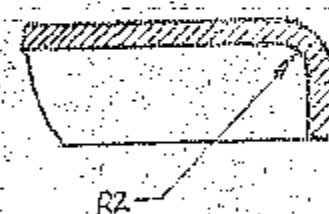
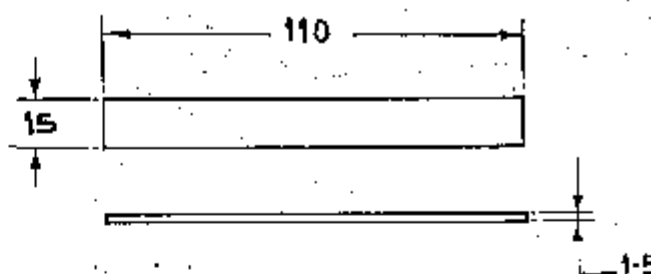
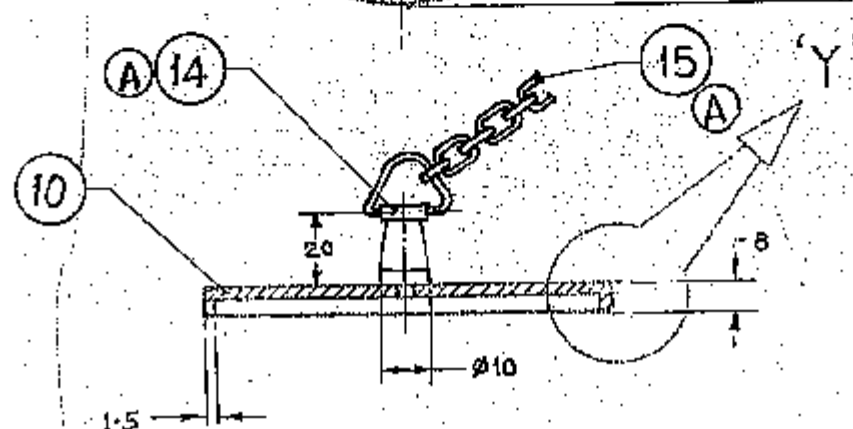
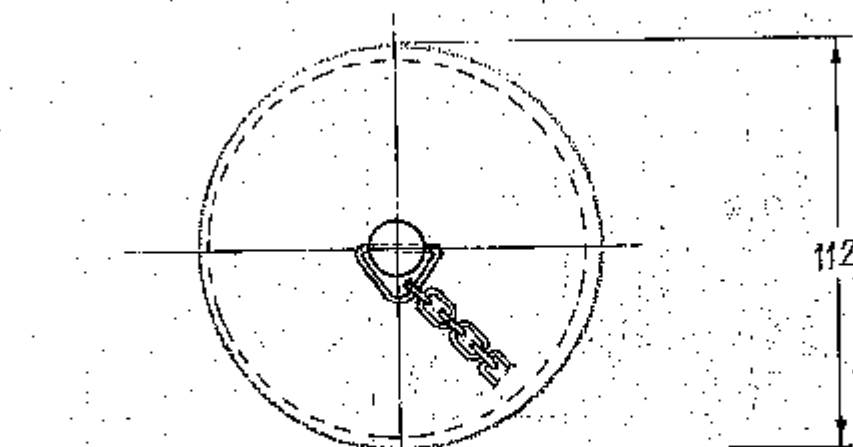
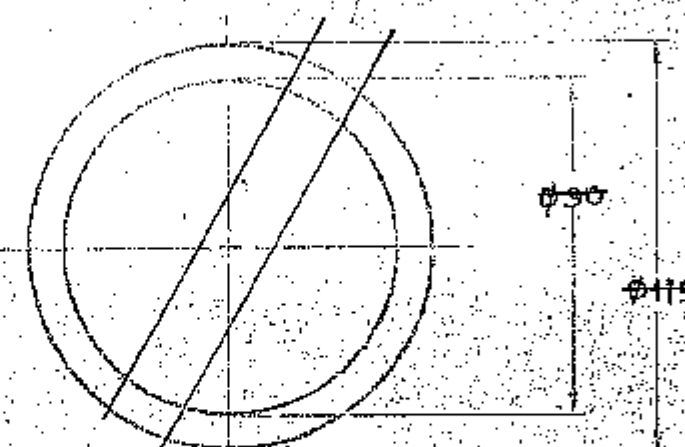


675-WT-PD-027

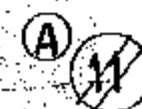


ENLARGED VIEW AT 'Y'

SCALE: 2:1



SCALE: 1:1



NOTE:-

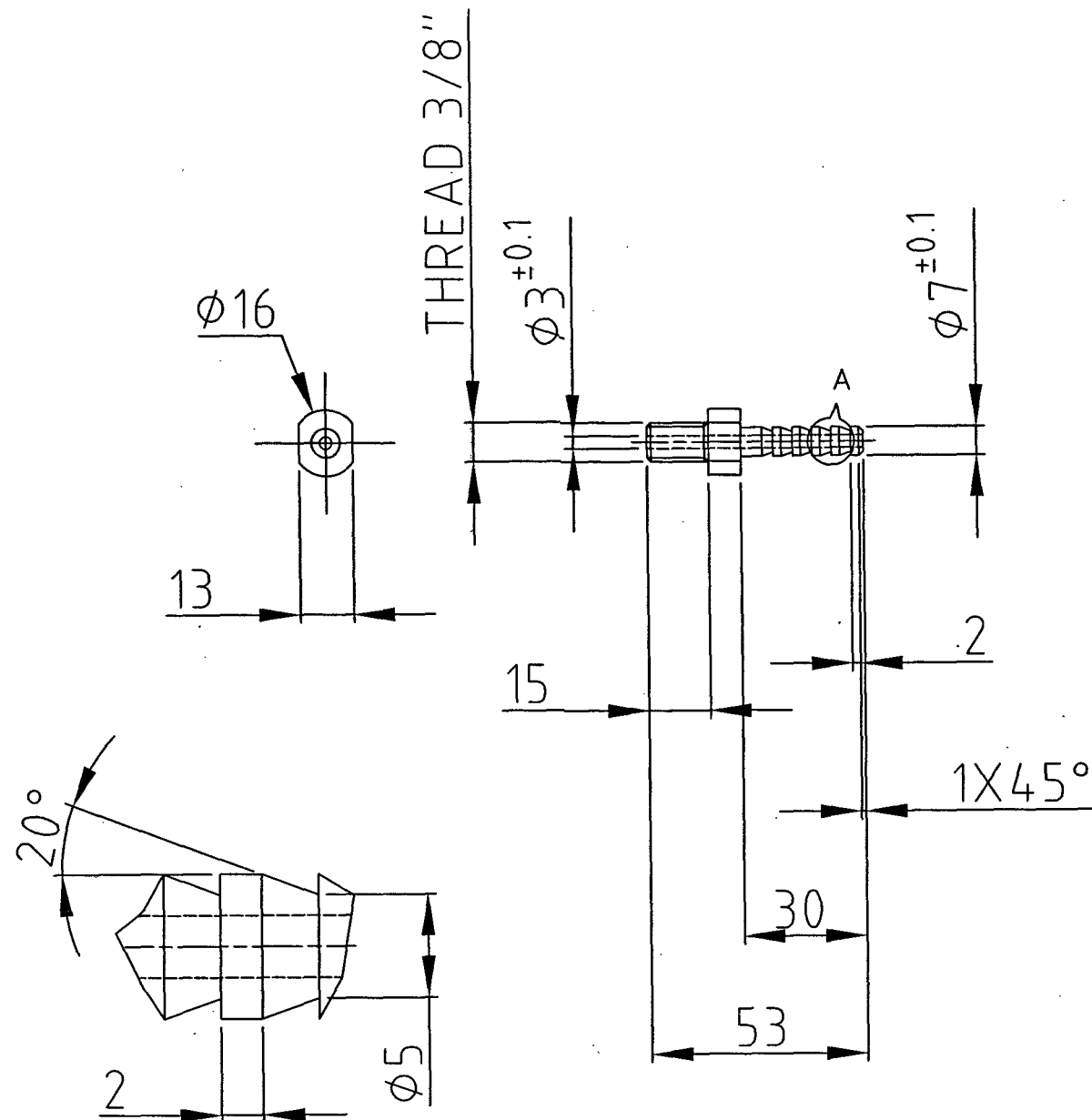
1. ALL DIMENSIONS ARE IN MILLIMETRES.
2. THIS IS A PROVISIONAL DRG. PRODUCTION HAS NOT BEEN CARRIED OUT TO THIS DRG.
3. PROTOTYPE SAMPLE SHOULD BE GOT APPROVED FROM CQA (ICV) BEFORE START OF BULK PRODUCTION.

NOTES:-

(A)	15	CHAIN (STD-WIDTH 5 mm, LENGTH 300mm)			
(A)	14	COLD ROLLED BRASS ROD Gdc CuZn 42 Pb2 TO IS: 3488-66			
(A)	13	COLLED ROLLED BRASS SHEET Gdc CuZn 37 TO IS: 410-67	60977-10	(A)	1 REF NOS : 13, 14 and 15 NEWLY ADDED 2 REF NO: 11, DELETED
	11	RUBBER No 3 Gdc D TO BS-AU: 106-65	(M)		
	10	COLD ROLLED BRASS SHEET Gdc CUZn 37 TO IS: 410-67	10 Set/lot		
ITEM NO.		MATERIAL	DCI/No & DATE	ISSUE	AMENDMENTS
		ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.	ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
		DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON:- 675-WT-SA-040
		SCALE:- 1:2, 2:1			
		DATE :- 18-5-99			
DRN.	WT :- (Kg)	ASSY. FUNNEL, ITEM No. 10, 13, 14 AND 15			
TCD.					
CHD.					
APD.					
		DRAWING NO	PART NO		
		675-WT-PD-027			
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)					

78

BASED ON:	✓(✓)	ISSUE	APPRD.	NATURE OF AMENDMENT
USED ON: 675-WT-SA-000				



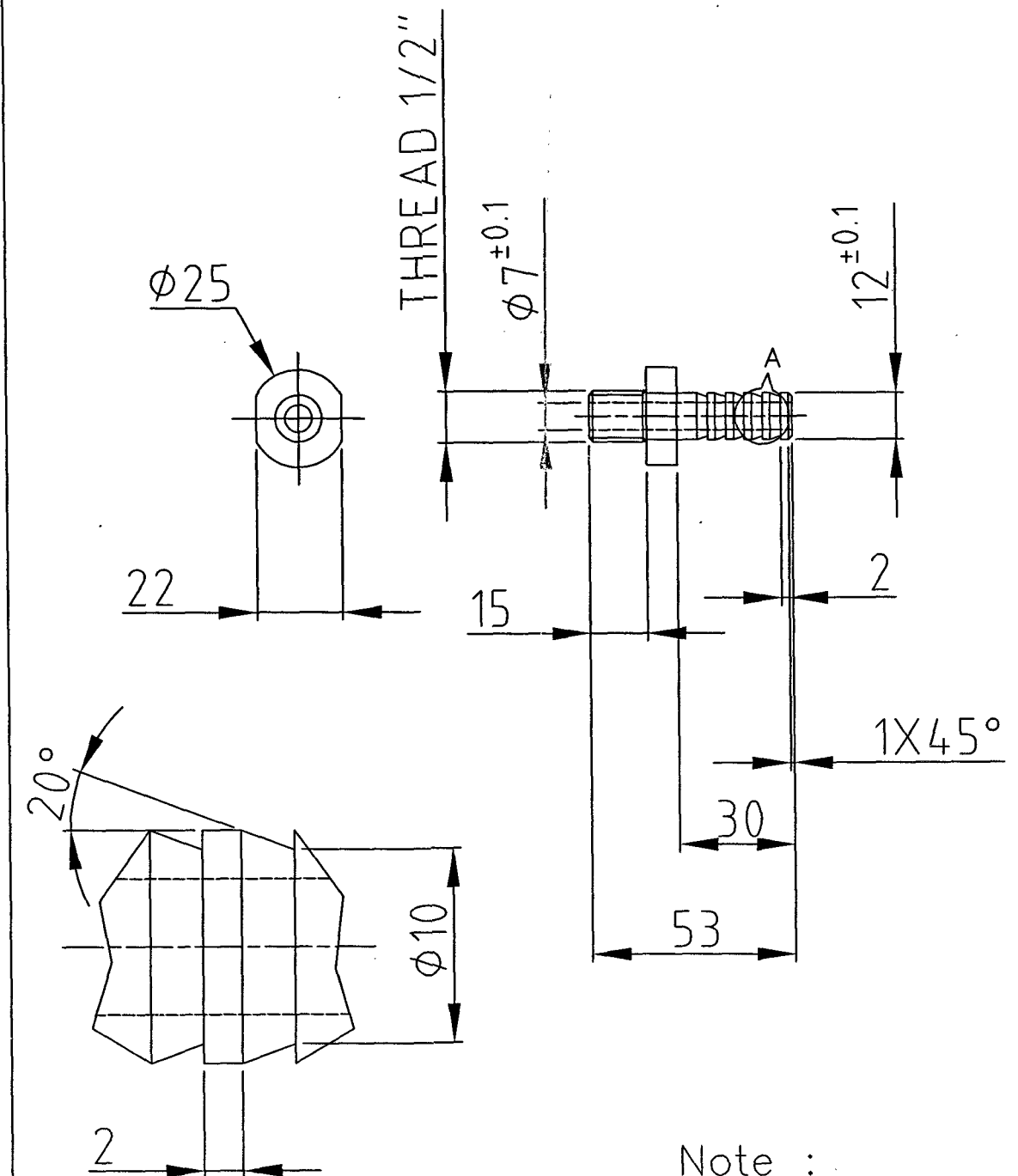
ENLARGED VIEW 'A'

Note :

1. Drawing is provisional.

AUTHD.				DRG.NO:	675-WT-SA-000-01		
APRD.	SANM			TITLE:	UNSPECIFD. TOLERANCES ARE AS PER IS:2102		
CHKD.	NSReddy	ASL	30/8/10		UNLESS SPECIFD, DIMNS.IN MM		
DRWN	URKRaju	UNR	29/8/10		SHEET NO.		
2009	NAME	SIGN	DATE		2 of 8		
ORDNANCE FACTORY MEDAK					NTS		
				MTL:	BRASS IS: 4170		
				FIRST ANGLE			

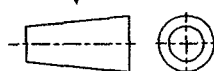
BASED ON:	✓(✓)	ISSUE	APPRD.	NATURE OF AMENDMENT
USED ON: 675-WT-SA-000				



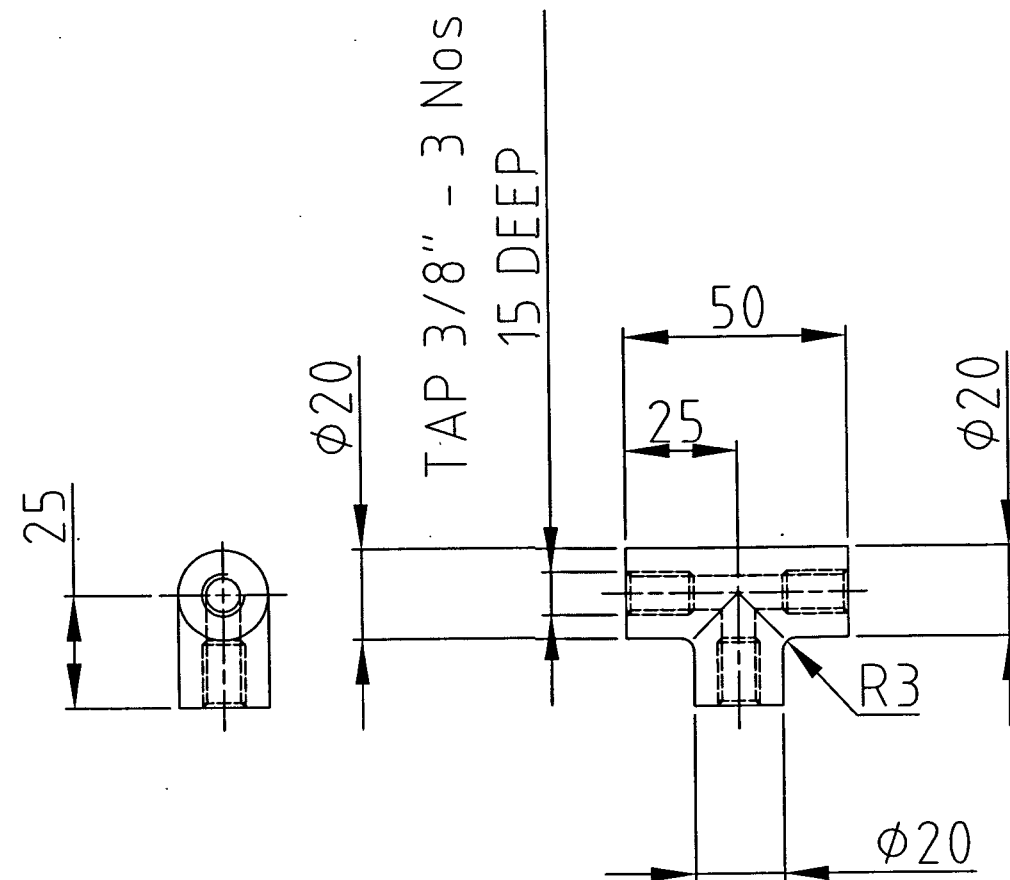
ENLARGED VIEW 'A'

Note :

1. Drawing is provisional.

AUTHD.				DRG.NO:	675-WT-SA-000-02		UNSPECIFD. TOLERANCES ARE AS PER IS:2102		
APRD.	SANM	9/7	30/08/10	TITLE:	DRAIN NIPPLE		UNLESS SPECIFD, DIMNS.IN MM		
CHKD.	NSReddy	10/7	30/08/10				SHEET NO.	WEIGHT	SCALE
DRWN	URKRaju	10/7	29/8/10				3 of 8		NTS
2009	NAME	SIGN	DATE	MTL:	BRASS IS: 4170				FIRST ANGLE
ORDNANCE FACTORY MEDAK									

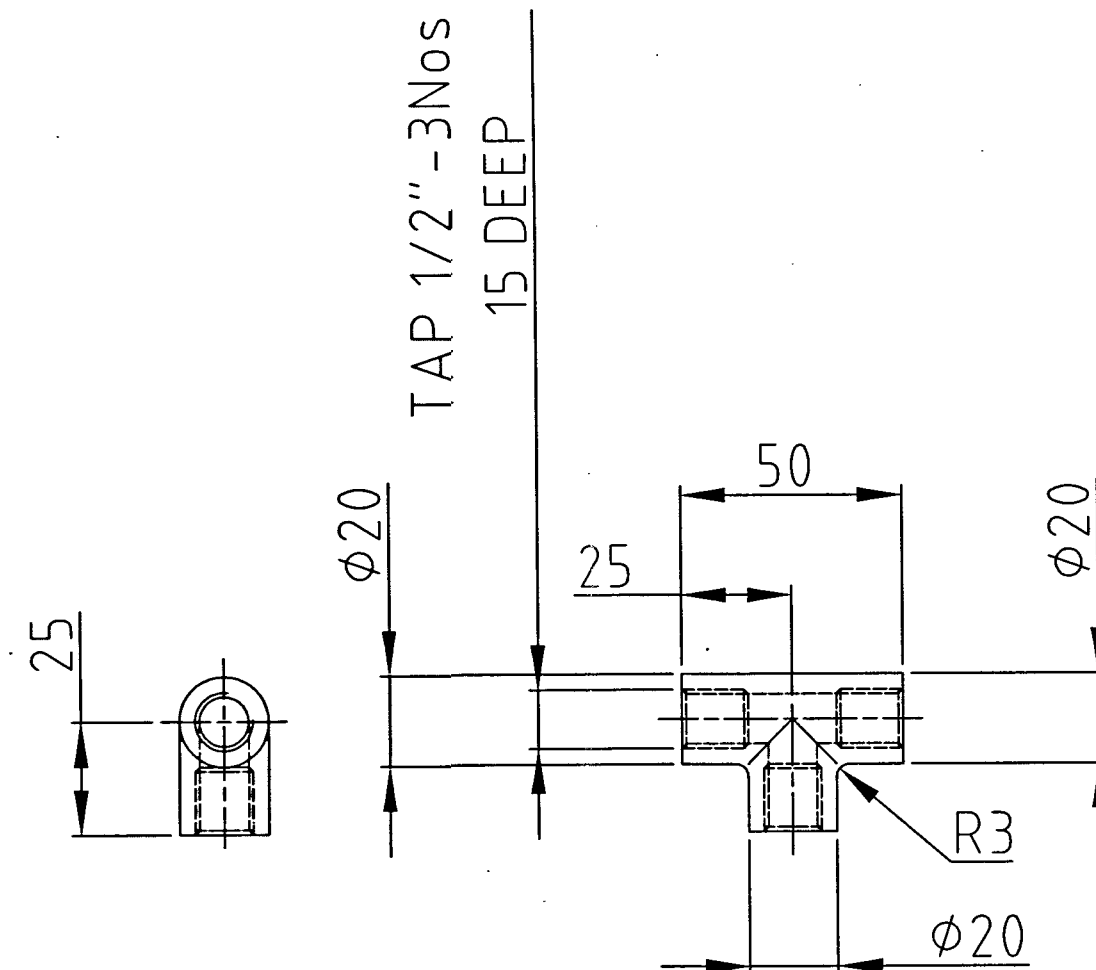
BASED ON:	✓(✓)	ISSUE	APPRD.	NATURE OF AMENDMENT
USED ON : 675-WT-SA-000				



Note :
1. Drawing is provisional.

AUTHD.				DRG.NO:	675-WT-SA-000-03	UNSPECIFD. TOLERANCES ARE AS PER IS:2102 UNLESS SPECIFD, DIMNS.IN MM		
APRD.	SANM			TITLE:	BREATHER T-JOINT			
CHKD.	NSReddy		30/8/10			SHEET NO.	WEIGHT	SCALE
DRWN	URKRaju		29/8/10			4 of 8		NTS
2009	NAME	SIGN	DATE					FIRST ANGLE
ORDNANCE FACTORY MEDAK				MTL:	BRASS IS: 4170			

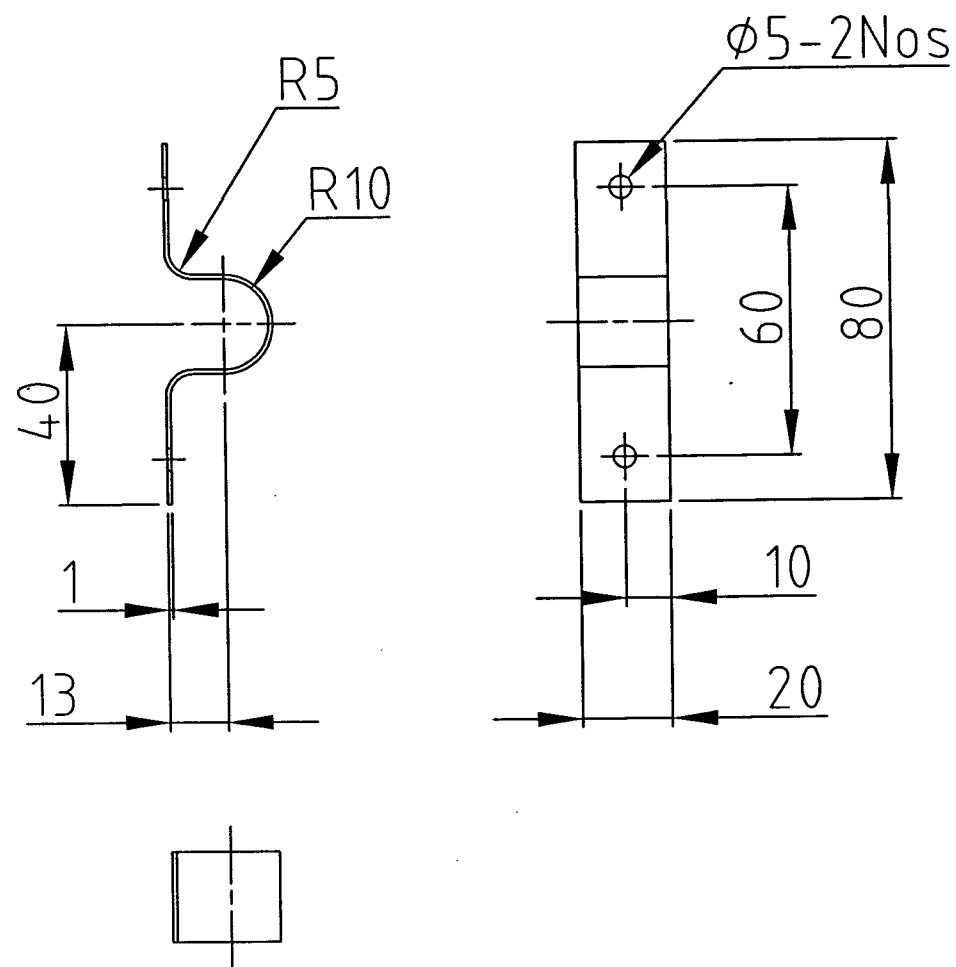
BASED ON:	✓(✓)	ISSUE	APPRD.	NATURE OF AMENDMENT
USED ON : 675-WT-SA-000				



Note :
1. Drawing is provisional.

AUTHD.				DRG.NO:	675-WT-SA-000-04	UNSPECIFD. TOLERANCES ARE AS PER IS:2102 UNLESS SPECIFD, DIMNS.IN MM		
APRD.	SANM		30/8/10	TITLE:	DRAIN T- JOINT			
CHKD.	NSReddy		30/8/10			SHEET NO.	WEIGHT	SCALE
DRWN	URKRaju		29/8/10			5 of 8		NTS
2009	NAME	SIGN	DATE					FIRST ANGLE
ORDNANCE FACTORY MEDAK				MTL:	BRASS IS: 4170			

BASED ON:	✓(✓)	ISSUE	APPRD.	NATURE OF AMENDMENT
USED ON: 675-WT-SA-000				

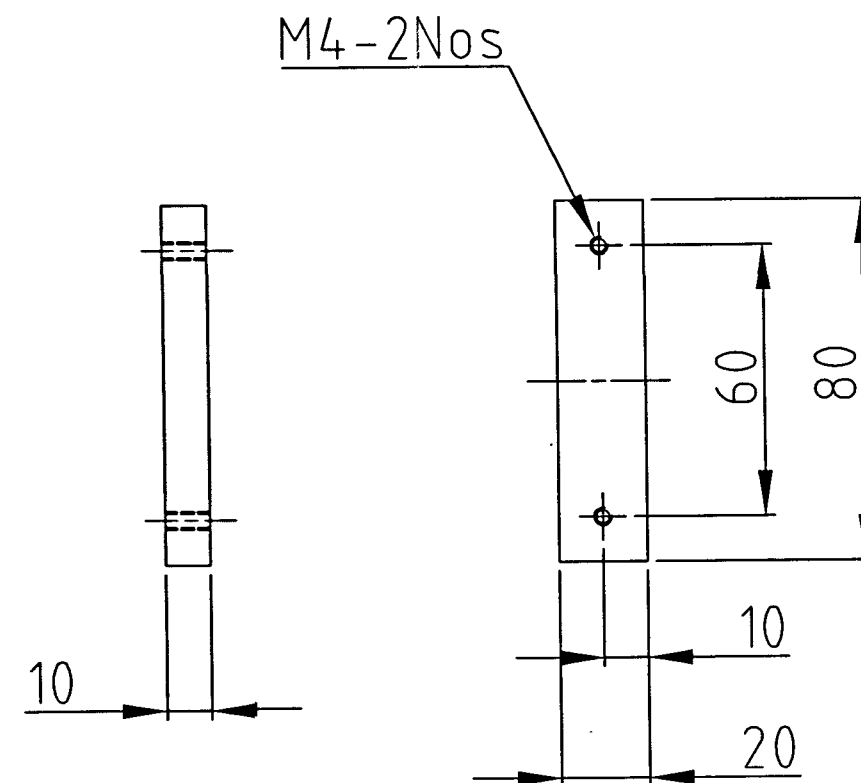


Note :

1. Drawing is provisional.

AUTHD.		DRG.NO:	675-WT-SA-000-05		
APRD.	SANM		UNSPECIFD. TOLERANCES ARE AS PER IS:2102		
CHKD.	NSReddy	30/8/10	UNLESS SPECIFD, DIMNS.IN MM		
DRWN	URKRaju	6/8/10	TITLE:	CLAMP	
2009	NAME	SIGN	DATE	SHEET NO.	WEIGHT
				6 of 8	SCALE
ORDNANCE FACTORY MEDAK			MTL:	MILD STEEL IS : 513 Gr. D	FIRST ANGLE

BASED ON:	✓(✓)	ISSUE	APPRD.	NATURE OF AMENDMENT
USED ON: 675-WT-SA-000				

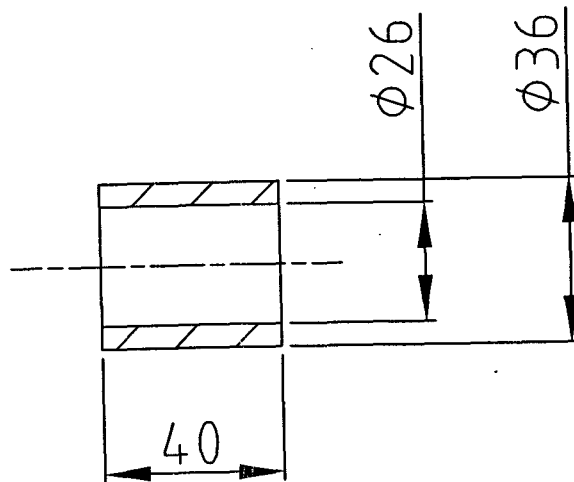


Note :

