

On Her Majesty's Service

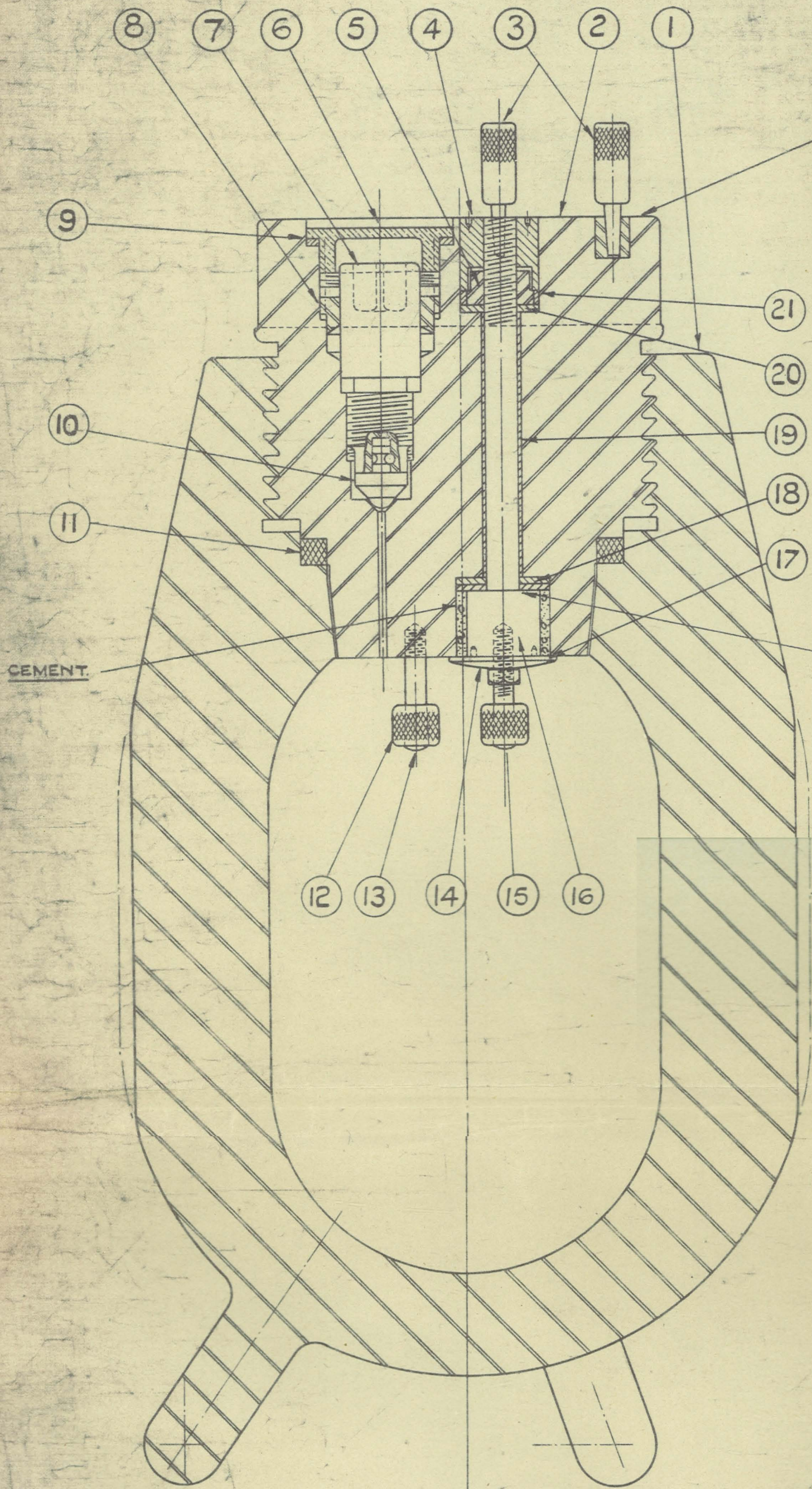
WASC1417

CORDITE BOMB. M^K. R.N. 1^C.

WEIGHT 58-59 LBS. CAPACITY 800 C.C.³

SCALE - FULL SIZE.

SHEET 1 OF 4.



ITEMS ⑥ & ④ TO BE FLUSH WITH TOP OF ITEM ②

SPECIFICATION FOR HEAT TREATMENT.

MATERIAL - VIBRAC (V 30) STEEL.

