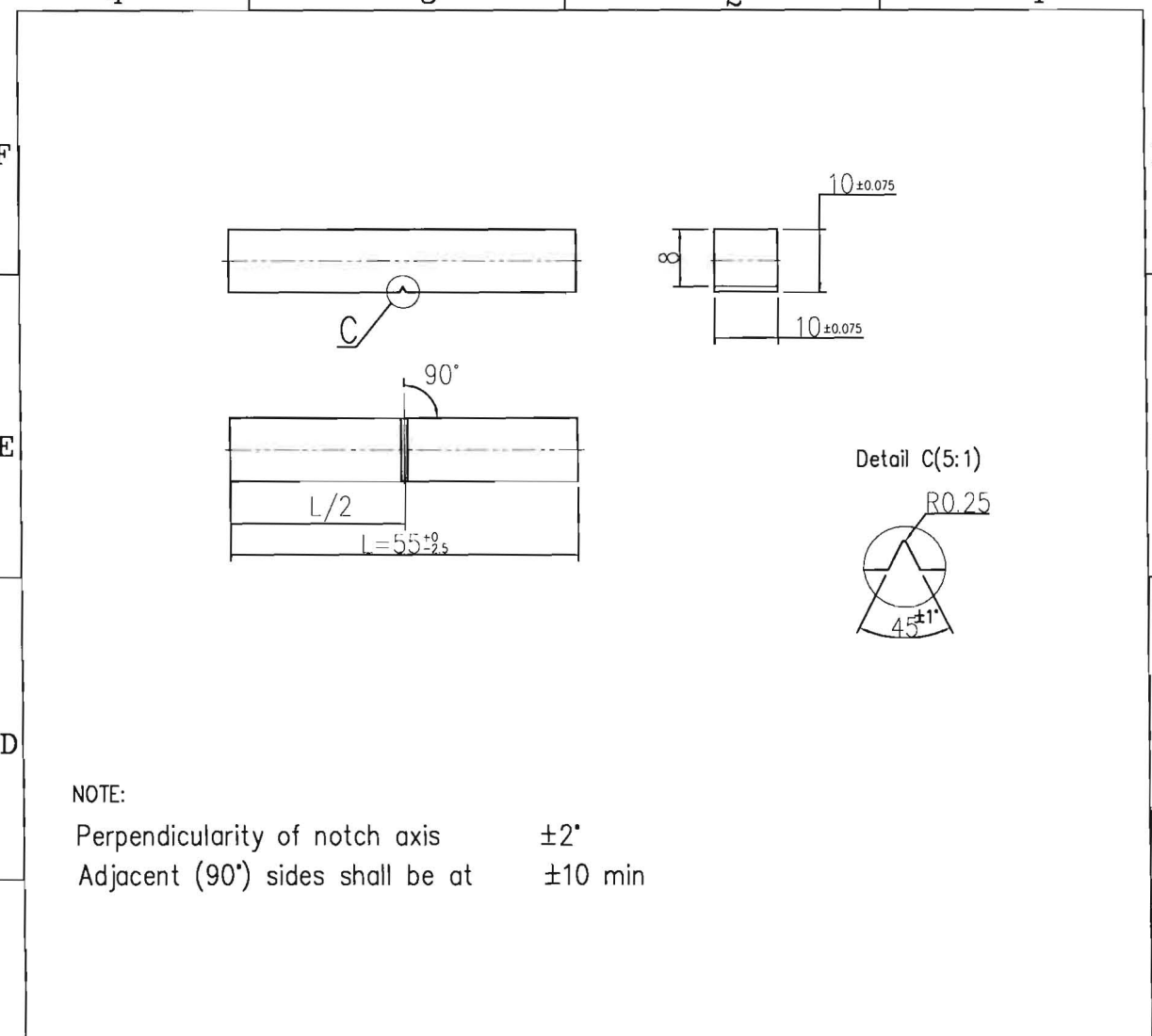


MACHINING DEVIATION TO IS:2102 (MEDIUM GRADE) UNLESS SPECIFIED OTHERWISE	
LENGTH IN mm OF SHORTER SIDE OF ANGLE	UP TO 6 ±1°
6-30	±30'
30-120	±20'
120-400	±10'
UP TO 4000 ABOVE	±3.0
UP TO 2000 ABOVE	±2.0
UP TO 1000 ABOVE	±1.2
UP TO 315 ABOVE	±0.8
UP TO 120 ABOVE	±0.5
UP TO 30 ABOVE	±0.3
UP TO 6 ABOVE	±0.2
UP TO 3 ABOVE	±0.1



NOTE:  
 Perpendicularity of notch axis  $\pm 2^\circ$   
 Adjacent (90°) sides shall be at  $\pm 10$  min

LENGTH  
 OR  
 DIA

C	DO NOT SCALE THE DRAWING ASK IF IN DOUBT. ALL DIMENSIONS ARE IN mm.	MATERIAL <u>As specified</u> Mechanical properties _____	SURFACE TREATMENT _____ Ra ≤ 2µm on notched surface and opposite face Ra ≤ 4µm on other surfaces
	Concentricity Perpendicularity Angularity Parallelism	General tolerance _____ Thread tolerance _____ Thread chamfer & under cut. _____ Radii not specified _____ Chamfers not specified _____	SURFACE FINISH

INDEX	AMEND.No.	DATE	TITLE <b>Charpy Impact Test Specimen</b> (Ref. ASTM E23/12M, Type-A)	Calculated Weight _____ Kg
-------	-----------	------	--	-------------------------------

DRN.	<i>kannan</i>	GOVERNMENT OF INDIA INDIAN SPACE RESEARCH ORGANISATION LIQUID PROPULSION SYSTEMS CENTRE VALIAMALA TRIVANDRUM-695547	ISSUE No.
CHD.	<i>Ravi Ranjan</i> 20/04		

INDEX	AMEND.No.	DATE	DRG.No. MME/AML/IMPACT/V-NOTCH	Rev. No. R0	FORMAT A4
REVD.	<i>Anoop C R</i> 04/05		SCALE NTS	SHEET 1 OF 1	
APPD.	<i>Thomas Tharian</i> 02/05				
2018	SIGN.	DATE			

