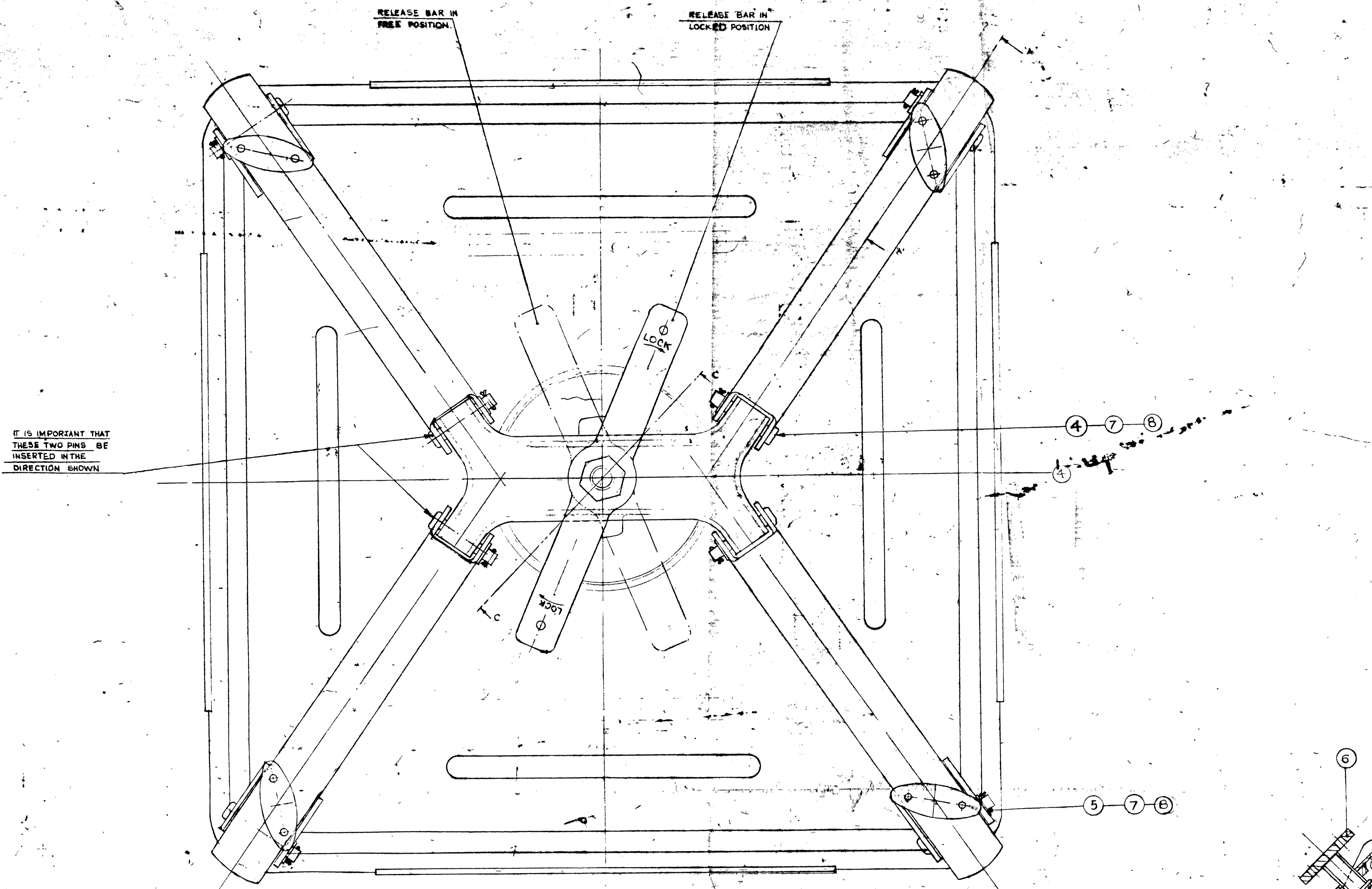
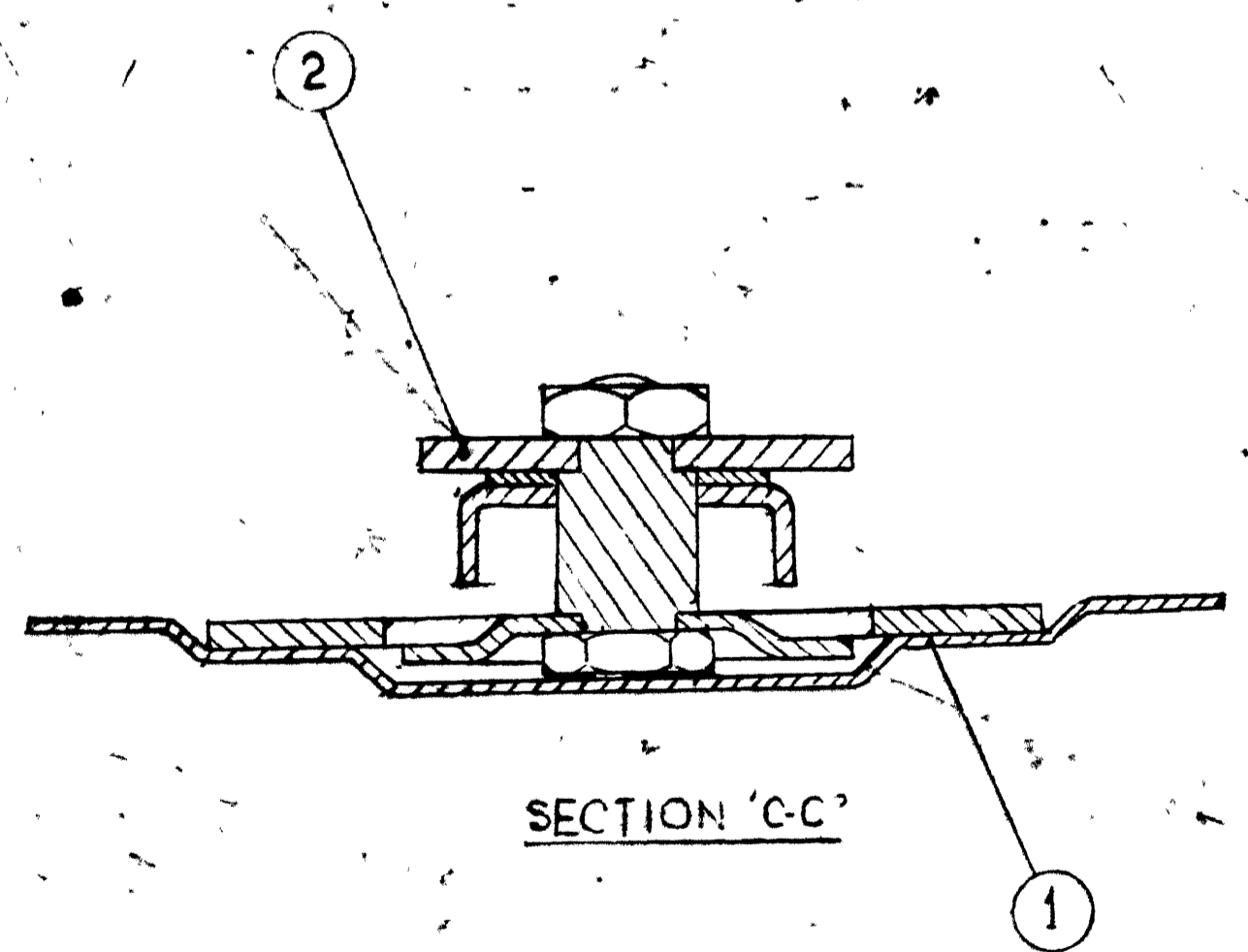


DRG No. ARDE 2039  
 PART No. 1  
 DET No. 14 SHTS 18 HT No. 4

LIST OF COMPONENTS					
S. No.	NOMENCLATURE	QTY	DRG No.	DET. No.	MATL. PART No.
1	LID (WELDING ASSY)	1	ARDE 2039	2	
2	PRESSURE PLATE SUB ASSY	1	32 32 32	3	
3	ARM	4	32 32 32	12	
4	PIN 'A'	4	ARM1253MM		
5	PIN 'B'	4	32 32 A16		
6	BOLT	4	32 32 A16		
7	SPLIT COTTER PIN 2.5 X 14 IS: 549	12	ND, PLATED		
8	PUNCHED WASHER M7 15: 2016	8	ND, PLATED		
9	RING, RUBBER	1	ARDE 2039	11	



IT IS IMPORTANT THAT THESE TWO PINS BE INSERTED IN THE DIRECTION SHOWN



PART SECTION 'A-A'

- PROTECTIVE FINISH**
- a) PHOSPHATED TO IS: 2618 CLASS A1.
  - b) TO BE PAINTED EXTERNALLY AND INTERNALLY WITH ONE COAT OF READY MIXED PAINT AIR DRYING MATT. FOR GENERAL PURPOSES. RED OXIDE (IS: 446 TO IS: 5) BRUSHING/ SPRAYING/DIPPING TO SPECN. IS: 168.
  - c) TO BE PAINTED EXTERNALLY & INTERNALLY WITH ONE COAT OF READY MIXED PAINT, SEMI GLOSSY MATT FINISH, OLIVEGREEN TO SPECN. IS: 168 WITH LSC SHADE 220 OF SPECN. IS: 5.

