

USED ON

ZONE	ITEM NO	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	QTY	REMARKS
		175.45.010cbCb		PIPE LINE		
		& ITEM LIST				
	1	175.45.047		PIPE	1	
	2	175.45.048		PIPE	1	
7	3	172.66.341 155.59.540		SWIVEL ELBOW	1	
	4	172.45.097-1		SWIVEL ELBOW	1	
	5	172.45.100 OR		SWIVEL ELBOW	1	
		172.45.100A		SWIVEL ELBOW		

COMMON TO T-90 & BLT

I/L RE-CREATED BASED ON RUSSIAN ORIGINAL ISSUE - 6

172.45.060cbCb
-175.45cbCb
188.45.001cb-3Cb
PV572.0711.0093

(B. JAYAVELU, JT0[D]
15-09-06

8B	06.05.12	55150/CQA(HV)/DB/BLT T-72 Dt.19.07.11			
8A	25.10.04	N OF A No. CQA(HV)/T90/45/001			
8	01.07.91	DRAWING AMENDED.			
7	24.11.88	AMDT. LIST. No.6 / II BOOK - 7			
ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS

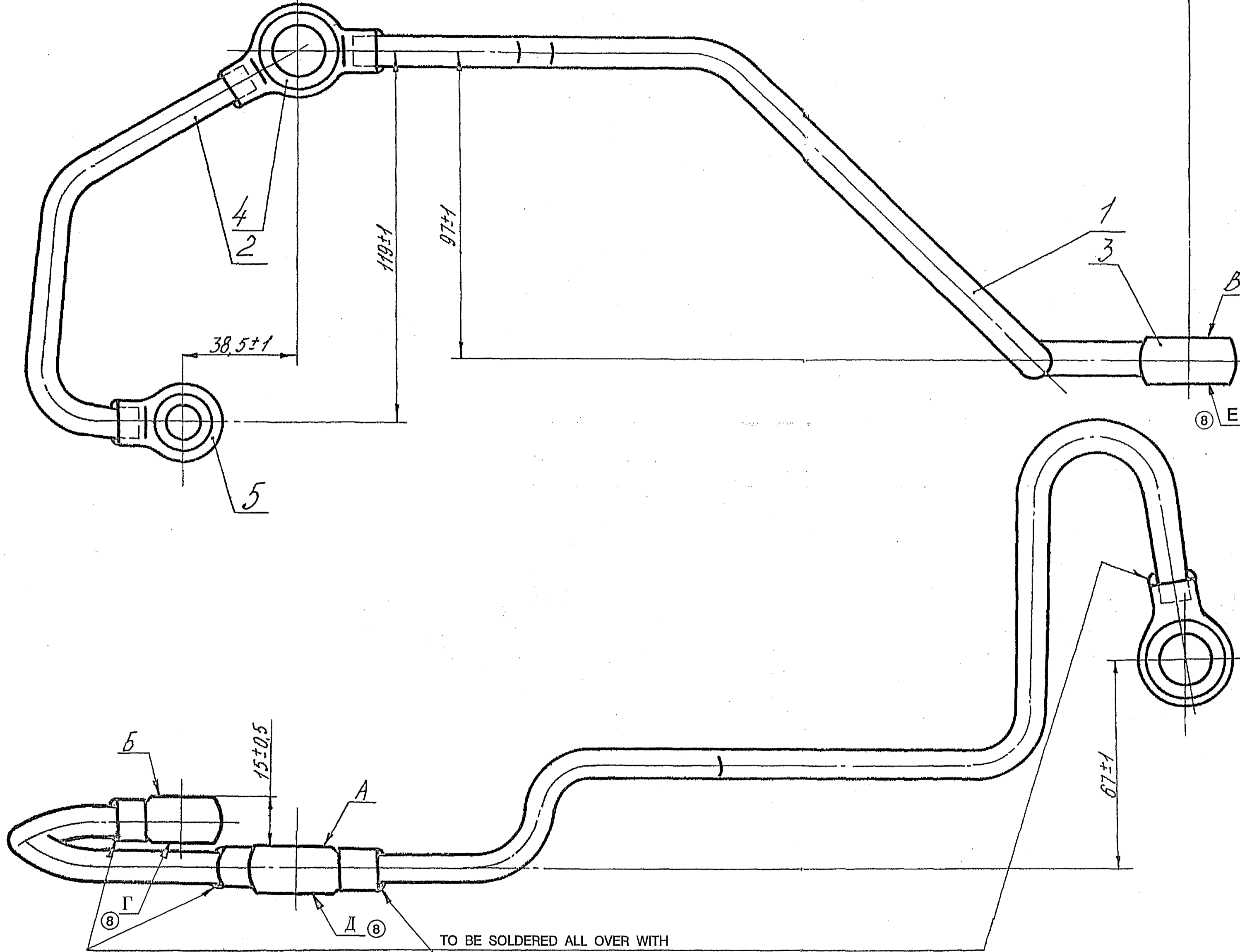
F - 84
10

DRN	Sd/=	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.			
CHD	Sd/=	TITLE : PIPE LINE			
APPD	Sd/=				
DATE	04 - 03 - 88				

DRAWING NUMBER
175.45.010cbCb

SHEET No. 1 OF 1

283±1



1. NON PARALLELISM OF SURFACES "A" AND "B" IS NOT TO EXCEED 0.5 mm WITHIN OVER ALL DIMENSIONS OF TURNING ELBOWS.
2. NON - SQUARENESS OF SURFACE "B" WITH SURFACE "A" AND "B" SHOULD NOT BE MORE THAN 0.5 mm WITHIN OVER ALL DIMENSIONS OF TURNING ELBOWS.
3. THE PIPE LINE IS TO BE SUBJECTED TO HYDRO-STATIC OR PRESSURE TEST AT A PRESSURE OF 4 Kg / cm² LEAKAGE OF LIQUID OR SEEPAGE OF AIR IS NOT ALLOWED.

