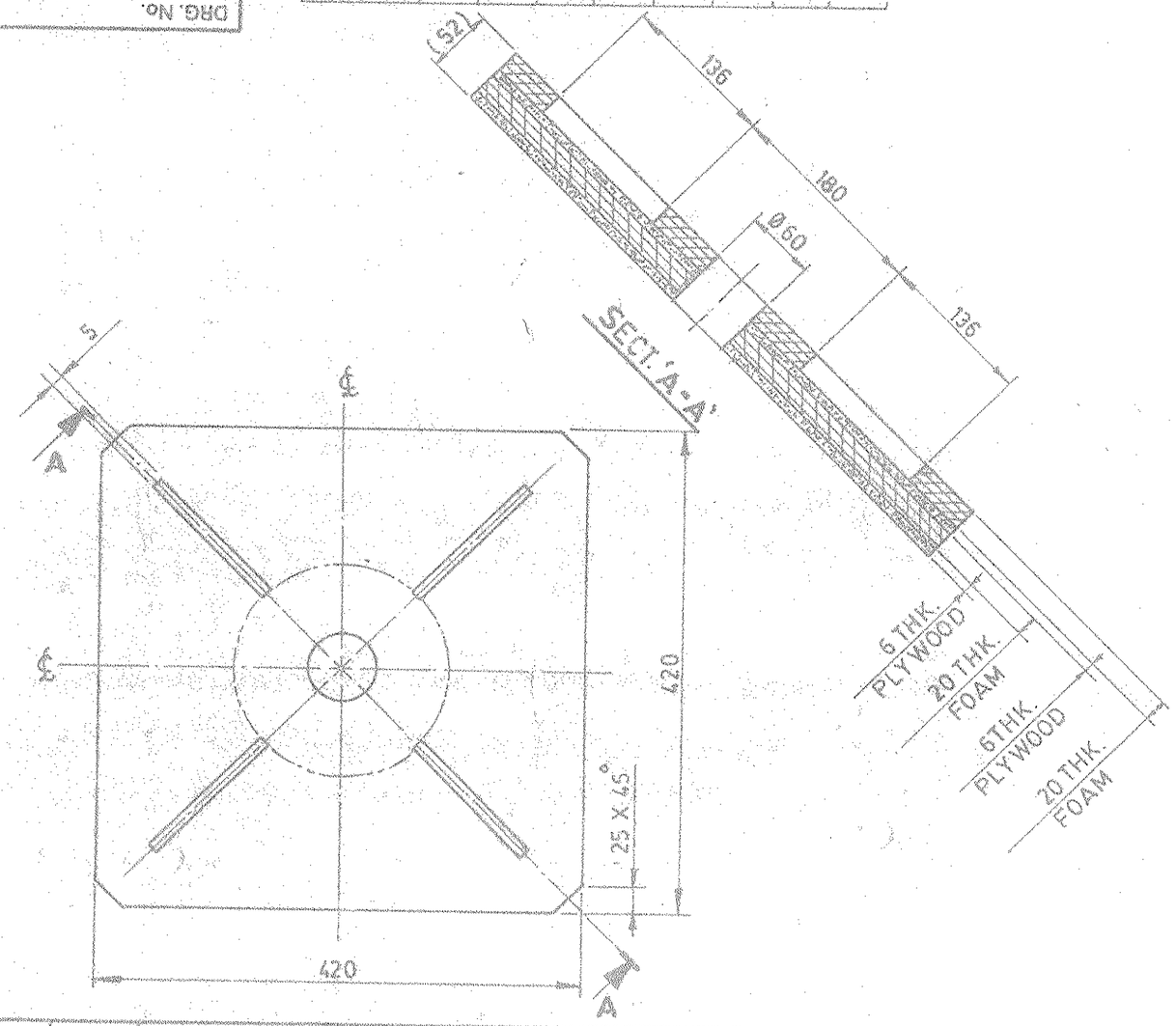
DRAWING CONVENTIONS CONFORM TO IS : 696

DIMNS ARE IN m.m. UNLESS OTHERWISE STATED

GEN. TOL. ~~MEDIUM~~ COARSE/~~MEDIUM~~ CLASS TO IS : 2102

DRG. No. ARDE 9501-05

PART No. | DET. No. 1 | SHTS. | SHTS. No.



MATL :—

FOAM :—

CROSSLINKED POLYETHYLENE FOAM TO DENSITY 80 ± 5 Kg/m³

PLYWOOD :—

PLYWOOD TO SPEC. IS : 303-89, GRADE : BWR.
TO BE COATED ALL OVER WITH SHELLAC VARNISH APC 224 OR APC 225 TO SPEC. JSS : 8010-63.

NOTE :—

PLYWOOD PIECES TO BE STUCK TO FOAM WITH APPROVED ADHESIVE AS SHOWN.

R. NO.	DATE :	AUTHORITY	BRIEF RECORD	ZONE	CD	GO	SIGN
DRG SEALED (PROV.)			CRE(AA)		08MAY2000		

DRN. Suresh. CHD. PASSED FOR APPROVED FOR DIRECTOR

CD

MATL : AS ABOVE

PROTECTIVE FINISH :

TRD. COMP.

SCALE : 1:5

EST MASS :

GAUGE SCHD :

DATE : 4-1-2000

ASSY DRG. ARDE 9501-05 ; SHT-2

DESIGN AUTHORITY

ARDE PUNE - 411021

DRG. No. ARDE 9501-05

DET. No. 1 | SHTS. | SHT. No.

PART No.

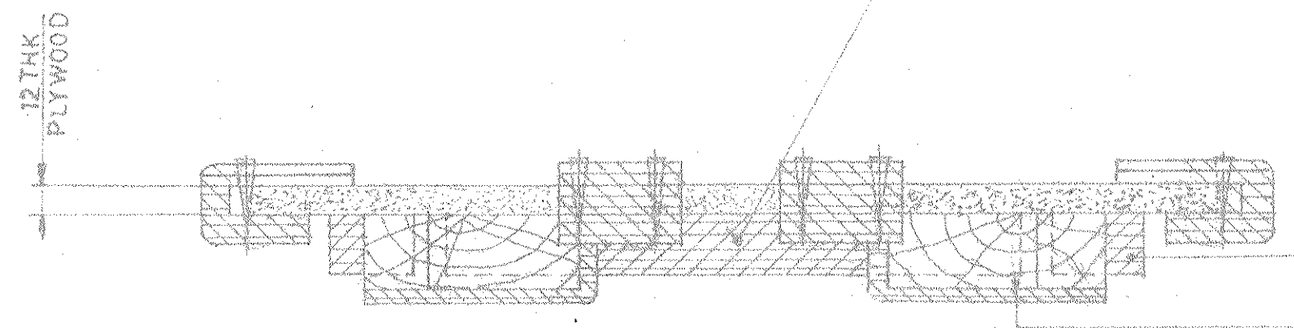
D. S. CAT. No.

A.H.S.P.

TITLE :

PIECE PACKING BOTTOM

ARDE 9501 - 05



PIECE POLYETHYLENE-I
SIZE : Ø 232 X 25THK. (QTY-1)
TO BE STUCK TO PLYWOOD WITH APPROVED ADHESIVE AS SHOWN

PIECE POLYETHYLENE-II
TO BE STUCK TO PLYWOOD WITH APPROVED ADHESIVE AS SHOWN

PIECE WOOD-I
EACH SECURED TO PLYWOOD BY 2 WOOD SCREWS MS C'SK HD Ø 3·45 X 35 LONG TO SPEC IS: 6760 AS SHOWN

PIECE FELT (QTY-8)
SIZE : 95 X 50 X 10THK TO SPEC IS : 1719 (PROOFED MEDIUM HARD) TO BE STUCK TO PLYWOOD WITH APPROVED ADHESIVE FOLDED BACK AND NAILED BY 4 NAILS Ø 1·8 X 30 LONG CLINCHED FROM OTHER END AS SHOWN TO SPEC IS: 723-1972

MATL:-

1) PIECE WOOD-I

TIMBER SHOWN IN APPENDIX 'A' OF SPEC. IND/ME/883 (PROV.)

