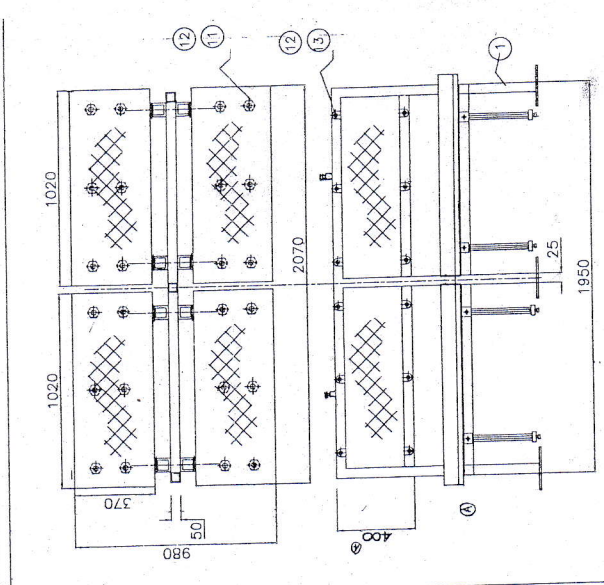


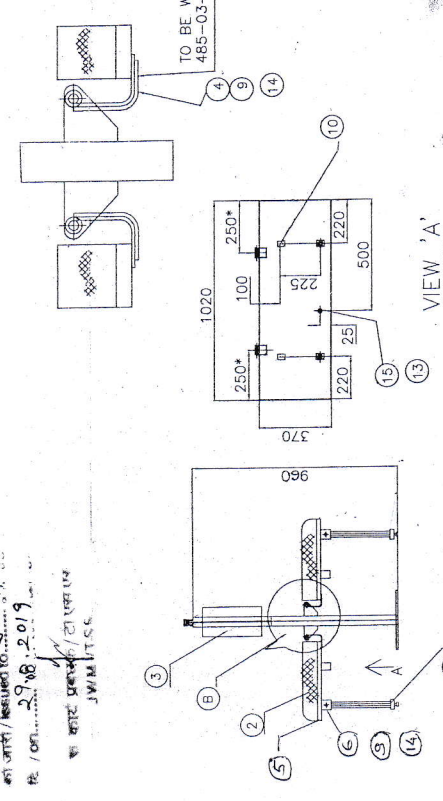
TECHNICAL SERVICES SECTION  
 Vehicle Factory, Jabalpur  
 CERTIFIED CORRECT COPY  
 29.08.2019



SL	DRG NO	NONVENCATURE	QTY	MATERIAL/ SIZE
16	-	BOSS	4	M10X20(00)X16L
15	-	SPLIT PIN	16	φ 2.5 L=25
14	STD	HEX. P/LT. M10	26	TVS /UNBRANKO
13	STD	M10 WASHER	50	-
12	STD	HEX. NUT M10	24	TVS /UNBRANKO
11	STD	LEG GRIP	8	REFER DRG
10	485-03-1045	LEG GRIP	8	REFER DRG
9	485-03-1043	PIN	8+8	REFER DRG
8	485-03-1042	HOLDER(LEG)	8	REFER DRG
7	485-03-1041	PIPE(LEG)	8	REFER DRG
6	485-03-1040	CLAMP(LEG)	8	REFER DRG
5	485-03-1038	SEAT FRAME	4	REFER DRG
4	485-03-1038	HINGE	8	REFER DRG
3	485-02-1036	BACK REST	4	REFER DRG
2	485-02-1035	CUSHIONED SEAT	4	REFER DRG
1	485-03-1031	MIDDLE FRAME ASSY	1	REFER DRG
SL	DRG NO	NONVENCATURE	QTY	MATERIAL/ SIZE

Rear Seat Assy 512

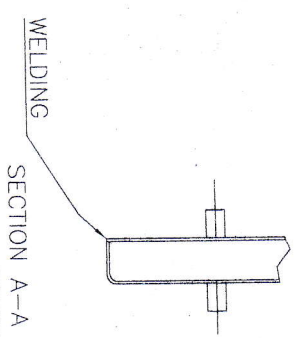
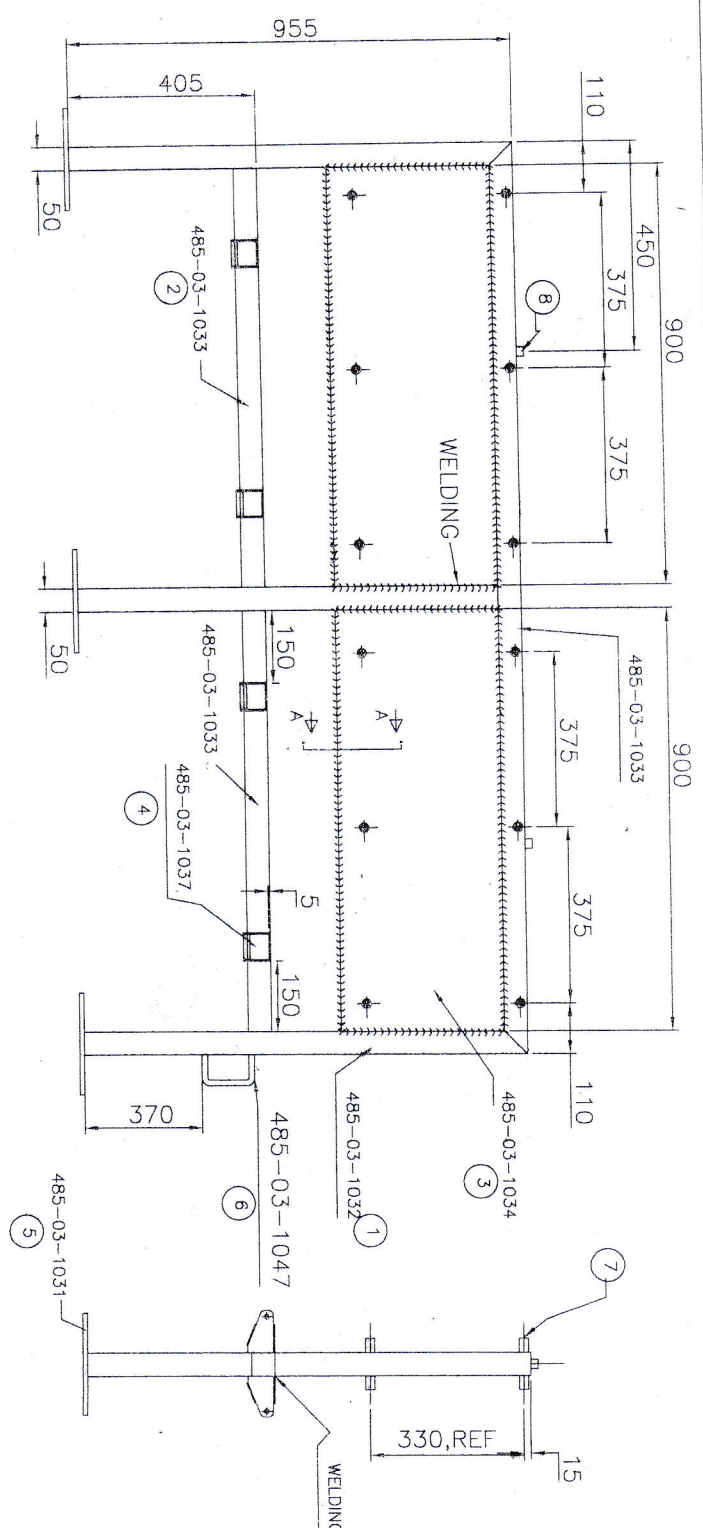
TECHNICAL SERVICES SECTION  
 Vehicle Factory, Jabalpur  
 CERTIFIED CORRECT COPY  
 29.08.2019



