

618-21-59L

▽3(▽)

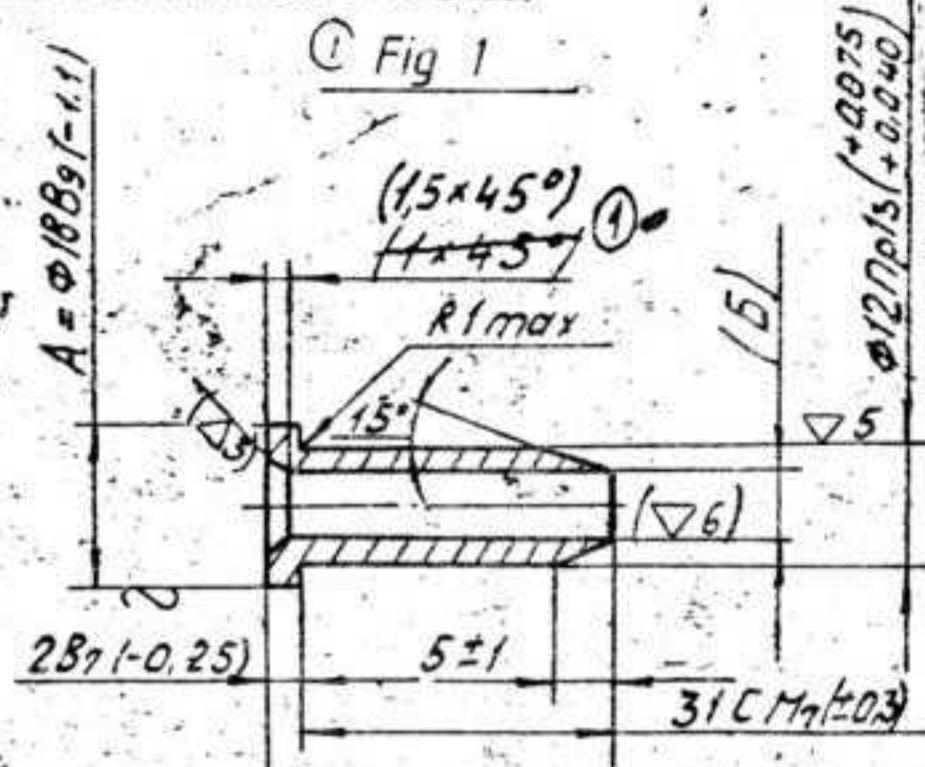
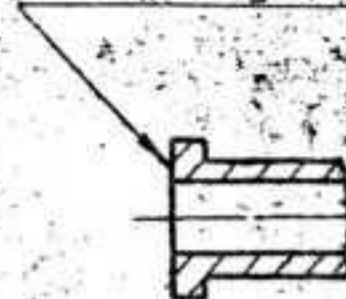


Fig 2
Other data Fig 1

Sharp edges



Designation.	Figure	/5/
765-71-819	Fig 1	(φ 8 A ₃ (+0.03))
-01	Fig 2	(φ 8.5 A ₅ (+0.2))

- Alternate material is Bronze Bp AMU 9-2 GOST 18175-78, in this case use φ17B₇-0.43 instead of dimension A, and Bronze BpAZH 9-4, GOST 18175-78.
- Dimensions and roughness of surfaces given in brackets are after assembly.

618-1L-59L

EXPLANATORY NOTES TO TECH. CONDITION.

BUSH SHOULD BE MANUFACTURED FROM TIN FREE PRESSURE WORKED ALUMINIUM BRONZE GRADE B_YAZHM TS 10-3-1-5 OR GRADE B_YAM TS 9-2 OR GRADE B_YAZH 9-4 CONFORMING TO GOST 18175-78 HAVING THE CHEMICAL COMPOSITION AS GIVEN IN TABLE BELOW

CHEMICAL COMPOSITION.

BASIC COMPONENT % (BY WEIGHT)	G R A D E S		
	B _Y AZHM TS 10-3-1-5	B _Y AM TS 9-2	B _Y AZH 9-4
ALUMINIUM	9.0 - 11.0	8.0 - 10.0	8.0 - 10.0
IRON	2.0 - 4.0	-	2.0 - 4.0
MANGANESE	1.0 - 2.0	1.5 - 2.5	-
COPPER	REST	REST	REST
IMPURITIES % (BY WEIGHT) MAX.			
TIN	0.1	0.1	0.1
SILICON	0.1	0.1	0.1
LEAD	0.03	0.03	0.01
PHOSPHORUS	0.1	0.01	0.01
IRON	-	0.5	-
ZINC	0.5	1.0	1.0
MANGANESE	-	-	0.5
TOTAL	0.7	1.5	1.7

NOTE :-

NICKEL UP TO 0.5% (PART BY WEIGHT) WITHOUT CONSIDERING IT IN TOTAL IMPURITIES, IS ALLOWED IN ABOVE GRADES OF BRONZE

SURFACE ROUGHNESS :-

▽3(▽) : REPRESENT THE SURFACE FINISH OF Ra VALUE OF 20MICRONS BY ANY PRODUCTION METHOD ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED

▽5 - SURFACE FINISH VALUE Ra - 5 MICRON.

▽6 - SURFACE FINISH VALUE Ra - 2.5 μ.

~ - SURFACE FINISH VALUE Ra - 80 μ.

765-71-819

BUSH

SHEET WEIGHT	SCALE
0.010	1:1
TOTAL SHEETS	

Brozne Bp AXM4 10-3-1-5
GOST 18175-78.

SNOISHT	DOC NO	SIGN	DATE
DRAWN	BHUSHAN		24.8.84
EDT, CHKD	S. S. NAIK		24.8.84
F/M, DC	S. R. NAIR		24.8.84
DIV. OFFR.	T. K. BANERJEE		31.8.84
	NAME	SIGN	DATE

INSCRIBED	
CHECK	<i>[Signature]</i>
APPROVED	<i>[Signature]</i>
DATE	31.7.86
TOLERANCE UNLESS OTHERWISE SPECIFIED	
DC (1)	DATE ZONE BRIEF RECORD SIGN. GEN DEC ANG

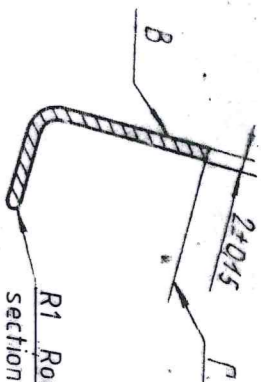
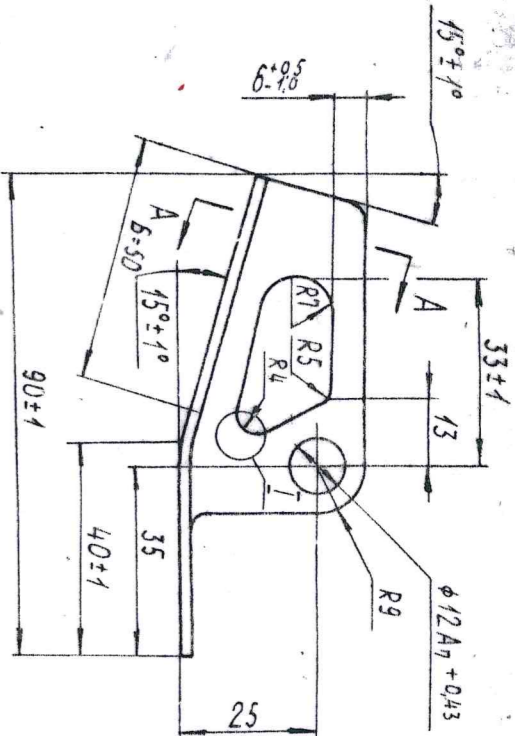
DRG NOT TO BE SCALED
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF
ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE SPECIFIED

