

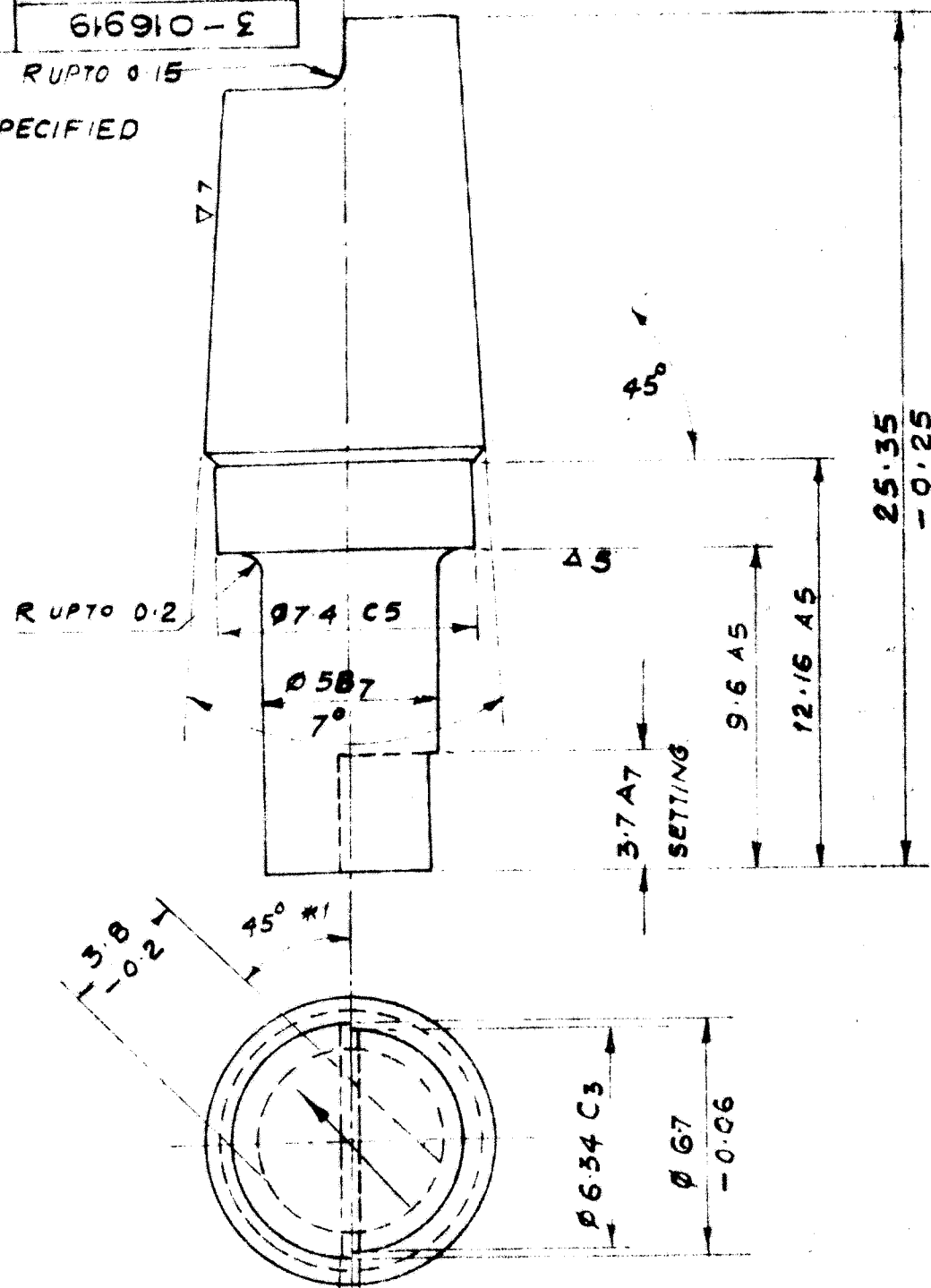
92

616910-2

D.C.I 28794-A

R UPTO 0.15

▽ 3 WHERE NOT SPECIFIED



DEVIATION OF THE PLANE OF DEPRESSION RELATIVE TO THE AXIS OF THE PART.

0.075

0.025

MATERIAL:- BSEN:12166-1998 MATERIAL
 SYMBOL CuZn40 Pb2 NUMBER CW 617N
 CONDITION R410

6.7.11	DC.37284-A	MATERIAL AMENDED	
3.5.90	34858-A	MATL. SPECN. SUPERSEDED.	
11-2-88	D.C.I. 34825-A	D.S. CAT NO. ADDED.	
21-4-85	D.C.I. 33748-A	PROTECTIVE TREATMENT NOTE NO 7 AMENDED	
13-2-82		TRACED WITHOUT CHANGE	
		PREVIOUS D.C.S (S) NOS:- 28794-A, 29221-A, 29306-A, 29486-A, 31028-A & 33258-A.	
DATE	AUTHORITY	REVISION	AHSP D.O. SIGN.

D.S. CAT No
 1390-000371

3-016919

53-B-025y

36

SETTING SCREW

LETTER MASS

6.6.24

BRASS AC 69-1
 GOBT 1019 - 47

- 1) FOR THE COCK HOLE BORED BY 0.15 MM IN THE HOUSING A COCK OF SECOND VERSION IS TO BE MANUFACTURED HAVING THE FOLLOWING DIMENSIONS -
 $\phi 6.49C3$ INSTEAD OF $\phi 6.34 C3$ AND $\phi 6.85 - 0.06$ INSTEAD OF $\phi 6.7 - 0.06$
- 2) THE ARROW \rightarrow IS TO BE MARKED ON THE BOTTOM FACE OF THE PART
- 3) FOR THE SECOND VERSION OF THE COCK, THE \rightarrow MAY BE MARKED WITH A VERTICAL BAR PREFIXED \rightarrow
- 4) THE ANGLE OF THE CONE OF THE COCK AND THE COCK ROLE CONE ANGLE IN THE HOUSING TO BE ACHIEVED BY PREPARING CORRESPONDING CUTTING AND CONTROL MEASURING MEANS AND JIGS ON THE BASIS OF A COMMON MASTER GAUGE USED AT THE PLANT AS STANDARD. ANGLE ON THE STANDARD MUST BE WITHIN THE RANGE OF $7^\circ \pm 5'$
- 5) ANGLE OF 45° TO BE CHECKED WITH A GAUGE HAVING THE FOLLOWING
 a) HOLE (FOR THE TAIL END OF THE PART HAVING A DIMENSION OF $3.8 - 0.2$) WITH DIMENSIONS 3.81 AND 5.01
 b) INSERT SLEEVE (TO GO INTO THE CUT IN THE TOP SECTION OF THE PART) HAVING A WIDTH OF 2.99 HAVING A TAPER AT AN ANGLE OF $45^\circ \pm 3'$ AND HOUSED IN THE GROOVE OF WIDTH 3.01 AND LENGTH 14
- 6) LACQUERING - LACQUER WITH SHELLAC LAC 3-5%
 TYFAY 4391-54
- 7) PROTECTIVE TREATMENT:- IN INDIA TO BE COATED WITH APC M222 TO SPECIFICATION NO J95 1-83-II

CD MAN	DRN	CNO	TRE