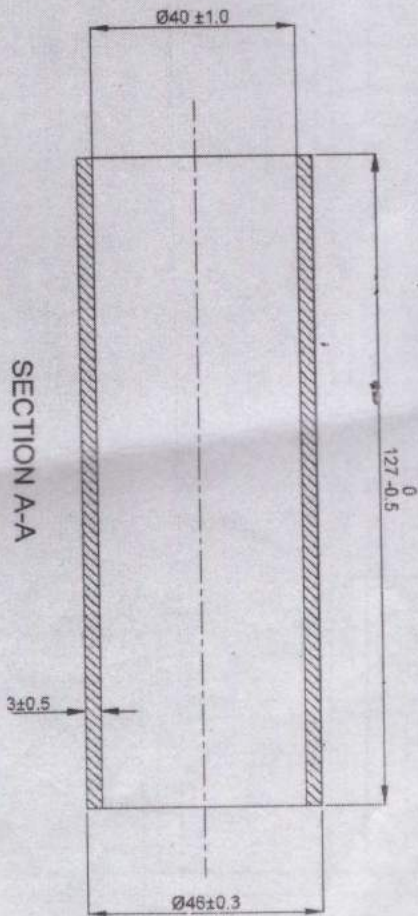
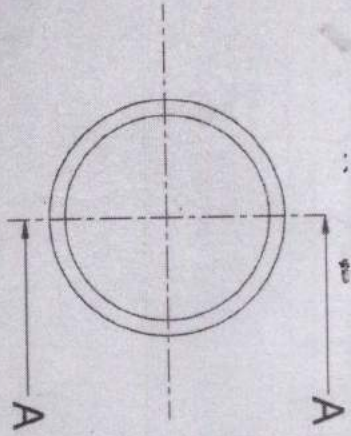


10-11-20W-16W-SCMB ON LTRV

DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS
DIMENSIONS ARE IN mm.

OFN PROPERTY.

This information contains in this drawing is to be used for official purposes only and shall not be reproduced or transmitted in any form or by any means or disclosed to any third party without prior permission from OFN.
This shall be returned to OFN when no longer contractually required.



- NOTES
1. CUT TO LENGTH ON LATHE
 2. MASS OF MACHINED TUBE 319.35 g.

REV. NO.	DATE	AUTHORITY	REVISION	SCALE	APP. NO.	APP. DATE	PROTECTIVE FINISH	DRG. MADE INTO COMAN FORMAT & NOTES ADDED
	31/04/2022							

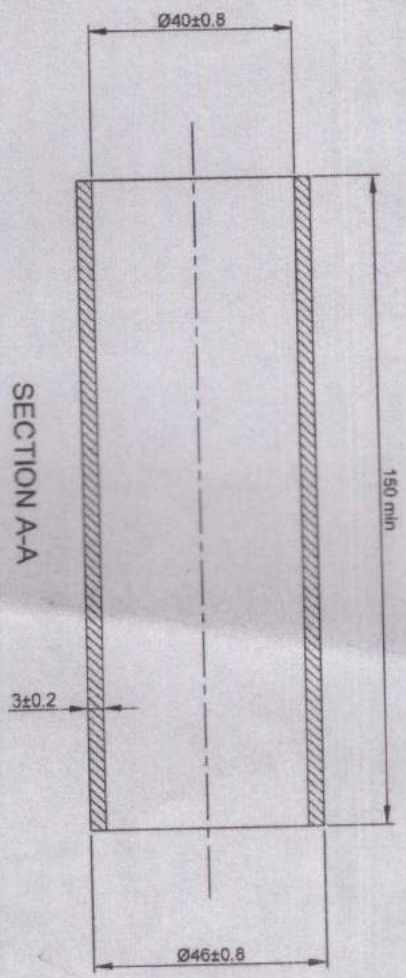
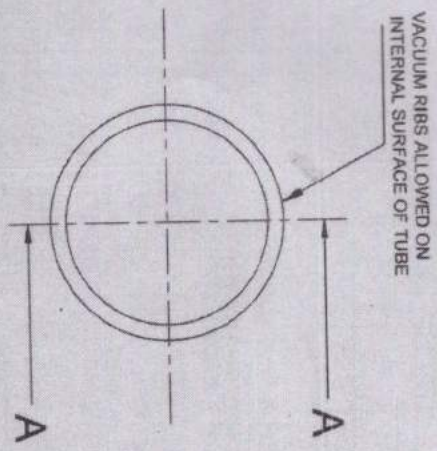
IGNITER TUBE, MACHINED, FOR 155mm BMCS M91 AND M92

BASED ON DENEL TOT DRG. NO.05730-001400A-203

ASSY.DRG.
PART NO. BMCS-M91-M92-IT-01
D.S. CAT NO.
AHSP

20-IT-29M-16W-SCMB ON 13V4
 DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS
 DIMENSIONS ARE IN mm.

OFN PROPRIETY.
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 This shall be returned to OFN when no longer contractually required.



- NOTES:
1. NO HOLES OR WEAK SPOTS SHALL BE PRESENT
 2. FLASH MARKS ALLOWED ON EXTERNAL SURFACE OF TUBE
 4. MANUFACTURE IN ACCORDANCE WITH DRG. NO.-BMCS-M91-M92-IT-01.

R.NO.	DATE	AUTHORITY	REVISION	ZONE	APSP	CL	WFL	PROTECTIVE FINISH	DRG. NO.	DRG. TITLE	SCALE	DATE	BY	CHECKED	APPROVED
	21.04.2022		DRG. MADE INTO COCALY FORMAT & NOTES ADDED								1:1				

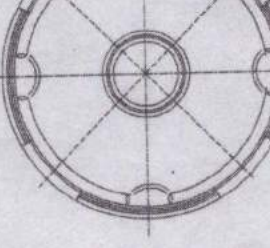
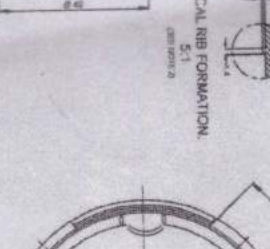
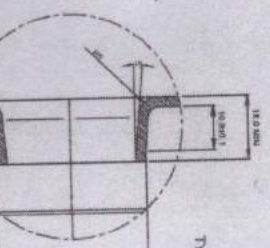
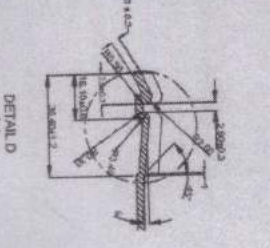
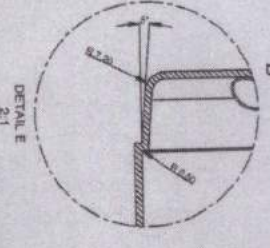
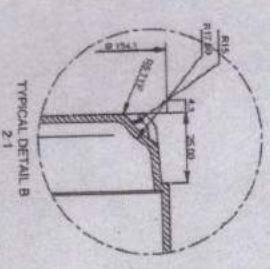
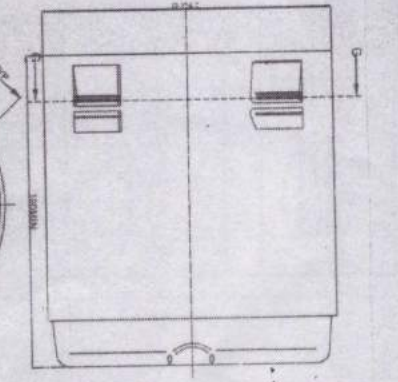
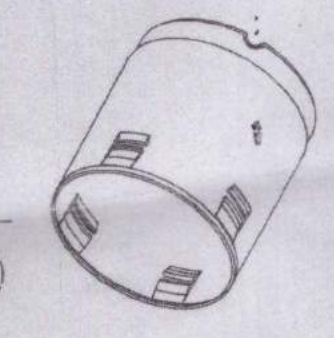
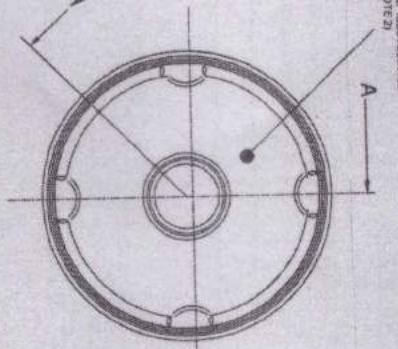
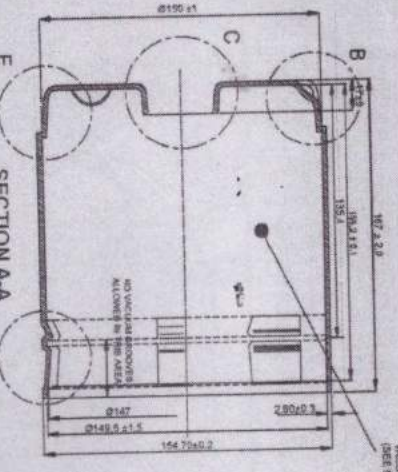
IGNITER TUBE, PRESSED, FOR 155mm BMCS M91 AND M92

BASED ON DENEL TOT DRG. NO.05730-001410A-203

ASSY. DRG.	DESIGNER'S REF.
PART NO. BMCS-M91-M92-IT-02	
D.S. CNT NO.	
AHSP	

10-CC-16M-SMIM
 PART D
 DRG. CONVENTIONS CONFORM TO
 IS SPECIFICATIONS
 DIMENSIONS ARE IN MM.

