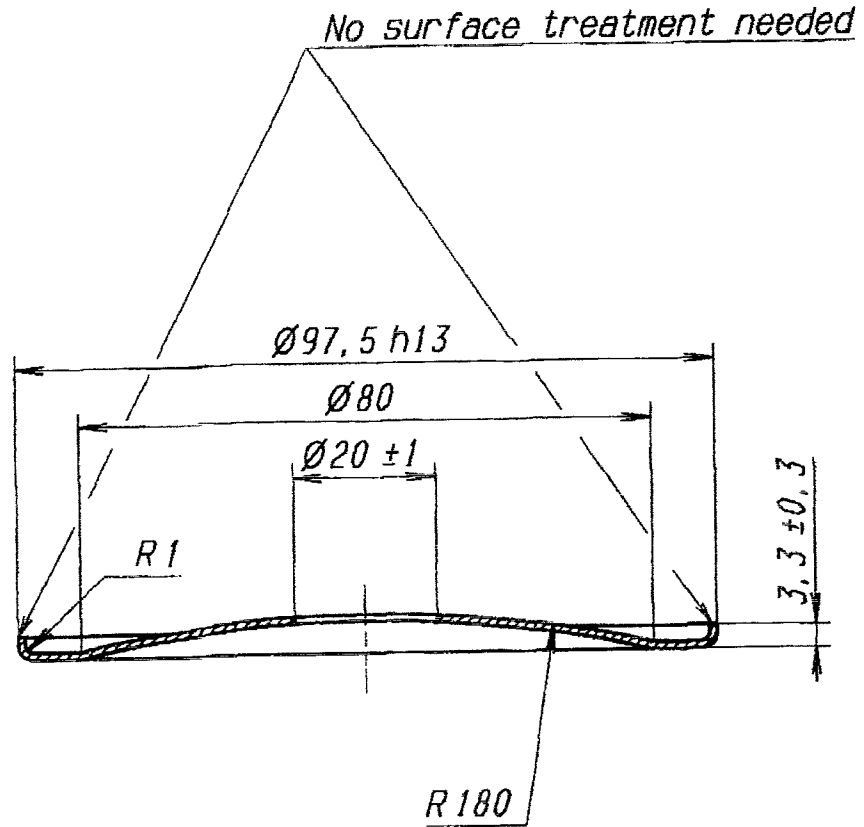


DRG.No.  
TRD-122165

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MATERIAL:- \*) Steel "ZINNJA" SP/D, zinc-plated 2,5 x 10µm and chromated Norrbottens Järnverk AB (or equivalent steel)

				Item No.	DESCRIPTION	No. off	MATERIAL
Insp.	Date	JWM/CDO	DA No	Heat Treatment Rc.-		SUPPORT DISC	
Amendments				▽2.5-25 Ra	0.2-0.075 Ra		
JWM/R&D	<i>Pal</i>			▽6.3 Ra	0.1-0.025 Ra	Drg. No. TRD-122165	
HOS/CDO	<i>Qir</i>	DATE 29.1.07		DIMENSIONS ARE IN mm.		SCALE:- 1:1	
CKD	<i>Fordu</i>	CKD		UNTOL. DIMNS. IS:2102 MEDIUM		No. of sheets - 01	
DRN	<i>As</i>	TRD		SHARP EDGES TO BE REMOVED		Sheet No. - 01	
Approved by Jt. GM CTR (R&D)				ORDNANCE FACTORY KHAMARIA			
PS/GS.				Store :- 84 mm HEAT 551		Compt.:- DRGN No. - 6417075	
				Drg.No.			

REF. DRG. NO. 6 417 075

Utfärdad av, tjtst <i>Compiled by, Dept.</i> Too/AUZ	Granskad av, tjtst <i>Reviewed by, Dept.</i> Amu/GUM	Datum <i>Date</i> 98-10-28	Utg nr <i>Edition No.</i> 1	Dokumentnummer <i>Document no.</i> 0 816 199
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84 mm container 520:9  
(IN)

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ÄNDRINGSFÖRTECKNING *RECORD OF CHANGES*

Ändring nr <i>Revision No</i>	ÄO-nr <i>Rev order No</i>	Berörda paragrafer + kort beskrivning <i>Relevant paragraph + brief description</i>
----------------------------------	------------------------------	--

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## 1 Relevant Documents

in addition to this specification:

Article number	1 194 406
Assembly drawing	2 032 398
Greasing of O-rings	0 802 826
Functional gauge (Art. No.)	1 195 221
Sampling procedures and tables for inspection by attributes	MIL-STD-105
Colour standard	BS 381 C

## 2 Description of Product

The container is designed for two 84 mm rounds of types 551, 552 or 551C. The containers shall provide the required protection to the rounds against the climatic and mechanical stresses that may occur during transportation, handling and storage.

## 3 Product Requirements

### 3.1 Included parts

The included parts shall meet the requirements of the applicable technical documentation.

### 3.2 Dimensions

**3.2.1** The outside dimensions specified in the drawing shall be considered as maximum dimensions and shall not be exceeded.

**3.2.2** A functional gauge, stated in para. 1, shall readily fit in the container. Max. force to pull out the gauge in horizontal position must not exceed 60 N. AQL: 1.0 %.

### 3.3 Surface Quality

**3.3.1** The sealing surfaces on tube and cap shall be free from burrs and other surface defects that may affect sealing in accordance with para. 3.4.4.

**3.3.2** The containers shall be free from cracks and other defects that may affect their strength and function in other respects.

**3.3.3** Externally, the containers shall be matt.

**3.3.4** The containers shall be free from grease and other impurities. AQL: 2.5 %.

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### 3.4 Function

**3.4.1** The containers shall after storage for a comparatively long time within the temperature range 344 K (+71 °C) to 219 K (-54 °C) meet the requirements of this specification within the temperature range 333 K (+60 °C) to 233 K (-40 °C). Inspection in accordance with para. 6.5.1.

Test to be carried out as type test.

**3.4.2** The starting torque required to tighten and unscrew the cap from the container, in which there shall be two rounds, shall not exceed 20 Nm. The requirement applies in the temperature range 233 K (-40 °C) to 333 K (+60 °C). AQL: 1 %. However, no value greater than 25 Nm.

Inspection in accordance with para 6.5.2.

**3.4.3** The requirement of para. 3.4.2 shall be met also after storage for a comparatively long time under normal storage conditions.

Requirement to be inspected in type test.

#### 3.4.4 Sealing

The container shall be airtight when subjected to an internal air overpressure of 20 kPa (0,2 bar) within the temperature range 233 K (-40 °C) to 333 K (+60 °C). Inspection in accordance with para. 6.5.4.

AQL: 0,65 %.

The container shall be watertight when subjected to an external water overpressure of 20 kPa (0,2 bar) within the temperature range 233 K (-40 °C) to 333 K (+60 °C).

Test to be carried out as type test.

#### 3.4.5 Drop Test 1.5 m

**3.4.5.1** Container containing rounds (Functional gauges), shall withstand a free fall drop test in random attitude from 1,5 m onto a concrete surface or a steel plate embedded in concrete without suffering any change in the function of the container. The function requirement implies, among other things, that after the drop test the containers shall be airtight when subjected to an internal overpressure of 20 kPa (0.2 bar).

AQL: 1 %. However, to 233 K (-40 °C) and 333 K (+60 °C) 4 % is applicable.

Inspection in accordance with para. 6.5.3.

#### 3.4.6 Drop Test 4 m

**3.4.6.1** Container containing rounds (Functional gauges), shall withstand a free fall drop test in random attitude from 4 m onto a concrete surface or a steel plate embedded in concrete subject to the requirements stated below.

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After the drop test the container shall be in such a condition that the rounds are adequately protected when transported in the package subjected to drop testing, which among other things implies that the nose shall not entirely come loose from the tube as well as that it shall be possible to unscrew the cap by hand after the test. If a cap has come loose, it shall be possible to fit the cap back.

Test to be carried out as type test.

AQL: 1 %. However, to 233 K (-40 °C) and 333 K (+60 °C) 6.5 % is applicable.

### 3.4.7 Handle Requirements

**3.4.7.1** The handle and its fastenings shall, at normal temperature, withstand a load of min. 500 N (50 kp) applied for 5 minutes.

AQL: 1 %.

**3.4.7.2** At 233 K (-40 °C) and 333 K (+60 °C), the handle shall withstand a rapidly applied load of min 150 N (15 kp), which shall then be applied for 5 minutes, without failure of the handle or permanent deformation of its fastenings.

Test to be carried out as type test.

In all tests, the load-carrying part of the handle shall be limited to max. 100 mm of the centre of the handle.

**3.4.8** The container shall be subjected to an external pressure of  $34 \times 10^3$  Pa (0.34 bar) for 4 hours. After storing the container at ambient pressure for 0.5 hour, it shall be possible to unscrew the caps by hand.

Test to be carried out as type test.

## 4 Manufacture

### 4.1 Methods and Equipment

**4.1.1** Injection-moulded parts shall be manufactured in machinery operating in accordance with established modern principles and giving an adequate reproducibility of the manufacturing cycle.

**4.1.2** The suppliers' production and quality control shall be such that the quality of the stores is not endangered. This implies among other things that there shall be written instructions for manufacture and inspection.

**4.1.3** Injection-moulded parts made at the start of a run, before continuity has been achieved, shall be rejected.

**4.1.4** In those cases where a release agent is required for starting-up, parts containing release agent shall be removed and rejected.

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**4.1.5** Injection-moulded parts shall be manufactured in such a way that they are free from such internal stresses that may cause stress cracking.

Testing to para. 6.5.1.

Test to be carried out as type test.

**4.1.6** Tube and nose shall be joined by injection moulding.

**4.1.7** Component parts and finished containers shall be stored and transported in such a way the maximum values for moisture specified on the drawings are not exceeded.

**4.1.8** Before fitting the sealing ring, it shall be greased in accordance with specification stated in para. 1. Ensure that the container is not stained with grease.

## **4.2 Planning and Follow-up**

**4.2.1** Alternations in the technical documents or in the manufacture that may affect the requirements of this specification shall not be made without the purchaser's consent.

**4.2.2** The tubes and the noses used for one lot of containers shall be made of the same grade of material, which shall be used also when joining nose and tube. Each of the parts shall be manufactured in one and the same set-up.

**4.2.3** The planning and follow-up shall be such that rejected stores cannot be included in approved deliveries.

**4.2.4** A manufacturing journal shall be kept and shall be available to the purchaser. The journal shall give information on the lots of parts used for each manufacturing lot as well as on raw materials, etc. Further, the journal shall state any changes of the design or in the manufacture as well as the results of tests made during manufacture.

## **5 Delivery**

### **5.1 Packing**

**5.1.1** A delivery lot shall consist of approx. 2 500 containers, which shall be from one and the same manufacturing lot.

**5.1.2** The containers shall be delivered complete in accordance with the drawing specified in para. 1.

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## 5.2 Transportation Marking

The transport package shall be marked with the name of the product, article number, the purchaser's purchase order number, quantity and delivery lot number.

## 6 Inspection

Inspection of dimensions and function shall be carried out not earlier than 48 hours after moulding.

### 6.1 Vendor's Inspection

**6.1.1** The vendor shall perform inspection to the extent necessary to verify that the requirements of this specification are met.

**6.1.2** Parts manufactured by subcontractors shall, when the vendor is the prime contractor, be inspected by him to the extent necessary to verify that the requirements laid down are met.

### 6.2 Purchaser's Inspection

**6.2.1** The purchaser is entitled to follow the vendor's manufacture and inspection and to carry out receiving inspection to the extent he will find suitable.

### 6.3 Inspection Lot

A delivery lot forms an inspection lot.

### 6.4 Certificates

**6.4.1** For each delivery lot, the vendor shall deliver to the purchaser test certificates of the extent and the result of his inspection in accordance with para. 6.1. Arrangement of certificate as agreed upon between purchaser and vendor.

**6.4.2** For each delivery lot, the vendor shall deliver to the purchaser a certificate of raw materials used, among other things specifying grade of material and colour.

### 6.5 Test Specifications

**6.5.1** For inspection of the requirements of para. 3.4.1 and para. 4.1.5, the twin container shall be subjected to the following environmental tests.

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### 6.5.1.1 Temperature and Humidity

Expose the twin container, fitted with two Functional gauges (stated in para. 1), to two 14-day cycles between 219 K (-54 °C) and 344 K (+71 °C) (95 % RH), each cycle with additional storage at 344 K (+71 °C) (95 % RH). (MIL-STD-331 Test 105).

The twin container is stored at low temperature from 08.00 to 16.00, and then at high temperature until 08.00 the following day.

The additional storage takes place from Friday 16.00 until Monday 08.00.

See also the graph, page 14.

### 6.5.1.2 Damp Heat

Subject the twin container, fitted with two Functional gauges, to the following cycle:

- 1) 3 days at 319.5 K (46.5 °C ± 5 °C) and 95 % RH ± 5 %
- 2) 24 hours cooling
- 3) 24 hours at 319.5 K (46.5 °C ± 5 °C) and 95 % RH ± 5 %
- 4) 24 hours at 333 K (60 °C ± 5 °C) and 60 % RH ± 5 %
- 5) 24 hours cooling

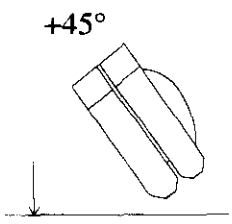
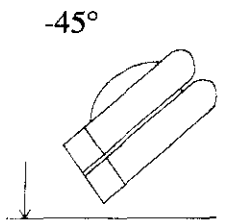
Repeat cycle for six months.

**6.5.2** The starting torque required to tighten and unscrew the cap to be measured after tightening and unscrewing the cap once.

