



NOTE :

- 1) PARTING OF BILLETS ARE TO BE GOVERNED BY THE WEIGHT AND NOT BY LENGTH. LENGTH AS MENTIONED IS FOR GUIDANCE ONLY.
- 2) 75-80mm WITH "BLACK" COLOUR BAND IS TO BE PAINTED THROUGHOUT THE LENGTH AND PARTED FACE OF EACH PARTED BILLET ON ONE SIDE.
- 3) HEAT /CAST NO. ALSO TO BE PAINTED WITH SAME COLOUR ON ANY PARTED FACE OF EACH PARTED BILLET.
- 4) ENDS OF EACH PARTED BILLET ARE TO BE SAW CUT & DEBRRED. PLASMA CUT IS NOT ALLOWED.
- 5) PACKING/ PALLETISATION OF PARTED BILLETS SHOULD BE SECURED BY STEEL STRAP TO FACILITATE EASY LOADING/ UNLOADING. PACKING IS TO BE DONE HEAT/CAST WISE WITH STEEL TAG MENTIONING STEEL GRAD, HEAT NO, QUANTITY AND FIRM NAME
- 6) MATERIAL : HOT WROUGHT STEEL AS PER ASTM A322 GRADE 4140. VACUUM DEGAUSSED. ALUMINIUM KILLED. FINE GRAIN STEEL. FREE OF SEGREGATION AND POROSITY CARBON: 0.40% MIN.-0.43% MAX. THE QUALITY AND CLEANLNESS ACCORDING TO ASTM E381 GRADED SERIES ONLY.S2,R1,C2 MAX. BENDING TEST 180° (AS PER ASTM A675) 100% MAGNETIC PARTICLE INSPECTION REQUIRED. TEST CERTIFICATE REQUIRED.

WEIGHT = 72.2 +1.0 kg

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 यह प्रति सी.डी.डी./ऑ. ए. के. के.
 द्वारा दी जा रही है।
 दिनांक: 24/05/2018
 Date: 24/05/2018
 क.का.प्र./सी.डी.डी.
JVM/CDD

AMENDMENTS		REV.	DATE	NOMENCLATURE	SIGN.
APPROVED					
DIMENSIONS ARE IN mm		APPV	HOS/SF	DATE	21.5.18
THIRD ANGLE PROJECTION		WM/SF			
SCALE : 1 : 1					
2018	NAME	DATE			
DRAWN		18.5.18			
CHECKED		18.05/18			
HOS/CDD		18.5.18			
JVM/SF		21.5.18			
MATERIAL: SAE 4140					
NOMENCLATURE: PARTED BILLET					
ORDNANCE FACTORY AMBAJHARI					
आर्जना कारखाना अम्बाजारी					
DRG. NO: F-632					
SHEET NO: 1					
NO. OF SHEETS: 1					
COMPT: 155mm IMI					