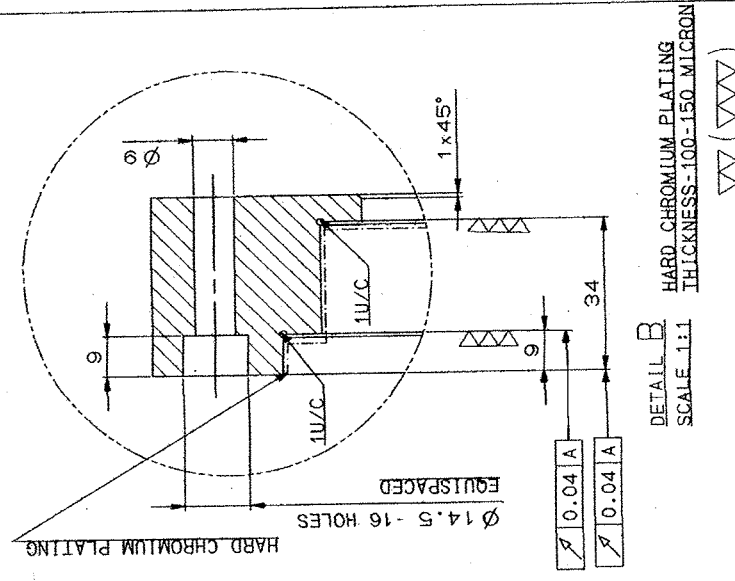
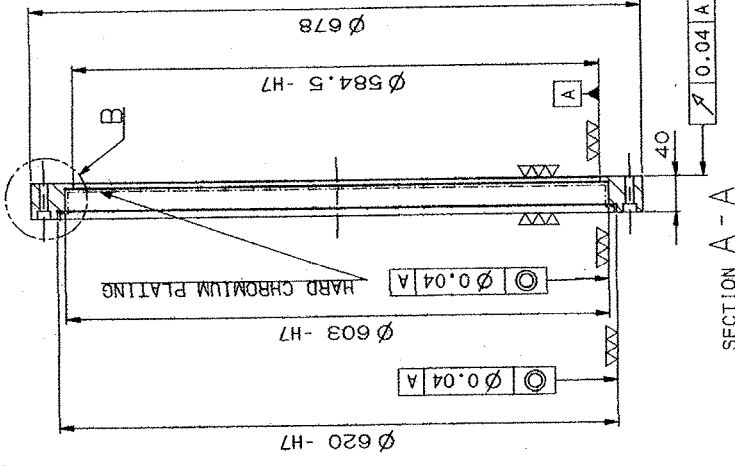
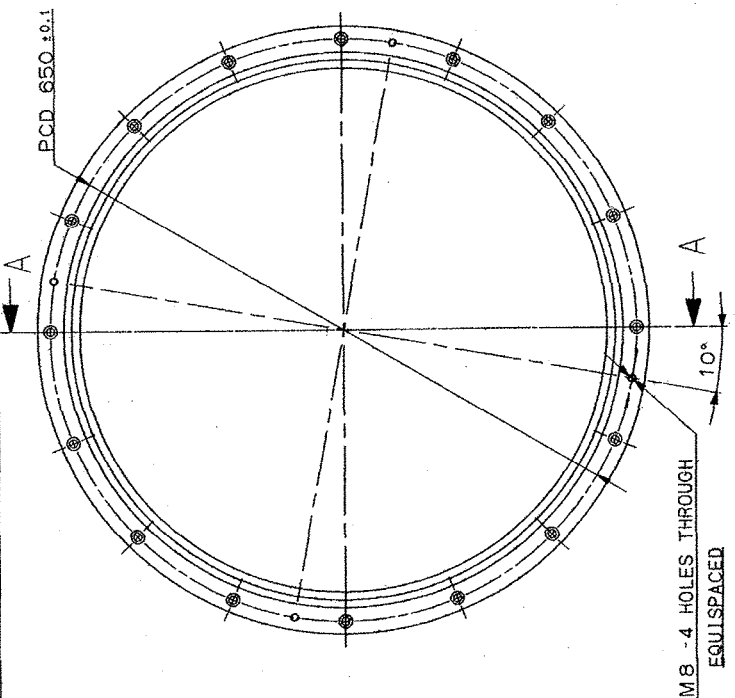


