



SETS OF EMPTY COMPONENTS FOR SAFE & ARM DEVICE FOR FUZE FB-40

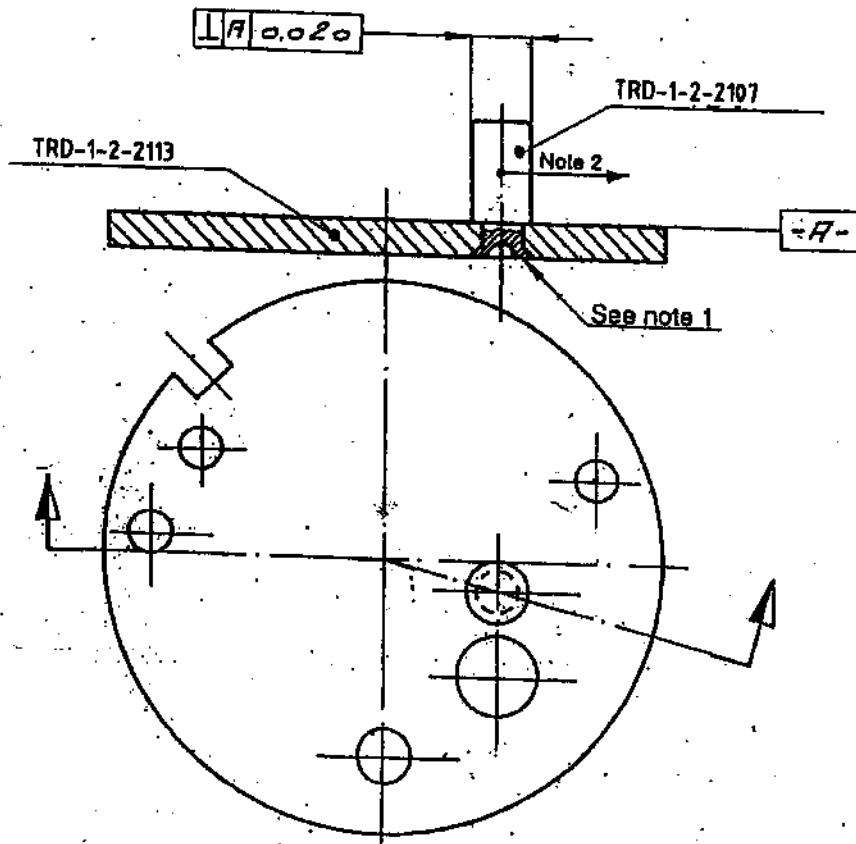
S.No.	Nomenclature of components	TRD Drawing Number	Assembly drawing having following components
1	Plate 1 Assembly	1-2-2106	1. Plate 1, TRD1-2-2113 2. Pivot of Rotor TRD 1-2-2107
2	Pinion & Gear 2 Assy.	2-2-2125	1. Geat n°1e2 TRD 2-1-2136 2. Pinion TRD 2-2-2127
3	Balance Assy	2-2-2130	1. Balance TRD 2-2-2123 2. Balance Pivot TRD 1-2-2108 3. Balance Pin Drg. TRD 1-2-2099
4	Assembly of Pinion 2 & Gear1	1-2-2098	1. Pinion No. 2 TRD 1-2-2112 2. Gear No. 1 TRD 2-2-2122
5	Sector Gear Assembly	2-2-2124	1. Sector Gear TRD 2-2-2115 2. Bush TRD 1-2-2116 3. Self Threading Rivet TRD 1-2-2102 4. Mas TRD 1-2-2104
6	Pinion & Escapement Gear Assembly	2-2-2126	1. Escapement Gear TRD 2-2-2132 2. Escapement Pinion TRD 2-2-2129
7	Wheel work holder body & pins assembly	2-2-2133	1. Pin TRD1-2-2275 2. Wheel work holder body TRD 3-2-2128
8	Plate 2	1-2-2114	
9	Plate 3	2-2-2118	
10	Plate 4	2-2-2119	
11	Plate 5	2-2-2274	
12	Plate 6	2-2-2120	
13	Plate 7	2-2-2121	
14	Rotor	1-2-2111	
15	Tube	1-2-2103	
16	Disc (2 Nos)	1-2-2101	
17	Inertial Pin	1-2-2094	
18	Spring of Inertial Pin	1-2-2096	
19	Pivot	1-2-2105	
20	Spring	2-2-2117	
21	Pin	1-2-2095	
22	Pin	1-2-2097	
23	Detonator Holder	1-2-2109	

*JWM/43*

*JWM/R&P*

TO BE MARKED ON TOOL/GAUGE/PART

TRD-1-2-2106



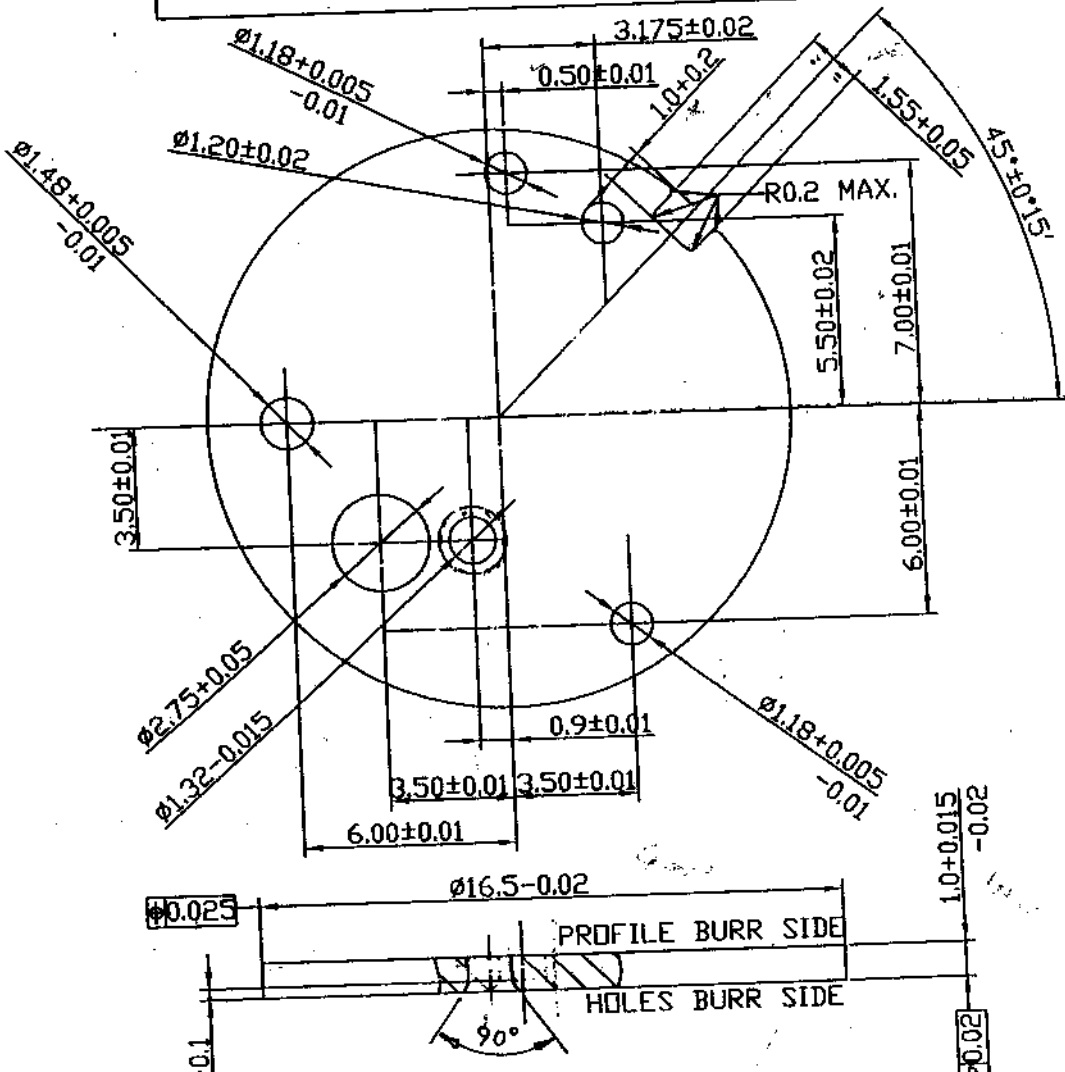
Notes:

- 1 - Insert the pin of the rotor in plate 1 as indicated and secure it by caulking at 360°. The caulking shall be flush to or under the plane of the plate.
- 2 - Apply a load of Kg. 7,0 at medium length of protruding part of pin, no loosening or deformation shall appear.

				ITEM No.	DESCRIPTION	No. OFF	MATERIAL
INSP.	DATE	HOS/ CDO	DA No	HEAT TREATMENT Rc.		PLATE 1 ASSEMBLY	
AMENDMENTS				▽ 12.5-25 Ra	▽▽▽ 0.2-0.8 Ra		
JWM/AS [Signature] AWM/ERT [Signature]				▽▽ 1.6-6.3 Ra	▽▽▽▽ 0.1-0.025 Ra		
HOS/ CADC [Signature] DATE 3.7.06				DIMENSIONS ARE IN mm.		DRG. No.	
CKD [Signature] CKD				UNTOL. DIMS. IS-2102 MEDRM		TRD-1-2-2106	
DRN [Signature] TRD				SHARP EDGES TO BE REMOVED		1ST. ANGLE PROJECTION	
				GAUGING SURFACES SHOWN BY THICK LINES		SCALE:-	
APPROVED BY				ORDNANCE FACTORY KHAMARIA		No. OF SHT. - SHEET No. -	
PS/GS.				STORE:- DRG. No.		COMPT. DRG.No.	

DRG.No.  
TRD -1-2-2113

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MATL-ALLOY P-Cu Zn 37 UNI 4892-H10  
ALTERNATIVE MATL-BRASS  
ASTM-B-36COMP.268R=42 Kg/mm<sup>2</sup>

				Item No.	DESCRIPTION	No. off	MATERIAL
Insp.	Date	JWM/CDD	DA No		Heat Treatment Rc.-		PLATE 1
Amendments					▽ 12.5-25 Ra ▽▽▽ 0.2-0.8 Ra		
JWM/AS					▽ 1.6-6.3 Ra ▽▽▽ 0.1-0.025 Ra	M/C	
JWM/HDS					DIMENSIONS ARE IN mm.		DRG. No.
CDD					UNTEL. DIMNS. IS:2102 MEDIUM		TRD :- 1-2-2113
CKD					SHARP EDGES TO BE REMOVED		Scale -5:1
DRN. R.R.					Gauging surfaces shown by thick line		No. of sheets - 1
Approved by					ORDNANCE FACTORY KHAMARIA		Sheet No. - 1
PS/GS.				STORE			Compt.
				DRG.No.			DRG.No.:

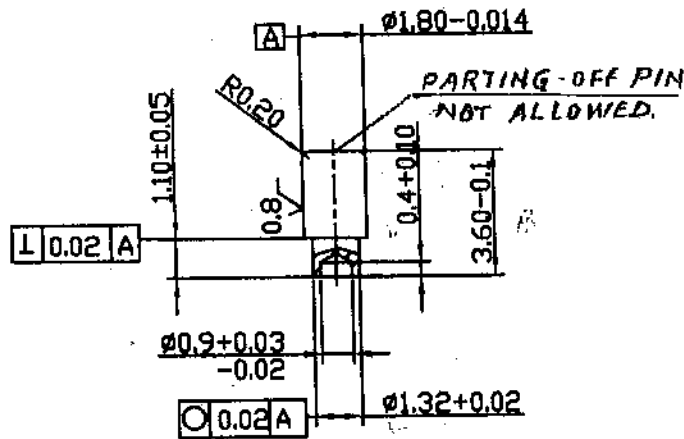
(3)

1/3

DRG.No.  
TRD -1-2-2107

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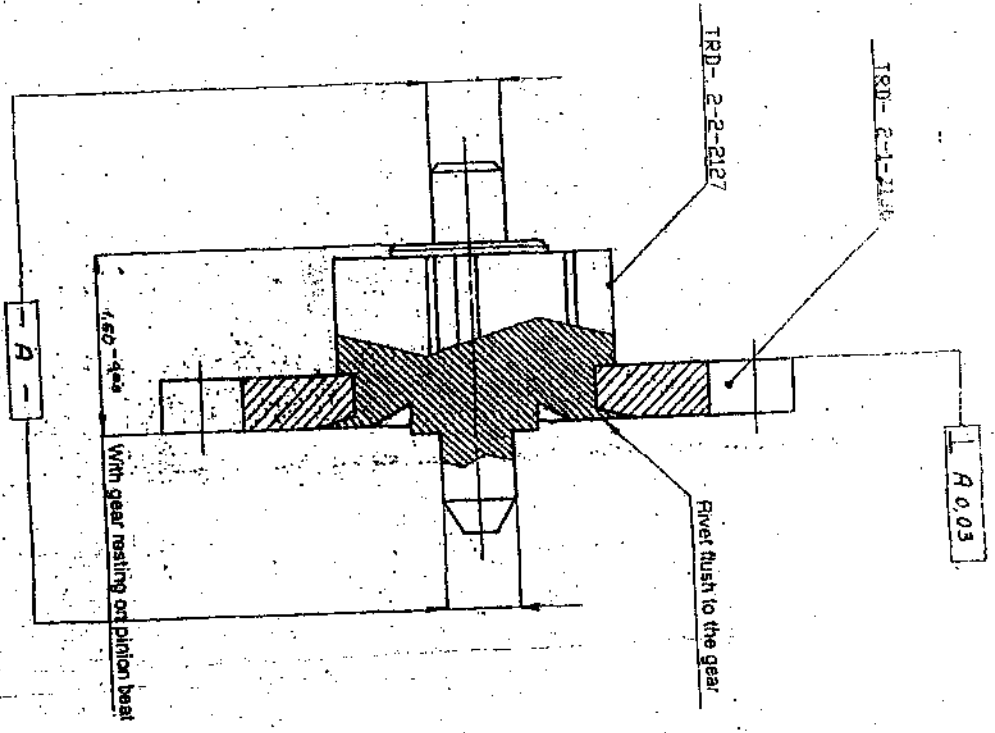
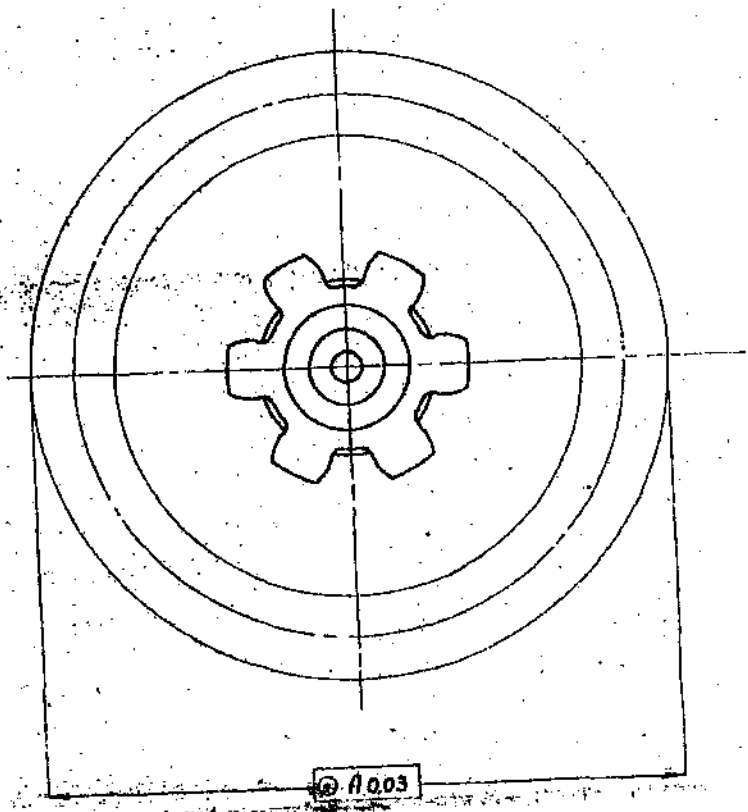


MATL-STAINLESS STEEL ROD HEAT RESISTANT, TYPE 303  
COND. B SPEC. ASTM-A581.

C (MAX)-0.15, Mn-1.25, P-0.06 S-0.15 MIN. SI MAX.-1.0, Cr. 12-14 INTERMEDIATE  
TEMPER (T)

				Item No.	DESCRIPTION	No. off	MATERIAL
Insp.	Date	JWM/ CDD	DA No	Heat Treatment Rc.-		PIVOT OF ROTOR	
Amendments				$\nabla$ 12.5-25 Ra	$\nabla\nabla\nabla$ 0.2-0.8 Ra		
JWM/HOS				$\nabla\nabla$ 1.6-6.3 Ra	$\nabla\nabla\nabla$ 0.1-0.025 Ra	M/C	
JWM/HOS				DIMENSIONS ARE IN mm.		Drg. No.	
CKD			DATE 19/5/06	UNTOL. DIMNS. IS:2102 MEDIUM		TRD -1-2-2107	
DRN R.R.			CKD	SHARP EDGES TO BE REMOVED.		Scale-5:1	
				Gauging surfaces shown by thick line		No. of sheets - 1	
Approved by				ORDNANCE FACTORY KHAMARIA		Sheet No. - 1	
PS/GS.			STORE	Compt.			
			Drg.No.	Drg.No.:			

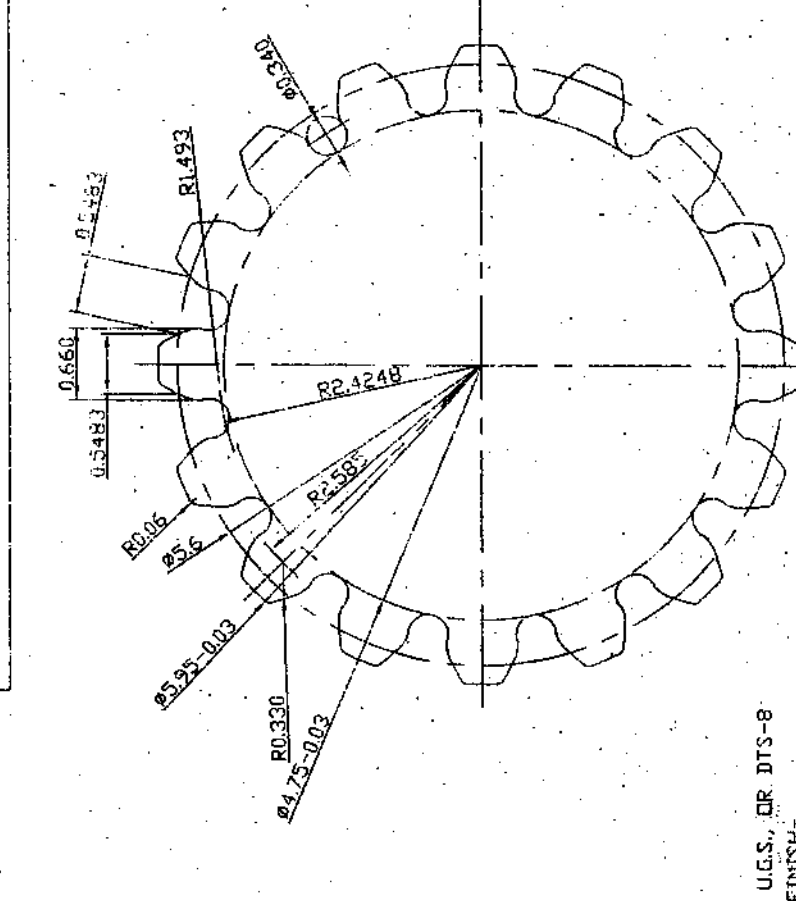
(2)



ITEM No.	DESCRIPTION	MATERIAL
	125-57 Ra	STEEL
	1.6-6.3 Ra	STEEL
	125-57 Ra	STEEL
	1.6-6.3 Ra	STEEL
AMENDMENTS CHG/ DATE/ BY/ REASON HOS/ DATE/ BY/ REASON CAD/ DATE/ BY/ REASON CKD/ DATE/ BY/ REASON DRN/ DATE/ BY/ REASON		
DIMENSIONS ARE IN MM UNTIL DIMS. IS SPEC. REQUIR. SHARP EDGES TO BE REMOVED GAUGING SURFACES SHOWN BY THEIR LINES		
DRG. No. TRD-2-2-2125 1ST ANGLE ISOMETRIC PROJECTION No. OF SHT. - 1 SHEET No. - 1		
APPROVED BY P. S. S.		STORED DRG. No.
DRDANCE FACTORY KHAMARIA		COMPT. DRG. No.

