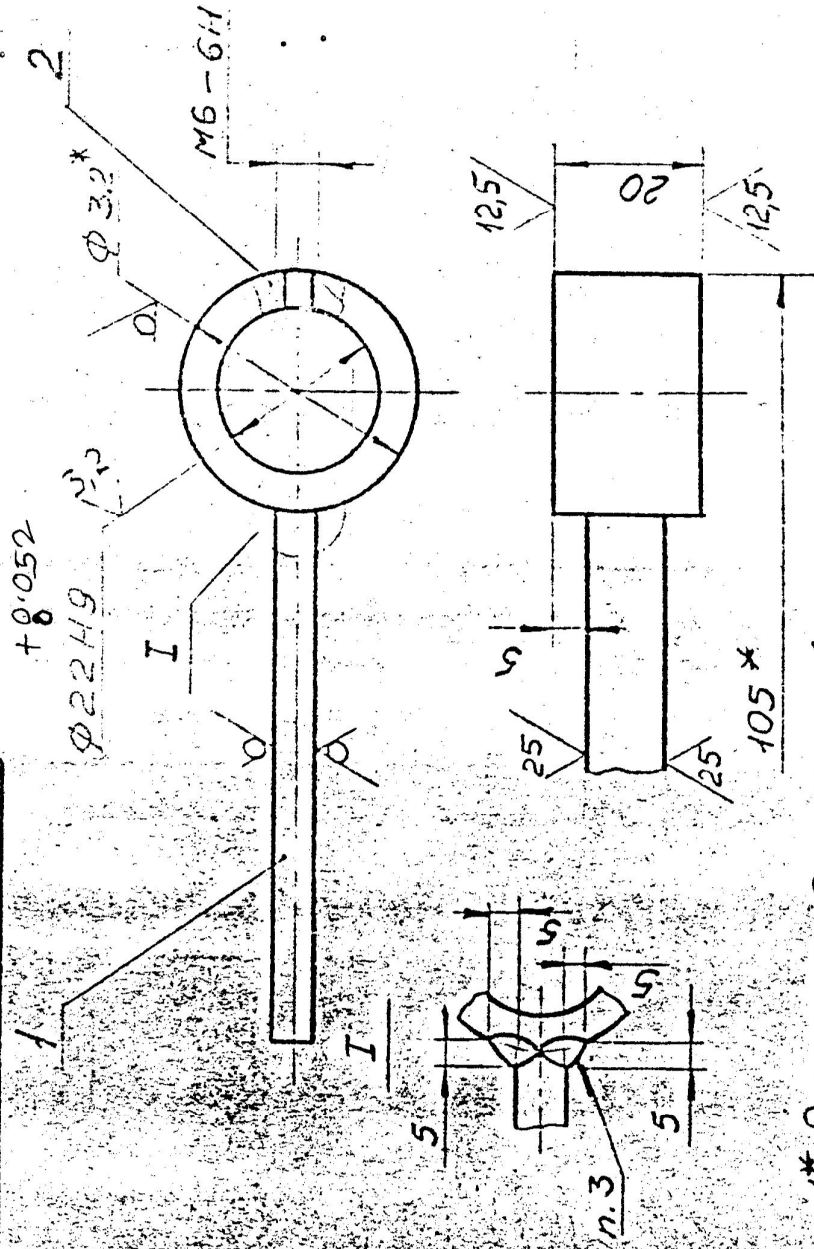


2344-104-00МКСБ



1* Размеры для справок

2. Неуказанные предельные отклонения размеров: валов - $\pm IT14$, остальных - $\pm IT14/2$

