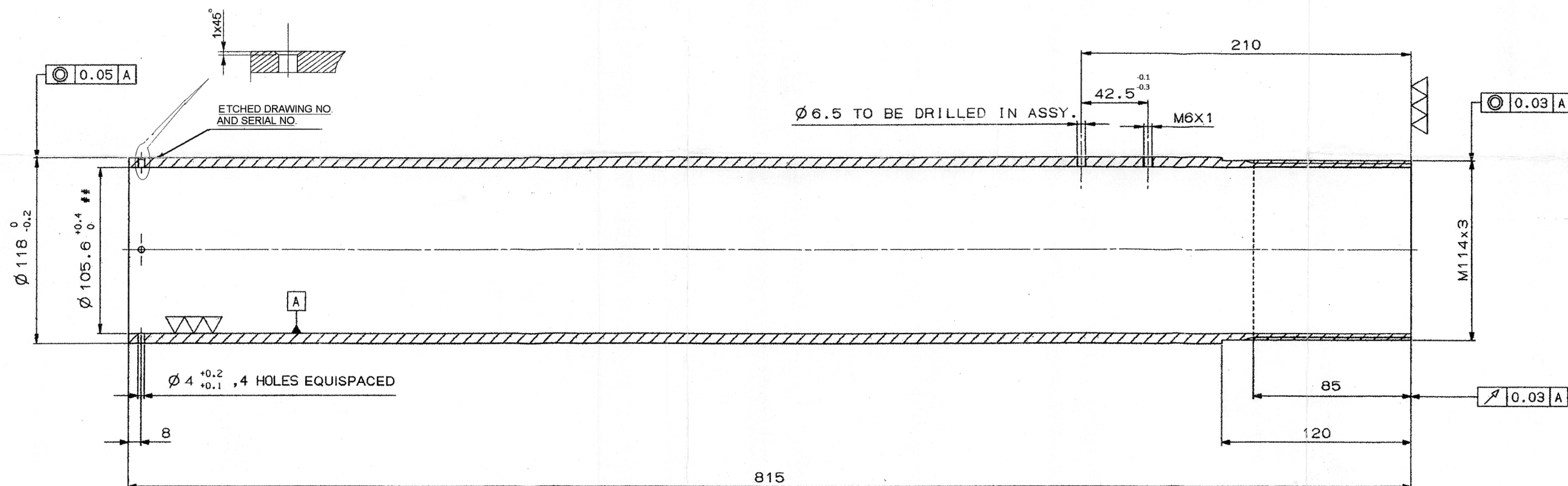


8	7	6	5	4	3	2	1
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1. PRIMER RED OXIDE TO STANDARD IS:12744 TO BE APPLIED BY FIRM WHO IS SUPPLYING STORE TO MPF AS PER DW-1134
2. PAINTING TO BE DONE AT MPF IN OR DURING ASSEMBLY AS PER DW-1134
3. APPLY PRIMER AND PAINT ON OUTSIDE SURFACE ONLY
4. DO NOT APPLY PRIMER AND PAINT ON THREAD AND BORE SURFACE



INTERNAL SURFACE TO BE HARD CHROMIUM PLATED
DIMENSION TO BE FINISHED AFTER WELDING OF
SHEAR PIN HOLDER(DRG.NO.DW-1108-1104-14)
AND PIN(DRG.NO.DW-1108-1106-14)WITH
TUBE LRM(R.DRG.NO.DW-1108-1101-12)

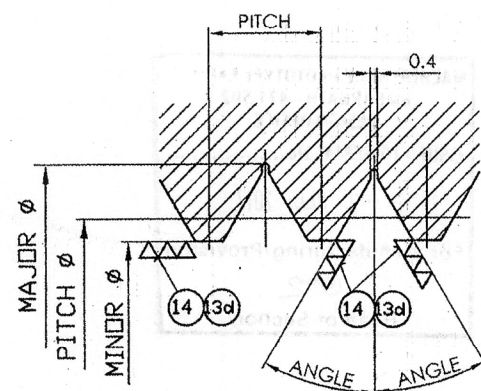
HARD CHROMIUM PLATING
THICKNESS: -100-150 MICRON

$$\triangle \triangle (\triangle \triangle \triangle)$$

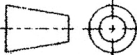
INSPECTION OF BORE & THREAD

- CHECK TUBE ID WITH PLUG GAUGE HAVING DIMENSIONS - $\varnothing 105.628 \pm 0.007$
- CHECK THREAD M114x3 WITH RING GAUGE HAVING FOLLOWING DIMENSIONS

THREAD ANGLE & TOLERANCE	30° ± 10'	30° ± 14'
PITCH	3 ± 0.005	3 ± 0.005
MINOR DIA	Ø110.704 ± 0.0115	Ø111.0334 ± 0.03
PITCH DIA	Ø111.9834 ± 0.0115	Ø111.6334 ± 0.0115
MAJOR DIA	Ø114.187 MIN	Ø113.97 MIN
	GO-GAUGE	NO GO-GAUGE



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1	TUBE- LRMR			* *				* * *		
No.Off	DESCRIPTION		PART No.	MATERIAL	STANDARD	DIMENSIONS		REMARKS		
GENERAL TOLERANCE										
LINEAR DIMENSIONS										
0-8	±0.1									
8-30	±0.2									
30-120	±0.3									
120-315	±0.5									
315-1000	±0.8									
1000-2000	±1.2	16	DW-1108 0000-12	REVISION-I	TOLERANCE ADDED ON DIM 42.5 0.1/-0.3			03.04.13	VIJAY	
				REVISION-I	DETAILS OF HOLE OF DIA 4 ADDED LOCATION OF MARKING AREA ADDED DIM 85 WAS 100			22.04.2013	VIJAY	
ANGULAR DIMENSION			No.Off	DRG. No. OF ASSOCIATED PART	INDEX	ALTERATION		DATE	NAME	
1-10	±1°	TUBE LR-MR TUBE ASSY. LAUNCHER ASSY LR-MR LAUNCHER KAVACH MOD-II				SCALE 1:2	DRAWN	18.01.08	Sanjay	
10-50	±30'						CHECKED	"	Sanjay	
50-100	±20'						APPROVED			
>100	±10'									
VALUE IN "um"										
~	>25					REPLACED BY				
▽	8-25					REPLACED FOR				
▽▽	1.8-8									
▽▽▽	0.025-1.8									
▽▽▽▽	<0.025									
			MACHINE TOOL PROTOTYPE FACTORY.			Design Office		DRAWING No. DW-1108-1101-12		
			AMBERNATH							