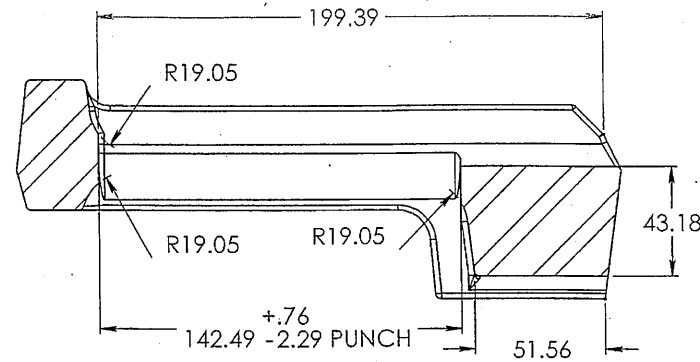


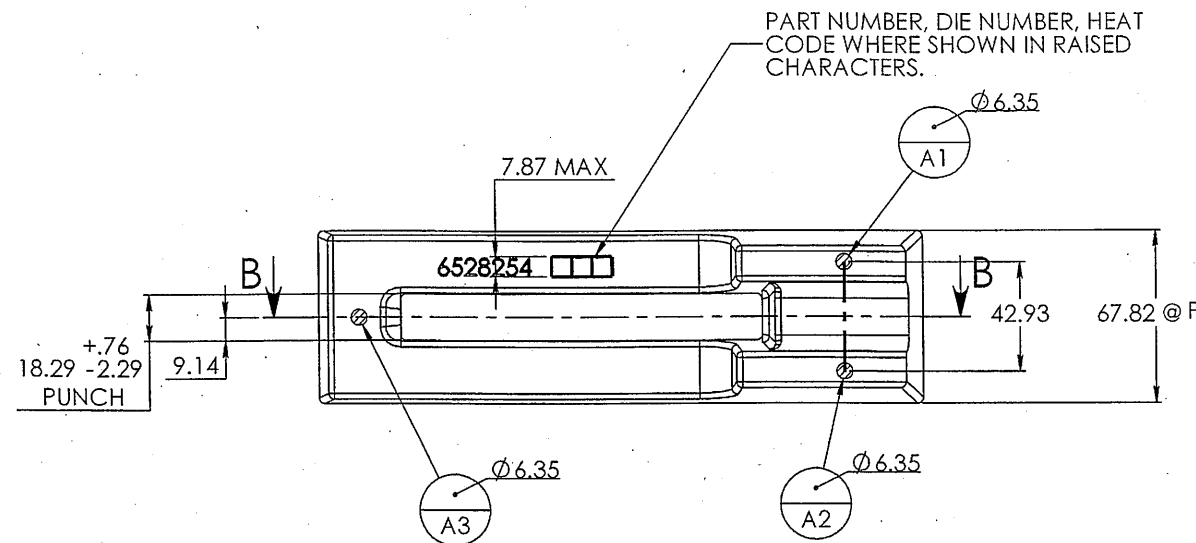
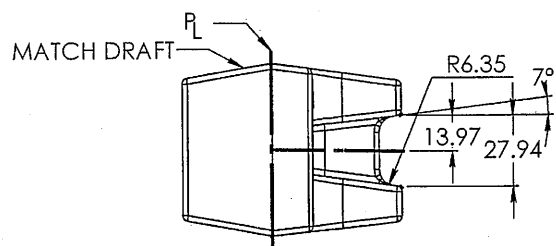
NOTES:

1. ALL DIMENSIONS TAKEN TO POINT OF INTERSECTION.
2. MATERIAL: ASTM A322 GRADE 4340.
3. HEAT TREATMENT: NORMALIZE AND ANNEAL TO HARDNESS 187-235 BHN.
4. I.D. TO WHERE SHOWN IN 6.35 HIGH CHARACTERS.
5. TOLERANCES ON RADII UP TO 12.7 ARE $\pm 50\%$ OF SPECIFIED RADIUS.

