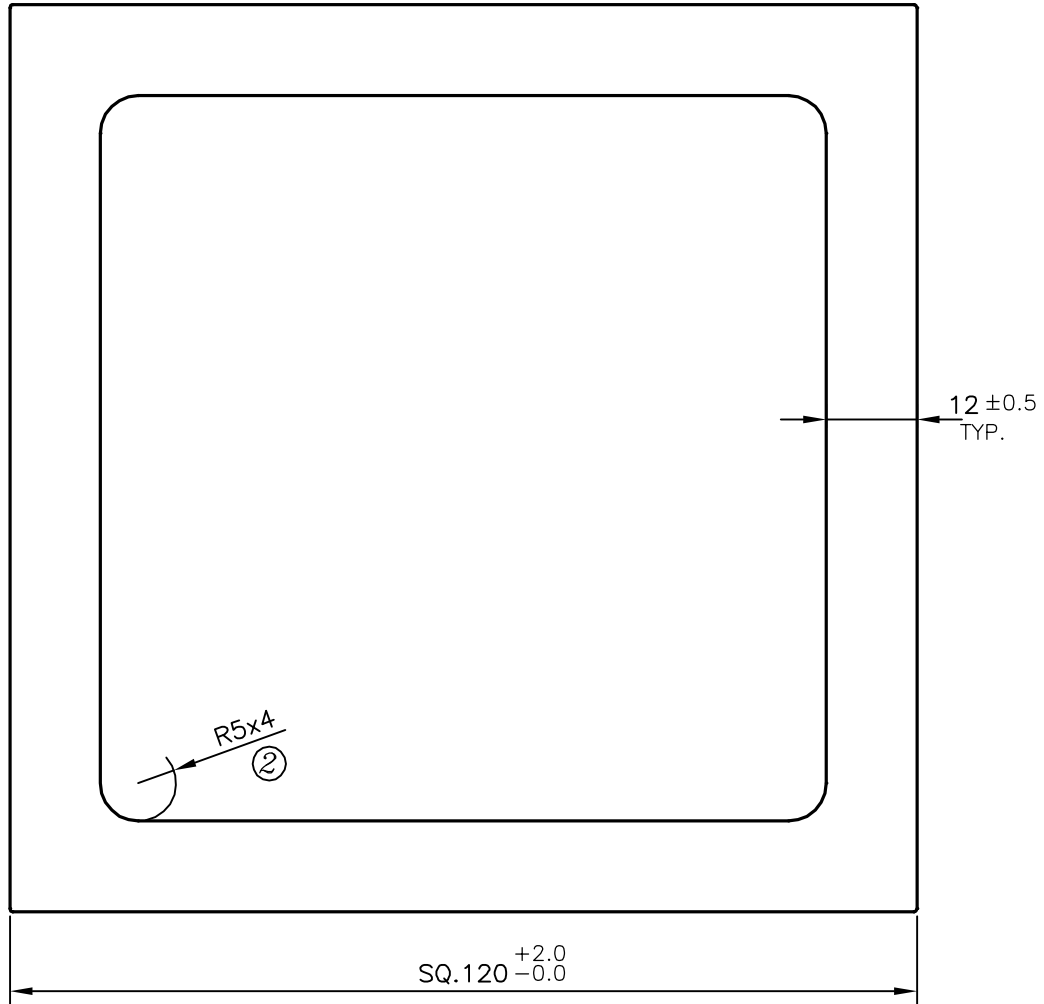


P-13078-2

S3906

15260



ISSUE (2) :-

- ☞ RADIUS CHANGED 0.4 mm TO 5.0 mm.
- ☞ WEIGHT ALSO CHANGED FROM 13.997 Kg/M TO 14.054 Kg/M.

ISSUE (3) & (4):-

- ☞ SECTION SPECIFICATION & CHEMICAL COMPOSITION ADDED.
- ☞ TOLERANCE ON LENGTH 3000 mm. = $\begin{matrix} +9.0 \\ -0.0 \end{matrix}$

CHEMICAL COMPOSITION

SR. No.	MATERIAL	% RANGE
1.	Mg	0.8-1.2
2.	Si	0.4-0.8
3.	Mn	0.15 (max)
4.	Fe	0.7 (max)
5.	Cu	0.15-0.4
6.	Zn	0.25 (max)
7.	Ti	0.15 (max)
8.	Cr	0.04-0.35
9.	Al	Remainder

SECTION SPECIFICATION

1. CUT END SQUARENESS	:- 3 mm.
2. STRAIGHTNESS	:- 1.5 mm/M
3. SECTION TWIST	:- 1.5 mm/M
4. HARDNESS	:- 80 BHN (MIN.)
5. SURFACE ROUGHNESS	:- 7 Ra
6. 0.2% PROOF STRESS	:- 240 MPA (MIN.)
7. TENSILE STRENGTH	:- 260 MPA (MIN.)
8. ELONGATION % ON 50 mm G.L.	:- 10% (MIN.)



SYMBOL OF QUALITY
AN ISO 9001 COMPANY

JINDAL ALUMINIUM LTD.
BANGALORE-560073 (INDIA)

	NAME	DATE
DRAWN	PARVESH	18-01-2014
CHECKED		
APPROVED	S.S.GARG	09-11-2011

- ALL DIMENSIONS ARE IN mm.
- ROUND OFF ALL SHARP CORNERS WITH 0.40 mm.
- TOLERANCES WILL BE AS PER BS:EN-755-9, UNLESS OTHERWISE SPECIFIED

SCALE	1:1
AREA mm ²	5205.323
PERIMETER mm.	479.313
WEIGHT kg/m	14.054

PARTY'S NAME	PRECISION AUTOMATION & ROBOTICS INDIA LTD., PUNE	DRAWING No.	P-13078-2	SECTION No.	-
PARTY'S DRAWING No.	AS PER SPECIFICATION		S3906		S3906 (ISSUE-4)
ALLOY & TEMPER	6061 T6		15260		15260
DESCRIPTION	SQUARE TUBE				