

THE PORTION OF BODY AND LID WHERE THE LID ENGAGES THE PORTION OF BODY AND TEAR OFF BAND WHERE THE TEAR OFF BAND IS TO BE SOLDERED TO BODY AFTERWARDS IS TO BE LEFT UNPAINTED

HANDLE TO BE PAINTED SERVICE COLOUR BEFORE ASSEMBLY POSITION OF HANDLE PLATES TO BE SUCH THAT HANDLE WILL LAY AS FLAT AS POSSIBLE DURING TRANSIT

TO BE LABELLED HERE WITH AN APPROVED HERE WHICH IS TO BE AFTERWARDS VARNISHED OVER

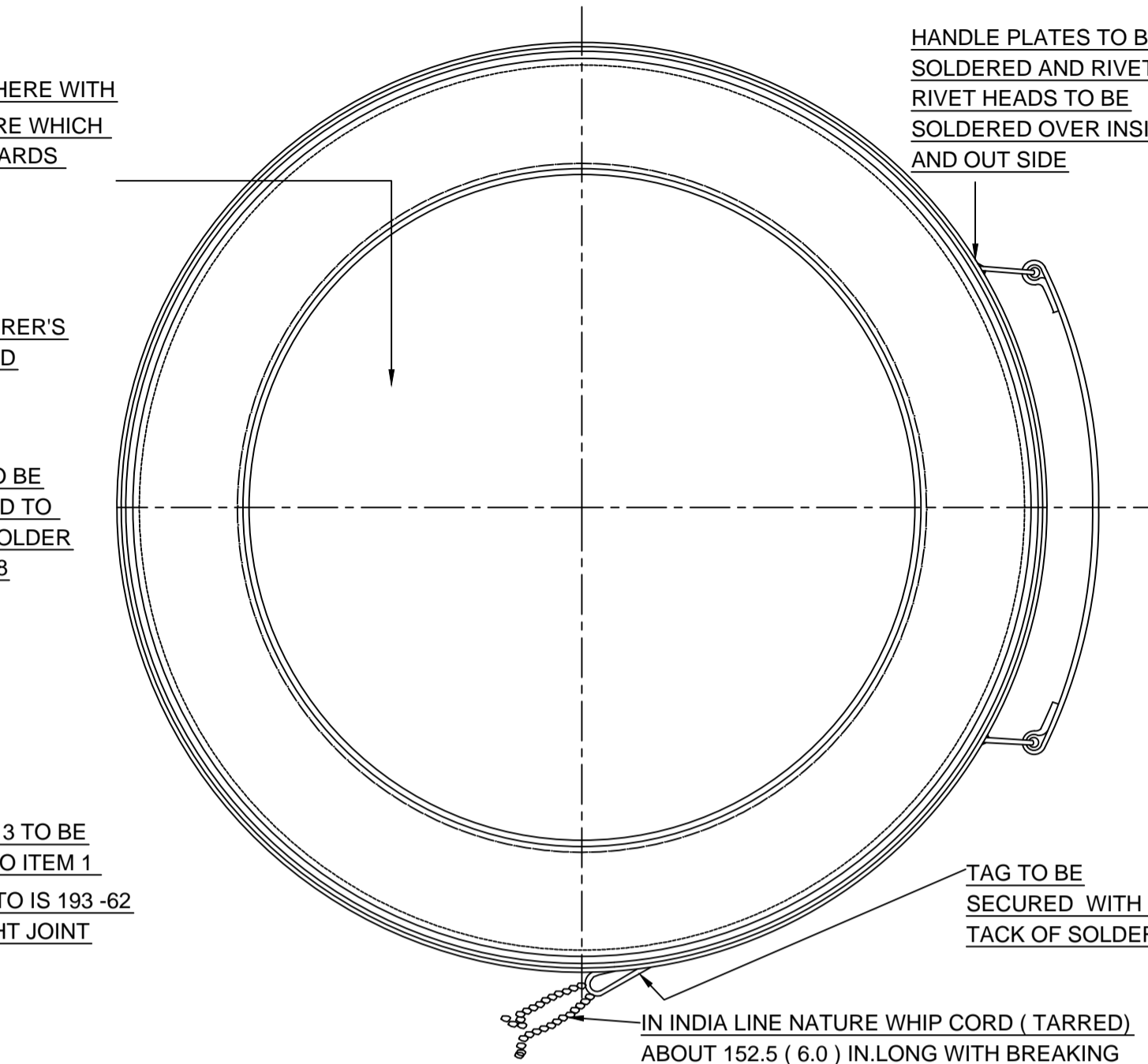
HANDLE PLATES TO BE SOLDERED AND RIVETTED RIVET HEADS TO BE SOLDERED OVER INSIDE AND OUT SIDE

