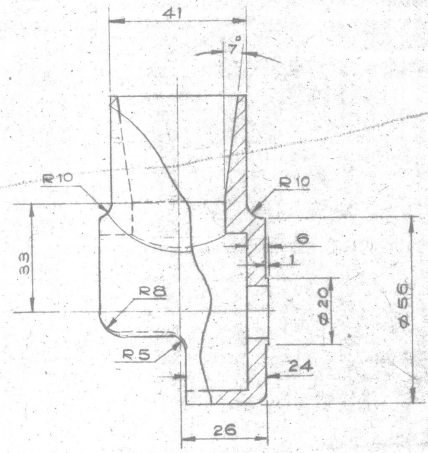
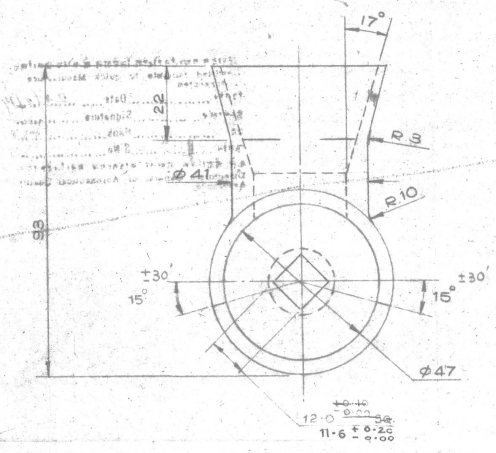
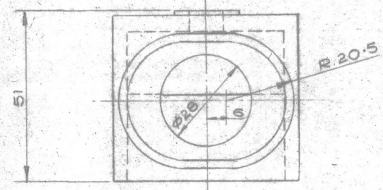


DRG CONVENTIONS CONFORM TO IS: 696
 DIMS ARE IN MM UNLESS OTHERWISE STATED
 GEN TOLS: MEDIUM CLASS IS: 2102



NOTES:-

- 5) CASTING ANGLE UP TO 1°
- 6) SQUARE HOLE DIMENSION 11.6 IS PROVISIONAL AND CAN BE ALTERED AS PER AGREEMENT BETWEEN CASTING AND MACHING AGENCIES WITH AN ULTIMATE AIM OF ACHIEVING THE FINAL DIMENSION OF 12.0 ± 0.10 IN THE FINAL PRODUCT AS SPECIFIED IN DRG. NO. ERDL 1040 DETAIL NOS. 1 AND 2.
- 7) EACH CASTING TO BE SUBJECTED TO ULTRASONIC EXAMINATION AS PER IS: 7666 OR RADIOGRAPHIC EXAMINATION AS PER IS: 2595 FOR ENSURING FREEDOM FROM INTEGRAL DEFECTS OR EACH CAST NOZZLES TO BE SUBJECTED TO MAGNETIC CRACK DETECTION.