- NOTE:
1. ALL DIMENSIONS ARE IN MM.
  2. UNSPECIFIED LIMIT DEVIATIONS ARE ±1mm.
  3. REMOVE SHARP CORNER & BURR
  4. STRESS RELIEVE AFTER WELDING
  5. STANDARD FASTENER UNBRANKO / TVS SHOULD USE.
  6. HOLES FOR SEAT IN SEAT FRAME TO BE DRILLED IN ASSY
  7. REDOXIDE THE ASSY IN FINAL STAGE & TWO COATS OF OLIVE GREEN PAINT ON METALLIC PARTS
  8. \* DIMENSIONS ARE FOR REFERENCE ONLY
  9. IF DOUBT PLEASE ASK FOR CLARIFICATION.

DRG IS AMENDED ON 21/11/03

ISSUE	APPROVAL	NATURE OF AMENDMENT
01	5.3.03	DRG NO: 485-03-1030
REAR SEAT ASSY.		
(TATA-407)		
ORDNANCE FACTORY		

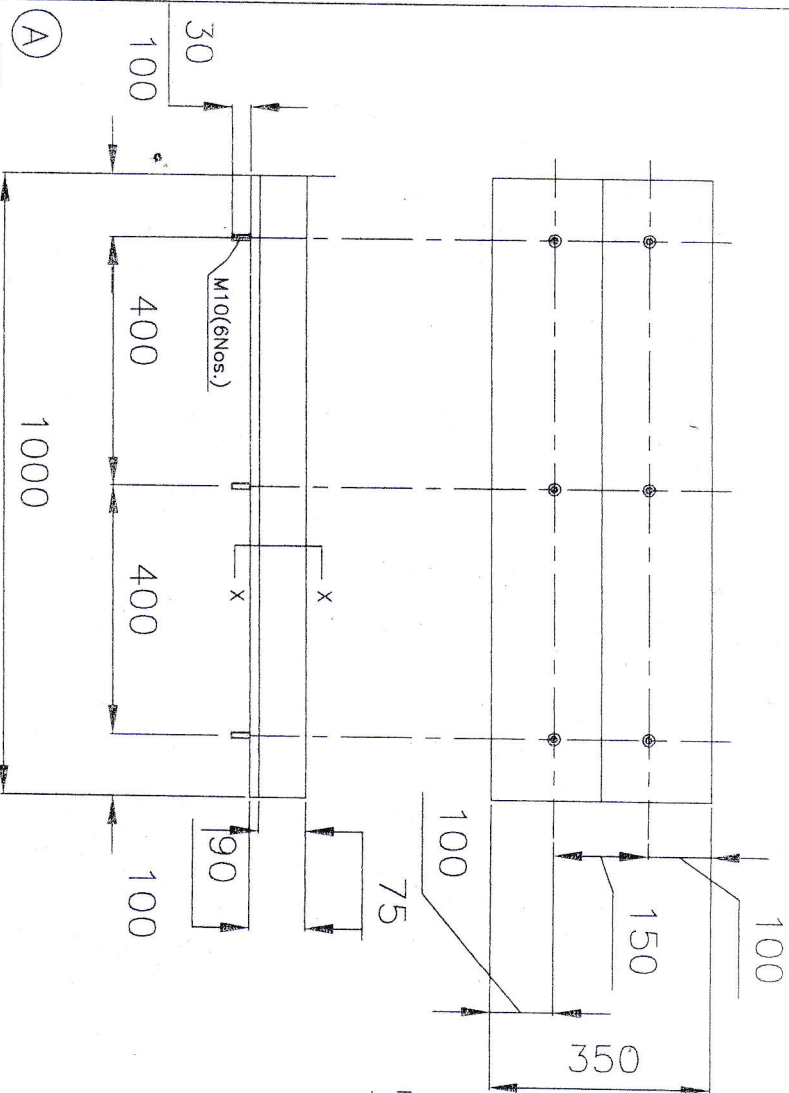


Sl. No.	Part No.	Description	Qty	Material / Size
1	485-03-1031	VERTICAL MEMBER	2+1	REFER DRG
2	485-03-1032	BACK REST PLATE	4	REFER DRG
3	485-03-1033	HINGE	8	REFER DRG
4	485-03-1034	BASE PLATE	3	REFER DRG
5	485-03-1037	HANDLE	1	REFER DRG
6	485-03-1047	BOSS	24	M10X20(OD)X30L
7	485-03-1031	VERTICAL MEMBER	2	M/S/ EMB
8	485-03-1031	VERTICAL MEMBER	2	M/S/ EMB

ISSUE	APPROD.	DATE	DRG. NO:	485-03-1031
NATURE OF AMENDMENT			DRG. NO:	485-03-1031
MIDDLE FRAME ASSLY (FABRICATED)			SHEET NO	SCALE
ORDNANCE FACTORY MEDAK			REVISION	

USED ON QTY./VEH.	TATA407	1
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78



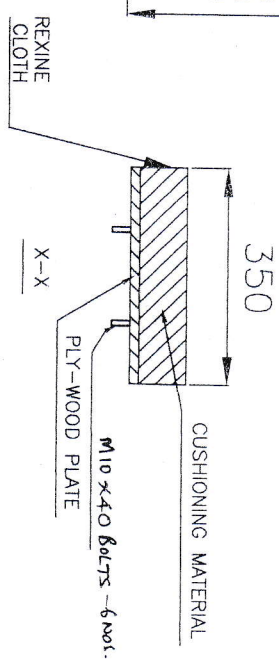
(A)

NOTE:

1. ALL DIMENSIONS ARE IN MM.
2. UNSPECIFIED LIMIT DEVIATIONS ARE  $\pm 2$ mm
3. PLY WOOD: 14<sup>+2</sup><sub>-0</sub> mm THICK PHENOL BONDED COMMERCIAL PLY WOOD.
4. COVERING CLOTH : REXINE CLOTH (VINYL COATED FABRIC) AS PER IS: 1259  
GRADE 1 CLASS 'B' WITH OLIVE GREEN COLOUR.
5. BOLTS : 6 Nos. BOLTS OF SIZE M10X40-IS:1363 (T/S MAKE) SHOULD BE FASENED.  
OUT SIDE PROTRUSION OF THE BOLT SHOULD BE 30mm AS SHOWN IN THE DRAWING.
6. SIZES OF THE SEAT ARE TO BE CONFIRMED AS PER DRAWING.
7. SUITABLE NUTS M10-IS:1363, PLAIN WASHERS B10-IS:5370 AND SPRING WASHERS 10-IS:6735 EACH 6 NOS (ALL ARE T/S MAKE) DULY FITTED TO THE BOLT AS SHOWN IN THE DRAWING ARE TO BE SUPPLIED ALONG WITH SEAT ASSY IN ASSEMBLED CONDITION.
8. TEST CERTIFICATES FROM ANY GOVT./GOVT. RECOGNISED LAB ARE TO BE ENCLOSED FOR THE MATERIALS VNYL COATED FABRIC AND P.U. FOAM.

