

ASSAY 200 x 200 x 800

~~A~~
 Approved
 Marked boxes should be supplied as pre-machined to the dia 130 mm.
 13/04/22
 Wm ITT

PILOT SAMPLE SHOULD BE APPROVED BEFORE BULK SUPPLY.

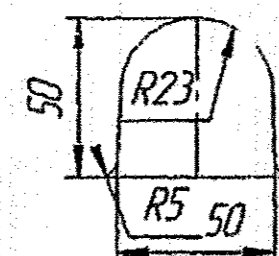
- SHRINKAGE ON DIMENSIONS OF CASTING 2%.
- UNSPECIFIED DRAFTS AND CLEARANCES ARE AS PER GOST 3212-92.
- UNSPECIFIED CASTING RADII 5±5MM.
- MAKE THE SPRUE IN THE UPPER HALF MOULD BY PIPES III-C - 70 X 50 X 250 AS PER GOST 11586-69.
- THE PATTERN SET CONSISTS OF SETTING OF PATTERNS UPWARD, SETTING OF PATTERNS DOWNWARD AND CORE BOXES NO. 1,2,3,4,5,6.
- ACCURACY MK5 - GOST 3212 - 92
- AT THE MARKED PORTIONS OF THE CORE BOXES SET THE SERIAL NUMBERS, TYPE NO.30 AS PER GOST 26.008-85.

