

# BONNET BOM FOR 1168245

S. No.	1168245				Part Name	QTY	241
1	1168245				ENGINE BONNET REAR	1	241
2	1168245	2028690			DRWG		111
3	1168245	2028687			ENGINE BONNET REAR	1	341
4	1168245	5193878			BRACKET	2	341
5	1168245	6364065			PLATE	2	341
6	1168245	6391759		GCF/50/39067	PLATE	2	341
7	1168245	10648372			HEXAGON SCREW N2-140-6X25	8	352
8	1168245	10994374			FLANGE SCREW N2-240-6X30	4	352
9	1168245	10312026			HEXAG LOCK NUT N3-64-6	12	352
10	1168245	10316983			WASHER N5-42-6.4X12	4	352
11	1168245	11001695			LOCKING FLUID W53-16-1	ERF	852
12	1168245	1168239			BRACKET	2	241
13		1168239	5193884		BRACKET WELDING DRG		121
14		1168239	5193883		PLATE	1	341
15		1168239	10302253		HOOK U2-25-1	1	352
16		1168239	38000075		WELDING SPEC A3025		1C1
17		1168239	11500144		ZINC PHOSPHAT Y3-11		951
18		1168239	11500267		PAINTING METHOD Y4-26-10-600		951

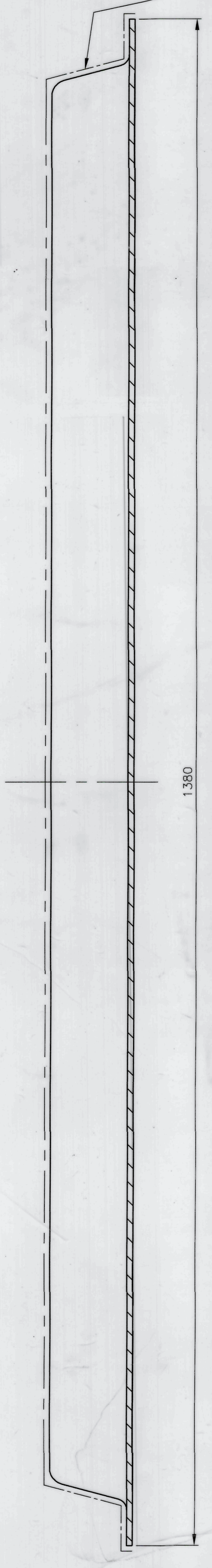
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 5193884  
 5193883  
 10302253  
 38000075  
 11500144  
 11500267

DESIGN  
 GLASSFIBER REINFORCED POLYESTER PLASTIC WITH  
 SMOOTH GEL-COATED OUTER SURFACE  
 CONTENT OF GLASS SHALL BE MIN.20W/LP  
 THE AREAS MARKED SHALL BE REINFORCED TO THE  
 STATED THICKNESS WITH SQUARE ROVING(550-650g/m<sup>2</sup>)

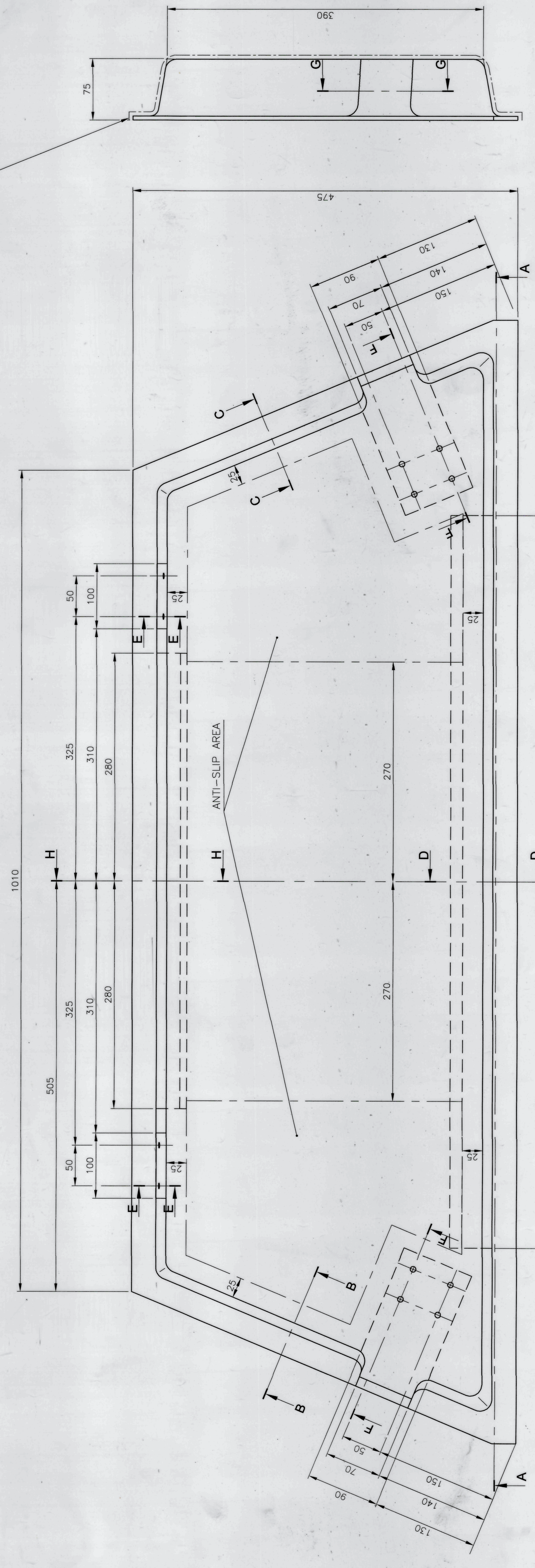
SURFACE TREATMENT  
 MARKED ANTI-SLIP AREAS TO BE COATED WITH SAND  
 (GRANULE SIZE 0.2-0.6mm)EVENLY.  
 OUTER SURFACE TO BE PAINTED WITH OLIVE-GREEN  
 IR-PROOF POINT W6-66-600 THICKNESS 20μm

REMOVE SHARP EDGES

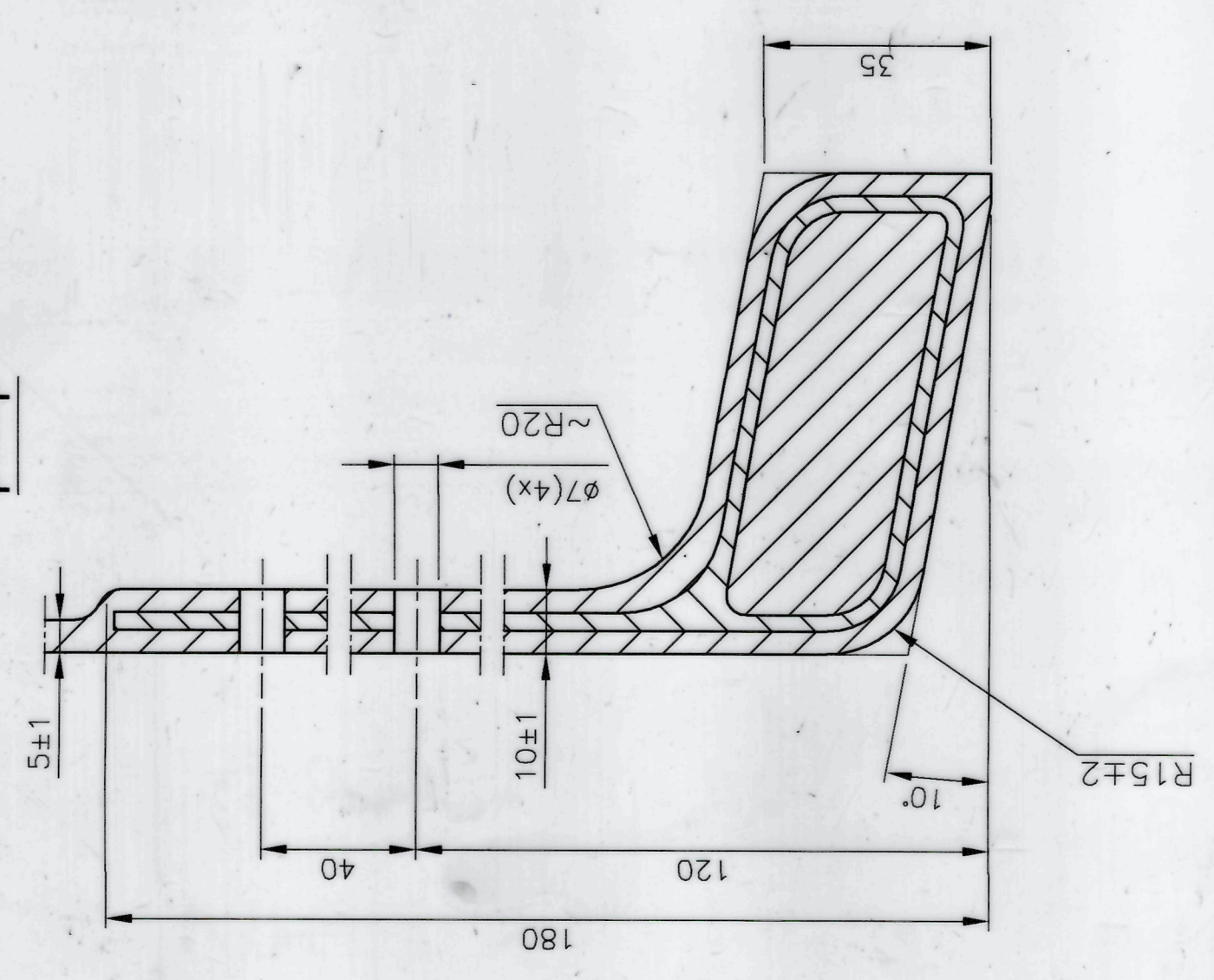
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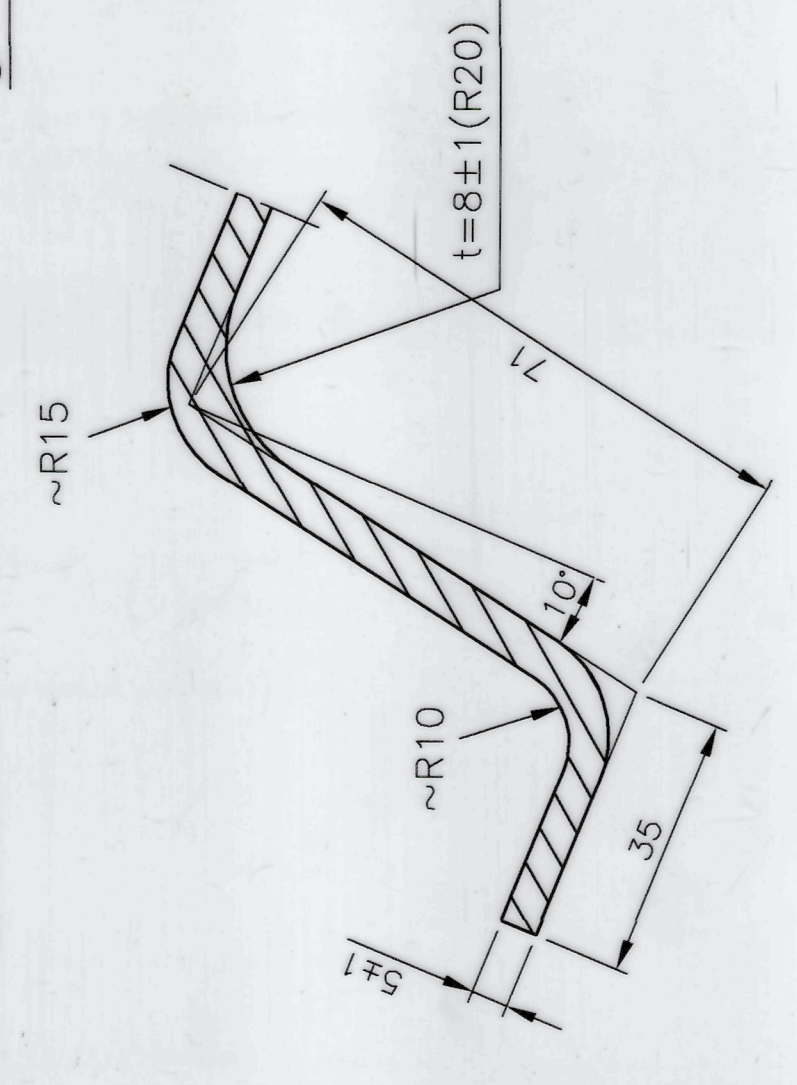
OUTER SURFACE



