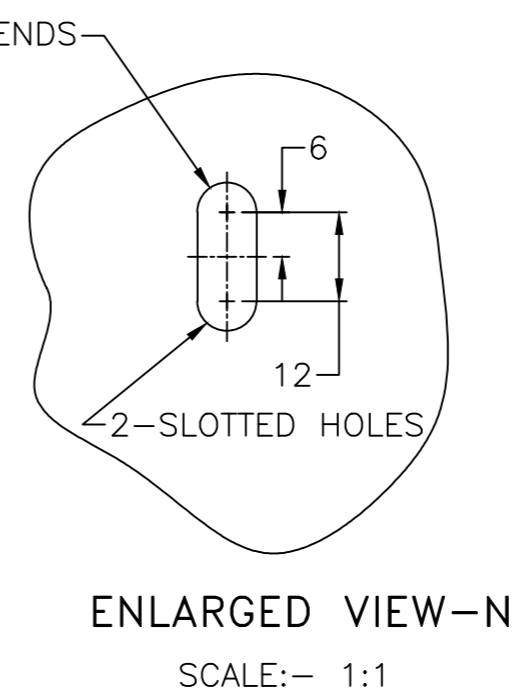
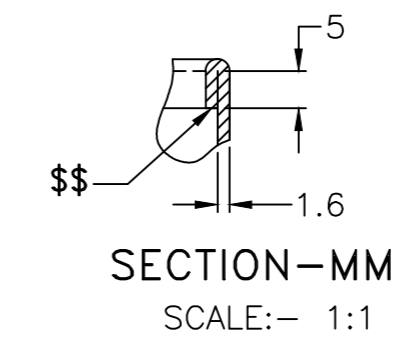
