

**TITLE : 1 SEC DELAY TUBE EMPTY**

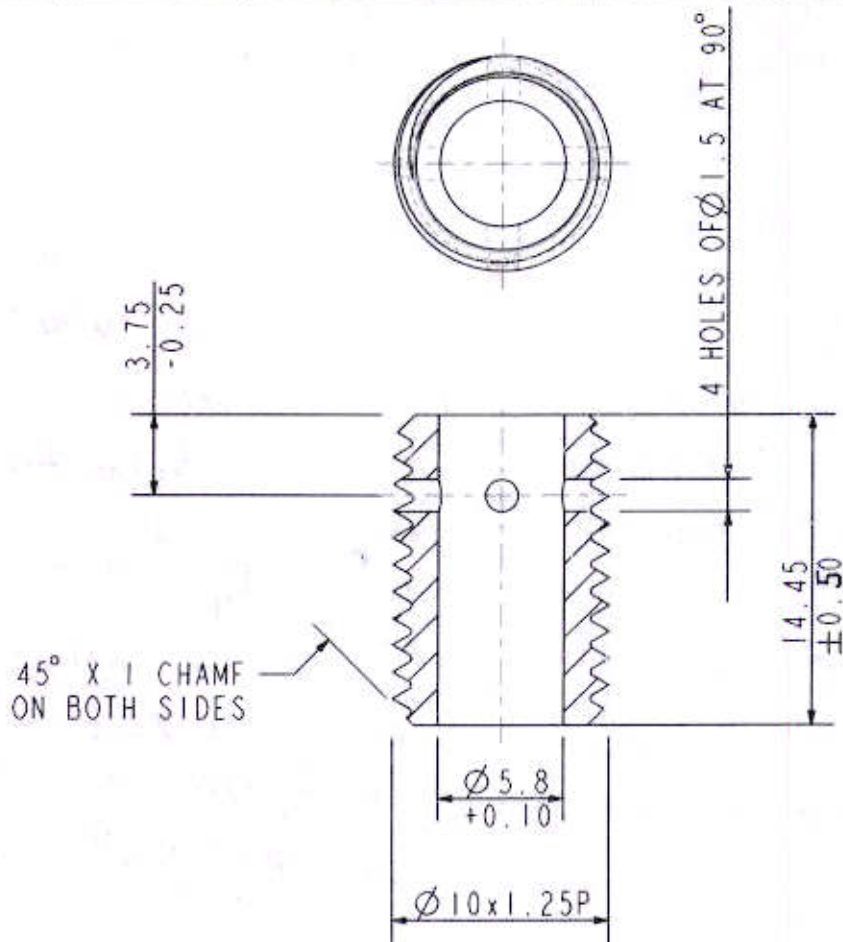
**DRAWING No. : TSG-0009**

**MATERIAL : ECTRUDED ALLUMINIUM ROD TO  
Specification IS 733-1967 HE 30 WP**

**ESTIMATED WEIGHT : 1.7 gms**

MACHINING DEVIATION TO ISI 2102 MEDIUM GRADE UNLESS SPECIFIED OTHERWISE

LENGTH OR DIA	MACHINING DEVIATION TO ISI 2102 MEDIUM GRADE UNLESS SPECIFIED OTHERWISE								LENGTH IN mm OF SHORTER SIDE OF ANGLE			
	UPTO 6	6 30	30 120	120 315	315 1000	1000 2000	2000 4000	4000 ABOVE	UPTO 6	6-30	30-120	120-400
	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0	±1	±30'	±20'	±10'



SECTION A-A

NOTE: BURS TO BE REMOVED. UNIFORM THICKNESS TO BE MAINTAINED THROUGH OUT THE LENGTH.

