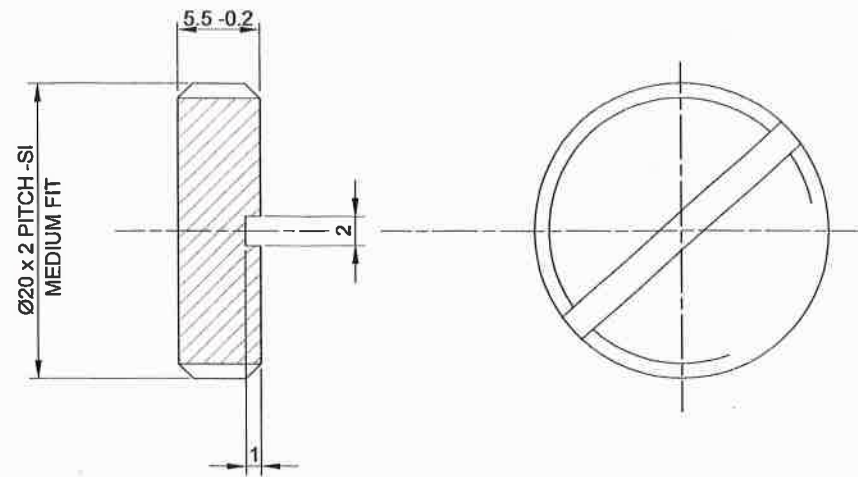


DRG. NO:
C PLG 081 1 030 0

REFERENCE



UNLESS OTHERWISE SPECIFIED TOL. ARE
UPTO 10mm = ±0.1
ABOVE 10mm = J 13

ALL DIMS. ARE IN mm

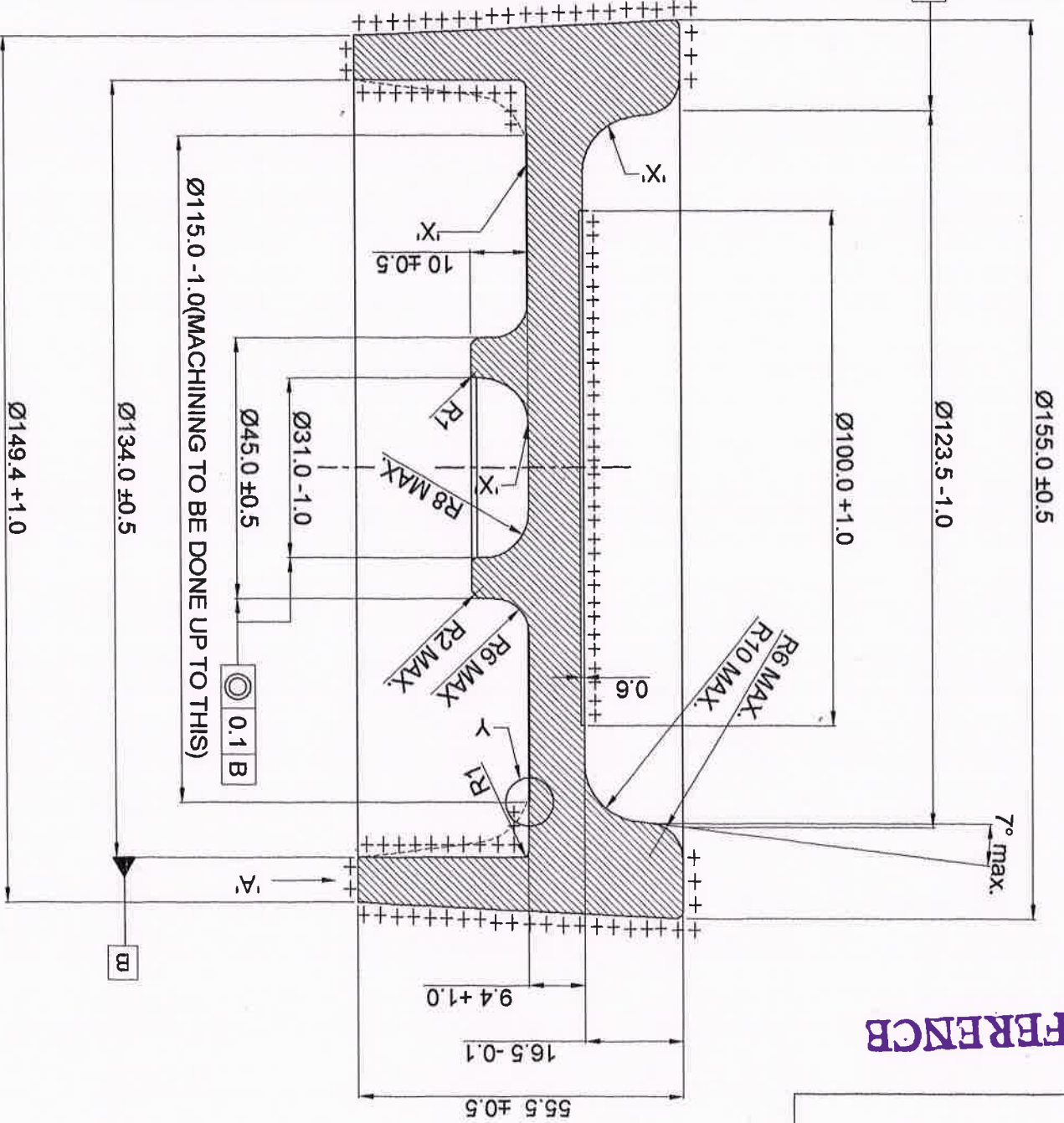
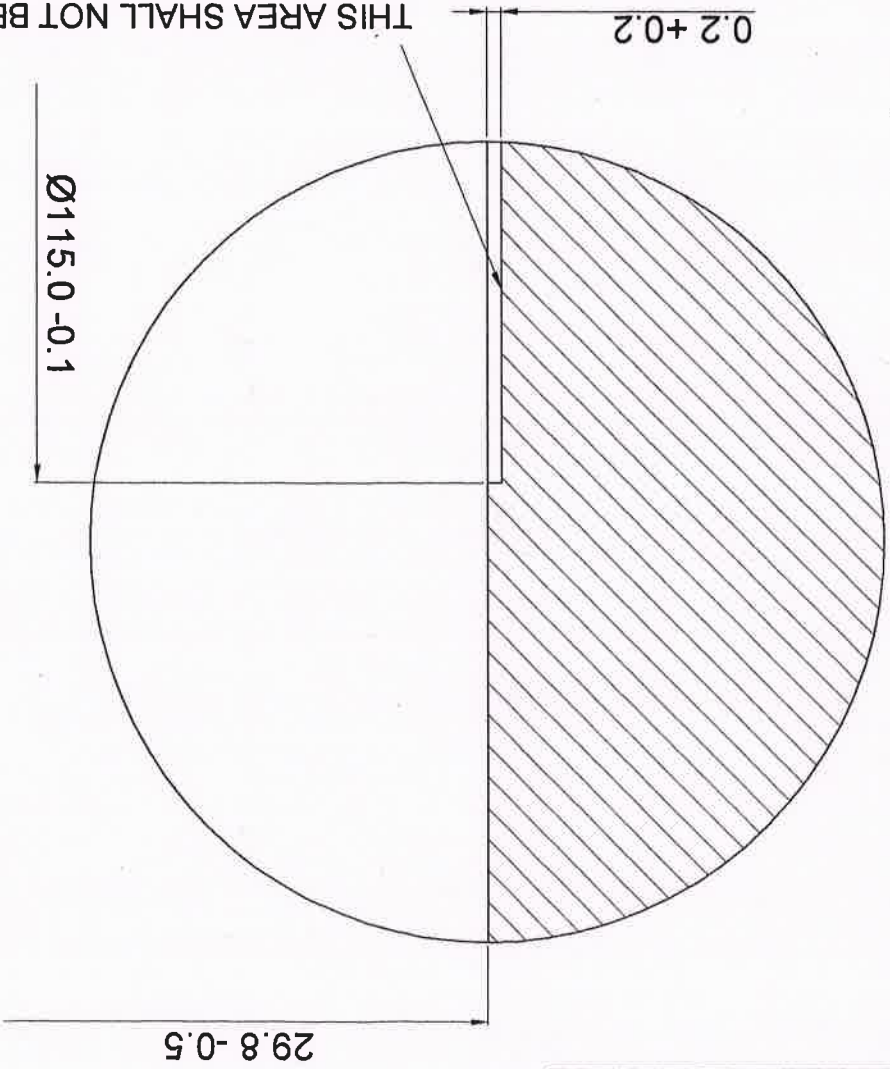
MATERIAL		LATEST REF./DC NO.:	
STEEL TO SPECN.B.S:970:pt3, 1991.GRADE 070M20 NORMALISED OR BRIGHT FINISHED (OTHER THAN COLD DRAWN)	1	C. I (A), KIRKEE DRG ITV-52	
GAUGE SCHEDULE		DRAWN	
I-1552		CHECKED	
SURFACE FINISH		USER SEC	
3.2		CHECKED	
EST.MASS		HOS/DDO	SHEET
PRO/FINAL		APPRD.	1 OF 1
		DATE	REV
		SCALE	1:1
		DRG. NO.:	
		C PLG 081 1 030 0	

TITLE : **PLUG REAR**
FOR 81mm MORTOR BOMB BODY
HEAVY ALLOY PENETRATOR PROJECT
TIRUCHIRAPALLI

DRG NO:	0 ADF 155 2 010
REV	8

DRAWING CONVENTIONS CONFORM TO INDIAN STANDARD DIMENSIONS IN MM UNLESS OTHERWISE STATED.

