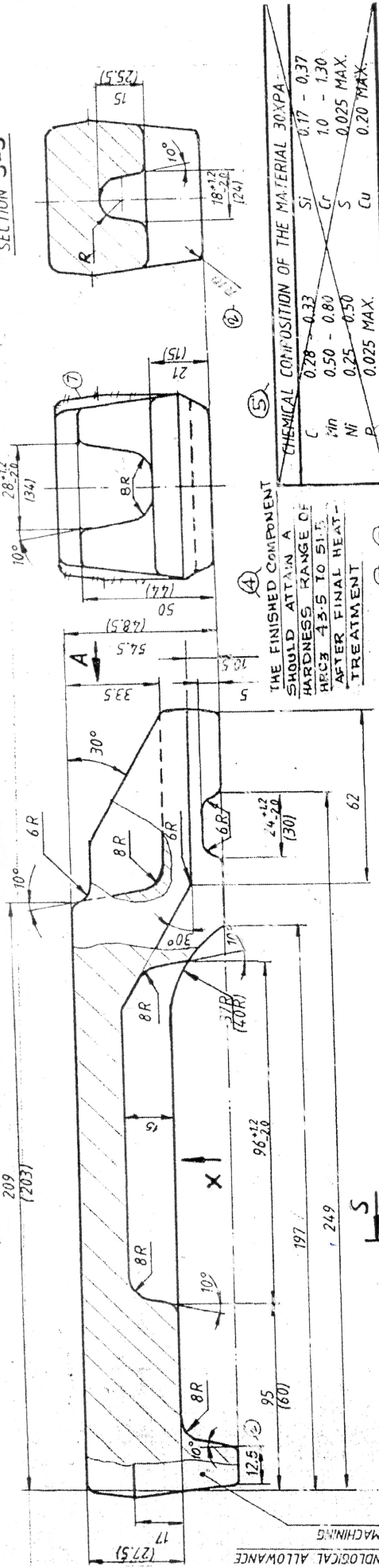


**FORGING DRAWING**

**SECTION S-S**

**VIEW THROUGH 'A'**



④ THE FINISHED COMPONENT SHOULD ATTAIN A HARDNESS RANGE OF HRC3 43.5 TO 51.5 AFTER FINAL HEAT-TREATMENT

⑤ CHEMICAL COMPOSITION OF THE MATERIAL 30XPA

C	0.28 - 0.33	Si	0.17 - 0.37
Mn	0.50 - 0.80	Cr	1.0 - 1.30
Ni	0.25 - 0.50	S	0.025 MAX.
P	0.025 MAX.	Cu	0.20 MAX.

⑥ INDIANOUS MATL: IS: 4367-91, 25C13M06 CONDITION 'M' (OR) IS 5517-9983, DESIGN, 25C13M06 CONDITION 'M'. TEST SAMPLE SHALL BE HEAT TREATED AND TESTED TO LRS 63mm

⑤ HEAT TREATMENT PROCESS CHART

NOMENCLATURE AND IDT. NO.	STEEL GRADE	TYPE OF OPERATION	EQUIPMENT	TEMP. IN °C	TIME	COOLING MEDIUM	HARDNESS IN TRAY
FRONT STRIPPER	30XPA	NORMALIZING HEATING	ELECTRIC CHAMBER OR FURNACE	850-870	3 HRS.	AIR	37% BUT NOT LESS THAN 3 PIECES
REAR STRIPPER	30XPA	PUSHING	FURNACE				
C 1092							
C 1093							

1. DRESSING OF PLACES FOR CHECKING HARDNESS.  
2. CHECKING OF HARDNESS.

SEND ONE PART FROM THE CHARGE UP CHAMBER OR PUSHER FURNACE FOR CHECKING UP ABSENCE OF FRACTURE DUE TO OVER HEATING.

- ④ NUMBER OF PARTS OBTAINED FROM ONE FORGING : 1 PIECE.
- ⑤ DIMENSIONS GIVEN IN BRACKETS ARE FOR MACHINING
- ⑥ WEIGHT OF THE FORGING 4.215 Kgs. ~
- ⑦ RAW MATERIAL SIZE :- 55.58 x 270 LONG ( HOT ROLLED ) ( OR ) Eq. Wt. DIA 80x163mm
- ⑧ MATERIAL :- 30XPA OST 3-98-80
- ⑨ ANGLE UNDER FILLING OF LAP WITH PRESERVED RADII 5 x 5 mm
- ⑩ IS TOLERABLE

⑪ SURFACE DEFECTS SHOULD NOT EXCEED 0.6 mm IN DEPTH.

⑫ DRAFT ANGLE 7°.

⑬ UNSPECIFIED RADII 2.5 mm.

⑭ ALLOWANCES AS PER CLASS II COST 7505-74 M1

⑮ TOLERANCES AS PER CLASS II COST 7505-74 M1

⑯ VERTICAL HORIZONTAL -20

⑰ DIE FORGING BY HAMMER.

⑱ F (6) DA-NO 005101 (3) 10/3/01

⑲ DA-NO 005101 (3) 10/3/01

⑳ DA-NO 005101 (3) 10/3/01

① FOR COMPONENT NO

2442-01-092 - FRONT STRIPPER

2442-01-093 - STRIP RETAINING METALLIC

② DRG NO

64 C 1092 200 N3

③ I 3

④ ORDNANCE FACTORY TIRUCHIRAPALLI-16

⑤ 23/1/86

⑥ WM/PROJ

⑦ I/C PROJ

⑧ APPROVED

⑨ 6/88

⑩ CHECKED

⑪ REDRAWN

⑫ 3446-W 14.09.15 MATL. AMENDED (DA No. 001115 Dt. 01.01.16) AS PER L. No. 1B/1218-COAW, Dt. 15.12.15

- ① DIMENSIONS ARE IN mm.
- ② SCALE :- NOT TO SCALE
- ③ FIRST ANGLE PROJECTION.
- ④ HEAT-TREATMENT :- NORMALIZING; HARDNESS HB 220 - 260
- ⑤ DESCLAING :- PICKLING.
- ⑥ DISPLACEMENT IN THE PARTIS PLANE SHOULD NOT EXCEED 0.9 mm.
- ⑦ REMAINDER OF FLASH ON DIE PARTING LINE SHOULD NOT EXCEED 1.2 mm.
- ⑧ ROD CURVATURE SHOULD NOT EXCEED 1.2 mm.