9. DETAILS OF POLYURETHANE FOAM :

- a). POLYURETHANE FOAM TO SPECIFICATION NO: IS:8255-76
- b). THICKNESS OF THE FOAM - 75 mm
- c). TYPE-II
- d). GRADE - 'J'
- e). DENSITY OF FOAM : 40 $\pm$ 1 Kgs./m
- f). HARDNESS NUMBER : 33 TO 40.

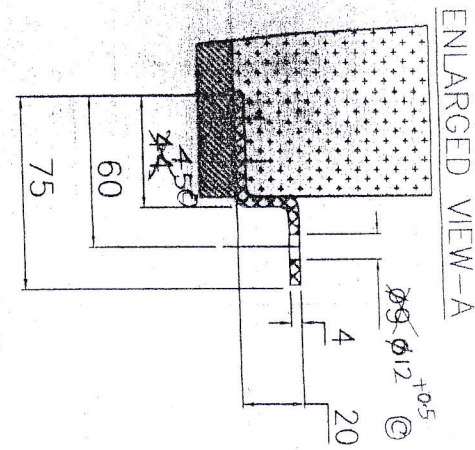
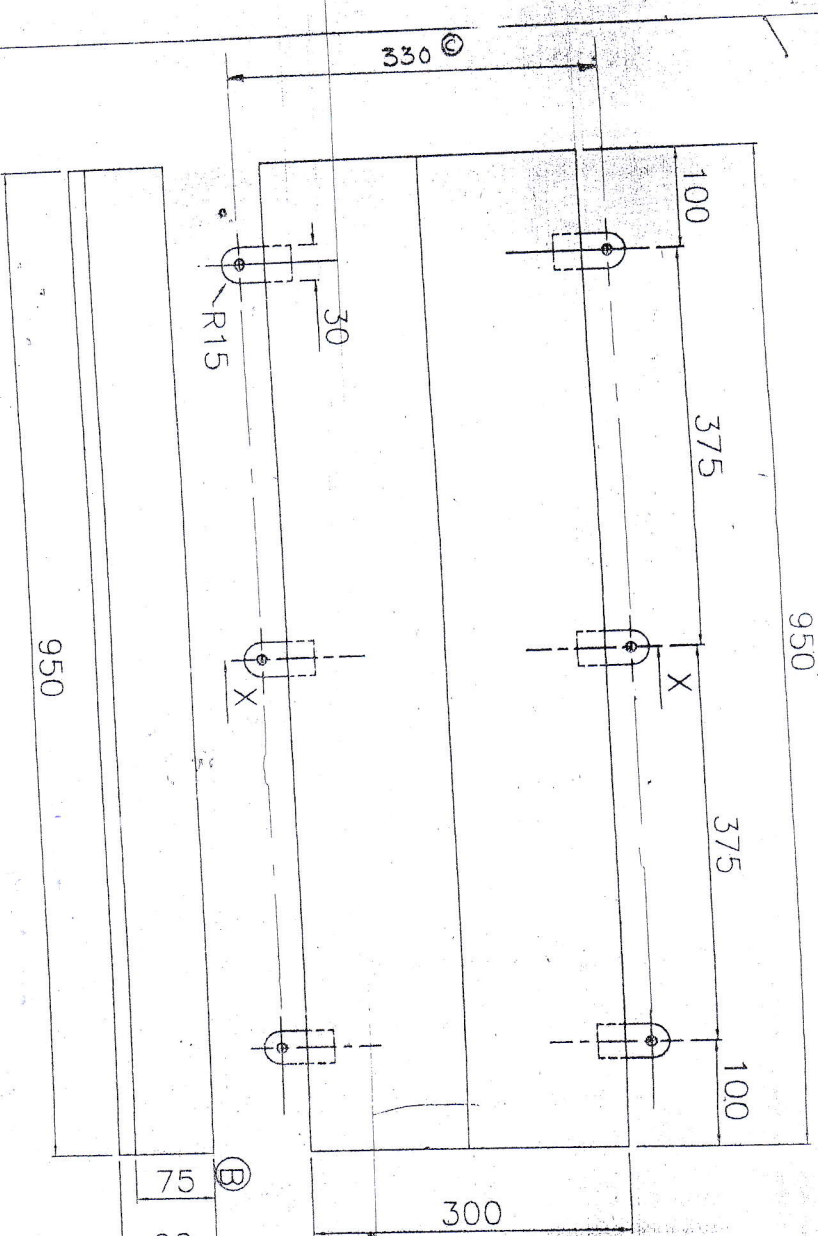


(A)  
17-08-05

DRY/veh 4 nos. WAS ENCL.  
Technical notes amended

82

ISSUE	APPROD.	DRG. NO:	485-02-1035
		NATURE OF AMENDMENT	
AUTHOR	S.K.V.		
CHKD	J.P.		
DRWN	B.C.D.		
NAME	DATE		
ORDNANCE FACTORY MEDAK		CUSHIONED SEAT (TATA-407)	
		MATERIAL:	
USED ON	QTY./VEH.		
TATA-407	04		

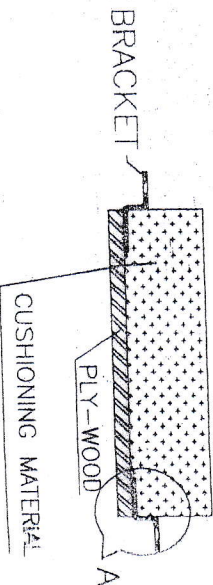


(A) NOTE:

1. ALL DIMENSIONS ARE IN MM.
2. UNSPECIFIED LIMIT DEVIATIONS ON LINEAR DIMENSIONS ARE  $\pm 1$ mm
3. PLY WOOD: 14  $\pm 2$  mm THICK PHENOL BONDED COMMERCIAL PLY WOOD.
4. COVERING CLOTH: REXINE CLOTH (VINYL COATED FABRIC) AS PER IS:1259 GRADE 1 CLASS 'A' WITH OLIVE GREEN COLOUR.
5. SIZES OF THE SEAT BACK REST ARE TO BE CONFIRMED AS PER DRAWING.
6. MOUNTING CLIPS: M.S. (Gr.FE410 WA TO IS 2062-92)CLIPS (6Nos.) WITH DIMENSIONS AS SHOWN IN THE DRAWING DULY FITTED.

