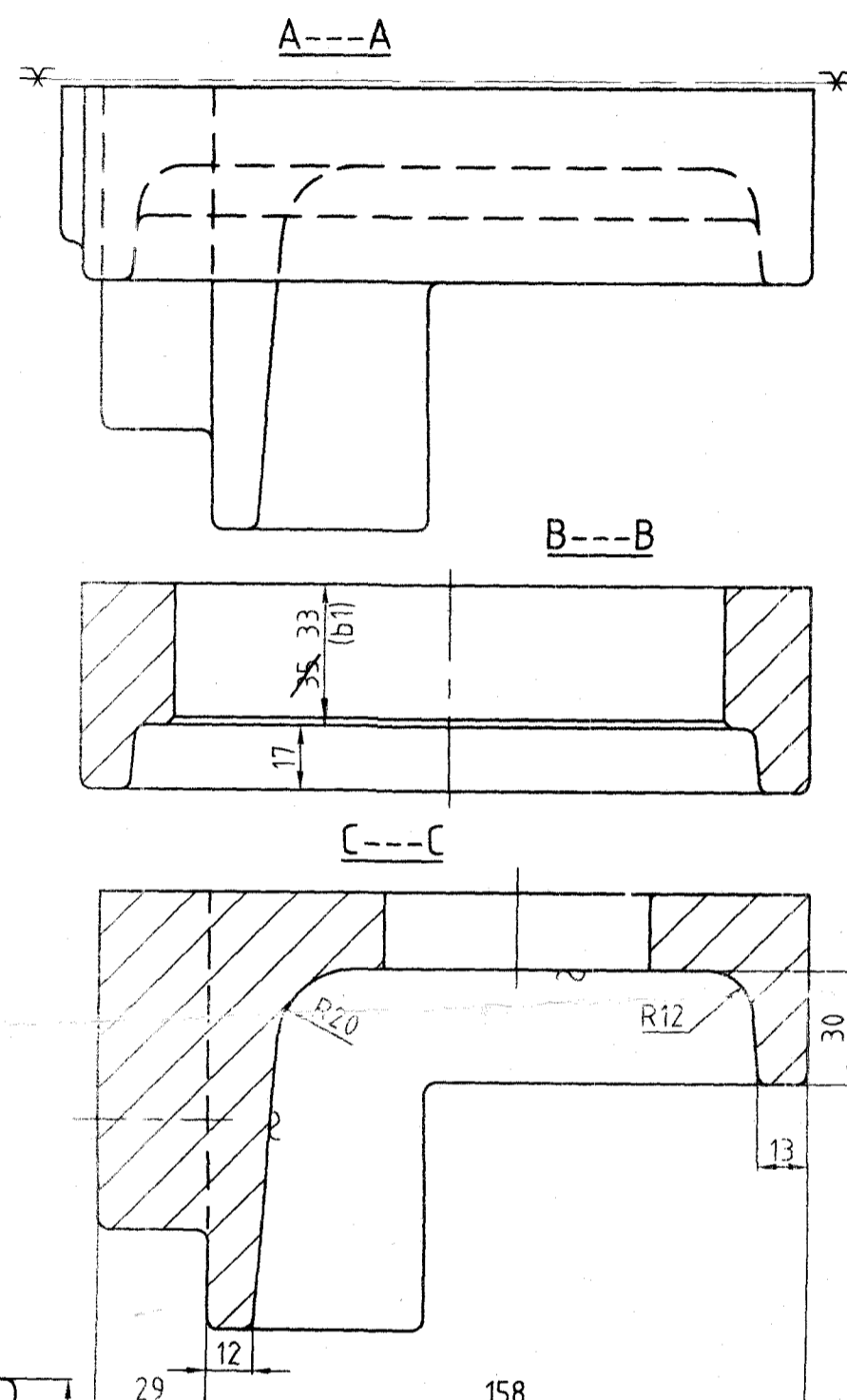
