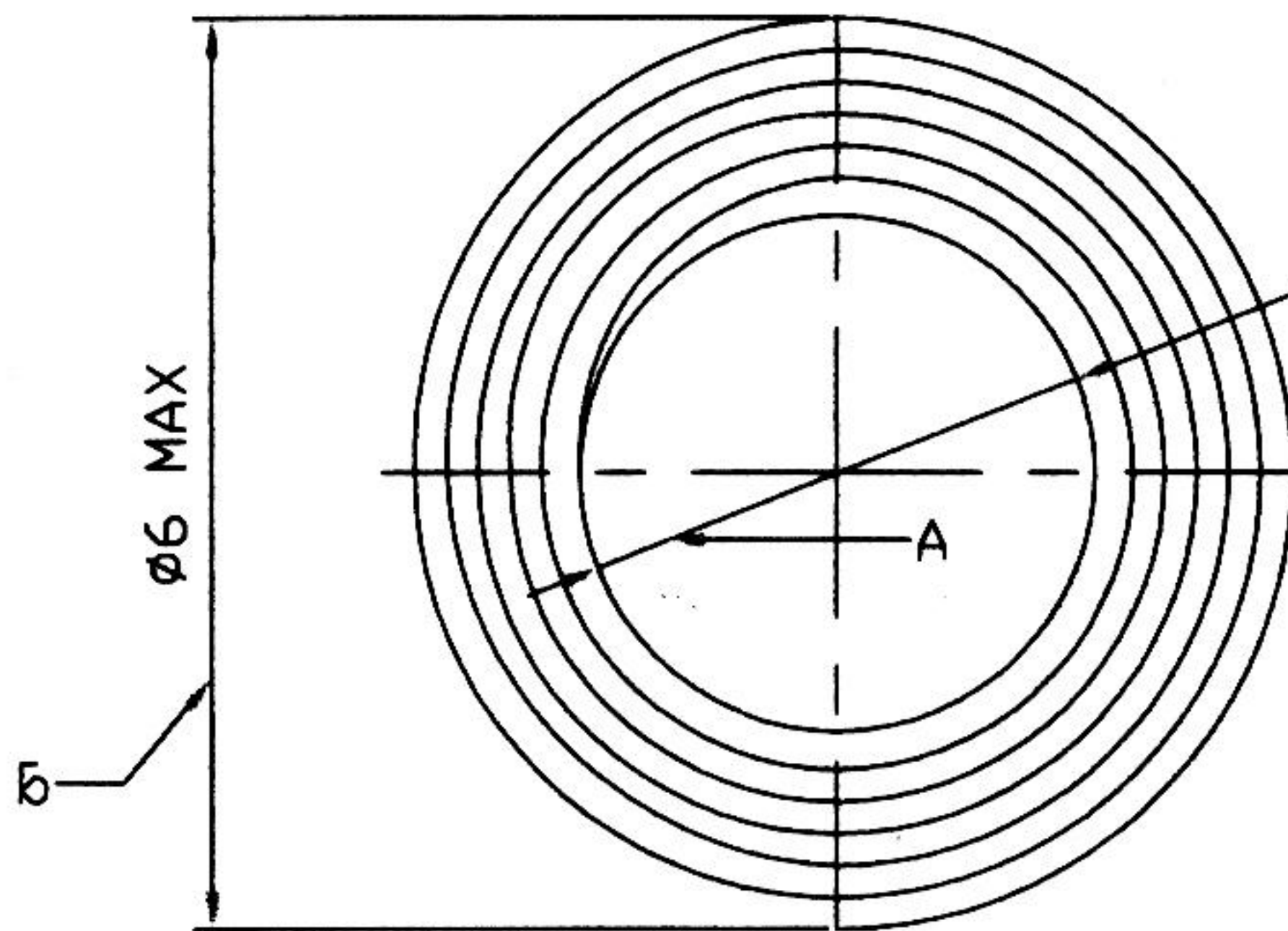
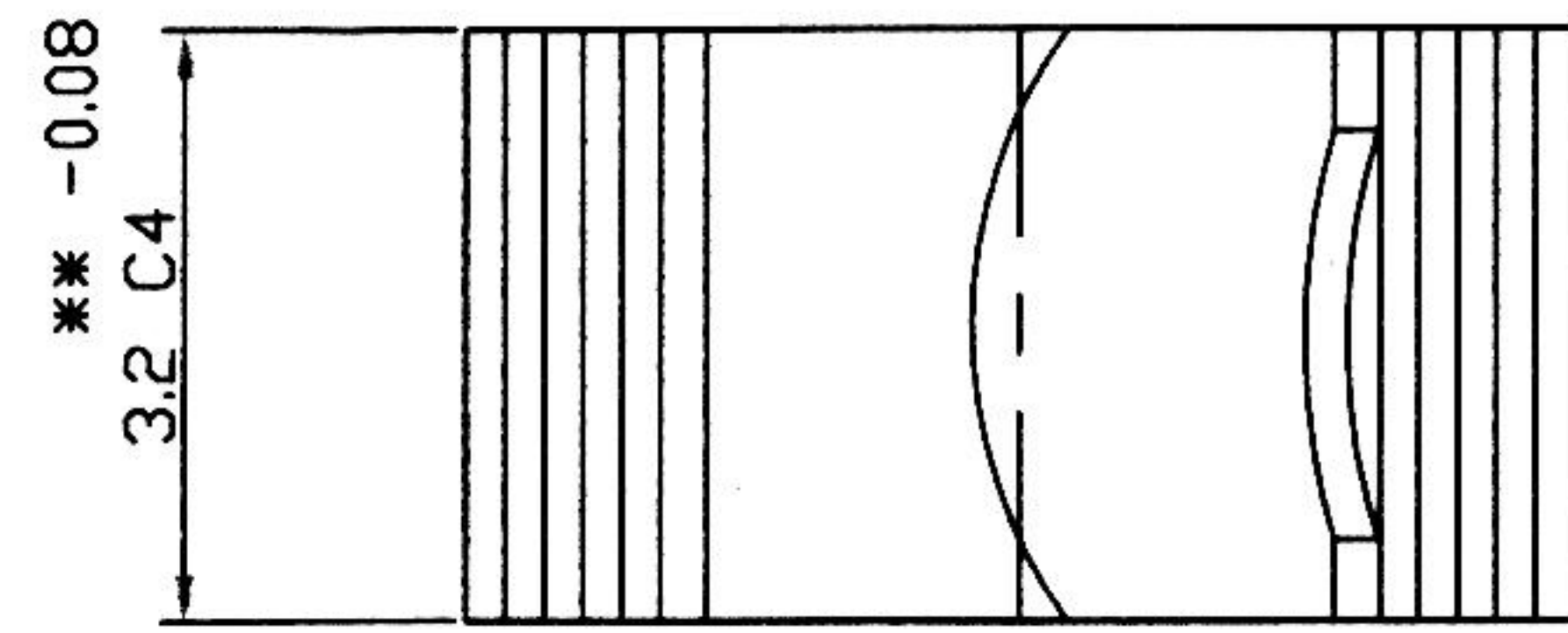
