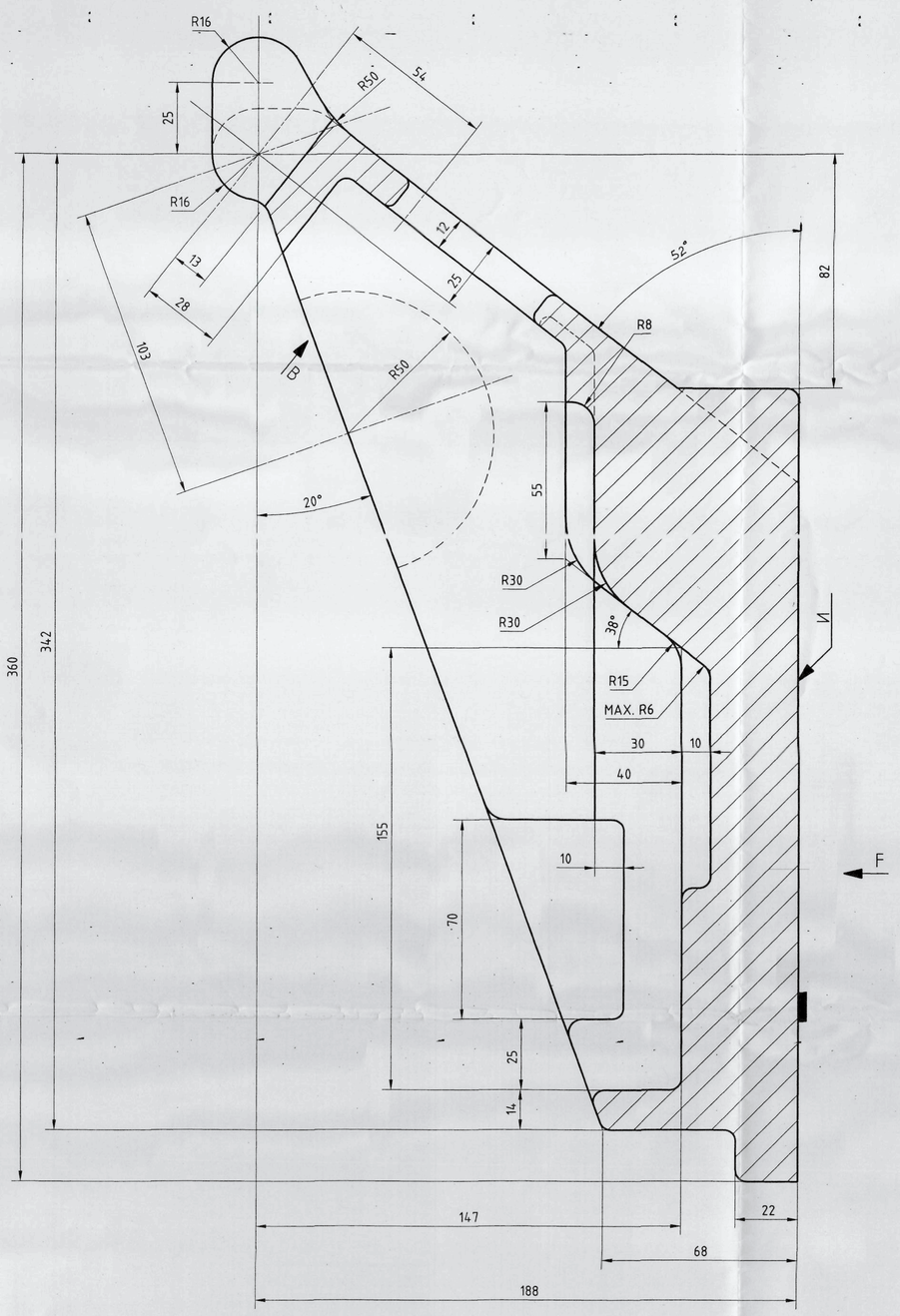
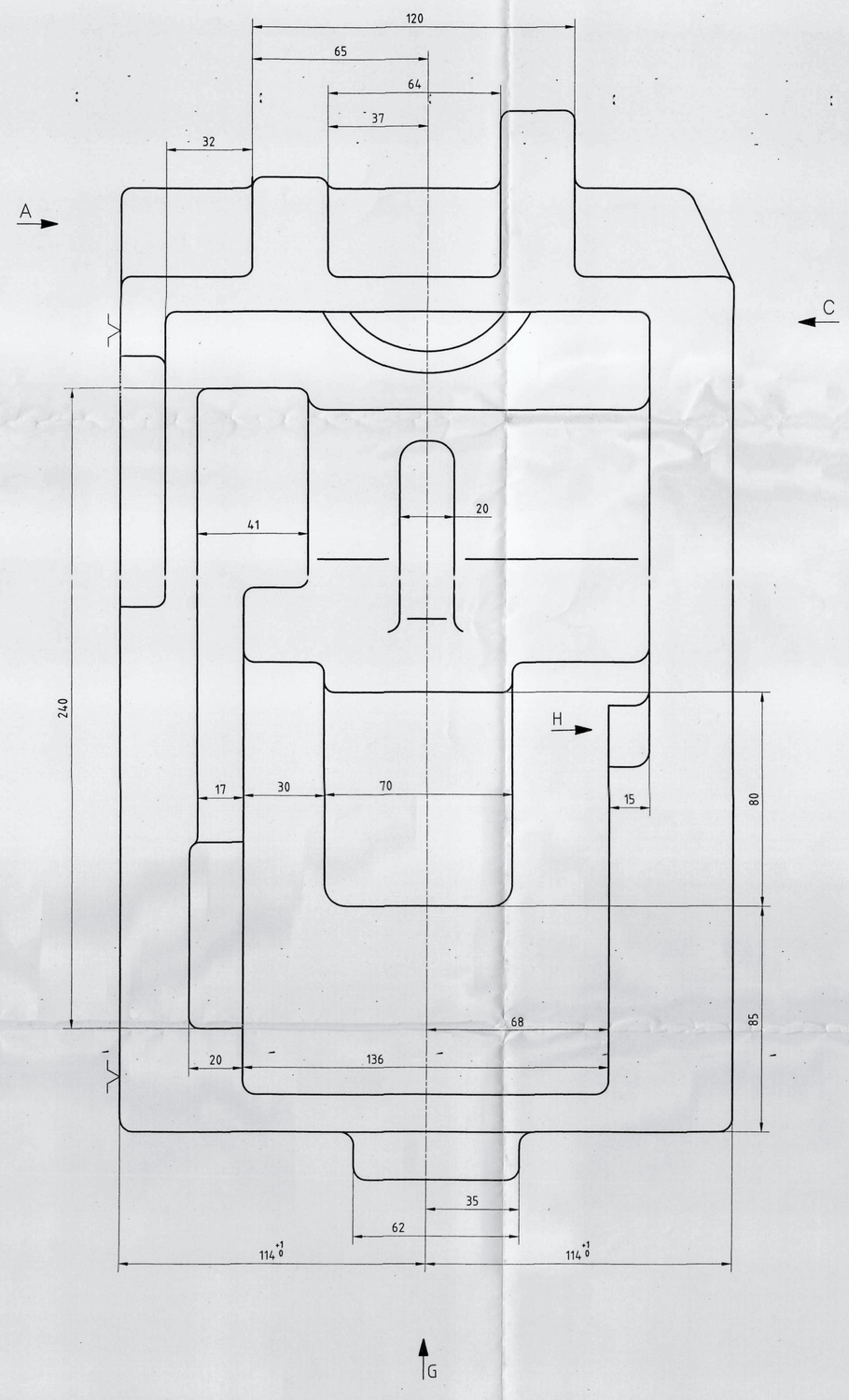
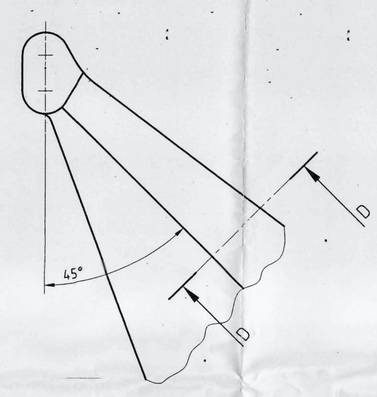
DRG. No. GCF TM-191(I)

