

GENERAL TOL. FINE / MEDIUM / COARSE

CLASS TO IS 3102

DRAWING CONVENTIONS CONFORM TO INDIAN STANDARDS

DIMENSIONS ARE IN mm UNLESS OTHERWISE IS STATED.

SECTION A-A

SECTION B-B

SECTION C-C

SECTION D-D

SECTION E-E

SECTION F-F

SECTION G-G

SECTION H-H

SECTION I-I

DETAIL J
SCALE 2 : 1
141 OR 751 1.5 X 10.5

DETAIL K
SCALE 1 : 1
W

DETAIL L
SCALE 2 : 1
W

DETAIL M
SCALE 2 : 1
W

DETAIL N
SCALE 2 : 1
W

DETAIL O
SCALE 2 : 1
W

DETAIL P
SCALE 1 : 1
W

DETAIL Q
SCALE 2 : 1
W

DETAIL R
SCALE 2 : 1
W

DETAIL S
SCALE 2 : 1
W

DETAIL T
SCALE 2 : 1
W

DETAIL U
SCALE 2 : 1
W

DETAIL V
SCALE 2 : 1
W

DETAIL W
SCALE 1 : 1
W

DETAIL X
SCALE 2 : 1
W

DETAIL Y
SCALE 2 : 1
W

DETAIL Z
SCALE 2 : 1
W

DETAIL H
SCALE 1 : 1
W

ITEM NO. **PART NUMBER** **DESCRIPTION** **QTY.**

1 BODY RECEIVER 1804 01 01 01 001 000A 1

2 HOUSING REAR SHFT 1804 01 01 01 002 000A 1

3 HOUSING COVER 1804 01 01 01 003 000A 1

4 BRACKET BARREL LATCH 1804 01 01 01 004 000A 1

5 PLATE REAR COVER 1804 01 01 01 005 000A 1

6 BUTTON FEED BOX 1804 01 01 01 007 000A 1

7 PLATE FRONT COVER 1804 01 01 01 006 000A 1

G

Sp. No.	Date	Authority	BRIEF RECORD	ZONES	CD	GO	SIGN
DRN: HARSH	SIGN:	MATERIAL:	*****				
APPD.: 28/06/2022	CHECKED						
DATE: 28/06/2022	FOR DIRECTOR						
DESIGN AUTHORITY	EST. MASS						
ARDE	-----						
PUNE 411011							

H

(W)-TO BE TIG LASER WELDED

2. EXCESS RUN OF WELD TO BE FLUSH PROPERLY

3. WELDING PROCEDURE SHOULD BE APPROVED AS PER IS-3821 AND METHOD OF TESTING WELDED JOINTS SHOULD CONFIRM TO IS-3800.

4. FIRSTLY, HOLE 'H' ON RECEIVER BODY SHOULD BE MADE CONCENTRIC WITH HOLE 'H' ON HOUSING COVER; AND THEN WELDING IS TO BE DONE AS SHOWN.