REFERENCE



NOTES

1. THE FORGING SHOULD BE HEAT TREATED TO OBTAIN MECHANICAL PROPERTIES IN ACCORDANCE WITH CONDITION "V" BS 970 PART I 1983 AND SHOT BLASTED TO REMOVE SCALE IN THE FORGINGS
2. FORGING SHOULD BE SUPPLIED AFTER PROOF MACHINING
3. FORGING SHOULD BE FREE FROM CRACKS & FLAWS
4. 100% MAGNETIC PARTICLE TEST MUST BE DONE FOR CRACK DETECTION
5. 'X' - FORGING WITH PIT / DENT MARKS ON THIS SURFACE IS NOT ACCEPTABLE
6. DIMENSIONS SHOWN IN THE DRG. ARE AFTER PROOF MACHINING

REV	8	0 ADF 155 2 010
DRG. NO. HEAVY ALLOY PENETRATOR PROJECT		
TITLE: ADAPTOR FORGING		
REV	DATE	ALTERATIONS
1	23/8/07	DIM. R6 & R8 WAS R1
2	17/9/07	IN NOTES STRESS RELIEVING ADDED & HARDNESS 32-35 WAS 31-37 HRC POINTS NO. 5 & 6 ADDED
3	08/10/07	NOTE 6 DELETED
4	23/11/07	TOL. ADDED
5	16/01/08	DIM 6.5 WAS 17.1; PROOF MACHINING SURFACES ADDED; DETAIL Y ADDED; NOTE 6 ADDED; SIDE VIEW REMOVED; NOTE 1 AMENDED; MATERIAL AMENDED
6	22-10-08	IN MATERIAL LIST, OTHER THAN STEEL 709 M40 ARE REMOVED
7	21-11-08	MASS ADDED; NOTE 8 AMENDED; DIM 9.4 ± 1.0 WAS 9.4 ± 0.7
8	11-03-10	CONCENTRICITY WITH RESPECT TO DATUM 'B' ADDED
MATERIAL: BS-970 PART-1 1983 STEEL 709 M40		
HARDNESS: 32-35 HRC		
SUR. FINISH/COAT		
EST. MASS: 3310g ± 50.0 g		

DATE	18/08/07
SCALE	NTS
HOS/DDO	APPRD.
CHECK	
USER SEC	
CHECK	
DRAWN	

REF - 02676-20012 A02

REMOVE ALL SHARP EDGES
ALL DIMENSIONS ARE IN mm

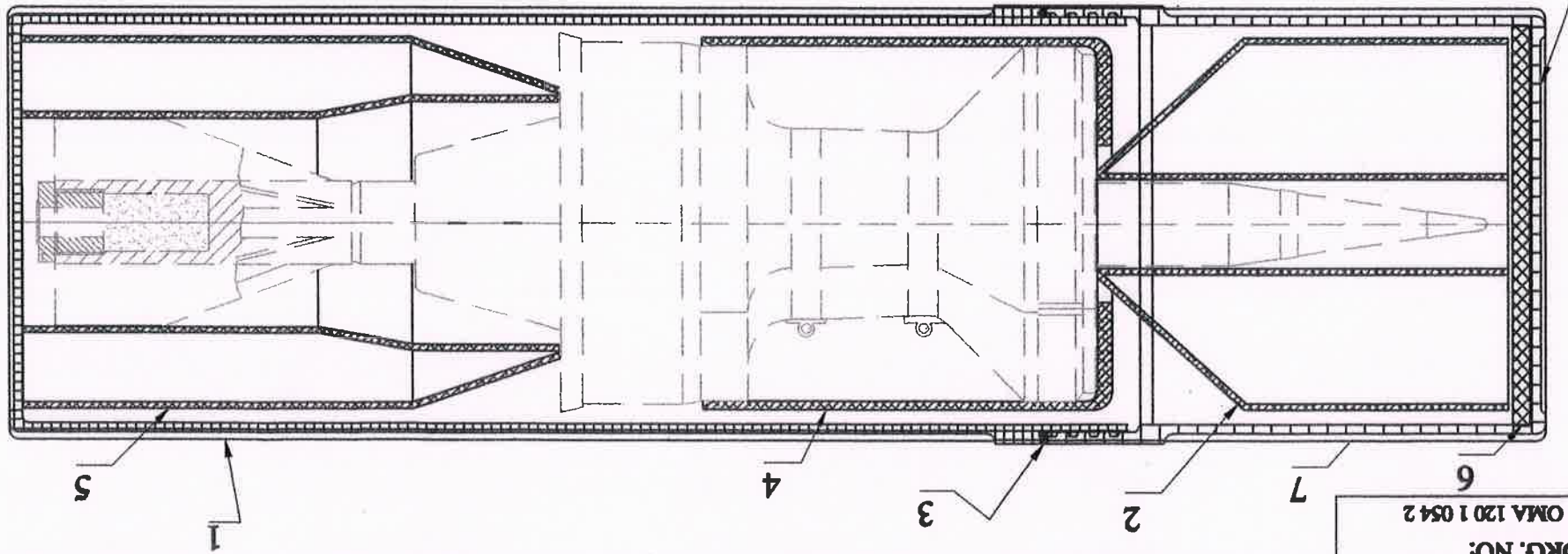
++ PROOF MACHINING MUST BE DONE

H OMA 120 1 054 2		DRG. NO:		HEAVY ALLOY PENETRATOR PROJECT	
SECTION		SCALE		TITLE:	
DESIGN		1:1		CONTAINER FOR 120mm FSAPDS	
REV		DATE		ISSUE	
2		06/06/02		1	
APPRD.		CHECKD.		ALTERATIONS	
1 OR 4		1		DRAWING WAS REDRAWN	
SHEET		DRAWN		1. DRAWING WAS REDRAWN	
1		REV.		2. NOTE 7 AMENDED, MARKING SYMBOLS HAS BEEN SHOWN ON ITEM NO.7	
DRAWN		AL.T.NO		DATE	
1		1		ASGN	

ALL DIMENSIONS ARE IN MM

SL NO	DESCRIPTION	MATERIAL	QTY.
1	BODY	SEE NOTE-1	1
2	SLEEVE TOP	SEE NOTE-1	1
3	GASKET	NEOPRENE RUBBER TO SPECN: IND/ME/884(PROV)	1
4	SLEEVE MIDDLE	SEE NOTE-1	1
5	SLEEVE BOTTOM	SEE NOTE-1	1
6	CUSHION PAD TOP	SPONGE RUBBER TO SPECN: IND/ME/645	1
7	LID	SEE NOTE-1	1

REFERENCE



DRG. NO: H OMA 120 1 054 2

NOTE:
 1. MATERIAL: FOR ITEMS 1, 2, 4, 5 & 7
 HIGH DENSITY POLYETHENE TO SPEC 1213/A IN NATURAL COLOR.
 2. HARDNESS FOR ITEM NO. 3 CLASS C-2
 51 TO 55, NOT TO EXCEED HIGHER
 LIMIT.
 3. ITEM NO. 3 TO BE FREE FROM FLASH ON SURFACE
 PRESERVED IN TALC DUST, TO BE COATED WITH SILICON
 GREASE BEFORE ASSEMBLY.
 4. CONTAINER WITH SHOT SHALL CONFORM TO SPECN. FOR
 DROP TEST-JSG 0102
 5. IF IN DOUBT GET IT CLARIFIED BEFORE MANUFACTURING.
 6. ADVANCE SAMPLE TO BE SUPPLIED AND THE SAMPLE WILL
 BE TESTED FOR ACTUAL PRODUCTION CONDITIONS BEFORE
 FINAL ACCEPTANCE AND BULK SUPPLY.
 7. MARKING
 FOLLOWING DETAILS ARE TO BE EMBOSSED IN 8MM SIZE, 1.2MM THICKNESS
 ON FACE 'A' OF ITEM NO 7, EXCEPT ORB EMBLEM
 * ORB EMBLEM (20mm SIZE) AS SHOWN IN DRG. NO K GEN 000 0 220 0
 + CALIBER SIZE 120mm ⊕ YEAR OF MANUFACTURING
 ☑ MANUFACTURER'S INITIAL

H OMA 120 1 054 2		TIRUCHIRAPALLI	
DRG. NO:		HEAVY ALLOY PENETRATOR PROJECT	
SECTION DESIGN	SCALE	TITLE :	
REV 2	1:1	CONTAINER	
DATE	APPRD.	FOR 120mm FSAPDS	
02/12/02		ALTERATIONS	
3 OF 4	CHECKD.	ISSUE	
SHEET	DRAWN	1	REFER SHT 1 OF 4.
	REV.	2	REFER SHT 1 OF 4.
	ALT. NO		
	DATE		
	DESIGN		

ALL DIMENSIONS ARE IN MM

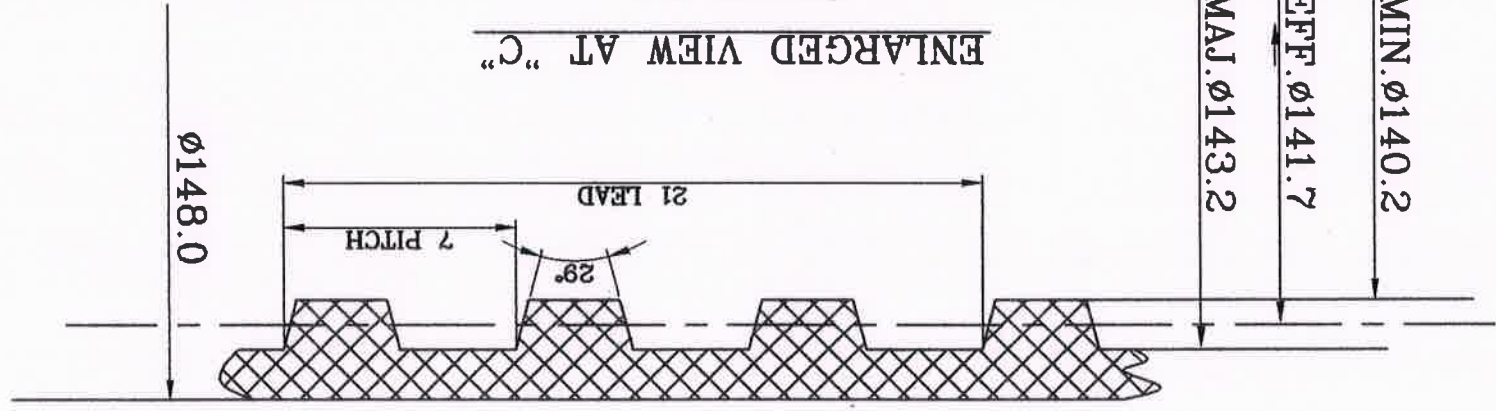
THIS DRG. SUPERSEDES THE DRG. NO H OMA 120 1 053 1

MATERIAL: REF NOTE 1
 QTY-1
 LTD

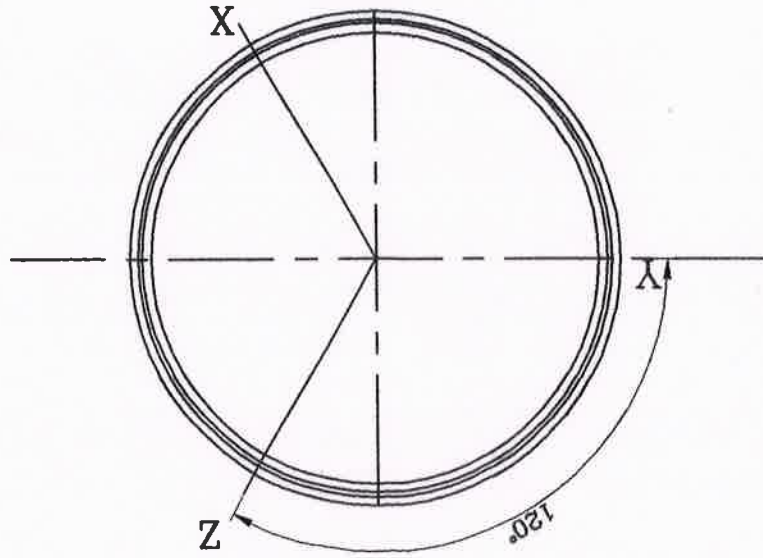
ABRUPT START OF PERFECT THREAD 3 START THREAD RH

