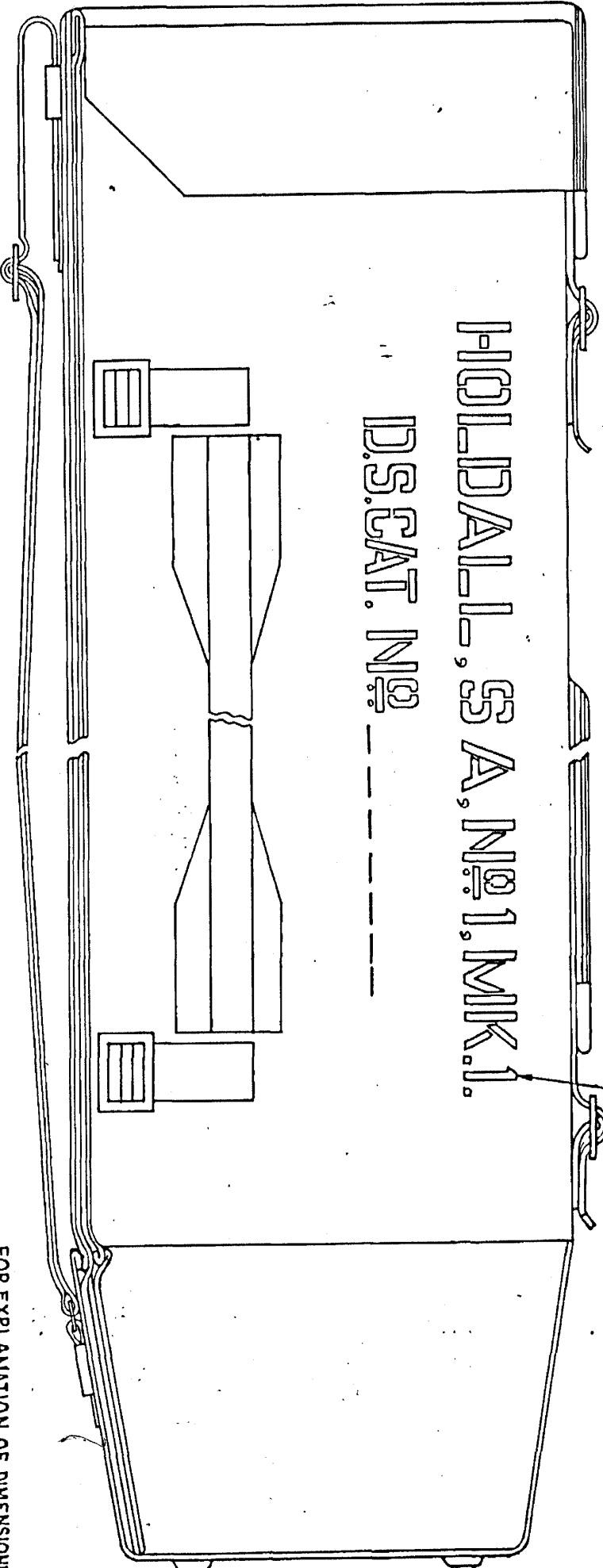


HOLDALL, SA, NO 1, MK 1.

D.S.CAT. NO. 1



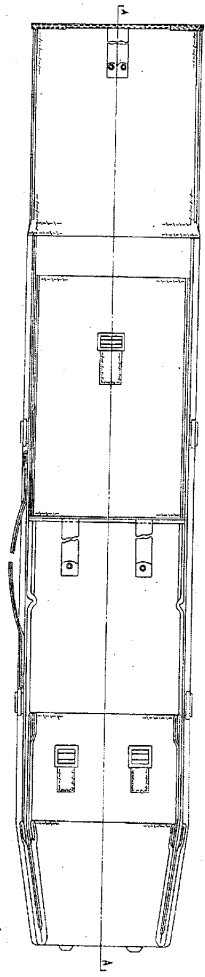
25 mm. LETTERING IN YELLOW TO BE STENCILED
(PAINT READY MIXED/HINKINS FOR PACKAGES &
PETROL CONTAINERS SEMI-GLOSSY FINISH (OLD
OR YELLOW GOLDEN (IS: 356 OF IS: 5-1951)
CONFORMING TO SPECN. IS: 138-1959 (AS APPLICABLE
TO DEFENCE USES))

FOR EXPLANATION OF DIMENSIONING
ETC. SEE ARDE NOTE SHEET NO. 1

आरेखण की सही प्रमाणिकता/माप
यतिनिधि प्रमाणिकता
Certified as correct copy
of drg. on 03.09.68

श्री. वी. के. शर्मा द्वारा
Jr. Works Manager
STANDARD CO.

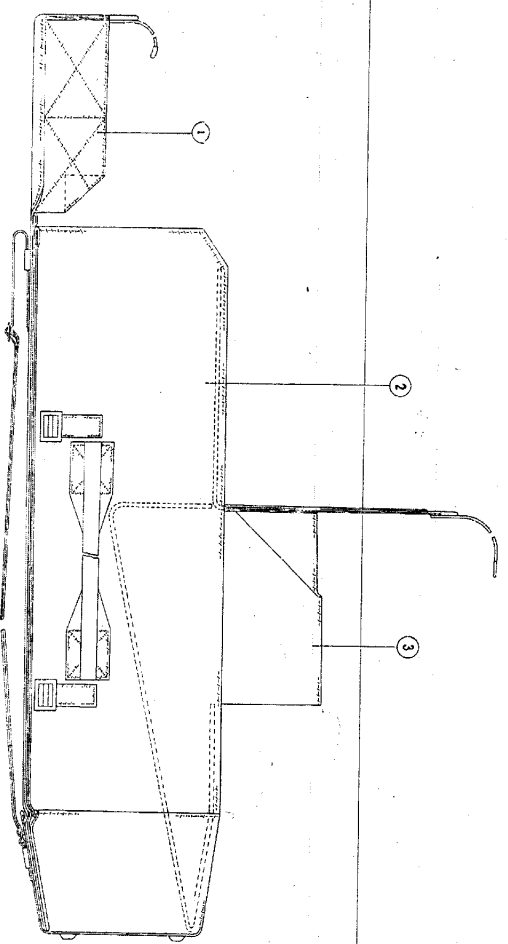
PROFORMA CONVERTED TO A3 SIZE NEGATIVE RE-TRACED AND DRAWING RE-SEALED	PREVIOUS D.C. NOS: 9884-5A 14864-SA & 15767-SA.	DATE	NAME	ASSY. 1	MATERIAL.	DIMENSIONS ARE IN MILLIMETRES.	METHOD OF MARKING:- HOLDALL, SA, NO 1, MK 1	APPROVED: DT: 15-12-68 NEG. RE-TRACED. DESIGNER'S REF. SHEET ARDE 1164-5A-1 D.S. CAT. NO. 1164-5A-1 1005-000718
SIGNATURE	SCALE: 1/1 C/D.O.	DGN.						
DRN.		OR.						
TRD.	24-94	COMB.	12-5-94					
SIG.	SEALED-D.C. NO. 9884-SA, DT: 16-3-68							



LIST OF PARTS			
ITEM	DESCRIPTION	QTY	UNIT
1	WINDOW	1	SQ. FT.
2	DOOR	1	SQ. FT.
3	WINDOW	1	SQ. FT.

