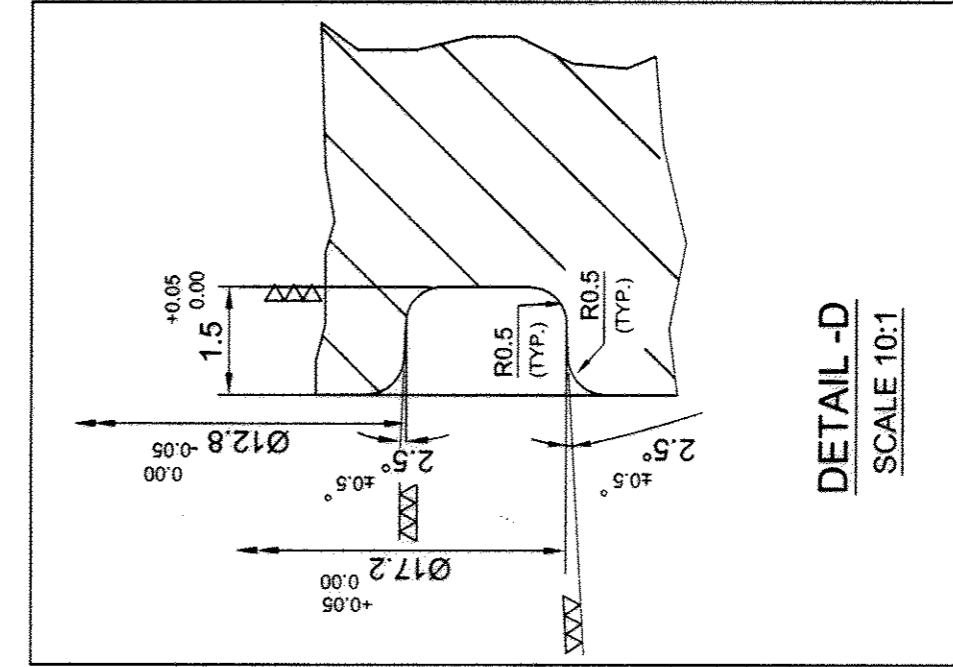
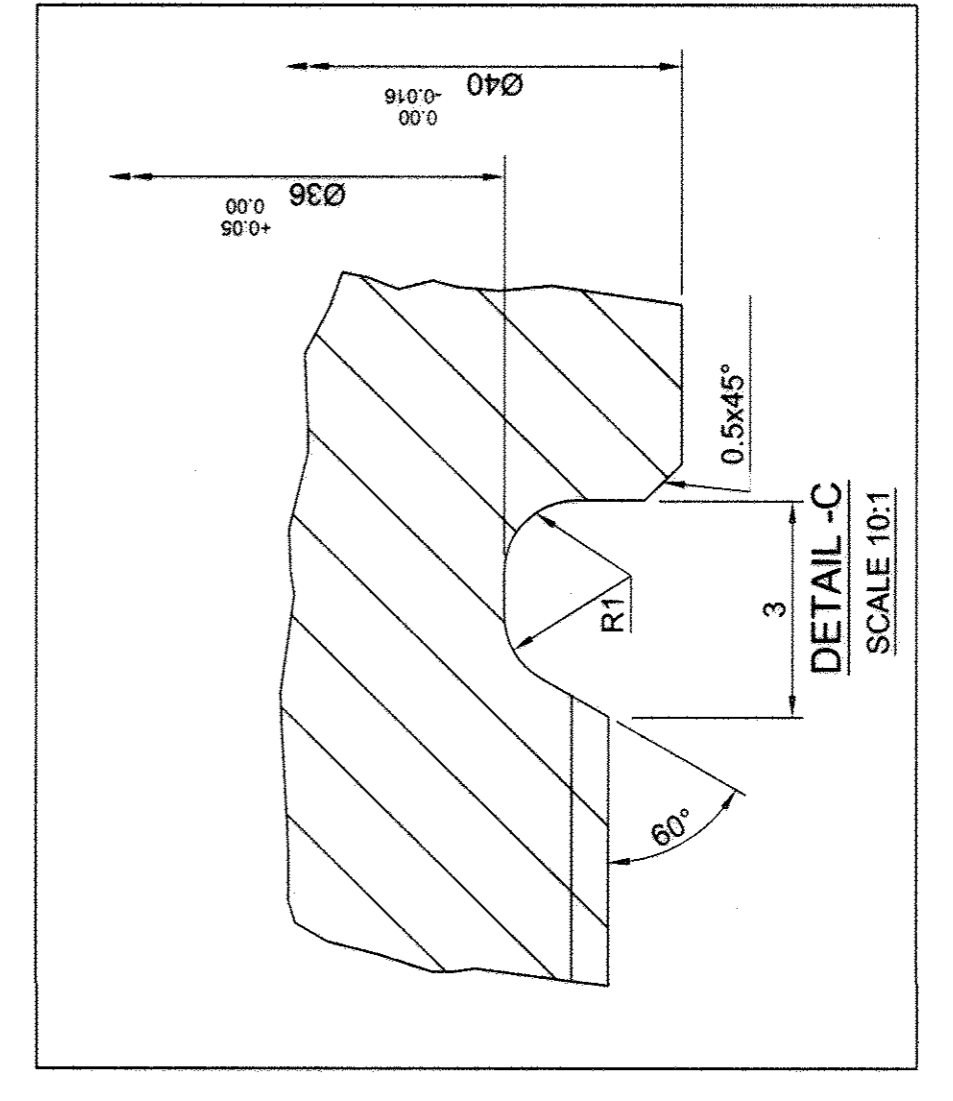
