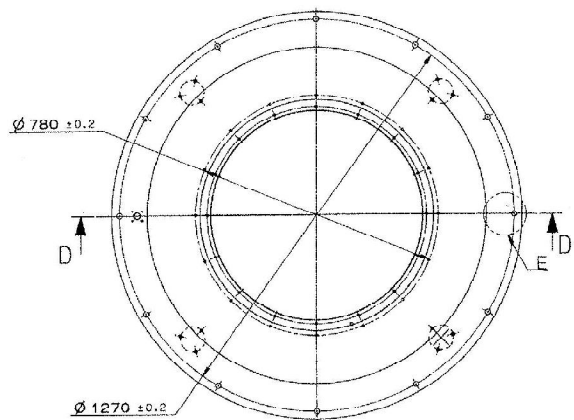
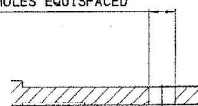
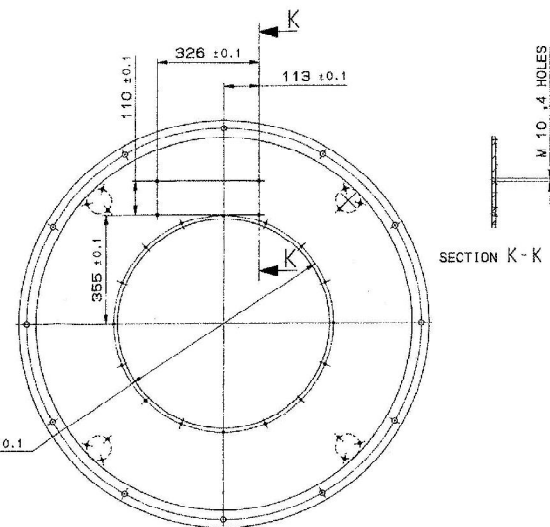


DETAIL E
SCALE 1:2

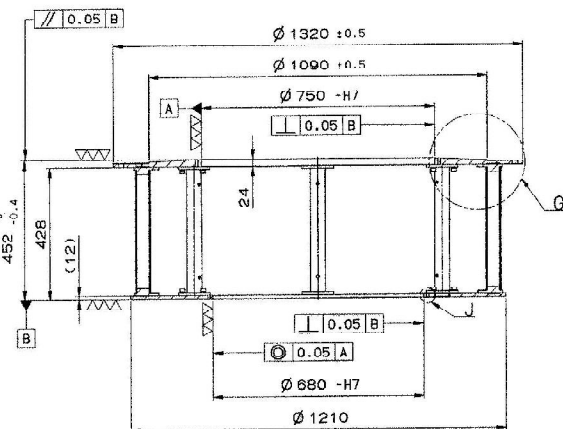
Ø 17, 12 HOLES EQUISPACED



SECTION F-F



SECTION K-K



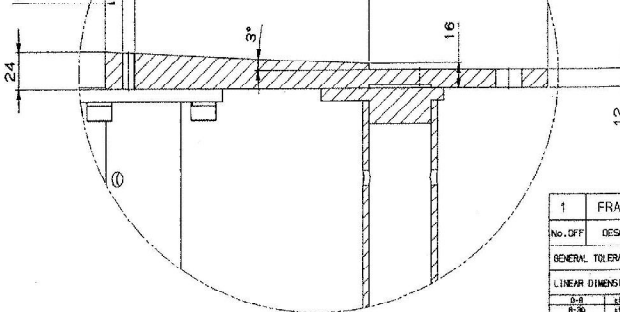
SECTION D-D



DETAIL J
SCALE 1:2

M 8 - 16 HOLES
EQUISPACED

Ø 750 - H7



DETAIL G
SCALE 1:2

NOTE:-

1. FOR TRAINING END LIMITS HOLE POSITION REFER DGR. NO. DW-1179
2. M16 - 4 HOLES EQUISPACED TO BE MADE ON PCD 1270 FOR LIFTING
3. M10-3 HOLES TO BE DONE IN ASSY FOR LRMR LAUNCHER

