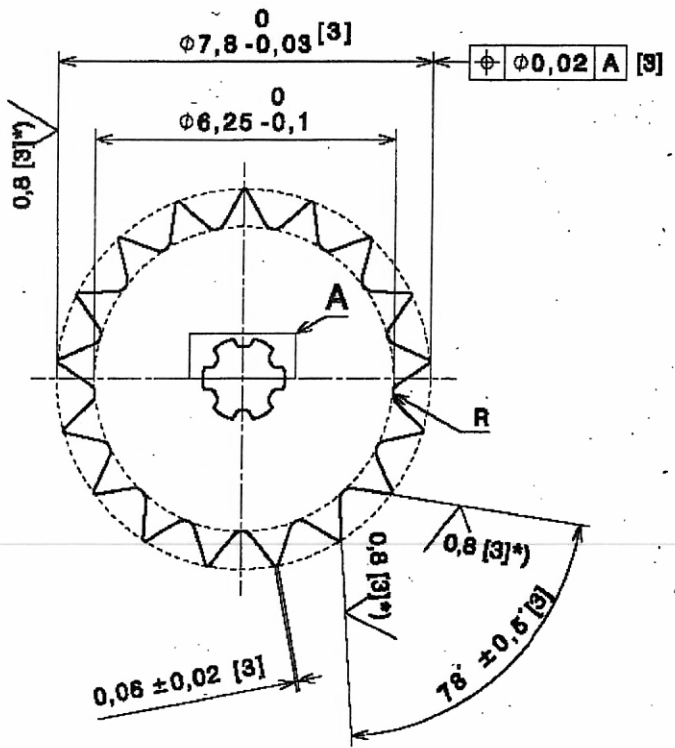
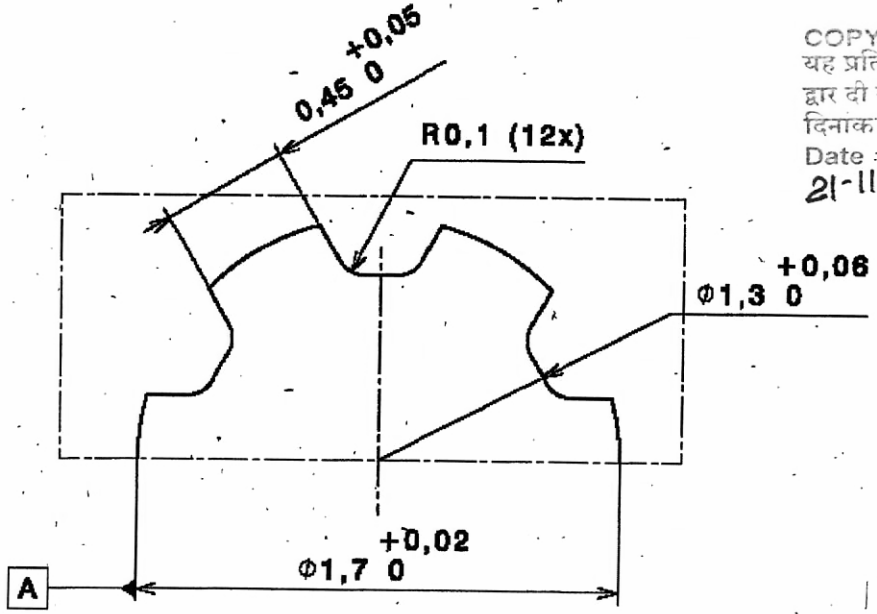
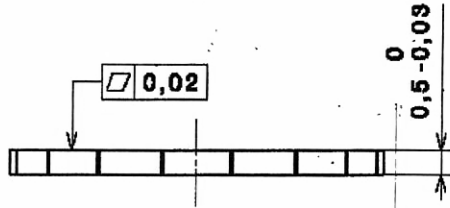


DRG. NO: FS-3108

PROVISIONAL

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 यह प्रति सी डी डी/ओ. एफ. ऐ. जे.
 द्वार दी गई है।
 दिनांक: क. क. प्र. / सी. डी. डी.
 Date: 21-11-20
 for JWM/CDD



6 LANDS, EVEN SPACING
 z = 17 TEETH
 FREE FROM BURRS [3]
 HARD. AND TEMPD.
 TO HV 430-550

Detail A

- 1). SAMPLE SIZE, ACCORDING TO SPECIAL CASES.
- 2). EVEN AND FLAT - VISUAL INSPECTION.
 COAT THICKNESS - SAMPLE SIZE : 2/1000 pcs.
 SURFACE TREATMENT- NICKEL PLATED 2-3 μm [3]**
 GENERAL SURFACE ROUGHNESS- Ra 1.6
 SHARP EDGES BROKEN- 0.1MAX.
 FORM & POS TOL. ACC. TO- ISO 1101
 GENERAL TOLERANCE- ISO 2768-fH