DRG. FOOTNOTES:
 The dimensions conform to the drawing is to be used for official purposes in order and shall be interpreted as
 intended to the extent of the drawing is not intended to be used for any other purpose than that for which
 the drawing is intended to be used in the original drawing.



- NOTES:
 1. PROCESS AND MANUFACTURE IN ACCORDANCE WITH DOC 05730-001500A-311
 2. RIBS FORMED AS PART OF VACUUM MOLDING PROCESS ALLOWED
 3. TOOLING MARKS BLEMISHES ALLOWED
 4. REMOVE ALL FLASHING ON EXTERNAL SURFACE OF CASE.

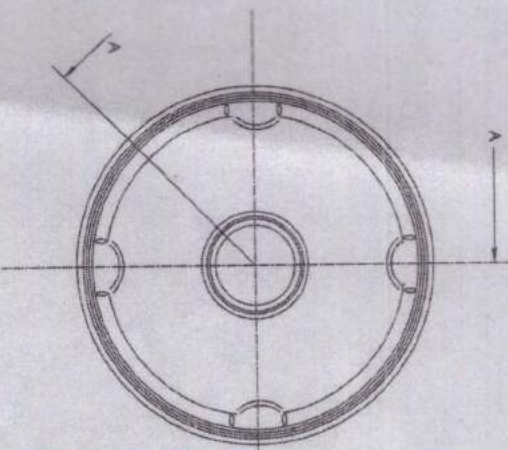
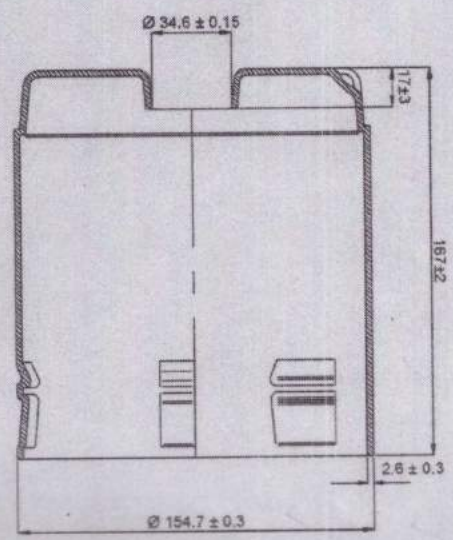
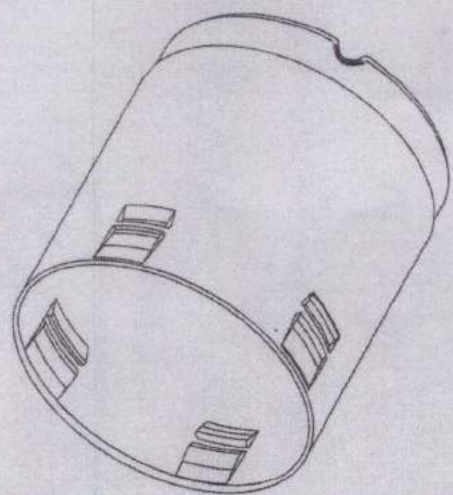
DRG. NO.	215M 2002	DRG. MADE INTO COMA/TORNA/T & NOTES ADDED	REVISION	ZONE	REV.	DATE	BY	CHKD.	APPD.	PROTECTIVE MARKS
REV.										
DESIGNERS										
DR. CAT. NO.										
PART NO.										
ASSY. DRG.										
SCALE	1:1									
DATE	21.04.2002									
AUTHORITY										
RAND.										
DRG. SEALED										

COMBUSTIBLE CARTRIDGE CASE (CCC) PRESSED FOR 155mm BMCS M91 (EMPTY)

BASED ON DETAIL 101 0803 M0 001 04081200A-001

20-CCC-16M-SBMC
ON PART
DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS
DIMENSIONS ARE IN MM

OPEN PROSPECT.
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This shall be returned to OFPA when no longer contractually required.



- NOTES
1. MASS OF UNCOATED CARTRIDGE SHALL BE 209g TO 235g.
 2. TOOLING MARKS AND DIMENSIONS ARE ACCEPTABLE.
 3. COATING WEIGHT MASS SHALL BE 8.5g TO 11.5g.
 4. FOR EMPTY MARKING SEE DRG. NO. BMC-S-M91-FILLED-M-01.

REV	DATE	AUTHORITY	REVISION	ZONE	APP'D	CO. SEAL	Q.C. SEAL	MATL.	INSPECTIVE FINISH
1	21.04.2022		DRG. MADE INTO COVAI FORMAT & NOTES ADDED						

COMBUSTIBLE CARTRIDGE CASE (CCC) MACHINED AND COATED FOR 155mm BMC-S M91 (EMPTY)

ASSY/DRG.
PART NO. BMC-S-M91-CCC-02
D.S. CAT NO.
AHSP:

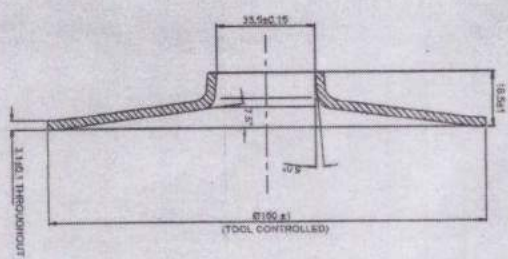
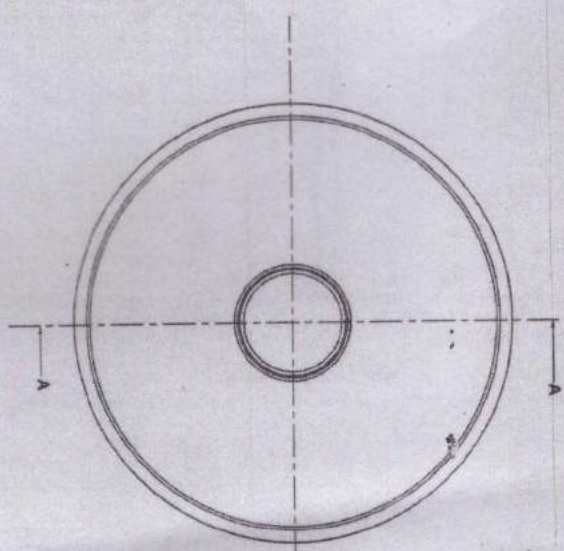
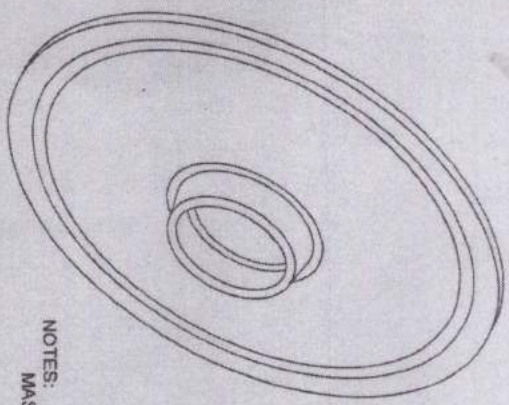
BASED ON DEBEL TOT DRG. NO. 06730-001501A-203 AND 05729-001000A-203

10-PRD-16W-SCWB ON LTRV

DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS
DIMENSIONS ARE IN MM.

OWN PROPERTY.

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NOTES:
MASS OF FINISHED PRODUCT SHALL BE 37g TO 43g

R.NO.	DATE	AUTHORITY	REVISION	ZONE	ISS	NO	DATE	REVISION
	21.04.2022		DRG. MADE INTO COA(A) FORMAT & NOTES ADDED					
DRG. SEALED -								

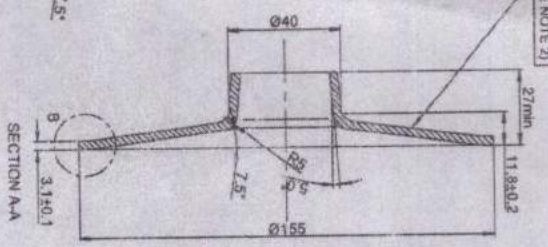
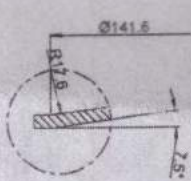
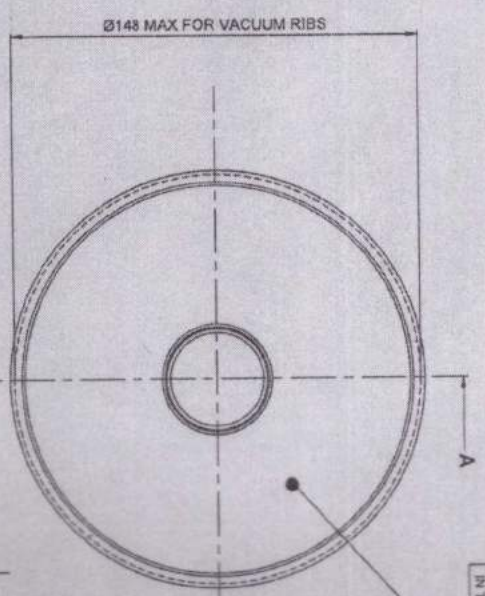
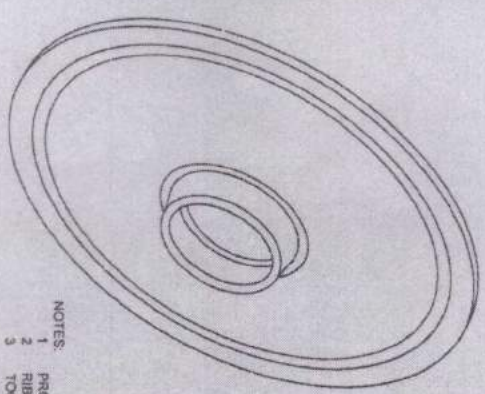
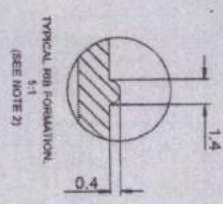
PROPELLANT RETAINING DEVICE (PRD) PUNCHED FOR 155mm BMCS M91

BASED ON DEVEL TOT DRG NO.05730-000100A-203

ASSY DRG.	DESIGNERS REF.
PART NO.	BMCS-M91-PRD-01
D.S. CAT NO.	
AHSP	

20-PRD-1-BM-SCMB ON 155V
 DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS
 DIMENSIONS ARE IN mm.

