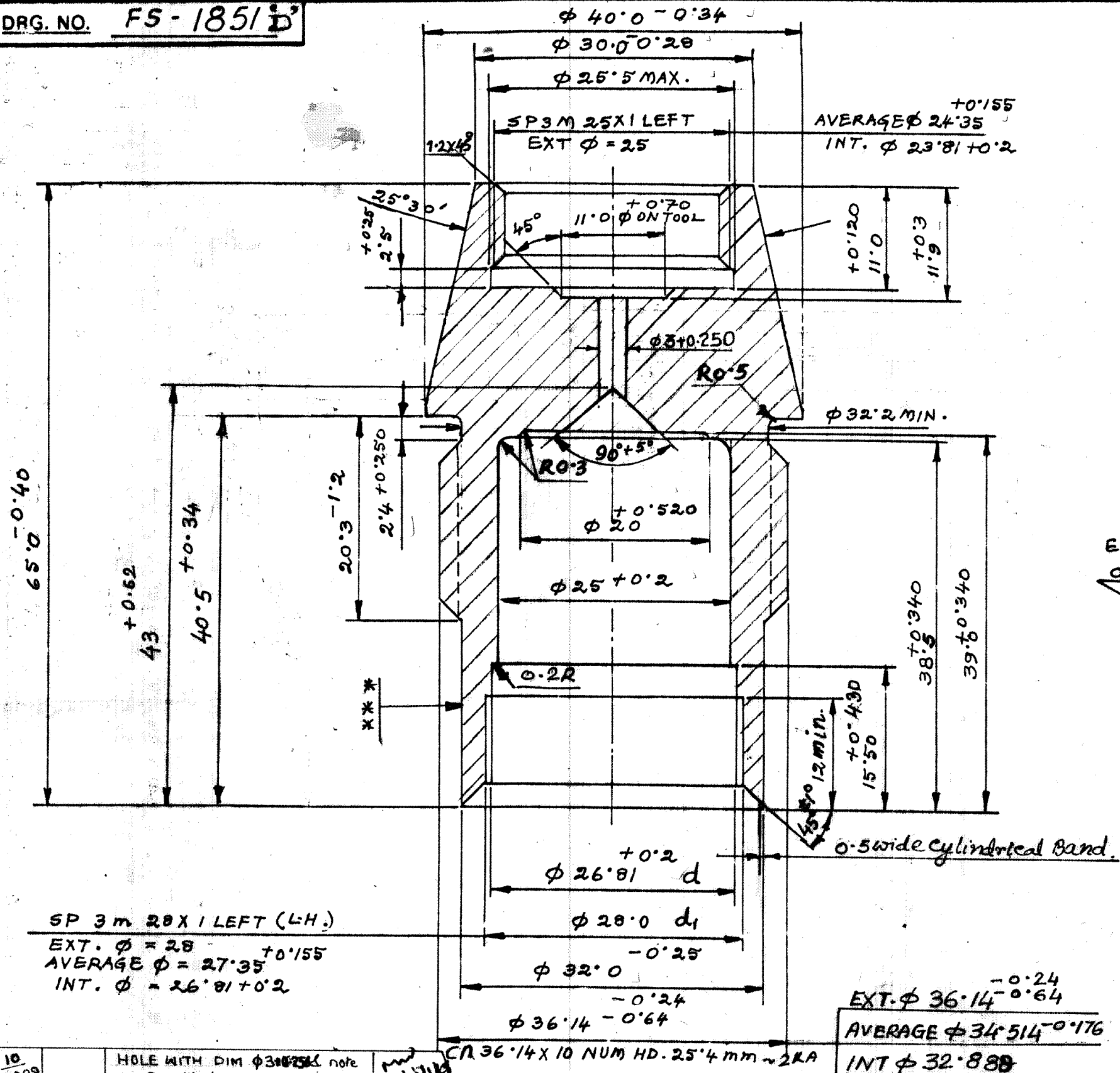
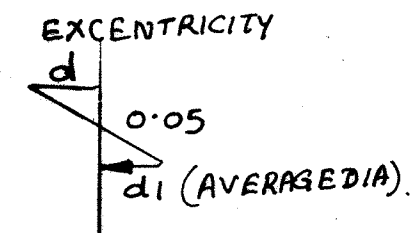


DRG. NO. **FS-1851 D**



NOTE:
 1) Manufacturers Monogram to be engraved/etched/stamped on *** circumference.
 2) THE SURFACES NOT BEARING THE SIGN OF SURFACE FINISH MUST SATISFY THE REQUIREMENTS FOR THE MATERIAL.



Material:- Steel to Specn. BS 970 Pt 1: 1972
 080 M40 (Normalised) Grainsize 5-8
 The material should satisfy specified IZOD
 impact value of 20.340 Nm Minimum.

SP 3m 20x1 LEFT (L.H.)
 EXT. $\phi = 28$
 AVERAGE $\phi = 27.35$
 INT. $\phi = 26.81 \pm 0.2$

EXT. $\phi 36.14$
 AVERAGE $\phi 34.514$
 INT. $\phi 32.88$

REV.	DATE	DESCRIPTION	SIGN.
10	2009	HOLE WITH DIM $\phi 30.25$ note no. 2 added.	JGM/FS
C	21.10.99	Internal cone called in dry. Corresponding dims 43 to 62. angle 90+5 also added. DA NO. 441/99	JGM/FS
B	14.9.99	Dim 40.5 & 1.2x45 are added. Note for Mfg. Monogram added. Dim 26.4 to 4 deleted. DRG. NO. ADV. TO B. DA. NO. 410/99	JGM/FS
A	6.7.99	Matl. Specification added. DRG. NO. ADV. TO A. DA. NO. 294/99	JGM/FS

AMENDMENTS

UNSPECIFIED MACHINING DEVIATIONS			ANGULAR DIMENSIONS			SURFACE ROUGHNESS	
LINEAR DIMENSIONS	LENGTH OF SHORTER SIDE	DEVIATION	OF ANG.	DEGREE	SYMBOL	MAX. Ra VALUE	IN μm
ABOVE 6	6	± 0.1	UP TO 10	$\pm 10'$	V	50	
6	30	± 0.2	ABOVE UP TO 10	165	~	25	
30	120	± 0.3	10	± 0.1	V	6.3	
120	315	± 0.5	50	± 0.2	VV	0.8	
315	1000	± 0.8	100	± 0.5	VVV	0.8	
1000	2000	± 1.2	120	± 0.8	VVVV	0.1	

DIMENSIONS ARE IN mm			MATERIAL	ORDNANCE FACTORY, AMBAJHARI.
THIRD ANGLE PROJECTION			AS Above.	
SCALE 2:1			NOMENCLATURE -	DRAWING NO. - FS-1851 D
1999	NAME	DATE	BODY	
DRAWN	JGM/FS	28.6.99	(TURNING OPERATION)	SHEET NO. - 1
TRACED				NO. OF SHEETS - 1
CHECKED	JGM/FS	29.6.99		FEATURE NO. -
JWM/CDO		29.6.99		COMPT. - BODY
APPROV.	J.G.M/FA		SCHEDULE NO. -	
			STORE - FBF 29	