Approved
 15/11/2006



ALTERNATE MATERIAL :- EN-8 OR 080M40 BS:970 PART-I 1983

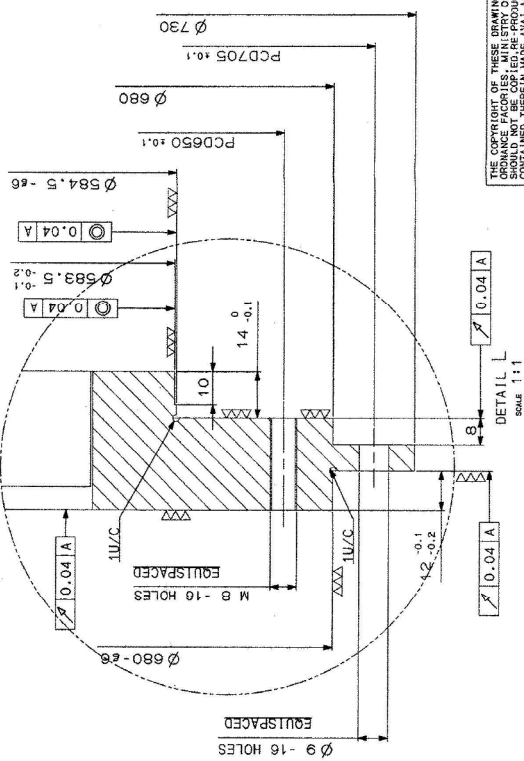
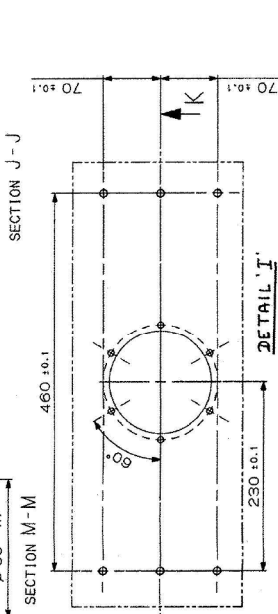
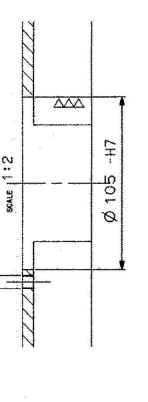
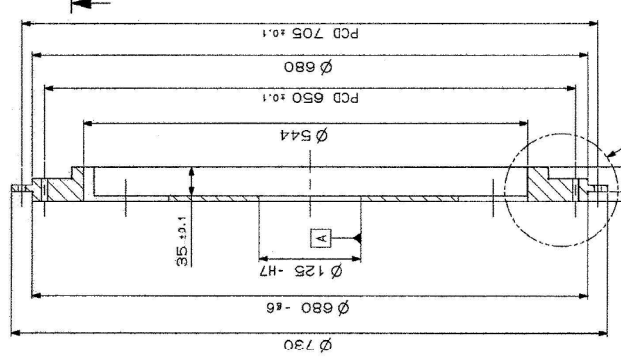
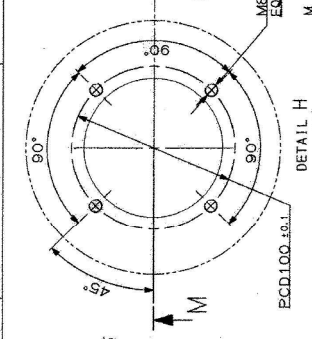
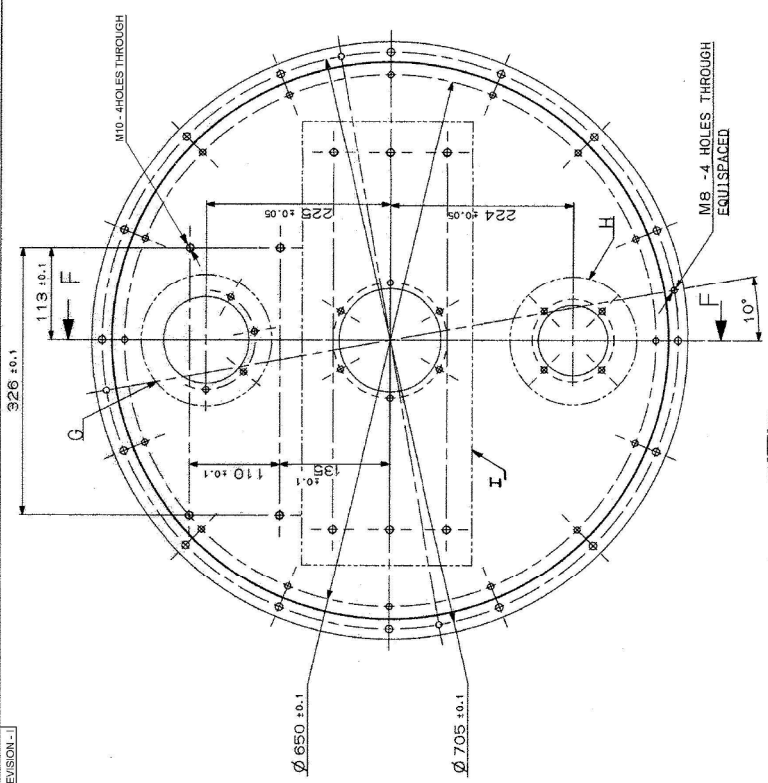
No. OFF	DESCRIPTION	PART No.	MATERIAL	STANDARD	DIMENSIONS	REMARKS
1	BEARING HOUSING		40C8	IS:5517		* *
GENERAL TOLERANCE						
LINEAR DIMENSIONS						
0-5	±0.1					
6-30	±0.2					
30-120	±0.3					
120-315	±0.5					
315-1000	±0.8					
1000-2000	±1.2					
ANGULAR DIMENSION						
1-10	±1°					
10-50	±30'					
50-100	±1'					
100	±10'					
VALUE IN "µm"						
~	±25					
~	±50					
~	±100					
~	±1.8-9					
~	0.025-1.8					
~	0.025					
No. OFF						
DRG. No. OF ASSOCIATED PART						
INDEX						
ALTERNATION						
DATE						
NAME						
SCALE						
DRAWN						
CHECKED						
APPROVED						
REPLACED BY						
REPLACED						
DRAWING No.						
DW - 1108 - 3002 - 13						

