

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.

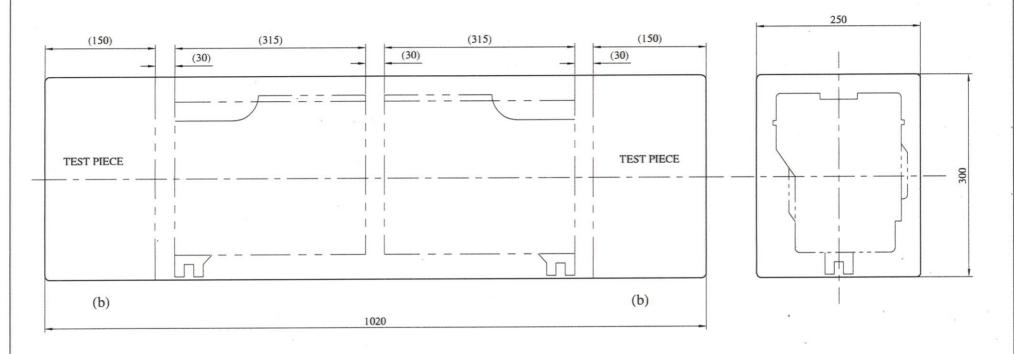
ALL DIMENSIONS ARE IN mm.

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

	SCHEDULE NO.		COMPT.: BREECH RING	ST. DRG. NO. :
(b) TEST PIECE SHOWN AT BOTH ENDS	SCALE: N.T.S	PROJECTION FIRST ANGLE	40 mm L-70 GUN	1002378
Al Bolli Labo	DRAWN BY: M. Paul 1202		ROUGH FORGING DRAWING FOR BREECH RING	
(a) D.A.NO 06/20 NOTE NO. 1-2 ADDED AS PER CQA(W), DATED JABALPUR. LETTER No. 2A 1,003/CQAW/ 40mml70/8P DATED 17/01/20.	TRACED BY:			
	CHECKED BY:		DRG. NO.: F - 2332 B	
	APPROVED BY: 48.2.20			
DESCRIPTION	CONCURRED BY:		M/C:	NO. OF SHEETS: 2
NDMENTS	DATE: 2 SIGN. OF DRAWING No. 4018545 I		G & S FY. COSSIPORE	SHEET NO.: 1
	TEST PIECE SHOWN AT BOTH ENDS (a) (b) (c) (c) (d) (d) (d) (e) (e) (e) (e) (e	(b) TEST PIECE SHOWN AT BOTH ENDS DRAWN BY: (a) NOTE NO. 1-2 ADDED AS PER CQAIW, JABALPUR LEITER NO. 2A1000/CQAW/ 40mml. 7008P DATED 17/01/20. DESCRIPTION CONCURRED B	(a) (a) (b) TEST PIECE SHOWN AT BOTH ENDS CALE: N.T.S PROJECTION FIRST ANGLE DRAWN BY: (a) NOTE NO. 1-2 ADDED AS PER CQAIW, JABALPUR LETTER NO. 2A1000/CQAW/ 40mml. 70/8P DATED 17/01/20. DESCRIPTION CONCURRED BY:	(a) TRACED BY: TRACED BY: CHECKED BY: APPROVED BY: APPROVED BY: DRG. NO.: F- DESCRIPTION CONCURRED BY: M/C: DESCRIPTION DRAWN BY: M BREECH RING BREECH RING 40 mm L-70 GUN ROUGH FORGING DR BREECH RING ROUGH FORGING DR BREECH RING BREECH RING APPROVED BY: DRG. NO.: F-

DRG. NO.: F - 2332 B

PROVISIONAL



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

		SCHEDULE NO.		COMPT.: BREECH RING	ST. DRG. NO. :
DANO 13/20 DATED 18/02/2020 (b) TEST MECE SHOW AT BOTH ENDS	TEST PIECE SHOWN	SCALE: N.T.S	PROJECTION FIRST ANGLE	40 mm L-70 GUN	1002378
		DRAWN BY: M. Paul 202		FINISHED FORGING DRAWING FOR	
D.A.NO 06/20 ADDED AS FER CQA(W). DATED JABALPUR. LETTER No. 2A 1/003/CQAW/. 40mmL-709F DATED 17/01/20.	TRACED BY:		BREECH RIN	NG	
	JABALPUR, LETTER No. 2A1/003/CQAW/	CHECKED BY:		DRG. NO.: F - 2332 B	
		APPROVED BY: 18.2.20		, DRG. No 1	2332 B
DT. & SG.	DESCRIPTION	CONCURRED BY:		M/C:	NO. OF SHEETS: 2
AMENDMENTS		DATE: 0 2/20	SIGN.	G & S FY. COSSIPORE	SHEET NO.: 2
רא מת	MAN AC DED D	OF DO A WING	MA ANTOCACT	DO NO 107/4 W/ DATED OF	12 2010