SCALE-5:1

ENLARGED VIEW AT "C"



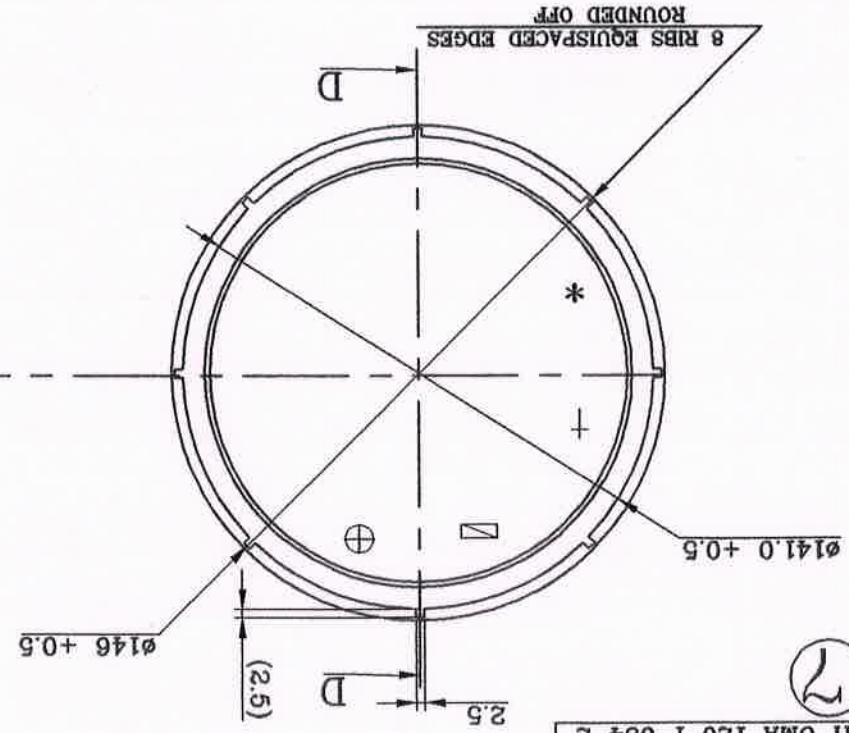
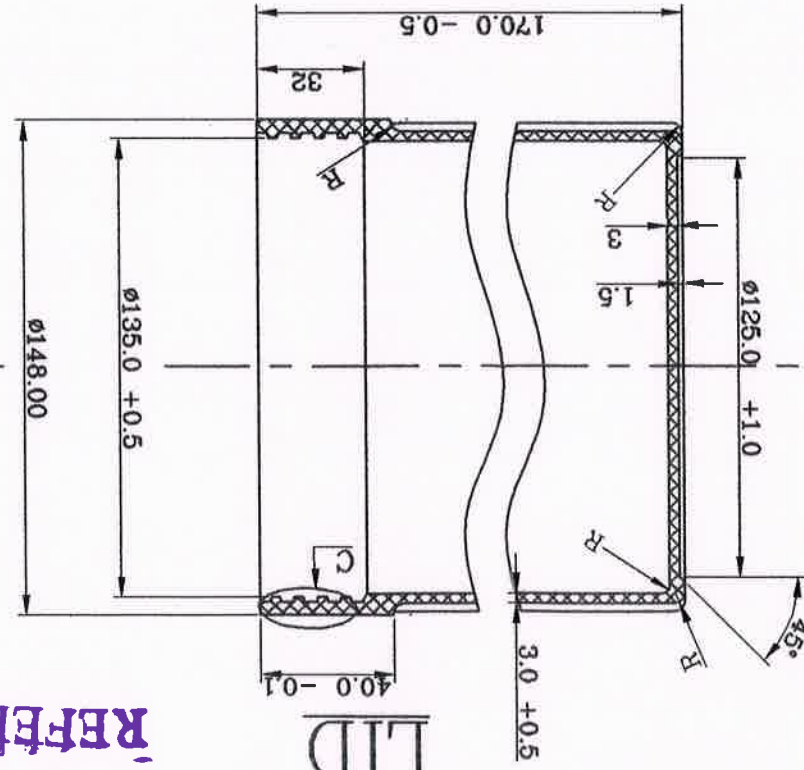
3 START RH THREAD SHOWING AT XYZ



REFERENCE

LTD

SECTION "D-D"

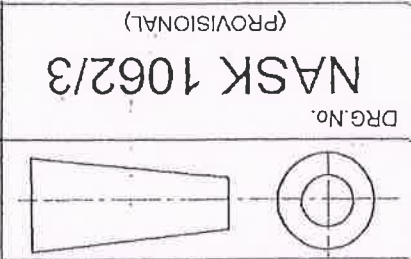


DRG. NO: H OMA 120 1 054 2

2

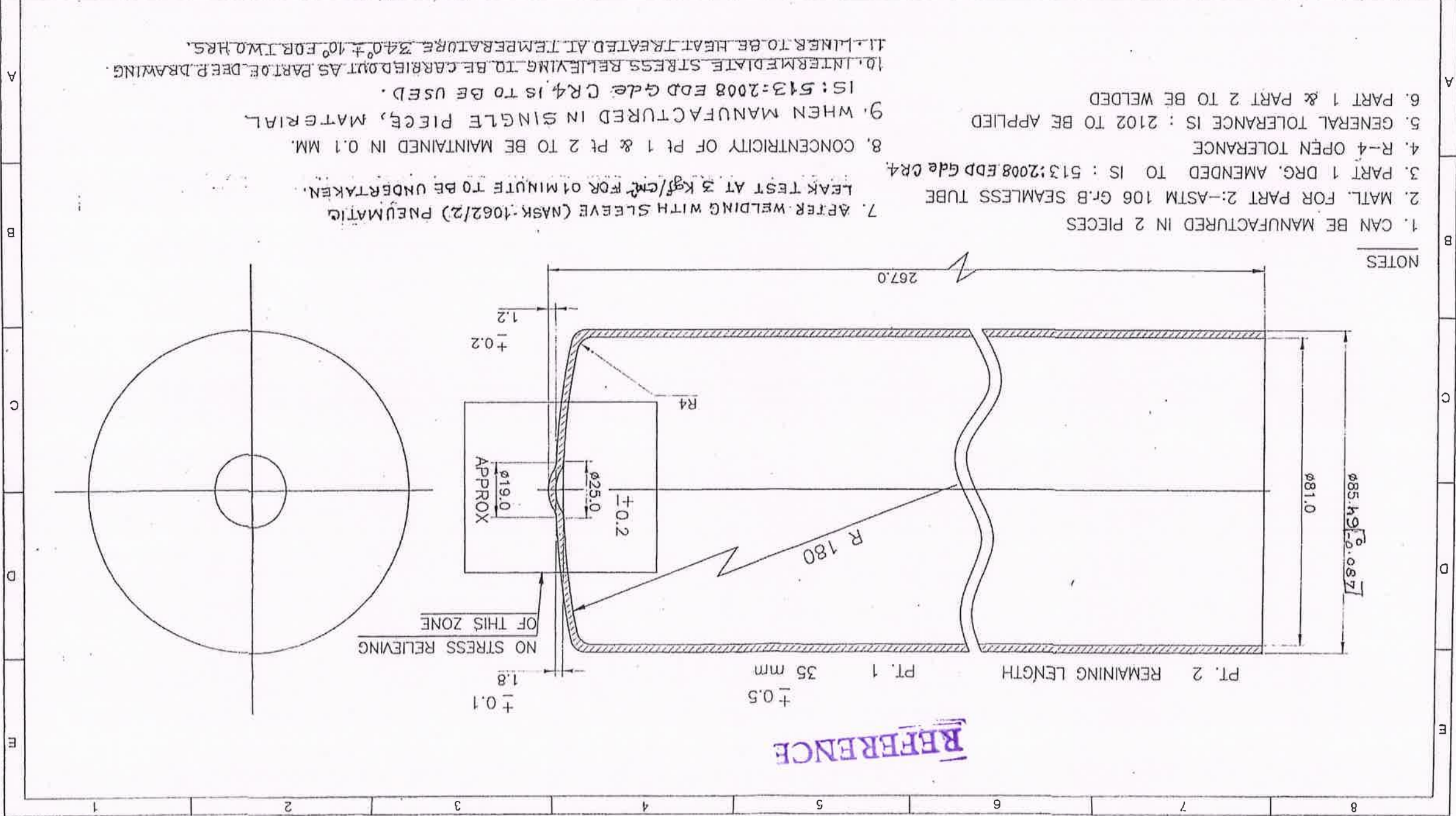
TRIM ON THIS LINE WHEN SUPPLIED TO TRADE

LINER



DRG. No. **NASK 1062/3**
(PROVISIONAL)

ASSY. DRG. No. NASK 1062(P)	ASSY. DRG. LIST No.	DTE GEN OF NAVAL ARMAMENT INSPECTION HQ, MOD (NAVY), N DELHI	R No.	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS	PROTECTIVE FINISH, SEE ASSY DRG	GAUGE SCHEDULE No.
			22-09-15	22-09-15		MATL SPEC AMENDED & NOTES ADDED	ARD2484			
			22-09-15	22-09-15	C-D-8	DIMENSION AMENDED	ARD2479		PASSED	THREADS TO CONFORM IS:4218
			13-02-14	13-02-14		NOTES SL. NO 7 AMENDED	ARD2453		APPROVED	GEN. SPEC. IS:2102
			14-01-11	14-01-11		NOTE - 9 ADDED	ARD2415			STORE SPEC. NO.
			02-06-09	02-06-09		APPROVED	DGNAI			STORE REF. No.



- NOTES**
1. CAN BE MANUFACTURED IN 2 PIECES
 2. MATL. FOR PART 2:-ASTM 106 GR.B SEAMLESS TUBE
 3. PART 1 DRG. AMENDED TO IS : 513:2008 EDD Gde CR4
 4. R-4 OPEN TOLERANCE
 5. GENERAL TOLERANCE IS : 2102 TO BE APPLIED
 6. PART 1 & PART 2 TO BE WELDED
 7. AFTER WELDING WITH SLEEVE (NASK-1062/2) PNEUMATIC LEAK TEST AT 3 Kgf/cm² FOR 01 MINUTE TO BE UNDERTAKEN.
 8. CONCENTRICITY OF Pt 1 & Pt 2 TO BE MAINTAINED IN 0.1 MM.
 9. WHEN MANUFACTURED IN SINGLE PIECE, MATERIAL IS : 513:2008 EDD Gde CR4 IS TO BE USED.
 10. INTERMEDIATE STRESS RELIEVING TO BE CARRIED OUT AS PART OF DEEP DRAWING.
 11. LINER TO BE HEAT TREATED AT TEMPERATURE 340 ± 10° FOR TWO HRS.

