

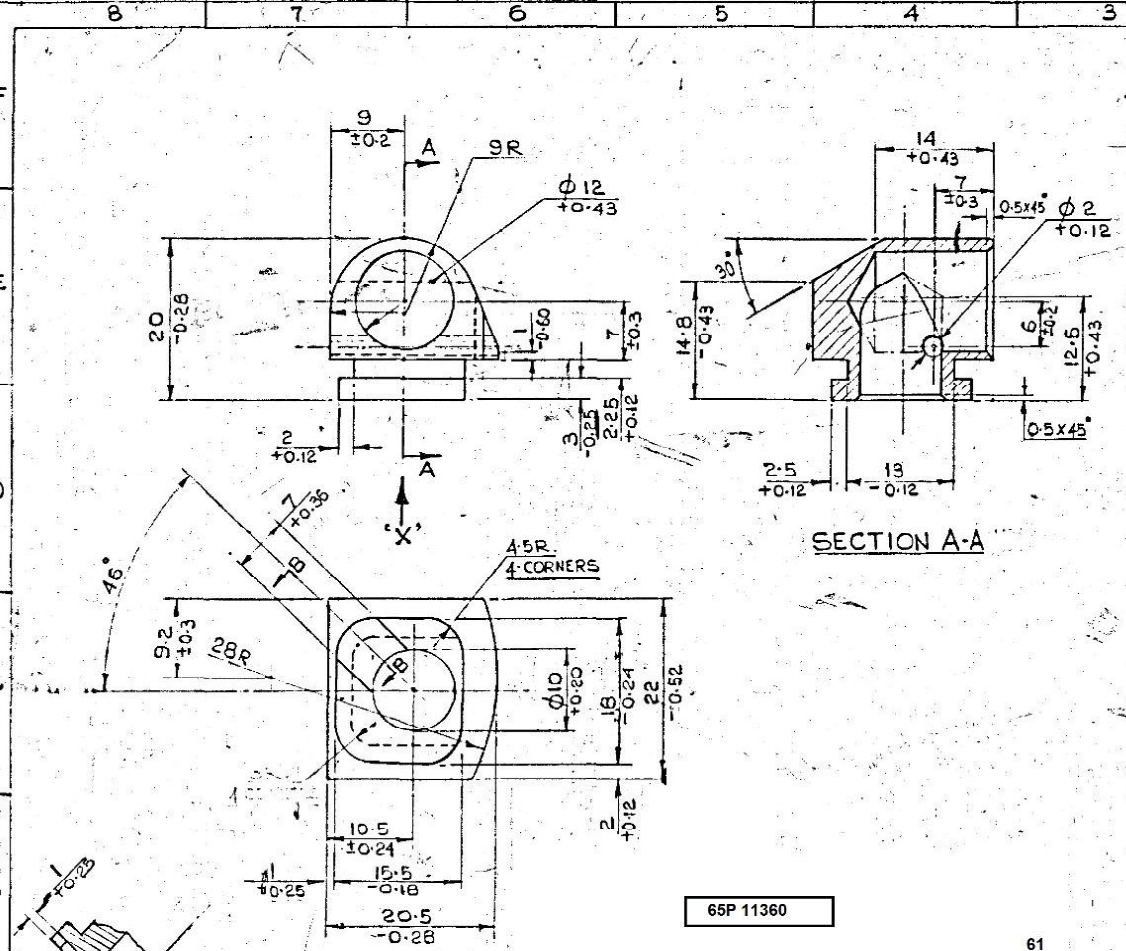
DRAWING CONVENTIONS CONFORM TO IS: 696.  
TOLERANCES FOR UNTOLERANCED DIMENSIONS  
SEE 'MEDIUM' IS: 2102.

DRAWING PREPARED BY REVERSE ENGINEERING  
PROCESS, AS SUCH SUITABLE NUMBER OF  
ADVANCE SAMPLES ARE TO BE TRIED OUT BY  
FITMENT & FIRING BY CQA (SA), BEFORE  
BULK IS PRODUCED.

