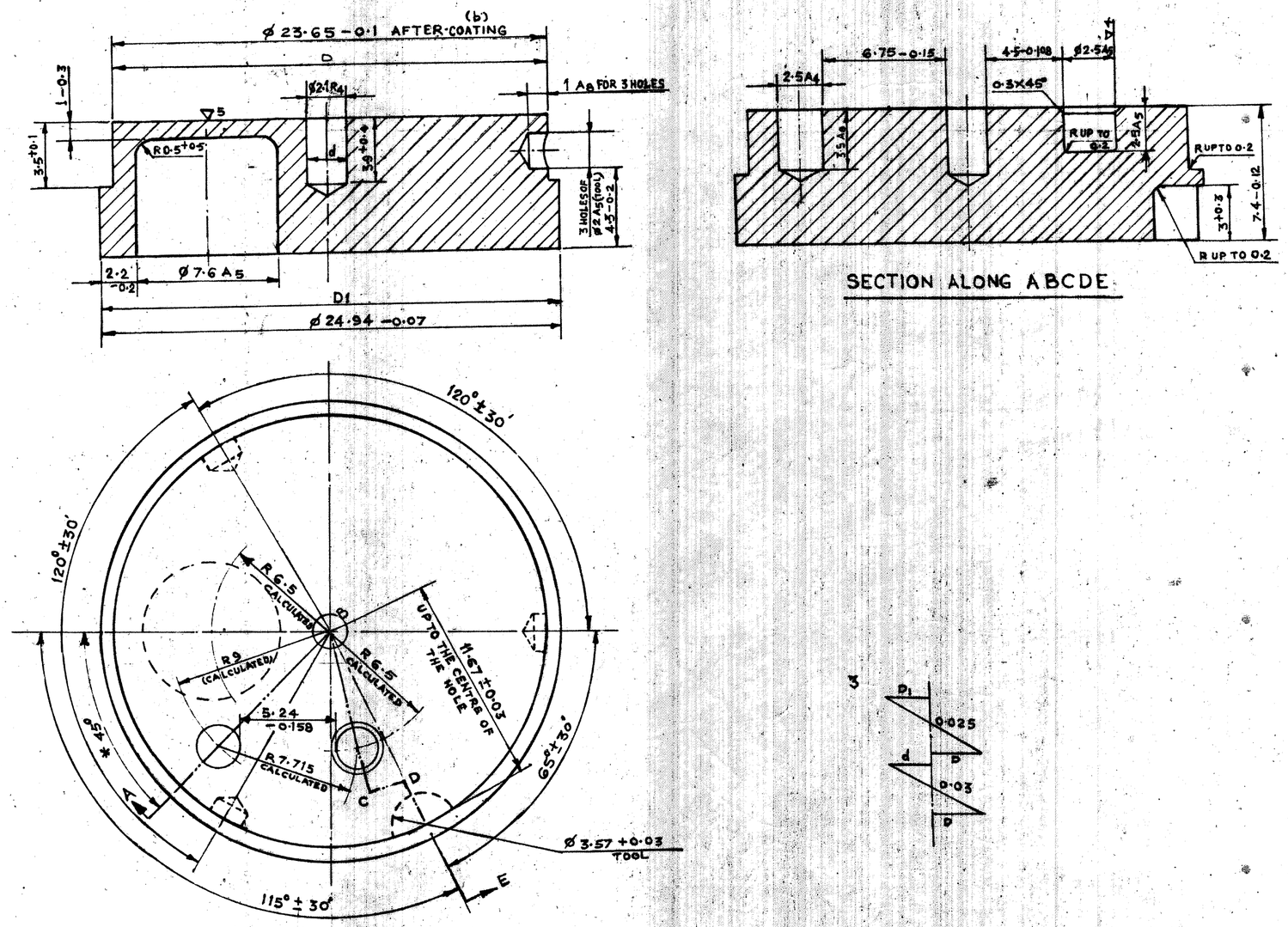
20 | 3-016919

D.C.I. 28794-A

∇3 IF NOT STATED OTHERWISE

"PROTECTIVE TREATMENT IN INDIA TO BE ZINC PLATED TO SPECIFICATION NO. DTD 903 OR CADMIUM PLATED TO SPECN DTD 904 FOLLOWED BY CHROMATE PASSIVATION TO SPECN DEF. 130"