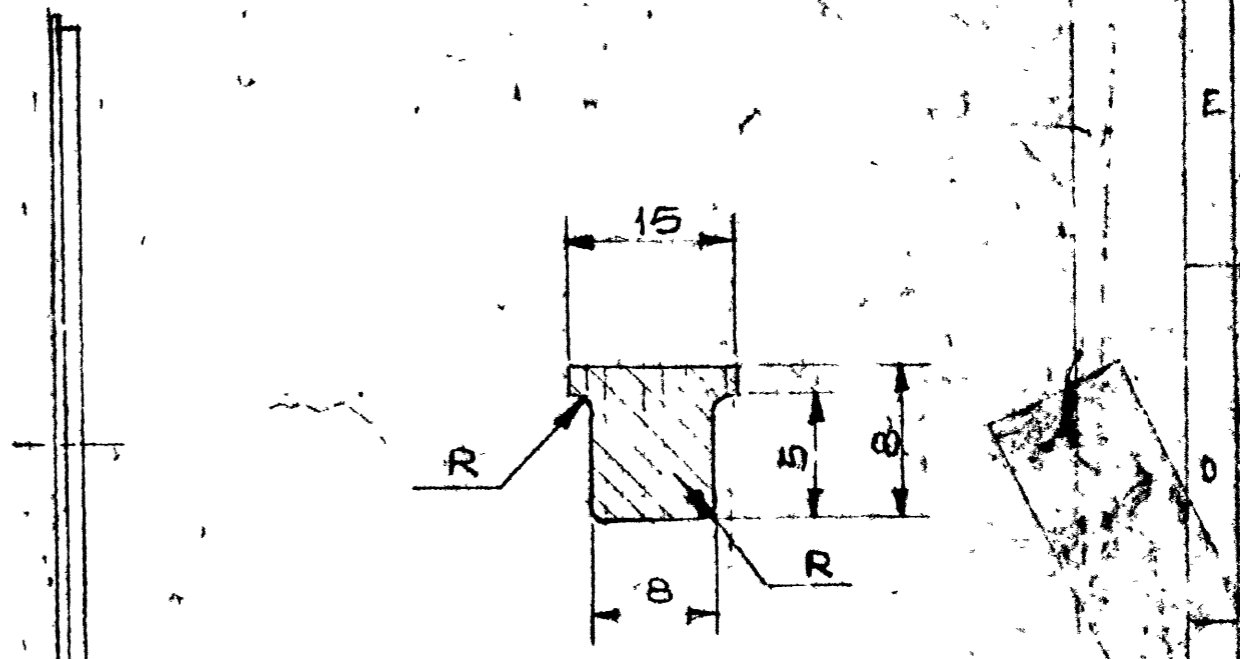
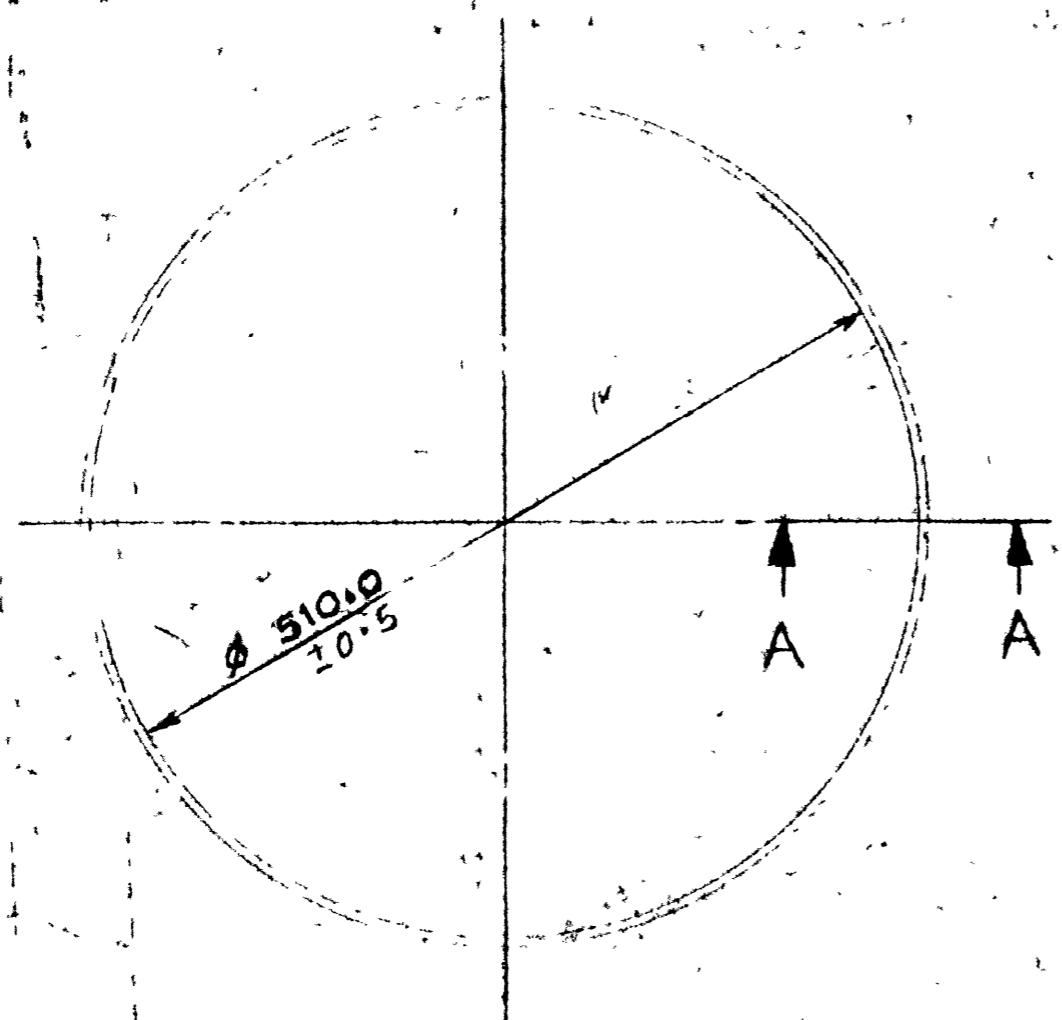
DRN No. 171187	CD PASSED	TRD No. 110	COMP. 110	ASSY DRG ARDE 2039 SHZ
DATE AUTHORITY	BRIEF RECORD	ZONE	CD GO	MATL
DRG SEATED	PROVISIONAL	DATE	15-7-80	SCALE 1:1
DRG AMENDED VIDE AL No 586				DESIGN AUTHORITY
APPROVED FOR DISCRETION				ARDE PUNE-21
PROTECTIVE FINISH AS ABOVE				DRG No. ARDE 2039
				DET No. 14 SHTS 18 HT No. 4
				PART No.
				D. S. CAT No.
				AHSP

SEALING LID-ASSEMBLY




PART NO. ON LHS  
 DET NO. II ON SHTS  
 DRG. NO. ARDE 2039  
 GRG CONVENTIONS CONFORM TO IS: 696  
 DIM ARE IN MM  
 GEN. TOL MEDIUM CLASS TO IS 2102

**NOTE:**  
 RING TO BE FREE FROM FLASH.  
 PRESERVED IN TALKDUST, TO BE COATED  
 WITH SILICON GREASE BEFORE ASSY



PART SECTION 'A-A'  
 (SCALE 2:1)

