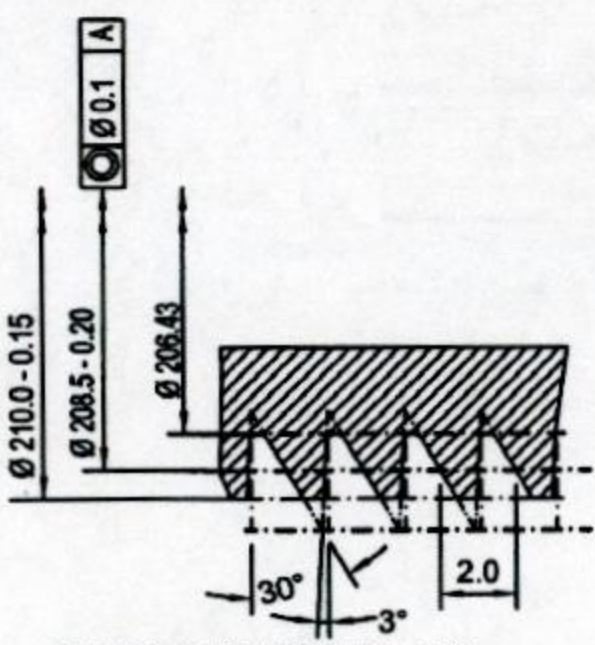
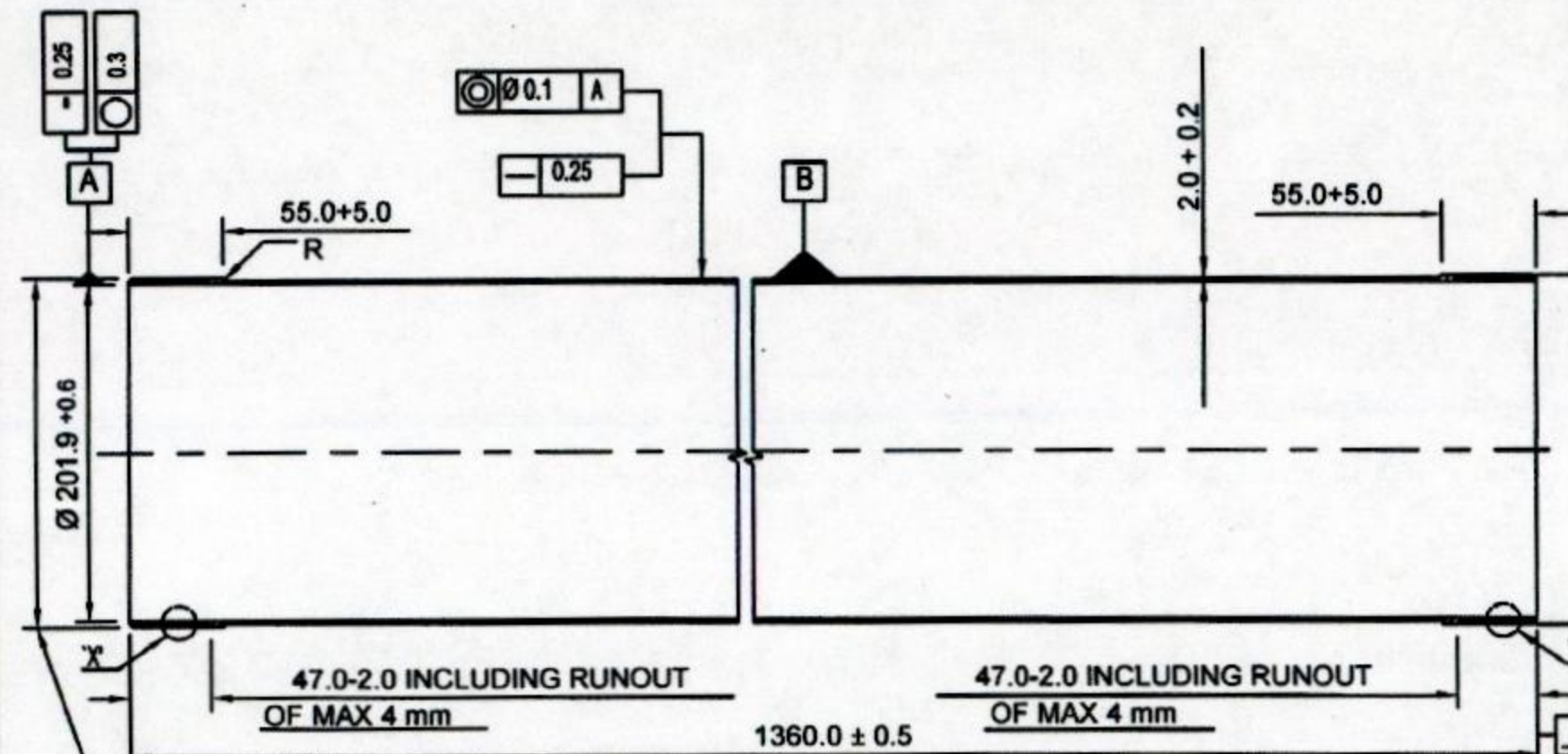


