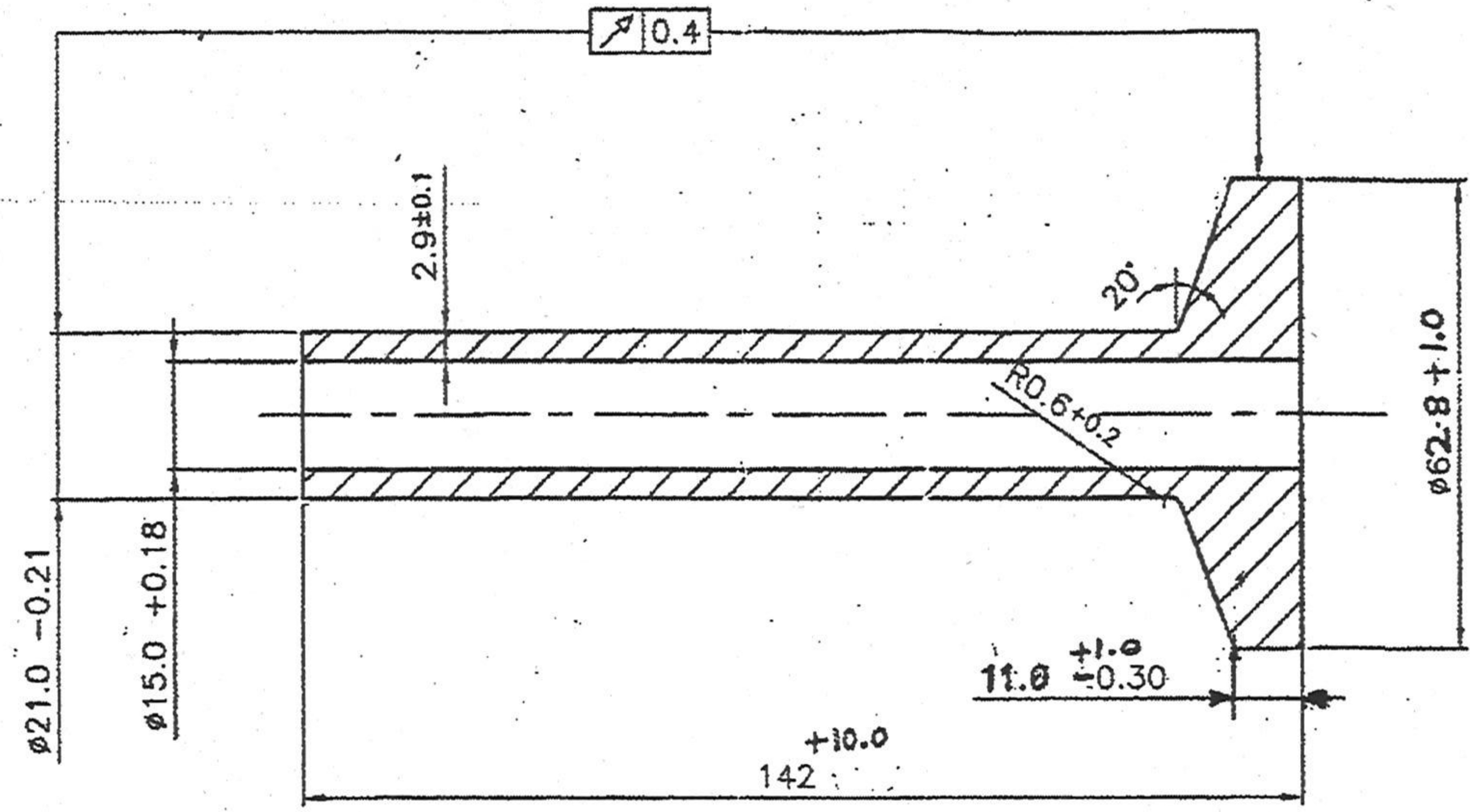


DRG. NO : CC-533 C

TOLERANCE ON UNTOLERATED DIMS. ARE AS PER IS: 2102, MEDIUM CLASS



MATERIAL:
ALUMINIUM TO SPECIFICATION
IS:733 GRADE 64430 IN 'WP' CONDITION
HARDNESS → HV₁₀ - 85 TO 120

COPY ISSUED BY [Signature]
यह प्रति ली डी डी/ओ.एफ.ए.ने
द्वारा दी गई है।
दिनांक : 19-05-14
Date 19-05-14