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 This shall be returned to OFR when no longer constructively required.



VACUUM RIBS ALLOWED IN THIS AREA (SEE NOTE 2)

- NOTES:
- 1 PROCESS AND MANUFACTURE IN ACCORDANCE WITH BMCS-M91-PRD-01
 - 2 RIBS FORMED AS PART OF VACUUM WELDING PROCESS ALLOWED.
 - 3 TOOLING MARKS BLEMISHES ALLOWED.

DRG. NO.	2144022	DRG. MADE INTO COA(A) FORMAT & NOTES ADDED	REV. NO.	1	DATE	19/15/89
DRG. SEALED >			REV. NO.	2	DATE	19/15/89
			REV. NO.	3	DATE	19/15/89

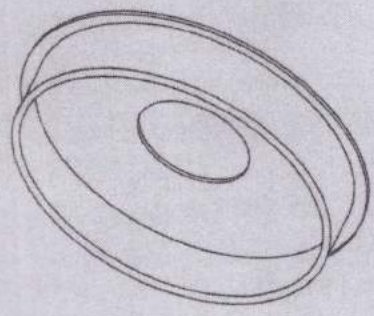
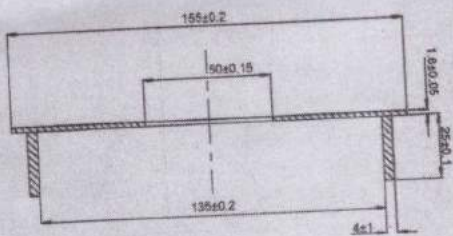
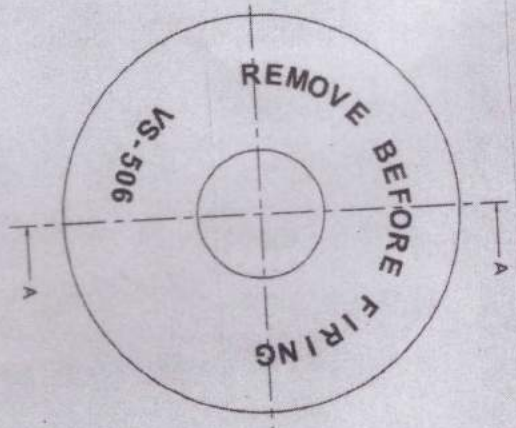
PROPELLANT RETAINING DEVICE (PRD) PRESSED FOR 155mm BMCS M91

BASED ON DENEL TOF DRG. NO.05730-000101A-203

ASSY. DRG.	11	SCALE	1:1
DESIGNER'S REF.		DATE	19/15/89
PART NO.	BMCS-M91-PRD-02	DATE	19/15/89
D.S. CAT. NO.		DATE	19/15/89
AHSP		DATE	19/15/89

10-S-DS-26W-16W-3-MCS-BMCS-ON PART 7 DIMENSIONS CONFORM TO IS SPECIFICATIONS DIMENSIONS ARE IN MM.

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NOTES:
 1. REMOVE BEFORE FIRING AND THE APPLICABLE "VS-506" TO BE RUBBER STAMPED ON THE DISC IN 10mm BLACK HIGH CHARACTER AS INDICATED.
 2. MATERIAL:- 2.1 SA GREYVILLE BOARD ALTERNATIVELY UMGENI MILL CHIP BOARD 2.2 PILES FOR 230 OR 340 gsm KRAFT.

DRG. BEHELD		DRG. MADE INTO CDMA) FORMAT & NOTES ADDED		REVISION		ZONE		MATERIAL		PROTECTIVE FINISH		ASSY. DRG.	
RANK	DATE	AUTHORITY											
	27.04.2022												
PART NO.		BMCS-M91-M92-DS-01		DESIGNERS REF.									
D.R. CAT NO.													
AHSF:													

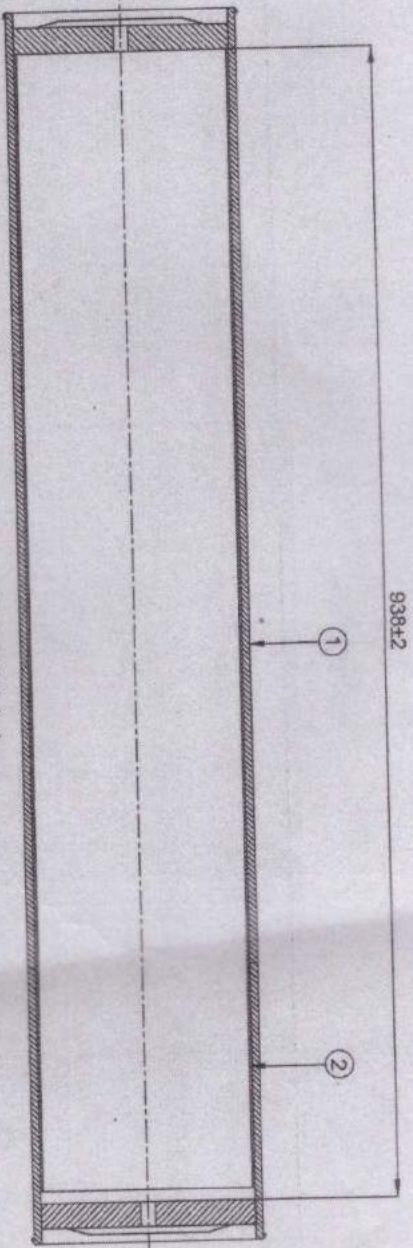
RING/DISC SPACER

BASED ON DRNEL TOT DRG. NO. 02612-100000-203

8	7	6	5	4	3	2	1
10-LD-F-750W-18W-SC-MB ON LRD		DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS		OPEN PROFITABILITY		DESCRIPTION	
DIMENSIONS ARE IN mm.						QTY.	
						01	BMC'S-M91-M92-FF-T04
						01	BODY ASSEMBLY OF CYLINDER 8703
						02	BMC'S-M91-M92-FF-T02
						01	LD ASSEMBLY OF CYLINDER 8703

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This shall be returned to ORNL when no longer conductively required.



SECTION A-A

NOTES:
THIS CONTAINER IS TO BE MANUFACTURED AND ASSEMBLED IN ACCORDANCE WITH SPEC.

CYLINDER 8703 (SAND STONE)

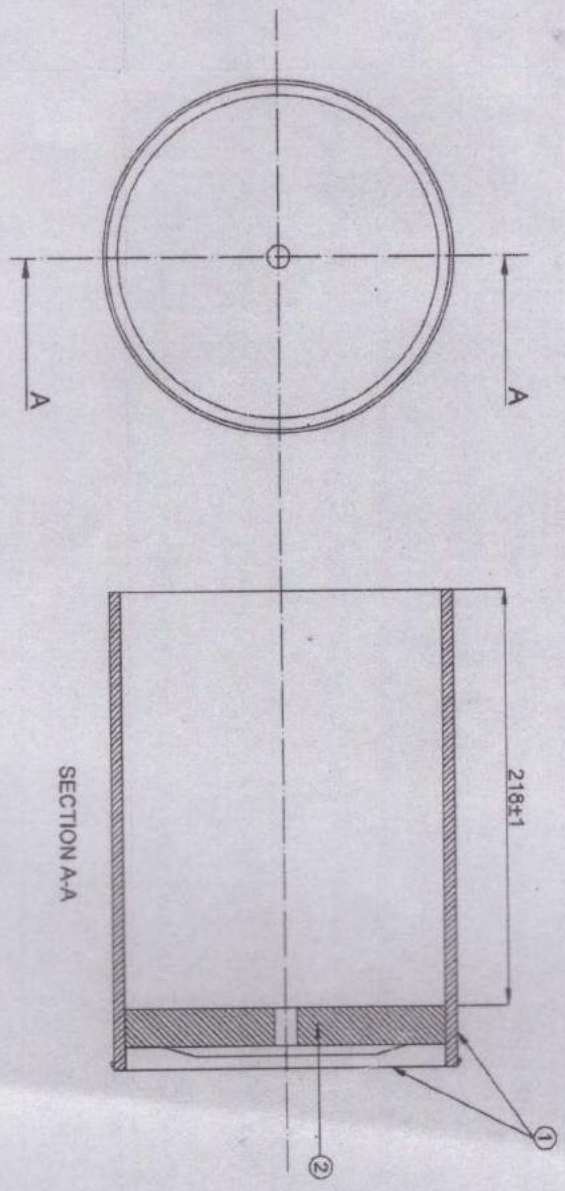
DATE	21.04.2022	AUTHORITY	DRG. MADE INTO COVA/1 FORMAT & NOTES ADDED	ZONE		APPD.		THD.	1:1	SCAFF.		ASSY DRG.	
RNO						FOR COVA/1		SCALE				PART NO.	BMC'S-M91-M92-FF-T-01
DRG. SEALED												D/S CMT NO.	AHSP

BASED ON DETAIL TOT DRG. NO. 98-87-46-03765-00001-202

20-LID-28W-16W-SCHMB ON LVVD
 DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS
 DIMENSIONS ARE IN MM.