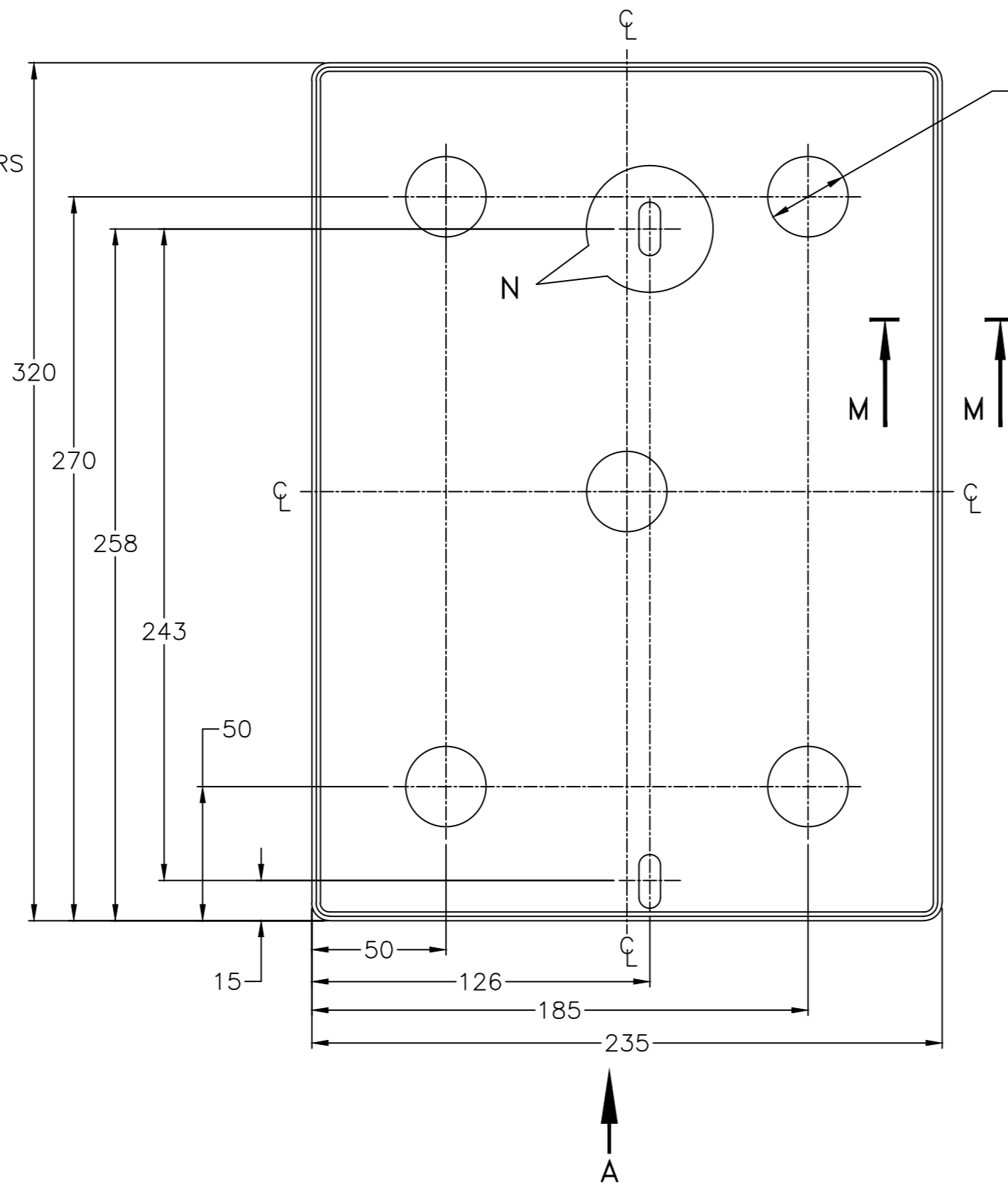
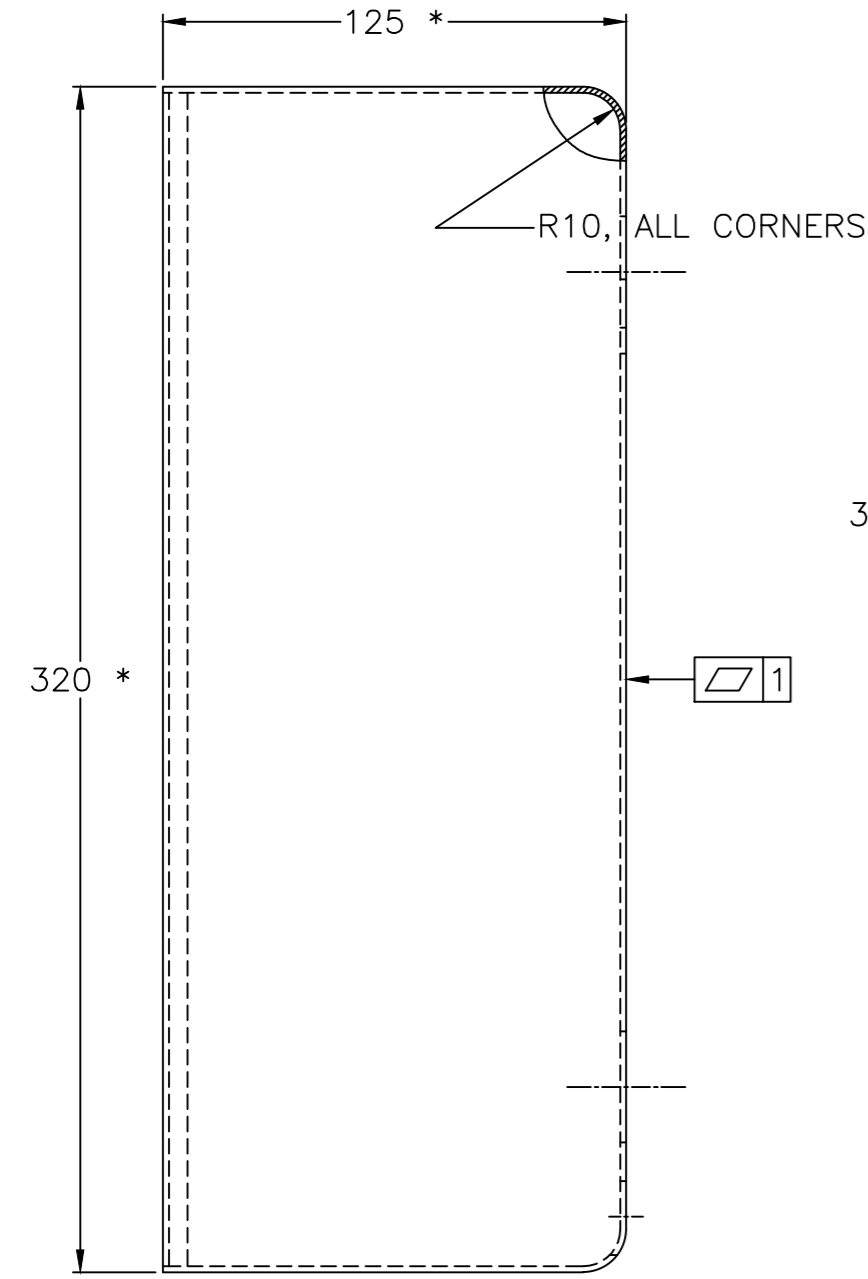