SPRUE



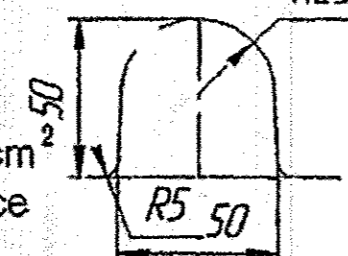
CORE = 19.6 cm²
 QTY = 1 Piece

B-B



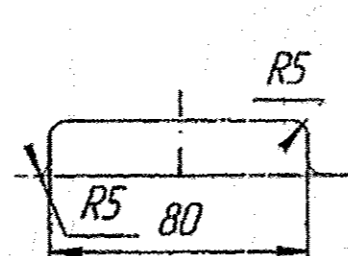
F_W np = 24 cm²
 QTY = 1 Piece

I-I



F_W np = 24 cm²
 QTY = 1 Piece

F-F

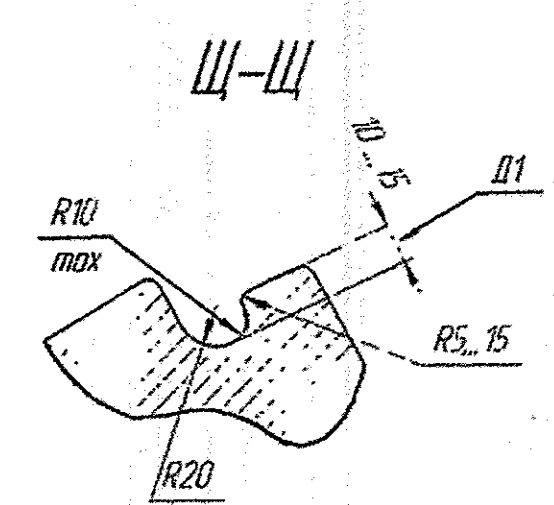
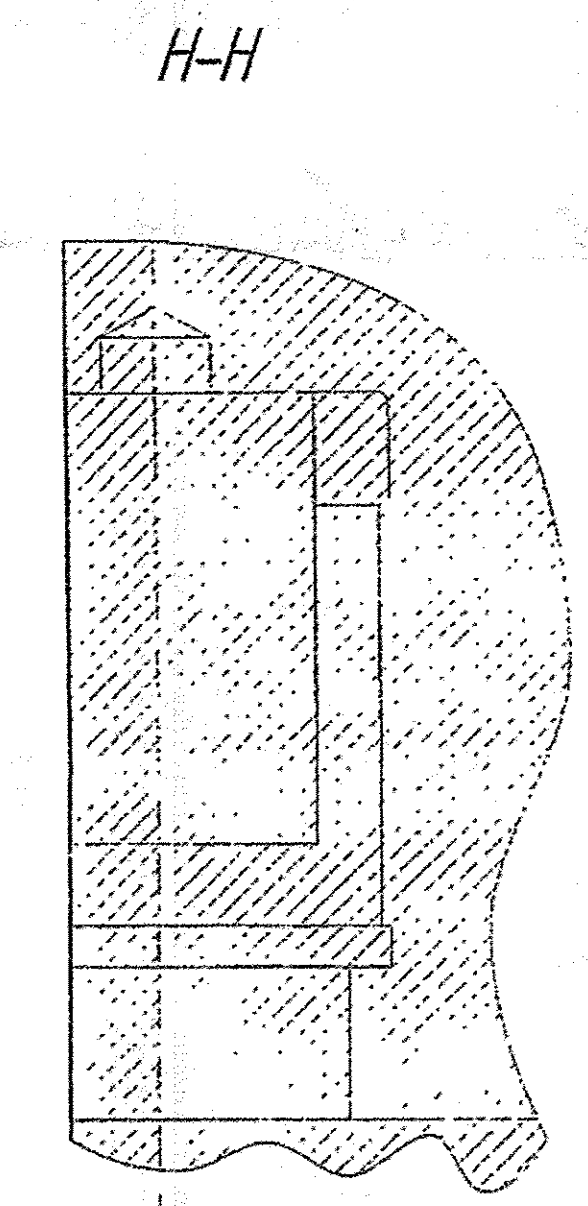
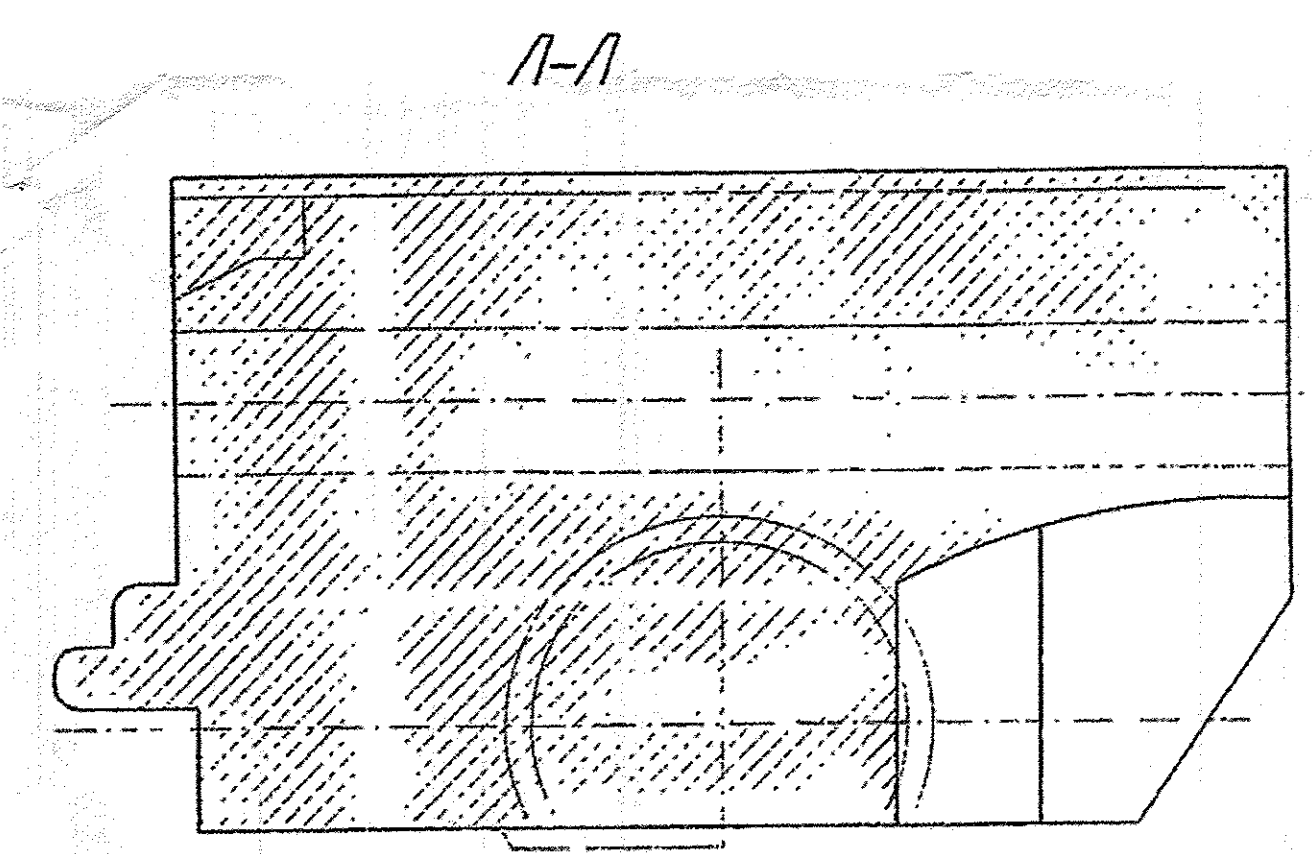
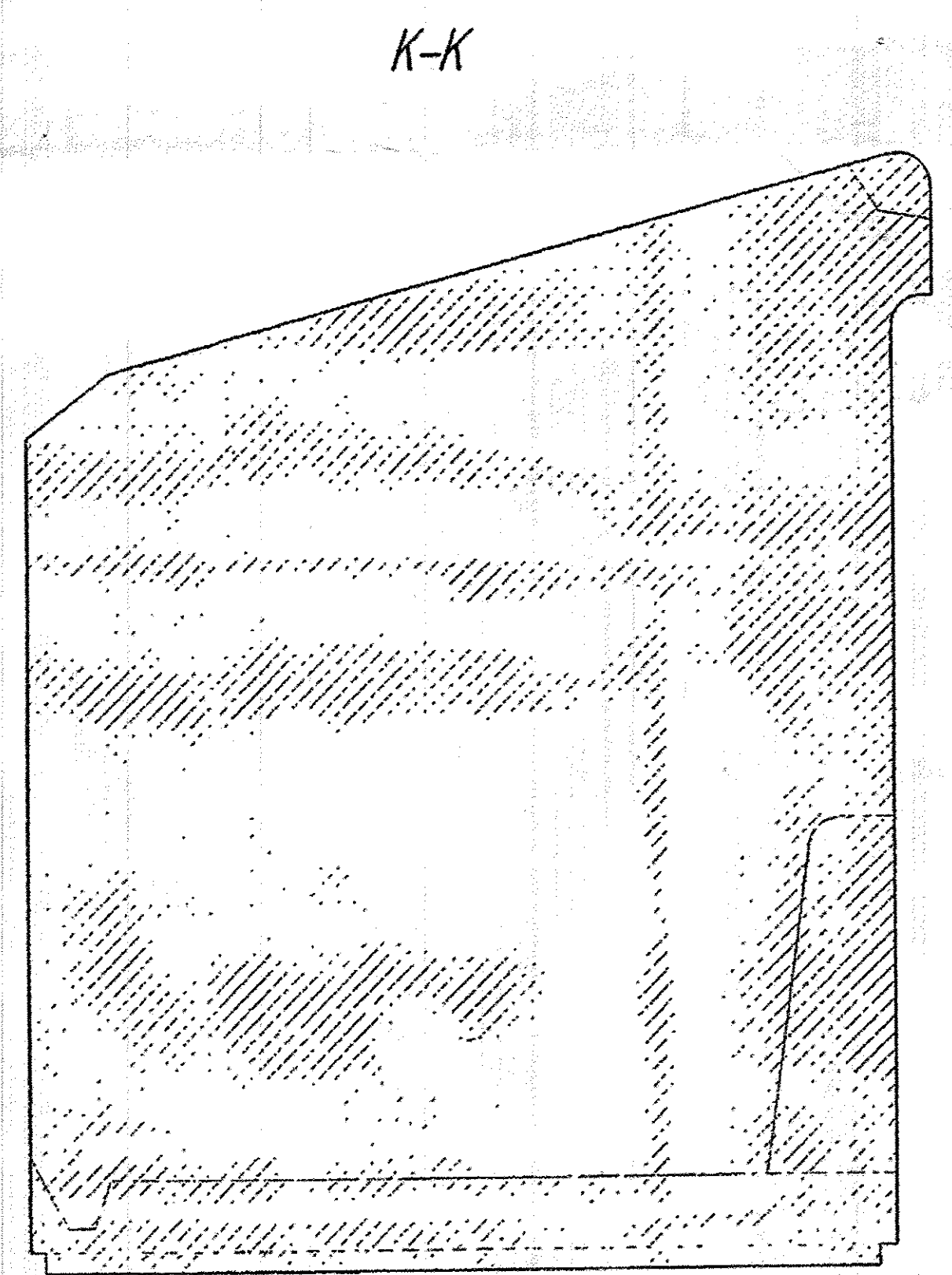