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 or by any means electronic or mechanical, including photocopying,
 recording, or by any information storage and retrieval system.
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ITEM	DRG. NUMBER	DESCRIPTION	QTY.
01	BMC5-M91-M92-FPT-06	METAL END AND OUTER TUBE (LID) ASSEMBLY	01
02	BMC5-L91-M92-FPT-15	PROTECTING DISC OF CYLINDER 8703	01
03		ADHESIVE CONTACT (DENNEK ANY 8130)	APR



NOTES:
 ITEM 3 OR APPROVED SUBSTITUTE TO BE USED TO BOND ITEM 2 TO ITEM 1

DATE	21/04/2022	AUTHORITY		DRG. MADE INTO COQVA FORMAT & NOTES ADDED	ZONE		ASHP	OLD	DATE	PROTECTIVE FINISH
DRG. SEALED										

LID ASSEMBLY OF CYLINDER 8703

PART NO.	BMC5-M91-M92-FPT-02
D.S. CAT NO.	
AHSP	

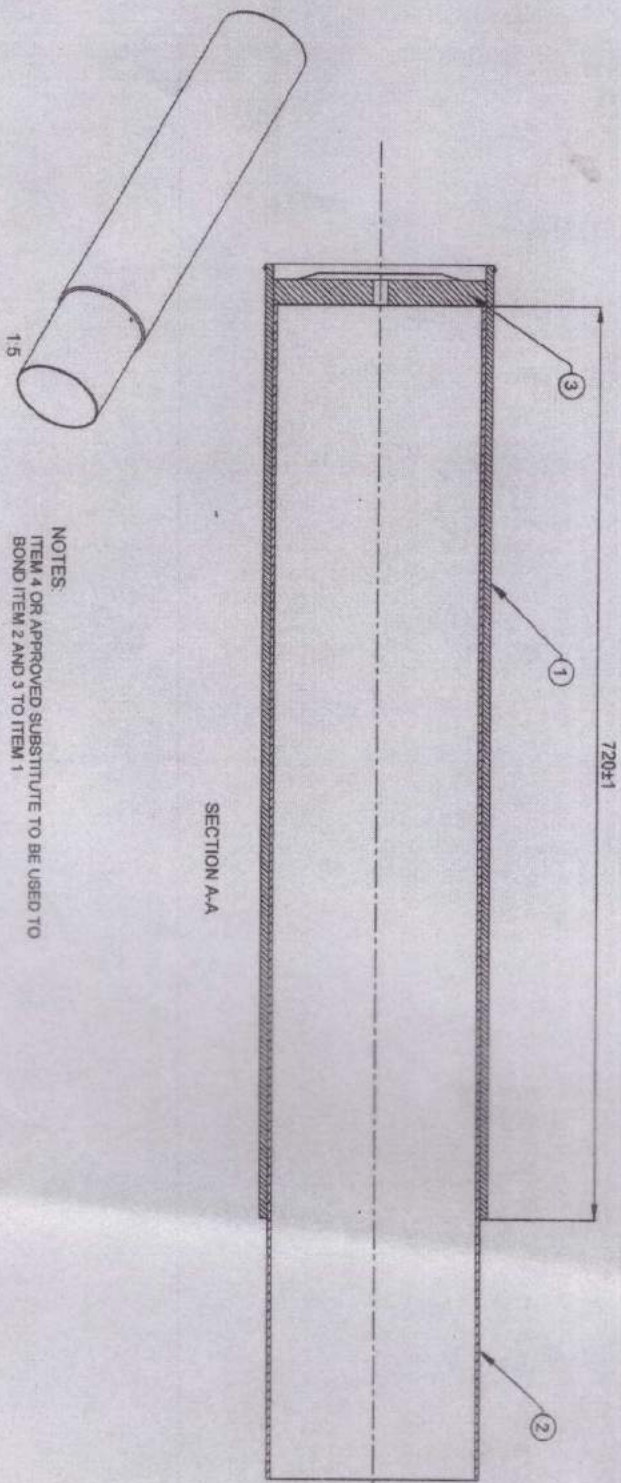
BASED ON DENNEK TOT DRG. NO. 06-8140-03766-01001-202

40-111-F-19M-19M-SCWB (ON LHM)

DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS
DIMENSIONS ARE IN MM.

GENERAL NOTE:
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This shall be returned to the originator when no longer contractually required.

ITEM	DRG. NUMBER	DESCRIPTION	QTY.
01	BMCS-M91-M92-FTP-05	METAL END COLLAR TUBE BODY ASSEMBLY	01
02	BMCS-M91-M92-FTP-11	PAPER TUBE (BODY) OF CYLINDER 8703	01
03	BMCS-M91-M92-FTP-15	PROTECTING DRG	01
04		ADHESIVE CONTACT/GUNNER AUV #139	01



NOTES
ITEM 4 OR APPROVED SUBSTITUTE TO BE USED TO
BOND ITEM 2 AND 3 TO ITEM 1

BODY ASSEMBLY OF FINAL PACKING TUBE CYLINDER 8703

DRG. NO.	DATE	AUTHORITY	REVISION	ZONE	REP.	Q.D.	MATL.	PROTECTIVE FINISH	APPRO.	DATE	FOR CORRAL	DATE	SCALE	ASBY. DRG.	DESIGNER'S REF.	PART NO.	D.S. CAT. NO.	AHSP.
	21.04.2022		DRG. MADE INTO COQVA FORMAT & NOTES ADDED													BMCS-M91-M92-FTP-04		

BASED ON DEMEL TOT DRG. NO. 08-9-140-03795-02001-202

90-FLT-25W-16W-SQ/MB ON LTRD

DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS

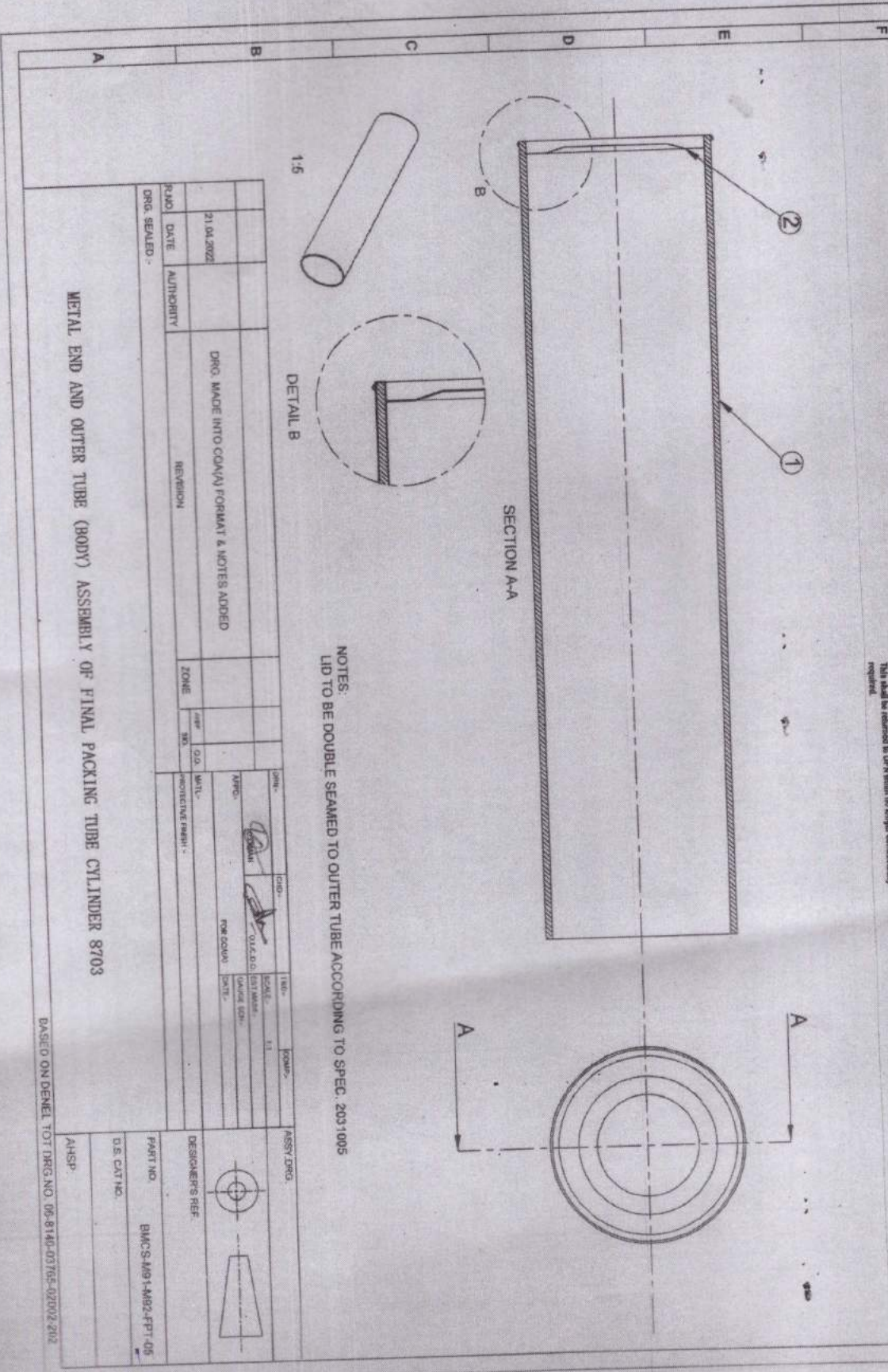
DIMENSIONS ARE IN MM.