⑧ 5. COATING : PAINTING IN COMPLIANCE WITH THE CURRENT SPECIFICATIONS

⑧ 5. COATING : EXTERNAL SURFACES EXCEPT FACES A, B, Γ, Δ, E PRIMER ПІ - 03K. DARK GREY ENAMEL ПІ - 223 OR ПІ - 115 DARK GREY ENAMEL 894. INTERNAL SURFACES INSULATING VARNISH ГІ - 95. REQUIREMENTS AS PER 520 TY 5.

TO BE SOLDERED ALL OVER WITH
AK-62-0.5 OR *1060-1* GOST 16130-72
OR WELDED.

188.45.001cb-3Cb ⑧A

COMMON TO T-90 & BLT
DRG. RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 6

COMMON TO T-90 & BLT
DRG. RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 6

F-84
10
SIZE A2

PILOT SAMPLE SHOULD BE APPROVED BY A I S P BEFORE BULK PRODUCTION.

EST. WT. (Kg)	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
0.24	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

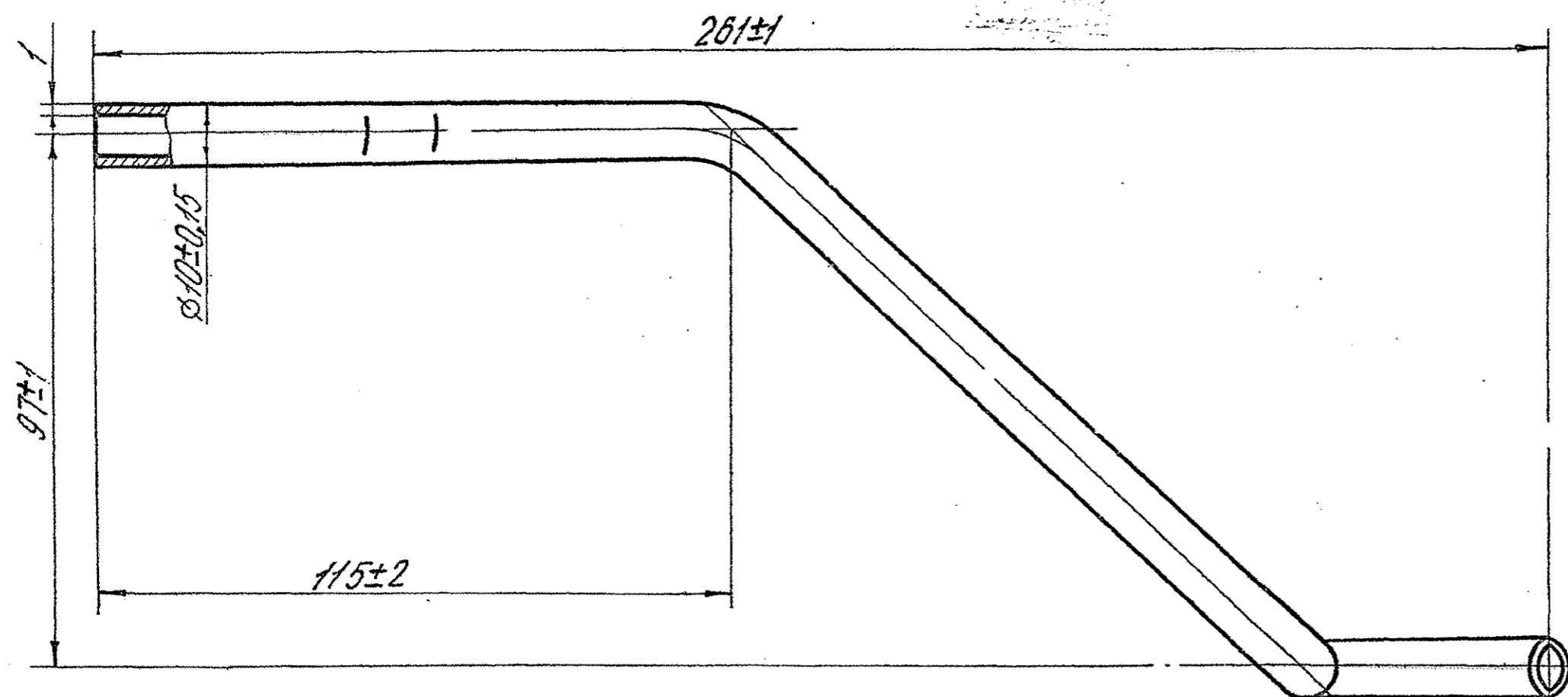
DRN	Sd / =	MATERIAL :-	USED ON :-
CHD	Sd / =		175.45ebCb
APPD	Sd / =		172.45.060cbCb
DATE	04 - 03 - 88		PV572.0711.0093 ⑧B
SCALE:- 1 : 1		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
DIMENSIONS IN mm		TITLE :-	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69		PIPE LINE	
8B	06.05.12	55150/CQA(HV)/DB/BLT T-72 Dt.19.07.11	D S CAT NUMBER
8A	25.10.04	N OF A No.CQA(HV)/T90/45/001	DRAWING NUMBER
8	01.07.91	NOTN.172M.807 'A'-88(AL.12 BK-1)	175.45.010cbCb
7	24.11.88	I/L AMENDED.	
ISSUE	DATE	NATURE OF AMENDMENTS	