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**6.5.3 Drop 1.5 m (destructive test)**

The test is performed as a sequential test in accordance with the following:

Procedure	Comment
Sealing test, 20 kPa internal overpressure	+20 °C
Conditioning to -40 °C	min 24 hour
	-40 °C
	-40 °C
Sealing test, 20 kPa internal overpressure	+20 °C

If one or both caps come loose, the container is not approved.  
 The sealing test to be carried out in accordance with para. 6.5.4.2.  
 In the sealing test, the twin container is regarded as one unit, which implies that approval requires tightness of BOTH tubes.  
 Sampling schedule in accordance with MIL-STD-105 level 1:  
 AQL: 4 %.

Standard sampling for lot size of 501-1200 units.

n	n	c	r
20	20	1	4
20	40	4	5

Reduced sampling may be used after 10 consecutive approved lots during standard sampling.

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Reduced sampling for lot size of 501-1200 units.

n	n	c	r
8	8	0	4
8	16	1	5

If 2,3,or 4 failures are obtained after double reduced testing then standard sampling shall be resumed for the next lot. However, the lot tested shall be approved.

Standard sampling for lot size of 1201-3200 units.

n	n	c	r
32	32	2	5
32	64	6	7

Reduced sampling may be used after 10 consecutive approved lots during standard sampling.

Reduced sampling for lot size of 1201-3200 units.

n	n	c	r
13	13	0	4
13	26	3	6

If 4 or 5 failures are obtained after double reduced testing then standard sampling shall be resumed for the next lot. However, the lot tested shall be approved.

Standard sampling for lot size of 3201-10000 units.

n	n	c	r
50	50	3	7
50	100	8	9

Reduced sampling may be used after 10 consecutive approved lots during standard sampling.

Reduced sampling for lot size of 3201-10000 units.

n	n	c	r
20	20	1	5
20	40	4	7

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If 5 or 6 failures are obtained after double reduced testing then standard sampling shall be resumed for the next lot. However, the lot tested shall be approved.

N.B. Refer to MIL-STD-105 for other lot sizes or AQL values.

**6.5.4 Sealing test**

The following sealing tests shall be performed on a complete twin container containing inert rounds. The test shall be performed at a temperatur of +20 °C ± 5 °C and at least 2 minutes after the specified pressure has been reached.

**6.5.4.1 Sealing test, external overpressure.**

The twin container is immersed in water in an enclosed vessel after which the air pressure in the vessel is increased by 20 kPa (0,2 bar). There shall be no ingress of water into the container.

**6.5.4.2 Sealing test, internal overpressure.**

Alternative 1:

The twin container is immersed in water in a transparent enclosed vessel after which the air pressure in the vessel is reduced by 20 kPa (0,2 bar). There shall be no egress of air from the container.

Alternative 2:

The test is performed by drilling a hole in the wall of the twin container and an overpressure of 20 kPa (0,2 bar) is applied, after which the container is immersed in water.

There shall be no egress of air from the container.

In the sealing test, the twin container is regarded as one unit, which implies that approval requires tightness of BOTH tubes.

Sampling schedule in accordance with MIL-STD-105 level 1:

AQL: 0,65 %.

Standard sampling for lot size of 501-1200 units.

n	n	c	r
20	20	0	1
-	-	-	-

Reduced sampling may be used after 10 consecutive approved lots during standard sampling.

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Reduced sampling for lot size of 501-1200 units.

n	n	c	r
20	20	0	2
20	40	0	2

If 1 failure is obtained after double reduced testing then standard sampling shall be resumed for the next lot. However, the lot tested shall be approved.

Standard sampling for lot size of 1201-3200 units.

n	n	c	r
50	50	0	2
50	100	1	2

Reduced sampling may be used after 10 consecutive approved lots during standard sampling.

Reduced sampling for lot size of 1201-3200 units.

n	n	c	r
20	20	0	2
20	40	0	2

If 1 failure is obtained after double reduced testing then standard sampling shall be resumed for the next lot. However, the lot tested shall be approved.

Standard sampling for lot size of 3201-10000 units.

n	n	c	r
50	50	0	2
50	100	1	2

Reduced sampling may be used after 10 consecutive approved lots during standard sampling.

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Reduced sampling for lot size of 3201-10000 units.

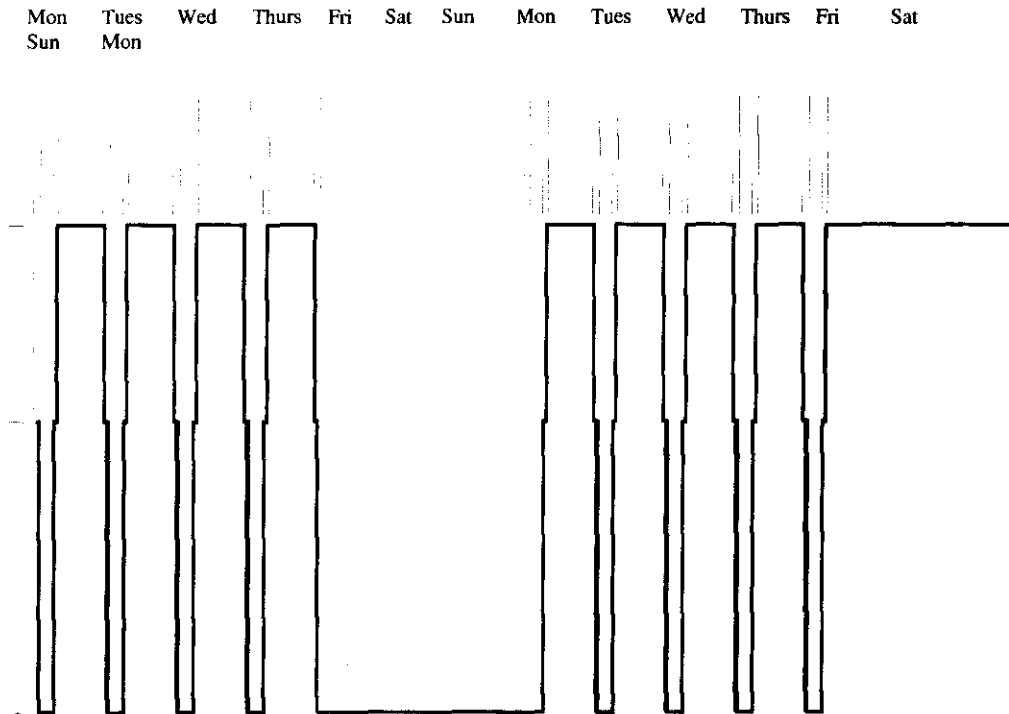
n	n	c	r
20	20	0	2
20	40	0	2

If 1 failure is obtained after double reduced testing then standard sampling shall be resumed for the next lot. However, the lot tested shall be approved.

N.B. Refer to MIL-STD-105 for other lot sizes or AQL values.

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**Climate cycle**



Item	Hour of the day	Actions
1	08.00	Before the test starts, keep the test object for minimum 1 hour at room temperature, +21 °C until 09.00.
2	09.00	Place the test object in a climate chamber at -54 °C until 15.00.
3	15.00	Remove the test object and keep it at room temperature, +21°C until 16.00.
4	16.00	Place the test object in a climate box at +71 °C and 95 % RH until 08.00 the following day.
5		Repeat the cycle from item 1 for 3 days.
6	08.00	Remove the test object and keep it at room temperature, +21 °C, until 09.00.
7	09.00	Place the test object in a climate chamber at -54 °C until 15.00 until following monday.
8	15.00	Remove the test object and keep it at room temperature, +21 °C, until 16.00.
9	16.00	Place the test object in a climate chamber at +71 °C and 95 % RH, until 08.00 the following day.
10	08.00	Remove the test object and keep it at room temperature, +21 °C until 09.00.
11		Repeat the cycle from item 7 during 3 days.
12	09.00	Place the test object in a climate chamber at -54 °C until 15.00.
13	15.00	Remove the test object and keep it at room temperature, +21 °C until 16.00.
14	16.00	Place the test object in a climate chamber at +71 °C and 95 % RH for 64 hours (2 days and 16 hours, until 08.00).

**FFV Ordnance AB****TEKNISK BESTÄMMELSE**  
**TECHNICAL SPECIFICATION**

15 (15)

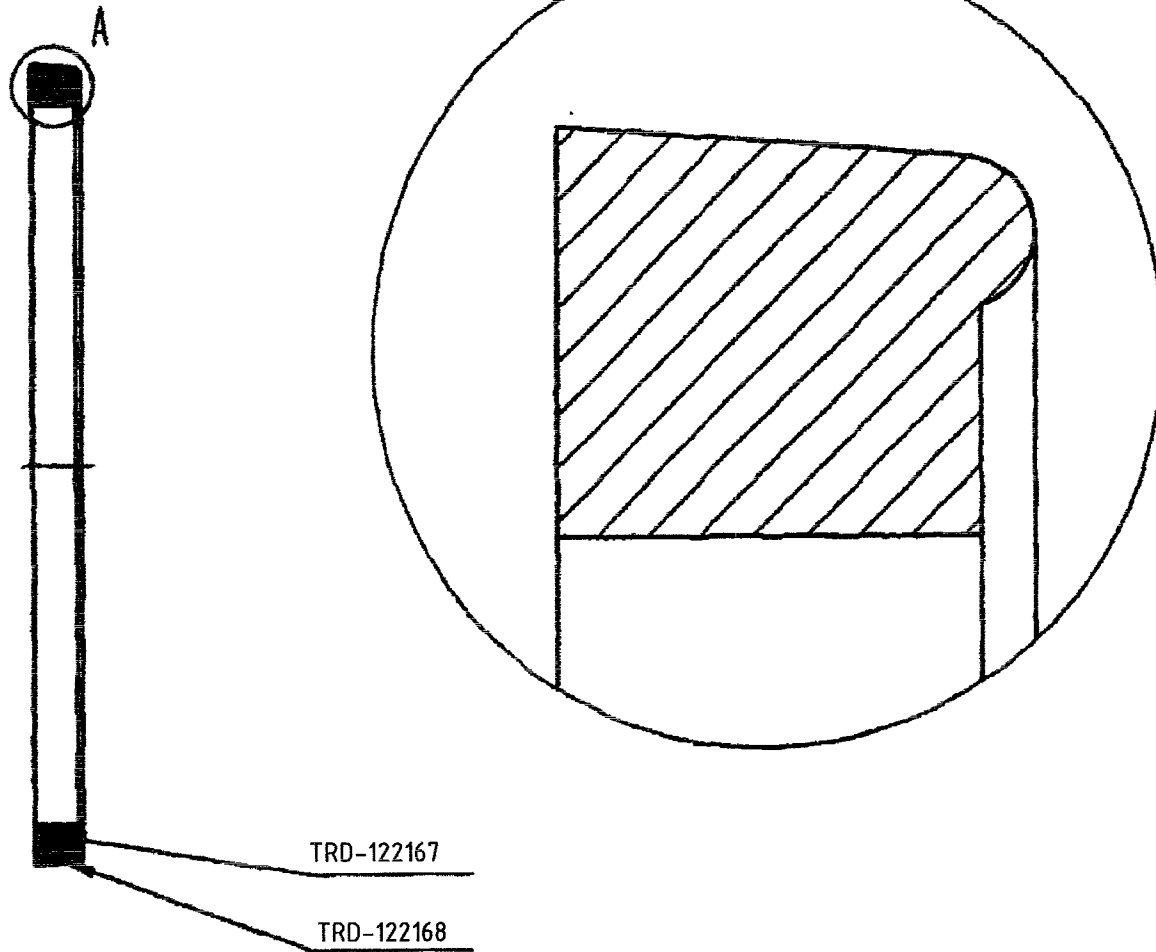
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TRD-122166

