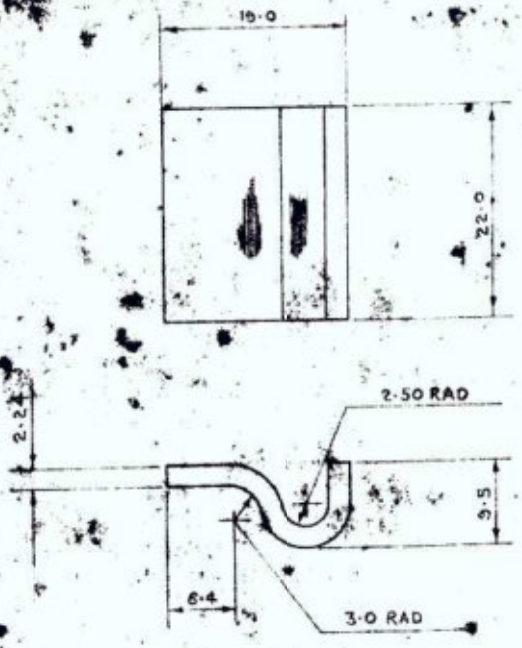
CONFORM TO IS ...

... ARE IN mm



NOTE:-

TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ± ·1
FOR TWO OR MORE DECIMAL PLACES ± ·13

MATERIAL -

STEEL, 3·0 THICK CONFORMING TO
a) IS: 1079 - 1963 GRADE ST 34 HOT ROLLED & ANNEALED OR
b) IS: 513 - 1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE 'D' OR
c) BS: 1449 PT 3B - 1964 - C.S4 COLD ROLLED & ANNEALED OR
d) BS: 1449 PT 3A - 1964 - H S4 (A) HOT ROLLED & ANNEALED

DEVELOPED LENGTH 28·7

R.No	DATE	AUTHORITY	REVISION	ZONE	AHSP 616	D.O. SDI/
	15-10-65		RETRACED WITHOUT CHANGE. PREVIOUS D.C.S.(T) Nos. 28679-A & 31525-A			

DRG. SEALED :- 26-10-67 (PROV.)

DRN	CHD V.R.S.	TCD RDT	COMP.
SDI/ C.D'MAN	SDI/ O/C DO	SCALE :- 2:1	
APPD	SDI/ FOR C.I. (A)	EST. MASS :-	
		GAUGE SCHD :-	
		DATE :- 5-1-65	

MATL :- AS ABOVE

PROTECTIVE FINISH :-

ASSY. DRG. ISV 34 SA

DESIGNER'S REF. CIA/AMN/638 DETAIL No 1

PART No ISV 901

D.S. CAT No

AHSP :- C.I. (A) KIRKEE

PLATE, HOOK

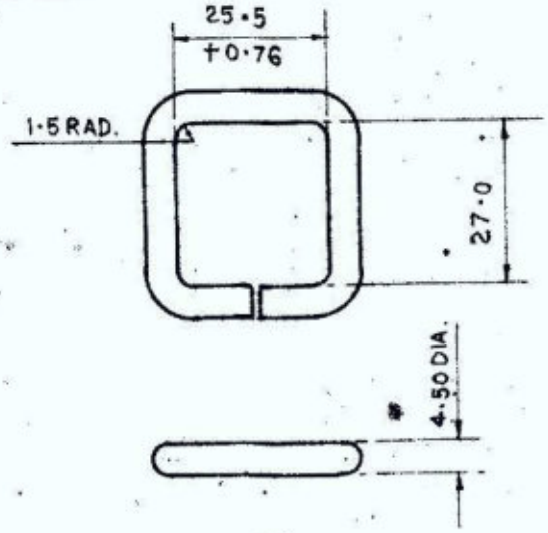
(10)

4	3	2	1

PART No. ISV 902

DRG. CONVENTIONS CONFORM TO IS : 696
DIMENSIONS ARE IN mm.

D.C.I. 28679-A.



MATERIAL :- WIRE STEEL CONFORMING TO IS:280 HALF HARD BRIGHT DRAWN.

TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ± 1·3 .
FOR TWO DECIMAL PLACES ± ·13 .

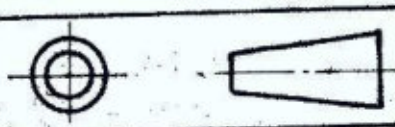
DEVELOPED LENGTH :- 120·65

R. No	DATE	AUTHORITY	REVISION	ZONE	AHSP	D.O.
	6-10-65		RETRACED WITHOUT CHANGE.			SD/-
			PREVIOUS D.C.(I) Nos 28679-A & 31525-A.			

DRG. SEALED:- 26-10-67 (PROV.)

DRN.	CHD. V.R.S.	TCD.M.A.K.	COMP.
SD/- CD'MAN	SD/- O/C D.O.	SCALE:- ½	
APPD. SD/- FOR C.I.(A)		EST MASS:-	
		GAUGE SCHD:-	
		DATE:- 5-1-65	

ASSLY DRG. ISV 34SA



MATL:- AS ABOVE

PROTECTIVE FINISH:-

DESIGNER'S REF. CIA/AMN/636 . DET. No 2

PART No ISV 902

D.S. CAT No.

AHSP :- C.I.(A) KIRKEE

LINK

12096

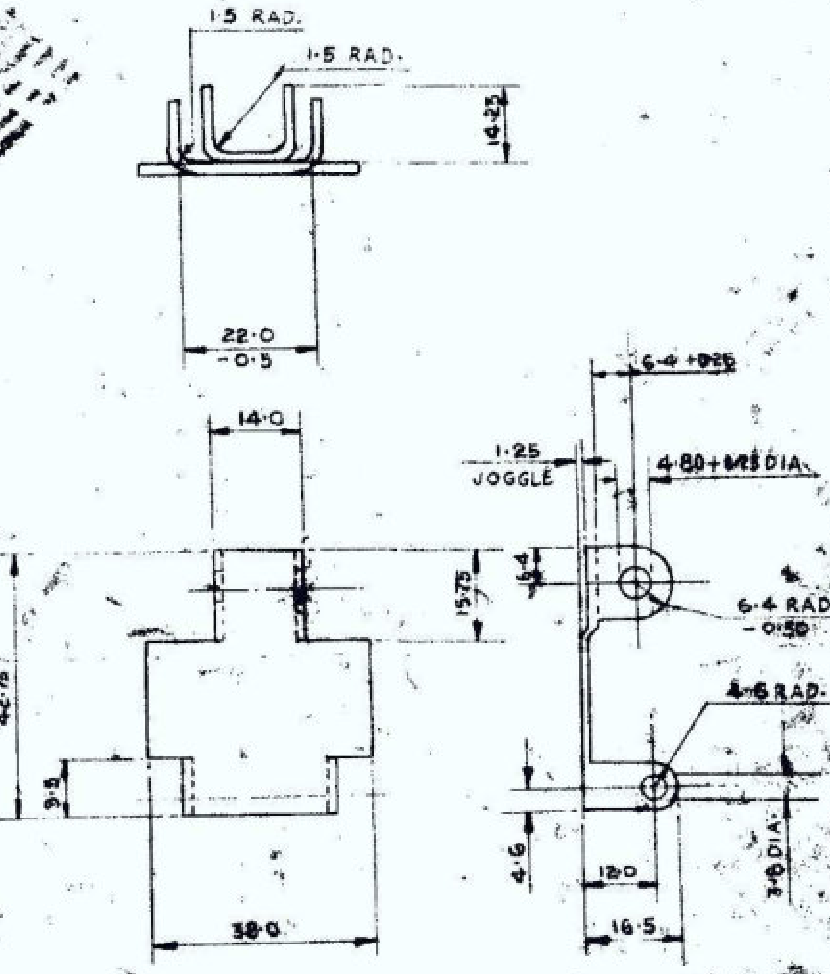
PART No.	FOR EXPLANATION OF DIMENSIONING ETC., SEE D.D. NOTE SHEET
1SV 903	THIRD ANGLE PROJECTION. DIMENSIONS ARE IN MM

NOTE:- TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ±1.3
FOR TWO OR MORE DECIMAL PLACES ±.15

MATERIAL :-

STEEL, 1.60 THICK CONFORMING TO

(a) I.S : 1079 - 1963 GRADE ST. 34 HOT ROLLED & ANNEALED OR
(b) I.S : 513 - 1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE 'D' OR
(c) B.S : 1449 PT. 3B, 1964 - CS4 COLD ROLLED & ANNEALED. OR
(d) B.S : 1449 PT. 3A, 1964 - HS4 A HOT ROLLED & ANNEALED.



DEVELOPED WIDTH = 53.0

RC1 28673 A

ASSLY DRG :- 1SV
INSP. INSTRS :-
DRAWN CHECKED
V.R.S
CHIEF D'MAN

DATE	AUTHORITY	ZONE	NATURE	SIGN.	CHKD.
			RECONVERTED TO SI UNITS & RE-SEALED NEW COPY OF DRG. SEALED IN SUPERSESSION OF THE EXISTING DRG. OF SAME NO.		
			TRACED WITHOUT CHANGE		
			DRAWING PROV. SEALED		
			AMENDMENTS	AHSP	D.O.

DRG. SEALED :- 26-10-67 (PROV.) D.O. C.I.A.
MATERIAL :- AS ABOVE
PROTECTIVE FINISH :-
ESTIMATED MASS :-
SCALE :- 1/1

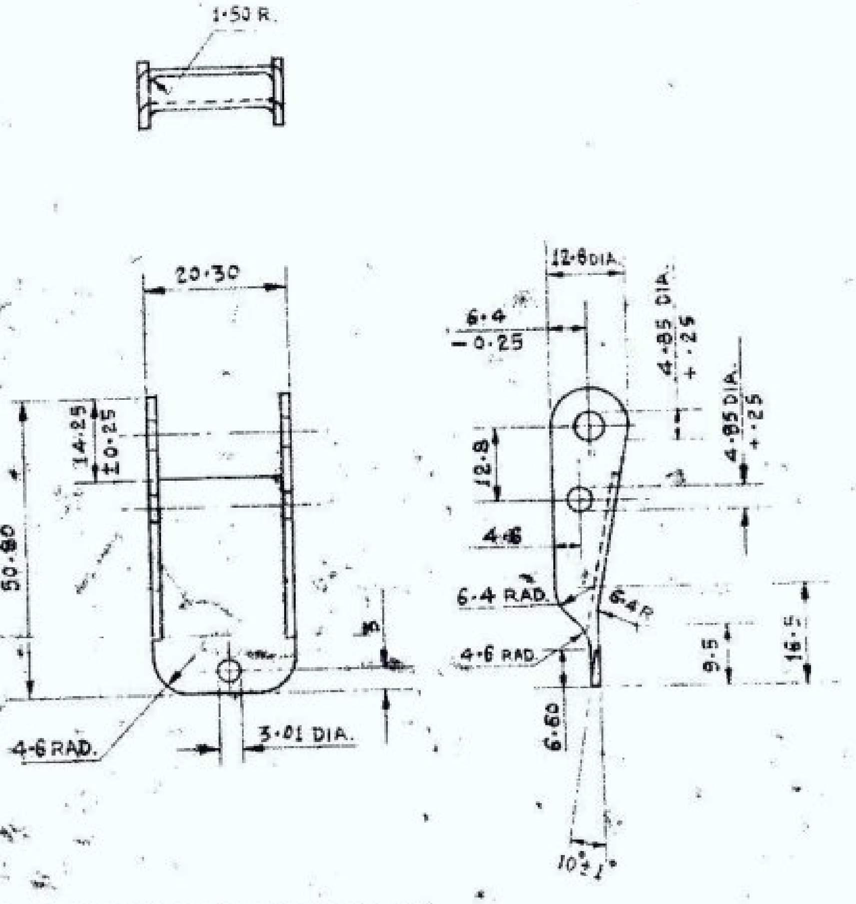
PLATE

ISV 904

FOR EXPLANATION OF DIMENSIONING ETC., SEE
THIRD ANGLE PROJECTION. DIMENSIONS ARE IN mm.

D.C.I. 28679-A

MATERIAL :-
STEEL 1·60 THICK CONFORMING TO
(a) IS: 1079-1963 GRADE ST. 34 HOT ROLLED & ANNEALED OR
(b) IS: 513-1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE 'D' OR
(c) B.S: 1449 PT. 3B 1964-C S4 COLD ROLLED & ANNEALED OR
(d) B.S: 1449 PT. 3A 1964-H S4 A HOT ROLLED & ANNEALED.



TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ± 1·3.
FOR TWO OR MORE DECIMAL PLACE ±·13.

ASSLY DRG.:- ISV 34 SA
INSP. INSTRS.:-

DRAWN	CHECKED	TRACED	TRN. CHD.
	V.R.S.	U.A.K.	[signature]

CHIEF D'MAN: SD/- (V N K RAO)
GROUP OFFICER: SD/- D.O. CIA.
APPROVED: SD/-

DATE	AUTHORITY	ZONE	NATURE	SIG. AHSP	SIG. D.O.
	D.C.I. 31625-A		DRG. CONVERTED TO SI UNITS. RATIONALISED NEW COPY OF [illegible] OF THE OLD SERIES DRG. OF THE SAME NO.		[signature]
			TRACED WITHOUT CHANGE.		[signature]
	D.C.I. 28679-A		DRAWING. PROV. SEALED.		SD/-

AMENDMENTS

SEALED:- 26-10-67 (PROV.)
MATERIAL:- AS ABOVE.
PROTECTIVE FINISH:-
ESTIMATED MASS:-

LEVER

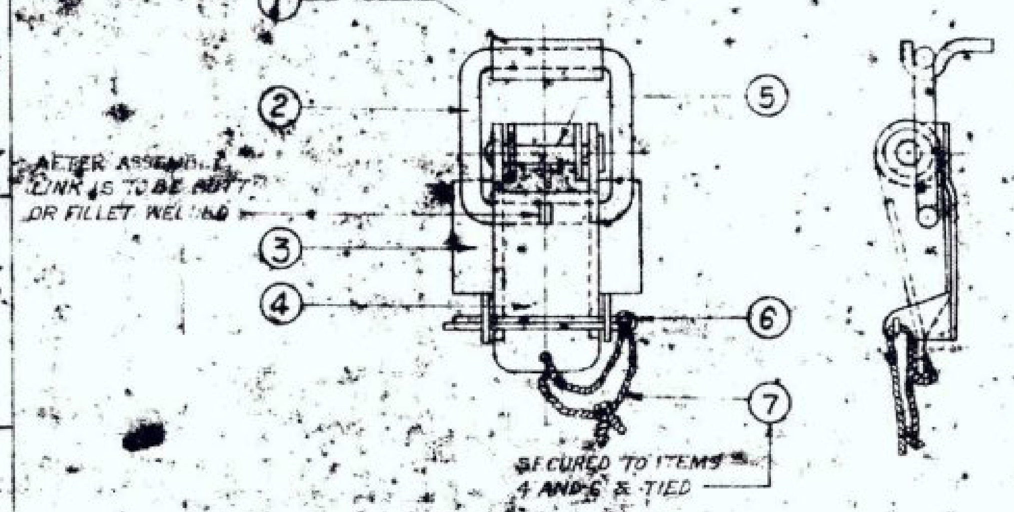
CIA/AMB
DETAIL No.
PART No.
ISV [illegible]

ISV 34 SA

DRG CONVENTIONS CONFORM TO IS 696
DIMENSIONS ARE IN mm

TOL ON UNTOL DIMENSIONS
FOR ONE DECIMAL PLACE ± 0.5
FOR TWO OR MORE DECIMAL PLACES ± 0.13

D.O.-286



LIST OF COMPONENTS

ITEM NO	DESCRIPTION	DESIGNER'S REF	PART No	No PER SET
1	PLATE HOOK	C/A/AMN/635 DET 1	ISV 90[illegible]	1
2	LINK	" " " 2	ISV 90[illegible]	1
3	PLATE LATCH	" " " 3	ISV 90[illegible]	1
4	LEVER	" " " 4	ISV 90[illegible]	1
5	RIVET, FLAT HEAD 30 LONG x 5 DIA (STEEL) TO SPECIFICATION IS 2155 (LATEST ISSUE)			1
6	SPLIT PIN, 3.2 x 36 (STEEL) TO SPECIFICATION IS 549 (LATEST ISSUE)			1
7	WHIP CORD 200 LONG		—	1

ASSY DRG ISV 335 A & ISV 336 A

DESIGNER'S REF C/A/AMN/630

ISV 34 SA

CATCH LOCKING

C/(A) KIRKEE

PART No. ISV 36SA

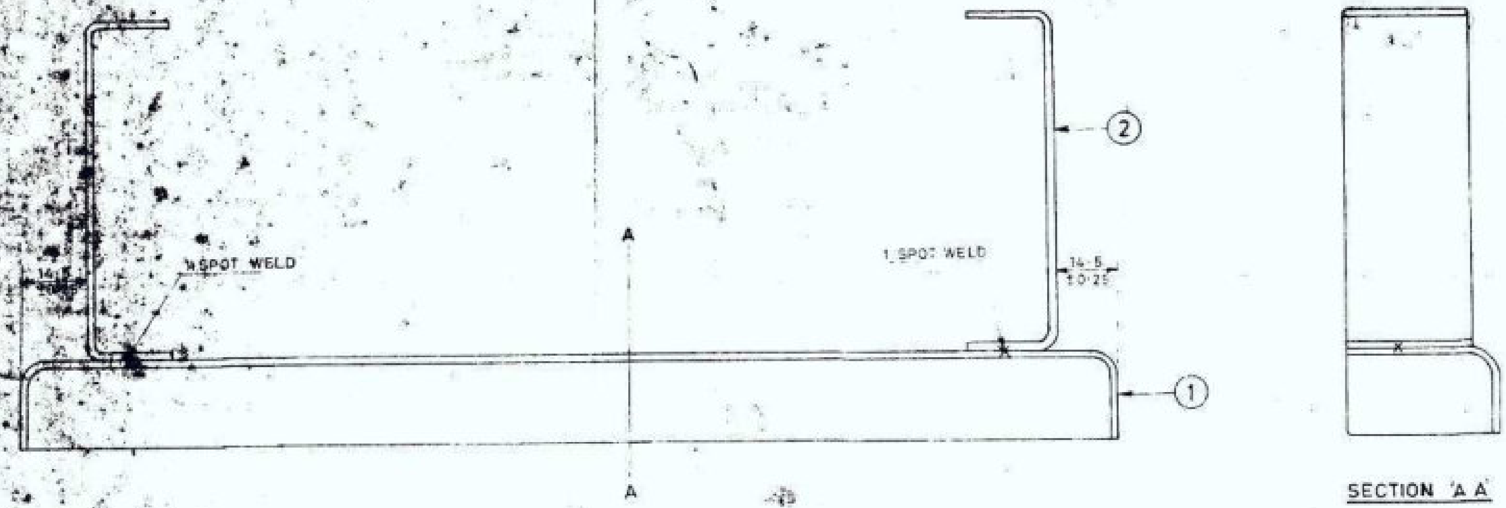
• DRG. CONVENTIONS CONFORM TO IS: 696
DIMS. ARE IN mm

D.C.I. 28679-A

TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ± 1·3.
FOR TWO OR MORE DECIMAL PLACE ± ·13.

