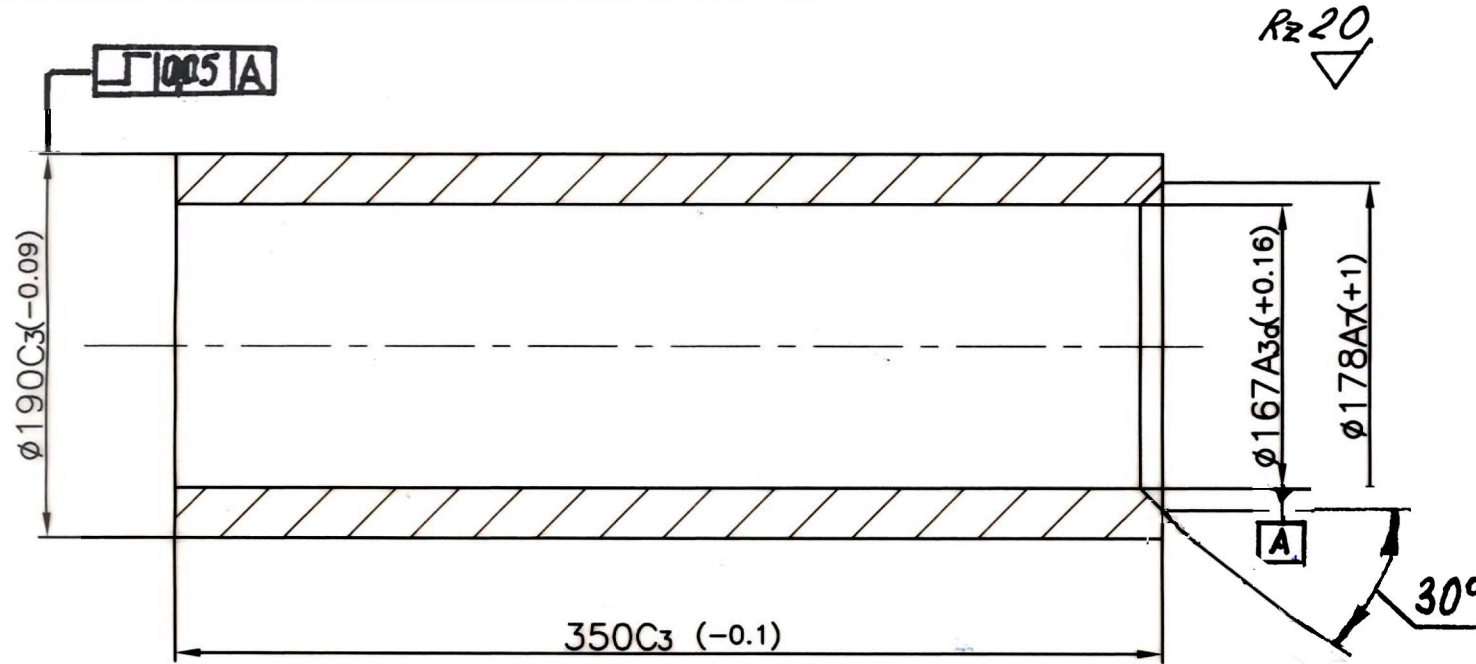


DRG. NO: M-11456

UNSPECIFIED TOLERANCES CONFORM TO IS 2102 (MEDIUM CLASS.)

PROVISIONAL



1. Curve Ø190 C₃ along whole length of component not more than 0.03 mm.
2. Machining and Heat Treatment from Opn. No. 0110 to 0280 as per TOT Process schedule.

MATL : 219 x36 GOST 8732-78
G30XH2MFA GOST 8731-87

HEAT TREATMENT : 45.5---51.5 HRCe.

ALT. EQUIVALENT MATERIAL:

Designation T11 to IS:11714 (PT-4)-86 as drawn & tempered condition to achieve mechanical properties as laid down in OEM STANDARD.

FURTHER MACHINING PROCESS SHOULD BE AS PER TOT PROCESS SCHEDULE OF 9A-621.02.003.

ALL DIMENSIONS ARE IN mm.

		SCHEDULE NO:		COMPT :	St. Drg. No. :	
		Scale:N.T.S	Projection Third Angle	CAMPLATE		AO-18 GUN OF AK-630M
		Drawn By: L.GHOSH		SEMI MACHINING STAGE DRG. OF CAMPLATE		
		Approved By: <i>[Signature]</i>				
		Concurred By: JWM/GUN-B		DRG. NO. M- 11456		
Date: 04/09/21 Sign: <i>[Signature]</i>						
DT. & SG.	DESCRIPTION	Vetted By: NAI / COSSIPORE	M/C -	NO. OF SHEETS: 1		
AMENDMENTS		Date: Sign.:	G & S FY. COSSIPORE	SHEET NO.: 1		