



THE AREAS OTHER THEN SPECIFIED ARE TO BE TESTED FOR RADIOGRAPHIC LEVEL 3.

ASTM E 446-78, CLASS 2, GROUP A,B AND C
GROUP D, E, F AND G ARE NOT ACCEPTED.

ONE TENSILE TEST FROM SEPARATELY CAST TESTPIESE FOR EACH CHARGE.

APPROPRIATE CASTING CLEARANCE TO BE APPLIED.

CASTING TOLERANCE ACCORDING TO SS 722 GTA 16-18.

MANUFACTURING SPECIFICATION A 2003 AND 0804092.

FOR COMPONENT SEE DRG. No.- 2025499

OEM: MATERIAL:- SIS 2225-24, WEIGHT-N/A.

MATL.-IS:10343-1999, Gde-8Q; Cond 'QT' %S & %P
RESTRICTED TO 0.035% eACH MAX.

TO ACHIEVE Rp0.2 = 600 Mpa MIN.
Rm = 800-950 Mpa, EI= 10%
HB = 235-285.

(b1) * WEIGHT: 51 KGS.

PT.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	SIZE	REMARKS
GEN. TOL. NOT SPECIFIED							
FOR Sr:GM G.C.Fy.							
LINEAR DIMENSIONS							
0-6	±0.1					2014	NAME DATE APPROVED
6-30	±0.2					DRN.	SK JAIN 20.12.14
30-120	±0.3					CKD.	
120-375	±0.5						JWM/Shop
375-750	±0.8						
750-2000	±1.2						
ANGULAR DIMENSIONS							
INDEX	AMENDMENTS			SIGN	DATE	HOS/DDC	JWM/TR
0°-90°	±1°						
90°-54°	±30'						
54°-90°	±20'						
> 90°	±1°						
UNMACHINED ▽ ROUGH ▽▽ SMOOTH ▽▽▽ FINISH							
BRACKET (CASTING) FOR 155MM DHANUSH GUN CARRIAGE FACTORY, JABALPUR							
SEC. M/C							JWM/TR
SCALE NTS.							REF. DEM. REF.DRG.No. 2025651 (CAST)
DRG. No. GCF/50/39467							
SHEET NO. OF SHEETS							

CHARGE NR. STAMP- Z13-5-5A

2025500 CASTING NR.- Z13-2-10A