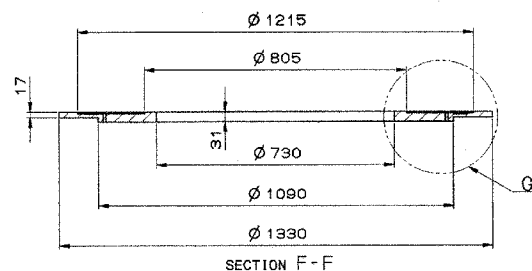
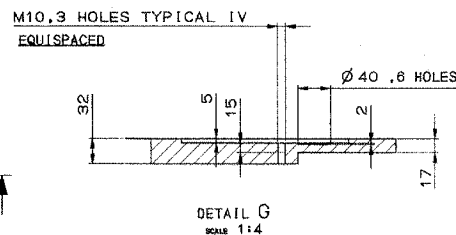
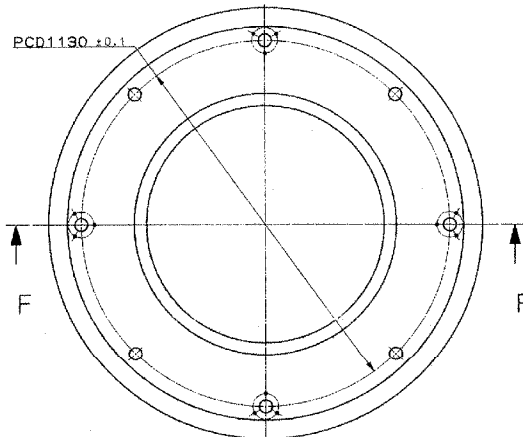
* TO BE MANUFACTURED FROM DW-1108-0210-42

* PHOSPHATING AND PAINTING

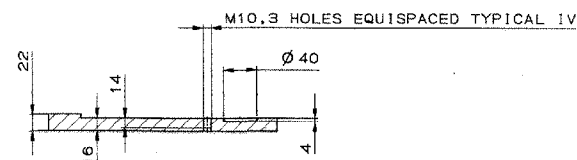
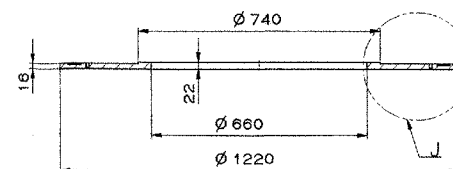
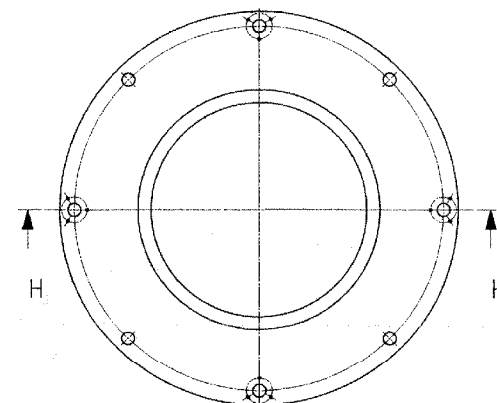
1. PHOSPHATING TO BE DONE AS PER IS:3018 CLASS B
2. PRIMER RED OXIDE TO STANDARD IS:12744 TO BE APPLIED BY FIRM WHO IS SUPPLYING STORE TO MPFAS PER DW-1134
3. PAINTING TO BE DONE AT MPF IN OR DURING ASSEMBLY AS PER DW-1134
4. DO NOT APPLY PRIMER AND PAINT ON THREAD AND BORE SURFACE

1	FRAME	**	*	*			
No. OFF	DESCRIPTION	PART No.	MATERIAL	STANDARD	DIMENSIONS	REMARKS	
GENERAL TOLERANCE							
LINEAR DIMENSIONS							
0-25	±0.1						
25-50	±0.2						
50-100	±0.3						
100-200	±0.5						
200-500	±0.8						
500-1000	±1.2						
1000-2000	±1.5						
ANGULAR DIMENSION							
No. OFF	Des. No. OF ASSOCIATED PART	INDEX	ALTERATION			DATE	NAME
1-10	±1°	FRAME					
10-30	±2°						
30-100	±3°						
100-180	±5°						
180-360	±10°						
VALUE IN "mm"							
0-25	±0.021	FRAME ASSY					
25-50	±0.035						
50-100	±0.050	LR-MR LAUNCHER					
100-200	±0.075	KAVACH MOD-II					
200-500	±0.100						
500-1000	±0.150						
1000-2000	±0.200						
MACHINE TOOL PROTOTYPE FACTORY							
AMBERNATH							
Design Office							
DRAWING No. DW-1108-0210-12							