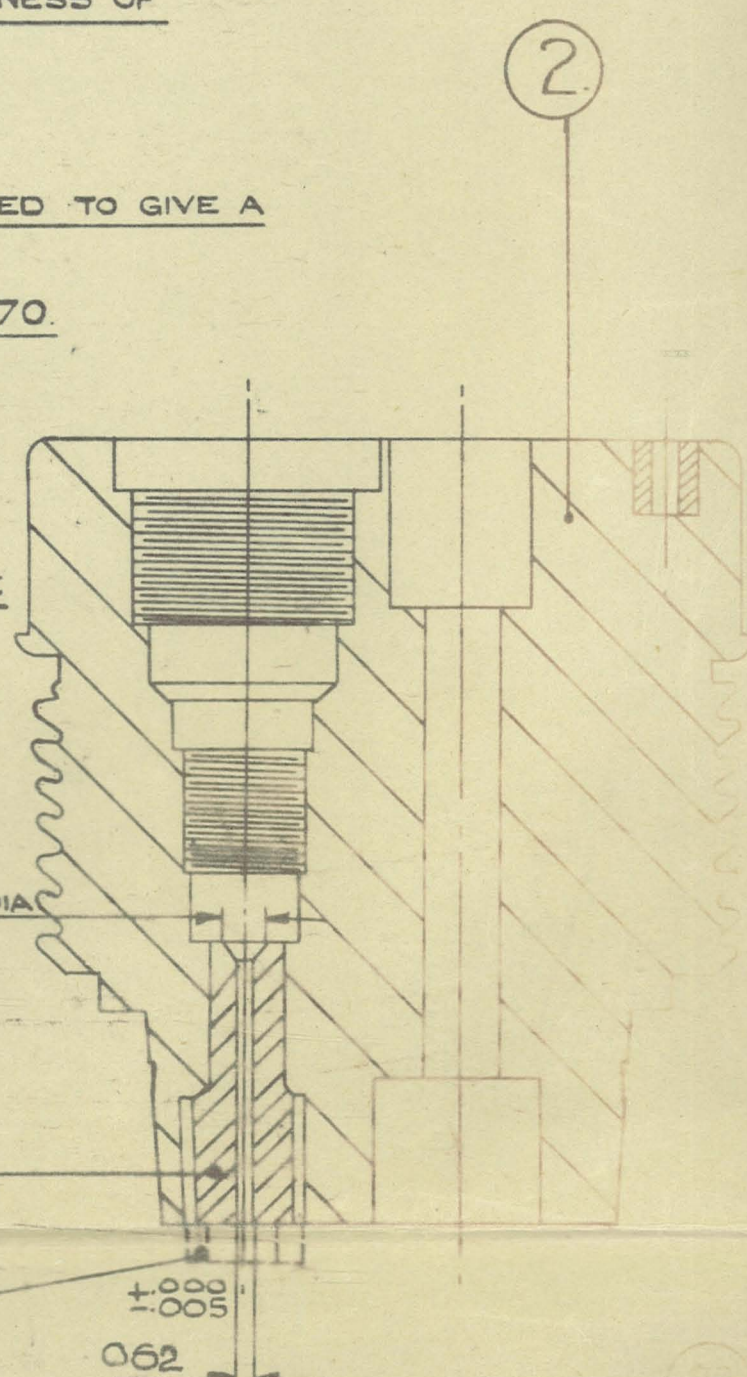
BOMB BODY FORGING ① - OIL HARDENED.

FROM 830° C. TEMPERED AT A TEMPERATURE NOT BELOW 400° C. TO GIVE A BRINELL HARDNESS OF NOT LESS THAN 350.

PLUG ② - HARDENED AS ABOVE & TEMPERED TO GIVE A BRINELL HARDNESS OF NOT LESS THAN 270.

THE ADJACENT FLAT SURFACES AT THE BOTTOM OF RECESS & INSIDE OF ELECTRODE ARE TO BE ACCURATELY TURNED SO AS TO BE TRULY PARALLEL & AT RIGHT ANGLES TO THEIR COMMON AXIS.

CHAIN LINE SHOWS OUTLINE OF BOMB BEFORE FLATS ARE MADE.