DRG. No  
TRD - 2-1-2136

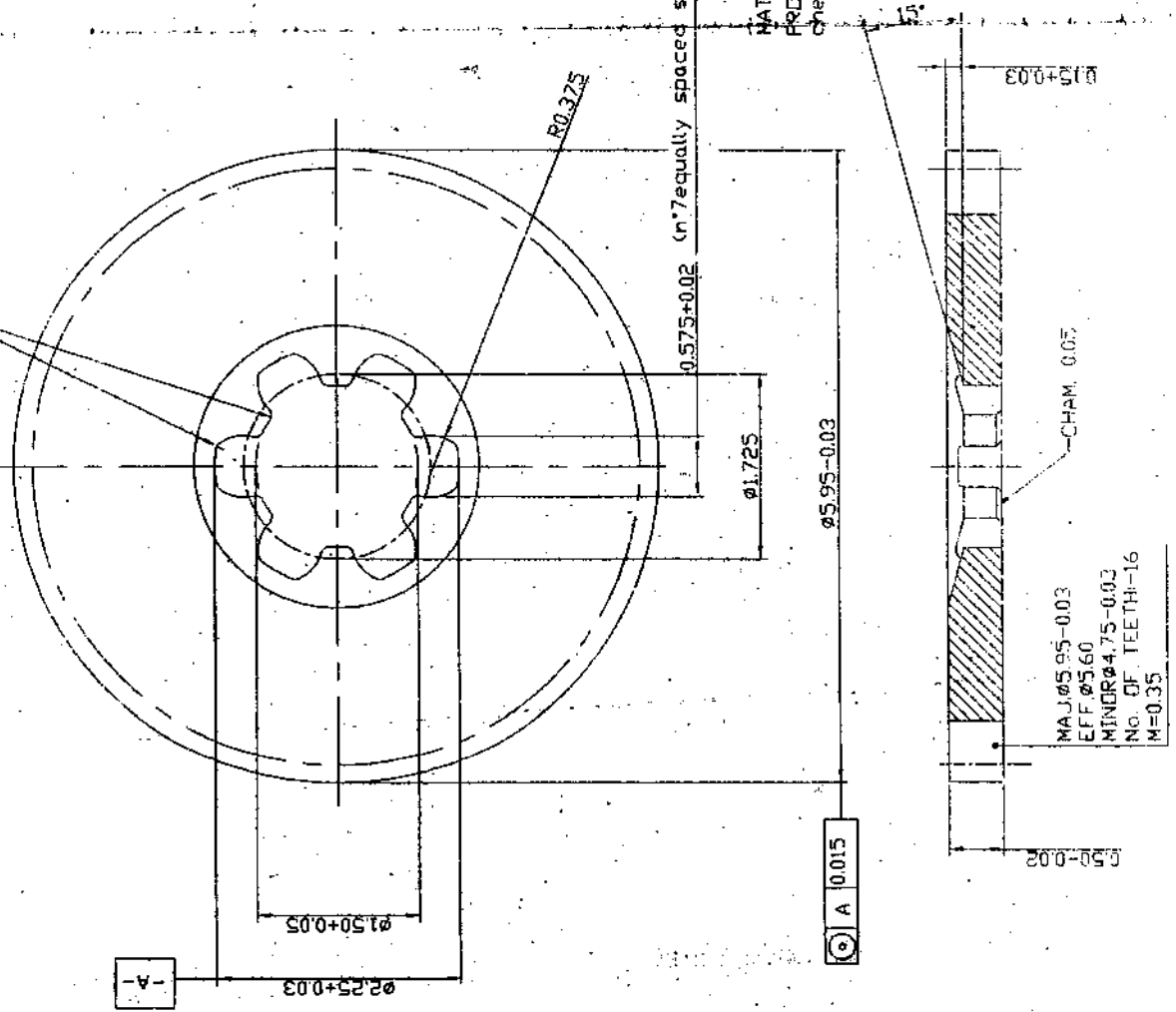
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MAT. - sheet U.G.S., OR DTS-8  
PROTECTIVE FINISH:  
Chemical nicking thickness of plating from L3 to 2.5

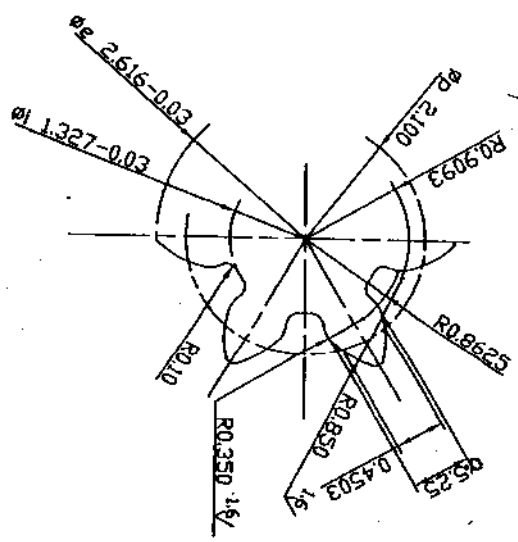
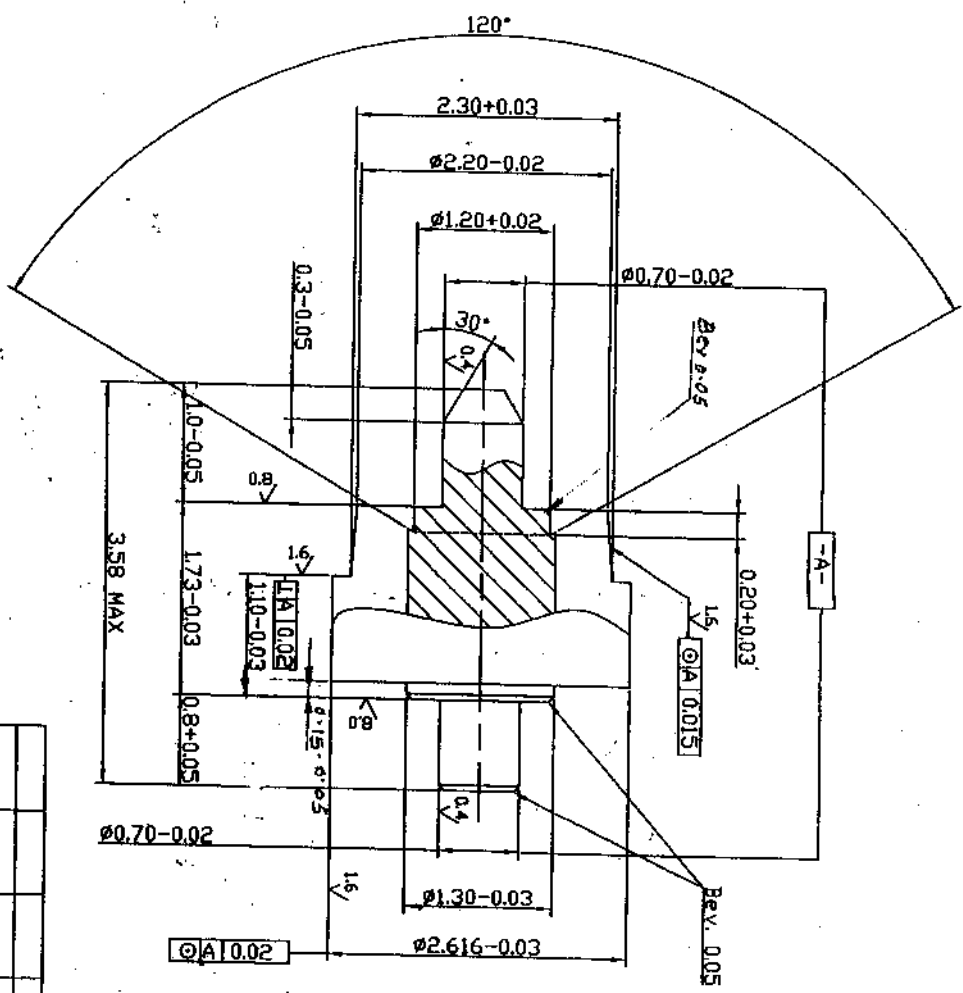
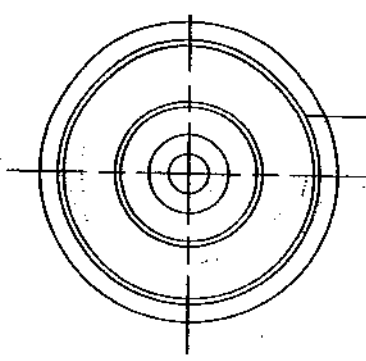
DETAIL OF TEETH  
SCALE: 20:1

Item No.	DESCRIPTION	No. OFF	MATERIAL
Insps	Date	JWM/ CDD	DA No
Amendments			
JWM/ CDD	DATE	CKD	TRD
Heat Treatment Rc- V 125-25 Kc VVV 02-08 Ru VV 1.6-6.3 Ru VVVV 01-025 Ra M/C DIMENSIONS ARE IN mm. UNTIL DIMNS. IS2102 MEDIUM SHARP EDGES TO BE REMOVED Gauging surfaces shown by thick line ORDNANCE FACTORY KHAMARIA No. of sheets - 1 Sheet No. - 1			
GEAR n° 1B 2 DRG No. TRD - 2-1-2136 Scale 20:1			



NOTES:-  
1) REMOVE ALL BURS  
2) HAT TREAT HARDEN AND TEMP. TO OBTAIN A ROCKWELL HARDNESS

Ø 2.616-0.03
ØP 2.10
Ø1.1327-0.03
M 0.35
Z 6



**NOTES:-**

1-FINISHING 3 GENERAL EXCEPT WHERE DIFFERENTLY INDICATED

2-HEAT TREAT(HARDEN & TEMPT)O OBTAIN A ROCKWELL HARDNESS HRC 40-45

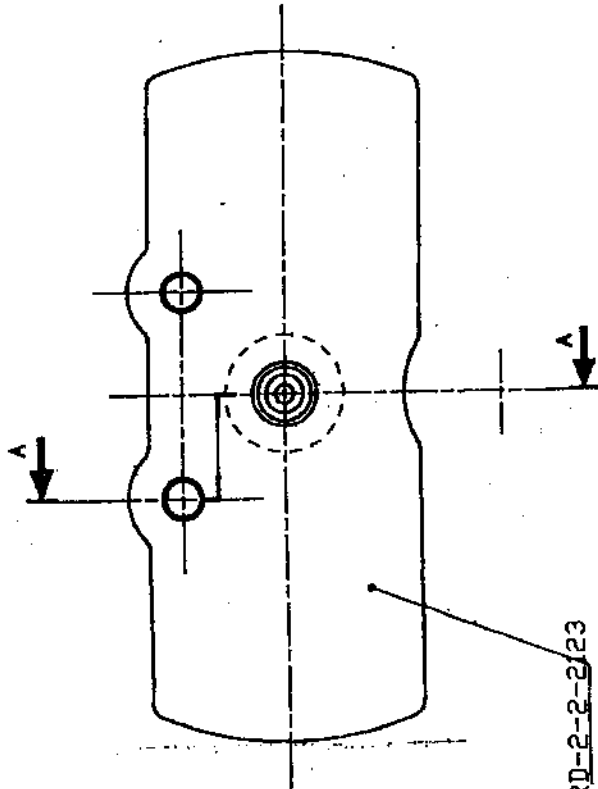
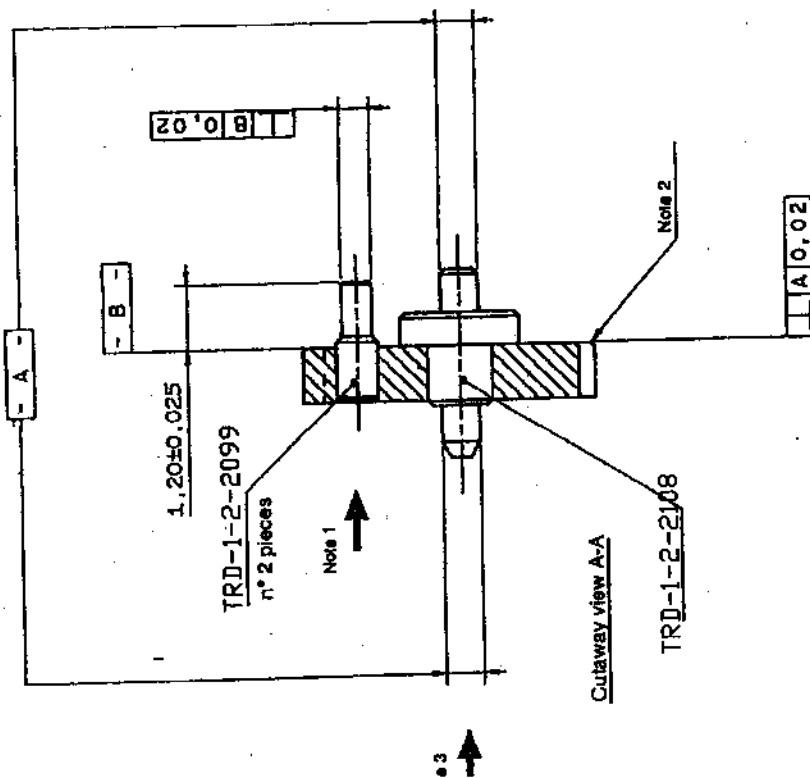
3-REMOVE ALL BURRS.

Insp.	Date	JVM/ CAD	DA No	Item No.	DESCRIPTION	No. off	MATERIAL
					Heat Treatment Rc:-		PINION 2
Amendments					▽ 125-25 Ra	▽▽ 02-08 Ra	
JVM/ CAD					▽▽ 16-6.3 Ra	▽▽▽ 01-0025 Ra	M/C
HOS/ CKD					DIMENSIONS ARE IN mm.		
CAD DATE 19/1/06					UNTEL. DIMNS. IS:2102 MEDIUM		
CKD					SHARP EDGES TO BE REMOVED		
DRN R.P.E.					Gauging surfaces shown by thick line		
TRD					ORDNANCE FACTORY KHAMARIA		
Approved by AATV (KH)					No. -		

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*Kanuja*

E MARKED ON TOOL/GAUGE/PART  
TRD-2-2-2130



TRD-2-2-2123

NOTES:

- 1 - The pins TRD-1-2-2099 of the balance, after assembling, shall stand an extraction load of 1,800 Kg. applied in indicated direction, without loosening or deformations.
- 2 - Projection of pins from blanking radiuses side of balance.
- 3 - The balance pivot TRD-1-2-2108 after assembling, shall stand an extraction load of 2,000 Kg. applied in indicated direction, without loosening or deformations.

ITEM No.	DESCRIPTION	No. OFF	MATERIAL
	HEAT TREATMENT Rc.		BALANCE ASSEMBLY
	▽ 12.5-25 Ra	▽▽	M/C
	▽ 1.6-6.3 Ra	▽▽▽	
DIMENSIONS ARE IN MM.			
UNTOL. DIMNS. IS:2102 MEDIUM			
SHARP EDGES TO BE REMOVED			
GAUGING SURFACES SHOWN BY THICK LINES			
AMENDMENTS		DRG. No.	TRD-2-2-2130
JWM/AS	DATE 21.7.12	1 St ANGLE PROJECTION	SCALE:-
CKD V.K. Kishan	CKD	No. OF SHT. -	
DRN J.K.	TRD	SHEET No. -	
APPROVED BY	ORDNANCE FACTORY KHAMARIA		

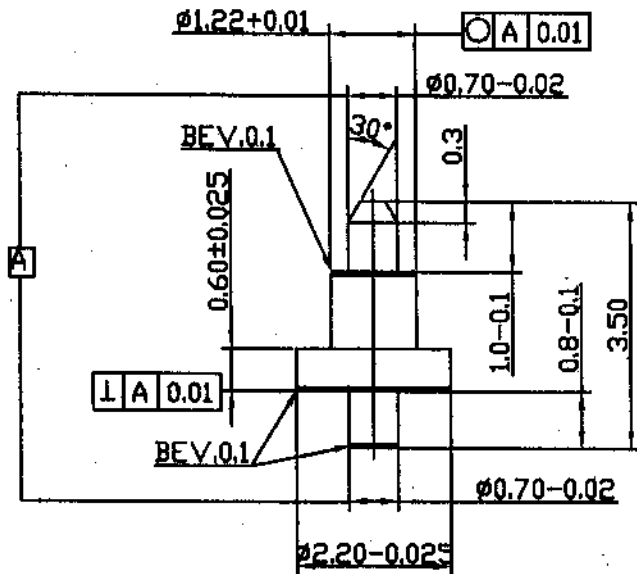


9

DRG.No.  
TRD -1-2-2108

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MATL:- CORROSION PROOF STEEL AISI 302-X 10 Cr Ni1809-UNI 6900-71  
OR BSI:302; S25 C:0.12, Mn-2.0 MAX, Si-1, Cr-17-19, Ni-8-10, P,0.45i MAX, S<0.03

NOTE: PROTECTIVE FINISHING FINISHING N° 5.4.1 SPEC MIL-STD-171B.

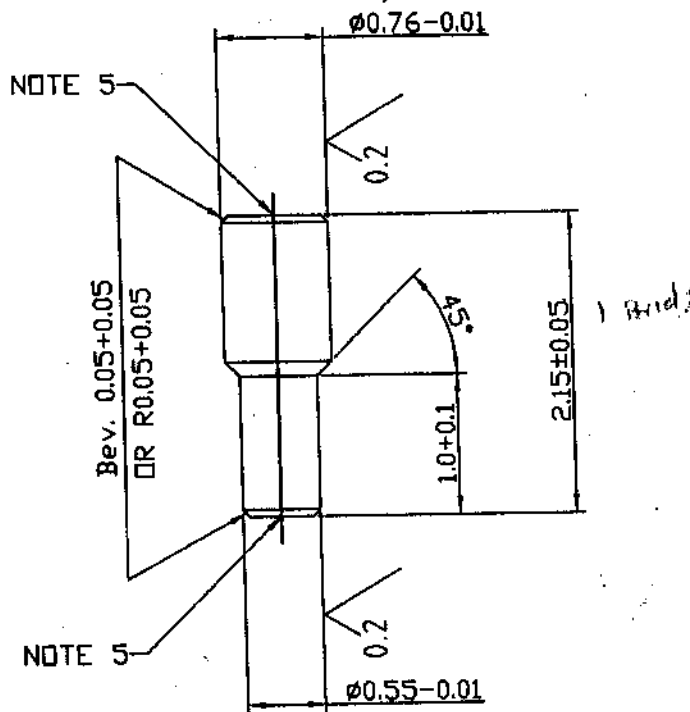
				Item No.	DESCRIPTION	No. off	MATERIAL
Insp.	Date	JWM/CDD	DA No	Heat Treatment Rc.-		BALANCE PIVOT	
Amendments				$\nabla$ 12.5-25 Ra	$\nabla\nabla\nabla$ 0.2-0.8 Ra		
JWM/AS	<i>[Signature]</i>	<i>[Signature]</i>		$\nabla\nabla$ 1.6-6.3 Ra	$\nabla\nabla\nabla\nabla$ 0.1-0.025 Ra	Drg. No.	
JWM/HDS	<i>[Signature]</i>	DATE 19/5/06		DIMENSIONS ARE IN mm.		TRD -1-2-2108	
CKD	<i>[Signature]</i>	CKD.		UNTOL. DIMNS. IS:2102 MEDIUM		Scale -10:1	
DRN. R.R.		TRD.		SHARP EDGES TO BE REMOVED		No. of sheets - 1	
Approved by				ORDNANCE FACTORY KHAMARIA		Sheet No. - 1	
PS/GS.			STORE			Compt.	
			Drg.No.			Drg.No.	

DRG.No.

TRD-1-2-2099

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NOTES:-

- 1-MATERIAL: CORROSION PROOF STEEL,TYPE 410 SPEC.QQ-S-763 OR SPEC. QQ-W-423.  
ALTERNATIVE MATERIAL:-CORROSION PROOF STEEL,TYPE 416, COND.T,COLD-ROLLED, SPEC ASTM-A581 OR SPEC. MIL-W-52263, HARDNESS HRC 38-44 OR Y/S 119.5 TO 147.6 Kg./mm<sup>2</sup>
- 2-FINISHING 1,6 GENERAL EXCEPT WHERE DIFFERENTLY INDICATED.
- 3-PROTECTIVE FINISHING n<sup>o</sup>5.4.1 SPEC.MIL-STD-171.
- 4-PHYSICAL PROPERTIES OF MATERIAL: HARDNESS HRC 38-44 OR YELD STRENGTH FROM 119,5 TO 147,6 Kg/mm<sup>2</sup>
- 5-PARTING-OFF PINS NOT ALLOWED.

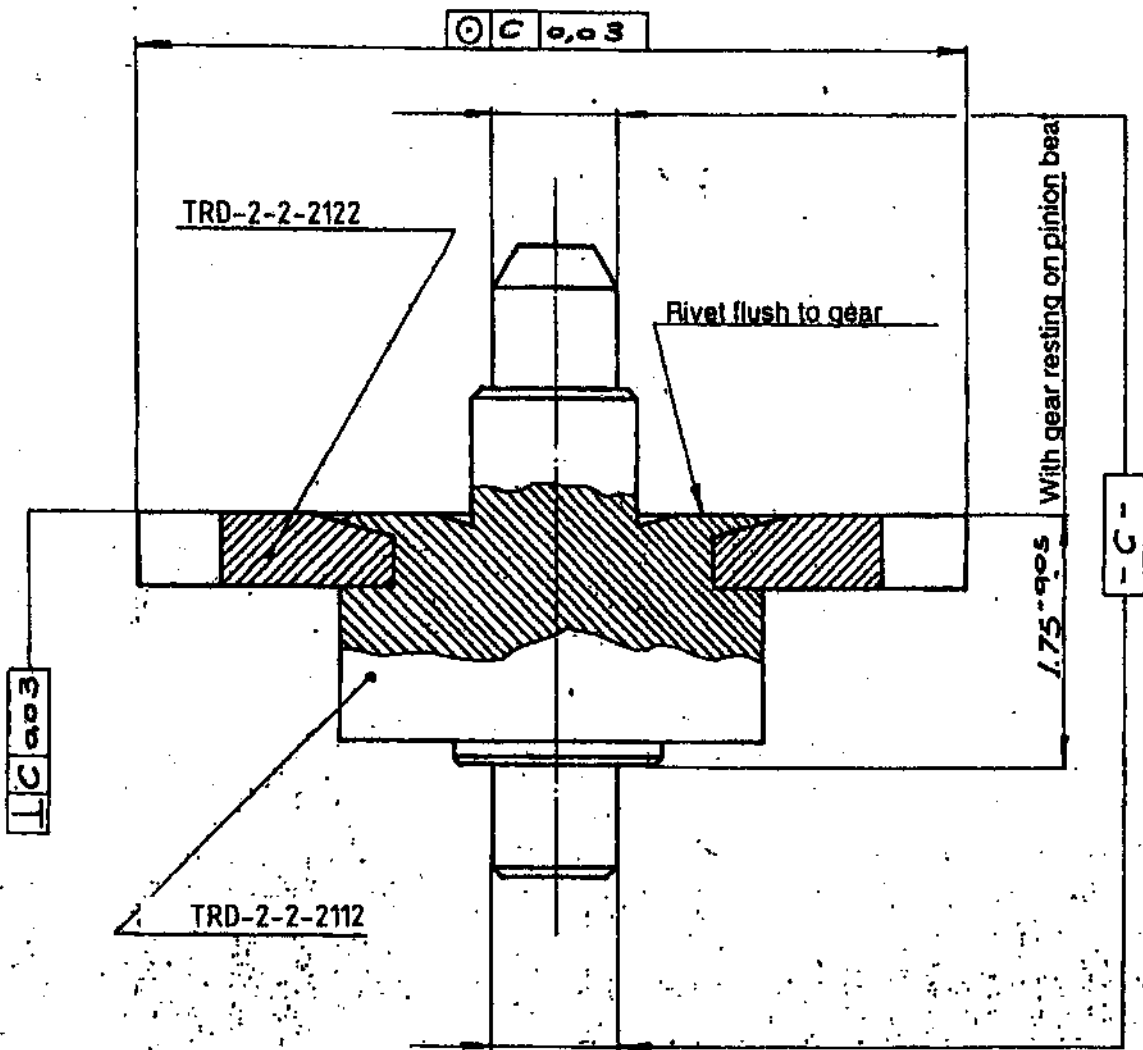
				Item No.	DESCRIPTION	No. off	MATERIAL
INSP.	Date	JWM/CDD	DA No	Heat Treatment Rc.-		BALANCE PIN	
Amendments				▽ 12.5-25 Ra	▽▽▽ 0.2-0.8 Ra		
JWM/AS				▽▽ 1.6-6.3 Ra	▽▽▽▽ 0.1-0.025 Ra	M/C	
HDS/CDD	DATE 19/5/06			DIMENSIONS ARE IN mm.		DRG.No.	
CKD	CKD			UNTOL. DIMNS. IS:2102 MEDIUM		TRD-1-2-2099	
DRN	OPV	TRD		SHARP EDGES TO BE REMOVED		SCALE: 1-20:1	
APPROVED BY				Gauging surfaces shown by thick line		No. of sheets - 01	
PS/GS.				ORDNANCE FACTORY KHAMARIA		Sheet No. - 01	
STORE-DRG.No.				COMPT.		DRG.No.	