1. Drawing is provisional.

AUTHD.		DRG.NO:	675-WT-SA-000-06		
APRD.	SANM	30/8/10	UNSPECIFD. TOLERANCES ARE AS PER IS:2102		
CHKD.	NSReddy	30/8/10	UNLESS SPECIFD, DIMNS.IN MM		
DRWN	URKRaju	6/8/10	TITLE:	CLAMP BLOCK	
2009	NAME	SIGN	DATE	SHEET NO.	WEIGHT
				7 of 8	SCALE
ORDNANCE FACTORY MEDAK			MTL:	MILD STEEL IS : 513 Gr. D	FIRST ANGLE

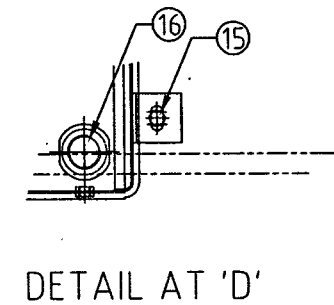
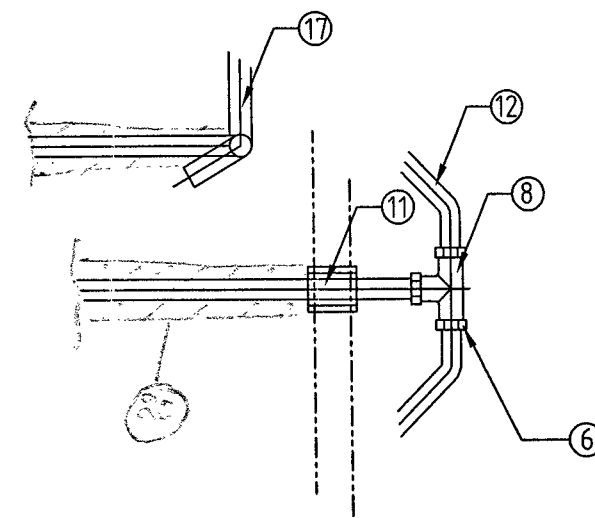
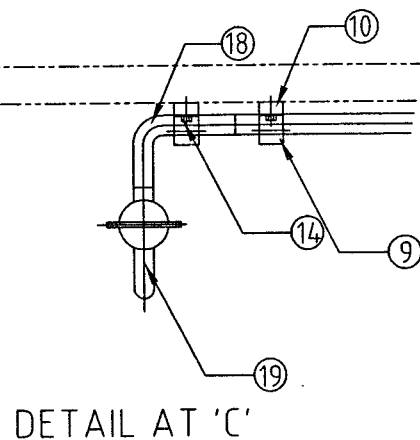
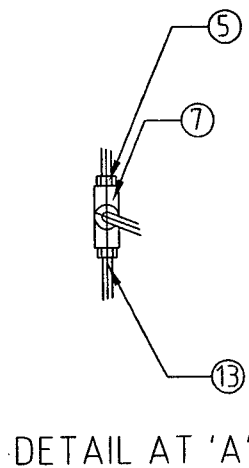
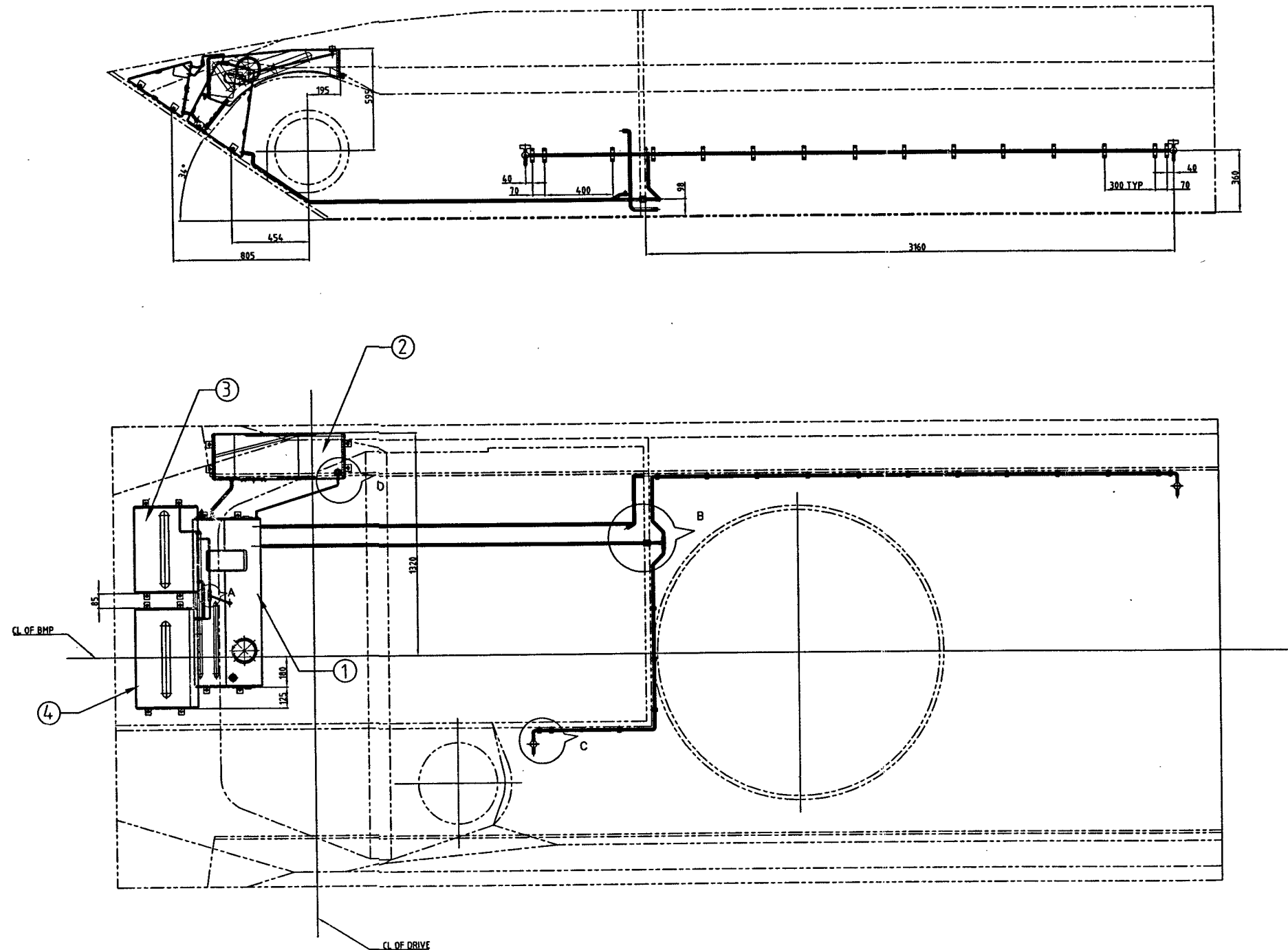
BASED ON:	✓(✓)	ISSUE	APPRD.	NATURE OF AMENDMENT
USED ON : 675-WT-SA-000				



Note :

1. Drawing is provisional.

AUTHD.				DRG.NO:	675-WT-SA-000-07	UNSPECIFD. TOLERANCES ARE AS PER IS:2102		
APRD.	NSM		30/8/10	TITLE: BUSH		UNLESS SPECIFD, DIMNS.IN MM		
CHKD.	NSReddy		30/8/10			SHEET NO.	WEIGHT	SCALE
DRWN	URKRaju		28/8/10	MTL: MILD STEEL IS : 513 Gr. D		8068		NTS
2009	NAME	SIGN	DATE			FIRST ANGLE		
ORDNANCE FACTORY MEDAK								



Note :

1. DRAWING IS PROVISIONAL.
2. TANKS FITTING TO BE IN-SITU.
3. UNSPECIFIED LIMIT DEVIATION IS IS : 2102
4. UNSPECIFIED THREAD TOLERANCE IS : 4218
- (A) 5. 4 Stainless Steel Tanks with 5mm FRP pasting.

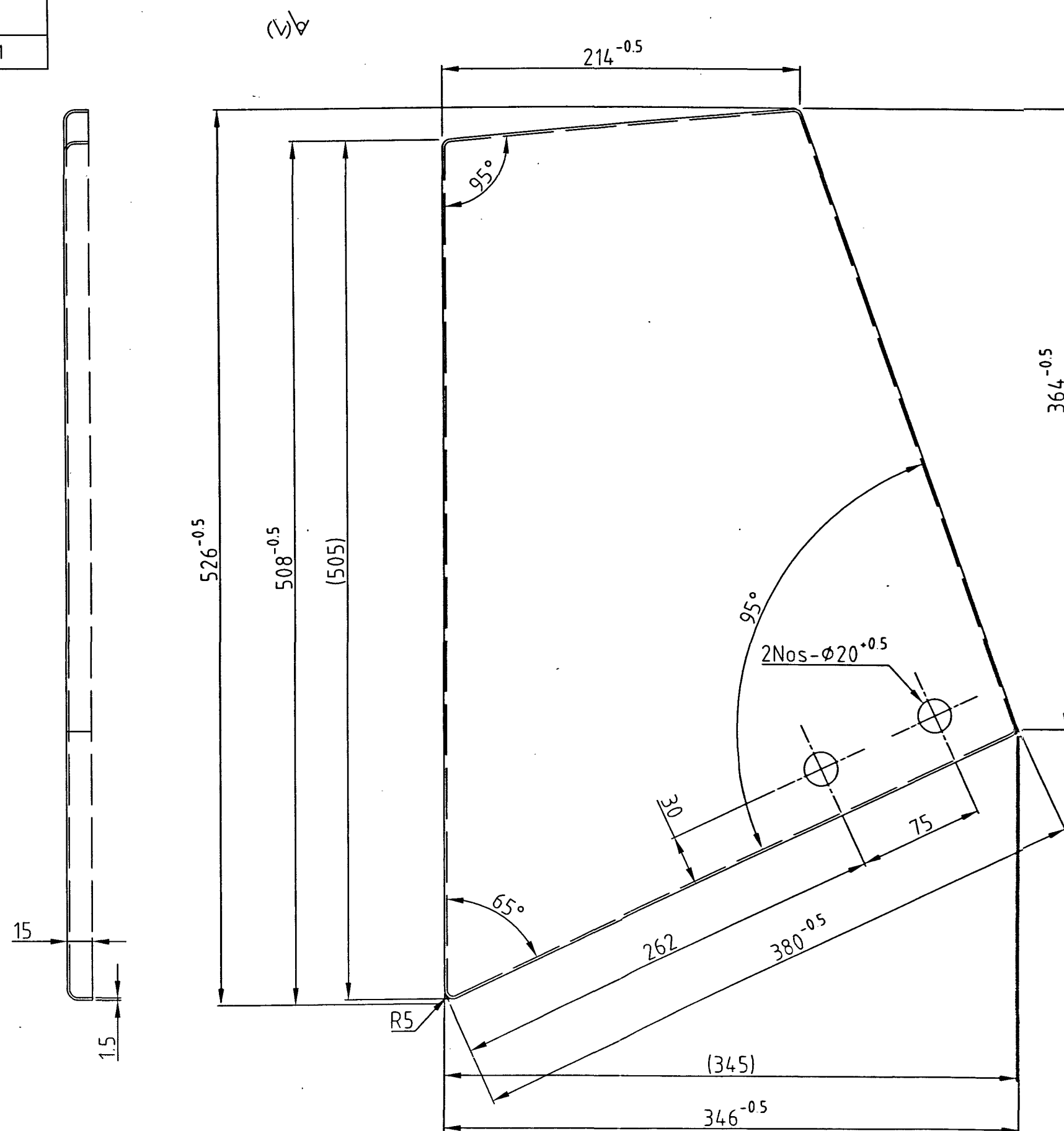
Steel Braided Sleeve of STD-15, L= 40 Mtrs				
(A) 20	STD.	PIPE	2	B.O
19	STD.	ELBOW	2	B.O
18	765-08-Cb261Cb	PIPE (ASSEMBLY)	1	BMP PART
17	700-37-327	PLUG	1	BMP PART
16	M8 X 30	HEX. SEREW	16	B.O
15	M4 X 15	HEX. SEREW	60	B.O
14	675-WT-SA-000-09	SILICON RUBBER TUBE 3/8"	6 MT.	B.O W/D
13	675-WT-SA-000-08	SILICON RUBBER TUBE 1/2" 40Mtrs	40 MT.	B.O W/D
(A) 12	675-WT-SA-000-07	BUSH	1	MS IS : 513 Gr.D
11	675-WT-SA-000-06	CLAMP BLOCK	30	MS IS : 513 Gr.D
10	675-WT-SA-000-05	CLAMP	30	MS IS : 513 Gr.D
9	675-WT-SA-000-04	DRAIN T-JOINT	1	BRASS IS : 4170
8	675-WT-SA-000-03	BREATHER T-JOINT	1	BRASS IS : 4170
7	675-WT-SA-000-02	BRASS NIPPLE	11	BRASS IS : 4170
6	675-WT-SA-000-01	BRASS NIPPLE	8	BRASS IS : 4170
5	675-WT-SA-004	FRONT WATER TANK (LH)	1	S.S AISI : 316
4	675-WT-SA-003	FRONT WATER TANK (RH)	1	S.S AISI : 316
3	675-WT-SA-002	SIDE WATER TANK	1	S.S AISI : 316
2	675-WT-SA-001	MAIN WATER TANK	1	S.S AISI : 316
1				
REF.NO	DRAWING NO.	DESCRIPTION.	QTY.	REMARKS
AUTHD	APRD	DRG. NO:	675-WT-SA-000	UNSPECIFD. TOLERANCES ARE AS PER IS:2102
CHKD.	NSReddy	DATE: 30/09/2019		UNLESS SPECIFD. DIMNS. IN MM
DRWN	URKReddy	DATE: 30/09/2019	MAIN ASSEMBLY	SHEET NO. WEIGHT SCALE
2009	NAME SIGN DATE			1 OF 3 NTS
ORDNANCE FACTORY MEDAK		MTL:	ASSEMBLY DRAWING	FIRST ANGLE

A 04/10/2019 Note No.5 added, SI.No.20 added in item list
SI No.12 Length 40M was 20M
Nature of Amendment

Issue Date Signature

BASED ON:
USED ON : 675-WT-SA-001

ISSUE	APPRD.	NATURE OF AMENDMENT



Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911
3. Thickness 1.5mm.
4. It is allowed to cut and weld at corners of flange.

AUTHD.		DRG.NO:	675-WT-SA-001-02	UNSPECIFD. TOLERANCES ARE
APRD.	NSreddy	DATE:	30/08/2009	AS PER IS:2102
CHKD.	URKRaju	TITLE:	SIDE PLATE (RH)	UNLESS SPECIFD, DIMNS.IN MM
DRWN	NAME	SIGN	DATE	SHEET NO.
2009				3 OF 7
ORDNANCE FACTORY MEDAK				SCALE
M:L: STAINLESS STEEL AISI: 316				NTS
				FIRST ANGLE

BASED ON:

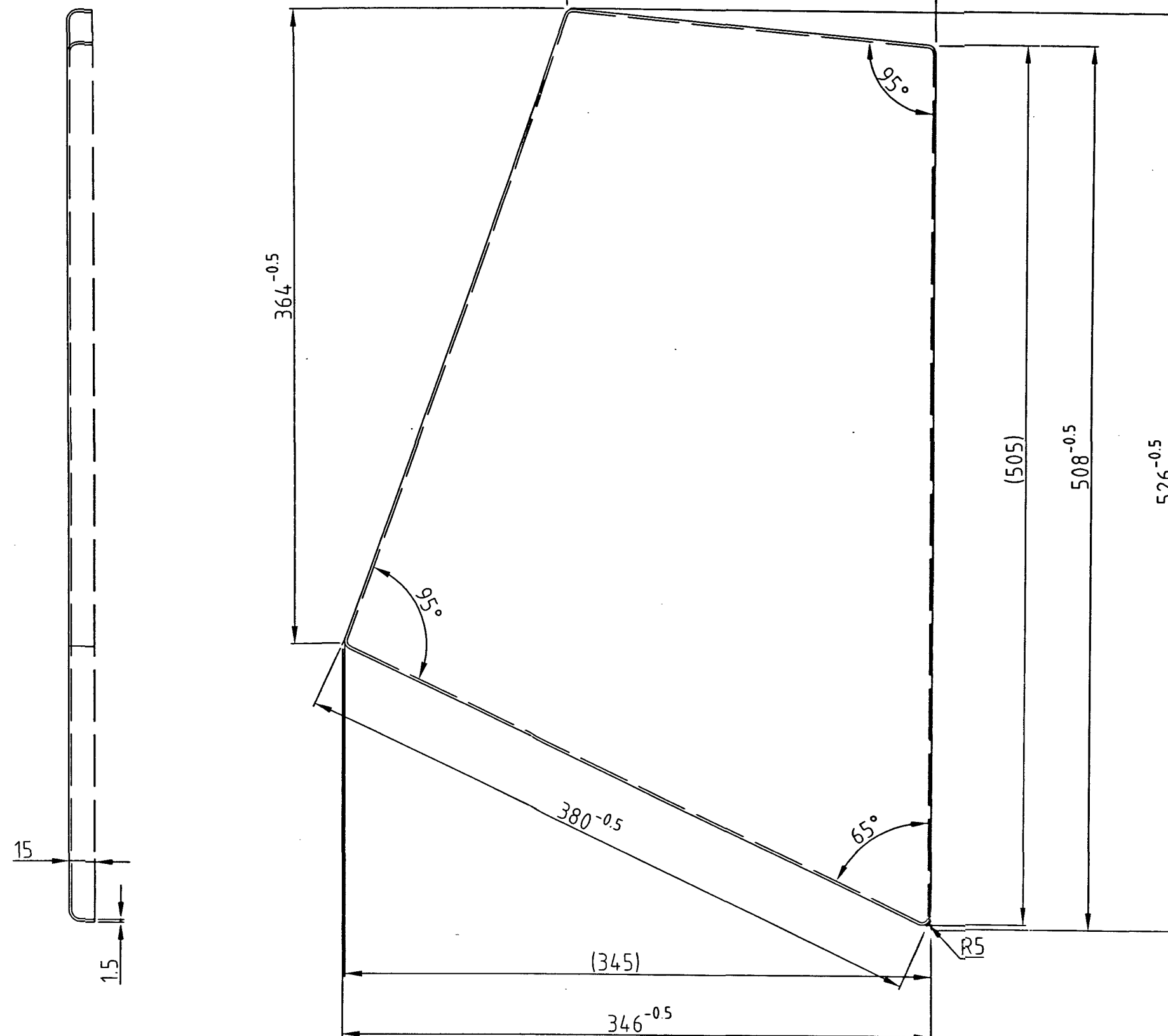
USED ON : 675-WT-SA-001

✓(✓)

ISSUE

APPRD.

NATURE OF AMENDMENT



Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911
3. Thickness 1.5mm.
4. It is allowed to cut and weld at corners of flange.

AUTHD.		DRG.NO:	675-WT-SA-001-03	UNSPECIFD. TOLERANCES ARE		
APRD.	NSreddy			AS PER IS:2102		
CHKD.	URKRaju			UNLESS SPECIFD, DIMNS.IN MM		
DRWN	NAME	SIGN	DATE	SHEET NO.	WEIGHT	SCALE
2009				4 OF 7		NTS
ORDNANCE FACTORY MEDAK				WTL:	STAINLESS STEEL AISI: 316	FIRST ANGLE

BASED ON:

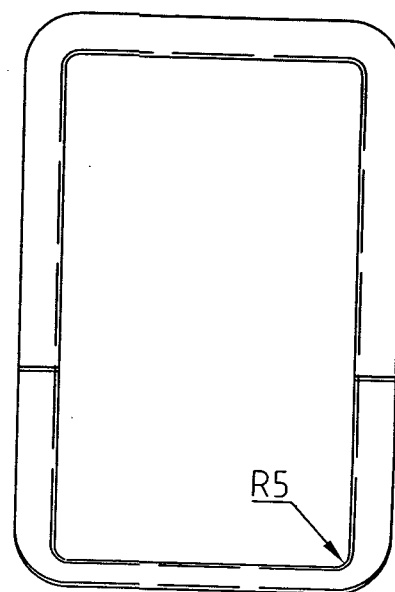
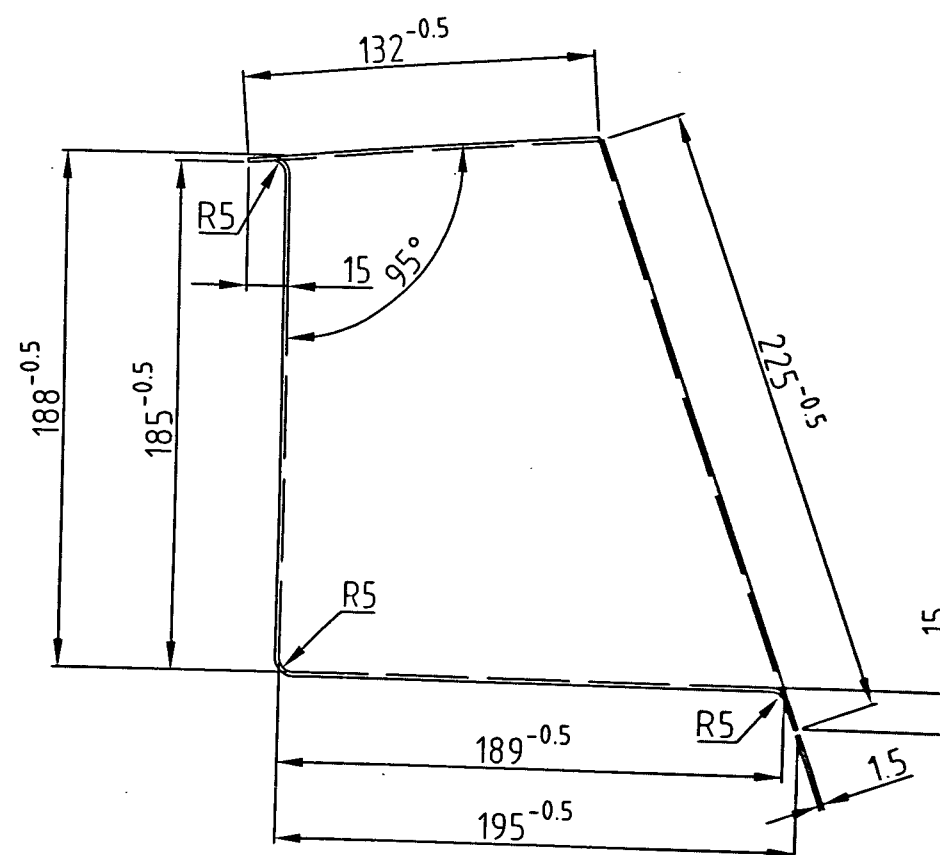
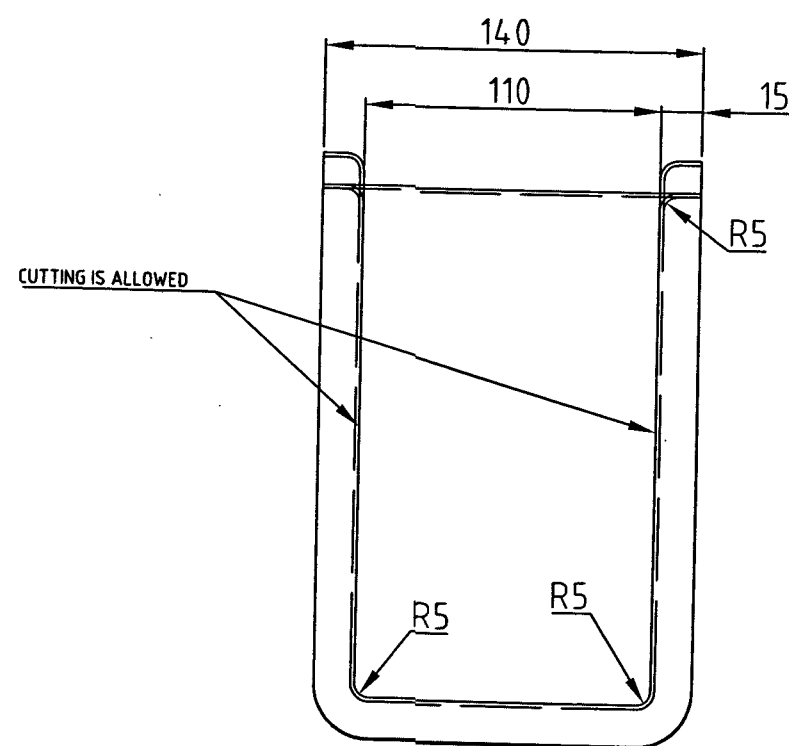
USED ON: 675-WT-SA-001

✓(✓)

ISSUE

APPRD.

NATURE OF AMENDMENT



Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911
3. Thickness 1.5mm.
4. It is allowed to cut and weld at corners of flange.

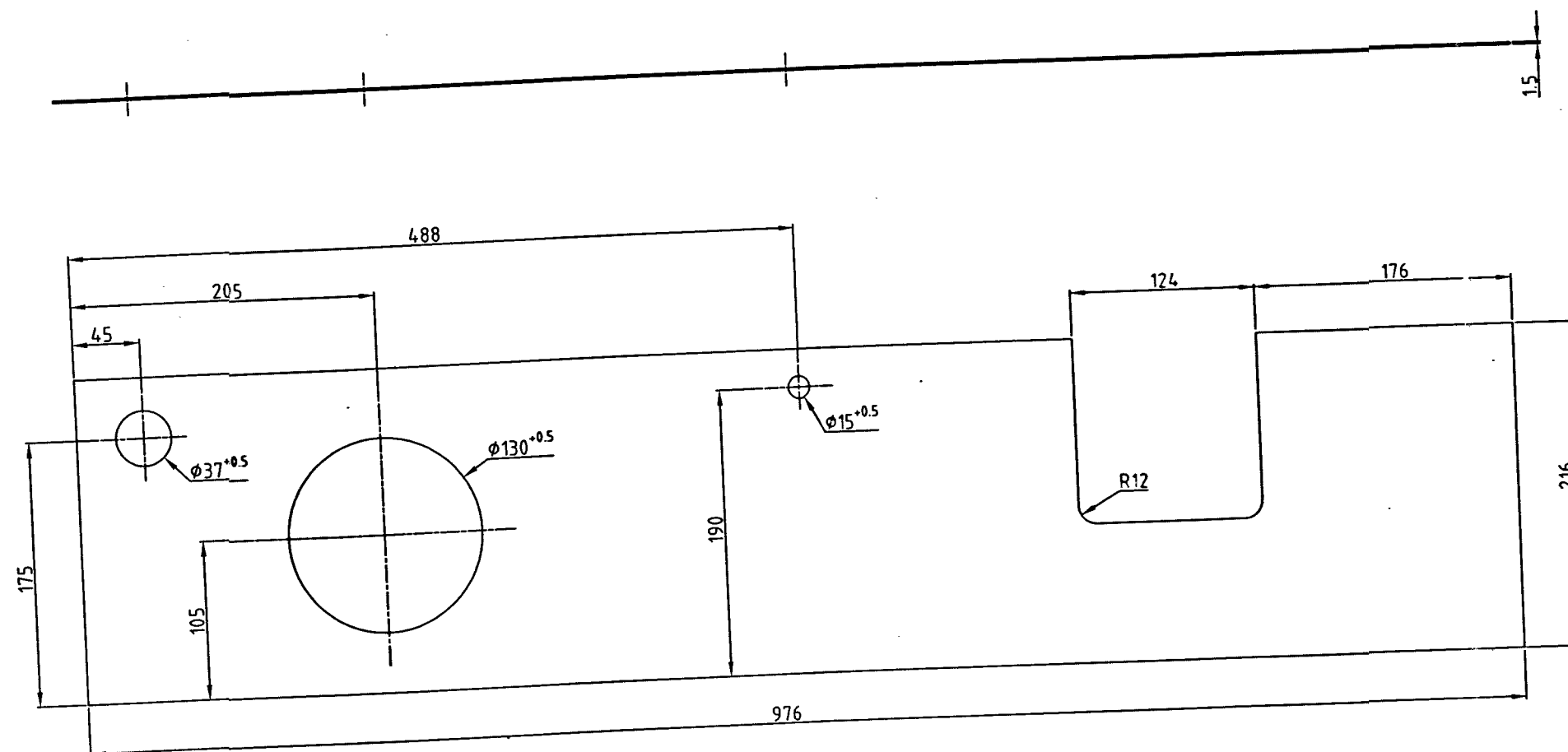
AUTHD.				DRG.NO:	675-WT-SA-001-04	UNSPECIFD. TOLERANCES ARE AS PER IS:2102
APRD.	NSreddy	24/8/10	32/8/10	TITLE:	COVER PLATE	UNLESS SPECIFD, DIMNS.IN MM
CHKD.	URKRoju	24/8/10	24/8/10			SHEET NO. WEIGHT SCALE
DRWN	NAME	SIGN	DATE			5 OF 7 NTS
ORDNANCE FACTORY MEDAK				MTL:	STAINLESS STEEL AISI: 316	FIRST ANGLE

BASED ON:

USED 675-WT-SA-001

✓(✓)

ISSUE	APPRD.	NATURE OF AMENDMENT

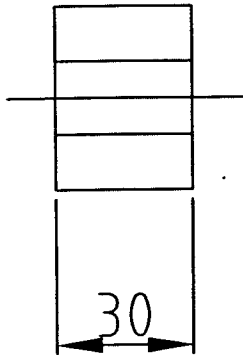


Note :

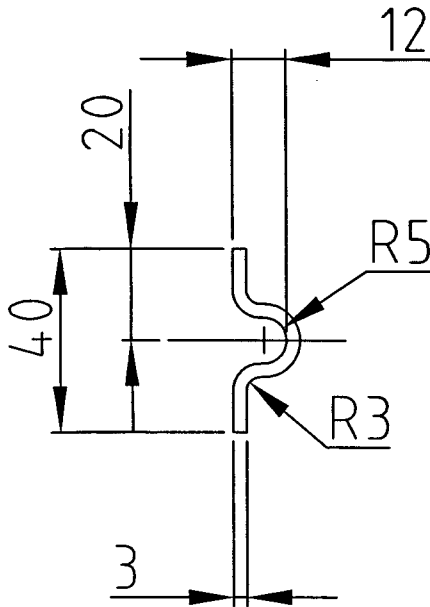
1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911
3. Thickness 1.5mm.