BUSH

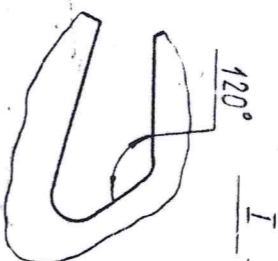
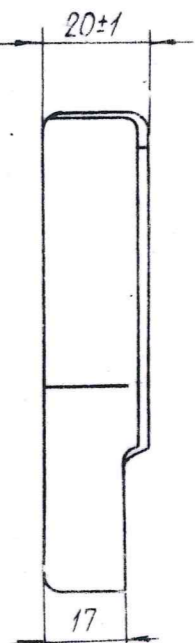
PERTAINS TO

765-71-819

SCALE
CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT. PUNE



1. Blunt sharp edges.
2. Make dimensions without deviations with an accuracy ±0.5.
3. Unspecified radii are R3.
4. Non-flatness of surface B should not exceed 0.5.
5. Incomplete cut is allowed followed by welding and dressing the welds.
6. To be heat treated, HB 302 to 255 (φ3.5 to 3.8).
7. On surface F contraction, bevels and chippings are not allowed. Machining of surface F is allowed.



SNOSHIDOC NO	SIGN	DATE
DRAWN CHVRAO	100%	26/7/84
EDICHO	As per spec	1.1.84
F/M D/C	S.R. NAIN	88
DIVDFR	T. K. BANERGE	80-1-1
NAME	SIGN	DATE

LEVER		SHEET/WEIGHT/SCALE
30X FCA FOCT 4543-71		004 1:1
ROYAL SHEETS ORDNANCE FACTORY PROJECT HYDERABAD		

765-71-820

15/11/86

028-12-592

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

LEVER SHOULD BE MANUFACTURED FROM STRUCTURAL CHROM. SILICON MANGANESE STEEL OF GRADE 30X FCA OF GOST 4543-71 AND HAVING THE FOLLOWING CHEMICAL COMPOSITION

CHEMICAL COMPOSITION		ELEMENT CONTENT %		IMPURITIES	
GRADE OF STEEL	CARBON	SILICON	MANGANESE	CHROMIUM	SULPHUR AND PHOSPHORUS
30X FCA	0.28-0.34	0.30-1.20	0.80-1.10	0.80-1.40	0.020MAX

MECHANICAL PROPERTIES OF STEEL GRADE 30X FCA AS PER GOST 4543-71

- 1) YIELD POINT 85 kgf/mm² (MIN)
- 2) TENSILE STRENGTH 110 kgf/mm² (MIN)
- 3) % ELONGATION 10
- 4) REDUCTION OF CROSS SECTIONAL AREA % 45 (MIN)
- 5) IMPACT STRENGTH 5 kg m/cm²
- 6) CROSS SECTIONAL DIMENSIONS 25 Sq. mm

- HEAT TREATMENT
- 1st HARDENING OR NORMALISING - 880°C
 - TEMPERING - 540°C
 - COOLING MEDIUM - WATER OR OIL.
 - SURFACE FINISH

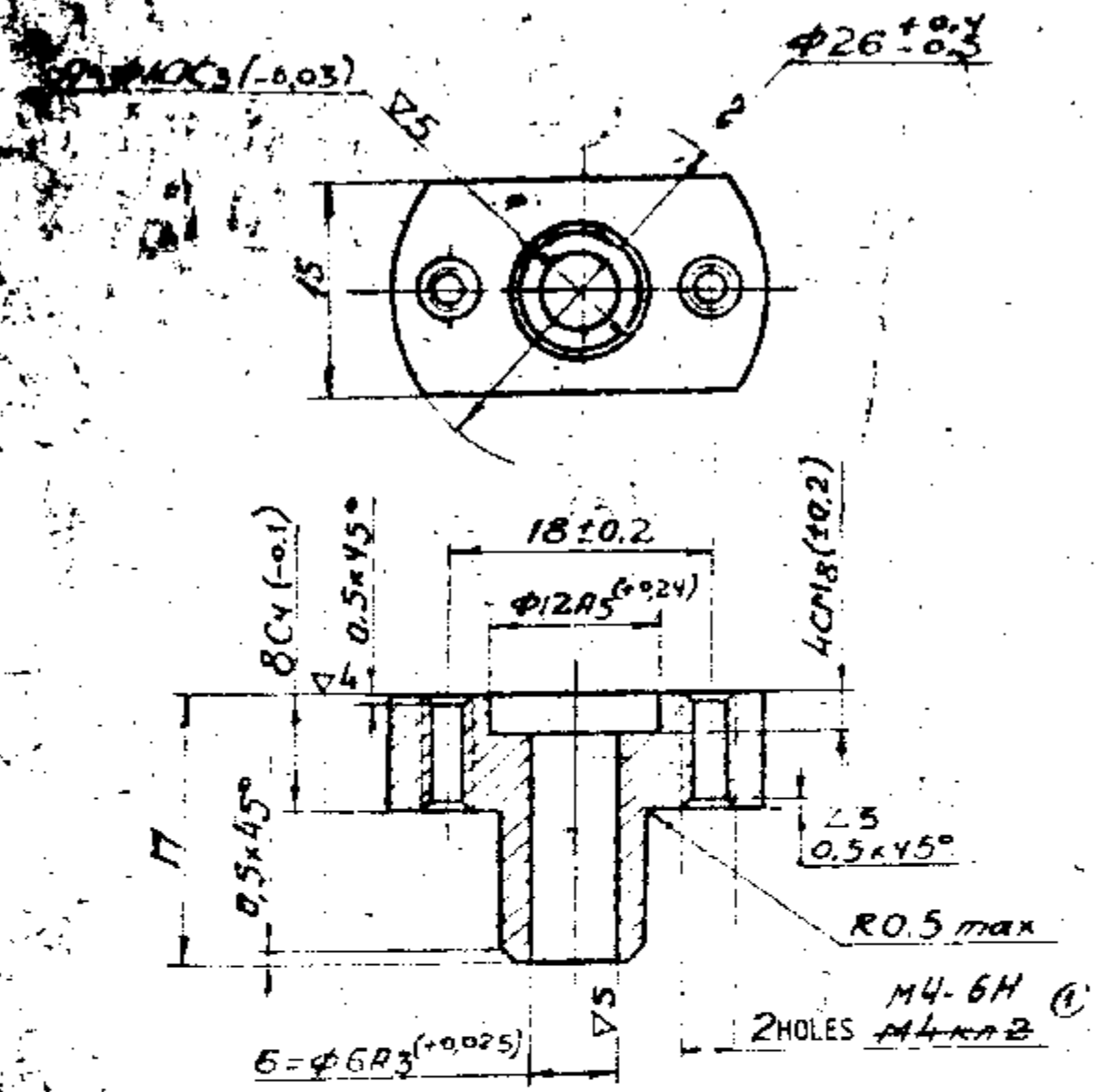
WHERE SURFACE FINISH IS NOT SPECIFIED

319
7/1/86

INScribed	DATE	BY	SCALE
CHECKED	DATE	BY	SCALE
APPROVED	DATE	BY	SCALE
LEVER			
765-71-820			

USED ON
765-71-25570 1 1

3
2



1. Unspecified limit deviations of dimensions are as follows: for holes as per A7, shafts as per B7, and others-as per CM7.
2. Run-out of surface A with respect to axis of surface B should not 0.05mm.

