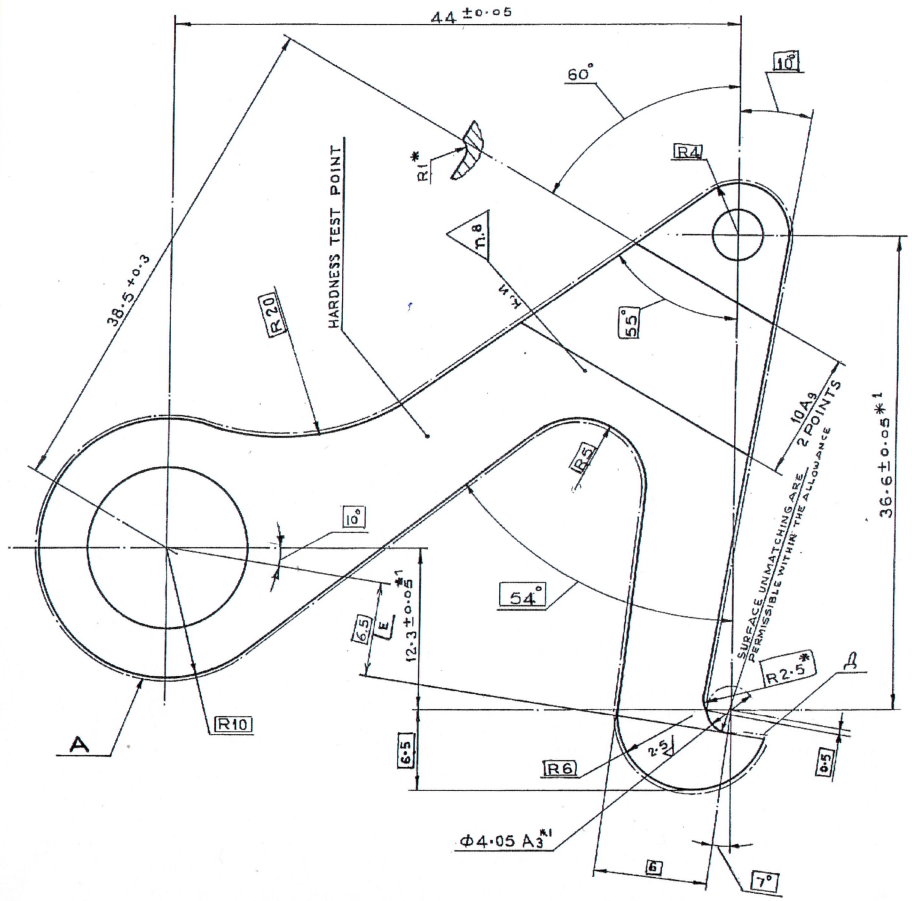
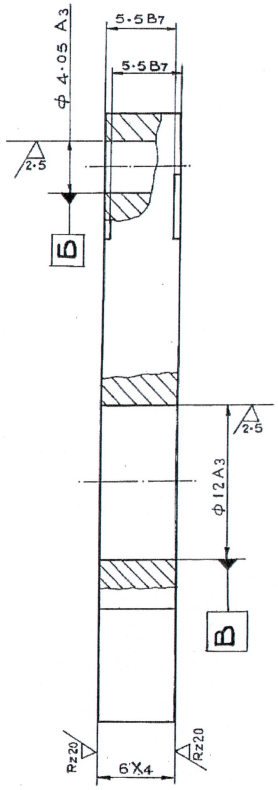
D.S.CAT.No.
3040-022820

DIMNS ARE IN mm.

Rz40





NOTES:-

1. HRC 43·5 – 51·5 .
2. * ENSURE SIZES BY TOOLS
5. TOLERANCE ALONG CONTOUR 'A' IS 0·4 mm, ALONG A WITH RESPECT TO BASE B AND B IS 0·05 mm.
4. BLUNT SHARP EDGES TO R ≈ 0·6 mm.
6. COATING: ACCELERATED ELECTROLESS PHOSPHATING WITH CHROMATE TREATMENT/IMPREGNATION WITH ADHESIVE BΦ-4, GOST 12172-74 WITH NIGROSINE, GRADE A (1), GOST 9307-78, ONE COAT OR PHOSPHATING (ACCELERATED) GDE I TO JSS:0465-01-94, WITH COATING OF DUNLOP ADHESIVE S 758, ONE LAYER & NIGROSINE TO JSS. 1036.
7. SHOT BLAST.
8. STAMP.
3. *1 THE DIMENSIONS CHECKED BEFORE ENSURING DIMENSION "E"

INDIGS MATL:-

BS: 970 Pt 1-1983, GRADE 826 M 31, IN 'Z' CONDITION

OR

IS: 5517-93, DESIGN 31 Ni 10 Cr 3 Mo 6, LRS 63 mm (TENSILE STRENGTH 1550 MPa)

A SEPARATE TEST SAMPLE IS TO BE HEAT TREATED AND TESTED IN 'Z' CONDITION

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

19157-W 7-5-09	D.S. CAT. No. ADDED & NOMEN. AMENDED.
18845-W 13-1-04	HINDI NOMEN ADDED
18614-W 19-1-2001	INDIGS MATL AMENDED
18412-W 8-12-97	INDIGS MATL AMENDED
18291-W 3-9-96	INDIGS MATL AMENDED
18283-W 19-8-96	NOTE No. 5 AMENDED
18193-W 30-11-95	NOTE No. 6 AMENDED.
18225-W 26-2-96	INDIGS MATL AMENDED.
18174-W 22-9-95	PROV SEALING CANCELLED & DRG SEALED.
16407-W 20-2-86	DRG SEALED PROV.

DATE	AUTHORITY	ZONE	NATURE
22·7·95	18150-W		INDIGS MATL ADDED.
14-10-93	17755-W		DRG AMENDED.
31-10-92			RETRACED WITHOUT CHANGE

AMENDMENTS

DRG. SEALED :- DC(I) No. 18174-W DT. 22-9-95 DOCQA(W)

DRN. | CHD. | ASSY. DRG.
TCD. S.R. Jaulkar | CHD. G.P. Shukla | DATE:-
SIG. AHSP | SIG. D.O. | CHIEF D'MAN | D.O. | AHSP | FORCQA(W) | SCALE:- 4:1 | ESTD.WT. 0·043

MATL:- STEEL 30XH2MΦA OST 3-98-80

PROTECTIVE FINISH:-

CQA(W) JABALPUR

DESIGN No.

PART No. 2A42.05.056

D.S.CAT.No. 3040-022820

CONNECTING LINK, RIGID

कनेक्टींग लींक, रिजीड