BEARING HOUSING
 TRAINING GEAR ASSEMBLY
 LR-MR LAUNCHER
 KAVACH MOD-II
 MACHINE TOOL PROTOTYPE FACTORY
 AMBARNATH

THE COPYRIGHT OF THESE DRAWINGS AND ATTACHMENTS TO THE INDIAN
 STANDARDS BUREAU, GOVT. OF INDIA. THE INFORMATION
 CONTAINED HEREIN IS NOT TO BE REPRODUCED IN ANY WAY OR THE INFORMATION
 CONTAINED THEREIN MADE AVAILABLE TO UNAUTHORISED PERSONS WITHOUT
 THE WRITTEN PERMISSION OF THE DIRECTOR OF ORDNANCE FACTORIES.

* * PHOSPHATING TO BE DONE AS PER IS:3618 CLASS-A1

REVISION-



ALTERNATE MATERIAL :- EN-8 OR
080M40 BS 970 PART-1 1983

* * *
PHOSPHATING TO BE DONE AS PER IS:3618 CLASS-A1

No. OF PART	DESCRIPTION	PART No.	MATERIAL	STANDARD	DIMENSIONS	REMARKS
1	HOUSING SUPPORT	40C8	IS:5517	**	**	**

GENERAL TOLERANCE	LINEAR DIMENSIONS	ANGULAR DIMENSION	No. OF ASSOCIATED PART	INEX	ALTERNATION
0.1	0.1	1'00"	1		
0.2	0.2	1'30"			
0.3	0.3	2'00"			
0.4	0.4	2'30"			
0.5	0.5	3'00"			
0.6	0.6	3'30"			
0.7	0.7	4'00"			
0.8	0.8	4'30"			
0.9	0.9	5'00"			
1.0	1.0	5'30"			
1.1	1.1	6'00"			
1.2	1.2	6'30"			
1.3	1.3	7'00"			
1.4	1.4	7'30"			
1.5	1.5	8'00"			
1.6	1.6	8'30"			
1.7	1.7	9'00"			
1.8	1.8	9'30"			
1.9	1.9	10'00"			
2.0	2.0	10'30"			

