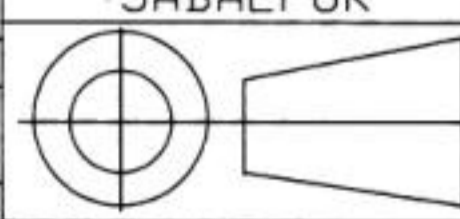
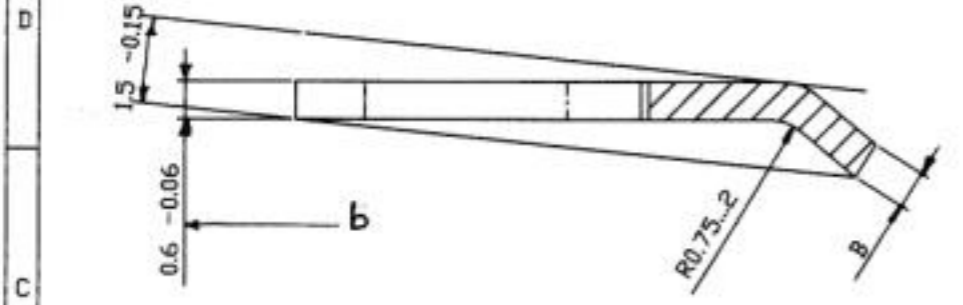
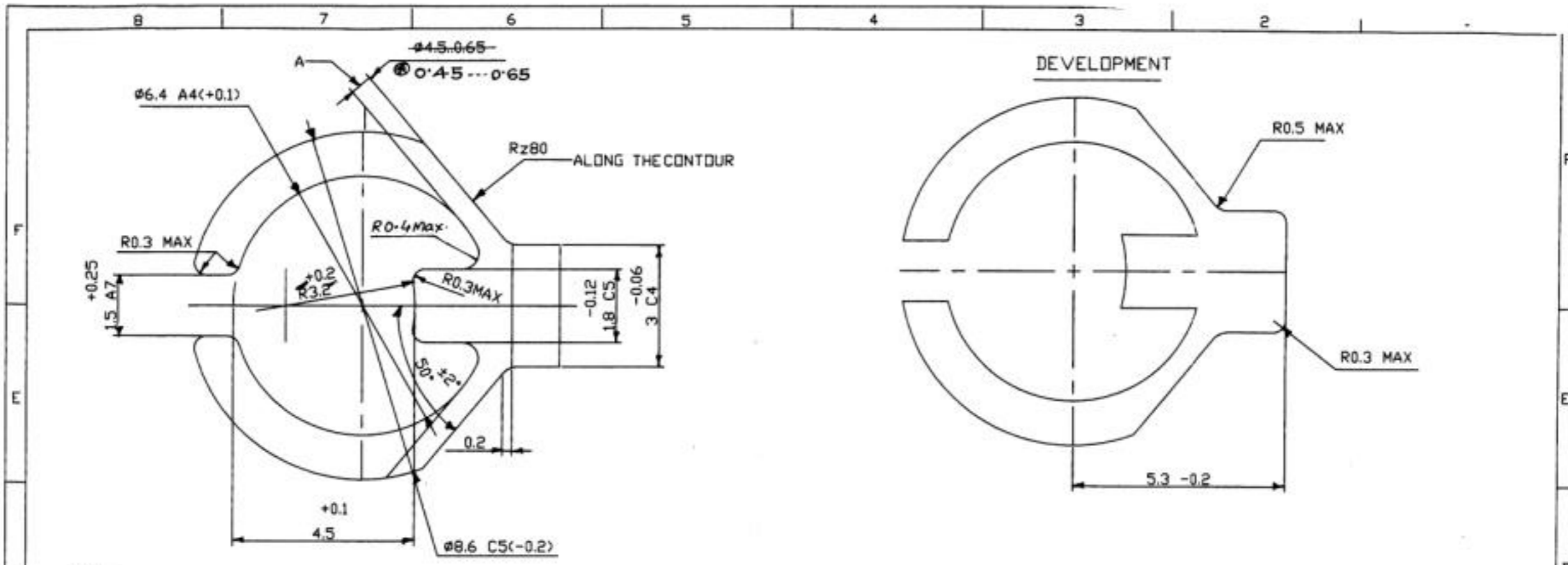