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TB O 802 826

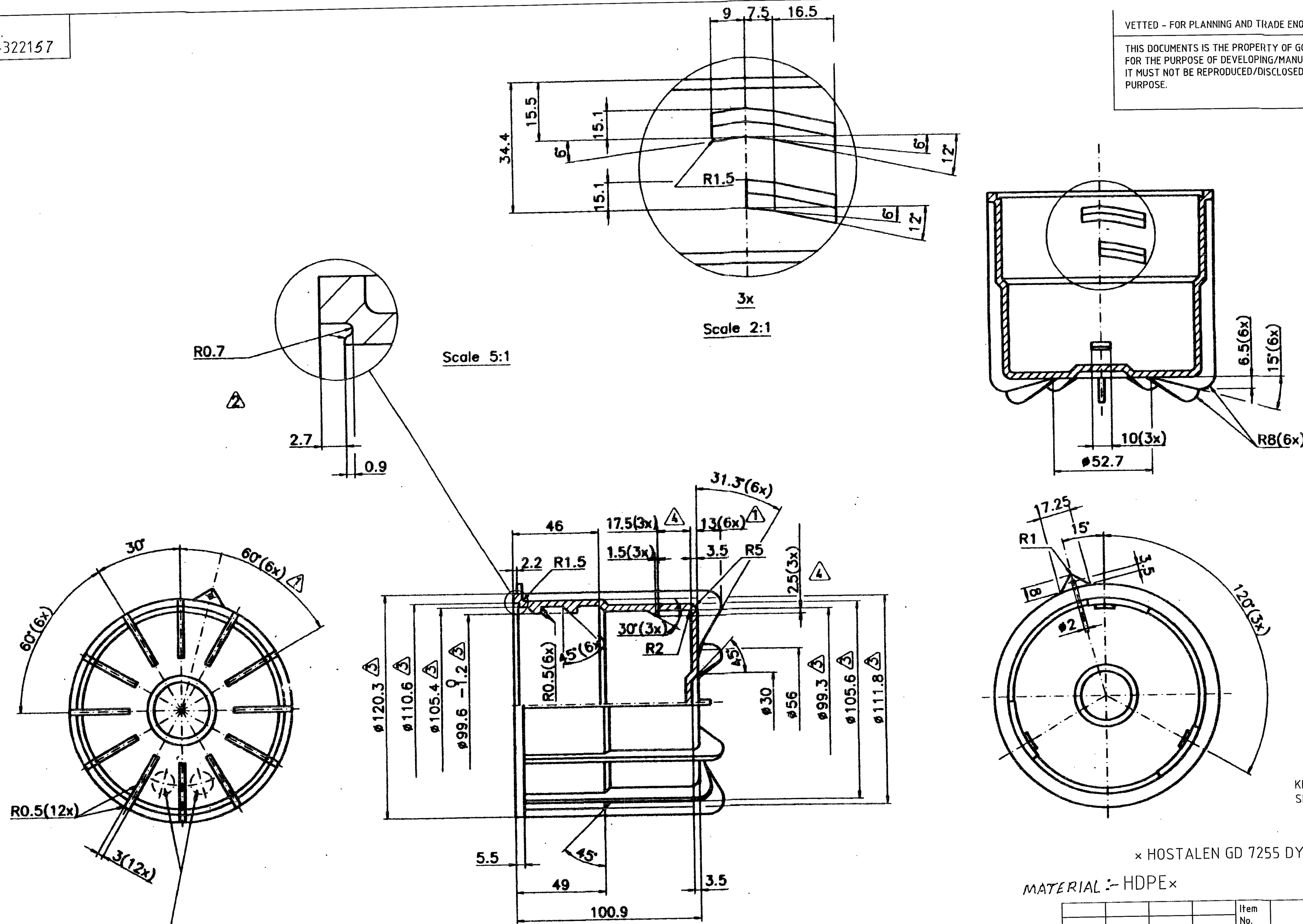
TS O 802 826

				Item No.	DESCRIPTION	No. off	MATERIAL
Insp.	Date	JWM/ CDO	DA No	Heat Treatment Rc.-		GREASED RING	
Amendments				▽ 12.5-25 Ra	▽▽▽ 0.2-0.8 Ra	M/C	
JWM/ R&D				▽▽ 1.6-6.3 Ra	▽▽▽▽ 0.1-0.025 Ra	M/C	
HOS/ CDO	<i>[Signature]</i>	DATE	29.11.07	DIMENSIONS ARE IN mm.		Drg. No. TRD-122166	
CKD	<i>[Signature]</i>	CKD		UNTOL. DIMNS. IS:2102 MEDIUM		SCALE:- 10:1	
DRN	<i>[Signature]</i>	TRD		SHARP EDGES TO BE REMOVED		No. of sheets - 01	
Approved by <i>[Signature]</i> (R&D)				ORDNANCE FACTORY KHAMARIA		Sheet No. - 01	
PS/GS.				Store :-		Compt.:-	
				Drg.No.			

DRG.No.  
TRD-322157

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Date clock: Hasco Z483/12,Z482/12

SURFACE: Ra 1.25 Flat  
TOLERANCES: Plastic part DIN 16901 level B140

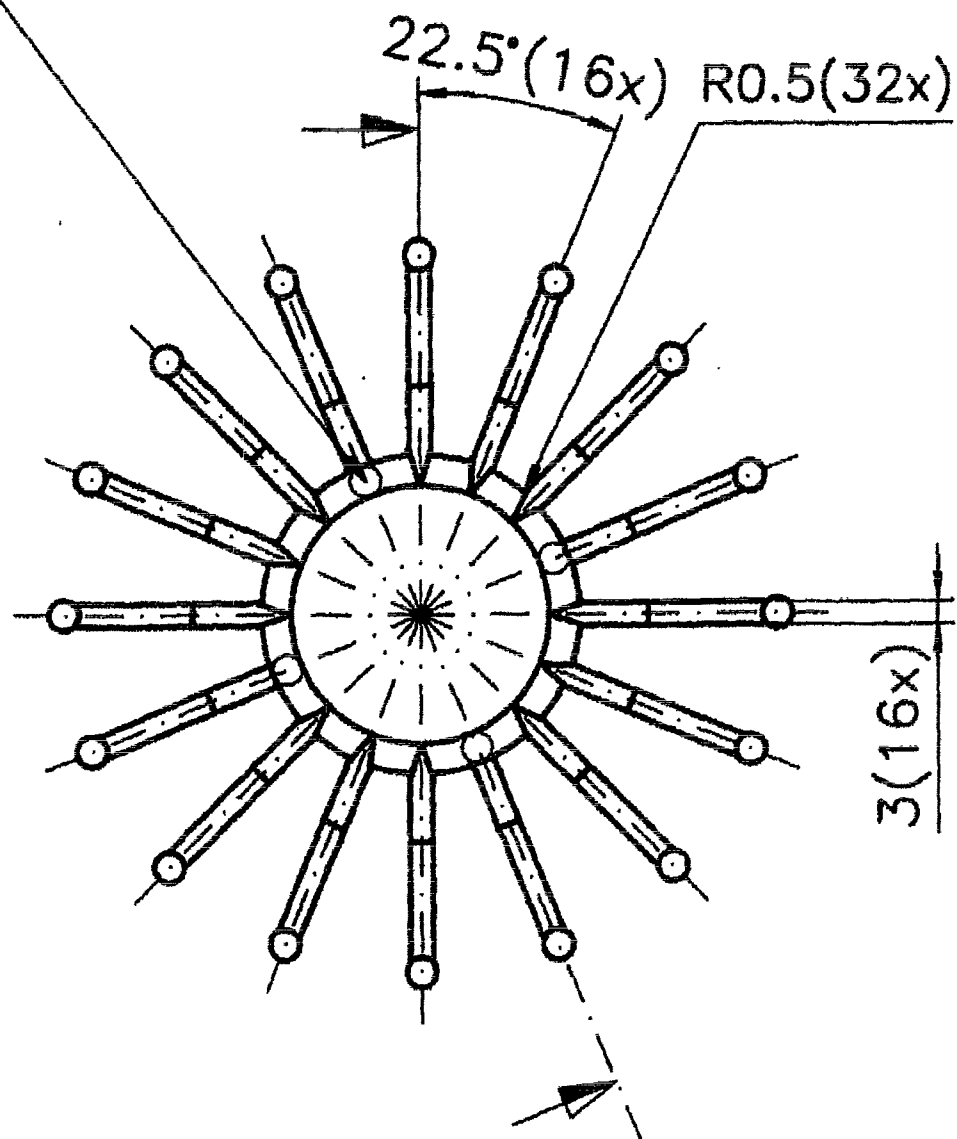
KNOCKOUT PIN MARKS AND SPRUE MARKS PERMISSIBLE

MATERIAL :- HDPE x  
x HOSTALEN GD 7255 DYED GREEN TO BS381C No.285

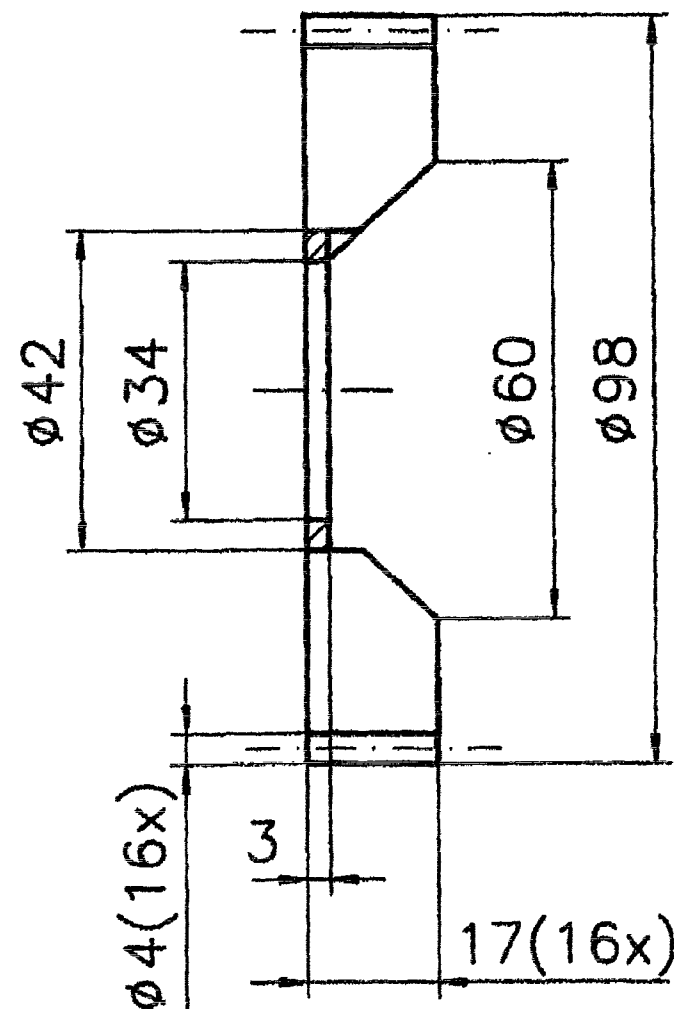
Insp.	Date	JWM/CDO	DA No	Item No.	DESCRIPTION	No. off	MATERIAL
					Heat Treatment Rc.-		CAP
Amendments				▽	125-25 Ra	▽▽▽	0.2-0.8 Ra
JWM/R&D				▽▽	1.6-6.3 Ra	▽▽▽▽	0.1-0.025 Ra
HOS/CDO			DATE 29.1.07	DIMENSIONS ARE IN mm.			M/C
CKD			CKD	UNTOL. DIMNS. IS:2102 MEDIUM			Drg. No. TRD-322157
DRN			TRD	SHARP EDGES TO BE REMOVED			SCALE:- 1:1
Approved by J4. (MTR) (KRD)				Gauging surfaces shown by thick line			No. of sheets - 01 Sheet No. - 01
PS/GS.				ORDNANCE FACTORY KHAMARIA			Compt.- DRG No.- 03067932
				Store :- 84 mm Heat 551			
				Drg.No.			

DRG.No.  
TRD-222160

Openings for eject pins are allowed (4x)



Knockout pin marks and sprue marks permissible



MATERIAL :- HDPE

General tolerances  
DIN 16901 level B140

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Insp.	Date	JWM/ CDO	DA No	Item No.	DESCRIPTION	No. off	MATERIAL
					Heat Treatment Rc.-		REAR CUSHION
					Amendments		M/C
JWM/ R&D					∇2.5-25 Ra 0.2-0.8 Ra		Drg. No. TRD-222160
HOS/ CDO			DATE 29.1.07		∇6.3 Ra 0.1-0.25 Ra		SCALE:- 10:1
CKD			CKD		DIMENSIONS ARE IN mm. UNTOL. DIMNS. IS:2102 MEDIUM		No. of sheets - 01 Sheet No. - 01
DRN			TRD		SHARP EDGES TO BE REMOVED Gauging surfaces shown by thick line		
Approved by J+GM (R&D)					ORDNANCE FACTORY KHAMARIA		
PS/GS.					Store :- Drg.No.		Compt.:- DRG.No.- 5212496

TO BE MARKED ON TOOL/GAUGE/PART  
TRD-422155

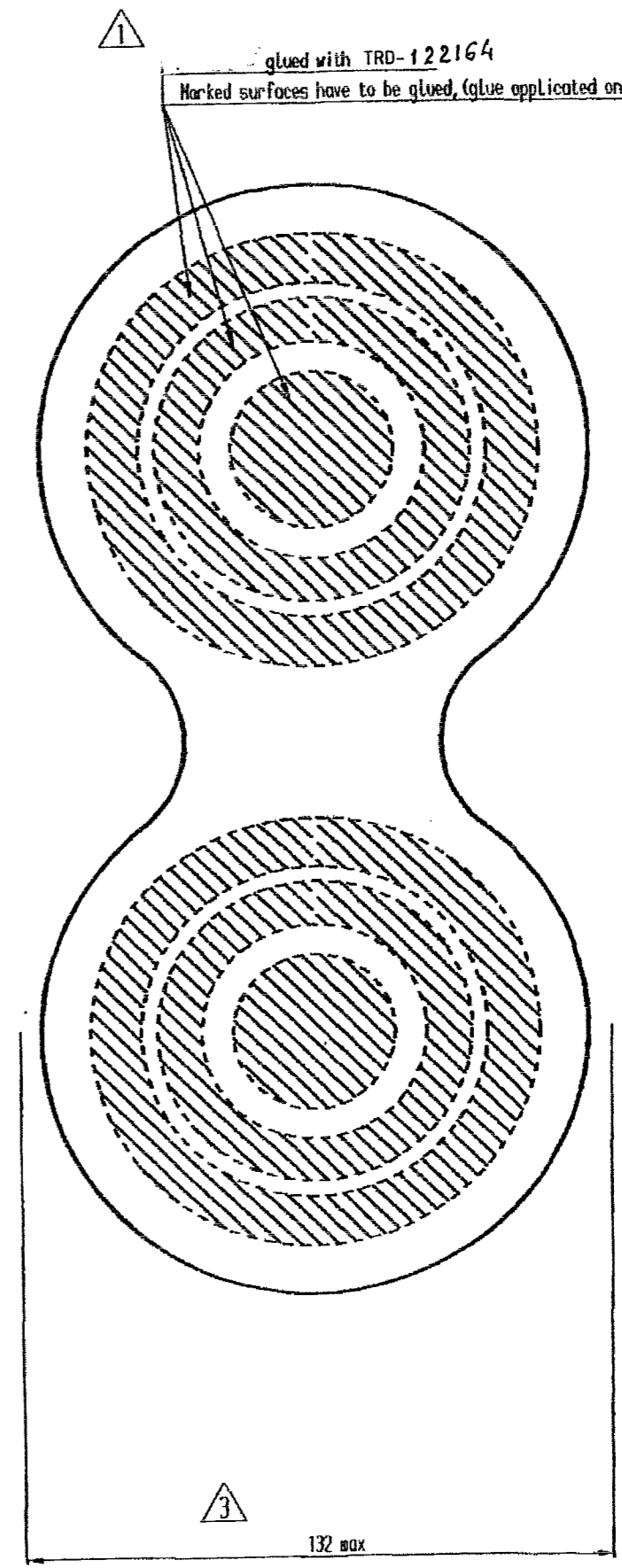
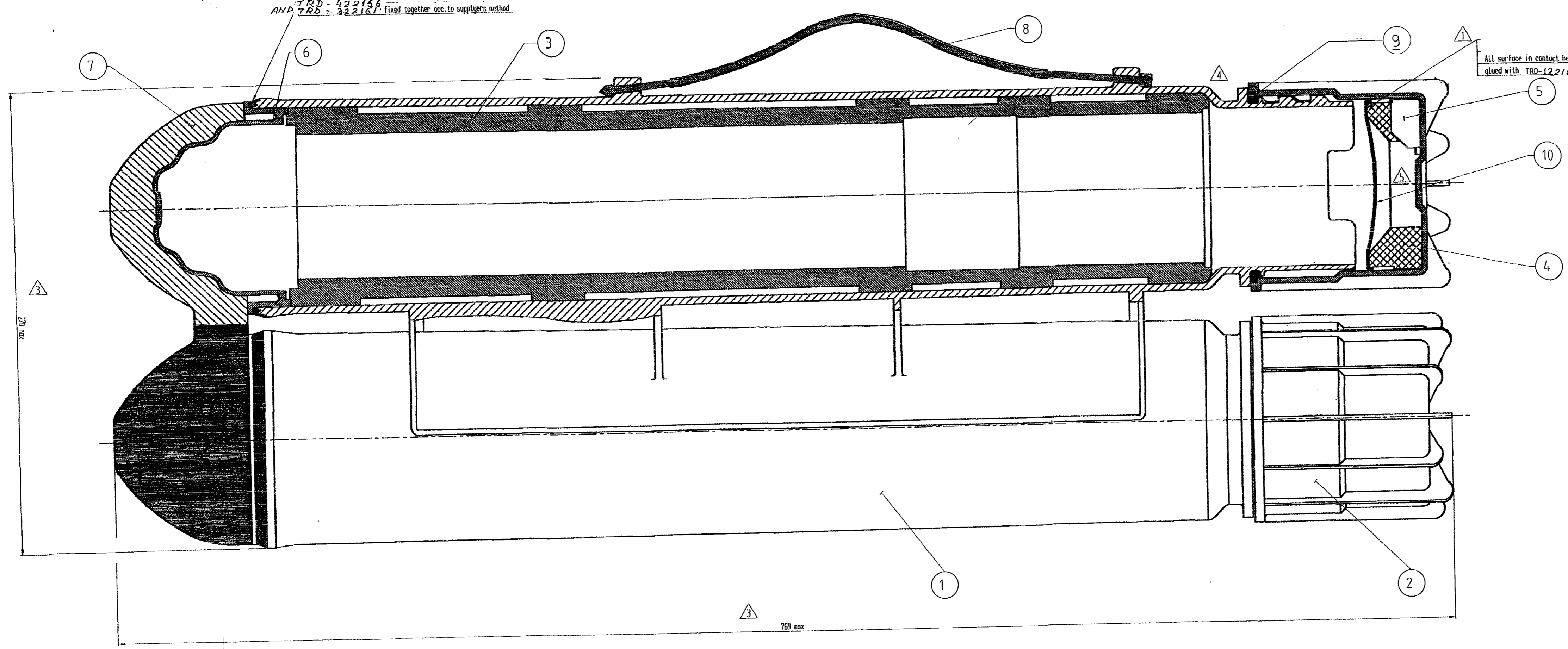
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TRD-422156  
AND TRD-322167 fixed together acc. to suppliers method