DRN	Sd / =	MATERIAL :-	USED ON :-
CHD	Sd / =		175.45ebCb
APPD	Sd / =		172.45.060cbCb
DATE	04 - 03 - 88		PV572.0711.0093 ⑧B
SCALE:- 1 : 1		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
DIMENSIONS IN mm		TITLE :-	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69		PIPE LINE	
8B	06.05.12	55150/CQA(HV)/DB/BLT T-72 Dt.19.07.11	D S CAT NUMBER
8A	25.10.04	N OF A No.CQA(HV)/T90/45/001	DRAWING NUMBER
8	01.07.91	NOTN.172M.807 'A'-88(AL.12 BK-1)	175.45.010cbCb
7	24.11.88	I/L AMENDED.	
ISSUE	DATE	NATURE OF AMENDMENTS	

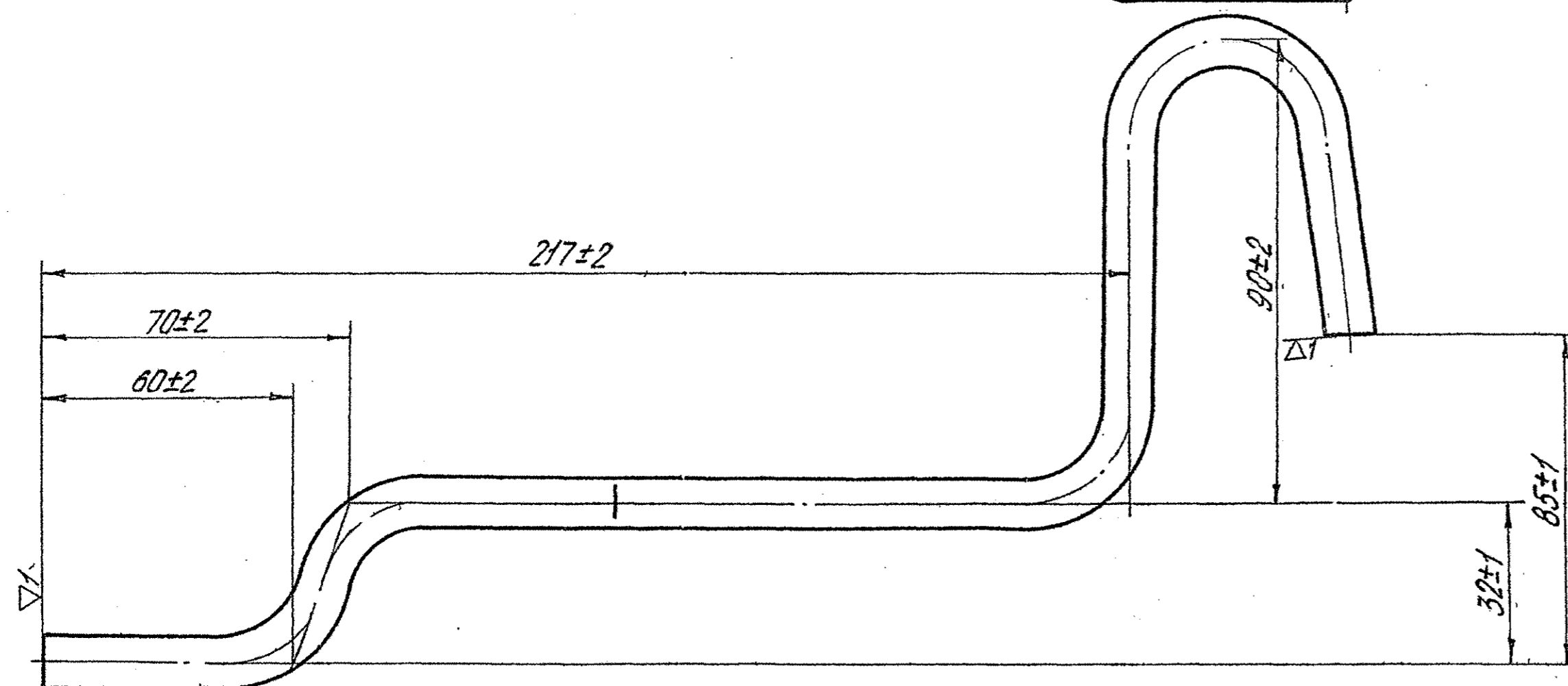
DRAWING NUMBER
175.45.047

SHEET No. 1 OF 1

~(V)



1. SMOOTH-SURFACE DENTS UP TO 1.5 mm DEEP ARE ALLOWED ON THE TUBE SURFACE. DENTS ARE NOT ALLOWED AT A LENGTH OF 10 mm FROM END FACES.
2. FOLDS UP TO 2 mm HIGH ARE ALLOWED ON BENDS.
3. OVALITY OF THE TUBE AT A LENGTH OF 10 mm FROM END FACES SHOULD NOT EXCEED 10 mm AND ON THE REMAINING LENGTH THE OVALITY SHOULD NOT EXCEED 2 mm.
4. NOMINAL DIMENSIONS OF STRAIGHTENED LENGTH ≈ 452 mm.
5. RADII OF TUBE BENDING SHOULD BE R20 mm IN PLANE OF BENDING ALONG THE TUBE AXIS.



