

MP sheet not received

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SHEET REV STATUS		REVISION RECORD		
REV	ECO	DESCRIPTION	DATE	APPD
01		Final	31-Dec-12	
02		Revised	30-Sep-13	
03		Revised	16-Dec-14	D. Nave
04		Revised	09-Apr-18	L. Goldstein

NOTES :

1. INTERPERT THIS DRAWING IAW ASME Y14.100M.
2. PART SHALL BE MANUFACTURED IN ACCORDANCE WITH ASTM-B26/M EXCEPT FOR THE FOLLOWING:
 - 2.1 MECHANICAL PROPERTIES SHALL BE TAKEN FROM SEPARATE TEST BARS CASTINGS WITH FIRST ARTICLE, AND EACH PRODUCTION LOT.
 - 2.2 QUALITY REQUIREMENTS SHALL BE IN ACCORDANCE WITH AMS-STD-2175 CLASS 4 GRADE D
 - 2.3 AREAS MARKED SHOULD MEET QUALITY REQUIREMENTS IN ACCORDANCE WITH AMS-STD-2175 CLASS 3 GRADE C. ONLY ON ONE FAI.
3. MATERIAL: ALUMINUM ALLOY A357 T6 PER AMS--21180 CL12.
4. HEAT TREATMENT ACC.TO AMS STD. 2771C-T6.
5. WELDING IS PERMITTED, ONLY BEFORE THE HEAT TREATMENT OF THE CASTING AND SHALL BE DONE ACCORDING MIL-STD-278F AND ASTM B26/26M. POST WELD OPERATIONS ACC. TO ASTM-B26/26M AND AMS STD. 2175.
6. GENERAL TOLERANCE:
LINEAR: +/- (1 + 0.002DIM.)
ANGULAR: +/- 1°
7. MISMATCH ON PARTING LINES SHALL BE GRINDED
8. ROUGHNESS OF VISIBLE CAST SURFACES SHALL BE 250 MICROINCH RMS OR BETTER UNLESS OTHERWISE SPECIFIED.
INNER CAST SURFACES SHALL BE 500 MICROINCH OR BETTER
9. UNLESS OTHERWISE SPECIFIED EXTERNAL CORNERS SHOWN SHARP, SHALL BE R1MM +/- 0.5 AND INTERNAL FILLETS SHALL BE R3MM +/- 1..
9.1 THE CASTING SHALL BE FREE OF FINS AND RISERS.
10. DRAFT ANGLES 2° MAX. TO ADD MATERIAL DIRECTION.

11. DATUM AND DATUM TARGETS:

- 11.1 CORRELATED DATUMS ARE INDICATED BY A AND B
- 11.2 DATUM TARGETS ARE INDICATED BY THE NUMBERED SYMBOLS RELATED TO TARGET POINTS INDICATED BY IN ACCORDANCE WITH ASME-Y14.5M-1994. PERPENDICULARITY BETWEEN THESE DATUMS IS 90 DEGREES ABSOLUTE.

