

ISV 2254

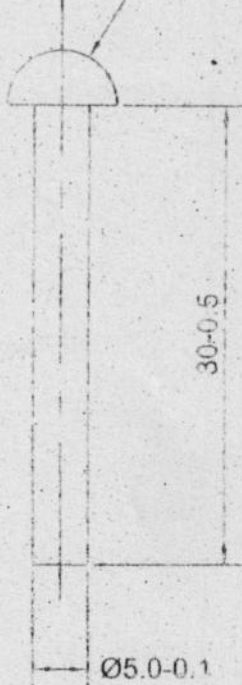
DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS

PART No. DIMENSIONS ARE IN mm.

DC 37283-A

GEN. TOLERANCE MEDIUM CLASS TO SPEC. IS:2102-1969

STANDARD HEAD



ACTUAL SIZE

MATERIAL :-

STEEL WIRE IN ACCORDANCE WITH SAE J 430 GRADE 'O'

ALT. MATERIAL :-

- i) STEEL WIRE TO SPEC. IS:7557-1994 IN ANNEALED CONDITION WITH 'P' CONTENT 0.04% Max.
- ii) TO BE MANUFACTURED IN ACCORDANCE WITH SPEC.No. IS:2155-1962

R.No.	DATE	AUTHORITY	REVISION	ZONE	AHSP	D.O
	30-06-2011	DC 37283-A	DRG. SEALED (PROV)			
DRG. SEALED - 30-06-2011 (PROV.)					SIG.	

DRN. <i>R.C. Diver</i>	CHD	TRD	COMP
C.D/MAN	<i>(Signature)</i>	SCALE: 1:1 & 2:1	EST MASS.
APPE	FOR CQA(A)	GAUGE SCHED.	DATE: 16-03-2011
MATL. AS ABOVE			
PROTECTIVE FINISH.			

ASSY DRG.	ISV305 A
DESIGNER'S REF	CQA(A) / AMN / 3505 DET.3
PART No.	ISV 2254
D.S.CAT No.	NOT TO BE ALLOTTED.
AHSP	CQA(A) KIRKEE

LATCH RIVET

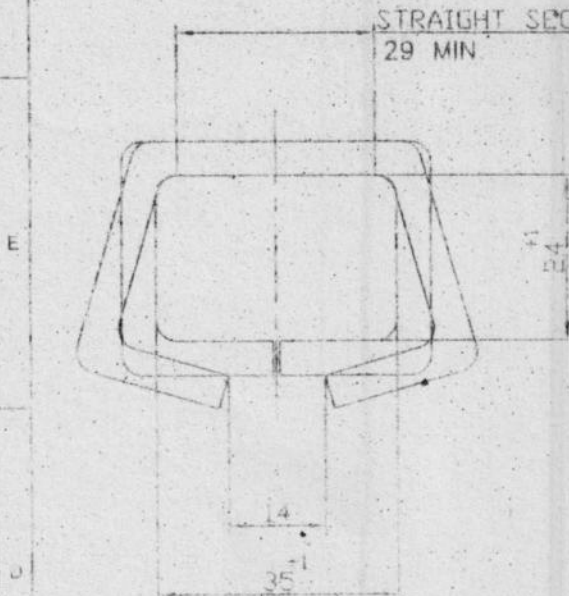
ISSV 2255

DRG. CONVENTIONS CONFORM TO IS: SPECIFICATIONS

DIMENSIONS ARE IN mm.

DC.37283-A.

GEN. TOLERANCE MEDIUM CLASS TO SPEC. IS:2102-1969.



MATERIAL -

STEEL ROD, COLD DRAWN SAE 1010 TO 1020 THICKNESS: ϕ 5.00

ALT. MATERIAL -

MS WIRE DIA 5mm TO SPEC. IS:280-1978 (3rd REW) IN SOFT DRAWN CONDITION, COMPOSITION AS PER S.7887-1992, Gde 8 WITH P CONTENT 0.04% Max.