Isometric view

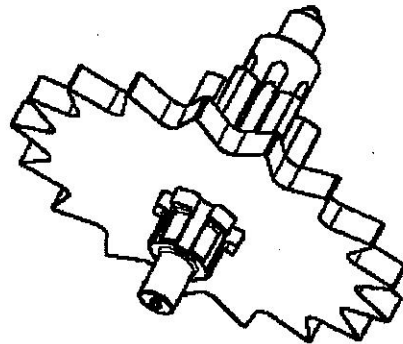
DIMENSIONS ARE IN mm.			MATERIAL:-		ORDNANCE FACTORY AMBAJHARI
FIRST ANGLE PROJECTION			STEEL SS-EN 10132-4 1.1274+QT [2]		
SCALE - - NTS			NOMENCLATURE		आर्डनेन्स फैक्टरी अम्बाझरी
2020	NAME	DATE	ESCAPE WHEEL		
DRAWN	Ladhey	08-10-20			
CHECKED		4/11/20			
HOS/CDD		1/11/20			
APPROVED		12/11/20			
NOMENCLATURE			SIGN.		DRG. NO :
AMENDMENTS					FS-3108
					REVIEW NO: 0
					SHEET NO- 1
					NO OF SHEETS- 1
					COMPT.
					ESCAPE WHEEL (304100128)
			STORE:		
			84mm HEAT 751 ML-3 P13 SA DEVICE		

15

DRG. NO: FS- 3144

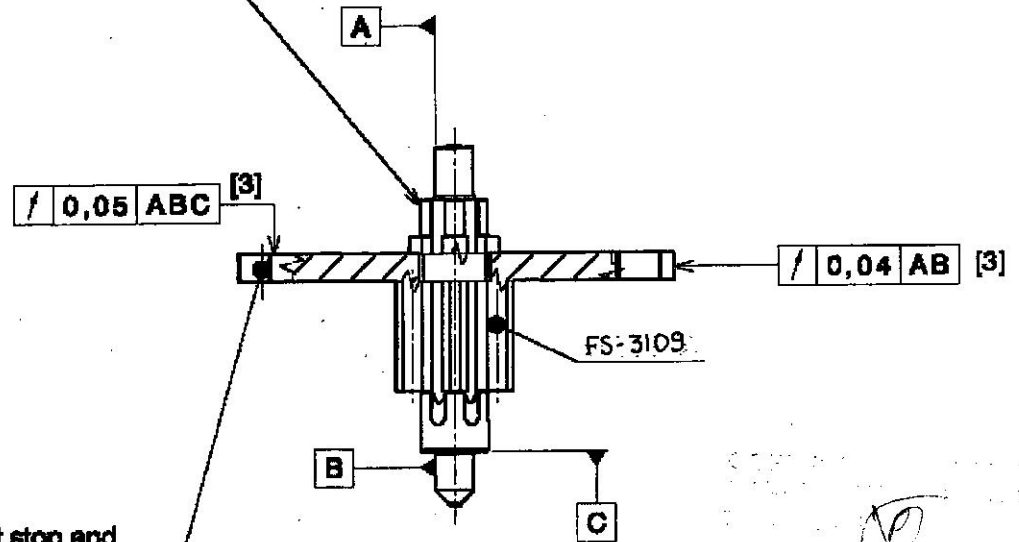
PROVISIONAL

Riveted marking FS-3108
endures an axial load of $\geq 197N$ [3]



Isometric view

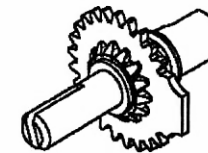
Riveting well performed and Centre wheels pressed against stop and with bevelled edge towards stop surface. [2] Visual inspection