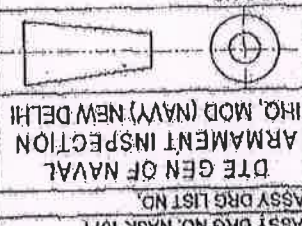
1 2 3 4 5 6 7 8

R NO	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS
13-214			NOTE ADDED	ARD 2453	
14-111		F-4	2 HOLES DIA AMENDED	ARD 2413	
12-474			APPROVED		

SCALE: 1:1	DIMENSIONS ARE mm	TOL	DS CAT NO	ASSY DRG NO. NASK 1071
DGN	DRN	ICD	COMP	CHD
PASSED	APPROVED	THREADS TO CONFIRM IS: 4218		
MATL: STEEL CASTING	GEN SPEC:	STORE SPEC NO:		
MATL SPEC. IS 2858 AT 022 NORMALISED CONDITION	STORE REF NO:			
PROTECTIVE FINISH: SEE DRG	GUAGE SCH NO:			

DIAPHRAGM (NOZZLE PLATE)

DRG NO
NASK 1071/4
(PROVISIONAL)

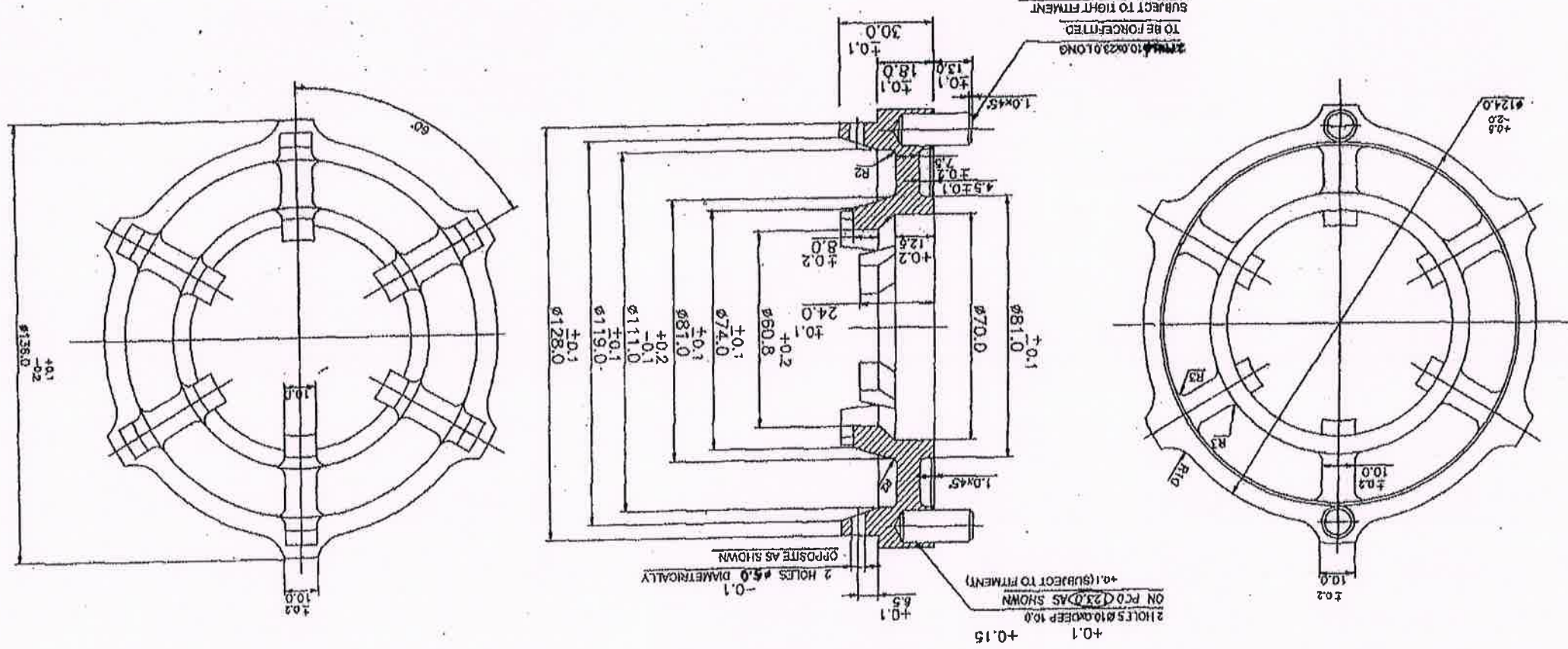


DTE GEN OF NAVAL
ARMAMENT INSPECTION
HQ, MOD (NAVY) NEW DELHI

BLOW HOLES TO BE INSPECTED AS PER IS 5530
AS CAST CONDITION BUT ALL FEATURES AT ALL
POINTS MUST BE WITHIN THE SPECIFIED TOLERANCES.

WITH OLIVE GREEN ISC NO. 220 TO SPEC IS:5
PROTECTIVE FINISH: PHOSPHATED TO SPEC IS:3818 CLASS 'B' AND THEN PAINTED

PIN MATERIAL: STEEL TO IS: 5517 GRADE: 30C8/40C8 HARDENED TO 25 HRC MIN.



REFERENCE

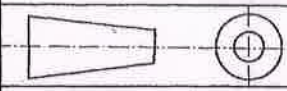
TRIM ON THIS LINE WHEN SUPPLY TO TRADE

R NO	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS
21-01-16	12-12-14	D-3&5	DRAWING AMENDED	ARD 2490	[Signature]
	12-12-14	D-3&5	DIMENSIONS AMENDED	ARD 2452	[Signature]
	14-1-11		2 HOLES ϕ 4.5 AMENDED	ARD 2413	[Signature]
	02-06-07		APPROVED	DGNAL	[Signature]

SCALE: 1:1	DIMENSIONS ARE mm	TOL	DS CAT NO	ASSY DRG NO. NASK 1068 (PROV)
			COMP	CHD
			DRN	TCD
			APPROVED	APPROVED
			THREADS TO CONFIRM IS: 4218	GEN SPEC. IS: 2102
			STORE SPEC NO-	STORE REF NO-
			MATL. STEEL CASTING	MATL SPEC.- SEE DRG
			PROTECTIVE FINISH: SEE DRG	GAUGE SCH NO-

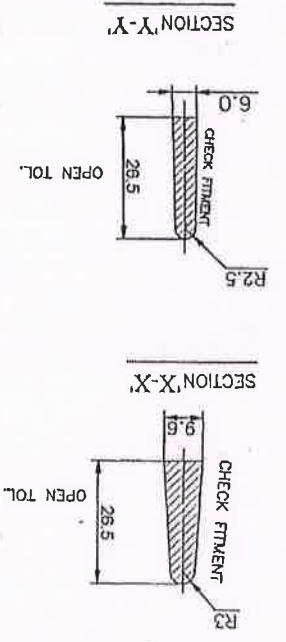
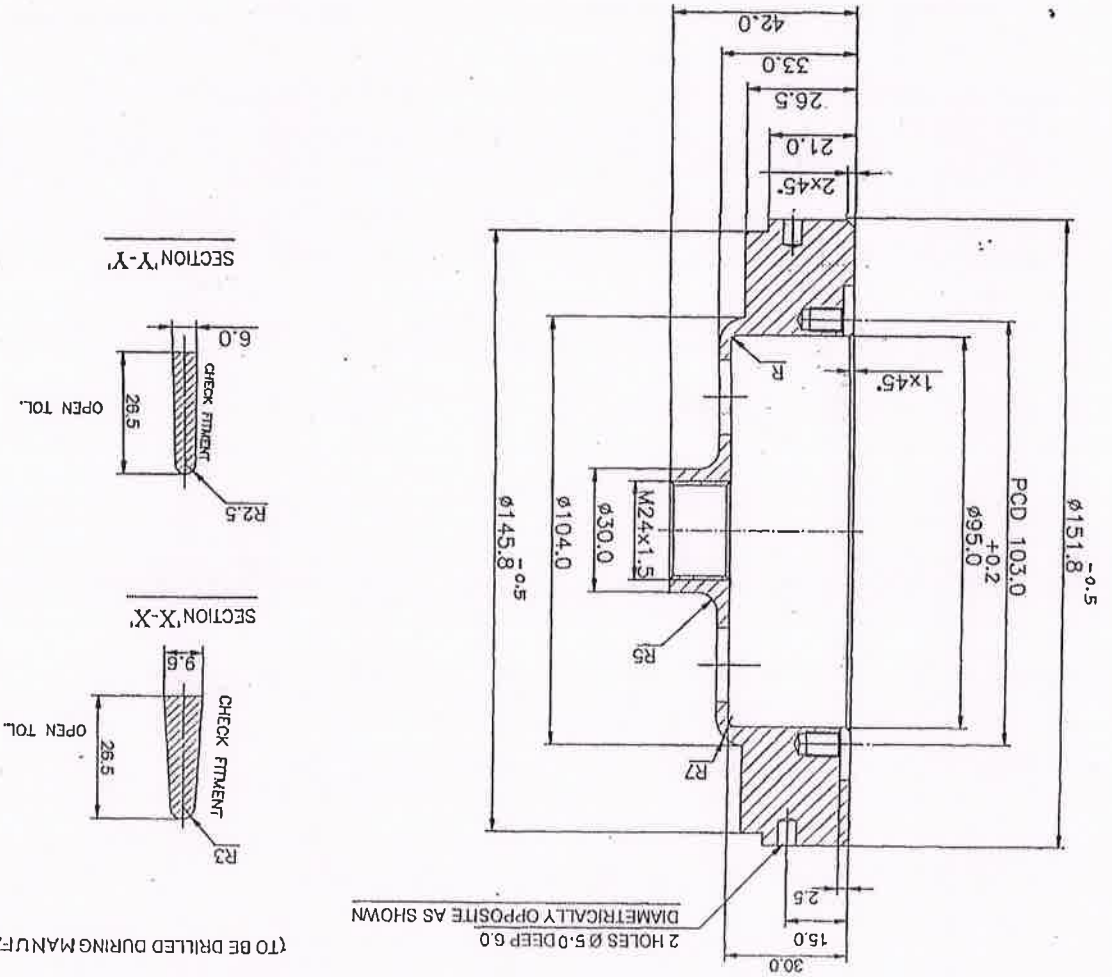
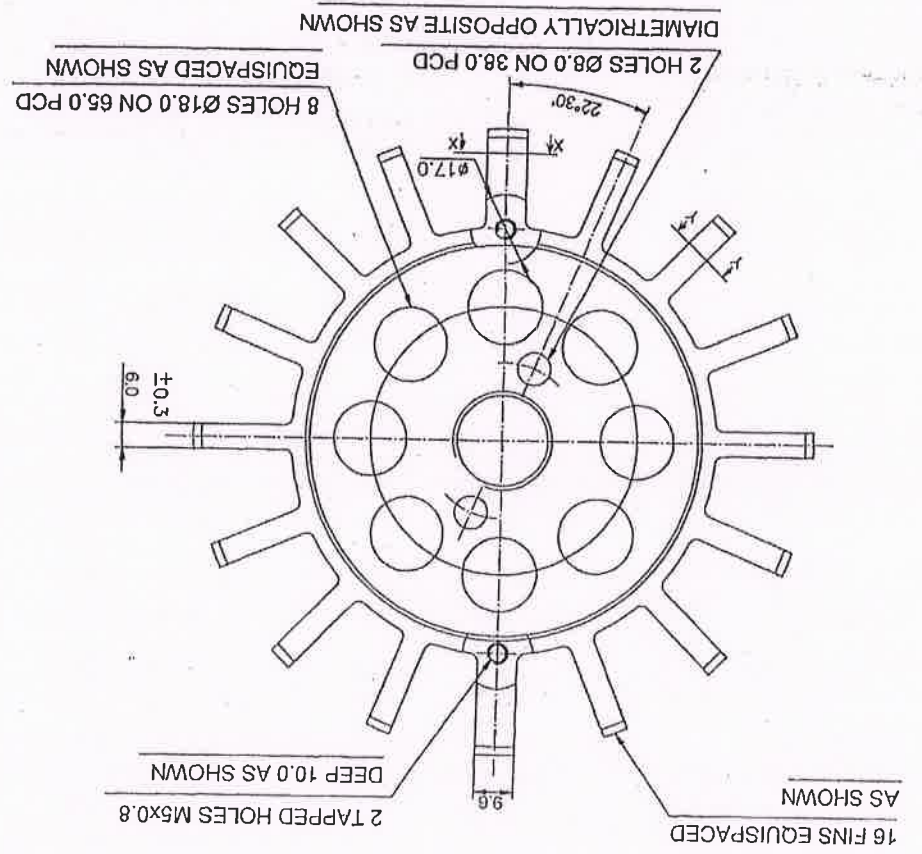
DIAPHRAGM
(ASSY ADAPTER)