3. Сварка ручная дуговая. Электрод УОНИИ-13/45-3-2 ГОСТ 9466-75

4. Покрытие: Хим. пос. пр.м. ГОСТ 9.073-77

STOP

TANK ASSY

125 mm SCCC WINDING M/C

NO. OFF - 1

DRG. NO. YMT.SK.119.8200-A/4

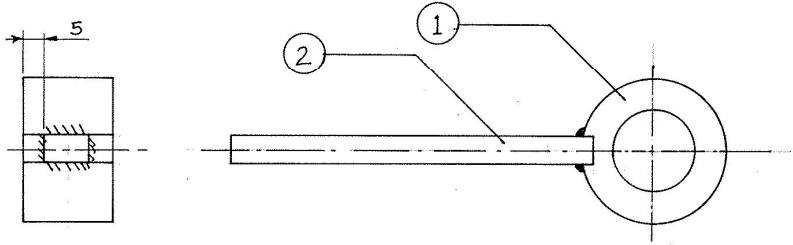
APPROVED BY
18/8

Лист	№ докум.	Дата

2344-104-00МКСБ

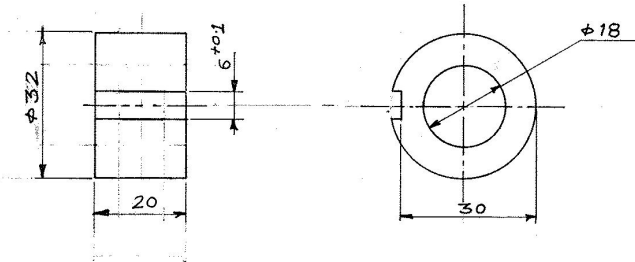
Упор
сборочный чертёж

Лист	Масса	Масштаб
1		1:1
Лист	Листов	1



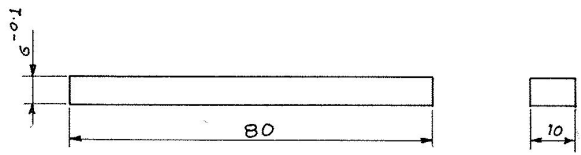
'E' WELDED

* STRESS TO BE RELIEVED AFTER WELDING



W

VMT-SK-119-8201-A13	1	BOSS	40 C8 IS:5517	1	1:1
DRG. NO	ITEM NO	DESCRIPTION	MATERIAL	NO OFF	SCALE



W

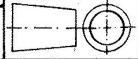
VMT-SK-119-8202-A13	2	PLATE	40 C8 IS:5517	1	1:1
DRG. NO	ITEM NO	DESCRIPTION	MATERIAL	NO OFF	SCALE

1	STOP								
संख्या NO. OFF.	विवरण DESCRIPTION	पुर्जा क्र. PART NO.	पदार्थ MATERIAL	मानक STANDARD	परिमाण DIMENSIONS	अभ्यक्ति REMARKS			
सामान्य सहिष्णुता GENERAL TOLERANCE									
रेखिक परिमाण LINEAR DIMENSION									
0 - 6 ± 0.1									
6 - 30 ± 0.2									
30 - 120 ± 0.3									
120 - 315 ± 0.5									
315 - 1000 ± 0.8									
1000 - 2000 ± 1.2									
कोणिक परिमाण ANGULAR DIMENSION	संख्या NO. OFF.	संबंधित पुर्जाका आरेखण क्र. DRG. NO. OF ASSOCIATED PART	सूचक INDEX	मशीधन ALTERATION		दिनांक DATE	नाम NAME		
1 - 10 ± 1'						2000			
10 - 50 ± 30'									
50 - 100 ± 20'									
> 100 ± 10'									
मापानक : म्यू एम 'म' VALUE IN 'μm'									
▽	> 25								
▽▽	8 - 25								
▽▽▽	1.6 - 8								
▽▽▽▽	0.025 - 1.6								
▽▽▽▽▽	< 0.025								
मापमान SCALE	आरेखित DRAWN	जांचा CHECKED	अनुमोदित APPROVED	द्वारा बदला REPLACED BY	कार्यालय OFFICE	हेतु बदला REPLACED FOR	आरेखण क्र. DRAWING NO.		
1:1	24/2/20	Pradip			VMT		VMT-SK-119-8200-A43		
STOP FOR		TANK ASSY.		125 mm SCCC WINDING M/C		मशीनी औजार आदिरूप फैक्टरी, अम्बरनाथ MACHINE TOOL PROTOTYPE FACTORY, AMBARNATH			

इन आरेखणों तथा इसके साथ की सम्पूर्ण सामग्री का स्वत्वाधिकार भारत सरकार, रक्षा मंत्रालय की भारतीय आयुध निर्माणियों के पास है। भारतीय आयुध निर्माणियों के महानिदेशक की लिखित अनुमति के बिना इनकी नकल या किसी भी रूप में इनके उद्धरण या इनमें समाहित सूचना किसी अनधिकृत व्यक्ति को उपलब्ध नहीं कराई जानी चाहिए।