MATERIAL:-  
BS: 970:PT. 3: 291 GRD. 070 M 55  
OR  
IS: 5517: 293 DESIG. 55 C 8

HARDNESS:-  
H 34E - 395 HV

PROTECTIVE FINISH:-  
PHOSPHATE TO SPECN. JSS: 0465: OI-B  
1986 CLASS II, OIL FINISH.



SECTION A-A

VIEW X'X'

SECTION B-B

65P 11360

61

			DATE	NAME	ASSY: 15945-007663	CQA(SA) ICHAPUR	
			DGN.	25.4.93			MATERIAL:- AS STATED.
			CHKD		DIMENSIONS ARE IN mm.	NEG. PREPARED	
			TRD			DESIGNER'S REF.	
			COMP			(CISA-506/27	
					SCALE:- 2:1	PART NO.	
						PLUG CABLE PROTECTOR	617/12-7
					SEALING:- PROV. D.C (I) 19935-SA- DT. 5-3-88.		
AUTHY.	DATE	ZONE	BRIEF RECORD	SIG.			

A/

23534-SA

25-10-96

MATERIAL AND HARDNESS AMENDED.

350

22871-SA

20.2.95

ASSEMBLY NO. ADDED

350

22144-SA

13-2-93

DRG. REVISED, RE-DRAWN AND PROV. RE-SEALED.

MAN

PREV. D.C (I) NO. 19935-SA-DT. 5.3.88

COPY.

SEALED:- PROV. D.C (I) 19935-SA-DT. 5-3-88.

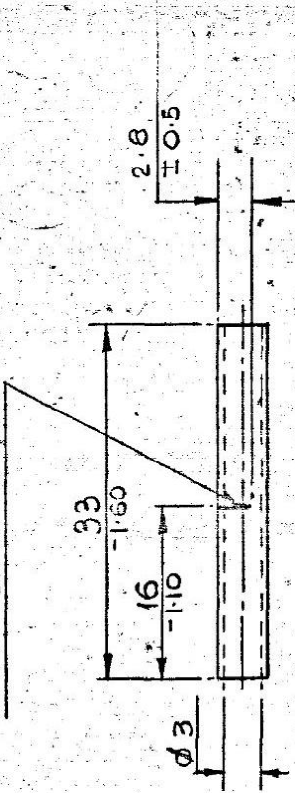
COPY.

SIG.

4 3 2 1

DRAWING PREPARED BY REVERSE ENGINEERING PROCESS  
 AS SUCH SUITABLE NUMBER OF ADVANCE SAMPLES ARE  
 TO BE TRIED OUT BY FITMENT & FIRING BY COM(SA)  
 BEFORE BULK IS PRODUCED.

THROUGH CUT



MATERIAL:-

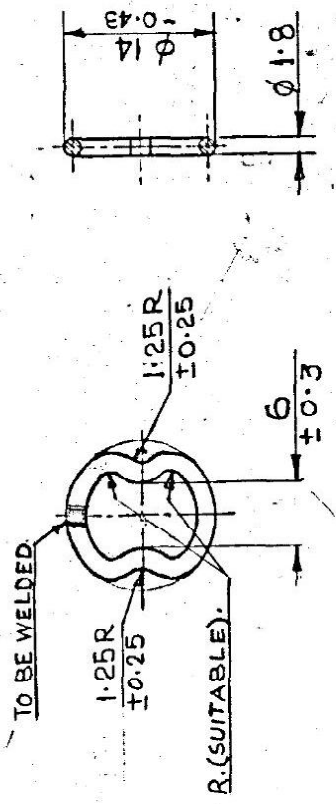
FLEXIBLE INSULATING SLEEVING TO  
 SPECN. IS: 11645 (PART 3/SEC 405/1989)  
 NORMAL BORE SIZE 3mm., B, COLOUR  
 'YELLOW' OR 'BROWN'.

