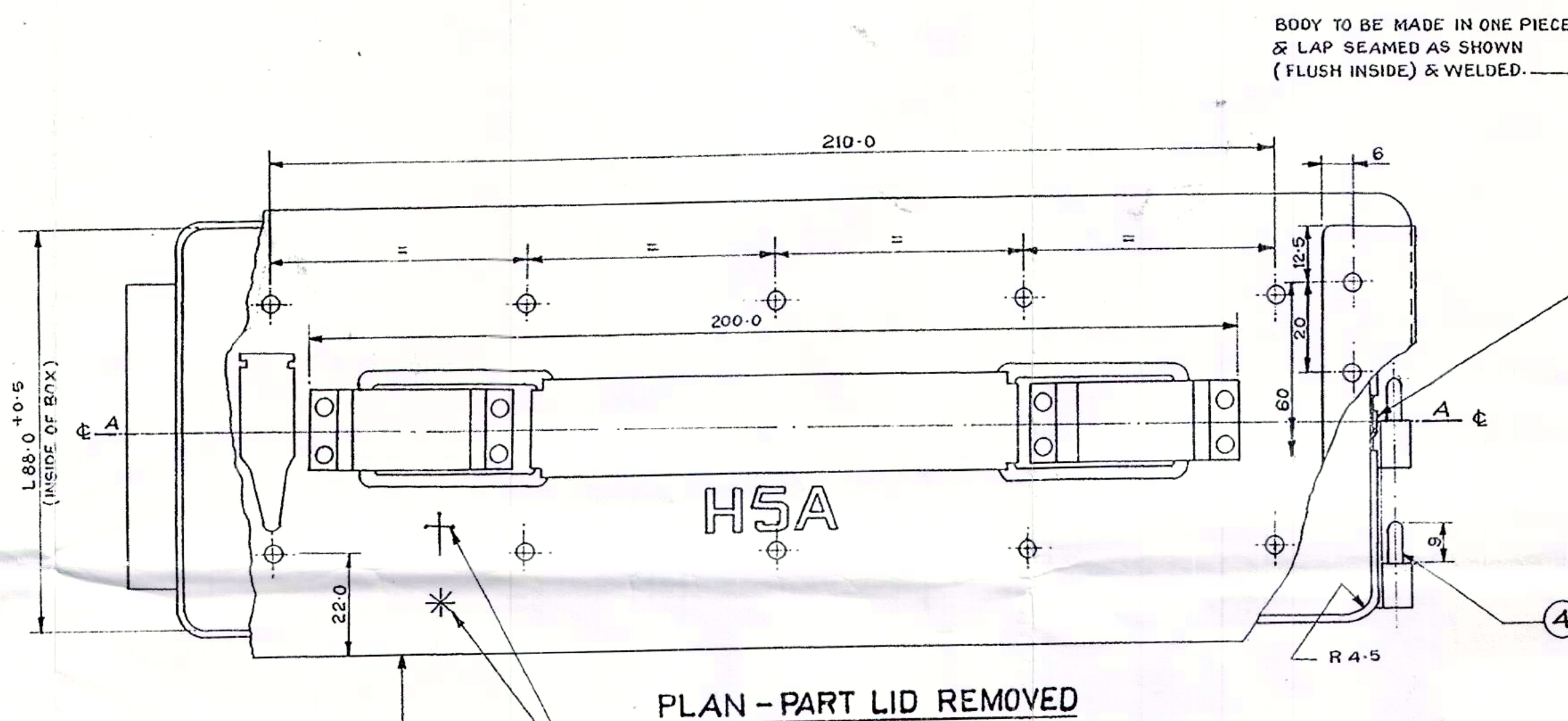


D.C. 34344-A.

TOLERANCE - MEDIUM IS:2102.

