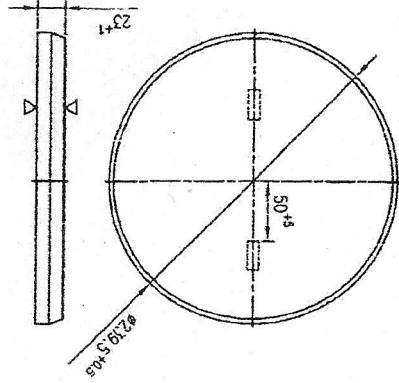


REFER CC-417

DRG. NO. - CC-548

PROVISIONAL



NOTE:
 1) BLANKS ARE TO BE PUNCHED/MACHINED OUT FROM ROLLED STRIPS, MANUFACTURED FROM HIGH GRADE MILD KILLED STEEL OF GRADE 11 10A TO SPECIFICATION GOST B 19032-73, DEOXIDISED BY ALUMINIUM WITH FOLLOWING CHEMICAL COMPOSITION, (ESR QUALITY PREFERABLE)

C%	Mn%	Si%	P%	S%	Cr%	Ni%	Cu%	Al%
0.09-0.13	0.30-0.50	0.13	0.025	0.025	0.20	0.15	0.20	0.03-0.09
NOT MORE THAN								
NITROGEN CONTENT 50 PPM MAX.								

2) BLANKS ARE TO BE HEAT TREATED (HARDENED & TEMPERED) FOLLOWED BY PICKLING. THE SURFACE OF DISKS/STRIPS.
 3) PROPERTIES OF BLANK :
 TENSILE = 34-41 kgf/mm²
 RELATIVE ELONGATION = 35% min.
 IMPACT STRENGTH (AFTER MECHANICAL AGEING) ALONG ROLLING NOT LESS THAN 15.0 kgfm/cm² ACROSS ROLLING NOT LESS THAN 9.0 kgfm/cm² IMPACT STRENGTH AS PER GOST 9454-78, MECHANICAL AGEING AS PER GOST 7268-67 WITH DEFORMATIONS DUE TO COMPRESSION.

- 4) ULTRASONIC TESTING AS PER COA(M) INSTRUCTION NO. MDA-2/UST/2/97.
- 5) INSPECTION OF THE MACRO STRUCTURE IS TO BE CARRIED OUT IN DISKS AND STRIPS. THE PRESENCE OF COARSE GRAINS IN THE SURFACE LAYER, BREAK IN THE CONTINUITY OF METAL IN THE FORM OF SEPARATION OF LAYERS, TRACES, SHRINKAGE POROSITY, BLOW HOLES AND OTHER ROUGH DEFECTS ARE NOT PERMITTED.
- 6) MICRO STRUCTURE OF STEEL SHOULD CONSIST OF EQUAXIAL FERRITE GRAINS AND UNIFORMLY ARRANGED GRANULAR OR SORBITIC PEARLITE WITH COMPLETE ABSENCE OF WIDMANSTATTEN PATTERN OF FERRITE.
- FOLLOWING HEAT TREATMENT SCHEDULE IS SUGGESTED TO ACHIEVE THE MICRO STRUCTURE AND OTHER PROPERTIES-
- a) AUSTENITIZE AT 900°C
 - b) QUENCH IN WATER
 - c) TEMPER AT 680°C/700°C FOR AT LEAST 28 HOURS.
- IT IS TO BE NOTED THAT THE ABOVE SCHEDULE IS ONLY FOR GUIDANCE OF MANUFACTURER / SUPPLIER & IT DOES NOT ABSOLVE THE MANUFACTURER/SUPPLIER OF THE RESPONSIBILITY OF GIVING CORRECT MICRO-STRUCTURE & OTHER PROPERTIES AS PER THE SPECIFICATION.
- 7) EVERY BLANK SHOULD BE MARKED WITH CAST NUMBER AT 'A' ON SMALLER DIA.
- 8) TOP & BOTTOM SURFACES OF BLANKS SHOULD BE CLEANED BY GRINDING/MACHINING SO AS TO OBTAIN EVEN & SMOOTH SURFACE.
- 9) DURABLE PROTECTIVE COATING SHOULD BE APPLIED TO AVOID RUSTING & CORROSION DURING TRANSPORT & STORAGE.
- 9) FOR ALL OTHER CONDITIONS GOST B19032-73 IS PERTINENT
- 10) BLANK SHOULD HAVE BLUE COLOUR PAINT MARK ON THE OPPOSITE SIDE OF CAST NO. FOR IDENTIFICATION.
- SPECIAL NOTE:
 1. THICKNESS LESS THAN SPECIFIED WILL NOT BE ACCEPTED.
 2. THE ANGLE AND CHAMFERED SHOWN IN THE DRG. IS ACTUALLY THE CLEARANCE BETWEEN THE DIE AND PUNCH PROVIDED FOR FACILITATING BLANKING OPERATION ONLY. AS SUCH THE ANGLE AND CHAMFER ARE NOT SPECIFICALLY MENTIONED & IS NOT IMPORTANT.
 3. ROUNDNESS 1mm (ASYMMETRICALLY) IS ALLOWED.
 4. INCOMPLETE SHAPE OF ROUND, TEARS, SWELLING ALONG THE CIRCUMFERENCE, ROUGH DENTS, RUPTURE, SEAMS OF METAL, DEEP SCRATCHES, BURRS ARE NOT ALLOWED.
- WEIGHT OF BLANK = 8.35 kg (Approx).

AMENDMENTS		REV.	DATE	DESCRIPTION	SIGN.

APPROV.	HOS/CCS	DGM/CCS

2016	NAME	DATE

2016	DRAWN	CHECKED	HOS/CDD	JWM/CCS

THIRD ANGLE PROJECTION	SCALE : 1:4

ALTERNATIVE STEEL REF 2503	STEEL 11 10A TO GOST B 19032-73

DRG. NO. :	NOMENCLATURE	STORE:
CC-548	SLUC	AK-100 NAVAL

NO. OF SHEETS-	OPERATION NO -	COMPT.
1	1	CARTG. CASE

COMP. CASE NAM(1) SK-851