

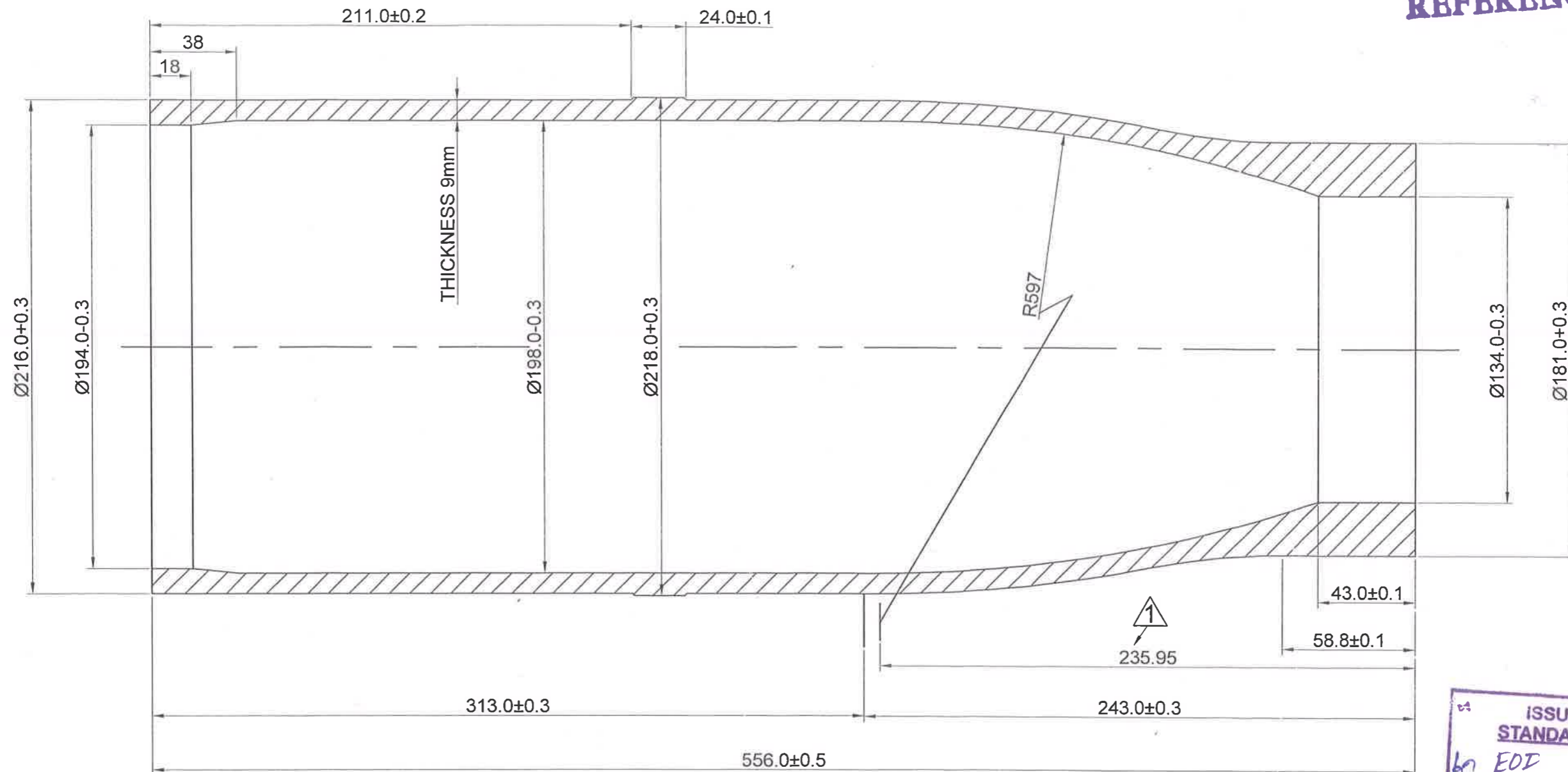
DRG NO:

REV

O ROC 060 1 230

1

REFERENCE



ISSUED BY  
STANDARD  
for EOD  
DATE: 09/10/12

NOTE:

OD/ID CONCENTRICITY SHOULD BE MAINTAINED WITHIN 0.3mm

1. MATERIAL: STEEL SPECN ASTM 106 Gr 'B'

CHEMICAL COMPOSITION:-

C - 0.3Max, Cr - 0.4Max, Cu - 0.4Max, Mn - 0.29 - 1.06, Ni - 0.4Max, P - 0.035Max, S - 0.035Max, Si - 0.1Max  
Mo -0.15 Max & V - 0.08 Max.

2. UNIFORM WALL THICKNESS TO BE MAINTAINED

3. ALL COMPONENTS SHOULD BE TESTED 100% FOR NDT  
(ULTRASONIC TEST )

4. COMPONENT SHOULD BE FREE FROM CRACKS & DENT MARKS

5. MECHANICAL & HARDNESS PROPERTIES TO BE TESTED  
AS PER SPECIFICATION & MONITORING INSTRUCTION

REMOVE ALL SHARP EDGES  
ALL DIMENSIONS ARE IN mm

MATERIAL		REF.DRG NO.	
SEE NOTE		DRAWN	<i>[Signature]</i>
HEAT TREAT/GROUND	1 Radiography test removed; material chemical amended (NAI VETTING). R597 centre distance added	CHECK USER SEC.	<i>[Signature]</i>
SEE NOTE	REV	DATE	4-5-15
HARDNESS	TITLE : SUPPLY OF HR BODY (PRE MACHINED) (RGB-60)		CHECK HOS/DDO
SEE NOTE	HEAVY ALLOY PENETRATOR PROJECT		APPRD. <i>[Signature]</i>
SUR. FINISH/COAT	TIRUCHIRAPALLI		DATE 11-12-12
SEE NOTE	EST.MASS	PRO/FINAL	SCALE NTS
	28.5±0.5Kg.		DRG. NO: O ROC 060 1 230
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