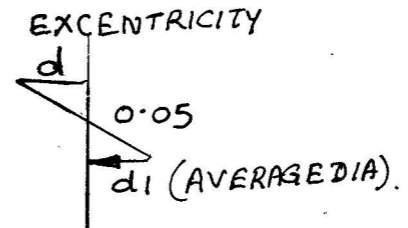


NOTE:
 1) Manufacturers Monogram to be engraved/etched/stamped on *** circumference.
 2) THE SURFACES NOT BEARING THE SIGN OF SURFACE FINISH MUST SATISFY THE REQUIREMENTS FOR THE MATERIAL.



Material:- Steel to Specn. BS 970 Pt 1:1983
 080 M40 (Normalised) Grain Size 5-8,
 Izod value - 20.340 Nm (Min).

REV.	DATE	DESCRIPTION	SIGN.
E-133/2016	22-06-16	DC NO. 37284-A DATED 06-07-11. UPDATED, DRG. ADY. TO E.	JGM/OC
D/2009	15-01-09	HOLE WITH DIM $\phi 3 \pm 0.25$ note no. 2 added.	JGM/ES
C	21-10-99	Internal cone added in drg. Corresponding dims 43 ± 0.62 & angle $90^\circ 5'$ also added. D.A. NO. 466/99	AKM/BCZ
B	14-9-99	DIMS. 40.5 ± 0.34 & $1.2 \times 45^\circ$ are added. NOTE for Mfg. Mono-gram added. Dim 24.4 ± 0.4 deleted. DRG. No Adv. To 'B' D.A. NO. 418/99	JGM/BA
A	6-7-99	Matl. Specification added. DRG. No Adv. To A. D.A. NO. 294/99	JGM/BA

AMENDMENTS

UNSPECIFIED MACHINING DEVIATIONS			ANGULAR DIMENSIONS		SURFACE ROUGHNESS	
ABOVE	UPTO	DEVIATION	LENGTH OF SHORTER SIDE	OF ANGLE	DEGREE	MAX. RA VALUE
	B	± 0.1			OR MINUTES	IN μm
6	30	± 0.2	ABOVE	UP TO	$\pm 1^\circ$	50
30	120	± 0.3			$\pm 30'$	25
120	315	± 0.5	10	50	$\pm 20'$	6.3
315	1000	± 0.8	50	120	$\pm 10'$	0.8
1000	2500	± 1.2	120		$\pm 10'$	0.1

DIMENSIONS ARE IN mm		
THIRD ANGLE PROJECTION		
SCALE: 2:1		
1999	NAME	DATE
DRAWN	JGM/BA	28.6.99
TRACED		
CHECKED	JGM/BA	29.6.99
JWM/CDO		29.6.99
APPVD.	JGM/BA	

MATERIAL	AS Above.
NOMENCLATURE	BODY (TURNING OPERATION)
SCHEDULE NO.	
STORE	FBF 29

ORDNANCE FACTORY, AMBAJHARI.	
DRAWING NO.	F5-1851 E'
SHEET NO.	1
NO. OF SHEETS	1
FEATURE NO.	BODY