SCHEDULE OF COMPONENTS

ITEM No.	DESCRIPTION	DESIGNER'S REF	PART No.	No. PER SET
1	PLATE 'A'	CIA/AMN/642 DETAIL 1	ISV 810	1
2	PLATE 'B'	CIA/AMN/642 DETAIL 2	ISV 811	1



SECTION 'A A'

	1/4/84		RETRACED WITHOUT CHANGE PREVIOUS D.C. Nos. 28679-A & 27125-A			
ISS No.	DATE	AUTHORITY	REVISION	ZONE	AMSR SIG.	ECD

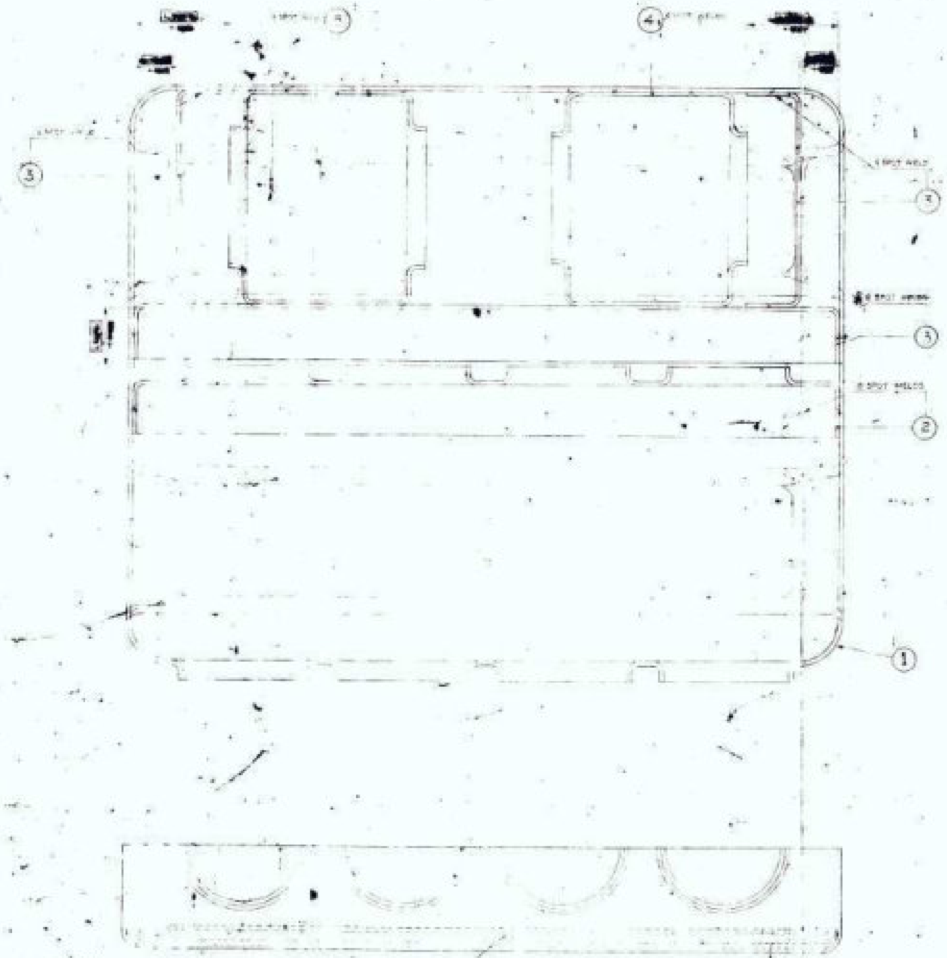
DRG. SEALED 28/10/67 (PROV.)

APPD
STATUS
PROJECTION: AS STATED
DATE - 5/1/65
SCALE
EST. MASS
GAUGE STEEL

ASSY DRG. ISV 35SA, ISV 37SA
DESIGNER'S REF: CIA/AMN/642
PART No.: ISV 36SA
CAT. No.

PLATE PARTIONIN

C.I. (A) KIRKEE



SCHEDULE OF COMPONENTS

ITEM No	DESIGNATION	PART No	DESIGNER'S REF	[illegible]
1	BODY	ISV 301	CIA/[illegible]/641 [illegible]	[illegible]
2	SUPPORT 'A'	ISV 305	CIA/[illegible]/641 [illegible]	[illegible]
3	PLATE, PARTITIONING	ISV 303A	CIA/[illegible]/642	1
4	SUPPORT 'B'	ISV 307	CIA/[illegible]/641 [illegible]	[illegible]
5	SUPPORT 'C'	ISV 305	CIA/[illegible]/641 [illegible]	[illegible]

MATERIAL:

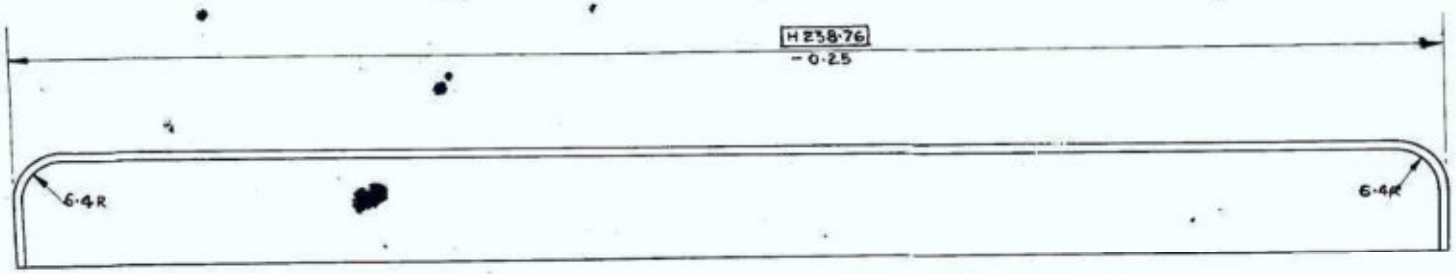
BODY UPPER

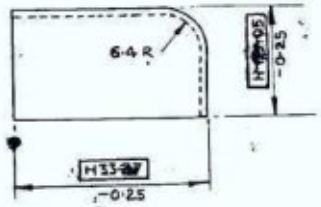
PART No
ISV 910

D.C.I. 28679-A.

~~FOR EXPLANATION OF DIMENSIONING ETC, SEE~~
THIRD ANGLE PROJECTION. DIMENSIONS ARE IN mm

NOTE:-
TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ±1·3
FOR TWO OR MORE DECIMAL PLACES ±·13





MATERIAL :-

STEEL 1·60 THICK. CONFORMING TO
(a) IS: 1079 - 1963 GRADE ST 34 HOT ROLLED & ANNEALED OR
(b) IS: 513 - 1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE 'D' OR
(c) BS: 1449 - PT 3B - 1964 CS4 COLD ROLLED & ANNEALED.
(d) BS: 1449 - PT 3A - 1964 HS4A HOT ROLLED & ANNEALED.

▭ TO BE GAUGED.

DATE	AUTHORITY	ZONE	NATURE AMENDMENTS	SIG. AHSP	SIG. D.O.
12-7-75	D.C.I. 31525-A		DRG. CONVERTED TO SI. UNITS & RATIONALISED.		
14-7-69	DCI.29286-A		VARIOUS DIMENSIONS AMENDED. NOTE ▭ TO BE GAUGED ADDED.		
21-2-68			TRACED WITHOUT CHANGE.		
26-10-67	D.C.I. 28679-A		DRAWING PROV. SEALED.		SD/-

DRG. SEALED :- 26-10-67 (PROV.)
D. D'C I.A.

PROTECTIVE FINISH:- MUST BE KEPT CLEAN & FREE FROM RUST.

MATERIAL:- AS ABOVE.

ESTIMATED MASS:-

SCALE:- 1/1

PLATE A

ASSLY DRG.:- ISV 365A.
INSP. INSTRS:-

DRAWN	CHECKED	TRACED	TRN.CHD.
	V.R.S.	M.A.K.	

CHIEF D'MAN: SD/- (V.N.K. RAO)
GROUP OFFICER: SD/- D.D.C.I.A.

APPROVED: SD/- FOR C.I.A.

DATE: 25-1-65

DESIGNER'S REF.
CIA/AMN/642
DET. AHS No 1

PART No
ISV 910

G. A. KIRKEE

4227

PART Nº **ISV 911**

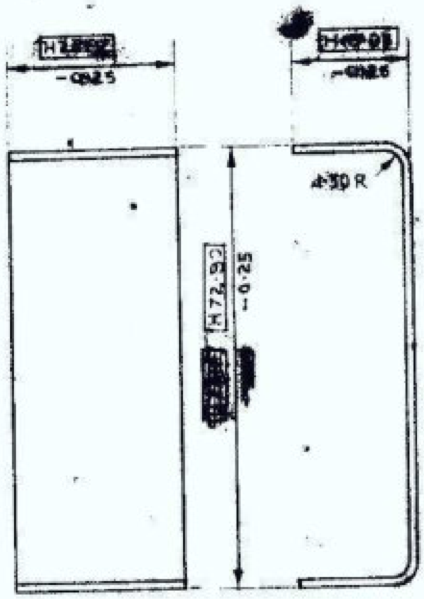
~~FOR EXPLANATION OF DIMENSIONING ETC., SEE D.D. NOTE SHEET Nº~~

THIRD ANGLE PROJECTION. DIMENSIONS ARE IN mm.

D.CI. 28679-A.

NOTE:-

TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ±1.3
FOR TWO OR MORE DECIMAL PLACE ±.13



MATERIAL:-

STEEL ... CONFORMING TO
(a) IS : 1079 - 1963 GRADE ST 34 HOT ROLLED & ANNEALED OR
(b) IS : 513 - 1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE 'D' OR
(c) BS : 1449 PT 3B - 1964 C S4 COLD ROLLED & ANNEALED OR
(d) BS : 1449 PT 3A - 1964 H S4 A HOT ROLLED & ANNEALED.

▭ TO BE GAUGED.

DATE	AUTHORITY	ZONE	NATURE	SIG. AHSP	SIG. D.O.
12-7-72	DCI.31525-A		DRG. CONVERTED TO S.I. UNITS & RATIONALISED		
14-7-69	DCI.29286A		VARIOUS DIMENSIONS AMENDED NOTE ▭ TO BE GAUGED ADDED		
2-2-68	-		TRACED WITHOUT CHANGE.		
28-11-67	DCI.28679-A		DRAWING PROV. SEALED.		SD/-

AMENDMENTS:-

ASSLY. DRG.:- ISV 36 SA.
INSP. INSTRS.:-

DRAWN	CHECKED	TRACED	TRN.CHD.
	V.R.S.	U.A.K.	

CHIEF D'MAN: SD/-
GROUP OFFICER: SD/- D.CICIA
APPROVED: FOR CIA

DRG. SEALED:- 26-10-67 (PROV.)

MATERIAL:- AS ABOVE.

PROTECTIVE FINISH:- MUST BE KEPT CLEAN & FREE FROM RUST.

ESTIMATED MASS:-

SCALE:- 1/1

DATE:- ...-1-65

DESIGNER'S REF. CIA/AMN/642

DETAIL Nº

PART Nº

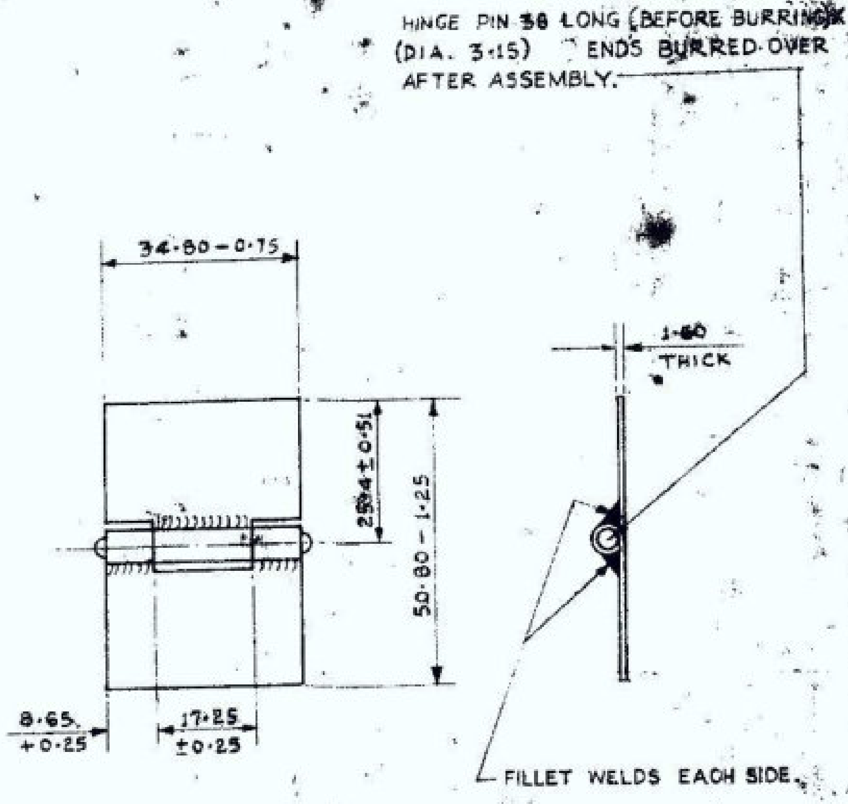
PLATE 8

PART No.	FOR EXPLANATION OF DIMENSIONING ETC., SEE THIRD ANGLE PROJECTION.	DIMENSIONS ARE IN
ISV 898		

D.C.I. 28679-A.

THIS DOCUMENT IS THE PROPERTY OF THE GOVERNMENT OF INDIA MINISTRY OF DEFENCE ... disclosed to ... purpose ... issue has been ...

TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ± 1·3.
FOR TWO OR MORE DECIMAL PLACE ± ·13.



MATERIAL:-

STEEL 1·60 THICK CONFORMING TO
(a) IS: 1079-1963 GRADE ST. 34 HOT ROLLED & ANNEALED OR
(b) IS: 513-1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE 'D' OR
(c) BS: 1449 PT. 3B-1964-CS4 COLD ROLLED & ANNEALED OR
(d) BS: 1449 PT. 3A-1964-HS4A HOT ROLLED & ANNEALED.

WIRE STEEL CONFORMING TO IS: 280 HALF HARD & BRIGHT DRAWN.

DATE	AUTHORITY	ZONE	NATURE	SIG. AHSP	SIG. D.O.
12-7-78	DCI 38523-A		DRG. CONVERTED TO SI UNITS & RATIONALISED		
13-3-68	DCI 28785-A		ASSLY. DRG. REF. WAS ISV 4 A.		
9-3-68			TRACED WITHOUT CHANGE.		
26-10-67	D.C.I. 28679-A		DRAWING PROV. SEALED.		SD/-
			AMENDMENTS		

ASSLY. DRG.:- ISV 335A
INSP. INSTRS:-

DRAWN	CHECKED	TRACED	TRN. CHD.
	V.R.S	CGK	

CHIEF D'MAN: SD/-
GROUP OFFICER: SD/- D.O. CIA
APPROVED: for ...

DRG. SEALED:- 26-10-67 (PROV.) D.O. CIA

DATE:- 5-1-65.
DESIGNER'S REF. CIA/AMN/641
DETAIL No. 1.

MATERIAL:- AS ABOVE.
PROTECTIVE FINISH:-
ESTIMATED MASS:-
SCALE:- 1/1.

PART No. ISV 898

HINGE

C.I.A. KIRKEE

1 2 3

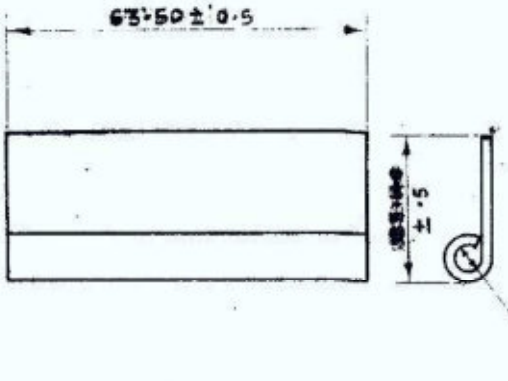
9255

ISV 899

THIRD ANGLE PROJECTION.

DIMENSIONS ARE IN m/m

D.C.I. 28579-A.



TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ± 1·3.
FOR TWO OR MORE DECIMAL PLACE ± ·13.