R.No	DATE	AUTHORITY	REVISION	ZONE	AHSP	D.O
	30-06-2011	DC 37283-A	DRG SEALED (PROV.)			

DRG. SEALED 30-06-2011 (PROV.)			
DRN: <i>R.P. Thivar</i>	CHD: <i>A.V. Jadhav</i>	TRD.	COMP
G.D'MAN	O/C D.O	SCALE: 1:1 & 2:1	ASSY DRG
APPD: <i>[Signature]</i>	FOR COA(A)	EST MASS:	ISV305 A
MATL: AS ABOVE		GAUGE SCHD:	
PROTECTIVE FINISH: XXXXXXXXXX		DATE: 16-03-2011	DESIGNER'S REF.
			CQA(A) / AMN / 3505 DET 4
			PART No
			ISV 2255
			D.SCAT No
			NOT TO BE ALLOTTED
			AHSP
			CQA(A) KIRKEE

LOOP

BASE

AHSF: COA(A) KIRKEE		D.S. CAT NO.	
PART NO. ISV 2253		DESIGNER'S REF. COA(A) / AMN / 3505	
DATE: 16-08-2011		PROTECTIVE FINISH	
G.A.U. DATE: 16-08-2011		MATERIAL: AS ABOVE	
EST. MASS		APPS	
SCALE: 1:1		C.D. MAN	
TRD. COMP.		O.M.N. RAUT	
ASBY DRG. ISV305 A		CHD.	

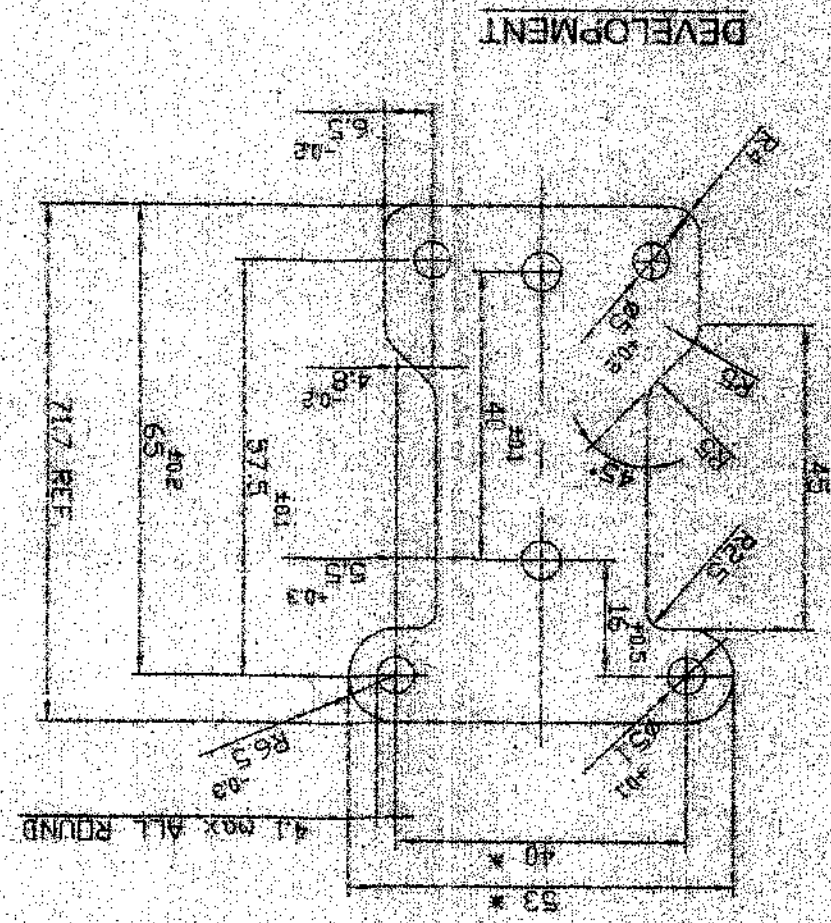
MATERIAL: COLD ROLLED, CARBON STEEL STRIP IN ACC TO ASTM A109M-77 DRAWING QUALITY, ALUMINIUM KILLED, TEMPER N#3, EDGE N#3 FINISH N#2

