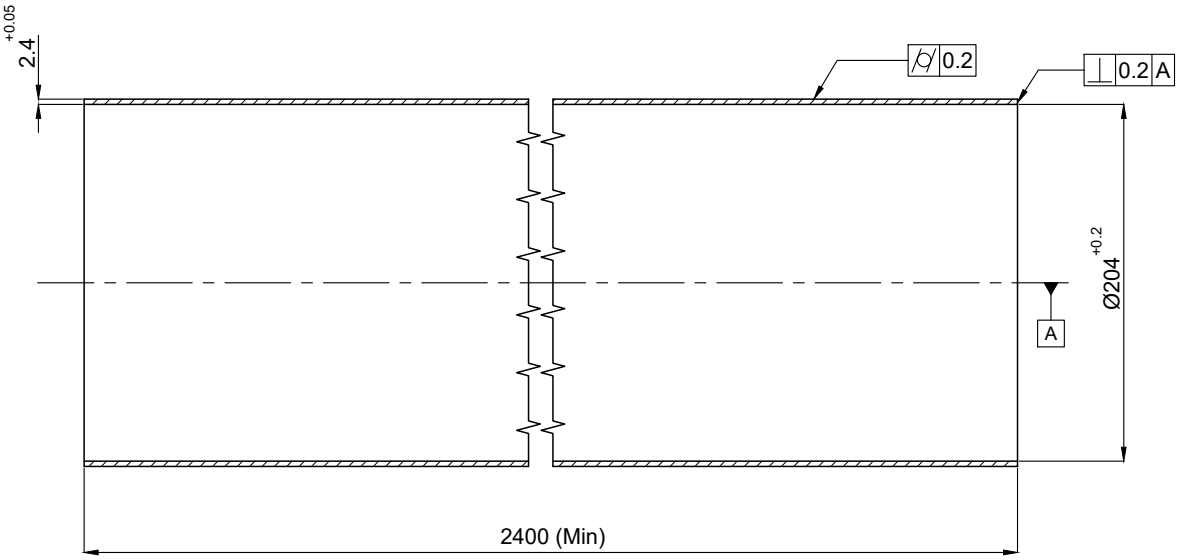
1	2	3	4
MACHINING FINISH MICRONS	▽▽▽▽ < 0.025	▽▽▽ 0.025 – 1.6	▽▽ 1.6 – 8	▽ 8 – 25	S > 25

Do not scale the drawing, Ask if in doubt, All dimensions are in MM, Remove sharp edges & burrs, Chamfer 1x45°

MACHINING DEVIATION TO ISI : 2102 (MEDIUM GRADE) UNLESS SPECIFIED OTHERWISE												
LENGTH OR DIA	UP TO 6	6 30	30 120	120 315	315 1000	1000 2000	2000 4000	4000 ABOVE	LENGTH IN mm OF SHORTER SIDE OF ANGLE	UP TO >6	6–30	30–120	120–400
	± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2.0	± 3.0		± 1°	± 30''	± 20''	± 10''



Note:

1. All dimensions shall be demonstrated on first off flow formed shell after heat treatment and shot blasting
2. Ovality limited to 0.50, Same shall be measured 100mm interval

REVISIONS			
ZONE	REVN No.	SIGN	DATE
	A		

MATL. 15CDV6	TITLE Flow Formed Shell for SP Motor Hardware Type-I	No.OFF	WT kg.
DGN.			
DRN. A 07.06.2024	GOVERNMENT OF INDIA INDIAN SPACE RESEARCH ORGANISATION VIKRAM SARABHAI SPACE CENTRE TRIVANDRUM	GROUP / PROJECT RMFD/EFA	
CHD.			
APPD. A 07.06.2024	DRG. No. RMFD/FF/SPM/SHELL/TYP-I R0		
SIGN. DATE			
A4	SCALE : NTS	SHEET 01 OF 01	