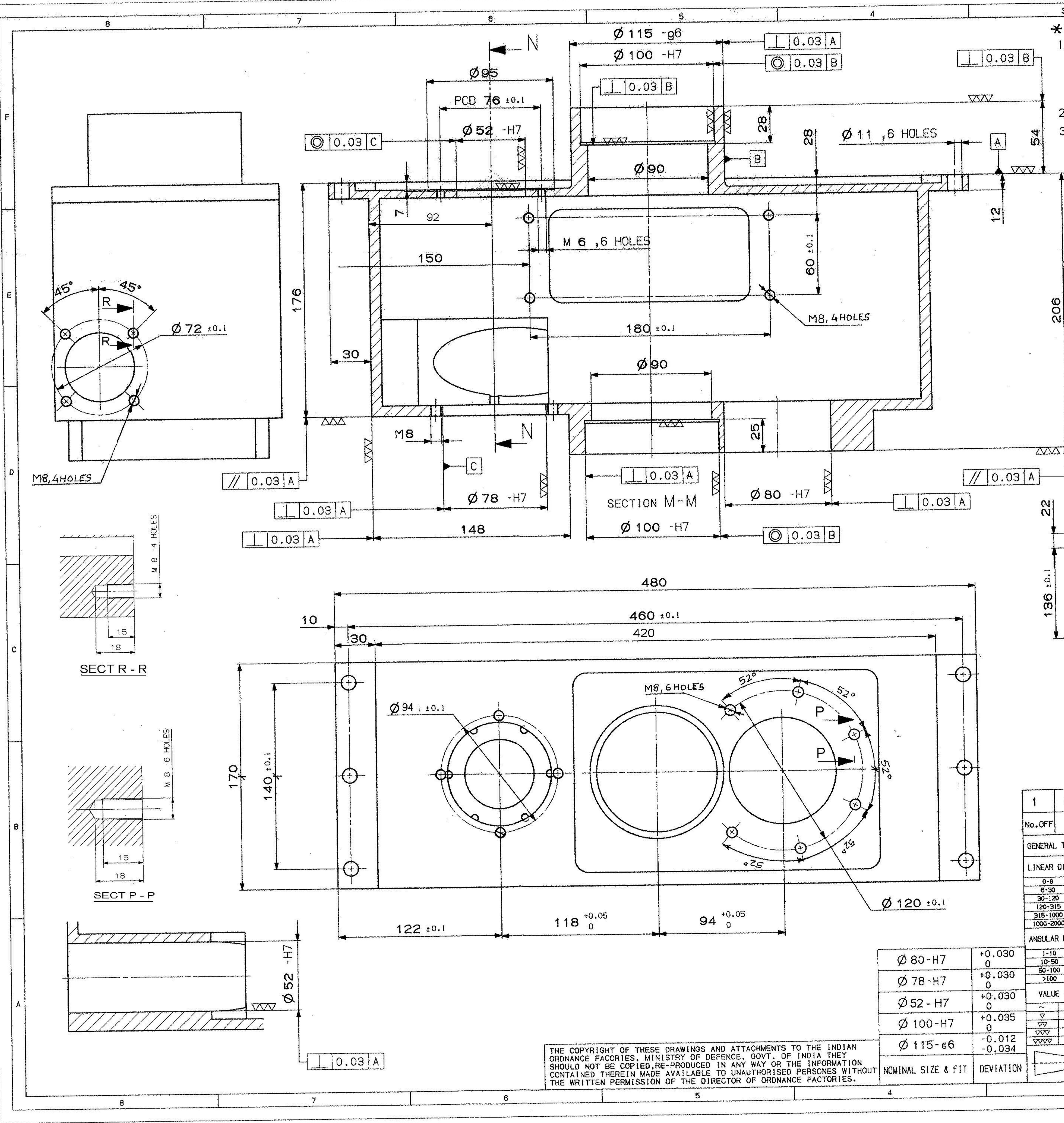




**** PAINTING :-**

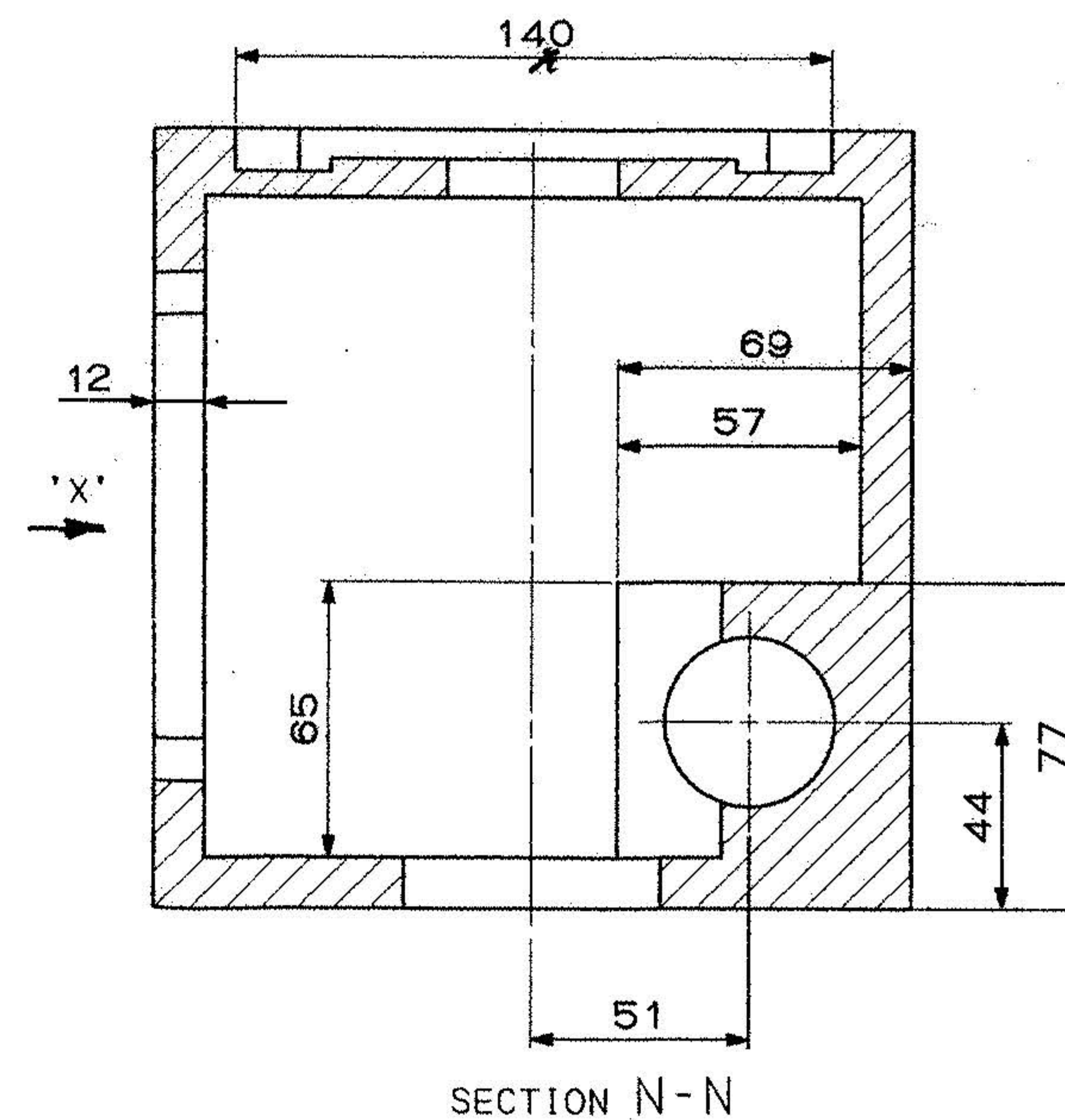
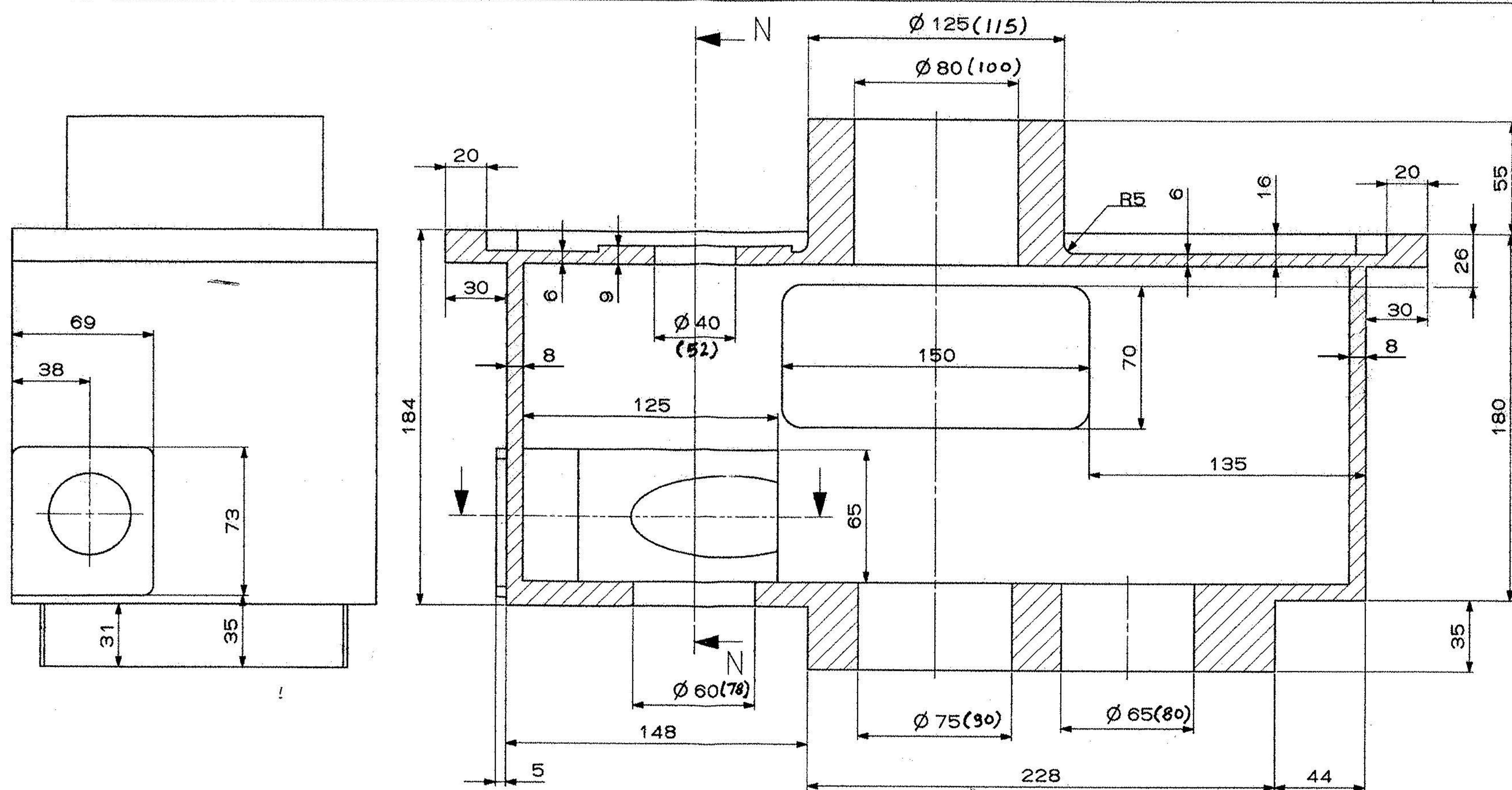
1. PRE-TREATMENT PRIMER TO DEF STAN 80-15 (Patt.No.8010 - 000116 & 8010 - 000117) AND PRIMER YELLOW ZINC CHROMATE TO IS:1874 (Patt.No.8010-000113) TO BE APPLIED BY FIRM WHO IS SUPPLYING STORE TO MPF AS PER DW-1134
2. PAINTING TO BE DONE AT MPF IN OR DURING ASSEMBLY AS PER DW-1134
3. DO NOT APPLY PRIMER AND PAINT ON THREAD AND CYLINDRICAL BORE FACE DIA 52 - H7, DIA 78 - H7, DIA 80 - H7, DIA 100 - H7 AND CYLINDRICAL FACE DIA115-g6

