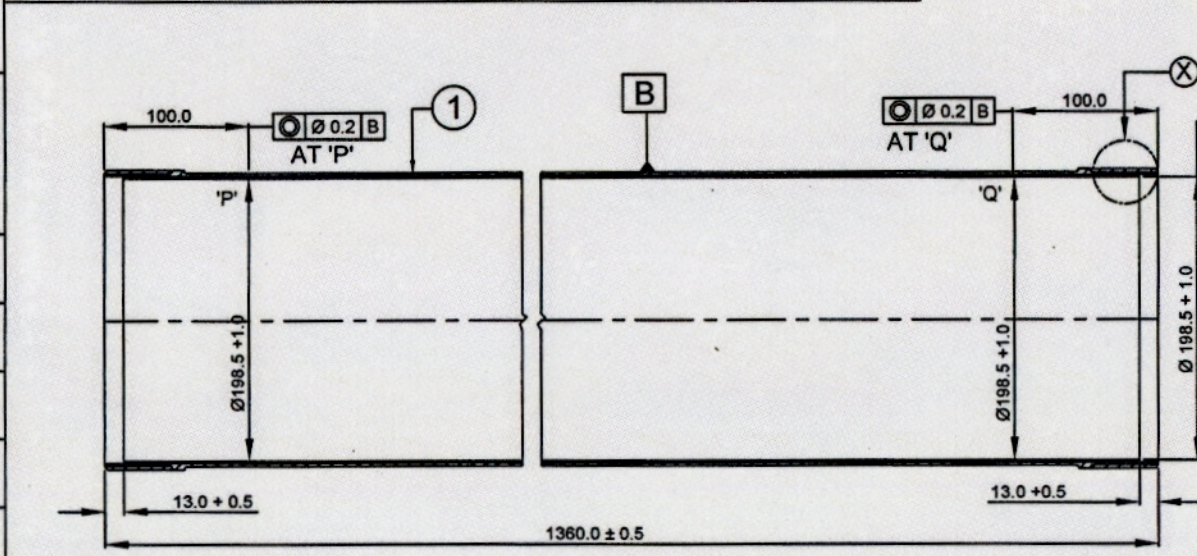


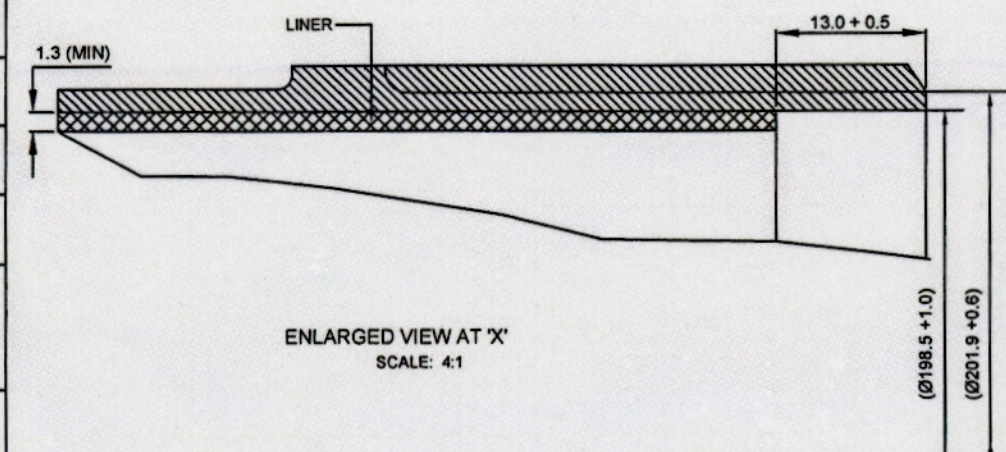
1 2 3 4 5 6 7 8

DRG No. 8603 02 01 04 00 00 1 0 0 D D
 GEN TOL: MEDIUM CLASS TO IS:2102
 DRG CONVENTIONS CONFORM TO INDIAN STD.
 DIM IN mm UNLESS OTHERWISE STATED