12. IDENTIFICATION OF PRODUCT

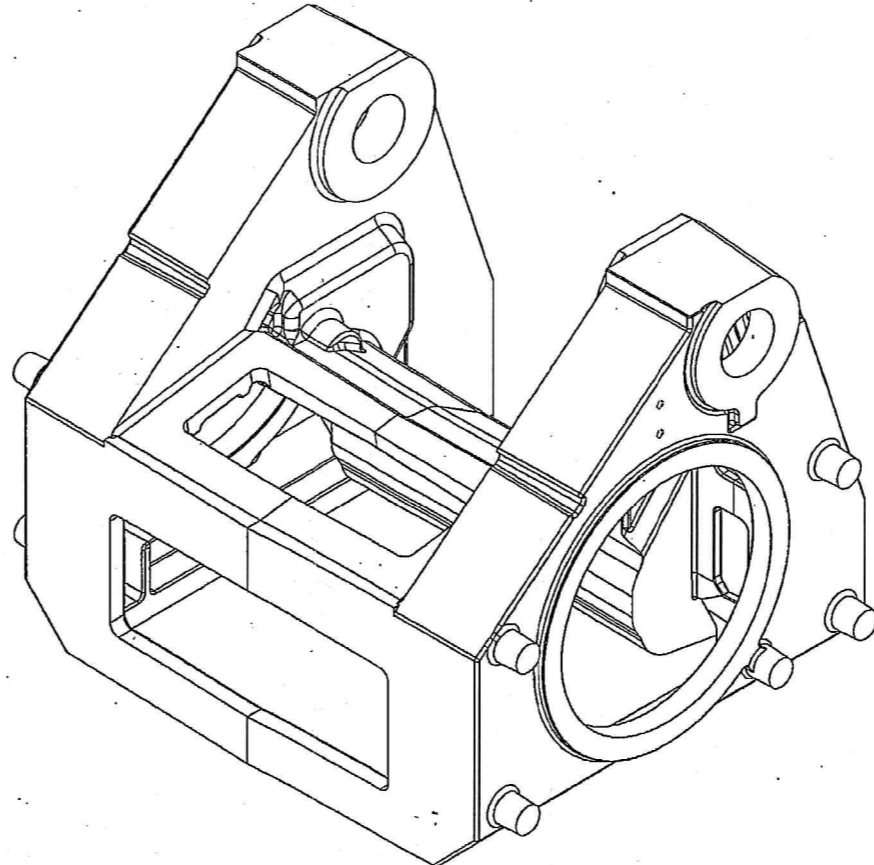
- 12.1 PRODUCT PART NUMBER AND REVISION SHALL BE WITH BOLT LETTERS IN MOLD IN THE LOCATION SHOWN.
- 12.2 CHARACTERS TO BE RAISED 1 MM MAX FROM CAST SURFACE.
- 12.3 CHARACTERS TO BE 3.2 MM HIGH AND 0.6 MM LINE WIDTH.
- 12.4 SERIAL NUMBER SHALL BE MARKED BY VIBRATION OR ELECTRIC PEN IN THE LOCATION SHOWN.
- 12.5 WELDED CASTING SHALL BE MARKED ACCORDING ASTM B23/26M.

13. QUALITY ASSURANCE PROVISIONS.

- 13.1 QUALITY ASSURANCE PROVISIONS FOR THIS ITEM PER RDMQ00080P.

14. PACKAGING AND PACKING:

THE FINISHED PART SHALL BE PRESERVED AND PACKAGED IN ACCORDANCE WITH MANUFACTURER'S COMMERCIAL PRACTICE.



UN CONTROLLED COPY

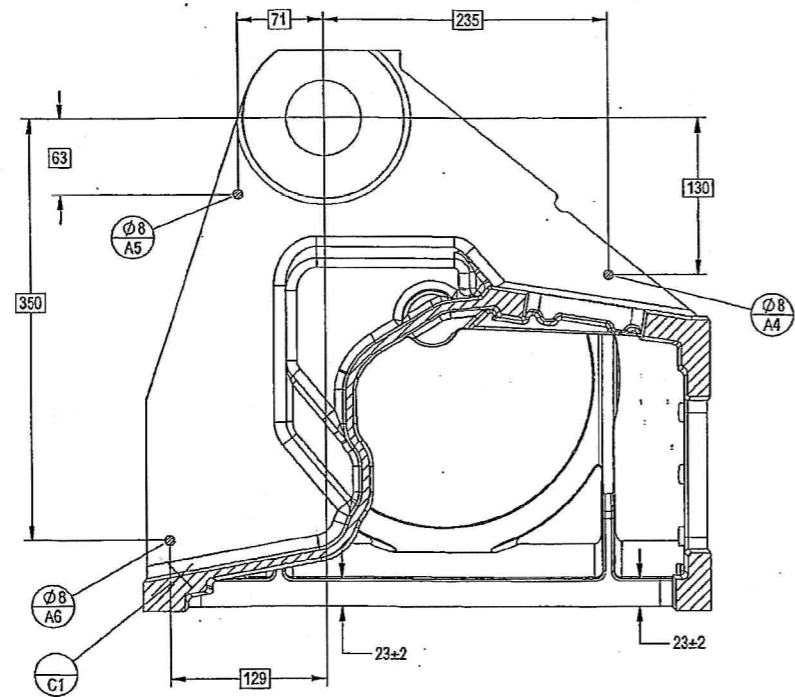
CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE 26-11-2020