765-71-872

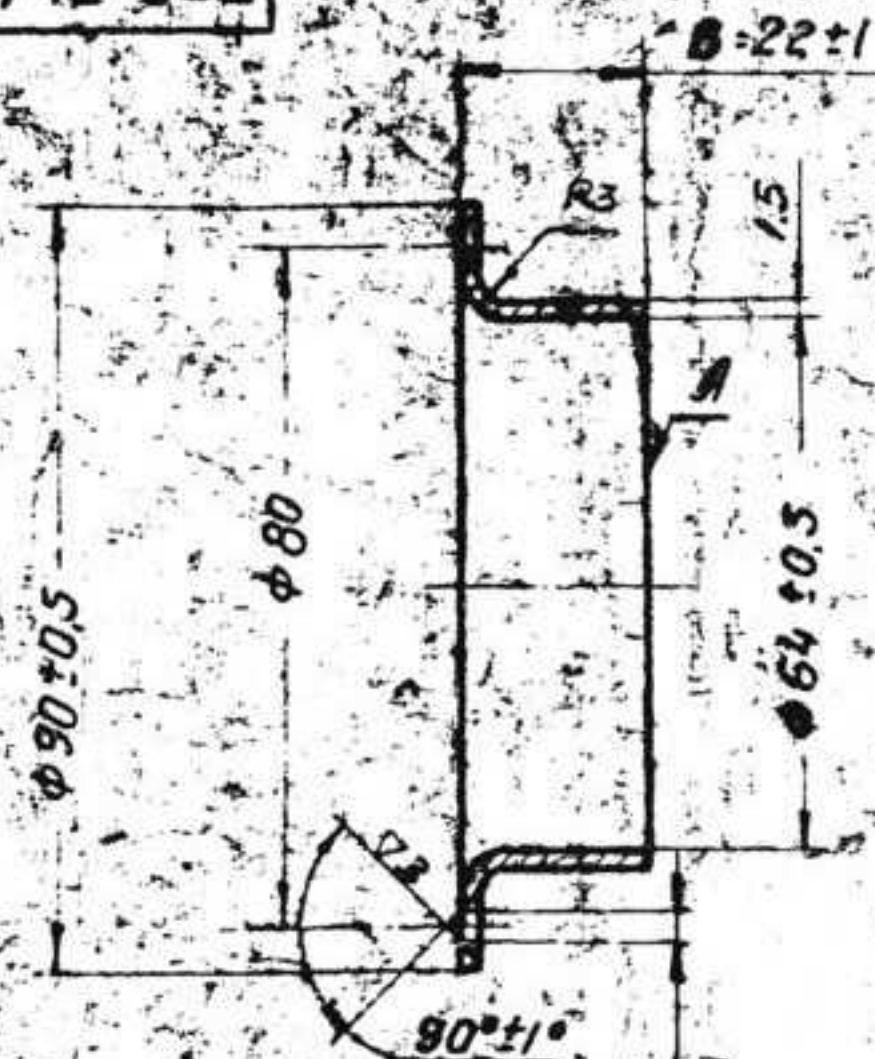
NO	DO	NO	SIGN	DATE
DRAWN	V.J.RAO			22.8.84
EDT & CHKD	W. S. S. S.			
F/M, DC	S.R. NAIR			22.8.84
DIV. OFFR	T.K. BANERJEE			21.8.84
	NAME	SIGN	DATE	

CARRIER
45 OCT 1050-74

SHEET	WEIGHT	SCALE
1	0.025	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

Unless otherwise specified.

6801-11-591



- Burrs are not allowed.
- Displacement of axes of hole from true position should not exceed 0.2 mm.
- Coating: Anodic oxidization; chromated.
- Surface ruptures to a depth not exceeding 2 mm are allowed on butt-end A.
- Thinning of metal upto 1 mm min. is allowed over section B.

6 Holes $\phi 5A7 \pm 0.3$
Equally spaced along
circumference.

S/NO	SHEET	DOC NO	SIGN	DATE
DRAWN BY	CH.V.RAO			26.7.84
EDITED AND CHECKED BY				27.7.84
FOREMAN OF DC	S.R.NAIN			26.7.84
DIVISIONAL OFFICER	T.K. BANERJEE			18.8.84
	NAME	SIGN	DATE	

FLANGE
765-71-1089
SHEET AMUM-1.5,
GOCT 21631-76.

SHEETS	WEIGHT	SCALE
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

6801-11-591

EXPLANATORY NOTES TO TECH CONDITIONS

FLANGE SHOULD BE MANUFACTURED FROM ALUMINIUM ALLOY SHEET 1.5 mm THICK, GRADE AMTS, ANNEALED(M) WITH NORMAL SURFACE FINISH AND NORMAL MANUFACTURING ACCURACY, HAVING CHEMICAL COMPOSITION CONFORMING TO GOST - 4784 - 74 (AS REFERRED IN GOST - 21631-76).

I) CHEMICAL COMPOSITION :-

GRADE	ALLOYING CONSTITUENTS%				IMPURITIES, % (max)						
	ALUMINIUM	MAGNASIUM	MANGANESE	IRON	SILICON	COPPER	ZINC	TITANIUM	MAGNASIUM	OTHER IMPURITIES	
AMTS	BASE CONSTITUENT	-	1.0 - 1.6	0.7	0.6	0.15	0.10	0.20	0.2	EACH INDIVIDUALLY	TOTAL
										0.05	0.10

II) MECHANICAL PROPERTIES (GOST - 21631-76)

- i) MATERIAL CONDITION — ANNEALED
- ii) TENSILE STRENGTH, kgf/mm² (min) — 9.0
- iii) YIELD POINT, kgf/mm² (min) — —
- iv) PERCENTAGE ELONGATION, (min) — 22.0

