

A4

1

2

3

4

5

6

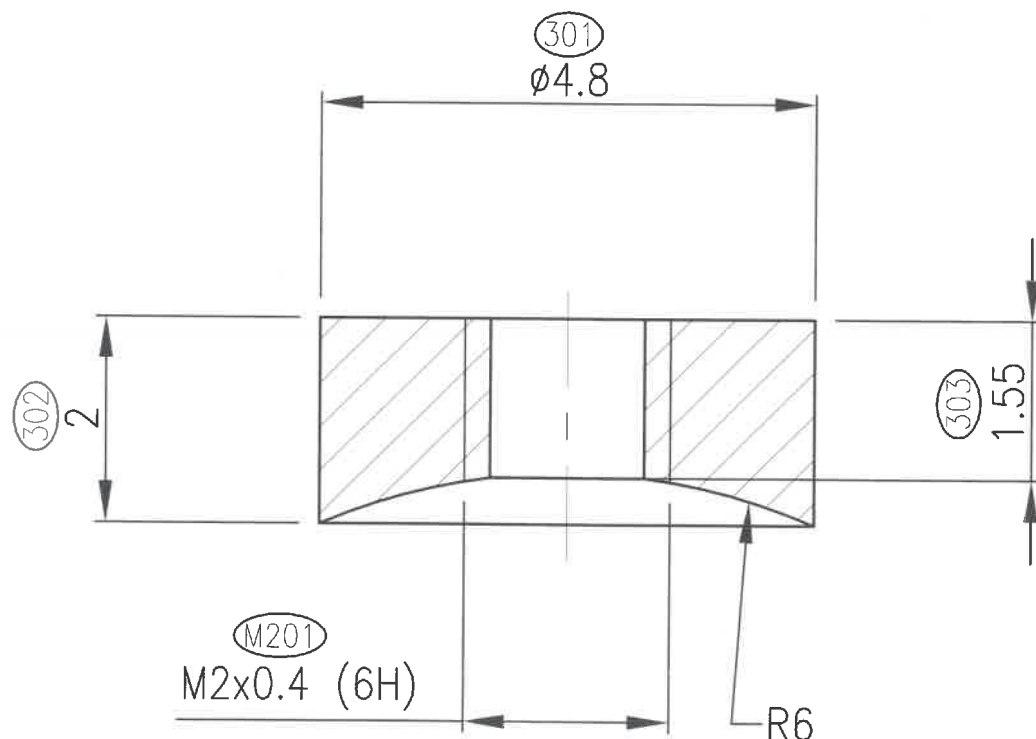
NOTE:

1. REMOVE ALL SHARP EDGES.
2. BRASS CZ 121 PB3 COND. M TO BS 2874.
3. SILVERPLATE 0.002-0.006mm THICK
A CERTIFICATE OF CONFORMANCE SHALL BE PROVIDED.

M101D

ACCEPTANCE INSPECTION INSTRUCTION

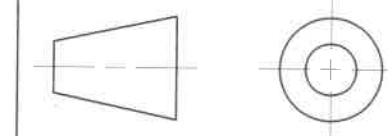
CHAR. No.	CROSS REF.	GAUGE NUMBER	MEASURING DESCRIPTION
M101D	A-1	MATL.SPEC.	REPORT
M201	C-1	05228-010106-267001	GAUGE PLUG SCREW
301	B-2		VERNIER
302	C-1		VERNIER
303	C-3		VERNIER



Should a Tenderer/Vendor not be able to meet the requirements of this document, it must be declared in writing to the Buying Manager at the time of tendering/receipt of an order.

DATE: 2023.06.06
COPY NO 18
ISSUE BY, I P

DO NOT SCALE
ALL DIMENSIONS ARE IN mm.



CLASSIFICATION OF CHARACTERISTICS CODING BASED ON DOD-STD 2101	
CLASSIFICATION	TOTAL
CRITICAL (C1-C99)	0
MAJOR A (M101-M199)	1
MAJOR B (M201-M299)	1
MINOR (301-399)	3
INCIDENTAL (401-499)	0

FINAL ACCEPTANCE SAMPLE FOR VISUAL AND DIMENSIONAL INSPECTION: ACCORDING TO MIL. STD. 105 SINGLE NORMAL SAMPLE PLAN: GENERAL INSPECTION II		
A.Q.L.	CRITICAL	NOT APPLICABLE
	MAJOR A	0,025%
	MAJOR B	0,65%
	MINOR	1,5%
	INCIDENTAL	4,0%

N7/ [✓] [✓]

HRC

JOB No.
KB/134/95 DEV.

MATERIAL
SEE NOTE 2

DRAWN
JVR 06-03-06

CHECKED
FJW 06-03-06

NEXT ASSY
05228-010101-202001

FINALIZED

APPROVED
MGV 06-03-29

DRG No.
05228-010106-203001

REV
A

GENERAL TOLERANCES (UNLESS OTHERWISE STATED)

LENGTHS AND DIAMETERS								ANGLES		RADII					ALL GEOMETRIC TOLERANCES TO BE WITHIN 0,1
0 TO 6	6 TO 30	30 TO 120	120 TO 315	315 TO 1000	1000 TO 2000	2000 TO 4000	4000 AND MORE	0° TO 30°	30° AND MORE	1 TO 6	6 TO 30	30 TO 100	100 TO 300	300 TO 1000	
±0,1	±0,2	±0,3	±0,5	±0,8	±1,2	±2,0	±3,0	±30°	±1°	±0,5	±1,0	±1,5	±2,0	±3,0	

PROJECT LEADER

SCREEN DRG.No.

CODE No.
01106007308

CAD No.
00247800

CARTRIDGE EXTINGUISH

PRODUCT

TITLE
RETAINING NUT
M9425

MACHINE

REPLACES DRG. No.

A
MGV
06/03/29

REDRAWN AND UP DATED
SEE JOB No. 03/E015/05PC

DETAILS

JVR

DONE BY

NOTE:

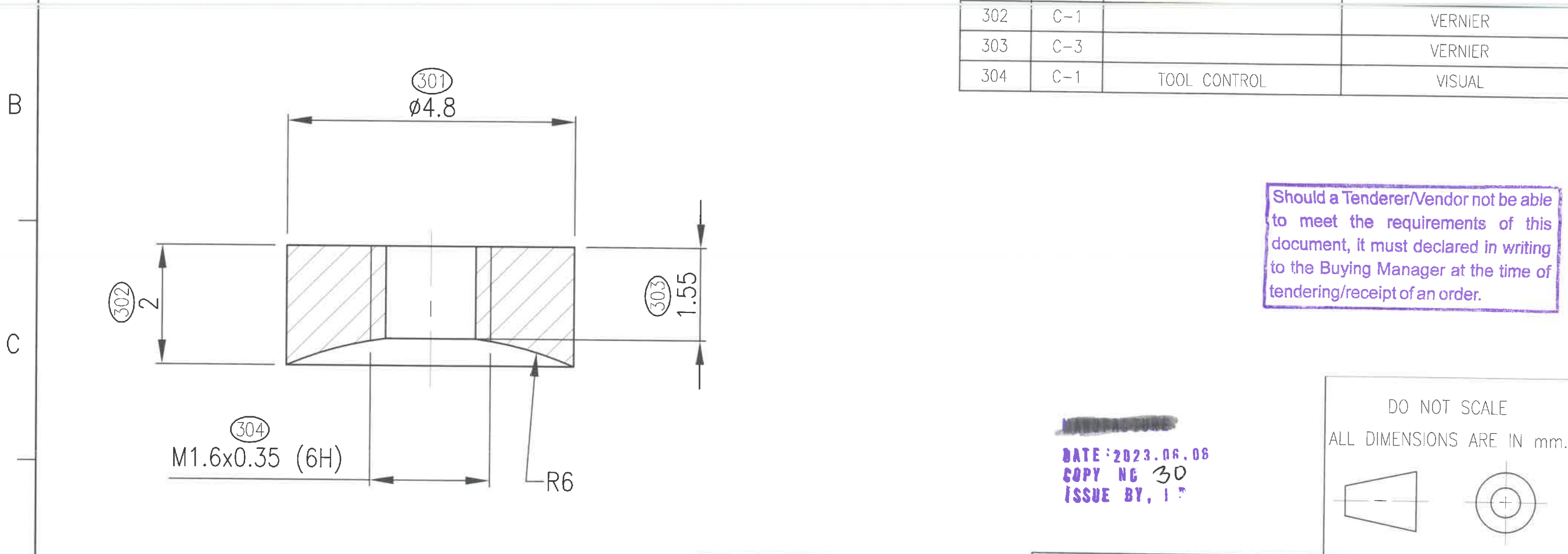
1. REMOVE ALL SHARP EDGES.

M101D 2. BRASS CZ 121 PB3 COND. M TO BS 2874.

M201 3. SILVERPLATE 0.002-0.006mm THICK

A CERTIFICATE OF CONFORMANCE SHALL BE PROVIDED.

ACCEPTANCE INSPECTION INSTRUCTION			
CHAR. No.	CROSS REF.	GAUGE NUMBER	MEASURING DESCRIPTION
M101D	A-1	MATL.SPEC.	REPORT
M201	A-1	VISUAL	REPORT
301	B-2		VERNIER
302	C-1		VERNIER
303	C-3		VERNIER
304	C-1	TOOL CONTROL	VISUAL



CLASSIFICATION OF CHARACTERISTICS CODING BASED ON DOD-STD 2101		FINAL ACCEPTANCE SAMPLE FOR VISUAL AND DIMENSIONAL INSPECTION: ACCORDING TO MIL. STD. 105 SINGLE NORMAL SAMPLE PLAN: GENERAL INSPECTION II	
CLASSIFICATION		A.Q.L.	
CRITICAL (C1-C99)	0	CRITICAL	NOT APPLICABLE
MAJOR A (M101-M199)	1	MAJOR A	0,025%
MAJOR B (M201-M299)	1	MAJOR B	0,65%
MINOR (301-399)	4	MINOR	1,5%
INCIDENTAL (401-499)	0	INCIDENTAL	4,0%

JOB No.
KB/198/98COM

MATERIAL
SEE NOTE 2

GENERAL TOLERANCES (UNLESS OTHERWISE STATED)

LENGTHS AND DIAMETERS								ANGLES		RADII					ALL GEOMETRIC TOLERANCES TO BE WITHIN 0,1
0 TO 6	6 TO 30	30 TO 120	120 TO 315	315 TO 1000	1000 TO 2000	2000 TO 4000	4000 AND MORE	0° TO 30°	30° AND MORE	1 TO 6	6 TO 30	30 TO 100	100 TO 300	300 TO 1000	
±0,1	±0,2	±0,3	±0,5	±0,8	±1,2	±2,0	±3,0	±30'	±1°	±0,5	±1,0	±1,5	±2,0	±3,0	

DRAWN
JVR 06-03-07

CHECKED
FJW 06-03-28

FINALIZED

APPROVED
MGV 06-03-29

PROJECT LEADER

SCREEN DRG.No.

