

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 SOLDED TO BODY, AFTERWARD IS TO BE LEFT UNPAINTED.

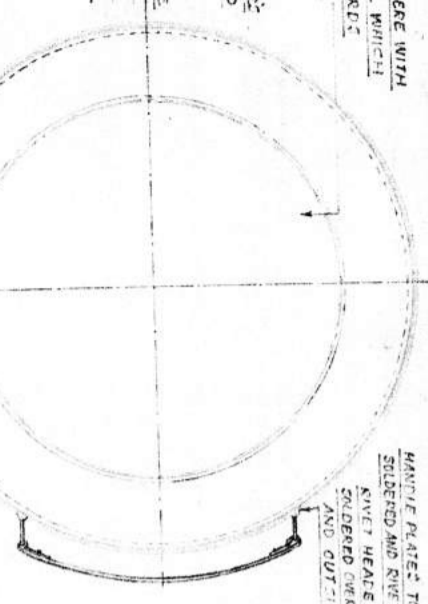
TO BE LABELLED HERE WITH AN APPROVED LABEL WHICH IS TO BE AFTERWARDS VARNISHED OVER.

NOTE - PACKING AND SOLDERED LABEL TO BE INSERTED BEFORE COILING.

AFTER PACKING ITEM 3 TO BE LIGHTLY SOLDED TO ITEM 1 WITH SOLDER SN 40 TO FORM A TIGHT JOINT TO FORM AN AIR TIGHT JOINT.

HANDLE TO BE PAINTED SERVICE COLOUR BEFORE ASSEMBLY POSITION OF HANDLE WILL BE AS FLAT AS POSSIBLE DURING TRANSPORT.

HANDLE PLATE TO BE SOLDERED AND RIVETTED SWEET HEAT TO BE SOLDED OVER WORK AND OUTSIDE.



TWO FELT DISCS (24x5 (S&N DIA) MOTTEN PROOFED TYPE MEDIUM HARD VARIETY NO 4, 35 (S&N) THICK) TO CHECK INS-1989 SECURED TO BENCH PLATE IN LID & BOTTOM BY ANY SUITABLE METHOD (ONE IN LID & ONE IN BOTTOM).



METHOD OF ASSEMBLY EMPTY

VARNISHING - THE CYLINDER IS TO BE COATED INTERNALLY WITH AMMUNITION SEALING COMPOSITION NO 221 TO JCS 1973 (LATEST ISSUE) OR WITH VARNISH AIR DRYING AMMUNITION TO IND/INT/713.

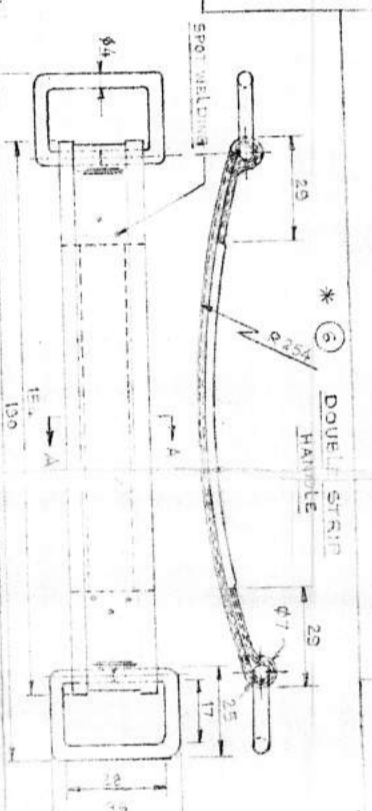
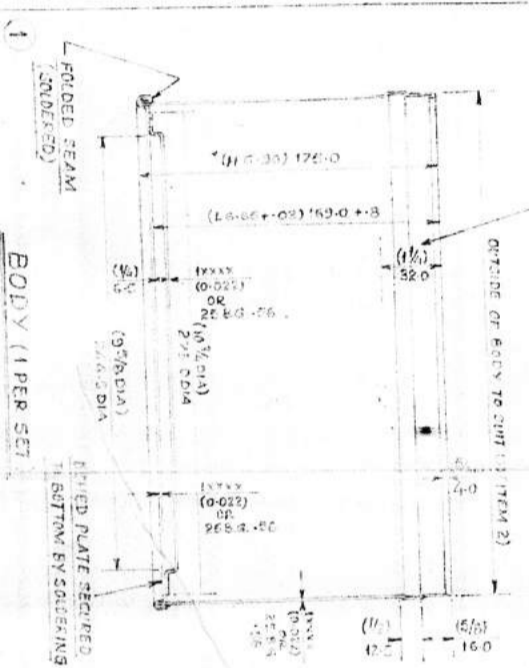
REVISIONS

NO	DATE	AMENDMENT	BY	CHKD
1	23-3-08	150 METRE CORD DETONATION A	DVA/RY	SIEN
2	10-10-08	TYPE 'DEEP DRAWING' DESIGNATION 'GPD' TO SPECIFICATION IS: 277-2003, AMENDED VIDE IC LETTER 10/HAS/AMEND. DT: 03-10-09 AND NEW DC NO 37183-A	DVA/RX	
3	23-3-08	150 METRE CORD DETONATION A	DVA/RY	SIEN

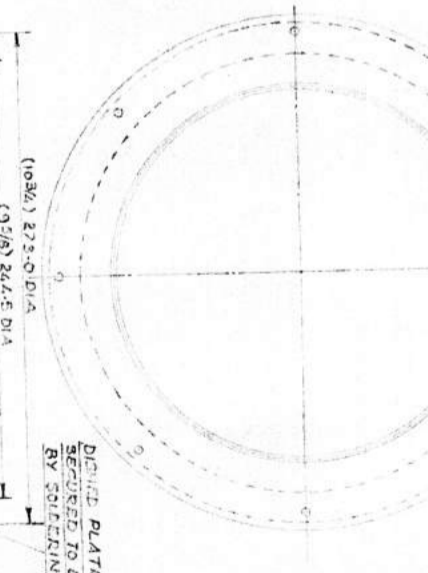
MARKING - TO BE STAMPED ON FROM OUTSIDE IN APPROX. 300 (40) LETTERS NO 443 MARK OF CYLINDER TO BE IN CONTRACTOR'S INITIALS OR RECOGNISED MARK YEAR OF MANUFACTURE.



