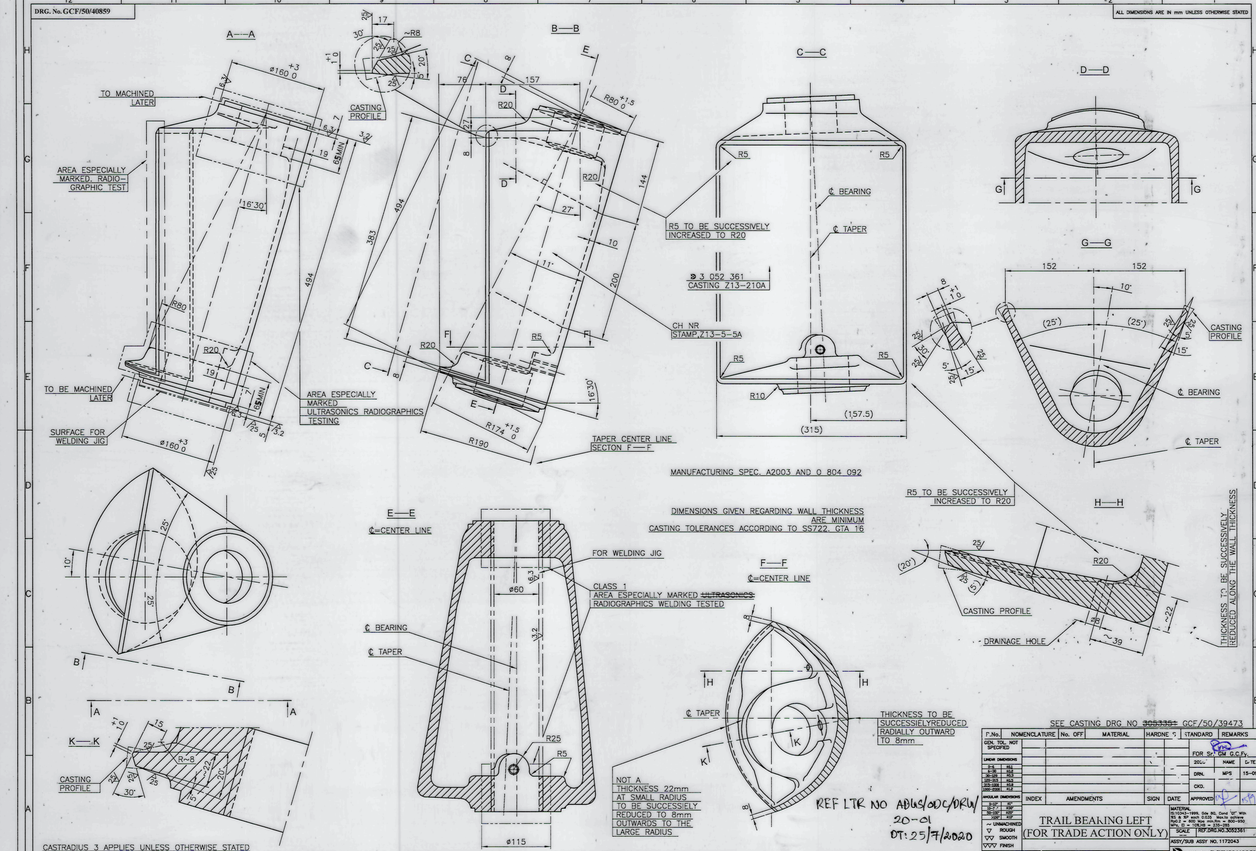
DRG. No. GCF/50/40859

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED



SEE CASTING DRG NO ~~3053335~~ GCF/50/39473

P.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNE °C	STANDARD	REMARKS
GEN. TOL. NOT SPECIFIED						
LINEAR DIMENSIONS						
0.5 - 6	±0.1					
6.01 - 30	±0.2					
30.01 - 120	±0.3					
120.001 - 315	±0.5					
ANGULAR MEASURE						
0° - 10°	±2°					
10.01° - 50°	±1°					
50.01° - 120°	±0.5°					
UNMACHINED						
▽ ROUGH						
▽▽ SMOOTH						
▽▽▽ FINISH						

INDEX	AMENDMENTS	SIGN	DATE	APPROVED

FOR SQ. GEN.

