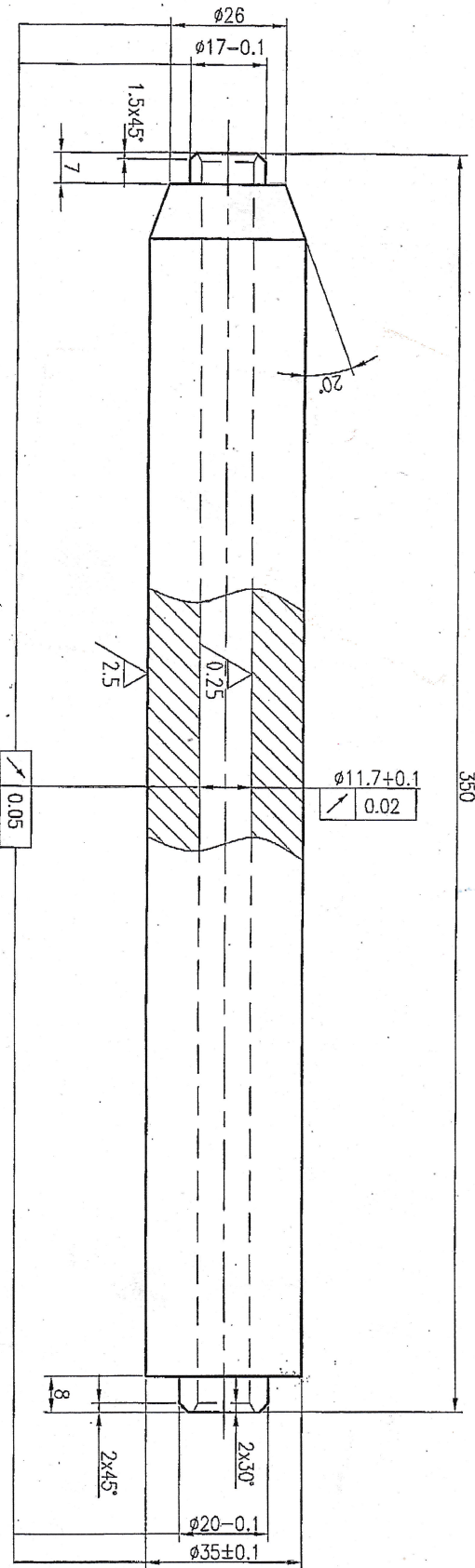


BEFORE COLD SWAGING WITH CHAMBER



The Steel should be produced by secondary refining route. The following restriction S&P contents should apply for both the above specification. S = 0.010 max, P = 0.015 max. S&P combined 0.022 max

HARDNESS :- 248-302 HB  
BLUNT SHARP EDGES ~0.4mm

STRAIGHTNESS OF BORE:-

A PLUG GAUGE OF 150mm LONG 0.015mm LESS THAN THE ACTUAL BORE SIZE SHOULD PASS THROUGH WHEN THE BARREL IS PLACED VERTICALLY.

DRILLING FROM ONE SIDE ONLY.

THERE SHOULD NOT BE ANY MARKS INSIDE THE BORE

CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE

7 NOV 2020  
Design & Drawing Office  
Ordnance Factory,  
Tiruchirappalli-620016

DIMENSIONS ARE IN mm.  
UNTOLERATED DIMMS. AS PER IS : 2102 (MED)

RAW MATERIAL :-  $\phi 38 \times 350 \pm 3$ mm

MATERIAL:-  
② JSS 9510-06-2012 CODE REF:R:  
STEEL TO  $\phi 08$  REF-B OF 955-9540-2000 REVISION 3 CONDITION 'T' WITH  
MACRO-ETCH NON METALLIC INCLUSION RATING TEST AND  
DETERMINATION OF NON METALLIC INCLUSION IN STEEL AS PER  
COLUMN (a) OR (b) OF COA(SA) NOTE SHEET No.1.  $\Sigma S+P < 0.022\%$

③ ALT.MATL:-  
BS:970 Pt-1-1983 G. 708 M40 'T' CONDITION

1305/05-4

DA.No:04/20 DL07/01.20 03/19 01.02.19	SIG. [Signature]	AMENDMENTS & DATE
DRG. No. 2226*2	OPERATION NO.	
NO. OF OFF.	SCALE	
MATERIAL	REMARKS	
TREATMENT		
DESCRIPTIONS		
SIGNATURE & DATE		
TRACED		
DRAWN		
CHECKED		
HDS/D&DO		
OFFICER/PRODN.		
OFFICER/D&DO		
APPROVED ON: 01.02.2019		
NO. OF SHEETS: 01		
SHEET No.: 01		

ORDNANCE FACTORY  
TIRUCHIRAPPALLI-16.