65P 11361

23926-25997 -SA	DRG. SEALED PROVISIONALLY.	<i>[Signature]</i>
AUTH. DATE	BRIEF RECORD	SIG.
REVISIONS	DATE	NAME
CONFORM TO JSG-0124	DGN.	SK. LAL
	DRN.	11.9.97
	CHD.	11.9.97
	TRD.	
	COMP.	
	11.9.97	<i>[Signature]</i>
	SCALE:-	2:1
	SEALED: PROVISIONALLY	D.C.No. 23926-SA, DT. 25-9-97
	ASSY: 5945-007666	CQA(SA)IC/12/12
	MATERIAL:- AS STATED	
	DIMENSIONS ARE IN MILLIMETRES	APPROVED
	<u>TUBE</u>	DT. 11.9.97 FOR COM(SA)
		DESIGNER'S H.T.
		CQA(SA)SK-63
		PART NO.
		4-12-35/607

4 3 2 1

DRAWING PREPARED BY REVERSE ENGINEERING PROCESS AS SUCH SUITABLE NUMBER OF ADVANCE SAMPLES ARE TO BE TRIED OUT BY FITMENT & FIRING BY COA(SA) BEFORE BULK IS PRODUCED.



MATERIAL:- IS: 280, HARD (BRIGHT DRAWN)  
HARDNESS:- 298 - 395 HV

PROTECTIVE FINISH:- PHOSPHATE TO SPECN. JSS 0465-01:1988 CLASS II. (ACCELERATED), OIL FINISH.

65P 11362

63

26648/04-712	D.S.CATNP ADDED.	3/16/83
23534-34	MATERIAL AMENDED & HARDNESS ADDED	3/16/83
22141	DRG. REVISED, RE-DRAWN & PROV. RE-SEALED.	3/16/83
- SA	PREVIOUS DC 19935-SA COPY.	MAJOR
AUTHY	BRIEF RECORD	SIG.
DRAWING CONVENTIONS	DATE	NAME
CONFORM TO IS:696.		sketch
TOLERANCES FOR UN TOLERANCED		
DIMENSIONS SEE "MEDIUM" IS:2102		
SCALE:- 2:1		
SEALED:- PROV.DC 19935-SA.DT. 5-3-88		

D.S. CAT. No. 5325-009395  
ASSY.DRG. 5945-007666

COA(SA) ICHAPUR  
MATERIAL:- AS STATED  
DIMENSIONS ARE IN MILLIMETRES

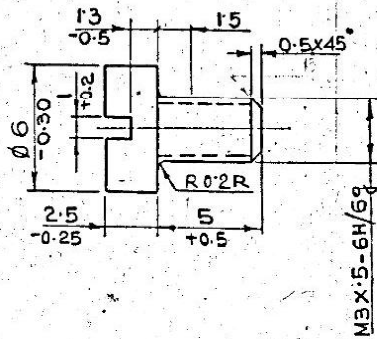
APPROVED.DT.  
(NEG. PREPARED)  
DESIGNER'S REF.  
CISA 506/25  
PART NO.  
617/12-34

RING

DRAWING PREPARED BY REVERSE ENGINEERING PROCESS, AS SUCH SUITABLE NUMBER OF ADVANCE SAMPLES ARE TO BE TRIED OUT BY FITMENT & FINING BY CQA(SA), BEFORE BULK IS PRODUCED.

DRAWING CONVENTIONS CONFORM TO IS: 696.

TOLERANCES FOR UNTOLERANCED DIMENSIONS SEE MEDIUM IS: 2102



MATERIAL: BS 970 PT. 3-91 Gd. 080 M40.

**PROTECTIVE FINISH:-**  
PHOSPHATE TO SPECN. J65: 0465-01-1988  
CLASS II (ACCELERATED), OIL FINISH AND SCREW  
HEAD TO BE PAINT PFU STOVING BLACK TO  
SPECN. DEF 1407.  
**MATT FINISH.**

