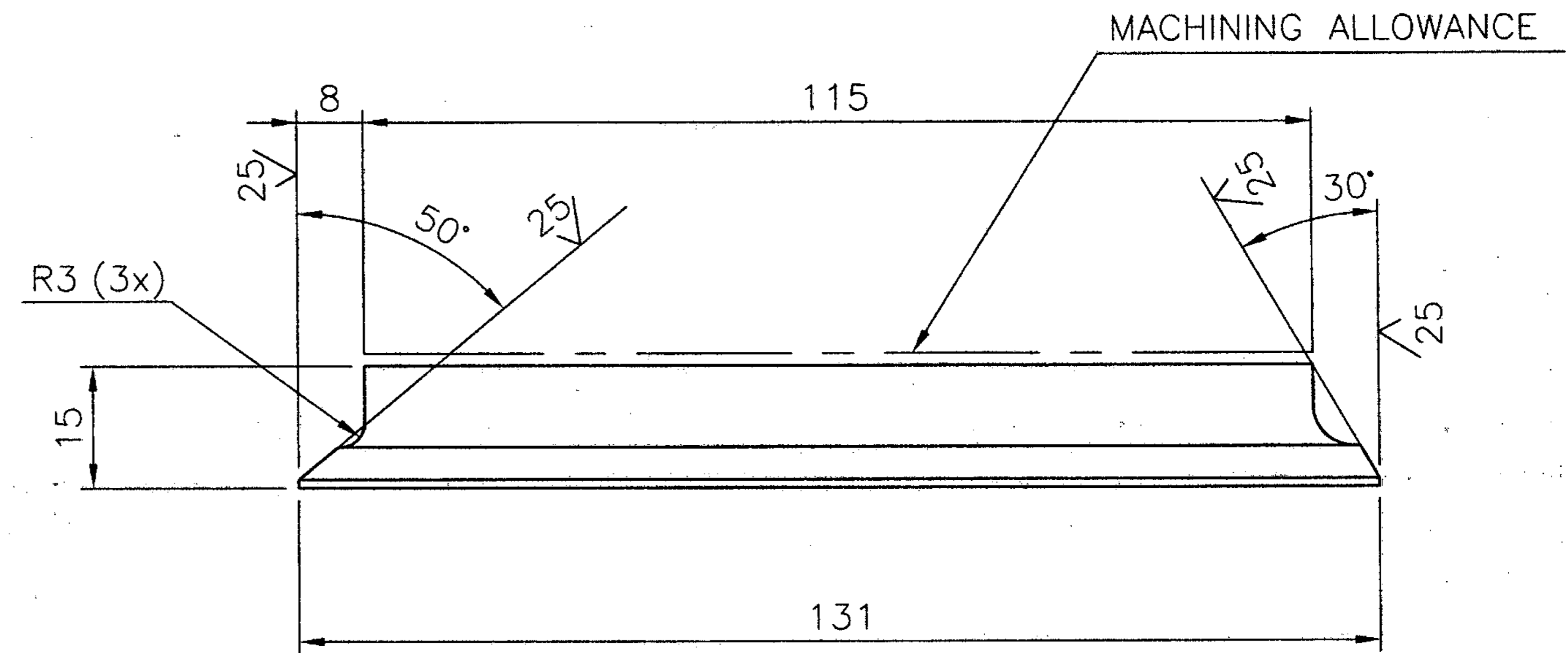