DRG NO
NASK 1068/7
(PROV)



DTE GEN OF NAVAL
ARMAMENT INSPECTION
HQ, MOD (NAVY) NEW DELHI

- NOTES:
1. GEN. TOL. SPEC. IS : 2102
 2. ϕ 95.0 TOL. ON POSITIVE SIDE
 3. CHROMIUM PLATING THICK 40 MICRON TO IS : 1337
 4. BLOW HOLES TO BE REPAIRED
AS PER IS : 5530-1969



(TO BE DRILLED DURING MANUFACTURING)

REFERENCE

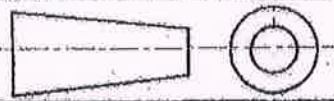
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Received vide below letter no
M/1113 dated 01 Jul 16

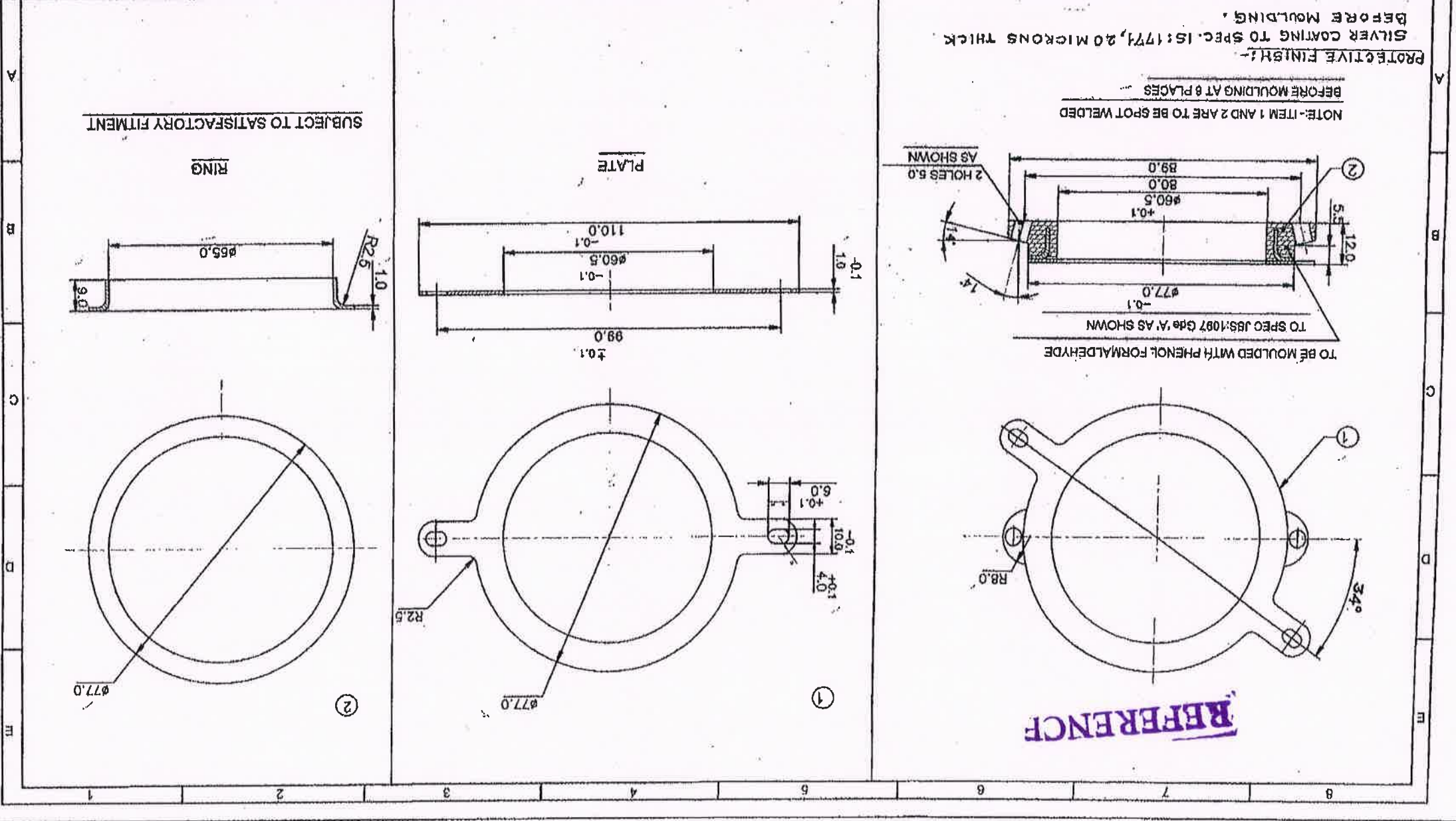
A-3

BUS BAR

DRG.No. **NASK 1071/8**
 (PROVISIONAL)



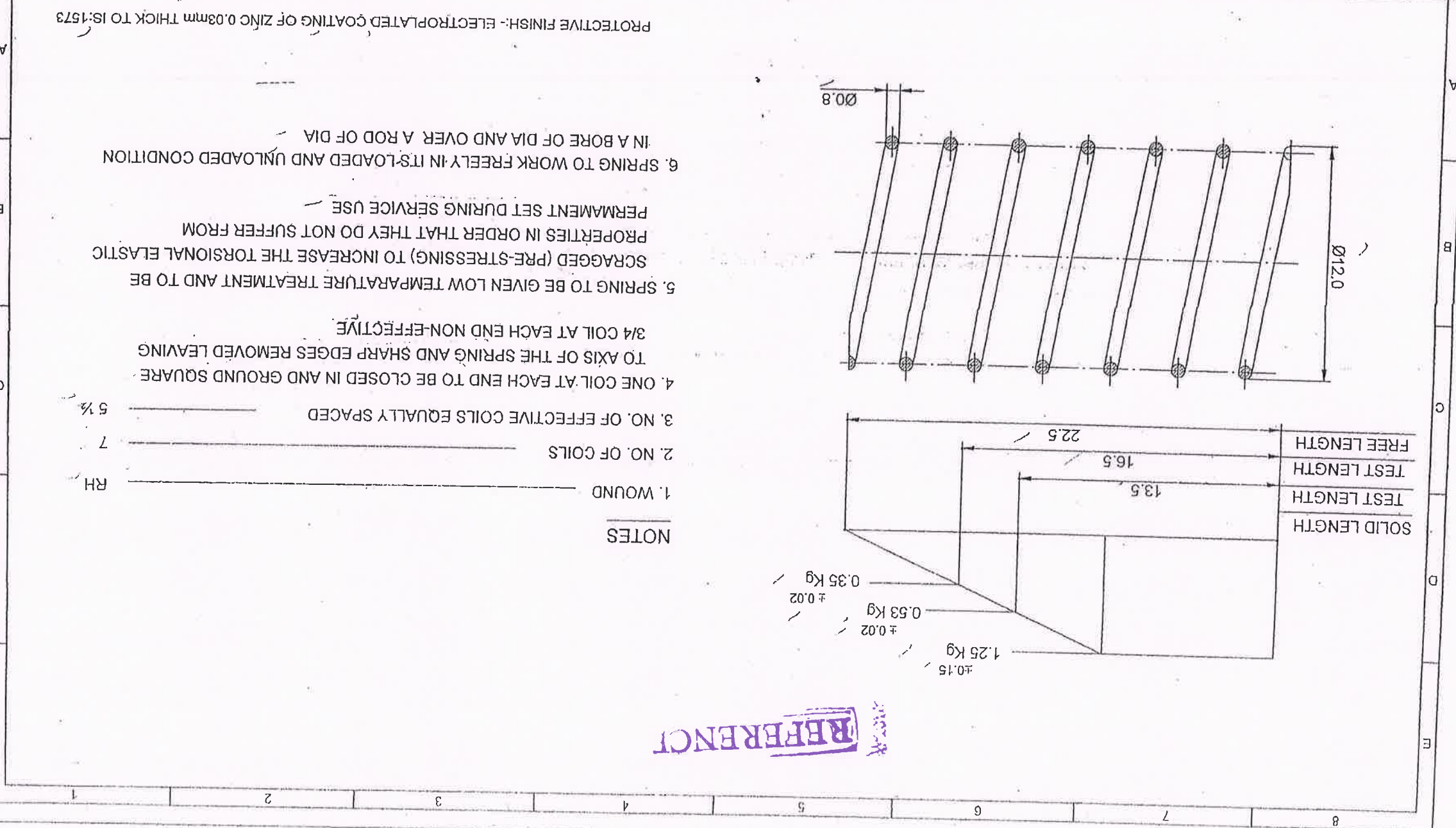
R.No	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS	PROTECTIVE FINISH	GAUGE SCHEDULE No.
13-02-14	13-02-14		FOR: 36°, READ: 3.4°	ARD 2413		MATL. STEEL	
14-11-11	14-11-11		PROTECTIVE FINISH ADDED	ARD 2413		MATL. STEEL	
02-06-09	02-06-09		APPROVED	DGNAL		MATL. SPEC.:- IS:6603-72, Gd& 07 CR16 NIB OR IS:613 Gd' O' EDD	STORE REF. No.
							STORE SPEC. NO.
							GEN. SPEC. IS:2102
							THREADS TO CONFIRM IS:4218
							APPROVED
							COMP. CHD.
							TOL.
							D.S.CAT No.
							ASSY. DRG. LIST No.
							ASSY. DRG. No. NASK 1071