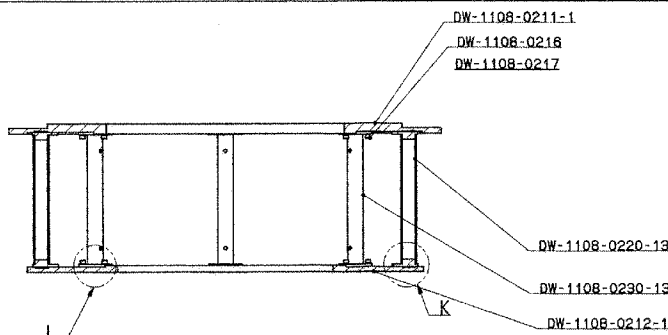
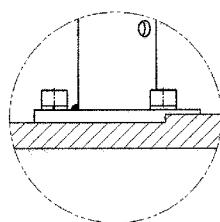
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ALTERNATE MATERIAL :- EN-8 OR
080M40 BS:970 PART-I 1983



ALTERNATE MATERIAL :- EN-8 OR
080M40 BS:970 PART-I 1983



DETAIL K
SCALE 1:2

E-WELDED

1. FIRST DRAWING NO. DW-1108-0211-1, DW-1108-0212-1
AND DW-1108-0230-13 SCREWED TOGETHER
2. DRAWING NO. DW-1108-0211-1, DW-1108-0212-1
AND DW-1108-0220-13 WELDED TOGETHER
3. STRESSES TO BE RELIEVED AFTER WELDING

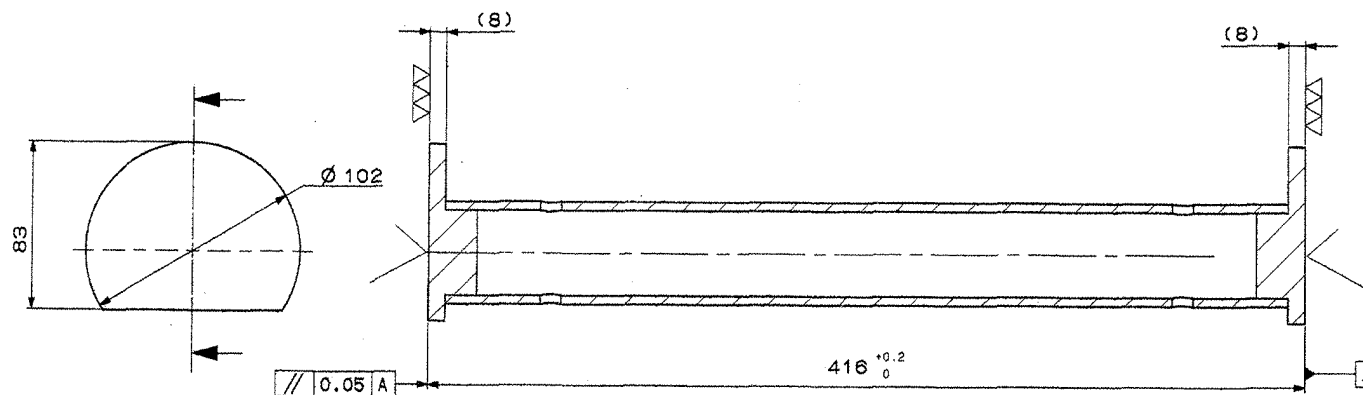
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NOMINAL SIZE & FIT DEVIATION

1		FRAME		PART No.		MATERIAL		STANDARD		DIMENSIONS		REMARKS	
No. OFF	DESCRIPTION												
GENERAL TOLERANCE													
LINEAR DIMENSIONS													
0-6	±0.1												
6-30	±0.2												
30-100	±0.3												
100-315	±0.5												
315-1000	±0.8												
1000-2000	±1.0												
ANGULAR DIMENSION													
1-15	±1°												
15-30	±30'												
30-100	±1'												
100	±10'												
VALUE IN "mm"													
0-25	±0.05												
25-50	±0.08												
50-100	±0.10												
100-200	±0.15												
200-300	±0.20												
FRAME (WELDING)													
FRAME ASSY													
LR-MR LAUNCHER													
KAVACH MOD-11													
MACHINE TOOL PROTOTYPE FACTORY.													
AMBERNATH													
SCALE 1:1													
DRAWN 10.10.00													
CHECKED 11													
APPROVED 23/12													
REPLACED BY													
REASON FOR													
DRAWING No.													
DW-1108-0210-42													



APPROVED



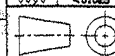
*
TO BE MANUFACTURED FROM DW-1108-0220-43