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मूलमाप व अन्वयोजन NOMINAL SIZE & FIT	विचलन DEVIATION
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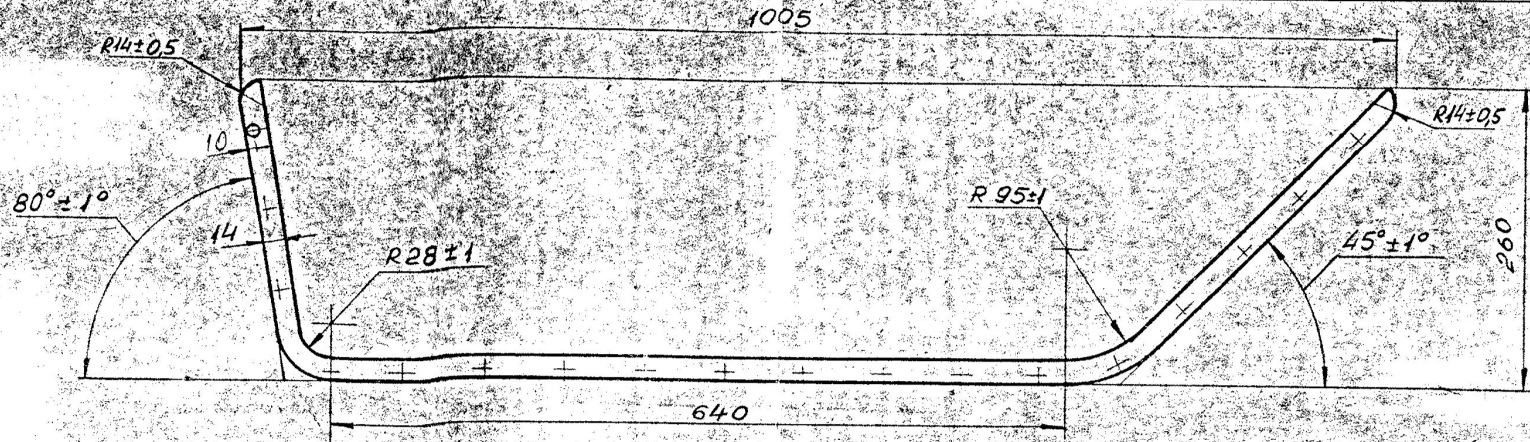


W

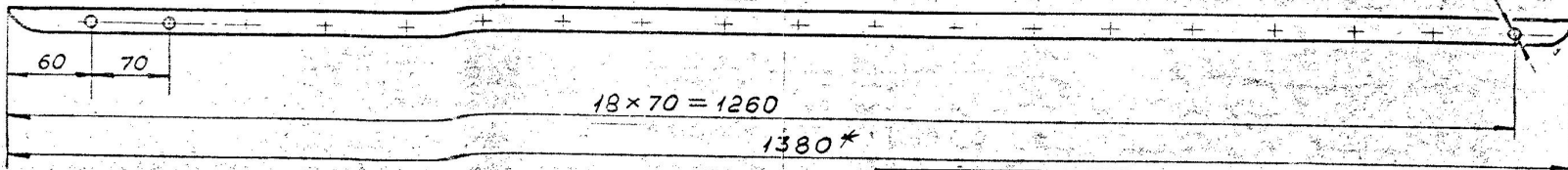
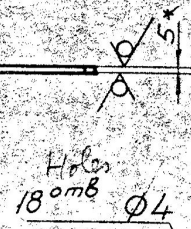
2344-101-09M

63 (✓)

** :- 04Cr18Ni10Ti20 STAINLESS STEEL



DEVELOPED VIEW Развёртка



*Размеры для справок
 2. Предельные отклонения размеров: отверстий - H14
 валов - h14, остальных - ± 0.14
 Hole size
 1. * Dimensions for reference
 2. Limit deviations for
 shafts - h14, others - ± 0.14

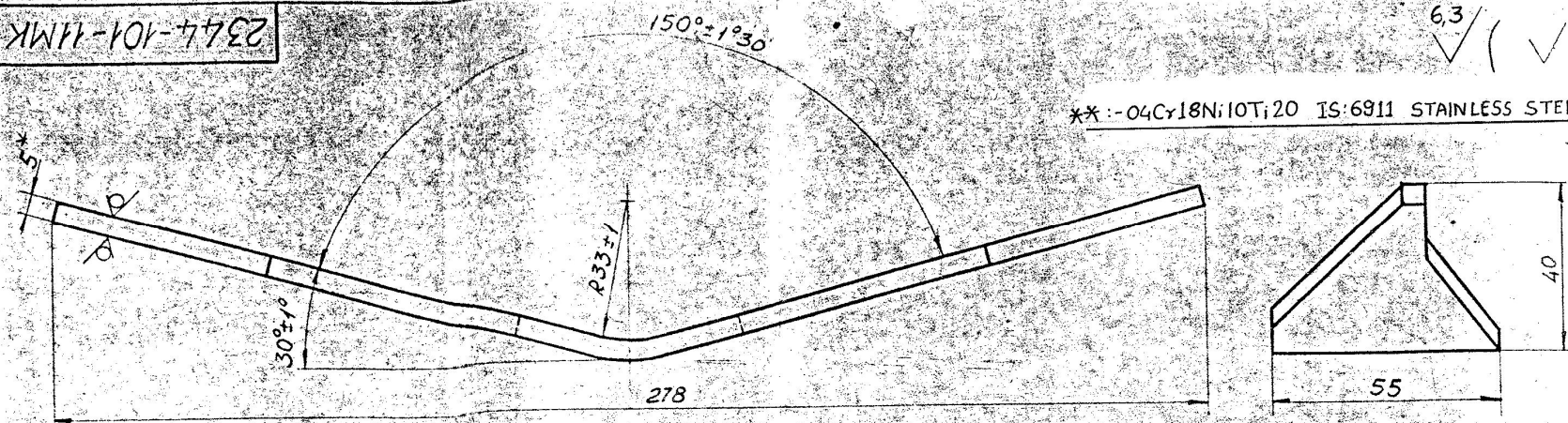
NO. OFF - 4	MATERIAL: **	IS: 6911	Book No 349
2344-101-09MK			
Редеро RIB			Авт. Масса Измеряет
TANK ASSY.			1:4
FIRST ANGLE PROJECTION			Авт. Измеряет 1
Авт. Б-0-ПН-5 ГОСТ 19904-74 12X1849T-M2aГОСТ 7350-77			13/396