DETAILS OF POLYURETHANE FOAM :

- a) POLYURETHANE FOAM TO SPECIFICATION NO: IS: 8255-76.
- b) THICKNESS OF THE FOAM - 75 $\pm 2$ mm
- c) TYPE-II
- d) GRADE - 'J'
- e) DENSITY OF FOAM : 40±1 Kgs./m<sup>3</sup>
- f) HARDNESS NUMBER : 33 TO 40.
- g) TEST CERTIFICATES FROM ANY GOVT./GOVT. RECOGNISED LAB ARE TO BE ENCLOSED
- h) TEST CERTIFICATES FROM ANY GOVT./GOVT. RECOGNISED LAB ARE TO BE ENCLOSED



ISSUE	APPROD.	DATE	DESCRIPTION
(A)		23-06-05	Technical notes amended
(B)		17-08-05	Dimms 300 Apped- 90&75 were 50 & 35 respectively
(C)		06-06-06	Dimms 300 Apped- 90&75 were 50 & 35 respectively

AUTHD. MAKE	APPROD.	DATE	DESCRIPTION
CHKD. CLIP			
DRWN. B.C.B.			
NAME	SIGN	DATE	

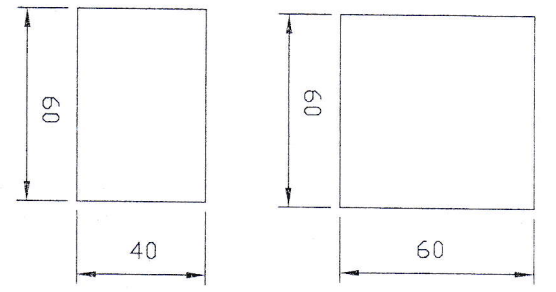
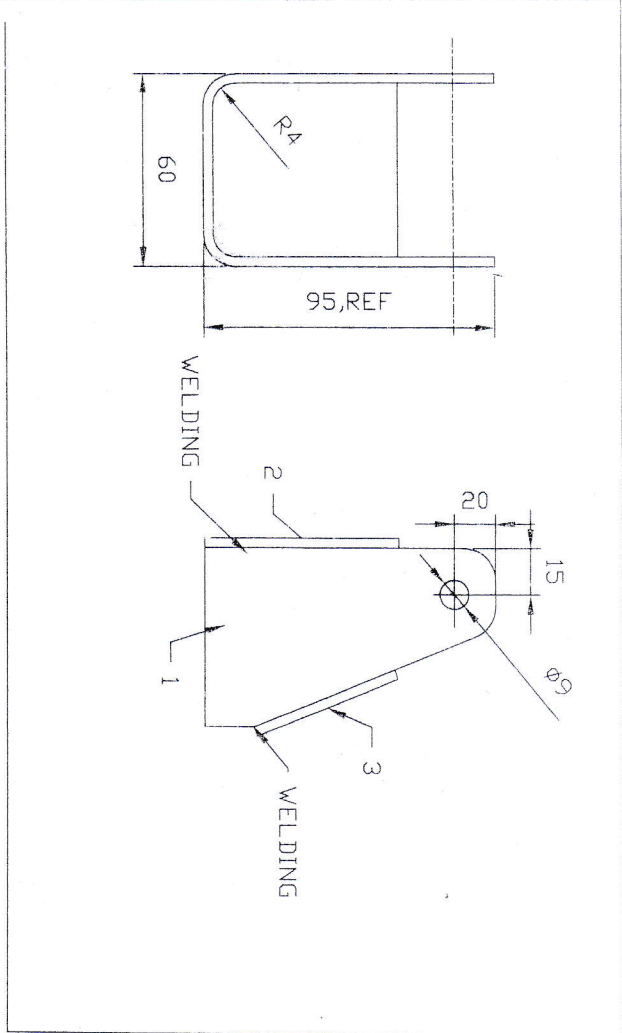
DRG. NO:	485-02-1036
NATURE OF AMENDMENT	
USED ON	QTY./VEH.
TATA-407	04

ORDNANCE  
FACTORY  
MEDDAV

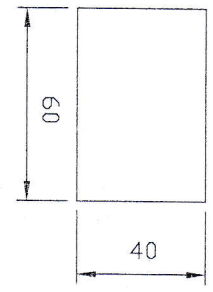
BACK REST  
(TATA-407)

MATERIAL:

SHEET NO.	SCALE	WEIGHT



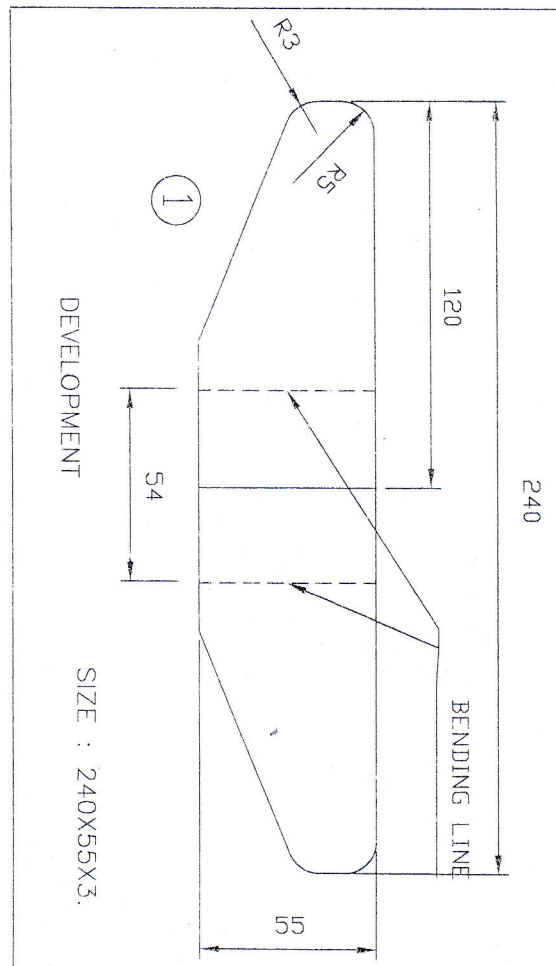
②  
SIZE : 60X60X3



③  
SIZE : 60X40X3

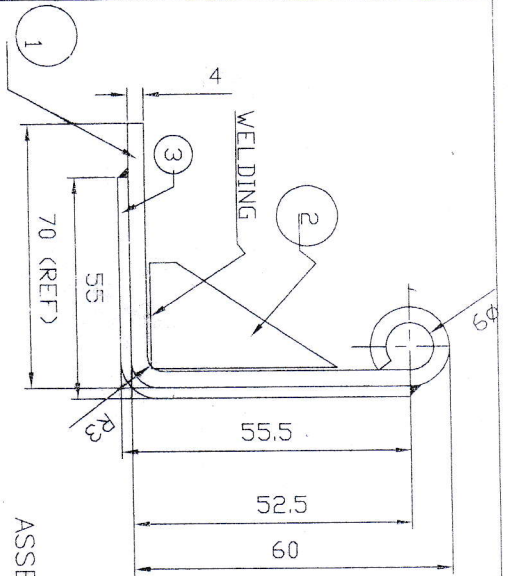
NOTE:

1. ALL DIMENSIONS ARE IN MM.
2. UNSPECIFIED LIMIT DEVIATIONS ARE ±1mm.
3. DRILL Ø9HOLES AFTER BENDING, TO BE ALIGNED

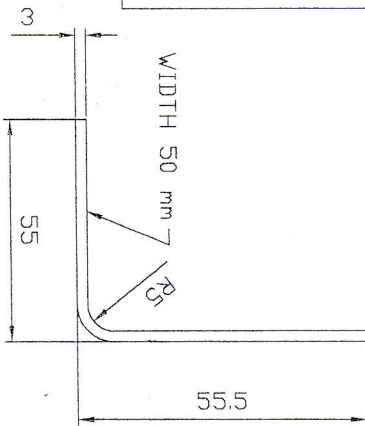
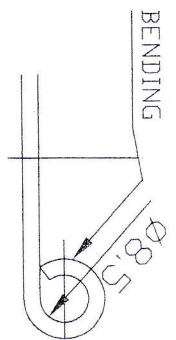
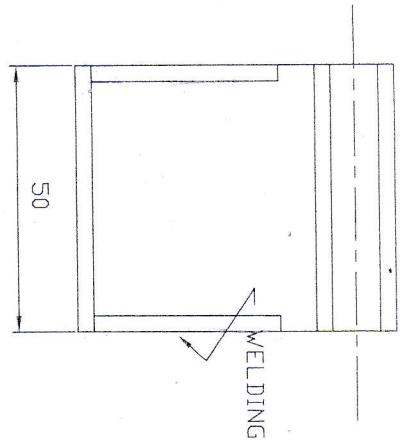


①  
DEVELOPMENT  
SIZE : 240X55X3.