TO BE MANUFACTURED FROM DW-1108-4631-12-2

1	HOUSING-II		***		**	
No.OFF	DESCRIPTION	PART No.	MATERIAL	STANDARD	DIMENSIONS	REMARKS
GENERAL TOLERANCE						
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 DIMENSION						
No.OFF	DRG. No. OF ASSOCIATED PART	INDEX	ALTERATION	DATE	NAME	
30	1-10 ±1'	HOUSING-II			SCALE	DRAWN 02.01.08 VIJAY
30	10-50 ±30"	WORM AND WORM WHEEL ASSY			CHECKED H	14
30	50-100 ±20"	ELEVATING DRIVE ASSY			APPROVED 01/10/08	14
35	>100 ±10"	LRMR LAUNCHER			REPLACED BY	REVISION
12	VALUE IN "um"	KAVACH MOD-II			REPLACED FOR	I
34	~ ≥25	MACHINE TOOL PROTOTYPE FACTORY.			DESIGN Office	DRAWING No.
34	▽ 8-25	AMBERNATH				DW-1108-4631-12
34	▽▽ 1.6-8					
34	▽▽▽ 0.025-1.6					
34	▽▽▽▽ <0.025					
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APPROVED



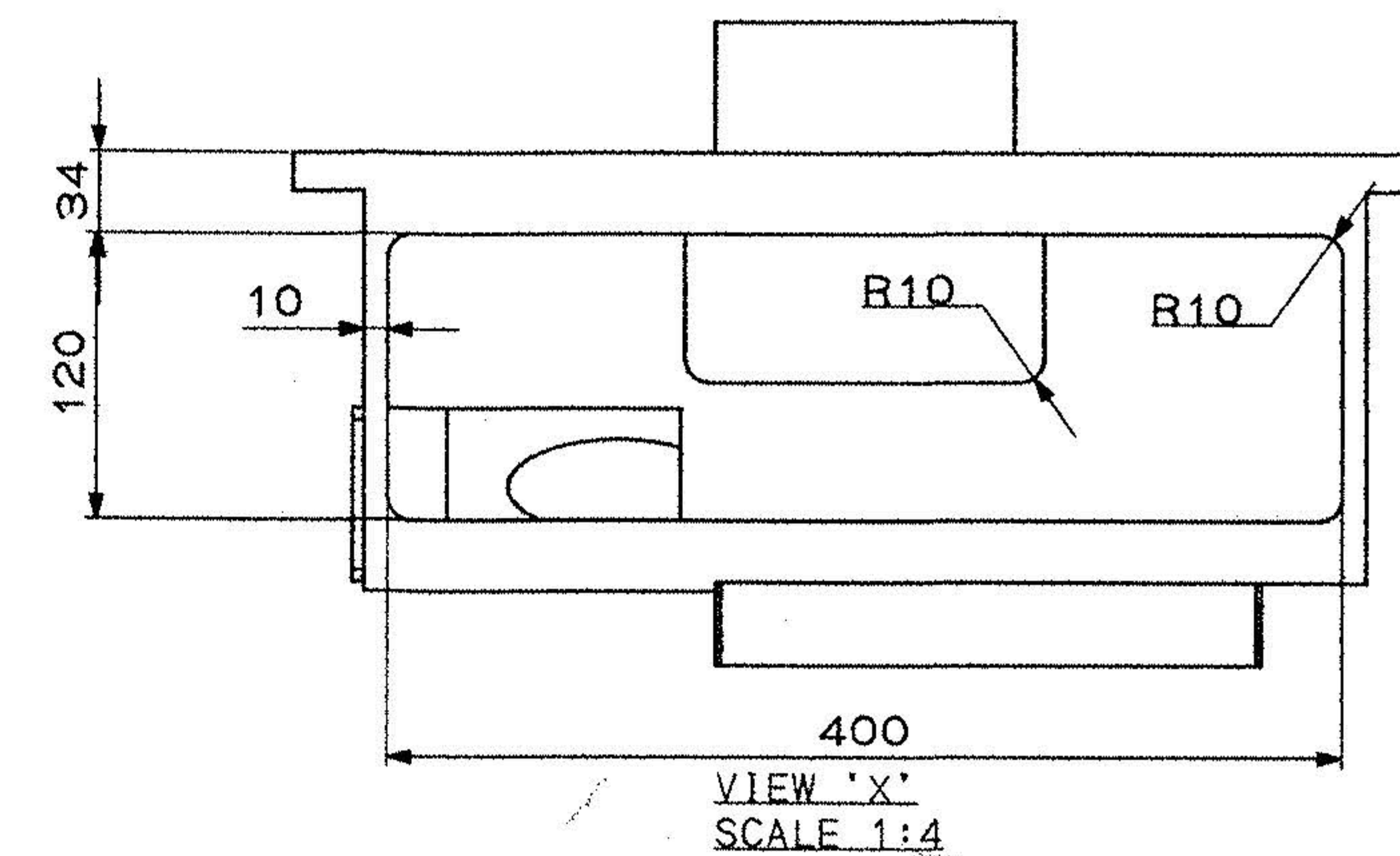
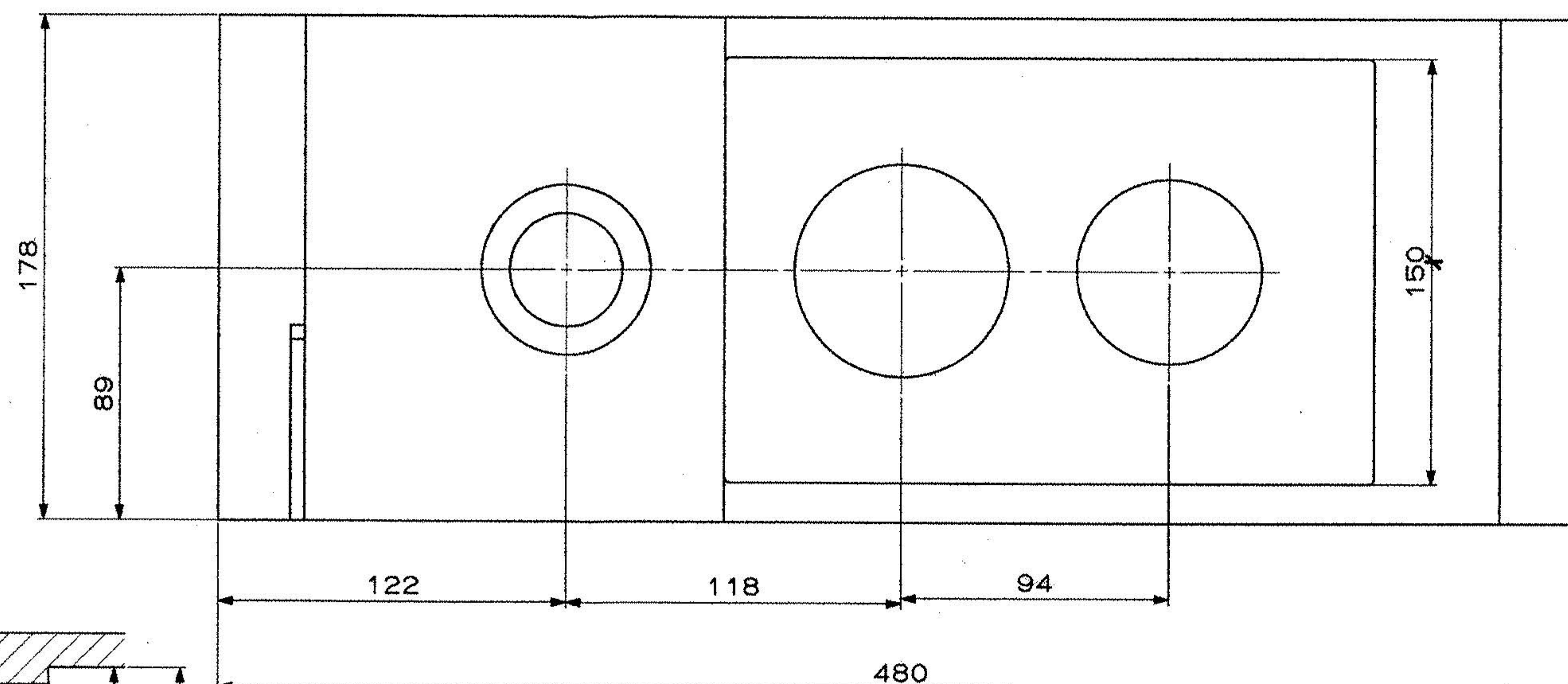
CHEMICAL COMPOSITION

ELEMENTS	IS:617-94, 5500 CONDITION T4
Mg %	9.5 - 11.0
Zr %	---
Be %	---
Ti %	0.2 Max.
Al %	Remainder
Fe %	0.4 Max.
Mn %	0.10 Max.
Cu %	0.1 Max.
Zn %	0.1 Max.
Si %	0.25 Max.
Pb %	0.05 Max.
Sn %	0.05 Max.
Ni %	0.1 Max.
Sum of impurities	---

MECHANICAL PROPERTIES

IS:617-94,
5500 CONDITION T4
TENSILE STRENGTH
275 MPa Min.
% ELONGATION ON 50
mm GAUGE
8 Min.

TO IS:617-94, 5500
CONDITION T4.

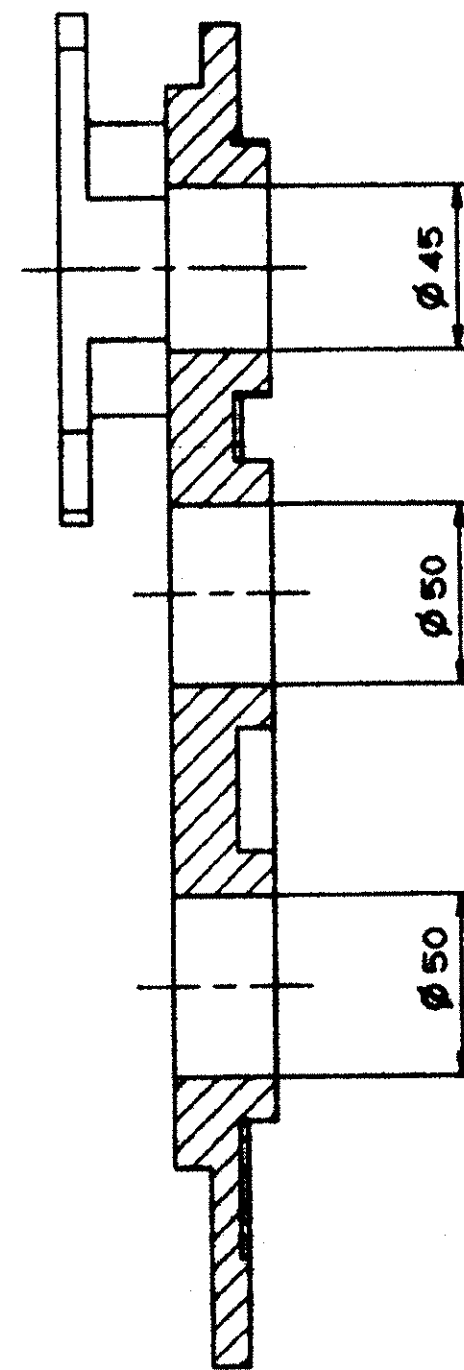
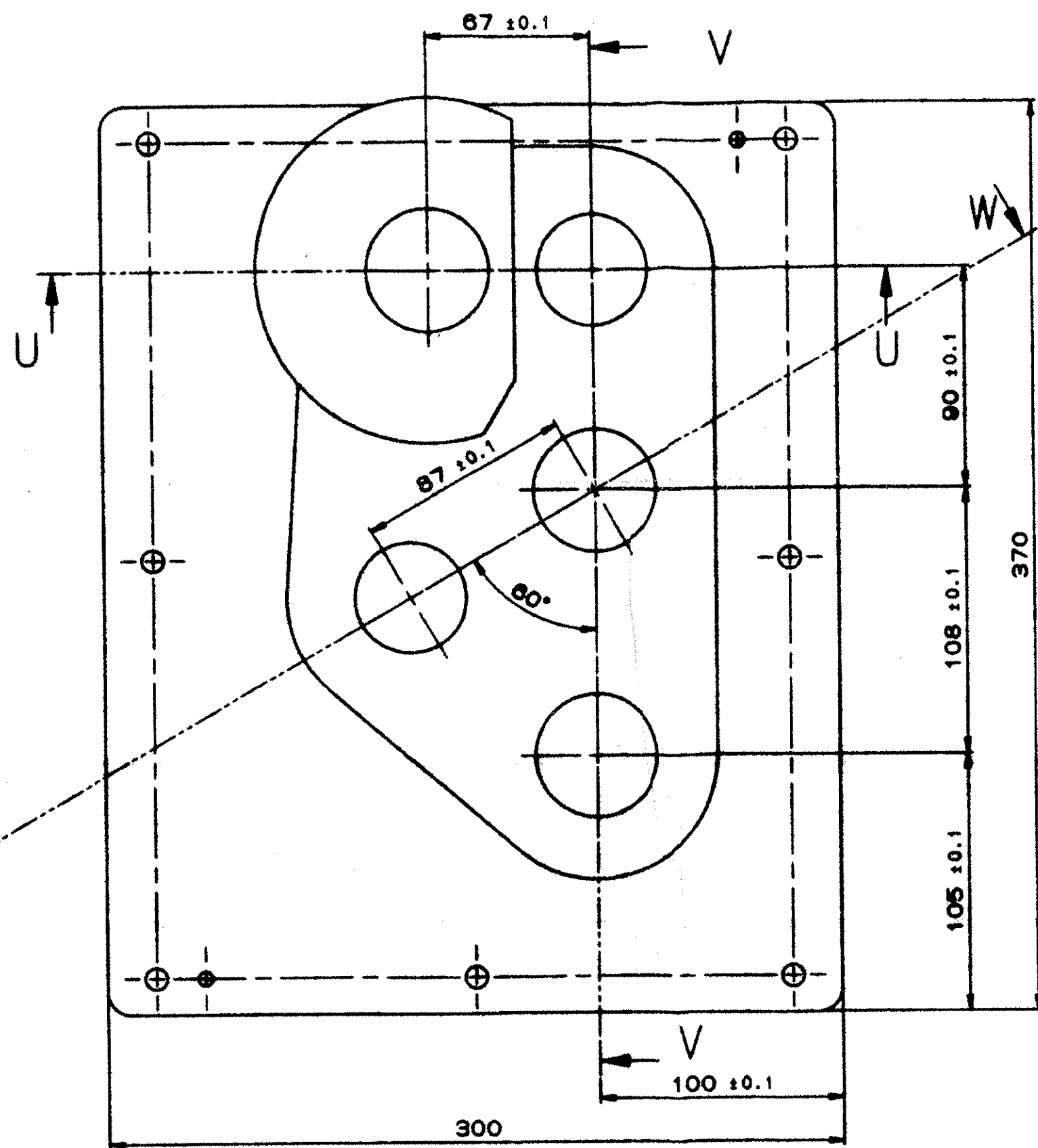