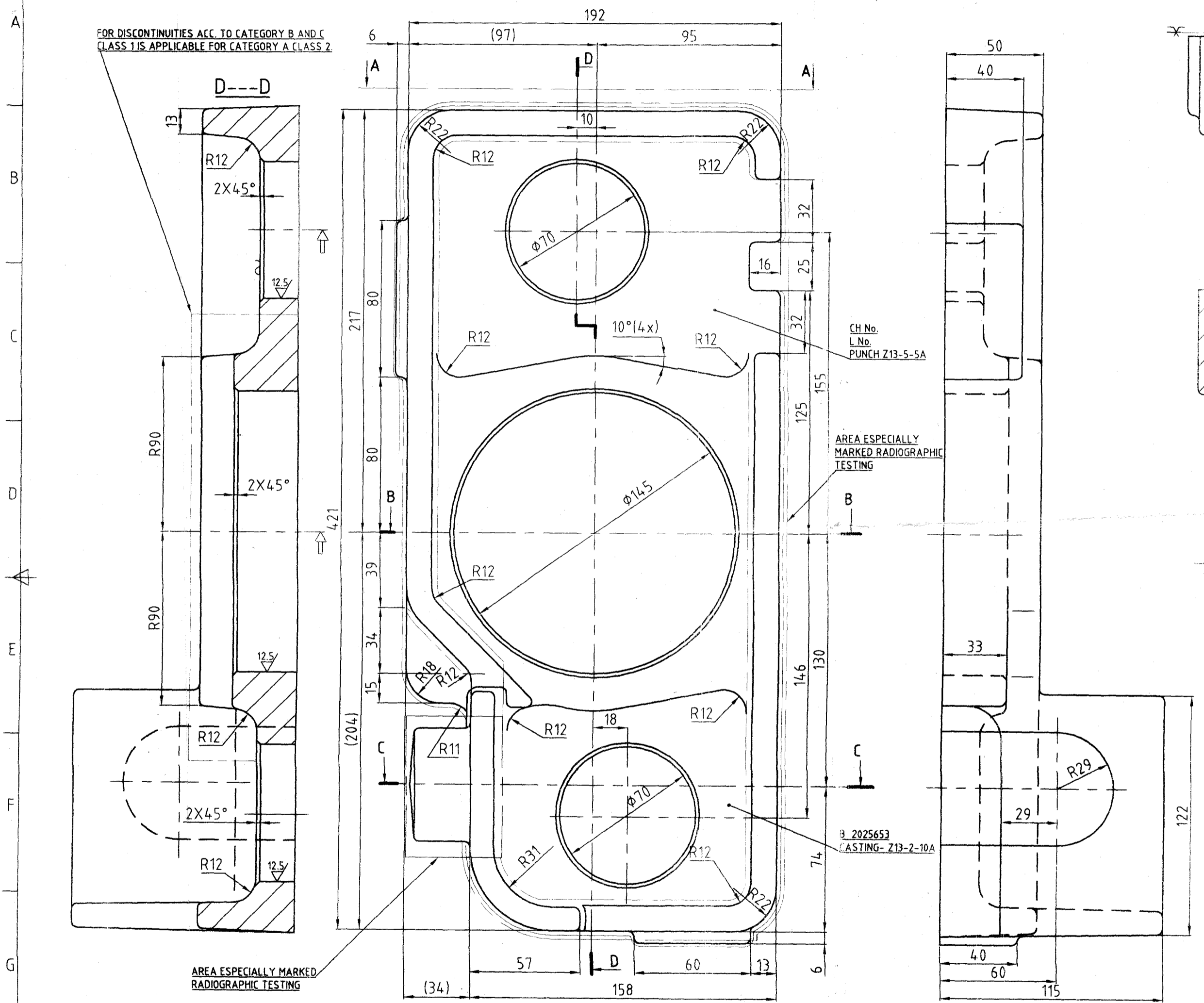