MATERIAL :—

STEEL [illegible] CONFORMING TO

(a) IS:1079-1963 GRADE ST 34 HOT ROLLED & ANNEALED OR
(b) IS:5[illegible]-1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE 'D' OR
(c) BS:1449 PT 3B-1964-C 54 COLD ROLLED & ANNEALED OR
(d) BS:1449 PT 3A-1964-H 54 A HOT ROLLED & ANNEALED.

DATE	AUTHORITY	ZONE	NATURE AMENDMENTS	SIG. AHSP	SIG. D.O.
22-7-75	D.C.I.31585-A		DRG. CONVERTED [illegible] RATIONALISED.		
[illegible]	D.C.I. 28785-A		ASSLY. DRG. REF. WAS ISV.4A.		
[illegible]			TRACED WITHOUT CHANGE.		
28-10-67	D.C.I.28679-A		DRG. PROV. SEALED.		SD/-

ASSLY. DRG. :- ISV 335A

INSP. INSTRS. :—

DRAWN	CHECKED	TRACED	TRN. CHD.
		F.A.MULLA	

CHIEF D'MAN: SD/- V.N.K.RAO

GROUP OFFICER: SD/- D.O. CIA

APPROVED FOR CIA

DRG. SEALED :- 28-10-67 (PROV.) D.O. CIA

DATE :- 5-1-68.

DESIGNER'S REF. CIA/AMN/641

DETAIL No. 2

PART No. ISV 899

MATERIAL :- AS ABOVE.

PROTECTIVE FINISH :- MUST BE KEPT CLEAN AND FREE FROM RUST.

ESTIMATED MASS :-

SCALE :- 1/1

PLATE A

C.I.A. KURE

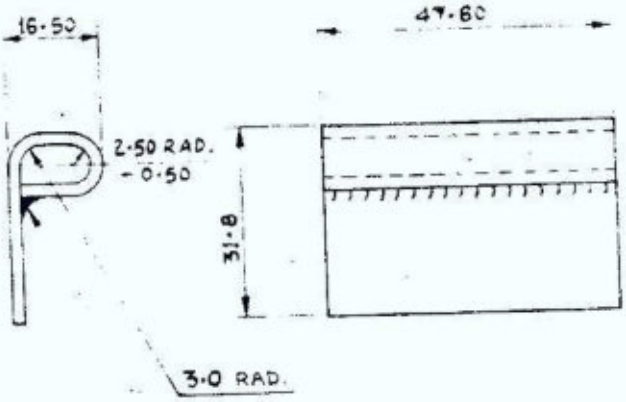
4260

PART Nº ISV 900

FOR EXPLANATION OF DIMENSIONING ETC., SEE THIRD ANGLE PROJECTION.

DIMENSIONS ARE IN MM.

D.C.I. 28679-A



TOL. ON UNTOL. DIMS.
FOR ONE DECIMAL PLACE ± 1·3.
FOR TWO OR MORE DECIMAL PLACE ± ·13.

MATERIAL :-
STEEL 1·60 THICK CONFORMING TO
(a) IS : 1079-1963 GRADE ST 34 HOT ROLLED & ANNEALED OR
(b) IS : 513-1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE 'D' OR
(c) BS : 1449 PT 3B-1964 CS4 COLD ROLLED & ANNEALED OR
(d) BS : 1449 PT 3A-1964 HS4 A HOT ROLLED & ANNEALED.

DEVELOPED LENGTH 61·0

DATE	AUTHORITY	ZONE	NATURE OF AMENDMENTS	SIG. AHSP	SIG. D.O.
12-7-75	DCI 31525-A		DRG. CONVERTED TO SI UNITS & RATIONALISED.		
15-3-68	DCI 28785-A		ASSLY. DRG. REF. WAS ISV4A.		
9-3-68			TRACED WITHOUT CHANGE.		SD/-
26-10-67	D.C.I. 28679-A		DRAWING PROV. SEALED.		

DRG. SEALED :- 26-10-67 (PROV.) D.O. CIA.

MATERIAL :- AS ABOVE.

PROTECTIVE FINISH :- MUST BE KEPT CLEAN & FREE FROM RUST.

ESTIMATED MASS

SCALE :- 1/1

PLATE

ASSLY DRG. :- ISV 336A

INSP INSTRS. :-

DRAWN	CHECKED	TRACED	TRN.CHD.
	V.R.S.	U.A.K.	

CHIEF D'MAN: SD/- (V N K RAO)

GROUP OFFICER: SD/- D.O. CIA.

APPROVED FOR

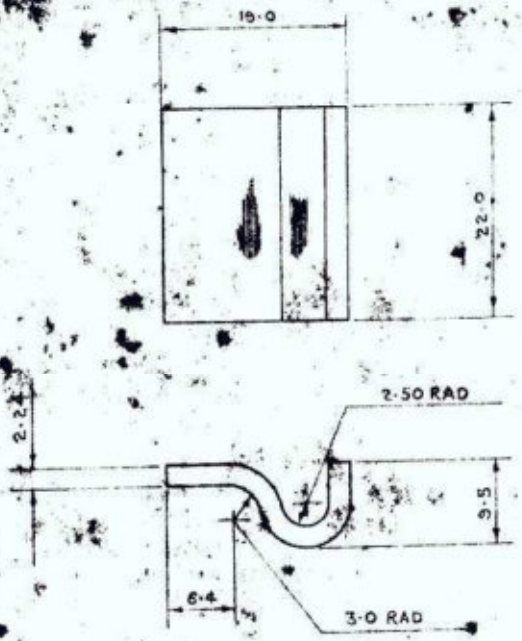
DATE :- 5-1-65

DESIGNER'S REF. CIA/AMN/641

DETAIL Nº 3

PART Nº ISV 900

CONFORM TO IS ... ARE IN mm



NOTE :-

TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ± 1·3
FOR TWO OR MORE DECIMAL PLACES ± ·13

MATERIAL :-

STEEL, 3·0 THICK CONFORMING TO
a) IS: 1079 - 1963 GRADE ST 34 HOT ROLLED & ANNEALED OR
b) IS: 513 - 1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE 'D' OR
c) BS: 1449 PT 3B - 1964 - C 54 COLD ROLLED & ANNEALED OR
d) BS: 1449 PT 3A - 1964 - H 54 HOT ROLLED & ANNEALED

DEVELOPED LENGTH 28·7

R.No	DATE	AUTHORITY	REVISION	ZONE	AHSP 616	D.O. SD/-
	15-10-65		RETRACED WITHOUT CHANGE. PREVIOUS D.C.E.(I) Nos. 28679-A & 31525-A.			
DRG. SEALED :- 26-10-67 (PROV.)						

DRN	CHD V.R.S.	TCD RDT	COMP
SD/- C.D'MAN	SD/- O/C DO	SCALE :- 2:1	
APPD	SD/- FOR C.I.(A)	EST. MASS :-	
		GAUGE SCHD :-	
		DATE :- 5-1-65	
MATL :- AS ABOVE			
PROTECTIVE FINISH :-			

ASSY. DRG. ISV 34 SA

DESIGNER'S REF. CIA/AMN/638 DETAIL No 1

PART No ISV 901

D.S. CAT No

AHSP :- C.I.(A) KIRKEE

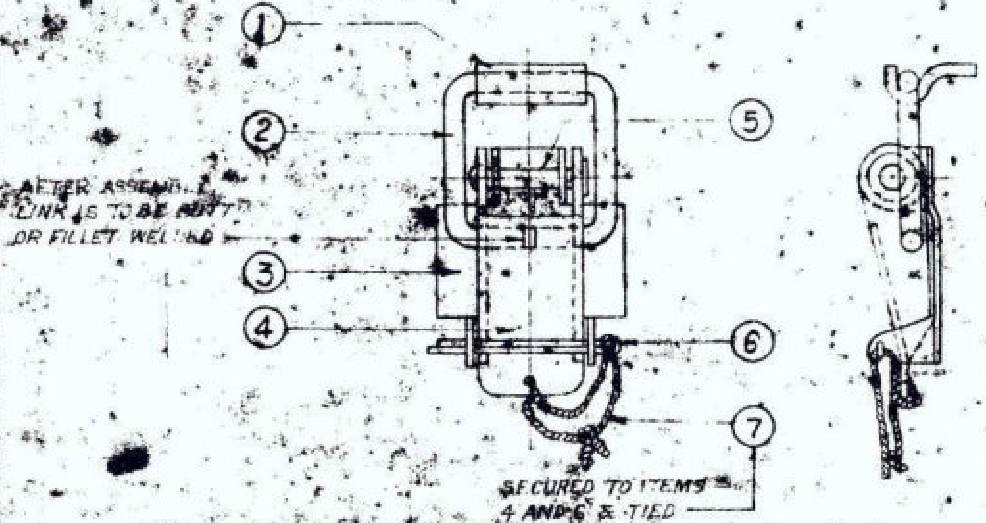
PLATE, HOOK

ISV 34 5A

DRG CONVENTIONS CONFORM TO IS 696

DIMENSIONS ARE IN MM

TOL ON UNTOL DIMENSIONS
FOR ONE DECIMAL PLACE ± 0.8
FOR TWO OR MORE DECIMAL PLACES ± 0.13



LIST OF COMPONENTS

ITEM No	DESCRIPTION	DESIGNER'S REF	PART No	No PER SET
1	PLATE HOOK	C/A/AMN/635 DET 1	ISV 90[illegible]	1
2	LINK	" " " 2	ISV 90[illegible]	1
3	PLATE CATCH	" " " 3	ISV 90[illegible]	[illegible]
4	LEVER	" " " 4	ISV 90[illegible]	[illegible]
5	RIVET, FLAT HEAD 20 LONG x 5 DIA (STEEL) TO SPECIFICATION IS 2155 (LATEST ISSUE)			1
6	SPLIT PIN, 3.2 x 36 (STEEL) TO [illegible] IS 548 (LATEST ISSUE)			1
7	WHIP CORD 208 LONG		–	1

ASSY DRG ISV 335 A & ISV 336 A

DESIGNER'S REF C/A/AMN/6[illegible]

PART No ISV 34 5A

CATCH LOCKING

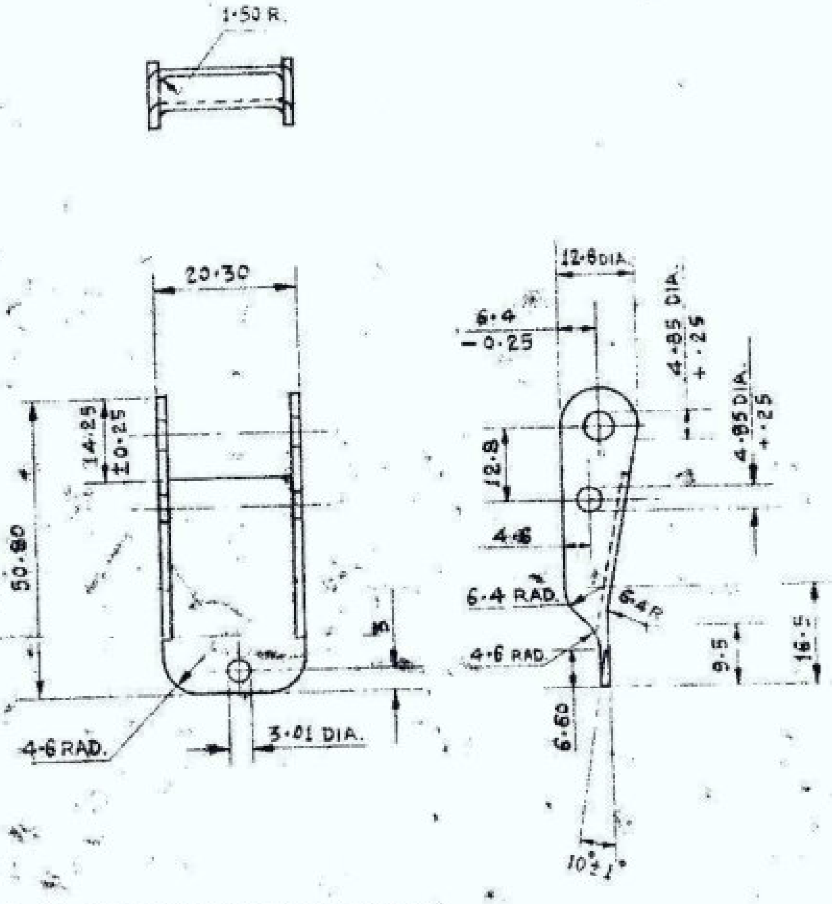
C(A) [illegible]

ISV 904

FOR EXPLANATION OF DIMENSIONING ETC., SEE
THIRD ANGLE PROJECTION. DIMENSIONS ARE IN mm.

D.C.I. 28679-A

MATERIAL :-
STEEL 1·60 THICK CONFORMING TO
(a) IS: 1079-1963 GRADE ST. 34 HOT ROLLED & ANNEALED OR
(b) IS: 513-1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE 'D' OR
(c) BS: 1449 PT. 3B 1964 - CS4 COLD ROLLED & ANNEALED OR
(d) BS: 1449 PT. 3A 1964 - HS4A HOT ROLLED & ANNEALED.



TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ± 1·3.
FOR TWO OR MORE DECIMAL PLACE ±·13.

ASSLY. DRG. :- ISV 34 SA
INSP. INSTRS. :-

DRAWN	CHECKED	TRACED	TRN. CHD.
	V.R.S.	U.A.K.	[signature]

CHIEF D'MAN: SD/- (V N K RAO)
GROUP OFFICER: SD/- D.O. CIA.

DATE	AUTHORITY	ZONE	NATURE	SIG. AHSP	SIG. D.O.
	D.C.I. 31625-A		DRG. CONVERTED TO SI UNITS, RATIONALISED, NEW COPY OF [illegible] OF THE OLD SERIES DRG. OF THE SAME NO.		[signature]
			TRACED WITHOUT CHANGE.		
	D.C.I. 28679-A		DRAWING PROV. SEALED.		SD/-

AMENDMENTS

APPROVED SD/-

SEALED :- 26-10-67 (PROV.)
D.O. CIA.
MATERIAL :- AS ABOVE.
PROTECTIVE FINISH :-
ESTIMATED MASS :-
CIA/AMMN

DETAIL No.
PART No.

LEVER

ISV 904

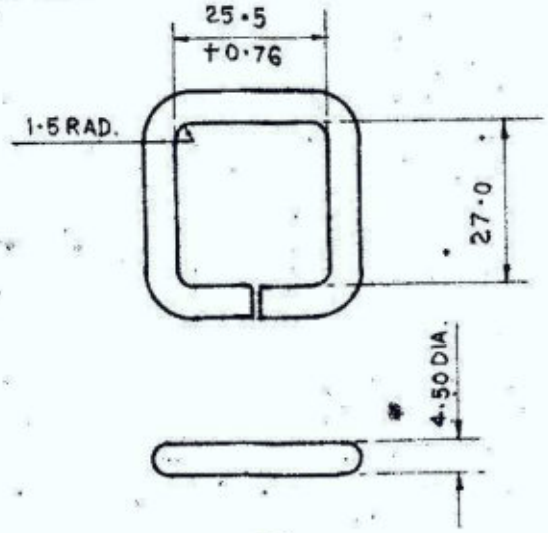
(10)

4	3	2	1

PART No. ISV 902

DRG. CONVENTIONS CONFORM TO IS : 696
DIMENSIONS ARE IN mm.

D.C.I. 28679-A.



MATERIAL :- WIRE STEEL CONFORMING TO IS:280 HALF HARD BRIGHT DRAWN.

TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ± 1·3 .
FOR TWO DECIMAL PLACES ± ·13 .

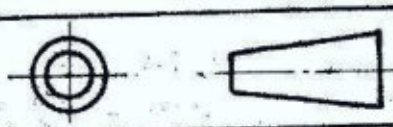
DEVELOPED LENGTH :- 120·65

R. No	DATE	AUTHORITY	REVISION	ZONE	AHSP.	D.O.
	6-10-65		RETRACED WITHOUT CHANGE.			SD/-
			PREVIOUS D.C.(I) No. 28679-A & 31525-A.			

DRG. SEALED:- 26-10-67 (PROV.)

DRN.	CHD. V.R.S.	TCD.M.A.K.	COMP.
SD/- CD'MAN	SD/- O/C D.O.	SCALE:- 1/1	
APPD. SD/- FOR C.I.(A)		EST MASS:-	
		GAUGE SCHD:-	
		DATE:- 5-1-65	

ASSLY DRG. ISV 34SA



MATL:- AS ABOVE
PROTECTIVE FINISH:-

DESIGNER'S REF.
CIA/AMN/636 . DET. No. 2

PART No. ISV 902

D.S.CAT No.

LINK

AHSP :- C.I.(A) KIRKEE

12696

PART No. 1SV 903

~~FOR EXPLANATION OF DIMENSIONING ETC., SEE D.D. NOTE SHEET~~

THIRD ANGLE PROJECTION.