Ø 105-H7	Ø 85-H7	Ø 680-66	Ø 584.5-66	Ø 125-H7
+0.035	0	-0.024	-0.022	+0.040
0	0	-0.024	-0.022	0

SCALE	DRAWN	CHECKED	APPROVED	DATE	NAME
1:5	15.10.80	11/87			

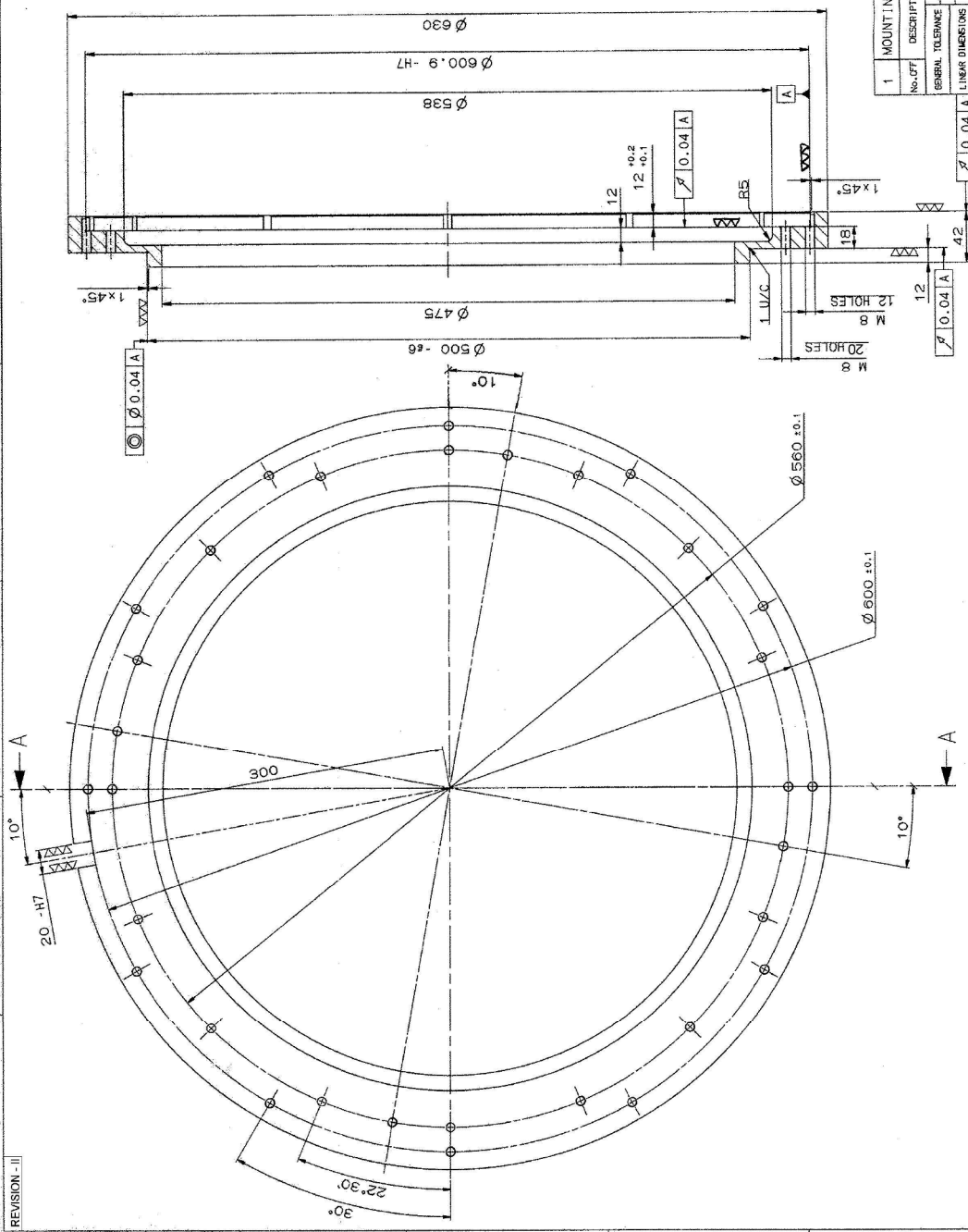
REVISION	BY	DATE	REASON
1			

DESIGNING GEAR ASSEMBLY
LEAFLET LAUNCHER
KAVACH MOD. II
MACHINE TOOL TECHNOLOGY FACTORY,
AMBURBATH

THE COPYRIGHT OF THESE DRAWINGS AND ATTACHMENTS TO THE INDIAN ORDNANCE FACTORIES, MINISTRY OF DEFENCE, GOVT. OF INDIA. THEY CONTAIN INFORMATION OF A CONFIDENTIAL NATURE AND ARE NOT TO BE DISCLOSED OR REPRODUCED WITHOUT THE WRITTEN PERMISSION OF THE DIRECTOR OF ORDNANCE FACTORIES.

DW-1108-30032
DW-1108-30032

REVISION - II



- ** PHOSPHATING AND PAINTING**
1. PHOSPHATING TO BE DONE AS PER IS:13618 CLASS-B
