

		MACHINING DEVIATION TO ISI : 2102 (MEDIUM GRADE) UNLESS SPECIFIED OTHERWISE																																																																													
LENGTH OR D/A	UP TO	315		4000		315		4000																																																																							
		120	315	2000	4000	1000	2000	3000	4000																																																																						
		± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2.0	± 3.0																																																																						
		>6	6-30	30-120	120-400																																																																										
		± 10"	± 20"	± 30"	± 40"																																																																										
<table border="1"> <tr> <td>1</td> <td>2</td> <td>3</td> <td>4</td> </tr> <tr> <td>MACHINING FINISH MICRONS</td> <td>▽▽▽ < 0.025</td> <td>▽▽ 0.025 - 16</td> <td>▽ 16 - 8</td> <td>∇ 8 - 25</td> <td>∩ > 25</td> </tr> </table> <p>Do not scale the drawing, Ask if in doubt, All dimensions are in MM, Remove sharp edges & burrs, Chamfer $\times 45^\circ$</p>										1	2	3	4	MACHINING FINISH MICRONS	▽▽▽ < 0.025	▽▽ 0.025 - 16	▽ 16 - 8	∇ 8 - 25	∩ > 25																																																												
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<p>Note:</p> <ol style="list-style-type: none"> All dimensions shall be demonstrated on first off flow formed shell after heat treatment and shot blasting Ovality limited to 0.50, Same shall be measured 100mm interval 																																																																															
<table border="1"> <tr> <td colspan="2">MATL.</td> <td colspan="2">15CDV6</td> <td colspan="2">TITLE</td> <td colspan="2">Flow Formed Shell for SP Motor Hardware Type-II</td> <td colspan="1">No.OFF</td> <td colspan="1">WT kg.</td> </tr> <tr> <td colspan="2">DGN.</td> <td colspan="2"></td> <td colspan="2">GOVERNMENT OF INDIA</td> <td colspan="4">GROUP / PROJECT</td> </tr> <tr> <td colspan="2">DRN.</td> <td colspan="2">07.06.2024</td> <td colspan="2">INDIAN SPACE RESEARCH ORGANISATION</td> <td colspan="4">RMFD/EFA</td> </tr> <tr> <td colspan="2">CHD.</td> <td colspan="2"></td> <td colspan="2">VIKRAM SARABHAI SPACE CENTRE</td> <td colspan="4">TRIVANDRUM</td> </tr> <tr> <td colspan="2">APPD.</td> <td colspan="2">07.06.2024</td> <td colspan="2">DRG. No.</td> <td colspan="4">RMFD/FF/SPM/SHELL/TYP-II R0</td> </tr> <tr> <td colspan="2">SIGN.</td> <td colspan="2">DATE</td> <td colspan="2">SCALE : NTS</td> <td colspan="4">SHEET 01 OF 01</td> </tr> <tr> <td colspan="2">REV. No.</td> <td colspan="2">A4</td> <td colspan="2"></td> <td colspan="4"></td> </tr> </table>										MATL.		15CDV6		TITLE		Flow Formed Shell for SP Motor Hardware Type-II		No.OFF	WT kg.	DGN.				GOVERNMENT OF INDIA		GROUP / PROJECT				DRN.		07.06.2024		INDIAN SPACE RESEARCH ORGANISATION		RMFD/EFA				CHD.				VIKRAM SARABHAI SPACE CENTRE		TRIVANDRUM				APPD.		07.06.2024		DRG. No.		RMFD/FF/SPM/SHELL/TYP-II R0				SIGN.		DATE		SCALE : NTS		SHEET 01 OF 01				REV. No.		A4							
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