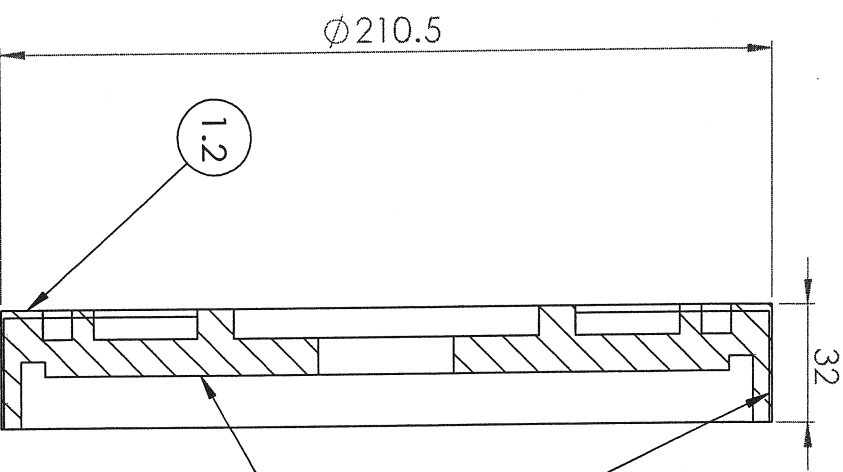
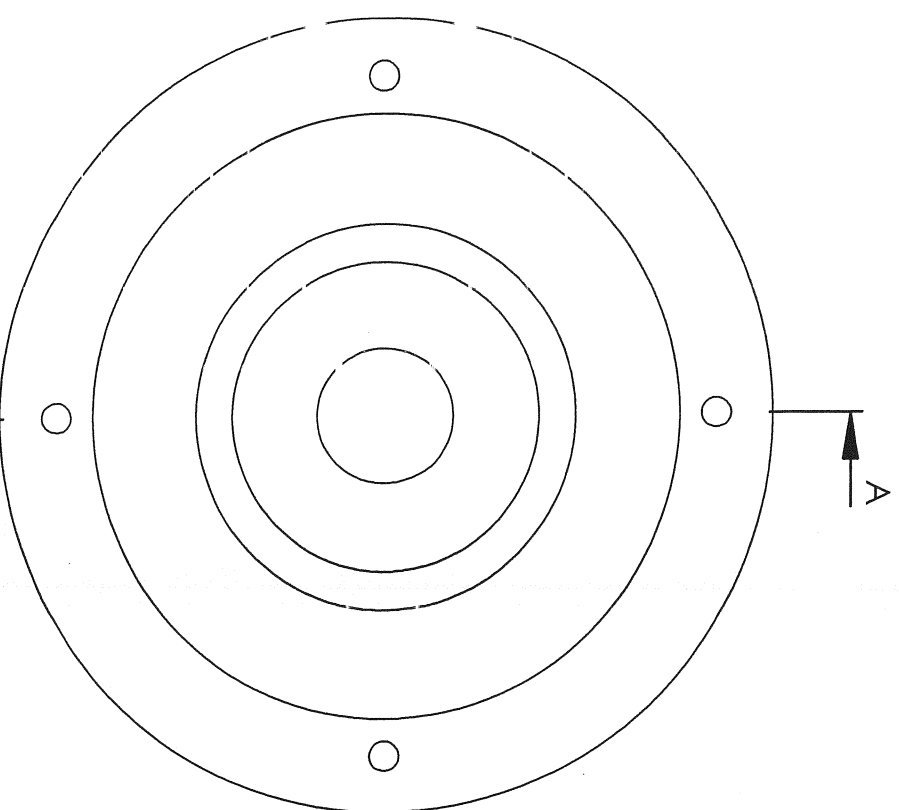


