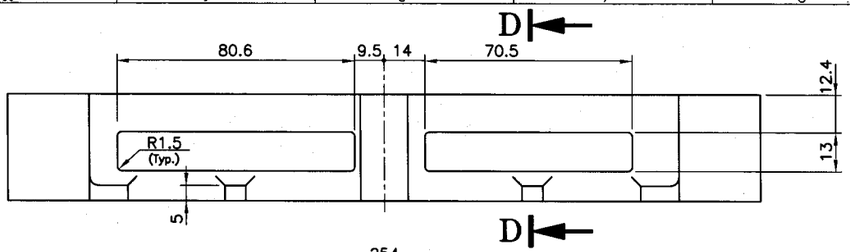
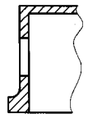
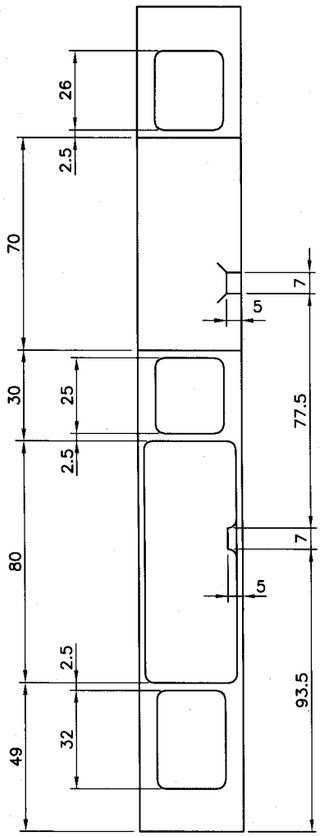
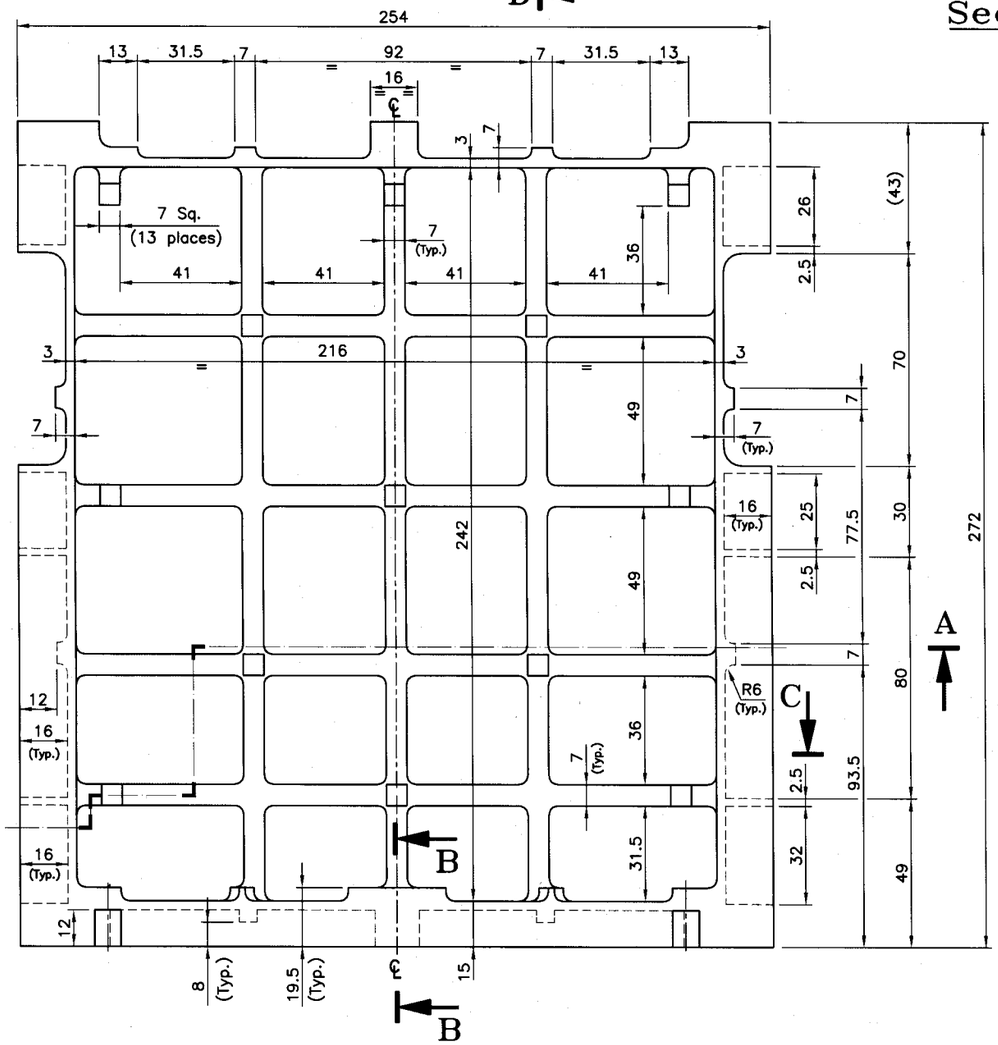
ISUPM312
M/CCB No. : 100.2/632/07
Checked :
Approved :