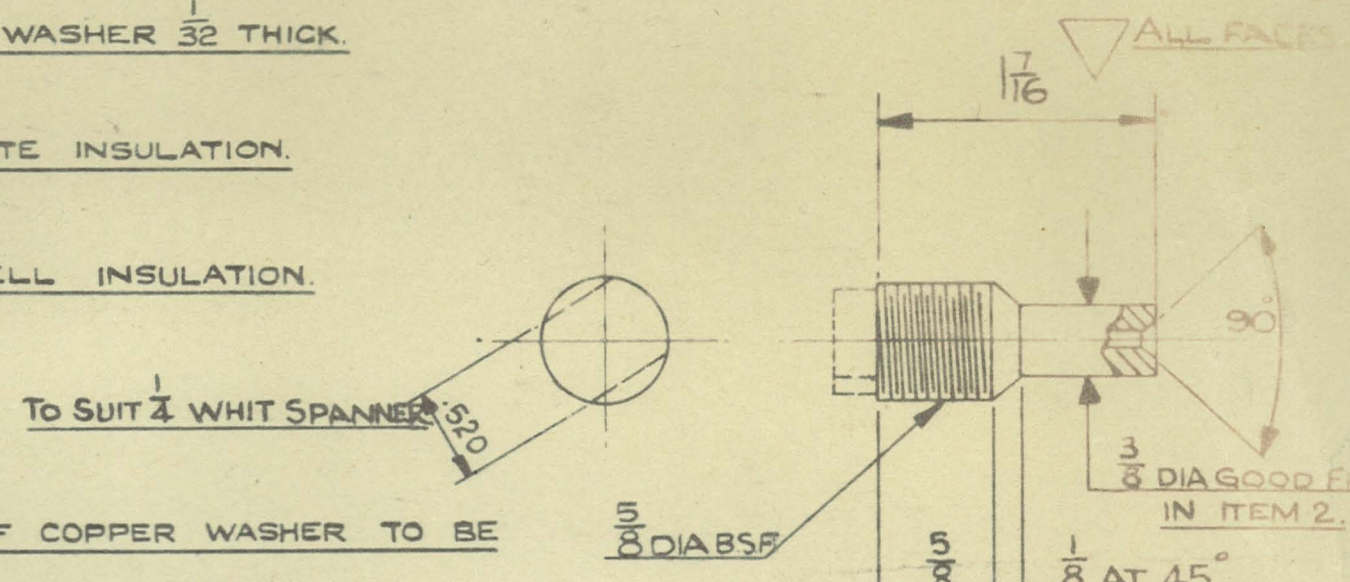
- ⑨ } TUFNELL WASHERS
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ITEM 23 TO BE SCREWED UP TIGHT IN BODY & MATERIAL SHOWN CHAIN DOTTED TO BE MACHINED OFF FLUSH.

MICA WASHER 1/32 THICK.

EBONITE INSULATION.

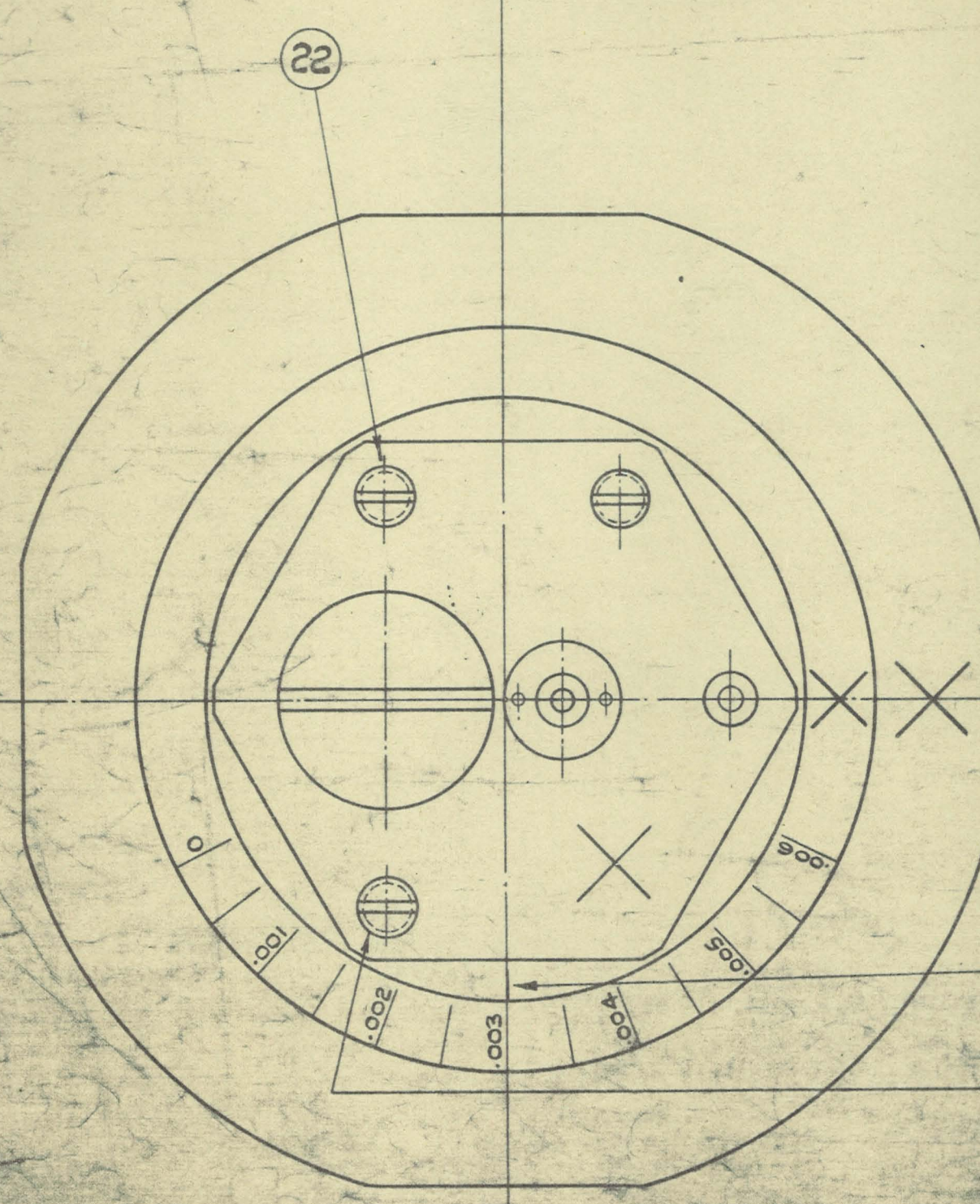
TUFNELL INSULATION.



