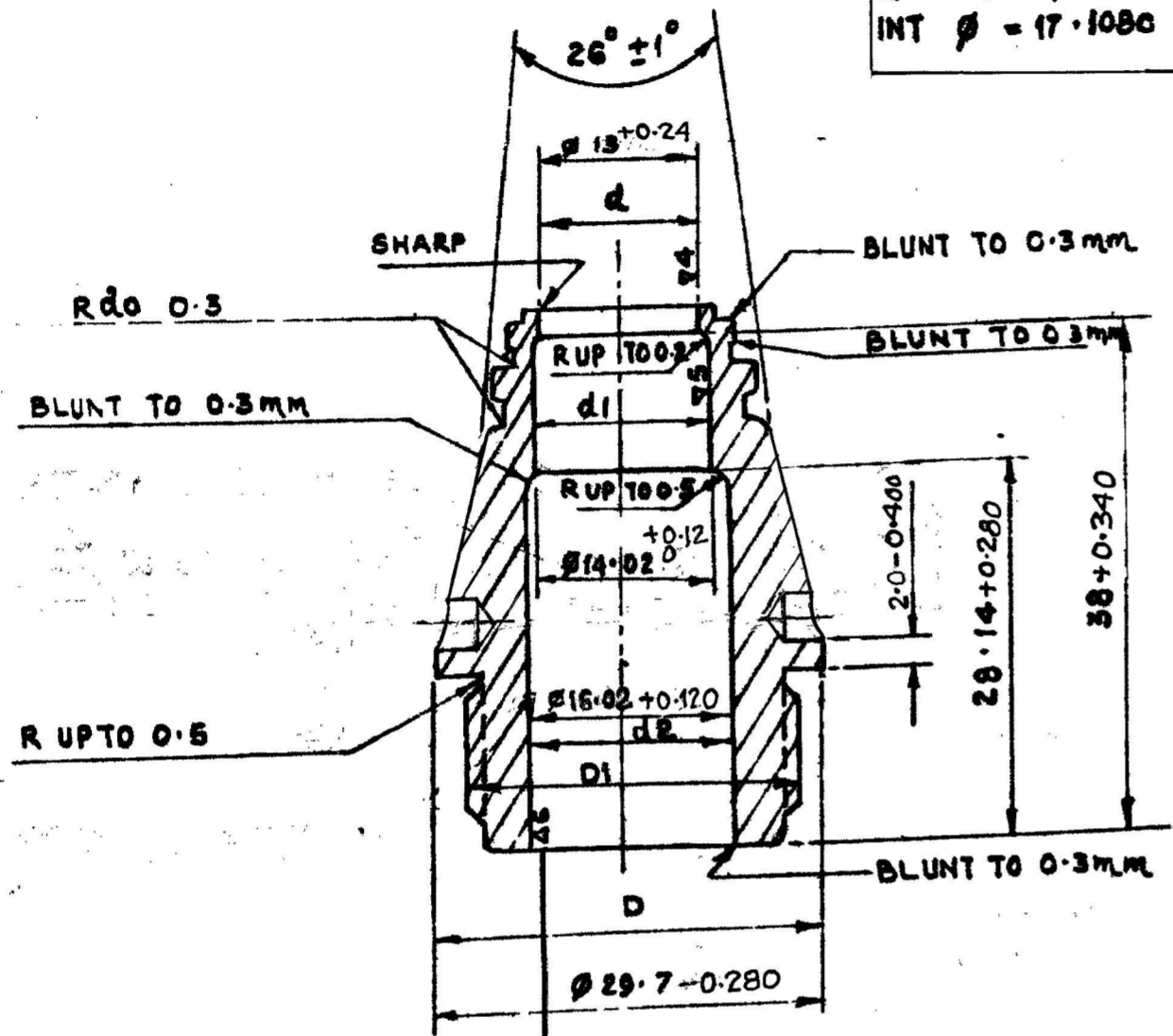
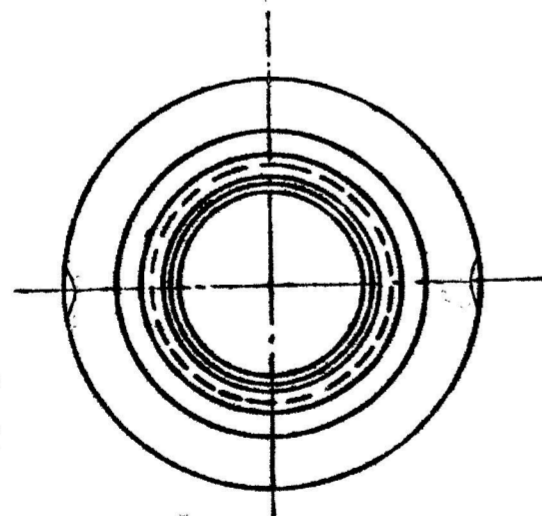


