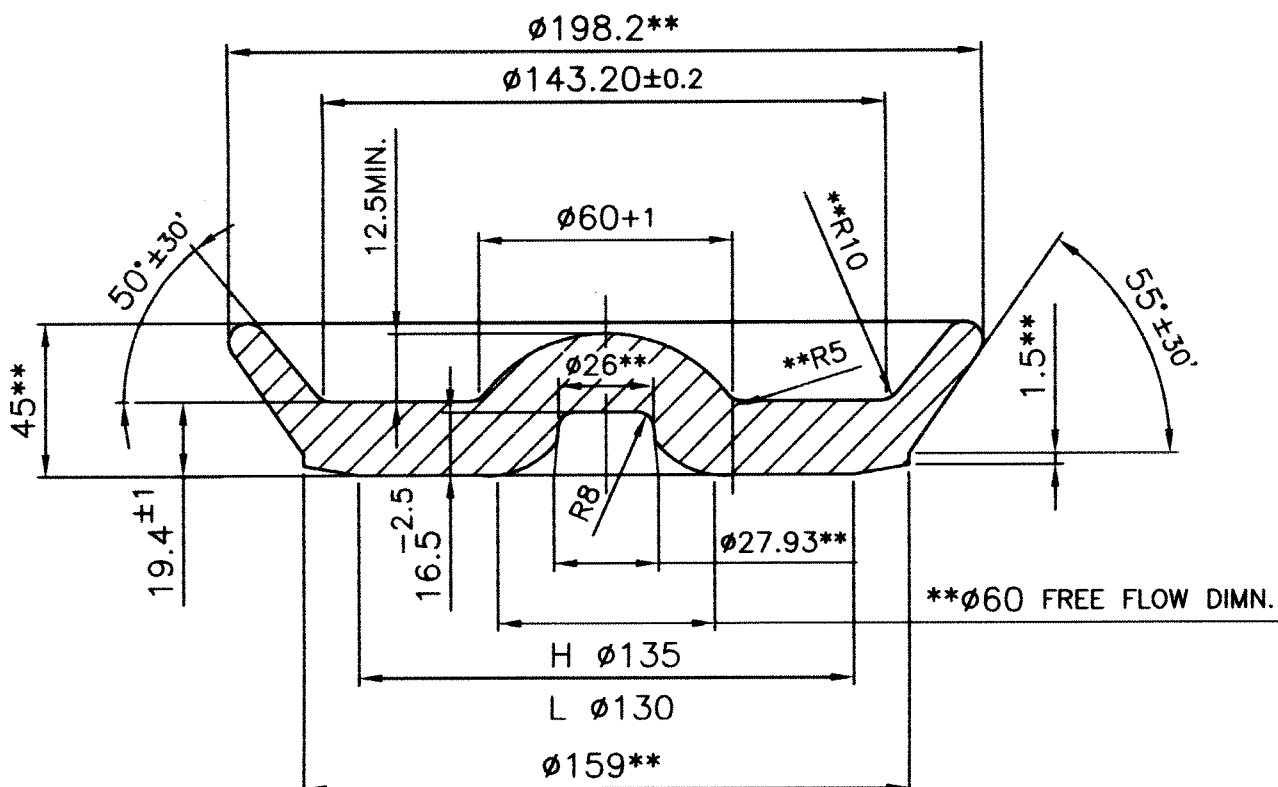


DRG. NO : CC-471 D

TOLERANCE ON UNTOLERATED DIMNS. ARE AS PER IS: 2102, MEDIUM CLASS



NOTE:

- 1) WALL THICKNESS VARIATION = 0.2 MAX.
- 2) DIMN. MARKED ** FOR REFERENCE ONLY.
- 3) WEIGHT - 4.67 ± 0.15 Kg.
- 4) HARDNESS AFTER ANNEALING 95 TO 125 VPN (10 Kg LOAD)
- 5) MATERIAL SHOULD BE HANDLED CAREFULLY ENSURING THERE SHOULD NOT BE ANY DASH/SCRATCH MARK ON EITHER SURFACE OF BLANK
- 6) MATERIAL TO BE CLEANED AFTER ANNEALING.
- 7) SUITABLE PROTECTIVE COATING TO BE APPLIED WITH PROPER CLEANING (FREE FROM SCALE) TO AVOID RUSTING AND CORROSION DURING TRANSPORT AND STORAGE

