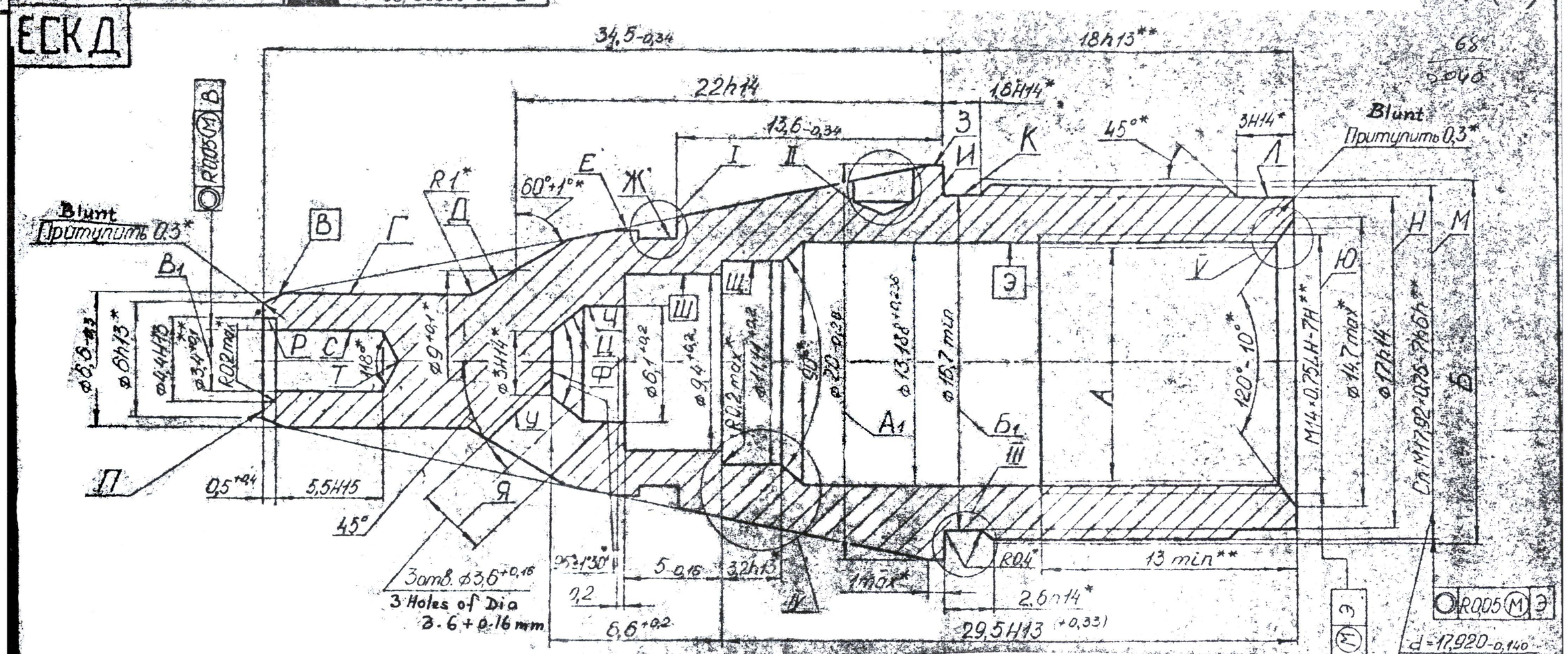
ГОСТ 2.104-68 Форма 1

Рем.№ 01899/82 | 3-0126082 | ЕШ8.036.077

ЕСКД

Rz80 (V)



2. **Dimensions are subjected to total checking

3. Perform machining of every given group of surfaces once clamped only. :

a) В, Г, Д, З, К, Л, У, И, Ш, Щ, Э;

b) Р, С;

c) Е, Ж

1. *Dimensions ensured by tool.

