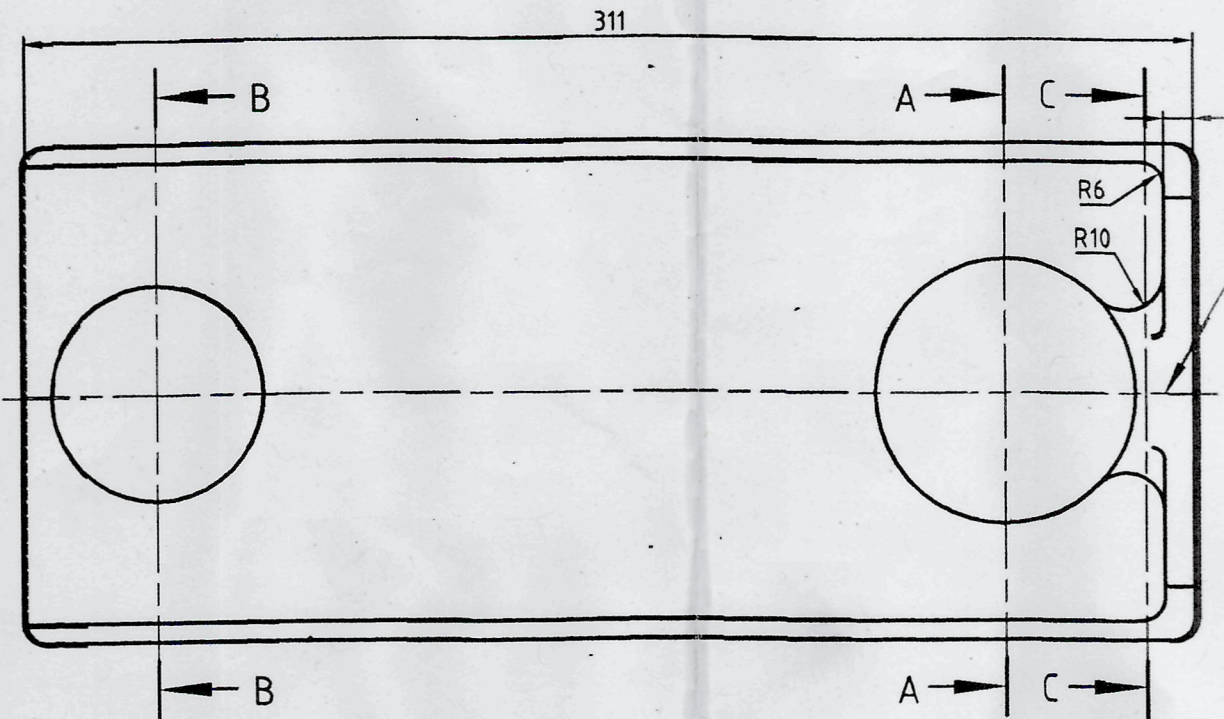
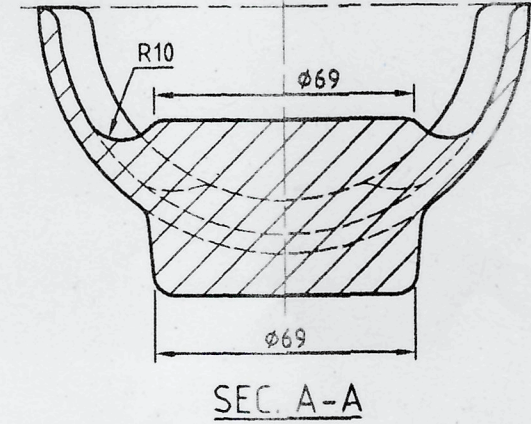
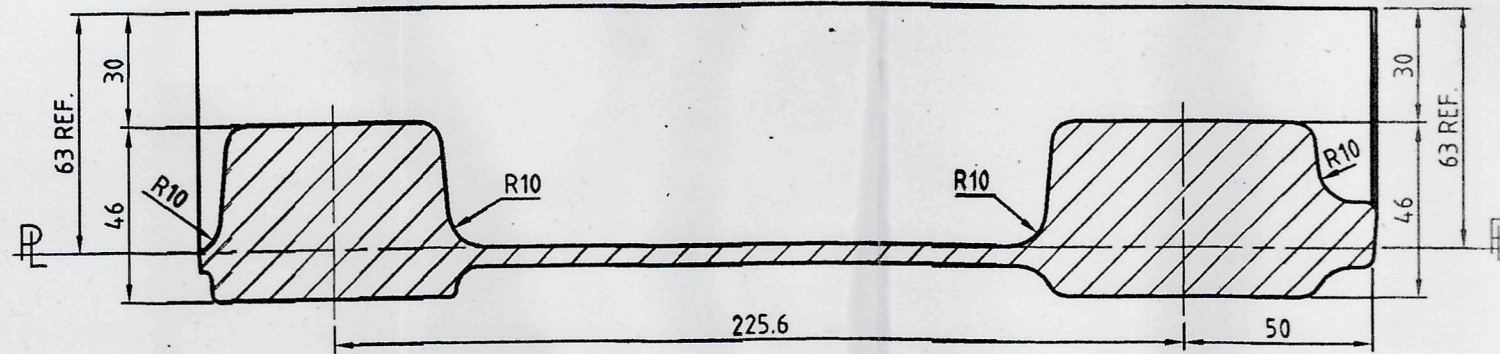
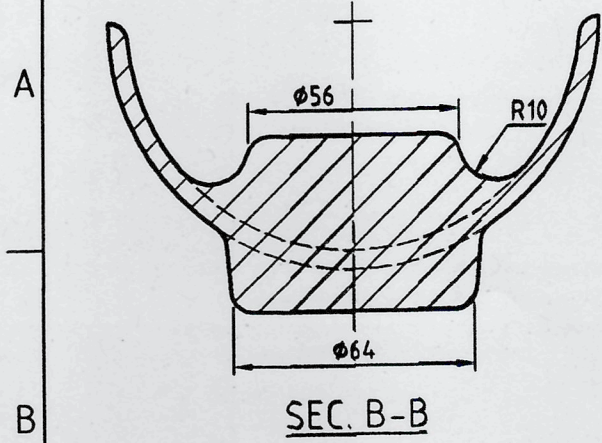


