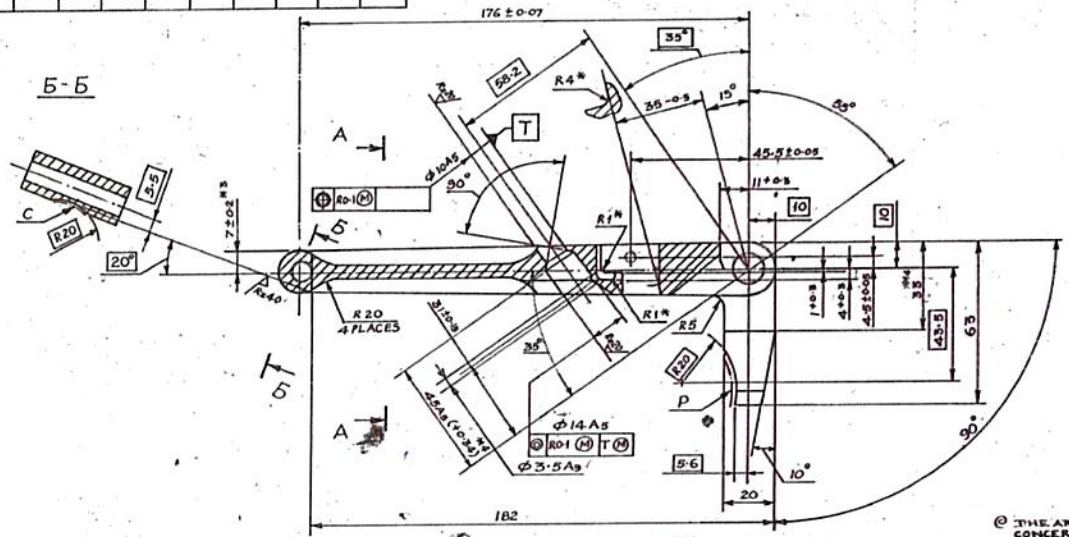
2A42.05.028

DIMENSIONS ARE IN mm.



IS:10343 -1999 GR 190

INDIGENOUS MATL :- ~~IS-10343-G-45~~ WITH C 0.45-0.50 ~~AND MECHANICAL PROPERTIES SPECIFIED IN THE SPECIFICATION FOR THE GRADE~~

DA.NO.001/2016 DT.01.01.2016

NOTES:-

1. UNSPECIFIED CASTING RADII. ARE 2 mm.
2. MACHINE REMAINDER OF GATING SYSTEM ON SURFACE 'H' TO DEPTH OF NOT MORE THAN 0·2 mm; TOLERABLE ROUGHNESS IS Ra80.
3. HRC, 41·5 ---------- 51·5.
4. ADDITIONALLY PERFORM CHECK OF IMPACT STRENGTH ACCORDANCE WITH SECTION 3, GOST 977-75.
5. INNER CORNERS WITH R≤ 0·4 mm.
6. BLUNT SHARP EDGES TO R≤ 0·6 mm.
7. * ENSURE SIZES BY TOOLS.
8. * 2 SIZES GIVEN IN RELATION TO BASES A, E, ЖС, З, И, К.
9. * 3 SIZES GIVEN IN RELATION TO BASES Г Ⓜ AND З.
10. * 4 SIZES GIVEN IN RELATION TO BASES В Ⓜ & Г Ⓜ.
11. * 5 DIMENSIONS ARE GIVEN FOR BASE A & E.
12. * 6 SIZES GIVEN FOR BASE И.
13. * 7 SIZES GIVEN FOR BASE К.
14. * 8 SIZES GIVEN FOR BASE ЖС.
15. TOLERANCE ALONG CONTOURS P&C IN RELATION TO SURFACES Ⓓ & Г Ⓜ IS 0·3 mm.
16. KNIT MARKS ARE PERMISSIBLE IN CASE OF MACHINING OF SLOTS M & П WITH IN TOLERABLE LIMITS.
17. COATING :- ACCELERATED ELECTROLESS PHOSPHATING WITH CHROMATE TREATMENT/ IMPRIGNATION WITH ADHESIVE 5 Ф-4, GOST 12172-74, WITH NIGROSINE MARK A GOST 9307-79, ONE COAT OIL NON-PAINTED SECTIONS.
18. MARKS WITH TYPE ПО-5, GOST 2930-62.
19. STAMP.
20. AFTER THERMAL TREATMENT CHANGE OF SIZE Ø FROM 2·0 TO 4·0 mm IS PERMISSIBLE WITH SUBSEQUENT MACHINING. OF SURFACE Ф Ra80 UNFINISHED AREA IS NOT RATED.
21. REMAINDER OF POURING GATE 0·3 mm HIGH MAX IS PERMISSIBLE.
22. MARK THE ORDINAL NUMBER OF PART WITH TYPE ПО-3 GOST 2930-62.
23. RADIOGRAPHIC ACCEPTANCE STANDARD OF THE CASTING SHOULD BE AS PER ASTM-E-446-84, LEVEL II.
24. (a) 100% OF THE ADVANCE SAMPLE (NOT LESS THAN 5) WILL BE SUBJECTED TO RADIOGRAPHIC TEST.
    (b) RADIOGRAPHIC TEST OF ADVANCE SAMPLES WILL BE CARRIED OUT BY CQA(MET) ICHAPUR.