All surface in contact between TRD- 222159  
glued with TRD-122164

glued with TRD-122164  
Hatched surfaces have to be glued, glue applied on TRD-322161



Before mounting the cap, it shall be visually inspected through the inspection hole in the supporting member TRD-122162 to ensure the presence of rear cushion TRD-222160

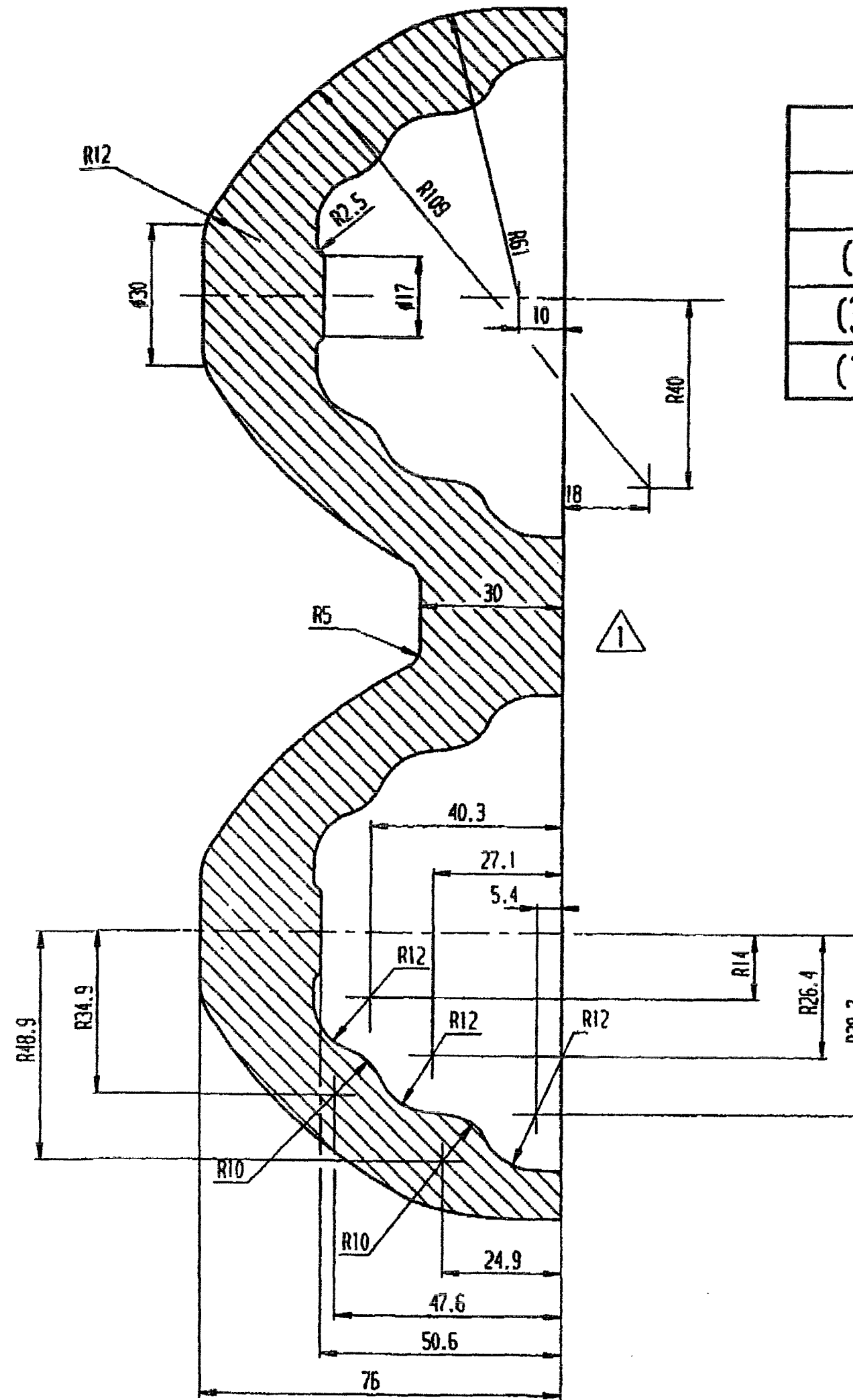
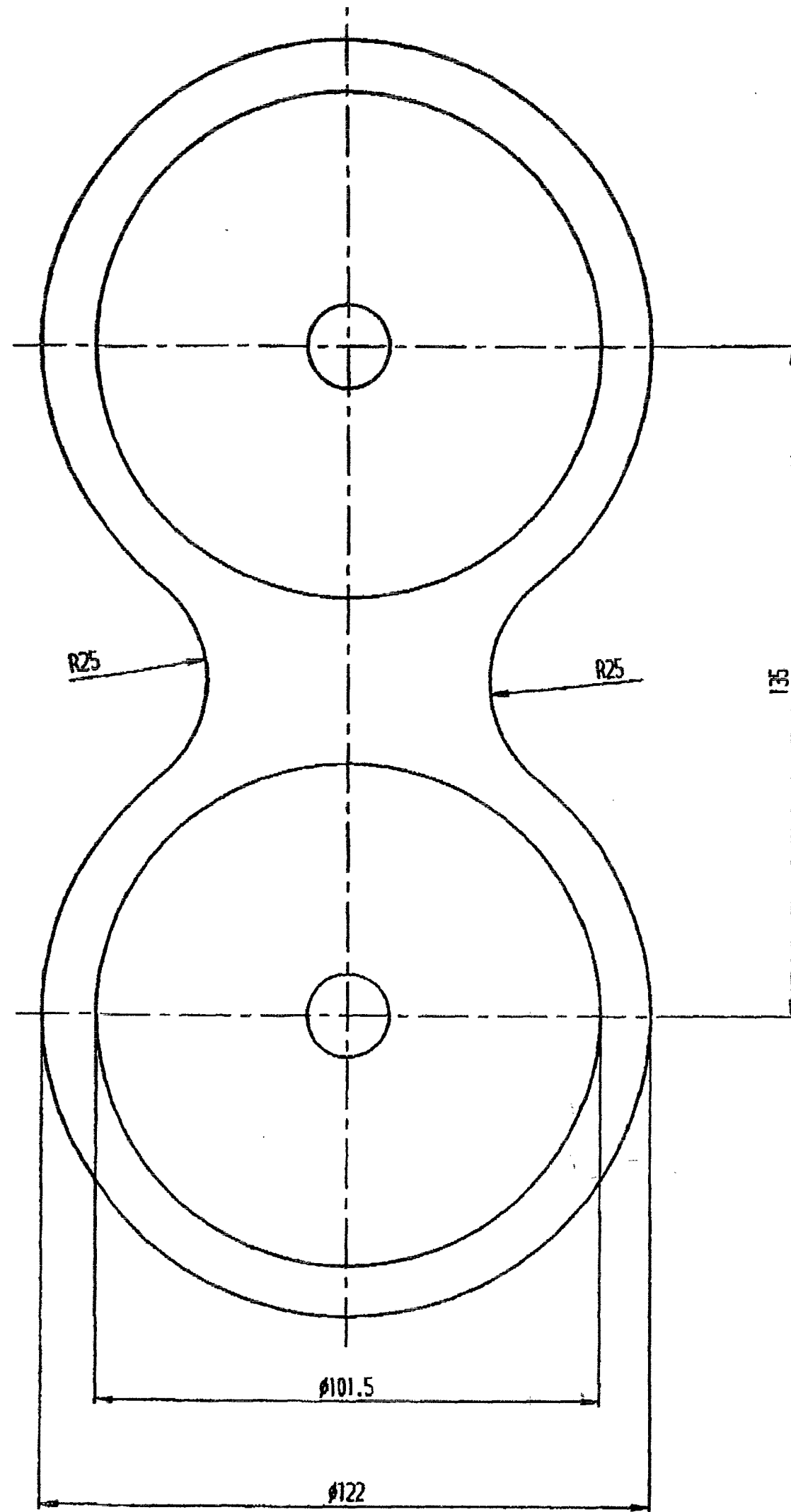
TB 0 816 199  
TS 0 816 199

ITEM No.	DESCRIPTION	No. OFF	MATERIAL
10	SUPPORT DISC	2	TRD-122165
9	GREASED RING	1	TRD-122166
8	HANDLE		TRD-322163
7	SHOCK ABSORBER		TRD-322162
6	NOSE 520:9	2	TRD-322161
5	REAR CUSHION	2	TRD-222160
4	BLOCK	2	TRD-222159
3	PACKAGE INSERT	4	TRD-322158
2	CAP		TRD-322157
1	TWIN TUBE 520:9		TRD-422156

INSP.	DATE	HOS/CDG	DA No	HEAT TREATMENT Rc.	ITEM No.	DESCRIPTION	No. OFF	MATERIAL
				125-25 Ra		TWIN CONTAINER		
				16-63 Ra		520:9		
				0.2-0.8 Ra				
				0.1-0.025 Ra				
AMENDMENTS				DIMENSIONS ARE IN mm.				
JWM/				UNTOL. DIMNS. IS 2102 MEDIUM				
HOS/				SHARP EDGES TO BE REMOVED				
CAD/C				GAUGING SURFACES SHOWN BY THICK LINES				
CKD				ORDNANCE FACTORY KHAMARIA				
DRN				No. OF SHT. -				
APPROVED BY				SHEET No. -				
PS/GS.				STORE--				
				DRG. No.				
				COMPT. DRG.No.				

