

1. MATL EN24 (BS:970 Gde 817M40) HARDENED AND TEMPERED 'U' CONDITION  
 2. U/C OPEN TO READ DIMMS IN DETAIL 'A' AND 'B' & NOTE 1. AMENDED  
 3. GEN. TOL. SPECN. IS: 2102 UNLESS SPECIFIED  
 4. PHOSPHATING TO IS: 3618 CLASS-B  
 5. INTERNAL SURFACES MARKED XX TO BE COATED WITH VARNISH STOPPING AMMUNITION TO SPEC JSS- 163-14  
 6. EXTERNAL SURFACES MARKED XXX TO BE PAINTED WITH P U PAINT AFTER ASSEMBLY WITH BODY ( NASK 1134/1/1/1) EXCEPT THREADED SURFACES AS PER DRG. NO NASK 1134/1/1.  
 7. SURFACE MARKED XXXX TO BE COATED WITH ZIRCONIUM SILICATE TO APPENDIX 'C' OF SPEC ARDE/SPEC/334/1085 9R.A.P.C 216 J S S : 8010-51  
 8. METRIC THREAD TO CONFORM TO SPEC IS: 4218  
 9. BUTTRESS THREAD TO CONFORM TO SPEC BS:1657

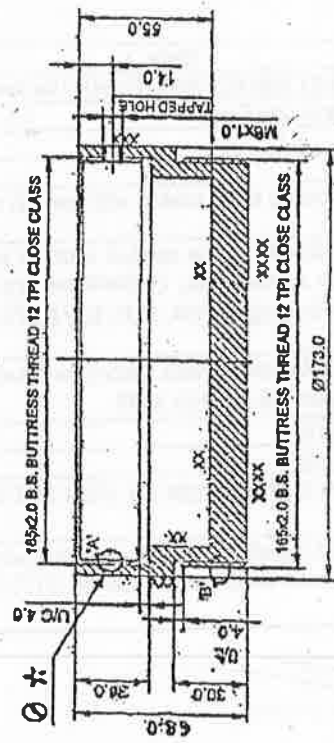
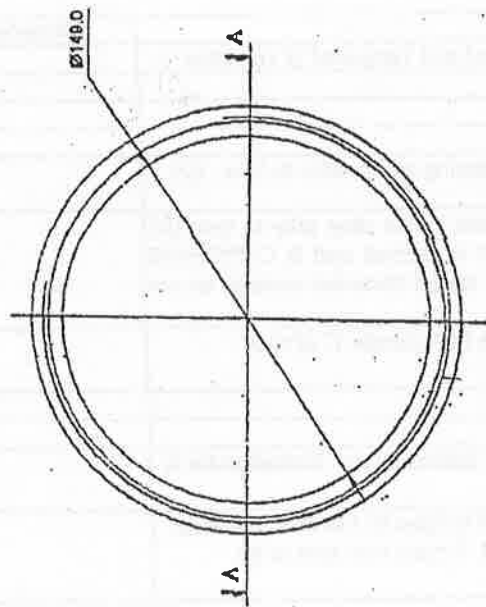
**NOTES:-**

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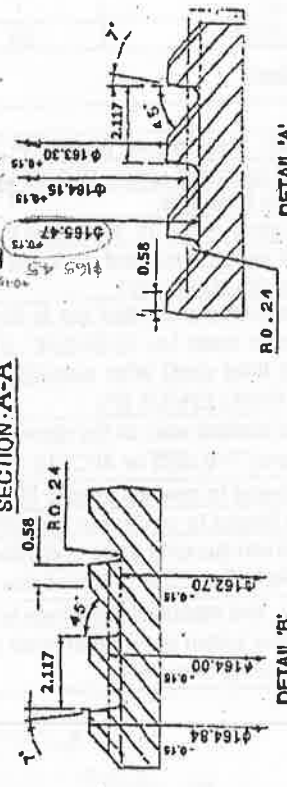
**MARKING NOTES:**

THE FOLLOWING MARKING TO BE STENCILLED WITH BLACK COLOUR PAINT TO SPEC IS: 138 IN 10 MM LETTER SIZE LEAVING 1MM SPACE FROM HEAD SIDE ON OUTER SURFACE HAVING Ø 173.0 TAPPED HOLE AREA TO BE AVOIDED DURING STENCILLING:-

⊗ SERIAL NO ☆ MANUFACTURE'S LOGO



**SECTION A-A**



**DETAIL 'A'**

**DETAIL 'B'**

Part No.	Rev.	Issued On	By	Checked By	Approved By	Authority
1.		19-09-2019				ARD 2576

Part No.	Rev.	Issued On	By	Checked By	Approved By	Authority
1.		19-09-2019				ARD 2576

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1.		19-09-2019				ARD 2576

NASK 1134/1/1/2(P)

BODY BASE MOD 1

SHEET

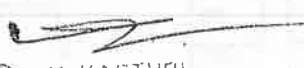
9  
**Inspection Report**

Description of the item	BODY BASE
Drawing No.	NASK 1134/1/1/2(P)

