

ORDNANCE FACTORY AMBAJHARI, NAGPUR

W.
MM/CCS

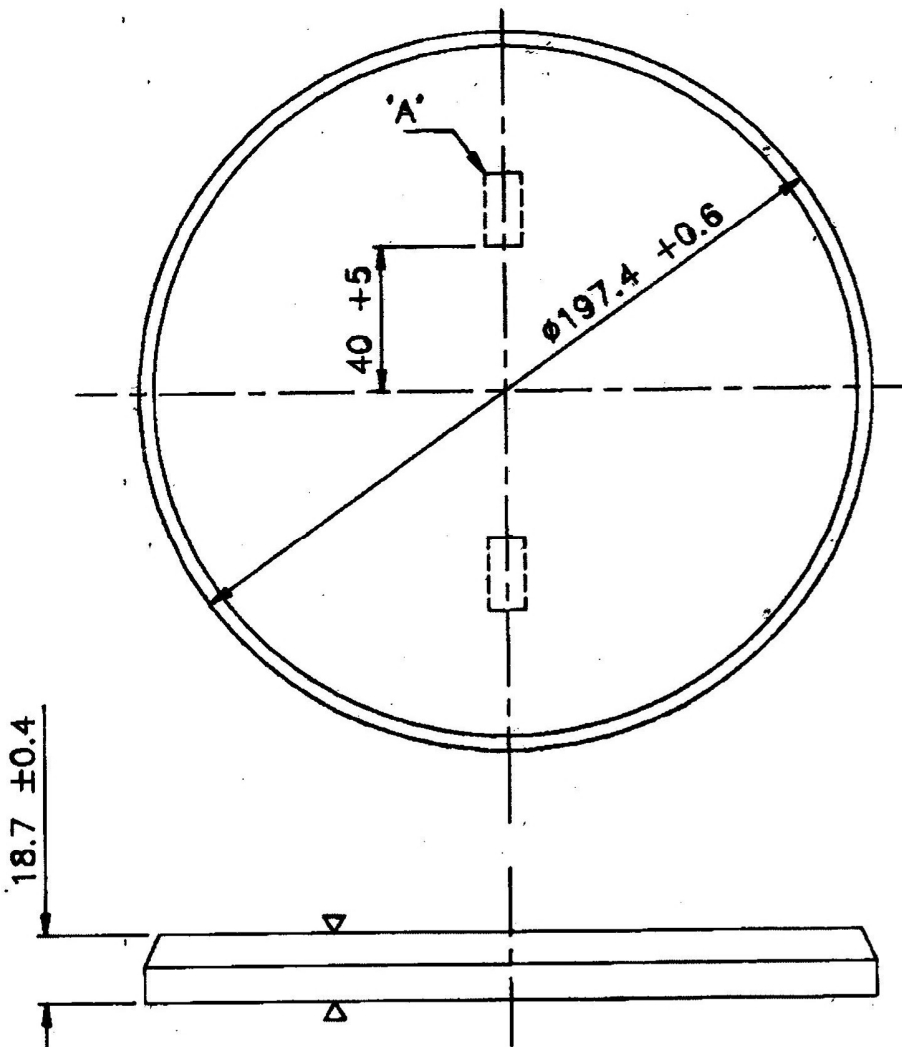
SPECN. NO.
CC-303Q

SPECIFICATION OF BLANK FOR BASE

ADG/BA

SHEET NO. 1

NO.OF.SHT. 4



WEIGHT OF BLANK = 4.67 ± 0.15 kg (Appx.)

NOTE :

- THICKNESS LESS THAN SPECIFIED WILL NOT BE ACCEPTED.
- THE ANGLE AND CHAMFER SHOWN IN THE DRG. IS ACTUALLY THE CLEARANCE BETWEEN THE DIE AND PUNCH PROVIDED FOR FACILITATING BLANKING OPERATION ONLY. AS SUCH THE ANGLE AND CHAMFER ARE NOT SPECIFICALLY MENTIONED & IS NOT IMPORTANT. STRAIGHT EDGES ARE ALLOWED.

DRAWING IS CORRECT

-sd-

(MARTYNOV)

Dt. : 06-09-85

COPY ISSUED BY CDO/CTM
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द्वारा दी गई है।
दिनांक 17-8-17
अनुभाग प्रमुख
HCS/CDO

ORDNANCE FACTORY AMBAJHARI, NAGPUR

WM/CCS

SPECN. NO.

CC-303 Q

SPECIFICATION OF BLANK FOR BASE

SHEET NO. 2

EDGM/BA

NO.OF.SHT.