**MATL:**  
 NEOPRENE RUBBER TO SPEC IND/ME/BB4  
 (PROV.) HARDNESS 50 TO 55

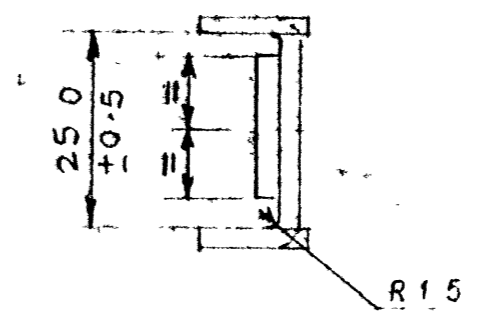
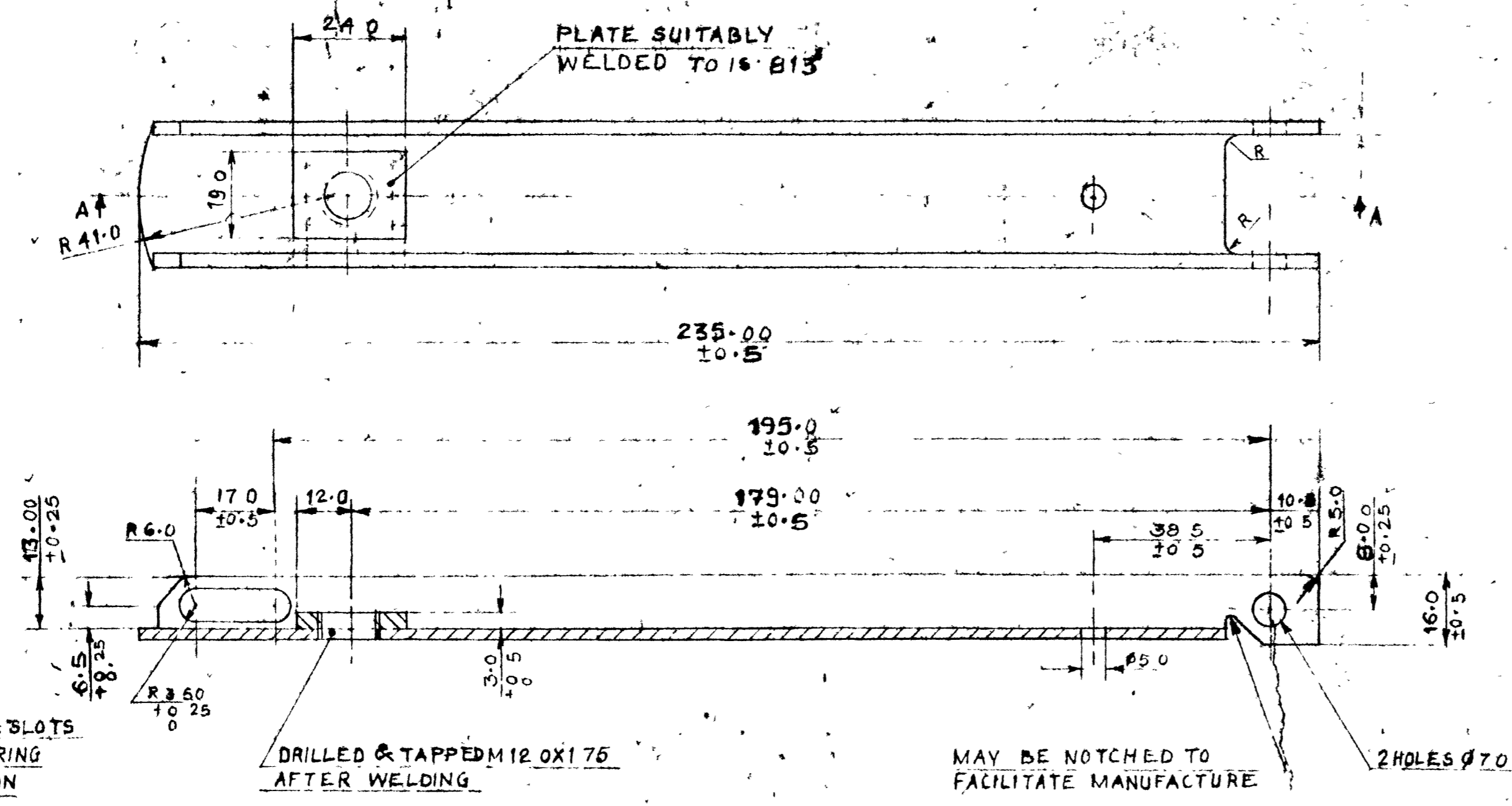
R No		DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO	MATL	PROTECTIVE FINISH	DET. <i>[Signature]</i> C.D. <i>[Signature]</i> APPROVED <i>[Signature]</i> FOR DIRECTOR	END. <i>[Signature]</i> PASSED <i>[Signature]</i> SCALE: 1.5 EST. WEIGHT GAUGE SCHD DATE 15-7-86	ASSY. DRG ARDE 2039 SHT 4 DESIGN. AUTHORITY ARDE, PUNE-21  DRG No ARDE 2039
DRG SEALED		<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>				AS ABOVE				DET No II   SHTS   SHT No PART No D S CAT No AHSP

RING RUBBER

DRG NO	ARDE 2039
DET. NO. 12	SHTS. 1
PART NO	ON PART
DRG CONVENTIONS CONFORM TO IS. 696	
DIM. ARE IN MM	
GEN. TOL. MEDIUM CLASS TO IS. 2102	

NOTE:-  
ALL SHARP EDGES & BURRS ARE TO BE REMOVED

MATL  
MILD STEEL 2.5mm THICK TO SPEC. IS: 1079-Gd  
ST. 34 HOT ROLLED & ANNEALED.



PROTECTIVE FINISH  
a) PHOSPHATED TO SPEC IS: 3618 CLASS A 1

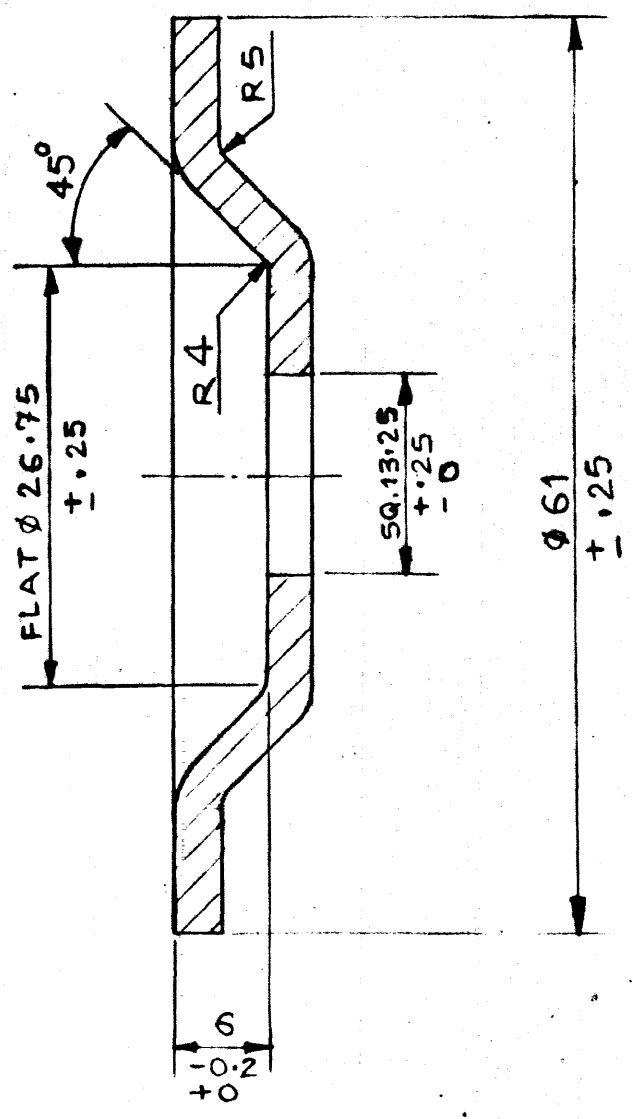
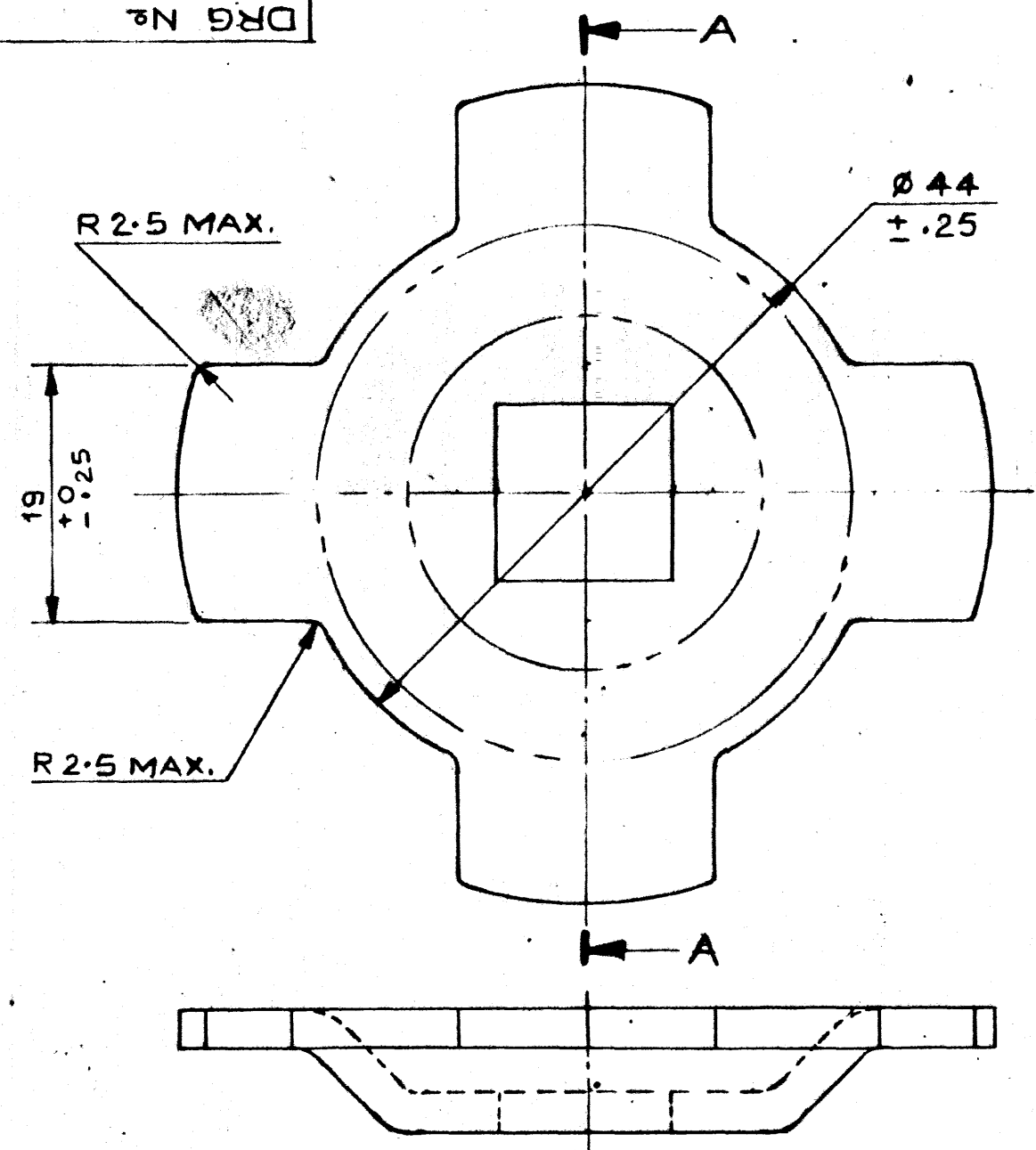
SECTION AA

DRN: <i>Prad</i>	CHD: <i>Prad</i>	TRD	COMP	ASSY. DRG ARDE 2039 SHT 4
C.D.	PASSED	SCALE: 1:1		DESIGN AUTHORITY
APPROVED	<i>Prad</i>	EST WEIGHT		ARDE, PUNE-21
FOR DIRECTOR	<i>Prad</i>	GAUGE SCHED		
MATL: AS ABOVE		DATE: 15-7-86		
PROTECTIVE FINISH: AS ABOVE				
BRIEF RECORD				DRG No
DATE	AUTHORITY	ZONE	C.D. GO SIGN	ARDE 2039
DRG SEALED: <i>Prad</i>				DET. NO. 12
				SHTS. 1
				SHT No
				PART No
				D.S. CAT No
				AHSP

ARM

DRG No  
ARDE 2039  
DET No 19  
SHTS  
PART No

DRG CONVENTIONS CONFORM TO IS: 696.  
DIMNS ARE IN mm.  
GEN. TOL :- MEDIUM CLASS TO IS: 2102.