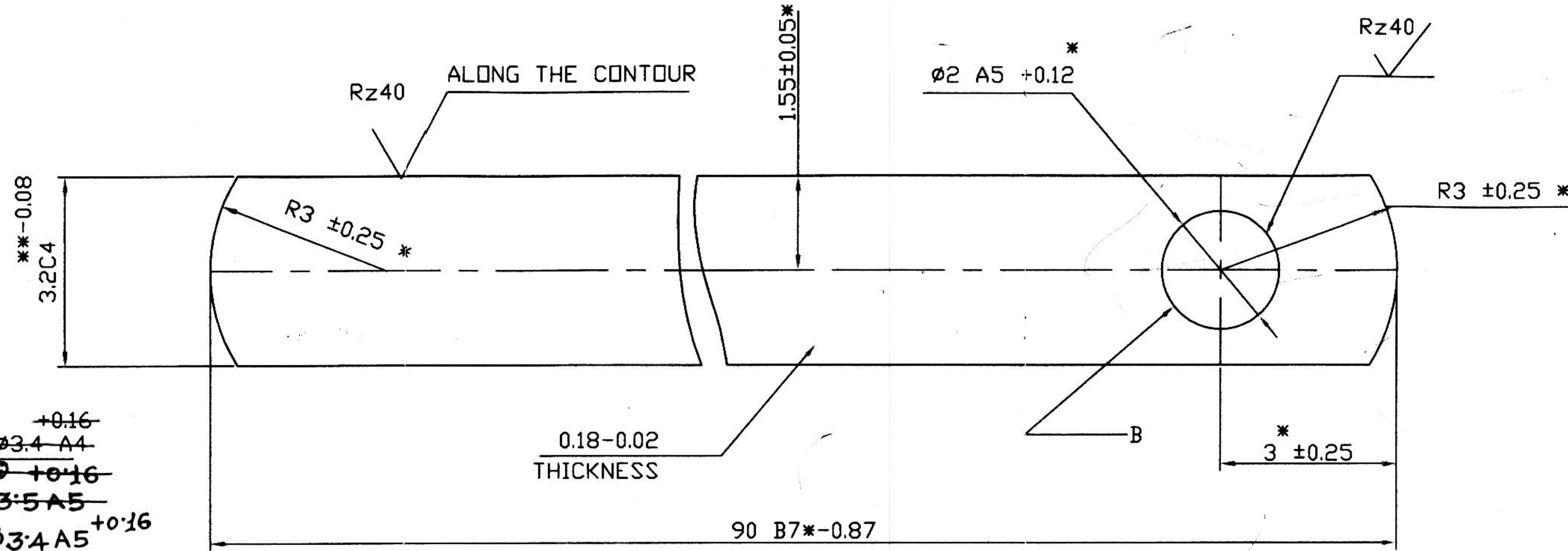