III) TOLERANCE ON SHEET THICKNESS :-

THICKNESS :- 1.5 mm, TOLERANCE :- -0.20 mm

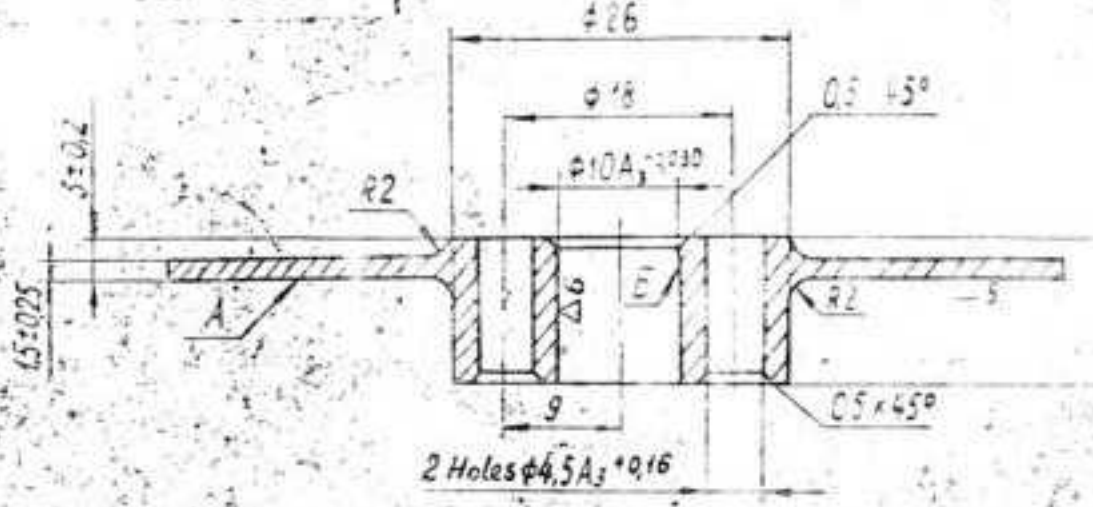
IV) SURFACE FINISH :-

▽3 :- INDICATES SURFACE FINISH TO BE OBTAINED BY ANY PRODUCTION METHOD IN Ra VALUE 20µ max.

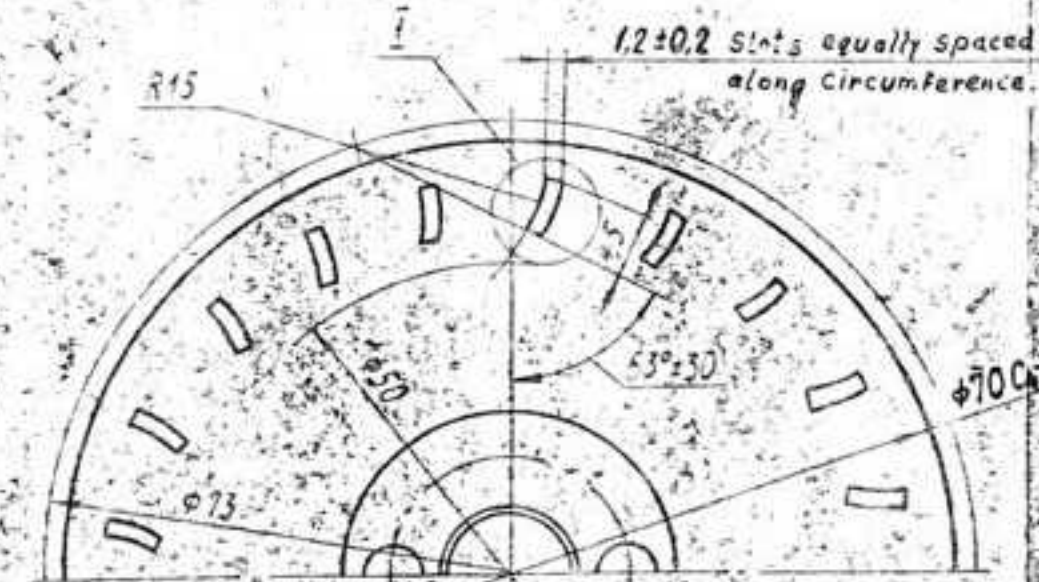
~ :- INDICATES SURFACE ROUGHNESS IN Ra VALUE NOT EXCEED TO 80µ max.

DC(i)	DATE	ZONE	BRIEF RECORD	SIGN	GEN	ANG	DEC																										
<table border="1"> <tr> <td>INSCRIBED</td> <td><i>[Signature]</i></td> <td>DRG NOT TO BE SCALED</td> <td rowspan="2">PERTAINS TO</td> </tr> <tr> <td>CHECKED</td> <td><i>[Signature]</i></td> <td>ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.</td> </tr> <tr> <td>APPROVED</td> <td><i>[Signature]</i></td> <td>ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED</td> <td rowspan="2">765-71-1089</td> </tr> <tr> <td>DATE</td> <td>26.07.84</td> <td></td> </tr> <tr> <td colspan="2">TOLERANCE UNLESS OTHERWISE SPECIFIED</td> <td>FLANGE</td> <td></td> </tr> <tr> <td colspan="2">SCALE :-</td> <td></td> <td></td> </tr> <tr> <td colspan="4">CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT, PUNE</td> </tr> </table>								INSCRIBED	<i>[Signature]</i>	DRG NOT TO BE SCALED	PERTAINS TO	CHECKED	<i>[Signature]</i>	ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.	APPROVED	<i>[Signature]</i>	ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED	765-71-1089	DATE	26.07.84		TOLERANCE UNLESS OTHERWISE SPECIFIED		FLANGE		SCALE :-				CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT, PUNE			
INSCRIBED	<i>[Signature]</i>	DRG NOT TO BE SCALED	PERTAINS TO																														
CHECKED	<i>[Signature]</i>	ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.																															
APPROVED	<i>[Signature]</i>	ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED	765-71-1089																														
DATE	26.07.84																																
TOLERANCE UNLESS OTHERWISE SPECIFIED		FLANGE																															
SCALE :-																																	
CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT, PUNE																																	

0501-11-591



- Unless otherwise specified:
- 1) Blunt sharp edges.
 - 2) Provide dimensions without deviations as per accuracy class 7 (IST 1010).
 - 3) Displacement of slots and axes of holes from true position should not exceed 0.3 mm.
 - 4) Run-out of surface A with respect to axis of surface B should not exceed 0.5 mm.
 - 5) Slots may be made as per conventional dotted line.
 - 6) Coating: Anodic oxidation, chromating.
 - 7) Alternate material is D 16, D 20, GOST 4784-74.



$\phi 70 \pm 0.02$ Machine in assembly.

SN/CHG	DOC NO	SIGN	DATE
DRAWN	Y.R. Ganesh	[Signature]	23.8.84
EDT/CHKD	[Signature]	[Signature]	20.10.84
F/M, DC	S.R. NAIR	[Signature]	24.9.84
DIV OFFR	T.F. BANERJEE	[Signature]	1.9.84
	NAME	SIGN	DATE

765-71-1090

FLANGE

SHEET WEIGHT SCALE
005 1:2:1

TOTAL SHEETS

AMG 6 GOST 4784-74

0601-11-591

EXPLANATORY NOTES TO TECHNICAL CONDITIONS:

FLANGE SHOULD BE MANUFACTURED FROM ALUMINIUM ALLOY SHEET OF GRADE AMg6 OR GRADE D-16 CONFORMING TO GOST 4784-74.