GEN. TOL. MEDIUM CLASS TO IS:2102 UNLESS OTHERWISE STATED



SECTION A-A

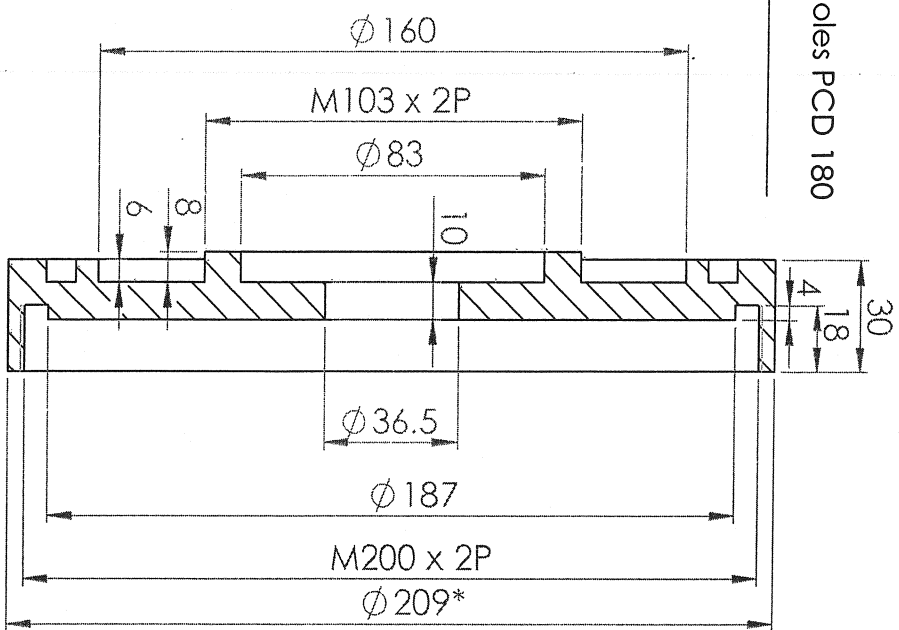
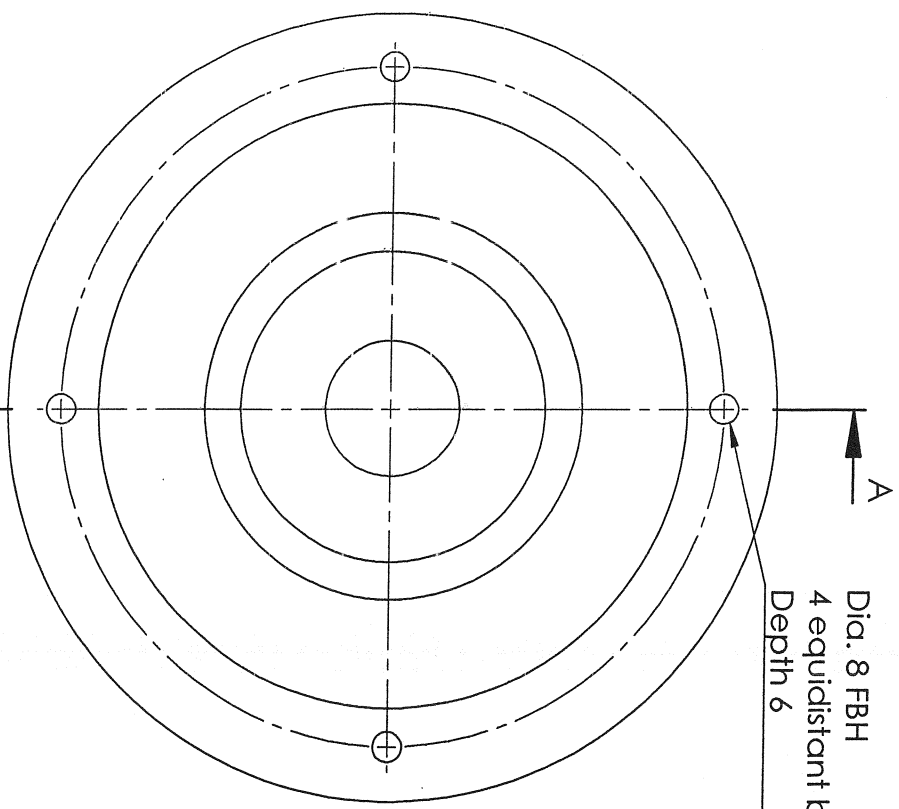
ITEM NO.	DESCRIPTION	QTY.
1.1	Cap	1
1.2	Rim	1

Note:

1. After bonding, Araldite must be allowed to cure for minimum 12 hrs.
2. After curing, trial assembly of the cap on the nozzle must be carried out. The cap must get smoothly assembled on the nozzle.
3. Bonding shall be carried out as per document no. HEMRL/IGN/PIN/ALPHA/1

