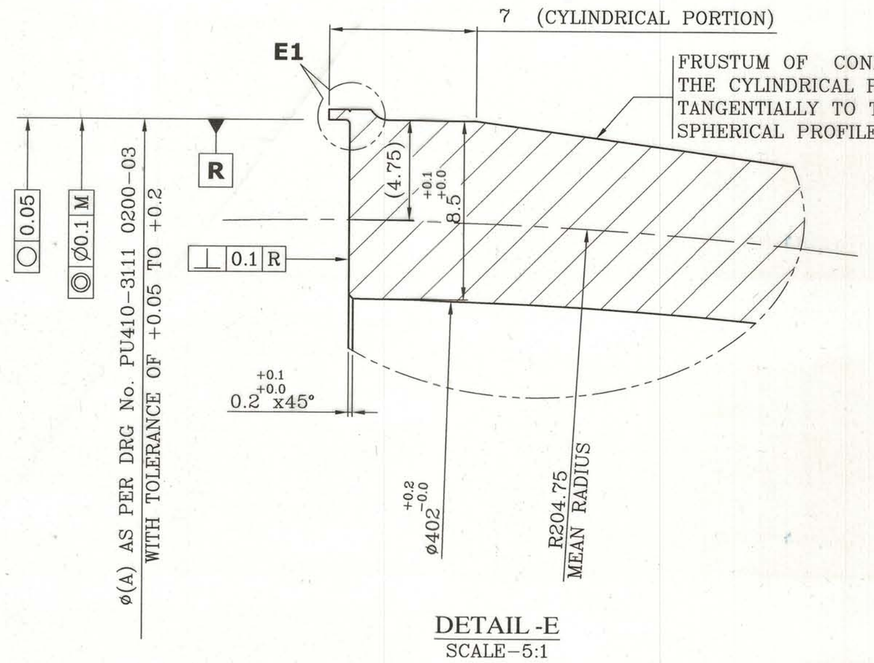
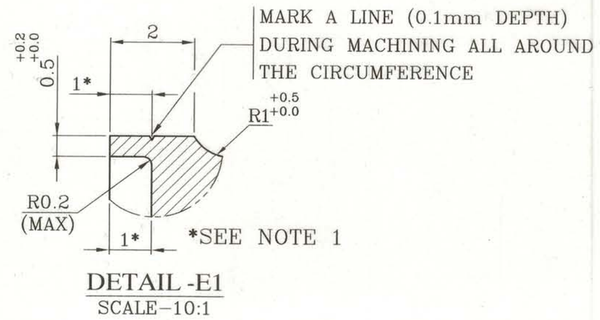
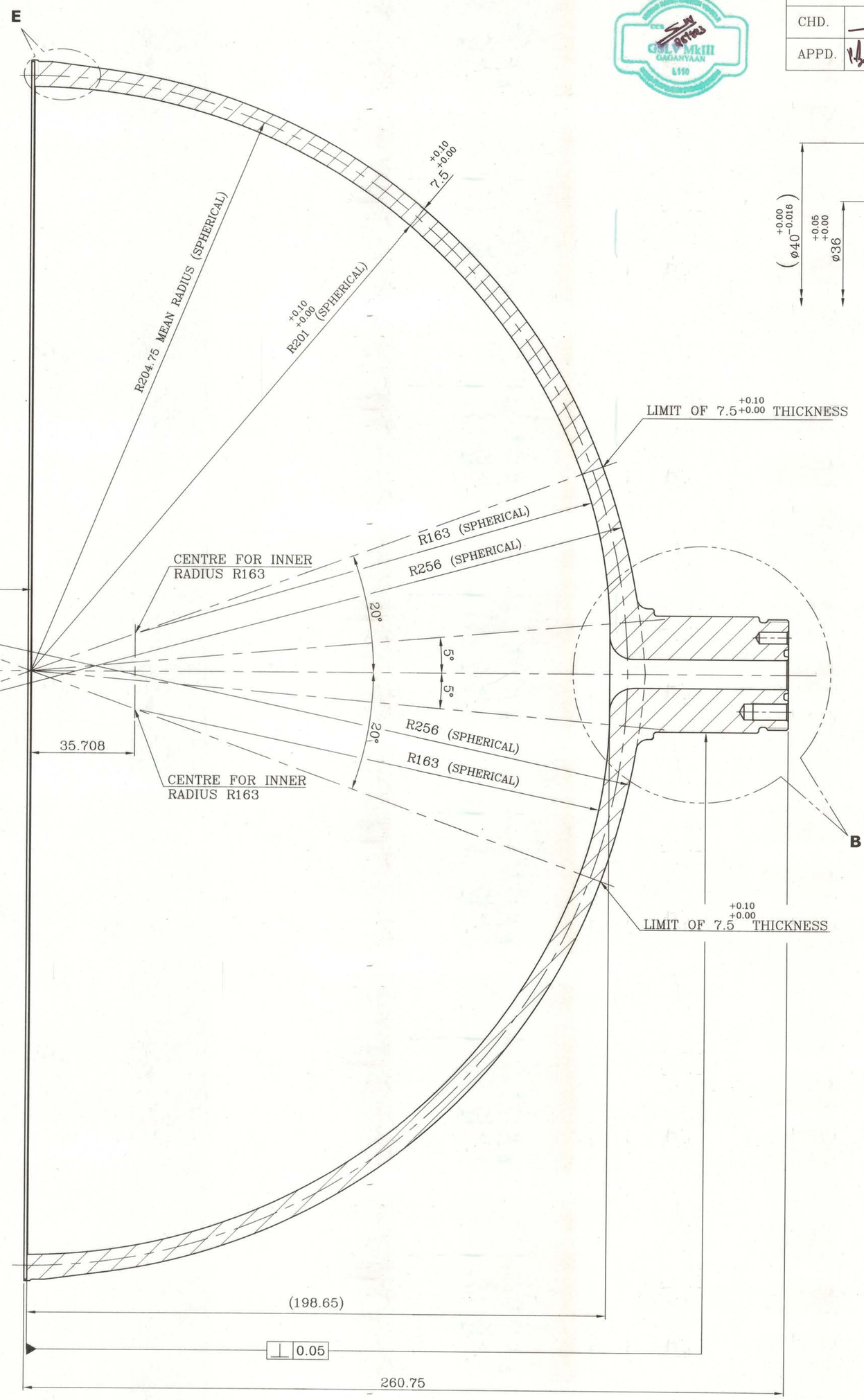
SRQA LPSC		CC RELEASE	
CHD.	23/10/23	CHD.	23/10/23
APPD.	23/10/23	APPD.	23/10/23

