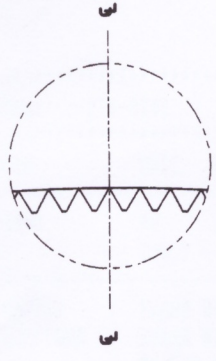
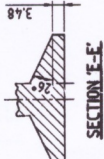


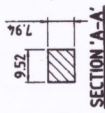
NOTE - MAY BE SQUARE SECTION AS AN ALTERNATIVE DESIGN OF SECTION 'X-X'.



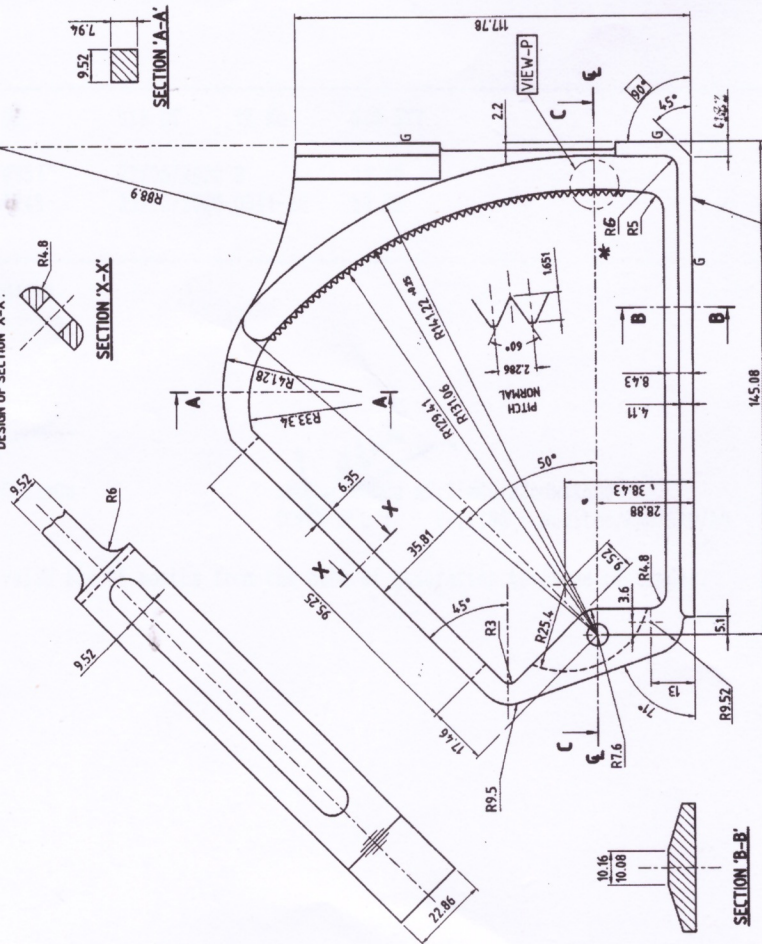
ENLARGED VIEW-P



SECTION 'E-E'



SECTION 'A-A'



SECTION 'B-B'

SECTION 'F-F'

NOTE-

1. THERE ARE 4.8 TEETH ABOVE THE CENTRE LINE AND 4 TEETH ARE BELOW THE CENTRE LINE.
2. FACES 'Y' AND 'Z' MUST BE EXACT PERPENDICULAR TO EACH OTHER.
3. FACES Y & Z TO BE GROUND SUCH THAT THESE ARE PARALLEL TO HOLE AXIS OF $\phi 6.25$ BORE. NON PARALLELISM NOT TO EXCEED 0.010 mm.
4. SCRATCHES, DENTS & NICKS WILL NOT BE PERMITTED ON SURFACES.
5. GROUND FACES ARE MARKED 'G'.
6. UNLESS OTHERWISE STATED, THE COMPONENT TO BE MACHINED ALL OVER.
7. COMPONENT SHOULD BE STABILISED BEFORE FINISH MACHINING AS PER FOLLOWING CYCLE. STABILISING TO BE DONE AFTER ROUGH MACHINING LEAVING MACHINING ALLOWANCE ALL AROUND FOR FINISH MACHINING.
 - (i) HEATING IN OIL AT 275°C-300°C FOR THREE HOURS.
 - (ii) COOLING AT -30°C FOR THREE HOURS.
 - (iii) HEATING IN OPEN FURNACE AT 100°C FOR THREE HOURS.
 - (iv) COOLING AT -30°C FOR THREE HOURS.

ALL DIMENSIONS ARE IN mm.
THIRD ANGLE PROJECTION

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

FOR TRADE COPY
Date of Issue 15/05/87
Raj

DATE-05.01.2017	SCALE- N.T.S.
MATL. AS ABOVE	TREAT -
D.A. No 95/2018 Dt. 17/04/18	SHTS.- 1
AMENDMENTS.	SHT. No.- 1
OFD/DO/002	DRAWING No.- MCT-3468

QUADRANT, FIRE CONTROL FIELD, MK. 6

FRAME
(WITHOUT ENGRAVING)

DR:- R.K.SHARMA	APPROVED.
TR:-	IT: K. H. T. J.
CH:-	JF: GM/P&P.
(Kuldeep Saini)	JWM/DO.

ORDNANCE FACTORY
DEHRADUN

REF. DRG. No.-
COA(II)-798/1