[Signature]
Design & Drawing Officer
Ordnance Factory,
Trichirappalli-620016

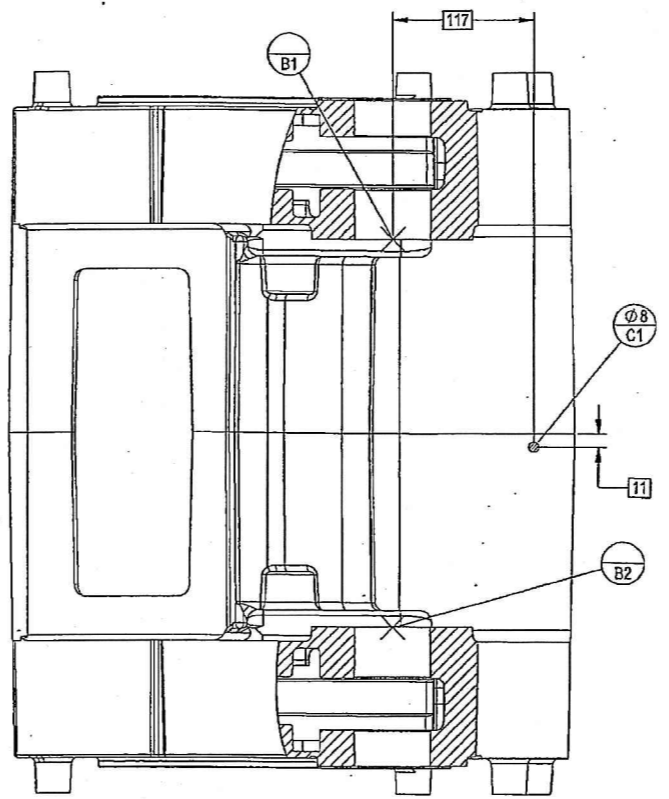
[Signature]
PROJ. OFFICER

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MM PER ASME Y14.5M-1994		SIGNATURE & DATE		ORDNANCE FACTORY TRICHIRAPPALLI	
TOLERANCES	DRAWN	<i>[Signature]</i> 03-0-20		FOR: CASING, MAIN	
LINEAR	CHECKED	R. J. S.		OF: 12.7MM SRCG	
ANGULAR	HOSE/DOO				
TAIL ANGLE PROJECTION	OFFICER/PRODR				
SURFACE TEXTURE IN Micro Meter	OFFICER/DC				
	OFFICER/DOO				
		SIZE	CAGE CODE	DRAWN	
		E	2281A	062814A-01	
		SCALE 1:2		AUTOMATED DRAWING (SW)	
				SHEET 1 OF 3	

