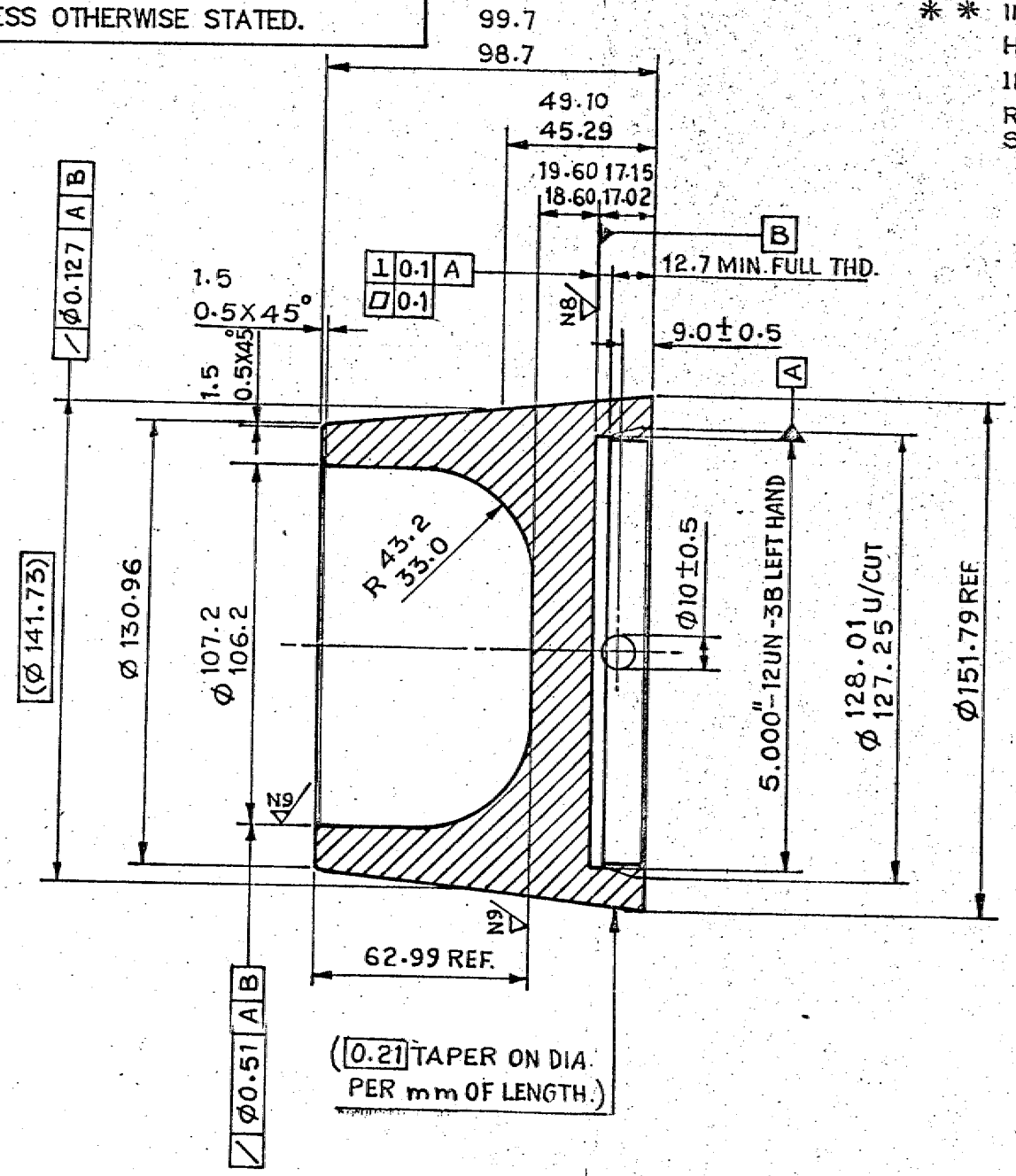
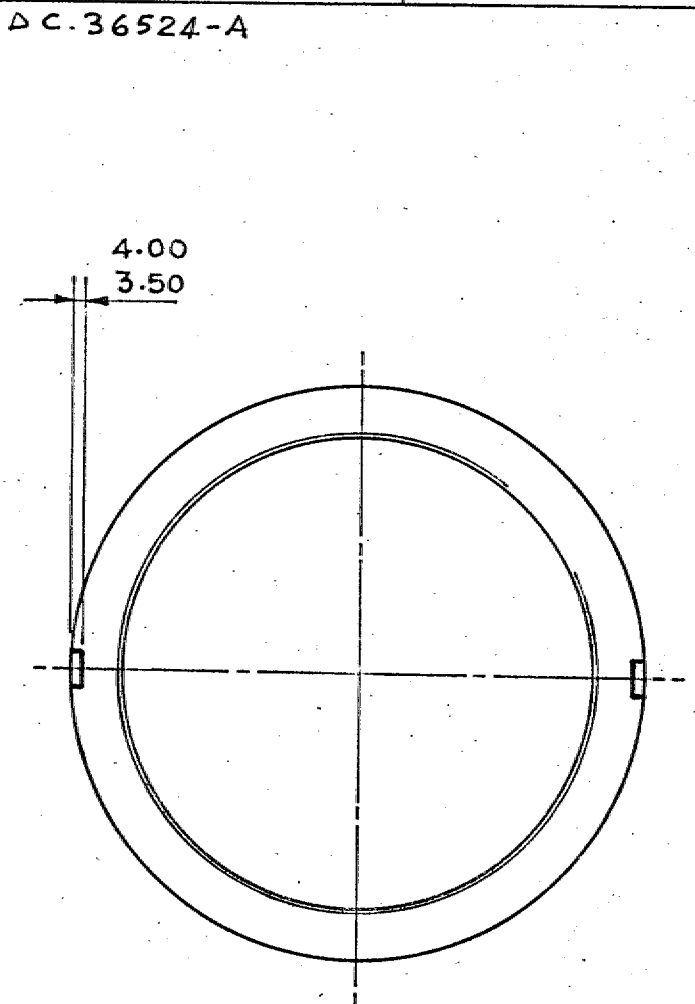


