

21743-SA	21-5-92	B-3	MARKING ARROW SHOWN CORRECTLY	<i>[Signature]</i>
21061-SA	31.12.92		DRAWING RETRACED & RE-SEALED	<i>[Signature]</i>
			PREVIOUS D.C. (I) NOS. 11963-SA, 15485-SA, 17744-SA, 18183-SA, 18501-SA & 18784-SA.	COPY

METRIC

AUTHY.	DATE	ZONE	BRIEF RECORD	SIG.		
					ASSY. DRG. NO.	CQA(SA) ICHAPUR
					DGN.	
					DRN.	
					CHD.	
					TRD.	15.9.90 SHAND
					COMP.	9.10.90 Flondaf.
						DIMENSIONS ARE IN MILLIMETRES
						APPROVED. DT. 10.12.69
						CL. NEG. RETRACED
						DESIGNER'S REF.
						CISA-180
						DS. CAT. NO.
						5315-001554

PIN, REAR MOUNTING,  
7.62mm M.G., MK. 1.



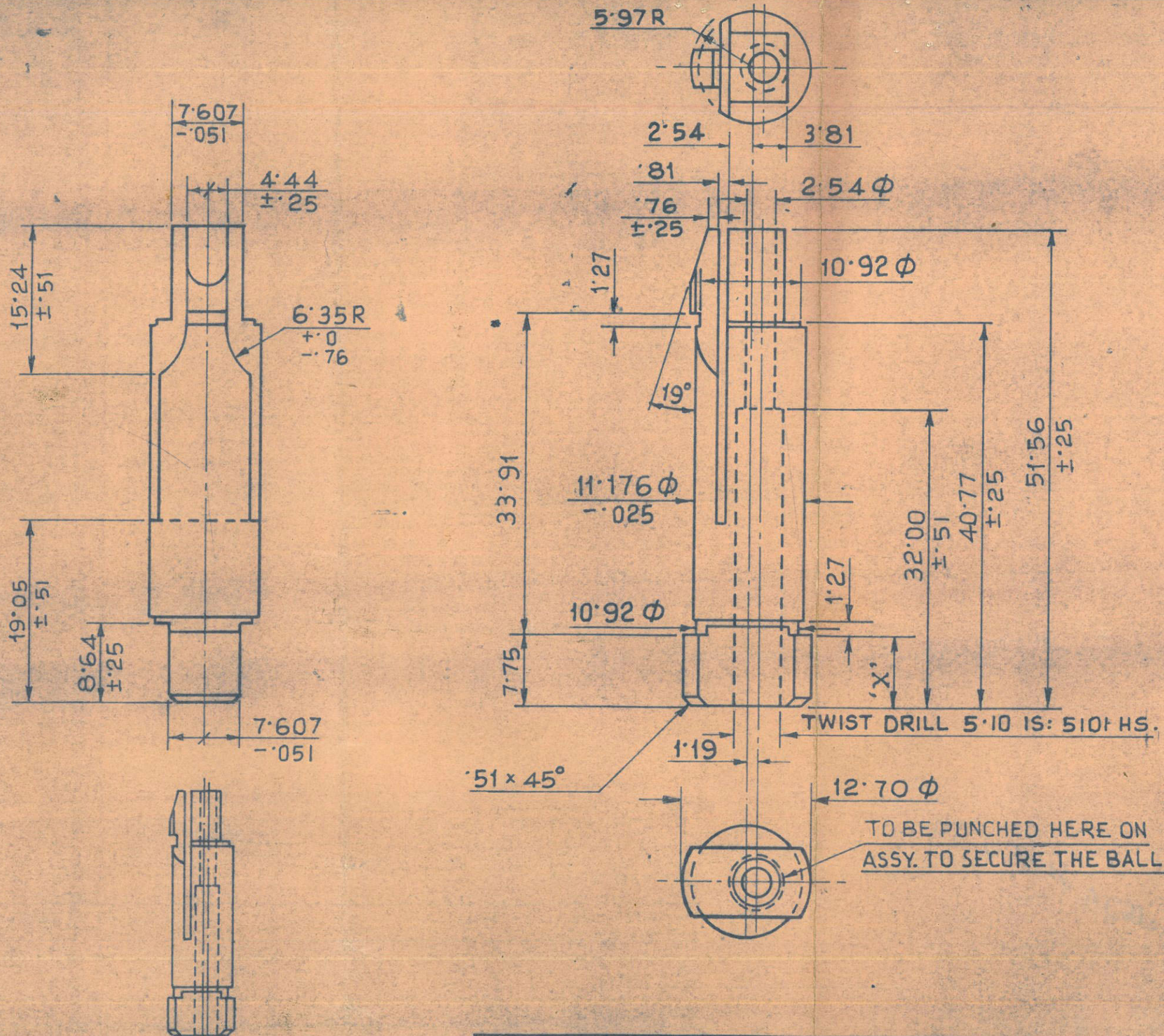
FOR EXPLANATION OF DETAILS WHERE-  
EVER NOT SPECIFIED REFER D.D.NOTE  
SHEET NO.3 (LATEST ISSUE)

MATERIAL :-  
BS 970 Pt.1:1983 Gr.080 M 50 OR  
BS 970 Pt.5:1972 Gr.250A 58 0RA61:

HEAT TREATMENT :-  
HRD. & TEMPD. TO 225 - 275 H.V. ON  
PORTION MARKED 'X' AND REMAINING  
PORTION 380 - 440 H.V.