 2. PRIMER RED OXIDE TO STANDARD IS:12744 TO BE APPLIED BY FIRM WHO IS SUPPLYING STORE TO MPFAS PER DW-1134
 3. PAINTING TO BE DONE AT MPF IN OR DURING ASSEMBLY AS PER DW-1134
 4. DO NOT APPLY PRIMER AND PAINT ON THREAD AND CYLINDRICAL SURFACE HAVING DIA 500 - g6 AND BORE DIA 600.9 - H7

ALTERNATE MATERIAL - EN-8 OR
080M40 BS-970 PART-1 1983

No. OF	DESCRIPTION	PART No.	MATERIAL	STANDARD	DIMENSIONS	REMARKS
1	MOUNTING FRAME HOLDER	4008	IS:5517			**

GENERAL TOLERANCE	LINEAR DIMENSIONS
F8	0.1
F7	0.2
F6	0.3
F5	0.5
F4	1.0
F3	2.0
F2	5.0
F1	10.0

ANGULAR DIMENSION	VALUE IN °
12	± 0.07
18	0
22.30	-0.020
30	-0.060

DATE	NAME
2006	

SECTION A - A

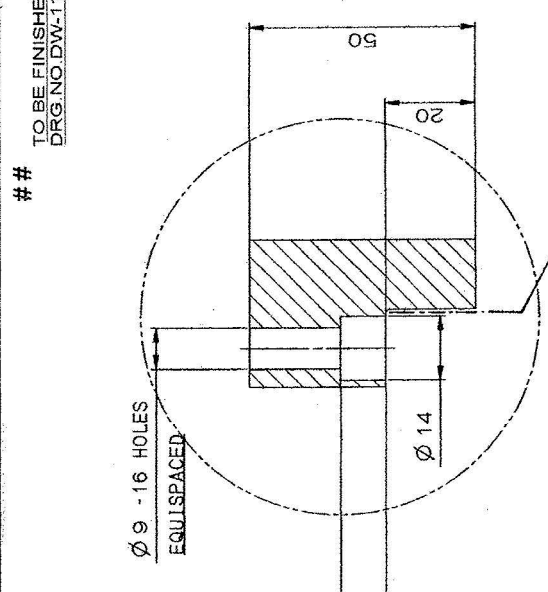
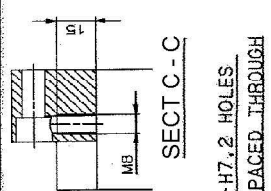
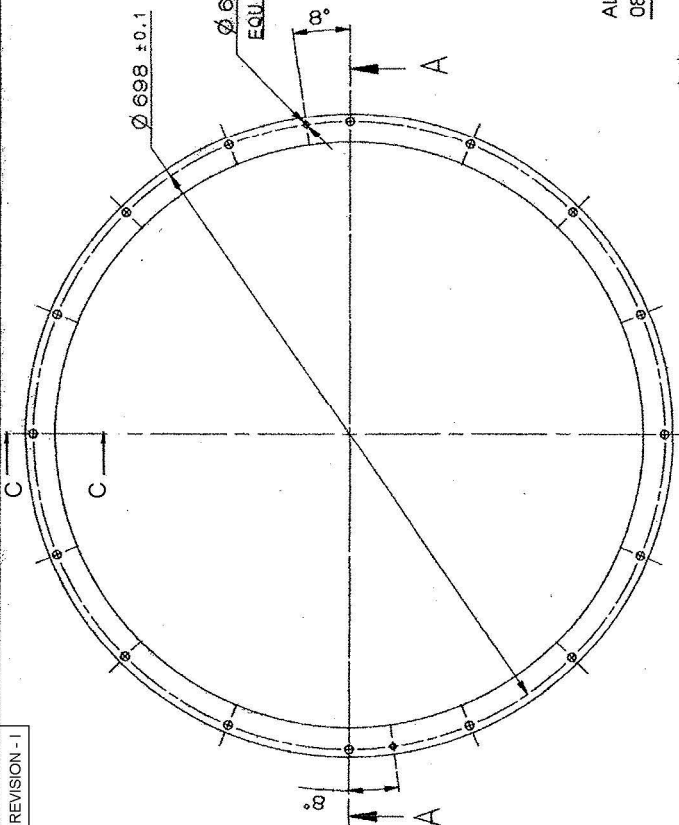
MOUNTING FRAME HOLDER
TRAINING GEAR ASSEMBLY
LIBRARY ARCHIVER
KAVACH MOD. II