CN M 17-92 X 0.75 K 03

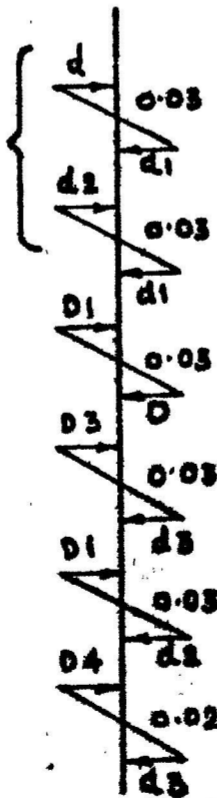
EXT $\phi = 17.92 - 0.15$
 AVERAGE $\phi = 17.433 - 0.195$
 INT $\phi = 17.1080$



OVER A LENGTH OF NOT LESS THAN 18mm FROM THE BOTTOM FACE

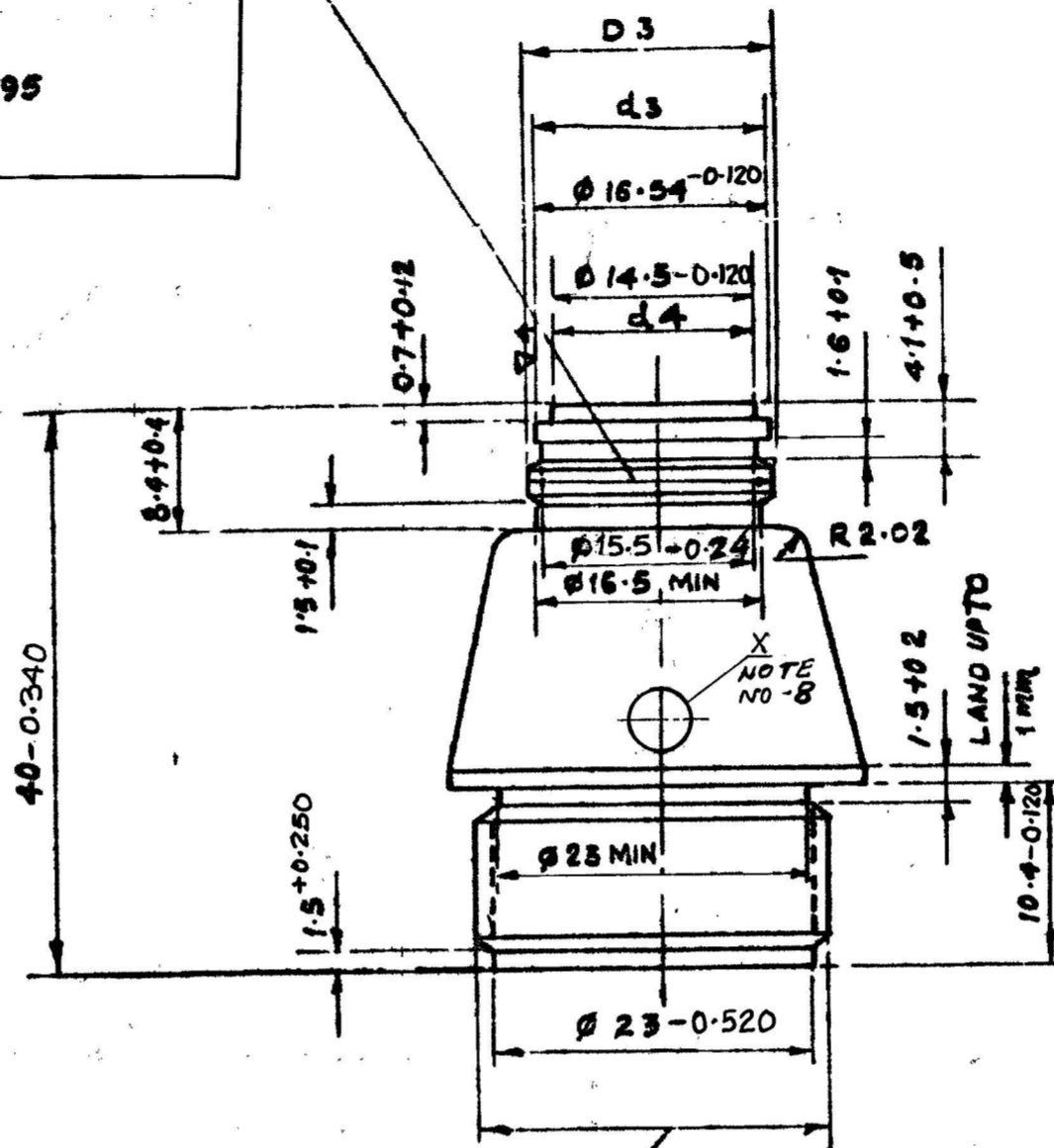


	R_a, μ
$\nabla 6$	2.5
$\nabla 5$	5
$\nabla 4$	10



SP3M 24.96 X 1 LEFT

EXT $\phi = 24.92 - 0.2$
 AVERAGE $\phi = 24.27 - 0.155$
 INT $\phi = 23.621$



NOTES

- 1) PERPENDICULARITY OF THREAD SP3M 24.96 X 1 LEFT TO THE FLANGE TO BE CHECKED WITH THREAD GAUGES HAVING NOGO FEELER GAUGE OF 0.15 mm.
- 2) MANUFACTURE OF SPANNER GROOVES WITH THE HELP OF TAPERED MILLING CUTTER HAVING AN ANGLE OF 10° AT THE APEX, IN THIS CASE THE AXIS OF THE MILLING CUTTER MUST BE AT 5° TO THE AXIS OF THE PART.
- 3) AT THE BOTTOM OF THE BORE OF $\phi 16.02^{+0.120}$ AT A DEPTH OF 27.5mm MINIMUM PROJECTION HAVING A MIN. ϕ OF 15.6 IS PERMITTED.
- 4) DIMENSION 8.4 ± 0.4 MAY BE REPLACED BY HEIGHT 31.2 AS FROM THE BOTTOM FACE OF THE PART UP TO THE PROJECTION.
- 5) THE THREAD SP3M 24.96 X 1 LEFT MAY BE CUT BY MILLING CUTTER WITH SIMULTANEOUS CUTTING OF THREAD STARTS IN THIS CASE THESE SHOULD NOT BE LESS THAN 4.25 FULL THREAD.
