

19.1.1884  
 100 (98)  
 DRG. NO. 64 C 5115 200 F3  
 TIRUCHIRAPALLI-16

**FORGING DRAWING** (5)

CHEMICAL COMPOSITION OF THE MATERIAL :- 30XPA

|    |             |    |             |
|----|-------------|----|-------------|
| C  | 0.28 - 0.33 | Si | 0.17 - 0.37 |
| Mn | 0.50 - 0.80 | Cr | 1.0 - 1.3   |
| Ni | 0.25 - 0.50 | S  | 0.025 MAX.  |
| P  | 0.025 MAX.  | Cu | 0.20 MAX.   |

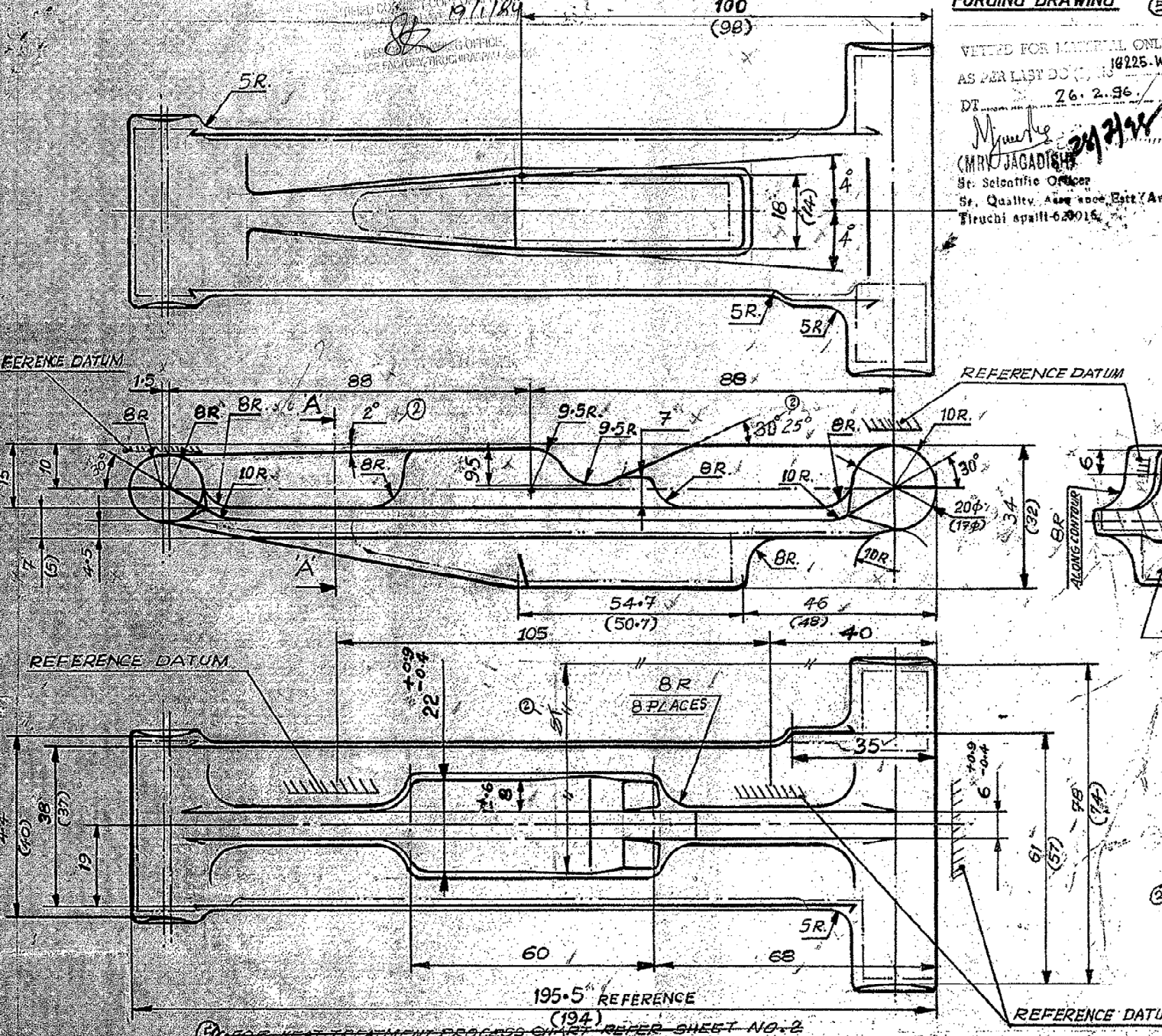
**FOR COMPONENT NO**  
**2A42-05-115 - CONNECTING LINK RIGID**