NEXT ASSY
05614-010101-202001 ITEM 6

DRG No.
05614-010105x203001

REV
B

CODE No.
01106012504

CAD No.
00115330

CARTRIDGE EXTINGUISH

PRODUCT

TITLE

RETAINING NUT

M9830 (A718 AND A719)

MACHINE

REPLACES DRG. No.

REDRAWN AND UP DATED
SEE JOB No. 03/EC15/05PC

JVR

DONE BY

06/03/29

MGV

B

DATE

APP.

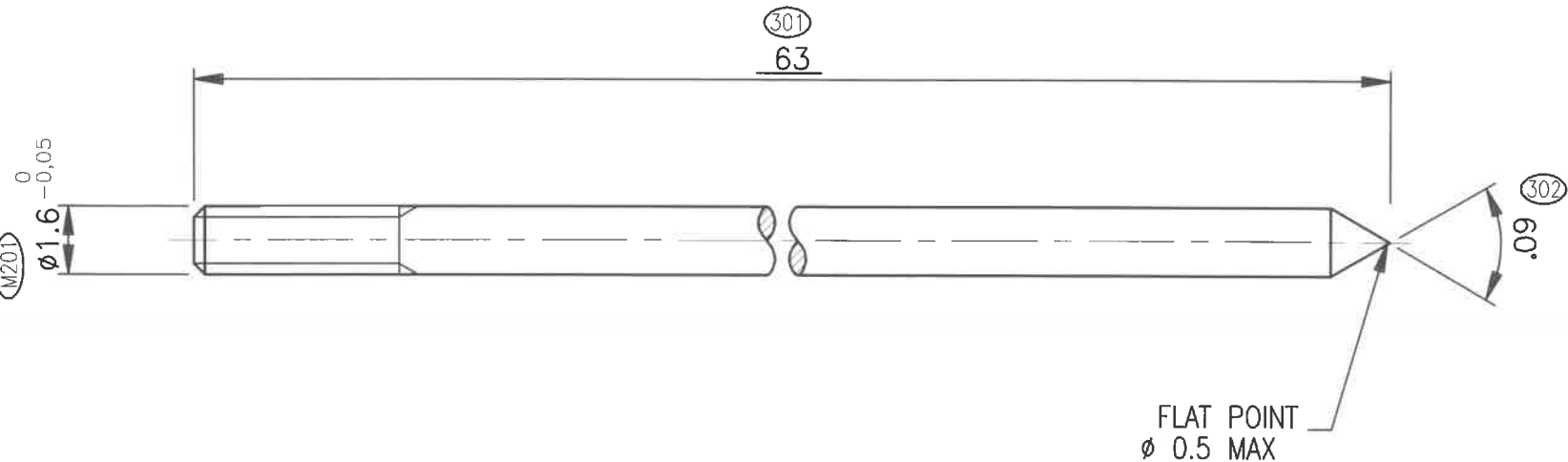
REV.

A3 1 2 3 4 5 6 7 8 9

NOTE:
1. REMOVE ALL SHARP EDGES.

ACCEPTANCE INSPECTION INSTRUCTION

CHAR. No.	CROSS REF.	GAUGE NUMBER	MEASURING DESCRIPTION
M101D	G-3	MATL.SPEC.	REPORT
M201	C-1		MICROMETER
301	C-4		VERNIER
302	C-6	TOOL CONTROL	REPORT



Should a Tenderer/Vendor not be able to meet the requirements of this document, it must be declared in writing to the Buying Manager at the time of tendering/receipt of an order.

DATE: 2023.06.08
COPY NO. 29
ISSUE BY, J

DO NOT SCALE ALL DIMENSIONS ARE IN mm.		CLASSIFICATION OF CHARACTERISTICS CODING BASED ON DOD-STD 2101		FINAL ACCEPTANCE SAMPLE FOR VISUAL AND DIMENSIONAL INSPECTION: ACCORDING TO MIL. STD. 105 SINGLE NORMAL SAMPLE PLAN: GENERAL INSPECTION II	
		TOTAL		A.Q.L.	
		CRITICAL (C1-C99)		CRITICAL	
		MAJOR A (M101-M199)		MAJOR A	
		MAJOR B (M201-M299)		MAJOR B	
		MINOR (301-399)		MINOR	
		INCIDENTAL (401-499)		INCIDENTAL	
		0		NOT APPLICABLE	
		1		0,025%	
		1		0,65%	
		2		1,5%	
		0		4,0%	

JOB No. KB/198/98COM		MATERIAL BRASS CZ 121 PB3 COND. M TO BS 2874		DRAWN FvT 98-09-09		CHECKED FJW 06-03-28		NEXT ASSY 05614-010102-202001 ITEM 2						
GENERAL TOLERANCES (UNLESS OTHERWISE STATED)				FINALIZED		APPROVED MGV 06-03-29		DRG No. 05614-010104x203001		REV. A				
				PROJECT LEADER H VAN DER WALT 98-10-08		SCREEN DRG. No.		CODE No. 01106012602		CAD No. 00115320				
LENGTHS AND DIAMETERS				ANGLES		RADII		ALL GEOMETRIC TOLERANCES TO BE WITHIN 0,1						
0 TO 6 ±0,1	6 TO 30 ±0,2	30 TO 120 ±0,3	120 TO 315 ±0,5	315 TO 1000 ±0,8	1000 TO 2000 ±1,2	2000 TO 4000 ±2,0	4000 TO 10000 ±3,0	0° TO 30° ±30'	30° TO 90° ±1°	1 TO 6 ±0,5	6 TO 30 ±1,0	30 TO 100 ±1,5	100 TO 300 ±2,0	300 TO 1000 ±3,0

CARTRIDGE EXTINGUISH

DRAWING UPDATED SEE JOB No. 03/E015/05PC

DETAILS

JVR

DONE BY

06/03/29

DATE

MGV

APP.

REV.

DATE

PRODUCT

CONTACT PIN THREADED
M9830 (A718 AND A719)

TITLE

MACHINE

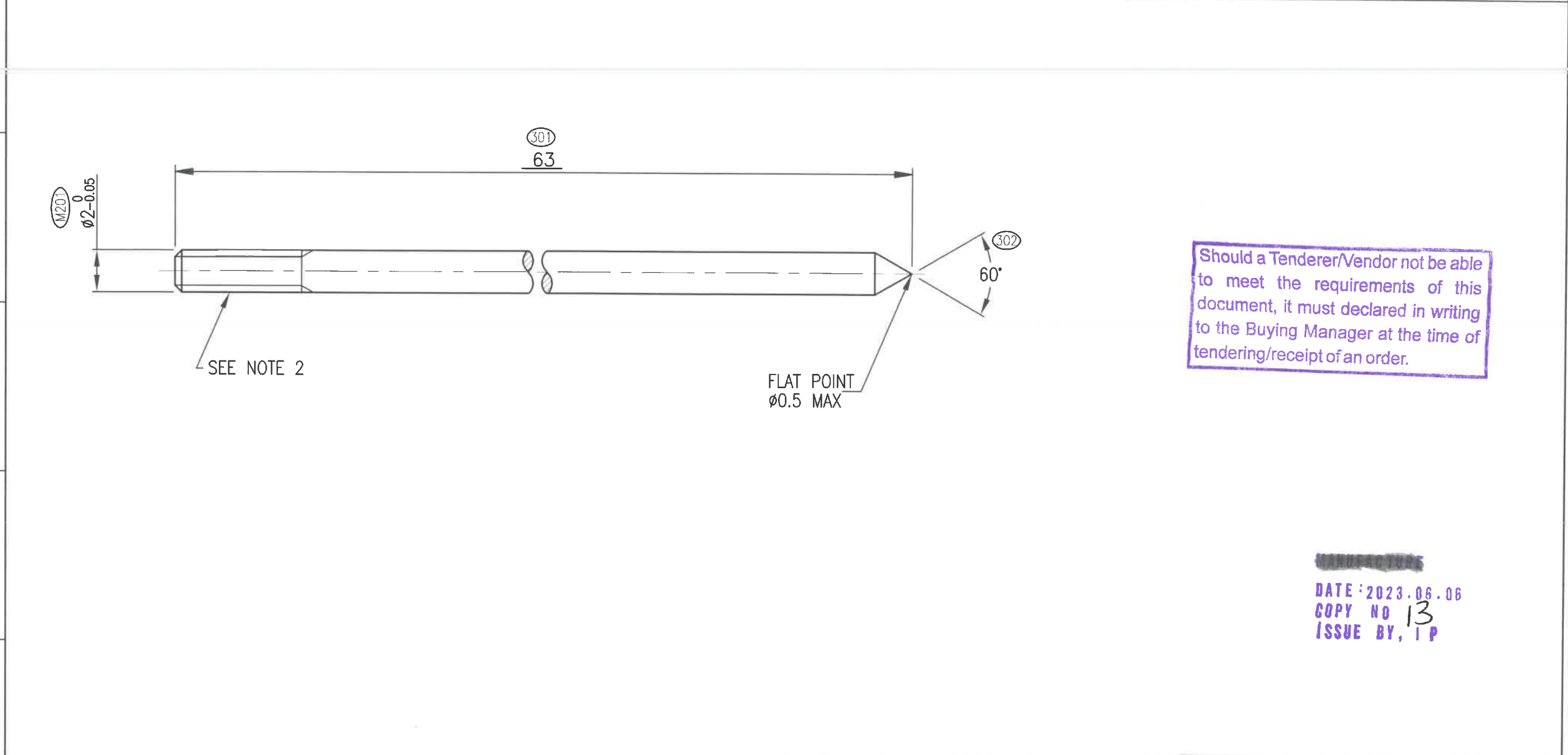
REPLACES DRG. No.

