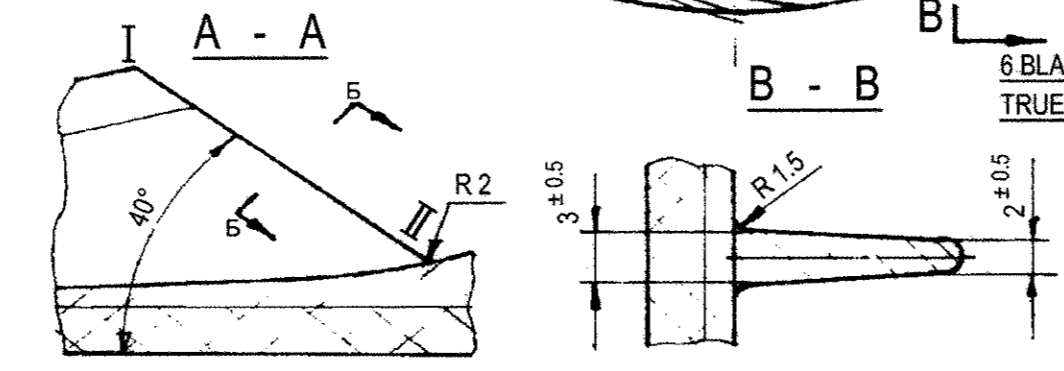
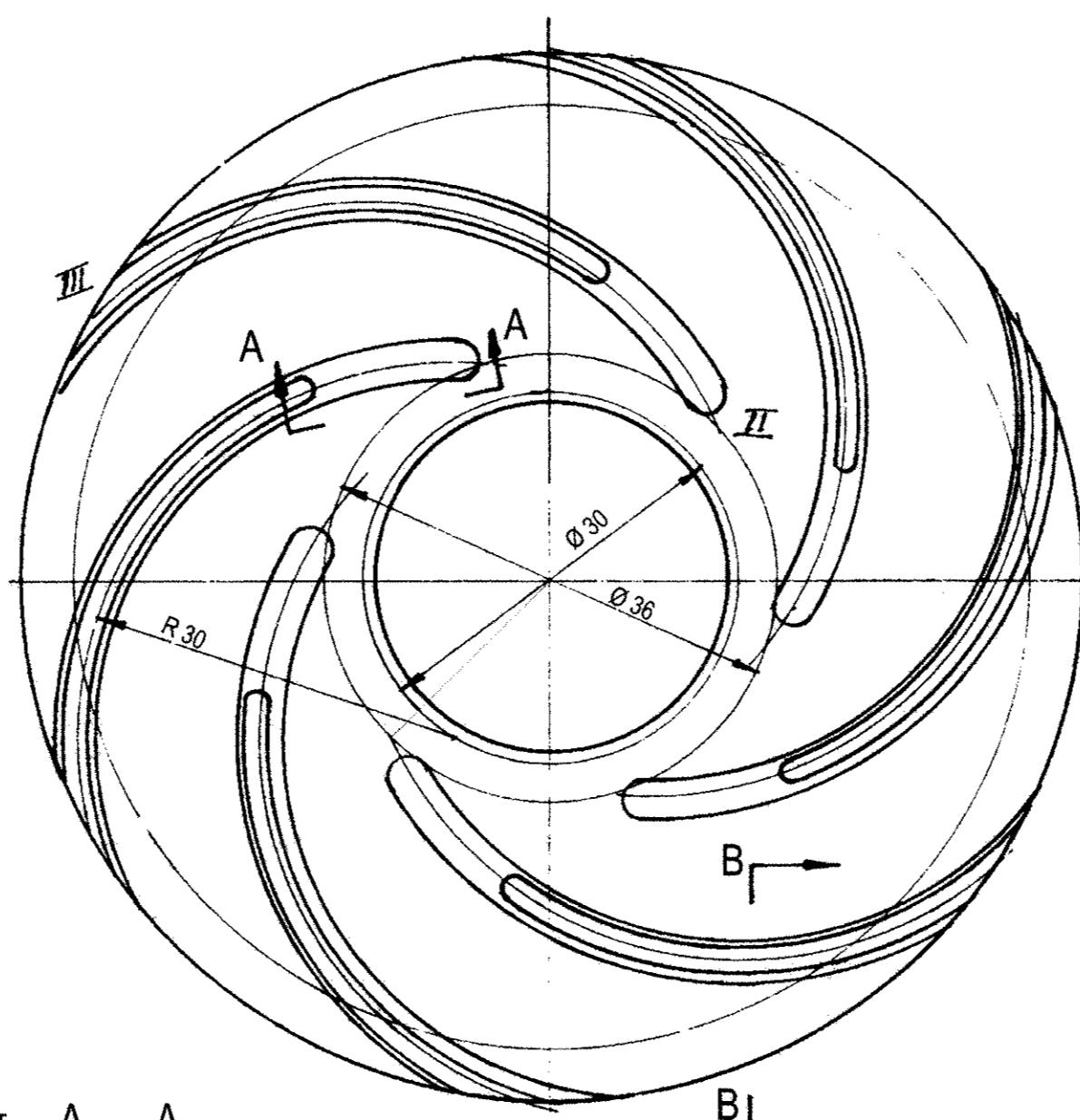