I CHEMICAL COMPOSITION:

GRADE	ALLOYING CONSTITUENTS %						IMPURITIES % (MAX)							
	ALUMINIUM	COPPER	MAGNESIUM	MANGANESE	TITANIUM	BARIUM	IRON	SILICON	COPPER	ZINC	NICKEL	TITANIUM	OTHER IMPURITIES	
													EACH INDIVIDUALLY	TOTAL
AMg6	BASE CONSTITUENT	-	5.8-6.8	0.5-0.8	0.02-0.10	0.0002-0.005	0.4	0.4	0.1	0.2	-	-	0.05	0.1
D-16	BASE CONSTITUENT	3.8-4.9	12-1.8	0.3-0.9	-	-	0.5	0.5	-	0.3	0.1	0.1	0.05	0.1

II LIMIT DEVIATIONS AS PER ACCURACY CLASS 7 (REF. NOTE NO. 2)

DIMENSION	DEVIATION (mm)
$\phi 16$	+0.430 0.0
$\phi 26$	+0.520 0.0
$\phi 50$	+0.620 0.0
$\phi 73$	+0.740 0.0

III SURFACE FINISH:

$\nabla 3$ - INDICATES SURFACE FINISH IN R_a VALUE 20 μ , ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.

$\nabla 5, \nabla 6$ - INDICATES SURFACE FINISH IN R_a VALUE 5 AND 2.5 μ RESPECTIVELY.

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	[Signature]	[Signature]	[Signature]				

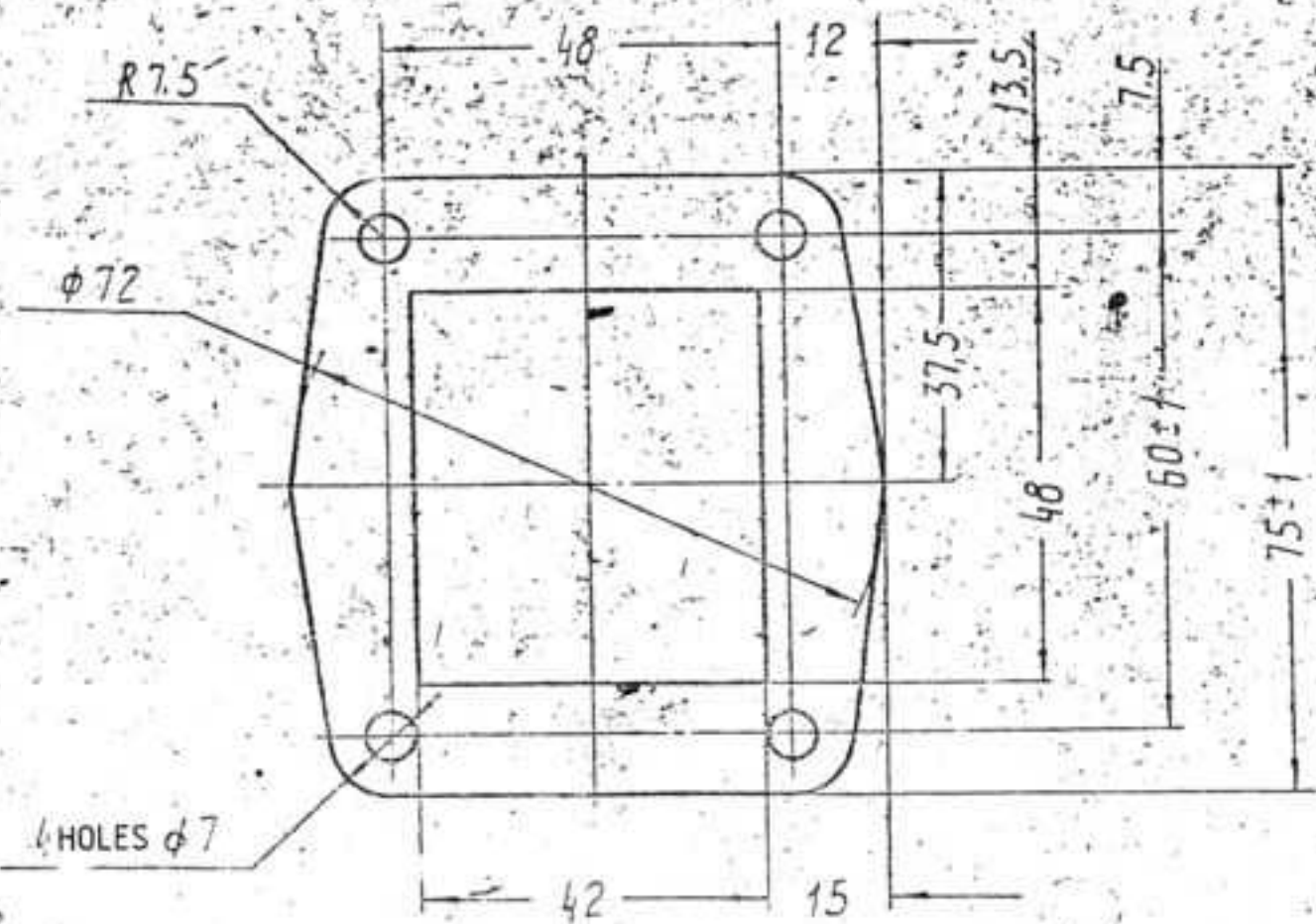
DRG. NOT TO BE SCALED
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.
ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED.

FLANGE

765-71-1090

CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT. PUNE.

Easy2Convert
www.easy2convert.com



Thickness 3 ± 0.5

1. Alternate material is rubber 632, Ty 005216-75.
2. Rest of requirements are as per technical specification Ty 005216-75 for the item of code 254311.

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

1. GASKET SHOULD BE MANUFACTURED FROM NEOPRENE RUBBER GRADE OF 637 OR 632 TO Ty-005216-75

PHYSICAL, MECHANICAL, TECHNOLOGICAL PROPERTIES OF RUBBER GIVEN AS BELOW:-

- 1) TYPE OF RAW RUBBER — CKMC - 30
APKM - 15
- 2) MODE OF VULCANIZATION — ① TEMP. - 143 ± 3
& THERMO STATING. ② TIME - 40 MIN.
- 3) ULTIMATE TENSILE STRENGTH — 45 Kg/cm^2
DURING BREAKAGE MINIMUM.
- 4) RELATIVE ELONGATION — 250 % MINIMUM.
DURING BREAKAGE
- 5) RELATIVE RESIDUAL ELONGATION — 35 % MAXIMUM.
AFTER BREAKAGE.
- 6) SHORE HARDNESS — 45 - 65.
- 7) HEAT AGEING IN AIR — ① TEMP. - 70°C
② TIME. - 96 Hrs.
③ AGEING CO-EFFICIENT - 0.70%
AS PER RELATIVE ELONGATION. (MIN)
- 8) CO-EFFICIENT OF ACID- — ① 20% SOLUTION-0.75% MIN.
ALKALI RESISTANCE FOR
24 Hrs. AT ATEMP. OF $15-25^\circ\text{C}$
AS PER STRENGTH. ② 20% NaOH OR KOH SOLUTION
0.75% MIN.
- 9) DENSITY (WITH LIMIT DEVIATION OF ± 0.05) — 1.35 g/cm^3