AUTHD.				DRG. NO:	675-WT-SA-001-05	UNSPECIFD. TOLERANCES ARE AS PER IS:2102
APRD.	NSM		3-7-3/10			UNLESS SPECIFD, DIMNS. IN MM
CHKD.	NSReddy		3-7-3/10	TITLE:	TANK TOP COVER PLATE	SHEET NO. WEIGHT SCALE
DRWN	URKRaju		2-4-8/10			6 OF 7 NTS
2009	NAME	SIGN	DATE			FIRST ANGLE
ORDNANCE FACTORY MEDAK				MTL:	STAINLESS STEEL AISI: 316	

BASED ON:				✓(✓)	ISSUE	APPRD.	NATURE OF AMENDMENT	
USED ON : 675-WT-SA-001								



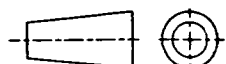
30



12
20
40
3
R5
R3

Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911

AUTHD.				DRG.NO:	675-WT-SA-001-06		
APRD.	<i>NSR</i>	<i>RA</i>	37/08/10	TITLE: CLAMP	UNSPECIFD. TOLERANCES ARE AS PER IS:2102		
CHKD.	NSReddy	<i>RA</i>	30/8/10		UNLESS SPECIFD, DIMNS. IN MM		
DRWN	URKRaju	<i>URK</i>	24/8/10		SHEET NO.	WEIGHT	SCALE
2009	NAME	SIGN	DATE		7 OF 7		NTS
ORDNANCE FACTORY MEDAK				MTL:	STAINLESS STEEL AISI: 316		FIRST ANGLE

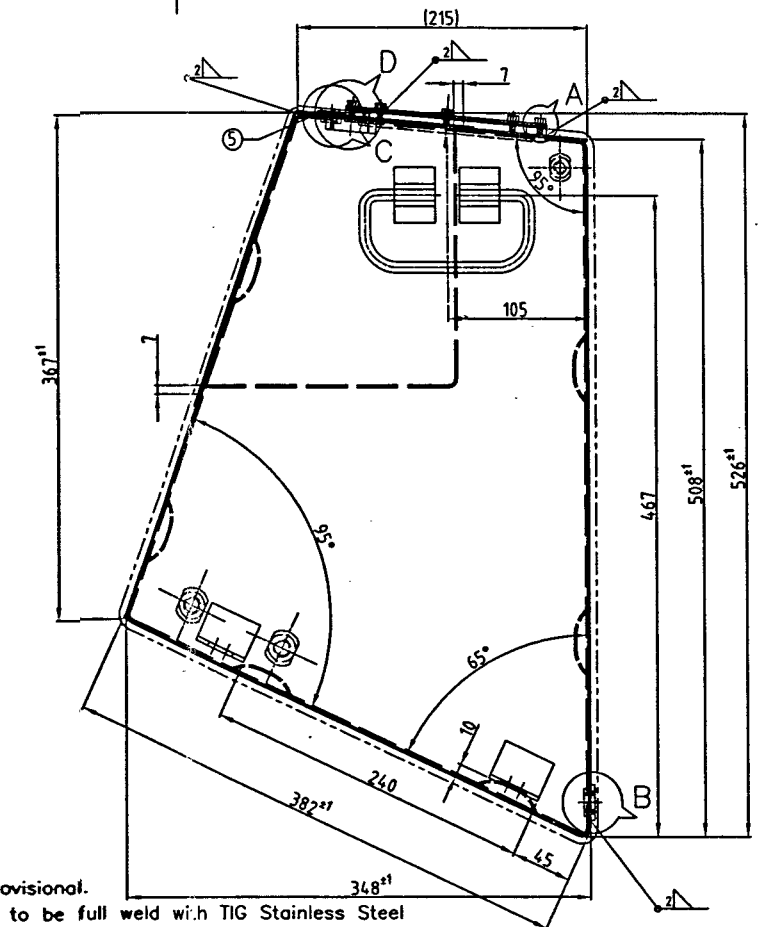
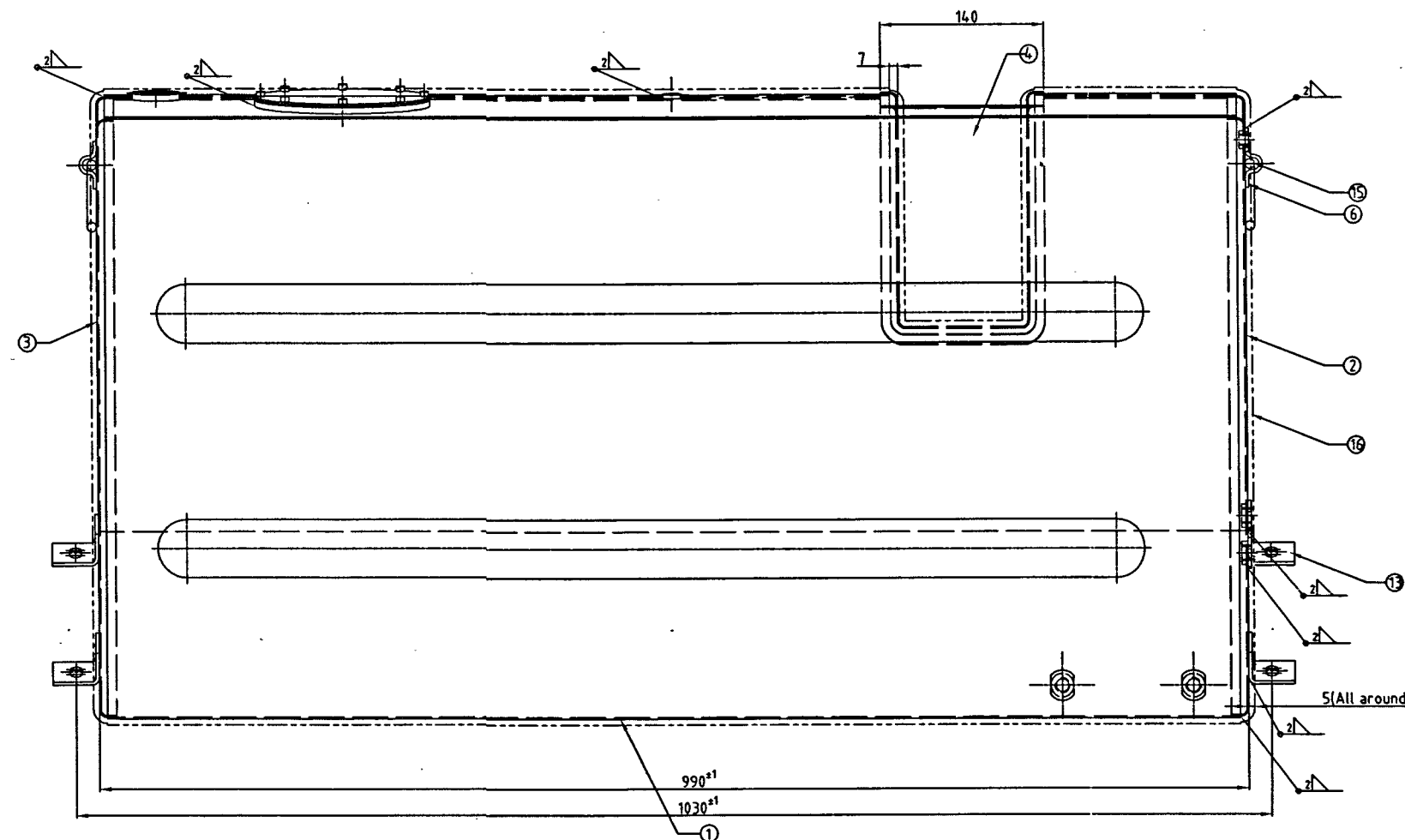
BASED ON:

USED 675-WT-SA-000

(A) 8. S.S Tank with 5mm Fibre Reinforced Plastic Pasting.

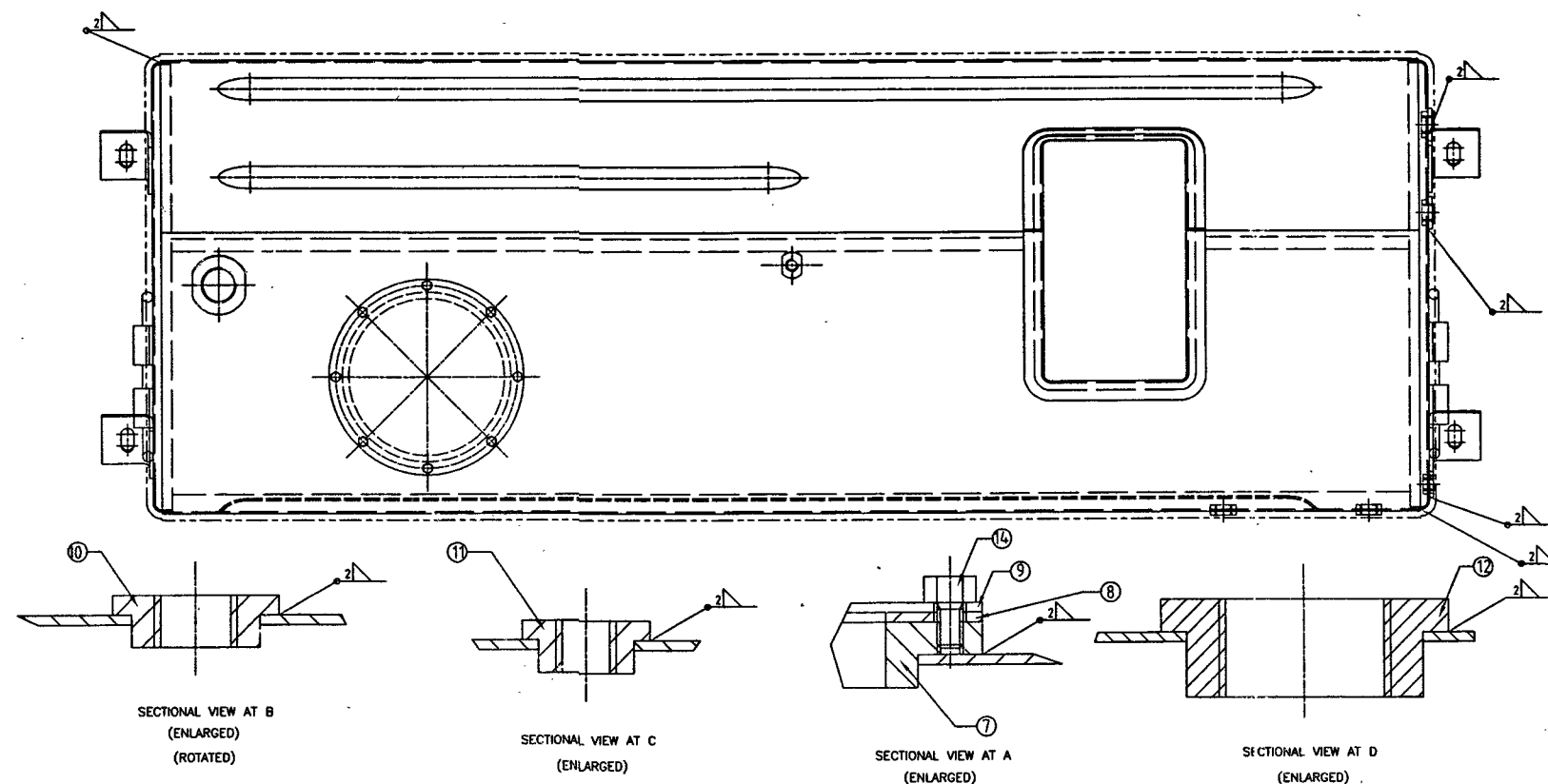
✓(✓)

ISSUE.	APPRD.	NATURE OF AMENDMENT
A	30/09/19	Note No.8 Added



Note :

1. Drawing is provisional.
2. All joints are to be full weld with TIG Stainless Steel welding to IS : 2811 - 92.
3. Confirming leak test to be conducted before FRP mould.
4. Unspecified tolerance on threads as per IS : 4218.
5. FRP to be moulded all around the tank by relieving openings.
6. Red Oxide primer colour shade ISC No. 446 to IS 2074-92.
7. Olive Green paint Shade 294, IS : 8982-91.

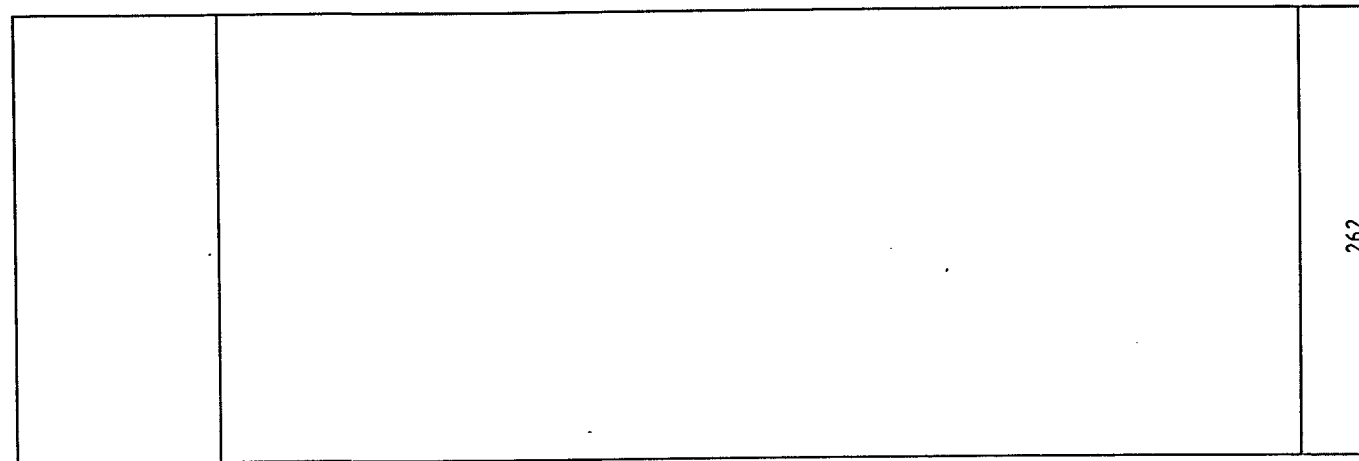
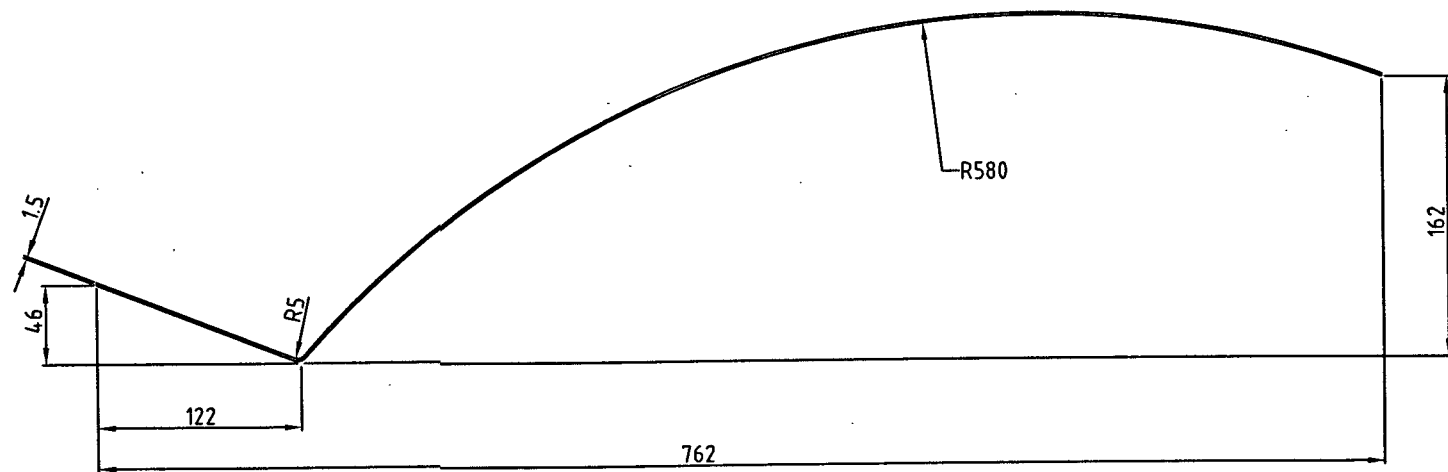


16	675-WT-SA-001-07	FRP BISPHENOL RESIN	1	THICKNESS 5 mm
15	765-06-980	HANDLE	2	BMP PART
14	675-WT-SA-002-13	EX. SCREW , IS : 1367-98	8	S.S, AISI 316
13	675-WT-SA-002-12	CLAMP PIPECE	4	S.S, AISI 316
12	675-WT-SA-002-11	INLET & BREATHER BUSH	1	S.S, AISI 316
11	675-WT-SA-002-10	BREATHER BUSH	2	S.S, AISI 316
10	675-WT-SA-002-09	INLET & DRAIN BUSH	4	S.S, AISI 316
9	675-WT-SA-002-08	COVER PLATE	1	S.S, AISI 316
8	675-WT-SA-002-07	SEALING RUBBER	1	QA/RUBBER/ CQA(ICV)/005
7	675-WT-SA-002-06	BUSH	1	S.S, AISI 316
6	675-WT-SA-001-06	CLAMP	4	S.S, AISI 316
5	675-WT-SA-001-05	TANK TOP COVER PLATE	1	S.S, AISI 316
4	675-WT-SA-001-04	COVER PLATE	1	S.S, AISI 316
3	675-WT-SA-001-03	SIDE PLATE (LH)	1	S.S, AISI 316
2	675-WT-SA-001-02	SIDE PLATE (RH)	1	S.S, AISI 316
1	675-WT-SA-001-01	MAIN BODY	1	S.S, AISI 316
REF.NO.	DRAWING NO.	DESCRIPTION.	QTY.	REMARKS
AUTHD.	APRD.	DRG.NO:		
CHKD.	DRWN	TITLE:		
2009	NAME SIGN DATE	MAIN WATER TANK		
ORDNANCE FACTORY MEDAK		MIL:		
		ASSEMBLY DRG.		
			UNSPECIFD. TOLERANCES ARE AS PER IS:2102	
			UNLESS SPECIFD. DIMNS.IN MM	
			SHEET NO.	WEIGHT
			1 OF 7	NTS
				FIRST ANGLE

BASED ON:
USED ON : 675-WT-SA-002

ISSUE	APPRD.	NATURE OF AMENDMENT

✓(✓)



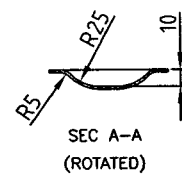
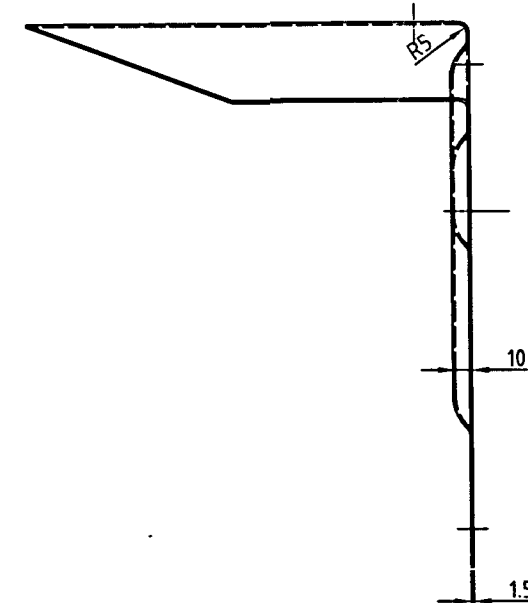
Note :

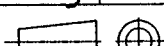
1. Drawing is provisional.
2. Alternate Material X34Cr17Ni12M02 IS : 6911
3. Thicknes 1.5mm.

AUTHD.		DRG.NO:	675-WT-SA-002-01	UNSPECIFD. TOLERANCES ARE
APRD.	NSReddy			AS PER IS:2102
CHKD.	URKRaju			UNLESS SPECIFD, DIMNS.IN MM
DRWN	2009	NAME	SIGN	DATE
2009	NAME	SIGN	DATE	
ORDNANCE FACTORY MEDAK				MTL: STAINLESS STEEL AISI: 316
TITLE: BOTTOM PLATE				SHEET NO. 2 OF 13
				WEIGHT
				SCALE
				NTS
				FIRST ANGLE

USED ON: 675-WT-SA-002

✓(✓)

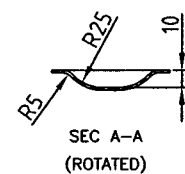
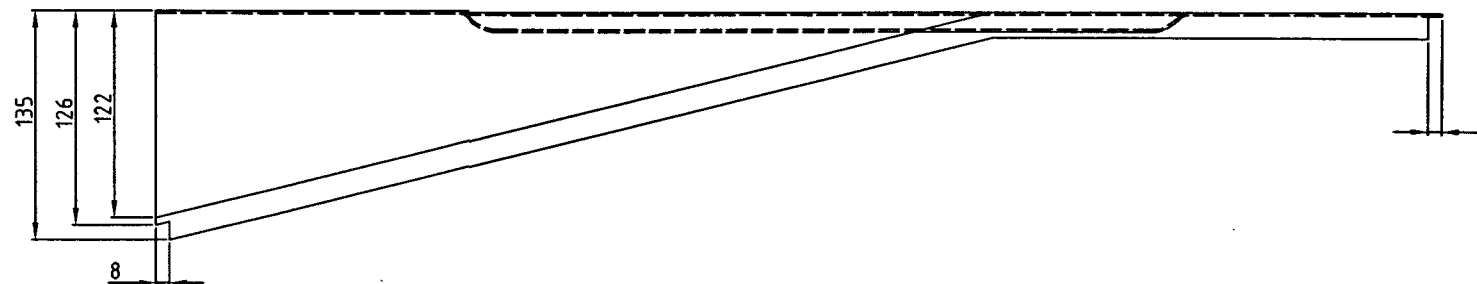
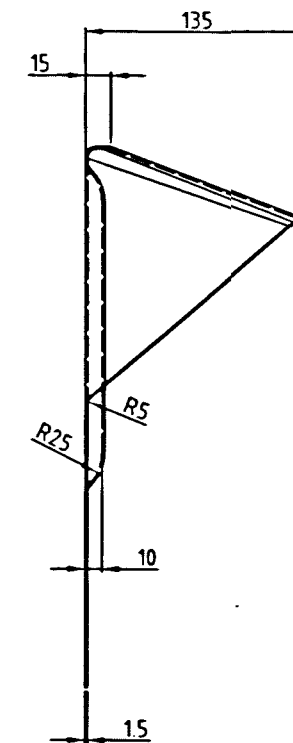
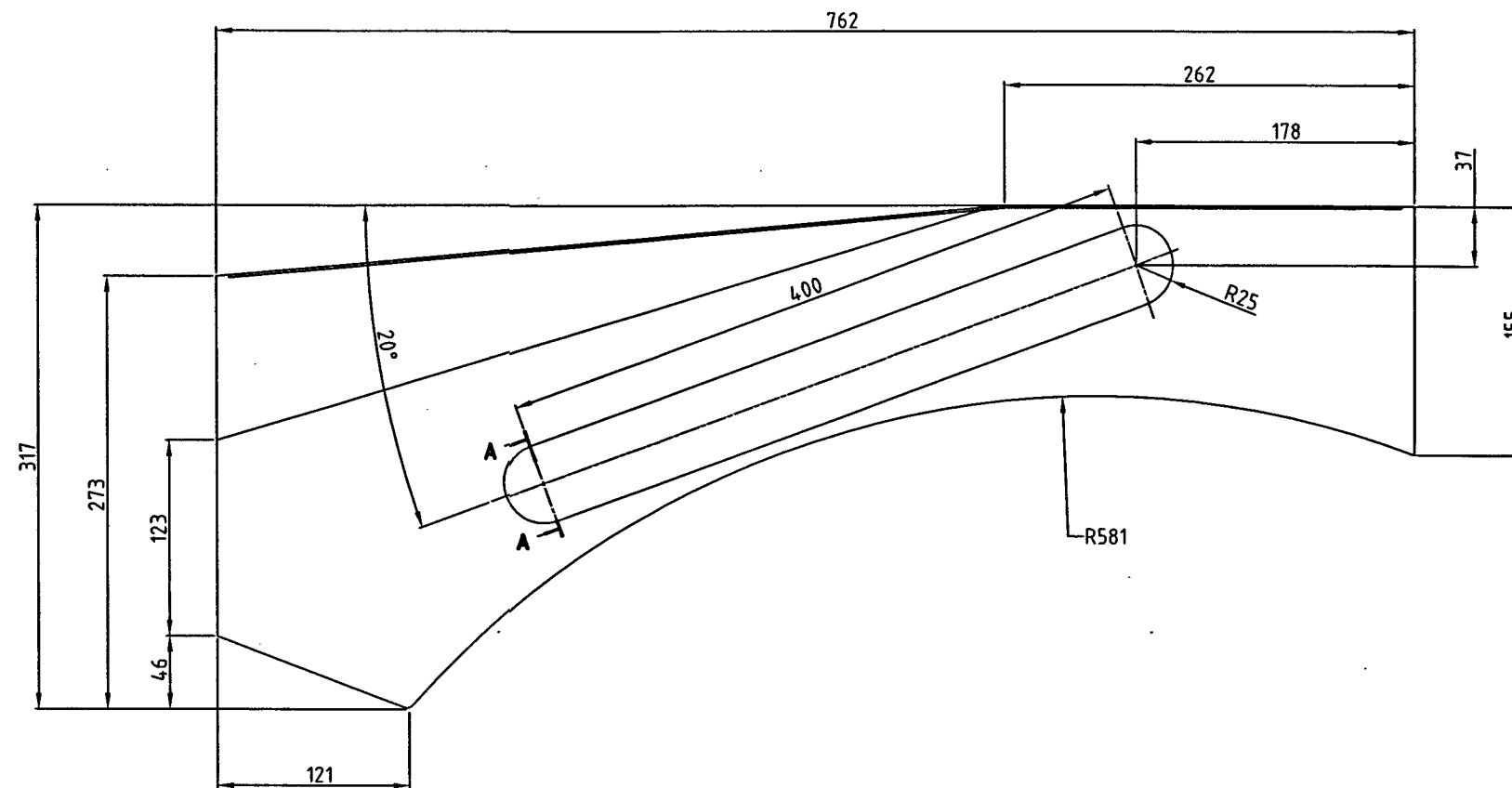


AUTHD.			DRG. NO:	675-WT-SA-002-02	UNSPECIFD. TOLERANCES ARE AS PER IS:2102
APRD.	SSIM	9/7/88	FILE:	FRONT PLATE	UNLESS SPECIFD, DIMS.IN MM
CHKD.	NSReddy	9/2/10			SHEET NO. WEIGHT SCALE
DRWN	URKRaju	29/8/10			3 OF 13 NTS
2009	NAME	SIGN	DATE		
ORDNANCE FACTORY MEDAK				MTL: STAINLESS STEEL AISI: 316	
					FIRST ANGLE

BASED ON:

USED ON : 675-WT-SA-002

ISSUE	APPRD.	NATURE OF AMENDMENT



Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911
3. Thicknes 1.5mm.