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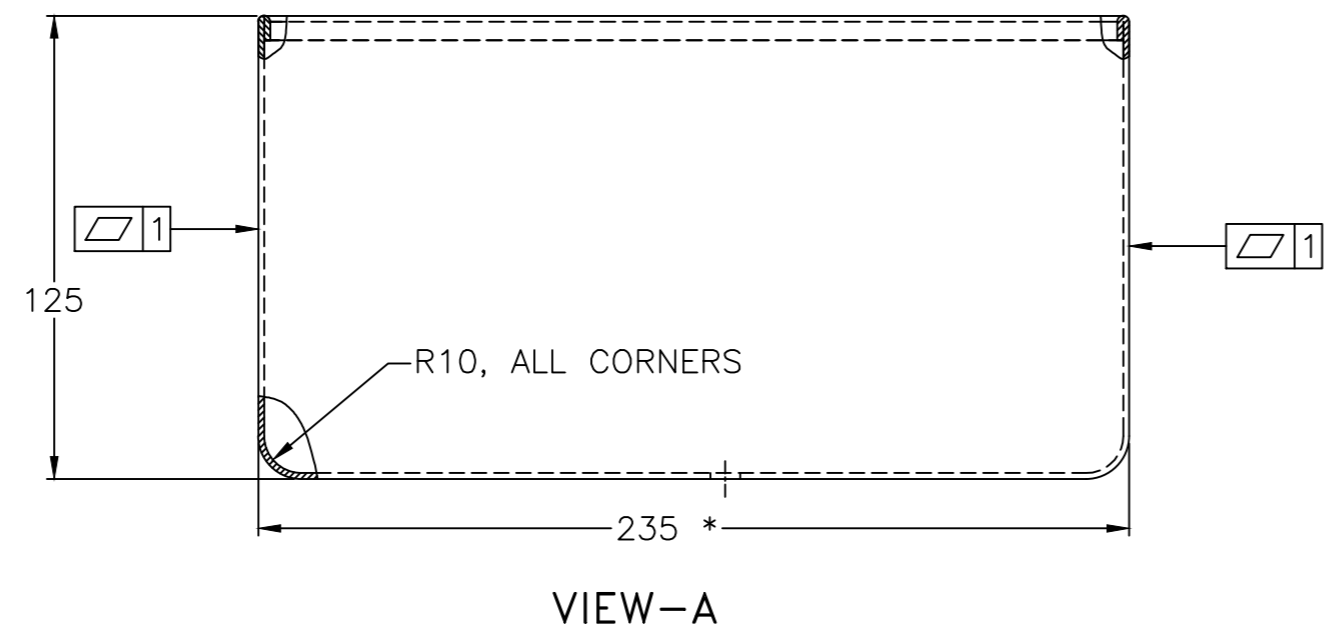
**