2) PLYWOOD

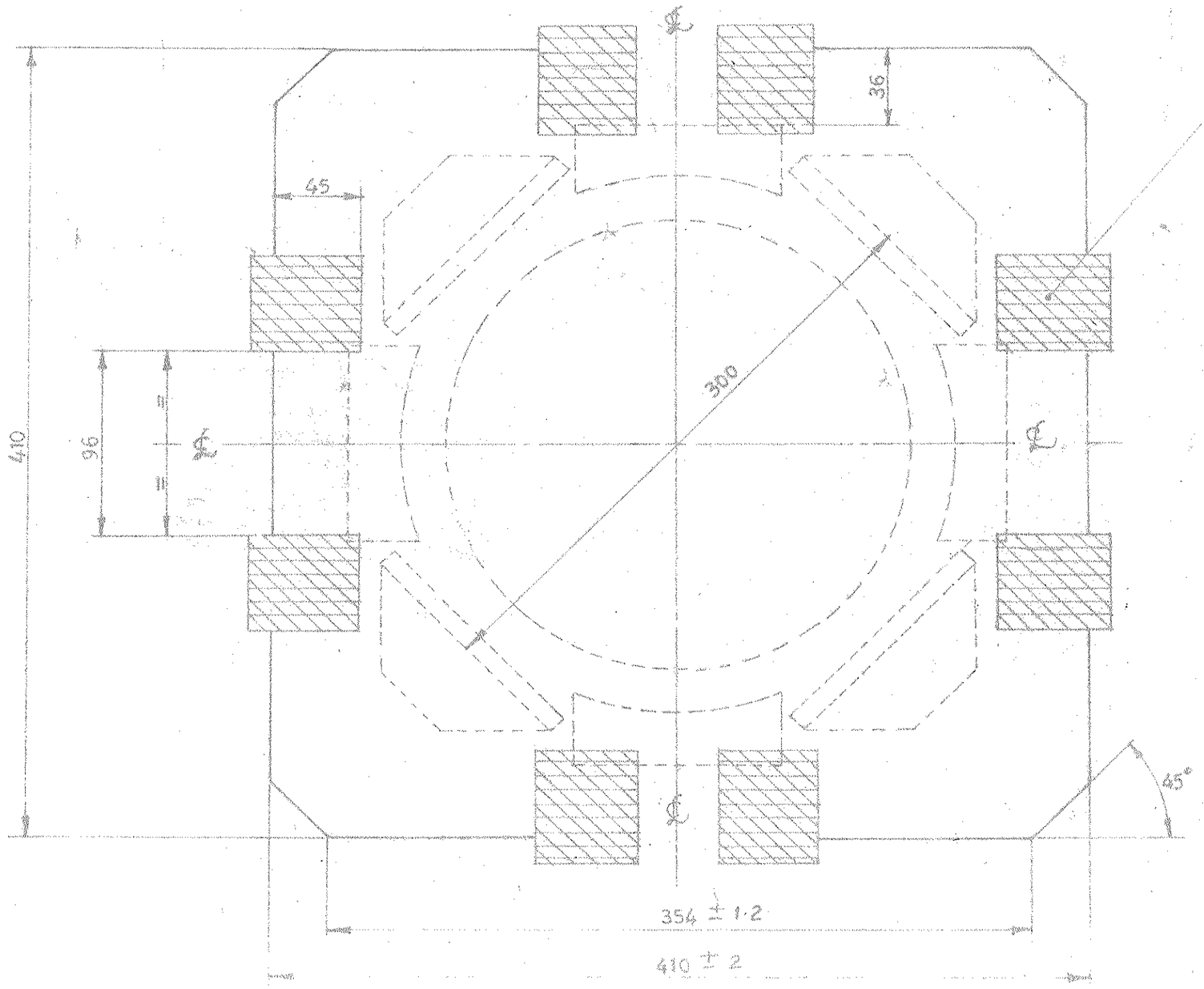
PLYWOOD MOISTURE PROOF TO SPEC IS: 303-1989
GRADE: BWR

VARNISHING

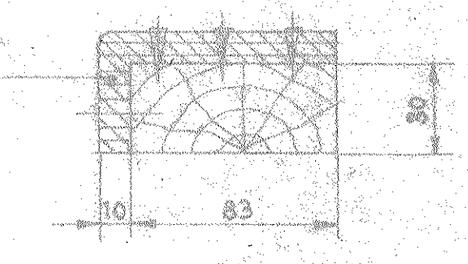
TO BE COATED ALL OVER WITH SHELLAC VARNISH APC-224 OR APC-225 TO SPEC JSS: 8010-63

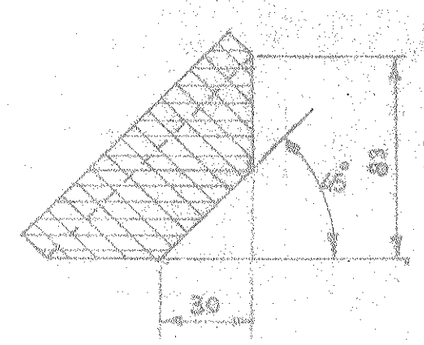
3) PIECE POLYETHYLENE I & II

EXPANDED POLYETHYLENE FOAM TO DENSITY 35 TO 40 Kg/m³

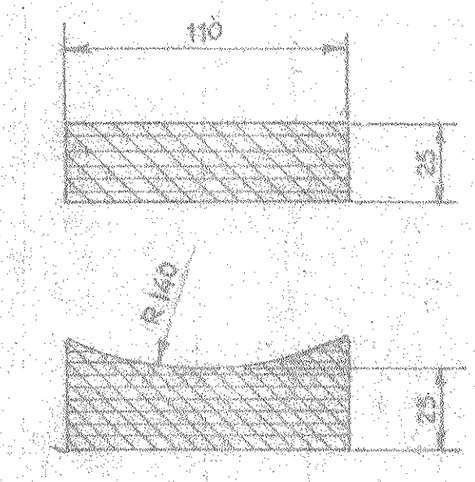


PIECE FELT TO THE SIZE OF PIECE WOOD TO SPEC. IS: 1719 (PROOFED MEDIUM HARD) TO BE STUCK TO PLYWOOD WITH APPROVED ADHESIVE AND NAILED BY 8 NAILS Ø 1·6 X 20 LONG TO SPEC IS: 723-1972





PIECE WOOD - I (QTY - 4)
(SCALE: 1:2)



PIECE POLYETHYLENE - II (QTY-4)
(SCALE: 1:2)

R NO	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO SIGN
1	13/9/05		ISSUE-A			

DRG SEALED (PROV) — R.L. RAMA (AA) 13/9/05

DRN Suresh... CHD — TRD COMP
CD — PASSED
APPROVED — FOR DIRECTOR
MATL:- AS ABOVE
PROTECTIVE FINISH :-
SCALE : 1 : 2·5
EST MASS
GAUGE SCHD
DATE :

ASSY DRG ARDE 9501-05, SHT. 2
DESIGN AUTHORITY
ARDE PUNE - 411 021

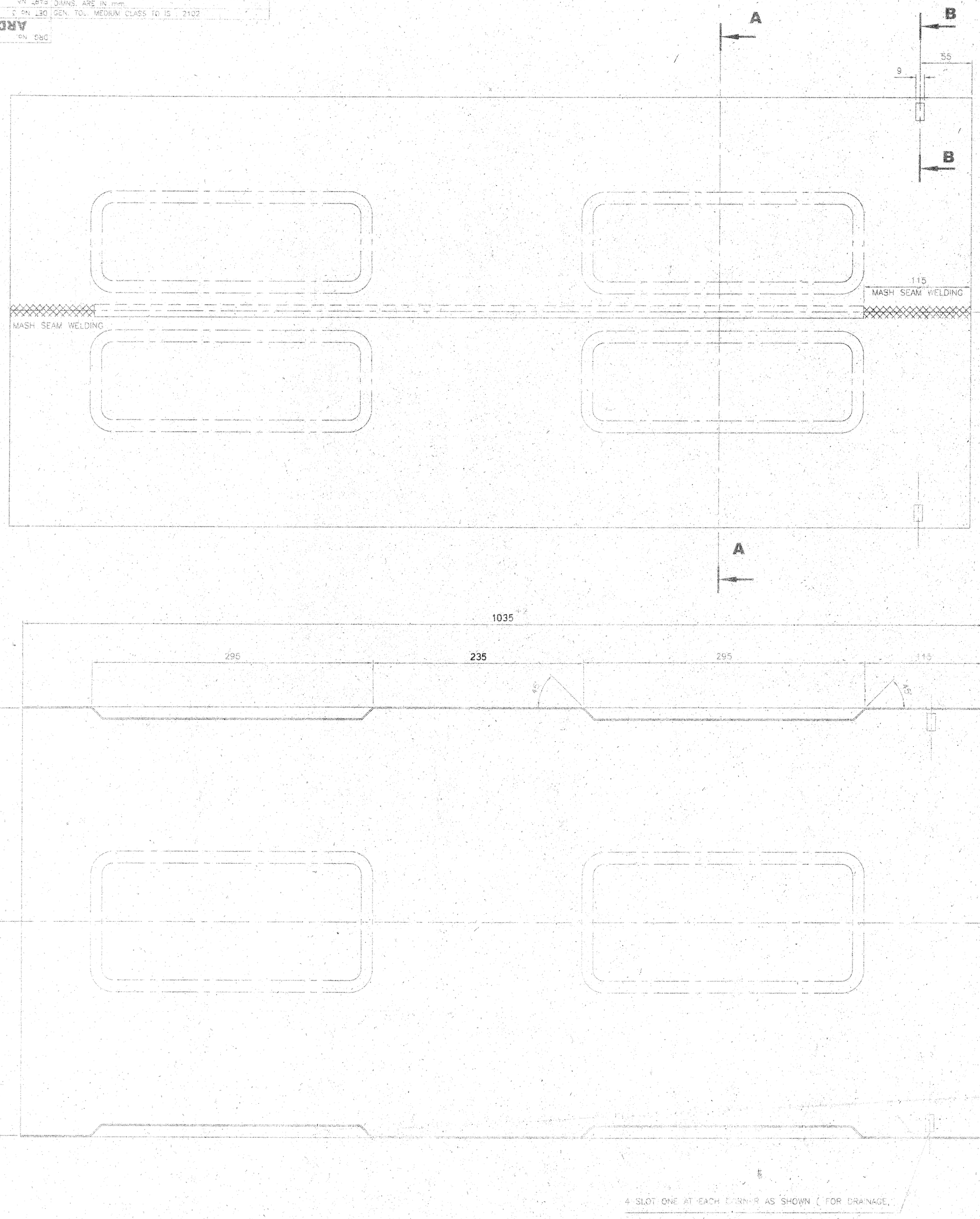
DRG NO. ARDE 9501 - 05
DET. NO. 2 | SHTS. | SHT NO.
PART NO.
D.S.CAT No.
A.H.S.P.