ISSUE APPROD. <b>4-305</b> MATERIAL AMENDED.		NATURE OF AMENDMENT	
AUTH'D BY: YESU		DRG. NO: <b>485-03-1037</b>	SHEET NO SCALE
APRD. M.S.P. <i>H</i>		<b>HINGE (SEAT)</b>	MATERIAL: Fed 410WA TO IS: 2062-92 3mm THK
CHKD. M.K.			
DRWN. M.M.R.			
NAME	SIGN	DATE	IST ANGLE
ORDNANCE FACTORY MEDAK		USED ON	QTY/VEH



ASSEMBLY DRG



SIZE : 111X50X3  
QTY 2NOS

DRG IS TOTALLY AMENDED  
AS ON 21/11/03

MATERIAL AMENDED.

NATURE OF AMENDMENT

ISSUE APPROD. 4-3-05

AUTHOR B.YESU

APPRD M.S.P.

CHKD M.K.

DRWN BCD

NAME SIGN DATE

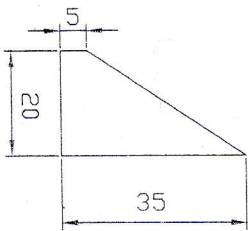
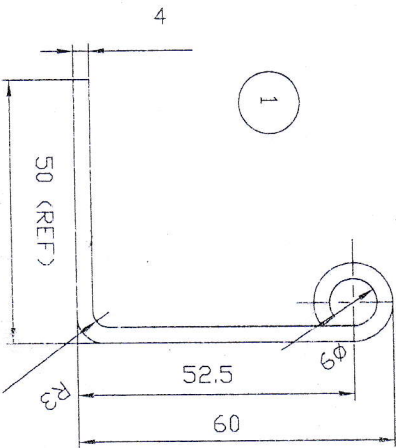
DRG. NO: 485-03-1038

CLAMP (SEAT)

MATERIAL: Fe 410W A to IS: 2062-91  
3/4 mm THK.

ORDNANCE  
FACTORY  
MEDAK

USED ON	QTY/VEH
TATA-407	8 SETS

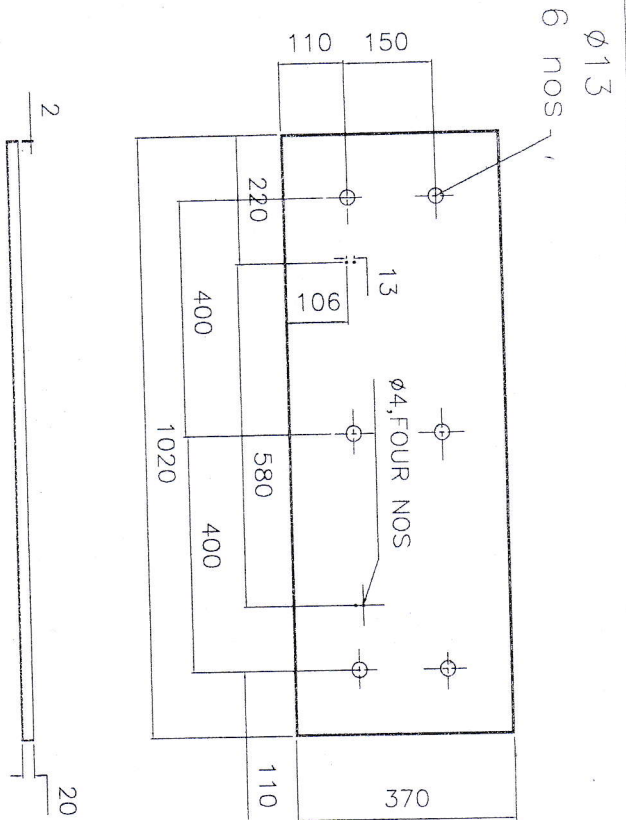


SIZE : 143X50X4  
QTY 1NOS

SIZE : 143X50X4  
QTY 2NOS

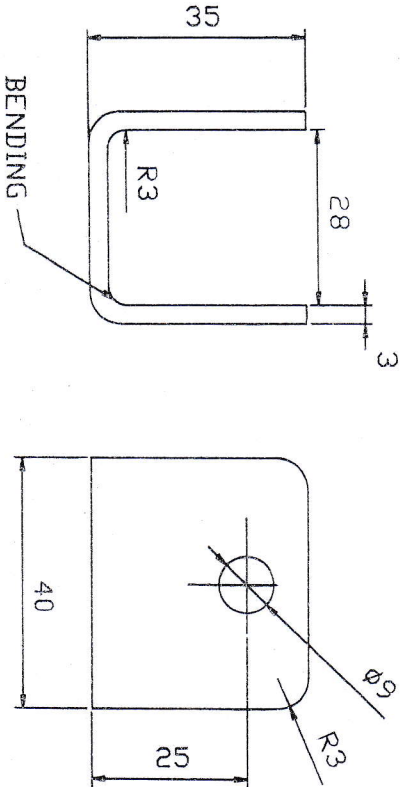
NOTE:

1. ALL DIMENSIONS ARE IN MM.
2. UNSPECIFIED LIMIT DEVIATIONS ARE  $\pm 1$ mm.
3. DRILL HOLES AFTER BENDING



- NOTE:
- 1) ALL DIMENSIONS ARE IN mm.
  - 2) HOLES  $\phi 13$  &  $\phi 4$  ARE TO BE DRILLED ON ASSLY.

(A) 4-3-05 MATERIAL AMENDED NATURE OF AMENDMENT		USED ON TATA-407	QTY./VEH. 4 SETS
ISSUE AUTH'D BY APR'D. K.V. CHK'D. M.K. DRAWN/PCD NAME SIGN DATE	DRG. NO: 485-03-1039 SEAT FRAME	SHEET NO SCALE WEIGHT	
ORDNANCE FACTORY MEDAK		MATERIAL: (A) 5x 3mm THK	



DEVELOPED SIZE 105X40X3

- NOTE:
1. ALL DIMENSIONS ARE IN MM.
  2. UNSPECIFIED LIMIT DEVIATIONS ARE  $\pm 1$ mm.
  3. DRILL HOLES AFTER BENDING

④ 4.205 MATERIAL AMENDED.