Ser	Description of parameter	Nominal dimension as per drawing in mm	Gauge used	Tolerance (As per drg/spec.)	Nature of parameter	Observed dimension in mm	Deviation in mm	Remarks
1	Outer dia.	173		±0.2	Major			
2	Inner dia	149	Plug 'Go' & 'No Go' gauge	±0.2	Major			
3	External thread	165 x 12 TPI Buttress Thread close class	165 x 12 TPI Buttress Thread close class. Buttress thread gauge		Major			
4	Internal thread	165 x 12 TPI Buttress Thread close class	165 x 12 TPI Buttress Thread close class. Buttress thread gauge		Major			
5	Outer step length	30	T plate 'Go' & 'No Go' gauge	±0.2	Major			
6	Under cut width	4		±0.1	Minor			
7	Inner step length	30	Plate 'Go' & 'No Go'	±0.2	Major			
8	Under cut width (Inner)	4		±0.1	Minor			
9	Overall length	68		±0.3	Major			
10	Tapped hole (1 no.)	M6 x 1	Screw plug 'Go' & 'No Go' gauge		Major			
11	Tapped hole centre distance	14		±0.2	Minor			
12	Inner depth	55	Depth H&L gauge	±0.3	Major			

**Special Notes:**

Ser	Note	Observations
1	Material:- Steel to spec BS 970 (Pt.3)-91 Gde 817 M40 (EN24), Hardened and Tempered 'U' condition	
2	General tolerance specn. IS 2102 unless specified.	
3	U/C open tolerance.	
4	Phosphating as per IS 3618 class B.	
5	Internal surfaces marked xx in the drawing to be coated with varnish stoving ammunition to Spec. JSS 8010-28.2015(APC 221)	
6	External surfaces marked xxx in the drawing to be painted with PU paint colour dove grey to spec ISC 694 (three coats i.e. CHEMZINC 1000 as first coat, CHEMPRIME 3001 as second coat & CHEMTHANE 3300 as third coat) after assembly with body (NASK 1134/1/1/1 (P)), except threaded surfaces as per Drg No NASK1134/1/1 (P).	
7	Surfaces marked xxxx in the drawing to be coated with zirconium silicate to Appendix 'C' of spec ARDE/spec/334/1985 or APC 216 to Spec JSS 8010-51.1999	
8	Metric thread to confirm to spec IS: 4218.	
9	Buttress thread to confirm to spec BS: 1657.	
10	100% thread gauging to be undertaken to check major dia 165 x 12 TPI Buttress thread Thread profile is to be checked on 10% of the lot size.	
11	Serial No. and Manufacturer's logo to be stencilled with black colour paint to Spec IS 138 in 10mm letter size leaving 14mm space from head side on outer surface having Ø173.0. Tapped hole area to be avoided during stencilling.	

  
 K. KASTURI  
 JUNIOR WORKS MANAGER  
 FACTORY / DIVISION OF DESIGN  
 AND DEVELOPMENT  
 AND MANUFACTURE  
 AND DEVELOPMENT  
 AND MANUFACTURE

(A. K. Kasturi)

## HEPF, TRICHY

The HIGH ENERGY PROJECTILE FACTORY (HEPF) is an Indian Defence establishment under Munitions India Limited, A Government of India Enterprise, Ministry of Defence, for production of anti tank kinetic energy projectiles of various calibers and the factory is located about 25 kilometres from the main city of Tiruchirappalli.

### SCOPE OF WORK

PR No: 2300162

### MACHINING OF RGB60 BODY BASE FROM STEEL BLANK (OD 180 MM AND LENGTH 75MM) AS PER DRG No: NASK 1134/1/1/2 (P) AND QUALITY ASSURANCE PROCEDURE ( QAP)

1. Raw material, steel rod (OD 180mm and length 75 mm) BS 970(Pt3)-91Gde 817 M40 (EN24), Hardened and Tempered to U condition and having weight 15 KGs approximately will be supplied by HEPF.
2. The firm has to carry out only machining work of Body Base .
3. The firm need not return the scrap generated during machining, however, the firm should submit their offer lowest by taking the cost of steel scrap of 11.5 kgs (approx) generated in machining into account.
4. The firm has to take utmost care to avoid material rejection due to dimensional deviation during machining.
5. In case of rejection exceeds 2%, the existing cost of raw material will be recovered from the firm. The firm shall also return the rejected components to HEPF.
6. The firm should submit Bank guarantee for the cost of raw material for minimum 50 Nos, and collect the material from HEPF store within 10 days of placement of supply order.
7. Firm should make their own arrangement (including loading/ unloading) for collection of raw material from HEPF stores and deliver the finished / accepted components to HEPF stores.
8. Firm should submit pilot sample along with dimension report within 15 days of receipt of raw material for prior approval.
9. The pilot sample submitted by the firm shall be inspected by HEPF Quality Control Section / inspection authority before bulk production.
10. After obtaining approval of pilot sample, the firm should maintain the delivery schedule of minimum 50 Nos for every week from the date of receipt of the raw material.

### QUALITY ACCEPTANCE CRITERIA:

11. The components shall be inspected by Quality Control Section /HEPF or Navel Armament of Inspectorate (NAI) as per drawing and Quality Assurance Procedure (Inspection Report). If it is confirming to both drawing and Quality Assurance Procedure (Inspection Report) the same will be accepted.

- Note:**
1. Prospective bidders are free to visit HEPF before bidding, for understanding the operation.
  2. In case of technical clarification the bidders may contact : 0431-2584-645 & 662, 0431-2584600 Extn: 271.

  
GO/MS

  
DO/MS

  
OIC/MS