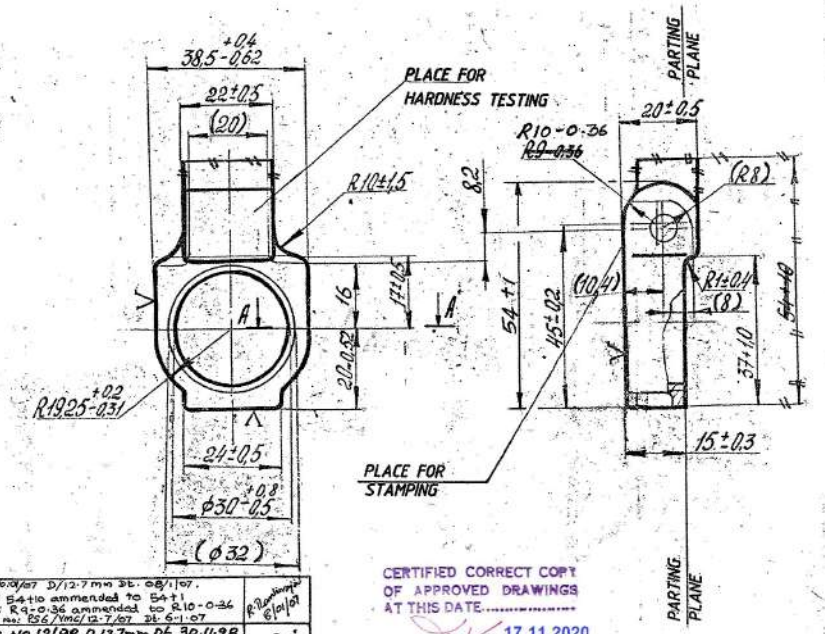
F	DA.No.001/17 Dt. 01.02.17 MATL. AMENDED.
G	GOST MATL. ADDED REF. CQAM/QA1/12.7/V-1/ Dt: 04/01/2019. DA.No. 001/19; Dt: 25/04/19
H	DA.No. 001/20 AS PER DC.No: 27193-SA, Dt. 08.04.19 amended on 22.02.20

MATERIAL : STEEL 35ХГСЛ GOST 977-75

(G) TECHNICAL REQUIREMENTS FOR CASTINGS ARE AS PER TY B3-65-88 GROUP 2. CHEMICAL COMPOSITION OF STEEL IS AS PER GOST 977-75

MATERIAL FOR INDIA :- IS: 10343-1999 GRADE 16Q ~~BS: 3146 PT-1: 74 TYPE CLA 12 Gr 'A' TO GR 'B' CASTINGS~~

(F) 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 DT. 5-5-94 FOR OTHER DETAILS.



MATERIAL COMPOSITION

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

1. SURFACE ROUGHNESS OF CASTINGS AS PER STANDARD.
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.
6. STAMP THE SL.NO. OF THE TAG ON WHICH THE DETAILS ARE MARKED.
7. SECTION A-A FOR MEASURING DEPTH OF DECARBURIZED LAYER.
8. REFER ATTACHED SHEET FOR HEAT TREATMENT PROCESS DRG. NO. MBB2
9. DIMS. IN ( ) ARE FOR REFERENCE ONLY.

HARDNESS HB. 241 MAX.

E	DA.No.01/07 D/12.7mm Dt. 08/1/07. Dim: 54±10 ammended to 54±1 Dim: R9-0.36 ammended to R10-0.36 REF. no: RS6/7MC/12.7/07 Dt. 5-1-07	R. Ramachandran 6/01/07
D	DA.NO.12/98 D.12.7mm DE. 30.11.98 MATL. FOR INDIA AMENDED REF. DC.NO.24192-SA.DE. 24.10.98	S. Raja 30-11-98

Details to be marked on the tag :

Sl.no. of Tag
Batch no.
No. of comp. in the Batch
Insp. mark of mould check
Insp. mark of Component

C	MATERIAL FOR INDIA. AMENDED 24074-SA-DE.6.4.98 DA.NO.8/98 D/12.7mm DE.16.6.98	S. Raja 16.6.98
B.	D.A.NO. 4195 D 12.7mm DE. 4.3.95	S. Raja 4.3.95
AMENDMENTS		DATE & SIGN.

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
26/04/19
AQAO SQAE(CA) TRICHY.
Principal Scientific Officer, Quality Assurance Officer, For Senior Quality Assurance Officer, Ordnance Factory, Trichy

D.S.CAT.No. 1005007179, 7180, 7181

BASE BRACKET FORESIGHT

SHEETS : 1	1ST ANGLE PROJECTION	DRAWN	I/C PROJ.	CASTING DRG. 6PII-1-5
SHEET No : 1				
ALL DIMENSIONS ARE IN mm.	SCALE : 1:1	CHECKED	DIV. OFFICER	DRG. NO.: 62 C 1005 250 H3