(A) ALT. MATL: CDS GDE 2 OR 3 TO IS: 3074-79

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. WT. (Kg) 0.1	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

DRN	Sd/=	MATERIAL:- TUBE	USED ON:-
CHD	Sd/=	10 x 1 GOST 8734 - 75	175.45.010CbCb
APPD	Sd/=	B 20 GOST 8733 - 74	
DATE	18-09-86	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE:-	1 : 1	AVADI	
DIMENSIONS IN mm		TITLE:-	TUBE
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69			
ISSUE	DATE	NATURE OF AMENDMENTS	D S CAT NUMBER
A	07-07-06	AUTHY Lt.No. 80001/CQA(HV)/GEN Dt. 15.10.05	DRAWING NUMBER
			175.45.047

Approved
(B. JAYAVELU, JTDI)
27-07-06

COMMON TO T-90
DRAWING RE-INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NIL

F-85

SIZE A2

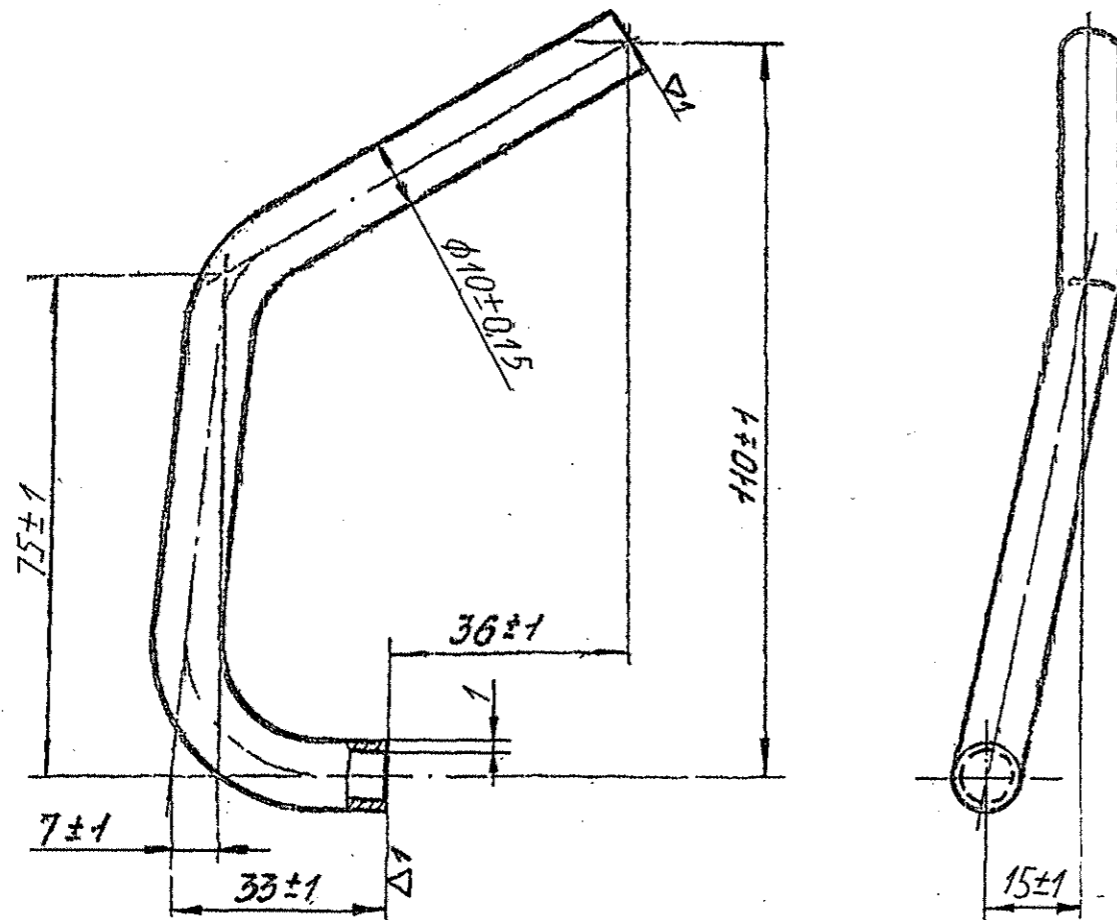
Approved
 (B. JAYAVELU, JTDI)
 21-07-06

COMMON TO T-90
 DRAWING RE - INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 4

DRAWING NUMBER
175.45.048

SHEET No. 1 OF 1

∞ (▽)



1. SMOOTH - SURFACE DENTS UP TO 1.5 mm DEEP ARE ALLOWED ON TUBE SURFACE. DENTS ARE NOT ALLOWED AT A LENGTH OF 10mm FROM END FACES.
2. FOLDS UP TO 2mm HIGH ARE ALLOWED ON BENDS.
3. OVALITY OF TUBE AT A LENGTH OF 10mm FROM END FACES SHOULD NOT EXCEED 2 mm.
4. NOMINAL DIMENSIONS OF STRAIGHTENED LENGTH ≈ 160 mm.
5. RADII OF BENDING SHOULD BE R20 mm IN PLANE OF BENDING ALONG THE TUBE AXIS.

ⓐ ALT. MATL: CDS GDE 2 OR 3 TO IS: 3074-79

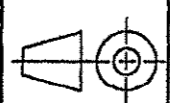
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. WT. (Kg) 0.04 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