DRAWING CONVENTIONS CONFORM TO SP:46-1988.
DIMNS. ARE IN mm. UNLESS OTHERWISE STATED.



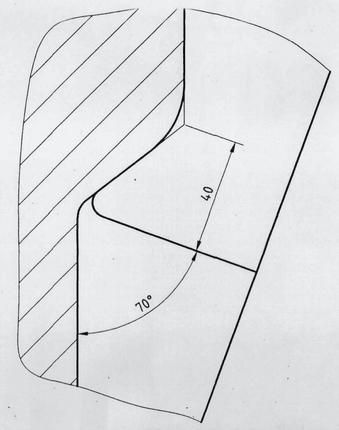


VIEW - C
SCALE : 1:2

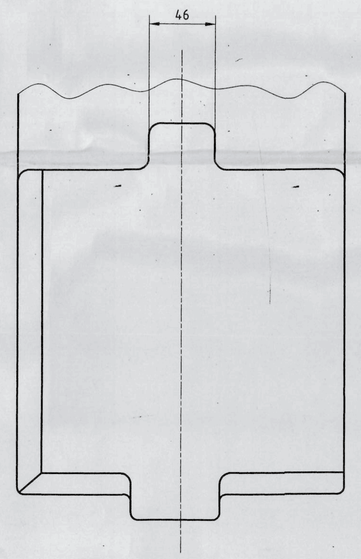


D-D
SCALE : 1:2

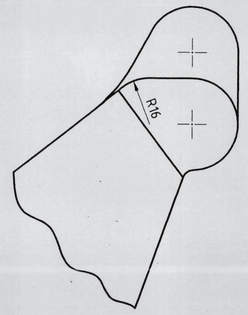
VIEW - H



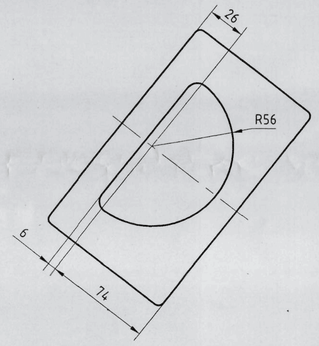
VIEW - F
SCALE 1:2



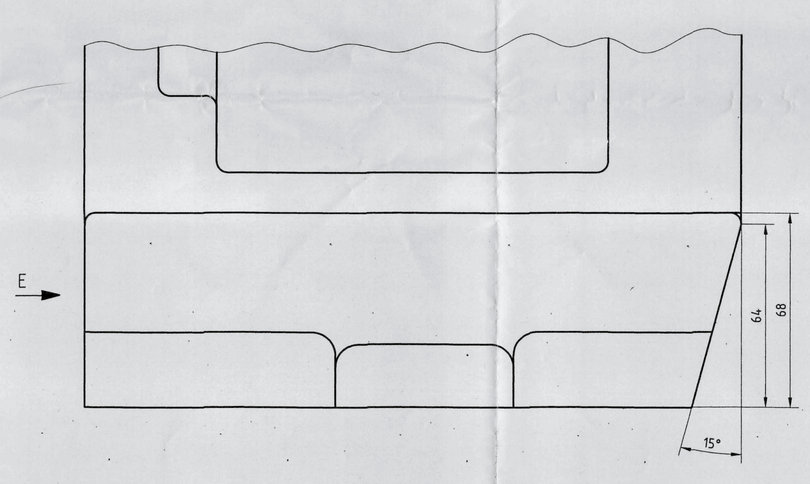
VIEW - A



VIEW - B
SCALE 1:2



VIEW - G



VIEW - E

TECHNICAL CONDITION

1. UNSPECIFIED CASTING RADII ARE NOT TO EXCEED 8 mm.
2. CASTING SIZES – ACCORDING TO ACCURACY CLASS III (DCT 2009-55.
3. CASTING DRAFT – 2° MAX.
4. MARKED ■ ARE LOCATIONS OF RISERS INSTALLATION.
5. RISER RESIDUE $^{+3}_{-1}$ mm.
6. MARKED ▽ ARE INITIAL MACHINING DATUM SURFACES.
7. OTHER REQUIREMENTS TO THE CASTING – ACCORDING TO TT 250.11.00001.
8. ON SURFACE И RIFFLE OF 3 mm. HIGH IS TOLERABLE.
9. (a) RADIOGRAPHIC TEST SHALL BE CARRIED OUT AS PER ASTM-E-192 WITH THE FOLLOWING ACCEPTANCE STD.
   LEVEL 5 FOR GAS HOLES AND FOREIGN MATERIAL
   LEVEL 3 FOR SHRINKAGE OF ALL TYPES. CRACKS HOT TEARS, COLD SHUTS ARE NOT ACCEPTABLE.
   (b) 100% OF THE ADVANCE SAMPLES SHALL BE SUBJECTED TO RADIOGRAPHIC TEST.
   (c) RADIOGRAPHIC TEST OF ADVANCE SAMPLE SHALL BE CARRIED OUT AND FORWARD THE PLATE ALONGWITH RADIOGRAPHIC TEST CERTIFICATE TO GCF, JABALPUR FOR SENTENCE AND APPROVAL OF THE MOULD.
   (d) IN CASE OF NON CONFORMANCE OF ANY CASTING OF FIRST LOT OF ADVANCE SAMPLES TO THE SPECIFIED ACCEPTANCE STANDARD, FRESH LOT OF ADVANCE SAMPLES SHALL BE MANUFACTURED AND SUBJECTED TO RADIOGRAPHIC EXAMINATION TILL THE ENTIRE LOT IS FOUND SATISFACTORY AND BULK PRODUCTION CLEARANCE IS GIVEN.
   (e) FOR BULK COMPONENT, 5% OF EACH CAST/HEAT SELECTED AT RANDOM SHOULD BE SUBJECTED TO RADIOGRAPHIC TEST. FAILURE OF ANY SAMPLE WOULD RENDER THE LOT UNACCEPTABLE.
   (f) ANY HEAT REJECTED IN RADIOGRAPHIC TEST MAY BE WEADED OUT BY 100% RADIOGRAPHY AT PRODUCERS' COST IF HE SO DESIRES.
   (g) OTHER TECHNICAL DETAILS AS PER CQA(MET), ICHAPUR INSTRUCTION No. MQA-1/QA-1/12.