5. TO BE CASE CARBURIZED UPTO CASE DEPTH OF 0.18 - 0.26 mm AND CASE HARDNESS OF 560 - 600 HV

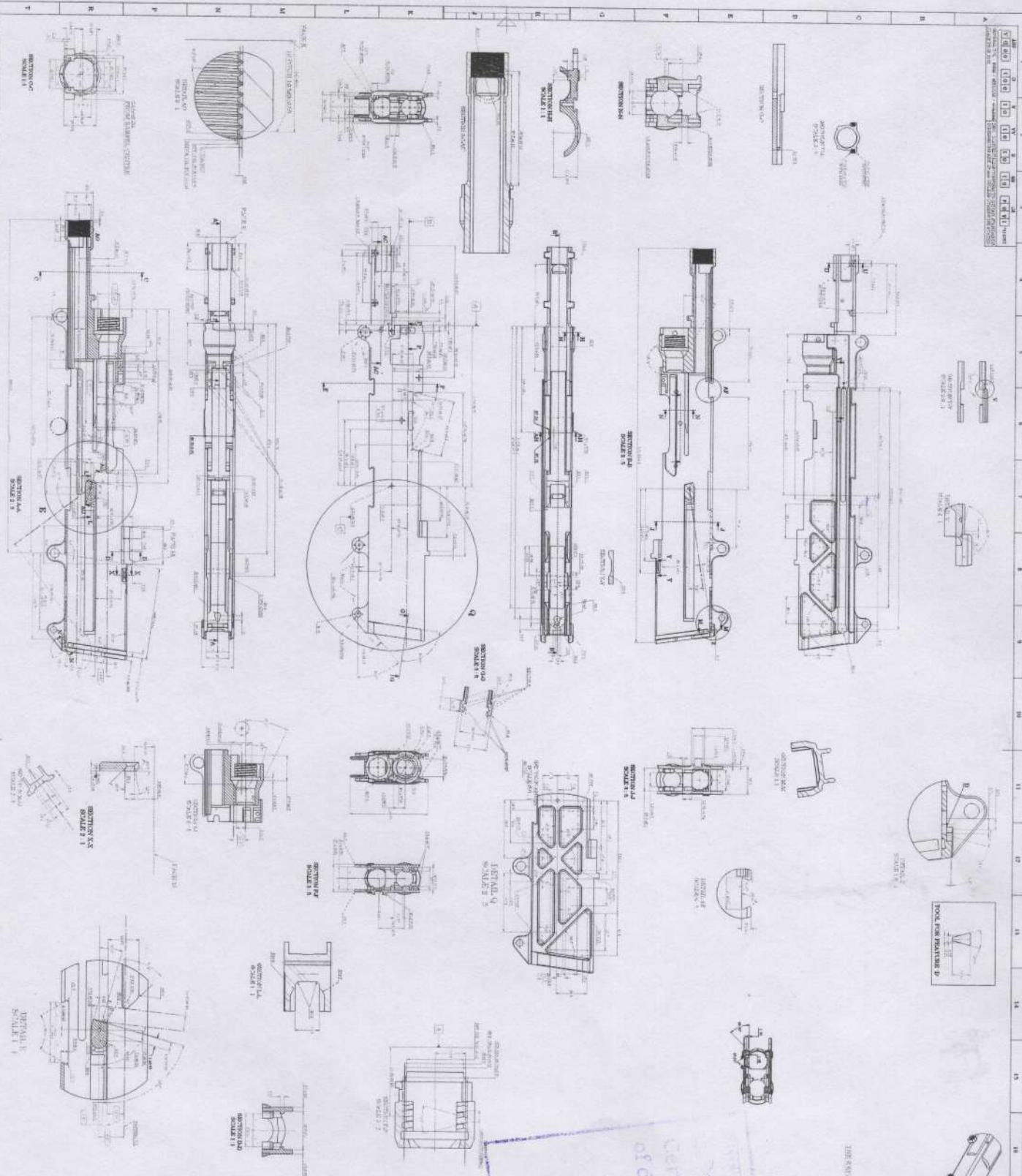
6. TO BE HARDENED AND TEMPERED TO THE CORE HARDNESS OF 380 - 390 HV

7. REMOVE ALL SHARP EDGES AND BURRS

I

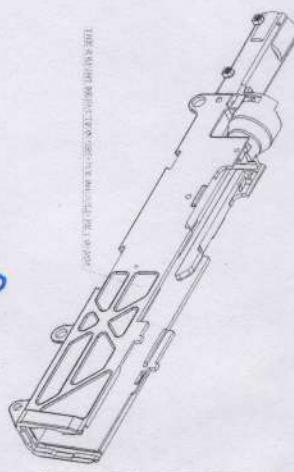
LNG	PART No.	DS CAT No.	AHSP
1C	S	C	SS

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कृ. कार्यालय अधिकारी
वर्ष २०१८ - २०१९
Jr. Works Manager
द्वि-वर्षीय
DDO