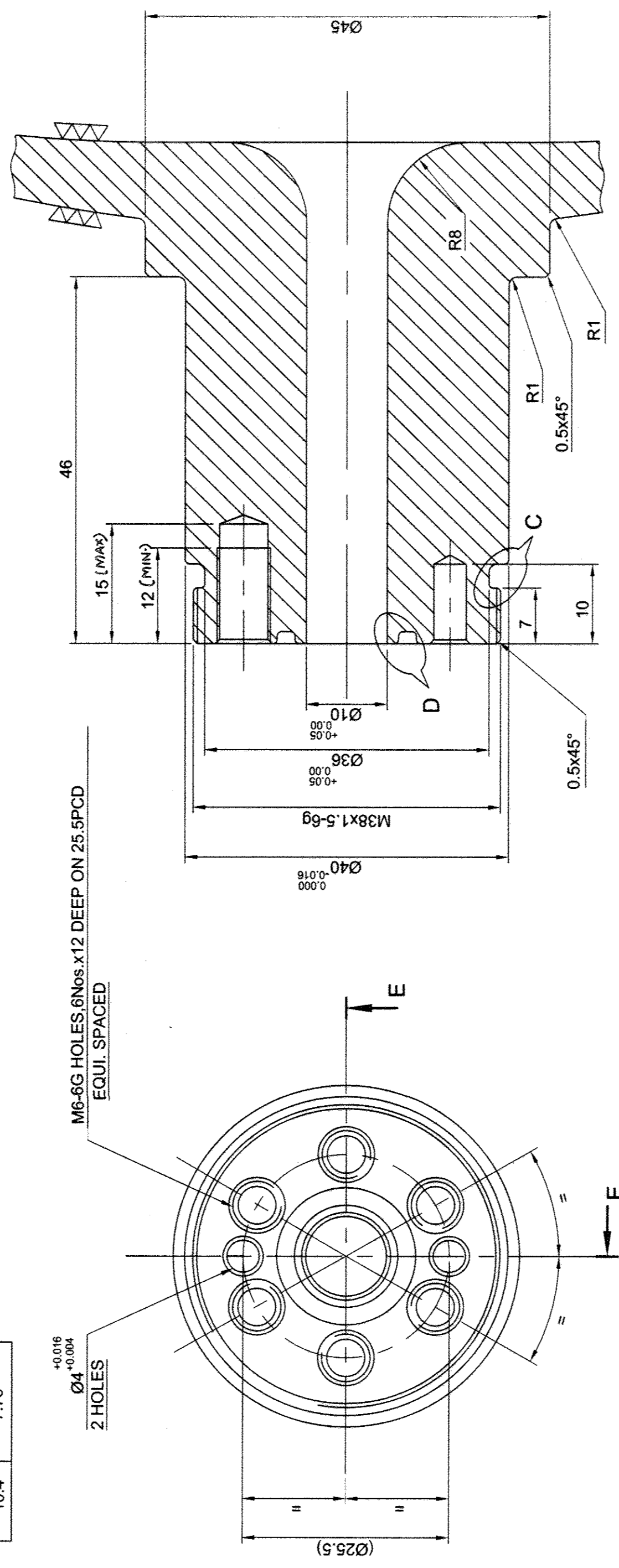