IMPORTANT:-

- a) ALL LIDS & BODIES MUST BE PRESSURE TESTED SEPARATELY BY AN INTERNAL AIR PRESSURE NOT LESS THAN 20·6 KPa & NOT EXCEEDING 34·3 KPa. THE TEST SHALL BE APPLIED FOR NOT LESS THAN 30 SECONDS DURING WHICH PERIOD NO LOSS OF PRESSURE SHALL BE INDICATED FOR THIS TEST LID WILL BE REPLACED BY A SIMILAR ONE FITTED WITH AN ADAPTER TO CONVEY AIR UNDER PRESSURE. THE LID WILL BE SEPARATELY TESTED UNDER SIMILAR PRESSURE WITH A MASTER BODY.
- b) BOXES WITH CORRECT LIDS MUST BE TESTED FOR LEAKAGE AFTER FINAL PAINTING & ASSEMBLY BY IMMERSION IN WATER HEATED TO 33·3-15K FOR A PERIOD NOT LESS THAN 90 SECONDS. LID BEING CLOSED & SECURED BY NORMAL METHOD.
- c) FOR OTHER TESTS THE RELEVANT SPECIFICATION SHOULD BE COMPILED WITH.



BODY TO BE MADE IN ONE PIECE
& LAP SEAMED AS SHOWN
(FLUSH INSIDE) & WELDED. —

NOTES :-

RUST PROOFING AND PAINTING:-

AFTER CLEANING AND INSPECTION THE BOX INCLUDING ALL STEEL FITTINGS WILL BE PHOSPHATED OR GALVANIZED OR ALUMINUM SPRAYED OR COATED WITH PAINT RFU PRIMING RED OXIDE, ZINC CHROME AMMUNITION AIR DRYING, OR STOVING OR BAKING IN A DRY PLACE FOR NOT LESS THAN SEVEN DAYS. FINISH BRUSHING /SPRAYING TO SPEC. JSS 1-63-05 FOLLOWED BY A FINISHING MAT COAT OF READY MIXED PAINT AIR DRYING BRUSHING /SPRAYING /DIPPING MAT) FINISH TO SPEC. IS: 168-1973 WITH AMENDMENT N°3 (REAFFIRMED IN 1988) (AS APPLICABLE FOR DEFENCE USE) SHADE OF PAINT WILL BE AS INDICATED IN THE SCHEDULE OF ORDER. THE PAINT MUST BE APPLIED EVENLY AND EACH COAT MUST BE THOROUGHLY DRIED BEFORE THE APPLICATION OF THE NEXT COAT

ALL JOINTS TO BE MADE AIR-TIGHT.

RADIUS AT CORNER'S 1.5 UNLESS OTHERWISE STATED.

