

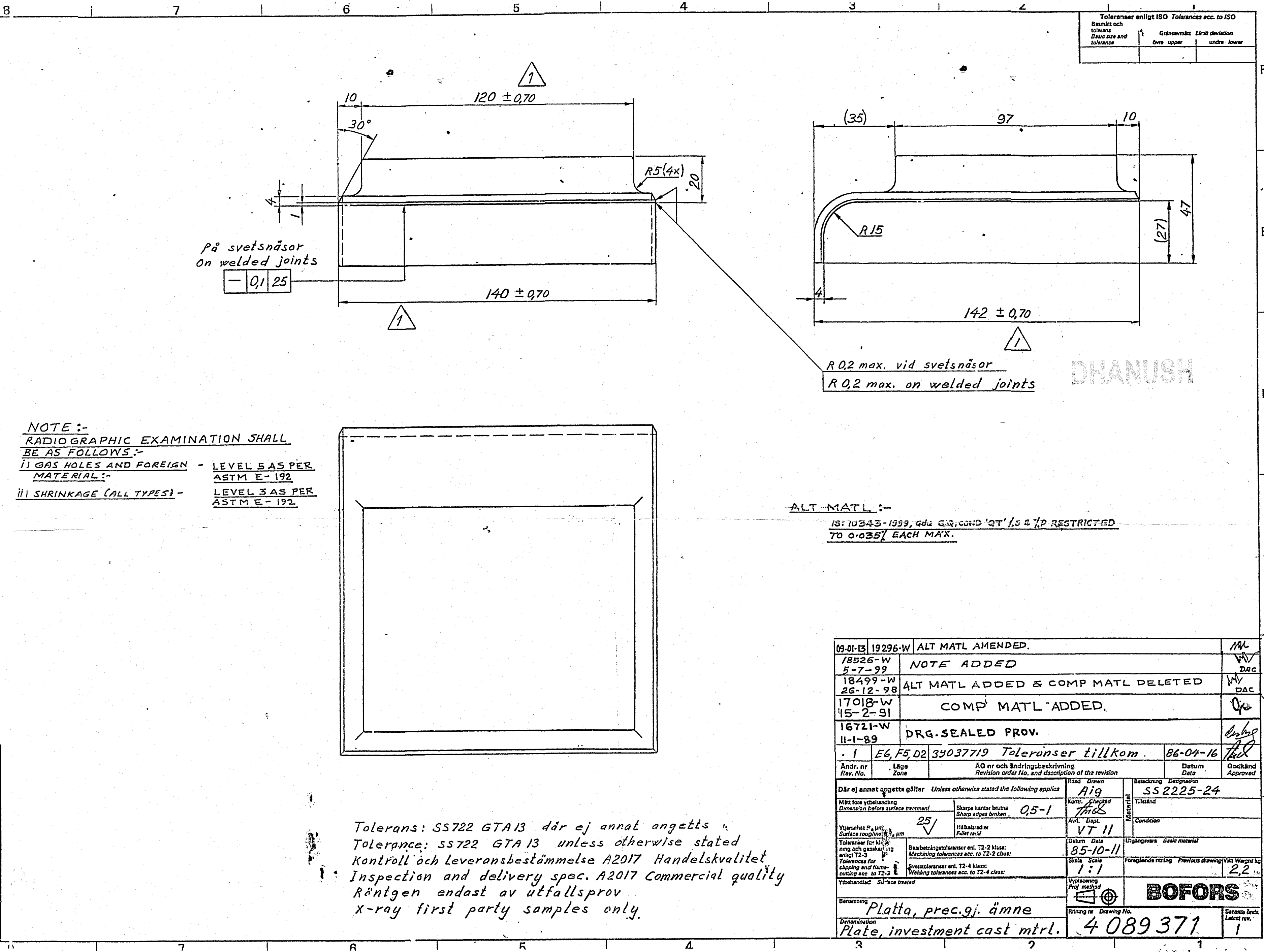
Komponentens konstruktion, mått och material skall vara sådana att den kan tillverkas enligt de tekniska bestämmelserna för de material som används. Övervakning kommer att beivras.

RÄNTGEN
 FOTOGRAFERA

The drawing is to be read in accordance with the drawing of Attachment 1. Any change in the drawing shall be made in accordance with the drawing of Attachment 1.