DSG.	NAME	DATE
DRN.	MPS	15-09
CKD.		

MATERIAL
CS 55-60 MPA, CAS 60, Grade "D" Min. 12% Elong. & 2.7 J Impact Value at 0°C or CS 70 MPA, Min. 8% Elong. & 2.7 J Impact Value at 0°C

SCALE: NOT DRG NO. 3052361

ASSY/SUB ASSY NO. 1172043

TRAIL BEAKING LEFT
(FOR TRADE ACTION ONLY)

GUN CARRIAGE FACTORY, JABALPUR

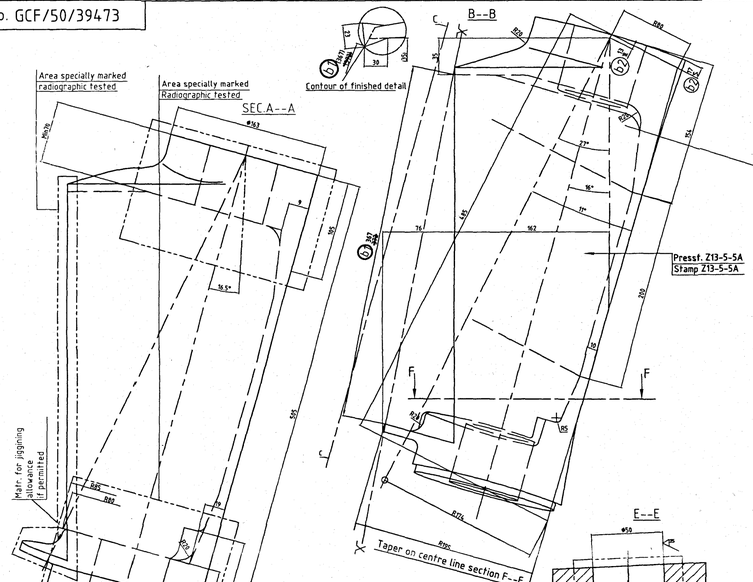
DRG. No. GCF/50/40859

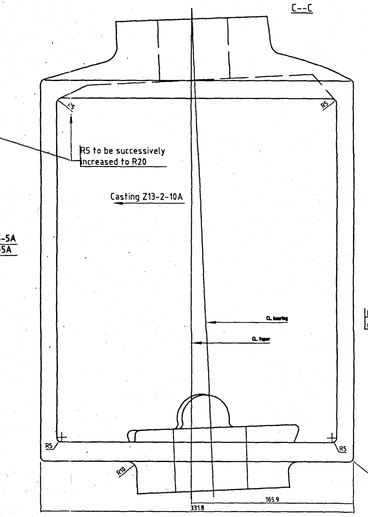
SHEET NO. 1 OF 1 SHEETS

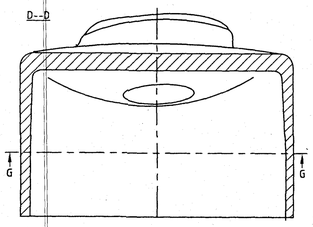
REF LTR NO AB16/20C/DRGW 20-01 DT: 25/7/2020

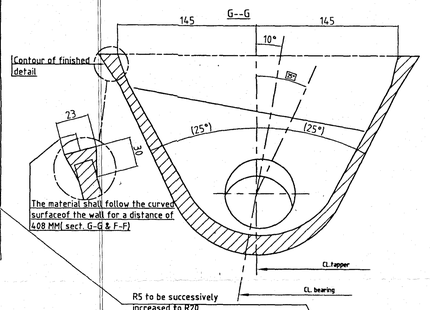
DRG. No. GCF/50/39473

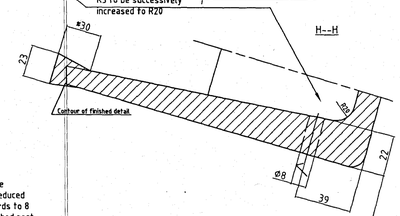
DRAWING CONVENTIONS CONFROM TO SP:46
DIMNS. ARE IN mm. UNLESS OTHERWISE STATED.