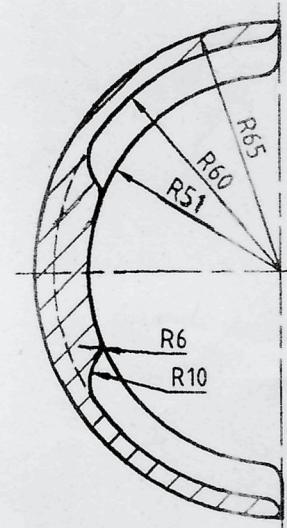
DRG.No. GCF LM-1065(B)

FOR TENDER ONLY

FOR EXPLANATION OF DIMENSIONING ETC., SEE CIARM NOTE SHEET No. 1
DIMNS. ARE IN mm. UNLESS OTHERWISE STATED.



GCF'S LM No. & SUPPLIER'S No.
HERE IN RAISED LETTERS



ALT. MATL:-STEEL BS:970 PT. I-1983, 60S M 36(R)
WEIGHT (Kg) :- 4.6
HEAT TREATMENT:- NORMALIZED, HARDENED, & TEMPERED.
DRG. VETTED AS PER APPROVED DRG. BY SR. I. OF A. DT. 5.1.77
FORGINGS AS PER BS SPECIFICATION
GENERAL TOLERANCES:-
1. DIE WEAR: $\begin{matrix} +2.4 \\ -1.2 \end{matrix}$ 4. FINREST: 1.0
2. THICKNESS: $\begin{matrix} +1.7 \\ -0.8 \end{matrix}$ 5. STRAIGHTNESS: 1.1
3. MISMATCH: 0.8 6. FILLET AND EDGE RADII: $\begin{matrix} +50\% \\ -25\% \end{matrix}$
7. OTHER TOLERANCES IF ANY-SEE NOTE

SURFACE TOLERANCES: :
I. MACHINED SURFACES: 50% OF MACHINING ALLOWANCE
II. ON FORGED SURFACES WITHOUT SUBSEQUENT MACHINING } 1/3 OF THICKNESS TOLERANCE

NOTE:-
1. THIS DOCUMENT IS THE PROPERTY OF THE GOV'T. OF INDIA M. OF D. AND IS ISSUED FOR THE PURPOSE OF DEVELOPING /MANUFACTURING STORES REQUIRED FOR DEFENCE USE.
2. IT MUST NOT BE REPRODUCED/DISCLOSED TO ANY THIRD PARTY OR USED FOR ANY CIVIL PURPOSE.
3. IT MUST BE RETURNED TO THE ISSUING AUTHORITY WHEN THE PURPOSE OF ITS ISSUE HAS BEEN SERVED.
4. PILOT SAMPLE TO BE APPROVED BEFORE BULK SUPPLY.

NOTE:-
UNSPECIFIED DRAFT ANGLE $5^{\circ} \pm 1^{\circ}$
UNSPECIFIED CORNER RADII 1.5 FILLET RADII 6
TO BE DROP FORGED.
TESTS TO BE CARRIED OUT IN ACCORDANCE WITH BS 970

GCF/SC/281/DRG/VETT/UC	7.11.22
GCF/SC/281/DRG/VETT/UC	15.2.19
GCF/SC/281/DRG/VETT/UC	28.3.17
GCF/SC/281/DRG/VETT/UC	31.7.14
GCF/SC/281/DRG/VETT/UC	9.9.10
GCF/SC/281/DRG/VETT/UC	20.9.09
(B) GCF/SC/281/DRG/VETT/26	18.8.07
(A) DRG/VETT/PO/693	23.1.87
INDEX	CERTIFICATION No. OF VETTING CELL DATE

PT.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	SIZE	REMARKS	
	GEN. TOL. NOT SPECIFIED							
	LINEAR DIMENSIONS							
	0 - 6							
	6 - 30							
	30 - 120							
	120 - 315							
	315 - 1000							
	1000-2000							
	ANGULAR DIMENSIONS							
	0° - 10°							
	10° - 50°							
	50° - 100°							
	> 100°							
	~ UNMACHINED							
	▽ ROUGH							
	▽▽ SMOOTH							
	▽▽▽ FINISH							
	INDEX							
	AMENDMENTS							
	SIGN							
	DATE							
	LEG							
	(FORGING DRAWING)							
	GUN CARRIAGE FACTORY, JABALPUR							
						2009		
						NAME	DATE	
						DRN.	APPROVED	
						K.L.Verma	15.9.09	
						CKD.		
							JWM/Shop	
						VERIFIED BY HOS/DDO		
							JWM/TR	
						SEC.	M/C	
						SCALE	REF.DEM.	
						NTS.	REF.DRG.No	
							3015284	
						DRG.No.	GCF LM-1065(B)	
						SHEET NO.	OF SHEETS	

NOTE:-REDRAWN WITHOUT CHANGE.