NOTES:-

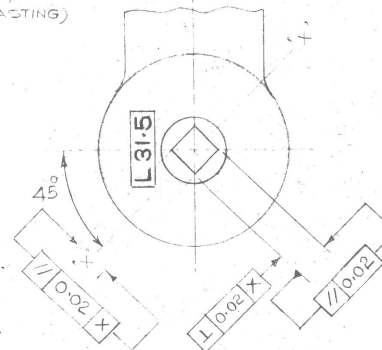
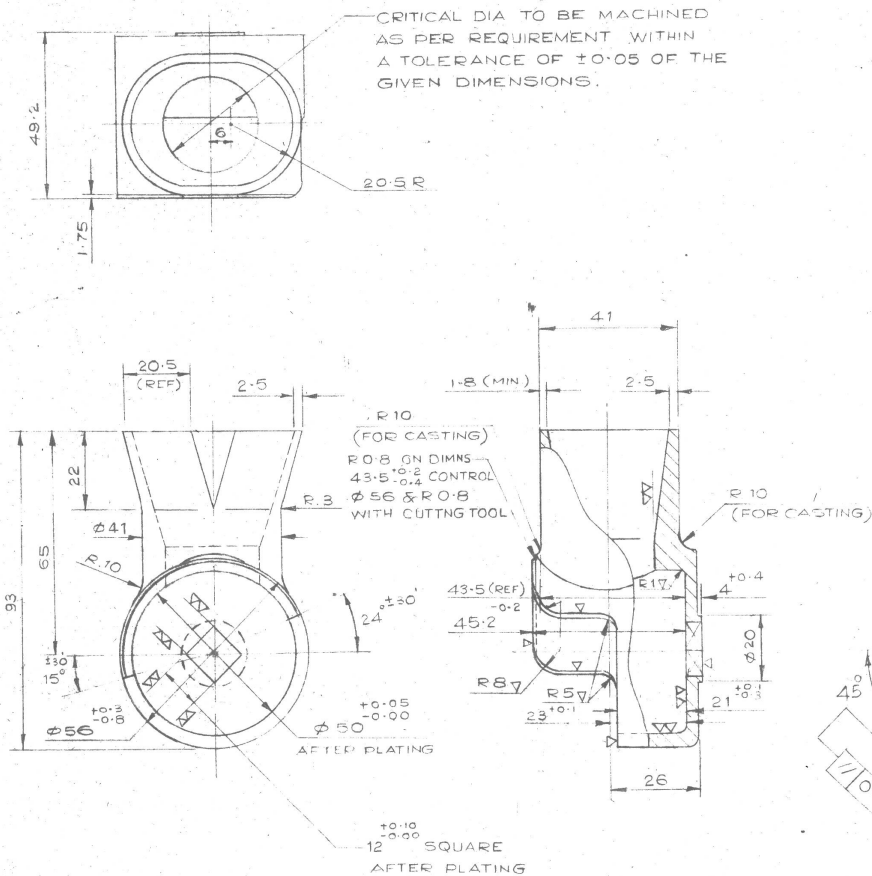
- 1) THE COMPONENT IS TO BE CAST FROM STEEL AND CHEMICAL COMPOSITION OF STEEL SHALL CONFIRM TO SPECIFICATION IS: 4896-1976 (GRADE II)
- 2) THE COMPONENT IS TO BE HARDENED AND TEMPERED TO A HARDNESS LEVEL OF 300 ± 20 HB.
- 3) TURN OF SQ. 11.6 ± 0.20 / 12.0 ± 0.00 RELATIVE TO THE AXIS IS NOT MORE THAN 10°
- 4) NON CO-AXIALITY OF SQ. 11.6 ± 0.20 / 12.0 ± 0.00 AND $\phi 47$ SHOULD NOT BE MORE THAN 0.05
- 5) THE COMPONENT IS TO BE HARDENED AND TEMPERED TO A HARDNESS LEVEL OF 330 - 380 HB. HOWEVER, THE HARDNESS BE ADJUSTED PREFERABLY ON THE LOWER STIPULATED LIMIT I.E. 330 HB.

4	6-4-98	AMENDED VIDE AL. NO. - 13/98			DRN ALS	CHD	TRO PDB COMP	ASSY. DRG
3	12-5-93	AMENDED VIDE AL. NO. 706			CD	PA	SCALE IN	DESIGN AUTHORITY
2	2-2-95	AMENDED VIDE AL. NO. 695			APPROVED		EST MASS	ERDL PUNE-21
1	14-7-87	AMENDED VIDE AL. NO. 577					GAUGE SCHED	
R NO	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO	DATE: 25-8-86	
DRG SEALED Provisionally signed by <i>Dr. P. S. Patil</i> on 14/7/87					MATERIAL AS ON DRG.		PROTECTIVE FINISH.	

