ENSURE THAT IT DOES NOT PROJECT OUT OF DIA. 27.7-0.1
BY STABLING AT THREE EQUI-RADIUS PLACES AS SHOWN

ITEM 4 TO BE SECURED IN POSITION

COPY ISSUED BY A.C. 40197

DRAWN BY: C. W. LANG

CHECKED BY: C. W. LANG

APP'D TO: 28-05-79

REVISED: 01-09-01

CONSTRUCTION/DRAWING/CLASS: BRAVO-10

DATE: 01-09-01

DRAWING NO.: 6102 01 03 11 03 301 000

REV.: 01
**FLARING SHOULD ENSURE THAT RIVET REMAINS IN FIRM POSITION WHEN LOAD OF 100 Kg IS APPLIED IN THE DIRECTION OF ARROW OVER THE RIVET.**

**NOTES:****

1) NO CRACKS ARE PERMITTED IN THE FLARED PORTION OF ITEM 3 AFTER FLARING OPERATION.
2) THERE SHOULD NOT BE ANY GAP BETWEEN COVER FUZE AND BODY UPPER
NOTES:
1) DIMS. APPLY AFTER PLATING.
2) BURRS/SHARP EDGES NOT PERMITTED.
3) GROOVE DIMENSION SHOULD ACCOMMODATE SEALING WASHER PERFECTLY.
STRAIGHT KNURLING 0.5 DEEP
TO SPEC.IS:3403-1981.
NOTES:
1) DIMNS. APPLY AFTER PLATING.
2) BURRS/SHARP EDGES NOT PERMITTED.
3) SURFACE MARKED 'X' MUST BE FLAT & SQUARE TO THE AXIS

COPY ISSUED BY: [Signature]
Date: 14-05-2019

OUTSIDE RO-6 WAS INSIDE: B-1,2

MATERIAL: STEEL SHEET TO SPEC. IS513-1986 Grade.

PROTECTIVE FINISH TO BE ZINC PLATED TO SPEC. IS6573
FeZn5 FOLLOWED BY CHROMATE PASSIVATION.

DESIGN AUTHORITY: [Signature]

TITLE: CAP SPRING STRIKER

PART No. [1000 10 0 5 0 1 0 0 0 0 0 0]
NOTE:
BURRES/SHARP EDGES NOT PERMITTED.
TOLERANCES ON SPRING SPEC. IS 7906 Pt.II

FREE LENGTH 7 ±0.1

Ø8.8±0.1

5

2500g±200g

WIRE DIA -------------- 0.90
No. OFF EFFECTIVE COILS ---2.5
WOUND --------------- LH.

APPROX. 1/2 COIL AT EACH END TO BE CLOSED IN & SQUARE TO THE AXIS.

NOTES:
1) THERE SHOULD NOT BE ANY PERMANENT SET WHEN IT IS COMPRESSED & KEPT FOR 48 HOURS.
2) DIMNS. APPLY AFTER PLATING.

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<tr>
<th>R. No.</th>
<th>DATE</th>
<th>AUTHORITY</th>
<th>BRIEF RECORD</th>
<th>ZONE</th>
<th>CD</th>
<th>GO</th>
<th>SIGN</th>
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<tbody>
<tr>
<td>DRN.</td>
<td>SABLE</td>
<td>CHD, WILF</td>
<td>MATERIAL:</td>
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<td>APPD.</td>
<td>DATE:</td>
<td>15/6/98 FOR DIRECTOR</td>
<td>PROTECTIVE FINISH TO BE CADMIUM PLATED TO SPEC.</td>
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<td>SEALED</td>
<td>DATE:</td>
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<td>IS 4572 Cd8. FOLLOWED BY CHROMATE PASSIVATION.</td>
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<tr>
<td>SCALE:</td>
<td>5:1</td>
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<td>TITLE:</td>
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<tr>
<td>EST.MASS:</td>
<td>0.32 g</td>
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<td>CONICAL SPRING</td>
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DESIGN AUTHORITY: ARDE

