NOTES:
NOT ALLOWED:
1) CRACKING OF DELAY CUP
2) EXCESS LAYER OF COMPOSITION ME - 452 (A) ON BOTTOM SIDE.

NOTES:
1) ALL INCREMENTS PRESSED AT 340 ± 5 kg DEAD LOAD.
2) SWELL TIME - 10 Sec.
3) RH IN ALL FILLING SHOPS: 75 ± 5%
TO BE VARNISHED WITH APC 219 (RED)
(single coat)

TO BE TURNED OVER AND
FLATTENED WITH 60-70 Kg. LOAD.

SERVICE LEAD AZIDE: 50-55 mg,
PRESSED AT 160-170 Kg.
Dwell Time: 10 SEC.

L-MIX: 45-50 mg,
PRESSED AT 160-170 Kg.
Dwell Time: 05 SEC.

NOTE:
RH IN THE FILLING SHOP SHOULD NOT EXCEED 70%
DRAWING CONVENTION CONFORM TO INDIAN STD.
DIMNS IN mm UNLESS OTHERWISE STATED

BASED ON HEMRL DRG. No. HEMRL DRG 1268

COMPOSITION: ME 452 (A)
CHARGE WT: 60 - 5 mg.

COMPOSITION: AGS - 339
CHARGE WT: 55 + 5 mg.

BOTH COMPOSITIONS PRESSED TOGETHER AT 240 + 5 Kg.
Dwell time: 5 Sec.
Reverse the mould and repress the pellet at same dead load
AND DWELL TIME.

NOTE:
RH IN THE FILLING SHOP: 55 ± 5%

COPY ISSUED BY: CCE/OFM

Date: 22-07-90

E

R.No. DATE AUTHORITY BRIEF RECORD ZONE CD GD SIGN
DRN. SABLE CHD. MATERIAL:
APPRO DATE: 15/6/98 PROTECTIVE FINISH:
SCALE:
EST.MASS: TITLE:
DESIGN AUTHORITY ARDE:
DRG.No.
PART No.
BS CAT No.
AHSP
1) ITEM 6 TO BE FORCE FITTED ON ITEM 1 UNDER LOAD OF 80 KG DWELL TIME 5 SEC.

2) ENSURE Ø2.45 OF ITEM 4 RESTS ON FLANGE OF ITEM 3.
BOTH COMPOSITIONS PRESSED TOGETHER AT 340±5 Kg
Dwell Time: - 5 Sec.

NOTE:
RH IN THE FILLING SHOP: - 55±5%

COMPOSITION: AGS-306
CHARGE WT: - 30 ± 5 mg

COMPOSITION: ME452 (A)
CHARGE WT: - 30 ± 5 mg

RELAY PELLET
LEAD STYPHANATE (CHE. 39D)
CHARGE Vt.: 30 + 5 mg
PRESSED AT: 100 Kg
DWELL TIME: 5 Sec

SERVICE LEAD AZIDE
CHARGE Vt.: 30 + 5 mg
PRESSED AT: 100 Kg
DWELL TIME: 5 Sec

PEEN TYPE 'A'
CHARGE Vt.: 40 - 5 mg
PRESSED AT: 200 Kg
DWELL TIME: 5 Sec

NOTES:
INNER SURFACE OF THE CAP SHOULD BE FREE FROM ANY TRACE OF INITIATORY COMPOSITION.
RH IN THE FILLING SHOP SHOULD NOT EXCEED 70 %

ITEM LIST

<table>
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<tr>
<th>ITEM</th>
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BASED ON HEMR. BRG. NO. HEMR. BRG. 15590
COPY ISSUED BY CDR. D.P. JAIN
DATE: 14-05-2019

DESIGN AUTHORITY: S.D. DETONATOR (FILLED)
DRAWN BY: A

DRAWING CONVENTION CONFORM TO INDIAN STD.
CHECKED BY: A
REV.: 1

MATERIAL:

REFERENCES:
CODA 40X 34.4384594 MA-2-03884-82875

SIGNATURES:

ZONE: CD - GO

DATE: 15/6/98
PROTECTIVE FINISH
SEAL:
DAT.
SABLE
EST. MASS
TITLE:

DRAWING CONVENTION CONFORM TO INDIAN STD.
CHECKED BY: A
REV.: 1

MATERIAL:
NOTES:
1) TEAR OF DELAY CUP
2) CONTAMINATION OF 8 SURFACE OF DELAY CUP WITH FOREIGN MATERIALS NOT ALLOWED.

RH IN THE ASSEMBLY SHOP - 93 ± 5%
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<td>SHUTTER (FILLED)</td>
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TO BE STABBED 0.5 DEEP
AT FOUR PLACES EQUISPERED
AS SHOWN AT DEAD LOAD OF
275 Kg DWELL TIME 5 Sec.
Before filling introduce 15 + 5 no.
Composition ME - 452 C60 in the
Gap between ignition pellet and
guide pin III. (ERDL DRG 1273/5)
(For other details see Note 4.)

While positioning of ignition pellet
Composition ME 452 C60 should face
towards the guide pin III.
Composition - ACS 206
Charge wt - 728 ± 50 mg
Pressing load - 1600 ± 10 Kg
Dwell time - 20 Sec.
See Note 1, 2, and 3.

Item List

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<td>Relay Pellet</td>
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NOTES:
1. RH in the filling shop - 55 ± 5%
2. Rub excess delay composition if any gently on zero
   grade cherry paper and then on a soft cotton cloth.
3. Apply 3 coats of 5% Perspex solution in chloroform
   on circular delay column only with 3 minutes intervals
   and allow to dry for 2 hrs at room temp.
4. Apply thin coat of APC 97 to the ignition end of ignition
   pellet and bottom end of relay charge and allow to dry
   for 1 hr. at room temp.
NOTE:
RH IN THE FILLING SHOP - 55 ± 5X

ITEM LIST

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