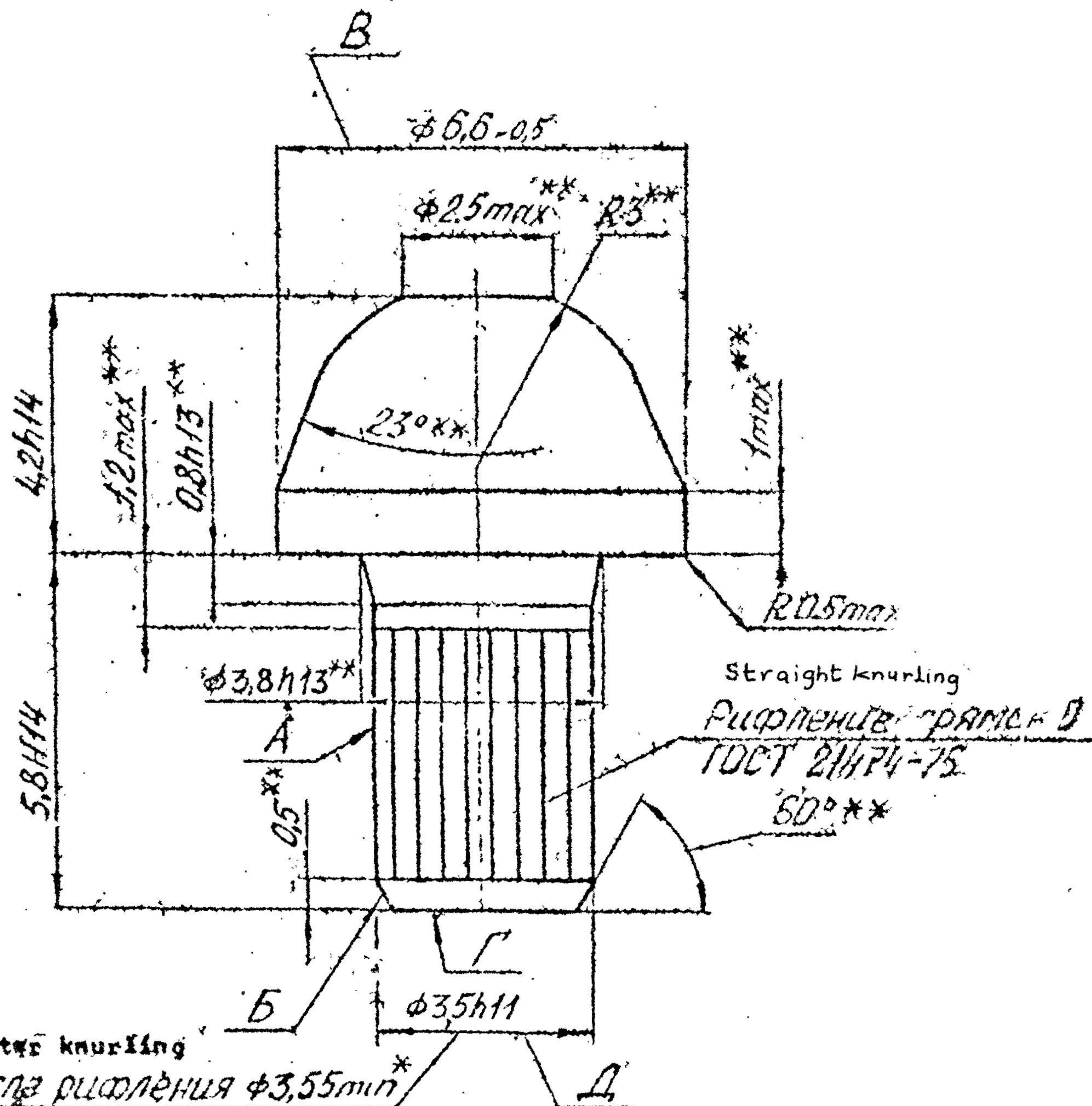


ЕСКД



1. Alternate material is strain hardened steel 20 GOST 1051-73 rounds 3,5 GOST 7417-75 annealed.
20 GOST 1051-73
2. *Dimensions are subjected to total checking.
3. **Dimensions ensured by tool.
4. Perform cylindrical surfaces once clamped only.
5. Coating should be in accordance with Table.
6. The following is allowed :
 - a) Local underfilling of metal at diameter B as against the standard sample established by manufacture and agreed with customer representative at manufacturing plant;
 - b) Cold cap of metal after knurling in the place of transition of surface A to surface B ;
 - c) Spalling of knurling-totally not exceeding 2 teeth ;
 - d) Seizure of ring gauge not exceeding 1.5 MM from surface A while checking the dimension A , after knurling ;
 - e) Laps and lines are allowed on the parts manufactured by cold extrusion as against the standard sample established by manufacture and agreed with customer representative at manufacturing plant.
7. Other requirements are as per OST B 84-264-81.
8. INDIGENOUS MATERIAL:-
IS: 1875 - 1992 REAFFIRMED GRADE 20 C8.

05-01-2011	DGOA SO Sec I Chap 10 para 40	Drg scan, clean & edit without change & m/c replaced in supersession of existing dilapidated copy of same No		
08-11-10	DCI 37271-A	INDIGENOUS MATERIAL ADDED AS NOTE NO 8.		
24-9-87	DCI 34241-A	DRG. PROV. SEALED.		
DATE	AUTHORITY	REVISION	SIG. AHSR.	SIG. D.O.

Обозначение по системе классификации	APPROVED
	KIRKEE
3-0136082	A3-BF-84

*Zinc 6 microns thick, chromated. The coating alloy Cu Zn (70%) 3. Sn3 or Cu3. Sn3 are allowed.

Обозначение Designation	Покрyтие Coating
БНЗ.633.050	03.Кд 9.хр Допускается покрытие Кд 15.хр
201	У6.хр. Допускается покрытие М-Ц(70)3.03 или М3.03.

--Sn3 cadmium 9 microns thick chromated. The coating cadmium 15 microns thick chromated is allowed.

SN/SH/DOC NO	SIGN	DATE
DRAWN		
EDT/CHKD		
F/M, DC		
DIV. OFFR		
NAME	SIGN	DATE

Head	Wire 3,5-20 GOST 5863-79,
ORDANCE PROJECT GENERAL	