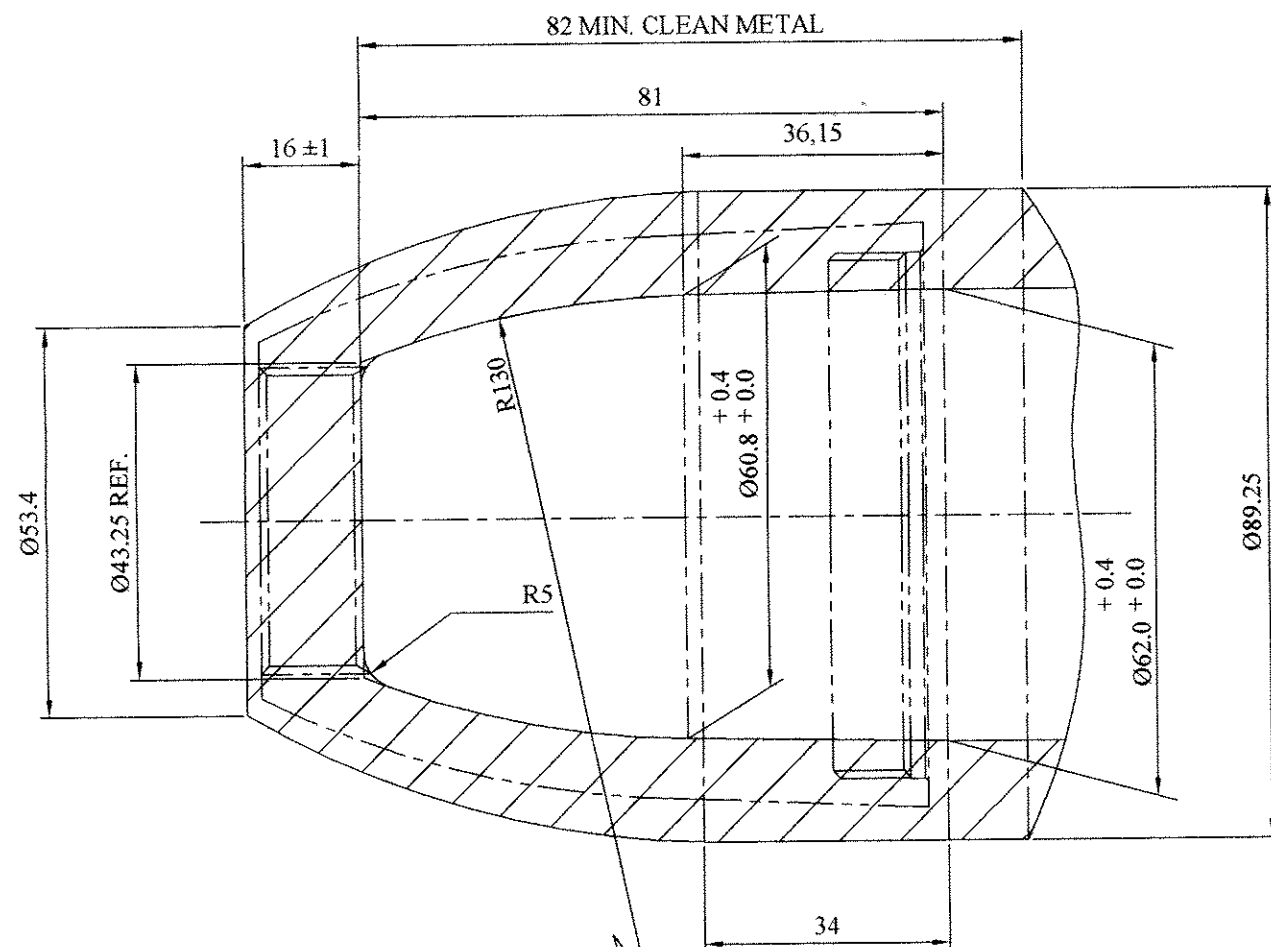


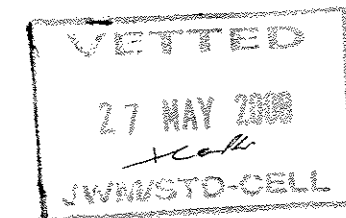


NOTES :-

- ROUGH FORGINGS SHOULD BE ANNEALED OR NORMALISED OR AS FORGED.
- FORGING TO BE STORED IN COVERED CONDITION.
- FORGING MUST BE SYMMETRIC ABOUT THE PARTING LINE.
- THE FORGING MUST BE HOMOGENOUS THROUGHOUT AND FREE FROM SEAM, FLAWS, PIPING AND OTHER DEFECTS.
- FORGING METHOD DO NOT LEAD TO THE FORMATION OF OVERLAPS, FALSE BOTTOMS OR OTHER UNDESIRABLE DISPLACEMENT OF STEEL.
- THE FORGING SHOULD BE SOUND WITHOUT ANY PITTINGS, CRACKS OR FOLDINGS.
- TOTAL INDICATOR READING BETWEEN INSIDE AND OUTSIDE DIAMETER = 3mm MAX.
- PILOT SAMPLES TO BE APPROVED BEFORE BULK SUPPLY
- FORGING TO ACHIEVE THE FOLLOWING MECHANICAL PROPERTIES IN AS FORGED CONDITION.

MECHANICAL PROPERTIES:-

TENSILE STRENGTH (Rm) = 590 - 885 MPa
0.2 % PROOF STRESS = 310 MPa MINIMUM



WEIGHT : 2.440 Kg. (APPROX.)

*** MATL : JSS 9510 - 1 AUG 82 TO CODE NO. SS / F44

CHEMICAL COMPOSITION:-

C % 0.45 - 0.55
Mn % 0.70 - 1.00
Si % 0.12 - 0.35
S % 0.05 Max
P % 0.05 Max

RESIDUAL ELEMENTS:-

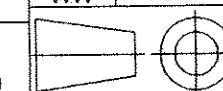
Ni % 0.25 Max.
Cr % 0.20 Max.
Mo % 0.10 Max.
Al % 0.035 Max.
V % 0.02 Max.

इन आरेखों तथा इसके साथ की सम्पूर्ण सामग्री का स्वत्वाधिकार भारत सरकार रक्षा मंत्रालय की भारतीय आयुध निर्माणियों के पास है। भारतीय आयुध निर्माणियों के महानिदेशक की लिखित अनुमति के बिना इनकी नकल या किसी भी रूप में इनके उद्धरण या इनमें समाहित सूचना किसी अनधिकृत व्यक्ति को उपलब्ध नहीं कराई जानी चाहिए।

