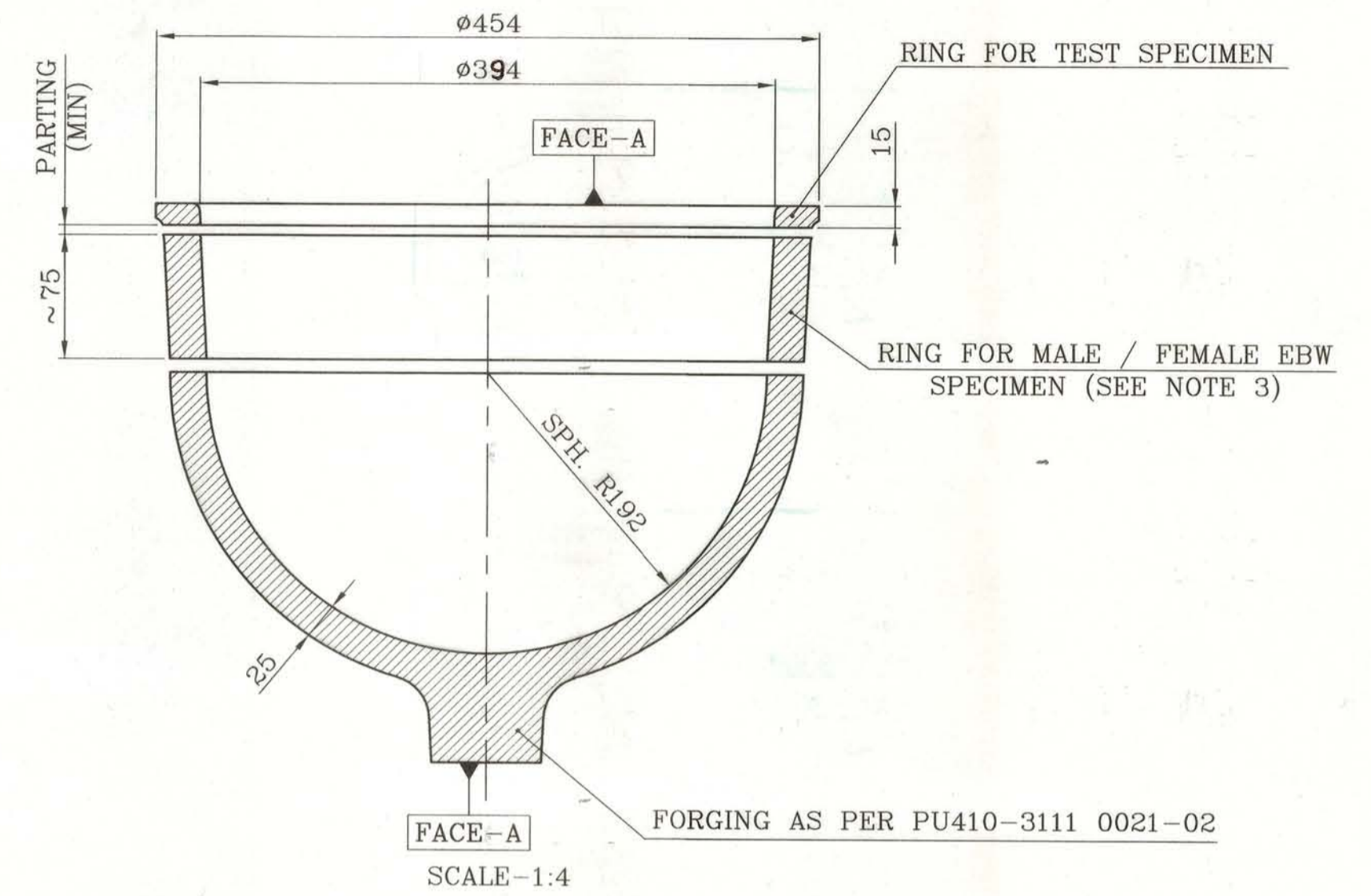
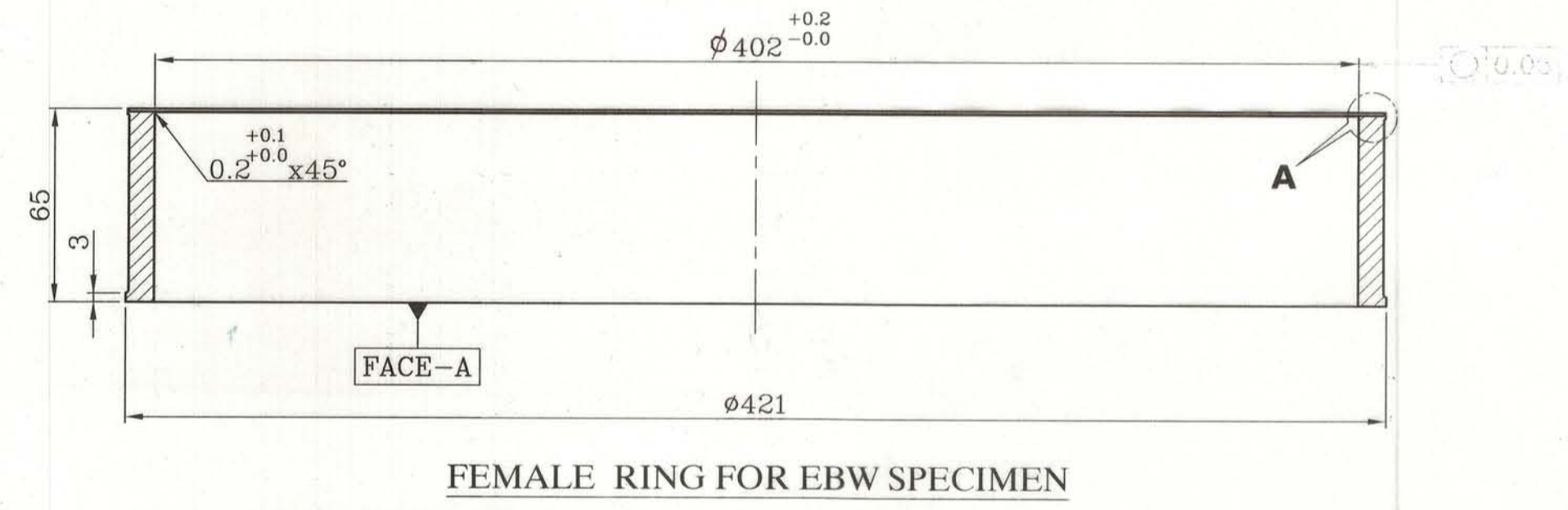
