



MATERIAL:-
 BS:3146 PT.1/1974 TYPE CLA 12 GRADE 'B'.
 OTHER TECHNICAL DETAILS ARE AS PER CQA(MET).
 INSPECTION INSTRUCTION No. MQA-1/QA-1/12 Dt. 05.05.94
 NON-STRESSED COMPT. GRADE 'B' CASTING.

ROUGHNESS OF CASTING SURFACES IS AS PER STANDARD.
 PATTERN DRAFT IS UPTO 1°
 UNSPECIFIED CASTING RADII ARE UPTO 1mm.
 MOULT SHIFT ALONG PARTING PLANE MAY BE UPTO 0.1mm.
 PUSHER MARKS UPTO 0.2mm. DEEP ARE ALLOWED.

HARDNESS:- HB 241 MAX.
 INTERNAL CORNERS = R 0.4mm.
 SHARP EDGES ARE TO BE BLUNT = 0.2mm.

MARK SERIAL No. OF TAG ON WHICH THE FOLLOWING
 DETAILS ARE MARKED:
 SERIAL No. OF TAG
 BATCH No.
 No. OF COMPONENTS IN THE BATCH.
 INSPN. MARK OF MOULD CHECK.
 INSPN. MARK OF COMPONENT.

SECTION X-X FOR MEASURING DEPTH OF CARBURISED LAYER.
 REFER ATTACHED SHEET FOR HEAT TREATMENT PROCESS
 DRG. No. M 882

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

VETTED FOR MATERIAL ONLY

 K.K. MURTHY
 LT COL.
 QUALITY ASSURANCE
 OFFICER
 SOAE(W), TIRUCHI-16

SHEETS: 1		1ST ANGLE PROJECTION		DRAWN		BRACKET FORESIGHT	
SHEET No:1		SCALE:		CHECKED		CASTING DRAWING	
ALL DIMNS. ARE IN mm.		1:1		S. Rajagopal		6P11 1-28	
				DIV.OFFICER		DRG.No. 62 C 1028 250 A 3	