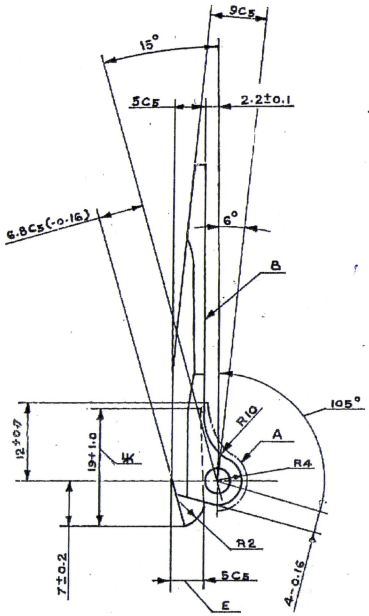
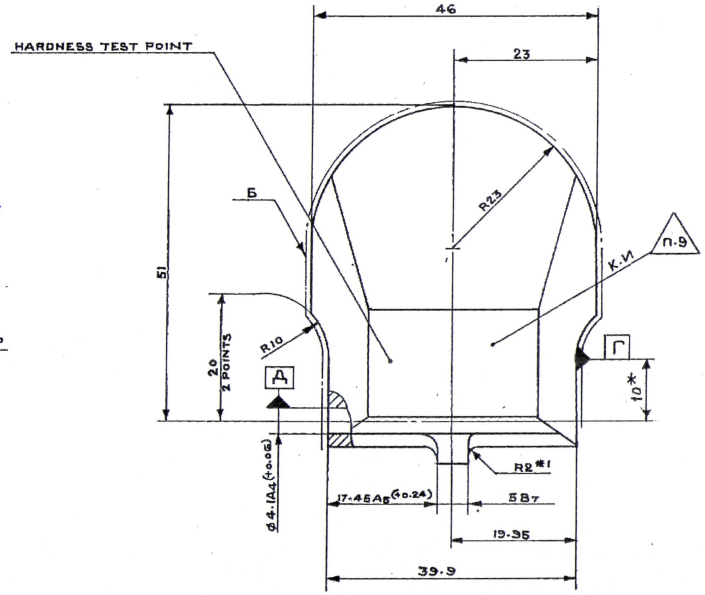
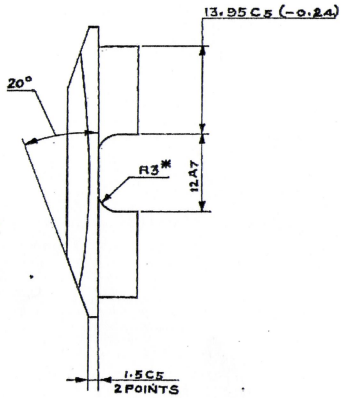
DS CAT No
1005-560456

DIMENSIONS ARE IN m m.

Rz 20







@ OR PHOSPHATING (ACCELERATED) GDE I TO JSS: 0465-01-94, WITH COATING OF DUNLOP ADHESIVE S 758, ONE LAYER AND NIGROSINE TO JSS: 1036.

NOTES:-

1. HRC$_3$ 48.5 TO 53.5.
2. * ENSURE SIZES BY TOOLS.
3. *1 SIZE NOT IN PROJECTION.
4. BLUNT SHARP EDGES, R ≈ 0.6 mm.
5. TOLERANCE ALONG CONTOUR A RELATIVE TO SURFACE Д AND SURFACE Б IS 0.2 mm.
6. TOLERANCE ALONG CONTOUR Б RELATIVE TO SURFACE Д AND SURFACE Г IS 0.2 mm.
7. SHOT- BLAST.
8. COATING: ACCELERATED ELECTROLESS PHOSPHATING WITH CHROMATE TREATMENT/IMPREGNATION WITH ADHESIVE БФ-4, GOST 12172-74 WITH NIGROSINE, GRADE A, GOST 9307-78, ONE COAT @
9. STAMP.
10. CHECK SIGE E ON SECTION Ж.

INDIGS MATL :- STEEL GRADE 826 M 31 TO BS: 970 Pt 1-1983 CONDITION 'Z' WITH S & P CONTENT 0.010% & 0.015% MAX RESPECTIVELY (ESR QUALITY STEEL)

UN CONTROLLED COPY
CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE... 21/9/23...
DESIGN & DRAWING OFFICE,
ORDNANCE FACTORY, TIRUCHIRAPPALI -620 016.

1-7-08	19131-W		D.S. CAT No. ADDED.	
19-1-2001	18614-W		INDIGS MATL AMENDED	
3-9-96	18291-W		INDIGS MATL AMENDED	
19-8-96	18283-W		NOTE No 8 AMENDED	
30 11 95	18193-W		NOTE No. 8 AMENDED.	
22 9 95	18174-W		PROV SEALING CANCELLED & DRG SEALED.	
23-12-92	17490-W		INDIGS MATL ADDED.	
13-11-92			RETRACED WITHOUT CHANGE	
			PREV D C (1) Nos. 16407-W, 16657-W, & 16975-W. Dt 14-11-90	
DATE	AUTHORITY	ZONE	NATURE	SIG AHSP / SIG DO

AMENDMENTS

DRG SEALED :- 18174-W 22-9-95 DO CQA(W)

DRN:-	CHD:-		ASSY DRG:-	CQA(W) JABALPUR
TCD:- S R SINGH	CHD:- G.P. Shukla		DATE:-	
			SCALE:- 2:1	
C/D'MAN	DO	FOR CQA(W)	ESTD MASS:- 709	

MATERIAL:- STEEL 35 X H2 M ΦA-III, OST 3-98-80.

PROTECTIVE FINISH:-

SHIELD शील्ड

DESIGN No.

PART No. 2A42-02-003

DS CAT No. 1005-560456

18845-W 13-01-04 HINDI NOMEN ADDED

CVS 12 18 11