



**MATERIAL COMPOSITION**  
 a) CHEMICAL COMPOSITION CONFORMING TO OEM MATERIAL GRADE STEEL, SUBJECT OF GOST 977-75 TO BE USED TO ACHIEVE SPECIFIED MECHANICAL PROPERTIES OF OEM OR IS 10343-1993 GRADE 16 G.  
 b) MATERIAL COMPOSITION TO BE FOLLOWED IN AS UNDER :-

SC	SI	SI	SI	SI	SI	SI	SI
0.30	1.00	0.60	0.60	0.80	0.30	0.040	0.050
0.40	1.30	0.80	0.50	max	max	max	max

**D** DA NO. 12/98 D.12.7mm DC. 30.11.98  
 MATL. FOR INDIA AMENDED  
 REF DC NO. 24/92-SA-DE. 24.10.98

**E** DA NO. 001/19 D. 12.7. MATL. AMENDED  
 DC NO. 24/92-SA DE. 24.10.98

**DETAILS TO BE MARKED ON TAG:**  
 SL. NO. OF TAG  
 BATCH NO.  
 NO. OF COMPTS. IN THE BATCH  
 INSR MARK OF MOULD CHECK.  
 INSR MARK OF COMPONENT

**VETTED FOR MATERIAL ONLY**

Principal Scientist, Quality Assurance Officer, Senior Quality Assurance Officer, Senior Quality Assurance Insp. (Arm's)  
 Bangalore-629 016

DA NO. 001/19 D. 12.7.19.19  
 GOST MATL. ADDED  
 REF. CRAM/QUAL/11/19/19 D. 01/01/19  
 DA NO. 001/20 AS PER DC NO. 27/93-SA  
 REF. CRAM/QUAL/11/19/19 D. 01/01/19  
 DC. 08.04.19 amended on 22.02.20

**F** DA NO. 001/19 D. 12.7.19.19  
 GOST MATL. ADDED  
 REF. CRAM/QUAL/11/19/19 D. 01/01/19  
 DA NO. 001/20 AS PER DC NO. 27/93-SA  
 REF. CRAM/QUAL/11/19/19 D. 01/01/19  
 DC. 08.04.19 amended on 22.02.20

**8** DIMENSIONS IN ( ) ARE FOR REFERENCE ONLY  
**9** REFER ATTACHED SHEET FOR HEAT TREATMENT PROCESS. DRG. NO. M 882.

**C** MATERIAL FOR INDIA AMENDED 24/07B-SA-DE 3-A-206  
 DA NO. 8/98 D.12.7mm DC. 16.6.98

<b>B</b>	DA NO. 4/95 D.12.7mm	S. Roy	A-3.95
AMENDMENTS		DATE & SIGN.	
SHEETS : 1	1 <sup>ST</sup> ANGLE	DATE	SIGN.
SHEET No : 1	PROJECTION		
ALL DIMENSIONS ARE IN mm.	SCALE :	CHECKED	

D.S. CAT. NO. 1005007191	
DETENT HANDLE BASE BARREL.	
CASTING DRG.	6/11-1-16
ORG. NO. :	62 C-1216-250 G3

**UN CONTROLLED COPY**  
 HARDNESS HB 241 MAX.

1. SURFACE ROUGHNESS OF CASTINGS AS PER STANDARD.
  2. DRAFT ANGLE IS UP TO 1°.
  3. UNSPECIFIED CASTING RADII 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.
- MATL. FOR INDIA: 15.10.23-1993 GRADE 16G  
 GR. A TO GR. 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] ICHAPUR INSPECTION INSTRUCTION NO. MQA-1/9A-1/12 DE. 5-5-94 FOR OTHER DETAILS.

**MATERIAL:**  
 35XPC71 GOST 977-75  
 TECH. REGT. FOR CASTINGS  
 ARE AS PER 7.7 B3-65-88  
 CHEM. COMP. IS AS PER GOST - 977-75

CERTIFIED CORRECT COPY  
 OF APPROVED DRAWINGS  
 AT THIS DATE: 17.11.2020  
 Designer & Drawing Office  
 Ordnance Factory,  
 Tiruchirappalli-620 016