ALT MATERIAL: COLD ROLLED LOW CARBON STEEL STRIP TO SPEC IS 513-2008 DESIGNATION CR1 TEMPER 1/4 HAR WITH 'P' CONTENT 0.035% MAX.

DIMENSION OF STRIP: $2 \pm 0.05 (0.0787 \pm 0.002)$

DIMENSION WITHOUT TOLERANCE ARE TOOL DIMENSIONS

* INFORMATION DIMENSIONS ADJUST TO SUIT FINAL DIMENSION OF PART



ISV 2246

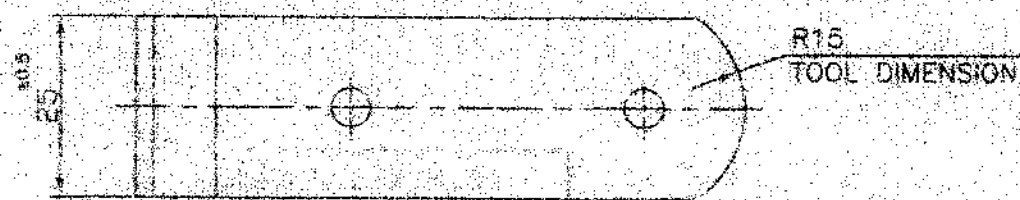
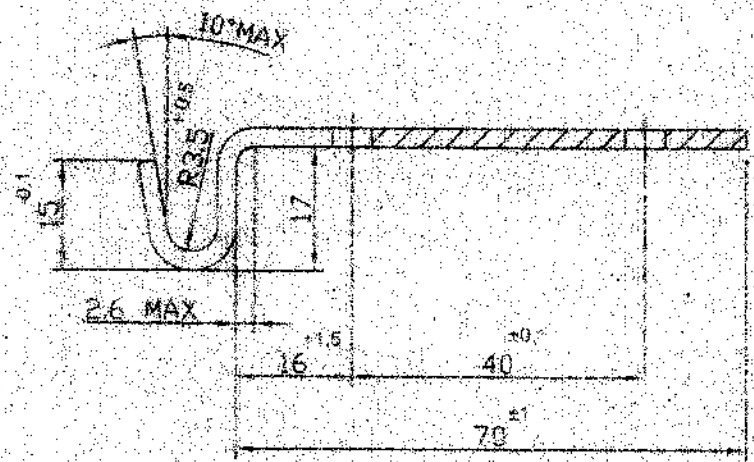
DRG. CONVENTIONS CONFORM TO IS: SPECIFICATIONS

PART NO

DIMENSIONS ARE IN mm.

DC.37283-A

GEN. TOL. MEDIUM CLASS TO IS:2102.



MATERIAL :-

COLD ROLLED CARBON STEEL STRIP IN ACC TO ASTM A 1008 - 70
DRAWING QUALITY ALUMINIUM KILLED TEMPER M₁₃ EDGE M₁₄ FINISH
DIMENSION OF STRIP - 2.6 ± 0.05 (0.102 ± 0.002")

ALT. MATERIAL :-

COLD REDUCED LOW CARBON STEEL STRIP TO SPEC. IS:675-3008
DESIGNATION CR1, TEMPER 1/4 HARD WITH 'P'CONTENT 0.035% MAX

PROTECTIVE FINISH :-

CADMIUM PLATING WITH SUPPLEMENTARY CHROMATE TREATMENT
THICKNESS 0.0076 TO 0.020 TYPE II CLASS 1 IN ACC WITH FED
SPEC. QQ-P-416