TO BE MARKED ON TOOL/GAUGE/PART

TRD-1-2-2098

4

11



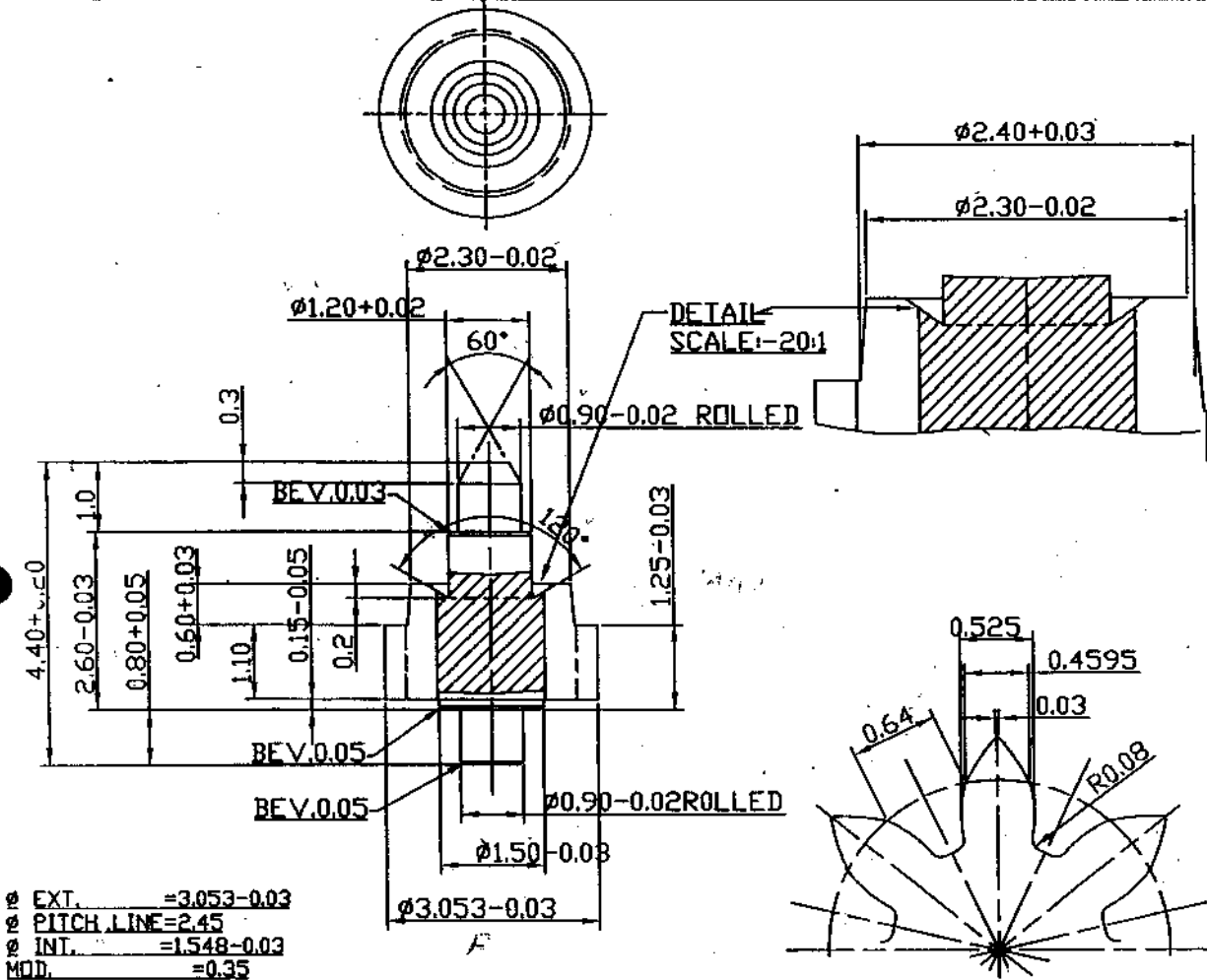
				ITEM No.	DESCRIPTION	No. OFF	MATERIAL
INSP.	DATE	HOS/ CDO	DA No	HEAT TREATMENT Rc.		ASSEMBLY PINION 2 AND GEAR 1	
AMENDMENTS				▽ 12.5-25 Ra	▽▽▽ 0.2-0.8 Ra	M/C	
JWM/AD1		AUMI/EPJ		▽▽ 16-6.3 Ra	▽▽▽▽ 0.1-0.025 Ra	DRG. No. TRD-1-2-2098	
HOS/ CADC		DATE 2/7/06		DIMENSIONS ARE IN mm.		1ST ANGLE PROJECTION	
CKD KOTDIN		CKD		UNTOOL. DIMNS. IS:2102 MEDIUM		SCALE:-	
DRN Kandi		TRD		SHARP EDGES TO BE REMOVED		No. OF SHT. - 1	
APPROVED BY				GAUGING SURFACES SHOWN BY THICK LINES		SHEET No. - 1	
ORDNANCE FACTORY KHAMARIA				PS/GS.		STORE:-	
				DRG. No.		COMPT. DRG.No.	

12 ✓

DRG.No.  
TRD -1-2-2112

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Ø EXT. = 3.053-0.03  
Ø PITCH LINE = 2.45  
Ø INT. = 1.548-0.03  
MOD. = 0.35  
TEETH = 7

DEVELOPING PROFILE-MAAGSYSTEM  
GENERATING LINE ANGLE 60°  
TEETH PROFILE DRW.27406.0  
MILL N°  
TREATMENT: NICKELING.

ASSEMBLY-SEE DRW.27383.0

TEETH DETAILS  
SCALE: 20:1

MATL.-STEEL U.G.S  
HARDENED & TEMPERED.

ROCKWELL HARDNESS -40-45.

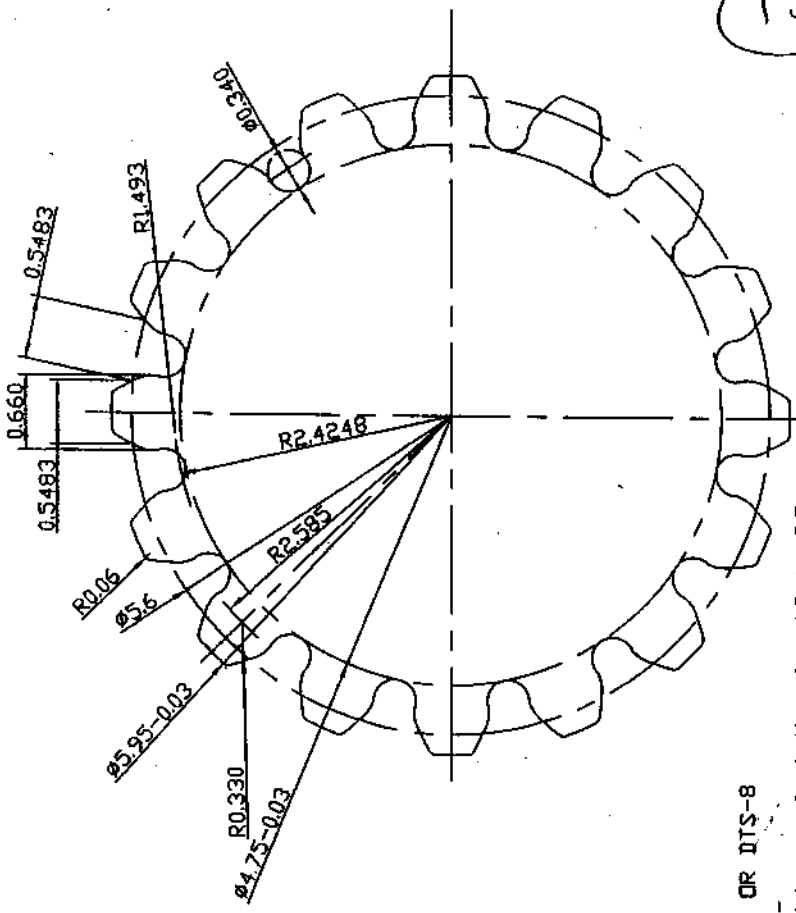
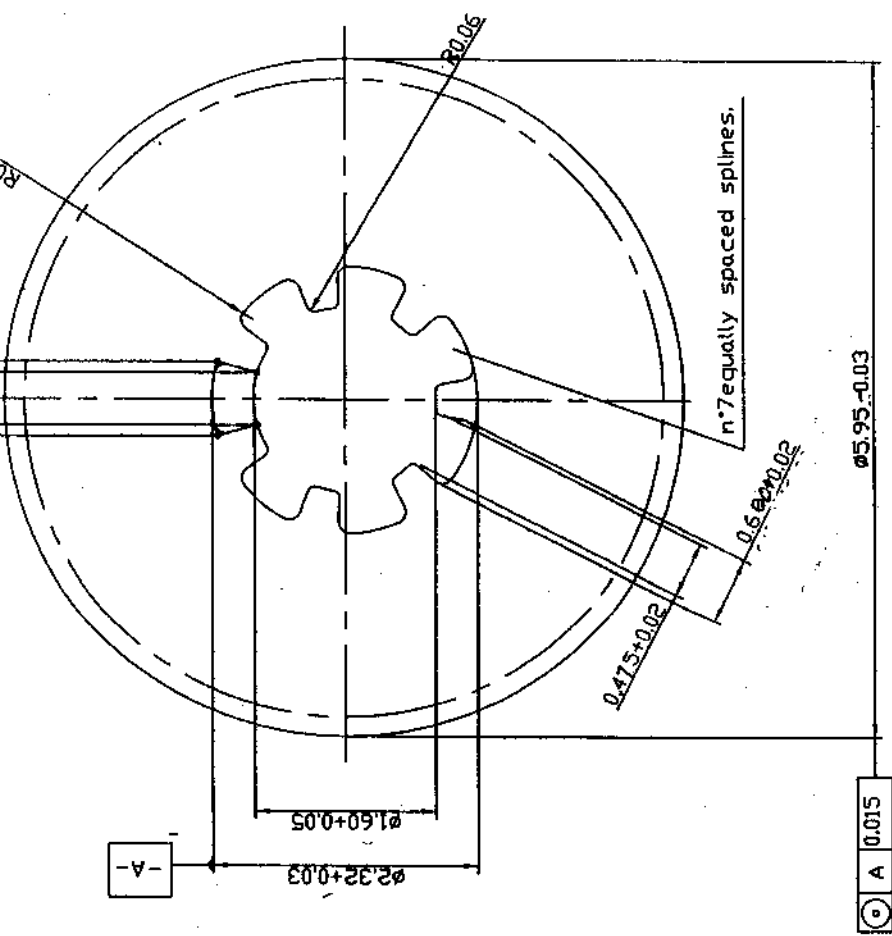
				Item No.	DESCRIPTION	No. off	MATERIAL
Insp.	Date	JWM/CDO	DA No	Heat Treatment Rc.-		PINION No.-2	
Amendments				▽ 12.5-25 Ra	▽▽ 0.2-0.8 Ra		
JWM/A3 R&D				▽▽ 1.6-6.3 Ra	▽▽▽ 0.1-0.025 Ra	M/C	
JWM/HOS CDO	DATE 19/5/06			DIMENSIONS ARE IN mm.		Drg. No.	
CKD	CKD			UNTOL. DIMNS. IS:2102 MEDIUM		TRD -1-2-2112	
DRN - JPS	TRD			SHARP EDGES TO BE REMOVED		Scale 10:1, (20:1)	
Approved by				ORDNANCE FACTORY KHAMARIA		No. of sheets - 1 Sheet No. - 1	
PS/GS.				STORE FB-40 Drg.No.		Compt. Drg.No.	

1. NO. 1 - 2 - 2 - 2122

MAJ. on the edge

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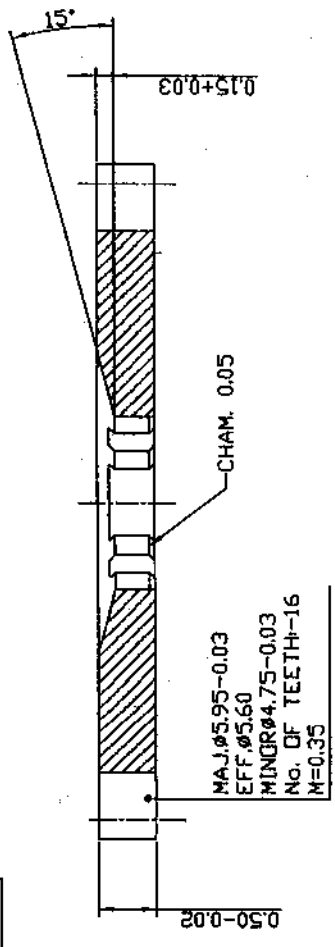
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MAT. - steel U.G.S. OR ITS-8  
PROTECTIVE FINISH-  
chemical nicking thickness of plating from 1.3 to 2.5

DETAIL OF TEETH  
SCALE:-20:1

13



Item No.	Description	No. off	Material
	Heat Treatment RC.-		GEAR n° 1
	▽ 12.5-25 Ra VVV 0.2-0.8 Ra		
	▽ 1.6-6.3 Ra VVVV 0.1-0.025 Ra		
DIMENSIONS ARE IN mm.			
UNTOL. DIMNS. IS:2102 MEDIUM			
SHARP EDGES TO BE REMOVED			
Gauging surfaces shown by thick line			
ORDNANCE FACTORY KHAMARIA			
No. of sheets - 1			
Sheet No. -			

Insp. Date	JWM/ CDD	DA No	Heat Treatment

Amendments	DRN	RRK	TRD
JWM/BJR			

HOS/ CDD	DATE	19	15	10

CKD	CKD

Drng. No.	TRD
	2-2-2122

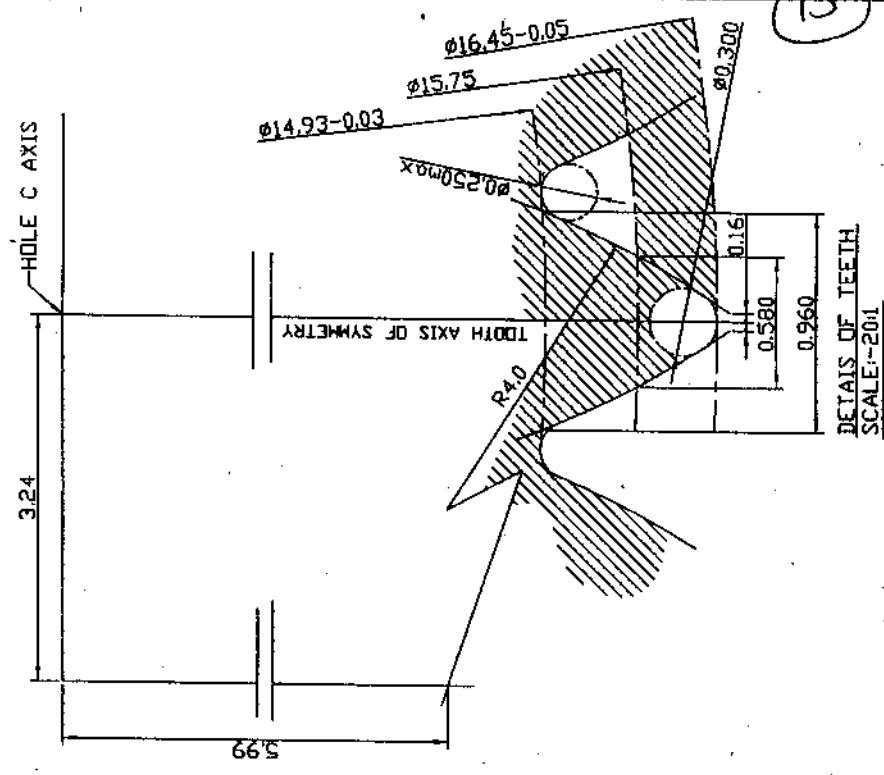
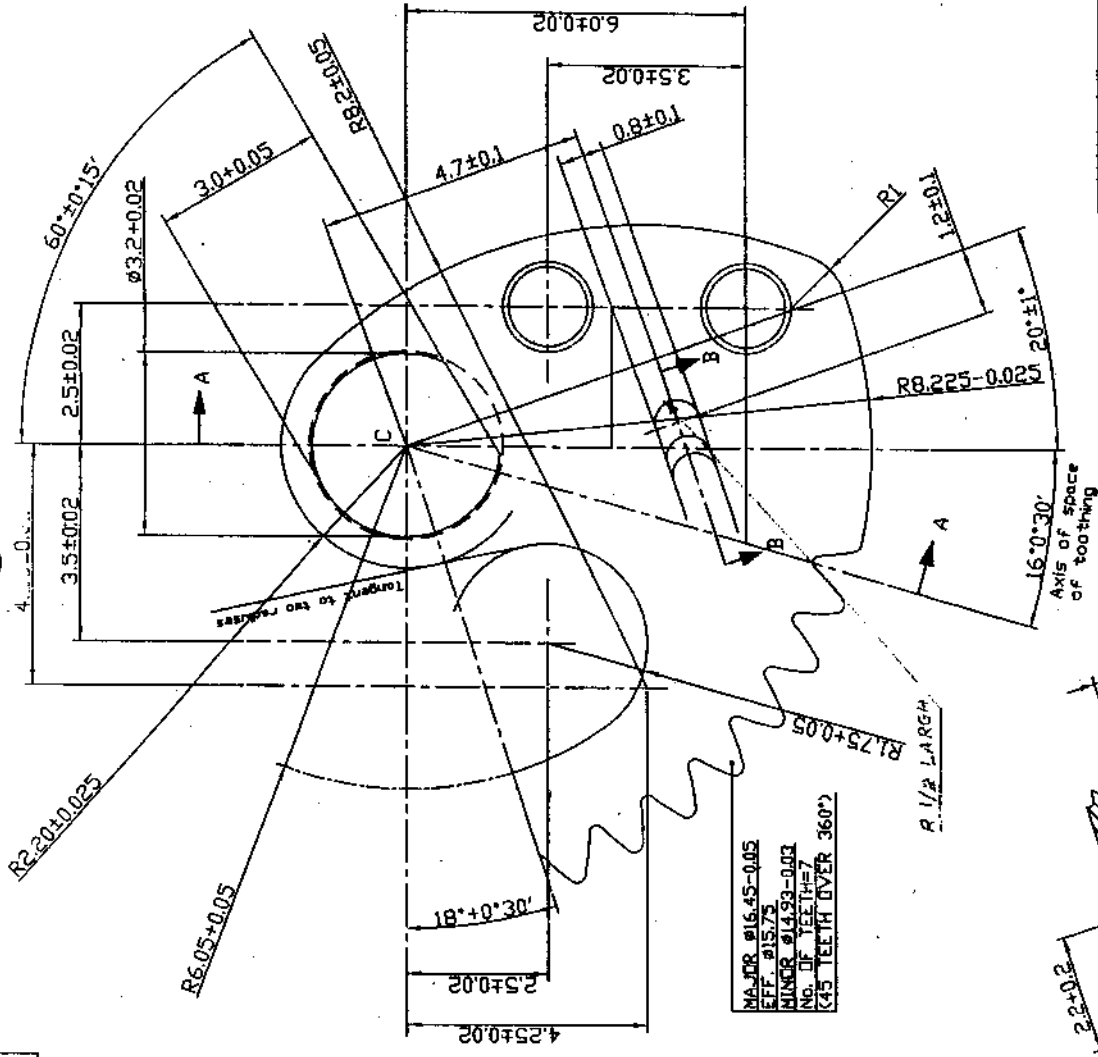
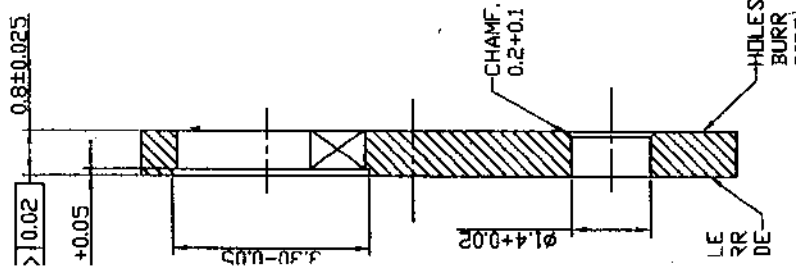
  

Scale
20:1

ES-1 REMOVE ALL BURRS

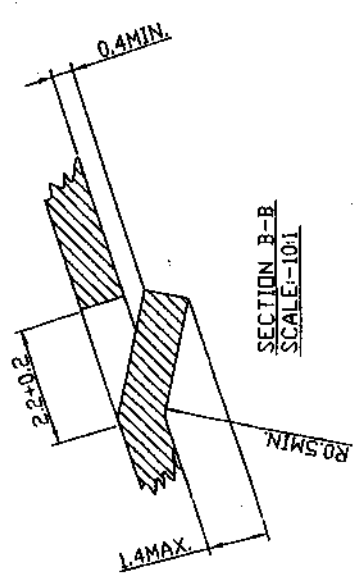


NO. 2-2-2115



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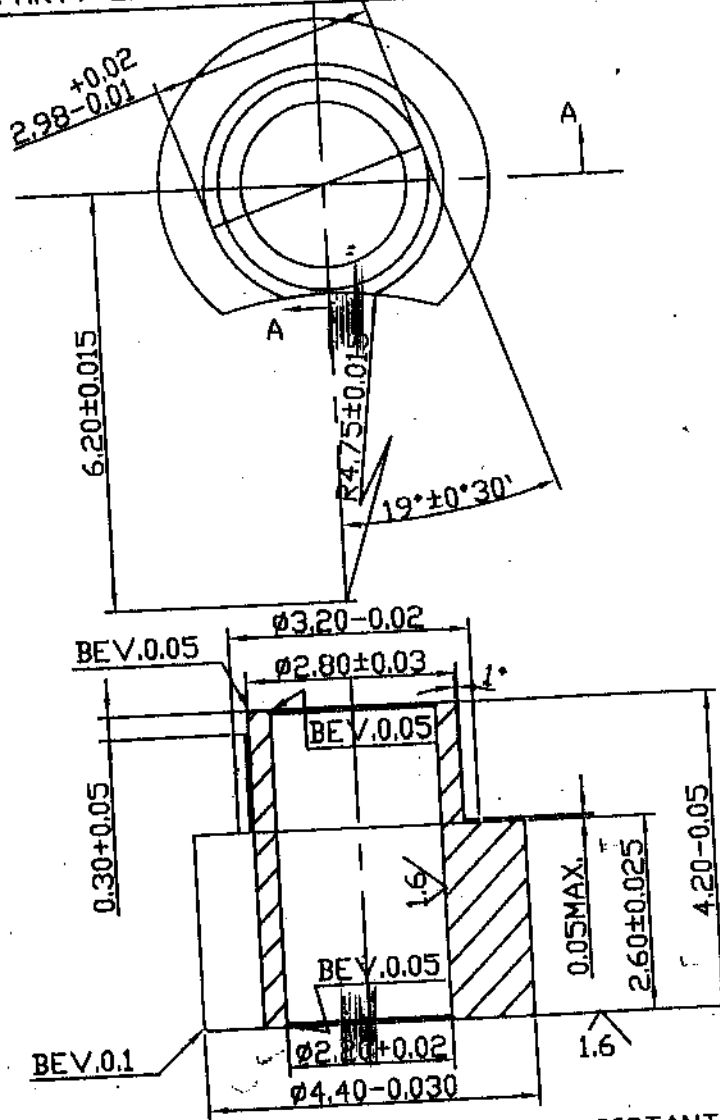
Item No.	DESCRIPTION	Material
	Heat Treatment Rc:-	SECTOR GEAR
	$\nabla$ 12.5-25 Ra $\nabla \nabla \nabla$ 0.2-0.8 Ra	M/C
	$\nabla$ 1.6-6.3 Ra $\nabla \nabla \nabla$ 01-0.025 Ra	
	DIMENSIONS ARE IN mm.	
	UNTL. DIMNS. IS:2102 MEDIUM	
	SHARP EDGES TO BE REMOVED	
	Gauging surfaces shown by thick line	
	ORDNANCE FACTORY KHAMARIA	
	No. of Sheets - 1	
	Scale 10:1 & 20:1	
	TRD :- 2-2-2115	
	Dr. No.	