For table, refer to sheet 3

3-0126082	А3-ВГ-84
ЕШ8.036.077	Sheet No. 1 / No. of Sheet 3

TF - 007

BODY

SHEET	WEIGHT	SCALE
A	32 г	5:1

TOTAL SHEETS

ROUND BAR: GOST 7417-75

(A12-H GOST 1414-75)

ORDNANCE FACTORY PROJECT HYDERABAD

APPROVED

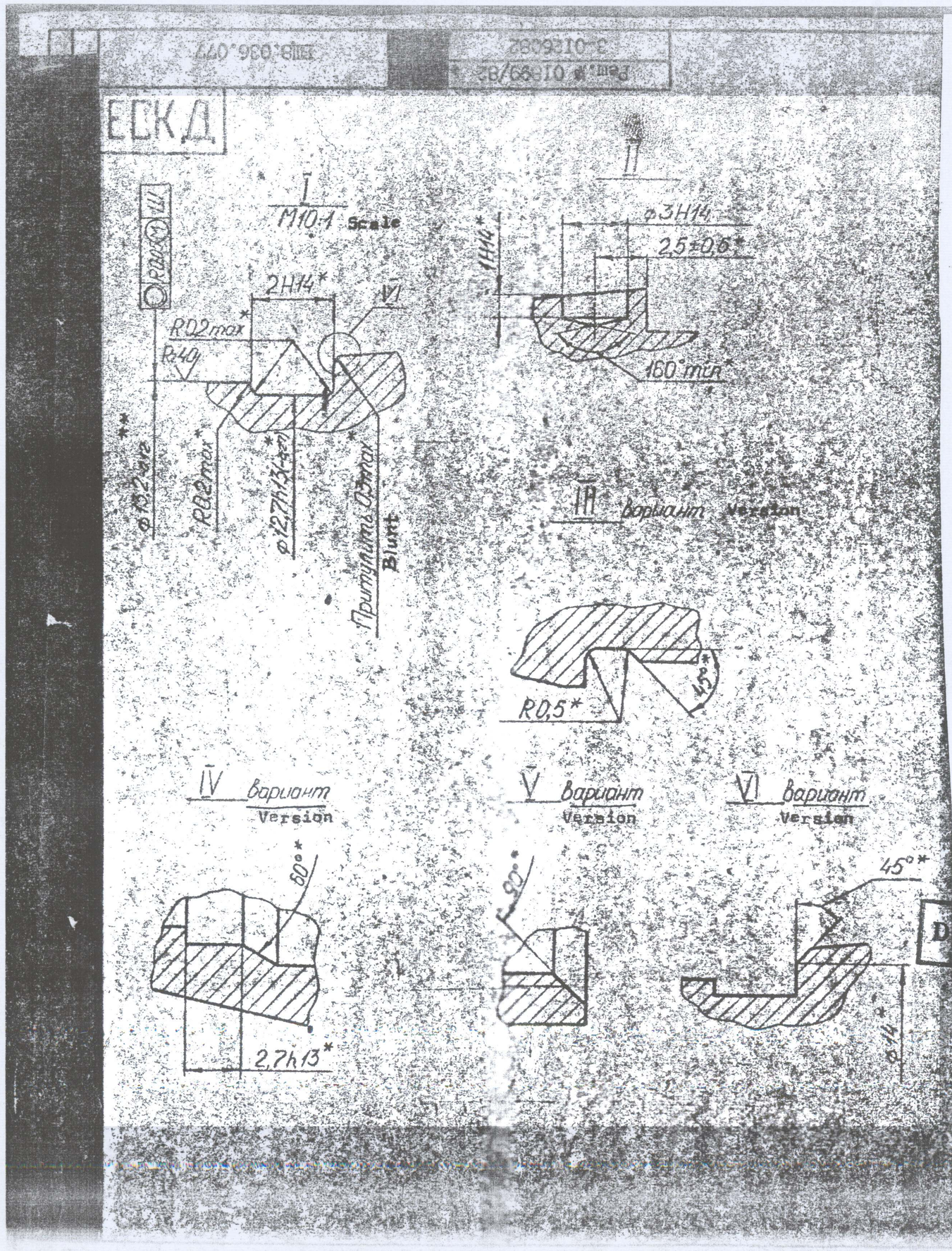
FOR C I (A)

AHSP: C I (A) KIRKEE

SIGN	SHEET	DOC NO	SIGN	DATE
DRAWN				
ED/CHKD				
F/M, DC,				
DIV.OFFR				

24-3-87 DCI.34241-A DRG. PROV. SEALED.

REVISION SIG. SIG.