TABLE OF CONTENTS	
1	GENERAL NOTES
2	SECTION A-A
3	SECTION B-B
4	SECTION C-C
5	SECTION D-D
6	SECTION E-E
7	SECTION F-F
8	SECTION G-G
9	SECTION H-H
10	SECTION I-I
11	SECTION J-J
12	SECTION K-K
13	SECTION L-L
14	SECTION M-M
15	SECTION N-N
16	SECTION O-O
17	SECTION P-P
18	SECTION Q-Q
19	SECTION R-R
20	SECTION S-S
21	SECTION T-T
22	SECTION U-U
23	SECTION V-V
24	SECTION W-W
25	SECTION X-X
26	SECTION Y-Y
27	SECTION Z-Z

NOTE: -
 1. ALL DIMENSIONS TO FACE UNLESS OTHERWISE SPECIFIED.
 2. ALL MATERIALS TO BE OF THE BEST QUALITY.
 3. ALL WORK TO BE DONE IN ACCORDANCE WITH THE LATEST EDITIONS OF THE BUILDING CODES.
 4. ALL WORK TO BE DONE IN ACCORDANCE WITH THE LATEST EDITIONS OF THE MECHANICAL AND ELECTRICAL CODES.
 5. FOR DETAILS OF MATERIALS, SEE DRAWING NO. 101 - COATING PLAN.



SECTION A-A

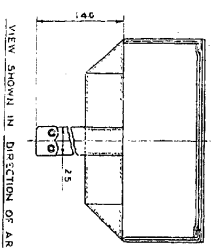
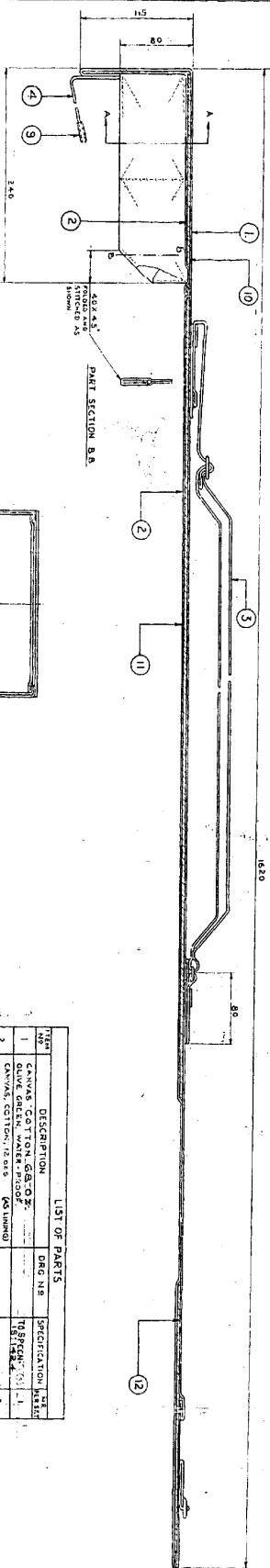
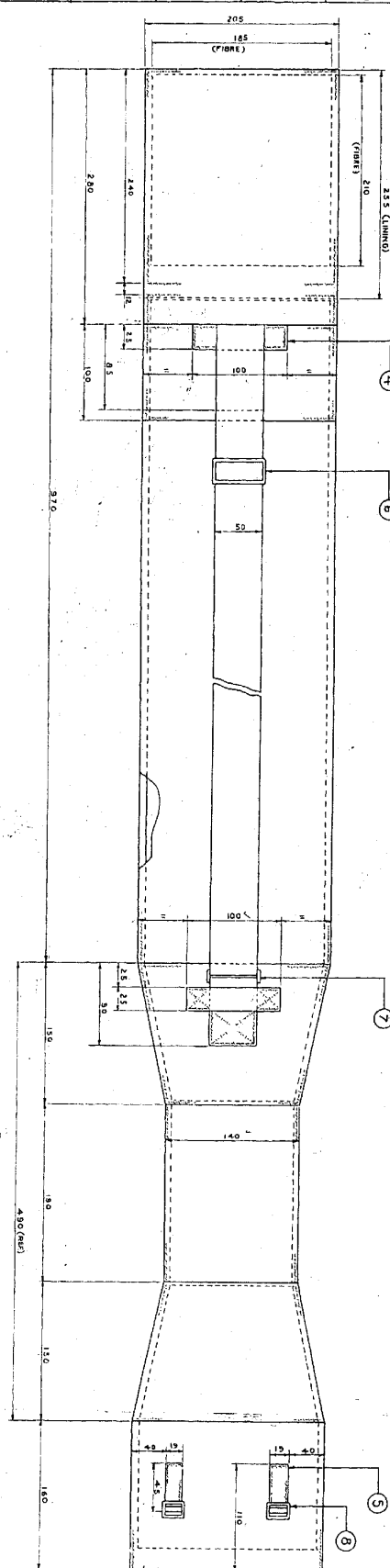
STANDARD
 Certified as correct copy
 of drawing No. 101
 of date 02/19/14

J.F. WORKS

REVISIONS	
NO.	DESCRIPTION
1	ISSUED FOR CONSTRUCTION
2	REVISION
3	REVISION
4	REVISION
5	REVISION
6	REVISION
7	REVISION
8	REVISION
9	REVISION
10	REVISION

HOLD BALL
 SA. NO. 101

SEALED -



LIST OF PARTS

ITEM NO.	DESCRIPTION	DRG. NO.	SPECIFICATION
1	CANVAS COTTON (G.S.O. 2)	10	100/100
2	CANVAS COTTON (G.S.O. 2)	10	100/100
3	WREN, OLIVE GREEN, THICK 2.00 (G.S. 2)	131	6-488
4	WREN, OLIVE GREEN, THICK 2.00 (G.S. 2)	131	6-488
5	WREN, OLIVE GREEN, THICK 2.00 (G.S. 2)	131	6-488
6	BUCKET, BRASS, QUICK RELEASE	482	431
7	BUCKET, BRASS, QUICK RELEASE	482	431
8	BUCKET, BRASS, QUICK RELEASE	482	431
9	TIP BRASS FOR WREN (G.S. 2)	131	6-488
10	SUPPORTER FIBRE 200/185/2 THICK	131	6-488
11	SUPPORTER I	482	431
12	SUPPORTER II	114	1

NOTE
 1) ALL DIMENSIONS ARE WITH SEWING COTTON.
 2) SPECIFICATION NO. 131-6-488.
 3) FOR ITEM NO. 10, 11 & 12, SIMILAR ALTERNATIVE MAY BE USED.