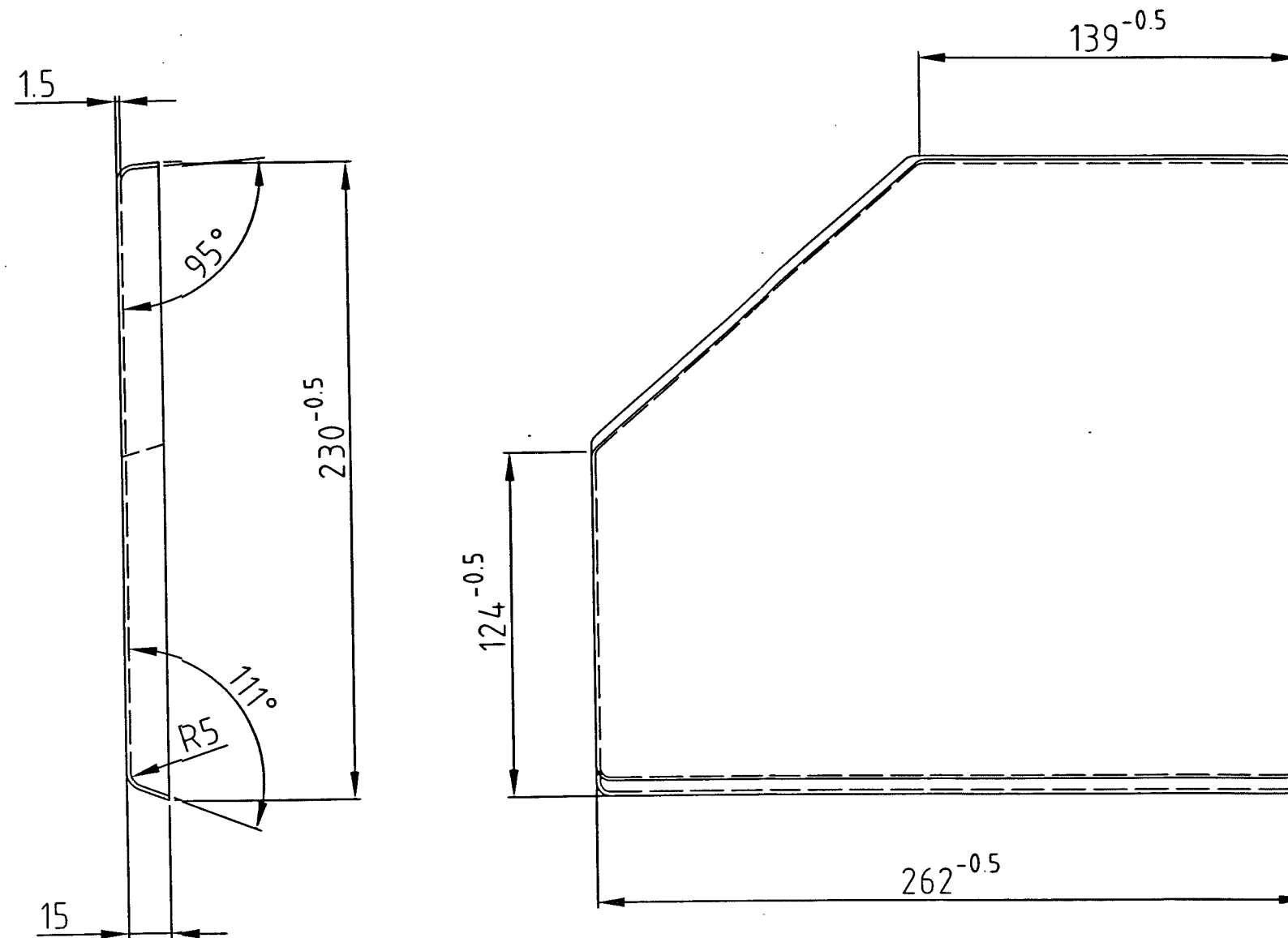
AUTHD.				DRG.NO:	675-WT-SA-002-03	UNSPECIFD. TOLERANCES ARE
APRD.	NSM					AS PER IS:2102
CHKD.	NSReddy			TITLE:	BACK PLATE	UNLESS SPECIFD, DIMNS.IN MM
DRWN	URKRaju					SHEET NO. WEIGHT SCALE
2009	NAME	SIGN	DATE			4 OF 13 NTS
ORDNANCE FACTORY MEDAK				MTL:	STAINLESS STEEL AISI: 316	FIRST ANGLE

BASED ON:

USED ON : 675-WT-SA-002

(V/A)

ISSUE	APPRD.	NATURE OF AMENDMENT



Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911
3. Thickness 1.5mm.
4. It is allowed to cut and weld at corners of flange.

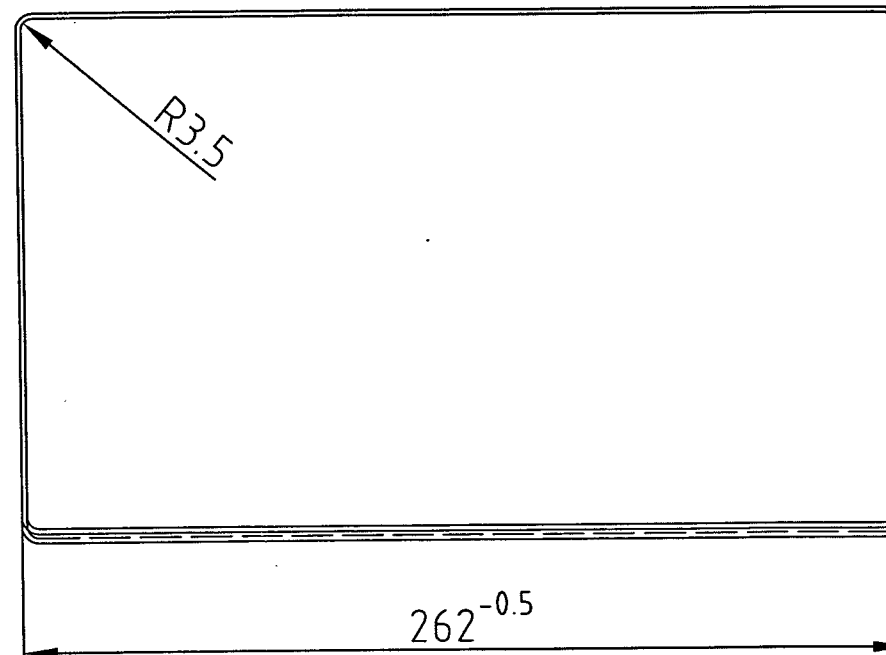
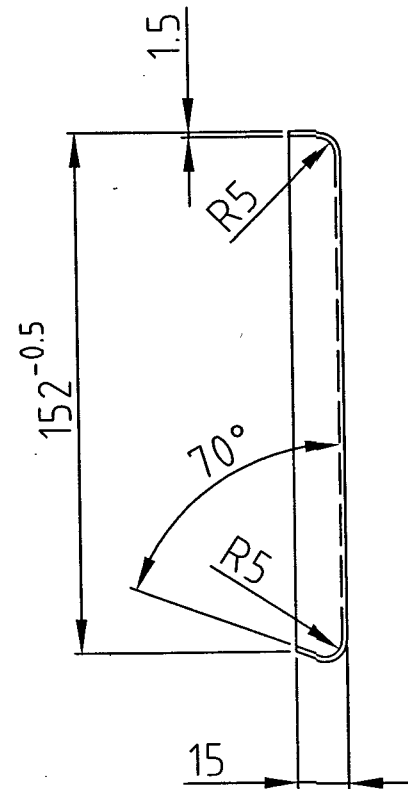
AUTHD.				DFG.NO:	675-WT-SA-002-04	UNSPECIFD. TOLERANCES ARE AS PER IS:2102
APRD.	SSM	25/08/2009				UNLESS SPECIFD, DIMNS.IN MM
CHKD.	NSReddy	25/08/2009		TITLE:	SIDE PLATE (LH)	SHEET NO.
DRWN	URKRaju	25/08/2009				WEIGHT
2009	NAME	SGN	DATE			SCALE
ORDNANCE FACTORY MEDAK				MFL:	STAINLESS STEEL AISI: 316	5 OF 13
						NTS
						FIRST ANGLE

BASED ON:

USED ON : 675-WT-SA-002

ISSUE APPRD. NATURE OF AMENDMENT

(V)A



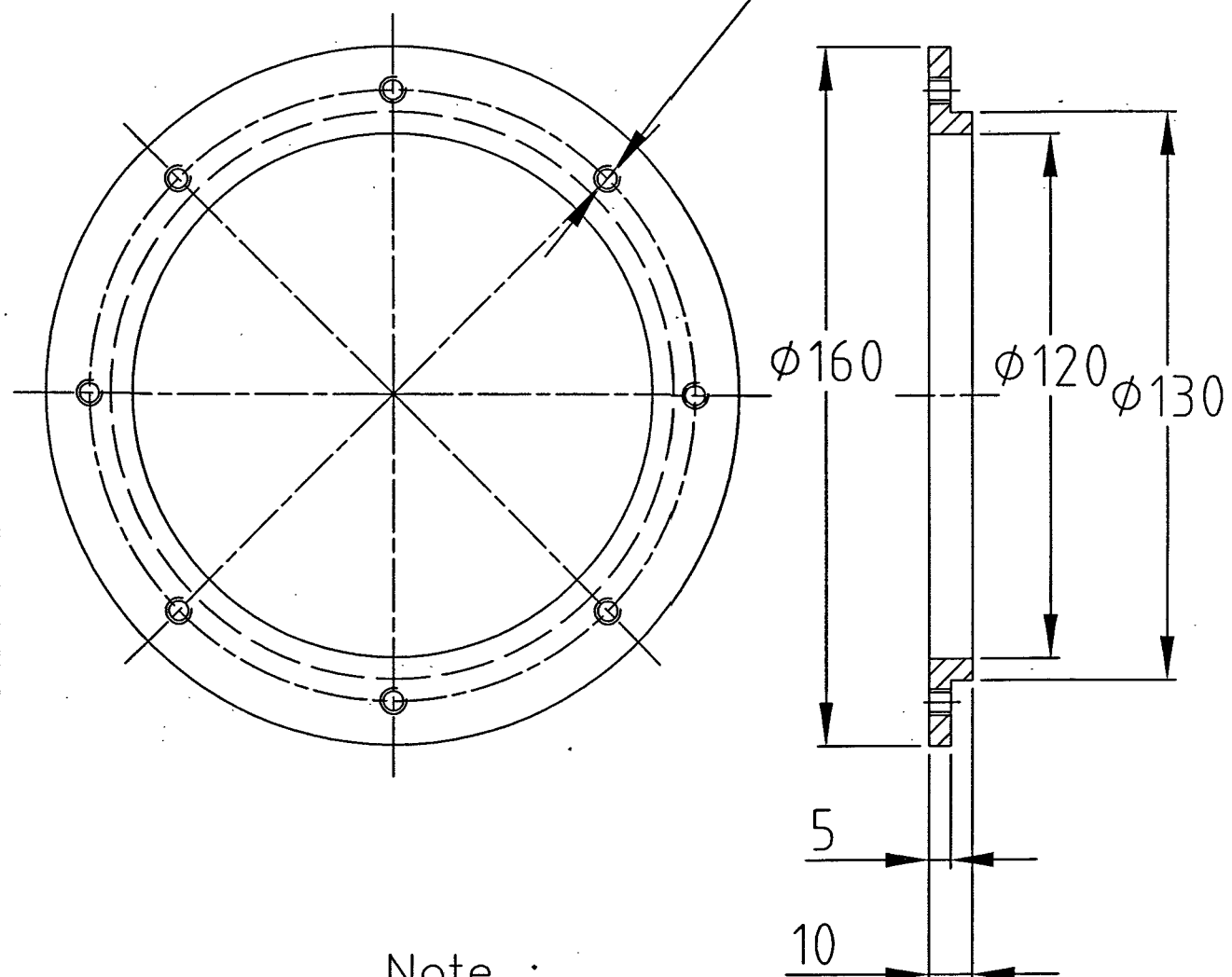
Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911
3. Thickness 1.5mm.
4. It is allowed to cut and weld at corners of flange.

AUTHD.		DRG.NO:	675-WT-SA-002-05	UNSPECIFD. TOLERANCES ARE		
APRD.	NSIM	3908		AS PER IS:2102		
CHKD.	NSReddy	30/10		UNLESS SPECIFD. DIMNS.IN MM		
DRWN	URKRaju	05/11/2009		SHEET NO.	WEIGHT	SCALE
2009	NAME	SIGN	DATE	6 OF 13		NTS
ORDNANCE FACTORY			M.L: STAINLESS STEEL AISI: 316		FIRST ANGLE	
MEDAK						

BASED ON:	✓(✓)	ISSUE	APPRD.	NATURE OF AMENDMENT
USED ON: 675-WT-SA-001 675-WT-SA-002 675-WT-SA-003 675-WT-SA-004				

8 Nos ON PCD-140-M6



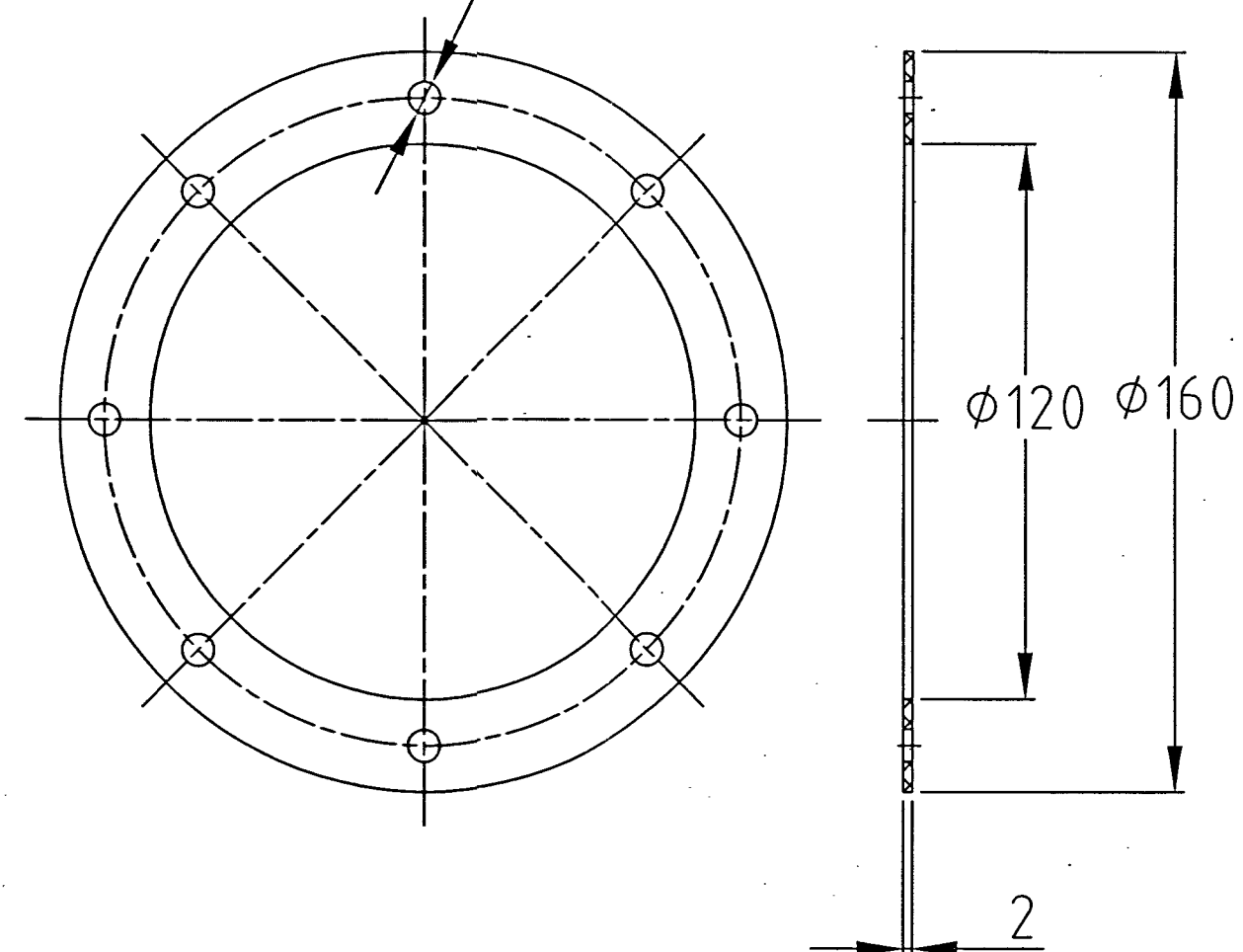
Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911

AUTHD.				DRG.NO:	675-WT-SA-002-06	UNSPECIFD. TOLERANCES ARE AS PER IS:2102		
APRD.	NSM			TITLE:	BUSH	UNLESS SPECIFD, DIMNS.IN MM		
CHKD.	NSReddy			SHEET NO.	7 OF 13	WEIGHT	SCALE	NTS
DRWN	URKRaju							
2009	NAME	SIGN	DATE					
ORDNANCE FACTORY MEDAK				MTL:	STAINLESS STEEL AISI: 316	FIRST ANGLE		

BASED ON:	✓(✓)	ISSUE	APPRD.	NATURE OF AMENDMENT
USED ON: 675-WT-SA-001 675-WT-SA-002 675-WT-SA-003 675-WT-SA-004				

8 Nos on PCD 140- $\phi 7^{+0.1}$



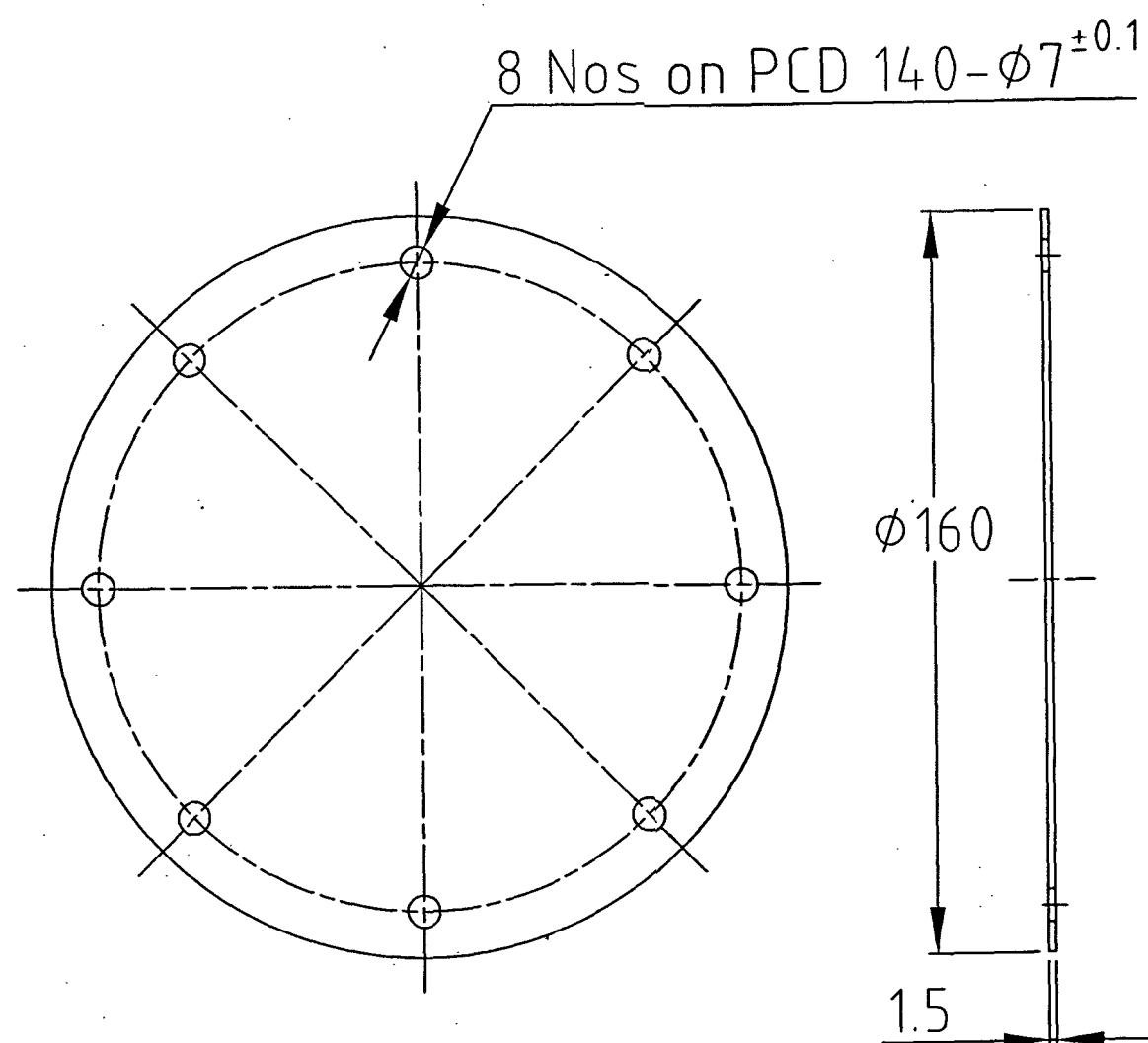
Note :

1. Drawing is provisional.

AUTHD.				DRG.NO:	675-WT-SA-002-07	UNSPECIFD. TOLERANCES ARE AS PER IS:2102		
APRD.	NSM			TITLE:	SEALING RUBBER	UNLESS SPECIFD, DIMNS.IN MM		
CHKD.	NSReddy			SHEET NO.	8 OF 13	WEIGHT	SCALE	NTS
DRWN	URKRaju							
2009	NAME	SIGN	DATE					
ORDNANCE FACTORY MEDAK				MTL:	QAI/RUBBER/CQA(ICV)005	FIRST ANGLE		

BASED ON:	ISSUE	APPRD.	NATURE OF AMENDMENT
USED ON: 675-WT-SA-001 675-WT-SA-002 675-WT-SA-003 675-WT-SA-004			

✓(✓)



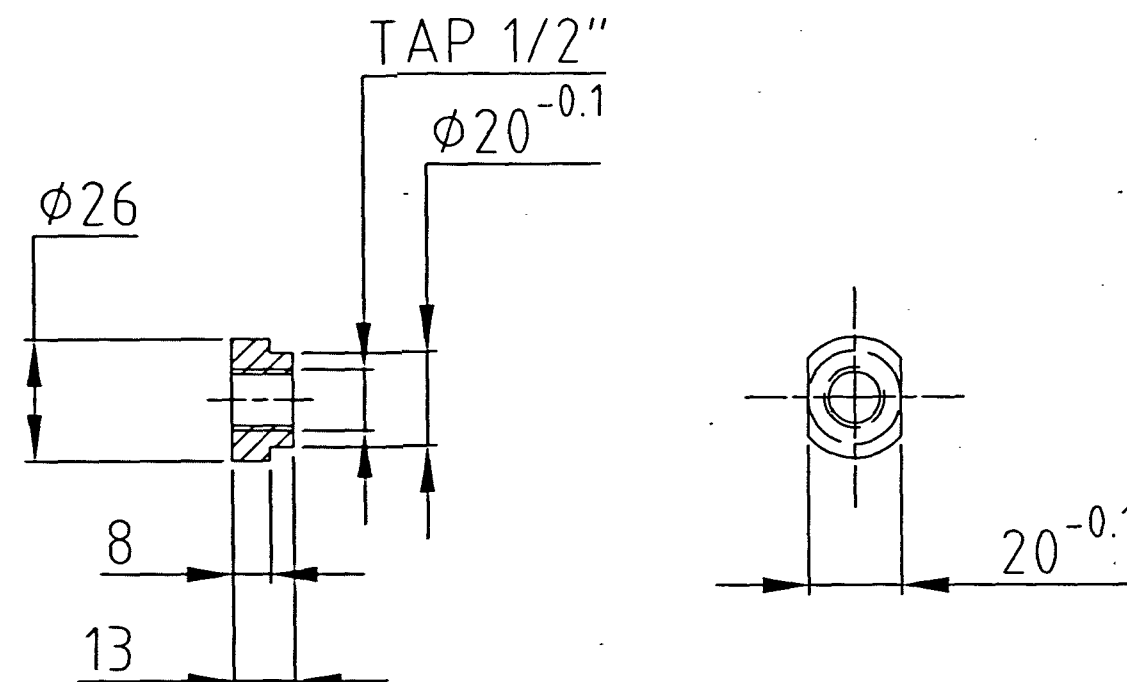
Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911

AUTHD.		DRG.NO:	675-WT-SA-002-08	UNSPECIFD. TOLERANCES ARE AS PER IS:2102
APRD.	NSM	TITLE:	COVER PLATE	UNLESS SPECIFD, DIMNS.IN MM
CHKD.	NSReddy	SHEET NO.	9 OF 13	WEIGHT
DRWN	URKRaju	SCALE	NTS	
2009	NAME	SIGN	DATE	FIRST ANGLE
ORDNANCE FACTORY MEDAK			MTL:	STAINLESS STEEL AISI: 316

BASED ON:	ISSUE	APPRD.	NATURE OF AMENDMENT
USED ON: 675-WT-SA-001 675-WT-SA-002 675-WT-SA-003 675-WT-SA-004			

✓(✓)

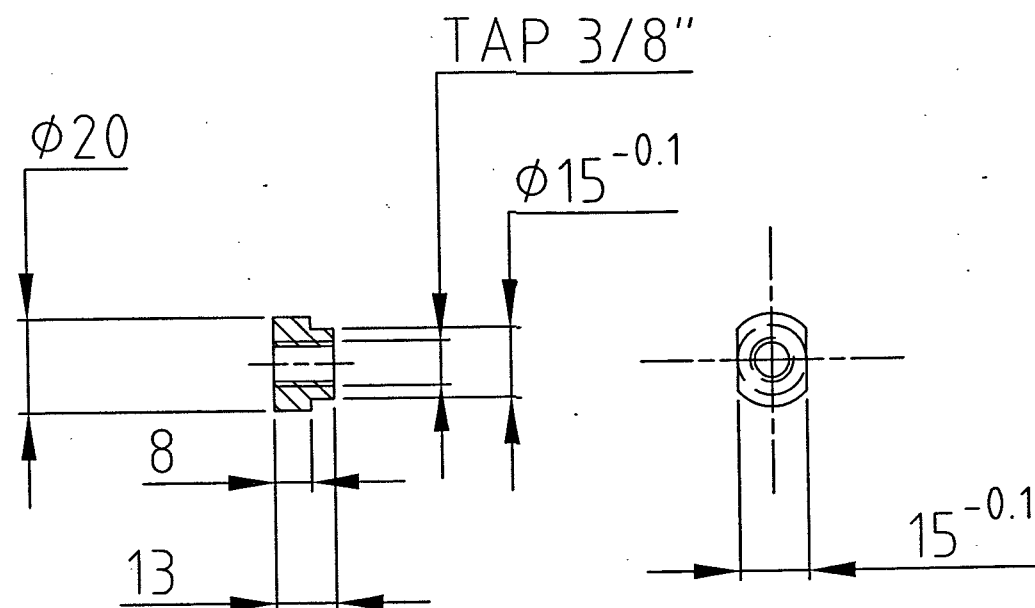


Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911

AUTHD.		DRG.NO:	675-WT-SA-002-09	UNSPECIFD. TOLERANCES ARE AS PER IS:2102
APRD.	NSM	TITLE:	INLET & DRAIN BUSH	UNLESS SPECIFD, DIMNS.IN MM
CHKD.	NSReddy	SHEET NO.	10 OF 13	WEIGHT
DRWN	URKRaju	SCALE	NTS	
2009	NAME	SIGN	DATE	FIRST ANGLE
ORDNANCE FACTORY MEDAK			MTL:	STAINLESS STEEL AISI: 316

BASED ON:	ISSUE	APPRD.	NATURE OF AMENDMENT
USED ON : 675-WT-SA-001 675-WT-SA-002 675-WT-SA-003 675-WT-SA-004			

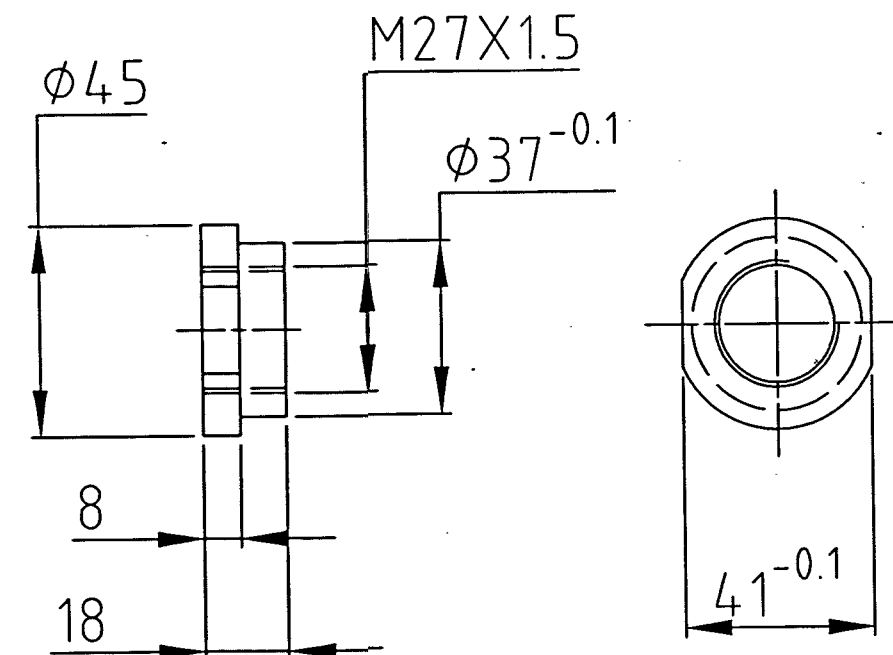


Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911

AUTHD.				DRG.NO:	675-WT-SA-002-10	UNSPECIFD. TOLERANCES ARE AS PER IS:2102
APRD.	NSM			TITLE:	BREATHER BUSH	UNLESS SPECIFD, DIMNS.IN MM
CHKD.	NSReddy			SHEET NO.	11 OF 13	WEIGHT
DRWN	URKRaju			SCALE	NTS	SCALE
2009	NAME	SIGN	DATE	MTL:	STAINLESS STEEL AISI: 316	FIRST ANGLE
ORDNANCE FACTORY MEDAK						

