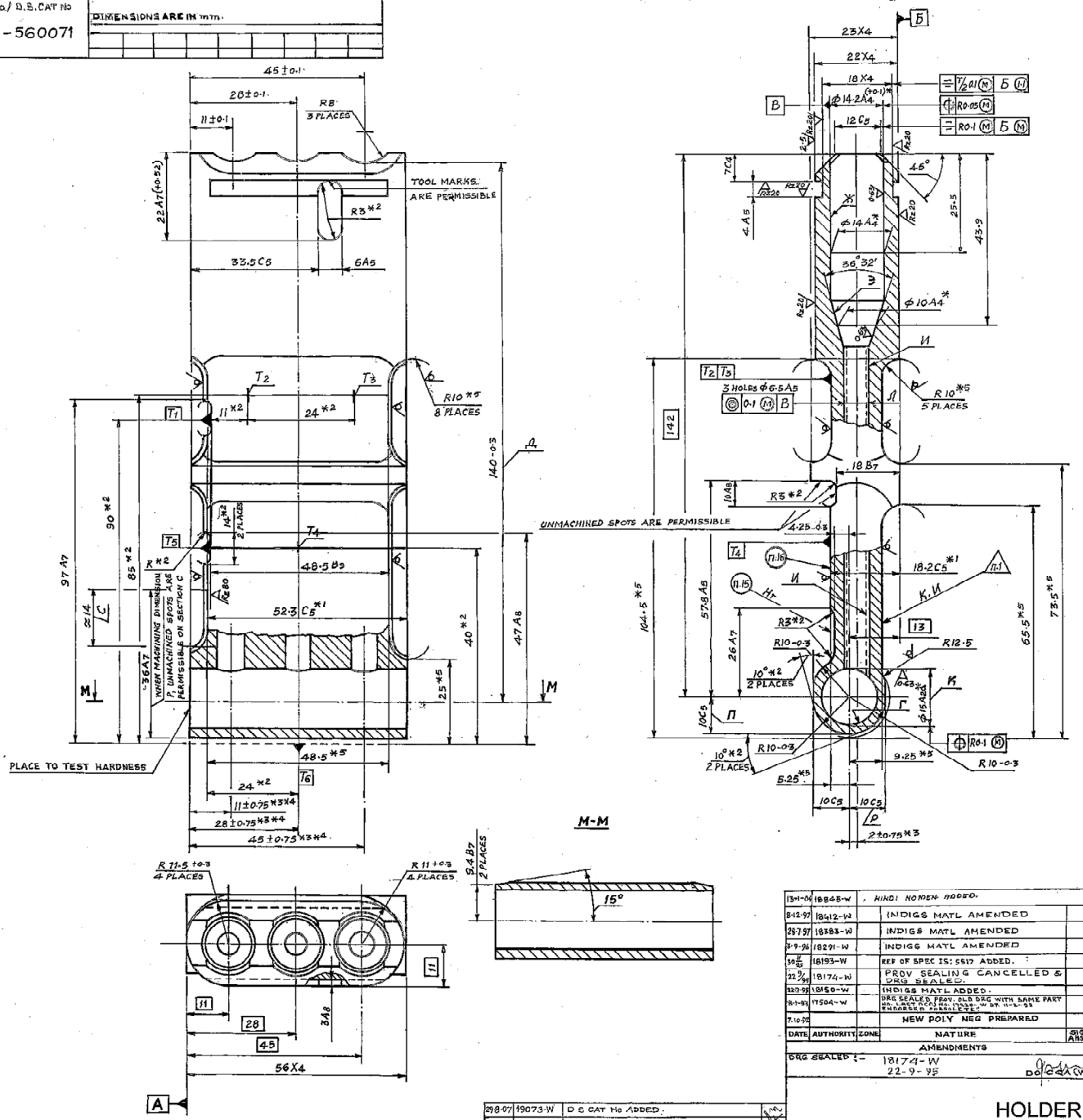
PART No./ D.S. CAT No
1005-560071

DIMENSIONS ARE IN mm.



