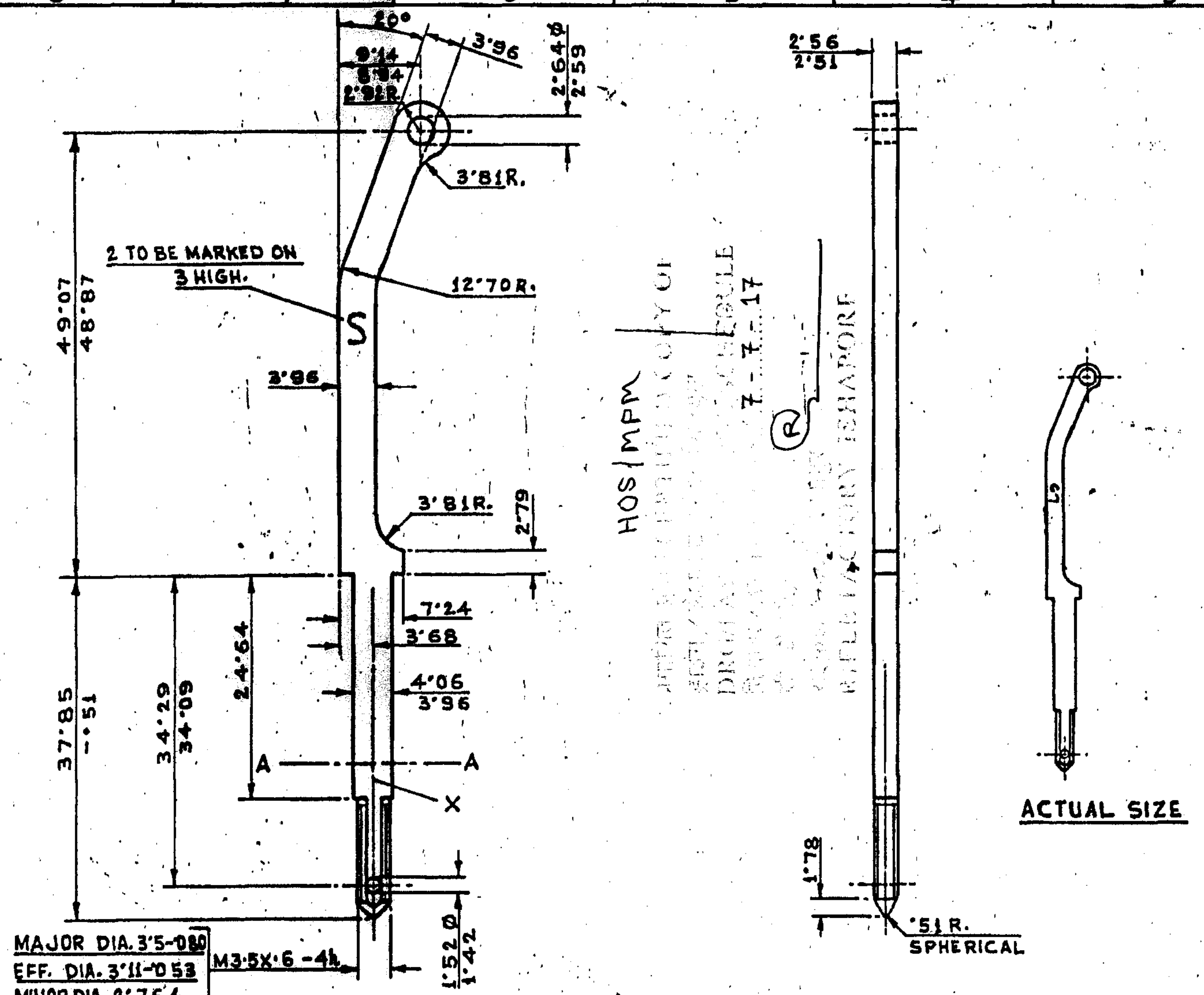
FOR EXPLATION OF DIMENSIONING ETC.
SEE CSAID NOTE SHEET No.1 (LATEST ISSUE).



MAJOR DIA. 3'5-0'080
EFF. DIA. 3'11-0'053
MINOR DIA. 2'764
(ROOT CLEARED)
THREADS TO SPECN.
IS: 4218-1967

(a). MACROETCH TEST TO ASTME 381-1984 WILL BE AS PER COL. (c) OF SL. NO. 1 OF CQA(SA) NOTE SHEET NO. 1.
(b). NMIR TEST TO IS: 4163 WILL BE AS PER COL. (c) OF SL. No. 3 OF CQA(SA) NOTE SHEET NO. 1.

MATERIAL :-

IS: 2507-1975 DESIGNATION 80C6.

HEAT TREATMENT :-
LOCALLY HARDEN AND TEMPER THREAD END FROM LINE A-A TO A D.P.N. 350-420 EQUIVALENT TO ROCK WELL 'D' 52-59 TESTED AT POINT 'X'.

PROTECTIVE FINISH :-
PHOSPHATE TO SPECN. JSS 0465-01: 1988 CLASS II (ACCELERATED), OIL FINISH.

NOTE :-
CORNERS & FILLETS TO BE RADIUSED TO '38 MAX. R.

~~ACCEPTANCE STANDARDS FOR MACRO ETCH TEST AND MICROSCOPIC DETERMINATION OF NON METALLIC INCLUSIONS FOR STEEL~~
~~I) MACRO ETCH TEST AS PER ASTME 381 WITH ACCEPTANCE STANDARD AS C2 R2 S2.~~
~~II) NMIR TEST AS PER IS: 4163-82.~~

HOS/MPM
7-7-17
R.FLE FACTORY ICHAPORE

AUTHY.	DATE	ZONE	BRIEF RECORD	SIG.
26826-SA	06.05.16		MATERIAL AMENDED.	
25056-SA	02-7-2001		D.S. CAT. NO. 3040-003489 WAS 1005-003161.	
22540-SA	19.8.94		NOTE FOR MACROETCH TEST AND NMIR TEST AMENDED	
22523-SA	4-5-94		PROFORMA CONVERTED TO A3 S/ZE NEG. RE-TRACED AND DRG. RE-SEALED.	
			PREVIOUS D.C. NOS. 10688-SA, 11258-SA, 14446-SA, 15303-SA, 20624-SA, 20638-SA, 21586-SA, 21963-SA & 22156-SA.	COPY

	DATE	NAME
DGN.		
DRN.		
CHD.		
TRD.	7.1.94	
COMP.		

DT. 6.5.94 I/C D.O.
SCALE :- 2:1
SEALED :- D.C. No. 11258-SA, DT. 5.5.72

ASSY. 1005-003159
MATERIAL :- AS STATED
DIMENSIONS ARE IN MILLIMETRES

LINK, HAMMER

CQA(SA) ICHAPUR
APPROVED. DT. 2.8.67
NEG. RE-TRACED
DESIGNER'S REF. CISA/333/3/1
D.S. CAT. NO. 3040-003489

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