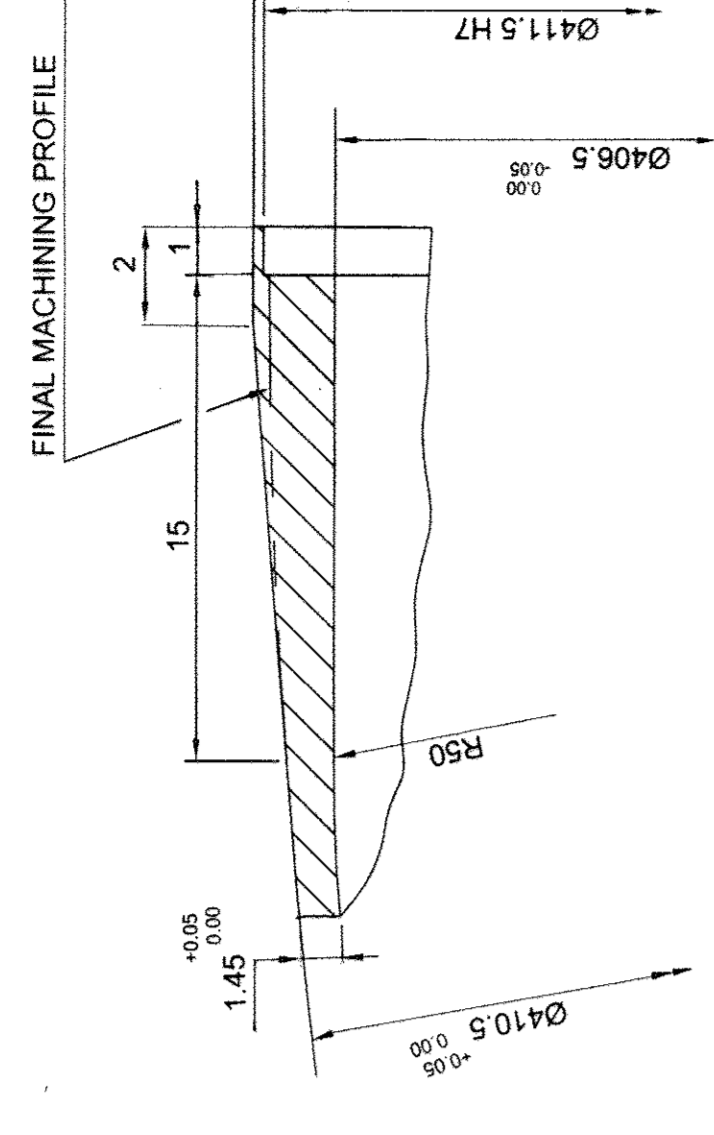
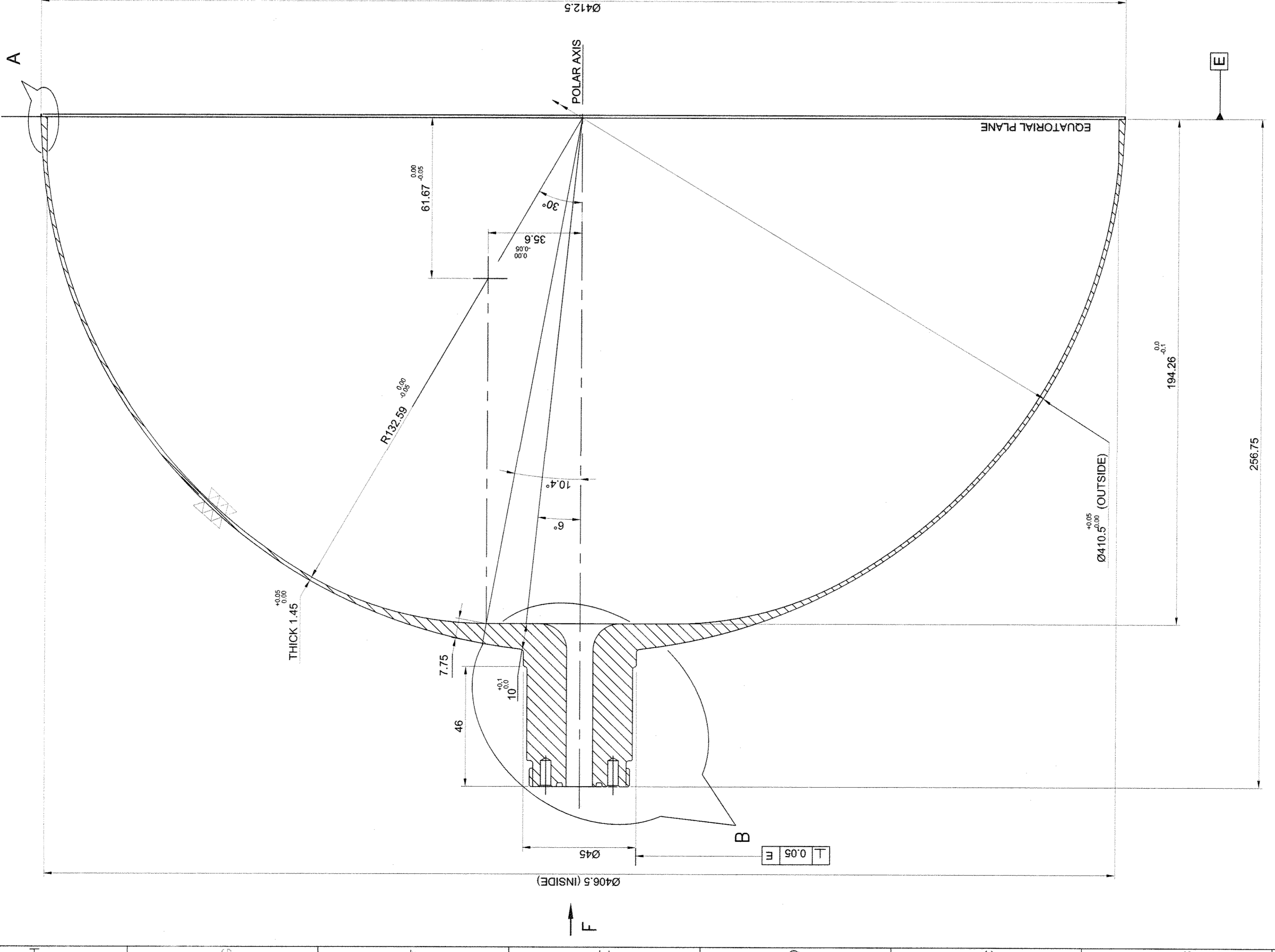
