



MATERIAL FOR INDIA:
 BS 3144 PT 1: 1974 TYPE CLA-12 GRADE 'B'
 OTHER TECHNICAL DETAILS ARE AS PER CQA (MET)
 INSPECTION INSTRUCTION NO. QAQA-1/QA-1/12 DE. 5.5.94

MATL. FOR INDIA:-
 IS: 10343-1999 GRADE 16Q

MATERIAL :- STEEL 35X7C71 GOST 977-75
TECHNICAL REQUIREMENTS FOR CASTING AREAS
PER TY 83-65-88, GR. 2, CHEMICAL COMPOSITION
IS AS PER GOST 977-75

DETAILS TO BE MARKED ON TAG:
 Sl. No. of Tag
 Batch No.
 No. of Compts. in the Batch
 Insp. Mark of Mould Check
 Insp. Mark of Component

MATERIAL FOR INDIA:

BS 3146 PT 1: 1974 TYPE CLA-12 GRADE 'B' FOR CASTINGS.
 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) CHAPUR
 INSPECTION INSTRUCTION NO. MQA-1/QA-1/12 DE. 5.5.94
 FOR OTHER DETAILS.

1. SURFACE ROUGHNESS OF CASTINGS AS PER STANDARD.
2. DRAFT ANGLE IS UP TO 1°.
3. UNSPECIFIED CASTING RADIUS 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

MATERIAL COMPOSITION

a) Chemical composition conforming to OEM material Gr. Steel 35X7C71 of Gost 977-75 to be used to achieve specified mechanical properties of OEM OR IS:10343-1999 Gr.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

DA.No. 001/20 AS PER DC.No: 27193-5A, Dt. 08.04.19 amended on 22.02.20

DA.No. 001/19 : Dt. 25/4/19.
 GOST MATL. ADDED
 REF:- CQA/M/QA/12.7/VI
 Dt: 04/01/19

MATL. FOR INDIA
 AMENDED. 24.09.98
 DE. 28.4.98
 DA. NO. 8/98 D/12-Tmm
 DE. 16.6.98

VETTED FOR MATERIAL ONLY

Principal Scientific Officer,
 Quality Assurance Officer,
 For Gen. & Quality Assurance Officer,
 Indian Quality Assurance Syst. (IQAIS)
 Tiruchirappalli - 620 016.

ARAO
 SQA (A)
 TRICHY

22/04/19

UN CONTROLLED COPY

HARDNESS HB 241 MAX.

CERTIFIED CORRECT COPY
 OF APPROVED DRAWINGS
 AT THIS DATE: 17.11.2020

Design & Drawing Office
 Ordnance Factory,
 Tiruchirappalli-620016

DA.12/98 D/12-Tmm 30.11.98
 MATL. FOR INDIA AMENDED
 DC.No. 24192-5A-24.10.98

DA.No. 8/98 D/12-Tmm
 DE. 16.6.98

DA.No. 8/98 D/12-Tmm
 DE. 16.6.98

SHEETS : 1	1 ST ANGLE	DRAWN	I/C PROJ.	CASTING DRG.
SHEET No : 1	PROJECTION	CHECKED	DIV. OFFICER	6P11-2-12
ALL DIMENSIONS ARE IN mm.	SCALE : 2:1	CHECKED	DIV. OFFICER	DRG. NO.: 62 C 2212 250 G3

BRACKET HANDLE