SECTION 'A-A'

MATL:-

MILD STEEL SHEET 2.5 mm.  
THICK TO SPEC. IS: 1079  
Gd ST-34 HOT ROLLED  
& ANNEALED.

PROTECTIVE FINISH:-

PHOSPHATED TO  
SPEC. IS: 3618.  
CLASS A1.

NOTE:-

ALL SHARP EDGES  
& BURRS ARE TO  
BE REMOVED.

						DRN: SLL	CHD	TRD	COMP	ASSY DRG. ARDE 2039/9
						CD	PASSED	SCALE: 2:1		DESIGN AUTHORITY
1	19-488		AMENDED VIDE AL. NO. 600			APPROVED		EST MASS		ARDE PUNE 21
R No	DATE	AUTHORITY	BRIEF RECORD,	ZONE	CD GO	MATL:-	AS ABOVE	GAUGE SCHD		
DRG SEALED			PROV. BY	CREAM	SIGN	PROTECTIVE FINISH:- AS ABOVE		DATE: 15-7-86		

BASE PLATE

DRG No  
ARDE 2039  
DET No 19 | SHTS | SHT No  
PART No  
DS CAT No  
AHSP

DRG CONVENTIONS CONFORM TO IS: 696  
 DRG No. ARDE 2039  
 DRG PART No. ARDE 2039  
 DRG PART No. ARDE 2039  
 DRG PART No. ARDE 2039

DRG No. ARDE 2039  
 DRG PART No. ARDE 2039  
 DRG PART No. ARDE 2039

DRG No. ARDE 2039  
 DRG PART No. ARDE 2039  
 DRG PART No. ARDE 2039

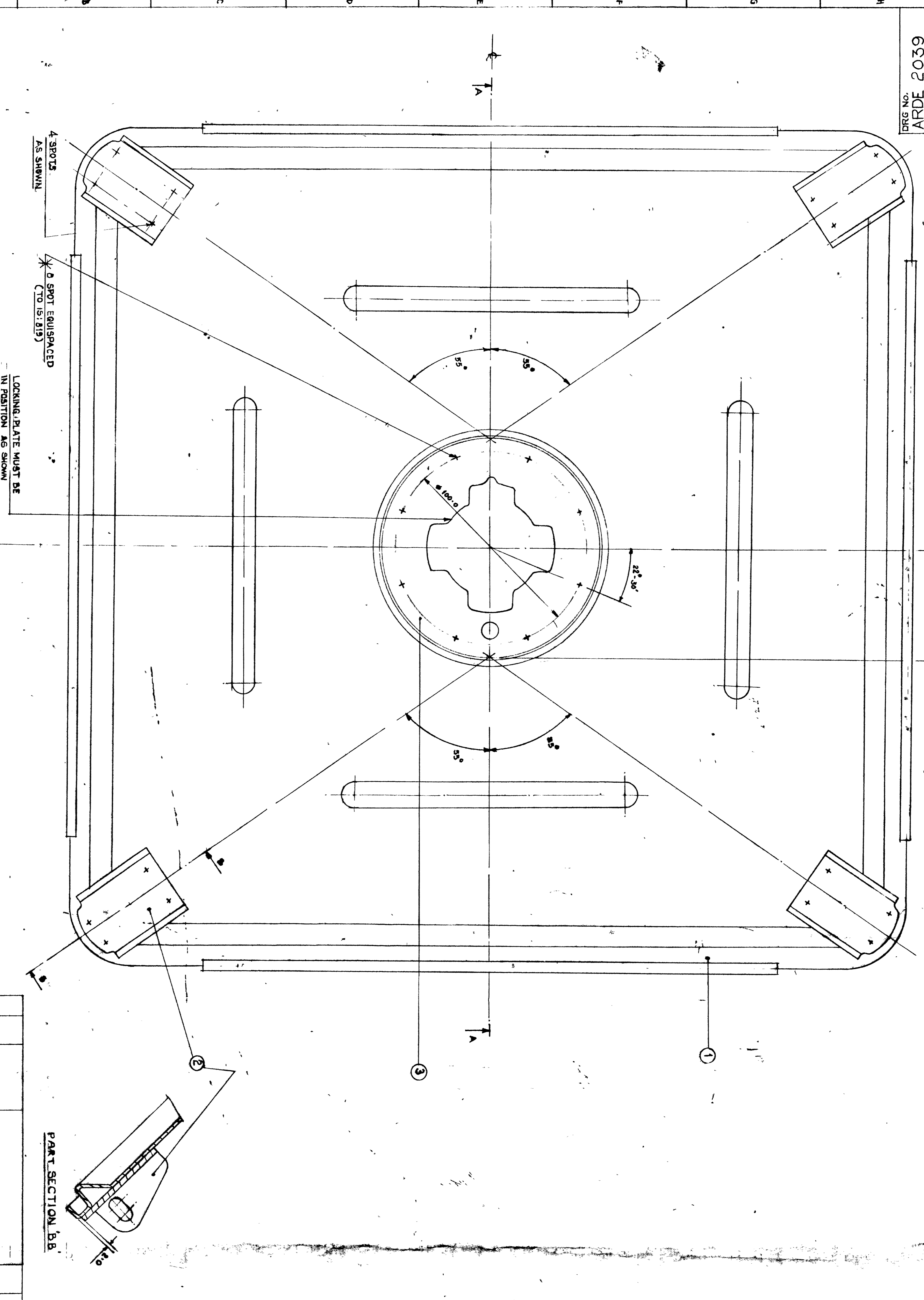
DRG No. ARDE 2039  
 DRG PART No. ARDE 2039  
 DRG PART No. ARDE 2039

DRG No. ARDE 2039  
 DRG PART No. ARDE 2039  
 DRG PART No. ARDE 2039

ITEM No.	NOMENCLATURE	MATL	DRG No.	DET. PART No.
1	LID	1	ARDE 2039	3
2	BRACKET	4	ARDE 2039	4
3	LOCKING PLATE	1	AS	5

**PROTECTIVE TREATMENT**  
 THE COMPONENTS OF THE SUB ASSY SHALL BE GIVEN THE FOLLOWING PROTECTIVE TREATMENT:  
 A) PHOSPHATED TO SPEC IS: 3618 CLASS A-1

