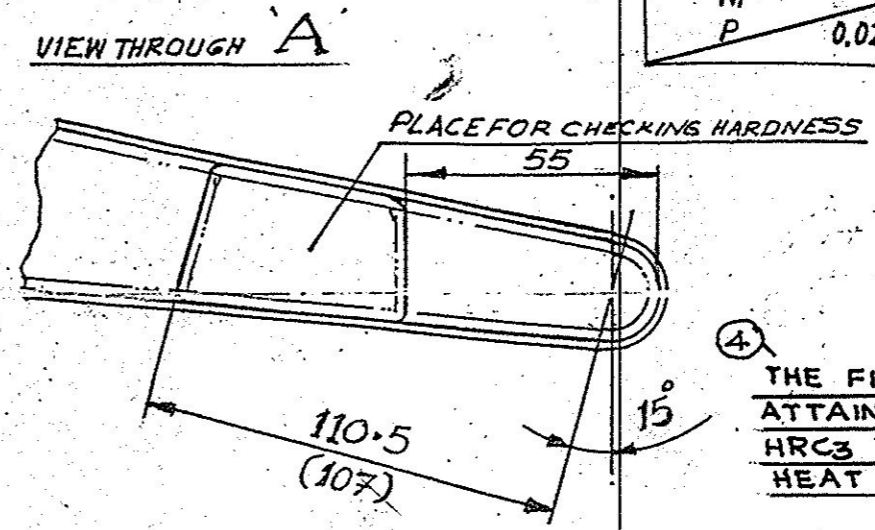
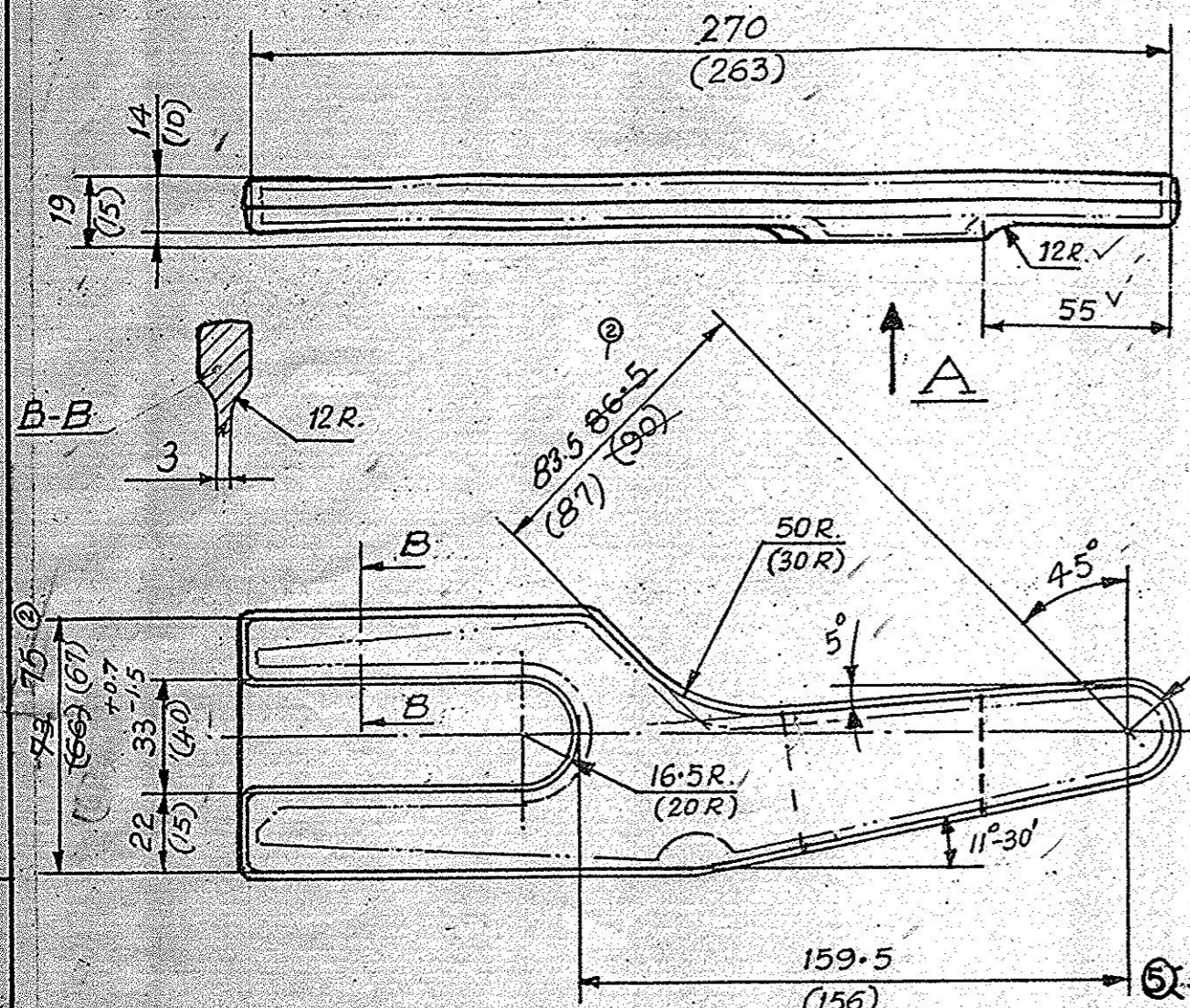


FORGING DRAWING

CHEMICAL COMPOSITION OF THE MATERIAL :- 30X1CA

C	0.28 - 0.34	Si	0.90 - 1.2
Mn	0.30 - 1.10	Cr	0.80 - 1.1
Ni	0.30 MAX.	S	0.025 MAX.
P	0.025 MAX.	Cu	0.30 MAX.