1. ALTERNATE MATERIAL:-
 - (a) HARD BAND EXTRA HARD OF ANY GRADE GOST 2208-75.
 - (b) HARD BAND EXTRA HARD OF ANY GRADE GOST 931-78.
2. * DIMENSION FOR REFERENCE, OTHER DIMENSIONS ARE ENSURED BY TOOL.
3. COATING : CHEMICAL PASSIVATION/VARNISH- П Б Г 2(1) DST 884-1010-74 AND COATING-CHEMICAL PASSIVATION/VARNISH Ω 4(1) DST 884-811-73 IS ALSO ALLOWED.

MATERIAL :- BRASS STRIP TO SPECN. BS:2870 GRADE cz-120 WITH UTS 37-50 AND ELONGATION 18% MIN.

MASS :- 0.1g.

	10.6.03		PROVISIONAL SEALING BY DGNAT		
	08.01.03		APPROVED.		
R. No.	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS
SCALE: 1-10:1		TOL.		DIMENSIONS ARE IN mm	
DGN.	DRN.	TCD.	COMP.	CHD.	NAVAL ARMAMENT INSPECTORATE JABALPUR 
PASSED <i>NAID</i>			APPROVED. <i>A. G. K. Gadhly</i>		
MATERIAL: SEE DRG			GEN. SPECN. NA-SPEC. A31-B		
MATERIAL SPECN: SEE DRG.			STORE SPECN.		
PROTECTIVE FINISH:			STORE REF. No.		
TITLE					DRG. No.
<u>SLIDER</u>					(52) NAI(J) 501/16/1 (PROVISIONAL)



1. ANNEAL CLIP AT A TEMPERATURE OF $290^{\circ} \pm 30^{\circ} C$ FOR TWO HOURS IN VACCUUM CASE.
2. SPREAD OF TEMPERATURE TO ENSURE THE FULFILLMENT OF REQUIREMENT AT REF. No 6 FOR ONE BATCH OF PARTS NOT TO EXCEED $30^{\circ} C$.

MATL :- BRASS TO SPECN. BS: 2870 Cz-108 WITH TENSILE STRENGTH 52-65 Kg/mm² ELONG 4% MIN.

Mass:- 0.11g

					SCALE:-10:1	TOL	DIMENSIONS ARE IN mm		ASSY DRG No. NAI(J)501/16
					DGN	DRN <i>Bave</i>	TCD	COMP	CHD. <i>AB</i>
DIMNS. AMENDED, PROVISIONALLY SEALED BY: <i>DAIAT</i>					PASSED <i>[Signature]</i>		APPROVED <i>A. G. C. Gadhwa</i> CINA		NAVAL ARMAMENT INSPECTORATE JABALPUR
APPROVED <i>[Signature]</i>					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.		

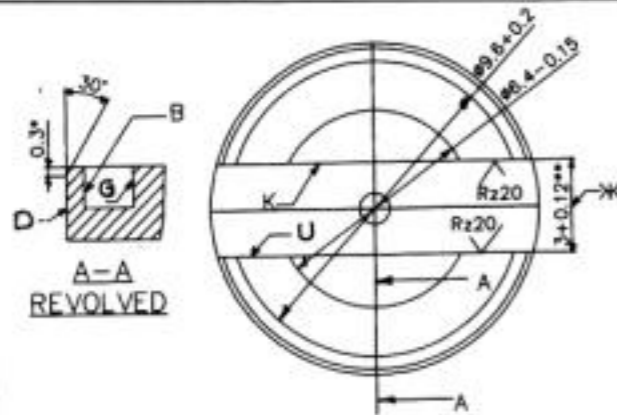
1A

CLIP

53

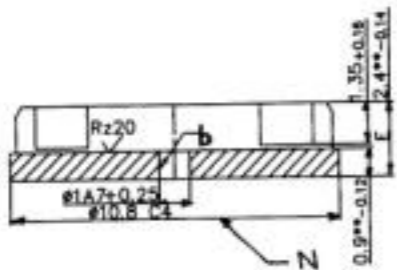
DIMNS. Amended Vide NAI Letter No.-CI/11101, Dt.-03/05/08

