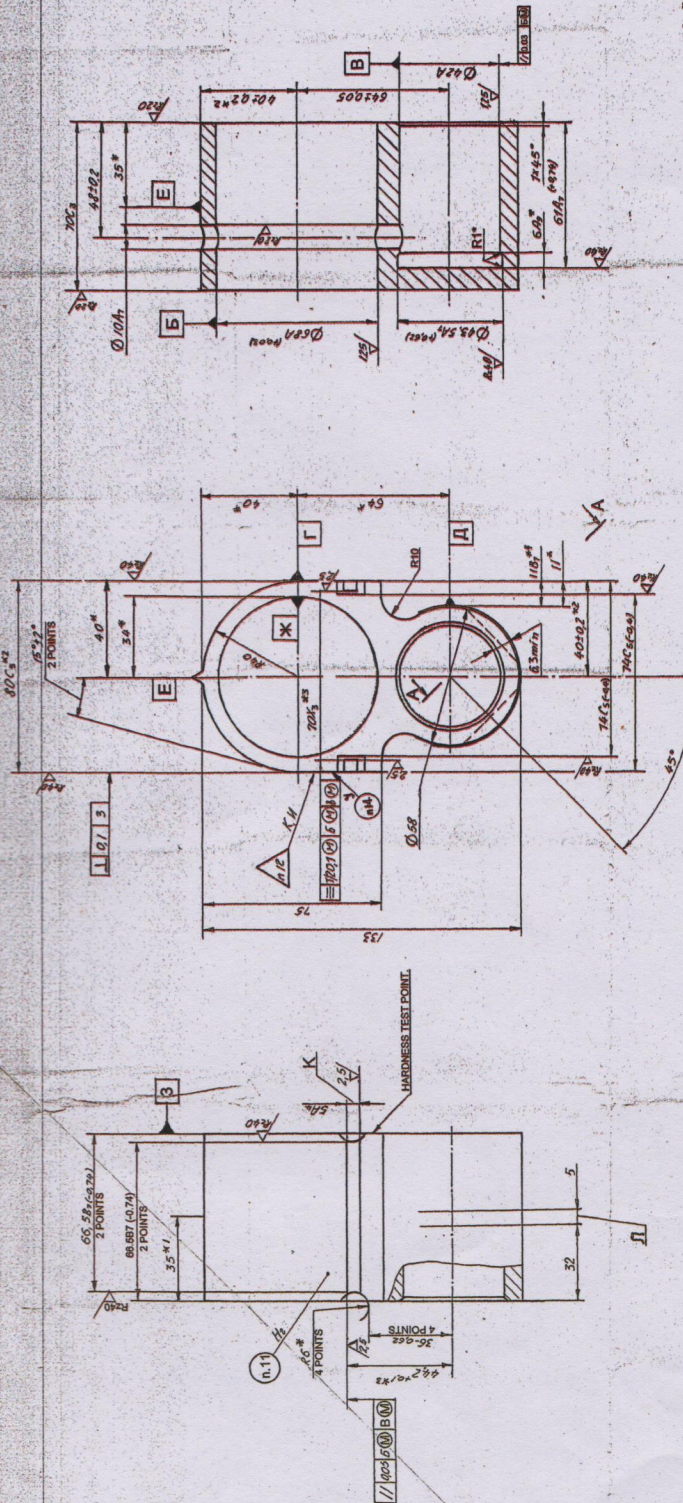


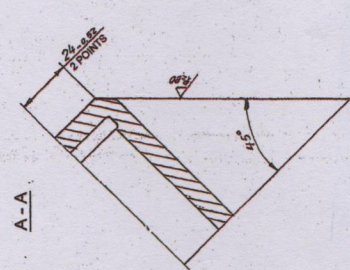
PART NO. 1005-560452



INDIGENOUS MATERIAL:-
 IS:10343-1993 OF BIL WITH
 HIGH PROPERTIES AT LOWER
 RE = 1000 MPa (Min)
 RE = 1000 MPa (Min)
 ELONGATION = 15% (Min)
 ON S-S V/S = 6.0 (Min)
 Z-RED OF AREA = 55.0 (Min)
 CHARPY IMPACT = 5.0 mts (Min)
 TENSILE = 5.0 mts (Min)