11-01-21 for

FORM & POS TOL ACC. TO ISO 1101
FREE FROM BURRET

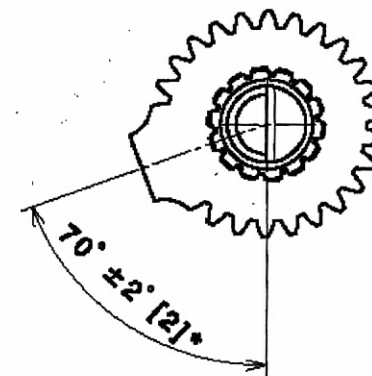
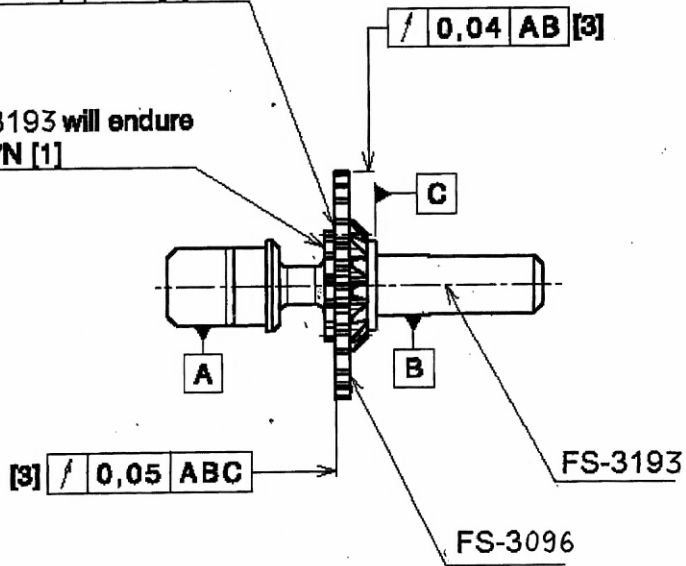
		DIMENSIONS ARE IN mm.		MATERIAL- --		ORDNANCE FACTORY AMBAJHARI	
		FIRST ANGLE PROJECTION				आईनैन्स फैक्टरी अम्बाझरी	
		SCALE - NTS		NOMENCLATURE		DRG. NO :	
2020	NAME	DATE	ESCAPE WHEEL ASSEMBLY		FS- 3144		
DRAWN	<i>K...</i>	30.12.20			REVIEW NO: 0		
CHECKED	ललित मेरी	30.12.20			SHEET NO- 1		
HOS/CDD	<i>[Signature]</i>	31/12			NO OF SHEETS- 1		
LWM/FS	<i>[Signature]</i>				COMPT.		
HOS/FS			M/C:	ESCAPE WHEEL ASSEMBLY (06414165)			
APPROVED	WM/FS	<i>[Signature]</i>	02/01	STORE: 84mm HEAT 751 PRECURSOR SA DEVICE			
NOMENCLATURE		SIGN.					
AMENDMENTS							



Isometric view

FS-3193 Pressed against stop and with bevelled edge against stop plane [2]

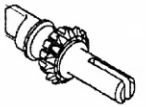
Riveted so that FS-3193 will endure an axial load of $\geq 137N$ [1]



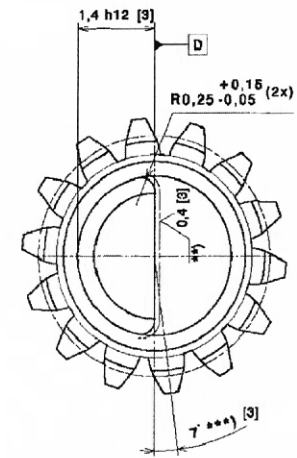
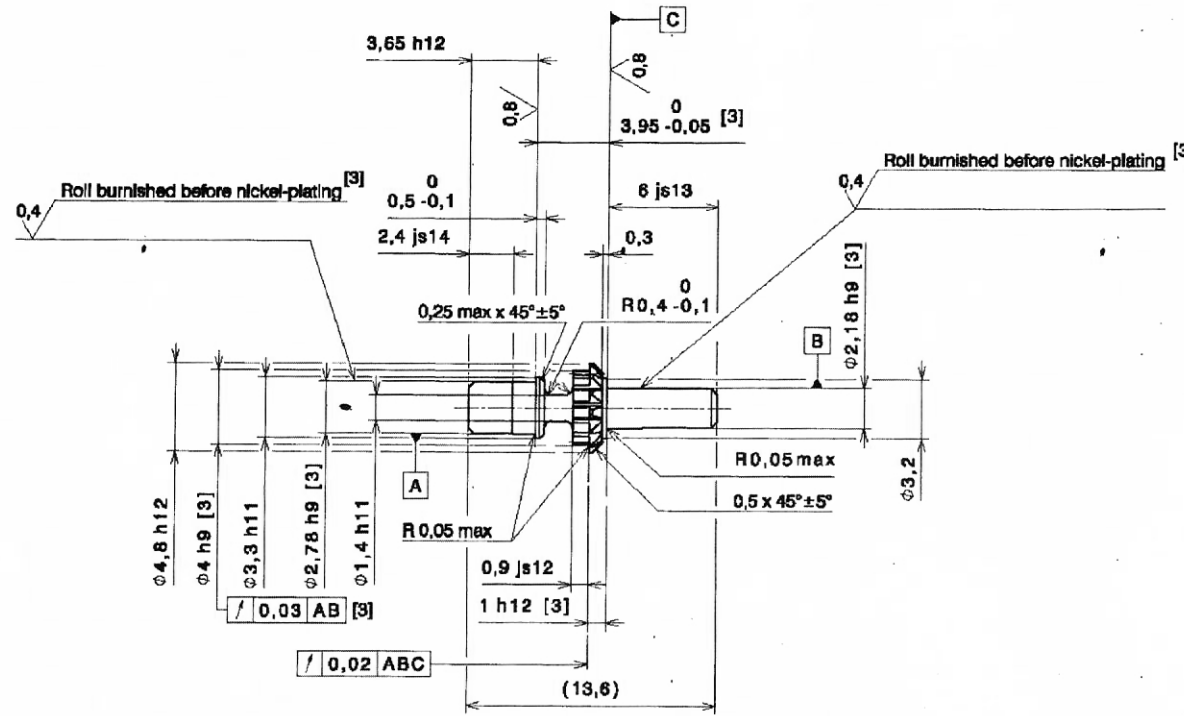
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 दिनांक: 04-03-21
 Date: 04-03-21
 for JWM/CDD

