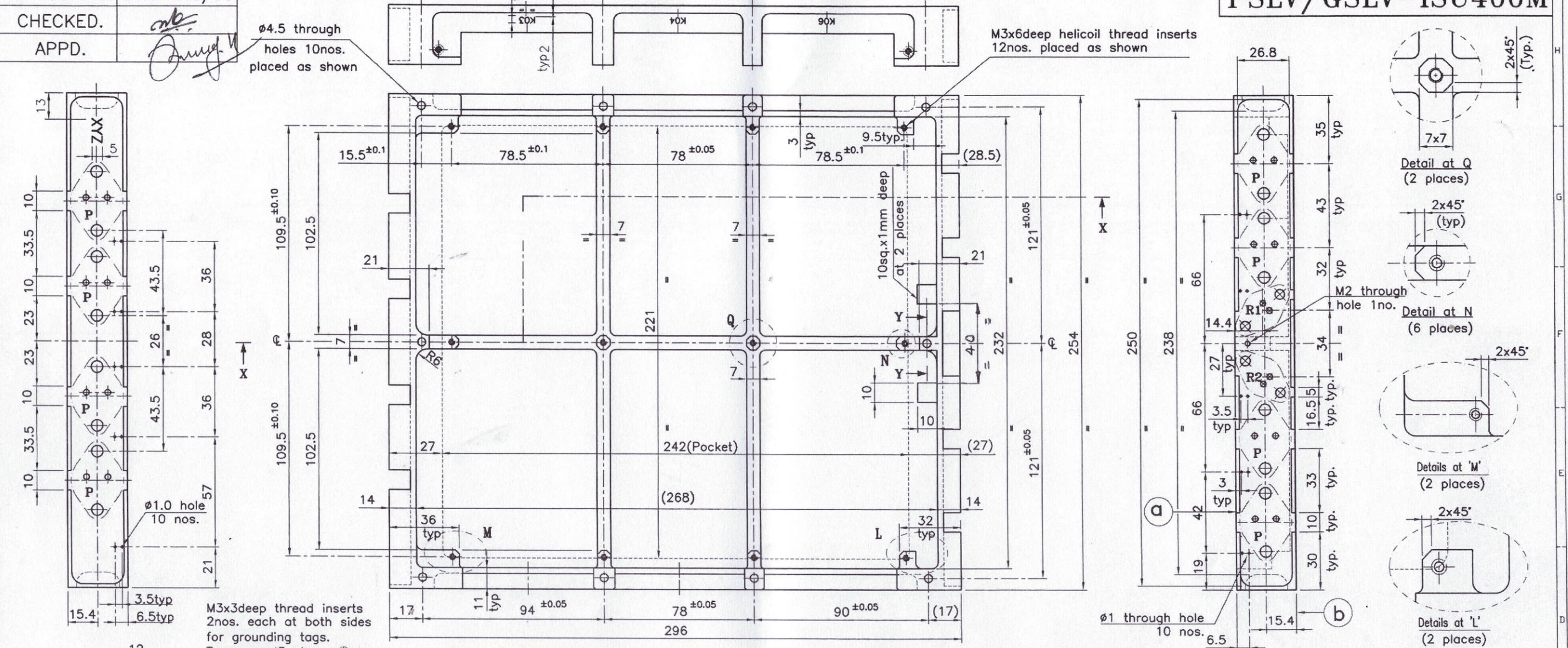


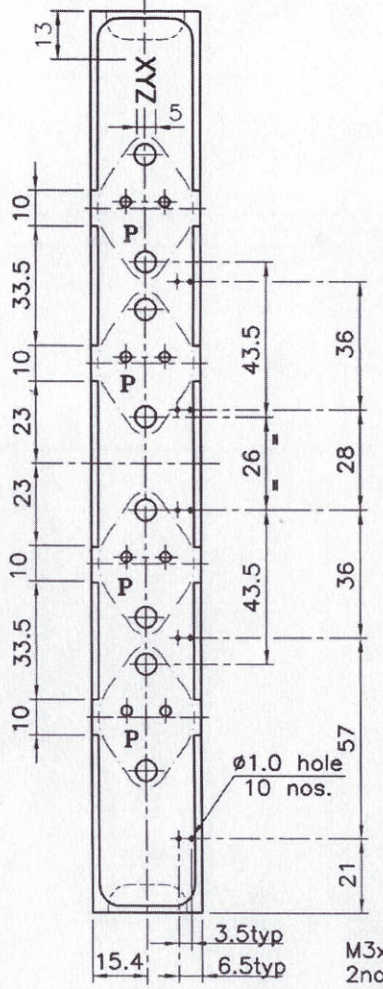
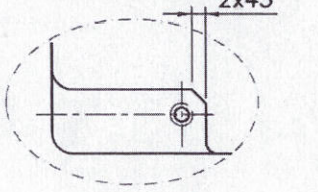
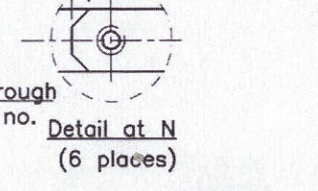
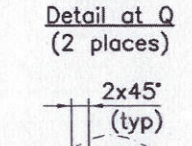
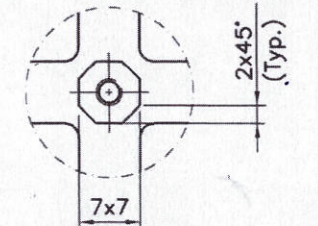
M-CCB NO. 54.6-148/06  