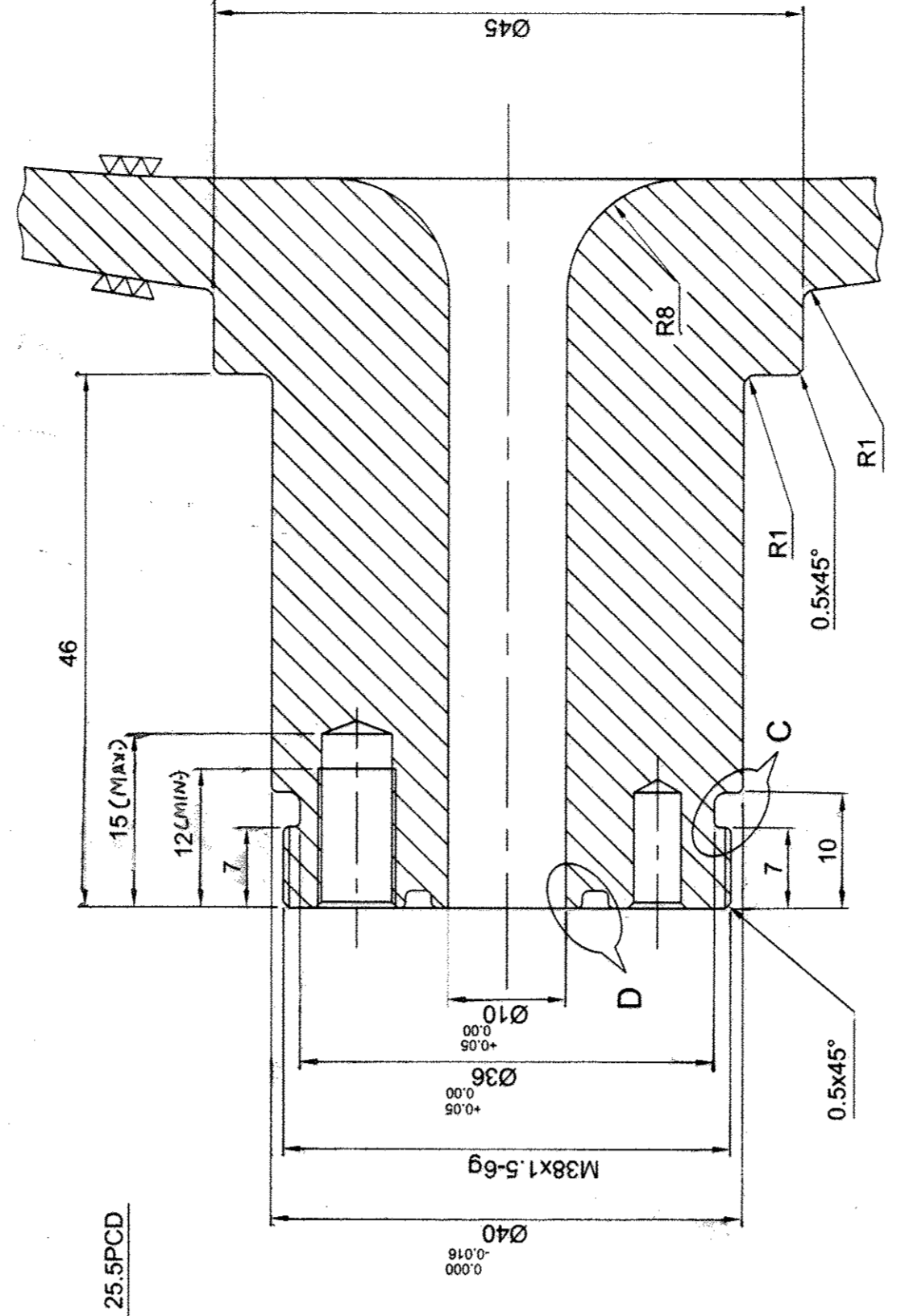


