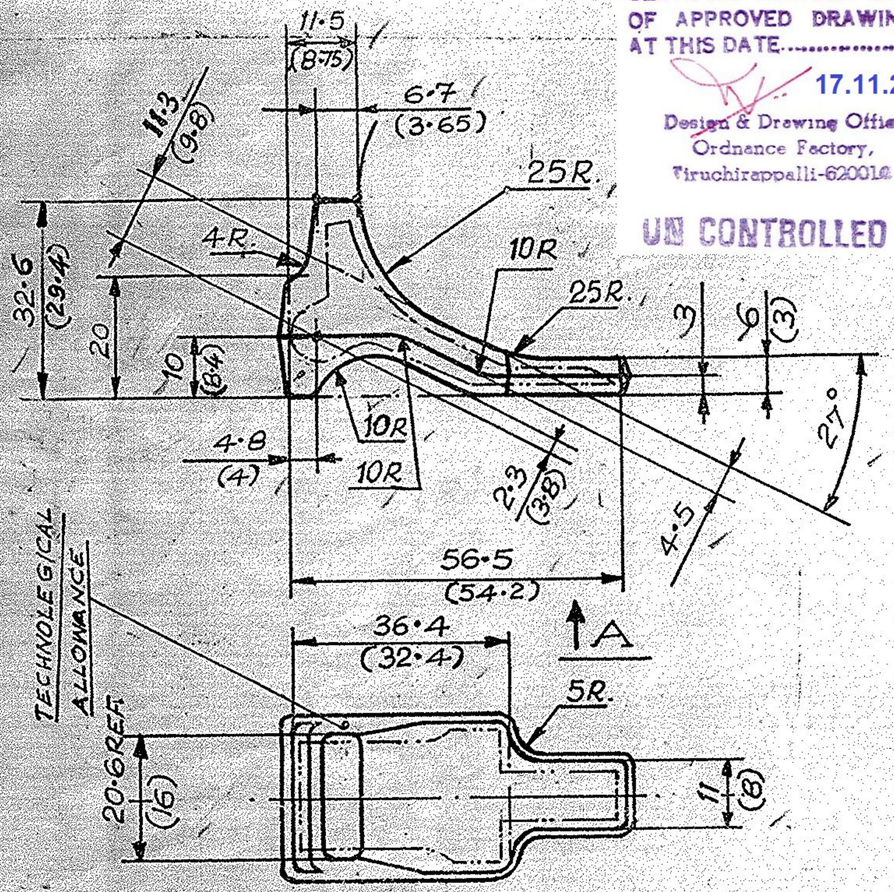
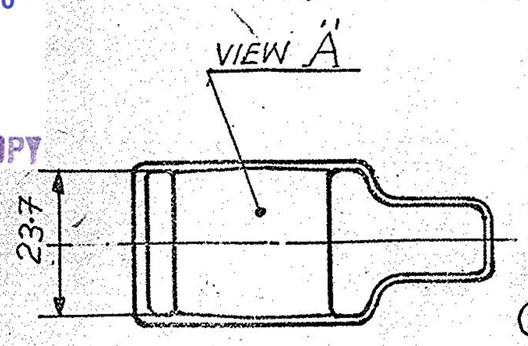
CERTIFIED CORRECT COPY
OF APPROVED DRAWINGS
AT THIS DATE.....
17.11.2020
Design & Drawing Office
Ordnance Factory,
Tiruchirappalli-620016
UN CONTROLLED COPY

FORGING DRAWING





(4) CHEMICAL COMPOSITION OF THE MATERIAL :- 30XH2MΦA-a

C	0.27 - 0.34	Si	0.17 - 0.37
Mn	0.30 - 0.60	Cr	0.6 - 0.9
Ni	2.0 - 2.40	Mo	0.2 - 0.3
V	0.10 - 0.18	P	0.025 MAX.
S	0.025 MAX.	Cu	0.30 MAX.