S.No	AMENDMENT	SIGN I/C	SIGN O/C	DATE	SIGN	DATE
					DGN :	
					DRN : HC MADAN PAL	12/01/12
					CHD : AJAY SAHAI, AC/AM	12/01/12
					RCMD : KAMAL KUMAR, ZIC/Manager	21/11/12
					APPD : SABU A JOSEPH, DIG/GM	03/01/12
					SCALE : 1 : 3	
					DATED : 12-01-2012	
					SHEET : 1 OF 1	
ALL DIMENSIONS ARE IN mm						
DRAWING & REPROGRAPHIC SECTION						
TEAR SMOKE UNIT,BSF, TEKANPUR, GWALIOR (M.P.), PIN - 475 005						

**TITLE : DELAY TUBE 2 SEC**

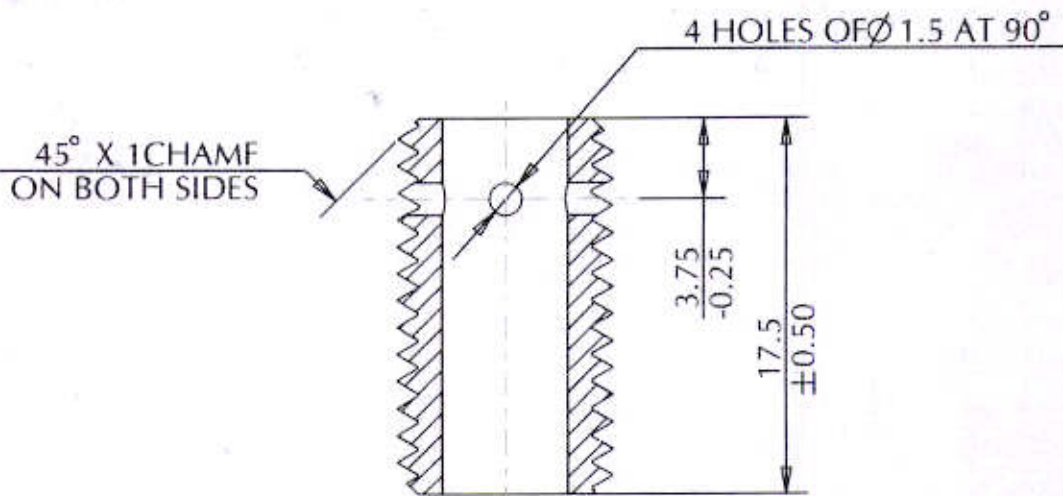
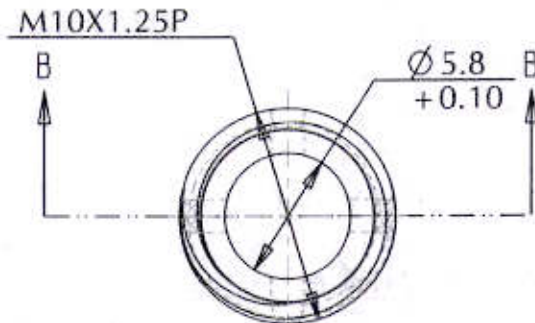
**DRAWING No. :TSG - 0016**

**MATERIAL : EXTRUDED ALLUMINIUM ROD TO SPECN  
IS : 733 -1967 HE 30 WP**

**ESTIMATED WEIGHT : 2 Gms**

MACHINING DEVIATION TO ISI 2102 MEDIUM GRADE UNLESS SPECIFIED OTHERWISE

LENGTH OR DIA	UPTO	6	30	120	315	1000	2000	4000	LENGTH IN mm OF SHORTER SIDE OF ANGLE				
		6	30	120	315	1000	2000	4000	UPTO 6	6-30	30-120	120-400	
		±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0	±1'	±30'	±20'	±10'



**SECTION B-B**

NOTE: BURS TO BE REMOVED. UNIFORM THICKNESS TO BE MAINTAINED THROUGH OUT THE LENGTH.

