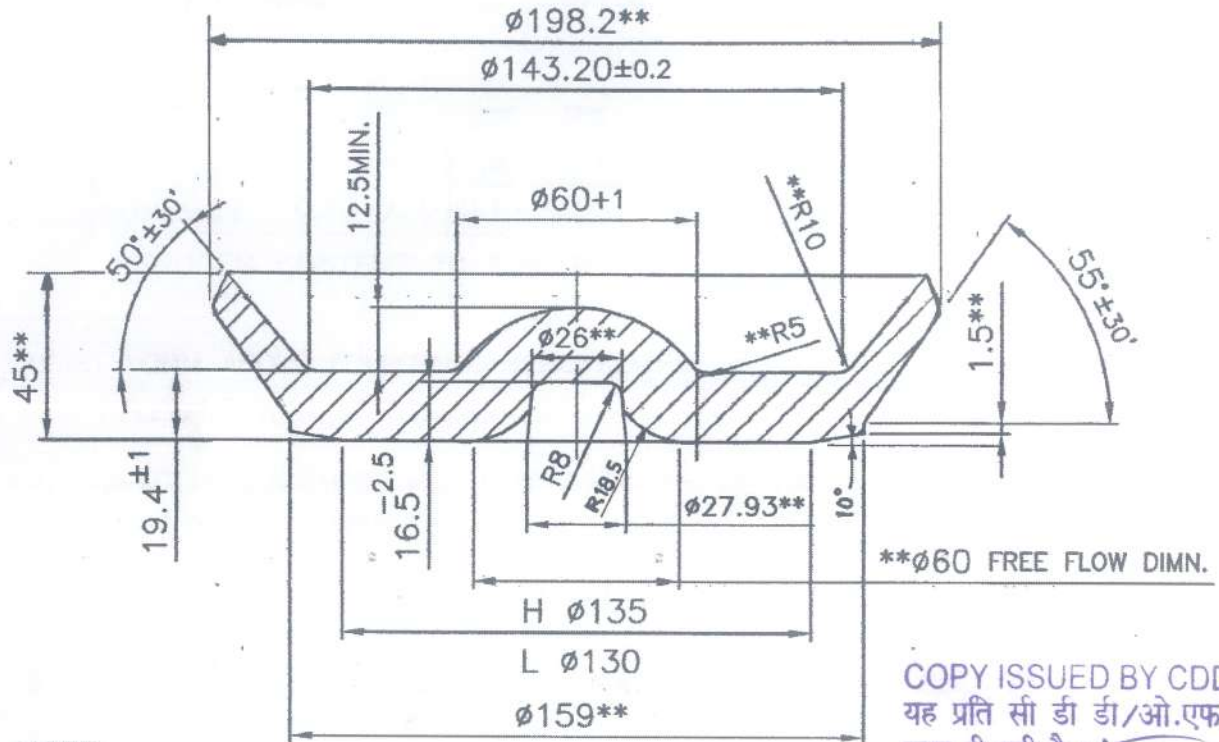


DRG. NO : CC-471 F

TOLERANCE ON UNTOLERATED DIMNS. ARE AS PER IS: 2102, MEDIUM CLASS



NOTE:

- 1) WALL THICKNESS VARIATION = 0.2 MAX.
- 2) DIMN. MARKED ** FOR REFERENCE ONLY.
- 3) WEIGHT - 4.67 ± 0.15 Kg.
- 4) HARDNESS AFTER ANNEALING 95 TO 125 VPN (10 Kg LOAD)
- 5) MATERIAL SHOULD BE HANDLED CAREFULLY ENSURING THERE SHOULD NOT BE ANY DASH/SCRATCH MARK ON EITHER SURFACE OF BLANK
- 6) MATERIAL TO BE CLEANED AFTER ANNEALING.
- 7) SUITABLE PROTECTIVE COATING TO BE APPLIED WITH PROPER CLEANING (FREE FROM SCALE) TO AVOID RUSTING AND CORROSION DURING TRANSPORT AND STORAGE

COPY ISSUED BY CDD/OFAJ
यह प्रति सी डी डी/ओ.एफ.ऐ.जे.
द्वारा दी गयी है

दिनांक 28/10/23
Date: 28/10/23
क.का.प्र./सी.डी.डी.
for JWM/CDD

DIMENSIONS ARE IN mm			MATERIAL : AS PER SHEET NO. 2&3		ORDNANCE FACTORY AMBAJHARI
THIRD ANGLE PROJECTION			NOMENCLATURE :		
SCALE : 1 : 2			PRE CUP BLANK (ANNEALED)		DRG. NO :
2003	NAME	DATE			CC-471 F
REDRAWN	Vase	26/7/12			SHEET NO : 1
CHECKED	plg	26.07.12			NO. OF SHEETS : 3
JWM/CDD	lll	26/07/12			OPERATION NO :
APPVD.:	AWM/CCS	N. L.	26/7/12	MACHINE :	COMPT. : BASE
	JGM/CCS	plg	26/7/12	STORE : 125mm SCCC	3-026892 4X40

