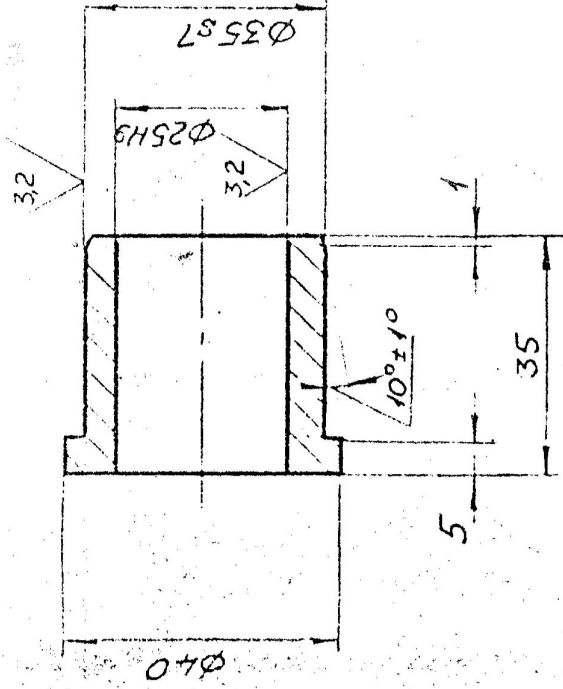


2344-10-02МК


125



Неуказанные предельные отклонения размеров:

Валов - h14, остальных - $\pm \frac{IT14}{2}$

BUSH
 TANK ASSY.
 125 mm SCCC WINDING M/C
 NO. OFF - 4 MATL. PHOS. BRONZE
 DRG. NO VMT. SK. 119.8029-14

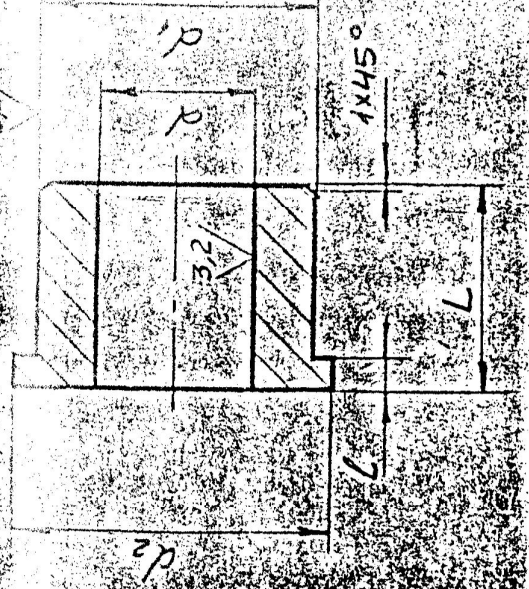
APPROVED BY

 18/08/20

		2344-10-02МК		Масса		Классиф.	
		Втулка		шт.		шт.	
		1007493-79		1		1	
Изм. Лист		№ докум		Листы			

2344-10-09MK

(N)

32/



MM

Обозначение	d	d ₁	d ₂	ℓ	L
2344-10-09MK					
01	20H9	40H8	45	5	15
02	22H9	40H8	45	4	32

