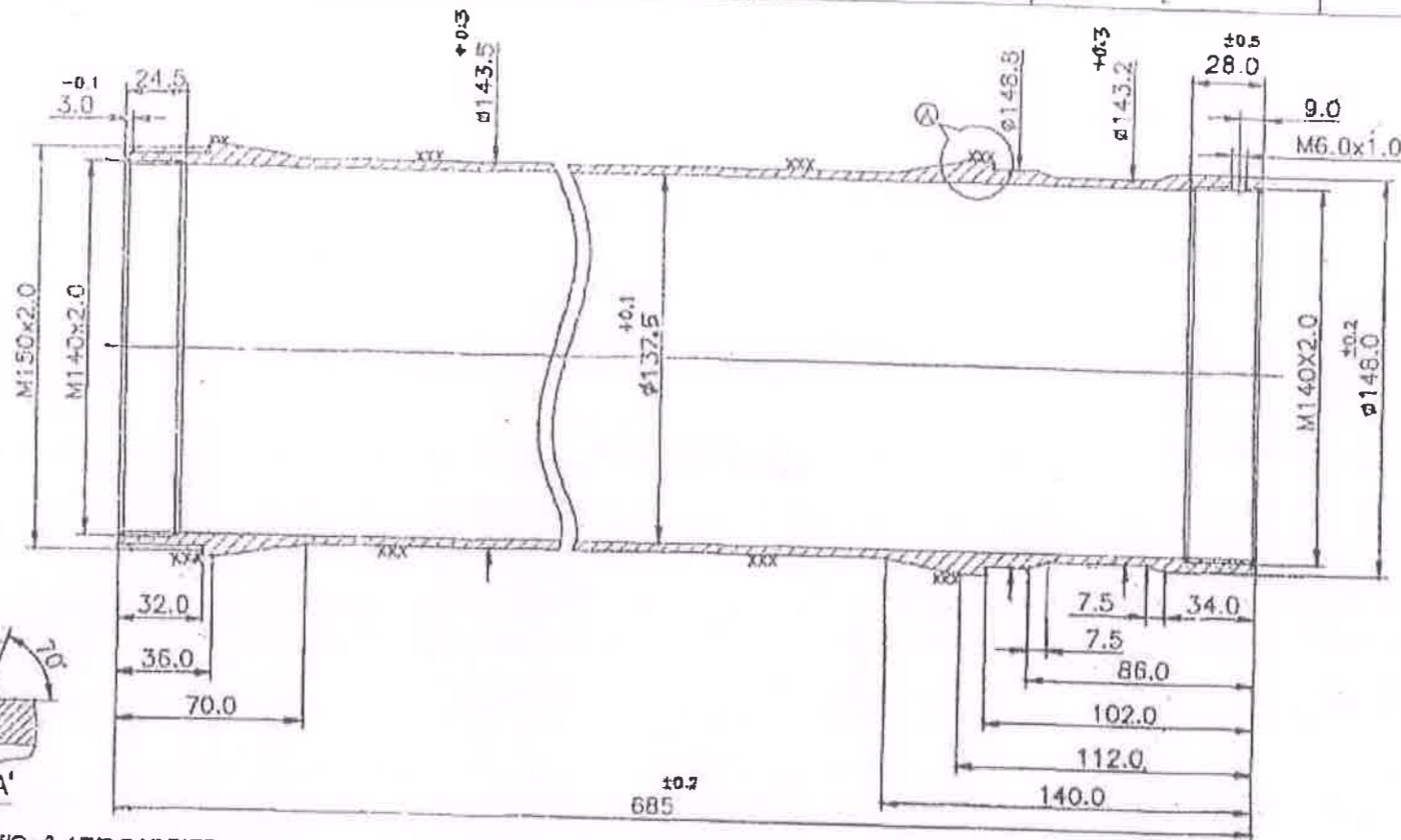
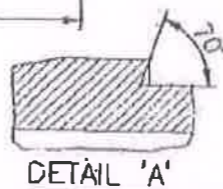
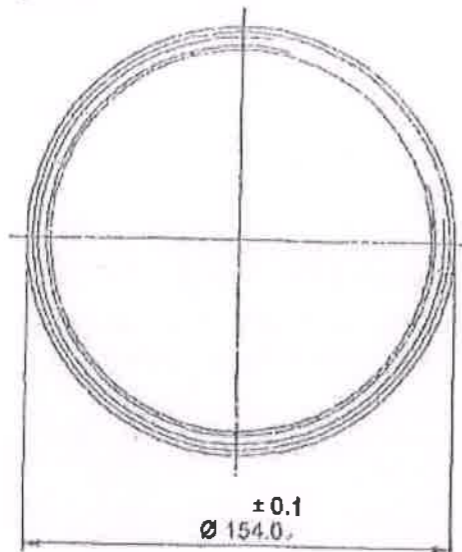