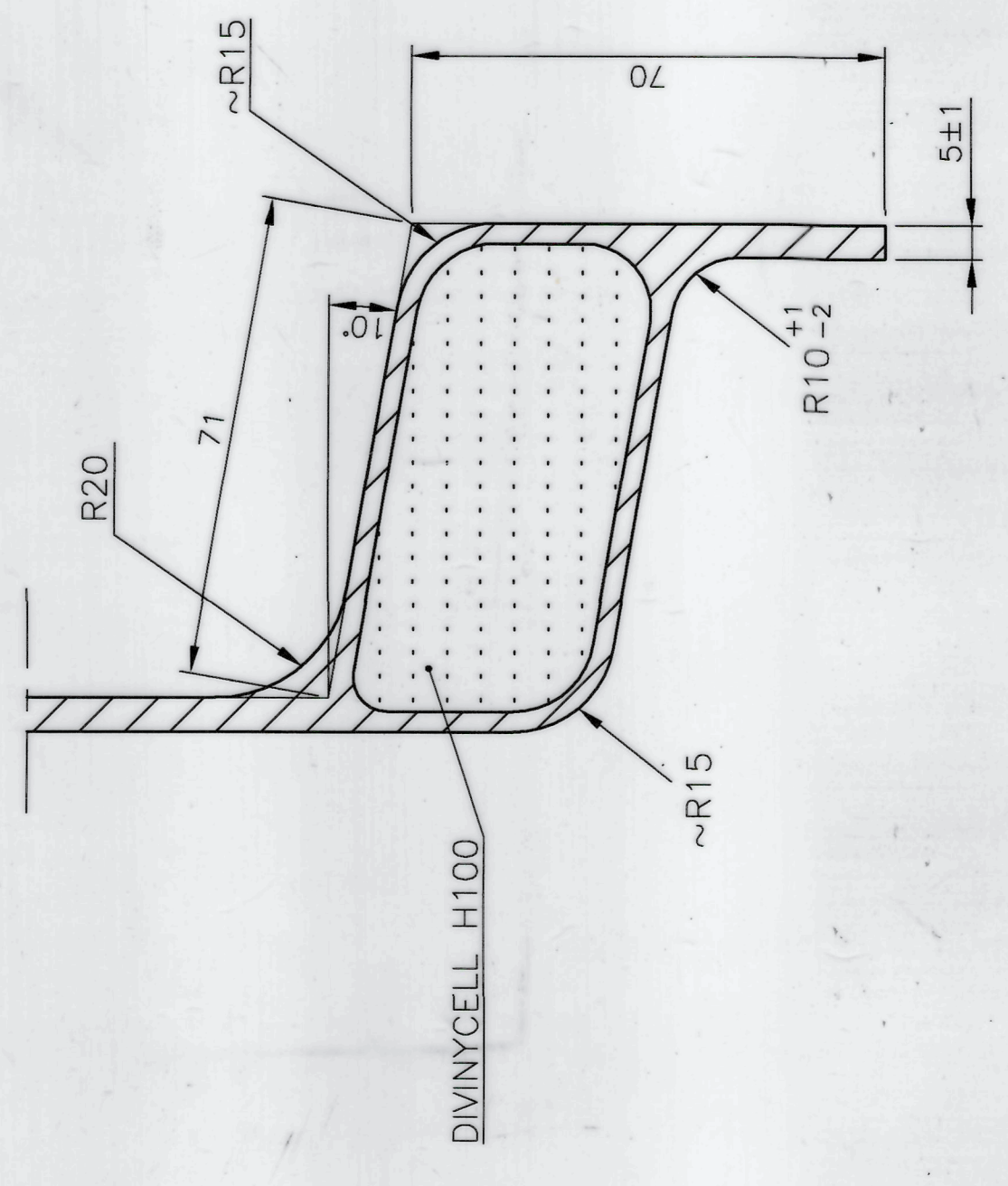
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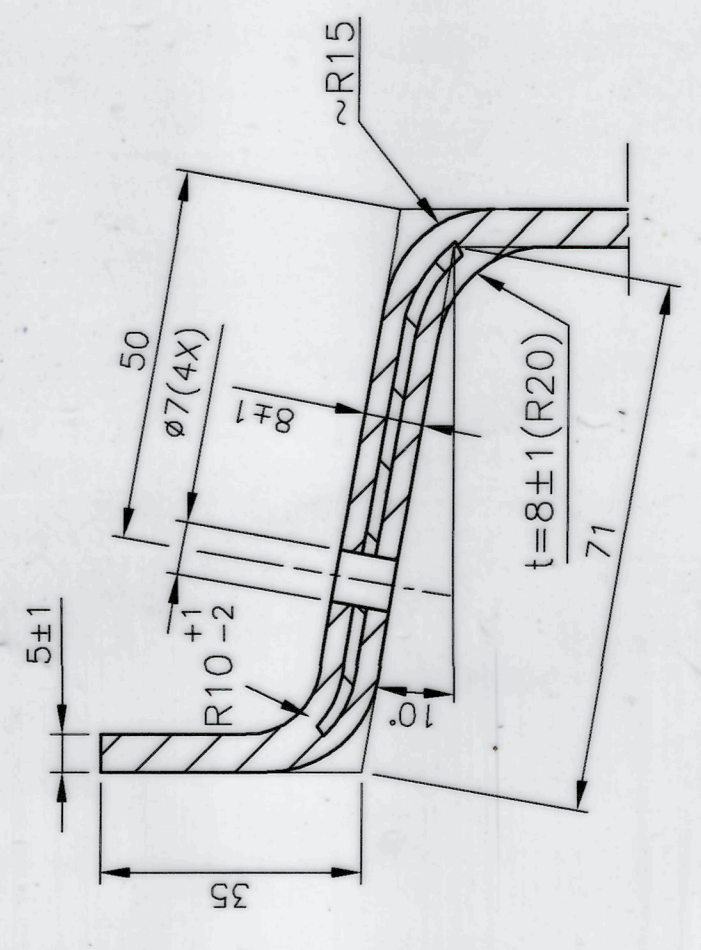
B---B  
 C---C  
 TURNED