ORIGIN: DENEL

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ITEM	DRG. NUMBER	DESCRIPTION	QTY.
01	BMC-S-AM91-M92-FPT-05	OUTER TUBE (BODY) OF CYLINDER 8703	01
02	BMC-S-AM91-M92-FPT-03	METAL END OF CYLINDER 8703	01



NOTES:
LID TO BE DOUBLE SEAMED TO OUTER TUBE ACCORDING TO SPEC. 2031005

METAL END AND OUTER TUBE (BODY) ASSEMBLY OF FINAL PACKING TUBE CYLINDER 8703

REV.	DATE	AUTHORITY	REVISION	ZONE	APP. NO.	CO. MATL.	WORKING DRAWING
1	21.04.2002		DRG. MADE INTO COMVA FORMAT & NOTES ADDED				

DRG. SEALED -

BASED ON DENEL TOT DRG. NO. 06-8140-0765-02002-202

SCALE	UNIT	FORM	ASSY. DRG.
1:1	mm	1	

DESIGNER'S REF.

PART NO. BMC-S-AM91-M92-FPT-05

D.S. CATING.

AHSP

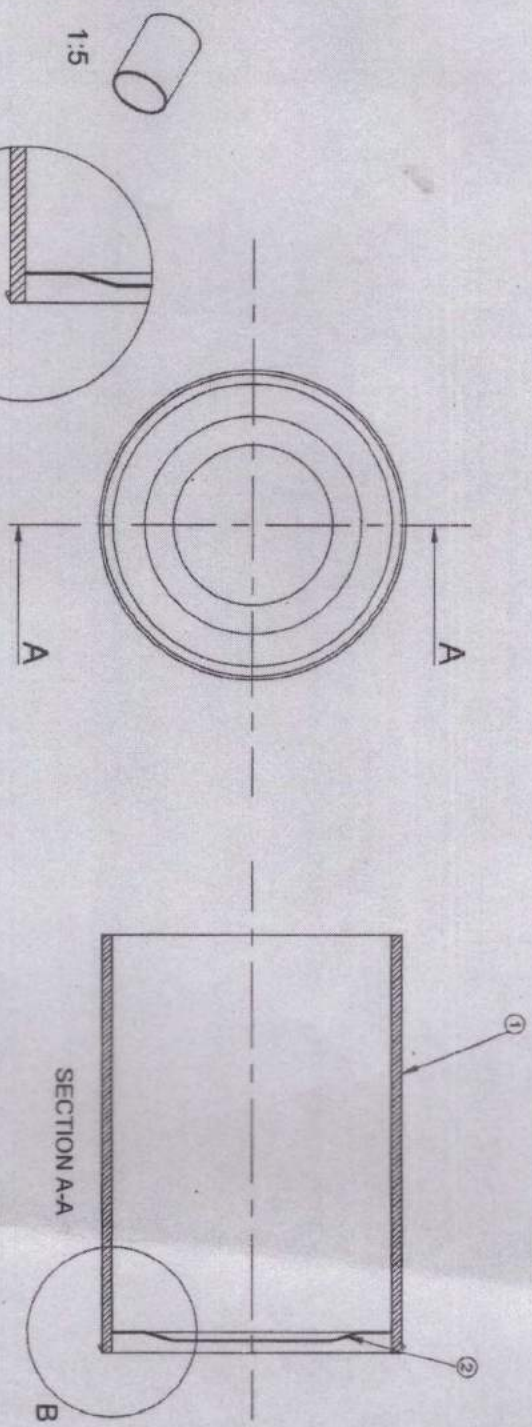
90-14-1-2017-16W-SQMB ON LTRVD

DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS

DIMENSIONS ARE IN MM.

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ITEM	DRG. NUMBER	DESCRIPTION	QTY.
01	BMCS-M91-1402-PRT-16	OUTER TUBE (LID) OF CYLINDER 8703	01
02	BMCS-M91-1402-PRT-13	METAL END OF CYLINDER 8703	01



NOTES:
LID TO BE DOUBLE SEAMED TO OUTER TUBE ACCORDING TO SPEC. 2031005.

DRG. NO.	21-04-2022	DATE	21-04-2022	AUTHORITY	
DRG. MADE INTO COM(A) FORMAT & NOTES ADDED		REVISION		ZONE	
DRG. SEALED >		PROTECTIVE FINISH >			
DATE		SCALE	1:1	ASBY DRG.	
APPRO.		CHK'D BY		RETURNS	
DATE		DATE		DATE	
DESIGNER'S REF.		PART NO.	BMCS-M91-1452-FPT-06	D.S. CAT NO.	
		AHSP:			

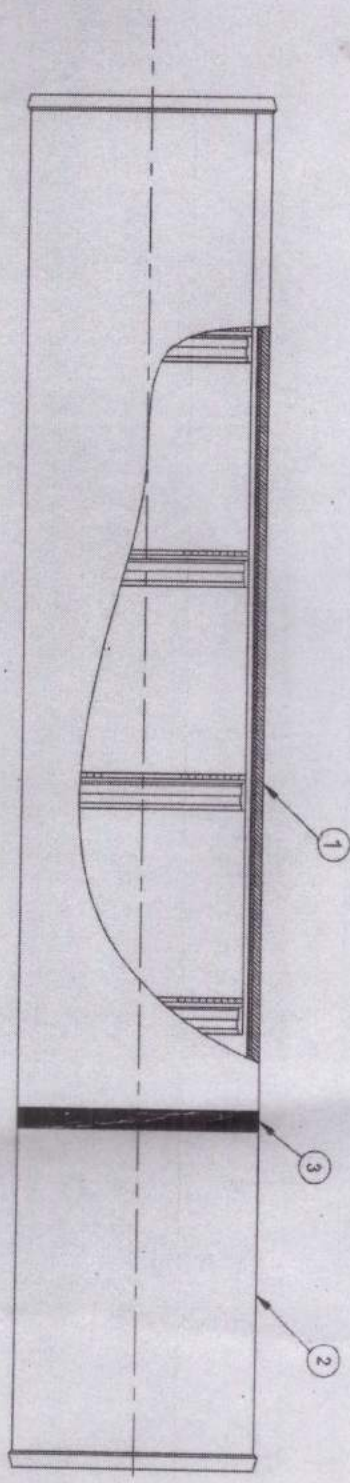
METAL END AND OUTER TUBE (LID) ASSEMBLY OF FINAL PACKING TUBE CYLINDER 8703

BASED ON DENEL TOT DRG. NO. 06-9140-03706-01002-202

107-144-209-BMCS-M92 ON LTRD
 DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS
 DIMENSIONS ARE IN MM.

OWN PROPERTY.
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ITEM	ORGANIZATION	DESCRIPTION	QTY.
01	BMC(M92-FPT-07)	SEALED 155mm BMC(M92-FPT-07) CYLINDER 8703	01
02	BMC(M92-FPT-07)	LD ASSEMBLY OF CYLINDER 8703	01
03	-	TYPE BELT ADHESIVE 155mm WIDE WHITE-EM SCOTCH	APR



SECTION A-A

- NOTES:
1. THE JOINT BETWEEN ITEM 1 AND ITEM 2 TO BE SEALED TIGHTLY WITH A DOUBLE LAYER OF ITEM 3.
 2. FOR PACKAGE MARKING ON METAL ENDS. SEE DRG. NO. BMC(M92-FPT-17)

155mm BMC(M92-FPT-07) HZ FILLED, FINAL PACKED IN CYLINDER 8703

DATE	AUTHORITY	REVISION	ZONE
21 04 2002		DRG. MADE INTO COQA(I) FORMAT & NOTES ADDED	

DATE	AUTHORITY	REVISION	ZONE

DATE	AUTHORITY	REVISION	ZONE

DATE	AUTHORITY	REVISION	ZONE

BASED ON DENEL TOI DRG. NO. 05730-102000-202

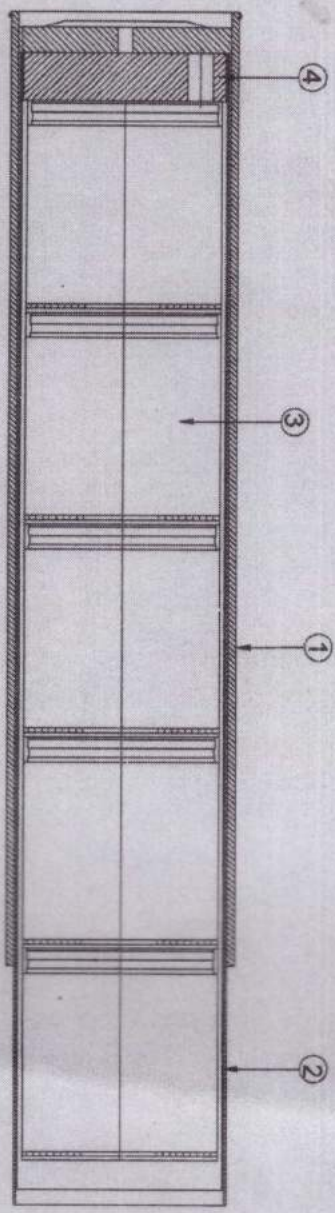
PART NO.	BMC(M92-FPT-07)
D.B. CAT NO.	
AHSP	

60-LD-28M-SQ/MT/ON LTR/4

DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS
DIMENSIONS ARE IN MM.