65P 11363

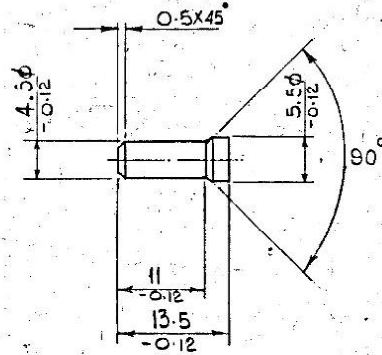
64

D.S. CAT. NO. 5305-099114

				DATE	NAME	ASSY. DRG. CISA-5945-007666		CQA(SA) ICHAPUR
26648-SA	04-7-12		D.S. CAT. NO. ADDED.	DGN.	GCM	MATERIAL: AS STATED		 APPROVED:- (NEG. PREPARED) DESIGNER'S REF. CISA-506/13 PART NO. 607 / 12-29 SCAN
23427-SA	8.8%		MATL. AMENDED & HARDNESS DELETED	DRN.		DIMENSIONS ARE IN MILLIMETRES		
22141-SA	13-2-93		DRG. REVISED, RE-DRAWN & PROV. RE SEALED.	CHD.		SCALE:- 5:1		
			PREVIOUS D.C. NOS 19935-SA AND 19975-SA.	TRD.	BCD	SEALED:- PROV D.C. 19935-SAP/5388		
AUTHY.	DATE	ZONE	BRIEF RECORD	COMP.				

DRAWING CONVENTIONS CONFORM TO IS: 696.  
TOLERANCES FOR UNTOLERANCED DIMENSIONS SEE "MEDIUM" IS: 2102

DRAWING PREPARED BY REVERSE ENGINEERING PROCESS, AS SUCH  
SUITABLE NUMBER OF ADVANCE SAMPLES ARE TO BE TRIED OUT BY  
FITMENT & FIRING BY CQA(SA) BEFORE BULK IS PRODUCED.



MATERIAL: BS 5216-75 CODE 'NS' Gd. I  
OR IS: 4454-PT.1: B1 Gd. I

HARDNESS: - 375 - 425 H.V.

PROTECTIVE FINISH: - PHOSPHATE TO SPECN. JSS: 0465-01-1988  
CLASS II (ACCELERATED) OIL FINISH.

65P 11364

65

DS. CAT. NO. 5340-013211

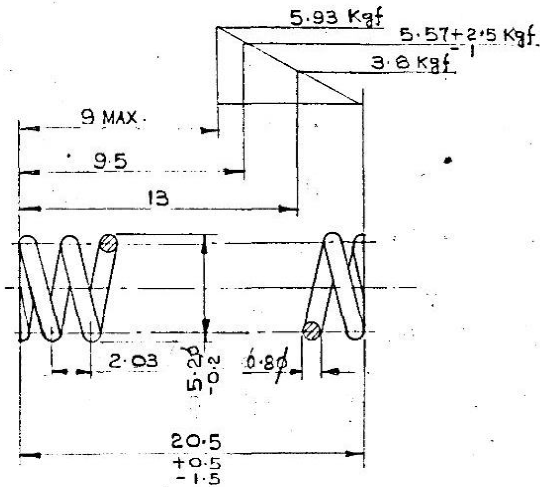
AUTHY.	DATE	ZONE	BRIEF RECORD.	SIG.	DATE	NAME	ASSLY. DRG. 5945-007666	CQA(SA) ICHAPUR
					DGN.			
					DRN.	<i>C. S. S.</i>	MATERIAL: AS STATED	
					CHD.			
					TRD.			
					COMB.	<i>M. S.</i>	DIMENSIONS ARE IN MILLIMETRES	
<i>HL</i>	2339C-SA	18.7.96	MATL. AMENDED	<i>[Signature]</i>				
<i>HL</i>	22836-SA	27-1-95	NOMENCLATURE AMENDED AND DS. CAT. NO. ADDED	<i>[Signature]</i>				APPROVED, DT. 19-8-77 (NEG. PREPARED)
	22141-SA	13-2-93	DRG. REVISED, RE-DRAWN & PROV. RE-SEALED.	<i>[Signature]</i>				DESIGNER'S REF. CISA 506/3
			PREVIOUS D.C. NO. 19931-SA & 19987-SA.	<i>[Signature]</i>				PART NO. G17 12-3
					SCALE: 2:1		CATCH FRICTION	
					SEALED: -		SOLENOID TRIGGER	
					COPY.	PROV. DC. No 19931-SA		
						DT. 5-3-88.		