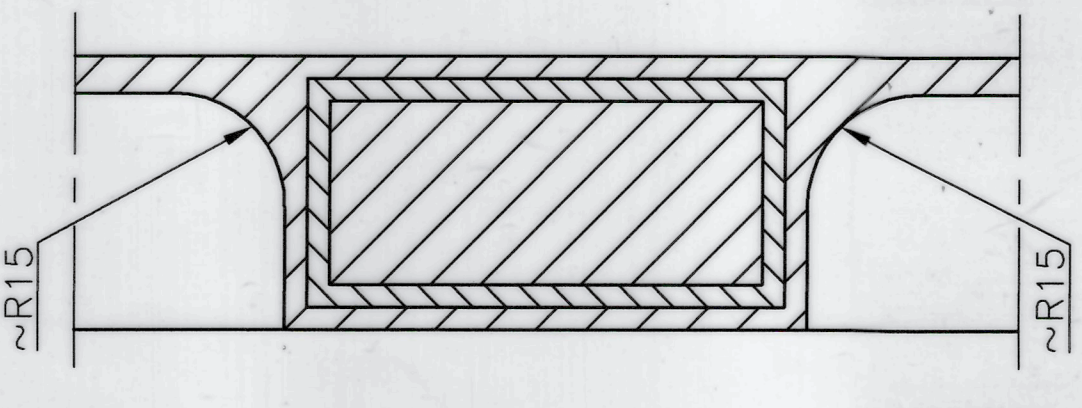
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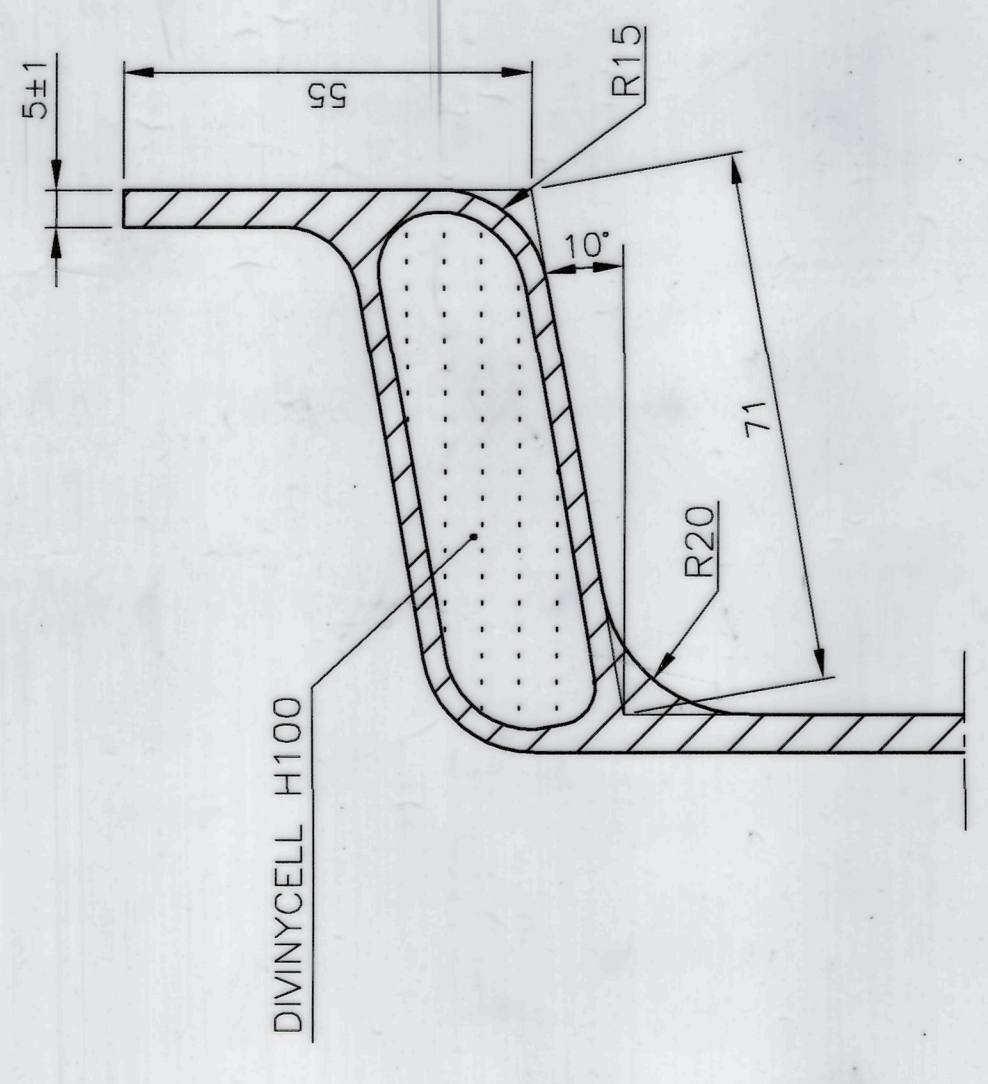
E---E