NOTES:-

1. BLANK - FORGING AS PER GOST 7505-74, CLASS II.
2. FORGED SURFACES FINISHING IS AS PER GOST 8479-70.
3. 39.5 ..... 46.5 HRC ϑ.
4. * DIMENSIONS GIVEN AFTER COATING.
5. *1 DIMENSIONS GIVEN RELATIVE TO DATUMS T1 ..... T6, TO BE CONTROLLED BEFORE DIMENSION П IS ENSURED.
6. *2 DIMENSIONS ENSURED BY TOOL.
7. *3 DIMENSIONS GIVEN FOR ACCEPTABLE DEVIATIONS OF THE HOLE Л AXIS WHERE THOSE, HOLES ENTER HOLE K. THE TOLERANCE IS DEPENDABLE (MMC)
8. *4 DIMENSIONS GIVEN IN THE PLANE OF DIMENSION Л TOLERANCE IS DEPENDABLE (MMC)
9. *5 DIMENSION IN THE BLANK.
10. INTERNAL CORNERS: R≈ 0.4 mm
11. RIBS TO BE BLUNTED TO R≈0.6 mm
12. INCREASE OF DIMENSION K UPTO 15.04 mm OVER THE 3 mm LENGTH FROM THE FACE ENDS IS ACCEPTABLE.
13. WHEN DIMENSION Д IS ENSURED CHROME EXCESS ON THE SURFACE И IS PERMISSIBLE.
14. THE SURFACES Г, Ж, Э - COATING IS Cr 15 TO Cr 30 HARD SURFACE И COATING IS CHEMICAL PHOSPHATING ACCELERATED CHROMOTIZED, OTHER SURFACES - CHEMICAL PHOSPHATING ACCELERATED, CHROMOTIZED/IMPREGNATED WITH NIGROSIN GRADE A (i) УХ Л1 GLUE 6Ф-4, GOST 12172-74 NIGROSIN GRADE A GOST 9307-78.
15. STAMPING WITH TYPE П0-5 GOST 2930-62.
16. STAMPING SERIAL NUMBER OF THE COMPONENT WITH TYPE П0-5 - GOST 2930-62 BY PUNCHING
17. STAMP
18. DECREASE OF DIMENSION Д BY 0.1 mm ABOVE THE TOLERANCE AFTER HEAT TREATMENT IS PERMISSIBLE.

INDIGS MATL :-
BS: 970, Pt I: 83 Gde 826 M 31 IN 'Z' CONDITION
OR
IS: 5517-93 DESIGN 31 Ni 10 Cr 3 Mo 6 LRS 30 mm
A SEPARATE TEST SAMPLES IS TO BE HEAT-TREATED AND TESTED IN 'Z' CONDITION

IN CONTROLLED CO... CERTIFIED CORRECT COPY OF ... DRAWINGS AT HIS DATE 21/02/84
DESIGN & DRAWING OFFICE, ORDNANCE FACTORY, TIRUCHIRAPPALLI-620 ...

DATE	AUTHORITY	ZONE	NATURE	SIG AHSP	SIG DO
13-1-06	18845-W		HINDI NOMEN ADDED.		
8-12-97	18412-W		INDIGS MATL AMENDED		
28-7-97	18383-W		INDIGS MATL AMENDED		
3-9-96	18291-W		INDIGS MATL AMENDED		
30/11/93	18193-W		REF OF SPEC IS: 5517 ADDED.		
22/9/95	18174-W		PROV SEALING CANCELLED & DRG SEALED.		
22-7-95	18150-W		INDIGS MATL ADDED.		
8-1-93	17504-W		DRG SEALED PROV. OLD DRG WITH SAME PART NO. LAST DCN NO. 17520-W DT. 11-2-93 ENDORSED AGAINST ITEM		
7.10.92			NEW POLY NEG PREPARED		

AMENDMENTS

DRG SEALED :- 18174-W 22-9-95 DO CQA(W)

DRAWN:-	CHD	ASSY. DRG: 2A42.01.05C6	CQA(W) JABALPUR
TRACED:-	CHD:-	DATE	
	AHSP	SCALE :- 2:1	
C/D MAN	DO	FOR CQA(W)	ESTD MASS:- 0.68

MATL:- STEEL 30 XH2M φ A OCT 3-98-80
PROTECTIVE FINISH

DESIGN No

PART No 2A42.01 026

DS CAT No 1005-560071

29.8-07	19073-W	D S CAT No ADDED.
28.2-98	18426-W	INDIGS MATL AMENDED

HOLDER होल्डर