

TITLE : 1 SEC DELAY TUBE EMPTY

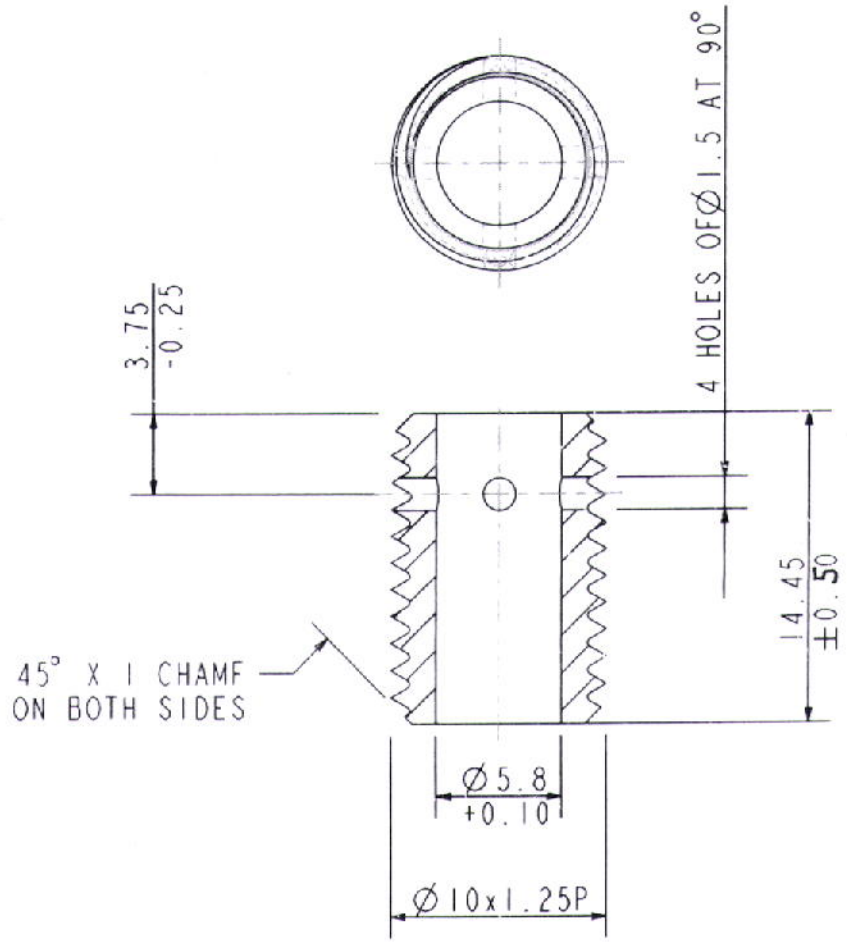
DRAWING No. : TSG-0009

**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	UPTO	6	30	120	315	1000	2000	4000	4000	ABOVE	LENGTH IN mm OF SHORTER SIDE OF ANGLE			
		±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0	UPTO 6	6-30	30-120	120-400	
											±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	27/1/12
					CHD : AJAY SAHAI, AC/AM	27/1/12
					RCMD : KAMAL KUMAR, ZIC/Manager	27/1/12
					APPD : SABU A JOSEPH, DIG/GM	03/02/11
					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