DRAWING BASED ON CG-84

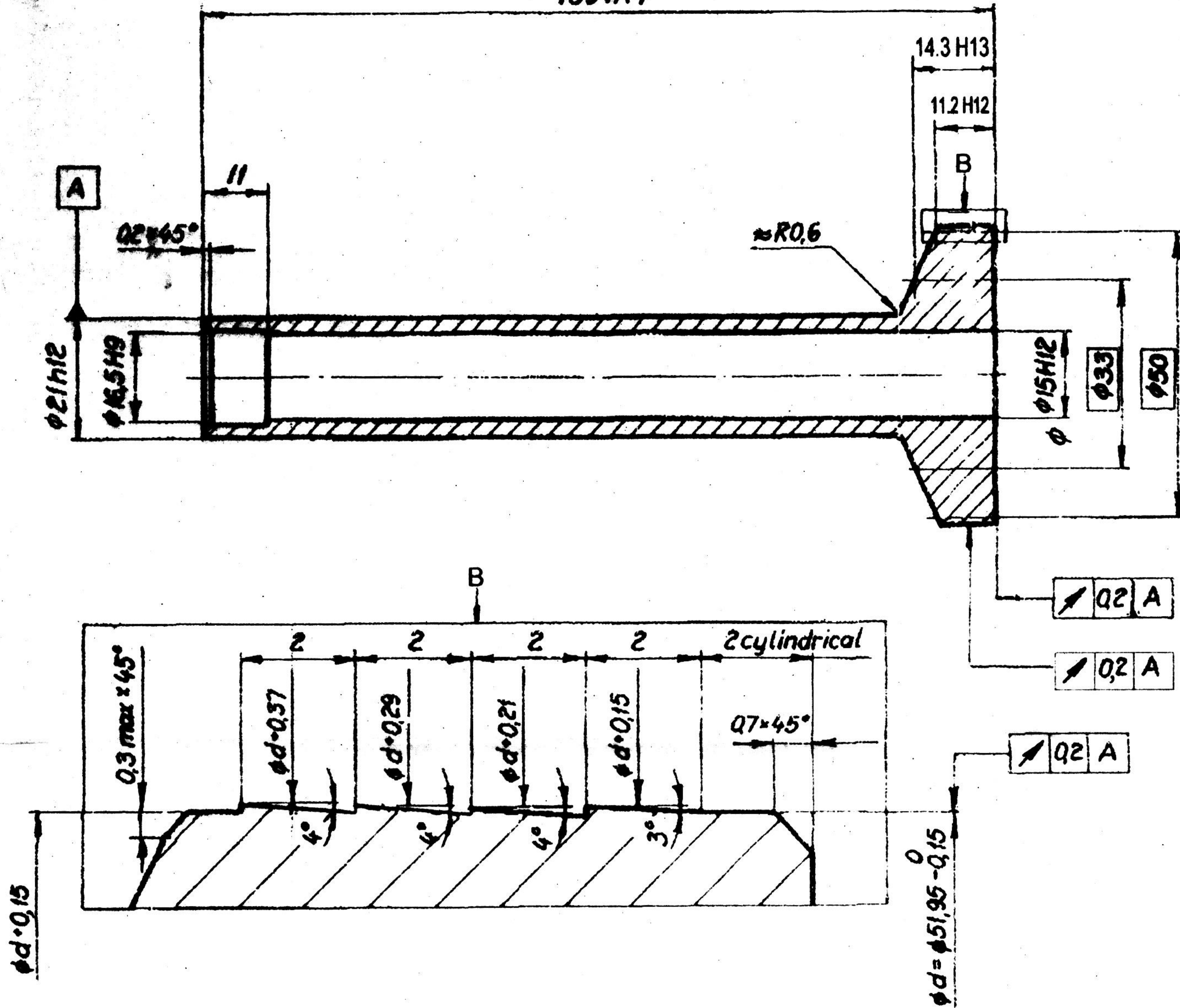
REV.	DATE	DESCRIPTION	SIGN.
1	28-05-2014	BS 1474:1987, GY 6082 IN T&B MATL. DELETED	Mu JGM/CM
2	21/11-2013	PROVISIONAL IS DELETED. +1 DIMENSION 142+10, Ø62.8 & 11±0.3 WERE 142+1 Ø62±0.2 & 11±0.3 AUTH: LT. FOR BS HARDNESS & NOTE ADDED.	Awam JGM/CCS
3	24/07-2012	Ø53 DELETED AND DISTANCE 11.0±0.3 WAS 12.6±0.3	AWM/FS
AMENDMENTS			