1. BLANKS ARE TO BE PUNCHED/MACHINED OUT FROM ROLLED STRIPS, MANUFACTURED FROM HIGH GRADE MILD KILLED STEEL OF GRADE 11 TO A TO SPECIFICATION GOST B 19032-73, DEOXIDIZED BY ALUMINIUM WITH FOLLOWING CHEMICAL COMPOSITION. (ESR QUALITY PREFERABLE)

C%	Mn%	Si%	P%	S%	Cr%	Ni%	Cu%	Al%
		NOT MORE THAN						
0.10-0.12	0.30-0.50	0.13	0.025	0.025	0.20	0.15	0.20	0.03-0.09

NITROGEN CONTENT 70 PPM MAX.

2. BLANKS ARE TO BE HEAT TREATED (HARDENED & TEMPERED) FOLLOWED BY PICKLING. PIN HOLES, CAVITIES, LAMINATIONS, CRACKS, SCALES AND OTHER ROUGH DEFECTS ARE NOT ALLOWED ON THE SURFACE OF DISKS/STRIPS.

3. PROPERTIES OF BLANK :

TENSILE = 34 - 41 kgf/mm²

RELATIVE ELONGATION = 35% MIN.

IMPACT STRENGTH (AFTER MECHANICAL AGEING)

ALONG ROLLING NOT LESS THAN 15.0 kgfm/cm²

ACROSS ROLLING NOT LESS THAN 9.0 kgfm/cm²

IMPACT STRENGTH AS PER GOST 9454-78, MECHANICAL AGEING AS PER GOST 7268-67 WITH DEFORMATIONS DUE TO COMPRESSION.

THE HARDNESS OF THE BLANK TO BE MAINTAINED 125 VPN MAXIMUM.

4. ULTRASONIC TESTING IS TO BE CARRIED OUT AS PER THE AMS 2630 CLASS A1.

5. INSPECTION OF THE MACRO STRUCTURE IS TO BE CARRIED OUT IN DISKS AND STRIPS. THE PRESENCE OF COARSE GRAINS IN THE SURFACE LAYER, BREAK IN THE CONTINUITY OF METAL IN THE FORM OF SEPARATION OF LAYERS, TRACES, SHRINKAGE POROSITY, BLOW HOLES AND OTHER ROUGH DEFECTS ARE NOT PERMITTED.

CENTRAL POROSITIES AND SEGREGATION SHOULD NOT EXCEED APPENDIX I OF GOST 19032-73.

APPROVED BY CDO/CTF
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 दिनांक 17.8.17
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ORDNANCE FACTORY AMBAJHARI, NAGPUR

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SPECIFICATION OF BLANK FOR BASE

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DGM/BA

SHEET NO. 3
NO.OF.SHT. 4

6. MICRO STRUCTURE OF STEEL SHOULD CONSIST OF EQUIAXIAL FERRITE GRAINS* AND UNIFORMLY ARRANGED GRANULAR OR SORBITIC PEARLITE WITH COMPLETE ABSENCE OF WIDMANSTATTEN PATTERN OF FERRITE.

THE STRIPNESS OF FERRITE PEARLITE STRUCTURE SHOULD NOT EXCEED NUMBER 2 AS PER GOST 5640-68, SCALE 3 ROW A.

MAXIMUM GRAIN SIZE 0.07mm

AS PER SPECIFICATION NO. GOST 5639-65

FOLLOWING HEAT TREATMENT SCHEDULE IS SUGGESTED TO ACHIEVE THE MICRO STRUCTURE AND OTHER PROPERTIES : -

- a) AUSTENITIZE AT 900°C
- b) QUENCH IN WATER
- c) TEMPER AT 680°C / 700°C FOR AT LEAST 28 HOURS.

IT IS TO BE NOTED THAT THE ABOVE SCHEDULE IS ONLY FOR GUIDANCE OF MANUFACTURER/SUPPLIER AND IT DOES NOT ABSOLVE THE MANUFACTURER/SUPPLIER OF THE RESPONSIBILITY OF ^{NOT}GIVING CORRECT MICRO-STRUCTURE AND OTHER PROPERTIES, AS PER THE SPECIFICATION.

7. EVERY BLANK SHOULD BE MARKED WITH CAST NUMBER AT 'A' ON SMALLER DIA.

8. TOP AND BOTTOM SURFACES OF BLANKS SHOULD BE CLEANED BY GRINDING/ MACHINING SO AS TO OBTAIN EVEN AND SMOOTH SURFACE.
SUITABLE PROTECTIVE COATING TO BE APPLIED TO AVOID RUSTING AND CORROSION DURING TRANSPORT AND STORAGE.