					SIGN	DATE
DGN : TSG -0016						
DRN : HC/DMM MADAN PAL					<i>[Signature]</i>	20/1/12
CHD : AJAY SAHAI, AC/AM					<i>[Signature]</i>	21/1/12
RE-CHD : KAMAL KUMAR, ZIC/MANAGER					<i>[Signature]</i>	21/1/12
APPD : SABU A JOSEPH, DIG/GM					<i>[Signature]</i>	02/02/12
SCALE : 1 : 2						
DATED : 19/01/2012						
SHEET : 1 OF 1						
ALL DIMENSIONS ARE IN mm						
DRAWING & REPROGRAPHIC SECTION						
S.No	AMENDMENT	SIGN I/C	SIGN O/C	DATE		

**TEAR SMOKE UNIT, BSF, TEKANPUR, GWALIOR (M.P.), PIN - 475 005**





**TITLE : SHELL BODY 126 MM**

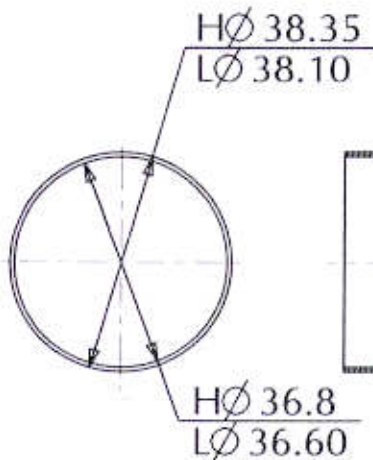
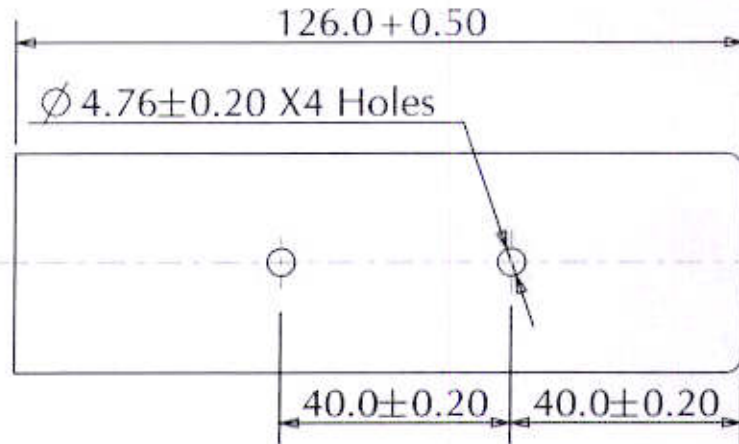
**DRAWING No. : TSS-0241**

**MATERIAL : AS STATED**

**ESTIMATED WEIGHT :**

MACHINING DEVIATION TO ISI 2102 MEDIUM GRADE UNLESS SPECIFIED OTHERWISE

LENGTH OR DIA	MACHINING DEVIATION TO ISI 2102 MEDIUM GRADE UNLESS SPECIFIED OTHERWISE								LENGTH IN mm OF SHORTER SIDE OF ANGLE			
	UPTO 6	6-30	30-120	120-315	315-1000	1000-2000	2000-4000	4000 ABOVE	UPTO 6	6-30	30-120	120-400
	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0	±1	±30'	±20'	±10'



**SECTION A-A**

MATERIAL: AL. TO SPECN IS : 736-1974-19000 IN 'M' CONDITION  
HARDNESS FROM BASE TO TOP: HRB 5 TO 10 ROCKWELL

NOTE:-

1. ANODIZED TO SPECIFICATION I.S.: 7088-1973 SULPHURIC ACID PROCESS ALL OVER
2. THICKNESS OF ANODIZING :- 7 - 12µ
3. WALL THICKNESS SHOULD BE UNIFORM ALL OVER
4. PROCESS OF MANUFACTURE :- DEEP DRAWN

S.No	AMENDMENT	SIGN I/C	SIGN O/C	DATE	DGN :	SIGN	DATE
					DRN : HC MADAN PAL		
					CHD : AJAY SAHAI, AC/AM		
					RECMD : KAMAL KUMAR, ZIC/MANAGER		
					APPD : SABU A JOSEPH, DIG/GM		
					SCALE : 1 : 0.80		
					DATED : 19-07-2012		
					SHEET : 1 OF 1		
					ALL DIMENSIONS ARE IN mm		
					DRAWING & REPROGRAPHIC SECTION		

