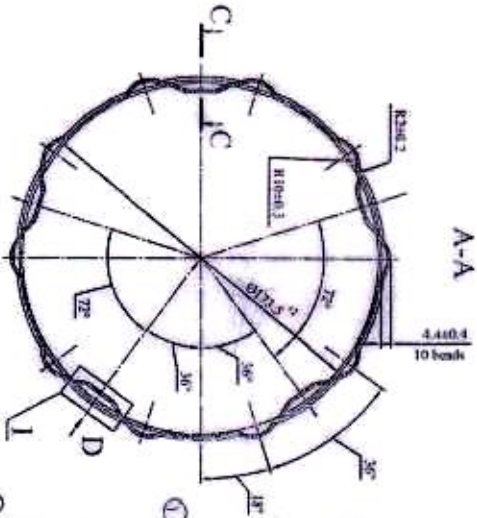
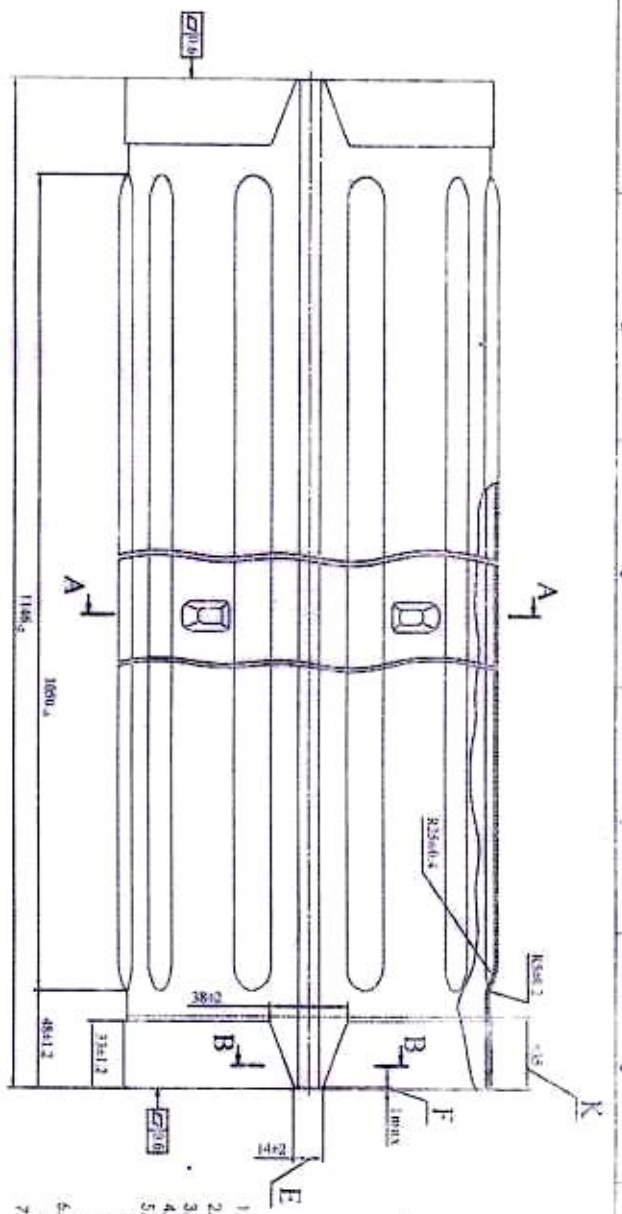


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REV. NO.	DATE	REVISION



Revision No 1 dt 01/03/2021. Indigenous / Alternate material added & thickness of sheet changed. Pkt. 23403 added.

① Indigenous / Alternate material: (i) For GOST TUC.10-1233-77 is Ready Mixed Paint, Air drying for General Purpose to specification IS 148: 2016 (Rev. No 4). Brushing / Spraying, Matt Finish Colour - Dark Aluminium Grey No. 632. 95 per IS 5 (latest edition) or as per the user requirement.

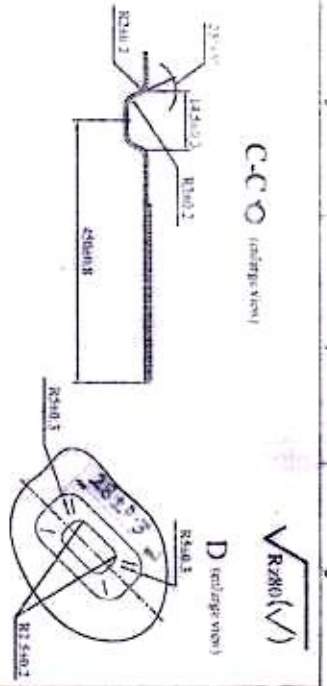
(ii) For GOST 9109-81 IS JSS 8010-68: 2014 (Rev. No 3) with nomenclature 'Paint, ready mixed priming, red oxide, zinc chromate, quinacridon, air drying matt finish, brushing / spraying'.

② The thickness of sheet for cylinder is 0.8 mm wide diameter DFK U. No 84/125 mm FSAPDS/AMK-339 pack dt 05/09/2020.

Authority: Lt. Col. (AMK) / 7200/GEN (CS)/125 mm FSAPDS (AMK 339) / 01 dt 21/Nov/2020.

Author: *[Signature]* 01/03/2021
 Designer: *[Signature]* 01/03/2021
 Checker: *[Signature]* 01/03/2021

1. Steel as per IS 513 Part-1: 2016 Grade CR1.
2. Limit deviations of radii are as per $\pm \frac{L13}{2}$.
3. Limit deviations of angular dimensions - 10th accuracy rate as per GOST 8908-81.
4. Dimension fit specified for bending.
5. During resistance welding, before bending apply the cylinder mutually mixed surfaces in sections G and K with enamel Rp-910 (1) II, 6-10-1233-77. May be coated with primer Ph-02K (1) GOST 9109-81 with 20% of aluminum powder. GOST 564-95 added.
6. Technical requirements to welded joints, category II, as per OST 3-403-91. Check welded joints by visual inspection of welds.
7. Test for leaks by internal gauge at pressure of 0.02 MPa (0.2 kgf/cm²) for 30 s by pressure decay test method after closing both the open ends by suitable mechanism so that it may perform the tilting of edges on rubber gasket. Pressure drop of 0.02 kgf/cm² maximum is allowed. Further pressure drop impermissible. Test for leaks by internal gauge at pressure of 0.02 MPa (0.2 kgf/cm²) for 1 minute by immersion into liquid is allowed. Air bubbles are not allowed.
8. Regarding details of GOST standards and thickness of sheet (1-12 mm), firm may communicate with OFB. If competent authority allows for relevant alternate specification the same will be allowed to vendor.
9. Any other test required to fulfil the criteria for qualification including welding of the cylinder.



TITLE:		CYLINDER	
SCALE: NTS		for Metal Case	
NOTE: 1. ALL DIMENSIONS ARE IN MM. 2. UNSPECIFIED TOLERANCES FOR LINEAR DIM. AS PER IS 2102 (IEC).			
DESIGNER	NAME	DATE	
DRG/DEN	E. S. SAHAI	07/2020	
INCHARGE	N. D. JAIN	07/2020	
APPROVED BY	K. S. VERMA	07/2020	
GOVDO	M. R. VERMA	07/2020	
DESIGN NO.	OFBH/SK/1406		