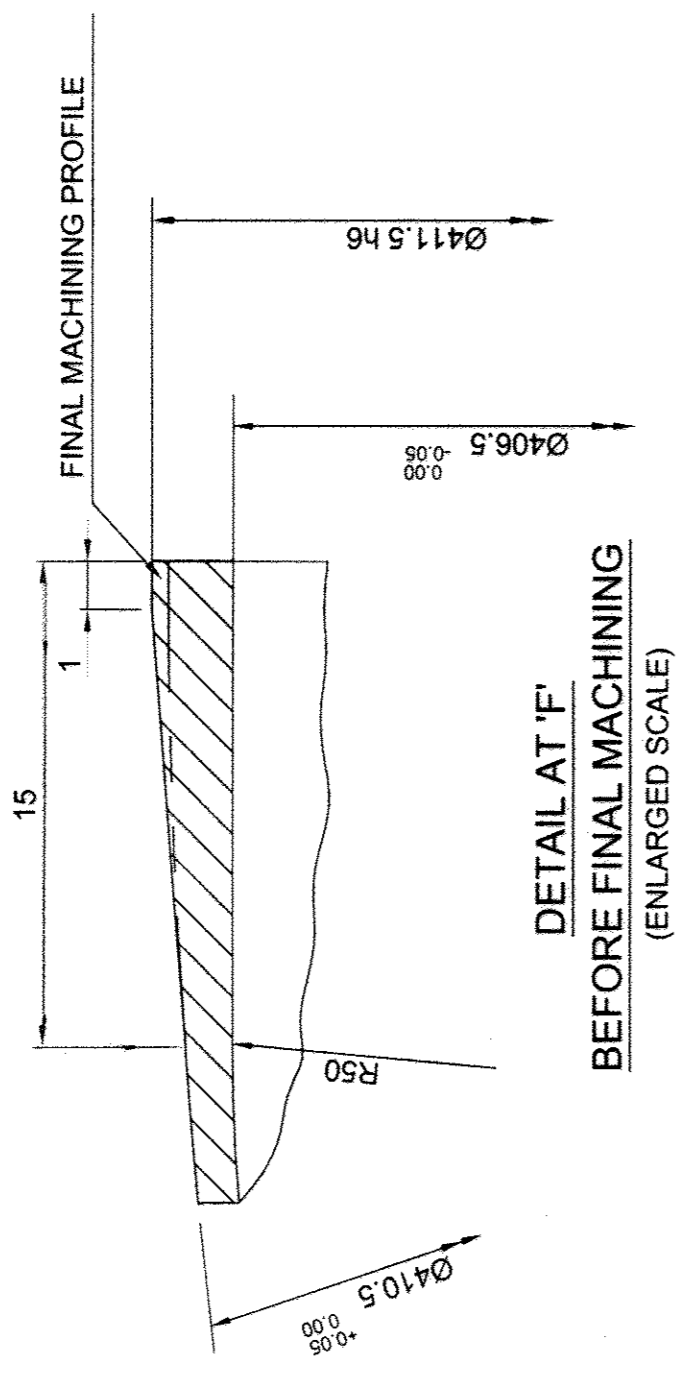
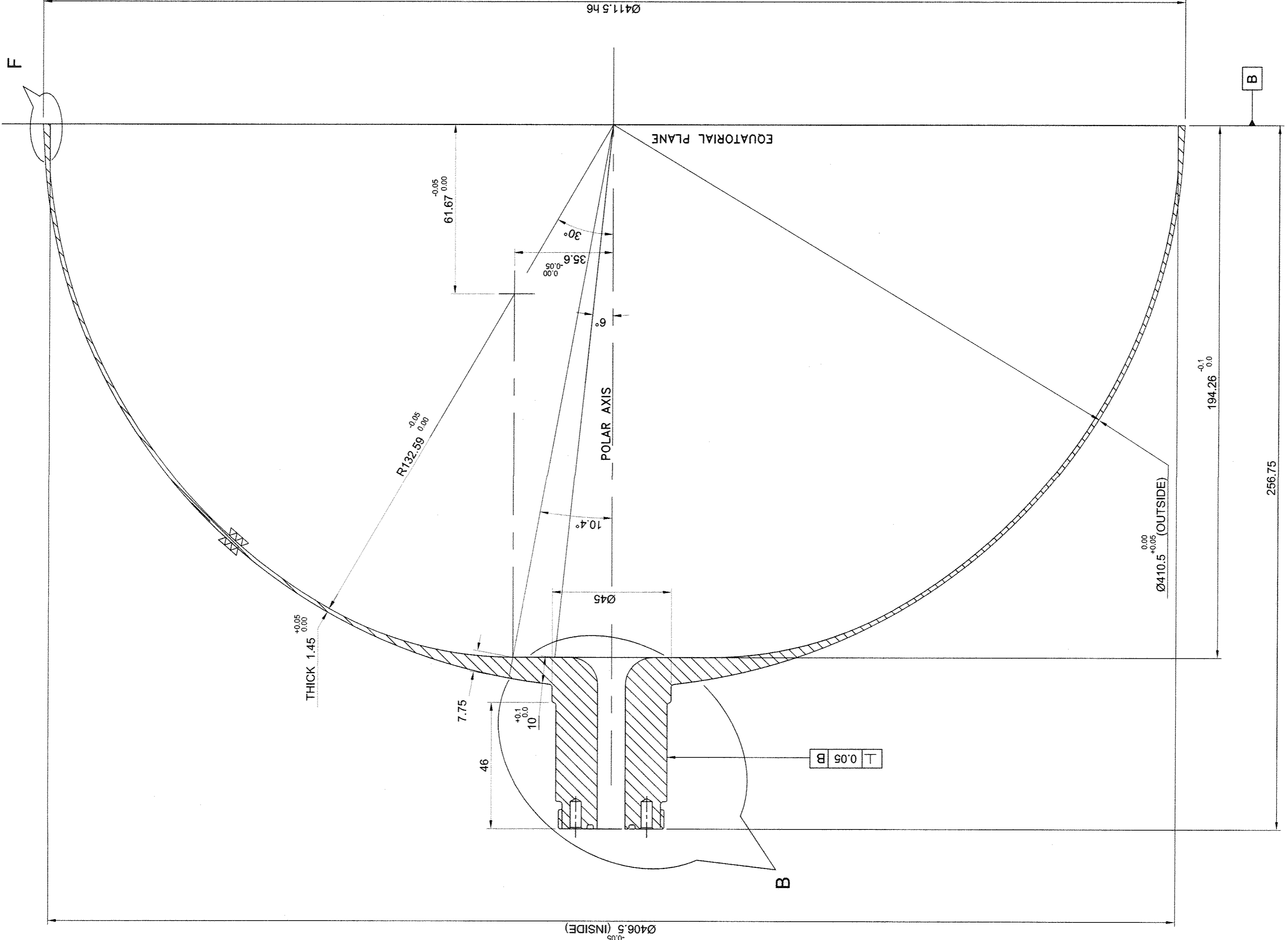