DRG. PROPERTY:
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This shall be returned to OFR when no longer constructively required.

ITEM	DRG. NUMBER	DESCRIPTION	QTY.
01	BMC-A92-FPT-09	ROCK ASSEMBLY OF CYLINDER 8703	01
02	BMC-A92-FPT-14	LINER CORRUGATED BOARD OF CYLINDER 8703	01
03	BMC-A92-FPT-01	SEALER 155mm BMC'S M92/M93 C/W/MSG C/W/MSG IN BARRIER BAG	05
04	BMC-A92-FPT-03	GASZEPER PACKING TOP OF CYLINDER 8703	01



SECTION A-A

NOTES:

1. ITEM 2 TO BE INSERTED INTO ITEM 1 WITH THE CORRUGATED SIDE AGAINST THE WALL OF ITEM 1.
2. ITEM 4 TO BE INSERTED AT BOTTOM OF ITEM 1.
3. ITEM 3 TO BE INSERTED INTO ITEM 1 WITH THE PRD TO THE OPEN END OF CONTAINER.

DRG. SEALER	DATE	21.04.2022	AUTHORITY	REVISION	ZONE	APP. BY	DATE	SCALE	1:1	FORM	11						
DRG. MADE INTO COQA(N) FORMAT & NOTES ADDED																	
<table border="0"> <tr> <td>DRG. NO.</td> <td>BMC-A92-FPT-09</td> </tr> <tr> <td>D.E. C/T NO.</td> <td></td> </tr> <tr> <td>AHSP:</td> <td></td> </tr> </table>												DRG. NO.	BMC-A92-FPT-09	D.E. C/T NO.		AHSP:	
DRG. NO.	BMC-A92-FPT-09																
D.E. C/T NO.																	
AHSP:																	

SEALED 155 mm BMC'S M92 IN CYLINDER 8703

BASED ON DENEL TOT DRG. NO. 06/30-102001-202

8 7 6 5 4 3 2 1

DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS

DRG. DIMENSIONS ARE IN mm.

DRG. DIMENSIONS ARE IN mm.

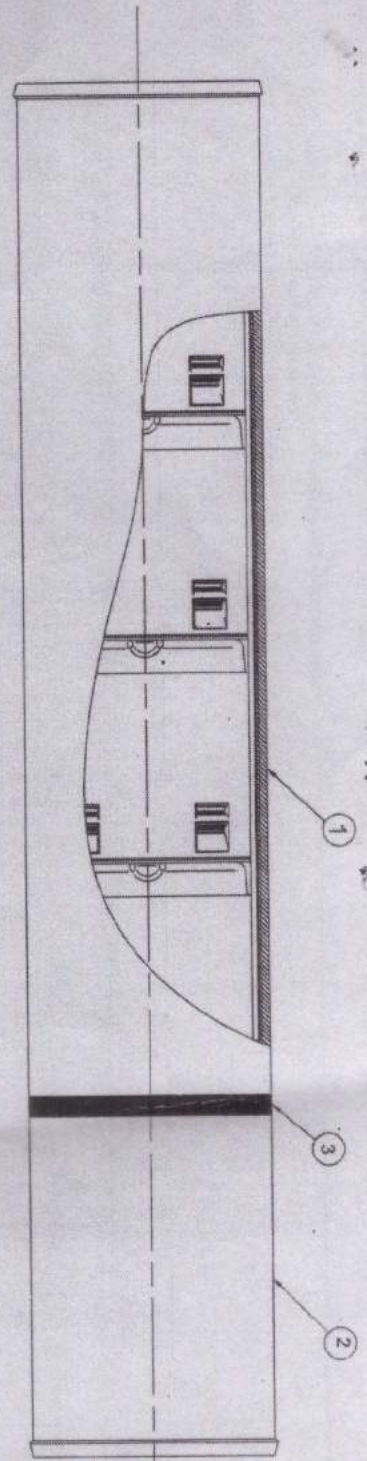
DRG. DIMENSIONS ARE IN mm.

DRG. DIMENSIONS ARE IN mm.

DRG. DIMENSIONS ARE IN mm.

DRG. DIMENSIONS ARE IN mm.

ITEM	DRG. NUMBER	DESCRIPTION	QTY.
01	BMC-S-MB1-F-PT-18	SEALED 150mm BMC3 M91 CYLINDER 8703	01
02	BMC-S-MB1-AMB-PT-08	LED ASSEMBLY FOR CYLINDER 8703	01
03		TYPE SELF ADHESIVE 15mm WIDE WHITE-3M SCOTCH TAPE	AN



SECTION A-A

- NOTES:
1. THE JOINT BETWEEN ITEM 1 AND ITEM 2 TO BE SEALED TIGHTLY WITH A DOUBLE LAYER OF ITEM 3.
 2. FOR PACKAGE MARKING ON METAL ENDS SEE DRG. NO. BMC3-M91-F-PT-18

DATE	21.04.2022	REVISION		ZONE		SCALE	1:1	SCALE	1:1	SCALE	1:1
R.N.O.		AUTHORITY									
DRG. MADE INTO COGNIT FORMAT & NOTES ADDED											
150mm BMC3 M91 FILLED, FINAL PACKED IN CYLINDER 8703											
AHSP:											

BASED ON ORG. NO. 107 DRG. NO. 06724-11100-002

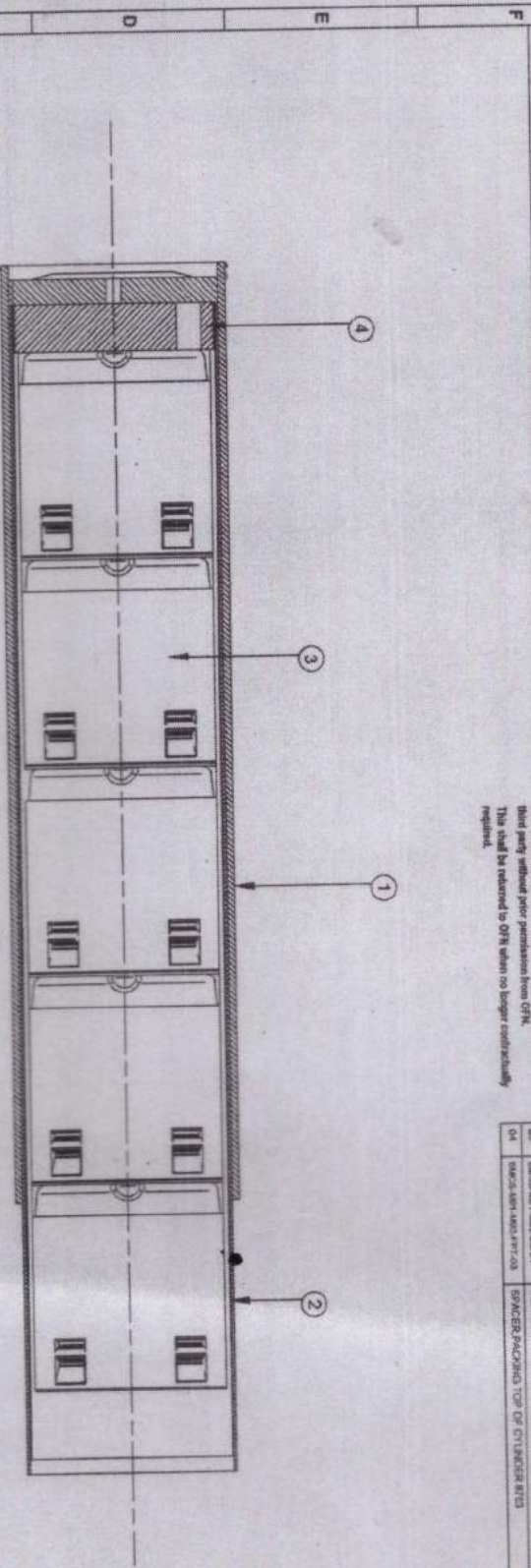
01-FPT-10-BMCS-M91 ON LHM
DIMENSIONS ARE IN MM.

DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS

ORH REQUEST.

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ITEM	DRG. NUMBER	DESCRIPTION	QTY.
01	BMCS-M91-FPT-10	BODY ASSEMBLY OF CYLINDER 8703	01
02	BMCS-M91-FPT-10	LINER CORRUGATED BEHIND OF CYLINDER 8703	01
03	BMCS-M91-FPT-10	SEALED 155mm BMCS M91/8703 CHANGE IN PARTS AND	05
04	BMCS-M91-FPT-10	SPACER PACKING 129 OF CYLINDER 8703	01



SECTION A-A

NOTES:

1. ITEM 2 TO BE INSERTED INTO ITEM 1 WITH THE CORRUGATED SIDE AGAINST THE WALL OF ITEM 1.
2. ITEM 4 TO BE INSERTED AT BOTTOM OF ITEM 1.
3. ITEM 3 TO BE INSERTED INTO ITEM 1 WITH THE PRD TO THE OPEN END OF CONTAINER.

DATE	21.04.2022	DRG. MADE INTO CO(A) FORMAT & NOTES ADDED	REVISION	ZONE	APPR.	CHKD.	DATE	SCALE	1:1	COMP.	ABST. DRG.
DATE					APPR.	CHKD.	DATE	SCALE		COMP.	ABST. DRG.
DATE					APPR.	CHKD.	DATE	SCALE		COMP.	ABST. DRG.
DATE					APPR.	CHKD.	DATE	SCALE		COMP.	ABST. DRG.
DATE					APPR.	CHKD.	DATE	SCALE		COMP.	ABST. DRG.