NOTE:- PGG OF 9mm DIAMETRICALLY MAXIMUM PERMITTED

DIMENSIONS ARE IN mm			MATERIAL : AS ABOVE	
THIRD ANGLE PROJECTION			ORDNANCE FACTORY AMBAJHARI	
SCALE : 1 : 2			DRG. NO : CC-533 C	
2012	NAME	DATE	SHEET NO : 1	
DRAWN	VAS		NO. OF SHEETS : 1	
CHECKED			OPERATION NO :	
JWM/CDD		22/05/14	COMPT. : DISTANCE TUBE (TPT)	
APPRO. JWM/FS			FINAL F1301-047281 D	
APPRO. JWM/CCS			M/C: 30 T EXT. PRESS	
			STORE : 84mm MARK-II	

DC 34692-A

139 h14



NOTE :-

FOR MARKING & STENCILLING
SEE DRG No.CIA/AMN/2188(LATEST ISSUE)

SURFACE TREATMENT :-

CHROMATED TO SPEC. F 1329-014360 OR
ACCICOAT 600 OR ANODISED TO SPEC DEF 151 TYPE II

MASS:- APPROX. 125 grams.

INDIGENIOUS MATERIAL :-

"IS:733/1983 GRADE 64430 IN WP CONDITION MATERIAL
INSPECTION OF FINISHED COMPONENT AS PER IS:1285/1975 GRADE 64430 WP"
NO HIGH GRAIN SIZE AREAS ARE PERMITTED
IN THE FINISHED PRODUCT AFTER MACHINING.

MATERIAL : ALUMINUM W3-4212-06
Al - Si 1Mg Mn

MATERIAL REQUIREMENTS:
Chemical Composition

	Al %	Cr %	Cu %	Fe %	Mg %	Mn %	Si %	Ti %	Zn %	other %	
										Of each	Total
Nom	97.4	-	-	-	0.9	0.7	1	-	-	-	-
Min	-	-	-	-	0.6	0.4	0.7	-	-	-	-
Max	-	0.25	0.10	0.50	1.2	1.0	1.3	0.10	0.20	0.05	0.15

AFTER THE SOLUTION TREATMENT/ARTIFICIAL AGING
THE DISTANCE TUBE SHOULD HAVE HARDNESS 85-120 HV.

R. NO.	DATE	AUTHORITY	REVISION	ZONE	AHSP	D.O.	SIG.
	07-06-2011	DGQA. S.Q. SEC. I CHAP 10 PARA 40	DRG REDRAWN WITHOUT CHANGE & MASTER COPY REPLACED IN SUPERSESSION OF EXISTING DILAPIDATED COPY OF SAME NO.				
			PREVIOUS DC Nos. 34692-A, 34989-A, 35366-A, 35509-A, 36160-A & 37282-A (DI.25-05-2011)				
DRG SEALED:- 17-08-1989							
D	1	B2			88-08-30	MU	12/11011
C	1	Redrawn; E4			77-06-08	OH	
Uppdrags nr	Andr nr	Beskrivning		Datum	Utförd	Gransk/Godk	

Del	Antal	Beskrivning/Beteckning	Ring/Reterens	Material/Ovrigt
Uppdrags nr		Uppdrags nr	Uppdrags nr	AS ABOVE
1114/2		Greening 0.3 0.3 x 45	GAUGE SCHD.	
H.A.		B.P.	H.Z.	I-2759
67-08-22				NTS
Distance Tube				
FORENADE FABRIKSVERKEN HUVUDKONTORET ESKILSTUNA				F1301-047281 D

01-047300

1/18