NOTE:- THICKNESS OF COPPER WASHER TO BE SUCH THAT THERE IS .003 RADIAL CLEARANCE ON TAPERED PORTIONS WHEN LINE ON CAP CORRESPONDS TO .003 MARK.

TOP FACE OF BODY TO BE WELL ENGRAVED AS SHOWN. EACH LINE TO BE EQUALLY SPACED AT INTERVALS OF 10°-48' ZERO LINE TO BE FIXED WITH COPPER WASHER REMOVED & TAPERED SURFACES IN CONTACT & FILLED WITH RED WAX. OTHER LINES & TOLERANCES FILLED WITH BLACK WAX.

SERIAL TO BE ENGRAVED ON BODY. PLUG & VALVE SPINDLE AS SHOWN AT X. WITH NUMBERS 1/2 INCH HIGH (WHERE POSSIBLE.) NUMBERS TO BE FILLED WITH RED WAX. FOR TIGHTENING PLUG INTO BODY SEE SPANNER, SKETCH I.N.O. No. 742 B & VICE, SKETCH I.N.O. No. 717.



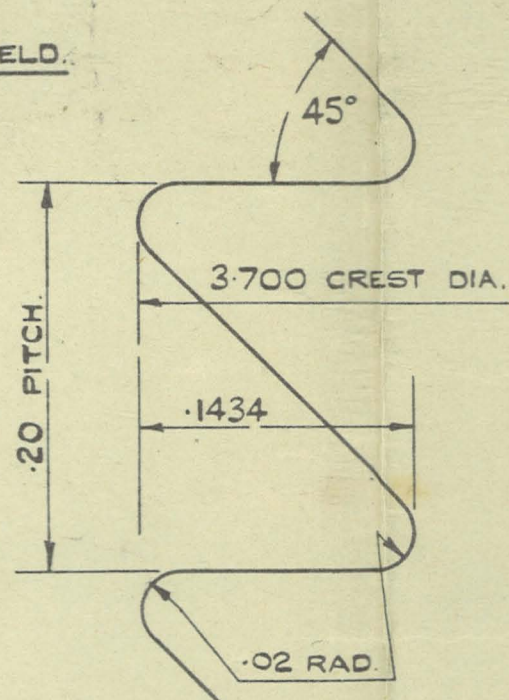
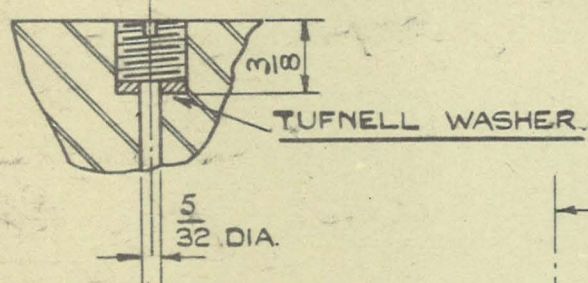
LINE ENGRAVED ON SIDE OF CAP & FILLED WITH RED WAX.
2 IN No. PLUGS. SCREWED 3/8 WHIT x 3/8 LONG FOR PLUGGING HOLES. FOR EYEBOLTS.