254311 - ROLLED TECHNICAL PLATES WITHOUT CLOTH LINERS

ALTERNATE MATERIAL :-

PHYSICAL MECHANICAL PROPERTIES OF RUBBER GRADE -632

- 1) TYPE OF RAW RUBBER — NAIRIT CKMC -30 APKM -15
- 2) RUPTURE STRENGTH AT LEAST Kg/cm^2 — 50
- 3) ELONGATION AT RUPTURE AT LEAST % — 300
- 4) PERMANENT ELONGATION AFTER RUPTURE % MAX. — 40
- 5) HARDNESS ~~AS PER DEVICE~~ SHORE ~~AS PER DEVICE~~ — 45 - 65
- 6) CO-EFFICIENT OF THERMAL AGEING IN AIR.
 - a) TEMP. 0°C — 70
 - b) PERIOD, HOUR — 96
 - c) AS PER ELONGATION AT LEAST — 0.60
- 7) VARIATION IN MASS UNDER THE INFLUENCE OF MEDIUM % MAX.
 - a) RUBBER SOLVENT, KALOSHA - 95 P/W + BENZENE - 5 P/W } 30.0
AT ATEMP. $15-25^\circ\text{C}$ FOR 24 Hrs.
 - b) OIL MT - 16 IT AT TEMP. 70°C FOR 24 Hrs. — ACTUAL
- 8) DENSITY g/cm^3 — 1.35

SN	SHT	DOC NO	SIGN	DATE

GASKET

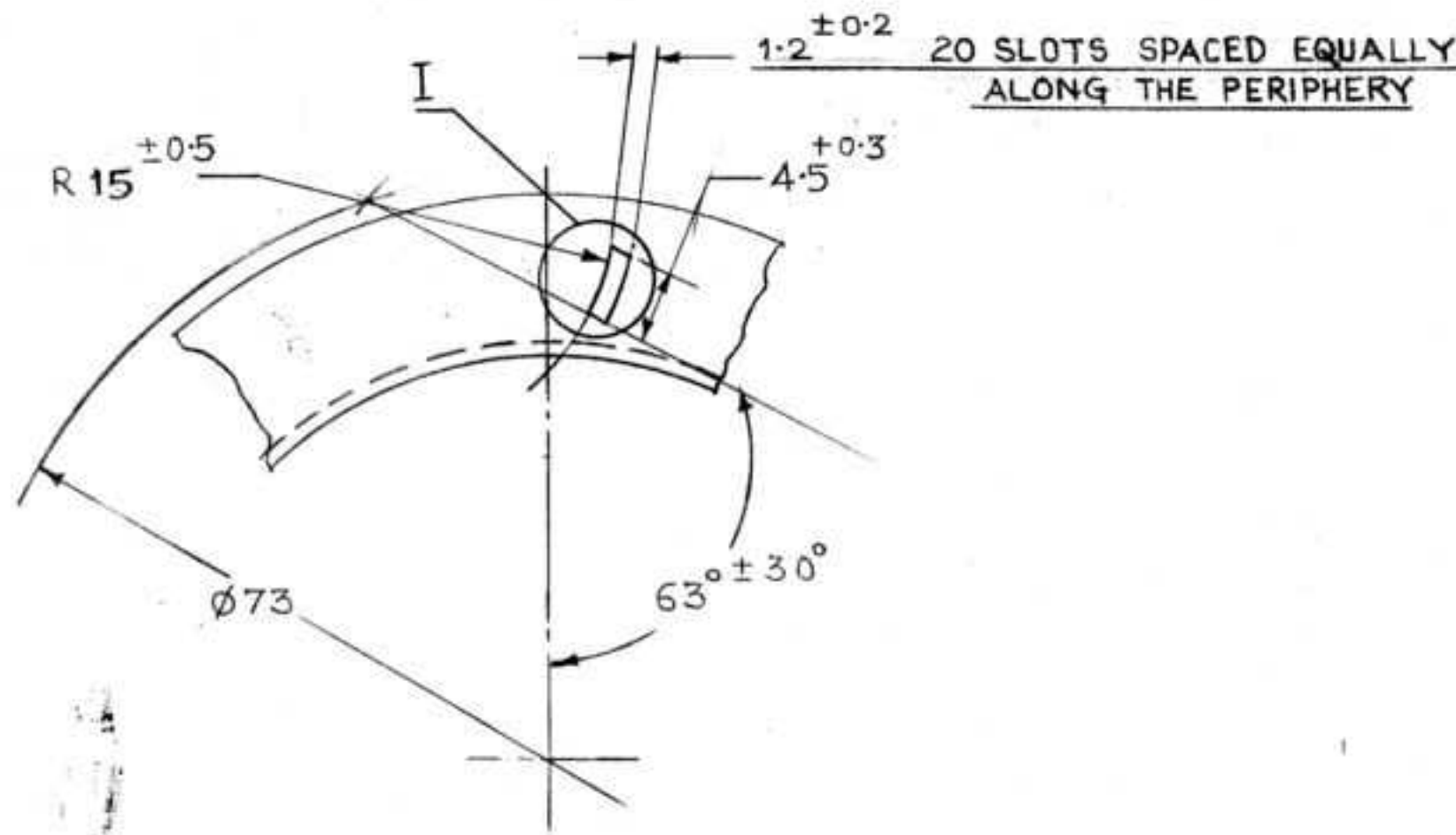
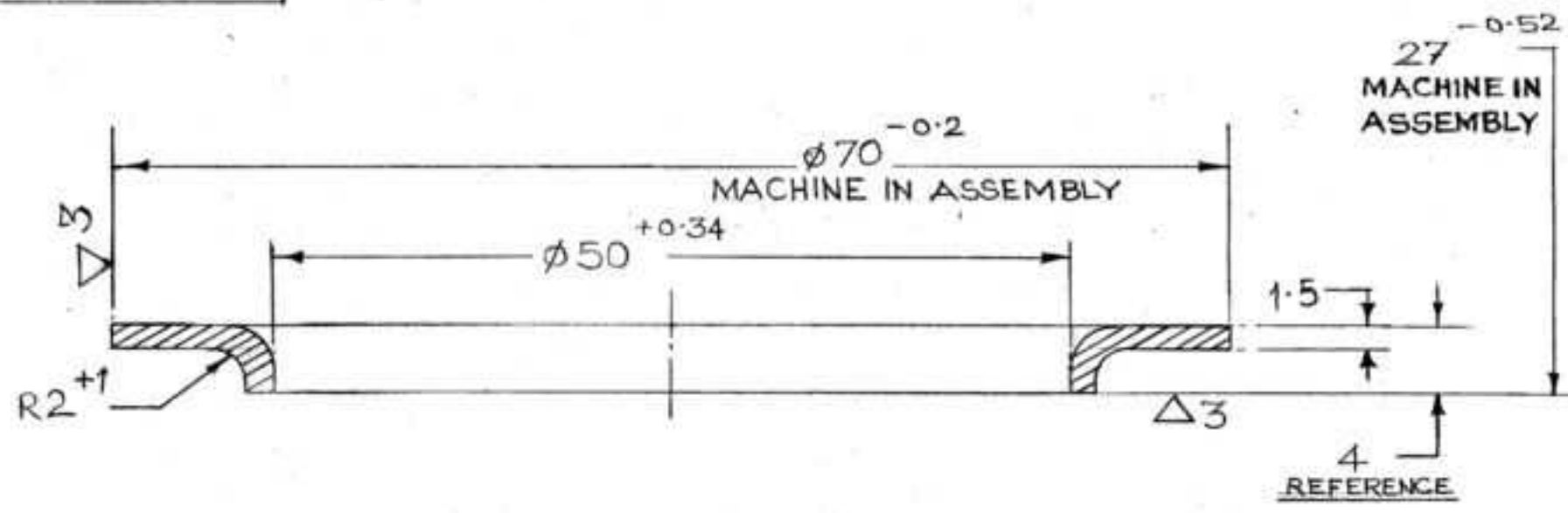
Plate 254311-3
Rubber 637 Ty 005216-7

