U | 3-016919

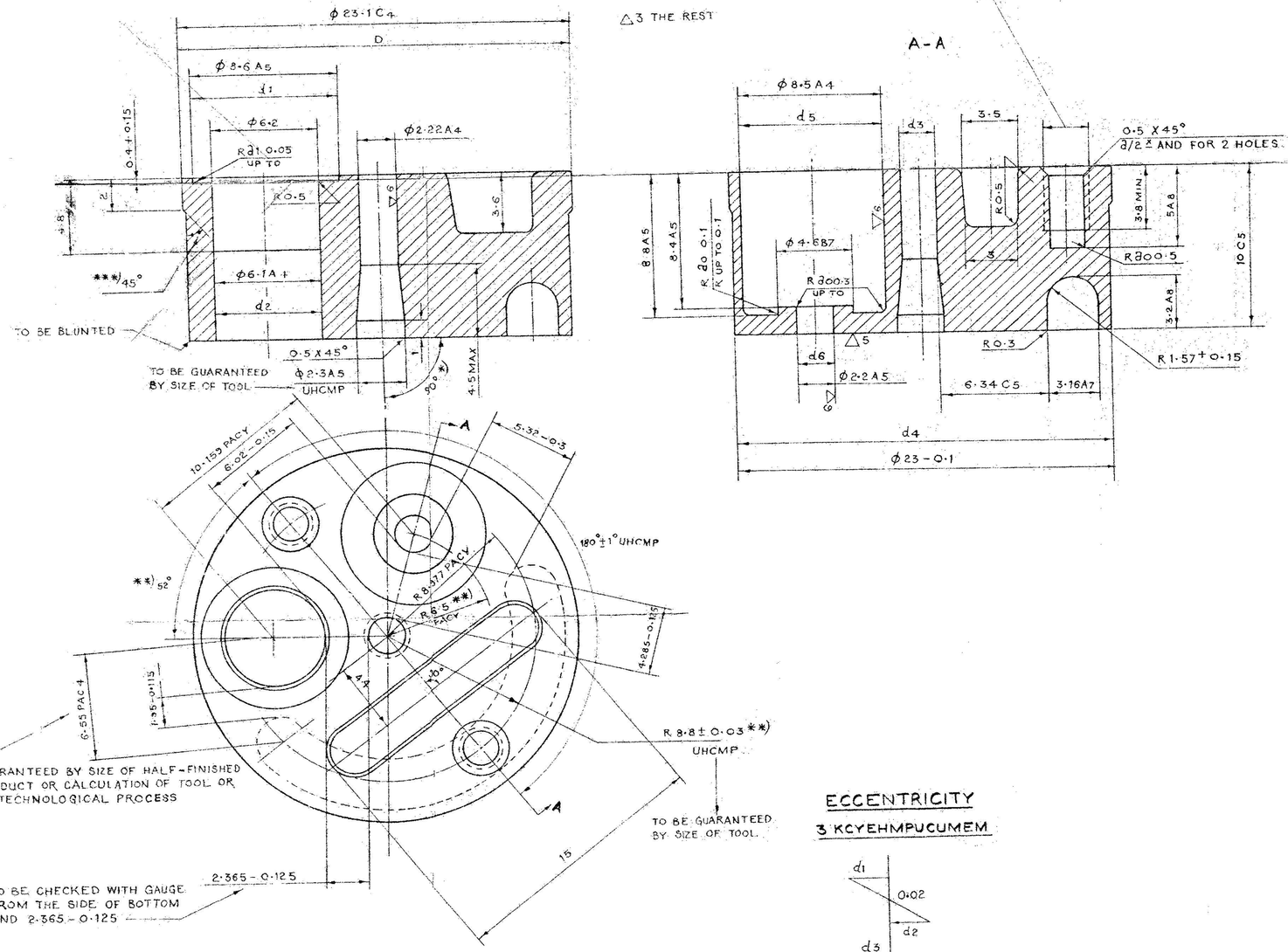
DC-29162-A

SPEC. M 2·6 X 0·45 CL.2 FOR 2 HOL.

OUTER HOP ϕ = 2·6

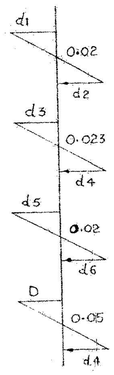
MIDDLE CP ϕ = 2·308 + 0·067

INNER BH ϕ = 2·113 + 0·12



ECCENTRICITY

3 KCYEHMPUCUMEM



1 THREADS S P M 2·6 X 0·45 CLASS 2 ARE NOT TO BE CHECKED WITH 'NO. GO THREAD GAUGE'

2 RECESS OR CUT IN THE PLACE OF TRANSITION OF DIAMETERS 23·1 C4 & 23−0·1 IS PERMITTED

3 *) 90° TO BE CHECKED WITH GO GAUGE WITH A SMALL NAIL ϕ 2·18

**) 52 TO BE CHECKED WITH GO GAUGE HAVING

a) NAIL ϕ 6·035 FIXED AT A DISTANCE OF 6·5 CALCULATED FROM THE CENTRE OF THE GAUGE

b) NAIL ϕ 2·18, 2·093

c) HOUSING ϕ 2·133 PLACED AT AN ANGLE OF 180° AT A DISTANCE OF R 8·8 ± 0·03 FROM CENTRE OF THE GAUGE.