DRG. No.
NAI(J) 501/16/2
(PROVISIONAL)
(SHEET 1 OF 2 SHEETS)



NOTES FOR CLIP: -

1. ALTERNATE MATERIAL IS BARDPHO 0.6 HA 63 GOST 931-78.
2. * DIMENSIONS FOR REFERENCE, OTHER DIMENSIONS ENSURED BY TOOLS.
3. DIMENSION 'A' DEVIATION NOT TO EXCEED 0.1mm IN ONE BATCH OF PARTS.
4. COATING-CHEMICAL PASSIVATION/VARNISH $\mu\text{M}-4$ (1) OST B 84-811-73.
5. - a) CLIPS CAN BE CHECKED, WHILE ACCEPTING THE PARTS AS A PART OF ASSEMBLY UNIT NAI (J)501/16 WITH USING PART 'PLUG FOR CLIP TESTING' (DRG. SHOWN IN THIS SHEET) WITHOUT PRELIMINARY IMPACT ON IMPACT TESTER MASSET.
 - b) CLIPS WHICH IS PRELIMINARY TESTED ON IMPACT TESTER MASSET BY IMPACTS FROM THE 23rd TOOTH AS A PART OF ASSEMBLED UNIT NAI(J)501/16 WITH CAP DOWNWARDS INFIXTURE IMITATING THE POSITION OF ASSEMBLY UNIT IN ITEM, SHOULD HOLD THE SLIDER (NAI(J)501/16/1) AT 30,000 RMP AND RELEASE IT AT 55,000 RPM. THE ACCURACY OF MEASURING ROTATIONAL FREQUENCY SHOULD BE ± 600 RPM. CAP NAI(J)501/16/3 CAN BE REPLACED.
6. PRESENCE OF BURRS ON THE EDGES OF PARTS IS ALLOWED PROVIDED THE DIMENSION B SHOULD NOT EXCEED 0.67mm AND DIMENSION A SHOULD NOT EXCEED 0.9mm.
7. THE VOLUME OF BATCH AND VOLUM OF SPOT CHECKING ACCORDING TO REF. NO. 6 IS SET BY MANUFACTURE AND IS AGREED WITH CUSTOMER. REPRESENTATIVE AT MANUFACTURING PLANT.





PLUG FOR CLIP TESTING

MATL. AL. ROD TO SPECN. BS : 1474
 GRADE 2014 IN TF COND. OR IS: 733
 DESIGN. 24345 IN 'WP' COND.
 SPECIFIED MATL: ROUND BAR GOST 21488-76.