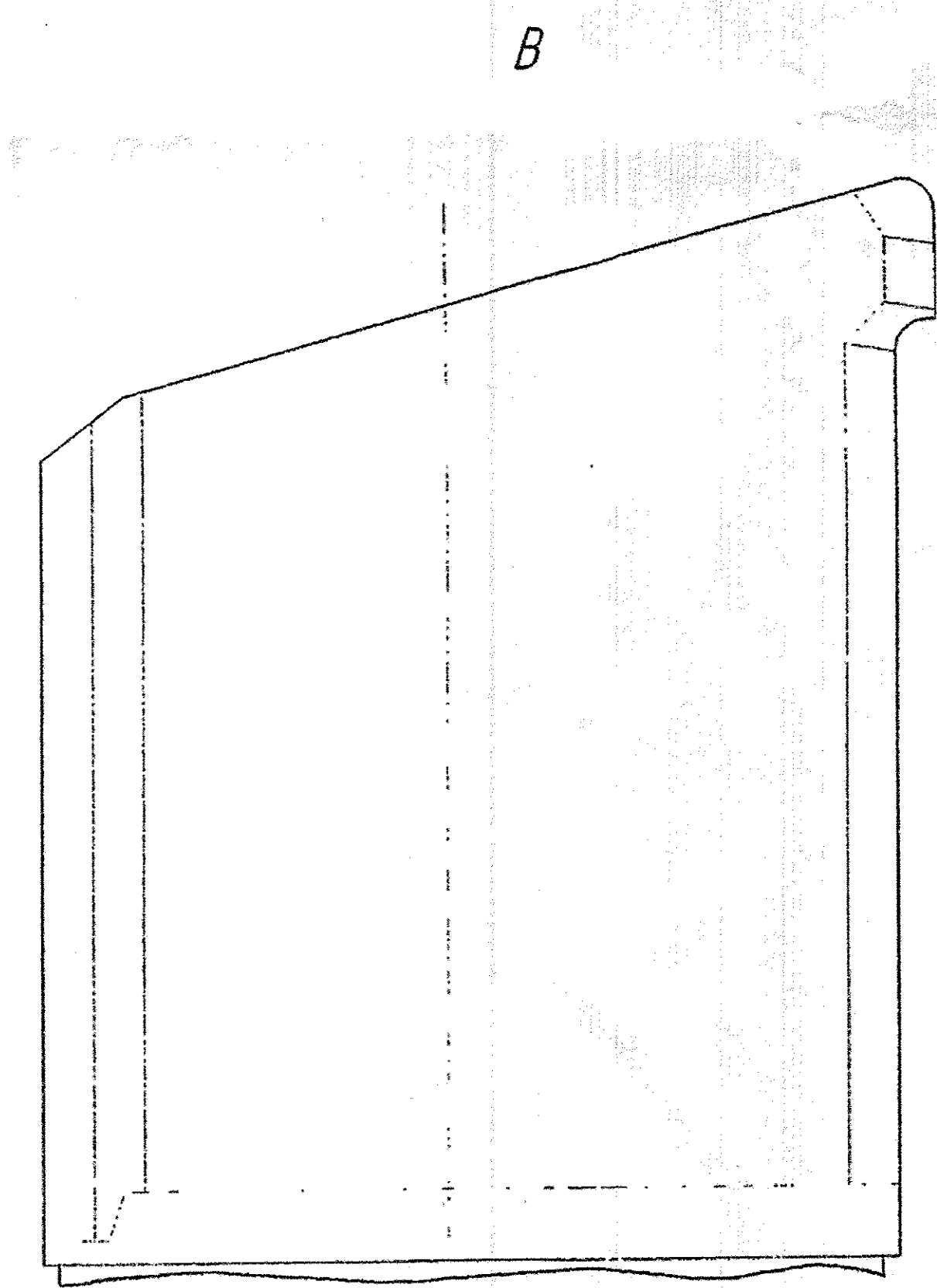
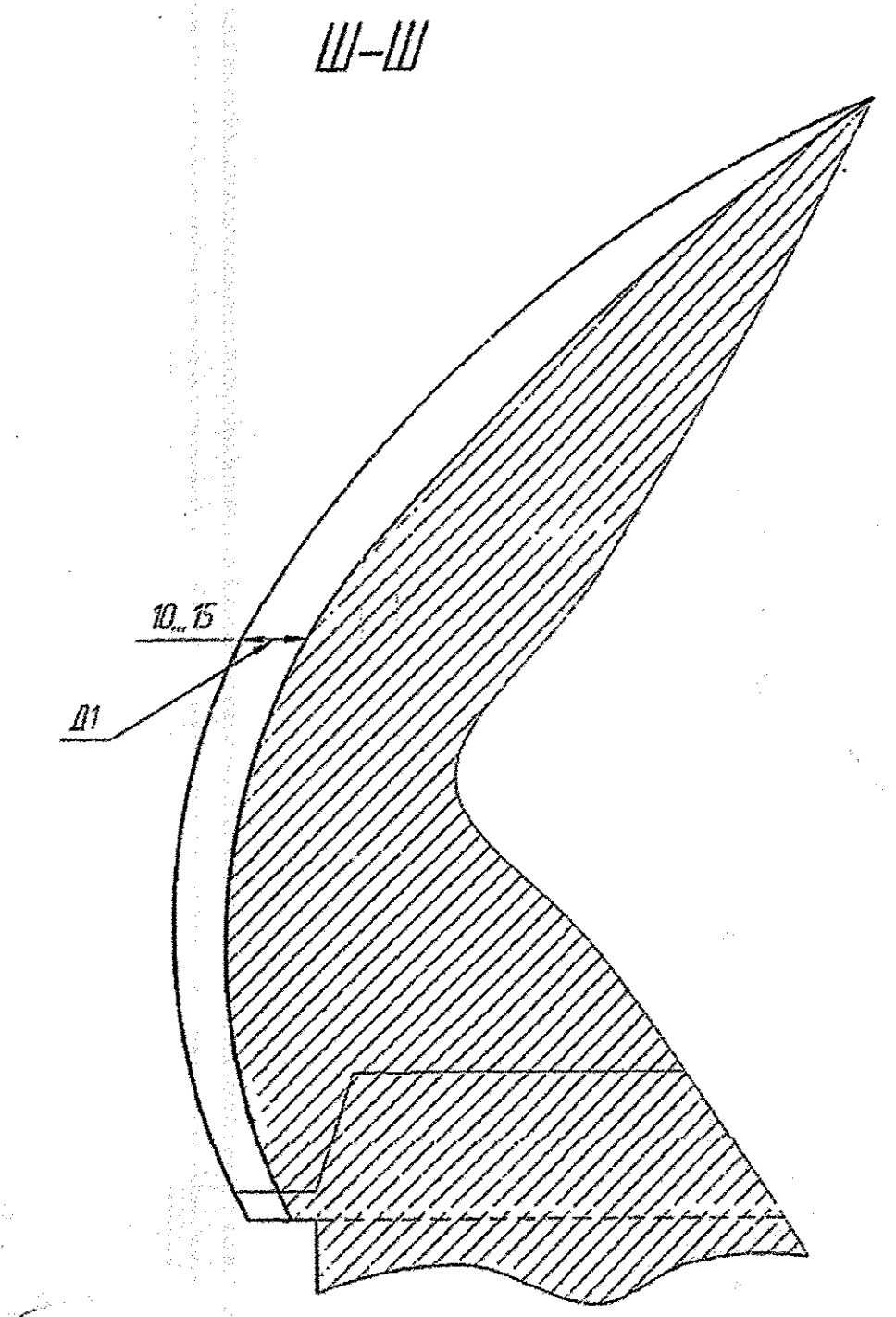
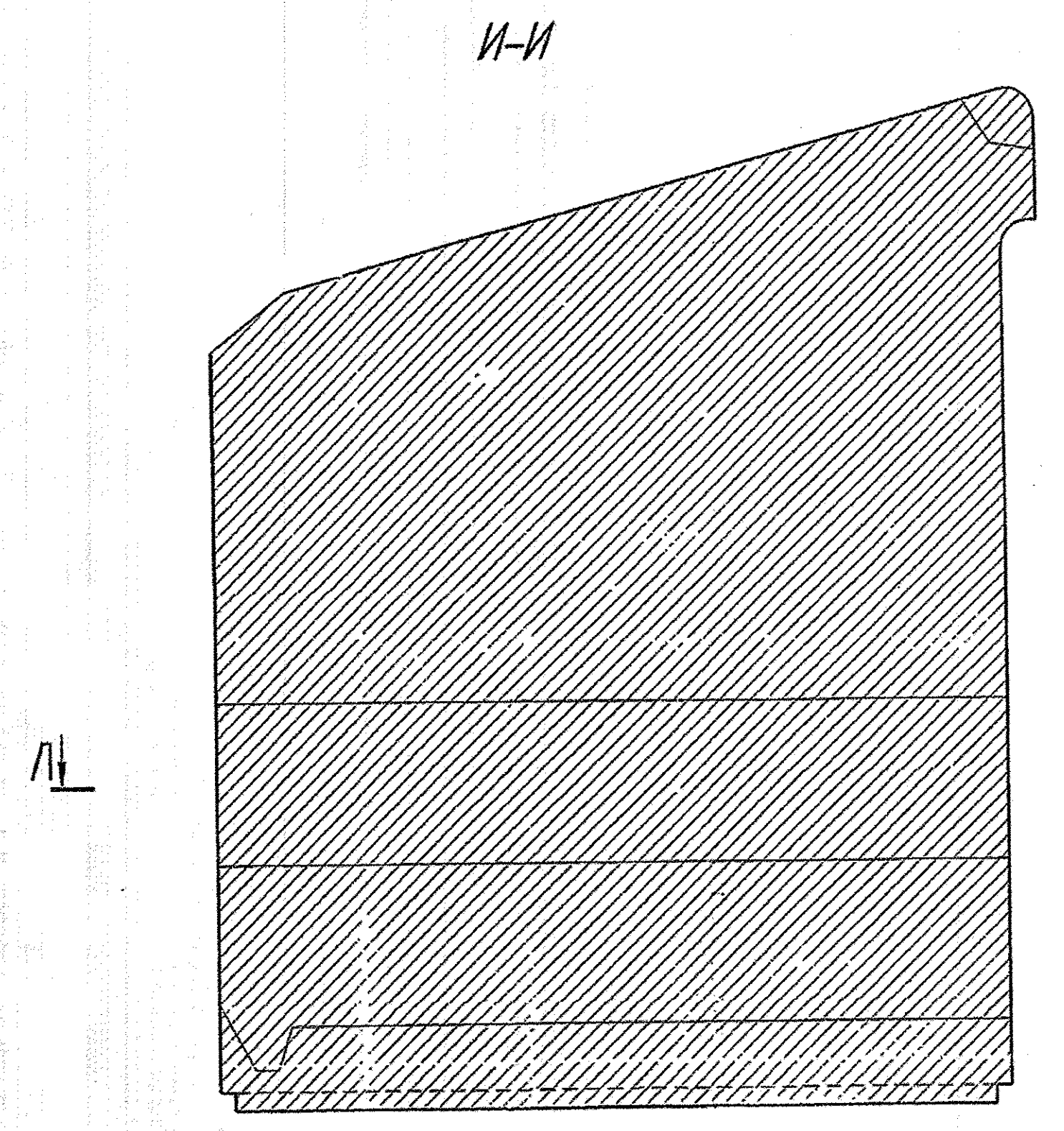
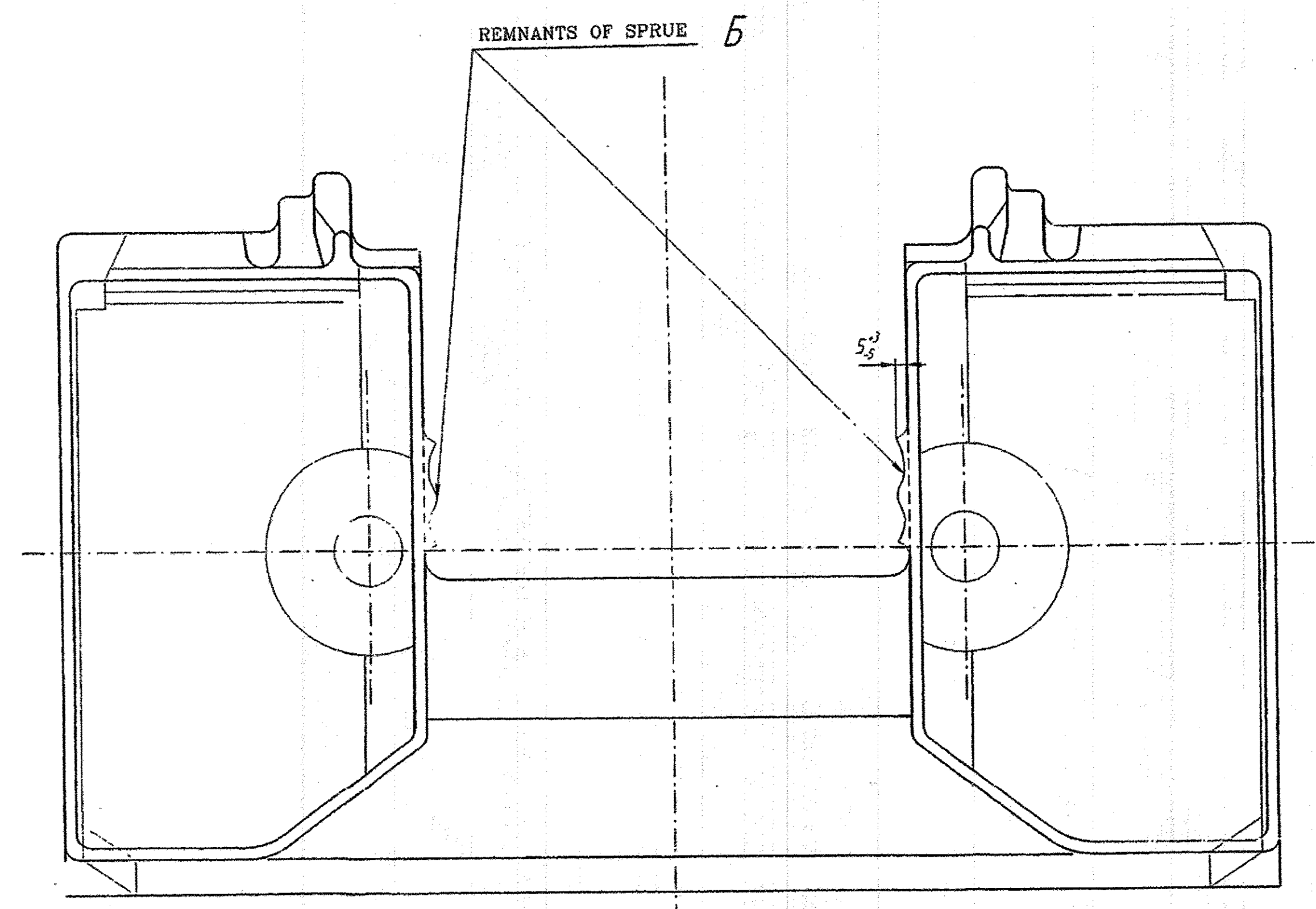