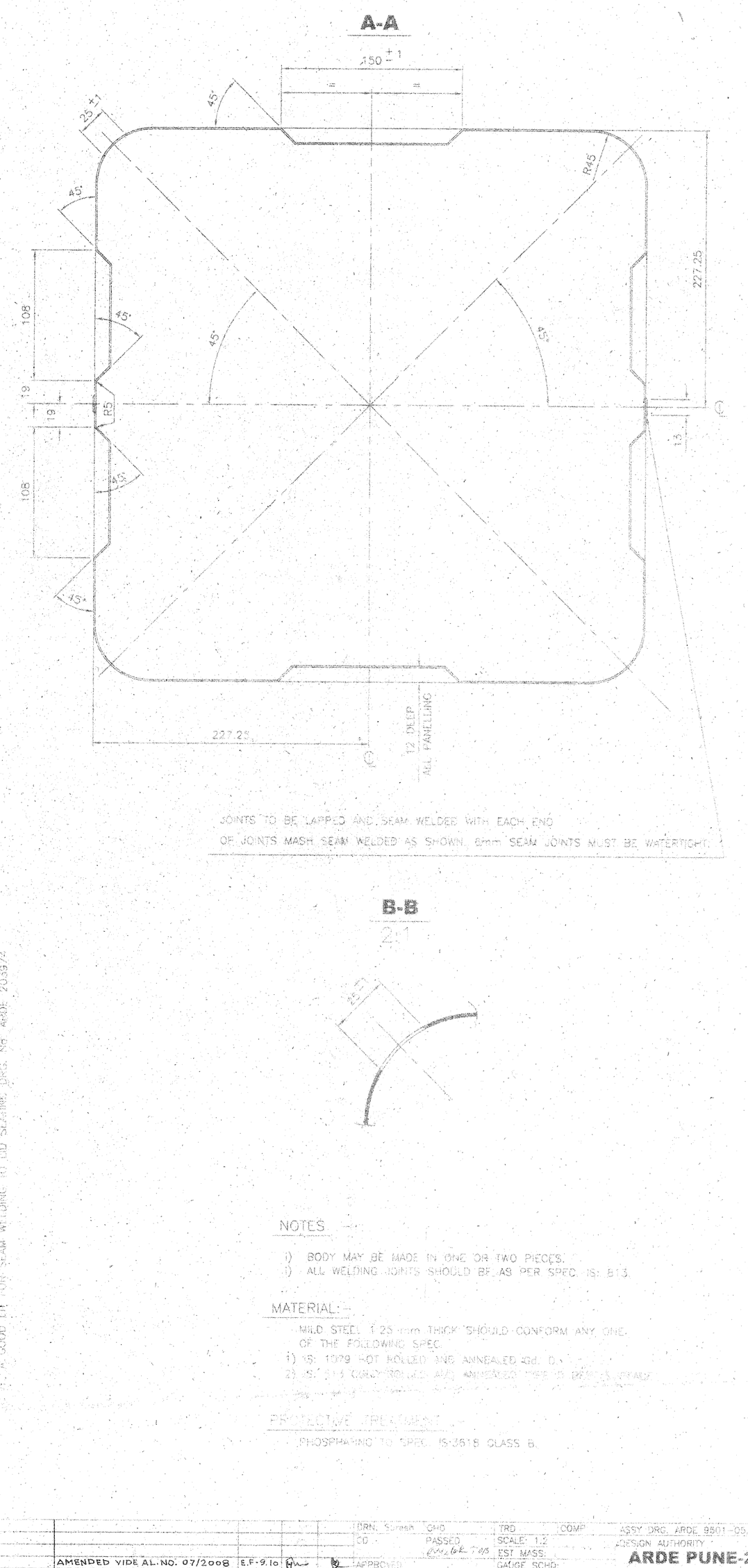
TITLE

PIECE PACKING TOP-I

DRAWING CONVENTIONS CONFORM TO IS SPECIFICATION
DIMNS. ARE IN mm
GEN. TOL. MEDIUM CLASS TO IS : 2102

ARDE 9501-05





JOINTS TO BE LAPPED AND SEAM WELDED WITH EACH END OF JOINTS MASH SEAM WELDED AS SHOWN. 6mm SEAM JOINTS MUST BE WATERTIGHT.

NOTES

1) BODY MAY BE MADE IN ONE OR TWO PIECES.
2) ALL WELDING JOINTS SHOULD BE AS PER SPEC. IS: 813.

MATERIAL:-

MILD STEEL 1.25 mm THICK SHOULD CONFORM ANY ONE OF THE FOLLOWING SPEC.
1) IS: 1079 HOT ROLLED AND ANNEALED sheet QUALITY
2) IS: 513 COLD ROLLED (DEEP DRAWING QUALITY) AND ANNEALED sheet IS PREFERABLY

PROTECTIVE TREATMENT:-

PHOSPHATING TO SPEC. IS:3618 CLASS B.

						DRN. Suresh	CHD	TRD	COMP	ASSY DRG. ARDE 9501-05 SH
						CD	PASSED	SCALE: 1:2		DESIGN AUTHORITY
							12/9/05	EST MASS:		ARDE PUNE-21
2	31/01/08	AMENDED VIDE AL. NO. 07/2008	E.F-9.10	gw		APPROVED		GAUGE SCHD:		
1.1	10/3/05	ISSUE - A			Y.K.	FOR DIRECTOR		DATE: 10/3/05		
R. No.	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD SIGN	GD	MATL	AS ABOVE		
DRG SEALED				12/9/05			PROTECTIVE FINISH:			

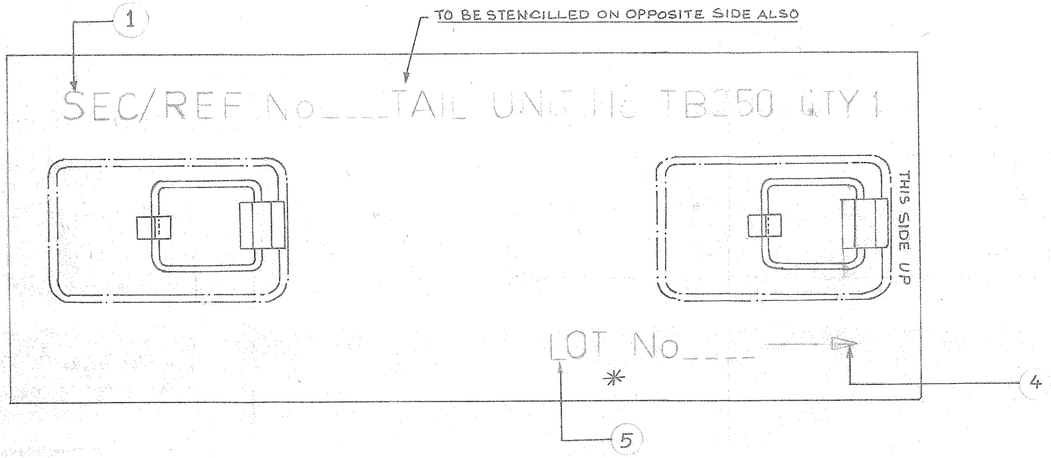
TITLE:

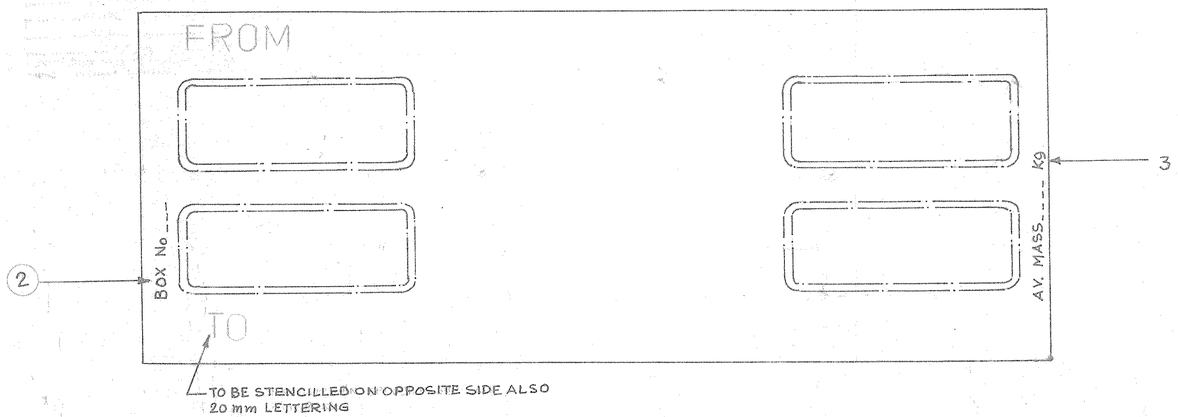
BODY

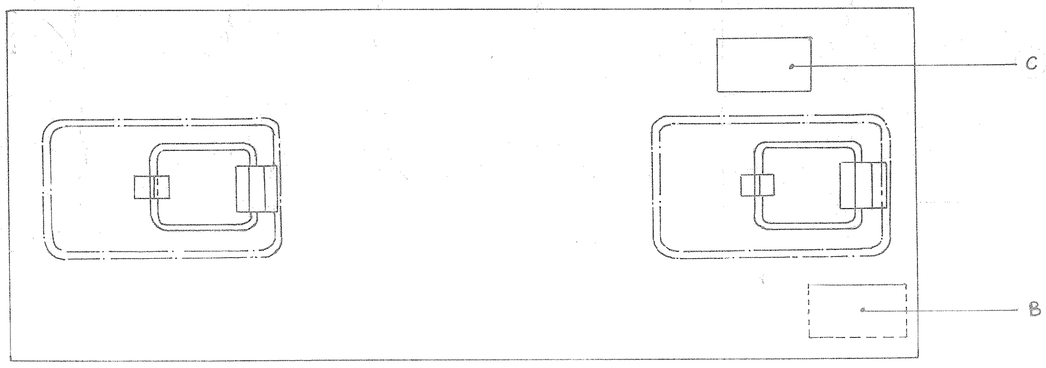
DRG No.
ARDE 9501-05
DET. No. 3 | SHTS | SHT No.
PART No.
D.S.DAT No.
A.H.S.B.