LINER THICKNESS
FROM 30° TO 10.4°
TOLERANCE ON THICKNESS 0.00

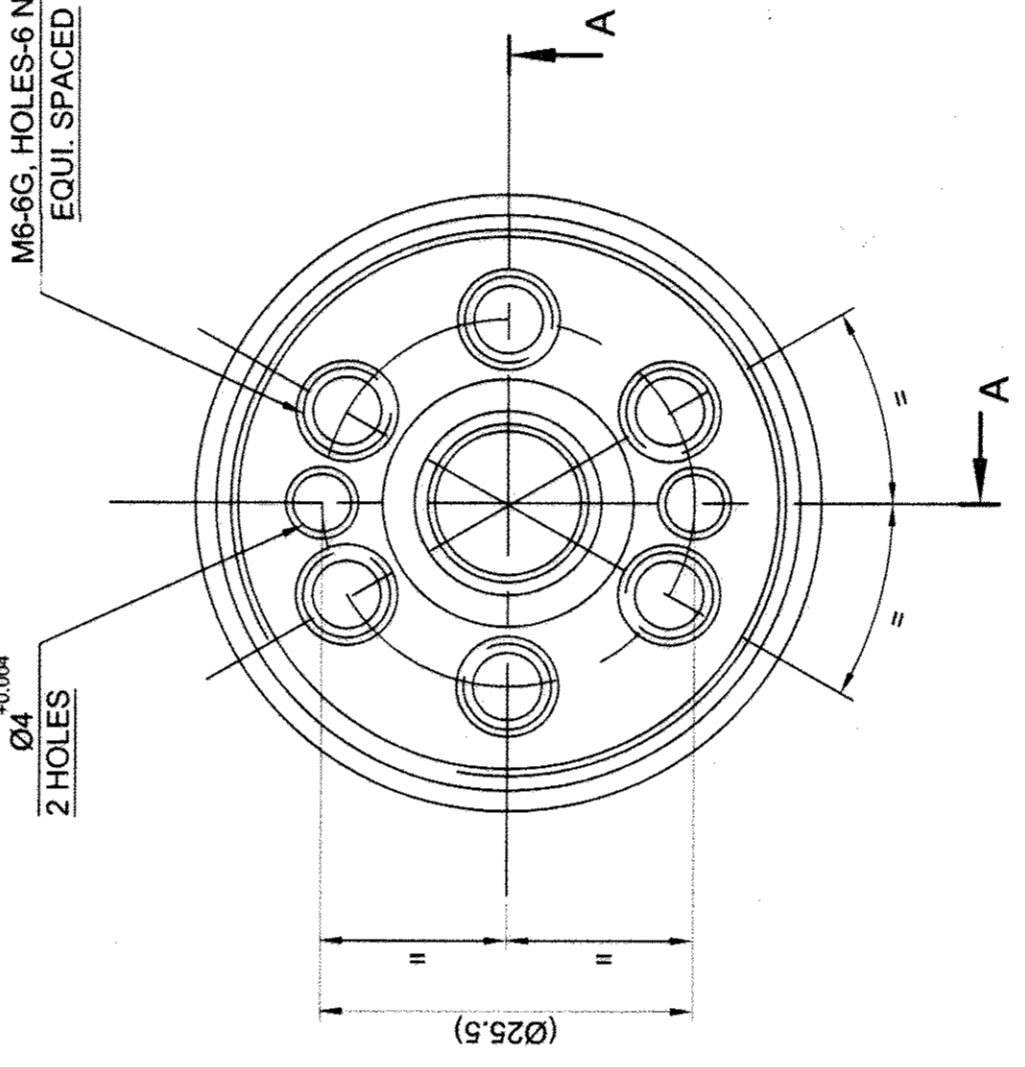
DEGREE	THICKNESS mm.
30	1.45
29	1.47
28	1.52
27	1.60
26	1.72
25	1.87
24	2.05
23	2.27
22	2.51
21	2.80
20	3.11
19	3.46
18	3.83
17	4.24
16	4.69
15	5.20
14	5.67
13	6.20
12	6.77
11	7.37
10.4	7.75