DRG No 8603 02 01 04 00 001 00DF

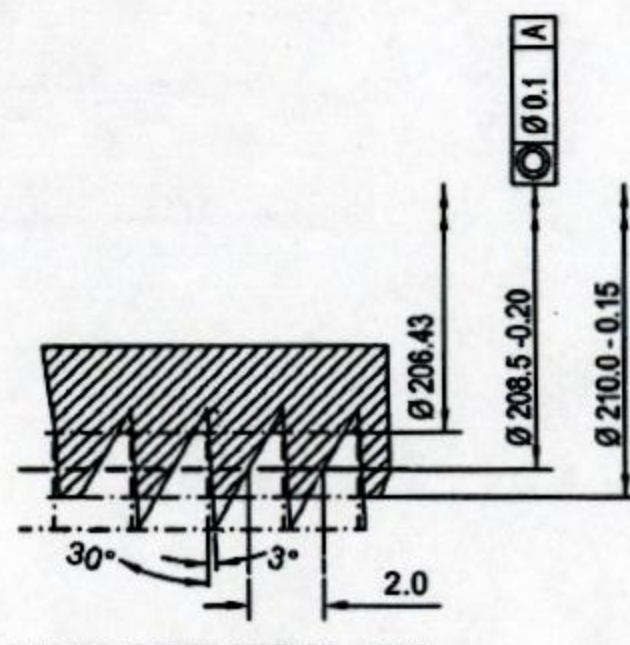
GEN TON : MEDIUM CLASS TO IS : 2102
 DRG CONVENTIONS CONFORM TO INDIAN STD. DIM IN mm UNLESS OTHERWISE STATED

- NOTES :
- ALL SHARP EDGES AND BURRS ARE TO BE REMOVED. EACH TUBE TO BE FREE FROM VISUAL DEFECTS.
 - TUBE FLOW FROMED FROM SAE 4130 ESR GRADE STEEL SHOULD HAVE THE FOLLOWING MECHANICAL PROPERTIES
 - (a) UTS = 120 kg/mm² (min) OR ITS EQUIVALENT IN MPa
 - (b) % ELONGATION = 6 (min) for 50 mm GAUGE LENGTH
 - (c) 0.2 % PROOF STRESS = 90 kg/mm² (min) OR ITS EQUIVALENT IN MPa
 - TUBE BEFORE PLATING IS TO BE HYDRAULICALLY TESTED TO WITHSTAND A MAX PRESSURE OF 15 MPa. RAISE THE PRESSURE IN STEPS OF 2.5 MPa AT 10 MPa KEEP IT FOR 30 secs AT 12.5 MPa FOR 30 secs AT 15 MPa FOR 1 MINUTE
 - SINCE THE MOTOR TUBE IS ZINC PLATED AS PER IS:1573-1986, IT SHOULD BE SUBJECTED TO STRESS & HYDROGEN EMBRITTEMENT RELIEF PROCESS, AS LAID DOWN IN IS:1573-1986. BAKING FOR 2hrs TO BE CARRIED AFTER PASSIVATION. NC LAQUER COATING SHOULD BE DONE AFTER PASSIVATION.
 - PREFORM DIMENSION BEFORE READY FOR FIRST PASS FLOW FORMING OPERATION SHOULD BE , OD 239 +0.05 mm , ID 201.9+0.03mm & L 270 ± 0.5mm. PREFORM THICKNESS TO BE MEASURED BEFORE FIRST PASS FLOW FORMING , AS A PART OF STAGE INSPECTION.
 - DIMNS CHECKING AND THREAD GAUGE CHECKING IS TO BE CARRIED OUT BEFORE AND AFTER APPLYING PROTECTIVE COATING.



ENLARGED VIEW OF THDS. AT 'X'
 SAW TOOTH THDS. TO IS:4696

SCALE 10:1



ENLARGED VIEW OF THDS. AT 'Y'
 SAW TOOTH THDS. TO IS:4696

SCALE 10:1

5	16 /05/11	CRC Meeting	Tolerance on saw tooth changed from 0.15 mm to 0.20 mm Measurement of preform thickness added.	EF-1,4 & AB-5 C-6,8	
4	03/11/08	PRC-4, Meeting	In protective finish Type 'C' Iridescent added.	E-6,8	
3	06/02/08	PRC-4, Meeting No-47	Stress & Hydrogen relief added & permanent set test deleted	C-6,7	
2	20/08/05	PRC-4, Review meeting No-26, dt:20/08/05	Step length 55.0±5.0 was 55.0 mm	B-1&B-5	
1	01/11/99	PINAKA/RKT/PRP/ DRG.AMEND	Proof Stress - 90 Kg/mm ² was 950 MPa UTS-120 Kg/mm ² was 1200 MPa	AB-6,7	
	March 99	ARKT/17	Drg. Reformed from Old Drg. No. ARDE/SK/3284, DET-10,2 Sheets, Sheet No-1		
R No	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD GO SIGN
DRN P K Singh		CHD <i>Blawah</i>	MATERIAL : SEE NOTE 2		
APPD DATE 30/12		SRS FOR DIRECTOR	PROTECTIVE FINISH : ZINC PLATED TO IS:1573 : 1986, Fe/Zn 12.5 Type 'C', Iridescent		
SEALED DATE					
SCALE 1:2	EST MASS 15.5 ± 0.75 Kg.		TITLE MOTOR TUBE		
DESIGN AUTHORITY ARDE					
DRG No	8603	02	01	04	00
	IC	SS	S	AA	A
PART No		DS CAT No			AHSP

Appx-B12