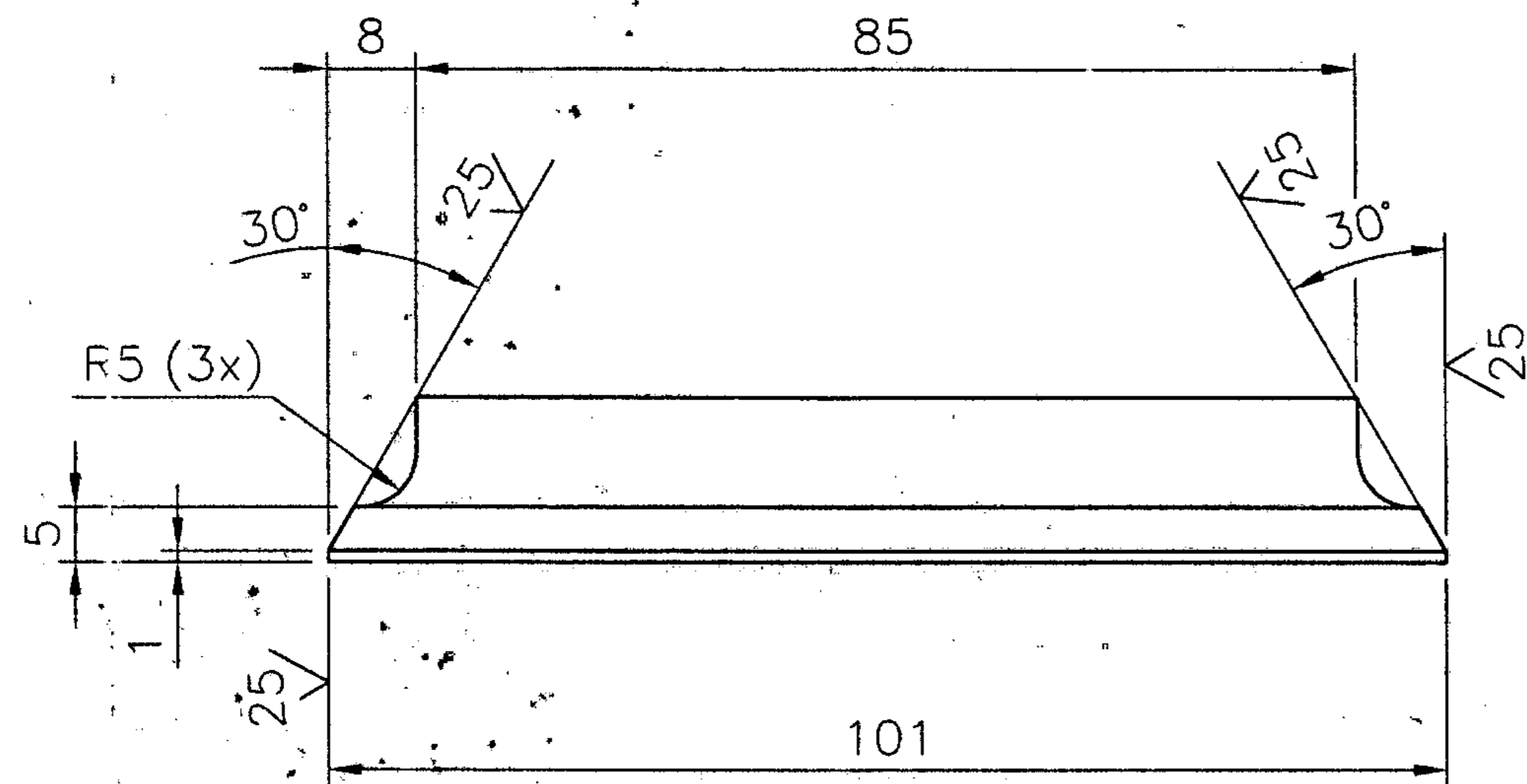


