VETTED FOR MATERIAL ONLY

AQAD SQAE(A) TRICHY

Technical Supplies Officer, Quality Assurance Officer, Senior Quality Assurance Officer, Quality Assurance Estt. (Army), Tiruchirapalli - 620 016.

CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE..... 17.11.2020
Design & Drawing Office, Ordnance Factory, Tiruchirappalli-620016

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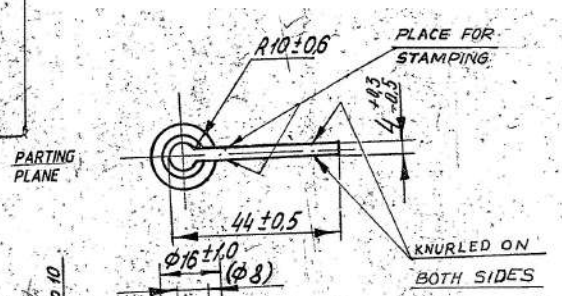
MATERIAL COMPOSITION (1)

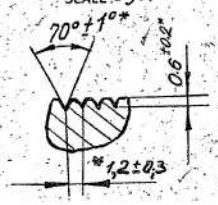
a) CHEMICAL COMPOSITION CONFORMING TO OEM MATERIAL GRADE STEEL 35ХГСЛ OF GOST 977-75 TO BE USED TO ACHIEVE SPECIFIED MECHANICAL PROPERTIES OF OEM OR IS:10343-1999 GRADE 16-Q.

b) MATERIAL COMPOSITION TO BE FOLLOWED IS AS UNDER :-

%C	%Mn	%Si	%Cr	%Ni	%Cu	%P	%S
0.30	1.00	0.60	0.60	0.30	0.30	0.040	0.040
0.40	1.30	0.80	0.90	max	max	max	max



PROFILE OF KNURLING
SCALE:- 5:1



(H)

MATERIAL :- STEEL 35ХГСЛ GOST 977-75
TECHNICAL REQUIREMENTS ARE AS PER TY-63-65-88.
CHEMICAL COMPOSITION IS AS PER GOST 977-75.

MATERIAL FOR INDIA:-
BS 3146 PT.1 1974 TYPE CLA. 12 GRADE 'B'
OTHER TECH. DETAILS ARE AS PER CQA(MET)
INSPN. INST. No. MQA-1/QA-1/12 -DT. 5.5.94

HARDNESS HB 241 MAX.

1. SURFACE ROUGHNESS OF CASTINGS AS PER CHECKING SPECIMEN
2. DRAFT ANGLE IS UP TO 1°.
3. UNSPECIFIED CASTING RADII UP TO 1mm.
4. MISALIGNMENT ALONG PARTING PLANE UPTO 0.2mm.
5. SINKAGE OF TRACES DUE TO EJECTOR IS PERMITTED UPTO 0.2mm. ON WORKING SURFACES.
6. STAMP THE SL. NO. OF TAG ON WHICH THE DETAILS ARE MARKED. STAMP INSPECTION MARK.
7. SECTION A-A FOR MEASURING DEPTH OF DECARBURIZED LAYER.

Details to be marked on the Tag
Sl.no. of Tag
Batch no.
No. of comp. in the Batch
Insp. mark of mould check

MATERIAL FOR INDIA:- 15:10343 GRADE 16Q

(G) ~~BS 3146 PT.1 '74 TYPE CLA.12 GR.'A' TO GR.'B' CASTINGS.~~

RADIOGRAPHIC TEST AS PER ASTM-E-192 WITH ACCEPTANCE STANDARDS FOR GAS HOLE AND FOREIGN MATERIAL:- LEVEL-5 SHRINKAGE (ALL TYPES) LEVEL-3, ALSO REFER CQA(MET) ICHAPUR INSPECTION INSTRUCTION NO. MQA-1/QA-3/12 DT. 5-5-94 FOR OTHER DETAILS.

*8. DIMENSIONS FOR TOOL
*9. DIMENSIONS PROVIDED WITH DIE.
10. PROFILE OF TEETH AS PER CHECKING SPECIMEN.
11. REFER ATTACHED SHEET FOR HEAT TREATMENT PROCESS. DRG. NO: M 882

H	DA.NO. 001/19 ; Dt.: 25/4/19. COST MATL. ADDED REF:- CQAM/QA1/12-7/V-1 ; Dt. 04/04/19		
G	DA.No. 001/17 Dt. 01-08-17 METL. AMENDED		
F	DA. 12/98 D/12-7mm Dt. 30-11-98 MATL. FOR INDIA AMENDED DC.NO. 24192-SA - DC. 24-10-98	S. Rajiv 30-11-98	
E	MATL. FOR INDIA AMENDED 24097-SA Dt. 5-5-98 DA. No. 8/98 D/12-7mm Dt. 16-6-98	S. Rajiv 16-6-98	
D	DA. NO. 4/95 D/12-7mm Dt. 4-3-95	S. Rajiv 4-3-95	
C	MATL. FOR INDIA ADDED	12-12-91	
B	DA. No. 20/90 & 19-3 AMENDMENTS	13-9-90 SIG. & DATE	
13	DA.No. 001/20 AS PER DC.No: 27193-SA, Dt. 08.04.19 amended on 22.02.20		

DS.CAT No. 1005007444				HANDLE CATCH FRICTION.	
SHEETS : 1	1ST ANGLE PROJECTION	DRAWN	I/C PROJ.	CASTING DRG. 6P11-6-25	H
SHEET No : 1					
ALL DIMENSIONS ARE IN mm.	SCALE : 1:1	CHECKED 5/5/94	DIV. OFFICER	DRG. NO.: 62 C 6025 250 I 3	