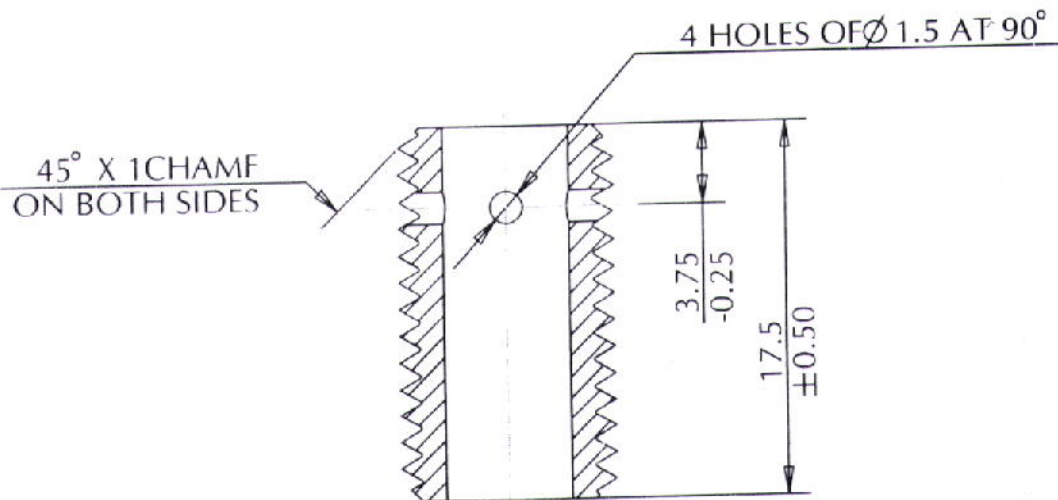
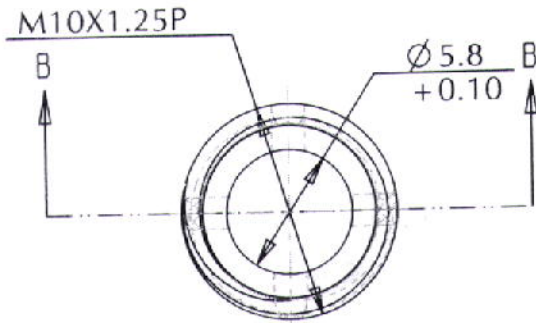
DRAWING No. :TSG - 0016

**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	LENGTH IN mm OF SHORTER SIDE OF ANGLE											
		6	30	120	315	1000	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 B-B

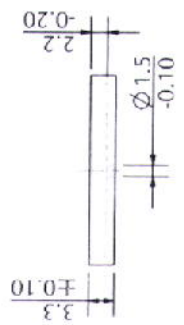
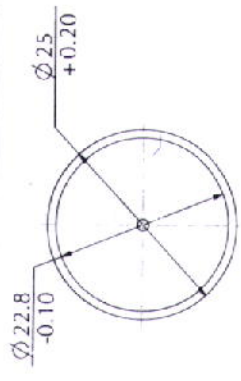
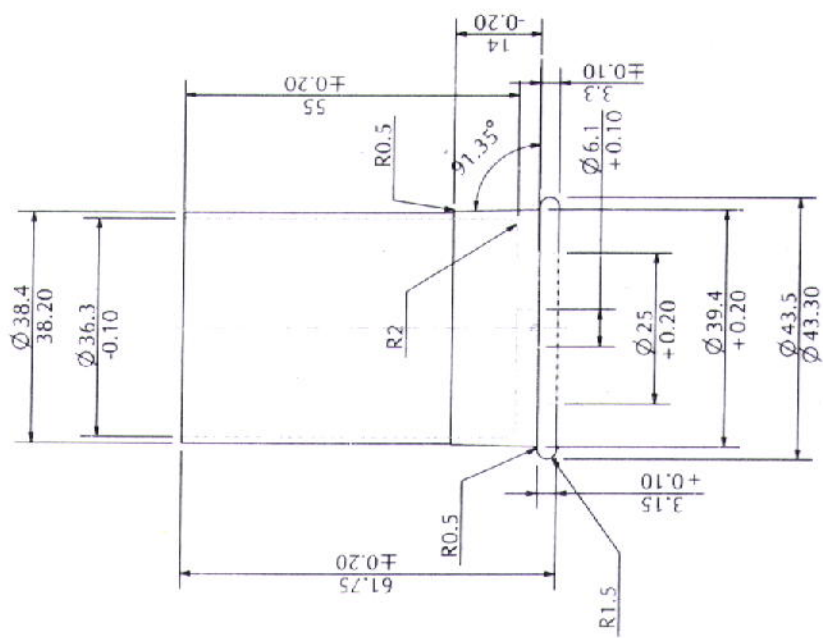
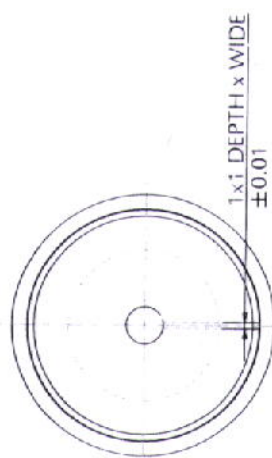
NOTE: BURS TO BE REMOVED.UNIFORM THICKNESS TO BE MAINTAINED THROUGH OUT THE LENGTH.