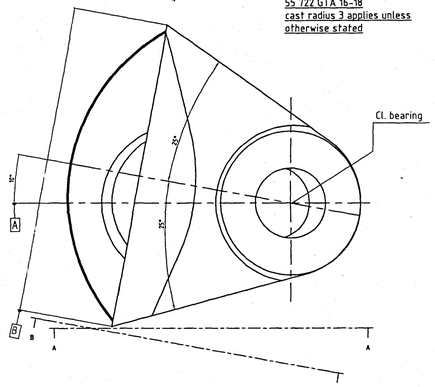


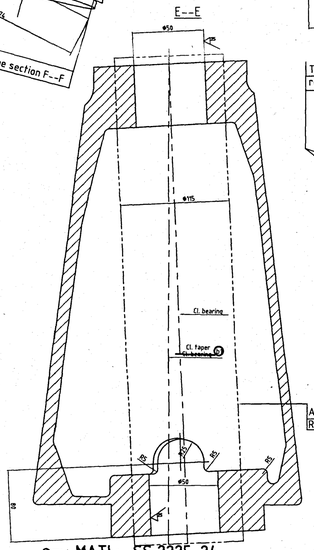


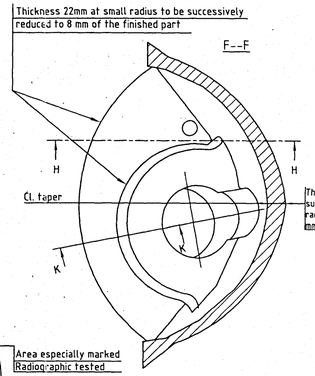


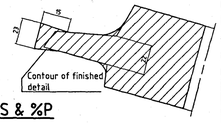


Manufacturing spec. A2003 and 0804092
Dimensions given regarding wall thickness are minimum
Casting tolerance according to 55 722 GTA 16-18
cast radius 3 applies unless otherwise stated









The thickness reduced to 8 mm along the wall of the finished part.

Weight - 35 Kg.

Matl. :- IS:10343-1999, Gde BQ, COND. 'QT' with %S & % P Each 0.035 MAX.
* to achieve Rp 0.2=600Mpa MIN. Rm = 800-950 Mpa, El = 10% HB = 235-285.

COMPONENT DRG. - 3052361

NOTE:- The areas other than specified are to be tested for Radiography level 3

OEM MATL:- SS 2225-24
MATL. IS: 10343-1999, GdeBQ, Cond.'QT'%S & %P
RESTRICTED TO 0.035% EACH MAX.

P.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	SIZE	REMARKS

GEN. TOL. NOT SPECIFIED

LINEAR DIMENSIONS

0-6	±0.1
6-30	±0.2
30-120	±0.3
120-315	±0.5
315-1000	±0.8
1000-2000	±1.2

ANGULAR DIMENSIONS

0-10°	±1°
10-50°	±30'
50-100°	±20'
>100°	±10'

UNMACHINED
ROUGH
SMOOTH
FINISH

INDEX	AMENDMENTS	SIGN	DATE
62/b2	Dimn.17 was 5, dimn.13 was 8	alok	27/5/17
48/b1	Inclined center line maned CL Taper, dimn. 367 was 372	JK	3/2/17

FOR Sr. GM G.C.F.y.

	NAME	DATE	APPROVED
2014			
DRN.	Alok	13/12/14	
CKD.			JWM/Shop
HOS/DO			
SEC.	M/C		JWM/TR

TRAIL BEARING LEFT CASTING
FOR
DHANUSH 155 mm FH GUN

SCALE
REF.DEMD.
REF.DRG.NO. 3053351
DRG.No. GCF/50/39473

GUN CARRIAGE FACTORY, JABALPUR

SHEET NO. 1 OF 1 SHEETS