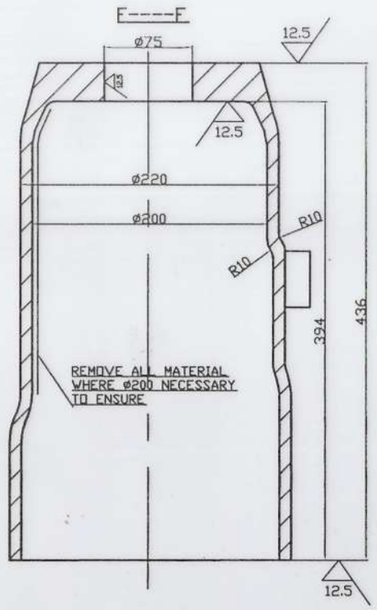
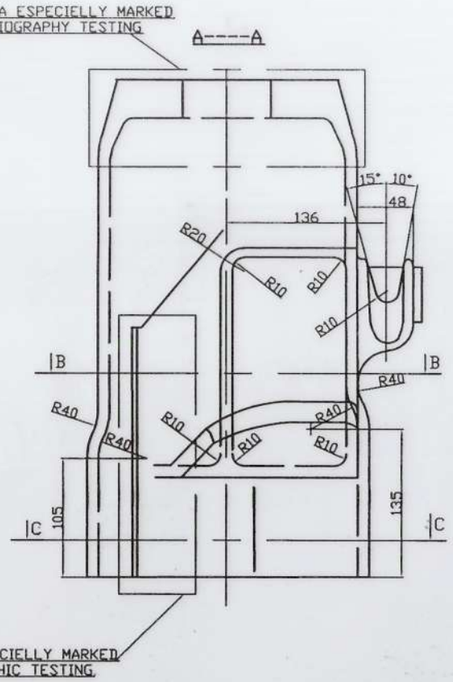
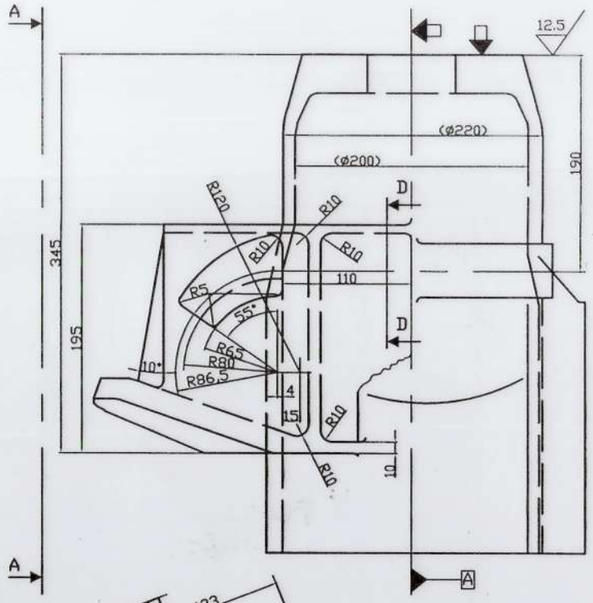
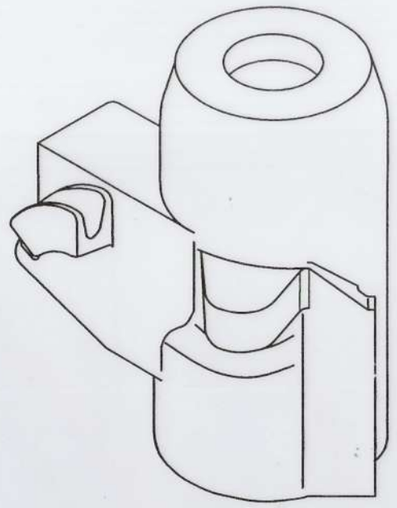
DRG. No. GCF/50/39491

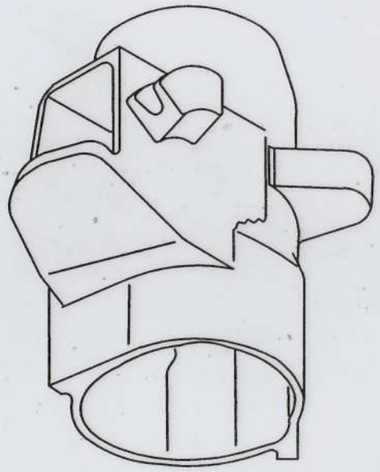
DRAWING CONVENTIONS CONFORM TO SP 46:1988
DIMNS. ARE IN mm. UNLESS OTHERWISE STATED.