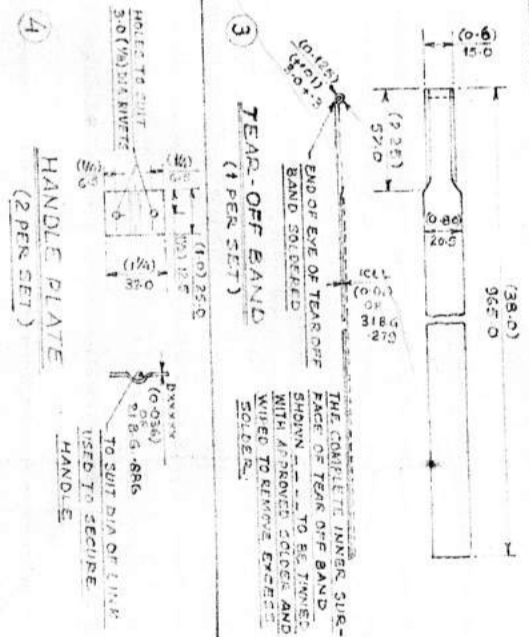
FOLDED SEAM, FLUSH INSIDE STITCHED START ABOUT 300 (40) FROM TOP AND A LAP SEAM BE NOTICED AT GAGE TO FACILITATE ASSEMBLY OF BOTTOM.



BLUET 300 (40) DIA DIMPLED PLATE TO FACILITATE SOLDERING.



LID (1 PER SET) (110.0+0.0 INSIDE DIA) 270.0+0.4 INSIDE DIA



HANDLE PLATE (2 PER SET)

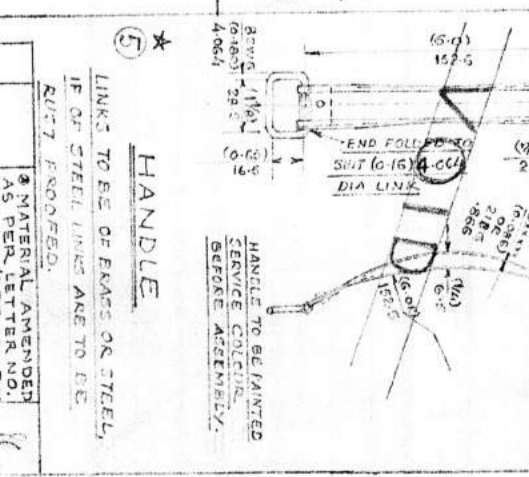
NO	DATE	AMENDMENT	BY	CHKD
1	27-02-04	MATERIAL AMENDED AS PER G.A APPROVAL NO. 94 17/FAL DT: 14-04-04 AND AMENDED VIDE CENP. 35693-A DT: 18-04-04.	DVA/RY	SIEN
2	28-07-04	REAFFIRMATION OF 151280-1976 IN 1976.	DVA/RY	SIEN
3	28-07-04	REAFFIRMATION OF 151280-1976 IN 1976.	DVA/RY	SIEN
4	5-1-07	* ITEM NO. 5, HANDLE ADDITION (DOUBLE STRIP HANDLE) (SINGLE STRIP HANDLE)	DVA/RY	SIEN
5	5-1-07	* ITEM NO. 6, HANDLE ADDITION (DOUBLE STRIP HANDLE)	DVA/RY	SIEN

GENERAL NOTE SHEET TYPE "DEEP DRAWING" DESIGNATION "6RD" TO SPECN. IS: 277-2015. AMENDMENT VIDE CX LETTER NO. CX/1052/10 DTD: 22-05-2010 & C LETTER: CX/1052/10/10/10 CORRE. DT: 04-10-10. AMENDMENT IN BRACKET ARE IN INCHES.

NOTE - DIMENSIONS ON UNTOUCHED DIMENSIONS (2.02 ± 0.05 MM).

MATERIAL - BEST CORE GRADE DEEP DRAWING UNASSORTED QUALITY STAMPING DIMENSIONED QUALITY TO SPECN IS: 577 (LATEST ISSUE).

HANDLE - STEEL SHOULD BE HALF HARD BRIGHT DRAWN TO SPECN IS: 280 LATEST ISSUE.



HANDLE

NO	DATE	AMENDMENT	BY	CHKD
1	03-06-08	MATERIAL AMENDED AS PER LETTER NO. 151280-1976 IN 1976 AND TO LETTER NO. 105 (AMENDMENT) DT: 03-06-08 AND TO LETTER NO. 105 (AMENDMENT) DT: 03-06-08.	DVA/RY	SIEN
2	24-2-93	SCALE - 3/4	DVA/RY	SIEN
3	03-06-08	ORIGINANCE FACTORY BRANDARA	DVA/RY	SIEN
4	03-06-08	CYLINDER NO. 443 MARK 1/L ONE SEAL CONTAINING 150 NETER CORD DETONATION A	DVA/RY	SIEN
5	03-06-08	SCALE - 3/4	DVA/RY	SIEN

TOP FROM C1(A) KIPKE DAG N.3 D-D(1) 16472 E DT-