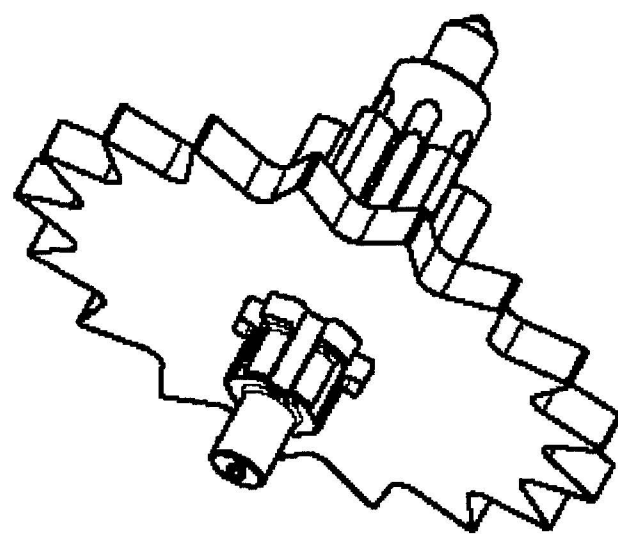
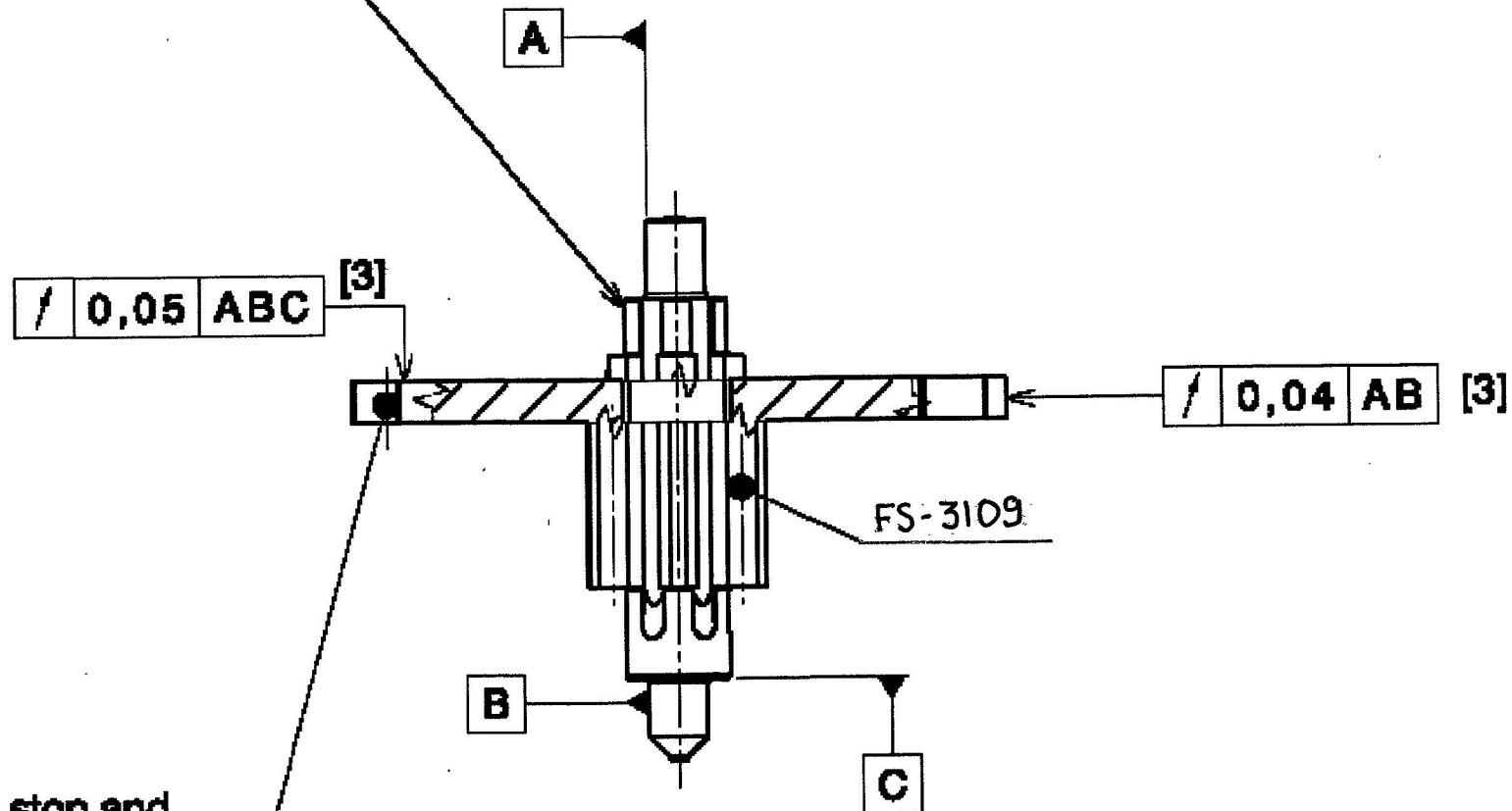


Riveted marking FS-3108 endures an axial load of  $\geq 137N$  [3]