(3) THE FINISHED COMPONENT SHOUD ATTAIN A HARDNESS RANGE OF HRC3 43·5 TO 51·5 AFTER FINAL HEAT TREATMENT

(4) HEAT-TREATMENT PROCESS CHART

NOMENCLATURE AND IDT. NO:	STEEL GRADE	TYPE OF OPERATION	EQUIPMENT	TEMP. IN °C	TIME	COOLING MEDIUM	FIXTURE	HARDNESS INSPN. %
ROCKER C 5025	30XH2MΦA	NORMALIZING HEATING	ELECTRIC CHAMBER FURNACE OR PUSHER FURNACE	850-870	3 HOURS	AIR	ON TRAY	3%, BUT NOT LESS THAN 3 PIECES.
		HIGH TEMPERING HEATING	ELECTRIC CHAMBER FURNACE OR ELECTRIC SHAFT FURNACE	660-680	5 HOURS	WITH FURNACE UP TO 500°C & IN AIR	ON TRAY	

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

NOTES :-

1. DIMENSIONS ARE IN mm.
2. FIRST ANGLE PROJECTION
3. SCALE :- 1:1
4. HEAT-TREATMENT :- NORMALIZING & HIGH-TEMPERING HARDNESS HB 255 MAX.
5. DE-SCALING :- SHOT BLASTING OR PICKLING
6. DISPLACEMENT IN PARTING LINE SHOULD NOT BE MORE THAN 0.4 mm.
7. FLASH REMAINDER ALONG DIE PARTING LINE SHOULD NOT BE EXCEED 0.6 mm.
8. MATERIAL :- 30H2MΦA-a OST 3-98-80
9. SURFACE DEFECTS :- SHOULD NOT EXCEED 0.5 mm IN DEPTH
10. UN-SPECIFIED DRAFT ANGLE SHOULD NOT BE MORE THAN 7°.
11. UN-SPECIFIED RADII 1.5 mm.
12. ALLOWANCES ARE AS PER II CLASS GOST 7505-74 : M 2.
13. TOLERANCES ARE AS PER II CLASS GOST 7505-74 AND AS FOLLOWS : C 2

    VERTICAL $^{+0.9}_{-0.5}$
    HORIZONTAL $^{+1.1}_{-0.5}$
    DIE FORGING ON HAMMER
14. NUMBER OF PARTS OBTAINED FROM ONE DIE FORGING: ONE PIECE.
15. DIMENSION BETWEEN BRACKETS ARE FOR MACHINING.
16. STAMPING OF CONVENTIONAL SEAL OF BLACK SMITH LETTERING 170-5 GOST 2930-62
17. RAW MATERIAL SIZE 260$^{+0.6}_{-0.7}$ × 60 +1 LONG (HOT ROLLED)
18. WEIGHT OF THE FORGING 0.130 Kgs.

(5) 1-83

(4) ~~-3-91~~

(3) INDIGENOUS MATERIAL: BS 970 Pt ~~1-83~~ Gde 826 M31 IN "Z" CONDITION (DR) IS 5517-93 DESIGN31 N110 CY3 MO6 LRS 63mm (TENSILE STRENGTH 1550 MPa)

(4) A SEPERATE TEST SAMPLE IS TO BE HEAT TREATED AND TESTED IN "Z" CONDITION. AUTHY: CQAM. LT. NO. MQA-3/TS/B Dt-02-05-97.

VETTED FOR MATERIAL ONLY
AS PER LAST DC (I) No. 12291W
DT 3.9.96
(M.N. JAGADISH) 28/5/98
Sr Scientific Officer
Sr. Quality Assurance Estt (Armrs)
Tiruchirapalli-620016.

E3 (5) DA No.005/16, Dt.04.05.16 PP

SL. NO	AMENDMENTS	SIG. & DATE
(4)	DA.No. 006/98. Dt. 24-4-98.	24/4/98
UPDATED.	DA. NO. 022/97 Dt. 23-3-97	23/3/97
C (3)	DANO. 058/96 Dt 27/6/96	27.6.96.
B (2)	DA.No. 027/95 Dt. 13-4-95	5-4-95
(1)	STORE DRG. NO ADDED	25/2/92

FOR COMPONENT NO (1)
2A42-05-025 - ROCKER

Sadhi 24/05/88	Seetharaman	6/7/88		7/6/88	ORDNANCE FACTORY TIRUCHIRAPALLI-16
REDRAWN	CHECKED	APPROVED	I/C PROJ.	WM/PROJ:	DRG NO: 64 C 5025 200 E 3

ALB. NO. 364/15