**TEAR SMOKE UNIT,BSF, TEKANPUR, GWALIOR (M.P.), PIN - 475 005**



**TITLE : CAP CHAMBER**

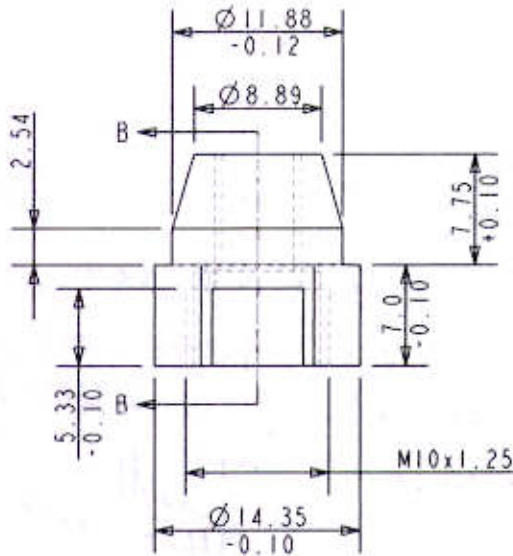
**DRAWING No. :TSG-0008**

**MATERIAL : ZINC ALLOY TO SPECN IS 713 - 1966**

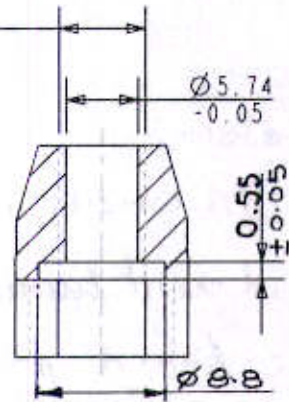
**ESTIMATED WEIGHT : 08 Gms**

MACHINING DEVIATION TO ISI 2102 MEDIUM GRADE UNLESS SPECIFIED OTHERWISE

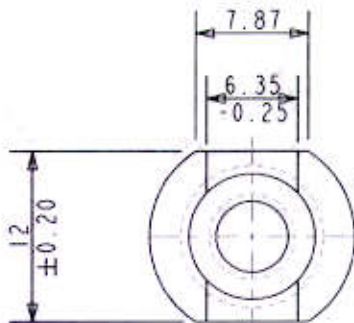
LENGTH OR DIA	UPTO	LENGTH IN mm OF SHORTER SIDE OF ANGLE										
		6	30	120	315	1000	2000	4000	ABOVE			
	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0	±1°	±30'	±20'	±10'



6x1.00 TAP IS TO BE PASSED THROUGH THE HOLE TO MAKE THE SURFACE ROUGH.

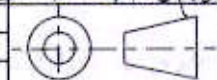


SECTION AT B-B



NOTE :- DIE CASTING TO SPECN DEF/77(A) LATEST ISSUE - CLASS II  
 SURFACE FINISH :- CHROMATE PASSIVATION TO DEF -130 SPECIFICATION  
 TOL FOR UNTOL DIMENSIONS TO 0.13MM

S.No	AMENDMENT	SIGN I/C	SIGN O/C	DATE	SIGN	DATE
					DGN : TSG - 0008	
					DRN : HC/DMM MADAN PAL	5/11/12
					CHD : AJAY SAHAI, AC/AM	12/11/12
					RE-CHD : KAMAL KUMAR 210/Manager	03/11/12
					APPD : SABU A JOSEPH, DIG/GM	03/11/12
					SCALE : 1 : 2	
					DATED : 05.01.2012	
					SHEET : 1 OF 1	
ALL DIMENSIONS ARE IN mm						
DRAWING & REPROGRAPHIC SECTION						



**TEAR SMOKE UNIT,BSF, TEKANPUR, GWALIOR (M.P.), PIN - 475 005**





