

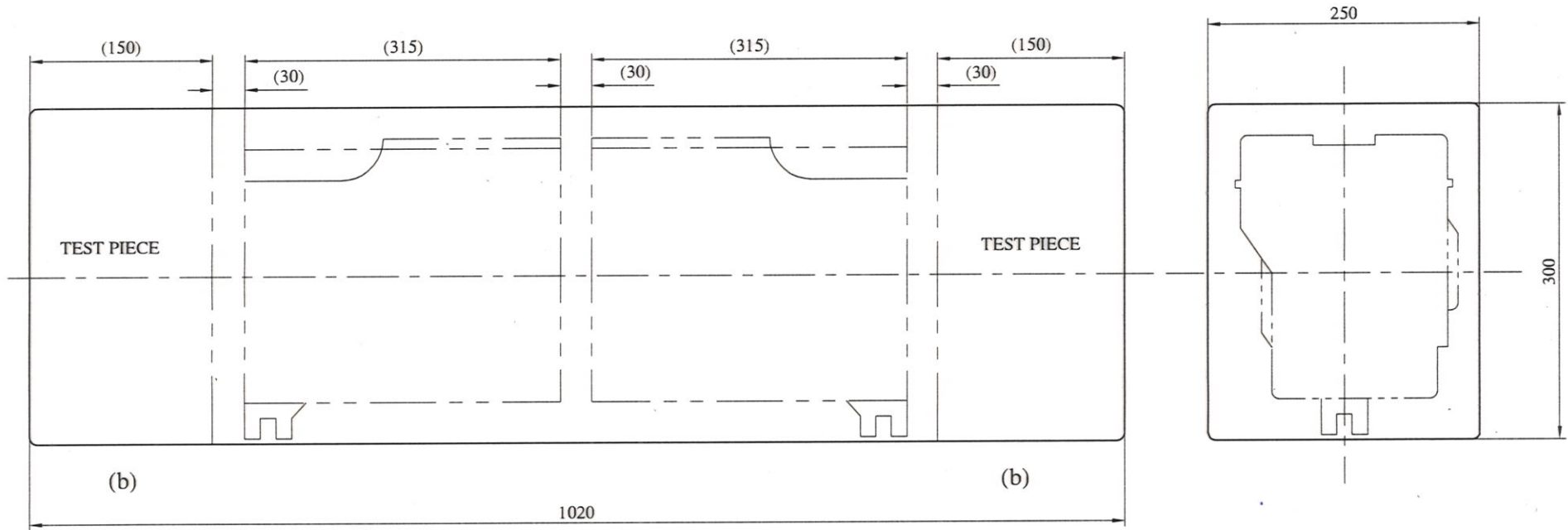
**NOTE**

1. INDIGENOUS MATL: IS: 5517-1993 DESIGN 40Ni6Cr4Mo2.
2. MANUFACTURE AND INSPECTION OF FORGINGS TO BE GOVERNED BY SPECN A 2002 & K 1100 READ IN CONJUNCTION WITH DEF-STAN10-13/1.
3. ONE FORGING TO MAKE TWO COMPONENTS ALONG WITH TEST PIECES AS SHOWN.
4. STORES TO BE SUPPLIED IN FORGED & ANNEALED CONDITION.

ALL DIMENSIONS ARE IN mm.

FOR EXPLANATION OF DIMENSIONS ETC. SEE CI ARM NOTE SHEET NO-1

D.A.NO 13/20 DATED 18/02/2020	(b) TEST PIECE SHOWN AT BOTH ENDS	SCHEDULE NO.		COMPT.: BREECH RING	ST. DRG. NO.:
		SCALE: N.T.S	PROJECTION FIRST ANGLE	40 mm L-70 GUN	1002378
D.A.NO 06/20 DATED 25/01/2020	(a) NOTE NO. 1-2 ADDED AS PER CQA/W/ JABALPUR. LETTER No. 2A1/003/CQA/W/ 40mmL-70/SP DATED 17/01/20.	DRAWN BY: <i>M. Paul</i> 18/02/2020		ROUGH FORGING DRAWING FOR BREECH RING	
		TRACED BY:			
DT. & SG.		DESCRIPTION	CONCURRED BY:	M/C:	NO. OF SHEETS: 2
AMENDMENTS		DATE: 12/2/20	SIGN: <i>[Signature]</i>	G & S FY. COSSIPORE	SHEET NO.: 1



**NOTE**

1. STORES TO BE SUPPLIED IN HEAT TREATED, ROUGH MACHINED & ULTRASONICALLY PASSED CONDITION (AFTER HEAT TREATMENT).
2. MECHANICAL PROPERTIES ARE TO BE ACHIEVED AS PER LRS 100.
3. ONE FORGING TO MAKE TWO COMPONENTS ALONG WITH TEST PIECES AS SHOWN.

ALL DIMENSIONS ARE IN mm.

FOR EXPLANATION OF DIMENSIONS ETC. SEE CI ARM NOTE SHEET NO-1

D.A. NO 13/20 DATED 18/02/2020	(b) TEST PIECE SHOWN AT BOTH ENDS	SCHEDULE NO.	COMPT. : BREECH RING	ST. DRG. NO. :
		SCALE: N.T.S	PROJECTION FIRST ANGLE	40 mm L-70 GUN
D.A. NO 06/20 DATED 25/01/2020	(a) NOTE NO. 1 ADDED AS PER COAWL JABALPUR, LETTER No. 2A/1003CQAW/ 40mmL-70/SP DATED 17/01/20.	DRAWN BY: <i>M. Paul</i>	FINISHED FORGING DRAWING FOR BREECH RING	
		TRACED BY:	DRG. NO.: F - 2332 B	
DT. & SG.	DESCRIPTION	CHECKED BY: <i>[Signature]</i>	NO. OF SHEETS: 2	
AMENDMENTS	DATE: 10/2/20	APPROVED BY: <i>[Signature]</i>	M/C:	SHEET NO.: 2
		SIGN: <i>[Signature]</i>	G & S FY. COSSIPORE	