

DA.No.004/20 Russian Matl. added on 23.07.20

CERTIFIED CORRECT COPY
OF APPROVED DRAWINGS
AT THIS DATE.....

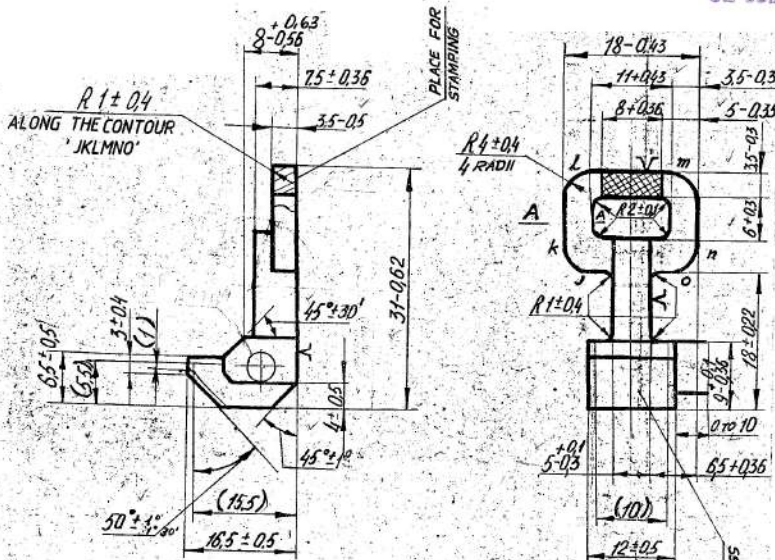
17.11.2020

Design & Drawing Office
Ordnance Factory,
Tiruchirappalli-620016

UN CONTROLLED COPY

Details to be marked on the Tag

Sl.No. of Tag
Batch no.
No. of compts. in the Batch
Insp. mark of mould check
Insp. mark of Component



- MATERIAL: STEEL 35XFCV. GAST 977-75
1. SURFACE ROUGHNESS OF CASTINGS AS PER CHECKING SPECIMEN.
 2. DRAFT ANGLE IS UP TO 1°.
 3. UNSPECIFIED CASTING RADII UP TO 1.6 mm.
 4. MISALIGNMENT ALONG PARTING PLANE UPTO 0.2mm.
 5. SINKAGE OF TRACES DUE TO EJECTOR IS PERMITTED UPTO 0.2mm.
 6. STAMP THE SL.NO. OF THE TAG ON WHICH THE DETAILS ARE MARKED
 7. SECTION A-A FOR MEASURING DEPTH OF DECARBURIZED LAYER.
 8. DIMENSIONS PROVIDED WITH THE TOOL
 9. PROFILE OF TEETH AS PER CHECKING SPECIMEN.
 10. DIMENSIONS IN () ARE FOR REFERENCE ONLY
 11. REFER ATTACHED SHEET FOR HEAT TREATMENT PROCESS- DRG-NO. M 882

MATERIAL FOR INDIA:- IS: 10343-1999 GRADE 16G
BS 5146 PT 1 1974 TYPE CLASS 12 GRADE 16G CASTINGS
RADIOGRAPHIC TEST AS PER ASTM E 192 WITH ACCEPTANCE STANDARD FOR GAS HOLE AND FOREIGN MATERIALS: LEVEL-5 SHRINKAGE (ALL TYPES) LEVEL-3 ALSO REFER CRACMET ICHAPUR INSPECTION INSTRUCTION NO. MRA-1/RA-1/12 DE-5-5-94 FOR OTHER DETAILS.

Hardness HB 241 max

NOTE: MACRO-ETCH TEST IS TO BE CARRIED OUT AS PER ASTM E 381 WITH ACCEPTANCE STANDARD AS C₂, R₂, S₂ MICROSCOPIC DETERMINATION OF NON-METALLIC INCLUSION RATING AS PER IS: 4163-80.

F DA.No.12/98 D/12.7mm Df. 30.11.98
MATL. FOR INDIA AMENDED
REF. DC.NO. 24/91 SA. DE. 23-10-98 S. Bat
30.11.98

G DA.No. 001/17 Dt. 01-03-17
DC.No. 23/90 dt. 01-5-12-18

VETTED FOR MATERIAL ONLY

Quality Assurance Officer,
Ordnance Factory,
Tiruchirappalli-620016

Principal Quality Assurance Officer,
Quality Assurance Unit,
Ordnance Factory,
Tiruchirappalli-620016

Sanjit Quality Assurance Officer,
Quality Assurance Unit,
Ordnance Factory,
Tiruchirappalli-620016

ARAD
SGAE(A)
TRICHY.

DA NO. 3 D/12.7mm Df. 12.5.98 MATL. FOR INDIA AMENDED REF. DC.NO. 24/91 SA. DE. 23-10-98	S. Bat 12.5.98
DA NO. 16 D/12.7mm Df. 16.9.95 GRADE 'A' TO GRADE 'B' Amended	S. Bat 16.9.95
DA NO. 4/95 D. 12.7mm DE. 4-3-95	S. Bat 4.3.95
AMENDMENTS	DESCRIPTION / DETAILS

DS.CAT. NO. 1005007177	TRIGGER
SHEETS : 1	1 ST ANGLE
SHEET No : 1	PROJECTION
DRAWN	CHECKED
V/C PROJ.	DIV OFFICER
CASTING DRG. 6P11-7-16	ORG. NO. : 62 C 7016 250 H3