

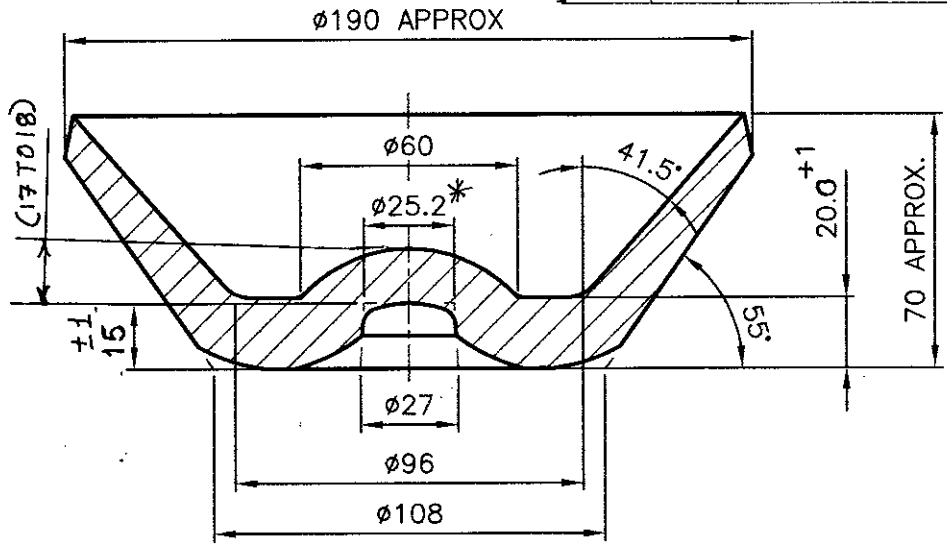
DRG. NO : **CC-508 D**

TOLERANCE ON UNTOLERATED DIMNS. ARE AS PER IS: 2102, MEDIUM CLASS

FOR TRADE ONLY

A M E N D M E N T S

REV.	DATE	DESCRIPTION	SIGN.
A 87/09	3/4/09	DIM (17 TO 18) & AT DIS. 40 TO 50 FROM BOTTOM ARE ADDED	DGM/CCS
B 98/09	19/09/09	DIMN. 15 ± 1 WAS 15 & NOTE NO. -7 ADDED	DGM/CCS
C 08/2010	16/02/10	IN NOTE NO -1, WALL THICK VARIATION 0.3 MAX WAS 0.2 MAX.	JGM/CCS
D 18/2016	30.01.16	DIMN. 20.0 ⁺¹ WAS 20.5 ⁻¹	DGM/CCS



NOTE:

- 1) WALL THICKNESS VARIATION = **0.3 MAX.** AT DIS. 40 TO 50 FROM BOTTOM
- 2) WEIGHT - 4.6 Kg APPRX.
- 3) HARDNESS AFTER ANNEALING 95 TO 120 VPN (10Kg Load)
- 4) ANNEALING SCHEDULE = ANNEALING TEMP. $645^\circ\text{C} \pm 10^\circ\text{C}$
(for Guidance only) SOAKING TIME = 2 HOURS.
COOLING TIME = 2 HOURS (IN FURNANCE)
- 5) MATERIAL SHOULD BE HANDLED CAREFULLY ENSURING THERE SHOULD NOT BE ANY DASH/SCRATCH MARK ON EITHER SURFACE OF BLANK
- 6) MATERIAL TO BE SCALE FREE AFTER ANNEALING.
- 7) DIMENSIONS MARKED * FOR REFERENCE ONLY NOT FOR GAUGING.

DIMENSIONS ARE IN mm			MATERIAL : AS PER CC-417 (LATEST ISSUE)		ORDNANCE FACTORY AMBAJHARI	
THIRD ANGLE PROJECTION			NOMENCLATURE :			
SCALE : 1 : 2			PRE CUP BLANK (ANNEALED)		DRG. NO : CC-508 D	
2009	NAME	DATE			SHEET NO : 1	
DRAWN	VASU				NO. OF SHEETS : 1	
CHECKED	[Signature]	16.01.09			OPERATION NO :	
JWM/CCD	[Signature]	16.01.09			COMPT. : CART. CASE ARDE 2286	
APPVD.	WM/CCS	[Signature]	MACHINE :	76.2mm NA		