TRIM ON THIS LINE WHEN SUPPLIED TO TRADE

R.No		DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS	PROTECTIVE FINISH:- SEE DRG	GUAGE SCHEDULE No.
22-09-15		08-09-09		MATL SPEC AMENDED	ARD2484		MATL SPEC:- IS:4454 (Pt.1) 2001 GRADE-5M	STORE REF. No.
		02-06-09		DCA No ADDED	ARD2396		MATL:- STEEL	STORE SPEC. NO.
				APPROVED	DGNAI		PROTECTIVE FINISH:- SEE DRG	ARMAMENT INSPECTION
							THREDS TO CONFIRM IS:4218	DTE GEN OF NAVAL
							APPROVED	ARMAMENT (NAVY), N.DELHI
							APPROVED	(PROVISIONAL)
							DRN	
							TCD	
							COMP.	
							CHD.	
							ASSTY.DRG.LIST No.	
							ASSTY.DRG. No.: NASK 1088/2	
							TOL	
							D.S.CAT No	
							ASSTY.DRG. No.: NASK 1088/2	
							SCALE:- 5:1	
							DIMENSIONS ARE IN mm	

SPRING



REFERENCE

TRIM ON THIS LINE WHEN SUPPLIED TO TRADE

Received with Naval letter no A1/4113 dated 01 Oct 16

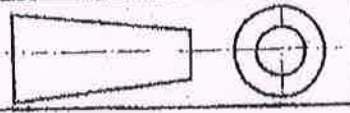
TRIM ON THIS LINE WHEN SUPPLIED TO TRADE

USED ON:- ROCKET RGB 60

BASED ON:- CNA(M) DRG No. NA(M) 8007/6(P) DT 13-02-08

ASSY CONTACT

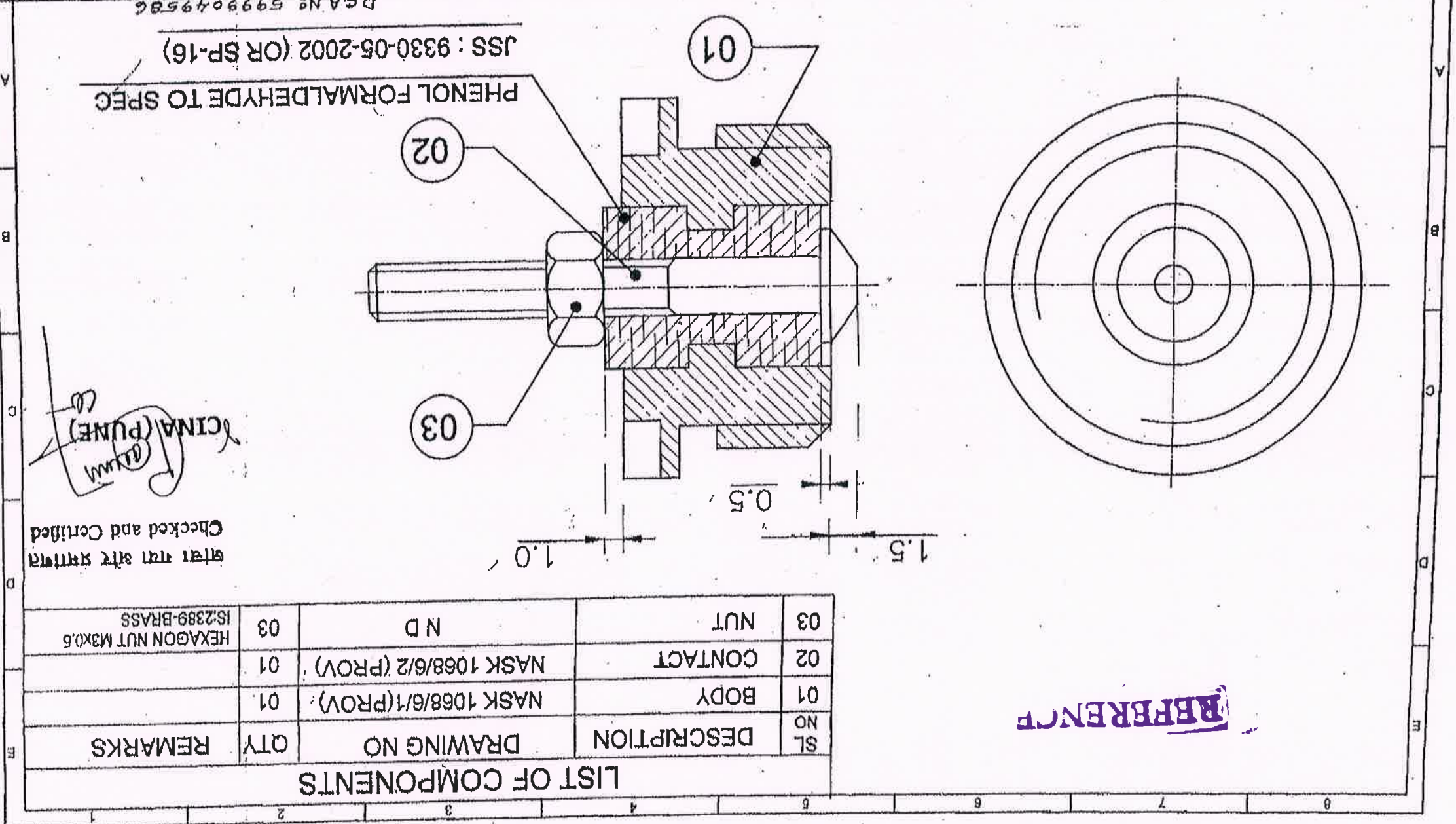
NASK 1068/6
(PROVISIONAL)
DRG. No.



DTE GEN OF NAVAL
ARMAMENT INSPECTION
IHO, MOD (NAVY), N. DELHI

ASSY DRG. NO. NASK1068 & 1071
ASSY DRG. LIST No.

R.No	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS	PROTECTIVE FINISH	GAUGE SCHEDULE No.
08/09/09	02-06-09		DCA NE ADDED	APP 2236		MATL. SPEC.	STORE REF. No.
			APPROVED	DGNAL		MATL. SPEC.	STORE SPEC. NO.
							GEN. SPEC. IS: 2102
							THREADS CONFORM TO IS: 4218
							APPROVED
							COMP. V
							CHD.
							TOP
							DRN
							P.S.V.
							APPROVED



SL NO	DESCRIPTION	DRAWING NO	QTY	REMARKS
01	BODY	NASK 1068/6/1 (PROV)	01	
02	CONTACT	NASK 1068/6/2 (PROV)	01	
03	NUT	N D	03	HEXAGON NUT M3X0.5 IS: 2389-BRASS

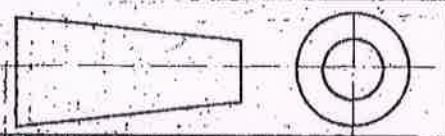
Checked and Certified
Rajima (PUNE)

REFERENCE

93

ASSY CENTRE CONTACT

DRG No. **NASK1068/8**
(PROVISIONAL)

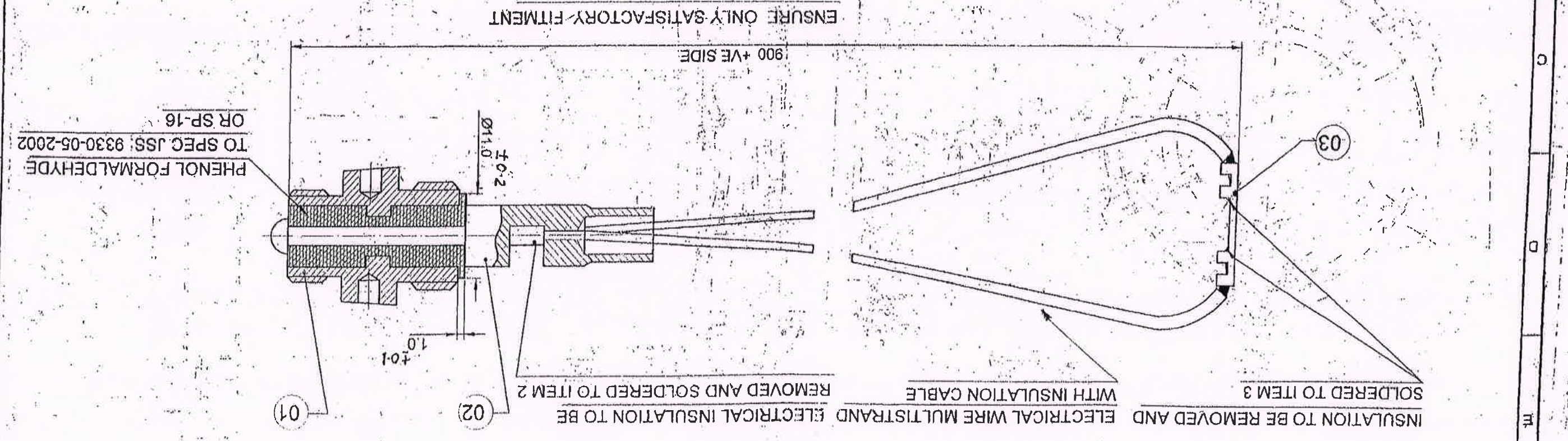


R.No	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS	PROTECTIVE FINISH	Gauge SCHEDULE No.
	02-06-09		APPROVED	DGNAI		MATL SPEC.	STORE REF. No.
	14.1.11		NOTE - 6 ADDED	ARD2413		MATL.	STORE SPEC. NO.
						GEN. SPEC. IS: 2102	DTE GEN OF NAVAL
						APPROVED	ARMAMENT INSPECTION
						APPROVED	IHQ, MOD (NAVY), N DELHI
						DRN P. S. W. T. CD	
						DGN.	ASSY DRG. No. 1068
						DIMENSIONS ARE IN mm	ASSY DRG. No. 1068
						TOL	D.S.CAT No
						COMP.	CHD. No.
						THREADS TO CONFIRM IS: 4218	ASSY DRG. LIST No.

- NOTES:-
1. DIA OF COPPER WIRE WITH PVC INSULATION : 19
 2. NUMBER OF STRANDS : 16 TO 19
 3. DIA OF EACH STRAND : 0.21
 4. GAUGE NO. OF WIRE (INDIVIDUAL STRAND) : 35
 5. LR OF WIRE : > 20 ML WITH 500 V MEGGER
 6. CONNECTOR TO BE SOLDERED WITH WIRE, ONLY AFTER ASSEMBLY WITH CORE TO DRG. NASK 1068/9.