 CHECKED. APPD.  
*Signature*

PSLV/GSLV-ISU400M



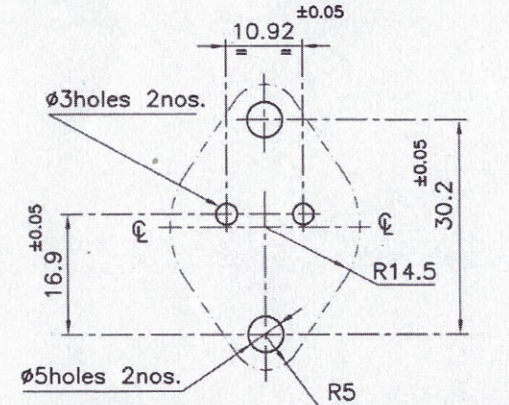
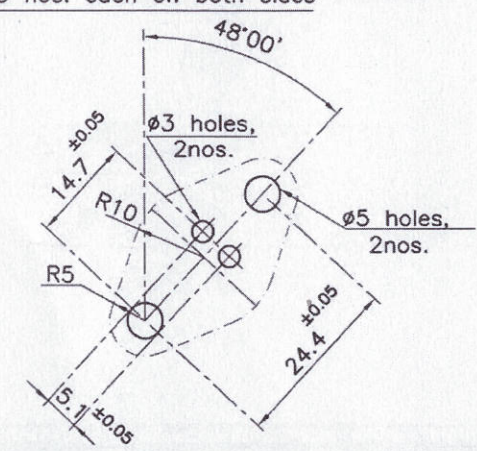
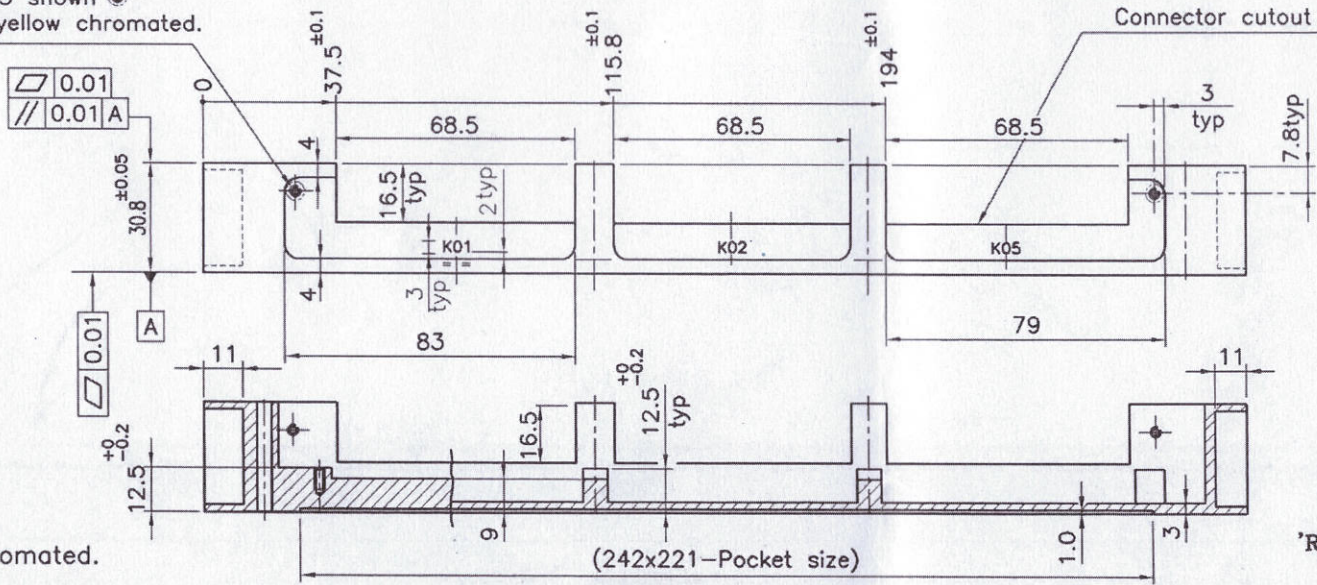
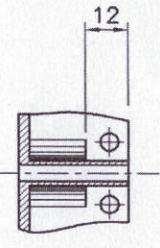
$\phi 4.5$  through holes 10nos. placed as shown