0

JOB No.		MATERIAL		DRAWN		CHECKED		INCIDENTAL		TYPICAL		4,0%	
KB/134/95DEV.		BRASS CZ 121 PB3 COND. M TO BS 2874		JVR 06-06-06		FJW 06-06-07		05228-010201-202001					
GENERAL TOLERANCES (UNLESS OTHERWISE STATED)				FINALIZED		APPROVED		DRG No.				REV.	
						MGV 06-06-07		05228-010107-203001				A	
LENGTHS AND DIAMETERS				ANGLES		RADII		PROJECT LEADER					
								P PRINSLOO					
								SCREEN DRG. No.				CODE No.	
												01106011801	
												CAD No.	
												00250630	

NOTE:
1. REMOVE ALL SHARP EDGES.
2. M2 THREAD TO BE CUT AFTER ASSEMBLY.

ACCEPTANCE INSPECTION INSTRUCTION			
CHAR. No.	CROSS REF.	GAUGE NUMBER	MEASURING DESCRIPTION
M101D	C-3	MATL.SPEC.	REPORT
M201	C-1		MICROMETER
301	C-4		VERNIER
302	C-6	TOOL CONTROL	REPORT



Should a Tenderer/Vendor not be able to meet the requirements of this document, it must declared in writing to the Buying Manager at the time of tendering/receipt of an order.

DATE : 2023.06.06
COPY NO 13
ISSUE BY, I P

N7

[✓][✓]

HRC

DO NOT SCALE

ALL DIMENSIONS ARE IN mm.

CLASSIFICATION OF CHARACTERISTICS CODING BASED ON DOD-STD 2101

CLASSIFICATION	TOTAL
CRITICAL (C1-C99)	0
MAJOR A (M101-M199)	1
MAJOR B (M201-M299)	1
MINOR (301-399)	2
INCIDENTAL (401-499)	0

FINAL ACCEPTANCE SAMPLE FOR VISUAL AND DIMENSIONAL INSPECTION: ACCORDING TO MIL. STD. 105 SINGLE NORMAL SAMPLE PLAN: GENERAL INSPECTION II

A.Q.L.	CRITICAL	NOT APPLICABLE
	MAJOR A	0,025%
	MAJOR B	0,65%
	MINOR	1,5%
	INCIDENTAL	4,0%

JOB No. KB/134/95DEV.

MATERIAL BRASS CZ 121 PB3 COND. M TO BS 2874 (M101D)

DRAWN JVR 06-06-06

CHECKED FJW 06-06-07

NEXT ASSY 05228-010201-202001

GENERAL TOLERANCES (UNLESS OTHERWISE STATED)

LENGTHS AND DIAMETERS								ANGLES		RADII					ALL GEOMETRIC TOLERANCES TO BE WITHIN 0,1
0 TO 6	6 TO 30	30 TO 120	120 TO 315	315 TO 1000	1000 TO 2000	2000 TO 4000	4000 AND MORE	0° TO 30°	30° AND MORE	1 TO 6	6 TO 30	30 TO 100	100 TO 300	300 TO 1000	
±0,1	±0,2	±0,3	±0,5	±0,8	±1,2	±2,0	±3,0	±30'	±1°	±0,5	±1,0	±1,5	±2,0	±3,0	

PROJECT LEADER H VAN DER WALT 98-10-08

SCREEN DRG. No.

DRG No. 05228-010102-203001

REV. A

CODE No. 01106011910

CAD No. 00250620

TITLE		CONTACT PIN THREADED M9425			PRODUCT			CART. EXTINGUISH		
MACHINE					A	MGV	06/06/07	REDRAWN AND UPDATED SEE JOB No. 03/E015/05PC		
REPLACES DRG. No.					REV.	APP.	DATE	DETAILS		
								JVR		
								DONE BY		

NOTE:

ACCEPTANCE INSPECTION INSTRUCTION

CHAR. No.	CROSS REF.	GAUGE NUMBER	MEASURING DESCRIPTION
M101D	E-2	MATL.SPEC.	REPORT
M201	B-2		MICROMETER
M202	C-2		INSIDE MICROMETER
301	A-1		VERNIER
302	C-1		VERNIER
303	C-2		VERNIER

CARTRIDGE EXTINGUISH

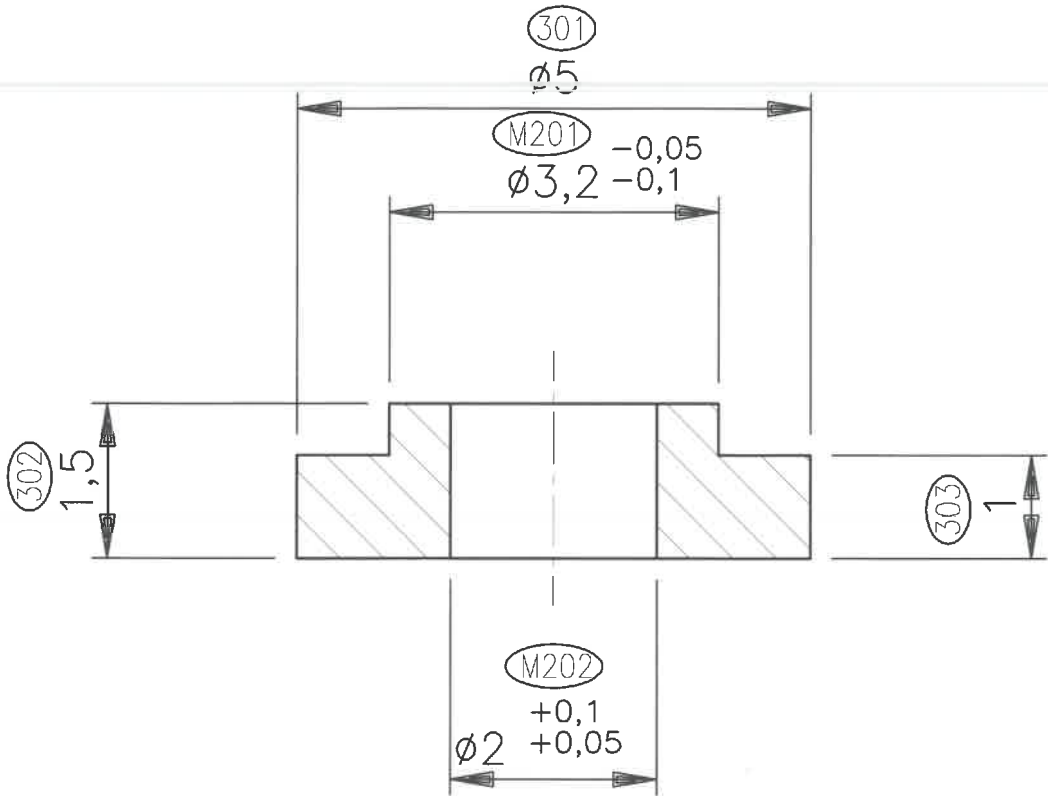
DRAWING UPDATED
SEE JOB No. 03/E015/05PC

B	MGV	06/03/29
REV.	APP.	DATE

JVR

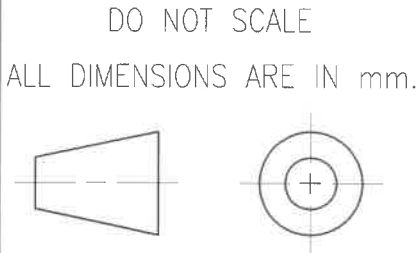
DETAILS

DONE BY



Should a Tenderer/Vendor not be able to meet the requirements of this document, it must declared in writing to the Buying Manager at the time of tendering/receipt of an order.

MANUFACTURED
DATE : 2023.06.06
COPY No 45
ISSUE BY, 1 P



CLASSIFICATION OF CHARACTERISTICS CODING BASED ON DOD-STD 2101		
CLASSIFICATION	TOTAL	
CRITICAL (C1-C99)	0	
MAJOR A (M101-M199)	1	
MAJOR B (M201-M299)	2	
MINOR (301-399)	3	
INCIDENTAL (401-499)	0	

FINAL ACCEPTANCE SAMPLE FOR VISUAL AND DIMENSIONAL INSPECTION: ACCORDING TO MIL. STD. 105 SINGLE NORMAL SAMPLE PLAN: GENERAL INSPECTION II		
A.Q.L.	CRITICAL	NOT APPLICABLE
	MAJOR A	0,025%
	MAJOR B	0,65%
	MINOR	1,5%
	INCIDENTAL	4,0%



JOB No. KB/134/95 DEV. MATERIAL M101D NYLON ERTELON 6 SA

DRAWN PE 94-11-15	CHECKED FJW 06-03-27	NEXT ASSY 05615-010101-202001 (A719) 05614-010101-202001 (A718) 05228-010101-202001 (A716)	
FINALIZED PAC 95-10-26	APPROVED MGV 06-03-29	DRG No. 05228-010103x203001	REV. B
PROJECT LEADER P PRINSLOO 95-01-11			

LENGTHS AND DIAMETERS								ANGLES	RADII					ALL GEOMETRIC TOLERANCES TO BE WITHIN 0,1
0 TO 6	6 TO 30	30 TO 120	120 TO 315	315 TO 1000	1000 TO 2000	2000 TO 4000	4000 AND MORE	0° TO 30°	30° AND MORE	1 TO 6	6 TO 30	30 TO 100	100 TO 300	300 TO 1000
±0,1	±0,2	±0,3	±0,5	±0,8	±1,2	±2,0	±3,0	±30'	±1°	±0,5	±1,0	±1,5	±2,0	±3,0

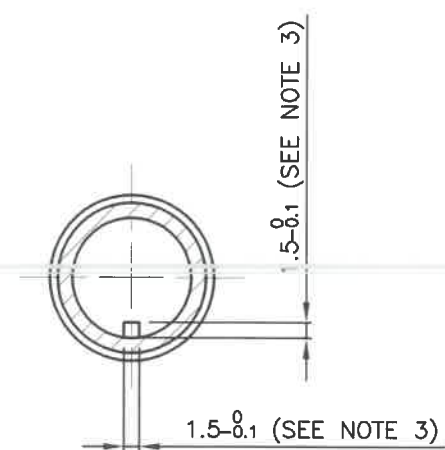
SCREEN DRG.No.	CODE No. 01106007003	CAD No. 00128110
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TITLE ISOLATING WASHER M9425

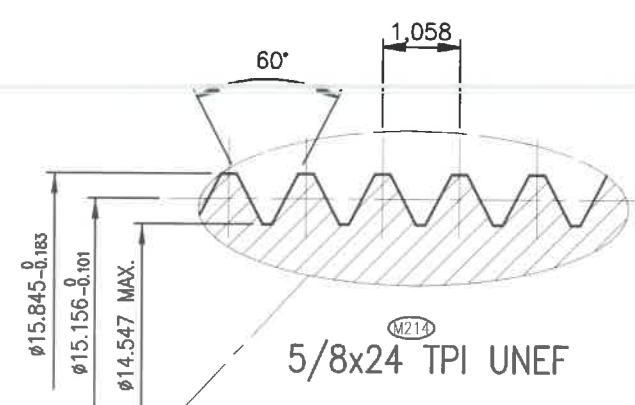
MACHINE

REPLACES DRG. No.