LIST OF COMPONENTS

SL NO	DESCRIPTION	DRG NO.	QTY	REMARKS
03	CONNECTOR	NASK1068/8/3 (PROV)	01	
02	CONTACT	NASK1068/8/2 (PROV)	01	
01	BODY	NASK1068/8/1 (PROV)	01	



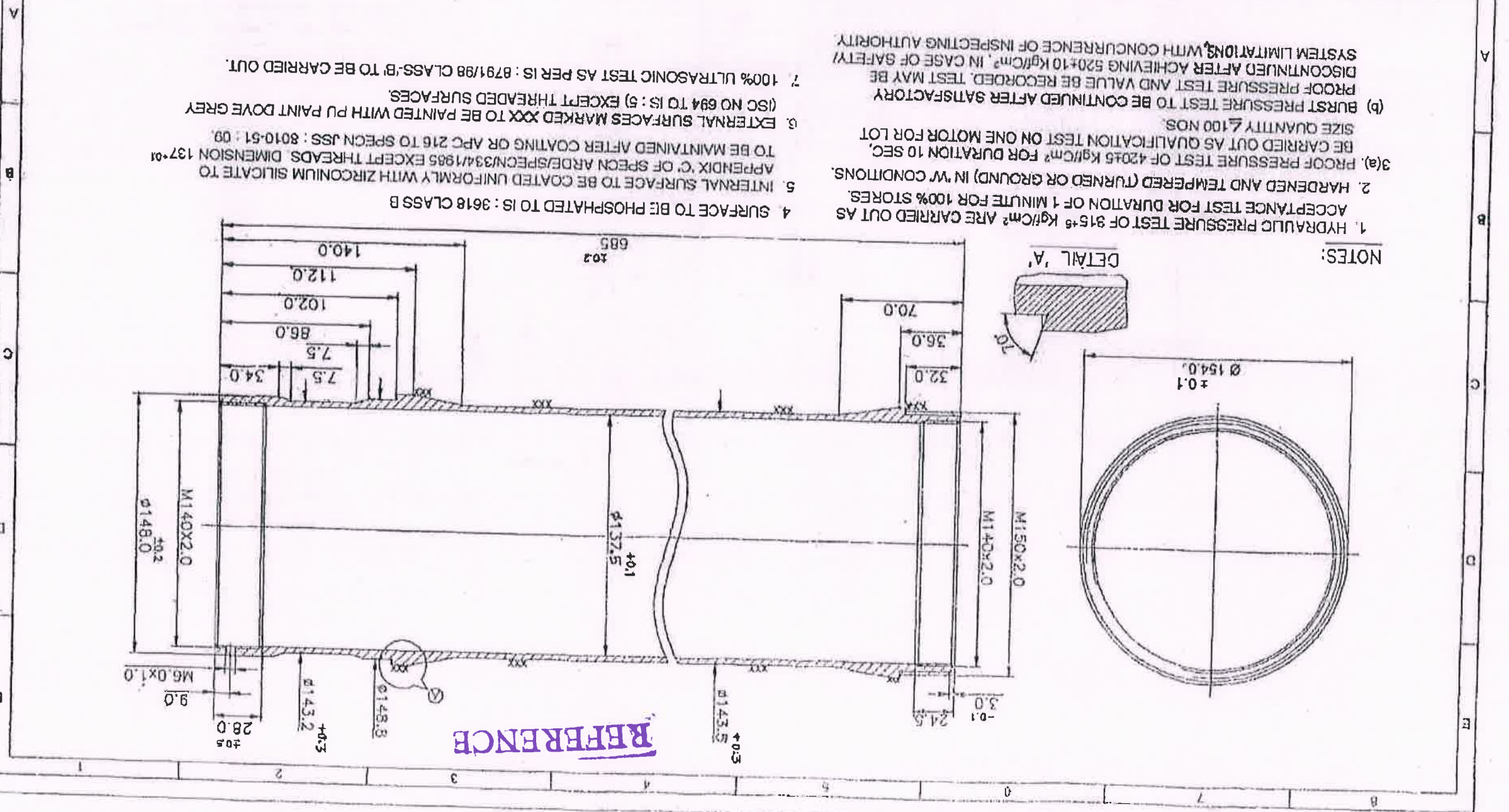
REFERENCE

TRIM ON THIS LINE WHEN SUPPLIED TO TRADE

USED ON: ROCKET RGB-60

BASED ON: CNA(V) DRG No NAI(V) 8008(P) Dt-19-02-08

R.No	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS	PROTECTIVE FINISH	GAUGE SCHEDULE No.
02-06-97			APPROVED			MATL SPEC. EN 19 HARDENED & TEMPERED	STOR. REF. No.
08-09-99			DCA No ADDED	ARD 2396		MATL: STEEL	STOR. SPEC. NO.
14.1.11			NOTE - 5 AMENDED	ARD 2413		GEN. SPEC. IS 2102	GEN. SPEC. IS 2102
13-02-14			DRAWINGS AMENDED	ARS 2452	PASSED	THREADS TO CONFORM IS 4218	THREADS TO CONFORM IS 4218
01-5-14			ON SPECIFICATION ADDED	ARD 2459			
29-9-16			NOTES AMENDED	ARD 2511			



- NOTES:
1. HYDRAULIC PRESSURE TEST OF 915^{±5} kgf/cm² ARE CARRIED OUT AS ACCEPTANCE TEST FOR DURATION OF 1 MINUTE FOR 100% STORES.
 2. HARDENED AND TEMPERED (TURNED OR GROUND) IN 'W' CONDITIONS.
 - 3(a). PROF PRESSURE TEST OF 420^{±5} kgf/cm² FOR DURATION 10 SEC, BE CARRIED OUT AS QUALIFICATION TEST ON ONE MOTOR FOR LOT SIZE QUANTITY 100 NOS.
 - 3(b). BURST PRESSURE TEST TO BE CONTINUED AFTER SATISFACTORY PROF PRESSURE TEST AND VALUE BE RECORDED. TEST MAY BE DISCONTINUED AFTER ACHIEVING 520^{±10} kgf/cm², IN CASE OF SAFETY SYSTEM LIMITATIONS, WITH CONCURRENCE OF INSPECTING AUTHORITY.
 4. SURFACE TO BE PHOSPHATED TO IS : 3618 CLASS B
 5. INTERNAL SURFACE TO BE COATED UNIFORMLY WITH ZIRCONIUM SILICATE TO APPENDIX 'C' OF SPECN ARDE/SPECN/34/1985 EXCEPT THREADS. DIMENSION 137^{±0.1} TO BE MAINTAINED AFTER COATING OR APC 216 TO SPECN JSS : 8010-51 : 09.
 6. EXTERNAL SURFACES MARKED XXX TO BE PAINTED WITH PU PAINT DOVE GREY (ISC NO 694 TO IS : 5) EXCEPT THREADED SURFACES
 7. 100% ULTRASONIC TEST AS PER IS : 8791/98 CLASS-B TO BE CARRIED OUT.

DRG. No. **NASK 1069**
(PROVISIONAL)

DTE GEN OF NAVAL
ARMAMENT INSPECTION
HQ, MOD (NAVY), N. DELHI

ASSTY. DRG. No. **DCA No 1340000563**

ASSEMBLY FIN

R.No	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS	PROTECTIVE FINISH	GUAGE SCHEDULE No.
	13-02-14		DRAWING AMENDED	ARD 2453	APPROVED		
	02-06-09		APPROVED	DGNAL			
DTE GEN OF NAVAL		ARMAMENT INSPECTION		IHQ, MOD (NAVY), N. DELHI			
ASSY DRG. No. MASK 1061		D.S. CAT No.		TOL.			
ASSY DRG LIST No.		COMP. CHD.		DGN		DIMENSIONS ARE IN mm	
DTE GEN OF NAVAL		ARMAMENT INSPECTION		IHQ, MOD (NAVY), N. DELHI			
ASSY DRG. No. MASK 1072		D.S. CAT No.		TOL.			
ASSY DRG LIST No.		COMP. CHD.		DGN		DIMENSIONS ARE IN mm	

LIST OF COMPONENTS

SL NO	DESCRIPTION	DRG NO	QTY	REMARKS
01	OUTER CYLINDER	NASK 1072/1 (PROV)	01	
02	INNER CYLINDER	NASK 1072/2 (PROV)	01	
03	STRIP	NASK 1072/3 (PROV)	04	

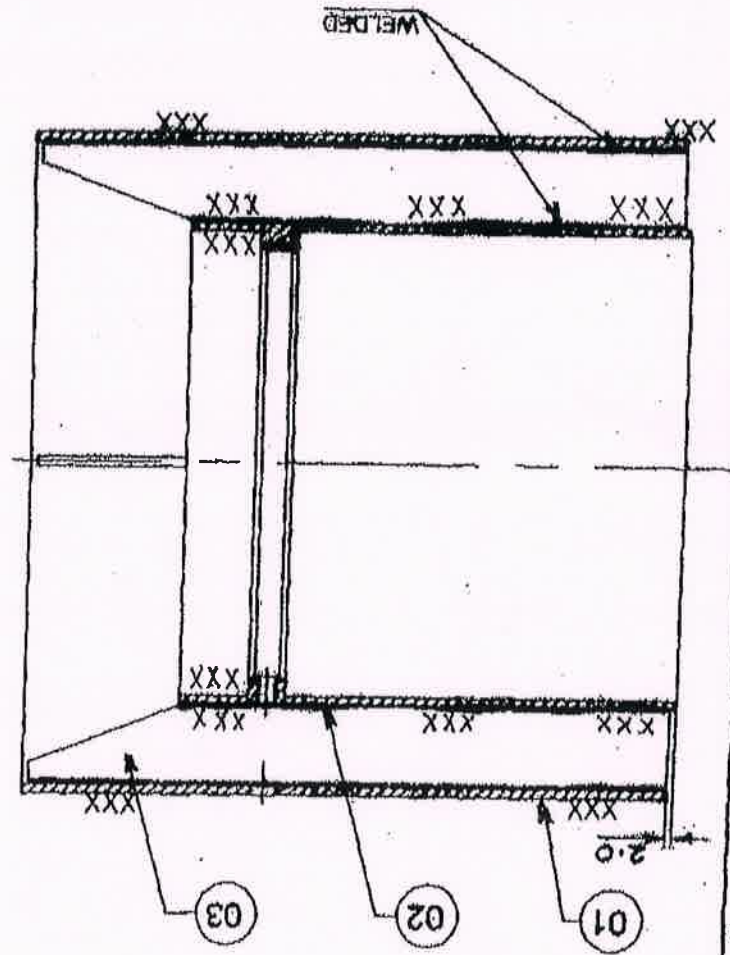
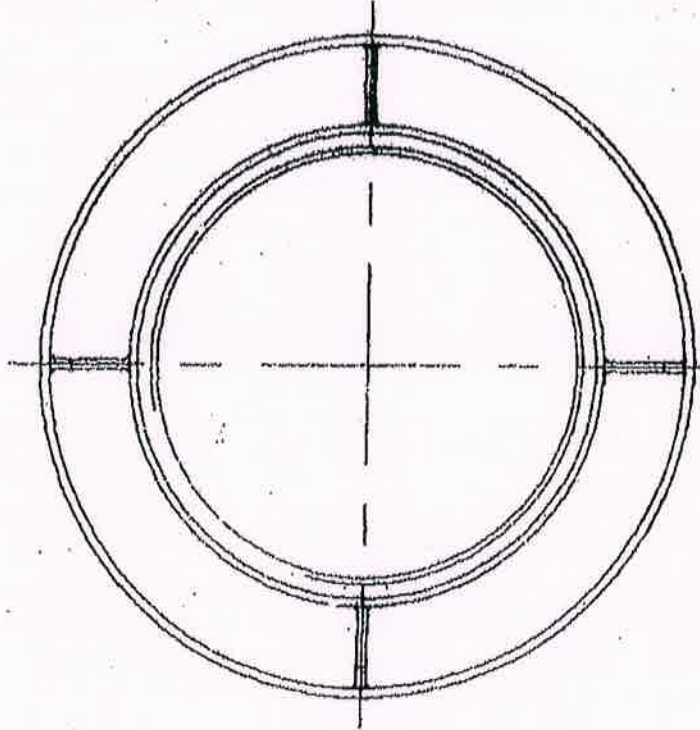
NOTE :-
 1. ITEM NO. 3 IS TO BE WELDED TO ITEM NO. 2 AND THEN TO BE WELDED TO ITEM NO. 1 AS SHOWN
 2. ZINC & YELLOW CHROMATE COATING (25 MICRON) ON ASSEMBLY TO IS: 1573.