BASED ON:	ISSUE	APPRD.	NATURE OF AMENDMENT
USED ON : 675-WT-SA-001 675-WT-SA-002 675-WT-SA-003 675-WT-SA-004			

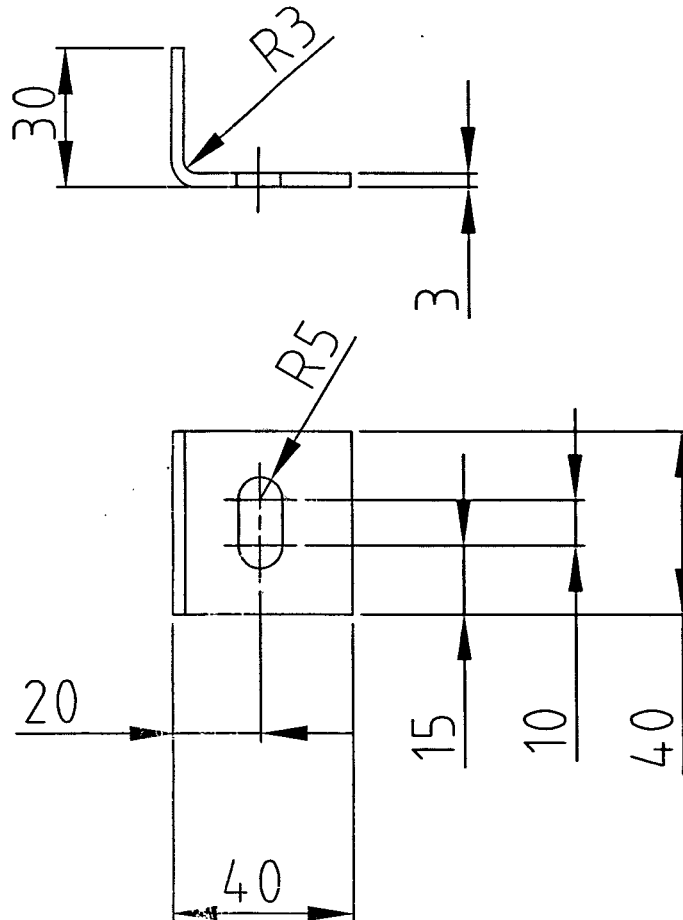


Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911

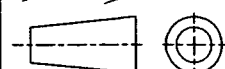
AUTHD.				DRG.NO:	675-WT-SA-002-11	UNSPECIFD. TOLERANCES ARE AS PER IS:2102
APRD.	NSM			TITLE:	INLET & BREATHER BUSH	UNLESS SPECIFD, DIMNS.IN MM
CHKD.	NSReddy			SHEET NO.	12 OF 13	WEIGHT
DRWN	URKRaju			SCALE	NTS	SCALE
2009	NAME	SIGN	DATE	MTL:	STAINLESS STEEL AISI: 316	FIRST ANGLE
ORDNANCE FACTORY MEDAK						

BASED ON:	✓(✓)	ISSUE	APPRD.	NATURE OF AMENDMENT
USED ON : 675-WT-SA-001				
675-WT-SA-002				
675-WT-SA-003				
675-WT-SA-004				



Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911

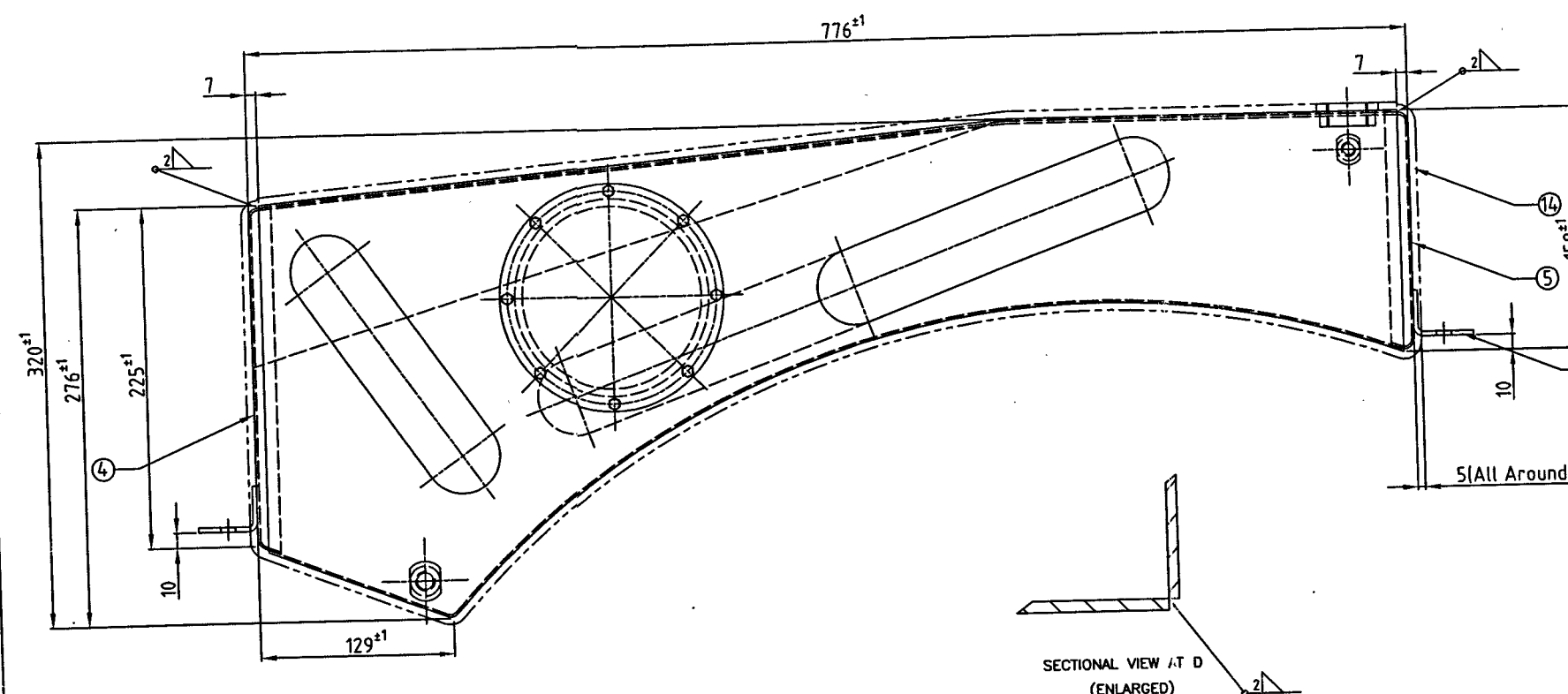
AUTHD.				DRG.NO:	675-WT-SA-002-12	UNSPECIFD. TOLERANCES ARE			
APRD.	NSM	9/8	30/08/10	TITLE: CLAMP PIECE		AS PER IS:2102			
CHKD.	NSReddy	10/8	30/08/10			UNLESS SPECIFD, DIMNS.IN MM			
DRWN	URKRaju	10/8	29/8/10			SHEET NO.	WEIGHT	SCALE	
2009	NAME	SIGN	DATE	MTL: STAINLESS STEEL AISI: 316		19 OF 13		NTS	
ORDNANCE FACTORY MEDAK									FIRST ANGLE

BASED ON:

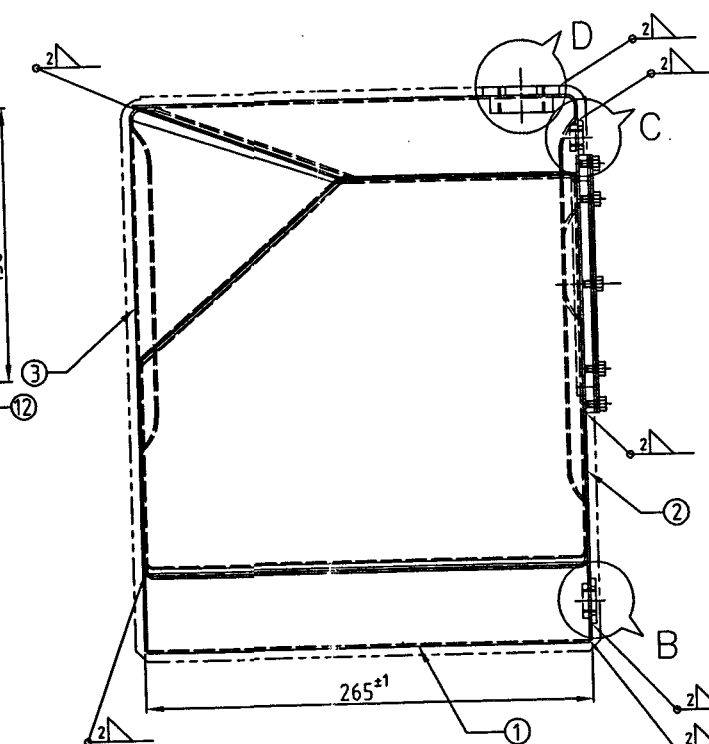
USED 675-WT-SA-000

ISSUE	APPRD.	NATURE OF AMENDMENT
A	30/09/19	Note No.8 Added

✓(✓)

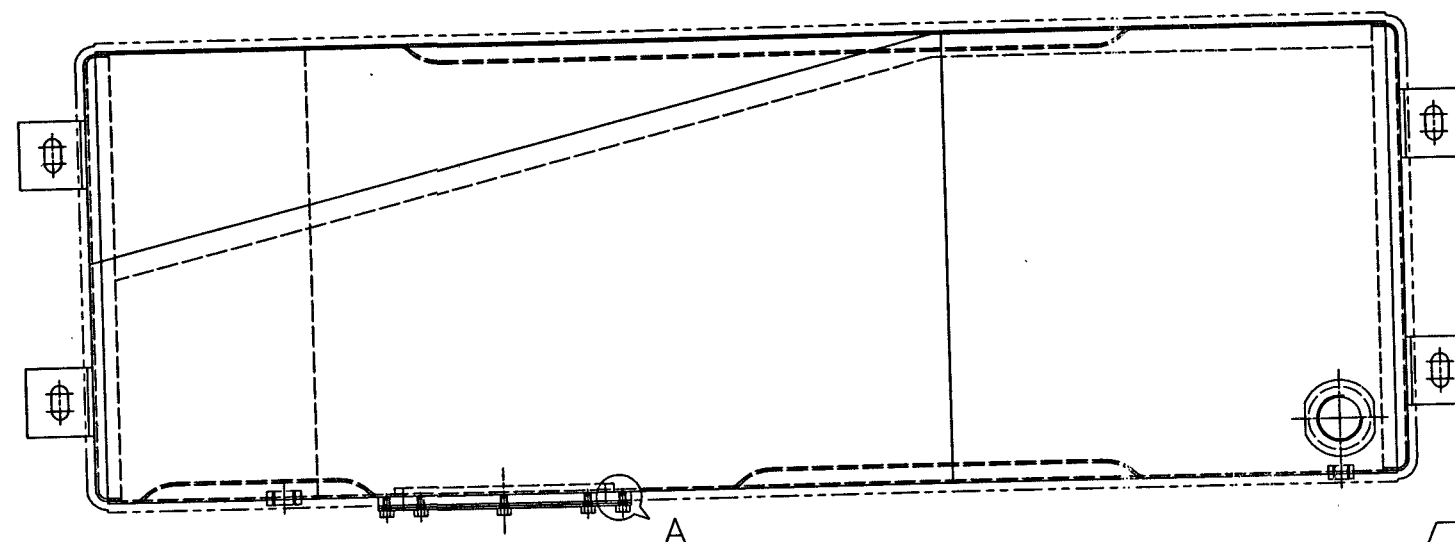


SECTIONAL VIEW AT D
(ENLARGED)

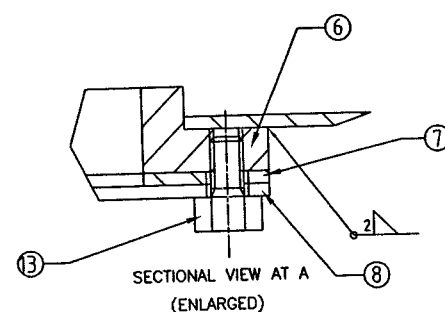


Note :

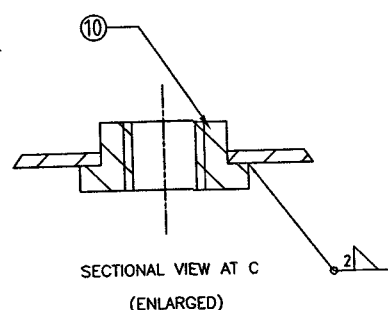
1. Drawing is provisional.
2. All joints are to be full weld with TIG Stainless Steel welding to IS : 2811 - 92.
3. Confirming leak test to be conducted before FRP mould.
4. Unspecified tolerance on threads as per IS : 4218.
5. FRP to be moulded all around the tank by relieving openings.
6. Red Oxide primer colour shade ISC No. 446 to IS 2074-92.
7. Olive Green paint 294, IS :b 8982-91.



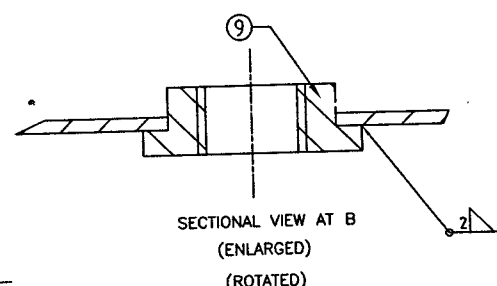
A



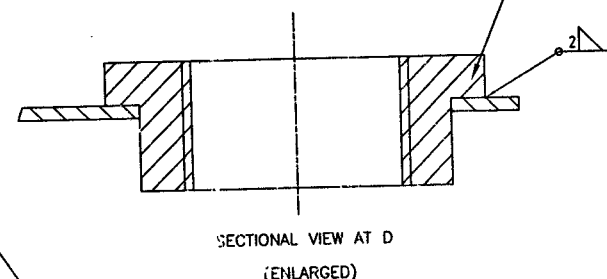
SECTIONAL VIEW AT A
(ENLARGED)



SECTIONAL VIEW AT C
(ENLARGED)



SECTIONAL VIEW AT B
(ENLARGED)
(ROTATED)



SECTIONAL VIEW AT D
(ENLARGED)

Note 8:Stainless Steel Tank with
5mm Fibre Reinforced
Plastic Pasting
(A)

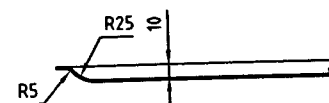
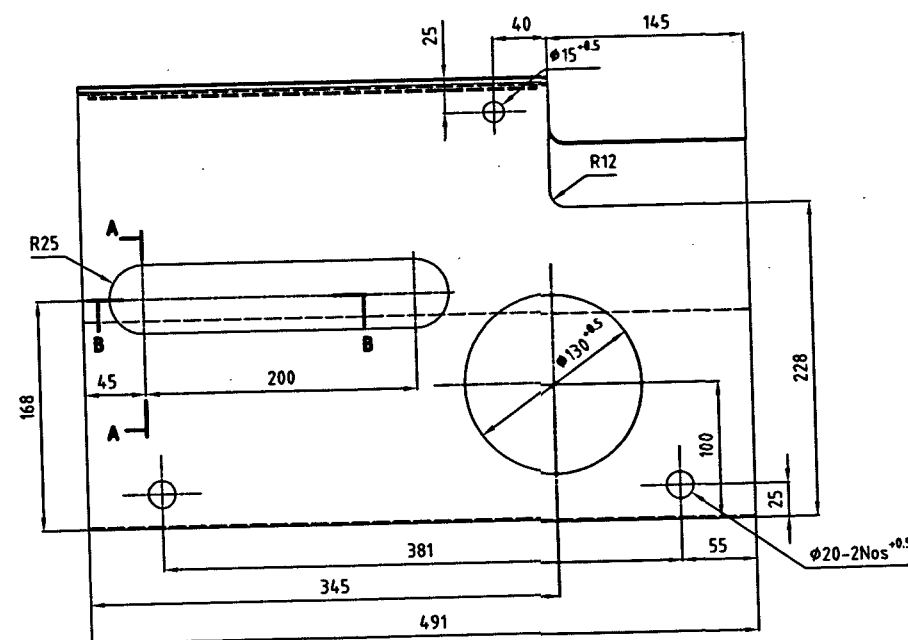
REF.NO.	DRAWING NO.	DESCRIPTION.	QTY.	REMARKS
14	675-WT-SA-002-14	FRP BISPHENOL RESIN	1	THICKNESS 5 mm
13	675-WT-SA-002-13	HEX. SCREW M6x10 IS : 1367-98	8	S.S, AISI 316
12	675-WT-SA-002-12	CLAMP PIECE	4	S.S, AISI 316
11	675-WT-SA-002-11	INLET & BREATHER BUSH	1	S.S, AISI 316
10	675-WT-SA-002-10	BREATHER BUSH	1	S.S, AISI 316
9	675-WT-SA-002-09	INLET & DRAIN BUSH	1	S.S, AISI 316
8	675-WT-SA-002-08	COVER PLATE	1	S.S, AISI 316
7	675-WT-SA-002-07	SEALING RUBBER	1	QA/RUBBER/ CQA(ICV)/005
6	675-WT-SA-002-06	BUSH	1	S.S, AISI 316
5	675-WT-SA-002-05	SIDE PLATE (RH)	1	S.S, AISI 316
4	675-WT-SA-002-04	SIDE PLATE (LH)	1	S.S, AISI 316
3	675-WT-SA-002-03	BACK PLATE	1	S.S, AISI 316
2	675-WT-SA-002-02	FRONT PLATE	1	S.S, AISI 316
1	675-WT-SA-002-01	BOTTOM PLATE	1	S.S, AISI 316
REF.NO.		DRAWING NO.	DESCRIPTION.	QTY.
AUTHD.		APPRD.	675-WT-SA-002	
CHKD.		DRWN.	2009	
NAME		SIGN	DATE	
ORDNANCE FACTORY MEDAK		ASSEMBLY DRG.		
UNSPECIFD. TOLERANCES ARE AS PER IS:2102		UNLESS SPECIFD, DIMNS.IN MM		
SHEET NO.		WEIGHT	SCALE	
1 OF 12			NTS	
FIRST ANGLE				

BASED ON:

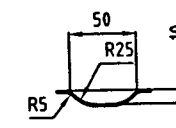
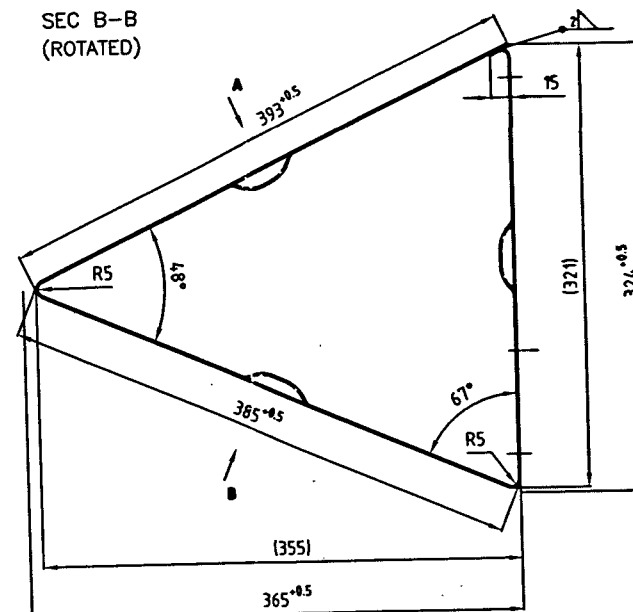
USED ON : 675-WT-SA-003

V(V)

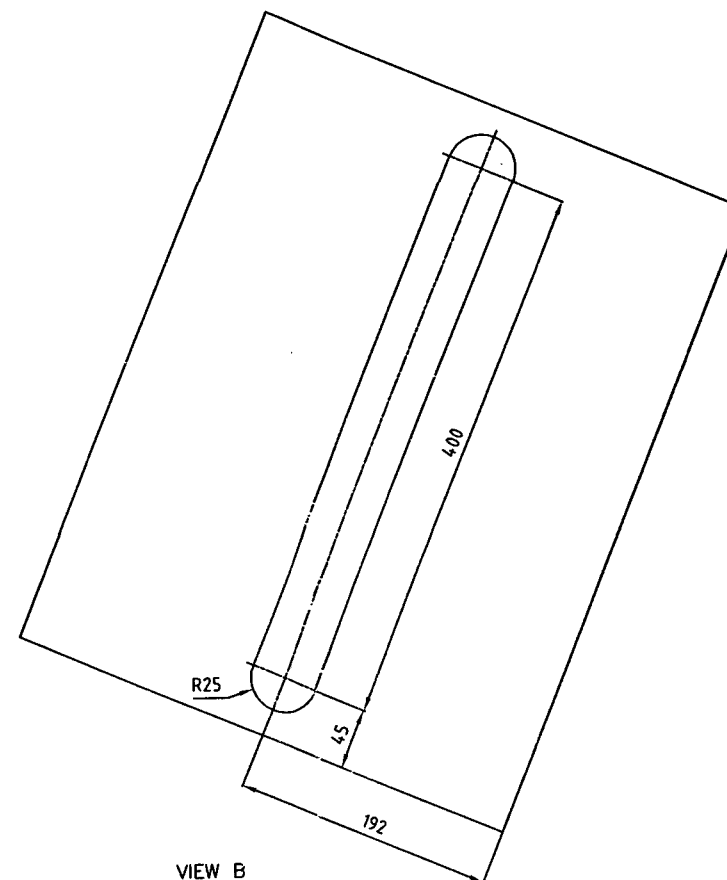
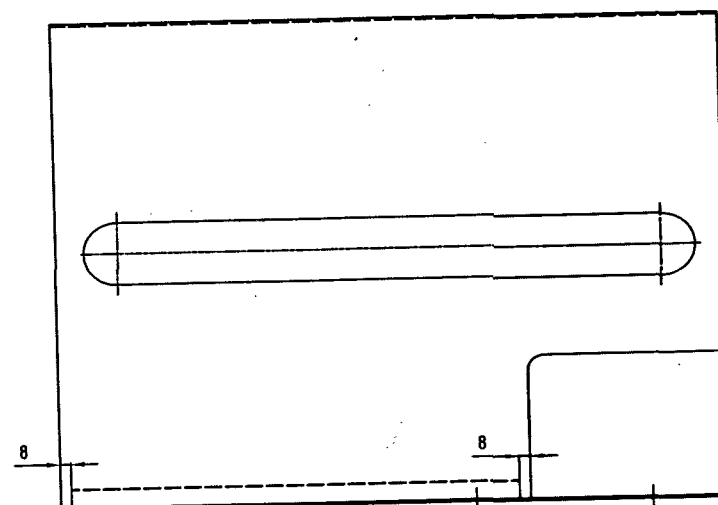
ISSUE	APPRD.	NATURE OF AMENDMENT



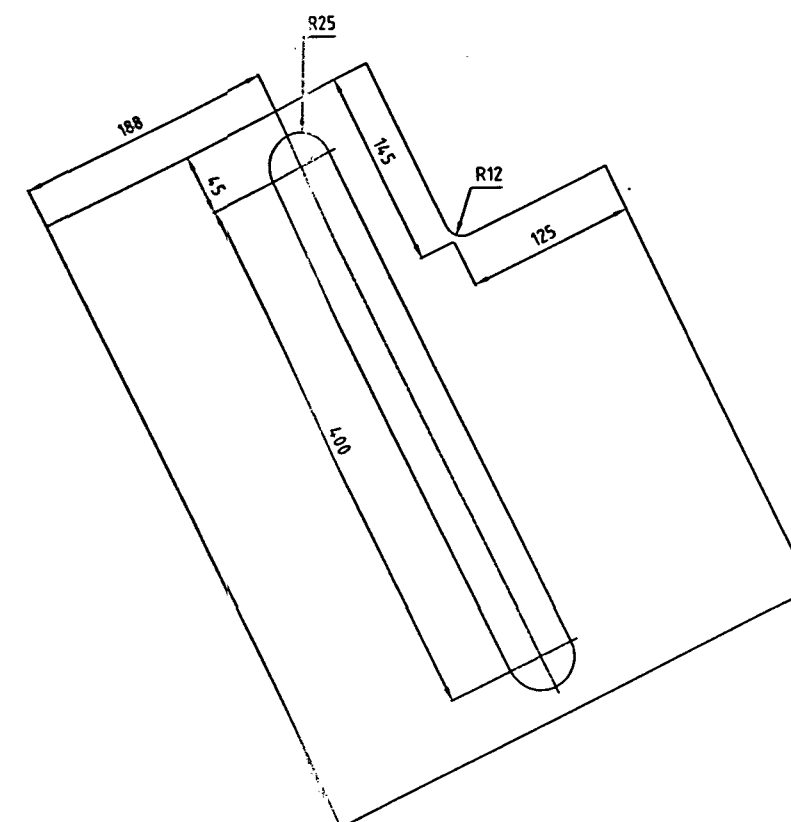
SEC B-B
(ROTATED)



SEC A-A
(ROTATED)



VIEW B
(TRUE)



VIEW A
(TRUE)

Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911
3. Thicknes 1.5mm

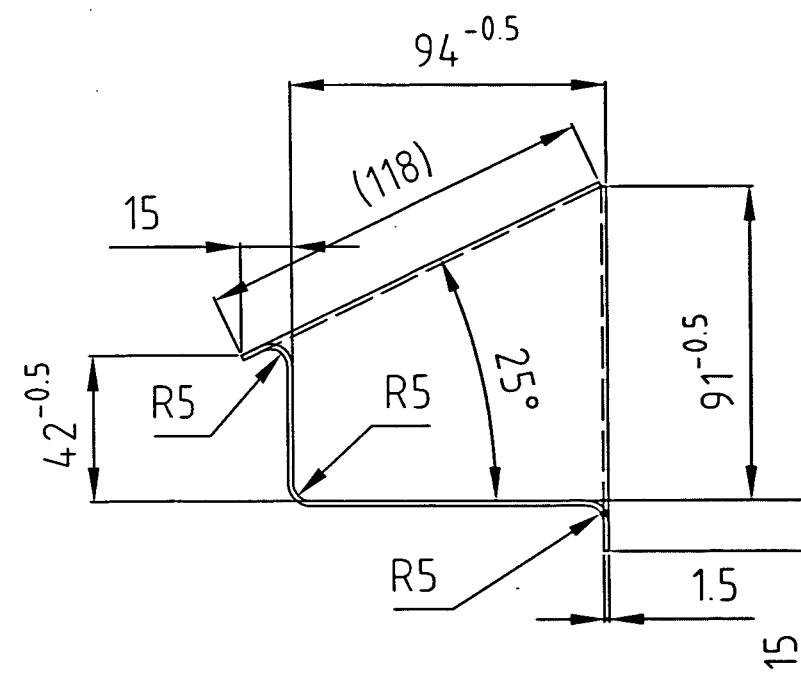
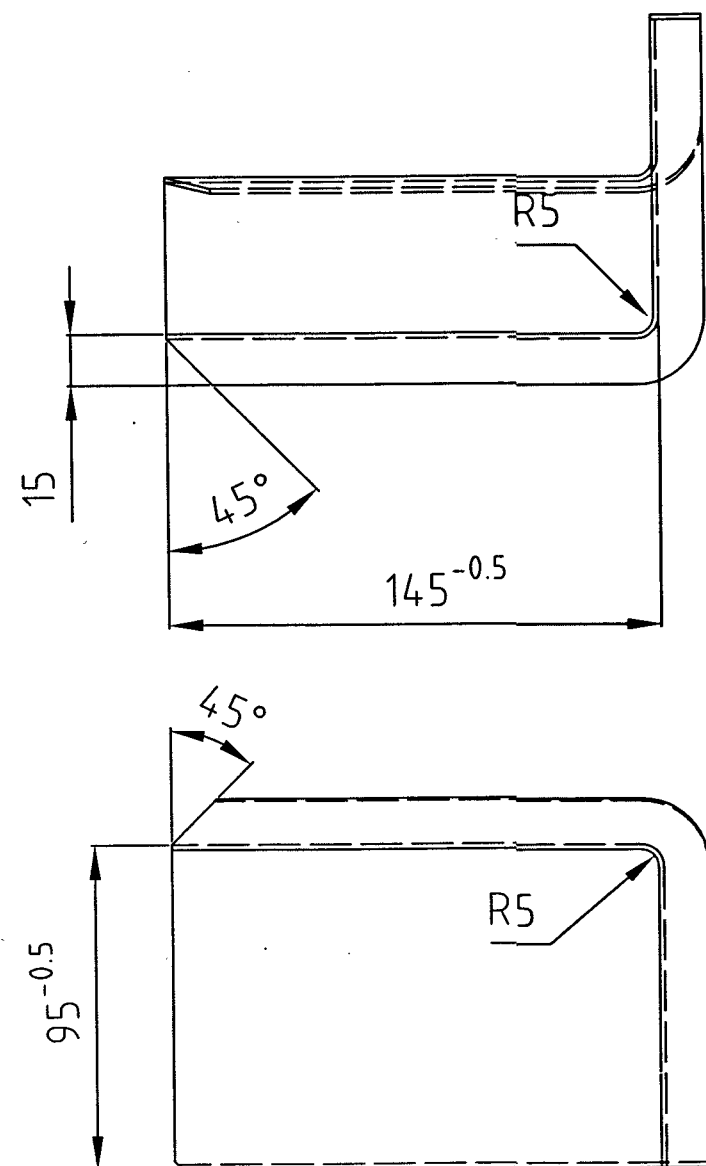
AUTHD.	APRD.	CHKD.	DRWN	2009	NAME	SIGN	DATE	DRG. NO:	675-WT-SA-003-01	UNSPECIFD. TOLERANCES ARE AS PER IS:2102
										UNLESS SPECIFD, DIMNS. IN MM
										SHEET NO.
										2 OF 5
										SCALE
										NTS
										FIRST ANGLE
ORDNANCE FACTORY MEDAK								W. L.	STAINLESS STEEL AISI: 316	

BASED ON:

USED ON : 675-WT-SA-003

ISSUE APPRD. NATURE OF AMENDMENT

✓(✓)



Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911
3. Thickness 1.5mm.
4. It is allowed to cut and weld at corners of flange.