CLASS OF DEVIATION	RADIUS-CHAMF					CLASS OF DEVIATION	ANGLE				LINEAR DIMNS										
	0.5-0.3	0.3-0.6	0.6-3.0	3.0-12.0	12.0-31.5		DEGREE	mm per 100mm	DEGREE	mm per 100mm	DEGREE	mm per 100mm	DEGREE	mm per 100mm	0.5-0.3	0.3-0.6	0.6-3.0	3.0-12.0	12.0-31.5	31.5-100.0	100.0-200.0
FINE & MEDIUM	±0.2	±0.5	±1	±2	±4	FINE & MEDIUM	±1°	±1.8	±30'	±0.9	±20°	±0.6	±10°	±0.3	±0.05	±0.05	±0.1	±0.15	±0.2	±0.3	±0.5
COARSE & EX-COARSE	±0.2	±1	±2	±4	±8	COARSE	±1°30'	±2.6	±50'	±1.5	±25°	±0.7	±15°	±0.4	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2
GENERAL TOLERANCES TO IS:2102-80						EXTRA COARSE	±3°	±5.2	±2'	±3.5	±1°	±1.8	±30°	±0.9	±0.1	±0.5	±1	±1.5	±2	±3	±4



TECHNICAL CONDITIONS

- UNSPECIFIED DEVIATIONS ARE AS PER IS:2102-1982 (COARSE) **
- BLUNT SHARP EDGES / CORNERS
- THE BOX MAY BE FABRICATED FROM 2 (OR) 3 (OR) 4 PIECES AND IS ALLOWED TO JOIN BY ANY SUITABLE WELDING / BRAZING METHOD BY MAINTAINING THE SPECIFIED SIZE DIMENSIONS
- EXTRA PROJECTIONS OF WELD METAL ON WELDING IS NOT ALLOWED
- \$\$\$ - FOLD THE SHEET TOP SIDE EVENLY AS MENTIONED AND ALSO BLUNT CORNERS / EDGES SUITABLY
- ALTERNATE THICKNESS OF SHEET IS 2mm
- * SIZE IS GIVEN FOR REFERENCE



*** MATL:-STEEL SHEET Fe410 WC TO IS:1079-1994, 'D' ANNEALED

(BK) APPROVED FOR BULK PRODUCTION

ROUGHNESS SYMBOL						23.12.14
ROUGHNESS VALUE	25-50	6.3-25	0.8-6.3	0.1-0.8	< 0.1	ISSUE
MATL:- ***						AMENDMENTS
DRN. <i>H.Yuvaraj</i> H.Yuvaraj	DIMENSIONS IN mm.				Est.Wt:-	
CHD. <i>B.Mohan</i> B.Mohan	DRG. NOT TO BE SCALED				STAMP PART No. & MANUFACTURER'S NAME & YEAR AT #	
PASSED. <i>S.Arun sundar</i> S.Arun sundar					REMOVE ALL BURRS	
APPROVED. <i>S.Savithri</i> S.Savithri	SCALE:-1:2,1:1				USED ON	
DATE:12.06.10						6755-86-Cb1940
TITLE						DRG. NO.
BOX						6755-86-1941
[FOR STOWAGE OF HEAD GEAR]						

COMBAT VEHICLES RESEARCH & DEVELOPMENT ESTABLISHMENT

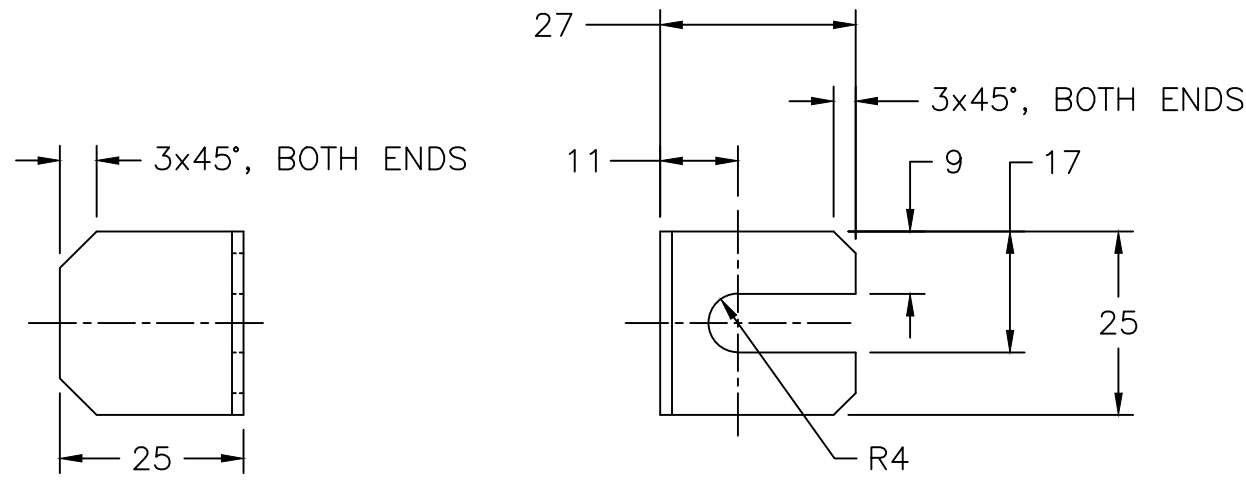
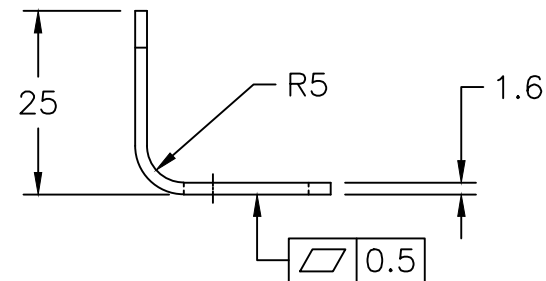
OLD REF:-

