

MATER. :- STEEL 35XFC1 GOST 977-75  
 TECH. REQT. FOR CASTING ARE AS PER T7 B3-65-88 (v.2)  
 CHEMICAL COMP. IS AS PER GOST 977-75.

**MATERIAL COMPOSITION**

a) CHEMICAL COMPOSITION CONFORMING TO OEM MATERIAL GRADE  
 STEEL 35XFC1 OF GOST 977-75 TO BE USED TO ACHIEVE SPECIFIED  
 MECHANICAL PROPERTIES OF OEM OR IS:10343-1999 GRADE 16-Q.  
 b) MATERIAL COMPOSITION TO BE FOLLOWED IS AS UNDER :-

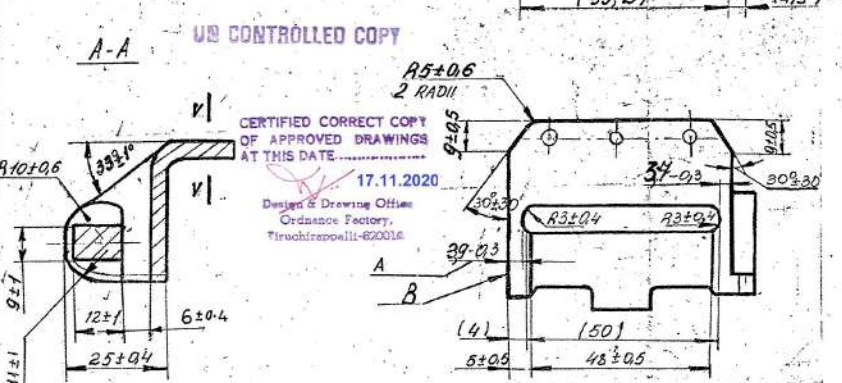
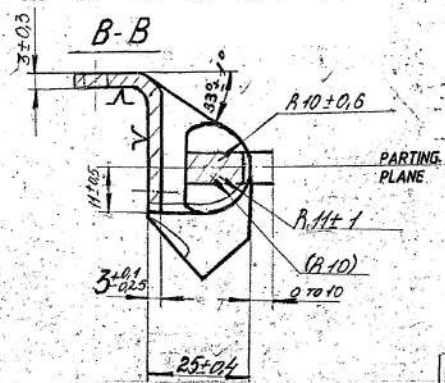
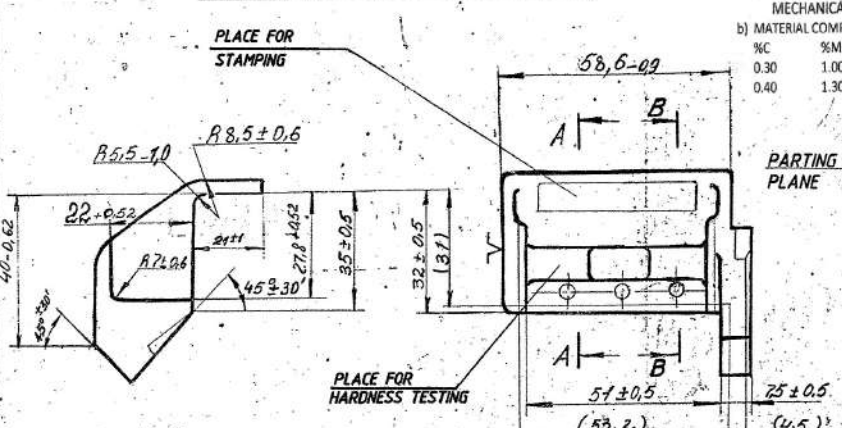
%C	%Mn	%SI	%Cr	%Ni	%Cu	%P	%S
0.30	1.00	0.60	0.60	0.30	0.30	0.040	0.040
0.40	1.30	0.80	0.90	max	max	max	max

DA.No. 001/20 AS PER DC.No: 27193-SA, Dt. 08.04.19  
 amended on 22.02.20

Details to be marked on the Tag

Sl.no. of Tag  
 Batch no.  
 No. of compts. in the Batch  
 Insp. mark of mould check

DA No. 001/19 Dt. 25/11/19  
 GOST MARK ADDED  
 REF. 6061/12/14 Dt. 01/11/19  
 DA No. 001/17 Dt. 01.03.17 MATE. AMENDED  
 DA.12.198 Dt. 12.27.19 DE. 30.11.19 S.P.A.  
 MATE. FOR INDIA AMENDED  
 DC. NO. 24192-59 Dt. 24.10.19



HARDNESS HB 241 MAX.

1. SURFACE ROUGHNESS OF CASTINGS AS PER STANDARD.
2. DRAFT ANGLE IS UP TO 1°.
3. UNSPECIFIED CASTING RADII UP TO 1mm.
4. MISALIGNMENT ALONG PARTING PLANE UPTO 0.2mm.
5. SINKAGE OF TRACES DUE TO EJECTOR IS PERMITTED UPTO 0.5mm. ON WORKING SURFACES.
6. STAMP THE SL. NO. OF THE TAG ON WHICH THE DETAILS ARE MARKED STAMP INSPECTION MARK
7. SECTION V-V FOR MEASURING DEPTH OF DECARBURIZED LAYER.
8. ON SURFACE 'B' PROJECTION DUE TO PARTING PLANE OF THE DIE IS TO BE GROUND.
9. DECREASE OF DIMENSION 'A' UP TO 34mm IS PERMITTED.
10. REFER ATTACHED SHEET FOR HEAT TREATMENT PROCESS DRG.No. M 882
11. DIMNS WITHIN ( ) INDICATE AFTER MACHINING.

MATERIAL FOR INDIA :- IS:10343-1999 GRADE 16Q  
 BS:5146 Pt.1:74 TYPE C1A 120R A 40 CR B CASTINGS  
 RADIOGRAPHIC TEST AS PER ASTM-E-192 WITH ACCEPTANCE STANDARDS FOR GAS HOLE AND FOREIGN MATERIALS LEVEL-5  
 SHRINKAGE [ALL TYPES] LEVEL-3 ALSO REFER CQA(MET) ICHAPUR  
 INSPECTION INSTRUCTION NO. MRA-1/QA-1/12 Dt. 5-5-94 FOR OTHER DETAIL  
 COMPONENT DRG NO. 6P11-6-19  
 BRACKET HOLDING FRONT COVER

E	DA NO. 7/18 Dt. 27.7.698	S. R. P. 2648	MATERIAL FOR INDIA ADDED	SHEETS : 1	1ST ANGLE PROJECTION	DRAWN	I/C PROJ.	CASTING DRG. 6P11-6-19
	DA NO. 14/95 Dt. 3-9-95							

DS.CAT NO. 1005007440

APPROVED FOR MATERIAL ONLY  
 Quality Assurance Officer,  
 Ordnance Factory,  
 Tiruchirappalli-620016