



1. ALTERNATE MATERIAL IS STRAIN HARDENED STEEL 20 GOST 1051-73
 ROUNDS $\frac{3.5 \text{ GOST 7417-75}}{20 \text{ GOST 1051-73}}$ ANNEALED.
2. * DIMENSIONS ARE SUBJECTED TO TOTAL CHECKING.
3. ** DIMENSION ENSURED BY TOOL.
4. PERFORM CYLINDRICAL SURFACES ONCE CLAMPED ONLY.
5. COATING SHOULD BE ZINC 6 MICRONS THICK CHROMATIZED.
 THE COATING ALLOY Cu Zn (70%) 3. Sn3 OR CU3. Sn3
 ARE ALLOWED. Sn3 CADMIUM 9 MICRONS THICK CHROMATIZED. THE COATING
 CADMIUM 15 MICRONS THICK CHROMATIZED IS ALLOWED.
6. THE FOLLOWINGS IS ALLOWED.
 - (a) LOCAL UNDERFILLING OF METAL AT DIAMETER B AS AGAINST THE STANDARD SAMPLE ESTABLISHED BY MANUFACTURE AND AGREED WITH CUSTOMER REPRESENTATIVE AT MANUFACTURING PLANT.
 - (b) COLD CAP OF METAL AFTER KNURLING IN THE PLACE OF TRANSITION OF SURFACE A TO SURFACE b.
 - (c) SPOILING OF KNURLING—TOTALLY NOT EXCEEDING 2 TEETH.
 - (d) SEIZURE OF RING GAUGE NOT EXCEEDING 1.5mm FROM SURFACE G WHILE CHECKING THE DIMENSION D , AFTER KNURLING.
 - (e) LAPS AND LINES ARE ALLOWED ON THE PARTS MANUFACTURED BY COLD EXTRUSION AS AGAINST THE STANDARD SAMPLE ESTABLISHED BY MANUFACTURE AND AGREED WITH CUSTOMER REPRESENTATIVE AT MANUFACTURING PLANT.

				SCALE: -10:1		TOL		DIMENSIONS ARE IN mm		ASSY DRG No. NAI(J)501(P)	
				DGN		DRN <i>[Signature]</i>		TCD		COMP	
				PASSED <i>[Signature]</i>		NAIO		APPROVED <i>[Signature]</i>		CINA	
				MATERIAL: STEEL		GEN SPEC NA SPEC A31-B		STORE SPEC		STORE REF No.	
				MATERIAL SPEC: IS: 1673, Gr. 1		PROTECTIVE FINISH					
R.No.	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS						
	10.6.02		PROV. FULLY SEALED BY DGM								
	08.01.03		APPROVED								

TOP PLUG

DRG. No. NAI(J) 501/2 (PROVISIONAL)