LIST OF COMPONENTS		DRAWING NUMBER		QTY.
SL. No.	NOMENCLATURE			
1	MOTOR TUBE	8603	02010400000100DF	1



- NOTES:
- INTERNAL SURFACE OF THE LINING SHOULD BE SMOOTH
 - LINING SHOULD BE FREE FROM BLISTERS, CRACKS, VOIDS AND DEBONDING ETC.
 - LINING MATERIAL HIGH SILICA PHENOLIC COMPOSITE MADE FROM PRE-PREG USING FOLLOWING RAW MATERIALS -
 - (i) HIGH SILICA FABRIC TO ISROSIL GRADE OR EQUIVALENT
 - (ii) PHENOLIC RESIN IVP IVAREZ ISRO GRADE, PR-100 WS OR EQUIVALENT PHENOLIC RESIN PR-100 WS IS MANUFACTURED AT M/s ABR ORGANICS PVT. LTD., HYDERABAD
- * FOR SPEC SEE QA/QC DOCUMENT No. ARDE/SPECN/PINAKA/RKT-02
- PROPERTIES OF PREPREG
 - (i) SOLID CONTENT : 35 ± 3%
 - (ii) VOLATILE CONTENT : 10 ± 3%
 - (iii) FIBRE CONTENT : 58 ± 4%
 - AFTER CURING THE LINER MATL SHOULD HAVE
 - DENSITY : 1.5 ± 0.1g/cc
 - RESIN CONTENT : 32 ± 2%
 - NOT TESTS IN RESPECT OF LINED TUBES TO BE DONE BOTH FOR INTERNAL DEFECTS AND BONDING FOR QUALIFICATION AS PER QUALITY ASSURANCE AND QUALITY CONTROL DOCUMENT No. ARDE/SPECN/PINAKA/RKT-02.
 - THE MOTOR TUBE SHALL BE LINED FOR THE FULL LENGTH. AFTER CURING 13.0 + 0.5mm LENGTH LINER HAS TO BE REMOVED FROM EITHER END OF THE TUBE BY CAREFUL MACHINING.
 - LINER THICKNESS HAS TO BE MIN 1.3mm. IT SHOULD BE MEASURED FROM END CUTTING LINER PIECE.
 - ACCEPTED LINED MOTOR TUBE TO BE PAINTED AS GIVEN IN QAP No. ARDE/SPECN/PINAKA/RKT-02.



3	16/05/11	CRC MEETING	MOTOR TUBE DRG. No. CHANGED & NOTE Sr. No. 7 ADDED.	A-C-5,8
2	29/12/06	PRC No-38	NOTE No. 3,4 & 5 MODIFIED	6-8,C
1	03/11/2K	PNK/RKT/PRP/DRG/AMEND-1	NOTE No. 3 & 4 MODIFIED & NOTE No. 5 ADDED STRAIGHTNESS VALUE 0.15/450 WAS 0.25. CONCENTRICITY TOL. DELETED AND ADDED AT 100.0 mm DISTANCE ON EITHER END [0.1B] DELETED	6-B A-D 6-D 2-B,C 5-B,C
	MAR 99	A/RKT/17	DRG REFORMED FROM OLD DRG. No. ARDE/SK/3284 DET 10 2 SHEETS SHT No.1	

R No	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO
						SIGN
DRN	P K SINGH		MATERIAL : SEE NOTE -3			
APPD	DATE 30/3/12 FOR DIRECTOR		PROTECTIVE FINISH :			
SCALE	EST MASS	TITLE				
1:2	17.5 +1.0 Kg.	MOTOR TUBE (LINER ASSEMBLY)				
DESIGN AUTHORITY	ARDE					

DRG No. 8603 02 01 01 04 000 00DD
 PART No. DS CAT No. AHSP

1 2 3 4 5 6 7 8

Appendix - F