DRG CONVENTIONS CONFORM TO IS: 695.
DIMNS ARE IN mm UNLESS OTHERWISE STATED.
GEN TOL: MEDIUM / COARSE / FINE CLASS
IS 12 : 2102

ORG No ARDE 9501-05
PART No
DET No
1ST SHT No







NOTES

FOR PAINTING NOTE REFER DRAWING ARDE 2283, SHT 3

MARKING TO BE IN 12 mm LETTERING EXCEPT OTHERWISE STATED WITH PAINT FINISHING CHLORINATED RUBBER TYPE BRUSHING TO SPEC. DEF. STAN 80-72/1 COLOUR CANARY YELLOW (No. 309) TO 15:5

1. MARKING ON ALL SIDES TO BE IN 30 mm TO 40 mm LETTERING.
2. PACKAGE SERIAL No. OF FILLED BOX.
3. AVERAGE MASS OF FILLED BOX.
4. ARROW SHOWING POSITION OF STACKING OF THE BOX TO BE STENCILLED IN COLOUR WHITE TO SPEC 15: 138 TO SUITABLE SIZE ON OPPOSITE SIDE ALSO.
5. LOT No.
B. PACKER'S LABEL No. L566A TO BE AFFIXED TO UNDERSIDE OF LID.
C. ADDRESS LABEL No IA 108 TO BE AFFIXED ON LID.

LABELS TO BE AFFIXED TO THE BOX WITH APPROVED ADHESIVE AND THOSE ON EXTERIOR TO BE COATED WITH VARNISH LABEL AMMN TO SPEC. JSS 8010-23.

* APPROVED INITIALS OF MANUFACTURER.

FOR METHOD OF PAINTING SEE DRG No ARDE [illegible] SHT 3.

R NO	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO

DRG SEALED (PROV.) [signature] SC, REMH (AA) 13/9/05

DRW'G'S CD | CMD PASSED | TRC / ZONE | TEST DRG | DESIGN AUTHORITY: ARDE PUNE-411021
APPROVED | SCALE N.T.S | TEST MASS | GAUGE SCHD | DATE 12.7.05
MATL | PROTECTIVE FINISH

METHOD OF PAINTING & STENCILLING FOR-

BOX STEEL No.1 MK 1 TO HOLD 1 TAIL UNIT No. TB 250

ORG No ARDE-9501-05
DET No | SHTS 3 | SHT No 1
PART No.
D.S CAT No
A.H.S.P

DRG NO ARDE 9501-05

DRAWING CONVENTIONS CONFORM TO IS: 696		
DIMNS. ARE IN MM UNLESS OTHERWISE STATED		
GEN TOL: MEDIUM / COARSE / FINE CLASS TO IS: 2102	DET NO.	SHTS. 3 SHT. NO. 2

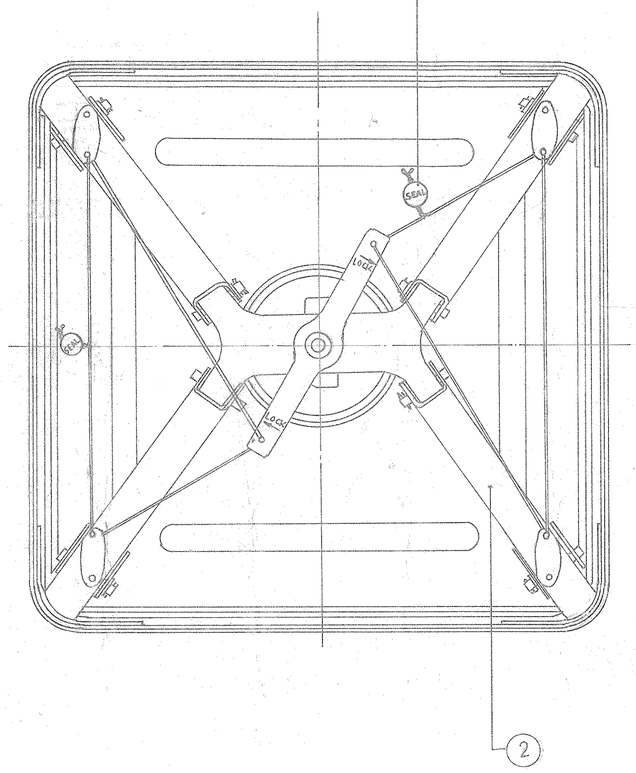
MATERIAL FOR :-

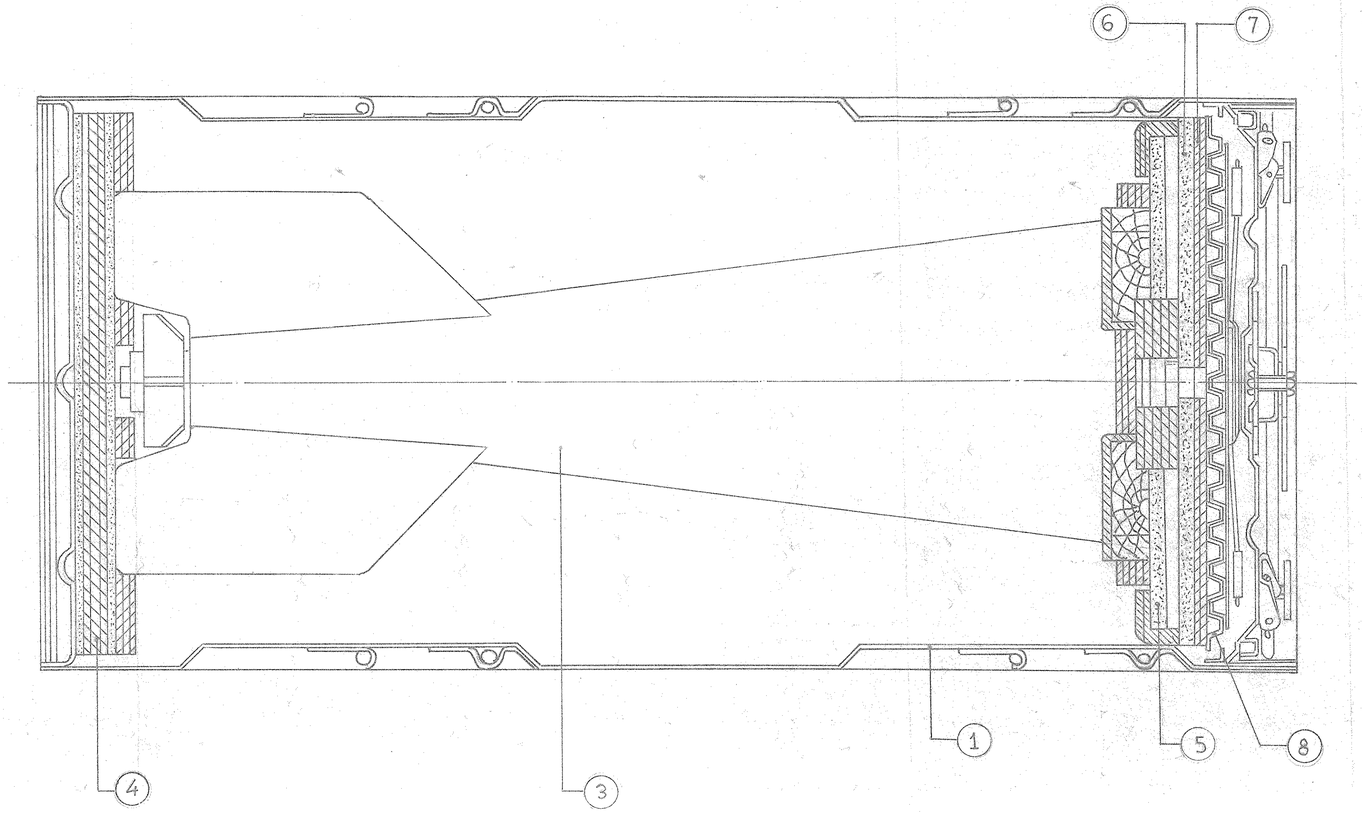
ITEM No (6)
PLYWOOD TO SPEC. IS : 303 - 89 GRADE : BWR.
TO BE COATED ALL OVER WITH SHELLAC
VARNISH APC-224 OR APC-225
TO SPEC. JSS : 8010-63

ITEM No (7)
EXPANDED POLYETHYLENE FOAM TO
DENSITY 80 ± 5 Kg/M³

WHEN PACKED AFTER PUTTING IN PACKER'S LABEL WIRE STEEL SOFT GALVANISED Ø1 OR 1·25 X 850 LONG TO SPEC. IS: 280, TO BE PASSED THROUGH HOLES TWISTED AND SEALED WITH SEAL LEAD Ø10 WHICH IS STAMPED WITH INSPECTOR'S MONOGRAM. THE ENDS OF WIRE TO BE LEFT LONG ENOUGH TO ENABLE UNTWISTING BY HAND.