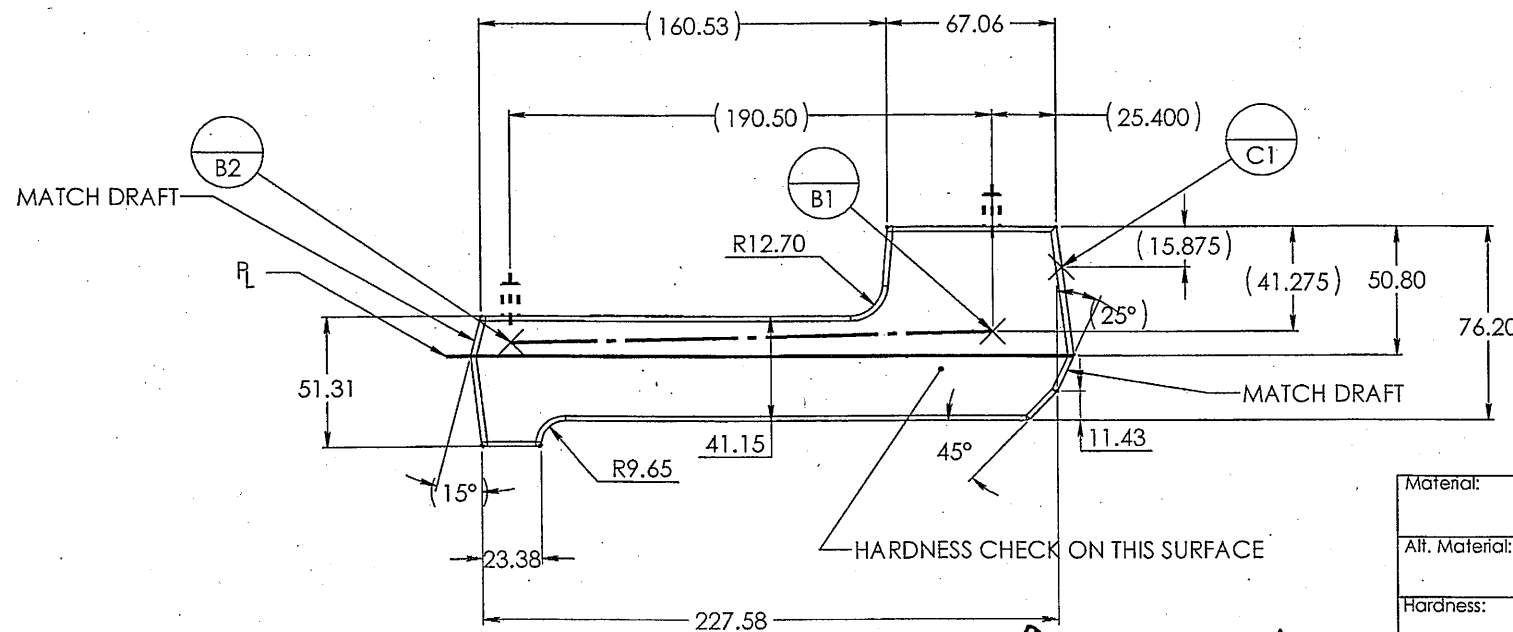
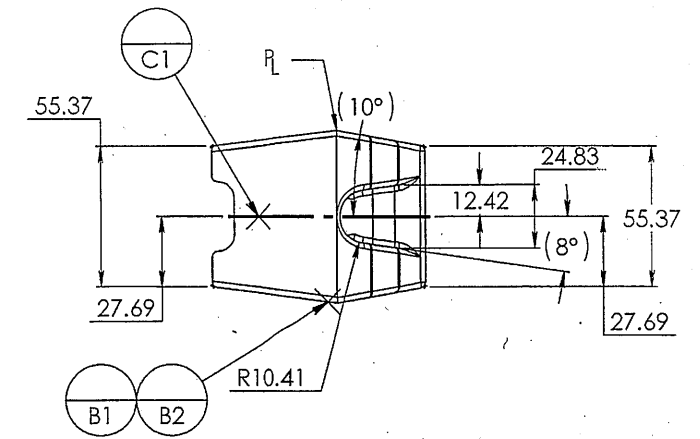
UN CONTROLLED COPY
 CERTIFIED CORRECT COPY OF APPROVED
 DRAWINGS AT THIS DATE. 01.09.2022
 DESIGN & DRAWING OFFICE,
 ORDNANCE FACTORY, TIRUCHIRAPPALLI-620 016.



SECTION B-B



GRAIN FLOW



INSPECTION FORGING SIZES
 UNLESS OTHERWISE SPECIFIED

CORNER RADII	2.286
FILLET RADII	2.286
DRAFT ANGLES	7° \pm 2°
THICKNESS	+2.286/- .762
EXTERNAL \varnothing	+2.286/- .762
INTERNAL \varnothing	+ .762/- 2.286
LENGTH	+2.286/- .762
WIDTH	+2.286/- .762
FLASH EXT.	1.524
STRAIGHTNESS	.762
MISMATCH	.762
CLEANING	SHOTBLAST SCALE FREE

Material:		DWG Details	SUB: FORGING, BARREL EXTENSION
Alt. Material:	DRAWN	SIGN	DATE
Hardness:	CHECKED	HOS/D&DO	FOR: BARREL EXTENSION
Finish:	HOS/PS6	Div. Officer / Prodn	PROJ.: M2HB GUN
		Div. Officer QC	Design Ref
		Div. Officer DDO	DWG. No.: 6528254-FORGE A3
			QPG -
			ORDNANCE FACTORY TIRUCHIRAPPALLI-16.
			Wt. (Appx) gm
			SHEET: 1 OF 1

PROJECT OFFICER HOS/PS6