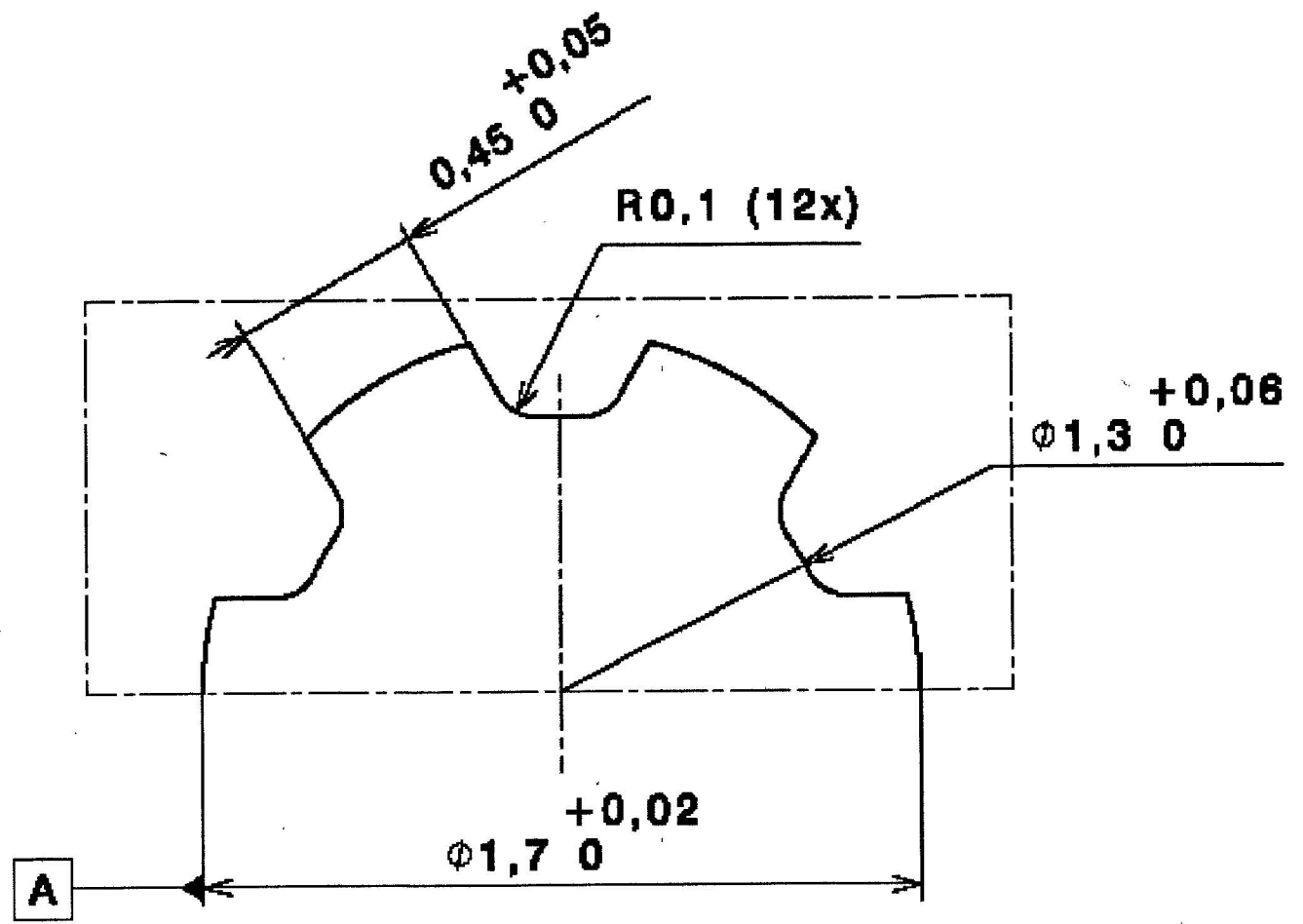
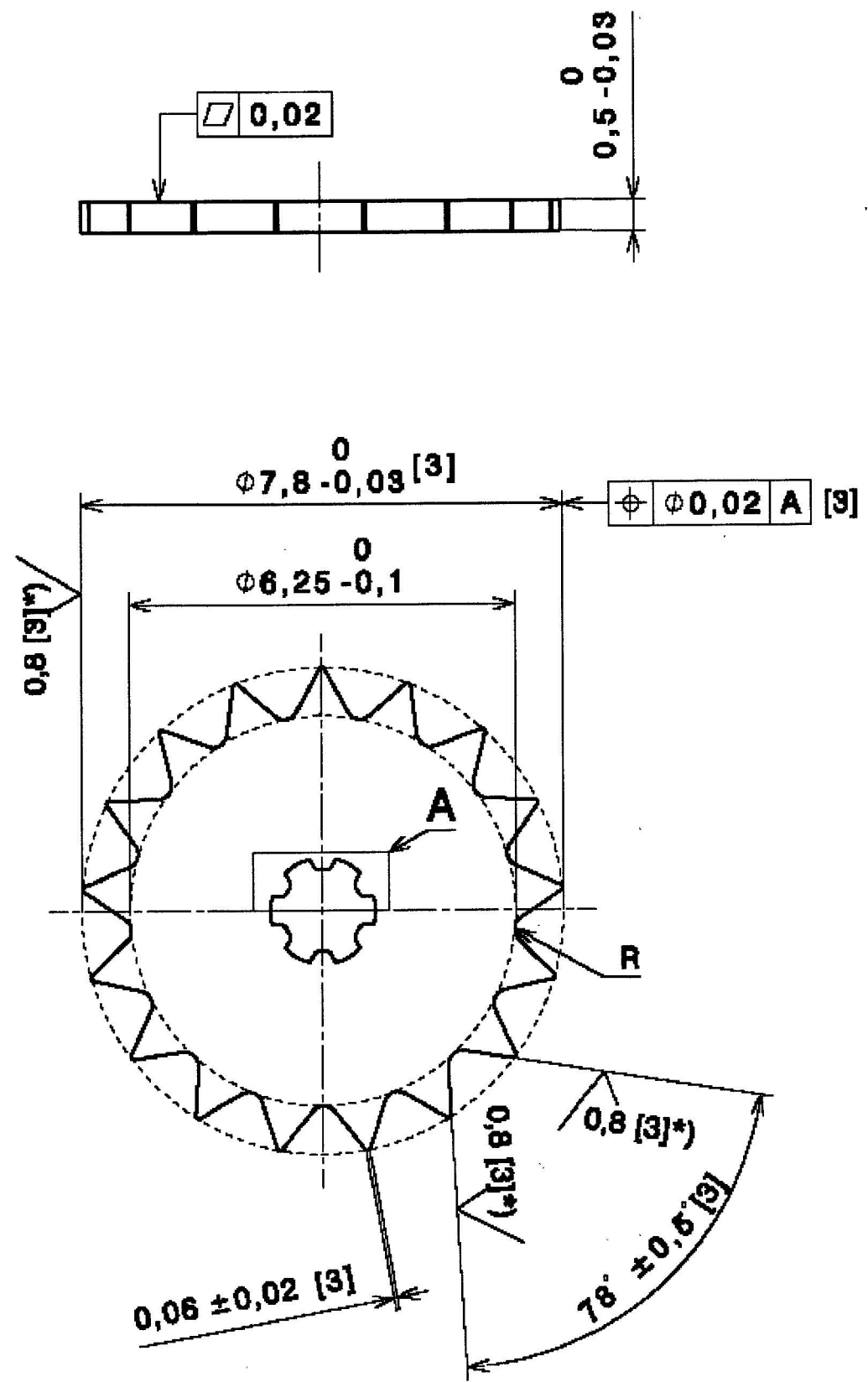
Isometric view

Riveting well performed and Centre wheels pressed against stop and with bevelled edge towards stop surface. [2] Visual inspection



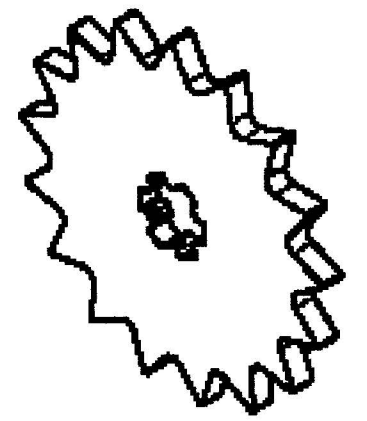
FORM & POS TOL ACC. TO ISO 1101  
FREE FROM BURRES

			DIMENSIONS ARE IN mm.			MATERIAL:-	ORDNANCE FACTORY AMBAJHARI
			FIRST ANGLE PROJECTION				
			SCALE - NTS			ESCAPE WHEEL, ASSEMBLY	DRG. NO :
			2020	NAME	DATE		NO OF SHEETS- 1
			DRAWN	<i>Kush</i>	30.12.20	REVIEW NO: 01	
			CHECKED	ललित गौरी	30.12.20	SHEET NO-	1
			HOS/CDD	<i>[Signature]</i>	31/12	NO OF SHEETS-	1
			APPROVED BY	JWM/FS	<i>[Signature]</i>	COMPT.	
				HOS/FS			
				WM/FS	<i>[Signature]</i>		
			AMENDMENTS				



Detail A

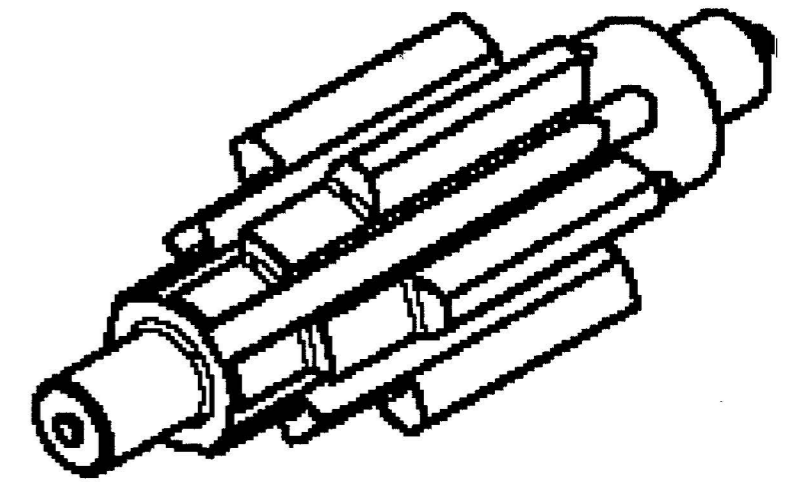
6 LANDS, EVEN SPACING  
 z = 17 TEETH  
 FREE FROM BURRS [3]  
 HARD. AND TEMPD.  
 TO HV 430-550



