



- NOTE :1) PARTING OF BILLETS ARE TO BE GOVERNED BY THE WEIGHT AND NOT BY LENGTH, LENGTH AS MENTIONED IS FOR GUIDANCE ONLY.
- 2) 25-30mm WITH "BLUE" COLOUR BAND IS TO BE PAINTED THROUGH OUT THE LENGTH AND PARTED FACE OF EACH PARTED BILLET ON ONE SIDE.
- 3) HEAT/CAST NO. ALSO TO BE PAINTED WITH SAME COLOUR ON ANY PARTED FACE OF EACH BILLET.
- 4) ENDS OF EACH PARTED BILLET ARE TO BE SAW CUT AND DEBURRED (PLUSMA/GAS CUT IS NOT ALLOWED.)
- 5) PACKING/PALLETISATION OF PARTED BILLETS SHOULD BE SECURED BY STEEL STRAP TO FACILITATE EASY LOADING/UNLOADING. PACKING IS TO BE DONE HEAT/CAST WISE WITH STEEL TAG MENTIONING STEEL GRADE, HEAT NO, QUANTITY AND FIRM NAME.
- 6) OTHER PARAMETERS ARE TO BE GOVERNED BY THE O.F.Aj. SPEC. NO. F-330 (LATEST ISSUE) ~~EXCEPT POINT NO. 7.5, 8.1, 8.2, 8.4, 8.5, 8.7 & 9.6.~~

MASS OF BILLET = 23.800 +0.500 Kg.

50/2014 D	15.3.14	OBLIQUITY 2+1 WAS 1.0 MAX.	WM/SF
265/13 C	27.12.13	EXCEPT POINT NO ARE DELETED FROM COLUMN NO 6	WM/SF
564/06 B	27.12.06	NOTE-6, ADDED "EXCEPT POINT NO."	WM/SF
511/06 A	25.11.06	TOL. ON DIMNS AMENDED, OBLIQUITY 1.0 WAS 1.5mm NOTE NO. 5 ADDED, NOTE NO. 1,2,3,4, AMENDED, NOTE NUMBERS ADJUSTED ACCORDINGLY. NEW TRACING MADE.	WM/SF
REV	DATE	DESCRIPTION	SIGN.
A M E N D M E N T S			

DIMENSIONS ARE IN mm		
THIRD ANGLE PROJECTION		
SCALE - 1 : 1		
2006	NAME	DATE
DRAWN	-sd-	DATE
RETRACED	BAGDE	25/11/06
CHECKED	-sd-	05/06/2000
JWM/CDD	-sd-	
APPVD	WM/SF	25.11.06
JGM/SF	-sd-	17/06/2000

MATERIAL	STEEL TO SPECN. JSS 9510-1, Grade-SS/B27
NOMENCLATURE	PARTED BILLET
M/C :	
STORE :	105 mm IFG SHELL

ORDNANCE FACTORY AMBAJHARI	
DRAWING NO. F-472 D	
SHEET NO.-	1
NO.OF SHEETS -	1
OPERATION -	
COMPT.	FORGED BODY F- 160