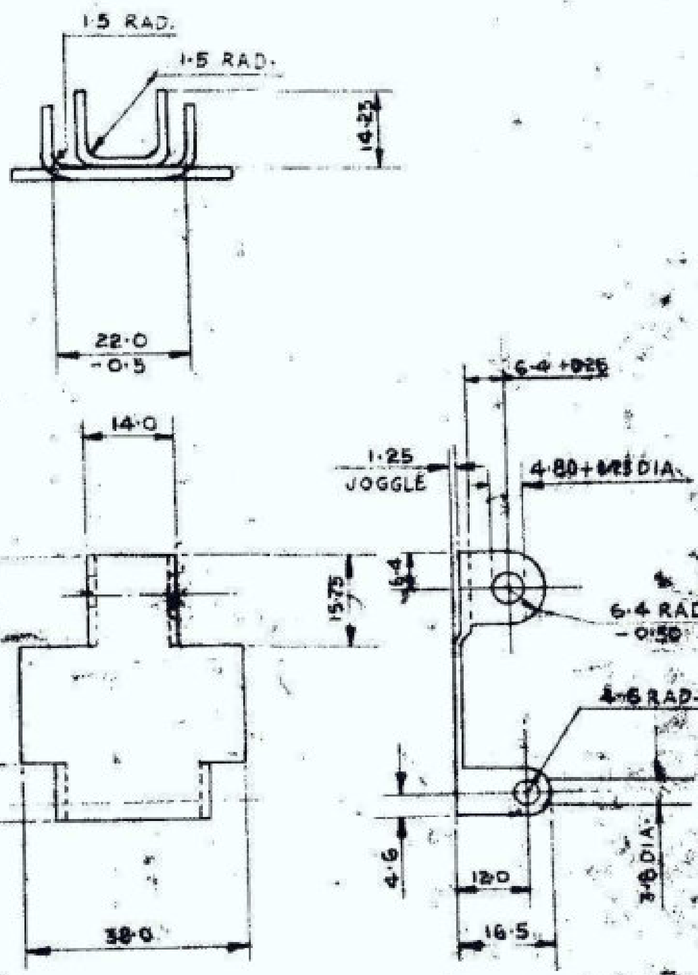
DIMENSIONS ARE IN

NOTE:- TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ±1.3
FOR TWO OR MORE DECIMAL PLACES ±.15

MATERIAL :-

STEEL, 1.60 THICK CONFORMING TO

(a) I.S : 1079 – 1963 GRADE ST. 34 HOT ROLLED & ANNEALED OR
(b) I.S : 513 – 1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE 'D' OR
(c) B.S : 1449 PT. 3B, 1964 · CS4 COLD ROLLED & ANNEALED. OR
(d) B.S : 1449 PT. 3A, 1964 - HS4 A HOT ROLLED & ANNEALED.



DEVELOPED WIDTH = 53.0

				ASSY. DRG. –
				INSP. INSTRS:-
				DRAWN CHECKED
				V.R.S
		METRICATED & ... CONVERTED TO SI. UNITS ... NEW COPY OF DRG. SEALED IN SUPERSESSION OF THE EXISTING DRG. OF SAME NO.		CHIEF D'MAN
		TRACED WITHOUT CHANGE		
		DRAWING PROV. SEALED		
DATE	AUTHORITY	ZONE	NATURE	
			AMENDMENTS	AHSP D.O.

DRG. SEALED :- 26-10-67 (PROV.) D.O.

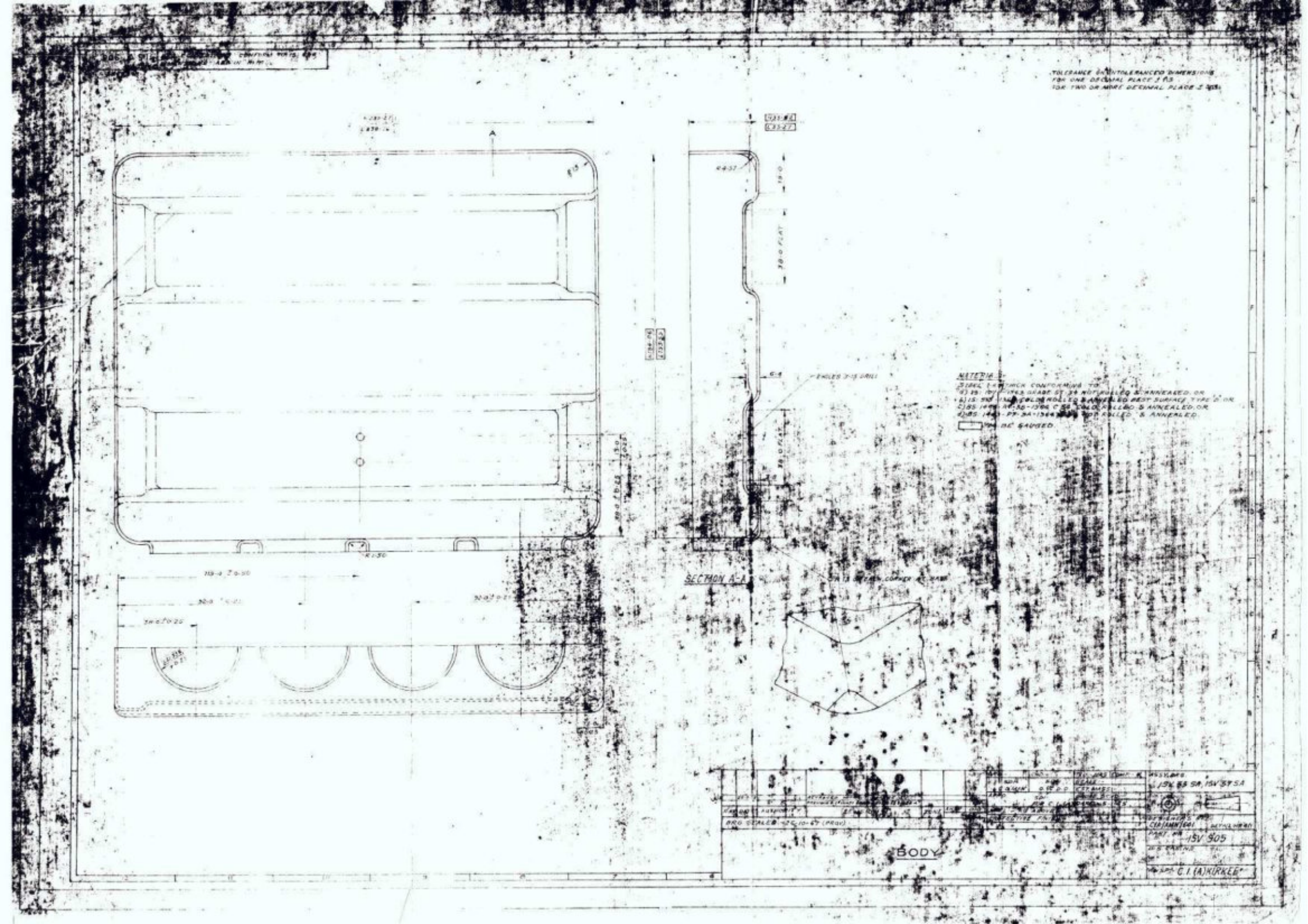
MATERIAL :- AS ABOVE

PROTECTIVE FINISH :-

ESTIMATED MASS :-

SCALE :-

PLATE

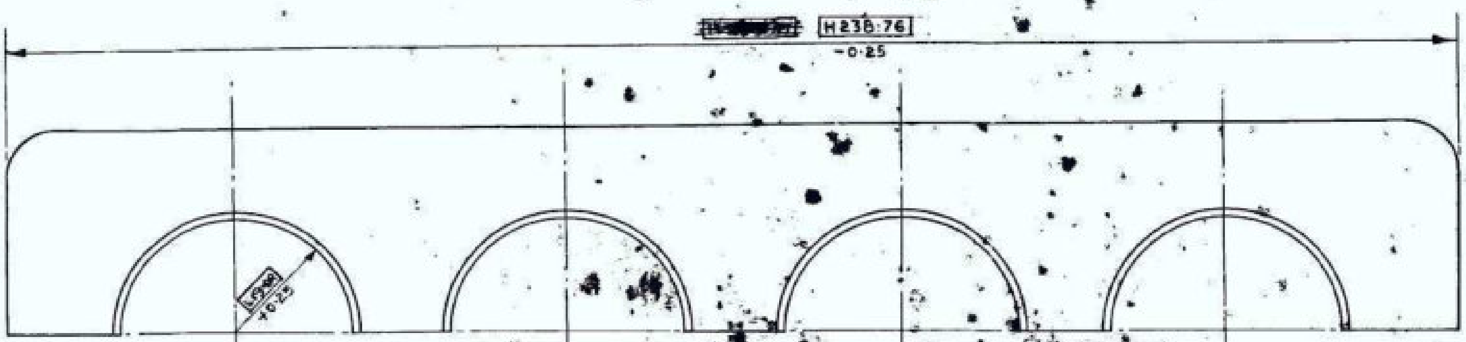

SECTION A-A
BODY

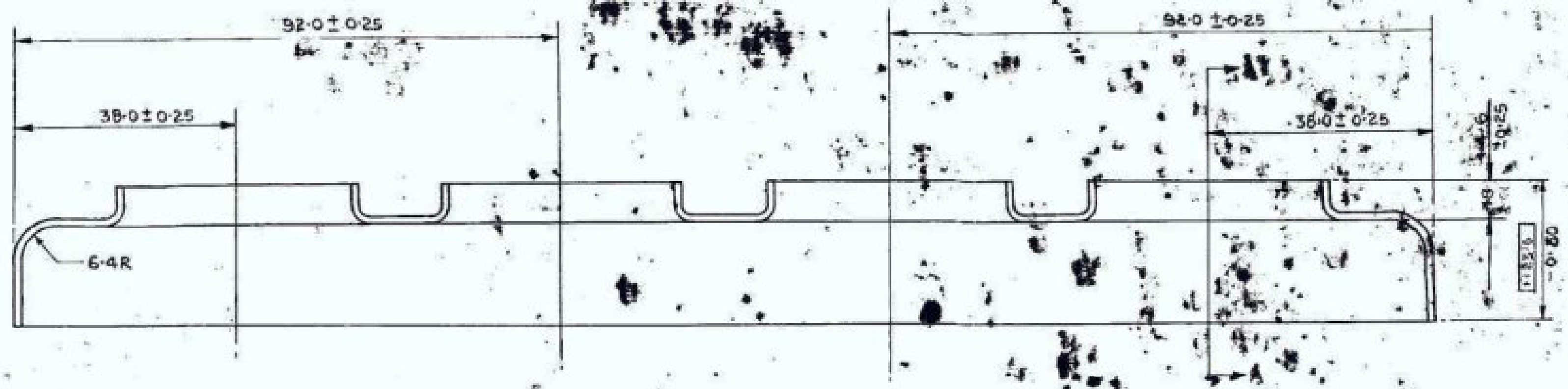
PART Nº ISV 906

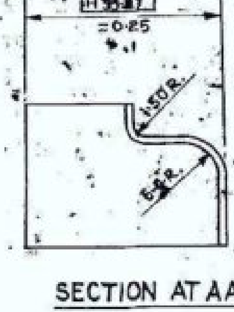
D.C.I. 28679-A.

~~FOR EXPLANATION OF DIMENSIONING ETC., SEE D.D. NOTE SHEET Nº 8.~~

THIRD ANGLE PROJECTION. DIMENSIONS ARE IN mm.







SECTION AT AA.

MATERIAL:-

STEEL 1·60 THICK CONFORMING TO

(a) IS: 1079-1963 GRADE ST 34 HOT ROLLED & ANNEALED OR
(b) IS: 513-1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE 'D' OR
(c) BS: 1449 PT 3B-1964-C S4 COLD ROLLED & ANNEALED OR
(d) BS: 1449 PT 3A-1964-H S4 A HOT ROLLED & ANNEALED.

▭ TO BE GAUGED.

NOTE:-
TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ±1·3
FOR TWO OR MORE DECIMAL PLACES ±·13

DATE	AUTHORITY	ZONE	NATURE AMENDMENTS	SIG. AHSP	SIG. D.O.
12-7-75	D.C.I. 31525-A		DRG. CONVERTED TO S.I. UNITS & RATIONALISED.		
14-7-69	D.C.I. 29286-A		VARIOUS DIMENSIONS AMENDED & ADDED NOTE ▭ TO BE GAUGED ADDED.		
6-3-68			TRACED WITHOUT CHANGE.		
26-10-67	D.C.I. 28679-A		DRAWING PROV. SEALED.		SD/-

DRG. SEALED:- 26-10-67. (PROV.)

D.O. C.I.A.

THIS DOCUMENT IS THE PROPERTY OF GOVT. OF INDIA, MINISTRY ...

PROTECTIVE FINISH:- MUST BE KEPT CLEAN & FREE FROM RUST.

MATERIAL:- AS ABOVE.

ESTIMATED MASS:-

SCALE:- 1/1.

SUPPORT A

ASSLY. DRG.:- ISV 355A. ISV 375A

INSP. INSTRS:-

DRAWN	CHECKED	TRACED	TRN. CHD.
	V.R.S.	C.G.K.	

CHIEF D'MAN SD/- (V.N.K. RAO)

GROUP OFFICER SD/- D.O.

APPROVED FOR CIA

DATE:- 5-1-65.

DESIGNER'S REF. CIA/AMN/641

DETAIL Nº 4/2.

PART Nº ISV 906

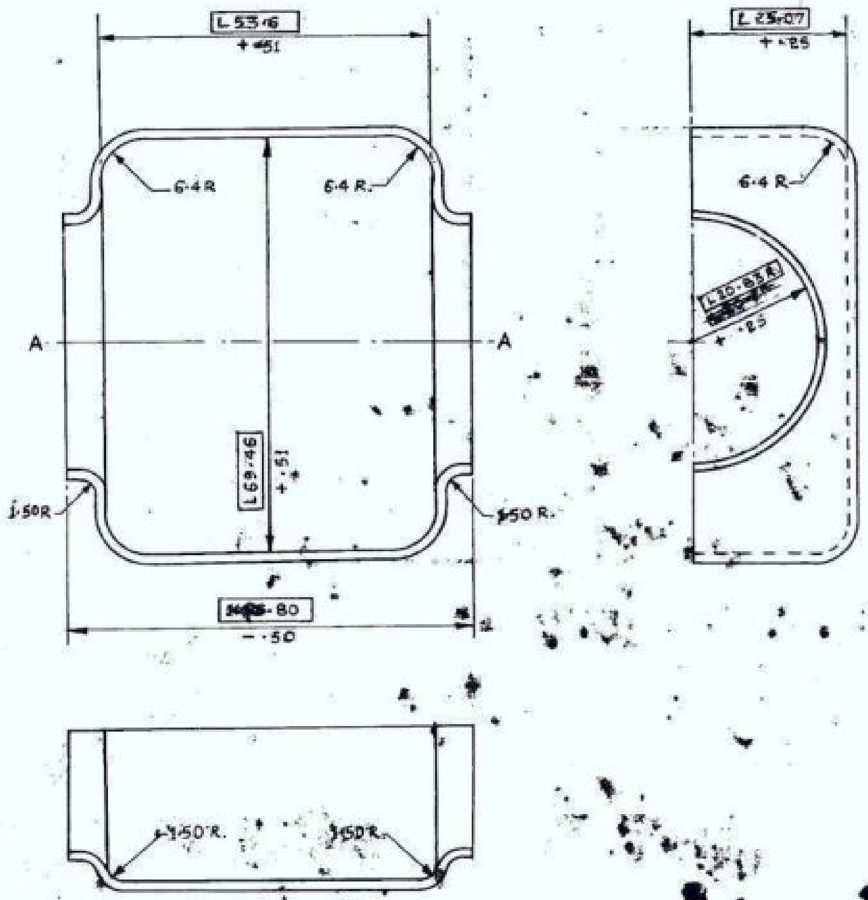
C.I.A. KIRKEE

4248.

PART NO.
ISV 907
D.C.I. 28679-A.

FOR EXPLANATION OF DIMENSIONING ETC., SEE THIRD ANGLE PROJECTION.

DIMENSIONS ARE IN mm.



SECTION A-A

TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ± 1·3.
FOR TWO OR MORE DECIMAL PLACES ± ·13.

MATERIAL:-

STEEL 1·60 THICK CONFORMING TO.
(a) IS: 1079-1963 GRADE ST 34 HOT ROLLED & ANNEALED OR
(b) IS: 513-1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE 'D' OR
(c) BS: 1449 PT-3B-1964-C S4 COLD ROLLED & ANNEALED OR
(d) BS: 1449 PT-3A-1964-R S4 A HOT ROLLED & ANNEALED.

▭ TO BE GAUGED.

DATE	AUTHORITY	ZONE	NATURE	SIG. AHSP	SIG. D.O.
12-7-75	DCI.31525-A		DRG. CONVERTED TO SI UNITS & RATIONALISED		
14-7-69	DCI.29286-A		VARIOUS DIMENSIONS AMENDED & ADDED NOTE "▭ TO BE GAUGED" ADDED.		
16-2-68			TRACED WITHOUT CHANGE.		
26-10-67	D.C.I.28679-A		DRAWING PROV. SEALED.		SD/-

AMENDMENTS

DRG. SEALED:-26-10-67 (PROV.)

D.O.C.I.A.

PROTECTIVE FINISH:- MUST BE KEPT CLEAN AND FREE FROM RUST.

MATERIAL:- AS ABOVE.

ESTIMATED MASS:-

SCALE:- 1/1.

SUPPORT B

ASSLY. DRG.:- ISV 35 SA. ISV 37 SA.

INSP. INSTRS:-

DRAWN	CHECKED	TRACED	TRN.CHD.
	V.R.S.	C.G.K.	

CHIEF D'MAN: SD/- (N.K.RAO)

GROUP OFFICER: SD/- D.O.CIA

APPROVED. SD/- for CIA

DATE:- 5-1-65.

DESIGNER'S REF. CIA/AMN/641.

DETAIL NO. 4/3.

PART NO. ISV 907

C.I.A. KIRKEE.

4223.