9. NO DEPTH OF COMPLETE DECURBURISATION IS PERMITTED IN THE BLANK.

10. FOR ALL OTHER CONDITIONS GOST B 19032-73 IS PERTINENT

11. IN CASE OF COMPLETELY MACHINED BLANKS A 5 mm RADIUS TO BE PROVIDED IN ONE CORNER AND CAST NO TO BE STAMPED IN ADJUCENT FACE OF RADIUS

ISSUED BY GSO/STP
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का को नहीं है।
दिनांक
DATE 17.8.17
33P
अनुमति विद्युत
HCE/GSO

ORDNANCE FACTORY AMBAJHARI, NAGPUR		WM/CCS	SPECN. NO. CC-303Q
SPECIFICATION OF BLANK FOR BASE		DGM/QA	SHEET NO. 4
			NO.OF.SHT. 4

33/2017 Q	03.03.17	WEIGHT OF BLANK 4.67±0.05 Kg. WAS 4.4 Kg.	DGM/CCS
19/2012 P	24.01.12	IN CHEMICAL COMPOSITION NI% 0.15 WAS 0.20	DIR/CDC
239/2009 N	08.09.09	IN PARA 9 NO DEPTH OF COMPLETE DECURBURISATION IS PERMITTED IN THE BLANK. WAS DEPTH OF COMPLETE DECURBURISATION SHOULD NOT EXCEED 0.25 mm.	JGM/QA
243/2008 M	26.07.08	NOTE ADDED AS PER SPECIFICATION NO. G05T 5639-65	JGM/QA
328/03 L	03.10.03	NOTE NO 3 PROPERTIES OF BLANK. THE HARDNESS OF BLANK ADDED AMMN/CCS L.NO. CCS/125mm/47/04 DT. 26.09.03	JGM/CCS
307/2002 K	06.08.02	NOTE NO 11 ADDED, REF. LT NO CCS/PROD/TOOLS/47/08 dt. 3-8-02	DGM/CCS
101/01 J	27-08-01	IN CHEMICAL COMP. C% 0.10-0.12 WAS 0.10-0.13 REF: CQA(MET) L.NO. P/VISL/S/290/T-72/MQA-2 dt. 01 Aug 2001 IN NOTE NO. 6 'OF NOT GIVING' WAS 'OF GIVING'	JGM/QA
180/2K H	29-03-01	AMENDED AS PER CQA(MET) L. NO. P/SIL/N/2/T-72/MQA-2, SL. NO. 10 WAS SL. NO. 9. NEW NEGATIVE MADE DT 03-11-2000	DGM/QA
524/2K G	13.8.2K	NITROGEN CONTENT 70 PPM WAS 50 PPM IN NOTE NO. 1	-sd- JGM/F&CC
419/99 F	18.9.99	IN CHEMICAL COMP. C% 0.10-0.13 WAS 0.09-0.13 REF. CQA(AMN) L. NO. QA1A854/X1, DT. 30 AUG. 1999.	-sd- JGM/QA
417/99 E	11.9.99	IN NOTE NO.1 NITROGEN CONTENT ADDED. REF. LETTER NO. INST/TECH/MQA-2, DT. 12 MAY 1999.	-sd- JGM/F&CC
247/99 D	14.6.99	IN NOTE 1 'MACHINED' ADDED.	-sd- JGM/F&CC
302/98 C	07.11.98	NOTE NO. 1 CHANGED, SPECIAL NOTE ADDED.	-sd- JGM/F&CC
348/97 B	29.10.97	NOTES ADDED AND REARRANGED AS PER DGM/QA LETTER NO. 8573/A/QPR, DT. 13-10-97.	-sd- DGM/CCS
305/97 A	19.9.97	DIMENSION 18.7±0.4 WAS 18.5 ±0.4. LOCATION OF CAST NO. MARKING SHOWN. NOTES ADDED AS PER DIRECTIVES OF CQA(MET) AND REARRANGED. REF. CQA(MET) LETTER NO. (1) D/IMP/MQA2, DT. 31 JULY 1997. (2) P/INV/GEN/MQA2, DT. 13 AUG 1997. DRG. RETRACED.	-sd- DGM/CCS -sd- DGM/QA

REV.	DATE	DESCRIPTION	SIGN
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AMENDMENTS

ORDNANCE FACTORY AMBAJHARI

COMPILED BY :	SPECIFICATION OF BLANK FOR BASE	SPECN. NO.:	CC-303Q
CHECKED BY : <i>Bomal 28-03-01</i>		SHEET NO.:	4
JWM/CDO		NO.OF SHEETS :	4
APPROVED	STORE :	COMPT. 125mm SCCC BASE 3-026892 4X40	
<i>WM/CCS</i>	<i>DGM/QA</i>		