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मूलमाप व अन्वयोजन
NOMINAL SIZE & FIT

विचलन
DEVIATION



FORGED BODY (FRONT PART)				***				
संख्या NO. OFF	विवरण DESCRIPTION	पदार्थ MATERIAL	मानक STANDARD	परिमाण DIMENSIONS	अभ्यक्ति REMARKS			
सामान्य सहिष्णुता GENERAL TOLERANCE					S% - 0.05 Max was 0.03 - 0.06 Ref. OFAJ dng. no. F-329L	03.02.08		
रेखिक परिमाण LINEAR DIMENSION								
0-6	±0.1							
6-30	±0.2							
30-120	±0.3							
120-315	±0.5							
315-1000	±0.8							
1000-2000	±1.2							
कोणिक परिमाण ANGULAR DIMENSION		संख्या NO. OFF	संबंधित पुर्जाकर आरेखण क्र. DRG. NO. OF ASSOCIATED PART	सूचक INDEX	संशोधन ALTERATION	2008	दिनांक DATE	नाम NAME
1-10	±1°							
10-50	±30'							
50-100	±20'							
>100	±10'							
मापक 'म्यू एम' में VALUE IN "um"								
~	>25							
▽	8-25							
▽▽	1.6-8							
▽▽▽	0.025-1.6							
▽▽▽▽	<0.025							
FORGED BODY (FRONT PART) BOMB 81mm MORTAR C - EMPTY BODY (OFAJ)						मापमान SCALE	आरेखित DRAWN	26.05.08
						1:1	जाँचा CHECKED	27.15.08
							अनुमोदित APPROVED	27.15.08
						द्वारा बदला REPLACED BY		
						हेतु बदला REPLACED FOR		
मशीनी औजार आदिरूप फैक्टरी, अम्बरनाथ MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH						कार्यालय OFFICE	DO	
						आरेखण क्र. DRAWING NO.	F - 9G	