108/108
 Certified as correct copy
 of drg. no. B2(109)24

5. JEFFERY 7777
 J.R. WORKS MANAGER
 4781 1000

BOTTOM PIECE

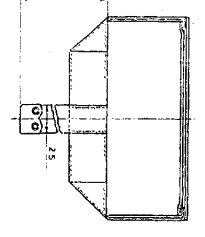
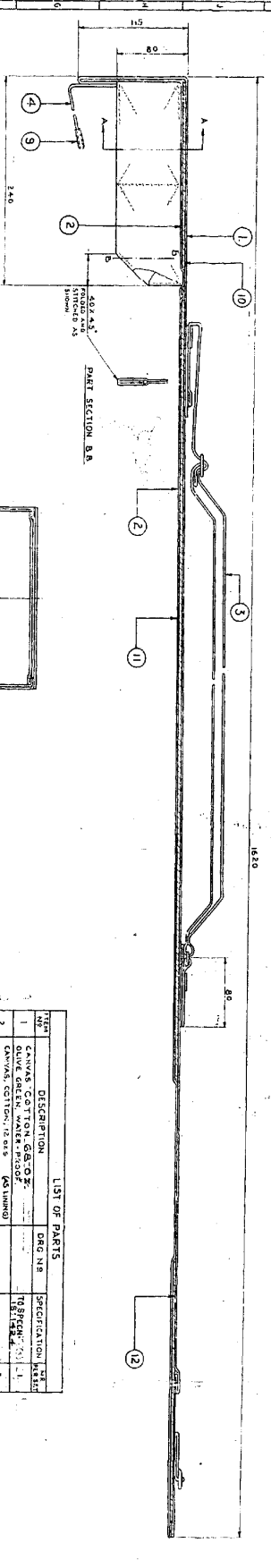
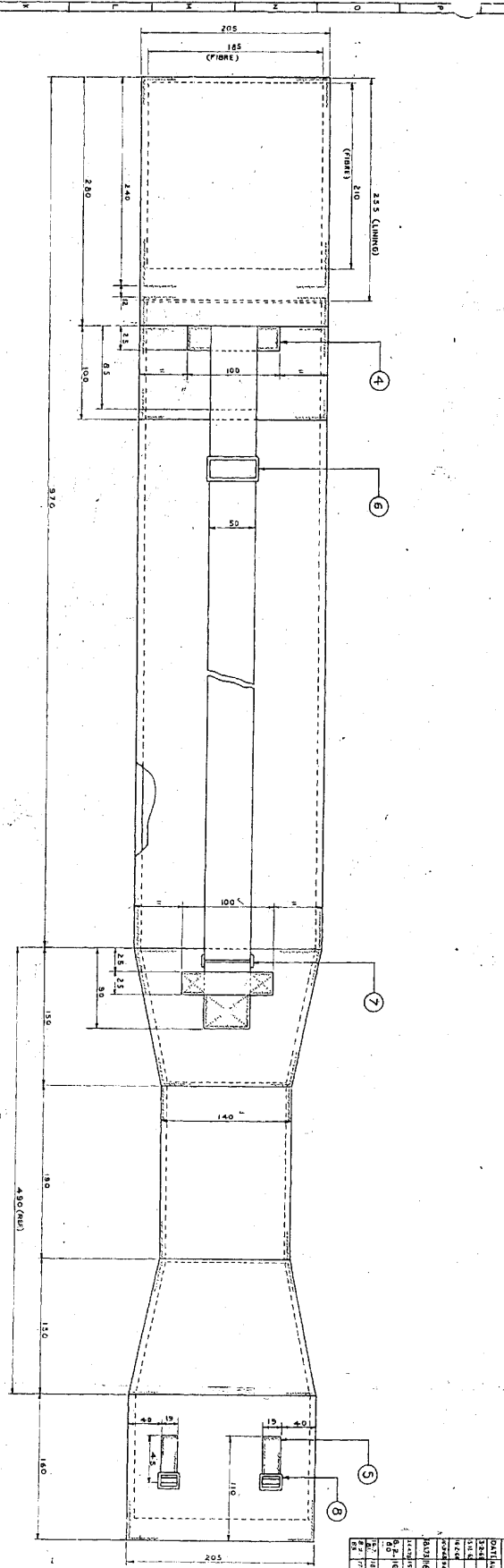
Create PDF files without this message by purchasing novaPDF printer (<http://www.novapdf.com>)

AMENDMENTS

NO.	DATE	DESCRIPTION
1		
2		
3		
4		
5		
6		
7		
8		
9		
10		
11		
12		

NO.	DATE	DESCRIPTION
1		
2		
3		
4		
5		
6		
7		
8		
9		
10		
11		
12		

APPROVED
 ARDE 1164
 AR. D. E. KIRKEE



ITEM NO.	DESCRIPTION	DWG. NO.	SPECIFICATION
1	CANVAS COTTON (8.5 O.Z.)	105	105
2	CANVAS COTTON (2 O.Z.)	105	105
3	WEN. OLIVE GREEN (THICK 2.16 (52) mm)	105	105
4	WEN. OLIVE GREEN (THICK 2.16 (52) mm)	105	105
5	WEN. OLIVE GREEN (THICK 2.16 (52) mm)	105	105
6	BUCKET. BRASS. QUICK RELEASE	105	105
7	BUCKET. BRASS. QUICK RELEASE	105	105
8	BUCKET. BRASS. QUICK RELEASE	105	105
9	TIP BRASS FOR WED. TIN (45 mm)	105	105
10	SUPPNER. FIBRE 200/16512 THICK.	105	105
11	STIFFENER - I	440E (144/2)	105
12	STIFFENER - II	1144/5	105

NOTE
 a) ALL DIMENSIONS ARE WITH SEWING COTTON.
 b) TO SPECIFICATION WE USE.
 c) TO SPECIFICATION WE USE.
 d) FOR ITEM NO. 10, 11 & 12. SAMPLE ALTERNATIVE MAY BE USED

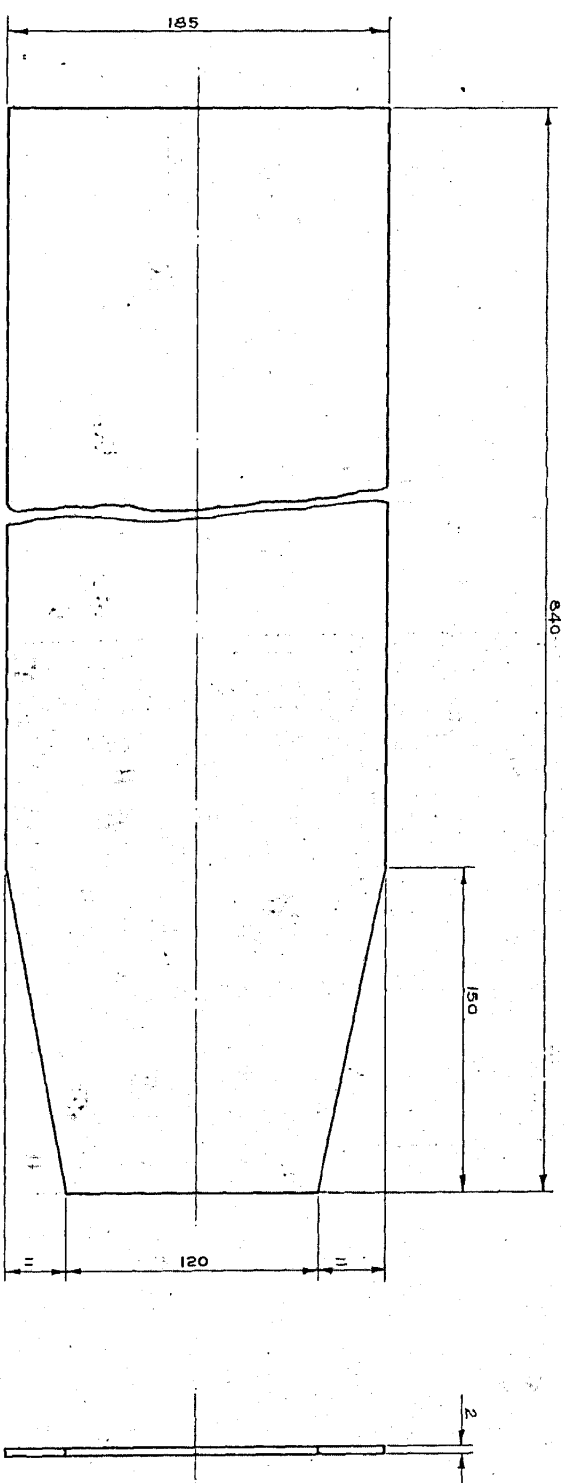
REVISIONS
 APPROVED BY: [Signature]
 APPROVED BY: [Signature]
 Certified as correct copy of drg. no. 03/09/24

5. [Signature]
 M. WORKS
 STANBARD

BOTTOM PIECE

DESIGNED BY: [Signature]	CHECKED BY: [Signature]
SCALE: 1:1	MATERIAL: AS ABOVE
DATE: 03/09/24	APPROVED BY: [Signature]
DRG. NO. 1	APPROVED BY: [Signature]
ARDE 1164	APPROVED BY: [Signature]

FOR EXPLANATION OF DIMENSIONING ETC., SEE ARDE NOTE SHEET N-1.
THIRD ANGLE PROJECTION. DIMENSIONS ARE IN MILLIMETRES.