DRG.: 102 S 03 04 10 03 03 DIODES

PART No. | BS CAT No. | AHSP |
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COPY ISSUED BY G. D. N. R. 4-05-19
8-RIBS 0.5 EQUISPACED AS SHOWN.
NOTES:
1) DIMNS. APPLY AFTER PLATING.
2) BURRS/SHARP EDGES NOT PERMITTED.
NOTES:
1) THERE SHOULD NOT BE ANY GAP WHERE THE LEAF SPRING OVERLAPS WHEN ASSEMBLED.
2) THERE SHOULD NOT BE ANY DEFORMATION OF LEAF SPRING DURING ASSEMBLY.

ITEM LIST

<table>
<thead>
<tr>
<th>ITEM</th>
<th>QUANTITY</th>
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<tr>
<td>1</td>
<td>1</td>
<td>COVER FUZE</td>
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<tr>
<td>2</td>
<td>1</td>
<td>LEAF SPRING</td>
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COMPOUNDS ORG NO. CHANGED

R. DATE AUTHORITY BRIEF RECORD ZONE SIGN

DRGN. NO. 9102 00 03 10 18 001 002

COVER FUZE & LEAF SPRING ASSY.

PART NO. BS CAT NO. AH5
NOTES:
1) DINNS. APPLY AFTER PLATING
2) BURRS/SHARP EDGES NOT PERMITTED
NOTES:
1) DIMNS. APPLY AFTER PLATING
2) BURRS/SHARP EDGES. NOT PERMITTED
3) SURFACE MARKED 'X' MUST BE FLAT & SQUARE TO THE AXIS.

COVER SHUTTER HOUSING
NOTES:
1) DIMNS. APPLY AFTER PLATING.
2) BURRS/SHARP EDGES NOT PERMITTED.
3) SURFACE OF Dimple PROTRUSION SHOULD BE SMOOTH FROM INSIDE.

COVER STRIKER SLEEVE
NOTES:
1) DIMNS. APPLY AFTER PLATING.
2) HOLE Ø1.4 SHOULD BE FREE FROM BURRS/SHARP EDGES.
3) * THIS DIMENSION IF ENSURES INTERFERENCE FIT ON HOUSING SRD TO COMPONENT No. 9102 00 03 00 01 005 00DA WITHIN 0.06 TO 0.08 mm IS ACCEPTABLE.

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<thead>
<tr>
<th>R No.</th>
<th>DATE</th>
<th>AUTHORITY</th>
<th>BRIEF RECORD</th>
<th>ZONE</th>
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<tbody>
<tr>
<td>DRN. SABLE</td>
<td>CHD. 3403</td>
<td>MATERIAL:</td>
<td>STEEL SHEET TO SPEC. IS/513-1986 GD. EDD</td>
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<td>APPEAL</td>
<td>DATE: 15/6/98 FOR DIRECTOR</td>
<td>PROTECTIVE FINISH TO BE ZINC PLATED TO SPEC. IS/573</td>
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<td>FE2N5 FOLLOWED BY CHROMATE PASSIVATION.</td>
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<tr>
<td>SCALE: 5:1</td>
<td>EST.MASS: 0.19 g</td>
<td>TITLE: CUP I SRD</td>
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<td>DRG. No. 9102 00 03 00 01 009 00DA</td>
<td>IS CAT No.</td>
<td>AHSP</td>
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NOTES:
1) DIMNS. APPLY AFTER PLATING.
2) BURRS/SHARP EDGES NOT PERMITTED.
3) SURFACE MARKED 'X' MUST BE FLAT & SQUARE TO THE AXIS.
NOTES:
1) BURRS/SHARP CORNERS & PIP NOT PERMITTED.
2) DIMNS. APPLY AFTER PLATING.
NOTES:
1) DIMNS. APPLY AFTER ANODISING.
2) BURRS/SHARP EDGES NOT PERMITTED.

