EMPTY SHELL BODY WITH DRIVING BAND DRG. No. NAI(J) 502/1

1. DIMENSIONS FOR REFERENCE.
2. ** DIMENSIONS ARE ENSURED BY TOOL.
3. COATING :- (a) INTERNAL AND EXTERNAL SURFACE, EXCEPT SURFACE B WITH VARNISH ЛШ-10 OST B84-811-73.
   (b) SURFACE B - VARNISH ЛШ-20 OST B 84-811-73, VARNISH ЛШ 30 OST B 84-811-73 IS ALLOWED.
4. THE FOLLOWING ARE ALLOWED:- (a) COATING OF INTERNAL SURFACES WITH VARNISH ЛШ-15. EXTERNAL SURFACES, EXCEPT SURFACE B WITH VARNISH ЛШ 15, ЛШ 20, OST B 84-811-73.
   (b) SHELLAC VARNISH COLOURED WITH RHODAMINE "C" TY 16-14-1088-74, RHODAMINE "Ж" AS PER TY 6-09-2463-77 OR AS PER TY 6-14-1058-79 FOR COATING THE INTERNAL SURFACES.
   (c) MANUFACTURING OF THE DRIVING BAND FROM PIPES (JSS 4710-1)
   (d) CIRCULAR CUTS OF 2mm WIDTH ON THE SURFACE "3" UP TO DIA 29.12 min. AND ON THE SURFACE "N" UPTO DIA 29.20 min. THE DIAMETER DECRESE IN PLACE OF CUT IS A SUM CAUSING BY BAND PRESSING ON AND BAND TURNING.

