

CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE: 17.11.2020

VETTED FOR MATERIAL ONLY

Principal Scientific Officer,
Quality Assurance Division,
For Greater Quality Assurance Officer,
Senior Quality Assurance Unit, (Rmte)
Tiruchirappalli-620 016.

ARAO
SRAE(A)
TRICHY.

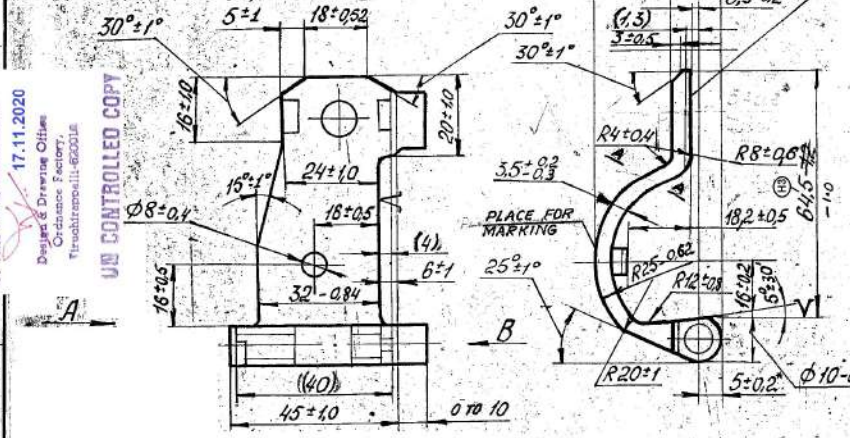
MATERIAL FOR INDIA:
B5 3%₄ P7 1/1974 TYPE CLA-22 GRADE B
OTHER TECHNICAL DETAILS ARE AS PER CQA / MET /
INSPECTION / INSTRUCTION NO. / MQA-1/QA-1/12 DE. 5-5-94

MATERIAL COMPOSITION

a) CHEMICAL COMPOSITION CONFORMING TO OEM MATERIAL GRADE STEEL 35XTC/L 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

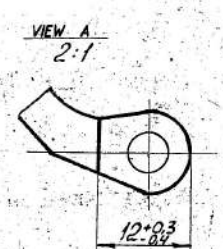
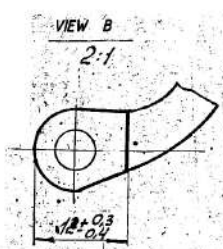


1. SURFACE ROUGHNESS OF CASTINGS AS PER STANDARD.
2. DRAFT ANGLE IS UP TO 1°.
3. UNSPECIFIED CASTING RADII UP TO 1mm.
4. MISALIGNMENT ALONG PARTING PLANE UP TO 0.2mm.
5. SINKAGE OF TRACES DUE TO EJECTOR IS PERMITTED UP TO 0.2mm.
6. MARK THE SL. NO. OF THE TAG ON WHICH THE DETAILS ARE MARKED.
7. SECTION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

8. DIMENSIONS ENSURED BY TOOL
9. DIMENSIONS IN () ARE FOR REFERENCE ONLY
10. REFER ATTACHED SHEET FOR HEAT TREATMENT PROCESS DRG. NO: M 882

HARDNESS HB. 241 MAX.

MATERIAL FOR INDIA: IS: 10343-1999 GRADE 16 Q
B5-3%₄P7-1/1974 TYPE CLA-22 GRADE B CASTINGS
RADIOGRAPHIC TEST AS PER ASTM-E-192 WITH ACCEPTANCE STANDARD FOR GAS HOLE AND FOREIGN MATERIAL LEVEL-5 SHRINKAGE [ALL TYPES] LEVEL-3
ALSO REFER CQA [MET] ICHAPUR INSPECTION INSTRUCTION NO. MQA-1/QA-1/12 DE. 5-5-94 FOR OTHER DETAILS.



Details to be marked on the Tag

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

MATERIAL :- STEEL 35XTC/L GOST 977-75
TECHNICAL REQUIREMENT FOR CASTING ARE AS PER TY B3-65-88, GROUP-1. CHEMICAL COMPOSITION IS AS PER GOST 977-75.

DA No. 002/19, Sl. No. 2
Dated: 17.11.2020
13
Dt. 08.04.19 amended on 22.02.20

Q3	DA No. 001/18, Dt. 25/4/19. GOST MATL. ADDED REF: CQA/MQA/1/12-7/y-1, Dt. 04/01/19
F3	DA No. 001/17, Dt. 13.12.17, Dt. 08.04.19 28999-CA 04/10/17-14
E	DA No. 12/98, Dt. 12.7mm DE. 30.11.98 MATL. FOR INDIA AMENDED REF DC. NO. 24192-SA. DE. 24.10.98

D	MATL FOR INDIA AMENDED 24078-SA 3438 DA No. 8/98 Dt. 27.11.98
C	DA No. 13/93 Dt. 12.12.93
B	DA No. 4/95 Dt. 12.12.95
AMENDMENTS	SI. No. DATE

DS. CAT NO. 1005007192		HANDLE BASE BARREL	
SHEETS : 1	ANGLE PROJECTION	DRAWN	I/C PROJ.
SHEET No : 1	SCALE: 1:1	CHECKED	DIV. OFFICER
ALL DIMENSIONS ARE IN mm.			DRG. NO: 62 C 1214 250 13

2 3 4 5 6 7 8