MATERIAL - COPPER BERYLLIUM ALLOY BERYLCO 25 COND. A  
 REMOVE ALL RIBBS AND SHARP EDGES

DRG.No.  
TRD -1-2-2116

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USE. IT MUST NOT BE REPRODUCED/DISCLOSED TO ANY THIRD  
PARTY OR USED FOR AND CIVIL PURPOSE.



MATL-HIGH MACHINABILITY STAINLESS STEEL, HEAT RESISTANT,  
TYPE 303 OR 303 Se OR 416 OR 416 Se, SPEC. ASTM-A581.  
C (MAX)-0.15, Mn-1.25, P-0.06, S-0.15 MIN., Si-10 MAX, Cr-12-14  
INTERMEDIATE TEMPER (T)

NOTES:- 1- EDGES WITH NO BURRS.  
2-FINISHING 3.2 GENERAL.

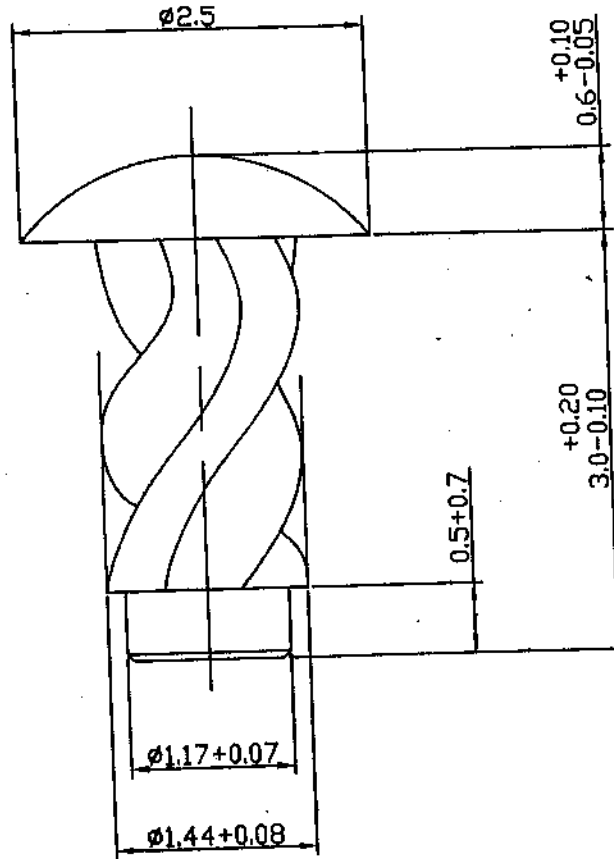
				Item No.	DESCRIPTION	No. off	MATERIAL
Insp.	Date	JWM/CDO	DA No	Heat Treatment Rc.-		BUSH	
Amendments				▽ 12.5-25 Ra	▽▽▽ 0.2-0.8 Ra		
JWM/A3	<i>[Signature]</i>	<i>[Signature]</i>		▽▽ 16-613 Ra	▽▽▽▽ 0.1-0.025 Ra	Drp. No.	
JWM/HOS	<i>[Signature]</i>	DATE	19/5/06	DIMENSIONS ARE IN mm.		TRD - 1-2-2116	
CKD	<i>[Signature]</i>	CKD		UNTOL. DIMNS, IS:2102 MEDIUM		Scale-1	
DRN R.R.	TRD			SHARP EDGES TO BE REMOVED		No. of sheets -	
Approved by				Gauging surfaces shown by thick line		Sheet No. -	
PS/GS.				ORDNANCE FACTORY KHAMARIA		Compt.	
STORE						Drp.No.,	

DRG.No.

TRD-1-2-2102

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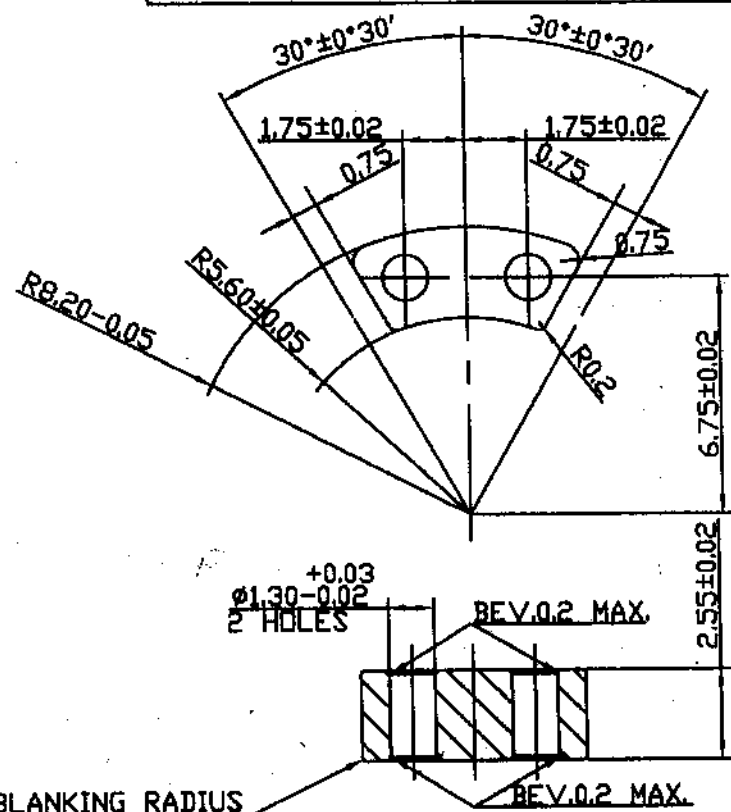
NOTE:-

1-SELF-THREADING RIVETS FROM SIREA Co.-TYPE 00 M

				Item No.	DESCRIPTION	No. off	MATERIAL
Insp.	Date	JWM/ CAD	DA No	Heat Treatment Rc.-		SELF THREADING RIVET	
Amendments				▽ 12.5-25 Ra	▽▽▽ 0.2-0.8 Ra	M/C	
JWM/ <i>AS</i>		AWM/ <i>AS</i>		▽▽ 1.6-6.3 Ra	▽▽▽▽ 0.1-0.025 Ra	Drg. No. TRD-1-2-2102	
HOS/ CAD <i>VTS</i>	DATE	19/5/06		DIMENSIONS ARE IN mm.		Scale-20:1	
CKD <i>Stodi</i>	CKD			UNTOL. DIMNS. IS2102 MEDIUM		No. of sheets - 01	
DRN <i>ASE</i>	TRD			SHARP EDGES TO BE REMOVED		Sheet No. - 01	
Approved by AAIW (KH)				ORDNANCE FACTORY KHAMARIA		Compt.-	
PS/GS.				Store :-		Drg.No.-	
				Drg.No.-			

DRG.No.  
TRD -1-2-2104

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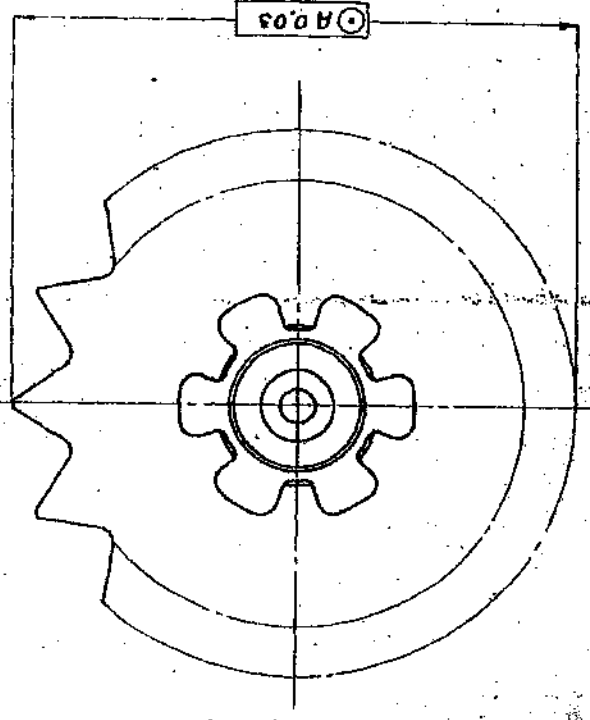
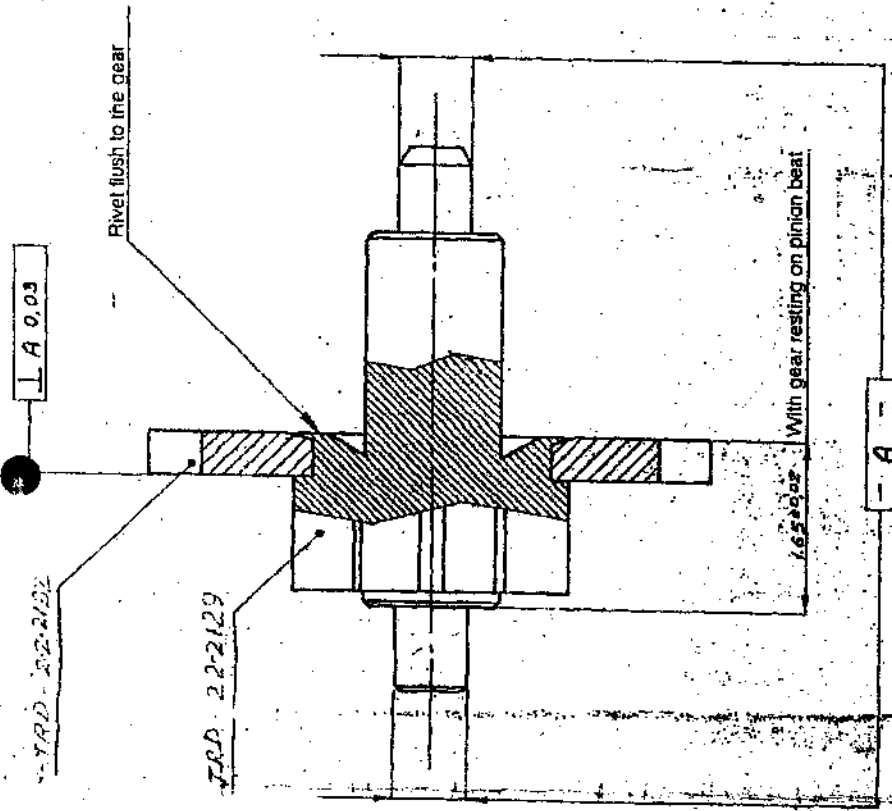


MATL - BRASS FOR FORGING.  
NOCKLE COATING THICKNESS-1.3 TO 2.5 μ

- NOTES-  
1-REMOVE ALL THE BURRS.  
2-DIMENSIONS REFER TO TREATED PART.

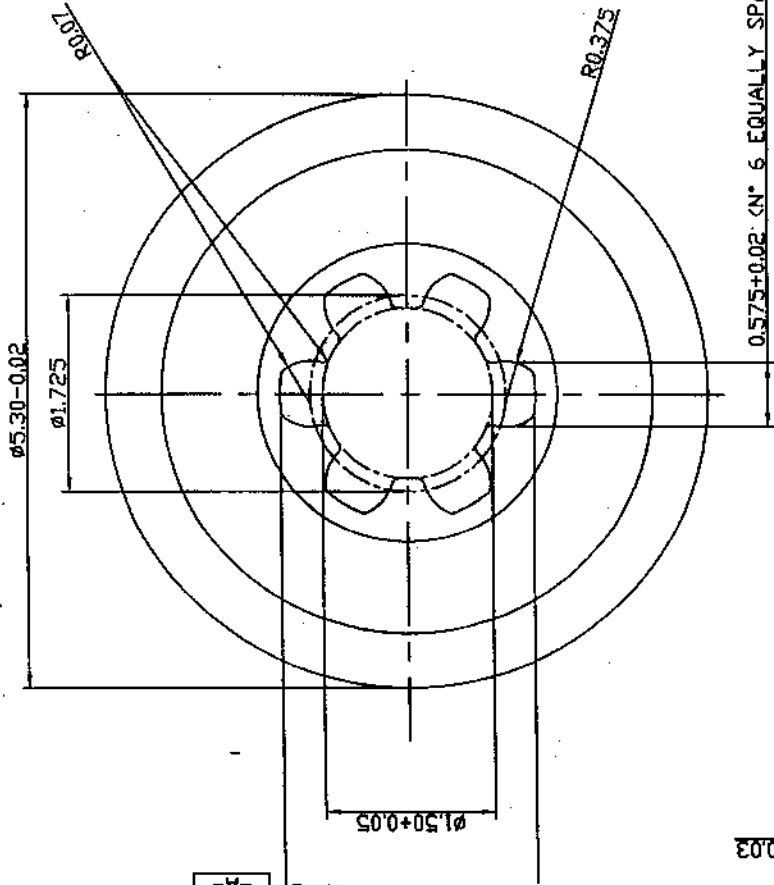
				Item No.	DESCRIPTION	No. off	MATERIAL
Insp.	Date	JWM/CDD	DA No	Heat Treatment Rc.-		MASS	
Amendments				▽ 12.5-25 Ra	▽▽▽ 0.2-0.8 Ra		
JWM/AS		[Signature]		▽ 1.6-6.3 Ra	▽▽▽▽ 0.1-0.025 Ra	Drg. No.	
JWM/HDS		DATE 19/5/02		DIMENSIONS ARE IN mm.		TRD - 1 - 2 - 2104	
CKD		CKD.		UNTOL. DIMNS. IS:2102 MEDIUM		Scale - 5:1	
DRN R.R.		TRD		SHARP EDGES TO BE REMOVED		No. of sheets - 1	
Approved by				ORDNANCE FACTORY KHAMARIA		Sheet No. - 1	
PS/GS.				STORE		Compt.	
				Drg.No.		Drg.No.	

15

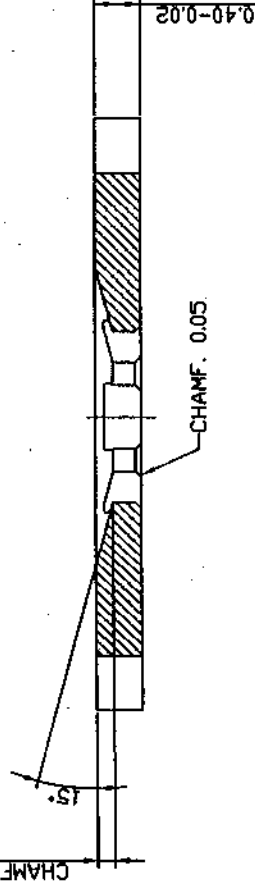


ITEM No.	DESCRIPTION	MATERIAL
	HEAT TREATMENT Rc	PINION AND ESCAPEMENT GEAR ASSY
	0.2-25 Rc $\nabla$ 0.2-4.8 Rc	M/C
	1.6-6.3 Rc $\nabla$ 0.1-0.25 Rc	DRG. No. TRD-2-2-2126
	DIMENSIONS ARE IN mm.	1ST ANGLE PROJECTION SCALE:-
	UNTIL DIMS. IS:2102 MEDIUM	No. OF SHT. -
	SHARP EDGES TO BE REMOVED	SHEET No. -
	GALVANIZING SURFACES SHOWN BY THICK LINES	
	ORDNANCE FACTORY KHANNA	
INSP. DATE	DA No.	
HOS/ CDO		
AMENDMENTS		
JMM/BS/2		
HOS/ CAD/C	DATE 19/5/86	
CKD	CKD	
DRN	TRD	
APPROVED BY	ORDNANCE FACTORY KHANNA	
PS/GS	STORE	COMPT -
	DRG. No.	DRGNG.

3. NO. 2-2-2/32

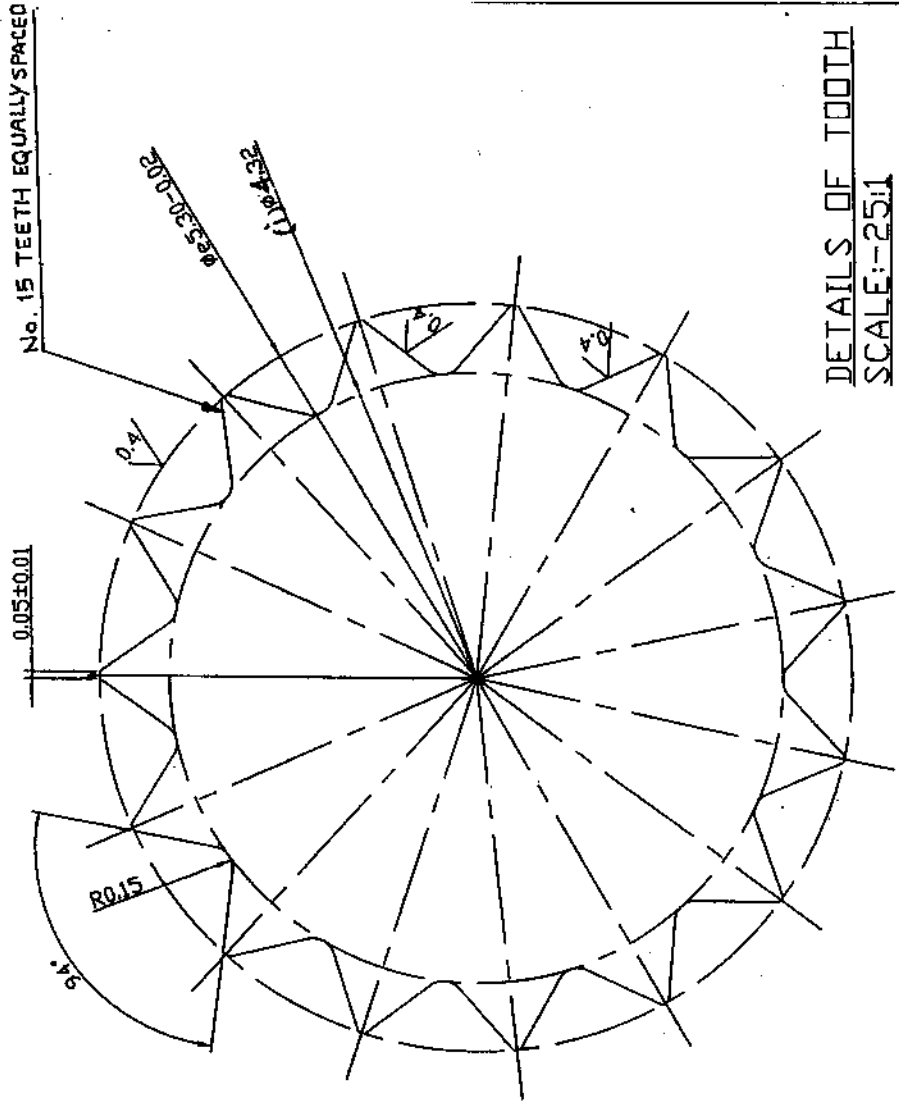


0.575 ± 0.02 (N° 6 EQUALLY SPACED SPLINES)



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DETAILS OF TOOTH  
SCALE: - 25:1

Item No.	DESCRIPTION	No. off	MATERIAL
	Heat Treatment Rc:-		ESCAPEMENT GEAR
	▽ 12.5-25 Ra	▽▽	M/C
	▽ 1.6-6.3 Ra	▽▽▽	
DIMENSIONS ARE IN mm.			
UNTOL. DIMNS. IS2102 MEDIUM			
SHARP EDGES TO BE REMOVED			
Gauging surfaces shown by thick line			
Insp. Date	JWM/CDD	DA No	
Amendments			
JWM/03/05			
HOS/Upditch	DATE 19/5/06		
CKD	CKD		
DRN- alok	TRD		
ORDNANCE FACTORY KHAMARIA Sheet No. - 1			
No. of sheets - 1			

