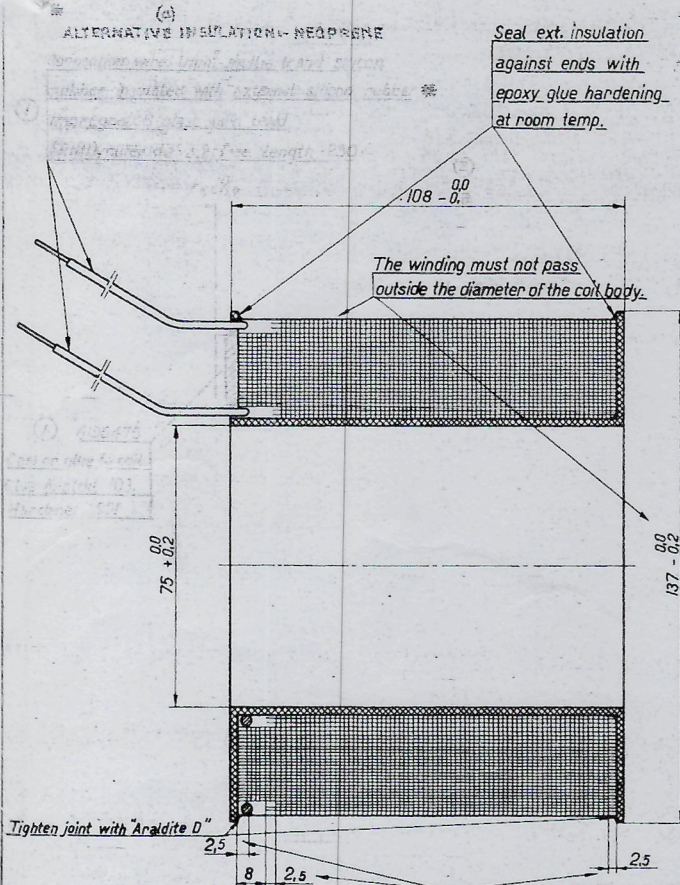
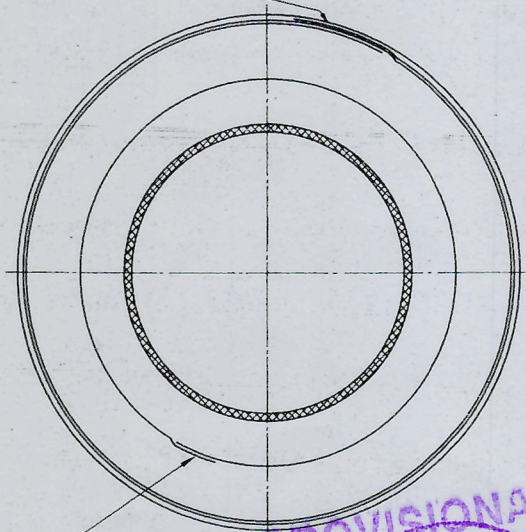


Andr. nr	Ändring	Begär av	Datum	Signatur	Tolerans	Även till
1	6135475 1000 1000 1000 1000	RNL	15-12-79	S93		
2	1000 1000 1000 1000	RNL	15-12-79	S93		
3	1000 1000 1000 1000	RNL	15-12-79	S93		
4	1000 1000 1000 1000	RNL	15-12-79	S93		
5	1000 1000 1000 1000	RNL	15-12-79	S93		



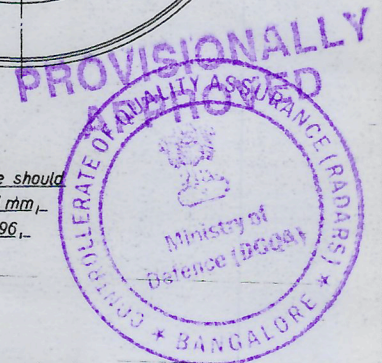
Commence and finish all bearings 2.5mm from the edges of the papers.



Exterior insulation:

2 layers presspan, 0.15 x 104
Cement 20 mm overlapping joint along complete length and seal with epoxy glue that hardens at room temp.
A marking sign showing winding drawing No., type of wire and total number of turns should be glued outside the exterior insulation.

