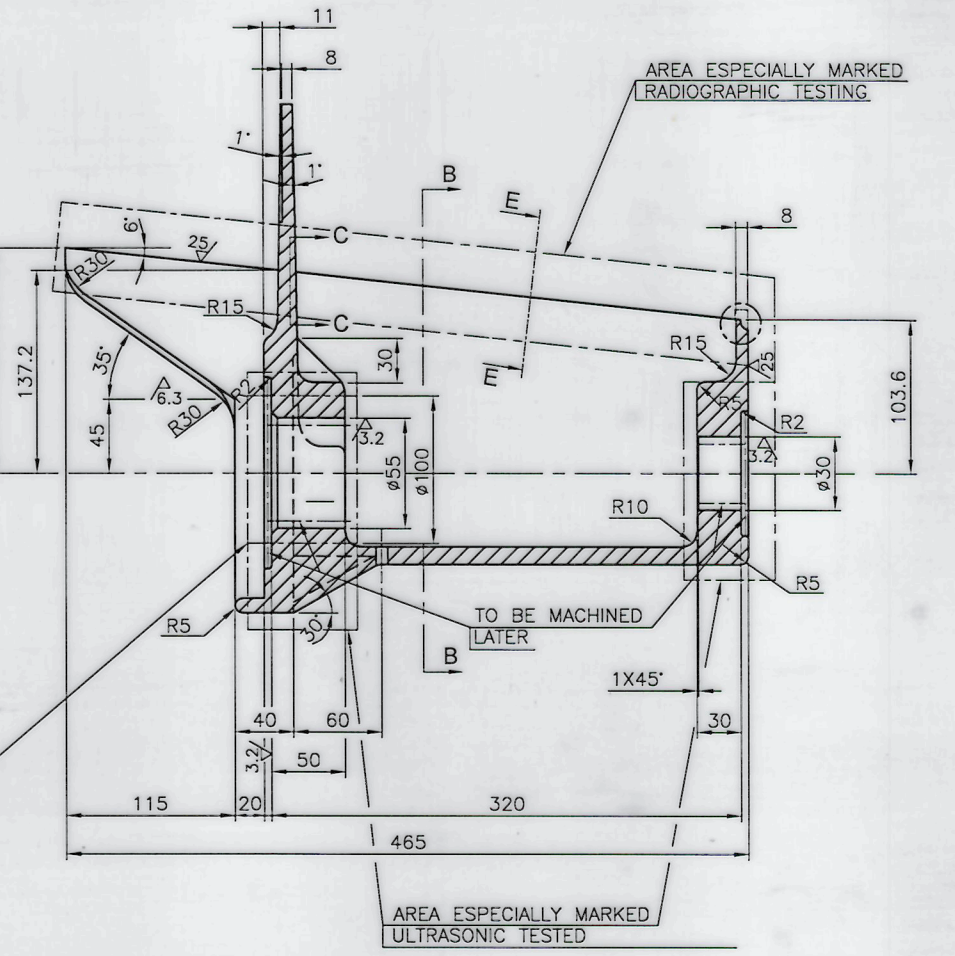


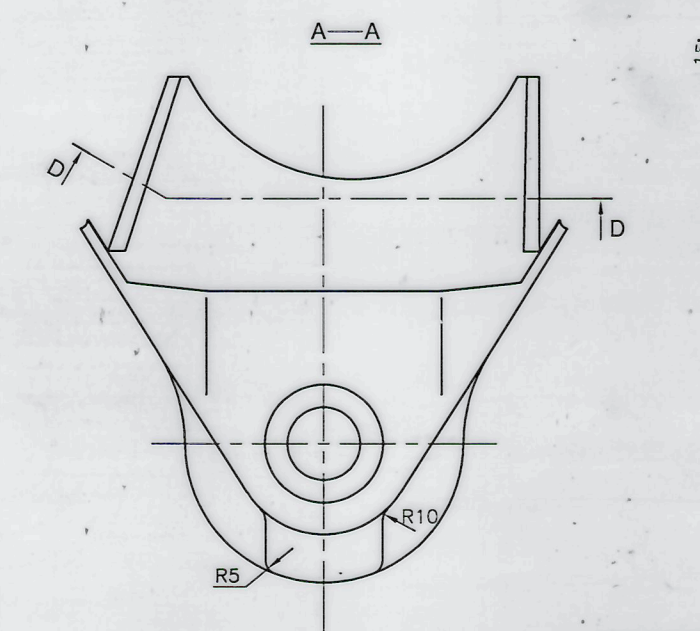
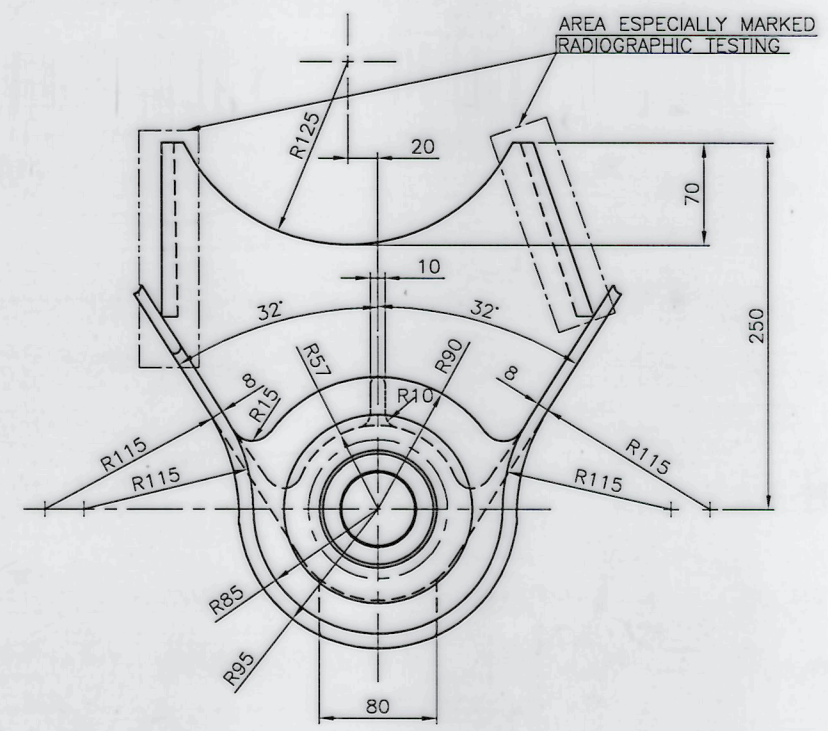
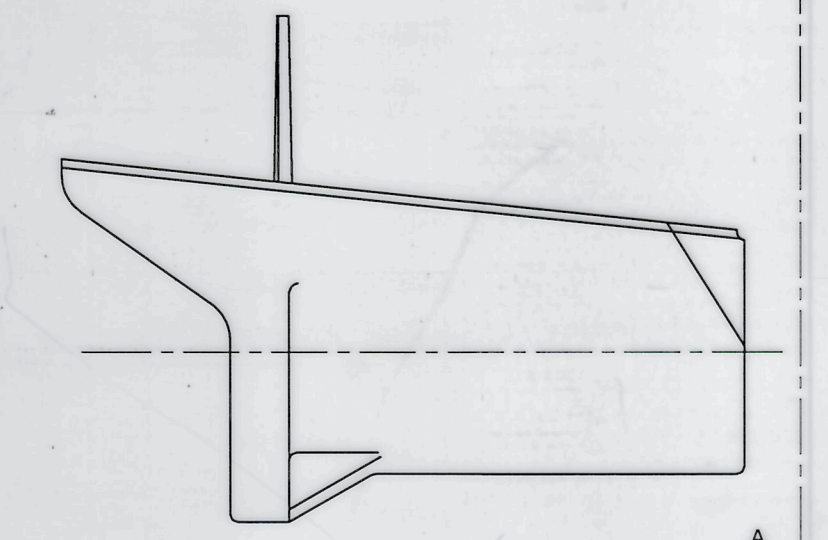
