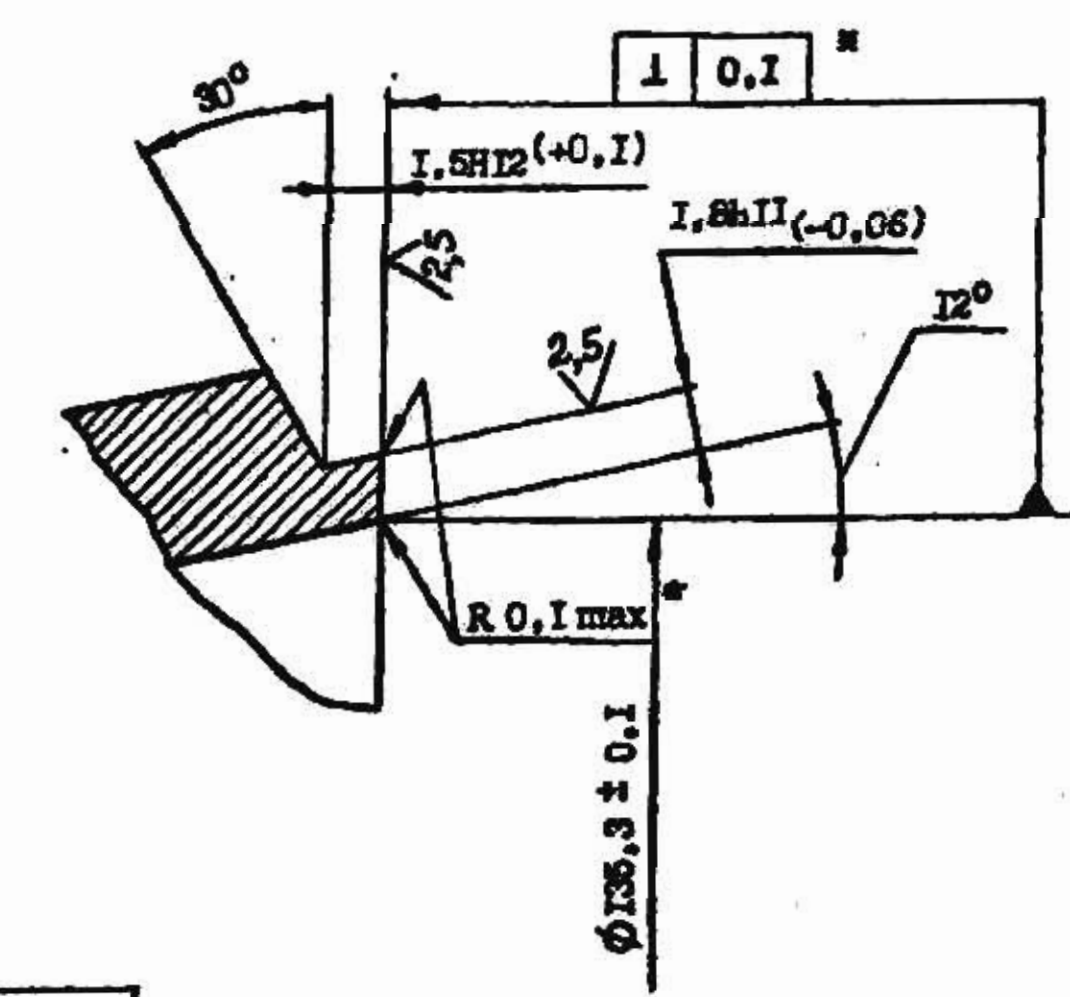
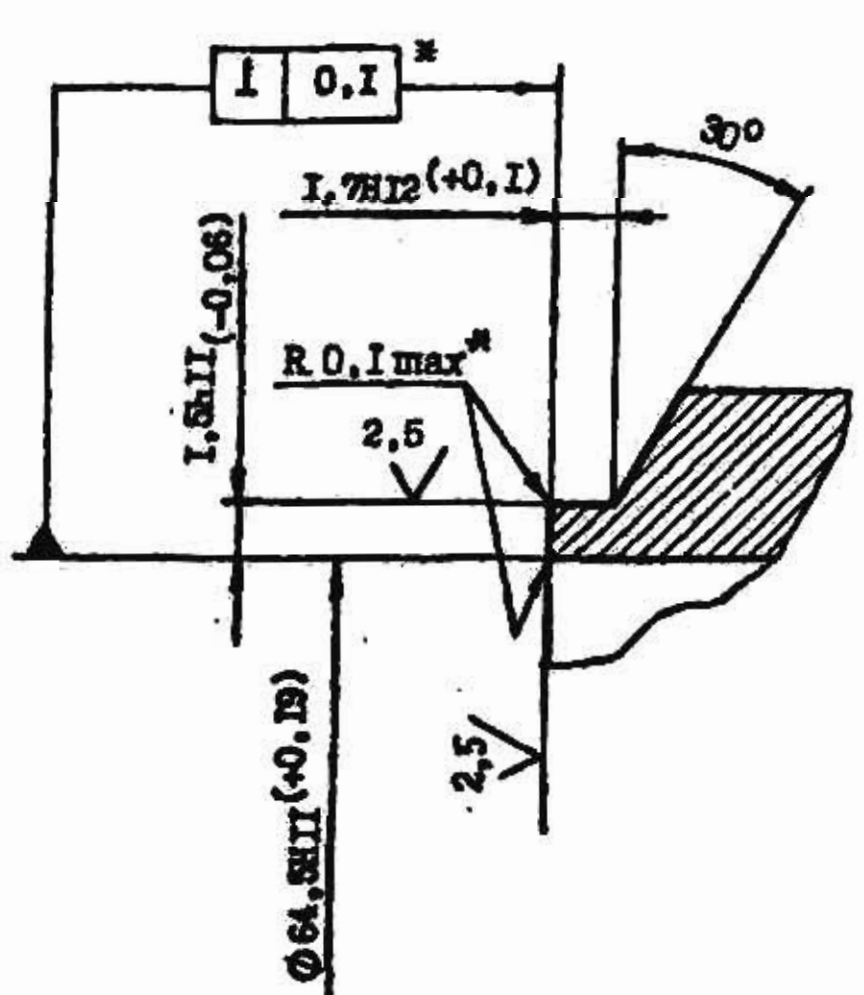