G---G



H---H

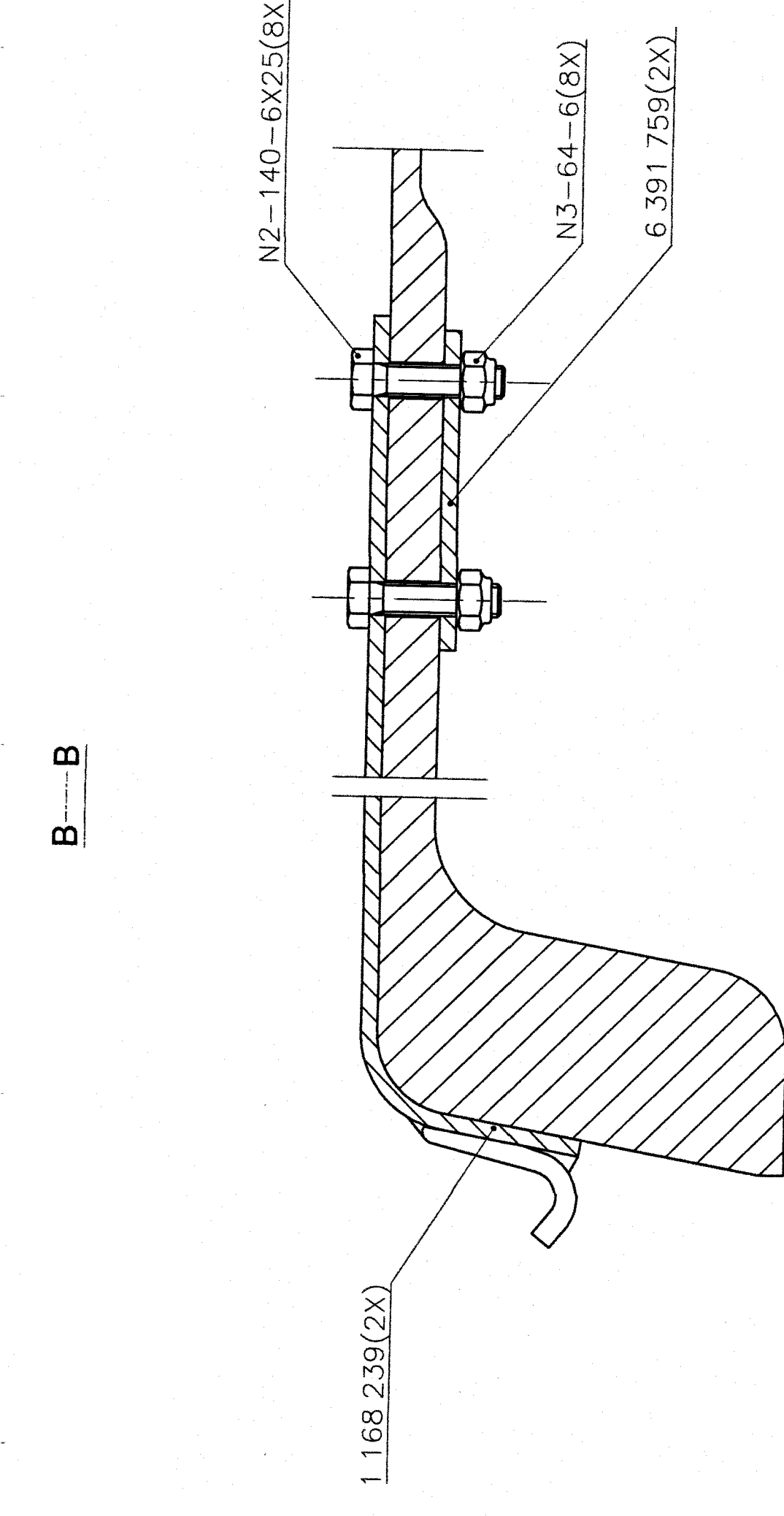
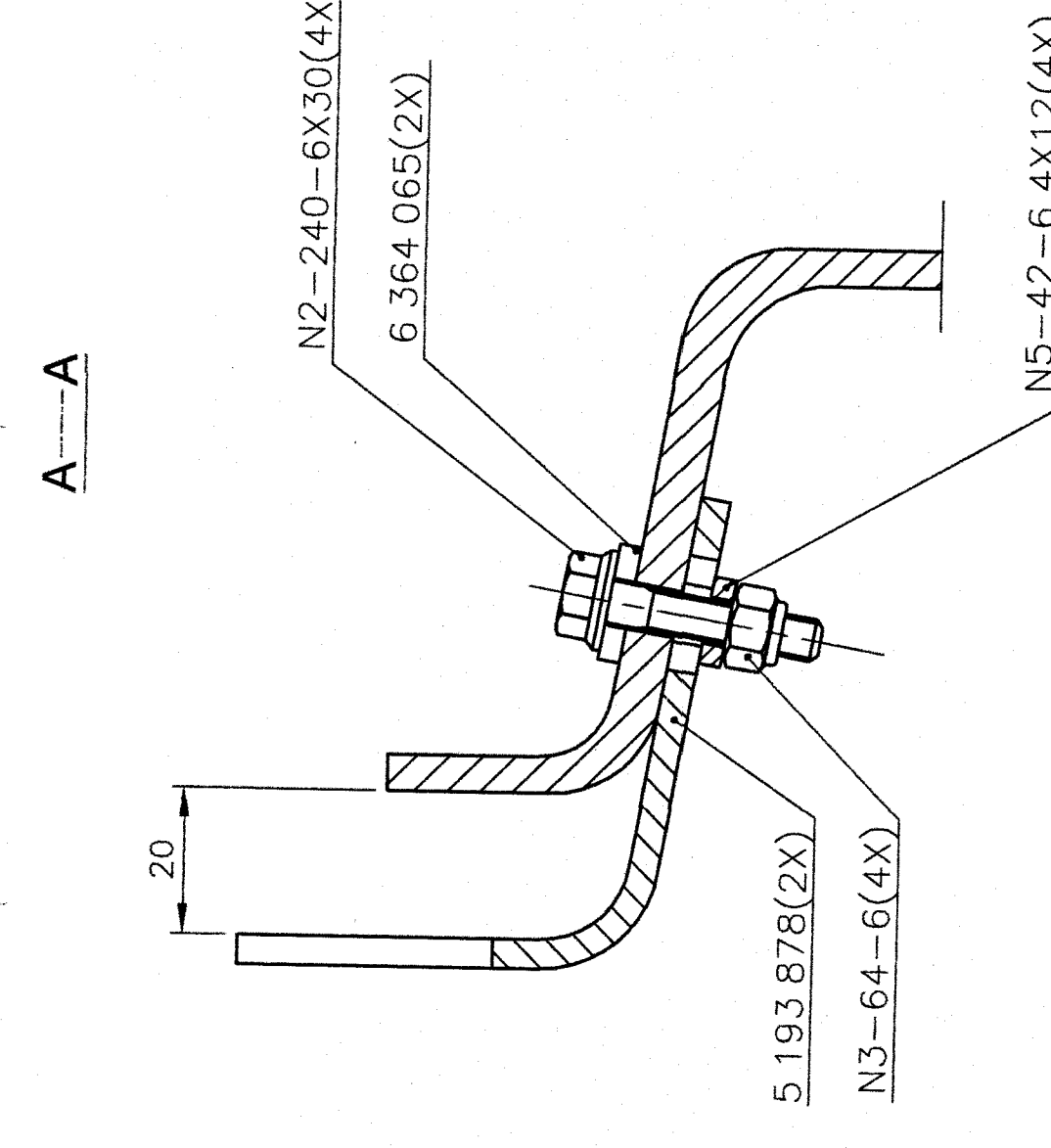
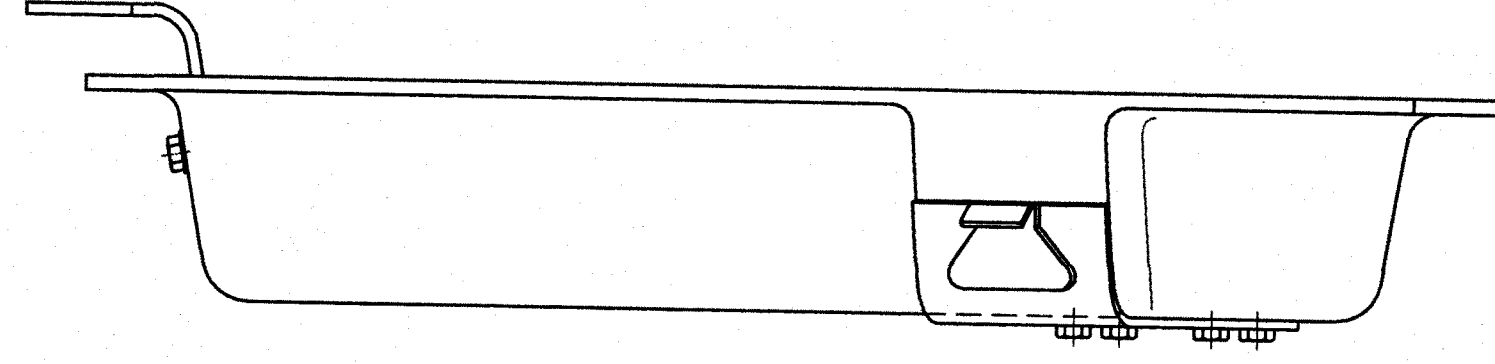
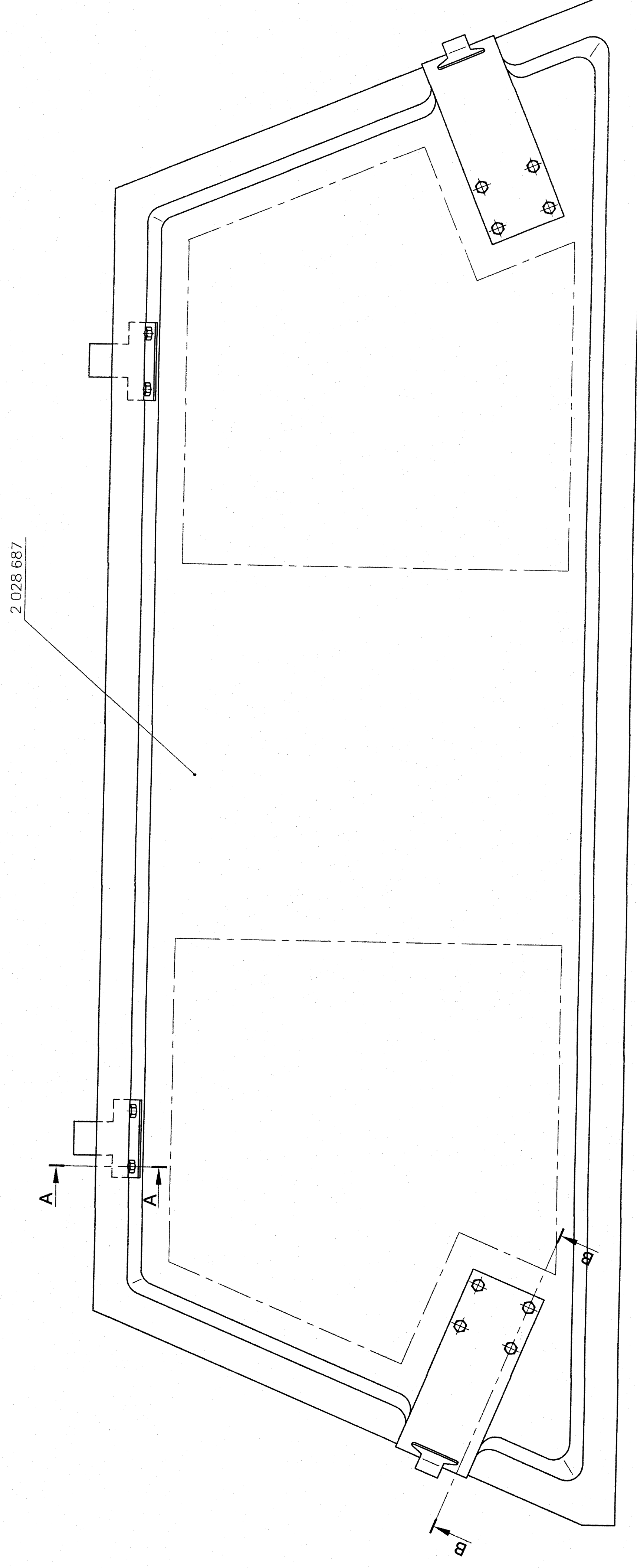
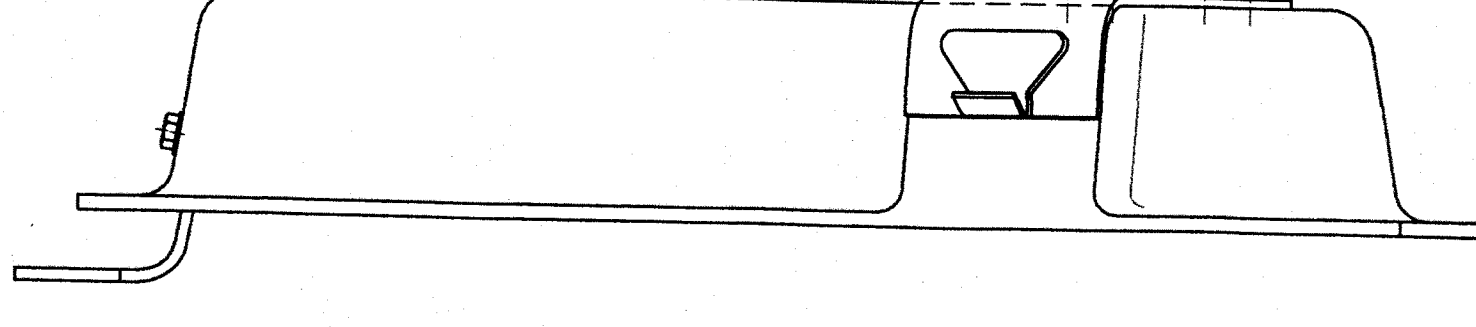
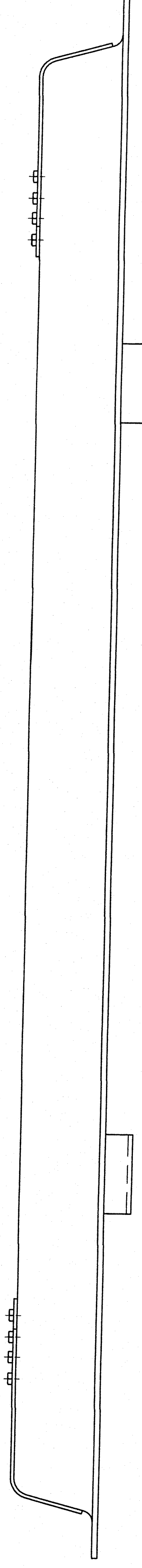


DIVINYCELL H100

P. No.	NOMENCLATURE	No.	OFF.	MATERIAL	HARDNESS	STANDARD	REMARKS
1	FOR S.C.C.F.V.						
2	DATE						
3	NAME						
4	DATE						
5	DATE						
6	DATE						
7	DATE						
8	DATE						
9	DATE						
10	DATE						
11	DATE						
12	DATE						
13	DATE						
14	DATE						
15	DATE						
16	DATE						

SCALE: REFERENCE NO.  
 ASST/SUB ASST NO. 118845  
**ENGINE BONNET, REAR**  
 GUN CARRIAGE FACTORY, JABALPUR

ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE STATED



P. No.	NOMENCLATURE	No. OF	MATERIAL	HARDNESS	STANDARD	REMARKS	FOR USE BY G.C.F.A.				
							DATE	NAME	DATE	DATE	
1											
2											
3											
4											
5											
6											
7											
8											
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**ENGINE BONNET,  
REAR GEN. DRWG**