@ THE AREA QUALITY ASSURANCE OFFICER CONCERNED WOULD GET THE RADIOGRAPHIC TEST DONE IN HIS PRESENCE AND FORWARD THE PLATES TO CQA(MET) ICHAPUR FOR SENTENCE AND APPROVAL OF THE MOULD

@ BULK PRODUCTION WOULD COMMENCE ONLY AFTER THE MOULD AND MATERIAL HAS BEEN APPROVED BY CQA(MET) ICHAPUR;

@ 3% OF THE CASTING SELECTED AT RANDOM FROM THE BULK WOULD BE SUBJECTED TO RADIOGRAPHIC TEST. THIS MAY BE DONE UNDER THE ARRANGEMENT OF THE AREA QUALITY ASSURANCE OFFICER AND SENTENCE. BAY BE AWARDED BY HIM BASED ON THE STANDARD OF THE ADVANCE SAMPLES CLEARED BY CQA(MET) ICHAPUR.

@ OK

C 5028

UN CONTROLLED COPY
CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE... 21/9/23 ...
DESIGN & DRAWING OFFICE,
ORDNANCE FACTORY, TIRUCHIRAPPALI -620 016.

@ Reg: CQA(M) Lr.No. 18218 CQM, Dt 30.12.2008. Authority: 240A-15 No. CQM/M1/03/2008 Dt. 18 MAR 2008.

DATE	AUTHORITY	ZONE	NATURE OF AMENDMENTS
22-9-95	18174-W		PROV SEALING CANCELLED & DRG SEALED:
26-2-97	17234-W		DRG SEALED PROV.
16-3-98	18100-W		INDIGS MATL & NOTE NO.24 ADDED.
29-9-98	17755-W		DIM 37.0±0.15 WAS 37.0±0.15* ADDED.
1-1-92			NEW POLY. NEGATIVE PREPARED
14.09.15	19446-W		MATL AMENDED DA NO.001/2016 Dt.01.01.2016
18-03-08	19118-W		DS CAT. No. ADDED & NOMENCLATURE AMENDED
13-1-88	18815-W		HINDI NOMEN ADDED
	18383-W		INDIGS MATL AMENDED
	18149-W		INDIGS. MATL. AMENDED.

DRG SEALED:- 18174-W 22-9-95

DO CQA(W)

CONNECTING LINK RIGID.

LOWER LINK लोअर लिंक

DRAWN	CHD	ASSY DRG	CQA(W) JABALPUR
TRACED:	CHD	DATE	
	PAINT:	SCALE:- 1:1	
C/D'MAN	DO	FORGING	ESTD MASS:- 0·7
MATL:		DESIGN No	
PROTECTIVE FINISH		PART No	2A42.05.028
		DS CAT No	3040-022424