DRG. MADE INTO CO(A) FORMAT & NOTES ADDED

DRG. SEALED >

SEALED 155 mm BMCS M91 IN FINAL PACKING TUBE CYLINDER 8703

DESIGNERS REF.

PART NO. BMCS-M91-FPT-10

D.S. CAT NO.

AHSP

BASED ON DENEL TOT DRG. NO. 05730-101001-202

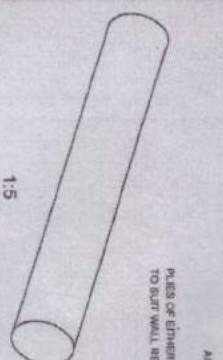
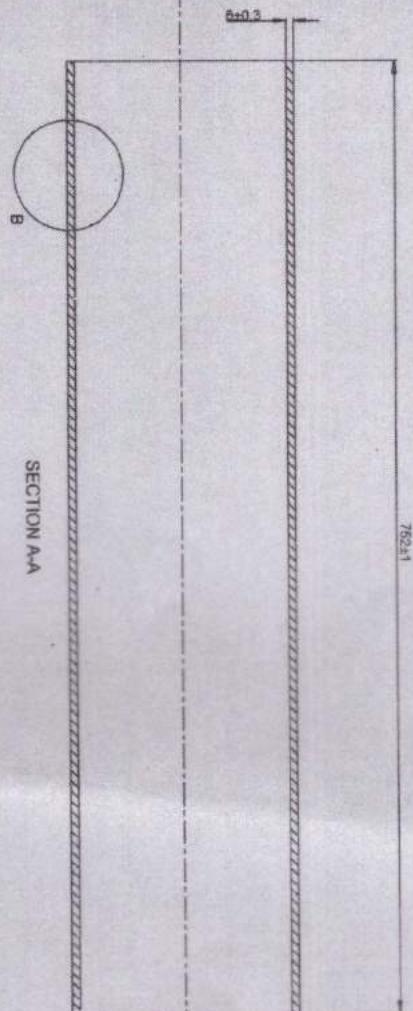
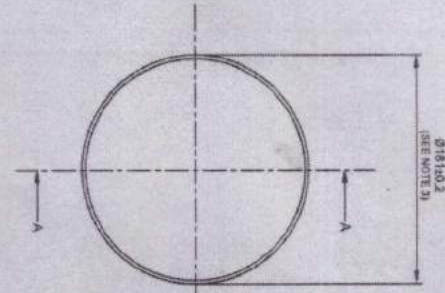
8 7 6 5 4 3 2 1

DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS

21-143-20M-18M-SQMB ON LTRVD DIMENSIONS ARE IN MM.

DRG. PROPERTIES

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- NOTES
1. MATERIAL
 - 1.1 ASPHALT IMPREGNATED RAFT TO SPECIFICATION MIL-P-22018 AND POLY RAFT 150 MICRON (150 g/m² BMD LINER / 25 g/m² P.E.)
 - 1.2 ALUMINUM STRIP TO BS 311C TYP 301
 - 1.3 ONE LAYER OF ASPHALT IMPREGNATED RAFT AND ONE LAYER OF POLY RAFT
 - 1.3.1 FOR ASPHALT IMPREGNATED RAFT USED ADHESIVE CONTACT (GENREM AKV 6136)
 - 1.3.2 FOR POLY RAFT USED ADHESIVE CONTACT (GENREM AKV 6136)
 - 1.3.3 ADHESIVE TO BE EVENLY SPREAD BETWEEN LAYERS
 2. CONTAINER FINISH TO BE SPECIFIED ON ORDER
 3. DIMENSION MARKED THIS Ø TO FIT OVER INNER TUBE GRD.NO. SWCR-MW-492-FPT-11

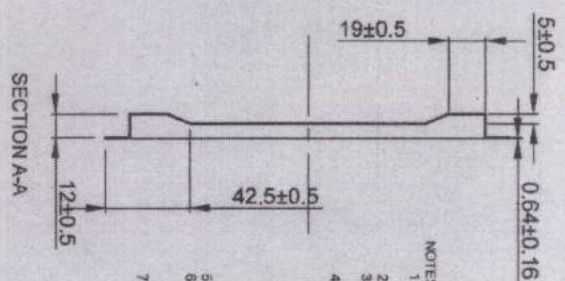
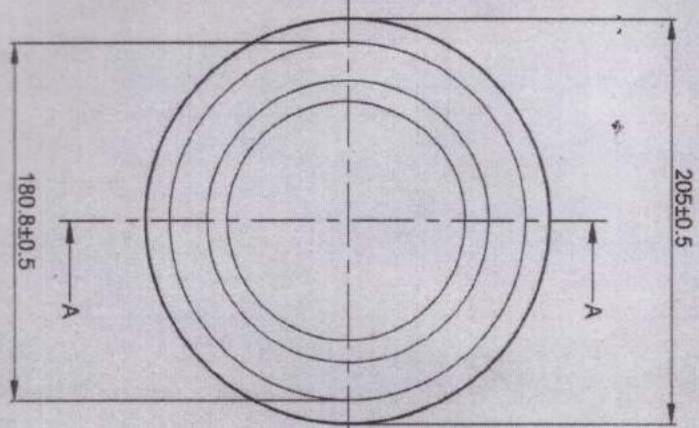
REV.	DATE	AUTHORITY	REVISION	ZONE	APP.	Q.D.	M.T.L.	PROTECTIVE FINISH	SCALE	KEY MARKS	DESIGNERS REF.
1	21.04.2002		DRG. MADE INTO COQA/1 FORMAT & NOTES ADDED						1:1		
DRG. SEALED											

OUTER TUBE (BODY) OF CYLINDER 8703

BASED ON DENEL TOT DRG. NO. 06-8-140-03765-02003-203

DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS
 DIMENSIONS ARE IN MM.

OWN PROPERTY.
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- NOTES
1. MATERIAL : TIN PLATE TO ISCOR NORM S.P.E. 159.
THICKNESS 0.47MM (NOMINAL) TIN COATING TYPE E1
 2. FINISHING PROCESS STONE OR COARSELY BRIGHT TEMPER T4 (TS2.5 TO TS5.5)
 3. EXTERNAL DECORATION : LIGHT STONE (MAY FINISH) TO BS 387C. TINT 361 WITH SPECULAR GLOSS AT 60° OF VIEW. MAXIMUM TO 5885 REF. METHOD 154.
 4. DECORATION TO CONSIST OF THE FOLLOWING
 - 4.1 INTERNAL : # SIZE MB 44
LACUER MB7
VARNISH MB 32
LIGHT STONE
VARNISH MB 32
VARNISH MB 32 WITH MATTING AGENT
 5. SEQUENCE OF COATING ON METAL END AS SET OUT IN NOTE 4
 6. METHOD OF APPLICATION OF DECORATION
 7. ALL MB 44 SIZE VARNISHES AND LACQUERS (IF REQUIRED) : ROLLER COATED.
 8. LIGHT STONE LITHO PRINTED.
 7. METAL THICKNESS INCLUDES DECORATION.

REV.	DATE	AUTHORITY	REVISION
1	21/04/2022		DRG. MADE INTO COAMA FORMAT & NOTES ADDED

DRG. SEALED ✓

DATE	BY	CHKD.	APPD.	ZONE	NO.	REV.	DATE	BY	CHKD.	APPD.	ZONE	NO.	REV.	DATE	BY	CHKD.	APPD.	

NO.	DATE	BY	CHKD.	APPD.	ZONE	NO.	REV.	DATE	BY	CHKD.	APPD.	ZONE	NO.	REV.	DATE	BY	CHKD.	APPD.

METAL END OF CYLINDER 8703

BASED ON DENEL TOT DRG. NO. 06-8140X3396-01006-203

DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS DIMENSIONS ARE IN mm.								OFN PROPERTY <small>The information contains in this drawing is to be used for official purposes only and shall not be reproduced or transmitted in any form or by any means or disclosed to any third party without prior permission from OFN. This shall be returned to OFN when no longer contractually required.</small>	
NOTES: MATERIAL TO BE TESTED FOR COMPATIBILITY WITH THE PRODUCT WITH WHICH IT WILL BE APPLIED.									
R.NO. DATE 21.04.2022		AUTHORITY		DRG. MADE INTO COAMA FORMAT & NOTES ADDED		REVISION		ZONE	
DRG. SEALED -		AS-SP SCL		O.O. MTL.		PROTECTIVE FILM -		THEO. SCALE 1:1	
PART NO. BMCS-M91-M92-FT-14		DESIGNER'S REF.		ASSY. DRWG.		DATE		SCALE	
D.S. CAT. NO.		AH-SP		BASED ON DENEL TOT DRG. NO. 06-1320X2626-90041				DATE	

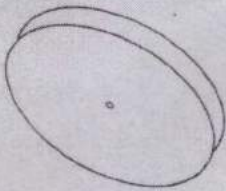
LINER CORRUGATED BOARD OF CYLINDER 8703

51-1-FPT-20W-16W-SCWB (ON LTR)D

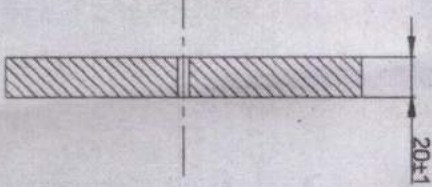
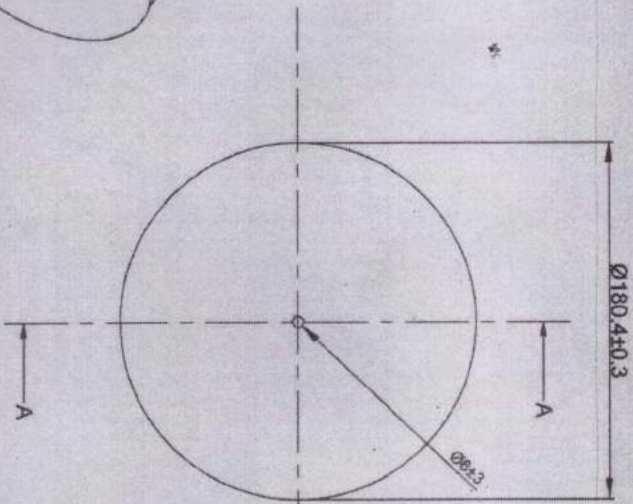
DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS
DIMENSIONS ARE IN mm.

