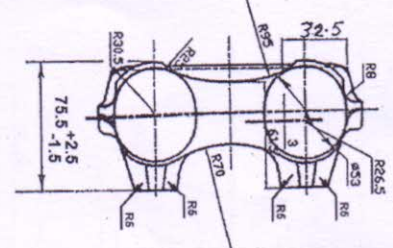


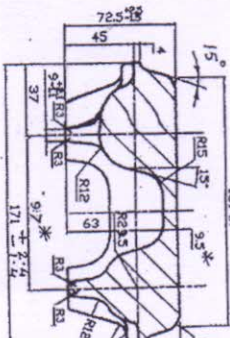
CERTIFIED CORRECT COPY
 OF APPROVED DRAWINGS
 AT THIS DATE 29.06.18.

Design & Drawing Office
 Ordnance Factory,
 Tiruchirappalli 620016



TECHNICAL REQUIREMENTS:

01. GROUP II, GOST 8479-70
02. PARAMETERS OF FORGING: 15M2C217 GOST 7505-89.
03. HARDNESS 179-269 HB & DIA. OF INDR. 3.7 TO 4.5MM
04. UNSPECIFIED DRAFT ANGLE 7°
05. UNSPECIFIED RABIT: -3.0MM
06. TOLERANCE OF TRANSVERSE SHIFT ALONG SURFACE OF PARTING LINE OF DIE
07. TOLERANCE OF LONGITUDINAL (END) SHIFT ALONG SURFACE OF PARTING LINE OF DIE 1.4 MM
08. PERMISSIBLE LIMIT VALUE OF RESIDUAL FIN 1.7 MM
09. PERMISSIBLE LIMIT HEIGHT OF BURRS ALONG CONTOUR OF CUTTING -5.0 MM
10. PERMISSIBLE LIMIT VALUE OF STAMPING BURR-2.0 MM
11. TOLERANCE OF FLATNESS AND CAVITURE 1.0 MM
12. DIMENSION OF FLATNESS AND CAVITURE NEED NOT TO BE CHECKED.
13. ON SECTION KNOWLING IS ALLOWED - 2.0 MM MAX.
14. ON SECTION 7/7, GRIPPER (CARBIDES) OF ANY DIMENSIONS ARE ALLOWED.
15. THE FOLLOWING LOCAL DEFECTS ARE ALLOWED ON UNMACHINED SURFACES WITHOUT RECTIFICATION: SCABS, NICKS, SCALES AND TOOL MARKS IN AN AREA NOT MORE THAN 30% OF THE SURFACE AND DEPTH NOT MORE THAN 1.0 MM. WRINKLES, CRIPS, LAPS AND ROLLING DEFECTS OF INPUT MATERIAL WITH DEPTH NOT MORE THAN 1.0 MM ANYWHERE IN THE AREA NOT LESS THAN 35 MM FROM THE FACES. FROM THE FACES WHEN THE HEIGHT OF ONE DEFECT IS NOT MORE THAN 5.0 MM/TOTAL NUMBER OF ALL SURFACE DEFECTS WITHOUT DRESSING SHOULD NOT BE MORE THAN TWO PER CORRESPONDING DIMENSION IS ALLOWED.
16. ON MACHINED SURFACES A FEW DEFECTS ARE ALLOWED WITHOUT RECTIFICATION, IF THEIR DEPTH AFTER DRESSING DOES NOT EXCEED 50% OF THE ACTUAL MACHINING ALLOWANCE.
17. DE-SCALING/SHOT BLASTED
18. METHOD OF MARKING OF SERIAL NO. OF THE BATCH BY STAMPING.
19. ACCEPTANCE STAMP ON ALL COMPONENTS.
20. EVERY BATCH QTY, & COMPONENTS TO BE LABELED WITH MARKING OF DRG. NO. AND BATCH NUMBER IDENTICALS.
21. * DIMENSIONS FOR REFERENCE
22. PAINT RED OXIDE.



MATERIAL: STEEL 30X6 GOST 9434-71

CHEMICAL COMPOSITION IN %
 C-0.034, Mn-0.42, Si-0.10, P-0.0035, S-0.0035

FORGING WT. 9.5 KGS

23. PLACE FOR HARDNESS TEST SURFACE OR OPPOSITE, HARDNESS TO BE CHECKED ON SAMPLE AFTER HEAT TREATMENT.

J. G. METI
 AVM/DD

ING. NO./OFF. MATL.	DESCRIPTION
LIST OF PARTS	STORE DRG. NO. 172.55.012/F
COMP.:	
DATE: - 20-4-85	FORGING DRG. FOR TA. LINK
SCALE	DRG. NO. OF M 32851
DRAWN PKRAD	M/C
TRCD	D.F. MURADNAGAR SHT. NO.1
CHKD.	