

DIMENSIONS ARE IN mm.

UNTOLERATED DIMNS. AS PER IS : 2102 (MED)

MATERIAL : OWHDMA-0-90. (GOST B 5192-78) (DR) BS: 970, PART-1, 1983 - 817M40
HARDNESS: 24 - 32 HRC

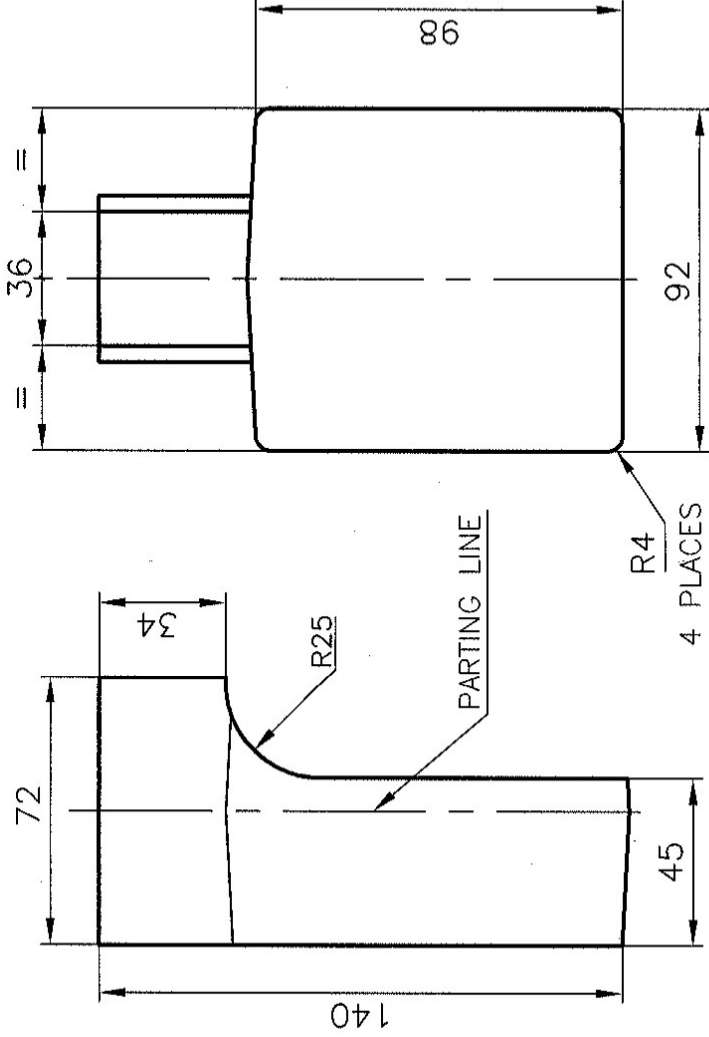
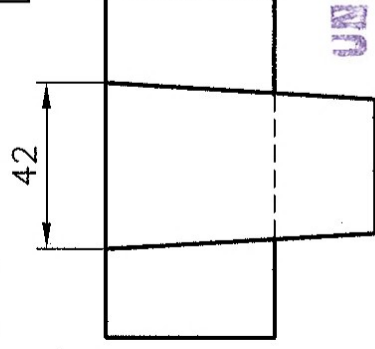
**CERTIFIED CORRECT COPY
OF APPROVED DRAWINGS
AT THIS DATE.....**

17.11.2020

Design & Drawing Office
Ordnance Factory,
Tiruchirappalli-620016

PROVISIONAL


UN CONTROLLED COPY



NOTE:

1. DRAFT ANGLE - 3°
2. NON SPECIFIED RADII - 2mm
3. FORGING ARE TO BE SUPPLIED IN ANNEALED CONDITION
4. THE REMAINDER OF THE BURR ON THE JOINT SHOULD NOT EXCEED 0.9mm
5. END BURR SHOULD NOT EXCEED 5mm
6. FORGINGS SHALL CONFIRM TO AS PER IS: 3469 - 1974
7. FORGINGS SHOULD BE SUPPLIED IN SHOT BLAST CONDITION.
8. FORGINGS SHOULD BE FREE FROM DEFECTS SUCH AS DEEP PIT MARK, LAPS, CRACKS, DENTS SCALE AND ANY OTHER FORGING DEFECTS.

HOS/PS-5

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
	SIGNATURE & DATE.	SUB: FORGING FOR PRE MACHINING			
TRACED		FOR: REAR CROSS			
DRAWN		OF : 40mm MGL			
CHECKED		DES. REF. NO.			
HOS/D&DO		DRG. 30C 3011 002 A4			
NOVAL OFFICER FOR MGL.		No.:			
OFFICER/D&DO		 ORDNANCE FACTORY TIRUCHIRAPPALLI-16.			
AMENDMENTS	SIG. & DATE	APPROVED ON. 28/12/18			
		SCALE: NTS			
		STORE DRG. NO. 30P 3011			
		OPERATION NO.			
		SHEETS: 1			
		SHEET No.: 1			