MATERIAL:-
FLAT SHEET (PULVERIZED RD) 2.7mm
THICK (AS PER 0005) TO SPECS
NO. IND/GS/1475 OR SUITABLE EQUIVALENT

Handwritten signature

Handwritten date: 23/09/12

PROTECTIVE FINISH :-

MATERIAL :- AS STATED.

ESTIMATED WEIGHT :-
SCALE :- 1:2

INSP. INSTRS.
DRAWN BY: [Signature]
R. SINGH
CHIEF D/WN
APPROVED BY: [Signature]
DATE: 27-1-65
DETAIL NO. 2
PART NO.

ARDE 1164

A. R. D. E. KIRKEE

**STIFFENER-I
FOR
BOTTOM PIECE**

MATERIAL AMENDED.

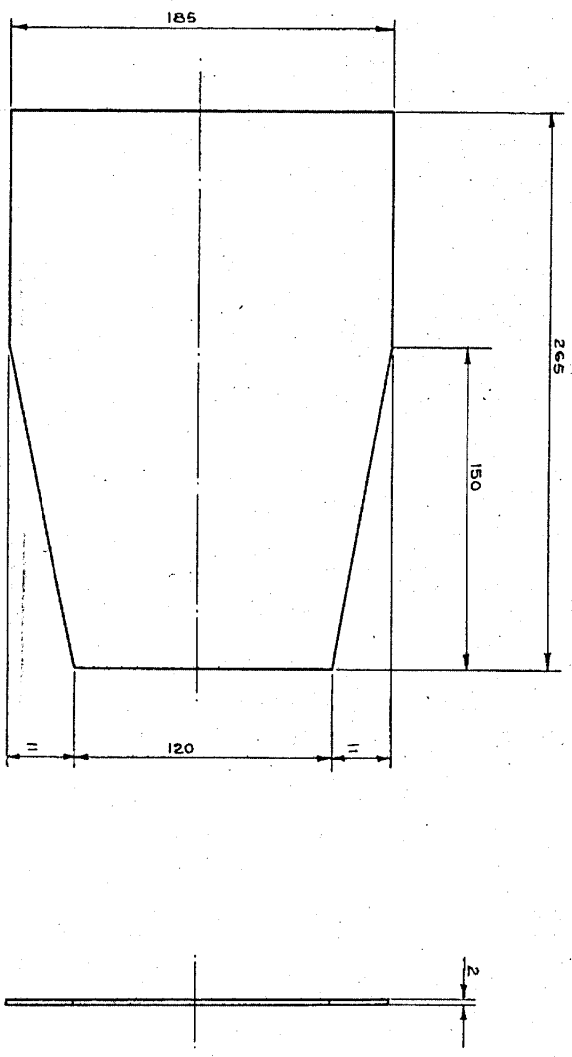
DRAWING SEALED

TRACED WITHOUT CHANGE
NATURE

AMENDMENTS.

PART No. 1 2 3 4 5 6 7 8 9 10

FOR EXPLANATION OF DIMENSIONING ETC. SEE ARDE NOTE SHEET NS. I.
THIRD ANGLE PROJECTION. DIMENSIONS ARE IN MILLIMETRES.



03/09/11
M=3/11/09

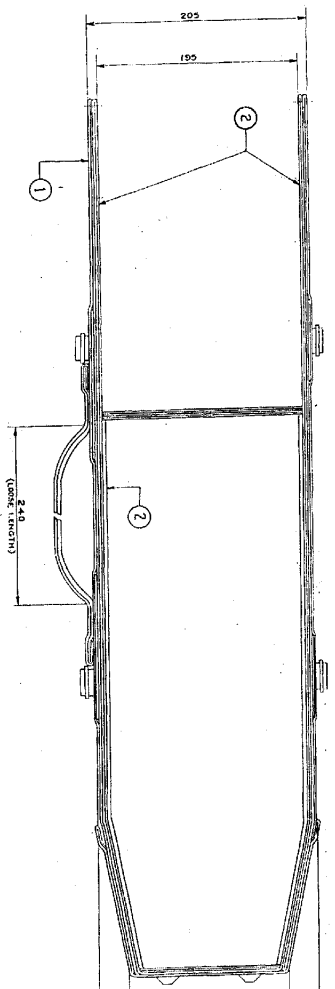
MATERIAL :-
FIBRE SHEET (VULCANISED RED) 2 mm
THICK (19/JHT-0005) TO SPECN
NO. IND/65/473 OR SUITABLE EQUIVALENT

1873/16/13-54	MATERIAL AMENDED
4366/9884-50	DRAWING SERIALIZED
32-65	TRACED WITHOUT CHANGE
DATE OF APPROVAL	NATURE
AMENDMENTS:	

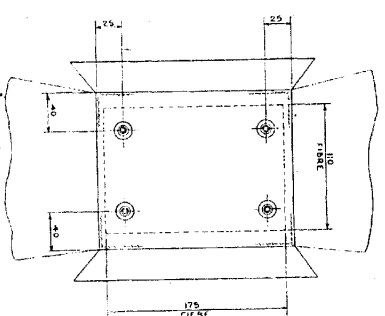
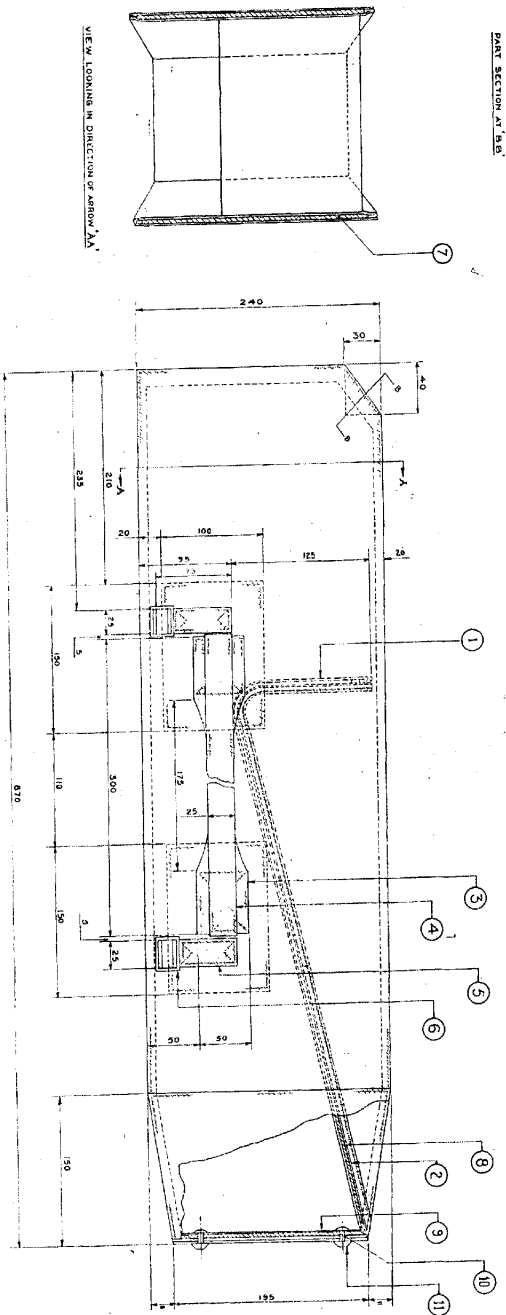
PROTECTIVE FINISH :-	MATERIAL :- AS STATED
EQUIVALENT	ESTIMATED WEIGHT :-
SCALE :- 1:2	ASST. DRG. ARDE 1164/1
INSR. INSTRS.	DRAWN
CHECKED	TRACED
R. SINGH	B. PULAY
CHEF D/MAN	GROUP OFFICER
APPROVED	FOR DIRECTOR
DATE :- 27-11-65	
ARDE 1164	
DETAIL NO. 3	
PART NO.	
A. R. D. E. KIRKEE	