Неуказанные предельные отклонения по меребов - h14, остальных - ± IT14 / 2

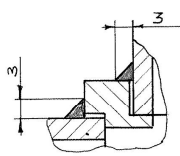
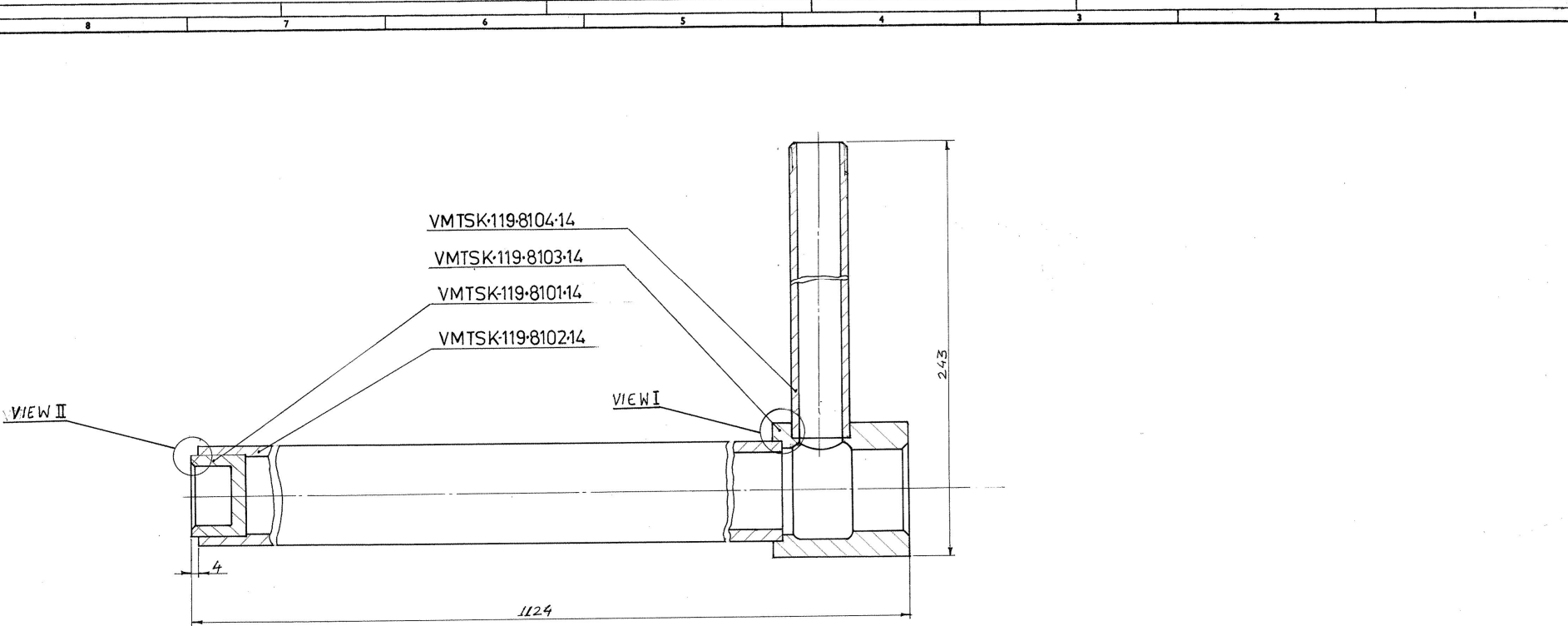
BUSH
TANK ASSY.
125 mm SCCC WINDING M/C
NO. OFF - 4 (EACH) MATL. PHOS. BRONZE

DRG. NO. VMT SK 119.8030-14
VMT SK 119.8031-14

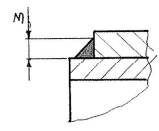
18/01/2K

2344-10-09MK		Авт.	Масса	Масштаб
Втулка		И		
PHOSPHEROUS BRONZE.		Автом	Автом	1
5р. А9Х 3Л ГОСТ 493-79				

510000 ALU



VIEW I



VIEW II

E-WELDED

* NOTE-STRESSES TO BE RELIEVED AFTER WELDING

इन आरेखों तथा इसके साथ की सम्पूर्ण सामग्री का मन्वत्वाधिकार भारत सरकार, रक्षा मन्त्रालय की भारतीय आयुध निर्माणियों के पास है। भारतीय आयुध निर्माणियों के महानिदेशक को लिखित अनुमति के बिना इनकी नकल या किसी भी रूप में इनके उद्धरण या इनमें समाहित सूचना किसी अनधिकृत व्यक्ति को उपलब्ध नहीं कराई जानी चाहिए।
 THE COPYRIGHT OF THESE DRAWINGS AND ALL ATTACHMENTS THERETO BELONGS TO THE INDIAN ORDNANCE FACTORIES, MINISTRY OF DEFENCE, GOVT. OF INDIA. THEY SHOULD NOT BE COPIED, REPRODUCED IN ANY WAY OR THE INFORMATION CONTAINED THEREIN MADE AVAILABLE TO UN-AUTHORISED PERSONS WITHOUT THE WRITTEN PERMISSION OF THE DIRECTOR GENERAL OF ORDNANCE FACTORIES.