EMPTY SHELL BODY WITHOUT DRIVING BAND DRG. No. NAI (J) 502/2

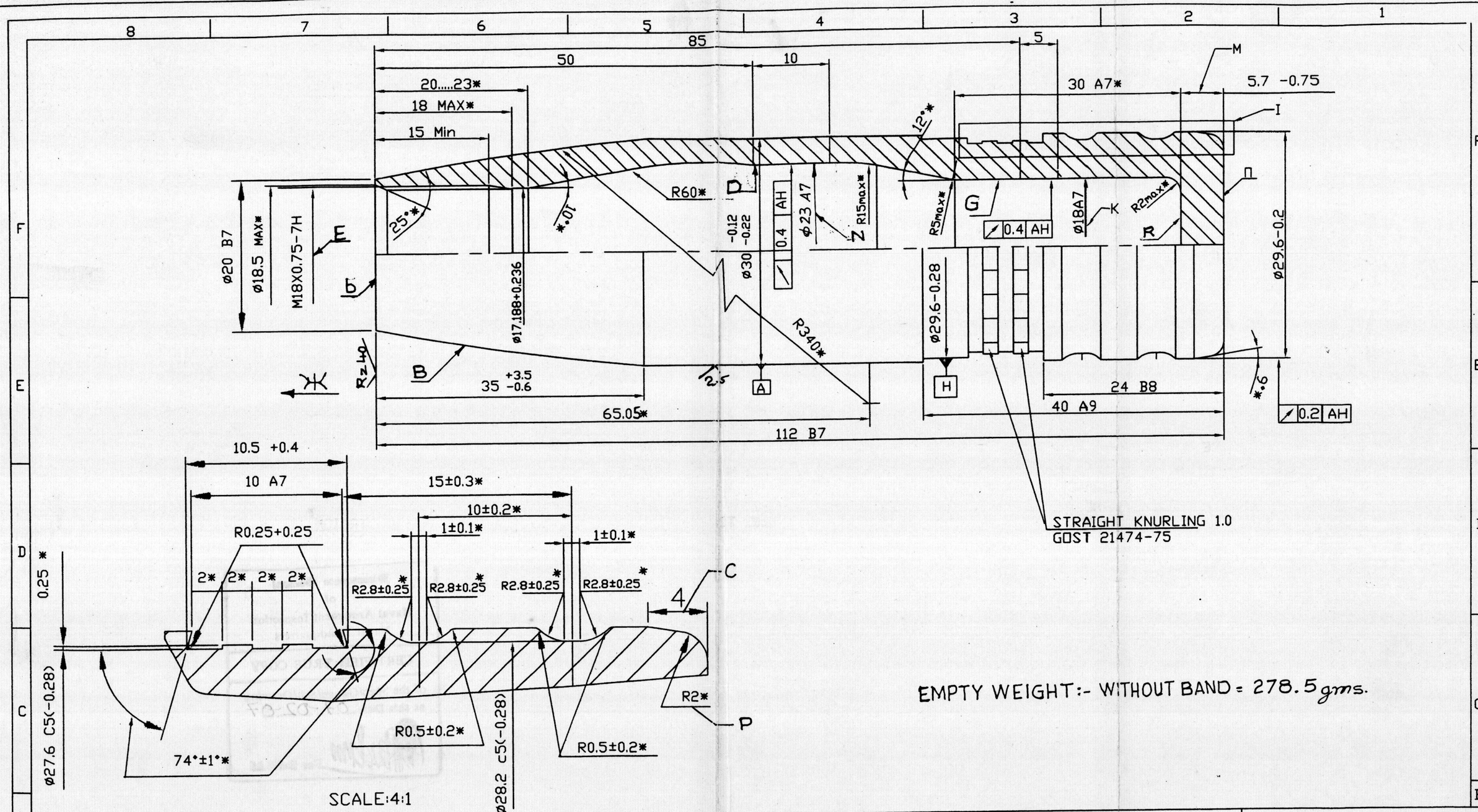
1.- * DIMENSIONS ARE ENSURED BY TOOL.
2.- REDIAL RUN OUT OF SURFACE OF PITCH DIAMETER OF THREAD E RELETIVELY TO THE EXIS OF SURFACES A AND H AT A DISTANCE OF 35mm FROM SURFACE b IN THE DIRECTION Ж SHOULD NOT EXCEED 0.4mm.
3.- OUT OF SQUARENCES OF AXIS OF PITCH DIAMETER OF THREAD E RELATIVELY TO SURFACE b SHOULD NOT EXCEED 0.2mm (QUALIFIED TOLERANCE)
4.- FAULT OF THE CONTINUITY OF THE MATAL OF BOTTOM PART IS NOT ALLOWED. CHECKING TO BE CARRIED OUT BY EXCESS PRESSURE 4 TO 6 ATM WITH HOLDING TIME OF ATLEAST 10 SEC. LEAKAGE OF AIR IS NOT ALLOWED.
5.- THE FOLLOWING ARE ALLOWED:-
   (a) TRACES DUE TO DRILLING ON SURFACE R WITH DRILL DIAMETER NOT MORE THAN 3mm, IN THIS CASE THE DIMENSION M UP TO THE BOTTOM OF DRILLING SHOULD BE ATLEAST 4.8mm.
   (b) DIMENSIONS K AND N ARE CHECKED BEFORE THE FORMATION OF SURFACE B.
   (c) CHECKING OF PLAY OF SURFACE D NOT TO BE CARRIEDOUT PROVIDED MANUFACTURING SURFACES G AND D ONCE CLAMPING.
   (d) INDUSTRIAL RECTIFIED ETHYL ALCOHOL GOST 17299-78 OF GRADE A.
   (e) DIMENSIONS P AND C TO BE CHECKED BEFORE THE FORMING OF SURFACE 7.
6.- OTHER REQUIREMENTS ARE AS PER OST B84-748-81.
7.- COATING : CHEMICAL PHOSPHATE COATING WITH CHROMETIZING TECHNICAL REQUIREMENTS FOR PHOSPHATE COATING/ THE GENERAL APPEARANCE AND PROTECTIVE PROPERTIES ARE AS PER GOST 9.301-73.
CHECKING OF PROTECTIVE PROPERTIES BY THE MATHOD OF SUBMERGING IN SOLUTION N 50 GOST 9.302-79.

R.No.	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS
	10-6-03		PROVISIONALLY SEALED BY DGNAI		
	08-01-03		APPROVED		

SCALE:	TOL		DIMENSIONS ARE IN mm	ASSY DRG No.
DGN	DRN	TCD	COMP	CHD
PASSED NAIO			APPROVED CINA	NAVAL ARMAMENT INSPECTORATE JABALPUR
MATL :			GEN SPEC NA SPEC A31-B	
MATL SPEC :			STORE SPEC	
PROTECTIVE FINISH			STORE REF No.	

EMPTY SHELL BODY WITH/WITHOUT DRIVING BAND (NOTE)

DRG. No.
NAI(J) 502/2
(PROVISIONAL) SHT. No.-1



EMPTY WEIGHT:- WITHOUT BAND = 278.5 gms.

R.No.	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS
	10-6-03		PROVISIONALLY SEALED BY DGNAI		
	08-01-03		APPROVED		

SCALE: 2:1	TOL	DIMENSIONS ARE IN mm	ASSY DRG No. NAI(J)500(P)
DGN	DRN	TCD	COMP	CHD
PASSED NAIO		APPROVED CINA	NAVAL ARMAMENT INSPECTORATE JABALPUR
MATL : STEEL 5.0		GEN SPEC NA SPEC A31-B	
MATL SPEC : Ty 14-1-2884-80		STORE SPEC	
PROTECTIVE FINISH		STORE REF No.	DRG. No. NAI(J) 502/2

SHELL BODY(EMPTY)

(PROVISIONAL) SHT. No.-2