5340-013211

8 7 6 5 4 3 2 1

DRAWING CONVENTIONS CONFORM TO IS: 696.  
TOLERANCES FOR UNTOLERANCED DIMENSIONS AS PER BS: 1726 PT.1: 1964.

DRAWING PREPARED BY REVERSE ENGINEERING PROCESS, AS SUCH SUITABLE NUMBER OF ADVANCE SAMPLES ARE TO BE TRIED OUT BY FITMENT & FIRING BY CQA(SA) BEFORE BULK IS PRODUCED.



NOTE :-

- 1. DEVELOPED LENGTH OF SPRING = 161
- 2. DIRECTION OF WOUND = RIGHT OR LEFT.
- 3. TOTAL NO. OF COILS = 11 - 1/2
- 4. NO. OF EFFECTIVE COILS = 9 1/2

CRAMP TEST :-

THE SPRING TO BE COMPRESSED TO A LENGTH OF 9.63 FOR PERIOD OF 12 HOURS BEFORE GAUGING.  
THE SPRING TO WORK FREELY IN ITS LOADED AND UNLOADED CONDITION IN A HOLE OF 5.5  $\phi$   
END COILS TO BE GROUNDED SQUARE WITH THE AXIS LEAVING 3/4 OF THE COIL NON-EFFECTIVE.

HEAT TREATMENT :- 240° - 260° C

PROTECTIVE FINISH :- PHOSPHATE TO SPECN. JIS: 0465  
-1988 CLASS II, OIL FINISH. DS. CAT. NO. 5360-006232

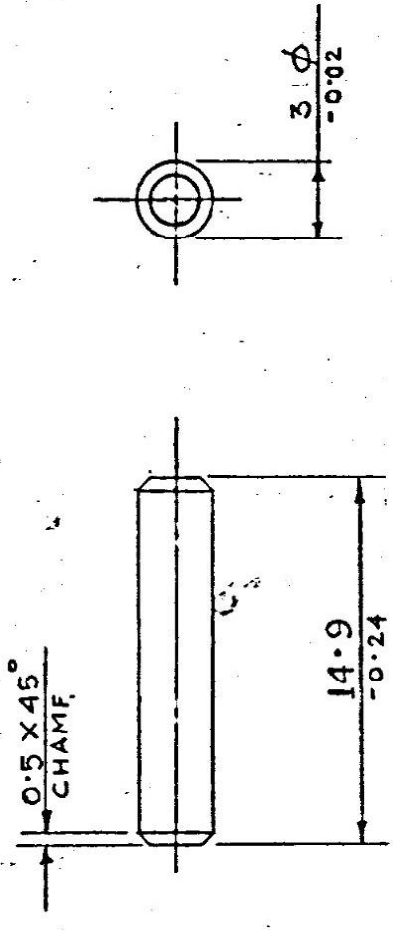
65P 11365

66

DATE	NAME	ASSY. 5945-007866	CQA(SA) ICHAFUP
DGN.			
DRN.			
CHD.			
TRD.			
COMP.	10.2.93	A. BARK	DIMENSIONS ARE IN MILLIMETRES
SCALE:	110	1/1 C.D.O.	<p>APPROVED DT 4-27-76 (NEG. PREPARED)</p> <p>DESIGNER'S REF CISA-503/4</p> <p>PART NO. 607/12-4</p>
SEALD:		PROVDC(H) 19931-SADR 5.3.88	
AUTHY. DATE	ZONE	BRIEF RECORD	

8 7 6

AS SUCH SUITABLE NUMBER OF ADVANCE SAMPLES ARE TO BE TRIED OUT BY FITMENT & FIRING BY CQA(SA) BEFORE GULK IS PRODUCED.



**MATERIAL :- BS 1429 E N 42C.**

**HARDNESS :- 375 - 425 HV.**

**PROTECTIVE FINISH :- PHOSPHATE**

**TO SPECN. JSS :  
0465-01:1988**

**CLASS II, OIL FINISH.**

65P 11366

67

**D.S. CAT. NO. 5315 - 007739**

CQA(SA)SK-85

**CQA(SA) ICHAPUR**

ASSY. DRG. No. 1505-007525  
D.S. CAT. No. 1505-007525



MATERIAL :- AS STATED.  
DIMENSIONS ARE IN MILLIMETRS

**PIN STRAIGHT  
HEADLESS TRIPPING**

APPROVED. DT. 19.8.77.  
(NEGATIVE PREPARED)  
DESIGNED'S REF.