SCALE: 1:2.5
CHECKED: [Signature]
APPROVED: [Signature]

DRWING INCH: DW-1108-3004-12
OFFICE: [Signature]

THE COPYRIGHT OF THESE DRAWINGS AND ATTACHMENTS TO THE INDIAN ORDNANCE FACTORIES, MINISTRY OF DEFENCE, GOVT OF INDIA. THEY CONTAINED HEREIN MADE AVAILABLE TO UNAUTHORISED PERSONS WITHOUT THE WRITTEN PERMISSION OF THE DIRECTOR OF ORDNANCE FACTORIES.

REVISION - I



TO BE FINISHED IN ASSY WITH
DRG. NO. DW-1108-3009-14

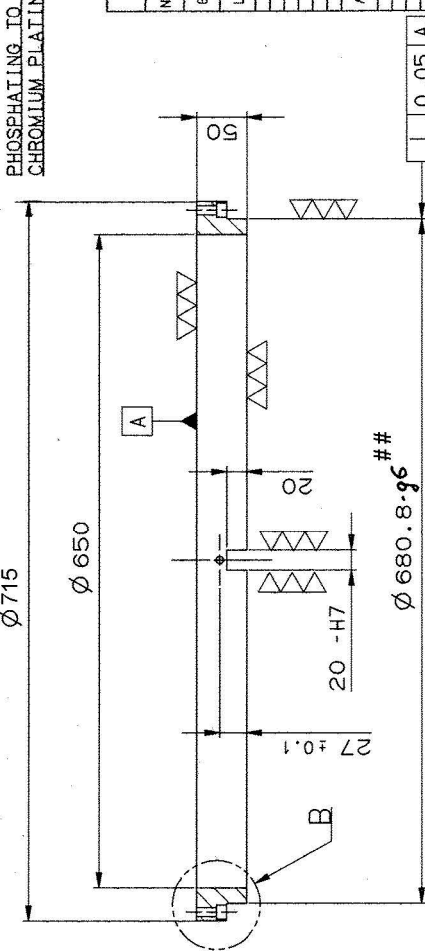
##

ALTERNATE MATERIAL :- EN-8 OR
080M40 BS-970 PART-I 1983

DETAIL B
SCALE 1:1

HARD CHROMIUM PLATING
THICKNESS 100-150 MICRON

PHOSPHATING TO BE DONE AS PER IS:3618 CLASS-A1
CHROMIUM PLATING TO BE DONE ON INDICATED SURFACE AFTER PHOSPHATING



SECTION A-A

680.8 ± 0.06 ##

20-H7	+0.021	DEVIATION
Ø 680.8 ± 0.06	-0.024	DEVIATION
	-0.074	DEVIATION
NOMINAL SIZE & FIT		