NOTE :-

PACKER'S AND SOLDERER'S LABEL TO BE INSERTED BEFORE CLOSING

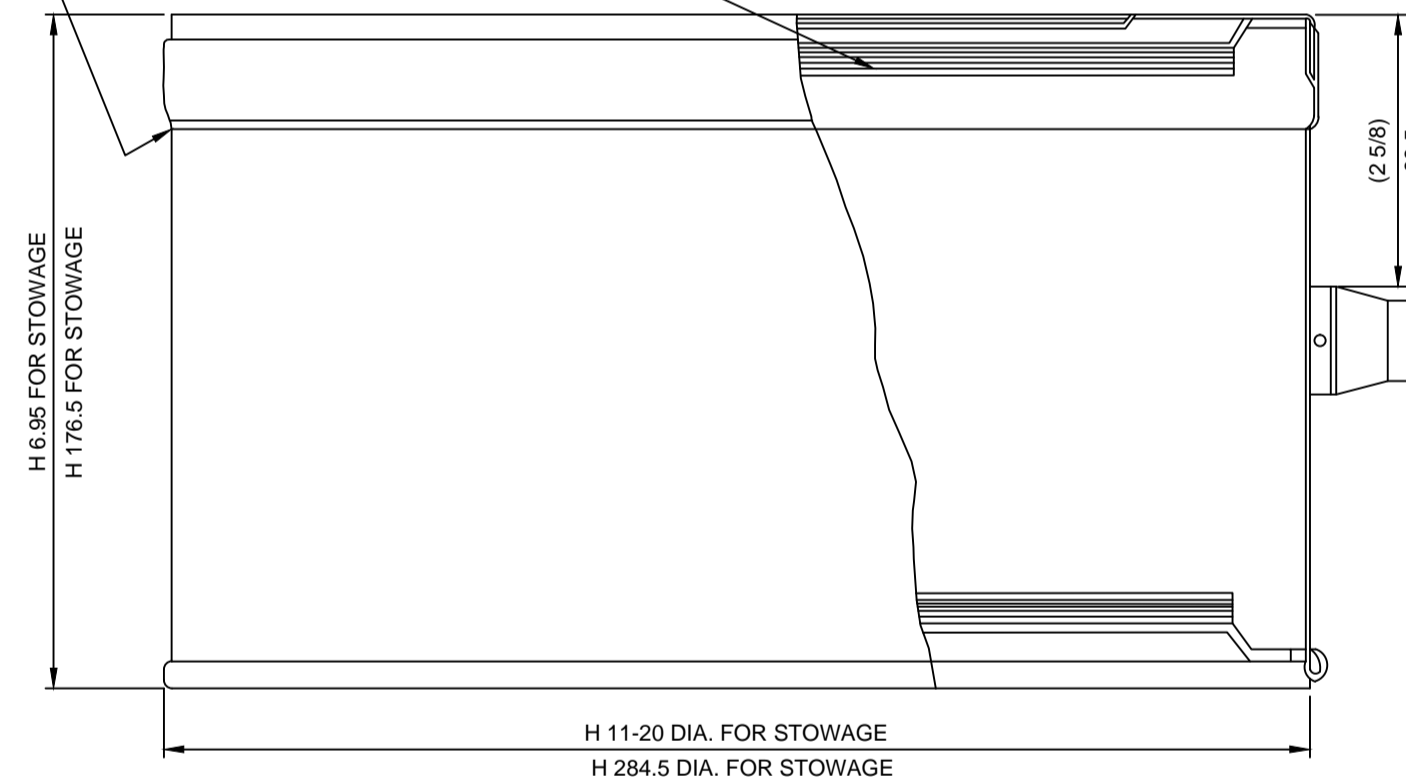
EDGE OF ITEM 3 TO BE LIGHTLY SOLDERED TO ITEM NO. 2 WITH SOLDER SN 40 TO IS 193 - 68