- NOTE:
1. CASTING TO BE DULY CLEANED & FREE FROM FINS, RUNNERS, RISERS ETC.
 2. CASTING TO BE FREE FROM CRACKS, BLOW HOLES & OTHER CASTING DEFECTS.
 3. CASTING TO BE SUPPLIED IN HEAT TREATED CONDITION TO ACHIEVE MECHANICAL PROPERTIES AS SPECIFIED.
 4. ALL UNSPECIFIED RADII ARE 3mm.
 5. CASTING AND TEST BAR SHOULD BE SUPPLIED AT SAME HEAT TREATED CONDITION.
 6. CASTING SHOULD BE TESTED FOR RADIOGRAPHIC TEST AS PER ASTM E-155-2000, LEVEL-II
 7. MACHINING SIZE SHOWN IN BRACKET

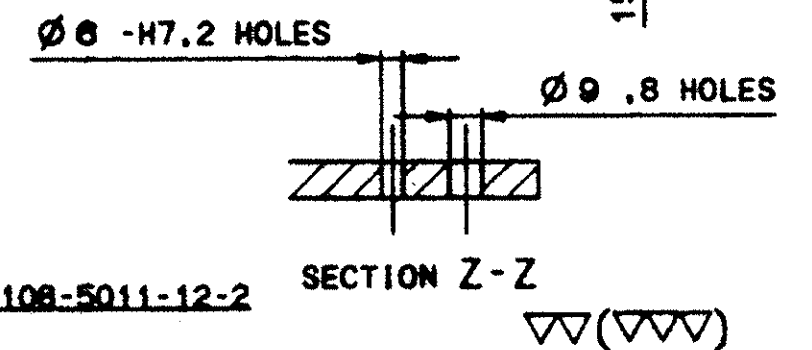
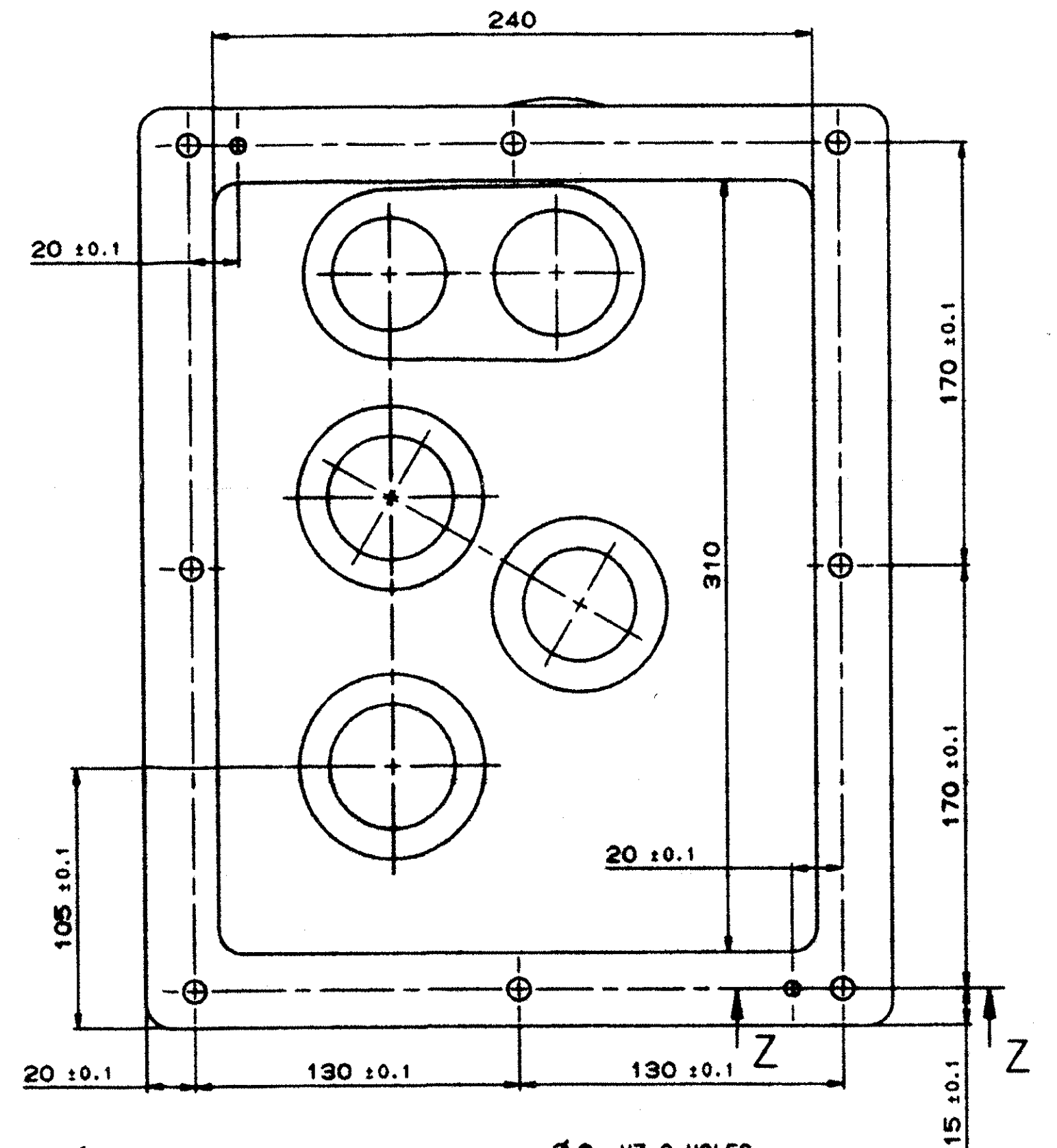
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NOMINAL SIZE & FIT DEVIATION

