



SURFACE ROUGHNESS $\mu\text{m}^{3.2}$ SHARP EDGES BROKEN 1.0-1.5

P.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	REMARKS
GEN. TOL NOT SPECIFIED						FOR Sr. G.C.Fy.
LINEAR DIMENSIONS						2015 NAME DATE
0-6	±0.1					DRN. SOBAN 24/09
6-30	±0.2					CKD. S.K.JAIN 23/10
30-120	±0.3					
120-315	±0.5					
315-1000	±0.8					
1000-2000	±1.2					
ANGULAR DIMENSIONS						
0-10°	±1'					
10-50°	±30'					
50-100°	±20'					
>100°	±10'					
INDEX	AMENDMENTS	SIGN	DATE	APPROVED		
UNMACHINED						
ROUGH						
SMOOTH						
FINISH						
SPRING						MATERIAL IS: 6911-1992, Design X07Cr18Ni9, Cond. Work Hardened to achieve Rp0.2 = 980 MPa min., Rm = 1080-1320 Mpa
GUN CARRIAGE FACTORY, JABALPUR						SCALE REF.DRG.NO.
DRG. No. 4 083 328						ASSY/SUB ASSY NO. 1156267
SHEET NO. OF SHEETS						