REF DRG. NO - 0203239B

DRG.No.  
TRD-322162



TOLERANSER	
Basmått	Epp 55-70 g/L
(3) - 30	± 0.5
(30) - 140	± 1.0
(140) -	± 1.5

MATL. - EPP 60g/L

Färg: Svart

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Insp.	Date	JWM/ CDO	DA No	Item No.	DESCRIPTION	No. off	MATERIAL
					Heat Treatment Rc.-		SHOCK ABSORBER
Amendments				▽	12.5-25 Ra	▽▽▽	0.2-0.8 Ra
JWM/ R&D	<i>Dah</i>			▽▽	16-6.3 Ra	▽▽▽▽	0.1-0.025 Ra
HOS/ CDO	<i>Qn</i>	DATE	29.1.07	DIMENSIONS ARE IN mm.			
CKD	<i>Stred</i>	CKD		UNTOL. DIMNS. IS:2102 MEDIUM			
DRN	<i>TR</i>	TRD		SHARP EDGES TO BE REMOVED			
Approved by <i>J. M. CTR (R&amp;D)</i>				Gauging surfaces shown by thick line			
				ORDNANCE FACTORY KHAMARIA			
PS/GS.				Store :-		Compt.:-	
				Drg.No.		DRG.No.- 4107818	

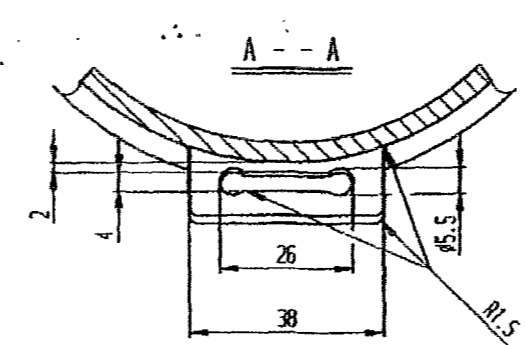
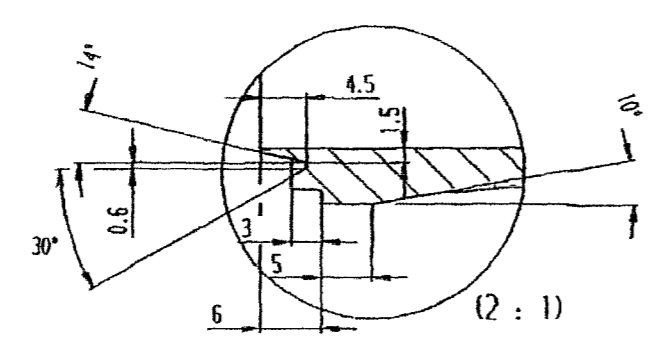
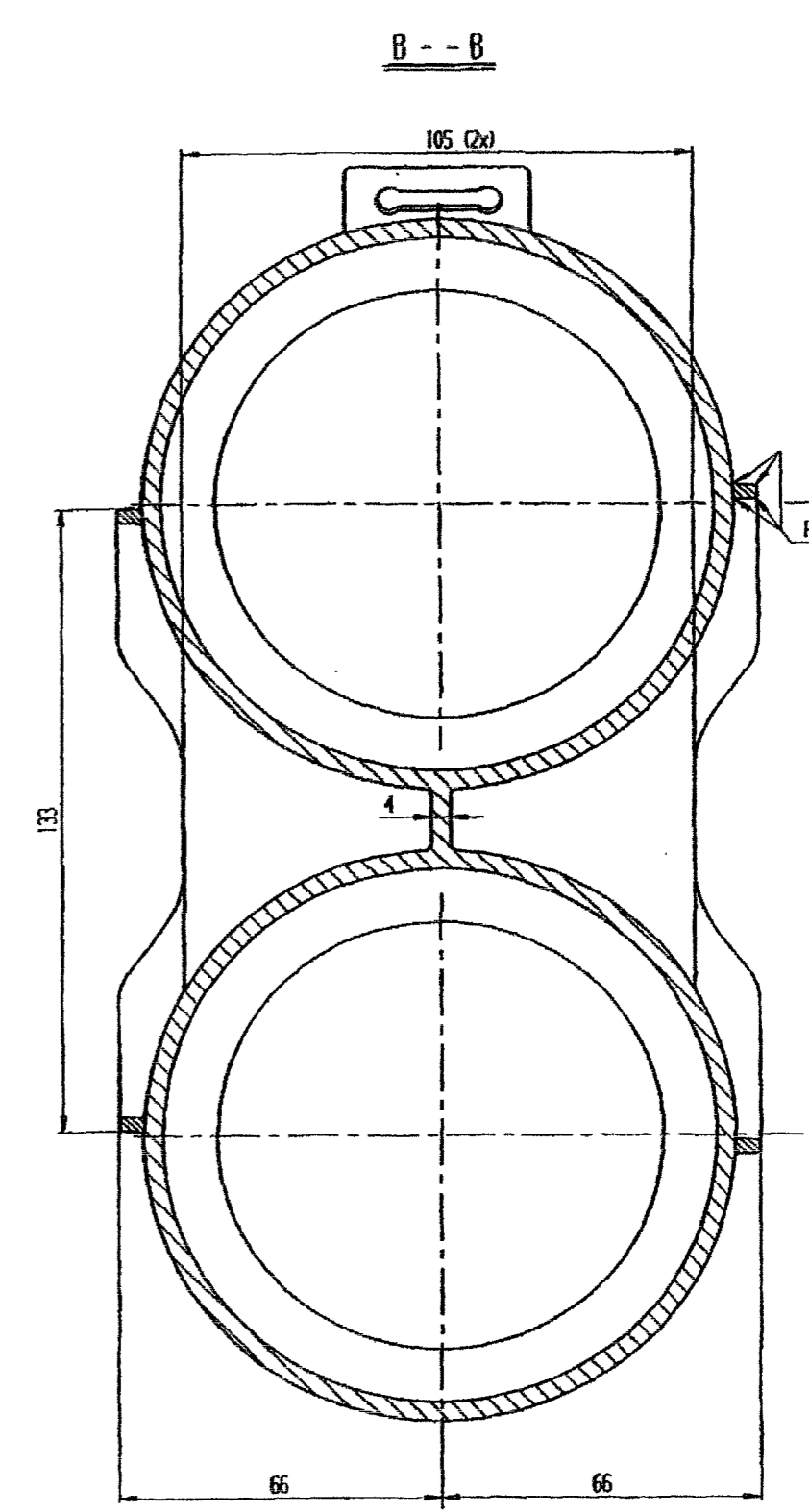
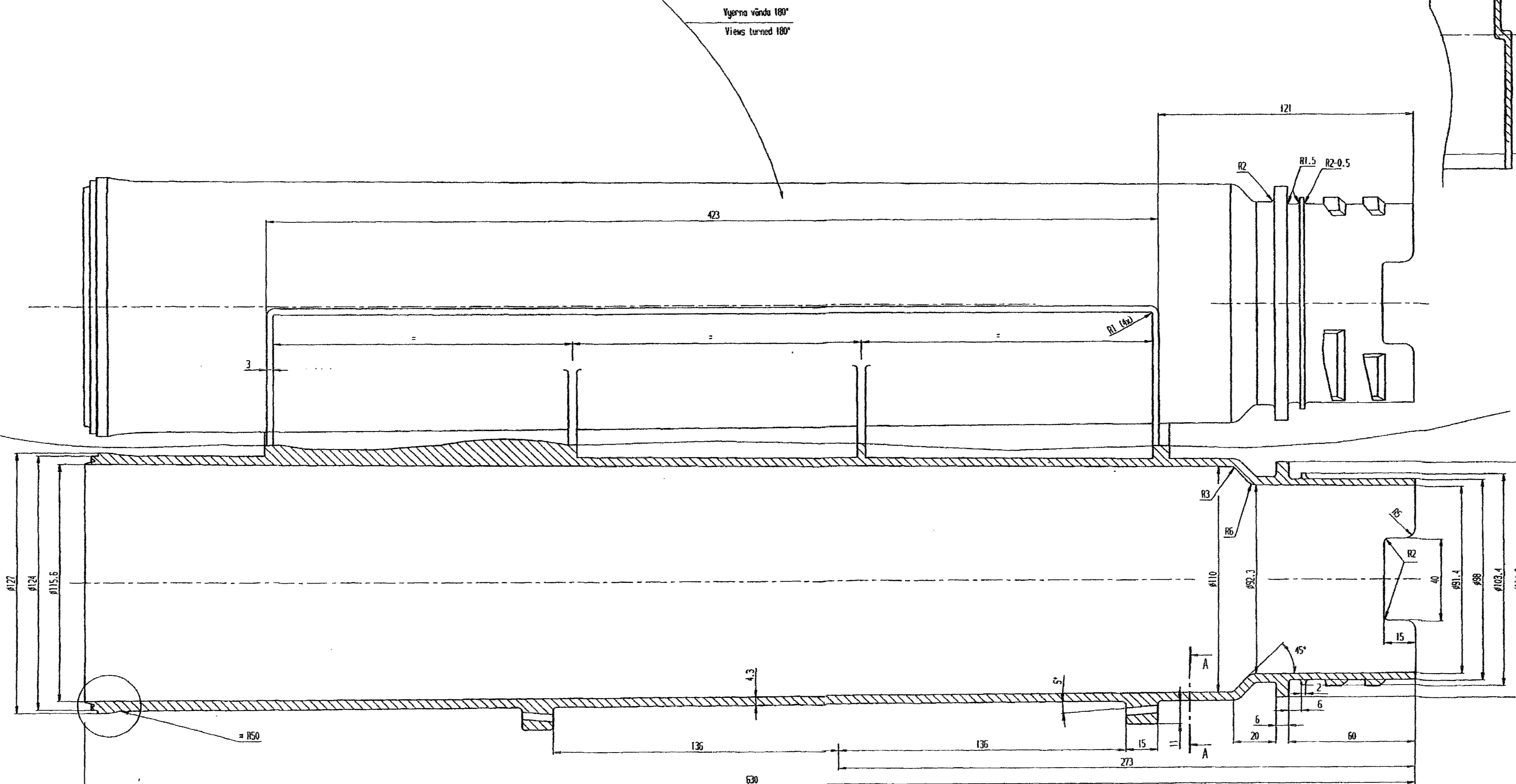
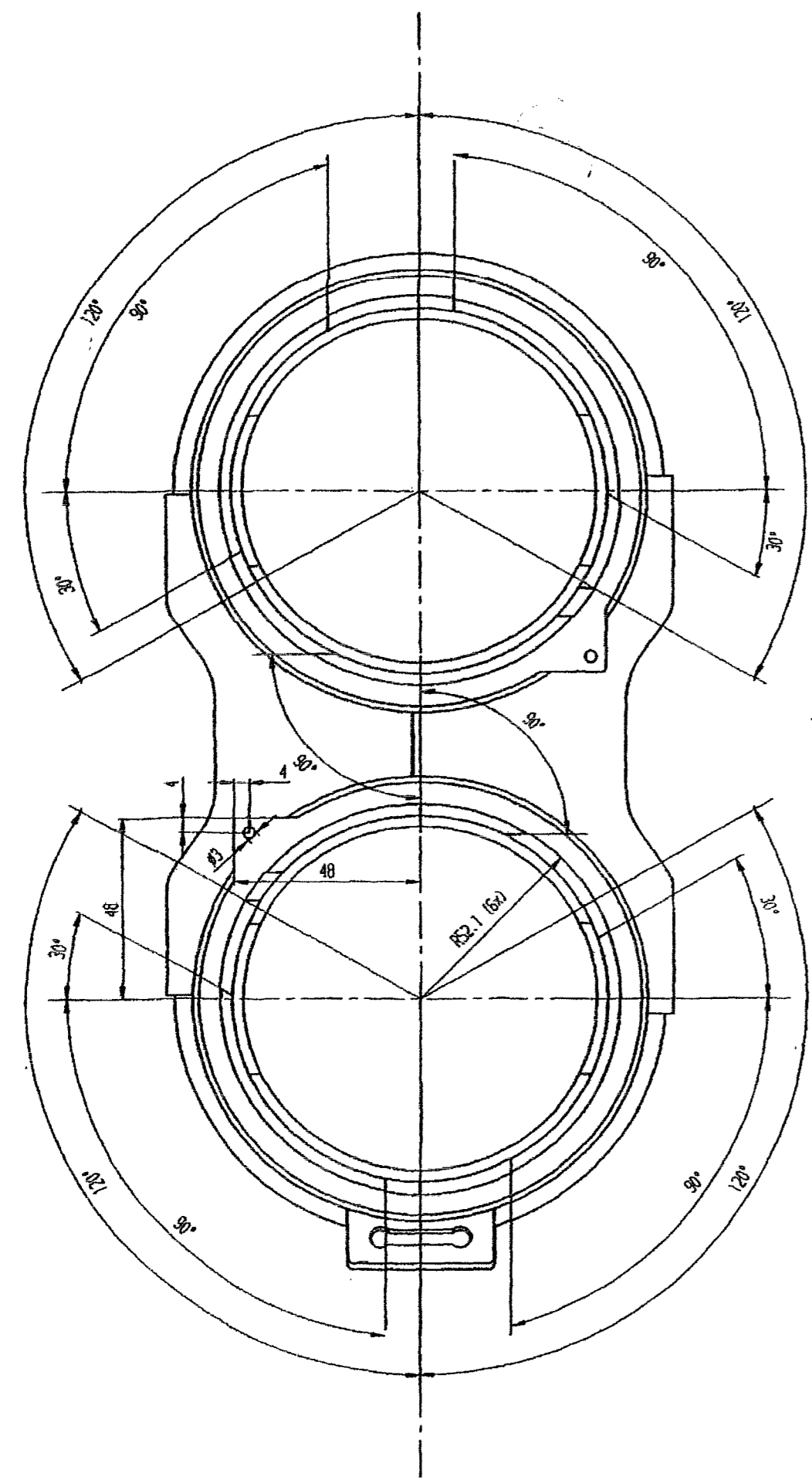
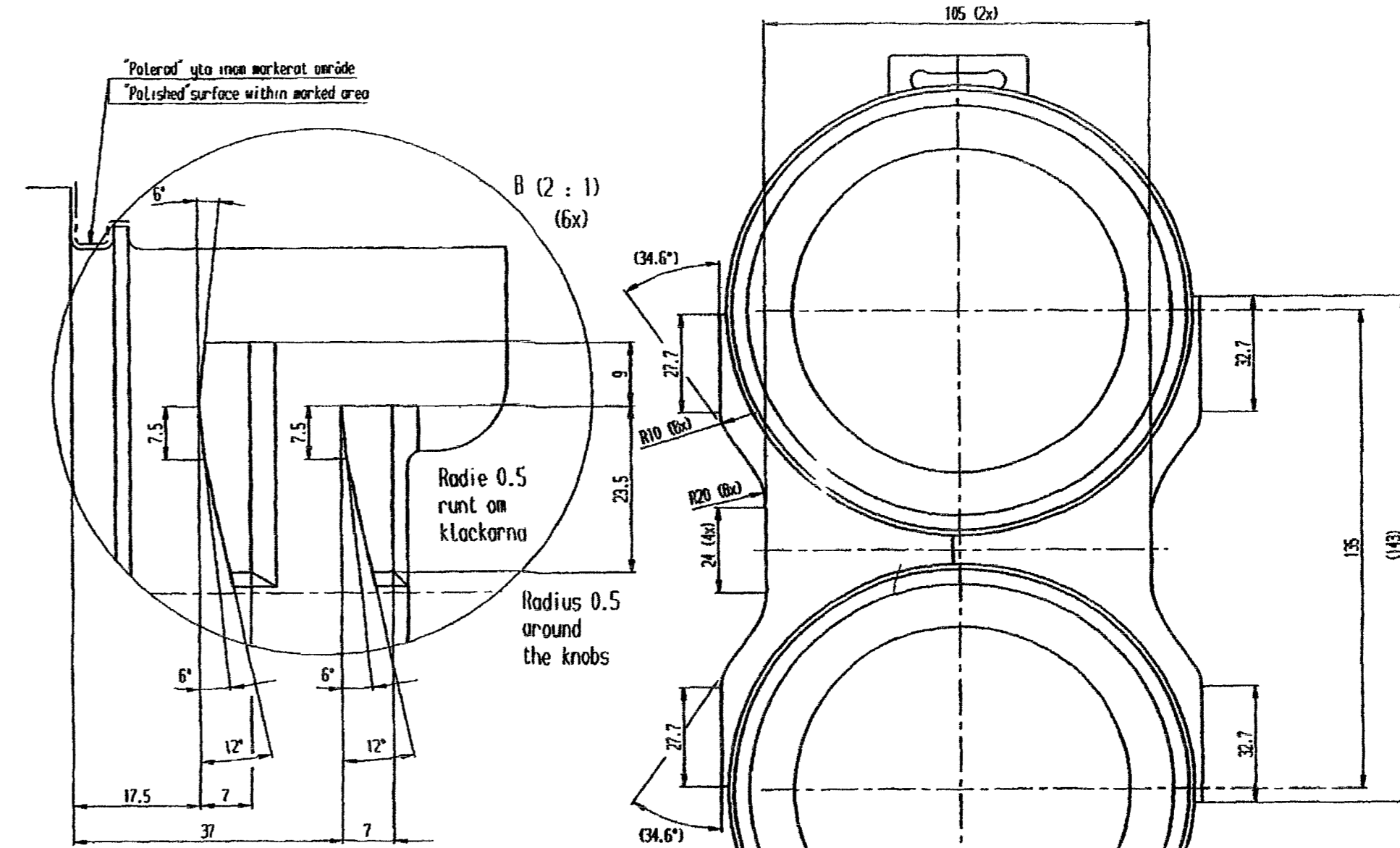
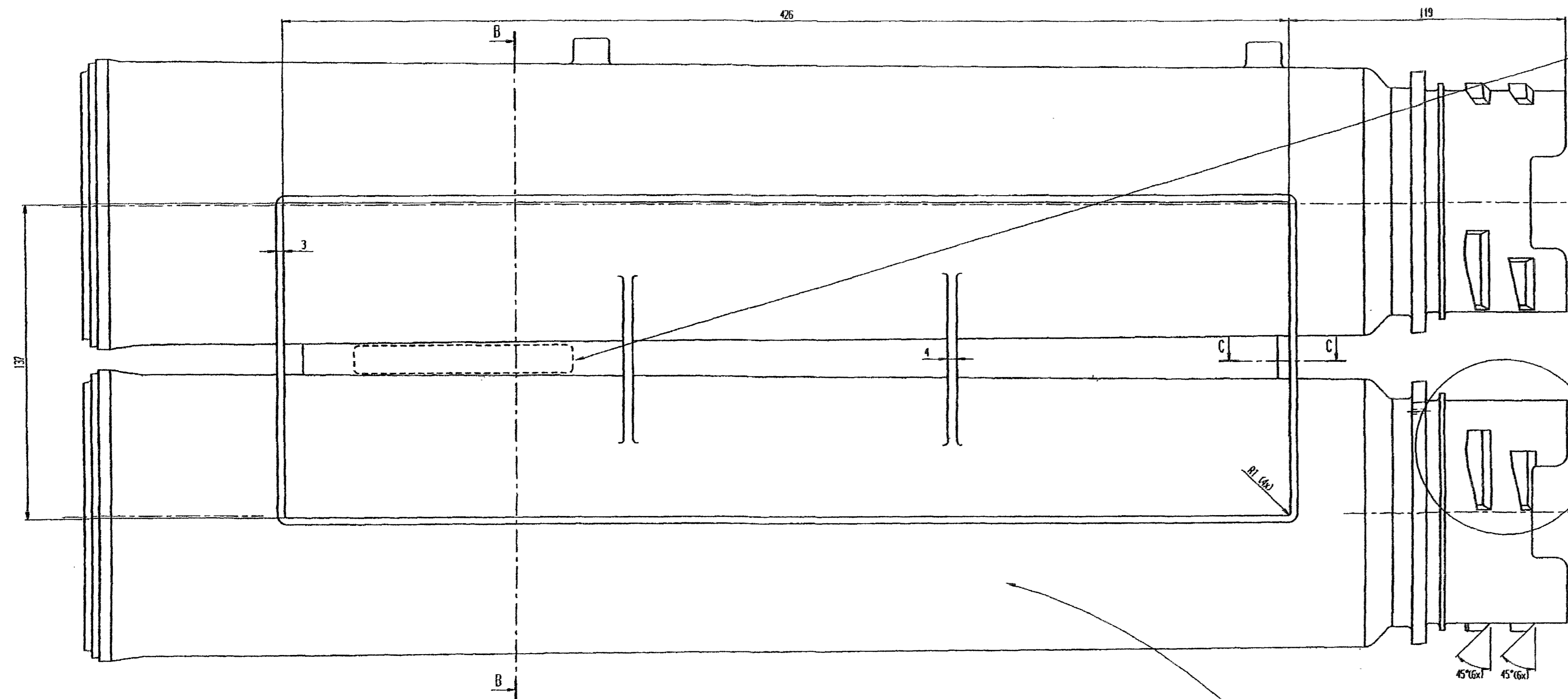
Drg. No.  
TRD-322162