DRG. NO. GCF/50/39461

DRAWING CONVENTIONS CONFORM TO SP 46:1988  
DIMNS. ARE IN mm. UNLESS OTHERWISE STATED.

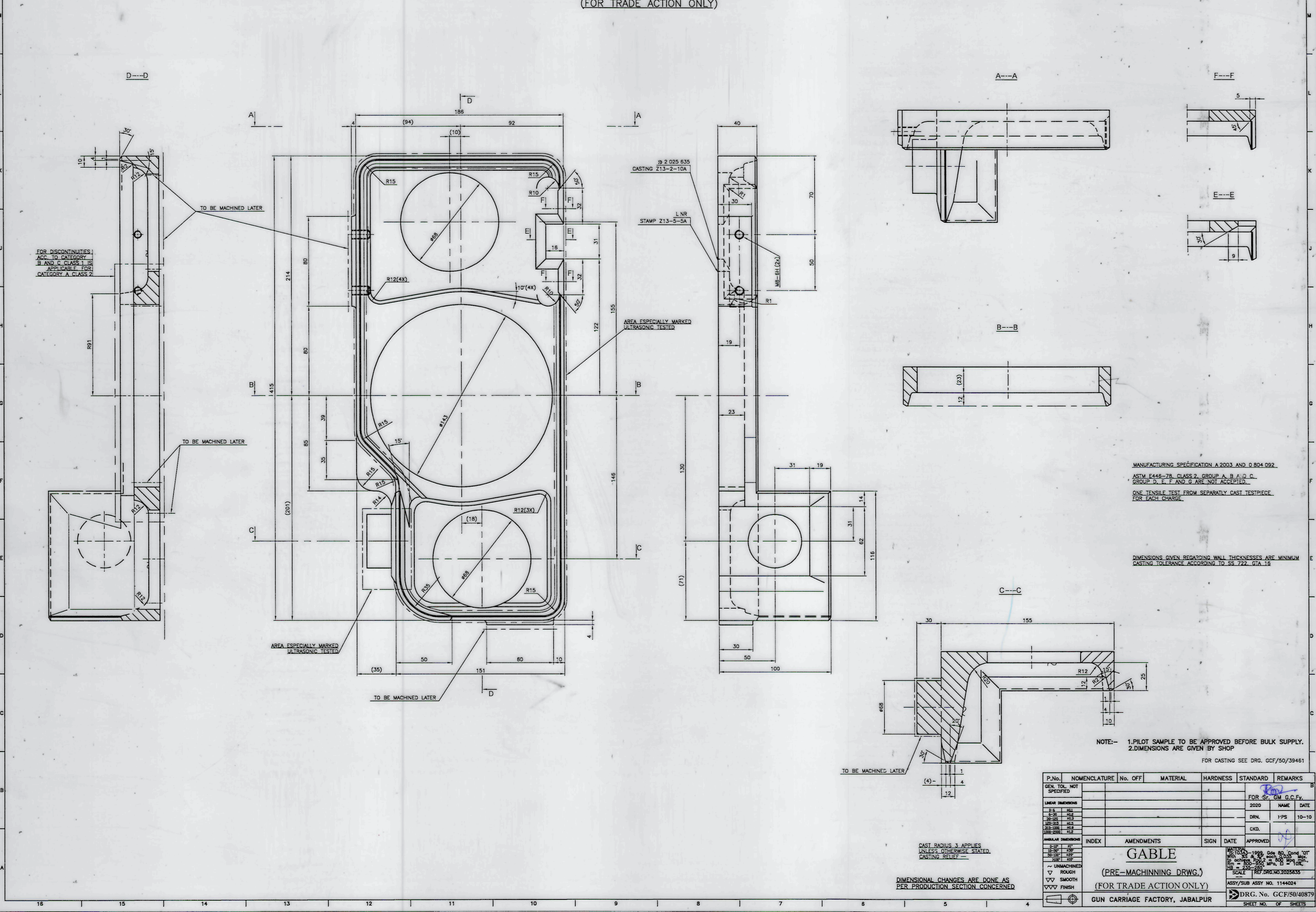


THE AREAS OTHER THEN SPECIFIED ARE TO BE TESTED FOR RADIOGRAPHIC LEVEL 3  
ASTM E 446-78, CLASS 2, GROUP A, B AND C  
GROUP D, E, F AND G ARE NOT ACCEPTED.  
ONE TENSILE TEST FROM SEPARATELY CAST TESTPIECE FOR EACH CHARGE.  
APPROPRIATE CASTING CLEARANCE TO BE APPLIED.  
CASTING TOLERANCE ACCORDING TO SS 722 GTA 16-18  
MANUFACTURING SPECIFICATION A 2003 AND 0804092.