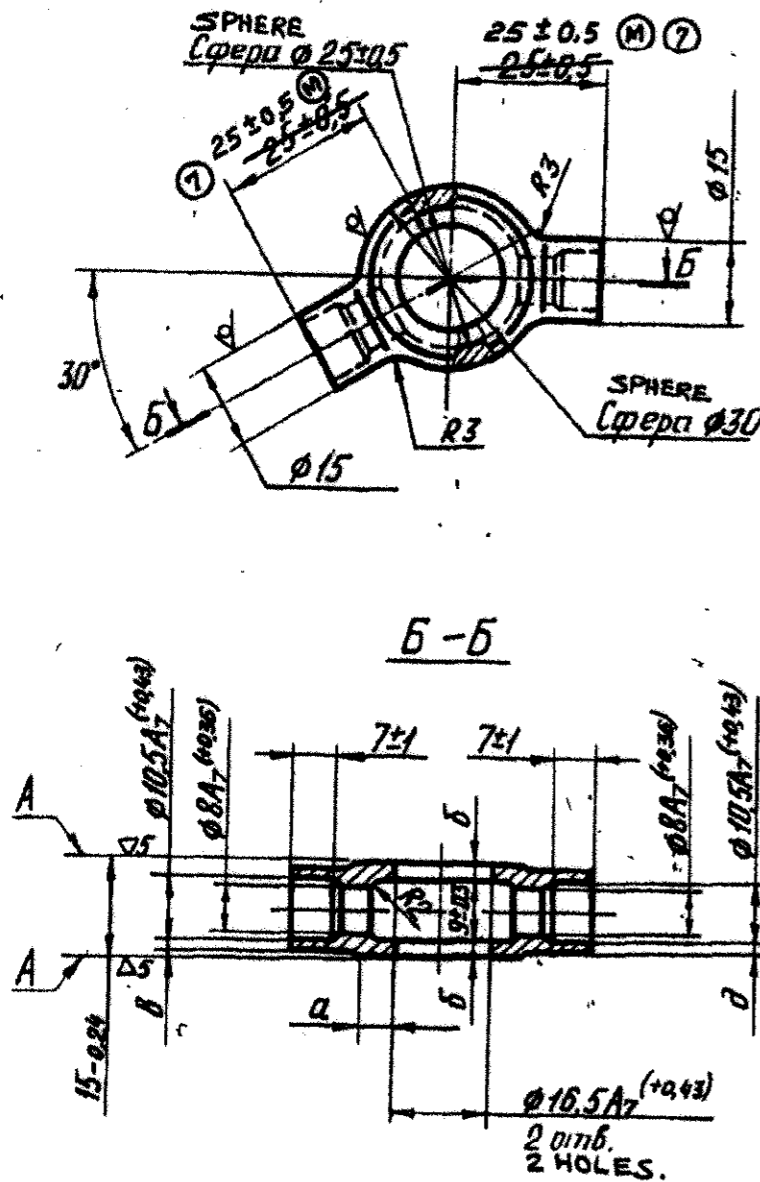
F - 85

SIZE A3

			DRN	Sd/=	MATERIAL:- TUBE	USED ON:-
			CHD	Sd/=	10 x 1 GOST 8734 - 75	175.45.010cb
			APPD	Sd/=	B20 GOST 8733 - 74.	
			DATE	18-9-86	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
			SCALE:-	1:1	AVADI	
			DIMENSIONS IN mm		 TITLE:- TUBE	
			TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69			
			ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
						175.45.048
4A	07-07-06	AUTHY Lt No 80001/CQA(HV)/GEN Dt 15.10.05	ISSUE	DATE	NATURE OF AMENDMENTS	

CHEMICAL COMPOSITION

GRADE OF STEEL	C	Si	Mn	Cr.	S	P
STEEL 15 GOST 1050-88	0.12 - 0.19	0.17 - 0.37	0.35 - 0.65	0.25 Max.	0.040 Max.	0.035 Max.
GDE-070M20 BS: 970-83	0.16 - 0.24	-	0.50 - 0.90	-	0.025-0.050	0.050 Max.



ALT. MATL: BS: 970-83 070M20
 AUTH: COA (HV)
 LETTER NO. 091/IED/IND-V/
 MTPP/OE
 DT: 17/03/2005

MECHANICAL PROPERTIES

STEEL 15 GOST 1050-88	YIELD POINT Kg/mm ²	23 Min.	ELONGATION, REDUCTION OF AREA %	27 Min.	HARDNESS HB	126-179
GDE-070M20 BS: 970-83	YIELD STRENGTH N/mm ²	215 Min.	ELONGATION %	55 Min.		
	TENSILE STRENGTH Kg/mm ²	38 Min.				
	TENSILE STRENGTH N/mm ²	430 Min.				

Восстановленный подлинник №1

▽3(▽)

- Component may be manufactured from open hearth steel Grades from 20 to 40 GOST 1050-60.
- Non-parallelism of planes "A" is not more than 0.1mm within overall dimensions of the component.
- Non squareness of axis of hole $\phi 16.5$ to planes "A" is not more than 0.15mm within overall dimensions of component. (MMC)
- Difference in measurements of dimension "a" is 1mm, Maximum.
- Difference in measurements of dimension 'g' is 0.5mm, maximum.
- Dimensions "b" and "z" should be 1mm, minimum.
- Projection of $\phi 15$ beyond planes 'A' is not allowed. Flats on $\phi 15$ surfaces are permissible.
- Technical requirements for unmachined stamped surfaces are in compliance with 80.018 Ty. ⑥

** OPENHEARTH STEEL 15 TO GOST 1050-60

USED ON: 175-45-010CD

PILOT SAMPLES ARE TO BE CHECKED BY A H S P BEFORE BULK PRODUCTION. This drg. has been prepared based on AHSP drg.