ALT. MATERIAL ADDED: AL ALLOY TO SPEC. IS:733-24345 W OR WP.
PROTECTIVE FINISH: TO BE ANODISED TO SPEC. DEF 151-1966 TYPE 2
NOTES:
1) DIMNS. APPLY AFTER PLATING.
2) BURRS/SHARP EDGES NOT PERMITTED.
3) * THIS DIMENSION IS INTERFERENCE-FIT TO CUP I SRD TO COMPONENT No. 9102 00 03 00 01 009 00DA WITHIN 0.06 TO 0.08 mm IS ACCEPTABLE.
TEST NOTE:
LEAF SPRING WHEN ASSEMBLED IN THE RECESS OF Ø115:
1) SPRING END SHOULD BE OVER LAPPED PROPERLY
2) SPRING SHOULD NOT HAVE PERMANENT SETTING EVEN AFTER 48 HRS.
3) SPRING GAP TO EXPAND TO 10 mm WHEN A LOAD OF 225 ± 15 N IS APPLIED

NOTES:
1) BURRS/SHARP EDGES NOT PERMITTED.
2) DIMNS. APPLY AFTER PLATING.
3) HARDNESS 450 ± 50 VHN/5 kg
**NOTES:**

1. DIMNS. APPLY AFTER PLATING
2. TO BE NORMALISED.
3. HARDNESS 170±10 VPN.

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<td>APPD.</td>
<td>DATE: 15/6/98 FOR DIRECTOR</td>
<td>STEEL TO SPEC. IS:2073-1962 OR BS 970 EN8.</td>
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<td>PART NO.</td>
<td>BS CAT NO.</td>
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NOTE:
1) DIMENSION OF THE SEALING WASHER SHOULD ENSURE PROPER FITMENT
   IN THE GROOVE OF BODY UPPER TO COMPONENT No. 9102 00 03 10 17 001 000A
2) SEALING WASHER SHOULD BE FREE FROM ANY FLASHES.

COPY ISSUED BY CCOK/OFAJ

Date: K. 05/19

ATERIAL:
NEOPRENE TO SPEC. IND/ME/884(PROV) CLASS C-5

PROTECTIVE FINISH:

TITLE: SEALING WASHER
ITEM 4 TO BE SECURED IN POSITION
BY STABBING AT THREE EQUISPACED PLACES AS SHOWN.
ENSURE THAT IT DOES NOT PROTRUDE OUT OF DIA 22.7-0.1
WIRE DIA  ---------------  0.5
No. OF EFFECTIVE COILS  ----  4
WOUND  ---------------  L.H.

NOTES:
1) TORQUE 1.47 Kg mm FOR 57° ANGULAR DEFLECTION.
2) DIMMS. APPLY AFTER PLATING.

SHUTTER SPRING
NOTE:
UNEVEN SURFACE FLASHES OR ANY OTHER DEFECT DUE TO MOLDING IS NOT PERMITTED.
NOTES:
1) DIMNS. APPLY AFTER PLATING.
2) HARDNESS 175 VPN/5 Kg.
3) BURRS/SHARP EDGES NOT PERMITTED.
4) NO CRACKS AT RIM EDGE PERMITTED.
5) FLATNESS OF RIM TO BE ENSURED.

ENLARGED VIEW ADDED  B-2

R No. DATE  AUTHORITY  BRIEF RECORD  ZONE  CD  GO
DRN.  SABLE  CHD.  APPD.  DATE: 15/6/98  PROTECTIVE FINISH: TO BE NICKEL PLATED TO SERVICE
SEALE DATE:  MATERIAL: STEEL SHEET TO SPEC. IS1513-1986 Gd. DD

SCALE:  EST. MASS: 0.45 g  TITLE: SPACER

DESIGN AUTHORITY

DRG.No. [9102 00 03 01 04 00] 00DB
TOLERANCE ON SPRING TO SPEC. IS:7906 Pt.II

WIRE DIA: 0.16
OUTSIDE DIA: 3.5
NO. OF EFFECTIVE COILS: 4.5
WOUND: L.H.

END COILS TO BE CLOSED IN AND SQUARE TO THE AXIS.