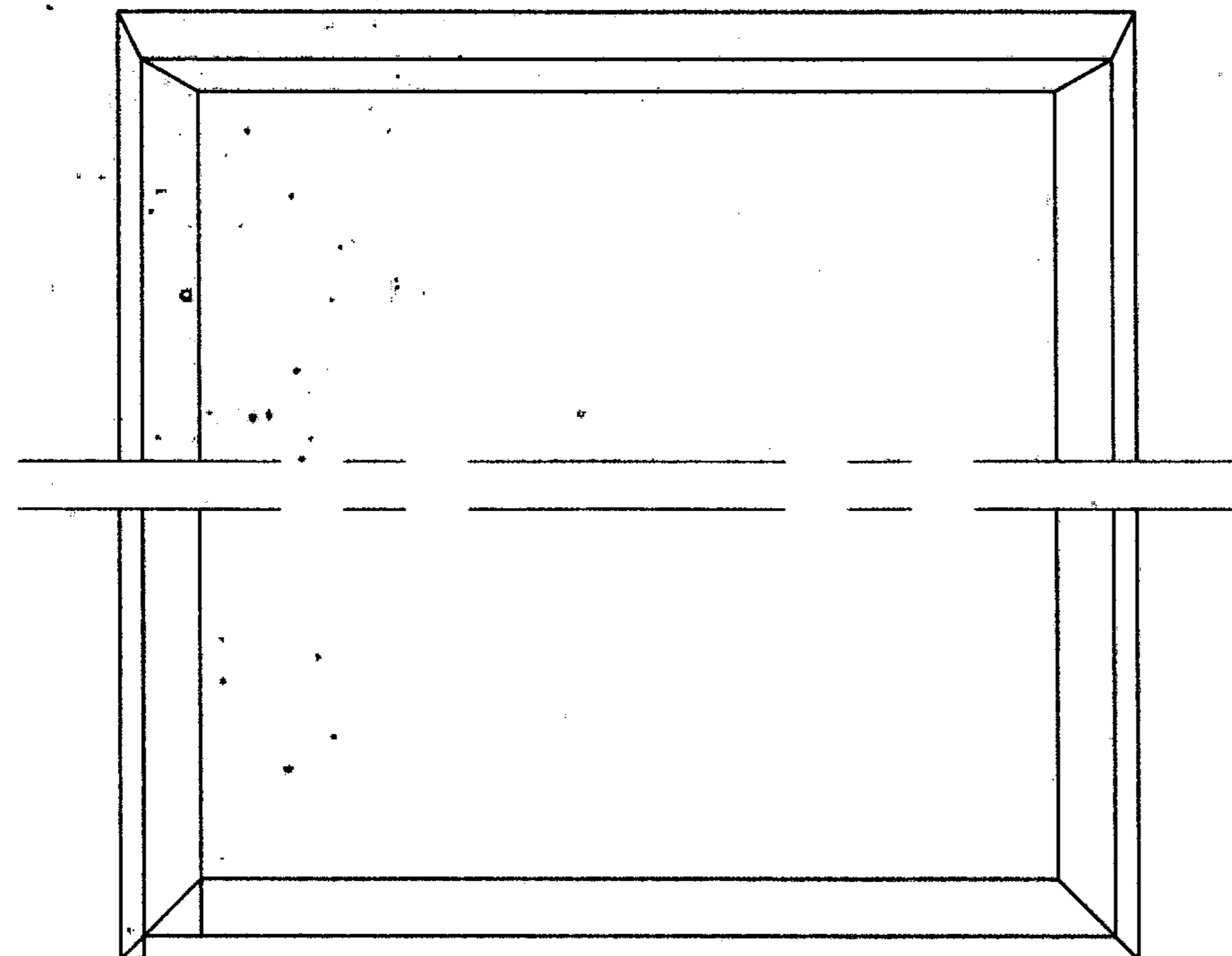
DRG. No. 5 167 374

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED



CASTING TOLERANCES ACC TO SS 722 GTA 12

MANUFACTURING SPEC : A2017, COMMERCIAL QUALITY EXCEPT RADIOGRAPHIC TESTING

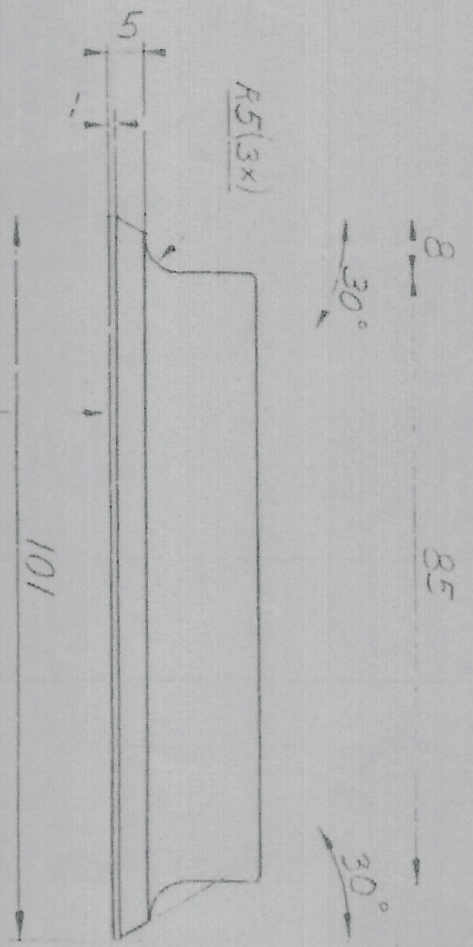


FOR CASTING SEE DRAWING NO. 5189619

P.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	REMARKS
GEN. TOL. NOT SPECIFIED						FOR SF. GM G.C.Fy.
LINEAR DIMENSIONS						2015
0-6	±0.1					NAME
6-30	±0.2					DATE
30-120	±0.3					DRN.
120-315	±0.5					SANJAY
315-1000	±0.8					16/07
1000-2000	±1.2					CKD.