LINER THICKNESS FROM 30° TO 10.4° TOLERANCE ON THICKNESS: 0.05 mm.

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 'B'-SECTION E-E SCALE 2:1

DETAIL -D SCALE 10:1

DETAIL -C SCALE 10:1

DO NOT SCALE THE DRAWING UNLESS OTHERWISE SHOWN. REMOVE SHARP EDGES AND BURRS. CHAMFER 1mm x45. MACHINING FINISH IN MICRONS: V7 8-25 VV7 0.025-16 VVV7 0.025-0.025

DEVIATION FOR NONTOLERANCED DIMENSIONS (IS: 2102-MEDIUM GRADE)

DIAMETER & LENGTH UPTO & INCL. 840.1	LENGTH IN mm OF SHORTER SIDE OF ANGLE UPTO & INCL. 6	ANGLE UPTO & INCL. 120	ANGLE UPTO & INCL. 300	ANGLE UPTO & INCL. 1200	ANGLE UPTO & INCL. 4000
6	3040.2	6	3040.2	30	4000
120	3140.2	6	12040.20	30	4000
315	10004.0	6	12040.20	30	4000
1000	20004.12	6	12040.20	30	4000
4000	20004.12	6	12040.20	30	4000

REVISIONS

REV/NO	ZONE	DESCRIPTION	SIGN	DATE
1	B/C4	REVISED IN DRAWING		
2	B/C4	REVISED IN DRAWING		
3	B/C4	REVISED IN DRAWING		
4	B/C4	REVISED IN DRAWING		
5	B/C4	REVISED IN DRAWING		

ITEM NO.	DESCRIPTION	MATERIAL	QTY.	WT.	REMARKS
1	TITANIUM LINER- MALE HALF FOR PS4 KEVLAR COMPOSITE GAS BOTTLE	TITANIUM			

UNIT/NO.	PROJECT	UNIT/NO.	PROJECT
INDIAN SPACE RESEARCH ORGANISATION	INDIAN SPACE RESEARCH ORGANISATION	INDIAN SPACE RESEARCH ORGANISATION	INDIAN SPACE RESEARCH ORGANISATION
VIKRAM SARABHAI SPACE CENTRE	VIKRAM SARABHAI SPACE CENTRE	VIKRAM SARABHAI SPACE CENTRE	VIKRAM SARABHAI SPACE CENTRE
TRIVANDRUM	TRIVANDRUM	TRIVANDRUM	TRIVANDRUM

DRG. NO.	SCALE	SHEET	OF
256-101-17-010003	1:1.2:1.10:1	1	1

CC RELEASE	CHD.	APPD.

Ø411.5 h6	0.000	-0.040