MATERIAL:-

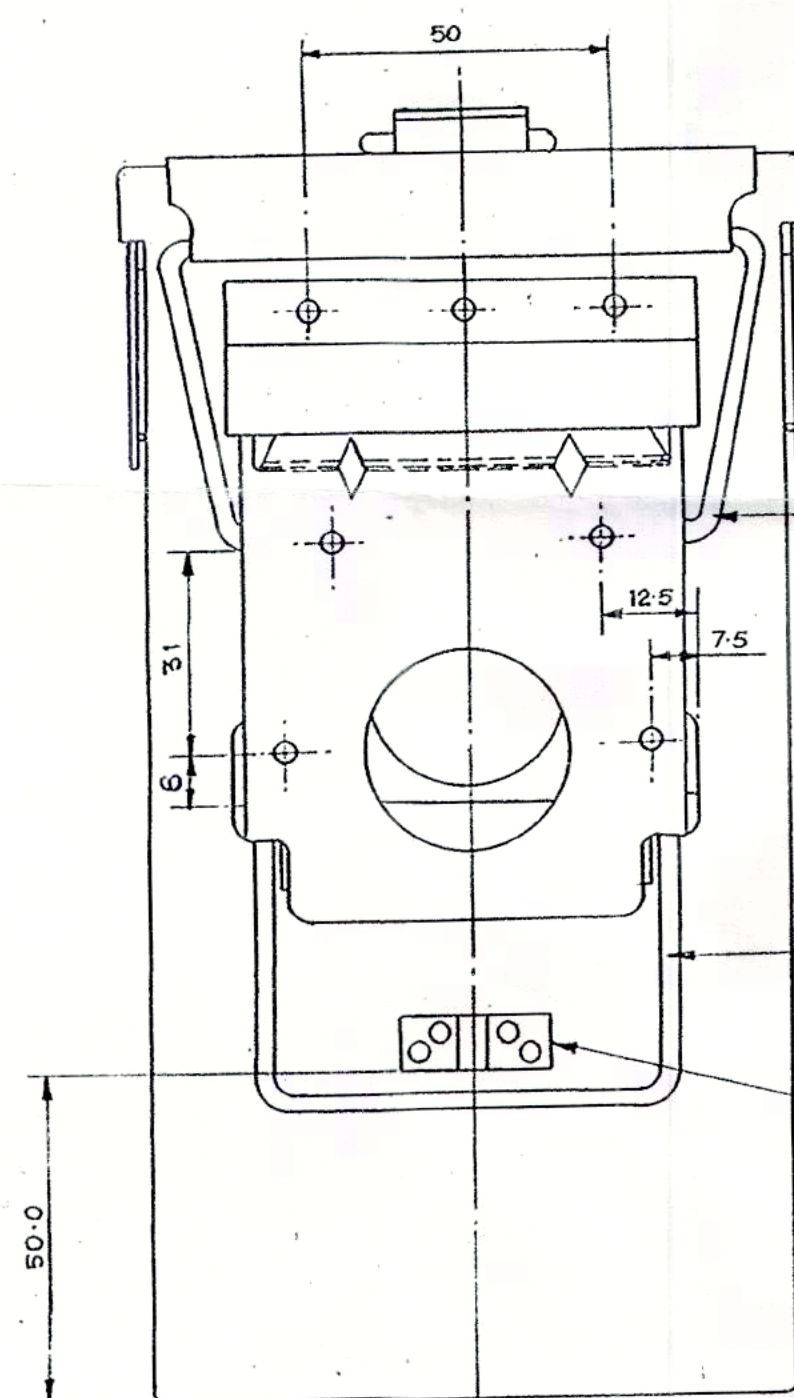
BODY:-
STEEL PLATE 0.80 ± 0.08 TO SPEC.