Ritning nr. Drawing No.
4 089 371

Skapad av
 1



På svetsnåsar
 On welded joints
 - 0,25

NOTE :-
RADIOGRAPHIC EXAMINATION SHALL
BE AS FOLLOWS :-
 I) GAS HOLES AND FOREIGN MATERIAL :- LEVEL 5 AS PER ASTM E-192
 II) SHRINKAGE (ALL TYPES) :- LEVEL 3 AS PER ASTM E-192

R 0,2 max. vid svetsnåsar
 R 0,2 max. on welded joints

ALT. MATL :-
 IS: 10343-1999, gda G.R, COND 'QT' / 0.2 / P RESTRICTED
 TO 0.025% EACH MAX.

Tolerans: SS722 GTA13 där ej annat angetts
 Tolerance: SS722 GTA13 unless otherwise stated
 Kontroll och Leveransbestämmelse A2017 Handelskvalitet
 Inspection and delivery spec. A2017 Commercial quality
 Röntgen endast av utfallsprov
 X-ray first party samples only.

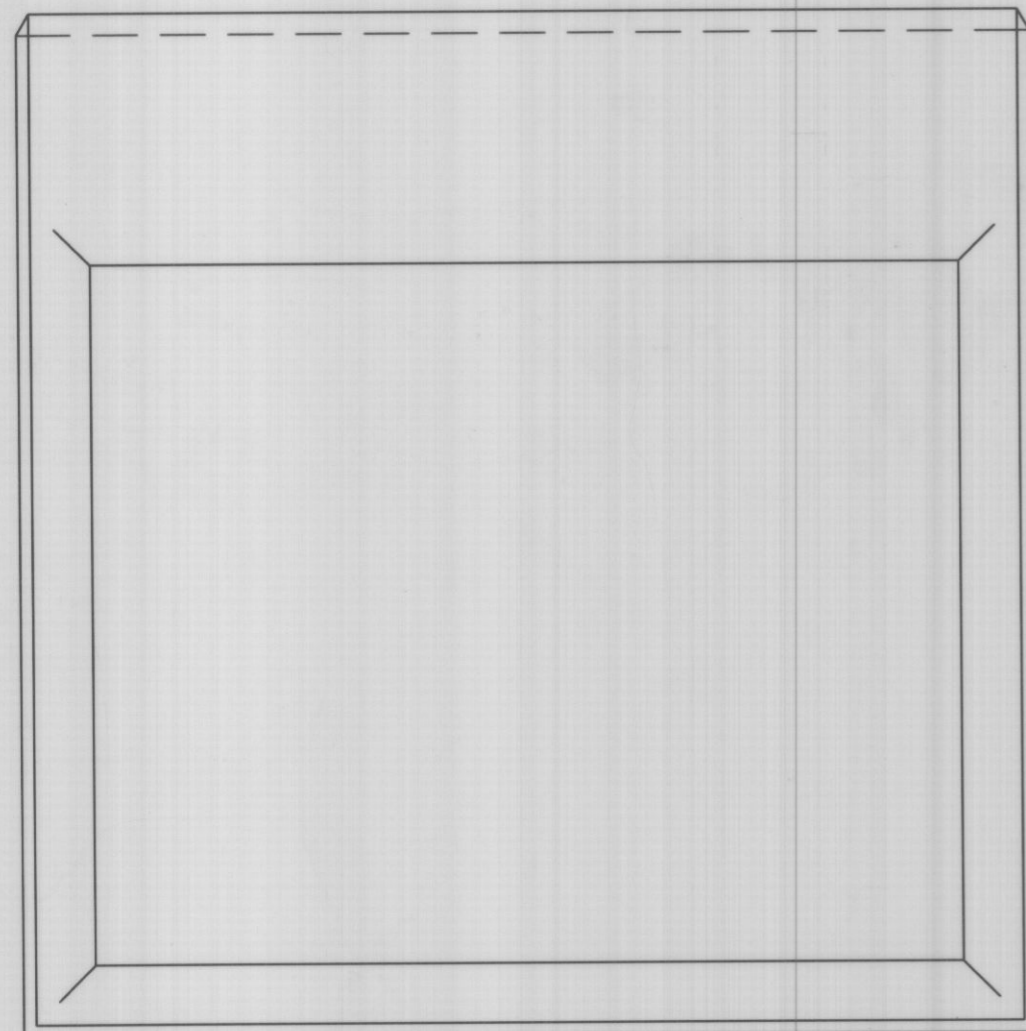
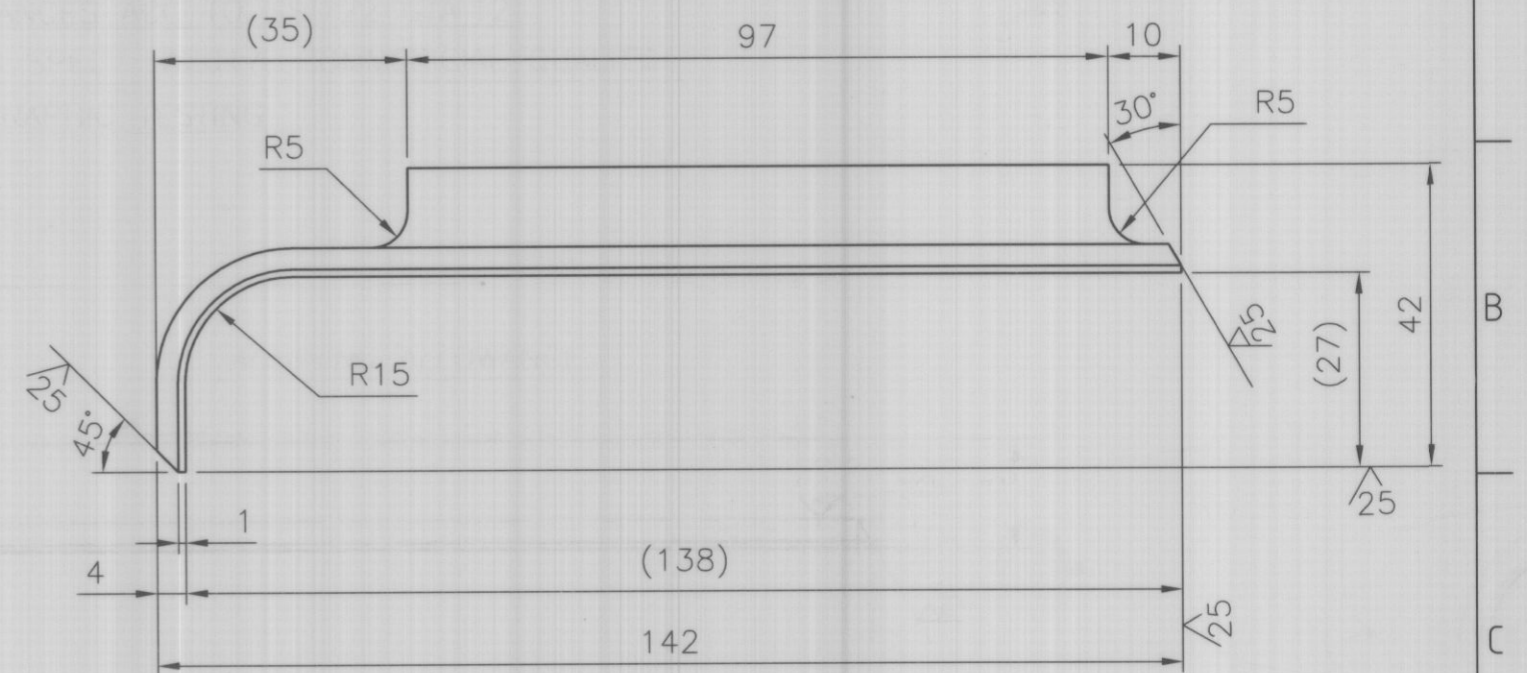
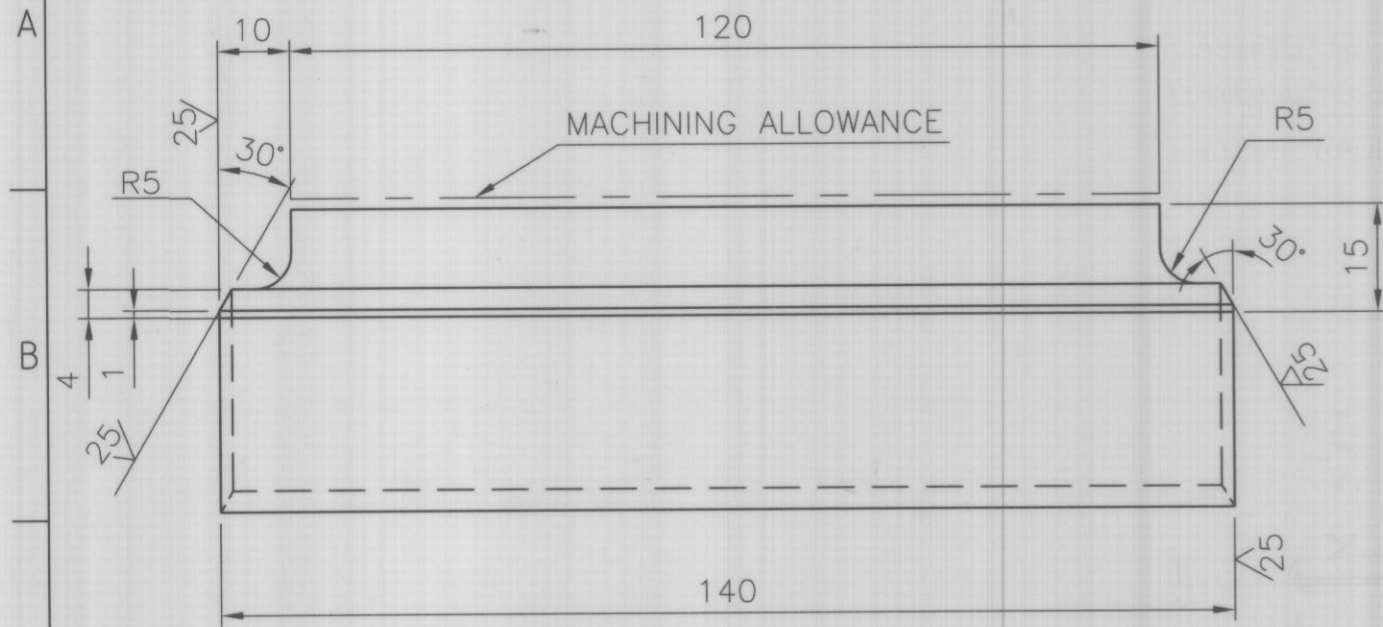
09-01-13	19296-W	ALT MATL AMENDED.			
18526-W	5-7-99	NOTE ADDED			
18499-W	26-12-98	ALT MATL ADDED & COMP MATL DELETED			
17018-W	15-2-91	COMP MATL ADDED.			
16721-W	11-1-89	DRG-SEALED PROV.			
1	E6,F5,D2	39037719 Toleranser tillkom.	86-04-16		