- NOTE:
- 1. REMOVE ALL SHARP EDGES.
 - 2. MATT TIN PLATE ON ALL OUTER SURFACES 0.002-0.006mm.
A CERTIFICATE OF CONFORMANCE SHALL BE PROVIDED.
 - 3. GUIDE TO BE FORMED AFTER CUTTING THREAD.

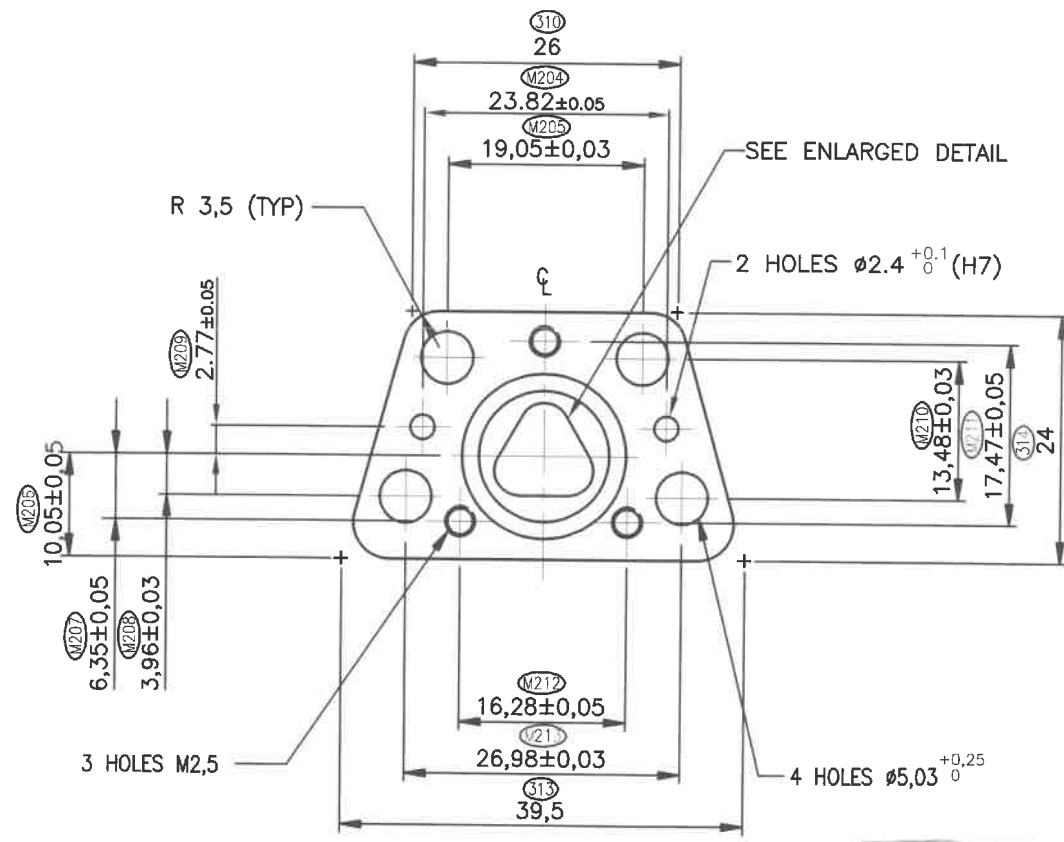
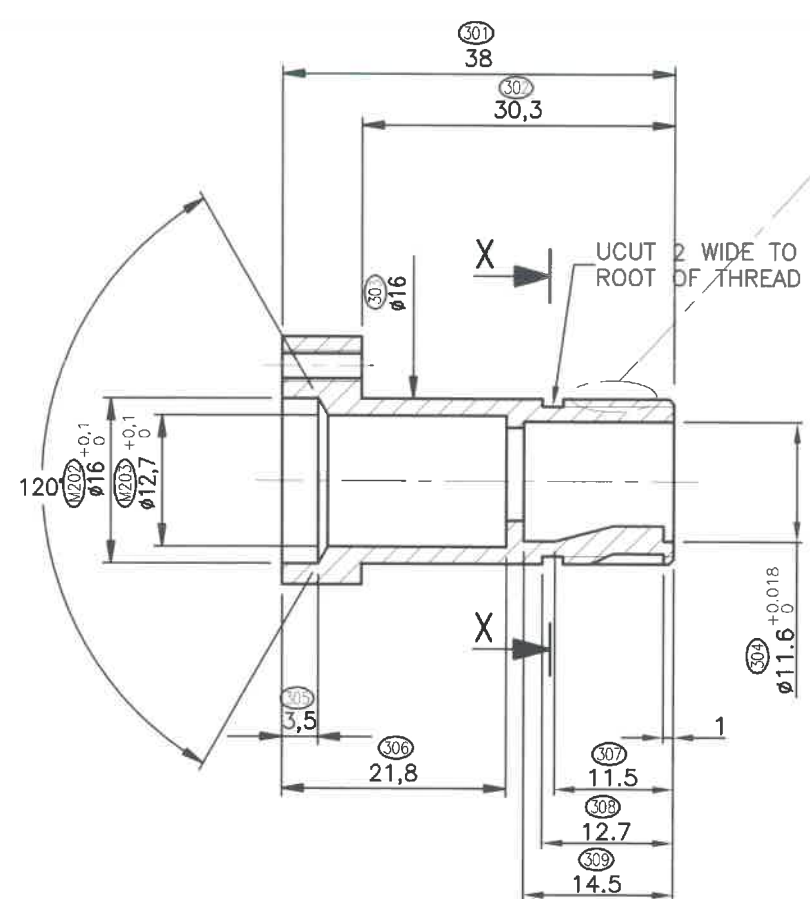


SECTION X-X



Should a Tenderer/Vendor not be able to meet the requirements of this document, it must be declared in writing to the Buying Manager at the time of tendering/receipt of an order.

ACCEPTANCE INSPECTION INSTRUCTION			
CHAR. No.	CROSS REF.	GAUGE NUMBER	MEASURING DESCRIPTION
M101	J-8	MATERIAL SPEC.	REPORT
M201	A-1	NOTE 2	REPORT
M202	G-2		INSIDE MICROMETER
M203	G-2		INSIDE MICROMETER
M204	E-11	05228-010003-267001	GAUGE PITCH
M205	F-11		
M206	G-8		
M207	H-8		
M208	H-9		
M209	G-9		
M210	G-13		
M211	G-13		
M212	H-11		
M213	I-11		
M214	D-8	05614-010002X267001	GAUGE RING THREAD
301	E-4		VERNIER
302	E-4		
303	F-3		
304	H-5		
305	H-3		
306	I-3		
307	I-4		
308	I-4		
309	I-4		
310	E-11		
311	B-11		
312	C-9		
313	I-11		



DATE: 2023.06.06
COPY NO 19
ISSUE BY, 1

FINAL ACCEPTANCE SAMPLE FOR VISUAL AND DIMENSIONAL INSPECTION: ACCORDING TO MIL-STD-105 SINGLE NORMAL SAMPLE PLAN: GENERAL INSPECTION G2.

A.Q.L. CRITICAL NOT APPLICABLE

MAJOR A 0.025%

MAJOR B 0.65%

MINOR 1.5%

INCIDENTAL 4.0%

CLASSIFICATION OF CHARACTERISTICS CODING BASED ON DOD-STD 2101

CLASSIFICATION TOTAL

CRITICAL (C1-C99) 0

MAJOR A (M101-M199) 1

MAJOR B (M201-M299) 14

MINOR (301-399) 13

INCIDENTAL (401-499) 0

DO NOT SCALE

ALL DIMENSIONS ARE IN mm.

JOB No. KB/198/98COM

MATERIAL BRASS CZ 121 PB3 COND. M TO BS 2874

DRAWN FvT 98-09-21

CHECKED PS 98-10-06

NEXT ASSY. 05615-010001-201001 ITEM 3

FINALIZED

APPROVED MGV 98-10-07

PROJECT LEADER HvdWALT 98-10-08

SCREEN DRG. No.

CODE No. 01106012809

CAD No. 00115400

GENERAL TOLERANCES (UNLESS OTHERWISE STATED)

LENGTHS AND DIAMETERS				ANGLES		RADII			
0 TO 6	6 TO 30	30 TO 120	120 TO 315	0° TO 30°	30° TO 90°	1 TO 6	6 TO 30	30 TO 100	
±0.1	±0.2	±0.3	±0.5	±0.5	±1.0	±0.1	±0.2	±0.3	

ALL GEOMETRIC TOLERANCES TO BE WITHIN 0.1

REPLACES DRG. No.

DATE: 2023.06.06

COPY NO 19

ISSUE BY, 1

REV. C

05615-010002-203001

CARTRIDGE EXTINGUISH

PRODUCT

MA- HINE

REPLACES DRG. No.