TRIM ON THIS LINE WHEN SUPPLY TO TRADE



- +0.16
- Ø3.4 A4
- +0.16
- Ø3.5 A5
- ⊕ Ø3.4 A5 +0.16

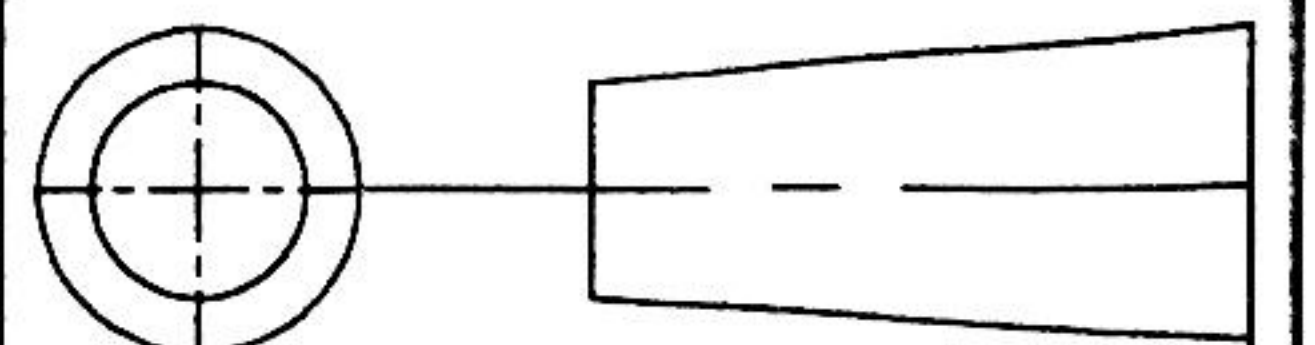


MATL. :- COPPER STRIP TO SPECN IS:3487-66 CHEMICAL COMPOSITION AS PER GRADE FRHC OF SPECN IS: 191 Pt.VI.

MASS :-

SCALE:-10:1		TOL		DIMENSIONS ARE IN mm		ASSY DRG No. NAI(J) 501/609	
ARD 2374 Dt. 25/5/09	D-6	DIMNS. AMENDED		DGN	DRN <i>[Signature]</i>	TCD	COMP
ARD No. 2374 Dt. 31-01-08		DIMNS. AMENDED.		PASSED <i>[Signature]</i>		APPROVED <i>[Signature]</i>	
10.6.03		PROVISIONALLY SEALED BY DGN		NAID		CINA	
08.01.03		APPROVED		MATL SEE DRG.		GEN SPEC NA SPEC A31-B	
R.No.	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS	MATL SPEC SEE DRG.	STORE SPEC
						PROTECTIVE FINISH	STORE REF No.

NAVAL ARMAMENT INSPECTORATE JABALPUR



DRG. No. NAI(J) 501/6/3 (PROVISIONAL) SHT 1 OF 2 SHTS

- ⊕ DIMNS. AMENDED VIDE DGN AI FAX No.- AI/9808, Dt.-25/05/09 & CINA LETTER No.- CI:11101, Dt.-04/08/2009
- ⊕ DIMNS. Amended vide NAI Letter No.- CI/11101, Dt.-03/05/08
- ⊕ ARD No. & Dt. ADDED VIDE NAI Letter No.- CI:327/50-37, Dt.-10/08/09

SPIRAL

6
14

- ALTERNATE MATERIAL IS BAND $\pi \pi \pi \pi$ - 0.18 N π M1 GOST 1173 AND BAND $\pi \pi \pi \pi$ - 0.18 x **22** H π Ty 48-21-529-82.
- BLANK SHOULD BE ANNEALED BEFORE COATING AT A TEMPERATURE OF 620.....660°C WITH HOLDING IT AT THIS TEMPERATURE FOR 20 MINUTES. THE SPREAD OF TEMPERATURES FOR ONE BATCH OF BLANKS SHOULD BE WITHIN 30°C. THERE SHOULD NOT BE CLEARLY MARKED HEAT TINT AFTER ANNEALING.