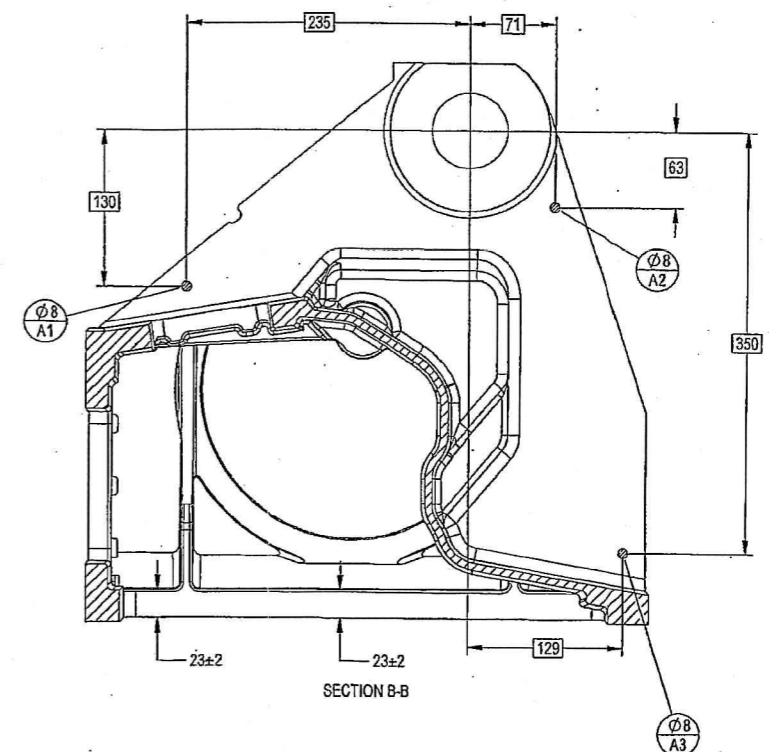
SEE ATTACHED MEDIA



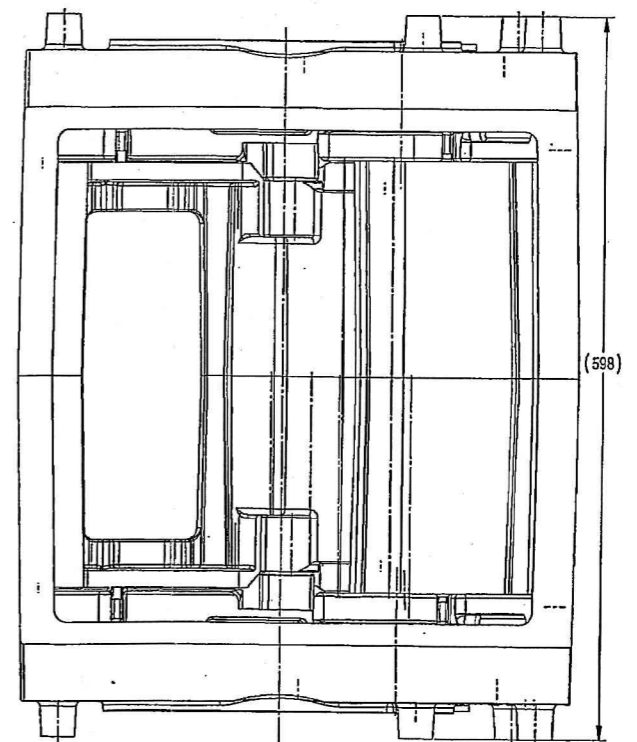
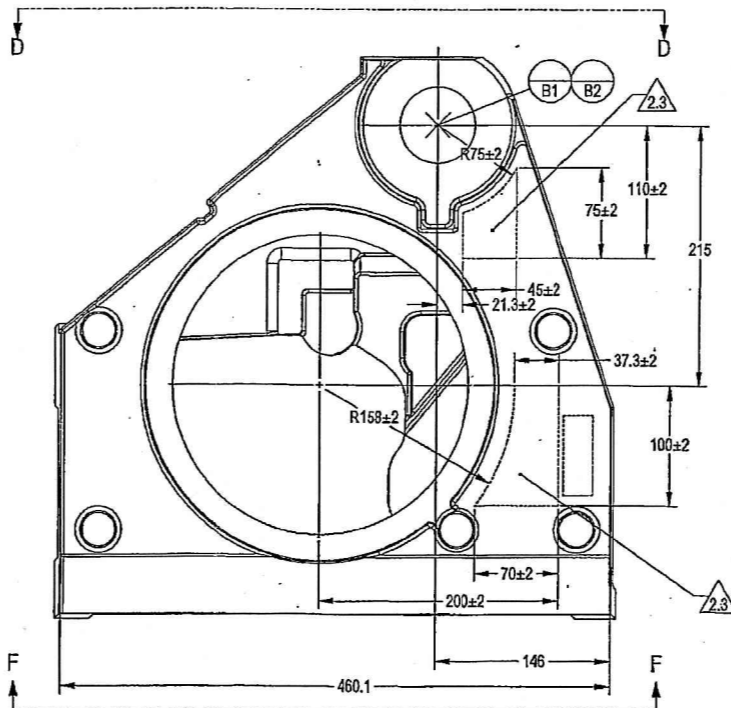
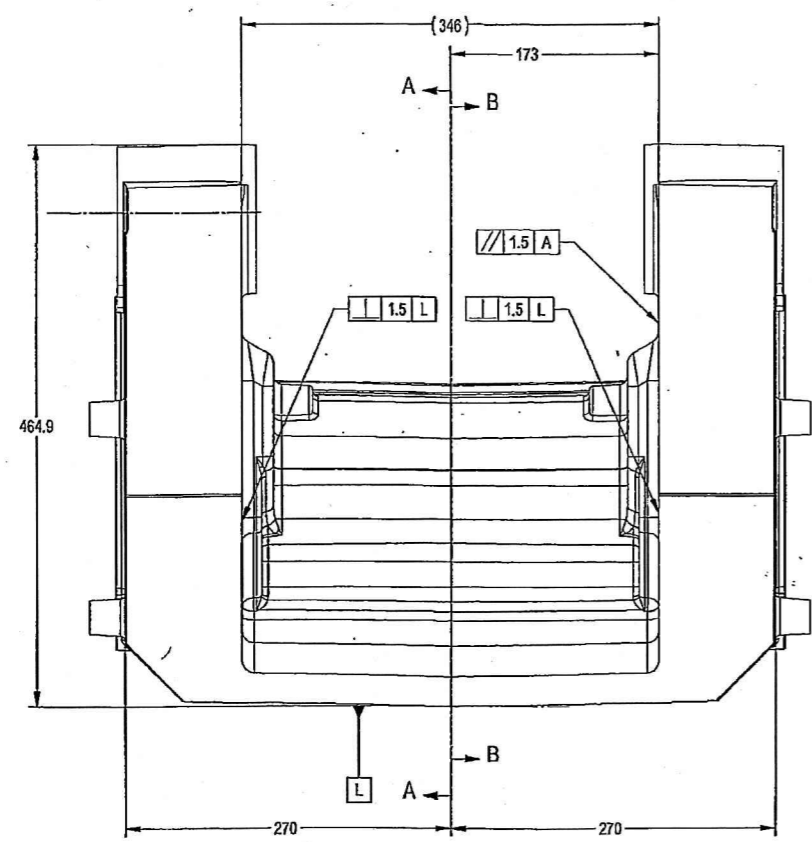
SECTION A-A