CASTING DRG. FOR NOZZLE - PZM

DRG NO
 ERDL DRG 1040
 DET. SHTS SHT
 PART NO
 DE. CAT. NO
 ANEP CTD 3 P (NR) NEW DELHI

DRG CONVENTIONS CONFORM TO IS: 696
 DIMNS. ARE IN mm UNLESS OTHERWISE STATED
 GEN. TOLS MEDIUM CLASS TO IS: 2102



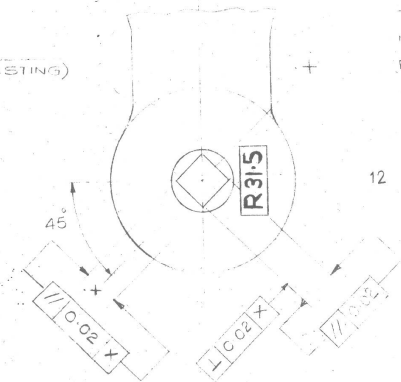
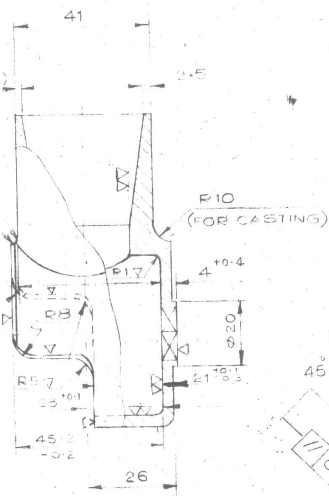
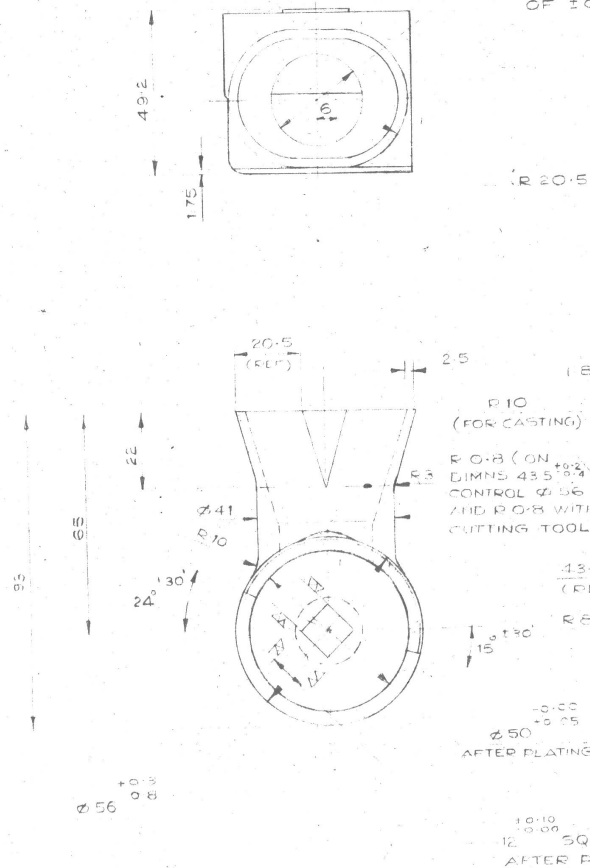
- NOTES:-
1. THE COMPONENT IS TO BE CAST FROM STEEL AND CHEMICAL COMPOSITION OF STEEL SHALL CONFIRM TO SPECIFICATION IS: 4896-1976 (GRADE II) HARDNESS 330-380 HB.
 2. CASTING ANGLE UPTO 1°
 3. ~~THE COMPONENT IS TO BE HARDENED AND TEMPERED TO A HARDNESS LEVEL OF 360 ± 20 BHN.~~
 4. MAGNETIC INSPECTION OR DYE PENETRATION CHECK AROUND THE SQUARE HOLE REGION ONLY. NO SURFACE CRACKS PERMITTED. THE COMPONENT TO BE DEMAGNETISED AFTER THE TEST.
 5. THE COMPONENT IS TO BE CADMIUM PLATED TO GRADE A OF IS: 1572 AFTER BORING THE CRITICAL DIA. (GRADE A: IS DESIGNATED AS CD-13 THICKNESS 0.018 mm)
 6. TURN OF SQUARE 12 ± 0.10 RELATIVE TO THE AXES IS NOT MORE THAN 10°
 7. NON COAXIALITY OF SQUARE 12 ± 0.10 AND $\phi 50$ SHOULD NOT BE MORE THAN 0.05
 8. CRITICAL DIA DIMENSION SHOULD BE ENGRAVED IN THE SHADED RECTANGULAR SPACE AFTER PLATING, PREFIXED BY THE LETTER L FOR EXAMPLE AS [L 31.5]
 9. SIZE OF THE LETTERS & NUMBERS - HEIGHT - 5 mm BREADTH - 3 mm
 10. AFTER ENGRAVING, THE LETTERS & NUMBERS SHOULD BE FILLED WITH RED PAINT.
 11. A COAT OF MINERAL JELLY (SPECN. JSS 1-59-36 (a)) / GUNGREASE (SPECN. GOST 3005-51) IS TO BE APPLIED ON THE EXTERNAL & INTERNAL SURFACES OF NOZZLES. THE NOZZLE IS TO BE WRAPPED IN PAPER CRAFT TYPE PARAFFIN WAXED AMMUNITION (SPECN. JSS 1206) OF SIZE 24 Cm X 20 Cm AND FINALLY PACKED IN POLYTHENE BAG [SPECN. JSS 1213 A: THICKNESS 0.15 mm. OF SIZE 17 Cm X 13 Cm.
 12. DRG FOR THE NOZZLE CASTING IS ENCLOSED FOR GUIDANCE