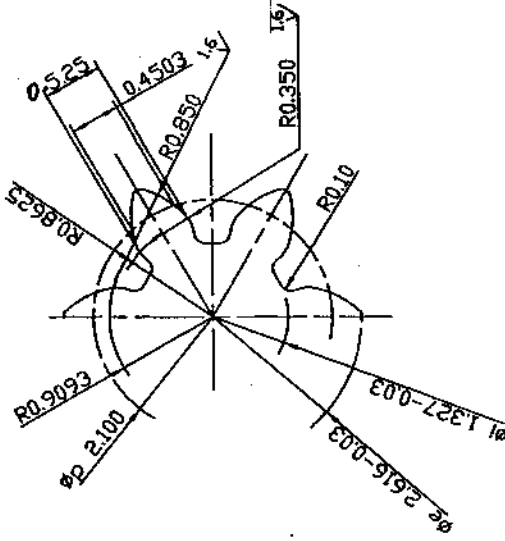
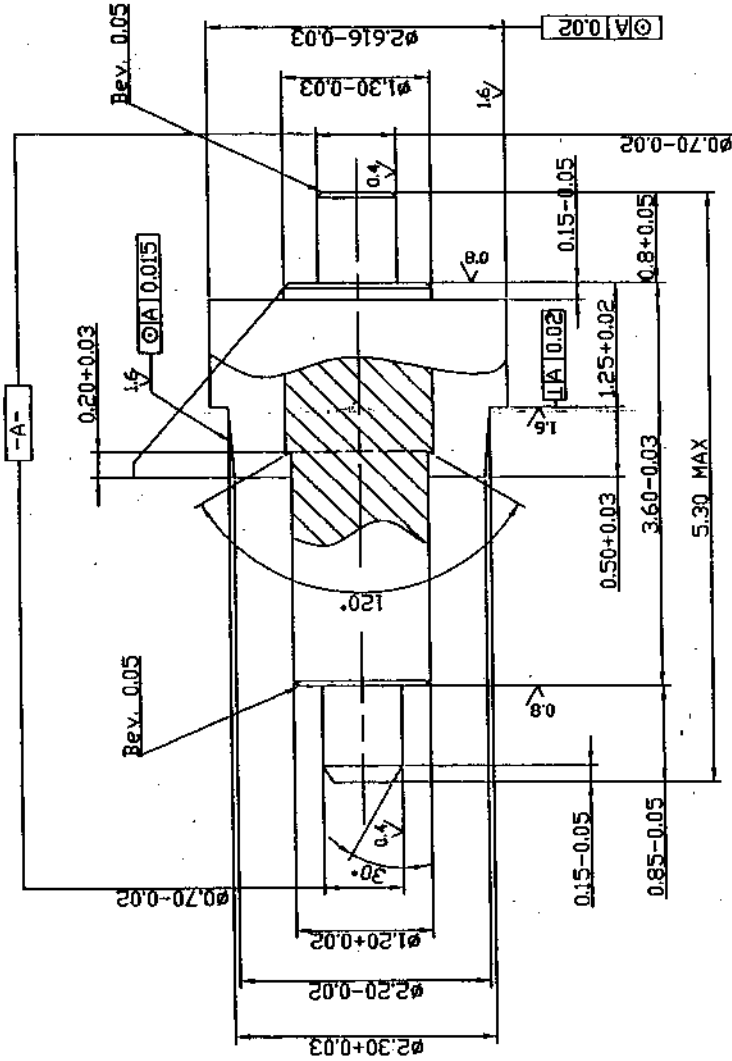
- S:-
- 1) REMOVE ALL BURRS.
  - 2) MATERIAL - SHEET U.G.S. DR DTS-8
  - 3) HEAT TREAT (HARDEN AND TEMP.) TO OBTAIN A Rc:- 40-45

TRD- 2-2-2/29

SAD

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øe 2.616-0.03  
 øp 2.10  
 øl 1.327-0.03  
 M 0.35  
 Z 6



TOOTHING PROFILE SCALE 20:1

NOTES:-

- 1-FINISHING 1.3 GENERAL EXCEPT WHERE DIFFERENTLY INDICATED.
- 2-HEAT TREAT(HARDEN & TEMP) TO OBTAIN A ROCKWELL HARDNESS HRC 40-45
- 3-REMOVE ALL BURRS.

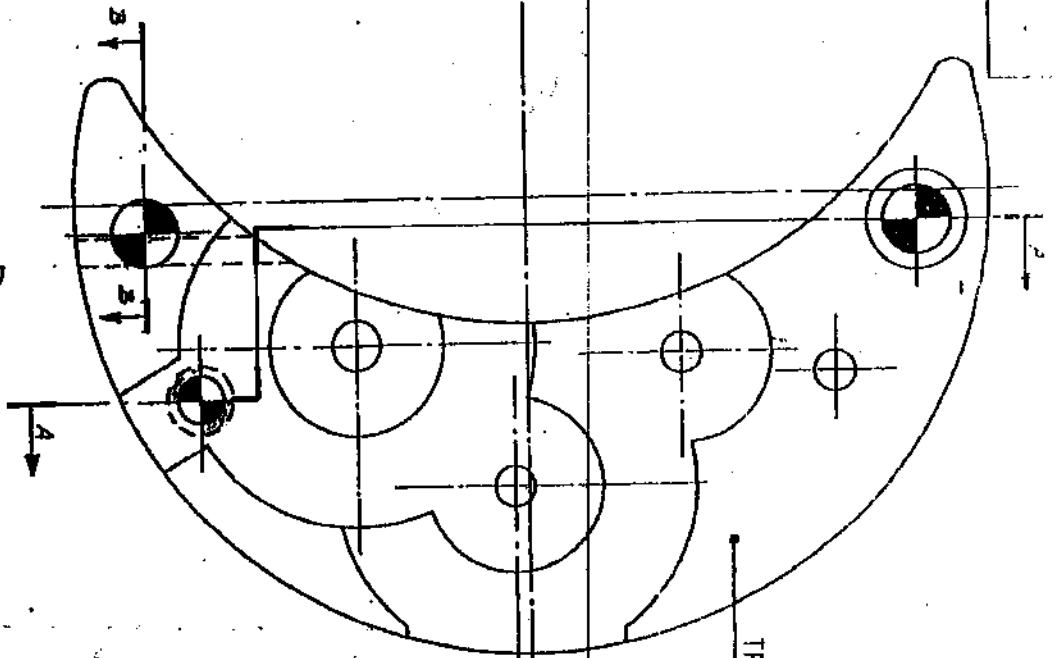
MAT. P.A. UGS OR DTS B

Item No.	Description	No. off	Material
	Heat Treatment Rc:-		ESCAPEMENT PINION
▽ 125-25 Ra	▽▽ 0.2-0.8 Ra		
▽ 1.6-6.3 Ra	▽▽ 0.1-0.025 Ra	M/C	
DIMENSIONS ARE IN mm.			
UNTOL. DIMNS. IS:2102 MEDIUM			
SHARP EDGES TO BE REMOVED			
Gauging surfaces shown by thick line			
ORDNANCE FACTORY KHAMARIA			
Approved by AAV (H)		No. of sheets - 01	
PS/GS.		Sheet No. - 01	
Store :-		Compt:-	

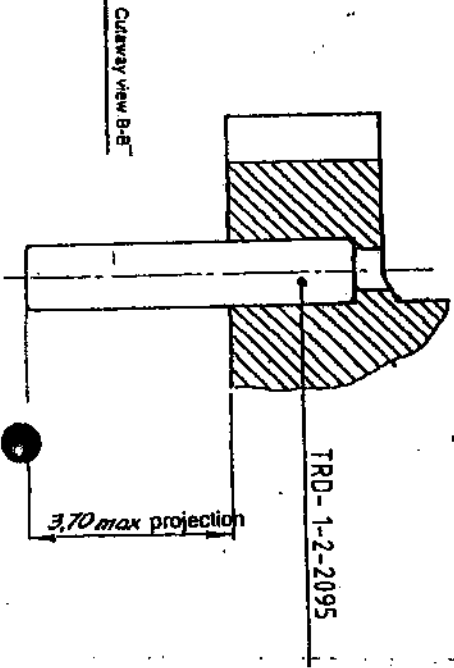
Drg. No. TRD-2-2-2/29  
 Scale: 20:1  
 No. of sheets - 01  
 Sheet No. - 01

TRD-2-2-2133

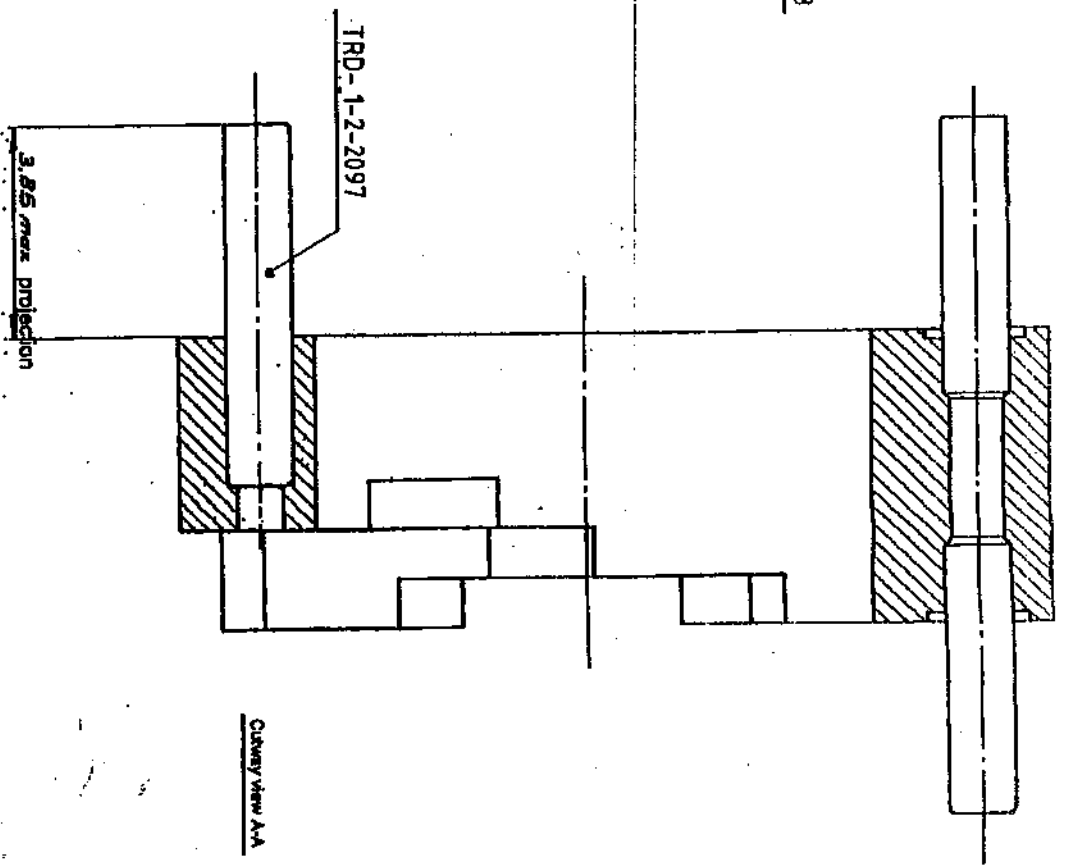
(22)



TRD-3-2-2128



TRD-1-2-2095



TRD-1-2-2097

Clearway view A-A

ITEM No.	DESCRIPTION	HEAT TREATMENT R.C.	DATE	BY	CHKD	DATE	BY
1	WHEEL WORK HOLDER BODY PINS ASSEMBLY	22-28 IN	1-2-2095	TRD	TRD	1-2-2095	TRD
2		14-44 IN					
3		14-44 IN					
4		14-44 IN					
5		14-44 IN					
6		14-44 IN					
7		14-44 IN					
8		14-44 IN					
9		14-44 IN					
10		14-44 IN					
11		14-44 IN					
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97		14-44 IN					
98		14-44 IN					
99		14-44 IN					
100		14-44 IN					

WHEEL WORK HOLDER BODY PINS ASSEMBLY

TRD-2-2-2133

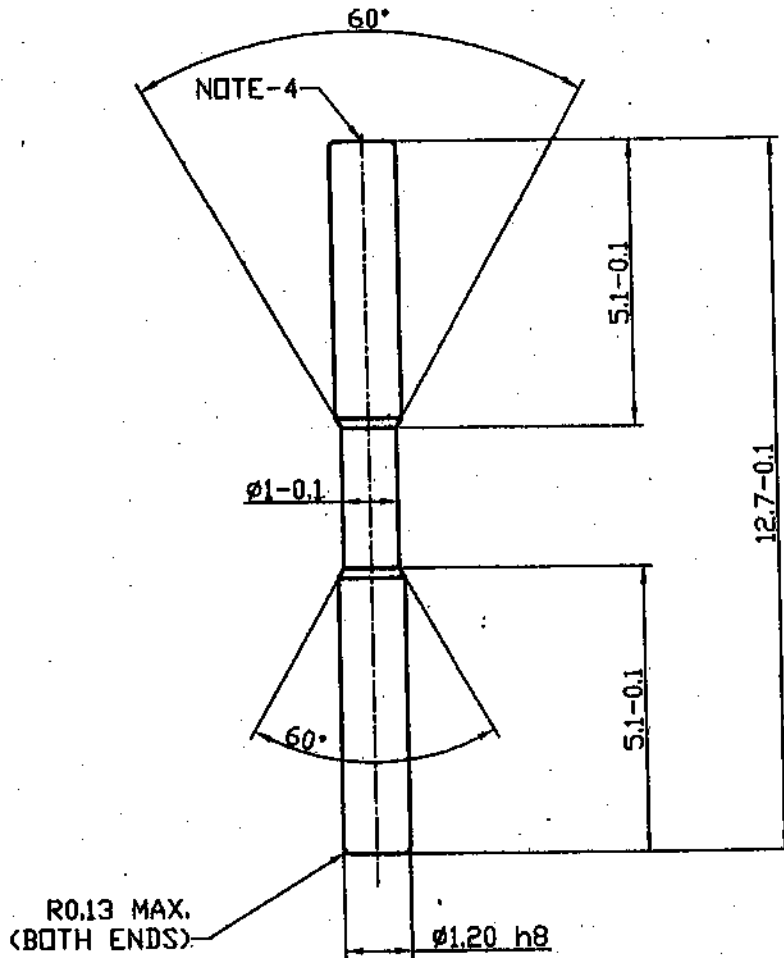
1ST ANGLE PROJECTION SCALE-

NO. OF SHIT.

DRG.No. TRD-  
122275

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- NOTE: 1-MATERIAL: CORROSION PROOF STEEL, COLD ROLLED, CLASS 416, COND.T, SPEC. ASTM-A581.  
 2-FINISHING 1,6 GENERAL.  
 3-PROTECTIVE FINISHING: FINISHING n° 5.4.1 OF SPEC. MIL-STD-171.  
 4-PARTING-OFF PINS NOT ALLOWED.

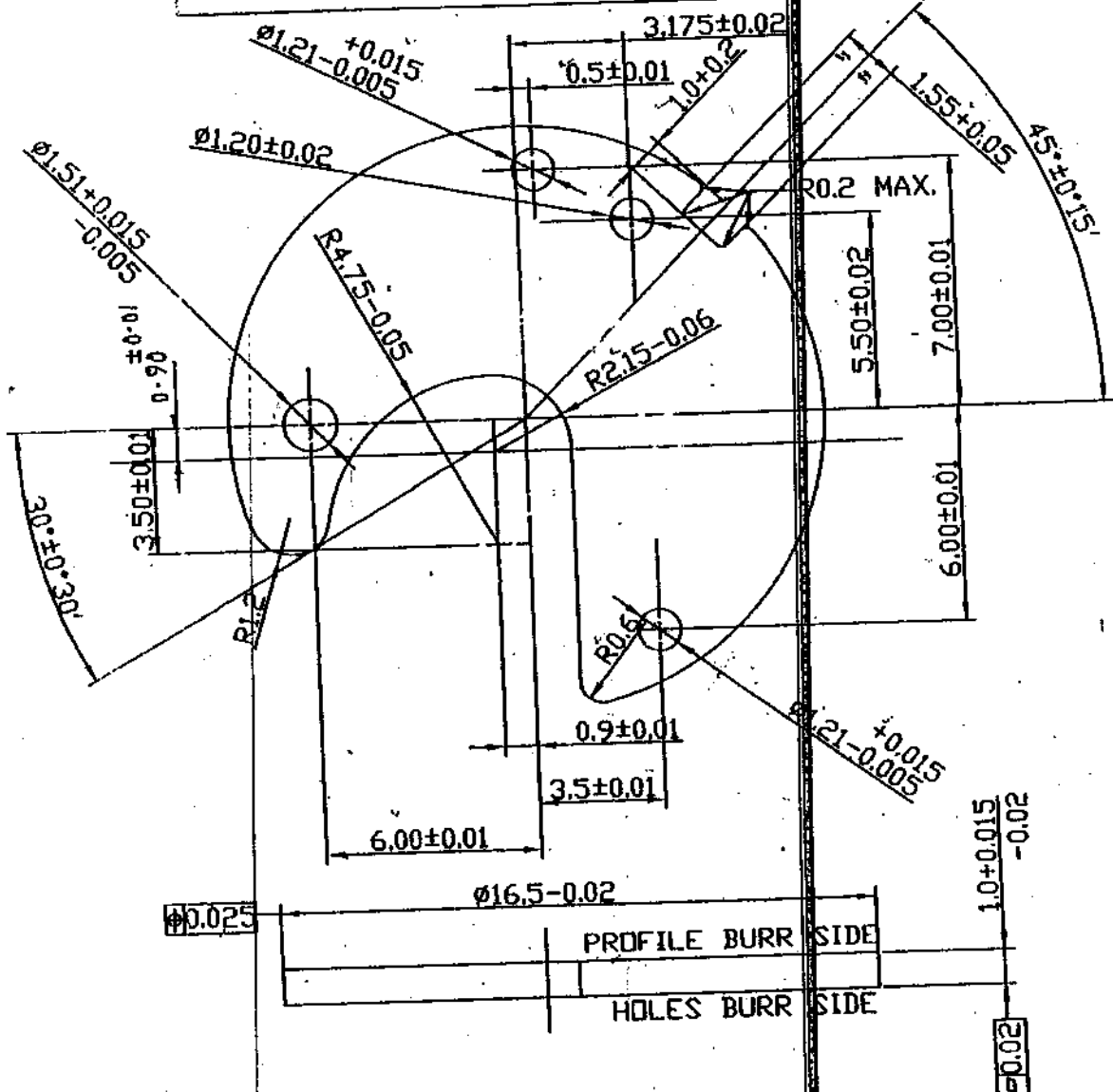
				Item No.	DESCRIPTION	No. OFF	MATERIAL
INSP.	Date	JWM/CDO	DA No	Heat Treatment Rc.-		PIN	
Amendments				▽ 12.5-25 Ra	▽▽ 0.2-0.8 Ra		
JWM/AIR				▽▽ 1.6-6.3 Ra	▽▽▽ 0.1-0.025 Ra	M/C	
HOS/CDO		DATE 24.9.07		DIMENSIONS ARE IN mm.		DRG.No.	
CKD		CKD		UNTOL. DIMNS. IS:2102 MEDIUM		TRD- 122275	
DRN OPY.		TRD		SHARP EDGES TO BE REMOVED		SCALE: 1-10:1	
APPROVED BY <i>Amir K...</i> AWM/P				ORDNANCE FACTORY KHAMARIA.		No. of sheets - 01 Sheet No. - 01	
PS/GS.				STORE- 40 mm PFEC		COMPT.	
				DRG.No.		DRG.No.	



DRG.No.  
TRD -1-2-2114

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NOTE-REMOVE ALL BURRS.

MATL-ALLOY P-Cu Zn 37 UNI 4892-H10  
ALTERNATIVE MATL-BRASS  
ASTM-B-360 MP.268R=42 Kg/mm<sup>2</sup>

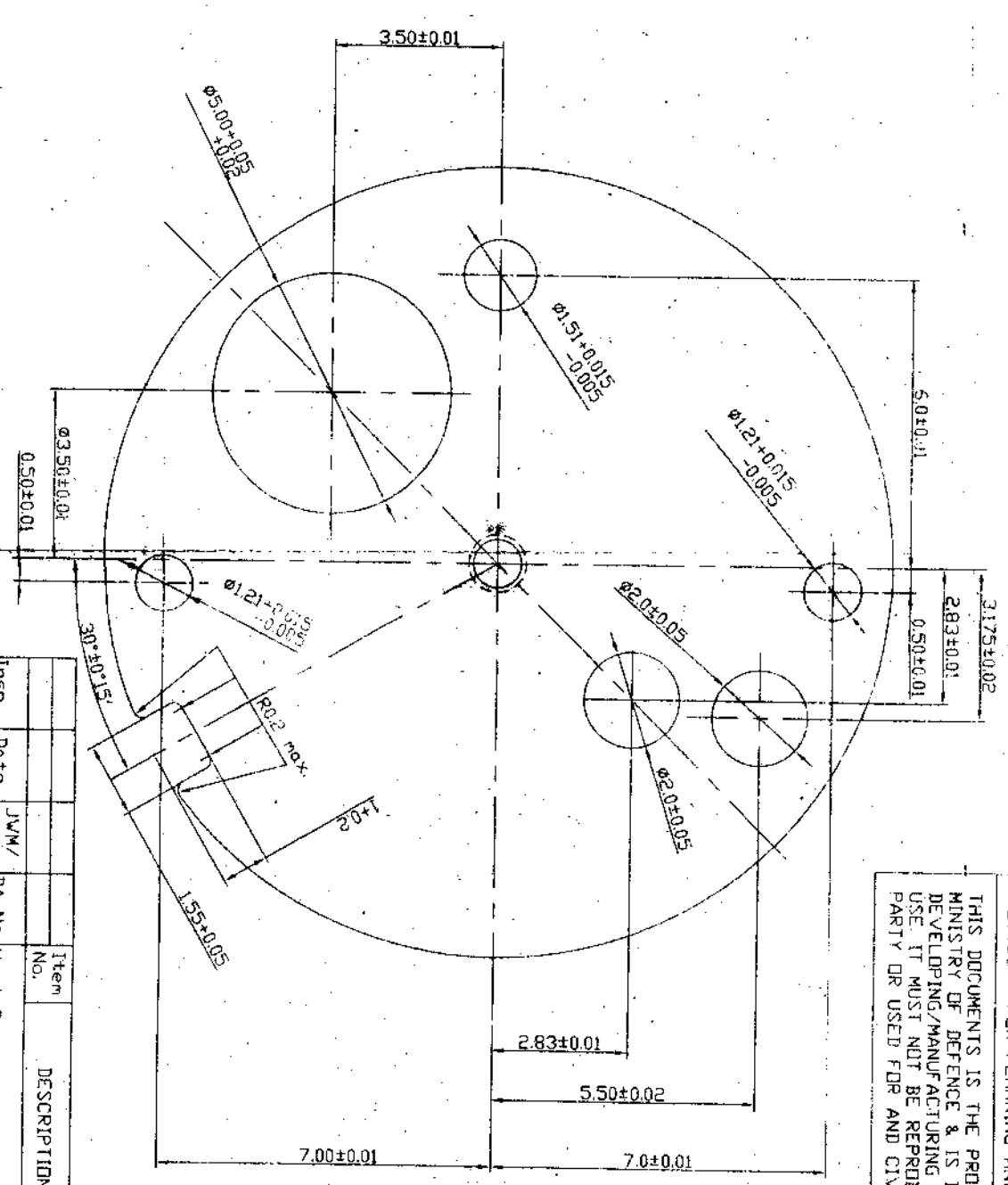
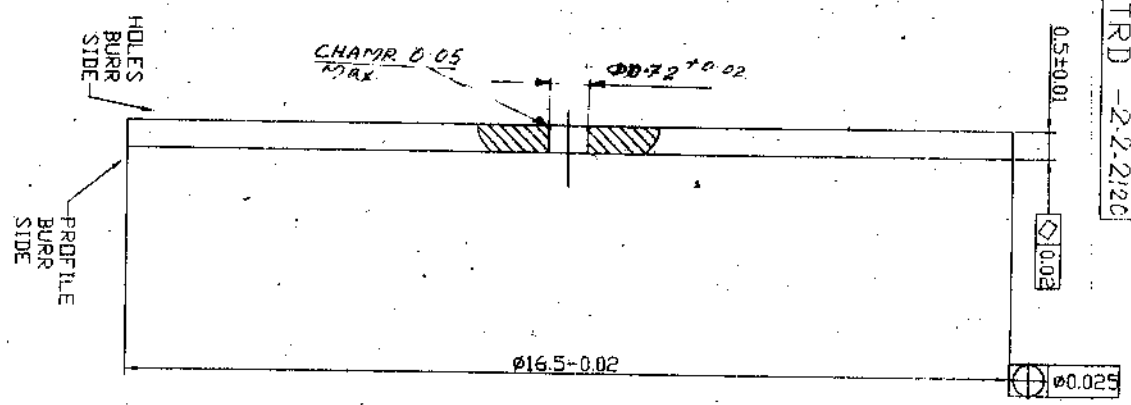
				Item No.	DESCRIPTION	No. off	MATERIAL
Insp.	Date	JWM/CDD	DA No	Heat Treatment Rc.-		PLATE 2	
Amendments				▽ 12.5-25 Ra	▽▽▽ 0.2-0.8 Ra	M/C	
JWM/A3	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>	▽ 1.6-6.3 Ra	▽▽▽ 0.1-0.025 Ra	Drg. No.	
JWM/HQS	<i>[Signature]</i>	DATE	19/5/02	DIMENSIONS ARE IN mm.		TRD - 1-2-2114	
CKD	<i>[Signature]</i>	CKD.		UNTOL. DIMNS. IS:2102 MEDIUM		Scale - 5:1	
DRN. R.R.	TRD.			SHARP EDGES TO BE REMOVED		No. of sheets - 1	
Approved by				ORDNANCE FACTORY KHAMARI		Sheet No. - 1	
PS/GS.				STORE		Compt.	







