



NOTES:-

1. DIMENSIONS ARE IN mm.
2. FIRST ANGLE PROJECTION.
3. SCALE :- 1:1.
4. FORGING OF GROUP II AS PER GOST 8479-70, HB 269 MAX.
5. DRAFT ANGLE 7°.
6. UN-SPECIFIED RADII 1.5R.
7. FLASH REMAINDER UP TO 0.9 mm.
8. WARPING UP TO 0.6 mm.
9. DIE SHIFTING UP TO 0.4 mm.
10. CONVENTIONAL CONTOUR AND DIMENSIONS GIVEN IN BRACKETS PERTAIN TO THE FINISHED PART.
11. STAMP PART NO, MELT NO, AND QCD STAMP ON THE TAG.
12. 5% OF A BATCH SHOULD BE CHECKED FOR HARDNESS AS PER GOST 8479-70.
13. WEIGHT OF THE FORGING 0.087 Kgs.
14. FORGING FOR TWO PARTS.

HEAT-TREATMENT:- FORGINGS ARE NORMALIZED AND TEMPERED FOR HEAT-TREATMENT SCHEDULE REFER DRAWING NO: M881 SHEET NO: 1 TO 3 AND SHEET NO: 5-1 SL. NO: 12, 1

MATERIAL:- STEEL 30XHZMΦA, OST 3-98-80

MATERIAL FOR INDIA- CONDITION 'W' DESIG. 31 N.10 Cr.3 Mo.6 WITH RESTRICTION OF 'S' & 'P' CONTENT UP TO 0.025% MAX. FOR EACH TO BE TESTED AS PER RG - 631170

ALT.MATERIAL : STEEL 30 X H2 Q A GOST 4543 - 71

NOTE
ACCEPTANCE STANDARDS FOR MACRO ETCH TEST & MICROSCOPIC DETERMINATION OF NON METALLIC INCLUSIONS FOR STEEL
1. MACRO ETCH TEST AS PER ASTM A-381 WITH ACCEPTANCE STANDARD AS C2, R2, S2
2. NMR TEST AS PER IS : 4163 - 82
STRESSED COMPONENT

CHEMICAL COMPOSITION AND MECHANICAL PROPERTIES OF MATERIAL

30 X H2 M Φ A	
C	0.27 - 0.34
Si	0.17 - 0.37
Mn	0.3 - 0.6
Cu	0.6 - 0.9
Ni	2.0 - 2.4
Mo	0.2 - 0.3
V	0.1 - 0.18
P	0.025 MAX
S	0.025 MAX
Cu	0.2 MAX
HARDNESS	269 HB
TENSILE STRENGTH	90 Kgf/mm ²
E LONGATION	10%
REDUCTION IN AREA	40%
IMPACT STRENGTH	9 KgfM/cm ²
YIELD POINT	80 Kgf/mm ²

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

UN CONTROLLED COPY

COMBINED FORGING FOR DRG NO 6P11-3-11
CATCH UPPER BOLT BREECH
DS. CAT. NO. 1005 007313
AND
DRG. NO. 6P11-3-12
CATCH LOWER BOLT BREECH
DS. CAT. NO. 1005-007304

VETTED FOR MATERIAL ONLY

Principal Scientific Officer,
Quality Assurance Officer,
For Senior Quality Assurance Officer,
Senior Quality Assurance Estt. (Armist)
Tiruchirappalli - 620 016.

E	DA NO. 001/17 DP. 01-03-17 DA NO. 26982-SA ON 08-03-16
D	COMPONENT DRG NO. 6P11-3-12 & DS. CAT. NO. ADDED Ref: DA NO. 2/19/2-12/11/01. 4-5-18
C	MATL. FOR INDIA AMENDED Ref: CG (ASA) Dtg. DE. 22-3-96
B	MATL. FOR INDIA ADDED
AMENDMENTS	
SIGN. & DATE	

REDRAWN	CHECKED	APPROVED	I/C, D & D.O.	DIV. OFFICER	ORDNANCE FACTORY, TIRUCHIRAPALLI-16.
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DRG NO: 62 C 3011 200 E3