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

ESTIMATED WEIGHT :- 27 GRAMS.



ACTUAL SIZE  
SCALE :- 1:1

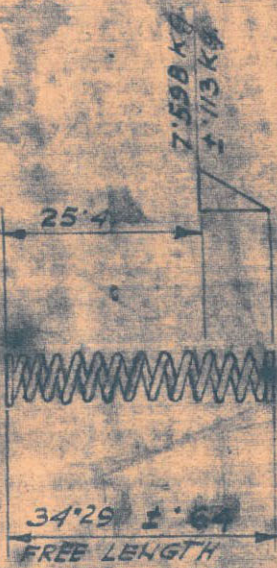
METRIC.

DATE	NAME	ASSY.	CQA(SA) ICHAPUR.
DGN.		D.S.CAT.NO. 5315-001554	
DRN.		MATERIAL :- AS STATED.	
CHD.		DIMENSIONS ARE IN MILLIMETRES	
TRD.	7.2.94 B.L.NATH		
COMP.	Wankar		APPROVED. DT.10.12.69
AUTHY.	22544-21.5.94 SA	PREVIOUS D.C.NOS. 11963-SA, 15485-SA, 17823-SA, 18325-SA, 18427-SA, 19457-SA, 22126-SA, 22212-SA & 22220-SA.	NEG. RE-TRACED.
DATE <td>23.5.94</td> <td>SCALE :- 2:1</td> <td>DESIGNER'S REF. CISA 180/1</td>	23.5.94	SCALE :- 2:1	DESIGNER'S REF. CISA 180/1
ZONE <td></td> <td>SEALED. ASA RE- CORD OF RECEIPT D.C.(1) 11963-SA DT 7.2.74</td> <td>D.S.CAT. NO. 5315-001555</td>		SEALED. ASA RE- CORD OF RECEIPT D.C.(1) 11963-SA DT 7.2.74	D.S.CAT. NO. 5315-001555
BRIEF RECORD. <td></td> <td>COPY. <td></td> </td>		COPY. <td></td>	
SIG. <td> <td> <td></td> </td></td>	<td> <td></td> </td>	<td></td>	

PIN REAR MOUNTING.



COMPRESSED LENGTH



18443-SA	24.685	
15485-SA	8.2.78	
05. CAT. NO. 10000		MATL. AMENDED
		SSO

TOTAL NO. OF COILS: -  $22 \pm \frac{1}{2}$   
 OUTSIDE DIMETER: -  $4.00 \pm 0.10$   
 DIA. OF WIRE: -  $1.00 \pm 0.02$  (SWG)  
 SPRING SHOULD WORK FREELY INSIDE A BORE OF 5.08  
 ONE COIL AT EACH END TO BE CLOSED IN GROUND SQUARE TO THE AXIS OF SPRING LEAVING  $\frac{3}{4}$  OF A COIL NON-EFFECTIVE AT EACH END.

SPRING TO BE COMPRESSED TO A LENGTH OF 25 FOR 12 HOURS IMMEDIATELY BEFORE GAUGING.

NOTE: - WHERE TOLERANCES ARE NOT SHOWN DIMENSIONS IN WHOLE NUMBER OR WITH ONE DECIMAL PLACE  $\pm 1.27$  mm DIMENSIONS WITH TWO DECIMAL PLACES  $\pm 0.13$  mm

METRIC

14330-SA	20.6.75	DIM. 34.29 ± 0.64 WAS	K. Singh
		DIM. 34.29 ± 0.25	856
11963-SA	7-2-74	DRG. SEALED AS A RECORD OF RECEIPT	K. Singh
			855
AUTHY.	DATE	ZONE	BRIEF RECORD
			319

FOR EXPLANATION	DATE	NAME
NO. 5		
PROTECTIVE FINISH: - PHOSPHATE TO SPECN. W/PN/GEN/3 CLASS II. O.L. FINISH		
SCALE: - 1/1		
SEALED: - AS A RECORD OF RECEIPT. DCU 11963-SA. DT. 7-2-74		

ASSY. 5315-001554

MATERIAL: BS 5216:1975 M500ND-3

DIMENSIONS ARE IN MILLIMETRES

APPROVED

DESIGNED BY

CISA 100

5360-000538

SPRING