



ENLARGED VIEW AT 'A'

TO BE MAINTAINED BY TOOLING

NOTE: TO BE MANUFACTURED BY JD METHOD USING SUITABLE SET OF DIES & TOOLS & CORRESPONDING PROCESS PARAMETERS

PRESSURE TEST: PRESSURE TEST FOR AIR TIGHTNESS TO BE CARRIED AT 0.6 TO 0.7 KG/CM², TEST TIME 60-70 SECONDS FOR CHECKING APPLY SOAP SOLUTION AT JOINT. BUBBLE AND PRESSURE DROP NOT PERMITTED. PRESSURE TEST 0.6 TO 0.7 KG/CM² (POSITIVE) IS ALLOWED. FOR CHECKING DIP COMPONENT IN WATER FOR 60 TO 70 SECONDS. AIR BUBBLE NOT PERMITTED.

LIST OF COMPONENTS

REV. NO.	DESCRIPTION	DRG. NO.	DET. NO.	SHT. NO.
1	CONTAINER	HEMRL/PYRD/SK.0275	2	1
2	LUG	HEMRL/PYRD/SK.0275	2	2

DEVIATION FOR UNTOLERANCED DIMENSIONS TO CONFORM TO SPEC. IS: 2102 MEDIUM	DRAWING CONVENTIONS CONFORM TO IS SPEC.
SCALE: NTS	
EST. MASS: 285415g	
GAUGE SCHD: 1	
ALL DIMS. ARE IN mm UNLESS OTHERWISE STATED	
MATL: AS DN DRG.	
PROTECTIVE FINISH: AS DN DRG.	
TITLE: OUTER CONTAINER	
DESIGN AUTHORITY: HIGH ENERGY MATERIALS RESEARCH LABORATORY, PUNE - 411021	
DRG. No. HEMRL/PYRD/SK.0275	DATE: 18-05-2018
DET. No. 2	SHTS/SHT. No. 1
PART No.	
D.S. CAT. No.	
AHSP.	

MATERIAL:- STEEL SHEET IS: 513 GRADE DD DR EDD IN ANNEALED/SKIN PASSED CONDITION DR BS: 1449 PART 1 Gr 1, DR 2 DR 3.

PROTECTIVE FINISH:- CADMIUM PLATING FOLLOWED BY CHROMATE PASSIVATION TO SPECN. IS: 1572 Cd 8 DR ZINC ELECTROPLATED COATING TO SPEC. IS: 1573 (1986).

