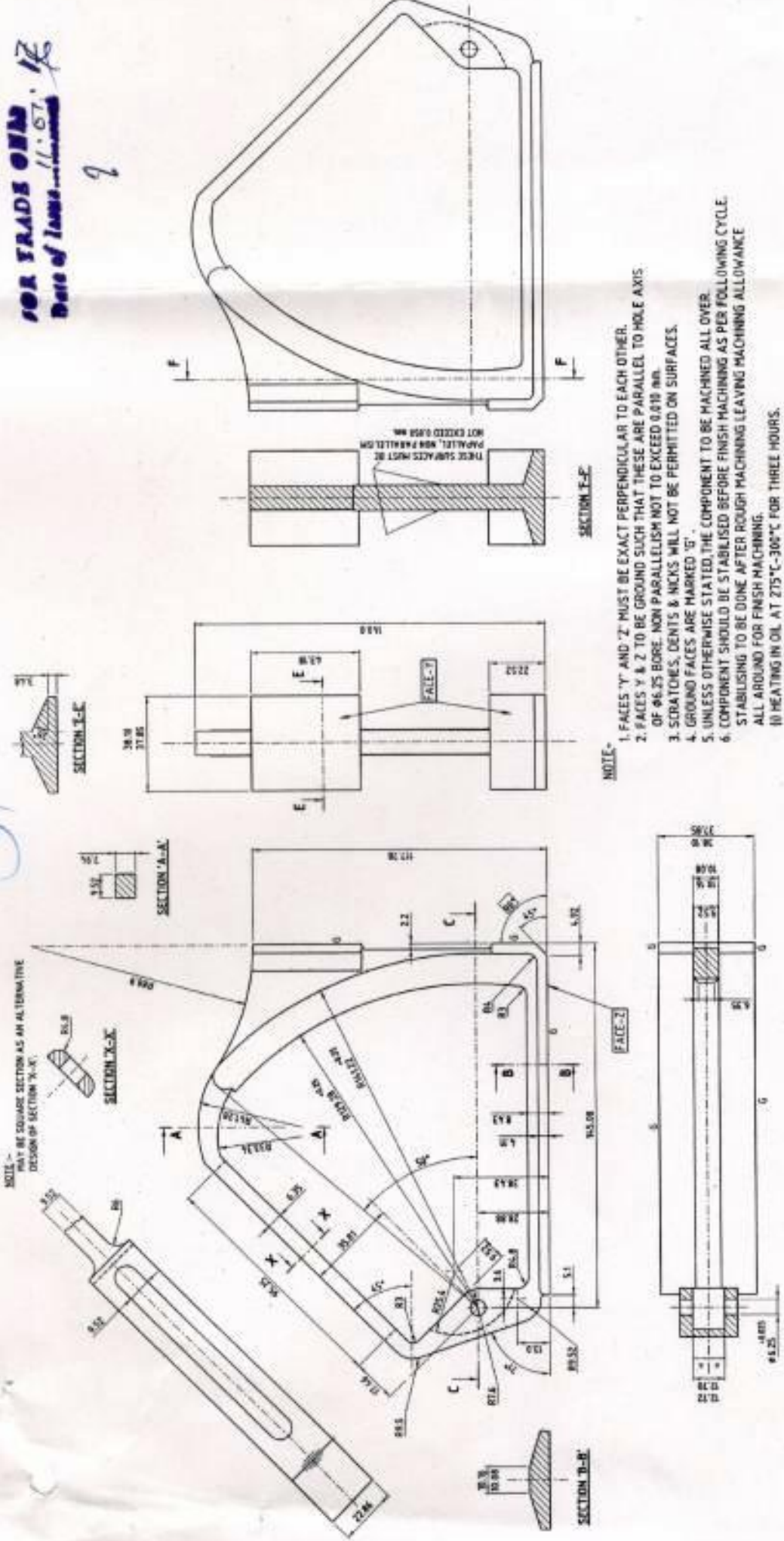


FOR TRADE O/M
 Date of Issue - 11.07.12

9



ALL DIMENSIONS ARE IN mm.
 THIRD ANGLE PROJECTION

- NOTE-**
1. FACES 'Y' AND 'Z' MUST BE EXACT PERPENDICULAR TO EACH OTHER.
 2. FACES 'Y' & 'Z' TO BE GROUND SUCH THAT THESE ARE PARALLEL TO HOLE AXIS OF 46.25 BORE. NON PARALLELISM NOT TO EXCEED 0.010 mm.
 3. SCRATCHES, DENTS & NICKS WILL NOT BE PERMITTED ON SURFACES.
 4. GROUND FACES ARE MARKED 'G'.
 5. UNLESS OTHERWISE STATED, THE COMPONENT TO BE MACHINED ALL OVER.
 6. COMPONENT SHOULD BE STABILISED BEFORE FINISH MACHINING AS PER FOLLOWING CYCLE.
 - (I) STABILISING TO BE DONE AFTER ROUGH MACHINING LEAVING MACHINING ALLOWANCE ALL AROUND FOR FINISH MACHINING.
 - (II) HEATING IN OIL AT 275°C-300°C FOR THREE HOURS.
 - (III) COOLING AT -30°C FOR THREE HOURS.
 - (IV) HEATING IN OPEN FURNACE AT 100°C FOR THREE HOURS.
 - (V) COOLING AT -30°C FOR THREE HOURS.

MATL. - TIN BRONZE OF IS: 306-1983.

QUADRANT, FIRE CONTROL, FIELD, MK.6

BODY

DT - 20.08	SCALE - N.T.S.
MATL AS ABOVE	TREAT AS ABOVE
SHTS - 1	SHT. No. 1
DRAWING No. - MCT-2287/2	
AMENDMENTS	
OPD/000/002	

DR - RK SHARMA	DES. No. - 0.5.134.29
TR -	
CH - <i>[Signature]</i>	DATE - 11/07/12
APPROVED	DM/FP
<i>[Signature]</i>	
E/O.	

ORDNANCE FACTORY
 DEHRADUNA