* VERIFIED ON ASSEMBLED LEVEL
 MASS-0.64g
 FORM & POS TOL ACC. TO- ISO 1101

				DIMENSIONS ARE IN mm.	MATERIAL-- AS ABOVE	ORDNANCE FACTORY AMBAJHARI आईनैन्स फैक्टरी अम्बाझरी
				FIRST ANGLE PROJECTION	NOMENCLATURE CENTRE WHEEL ASSY.	
				SCALE - NTS		
				2021 NAME DATE		
				DRAWN मंगल कौ 05.02.21		
CHECKED [Signature] 6.2.21						
HOS/CDD [Signature] 6.2.21	M/C:	REVIEW NO: 0				
JWM/FS [Signature] 08.2.21		SHEET NO- 1				
AMENDMENTS				JWM/FS [Signature]	STORE: FUZE 84mm HEDP-502	NO OF SHEETS- 1
						COMPT. CENTRE WHEEL ASSY. (05214667) ISSUE-2

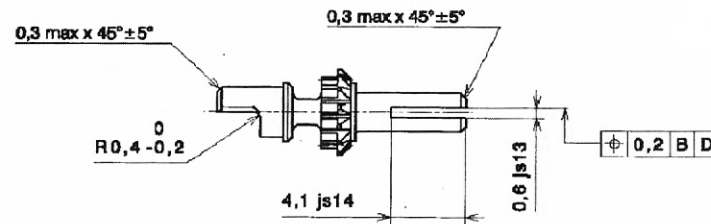


Isometric view



SCALED VIEW

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 यह प्रतिमा को डाटा एफ.ए.ए.
 द्वार को गड में
 दिनांक: 30/6/21
 Date: 01-07-21 for JWM/CDD



*) NICKEL PLATED 2-3 SAMPLE SIZE : 2/1000PCS.
 DEFECTS IN SAMPLE NOT PERMISSIBLE.

*) EVEN AND FLAT. VISUAL INSPECTION[3]
 *) BURNISHED BEFORE NICKEL-PLATING

***) SAMPLE SIZE ACCORDING TO SPECIAL CASES.
 (ALSO VERIFIED ON ASSEMBLED LEVEL.)

GEAR DATA
 Z=14 TEETH
 m=0.3
 d=φ4.8 h 12
 d_m=φ4.2
 d_i=φ3.55.
 =20
 INVOLUTE PROFILE

MATERIAL : Sandvik 20AP[2]

GENERAL SURFACE ROUGHNESS Ra 1.6
 SHARPE EDGE BROKEN 0.1 MAX.
 FORM AND POS TOL ACC. TO ISO 1101
 GENERAL TOLERANCE ISO 2768-fk
 FREE FROM BURRS [3]
 DIMENSIONS AFTER SURFACE TREATMENT

NOMENCLATURE		SIGN.
AMENDMENTS		

DIMENSIONS ARE IN mm.		
FIRST ANGLE PROJECTION		
SCALE - NTS		
2021	NAME	DATE
DRAWN	thg	30.06.21
CHECKED	ललित जी	30.06.21
HOS/CDD	SCDD	30/6/21
APPROVED	JWM/FS	30/6/21
APPROVED	JWM/FS	30/6/21

MATERIAL- AS ABOVE
NOMENCLATURE
CENTRE ARBOR
M/C:
STORE: FUZE 84mm HEDP-502

ORDNANCE FACTORY AMBAJHARI
आर्डनेन्स फैक्टरी अम्बाझरी
DRG. NO : FS-3193
REVIEW NO: 0
SHEET NO- 1
NO OF SHEETS- 1
COMPT. CENTER ARBOR (304094648)