Insulation between each layer:
Between each layer of wire there should be 1 layer of presspan 0.10 x 104 mm, opposite the locking wires 0.10 x 96, with 10 mm overlap.

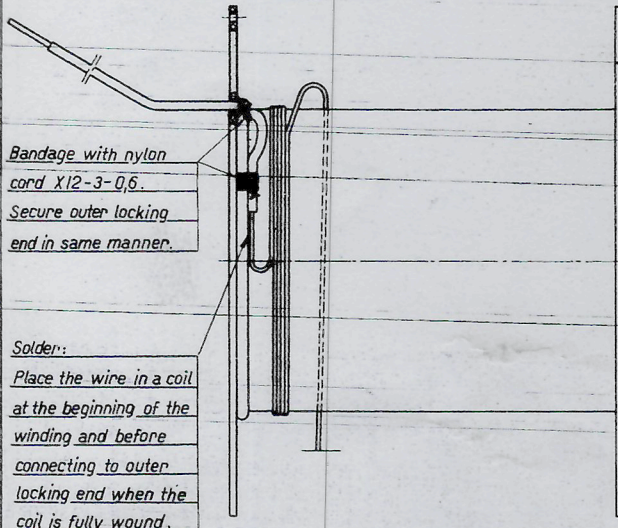


Impregnate the coil with heat-hardening epoxy resin acc. to B 3018.

Insulation resistance and insulation strength are measured between the winding and a metal cover encasing the winding.

Insulation resistance: Min 1000 MΩ, approx. 500 V D.C. is used.
Insulation strength: 2000 V, 50 P/S for 1 minute.

Signature



Voltage	volt	110	220
Wire		1.3 EE	0.90 EE
No. of bearings opposite locking wire		2	3
Total number of bearings		19	26
No. of turns / layer opposite locking wire	~	67	95
No. of turns / layer in other places	~	72	104
Total No. of turns (fully wound)		1300	2600
Resistance	Ohm ± 10 %	5.3	23
Design			2

(a)
ALTERNATE: 20 GAUGE WIRE (0.914 mm)

टि राजु/T Raju
वरिष्ठ वैज्ञानिक अधिकारी/SSO II
सहा नियंत्रक (म्यू ए)/AC(QA)
कृते नियंत्रक/For Controller

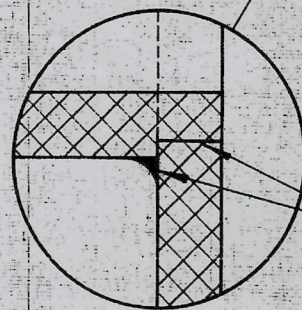
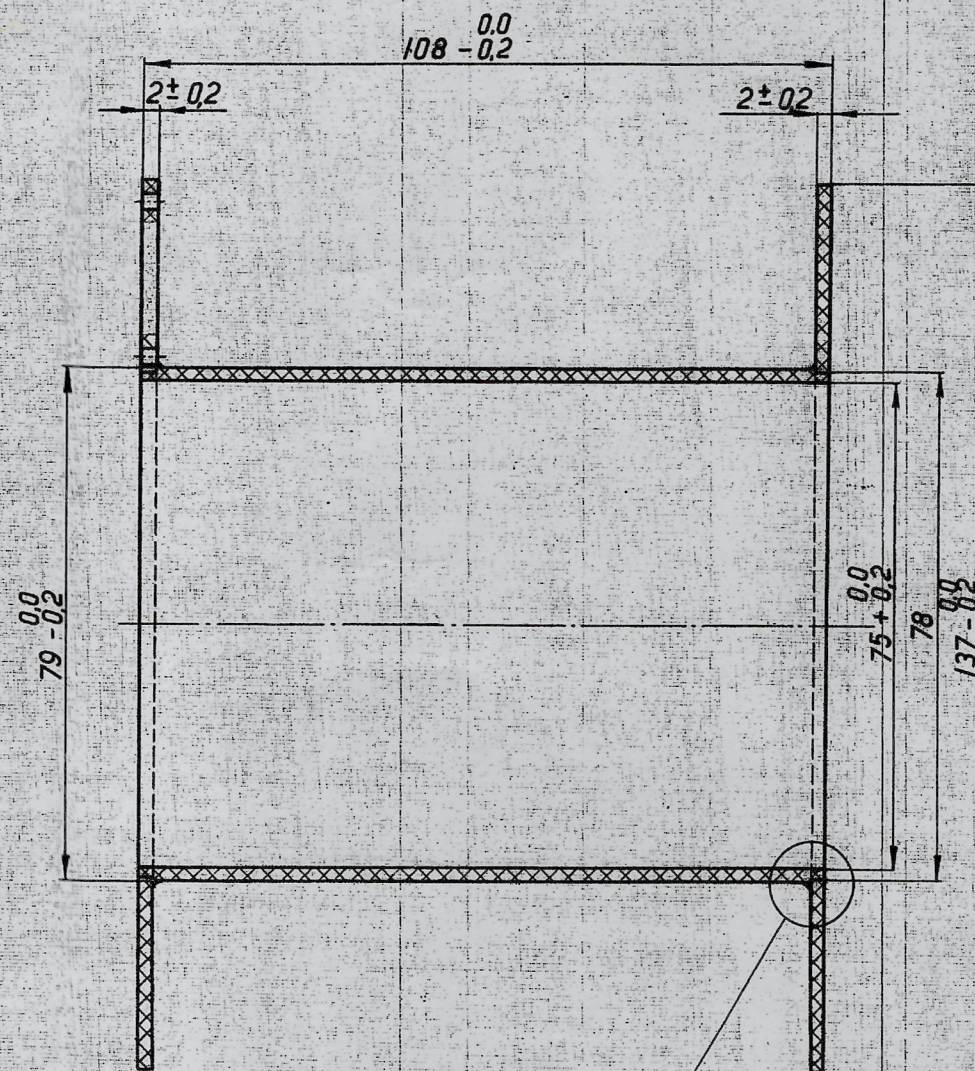
COIL SOLENOID 23 OHMS, 2600 TURNS 220 VOLTS GUN ELECTRO MAGNETIC ASSY.