DATE: 12-03-20

FJW

APP.

REV.

NOTE 3 UPDATED, SEE JOB No. E2/037/12PC

DETAILS

DJ

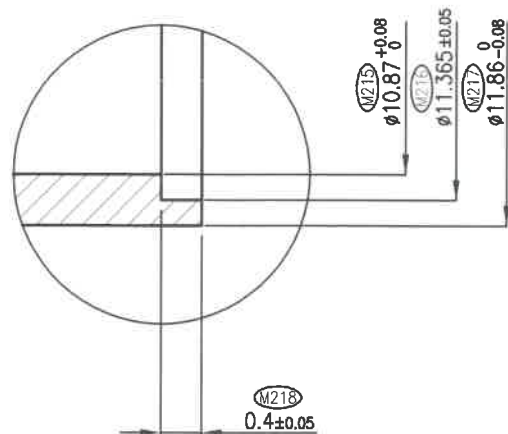
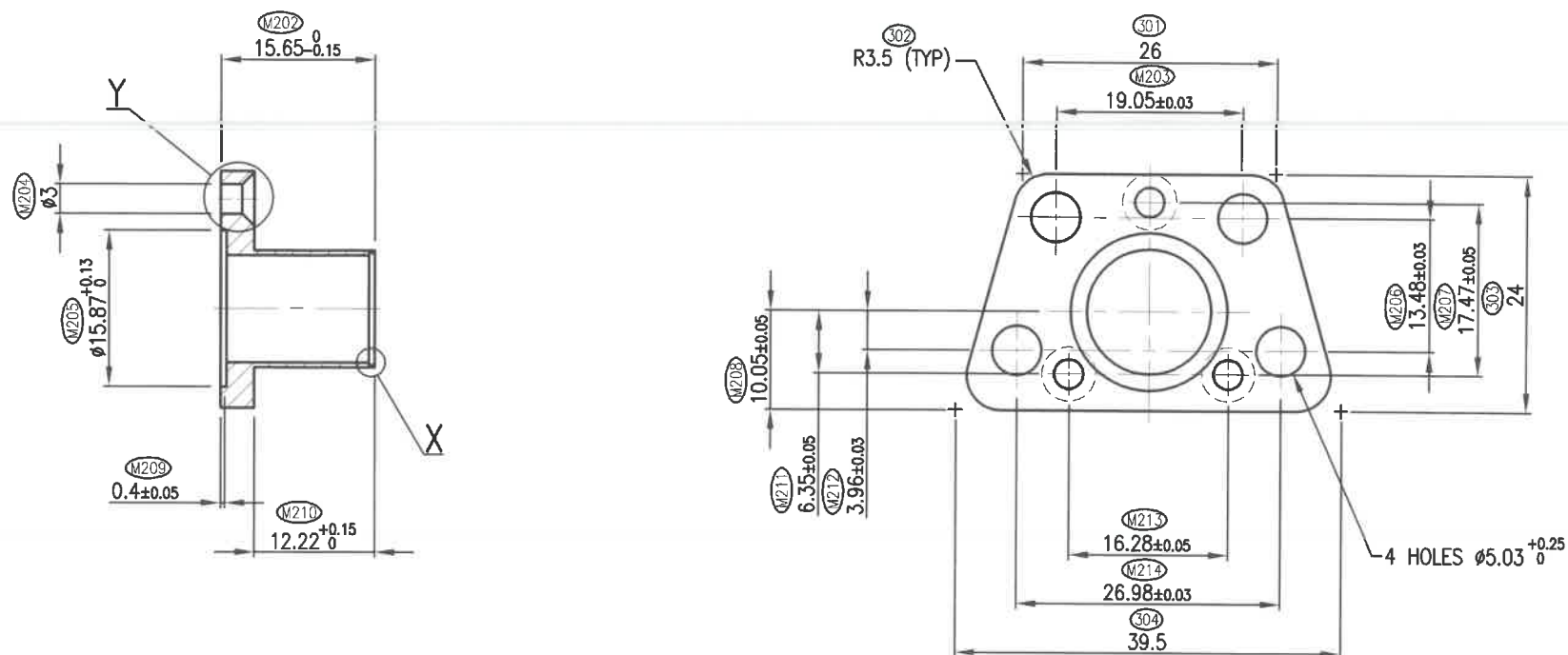
DONE BY

BODY M9831

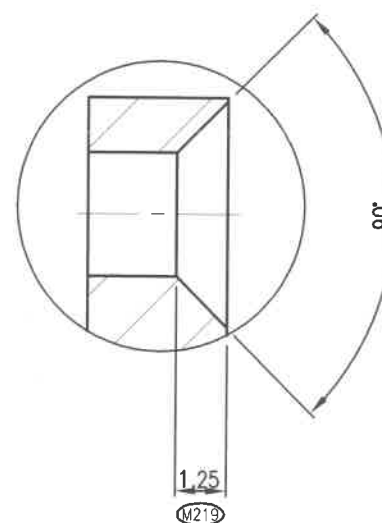
(A719-3)

•

2. MATT TIN PLATE ALL OUTER SURFACES 0.002 - 0.006mm THICK.
A CERTIFICATE OF CONFORMANCE SHALL BE PROVIDED.



ENLARGED DETAIL X



ENLARGED DETAIL Y

Should a Tenderer/Vendor not be able to meet the requirements of this document, it must declared in writing to the Buying Manager at the time of tendering/receipt of an order.

ACCEPTANCE INSPECTION INSTRUCTION			
CHAR. No.	CROSS REF.	GAUGE NUMBER	MEASURING DESCRIPTION
M101D	J-8	MATERIAL SPEC.	REPORT
M201	A-1	NOTE 2	REPORT
M202	B-4		VERNIER
M203	C-8	05228-010005-267005	GAUGE PITCH
M204	C-5		VERNIER
M205	D-3	05228-010005-267003	GAUGE PLUG
M206	D-10	05228-010005-267005	GAUGE PITCH
M207	D-10	05228-010005-267005	GAUGE PITCH
M208	D-6	05228-010005-267005	GAUGE PITCH
M209	E-3	05228-010005-267002	GAUGE CLOCK DEPTH
M210	E-4		VERNIER
M211	E-7	05228-010005-267005	GAUGE PITCH
M212	E-7	05228-010005-267005	GAUGE PITCH
M213	F-8	05228-010005-267005	GAUGE PITCH
M214	E-8	05228-010005-267005	GAUGE PITCH
M215	F-6		INSIDE MICROMETER
M216	F-6	05228-010005-267001	GAUGE PLUG
M217	F-7		MICROMETER
M218	H-6	05228-010005-267002	GAUGE CLOCK DEPTH
M219	H-10		VERNIER
301	B-8		VERNIER
302	B-7		RADIUS GAUGE
303	D-10		VERNIER
304	E-8		VERNIER

CARTRIDGE EXTINGUISH

DRAWING UPDATED SEE JOB No. E2/149/12PC	JVR
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DETAILS	DATE	BY
	12/11/12	

PRODUCT

REPLACES DRG. No.

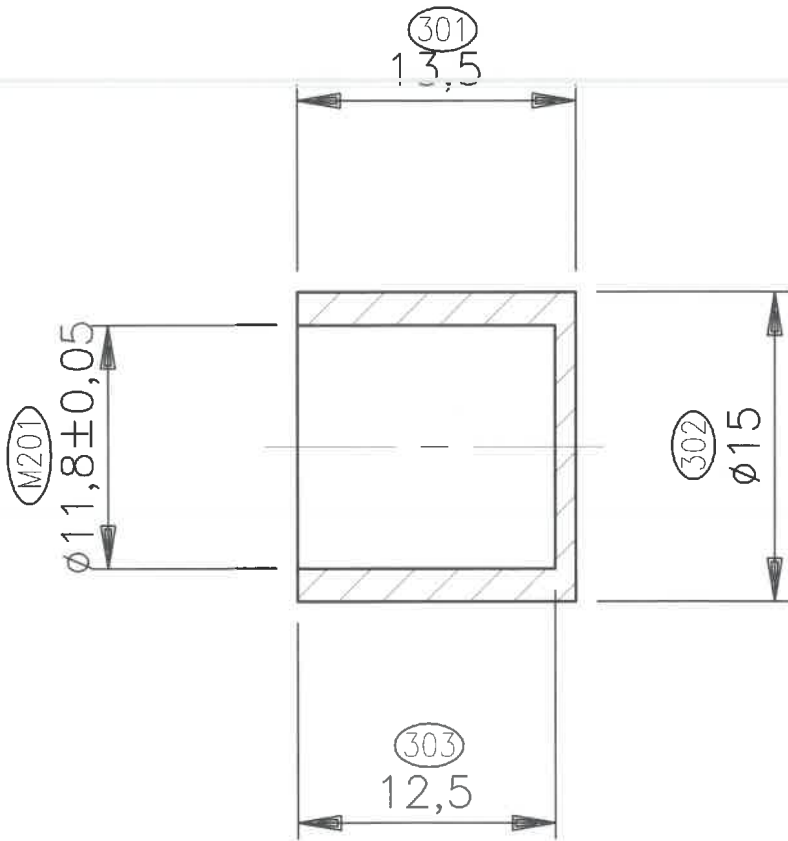
COVER M9425

3711

JOB No. KB/134/95/ DEV.		MATERIAL BRASS CZ 121 PB3 COND. M TO BS 2874										DRAWN JVR 06-02-28		INCIDENTAL (401-499) 0		INCIDENTAL 4.0%		
GENERAL TOLERANCES (UNLESS OTHERWISE STATED)														CHECKED FJW 06-03-28		NEXT ASSY 05228-010001-201001		
														APPROVED MGV 06-03-29		DRG No. 05228-010005-203001		REV. B
ALL GEOMETRIC TOLERANCES TO BE WITHIN 0,1														PROJECT LEADER		CODE No. 01106006409		CAD No. 00247780
														SCREEN DRG. No.				