6755-86-1942

**

CLASS OF DEVIATION	ANGLE	UP TO 10		OVER TO 50		OVER 50 TO 120		OVER 120		CLASS OF DEVIATION	LINEAR DIMNS					
		DEGREE	mm per 100mm	DEGREE	mm per 100mm	DEGREE	mm per 100mm	DEGREE	mm per 100mm		0.5-03	03-06	06-30	30-120	120-315	315-1000
FINE & MEDIUM	±1°	±1.8	±30'	±0.9	±20'	±0.6	±10'	±0.3	FINE	±0.05	±0.05	±0.1	±0.15	±0.2	±0.3	±0.5
COARSE	±1°30'	±2.6	±50'	±1.5	±25'	±0.7	±15'	±0.4	MEDIUM	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2
EXTRA COARSE	±3°	±5.2	±2°	±3.5	±1°	±1.8	±30'	±0.9	COARSE	-	±0.2	±0.5	±0.8	±1.2	±2	±3
									EXTRA COARSE	-	±0.5	±1	±1.5	±2	±3	±4

CLASS OF DEVIATION	RADI-CHAMF				
	0.5-03	03-06	06-30	30-120	120-315
FINE & MEDIUM	±0.2	±0.5	±1	±2	±4
COARSE & EX-COARSE	±0.2	±1	±2	±4	±8



(BK) APPROVED FOR BULK PRODUCTION
d. h...

ROUGHNESS SYMBOL		23.12.14
ROUGHNESS VALUE	25-50, 6.3-25, 0.8-6.3, 0.1-0.8, < 0.1	ISSUE AMENDMENTS
MATL:-STEEL SHEET TO IS:1079-1994, 'D' ANNEALED		Est.Wt:-
DRN. <i>Hyar</i> H.Yuvaraj	DIMENSIONS IN mm.	STAMP PART No. & MANUFACTURER'S NAME & YEAR AT #
CHD. <i>B.Mohan</i> B.Mohan	DRG. NOT TO BE SCALED	REMOVE ALL BURRS
PASSED. <i>S.Arun sundar</i> S.Arun sundar		USED ON
APPROVED. <i>d. h...</i> S.Savithri		SCALE:- 1:1
TITLE		DRG. NO.
BRACKET		6755-86-1942
[FOR STOWAGE OF HEAD GEAR]		