Firing magnet M/51
Coil Winding drawing

15-524 / 1
DF

4023416

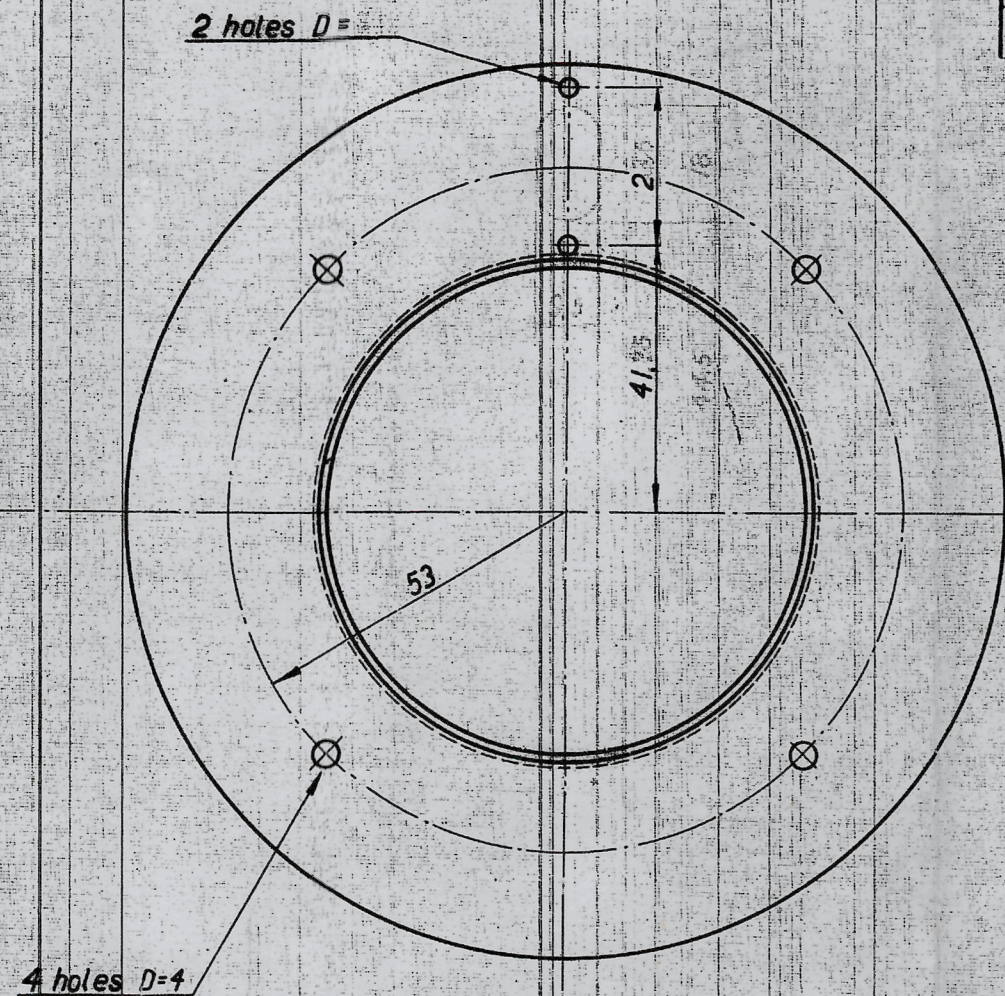
AB Bofors: godkänd till denna ritning är skyddad genom lagen av den 30 maj 1919. Konstruktionen eller ritningen för ej utan bolagets medgivande beaktas, kopieras eller mångfaldigas, bringas till vilseledelse eller i öfrigt obehörigen utnyttjas.