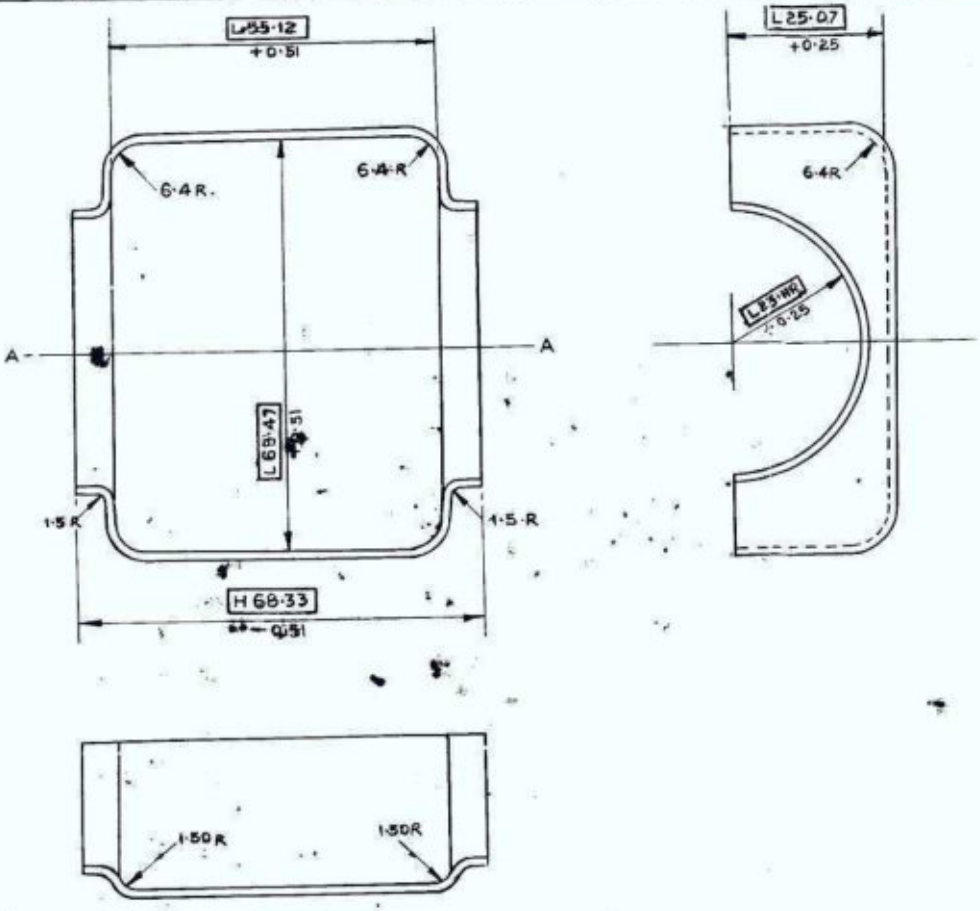
PART No. ISV 908

D.C.I. 28679-A.

~~FOR EXPLANATION OF DIMENSIONING ETC., SEE D.D. NOTE SHEET No. 3.~~

THIRD ANGLE PROJECTION

DIMENSIONS ARE IN mm



SECTION A A

NOTE:-
TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ±1·3
FOR TWO OR MORE DECIMAL PLACES ±·13

MATERIAL

STEEL 1·60 THICK . . CONFORMING TO
(a) IS : 1079 - 1963 GRADE ST 34 HOT ROLLED & ANNEALED OR
(b) IS : 513 - 1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE 'D' OR
(c) BS : 1449 PT 3B · 1964 · C S4 COLD ROLLED & ANNEALED OR
(d) BS : 1449 PT 3A - 1964 - HS4A HOT ROLLED & ANNEALED.

▭ TO BE GAUGED.

DATE	AUTHORITY	ZONE	NATURE	SIG. AHSR	SIG. D.O.
			AMENDMENTS		
12-7-75	DCI.31525-A		DRG. CONVERTED TO S.I. UNITS & RATIONALISED.		
14-7-69	DCI.29286-A		VARIOUS DIMENSIONS AMENDED & ADDED NOTE "▭ TO BE GAUGED" ADDED.		
17-2-68			TRACED WITHOUT CHANGE.		
26-10-67	D.C.I.28679-A		DRG. PROV. SEALED.		SD/-

DRG. SEALED :- 26-10-67 (PROV.)

D.O. CIA.

PROTECTIVE FINISH :- MUST BE KEPT CLEAN AND FREE FROM RUST.

MATERIAL :- AS ABOVE.

ESTIMATED MASS :-

SCALE :- 1/1

SUPPORT C

ASSLY DRG. :- ISV 355A ISV 375A

INSP. INSTRS :-

DRAWN	CHECKED	TRACED	TRN. CHD.
-	V.R.S.	M.A.K.	

CHIEF D'MAN	GROUP OFFICER
SD/- (VNK RAO)	SD/- D.O. CIA.

APPROVED FOR CIA.

DATE :- 5-1-65

DESIGNER'S REF.

CIA/AMN/641

DETAIL No. 4/4

PART No.

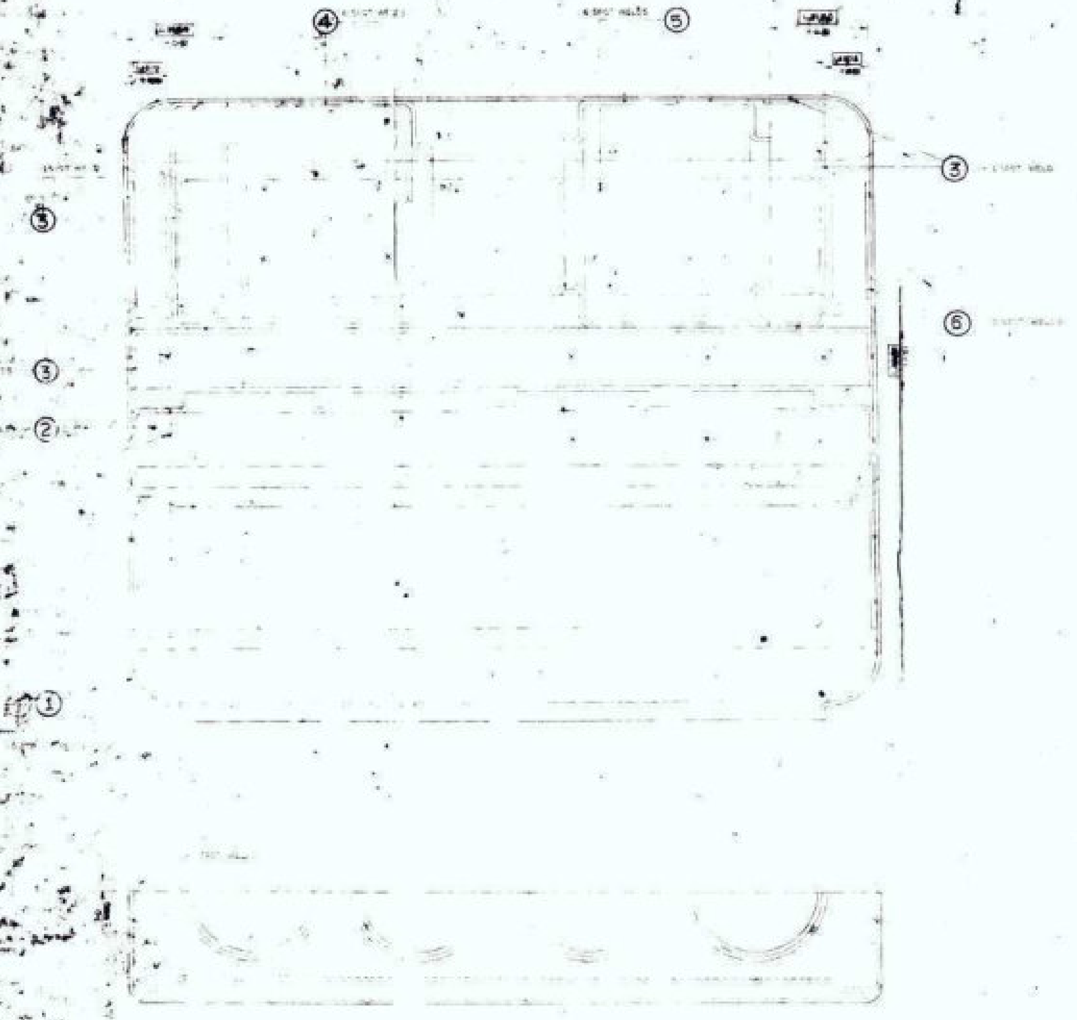
ISV 908

C.I.A. KIRKEE

4224.

SCHEDULE OF COMPONENTS

	DESIGNATION	MAT'L	DESIGNER'S
1	BODY	[illegible]	[illegible]
2	[illegible]	[illegible]	[illegible]
3	PLATE, [illegible]	[illegible]	[illegible]
4	[illegible]	[illegible]	[illegible]
5	[illegible]	[illegible]	[illegible]
6	PLATE, STOP	[illegible]	[illegible]
7			



MATERIAL:-

[illegible]

TO BE [illegible]

NOTE:- [illegible]

FOR ONE DECIMAL PLACES [illegible]

FOR TWO OR MORE DECIMAL PLACES [illegible]

BODY, LOWER

S.V.-25

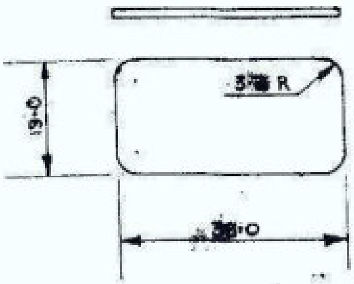
PART NR ISV:909

~~FOR EXPLANATION OF DIMENSIONING ETC., SEE D.D. NOTE SHEET NR 5.~~

THIRD ANGLE PROJECTION. DIMENSIONS ARE IN mm:

D.C.I 28679-A.

NOTE:-
TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ±1.3
FOR TWO OR MORE DECIMAL PLACES ±.13



MATERIAL:-

STEEL, 1.60 THICK :- CONFORMING TO
(a) IS: 1079 – 1963 GRADE ST. 34 HOT ROLLED & ANNEALED OR
(b) IS: 513 – 1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE D OR
(c) BS: 1449 PT. 3B-1964-CS4 COLD ROLLED & ANNEALED OR
(d) BS 1449 PT. 3A-1964-HS4A HOT ROLLED & ANNEALED.

DATE	AUTHORITY	ZONE	NATURE	SIG. AHGH	SIG. D.O.
18-7-75	D.C.I. 31525-A		DRG CONVERTED TO SI. UNITS & RATIONALISED.		
9-3-60			TRACED WITHOUT CHANGE.		
26-10-67	D.C.I. 28679 A		DRAWING PROV SEALED.		SD/-

AMENDMENTS

ASSLY. DRG :- ISV 38 SA - ISV 38 SA

INSP. INSTRS :-

DRAWN	CHECKED	TRACED	TRN. CHD.
	V.R.S.	J.R.N.	[signature]

CHIEF D'MAN	GROUP OFFICER
SD/- (V.N.K. RAO)	SD/- D.O. CIA

APPROVED :- SD/- FOR CIA

DATE :- 65

DESIGNER: CIA/AMN/G34

DETAILER:

PART NR ISV. 909

DRG. SEALED :- 26-10-67 (PROV) D.G. CIA

MATERIAL :- AS ABOVE

PROTECTIVE FINISH :-

ESTIMATED MASS :-

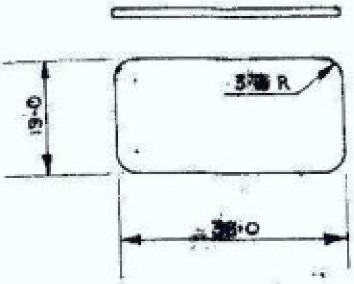
SCALE :- 1/1

PLATE, STOP.

PART NR ISV.909	~~FOR EXPLANATION OF DIMENSIONING ETC., SEE D.D NOTE SHEET NR 8.~~ THIRD ANGLE PROJECTION. DIMENSIONS ARE IN ~~mm~~ :

D.C.I 28679-A.

NOTE:-
TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ±1·3
FOR TWO OR MORE DECIMAL PLACES ±·13



MATERIAL :-

STEEL, 1·60 THICK CONFORMING TO
(a) IS : 1079 - 1963 GRADE ST. 34 HOT ROLLED & ANNEALED OR
(b) IS : 513 - 1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE D OR
(c) BS : 1449 PT. 3B - 1964 - C S 4 COLD ROLLED & ANNEALED OR
(d) BS 1449 PT. 3A - 1964 - H S 4 A HOT ROLLED & ANNEALED.

DATE	AUTHORITY	ZONE	NATURE	SIG. AHSP	SIG. D.O.
12-7-75	D.C.I. 31523-A		DRG. CONVERTED TO S.I. UNITS & RATIONALISED.		
9-3-68			TRACED WITHOUT CHANGE.		
26-10-67	D.C.I. 28679-A		DRAWING PROV SEALED.		SD/-
			AMENDMENTS		

ASSLY. DRG :- ISV 38 SA - ISV 38 3A
INSP. INSTRS :-

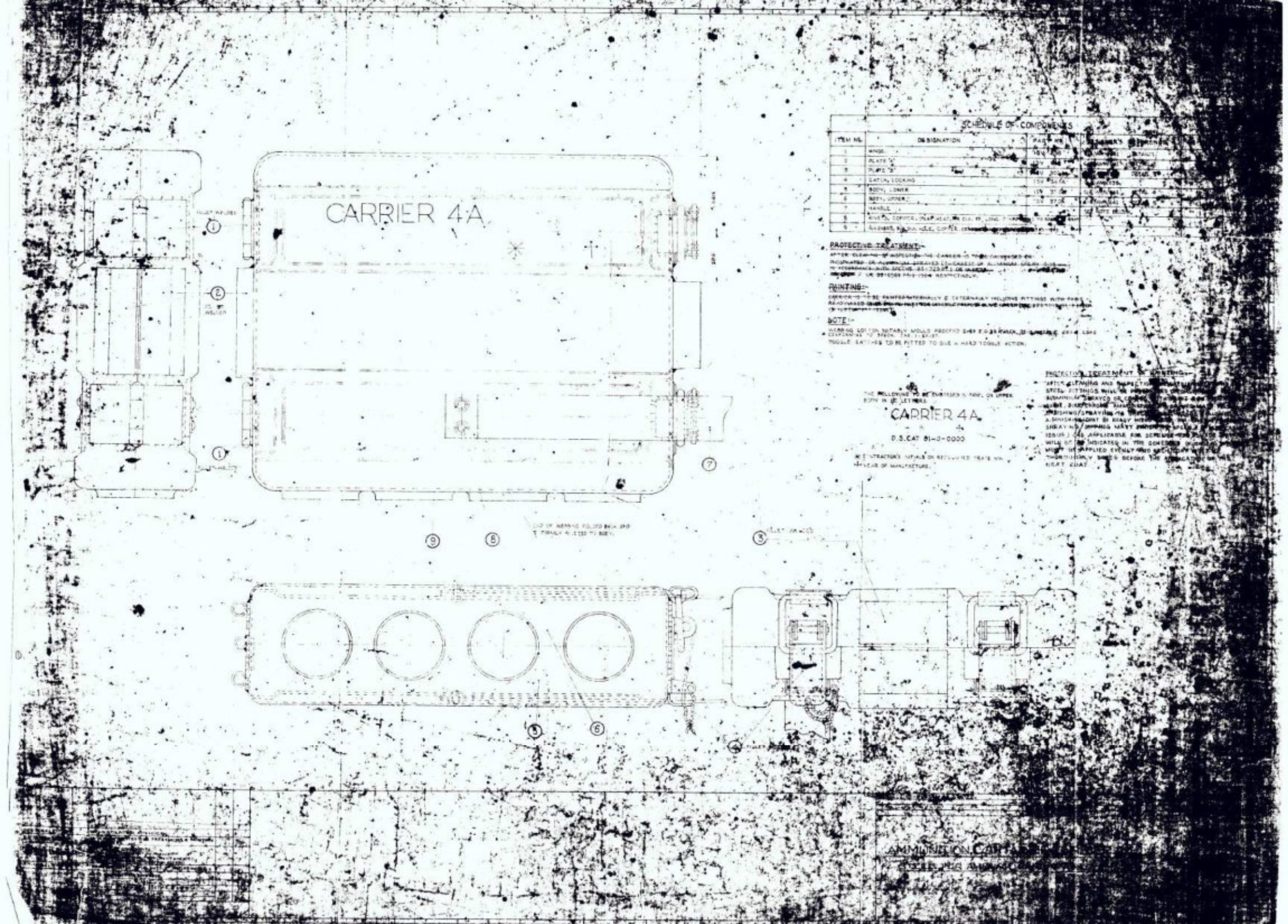
DRAWN	CHECKED	TRACED	TRN. CHD.
	V.R.S.	J. R.N.	[illegible]

CHIEF D'MAN: SD/- (V.N.K RAO)
GROUP OFFICER: SD/- D.O. CIA
APPROVED: SD/- FOR CIA

DRG. SEALED :- 26-10-67 (PROV) D.O. CIA
MATERIAL :- AS ABOVE
PROTECTIVE FINISH :-
ESTIMATED MASS :-
SCALE :- 1/1

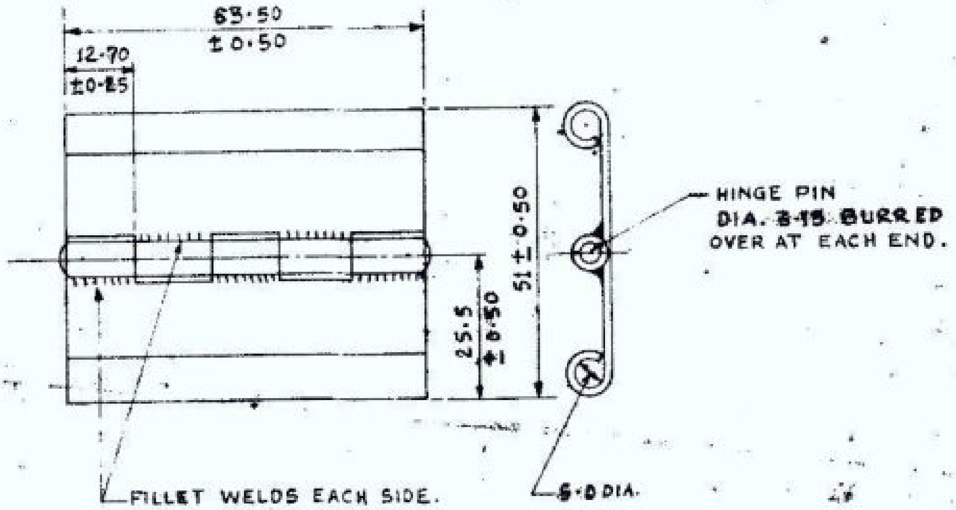
DATE :- [illegible] 65
DESIGNER'S REF. CIA/AMN/S 54
DETAILING
PART NR ISV. 909

PLATE, STOP.