Andr. nr Rev. No.	Läge Zone	ÄO nr och Ändringsbeskrivning Revision order No. and description of the revision	Datum Date	Godkänd Approved	
Där ej annat angivits gäller - Unless otherwise stated the following applies			Ritad Drawn	Åtg SS 2225-24	
Mått före yttbehandling Dimension before surface treatment	Skarpa kanter brutna Sharp edges broken	0,5-1	Skala Scale	Titeländ Title end	
Ytjämnhet Ra µm Surface roughness Ra µm	Hålstrålar Hole radii	25/	Ändr. Läge VT 11	Material Material	
Toleranser för klippning och gämsning enligt T2-3 Tolerances for clipping and flame-cutting acc. to T2-3	Årskattningstoleranser enligt T2-2 klass: Machining tolerances acc. to T2-2 class:		Datum Date	Utlämningsvillkor Basic material	
Yttbehandling: SU-sce treated	Svetsoleranser enligt T2-4 klass: Welding tolerances acc. to T2-4 class:		Skala Scale	Ändringsvillkor Previous drawing	Välj utlämningsvillkor 2,2
Benämning Designation	Platta, prec.gj. ämne Plate, investment cast mtrl.		Ritning nr. Drawing No. 4 089 371	Sista rev. Latest rev.	1