DRG. CONVENTIONS CONFORM TO IS: SPECIFICATIONS
 DIMS ARE IN mm. UNLESS OTHERWISE STATED.

** INDIGENOUS EQUIVALENT "R/M PAINT TO SPEC. IS:168-1993 AS FOLLOWS.
 HE BB AND BT SHELL - MIDDLE BUFF COLOUR ISC No. 359 OF IS:5.
 ILLG SHELL - WHITE.
 RED PHOSPHORUS AND - LIGHT BRUNSWICK GREEN ISC No. 225 OF IS: 5
 SMOKE SHELL



NOTE:

1. ∇ ALL MACHINED SURFACES EXCEPT AS NOTED.
 2. MACHINED AREAS TO BE FREE FROM BURRS, FALSE CUTS, MARKS OR OTHER DEFECTS.
 3. TOLERANCES ON DECIMALS: 0.0 = ± 0.25 0.00 = ± 0.13
 4. FOR EMPTY MARKING DETAIL. REFER TO DRAWING NUMBER: 155-9030. NOTE EMPTY MARKING TO BE APPLIED PRIOR TO ANODIZING PROCESS.
 5. PREPARE ALL SURFACES, USING SULPHURIC ACID, ANODIZE TO SPEC. MIL-A-8625 C TYPE 1 OR MIL-A-8625 C TYPE 11 CLASS 1, ANODIZE FILM TO MIL-A-8625 C TYPE 11 CLASS 1 NON DYED. ALTERNATIVE: ANODIZE ALL SURFACES IN ACCORDANCE WITH SPEC. DEF. 151 AMDT. 1 TYPE 1 DICHROMATE SEAL. ALTERNATIVE TO ANODIZING, CHROMATE CONVERSION TO SPEC. MIL-C5541 AMDT. C.
 6. COATING: COAT ALL SURFACES EXCEPT THREADS AND INNER FLAT SURFACES WITH GUNKOTE TO SPEC. KALGARD 16-2 TINT 224 TO BS 381C-1980. ** THICKNESS 8-13 MICRONS.
 7. BOAT TAIL TO BE TESTED FOR CRACKS BY AN APPROVED METHOD.
 8. FOR FORGING REF. DRG. NO 155-1160
- * INDIGENOUS EQUIVALENT "IS: 11232:- 85 CLASS 1" (LATEST REVISION TO BE FOLLOWED)

THREAD DETAIL

MAJOR DIA. (5.000" MIN.)	127.0
EFF DIA. (4.9459" +0.0063")	125.63 +0.16
MINOR DIA. (4.910" +0.010")	124.7 +0.25

R. NO.	DATE	AUTHORITY	REVISION	ZONE	AHSP	D.O.	SIG.
	1-11-01	DC-36792-A	"ASSY.DRG.Nos" ADDED, UNDER NOTE 5&6 "I.E. MATL." ADDED.				
	11-2-99	DC.36524.A	DRG. SEALED (PROV)				
DRG. SEALED:- 11.2.99 (PROV)							

DRN:-	TRD:-	CHD:-	TRNCHD:-
V.S.S. MAN	Gan... O I/C D.O	C...	
APPD	FOR CQA(A)	SCALE:- NOT TO SCALE	EST.MASS:-
MATL:- REFER TO DRG No 155-1160	PROTECTIVE FINISH:-	GAUGE SCHD:-	DATE:-

ASSY DRG.	2440A04001
	155-1010, 2439A04001
DESIGNER'S REF	155-1150
PART No.	
D.S.CAT NO	
AHSP:-	CQA(A) KIRKEE

BOAT - TAIL MACHINED