INDIGS. MATL :-

STEEL CASTING IS:1030-98 Gr. 280-520 W

OR

BS:3100-1991 Gr. A2.

OR

IS:10343-1999 Gr. 2A

OR

BS:3146-PT.-I-74 TYPE CLA1, Gr. 'B'.

NOTE:-
1. THIS DOCUMENT IS THE PROPERTY OF THE GOVT. OF INDIA M. OF D. AND IS ISSUED FOR THE PURPOSE OF DEVELOPING/MANUFACTRING STORES REQUIRED FOR DEFENCE USE.
2. IT MUST NOT BE REPRODUCED/DISCLOSED TO ANY THIRD PARTY OR USED FOR ANY CIVIL PURPOSE.
3. IT MUST BE RTURNED TO THE ISSUING AUTHORITY WHEN THE PURPOSE OF ITS ISSUE HAS BEEN SERVED.
4. DRAWINGS ARE SUBJECTED TO CHANGE. 3 PILOT SAMPLES ARE REQUIRED TO BE SUBMITTED TO INSPECTION OFFICER FOR TRIAL MACHINING FITMENT. APPROVAL FOR BULK MANUFACTURE WILL BE ACCORDED ON SATISFACTORY MACHINING TRIAL AND ACCEPTANCE OF FINISHED SAMPLE.

INDEX	CERTIFICATION No. OF VETTING CELL	DATE
-	GCF/SC/281/PP01VETT/07	17.10.20
	GCF/SC/281/DRG/VETT/UC	19.12.18
(I)	GCF/SC/281/DRG/VETT/PO/20	04.05.17
(H)	GCF/SC/281/DRG/VETT/PO/UC	15.03.16

P.T.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	SIZE	REMARKS
GEN. TOL. NOT SPECIFIED							
LINEAR DIMENSIONS							
0.5 – 3 ±0.3							
3 – 30 ±0.5							
30 – 120 ±0.8							
120 – 315 ±1.2							
315 – 1000 ±1.8							
1000–2000 ±2.5							
ANGULAR DIMENSIONS							
0°– 30° ±0°30'							
30°– 50° ±0°20'							
50°– 80° ±0°15'							
80°– 180° ±0°10'							

INDEX	AMENDMENTS	SIGN	DATE
(I)	Revetted	sd.	05.5.17
(H)	OC No. 19458-W DT.24.012015 & New reg. prepared with dims. changed	sd.	07.4.17

~ UNMACHINED
▽ ROUGH
▽▽ SMOOTH
▽▽▽ FINISH

कवर
COVER
CASTING

GUN CARRIAGE FACTORY, JABALPUR

APPROVED
11/05/2017
DGM/GMS&TR

FOR Sr. GM G.C.Fy.

2017	NAME	DATE	APPROVED
DRN.		11.5.17	JMM/Shop
CKD.			
HOS/ODC		11.5.17	
SEC.	M/C		JMM/TR

SCALE NTS. | REF.DEM. L/No. M/GMS&TR/PROD/62 DT. 15.3.2017 | REF.DRG.No. 675-51-56

DRG. No. GCF TM-191(I)

SHEET NO. OF SHEETS