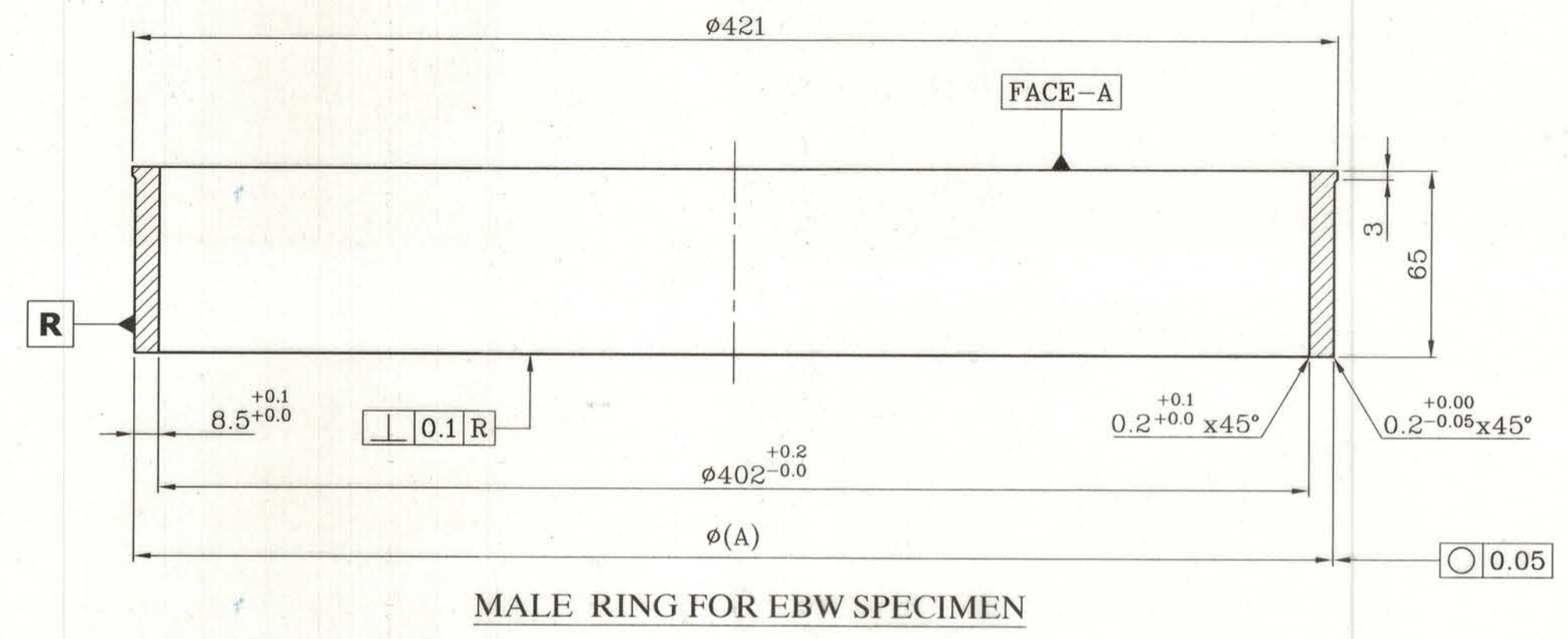