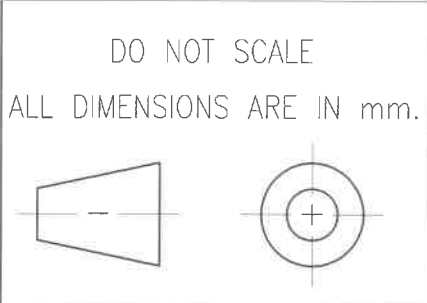
NOTE:

ACCEPTANCE INSPECTION INSTRUCTION			
CHAR. No.	CROSS REF.	GAUGE NUMBER	MEASURING DESCRIPTION
M101D	E-2	MATL.SPEC.	REPORT
M201	B-1		INSIDE MICROMETER
301	A-2		VERNIER
302	B-3		VERNIER
303	C-2		VERNIER



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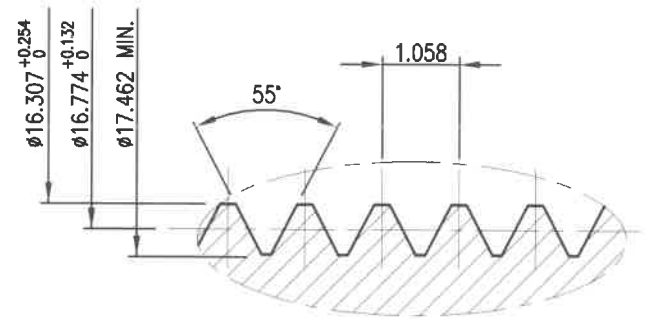
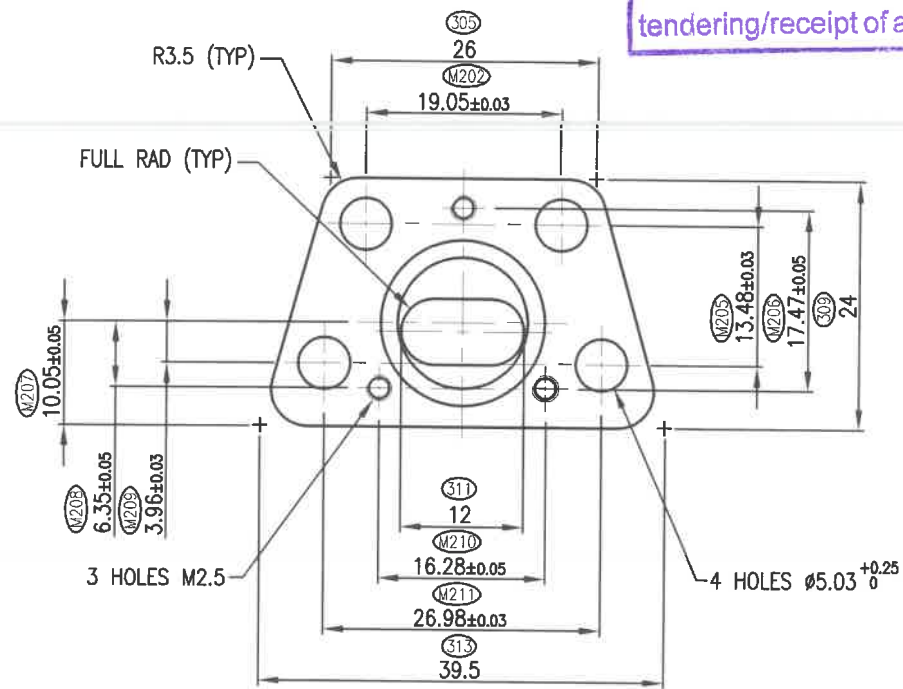
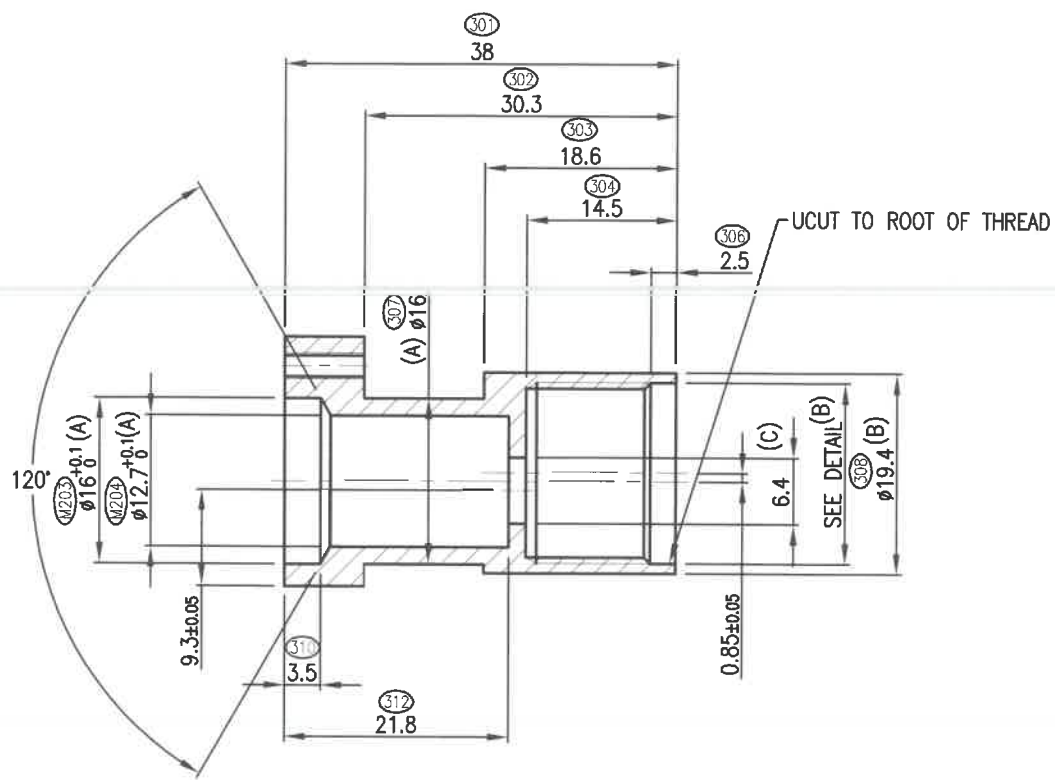
CLASSIFICATION OF CHARACTERISTICS CODING BASED ON DOD-STD 2101			FINAL ACCEPTANCE SAMPLE FOR VISUAL AND DIMENSIONAL INSPECTION: ACCORDING TO MIL. STD. 105 SINGLE NORMAL SAMPLE PLAN: GENERAL INSPECTION II		
CLASSIFICATION		TOTAL			
CRITICAL	(C1-C99)	0	A.Q.L.	CRITICAL	NOT APPLICABLE
MAJOR A	(M101-M199)	1		MAJOR A	0,025%
MAJOR B	(M201-M299)	1		MAJOR B	0,65%
MINOR	(301-399)	3		MINOR	1,5%
INCIDENTAL	(401-499)	0		INCIDENTAL	4,0%

✓ [✓][✓] HRC

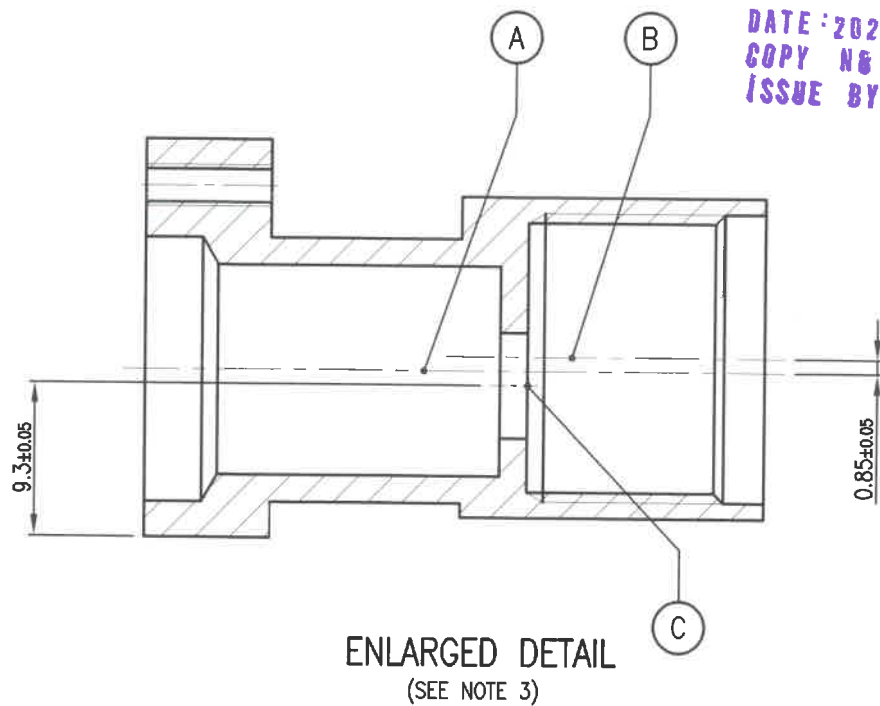
JOB No. KB/134/95 DEV.				MATERIAL HIGH DENSITY POLYPROPYLENE				FINALIZED PAC 95-10-26				APPROVED MGV 06-03-29				DRG No. 05228-010008x203001				REV B		
GENERAL TOLERANCES (UNLESS OTHERWISE STATED)												PROJECT LEADER P PRINSLOO 95-01-11										
LENGTHS AND DIAMETERS				ANGLES				RADIO				ALL GEOMETRIC TOLERANCES TO BE WITHIN 0,1										
0 TO 6	6 TO 30	30 TO 120	120 TO 315	315 TO 1000	1000 TO 2000	2000 TO 4000	4000 AND MORE	0° TO 30°	30° AND MORE	1 TO 6	6 TO 30									30 TO 100	100 TO 300	300 TO 1000
±0,1	±0,2	±0,3	±0,5	±0,8	±1,2	±2,0	±3,0	±30'	±1°	±0,5	±1,0									±1,5	±2,0	±3,0
SCREEN DRG.No.												CODE No. 01106006703				CAD No. 00128130						

TITLE	PROTECTIVE CAP M9425			PRODUCT		CARTRIDGE EXTINGUISH		
MACHINE		B	MGV	06/03/29	DRAWING UPDATED SEE JOB No. 03/E015/05PC			JVR
REPLACES DRG. No.		REV.	APP.	DATE	DETAILS			DONE BY

- NOTE:
1. REMOVE ALL SHARP EDGES.
 2. MATT TIN PLATE ALL OUTER SURFACES 0.002 - 0.006mm THICK.
A CERTIFICATE OF CONFORMANCE SHALL BE PROVIDED.
 3. THREE ECCENTRIC CENTRE LINES AND THEIR CORRESPONDING FEATURES ARE INDICATED BY A,B AND C.