DRG NO  
TRD -2-2-2120



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NOTES:-  
1) REMOVE ALL BURRS  
2) MATERIAL - ALLOY P-Cu Zn 37 UNI 4892-H10  
ALTERNATIVE MATERIAL - BRASS ASTM-B-36 COMP 268 R-42 Kg/mm<sup>2</sup>

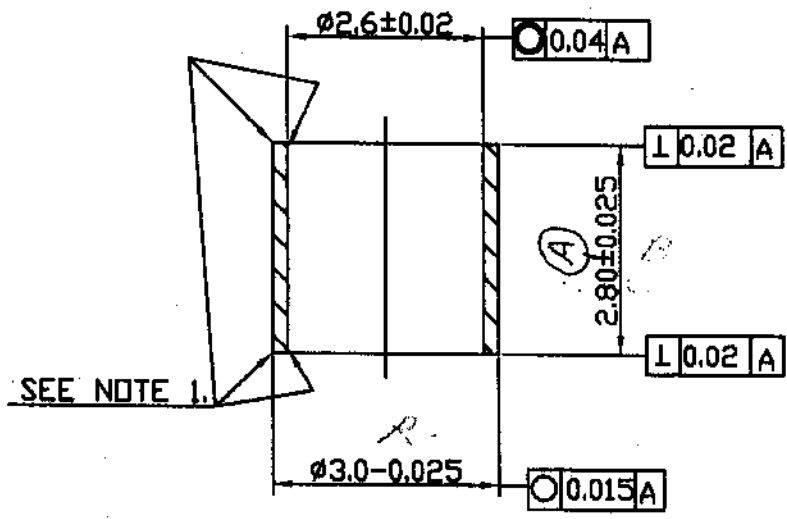
Item No.	DESCRIPTION	No.	MATERIAL
	Heat Treatment Rc		PLATE-6
Amendments			
Insp. Date	JVM/ CDD	DA No.	
JVM/AS	16/11/01		
HOS/	DATE 14/1/01		
CDD	CKD		
CKD	TRD		
DRN	TRD		
SHARP EDGES TO BE REMOVED			
Gauging surfaces shown by thick line			
DRDNANCE FACTORY KHAMARIA			
Approved by		Store	
PS/GS			
No. of Sheets		1	
Sheet No.		1	
Drg. No.		TRD -2-2-2120	
Scale		10:1	
M/C			
DIMENSIONS ARE IN mm			
UNTIL DIMS. IS/ISIDE MEDIUM			
▽ 16-63 Ra			
▽ 0.1-0.025 Ra			
▽ 0.2-0.8 Ra			
▽ 125-25 Ra			





DRG.No.  
TRD -1-2-2103

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MATL-STAINLESS STEEL TUBE AISI 304 OR STAINLESS STEEL ROD HEAT-RESISTANT TYPE 303 COND. B SPEC. ASTM-A581. C-0.15 MAX.,Mn-2.0,P-0.2 MAX.,S-0.15,SI-1.0 MAX.,Cr-17-19.

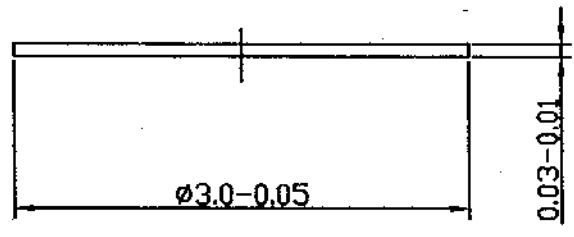
- NOTES:-  
 1- EDGES WITH NO BURRS, ALLOWED R0.5 MAX.OR BEV0.05 MAX.  
 2-FINISHING 3.2 GENERAL.

				Item No.	DESCRIPTION	No. off	MATERIAL
Insp.	Date	JWM/CDD	DA No	Heat Treatment Rc.-		TUBE	
Amendments				▽ 12.5-25 Ra	▽▽▽ 0.2-0.8 Ra		
JWM/A3				▽▽ 1.6-6.3 Ra	▽▽▽▽ 0.1-0.025 Ra	M/C	
JWM/HOS				DIMENSIONS ARE IN mm.		Drg. No.	
CKD			DATE 19/5/06	UNTOL. DIMNS. IS:2102 MEDIUM		TRD - 1-2-2103	
DRN R.R.			CKD	SHARP EDGES TO BE REMOVED		Scale-10:1	
Approved by				Gauging surfaces shown by thick line		No. of sheets - 1	
PS/GS.				ORDNANCE FACTORY KHAMARIA		Sheet No. - 1	
STORE						Compt.	

DRG.No.  
TRD-1-2-2101

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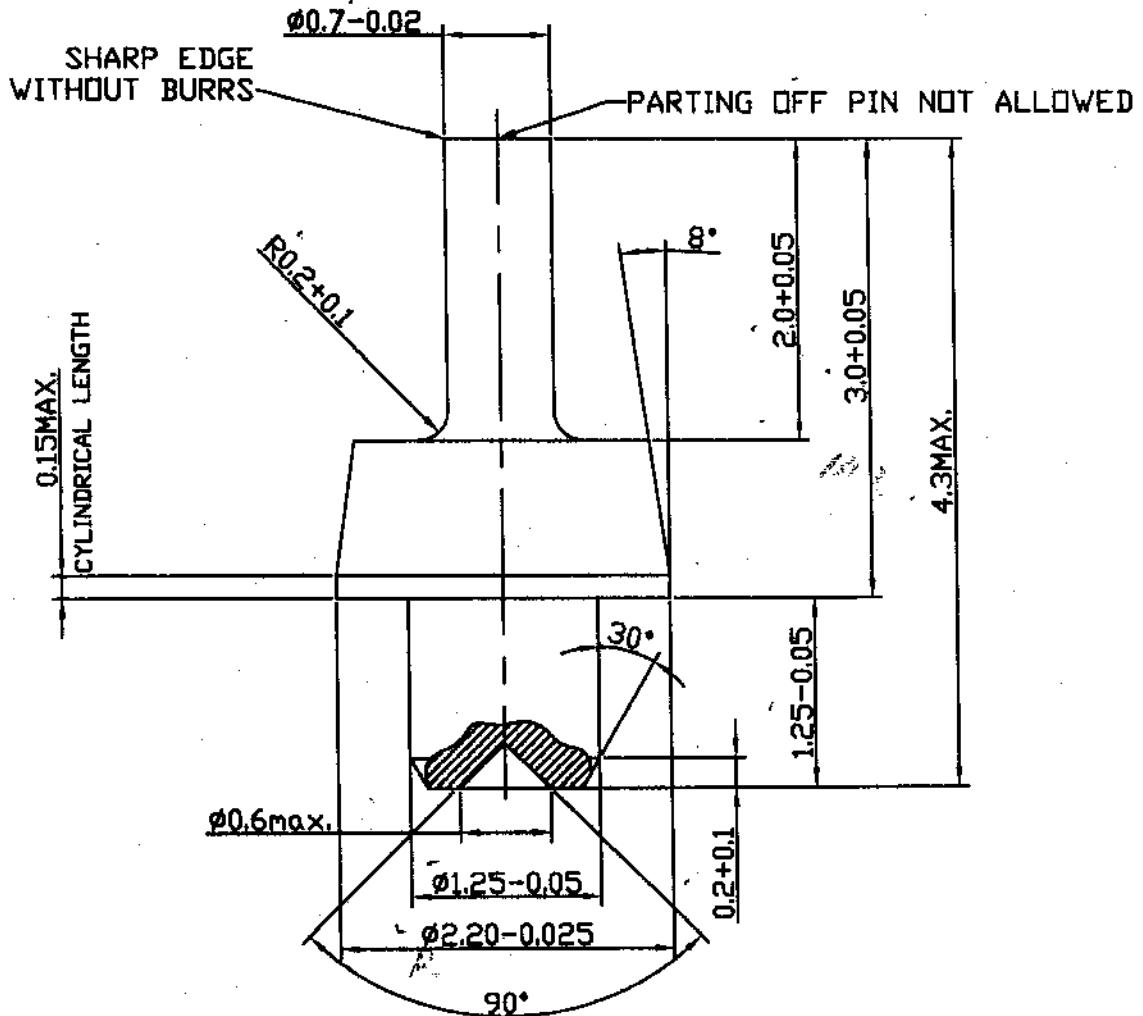
NOTES:-1) MATERIAL-COPPER ALLOY STRIP n° 210 (TOMBAC 95/5), 1/2 HARD, SPEC. MIL-C-21768  
 2)FOR DIMENSIONS CONTROL THE WORKING TOOL.  
 3)ALTERNATIVE MATERIAL-COPPER ALLOY STRIP P-CuZn20, WORK HARDNED H20 OR H30, UNI 4897.

				Item No.	DESCRIPTION	No. off	MATERIAL
Insp.	Date	JWM/CDO	DA No	Heat Treatment Rc.-		DISC	
Amendments				$\nabla$ 12.5-25 Ra $\nabla\nabla\nabla$ 0.2-0.8 Ra $\nabla\nabla$ 1.6-6.3 Ra $\nabla\nabla\nabla\nabla$ 0.1-0.025 Ra			
JWM/AS		DATE 19/5/06		DIMENSIONS ARE IN mm.		M/C	
HOS/CDO		CKD		UNTOL. DIMNS. IS:2102 MEDIUM		Drg. No.	
DRN		TRD		SHARP EDGES TO BE REMOVED		TRD :- 1-2-2101	
Approved by				Gaaging surfaces shown by thick line		Scale 20:1	
PS/GS.		Store		ORDNANCE FACTORY KHAMARIA		No. of sheets - 1	
						Sheet No. - 1	
						Compt. DISC	

DRG.No.  
TRD -1-2-2094

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MATERIAL:-CORROSION PROOF STEEL,COLD ROLLED,  
CLASS 416,COND. T, SPEC. ASTM-A581  
C (MAX)-0.15,Mn-1.25,P-0.06 S-0.15 MIN. SI MAX.-1.0,Cr-  
12-14 INTERMEDIATE TEMPER (T)

- NOTES:- 1) FINISHING 1.6 GENERAL  
2) REMOVE ALL BURRS BY TUMBLING  
3) PROTECTIVE FINISHING:-FINISHING n\*5.4.1 OF SPEC. MIL-STD-171

				Item No.	DESCRIPTION	No. off	MATERIAL
Insp.	Date	JWM/CDO	DA No	Heat Treatment Rc.-			INERTIAL PIN
Amendments				▽ 12.5-25 Ra ▽▽▽ 0.2-0.8 Ra			
JWM/AS		<i>[Signature]</i>		▽▽.16-6.3 Ra ▽▽▽▽ 0.1-0.025 Ra			M/C
HOS/CDO		DATE 19/5/06		DIMENSIONS ARE IN mm.			Drng. No.
CKD		CKD		UNTOL. DIMNS. IS:2102 MEDIUM			TRD :- 1-2-2094
DRN		TRD		SHARP EDGES TO BE REMOVED			Scale 20:1
Approved by				Gauging surfaces shown by thick line			No. of sheets - 1
PS/GS.				ORDNANCE FACTORY KHAMARIA			Sheet No. - 1
Store				Compt. INERTIAL PIN			

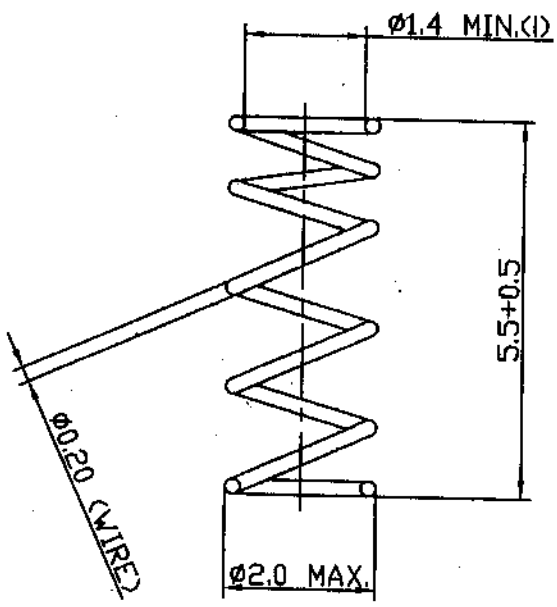
DRG.No.  
TRD - 1-2-2096

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MANUFACTURING DATA OF THE SPRING  
 No.OF TURNS 6 1/2 TOTAL  
 DIRECTION OF WINDING: ANY  
 SPRING CALIBRATION:  
 AT h=3,2 gr.120 MIN.  
 AT h=2,4 gr.200 MAX.  
 SPRING HEIGHT AT END OF STROKE 1,4 MAX.

TAKE NOTE OF LOADS AFTER COMPRESSION OF THE SPRING FOR 24 HOURS WITH A 2,4 mm STROKE.



MATERIAL: 1-NICKEL CHROME STEEL WIRE CORROSION PROOF HEAT-PROOF TYPE 302, SPEC ASTM-A 313.  
 C-0.15, Mn-2.0, P-0.045, Si-0.03, Cr17/19, Ni-8/10, OTHER N-0.10

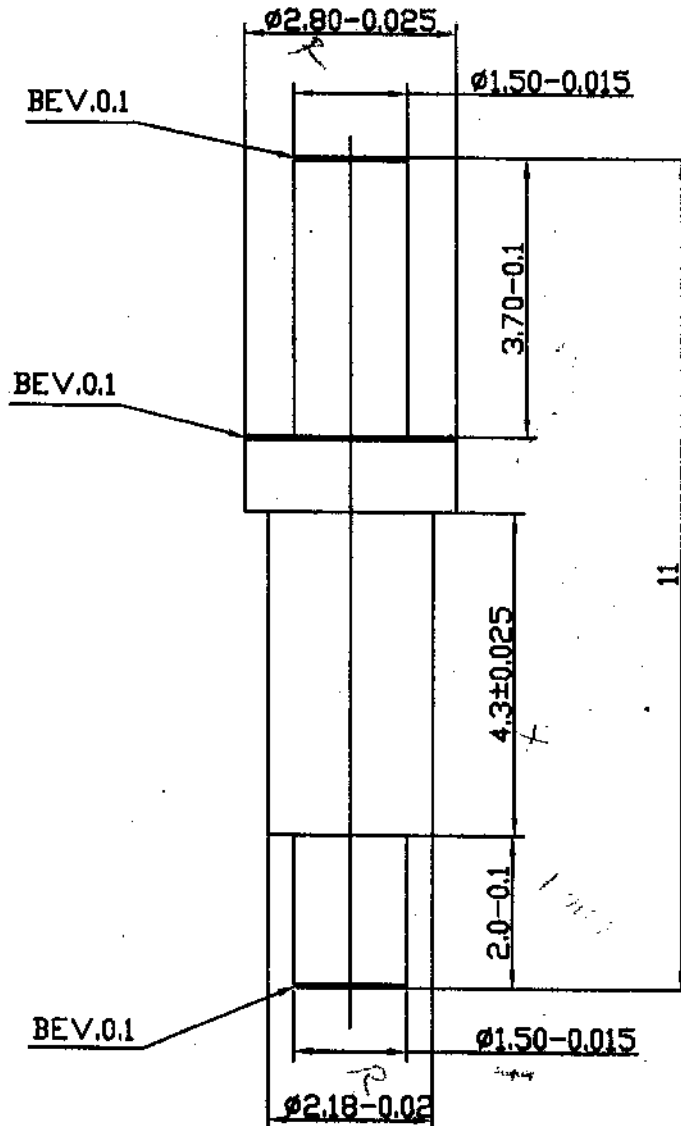
STABILIZE THE SPRING AT 232°C + AND 7° FOR 2 HOURS

				Item No.	DESCRIPTION	No. off	MATERIAL
INSP.	Date	JWM/CDD	DA No	Heat Treatment Rc.-		SPRING OF INERTIAL PIN	
Amendments				▽ 12.5-25 Ra	▽▽ 0.2-0.8 Ra		
JWM/A3	<i>[Signature]</i>	<i>[Signature]</i>		▽ 1.6-6.3 Ra	▽▽▽ 0.1-0.025 Ra	M/C	
HDS/CDD	<i>[Signature]</i>	DATE 19/5/06		DIMENSIONS ARE IN mm.		DRG.No.	
CKD	<i>[Signature]</i>	CKD		UNTOL. DIMNS. IS:2102 MEDIUM		TRD- 1-2-2096	
DRN	OPV	TRD		SHARP EDGES TO BE REMOVED		SCALE: 5:1	
				Gauging surfaces shown by thick line			
APPROVED BY				ORDNANCE FACTORY KHAMARIA		No. of sheets - 01 Sheet No. - 01	
PS/GS.			STORE- DRG.No.			COMPT. DRG.No.	

DRG.No.  
TRD -1-2-2105

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MATL- STEEL 95 Mn Pb 23 UNI-5105

UTS R55/75 Kg/mm<sup>2</sup> ELONGATION MIN. 6%

NOTE-DIMENSIONS REFER TO TREATED PART. NICKEL COATING THICKNESS 1.3-2.5  $\mu$

				Item No.	DESCRIPTION	No. off	MATERIAL
Insp.	Date	JWM/CDD	DA No	Heat Treatment Rc.-			PIVOT
Amendments				$\nabla$ 12.5-25 Ra	$\nabla\nabla\nabla$ 0.2-0.8 Ra		
JWM/AS		<i>[Signature]</i>		$\nabla\nabla$ 1.6-6.3 Ra	$\nabla\nabla\nabla\nabla$ 0.1-0.025 Ra	M/C	
JWM/HOS		DATE 19/5/06		DIMENSIONS ARE IN mm.			Drg. No.
CKD		CKD		UNTOL. DIMNS. ISI2102 MEDIUM			TRD -1-2-2105
DRN R.R.		TRD		SHARP EDGES TO BE REMOVED			Scale-10:1
				Gauging surfaces shown by thick line			No. of sheets - 1
Approved by				ORDNANCE FACTORY KHAMARIA			Sheet No. - 1
PS/GS.				STORE			Compt.
				Drg.No.			Drg.No.