CARRIER 4A
SCHEDULE OF COMPONENTS
ITEM NO.
DESIGNATION
PART NO.
NUMBER REQUIRED
PROTECTIVE TREATMENT:-
PAINTING:-
NOTE:-
CARRIER 4A
D.S.CAT 81-0-0000

PART Nº 1 SV 915 | FOR EXPLANATION OF DIMENSIONING ETC., SEE … THIRD ANGLE PROJECTION. DIMENSIONS ARE IN mm

D.C.I. 28679-A.



MATERIAL :-

STEEL 1·60 THICK CONFORMING TO

(a) I.S :-1079 - 1963 GRADE ST 34 HOT ROLLED & ANNEALED OR

(b) I.S : 513 - 1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE 'D' OR

(c) BS : 1449 - PT 3B - 1964 - CS4 COLD ROLLED & ANNEALED OR

(d) BS : 1449 - PT 3A - 1964 - HS4A HOT ROLLED & ANNEALED.

WIRE STEEL CONFORMING TO IS : 280 HALF HARD & ANNEALED.

DATE	AUTHORITY	ZONE	NATURE	SIG. INSP.	SIG. D.O.
12-7-78	DCI-31525-A		DRG. CONVERTED TO … RATIONALISED		
13-3-68	DCI 28725 A		ASSLY. DRG. REF WAS ISV…A.		
27-2-68			TRACED WITHOUT CHANGE		
26-10-67	D.C.I.28679-A		DRG. PROV. SEALED.		SD/-

AMENDMENTS

DRG. SEALED :- 26-10-67(PROV.) D.O. CIA.

MATERIAL :- AS ABOVE

PROTECTIVE FINISH :- MUST BE KEPT CLEAN & FREE FROM RUST

ESTIMATED MASS :-

SCALE :- 1/1

HINGE

ASSLY. DRG. :- …A.

INSP. INSTRS. :-

DRAWN	CHECKED	TRACED	TRACHD
	M.R.S.		

CHIEF D'MAN SD/- (V.K.RAO) | GROUP OFFICER SD/- D.D.CIA

APPROVED SD/- FOR CIA

DATE :- …

DESIGNER'S REF. CIA/ARN/6…

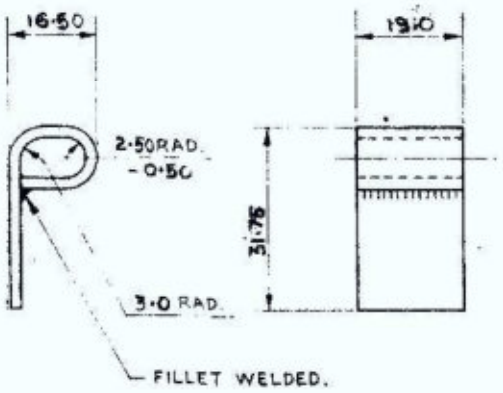
PART Nº 1SV 9…

4235

RT No. ISV 914	~~FOR EXPLANATION OF DIMENSIONING ETC., SEE D.D. NOTE SHEET No. 01~~ THIRD ANGLE PROJECTION.	DIMENSIONS ARE IN mm

D.C.I. 28679-A

NOTE:-
TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ±1·3
FOR TWO OR MORE DECIMAL PLACES ±·13



MATERIAL:-
5 STEEL 1·60 THICK CONFORMING TO
(a) IS: 1079-1963 GRADE ST 34 HOT ROLLED & ANNEALED OR
(b) IS: 513-1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE 'D' OR
(c) BS: 1449 PT 3B-1964-CS4 COLD ROLLED & ANNEALED OR
(d) BS: 1449 PT 3A-1964-HS4 A HOT ROLLED & ANNEALED.

DEVELOPED LENGTH 60·96

DATE	AUTHORITY	ZONE	NATURE AMENDMENTS	SIG. AHSH	SIG. D.O.
12-7-[illegible]	D.C.I. 31525-A		DRG. CONVERTED TO S.I. UNITS & RATIONALISED		
13-3-[illegible]	D.C.I. 28785-A		ASSLY. DRG REF. WAS ISV 5A.		
8-3-68			TRACED WITHOUT CHANGE.		
26-10-67	D.C.I. 28679-A		DRAWING PROV. SEALED.		SD/-

DRG. SEALED:- 26-10-67 (PROV) D.O. CIA.

MATERIAL:- AS ABOVE.
PROTECTIVE FINISH:- MUST BE KEPT CLEAN AND FREE FROM RUST.
ESTIMATED MASS:-
SCALE:- 1/1

PLATE

ASSLY. DRG. :- ISV 3 5GA
INSP. INSTRS. :-

DRAWN	CHECKED	TRACED	TRN. CHD.
	V.R.S.	U.A.K.	

CHIEF D'MAN: SD/- (V.N.K. RAO)
GROUP OFFICER: SD/- D.O. CIA.
APPROVED: SD/- D.O. CIA.
DATE:- 5-1-68
DESIGNER'S REF.: CIA/AMN/6[illegible]
DETAIL No. 3.
PART No. ISV 91[illegible]
CIA, KIRKEE

D-C. 35576-A

IA 1169 (m)
Supersedes I.A. 726-K (n)

THIS SPECIFICATION IS THE PROPERTY OF THE DIRECTOR GENERAL OF QUALITY ASSURANCE AND MUST BE RETURNED TO THE CONTROLLER OF QUALITY ASSURANCE (AMMUNITION), CONTROLLERATE OF QUALITY ASSURANACE (AMMUNITION), KIRKEE, PUNE 411 003 ON DEMAND.

This specification, or any patterns, drawings, or other information issued in connection therewith, may only be used for specific enquiries, tenders or orders placed by competent authority. It is not to be used for any other purpose whatsoever without the sanction of the Director General of Quality Assurance.

LAND SERVICES

GENERAL SPECIFICATION TO GOVERN THE MANUFACTURE REPAIR AND QUALITY ASSURANCE OF WATERTIGHT AND NON-WATERTIGHT STEEL AMMUNITION PACKAGES AND THEIR COMPONENTS.

Approved 30 May 1978

5. Special attention is called to any notes on the drawing.

6. Any sample lent to the manufacturer must be taken as a general guide only.

7. Neither the stores nor any component part may be built up or repaired in any way not provided for by the drawing or this specification, unless authorised by the Quality Assurance Officer.

8. The Manufacturer must provide the Quality Assurance Officer with copies of all sub-orders in connection with his order as soon as they are placed.

9. The Manufacturer must notify the Quality Assurance Officer when he (or his Sub-Manufacturers) is in a position to start work. On receipt of this notification from the Manufacturer the Quality Assurance Officer may arrange to be represented at the Works of the latter or at those of his Sub-Manufacturers.

10. Where tests are laid down in this specification or elsewhere for any of the materials to be used, the Quality Assurance Officer may require that such materials shall not be taken into use until accepted by him as satisfactory for the purpose intended, and may require the bulk to be bonded or sealed until the results of the tests are known.

11. The Manufacturer will be required to supply, free of charge the necessary material for test and analysis. Such material will be selected by the Quality Assurance Officer or his representative. The Quality Assurance Officer will inform the Manufacturer to what extent testing of materials will be carreid out. He may, if considered necessary during the progress of a order, vary the quantity of material taken for test.

12. Where component parts are issued to the Manufacturer, these will be in good condition and must, whilst in his possession be kept in that condition. The Manufacturer shall guarantee the due return of the component parts sent to him and shall be responsible to their full value for all loss of damage from whatever happening there to whilst in possession or control of himself, his servants or agents.

13. The Manufacturer will be required to carry out, free of charge, the work of assembly of the packages or component parts taken for test under the provisions of this specification, or otherwise as stipulated elsewhere as a condition of acceptance. He shall provide, free of charge, the sample welds referred to in para 5, section Four. The material so expended shall be held at the disposal of the Government as represented by the Quality Assurance Officer.

SECTION TWO — MATERIALS

1. Materials must conform to the requirements laid down in their relevant specification or as otherwise specified herein.

2. Sheet or strip steel employed is to be of a suitable quality to withstand breaking or cracking, the pressing, folding and assemblying operations called for by the construction shown on the drawing. All sheets or strips shall comply with :-

(*a*) IS : 1079 1958 1079 Crade St. 34 hot rolled and annealed.

or

(*b*) IS : 513 1958 513 Cold rolled and annealed.
Best surface type 'D'.

or

(*c*) BS : 1449 Pt. 3B-CS 4 Cold rolled and annealed.

or

(*d*) BS : 1449 Pt. 3A - HS 4A, hot rolled and annealed.

3. Bar steel emplyed in the Manufacture of parts such as handles, collers, tie-rods, etc. must conform to IS : 2073-(J). DES C20 or as quoted on the relevant drawings.

SECTION ONE — GENERAL

1. Any question relating to this specification, other specifications referred to herein, or to the drawings should be referred to CQA (A), Kirkee or other Quality Assurance Officer duly authorised to act on behalf of him hereafter called Quality Assurance Authority and Quality Assurance Officer respectively.

2. (*a*) Where specifications are quoted, the current issue is implied.

(*d*) Materials, their specifications and the office from which these specifications are obtainable are given below :—

	Material	*Specn No.*	*Obtainable from*
(i)	Steel Sheet or strips	IS : 1079 – 1973 IS : 513 – 1975 BS : 1449	Indian Standards Institution, Manak Bhavan, 9, Mathura Road, New Delhi – 1.
(ii)	Bar Steel	IS 7283 : 1982 IS-1-2073	– do –
(iii)	Spring Steel	(IS 1079 : 1973 BS : 1449 (IS 513 : 1975	– do –
(iv)	Rubber	IND/ME/584 (9)	The Controller, Controllerate of Quality Assurance (Military Explosives), Aundh Road, Kirkee, Pune – 3.
(v)	Timber	IA : 1001 (9)	CQA (A), Kirkee, Pune – 3.
(vi)	Paint	IS : 168 – 1973 (amended upto date) (for air drying) JSS-16302 (for stoving)	ISI, New Delhi–1. CQA (ME), Kirkee, Pune–3.
(vii)	Galvanising	BS : 729, Pt. I	ISI, New Delhi – 1.
(viii)	Phosphating	JSS 0465–01–1988	CQA (A), Kirkee, Pune – 3.
(ix)	Sprayed metal coating	BS : 2569, Pt. I	ISI, New Delhi – 1.
(x)	Wire Steel	IS : 280 – 1978	ISI, New Delhi – 1.
(xi)	Red Oxide Zinc Chrome Primer	JSS 1–63–05 (b)	CQA (ME), Kirkee, Pune – 3.

Note :— Reference in this specification to any other specification or documents means, in any tender or contract, the edition current at the date of such tender or order.

3. The dimensions, construction, assembling and marking of the ammunition packages or boxes (hereinafter referred to as packages) and their component parts are to be in accordance with the drawings issued to govern the supply of the stores.

4. Where the drawing or specification permits a choice of alternative materials or forms for particular components, the Manufacturer is required to notify the Quality Assurance Officer, in writing, which of the permitted alternative he chooses to produce. If the choice of alternative is changed during the course of the order the Manufacturer shall again notify the Quality Assurance Officer of such change.

4. Spring steel shall comply with all the requirements of BS 1449 En 42F unless otherwise specified on the relevant drawing,

5. Wire steel used in the manufacture of clips, catches, hinges etc. must comform to IS : 280 half hard bright.

6. Rubber sealing rings and pads are to conform to IND/ME/584 Class 'A' unless otherwise stated on the drawings or elsewhere and to be secured in the positions called for on the appropriate drawing in accordance with instructions on the drawings. Samples of adhesives to be used to secure rings/pads should be approved by CQA (ME), Kirkee.

7. Timber or plywoood required for fittings shall conform to the requirements of specification IA 1001 where applicable. Timber components of non-water-tight packages shall be impregnated with approved preservative salts; components for water-tight packages shall not be impregnated.

SECTION THREE — MANUFACTURE AND ASSEMBLY

1. The various parts of the package are to be formed and assembled as shown on the drawing. The dimensions and methods of securing them in position as laid down in particulars shall be strictly adhered to.

2. The steel or metal fittings when called for, must be well finished and a good fit; the holes in the diaphragms of packages so fitted are to be well shaped and in correct alignment when assembled, and free from raw edges and burrs.

3. The corners and joints of boxes must be closed completely. Rivets must be a tight fit and rivetted to the satisfaction of the Quality Assurance Officer. Handle grips if present, must be in good condition when finally accepted. Steel handles shall move freely and shall fall flush with the sides of the package when not in use.

4. Any loose components which need selective assembly will be assembled by the manufacturer to the satisfaction of the Quality Assurance Officer.

5. Parts which are to be joined by welding are to be so formed that when assembled the surfaces to be welded are in close contact so that the welded joint is not under stress. Particular care will be taken that the nature number and size of welds are strictly adhered to.

6. Where a watertight lapped seam is to be made, width of overlap must be as shown on the drawing. When no dimension is laid down, care is to be taken that sufficient width of overlap is provided to ensure that the welded joint is watertight.

7. Spot welds, where called for, are to be correctly positioned as shown on the drawings. In particular, the distance of the welds from the edges of fittings etc. is to be strictly complied with.

8. Particular care is to be taken that the seling for lids of watertight packages is fixed truly at right angles to the axis of the body, so that the pressure on the securing device causes even pressure all round on the rubber seal.

9. The rubber sealing washer (where employed) is to be assembled in its supporting channel and efficiently secured as stated in the drawing or with the material called for in Section Two Para 5 of this specification.

10. Immediately prior to despatch, all rubber components should be given a light covering of french chalk or other approved material.

SECTION FOUR — WELDING

1. All metal surfaces to be welded must be thoroughly clean and free from scale, rust or oil.

2. All welding machines employed must be equipped with a device giving fully automatic time control of the welding current under all workshop conditions and this device must be in use at all times when work on the order is proceeding. Means must also be provided for setting the welding pressure to a given value which is within the pressure range of the machine and for varifying that this pressure is maintained within ± 10% during the working cycle.

3. The manufacturer must make suitable arrangements to supervise his machines so that they are at all times maintained in such condition as will ensure the required standard of quality of welds.

4. The manufacturer must supply his welding operators with a process schedule setting forth :—

(*a*) The manner and order of making the welds.

(*b*) Particulars of tip changing and maintenance.

(*c*) Particulars of preparation of routine tests and methods of recording results.

(*d*) A standard specimen for comparison purposes.

A copy of the process schedule must be supplied to the QAO's representative, also any amendments thereto, which may subsequently be agreed as necessary. The manufacturer's records of tests must, at all times, be available for Quality Assurance by the QAO's representatives.

5. If required by the Quality Assurance Officer the manufacturer shall before beginning work or at anytime during which work on the order is proceeding, produce sample welds on strips of the correct material in order that the condition of the machine and reliability of the operator may be checked by examination and tearing apart of welds.

6. Appendix hereto contains instructions for the guidance of manufacturers in controlling the technique and upkeep of equipments manufacturers will be deemed to have agreed to adopt the recommended procedure on any order governed by this specification, unless prior notice has been given to the Quality Assurance Officer in writing, of their intention to depart wholly or in part, from the procedure and giving full details of the alternative methods proposed to be adopted.

SECTION FIVE — MARKING

1. The packages are to be marked, by embossing or impressing with the particulars called on the relevant drawings. The positions of the marking must not depart from these shown on the drawings.

SECTION SIX — TESTING

1. The package will be tested by the application of a load equal to four times the mass of the filled package, on each handle (when present), and must be capable of withstanding this test without showing any signs of defect either in the package or in the handles. Where no filled mass is given on the drawing, the test mass shall be 180 kg.

2. A percentage of the completed packages may, at the discretion of the Quality Assurance Officer be taken for testing to distruction to determine that the welding is satisfactory.

3. Test welds (when routine or otherwise) from any particular machine shall be made under conditions approximating as closely as possible to those experienced in production.

4. Spring steel clips : The clips when manufactured from spring steel wire will be tested as follows for the quality of welding.

A percentage of the clips will be subjected to a minimum load of 35 kg for 30 seconds on the arms of the clips by any suitable method. The clips should not show any signs of failure.

5. On tearing open the test samples the welds will only be considered satisfactory if a slug or strip is torn from one of the components.

6. All lids for water tight packages must be pressure tested before painting. Those embodying a rubber sealing washer must be painted before assembly.

7. All bodies for watertight package must be pressure tested before painting; the sealing rings are to be removed before and replaced after painting the packages bodies.

8. A minimum of 5% complete watertight packages with their correct lids must be tested for leakage, after final painting and assembly by immersion in water heated to 333·15 kg. for a period of not less than 90 seconds. The lid being closed and secured by normal method.

9. The pressure test for watertight packages is to be carried out by the Manufacturer's staff in the presence of a representative of the Quality Assurance Officer as follows :-

By an internal air pressure not less than 20·6 kPa not exceeding 34·3 kPa. For this test the lid will be replaced by a similar one which is fitted with an adapter to convey air under pressure into the package. The lid will be separately tested under similar pressure when held in suitable clamp. The test shall either be carried out under water or if loss of pressure can be observed on a mercury column, or other approved gauge. The test shall be applied for not less than 30 seconds during which period no loss of pressure shall be indicated.

