



SRQA LPSC		CC RELEASE	
CHD.	<i>[Signature]</i> 23/8/23	CHD.	<i>[Signature]</i>
APPD.	<i>[Signature]</i> 23/8/23	APPD.	<i>[Signature]</i> 23/8/23

**MECHANICAL PROPERTIES**

UTS	: ≥ 895N/mm <sup>2</sup>
0.2% YIELD STRESS	: ≥ 825N/mm <sup>2</sup>
% ELONGATION	: ≥ 10% ON L=5d

NO.OF ASSY.	QTY.	NEXT ASSEMBLY

02	195/PS4 Dt: 30.03.2021
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<b>MACHINING FINISH IN MICRONS</b>	DO NOT SCALE THE DRAWING ASK IF IN DOUBT. UNLESS OTHERWISE SHOWN ALL DIMENSIONS ARE IN mm.
~ - >25 ▽ - 25-8 ▽▽ - 8-1.6 ▽▽▽ - 1.6-0.025 ▽▽▽▽ - <0.025	
<b>IS : 2102 MEDIUM GRADE</b>	Concentricity
DIA & LENGTH UP TO & INCL.   LENGTH IN mm SHORTER SIDE OF ANGLE UP TO & INCL.	Perpendicularity
6-30 ±0.1 30-120 ±0.2 120-315 ±0.3 315-1000 ±0.5 1000-2000 ±1.2 2000-4000 ±2.0 4000&ABOVE ±3.0	Angularity
	Parallelism

<b>MATERIAL</b> Ti6Al4V (ANNEALED) Mechanical properties	<b>SURFACE TREATMENT</b>
General tolerance <b>IS 2102 MEDIUM GRADE &amp; CLASS 'K'</b> Thread tolerance	<b>SURFACE FINISH</b> 12.5/√
Thread chamfer & under cut.	<b>MARKING IDFN. NO.</b> <b>BY PUNCHING</b>
Radii not specified	
Chamfers not specified	

<b>QUANTITY</b> 2 Nos.	<b>MASS</b> 45 Kg
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<b>DGN.</b> <i>[Signature]</i> 23.8.23	<b>GOVERNMENT OF INDIA</b>
<b>D.CHD.</b> <i>[Signature]</i> 23/8/23	<b>INDIAN SPACE RESEARCH ORGANISATION</b>
<b>DRN.</b> ABIN.R 23.08.23	<b>LIQUID PROPULSION SYSTEMS CENTRE</b>
<b>CHD.</b> URS 8/2023	VALIAMALA TRIVANDRUM-695547
<b>APPD.</b> <i>[Signature]</i> 8/23	
<b>SIGN.</b> <i>[Signature]</i>	
<b>DATE</b>	

<b>TITLE</b> Ti6Al4V FORGING FOR Ø400 GAS BOTTLE	<b>DRG.No.</b> PU410-3111 0021
<b>SCALE</b> 1 : 2	<b>SHEET 1 OF 1</b>

<b>INDEX</b>	<b>MODIFICATION ORDER No. &amp; DATE</b>
<b>PROJECT</b> ESES/PS4	
<b>REV NO.</b>	<b>02</b>
<b>FORMAT</b>	<b>A3</b>

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