

LOCATIONAL TOLERANCE IN HOLE AXIS 0.2 ON RADIUS AT MM C.

LOCATIONAL TOLERANCE IN HOLE AXIS 0.2 ON RADIUS AT MM C.

PLACE OF HARDNESS TEST.

DRAWING CONVENTIONS CONFORM TO IS: 696.

HARDNESS: -- 67 TO 70.5 HRA

STRAIGHTENING MAY BE DONE AFTER HEAT TREATMENT.

DECREASE OF DIMENSION 'A' TO 8 mm. ON THE LENGTH 'B' IS PERMITTED.

COATING: -- ELECTROLESS ACCELERATED PHOSPHATING, OIL FINISHING.

COATING/PROTECTIVE FINISH FOR INDIAL- PHOSPHATE TO SPEEN. JSS-0465-01/1988 CLASS II; OIL FINISH.

STAMP 'K' (DIMENSIONAL ACCURACY) AND 'M' (HARDNESS CORRECTNESS) ON TAG.

REMAINING TECHNICAL REQUIREMENTS ARE AS PER 6011 TY SPECIFICATIONS.

GOST 15878-79-KM-5

1005-007437

5340-015903

5340-015902

122 ±0.2

26/9/05

UN CONTROLLED COPY
 CERTIFIED CORRECT COPY (COPY APPROVED)
 DRAWING AT THIS DATE 15/08/21
 DESIGN & DRAWING OFFICE
 ORDNANCE FACTORY, TIRUCHIRAPPALI-620 016

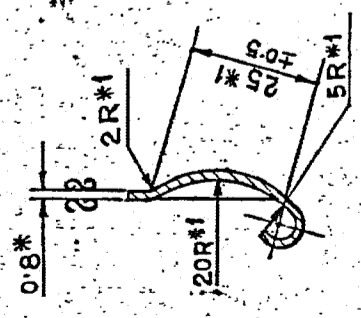
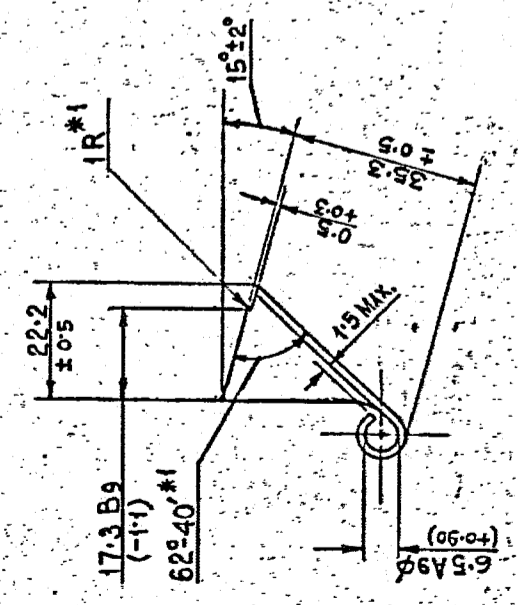
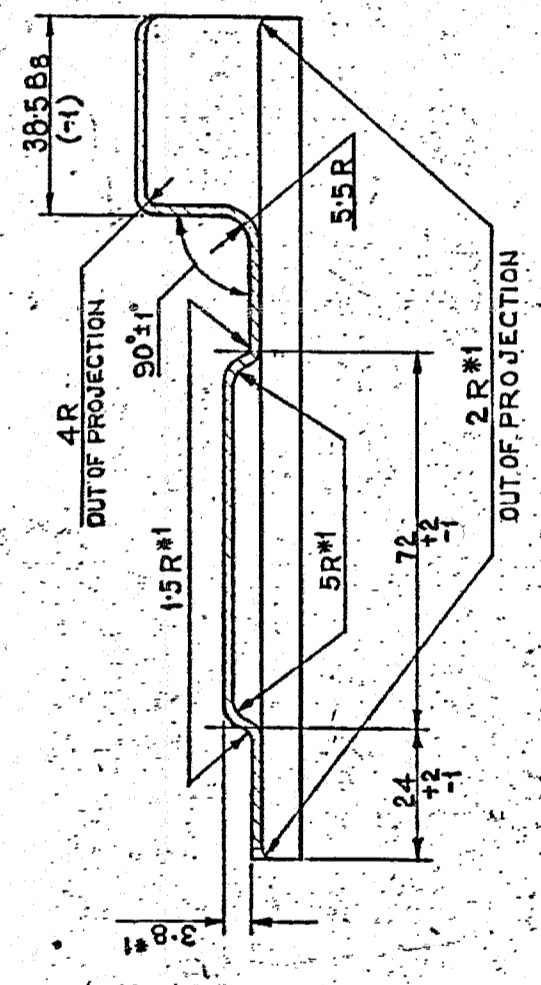
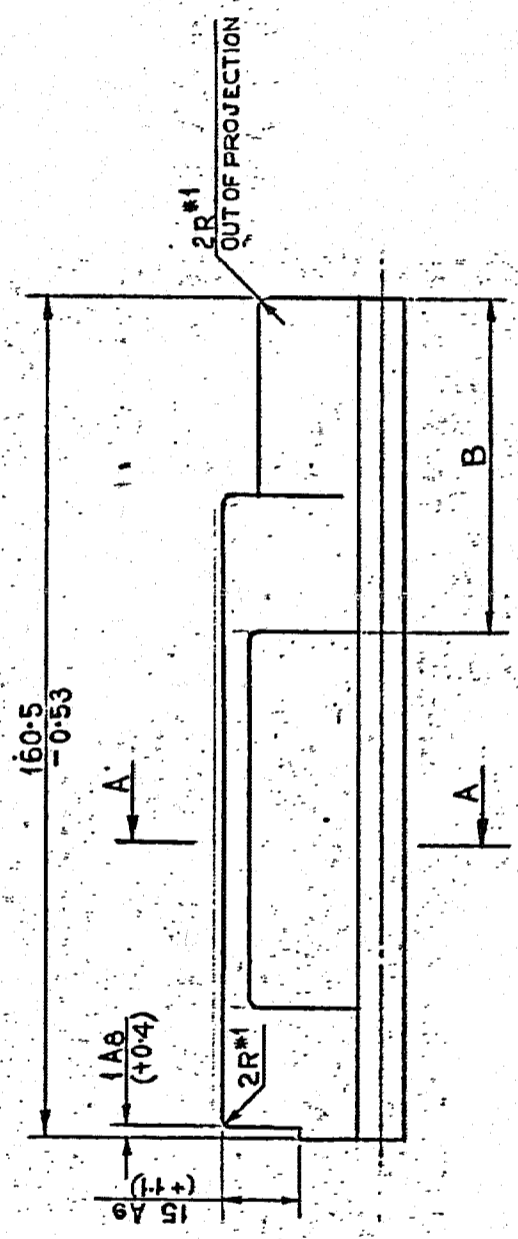
A 6400