**REFERENCE**



**NOTES:**

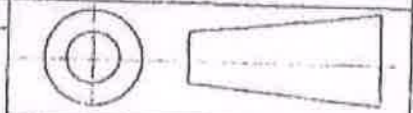
1. HYDRAULIC PRESSURE TEST OF  $315 \pm 5 \text{ Kgf/Cm}^2$  ARE CARRIED OUT AS ACCEPTANCE TEST FOR DURATION OF 1 MINUTE FOR 100% STORES.
2. HARDENED AND TEMPERED (TURNED OR GROUND) IN 'W' CONDITIONS.
- 3(a). PROOF PRESSURE TEST OF  $420 \pm 5 \text{ Kgf/Cm}^2$  FOR DURATION 10 SEC, BE CARRIED OUT AS QUALIFICATION TEST ON ONE MOTOR FOR LOT SIZE QUANTITY  $\leq 100$  NOS.
- (b) BURST PRESSURE TEST TO BE CONTINUED AFTER SATISFACTORY PROOF PRESSURE TEST AND VALUE BE RECORDED. TEST MAY BE DISCONTINUED AFTER ACHIEVING  $520 \pm 10 \text{ Kgf/Cm}^2$ , IN CASE OF SAFETY/ SYSTEM LIMITATIONS, WITH CONCURRENCE OF INSPECTING AUTHORITY.
4. SURFACE TO BE PHOSPHATED TO IS : 3618 CLASS B
5. INTERNAL SURFACE TO BE COATED UNIFORMLY WITH ZIRCONIUM SILICATE TO APPENDIX 'C' OF SPECN ARDE/SPECN/334/1985 EXCEPT THREADS. DIMENSION  $137 \pm 0.1$  TO BE MAINTAINED AFTER COATING OR APC 216 TO SPECN JSS : 8010-51 : 00.
6. EXTERNAL SURFACES MARKED XXX TO BE PAINTED WITH PU PAINT DOVE GREY (ISC NO 694 TO IS : 5) EXCEPT THREADED SURFACES.
7. 100% ULTRASONIC TEST AS PER IS : 8791/98 CLASS-'B' TO BE CARRIED OUT.

**ISSUED BY**  
**STANDARD CELL**  
 for EOI  
 DATE: 9/6/19  
 SIGNATURE:

DCA No 1340000563

29-9-16	NOTES AMENDED	ARD 2511	<i>Moud</i>	SCALE: NTS	DIMENSIONS ARE IN mm	TOL	D.S.CAT No	ASSY.DRG.No.
01-5-14	ALTERNATE PROTECTIVE COMPOSITION & SPECIFICATION ADDED	ARD 2459	<i>P.S.</i>	EGH	DRN P. Singh	---	CHD.	ASSY.DRG.LIST No.
13-02-14	DRAWINGS AMENDED	ARS 2453	<i>P.S.</i>	PASSED	APPROVED	---	---	---
14-1-11	NOTE - 5 AMENDED	ARD 2413	<i>P.S.</i>	---	---	---	---	---
08-09-09	DCA No ADDED	ARD 2396	<i>P.S.</i>	---	---	---	---	---
02-06-09	APPROVED	---	---	---	---	---	---	---
R.No	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS	MATL SPEC. - EN 19 HARDENED & TEMPERED	PROTECTIVE FINISH	GAUGE SCHEDULE No.

THREADS TO CONFIRM IS 421B  
 GEN.SPEC. IS 2102  
 STORE SPEC. NO.  
 STORES REF No.



DRG.No.  
**NASK 1069**  
 (PROVISIONAL)

**CHAMBER AFT MOTOR**

TRIM ON THIS LINE WHEN SUPPLIED TO TRADE