Isometric view

- 1) SAMPLE SIZE ACCORDING TO SPECIAL CASES.
  - 2) EVEN AND FLAT - VISUAL INSPECTION.
- COAT THICKNESS - SAMPLE SIZE : 2/1000 pcs.  
 SURFACE TREATMENT- NICKEL PLATED 2-3 μm [3]\*\*  
 GENERAL SURFACE ROUGHNESS- Ra 1.6  
 SHARP EDGES BROKEN- 0.1MAX.  
 FORM & POS TOL. ACC. TO- ISO 1101.  
 GENERAL TOLERANCE- ISO 2768-fH

DIMENSIONS ARE IN mm.			MATERIAL- STEEL SS-EN 10132-4 1.1274+QT [2]		ORDNANCE FACTORY AMBAJHARI आर्डनैन्स फैक्टरी अम्बाझरी
FIRST ANGLE PROJECTION			NOMENCLATURE		
SCALE - NTS			ESCAPE WHEEL		DRG. NO : FS-3108
2020	NAME	DATE			REVIEW NO: 01
DRAWN	Laidrepi	03.10.20			SHEET NO- 1
CHECKED	BL	4/11/20			NO OF SHEETS- 1
HOS/CDD	[Signature]	4/11/20			COMPT.
APPROVED BY	JWM/FS	[Signature]	M/C:		
BY	JWM/FS	[Signature]	STORE:		
NOMENCLATURE			SIGN.		
AMENDMENTS					



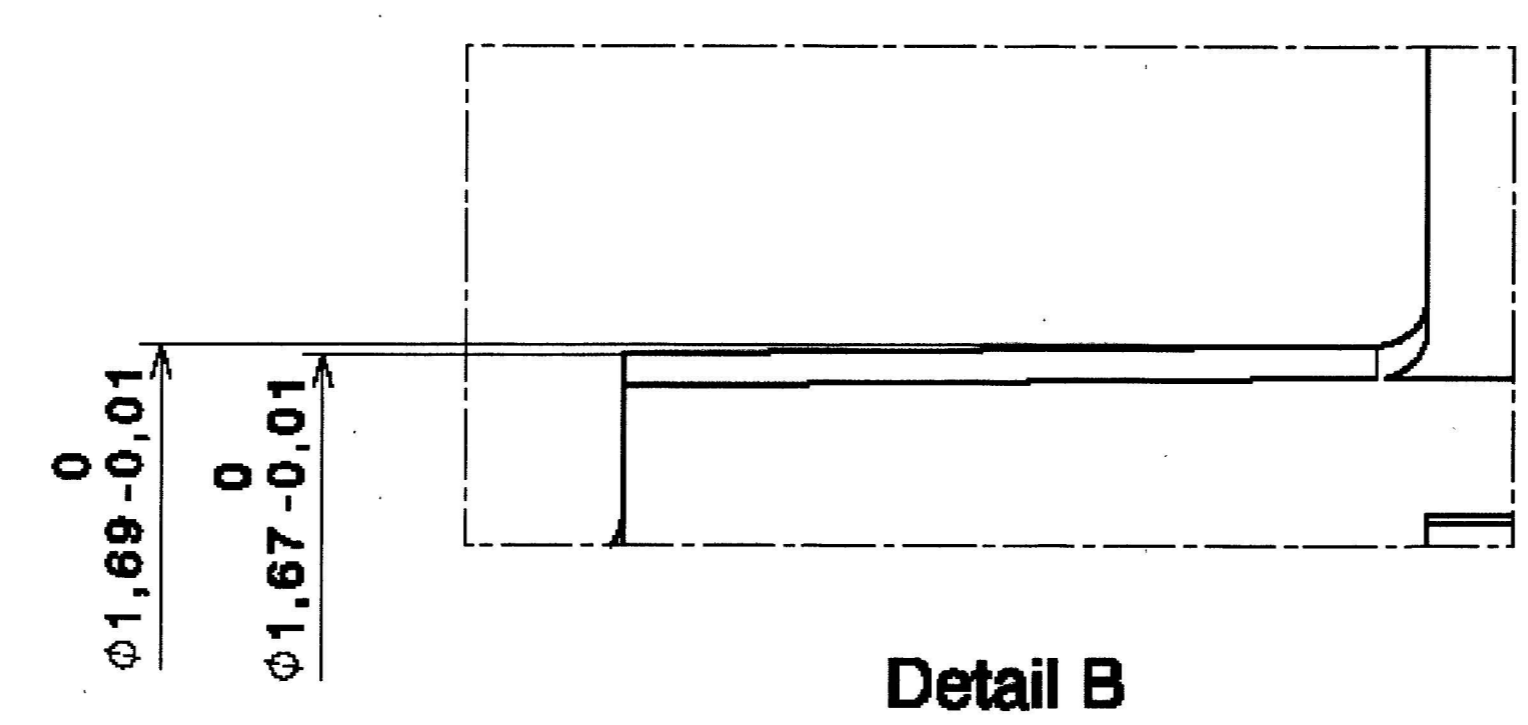
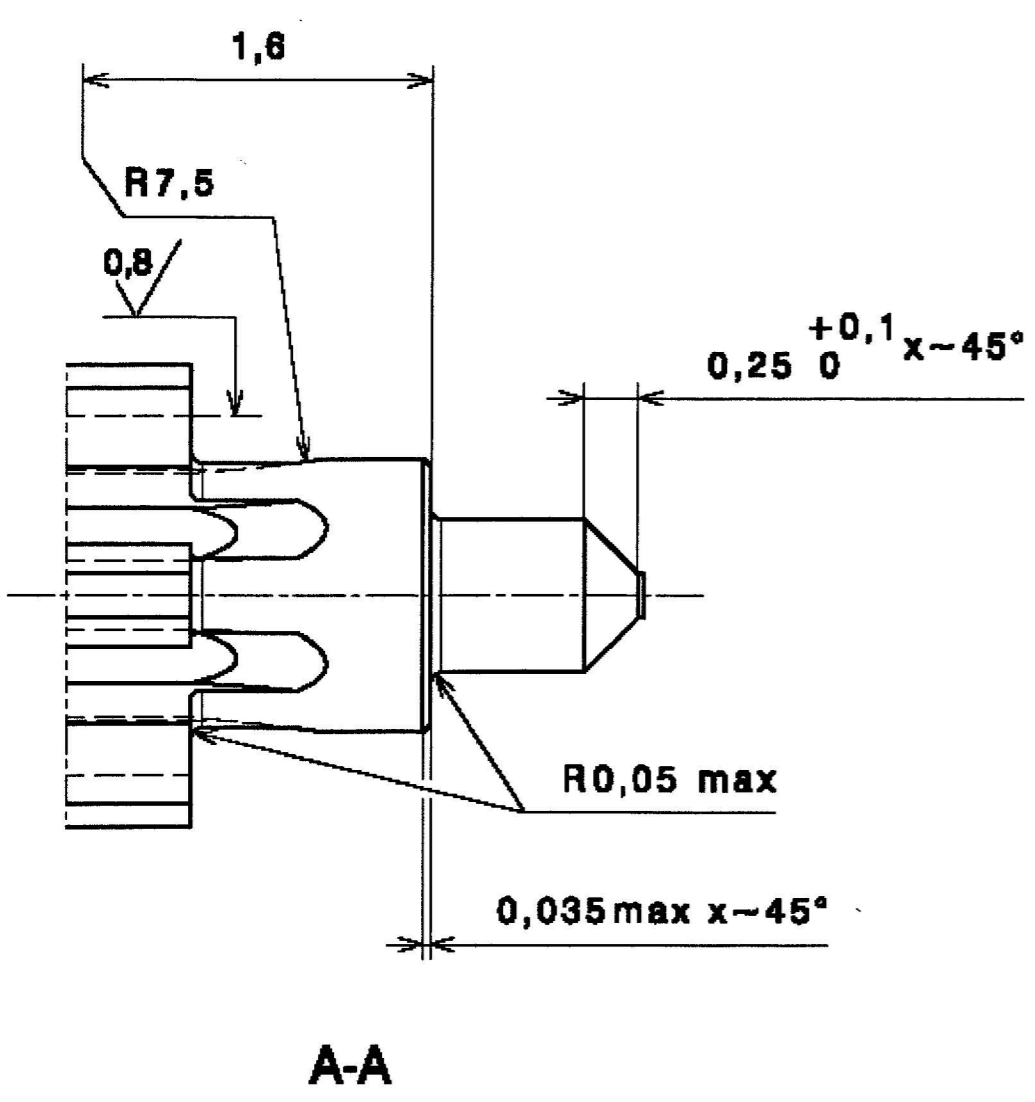
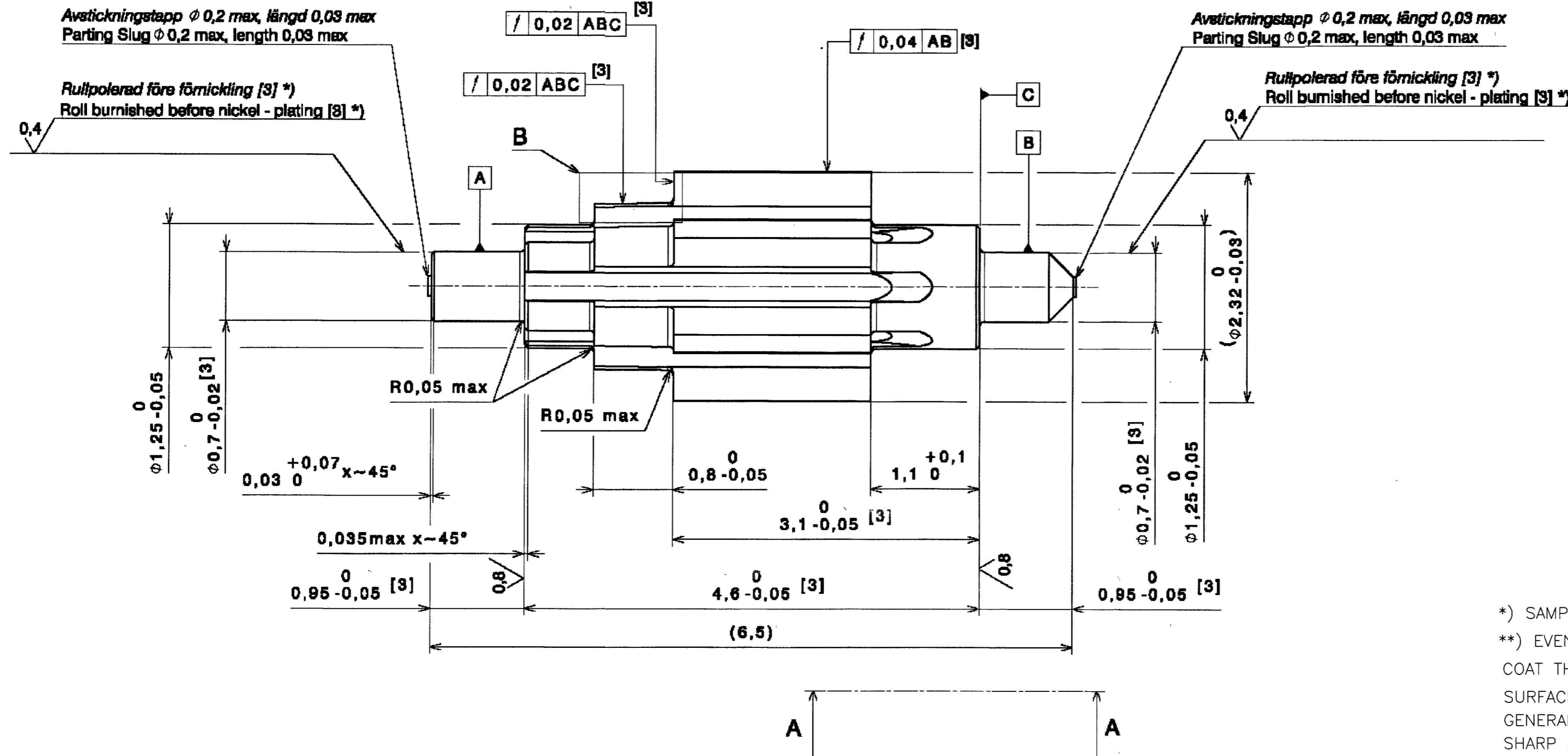
Isometric view

