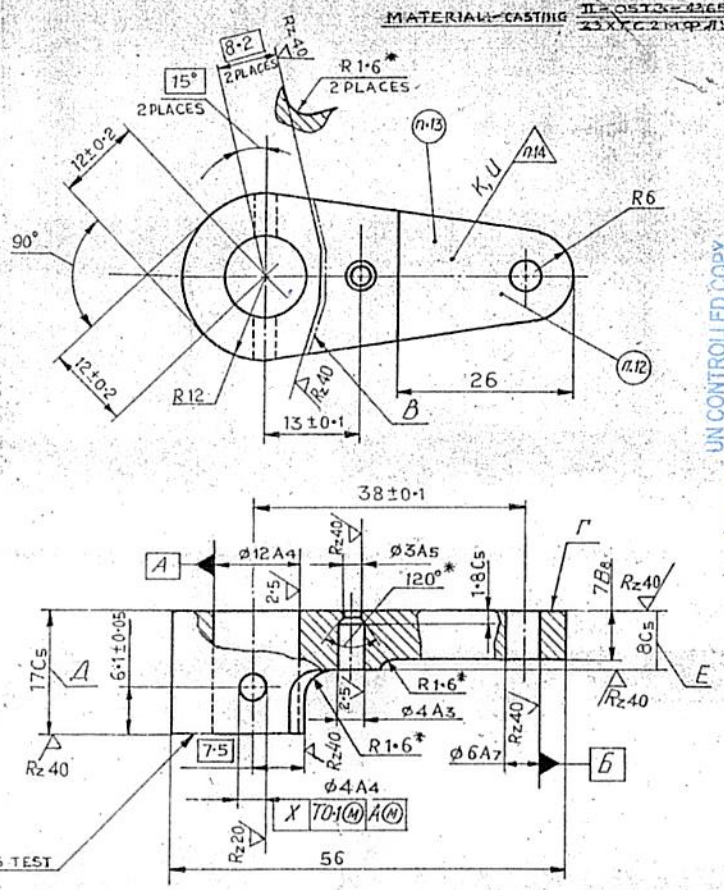
DS CAT No./PART No.
3040-021730
2A42·05·112

DIMNS ARE IN mm.

MATERIAL:- CASTING Ц-ОСТ 3-4365-79
ЗЛХСЛ 2 ПФЛ ГРУППА АА ГОСТ 977-75



NOTES:-

1. TECHNICAL REQUIREMENTS TO CAST PARTS AS PER OST 3-4365-79.
2. CASTING DEFECTS ON MACHINED SURFACES ARE PERMISSIBLE AS PER THE STANDARD.
3. ADDITIONALLY CHECK IMPACT STRENGTH IN ACCORDANCE WITH SECTION 3 OF GOST 977-75
4. UNSPECIFIED CASTING RADII R≈1mm.
5. 41.5 ... 51.5 HRCэ
6. *DIMENSION IS PROVIDED BY TOOL.
7. ROUND OFF SHARP EDGES R=0·6 mm
8. TOLERANCE ALONG CONTOUR B IN RELATION TO LOCATION SURFACES A Ⓜ AND 6 Ⓜ 0·2 mm Ⓜ.
9. ROUGHNESS ON SURFACE Г IS TOLERABLE, ROUGHNESS AREA IS NOT LIMITED.
10. LOCAL CHANGE OF DIMENSIONS A, E BY 0·3 mm ABOVE TOLERANCE IS PERMISSIBLE.
11. COATING CHEM. PHOSPH. ACCELERATED CHROMATIZING/INPREGNATION WITH ADHESIVE БФ-4 GOST 12172-74 @
12. MARK FUSION No. ORDINAL NUMBER OF MOLD, MOLD POCKET No. WITH TYPE ПО-Б GOST 2930-62
13. MARK THE ORDINAL NUMBER OF PART WITH TYPE ПО-3 GOST 2930-62 BY STRIKING METHOD.
14. STAMP.
15. (a) RADIOGRAPHIC ACCEPTANCE STANDARD OF THE CASTING SHOULD BE AS PER ASTM-E-A46-84, LEVEL II.
    (b) 100% OF THE ADVANCE SAMPLE (NOT LESS THAN 5) WILL BE SUBJECTED TO RADIOGRAPHIC TEST.
    (c) RADIOGRAPHIC TEST OF ADVANCE SAMPLES WILL BE CARRIED OUT BY CQA (MET) ICHAPUR.
    OR
    THE AREA QUALITY ASSURANCE OFFICER CONCERNED WOULD GET THE RADIOGRAPHIC TEST DONE IN HIS PRESENCE AND FORWARD THE PLATES TO CQA(MET) ICHAPUR FOR SENTENCE AND APPROVAL OF THE MOULD.
    (d) BULK PRODUCTION WOULD COMMENCE ONLY AFTER THE MOULD AND MATERIAL HAS BEEN APPROVED BY CQA(MET) ICHAPUR.
    (e) 5% OF THE CASTING SELECTED AT RANDOM FROM THE BULK WOULD BE SUBJECTED TO RADIOGRAPHIC TEST. THIS MAY BE DONE UNDER THE ARRANGMENT OF THE AREA QUALITY ASSURANCE OFFICER AND SENTENCE MAY BE AWARDED BY HIM BASED ON THE STANDARD OF THE ADVANCE SAMPLES CLEARED BY CQA (MET) ICHAPUR.

@ OR PHOSPHATING (ACCELERATED) CODE I TO 355:04-65-01-1994 WITH COATING OF DUNLOP ADHESIVE @ 758, ONE LAYER.

INDIGS MATL:-IS:10343-1999 GR 19Q WITH CARBON 0.45-0.5

C-5112

UN CONTROLLED COPY
CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE 21/9/23
DESIGN & DRAWING OFFICE
ORDNANCE FACTORY, TIRUCHIRAPPALLI-620 016

DATE	AUTHORITY	ZONE	NATURE	SIG AHSP	SIG DO
14-9-15	19446-W		INDIGS MATL AMENDED		
18-3-08	19118-W		D.S.CAT.No ADDED & NOMEN. AMENDED.		
18845-W	13-1-04		HINDI NOMEN ADDED		
18383-W	28-7-97		INDIGS MATL AMENDED		
18283-W	19-8-96		NOTE No 4 AMENDED		
18193-W	30-11-95		NOTE No.11 AMENDED.		
18174-W	22-9-95		PROV SEALING CANCELLED & DRG SEALED.		
18149-W	22.7.95		INDIGS MATL AMENDED.		
16-3-95	18100-W		INDIGS MATL & NOTE No.15 ADDED.		
27-3-92	17262-W		DRG. SEALED PROV. OLD DRG. WITH SAME PART No. ENDORSED "CANCELLED".		
12-11-91			NEW POLY NEGATIVE PREPARED		

AMENDMENTS

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

DRN:- CHD:- ASSY DRG:-
TCD:- CHD:- DATE:-
CHIEF D'MAN DO AHSP FOR CQA(W)
SCALE:- 2:1
ESTD MASS:- 0·08
MATERIAL:- AS ABOVE
PROTECTIVE FINISH:-

CONNECTING LINK, RIGID कनेक्टींग लींक, रीजीड

CQA(W) JABALPUR

DESIGN No.

PART No. 2A42·05·112

DS CAT No. 3040-021730