(a) ANNEALED BLANKS TO BE SUBJECTED TO DIFLECTION TEST ON SAMPELING (SAMPLE SIZE 1%) THROUGH FIXTURE DRG. No.91.97.425 C6 (RUSSIAN) DIFLECTION SHOULD BE 20° MIN. WHEN ARM OF FIXTURE FALLS INSTANTLY FROM 15° ANGLE (CONFIRMATION TO ASCERTAIN THE SOFTNESS OF BLANK)

3. THICKNESS OF THE BLANK AFTER PICKLING SHOULD BE 0.18 -0.023mm.

4. * DIMENSIONS ENSURED BY TOOL.

5. ** DIMENSIONS ENSURED BY TOTAL CHECKING.

6. *** DIMENSIONS FOR REFERENCE.

7. SURFACE TREATMENT :- 2% SHELLAK VARNISH OR Sn 1 μ .

8. THE FOLLOWING IS ALLOWED:-

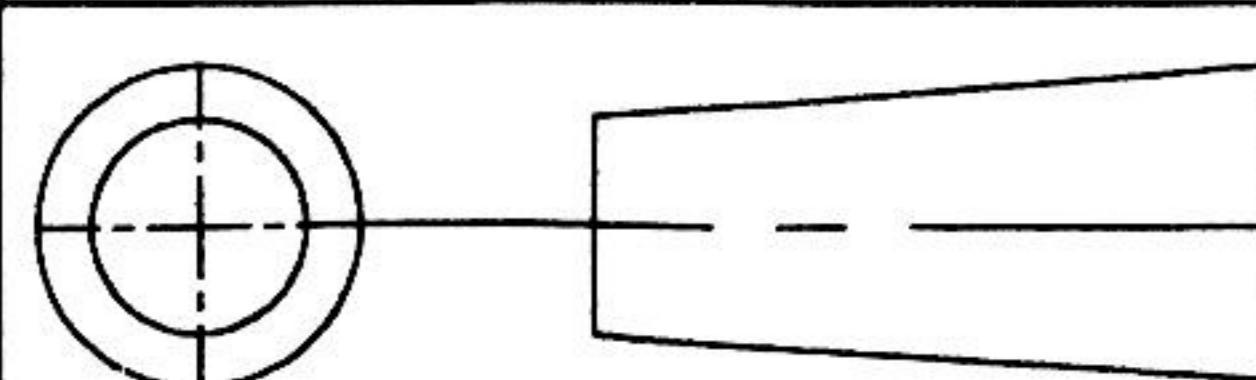
(a) DEVIATION OF THICKNESS OF BLANK MATERIAL IN DIFFERENT POINTS BEFORE COATING AND AFTER THE PICKLING AT A SECTION NOT EXCEEDING 15mm OF ± 0.005 mm.

(b) THE THICKNESS OF BLANKS COATING AT LEAST 0.5 μ .

(c) OPENING OF THE END COLS PERMITTED WITHIN SPECIFIED DIMENSION OF A & B.

9. SPIRAL IS TO BE SUBJECTED TO A SUITABLE FIXTURE, (NAI(J) - - -) UNWINDING LOAD SHOULD NOT EXCEED 280gms. (MAX) SAMPLING INSPECTION PLAN 1% PER BATCH OF 2000 Nos. IN CASE OF MORE THAN 1 FAILURE - SAMPLE SIZE IS DOUBLED. NO FAILURE IS PERMITTED IN THIS CONDITION.

SPECIAL REMARK:- DESIRABLE UNWINDING LOAD FOR BEST FUNCTIONING OF SPIRAL = 90gms. TO 160gms.

				SCALE:-		TOL		DIMENSIONS ARE IN mm		ASSY DRG No.			
ARD 2374 Dt. 25/05/09 D-6 DIMNS. AMENDED				DGN		DRN <i>[Signature]</i>		TCD		COMP		NAVAL ARMAMENT INSPECTORATE JABALPUR	
ARD No. 2374, Dt. 31-01-08 DIMNS. AMENDED.				PASSED <i>[Signature]</i>		NAID		APPROVED <i>[Signature]</i>		CHD			
10.6.03 PROVISIONALLY SEALED BY DGNAI										CINA			
08-01-03 APPROVED				MATERIAL :				GEN SPEC NA SPEC A31-B					
R.No.				DATE		ZONE		BRIEF RECORD		AUTHORITY		INITIALS	
				MATERIAL SPEC :				STORE SPEC				STORE REF No.	
				PROTECTIVE FINISH									
SPIRAL (NOTE)										(6)		DRG. No.	
* DIMNS. Amended Vide NAI Letter No.- CI/11101, Dt.-03/05/08. * ARD No. & Dt. ADDED VIDE NAI Letter No.- CI:327/50-37, Dt.-10/08/09.										(15)		NAI(J) 501/6/3 (PROVISIONAL) SHT 2 OF 2 SHTS	

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