11/16x24 TPI
ENLARGED DETAIL OF THREAD



ENLARGED DETAIL
(SEE NOTE 3)

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ACCEPTANCE INSPECTION INSTRUCTION			
CHAR. No.	CROSS REF.	GAUGE NUMBER	MEASURING DESCRIPTION
M101D	J-8	MATERIAL SPEC.	REPORT
M201	A-1	NOTE 2	REPORT
M202	C-1	05228-010003-267001	GAUGE PITCH
M203	D-1		INSIDE MICROMETER
M204	D-2		INSIDE MICROMETER
M205	D-10	05228-010003-267001	GAUGE PITCH
M206	D-10	05228-010003-267001	GAUGE PITCH
M207	D-6	05228-010003-267001	GAUGE PITCH
M208	E-7	05228-010003-267001	GAUGE PITCH
M209	E-7	05228-010003-267001	GAUGE PITCH
M210	E-8	05228-010003-267001	GAUGE PITCH
M211	E-8	05228-010003-267001	GAUGE PITCH
M212	H-5	05228-010003-267002	GAUGE PLUG SCREW
301	B-3		VERNIER
302	B-3		VERNIER
303	B-4		VERNIER
304	B-4		VERNIER
305	B-8		VERNIER
306	C-4		VERNIER
307	C-3		VERNIER
308	D-5		VERNIER
309	D10		VERNIER
310	E-2		VERNIER
311	E-8		VERNIER
312	E-3		VERNIER
313	E-8		VERNIER

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DATE: 2023.06.06
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DO NOT SCALE ALL DIMENSIONS ARE IN mm.		CLASSIFICATION OF CHARACTERISTICS CODING BASED ON DOD-STD 2101 CLASSIFICATION TOTAL		FINAL ACCEPTANCE SAMPLE FOR VISUAL AND DIMENSIONAL INSPECTION: ACCORDING TO MIL. STD. 105 SINGLE NORMAL SAMPLE PLAN: GENERAL INSPECTION II	
CRITICAL (C1-C99)		0		A.Q.L. CRITICAL NOT APPLICABLE	
MAJOR A (M101-M199)		1		MAJOR A 0.025%	
MAJOR B (M201-M299)		12		MAJOR B 0.65%	
MINOR (301-399)		13		MINOR 1.5%	
INCIDENTAL (401-499)		0		INCIDENTAL 4.0%	
JOB No. KB/134/95/ DEV.		MATERIAL BRASS CZ 121 PB3 COND. M TO BS 2874		DRAWN JVR 06-02-28	
GENERAL TOLERANCES (UNLESS OTHERWISE STATED)		CHECKED FJW 06-03-28		NEXT ASSY 05228-010001-201001	
LENGTHS AND DIAMETERS		APPROVED MGV 06-03-29		DRG No. 05228-010003-203001	
ANGLES		PROJECT LEADER		REV. B	
RADII		SCREEN DRG. No.		CODE No. 01106006104	
ALL GEOMETRIC TOLERANCES TO BE WITHIN 0,1		CAD No. 00247440			

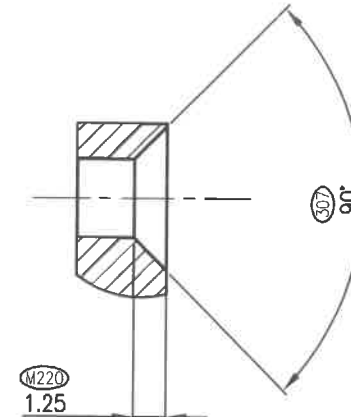
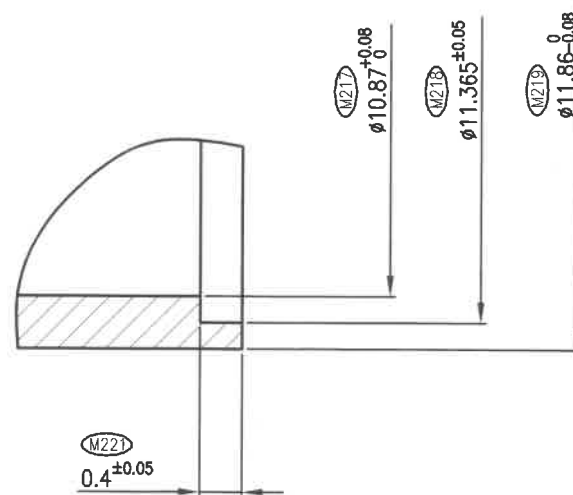
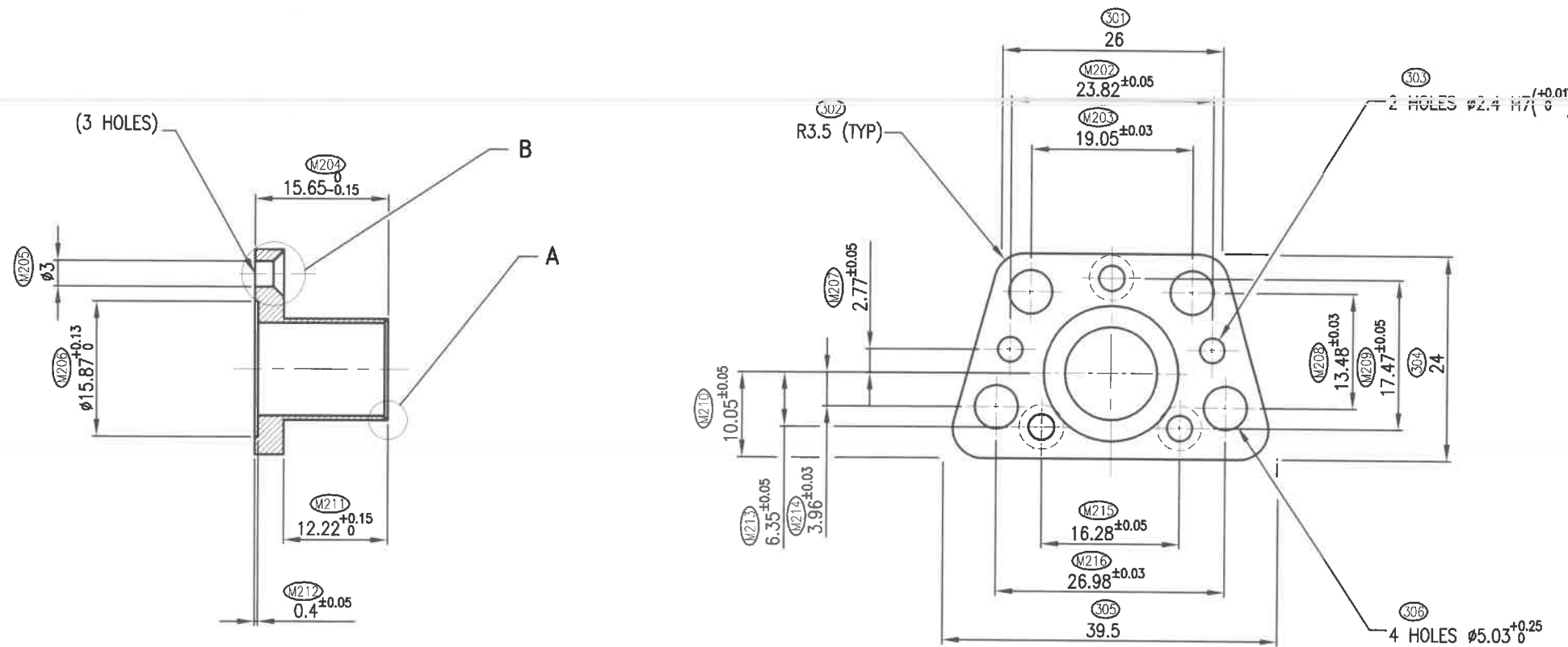
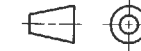
N7/ [✓][✓] HRC

CARTRIDGE EXTINGUISH		JVR		DONE BY	
REPLACES DRG. No.		DRAWING UPDATED SEE JOB No. E2/116/07PC		DETAILS	
B		FJW		DATE	
REV.		APP.			
MACHINE		PRODUCT			
BODY M9425					

NOTE:

1. REMOVE ALL SHARP EDGES.
2. MATT TIN PLATE ALL OUTER SURFACES 0.002-0.006mm THICK
A CERTIFICATE OF CONFORMANCE SHALL BE PROVIDED.

DO NOT SCALE
ALL DIMENSIONS ARE IN mm.