AFTER PACKING ITEM 3 TO BE LIGHTLY SOLDERED TO ITEM 1 WITH SOLDER SN 40 TO IS 193 - 62 TO FORM AN AIR TIGHT JOINT



TWO FELT DISCS 241.5 (8 1/2 IN DIA) WOLLEN PROOFED TYPE MEDIUM HARD VARIETY NO 4, 9.5 (3/8 IN THICK) TO SPECN 1719 - 1969 SECURED TO DISHED PLATE IN LID & BOTTOM BY ANY SUITABLE ADHESIVE (ONE IN LID & ONE IN BOTTOM)

IN INDIA LINE NATURE WHIP CORD (TARRED) ABOUT 152.5 (6.0) IN LONG WITH BREAKING STRENGTH OF NOT LESS THAN 21.319 KG (47 - LBS) PASSED THROUGH EYE IN TEAR OFF BAND AND TIED TO FORM A BECKED ALTERNATIVSL WITH CORD 152.5 (6.0) IN LONG MOULD PROOFED WITH BREAKING STRENGTH OF 18.444 KG (40 LBS) MAY BE USED.



METHOD OF ASSEMBLY EMPTY

VARNISHING :-

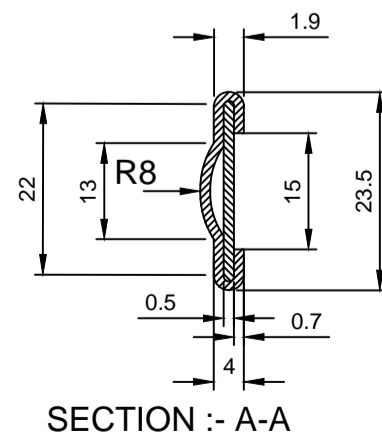
THE CYLINDER IS TO BE COATED INTERNALLY WITH AMMUNITION SEALING COMPOSITION NO 221 TO JSS 1329 (LATEST ISSUE) OR WITH VARNISH AIR DRYING AMMUNITION TO SPECN. IND / ME / 719

PAINTING :-

THE CYLINDER IS TO PAINTED EXTERNALLY WITH PAINT READY MIXED QUICK DRYING MATT FOR GENERAL PURPOSEOLIVE GREEN (ISC 220 OF IS:5) TO SPECN IS : 168 (LATEST ISSUE)

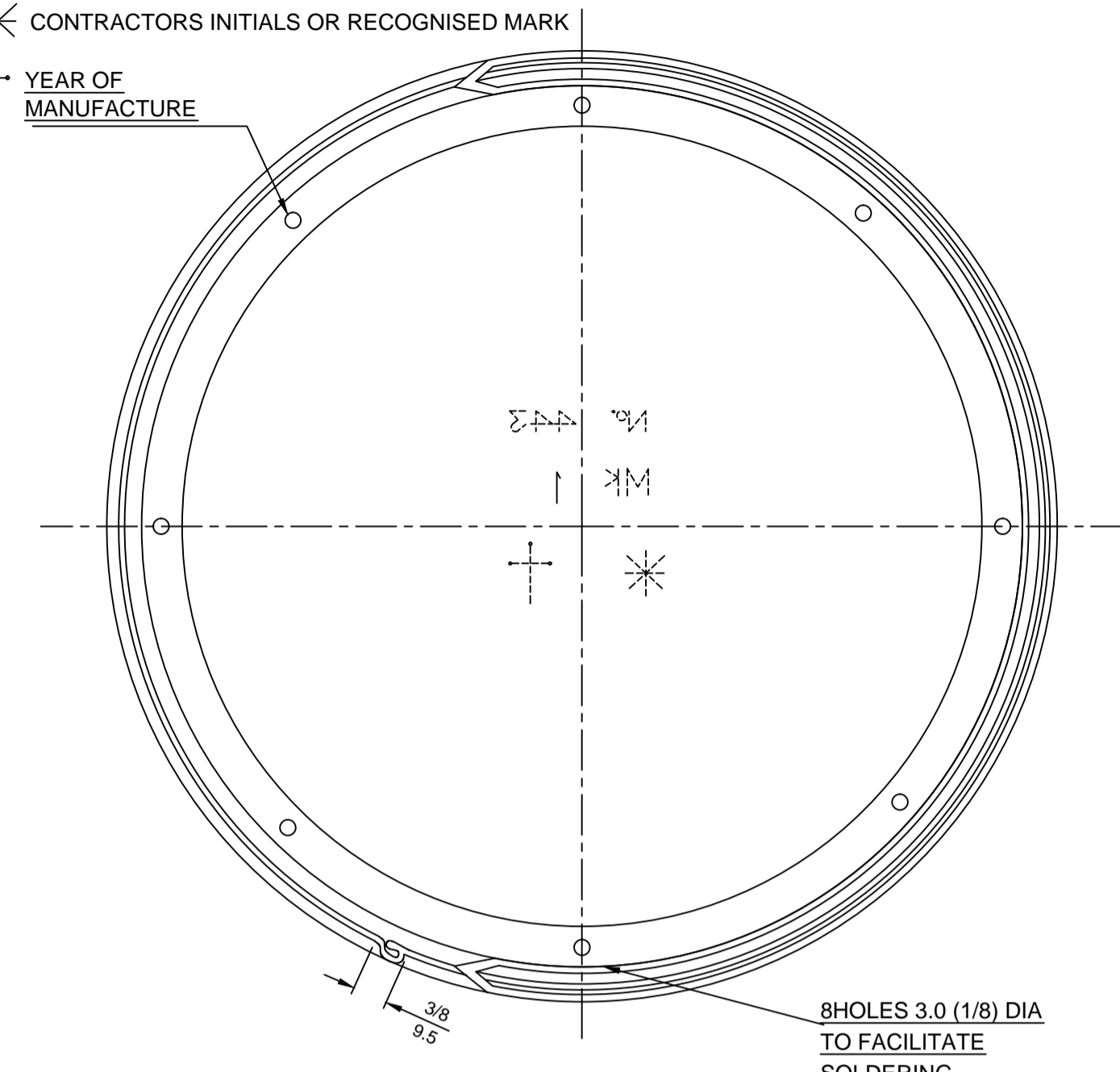
ⓈⓈ IS:5 - 1978 (REAFFIRMED IN 1991)