STIFFENER-II
FOR
BOTTOM PIECE

REV.	DATE	DESCRIPTION
1	10/10/11	ISSUED FOR PRODUCTION
2	10/10/11	ISSUED FOR PRODUCTION
3	10/10/11	ISSUED FOR PRODUCTION
4	10/10/11	ISSUED FOR PRODUCTION
5	10/10/11	ISSUED FOR PRODUCTION
6	10/10/11	ISSUED FOR PRODUCTION
7	10/10/11	ISSUED FOR PRODUCTION
8	10/10/11	ISSUED FOR PRODUCTION
9	10/10/11	ISSUED FOR PRODUCTION
10	10/10/11	ISSUED FOR PRODUCTION
11	10/10/11	ISSUED FOR PRODUCTION
12	10/10/11	ISSUED FOR PRODUCTION
13	10/10/11	ISSUED FOR PRODUCTION
14	10/10/11	ISSUED FOR PRODUCTION
15	10/10/11	ISSUED FOR PRODUCTION
16	10/10/11	ISSUED FOR PRODUCTION
17	10/10/11	ISSUED FOR PRODUCTION
18	10/10/11	ISSUED FOR PRODUCTION
19	10/10/11	ISSUED FOR PRODUCTION
20	10/10/11	ISSUED FOR PRODUCTION



ITEM	DESCRIPTION	QTY	UNIT	REMARKS
1	CANVAS (SPECIAL) (AS LINED)	1	PC	
2	CANVAS (SPECIAL) (AS LINED)	2	PC	
3	WEB OLIVE GREEN THICK	1	PC	
4	WEB OLIVE GREEN THICK	1	PC	
5	ROCKE, GRAYS, QUICK RELEASE	4	PCS	
6	STIFFENER PARTITION	1	PC	
7	STIFFENER PARTITION	1	PC	
8	RIVET, TUBULAR	1	PC	
9	RIVET, TUBULAR	1	PC	
10	CUP, RIVET	4	PCS	



VIEW LOOKING IN DIRECTION OF ARROW 'A'

FRONT SECTION AT 'B-B'

आदेश को सही आदेश देसिये
 वरिष्ठता प्राप्त...
 Certificate of Correct COPY
 of drg. O: 03/09/11
 Sr. Works

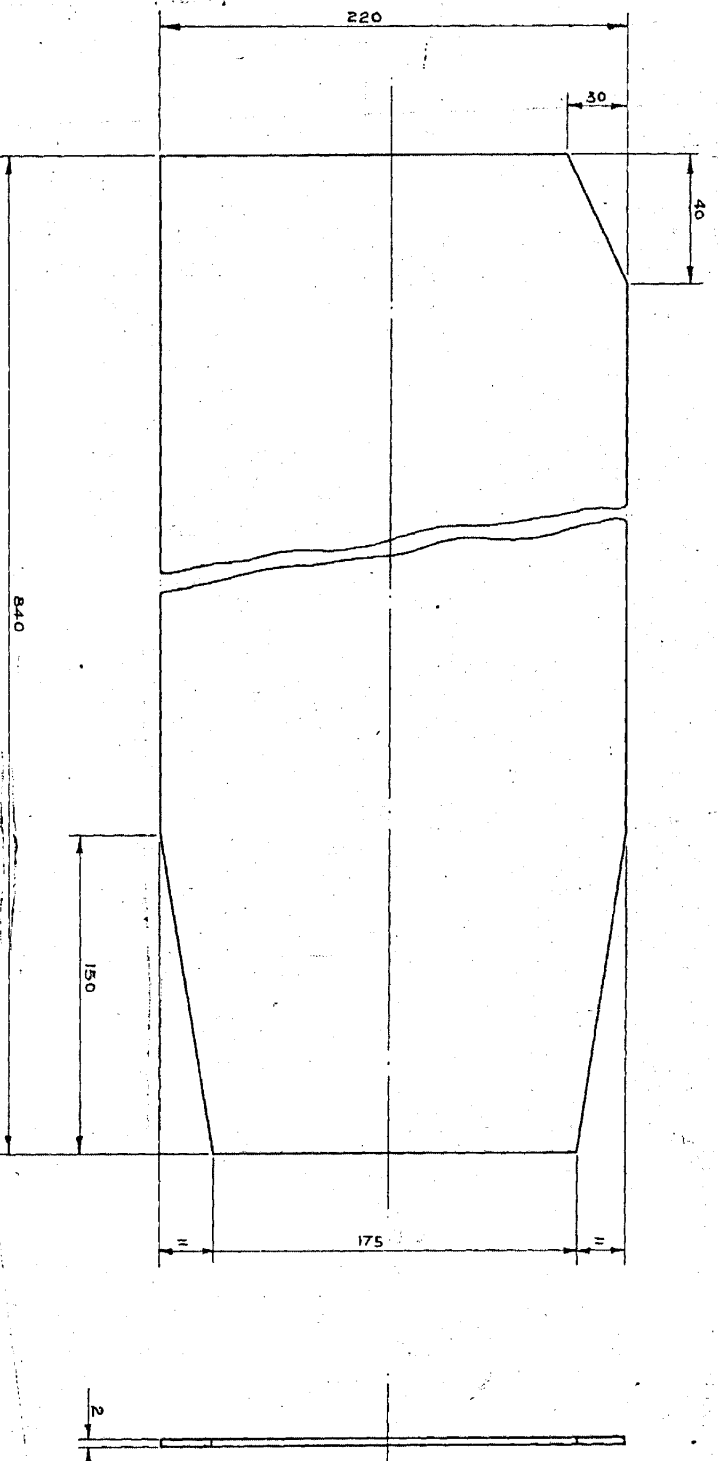
SIDE PIECE

DESIGNER	DATE	SCALE
DRIVER	DATE	SCALE
CHECKED	DATE	SCALE
APPROVED	DATE	SCALE

ARDE 1164

PART No.

FOR EXPLANATION OF DIMENSIONING ETC. SEE ARDE NOTE SHEET N&I.
THIRD ANGLE PROJECTION. DIMENSIONS ARE IN MILLIMETRES.



PROTECTIVE FINISH :-

MATERIAL:- FIBRE OR SUITABLE
EQUIVALENT.
ESTIMATED WEIGHT :-
SCALE:- 1:2

ASSY. DRG. ARDE 1164/4.

INSR. INSTRS.	CHECKED	TRACED	TNN. SLD.
DRAWN	R. SINGH	D. PILLAY	
CHIEF DRAWN		GROUP OFFICER	

APPROVED:

DATE:- 27-1-65

ARDE 1164

DETAIL. NO. S.

PART NO.