				SIGN	DATE
				DGN : TSG -0016	
				DRN : HC/DMM MADAN PAL	20/1/12
				CHD : AJAY SAHAI, AC/AM	21/1/12
				RE-CHD : KAMAL KUMAR, 2IC/MANAGER	31/1/12
				APPD : SABU A JOSEPH, DIC/GM	03/20
				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	

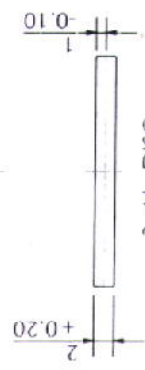
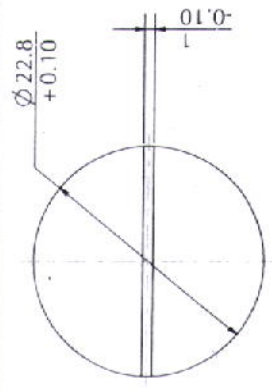
TEAR SMOKE UNIT,BSF, TEKANPUR, GWALIOR (M.P.), PIN - 475 005

LENGTH	UP TO 6	±0.1
	6 TO 120	±0.2
DIA	UP TO 10	±0.3
	10 TO 120	±0.5
MATERIAL	1000	±0.8
	2000	±1.2
HARDNESS	1000	±2.0
	2000	±7.0
FINISH	UP TO 6	±1.0
	6 TO 120	±1.5
TOLERANCE	UP TO 6	±0.1
	6 TO 120	±0.2

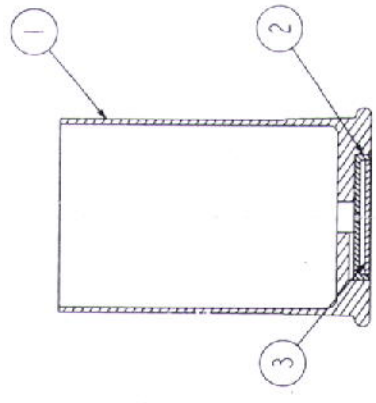
1. AL CARTIG CASE
 MATERIAL:- AL. TO SPECN
 I S 736-1974-19000/19500
 IN 'M' CONDITION
 HARDNESS:- 5 TO 10 HRB
 ROCKWELL



2. CAP
 MATL:- NYLON



3. AL. DISC
 MATL:- AL.



SECTION A-A

ASSEMBLY

1. ONLY AL CARTIG CASE TO BE ANODIZED TO SPECN I S 7088-1973.
2. SULPHURIC ACID PROCESS ALL OVER.
3. THICKNESS OF ANODIZING .7-12 MICRON
4. PROCESS OF MANUFACTURE DEEP DRAWN
5. BASE SHOULD NOT PROTRUDE WHILE FITTING WITH AL. DISC AND CAP.

DGN :	DRN :	HC MADAN PAL	SIGN :	DATE :
CHD :	APAY SAHAI, AC/AM			
RECD :	KAMAL KUMAR, DIGMANAGER			
APPD :	SABU A JOSEPH, DIG/CM			
SCALE :	1 : 1			
DATED :	09.01.2012			
SHEET :	1 OF 1			

S.No	AMENDMENT	SIGN/IC	SIGN/OC	DATE

DRAWING No. :TSU/R&D/79(CAD)
 ESTIMATED WEIGHT :

TITLE : AL CARTIG CASE ASSY FOR MSL (E)
 MATERIAL : AS STATED

DRAWING & REPROGRAPHIC SECTION

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