- Unpneumated casting radii are to be 2 mm.
- MS, 41.5 to 51.5.
- Additionally check impact strength in accordance with section 3, P002 977-75.
- Inner corners, R = 0.4 mm.
- Blunt edges, R = 0.6 mm.
- Flanges align by tools.
- MS is preset for bases I, H, X.
- R, Z Sizes are preset relative to surfaces I, H, Z.
- Sizes are preset relative to surfaces B and X.
- Coating: accelerated diethanol phosphating with chromate treatment/impregnation with adhesive B8-4, P002 1212-74 additionally coat outer surfaces (except for grooves X) with adhesive B8-4 with microfine, grade A, P002 9307-76, one coat 8700 sealers & abrasives B88 1008.
- Mark by type P0-3, P002 2930-62.
- Stamp.
- Dimension to be controlled in zone J.
- Mark serial No. of part with type P0-3, GO02 2930-62.

- (A) RADIOGRAPHIC ACCEPTANCE STANDARD OF THE CASTING SHOULD BE AS PER ASHTM B 31-75-REVISED EDITION.
 - (B) THE CASTING SAMPLE (NOT LESS THAN 5) WILL BE SUBJECTED TO RADIOGRAPHIC TEST.
 - (C) RADIOGRAPHIC TEST OF ADVANCE SAMPLES WILL BE CARRIED OUT BY CSA (MET) CHAPUR.
- OR
- THE AREA QUALITY ASSURANCE ENGINEER/INSPECTOR SHOULD GET THE SAMPLES FOR RADIOGRAPHIC TEST AND FORWARD THE RESULTS TO QUALITY ENGINEER FOR REVIEW AND APPROVAL OF THE MOLD. BULK PRODUCTION WOULD COMMENCE ONLY AFTER THE MOLD AND MATERIAL HAS BEEN APPROVED BY CSA (MET) CHAPUR.
- (D) 5% OF THE CASTING SELECTED AT RANDOM FROM THE BULK WOULD BE SUBMITTED TO RADIOGRAPHIC TEST. THIS MAY BE DONE UNDER THE SUPERVISION OF THE AREA QUALITY ASSURANCE OFFICER AND SENTENCE MAY BE AWARDED BY THE AREA QUALITY ASSURANCE OFFICER. SAMPLES CLEARED BY CSA (MET) CHAPUR.



MATERIAL - CASTING
 I- OCT 3-6555-79
 23:11C2.M4917Y.A4116-76

3-0-1018185-W	INDIS. MATL. AMENDED.	DRAWN	SCANNED - 304	CRD.	CRD.	JUST DRS.	CQAW, JABALPUR
17408 19181-W	C/S CAT No. ADDED.	CHK	CHK	CHK	CHK	DATE	
74-96	SCANNED & PRINTED WITHOUT CHANGE	CHK	CHK	CHK	CHK	SCALE: 1:1	
DATE	AMENDMENTS:	CHK	CHK	CHK	CHK	FOR COMMENTED: 1.77	
AUTHORITY	ZONE	CHK	CHK	CHK	CHK	MATERIAL: AS ABOVE	DESIGN No.
19121-WA, 19165-W, DT. 13-04-04		CHK	CHK	CHK	CHK	PROTECTIVE FINISH	PART No.
		CHK	CHK	CHK	CHK		2A42.02.026
		CHK	CHK	CHK	CHK		DRY No.
		CHK	CHK	CHK	CHK		1005-560452

UN CONTROLLED COPY
 CERTIFIED CORRECT COPY OF APPROVED
 DRAWINGS AT DATE 30/01/18

DESIGN DRAWING OFFICE,
 ORDNANCE FACTORY, TIRUCHIRAPPALI-620 016

HOLDER