PLUG FOR CLIP TESTING

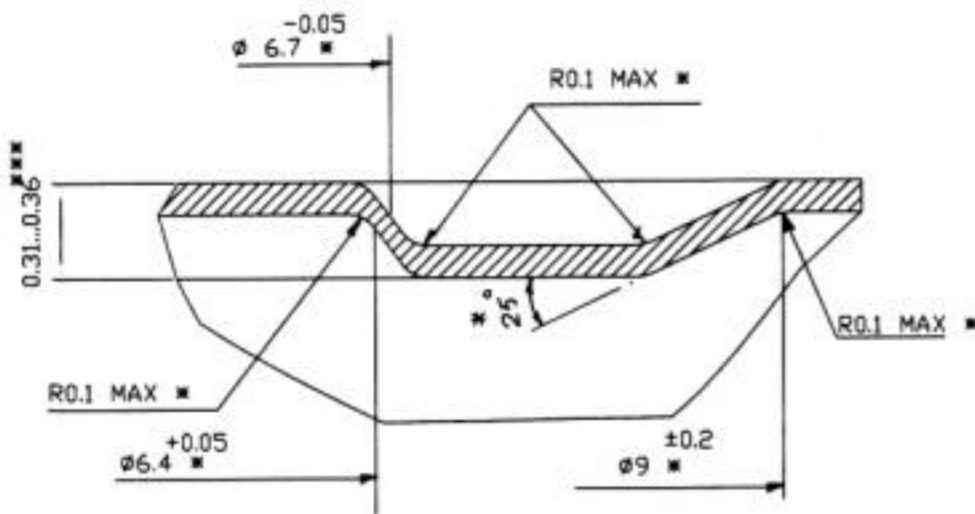
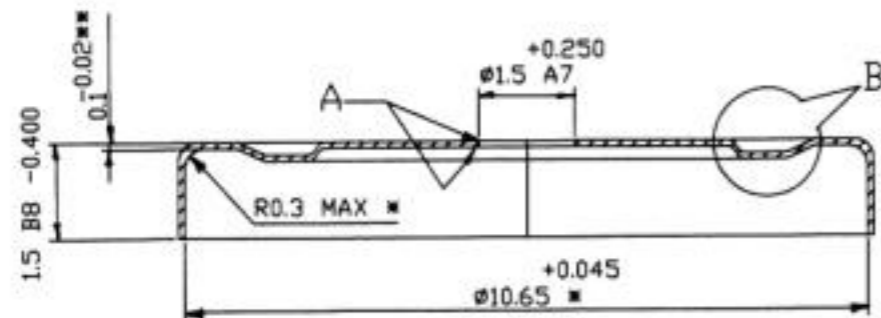
1. * DIMENSIONS ENSURED BY TOOLS.
2. ** DIMENSIONS SUBJECT TO TOTAL CHECKING.
3. FINISH SURFACES b, B, G, D IN ONE SETTING.
4. RADIUS OF INTERNAL ROUNDING OFF NOT TO EXCEED 0.2mm.
5. THE FOLLOWING IS ALLOWED: -
 (a) PRESENCE OF MARKS WITH DEPTH NOT EXCEEDING 0.1mm ON SURFACES K, U
 (b) COATING WITH VARNISH $\mu\text{M}-4$ OST B 84-811-73.
 (c) REDUCTION OF DIMENSION N IN PLACE OF GROOVE WITH DIMENSION \mathcal{K} .
 (d) LOCAL REDUCTION OF DIMENSION E UP TO 2.2mm TOTALLY ON 0.2 OF CIRCUMFERENCE LENGTH.
6. COATING : CHEMICAL PASSIVATION/VARNISH $\mu\text{M}-4$ OST B-84-811-73.

					SCALE: -5:1	TOL	DIMENSIONS ARE IN mm		ASSY DRG No. NAI(J)501/16(P)
					DCN	DRN	TCD	COMP	CHD
APPROVED					PASSED		APPROVED		NAVAL ARMAMENT INSPECTORATE JABALPUR
					NAIO		CINA		
					MATL : SEE DRG.		GEN SPEC NA SPEC A31-B		
					MATL SPEC : SEE DRG.		STORE SPEC		 
R.No.					DATE		ZONE		
BRIEF RECORD					AUTHORITY		INITIALS		NAI(J) 501/16/2
									(PROVISIONAL)

CLIP

DIMNS. Amended Vide NAI Letter No.-CI/11101, Dt.-03/05/08.

(14)
(5A)



ENLARGED VIEW AT 'B'

1. ALTERNATE MATERIALS ARE BAND SOFT OR ANY GRADE GOST 4986-79 WITHOUT COATING, BAND 0.8 mm-DM-3-0.1 GOST 503-81
2. * DIMENSIONS ENSURED BY TOOLS.
3. ** DIMENSIONS FOR REFERENCE.
4. COATING TIN 6 MICRONS THICK, CHROMATIZED.
5. THE FOLLOWING IS ALLOWED:-
 (a) COATING ALLOY Cu Zn (70%)/3μ Sn 3μ OR Cu 3u Sn 3μ.
 (b) PRESENCE OF BURRS (EXCEPT EDGE A), SLIGHT CORRUGATION.
6. DIMENSIONS MARKED WITH *** ARE SUBJECTED TO TOTAL CHECKING.

MATL : STEEL STRIP SPECN BS:1442 SEC. 2 CR 3 OR IS:513 DD.