SHEET	WEIGHT	SCALE
	0.035	1:1
TOTAL SHEETS		

INScribed	CHECKED <i>Kul</i>	APPROVED <i>Jhu</i>	DATE 25.11.06	DRG. NOT TO BE SCALED			PERTAINS TO
				ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.			
				ALL DIMENSIONS ARE IN MM. UNLESS OTHERWISE SPECIFIED.			
				GASKET			
TOLERANCE UNLESS OTHERWISE SPECIFIED.				765-71-1429			
GEN. DEC. ANG.				SCALE:			
CONTROLLERATE OF INSPECTION FIRE FIGHTING. EQPT. PUNE.							

765-71-1446

UNLESS OTHERWISE SPECIFIED.



I
SCALE-5:1

MATL- SHEET AMF-6 5M-1.5 GOST-21631-76

- 1) REMOVE SHARP EDGES.
- 2) DEVIATION OF SLOTS FROM TRUE POSITION IS 0.5 MAXIMUM.
- 3) PART MAY BE MADE AS PER CONVENTIONAL DOTTED LINE.
- 4) TYPE OF COATING — ANODIC OXIDISATION, CHROMATISATION.

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

RING SHOULD BE FABRICATED FROM CLADDED (B) & ANNEALD (M) ALUMINIUM ALLOY SHEET 1.5mm THICK WITH NORMAL FINISH & NORMAL ACCURACY OF GRADE AMg6 HAVING COMPOSITIONS AS PER DRG No 675-71-354 AND MECHANICAL PROPERTIES AS PER GOST 21631-36.

CHEMICAL COMPOSITIONS OF CLADDING MATERIAL

GRADE	ALLOY ELEMENTS	CHEMICAL COMPOSITIONS OF CLADDING MATERIAL %								SUM OF TOTAL PERMISSIBLE ADMIXTURE
		ADMIXTURE (max)								
	AL	Fe	Si	Cu	Mn	Zn	Ti	Mg	OTHER ADMIXTURE	
AMg6	99.30 (min)	0.30	0.30	0.02	0.025	0.1	0.15	0.05	0.02	0.70

MECHANICAL PROPERTIES

TENSILE STRENGTH — 32.0 kgf/mm²(min)

YIELD POINT — 16.0 kgf/mm² (min)

ELONGATION % — 15.0 (min)

THICKNESS OF TECHNOLOGICAL CLADDING LAYER FOR SHEETS FROM ALLOY AMg6 SHOULD BE ON EACH SIDE OF SHEET NOT MORE THAN 1.5 % FROM NORMAL SHEET THICKNESS.

TOLERANCE ON SHEET THICKNESS SHOULD BE -0.15mm.

SURFACE FINISH

▽3 — REPRESENTS SURFACE FINISH TO BE OBTAINED OF Ra VALUE IN 20.4 (MAX)

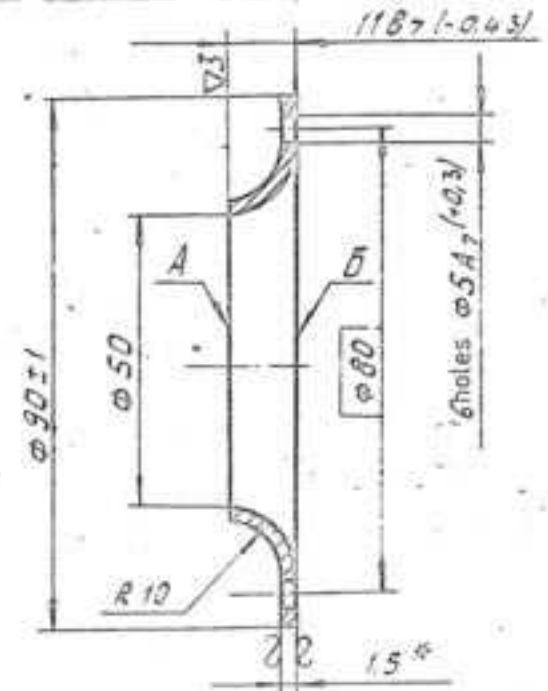
∞ — REPRESENTS SURFACE FINISH TO BE OBTAINED OF Ra VALUE IN 80.4 ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.

DRN	sd	DRG NOT TO BE SCACED.	PERTAINS TO
TCD	-	ALL SHARP EDGES AND CORNERS TO BE ROUNDED OFF	
CHKD	sd	ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED	
PSD	-		
APPD	sd	RING SCALE-2:1 C Q A F E, AUNDH CAMP, PUNE-27	765-71-1446
DATE	16 OCT 86		
DC(I)	DATE ZONE	BRIEF RECORD	SIGN

1664

AUTHENTICATION	TCD	CHD	PSD	DATE	DRG BASED ON	W/O No CQAFE/FPS
	BLR			26-7		Misc dt 03 Dec

765-71-1507



1. Alternate material is AMg2, GOST 4784-74.
2. Unspecified limit deviations of dimensions are ±0.5mm.
3. Displacement of axis of hole from true position should not exceed 0.2mm.
4. Nonflatness of surfaces A and B should not exceed 0.4mm.
5. Nonparallelism of surfaces A and B should not exceed 0.4mm over length 90.
6. Type of coating: Anodic oxidation, chromating.
7. Dimensions with (*) is for reference.