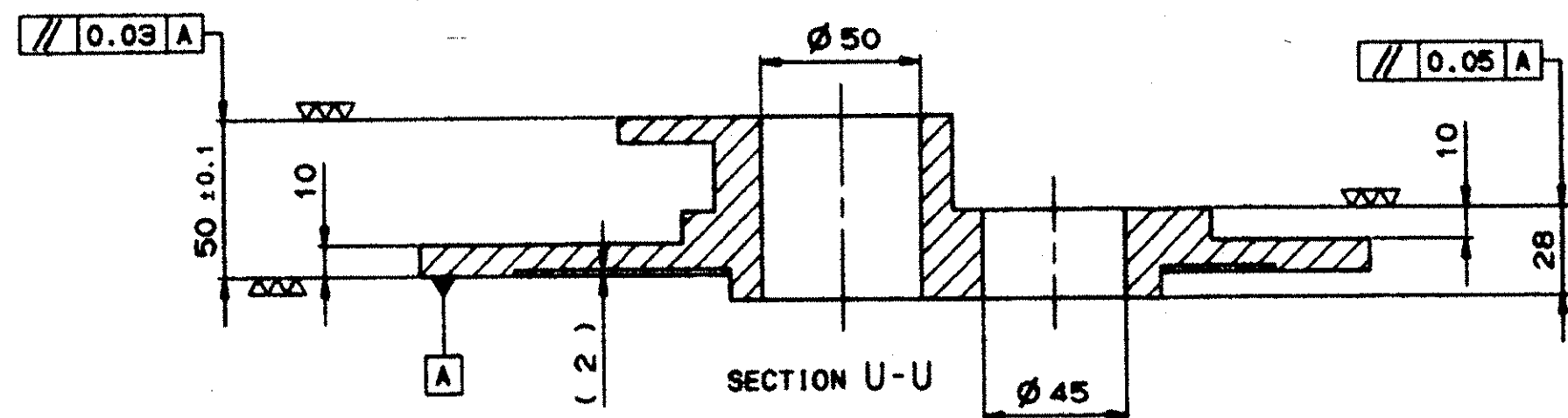
1	HOUSING-II		**			Wt:-11.75Kg
No.OFF	DESCRIPTION	PART No.	MATERIAL	STANDARD	DIMENSIONS	REMARKS
GENERAL TOLERANCE						
LINEAR DIMENSIONS						
0-6	±0.1					
6-30	±0.2					
30-120	±0.3					
120-315	±0.5					
315-1000	±0.8					
1000-2000	±1.2					
ANGULAR DIMENSION						
1-10	±1°					
10-50	±30'					
50-100	±20'					
>100	±10'					
VALUE IN "um"						
~	>25					
▽	8-25					
▽▽	1.6-8					
▽▽▽	0.025-1.6					
▽▽▽▽	<0.025					
CASTING FOR HOUSING-II						
WORM AND WORM WHEEL ASSY						
ELEVATING DRIVE ASSY						
LRMR LAUNCHER						
KAVACH WOP						
MACHINE TOOL PROTOTYPE FACTORY.						
AMBERNATH						
SCALE						
DRAWN 02.01.08 VIJAY						
CHECKED 11						
APPROVED 10/1/09						
REPLACED BY						
REPLACED FOR						
Design Office						
DRAWING No.						
DW-1108-4631-12-2						