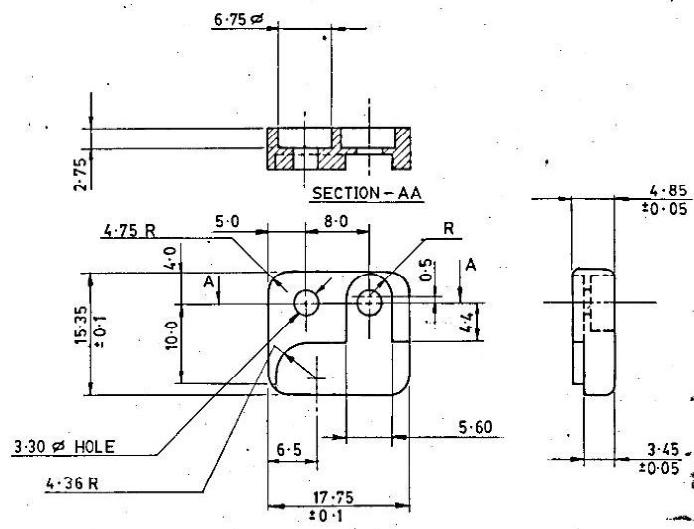
DATE	BY	REVISION	DESCRIPTION
4-4-2000	SA	1	NOMENCLATURE AMENDED
19.1.95	SA	2	NOMEN. AMENDED & D.S. CAT. NO. ADDED
29.6.92	SA	3	D.S. CAT. NO. 1005-007525 ADDED IN ASSY. COLUMN & D.S. REVISED GE. DRAWN AND PRV. 23.2.92
22.10.90	SA	4	REVISED TO PREVIOUS D.C. No. 19989-5A. COPY.

AUTHY. DATE	ZONE	BRIEF RECORD	SIG.

DRAWING CONVENTIONS CONFORM TO IS: 696: TOLERANCE FOR UNTOLENCED DIMENSIONS SEE MEDIUM IS: 2102 SHARP EDGES

DSCAT. No.

DRAWING CONVENTIONS CONFORM TO JSG-0104  
DIMENSIONS ARE IN mm. GEN. TOL. 'MEDIUM' IS: 2102



DRAWING PREPARED BY REVERSE ENGINEERING  
PROCESSES SUCH SUITABLE NUMBER OF ADVANCE  
SAMPLES ARE TO BE TRIED OUT BY FITMENT &  
FITTING BY CQA(SA) BEFORE BULK IS PRODUCED.

SHARP EDGES REMOVED.

65P 11367

68

12.9.2001.		25122-SA	PROFCRMA CHANGED, PROTECTIVE FINISH & PART No. AMENDED, NEG. RE-TRACED AND DRG. PROV. RE-SEALED.	cb	M.D.C.	DRN.	CHD.	TRD. <i>Handwritten</i>	COMP. <i>Handwritten</i>	AHSP. CQA(SA), ICHAPUR
DATE		AUTHY.	BRIEF RECORD	ZONE	I/C.D.O. G.O.	DT. 12.9.2001.	SCALE :- 2:1	EST. MASS.	APPROVED. DT. 24.11.77	ASSY.
SEALED:-		PROV. D.C.No. 19935-SA	DT. 5.3.88	SIGN		MATERIAL.	BS:970 PT.1:1972 GRD.080 M 40 OR IS:5517:1967 DESIG. C-40 OR BS:970 EN. 3		DGNR'S REF. CISA-506/18	
NOMENCLATURE :-		<b>CLIP</b>				HT/HARDNESS:	HARDENED & TEMPERED TO A HARDNESS OF 225 - 275 H.V.		PART No. 4-25/56-P-428MT	
						PROTECTIVE FINISH :-	PHOSPHATE TO SPECN. JSS 0465-01:1988 CLASS II (ACCELERATED), OIL FINISH		DRG. No. D.S.CAT. No.	