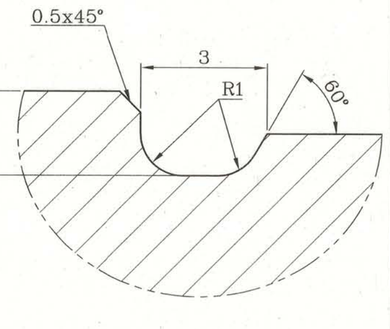


DETAIL -E
SCALE–5:1

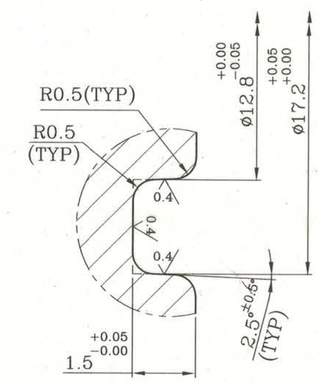


DETAIL -E1
SCALE–10:1



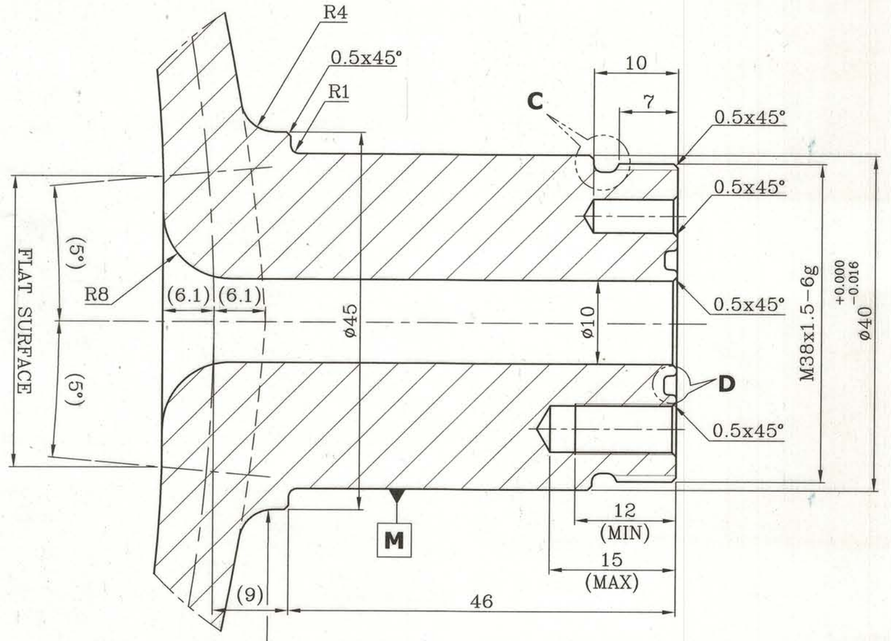


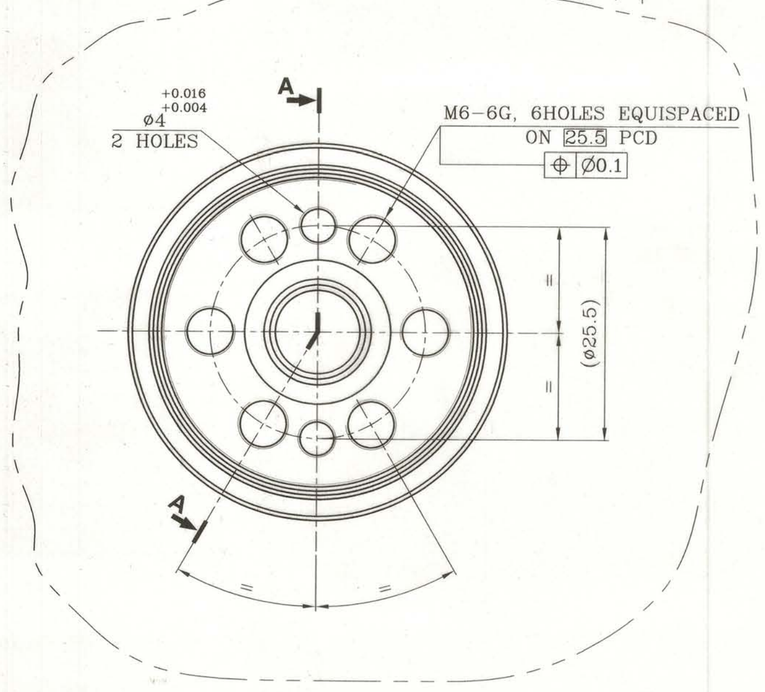
DETAIL - C
SCALE–10:1



DETAIL - D
SCALE–10:1

DETAIL - F





DETAIL - B & SECTION A-A
SCALE–2:1

PART No. MARKING : 3111 0300–03/F (FORGING SL.NO) / B(BOTTLE SL.NO.) BY ENGRAVING
HEIGHT OF MARKING : 3mm
DEPTH OF MARKING : 0.2max
REFER DETAIL 'F' FOR MARKING DETAILS

NOTE :

1. THESE TWO DIMENSIONS SHALL ALWAYS BE EQUAL WITHIN IN A TOLERANCE OF +0.05 −0.00

PRECAUTIONS FOR MACHINING Ti6Al4V

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

03	195/PS4 Dt: 30.03.2021
02	134/PS4 Dt: 22.12.2011
24.07.87	i) MARKING OF Drg No. 3111 0200-01/ F (FORGING Sl. No.)/ B (BOTTLE Sl. No.)
01	i) WELDING JOINT ii) THICKNESS iii) END BOSS 18.10.85
INDEX	MODIFICATION ORDER No. & DATE

REVISION

NO. OF ASSY.	QTY.	NEXT ASSEMBLY
	1	PU410-3111 0001

MACHINING FINISH IN MICRONS		DO NOT SCALE THE DRAWING
~	– >25	ASK IF IN DOUBT.
▽	– 25–8	UNLESS OTHERWISE SHOWN
