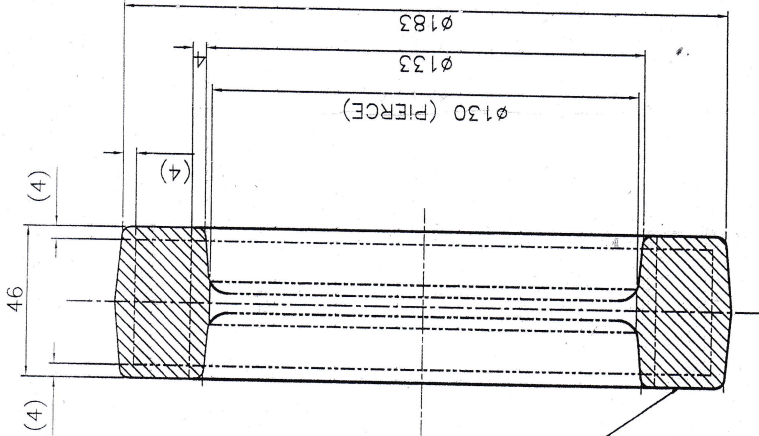


ALL DIMENSIONS ARE IN MM.



STAMP PART NO &
SUPPLIER CODE

TECHNICAL SERVICES SECTION
Jabalpur
CERTIFIED CORRECT COPY
30/06/2022
JWM/JMM-1

AMENDMENT 'A':- DETAILS FOR MICRO STRUCTURE, GRAIN SIZE & INCLUSION RATING ADDED.

FORGING WEIGHT :- 5 KG (APPROX)
NOTE: SAMPLE SHOULD BE APPROVED BEFORE BULK SUPPLY.

<p>NOTE:</p> <ol style="list-style-type: none"> FORGING RINGS TO BE TRIMMED CLEAN & SMOOTH FINISH ALL OVER. FORGING TO BE SHOT BLASTED & SUPPLIED AFTER APPLYING RED OXIDE PRIMER TO ISS 147-1B7Y BRUSHING OR SPRAYING. SAMPLE TO BE APPROVED BEFORE BULK SUPPLY. STEEL SHOULD BE FREE FROM CENTRE SEGREGATION, PIPING, FLAKES ETC. DIMS. IN BRACKETS INDICATE MACHINING ALLOWANCE. DRAFT ANGLE: INNER 7°, OUTER 5°. UNSPECIFIED RADII: CORNER -R, FILLET -R. UNSPECIFIED FACE & STOP FACE OR 1ST MACHINING OPERATION. 	<p>MATERIAL: C-45 IS-2004</p> <p>COMP. OF CLASS-4: C 0.4-0.50, Si 0.35MAX, Mn 0.60-0.90, S 0.04MAX, P 0.04MAX.</p> <p>HEAT TREATMENT: NORMALIZED HARDNESS: 150-210 BRN</p> <p>MICRO STRUCTURE: FINE FERRITE & PEARLITE</p> <p>GRAIN SIZE: ASTM 5 OR FINER</p> <p>INCLUSION RATING: 3 A B C D THIN OR IS 4163.</p> <p>FORGING TOLERANCE AS PER IS 3469-1974</p>	<p>KIND OF DIMS.</p> <p>LENGTH / DIA: +1.2 / -0.6</p> <p>THICKNESS: +0.6 / -0.5</p> <p>MISMATCH: 0.6</p> <p>STRAIGHTNESS: 0.6</p> <p>RESIDUAL FLAT: +0.7</p> <p>TRIMMED FLAT: -0.7</p> <p>ANGULAR: +2° / -1°</p> <p>RADI: +50% / -25%</p> <p>INTERNAL DIMS, REVERSE SIGN + & -</p>	<p>ALTERATION</p> <p>FORGING BLANK FOR SPACER (DOOR) FOR GUN PORT UPGRADED MPV 4X4</p>	<p>ALTERNATIVE NOTE</p> <p>2672-57-31</p>	<p>UPGRADED MPV</p> <p>4X4</p>	<p>DIR/ODC</p> <p>AD/ODC</p> <p>JWM/ODC</p>	<p>DRN</p> <p>CKD</p>	<p>SCALE</p> <p>1:1</p>	<p>REPLACED BY</p> <p>DATE</p>	<p>REPLACEMENT FOR</p> <p>DRG.NO. F-2672-57-31/A</p>	<p>1/1</p> <p>SHT.</p>

QTY./MTR = 02 NOS.

John