ESTT. WT. 0.04 Kg. TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTER)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

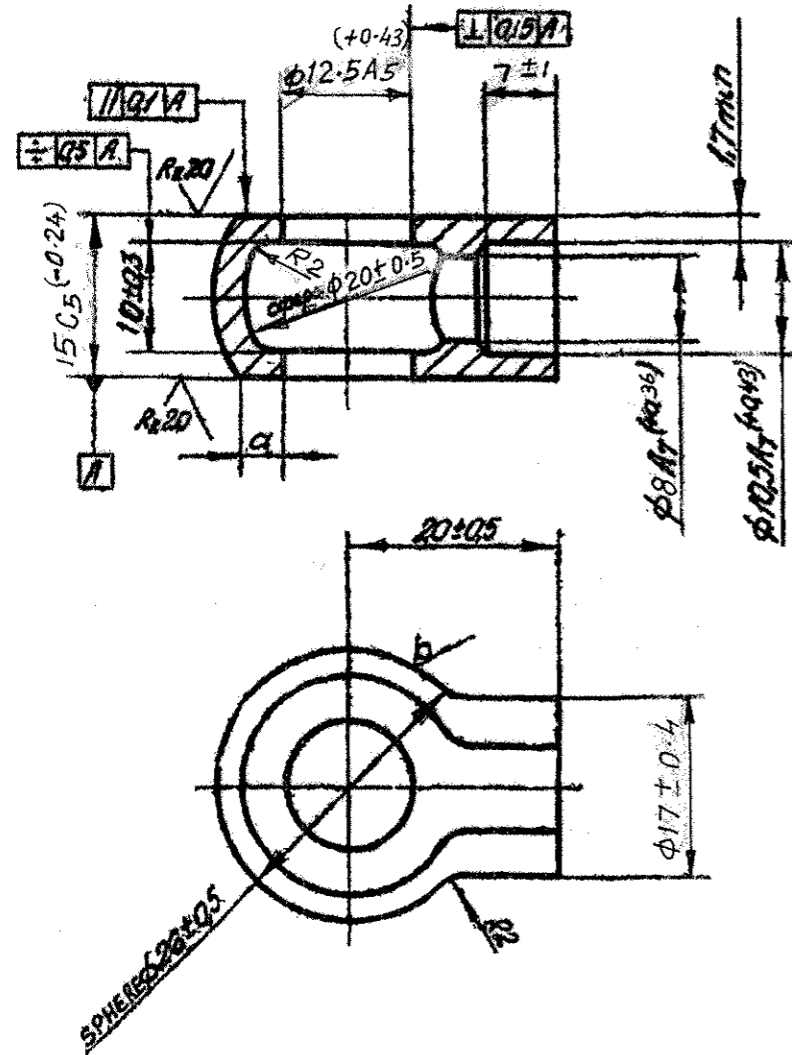
इन आरेखणों तथा इसके साथ की सम्पूर्ण सामग्री का स्वत्वाधिकार भारत सरकार रक्षा मंत्रालय की भारतीय आयुध निर्माणियों के पास है। भारतीय आयुध निर्माणियों के महानिदेशक की लिखित अनुमति के बिना इनकी नकल या किसी भी रूप में इनके उद्धरण या इनमें समाहित सूचना किसी अनधिकृत व्यक्ति को उपलब्ध नहीं कराई जानी चाहिए।
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मूलमाप व अन्वयोजन
 NOMINAL SIZE & FIT

विचलन
 DEVIATION

1	SWIVEL ELBOW	4	**			WT = 0.04 Kg
संख्या NO. OFF	विवरण DESCRIPTION	पुर्जा क्र. PART NO.	पदार्थ MATERIAL	मानक STANDARD	परिमाण DIMENSIONS	अभ्यक्ति REMARKS
<p>सामान्य सहिष्णुता GENERAL TOLERANCE</p> <p>रेखिक परिमाण LINEAR DIMENSION</p> <p>कोणिक परिमाण ANGULAR DIMENSION</p> <p>मापक 'म्यू एम' में VALUE IN "um"</p>						
<p>2005</p> <p>दिनांक DATE</p> <p>नाम NAME</p> <p>मापमान SCALE</p> <p>आरेखित DRAWN</p> <p>जाँचा CHECKED</p> <p>अनुमोदित APPROVED</p> <p>द्वारा बदला REPLACED BY</p> <p>हेतु बदला REPLACED FOR</p> <p>आरेखण क्र. DRAWING NO.</p>						
<p>TURNING ELBOW</p> <p>TRANSMISSION GEAR UNIT</p> <p>CODE - 45 T-72/T-90</p>				<p>मशीनी औजार आदिरूप फैक्टरी, अम्बरनाथ MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH</p> <p>कार्यालय OFFICE</p> <p>D.O.</p>		
						172-45-097-1

26



CHEMICAL COMPOSITION

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C	Mn	Si	Cr	Ni	Cu	P	S
25 J GOST 977-75	0.22-0.30	0.35-0.90	0.20-0.52	0.30	0.30	0.30	-	-
BS:970-83 070M20	0.16-0.24	0.50-0.90	-	-	-	-	0.050	0.025-0.050

UNLESS OTHERWISE SPECIFIED ✓ (✓)

MECHANICAL PROPERTIES:

GRADE OF STEEL	YIELD STRENGTH Kgf/mm ²	ULTIMATE STRENGTH Kgf/mm ²	ELONGATION %	REDUCTION %	IMPACT STRENGTH Kgf/m/cm ²
25 J GOST 977-75	24	45	19	30	4
BS:970-83 070M20	TENSILE STRENGTH N/mm ²	ELONGATION %	YIELD STRENGTH N/mm ²	HARDNESS HB	-
	430	21 Min.	215 Min	125-179	-

1. COMPONENT MAY BE MANUFACTURED FROM STEEL, GRADES: 20Л-I, 30Л-I GOST 977-75.
2. DRAUGHTS: 1:20
3. REQUIREMENTS FOR CASTING ARE IN COMPLIANCE WITH 172.TY10.
4. DIFFERENCE IN MEASUREMENTS OF DIMENSION 'a' IS NOT MORE THAN 1mm.