8	10.10.08	GALVANISED STEEL SHEET TYPE "DEEP DRAWING " DESIGNATION 'GPD' TO SPECIFICATION IS : 277 - 2003 AMENDED VIDE IO LETTER IO / 146 / AMEND DT. 06 . 10.08 AND NEW DC NO . 37189 - A DT. 22 . 09 . 08	Sd/- DVO / RX
7	29. 9.08	CYLINDER NO 443 MARK 1 / L/TIN PLATE ONE REEL CONTAINING 150 METER CORD DETONATION A	Sd/- DVO / RX
SL. NO	DATE	AMENDMENT	SIGN.

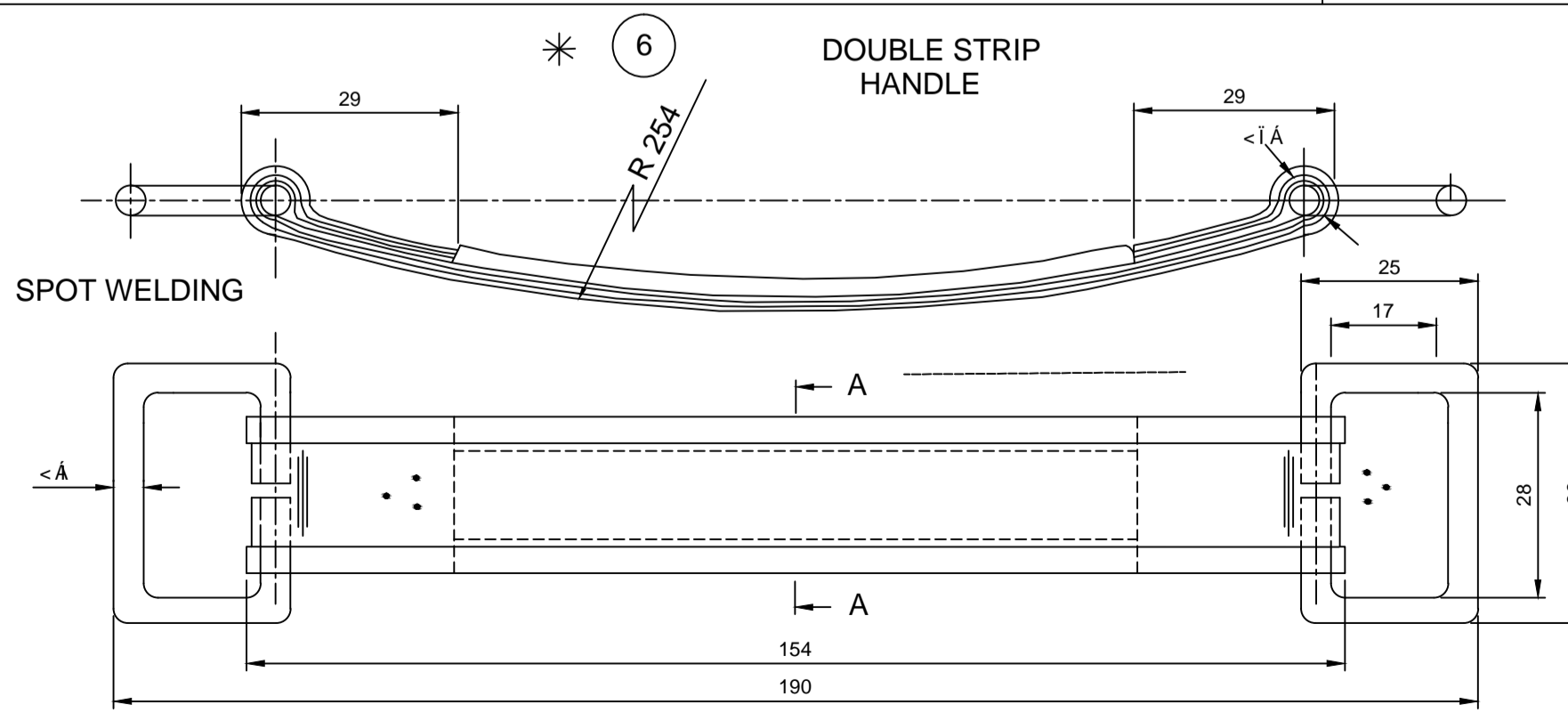
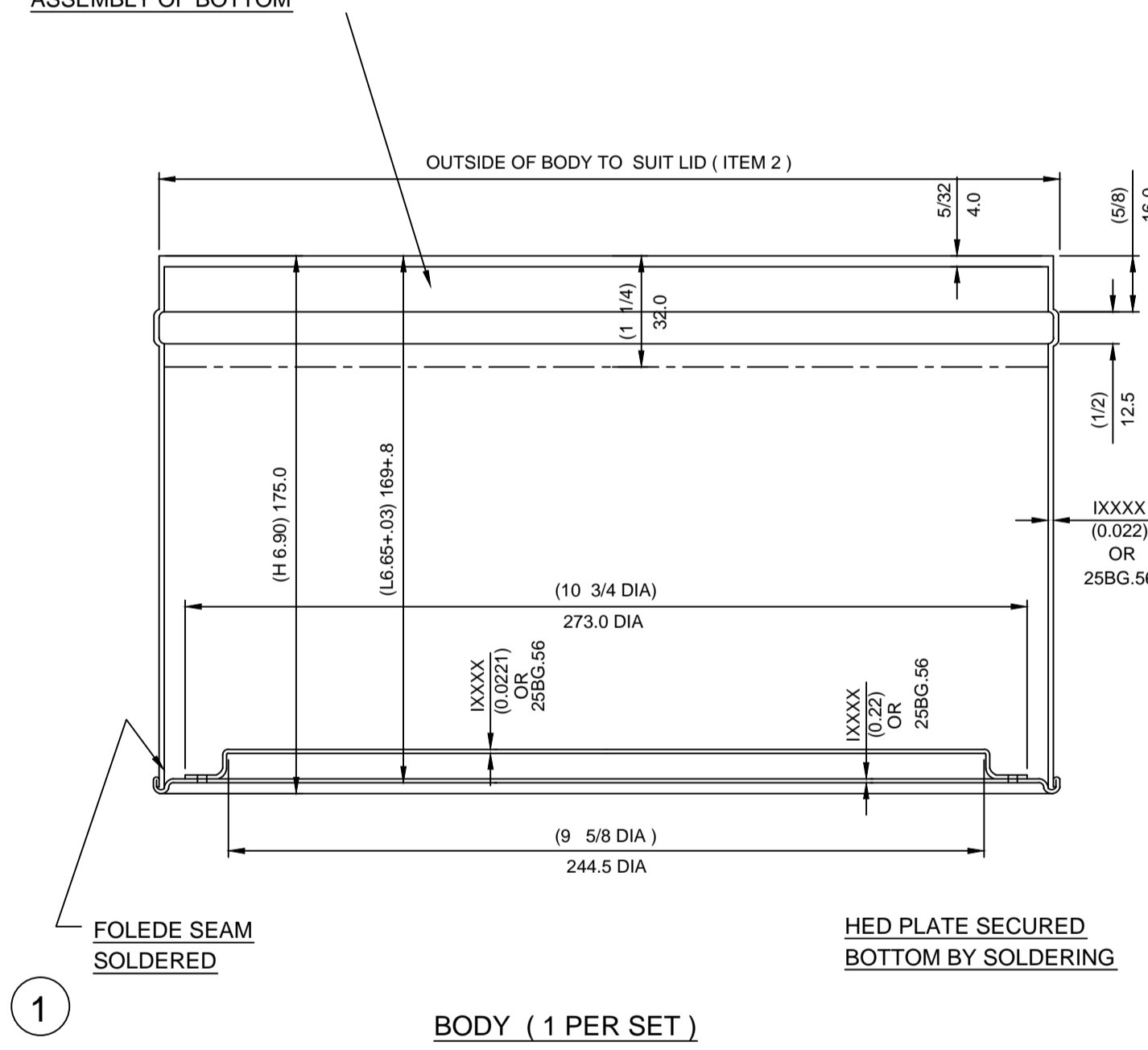


