

Y OE, A LI  
 DC 32884-A  
 DC 35613-A  
 DIM. CONVENTIONS TO CONFORM WITH SPECIFICATIONS.  
 TOLERANCE TO SPECIFICATIONS: ±0.02 IN. DIAM. CLAS. UNLESS OTHERWISE STATED.

**PROFILE OF TOOLED BODY**

SHOULD A PROJECTILE BODY BE TOO HEAVY THE MASS TO BE BROUGHT DOWN WITHIN LIMITS BY FINISHING IN FOLLOWING ORDER:  
 (1) OUTER PROFILE TO BE BROUGHT TOWARDS MIN. DIMS MAINTAINING MIN THICKNESS OF REAR PART.  
 (2) INNER PROFILE OF FRONT PART TO BE FINISHED TOWARDS MAX. DIMS MAINTAINING MIN. HEIGHT OF NOSE THREADS.

**NOTES :-**

THE FRONT & REAR PARTS WILL BE ASSEMBLED WITH APOXY RESIN ADHESIVE VIZ DOBECOIT 508/HARDNER 750. AFTER ALLOWING THE REQUIRED SETTING TIME 48 HRS. THE EXTERIOR OF BODY WITH EXCEPTION OF FACES B & C AND SCREW HEADS, A DRYING SEMI-GLOSSY POLYURETHANE BOND WILL BE PAINTED WITH A.M. PAINT. (COLOUR AS SPEC. IS - 5. LATERAL SURFACES WILL BE PAINTED WITH A.M. PAINT. (AND REGION WITH AMENDMENT) THE SCREW THREADS WILL NOT BE PAINTED. THE BOND WILL BE APPLIED TO THE SCREW HEADS AND THE SCREW THREADS WILL NOT BE PAINTED. THE BOND WILL BE APPLIED TO THE SCREW HEADS AND THE SCREW THREADS WILL NOT BE PAINTED. THE BOND WILL BE APPLIED TO THE SCREW HEADS AND THE SCREW THREADS WILL NOT BE PAINTED.

**METHOD OF APPLICATION OF DOBECOIT TO SCREW THREADS OF FRONT AND REAR PARTS OF BOMB.**

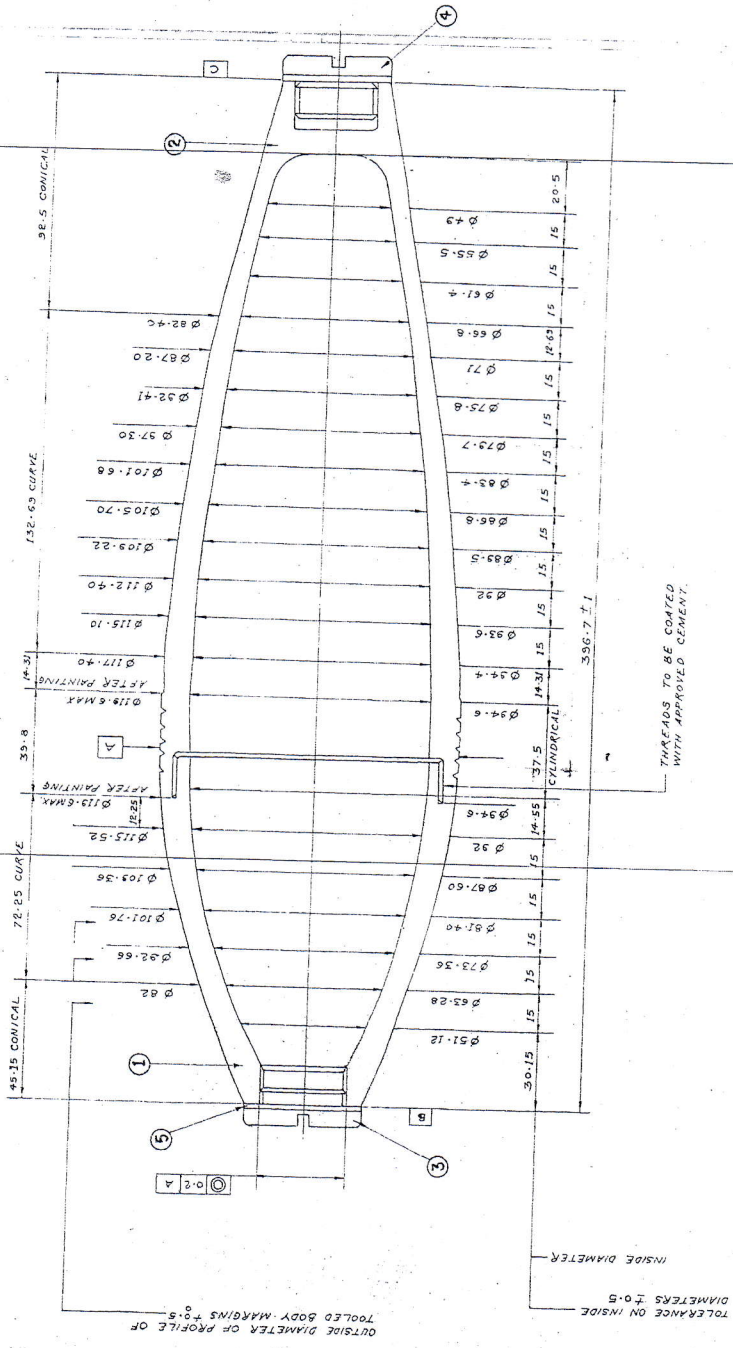
THE FRONT AND REAR PARTS OF THE BOMB WILL BE ASSEMBLED TOGETHER WITHIN 15-20 MINUTES AFTER THIS PERIOD. AT A TIME AS IT GETS HARDENED AFTER THIS PERIOD. CAPACITY 1717 CM<sup>3</sup> @ 1.0g.