USED ON	QTY/VEH
TATA-407	8 NOS

ISSUE		APPROV.		MATERIAL AMENDED.	
AUTH'D.	BY	YES/NO	DATE	DATE	DATE
APPROV.	DATE				
CHKD.	DATE				
DRWN.	DATE				
NAME	SIGN	DATE			

DRG. NO: 485-03-1040

CLAMP (SEAT)

(TATA 407)

MATERIAL: ④ - 5mm THK  
Fe 410Wt to IS: 2062-92

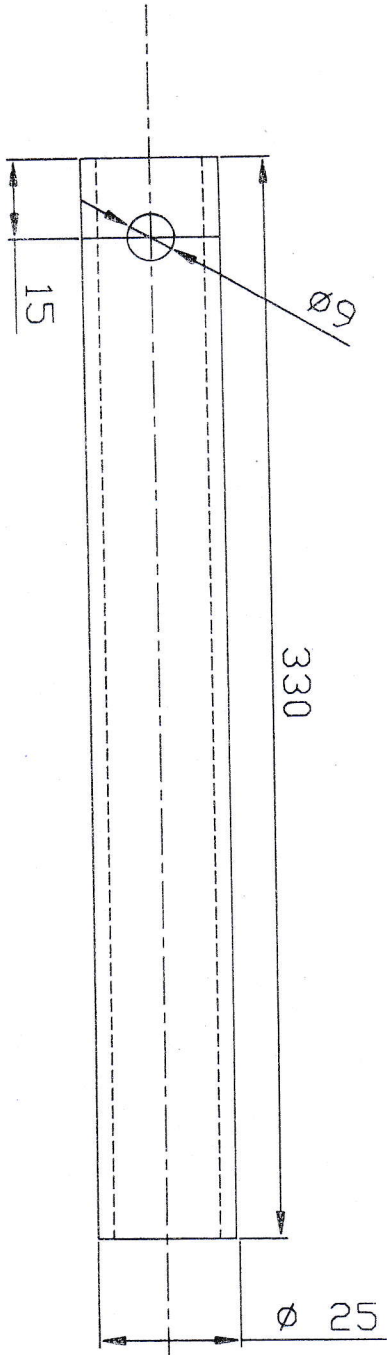
SHEET NO. SCALE WEIGHT

1ST ANGLE PROJ

ORDNANCE  
FACTORY  
MEDAK

④





SIZE : PIPE OD 25X330

NOTE:

1. ALL DIMENSIONS ARE IN MM.
2. UNSPECIFIED LIMIT DEVIATIONS ARE  $\pm 1$ mm.

DATE: 4-3-05 MATERIAL: A.M.E.N.D.E.D.

ISSUE: APPROD. NATURE OF AMENDMENT

DRG. NO: 485-03-1041

AUTHOR	DESIGN	DATE	ISSUE	APPROD.	NATURE OF AMENDMENT
M.S.P.	M.K.	13/8/11	1		
DRWING	M.A.R.	13/8/11			
NAME	SRIN	DATE			

ORDNANCE  
FACTORY  
MEDAK

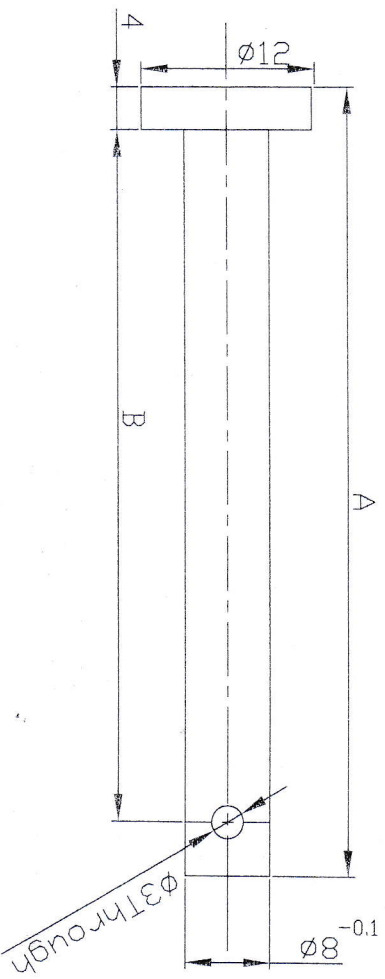
LEG (PIPE)  
(FOR SEAT)

MATERIAL: A  
SERIAL: 15:3074-79

1ST ANGLE PROJ

USED ON	QTY/VEH
TATA-407	00





	A	B	QTY
1	75	63	8
2	47	37	8

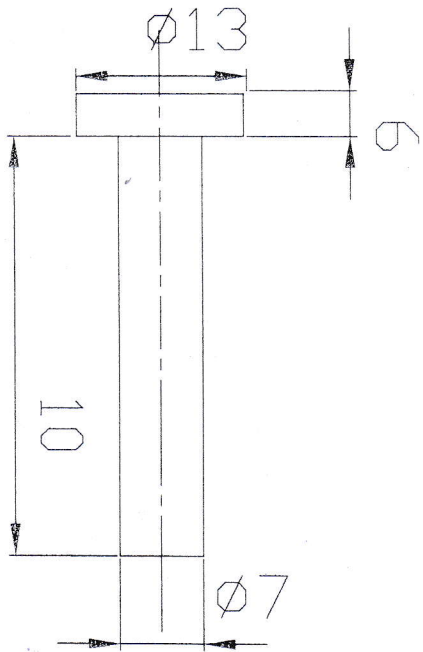
- NOTE:
1. ALL DIMENSIONS ARE IN MM.
  2. UNSPECIFIED LIMIT DEVIATIONS ARE  $\pm 1$ mm.

SIZE :  $\phi 12 \times 75$  8NOS  
 $\phi 12 \times 47$  8NOS

✓ (90)

USED ON	QTY/VEH
TATA-407	8+8

ISSUE	APPRD.	NATURE OF AMENDMENT
AUTH'D. BY	YES/NO	DRG. NO: 485-03-1043
APPRD. M.S.P.	✓	PIN (SEAT)
CHKD. M.K.		
DRWN. M.M.R.		
NAME	SIGN	
ORDNANCE FACTORY MEDAK		MATERIAL: MS / ENB
		1ST ANGLE PROU
		SHEET NO SCALE WEIGHT



- NOTE:
1. ALL DIMENSIONS ARE IN MM.
  2. UNSPECIFIED LIMIT DEVIATIONS ARE ±1mm.

1 (41)

ISSUE APPR		NATURE OF AMENDMENT	
AUTH'D	YES/NO	DRG. NO:	485-03-1043-01
APRD	M.S.P.		
CHKD	M.K.		
DRWN	M.K.R.		
NAME	SIGN	DATE	

ORDNANCE  
FACTORY  
MEDAK

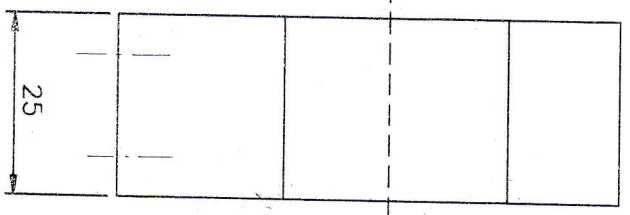
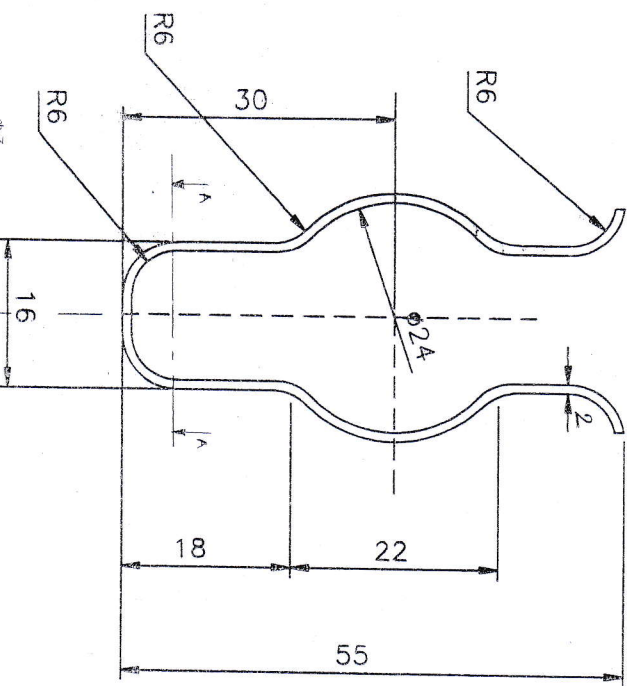
PIN (SEAT)