Hosim-
दिल्ली की सही प्रगतिः



SECTION A-A

SECTION B-B
SCALE 1.5 : 1

SECTION C-C

SECTION D-D

SECTION E-E

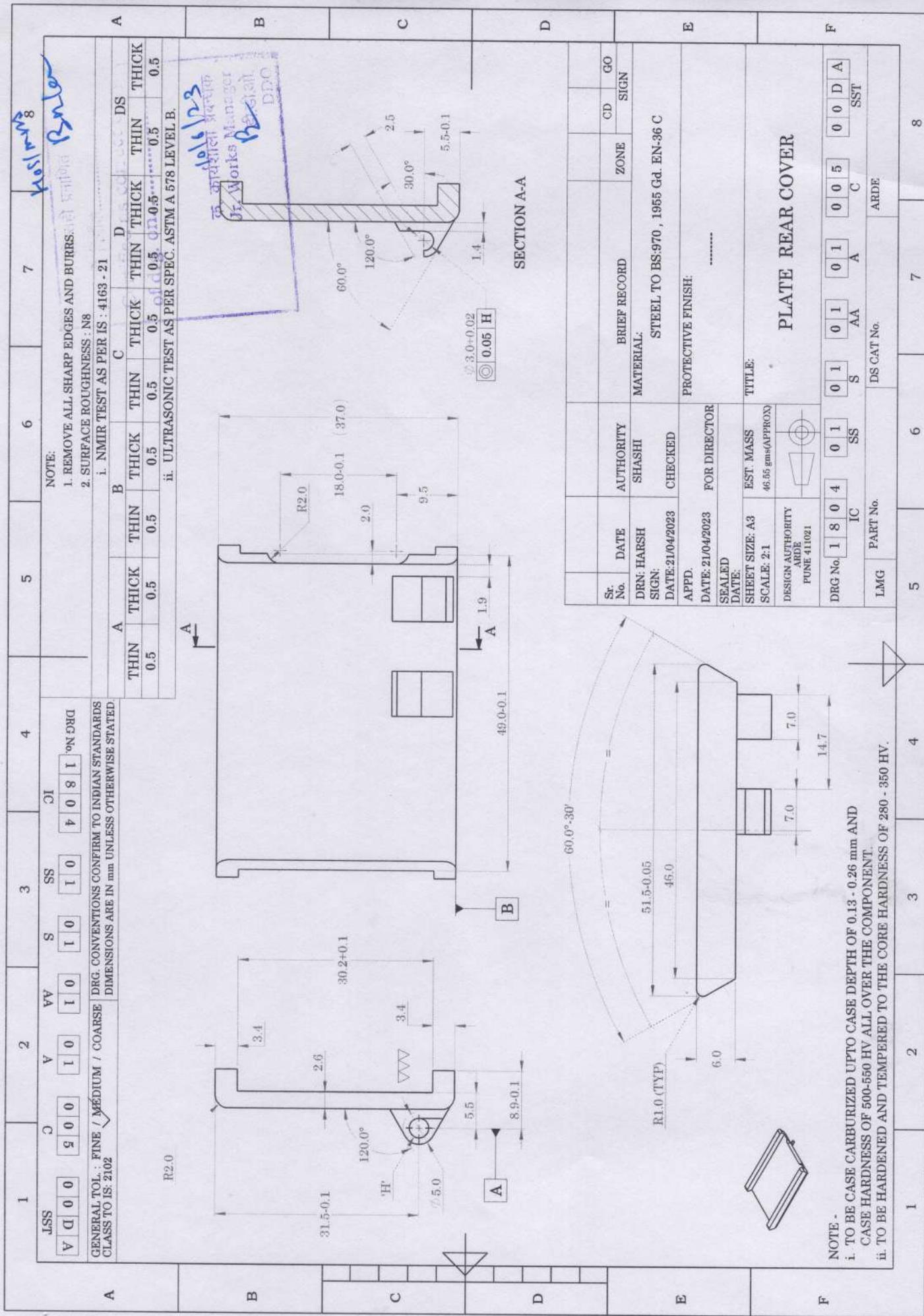
SECTION F-F

DETAIL C

1	2	3	4	5	6	7	8
JSS V Q 0 0	3 8 0 0	V 1 0	SS 1 0	3I 1 0	NOTE: 1. REMOVE ALL SHARP EDGES AND BURRS. 2. SURFACE ROUGHNESS: N8	R3.0 10.0+0.1 2.0 X 60	R3.0 6.25 22.0+0.02
GENERAL TOL.: FINE / MEDIUM / COARSE	DRG. CONVENTIONS CONFIRM TO INDIAN STANDARDS						
CLASS TO IS: 2102	DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED.						

LMG	PART No.	DS CAT No.	AHSP
DRG No. 1 IC	8 0 4 SS	0 1 AA	0 0 3 C
			0 0 D A SST

	1	2	3	4	5	6	7	8																		
GENERAL TOL : FINE / MEDIUM / COARSE CLASS TO IS: 2102	JSS V 0 0 0 0 0 V 0 0	JSS V 0 0 1 0 0 1 0	JSS S 1 0 0	JSS SS 1 0 0	JSS C 4 0 8 1																					
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B																										
C																										
D	<p>i. NMIR TEST AS PER IS : 4163 - 21</p> <table border="1" style="margin-left: auto; margin-right: auto;"> <thead> <tr> <th>THIN</th> <th>A</th> <th>B</th> <th>C</th> <th>D</th> <th>DS</th> </tr> <tr> <th>0.5</th> <td>0.5</td> <td>0.5</td> <td>0.5</td> <td>0.5</td> <td>0.5</td> </tr> </thead> <tbody> <tr> <td>0.5</td> <td>0.5</td> <td>0.5</td> <td>0.5</td> <td>0.5</td> <td>0.5</td> </tr> </tbody> </table> <p>ii. ULTRASONIC TEST AS PER SPEC. ASTM A 578 LEVEL B.