AUTHD.		DRS.NO:	675-WT-SA-003-02	UNSPECIFD. TOLERANCES ARE
APRD.				AS PER IS:2102
CHKD.	NSReddy			UNLESS SPECIFD, DIMNS.IN MM
DRWN	URKRaju			SHEET NO.
2009	NAME	SIGN	DATE	3 OF 5
ORDNANCE FACTORY MEDAK				SCALE
				NTS
				FIRST ANGLE

MFL: STAINLESS STEEL AISI: 316

BASED ON:

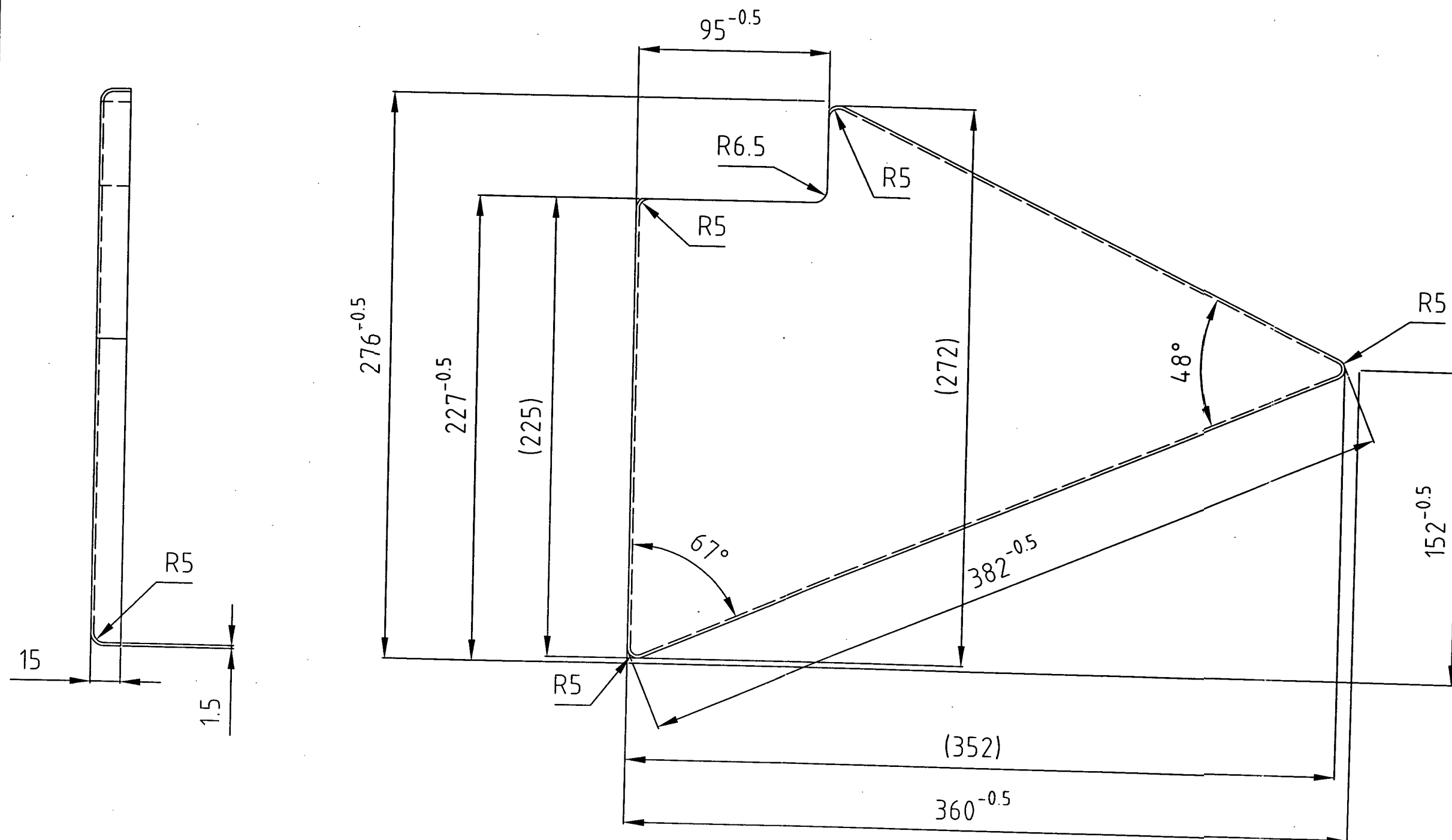
USED ON : 675-WT-SA-003

✓(✓)

ISSUE

APPRD.

NATURE OF AMENDMENT



Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911
3. Thickness 1.5mm.
4. It is allowed to cut and weld at corners of flange.

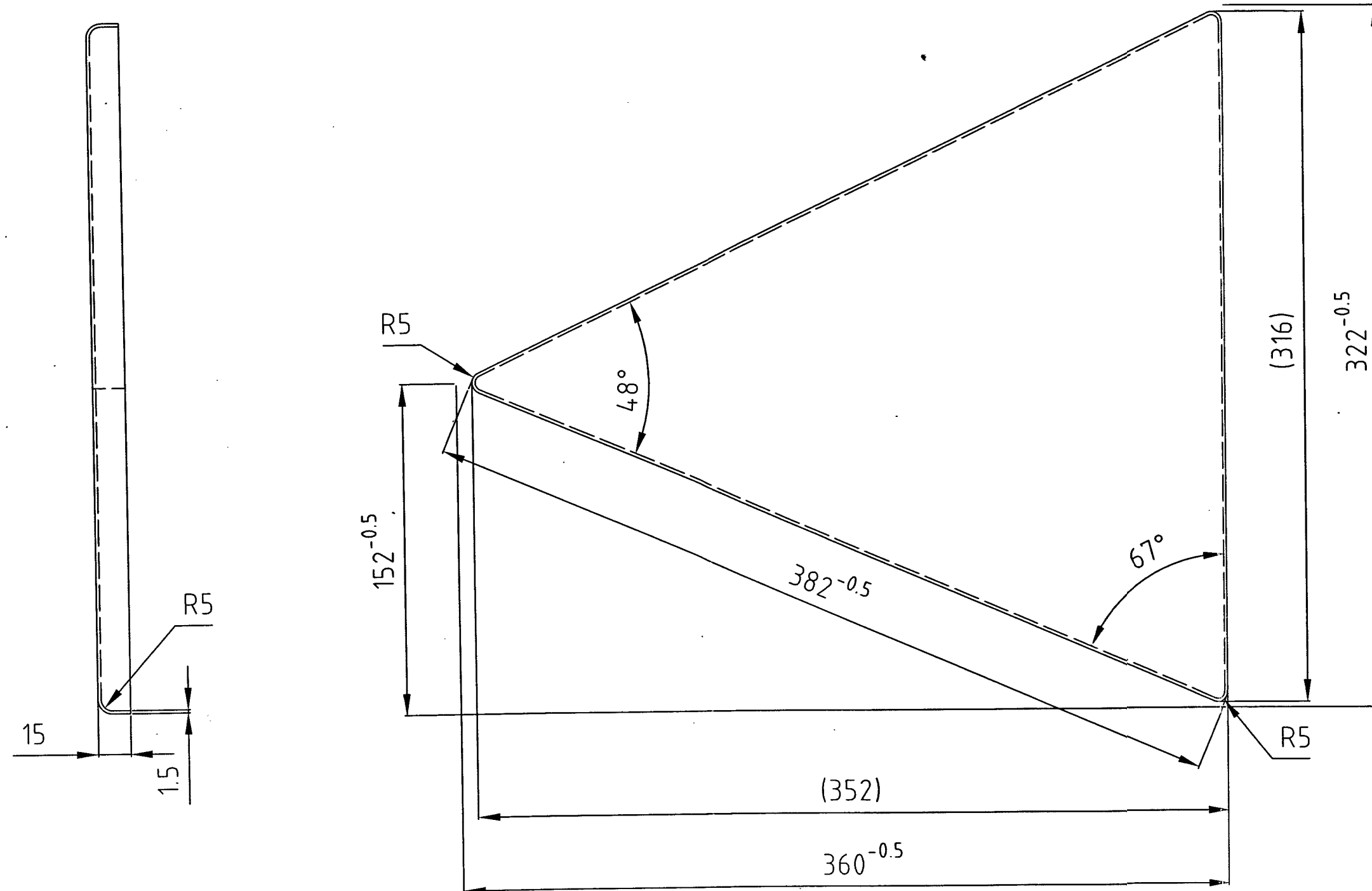
AUTHD.		DRG. NO:	675-WT-SA-003-03
APRD.	NSReddy	TITLE:	SIDE PLATE (RH)
CHKD.	URKRaju	DATE	2009
DRWN	NAME	SIGN	DATE
ORDNANCE FACTORY MEDAK			
MTL: STAINLESS STEEL AISI: 316			
UNSPECIFD. TOLERANCES ARE AS PER IS:2102			
UNLESS SPECIFD, DIMNS. IN MM			
SHEET NO.	WEIGHT	SCALE	NTS
4 OF 5			
			FIRST ANGLE

BASED ON:

USED ON : 675-WT-SA-003

✓(✓)

ISSUE	APPRD.	NATURE OF AMENDMENT



Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911
3. Thickness 1.5mm.
4. It is allowed to cut and weld at corners of flange.

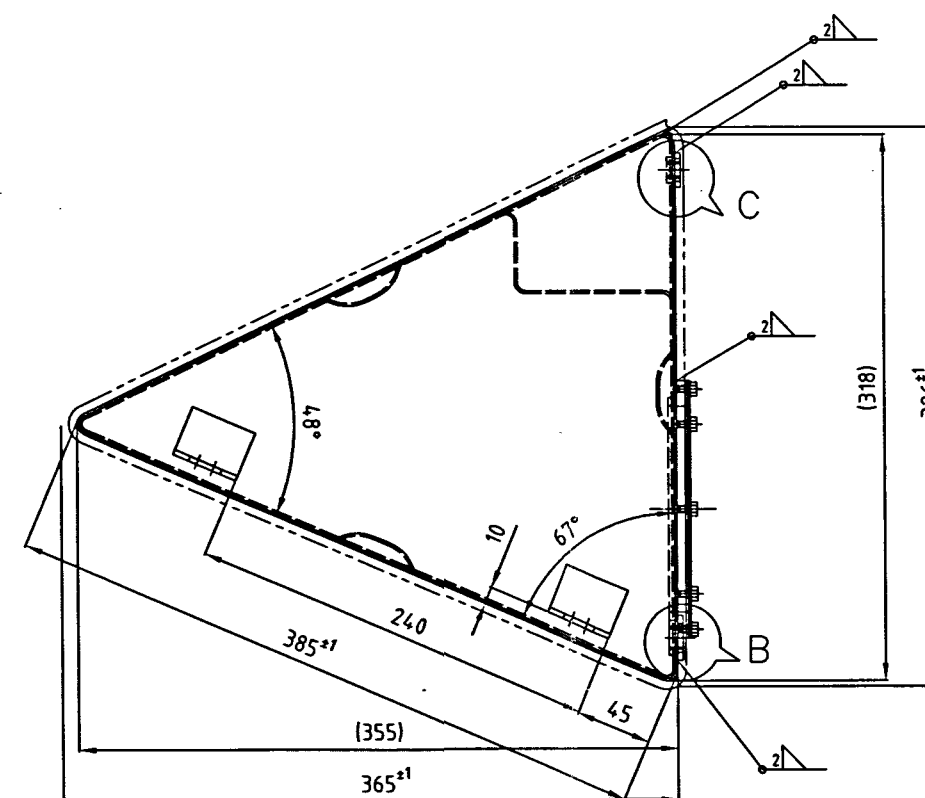
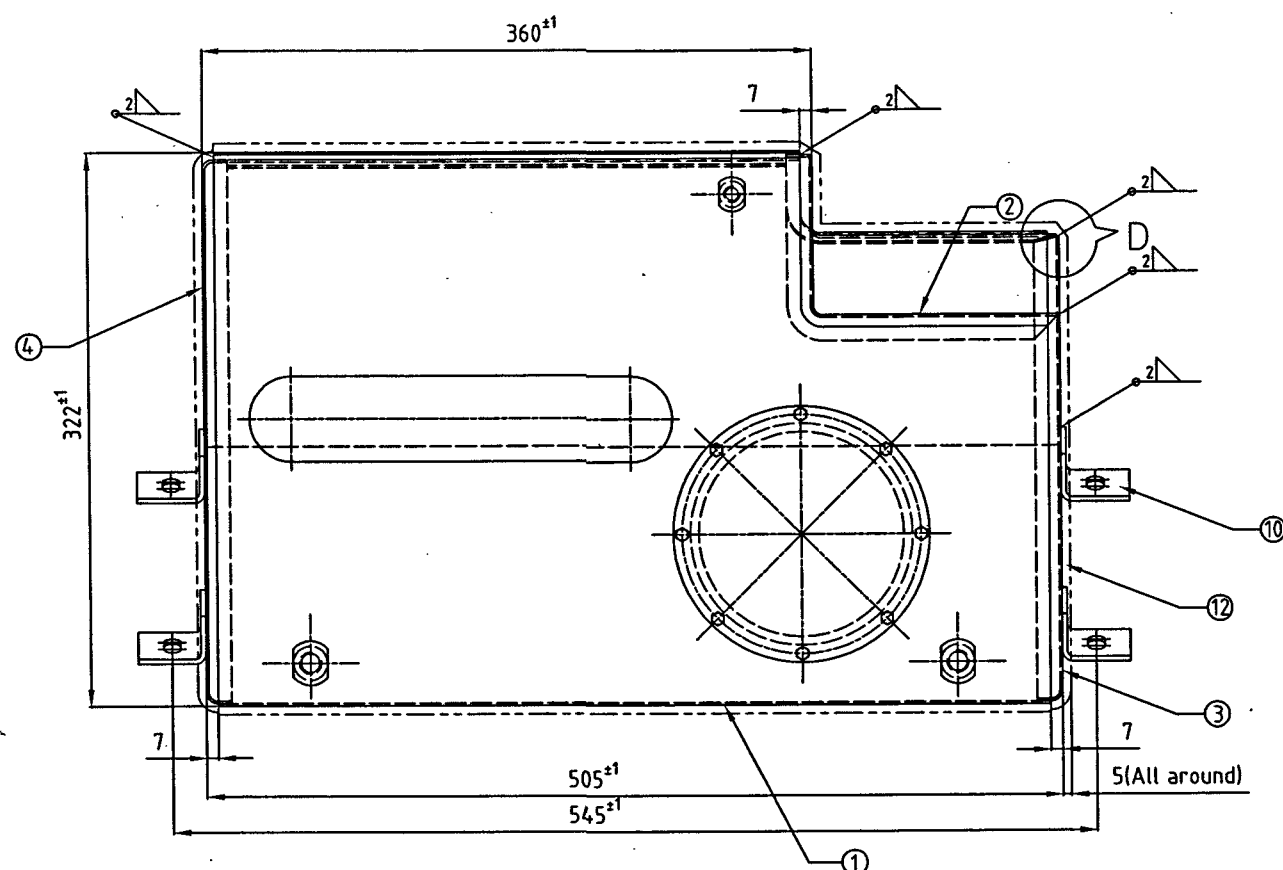
AUTHD.		DRG.NO:	675-WT-SA-003-04	UNSPECIFD. TOLERANCES ARE AS PER IS:2102
APRD.	NSReddy	CHKD.	URKRaju	UNLESS SPECIFD, DIMNS.IN MM
DRWN	URKRaju	DATE	24/8/2009	SHEET NO. 5 OF 5
2009	NAME	SIGN	DATE	SCALE NTS
ORDNANCE FACTORY MEDAK			MT: STAINLESS STEEL AISI: 316	FIRST ANGLE

USED 675-WT-SA-000

(A) Note8: S.S. Tank with 5mm Fibre Reinforced Plastic Pasting.

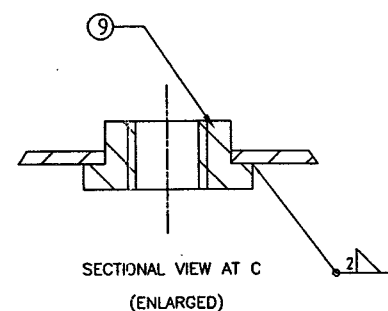
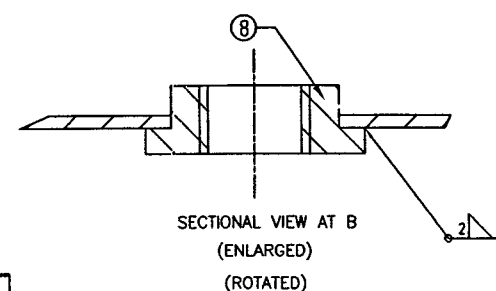
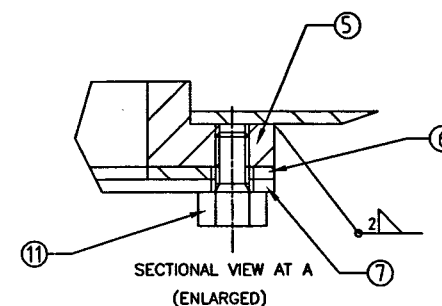
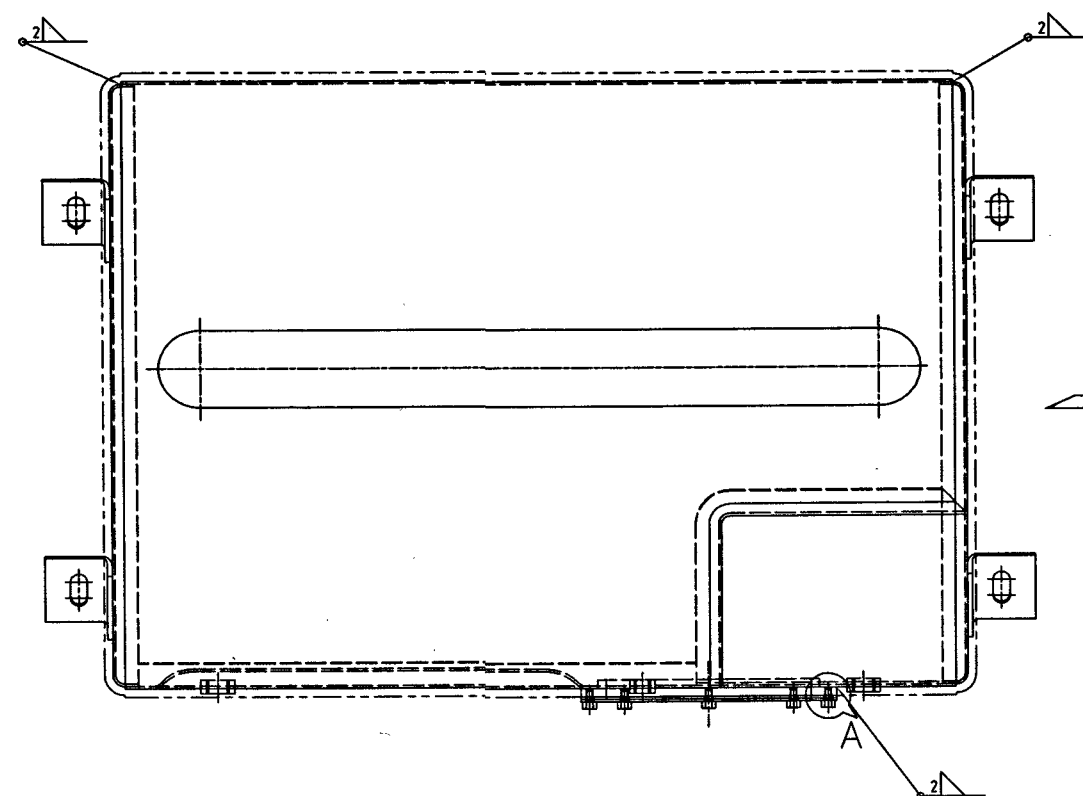
✓(✓)

ISSUE	APPRD.	NATURE OF AMENDMENT
A	30/09/19	Note no.8 added



Note :

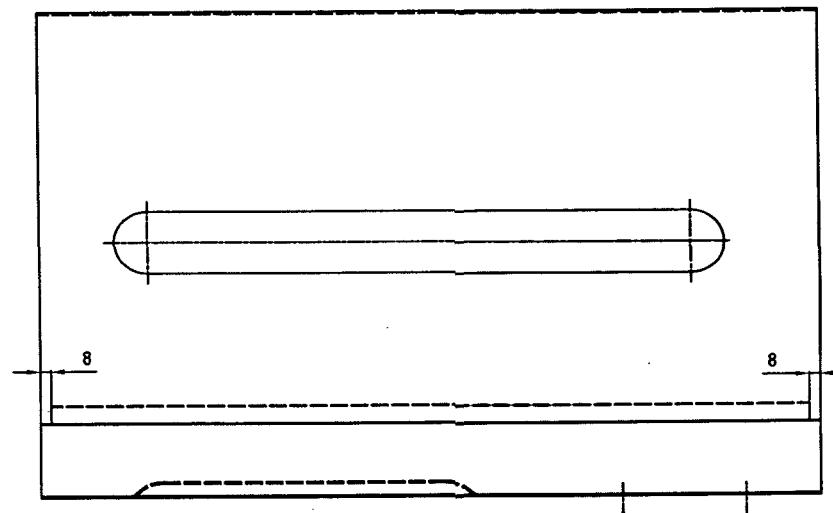
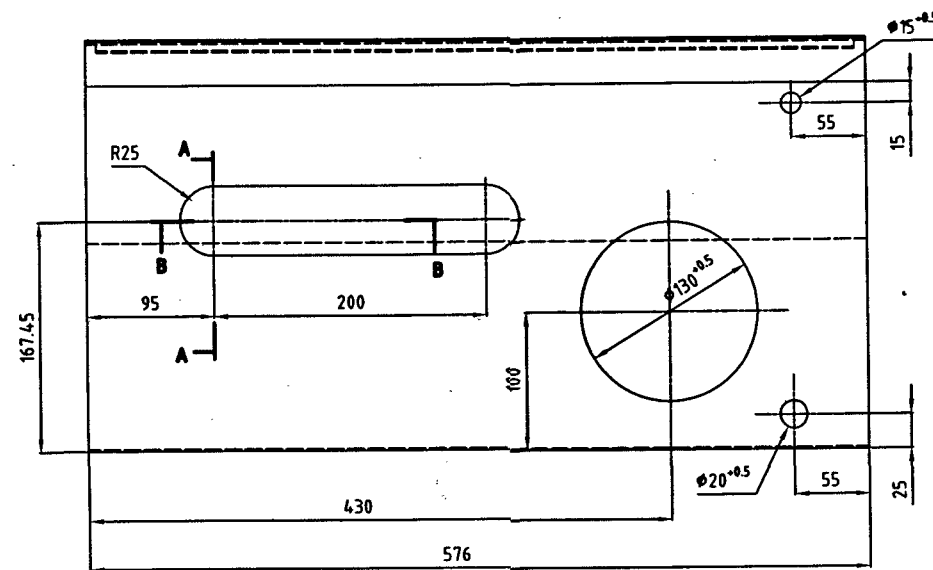
1. Drawing is provisional.
2. All joints are to be full weld with TIG Stainless Steel welding to IS : 2811 – 92.
3. Confirming leak test to be conducted before FRP mould.
4. Unspecified tolerance on threads as per IS : 4218.
5. FRP to be moulded all around the tank by relieving openings.
6. Red Oxide primer colour shade ISC No. 446 to IS 2074–92.
7. Olive Green paint Shade 294, IS : b 8982–91.



12	675-WT-SA-003-05	FRP BISPHENOL RESIN	1	THICKNESS 5 mm
11	675-WT-SA-002-13	HEX. SCREW MEXIDIS : 1367-98	8	S.S, AISI 316
10	675-WT-SA-002-12	CLAMP PIECE	4	S.S, AISI 316
9	675-WT-SA-002-10	BREATHER BUSH	1	S.S, AISI 316
8	675-WT-SA-002-09	INLET & DRAIN BUSH	2	S.S, AISI 316
7	675-WT-SA-002-08	COVER PLATE	1	S.S, AISI 316
6	675-WT-SA-002-07	SEALING RUBBER	1	QAI/RUBBER/ CQA(ICV)/005
5	675-WT-SA-002-06	BUSH	1	S.S, AISI 316
4	675-WT-SA-003-04	SIDE PLATE (LH)	1	S.S, AISI 316
3	675-WT-SA-003-03	SIDE PLATE (RH)	1	S.S, AISI 316
2	675-WT-SA-003-02	CORNER PLATE	1	S.S, AISI 316
1	675-WT-SA-003-01	MAIN BODY	1	S.S, AISI 316
REF.NO.	DRAWING NO.	DESCRIPTION.	QTY.	REMARKS
AUTHD.	APRD.	CHKD.	DRWN.	2009
ORDNANCE FACTORY MEDAK		FRONT WATER TANK (RH)		
MIL:		ASSEMBLY DRG.		
UNSPECIFD. TOLERANCES ARE AS PER IS:2102		UNLESS SPECIFD, DIMNS IN M		
SHEET NO.		WEIGHT		SCAL
1 OF 5				NTS
				
				FIRS ANG

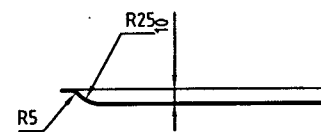
USED ON: 675-WT-SA-004

ISSUE	APPRD.	NATURE OF AMENDMENT

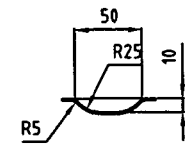
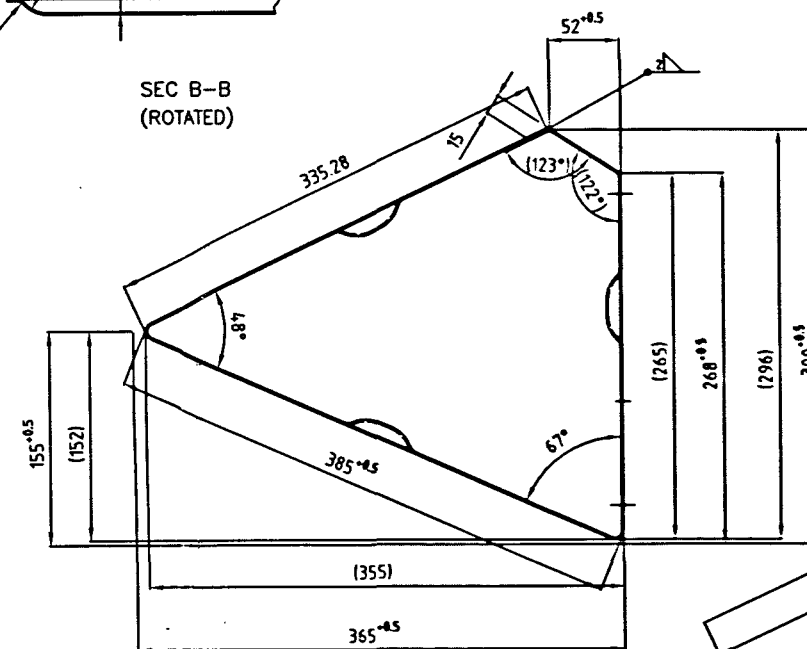


Note :

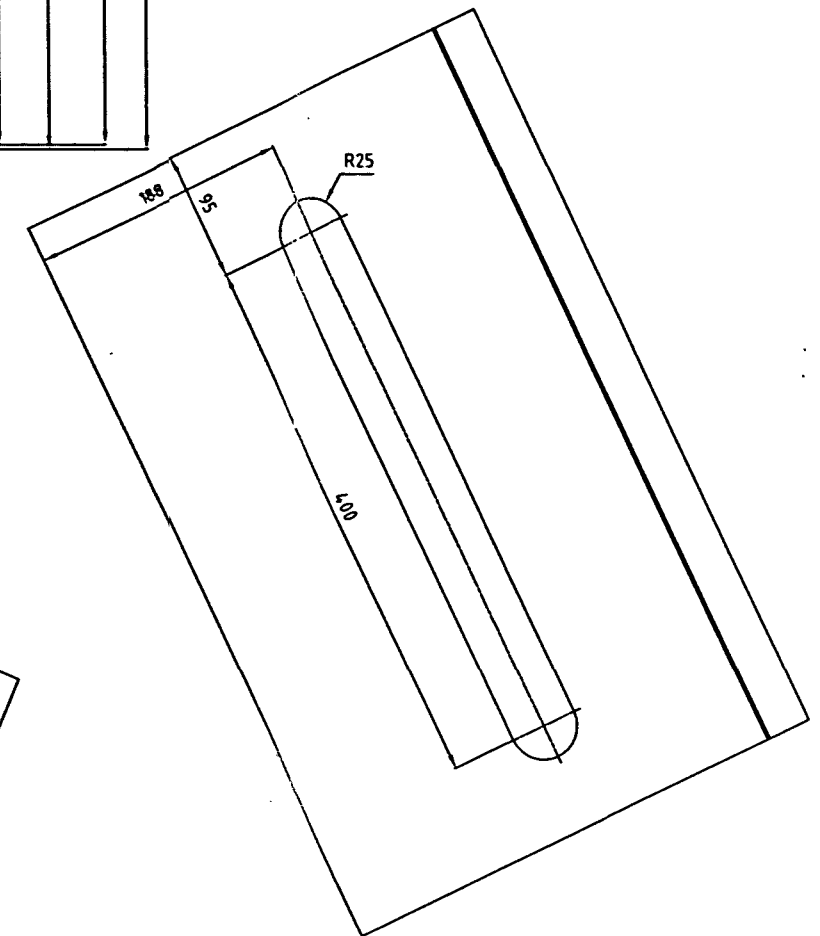
1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911
3. Thicknes 1.5mm