DHANUSH

BOFORS

DRG. No. 5 175 362

\pt38;ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED



CASTING TOLERANCES ACC TO SS 722 GTA 12
 MANUFACTURING SPEC : A2017, COMMERCIAL QUALITY
 EXCEPT RADIOGRAPHIC TESTING

FOR CASTING SEE DRG. No. 4089371.

P.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	REMARKS
GEN. TOL. NOT SPECIFIED						FOR Sr. GM G.C.Fy.
LINEAR DIMENSIONS						2015 NAME DATE
0-6 ±0.1						DRN. SANJAY 17/07
6-30 ±0.2						CKD. S.K.JAIN 28/08
30-120 ±0.3						
120-315 ±0.5						
315-1000 ±0.8						
1000-2000 ±1.2						
ANGULAR DIMENSIONS	INDEX	AMENDMENTS		SIGN	DATE	APPROVED
0-10° ±1'						
10-50° ±30'						
50-100° ±20'						
>100° ±10'						
~ UNMACHINED	<h1>PLATE</h1>					MATERIAL IS: 10343-1999 Gde 8Q Cond 'QT' With %S & %P each 0.035 Max. to achieve Rp0.2 = 600 Mpa min., Rm = 800-950 MPa, El = 10%, HB = 235-285
▽ ROUGH						
▽▽ SMOOTH						
▽▽▽ FINISH						
						SCALE REF.DRG.NO.
						ASSY/SUB ASSY NO. 1144024
						DRG. No. 5 175 362
						SHEET NO. OF SHEETS

GUN CARRIAGE FACTORY, JABALPUR

DRG. No. 5 175 362

SHEET NO. OF SHEETS