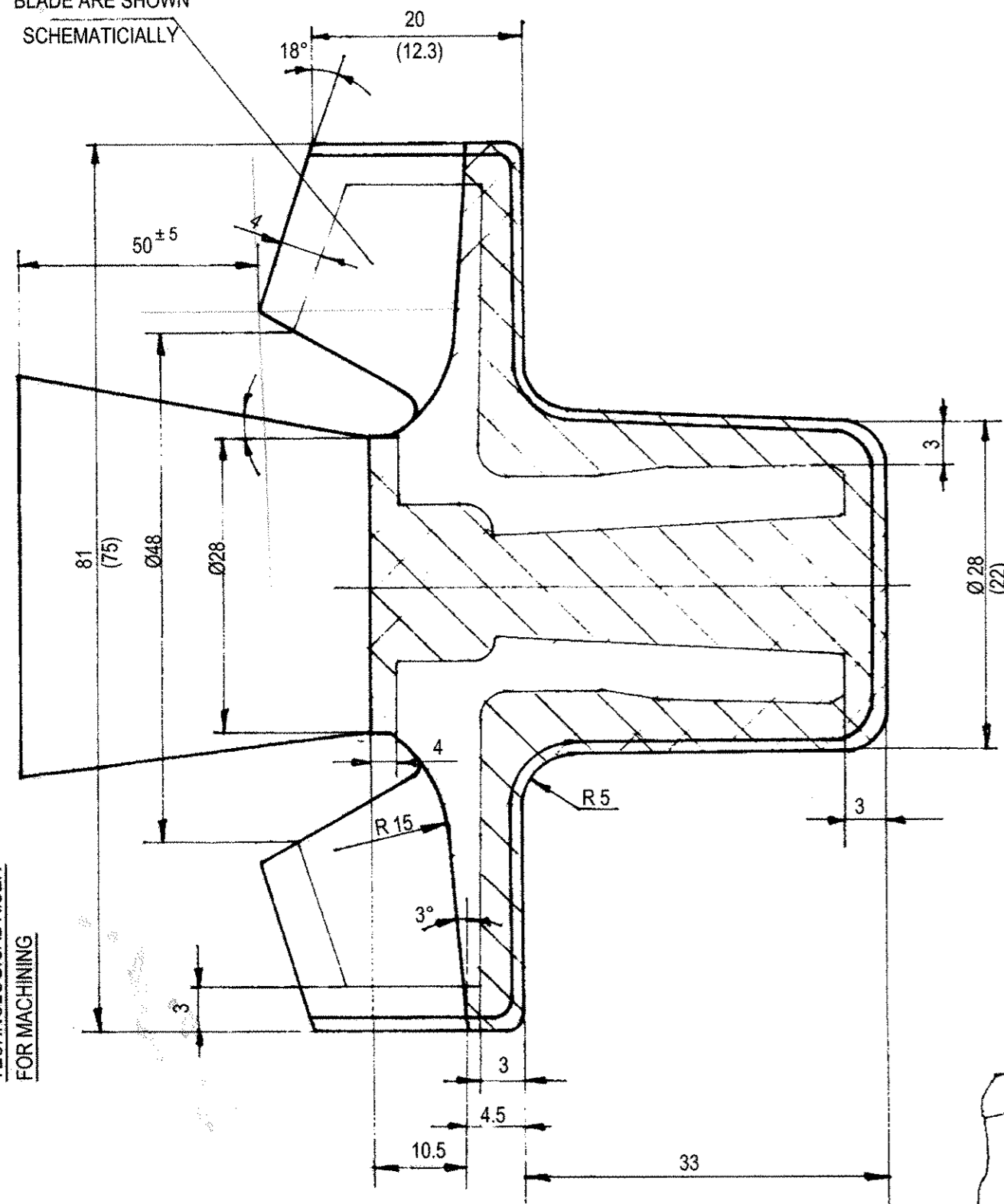