GEAR DATA :

z = 6 TEETH  
 m = 0.3  
 d =  $\phi 2.32 - 0.03$  [3]  
 dm =  $\phi 1.8$   
 di =  $\phi 1.15 - 0.05$   
 a = 20°

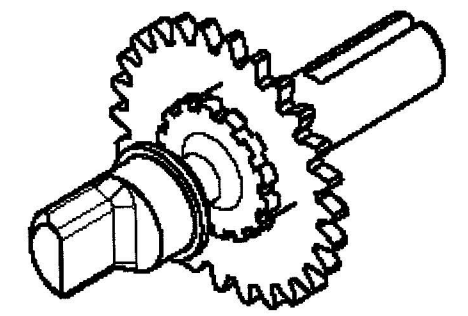
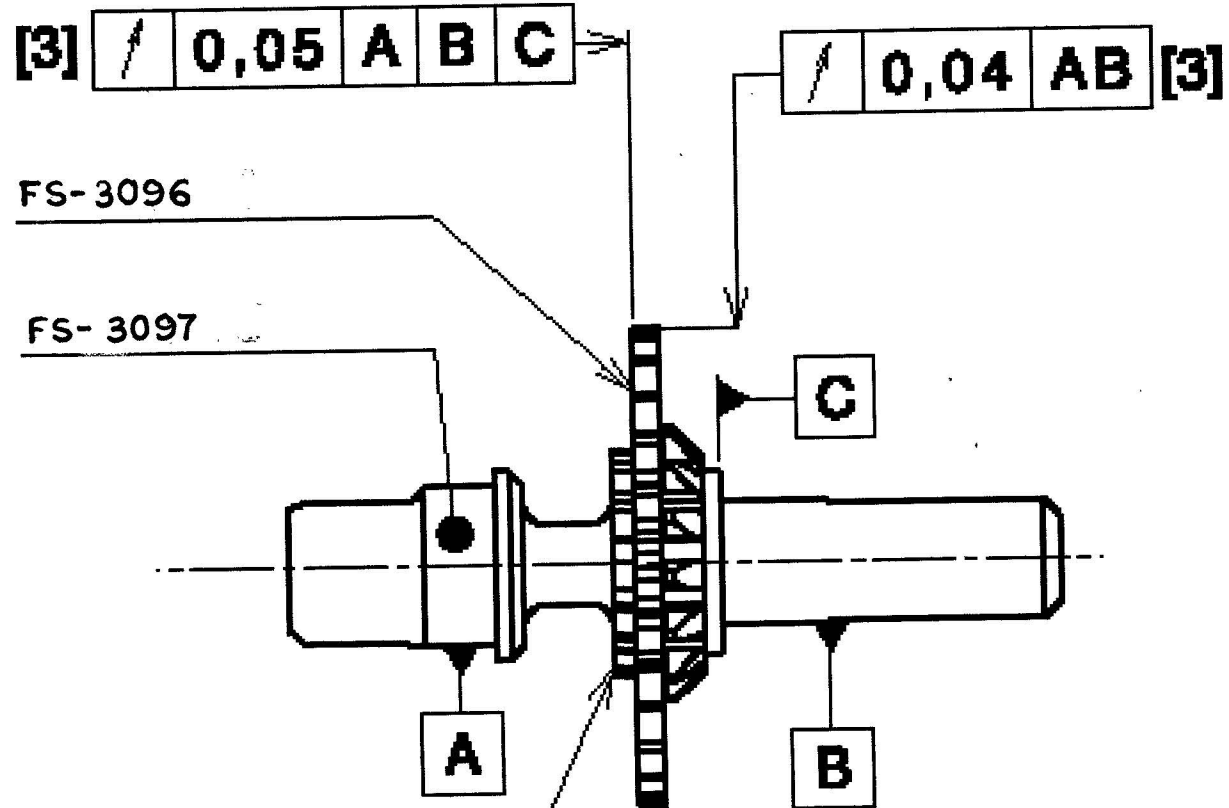
INVOLUTE PROFILE  
 FREE FORM BURRS [3]