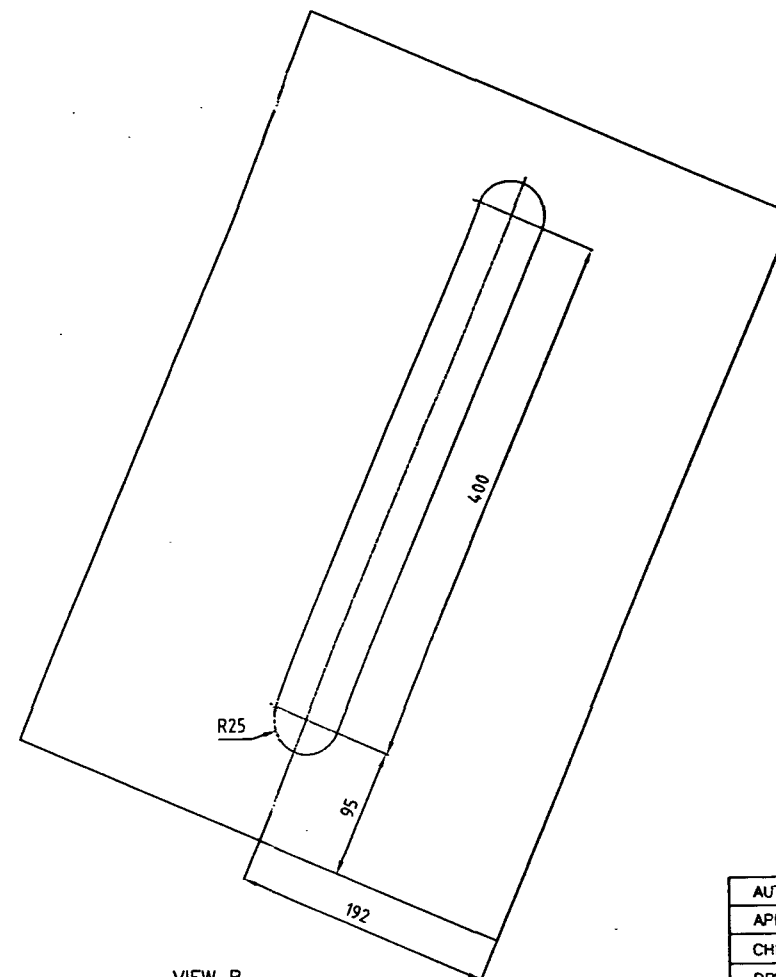
SEC B-B
(ROTATED)



SEC A-A
(ROTATED)



VIEW A
(TRUE)



VIEW B
(TRUE)

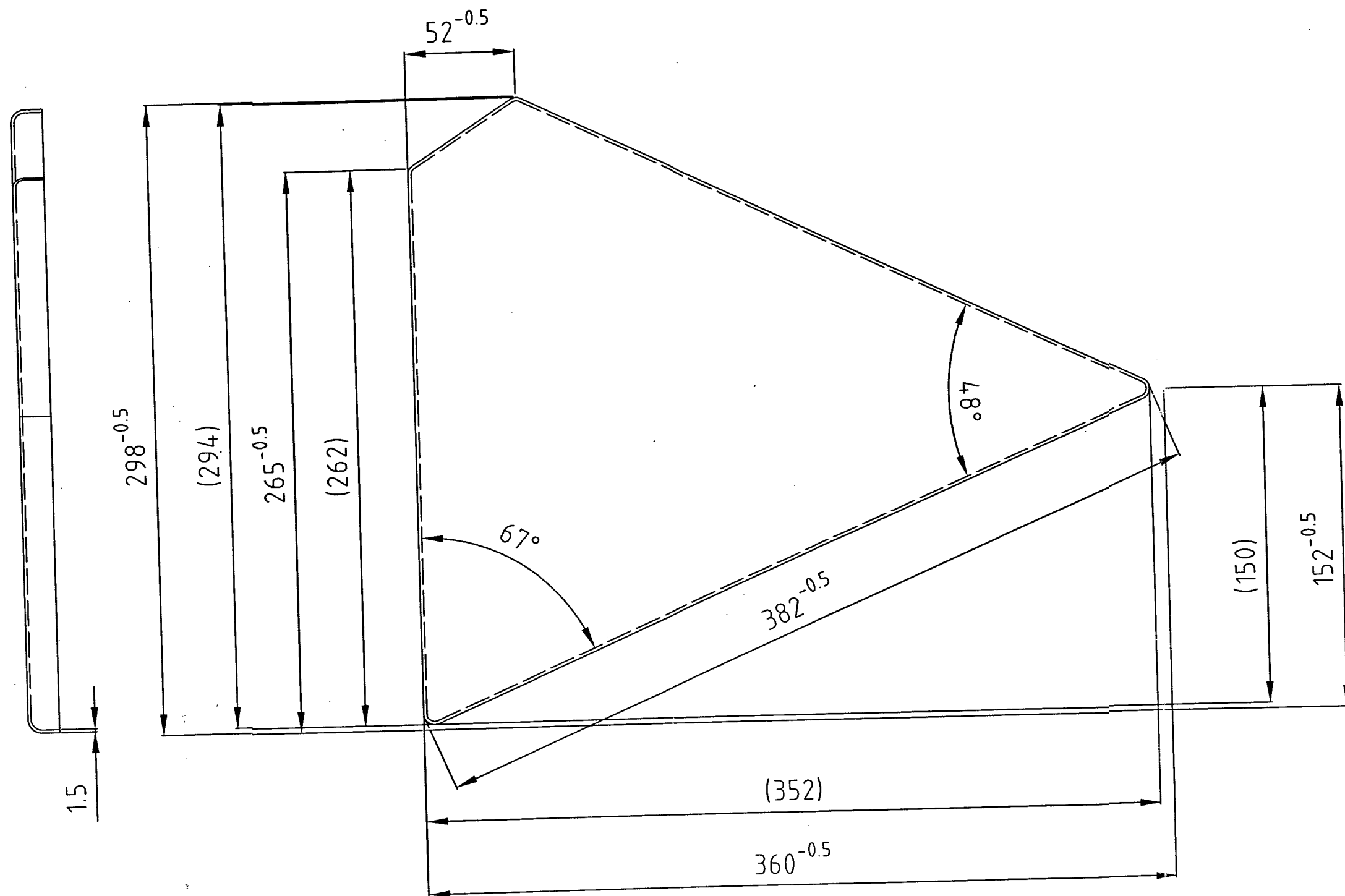
AUTHD.				URG.NO:	675-WT-SA-004-01	UNSPECIFD. TOLERANCES ARE AS PER IS:2102		
APRD.	PRD	97	30/8/83	TITLE:	MAIN BODY	UNLESS SPECIFD, DIMS.IN MM		
CHKD.	NSRReddy	12	30/8/83			SHEET NO.	WEIGHT	SCALE
DRWN	URKRaju	(WR)	24/8/83			2 OF 4		NTS
2009	NAME	SGN	DATE					FIRST ANGLE
ORDNANCE FACTORY MEDAK				MTL:	STAINLESS STEEL AISI: 316			

BASED ON:

USED ON : 675-WT-SA-004

✓(✓)

ISSUE	APPRD.	NATURE OF AMENDMENT



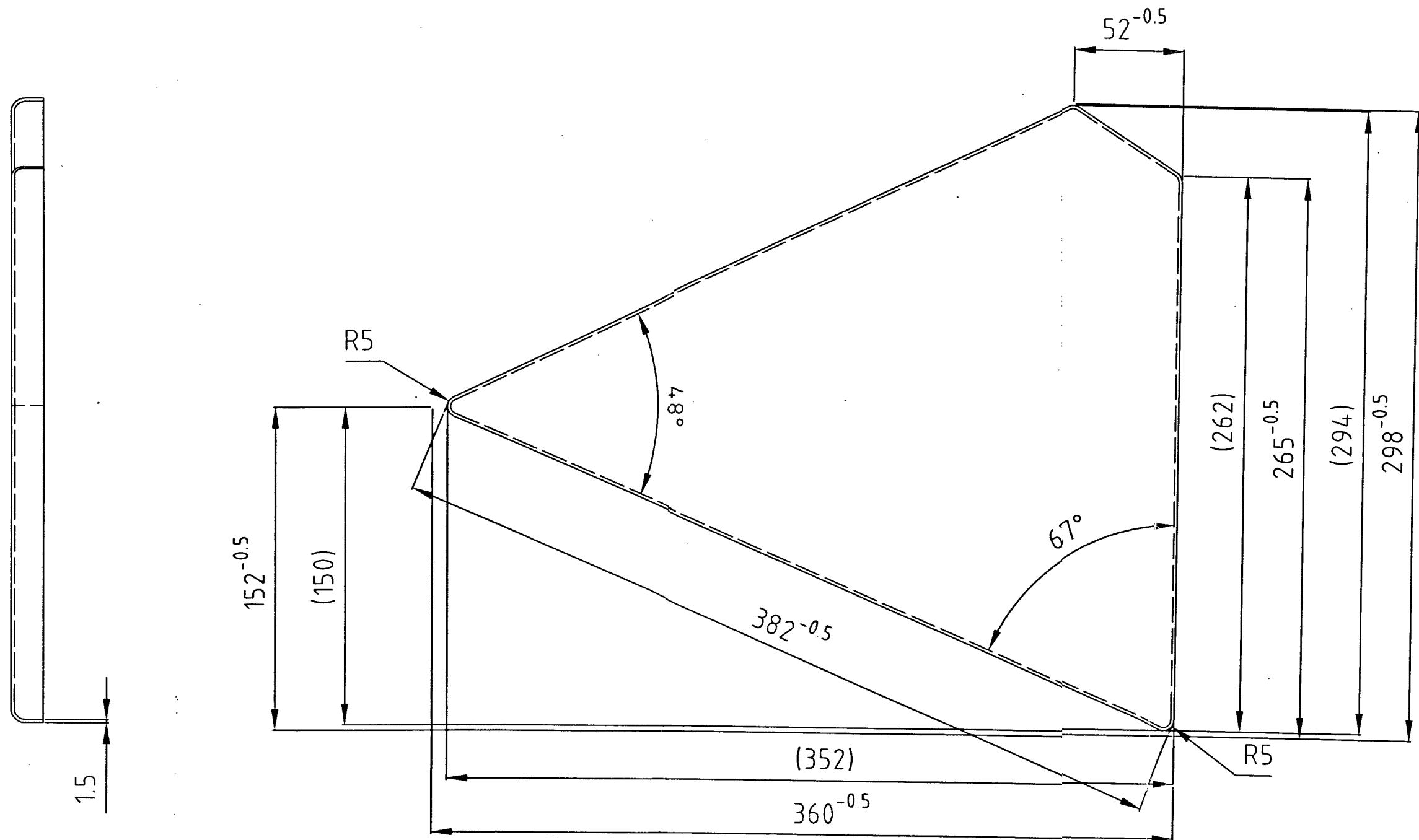
Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911
3. Thickness 1.5mm.
4. It is allowed to cut and weld at corners of flange.

AUTHD.		DRG.NO:	675-WT-SA-004-02	UNSPECIFD. TOLERANCES ARE AS PER IS:2102		
APRD.	NSReddy	CHKD.	URKRaju	UNLESS SPECIFD, DIMNS.IN MM		
DRWN	2009	NAME	SIGN	DATE	SHEET NO.	WEIGHT
					3 OF 4	SCALE
ORDNANCE FACTORY MEDAK				MTL:	STAINLESS STEEL AISI: 316	FIRST ANGLE

BASED ON:
USED ON : 675-WT-SA-004

ISSUE	APPRD.	NATURE OF AMENDMENT



Note :

1. Drawing is provisional.
2. Alternate Material X04Cr17Ni12M02 IS : 6911
3. Thickness 1.5mm.
4. It is allowed to cut and weld at corners of flange.

AUTHD.	APRD.	CHKD.	DRWN	2009	NAME	SIGN	DATE	ORG. NO:	675-WT-SA-004-03	TITLE:	SIDE-PLATE (LH)	UNSPECIFD. TOLERANCES ARE AS PER IS:2102
		NSReddy	URKRaju									UNLESS SPECIFD. DIMNS. IN MM
												SHEET NO.
												4 OF 4
												WEIGHT
												SCALE
												NTS
												FIRST ANGLE

ORDNANCE FACTORY
MEDAK

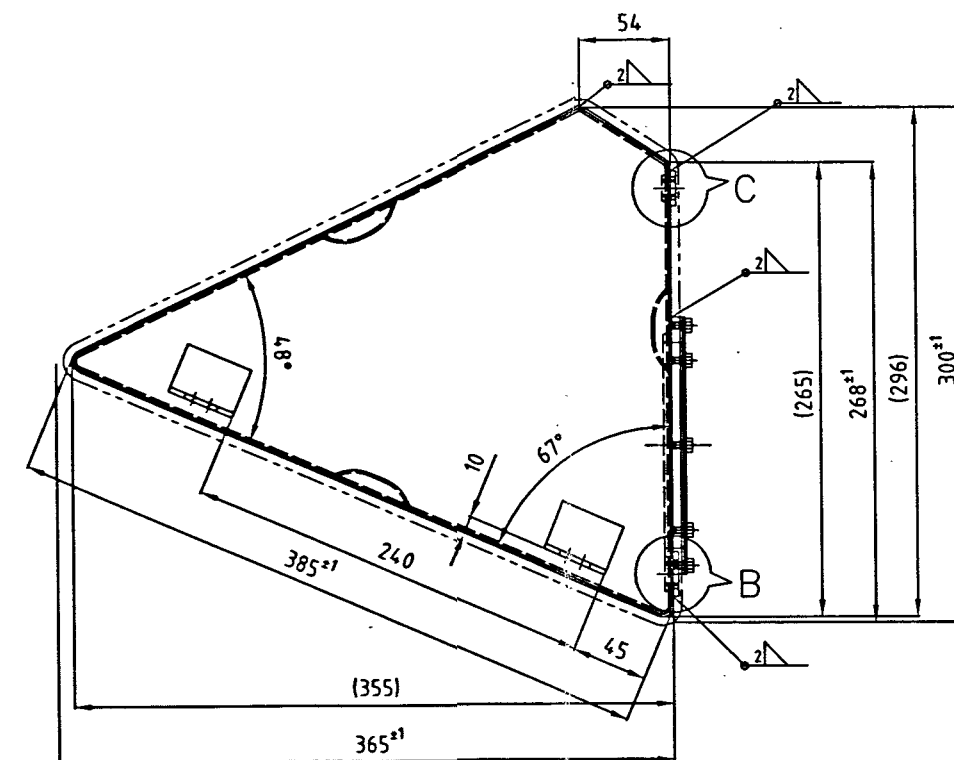
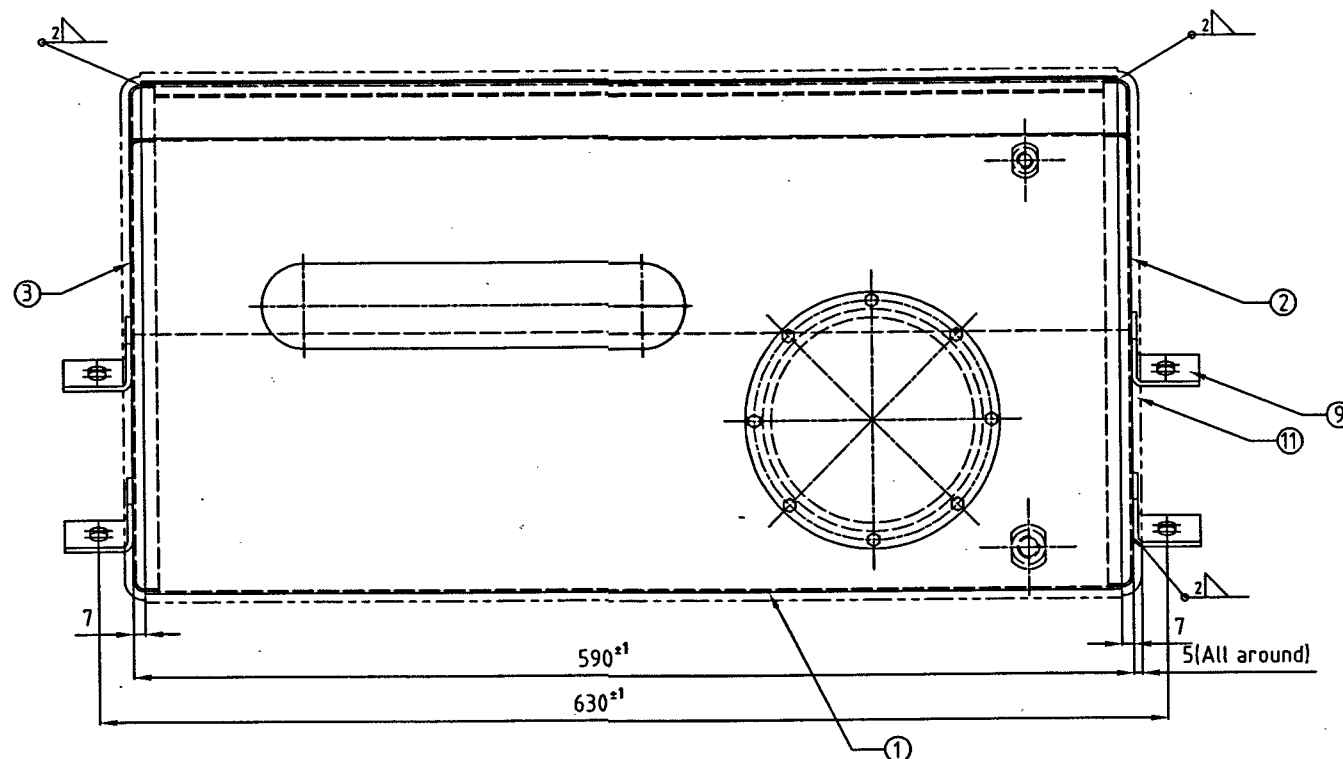
MTL: STAINLESS STEEL AISI: 316

BASED ON:

USED 675-WT-SA-000

✓(✓)

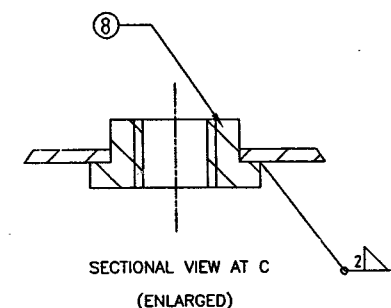
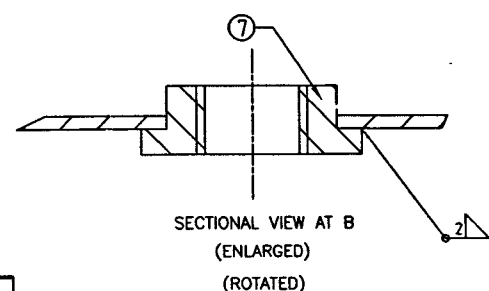
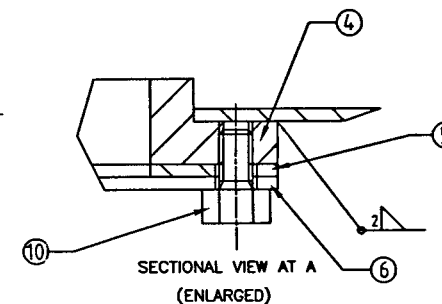
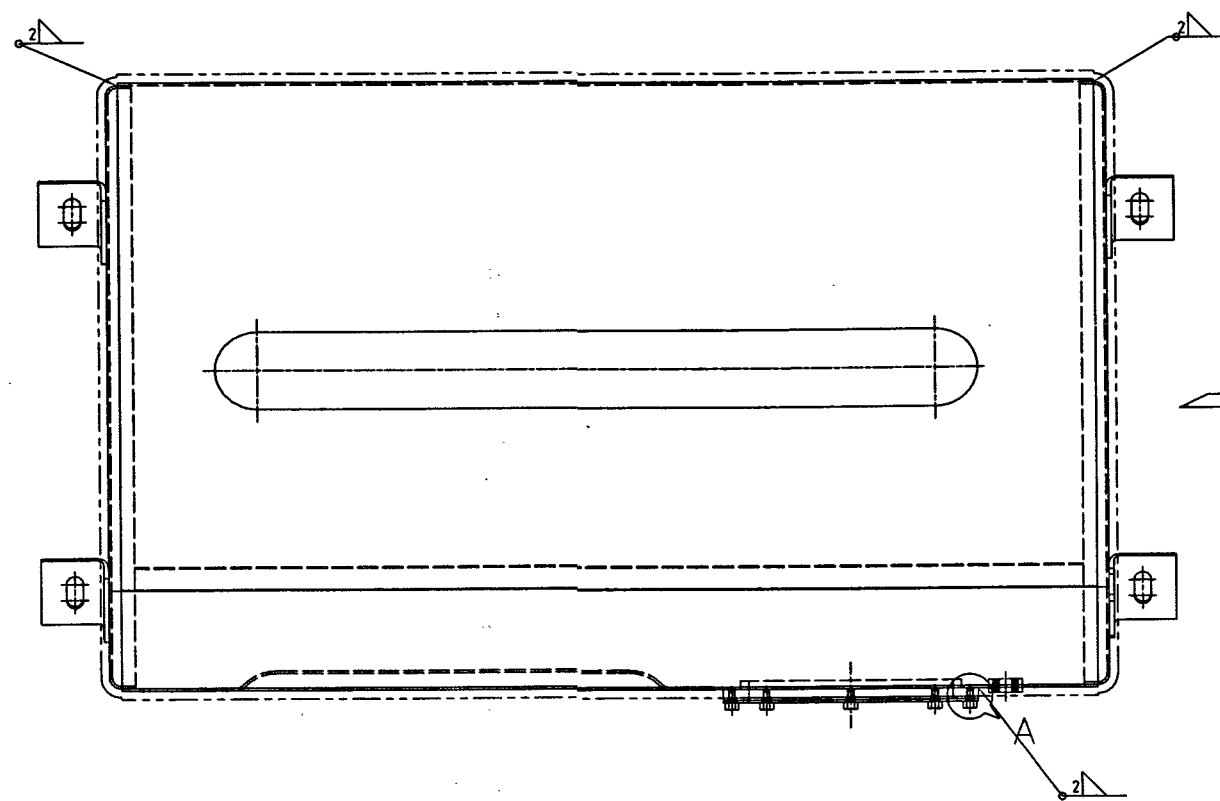
ISSUE	APPRD.	NATURE OF AMENDMENT
(A)	30/09/19	Note No.8 Added.



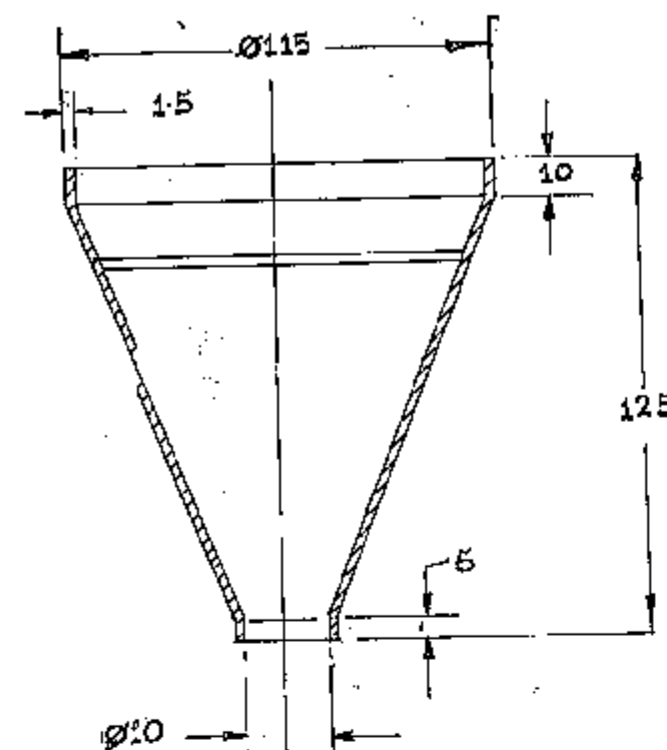
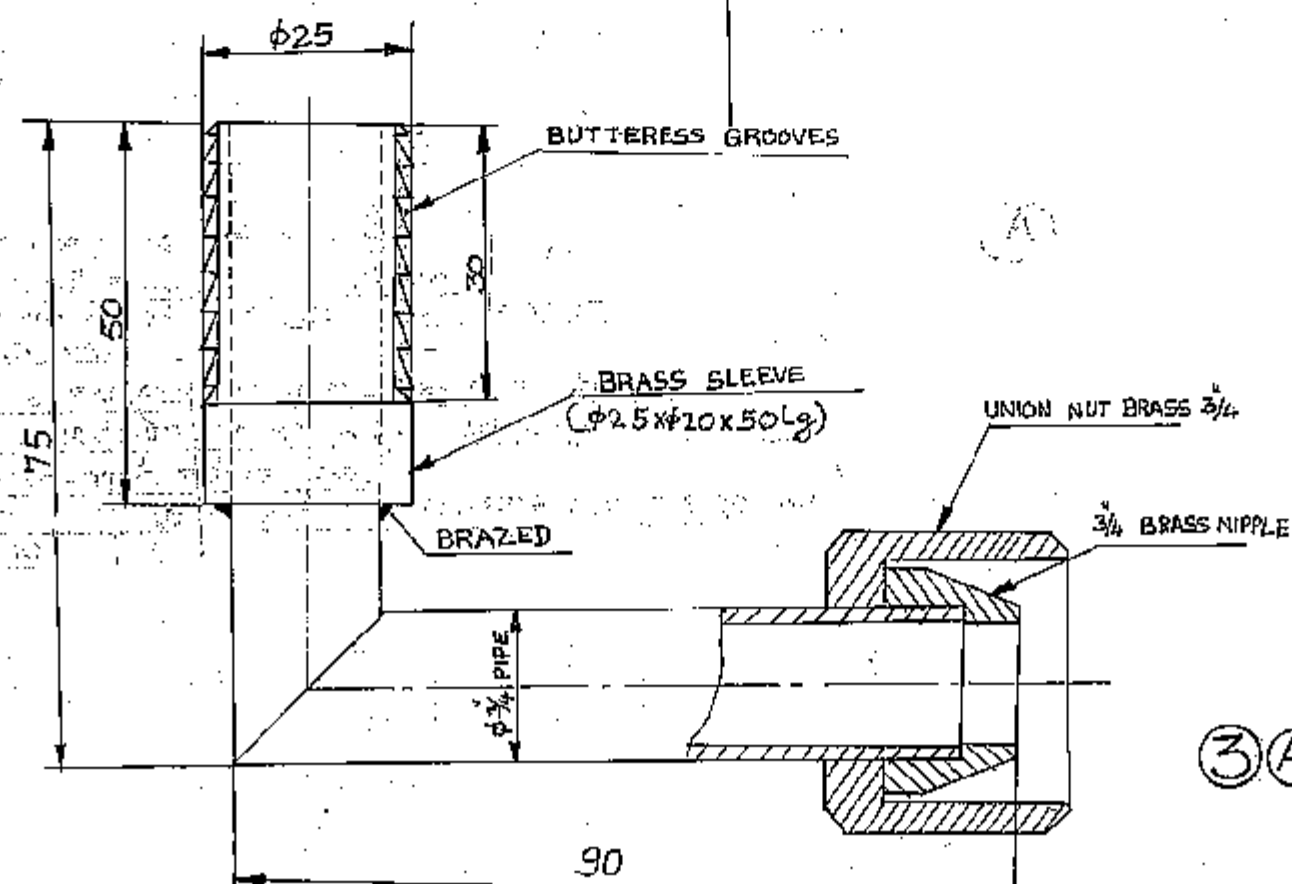
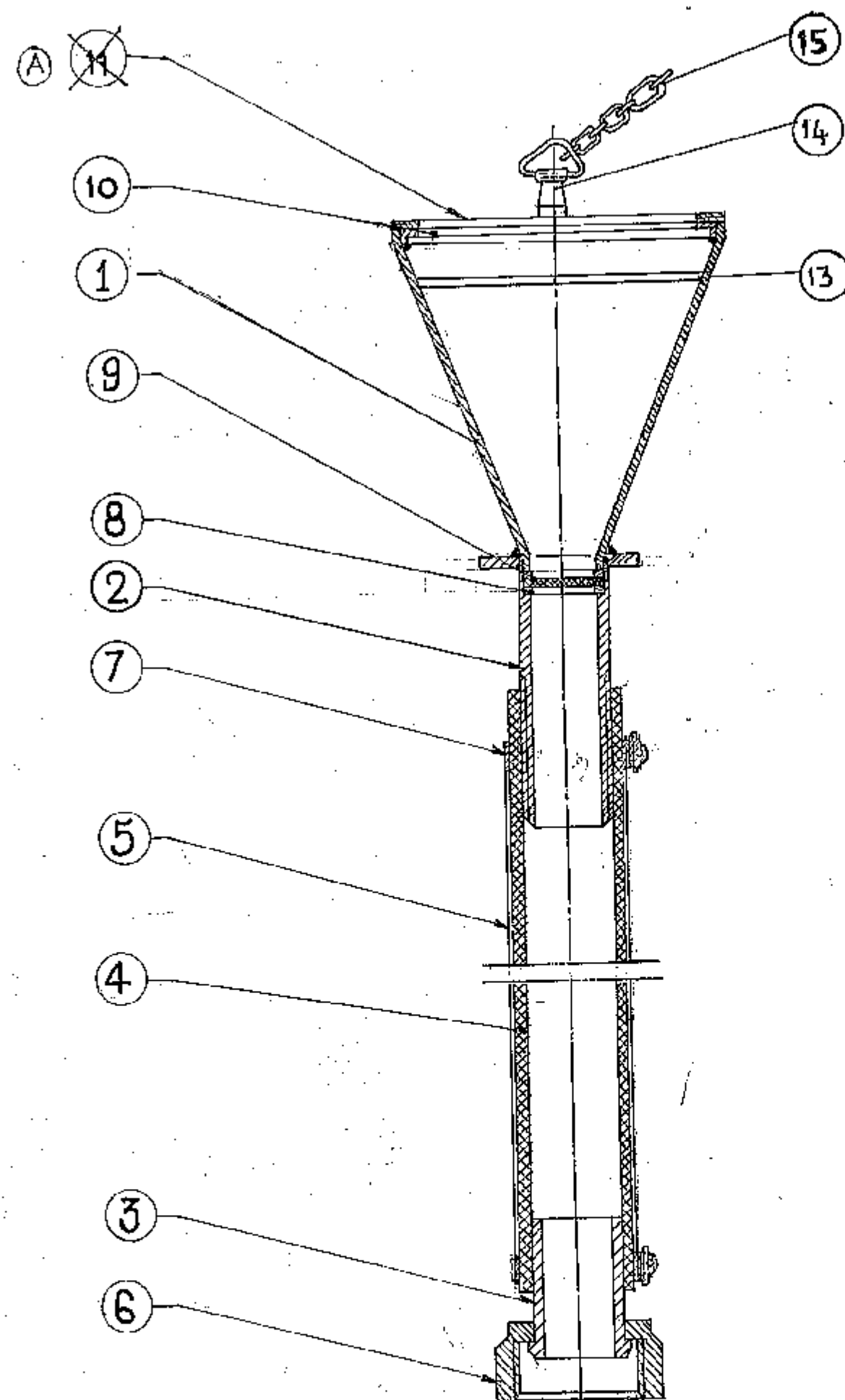
Note :

1. Drawing is provisional.
2. All joints are to be full weld with TIG Stainless Steel welding to IS : 2811 - 92.
3. Confirming leak test to be conducted before FRP mould.
4. Unspecified tolerance on threads as per IS : 4218.
5. FRP to be moulded all around the tank by relieving openings.
6. Red Oxide primer colour shade ISC No. 446 to IS 2074-92.
7. Olive Green paint Shade 294, IS : b 8982-91.