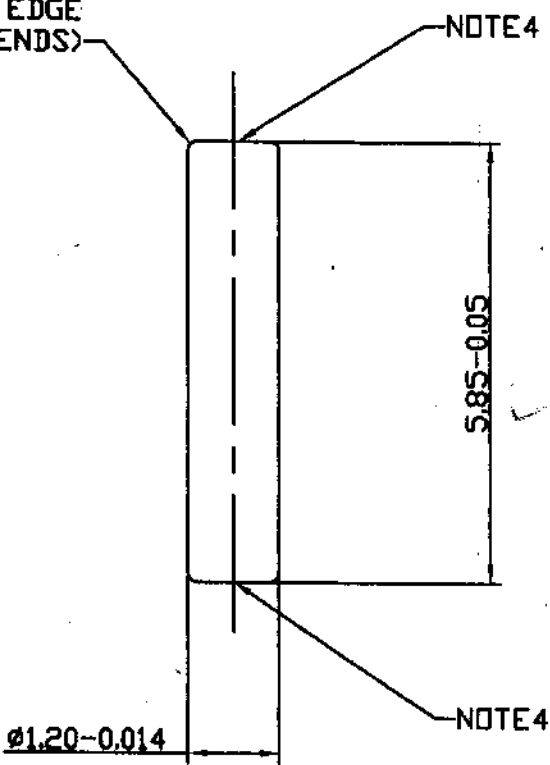


DRG.No.  
TRD -1-2-2095

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ROUND-OFF THE EDGE WITH R0.13 MAX.(BOTH ENDS)



MATERIAL-CORROSION PROOF STEEL,COLD ROLLED;  
CLASS 416,COND. T, SPEC. ASTM-A581  
C (MAX)-0.15,Mn 1.25,P 0.06 S 0.15 MIN. SI MAX.-1.0,Cr.  
12-14 INTERMEDIATE TEMPER (T)

- NOTES:- 1) FINISHING 1,6 GENERAL  
2) PROTECTIVE FINISHING-FINISHING n°5.4.1 OF SPEC. MIL-STD-171  
3) PARTING-OFF PINS NOT ALLOWED

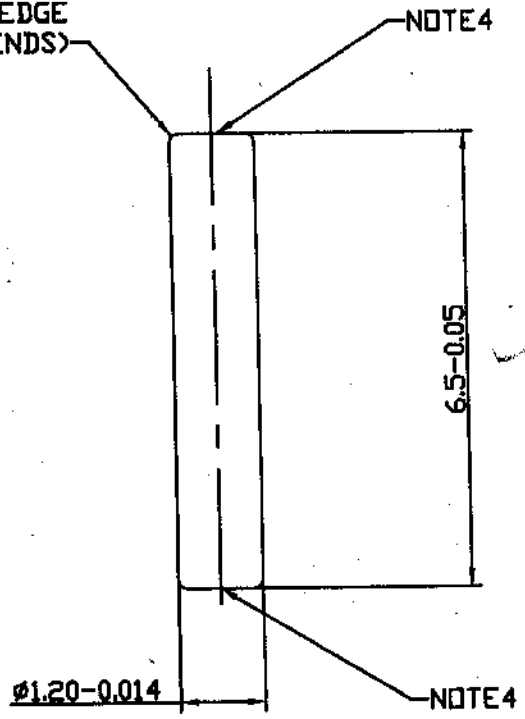
				Item No.	DESCRIPTION	No. off	MATERIAL
Insp.	Date	JWM/ CDD	DA No	Heat Treatment Rc.-		PIN	
Amendments				▽ 12.5-25 Ra	▽▽▽ 0.2-0.8 Ra	M/C	
JWM/AS				▽▽ 1.6-6.3 Ra	▽▽▽▽ 0.1-0.025 Ra		
HOS/ CDD	DATE 19/5/06			DIMENSIONS ARE IN mm.		Drg. No.	
CKD	CKD			UNTOL. DIMNS. IS:2102 MEDIUM		TRD 1-1-2-2095	
DRN	TRD			SHARP EDGES TO BE REMOVED		Scale 10:1	
Approved by				ORDNANCE FACTORY KHAMARIA		No. of sheets - 1 Sheet No. - 1	
PS/GS.				Store		Compt. PIN	
				Drg No		Drg No	

DRG.No. TRD -1-2-2097

VETTED - FOR PLANNING AND TRADE ENQUIRY ONLY.

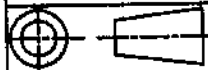
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ROUND-OFF THE EDGE WITH R0.13 MAX.(BOTH ENDS)



MATERIAL-CORROSION PROOF STEEL,COLD ROLLED, CLASS 416,COND. T, SPEC. ASTM-A581 C (MAX)-0.15,Mn+1.25,P- 0.06 S- 0.15 MIN., SI MAX.-1.0,Cr- 12-14 INTERMEDIATE TEMPER (CT)

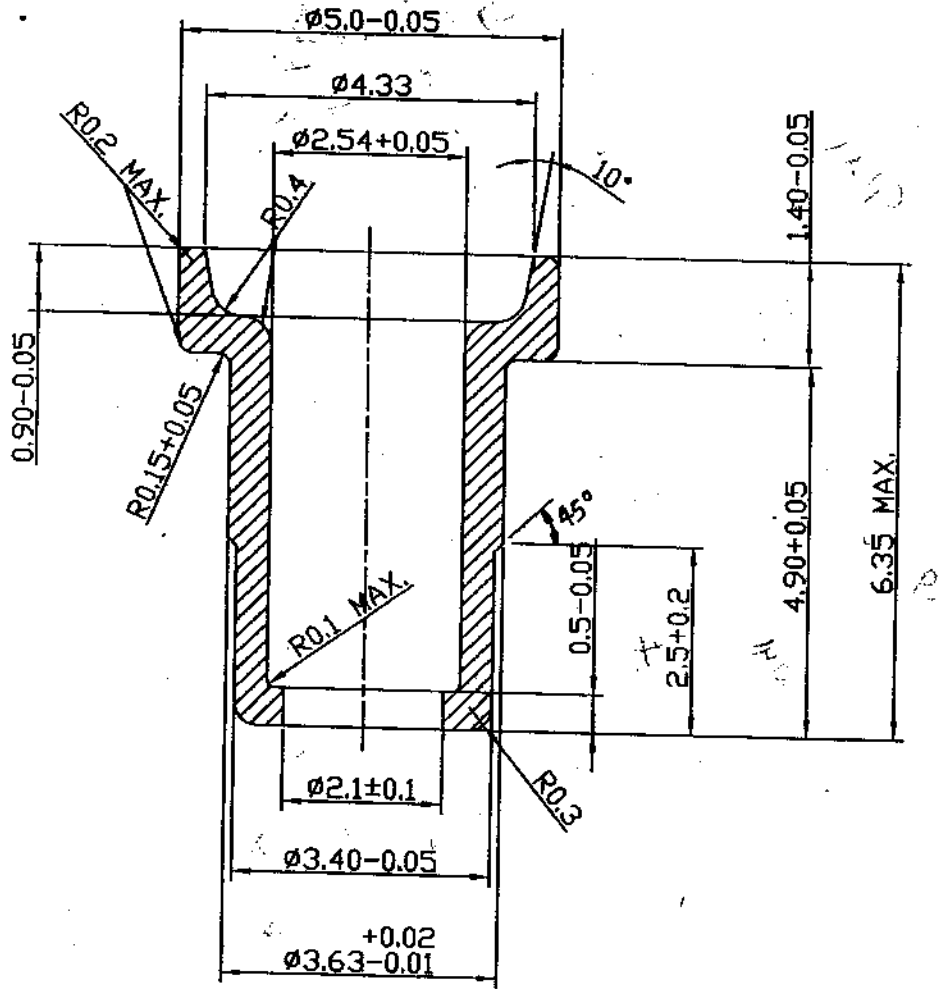
- NOTES:- 1) FINISHING 1.6 GENERA  
 2) PROTECTIVE FINISHING-FINISHING n\*5.4.1 OF SPEC. MIL-STD-171  
 3) PARTING-OFF PINS NOT ALLOWED

				Item No.	DESCRIPTION	No. off	MATERIAL
Insp.	Date	JWM/CDO	DA No	Heat Treatment Rc.-		PIN	
Amendments				$\nabla$ 12.5-25 Ra $\nabla\nabla\nabla$ 0.2-0.8 Ra $\nabla\nabla$ 1.6-6.3 Ra $\nabla\nabla\nabla\nabla$ 0.1-0.025 Ra DIMENSIONS ARE IN mm. UNTOL. DIMNS. IS:2102 MEDIUM SHARP EDGES TO BE REMOVED Gauging surfaces shown by thick line		M/C	
JWM/AS	<i>[Signature]</i>	DATE 19/5/86	CKD	ORDNANCE FACTORY KHAMARIA		Drg. No. TRD - 1 - 2 - 2097  Scale 10:1	
HOS/CDO	<i>[Signature]</i>		TRD			No. of sheets - 1 Sheet No. - 1	
DRN: Alok						Compt. PIN Drg.No.	
Approved by				Store			
PS/GS.				Drg.No.			

40

DRG.No.  
TRD -1-2-2109

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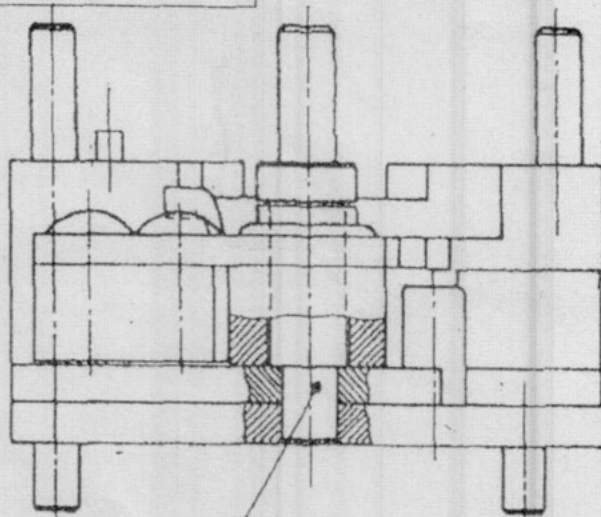
NOTES:-

- 1-THE PART SHALL BE WITHOUT BURRS AND VISIBLE MATERIAL INJECTION POINTS.
- 2-MATERIAL: LATAMID 6H2 G/30 MS 01 NEUTRAL COLOUR OR SNIAMID ASN 27/300 NEUTRAL COLOUR.

				Item No.	DESCRIPTION	No. off	MATERIAL
Insp.	Date	JWM/ CDO	DA No	Heat Treatment Rc.-		<b>DETONATOR HOLDER</b>	
Amendments				▽ 12.5-25 Ra	▽▽▽ 0.2-0.8 Ra		
JWM/ R&D				▽▽ 1.6-6.3 Ra	▽▽▽▽ 0.1-0.025 Ra	M/C	
JWM/HOS CDO		DATE 19/5/06		DIMENSIONS ARE IN mm.		Drg. No.	
CKD		CKD		UNTOL. DIMNS. IS2102 MEDIUM		TRD -1-2- 2/09	
DRN - JPS		TRD		SHARP EDGES TO BE REMOVED		Scale 10:1	
Approved by				ORDNANCE FACTORY KHAMARIA		No. of sheets - 1 Sheet No. - 1	
PS/GS.				STORE FB-40		Compt.	
				Dra.No.		Ino.No	

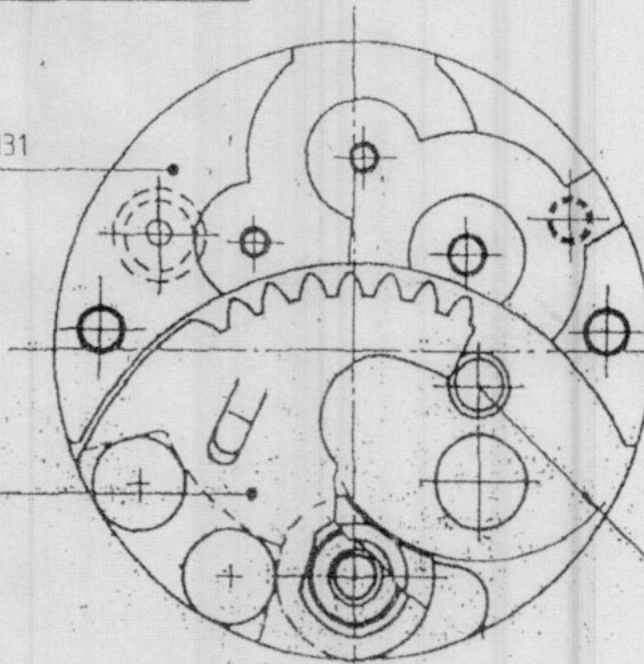
TO BE MARKED ON TOOL/GAUGE/PART

TRD-1-2-2088



TRD-1-2-2105

TRD-2-2-2131



TRD-2-2-2124

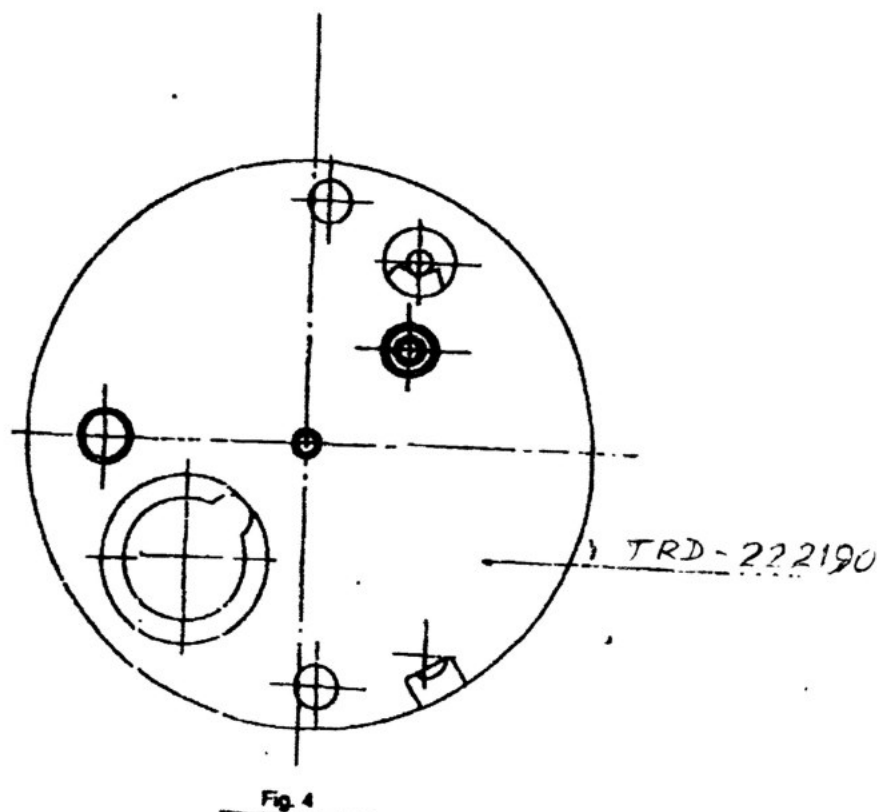
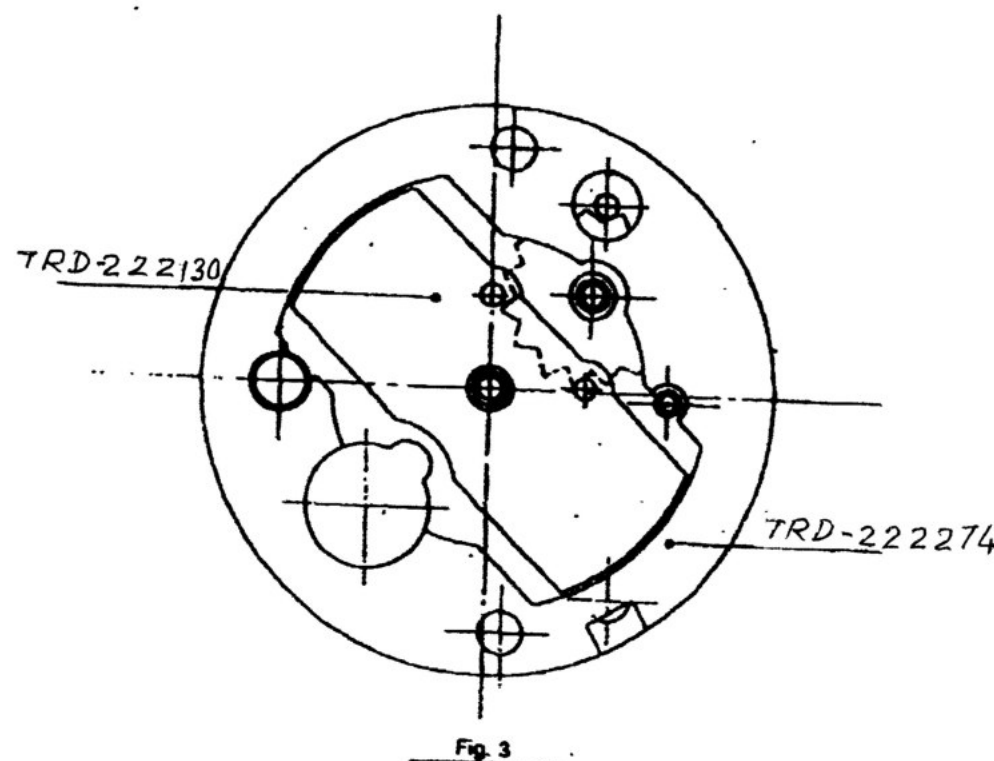
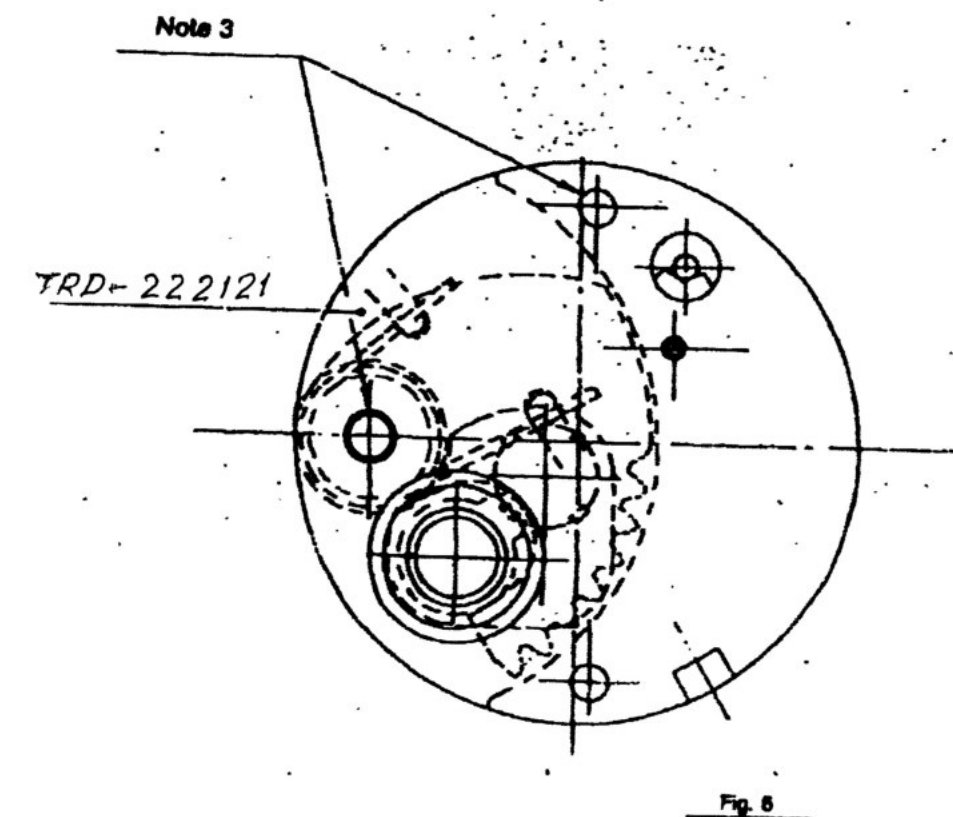
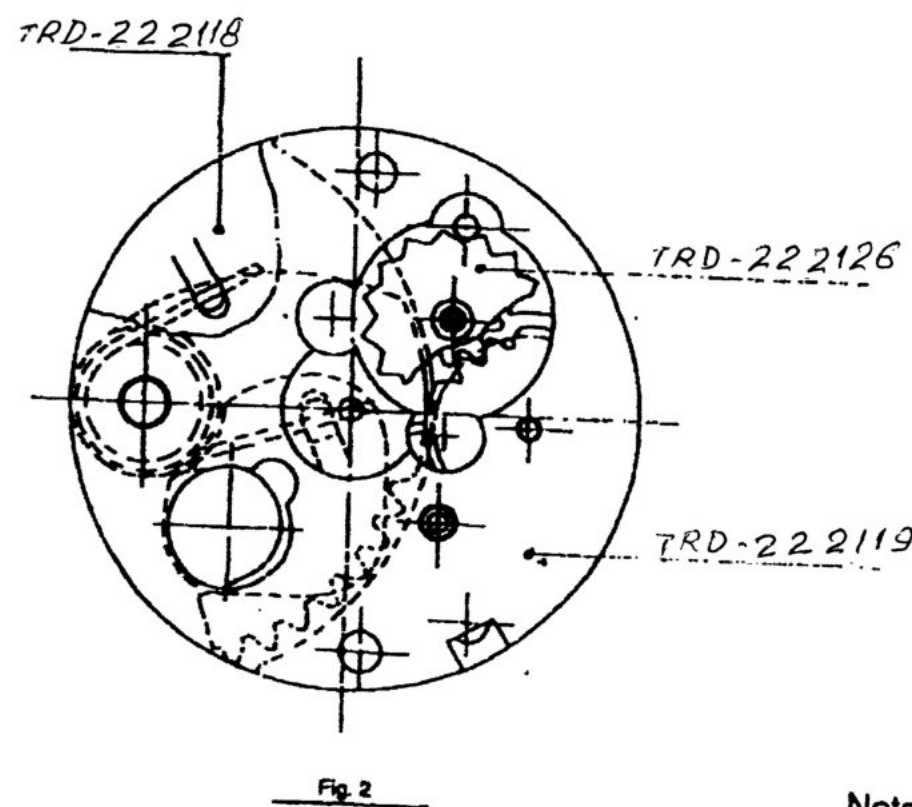
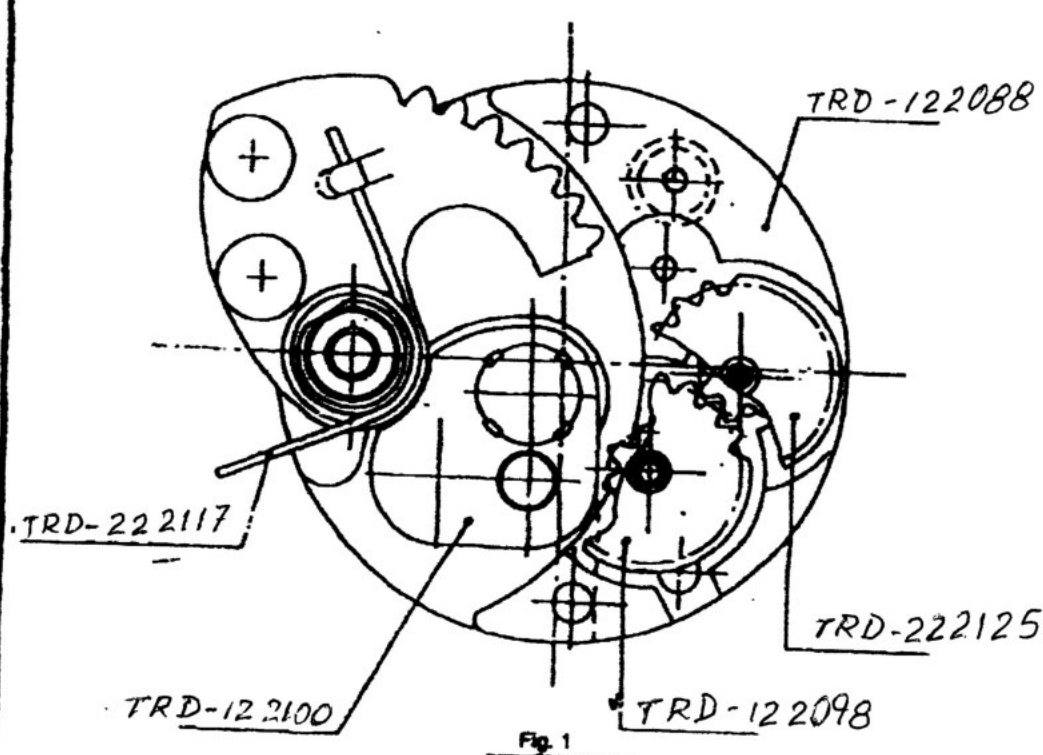
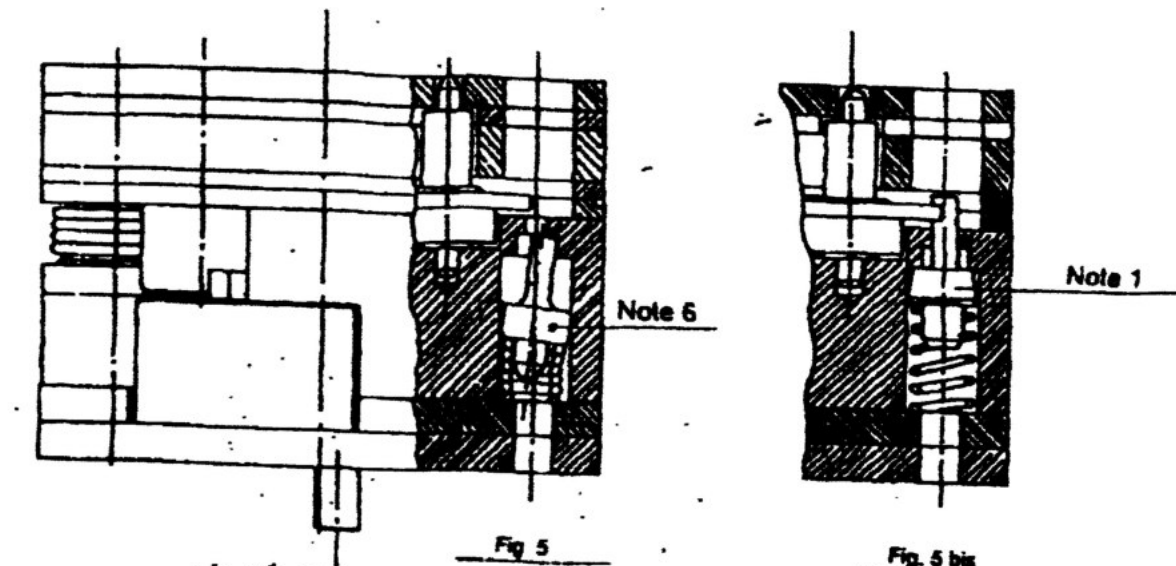
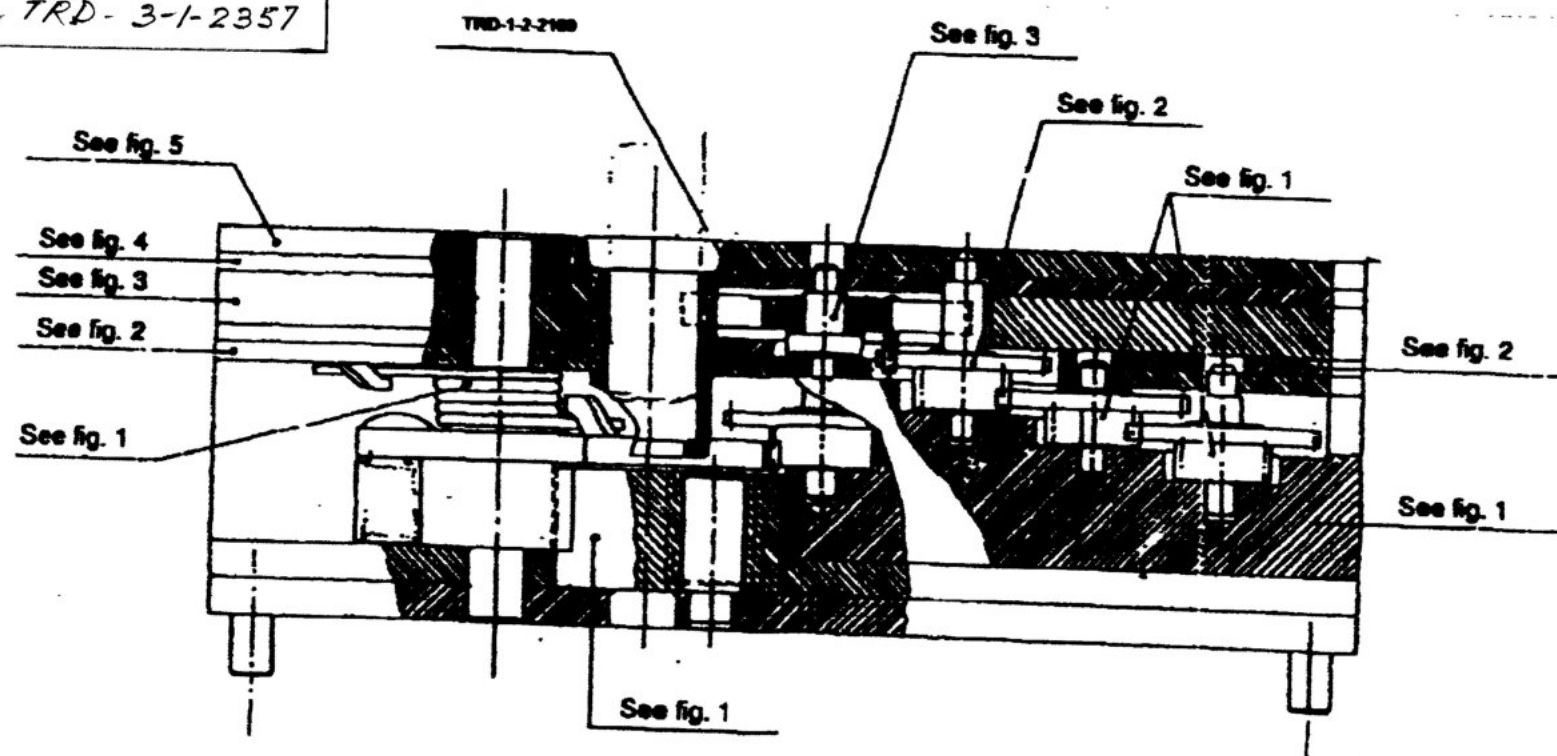
See note 2