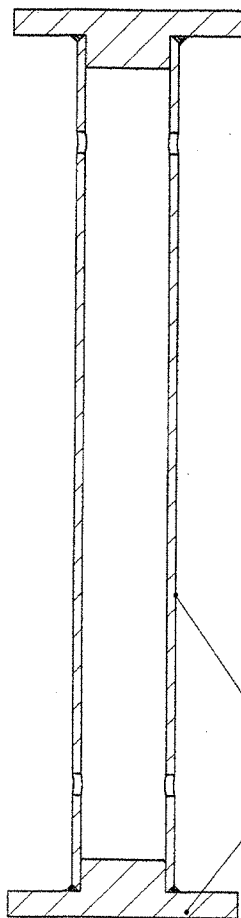
4	TUBE ASSY-I			*		
No. OFF	DESCRIPTION	PART No.	MATERIAL	STANDARD	DIMENSIONS	REMARKS
GENERAL TOLERANCE						
LINEAR DIMENSIONS						
0-8	±0.1					
8-30	±0.2					
30-120	±0.3					
120-315	±0.5					
315-1000	±0.8					
1000-2000	±1.2					
ANGULAR DIMENSION						
1-10	±1°					
10-50	±30'					
50-100	±20'					
>100	±10'					
VALUE IN "um"						
~	>25					
▽	0-25					
▽▽	1.0-8					
▽▽▽	0.025-1.0					
▽▽▽▽	<0.025					
TUBE ASSY-I						
FRAME ASSY						
LR-MR LAUNCHER						
KAVACH MOD-II						
MACHINE TOOL PROTOTYPE FACTORY, AMBARNATH						
Design Office						
DRAWING No. DW-1108-0220-13						

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NOMINAL SIZE & FIT DEVIATION



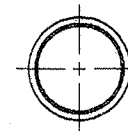
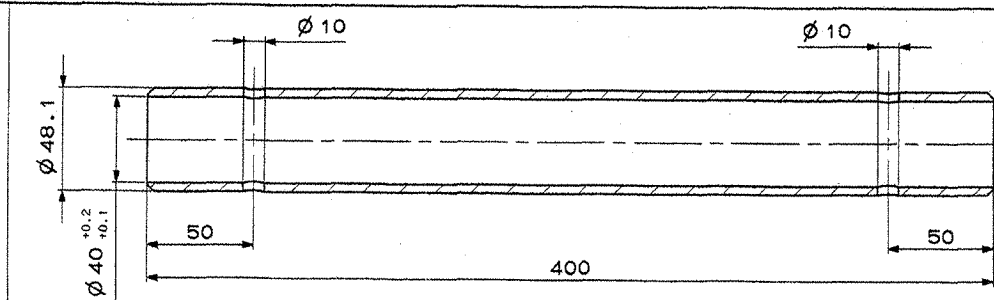
APPROVED



E-WELDED

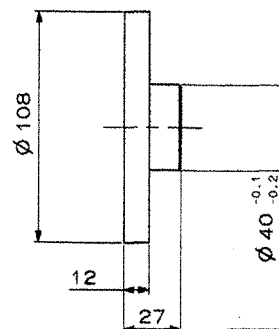
STRESSES TO BE RELIEVED AFTER

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~(▽)

DW-1108-0222-1	TUBE	IS:1161	1	1:2
DRAWING NO	NOMENCLATURE	MATERIAL	NO. OFF	SCALE



ALTERNATE MATERIAL :- EN-8 OR
080M40 BS:970 PART-1 1983

DW-1108-0221-1	FLANGE	40CB, IS:5517	2	1:2
DRAWING NO	NOMENCLATURE	MATERIAL	NO. OFF	SCALE

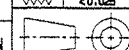
1	TUBE ASSY	*			BLACKENED	
No. OFF	DESCRIPTION	PART No.	MATERIAL	STANDARD	DIMENSIONS	REMARKS
GENERAL TOLERANCE						
LINEAR DIMENSIONS						
0-8	±0.1					
8-30	±0.2					
30-120	±0.3					
120-315	±0.5					
315-1000	±0.8					
1000-2000	±1.2					
ANGULAR DIMENSION						
No. OFF	DRG. No. OF ASSOCIATED PART	INDEX	ALTERATION		DATE	NAME
1-10	±1°		TUBE ASSY(WELDING) FRAME ASSY LR-MR LAUNCHER KAVACH MOD		SCALE 1:1	DRAWN 10.12.08
10-60	±30'					CHECKED
60-100	±20'					APPROVED
>100	±10'					
VALUE IN "um"						
~	>25					
▽	8-25					
▽▽	1.6-8					
▽▽▽	0.025-1.6					
▽▽▽▽	<0.025					
MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH				Design Office	DRAWING No. DW-1108-0220-43	