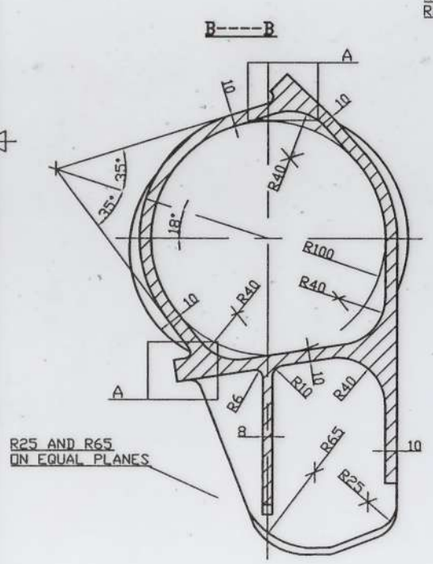


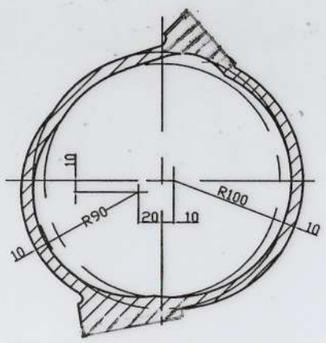



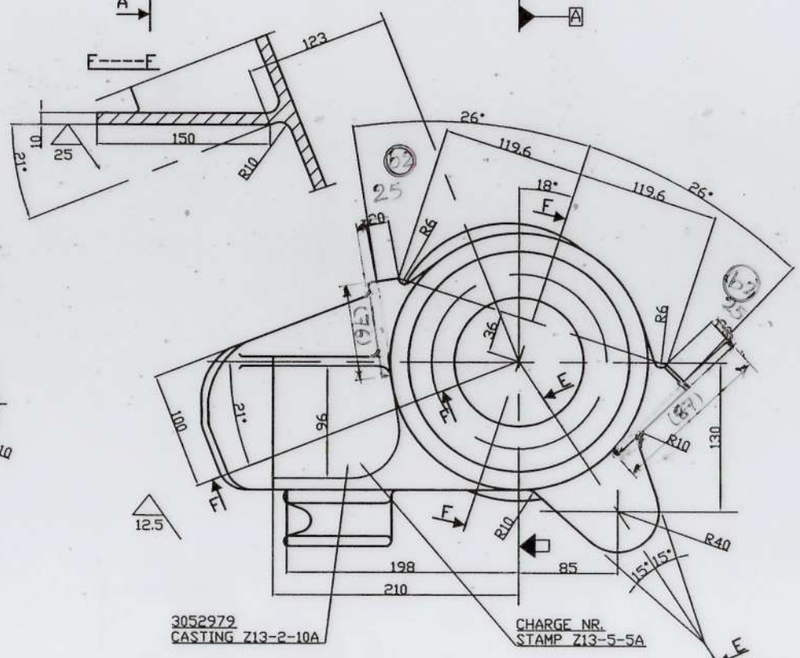



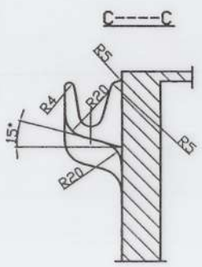



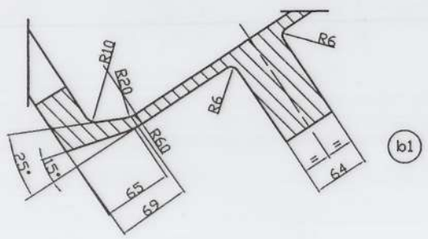





MAIN MATL.- SS 2225-24, WEIGHT- 40.5 Kg.

OR IS:10343-1999, Gde-8Q,
COND 'QT' WITH %S & %P EACH 0.035MAX
TO ACHIEVE Rp0.2=600Mpa MIN,
Rm=800-950 Mpa, El=10%, HB=235-285

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

| PT.No. | NOMENCLATURE | No. OFF | MATERIAL | HARDNESS | STANDARD | SIZE | REMARKS |
|---|---|---|---|---|---|---|---|
| GEN. TOL. NOT SPECIFIED | | | | | | FOR Sr. GM G.C.Fy. | |
| LINEAR DIMENSIONS | | | | | | 2014 NAME DATE APPROVED | |
| 0~ 6 ±0.1 / 6~ 30 ±0.2 / 30~ 120 ±0.3 / 120~ 315 ±0.5 / 315~ 1000 ±0.8 / 1000~2000 ±1.2 | | | | | | DRN. SK JAIN 10.12.14 | |
| | | | | | | CKD. | JWM/Shop |
| ANGULAR DIMENSIONS | | | | | | HOS/QDC 11.4.22 | |
| 0°~ 10° ±1° / 10°~ 50° ±30' / 50°~100° ±20' / >~100° ±10' | | | | | | SEC. M/C | JWM/TR |
| ~ UNMACHINED ▽ ROUGH ▽▽ SMOOTH ▽▽▽ FINISH | | | | | | SCALE NTS. REF. DEM. REF.DRG.No. 3052978 3052359 | |
| | | | | | | DRG.No. GCF/50/39491 | |
| | | | | | | SHEET NO. OF SHEETS | |

| INDEX | AMENDMENTS | SIGN | DATE |
|---|---|---|---|
| 468/b2 | DIM 25±25 WAS 20±20 RESPECTIVELY | | 08/06/22 |
| 456/b1 | DIM 15.5 & 23 DELETED AND DIM 64 ADDED. SPLIT FLANGE CONVERTED INTO SOLID FORM | | 09/04/22 |

CASTING FOR HOUSING LEFT 155mm DHANUSH

GUN CARRIAGE FACTORY, JABALPUR