ALT. MATL: BS:970-83 070M20
AUTH: CQA(HV) LETTER NO. 091/IFD/IND-V/MTPP/DE DT. 17-03-2005.

VETTED
24 JUN 2005
JWM/STG-CELL

VETTED
28 DEC 2007
JWM/STG-CELL

*** MATERIAL:- STEEL
25Л-I GOST 977-75

USED ON 175.45.010.C8

PILOT SAMPLES ARE TO BE CHECKED BY A H S P BEFORE BULK PRODUCTION. This drg. has been prepared based on AHSP drg.

ESTT. WT. 0.06 Kg. TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTER)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

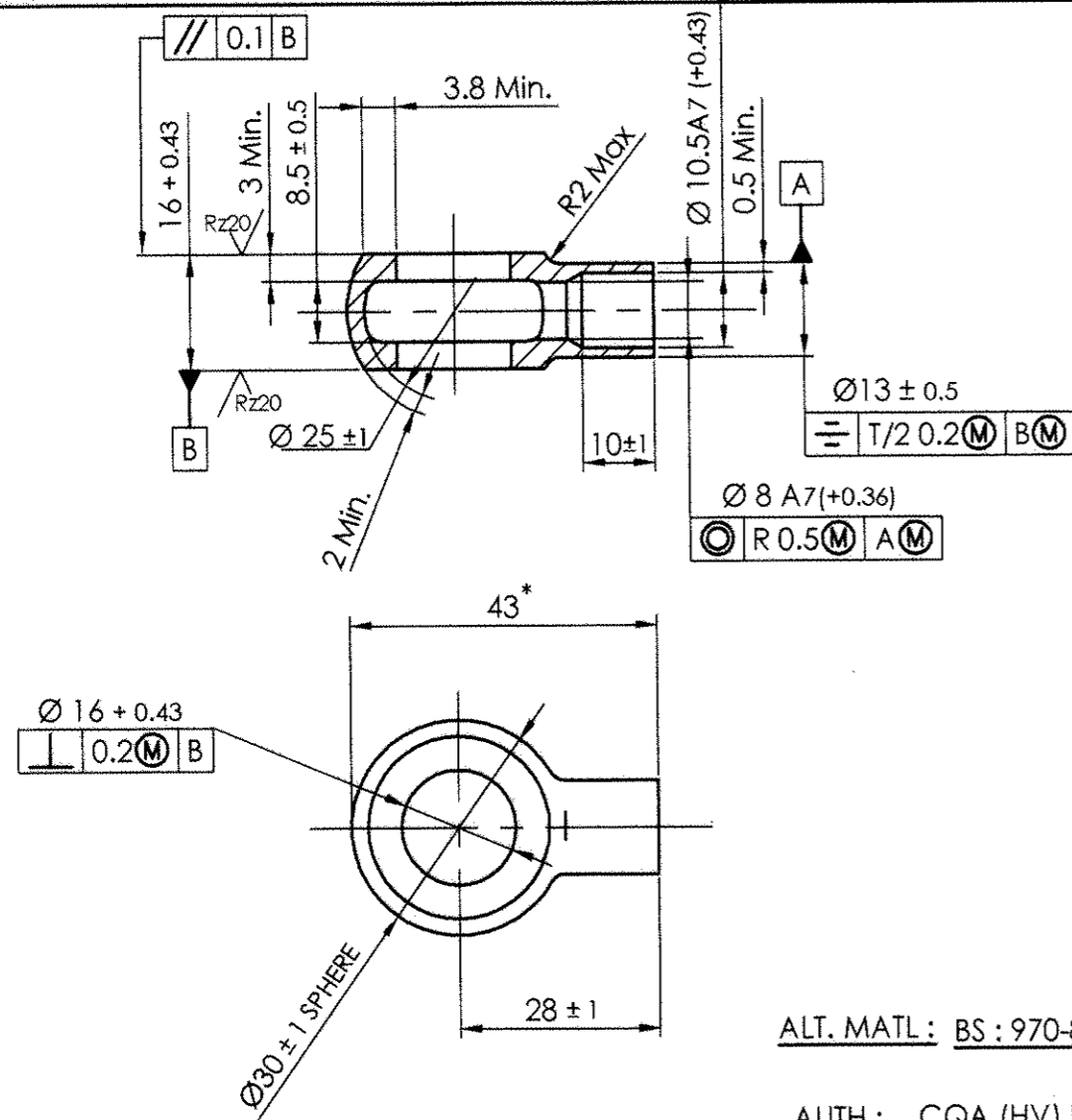
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मूलमाप व अन्वयोजन
NOMINAL SIZE & FIT