MARKING :-

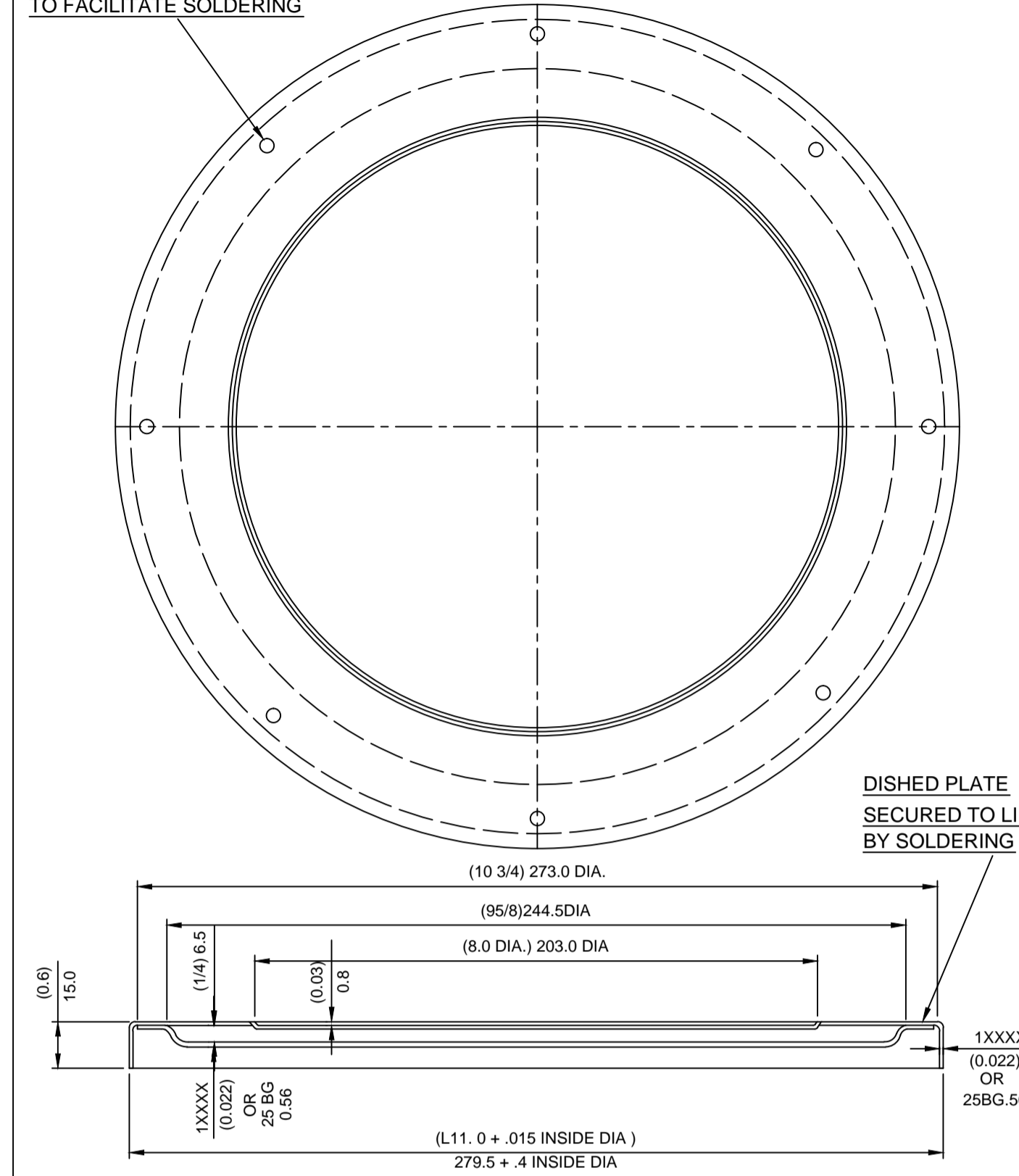
TO BE STAMPED ON FROM OUTSIDE IN APPROX. 9.5 (3/8) LETTERS NO 443 MARK OF CYLINDER IC MK 1 CONTRACTORS INITIALS OR RECOGNISED MARK YEAR OF MANUFACTURE