MATERIAL: MS / EN8

USED ON	QTY/VEH
TATA-407	2

SHEET NO	SCALE	WEIGHT

1ST ANGLE PROJ



BLANK SIZE : 130x25x2

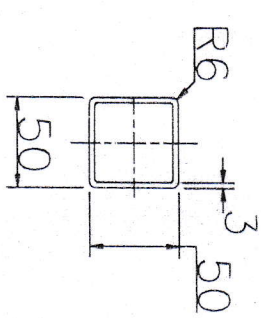
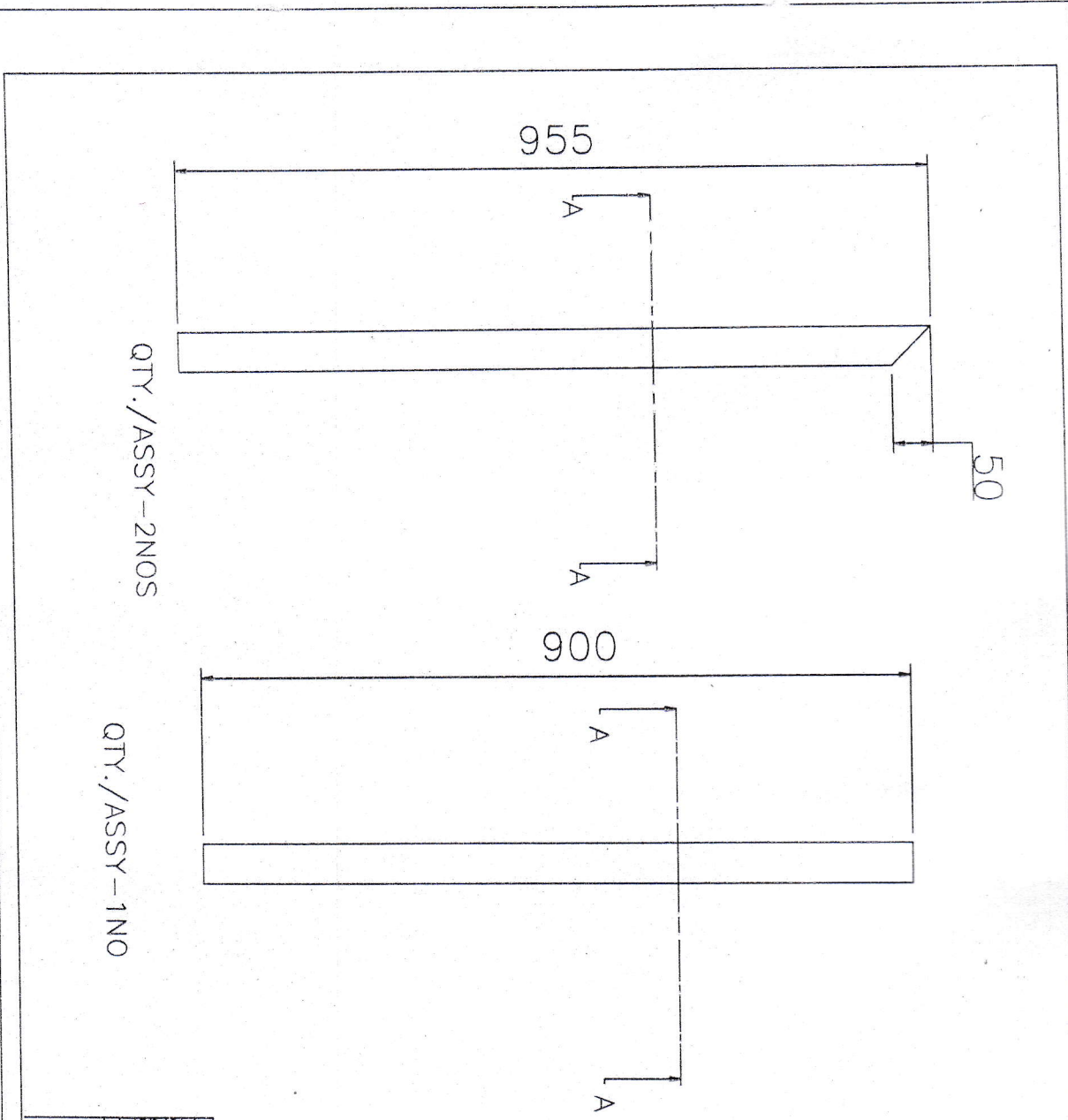
NOTE :-

1. ALL DIMENSION ARE IN MM
2. UNSPECIFIED RADIUS R3
3. REMOVE SHARP CORNERS AND BURRS

ISSUE		APPROD.		MATERIAL AMENDED	
AUTHOR		APPROD.		NATURE OF AMENDMENT	
CHKD.	DATE	NAME	SIGN	DATE	
DRG. MARK	DATE	NAME	SIGN	DATE	
ORDNANCE FACTORY MEDAK			LEG GRIP (TATA-407)		
DRG. NO: 485-03-1045			MATERIAL: Gr. 1 to IS: 4454 (Fe-52)		
SHEET NO. SCALE			WEIGHT		
THIRD ANGLE PROJECTION					

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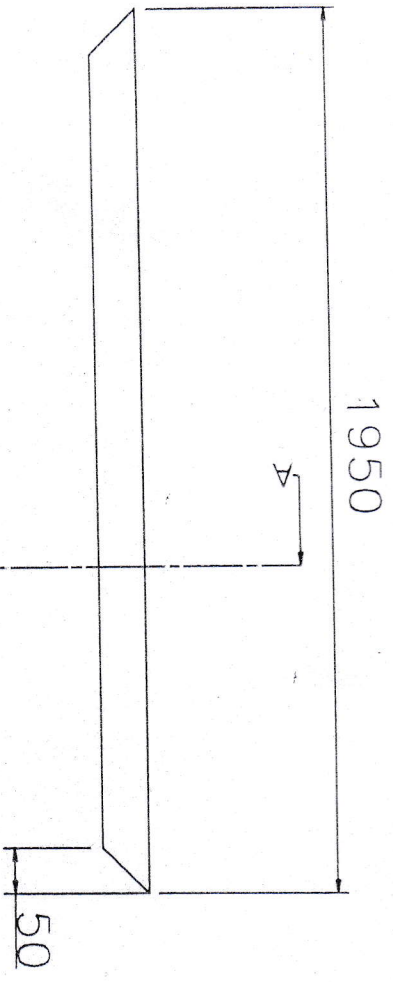
USED ON	QTY./VEH.
TATA407	