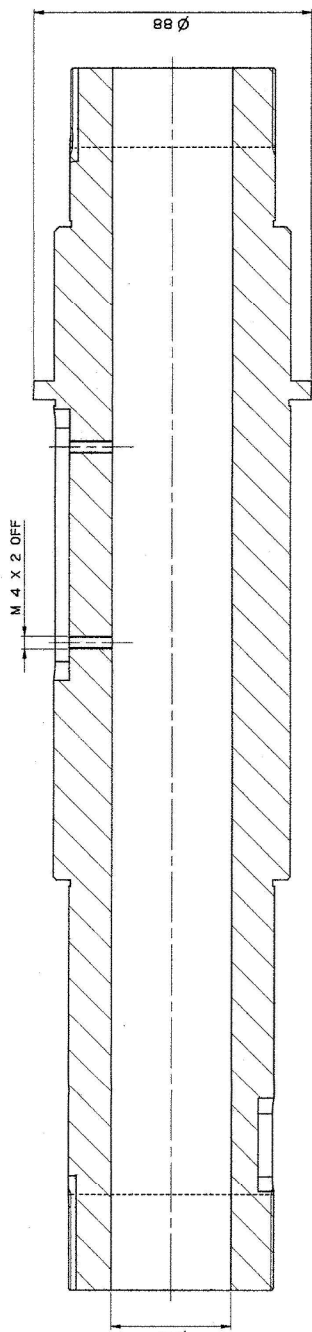
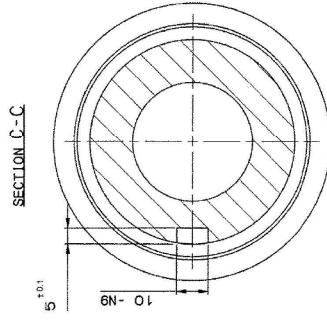
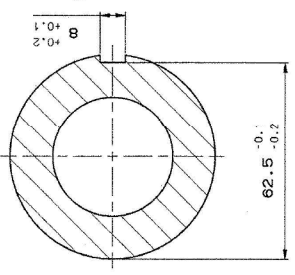
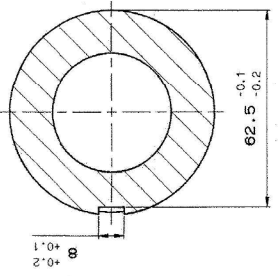
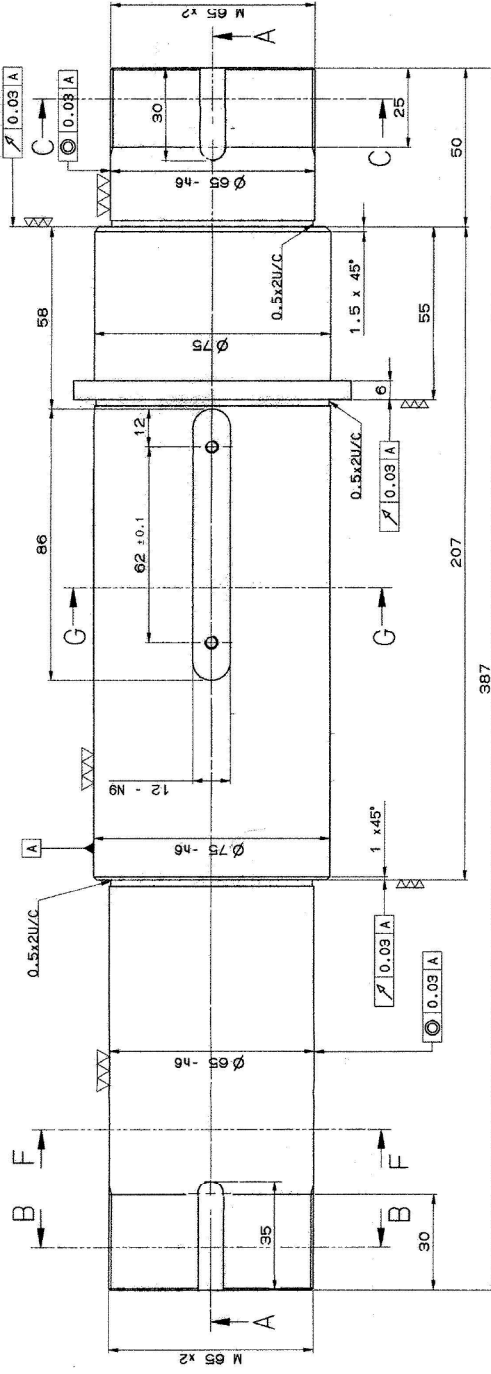
1	INNER RING	40C8, IS:5517	**			
No. OFF	DESCRIPTION	PART No.	MATERIAL	STANDARD	DIMENSIONS	REMARKS
GENERAL TOLERANCE						
LINEAR DIMENSIONS						
0-6	±0.1					
6-30	±0.2					
30-120	±0.3					
120-315	±0.5					
315-500	±0.8					
500-2000	±1.2					
ANGULAR DIMENSION						
1°-15°	±15'					
15°-30°	±30'					
30°-100°	±20'					
100°-180°	±10'					
VALUE IN "UM"						
±	±25					
∇	B-25					
∇∇	L-8-B					
∇∇∇	0.025-1.6					
∇∇∇∇	±0.025					
No. OFF						
DRG. No. OF ASSOCIATED PART						
INDEX						
ALTERNATION						
DATE						
NAME						
DRAWN						
CHECKED						
APPROVED						
REPLACED BY						
REPLACED FOR						
DRAWING No.						
DW-1108-3008-13						