GUN CARRIAGE FACTORY, JABALPUR

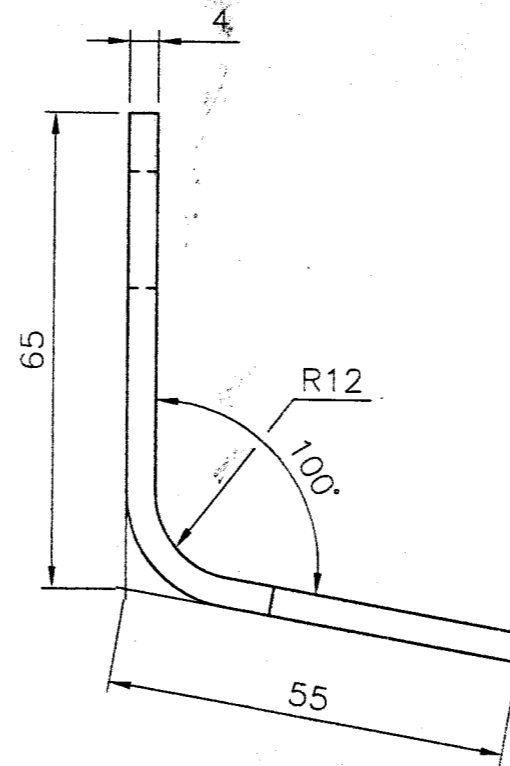
DRG. No. 2 028 690

SHEET NO. OF SHEETS

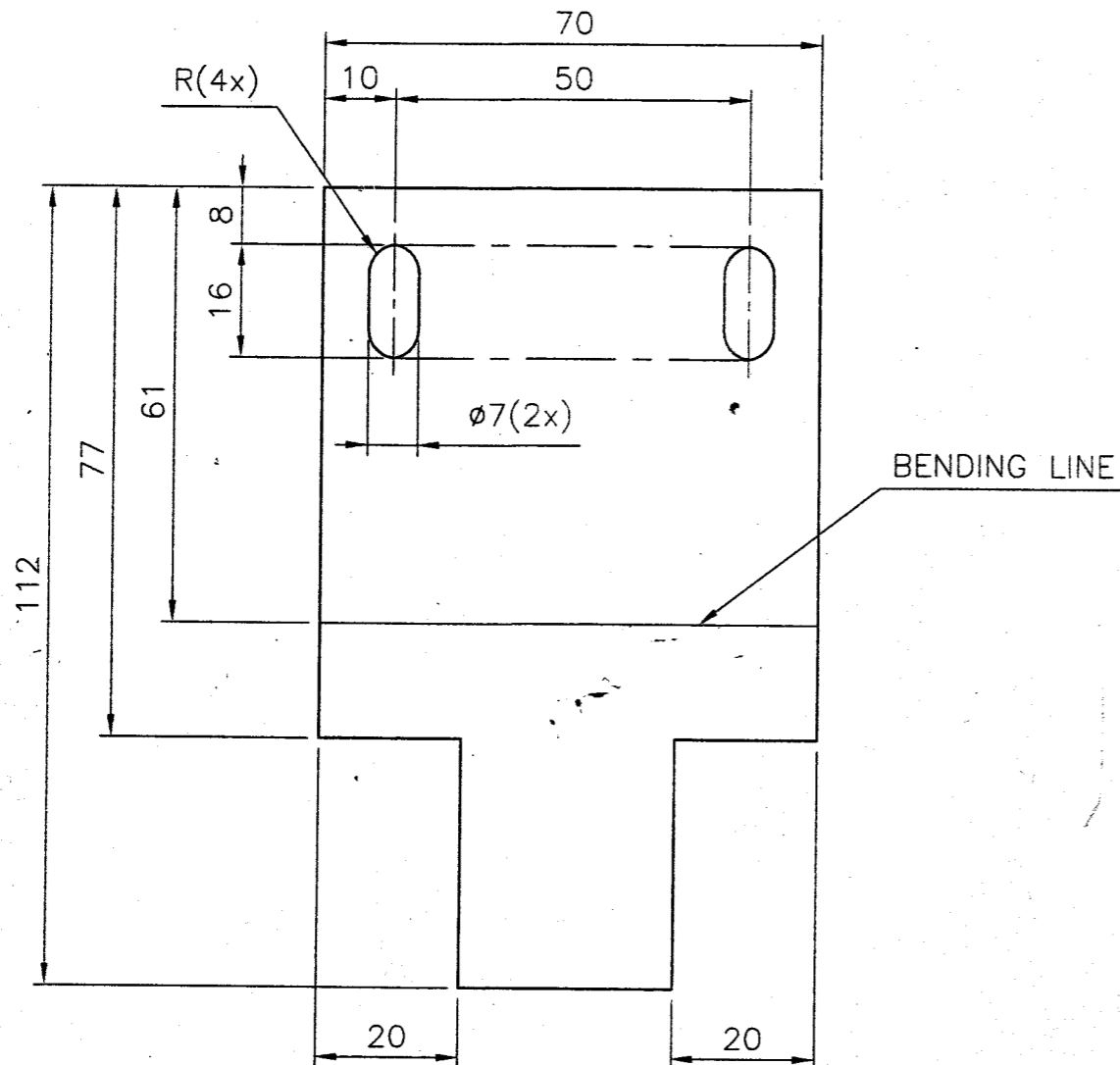
PLEASE DO NOT WRITE ANYTHING ON THIS DRAWING

DRG. No. 5 193 878

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED



DEVELOPMENT



SAILRATH MATL: SAILRATH, GD, B 690

SHARP EDGES BROKEN 0.5-1.0

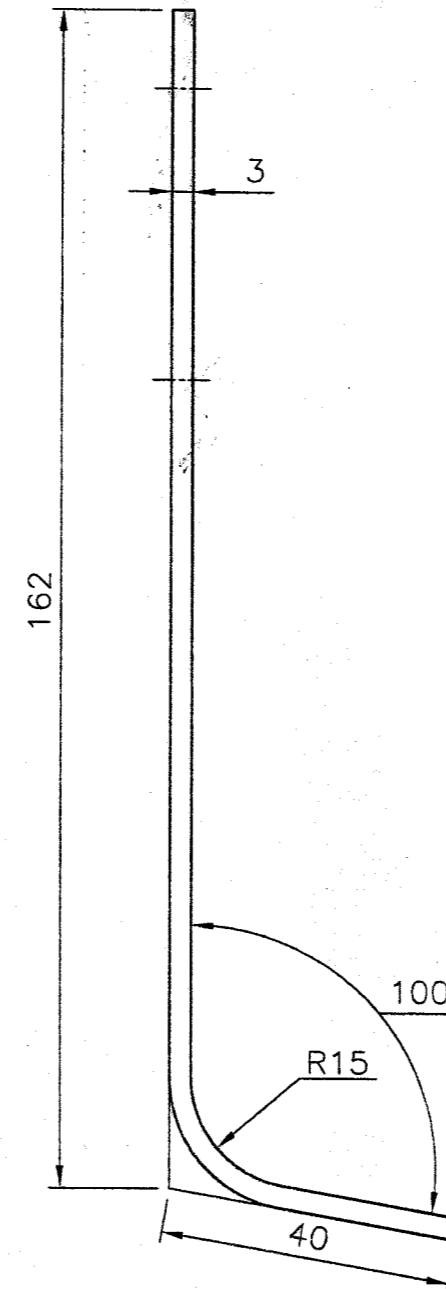
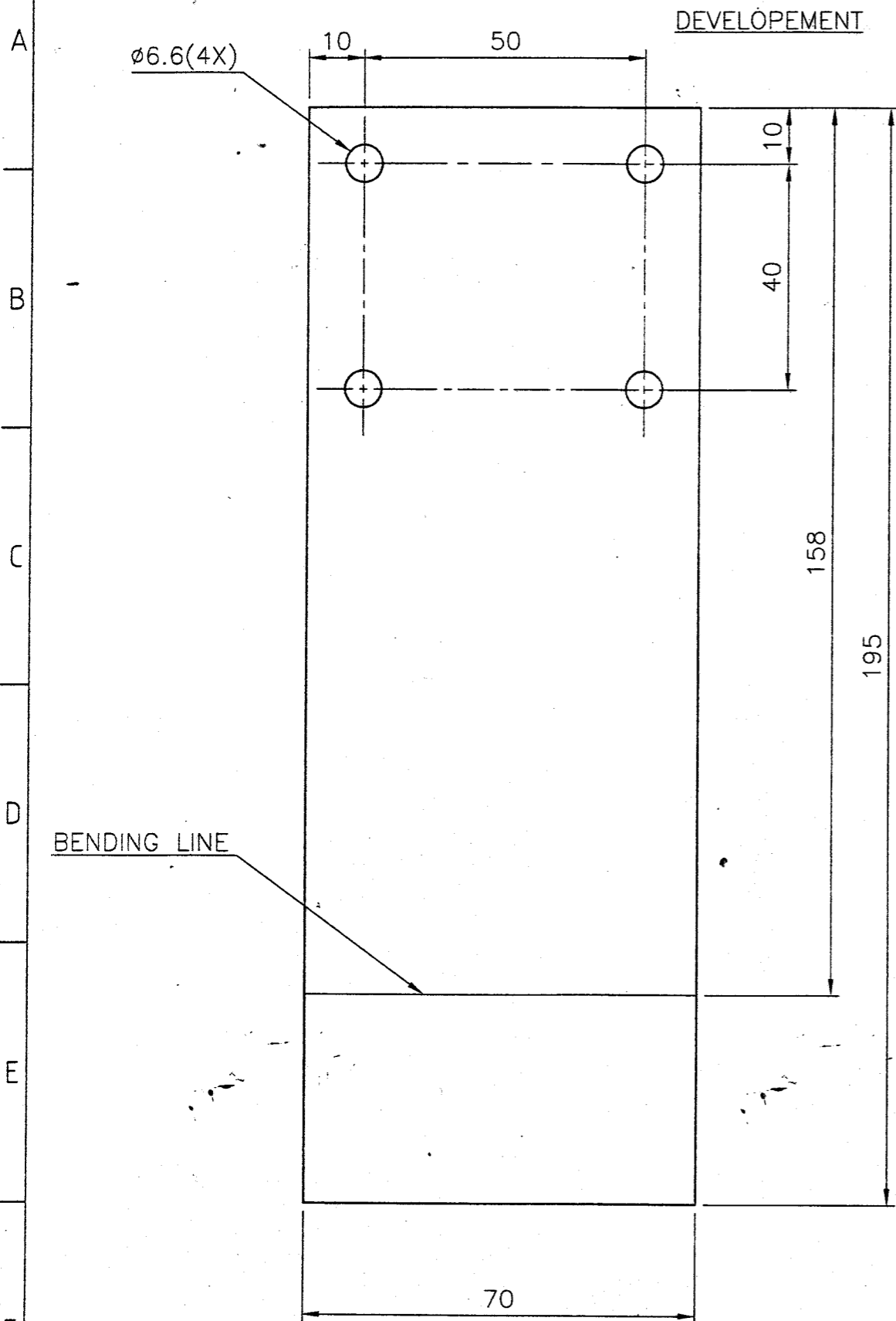
P.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	REMARKS										
GEN. TOL. NOT SPECIFIED						FOR S. GM G.C.Fy.										
LINEAR DIMENSIONS						2016										
0-6	±0.1					NAME										
6-30	±0.2					DATE										
30-120	±0.3					DRN.										
120-315	±0.5					SOBAN										
315-1000	±0.8					17/03										
1000-2000	±1.2					CKD.										
ANGULAR DIMENSIONS						S.K.JAIN										
0-10°	±1'					01/04										
10-50°	±30'															
50-100°	±20'															
>100°	±10'															
~ UNMACHINED																
▽ ROUGH																
▽▽ SMOOTH																
▽▽▽ FINISH																
<b>BRACKET</b>						MATERIAL										
<table border="1"> <tr> <th>INDEX</th> <th>AMENDMENTS</th> <th>SIGN</th> <th>DATE</th> <th>APPROVED</th> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>						INDEX	AMENDMENTS	SIGN	DATE	APPROVED						EN-10025-6-2004, Design S690 QL1
						INDEX	AMENDMENTS	SIGN	DATE	APPROVED						
						with impact charpy test										
						at (-50 °C) = 27J min										
						SCALE										
						REF.DRG.NO.										
						ASSY/SUB ASSY NO. 1168245										
						<b>DRG. No. 5 193 878</b>										
						SHEET NO. OF SHEETS										