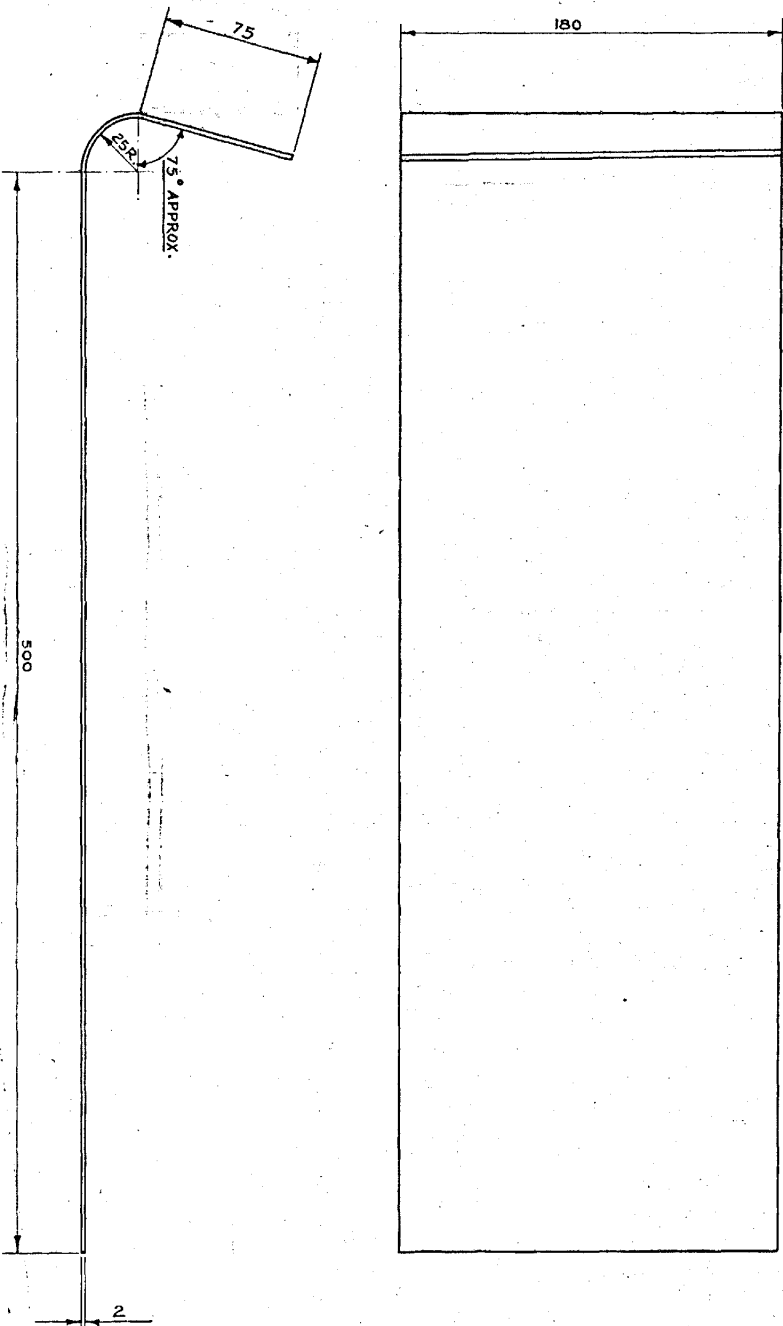
A. R. D. E. INRSEE.

STIFFENER
FOR
SIDE PIECE

4318 9824-SH
32-55
DRAWING STARTED
TRACED WITHOUT CHANGE.
NATURE
AMENDMENTS.

PART No.

FOR EXPLANATION OF DIMENSIONING ETC., SEE ARDE NOTE SHEET NR 1.
THIRD ANGLE PROJECTION. DIMENSIONS ARE IN MILLIMETRES.



PROTECTIVE FINISH :-

MATERIAL :- FIBRE OR SUITABLE

EQUIVALENT.

ESTIMATED WEIGHT :-

SCALE :- 1:2

INSP. INSTRS.

DRAWN

R-SINGH

CHIEF DRYAN

APPROVED

DATE :- 27.1.65

DETAIL NO. G.

PART NO.

A. R. D. E. KIRKEE.

ASSY. DRG. ARDE 1164/4.

CHECKED

D. PULLAY

GRSUP OFFICER

TRACED

TRN. JLD.

FOR DIRECTOR

ARDE 1164.

STIFFENER PARTITION

1032819884-54

5 165

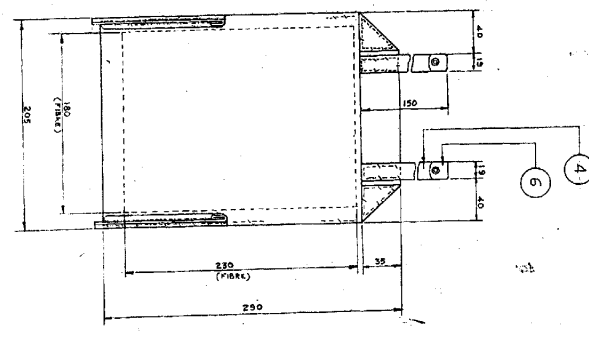
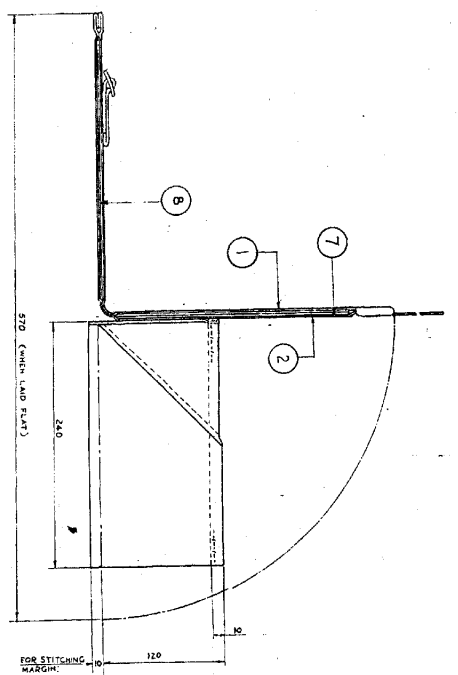
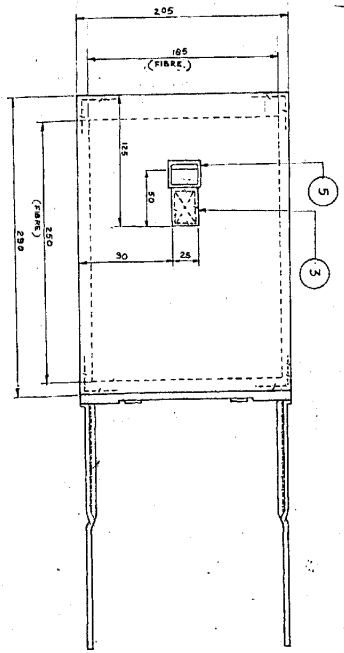
TRACED WITHOUT CHANGE.

NATURE

AMENDMENTS.

FOR EXPLANATION OF DIMENSIONS ETC. SEE ARDE NOTE SHEET NO. 1
 THIS SHEET PRODUCTION DIMENSIONS ARE IN MILLIMETERS

REV.	DATE	DESCRIPTION
1	1955-10-15	ISSUED FOR PRODUCTION
2	1955-10-15	ISSUED FOR PRODUCTION
3	1955-10-15	ISSUED FOR PRODUCTION
4	1955-10-15	ISSUED FOR PRODUCTION
5	1955-10-15	ISSUED FOR PRODUCTION
6	1955-10-15	ISSUED FOR PRODUCTION
7	1955-10-15	ISSUED FOR PRODUCTION
8	1955-10-15	ISSUED FOR PRODUCTION
9	1955-10-15	ISSUED FOR PRODUCTION
10	1955-10-15	ISSUED FOR PRODUCTION
11	1955-10-15	ISSUED FOR PRODUCTION
12	1955-10-15	ISSUED FOR PRODUCTION
13	1955-10-15	ISSUED FOR PRODUCTION
14	1955-10-15	ISSUED FOR PRODUCTION
15	1955-10-15	ISSUED FOR PRODUCTION
16	1955-10-15	ISSUED FOR PRODUCTION
17	1955-10-15	ISSUED FOR PRODUCTION
18	1955-10-15	ISSUED FOR PRODUCTION
19	1955-10-15	ISSUED FOR PRODUCTION
20	1955-10-15	ISSUED FOR PRODUCTION



ITEM NO.	DESCRIPTION	SPECIFICATION IN CHG. NO.	QTY.
1	CANVAS COTTON FAB - SOLUBLE GREEN WATER PROOF	TO SPECIFICATION IS: 14-24	1
2	CANVAS COTTON FAB - GREEN (AS SUPPLIED) WATER PROOF	TO SPECIFICATION IS: 14-24	1
3	WAS. CLOVE GREEN - 1/2" THICK	TO SPECIFICATION IS: 14-24	1
4	WAS. CLOVE GREEN - 1/2" THICK	TO SPECIFICATION IS: 14-24	2
5	BUCKET, STAIN, QUICK RELEASE	NO. 10/100000	1
6	ZIP BASKET FOR 2 (E.S.M.) STRAP	" "	2
7	STIFFENER FIBRE	" "	1
8	STIFFENER FIBRE	" "	1

NOTES -
 1) ALL DIMENSIONS BE WITH SEWING CANTON TO SPEC. IN CHG. NO. 11220 5/25/56
 2) IS SUPPLEMENTARY WORK TO APPROVED DRAWING
 3) ALL SEWING SHOULD BE WITH SEWING CANTON
 4) FOR BULKING 2" & 3" SUITABLE ALTERNATIVE MAY BE USED.