**NOTE**  
 ALL WELDING JOINTS SHOULD BE AS PER TO SPEC IS: 618



4 SPOTS AS SHOWN  
 8 SPOT EQUISPACED (TO IS: 819)  
 LOCKING PLATE MUST BE IN POSITION AS SHOWN

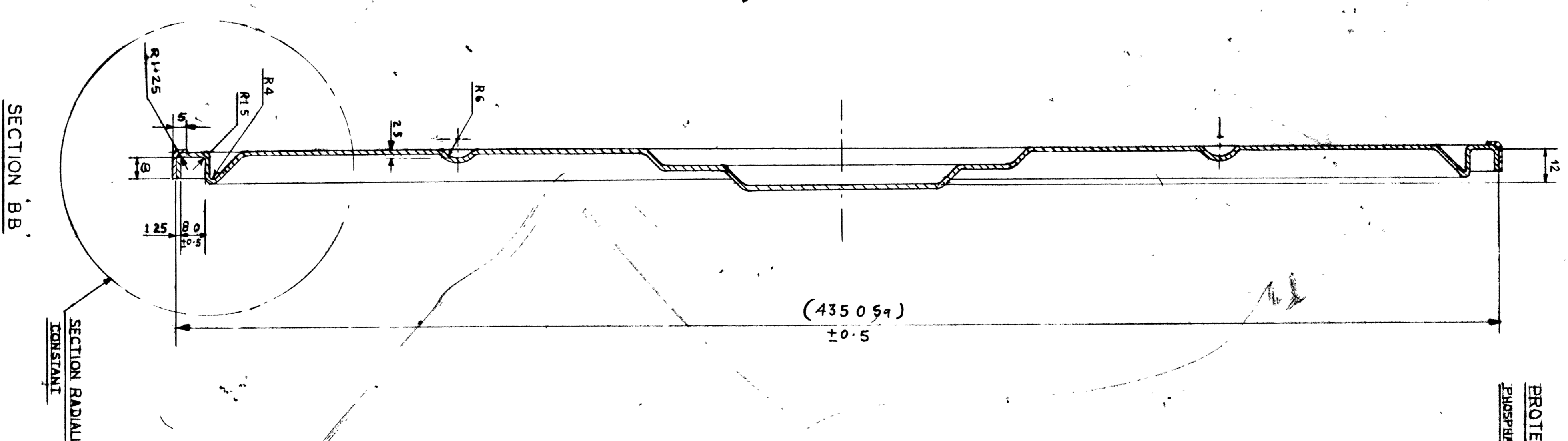
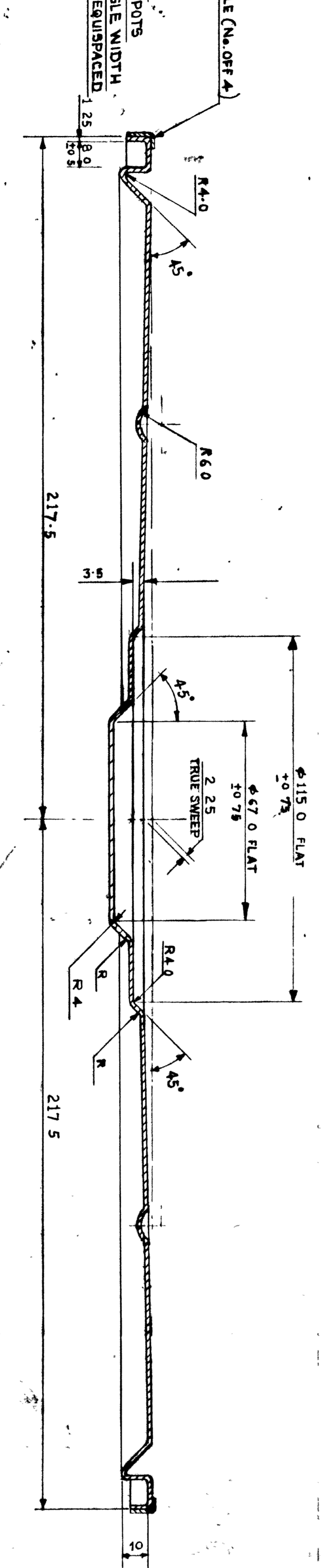
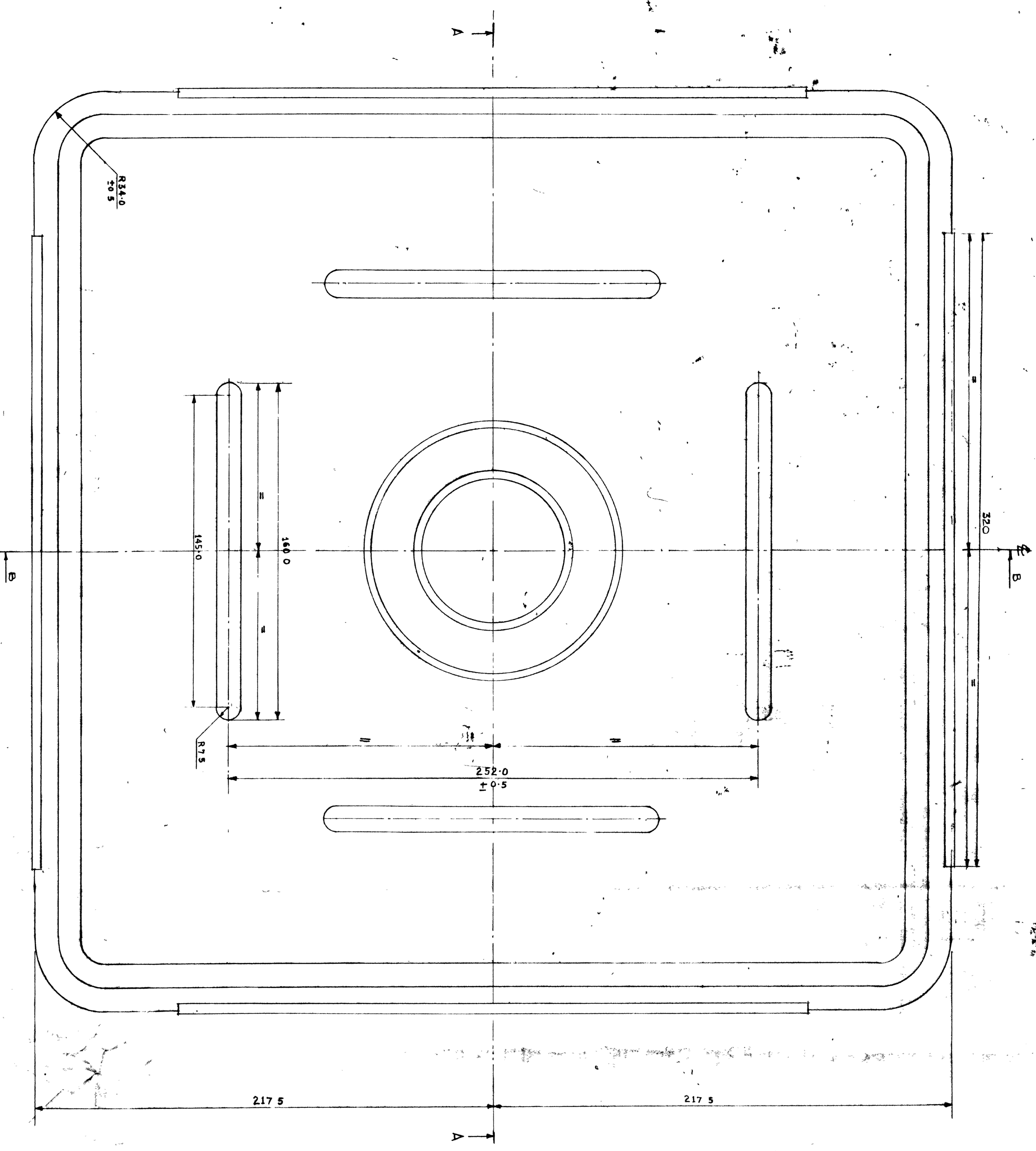
PART SECTION B.B

SECTION A.A

DRG No.	DET No.	SMTS	SMT No.
ARDE 2039	2		

LID (WELDING ASSY)

DRG No.	DET No.	SMTS	SMT No.
ARDE 2039	2		



0.57320X1.43 THICK STRENGTHENING ANGLE (No. OF 4)  
 1) SPOT DIA 5mm  
 2) EDGE DISTANCE TO BE MAX.  
 3) OBTAINABLE BY POSITIONING SPOTS  
 4) SPOTS IN RELATION TO ANGLE LENGTH  
 5) SPOTS IN RELATION TO 90 DEGREE  
 6) SPOTS PER ANGLE

SECTION A-A  
 SWEEP APPLIED TO ALL LONGITUDINAL SECTIONS

NOTE  
 ALL SHARP EDGES AND BURRS ARE TO BE REMOVED  
 MATERIAL  
 MILD STEEL 1.53 mm THICK SHOULD CONFORM TO ANY ONE OF THE FOLLOWING SPEC.  
 IS: 1079-43 Q&L ST 34 HOT ROLLED AND ANNEALED  
 IS: 515-43 COLD ROLLED AND ANNEALED TYPE D, BEST SURFACE