विचलन
DEVIATION



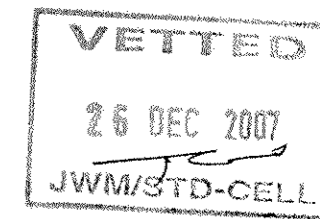
1	SWIVEL ELBOW	5	***				WT : 0.06 Kg.	
संख्या NO.OFF	विवरण DESCRIPTION	पुर्जा क्र. PART NO.	पदार्थ MATERIAL	मानक STANDARD	परिमाण DIMENSIONS	अभ्यक्ति REMARKS		
सामान्य सहिष्णुता GENERAL TOLERANCE								
रेखिक परिमाण LINEAR DIMENSION								
0-6 ±0.1								
6-30 ±0.2								
30-120 ±0.3								
120-315 ±0.5								
315-1000 ±0.8								
1000-2000 ±1.2								
कोणिक परिमाण ANGULAR DIMENSION	संख्या NO.OFF	संबंधित पुर्जाका आरेखण क्र. DRG. NO OF ASSOCIATED PART	सूचक INDEX	संशोधन ALTERATION	2005	दिनांक DATE	नाम NAME	
1-10 ±1°								
10-50 ±30'								
50-100 ±20'								
>100 ±10'								
नापांक 'म्यू एम' में VALUE IN 'um'								
- >25								
~ 8-25								
∇∇ 1.6-8								
∇∇∇ 0.025-1.6								
∇∇∇∇ <0.025								
TURNING ELBOW TRANSMISSION GEAR UNIT CODE-45 T-72/T-90							मापमान SCALE 1:1	आरेखित DRAWN 19-1 VML
मशीनी औजार आदिरूप फैक्टरी, अम्बरनाथ MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH							कार्यालय OFFICE D-O-	जाँचा CHECKED 24-1 A/r
द्वारा बदला REPLACED BY							हैतु बदला REPLACED FOR	आरेखण क्र. DRAWING NO. 172-45-100-A



ALT. MATL : BS : 970-83 070M20

AUTH : CQA (HV) LETTER No.
091 /IFD/IND-V/MTPF/OE
DT: 17-03-2005

CHEMICAL COMPOSITION IN %		
STEEL 15 GOST 1050 - 88	GDE -070M20 BS :970 -83	
C	0.12- 0.19	0.16 - 0.24
Si	0.17 - 0.37	--
Mn	0.35 - 0.65	0.50 - 0.90
Cr.	0.25 Max.	--
S	0.040 Max.	0.025 - 0.050
P	0.035 Max.	0.050 Max.
MECHANICAL PROPERTIES		
YEILD POINT Kg / mm ² 23 Min.	TENSILE STRENGTH N/mm ² 430 Min.	
ULTIMATE TENSILE STRENGTH Kg / mm ² 38 Min.	YEILD STRENGTH N/mm ² 215 Min.	
ELONGATION , % 27 Min.	ELONGATION 5.65 √s ₀ % , Min. 21	
REDUCTION OF AREA 55 Min.	HARDNESS HB 126 - 179	



USED ON 172-66-087CD, 172-66-089CD,
172-66-091CD, 172-66-093CD.

1. ALTERNATIVE MATERIAL: STEEL 20 GOST 1050-74
2. DIMENSION FOR REFERENCE.
3. THE OF THE REQUIREMENTS ARE AS 520 TY 1.

PILOT SAMPLE SHOULD BE APPROVED BY AHSP
BEFORE BULK PRODUCTION. *This drg. has been prepared based on AHSP drg.*

इन आरेखणों तथा इसके साथ की सम्पूर्ण सामग्री का स्वत्वाधिकार भारत सरकार रक्षा मंत्रालय की भारतीय आयुध निर्माणियों के पास है। भारतीय आयुध निर्माणियों के महानिदेशक की लिखित अनुमति के बिना इनकी नकल या किसी भी रूप में इनके उद्धरण या इनमें समाहित सूचना किसी अनधिकृत व्यक्ति को उपलब्ध नहीं कराई जानी चाहिए।
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मापक 'म्यू एम' में VALUE IN "um"	विचलन DEVIATION
-	> 25
∅	8-25
∅∅	1.6-8
∅∅∅	0.025-1.6
∅∅∅∅	< 0.025

TURNING ELBOW		STEEL 15 GOST: 1050-74			WT. = 0.04 Kg.																									
संख्या NO. OFF	विवरण DESCRIPTION	पुर्जा क्र. PART NO.	पदार्थ MATERIAL	मानक STANDARD	परिमाण DIMENSIONS	अभ्यक्ति REMARKS																								
<table border="1"> <thead> <tr> <th>संख्या</th> <th>संबंधित पुर्जा का आरेखण क्र.</th> <th>सूचक</th> <th>संशोधन</th> <th>दिनांक</th> <th>नाम</th> </tr> <tr> <th>NO. OFF</th> <th>DRG. NO. OF ASSOCIATED PART</th> <th>INDEX</th> <th>ALTERATION</th> <th>DATE</th> <th>NAME</th> </tr> </thead> <tbody> <tr> <td>1-10</td> <td></td> <td></td> <td></td> <td>2007</td> <td></td> </tr> <tr> <td>10-50</td> <td></td> <td></td> <td></td> <td>21.12</td> <td>CMR</td> </tr> </tbody> </table>							संख्या	संबंधित पुर्जा का आरेखण क्र.	सूचक	संशोधन	दिनांक	नाम	NO. OFF	DRG. NO. OF ASSOCIATED PART	INDEX	ALTERATION	DATE	NAME	1-10				2007		10-50				21.12	CMR
संख्या	संबंधित पुर्जा का आरेखण क्र.	सूचक	संशोधन	दिनांक	नाम																									
NO. OFF	DRG. NO. OF ASSOCIATED PART	INDEX	ALTERATION	DATE	NAME																									
1-10				2007																										
10-50				21.12	CMR																									
TURNING ELBOW FOR PIPE LINE DRG. No. 172-45-010CD INTERMEDIATE GEAR BOX, CODE - 45, T - 72 / T - 90				मापमान SCALE	आरेखित DRAWN																									
				1:1	जाँचा CHECKED																									
					अनुमोदित APPROVED																									
				द्वारा बदला REPLACED BY	हेतु बदला REPLACED FOR																									
मशीनी औजार आदिरूप फैक्टरी, अम्बरनाथ MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH				कार्यालय OFFICE	आरेखण क्र. DRAWING NO. 172-66-341																									