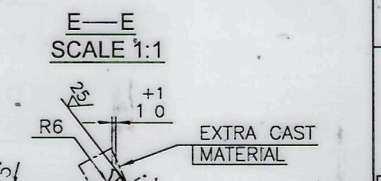
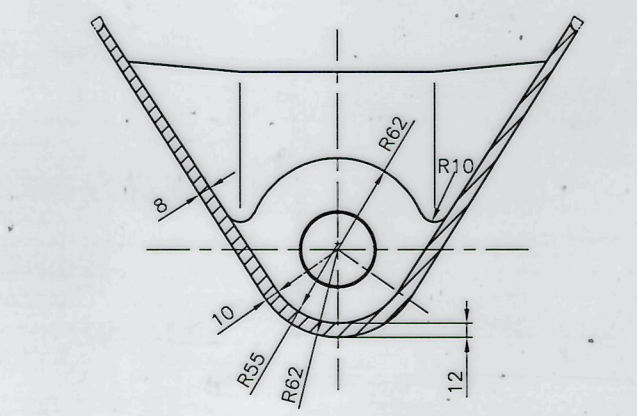
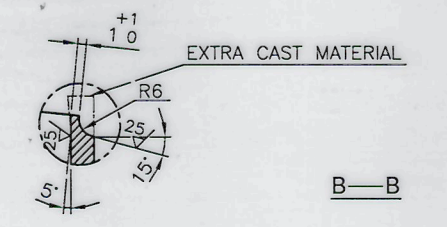
CH NR  
STAMP Z13-2-10A