- \*) SAMPLE SIZE ACCORDING TO SPECIAL CASES.
- \*\*\*) EVEN AND FLAT – VISUAL INSPECTION.
- COAT THICKNESS – SAMPLE SIZE : 2/1000 pcs.
- SURFACE TREATMENT– NICKEL PLATED 2–3  $\mu$ m [3]\*\*
- GENERAL SURFACE ROUGHNESS : Ra 1.6
- SHARP EDGES BROKEN : 0.05 max.
- DIMENSIONS AFTER SURFACE TREATMENT
- GENERAL TOLERANCE– ISO 2768–fH.
- FORM & POS TOL ACCORDING TO ISO 1101

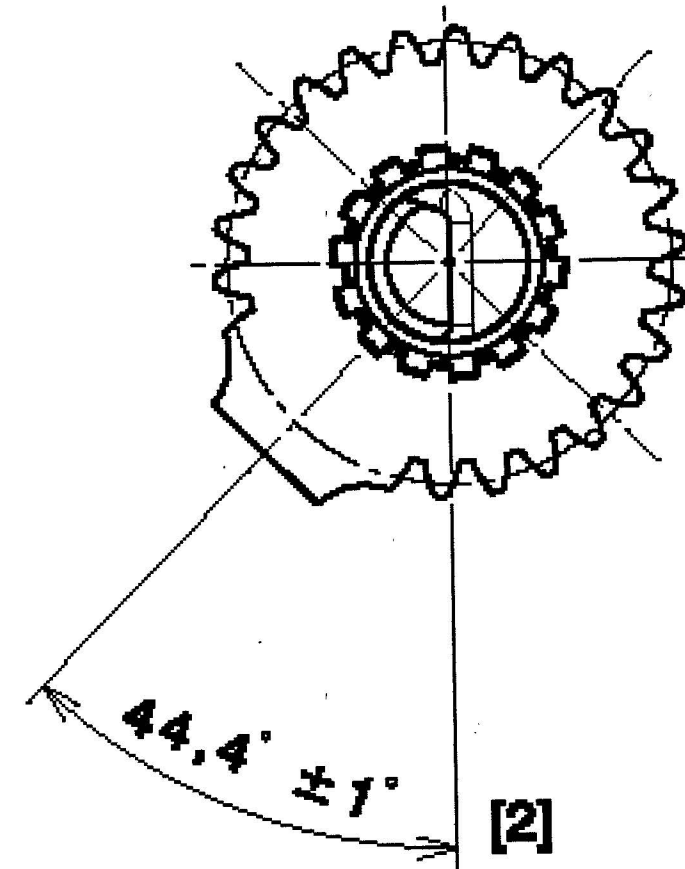


Detail B

DIMENSIONS *ARE IN mm.		MATERIAL–		ORDNANCE FACTORY AMBAJHARI	
FIRST ANGLE PROJECTION		STEEL SANDVIK 20 AP		आर्डनेन्स फॅक्टरी अम्बाझरी	
SCALE – NTS		NOMENCLATURE		DRG. NO :	
2020	NAME	DATE	ESCAPE SHAFT	FS- 3109	
DRAWN	Latipuri	02.10.20		REVIEW NO:	01
CHECKED	SB	4.11.20		SHEET NO–	1
HOS/CDD				NO OF SHEETS–	1
APPROVED VERIFIED BY	JWM/FS		M/C:	COMPT.	
	WM/FS		STORE:		
NOMENCLATURE		SIGN.			
AMENDMENTS					



Isometric view  
Scale: 5:1

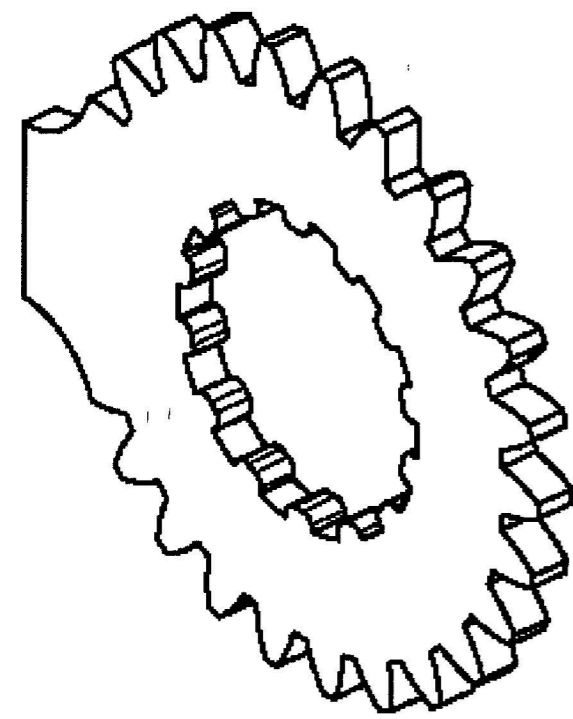


Riveted so that FS-3096 will endure an axial load of  $\geq 137$  N [1]

Riveting well performed and Centre wheel pressed against stop and with bevelled edge towards stop surface [2]. Visual inspection

FORM & POS TOL ACC. TO ISO 1101

			DIMENSIONS ARE IN mm.			MATERIAL- ---		ORDNANCE FACTORY AMBAJHARI	
			FIRST ANGLE PROJECTION					आर्डनैन्स फैक्टरी अम्बाझरी	
			SCALE - NTS			NOMENCLATURE		DRG. NO : FS-3143	
			2021	NAME	DATE	CENTRE WHEEL ASSEMBLY		REVIEW NO: 1	
			DRAWN	Kush	06.01.21			SHEET NO- 1	
			CHECKED	बलित का	06.01.21			NO OF SHEETS- 1	
			HOS/CDD	[Signature]	06.01.21			COMPT.	
			JWM/FS	[Signature]	06.01.21				
			NOMENCLATURE		SIGN.	M/C:			
			AMENDMENTS			STORE:			



