



① MATERIAL COMPOSITION

a) CHEMICAL COMPOSITION CONFORMING TO OEM MATERIAL GRADE STEEL 35X7C1 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

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

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

UN CONTROLLED COPY

17.11.2020

Design & Drawing Office
Ordnance Factory,
Truichiroppalli-620016

HARDNESS MB 241 MAX.

MATERIAL FOR INDIA: IS:10343-1999 GRADE 16Q
~~B.S. 2146 PT. 1 TYPE CLA-12 OR A TO OR B CASTING~~

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

② MATERIAL: - STEEL 35X7C1 GOST 977-75
TECHNICAL REQUIREMENTS FOR CASTINGS ARE AS PER TY B3-65-88 Pt. 2. CHEMICAL COMP. AS PER GOST 977-75

1. SURFACE ROUGHNESS OF CASTINGS AS PER STANDARD.
2. DRAFT ANGLE IS UPTO 1°.
3. UNSPECIFIED CASTING RADII UPTO 1 mm.
4. MISALIGNMENT ALONG PARTING PLANE UPTO 02 mm.
5. SINKAGE OF TRACES DUE TO EJECTOR IS PERMITTED UPTO 0.2 mm.
6. STAMP THE SL.NO. OF THE TAG ON WHICH THE DETAILS ARE MARKED. STAMP INSPECTION MARK
7. SECTION A-A FOR MEASURING DEPTH OF DECARBURISED LAYER.

8. ON SURFACES 'P&L' AND SECTION 'M&N', SINKAGE IS PERMITTED UP TO 0.5 mm.
9. REFER ATTACHED SHEET FOR HEAT TREATMENT PROCESS.

DRG No. 62C 2463 250 J3
DS. CAT NO. 1005007330

HOUSING EJECTOR

PLACE FOR STAMPING

PLACE FOR TESTING HARDNESS

① DA. No. 001/20 AS PER DC. NO. 27193-5A Dt. 08.04.19
ORIGINAL COPY ADDED Dt. 22.02.2020

I DA. No. 001/19 ; Dt. 25/4/19.
GOST MATL. ADDED
REF. CQAM/QA/112-7/V-1 ; Dt. 04/01/19
VETTED FOR MATERIAL ONLY

Principal Scientific Officer,
Quality Assurance Division,
For Senior Quality Assurance Officer,
Senior Quality Assurance Officer, (Special)
Truichiroppalli-620 016,
TRICHY.

H DA. No. 001/17 Dt. 01-03/17 Matl. Amended 30/11/98

G DA. 12/98. D/127mm 30-11-98
MATL. FOR INDIA AMENDED
REFDC NO. 24192 SA-24-10-98 S. Raju
30-11-98

F MATL. FOR INDIA AMENDED
24090-SA-DE-28-4-98
DA. No. 8/98 D/127mm
Dt. 16-6-98 S. Raju
16-6-98

E D. R. No. 4195 S. Raju
Dt. 12-2-99 Dt. 4-3-95

D DA. No. 66 S. Raju
Dt. 27-12-93 Dt. 27-12-93

C MATL. FOR INDIA ADDED
DA. No. 4/91 Dt. 14-3-91

B DA. No. 4/91 Dt. 14-3-91
AMENDMENTS SIG & DATE

ALL DIMENSIONS ARE IN mm.	1 st ANGLE PROJECTION	DRAWN	1/2 PROJ.	CASTING DRG. 6P/1- 2-63
SHEETS : 1	SCALE : 1:1	CHECKED	DIV. OFFICER	DRG. NO.: 62 C 2463 250 J3