

MATERIAL: STEEL 35 X H2 M6A - W - TY 83-36-85

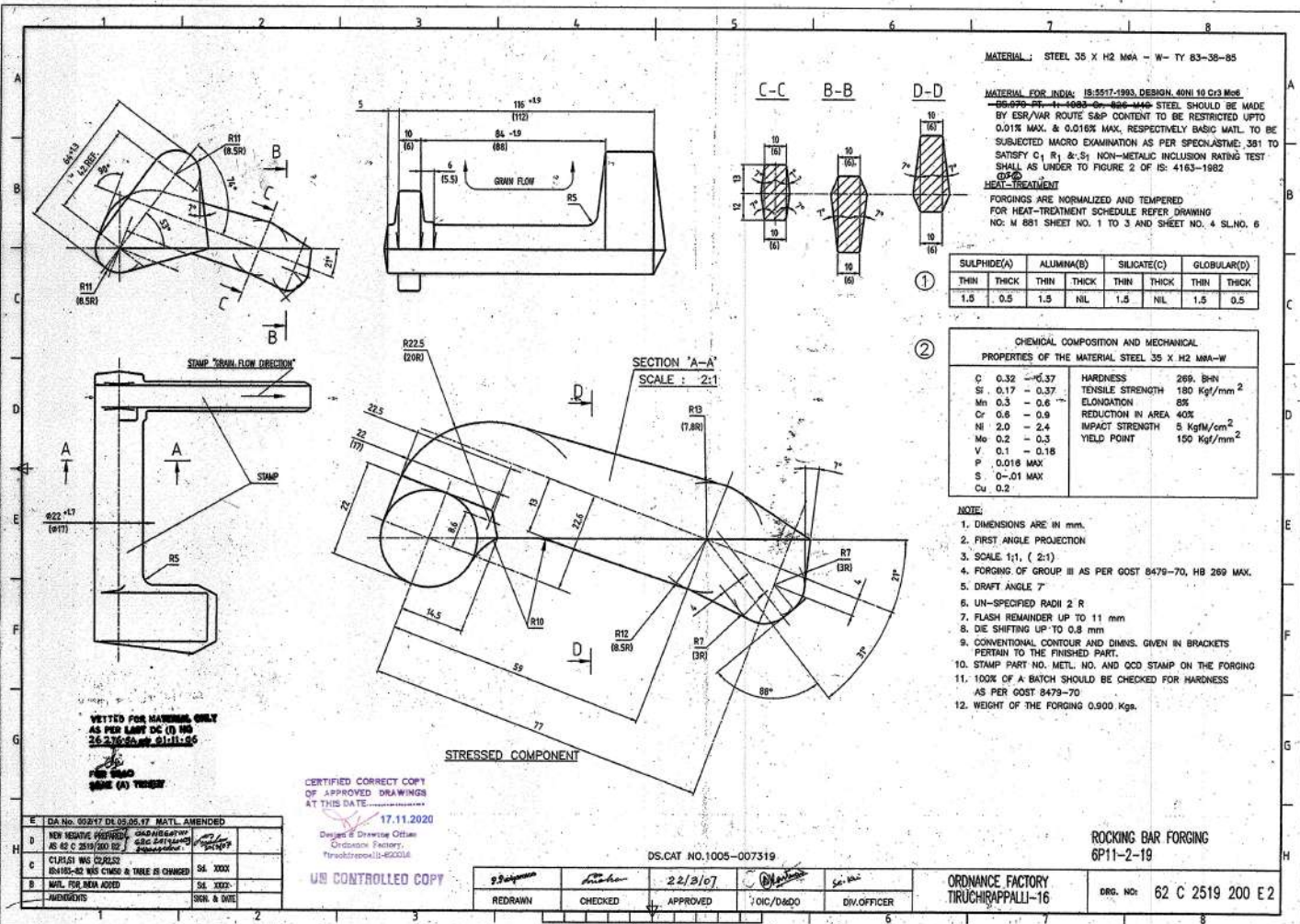
MATERIAL FOR INDIA: IS-5517-1993, DESIGN, MINI 10 Cr3 Mo8
 STEEL SHOULD BE MADE BY ESR/VAR ROUTE S&P CONTENT TO BE RESTRICTED UPTO 0.01% MAX. & 0.018% MAX. RESPECTIVELY BASIC MTL. TO BE SUBJECTED MACRO EXAMINATION AS PER SPEC. LATEST. 351 TO SATISFY C₁, R₁ & S₁ NON-METALLIC INCLUSION RATING TEST SHALL AS UNDER TO FIGURE 2 OF IS: 4163-1982

HEAT-TREATMENT
 FORGINGS ARE NORMALIZED AND TEMPERED
 FOR HEAT-TREATMENT SCHEDULE REFER DRAWING NO. M 881 SHEET NO. 1 TO 3 AND SHEET NO. 4 SLNO. 6

SULPHIDE(A)		ALUMINA(B)		SILICATE(C)		GLOBULAR(D)	
THIN	THICK	THIN	THICK	THIN	THICK	THIN	THICK
1.5	0.5	1.5	NIL	1.5	NIL	1.5	0.5

CHEMICAL COMPOSITION AND MECHANICAL PROPERTIES OF THE MATERIAL STEEL 35 X H2 M6A-W				
C	0.32	-0.37	HARDNESS	268 BHN
Si	0.17	-0.37	TENSILE STRENGTH	180 Kgf/mm ²
Mn	0.3	-0.6	ELONGATION	8%
Cr	0.6	-0.9	REDUCTION IN AREA	40%
NI	2.0	-2.4	IMPACT STRENGTH	5 Kgf/cm ²
Mo	0.2	-0.3	YIELD POINT	150 Kgf/mm ²
V	0.1	-0.16		
P	0.018	MAX		
S	0.01	MAX		
Cu	0.2			

- NOTE:
- DIMENSIONS ARE IN mm.
 - FIRST ANGLE PROJECTION
 - SCALE 1:1, (2:1)
 - FORGING OF GROUP III AS PER GOST 8479-70, HB 269 MAX.
 - DRAFT ANGLE 7°
 - UN-SPECIFIED RADII 2 R
 - FLASH REMAINDER UP TO 11 mm
 - DIE SHIFTING UP TO 0.8 mm
 - CONVENTIONAL CONTOUR AND DIMNS. GIVEN IN BRACKETS PERTAIN TO THE FINISHED PART.
 - STAMP PART NO. METL. NO. AND OCD STAMP ON THE FORGING
 - 100% OF A BATCH SHOULD BE CHECKED FOR HARDNESS AS PER GOST 8479-70
 - WEIGHT OF THE FORGING 0.900 Kgs.



NOTED FOR MATERIAL ONLY AS PER LAST DC (I) NO 26276-2000-0111-05
 FOR STAMP SAME (A) THERBY

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

UN CONTROLLED COPY

DS.CAT NO.1005-007319

ROCKING BAR FORGING
 6P11-2-19

REV	DESCRIPTION	DATE	BY	CHKD
E	DA No. 50247 DL05.05.17 MTL AMENDED			
D	NEW MESHING PROVIDED AS 42 C 2519/200 D2			
C	CLUSTERS WAS CHANGED	26.10.2019		
B	MTL FOR NEW JDED			
A	AMENDMENTS			

23/10/2019	22/10/2019			
REDRAWN	CHECKED	APPROVED	OIC/D&DO	DIV.OFFICER

ORDNANCE FACTORY
 TRICHIRAPPALLI-16

DRG. No: 62 C 2519 200 E 2