SCALE	DRAWN	19.12.08	1181
1:1	CHECKED		
	APPROVED		

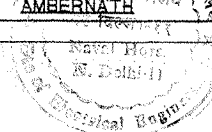
REPLACED BY	
REPLACED FOR	

DRAWING No.	DW-1108-0220-43
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NOMINAL SIZE & FIT DEVIATION

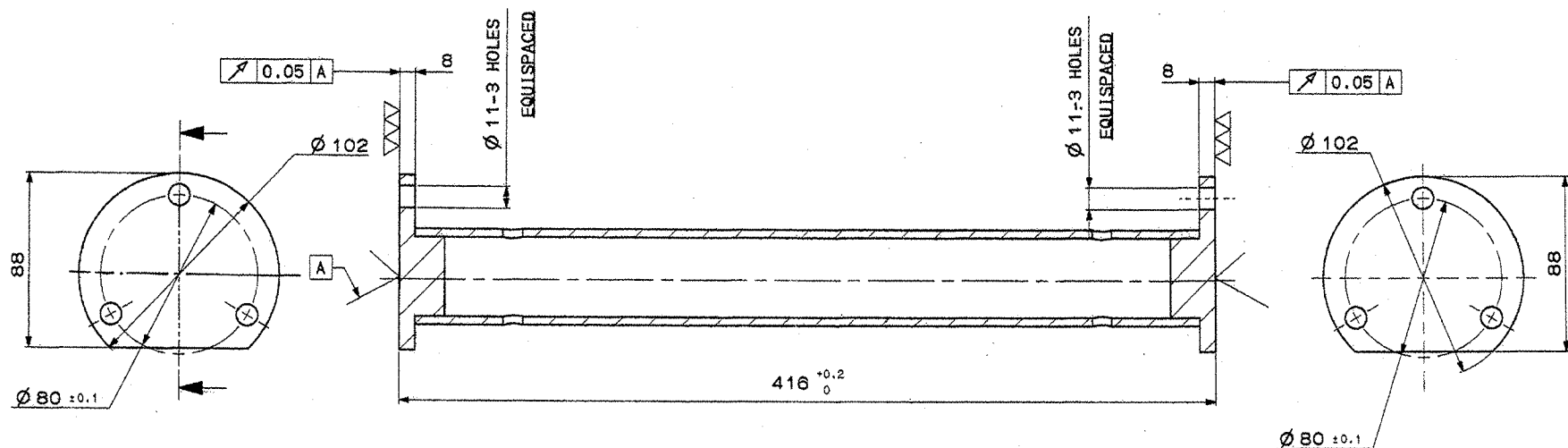


AMBARNATH



REMOVED





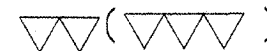
**

PHOSPHATING AND PAINTING

1. PHOSPHATING TO BE DONE AS PER IS:3618 CLASS B
2. PRIMER RED OXIDE TO STANDARD IS:12744 TO BE APPLIED BY FIRM WHO IS SUPPLYING STORE TO MPFAS PER DW-1134
3. PAINTING TO BE DONE AT MPF IN OR DURING ASSEMBLY AS PER DW-1134
4. DO NOT APPLY PRIMER AND PAINT ON TOP AND BOTTOM FACE

*

TO BE MANUFACTURED FROM DW-1108-0220-43



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NOMINAL SIZE & FIT DEVIATION

TUBE ASSY-11		*		**		
No. OFF	DESCRIPTION	PART No.	MATERIAL	STANDARD	DIMENSIONS	REMARKS
GENERAL TOLERANCE						
LINEAR DIMENSIONS						
0-6	±0.1					
6-30	±0.2					
30-120	±0.3					
120-315	±0.5					
315-1000	±0.8					
1000-2000	±1.2					
ANGULAR DIMENSION						
1-10	±1°					
10-50	±30'					
50-100	±20'					
>100	±10'					
VALUE IN "um"						
~	>25					
▽	8-25					
▽▽	1.6-8					
▽▽▽	0.025-1.6					
▽▽▽▽	<0.025					
TUBE ASSY-11 FRAME ASSY LR-MR LAUNCHER KAVACH MOD-11				SCALE 1:1		
MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH				DESIGN OFFICE		
DRAWING No. DW-1108-0230-13				DATE 06.12.08		