10. Under any one of these tests neither the body nor the lid shall shown any sign of leakage at any joint, and where lid and body are tested together a perfect seal shall be made on the sealing device.

11. Packages must be properly dried after immersion.

12. Package should be jolted for 8 hrs on a jolting machine having a lift of 50 mm and frequency of 60 jolts per minute. After jolt test packages will be drop tested. After drop test watertight packages should withstand leak proof test as per para 9 Section six...(k).

SECTION SEVEN — RUSTPROOFING AND PAINTING

1. Unless otherwise specified in order or elsewhere, the packages are to be delivered painted with paint specified in the order and will approximate to one of the following colours given in Indian Standard Schedule of colours No. IS : 5.

Olive Green	..	Colour No. 220
Light Brunswick Green	...	Colour No. 225
Signal Red	...	Colour No. 537

2. Before painting the Manufacturer shall arrange for the packages to be adequately treated to secure freedom from scale, rust or corrosion and no packages which fails to satisfy the Quality Assurance Officer in this respect or which is dirty shall be allowed to forward for rust proofing or painting. The package must not be contaminated with grease or oil.

WATERTIGHT PACKAGES (BOXES & CONTAINERS)

3. After closing and inspection the body and lid are to be galvanised or phosphatised or painted with red oxide zinc chrome primer or sprayed with aluminium (thickness of aluminium spray 0-15 mm) in accordance with specification BS : 729 Pt I or JSS 0465-01-1988 (class of phosphating is class II) or JSS 1-63-05 or BS : 2569 Pt I respectively.

NON WATERTIGHT PACKAGES

4. After cleaning and inspection the packages are to be galvanised or phosphatised or painted with red oxide zinc chrome primer or aluminium sprayed (thickness of aluminium spray 0-15 mm) in accordance with specification BS : 729 Pt I or JSS 0465-01-1988 (class of phosphating is class II) or JSS 1-63-05 or BS : 2569 Pt I respectively.

5. If galvanising is adopted, the package and all steel fittings are to be galvanised either before or after assembly, the stage at which galvanising is carried out being at discretion of the Manufacture. If phosphating or aluminium spraying is adopted the package and all metal fittings are to be phosphatised or aluminium sprayed after assembly.

PAINTING PACKAGES

6. After rust proofing and Q. A. the packages will be painted internally and externally with a coat of specified paint. The Paint must be applied evenly and each coat must be thoroughly dry before the application of the next coat.

7. Paint may be applied by Brushing, spraying or dipping, except that brushing or spraying is not to be used when the package is fitted with diaphragms or other fittings with concealed surfaces. As soon as the order is placed the Manufacturer must state the method he proposes to employ. When dipping is employed the Manufacturer must also state in the sub-order placed for paint the viscosity at which he intends to, work his tanks. which must be maintained during use at the viscosity declared. The mixing of paints from different paint manufacturers will not be permitted.

8. The paint shall comply with the requirements of specn IS-168 (amended to date) or JSS : 46302 (for stoving). The paint is to be obtained from the Manufacturer in a consistancy appropriate to the method of application exployed, and no thinners are to be added for any purpose other than the replacement of evaporation losses or to produce the required viscosity of the dipping tanks. The thinners used must be those supplied by the paint manufacturer for use with each particular type of paint.

9. Immediately before use the paint must be thoroughly stirred and agitated (by any suitable means) in the containers so that all the pigment is uniformly dispersed throughout the medium and no sediments remains on the bottom of the container. Periodical stirring of the paint in the container must be carried ous if necessary during the day to ensure that the material is maintained in a uniform consistency throughout painting operations.

10. If dipping is employed, care must be taken to ensure that the paint reaches all internal surfaces Accumulation of paint due to faulty draining must be avoided.

11. Before despatch, the paint on the packages must be thorougly dried and must be to the satisfaction of the Quality Assurance Officer.

12. Any screw threads or working parts of the hinges etc. must be free from paint and well greased.

13. The lids and any components not secured to the body by a fixed fastening are to be separately painted before assembly.

14. Sealing rings and sealing washers must not be shot blasted painted or subjected to the stoving temperature.

SECTION NINE — QUALITY ASSURANCE

1. The packages and components will be subject to Quality Assurance at any stage of the process of manufacture or repair and after delivery. Acceptance at an intermediate stage does not necessarily imply that the article on potentially acceptable in the finished state.

2. The Quality Assurance Officer may at his discretion, take during the progress of the order, samples of any of the materials used in manufacture for the purpose of analysis or testing.

3. Any package component or fitting, which at any stage fails to conform to the stipulated requirements and is not to the satisfaction of the Quality Assurance Officer will rejected. Those stores in which departures can be rectified may be brought up to the approved design by the Manufacturer and be resubmitted for examination.

4. To permit of the foregoing Quality Assurance the Quality Assurance Officer, shall as a condition of the order, have a right of entry into the works of the Manufacturer and/or the works of any sub. Manufacturer where work on the order is in progress.

5. The manufacturer will submit for acceptance the material, components or assemblies called for in the order in suitably sized batches. The amount of material or number of units that comprise a batch will be decided by the Quality Assurance Officer after consultation with Manufacturer. If the QAO's examination of a proportion of a batch of material, components or assemblies submitted to him reveals departures from the drawings and/or specification the whole batch may be rejected. At the discretion of the Quality Assurance Officer a rejected batch may be resubmitted to him provided that the Manufacturer has examined all the units therein and eliminated any defective.

SECTION TEN — PACKING

1. The stores shall be packed for delivery in accordance with the terms of the order.

2. Not-withstanding the conditions for packing prescribed by the order, the Manufacturer shall be responsible that the stores are packed in containers which will prevent damage in transport or in storage and which are so marked that the stores may be readily recognised and identified with the order on which they are supplied.

Revised and approved

Sd/ x x x
(LH SHAW)
DSS
for CONTROLLER OF QUALITY ASSURANCE (AMN)

Dated 30 May 1978

Notes :- (i) This specification is to be returned to the Controller, Controllerate of Quality Assurance (Amn) Kirkee, Pune-3, immediately on submission of tender or completion of order.

(ii) This specification only holds good for the particular order for which it was issued.

Correct copy of the sealed specification at this date.

(A.M. ATHALE)
DY. ASSISTANT CONTROLLER
for CONTROLLER OF QUALITY ASSURANCE (AMN)

Kirkee, Pune-411 003.

Dated 31 MAY 1989

15. Air drying paints may be used for the purpose of 'touching up' small areas of damaged paint or surfaces which show slight discrepancies.

SECTION EIGHT — REPAIR OF PACKAGES

1. The provisions of all the foregoing Sections shall apply except in so far as they are clearly applicable to new manufacture only.

2. Packages shall be emptied of any containers or packing pieces, which shall be sorted, segregated and reported for disposal instructions.

3. The Manufacturer shall sort the packages and segregate those unstuitable for repair, which will be reported for disposal instructions.

4. The packages shall be cleaned, and all rust and water strains shall be removed, by an approved process. The Manufacturer must inform the Quality Assurance Officer of the process, he proposes to use and obtain his approval before commencing production. After cleaning and completely de-rusting inside and out, the packages shall be inspected by a representative of the Quality Assurance Officer before any further work is done.

5. All large dents and distortions shall be removed to the satisfaction of the Quality Assurance Officer Complete removal of dents will not usually be necessary. but any small dents which remain must not interfare with the correct functioning of fittings, the opening, closing, and securing of the package or to the insertion and removal of the stores to be packed.

6. Cracks must be welded up, and punctures covered with plates welded on, to the satisfaction of the Quality Assurance Officer.

7. Broken or damaged fittings are to be removed and replaced. Missing components are also to be replaced. Components for repair will be obtained as far as possible from packages not worth repair.

8. Any new component supplied by the Manufacturer must confirm to the relevant drawing, and be secured to the package in the manner lain down in the drawings.

9. Fittings which are broken away from their attachments are to be re-secured in a suitable manner to the satisfaction of the Quality Assurance Officer.

10. Rivets shall be tightened to the satisfaction of the Quality Assurance Officer or renewed; missing rivets shall be replaced.

11. New fittings are to be well finished and fitted, and where necessary are to be assembled in correct alignment. Raw edges and burrs from whatever cause are to be removed to the satisfaction of the Quality Assurance Officer.

12. All non-watertight packages are where called for, to be provided with drainage and ventilation holes drilled in the positions shown in the drawing.

13. Rubber sealing ring of watertight packages shall be removed and new ones provided. They shall be secured as shown in the drawing or with adhesive to the current approved specification.

14. The packages shall be rustproofed and painted, as provided in Section Seven. Brushing may be used as an alternative to dipping or spaying. If packages have been previously rustproofed and the metalized or phosphated surface is still maintained these packages shall be painted as provided in Section Seven. Air drying paints may be used to paint small areas after removal of patches of rust or seals, and to repair damaged paint.

15. The packages shall be tested as specified in Section Six of this specification.

16. The packages are to be stencilled with initials of the repairing Manufacturer and the year of repair, in a position agreed with the Quality Assurance Officer.

APPENDIX I TO SPECIFICATION 1A 1169

(*See* Section 4)

WELDING

1. SEAM WELDING

(*a*) The working face of the electrode must be maintained flat, smooth and clean. The width must not be allowed to increase more than 20% above the initial width which the machine was set up to work. Filing of wheels is not permitted.

(*b*) A gauge should be provided for checking the width of the electrode working face.

(*c*) Test welds should be made as follows on strips of the material being used :—

At the commencement of each shift. Each time the electrodes are changed or dressed.
At two hourly intervals during each shift. Or as other agreed upon.

2. SPOT WELDING

(*a*) The diameter of the electrode tips, or of the one tip in the case where a pad type of electrode is used must not be allowed to increase more than 20% above the initial value with which the machine was set up to work.

(*b*) A gauge should be provided for checking this.

(*c*) When the maximum permitted diameter has been reached, the tip or tips must be changed or dressed. Filing of the tips is not permitted.

(*d*) Test welds should be made at the commencement of each shift and before and after tips have been changed or dressed.

APPENDIX 'I' TO SPECIFICATION 1A 1169

(*See* Section 2, Clause 5)

Instructions for the use of rubber Resin Cement when sticking non-intercellular rubber and her rubber pads and packing strips to steel packages.

GENERAL

(*a*) Cleanliness is essential at all times.

(*b*) Surface to be stuck together must be clean and dry.

(*c*) An even and adequate coat of cement must be used on each surface. The amount of surface which can be covered per litre is 2·2 to 2·4m². So far the two surfaces a litre is required for every 1·1 to 1·2m² of non-intercellular or other rubber.

INSTRUCTIONS

(*a*) The temperature of the shop in which the work is carried out should not be less than 289·15 k.

(*b*) The cement must be well stirred prior to use.

(*c*) The cleanliness and dryness of the surface of the rubber and the metal will be ensured by wiping them thoroughly with a clean rag moistered with trichloerethylene.

Note :— To ensure that the rag is clean and free from grease, it will be changed.

(*d*) Apply an even coat of the cement adhesive to both rubber and metal surface ensuring that the area of metal covered is slightly larger than that of the rubber.

(*e*) Allow to dry. Drying time will depend on the shop conditions but should not be less than 15 minutes nor more than 35 minutes.

(*f*) When the cement adhesive is properly dry the two surfaces should be pressed together and rolled to ensure that no air is trapped in the joint.

Note :— No stress should be applied to the joint for 24 hours.

AIDE MEMOIRE — P/11

Specification IA 1169 for steel boxes/carriers will be read in conjunction with the following : —

A Steel boxes (other than those which are air tight) and carriers packed as per service condition will be subjected to jolting and individually drop tested thereafter ...(k)

DROP TEST

One box/carrier per lot will be subjected to drop test from a height of 140 cms on to a concrete floor, successively on its base, top, side and any on corner/or any other position at the discretion of the Quality Assurance Officer with contents packed inside as per Service condition.

After drop test the box/carrier will be examined for the following :—

(i) Catches, handles, hinges are not damaged to such an extent that they are beyond minor repairs by slight tapping with mallet.

(ii) Welding should be intact.

(iii) Boxes/carriers should be easy to open and close.

(iv) Containers/Liners/Cylinders/Boxes and rounds packed therein should be easily removable.

B Hermetically sealed boxes with contents packed as per service conditions will be subjected to jolt and drop test (in their outer package as applicable)...(k) followed by leak test.

JOLT TEST

Boxes will be subjected to jolt test in a machine having a lift of 50 mm and frequency of 60 jolts per minute for 8 hours. The boxes after jolt test as above should withstand leak test in accordance with specification IA 1169. Section Six Clause 8.

Revised and approved

Sd/ x x x
(LH SHAW)

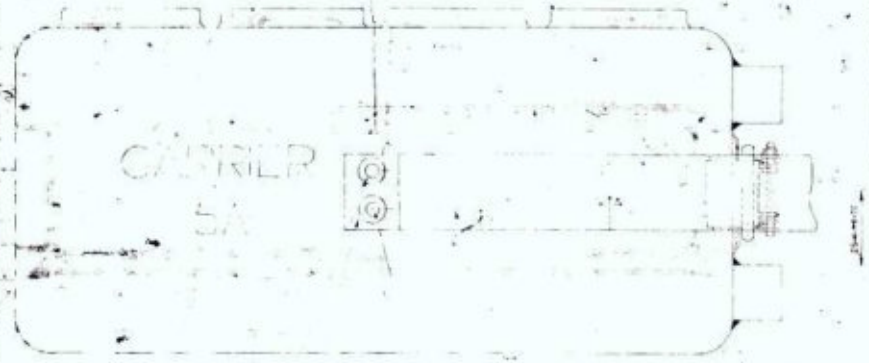
Dated 30 May 1978

for CONTROLLER OF QUALITY ASSURANCE (AMN)

Certified correct copy of aprroved Aide Memoire at this date.

DATED :

for CONTROLLER OF QUALITY ASSURANCE (AMN)



(8) (7) (6)

(4) (3)

(1) (2)

SCHEDULE OF COMPONENTS

ITEM NO	DESCRIPTION	PART NO	DESIGNATIONS PER	NUMBER
1	BODY, LOWER	15V 38 SA		
2	BODY, UPPER	15V 33 SA		
3	PLATE	15V 314		
4	CATCH, LOCKING	15V 34 SA		
5	HINGE	15V 315		
6	HANDLE			
7	RIVETS, COPPER, SNAP HD, 3/16 DIA. 3/8 LONG CONFORMING TO SPEC. S 280			
8	WASHER 5 DIA. HOLE, COPPER			

NOTE:

THE FOLLOWING TO BE EMBOSSED, IN RELIEF, ON LOWER BODY IN 12 LETTERS.

CARRIER 5A

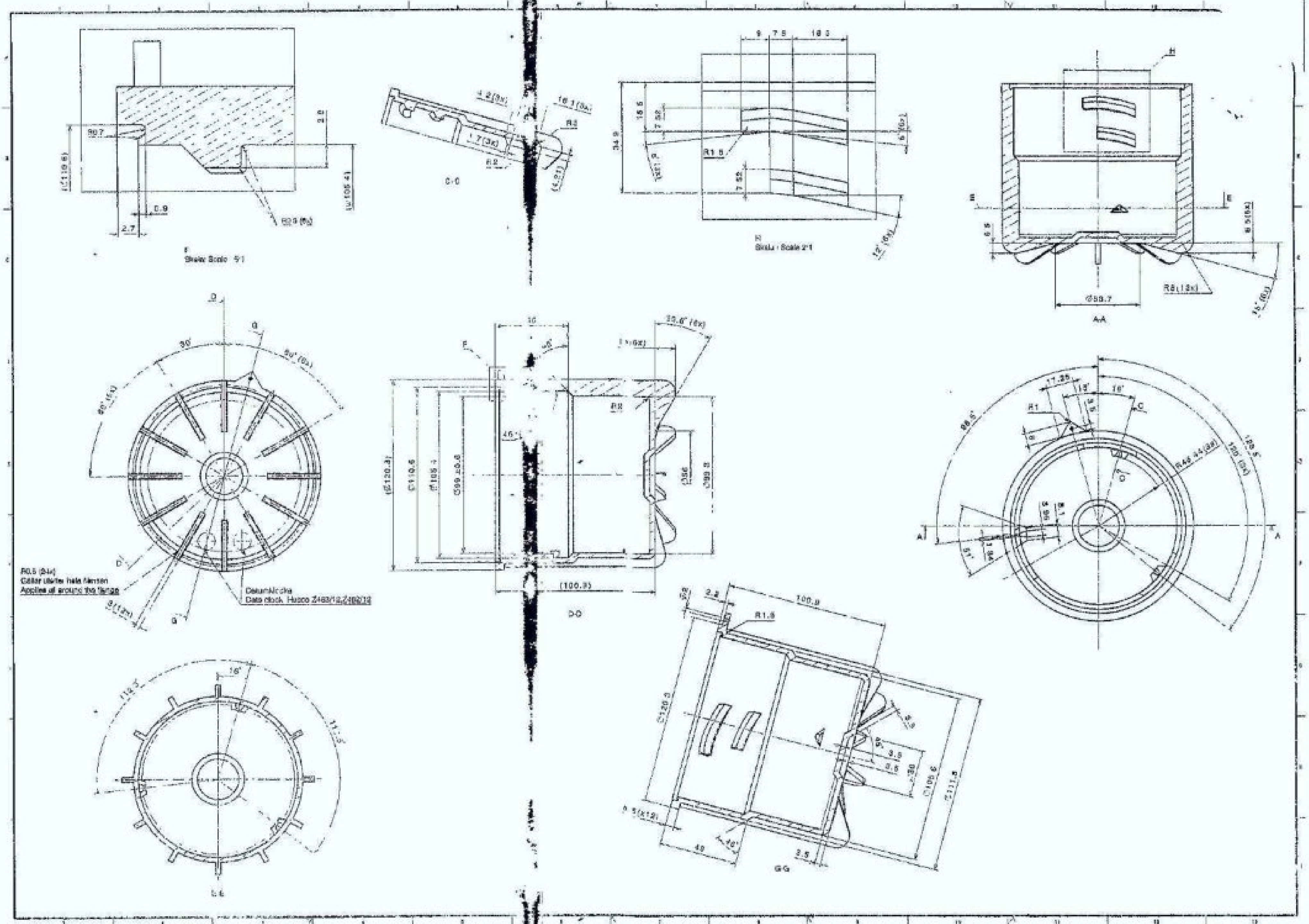
PROTECTIVE TREATMENT

PAINTING

PROTECTIVE TREATMENT & PAINTING

AMMUNITION CARRIER CARRIER 5A

STEEL FOR AMMUNITION CONTAINERS ASSY. NO.



A-A
D-D
G-G
R1.5
100.9

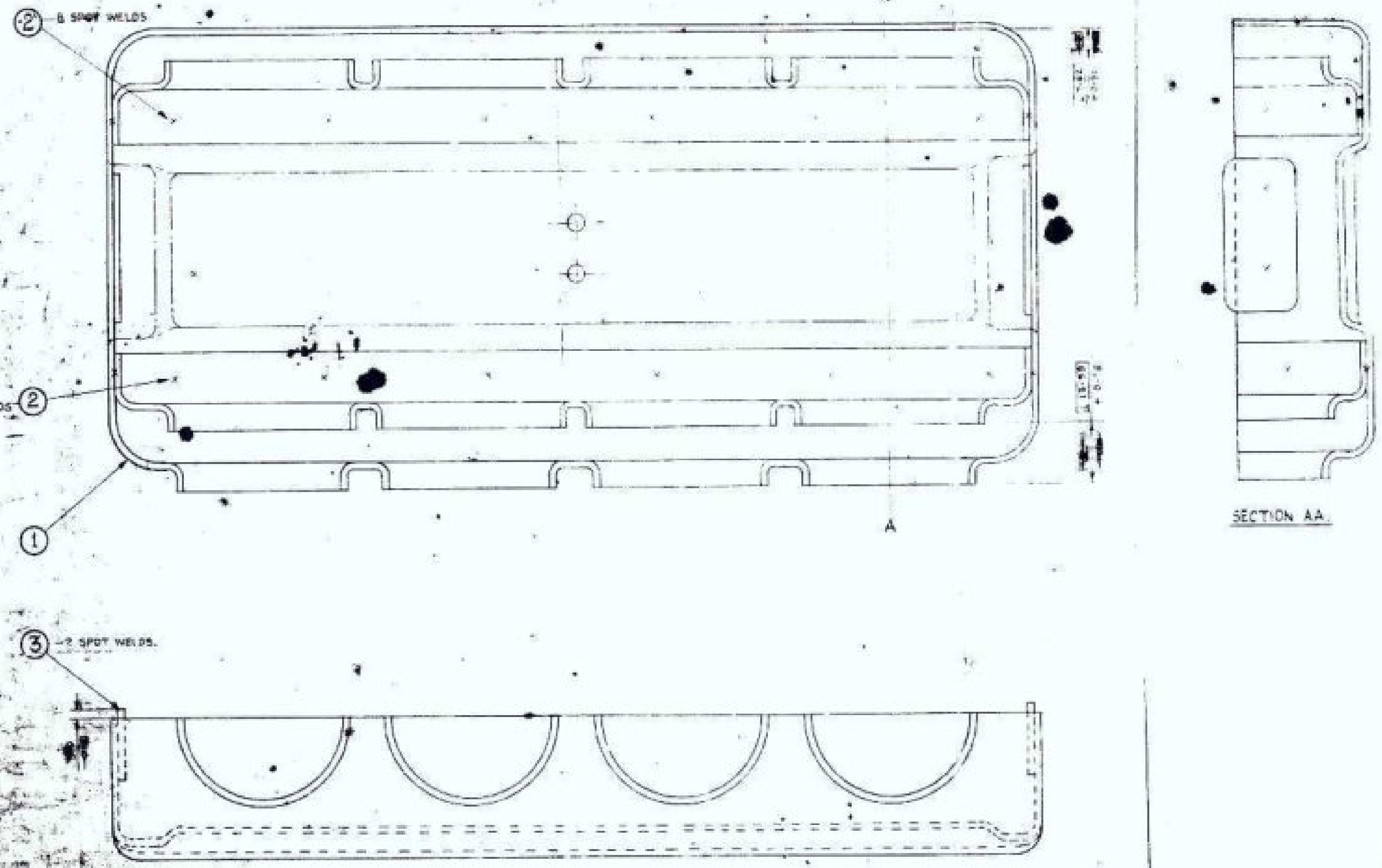
PART No. 13V 56 SA

S.C.I. 26673-A.

FOR EXPLANATION OF DIMENSIONING ETC.

THIRD ANGLE PROJECTION.

DIMENSIONS ARE IN



SCHEDULE OF COMPONENTS.

ITEM No.	DESIGNATION	PART No.	DRAWING No.	No. PER SET
1	[illegible]	13V 912	CIA/AMN/6637 DET. 1/1	1
2	[illegible]	13V 913	CIA/AMN/6637 DET. 1/2	2
3	[illegible]	13V 909	CIA/AMN/6637 DET. 1/3	2

MATERIAL:-

STEEL [illegible] THICK CONFORMING TO

(1) BS 1079-1963 GRADE ST 5 HOT ROLLED & ANNEALED OR

(2) BS 1313-1967 COLD ROLLED & ANNEALED [illegible] SURFACE TYPE "D" OR

(3) BS 1449 PT. 1B-1964-[illegible] A COLD ROLLED & ANNEALED OR

(4) BS 1449 PT. 1A-1964-[illegible] A HOT ROLLED & ANNEALED.

▭ TO BE GAUGED

PROTECTIVE FINISH:-

MATERIAL: AS ABOVE.

ESTIMATE: [illegible]

SCALE 1:1

ASSY DRG:- [illegible]

DRAWN | CHECKED | TRACED

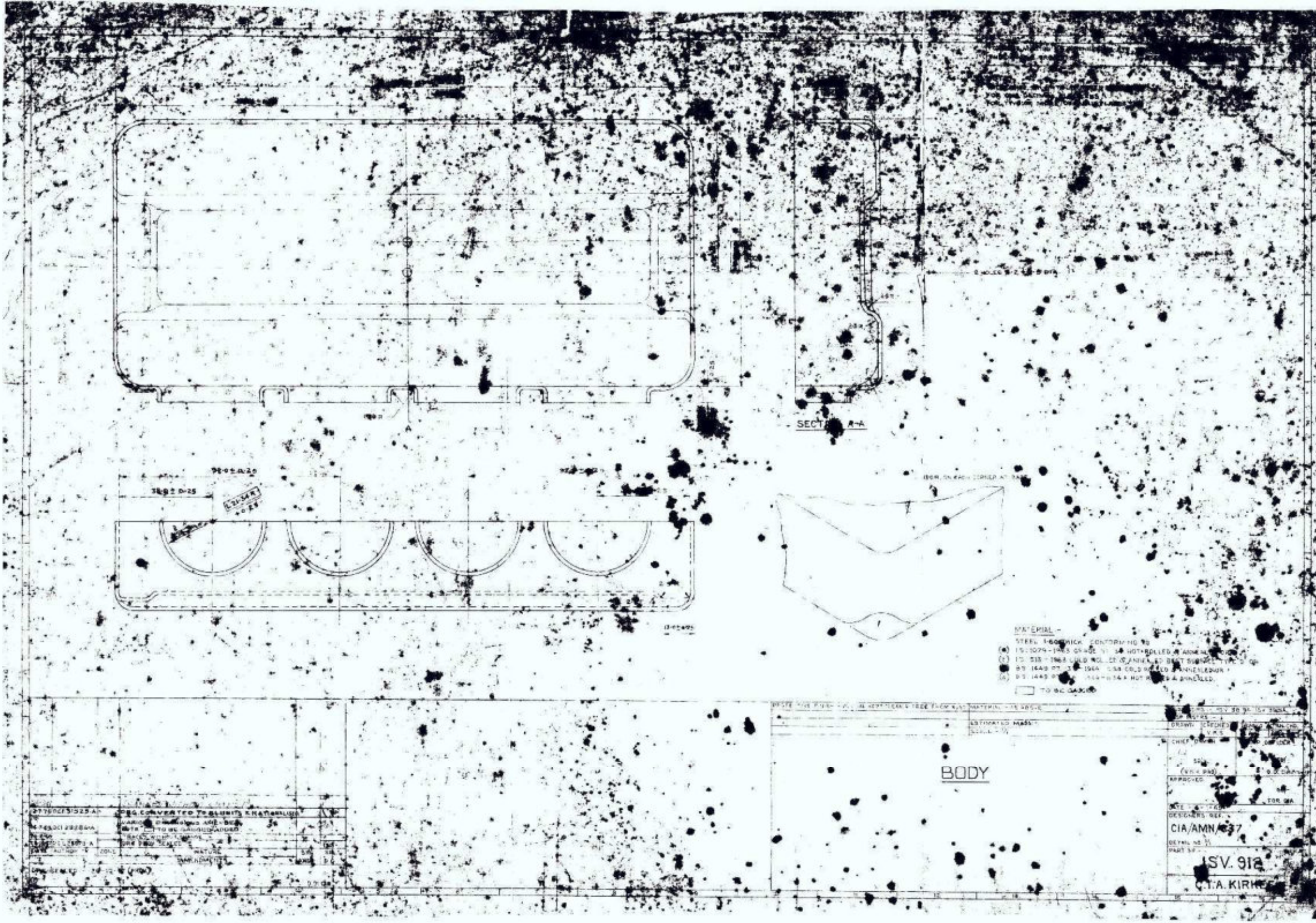
CHIEF D'MAN

APPROVED

BODY, LOWER

SI UNITS & OPTIONS USED

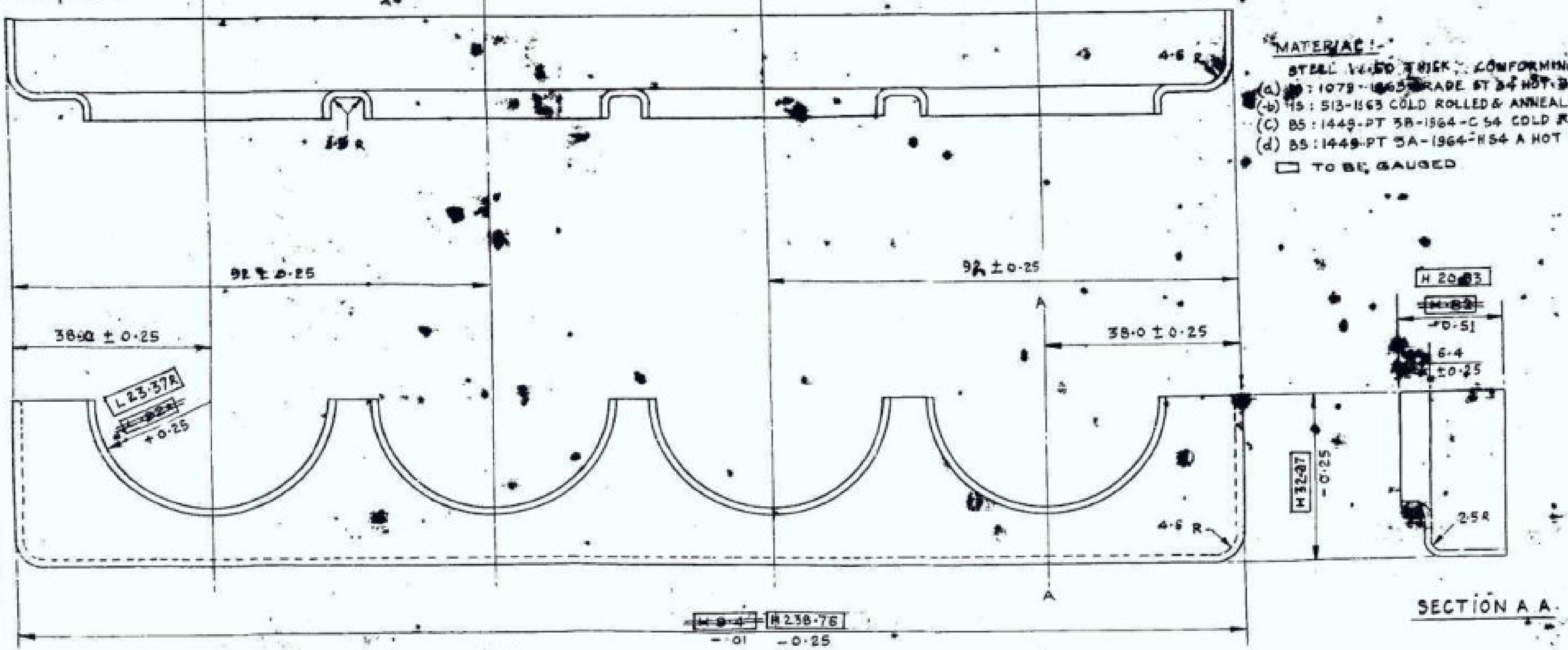
CIA/AMN/6637


SECTION A-A
MATERIAL -
BODY
CIA/AMN/637
ISV. 918
C.I.A. KIRIK

PART No. ISV 913

D.C.I. 28679-A

FOR EXPLANATION OF DIMENSIONING ETC., THIRD ANGLE PROJECTION. DIMENSIONS ARE IN mm.



MATERIAL:-
STEEL 1·60 THICK, CONFORMING TO
(a) IS: 1079-1963 GRADE ST 34 HOT ROLLED & ANNEALED OR
(b) IS: 513-1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE'D' OR
(C) BS: 1449-PT 3B-1964-C S4 COLD ROLLED ANNEALED OR
(d) BS: 1449-PT 3A-1964-HS4 A HOT ROLLED ANNEALED.

☐ TO BE GAUGED

TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ± 1·3.
FOR TWO OR MORE DECIMAL PLACE ± ·13.

DATE	AUTHORITY	ZONE	NATURE	SIG AHSP	SIG D.O.
12-7-75	DCI-31525-A		DRG. CONVERTED TO SI UNITS		
14-1-69	DCI 29286-A		VARIOUS DIMENSIONS AMENDED NOTE ☐ TO BE GAUGED ADDED		
11-3-68			TRACED WITHOUT CHANGE		
26-10-67	D.C.I.28679-A		DRG. PROV. SEALED		SD/-

AMENDMENTS

DRG. SEALED:-26-10-67 (PROV.)

D.O.CIA.

PROTECTIVE FINISH:- MUST BE KEPT CLEAN AND FREE FROM RUST.

MATERIAL:- AS ABOVE

ESTIMATED MASS:-

SCALE:- 1/1

SUPPORT

ASSLY. DRG.:- ISV 385A. ISV 393A

INSP. INSTRS.:-

DRAWN	CHECKED	TRACED	TRN. CHD.
	V.R.S.	M.A.K.	

CHIEF D'MAN SD/- (VNK RAO)

GROUP OFFICER SD/- D.O.CIA

APPROVED SD/- FOR CIA.

DATE:- 5-1-68

DESIGNER'S REF. CIA/AMK 637

DETAIL No. 1/2

PART No. ISV 913

C.I.A. KIRKEE

4238

PART NR **ISV 909**

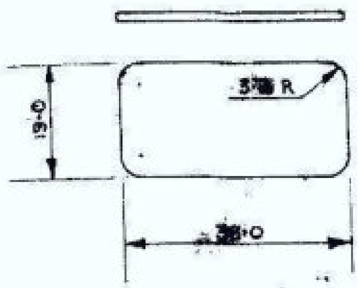
~~FOR EXPLANATION OF DIMENSIONING ETC., SEE D.D. NOTE SHEET NR 8.~~

THIRD ANGLE PROJECTION. DIMENSIONS ARE IN ~~mm~~

D.C.I 28679-A.

NOTE:-

TOLERANCE ON UNTOLERANCED DIMENSIONS
FOR ONE DECIMAL PLACE ±1·3
FOR TWO OR MORE DECIMAL PLACES ±·13



MATERIAL:-

STEEL, 1·60 THICK CONFORMING TO
(a) IS: 1079-1963 GRADE ST. 34 HOT ROLLED & ANNEALED OR
(b) IS: 513-1963 COLD ROLLED & ANNEALED BEST SURFACE TYPE D OR
(c) BS: 1449 PT. 3B-1964-C S4 COLD ROLLED & ANNEALED OR
(d) BS 1449 PT. 3A-1964-H S4 A HOT ROLLED & ANNEALED.

DATE	AUTHORITY	ZONE	NATURE	SIG. AHSP	SIG. D.O.
18-7-75	D.C.I. 31523-A		DRG. CONVERTED TO S.I. UNITS & RATIONALISED.		
9-3-68			TRACED WITHOUT CHANGE.		
26-10-67	D.C.I. 28679-A		DRAWING PROV SEALED.		SD/-
			AMENDMENTS		

ASSLY. DRG:- ISV 38 3A - ISV 38 3A
INSP. INSTRS:-

DRAWN	CHECKED	TRACED	TRN. CHD.
	V.R.S.	J.R.N.	[signature]

CHIEF D'MAN: SD/- (V.N.K RAO)
GROUP OFFICER: SD/- D.O. CIA
APPROVED: SD/- FOR CIA

DRG. SEALED:- 26-10-67 (PROV) D.O. CIA

DATE:- [illegible] 65
DESIGNER'S NR: CIA/AMN/834
DETAILING: V
PART NR: ISV 909

MATERIAL:- AS ABOVE
PROTECTIVE FINISH:-
ESTIMATED MASS:-
SCALE:- 1/1

PLATE, STOP.