5 CRACKS, RUPTURES, CAVITIES, BULGES, SLOGS & CONTINUOUS NON-COMPACT STRUCTURE ARE NOT PERMITTED.

6 THE FOLLOWING ARE PERMITTED :-

a) INTERNAL PORES

b) "MOHAZ" TYPE FINE GROUND - SWELLS & INSIGNIFICANT UNMASSIVE STRUCTURE ON THE SURFACE.

c) PARTIAL STRIPPING OF DEPTH UP TO 0·1 mm & WIDTH IN TOTAL NOT MORE THAN 1/4 OF THE CIRCUMFERENCE ON THE SURFACES OF ALL THE CHANNELS.

d) UNEVEN COLOUR ON ENTIRE SURFACE

7 HAVING FIXED THE TECHNOLOGICAL PROCESS OF MANUFACTURE OF COMPONENTS SELECTIVE CHECKING WITH CALIBRES CAN BE DONE (PERCENTAGE IS FIXED BY THE FACTORY WITH THE CONCURRENCE OF THE CUSTOMER.) DIMENSION 10 C 5 IS CHECKED 100 %

8 DIMENSION ϕ 23−0·1 IS CHECKED AT A HEIGHT UP-TO 3 mm ANGLE OF TAPERING ON ϕ 23 − 0·1 IS PERMITTED BUT SHOULD NOT EXCEED THE LIMIT OF ϕ 23·05

9 DIMENSIONS WITHOUT ALLOWANCES ARE EXECUTED WITHIN THE LIMITS OF 7 TH. CLASS & ARE NOT CHECKED WITH GAUGE

10 MAKING OF 2 THROUGH HOLES UNDER THE THREAD IS PERMITTED.

11 MECHANICAL PROPERTIES OF ALLOY ARE NOT CHECKED.

ON THE GENERAL HEIGHT OF THE COMPONENT 10 C5 PARTIAL GAPPING OF THE CIRCUMFERENCE UP-TO 3·75 MINUTES IS PERMITTED

13 ***) 45° ANGLE CAN BE CHANGED.

~~14 IN INDIA TO BE COATED WITH APC NO 222 TO SPECIFICATION NO JSS 1-63-11~~

15 VARNISHED COMPONENTS HAVING IMPROPER PAINTING, STRIPING AND PEALING OF VARNISH FILM ARE NOT PERMITTED. RUN (SAG) OF PAINT NOT AFFECTING THE WORKING OF THE ITEM IS PERMITTED.

14 THE COMPONENT IS DEGREASED IN PETROL & PAINTED WITH 3-5 % SHELLAC VARNISH TY-CAY-4391-54 IN INDIA TO BE COATED WITH APC NO 222 TO SPECIFICATION NO JSS 1-63-11

16 SURFACE FINISH OF BOTTOM SURFACE COMING IN CONTACT WITH TOP SURFACE OF SLEEVE FOR STEMMING (DRG. NO 3-16919 DETAIL 20) SHOULD BE MAINTAINED AT 0·8 MICRON.

NOTE :- NO HIGH GRAIN SIZE AREAS ARE PERMITTED IN THE FINISHED PRODUCT AFTER MACHINING FOR ALUMINIUM ALLOY.

MAT. :- Al. Alloy to BS : 1490-1988 LM-6
OR - BS-617-1994 Alloy 4600 in 'M' condn

D.S. CAT No 1390-000288

8-7-11	DC-37248-B	MAT. SPECN. Amended			
25-11-88	DC 34489-A	NOTE 16 ADDED.		COATING	VARNISH - SEE DRAWING
11-2-88	D.S.C. 34325-A	D.S. CAT No ADDED.		3-0169'9	53-B-025 Y
21-4-85	D.C. 33748-A	NOTE No 14 IN INDIA ..... No JSS 1-63-11 ADDED.		ROTOR SLEEVE	17
20-9-84	D.C. 33662-A	MATERIAL AMENDED.			LETTER / WT. / SCALE: B / 5 / 7 / 5:1
3-2-84	D.C. 33484-A	DIMENSION LINE OF 2·365-0·125 SHOWN CORRECTLY.			
10-8-82		TRACED WITHOUT CHANGE			
		PP VIA (1) D.C.(U) No 23162-A, 23227-A, 23300-A, 23595-A & 23154-A		ALUMINIUM ALLOY AL2 GOST 2685-63	SHEET 1 TOTAL SHEETS 1
DATE	AUTHORITY	REVISION	AHSP / DO	SIGN	

B	1			
A.L.	QTY.			

MATL. :- IN INDIA ALUMINIUM ALLOY TO SPECIFICATION BS 1490 - 1970 LM GM OR IS 617-1975 ALLOY 4600 IN 'M' CONDITION.

10-9-2001		SCANNED WITHOUT CHANGE		
29-3-97	D.C. 36264-A	NOTE REG. MACHINING FOR ALUMINIUM ALLOY ADDED		
5-3-97	D.C. 36253-A	IN NOTE No 8 ϕ 23-0·1 WAS ϕ 23-01.		
DATE	AUTHORITY	REVISION	AHSP	D.O.

DATE	AUTHORITY	REVISION	AHSP	D.O.	

CO MAN	DRN	CHD	TCD	COMP.

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