						S.K.JAIN
						28/08
ANGULAR DIMENSIONS						INDEX
0-10°	±1°	AMENDMENTS		SIGN	DATE	APPROVED
10-50°	±30'					
50-100°	±20'					
>100°	±10'					
~ UNMACHINED		<h1>PLATE</h1>		MATERIAL IS:10343-1999, Gde 80, Cond 'QT' With %S & %P each 0.035 Max. to achieve Rp0.2 = 600 Mpa min., Rm = 800-950 MPa, El = 10%, HB = 235-285		
▽ ROUGH						
▽▽ SMOOTH						
▽▽▽ FINISH						
				SCALE REF.DRG.NO.		
GUN CARRIAGE FACTORY, JABALPUR						ASSY/SUB ASSY NO. 1144016
						SHEET NO. OF SHEETS

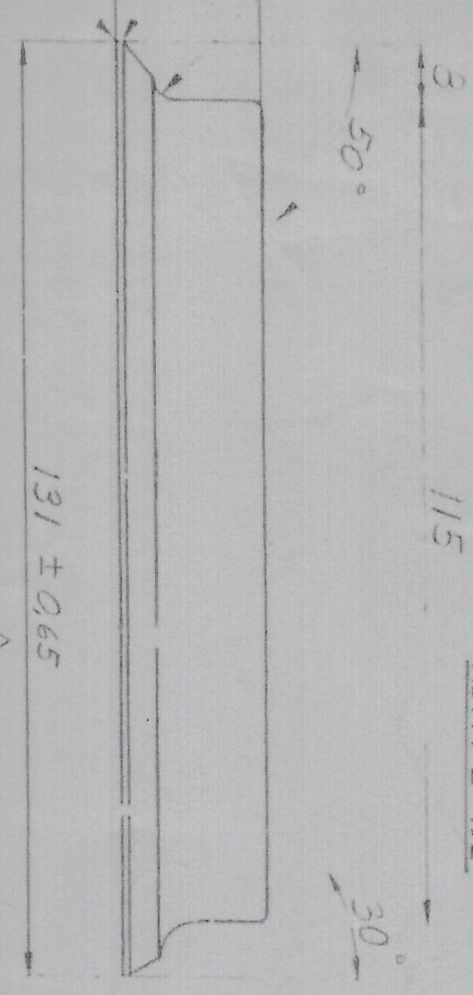
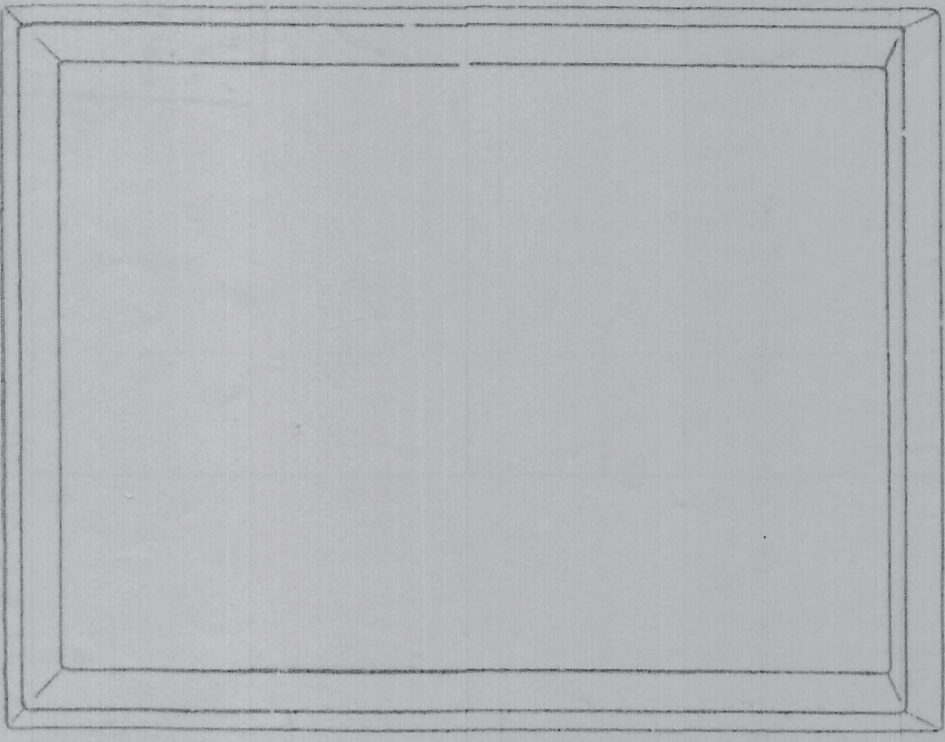
6
5
4
3
2
1