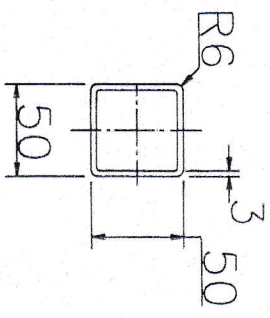
SECTION A-A

4.305 MATERIAL AMENDED.		DRG. NO: 485-03-1032	
ORDNANCE FACTORY MEDAK		VERTICAL MEMBER MATE: 41 68, 50K50X3 15:4923	
ISSUE APPROVED DATE	CHECKED DATE	DRAWN DATE	MADE DATE
USED ON QTY./VEH. TATA407 2+1		TYPICAL ANGLE PROJECTION	

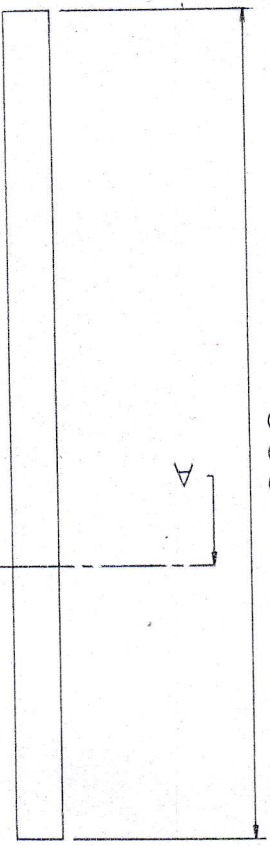
79



QTY./ASSY-1NO



SECTION A-A



QTY./ASSY-2NOS

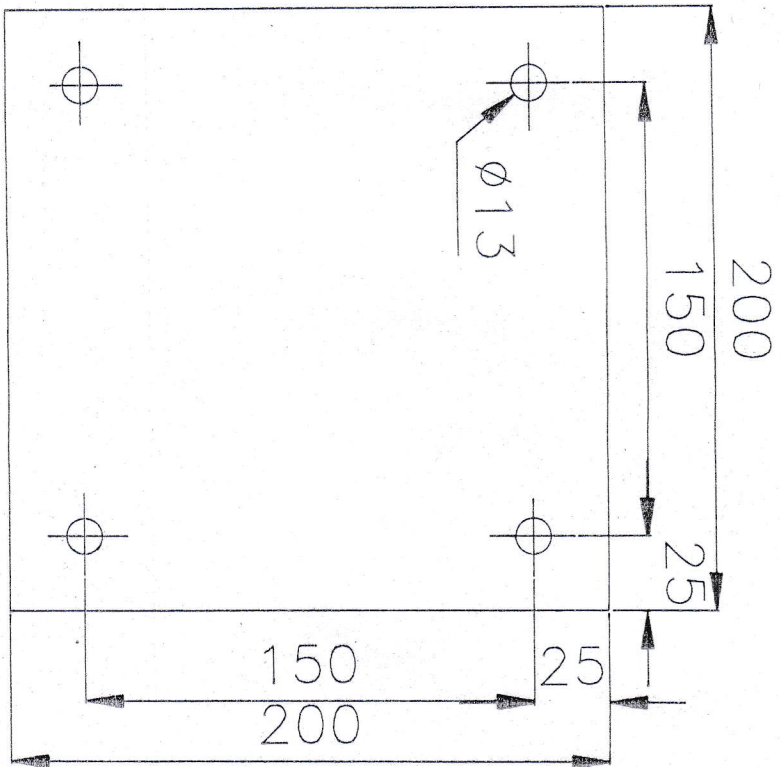
④ 4-305 MATERIAL AMENDED.

USED ON	QTY./VEH.
TATA407	1+2

ISSUE	APPROVED	NATURE OF AMENDMENT
DATE		
APPROVED BY		
DESIGNED BY		
CHECKED BY		
DRAWN BY		
SCALE		
ORDNANCE FACTORY MEDAK		
HORIZONTAL MEMBER		
MATL : ④ 5x68.50x10x2		
④ 15:4:923		
THIRD ANGLE PROJECTION		







SIZE : 200X200X6

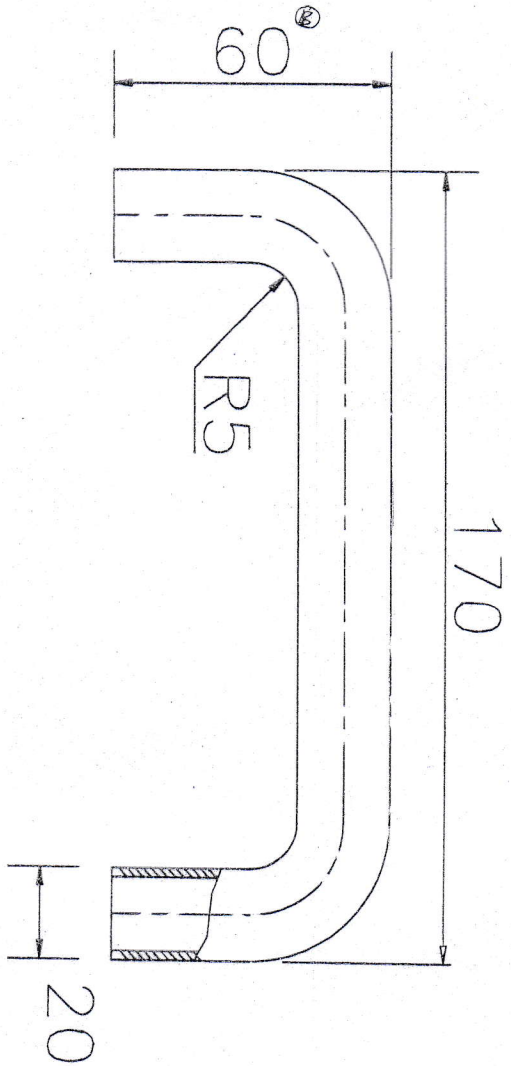
① 4305 MATERIAL AMENDED.

ISSUE	APPROV.	
DATE		
APPROVED BY		
DESIGNED BY		
CHECKED BY		
DATE		
ORDNANCE		
FACTORY		
MEDAK		

DRG. NO: 485-03-10-  
**BASE PLATE**  
 (TATA-407)

MADE AT: ② S.V. Pathan  
 To IS: 2062-92

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SIZE :- PIPE Ø20X260 L  
 PIPE THICKNESS :- 1.5MM

NOTE :-

1. ALL DIMENSION ARE IN MM
2. UNSPECIFIED RADIUS R3
3. REMOVE SHARP CORNERS AND BURRS

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4.305 W ISSUE ④ CANCELLED. MATERIAL AMENDED.		DRG. NO: 485-03-1047	SHEET NO. SCALE WEIGHT
ISSUE APPROD. ① 9.5.03	DIMN 90 WAS 60	NATURE OF AMENDMENT	USED ON TATA407
AUTHR BY YESU APPR M.S.P. ✓ CHGD S.K. ✓ DRWN M.M.R. ✓ NAME SIGN DATE	HANDLE (TATA-407)	DRG. NO: 485-03-1047	QTY./VEH. ②
ORDNANCE FACTORY MEDAK	MAIL: ③ Gr. C.D.S-2 to IS: 3074-79	THIRD ANGLE PROJECTION	THIRD ANGLE PROJECTION