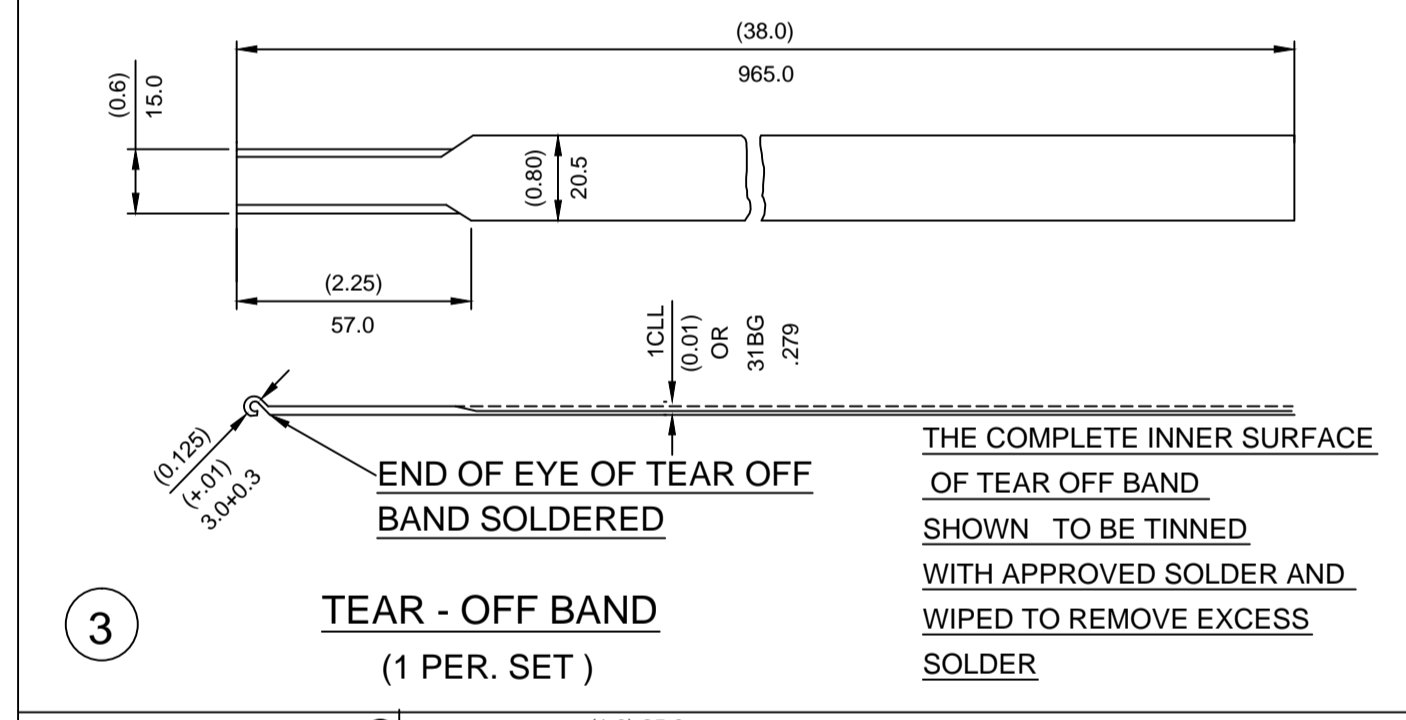
FOLDED SEAM FLUSH INSIDE STOPPED START ABOUT 32.0 (1 1/4) FROM TOP AND A LAP SEAM FORMED FLUSH OUTSIDE. SOLDERED SEAM MAY BE NOTCHED AT BASE TO FACILITATED ASSEMBLY OF BOTTOM