BLADE ARE SHOWN SCHEMATICALLY



B - B FROM (IN POINT I) UP TO R 1.5 (IN POINT II)

1. USE METAL MOULD CASTING.
2. UNSPECIFIED PATTERN DRAFTS SHOULD NOT EXCEED 2°.
3. UNSPECIFIED CASTING RADII R 3.
4. BLADES MAY BE MADE BY SMOOTH INCREASING OF THICKNESS FROM 2±0.5 AT POINT I UP TO 3±0.5 AND 40.5 AT POINT II.
5. TOLERANCES ON CASTING SURFACES ARE  $\begin{matrix} +1.5 \\ -1.0 \end{matrix}$
6. CAVITIES IF THEY ARE NOT IN ONE GROUP, MAY BE IN QUANTITY NOT MORE THAN 15 NOS. FOR A PART AND NOT MORE THAN 3 NOS. FOR A SURFACE TO A DEPTH UP TO 1 mm AND OF AREA OF 3 mm<sup>2</sup> EACH ON SURFACES TO BE MACHINED AND NOT TO BE MACHINED ARE ALLOWED CAVITIES, WHICH ARE IN THE SAME PLACE OF OPPOSITE SURFACES ON SURFACES OF Ø 20 AND ON EDGES OF BLADES ARE NOT ALLOWED.
7. POROSITY OF BOSS SHOULD NOT EXCEED 0.3 mm.
8. PART MAY BE MADE OF BRONZE OF GRADE брОуС-5-5-5 брОуСН-3-7-5-1 GOST-613-65 AND брА\*10-3-15 GOST - 18175 - 78 AND ALSO FROM BRASS LK80-3 GOST-17711-78.
9. DO NOT MARK.
10. OTHER REQUIREMENTS OF CASTING SHOULD BE AS PER 54 TY P6-4 OR TT 4A408.
11. PART 765-55-185 IS MADE OF TECHNOLOGICAL RISER.

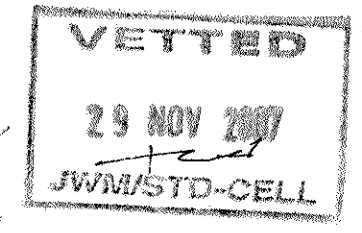
NOTE:- CASTING SHOULD BE TESTED FOR RADIOGRAPHIC TEST AS PER ASTM E-310:1999 LEVEL-II

CHEMICAL COMPOSITION (%)

	бр А 9Ж3 л GOST-493-79	
ALUMINIUM	8.0 - 10.5	✓
IRON	2.0 - 4.0	✓
COPPER	REST	✓
ARSENIC	0.05 Max.	✓
ANTIMONY	0.05 Max.	✓
TIN	0.2 Max.	✓
SILICON	0.2 Max.	✓
NICKEL	1.0 Max.	✓
LEAD	0.1 Max.	✓
PHOSPHORUS	0.1 Max.	✓
ZINC	1.0 Max.	✓
MANGANESE	0.5 Max.	✓
TOTAL	2.7 Max.	✓

MECHANICAL PROPERTIES

ULTIMATE STRENGTH, 40 Kg/mm <sup>2</sup> Min.	✓
RELATIVE ELONGATION, % 10 Min.	✓
HARDNESS, HB. 100 Min.	✓