ITEM LIST					
ITEM No.	DESCRIPTION	DRG. No	DET No	PART No	No OFF
1	BODY (WELDING ASSY)	ARDE 9501-05	SHT-3		1
2	SEALING LID ASSY	ARDE 2039	SHT-4		1
3	TAIL UNIT NO TB-250 FOR BOMB 250 Kg HSLD	ARDE 9501-03			1
4	PIECE PACKING BOTTOM	ARDE 9501-05	1		1
5	PIECE PACKING TOP - I	ARDE 9501-05	2		1
6	PIECE PACKING TOP - II SIZE : 420 X 420 X 12 THK Ø25 HOLE AT CENTRE	ND.			1
7	PIECE PACKING TOP - III SIZE 420 X 420 X 10 THK. Ø25 HOLE AT CENTRE.	ND			1
8	INNER LID ASSY	ARDE 2283	SHT-4		1





FOR METHOD OF PAINTING & STENCILLING SEE DRG. No. ARDE 9501-05, SHT-1

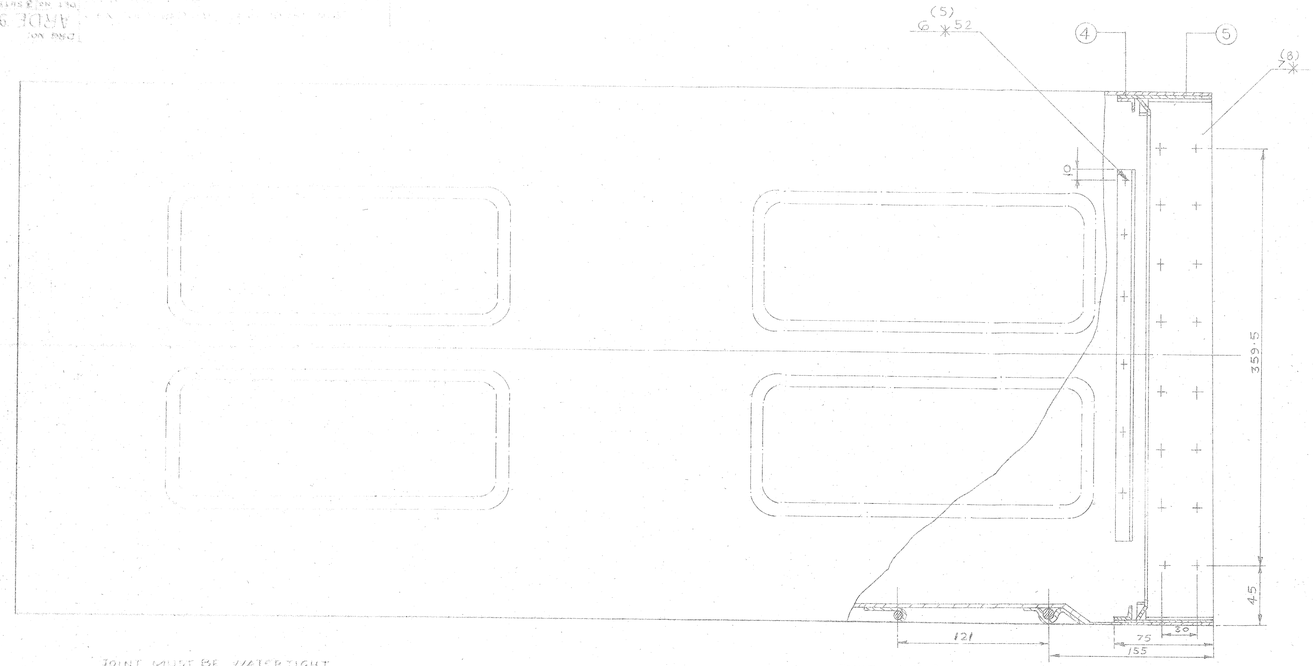
						DRN	CHD	TRD	COMP	ASSY DRG
						CD.	PASSED 'D'	SCALE :- 1:2:5		DEFENCE RESEARCH & DEVELOPMENT ESTABLISHMENT
								EST MASS		ARDE PUNE - 411021
1	10/3/05		ISSUE - 1'			APPROVED:		DATE 10/3/05		
R NO	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD. GO	MATL				DRG. No. ARDE 9501-05
DRG SUPERSEDED					SHEET	PROTECTIVE FINISH				DET. No. SHTS. 3 SHT NO. 2

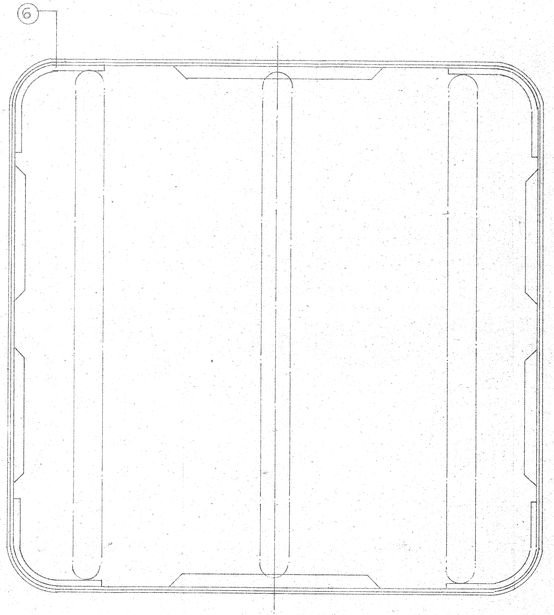
METHOD OF PACKING FOR

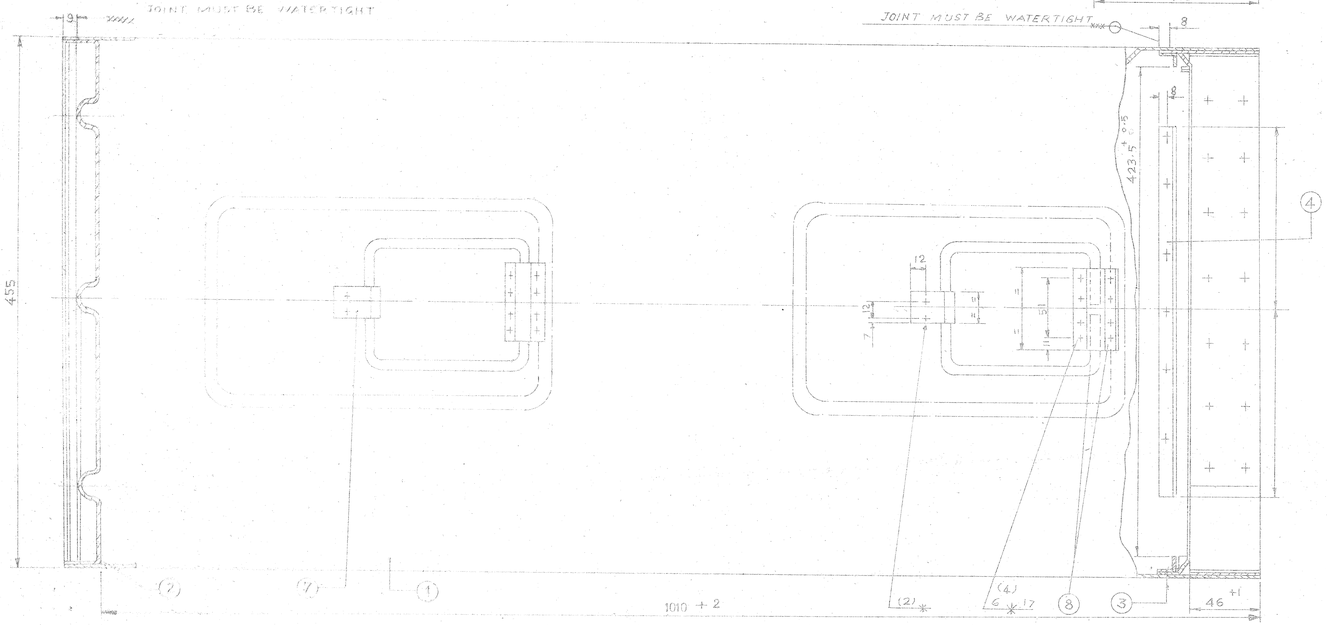
BOX STEEL No. 1 MK 1 TO HOLD ONE TAIL UNIT No. TB 250

RD - RCMA (AA) 13/9/05

PART No.
D.S.CAT.NO.
AHSP







LIST OF COMPONENTS

ITEM NO.	DESCRIPTION	DRG NO.	DET NO.	PART NO.	NO. OFF
1	BODY	ARDE 9501-05	3	—	1
2	BOTTOM	ARDE 2035	7	—	1
3	LID SEATING	ARDE 2039	4	—	1
4	BRACKET	ARDE 2283	3	—	4
5	RIM	ARDE 2039	5	—	1
6	CORNER PLATE	ARDE 124B	2	—	4
7	CLIP	ARDE 124B	3 OR 4	—	4
8	HANDLE AND CLEAT	ARDE 228 3	4	—	4