3 052 356  
CASTING Z13-2-10A

CLASS 1  
AREA ESPECIALLY MARKED  
ULTRASONIC TESTED



AREA ESPECIALLY MARKED  
ULTRASONIC TESTED



MANUFACTURING SPECIFICATION A 2003 AND O 804 092

DIMENSIONS GIVEN REGARDING WALL THICKNESSES  
ARE MINIMUM.

CASTING TOLERANCE ACCORDING TO SS722, GTA 16

CASTRADIUS 3 APPLIES UNLESS OTHERWISE STATED

REF LETTER NO: ADG5/ODC/DRG/20-01 DT 25-JULY-2020

SEE CASTING DRWG 3052000 GCF-50-39475

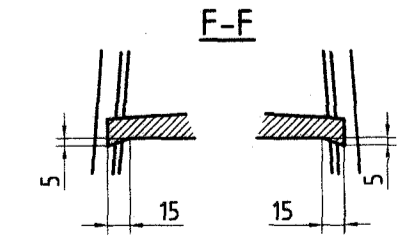
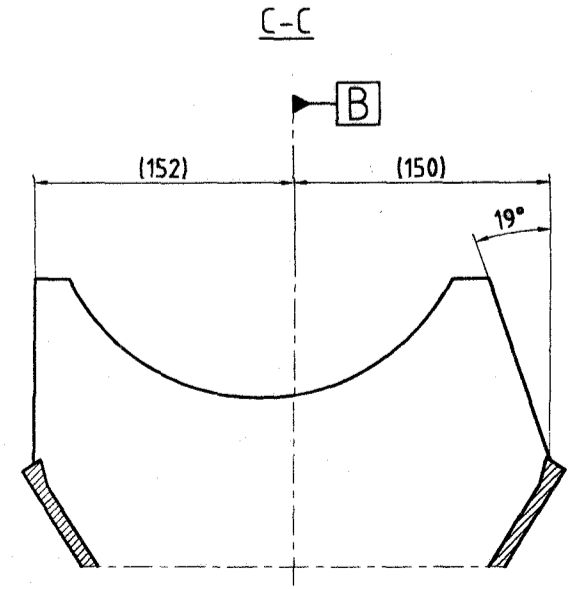
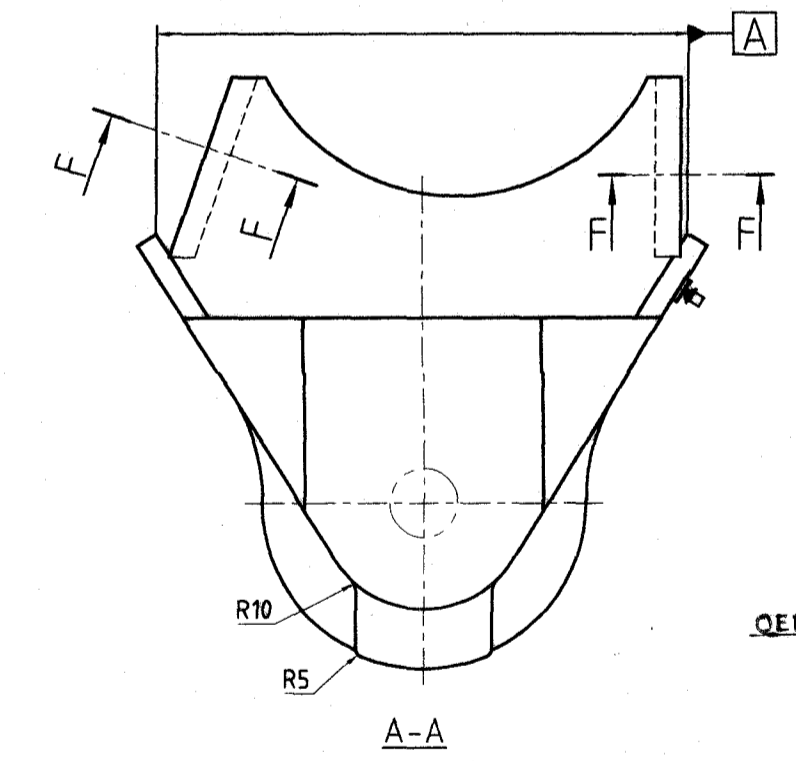
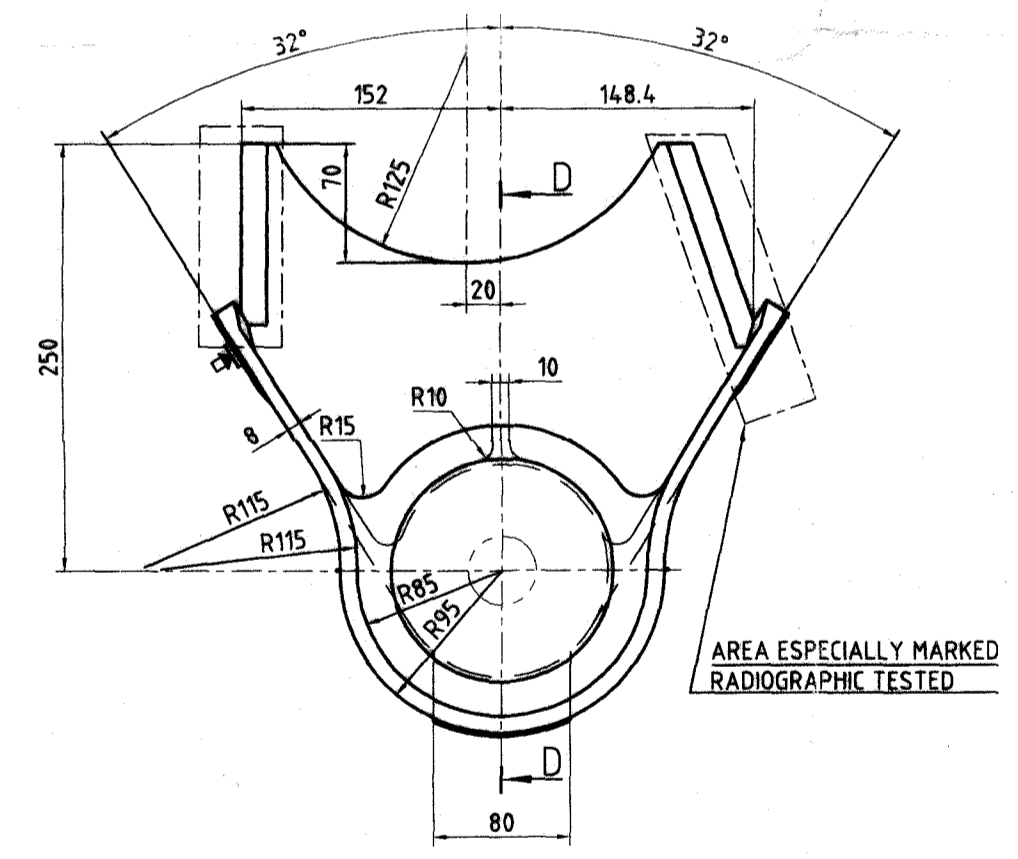
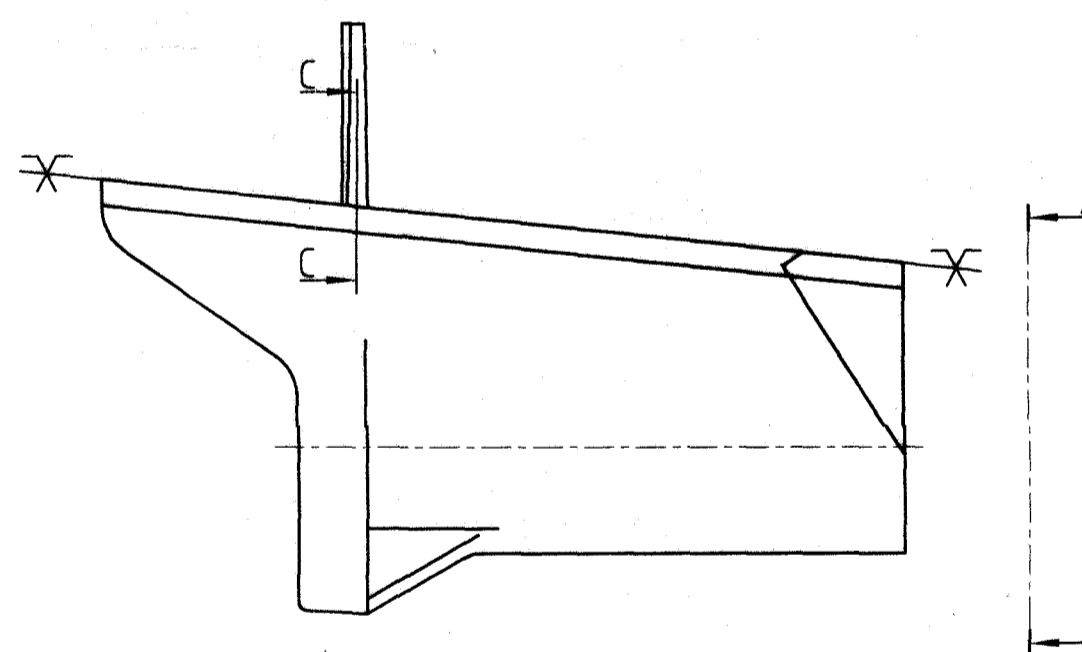
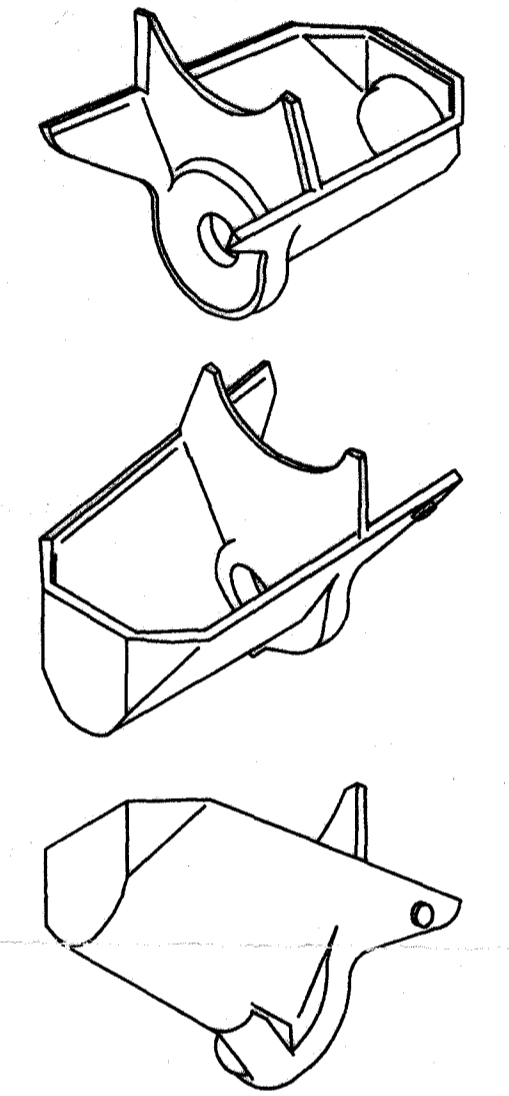
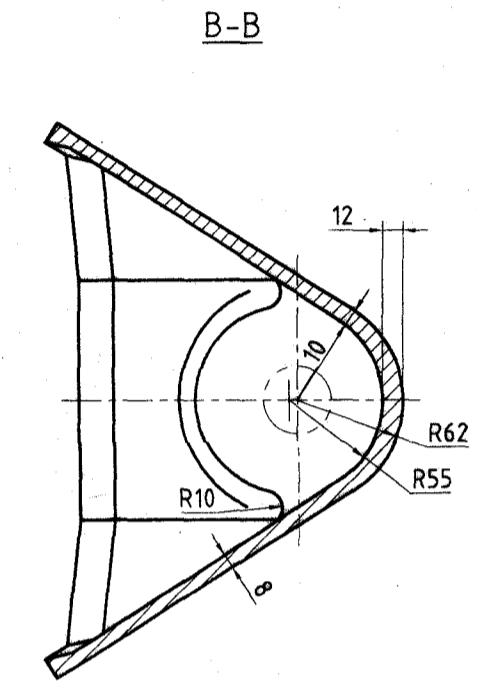