DETAILS OF BODY ① & PLUG ②

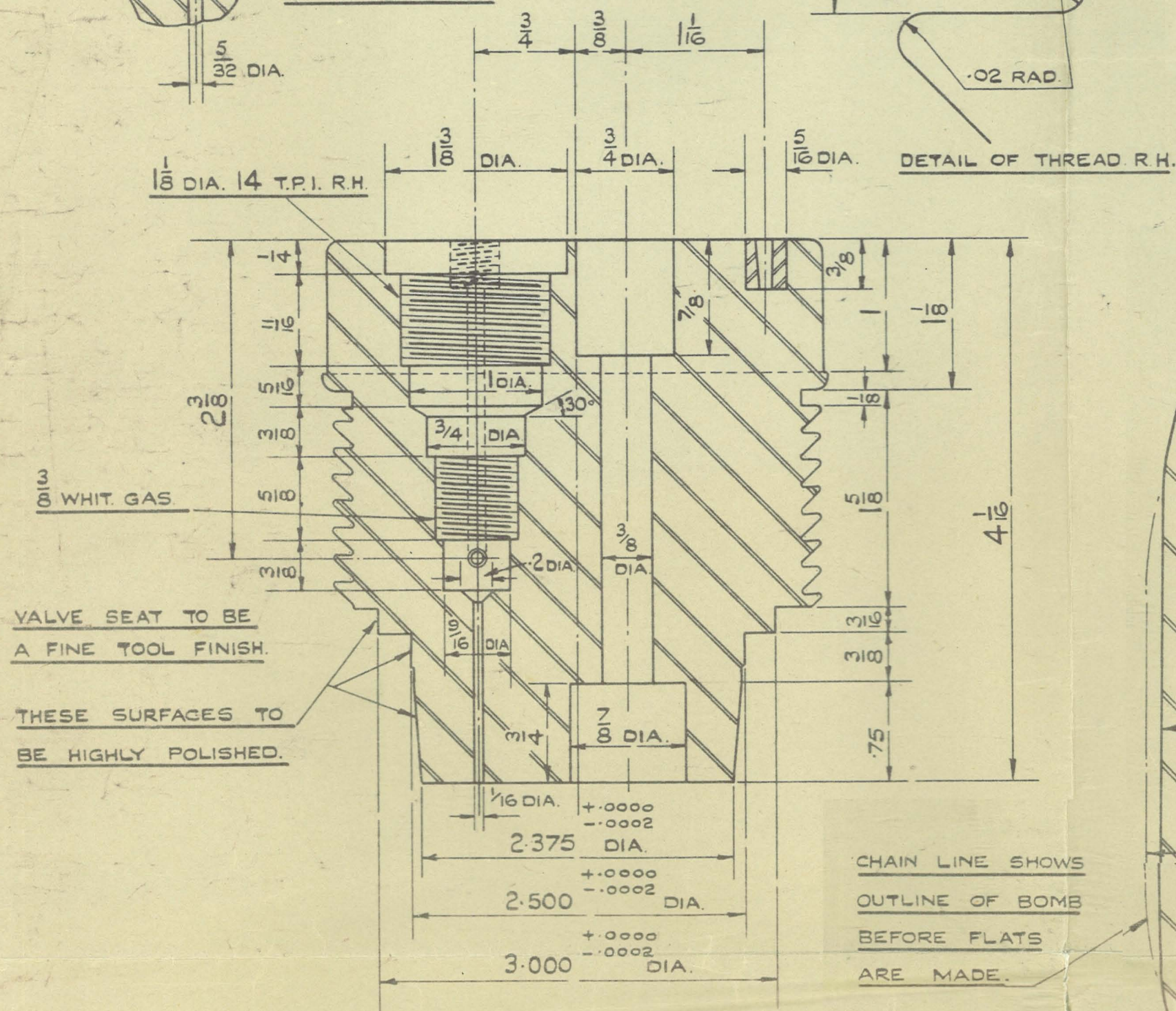
MATERIAL- VIBRAC (V 30) STEEL

THREAD TO SUIT GAUGES.
 RETAINED BY I.N.O. SHEFFIELD.