INNER RING
TRAINING GEAR ASSEMBLY
LR-MR LAUNCHER
KAVACH MOD-I II
MACHINE TOOL PROTOTYPE FACTORY,
AMBERNATH

THE COPYRIGHT OF THESE DRAWINGS AND ATTACHMENTS TO THE INDIAN ORDNANCE FACTORIES, MINISTRY OF DEFENCE, GOVT. OF INDIA. THEY SHOULD NOT BE COPIED, REPRODUCED IN ANY WAY OR THE INFORMATION CONTAINED HEREIN BE MADE AVAILABLE TO ANY PERSONS WITHOUT THE WRITTEN PERMISSION OF THE DIRECTOR OF ORDNANCE FACTORIES.



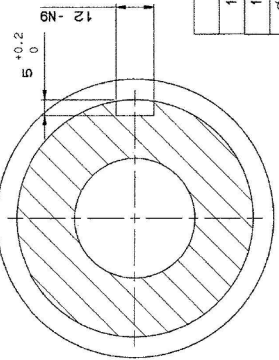
Handwritten signatures and initials at the top right of the drawing.



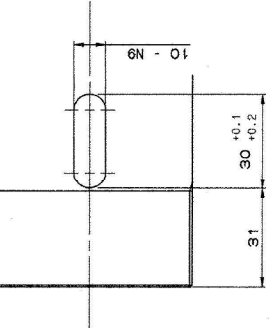
TOUGHENED
RC:28-32
VV (VVV)

ALTERNATE MATERIAL:- EN-24 OR 817M40 BS-970 PART-1 1983
* PHOSPHATING TO BE DONE AS PER IS:3018 CLASS-A1

SECTION A-A



SECTION G-G
THE COPYRIGHT OF THESE DRAWINGS AND ATTACHMENTS TO THE
ORIGINATOR'S MINISTRY OF DEFENCE, GOVT. OF INDIA. THE
CONTAINED HEREIN MAKE AVAILABLE TO UNCLASSIFIED PERSONS WITHOUT
THE WRITTEN PERMISSION OF THE DIRECTOR OF ORDNANCE FACTORIES.



SECTION F-F

No. OFF	DESCRIPTION	PART No.	MATERIAL	STANDARD	DIMENSIONS	REMARKS
1	HOLLOW SHAFT		40NiCr-Mn03	IS:5517-1993		**

GENERAL TOLERANCE	LINEAR DIMENSIONS	ANGULAR DIMENSIONS	NO. OF ASSOCIATED PART	INDEX	ALTERNATION
10-N9	0 - 0.05	10°			
12-N9	0 - 0.05	10°			
$\phi 75 - h6$	0 - 0.19	10°			
$\phi 85 - h6$	0 - 0.19	10°			

SCALE	DRAWN	CHECKED	DATE	NAME
1:1				

REVISION	DATE	BY	REASON

DESIGNER'S No.	DEPARTMENT	FACTORY

HOLLOW SHAFT
ELEVATING DRIVE ASSY.
LR-MR LAUNCHER
KAVACHOD
MACHINE TOOL ENGINEERING FACTORY,
BANGALORE

DW-1108-4606-12

APPROVED