IS: 513 - 1986 COLD ROLLED & ANNEALED TYPE 'D' BEST SURFACE

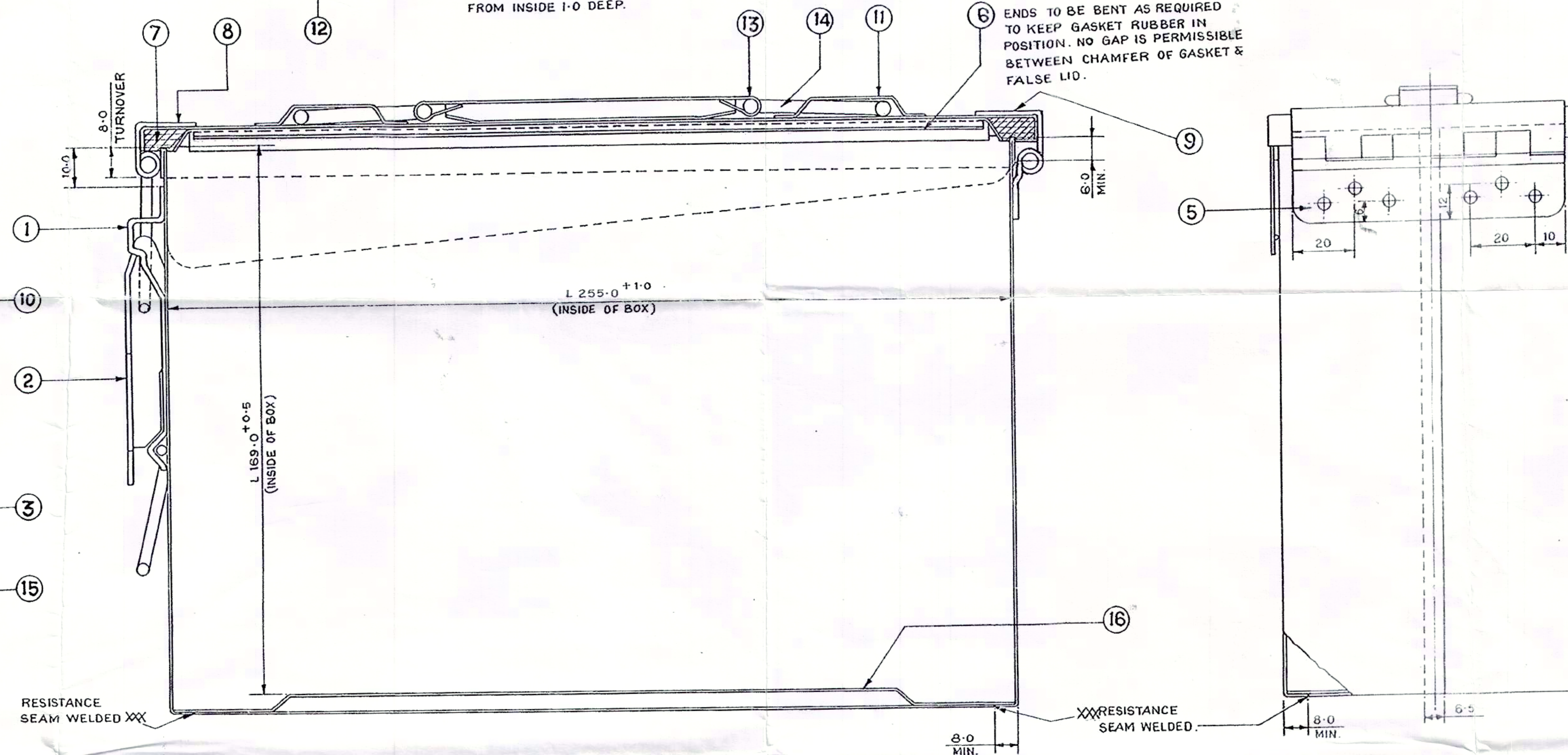
PLAN - PART LID REMOVED

---TO BE EMBOSSED ON LID
FROM INSIDE 1-0 DEEP.

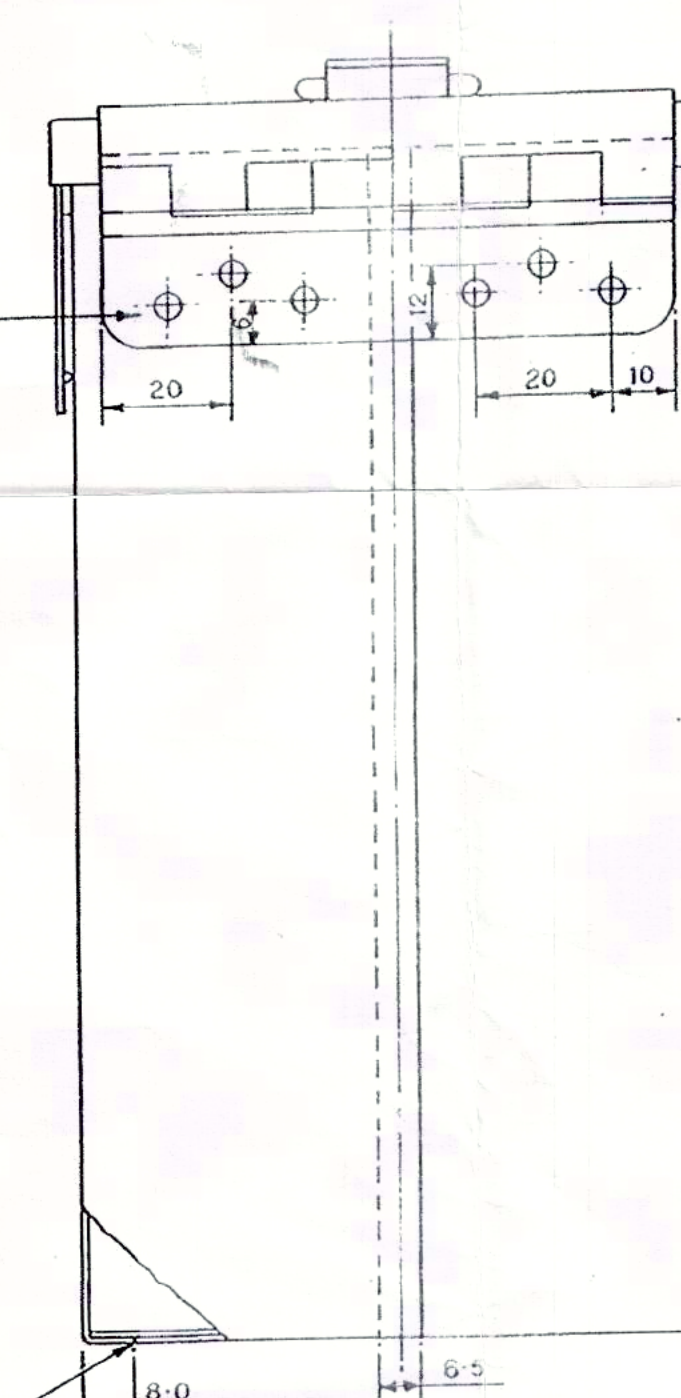
ENDS TO BE BENT AS REQUIRED
TO KEEP GASKET RUBBER IN
POSITION. NO GAP IS PERMISSIBLE
BETWEEN CHAMFER OF GASKET &
FALSE LID.