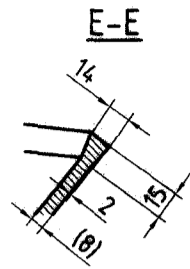
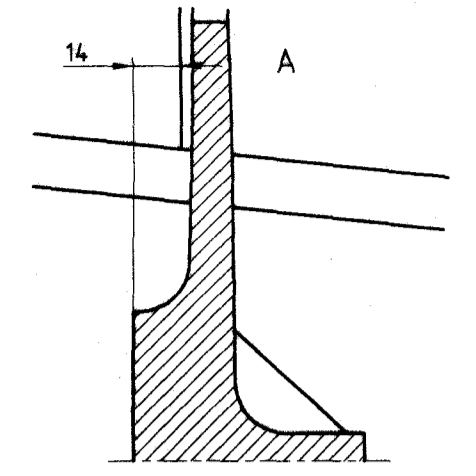
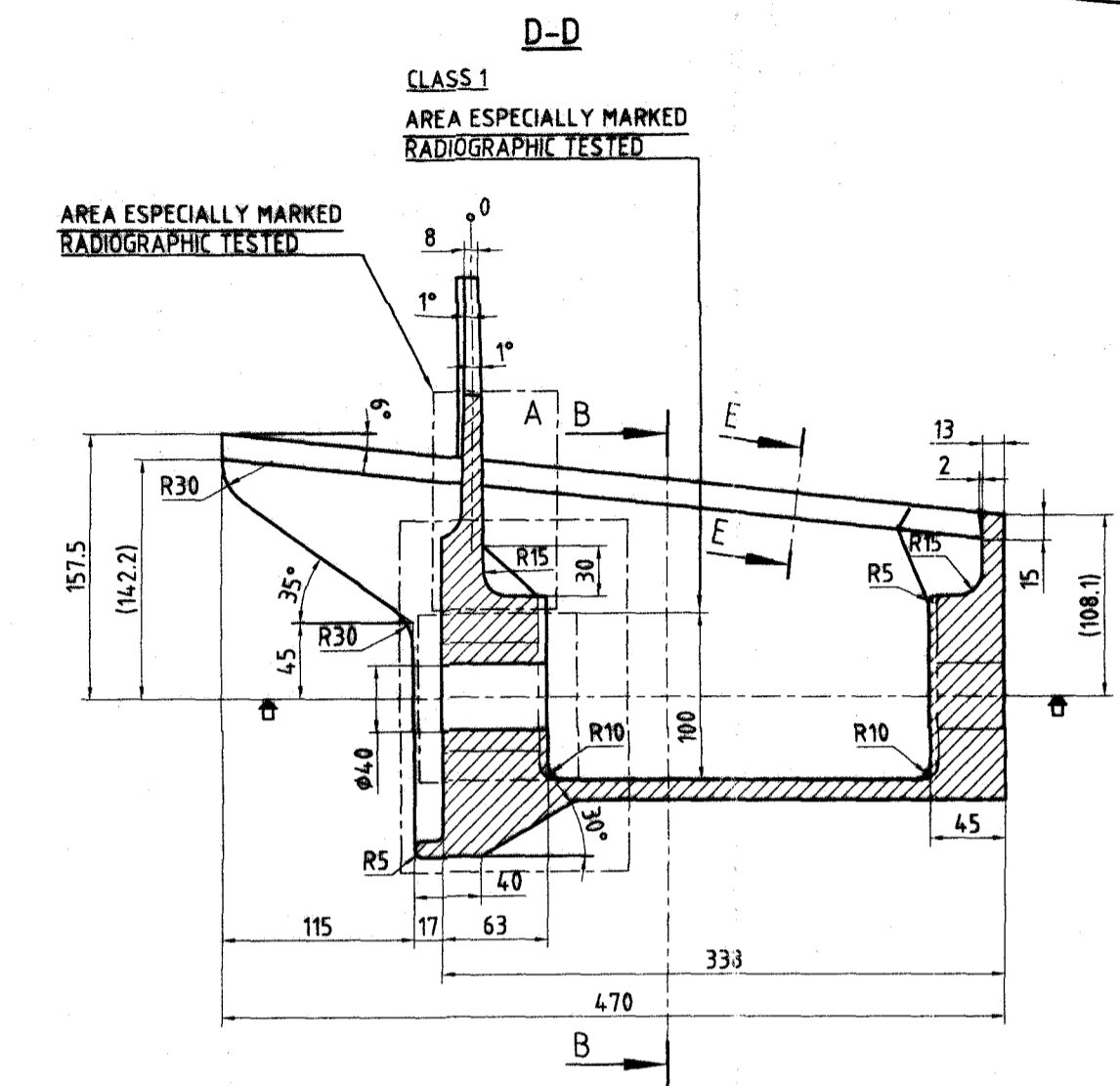
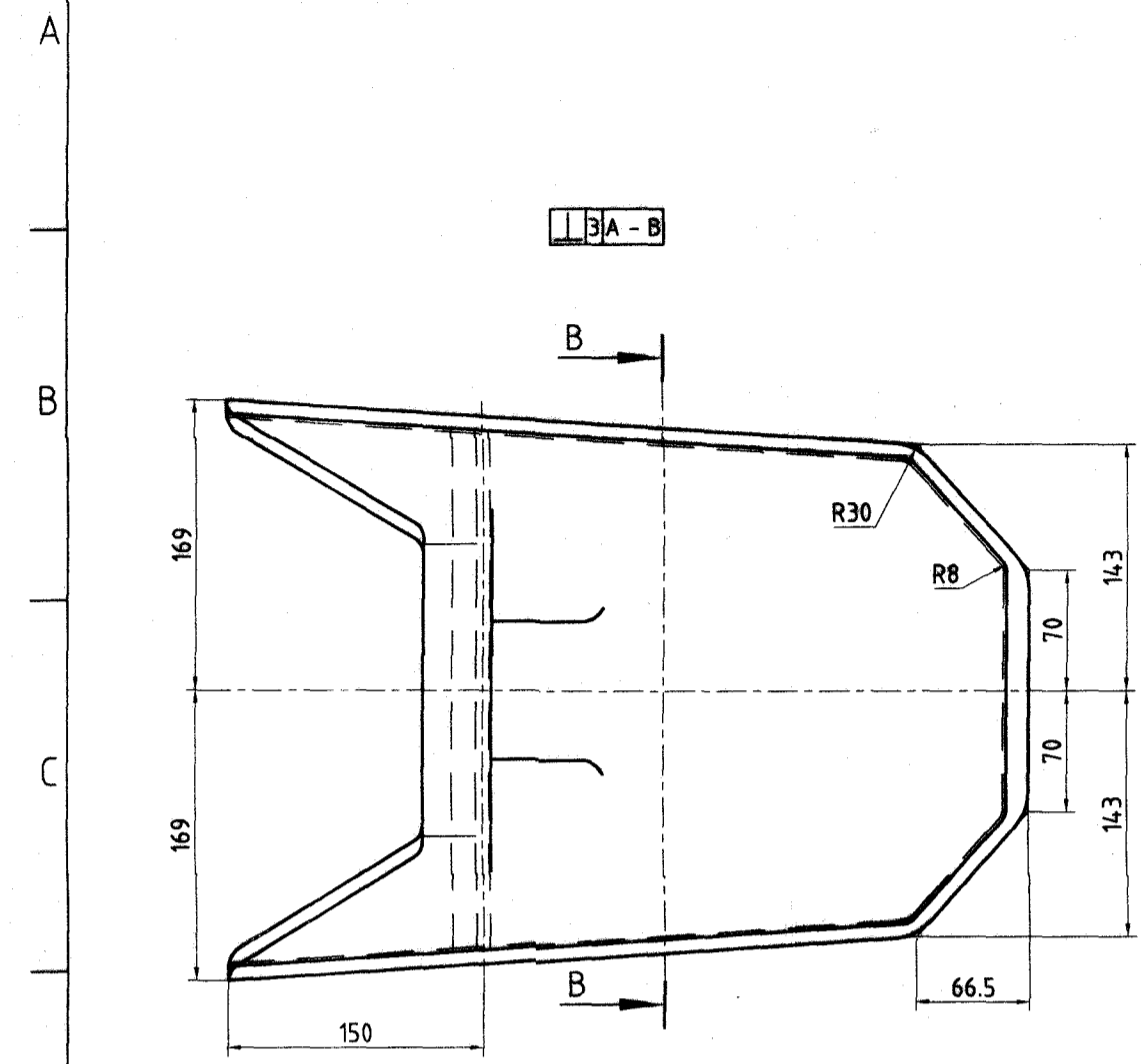
P.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STAMPED	REMARKS
GEN. TOL. NOT SPECIFIED						
LINEAR DIMENSIONS						FOR S. IN G.C.F.
ANGULAR DIMENSIONS						NAME 10:16
ROUGH						DRN. MPS 15-09
SMOOTH						CHKD.
FRESH						APPROVED
INDEX	AMENDMENTS	SIGN	DATE	APPROVED		