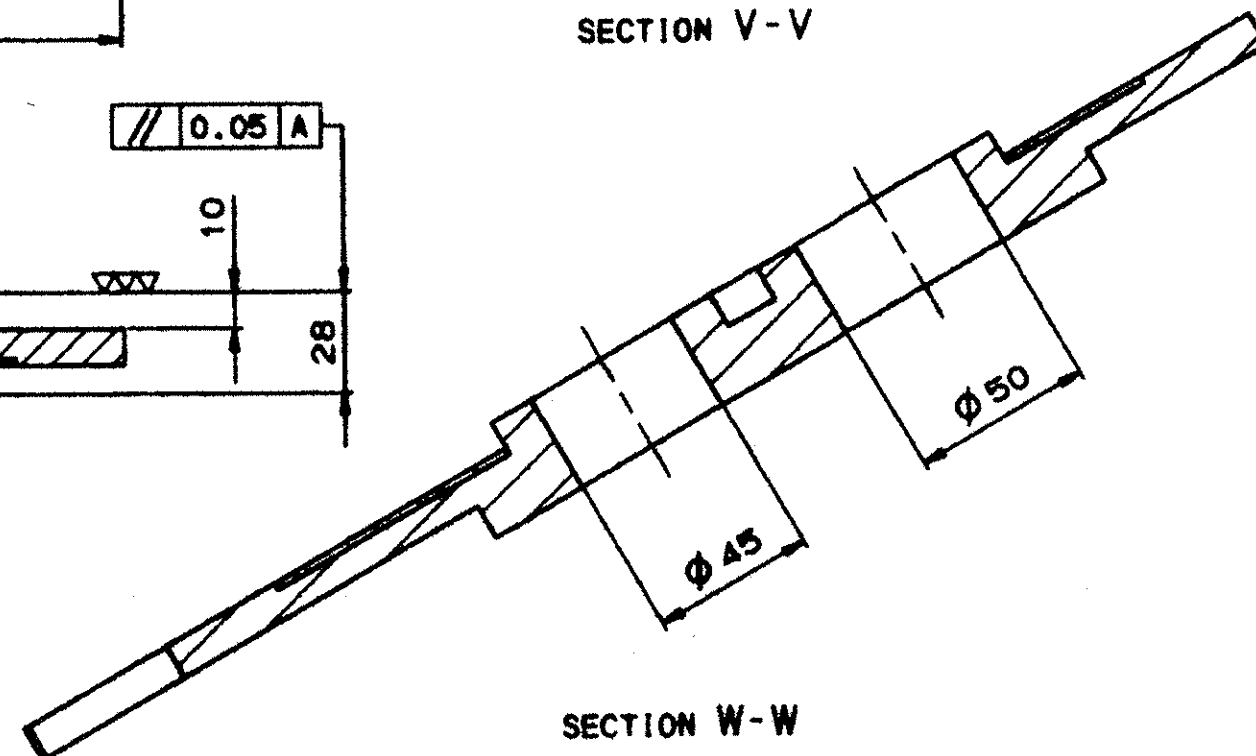
SECTION V-V



SECTION Z-Z



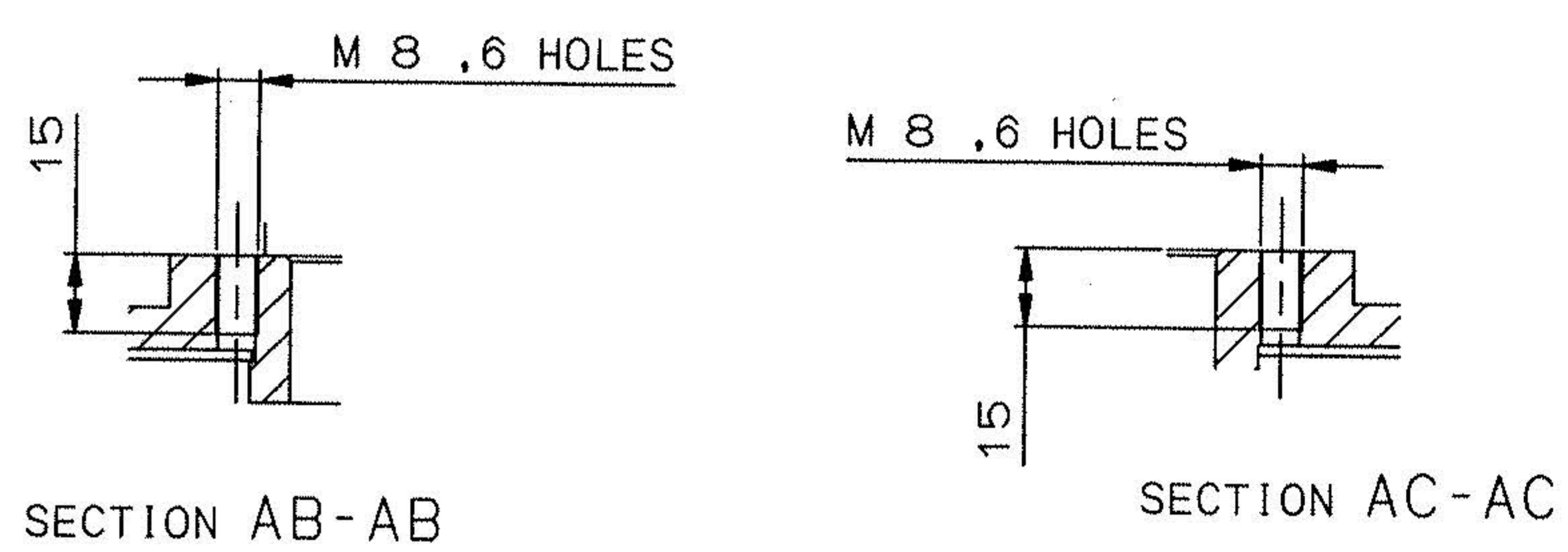