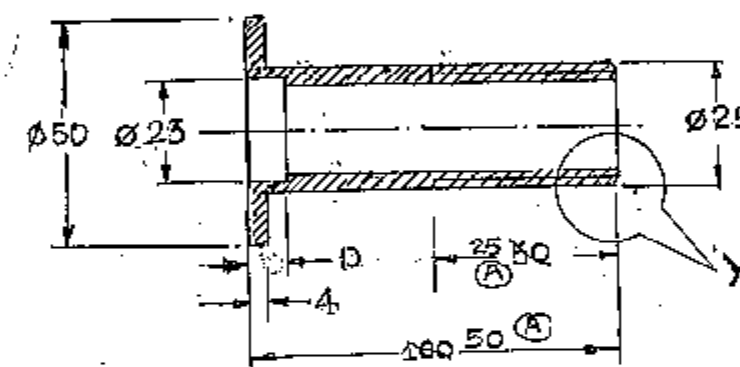
(A) 8. S.S. Tank with 5mm Fibre Reinforced Plastic Pasting.



11	675-WT-SA-004-04	FRP BISPHENOL RESIN	1	THICKNESS 5 mm
10	675-WT-SA-002-13	HEX. SCREW M5x10 IS : 1367-98	8	S.S. AISI 316
9	675-WT-SA-002-12	CLAMP PIECE	4	S.S. AISI 316
8	675-WT-SA-002-10	BREATHING BUSH	1	S.S. AISI 316
7	675-WT-SA-002-09	INLET & DRAIN BUSH	1	S.S. AISI 316
6	675-WT-SA-002-08	COVER PLATE	1	S.S. AISI 316
5	675-WT-SA-002-07	SEALING RUBBER	1	QAI/RUBBER/COA(ICV)/005
4	675-WT-SA-002-06	BUSH	1	S.S. AISI 316
3	675-WT-SA-004-03	SIDE PLATE (LH)	1	S.S. AISI 316
2	675-WT-SA-004-02	SIDE PLATE (RH)	1	S.S. AISI 316
1	675-WT-SA-004-01	MAIN BODY	1	S.S. AISI 316
REF.NO.	DRAWING NO.	DESCRIPTION.	QTY.	REMARKS
AUTHD.		DRG.NO.		
APRD.	SSM	675-WT-SA-004		UNSPECIFD. TOLERANCES ARE AS PER IS:2102
CHKD.	NSReddy			UNLESS SPECIFD, DIMNS.IN MM
DRWN	URKRaju			SHEET NO. WEIGHT SCALE
2009	NAME SIGN DATE			1 OF 4 NTS
ORDNANCE FACTORY MEDAK		FRONT WATER TANK (LH)		FIRST ANGLE
		ASSEMBLY DRG.		

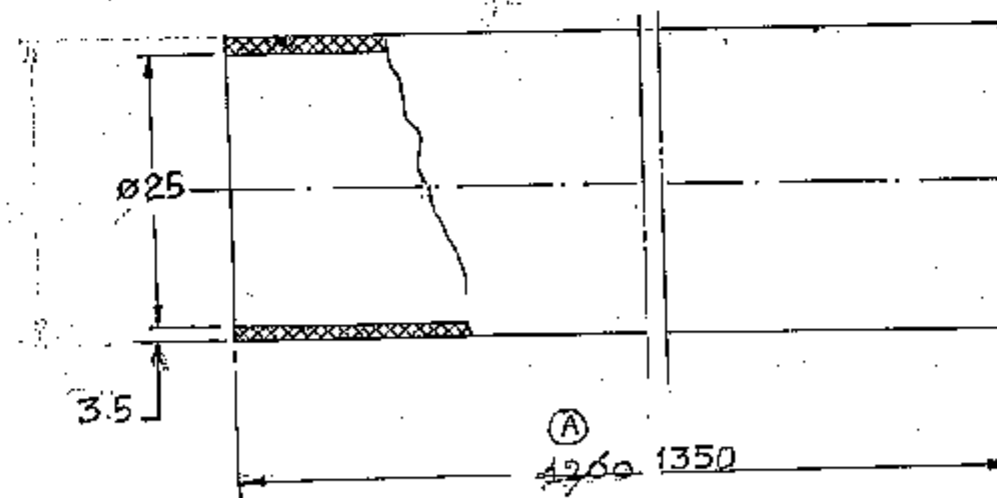


①

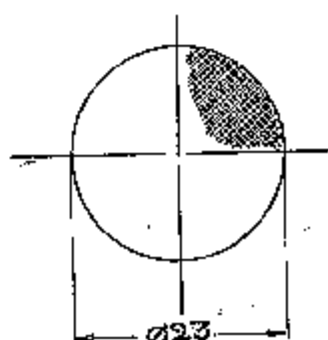
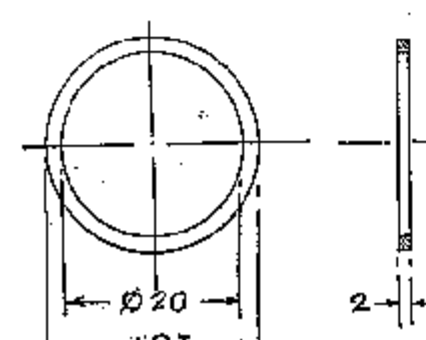


GROOVES
BUTTERESS
ENLARGED VIEW AT 'Y'

②



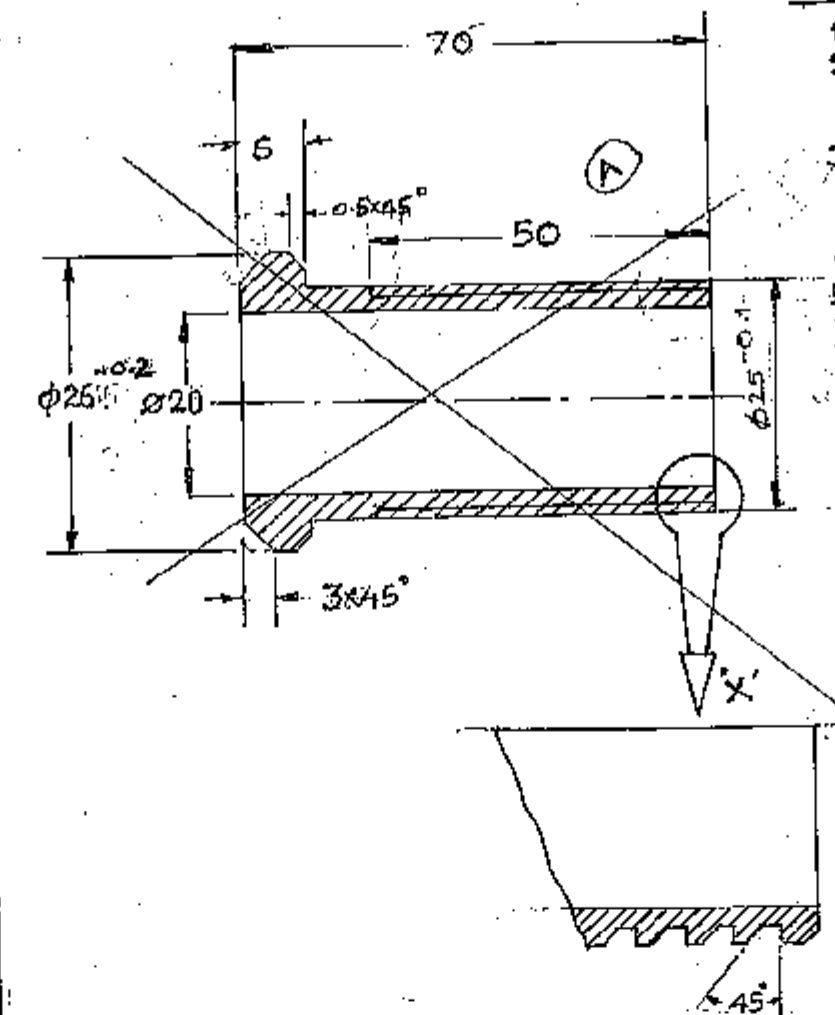
④

②
⑨

③

NOTE

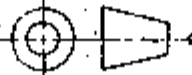
- 1) ALL DIMENSIONS ARE IN M.M.
- 2) THIS IS A PROVISIONAL DRAWING. PRODUCTION HAS NOT BEEN CARRIED OUT TO THIS DRAWING.
- 3) PROTO TYPE SAMPLE SHOULD BE GET APPROVED FROM CSA/ICV BEFORE START OF BULK PRODUCTION.
- 4) AA INDICATES BRAZING.
- 5) ITEM NO. 11 SHALL BE STICKED WITH SUITABLE ADHESIVE TO ITEM NO. 10.



③

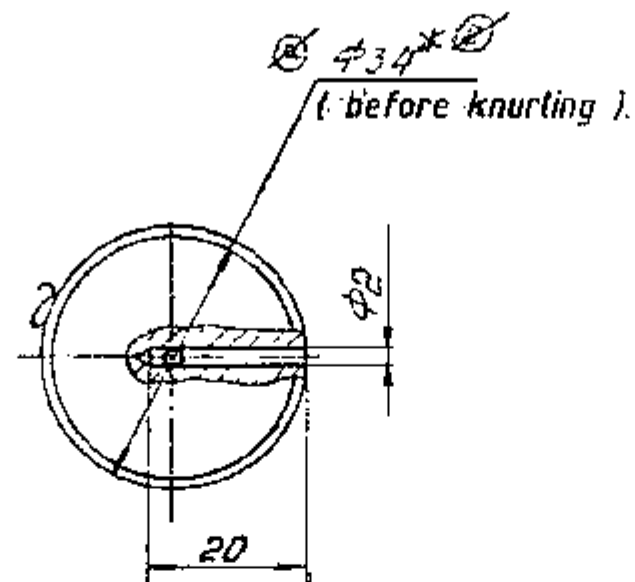
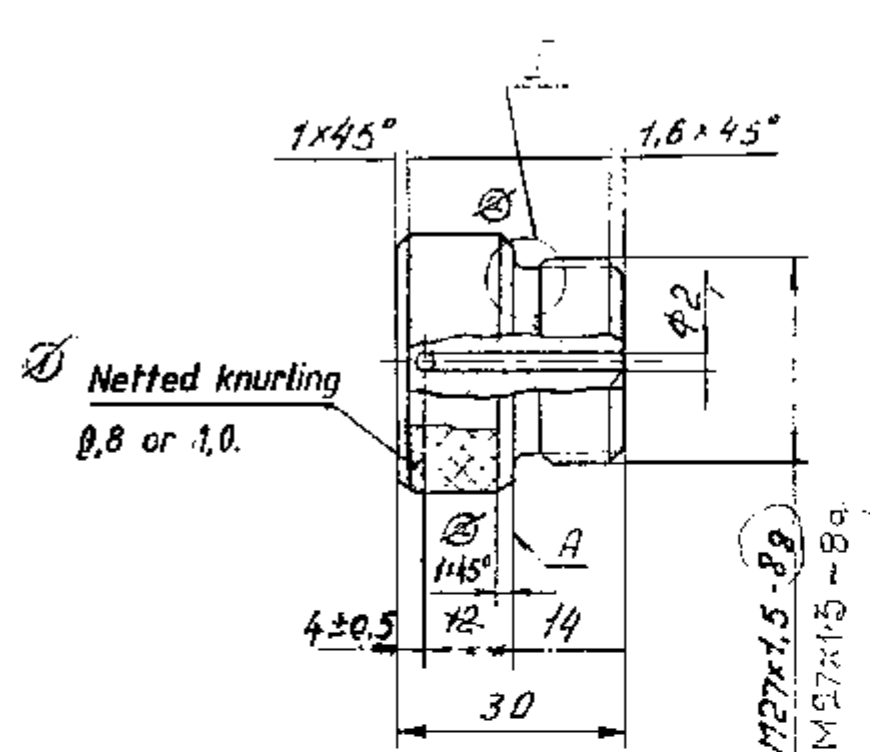
BUTTERESS THREADS ENLARGED VIEW AT 'X'

ITEM No.	MATERIAL	QTY.
1	COLD ROLLED BRASS SHEET GRADE CU ZN 37 TO IS: 410-67 OR CZ 108 TO BS: 2870-68	1
2	ROD BRASS GRADE Cu Zn 42 Pb 2 TO IS: 3488-66	1
3	ROD BRASS GRADE Cu Zn 42 Pb 2 TO IS: 3488-66	1
4	HIGH DENSITY PVC TUBE ID 25 TO IS: 4984-72, L-1400 mm	1
5	FLEXIBLE CONDUIT PIPE ID 35x1000	1
6	UNION NUT BRASS. DRG. No. 675-WT-PD-023	1
7	CLAMP. (HOSE CLAMP) 38-30 TO IS: 4762-68	2
8	WASHER BRASS COLD ROLLED SHEET GDE Cu Zn 37 TO IS: 410-67 OR CZ 108 TO BS 2870-68.	2
9	BRASS WOVEN WIRE CLOTH APERTURE SIZE 2.5x2.5 WIRE DIA 0.5 MM TO IS: 2405-63	1
10	COLD ROLLED BRASS SHEET GDE Cu Zn 37 TO IS: 410-67	1
11	RUBBER No. 3 GDE 'D' TO BS: AU-106-65. (ITEM No. 10 & 11 SEE DRG. No. 675-WT-PD-027)	1
12	BRASS WOVEN WIRE CLOTH APERTURE SIZE 355 MICRON 01	1
13	COLD ROLLED BRASS SHEET GDE CU ZN 37 TO IS: 410-67	1
14	COLD ROLLED BRASS ROD GDE Cu Zn 42 Pb 2 TO IS: 3488-66	1
15	CHAIN (STD - WIDTH 6 mm, LENGTH 500 mm)	1

----- MATERIAL		DCU/No & DATE	ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.		ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED				
SCALE:- 1:1, 2:1		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON:- 675-WT-GA-001
DATE :- 18-5-99				
DRN. <i>[Signature]</i>	WT :- (Kg)	ASSY. FUNNEL		
TCD. <i>[Signature]</i>				
CHD. <i>[Signature]</i>		DRAWING NO		PART NO
APD. <i>[Signature]</i>		675-WT-SA-040		
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) - 50				

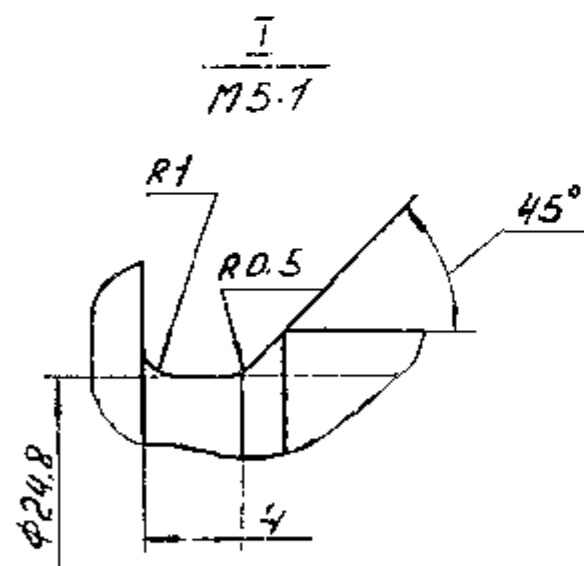
700-37-327

▽4 (▽)



1. Unspecified limit deviations of dimensions are as follows
2. for holes - as per A₇, shafts - as per B₇, other - as per CM₁₀.
2. Non - squareness of surface A with respect to the axis of thread should not exceed 0.15 mm.
3. Coating: oxidizing with ^{oxide}oxidation, chromated or chemically parkerized, blue, chromated.
4. *Dimension is given for reference.

(a) EQUIVALENT INDIAN MATL: AL. ALLOY ROD, DESIG. 24345, CONDITION- 'W' OF IS: 733-1983



D.C:6460-I	14-12-99	EQUIVALENT INDIAN MATERIAL ADDED	
D.C:6123-I	26-7-96	DRAWING SEALED	
ISSUE	DATE	AMENDMENTS	SIGN

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

700-37-327

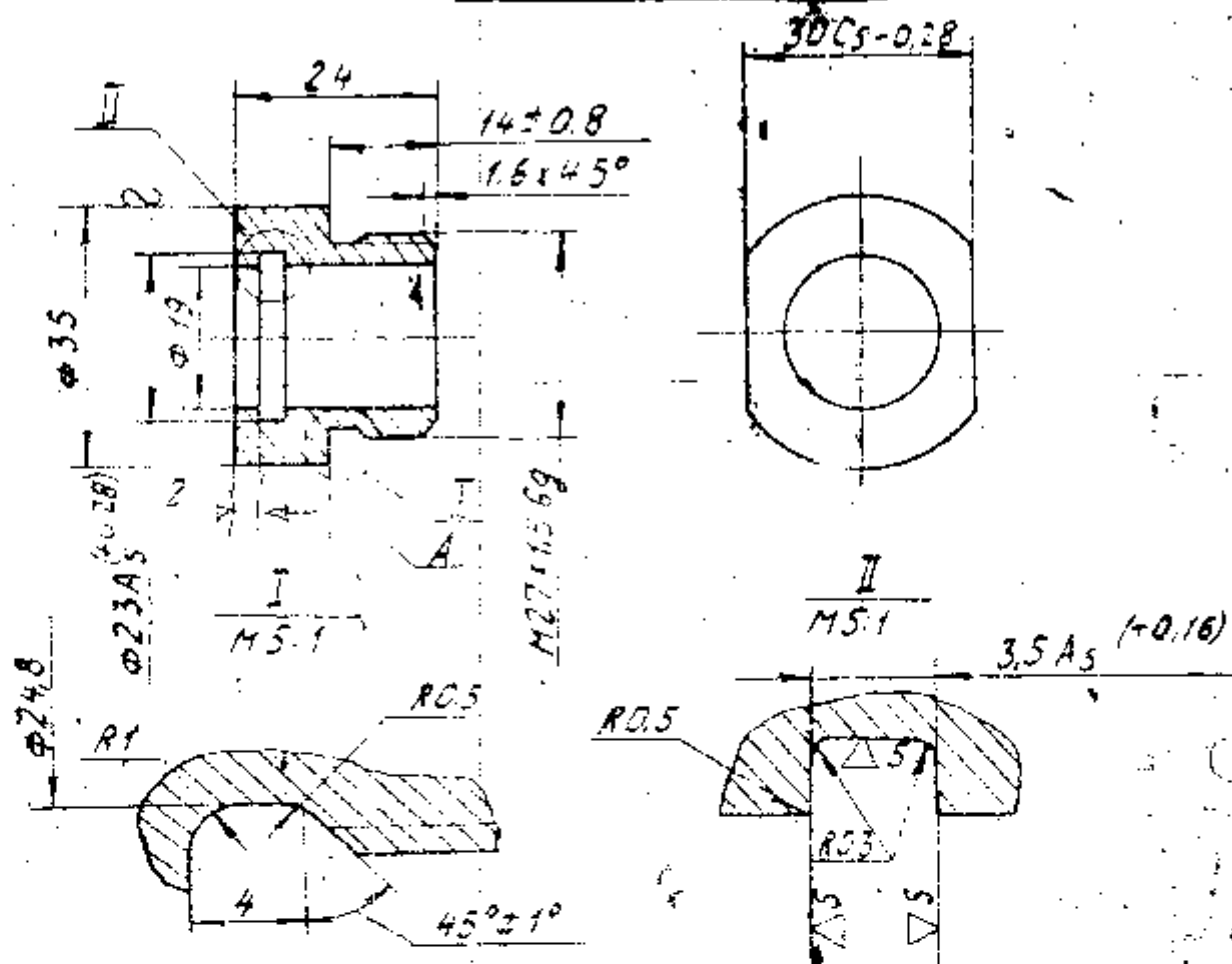
PLUG

Bar A1T Kp 34 II
GOST 21488-76

WRIGHT SCALE

0.018 1:1

SHT 1 SHTS 1



Ⓐ EQ. MATL: AL ALLOY EXTRUDED BAR GRADE 54300 TO IS: 733-83.

1. Coating: anodic oxidation, chromating.
2. Unspecified limit deviations of dimensions are as follows for holes-as per A7, shafts-as per B7.
3. Run-out of surface A with respect to angle diameter of thread should not exceed 0.1mm(qualified tolerance).

00835 REV 11-11-2000	Ⓐ Am	EQ. MATERIAL ADDED.
DCO No. DATE	ISSUE	NATURE OF AMENDMENT

APPROVED	M. VASU	765-08-890			
CHECKED	DSKUMAR	317 of 375			
CONTROLLERATE OF INSPECTION (ICV)		FLANGE		WEIGHT	SCALE
				0.032	1:1
				SHT	SHTS
		BAR AMT 6Kp 35n, ГОСТ 21488-76		08	

FORMAT	ZONE	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
				Technical papers		
2	B		765-08-cb261Cb	Assembly drawing		
				Parts		
64		1	765-08-532	Pipe	1	W/O DRG.
11	B	2	765-08-890	Flange	1	
(B) 11		3	765-33-54 LV2/RCV-5330-021359	RING SEALING TOROIDAL	1	
				Materials		
		4		Bakelite varnish grade 76c-1		
				GOST 901-78		
		5		Primer ϕ 7-03 *		
				GOST 9109-81		
		6		Green enamel n ϕ -223		
				GOST 14923-78		

00428-1CV

Bmt JSD
MAR 24

00224/1CV

JSD
24-02-91

DC(i) NO. DATE

(B)
COM

(A)

ISSUE

PART LIST REF. NO. 3
D.S. CAT. PART NO ADDED
DESCRIPTION WAS SEALING RINGNOMENCLATURE WAS
PACKING RING.

NATURE

AMENDMENTS

APPROVED

CHECKED

CONTROLLERATE
OF
INSPECTION
(REV)

765-08-CE 261

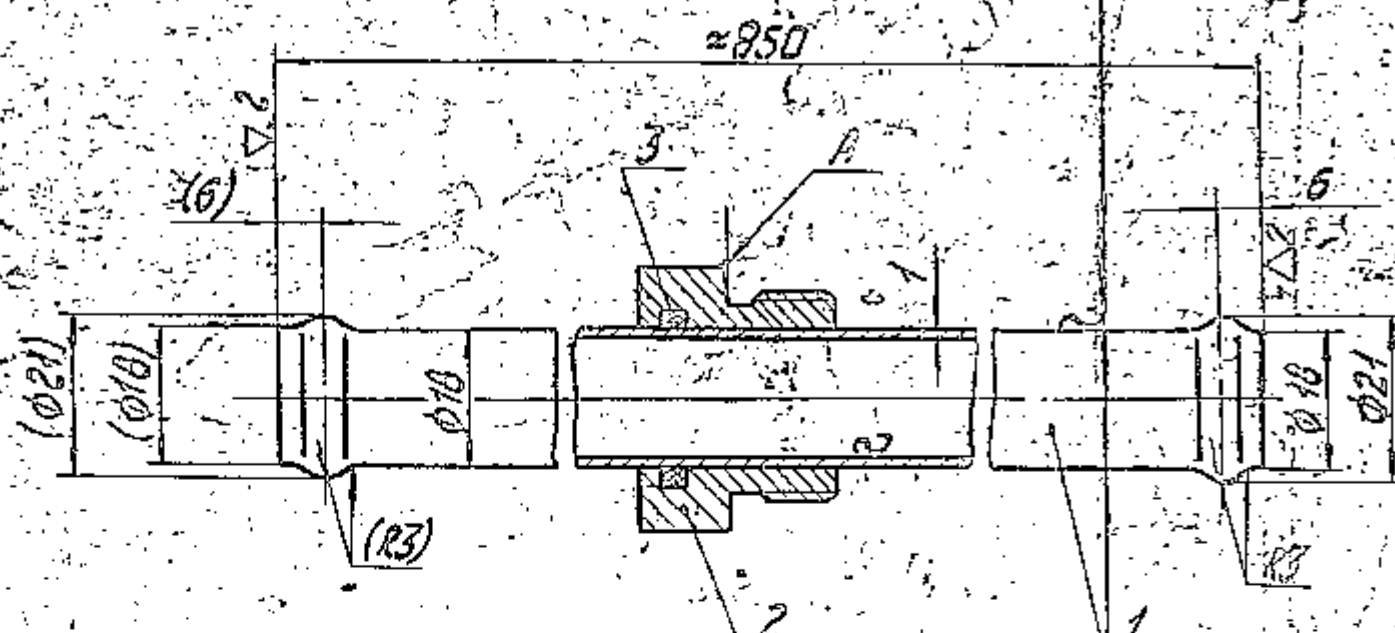
91 OF 374

WEIGHT SCALE

PIPE

SHT SHTS

91/374



4. Form the bead of pipe from side of flange after final coating and assembly with flange and rubber packing. Bead forming may damage bakelite layer.
5. Test for air tightness in water bath under pressure of 2.5 kgf/cm² for 0.5 minutes.

Air leakage is not allowed. Back-up welding followed by test is allowed.

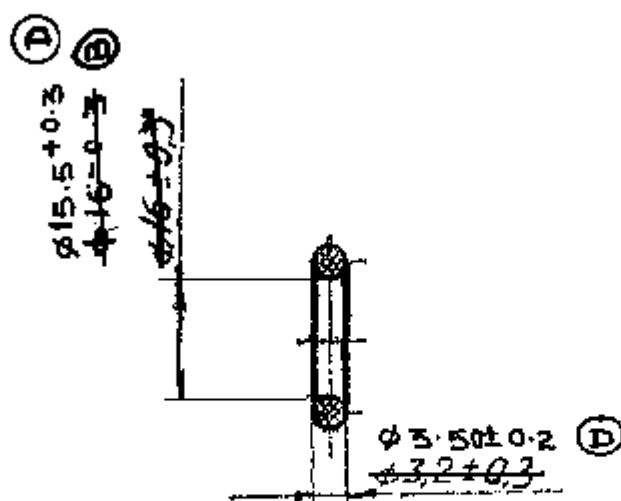
(A) AL. ALLOY EXTRUDED ROUND TUBE GRADE 54300 TO IS:128575

- (A) Pipe Ref.No.1 should be made of round pipe 18xAMr5M GOST 18475-73; weight should be 0.145 kg.
Manufacture of pipe is allowed from round pipe 10x1 AMUM or AMr6M GOST 18475-73, OR
In this case.
 - a) Ovality and corrugations not exceeding 2 mm are allowed at places of bends.
 - b) Bending is allowed. Make dimensions more precise as per standard made in situ.
 - c) Unspecified limit deviations of dimensions are ± 0.5 mm.
 - d) Dimensions given in brackets are after installation of part Ref.No.2,
 - e) Ovality should not exceed 1 mm over length of 40 mm from the expanded edges.
 - f) Coating: Anodically-oxidised, oiled or chemically-parkerised, Light blue, for external surface.
2. Coat internal surface with bakelite varnish, Ref.No.4.
3. Apply primer Ref.No.5 on the external surfaces except thread and surface A and paint with enamel, Ref, No.6.

00 814 -ICK	(A)	EQ. MATERIAL ADDED.
01-10-2000	As per	
DC(L) No. DATE	ISSUE	NATURE OF AMENDMENTS.

APPROVED	765-08-CD 261CB	92 of 974
CHECKED		
CONTROLLERATE OF INSPECTION (ICV)	PIPE (ASSY. DRG.)	WEIGHT SCALE 0.177 1:1 SHT SHTS

765-33-54



(C) EQ. MATL:- NITRILE RUBBER GRADE BA-40 TBS: 2751-82.

1. Apply mark on tag.
2. Flash upto 0,3 mm along the die line is allowed.
3. Other requirements are as per Technical Specification.
Ty 005216-75 for articles, code 25311H7.

00837 -ICV N.H. 12-2000	(C)	EQ. MATERIAL ADDED.
00763 -ICV v. Rana 24-02-2000	(B)	$\phi 16 \pm 0.3$ WAS $\phi 16 \pm 0.3$
00428 -ICV Brij MAR 94	(A)	DS. CAT PART NO. ADDED DESCRIPTION WAS "SEALING "RING"
00970 -ICV K. K. 01-01-2000	(D)	1. THICKNESS OF THE RING - $\phi 3.5 \pm 0.2$ WAS $\phi 3.2 \pm 0.3$ 2. INNER DIA 15.50 ± 0.2 mm WAS $\phi 16 \pm 0.3$
DC. NO. & DATE	ISSUE	NATURE OF AMENDMENT
DC. NO. & DATE	ISSUE	AMENDMENT

APPROVED

H. VASU

CHECKED

K. K. Khatke

CONTROLLERATE OF
QUALITY ASSURANCE
(ICV)
SECUNDERABAD

765-33-54

LV2/RCV-
5330-021359

RING SEALING TOROIDAL

WEIGHT SCALE

0.0007 1:1

SHT SHTS

RUBBER 310 TY 005216-75

89 OF 116