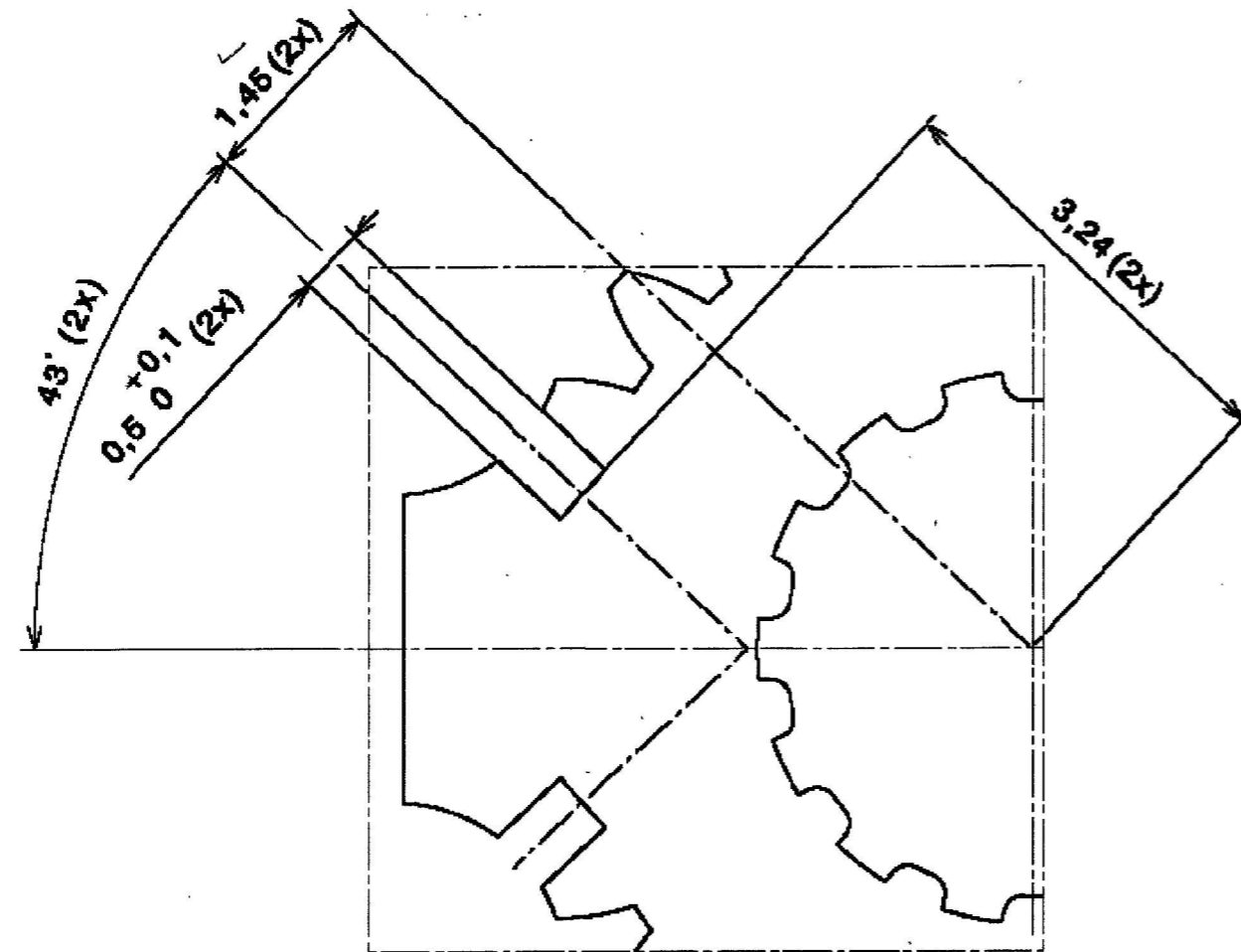
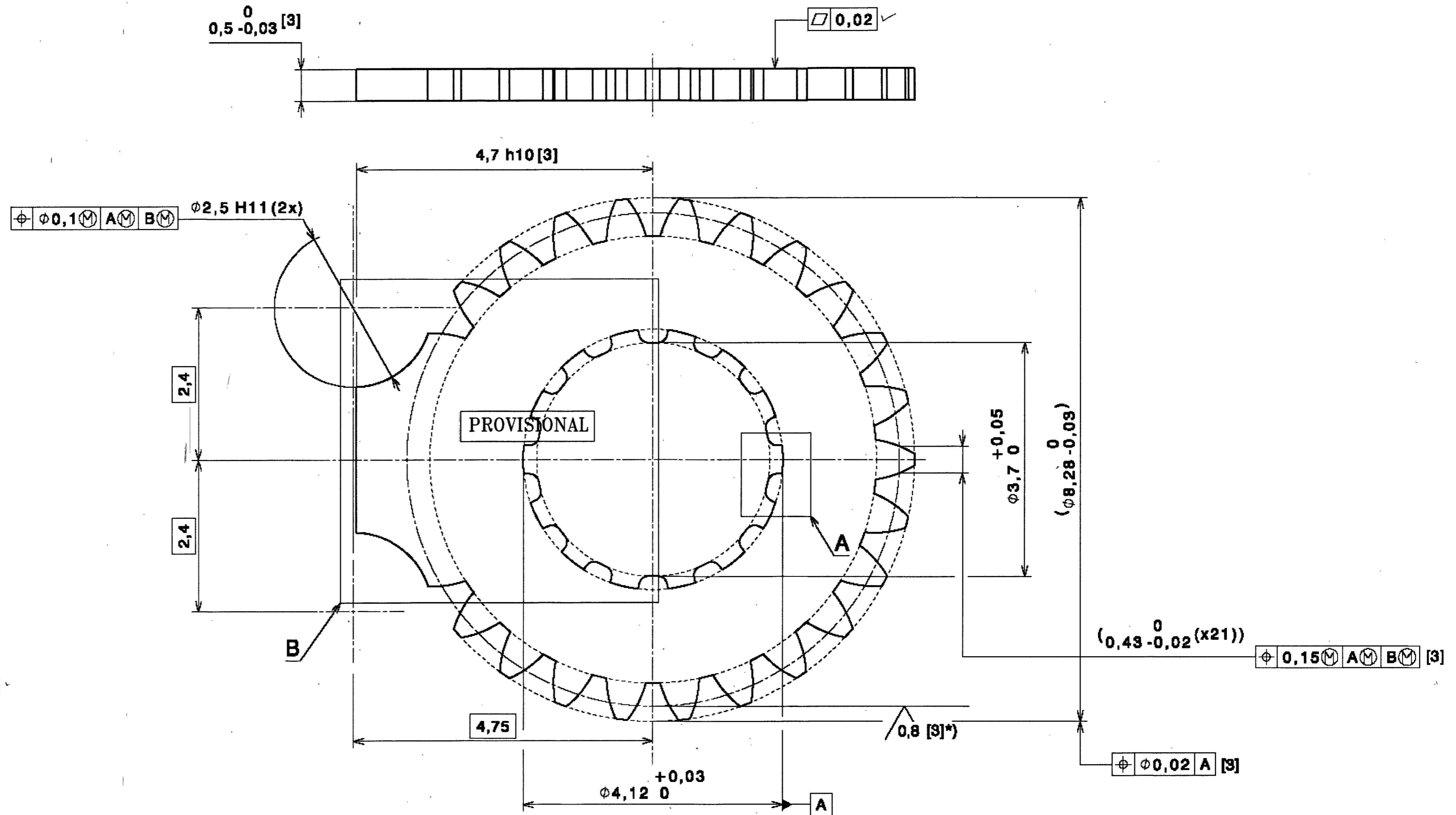
**Isometric view**  
Scale: 10:1

DIMENSIONS AFTER SURFACE TREATMENT  
 \*SAMPLE SIZE ACCORDING TO SPECIAL CASES.  
 \*\*EVEN AND FLAT - VISUAL INSPECTION.  
 COAT THICKNESS - SAMPLE SIZE: 2/1000 pcs.  
 SURFACE TREATMENT-NICKEL PLATED 2-3 μm [3]  
 SURFACE ROUGHNESS - Ra 1.6  
 FORM & POS TOL. ACC. TO ISO 1101  
 GENERAL TOLERANCE ISO 2768 FH.

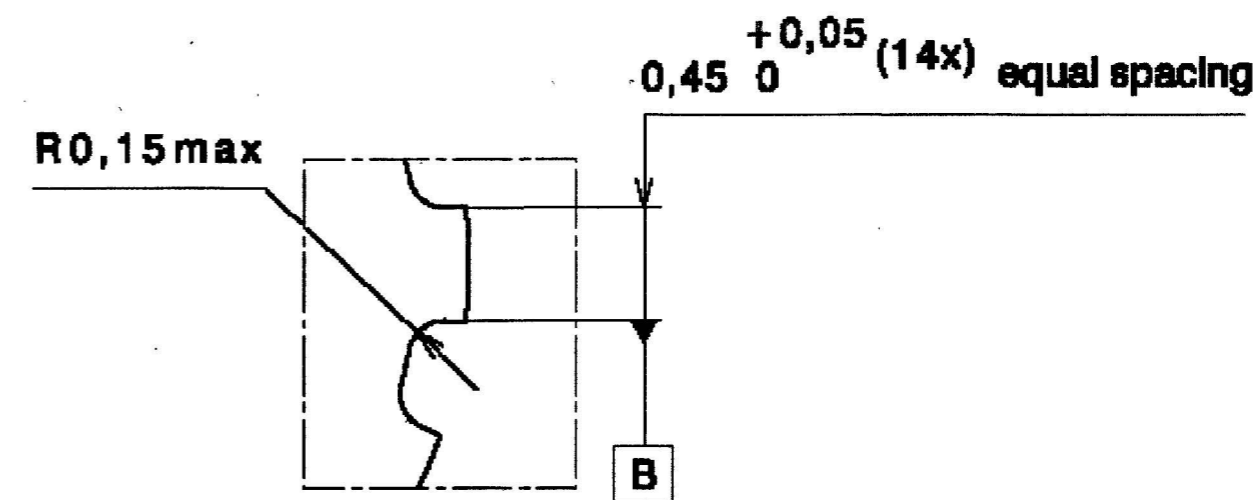
**GEAR DATA :**

z = 26 TEETH/360°  
 m = 0.3  
 d =  $\phi 8.28 -0.03$  [3]  
 dm =  $\phi 7.8$   
 di =  $\phi 7.1 -0.05$   
 t2 vid/at dm =  $0.43 -0.02$   
 a = 20°