SRQA LPSC		CC RELEASE	
CHD.	<i>[Signature]</i> 23/08/23	CHD.	<i>[Signature]</i>
APPD.	<i>[Signature]</i> 23/08/23	APPD.	<i>[Signature]</i> 23/08/23



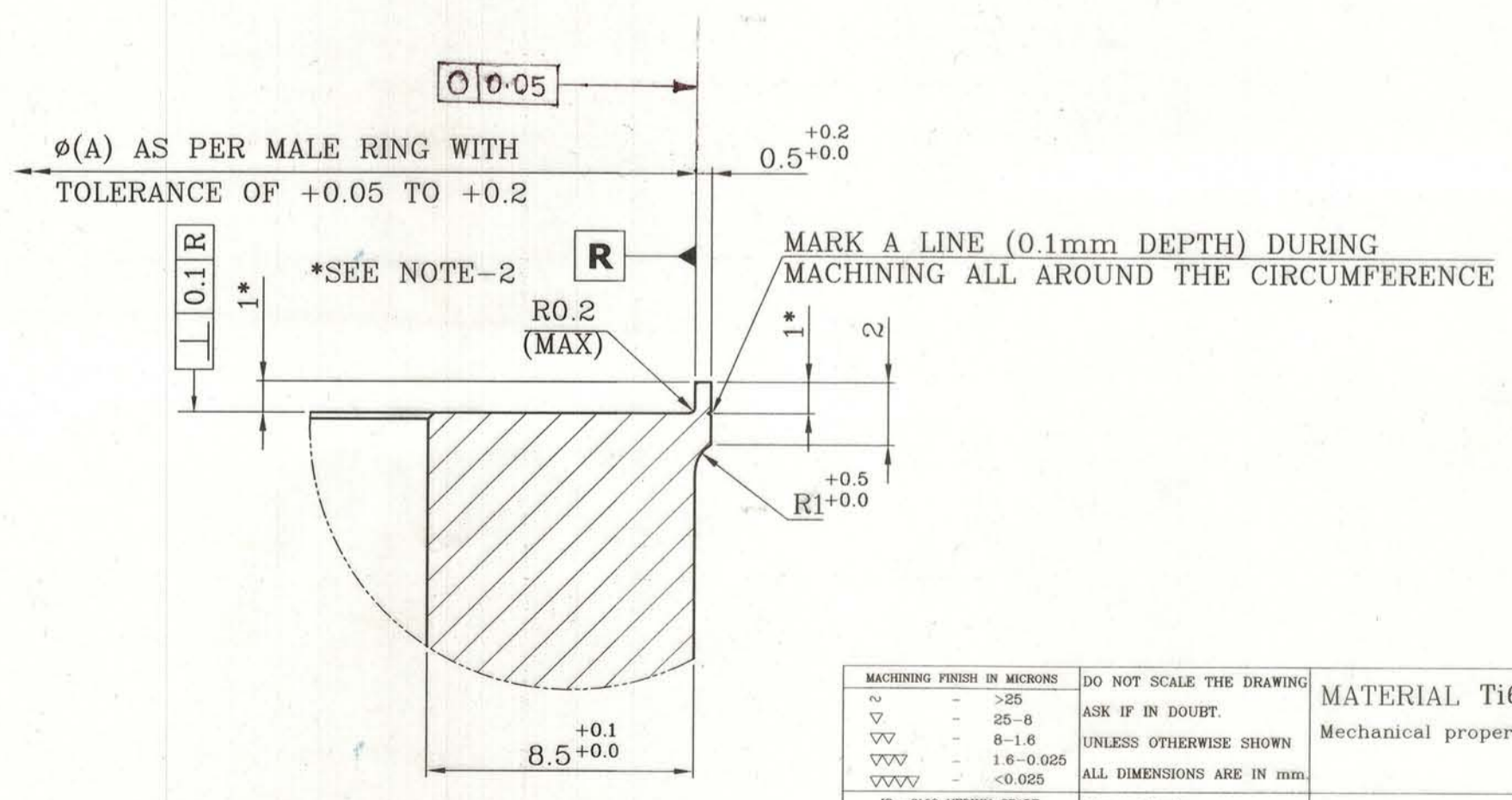
- NOTE :**
- IDENTIFICATION NUMBER OF THE SUPPLIED FORGING SHALL BE REPRODUCED IN ALL FACE-A LOCATIONS BY ENGRAVING.
 - THESE TWO DIMENSIONS SHALL ALWAYS BE EQUAL WITHIN IN A TOLERANCE OF $\begin{matrix} +0.05 \\ -0.00 \end{matrix}$
 - ONE RING FOR MALE/FEMALE EBW SPECIMEN IS TO BE REALIZED FROM THIS PART.