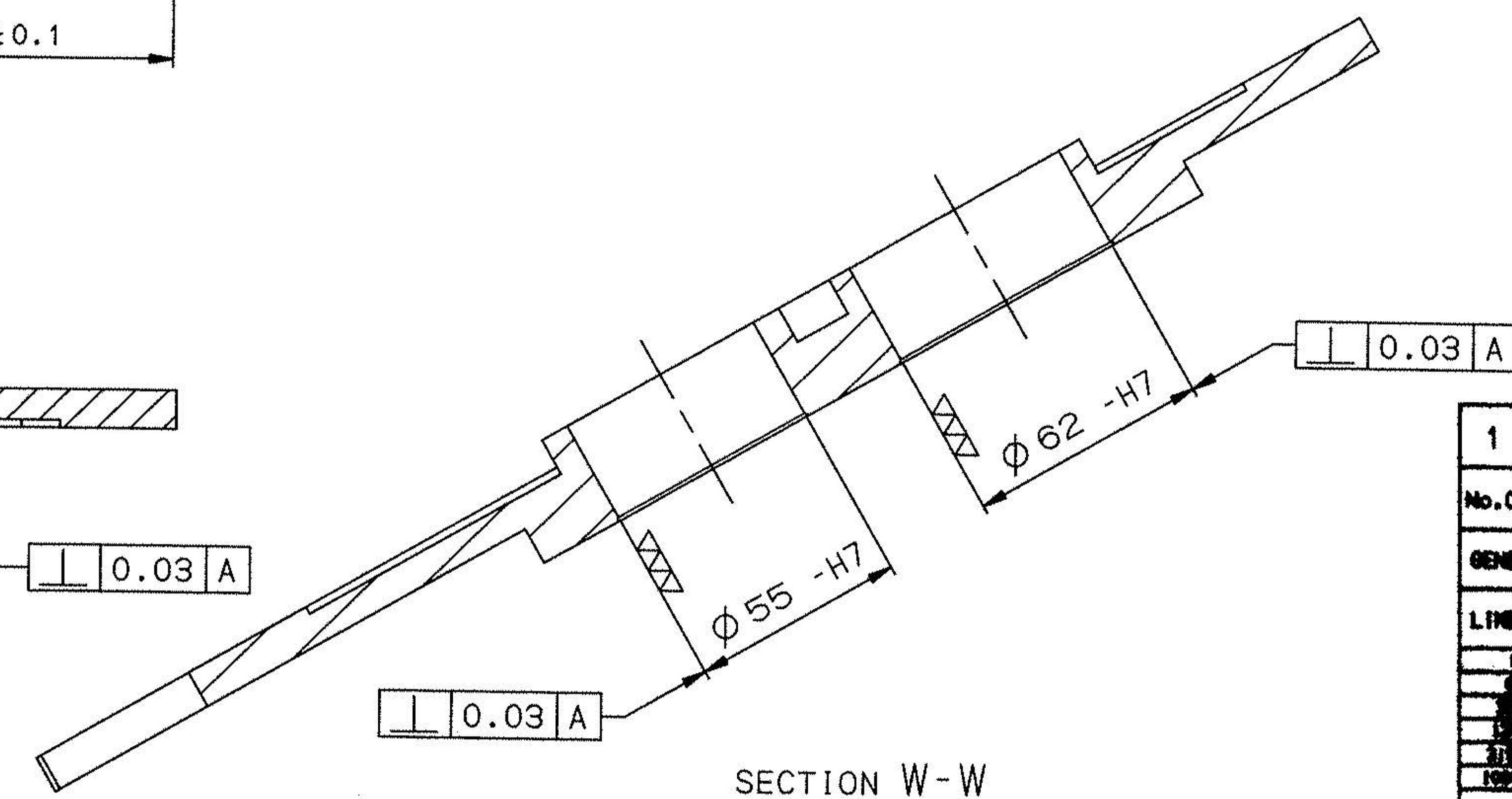
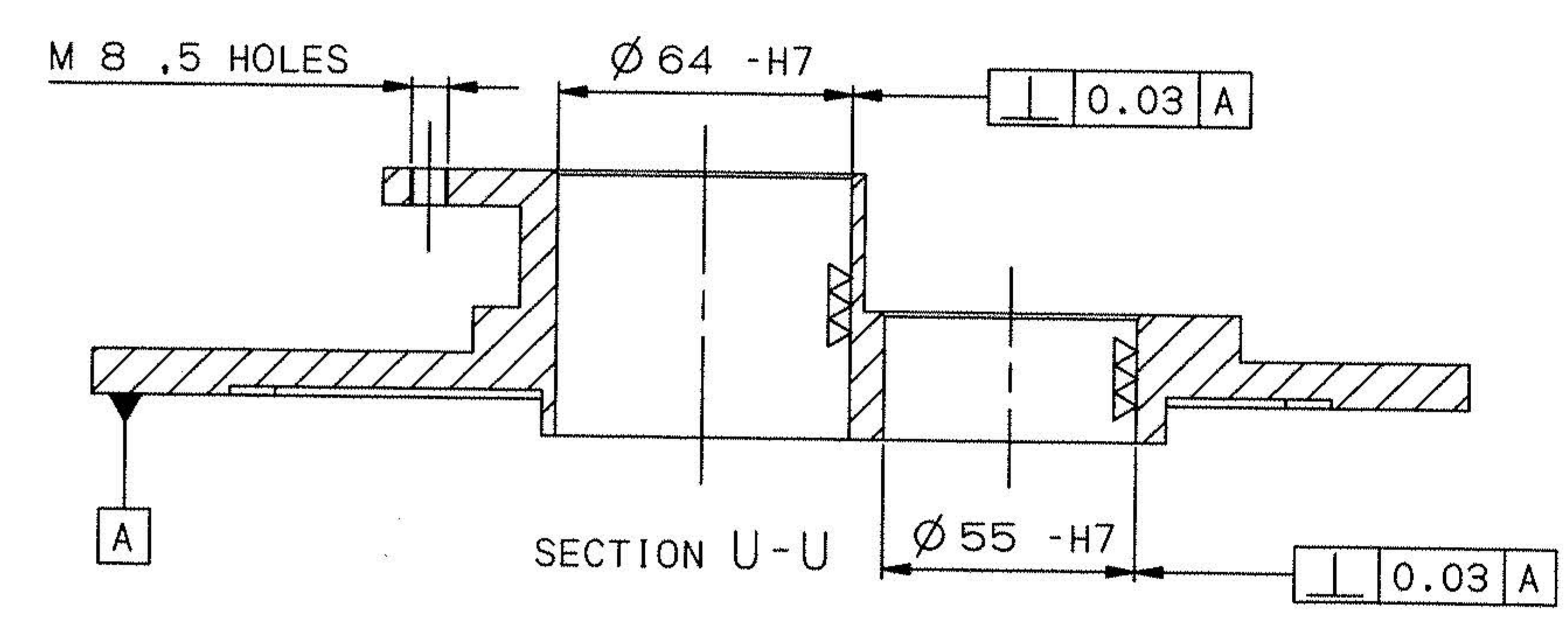
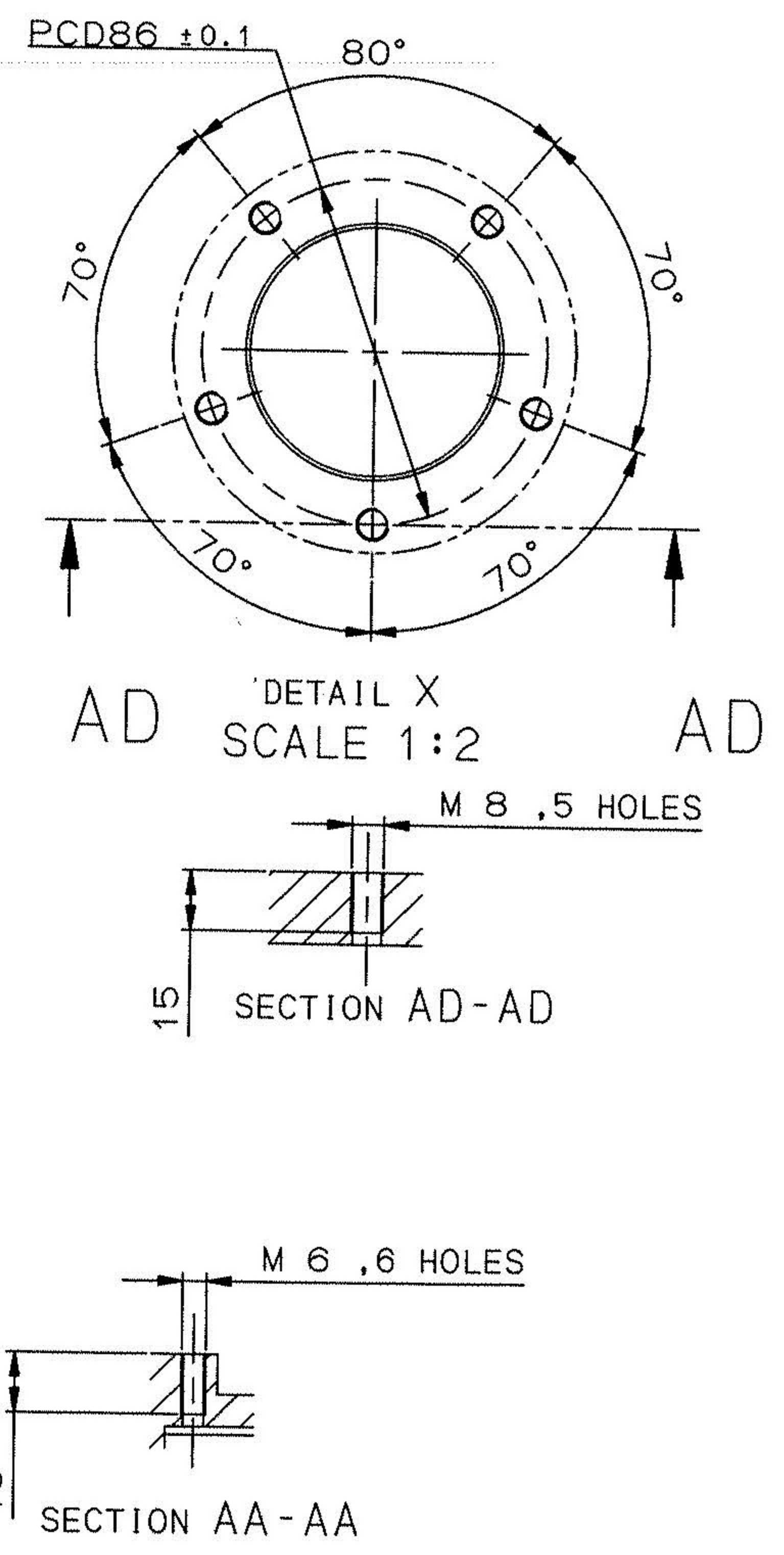