TECHNICAL CONDITIONS

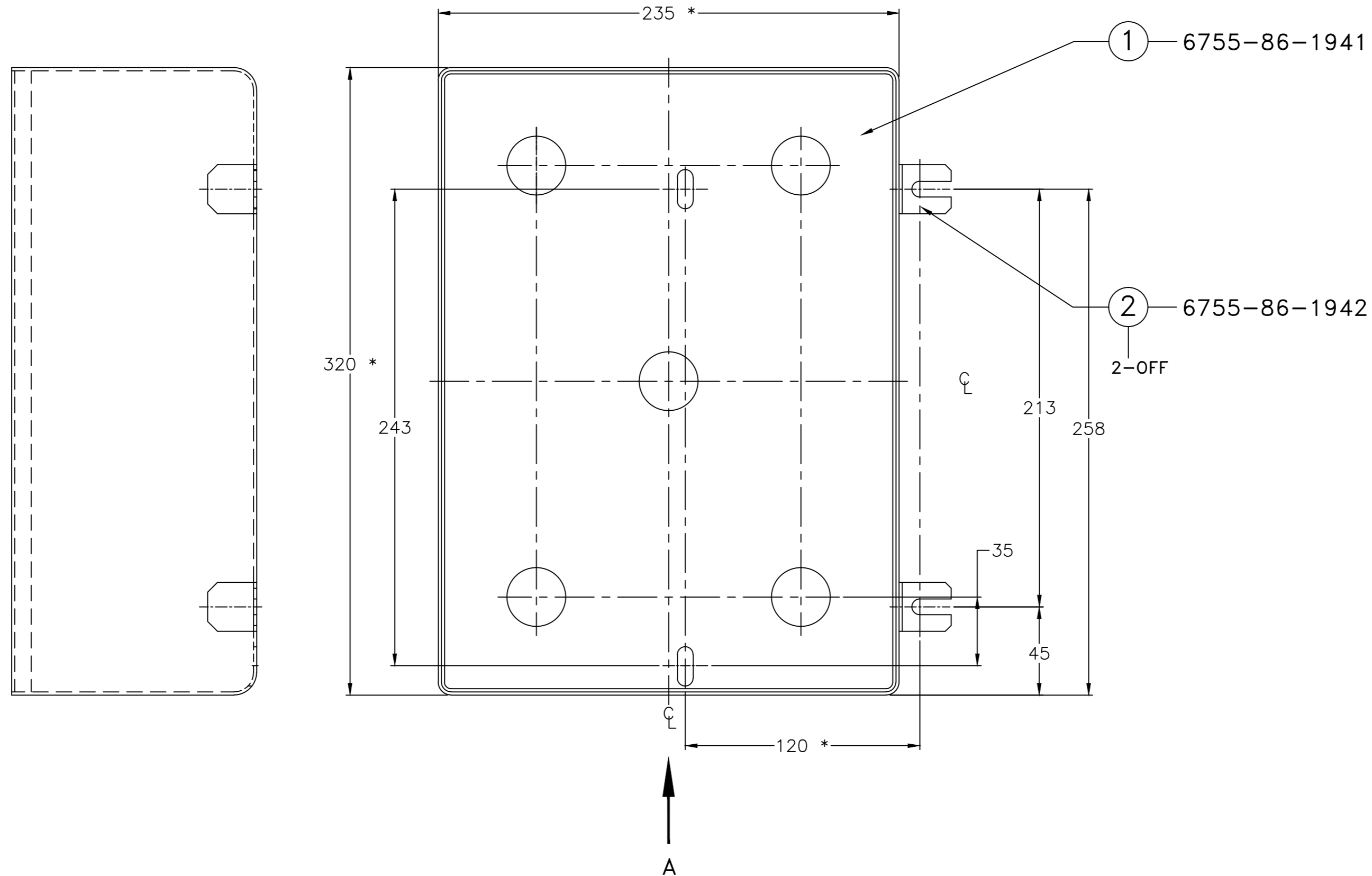
- UNSPECIFIED DEVIATIONS ARE AS PER IS:2102-1982 (COARSE) **
- ALTERNATE THICKNESS OF SHEET IS 2mm
- BLUNT SHARP EDGES / CORNERS