Notes:

- 1 - After force fit of pivot TRD-2-2-2105 on the body and plates ass.y TRD-2-2-2131 the sector gear assembly TRD-2-2-2105 must be capable to freely rotate.
- 2 - The sector gear assembly positioned on wall of a bush of inside diam. 16,55 must allow free rotation to a purposely shaped gauge, of 4,60 mm radius, pivoted on the indicated pin.

				ITEM No.	DESCRIPTION	No. OFF	MATERIAL
INSP.	DATE	HOS/ CDO	DA No	HEAT TREATMENT Rc.		BODY & SECTOR GEAR ASSEMBLY	
AMENDMENTS				▽ 12.5-25 Ra	▽▽ 0.2-0.8 Ra		
				▽ 16-6.3 Ra	▽▽▽ 0.1-0.025 Ra		
HOS/ CADE	DATE	ALXN/ EPJ		DIMENSIONS ARE IN mm.			
EKD	TRD	EKD		INTOL. DIMS. IS:202 MEDIUM			
DRN	TRD	DRN		SHARP EDGES TO BE REMOVED			
APPROVED BY				DASHING SURFACES SHOWN BY THICK LINES			
				ORDNANCE FACTORY KHAMARIA			
						DRG. No.	SCALE--
						TRD-1-2-2088	
						1ST. ANGLE PROJECTION	
						No. OF SHT. -	SHEET No. -





Notes:

- 1 - Verify that the rotor assembly TRD-1-2-2100 freely rotates on its pivot, that it is held in safety position when the sector gear is positioned as in fig. 2, and that it is released when the sector gear is moved toward outside on wall of a bush with an inside diam. 16,55.
- 2 - The pins of pinions and of the balance shall not be oiled.
- 3 - The plate 7 Drw. TRD-2-2-2121 must force on the pin of the sector-gear and on the indicated pin.
- 4 - Before inserting the detonator support TRD-1-2-2100 move toward outside the sector-gear, to allow correct insertion, then release the sector gear (note 5).
- 5 - Every operation requiring a rotation of the gear train, must be done keeping the inertial pin in armed position as indicated in fig. 5
- 6 - Each movement ass.y shall be subjected to "NOT ARMING" test, by putting it in rotation, on its longitudinal axis, at 8000 rpm (Note 5) and to "ARMING" test at 20 000 rpm (Note 5)
- 7 - After the test at 20 000 rpm, reset the movement to safe condition as indicated with short dashes lines in fig. 6, and put the inertial pin in the position of locking the escapement gear as indicated in fig. 5 bis.

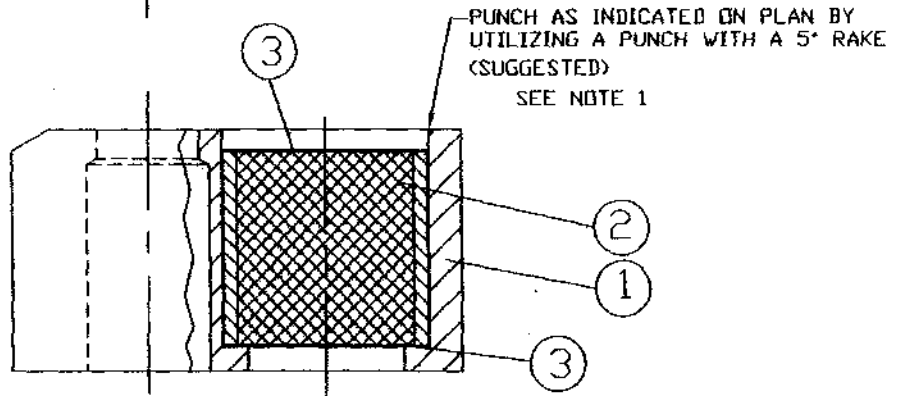
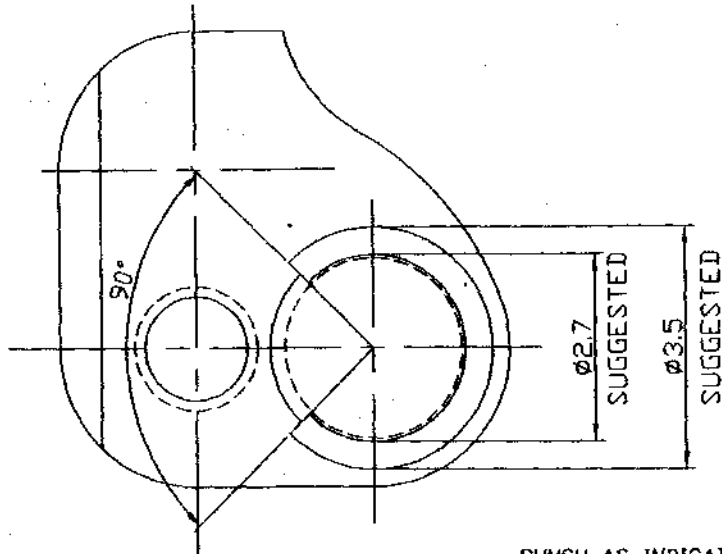
				ITEM No.	DESCRIPTION	No. OF	MATERIAL
INSP.	DATE	JWM/CADC	DA No	HEAT TREATMENT RC.		ASSEMBLY STEPS	
AMENDMENTS				∇ 125-25 Ra	∇∇∇ 0.2-0.8 Ra		
JWM/RED				∇∇ 1.6-6.3 Ra	∇∇∇∇ 0.1-0.025 Ra	M/C	
JWM/CADC				DIMENSIONS ARE IN mm.			
CKD				UNTOOL. DIMMS. IS-2102 MEDIUM			
DRN Arun				SHARP EDGES TO BE REMOVED GUGING SURFACES SHOWN BY THICK LINES			
APPROVED BY ANM/RE'D				ORDNANCE FACTORY KHAMARIA		No. OF SHT. -1 SHEET No. -1	
PS/GS.				STORE:- DRG. No. 1		COMPT. DRG.No.	



DRG. NO. TRD- 1-2-2100

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**NOTE :-**  
 1- THE PUNCHING SHALL NOT PROTRUDE OVER THE SURFACE OR CAUSE DEFORMATIONS OF EXTERNAL PROFILE OR OF THE HOLE DIAMETER WHICH SHALL ALLOW AFTER PUNCHING THE SLIDING OF A 1.805 CALIBRATED PEG.

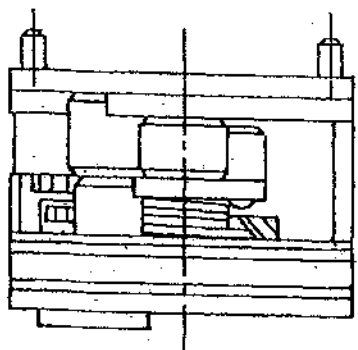
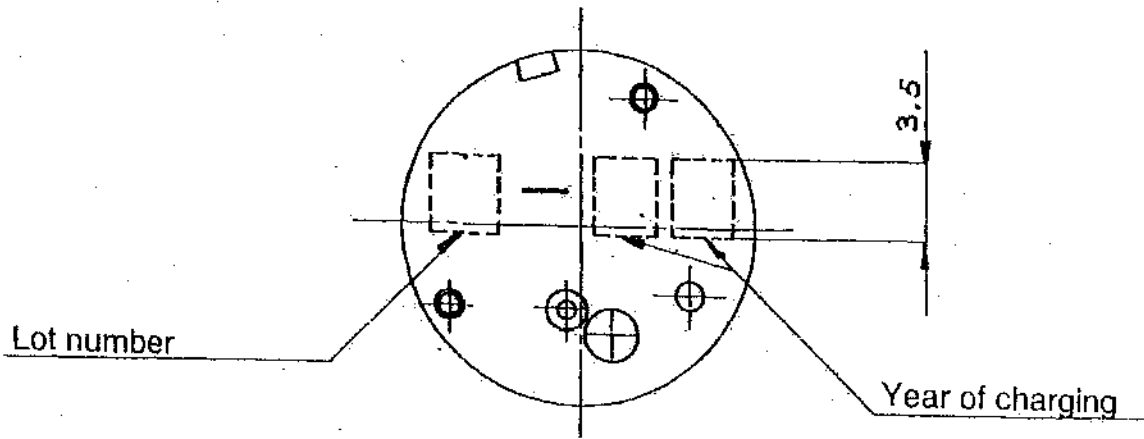
3	COPPER DISC	2	TRD-1-2-2101
2	CHARGED TUBE	1	TRD-1-1-2356
1	ROTOR	1	TRD-1-2-2111

ITEM No.	DESCRIPTION	No. OF	MATERIAL
	HEAT TREATMENT Rc.		ROTOR ASSY.
AMENDMENTS			
JWM/R&D	▽ 12.5-25 Ra ▽▽▽ 0.2-0.8 Ra		M/C
HOS/CDO	▽ 1.6-6.3 Ra ▽▽▽ 0.1-0.025 Ra		DRG. No. TRD- 1-2-2100
CKD	DIMENSIONS ARE IN mm.		SCALE:- 10:1
DRN	UNTOL. DIMNS. IS:2102 MEDIUM		No. OF SHT. - 1
	SHARP EDGES TO BE REMOVED		SHEET No. - 1
	GAUGING SURFACES SHOWN BY THICK LINES		
APPROVED BY AWM/R&D	ORDNANCE FACTORY KHAMARIA		
PS/GS.	STORE:-		COMPT.
	DRG. No.		DRG.No.

DRG.NO. TRD- 1-1-2358

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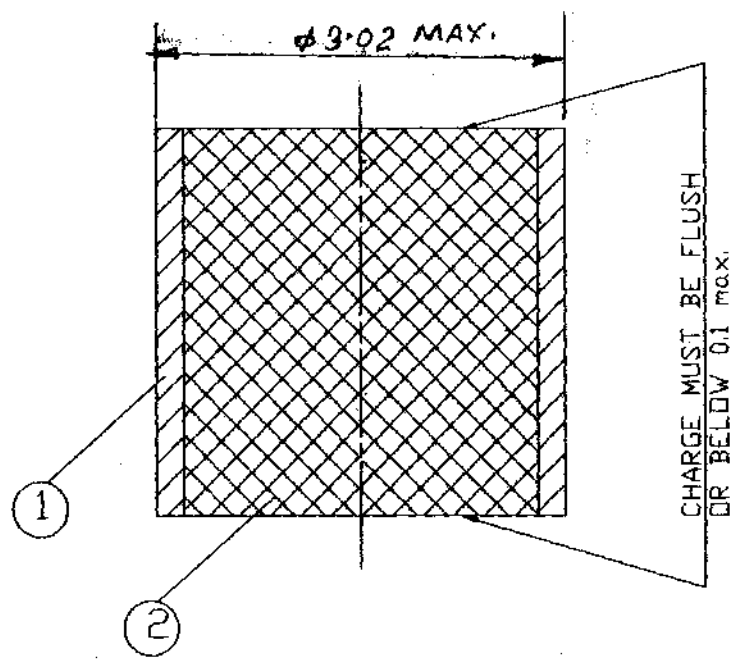
NOTE: MARK WITH INDELIBLE INK BLACK COLOUR

				ITEM No.	DESCRIPTION	No. OF	MATERIAL
INSP.	DATE	HOS/ CDD	DA No	HEAT TREATMENT Rc.		MARKING	
AMENDMENTS				▽ 125-25 Ra	▽▽▽ 0.2-0.8 Ra		
JWM/RED				▽ 1.6-6.3 Ra	▽▽▽ 0.1-0.025 Ra	M/C	
HOS/ CDD	DATE 16/2/15			DIMENSIONS ARE IN mm.		DRG. No. TRD- 1-1-2358	
CKD	CKD			UNTDL. DIMNS. IS:2102 MEDIUM		SCALE:- 5:1	
DRN	TRD			SHARP EDGES TO BE REMOVED		No. OF SHT. - 1	
APPROVED BY AWM/RED				GAUGING SURFACES SHOWN BY THICK LINES		SHEET No. - 1	
PS/GS.				STORE:-		COMPT.	
				DRG. No.		DRG.No.	

DRG.NO. TRD- 1-1-2356

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CHARGE MASS - 30mg.  
DEAD LOAD - 7Kg/mm<sup>2</sup>

- NOTE :-
1. THE CHARGE SHALL NOT PROTRUDE FROM THE TUBE. CAN STAY UNDER THE PLANE OF THE TUBE OF 0.1 MAX.
  2. THE SURFACES OF THE CHARGE SHALL NOT SHOW DEFORMATIONS OR CRUMBLING.

				2	PANNTAERITHRITE CL.4		
				1	TUBE	1	TRD-1-2-2103
				ITEM No.	DESCRIPTION	No. OF	MATERIAL
INSP.	DATE	HQS/CDD	DA No	HEAT TREATMENT Rc.		CHARGED TUBE	
AMENDMENTS				▽ 12.5-25 Ra ▽▽▽ 0.2-0.8 Ra			
JWM/R&D		<i>[Signature]</i>		▽ 1.6-6.3 Ra ▽▽▽ 0.1-0.025 Ra		M/C	
HQS/CDD	<i>[Signature]</i>	DATE 16/7/15		DIMENSIONS ARE IN mm.		DRG. No.	
CKD		CKD		UNTEL. DIMNS. IS:2102 MEDIUM		TRD- 1-1-2356	
DRN	<i>[Signature]</i>	TRD		SHARP EDGES TO BE REMOVED		SCALE:-	
				GAUGING SURFACES SHOWN BY THICK LINES		5:1	
APPROVED BY AWM/R&D				ORDNANCE FACTORY KHAMARIA		No. OF SHT. - 1	
						SHEET No. - 1	
PS/GS.				STORE:- FUZE AVU-ETM		COMPT.	
				DRG. No.		DRG.No.	


Inspection Criteria of Assembly S&A ( filled) for Fuze FB-40 for  
40mm PFFC Ammn.

<u>SL. No.</u>	<u>Test</u>	<u>Inspection Method</u>	<u>Qty</u>	<u>Limit</u>	
				<u>Acc</u>	<u>Rej</u>
1	Verify correct assembly of explosive components	Visual	70	0	1
2	Verify correct assembly of spring	Visual	70	0	1
3	Verify dimensional compliance of parts to the drawings	Visual	70	0	1
4	Verify absence of burrs, cutting edges or foreign matters	Visual	70	0	1
5	No. Arm test with force of 80 g	Gauge	10	0	1
6	Arm test with force of 250g	Gauge	15	0	1
7	Arming test at 20000 RPM	Gauge	15	0	1
8	Non Arming test at 8000 RPM	Gauge	10	0	1
9	Jolt test( Specn. MIL-STD-331 )	Device	10	0	1
10	Vibration Test (Specn. MIL-STD-331 )	Device	10	0	1
11	Mechanical Safety	Dynamic test	5	0	1
12	Percussion test	Dynamic test	5	0	3
			10	3	4

  
J.T. GM/ P&P

  
WM/ R&D

  
AWM/ R&D

  
JWM/ R&D  
No. 60/ SAD/PFFC/R&D  
Date 15/10/2014

Inspection Criteria of Assembly S&A ( filled) for Fuze FB-40 for  
40mm PFFC Ammn.

<u>SL. No.</u>	<u>Test</u>	<u>Inspection Method</u>	<u>Qty</u>	<u>Limit</u>	
				<u>Acc</u>	<u>Rej</u>
1	Verify correct assembly of explosive components	Visual	70	0	1
2	Verify correct assembly of spring	Visual	70	0	1
3	Verify dimensional compliance of parts to the drawings	Visual	70	0	1
4	Verify absence of burrs, cutting edges or foreign matters	Visual	70	0	1
5	No. Arm test with force of 80 g	Gauge	10	0	1
6	Arm test with force of 250g	Gauge	15	0	1
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8	Non Arming test at 8000 RPM	Gauge	10	0	1
9	Jolt test( Specn. MIL-STD-331 )	Device	10	0	1
10	Vibration Test (Specn. MIL-STD-331 )	Device	10	0	1
11	Mechanical Safety	Dynamic test	5	0	1
12	Percussion test	Dynamic test	5	0	3
			10	3	4