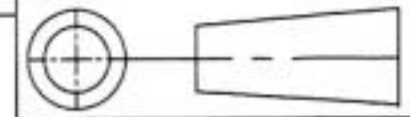
MASS:- 0.1g

				SCALE:-10:1	TOL	DIMENSIONS ARE IN mm		ASSY DRG No. NAI(J)501/16 (P)
				DGN	DRN	TCD	COMP	CHD
				PASSED	NAID		APPROVED <i>A. Lakshmi</i>	NAVAL ARMAMENT INSPECTORATE JABALPUR
						CINA		
				MATL (SEE DRG.)		GEN SPEC NA SPEC A31-B		
R.No.	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS	MATERIAL SPEC (SEE DRG.)		STORE SPEC
						PROTECTIVE FINISH		STORE REF No.

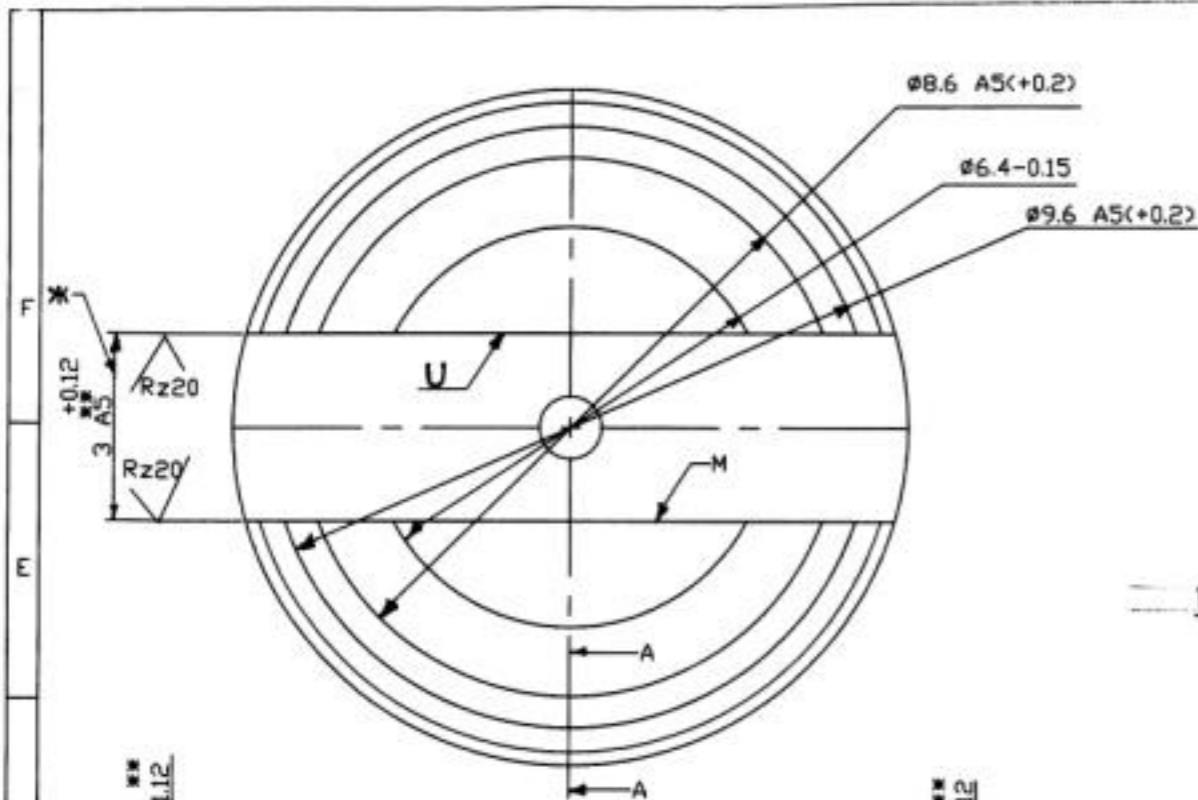
14

CAP

55

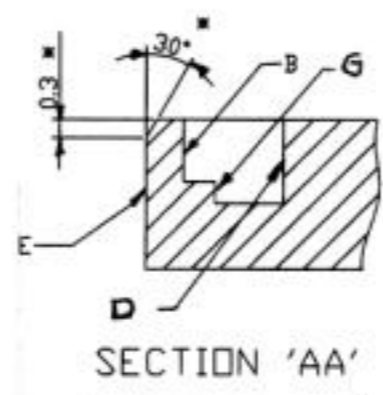
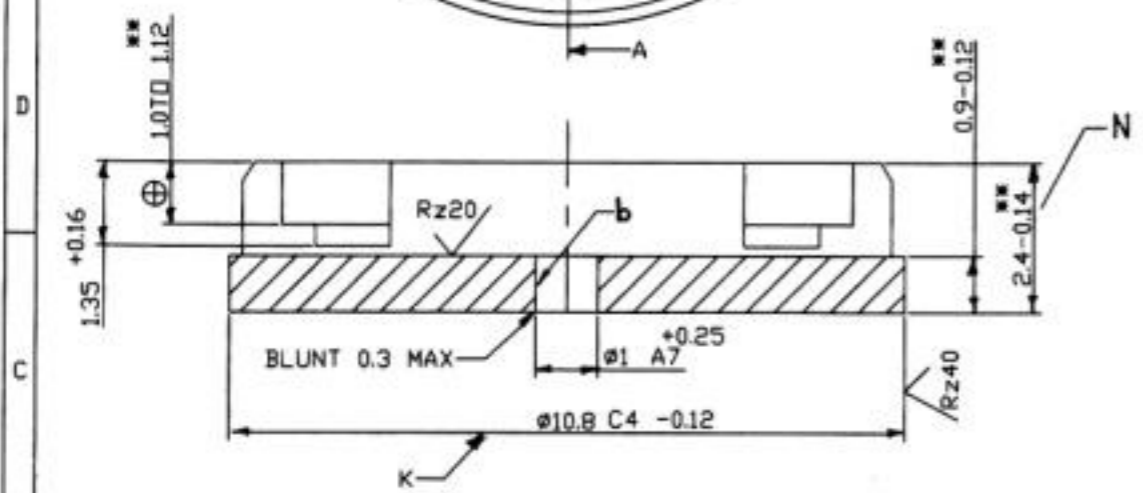


DRG. No.
NAI(J)501/16/3
(PROVISIONAL)



1. * DIMENSIONS ENSURED BY TOOLS.
2. ** DIMENSIONS SUBJECTED TO TOTAL CHECKING.
3. FINISH SURFACES **b, G, B, A, D, E** IN ONE SETTING.
4. RADIUS OF INTERNAL ROUNDING OFF NOT TO EXCEED 0.2mm*
5. COATING : CHEMICAL PASSIVATION (CHROMATIZING).
6. THE FOLLOWING IS ALLOWED:-
 - (a) PRESENCE OF MARKS ON SURFACE **U, M** WITH A DEPTH UP TO 0.1mm.