No. of sheets - 01  
Sheet No. - 01

SCALE:-  
1:1

REF. DRG. NO. 4107818

DRG.No.  
TRD-422156



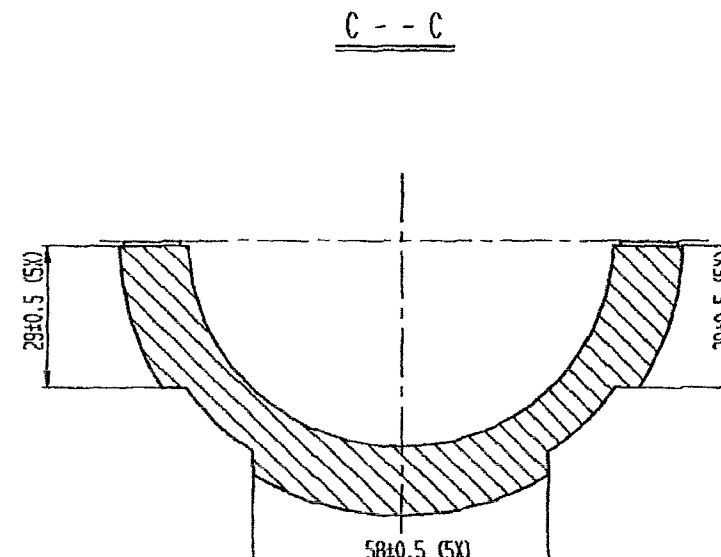
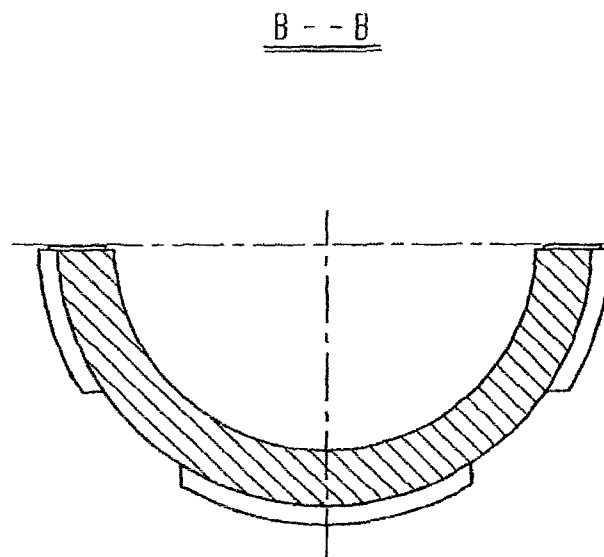
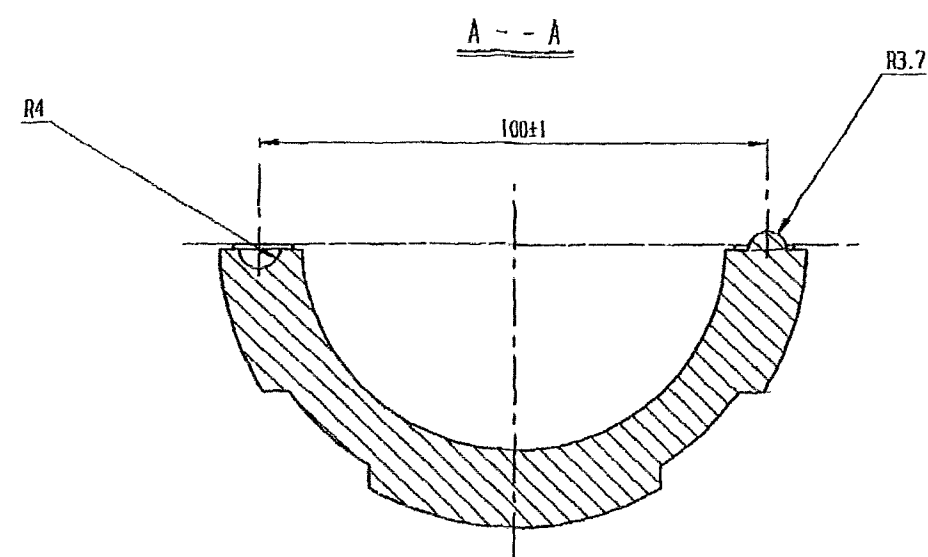
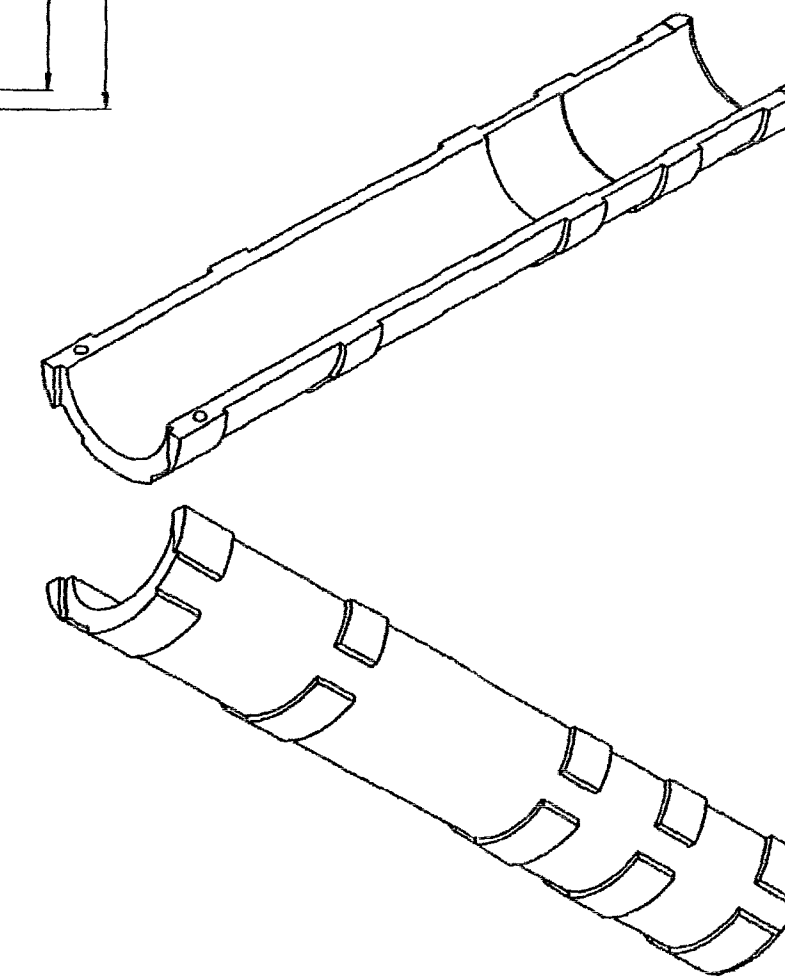
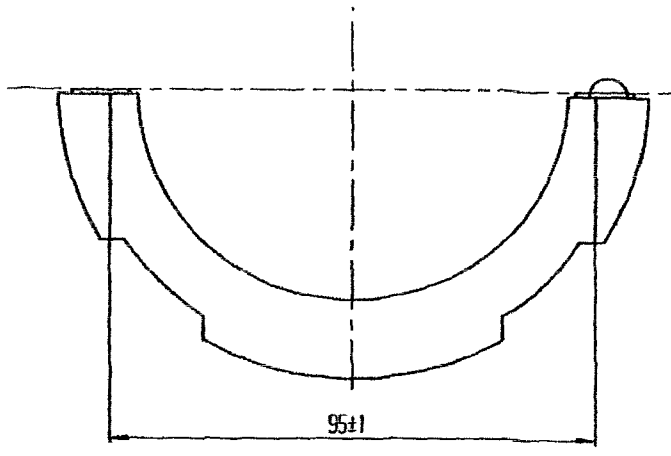
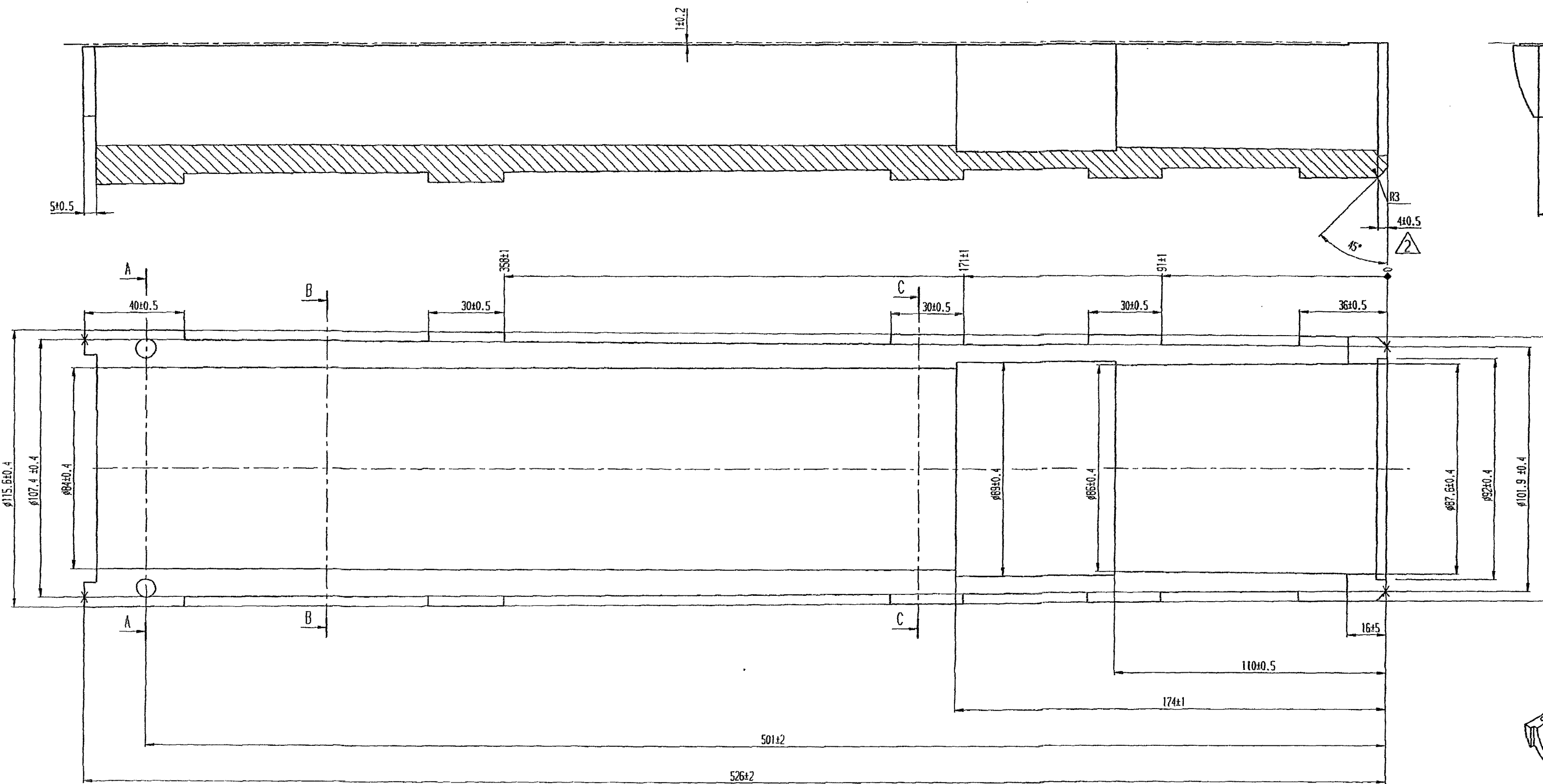
\* Material: EN 725 40d green to BS30C No. 205  
Utvinding g/struktur 30-75 (Kjæm 4, p. 3.8)  
\*\* Toleranser: Plastdetaljer: DIN 15001 nivå B140  
Toleranser: Plast: p/15: DIN 15001 Level B140  
Slippingsvinkler der ej annat angives 2-3°  
Angle of clearance where otherwise not stated: 2-3°