OLD REF:-

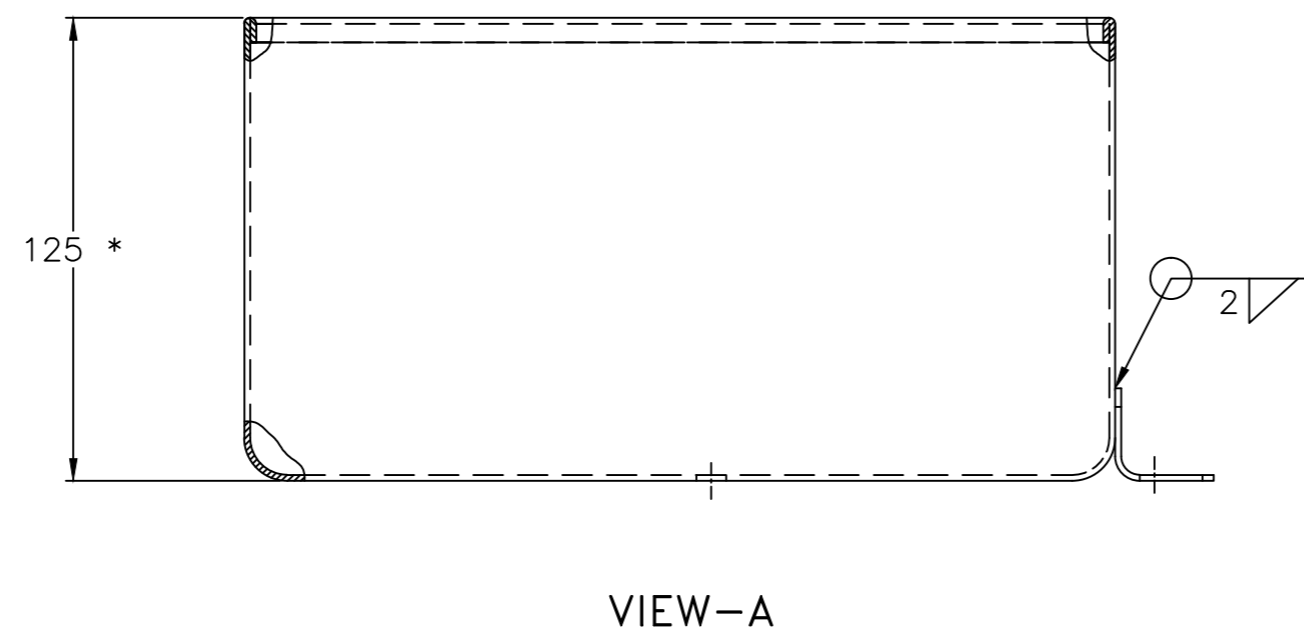
6755-86-Cb1940Cb

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CLASS OF DEVIATION	RADIUS-CHAMF					ANGLE					LINEAR DIMNS										
	0.5-0.3	0.3-0.6	0.6-30	30-120	120-315	DEGREE	mm per 100mm	DEGREE	mm per 100mm	DEGREE	mm per 100mm	DEGREE	mm per 100mm	0.5-0.3	0.3-0.6	0.6-30	30-120	120-315	315-1000	1000-2000	
FINE & MEDIUM	±0.2	±0.5	±1	±2	±4	±1°	±1.8	±30'	±0.9	±20°	±0.6	±10°	±0.3	±0.05	±0.05	±0.1	±0.15	±0.2	±0.3	±0.5	
COARSE & EX-COARSE	±0.2	±1	±2	±4	±8	±1°30'	±2.6	±50'	±1.5	±25°	±0.7	±15°	±0.4	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	
GENERAL TOLERANCES TO IS:2102-80						COARSE	±1°30'	±2.6	±50'	±1.5	±25°	±0.7	±15°	±0.4	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2
						EXTRA COARSE	±3°	±5.2	±2'	±3.5	±1°	±1.8	±30°	±0.9	±0.5	±1	±1.5	±2	±3	±4	



- TECHNICAL CONDITIONS**
1. WELDING CONFORM TO IS:816
 2. FILLER RODS CONFORM TO IS:814
 3. UNSPECIFIED DEVIATIONS ARE AS PER IS:2102-1982 (COARSE) **
 4. BLUNT SHARP EDGES / CORNERS
 5. APPLY PRIMER ϕ .I-03K, GOST 9109-1981 (OR) IS:1874-1968
 6. APPLY ENAMEL WHITE, II ϕ -223, GOST 14923-1978 (OR) JSS:8010-90
 7. MAINTAIN STRAIGHTNESS / FLATNESS EVEN AFTER WELDING BY USING PROPER FIXTURES



VIEW-A

<table border="1"> <tr> <td>ROUGHNESS SYMBOL</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>ROUGHNESS VALUE</td> <td>25-50</td> <td>6.3-25</td> <td>0.8-6.3</td> <td>0.1-0.8</td> </tr> </table>					ROUGHNESS SYMBOL					ROUGHNESS VALUE	25-50	6.3-25	0.8-6.3	0.1-0.8	(BK) APPROVED FOR BULK PRODUCTION 23.12.14 ISSUE AMENDMENTS
ROUGHNESS SYMBOL															
ROUGHNESS VALUE	25-50	6.3-25	0.8-6.3	0.1-0.8											
MATL:- REFER DETAILS					Est.Wt:-										
DRN. <i>H.Yuvaraj</i>	H.Yuvaraj	DIMENSIONS IN mm.		STAMP PART No. & MANUFACTURER'S NAME & YEAR AT #											
CHD. <i>B.Mohan</i>	B.Mohan	DRG. NOT TO BE SCALED		REMOVE ALL BURRS											
PASSED. <i>S.Arun sundar</i>	S.Arun sundar		SCALE:-1:2	USED ON											
APPROVED. <i>S.Savithri</i>	S.Savithri		DATE:12.06.10	6755-86-Cb5650											
TITLE				DRG. NO.											
ASSY. BOX [FOR STOWAGE OF HEAD GEAR]				6755-86-Cb1940Cb											
COMBAT VEHICLES RESEARCH & DEVELOPMENT ESTABLISHMENT															

OLD REF:-