6. EXTERNAL & INTERNAL SURFACES MARKED
 XXX AND STRIP TO BE PAINTED WITH PU
 PAINT DOVE GREY (ISC. NR. 694 TO 1815)
 EXCEPT THREADED SURFACES.

4. INSPECTION OF FOLLOWING
 FEATURES ALSO ON ASSEMBLY:-
 (a) OD OF OUTER CYLINDER
 (b) ID OF INNER CYLINDER
 5. ENSURE TIGHT FITMENT
 OF STRIP BETWEEN INNER
 & OUTER CYLINDERS
 PRIOR TO WELDING.

3. QUALITY ON NEGATIVE SIDE: 0.3mm MAX
 PASSING OF ASSEMBLY THROUGH CHAMBER
 GAUGE MANDATORY.

NOTE :-

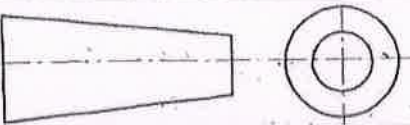


TRIM ON THIS LINE WHEN SUPPLIED TO TRADE

CHAMBER FORE MOTOR

NASK 1064

DRG.No.



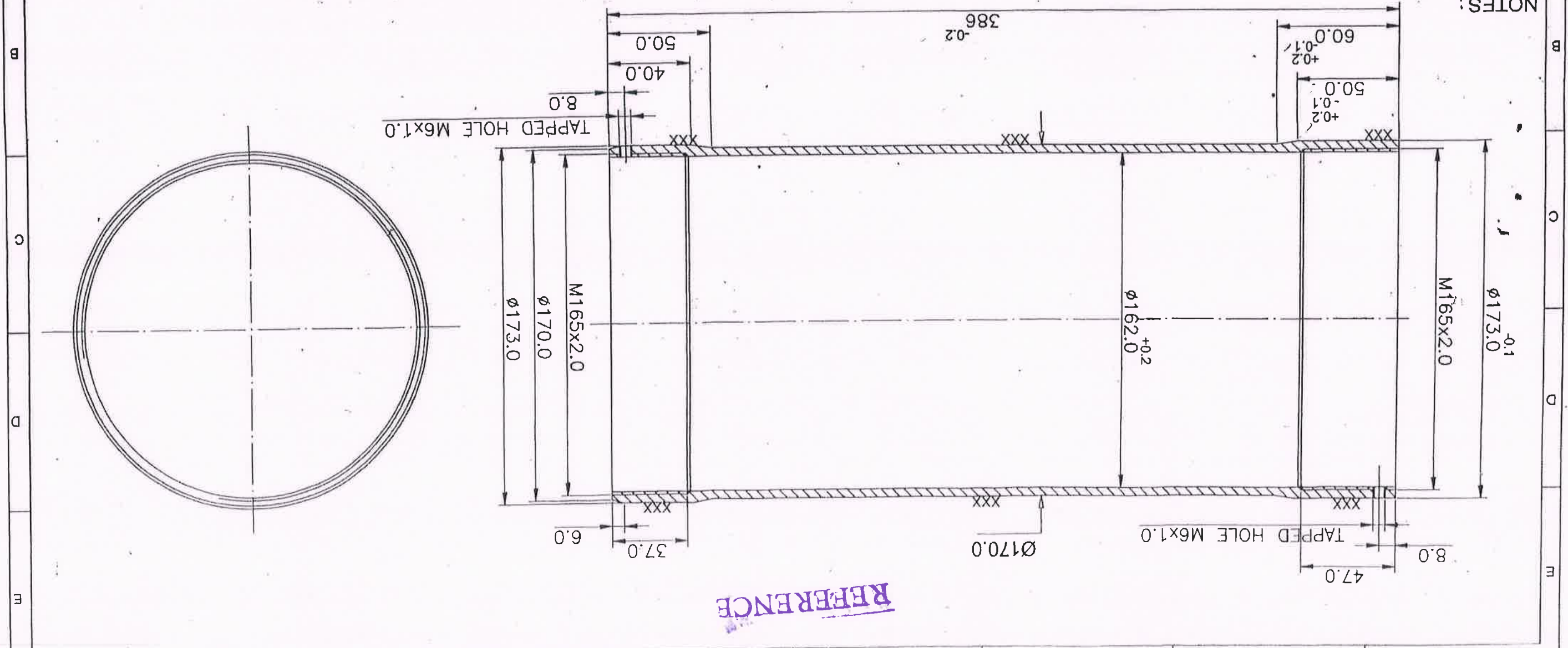
R.No	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS	PROTECTIVE FINISH	Gauge Schedule No.
02-06-09	02-06-09		APPROVED	DGNAI		SEE NOTES ON DRAWING	
08-09-09	08-09-09		DCA No ADDED	ARD2396			
12-02-14	12-02-14		NOTES ADDED & AMENDED	ARD2453			
01-05-14	01-05-14		ALTERNATE PROTECTIVE COMPOSIT- ION & SPECIFICATION ADDED	ARD 2459			

SCALE	DGN.	DRN	TCD	COMP.	CHD.	CD.	ASSY.DRG.LIST No.

DIMENSIONS ARE IN mm	TOL.	D.S.CAT No	ASSY.DRG. No

5. GEN. TOL. IS:2102 EXCEPT SPECIFIED
 4. TAPPED HOLES M6x1.0 AT DIST 8.0 TO BE MADE ONLY AFTER ENSURING FULL TIGHTENING DURING ASSY.
 TEST FOLLOWED BY BURST TEST (VALUE TO BE RECORDED).
 3. HYDRAULIC PRESSURE TESTING TO 215kg/cm² DURATION FOR 01 MINUTE AND ONE MOTOR FROM LOT (50-100) TO BE TESTED AT HIGH PRESSURE PROOF TEST AT 420 KSC AS QUALIFICATION
 2. HARDENED & TEMPERED (TURNED OR GROUND) IN 'W' CONDITIONS
 1. MATL. :- EN19

NOTES:
 6. SURFACES TO BE PHOSPHATED TO IS 3618 CLASS B
 7. INTERNAL SURFACE BE COATED UNIFORMLY WITH ZIRCONIUM SILICATE TO
 APPENDIX 'C' OF SPECN ARDE/SPECN/334/1985 OR APC 216 TO SPEC;
 JSS: 010-51:09
 8. EXTERNAL SURFACES MARKED XXX TO BE PAINTED WITH PU PAINT DOVE GREY
 (ISC No 694 TO IS: 5) EXCEPT TREADED SURFACES.
 9. 100% ULTRA SONIC TEST AS PER IS: 8791/98 CLASS 'B' TO
 BE CARRIED OUT.
 DCA No 1340000562

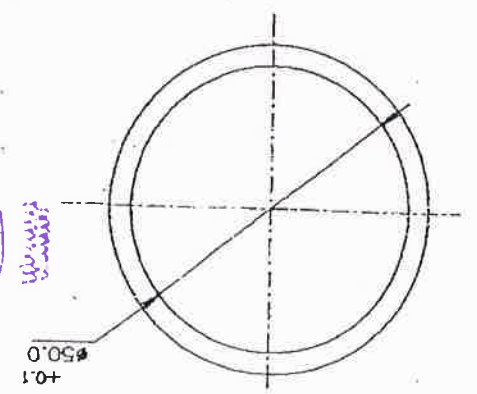
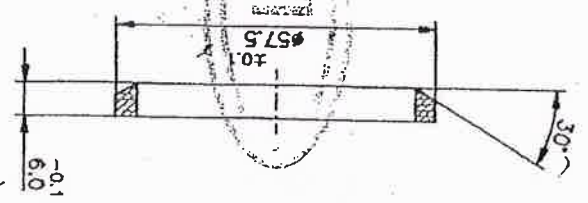


1	2	3	4	5	6	7	8
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A4

GASKET	
DRG No. NASK 1071/5 (PROVISIONAL)	
PROTECTIVE FINISH: DCA No. 530386772	
GAUGE SCH No.	
MATL SPEC: INDM/578	
STORE REF No.	
MATL: NEOPRENE RUBBER	
STORE SPEC:	
GEN SPEC: IS:2102	
THREADS TO CONFORM IS:4218	
PASSED: [Signature]	APPD. [Signature]
DGN - -	DRN [Signature]
SCALE: 1:1	TOL
DIMENSIONS ARE IN mm	
ASSY DRG No. NASK 1071	
ASSY DRG LIST.	
DTE GEN OF NAVAL	
ARMAMENT INSPECTION	
HQ, MOD (NAVY) N. DELHI	
DCA No. Added	
ARD 2596	DGN/
APPROVED	BRIEF RECORD
DATE	ZONE
R.No	
08-19-09	
02-06-09	

SUBJECT TO FITMENT WITH MATING COMPONENT



REFERENCE

TRIM ON THIS LINE WHEN SUPPLIED TO TRADE

A

B

C

D

1 2 3 4

