



CHARGE NR. STAMP Z13-5-5A  
CASTING 3052979 Z13-2-10A

MANUFACTURING SPECIFICATION A2003 AND 0804092  
DIMENSIONS GIVEN REGARDING WALL THICKNESSES ARE MINIMUM  
CASTING TOLERANCE ACCORDING TO SS 722 GTA 16-18  
CASTING RADIUS 3 APPLIES UNLESS OTHERWISE STATED.  
THE AREAS OTHER THAN SPECIFIED ARE TO BE TESTED FOR RADIOGRAPHY LEVEL 3.

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

MAIN MATL. - SS 2225-24, WEIGHT- 40.5 Kg.

PT.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	SIZE	REMARKS
GEN. TOL. NOT SPECIFIED							FOR SP. GM G.C.Fy.
LINEAR DIMENSIONS							2014 NAME DATE APPROVED
0- 6	±0.1						
6- 30	±0.2						
30- 120	±0.3						
120- 315	±0.5						
315- 1000	±0.8						
1000- 2000	±1.2						
ANGULAR DIMENSIONS							HOS/ODC
0°- 10°	±1°						
10°- 50°	±30'						
50°- 100°	±20'						
> 100°	±10'						
INDEX							SEC. M/C JWM/TR
AMENDMENTS							SCALE REF. DEM.
SIGN DATE							NTS. REF.DRG.No. 3052979 3052358
CASTING FOR HOUSING RIGHT 155mm DHANUSH							DRG.No. GCF/50/39476
GUN CARRIAGE FACTORY, JABALPUR							SHEET NO. OF SHEETS

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