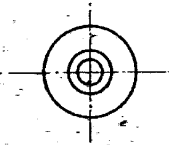
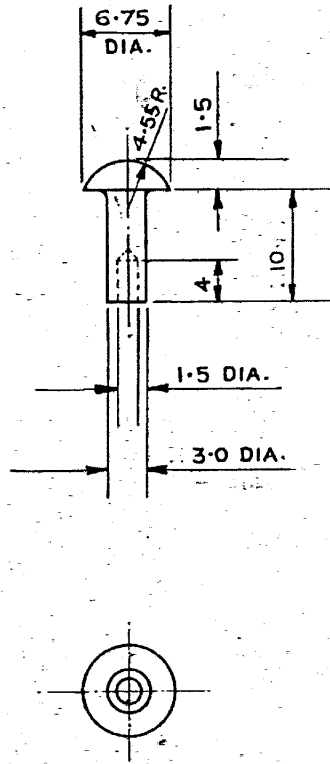
Handwritten: Haslam
 23/10/56
 son

TOP PIECE

APPROVED BY: ARDE 1164	DATE: 21.10.56
CHECKED BY: [Signature]	DATE: [Signature]
DESIGNED BY: [Signature]	DATE: [Signature]
DRAWN BY: [Signature]	DATE: [Signature]
SCALE: 1:1	

PART No.

FOR EXPLANATION OF DIMENSIONING ETC. SEE ARDE NOTE SHEET No. 1.
THIRD ANGLE PROJECTION. DIMENSIONS ARE IN MILLIMETRES.

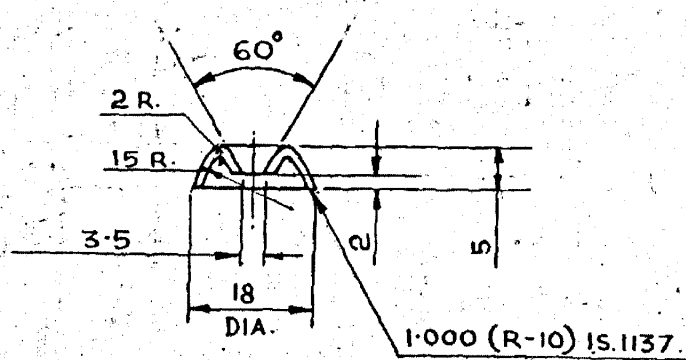
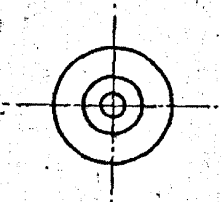


Handwritten notes and signatures in a box, including 'HOS/MAN', 'Cert. of dir.', and a signature 'San'.

NOTE :-

ALTERNATIVELY MAY BE OBTAINED FROM TRADE IF AVAILABLE.

					ASSY. DRC. ARDE 1164/4.	
					INSP. INSTRS.	
					DRAWN	CHECKED
					R. SINGH	Ch
					CHIEF DWMAN	GROUP OFFICER
					Ch	Ch
					APPROVED.	
					DATE = 27-1-65	
					ARDE 1164	
					DETAIL No. 7	
					PART No.	
					A. R. D. E. KIRKEE.	
16-3-68	9884-SR		DRAWING SEALED	055		
3-2-65			TRACED WITHOUT CHANGE.			
DATE	AUTHORITY	ZONE	NATURE	SIG.		
AMENDMENTS.						
SEALED :-						
MATERIAL :- COPPER STA 7 - C10.						
PROTECTIVE FINISH :-						
ESTIMATED WEIGHT :-						
SCALE :- 2:1						
RIVET, TUBLAR.						



NOTE:-
ALTERNATIVELY MAY BE OBTAINED
FROM TRADE IF AVAILABLE.

Handwritten notes and signatures, including the name "Kailash" and a date "03/09/65".

16-3-68	9884-59	DRAWING SEALED	
3-2-65		TRACED WITHOUT CHANGE.	
DATE	AUTHORITY (ZONE)	NATURE	SIC.
AMENDMENTS			
SEALED :-			
MATERIAL :- COPPER STA 7 - C10.			
PROTECTIVE FINISH :-			
ESTIMATED WEIGHT :-			
SCALE :- 1:1			

ASSY. DRC. ARDE 1164/4.

INSP. INSTRS.

DRAWN	CHECKED	TRACED	TRN. D.
R. SINGH	[Signature]	[Signature]	[Signature]

CHIEF D'MAN [Signature] GROUP OFFICER [Signature]

APPROVED [Signature]

DATE :- 27-1-65.

ARDE 1164

DETAIL No. 8

PART No.

Received from CI (Amm), Kirkce Telle NO. 7504078/ISA
 (P. 9542202000) dt. 05 Aug. 76.

AR DE NOTE SHEET No 1

Handwritten notes:
 03/09/76
 [Signature]

DCI NS 14793-W	INCH VALUE DELETED FROM PARA 10 2 AND 4		24-3-76
	CLOTH NEG. RETRACED	10%	
	PREV DCI 8187-W & 8509-W		
AMENDMENTS		SHEET NO	SIG DATE
CHIEF D'MAN	APPROVED		
	0387-W 15-2-62	NOTE SHEET SEALED	FOR CIA DIRECTOR

DIMENSIONS

- 1 ALL DIMENSIONS ARE IN MILLIMETERS UNLESS OTHERWISE STATED
- (a) WHERE A DIMENSION IS GIVEN A LIMIT OF HIGH AND/OR LOW SUCH LIMIT (S) OF SIZE MUST NOT BE EXCEEDED
- (b) A WORKING TOLERANCE INDICATED BY '+', 'OR' '-', 'OR' '±' SIGN SHOWS THE STANDARD OF WORKMANSHIP TO BE MAINTAINED AND IF DEPARTED FROM MAY INVOLVE REJECTION.
- (c) WHERE TOLERANCES ARE NOT SHOWN
- (i) DIMENSIONS IN WHOLE NUMBERS IMPLY A TOLERANCE OF ± 1 mm.
- (ii) DIMENSIONS IN DECIMALS IMPLY
- | | | |
|-------------------------|---|---------------|
| FOR EXTERNAL FEATURES | - | -0.2 mm. |
| FOR INTERNAL FEATURES | - | +0.2 mm. |
| FOR POSITIONAL FEATURES | - | ± 0.1 mm. |
- (d) UNLESS OTHERWISE STATED RADII AT CORNERS ARE PERMITTED A TOLERANCE OF $\pm 20\%$ OF THE RADIUS DIMENSION CHAMFERS ARE TO BE 45° AND ARE TO CONFORM TO THE REQUIREMENTS OF RADII STATED ABOVE.
- (e) UNTOLERANCED TAPERS ARE CONSTRUCTIONAL AND THE TOLERANCES ON SUCH TAPERS MUST BE DERIVED FROM THOSE ON THE ASSOCIATED LINEAR DIMENSION.
- (f) FOR ANGLES WHERE TOLERANCES ARE NOT SHOWN THE FOLLOWING TOLERANCES WILL IMPLY:-
- (i) ANGLES GIVEN IN DEGREES ± 30 MINUTES
- (ii) " " " " AND MINUTES ± 5 MINUTES
- (g) UNLESS OTHERWISE STATED, ALL SHARP EDGES ARE TO BE REMOVED, AND TO ALLOW FOR TOOL WEAR A RADIUS OR CHAMFER, NOT EXCEEDING 0.5 MILLIMETER WILL BE PERMITTED IN THE CORNER OF BLIND HOLS, RECESSES AND STEPS. ALL BURRS ARE TO BE REMOVED.