NOTE: RADIOGRAPHY TESTS IS MEANT FOR TRADE SUPPLIES ONLY

6 BLADES AT EQUAL DISTANCES OF BLADES FROM THEIR TRUE POSITION SHOULD NOT EXCEED 1 mm.

इन आरेखणों तथा इसके साथ की सम्पूर्ण सामग्री का स्वत्वाधिकार भारत सरकार रक्षा मंत्रालय की भारतीय आयुध निर्माणियों के पास है। भारतीय आयुध निर्माणियों के महानिदेशक की 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 THERE TO 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 UNAUTHORIZED PERSONS WITHOUT THE WRITTEN PERMISSION OF THE DIRECTOR OF ORDNANCE FACTORIES

संख्या NO. OFF	विवरण DESCRIPTION	पुर्जा क्र. PART NO.	पदार्थ MATERIAL	मानक STANDARD	परिमाण DIMENSIONS	अभ्यक्ति REMARKS																														
			БРА9Ж3л GOST-493-79		WT-0.600 Kg																															
<p>सामान्य सहिष्णुता GENERAL TOLERANCE</p> <p>रेखिक परिमाण LINEAR DIMENSION</p> <table border="1"> <tr><td>0-6</td><td>±0.1</td></tr> <tr><td>6-30</td><td>±0.2</td></tr> <tr><td>30-120</td><td>±0.3</td></tr> <tr><td>120-315</td><td>±0.5</td></tr> <tr><td>315-1000</td><td>±0.8</td></tr> <tr><td>1000-2000</td><td>±1.2</td></tr> </table> <p>कोणिक परिमाण ANGULAR DIMENSION</p> <table border="1"> <tr><td>1-10</td><td>±1'</td></tr> <tr><td>10-50</td><td>±30'</td></tr> <tr><td>50-100</td><td>±20'</td></tr> <tr><td>&gt;100</td><td>±10'</td></tr> </table> <p>मापक 'म्यू एम' में VALUE IN 'μm'</p> <table border="1"> <tr><td>-</td><td>&gt;25</td></tr> <tr><td>□</td><td>6-25</td></tr> <tr><td>□□</td><td>1.6-6</td></tr> <tr><td>□□□</td><td>0.025-1.6</td></tr> <tr><td>□□□□</td><td>&lt;0.025</td></tr> </table>							0-6	±0.1	6-30	±0.2	30-120	±0.3	120-315	±0.5	315-1000	±0.8	1000-2000	±1.2	1-10	±1'	10-50	±30'	50-100	±20'	>100	±10'	-	>25	□	6-25	□□	1.6-6	□□□	0.025-1.6	□□□□	<0.025
0-6	±0.1																																			
6-30	±0.2																																			
30-120	±0.3																																			
120-315	±0.5																																			
315-1000	±0.8																																			
1000-2000	±1.2																																			
1-10	±1'																																			
10-50	±30'																																			
50-100	±20'																																			
>100	±10'																																			
-	>25																																			
□	6-25																																			
□□	1.6-6																																			
□□□	0.025-1.6																																			
□□□□	<0.025																																			
संख्या NO. OFF	संबंधित पुर्जा का आरेखण क्र. DRG. NO. OF ASSOCIATED PART	सूचक INDEX	संशोधन ALTERATION	2007	दिनांक DATE	नाम NAME																														
					24.11.07	Y.D.K.																														
<p>CASTING OF IMPELLER</p> <p>CODE 38</p> <p>मशीनी औजार आदिरूप फैक्टरी, अम्बरनाथ MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH</p>				<p>मापमान SCALE</p> <p>NTS</p>	<p>आरेखित DRAWN</p> <p>जाँचा CHECKED</p> <p>अनुमोदित APPROVED</p> <p>द्वारा बदला REPLACED BY</p> <p>हेतु बदला REPLACED FOR</p>	<p>कार्यालय OFFICE</p> <p>D.O.</p>																														
<p>मूलमाप व अन्वयोजन NOMINAL SIZE &amp; FIT</p>				<p>विचलन DEVIATION</p>	<p>आरेखण क्र. DRAWING NO.</p> <p>54-83-005-1A-2</p>																															