MATERIAL :- HDPE

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Insp.	Date	JWM/ CDO	DA No	Item No.	DESCRIPTION	No. of off	MATERIAL
					Heat Treatment Rc:-		TWIN TUBE 520-9
					▽ 125-25 Ra	▽ 0.2-0.8 Ra	
					▽ 16-63 Ra	▽ 0.1-0.025 Ra	M/C
Amendments				DIMENSIONS ARE IN mm.			
JWM/ R&D				UNTOL. DIMNS. IS: 2102 MEDIUM			
HOS/ CDO				SHARP EDGES TO BE REMOVED			
CKD				Gauging surfaces shown by thick line			
DRN - JWM				ORDNANCE FACTORY KHAMARIA			
Approved by: JWM				No. of sheets - 01			
PS/GS.				Sheet No. - 01			
				Store :- 84 mm Heat 551			
				Compt.:- DRG No. - 02032317			

DRG.No.  
TRD-322158



MATERIAL - EPP 55g/L

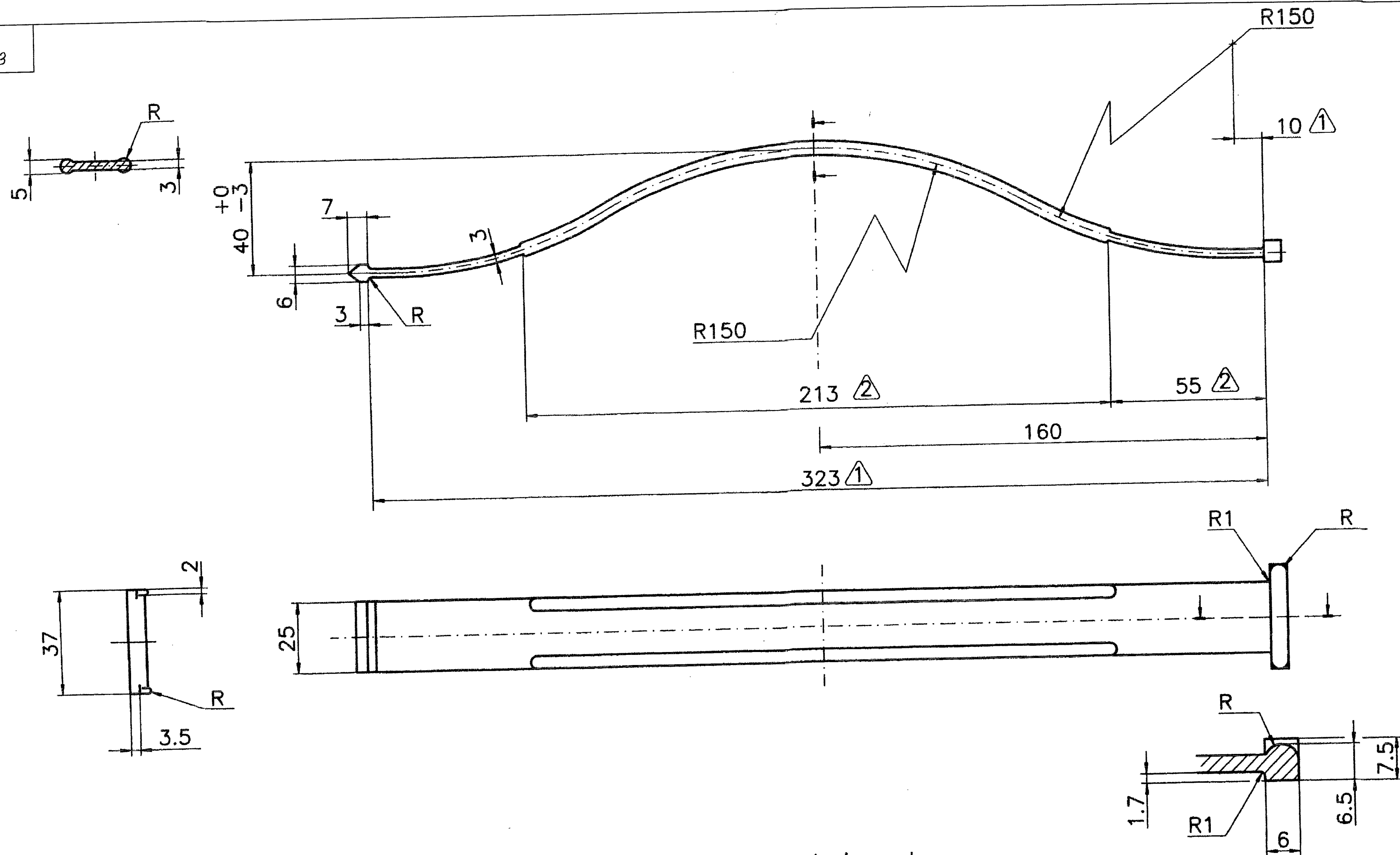
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Insp.	Date	JWM/ CDO	DA No	Item No.	DESCRIPTION	No. off	MATERIAL
					Heat Treatment Rc.-		PACKAGE INSERT
					Amendments		
					▽ 12.5-25 Ra	▽ 0.2-0.8 Ra	
					▽ 1.6-6.3 Ra	▽ 0.1-0.025 Ra	M/C
					DIMENSIONS ARE IN mm.		Drg. No.
					UNTOL. DIMNS. IS:2102 MEDIUM		TRD-322158
					SHARP EDGES TO BE REMOVED		SCALE:-
					Gauging surfaces shown by thick line		10:1
					Approved by: JGM (R&D)		No. of sheets - 01
					ORDNANCE FACTORY KHAMARIA		Sheet No. - 01
					PS/GS.		Compt.:-
					Store :-		DRG.No. - 3070432
					Drg.No.		

REF. DRG. NO. 03070432

DRG.No.  
TRD-322163



Knockout pin marks  
and sprue marks per-  
missible

Scale 2:1

**MATERIAL- HDPE\***  
\*Hostalen GD 7255 dyed green to BS381C No. 285

General tolerances  
DIN 16901 level B140

Insp.	Date	JWM/ CDO	DA No	Item No.	DESCRIPTION	No. off	MATERIAL
					Heat Treatment Rc.-		HANDLE
					Amendments		
					▽ 12.5-25 Ra	▽▽ 0.2-0.8 Ra	
					▽ 1.6-6.3 Ra	▽▽▽ 0.1-0.025 Ra	M/C
JWM/ R&D					DIMENSIONS ARE IN mm.		Drg. No.
HOS/ CDO			DATE 29.1.07		UNTOL. DIMNS. IS:2102 MEDIUM		TRD-322163
CKD			CKD		SHARP EDGES TO BE REMOVED		SCALE:- 1:1
DRN			TRD		Gauging surfaces shown by thick line		No. of sheets - 01
					ORDNANCE FACTORY KHAMARIA		Sheet No. - 01
				Approved by Jt. Com. (R&D)	Store :- 84 mm Heat SS1		Compt.:-
				PS/GS.	Drg.No.		DRG.No.- 4103480