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS		FINISH:		DEBUR AND BREAK SHARP EDGES	
SURFACE FINISH:				PART NO.: 1	
TOLERANCES:				REVISION	
LINEAR:					
ANGULAR:					
DRAWN	NAME	SIGNATURE	DATE	TITLE:	
CHKD	N.B. Dobhinkar	<i>[Signature]</i>	13/07/22	Cap & Rim Assembly	
APPVD	R.S. Patil	<i>[Signature]</i>	13/7/22	DWG NO. HEMRL/IGN/ALPHA/2022/01	
MFG				A4	
QA				SCALE: 1:2 SHEET 2 OF 13	

GEN. TOL. MEDIUM CLASS TO IS:2102 UNLESS OTHERWISE STATED



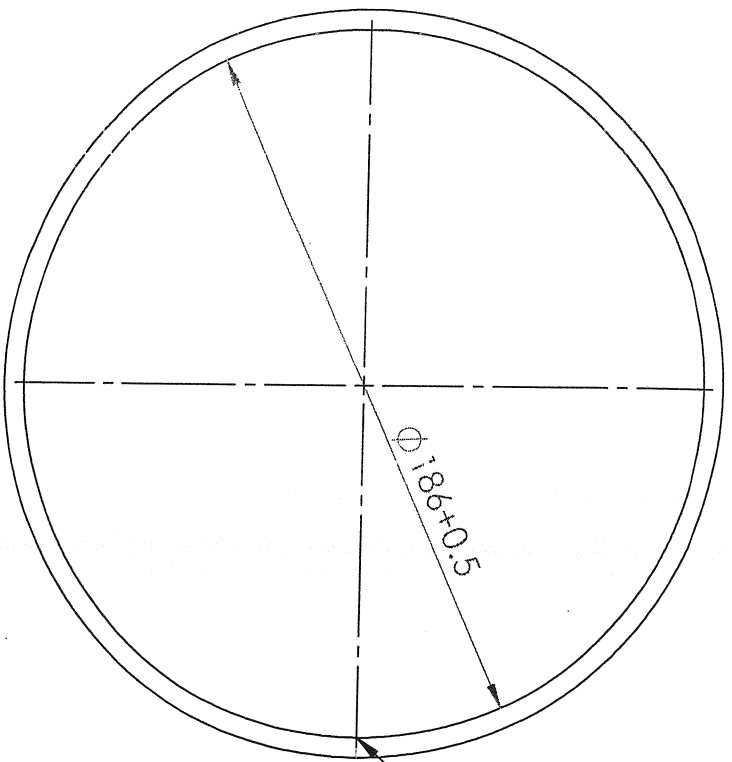
* : Tolerances to be matched with mating component by OD machining to achieve a gap of 50 micron for alraldite bonding

SECTION A-A

- Note:**
1. MATERIAL: FIBER GLASS REINFORCED MOULDING POWDER TO IA:1330, APPENDIX 'D'
 2. BARCOL HARDNESS ON MOULDING SHOULD NOT BE LESS THAN 50 AND SHORE 'D'-60

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS		FINISH:	
SURFACE FINISH:		DEBURR AND BREAK SHARP EDGES	
TOLERANCES:		PART NO. 1.1	
LINEAR:		REVISION	
ANGULAR:			
DRAWN	NAME	SIGNATURE	DATE
CHKD	M.B. Dhanasekhar	Signature	30/07/22
APPRD	E.S. Padmanabhan	Signature	13/7/22
MFG	QA		
MATERIAL: See Note		DWG NO. HEMRL/IGN/ALPHA/2022/01	
WEIGHT: 820 g (approx.)		SCALE: 1:2	
		SHEET 3 OF 13	
		A4	

Cap Closing



CHORD DIA. 5.4 + 0.15

GEN. TOL. MEDIUM CLASS TO IS:2102 UNLESS OTHERWISE STATED

NOTES:

1. MATERIAL: FLUORINATED ELASTOMER (HK) TO ASTM D 2000-05
2. MECHANICAL PROPERTIES:
 - I. HARDENESS: 80 +- 5 SHORE A
 - II. TENSILE STRENGTH (min): 10 MPa
 - III. ELONGATION AT BREAK(min): 150%
 - IV. COMPRESSION SET: NOT EXCEED TO 25% AT 70 DEG FOR 24 HRS (SPECIAL REQUIREMENT)
3. 'O' RING SHOULD BE FREE FROM POROSITY, VOIDS & SURFACE IMPERFECTION'
4. 'O' RING SHOULD RETAIN ITS PHYSICAL PROPERTIES BETWEEN -20 DEG C TO 55 DEG C
5. 'O' RING COLOUR: BLACK

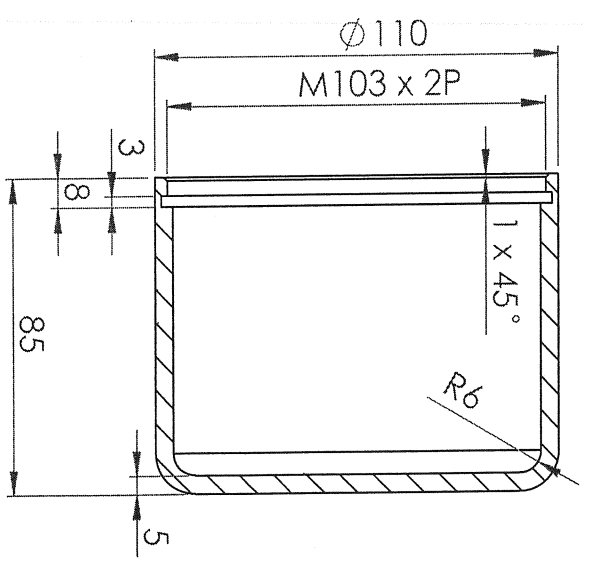
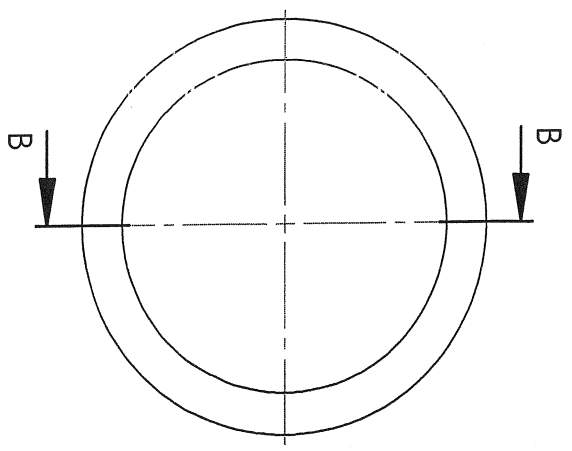
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS			FINISH:	
SURFACE FINISH:				
TOLERANCES:				
LINEAR:				
ANGULAR:				
DRAWN	NAME	SIGNATURE	DATE	
CHKD	N.B. David	<i>[Signature]</i>	13/07/25	
APPVD	R.S. Panch	<i>[Signature]</i>	17.3.25	
MFG				
Q.A				
MATERIAL:				
Refer Note				
WEIGHT:				
DWG NO.			HEMRL/IGN/ALPHA/2022/01	
TITLE:			O-ring	
PART NO.:			9	
DEBUR AND BREAK SHARP EDGES			REVISION	

SCALE:1:5

SHEET 12 OF 13

A4

GEN. TOL. MEDIUM CLASS TO IS:2102 UNLESS OTHERWISE STATED



SECTION B-B

- Note:**
1. MATERIAL: FIBER GLASS REINFORCED MOULDING POWDER TO IA:1330, APPENDIX 'D'
 2. BARCOL HARDNESS ON MOULDING SHOULD NOT BE LESS THAN 50 AND SHORE 'D'-60

UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN MILLIMETERS			FINISH:		DEBUR AND BREAK SHARP EDGES	PART NO.: 10	REVISION
SURFACE FINISH: TOLERANCES: LINEAR: ANGULAR:							
DRAWN	NAME	SIGNATURE	DATE				
CHKD	N.R. Subramanian	[Signature]	13.07.22				
APPRVD	N.R. Subramanian	[Signature]	13.07.22				
MFG							
QA							
MATERIAL: See Note				DWG NO.: HEMRL/IGN/ALPHA/2022/01			
WEIGHT: 250 g (approx.)				SCALE: 1:2			
				SHEET 13 OF 13			

Protective cap

A4