DRG. NO: - VMTSK-119-8201-13. RIB
 125mm. SCCC WINDING M/C
 AUTHENTICATED BY [Signature]
 SUPPORTED BY [Signature]

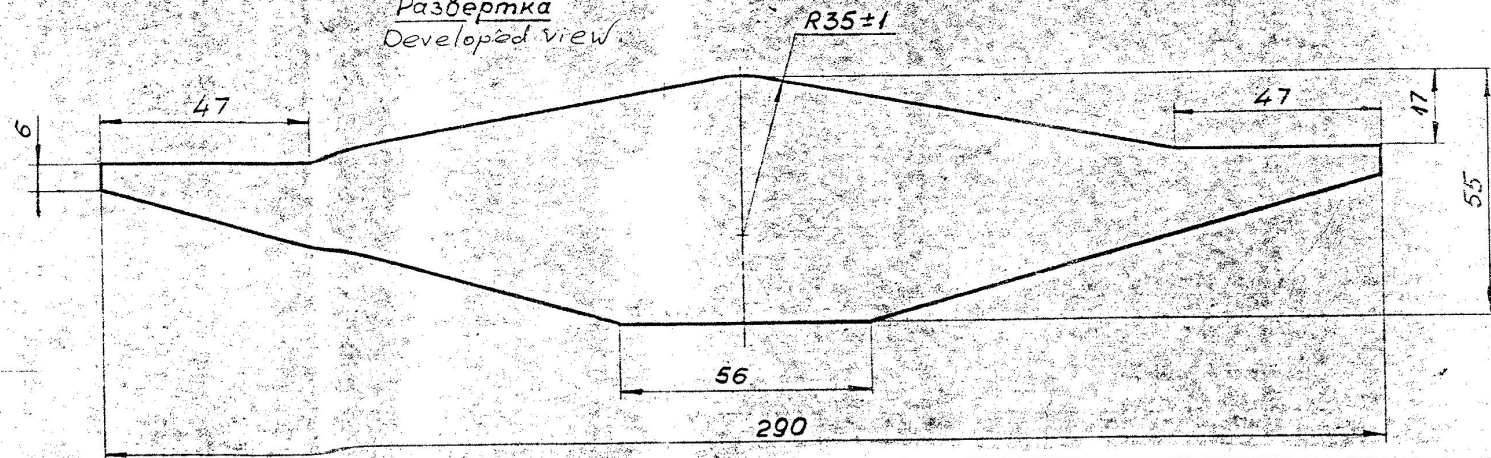
2344-101-11MK

6.3 / (✓)

** :- 04Cr18Ni10Ti20 IS:6911 STAINLESS STEEL



Развёртка
Developed view



1. Размеры для справок.
2. Предельные отклонения размеров: валов- ± 14 , остальных $\pm \frac{IT14}{2}$

1. Dimensions for reference.
2. Limit size deviations for: shafts- ± 14 , remaining $\pm \frac{IT14}{2}$

DRG.NO VMTSK-119-8202-13		NO OFF:-1		MATEL:- **		AUTHENTICATED BY <i>cm</i>	
SPOUT FOR 125mm SCCC, WINDING M/C				NO OFF:- 1		SUPPORTED BY <i>cm</i>	
2344-101-11MK							
НОСУК Spout						Лист	Мащтаб
FIRST ANGLE PROJECTION						1	1:4
6 9 1 1						Лист	Листов
04TANK ASSY: 20						15/336	
Лист Б-0-ПН-5 ГОСТ 19904-74 12X18H9T-M2a ГОСТ7350-77							