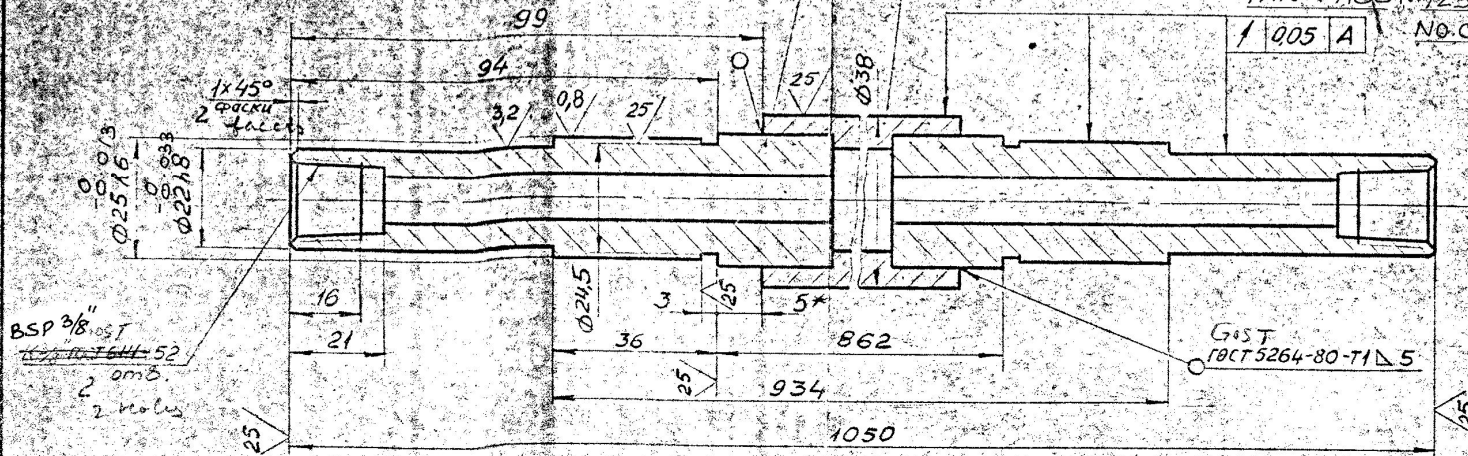
मानक व अन्वयोजन NOMINAL SIZE & FIT	विचलन DEVIATION	
---------------------------------------	--------------------	--

संख्या NO. OFF.	विवरण DESCRIPTION	पार्ट नं. PART NO.	पदार्थ MATERIAL	मानक STANDARD	परिमाण DIMENSIONS	अभ्यांकित REMARKS
सामान्य सहिष्णुता GENERAL TOLERANCE						
रेखिक परिमाण LINEAR DIMENSION						
0 - 6 ± 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 - 25 ± 30'						
50 - 100 ± 30'						
> 100 ± 10'						
मापक सूत्र VALUE IN μm						
H 0 - 25						
h 0 - 25						
f 1.6 - 8						
F 0.025 - 1.6						
f 0.025 < 0.025						
संख्या NO. OFF.	संबंधित पुर्जोका आरेखण क्र. DRG. NO. OF ASSOCIATED PART	सूचक INDEX	संशोधन ALTERATION	दिनांक DATE	नाम NAME	
	CYLINDER			3.5.95	...	
TANK BODY ASSEMBLY						
125mm SCCC WINDING M/C						
मापमान SCALE	आरेखित DRAWN	जांचा CHECKED	अनुमोदित APPROVED	द्वारा BY	बदला REPLACEMENT	कार्यालय OFFICE
1:1	WMT
मशीनी औजार आधिकार फेक्टरी, अम्बरनाथ MACHINE TOOL PROTOTYPE FACTORY, AMBARNATH						
आरेखण क्र. DRAWING NO. VMTSK-119-8100-42						

2344-1010-00MK СБ

DRG. NO. VMT-SK.119-8100-A13
 SCRAPER SHAFT
 TANK ASSY-125mm SCCC WINDING M/C

1 005 A NO. OF P. - 1



1. After welding to be heat treated for stress relief.
2. Dimensions for Reference.
3. Unspecified limit size deviations for holes - H14, for shafts - h11 for Remaining - ± JT14
4. Welding to be carried out with electrode УОНИИ - 17/45 - 3-2 GOST 9466-75
5. To be subject to internal hydraulic pressure of $4 \cdot 10^5$ Pa for strength test for 30 min.
6. Check for absence of crack by kerolene test method.

1. После сварки термообработать для снятия напряжений.
- 2.* Размеры для справок.
3. Неуказанные предельные отклонения размеров: отв. - H14, валов - h11, остальных - ± JT14
4. Сварку производить электродом УОНИИ - 17/45 - 3-2 GOST 9466-75.
5. Испытать на прочность внутренним гидравлическим давлением $4 \cdot 10^5$ Па в течение 30 минут.
6. Проверить отсутствие трещин методом керосиновой пробы.

APPROVED BY
 [Signature]
 2818

TO BE MANUFACTURED FROM VMT-SK-119-8100-A42

			2344-1010-00MK СБ					
BSP 3/8" 52 16mm 52 2 holes			Ось сборочный чертёж Scraper Shaft			Лист	Масса	Масштаб
1ST ANGLE PROJECTION						И 1		1:1
03 Sheets.			ASSEMBLY Drawing			Лист	Листов	4
						57/336		