INVOLUTE PROFILE  
 FREE FORM BURRS [3]

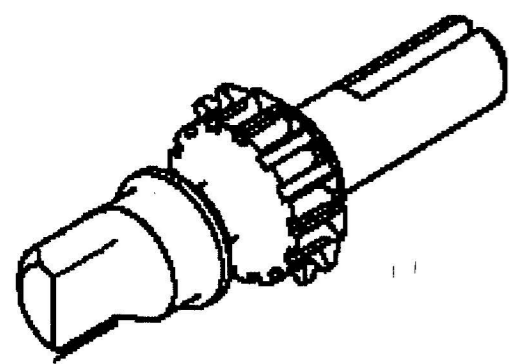


**Detail B**  
Alternative design

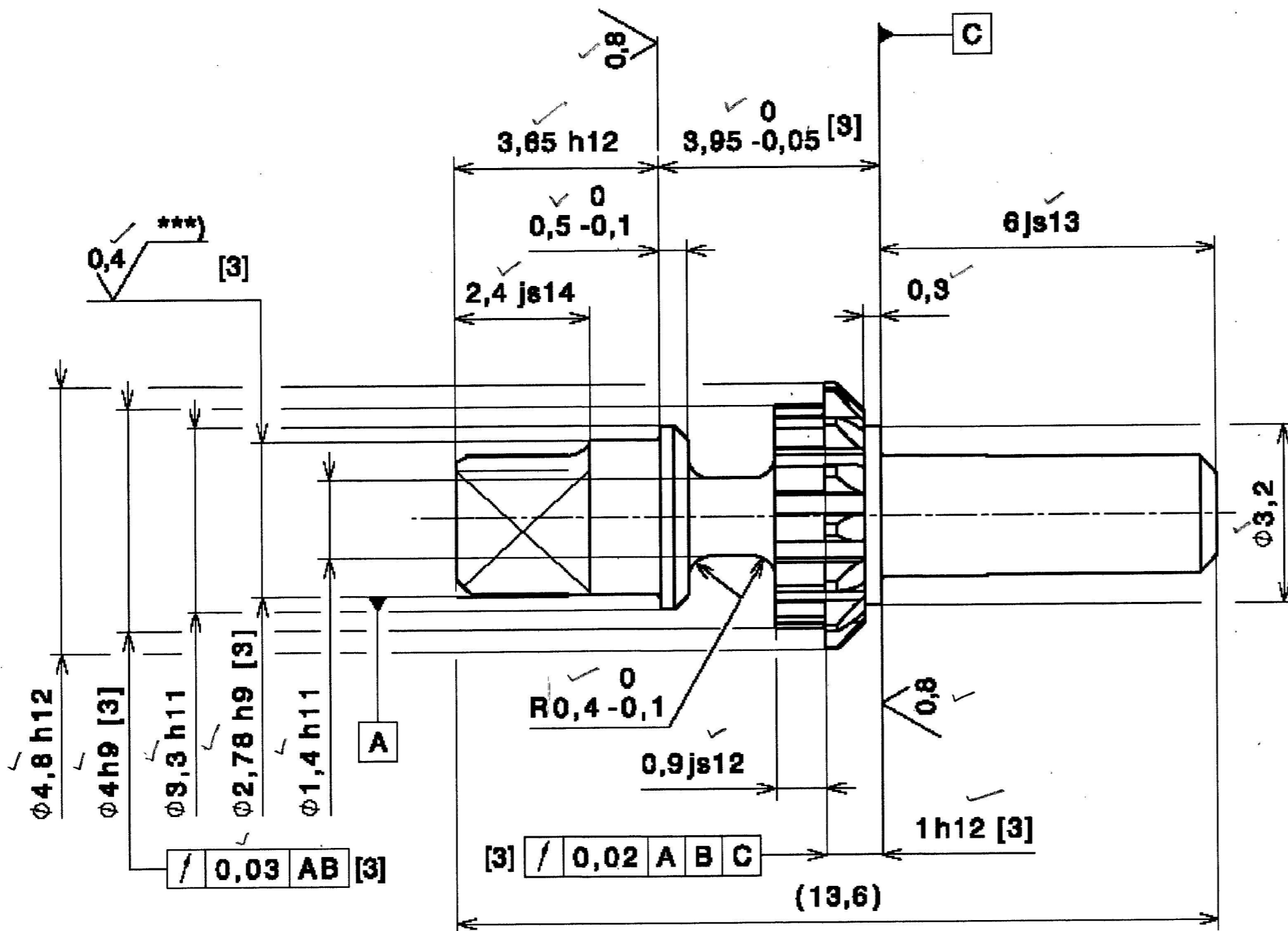


**Detail A**  
Scale: 30:1

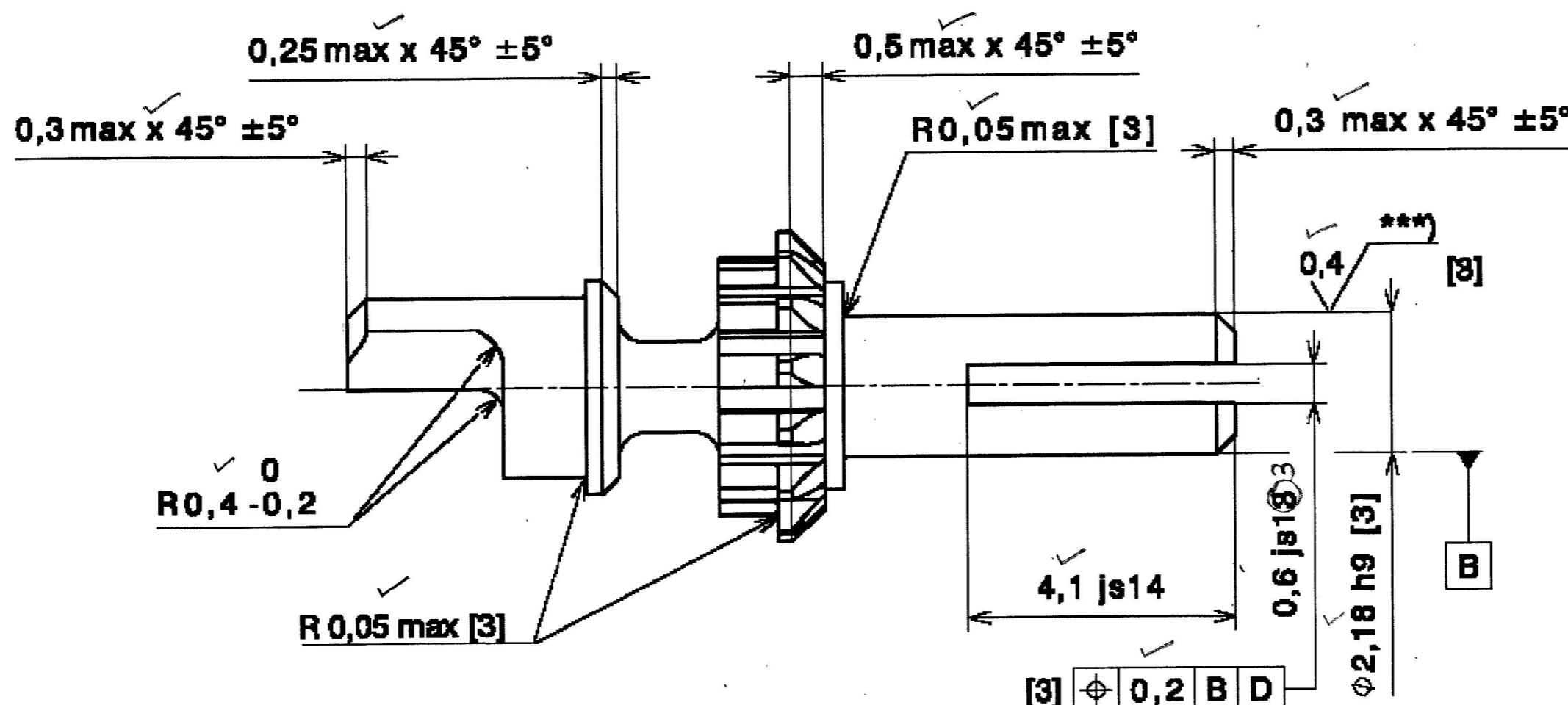
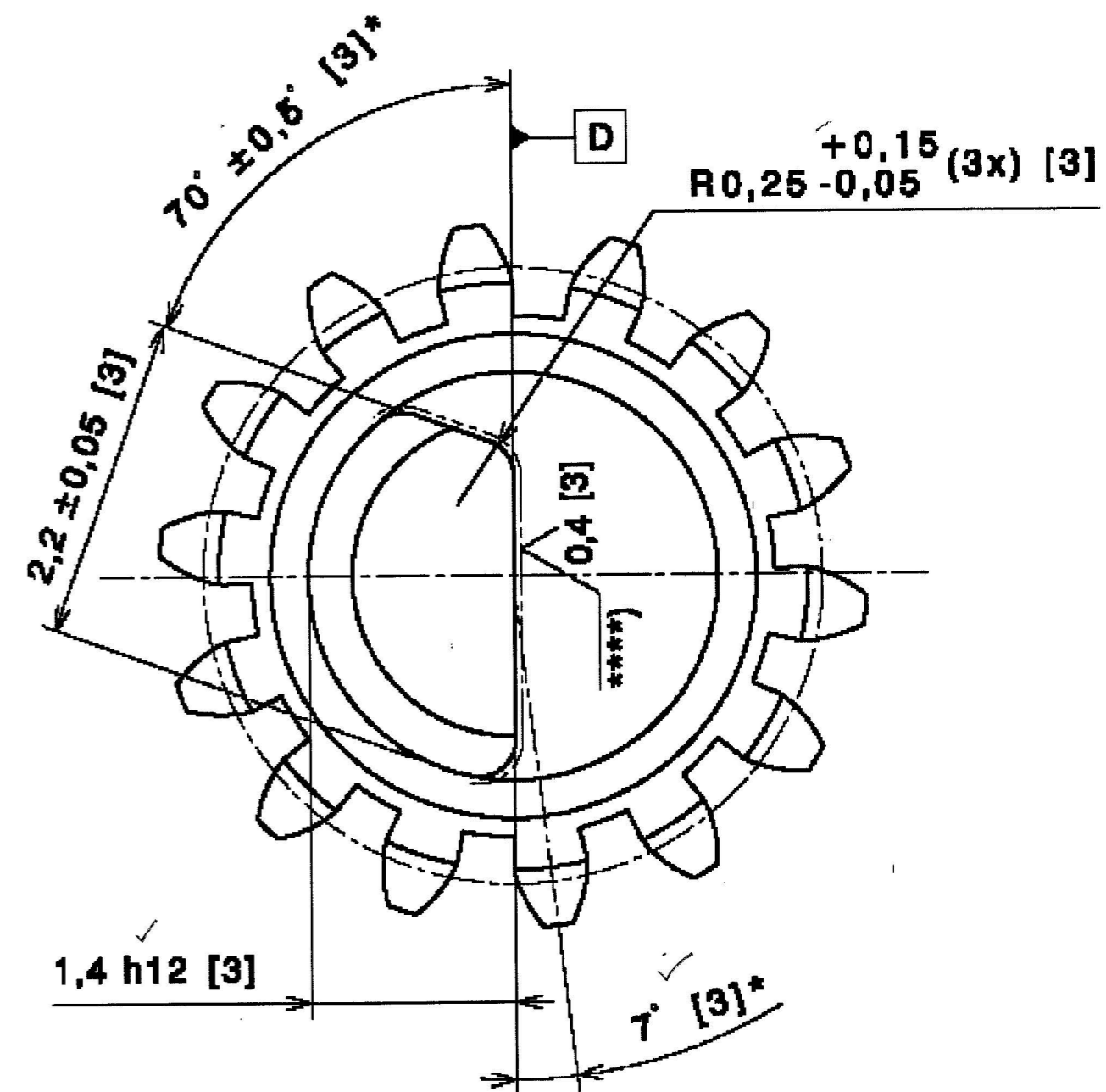
DIMENSIONS ARE IN mm.		MATERIAL- STEEL SS-EN	ORDNANCE FACTORY AMBAJHARI
FIRST ANGLE PROJECTION		10132-4 1.1274 +A[2]	आर्डनैन्स फैक्टरी अम्बाझरी
SCALE - NTS		NOMENCLATURE	DRG. NO :
2020	NAME	DATE	FS- 3096
DRAWN	Lo... 08.10.20		REVIEW NO: 0
CHECKED	4.11.20		SHEET NO- 1
HOS/CDD	4.11.20		NO OF SHEETS- 1
APPROVED BY	JWM/FS		COMPT.
	AMM/FS		
NOMENCLATURE		SIGN.	
AMENDMENTS			



Isometric view  
Scale: 5:1



PROVISIONAL



DIMENSIONS AFTER SURFACE TREATMENT

\*) SAMPLE SIZE ACCORDING TO SPECIAL CASES. ✓

\*\*) EVEN AND FLAT - VISUAL INSPECTION. ✓  
COAT THICKNESS - SAMPLE SIZE: 2/1000 pcs. ✓

\*\*\*) ROLL BURNISHED BEFORE NICKEL-PLATED ✓

