

MATERIAL COMPOSITION

a) CHEMICAL COMPOSITION CONFORMING TO OEM MATERIAL GRADE STEEL 35X1C1 OF GOST 977-75 TO BE USED TO ACHIEVE SPECIFIED MECHANICAL PROPERTIES OF OEM OR IS:10343-1999 GRADE 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

MATERIAL FOR INDIA
 BS 3146 PT 1: 1974 TYPE CLA-12 GRADE 'B'
 OTHER TECHNICAL DETAILS ARE AS PER CQA (MET) INSPECTION INSTRUCTION NO. MQA-1/QA-1/12 DE. 5/5-94

MATERIAL :- STEEL 35X1C1 GOST 977-75
 TECHNICAL REQUIREMENTS FOR CASTINGS ARE AS PER TY B3-65-88 GROUP 2. CHEMICAL COMPOSITION IS AS PER GOST 977-75

1. SURFACE ROUGHNESS OF CASTINGS AS PER STANDARD.
2. DRAFT ANGLE IS UP TO 2°.
3. UNSPECIFIED CASTING RADII UP TO 12mm.
4. MISALIGNMENT ALONG PARTING PLANE UPTO 0.2mm.
5. SINKAGE OF TRACES DUE TO EJECTOR IS PERMITTED UPTO 0.2mm.
6. MARK THE 'SL. NO. OF THE TAG ON WHICH THE DETAILS ARE MARKED
7. SECTION A-A FOR MEASURING DEPTH OF DECARBURIZED LAYER.

8. * DIMENSIONS FOR REFERENCE

9. DIMENSION IN (1) ALSO FOR REFERENCE ONLY. REFER ATTACHED SHEET FOR HEAT TREATMENT PROCESS DRG-NO: M 882

HARDNESS HB. 241 MAX.

MATERIAL FOR INDIA :- IS:10343-1999 Gr. 16Q
 BS: 3146 PT 1: 1974 TYPE CLA-12 GRADE 'B' 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.

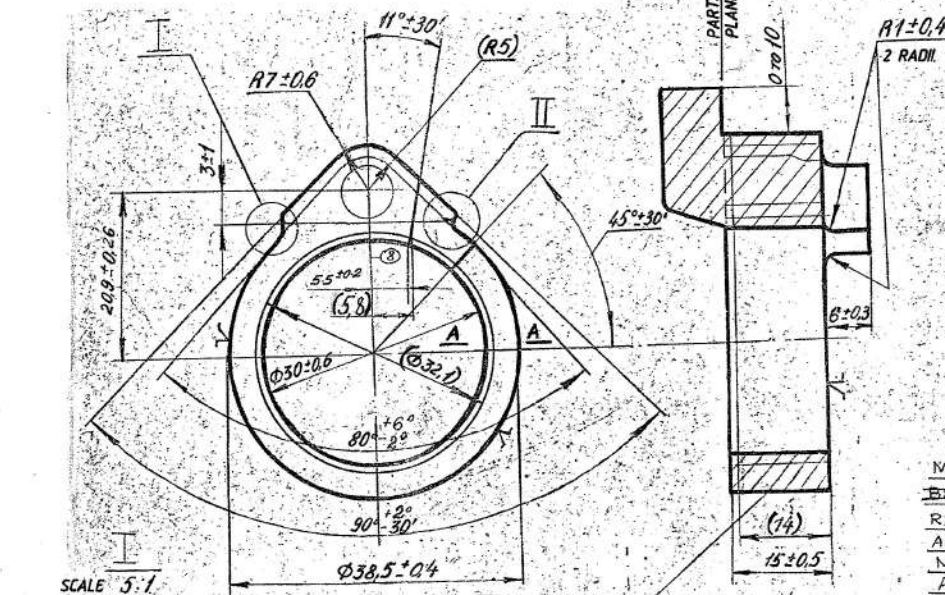
CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE.....

17.11.2020

Design & Drawing Office
 Ordnance Factory,
 Truichampalli-620016

UN CONTROLLED COPY

SLEEVE HANDLE
 BASE BARREL



SCALE 5:1

SCALE 5:1

VETTED FOR MATERIAL ONLY

Handwritten signatures and stamps for material vetting. Includes 'ARAO SRAE(A) TRICHY' and a date stamp '26/04/19'. The text below the signatures reads: 'Quality Assurance Officer, For Senior Quality Assurance Officer, Senior Quality Assurance Off. (Senior) Truichampalli, 620 016.'

Details to be marked on the Tag :-

- Sl.no. of the Tag
- Batch no.
- No. of Comp. in the Batch
- Insp. mark of mould check
- Insp. mark of Component

DS. CAT NO. 100500 7195, 7196, 7197

G DA.No. 001/20 AS PER DC.No. 27193-SA, Dt. 08.04.19 amended on 22.02.20

F DA.No. 001/19 ; Dt. 25/4/19
 GOST MATL. ADDED
 REF:- CQAM QA/12-7/VI ; Dt. 04/01/19

E DA.No. 001/17 Dt. 01.03.17 MATL. AMENDED

D DA.No. 12/98 D. 12/17mm D. 20-11-98
 MATL. FOR INDIA AMENDED
 REF. DC.No. 24191-SA-D. 23-10-98

C MATL. FOR INDIA AMENDED
 24090-SA-D. 20-4-98
 DA.No. 8/98 D. 12-7mm
 D. 16-6-98

B DA.No. 4/95 D. 12-7mm
 Dt. 4-3-95

AMENDMENTS

SHEETS : 1	1 ST ANGLE PROJECTION	DRAWN	I/C PROJ.
SHEET No : 1	SCALE : 2:1	CHECKED	DIV. OFFICER
ALL DIMENSIONS ARE IN mm.			

CASTING DRG.
6P11-1-13
DRG. NO.: 62 C 1013-250 G3