OWN PROPERTY.

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1.5



SECTION A-A

NOTES:

1. REMOVAL ALL BURRS AND SHARP EDGES.
2. A MAXIMUM OF 1 x 30mm FLAT SURFACE ALLOWED ON CIRCUMFERENCE OF PROTECTING DISC.

DATE	21.04.2022	DRG. MADE INTO COADA FORMAT & NOTES ADDED	REVISION	ZONE	APP.:	DATE:	SCALE:	1:1	ASSY DRG.
AUTHORITY					FOR CHIAA	DATE:	SCALE:		
DRG. SEALED					PROTECTIVE FINISH				

PROTECTING DISC OF CYLINDER 8703

BASED ON DENEL TOT DRG. NO. 06-8140X03765-01004-203

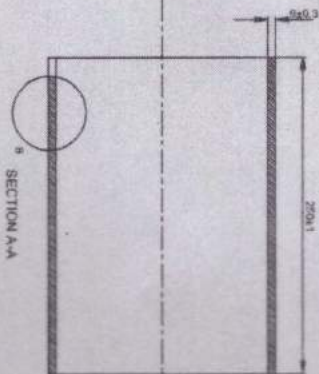
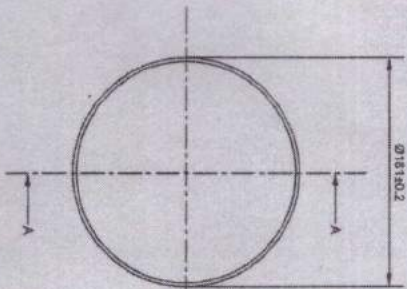
91-1443-20M-16M-SCMB ON LAYD

DIMENSIONS ARE IN mm.

DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS

DRG. PROPERTY:

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ASPHALT IMPREGNATED KRAFT PILES OF EITHER 230 OR 340g/m² KRAFT TO SUIT WALL REQUIREMENTS



DETAIL B
2:1

POLY KRAFT

0.1x25 ALUMINUM STRIP

NOTE:

- 1.1 ASPHALT IMPREGNATED KRAFT TO SPECIFICATION MIL-P-20893A AND POLY KRAFT 150 MICRON (150 g/m²) BAG LAYER (2mg/m² P.E.) COLOUR LIGHT STONE TO BS 381C TYP 351
- 1.2 ALUMINUM STRIP TO BS 1470 1672
- 1.3 ONE LAYER OF ASPHALT IMPREGNATED KRAFT AND ONE LAYER OF POLY KRAFT
- 1.3.1 FOR ASPHALT IMPREGNATED KRAFT USED ADHESIVE CONTACT-QJMT 165
- 1.3.2 FOR POLY KRAFT USED ADHESIVE CONTACT-QJMT 165
- 1.3.3 ADHESIVE TO BE EVENLY SPREAD BETWEEN LAYERS.
2. CONTAINER FINISH TO BE SPECIFIED ON ORDER.

DATE	21.04.2022	AUTHORITY	DRG. MADE INTO COM(A) FORMAT & NOTES ADDED	ZONE	APPROV.	CHKD.	SCALE	1:1	ASST. DRG.
RUNO		REVISION		APPR.	CHKD.	SCALE	1:1	ASST. DRG.	
DRG. SEALED				FOR COM	FOR COM	DATE			
				PROTECTIVE FINISH					

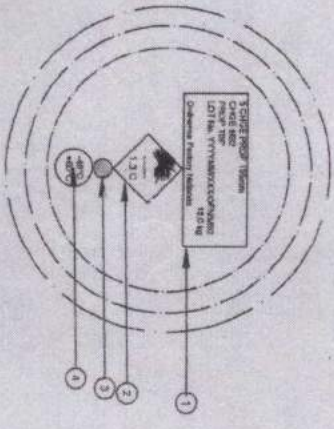
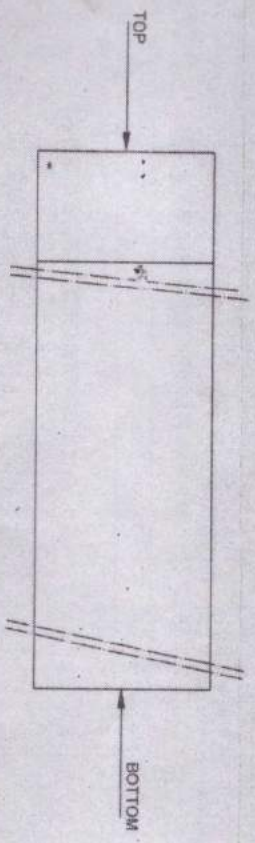
OUTER TUBE (LID) OF CYLINDER 8703

BASED ON DETAIL TOT DRG. NO. 04-41-140-03765-0-1003-203

PART NO. BMCS-M91-M92-PT-18
D.S. CAT NO.
AHSB

8 7 6 5 4 3 2 1
 DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS
 DIMENSIONS ARE IN mm.

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MARKING OF TOP AND BOTTOM VIEW

DATE	21.04.2022	AUTHORITY		REVISION		ZONE		AMP		CO.		VALT.		PROTECTIVE FIBRE	
RND															
DRG SEALED															
DRG. MADE INTO CO(A) FORMAT & NOTES ADDED															
DRG. NO.															
SCALE	1:1														
DATE															
DESIGNER'S REF.															
PART NO.	BMCS-M92-FPT-17														
D.S. CAT NO.															
AHSP															

PACKAGE MARKING OF 155mm BMCS M92 PACKED IN CYLINDER 8703

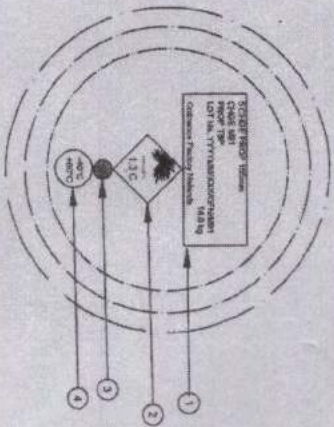
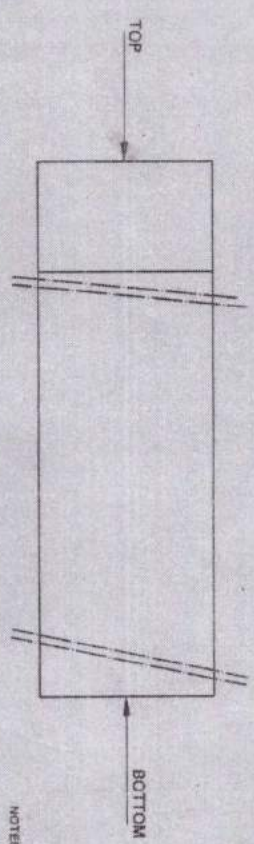
BASED ON DENEL TOT DRG. NO. 05730-992001-223

81-1471-BM-S-CMB ON LTRVD
 DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS
 DIMENSIONS ARE IN MM.

DRG. CONVENTIONS CONFORM TO IS SPECIFICATIONS
 DIMENSIONS ARE IN MM.

ORIG. PROPERTY

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MARKING OF TOP AND BOTTOM VIEW

NOTES:

- A. A TOLERANCE OF 10% IS PERMISSIBLE ON ALL CHARACTER SIZES, LABEL SIZES AND COLOUR TINTS, UNLESS OTHERWISE SPECIFIED.
- B. PRINTED LABELS (IF APPLICABLE) SHALL CONFORM TO SPECIFICATIONS KA 3063 AND KA3094.
- C. ALL MARKING SHALL BE SILK SCREENED/ LABELLED ON IN 7mm GOLDEN YELLOW CHARACTERS TO BS 381C-1980 THAT 249 ON SERVICE BROWN TO BS 381 C -1920, TINT 499 UNLESS OTHERWISE SPECIFIED.
- D. THE CYLINDER SHALL BE GEALED BY MEANS OF WHITE ADHESIVE TAPE.

DATE	21.04.2022	AUTHORITY	DRG. MADE INTO CAD/DWG FORMAT & NOTES ADDED	REVISION	SCALE	1:1	SCALE	1:1	ASSY. DRG.
DRG. SEALD.									
APPR.									
CHKD.									
DATE									
APPR.									
CHKD.									
DATE									

PACKAGE MARKING OF 155mm BMCS M91 LZ PACKED IN CYLINDER 8703

PART NO.	BMCS-M91-FPT-18
D.S. CMT NO.	
AHSP.	