MARKING DETAILS:

- HEIGHT OF LETTER : 5mm
- DEPTH OF MARKING : 0.2mm

PRECAUTIONS FOR MACHINING Ti6Al4V

- AVOID OVER HEATING
- AVOID USE OF CHLORINATED CUTTING FLUID
- USE ONLY IPA FOR CLEANING AND DEGREASING



MACHINING FINISH IN MICRONS	DO NOT SCALE THE DRAWING	MATERIAL Ti6Al4V ANNEALED	SURFACE TREATMENT
~ >25	ASK IF IN DOUBT.	Mechanical properties	
∇ 25-8	UNLESS OTHERWISE SHOWN	General tolerance	IS 2102 MEDIUM GRADE & CLASS 'K'
∇∇ 8-1.6	ALL DIMENSIONS ARE IN mm.	Thread tolerance	
∇∇∇ 1.6-0.025		Thread chamfer & under cut.	
∇∇∇∇ <0.025		Radii not specified	
IS : 2102 MEDIUM GRADE	Concentricity	Chamfers not specified	
DIA & LENGTH UP TO & INCL. SHORTER SIDE	Perpendicularity		
6 10.1			
6-30 10.2			
30-120 10.3			
120-315 10.4			
315-1000 10.8			
1000-2000 11.2			
2000-4000 12.0			
4000&ABOVE 13.0			

NO. OF ASSY.		QTY.	NEXT ASSEMBLY	01	195/PS4 Dt: 30.03.2021
TITLE MACHINED RINGS FOR EBW TRIAL AND TEST SPECIMENS				INDEX	MODIFICATION ORDER No. & DATE
DGN. <i>[Signature]</i> 23/08/23				REVISION	
D.CHD. <i>[Signature]</i> 23/08/23				PROJECT ESES/PS4	
DRN. ABIN.R 23.08.23				REV NO. 01	
CHD. URS 8/2023				FORMAT A2	
APPD. <i>[Signature]</i> 8/23				DRG.No. PU410-3111 0131	
SIGN. DATE				SCALE 1:2 & NOTED	
				SHEET 1 OF 1	
CAD FILE NAME:					