F

Scale 5:1

Cement and seal the joints with an epoxy glue that hardens at room temp.

Andr. nr	Andring	Begard. dy	Datum	Signature	Tolerans	Avg. ill.
1	D-3 was D-25, 4/15 was 4/5, 2/15 was 2/5					
	hole 18 x 3.5 placed	242	5/162	Soe		

[illegible]

B

A K T I E B O L A G E T B O F O R S



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Project : L7

**QUALITY ASSURANCE PLAN OF
COIL SOLENOID 23 OHMS, 2600 TURNS 220 VOLTS
GUN ELECTRO MAGNETIC ASSY.
DRG.NO. 4023416**

Item Code : 9069110513

Prepared and published by

Gun Carriage Factory

A Unit of Advanced Weapons and Equipments India
Ltd.

Government of India, Ministry of Defence,
Jabalpur (MP) 482011



RESTRICTED

QAP/ATP

This quality plan is a general guide to meet the quality requirements of product. It consists of applicable procedures (describing production processes, inspection & testing instructions), applicable workmanship standards, the measurement tolerances acceptable, the description of material standards and so forth. It also mentions the list of documents, test certificates that will be submitted by firm to GCF along with finished component.

1. Nomenclature & Drawing No. : COIL SOLENOID 23 OHMS, 2600 TURNS 220 VOLTS.
TO DRG. NO. 4023416

2. Method of manufacture & Inspection schedule :

S.NO.	SEQUENCE OF OPERATION/PROCESS/ FUNCTIONAL CHECK/INSPECTION.	REMARK (SAMPLE PLAN OR ANY OTHER APPLICABLE INSTRUCTIONS)
1	CABLE/COIL SHOULD BE PREPARED AS PER DRG.	ASSY.SHOULD CONFIRM ACCEPTANCE TEST. ALL ELECTRIC INSTRUMENTS SHOULD BE CHECKED ON PROPER TEST BENCH AND AS PER STANDARD NORMS.
2	FIT ASSEMBLE ALL DETAIL AS PER DRAWING.	
3	ACCEPTANCE TEST.	

3. Inspection: Following methodology is to be followed for inspection.

3.1 Mode of Inspection & Sample Size/Selection:

(a) **At Firm Premises:** Inspection by the manufacturer for 100% quantities of lot size.

(b) **At receipt End:** Inspection by MID/QC (GCF Rep.) at receipt at GCF. Sample selection as per existing IS standard 2500 part-II, 1965.

(c) Acceptance as per Chemical composition and Mechanical properties/Performance Test/Fitment Trial/Any other functional requirement.

4. Submission of Documents:

Following documents should be submitted along with finished product :


(1) Acceptance test report after functional trial.

(2) NABL/Govt. approved Lab certificate required for material.

Date:-02/11/2022



**Approved By
Controlling Officer
(QC Section)**



**Prepared By
HOS/SC**