SPRING CENTRIFUGAL BOLT

DESIGN AUTHORITY: ARDE

DRG. No.: 91102 06 03 01 05 0.03 0100B

PART No.: 5E 75 4A A E 81 ST
TOLERANCE ON SPRING TO SPEC. IS:7906 Pt.II

SOLID LENGTH 2.4
TEST LENGTH 6
FREE LENGTH 13.3

OUT SIDE DIA -------------- 2.8
WIRE DIA ------------- 0.25
No. OF EFFECTIVE COILS ---- 6.5
WOUND ------------------ L.H.

END COILS TO BE CLOSED IN AND SQUARE TO THE AXIS.

NOTE:
1) DIMNS. APPLY AFTER PLATING.

R. No. DATE AUTHORITY BRIEF RECORD ZONE CD GO

BRN. SABLE CHD. D\&_D MATERIAL: SPRING STEEL WIRE TO SPEC. IS:4454 Pt.I Gd.3
APPPD. DATE: 15/6/98 FOR DIRECTOR PROTECTIVE FINISH: TO BE CADMIUM PLATED TO SPEC. IS:6572
SEALED DATE: Cd8 FOLLOWED BY CHROMATE PASSIVATION.

SCALE: 51, EST. MASS: 0.03 g TITLE: SPRING I.D.

DESIGN AUTHORITY ARDE

DRG.No. 21.02 00 03 01 01 01 01 00 00 00 00

PART No. DIS CAT No. AHSP
TOLERANCES ON SPRING SPEC. IS:7906 Pt.II

SOLID LENGTH 5
TEST LENGTH 6
FREE LENGTH 9

WIRE DIA = 0.45
No. OF EFFECTIVE COILS = 8
WOUND = R.H.
END COILS TO BE CLOSED IN & SQUARE TO THE AXIS.

NOTES:
1) THERE SHOULD NOT BE ANY PERMANENT SET WHEN IT IS COMPRESSED AND KEPT 96 HOURS.
2) DIMS. APPLY AFTER PLATING.

DRN. SABLE
APPD.
DATE: 15/6/98
SEALE D
DATE:

SCALE: 5
EST. MASS: 0.1 g
TITLE: SPRING SRD

MATERIAL: SPRING STEEL, WIRE TO SPEC. IS:4454 Pt.I Gd.3
PROTECTIVE FINISH: TO BE CADMIUM PLATED TO SPEC.
IS:4572 C88 FOLLOWED BY CHROMATE PASSIVATION

PART No. IS CAT No. AHSP
TOLERANCE ON SPRING SPEC. IS:7906 Pt.II

SOLID LENGTH 3.6
TEST LENGTH 7
FREE LENGTH 14.5

OUTSIDE DIA -------------- 4.75
WIRE DIA -------------- 0.40
No. OF EFFECTIVE COILS ___6
WOUND -------------- L.H.

END COILS TO BE CLOSED IN AND SQUARE TO THE AXIS

NOTE:
1. DIMNS. APPLY AFTER PLATING.

COPY ISSUED BY GENERAL

DATE: 14/05/98

Sqw. Rk. AHD

E

DRN. SABLE CHD. SABLE
APPD. DATE: 15/6/98 FOR DIRECTOR
SEALED DATE:

SCALE: 51
EST.MASS: 0.12

F

DESIGN AUTHORITY ARDE

Drg.No. 010 010 010 03 04 11 002 0014 DA

PART No. IS CAT No. AHSP
NOTES:
1) DIMNS. APPLY AFTER PLATING.
2) BURRS/SHARP EDGES NOT PERMITTED.
NOTES:
1) DIMNS. APPLY AFTER PLATING
2) BURRS/SHARP EDGES NOT PERMITTED.
NOTES:
1) DIMNS. APPLY AFTER PLATING.
2) BURRS/SHARP EDGES NOT PERMITTED.
NOTES:
1) DIMNS. APPLY AFTER PLATING
2) HARDNESS 450±25 VPN /10 Kg.
3) BURRS/SHARP EDGES NOT PERMITTED.