



REFERENCE

ISSUED BY
 STAFF CELL
 for EOI
 DATE: 9/6/19
 SIGNATURE:

NOTES:

- MATL. :- EN19
- HARDENED & TEMPERED (TURNED OR GROUND) IN 'W' CONDITIONS.
- HYDRAULIC PRESSURE TESTING TO 315 Kg/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 TEST FOLLOWED BY BURST TEST (VALUE TO BE RECORDED).
- TAPPED HOLES M6x1.0 AT DIST 8.0 TO BE MADE ONLY AFTER ENSURING FULL TIGHTENING DURING ASSY.
(MEDIUM CLASS)
- GEN. TOL. IS:2102 EXCEPT SPECIFIED

- NOTES:**
- SURFACES TO BE PHOSPHATED TO IS 3618 CLASS B
 - INTERNAL SURFACE BE COATED UNIFORMLY WITH ZIRCONIUM SILICATE TO APPENDIX 'C' OF SPECN ARDE/SPECN/334/1985 OR 'APC 216 TO SPEC: JSS: 8010-51:09
 - EXTERNAL SURFACES MARKED XXX TO BE PAINTED WITH P U PAINT DOVE GREY (ISC No 694 TO IS:5) EXCEPT THREADED SURFACES.
 - 100% ULTRA SONIC TEST AS PER IS: 8791/98 CLASS 'B' TO BE CARRIED OUT.

DCA No 1340000562

R.No	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS	SCALE	DIMENSIONS ARE IN mm	TOL	D.S.CAT No	ASSY.DRG. No.
	01-05-14		ALTERNATE PROTECTIVE COMPOSIT- ION & SPECIFICATION ADDED	ARD 2459	<i>[Signature]</i>	DGN. -	DRN <i>[Signature]</i>	TCD -	COMP. <i>[Signature]</i>	ASSY.DRG.LIST No.
	13-02-14		NOTES ADDED & AMENDED	ARD 2453	<i>[Signature]</i>	PASSED <i>[Signature]</i>	APPROVED <i>[Signature]</i>		CHD <i>[Signature]</i>	DTE GEN OF NAVAL
	08-09-09		DCA No ADDED	ARD 2396	<i>[Signature]</i>	CTO(D)	DGNAI			ARMAMENT INSPECTION
	02-06-09		APPROVED	DGNAI		MATL:- EN 19				IHQ, MoD (NAVY), N.DELHI
						MATL. SPEC.:- SEE NOTES ON DRAWING				
						PROTECTIVE FINISH. SEE ABOVE				

CHAMBER FORE MOTOR

DRG.No.
NASK 1064
 (PROVISIONAL)