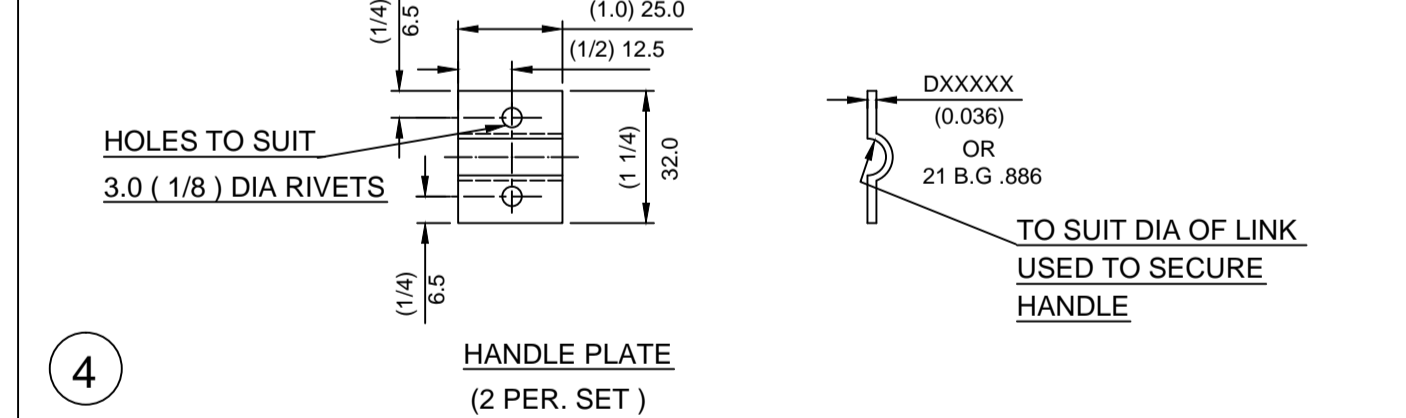
8 HOLES 3.0 (1/8) DIA' DISHED PLATE TO FACILITATE SOLDERING



LID (1 PER SET)



TEAR - OFF BAND (1 PER. SET)



HANDLE PLATE (2 PER. SET)

DIMENSIONS IN BRACKET ARE IN INCHES

NOTE :-
TOLERANCES ON UNTOLERANCED DIMENSION (± 0.02 ± 0.5MM)

MATERIAL

GALVANIZED STEEL SHEET TYPE " DEEP DRG " DESIGNATION ' GPD ' TO SPECIFICATION IS:277-2003 3.D (1/8) DIA SEMI TUBULAR RIVET ALTERNATIALLY 2 SPOT WELDS ABOUT 11:0 (7/14) APART ACROSS WIDTH

MATERIAL FOR LINK STEEL SHOULD BE HALF HARD BRIGHT DEAWN TO SPCN IS : 280 LATEST ISSUE I.S. : 280 - 1978 (REAFFIRMED IN 1992)

5	5.1.07	ITEM NO 6 HANDLE ADDED (DOUBLE STRIP HANDLE)	Sd/- JTGM / PV-I
4	5.1.07	ITEM NO 5 HANDLE VOID (SINGLE STRIP HANDLE)	
3	29.7.94	ⓈⓈ REAFFIRMATION OF I.S. : 5 - 1978 IN 1991 ADDED	
2	29.7.94	Ⓢ REAFFIRMATION OF IS : 280 - 1978 UB 1992 ADDED	Sd/- DVO / IO
1	27.7.94	MATERIAL AMENDED AS PER COA APPROVALNO QA 17042 DT 16.4.94 AND AMENDED VIDE DC NO 35693 A DT 18 . 4 . 94	
Sr. NO	DATE	AMENDMENT	SIGN.

6	09 . 06 . 08	Ⓐ MATERIAL AMENDED AS PER LETTER NO. QA 17370 / 1 DT 05.05.08 AND IO LETTER NO. IO / 146 / AMEND, DT. 4.6.08 DO NO. CHANGED FROM B5693A TO 37168A DT. 5.5.08	Sd/- DVO / RX
ORDNANCE FACTORY BHANDARA			
CYLINDER NO. 443 MARK 1 / L			
ONE REEL CONTAINING 150			
METER CORD DETONATION A			
DATE :- 24 - 2 - 89		SCALE :- 3/4	
DRN		DRG NO. :- OF BA ' CX ' 51	
TCD -			
CKD -			
APPROVED BY		FINAL APPROVAL	
Sd/- DGM/C		GENERAL MANAGER	