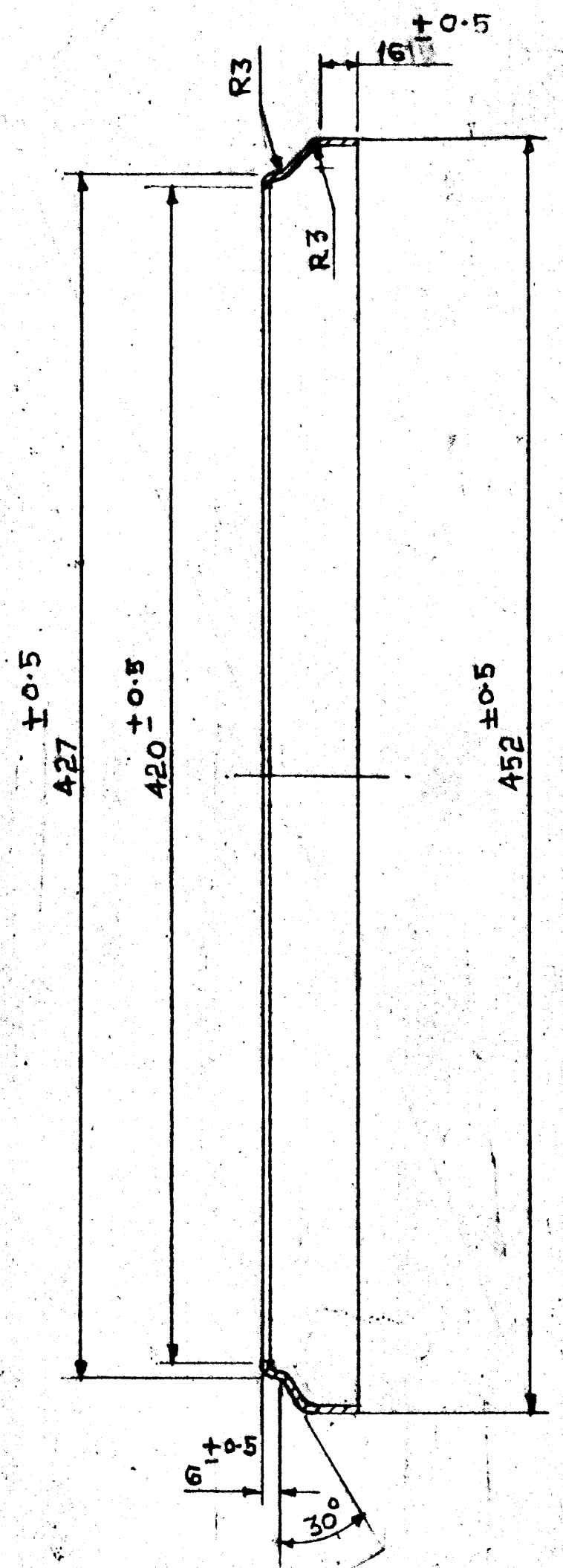
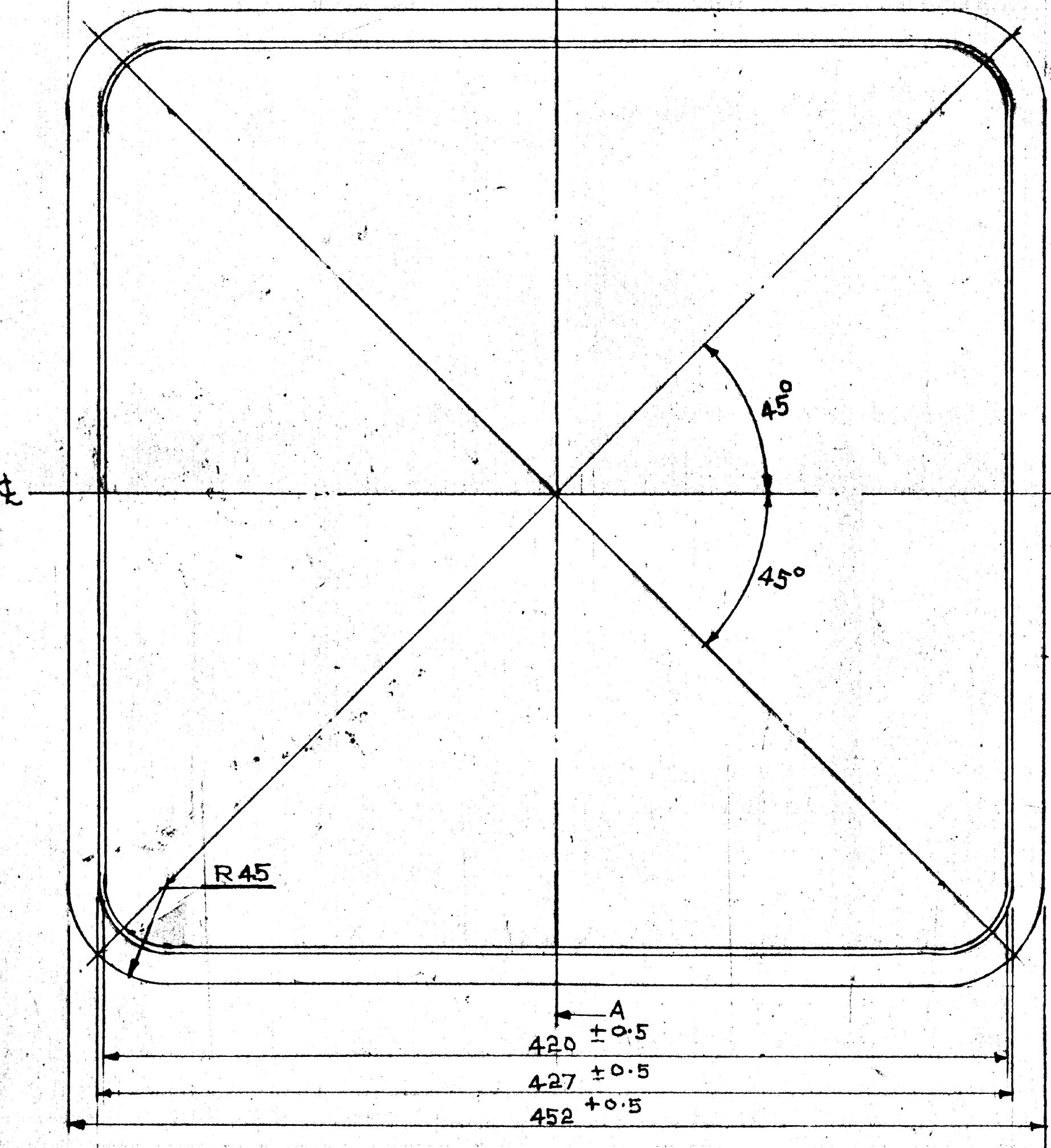
PROTECTIVE TREATMENT  
 APPROPRIATE TO SPEC IS: 3618 CLASS A1

DATE	19-01-88	APPROVED	AS ABOVE	PROTECTIVE FINISH	AS ABOVE
DESIGNED		CHECKED		DATE	19-01-88
DRAWN		SCALE	1:1	EST WEIGHT	
GAUGE		DATE			
TEST					
PASSED					
CONFORMS					
TO					
IS: 3618					
CLASS A1					

LID

ARDE 2039  
 PART No. 3  
 SHEET No. 1  
 OF 1

DRG No. ARDE 2039  
 DETN. No. 4  
 SHTS 8



**NOTE:—**  
 ALL SHARP EDGES AND BURRS  
 ARE TO BE REMOVED

**MATL:—**  
 MILD STEEL 1.25mm THICK SHOULD  
 CONFORM TO ANY ONE OF THE  
 FOLLOWING SPEC.  
 1) IS: 1079-63 Gd. ST 34 HOT ROLLED  
 AND ANNEALED  
 2) IS: 513-63 COLD ROLLED AND  
 ANNEALED TYPE D BEST SURFACE

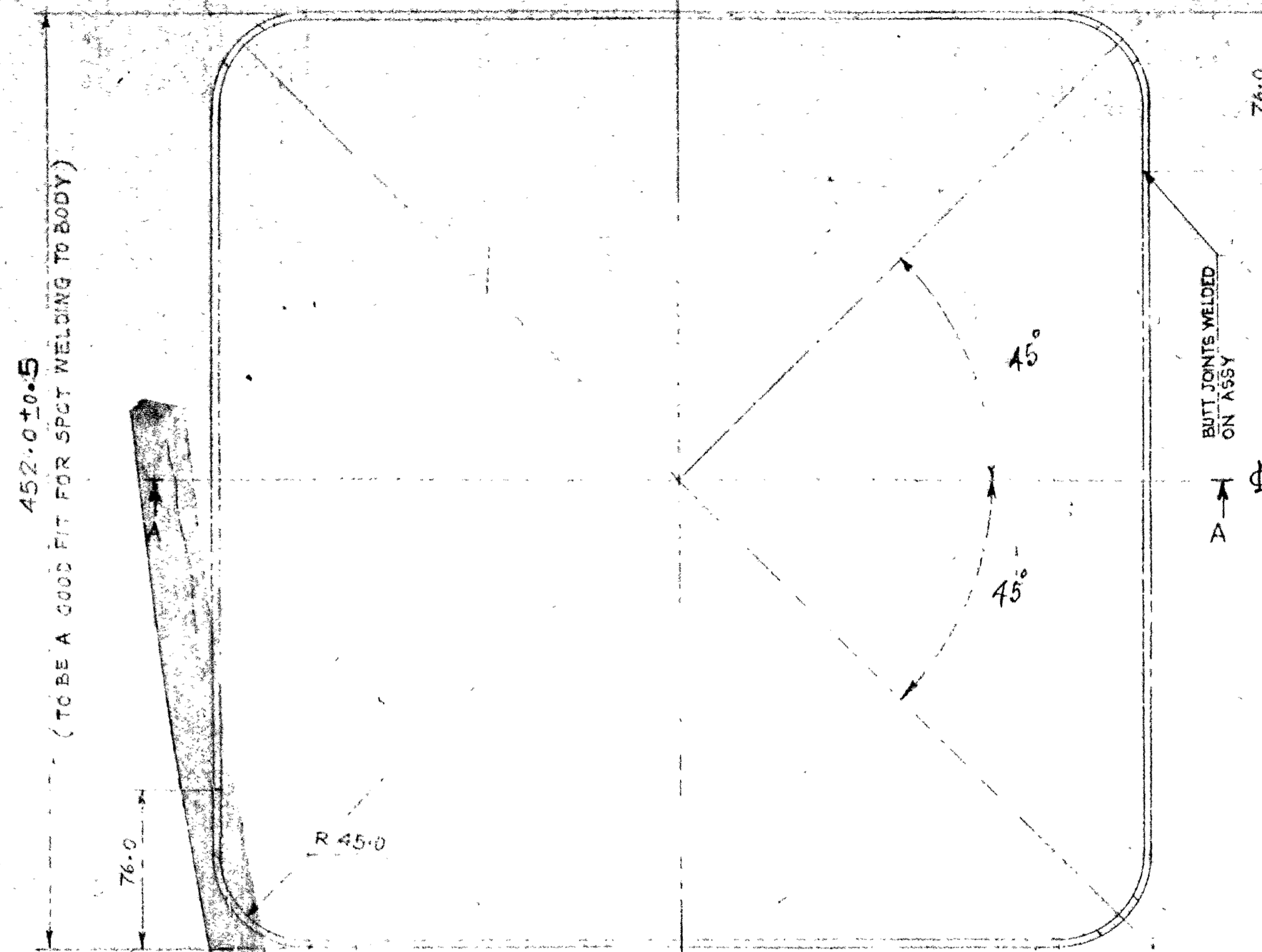
**PROTECTIVE FINISH:—**  
 PHOSPHATED TO SPEC IS: 3618  
 CLASS-A1