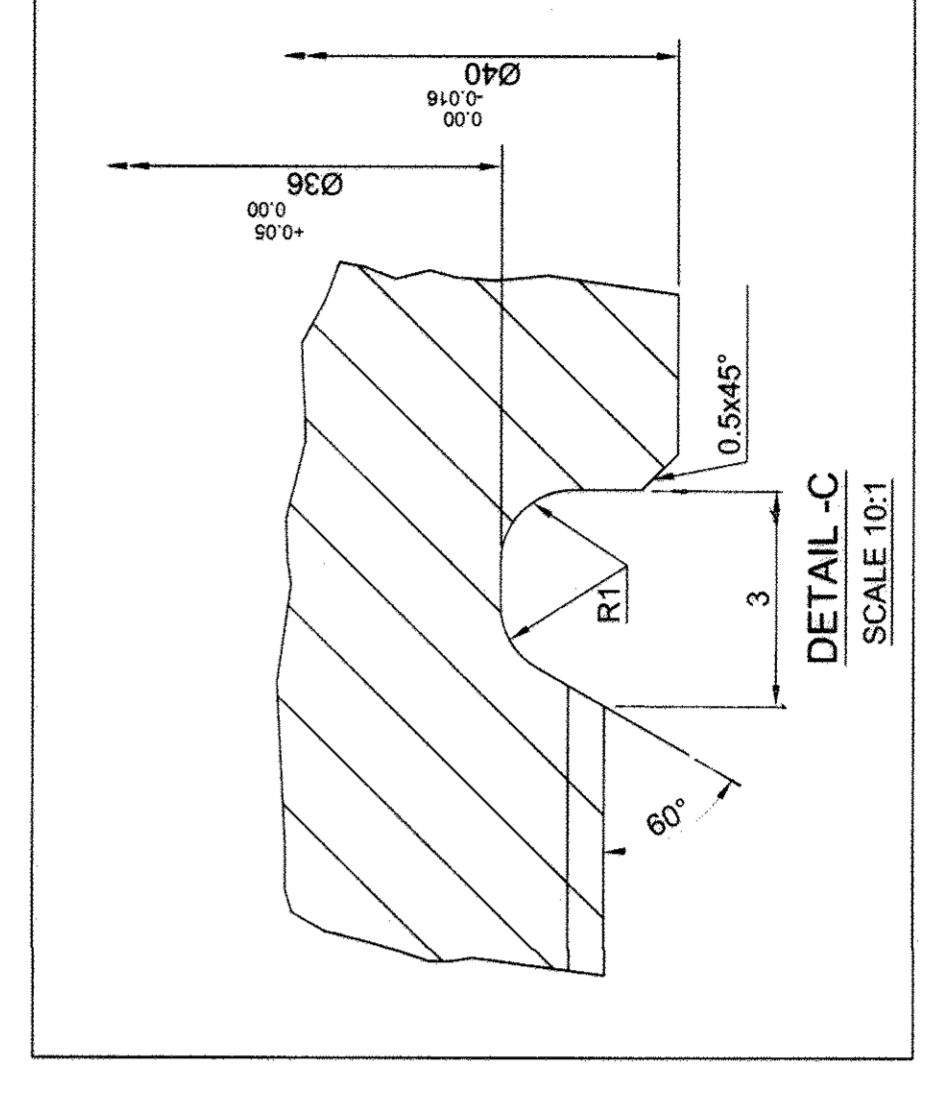
DETAIL AT 'A'
BEFORE FINAL MACHINING
(ENLARGED SCALE)