3	12-5-93	AMENDED VIDE AL. No. 707	DRN	PDR	CHD.	TRD	COMP	ASSY. DRG. ERDL DRG 664
2	2-2-93	AMENDED VIDE AL. No. 695	CD	K	passed	SCALE: 1:1	EST. MASS	DESIGN AUTHORITY
1	04-7-87	AMENDED VIDE AL. No. 577	APPROVED			GAUGE SCHD	DATE: 12-6-88	ERDL PUNE - 21
NR	DATE	AUTHORITY	BRIEF RECORD	ZONE	C. D. G. O. SIGN	MATL.	AS ON DRG	
DRG SEALED provisionally <i>quanti - specf. chg. 07/04/96</i>						PROTECTIVE FINISH - AS ON DRG.		DRG. NO.
								ERDL DRG 1040
								DET. 1. 1918 1818
								PART NO.
								D.S. CH. IS
								APPROVED SIGNATURE

NOZZLE - PZM (LEFT)

DRG. CONVENTIONS CONFORM TO IS: 695
 DIMNS ARE IN MM UNLESS OTHERWISE STATED
 GEN. TOLS. MEDIUM CLASS IS: 2102

CRITICAL DIA TO BE MACHINED
 AS REQUIRED WITHIN A TOLERANCE
 OF ± 0.05 OF THE GIVEN DIMENSION.



NOTES:-

- 1 THE COMPONENT IS TO BE CAST FROM STEEL AND CHEMICAL COMPOSITION OF STEEL SHALL CONFORM TO SPECIFICATION IS: 4896-1976 (GRADE - II)
- 2 CASTING ANGLE UP TO 1°
- 3 THE COMPONENT IS TO BE HARDENED AND TEMPERED TO A HARDNESS LEVEL OF 360 ± 20 HRN
- 4 MAGNETIC INSPECTION OR DYE PENETRATION CHECK: ~~WITHIN THE SQUARE HOLE REGION ONLY. NO SURFACE CHECKS. NO SURFACE CRACKS OR BLOW HOLES PERMITTED. THE COMPONENTS TO BE DEMAGNETISED AFTER THE TEST.~~
- 5 THE COMPONENT IS TO BE CADMIUM PLATED TO GRADE A OF IS: 1572 AFTER BORING THE CRITICAL DIA. (GRADE A: IS DESIGNATED AS CD-13, THICKNESS 0.013 mm)
- 6 TURN OF SQUARE $12^{+0.0}$ RELATIVE TO THE AXES IS NOT MORE THAN $10'$
- 7 NON CO-AXIALITY OF SQUARE $12^{+0.0}$ AND $\phi 50$ SHOULD NOT BE MORE THAN 0.05
- 8 CRITICAL DIA DIMENSION SHOULD BE ENGRAVED IN THE SHADED RECTANGULAR SPACE AFTER PLATING, PREFIXED BY THE LETTER R FOR EXAMPLE AS $[R31.5]$
- 9 SIZE OF THE LETTERS & NUMBERS: HEIGHT - 5 mm BREADTH - 3 mm
- 10 AFTER ENGRAVING, THE LETTERS & NUMBERS SHOULD BE FILLED WITH RED PAINT.
- 11 A COAT OF MINERAL JELLY (SPECN JSS 1-59-36 (a)) / GUNGREASE (SPECN GOS 3005-51) IS TO BE APPLIED ON THE EXTERNAL & INTERNAL SURFACES OF NOZZLES. THE NOZZLE IS TO BE WRAPPED IN PAPER CRAFT TYPE PARAFFIN WAXED AMMUNITION (SPECN JSS 1208) OF SIZE 24 Cm X 20 Cm AND FINALLY PACKED IN POLYTHENE BAG [SPECN JSS 1213 A: THICKNESS 0.15 mm OF SIZE 17 Cm X 13 Cm
- 12 DRG. FOR THE NOZZLE CASTING IS ENCLOSED FOR GUIDANCE

4					DRN	PDB	CHD	TRD	COMP	ASSY DRG	ERDL DRG	24
3	2-5-93	AMENDED VIDE AL NO 700			C B		PASOLD	SCALE 1:1		DESIGN AUTHORITY		
2	2-2-93	ENCLASSED VIDE AL NO 507						EST MASS		ERDL PUNE-21		
1	14-7-87	AMENDED VIDE AL. NO 577						GAUGE SCHO				
TO	DATE	AUTHORITY	BRIEF RECORD	ZONI	C. D. I. C. O.			DATE: - 20-6-86				
DRG	RELATED	Provisional	quint	grapt	OLE(AM)			PROTECTIVE FINISH: AS ON DRG.				

NOZZLE-PZM (RIGHT)

DRG. NO.
 ERDL DRG 1040
 DET 2 SHTS SHT
 PART NO.
 D S CAT NO
 AHSP DTD SP(AIT) NEW DELHI