4. Coating should be in compliance with Table.
5. Mark ~~intaglio~~ by stamping or by pressing in type 2 on surface B at a distance 2...8 MM from surface И in compliance with Assembly Drawing requirements.-
6. Check external diameter of thread M by smooth snap gauge of thickness 4 MM. ~~Perform~~ checking is done by the whole width of working surface of snap gauge.
**7. The profile of chamber, formed with surfaces и, у, ф, ш is to be checked by gauge with dimensions of minimum chamber profile.
8. Location of holes with dimension Я4 should be checked by gauge with dimensions as follows:
   - Diameter of measuring rod should be atleast 3.4 MM ;
   - Base distance should be (0,2±0,02) MM ;
   - Slope of measuring rod should 45°±5'.
9. The following is allowed :
   a) Presence of marks with a depth upto 0,1 MM on external and internal surfaces except surface E as against the standard sample;
   b) Presence of burrs on the edges of surface Y as against the standard sample;
   c) Presence of thread marks on surfaces as against the standard sample;
   d) ~~Spalling~~ Spoiling of the crests of thread HO totally not exceeding 0,5 of turns;

..... Contd.

DATE	AUTHORITY	REVISION	SIG. AHSP.	SIG. D.O.
24 9-87	DCI.34241-A	DRG. PROV. SEALED.		

APPROVED.

FOR CI(A)

AHSP:- CI(A) KIRKEE.

	SHT	DOC NO	SIGN	DATE
DRAWN				
TCHKD				
DC.				
OFFR				

3-0126082 | A3-BT-84

ВШ8.036.077 | Sheet No. 2 | No. of Sheet 3

BODY

TF-007 SHT-2

SHEET | WEIGHT | SCALE

TOTAL SHEETS

ORDNANCE FACTORY PROJECT HYDERABAD

Designation	Coating	Thread A after coating	Thread Б after coating
БШ8.036.077	Sn 3 ~~Cd 3~~ cadmium 9 microns thick chromatized. ~~It is allowed~~ The absence of cadmium coating is allowed ~~coating~~ on inner surfaces of parts. In this case the places uncoated with tin are not allowed. Under layer of tin with a thickness not less than 2 MKM is allowed.	Cn M18x0,75LH-7H** d = 18,960, d_2 = 17,473, d_1 = 17,148 } Min	M18x0,75-7h6h d = 18,000, d_2 = 17,513, d_1 = 17,188 } Max
-01	Coating Cu3.Sn3 alloy. Cu Zn (70%) 3. Sn 1 is allowed.	—	C M17,96x0,75-7h6h d = 17,960, d_2 = 17,473, d_1 = 17,148 } Max

e) The mark of tool with diameter upto 1,5 MM on surface ϕ and ~~reg~~ with diameter not exceeding 1,5 MM or rounding off with radius not more than 1 MM at the point Γ;

f) Deviation from coaxiality of surface ∂ ~~relatively~~ relative to major diameter of thread M while performing the thread by rolling;

g) One-side clearnce not exceeding 0,2 MM between the edges of thread calibre and surface $И$ while checking the thread M;

h) Reduction of major diameter thread M upto dimension 17,73 MM;

i) Reduction of dimension A_I upto 19,6 MM at 0,2 of circumference length;

j) Increase in diameter $Б_I$ and upto 17,1 MM;

k) Increase in diameter B_I upto dimension 3,52 at a depth upto 1,5 MM from surface $П$;

l) Passing of working surface of no-go gauge at a depth not exceeding 2,5 MM while chekcing the thread ~~Б~~ 10

m) To change the dimension of type, distance between signs and sign round by manufacturing plant as per the agreement with customer representative at manufacturing plant;

n) Standard samples are established by manufacture and agreed with customer representative at manufacturing plant.

10. These requirments are as per GST B 84-264-81.

*11. INDIGENOUS MATL:- IS:4431 1978 REAFFIRMED 2004 GRADE 14C14S14 IN COLD DRAWN CONDITION. AUTHORITY:- CQA L/No.- QA13A715/FZ/IND/MATL., Dt-02/07/010

08/11/2010	D.C No. 37271-A	NOTE No. 11 ADDED IN SHEET No. 3.			
24-9-87	DCI.34241-A	DRG. PROV. SEALED.			APPROVED.
DATE	AUTHORITY	REVISION	SIG. AHSP.	SIG. D.O.	AHSP:- CI(A)

3-0126082	A3-BГ-84	
БШ8.036.077	Sheet No. 3	No of Sheet 3
Body		

TF-007 SHT-3