28/07/23

MATERIAL DETAILS :-

BLANKS ARE TO BE PUNCHED/MACHINED OUT FROM ROLLED STRIPS, MANUFACTURED FROM HIGH GRADE MILD KILLED STEEL OF GRADE 11 10 A TO SPECIFICATION GOST B 19032-73, DEOXIDIZED BY ALUMINIUM WITH FOLLOWING CHEMICAL COMPOSITION. (ESR QUALITY PREFERABLE)

C%	Mn%	Si%	P%	S%	Cr%	Ni%	Cu%	Al%
0.10-0.12	0.30-0.50	0.13	0.025	0.025	0.20	0.15	0.20	0.03-0.09
NOT MORE THAN								

NITROGEN CONTENT 70 PPM MAX.

APART FROM ABOVE FOLLOWING SPECIFICATION MAY BE REFERRED TO RELEVANT TEST / REQUIREMENT

1. IMPACT STRENGTH AS PER GOST 9454-78, MECHANICAL TESTING AS PER GOST 7268-67 WITH DEFORMATIONS DUE TO COMPRESSION.
2. ULTRASONIC TESTING IS TO BE CARRIED OUT AS PER THE AMS 2630 CLASS A1.
3. CENTRAL POROSITIES AND SEGREGATION SHOULD NOT EXCEED APPENDIX-I OF GOST 19032-73.
4. MICRO STRUCTURE OF STEEL SHOULD CONSIST OF EQUIAXIAL FERRITE GRAINS AND UNIFORMLY ARRANGED GRANULAR OR SORBITIC PEARLITE WITH COMPLETE ABSENCE OF WIDMANSTATTEN PATTERN OF FERRITE.
5. THE STREAKNESS OF FERRITE PEARLITE STRUCTURE SHOULD NOT EXCEED NUMBER 2 AS PER GOST 5640-68, SCALE 3 ROW A.
6. MAXIMUM GRAIN SIZE 0.07mm AS PER SPECIFICATION NO.: GOST 5639-65
7. DEPTH OF COMPLETE DECURBURISATION IS NOT PERMITTED
8. FOR ALL OTHER CONDITIONS GOST B 19032-73 IS **PERTINENT**.
9. DIMENSION OF FERRITE GRAIN IS PERMITTED IN THE LIMIT OF NO. 7 TO 10 AS PER GOST-5639-65.

ORDNANCE FACTORY AMBAJHARI

2003	NAME	DATE	NOMENCLATURE :	DRG. NO :
REDRAWN	Vasu	26/7/12	PRE CUP BLANK	CC-471 F
CHECKED	[Signature]	28.03.12	(ANNEALED)	SHEET NO : 2
JWM/CDD	[Signature]	26-07-12		NO. OF SHEETS : 3
APPROV. AWM/CCS	[Signature]	26/7/20	MACHINE :	OPERATION NO :
JGM/CCS	[Signature]	26/7/12	STORE : 125mm SCCC	COMPT. : BASE
				3-026892 4 X 40

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द्वारा दी गयी है

दिनांक क.का.प्र./सी.डी.डी.
Date: for JWM/CDD

28/10/23

REV.	DATE	DESCRIPTION	SIGN
F	28.3.22	Amended as per actual free flow shape of material verified by QC-T46. Dimensions R18.5 & L10 added.	<i>Ammiti</i> 28/03/22 AWM/CCS
E	25.02.2022	In Sheet NO.2, note NO.5 "STREAKNESS" was "STRIPNESS." & Note No.9 added.	<i>Ammiti</i> 25/02/22 AWM/CCS
D	26/7/12	MATERIAL DETAIL & SHEET No. 2&3 ADDED AND NEW NEGATIVE MADE	<i>No. 10</i> AWM/CCS
C	25/5/09	AMENDED AS PER ACTUAL FREE FLOW OF MATERIAL, WEIGHT 4.67 ±0.15 KG WAS 4.4 (APPOX.) & NEW NEGATIVE MADE	Sd/- DGM/CCS
B	31/12/08	HARDNESS AFTER ANNEALING 95 TO 125VPN (10KG LOAD) WAS 95 TO 115 VPN	Sd/- WM/CCS
A	21/1/08	NOTE No. 4 TO 7 ADDED & NEW NEGATIVE MADE	Sd/- JGM/CCS

A M E N D M E N T S

ORDNANCE FACTORY AMBAJHARI

COMPILED BY : <i>Vasu</i> 26/7/12	PRE CUP BLANK (ANNEALED)	SPECN. NO.:	CC-471 F
CHECKED BY : <i>JS</i> 28-07-12		SHEET NO.:	3
JWM/CDD <i>[Signature]</i> 26-07-12	APPROVED	NO.OF SHEETS :	3
<i>No. 10</i> AWM/CCS	<i>[Signature]</i> JGM/CCS	COMPT. BASE	3-026892 4X40
STORE : 125mm SCCC			