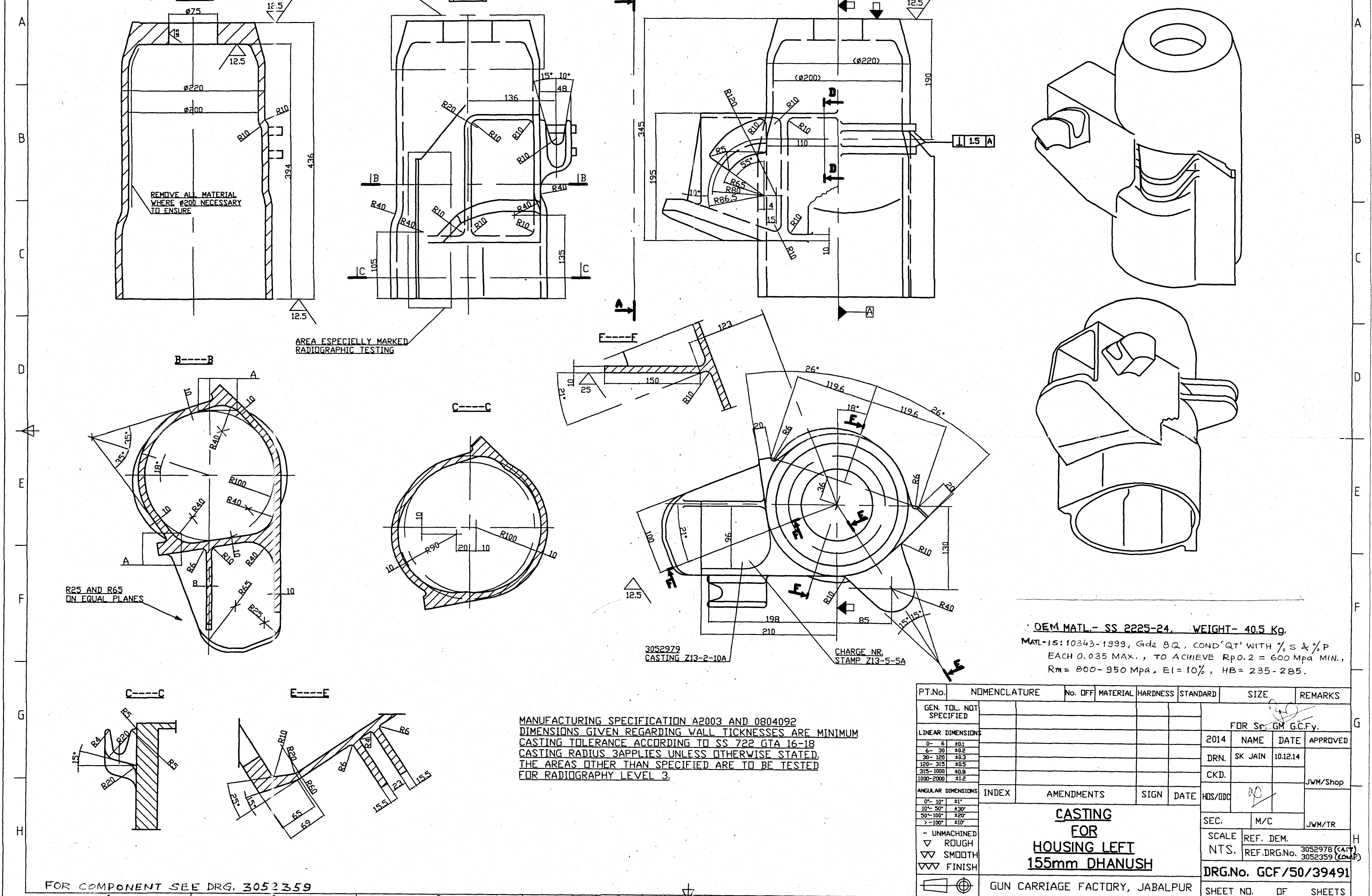


DRG. No. GCF/50/39491

DRAWING CONVENTIONS CONFORM TO SP 46:1988
DIMNS. ARE IN mm. UNLESS OTHERWISE STATED.



REMOVE ALL MATERIAL WHERE $\phi 200$ NECESSARY TO ENSURE

AREA ESPECIALLY MARKED RADIOGRAPHY TESTING

AREA ESPECIALLY MARKED RADIOGRAPHY TESTING

R25 AND R65 ON EQUAL PLANES

MANUFACTURING SPECIFICATION A2003 AND 0804092
DIMENSIONS GIVEN REGARDING WALL THICKNESSES ARE MINIMUM
CASTING TOLERANCE ACCORDING TO SS 722 GTA 16-18
CASTING RADIUS 3 APPLIES UNLESS OTHERWISE STATED.
THE AREAS OTHER THAN SPECIFIED ARE TO BE TESTED FOR RADIOGRAPHY LEVEL 3.

OEM MATL - SS 2225-24. WEIGHT - 40.5 Kg.
MATL-15: 10343-1999, Gds BQ, COND' QT' WITH %S & %P
EACH 0.035 MAX., TO ACHIEVE Rp0.2 = 600 Mpa MIN.,
Rm = 800-950 Mpa, EI = 10%, HB = 235-285.

PT.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	SIZE	REMARKS
	GEN. TOL. NOT SPECIFIED						
	LINEAR DIMENSIONS						FOR Sp. GM G.C.Fy.
	0-6	±0.1				2014	NAME DATE APPROVED
	6-30	±0.2				DRN.	SK JAIN 10.12.14
	30-120	±0.3					
	120-315	±0.5					
	315-1000	±0.8				CKD.	
	1000-2000	±1.2					JWM/Shop
	ANGULAR DIMENSIONS						
	INDEX	AMENDMENTS	SIGN	DATE	HDS/DDC		
	0°-10°	±1°					
	10°-30°	±30'					
	30°-100°	±20'					
	>100°	±10'					
	~ UNMACHINED					SCALE	M/C JWM/TR
	▽ ROUGH					REF. DEM.	
	∇∇ SMOOTH					N.T.S.	REF.DRG.No. 3052978 (CAST) 3052359 (COMP)
	∇∇∇ FINISH					DRG.No. GCF/50/39491	
						GUN CARRIAGE FACTORY, JABALPUR	
						SHEET NO. OF SHEETS	

FOR COMPONENT SEE DRG. 3052359