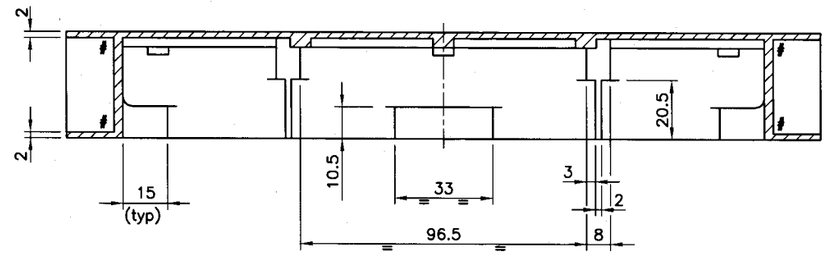




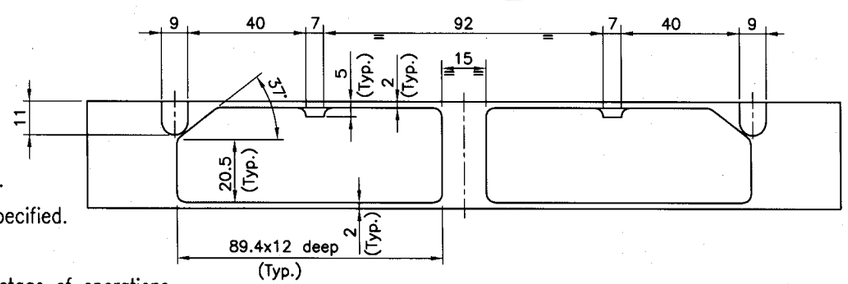
Section–DD

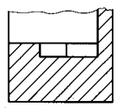




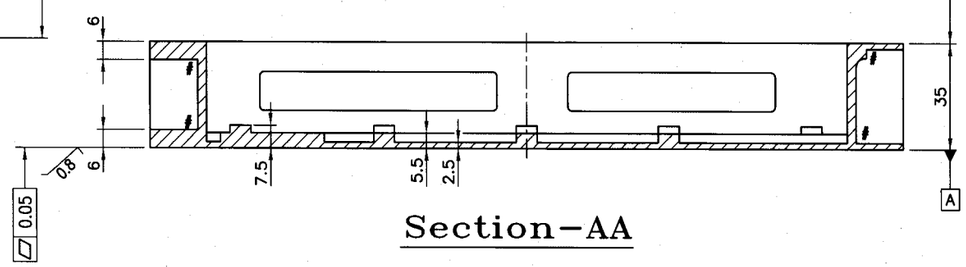


Section–CC





Section–BB



Section–AA

Notes:–

1. Remove all sharp corners and burrs.
2. All radius 3 mm unless otherwise specified.
3. # Maintain sharp corner
4. See Drg. No.8204 82 01 01 for next stage of operations.

DO NOT SCALE THE DRAWING ASK IF IN DOUBT
UNLESS OTHERWISE SHOWN ALL DIMENSIONS ARE IN MILLIMETERS REMOVE SHARP EDGES AND BURRS CHAMFER 1 mm X 45° MACHINING FINISH IN MICRONS
▽ 12.5–50 ▽▽ 1.6–6.3 ▽▽▽ 0.2–0.8 ▽▽▽▽ 0.025–0.1

DEVIATION FOR NON–TOLERANCED DIMENSIONS (IS:2102– MEDIUM GRADE)

DIAMETER & LENGTH			DEVIATION
UPTO & INCL.	6		± 0.1
6	– 30		± 0.2
30	– 120		± 0.3
120	– 315		± 0.5
315	– 1000		± 0.8
1000	– 2000		± 1.2
2000	– 4000		± 2.0
4000 & ABOVE			± 3.0

LENGTH IN mm OF SHORTER SIDE OF ANGLE UPTO & INCL.	DEVIATION
1 – 6	± 1° 00'
6 – 30	± 0° 30'
30 – 120	± 0° 20'
120 – 400	± 0° 10'

REV.NO.	ZONE	DESCRIPTION	SIGN	DATE	ASSY. DRG.
02	–	Drg. modified as per CCB–M100.2/03/23	Jishpaul	17.03.23	
01	–	Sharp corners in transistor mounting zone CCB–M–41.4/09/16 dt. 07/10/16	JISHPAUL	31.10.16	

REVISIONS

DRN.	Mani	15.7	
DGN.		22.03.23	
CHD. DRG.		23-03-23	
CHD. DGN.		24/03/23	
CHD. QA		18/3/23	
APPD.		24/3/23	
2004	SIGN	DATE	

TITLE: HOUSING–Milling

For ISUPM312–Single Unit

MATERIAL: Mg.alloy

GOVERNMENT OF INDIA
INDIAN SPACE RESEARCH ORGANISATION
ISRO INERTIAL SYSTEMS UNIT
THIRUVANANTHAPURAM–13

Project: GSLV/PSLV

No.OFF: 01

Mass.Kg:

MECHANICAL DESIGN MDD DIVISION

DRG. NO. 8204 82 01 01M

REV. No. 02

SCALE

SHEET OF

A1

File no. 8204820101M

मूल/ORIGINAL