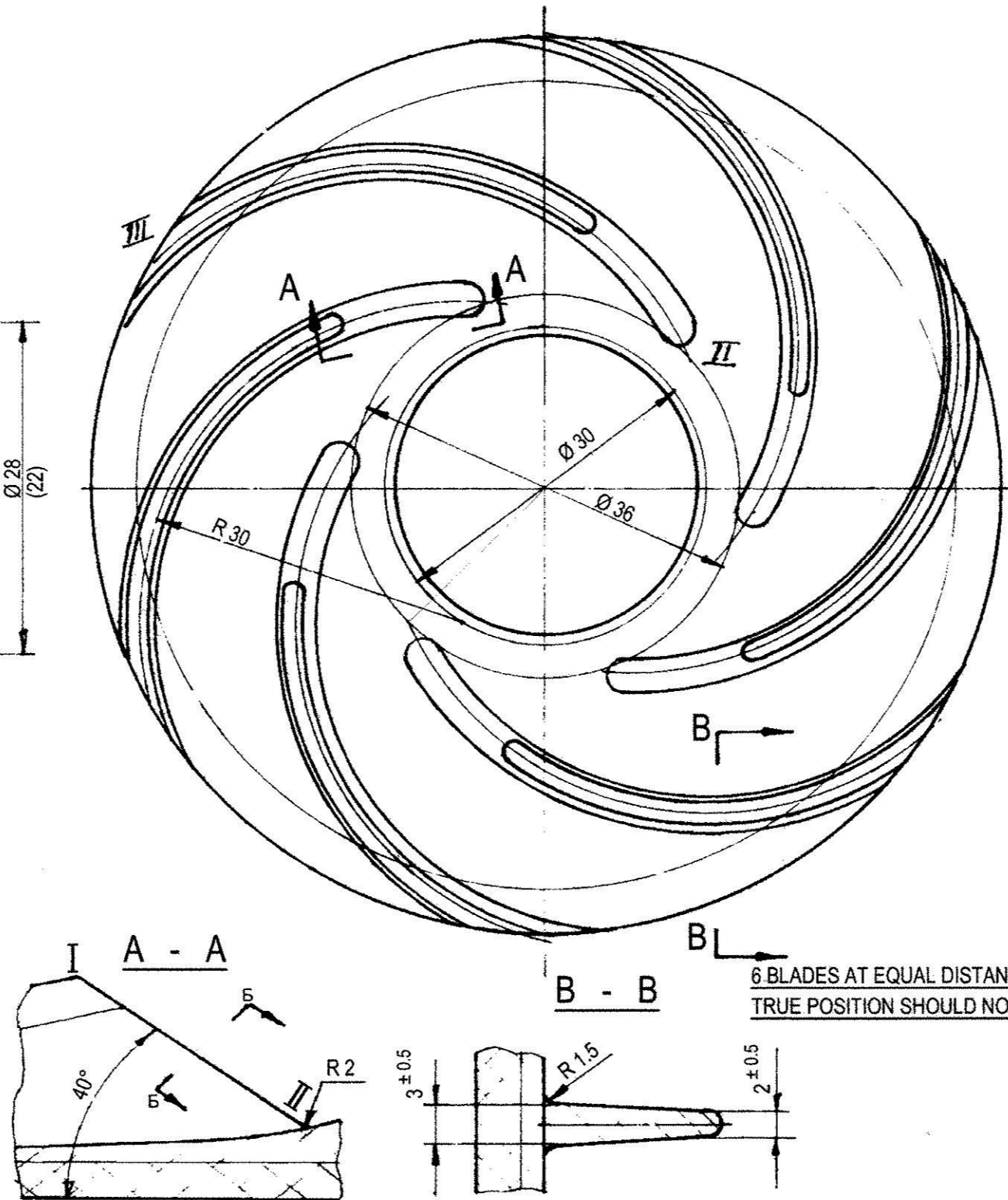