PAINTING

FIRST COAT :- PAINT, PRE-TREATMENT PRIMER (ETCHING PRIMER) TYPE SPRAYING TO SPECN. DEF STAN 80-1011
SECOND COAT :- PAINT, PRIMING, CHLORINATED RUBBER TYPE SPRAYING TO SPECN. DEF STAN 80-72/1, COLOUR: RED OXIDE (No. 446) TO 15:5
THIRD COAT :- PAINT, FINISHING, CHLORINATED RUBBER TYPE SPRAYING TO SPECN. DEF STAN 80-72/1, COLOUR: DEEP BRONZE GREEN (No. 34) TO 15:5
ALL COATS OF PAINTS TO BE APPLIED ALL OVER, INTERNALLY & EXTERNALLY
FOR METHOD OF APPLICATION AND TESTS FOR SUITABILITY OF THE PAINTS REFER PARA 4.3 OF SPECIFICATION NO. ARDE/SPECN/3030

PROTECTIVE FINISH :- PHOSPHATISING TO SPEC. IS: 3618 CLASS 'D'

NOTE :- 1) ALL WELDING JOINTS SHOULD BE AS PER SPEC. IS: 813
2) BOX TO BE TESTED AND INSPECTED TO SPEC I A 1169
3) WELDING TO CONFORM TO IS: 9595

R. NO.	DATE	AUTHORITY	BRIEF RECORD	ZONE	SIGN
2	31/01/08		AMENDED VIDE AL.NO. 07/2008	A-12	
1	10/3/05		ISSUE-A		
ORG	SEALED (PROV.)		13/9/05	H.S. MEHRA (AA)	

DRN SLL | CHD | TSD | COMP
C.D. | PASSED | SCALE: 1:2
TEST MASS
GAUGE CHD
DATE 10/3/05
MATL:
PROTECTIVE FINISH AS ABOVE

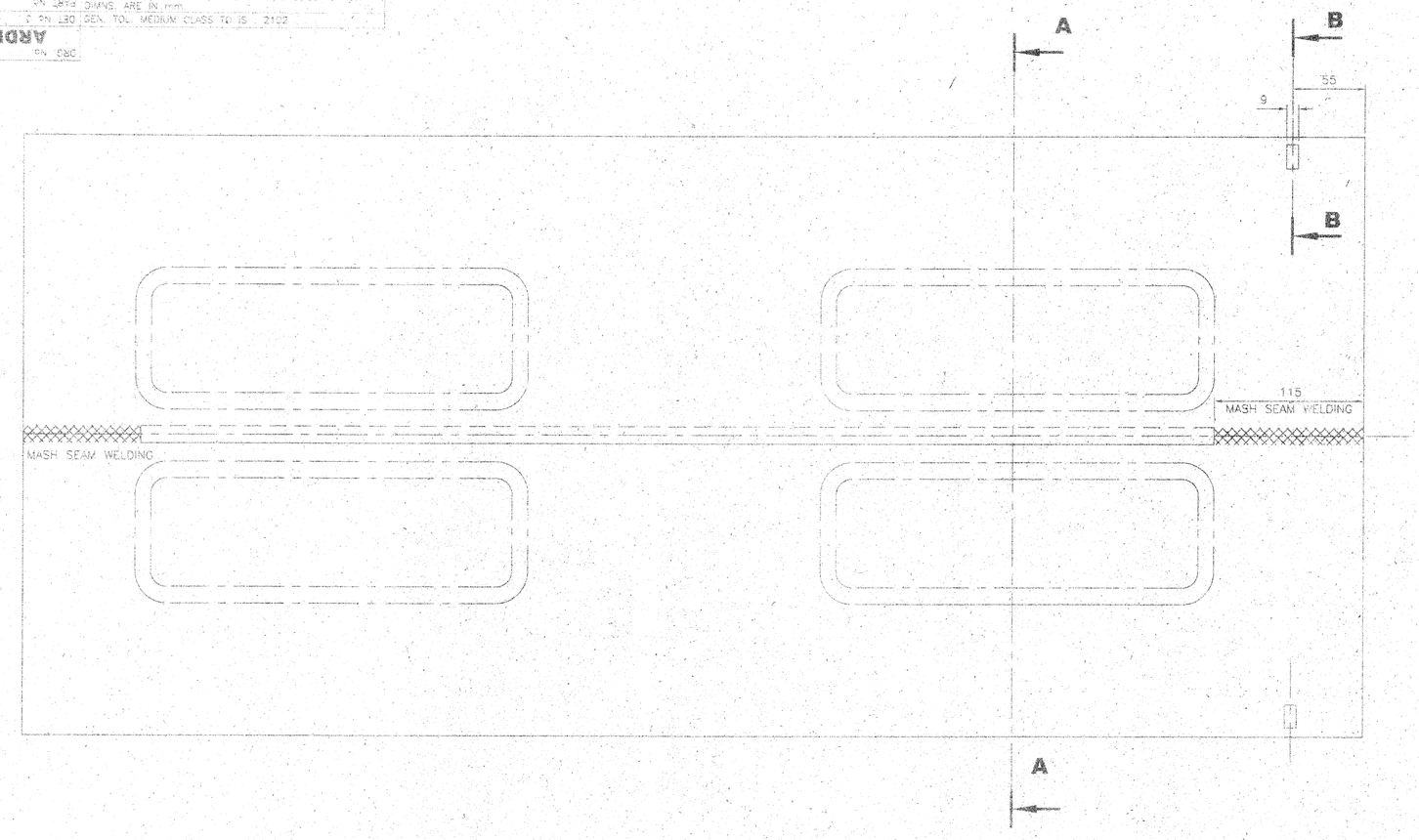
BODY
(WELDING ASSY)

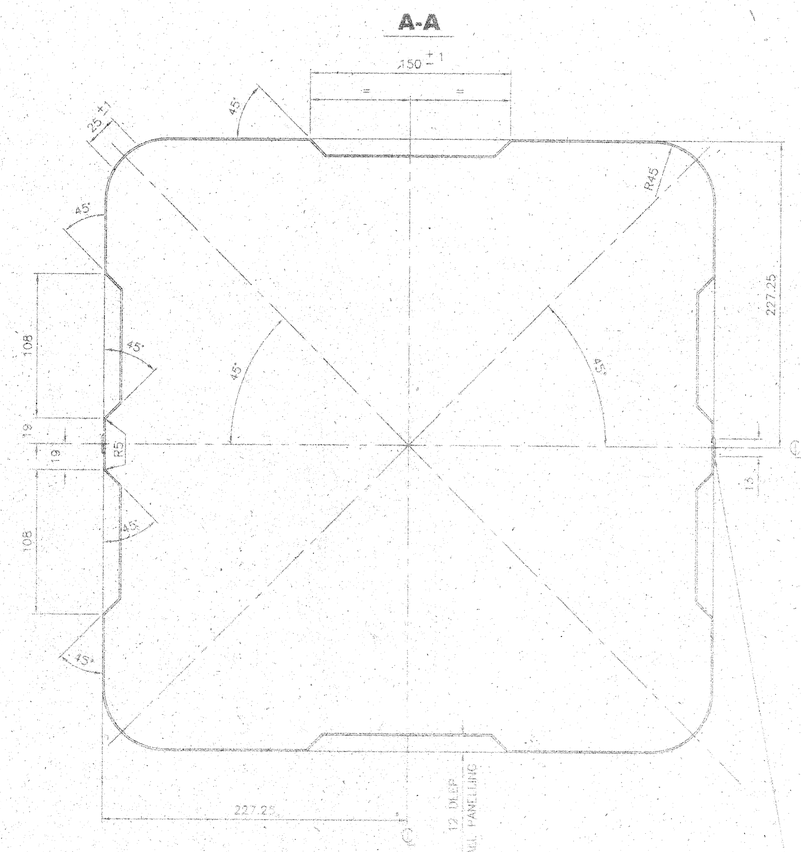
ASSY DRG ARDE 9501-05, SHT 2
DESIGN AUTHORITY
ARDE PUNE-21