**FOR MARKING ON EMPTY BODY SEE DRG. CIA/AMN/2443.**

AFTER ASSY. VARNISHING AND PAINTING ALL BODIES WILL BE SUBJECTED WHILST IMMERSED IN WATER TO 140 PSI INTERNAL AIR PRESSURE OF 850 ± 25 KPa MAINTAINED FOR ONE MINUTE.

EST. MASS - 0.540 kg ± 0.050 kg.

TECHNICAL REQUIREMENTS: SPEC NO. CQA(A)2541.



**LIST OF COMPONENTS**

ITEM NO.	DESCRIPTION	DESIGNER'S REF.	PART NO.	QTY.	REMARKS
1	FRONT PART 1A	CIA/AMN/2443	ITY 178	1	
2	REAR PART	CIA/AMN/2443	ITY 80	1	
3	PLUG, FUSE HOLE, TRANSIT	CIA/AMN/2450	ITY 179	1	
4	BASE PLUG TRANSIT	CIA/AMN/2424	ITY 93	1	
5	WASHER	CIA/AMN/2442		1	

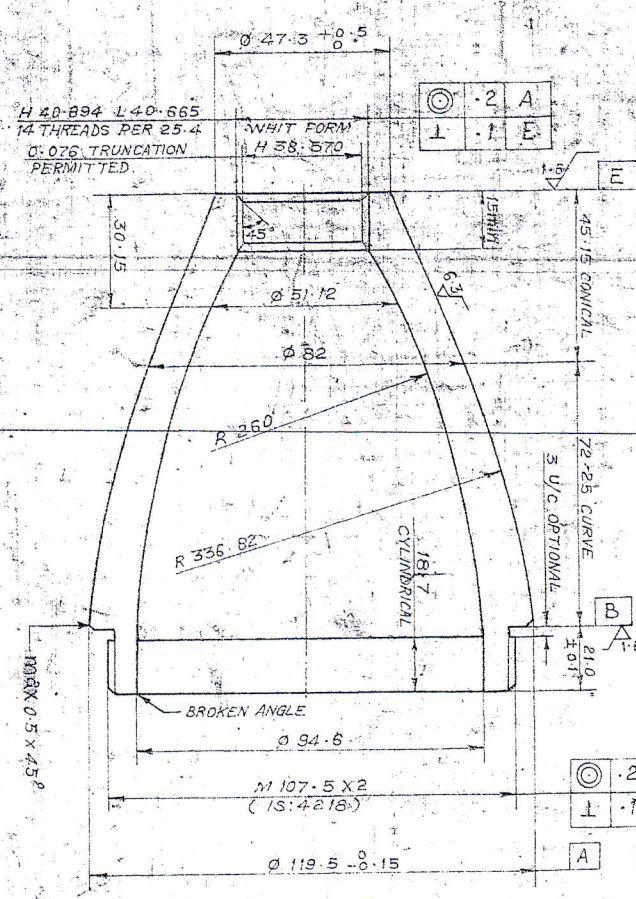
**REVISIONS**

NO.	DATE	BY	REVISION
1	1998	...	...
2	...	...	...
3	...	...	...
4	...	...	...
5	...	...	...

**MORTAR BOMB 120mm HE, 1A**  
**EMPTY BODY - (TWO PIECE SCREWED)**

DRG. NO. CIA/AMN/2443  
 DATE 11/01/98  
 AUTHORITY  
 REVISION

APPROVED BY: CIA/AMN/2443  
 DATE: 03/09/97  
 NAME: ...



TOLERANCE ON UNTOLERANCED DIMENSIONS AS PER IS: 2101-MEDIUM CLASS. VARIATION IN WALL THICKNESS AT ANY GIVEN CROSS SECTION NOT TO EXCEED 0.4 mm