GATE = 13.6 cm²
 QTY = 2 Piece
 Σ GATE = 27.2 cm²

ELEMENTS OF CASTING MOULD

 USER APPROVAL	A	Deleted pre-machined dia 130 mm Ref-Lr.07271/Turret/27/2022, dt.14.09.2022
	Issue No	

T 90		
MATERIAL	CASTING WT.	
ALT. MATERIAL	HAMMER	SCALE
DRAWN	CHECKED	APPROVED
DRAWING NO. 187.10.241 -C		
NOMENCLATURE: PORTHOLE		
HEAVY VEHICLES FACTORY		
AVADI, CHENNAI		



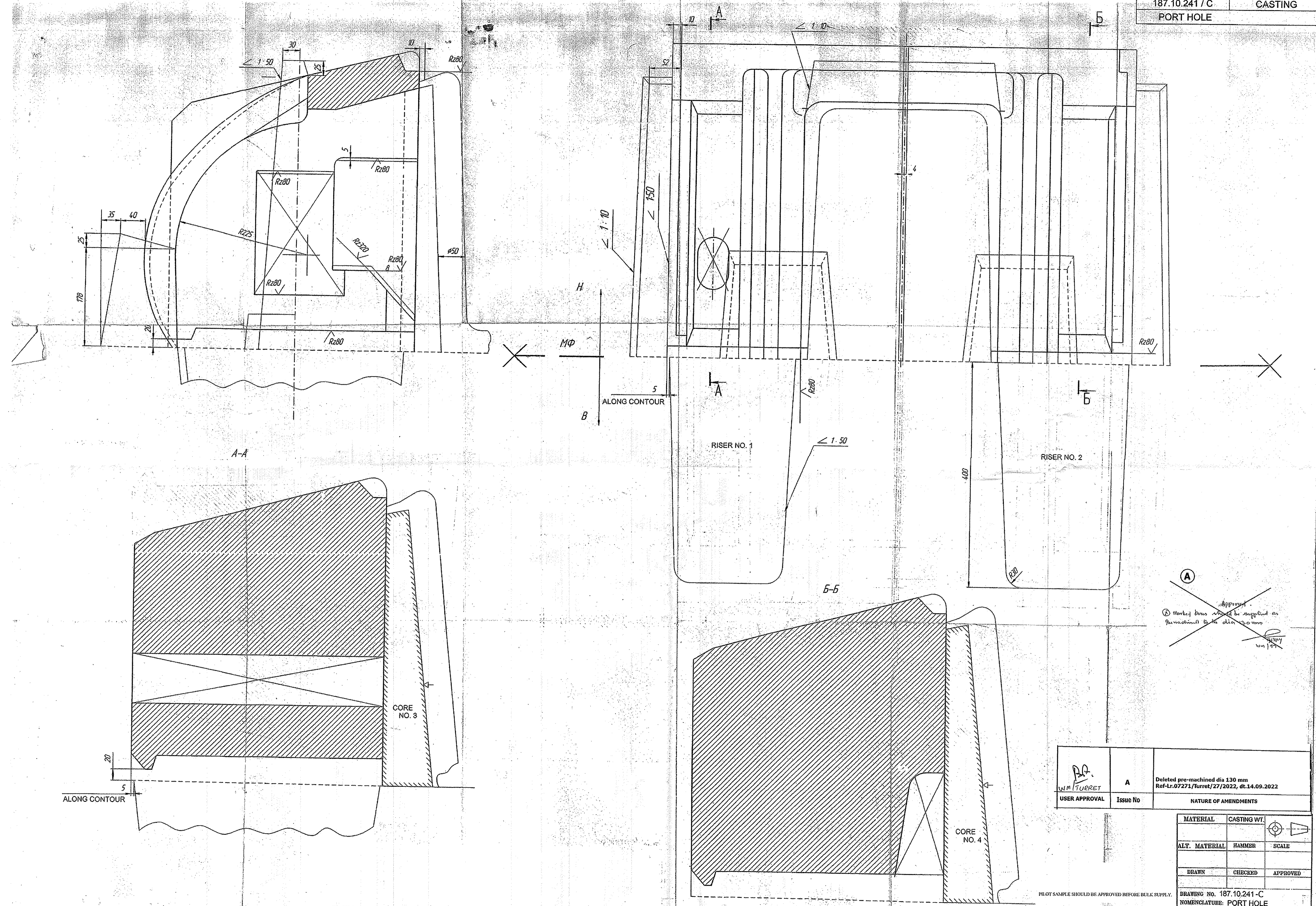
1. GRADE OF STEEL HEAT TREATMENT, METHOD OF ACCEPTANCE AND TESTS ARE AS PER THE LIST OF COMPONENTS, MADE OF SPECIAL STEEL.
2. MEDIUM HARDNESS.
3. REQUIREMENTS ARE AS PER 172.TY 5
4. UNSPECIFIED ROD UPTO 15MM
5. DRAFTS UPTO 3°
6. CASTING ACCURACY 12-0-0-5 GOST 26645-85.
7. SELECTION WITH SMOOTH CHANGE TO THE BASE SURFACE TO BE DONE ACCONISING TO DEPTH 11 (SEE VIEW UPWARD, SECTION Ш-Ш AND И-И)
8. WEIGHT OF CASTING - 755KG
9. SCALE 1:2

