VETTED FOR MATERIAL ONLY

AQAO
SQAE(A)
TRICHY

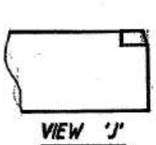
Principal Scientific Officer,
Quality Assurance Officer,
For Senior Quality Assurance Officer,
Senior Quality Assurance Estt. (Arms)
Tiruchirapalli - 620 016.

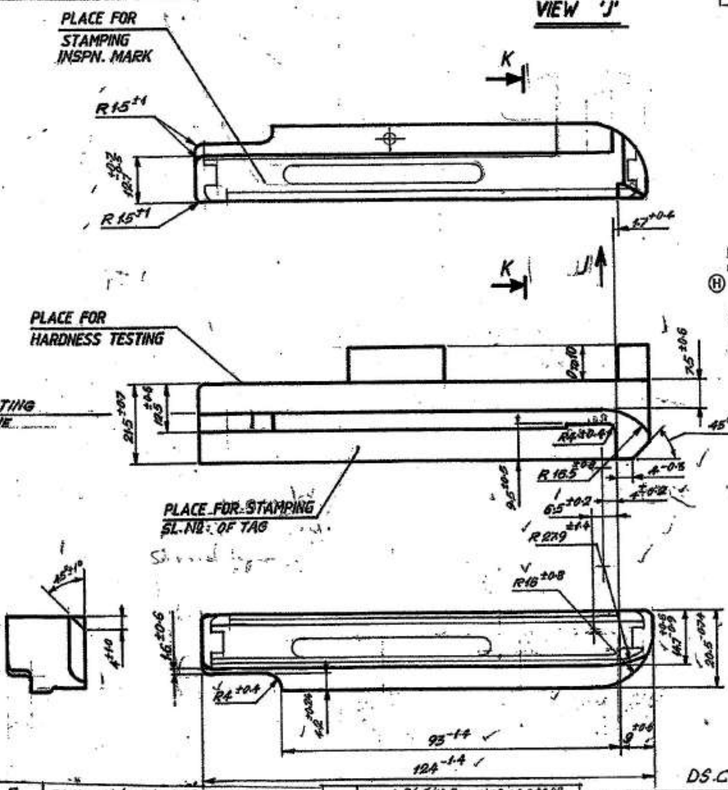
CERTIFIED CORRECT COPY
OF APPROVED DRAWINGS
AT THIS DATE 17.11.2020
Design & Drawing Office
Ordnance Factory,
Tiruchirappalli-620016

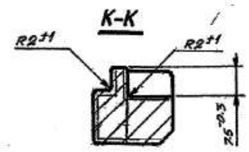
UN CONTROLLED COPY

| Rev. | Amendment |
|---|---|
| I | DA.No 003/20 Dt. 29.05.2020 Dimns removed at (C-4) view J |
| H | DA.No. 001/20 AS PER DC.No: 27193-SA, Dt. 08.04.19 amended on 22.02.20 |
| G | DA.No.001/19 ; Dt.: 25/4/19 GOST MATL. ADDED REF:- CQA(MET)(A)(I)2-7/V-1 Dt. 04/01/19 |

Details to be marked on Tag
- Sl.no. of Tag
- Batch no.
- No. of comp. in the Batch
- Insp. mark of mould check




Hardness HB 241 max

**MATERIAL COMPOSITION**

a) CHEMICAL COMPOSITION CONFORMING TO OEM MATERIAL GRADE STEEL 35XГСЛ OF GOST 977-75 TO BE USED TO ACHIEVE SPECIFIED MECHANICAL PROPERTIES OF OEM OR IS:10343-1999 GRADE 16-Q. (H)

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 |

MATERIAL :- STEEL 35XГСЛ GOST 977-75 (G)
TECH. REQT. FOR CASTING ARE AS PER TY B3-65-88, Gr.1.
CHEM. COMP. IS AS PER GOST 977-75.

1. SURFACE ROUGHNESS OF CASTINGS AS PER STANDARD.
2. DRAFT ANGLE IS UPTO 1°.
3. UNSPECIFIED CASTING RADII UPTO 1 mm.
4. MISALIGNMENT ALONG PARTING PLANE UPTO 02 mm.
5. SINKAGE OF TRACES DUE TO EJECTOR IS PERMITTED UPTO 0.5 mm. ON WORKING SURFACES.
6. STAMP SL.NO. OF TAG ON WHICH THE DETAILS ARE MARKED
7. STAMP INSPECTION MARK
8. SECTION A-A FOR MEASURING DEPTH OF DECARBURISED LAYER.
9. *DIMENSIONS FOR REFERENCE
10. REFER ATTACHED SHEET FOR HEAT-TREATMENT PROCESS - DRG.NO. 882

MATERIAL FOR INDIA:- IS:10343-1999 GRADE 16Q

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/QA-1/12 Dt. 5-5-94 FOR OTHER DETAILS.

DS.CAT NO. 1005007443

# BLOCK GUIDE LEVER FEED.

| | | | | | |
|---|---|---|---|---|---|
| F | DA.No.001/17 Dt.01.03.17 MATL. AMENDED | | C | DIMS. 26.5±0.5; 0.5±0.3; 4.8+0.48 DELETED VIEW CORRECTED D.A.NO. 12/95 D.12.7mm Dt.18.8.95 | S.Raju 18.8.95 |
| E | DA.12/98 D/12-7mm Dt.30.11.98 MATL. FOR INDIA AMENDED DC.NO. 24192-SA Dt.24.10.98 | S.Raju 30-11-98 | B | D.A.NO. 4/95 D.12.7mm Dt. 4.3.95 | S.Raju 4-3-95 |
| D | DA.NO.7/98 D/12-7 Dt. 7.6.98 | S.Raju 7.6.98 | | AMENDMENTS | SIG & DATE |

| | | | | |
|---|---|---|---|---|
| SHEETS :1 | 1 ANGLE PROJECTION | DRAWN | I/C PROJ. | CASTING DRG. 6P11-6-22 |
| SHEET No:1 | | | | |
| ALL DIMENSIONS ARE IN mm. | SCALE : 1:1 | CHECKED 5/4/87 | DIV. OFFICER | DRG. NO.: 62 C 6022 250 I 3 |