SURFACE TREATED Y3-11, Y4-26-10-600

GUN CARRIAGE FACTORY, JABALPUR

DRG. No. 5 193 883

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED



SAILRATH MATL: SAILRATH, GD, E 690

SHARP EDGES BROKEN 0.1-0.5

P.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	REMARKS
GEN. TOL. NOT SPECIFIED						FOR SF. GM G.C.Fy.
LINEAR DIMENSIONS						2016
0-6	±0.1					NAME
6-30	±0.2					DATE
30-120	±0.3					DRN.
120-315	±0.5					VISHW
315-1000	±0.8					14/03
1000-2000	±1.2					CKD.
						S.K.JAIN
						01/04
ANGULAR DIMENSIONS						APPROVED
0-10°	±1°	INDEX	AMENDMENTS	SIGN	DATE	
10-50°	±30°					
50-100°	±20°					
>100°	±10°					
~ UNMACHINED		<h1>PLATE</h1>				MATERIAL
▽ ROUGH						EN-10025-6-2004, Design S690
▽▽ SMOOTH						QL1 with impact charpy test at (-50°C)= 27J min
▽▽▽ FINISH						SCALE
		GUN CARRIAGE FACTORY, JABALPUR				ASSY/SUB ASSY NO. 1168239
						DRG. No. 5 193 883
						SHEET NO. 1 OF 1 SHEETS

PLATE

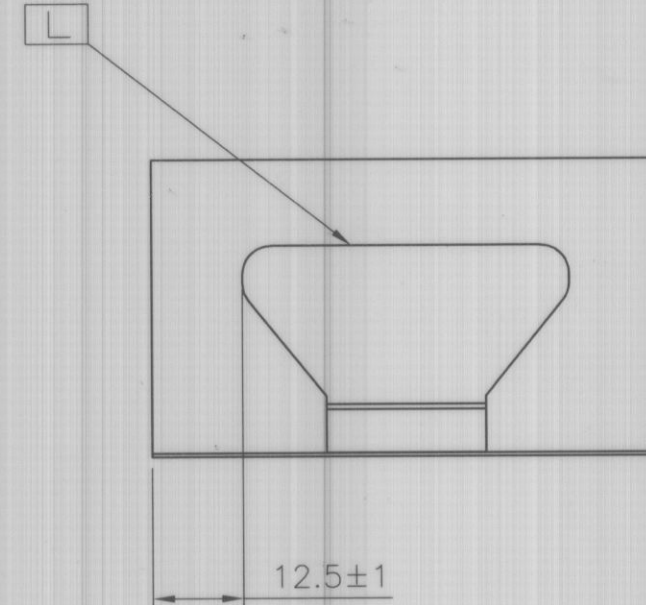
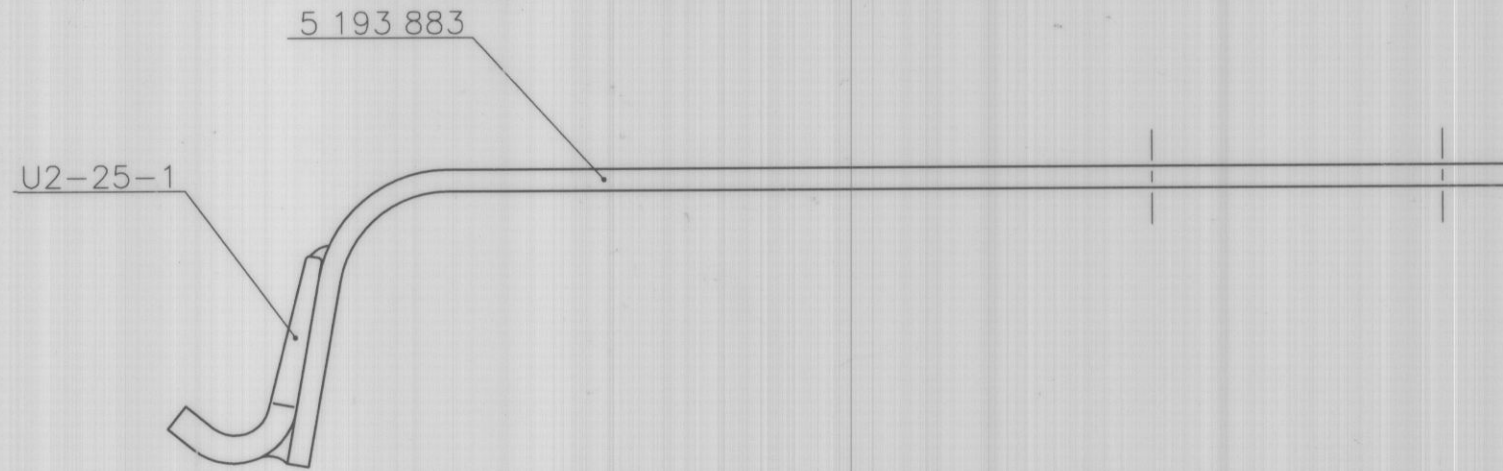
GUN CARRIAGE FACTORY, JABALPUR

DRG. No. 5 193 883

SHEET NO. 1 OF 1 SHEETS

DRG. No. 5 193 884

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED



SURFACE TREATMENT Y3-11, Y4-26-10-600

P.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	REMARKS
GEN. TOL. NOT SPECIFIED						FOR Sf. GM G.C.Fy.
LINEAR DIMENSIONS						2016 NAME DATE
0-6	±0.1					DRN. SANJAY 29/03
6-30	±0.2					CKD. J.K.KOSTA 04/07
30-120	±0.3					
120-315	±0.5					
315-1000	±0.8					
1000-2000	±1.2					
ANGULAR DIMENSIONS						INDEX AMENDMENTS SIGN DATE APPROVED
0-10°	±1'					
10-50°	±30'					
50-100°	±20'					
>100°	±10'					

WELD NO.	WELDING CLASS.	WELDING PROCESS	FILLER METAL
	C	MIG, TIG	W20-8
WELDING SPECIFICATION A 3025			
BASIC MATERIAL W3-8110-53 SAILRATH/1690 Q11			
WORKING TEMPERATURE DURING WELDING °C			
HEAT TREATMENT AFTER WELDING			
REQUIREMENT OF TIGHTNESS			
WELDING SCHEDULE		INSPECTION INSTRUCTIONS	

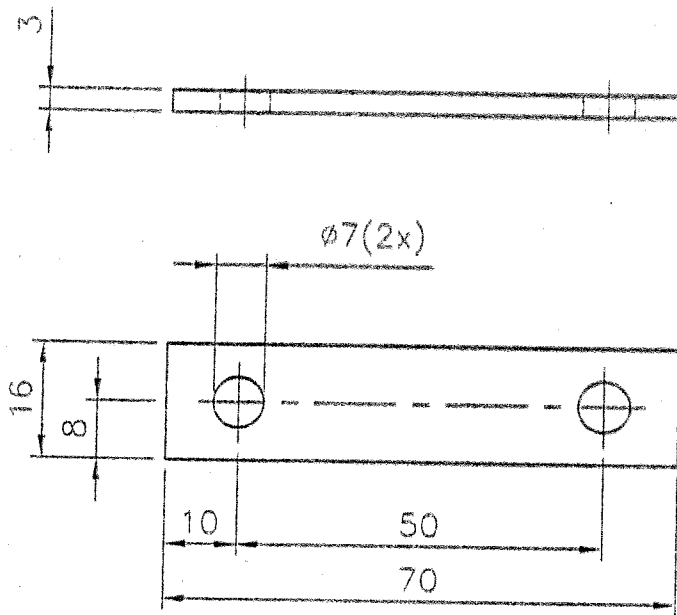
**BRACKET, WELDING DRWG.**

GUN CARRIAGE FACTORY, JABALPUR

MATERIAL	SCALE	REF.DRG.NO.
	ASSY/SUB ASSY NO. 1168239	
<b>DRG. No. 5 193 884</b>		
SHEET NO. OF SHEETS		

DRG. No. 6 364 065

ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE STATED



SURFACE TREATED Y3-11.Y4-27-10-600

SHARP EDGES BROKEN 0.5-1

P.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	REMARKS	
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LINEAR DIMENSIONS							
0-6	±0.1				2016	NAME DATE	
6-30	±0.2				DRN.	SOBAN 06/03	
30-120	±0.3				CKD.	ALOK 19/03	
120-315	±0.5						
315-1000	±0.8						
1000-2000	±1.2						
ANGULAR DIMENSIONS		INDEX	AMENDMENTS	SIGN	DATE	APPROVED	
0-10°	±1'						
10-50°	±30'						
50-100°	±20'						
>100°	±10'						
~ UNMACHINED		<h1>PLATE</h1>				MATERIAL	
▽ ROUGH						IS:737-2008, Design 52000, Hx4	
▽▽ SMOOTH						SCALE	REF.DRG.NO.
▽▽▽ FINISH						ASSY/SUB ASSY NO. 1168245	
		GUN CARRIAGE FACTORY, JABALPUR					DRG. No. 6 364 065
						SHEET NO. OF SHEETS	

1

2

3

4



Datum/Date	Dok.nr/Doc. No.
1978-10-01	28 000 075
Utgåva/Issue	Sida/Page
3	1 (2)

AR BOFORS • STANDARD • BOX 500 • S-430 20 • BOFORS • SWEDEN • EFTERTRYCK UTAN SKRIFTLIGT MEDGIVANDE FORBJUDS • COPYRIGHT

SVETSNING AV SEGHÄRDAT KONSTRUKTIONSTÅL  
SVETSBESTÄMMELSE

WELDING HARDENED CONSTRUCTIONAL STEEL  
WELDING SPECIFICATION

17112-W/BOFORS STANDARD  
17-B-91/SEALÉD PROV.