(A) Approved
 Marked items should be marked as per standard on drawings of the dia 130mm
 W.M.T

PILOT SAMPLE SHOULD BE APPROVED BEFORE BULK SUPPLY.

 W.M. TURRET USER APPROVAL	A	Deleted pre-machined dia 130 mm Ref-Lr.07271/Turret/27/2022, dt.14.09.2022
		NATURE OF AMENDMENTS

MATERIAL	CASTING WT.	T 90
172.TY 5	755Kg	
ALT. MATERIAL	HAMMER	SCALE
		1:2
DRAWN	CHECKED	APPROVED
DRAWING NO. 18710.241.C		
NOMENCLATURE: PORT HOLE		
HEAVY VEHICLES FACTORY AVADI,CHENNAI		

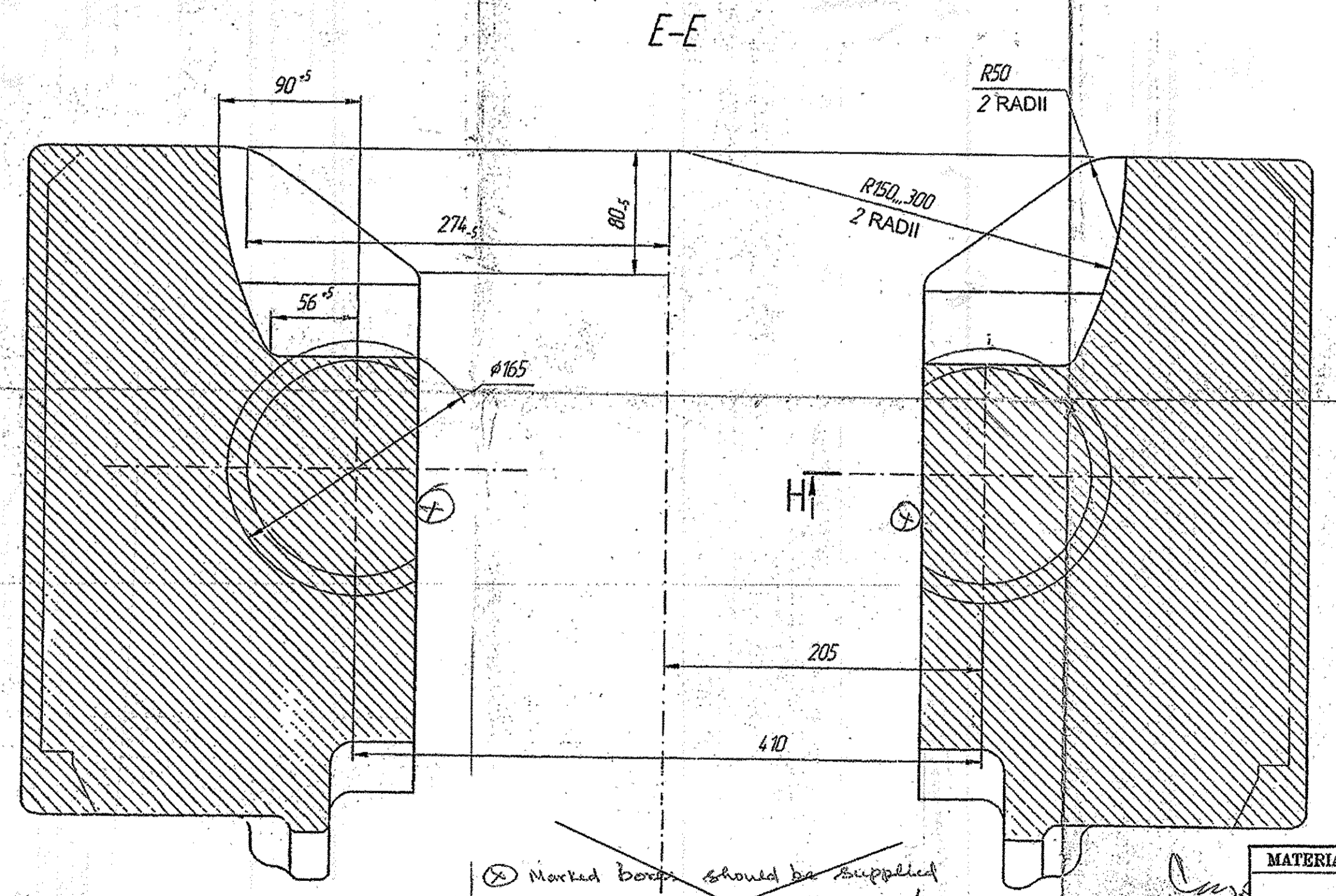
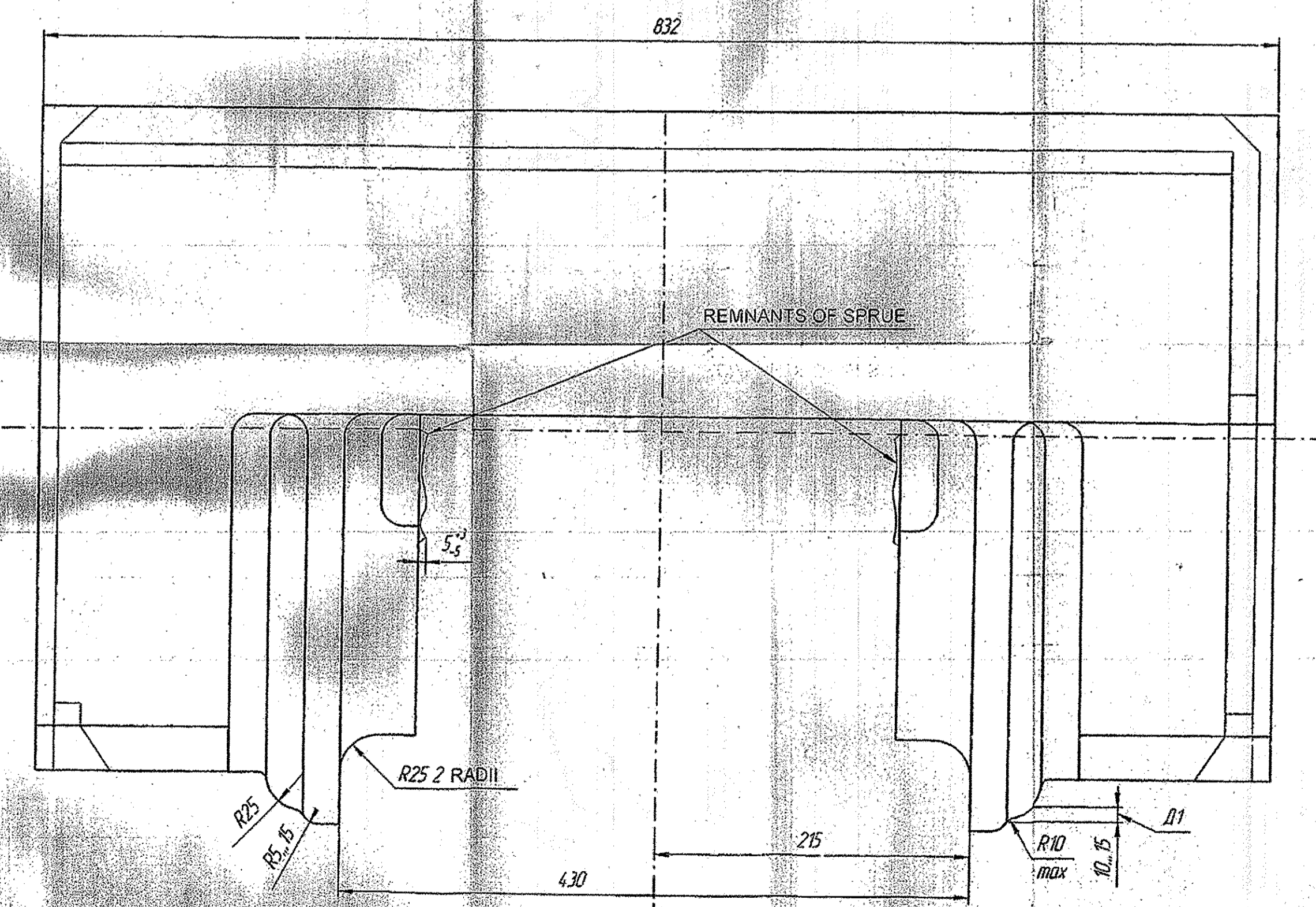
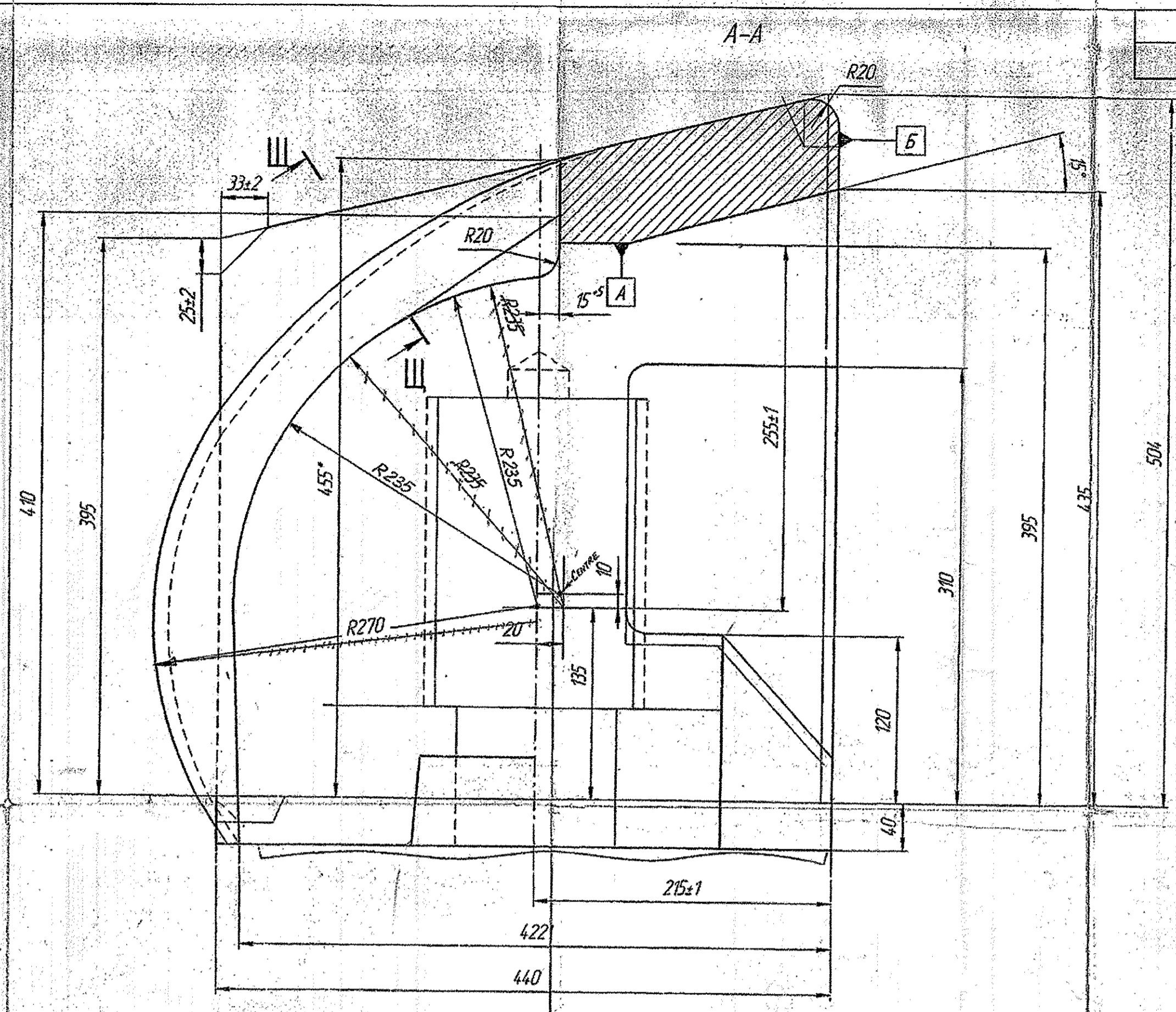
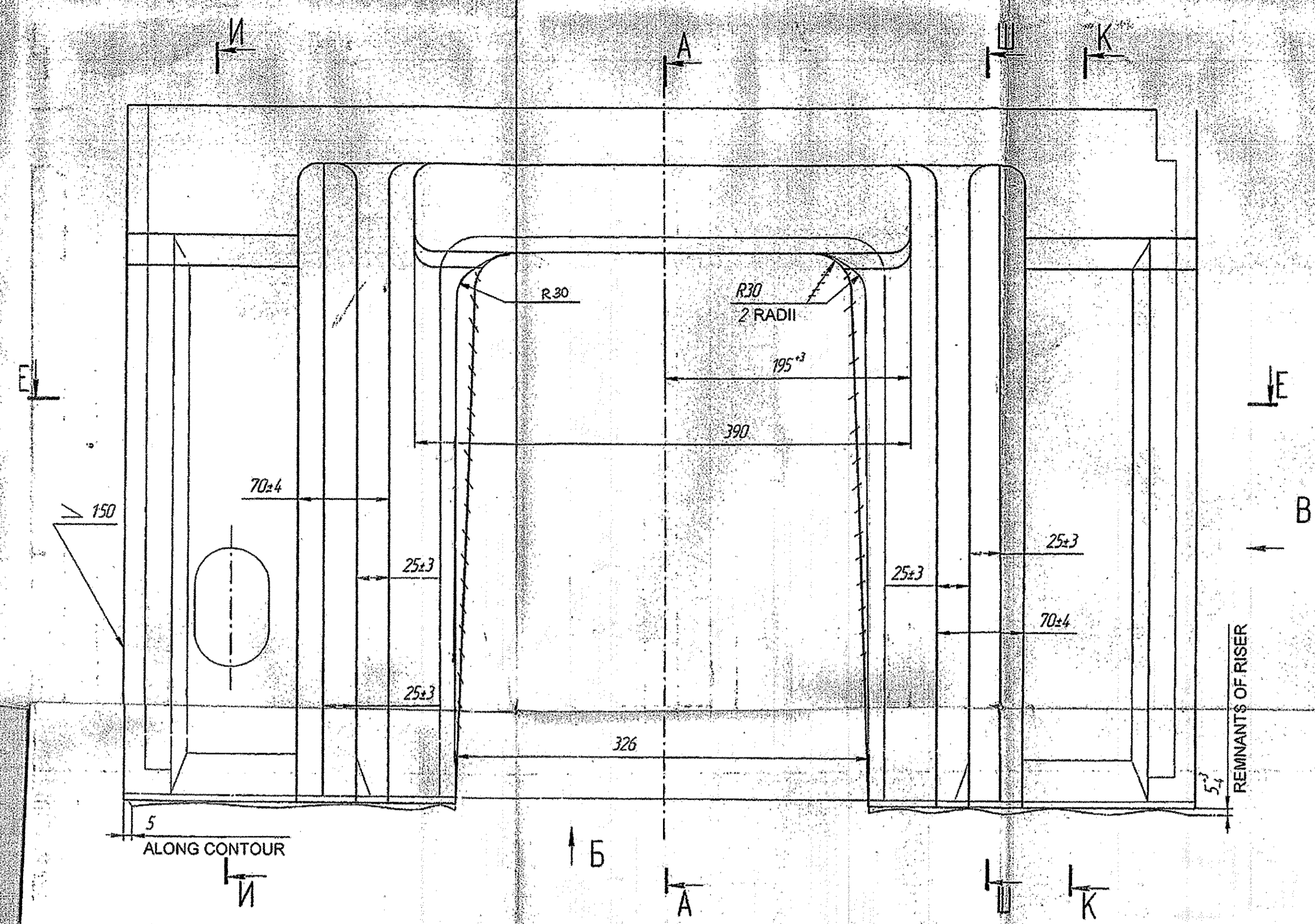


