



**MATERIAL IN CASTING ROUTE:-**  
**BS:3146 PART -1; 1974**  
**TYPE - CLASS: 5 GRADE-A.**

**(NON STRESSED COMPONENT)**

**RADIOGRAPHIC TEST AS PER ASTM-E-192**

**GAS HOLE & FOREIGN MATERIAL: LEVEL-5.**  
**SHRINKAGE (ALL TYPES) - LEVEL-3.**

**CASTING SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT TEARS, COLD SHUTS ETC. AND SURFACE FINISH MUST BE SMOOTH.**

**UNTOLERATED DIMNS. ARE AS PER IS : 11166-1984 CLASS 1**

**MATERIAL : IS: 5517 - 1993, GRADE - 42Cr4Mo2**

**(OR) BS:970, PART-3, 1991, GRADE - 709M40**

**ALTERNATE MATERIAL : En19**

**HARDNESS: 37 - 42 HRC**

**DIMENSIONS ARE IN mm.**

**UNTOLERATED DIMNS. AS PER IS : 2102 (MED)**

**SHARP CORNERS SHOULD BE BLUNT TO R 0.5**

**PROTECTIVE FINISH : PHOSPATED TO SPECIFICATION. JSS : 0465-01-1988**

**CLASS-I (ACCELERATED) OIL FINISH.**

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
	SIGNATURE & DATE.		SUB: <b>CHANGE LEVER R.H</b>		SCALE 2:1
	TRACED		FOR: <b>TRIGGER GUARD SUB ASSY.</b>		STORE DRG.NO.
	DRAWN <i>L. Venkatesh</i>		OF: <b>38mm MSL</b>		OPERATION NO.
	CHECKED		DES. REF. NO.		
	HOS/D&DO		DRG. No.: <b>33P 3034</b>		
	NODAL OFFICER/ FOR MGL.		ORDNANCE FACTORY TIRUCHIRAPPALLI-16.		SHEETS: 1
	DIV. OFFICER DDO		APPROVED ON: <b>23/12/2014</b>		SHEET No.: 1