DATE	NAME	ASSY	P.S. CAT. NO.	COA(SA) ICHAPUR
DSN			1005-007419	
DRN				
CHD				
TRD				
COMP				
MATERIAL		DIMENSIONS ARE IN MILLIMETRES		
DT. 29.9.2010 P.O.		EXCLUDER DUST		
SCALE: 1:1		SUB-ASSY (RIGHT)		
SEALING: PROV. DC (1)		APPROVED DT. 4.1.86		
18906-SADT 11-4-86		NEGATIVE PREPARED		
COPY		DESIGNER'S REF		
20217-SA-20786-SA		6011 C86-4C6		
2017-SA-20786-SA		DS. CAT. NO.		
18906-SADT 11-4-86		1005-007435		

DRAWING CONVENTIONS CONFORM TO IS:696.
 SURFACE FINISH:- AS PER IS:3073-67,
 WHERE NOT SPECIFIED SHOULD BE V.
 MATERIAL:- SHEET B-NY-0-0-8 GOST 19903-74
 MATERIAL FOR INDIA:- IS:2507-1975
 DESIG. 50 GR.4 (GRADE-I0)

ALT. MATL. FOR INDIA:-
 IS:2507-1975 Gr.11 DESIGN. 50 Gr4 V2

* - DIMENSION FOR REFERENCE.
 #1 - DIMENSION ENSURED BY TOOL.
 SHARP EDGES TO BE BLUNTED 0.2 MM.
 IN THE STRETCHED PLACES THE ALLOWED
 THICKNESS IS 0.4 MM.
 ON SECTION 'B' CORRUGATIONS ARE ALLOWED
 ACCORDING TO THE STANDARD.
 STAMP 'K' (DIMENSIONAL ACCEPTANCE) ON A TAG.
 REMAINING TECHNICAL REQUIREMENTS ARE
 AS PER G111 'Y' SPECIFICATIONS.



SECTION-A-A

UN CONTROLLED COPY
 CERTIFIED CORRECT COPY OF APPROVED
 DRAWINGS AT THIS DATE: 10/08/2011
 DESIGN & DRAWING OFFICE
 ORDNANCE FACTORY, TIRUCHIRAPPALI-620 016.

A-6416

DATE	NAME	ASSY. NO.	DES. CAT. NO.	QQA(SA) ICHAPUR
		105-007435		
DGN.				
DRN.				
CHKD.				
TRO.				
COMP.				
DT.	29.6.91	C, D, O		
SCALE:	1:1			
SEALING	PROV. DCU			
COPY	18906-SA, pr. 11, 4, 86.			
SIG.				

DA No. 004/17 Dt. 10.07.17	ALT. MATL. ADDED Lt. REF. No.			
21366 4-9-91	QASCH/2.7mmAD Dt. 23.06.17			
-SA	DRAWING REVISED, RE-DRAWN			
	ALL PROJ. RE-SEALED			
	PREVIOUS EDITIONS 18906-SA,			
	2011-SA 20269-SA			
AUTHOR	DATE	ZONE	BRIEF RECORD	

EXCLUDER DUST (RGHT)

DESIGNER'S REF. 6N11 6-16

APPROVED PR. 4.1.86. NEGATIVE PREPARED

DS. CAT. NO. 1005-007437