ALT. PROTECTIVE FINISH :-

ZINC COATING WITH CHROMATE TREATMENT TYPE III Fe/Zn 13 IN ACC
WITH ASTM B 533

DEVELOPMENT LENGTH:- 106mm

TONGUE

DRN- RAUT	CHD- <i>AK Jadhav</i>	TRG-	COMP-
C.D'MAN	G.H.D.S	SCALE- 1:1	EST.MASS.
APPR: <i>S</i>	FOR COA(A)	GAUGE SCHD.	DATE- 24-06-2010
MATL- AS ABOVE			
PROTECTIVE FINISH- AS ABOVE			

ASSY DRG	ISV 2246 A
DESIGNER'S REP	COA(A) AMN J 3509
PART NO	ISV 2246
D.S. CAT NO	
AHSP	COA(A) KIRKEE

R/NO	DATE	AUTHORIT	REVISION	ZONE	AHSP	D.O	SIG
	30-06-2011	DC 37283-A	DRG SEALED (PROV.)				
DRG SEALED 30-06-2011 (PROV.)							

ISV 305 SA	CO(A)/AMN/3905	ISV 626 A
ISV 305 SA	CO(A)/AMN/3905	ISV 626 A
ISV 305 SA	CO(A)/AMN/3905	ISV 626 A

DRN: <i>SPC 3/2011</i>	CHD: <i>6.3/2011</i>	TRD:	COMP:	ASSY DRG:
APPD:	CDMAN:	SCALE NTS:	EST MASS:	GAUGE GOLD:
MATL:	FOR GOVM:	DATE: 18-03-2011		

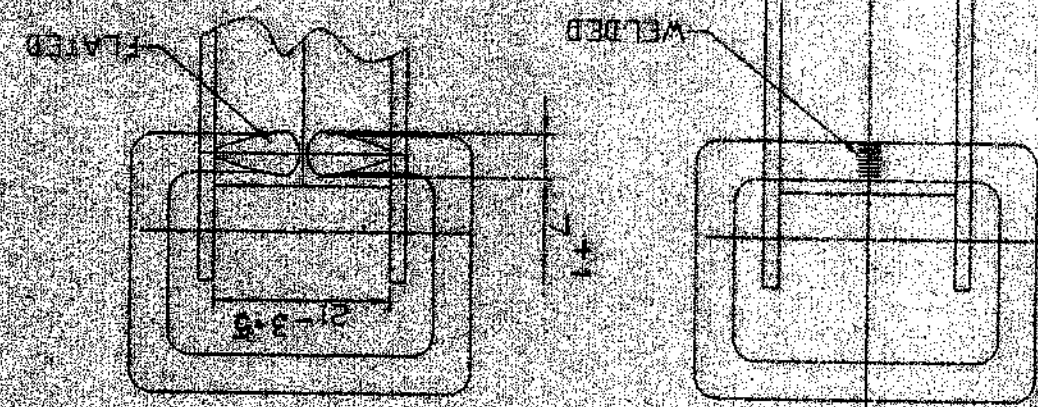
NO. DATE	AUTHORITY	REVISION	ZONE	SIG	O.O.	AHSP
30-06-2011	DC 07283-A	DRG SEALED (PROV)				
30-06-2011	DC 07283-A	DRG SEALED (PROV)				