1. *Sizes and tolerances for arrangement are to be ensured by tools.
2. **Sizes are given for reference.
3. The points of the contour preset by the table shall be connected by smooth French curve. The deviations from the preset contour shall not exceed 0.15 mm.
4. The technological allowance over the internal and external contours is allowed.
5. Mark drawing no. and stamp serial no. on the tag.
6. The remaining technical requirements are given in compliance with Specification CUE 4104 - 0 Ty.

B (5:1)

Γ (5:1)



Sizes, mm

A ± 0.1	3	6	9	12	15	20	25	30	35	40	50	60	70	80	100	120	140	160	170
B ± 0.15	φ19.0	φ22.1	φ25.8	φ29.6	φ33.4	φ39.5	φ45.5	φ51.1	φ56.4	φ61.5	φ70.9	φ79.4	φ87.3	φ94.6	φ107.5	φ118.9	φ128.9	φ137.7	φ141.7

Release	Signature	
QA	<i>[Signature]</i>	22/1/95
CC (CUSP)	<i>[Signature]</i>	22/1/95

D - 11674

DO NOT SCALE THE DRAWING ASK IF IN DOUBT ALL DIMENSIONS ARE IN mm		MATERIAL alloy bronze 6PXII, PT-B-I Ty-48-21-197-81.		SURFACE TREATMENT		TITLE WALL		INDEX MODIFICATION ORDER No & DATE	
Concentricity		General tolerance JS or p 12		SURFACE FINISH Rz 40		GOVERNMENT OF INDIA INDIAN SPACE RESEARCH ORGANIZATION LIQUID PROPELLION SYSTEMS CENTRE MADRAS TIRUVANANTHURAI - 605 017		REVISION	
Perpendicularity		Thread tolerance		MARKING		CUSP		FORMAT	
Angularity		Thread chamfer & under cut		MARKING		DING No CUE-4104-121		SHEET 1 OF 1	
Parallelism		Rads not specified		MARKING		SCALE 2:1		A1	
The drawing is the sole property of ISRO and shall not be copied, reproduced or communicated to others without proper authorization		Chamfers not specified		MARKING		SIGN DATE			