- DIMENSIONS ARE IN mm.  
 SCALE : 1:1  
 FIRST ANGLE PROJECTION.  
 HEAT-TREATMENT :- NORMALIZING; HARDNESS HB 217 MAX.  
 DE-SCALING :- SHOT-BLASTING PICKLING (2)  
 DISPLACEMENT OF DIE PARTING LINE SHOULD NOT EXCEED 0.8 mm.  
 MARKING: BY BLACKENING & STAMP; TO GOST 293  
 REMAINDER OF FLASH ON DIE PARTING LINE SHOULD NOT EXCEED 1.1 mm.  
 CURVATURE OF PLANE "S" SHOULD NOT EXCEED 0.4 mm.  
 UN-SPECIFIED DRAFT ANGLE 7°.  
 UN-SPECIFIED RADII 2.0 mm.

THE FINISHED COMPONENT SHOULD ATTAIN A HARDNESS RANGE HRC3 43.5 TO 51.5 AFTER FINAL HEAT-TREATMENT.

- ALLOWANCES AS PER CLASS II GOST 7505-74 M1  
 TOLERANCES AS PER CLASS II GOST 7505-74 C3 AND AS FOLLOWS:  
 VERTICAL:  $\pm 0.13$   
 HORIZONTAL:  $\pm 0.15$   
 DIE FORGING BY HAMMER.  
 NUMBER OF PARTS OBTAINED FROM ONE FORGING : 1 PIECE.  
 DIMENSIONS GIVEN IN BRACKETS ARE FOR MACHINING  
 WEIGHT OF THE FORGING 1.120 Kgs. 185  
 RAW MATERIAL SIZE  $38-50 \pm 0.4 \times 160$  LONG (HOT ROLLED)  
 MATERIAL :- 30XPA, GOST 30XPA-83 STEEL 30XPA OCT 3-98-83 INDIGENOUS. MATL. ADDED IN SHEET NO. 17.  
 QUALITY OF DIE FORGED SURFACE AS PER GOST 8479-70.  
 DIMENSIONS TO BE CHECKED; REMAINING DIMENSIONS ARE ENSURED BY DIE.  
 SURFACE DEFECTS SHOULD NOT EXCEED 0.4MM.

|            |                                      |
|------------|--------------------------------------|
| ①          | 10A No: 6379, 0622-10-92             |
| ②          | ANGLE 25° WAS 30°, DIM. 51 DELETED   |
| ④          | STORE DRG. NO. ADDED                 |
| B          | ANGLE 30° WAS 25° DIMENSION 51 ADDED |
| AMENDMENTS | DESCRIPTIONS/DETAILS                 |



|               |          |            |                   |                  |    |
|---------------|----------|------------|-------------------|------------------|----|
| SHEET NO. - 1 | 500 W    | 6/188      | ORDNANCE FACTORY  | DRG-NO:          | G3 |
| SHEETS - 2    | REDRAWN  | CHECKED    | TIRUCHIRAPALLI-16 | 64 C 5115 200 F3 |    |
|               | APPROVED | 1/C. PROJ. | WM/PROJ.          |                  |    |

ALB. No 364/57