DIMENSIONS ARE IN mm			MATERIAL : AS PER SHEET NO. 2&3		ORDNANCE FACTORY AMBAJHARI
THIRD ANGLE PROJECTION					
SCALE : 1 : 2			NOMENCLATURE :		DRG. NO :
2003	NAME	DATE	PRE CUP BLANK (ANNEALED)		CC-471 D
REDRAWN	Vase	26/7/12			
CHECKED	pk	26.07.12			
JWM/CDD	lll	26/07/12			
APPROV.:	AWM/CCS	N. - 10	MACHINE :	SHEET NO : 1	
	JGM/CCS	26/7/12	STORE : 125mm SCCC	NO. OF SHEETS : 3	
					OPERATION NO :
					COMPT. : BASE
					3-026892 4Ж40

MATERIAL DETAILS :-

BLANKS ARE TO BE PUNCHED/MACHINED OUT FROM ROLLED STRIPS, MANUFACTURED FROM HIGH GRADE MILD KILLED STEEL OF GRADE 11 10 A TO SPECIFICATION GOST B 19032-73, DEOXIDIZED BY ALUMINIUM WITH FOLLOWING CHEMICAL COMPOSITION. (ESR QUALITY PREFERABLE)

C%	Mn%	Si%	P%	S%	Cr%	Ni%	Cu%	Al%
0.10-0.12	0.30-0.50	NOT MORE THAN						0.03-0.09
		0.13	0.025	0.025	0.20	0.15	0.20	

NITROGEN CONTENT 70 PPM MAX.

APART FROM ABOVE FOLLOWING SPECIFICATION MAY BE REFERRED TO RELEVANT TEST / REQUIREMENT

1. IMPACT STRENGTH AS PER GOST 9454-78, MECHANICAL TESTING AS PER GOST 7268-67 WITH DEFORMATIONS DUE TO COMPRESSION.
2. ULTRASONIC TESTING IS TO BE CARRIED OUT AS PER THE AMS 2630 CLASS A1.
3. CENTRAL POROSITIES AND SEGREGATION SHOULD NOT EXCEED APPENDIX-I OF GOST 19032-73.
4. MICRO STRUCTURE OF STEEL SHOULD CONSIST OF EQUIAXIAL FERRITE GRAINS AND UNIFORMLY ARRANGED GRANULAR OR SORBITIC PEARLITE WITH COMPLETE ABSENCE OF WIDMANSTATTEN PATTERN OF FERRITE.
5. THE STRIPNESS OF FERRITE PEARLITE STRUCTURE SHOULD NOT EXCEED NUMBER 2 AS PER GOST 5640-68, SCALE 3 ROW A.
6. MAXIMUM GRAIN SIZE 0.07mm AS PER SPECIFICATION NO.: GOST 5639-65
7. DEPTH OF COMPLETE DECURBURISATION IS NOT PERMITTED
8. FOR ALL OTHER CONDITIONS GOST B 19032-73 IS **PERTINENT**.

ORDNANCE FACTORY AMBAJHARI

2003	NAME	DATE	NOMENCLATURE :	DRG. NO :
REDRAWN	Vasu	26/7/12	PRE CUP BLANK (ANNEALED)	CC-471 D
CHECKED	[Signature]	26.07.12		SHEET NO : 2
JWM/CDD	[Signature]	26-07-12		NO. OF SHEETS : 3
APPVD.	AWM/CCS	[Signature]	MACHINE :	OPERATION NO :
	JGM/CCS	[Signature]	STORE : 125mm SCCC	COMPT. : BASE 3-026892 4 X 40

D 122/12	26/7/12	MATERIAL DETAIL & SHEET No. 2&3 ADDED AND NEW NEGATIVE MADE	<i>N. S.</i> AWM/CCS
C 123/09	25/5/09	AMENDED AS PER ACTUAL FREE FLOW OF MATERIAL, WEIGHT 4.67 ±0.15 KG WAS 4.4 (APPOX.) & NEW NEGATIVE MADE	Sd/- DGM/CCS
B 366/08	31/12/08	HARDNESS AFTER ANNEALING 95 TO 125VPN (10KG LOAD) WAS 95 TO 115 VPN	Sd/- WM/CCS
A 23/08	21/1/08	NOTE No. 4 TO 7 ADDED & NEW NEGATIVE MADE	Sd/- JGM/CCS
REV.	DATE	DESCRIPTION	SIGN

A M E N D M E N T S

ORDNANCE FACTORY AMBAJHARI

COMPILED BY : <i>Vasu</i> 26/7/12	PRE CUP BLANK (ANNEALED)	SPECN. NO.:	CC-471 D
CHECKED BY : <i>JS</i> 28-07-12		SHEET NO.:	3
JWM/CDD <i>JS</i> 26-07-12		NO.OF SHEETS :	3
APPROVED	STORE :	COMPT. BASE	3-026892 4X40
<i>N. S.</i> AWM/CCS	<i>JS</i> JGM/CCS	125mm SCCC	