M3x6 deep helicoil thread inserts 12nos. placed as shown



M3x3 deep thread inserts 2nos. each at both sides for grounding tags. Tag area  $\phi 5$  shown should be yellow chromated.

Connector cutout 3 nos. each on both sides



- Notes:
- All radii 4mm unless otherwise specified.
  - Chamfer all corners to 0.2x45°
  - General surface finish 1.0 $\mu$
  - Surface treatment  
 (a), (b), (P) & (R) are Yellow dichromated.  
 Other areas are black chromating.
  - Connector name K01, K02, K03, K04, K05 & K06 and axis identification of module XYZ should be engraved and filled with white colour paint

DO NOT SCALE THE DRAWING ASK IF IN DOUBT		DEVIATION FOR NON-TOLERANCED DIMENSIONS (IS:2102 - MEDIUM GRADE)	
DIAMETER & LENGTH UPTO & INCL. 6 $\pm 0.1$	0 - 30 $\pm 0.2$	LENGTH IN mm OF SHORTER SIDE OF ANGLE UPTO & INCL.	1 - 6 $\pm 1.0$
UNLESS OTHERWISE SHOWN ALL DIMENSIONS ARE IN MILLIMETERS REMOVE SHARP EDGES AND BURRS CHAMFER 1 mm X 45°	30 - 120 $\pm 0.3$	6 - 30 $\pm 0.3$	6 - 30 $\pm 0.3$
MACHINING FINISH IN MICRONS	120 - 315 $\pm 0.5$	315 - 1000 $\pm 0.8$	30 - 120 $\pm 0.3$
$\nabla$ 8 - 25 $\nabla$ 1.6 - 8	1000 - 2000 $\pm 1.2$	2000 - 4000 $\pm 1.6$	120 - 400 $\pm 0.3$
$\nabla$ 0.025-1.6 $\nabla$ <0.025	4000 & ABOVE $\pm 2.0$		

REV.NO.	ZONE	DESCRIPTION	SIGN	DATE
04	B10,B8	Drawing Modified as per CCB-M/54.6/12/17 dt.11.12.17	Giri	17.01.18
03		Drawing Modified as per CCB-M/39.2/6/16 dt.13.06.16	Giri	30.08.16
02	C9	Drawing Modified as per CCB-M/3.4/0.5.09 dt.11.05.09	Sujith	11.05.09
01	F2,E11	Drawing Modified as per CCB-M/2.4/11/08 dt.21.11.08	Jana	21.11.08

DRN.	Beevi	21.09	TITLE	MATERIAL
DGN. <td>Team</td> <td></td> <td><b>HOUSING</b> For Electronics Module Assy.(single unit) ISU400M</td> <td>AZ 31B</td>	Team		<b>HOUSING</b> For Electronics Module Assy.(single unit) ISU400M	AZ 31B
DRG.			GOVERNMENT OF INDIA INDIAN SPACE RESEARCH ORGANISATION	Project No.OFF WT.Kg
DGN.			ISRO INERTIAL SYSTEMS UNIT	PSLV/GSLV 1
QA			TRIVANDRUM	1
APPD.			MDD DIVISION	REV. No. 04
2006			DRG. NO. 8204 03 01A 01	SCALE 1 : 1 SHEET OF A1
			File No.ISU301A01	CCB. no.148/06