DEM MATERIAL:- SIS 2225-24, WEIGHT- 14 Kg.  
MATERIAL:- IS:10343-1999, Gde 8Q, Cond 'QT' %S & %P  
TO STRICTED TO 0.025% eACH MAX. \* 2025635 (MACHINED DRG)

| PT.No.  | NOMENCLATURE | No. OFF | MATERIAL | HARDNESS | STANDARD | SIZE | REMARKS              |                |        |
|---|--------------|---------|----------|----------|----------|------|----------------------|----------------|--------|
| GEN TOL NOT SPECIFIED   |              |         |          |          |          |      |                      |                |        |
| LINEAR DIMENSIONS   |              |         |          |          |          | 2014 | NAME DATE APPROVED   |                |        |
| 30 - 61 ±0.1  |              |         |          |          |          |      | DRN SK JAIN 14.12.14 |                |        |
| 6 - 38 ±0.2   |              |         |          |          |          |      | CKD.                 |                |        |
| 31 - 28 ±0.3  |              |         |          |          |          |      | JWM/Shop             |                |        |
| 10 - 35 ±0.5  |              |         |          |          |          |      |                      |                |        |
| 37 - 300 ±0.8   |              |         |          |          |          |      |                      |                |        |
| 100-200 ±1.3  |              |         |          |          |          |      |                      |                |        |
| ANGULAR DIMENSIONS  |              |         |          |          |          |      |                      |                |        |
| 15° - 90° ±30'  |              |         |          |          |          |      |                      |                |        |
| 15° - 90° ±30'  |              |         |          |          |          |      |                      |                |        |
| 15° - 90° ±30'  |              |         |          |          |          |      |                      |                |        |
| 15° - 90° ±30'  |              |         |          |          |          |      |                      |                |        |
| INDEX   | AMENDMENTS   | SIGN    | DATE     | HOS/ODC  |          |      |                      |                |        |
|   |              |         |          |          |          |      |                      |                |        |
| <b>GABLE (CASTING) FOR 155MM DHANUSH</b>  |              |         |          |          |          |      | SEC                  | M/C            | JWM/TR |
| * TO ACHIEVE Rp 0.2 = 600 Mpa MIN.<br>Rm = 800-950 Mpa, El = 10%.<br>HB = 235-285 |              |         |          |          |          |      | SCALE                | REF. DEM       |        |
| GUN CARRIAGE FACTORY, JABALPUR  |              |         |          |          |          |      | REF. DRG. No.        | 2025653 (CAST) |        |
| DRG. NO. GCF/50/39461   |              |         |          |          |          |      | SHEET NO.            | OF SHEETS      |        |

FOR COMPONENT SEE DRG. 2025635



FOR DISCONTINUITIES ACC. TO CATEGORY B AND C CLASS 1 IS APPLICABLE FOR CATEGORY A CLASS 2

9 2 025 635  
CASTING Z13-2-10A

L NR  
STAMP Z13-5-5A

AREA ESPECIALLY MARKED  
ULTRASONIC TESTED

AREA ESPECIALLY MARKED  
ULTRASONIC TESTED

MANUFACTURING SPECIFICATION A 2003 AND G 804 092  
ASTM E448-78 CLASS 2 GROUP A-B A-D G  
GROUP D, E, F AND G ARE NOT APPLICABLE  
ONE TENSILE TEST FROM SEPARATELY CAST TESTPIECE  
FOR EACH CHARGE

DIMENSIONS GIVEN REGARDING WALL THICKNESSES ARE MINIMUM  
CASTING TOLERANCE ACCORDING TO IS 722-61A-18

NOTE:- 1. PILOT SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.  
2. DIMENSIONS ARE GIVEN BY SHOP.

FOR CASTING SEE DRG. GCF/50/39461

| P.No.                   | NOMENCLATURE | No. OFF | MATERIAL | HARDNESS | STANDARD | REMARKS              |
|-------------------------|--------------|---------|----------|----------|----------|----------------------|
| GEN. TOL. NOT SPECIFIED |              |         |          |          |          | FOR SC. CM. G.C.F.V. |
| DATE                    |              |         |          |          |          | 2020 NAME DATE       |
| DRN.                    |              |         |          |          |          | DRN. PPS 10-10       |
| CHKD.                   |              |         |          |          |          | CHKD.                |
| APPROVED                |              |         |          |          |          | APPROVED             |
| INDEX                   | AMENDMENTS   | SIGN    | DATE     | APPROVED |          |                      |
|                         |              |         |          |          |          |                      |

**GABLE**

(PRE-MACHINING DRWG.)

(FOR TRADE ACTION ONLY)

GUN CARRIAGE FACTORY, JABALPUR

CAST RADII 3 APPLIES  
UNLESS OTHERWISE STATED.  
CASTING RELIEF

DIMENSIONAL CHANGES ARE DONE AS  
PER PRODUCTION SECTION CONCERNED

DRG. No. GCF/50/4879  
SHEET NO. OF SHEETS