~~Approved~~
 Marked areas should be supplied as per mechanical drawing specifications.

<i>PR</i> USER APPROVAL	A Issue No	Deleted pre-machined dia 130 mm Ref-Lr.07271/Turret/27/2022, dt.14.09.2022
NATURE OF AMENDMENTS		

MATERIAL	CASTING WT.	
ALT. MATERIAL	HAMMER	SCALE
DRAWN	CHECKED	APPROVED
DRAWING NO. 187.10.241-C		
NOMENCLATURE: PORT HOLE		
HEAVY VEHICLES FACTORY		

PILOT SAMPLE SHOULD BE APPROVED BEFORE BULK SUPPLY.



(A) Approved
Marked boxes should be as pre-machined to the dia 130 mm
W.M. Iyer

(X) Marked boxes should be supplied as pre-machined to the dia 130 φ
W.M. Iyer

 W.M. IYER USER APPROVAL	A	Deleted pre-machined dia 130 mm Ref-Lr.07271/Turret/27/2022, dt.14.09.2022	MATERIAL	CASTING WT.	
			ALT. MATERIAL	HAMMER	
			DRAWN	CHECKED	APPROVED
			DRAWING NO. 187.10.241-C NOMENCLATURE: PORTHOLE		
			HEAVY VEHICLES FACTORY AVADI, CHENNAI		

PILOT SAMPLE SHOULD BE APPROVED BEFORE BULK SUPPLY.