Do

1 TILLÄMPNING

Denna svetsbestämmelse gäller vid svetsning av seghärdat konstruktionsstål, då så föreskrivits på svetsritning.

2 BEHÖRIGHET

Svetsningen får utföras endast av svetsare, som har behörighet enligt FMV-A norm KAF St 015. Föreskrivet kompetensprov skall utföras i närvaro av representant för kundens kontrollorgan.

3 SVETSPLAN

Innan produktionssvetsningen påbörjas skall svetsplan, om sådan föreskrivs på svetsritning, ha uppgjorts och överlämnats till kundens kontrollorgan.

4 KONTROLLINSTRUKTION

Innan produktionssvetsningen påbörjas skall kontrollinstruktion, om sådan föreskrivs på svetsritning, ha uppgjorts och överlämnats till kundens kontrollorgan.

5 FOGBEREDNING

Fogberedningen kan utföras genom maskinbearbetning eller gasskärning. Vid svetsningen skall fogytorna vara fria från felaktigheter, som kan äventyra svetskvaliteten. Klippgrader skall vara avlägsnade. Eventuella skärsår i gasskurva fogytorna kan behöva rundas genom slipning.

6 TILLSATSMATERIAL

Förpackningarna skall förvaras i torr lokal. Handsvetselektroder skall sedan förpackningen brutits föras över till ett torkskåp med temperaturen 350-400 °C, där de skall ligga 2-4 timmar. Därefter skall de fram till användningen förvaras i värmeskåp vid en temperatur av 100-120 °C.

Handsvetselektroder skall vid användningstillfället direkt överflyttas från värmeskåp till torrbehållare, som har temperaturen 100-120 °C. I denna får icke större mängd elektroder placeras än som väntas förbrukas under ett skift. Elektroder som icke förbrukats under denna tid skall återföras till värmeskåpet.

Vätehalten i elektrodhöljet till handsvetselektroder får vid användningstillfället ej överstiga den mängd, som motsvarar 0,20 % vatten, bestämd enligt metod angiven i FMV-A norm KAF St 030 punkt 8. Betyrägande kontroll av vätehalten skall finnas.

1 APPLICATION

Welding of hardened, constructional steel shall be carried out according to this specification when it is prescribed on the drawing.

2 COMPETENCE

Welding may only be carried out by welders who are competent according to Swedish military standard FMV-A norm KAF St 015. The prescribed competence test shall be carried out in the presence of a representative for the customer's inspection department.

3 WELDING SCHEDULE

Before production welding commences a welding schedule shall be made and delivered to the customer's inspection department where so specified on the welding drawing.

4 INSPECTION INSTRUCTION

Before commencing production welding inspection instructions shall be made and delivered to the customer's inspection department where so specified on the welding drawing.

5 PREPARATION OF THE SEAMS

Preparation of the seams shall be by machining or flame cutting. When welding the surfaces of the seams shall be free from defects which can jeopardize the quality of the weld. Pressing burrs shall be removed. Any flame cutting cracks in surfaces to be joined may have to be rounded off by grinding.

6 FILLER

Packed material shall be stored in dry premises. Hand-welding electrodes shall be transferred to a dry cupboard at a temperature of 350-400 °C, once the packaging has been opened and they shall remain there for 2-4 hours. They shall then be stored in a hot cupboard at a temperature of 100-120 °C until they are used.

Manual welding electrodes shall be transferred directly from the hot cupboard to a dry container having a temperature of 100-120 °C when being used. Greater quantities of electrodes than are expected to be used during one shift shall not be placed in this container. Electrodes not used during this time shall be returned to the hot cupboard.

The hydrogen content of the electrode covering is manual welding electrodes shall not exceed the amount corresponding to 0,20 % water as ascertained according to the method stated in FMV-A standard KAF chapter 030 item 8. There shall be a satisfactory inspection of the hydrogen content.





Utgåve/Issue	Sida/Page
3	2

Vid gasmetallbågs svetsning får skyddsgasens vattenhalt ej överskrida 0,005 %.

#### 7 SVETSNING

Vid svetsningen skall fogytorna vara rena och torra. Svetsning får icke utföras på våt, målad, oljig eller korroderad fogyta. Dock får fogytorna vara korrosionsskyddade med verkstadsgrundfärg W5-15.

Under svetsning får temperaturen i verkstaden icke understiga +15 °C.

Ljusbågen får icke tändas mot andra ytor av konstruktionen än fogytor.

Fel i samband med ändkratrar skall undvikas, t ex genom att bågen släcks först sedan elektroderna förts tillbaka ungefär 10 mm.

Vid automatsvetsning skall då så är möjligt start- och slutplåtar användas.

En arbetstemperatur av ca 120 °C bör eftersträvas, speciellt i grövre gods. Detta kan ibland medföra behov av förvärmning.

Svetssträng skall befrias från slagg och oxidskikt innan ny sträng läggs över den. Om sprickor kan iaktas i en lagd svetssträng skall de repareras innan svetsningen fortsätter.

Före svetsning av svetsförbandets rotsida skall felaktigheter i rotsträngen avlägsnas genom mejsling, kolvågsskärning eller slipning.

Sträckning av svets med lufthammare bör i möjligaste mån undvikas, men får användas då någon annan metod för riktning ej kan tillämpas.

Vid svetsning av en fog får uppehåll göras först sedan så många strängar lagts, att risk för sprickbildning under avsvälning icke finns.

Svetsens svälning får icke påskyndas genom särskilda åtgärder. Innan svetsen svalnat får den icke utsättas för drag eller kraftig luftväxling.

#### 8 EFTERBEHANDLING

Slipning av svetsråge eller svetsrot utförs då så föreskrivs på ritning. Därutöver bör slipning företas endast i mindre omfattning för att avlägsna svetspärlor eller för hög råge.

Efter färdigsvetsning får svetsfogarna inte utsättas för temperaturer som överstiger 590 °C i samband med riktning, avspänningsglödning eller annan arbetsoperation.

#### 9 KONTROLL

Om ej annat anges på svetsritning utförs kontroll enligt Bofors standard V9-3.

The moisture content of the protective gas shall not exceed 0,005 % when gas-metal arc welding.

#### 7 WELDING

When welding the surfaces to be joined shall be clean and dry. Welding of wet, painted, oily or corroded joining surfaces is not permitted. The surfaces to be joined may, however, be protected against corrosion with workshop primer W5-15.

During welding the temperature in the workshop shall not exceed +15 °C.

The arc is not to be ignited against other surfaces of the construction than the surface to be joined.

Pipe shall be avoided, for example, by not extinguishing the arc until the electrode has been retracted approx. 10 mm.

When automatic welding starting and run-off tabs shall be used where possible.

One should attempt to achieve a working temperature of approximately 120 °C, especially for heavier work. This may occasionally necessitate preheating.

The weld bead shall be cleaned of slag and oxide layer before a new bead is welded onto it. If cracks can be seen in a bead that has been welded they shall be repaired before continuing the welding.

Before welding the root of the junction defects in the welded bead shall be eliminated by chiselling, air-arc gouging or grinding.

Stretching of the weld with pneumatic hammers should be avoided as far as possible, but may be resorted to when no other straightening method can be used.

When welding a joint no interruption may be permitted until so many beads have been laid that there is no risk of formation of cracks during cooling.

Cooling of the weld may not be accelerated by artificial means. Before the weld has cooled it may not be subjected to stretching or powerful air calculation.

#### 8 SUBSEQUENT TREATMENT

Grinding of the weld seam or weld root is to be carried out when prescribed on the drawing. Apart from this it should be ground to only a small extent to remove drops of weld or too high beads.

After finish welding the joints are not to be subjected to temperatures exceeding 590 °C when straightening, stress relieving or for other operations.