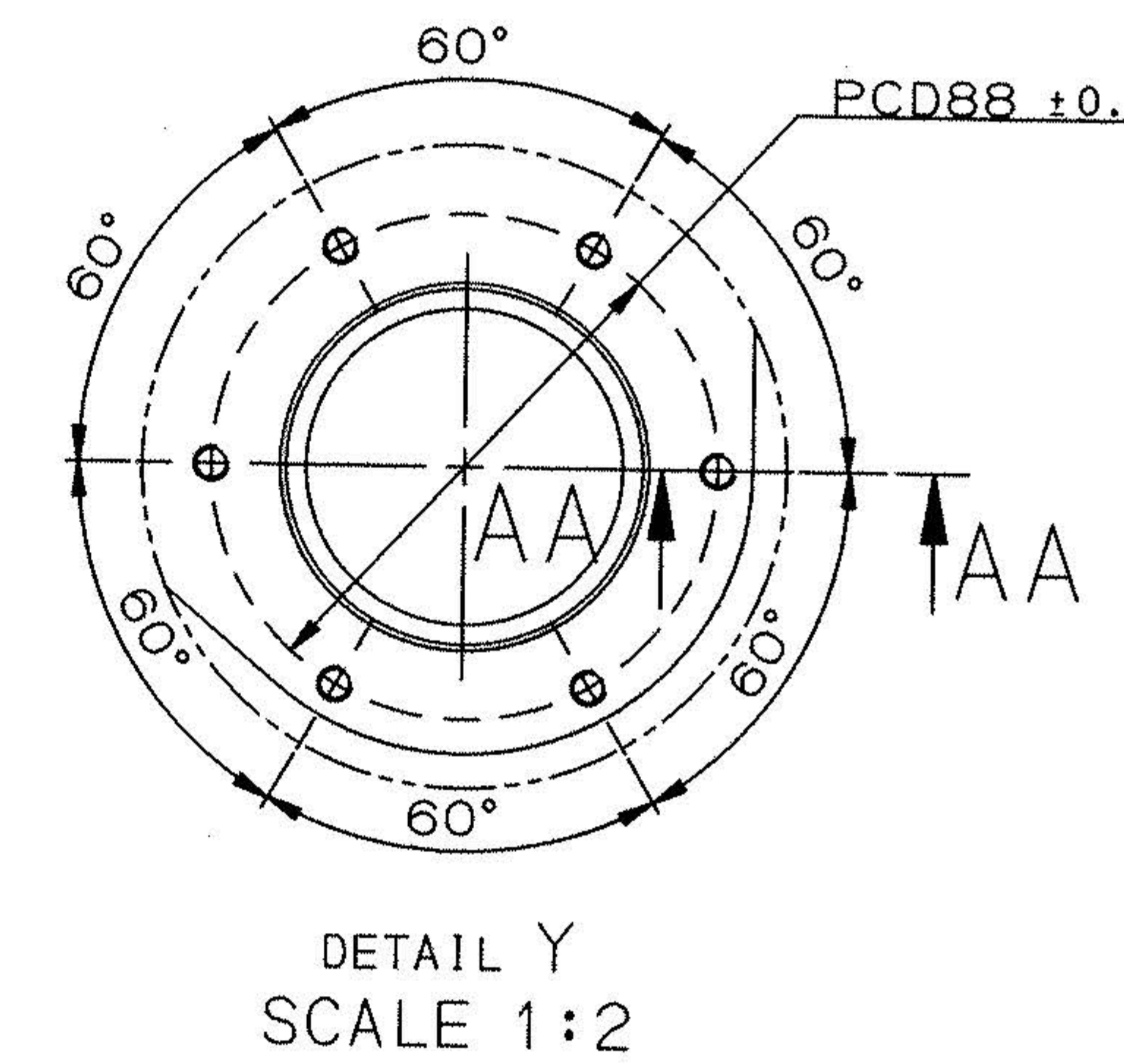
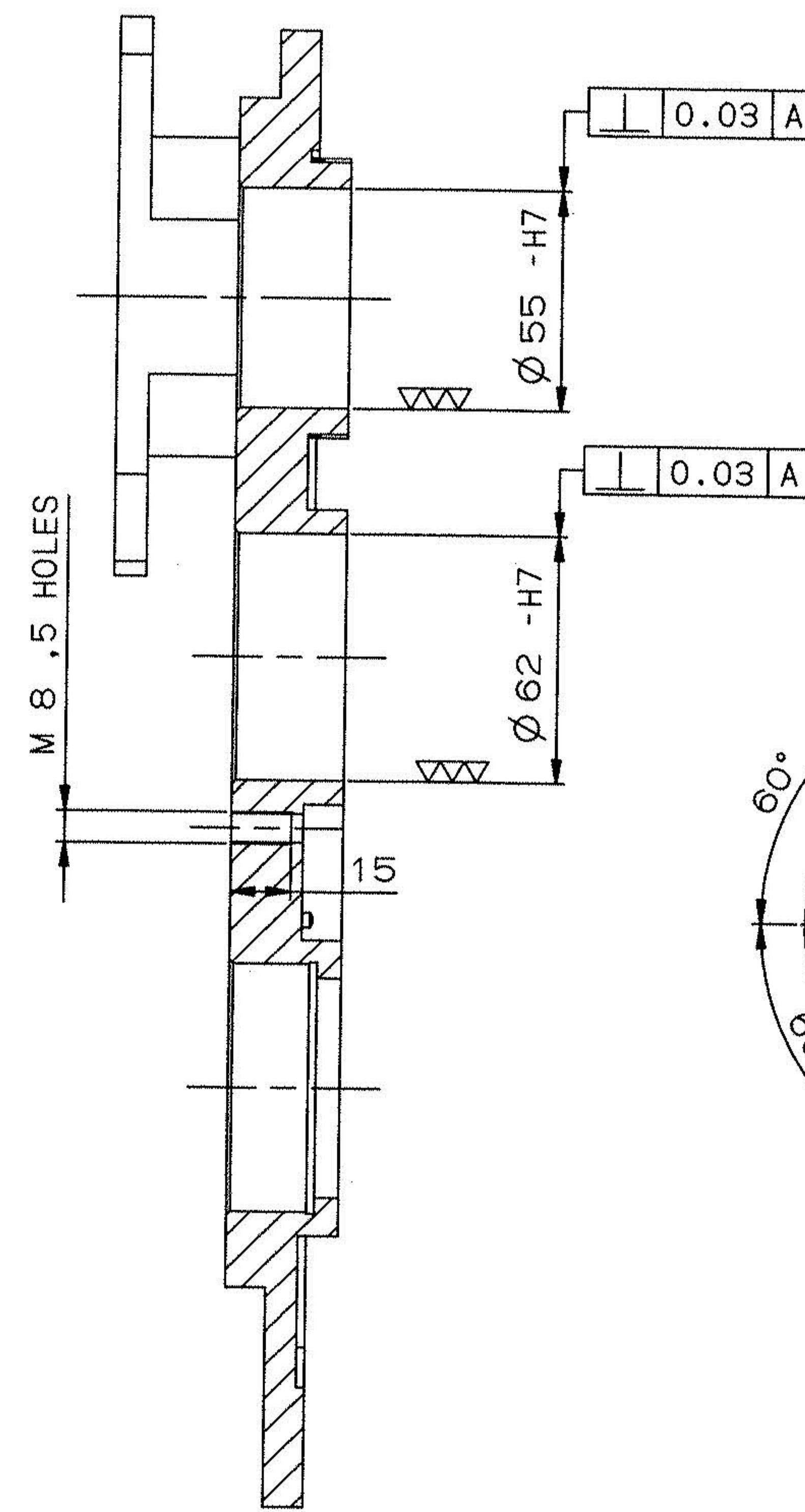
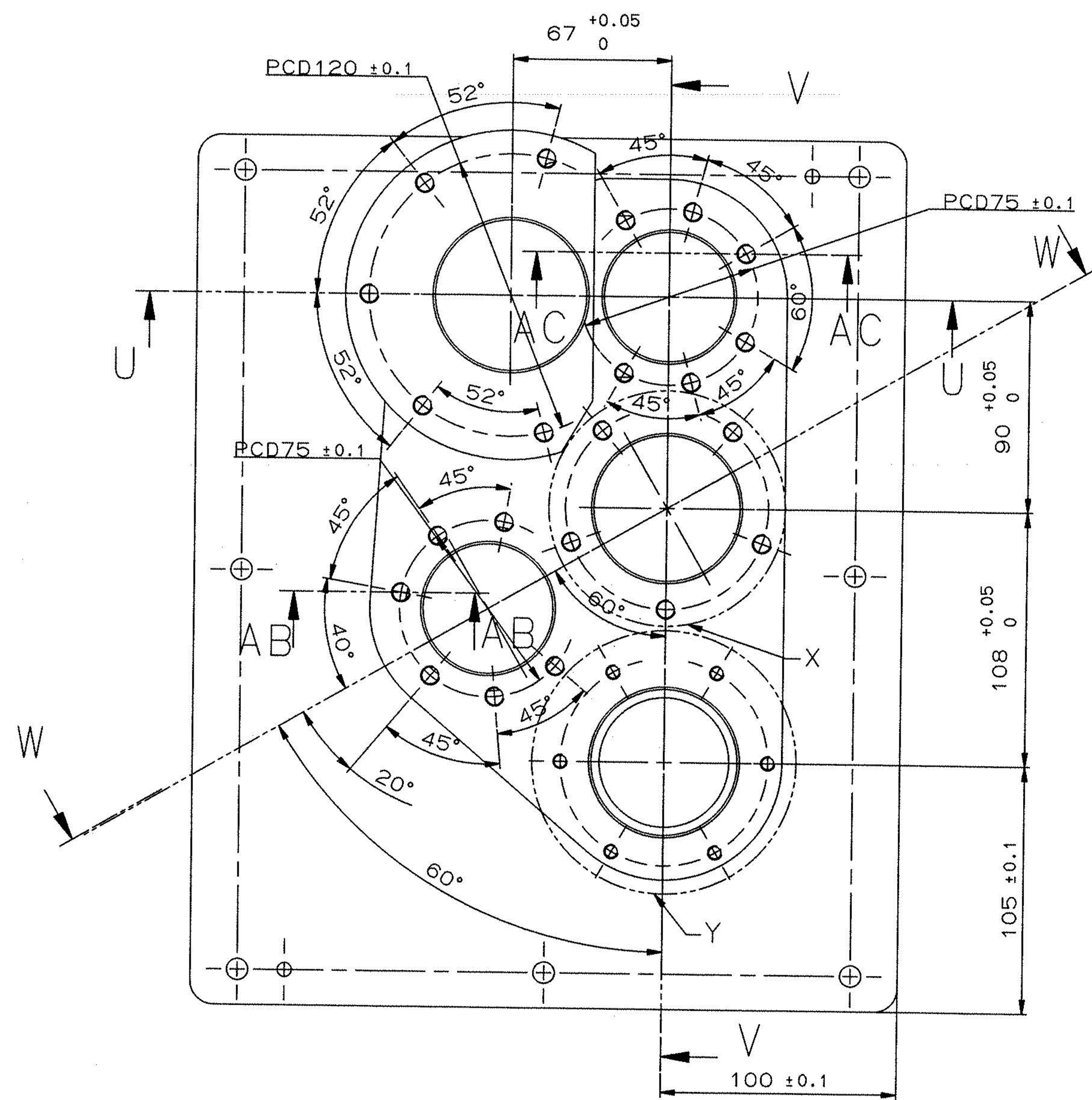
SECTION U-U



