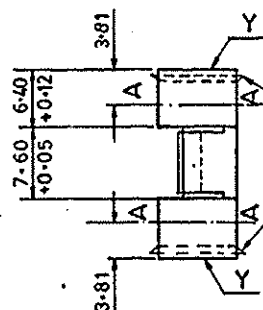
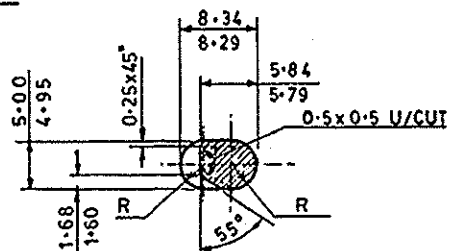
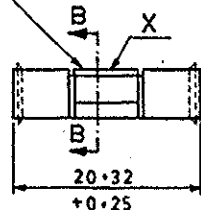


D.S.CAT. 1005-003146
NO.



DOTTED LINES INDICATE FORM
OF COMPONENT AFTER CLINCHING
AT ASSEMBLY.

RECESS GROUND AT ASSY.



SECTION 'BB'

FOR EXPLANATION SEE C.S.A.I.D. NOTE SHEET NO.1
DIMNS. ARE IN m.m.

NOTE :-

FOR SPECN. LATEST ISSUE SHOULD BE FOLLOWED

WHERE TOLERANCES ARE NOT SHOWN.

- DIMENSIONS IN WHOLE NUMBER ± 0.76 mm.
- DIMENSIONS WITH ONE DECIMAL PLACE ± 0.25 mm.
- DIMENSIONS WITH TWO DECIMAL PLACES ± 0.13 mm.

a). MACROETCH TEST TO ASTM E 381-1984 WILL BE
AS PER COL. (C) OF SL.NO.1 OF CQA (SA)
NOTE SHEET NO.1.

b). NMIR TEST TO IS:4163 WILL BE AS PER
COL. (C) OF SL.NO.3 OF CQA (SA) NOTE
SHEET NO.1.

HEAT TREATMENT :-

PROTECT EACH END FROM LINES 'AA' CASE
HARDEN BODY TO 0.508 - 0.635 HARDNESS- HV
600 MIN. TESTED AT POINT 'X', HV. 350 MAX. AT
POINTS 'Y', EQUIVALENT ROCKWELL HARDNESS
'D'-63 MIN. TESTED AT POINT 'X'.

METRIC

27.12.99	24599-SA.	PROFORMA CHANGED, ACTUAL SIZE VIEW DELETED, HARDNESS AMENDED, NEG. RE-TRACED AND DRG. RE-SEALED.	Andar	Shr	CD.	BLK	CCPY	DRN.	CHD.	TRD. SKG. SH.	COMP. Material	AHSP CQA(SA) ICHAPUR
DATE AUTHY.								SCALE :- 2:1		EST. MASS		ASSY. 1005 - 003144
BRIEF RECORD								DT. 27.12-99		APPROVED DT. 2.8. 67.		
D.C. NO. 11258-SA, DT. 5.5.72								BS:970 PART 1:1983 Gr.665 M17 OR		NEG. RE-TRACED		
NOMENCLATURE :- LOCKING PIECE								MATERIAL :-		IS:4432 : 1988 DESIGNATION 20Ni 7 Mo 2.		DGNR'S REF. CISA 333/7/2
SIGN.								H.T/HARDNESS :- AS STATED		PART NO.		DRG. NO.
PROTECTIVE FINISH :- ON ASSY.								D.S.CAT. NO. 1005-003146				