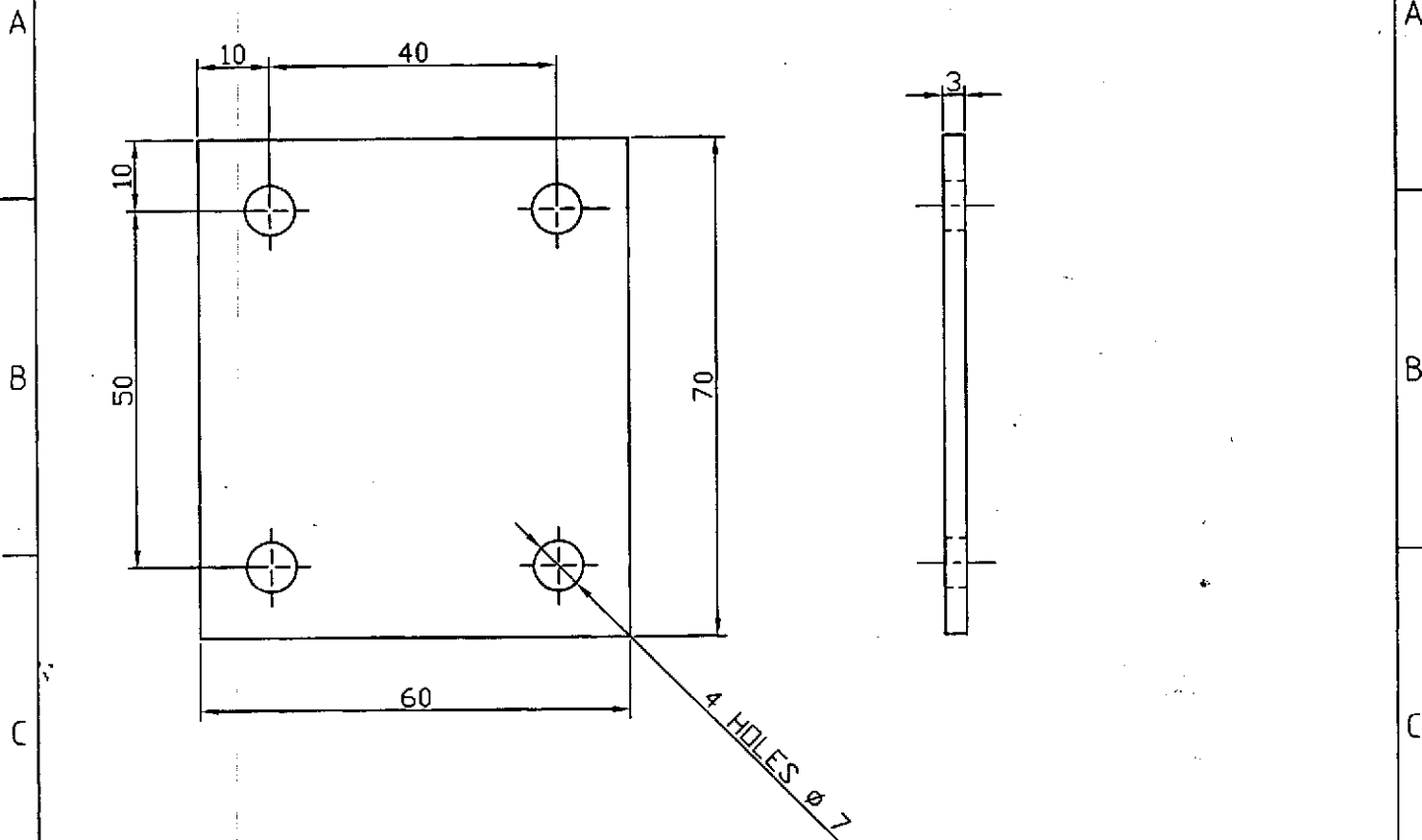
#### 9 INSPECTION

Unless otherwise stated on the weld drawing the inspection is to be carried out according to the Bofors standard V9-3.

17/12-W  
17-8-91  
BOFORS STANDARD  
SEALED PROV.  
M/S  
DO

DRG. No. - GCF/50/39067

DRAWING CONVENTIONS CONFORM TO SP:46-1988  
DIMNS. ARE IN mm. UNLESS OTHERWISE STATED.



MATERIAL :- IS:8500-1991, Gde Fe490

PT.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	SIZE	REMARKS	
GEN. TOL. NOT SPECIFIED						FOR GM G.C.Fy.		
LINEAR DIMS						2012	NAME	
0-6	±0.1					DRN.	A.Khare	
6-30	±0.2					CKD.	21.11.12	
30-120	±0.3							
120-315	±0.5							
315-1000	±0.8						JWM/Shop	
1000-2000	±1.2							
ANGULAR DIMENSIONS		INDEX	AMENDMENTS	SIGN	DATE	HOS/DDO		
0-10°	±1°							
10-50°	±30'							
50-100°	±20'							
>100°	±10'							
~ UNMACHINED	<p style="text-align: center;"><b>PLATE</b> 155MM DHANUSH FOR ENGINE HOUSING (ENGINE BONET REAR)</p>						SEC.	M/C
▽ ROUGH							SCALE	REF.DEMD.
▽▽ SMOOTH							1:1	REF.DRG.NO. 6391759
▽▽▽ FINISH							DRG. No.	GCF/50/39067
	GUN CARRIAGE FACTORY, JABALPUR						SHEET NO. 1 OF 1 SHEETS	



Datum/Date	Doc. nr/Doc. No
1979-04-15	38 000 242
Utgåva/Issue	Sida/Page
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6-KANTSKRUVAR  
METRISKA GÄNGOR, HÅLLFASTHETSKLASS 8.8  
FÖRZINKADE

HEXAGON SCREWS  
METRIC SCREW THREADS, STRENGTH GRADE 8.8  
ZINC PLATED

17/12.W  
17.8.91  
BOFORS STANDARD  
SEALED PROV.

REFERENS

Typ M6S, SMS 2165 utgåva 3.

DIN 933 Dezember 1970 och DIN 931 November 1970 för skruvar över respektive under trappstegslinjen.

ISO/R 272-1968 och ISO/R 888-1968, huvudets dimensioner respektive skruv- och gänglängder

DATA

Gängor ..... Metriska gängor M  
 Gängtoleranser ..... 6h efter ytbehandling  
 Material ..... Stål, hållfasthetsklass 8.8  
 Ytbehandling ..... Förzinkade och kromaterade:  
 M4-M5 Fe/Zn 5 c  
 M6-M24 Fe/Zn 8 c

Övriga tekniska data ... A6013, T6-17

REFERENCE

Type M6S, Swedish standard SMS 2165 edition 3.

DIN 933 Dezember 1970 and DIN 931 November 1970 for screws above respectively below the stepped line.

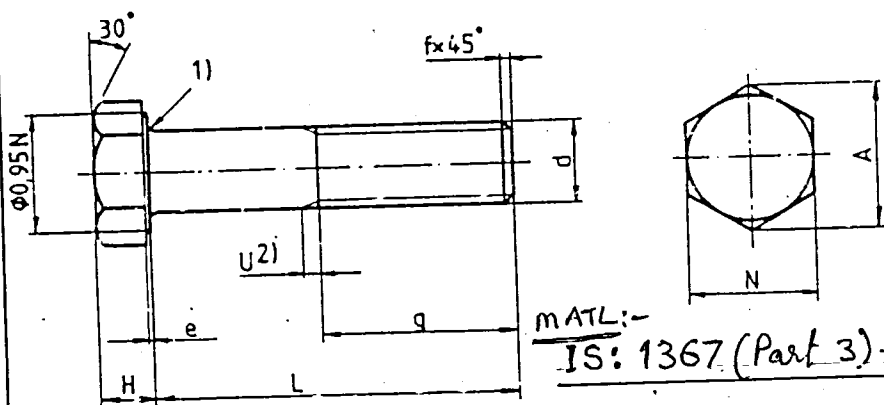
ISO/R 272-1968 and ISO/R 888-1968, the dimensions of the head respectively the screw- and thread lengths.

DATA

Threads ..... Metric screw threads M  
 Thread tolerance class ... 6h after surface treatment  
 Material ..... Steel strength grade 8.8  
 Surface treatment ..... Zinc plated and chromated:  
 M4-M5 Fe/Zn 5 c  
 M6-M24 Fe/Zn 8 c

Other technical data ..... Bofors standard A6013, T6-17

18334-W 12-2-97	ALT. MATL. AMENDED	15/11/92	11
17366-W 25-8-92	ALT. MATL. ADDED	15/11/92	11
19268-W 16.8.12	MATL. AMENDED	15/11/92	11



MATL:-  
IS: 1367 (Part 3)-2002 PROPERTY CLASS 8.8

- 1) Övergång enligt T6-17
- 2) Gängutlopp enligt Z11-1

- 1) Radii under the head according to T6-17
- 2) Run outs according to Z11-1

~~ALTERNATE MATL:- STEEL PROPERTY CLASS~~  
~~8.8 TO IS: 1367 Pt III: 1979. OR BS: 970 Pt 1: 83~~  
~~Gde 708 M40 HEAT TREATED TO CONDITION 'T' OR IS: 5517: 93~~  
~~Gde 40 Ni Cr 4 M03 HEAT TREATED TO LRS-63 mm~~



Gänga d 1) Thread d	M4	M5	M6	M8	M10	M12	(M14)	M16	M20	M24
N	7	8	10	13	17	19	22	24	30	36
A	8,1	9,2	11,5	15	19,6	21,9	25,4	27,7	34,6	41,6
H	2,8	3,5	4	5,5	7	8	9	10	13	15
e	-	0,2	0,3	0,4	0,4	0,4	0,4	0,4	0,4	0,5
r	0,8	0,8	1	1,2	1,5	2	2	2	2,5	3
L 1)	Dimensionsnummer Size number									
	Gänglängd g 2)					Thread length g 2)				
	14	16	18	22	26	30	34	38	46	54
8	287	323								
10	289	325	364							
12	291	327	366	447						
14	292	328	367	448	488					
16	293	329	368	449	489					
(18)	294	330	369	450	490	531				
20	295	331	370	451	491	532	575			
(22)	296	332	371	452	492	533	576			
25	297	333	372	453	493	534	577	622		
30		335	374	455	495	536	579	624		
35		337	376	457	497	538	581	626	670	
40		339	378	459	499	540	583	628	672	
45		340	379	460	500	541	584	629	673	718
50		341	380	461	501	542	585	630	674	719
55			381	462	502	543	586	631	675	720
60			382	463	503	544	587	632	676	721
65			383	464	504	545	588	633	677	722
70			384	465	505	546	589	634	678	723
75			385	466	506	547	590	635	679	724
80			386	467	507	548	591	636	680	725
90				469	509	550	593	638	682	726
100				471	511	552	595	640	684	728
110						554	597	642	686	730
120						556	599	644	688	732
	Gänglängd g		Thread length g		32	36	40	44	52	60
	20	22	24	28						
130						558	601	646	690	734
140								647	691	735
150									692	736
160									693	737
180										739
200										741

1712-W BOFORS STANDARD 17-8-91  
 17366-W 25-8-92  
 ALT. MATL. ADDED.  
 145-141  
 110

- 1) Parentesmarkerade diametrar och längder undviks  
 2) Skruvar över trappstegslinjen är helgängade
- 1) Diameters and lengths in brackets should be avoided  
 2) Screws above the stepped line are fully threaded

~~ALTERNATE MATL: STEEL PROPERTY CLASS~~  
~~8-8 TO IS: 1367 PL. III: 1979 OR BS: 970 PL1: 83 Gde 708~~  
~~M40 HEAT TREATED TO CONDITION 'T' OR IS: 5517: 93 Gde 40 Ni~~  
~~6 Cr 4 MO 3 HEAT TREATED TO LRS 63 mm~~

KOMPLETTERANDE UPPLYSNINGAR

SUPPLEMENTARY INFORMATION

Identifisering	10 648 dimensionsnummer	Identification	10 648 size number
Artikelnummer	6-kantskruv	Article number	Hexagon screw
Benämning	N2-140-dxL	Denomination	N2-140-dxL
Seteckning	Exempel: N2-140-4x8	Designation	Example: N2-140-4x8

MATL: - IS: 1367 (Part 3) - 2002 PROPERTY CLASS 8.8

19266-W 16.8.92	MATL AMENDED	DAG
18334-W 12-2-97	ALT. MATL. AMENDED	