END VIEW



ELEVATION
SECTION-A-A



END VIEW

ITEM 1 SECURED BY 7 SPOT WELDS.
ITEM 5 SECURED BY 6 SPOT WELDS.
ITEM 6 SECURED BY 10 SPOT WELDS.
ITEM 8 SECURED BY 4 SPOT WELDS.
ITEM 9 SECURED BY 4 SPOT WELDS.
ITEM 11 SECURED BY 4 SPOT WELDS.
ITEM 15 SECURED BY 4 SPOT WELDS.
ALL SPOT WELDS TO BE Ø 3-0.

OVERALL DIMENSIONS

OVERALL DIMENSIONS
LENGTH :- APPROX. 283.0
WIDTH :- " 97.0
HEIGHT :- " 190.0

MARKING TO BE STAMPED OR EMBOSSED
ON LID IN 10 TYPE

NO.

*	YEAR OF MANUFACTURE IN FOUR DIGITS.	} H5A
†	MANUFACTURER'S INITIALS OR RECOGNIZED TRADE MARK.	

ALTERNATIVELY H5A, MANUFACTURER'S INITIAL & YEAR OF MANUFACTURE CAN BE EMBOSSED IN ONE LINE BELOW HANDLE.

D.S. CAT NO 8140-NEED NOT BE EMBOSSED OR STAMPED.

TECHNICAL REQUIREMENT :-
SPECIFICATION 1A 1169 (n).

ADHESIVE DUNLOP S-480 ALTERNATIVELY
ADHESIVE SPEB-7 TO SPEC. JSS-8040-12 (LATEST
ISSUE) FOR FIXING RUBBER GASKET.

LIST OF COMPONENTS					
ITEM Nº	DESCRIPTION	PART N°	DESIGNER'S REF.	D.S.CAT N°	Nº PER SET.
1	PLATE ENGAGING.	ISV 1782	CIA/AMN/2476 DET.1		1
2	CATCH	ISV 1783	” ” ” DET.2		1
3	LIFTING LINK, END	ISV 1784	” ” ” DET.3		1
4	HINGE PIN	ISV 1785	” ” ” DET.4		3
5	HINGE	ISV 1786	” ” ” DET.5		1
6	FLASE LID	ISV 1787	” ” ” DET.6		1
7	GASKET	ISV 1788	” ” ” DET.7		1
8	PLATE (FOR CATCH LOCKING)	ISV 1789	” ” ” DET.8		1
9	PLATE (FOR HINGE)	ISV 1790	” ” ” DET.9		1
10	LID LINK (FOR CATCH LOCKING)	ISV 1791	” ” ” DET.10		1
11	CLIP	ISV 1792	” ” ” DET.11		2
12	LID	ISV 1793	” ” ” DET.12		1
13	HANDLE	ISV 1794	” ” ” DET.13		1
14	LINK (FOR HANDLE)	ISV 1795	” ” ” DET.14		2
15	STAPLE	ISV 1796	” ” ” DET.15		1
16	BOTTOM PIECE	ISV 1797	” ” ” DET.16		1

[illegible]