765-71-1507	FLANGE		SHEET WEIGHT SCALE
0.022	1:1	TOTAL SHEETS	
Sheet AMUM-15	GOST 21631-76		
NAME	SIGN	DATE	

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

I) FLANGE SHOULD BE MANUFACTURED FROM ALUMINIUM ALLOY SHEET 1.5 mm THICKNESS, GRADE AM15, ANNEALED, WITH NORMAL SURFACE FINISH AND NORMAL MANUFACTURING ACCURACY, HAVING CHEMICAL COMPOSITION CONFORMING TO GOST-4248-74 (AS REFERRED IN GOST-21631-76) AS FOLLOWS :-
 ALTERNATE MATERIAL :- ALTERNATIVELY ALUMINIUM ALLOY SHEET OF GRADE AMg2, CAN ALSO BE USED. CHEMICAL COMPOSITION AS PER GOST-4784-74 IS AS GIVEN BELOW
 CHEMICAL COMPOSITION

GRADE	ALLOYING CONSTITUENTS %			IMPURITIES % MAXIMUM						OTHER IMPURITIES	
	ALUMINIUM	MAGNESIUM	MANGANESE	IRON	SILICON	COPPER	ZINC	TITANIUM		EACH INDIVIDUALLY	TOTAL
AM15	BASE CONSTITUENTS		1.0 - 1.6	0.7	0.6	0.15	0.10	0.20	MAGNESIUM 0.2	0.05	0.10
AMg2	- DO -	2.0 - 2.7	0.2 - 0.6	0.4	0.4	0.10	0.20	0.10	CHROMIUM 0.05	0.05	0.10

II) MECHANICAL

II) MECHANICAL PROPERTIES (GOST-21631-76)

I) MATERIAL CONDITION	AM15 M	AMg2
	ANNEALED	WITHOUT HEAT TREATMENT
II) TENSILE STRENGTH Kg/mm ² (min)	9.0	18.0
III) YIELD POINT Kg/mm ² (min)	-	-
IV) PERCENTAGE ELONGATION (min)	22.0	7.0

III) TOLERANCE ON SHEET THICKNESS

THICKNESS	TOLERANCE
1.5 mm	-0.20 mm

IV) SYMBOLS

∅80 ON DIMENSIONS SHOWN IN RECTANGLES, TOLERANCES ARE NOT SPECIFIED BUT THESE ARE NOT "FREE DIMENSIONS"

V) SURFACE FINISH

- ▽3 - INDICATES SURFACE FINISH TO BE OBTAINED BY ANY PRODUCTION METHOD OF Ra VALUE 20 MICRONS (MAX)
- ~ - INDICATES SURFACE ROUGHNESS IN Ra VALUE, NOT TO EXCEED 80 MICRONS.
- ▽(▽) - INDICATES SURFACE FINISH TO BE OBTAINED WITHOUT REMOVAL OF MATERIAL ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED

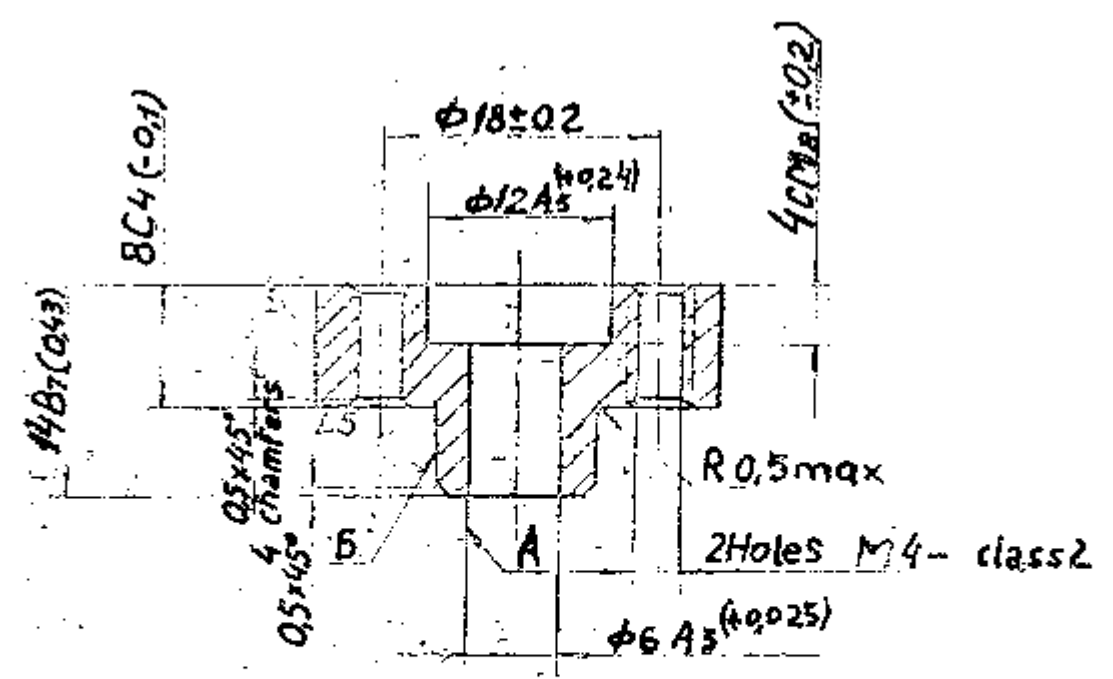
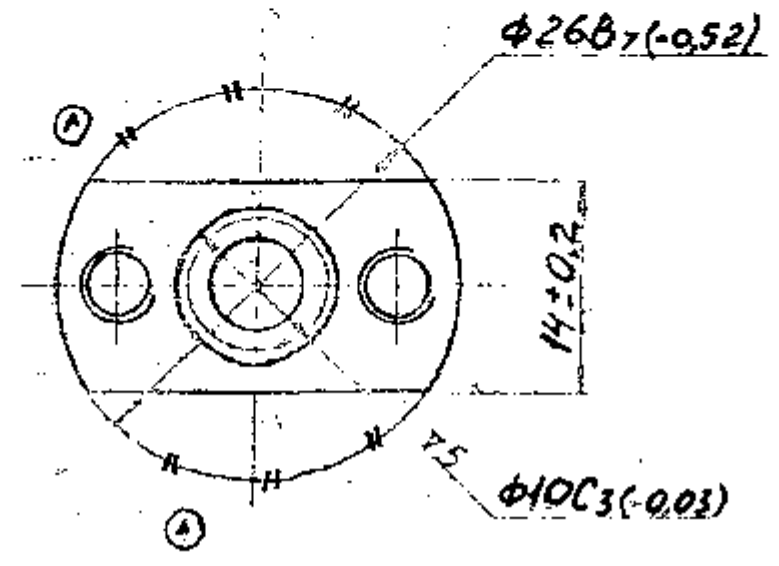
INSCRIBED		DRG NOT TO BE SCALED	RETAINS TO:-
CHECKED	<i>King</i>	ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.	
APPROVED	<i>Am</i>	ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE SPECIFIED	765-71-1507
DATE	<i>16/01/86</i>		
TOLERANCE UNLESS OTHERWISE SPECIFIED	GEN DEC ANG	FLANGE	SCALE:-
D.C.U)	DATE	ZONE	BRIEF RECORD
SIGN			
CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT PUNE			

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33 (A)
136/11

- 1) Alternate material is steel 40 GOST 1050-74.
- 2) Radial run-out of surface B with respect to surface A, should not exceed 0.05 mm.



DATE	ISSUE	NATURE OF AMENDMENT
07 DEC 90	1	FULL CIRCLE $\phi 26$ IS DELETED AND AN ARC FOR $\phi 26$ DIMENSION IS SHOWN.

MATERIAL :- STEEL 45 GOST 1050-74		
ALL SHARP EDGES & CORNERS TO BE BOUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OF ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFG.
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-
SCALE :- 2:1		
DATE :- 14-11-95		
DRN. [Signature]	WY :- (Kg) 0.025	DOG 765-71-1524
TCO. [Signature]		
CHD. [Signature]		
APD. [Signature]		

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)