

NOTE:

- 1) ALL DIMENSIONS ARE IN mm.
- 2) THE FINAL DIMENSIONS ARE GIVEN IN BRACKETS.
- 3) UNSPECIFIED TOLERANCES ARE AS PER IS 2102, (MEDIUM)
- 4) HARDNESS 363-429 HB TO BE CHECKED
FOUR PLACES ON SURFACE 'X' AT EQUI DISTANCE.
- 5) NON FLATNESS SHOULD NOT EXCEED 3mm.
- 6) NO WELDING IS PERMITTED ON THE RING
- 7) THIS IS BLANK FOR LOWER RING TO DRG NO. AK 630-119-1
- 8) BLUNT SHARP EDGES.
- 9) ALTERNATE METHOD: IT IS ALLOWED TO CUT RING FROM THE HOT ROLLED PLATE.
- 10) ULTRASONIC TEST AS PER ASTM/ASME A388/A388 M-11

AHSP-IHQ, MOD(NAVY) / DWE, NEW DELHI

HEAT TREATMENT SCHEDULE (FOR REFERENCE ONLY)	
	TEMPERATURE IN ° C
I. HARDENING	980-1030
II. TEMPERING	650-770

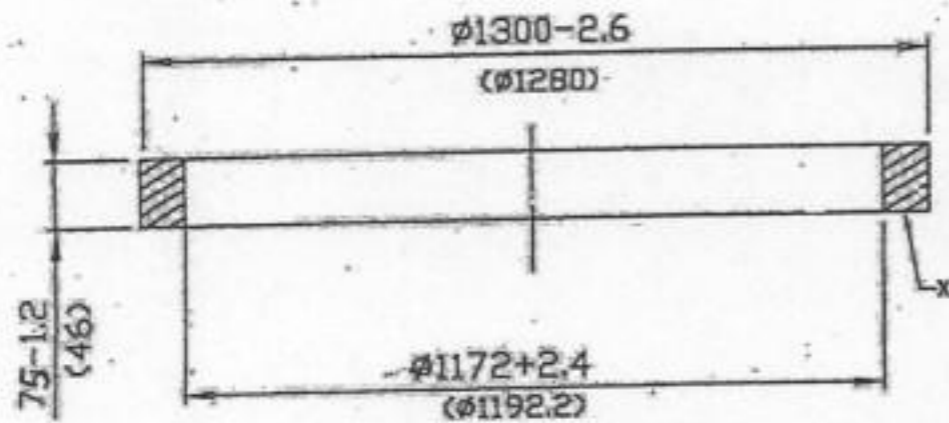
APPROVED BY:-

Rathin Kumar Das
21/8/13
JWM/CDO

GUN AND SHELL FY.

Rathin Kumar Das
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हथियार एवं शूला निर्माण / Gun & Shell Factory
कोसपोर, कोलकाता / Cossipore, Kolkata

SKETCH NO		AK- 630/SK/119-2	
USER	APPD	BLANK OF UPPER RING (FORGING)	SCALE WEIGHT
CHKD	NSR		
DRWN	BCD		
Gr. X20 Cr13 to IS:6911-92			



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AHSP-IHQ, MOD(NAVY) / DWE, NEW DELHI

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Rathore
21/8/13

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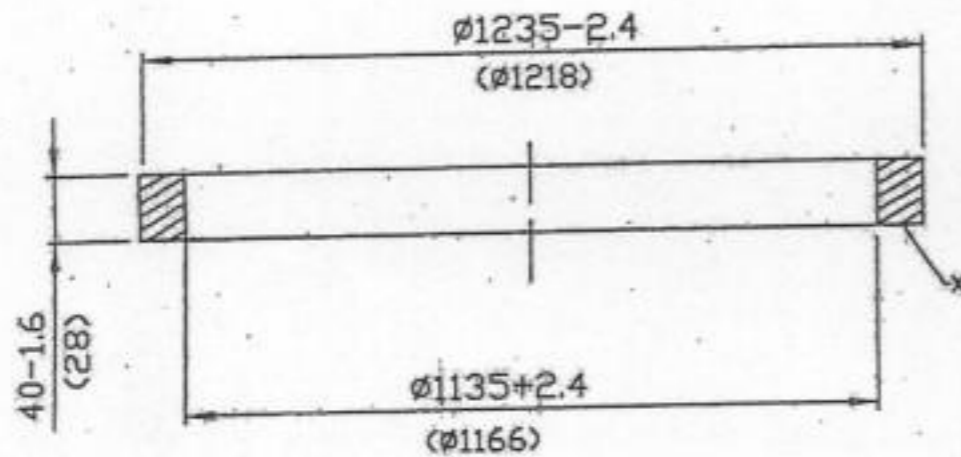
2404/epo

COSSIPORE, KOLKATA

Kumar Das
Jr. Works Manager
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तोप एवं गोला निर्माण / Gun & Shell Factory
कोलकाता-2 / Cossipore, Kolkata

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I HARDENING	980-1030
II TEMPERING	650-770

SKETCH NO			AK- 630/SK/119-1		
USER		BLANK OF LOWER RING (FORGING)		SCALE	WEIGHT
APP'D	HSP				
CHK'D	NSR				
DRWN	BCD				
Gr. X20 Cr13 to IS:6911-92					



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	TEMPERATURE IN °C
I HARDENING	980-1030
II TEMPERING	650-770

APPROVED BY:-
GUN AND SHELL FY.

COSSIPORE, KOLKATA-2

R. K. Das
21/8/13
JWM/WO

रथीन कुमार दस / R. K. Das
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SKETCH NO		AK- 630/SK/119-25		SCALE	WEIGHT
USER		BLANK OF INTERNAL RING (FORGING)			
APP'D	HSP				
DRWN	BCD	Gr. X20.Cr13 to IS:6911-92			