

**FORGING DRAWING**

**CHEMICAL COMPOSITION OF THE MATERIAL :- 30XPA**

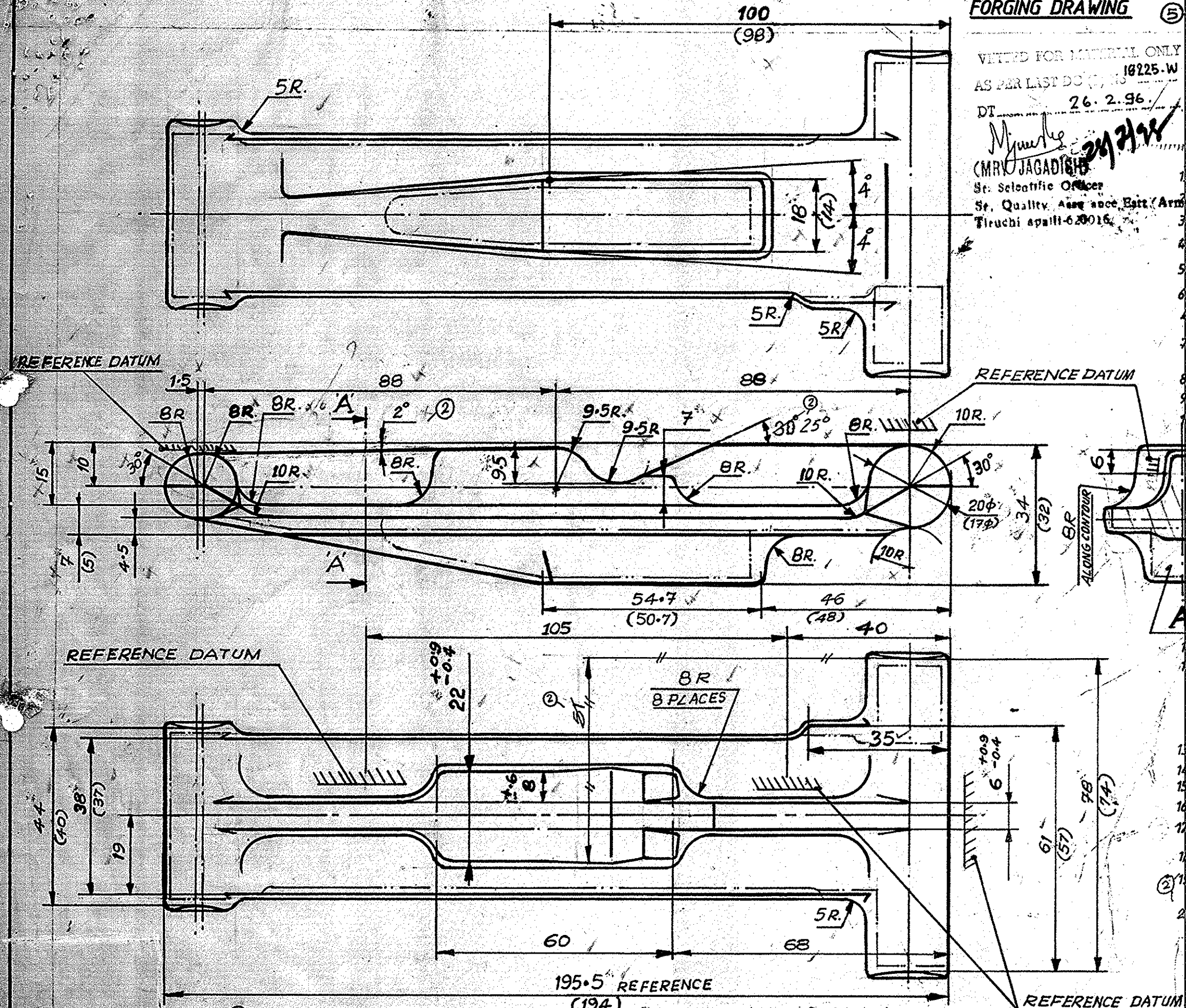
C	0.28 - 0.33	Si	0.17 - 0.37
Mn	0.50 - 0.80	Cr	1.0 - 1.3
Ni	0.25 - 0.50	S	0.025 MAX.
P	0.025 MAX.	Cu	0.20 MAX.

INTEND FOR MATERIAL ONLY  
AS PER LAST DC 10225-W  
DT 26.2.96

**FOR COMPONENT NO 2A42-05-115 - CONNECTING LINK RIGID**

*M. J. Jagadish*  
MRV JAGADISH  
Sr. Scientific Officer  
Sr. Quality Assurance Engg. (Arm)  
Tiruchirappalli-620016

- DIMENSIONS ARE IN mm.
- SCALE : 1:1
- FIRST ANGLE PROJECTION.
- HEAT-TREATMENT :- NORMALIZING; HARDNESS HB 217 MAX.
- DE-SCALING :- SHOT-BLASTING PICKLING
- DISPLACEMENT OF DIE PARTING LINE SHOULD NOT EXCEED 0.8 mm.
- MARKING BY BLACKSMITH'S STAMP: TO 5 GOST 2930-62
- REMAINDER OF FLASH ON DIE PARTING LINE SHOULD NOT EXCEED 1.1 mm.
- CURVATURE OF PLANE "S" SHOULD NOT EXCEED 0.4 mm.
- UN-SPECIFIED DRAFT ANGLE 7°.
- UN-SPECIFIED RADII 2.0 mm.



THE FINISHED COMPONENT SHOULD ATTAIN A HARDNESS RANGE OF HRC3 43.5 TO 51.5 AFTER FINAL HEAT-TREATMENT

- ALLOWANCES AS PER CLASS II GOST 7505-74 M1
- TOLERANCES AS PER CLASS II GOST 7505-74 C3 AND AS FOLLOWS  
VERTICAL: +0.13 / -0.7  
HORIZONTAL: +0.15 / -0.7  
DIE FORGING BY HAMMER.
- NUMBER OF PARTS OBTAINED FROM ONE FORGING : 1 PIECE.
- DIMENSIONS GIVEN IN BRACKETS ARE FOR MACHINING
- WEIGHT OF THE FORGING 1.120 Kgs. 185
- RAW MATERIAL SIZE 38 ± 0.50 ± 0.04 x 160 LONG (HOT ROLLED)
- MATERIAL - 30XPA - OST-3-98-80. INDIGENOUS MATL. ADDED IN SHEET NO. 2
- QUALITY OF DIE FORGED SURFACE AS PER GOST 8479-70.
- \* DIMENSIONS TO BE CHECKED; REMAINING DIMENSIONS ARE ENSURED BY DIE.
- SURFACE DEFECTS SHOULD NOT EXCEED 0.4 mm DEPTH

AMENDMENTS	DESCRIPTIONS/DETAILS	SIG & DATE
②	DAND: 63/92, DE 23-10-92. ANGLE 25° WAS 30°, DIM. 51 DELETED	
①	STORE DRG. NO. ADDED	
B	ANGLE 30° WAS 25° DIMENSION 51 ADDED	

SHEET NO:- 1	<i>Sadhi</i> 22-09/88	6/88			<i>WM</i> 22/6/88	ORDNANCE FACTORY TIRUCHIRAPALLI-16	DRG NO: 64 C 5115 200 F 3
SHEETS :- 2	REDRAWN	CHECKED	APPROVED	I/C. PROJ.	WM/PROJ.		