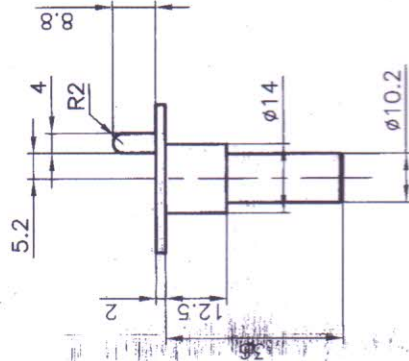
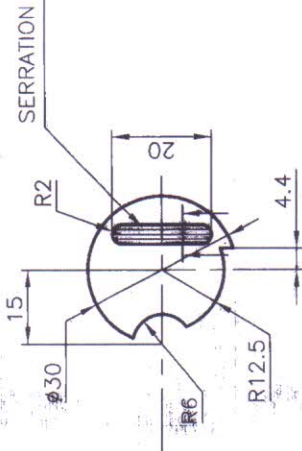


DRG. No.: TEND 2210 \*2



DIMENSIONS ARE IN mm.  
DRAFT ANGLE FOR HOLES 1°  
CASTING RADII R 1mm

UNTOLERATED DIMNS ARE AS PER IS : 11166-1984 CLASS I  
OF INVESTMENT CASTING. CASTING TO BE SUPPLIED IN  
NORMALISED CONDITION.

MATERIAL: -  
BS:3146 PART -1: 1974  
TYPE - CLASS: 5 GRADE -A.  
(NON STRESSED COMPONENT)

RADIOGRAPHIC TEST AS PER ASTM-E-192

ACCEPTENCE STANDARD:-

GAS HOLE & FOREIGN MATERIAL: LEVEL-5.  
SHRINKAGE (ALL TYPES) - LEVEL 3

CASTING SHOULD BE FREE FROM DEFECTS LIKE CRACKS,  
SURFACE FINISH MUST BE SMOOTH.

TEN NUMBERS OF SAMPLES ARE TO BE SUPPLIED  
FOR QUALITY CLEARANCE AT OFT BEFORE BULK SUPPLY

UN CONTROLLED COPY

CERTIFIED CORRECT COPY  
OF APPROVED DRAWINGS  
AT THIS DATE 3/4/18.....

*S. Venkatesh*  
Design & Drawing Office  
Ordnance Factory,  
Tiruchirappalli 620016

DA. NO.001/17  
Dt:03/01/2017  
DA. NO.117/13  
Dt:15/09/2013  
AMENDMENTS  
SIG. & DATE: *S. Venkatesh* 05/01/2017

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
TRACED	SIGNATURE & DATE.				SCALE 1:1
DRAWN	<i>S. Venkatesh</i>		CASTING DRG		STORE DRG.NO. 30P 1401
CHECKED	<i>V.V.</i>		FOR: HOUSING PLUG GAS		OPERATION NO.
HOS/D&DO			OF: 40mm MGL		
OFFICER/PRODN.	<i>P. Jayaraj</i>		DES. REF. NO.		
OFFICER/D&DO			DRG. No.: TEND 2210 *2		
APPROVED ON. 05/01/2017					
					ORDNANCE FACTORY TIRUCHIRAPPALLI-16.
					SHEETS 1
					SHEET NO: 1