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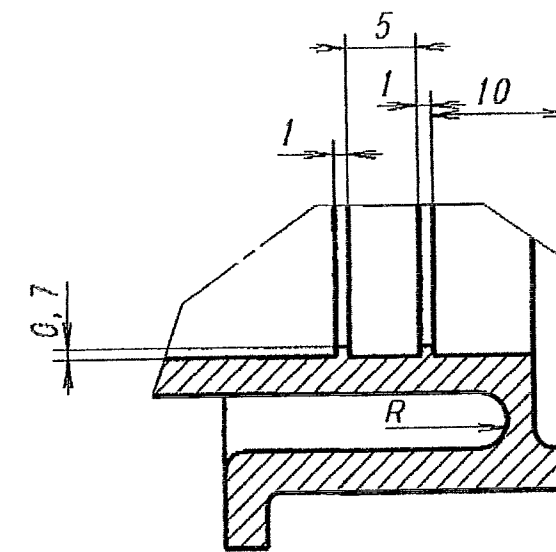
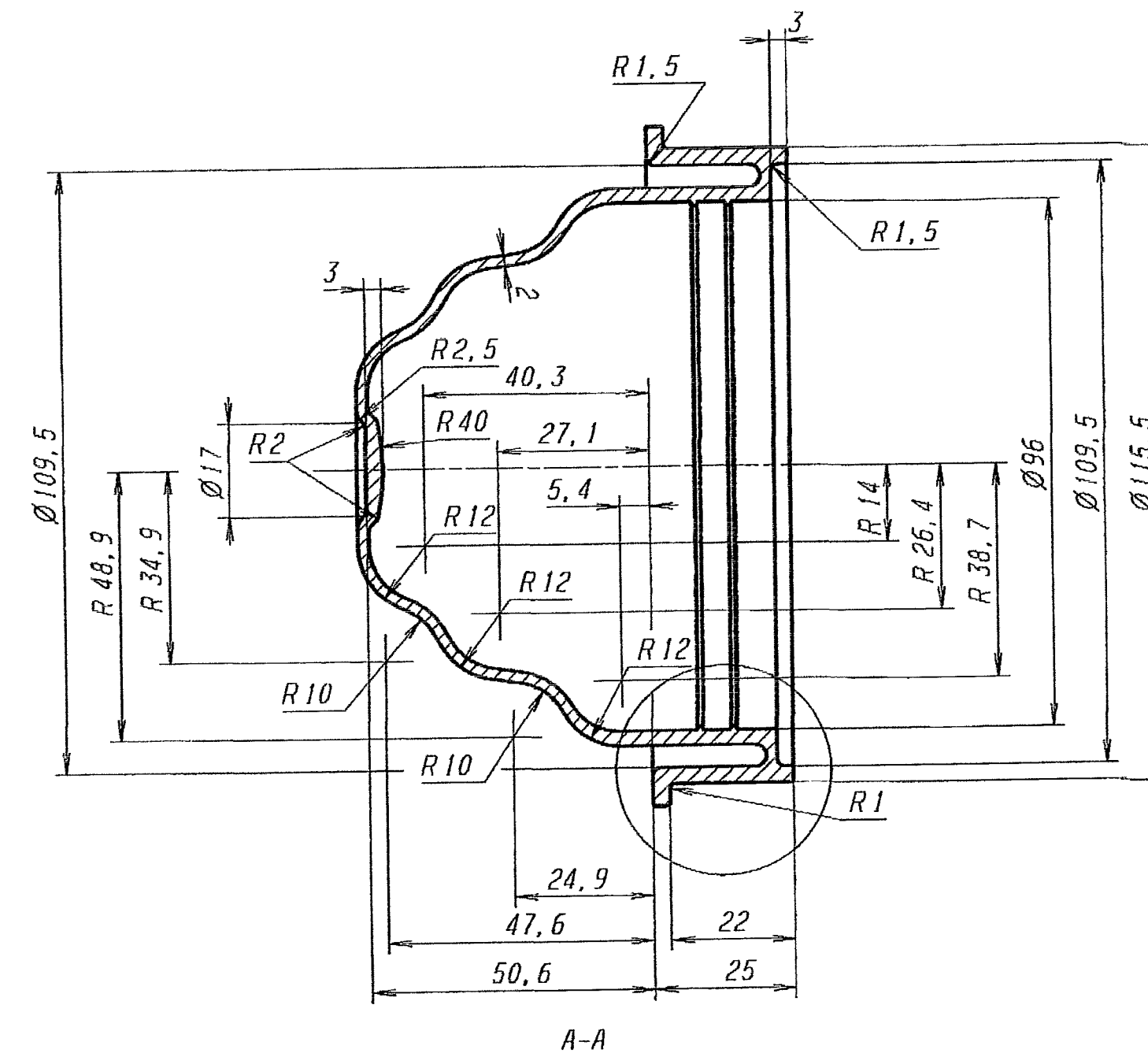
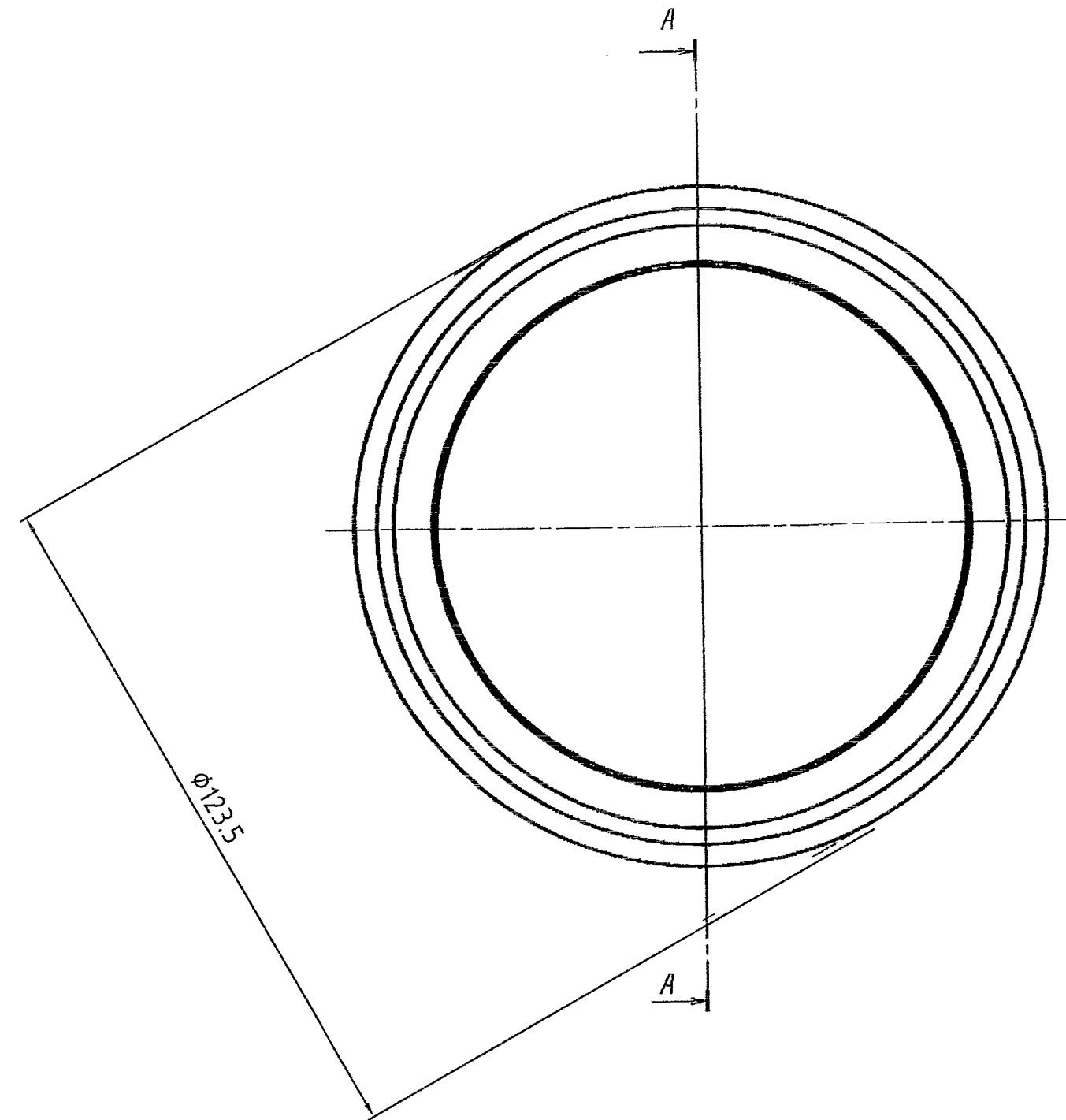
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REF. DRG. NO 4 103 480

DRG.No.  
TRD-322161

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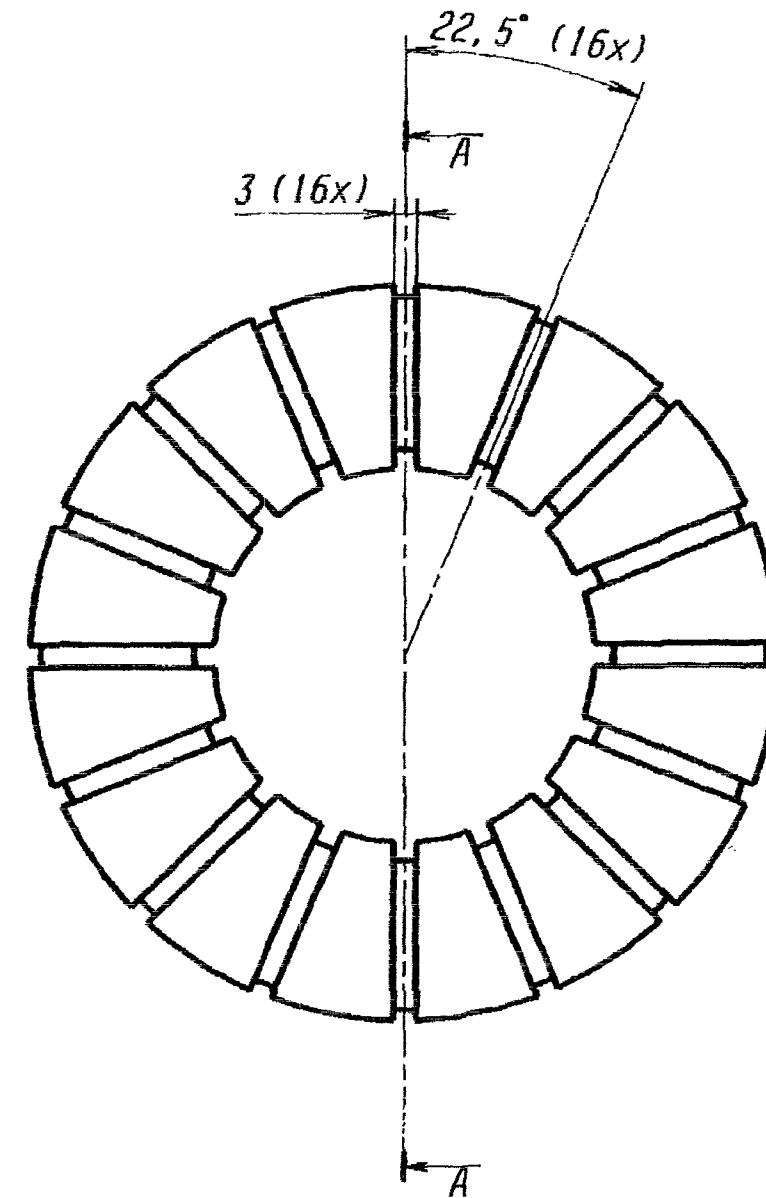
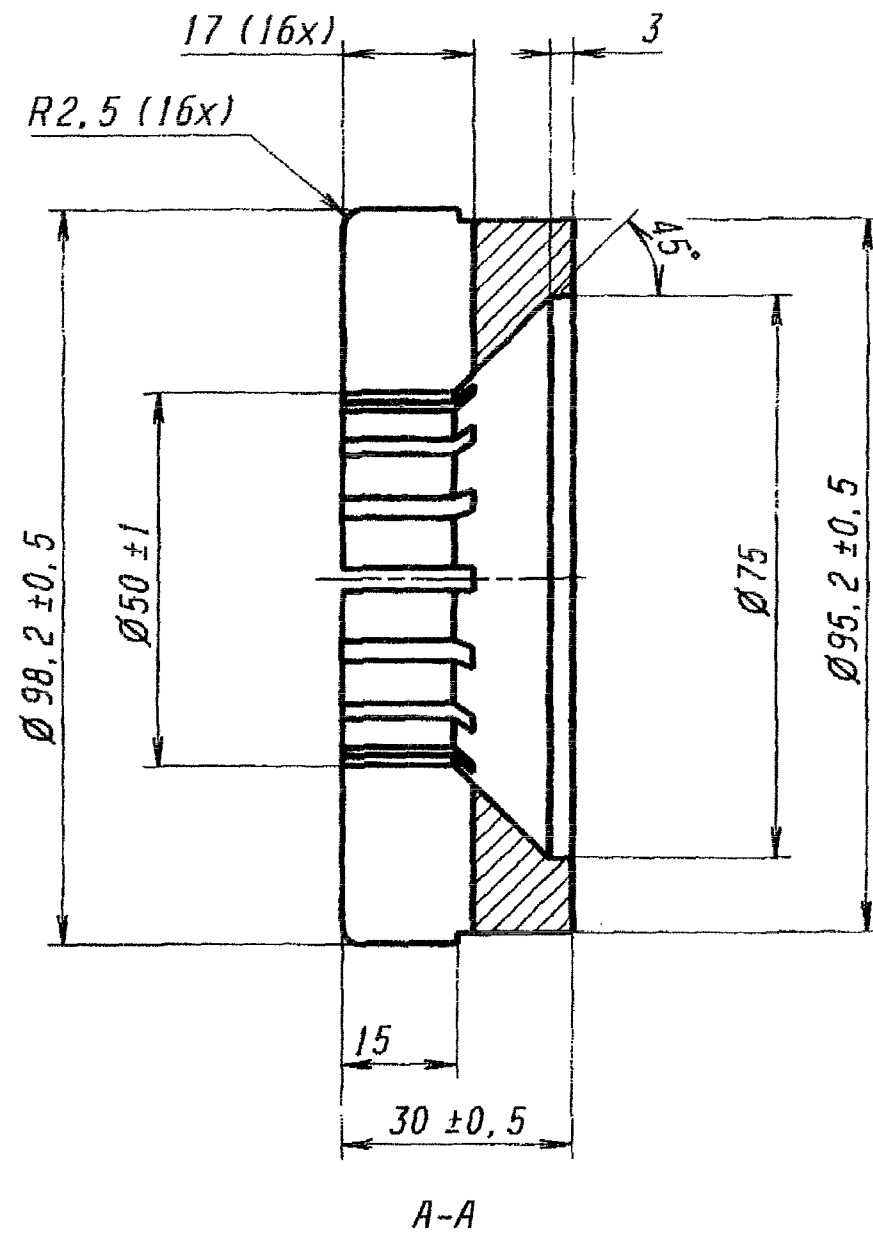
Skala | 2:1  
Scale | 2:1

\*) HD-polyeten Hostalen GD 7255  
Infärgad: Oliv 70/4621 enl BS 381C nr 285  
HD polyethylene Hostalen GD 7255  
Dyed: Olive 70/4621 to BS 381C No. 285

Material | Se not/See note \*)

Insp.	Date	JWM/ CDO	DA No	Item No.	DESCRIPTION	No. off	MATERIAL
					Heat Treatment Rc.-		NOSE 520:6
Amendments				▽	12.5-25 Ra	▽▽	0.2-0.8 Ra
JWM/ R&D				▽▽	1.6-6.3 Ra	▽▽▽	0.1-0.025 Ra
HOS/ CDO				DIMENSIONS ARE IN mm.			
CKD				UNTOL. DIMNS. IS:2102 MEDIUM			
DRN				SHARP EDGES TO BE REMOVED			
Approved by Jt. CDO (R&D)				Gauging surfaces shown by thick line			
PS/GS.				ORDNANCE FACTORY KHAMARIA			
				Store :- 84 km Heat SSI			
				Compt.:-			
				DRG.No.-04100380			

DRG.No.  
TRD-222159



\*) Torkad under/To be dried for 48h±1h, +50°C ± 5°C

Material EPP svart/black 60 kg/m<sup>3</sup> fri från fukt/moisture free \*)

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Insp.	Date	JWM/ CDO	DA No	Item No.	DESCRIPTION	No. off	MATERIAL
					Heat Treatment Rc.-		BLOCK
					Amendments		M/C
JWM/ R&D	<i>[Signature]</i>				▽2.5-25 Ra 0.2-0.075		
HOS/ CDO	<i>[Signature]</i>	DATE 29.1.07			▽6.3 Ra 0.1-0.025		
CKD	<i>[Signature]</i>	CKD			DIMENSIONS ARE IN mm.		Drg. No. TRD-222159
DRN	<i>[Signature]</i>	TRD			UNTOL. DIMNS. IS:2102 MEDIUM		SCALE:- 10:1
					SHARP EDGES TO BE REMOVED		No. of sheets - 01
					Gauging surfaces shown by thick line		Sheet No. - 01
					Approved by <i>[Signature]</i> (TRD)		
PS/GS.					ORDNANCE FACTORY KHAMARIA		
					Store :-		Compt:-
					Drg.No.		DRG.No. - 5212419