④ THE FINISHED COMPONENT SHOULD ATTAIN A HARDNESS RANGE OF HRC3 34 TO 40.5 AFTER FINAL HEAT TREATMENT

HEAT TREATMENT PROCESS CHART

NOMENCLATURE AND IDT. NO.	STEEL GRADE	TYPE OF OPERATION	EQUIPMENT	TEMP. IN °C	TIME	COOLING MEDIUM	FIXTURE	HARDNESS INSPN. %
⑤ FEED LEVER C 5015	30X1CA	ANNEALING HEATING	ELECTRIC CHAMBER FURNACE	840-860	3 HRS.	WITH FURNACE UP TO 550°C THEN IN AIR	ON TRAY	3%; BUT NOT LESS THAN 3 PIECES.

1. DRESSING OF PLACES FOR CHECKING HARDNESS.
2. CHECKING OF HARDNESS.

④ INDIGENOUS MATERIAL :- ~~BS 970 PL-1-83 Gde 720 M 32 IN V COND. (OR) IS 5517-93~~
 ⑤ Gde 42 C/4 M03 LRS 30
 INDIGENOUS MATERIAL: IS 4367-91 DESIGNATION 35 MN 6 M03 M' OR IS 5517-93 35 MN 6 M03 M'
 LRS 30 mm AUTHORITY: CQA(METALS) ICHAPUR, LY. NO. MQA-3/TS/BIL DE. 6/11-6-97

- NOTES :-
- DIMENSIONS ARE IN mm.
 - SCALE :- 1:2
 - FIRST ANGLE PROJECTION.
 - HEAT-TREATMENT :- ANNEALING; HARDNESS HB 229 MAX.
 - DESCALING :- PICKLING
 - DISPLACEMENT IN THE PARTING PLANE SHOULD NOT EXCEED 0.5 mm.
 - REMAINDER OF FLASH ON DIE PARTING LINE SHOULD NOT EXCEED 0.8 mm.
 - ROD CURVATURE SHOULD NOT EXCEED 12 mm.
 - SURFACE DEFECTS SHOULD NOT EXCEED 0.5 mm IN DEPTH.
 - DRAFT ANGLE 7°.
 - UNSPECIFIED RADII 2.0 mm.
 - ALLOWANCES AS PER CLASS II GOST 7505-74
 - TOLERANCES AS PER CLASS II GOST 7505-74 AND AS FOLLOWS
 VERTICAL: $\begin{matrix} +0.15 \\ -0.12 \end{matrix}$
 HORIZONTAL: $\begin{matrix} +0.20 \\ -0.12 \end{matrix}$
 DIE FORGING BY HAMMER.

- NUMBER OF PARTS OBTAINED FROM ONE FORGING : 1 PIECE.
- DIMENSIONS GIVEN IN BRACKETS ARE FOR MACHINING
- WEIGHT OF THE FORGING 1600 Kgs.
- RAW MATERIAL SIZE :- ~~400-500 x 180~~ LONG (HOT ROLLED) $\phi 36^{+0.4}_{-0.7} \times 300$
- MATERIAL :- 30X1CA; OST 3-98-88
- MARKING OF CONVENTIONAL BLACKSMITH'S STAMP: LETTERING П0 5-8. GOST 2930-62

⑥ TEST SAMPLES SHALL BE SEPARATELY HEAT TREATED & TESTED TO LRS. 30mm.
 AUTHY: CQAW Ly. No. 40218 - CQAW (QA-6)
 Dt. 19-12-97.

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

17.11.2020
 Design & Drawing Office
 Ordnance Factory,
 Tiruchirappalli-620016

UN CONTROLLED COPY

⑥	DA. NO. 006/98 Dt. 24-4-98	
E ⑤	DANO. 052/97 Dt. 11/11/97	
UPDATED.	DA. NO. 22/97 Dt. 23/1/97	22-3-97
D ④	DA. NO. 058/96 Dt. 27/6/96	27/6/96
C ③	DA. NO. 026/95 Dt. 13-4-95	13-4-95
B ②	DA. NO. 58/92 Dt. 28-10-92 DIM. 83.5 WAS 86.5	
①	STORE DRG. NO ADDED	Mar 25/99
SL. NO.	AMENDMENTS.	SK & DATE

VETTED FOR MATERIAL ONLY AS PER LAST DC (I) N. LETTERED
 MQA-3/TS/BIL dt. 6/11-6-97
 CMRV JAGADISH
 Sr. Scientific Officer
 Sr. Quality Assurance Estt (Asst)
 Tiruchi appalli-620016.

FOR COMPONENT NO 2A42-05-015 -FEED LEVER ①
 DRG NO 64 C 5015 200 B3 ⑤

Sadhi	Retirama	6/88		23/6/88
REDRAWN	CHECKED	APPROVED	I/C. PROJ.	WM/PROJ.

ORDNANCE FACTORY
 TIRUCHIRAPALLI-16