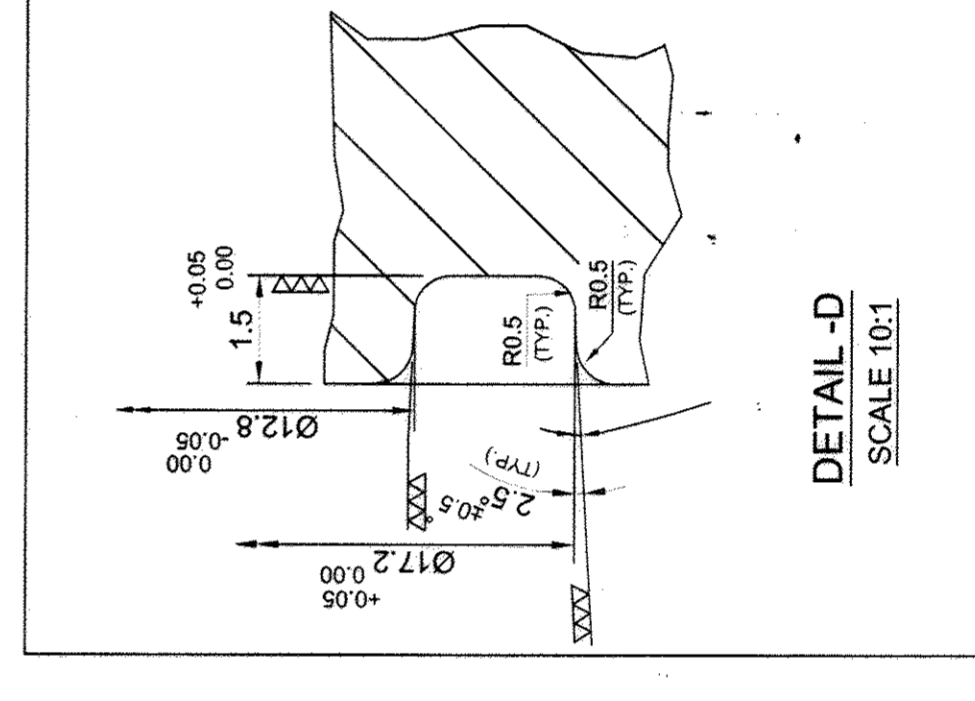
DETAIL AT 'B'-SECTION A-A
SCALE 2:1



END VIEW AT 'F'



DETAIL - C
SCALE 10:1



DETAIL - D
SCALE 10:1

DO NOT SCALE THE DRAWING
ASK IF IN DOUBT
UNLESS OTHERWISE SHOWN:
REMOVE SHARP EDGES AND BURRS
CHAMFER 1mm x 45°
MACHINING FINISH IN MICRONS:
▽ 8-25
▽▽ 0.025-1.6
▽▽▽ 0.025-0.025

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

DIAMETER & LENGTH	LENGTH IN mm OF SHORTER SIDE OF UPTO & INCL.	ANGLE UPTO & INCL.
6	3040.2	6
12	3150.3	1
315	100040.8	30
1000	200041.2	120
4000	800041.6	4000 & ABOVE

ITEM NO.	MATERIAL	DESCRIPTION	QTY.	WT.Kg.	REMARKS
1	TITANIUM FORGING	TITANIUM LINER-FEMALE HALF			
2	FOR PS4 KEVLAR COMPOSITE GAS BOTTLE				

NO. OFF.	WT.Kg.
1	

UNIT/DIVISION/PROJECT	CMSE/CPDG/CPDD/PSLV
INDIAN SPACE RESEARCH ORGANISATION	
VIKRAM SARABHAI SPACE CENTRE	
TRIVANDRUM	

DRG. NO.	SCALE	SHEET	OF
256-101-17-010002	1:1	1	1