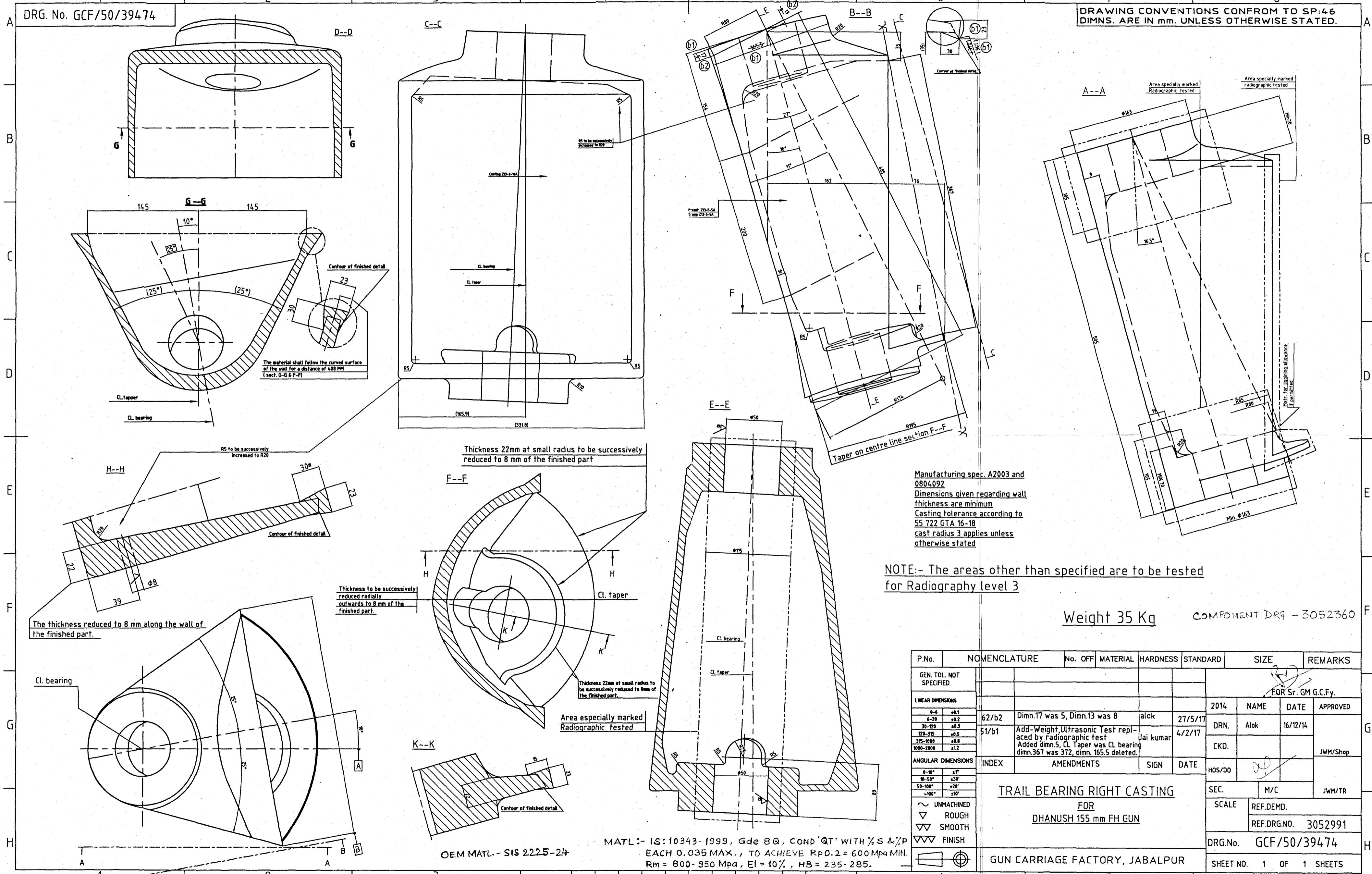




DRG. No. GCF/50/39474

DRAWING CONVENTIONS CONFORM TO SP:46  
DIMNS. ARE IN mm. UNLESS OTHERWISE STATED.



Manufacturing spec. A2003 and 0804092  
Dimensions given regarding wall thickness are minimum  
Casting tolerance according to IS 722 GTA 16-18  
cast radius 3 applies unless otherwise stated

NOTE:- The areas other than specified are to be tested for Radiography level 3

Weight 35 Kg COMPONENT DRG - 3052360

P.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	SIZE	REMARKS
GEN. TOL. NOT SPECIFIED							
LINEAR DIMENSIONS							
0-4	±0.1					2014	NAME DATE APPROVED
5-30	±0.2				27/5/17	DRN.	Alok 16/12/14
30-120	±0.3				4/2/17	CKD.	
120-315	±0.5						JWM/Shop
315-1000	±0.8						
1000-2000	±1.2						
ANGULAR DIMENSIONS							
0-10°	±1°					HOS/DD	
10-50°	±30'						
50-100°	±20'						
>100°	±10'						
~	UNMACHINED					SEC.	M/C JWM/TR
▽	ROUGH					SCALE	REF.DEMD.
▽▽	SMOOTH						REF.DRG.NO. 3052991
▽▽▽	FINISH					DRG.No.	GCF/50/39474
⊕						SHEET NO.	1 OF 1 SHEETS

MATL :- IS:10343-1999, Gde 8Q, COND 'QT' WITH %S & %P EACH 0.035 MAX., TO ACHIEVE Rp0.2 = 600 Mpa MIN. Rm = 800-950 Mpa, EI = 10%, HB = 235-285.

OEM MATL. - SIS 2225-24

TRAIL BEARING RIGHT CASTING  
FOR  
DHANUSH 155 mm FH GUN

GUN CARRIAGE FACTORY, JABALPUR