SECTION W-W

* TO BE MANUFACTURED FROM DW-1108-5011-12-2

1	COVER-V(R)		*						
No.Off	DESCRIPTION		PART No.	MATERIAL	STANDARD	DIMENSIONS		REMARKS	
GENERAL TOLERANCE									
LINEAR DIMENSIONS									
±0.1	±0.1								
±0.2	±0.2								
±0.3	±0.3								
±0.5	±0.5								
±0.7	±0.7								
±1.0	±1.0								
±1.5	±1.5								
±2.0	±2.0								
±2.5	±2.5								
±3.0	±3.0								
±4.0	±4.0								
±5.0	±5.0								
ANGULAR DIMENSION		No.Off	ENG. No. of ASSOCIATED PART		INDEX	ALTERATION		DATE	NAME
±10	±10								
±15	±15								
±20	±20								
±25	±25								
±30	±30								
VALUE IN "mm"									
~	~								
0	0.25								
0.25	1.0								
0.00	0.001								
0.00	0.002								
COVER-V(R)						SCALE		DRAWN	10.01.08 VIJAY
TRAINING DRIVE ASSY.						1:1		CHECKED	" P4
LRMR LAUNCHER								APPROVED	
KAVACH MOD-II						REPLACES BY			
						REPLACES FOR			
MACHINE TOOL PROTOTYPE FACTORY.		Design Office		DRAWING No.		DW-1108-50112(R)			
AMBERNATH									



- ***
PAINTING :-
1. PRE-TREATMENT PRIMER TO DEF STAN 80-15 (Patt.No.8010 - 000116 & 8010 - 000117) AND PRIMER YELLOW ZINC CHROMATE TO IS: 1874 (Patt.No.8010-000113) 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. DO NOT APPLY PRIMER AND PAINT ON THREAD AND CYLINDRICAL BORE FACE DIA 55 - H7, DIA 62 - H7, DIA 64 - H7

* TO BE MANUFACTURED FROM DW-1108-5011-12(R) AFTER MACHINING IN ASSY. TO DRG.NO. DW-1108-5700-12 (R) (VV)(VVV)

1 COVER-V		*		***	
No. OFF	DESCRIPTION	PART No.	MATERIAL	STANDARD	DIMENSIONS
GENERAL TOLERANCE					
LINEAR DIMENSIONS					
ANGULAR DIMENSION					
VALUE IN %					
COVER-V					
TRAINING DRIVE ASSY.					
LRMR LAUNCHER					
KAVACH MOD-II					
MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH					
DRAWING No. DW-1108-5011-12					

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NOMINAL SIZE & FIT	DEVIATION
Ø 55 -H7	+0.030 0
Ø 62 -H7	+0.030 0
Ø 64 -H7	+0.030 0

SCALE 1:1
DRAWN BY VIJAY
CHECKED BY
APPROVED BY
REVISION