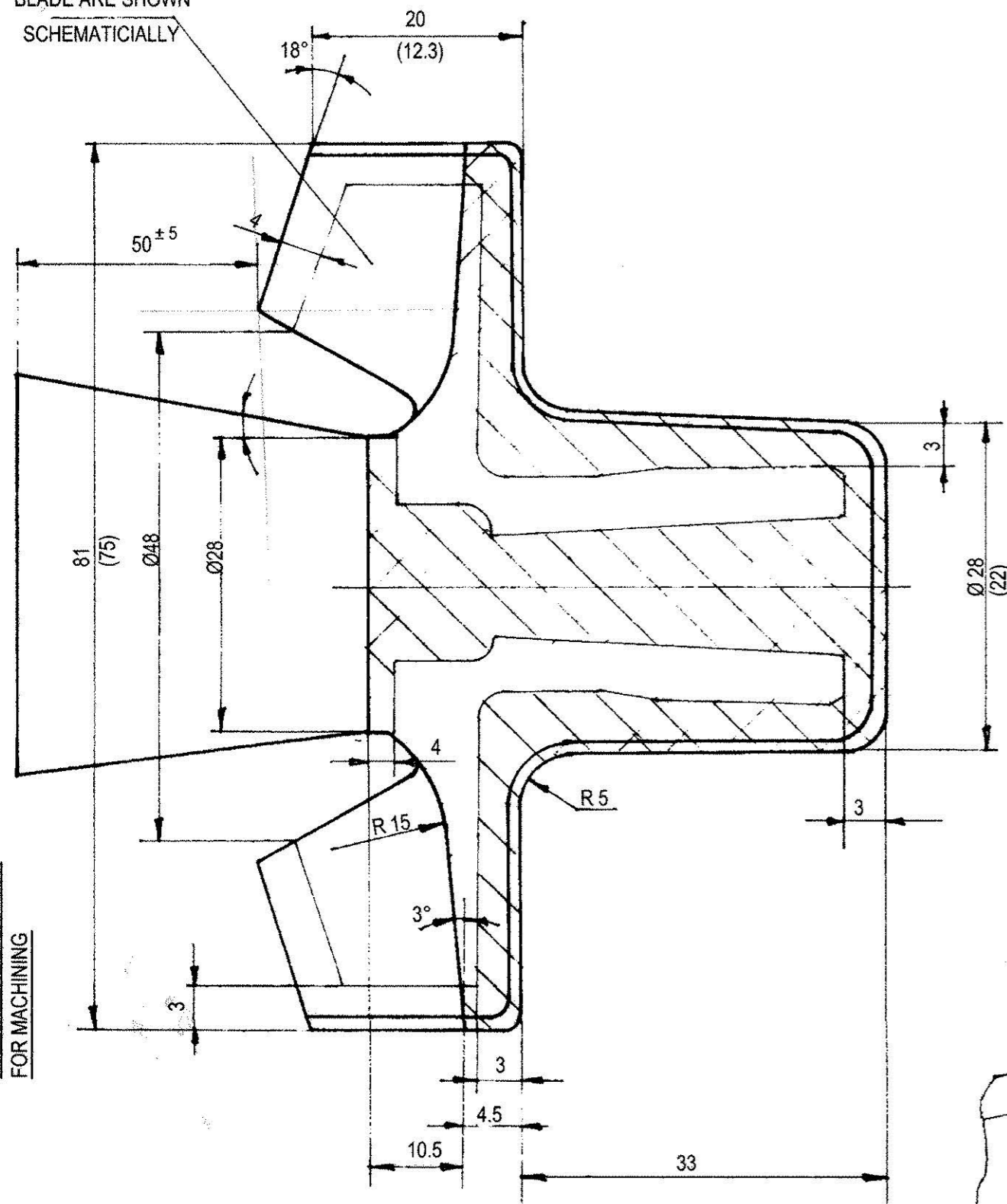




