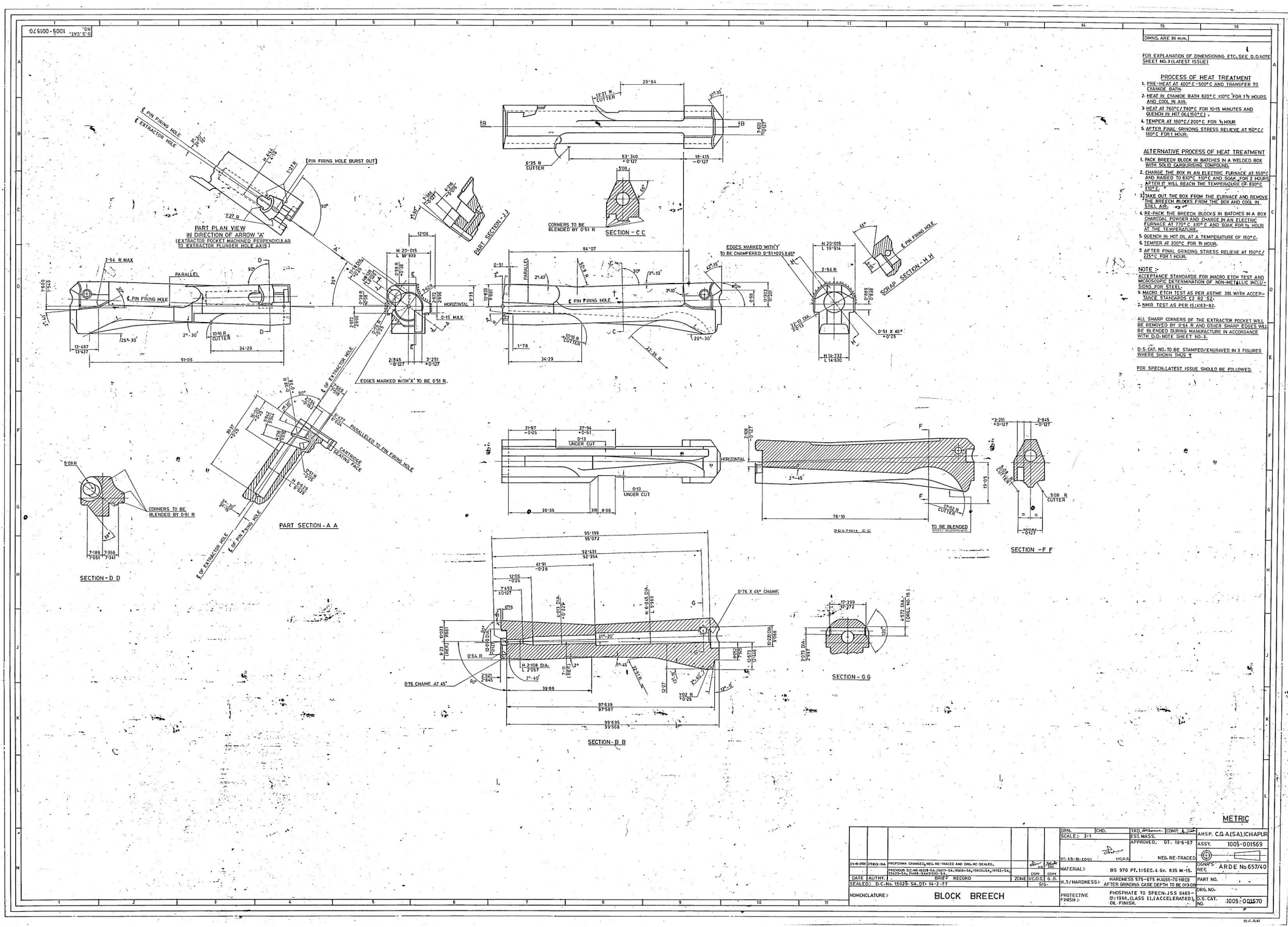

DIMNS. ARE IN mm.

FOR EXPLANATION OF DIMENSIONING ETC., SEE D.D.NOTE SHEET NO. 3 (LATEST ISSUE)

PROCESS OF HEAT TREATMENT

1. PRE-HEAT AT 400°C - 500°C AND TRANSFER TO CYANIDE BATH.
2. HEAT IN CYANIDE BATH 820°C ±10°C FOR 1½ HOURS AND COOL IN AIR.
3. HEAT AT 760°C / 780°C FOR 10-15 MINUTES AND QUENCH IN HOT OIL (150°C).
4. TEMPER AT 180°C / 200°C FOR ½ HOUR
5. AFTER FINAL GRINDING STRESS RELIEVE AT 150°C / 180°C FOR 1 HOUR.

ALTERNATIVE PROCESS OF HEAT TREATMENT

1. PACK BREECH BLOCK IN BATCHES IN A WELDED BOX WITH SOLID CARBURISING COMPOUND.
2. CHARGE THE BOX IN AN ELECTRIC FURNACE AT 550°C AND RAISED TO 830°C ±10°C AND SOAK FOR 2 HOURS. AFTER IT WILL REACH THE TEMPERATURE OF 830°C ±10°C.
3. TAKE OUT THE BOX FROM THE FURNACE AND REMOVE THE BREECH BLOCKS FROM THE BOX AND COOL IN STILL AIR.
4. RE-PACK THE BREECH BLOCKS IN BATCHES IN A BOX CHARCOAL POWDER AND CHARGE IN AN ELECTRIC FURNACE AT 770°C ±10°C AND SOAK FOR ½ HOUR AT THE TEMPERATURE.
5. QUENCH IN HOT OIL AT A TEMPERATURE OF 150°C.
6. TEMPER AT 200°C FOR ½ HOUR.
7. AFTER FINAL GRINDING STRESS RELIEVE AT 150°C / 225°C FOR 1 HOUR.

NOTE :-

ACCEPTANCE STANDARDS FOR MACRO ETCH TEST AND MICROSCOPIC DETERMINATION OF NON-METALLIC INCLUSIONS FOR STEEL.

1. MACRO ETCH TEST AS PER ASTME 381 WITH ACCEPTANCE STANDARDS C2 R2 S2.
2. NMIR TEST AS PER IS:4163-82.

ALL SHARP CORNERS OF THE EXTRACTOR POCKET WILL BE REMOVED BY 0·64 R AND OTHER SHARP EDGES WILL BE BLENDED DURING MANUFACTURE IN ACCORDANCE WITH D.D. NOTE SHEET NO. 3.

D.S. CAT. NO. TO BE STAMPED/ENGRAVED IN 3 FIGURES WHERE SHOWN THUS ↑

FOR SPECN. LATEST ISSUE SHOULD BE FOLLOWED.

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