DRN	DSS	CHD	TRD	RMN	COMP	ASSY	DRG	ARDE 2039, SHTS
CD	MAH	PASSED	SCALE	1:2	EST WEIGHT	DESIGN	AUTHORITY	ARDE PUNE-21
APPROVED	FOR DIRECTOR	DATE	15-7-08	Gauge	SCHD			
MATL	AS ABOVE	PROTECTIVE FINISH	AS ABOVE					

**LID SEATING**

DRG No.	ARDE 2039
DET No.	4
SHTS	8
SHT No.	
PART No.	
DS CAT No.	
AHSP	

DRG. CONVENTIONS CONFORM TO IS 696  
DIM. ARE IN MM  
GEN. TOL. MEDIUM CLASS TO IS 2102  
DRG NO. ARDE 2039



452.0 ± 0.5  
(TO BE A GOOD FIT FOR SPCT WELDING TO BODY)

452.0 ± 0.5  
(TO BE A GOOD FIT FOR SPCT WELDING TO BODY)

58.0  
-0.5  
3.15

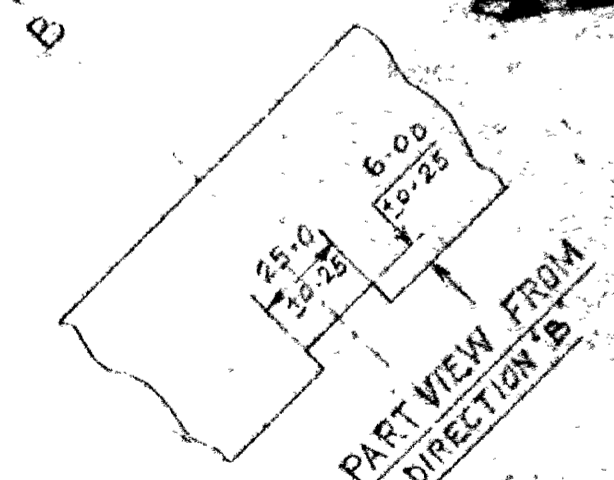
4 SLOTS TO EACH  
CORNER AS SHOWN

BUTT JOINTS WELDED  
ON ASSY

**MATERIAL**  
MILD STEEL 3-15 mm THICK TO SPEC 15:1079-G1  
ST 34 HOTROLLED & ANNEALED.

**PROTECTIVE TREATMENT**  
A PHOSPHATED TO SPEC 15:3618 CLASS A1

**NOTE** - 1) ALL SHARP EDGES & BURRS ARE TO BE REMOVED  
2) ALL WELDING JOINTS SHOULD BE AS PER TO SPEC 15:813



MAY BE MADE IN ONE PIECE  
IF DESIRED

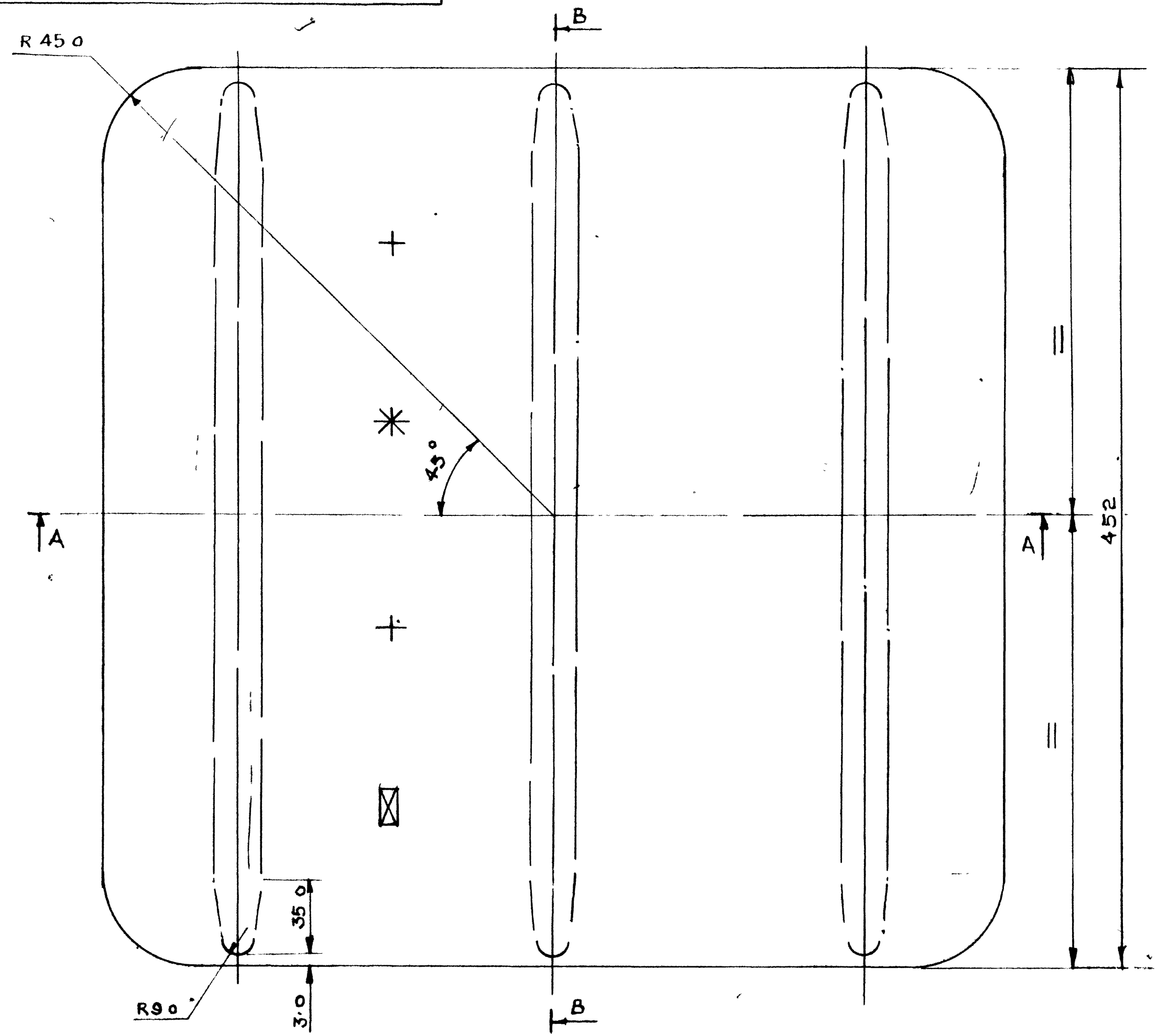
SECTION AA

DRN	CHKD	TRD	COMP	ASSY DRG. ARDE 2039-973
C D	PASSED	SCALE 1:2	EST WEIGHT	DESIGN AUTHORITY
APPROVED	FOR DIRECTOR	GAUGE SEND	DATE 15-7-86	ARDE, PUNE 21
R N	DATE	AUTHORITY	BRIEF RECORD	ZONE
DWG SEALED	Pmr	<i>[Signature]</i>	<i>[Signature]</i>	MATE
				AS ABOVE
				PROTECTIVE FINISH: AS ABOVE
				DRG. NO.
				ARDE 2039
				DET. SHTS
				SHT. No.
				PART. No.
				D.S. CAT. No.
				AHSP

RIM

10 9 8 7 6 5 4 3 2 1

DRG CONVENTIONS CONFORM TO IS: 696  
 DIM ARE IN mm  
 GEN TOL-MEDIUM CLASS TO IS: 2102  
 DRG No. ARDE 2039  
 DET No. 7 SHTS SHT No. 4

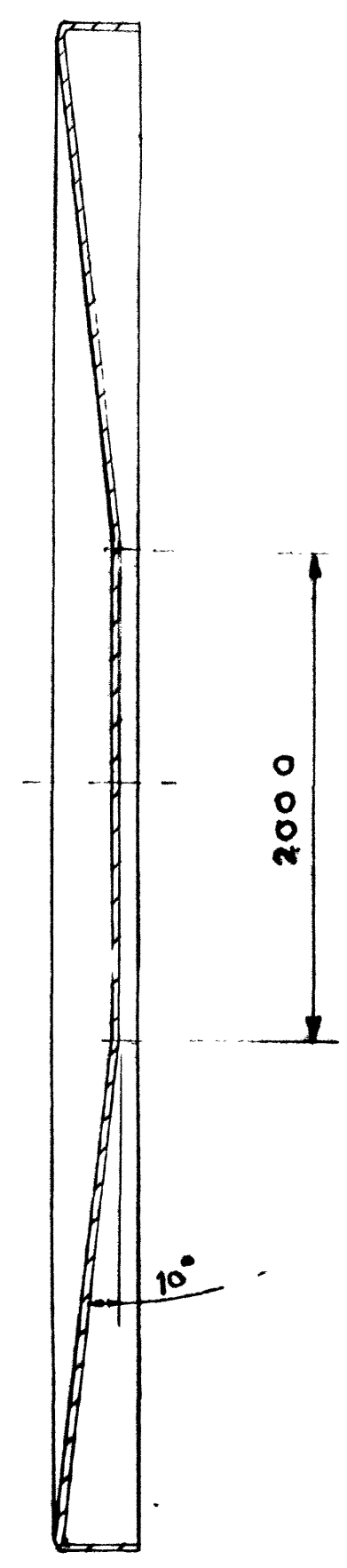


**NOTE:-**  
 ALL SHARP EDGES & BURRS ARE TO BE REMOVED.  
**MATL :-**  
 MILD STEEL 1.25 mm THICK SHOULD CONFORM TO ANY ONE OF THE FOLLOWING SPEC,  
 1 IS: 1079 Gd ST 34 HOT ROLLED AND ANNEALED  
 2 IS: 513 COLD ROLLED AND ANNEALED TYPE 'D' BEST SURFACE.