</p>								THIN	A	B	C	D	DS	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5	0.5
THIN	A	B	C	D	DS																					
0.5	0.5	0.5	0.5	0.5	0.5																					
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E	<p>Sr. No. DATE AUTHORITY BRIEF RECORD ZONE CD GO</p> <p>DRN: HARSH SHASHI MATERIAL: SIGN: PROTECTIVE FINISH: *****</p> <p>SIGN: DATE: 21/04/2023 CHECKED APPD. DATE: 21/04/2023 FOR DIRECTOR</p> <p>APPD. DATE: 21/04/2023 FOR DIRECTOR</p> <p>SEALED DATE: SHEET SIZE: A3 EST. MASS: TITLE: SECTION A-A</p> <p>DESIGN AUTHORITY: ARDDE PUNE 411021 SCALE: 5:1 5.40 grams(approx) BRACKET BARREL LATCH</p> <p>NOTE : i. TO BE CASE CARBURIZED UPTO CASE DEPTH OF 0.13 - 0.26 mm AND CASE HARDNESS OF 500-550 HV ALL OVER THE COMPONENT. ii. TO BE HARDENED AND TEMPERED TO THE CORE HARDNESS OF 280 - 350 HV.</p>																									
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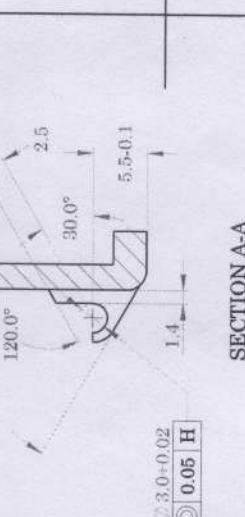
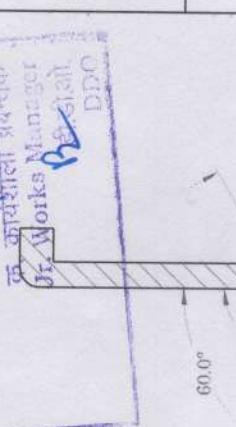


NOTE:

- i. REMOVE ALL SHARP EDGES AND BURRS.
- 2. SURFACE ROUGHNESS N8

i. NMIR TEST AS PER IS : 4163 - 21

- ii. ULTRASONIC TEST AS PER SPEC. ASTM A 578 LEVEL B.