▽▽	– 6–1.6	ALL DIMENSIONS ARE IN mm.
▽▽▽	– 1.6–0.025	
▽▽▽▽	– <0.025	

IS : 2102 MEDIUM GRADE

DIA in LENGTH UP TO & INCL.		LENGTH IN mm SMOOTHER SIDE OF ANGLE UP TO & INCL.	
6mm	±0.1	1–6	±1°.00'
6–30	±0.2	6–30	±0°.30'
30–120	±0.3	30–120	±0°.20'
120–315	±0.5	120–400	±0°.10'
315–1000	±0.8		
1000–2000	±1.2		
2000–4000	±2.0		
4000&ABOVE	±3.0		

Concentricity	
Perpendicularity	
Angularity	
Parallelism	

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MATERIAL
Ti6Al4V ANNEALED
Mechanical Properties

General tolerance
IS 2102 MEDIUM GRADE & CLASS 'K'
Thread tolerance

Thread chamfer & under cut.

Radii not specified

Chamfers not specified

SURFACE TREATMENT

SURFACE FINISH
1.6 (0.4)

MARKING DRAWING
No. BY ENGRAVING

QUANTITY
1

MASS
9.25
Kg

TITLE
HEMISPHERE (FEMALE)

DGN.		23/10/23	
D.CHD		23/10/23	
DRN.	ABIN.R	23.08.23	
CHD.	URS	8/2023	
APPD.		8/23	
	SIGN.	DATE	

GOVERNMENT OF INDIA
INDIAN SPACE RESEARCH ORGANISATION
LIQUID PROPULSION SYSTEMS CENTRE
VALIAMALA TRIVANDRUM-695547

PROJECT ESES/PS4
REV. NO. 03
DRG.No. PU410-3111 0300
FORMAT A1
SCALE 1:1 & NOTED
SHEET 1 OF 1
CAD FILE NAME: