



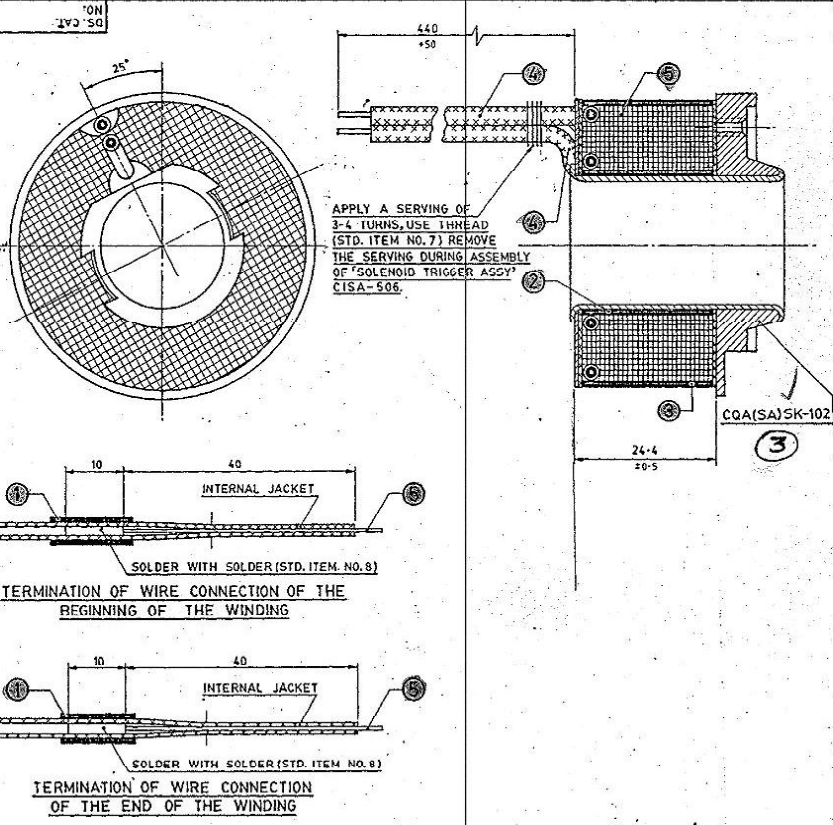
DRAWING PREPARED BY REVERSE ENGINEERING PROCESS, AS SUCH SUITABLE NUMBER OF ADVANCE SAMPLES ARE TO BE TRIED OUT BY FITMENT & FIRING BY COA(SA) BEFORE BULK IS PRODUCED.

DRAWING CONVENTIONS CONFORM TO IS:696 DIMNS. ARE IN mm. (GEN. TOL. SEE "MEDIUM" IS:2102)

Sl. No.	NOMENCLATURE	ALTERNATE INDIGENOUS SPECN	NO PER ASSY.	REMARKS
1	GASKET 15x22 VARNISHED CAMBRIC 1/WM-105-0-1 GOST 2214-70	SILK VARNISH CLOTH TO BS:419-1966	2	
2	GASKET 24x160 VARNISHED CAMBRIC 1/WM-105-0-1 GOST 2214-70	SILK VARNISH CLOTH TO BS:419-1966	1	
3	GASKET 24x200 VARNISHED CAMBRIC 1/WM-109-0-1 GOST 2214-70	SILK VARNISH CLOTH TO BS:419-1966	1	
4	WIRE 6/18 /1 0.5K, L = 610 TY 16 - 505911 - 76	UNIPREN CABLE DESIGNATION 6 TO SPECIFICATION IS:10241 (PART II):1982	2	OF ANY COLOUR
5	WIRE 0.3B-1-0.6mm GOST 7262-78 L-88500	AS PER JSS 54700	1	
6	CABLE PAPER KBM-080 GOST 645-79E	AS PER IS:6615-1972		
7	THREAD No. 0 OF ANY COLOUR GOST 6303-73	SEWING COTTON THREAD DYED 155 & TEX/27 (BREAKING LOAD - 36N) AS PER IS:1720-1978 VARIETY No.42		
8	SOLDER NP2 POC 40 GOST 1499-70	IS:193-1982 Gd. Sn 38		
9	ADHESIVE EQ-4, GOST 12172-66	DUNLOP ADHESIVE S-758 OR APC No. 6 TO JSS 8040-12		
10	INSULATING IMPREGNATING VARNISH ST-987, ST-588, GOST 6244-70	ORGANIC BAKING IMPREGNATING INSULATING VARNISH FOR ELECTRICAL PURPOSE TO SPEC IS:350-1968		
11	GREEN OR LIGHT BROWN ENAMEL 2A-773 GOST 23143-78	IS:2932-1974 COLOUR CATEGORY No. 20 (iii)		

**NOTE**

1. APPLY THE WINDING WITH TURNS TOUCHING.
2. TOTAL NUMBER OF TURNS IS 670.
3. APPLY ONE TURN OF WIRE (STD. ITEM NO. 4) TO BEGIN WITH.
4. FINISH THE WINDING WITH APPLYING OF ONE TURN OF WIRE (STD. ITEM NO. 4) AND FIXING IT WITH THREAD (STD. ITEM NO. 7).
5. TO STRAIGHTEN THE WINDING USE GASKETS OF CABLE PAPER (STD. ITEM NO. 6).
6. TWIST THE CONNECTING ENDS OF THE BEGINNING AND END OF THE WINDING AND SOLDER THEM WITH ACIDLESS METHOD.
7. PASTE TOGETHER STD. ITEM Nos. 1, 2 & 3 WITH ADHESIVE (STD. ITEM NO. 9), SHOULD BE DRIED TOGETHER WITH THE COIL DURING MANUFACTURING PROCESS.
8. SOLDERLESS PLACES AND ROUGH ROLLS OF SOLDER ARE NOT TOLERATED.
9. INSULATION TURN-OUT AND FRICTION WEAR ARE NOT TOLERATED.
10. BREAKING OF SEPARATE CONDUCTORS OF WIRES IS NOT TOLERATED.
11. PROTRUSION OF WINDING FROM THE OUTER DIAMETER OF CISA-553/4 AND CISA-553/5 IS NOT TOLERATED.
12. IMPREGNATE THE COIL WITH IMPREGNATING VARNISH (STD. ITEM NO. 10).
13. AFTER IMPREGNATING COAT THE COIL WITH ENAMEL (STD. ITEM NO. 11).
14. TURNING THROUGH OF CISA-553/3 RELATIVE TO CISA-553/2 IS NOT TOLERATED.
15. RESISTANCE OF WINDING IS 4.75 ± 0.30hm AT A TEMPERATURE OF 20°C.
16. CHECK THE ELECTRICAL STRENGTH OF THE INSULATION WITH ALTERNATING CURRENT VOLTAGE OF 500V AND FREQUENCY OF 50H DURING 1 MINUTE.



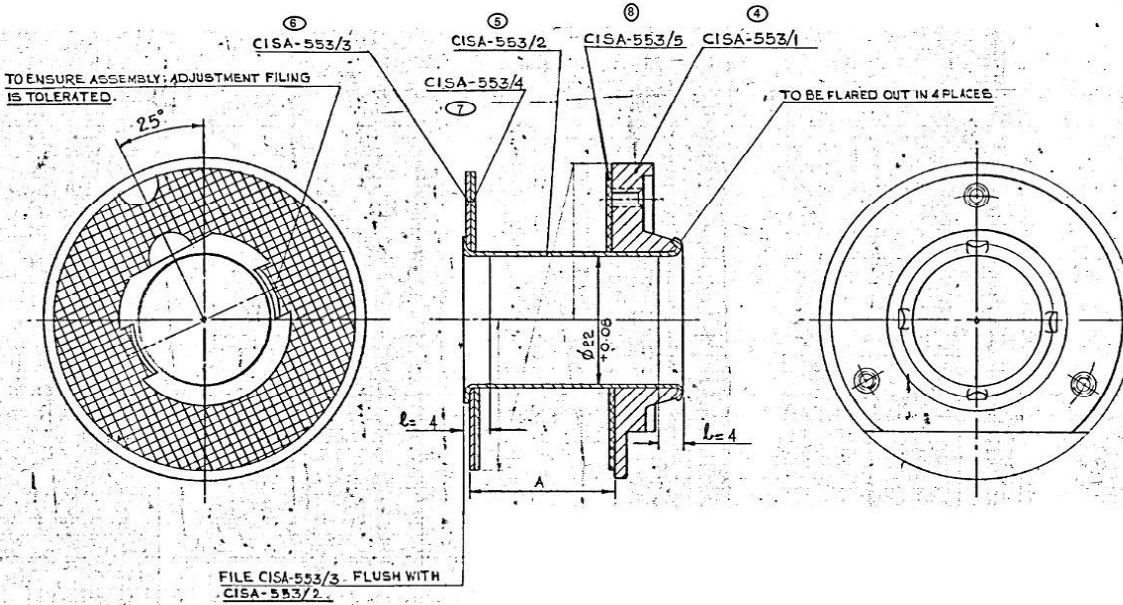
65P 11301 (2)

19-12-58	24231-SA	NOMENCLATURE AMENDED ON STD. ITEMS.	5-6/1-8	APPROVED, DT. 4-2-78 (NEGATIVE RE-TRACED)	ASHP. COA(SA), ICHAPUR
16-8-37	23830-SA	ALTERNATE INDIGENOUS SPECN. ADDED			ASSY. 5945-007666
4-12-56	23599-SA	ASSY. NO. AMENDED, ALTERNATE INDIGENOUS SPECN. COLUMN ADDED IN STD. ITEMS DRAWING RE-TRACED & PROV. RE-SEALED. PREVIOUS DC. 19935-SA, 21137-SA & 22372-SA			DGNR'S REF. CISA-553
DATE AUTHY.		BRIEF RECORD	ZONE	MATERIAL. AS STATED	PART NO. C6 12-3/617
SEALED:-	PROV. DC. 19935-SA DT. 5-3-88		1/C:0.0. G.O. SIGN.	H/I/HARDNESS.	DRG. NO.
NOMENCLATURE:- MAGNET COIL ASSY.				PROTECTIVE FINISH.	DS. CAT. NO.

DRAWING CONVENTIONS CONFORM TO JS

TOLERANCES FOR UNTOLERANCED DIMENSIONS  
SEE 'MEDIUM' IS: 2102.

DRAWING PREPARED BY REVERSE ENGINEERING  
PROCESS, AS SUCH SUITABLE NUMBER OF  
SAMPLES ARE TO BE TRIED OUT BY FITTING  
FIRING BY CQA(SA), BEFORE BULK IS



DIMENSION 'A' IS DETERMINED DURING THE  
PROCESS TO ENSURE MATING WITH RE  
DIMENSION IN CISA-553.

ROUND OFF SHARP EDGES ON CISA-  
CISA-553/3 AFTER ADJUSTMENT.

TURNING THROUGH OF CISA-553/3  
CISA-553/2 FOR 0.5 mm IS ALLOWED

TEAR OF METAL DURING FLARING IS

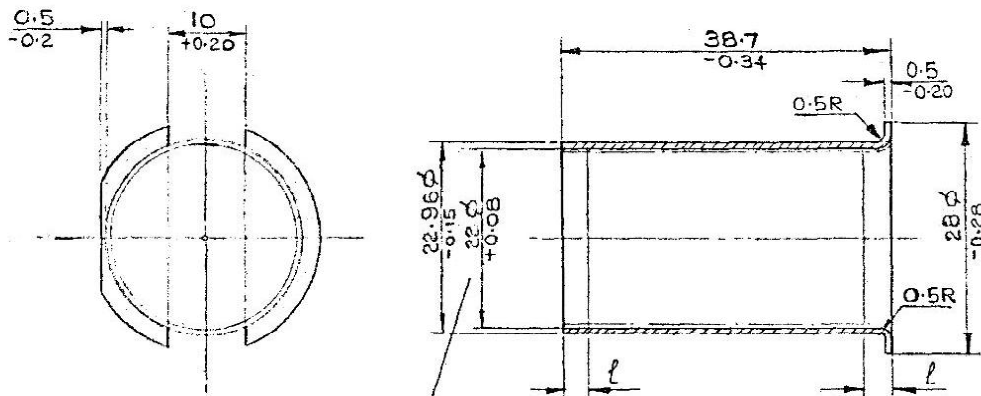
6SP 11302

3

		DATE	NAME	ASSY CISA-553
DCN				MATERIAL:
DRN				DIMENSIONS ARE IN MILLIMETRES.
CHD				
TRD				
COMF				
		1/C3D.O.		COIL FORM
23930	15.5.97	DRG. PROV. SEALED	SEALED PROV.	DC No. 23930-SA
AUTHY	DATE	ZONE	BRIEF RECORD	SIG.
				DT. 15-5-97







AT SECTIONS  $l$  - 3<sup>+</sup> INCREASE OF SIZE UP TO SIZE 22±0.14 IS TOLERATED

65P 11304

DRAWING PREPARED BY REVERSE ENGINEERING PROCESS, AS SUCH SUITABLE NUMBER OF ADVANCE SAMPLES ARE TO BE TRIED OUT BY FITMENT & FIRING BY CQA(SA) BEFORE BULK IS PRODUCED. DRAWING CONVENTIONS CONFORM TO IS: 696. TOLERANCES FOR UNTOLERANCED DIMENSIONS SEE MEDIUM IS:2102.

**MATERIAL :-**  
BS 2871:1972 Pt.2 Gd.CZ 126 OR  
IS: 407:81 Gd.CuZn 30As, TEMPER 'O'

**MATERIAL :-**  
~~BS 2871-1957 CZ 105 CONDITION 'O', OR~~  
~~IS: 407-1966 ALLOY No. 1 (CuZn 30As)~~  
~~ANNEALED CONDITION~~  
~~BS 2870:80 DES.Cz 106, CONDITION 1/2 HR~~  
~~IS: 410:77 DESIG. CuZn 30, CONDITION NO~~

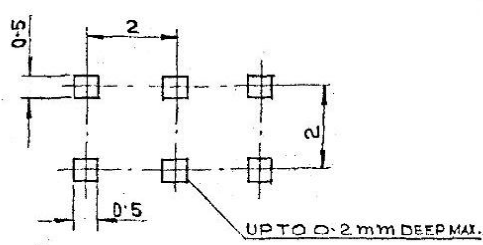
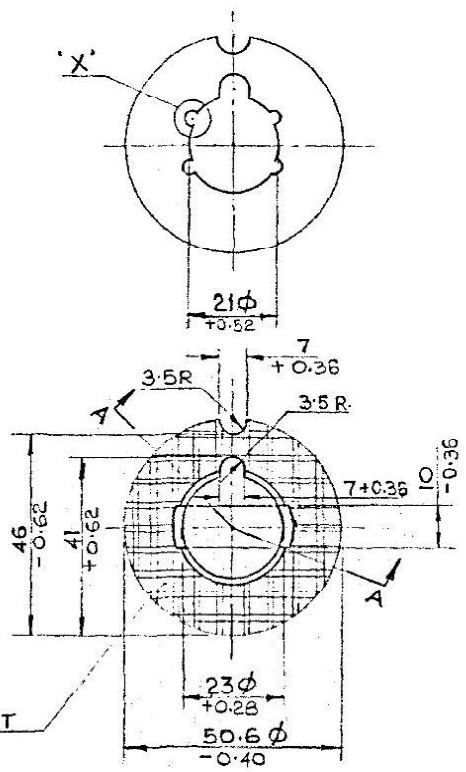
**PROTECTIVE FINISH :-**  
ANODIZED AS PER GR.AC 25 OF IS: 6651-1972,  
COLOUR - STEEL GREY.

5

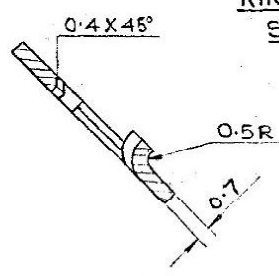
AUTHY.	DATE	ZONE	BRIEF RECORD	SIG.	DATE	NAME	ASBY.DRG.-CQA(SA)SK:102	CQA(SA) ICHAPU
					DGN.			
					DRN.	SK:102		
					CHD.	4.1.77		
					TRD.			
					COMP.			
A	23572-SA	15-11-96	MATERIAL AMENDED, PROTECTIVE FINISH ADDED	[Signature]			MATERIAL :- AS STATED.	APPROVED, DT. 4-2-77 (NEG. PREPARED)
A	22372-SA	6-1-94	PART No-12-13/60T WAS 12-13	[Signature]			DIMENSIONS ARE IN MILLIMETRES	
B	21133-SA	27-2-91	DRG. REVIEW REVISED, RE-DRAWN AND PROV. RE-SEALED	[Signature]			TUBE, ELECTROMAGNET	
			PREVIOUS DC(D) No. 19935-SA.	[Signature]			SCALE :- 2:1	DESIGNER'S REF. C.1SA-553/2
							SEALED :- PROV.DC(D)	PART NO. 12-13/60
							19935-SA, DT. 5-3-88	

8 7 6 5 4 3 2 1

DRAWING CONVENTIONS CONFORM TO IS: 696  
 TOLERANCES FOR UNTOLERACED DIMENSIONS  
 SEE 'MEDIUM' IS: 2102.  
 DRAWING PREPARED BY REVERSE ENGINEERING  
 PROCESS, AS SUCH SUITABLE NUMBER OF  
 ADVANCE SAMPLES ARE TO BE TRIED OUT  
 BY FITMENT & FIRING BY CQA(SA), BEFORE  
 BULK IS PRODUCED.



KIND OF CUT  
 SCALE: 10:1

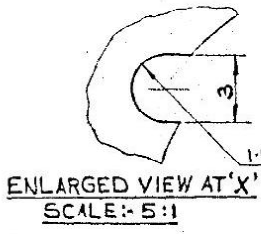


SECTION A-A

PROTECTIVE FINISH:-  
 ANODIZED AS PER GR. AC 2:5 OF  
 IS: 6651-1972, COLOUR - STEEL GREY.

MATERIAL:-  
 BS 2870:1800 DES. C2 106 COND. 1/2 H  
 TIGEN 1/2 H OR IS: 410-1967 DES.  
 CU ZN 30 TEMPER 1/2 H  
 BS 2870:80 DES. C2 106, CONDITION 1/2 H  
 IS: 410:77 DESIG. CU ZN 30, CONDITION HB.

65P 11305



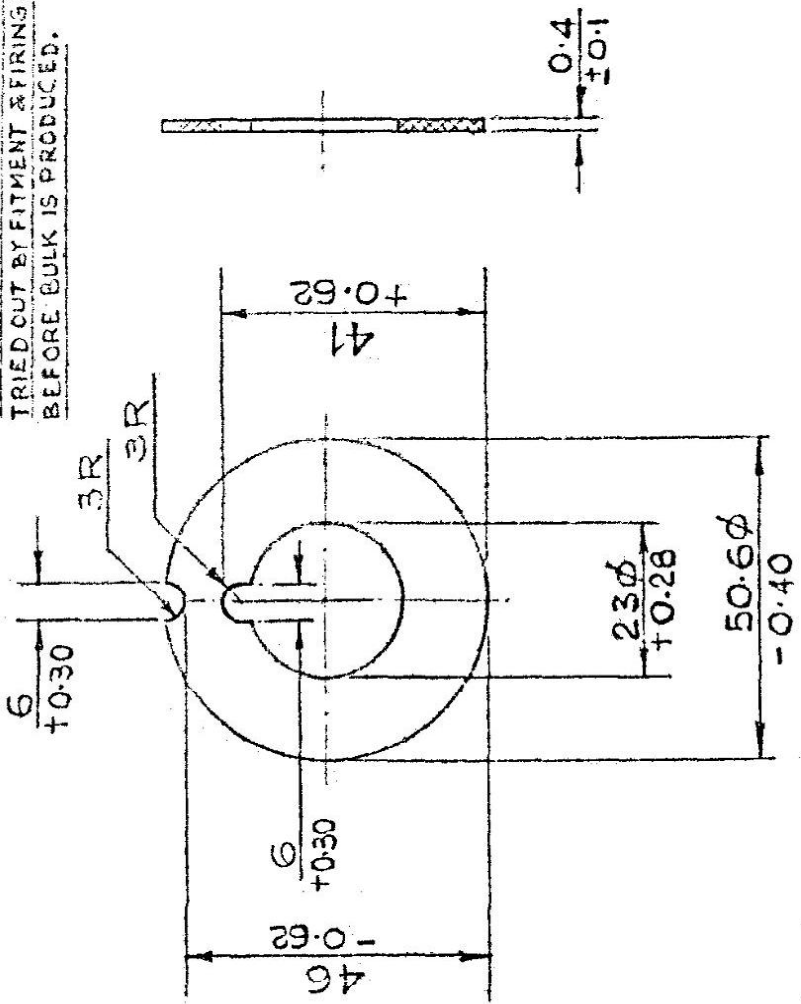
DATE	NAME	ASSY. CQA(SA)-102	CQA(SA) ICHAP
DGN.			
DRN.			
CHK.			
TRD.			
DATE	NAME	MATERIAL: - AS STATED.	APPROVED: - 4 2
		DIMENSIONS ARE IN MILLIMETRES	(NEG PREP)
15-11-96	SA		DESIGNER'S REF:
6.1.94	SA		CISA: 553
27-2-91	SA		PART NO.
			12-14/6
AUTHY.	DATE	ZONE	BRIEF RECORD.
			SIG.

DISC, BRASS  
 MAGNET COIL

PREVIOUS D.C. (I) NO. 19935-SA, DT. 5.3.88  
 SCALE: 1:1  
 SEALED: - FROM D.C. (I) 19935-SA, DT. 5.3.88.



NUMBER OF ADVANCE SAMPLES ARE TO BE TRIED OUT BY FITMENT & FIRING BY CQA SA BEFORE BULK IS PRODUCED.



MATERIAL :-  
HYLUM PAPER/BOARD CONFORMING ELECTRICAL  
PROPERTIES AS PER GRADE P-2 TO SPECN.  
IS: 2036 : 1974.

65P 11306

7

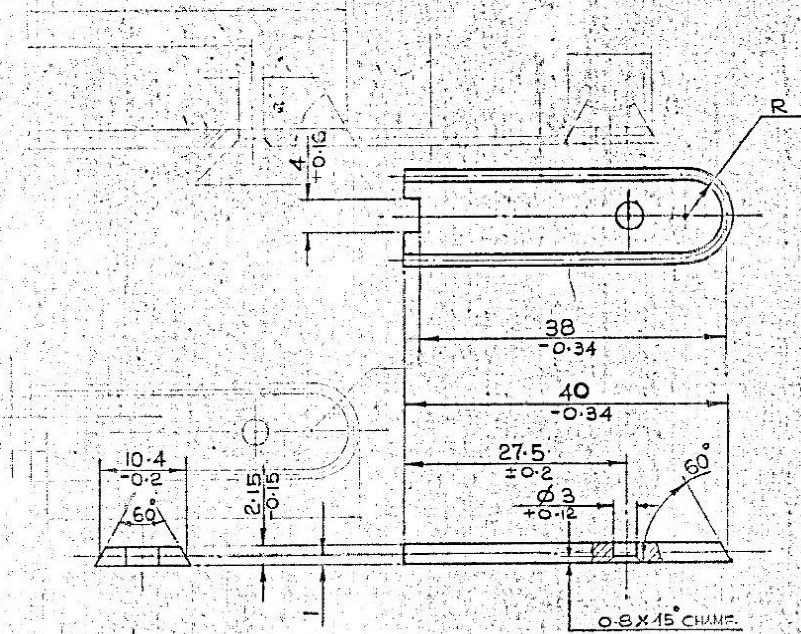
23529 -SA	17.10.96	MATERIAL AMENDED	DRG
22372	6.1.94	PART NO: 12-16/6 NT	350
21134 SA	27-2-91	WAS 12-16 DRG REVIEW, REVISED, RE-DRAWN AND PROJ. RE-SEALED PREV. D.C (I) NDS 19935 - SA.	COPI
AUTHY DATE ZONE		BRIEF RECORD	SIG
DRAWING CONVENTIONS		DATE	NAME
CONFORM TO IS: 696.		DGN.	A DAS
TOLERANCES FOR UN-		DRN.	A DAS
TOLERANCED DIMENSION		CHD.	A DAS
SEE MEDIUM IS: 2102		TRD.	
		COMP.	

ASSY. CQA(SA) SK-102  
 MATERIAL: ~~ESTATE~~ AS STATE  
 DIMENSIONS ARE IN MILLIMETRES  
 CQA(SA) ICHAPUR  
 APPROVED (DI. 4-278)  
 (NEG PREPARED)









DRAWING PREPARED BY REVERSE ENGINEERING PROCESS, AS SUCH SUITABLE NUMBER OF ADVANCE SAMPLES ARE TO BE TRIED OUT BY FITMENT & FIRING BY CQA(SA) BEFORE BULK IS PRODUCED.

DRAWING CONVENTIONS CONFORM TO IS: 696.

TOLERANCES FOR UNTOLERANCED DIMENSIONS SEE MEDIUM IS: 2102.

MATERIAL: - B8: 970 PT. 119] Gr. 030 M50 QR  
IS: 5517: 93 DESIGN: 50CB

HARDNESS: - 317-360 HV

PROTECTIVE FINISH: - PHOSPHATE TO SPECN: JSS 0465: 01-1988 CLASS II (ACCELERATED) OIL FINISH.

65P 11309

10

1005-560894

DATE	NAME	ASSY. CQA(SA)	SK 79	CQA(SA), ICHAPUR
26680-SA-07-08-13	D.S. CAT. No. ADDED			
23569-SA-14-11-96	MATERIAL & HARDNESS AMENDED; COATING DELETED; PROTECTIVE FINISH ADDED			
22370-SA-6-1-94	PART No. 12-17/817 WAS 4-G/55-P-A28MT			
21090-SA-24-1-91	DRAWING SEALED			
AUTHY	DATE	ZONE	BRIEF RECORD	SIG.

TRIGGER LATCH

MATERIAL: - AS STATED.

DIMENSIONS ARE IN MILLIMETRES

SCALE: - 2:1

SEALED - PRODUCE (U)

APPROVED

DESIGNER'S REF

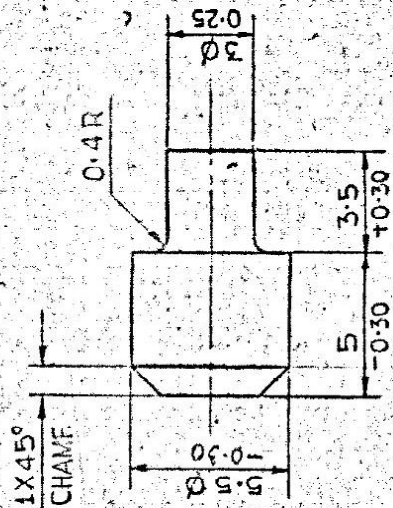
CQA(SA) SK 79

PART NO.

1005-560894



DRAWING PREPARED BY REVERSE ENGINEERING PROCESS.  
 AS SUCH SUITABLE NUMBER OF ADVANCE SAMPLES  
 ARE TO BE TRIED OUT BY FITMENT & FIRING BY  
 CQA(SA) BEFORE BULK IS PRODUCED.



MATERIAL: -  
 BS 970-PT.1:91 G0.080 M 50 OR  
 IS:5517:93 DESIG.50 CB

HARDNESS: - 315-360 HV  
 PROTECTIVE FINISH:  
 PHOSPHATE TO SPECN.JSS 0465-01-1988  
 CLASS-II (ACCELERATED), OIL FINISH

65P 11310

11

AW	26680 USA	07.08 13		D.S.CAT. No. ADDED.	350
	23570 SA	14-11-96		MATERIAL & HARDNESS AMEN IDEO HEAT-TREATMENT DELAYED/PROTECTIVE FINISH ADDED.	DAC
	AUTHY.	DATE	ZONE	BRIEF RECORD	516

22370  
22370  
21690-39-1

PART NO. 12-18/607  
 WAS 4-7/55-P-428 MT. 350  
 DRG. SEALED PROFESSIONALLY

BRIEF RECORD	DATE	NAME
CONFORM TO IS 1625		
TOLERANCES FOR		
UNGLE HANCED		
DIMENSIONS SEE		
MEDIUM IS: 2102		

SCALE: 5:1  
 SEALED, PROV. DC (I)  
 21050-SA DT 24-1-91

5315-052603  
 CQA(SA) ICHAFUR

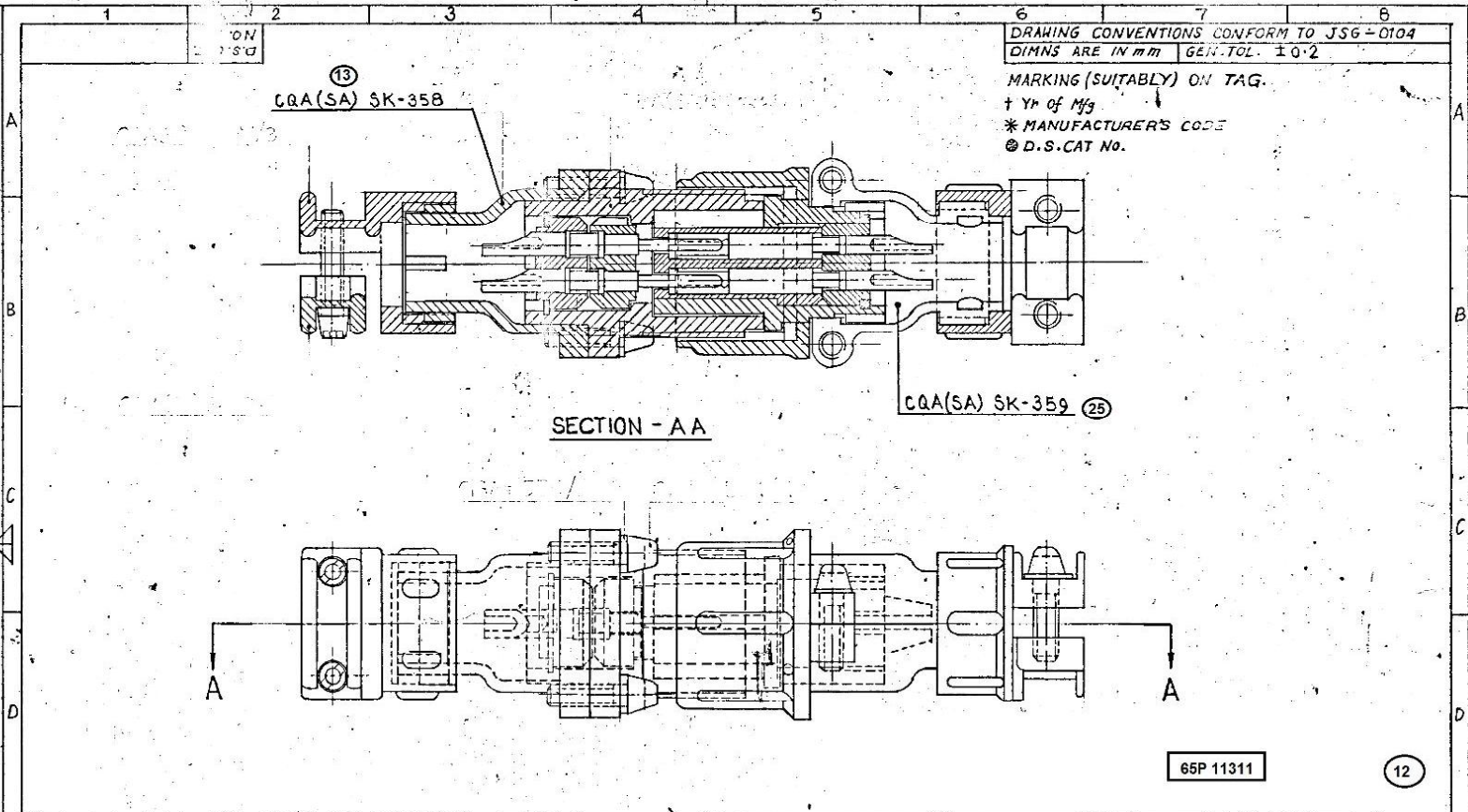
ASSY. CQA(SA) SK-77  
 MATERIAL: - AS STATED  
 DIMENSIONS ARE IN MILLIMETRES

APPROVED

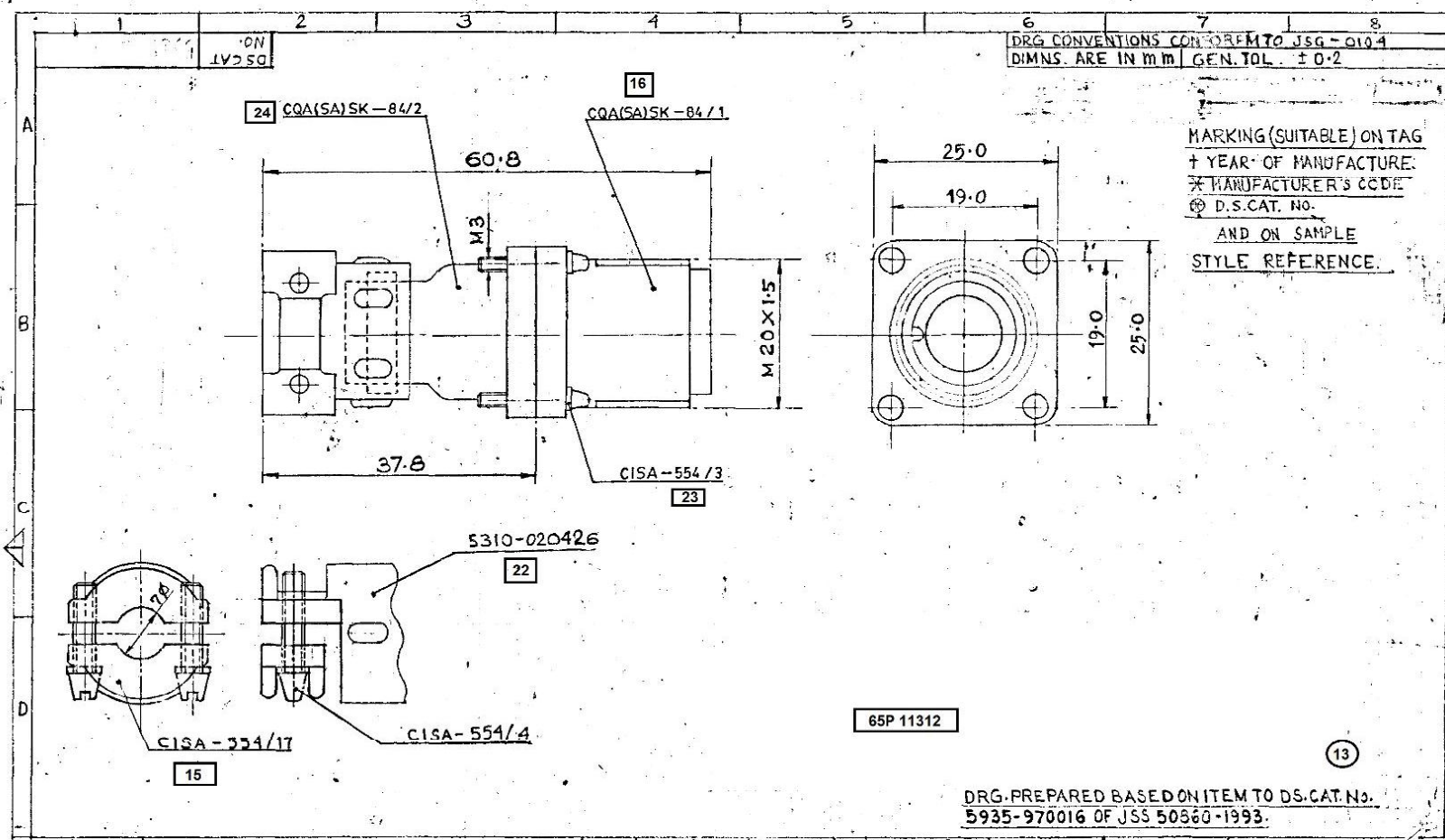
DT 22-12-90 FOR CQA(SA)  
 DESIGNER'S REF.  
 CQA(SA) SK-79/2  
 PART NO.

SPRING GUIDE  
 PIN





		DRN <i>Rand</i> ICHD <i>...</i>		TRD	COMP.	AHSP CQA(SA), ICHAPUR
		SCALE - 2:1		EST. MASS.		ASSY: 5945-007666
		DT 24-2-97 <i>Amles</i>		APPROVED. <i>...</i>		
		ZONE <i>...</i>		DT. 25.02.97 FOR CQA(SA)		PART No. 56-CZ-428 MT
7-3-97 23716-SA		DRAWING SEALED PROVISIONALLY.		HT./HARDNESS		DRG. NO. CQA(SA)SK-84.
DATE AUTHY		BRIEF RECORD		PROTECTIVE FINISH.		D.S. CAT. NO.
SEALED:- PROV. SEALED, DC No. 23716-SA, DT. 7.3.97		SIGN				
NOMENCLATURE		PLUG IN CONNECTOR ASSEMBLY.				



DRG CONVENTIONS CONFORM TO JSG-0104  
DIMNS ARE IN MM GEN. TOL ± 0.2

MARKING (SUITABLE) ON TAG  
+ YEAR OF MANUFACTURE  
\* MANUFACTURER'S CODE  
⊕ D.S.CAT. No.  
AND ON SAMPLE  
STYLE REFERENCE.

DRG. PREPARED BASED ON ITEM TO D.S.CAT. No.  
5935-970016 OF JSS 50560-1993.

22.8.98	24165-SA	NOTE DELETED, DETAIL DRG. NOS. INDICATED AND DRG. NO. CISA 554/4 WAS CISA 554/11.			DRN <i>CHD</i>	TRD	COMP	AHSP - CQA(SA) ICH:PU
26.11.97	23963-SA	VIEW ADDED, AMENDED; DIM. 7 Ø & DRG. NOS. SHOWN PROPERLY & NOTE AMENDED.			SCALE - 2:1	EST. MASS APPROVED		ASSY CQA(SA)SK-84
7.3.97	23716-SA	DRG. SEALED PROVISIONALLY.			DT 24.2.97	DT. 25.02.97 FOR CQA(SA)		DGMR'S STYLE REF CCTH REF WPT/R-10-2-S-M-USG
		DATE AUTHY	ZONE	I/C:DO	GO.			PART NO. 511
		SEALED - PROV. SEALED. DC No. 23716-SA, DT. 7.3.97.		SIGN				DRG No. CQA(SA)SK-358
NOMENCLATURE :- OUT LINE SKETCH OF CONNECTORS, CIRCULAR, THREADED COUPLING (METRIC SHELL SIZE) RECEPTACLE.						PROTECTIVE FINISH.		DS CAT No.





DRAWING PREPARED BY REVERSE ENGINEERING,  
AS SUCH SUITABLE NUMBER OF ADVANCE SAMPLES  
ARE TO BE TRIED OUT BY FITMENT & FIRING BY  
CISA, BEFORE BULK IS PRODUCED

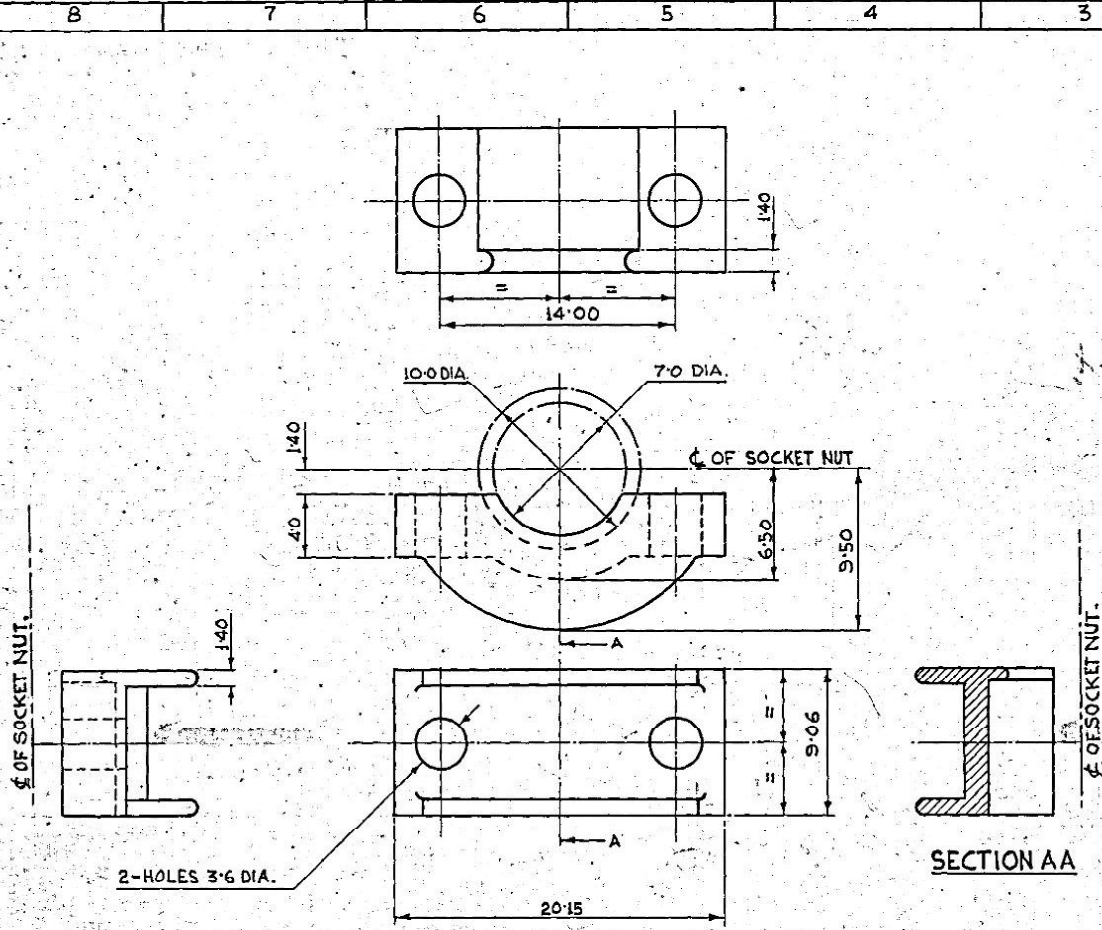
MATERIAL:-  
AL ALLOY TO SPECN. BS:1490-1970 DESIG.  
LM-9 OR IS:617-1975 DESIG.4635

ALTERNATIVE MATERIAL:-  
AL ALLOY TO SPECN. BS:1490-1970 DESIG.  
LM-6 OR LM-25  
OR  
IS:617-1975 DESIG.4600 OR 4600A OR 4450

SHARP EDGES REMOVED

TOLERANCES FOR UNTOLERANCED DIMENSIONS  
SEE 'MEDIUM IS:2102'

NOTE :-  
FOR OTHER TECHNICAL REQUIREMENTS  
REFER TO JSS :50860 - 1993



ELEVATION

SECTION AA

65P 11314

15

AUTHY.	DATE	ZONE	BRIEF RECORD	SIG.	D.C.N.	19935-SA.DT.53.88	SCALE:- 4:1	1/c.d.o.	SEALED:- PROV.	D.C.N.	19935-SA.DT.53.88	ASSLY.(QA(SA)SK:358&359	CQA(SA)I(CHAPUR
A	24.12.98	SA	17-12-98									ORG.NO. AMENDED IN ASSY. COLUMN.	⊕
A	23.95.8	SA	18-11-97	1/c/2								MATERIAL:- AS STATED	
	22.871	SA	20.2.95									DIMENSIONS ARE IN MILLIMETRES	
	21.876	SA	23.7.92									APPROVED DT.23.12.77	
	20.003	SA	7.8.88									CL.NEG.PREPARED	
												DESIGNER'S REF.	
												CISA-554/11	
												PART NO. 2-10/56	
												Z=428 M.T.	

SOCKET  
CLAMP