A

SECTION A-A

Sr. No.	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO
DRN: HARSH	SHASHI	MATERIAL: STEEL TO BS:970, 1955 Gd. EN-36 C	CHECKED	PROTECTIVE FINISH:	*****	

APPD.	DATE: 21/04/2023	FOR DIRECTOR	SEALED	SHEET SIZE: A3	EST. MASS	TITLE:
DESIGN AUTHORITY ARDE PUNE 411021	DATE: 21/04/2023			SCALE: 2:1 46.55 gms(APPROX)	R1.0 (TYP)	PLATE REAR COVER

DRG No.	1	8	0	4	0	1	0	0	5	0	0	D	A
IC		SS		S	AA	A	C		SST				

LMG	PART No.	DS CAT No.	ARDE
1	2	3	4

1	2	3	4	5	6	7
1	2	3	4	5	6	7

1	2	3	4	5	6	7
1	2	3	4	5	6	7

1	2	3	4	5	6	7
1	2	3	4	5	6	7

1	2	3	4	5	6	7
1	2	3	4	5	6	7

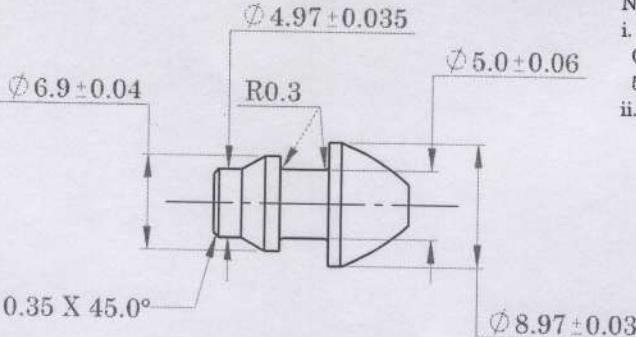
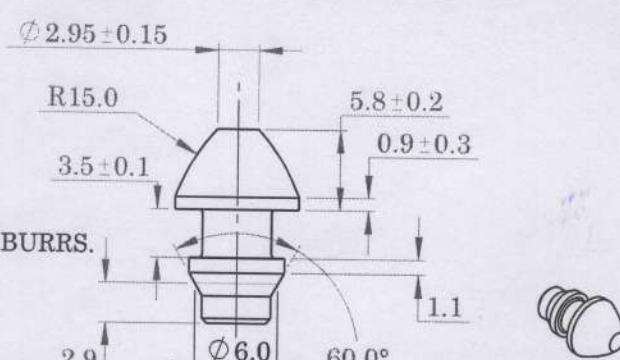
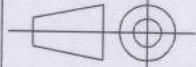
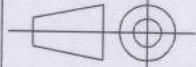
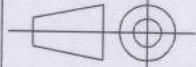
1	2	3	4	5	6	7
1	2	3	4	5	6	7

1	2	3	4	5	6	7
1	2	3	4	5	6	7

1	2	3	4	5	6	7
1	2	3	4	5	6	7

1	2	3	4	5	6	7
1	2	3	4	5	6	7

1	2	3 HARSH Copy of drg. J. Works Manager S. (31) DDO	4																				
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APPD. DATE:21/04/2023 FOR DIRECTOR				PROTECTIVE FINISH: ---																			
SEALED DATE:																							
SHEET SIZE: A4 SCALE: 2:1		EST. MASS 19.62 gm (Approx)		TITLE: PLATE FRONT COVER																			
DESIGN AUTHORITY ARDE PUNE 411021																							
DRG No. 1 8 0 4 0 1 0 1 0 1 0 0 6 0 0 D A IC SS S AA A C SST																							
LMG PART No.		DS CAT No.		AHSP		ARDE																	
1		2		3		4																	

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