BLADE ARE SHOWN SCHEMATICALLY



Б - Б FROM (IN POINT I)  
UP TO R 1.5 (IN POINT II)

1. USE METAL MOULD CASTING.
2. UNSPECIFIED PATTERN DRAFTS SHOULD NOT EXCEED 2°.
3. UNSPECIFIED CASTING RADII R 3.
4. BLADES MAY BE MADE BY SMOOTH INCREASING OF THICKNESS FROM 2±0.5 AT POINT I UP TO 3±0.5 AND 40.5 AT POINT III.
5. TOLERANCES ON CASTING SURFACES ARE +1.5 / -1.0
6. CAVITIES IF THEY ARE NOT IN ONE GROUP, MAY BE IN QUANTITY NOT MORE THAN 15 NOS. FOR A PART AND NOT MORE THAN 3 NOS. FOR A SURFACE TO A DEPTH UP TO 1 mm AND OF AREA OF 3 mm<sup>2</sup> EACH ON SURFACES TO BE MACHINED AND NOT TO BE MACHINED ARE ALLOWED CAVITIES, WHICH ARE IN THE SAME PLACE OF OPPOSITE SURFACES ON SURFACES OF Ø 20 AND ON EDGES OF BLADES ARE NOT ALLOWED.
7. POROSITY OF BOSS SHOULD NOT EXCEED 0.3 mm.
8. PART MAY BE MADE OF BRONZE OF GRADE брОuС-5-5-5 брОuСН-3-7-5-1 GOST-613-65 AND брАЖ-10-3-15 GOST - 18175 - 78 AND ALSO FROM BRASS ЛК80-3 GOST-17711-78.
9. DO NOT MARK.
10. OTHER REQUIREMENTS OF CASTING SHOULD BE AS PER 54 TY P6-4 OR TT 4408.
11. PART 765-55-185 IS MADE OF TECHNOLOGICAL RISER.

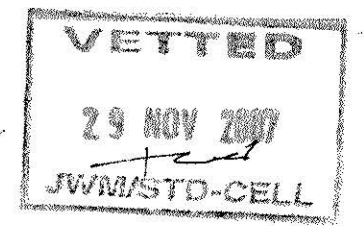
NOTE:-  
CASTING SHOULD BE TESTED FOR RADIOGRAPHIC TEST AS PER ASTM E-310:1999, LEVEL-II

CHEMICAL COMPOSITION (%)

	бр А 9Ж3Л GOST-493-79	
ALUMINIUM	8.0 - 10.5	✓
IRON	2.0 - 4.0	✓
COPPER	REST	✓
ARSENIC	0.05 Max.	✓
ANTIMONY	0.05 Max.	✓
TIN	0.2 Max.	✓
SILICON	0.2 Max.	✓
NICKEL	1.0 Max.	✓
LEAD	0.1 Max.	✓
PHOSPHORUS	0.1 Max.	✓
ZINC	1.0 Max.	✓
MANGANESE	0.5 Max.	✓
TOTAL	2.7 Max.	✓

MECHANICAL PROPERTIES

ULTIMATE STRENGTH,	40 Kg/mm <sup>2</sup> Min.	✓
RELATIVE ELONGATION, %	10 Min.	✓
HARDNESS, HB.	100 Min.	✓



NOTE:- "RADIOGRAPHY TESTS IS MEANT FOR TRADE SUPPLIES ONLY"  
NOTE:- SAMPLE TO BE APPROVED BEFORE BULK SUPPLY

संख्या NO. OFF	विवरण DESCRIPTION	पुर्जा क्र. PART NO.	पदार्थ MATERIAL	मानक STANDARD	परिमाण DIMENSIONS	अभ्यन्तित REMARKS
			БРА9Ж3Л	GOST-493-79	WT-0.600 Kg	
<p>सामान्य सहिष्णुता GENERAL TOLERANCE</p> <p>रेखिक परिमाण LINEAR DIMENSION</p> <p>कोणिक परिमाण ANGULAR DIMENSION</p> <p>मापक 'म्यू एम' में VALUE IN 'μm'</p>						
<p>NOTE ADDED AS PER LETTER No. MPE/p&amp;P/ExT/2011 DT.14.6.11 ADDED ON. 18.6.11 NOTE ADDED ON 09/04/2018</p>						
<p>2007</p> <p>मापमान SCALE: NTS</p> <p>आरेखित DRAWN: 24.11.07 Y.D.K.</p> <p>जाँचा CHECKED: J.P.Y.</p> <p>अनुमोदित APPROVED: A.K.N.</p> <p>द्वारा बदला REPLACED BY: हेतु बदला REPLACED FOR: आरेखण क्र. DRAWING NO. 54-83-005-1A-2</p>						
<p>CASTING OF IMPELLER</p> <p>CODE 38</p> <p>मशीनी औजार आदिरूप फैक्टरी, अम्बरनाथ MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH</p> <p>कार्यालय OFFICE: D.O.</p>						

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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