DRG NO.
ARDE 9501-05
DET NO. SHTS 3 SHT NO 3
PART NO:-
D.S.CAT. NO.
AHSP

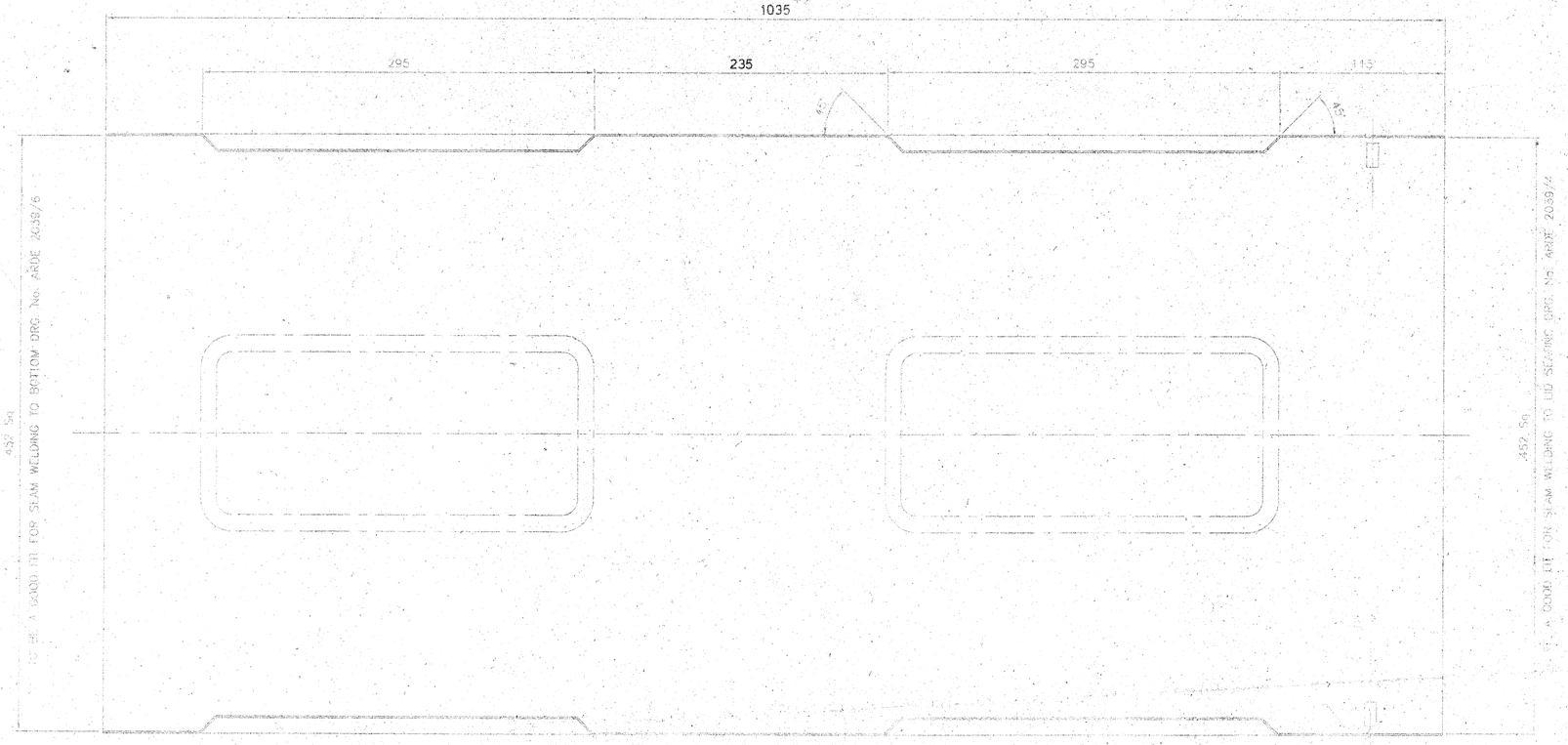
DRAWING CONVENTIONS CONFORM TO 'S' SPECIFICATION
DIMNS. ARE IN mm
GEN. TOL. MEDIUM CLASS TO IS : 2102

ARDE 9501-05



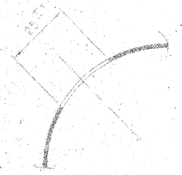


JOINTS TO BE LAPPED AND SEAM WELDED WITH EACH END OF JOINTS MASH SEAM WELDED AS SHOWN. 6mm SEAM JOINTS MUST BE WATERTIGHT.



B-B

2:1



NOTES :-

i) BODY MAY BE MADE IN ONE OR TWO PIECES.
ii) ALL WELDING JOINTS SHOULD BE AS PER SPEC. IS: 813.

MATERIAL :-

MILD STEEL 1.25 mm THICK SHOULD CONFORM ANY ONE OF THE FOLLOWING SPEC.
1) IS: 1079 HOT ROLLED AND ANNEALED Gd. D.
2) IS: 513 COLD ROLLED FULL ANNEALED TYPE D DEEP DRAWING QUALITY.

PROTECTIVE TREATMENT :-

PHOSPHATING TO SPEC. IS-3618 CLASS B.

No.	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD.	CD.	MATL.	AS ABOVE
2	31/01/08		AMENDED VIDE AL. NO. 07/2008 E.F-9.10			Y.K.	APPROVED	FOR DIRECTOR
1	10/3/05		ISSUE - A				DATE	10/3/05

DRG SEALED [illegible] 13/9/05

DRN. S.Desai CHD TPD COMP
CD PASSED SCALE: 1:2
EST. MASS
GAUGE SCHD.

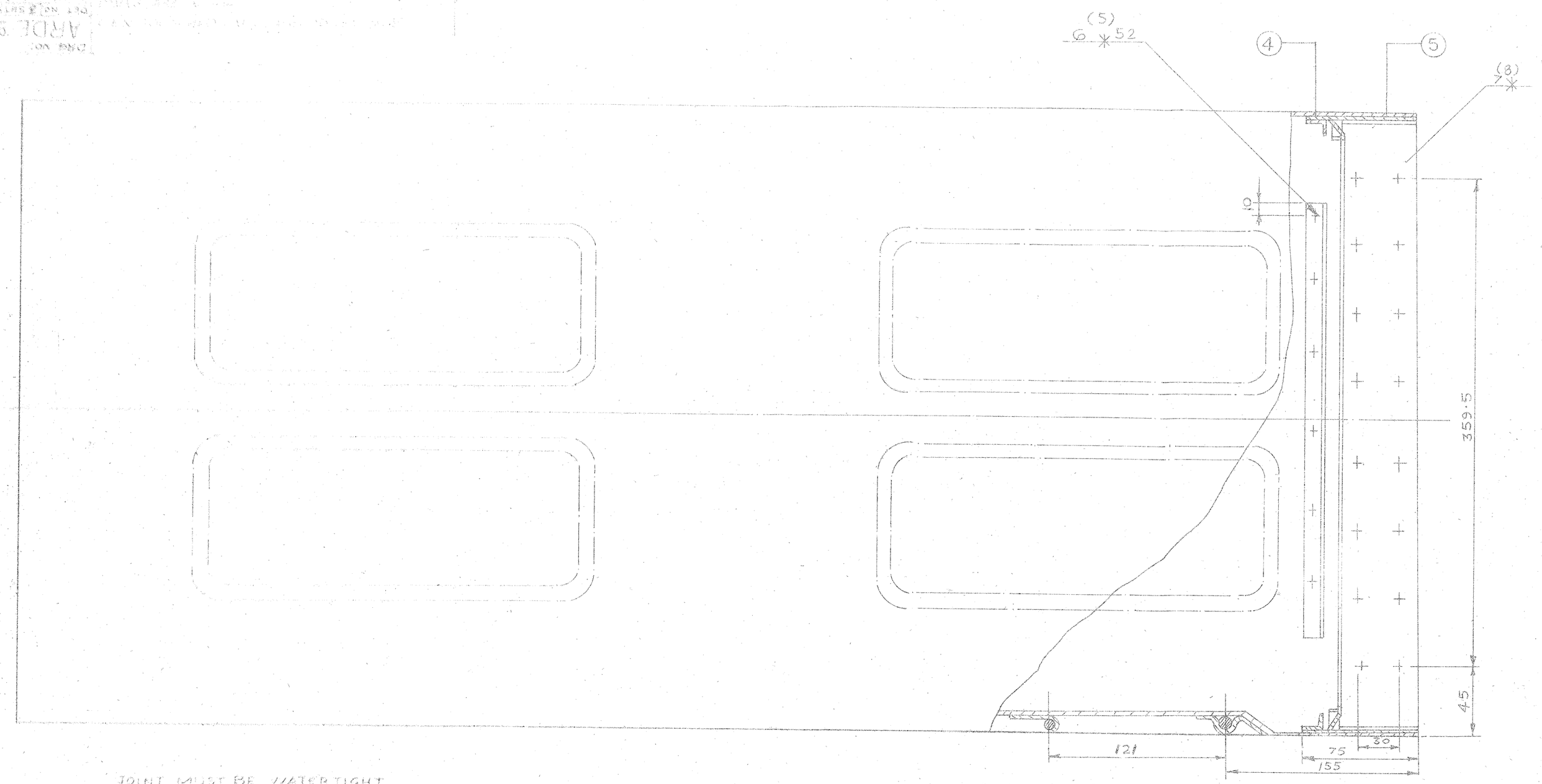
ASSY. DRG. ARDE 9501-05 SHT
DESIGN AUTHORITY
ARDE PUNE-21