 - (b) COATING WITH VARNISH **4(1) DST B 84-811-73**, CHEMICAL PASSIVATION COATING/VARNISH **4(1) DST B 84-811-73**.
 - (c) REDUCTION OF DIMENSION **K** IN PLACES OF GROOVES WITH DIMENSION**
 - (d) LOCAL REDUCTION OF DIMENSION **N** UP TO 2.2mm ON THE LENGTH OF 0.2 OF CIRCUMFERENCE.

EQUIVALENT MATL. : AL. ROD TO SPECN. BS:1474 GRADE 2014 IN TF CONDITION



MASS:- 0.35g

				SCALE-10:1	TOL	DIMENSIONS ARE IN mm		ASSY DRG No. NAI(J) 501/16(P)
				DGN	DRN	TCD	COMP	CHD
				PASSED	NAIO		APPROVED	CINA
				MATL :- AL. ROD		GEN SPEC NA SPEC A31-B		NAVAL ARMAMENT INSPECTORATE JABALPUR
				MATL SPEC IS: 733 DESIG. 24345 IN 'WP' COND		STORE SPEC		
				PROTECTIVE FINISH		STORE REF No.		
R.No.	DATE	ZONE	BRIEF RECORD	AUTHORITY	INITIALS			

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SAFETY PLUG

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DRG. No. NAI(J) 501/16/4 (PROVISIONAL)