

- 1. * DIMENSIONS ENSURED BY TOOL.
- 2. ** DIMENSIONS ARE SUBJECTED TO TOTAL CHECKING
- 3. PERFORM MACHINING OF A VERY GIVEN GROUP OF SURFACE ONCE CLAMPED ONLY
 - (a) b,G, D.F, K, H, Y,U.W.X E
 - (b) P C
 - (C) E X
- COATING SHOULD BE IN COMPLIANCE WITH TABLE.
- 5. MARK BY STAMPING OR BY PRESSING IN TYPE 2 ON SURFACE 8 AT A DISTANCE 2....8 MM FROM SURFACE TO N IN COMPLIANCE WITH ASSEMBLY DRAWING REQUIREMENTS.
- 6. CHECK EXTERNAL DIAMETER OF THREAD M BY SMOOTH SNAP GAUGE OF THICKNESS 4mm, CHECKING IS DONE BY THE HOLE WIDTH OF WORKING SURFACE OF SNAP GAUGE.
- 7. THE PROFILE OF CHAMBER, FORMED WITH SURFACES U, V, W, W IS TO BE BHECKED BY GAUGE WITH DIMENSIONS OF MINIUM CHAMBER PROFILE
- B. LOCATION OF HOLES WITH DIMENSION R SHOULD BE CHECKED BY GAUGE WITH DIMENSIONS AS FOLLOWS:-
 - DIMETER OF MEASURING ROD SHOULD BE ATLEST 3.4mm.
 - BASE DISTANCE SHOULD BE (0.2 ±0.02mm),
 SLOPE OF MEASURING ROD SHOULD 45*±5'.

DESIGNATION	COATING	THREAD A AFTER COATING	THREAD & AFTER COATING
NAI (J) 501/1	Sn 3 CADMIUM 9 MICRONS THICK CHROMATIZED, THE ABSENCE OF CADMIUM COATING IS ALLOWED 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 M13, $96 \times 0.75 LH-7H**$ $D = 13.960 MIN$ $D_2 = 13.473 MIN$ $D_1 = 13.148 MIN$	$M18 \times 0.75 - 7h6h$ $d = 18.000 \text{ MAX}$ $d_2 = 17.513 \text{ MAX}$ $d_1 = 17.188 \text{ MAX}$
-01	COATING Cu3. Sn3 ALLOY. Cu Zn (70%) 3. Sn 3 IS ALLOWED.		$M17.96 \times 0.75 - 7h6h$ d = 17.960 MAX $d_2 = 17.473 \text{ MAX}$ $d_1 = 17.148 \text{ MAX}$

9. THE FOLLOWING IS ALLOWED.

- (a) PREASENCE OF MARKS WITH A DEPTH UPTO 0.1MM, ON EXTERNAL AND INTERNAL SURFACES EXCEPT SURFACE E AS AGAINST THE STANDARD SAMPLE.
- (b) PRESENCE OF BURRS IN THE EDGES OF SURFACES Y AS AGAINST THE STANDARD SAMPLE.
- (C) PRESENCE OF THREAD MARKS ON SURFACES AS AGAINST THE STANDARD SAMPLE.
- (d) SPOILING OF CRESTS OF THREAD C TO TOTALLY EXCEDING 0.5 OF TURNS
- (e) THE MARK OF TOOL WITH DIAMETER UPTO 1.5MM ON SURFACE Ø 6 D AREA WITH DIAMETER NOT EXCEEDING 1.5MM OR ROUNDING OFF WITH RADIUS NOT MORE THAN 1MM AT THE POINTS ...
- (f) DEVIATION FROM COAIALITY OF SURFACE F RELATIVE TO MAJOR DIAMETER OF THREAD M WHILE PERFORMING THE THREAD BY ROLLING
- (9) DNE-SIDE CLEARNCE NOT EXCEEDING 0.2MM BETWEEN THE EDGES OF THREAD CALIBRE AND SURFACE WHILE CHECKING THE THREAD M.
- (h) REDUCTION OF MAJOR DIMETER THREAD M UPTO DIMENSION 17,73M 1.
- (i) REDUCTIO OF DIMENSION A1 UP TO 19.6MM AT 0.2 OF CIRCUMFERE CE LENGTH.
- (j) INCREASE IN DIAMETER **b**1 AND H UP TO 17.1MM.
- (k) INCREASE IN DIAMETER \bar{B}_1 UP TO DIMENSION 3.52 AT A DEPTH UP TO 1.5MM FROM SURFACE
- (I) PASSING OF WORKING SURFACE BY NO-GO GAUGE AT A DEPTH NOT EXCEEDING 2.5MM WHILE CHEKCING THE THREAD
- (m) TO CHANGE THE DIMENSION OF TYPE, DISTANCE BETWEEN SIGNS AND SIGN GROUPS BY MANUFACTURING PLANT. AS PER THE AGREEMENT WITH CUSTOMER REPRESENTATIVE AND MANUFACTURING PLANT. THE STANDARD SAMPLES ARE ESTABLISHED BY MANUFACTURE AND AGREEMENT WITH CUSTOMER REPRESENTATIVE



