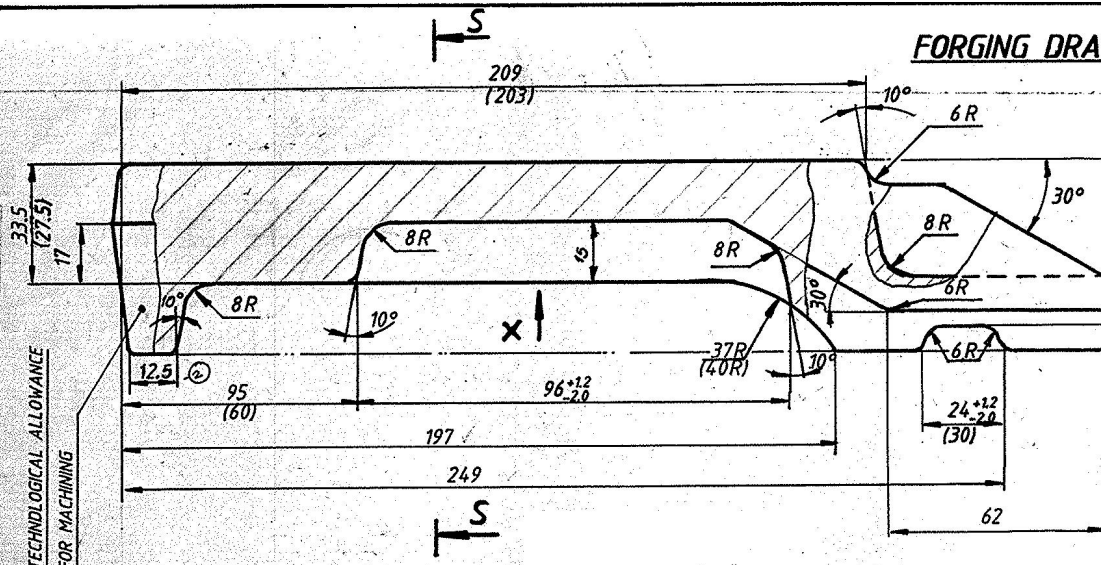


FORGING DRAWING

04.05.16 DA.No. 005/16, Dt.04.05.16 NOMENCLATURE OF C-1093 CHANGED (PP)



TECHNOLOGICAL ALLOWANCE FOR MACHINING

CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE.....

17.11.2020

Design & Drawing Office
Ordnance Factory,
Tiruchirappalli-620016

NOTES :-

- DIMENSIONS ARE IN mm.
- SCALE :- NOT TO SCALE
- FIRST ANGLE PROJECTION.
- HEAT-TREATMENT :- NORMALIZING; HARDNESS HB 220-260
- DESCALING :- PICKLING
- DISPLACEMENT IN THE PARTING PLANE SHOULD NOT EXCEED 0.9 mm.
- REMAINDER OF FLASH ON DIE PARTING LINE SHOULD NOT EXCEED 12 mm.
- ROD CURVATURE SHOULD NOT EXCEED 1.2 mm.

UN CONTROLLED COPY

- SURFACE DEFECTS SHOULD NOT EXCEED 0.6 mm IN DEPTH.
- DRAFT ANGLE 7°.
- UNSPECIFIED RADIUS 2.5 mm.
- ALLOWANCES AS PER CLASS II GOST 7505-74 M1
- TOLERANCES AS PER CLASS II GOST 7505-74 C2 AND AS FOLLOWS

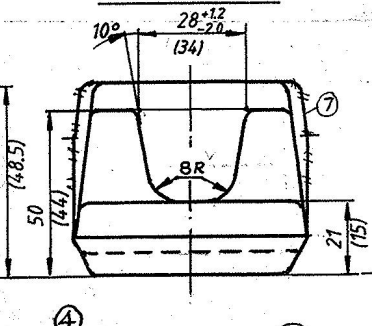
VERTICAL ± 0.16
HORIZONTAL ± 0.20
DIE FORGING BY HAMMER.

HB) 19446-W 14.09.15 MATL. AMENDED (DA.No.001/15 DL01.01.16)
AS PER Lr.No.1B1218-CQAW Dt.15.12.15

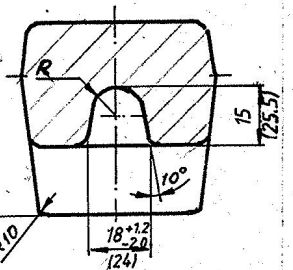
DA.No. 006/10 23/1/16 E(5) DAND. 052/ST 11/8/97

Sadhi 21-05-88	Asst. Engineer	6/88	1/18	23/1/86	WM/PROJ
REDRAWN	CHECKED	APPROVED	I/C. PROJ.		

VIEW THROUGH 'A'



SECTION S-S



THE FINISHED COMPONENT SHOULD ATTAIN A HARDNESS RANGE OF HRC3 43.5 TO 51.5 AFTER FINAL HEAT-TREATMENT

CHEMICAL COMPOSITION OF THE MATERIAL 30XPA

C	0.28 - 0.33	Si	0.17 - 0.37
Mn	0.50 - 0.80	Cr	1.0 - 1.30
Ni	0.25 - 0.50	S	0.025 MAX.
P	0.025 MAX.	Cu	0.20 MAX.

INDIGENOUS MATL: B6 070 RT-T 1083 G-817 M40 IN 12" CONDITION

HEAT TREATMENT PROCESS CHART

NOMENCLATURE AND IDT. NO:	STEEL GRADE	TYPE OF OPERATION	EQUIPMENT	TEMP. IN °C	TIME	COOLING MEDIUM	FIXTURE	HARDNESS INSPEL %
FRONT STRIPPER REAR STRIPPER C 1092 C 1093	30XPA	NORMALIZING HEATING	ELECTRIC CHAMBER FURNACE OR PUSHER TYPE FURNACE	850-870	3 HRS. PUSHING DURATION 15 MIN.	AIR	ON TRAY	7% BUT NOT LESS THAN 3 PIECES.

1. DRESSING OF PLACES FOR CHECKING HARDNESS.
2. CHECKING OF HARDNESS.

SEND ONE PART FROM THE CHARGE OF CHAMBER OR PUSHER FURNACE FOR CHECKING UP ABSENCE OF FRACTURE DUE TO OVER HEATING.

- NUMBER OF PARTS OBTAINED FROM ONE FORGING : 1 PIECE.
- DIMENSIONS GIVEN IN BRACKETS ARE FOR MACHINING
- WEIGHT OF THE FORGING 4.215 Kgs. ~
- RAW MATERIAL SIZE :- 55 Sq. x 270 LONG (HOT ROLLED) (OR) Eq.Wt. DIA 80x163mm
- MATERIAL :- 30XPA OST-3-98-80
- ANGLE UNDERFILLING OF LAP WITH PRESERVED 54.5 mm IS TOLERABLE

(MRV JAGADISH)

Sr. Scientific Officer
Sr. Quality Assurance Engg (Arms)
Tiruchirappalli-620016
VETTED FOR MATERIAL ONLY
AS PER LAST DOCUMENT
1.0 MQA-31

D 4	DA NO. 052/96 Dt 13-6-96	13-6-96	Updated.	DA No. 22/97 dt. 23-3-97
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FOR COMPONENT NO
2A42-01-092 - FRONT STRIPPER
2A42-01-093 - STRIP RETAINING METALLIC

STORE DRG. NO ADDED
AMENDMENTS
Slg & DATE

**ORDNANCE FACTORY
TIRUCHIRAPALLI-16**

DRG NO. I3
64 C 1092 200 N3

ALB NO. 363/23