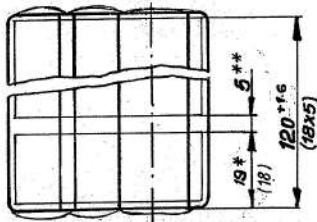


CERTIFIED CORRECT COPY
OF APPROVED DRAWINGS
AT THIS DATE.....

17.11.2020

Design & Drawing Office
Ordnance Factory,
Tiruchirappalli-620016

UN CONTROLLED COPY



NOTE

ACCEPTANCE STANDARDS FOR MACRO ETCH TEST & MICROSCOPIC DETERMINATION OF NON METALLIC INCLUSIONS FOR STEEL
1. MACRO ETCH TEST AS PER ASTM- 381 WITH ACCEPTANCE STANDARD AS C2, R2, S2

2. NMR TEST AS PER IS : 4163 - 82 ✓

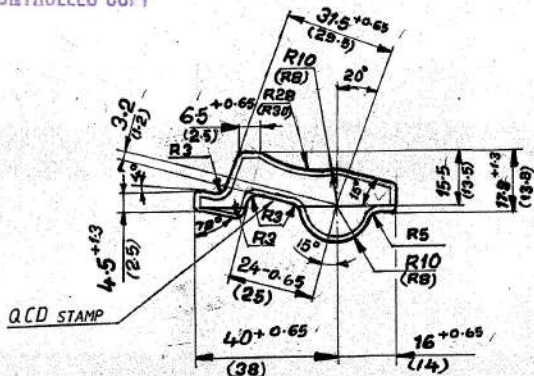
MATL FOR INDIA :

BS-990-PT-1-1993 GR-826-M-31-OR IS : 5517 - 78
DESIG 31 Ni 10 Cr 3 Mo 6 WITH RESTRICTION OF 'S' & 'P'
CONTENT UP TO 0.025 % MAX. FOR EACH

STRESSED COMPONENT

**CHEMICAL COMPOSITION
AND MECHANICAL PROPERTIES
OF MATERIAL**

30XH2MΦA	
C	0.27 - 0.34
Si	0.17 - 0.37
Mn	0.30 - 0.60
Cr	0.60 - 0.90
Ni	2.00 - 2.40
Mo	0.20 - 0.30
V	0.10 - 0.18
S	0.025 MAX.
P	0.025 MAX.
Cu	0.20 MAX.
HARDNESS HB269	
ELONGATION	10%
REDUCTION IN AREA	40%
IMPACT STRENGTH	9 Kgf M / CM ²
TENSILE STRENGTH	90 Kgf / MM ²
YIELD POINT	80 Kgf / MM ²



NOTES:-

1. DIMENSIONS ARE IN mm.
2. FIRST ANGLE PROJECTION.
3. SCALE :- 1:1
4. FORGING OF GROUP II AS PER GOST 8479-70, HB 269 MAX.
5. DRAFT ANGLE 7°.
6. UN-SPECIFIED RADII 2R
7. FLASH REMAINDER UP TO 0.3 mm.
8. WARPING UP TO 0.6 mm.
9. DIE SHIFTING UP TO 0.6 mm.
10. CONVENTIONAL CONTOUR AND DIMENSIONS GIVEN IN BRACKETS PERTAIN TO THE FINISHED PART.
11. STAMP PART NO, MELT NO, AND Q.C.D STAMP ON THE TAG.
12. 5% OF A BATCH SHOULD BE CHECKED FOR HARDNESS AS PER GOST 8479-70.
13. WEIGHT OF THE FORGING 0.770 Kgs.
14. FORGING TO BE DONE FOR 5 PARTS.
15. * DIMENSIONS FOR REFERENCE.
16. ** DIMENSIONS FOR TOOLING.

HEAT-TREATMENT:-FORGINGS ARE NORMALIZED AND TEMPERED.
FOR HEAT-TREATMENT SCHEDULE REFER DRAWING
NO: M 881 SHEET NO: 1 TO 3 AND SHEET NO: 6 SL NO: 21.

MATERIAL:-

STEEL- 30XH2MΦA... OST 3-98-30 ✓

ALT. MATERIAL:

STEEL 30 X H 2 M Φ A GOST 4543 - 71 ✓

VETTED FOR MATERIAL ONLY

[Signature]
Principal Scientific Officer,
Quality Assurance Officer,
For Senior Quality Assurance Officers,
Senior Quality Assurance Estt. (Grade),
Tiruchirappalli-620 016.

COMPONENT DRG. NO. 6PII-7-3
SEAR

DRAWING PROVISIONAL

DS. CAT NO. 1005007168

B	DA.No. 003/17 Dt. 16.06.17 Matl. Amended						
	<i>[Signature]</i> REDRAWN	<i>[Signature]</i> CHECKED	<i>[Signature]</i> V.C. D&DO	11.8.9 APPROVED	<i>[Signature]</i> DIV. OFFICER	ORDNANCE FACTORY, TIRUCHIRAPALLI-16.	DRG. NO: 62 C 7003 200 B 3