VIEW D-D



SECTION B-B



VIEW F-F

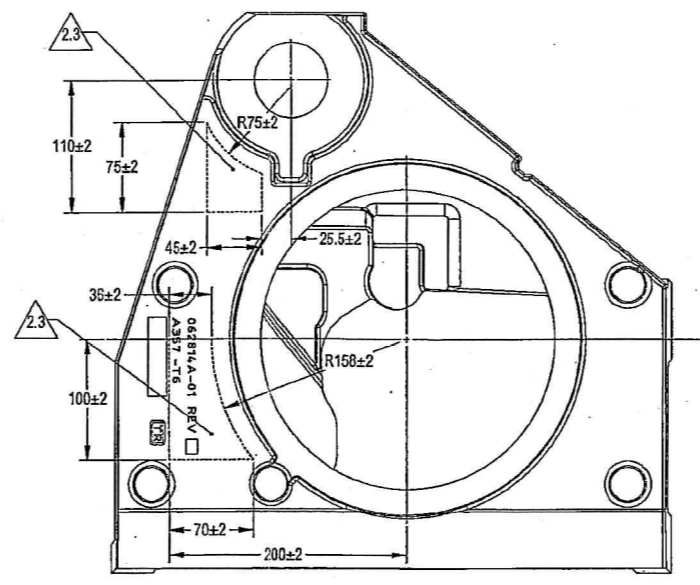
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FILE	CAGE CODE	DWG NO	REV
E	2291A	062614A-01	-
SCALE 1:2		AUTOMATED DRAWING	SHEET 3 OF 3

PLM Connect



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SIZE E	CAGE CODE 2281A	DRWNO 062814A-01	REV 1
SCALE 1:1	AUTOMATIC DRAWING (DWG)		SHEET 3 OF 3