\*\*\*\*) BURNISHED BEFORE NICKEL-PLATED ✓

SURFACE TREATMENT-NICKEL PLATED  $2-3 \mu m$  [3]\*\* ✓

GENERAL SURFACE ROUGHNESS -  $Ra 1,6$  ✓

SHARP EDGES BROKEN- $0,1$  MAX ✓

FORM & POS TOL ACC. TO -ISO 1101 ✓

FILLET-  $R0,1$  MAX. ✓

GENERAL TOLERANCE - ISO 2768 fh ✓

GEAR DATA :

$z = 14$  TEETH ✓

$m = 0,3$  ✓

$d = \phi 4,8$  h12 ✓

$d = \phi 4,2$  ✓

$d_i = \phi 3,55$  ✓

$\alpha = 20^\circ$  ✓

INVOLUTE PROFILE ✓

FREE FORM BURRS [3] ✓

DIMENSIONS ARE IN mm.			MATERIAL- STEEL SANDVIK 20 AP[2]		ORDNANCE FACTORY AMBAJHARI आईनैन्स फैक्टरी अम्बाझरी
FIRST ANGLE PROJECTION			NOMENCLATURE		
SCALE - NTS			CENTRE ARBOR		DRG. NO : FS-3097
2020	NAME	DATE			REVIEW NO: 0
DRAWN	Dipankar Khajur	13.11.20			SHEET NO- 1
CHECKED	ललित भा	19.11.20			NO OF SHEETS- 1
HOS/CDD		19/11/20			COMPT.
APPROVED BY	JWM/FS	23/11/20			CENTRE ARBOR (304100134)
	JGM/FS	24/11/20			
AMENDMENTS			STORE: 84mm HEAT 751 SA DEVICE		