- 6) STEEL 65 (HARDENED) AND STEEL 50 (HARDENED) AS PER GOST 1051-59 MAY BE USED.
- 7) THE "NOGO" GAUGE MAY ENTER UP TO DEPTH OF 2mm IN THE HOLE OF $\phi 16.02^{+0.120}$.
- 8) TWO NUMBERS OF TOMMY HOLES, MARKED 'X', HAVING DIA $4.2^{+0.3}$ AND DEPTH 2.98 ± 0.2 mm.
- 9) THOUGH SURFACE TREATMENT IS NOT TO BE DONE, THE PACKAGE OF EACH 'HEAD' SHOULD BE MADE BY WRAPPING OIL SKIN PAPER TO PROTECT AGAINST ATMOSPHERIC ACTION ETC. AND AGAINST DAMAGE DURING HANDLING, TRANSPORTING AND STORAGE. APPLY RUST PROOF OIL SEALING BEFORE WRAPPING.

MATERIAL:-

STEEL TO SPECN BS 970: Pt I: 1983, 080M40
 COLD DRAWN FROM HOT ROLLED CONDITION OR
 BS 970: Pt I: 1983, 080M40 (LATEST ISSUE)
 OR
 BS:970 Pt-1: 1983, 212 M 36 COND "R"

DIMENSIONS ARE IN mm		THIRD ANGLE PROJECTION		SCALE - NTS		MATERIAL: AS ABOVE		आर्जेन्स फैक्टरी अम्बाजरी ORDNANCE FACTORY, AMBAJHARI	
2010		NAME		DATE		NOMENCLATURE		DRAWING NO.	
DRAWN		TRACED		CHECKED		JWM/CDD		HEAD	
228		17-11-2016		ALT MATERIAL UPDATED AS PER DC 37284-A Dt: 6-7-11. DRG ADV TO SA.		SIGN		(WITHOUT SURFACE TREATMENT)	
REV		DATE		DESCRIPTION		SIGN		SHEET NO. - 1	
A								NO. OF SHEETS - 1	
AMENDMENTS		JGM/FS		23/11/10		SCHEDULE NO.		OPERATION -	
						STORE		FUZE B-429	
								COMPT. 3-016910 DET NO. 2	