LATCH UNIT

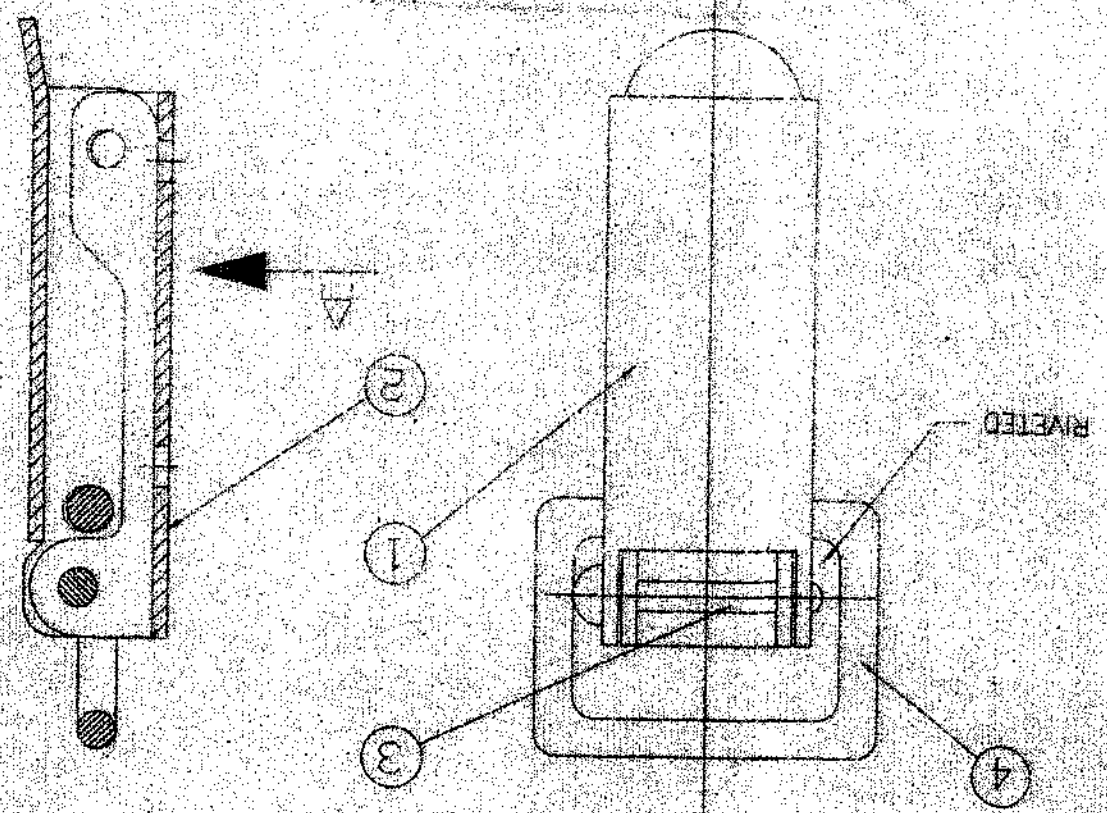
LIST OF COMPONENTS

SL. NO	DESCRIPTION	DESIGNER'S REF. NO.	PART NO.	QTY
1	LATCH	CO(A)/AMN/3905 DET.1	ISV 2252	1
2	BASE	CO(A)/AMN/3905 DET.2	ISV 2253	1
3	LATCH RIVET	CO(A)/AMN/3905 DET.3	ISV 2254	1
4	LOOP	CO(A)/AMN/3905 DET.4	ISV 2255	1

VIEW A
ALTERNATIVE PROCESSING FOR LOOP ASSY
WITHOUT PARTS No. 2 AND 3



PROTECTIVE FINISH -
ZINC COATING WITH SUPPLEMENTARY CHROMATE TREATMENT TYPE III Fe/Zn 12 ACC ASTM B 633.
ALTERNATIVE TREATMENT -
CADMIUM PLATING WITH SUPPLEMENTARY CHROMATE TREATMENT TYPE II CLASS 1 ACC TO FED SPEC 00-P-416
OR CADMIUM PLATING FOLLOWED BY CHROMATE PASSIVATION SPECN. IS 1572



ISV 305 SA	DRG CONVENTIONS CONFORM TO IS SPECIFICATIONS
ON LAMP	DIMENSIONS ARE IN MM
DC 07283-A	GEN TOL MEDIUM CLASS TO IS 2102