ALT MATL: BS: 3146-PT 1-74 TYPE
 GLA-1 HEAT TREATED TO
 ACHIVE HARDNESS 245-290 HB



På svetsnäsor
 On welded joints
 R0,2 max. vid svetsnäsor
 R0,2 max. on welded joints

MATL:- IS: 10343-1999, Gde 8Q, Cond. 'QT' with
 %S & %P each 0.035 Max. to achieve
 Rp0,2 = 600 Mpa min., Rm = 800-950 Mpa,
 EL = 10%, HB = 235-285



NOTE :- RADIOGRAPHIC EXAMINATION SHALL BE AS FOLLOWS :-
 1) GAS HOLES AND FOREIGN MATERIAL
 2) SHRINKAGE (ALL TYPES) - LEVEL 3 AS PER E-192
 LEVEL 3 AS PER ASTM E-192

Tolerans: SS722 GTA13 där ej annat angetts
 Tolerance: SS722 GTA13 unless otherwise stated
 Kontroll o. leveransbest. A2017 Handelskvalitet
 Inspection and delivery spec. A2017 Commercial quality
 Röntgen endast av utfallsprov
 X-ray first part samples only

FOR COMPONENT SEE DRG. NO. 5167374

DHANUSH

18526-W 5-7-99	NOTE ADDED									
18499-W 26-12-98	ALT MATL ADDED & COMP MATL DELETED									W/DAC
15-2-91	17018-W	COMP MATL ADDED								
13-1-89	16724-W	DRG SEALED PROV								
1	C6, C2	39037719	Toleranser tillkom							
Andr. nr Rev. No.	Läge Zone	KO nr och ändringbeskrivning revision order No. and description of the revision		Ritad Drawn	Datum Date	Godkänd Approved				
Där ej annat angetts gäller										
Mått före användning										
Dimensioner före surface treatment										
Ytbehandling Surface roughness R _a , µm	Hållbarhet Durability	Skarpa kanter/bursta Sharp edges broken		0,5-1						
Ytbehandling R _a , µm	Ytbehandling R _a , µm	Hållbarhet Durability		25						
Tol. max för hinc. Tol. max gaspassning enligt 12-3										
Tolerans för cutting and flame cutting acc. to 12-3										
Ytbehandling Surface treated										
Material SS 2225-24										
Datum Date 85-10-09										
Skala Scale 1:1										
Förvägning Previous drawing Viki Weight kg 1,65										
Beteckning Designation SS 2225-24										
Ritning nr Drawing No 5189619										
Skrivet av Drawn by 1										

610 = 2.08kg = 2085 + 800 + 15 = 1023 / 4

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