1. A TAPER BOTTOM OF CONE ANGLE OF 150° MIN. FROM THE TOOL IS PERMISSIBLE AT THE BOTTOM OF THE HOLE ø2·5 A5.
2. LOCAL DEPRESSION NEAR THE HOLE OF ø 2 A5 IS PERMISSIBLE ON THE CYLINDER OF ø 23·65
*3. THE ANGLE OF 45° TO BE CHECKED WITH 'GO' GAUGE HAVING THE FOLLOWING DIMENSION a) GROOVE BELOW THE EXTERNAL DIAMETER OF THE PART 24·96 b) CAVITY (FOR THE STEP) OF 2·515 SITUATED AT AN ANGLE OF 45°±2' TO THE COMMON AXIS OF THE CAVITY 24·96 AND HOLE ø 7·6 c) STUDS OF ø 2·488 AND 7·56 FOR HOLES OF ø7·6 A5 AND 2·5 A4 d) HOLE ø7·6 FOR THE STUD ø 7·56
4. DIMENSION 4·3 −0·2 MAY BE CHANGED BY THE DIMENSION OF THE CROSS PIECE 1 +0·2 FROM THE TOP CUT TO THE HOLE ø 2 A5 (TOOL)
5. THE PART MAY BE USED AFTER DISSEMBLY OF ASSEMBLED UNITS HAVING A HOLE FOR THE AXLE ø2·17
6. THE ANGLE OF THE CONE AT THE BOTTOM OF THE HOLES ø2·1 A4, ø2 A5 (TOOL) AND ø2·5 A4 IS EQUAL TO 116° TO 120° (TOOL)
7. PERMISSIBLE MATERIAL STEEL 55-40 GOST 1050-60 AND STEEL 85B TY 2784 ГАУ
8. PERMISSIBLE COAT 43 Xp.
9. LACQUIRING - SEE PREVIOUS SHEETS
10. SURFACE FINISH OF TOP SURFACE OF SLEEVE FOR STEMMING, COMING IN CONTACT WITH BOTTOM SURFACE OF ROTOR SLEEVE, SHOULD BE MAINTAINED AT 0·8 MICRON.

MATL:- STEEL TO SPECN. B S: 970 : PT 1: 1983 080 M40 (NORMALISED) OR BS: 970 PT.-3 1991 GDE. 212 M36 (NORMALISED) (SAME AS BS: 970 PT.-1 1983)

D. S. Cat No. 1390-000285

ORDNANCE FACTORY AMBAJHARI		
1996	NAME	DATE
TRACED	Hingot	
CHECKED	[signature]	24/7/96
JWM/DO.	[signature]	25/7
DGM/QA	[signature]	05/08/96

(b)	1	6·7·11	DC. 37284-A	MATERIAL AMENDED	
	3	3·3·97	DC 36252-A	NOTE NO. 6 AMENDED	
	4	25·11·88	34489-A	NOTE 10 Added	
		11·2·88	34325-A	D.S. Cat. No. Added	
		21·4·85	D.C.I 33748-A	PROTECTIVE TREATMENT NOTE AMENDED	
		3·5·82		TRACED WITHOUT CHANGE	
				PREVIOUS D.O(I) NOS 28794-A, 29162-A, 29221-A, 29306-A, 31022-A & 32177-A.	SD/- SD/-
		DATE	AUTHORITY	REVISION	AHSP D.O. SIGN

3-016919 | 53-B-025Y

SLEEVE FOR STEMMING

20

LETTER	MASS	SCALE
	24	5:1

MATL: AS PER NOTE 7 ABOVE | SHEET:— | TOTAL SHEETS

C.D'MAN	DRN.	CHD.	TCD.	COMP.
[signature]			MRS	[signature]

FZ-B429

B 429

1440