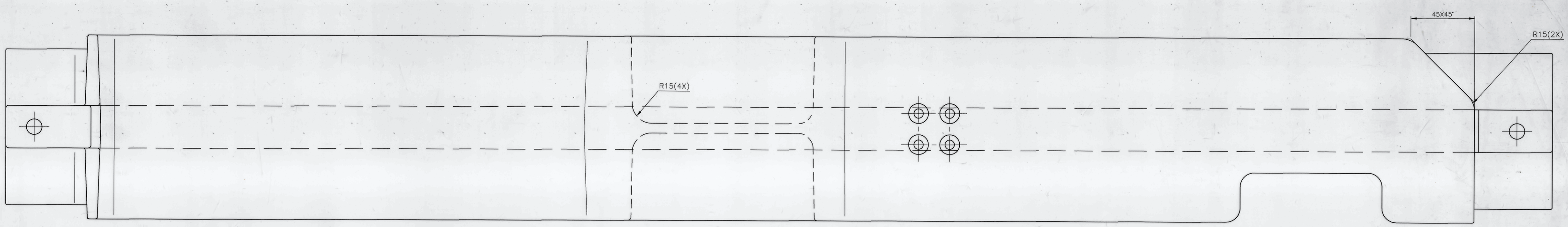
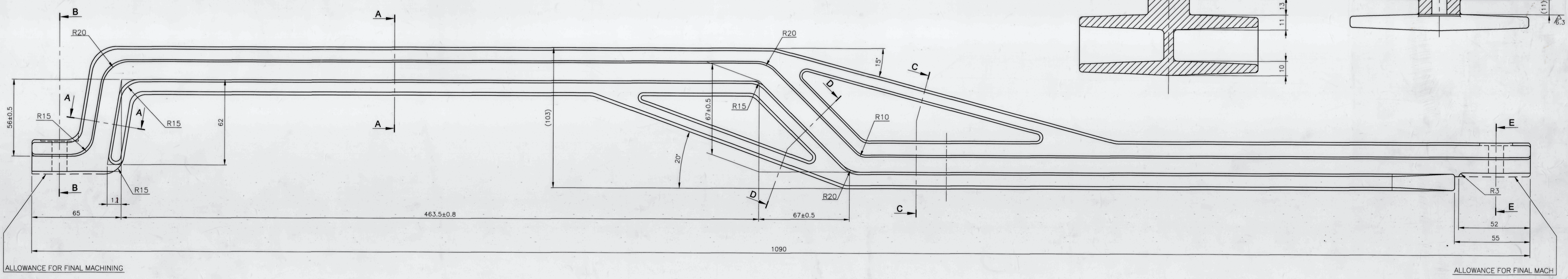
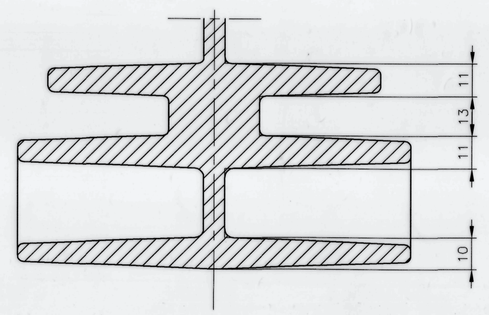
DRG. No. 2 028 682

ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED

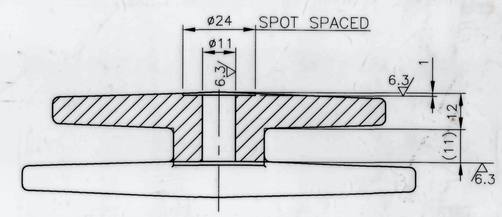


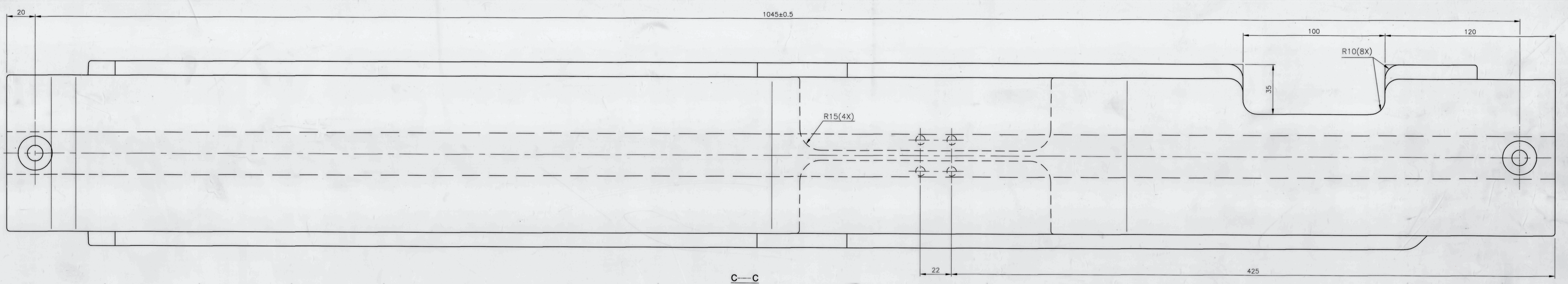


D---D

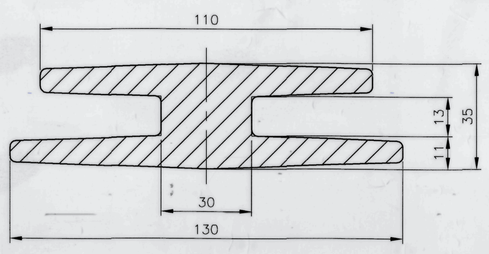


E---E

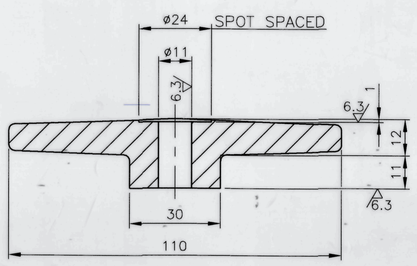




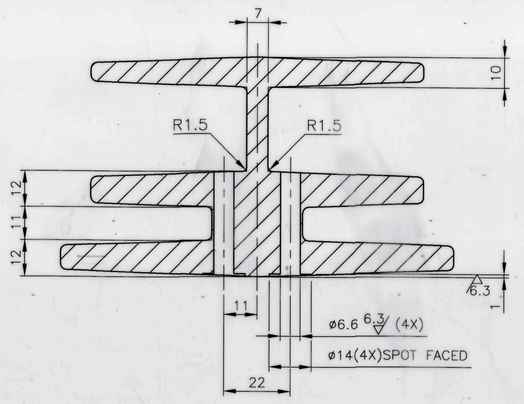
A---A



B---B



C---C



CASTRADIUS 3 AND CASTING TOLERANCE
ACC.TO SS 722 GTA16 APPLIES
UNLESS OTHERWISE STATED.
ANGLE OF CLEARANCE 2°

INSPECTION AND DELIVERY REGULATION
A 2014,COMMERCIAL QUALITY.
TO X-RAY INSPECTION OF QUTTURN
SAMPLES APPLIES ASTM DESIGN.E155;
GASHOLES AND AIRHOLES(ROUND,ELONGATED)
CLASS 2
SURFACE SHRINKAGES,HOLES CLASS 3
SPONGE CLASS 4
FOREIGN MATERIAL IS NOT ALLOWED.
CRACKS IS NOT ALLOWED.

IT IS'NT NECESSARY TO CARRY OUT X-RAY TEST AT DELIVERY CONTROL

SURFACE TREATED Y3-13,Y4-27-10-600

P.No.	NOMENCLATURE	No. OFF	MATERIAL	HARDNESS	STANDARD	REMARKS
GEN. TOL. NOT SPECIFIED						
LINEAR DIMENSIONS: 0-6 ±0.1; 6-30 ±0.2; 30-120 ±0.3; 120-315 ±0.5; 315-1000 ±0.8; 1000-2000 ±1.2					FOR-Sr. GM G.C.Fy.	
					2016	NAME / DATE
					DRN.	RAM 11/04
					CKD.	J.K.KOSTA 04/07
ANGULAR DIMENSIONS: 0-10° ±1°; 10-50° ±30'; 50-120° ±20'; 120° ±10'						
~ UNMACHINED; ▽ ROUGH; ▽▽ SMOOTH; ▽▽▽ FINISH	INDEX	AMENDMENTS	SIGN	DATE	APPROVED	

BEAM

MATERIAL: EN 1706-1998 DESIGN EN-AC 42000-S-T6

SCALE — | REF.DRG.NO.

ASSY/SUB ASSY NO. 1155267

GUN CARRIAGE FACTORY, JABALPUR

DRG. No. 2 028 682

SHEET NO. OF SHEETS