

1. REQUIREMENTS PLACED UPON CASTING ARE AS PER TECHNICAL REQUIREMENTS TT ЦП - 408.
2. CAVITIES OF MAXIMUM SIZE UPTO 2 mm DEPTH UPTO 1mm AT THE RATE OF 3 PER SURFACE ARE ALLOWED ON FINALLY MACHINED SURFACES, IF THEY ARE LOCATED NOT CLOSER THAN 10 mm FROM EACH OTHER ALONG CIRCUMFERENCE AND NOT CLOSER THAN 2 mm FROM THE EDGES.
3. DIMENSIONS WITH IN BRACKETS ARE FINISHED DIMN.
4. CASTING SHOULD BE TESTED FOR RADIOGRAPHIC TEST AS PER ASTM E - 310-1999, LEVEL - I.
5. UNSPECIFIED CASTING RADII SHOULD NOT EXCEED 3 mm.
6. CASTINGS FOR ACCEPTENCE SHOULD BE CLEANED FROM MOULDING MATERIALS BURNS AND OTHER CASTING LAMINATIONS WITH THE CUT RISERS WITHOUT BURRS.
7. IT IS ALLOWED TO MAKE THE TAPER BY LIQUID STAMPING AS PER TECHNICAL REQUIREMENT TTEП - 445.
8. PILOT SAMPLE SHOULD BE APPROVED BEFORE BULK SUPPLY.

VETTED
11 SEP 2011
JWM/STD-CELL

VETTED
30 OCT 2005
JWM/QC
SKP

CHEMICAL COMPOSITION

MATL.	%Sn	%Zn	%Pb	%P	%Ni	%Cu	%Al	%Fe	%Si	%Sb
Бр06ц63 GOST 613-79	5.0 - 7.0	5.0 - 7.0	2.0 - 4.0	0.05 Max.	-	REST	0.05 MAX	0.4 MAX	0.02 MAX	0.5 MAX

MECHANICAL PROPERTIES:

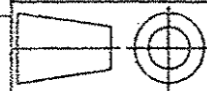
MATL.	METHOD OF CASTING	ULTIMATE STRENGTH MPa(kgf/cm ²)	RELATIVE ELONGATION AFTER RUPTURE % Min.	BRINELL HARDNESS BHN MPa(kgf/mm ²) Min.
Бр06ц63 GOST 613-79	CHILLED	176.2(18) Min.	4	588 (60)

TAPER		Бр06ц63 GOST 613-79		WEIGHT=1.56 kg		
संख्या NO. OFF	विवरण DESCRIPTION	पुर्जा क्र. PART NO.	पदार्थ MATERIAL	मानक STANDARD	परिमाण DIMENSIONS	अन्यक्ति REMARKS
सामान्य सहिष्णुता GENERAL TOLERANCE						
रैखिक परिमाण LINEAR DIMENSION						
0-5	±0.1					
6-30	±0.2					
30-120	±0.3					
120-315	±0.5					
315-1000	±0.8					
1000-2000	±1.2					
कोणिक परिमाण ANGULAR DIMENSION						
1-10	±1°					
10-50	±30'					
50-100	±20'					
>100	±10'					
मापक 'म्यू एम' में VALUE IN 'μm'						
-	>25					
V	8-25					
PP	1.6-8					
PPV	0.025-1.6					
PPVV	<0.025					
CASTING FOR TAPER FOR COUPLING SHAFT Drg.No.765-12-CB142				मापमान SCALE	आरेखित DRAWN	27/08/05
BMP-I				1:1	जाँचा CHECKED	30-10
मशीनी औजार आदिखप फैक्टरी, अम्बरनाथ				कार्यालय OFFICE	अनुमोदित APPROVED	
MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH				D.O	द्वारा बदला REPLACED BY	
					हेतु बदला REPLACED FOR	
					आरेखण क्र. DRAWING NO.	765-12-194-2

इन आरेखणों तथा इसके साथ की सम्पूर्ण सामग्री का स्वत्वाधिकार भारत सरकार रक्षा मंत्रालय की भारतीय आयुध निर्माणियों के पास है। भारतीय आयुध निर्माणों के महानिदेशक को लिखित अनुमति के बिना इनकी नकल या किसी भी रूप में इनके उद्धरण क इनमें समाहित सूचना किसी अनधिकृत व्यक्ति को उपलब्ध नहीं कराई जानी चाहिए।

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मूलमाप व अन्वयोजन NOMINAL SIZE & FIT	विचलन DEVIATION



NOTE ADDED AS PER AHSP SEALED Drg. No.765-12-194 "TAPER" D:17/10/05,V-23025

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