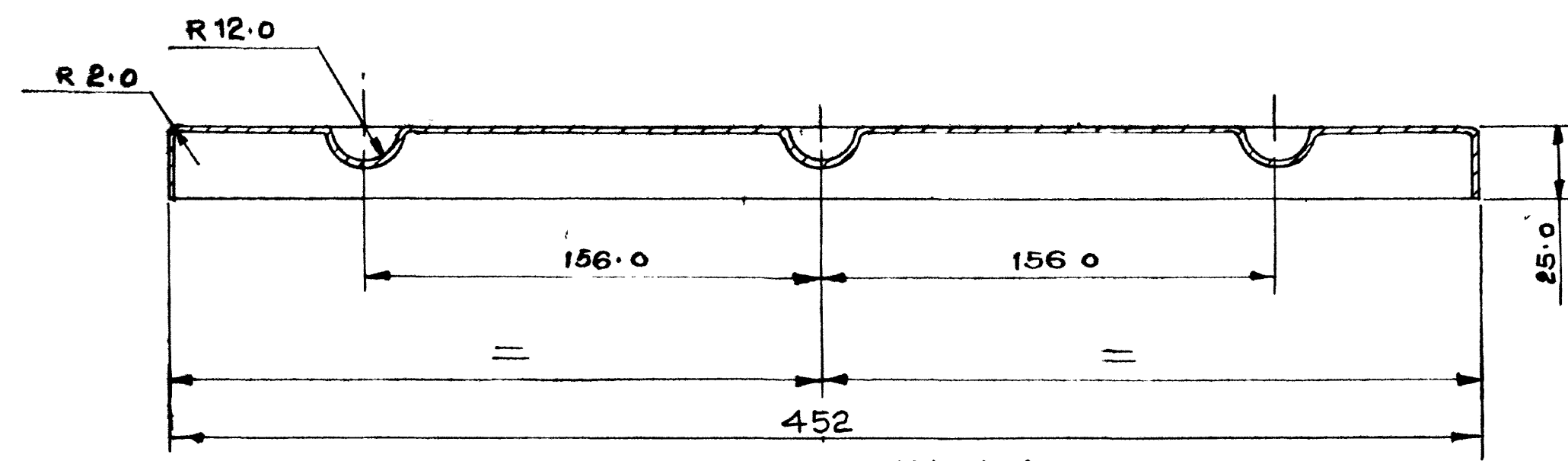
**PROTECTIVE TREATMENT -**  
 PHOSPHATED TO SPEC IS: 3610 CLASS A1

**MARKING TO BE EMBOSSED IN RECESS IN 12 mm LETTERING**

- ☒ SERIAL No. OF BOX AS APPLICABLE
- +
- MARK OF BOX AS APPLICABLE
- \*
- CONTRACTORS INITIALS, RECOGNISED TRADE MARK OR APPROVED INSPECTION STAMP
- +
- YEAR OF MANUFACTURE



SECTION-BB



SECTION A-A

DRN DSS	CHD	TRD	SVG	COMP	ASSY DRG ARDE 2039 SHT 4
CD	PASSED	SCALE	1/2	EST WEIGHT	DESIGN AUTHORITY
APPROVED	FOR DIRECTOR	Gauge	SCHD	DATE	15-7-86
MATL	AS ABOVE	PROTECTIVE FINISH	AS ABOVE		
R No	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD GO SIGN
DRG SEALED					

**BOTTOM**

ARDE PUNE-21  
 DRG No. ARDE 2039  
 DET No. 7 SHTS SHT No. 4  
 PART No.  
 D S CAT No.  
 AHSP

10 9 8 7 6 5 4 3 2 1

DRG NO	ARDE 2039
DET. NO	9
SHTS	4
PART NO	

DRG CONVENTIONS CONFORM TO IS. 696  
DIM ARE IN mm

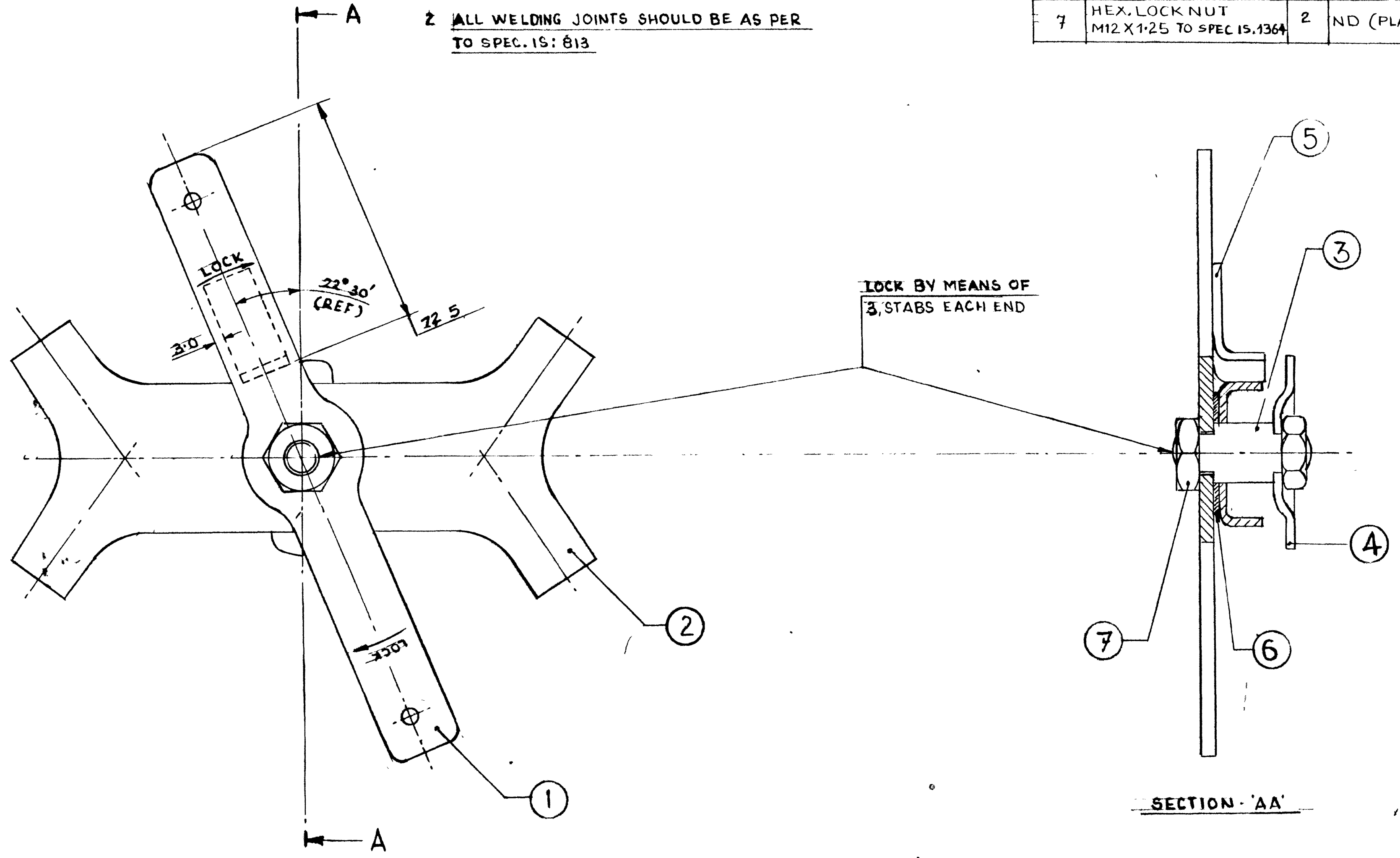
GEN TOL MEDIUM CLASS TO IS: 2102

LIST OF COMPONENTS						
ITEM NO	NOMENCLATURE	NO OFF	DRG NO	DET. NO	MATL	PART NO
1	RELEASE BAR	1	ARM 1253 B8			
2	PRESSURE PLATE	1	ARDE 2039	10		
3	SPIGOT	1	ARM 1253 A-10			
4	BASE PLATE	1	ARDE 2039	19		
5	STOP	1	ARM 1253 A-12			
6	WASHER	1	ARM 1253 A-13			
7	HEX. LOCK NUT M12 X 1.25 TO SPEC IS. 1364	2	ND (PLATED)			

**NOTES:-**

1 ITEMS 1 & 5 SPOT WELDED IN POSITION & PROTECTIVE TREATMENT GIVEN AFTER WELDING

2 ALL WELDING JOINTS SHOULD BE AS PER TO SPEC. IS: 813



DRM. DSS.		CHKD. BY		TRD. BY		COMP		ASSY DRG ARDE 2039, SHT. 4	
CD		PASSED		SCALE - 1:1		GAUGE SCHD		DESIGN AUTHORITY	
APPROVED		FOR DIRECTOR		DATE 15-7-86		EST WEIGHT		ARDE PUNE-21	
R NO	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO	MATL		
SEALED BY				31 JUN 87		PROTECTIVE FINISH PHOSPHATED TO IS: 3618, CLASS A1		DRG NO	
								ARDE 2039	
DET NO 9		SHTS		SHT NO		DS CAT NO		AHSP	

PRESSURE PLATE-SUB ASSY.