METHOD OF PROJECTION

- 2 THE DRAWINGS ARE PREPARED ON THE THIRD ANGLE PROJECTION METHOD IE THE VIEWS ARE PROJECTED ADJACENT TO THE FACE THEY REPRESENT

MACHINING AND TEMPERING

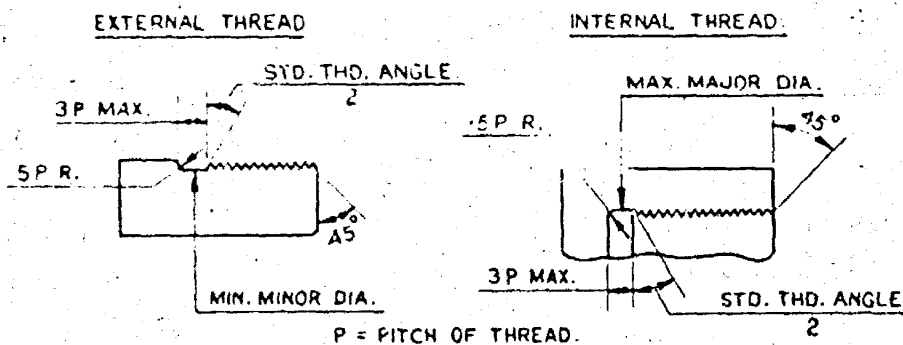
3. MACHINING AND TEMPERING FOR COMPONENTS IS INDICATED ON THE DRAWING.

FINISH

4. THE FINISH REQUIRED WILL BE INDICATED BY THE METHOD AND SYMBOLS GIVEN IN IS 696.

THREADS

5. (a) SCREW THREADS SHOULD BE TO SPECIFICATION IS 1362 MEDIUM CLASS UNLESS OTHERWISE STATED.
- (b) THE FRONT ENDS OF INTERNAL AND EXTERNAL 'V' THREADS ARE TO BE CHAMFERED AT AN ANGLE OF 45° APPROX. AND NOT EXCEEDING THE ROOT OF THE THREAD. (SEE SKETCH BELOW.)
- (c) RECESSING AT THE BACK OF SCREW THREADS IS *PERMITTED, WHEN INDICATED ON THE DRAWING. (SEE SKETCH BELOW.)

SCREW DRIVER SLOTS.

6. THE BOTTOM OF THE SCREW DRIVER SLOTS NEED NOT BE FLAT, PROVIDED THAT THE MINIMUM DEPTH OF SLOT IS TO THE DIMENSION GIVEN, THE COMPONENT IS NOT WEAKENED AND A SATISFACTORY SLOT RESULTS.

DIE CAST COMPONENTS AND MOULDINGS.

7. UNLESS OTHERWISE STATED, SURFACES MAY BE LEFT AS CAST OR MOULDED, WHEN 'DRAFT' IS INDICATED ON THE DRAWING, THE DRAWING DIMENSIONS WILL APPLY AT THE END OF THE FEATURE AT WHICH THEY ARE SHOWN. WHEN 'DRAFT' IS NOT INDICATED ON THE DRAWING, ANY DRAFT TAKEN MUST BE WITHIN THE DRAWING LIMITS.

DRILLED HOLES.

8. DRILLED HOLES ARE TO BE GRADE H 10 OF IS 919 UNLESS OTHERWISE STATED.

PRESSINGS, STAMPINGS AND CASTINGS.

9 WHERE BLANKS ARE MADE WITH SURPLUS METAL FOR SUBSEQUENT MACHINING, DIMENSIONS ARE NORMALLY LEFT TO THE CONTRACTOR'S DISCRETION.

PLASTIC MOULDINGS.

10 WHERE HOLES ARE CALLED FOR TO BE DRILLED THEY MUST NOT BE MORE THAN 1mm BELOW THE NOMINAL SIZE OF DRILL QUOTED.

PROTECTIVE COATING

11 UNLESS OTHERWISE STATED:-

- (a) WHEN PARTS ARE TO BE GIVEN A PROTECTIVE COATING, EXCEPT AS STATED IN (b) BELOW, THE DIMENSIONS ARE TO BE READ AS APPLYING BEFORE COATING.
- (b) FOR STEEL PARTS WHICH ARE TO BE PROTECTED BY A PHOSPHATE OR SIMILAR CHEMICAL PROCESS, THE DIMENSIONS ARE TO BE READ AS APPLYING AFTER COATING.

MARKING

- 12
- (a) ANY SPECIAL MARKING REQUIRED ON COMPONENTS IS CALLED FOR ON THE DRAWING AND/OR SPECIFICATION.
 - (b) PART/ DRAWING NUMBERS, CONTRACTOR'S INITIALS AND YEAR OF MANUFACTURE ARE ENGRAVED ON COMPONENTS WHERE PRACTICABLE.
 - (c) DIE CASTING AND PLASTIC MOULDINGS, WHEREVER PRACTICABLE, SHOULD BEAR THE MAKER'S APPROVED MONOGRAM AND AN IDENTIFICATION NUMBER OF THE DIE OR MOULD IMPRESSION FROM WHICH IT WAS CAST OR MOULDED.
 - (d) MARKINGS TO BE LOCATED IN A POSITION WHERE IT WILL NOT INTERFERE WITH FUNCTIONING OR GAUGING, AS INDICATED ON THE DRAWING OR AS APPROVED BY THE INSPECTING OFFICER.

WELDING

13 THE SCHEME OF SYMBOLS FOR WELDING AS GIVEN IN IS: 696 AND IS: 813 IS APPLICABLE.

WELDING CONTINUED

PREPARATION AND PROCESS OF WELDING.

UNLESS OTHERWISE STATED THE FOLLOWING PREPARATION AND PROCESS OF WELDING WILL BE FOLLOWED

- (a) WELDING TO BE DONE USING LOW HYDROGEN TYPE OF ELECTRODE CONTAINING CHROMIUM AND MOLYBDENUM "CHROMCORO" MANUFACTURED BY M/S ADVANI CERLIKON & CO., WILL BE SUITABLE
- (b) ALL PARTS TO BE JOINED SHOULD PROPERLY BE CHAMFERED AT THE JUNCTION TO BE WELDED
- (c) PRIOR TO WELDING THE COMPONENTS TO BE JOINED SHOULD BE PRE-HEATED TO ABOUT 200°C - 250°C.
- (d) AFTER WELDING A POST WELD STRESS RELIEVING SHOULD BE DONE AT ABOUT 600°C - 650°C
- (e) PRIOR TO WELDING THE ELECTRODES SHOULD PREFERABLY BE HEATED AT 300°C - 350°C FOR 1-2 HOURS FOR MOISTURE ELIMINATION

LIMITS AND FITS :-

- 14 LIMITS AND FITS ARE TO BE IN ACCORDANCE WITH IS: 919: 1959 UNLESS OTHERWISE INDICATED.