

QUALITY MONITORING INSTRUCTION FOR INSPECTION		Issue No : 01
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C 2016 (COMPENSATOR)		Date of Issue / / 2021
		OFT/MI/30mm/C 2016
Rev.No	Amendment	Date

MATERIAL SPECIFICATION : Sheet 5-1, GOST 19904-74 / 4-III-50, GOST-16523-70
 INDIGENOUS MATERIAL : BS 1449 PT.1 1983 SEC.4 GRADE. CS 60 (OR)
 : IS:2507-1975 Grade 2, DESIGN 55C6.
 CONDITION OF SUPPLY : FULL FINISHED WITH FIRM'S MATERIAL.
 END USE : 30mm CANNON.

INSPECTION CHECK TO BE CARRIED OUT


Table 'A'

SL NO	CHARACTERISTICS	SPECIFICATION / REQUIREMENT	SAMPLE SIZE
1.	Visual	The Component shall be free from defects such as rust, scale, burrs and any other harmful defects.	100%
2.	Dimension	100% Dimension to check as per drawing.	
3.	Chemical Composition (%)	<u>B-3, GOST 19904-74 / 4-III-50, GOST-16523-70</u> <u>(Refer GOST 1050-74)</u> C = 0.47-0.55 Cu = 0.25(Max) Mn = 0.50-0.80 S = 0.035(Max) Si = 0.17-0.37 P = 0.030(Max) Cr = 0.25(Max) Ni = 0.25(Max)	One Sample Per Heat
		<u>BS 1449 PT.1 1983 SEC.4 GRADE. CS 60</u> C = 0.55-0.65 S = 0.045 (Max) Si = 0.05-0.35 P = 0.045 (Max) Mn = 0.50-0.90	
		<u>IS 2507:1975 Design. 55C6</u> C = 0.50-0.60 S = 0.050 (Max) Si = 0.10-0.35 P = 0.050 (Max) Mn = 0.50-0.65	
(Permissible variations in value as per specification standard)			

4.	Mechanical Properties	<u>B-3, GOST 19904-74 / 4-III-50, GOST-16523-70</u> Tensile Strength 55-73 Kgf/mm ² Relative Elongation 13% (Min)	One Sample Per Heat
		<u>BS 1449 PT.1 1983 SEC.4 GRADE. CS 60</u> Hardness 280-530 HV (Max)	
		<u>IS 2507:1975, Gr.1 Design. 55C6</u> Tensile Strength 1180-1420 N/mm ² Yield Stress 1030 N/mm ² (Min) Elongation 6% (Min.) Hardness 350-425HV.	
5.	Other Tests	Decarburization Test, Bend Test are carried out as per material specification standards.	
6.	Hardness	38.5-45.5 HRC (as per drawing)	
7.	Protective Finish	Accelerated electroless phosphating as per JSS: 0465-01-1988 with Oiling.	
8.	Packing	The Packing of the Material shall be done in such a manner to avoid corrosion and damage in handling and transit.	
9.	Marking	Each Packing shall be legibly marked with manufacturer's identity, Qty, Heat No, OFT Supply order No etc.,	
			Each Consignment

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