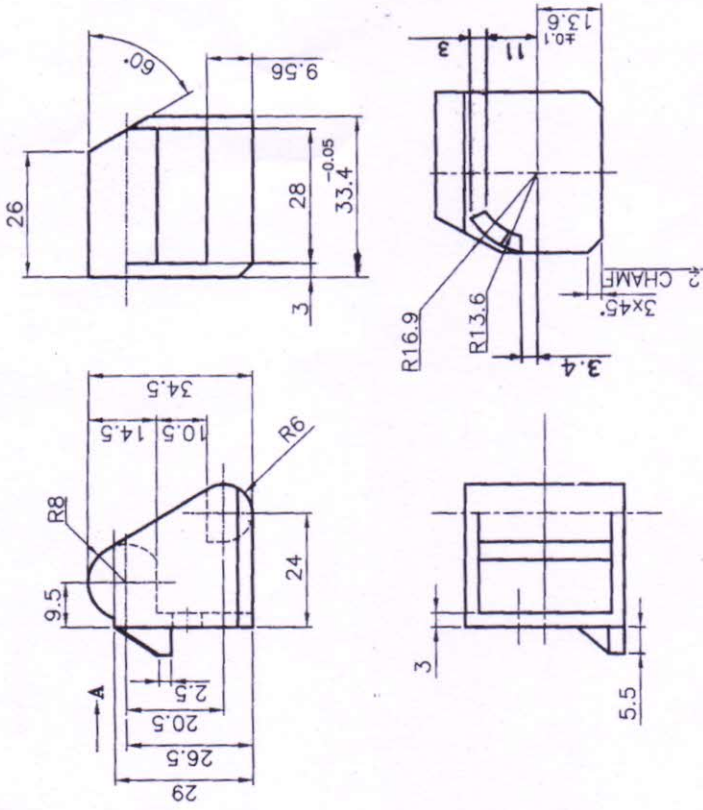


DRG. No.: TEND 2209*



DIMENSIONS ARE IN mm.
DRAFT ANGLE FOR HOLES 1°
CASTING RADIUS R 1mm

UNTOLERATED DIMS ARE AS PER IS : 11166-1984 CLASS I
OF INVESTMENT CASTING. CASTING TO BE SUPPLIED IN
NORMALISED CONDITION.

MATERIAL:-
BS:3146 PART -1: 1974
TYPE - CLASS: 5 GRADE-A.
(NON STRESSED COMPONENT)

RADIOGRAPHIC TEST AS PER ASTM-E-192

ACCEPTENCE STANDARD:-
GAS HOLE & FOREIGN MATERIAL: LEVEL-5.
SHRINKAGE (ALL TYPES) - LEVEL 3

CASTING SHOULD BE FREE FROM DEFECTS LIKE CRACKS,
SURFACE FINISH MUST BE SMOOTH.

TEN NOS. OF SAMPLES TO BE SUPPLIED
FOR QUALITY CLEARANCE AT DFT BEFORE
BULK SUPPLY.

CERTIFIED CORRECT COPY
OF APPROVED DRAWINGS
AT THIS DATE... 5/3/18

Design & Drawing Office
Ordnance Factory,
Tiruchirappalli-600016

UN CONTROLLED COPY

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
TRACED	SIGNATURE & DATE				SCALE NTS
DRAWN	<i>S. Subash</i>		CASTING DRG		STORE DRG. NO. 30P 5001
CHECKED	<i>[Signature]</i>		FOR: BLOCK STOCK		OPERATION NO.
HOS/D&DO	<i>[Signature]</i>		OF: 40mm MGL		
OFFICER/PRODN.	<i>[Signature]</i>				
OFFICER/D&DO	<i>[Signature]</i>				
DA. NO.117/13 Dt:15/09/2013					
AMENDMENTS & DATE					
APPROVED ON: 02/2014					
DES. REF. NO.					
DRG. No.: TEND 2209*					
ORDNANCE FACTORY TIRUCHIRAPPALLI - 6.					
SHEETS: 1					
SHEET No.: 1					

DA. NO.117/13
Dt:15/09/2013

AMENDMENTS & DATE

APPROVED ON: 02/2014

DES. REF. NO.

DRG. No.: TEND 2209*

ORDNANCE FACTORY
TIRUCHIRAPPALLI - 6.

SHEETS: 1

SHEET No.: 1