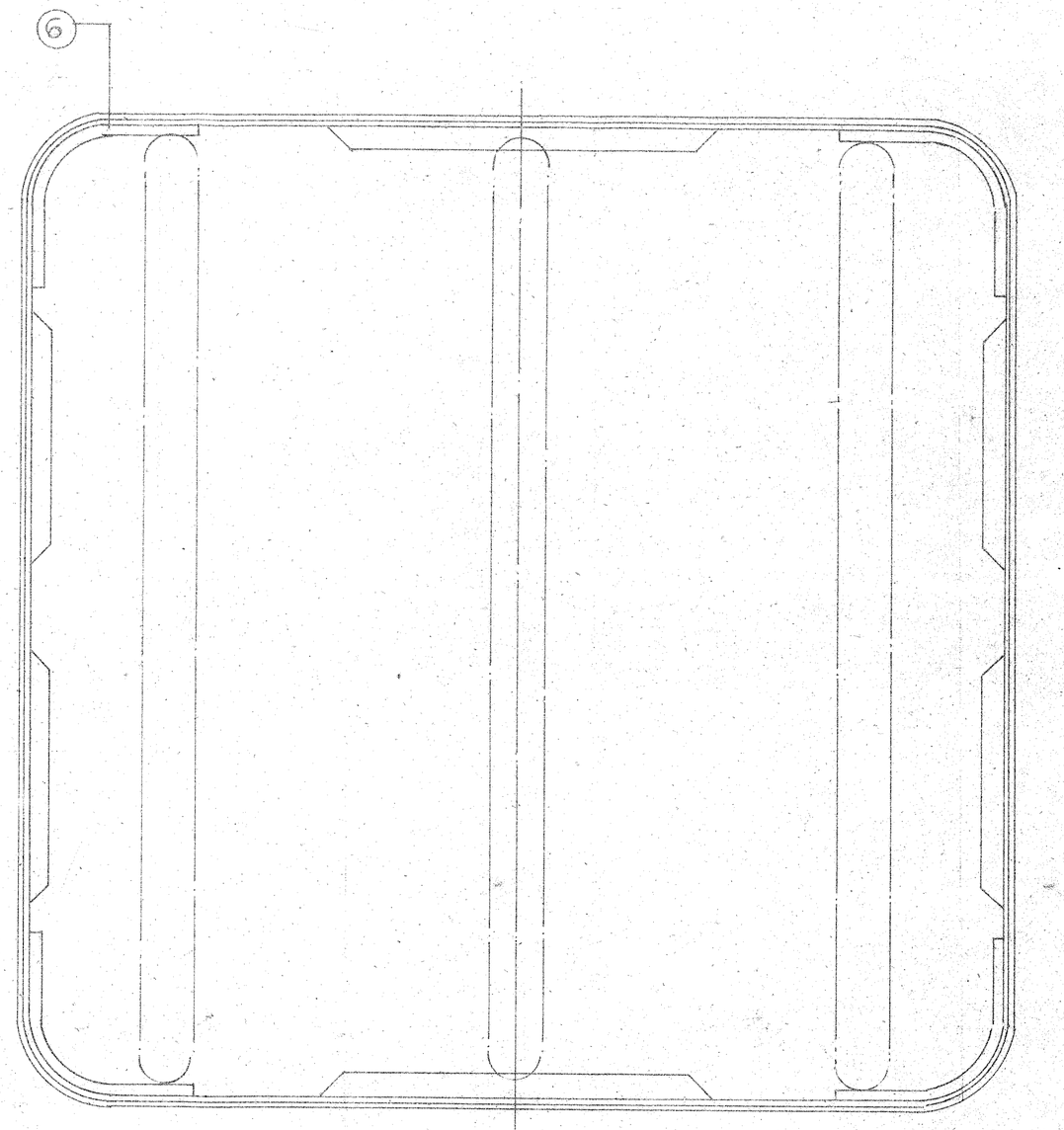
PROTECTIVE FINISH:

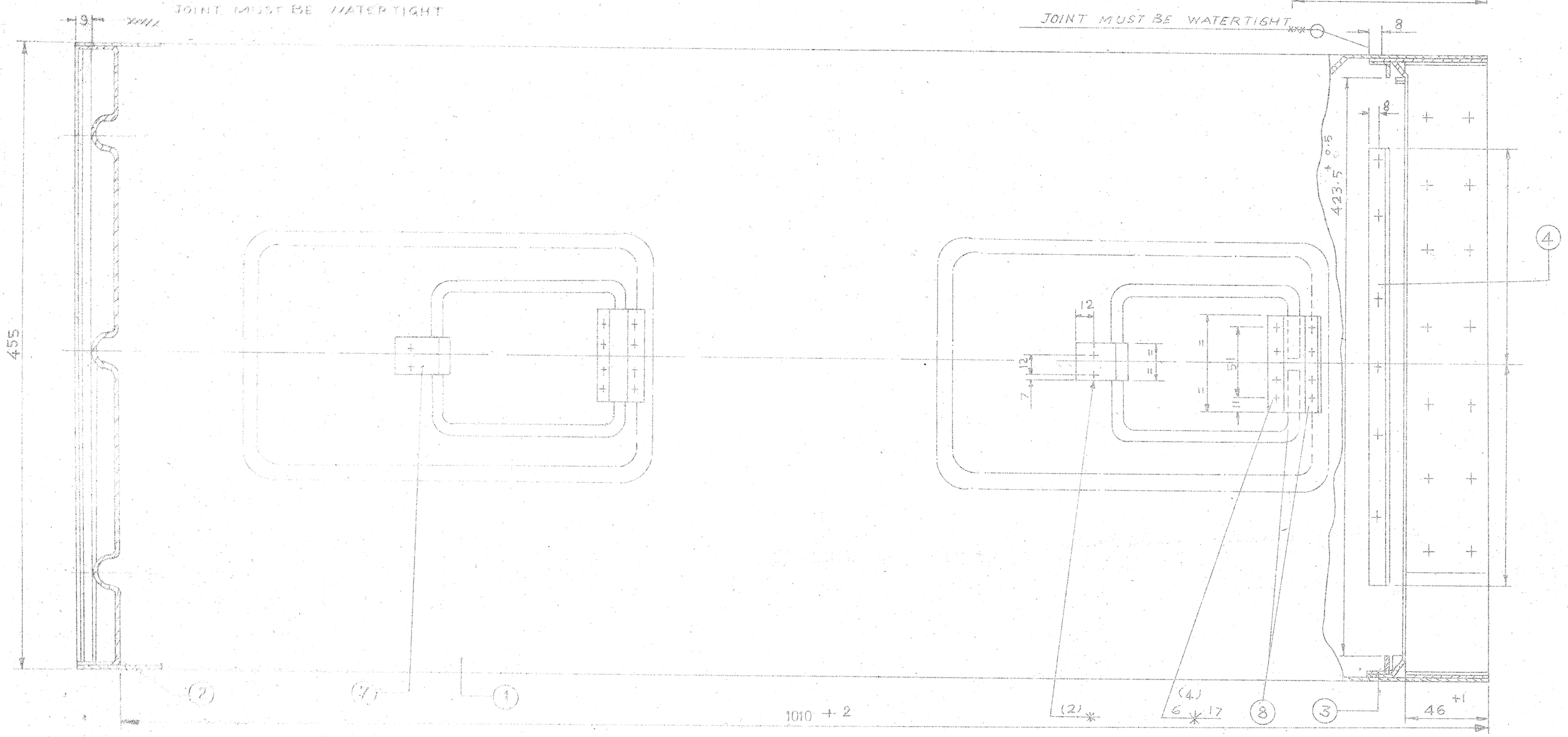
DRG No.
ARDE 9501-05
DET No 5 SHTS SHT No
PART No.
DIS DAT No.
A.M.S.D

TITLE:

BODY







LIST OF COMPONENTS

ITEM NO.	DESCRIPTION	DRG NO.	DET NO.	PART NO.	NO OFF
1	BODY	ARDE 95[illegible] 05	3	—	1
2	BOTTOM	ARDE 2039	7	—	1
3	LID SEATING	ARDE 2039	4	—	1
4	BRACKET	ARDE 2283	3	—	4
5	RIM	ARDE 2039	5	—	1
6	CORNER PLATE	ARDE 1248	2	—	4
7	CLIP	ARDE 1248	3 OR 4	—	4
8	HANDLE AND CLEAT	ARDE 2283	4	—	4

PAINTING

FIRST COAT :- PAINT, PRE-TREATMENT PRIMER (ETCHING PRIMER) TYPE SPRAYING TO SPECN. DEF STAN 80-19/1.
SECOND COAT :- PAINT, PRIMING, CHLORINATED RUBBER, TYPE, SPRAYING TO SPECN. DEF STAN 80-72/1, COLOUR: RED OXIDE (No 446) TO IS: 5
THIRD COAT :- PAINT, FINISHING, CHLORINATED RUBBER TYPE SPRAYING TO SPECN. DEF STAN 80-72/1, COLOUR: DEEP BRONZE GREEN (No. 34) TO IS: 5
ALL LOCATE OF JOINTS, TO BE APPLIED ALL OVER, INTERNALLY & EXTERNALLY
FOR METHOD OF APPLICATION AND TESTS FOR SUITABILITY OF THE PAINTS REFER PARA 4.3 OF SPECIFICATION NO. ARDE/SPECIFICATION

PROTECTIVE FINISH :- PHOSPHATING TO SPEC. IS: 3618 CLASS 'B'

NOTE :- (i) ALL WELDING JOINTS SHOULD BE AS PER SPEC. IS: 813
(ii) BOX TO BE TESTED AND INSPECTED TO SPEC I A 1169
(iii) WELDING TO CONFORM TO IS: 9595

R. NO	DATE	AUTHORITY	BRIEF RECORD	ZONE	SIGN
2	31/10/08		AMENDED VIDE AL. NO. 07/2008	A-12	
1	10/3/05		ISSUE-A		
ORG. SEALED (PROV.)			13/9/05	H.O. (ARDE (AA))	

DRN. SLT. CHD. CO. PASSED (INSP.) TRD. SCALE: 1:2 COMP. TEST MASS GAUGE BOND DATE 10/3/05

MATL. PROTECTIVE FINISH AS ABOVE

BODY
(WELDING ASSY)

ASSY DRG. ARDE 95[illegible] 05, SHT 2
DESIGN AUTHORITY
ARDE PUNE-21

DRG NO. ARDE 9501-05
DET NO. SHTS 3 SHT NO 3
PART NO:-
D.S.CAT. NO.
AHSP