**NOTES :-**

1. THE WHOLE OF THE INTERIOR AND EXTERIOR SURFACES AFTER FINISHING WILL BE RUST-PROOFED BY AN APPROVED METHOD. THE PROTECTIVE COATING TO BE USED SHALL BE AS PER 1988 CLASS II. PHOSPHATING TO SPEC ISS 0145 ON IMMEDIATELY AFTER PHOSPHATING. EXTERIOR SURFACE AND THE SCREW HEADS WILL BE COATED WITH IMPERMEABLE TO WATER COATING OR LACQUER TO IND/SI/2804 (REFER ISS 1988)
2. THE INTERNAL SURFACE EXCEPT SCREW THREADS WILL BE COATED WITH APC No 281 TO SPEC. (REFER ISS 1988) OR STORED.

**MATERIAL :-**

STEEL TO SPEC. ISS 9510 - 1 ~~1988~~ AUG 82 TO CODE No 55 / P.44  
 MACHINED BOMB BODIES AFTER HEAT TREATMENT WILL BE TESTED TO SATISFY MECHANICAL PROPERTIES AS MENTIONED BELOW

TENSILE STRENGTH 835 TO 1050 MPa  
 ELONGATION 8% MINIMUM  
 ELASTIC LIMIT 590 MPa MINIMUM  
 HARDNESS 250 TO 300 HB.

**TECHNICAL REQUIREMENTS :-**

Spec No. 594(X) 2341

DEN-MARK	CHD-SR	RD-MDZ	QUNE-WG	ISSY-PBR	17V-8DA
90%	0.7%	SCALE	1:1		
C.D/MKH	O/R/O	EST MESS	DATE	DATE	DATE
		FOR C/ES	DATE	DATE	DATE
		PROTECTIVE FINISH AS STATED			

30.10.93	PC 35613-A	DRG. SEALED.	DRG. EQUIPMT AND EXCHANGES NOT TO BE MADE WITHOUT PERMISSION FROM DRG. CONTROL OFFICE.
10.6.96	PC 35643-A	DRG. EQUIPMT AND EXCHANGES NOT TO BE MADE WITHOUT PERMISSION FROM DRG. CONTROL OFFICE.	
9.4.98	DCI 35994-A	DRG. SEALED WITHOUT CHANGE	
DATE	AUTHORITY	DRG. CONTROL OFFICE	

DRG. SEALED 19-4-86 (9901) 35.10.93 DRG. SEALED

FRONT PART IA