BEARING HOUSING  
(FOR TRADE ACTION ONLY)

MATERIAL: 15120-100, Ste. 40, Cast 100  
 REF. DRG. NO. 3052356  
 SCALE: 1:1  
 ASSY/SUB ASY: NO. 1172044

GUN CARRIAGE FACTORY JABALPUR

DRG. No. GCF/50/40865



NOTE:-  
ONE TENSILE TEST FROM SEPARATELY CAST TEST PIECE FOR EACH CHARGE.  
MANUFACTURING SPEC. A2003 & 0804092.  
DIMENSIONS GIVEN REGARDING WALL THICKNESS ARE MINIMUM.  
CASTING TOLERANCES ACC. TO SS 722 GTA16-18.  
APPROPRIATE CASTING CLEARANCE TO BE APPLIED.  
THE AREAS OTHER THAN SPECIFIED ARE TO BE TESTED FOR RADIOGRAPHY LEVEL 3.

**QEM MATL:-SS 2225-24**  
**MATL:-IS:10343-1999, GDE 80, COND. 'QT' %S & %P RESTRICTED TO %0.035EACH MAX.**  
**TO ACHIEVE Rp 0.2 = 600 Mpa MIN., Rm = 800-950 Mpa, El = 10%, HB = 235-285.** WEIGHT: 30Kg.

COMPONENT DRG - 3052356

PT.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	SIZE	REMARKS
	GEN. TOL NOT SPECIFIED						
	LINEAR DIMENSIONS						
	0- 6 ±0.1						
	6- 30 ±0.2						
	30- 120 ±0.3						
	120- 375 ±0.5						
	375- 1000 ±0.8						
	1000- 2000 ±1.2						
	ANGULAR DIMENSIONS						
	0°- 10° ±1'						
	10°- 50° ±30'						
	50°- 100° ±20'						
	> 100° ±10'						
	INDEX						
	AMENDMENTS						
	SIGN						
	DATE						
	HOS/ODC						
	SEC.						
	M/C						
	JWM/TR						
	SCALE						
	REF.DEM.						
	NTS.						
	REF.DRG.No.						
	DRG.No.						
	GCF/50/39475						
	SHEET NO.						
	OF SHEETS						

**BEARING HOUSING, CASTING BLANK**  
**(MOD. DRG.)**  
**155mm. DHANUSH**

GUN CARRIAGE FACTORY, JABALPUR