ACCEPTANCE INSPECTION INSTRUCTION

CHAR. No.	CROSS REF.	GAUGE NUMBER	MEASURING DESCRIPTION
M101D	J-9	MATERIAL SPEC.	REPORT
M201	A-1	NOTE 2	REPORT
M202	C-8	05228-010005-267005	GAUGE PITCH
M203	C-8	05228-010005-267005	GAUGE PITCH
M204	C-4		VERNIER
M205	D-2		VERNIER
M206	D-2	05228-010005-267003	GAUGE PLUG
M207	D-6	05228-010005-267005	GAUGE PITCH
M208	D-10	05228-010005-267005	GAUGE PITCH
M209	D-10	05228-010005-267005	GAUGE PITCH
M210	E-6	05228-010005-267005	GAUGE PITCH
M211	F-3		VERNIER
M212	E-4	05228-010005-267002	GAUGE CLOCK DEPTH
M213	E-6	05228-010005-267005	GAUGE PITCH
M214	E-6	05228-010005-267005	GAUGE PITCH
M215	E-8	05228-010005-267005	GAUGE PITCH
M216	E-8	05228-010005-267005	GAUGE PITCH
M217	G-5		INSIDE MICROMETER
M218	G-6	05228-010005-267001	GAUGE PLUG
M219	F-6		MICROMETER
M220	H-9		VERNIER
M221	I-4	05228-010005-267002	GAUGE CLOCK DEPTH
301	B-8		VERNIER
302	C-7		RADIUS GAUGE
303	C-10		TOOL CONTROL
304	D-10		VERNIER
305	F-8		VERNIER
306	F-10		TOOL CONTROL
307	G-10		TOOL CONTROL

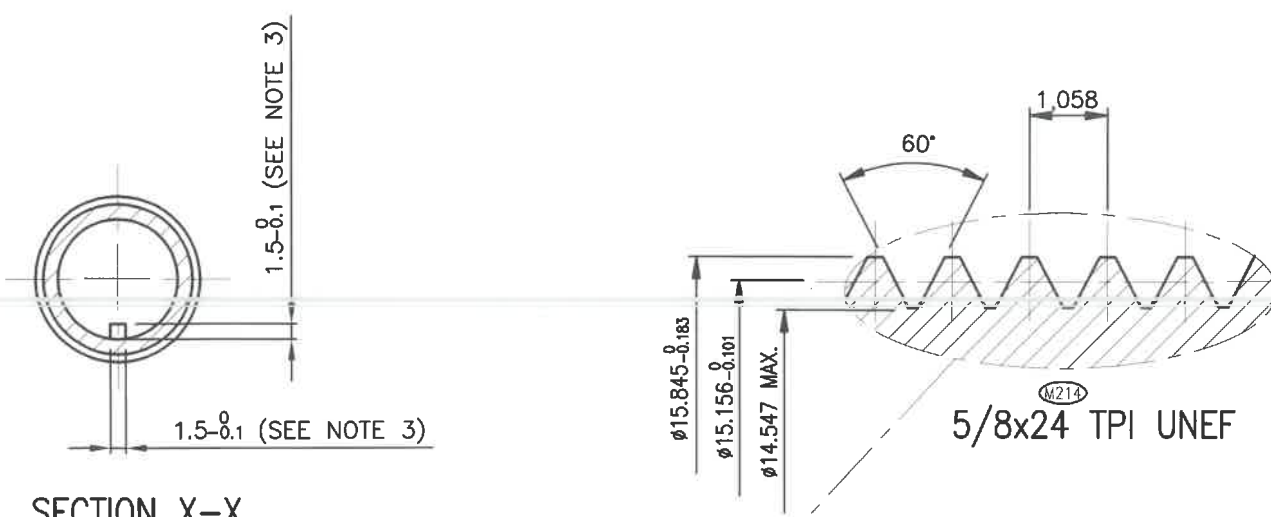
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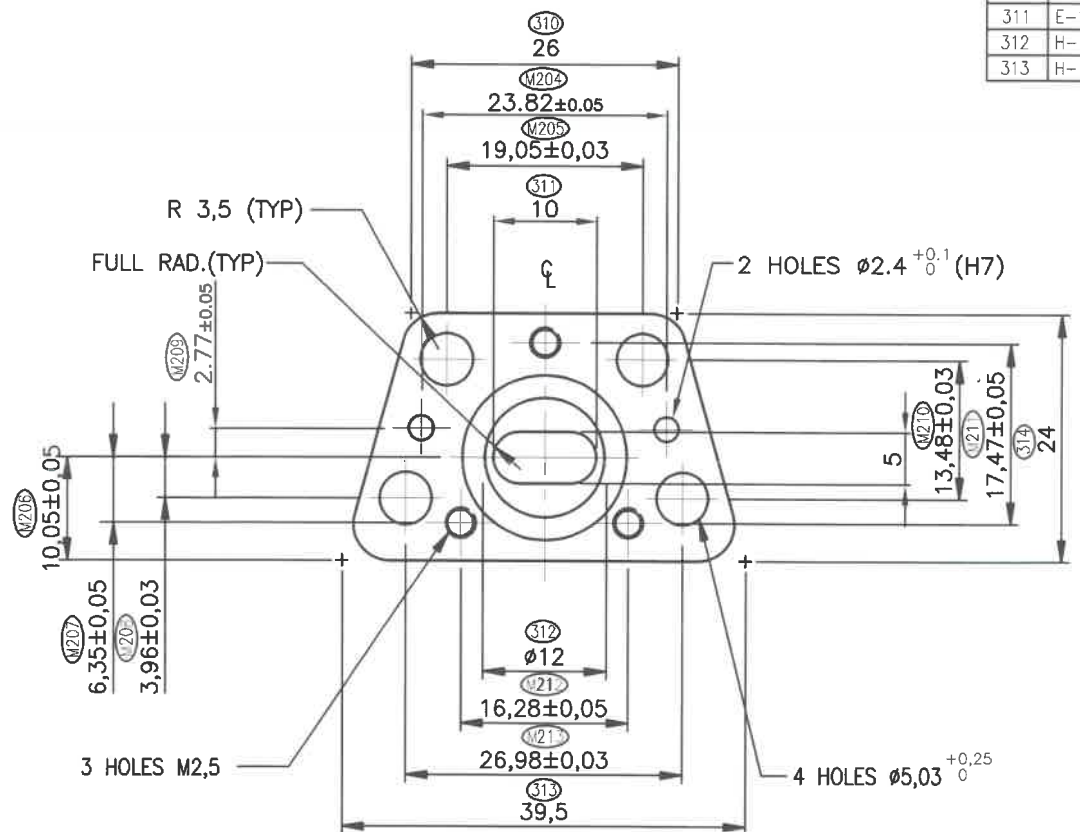
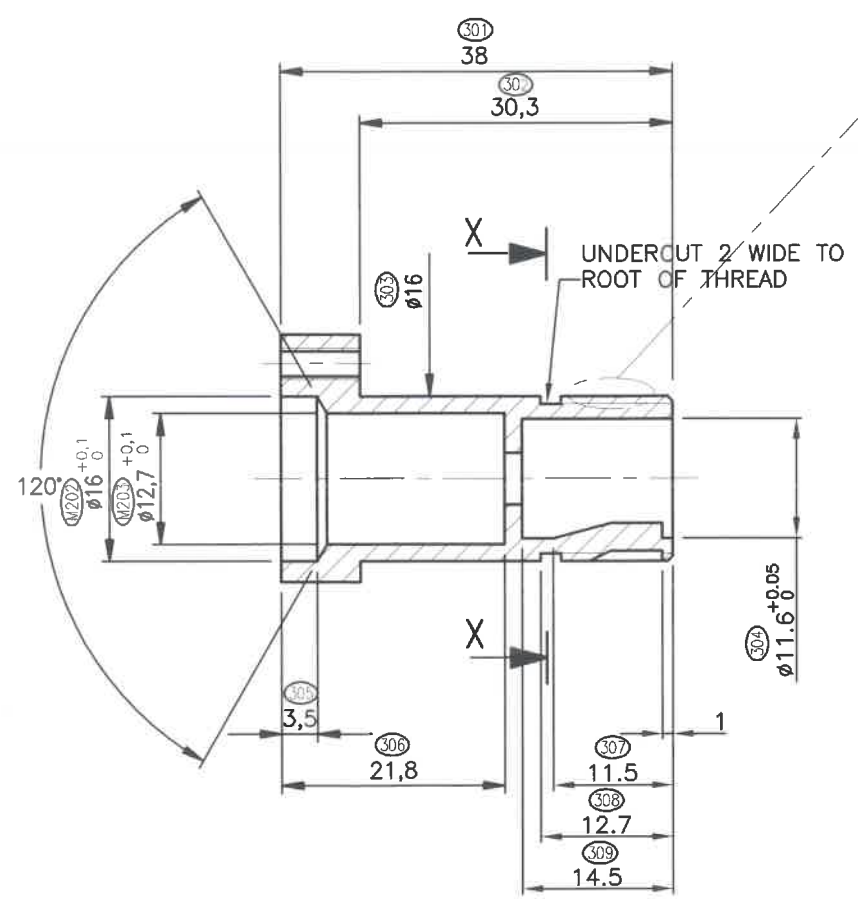
CLASSIFICATION OF CHARACTERISTICS CODING BASED ON DOD-STD 2101	
CLASSIFICATION	TOTAL
CRITICAL (C1-C99)	0
MAJOR A (M101-M199)	1
MAJOR B (M201-M299)	21
MINOR (301-399)	7
INCIDENTAL (401-499)	0

JOB No. E2/090/11PC	MATERIAL M101D BRASS CZ 121 Pb3 COND. M TO BS 2874	MACHINE	DRAWN JJO 11-08-31	CHECKED FJW 11-09-07	NEXT ASSY 05614-010001-201001 ITEM 6	REPLACES DRG. No.
GENERAL TOLERANCES (UNLESS OTHERWISE STATED)			FINALIZED	APPROVED MCV 11-09-08	TITLE COVER M9830 (A718)	
LENGTHS AND DIAMETERS			PROJECT LEADER		CODE No. 00189037003	DRG No. 05614-010003x203001
ALL GEOMETRIC TOLERANCES TO BE WITHIN 0.1			SCREEN DRG. No.		CAD No. 00115350	REV. B

- NOTE:
- 1. REMOVE ALL SHARP EDGES.
 - 2. MATT TIN PLATE ON ALL OUTER SURFACES 0.002-0.006mm THICK. A CERTIFICATE OF CONFORMANCE SHALL BE PROVIDED.
 - 3. GUIDE TO BE FORMED AFTER CUTTING THREAD.



ACCEPTANCE INSPECTION INSTRUCTION			
CHAR. No.	CROSS REF.	GAUGE NUMBER	MEASURING DESCRIPTION
M101D	J-8	MATERIAL SPEC.	REPORT
M201	A-1	NOTE 2	REPORT
M202	G-2		INSIDE MICROMETER
M203	G-2		INSIDE MICROMETER
M204	E-10	05228-010003-267001	GAUGE PITCH
M205	E-10		
M206	G-7		
M207	G-7		
M208	G-8		
M209	F-8		
M210	F-12		
M211	F-12		
M212	H-10		
M213	H-10		
M214	C-8	05614-010002X267001	GAUGE RING THREAD
301	D-4		VERNIER
302	E-4		
303	F-3		
304	G-5		
305	H-3		
306	H-3		
307	H-4		
308	H-4		
309	H-4		
310	E-10		
311	E-10		
312	H-10		
313	H-10		



MANUFACTURE

DATE: 2023.06.08

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