SECTION THROUGH GAS
 ESCAPE HOLE SHOWING
 ② IN POSITION.



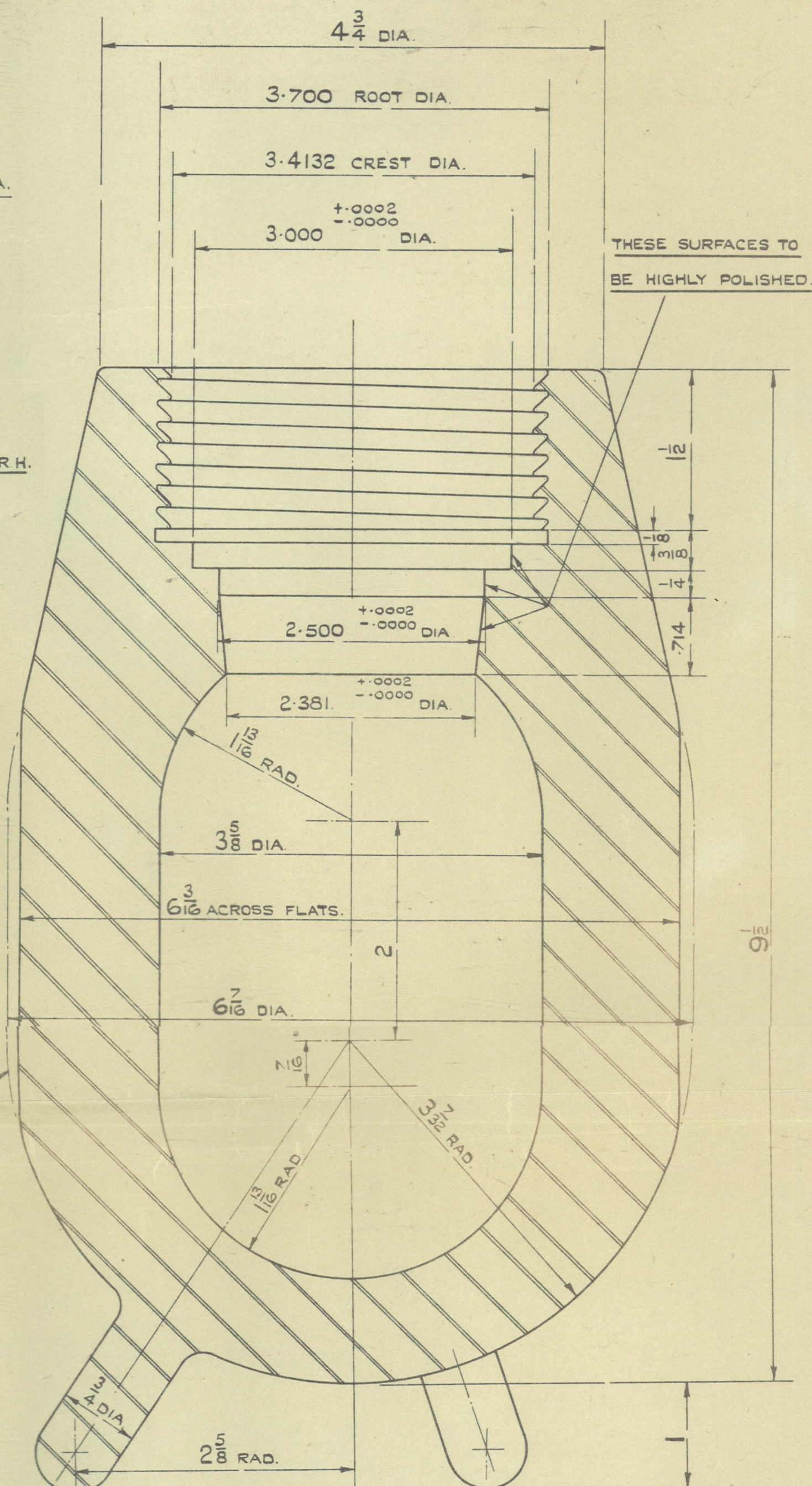
DETAIL OF THREAD R.H.



VALVE SEAT TO BE
 A FINE TOOL FINISH.

THESE SURFACES TO
 BE HIGHLY POLISHED.

CHAIN LINE SHOWS
 OUTLINE OF BOMB
 BEFORE FLATS
 ARE MADE.



THESE SURFACES TO
 BE HIGHLY POLISHED.

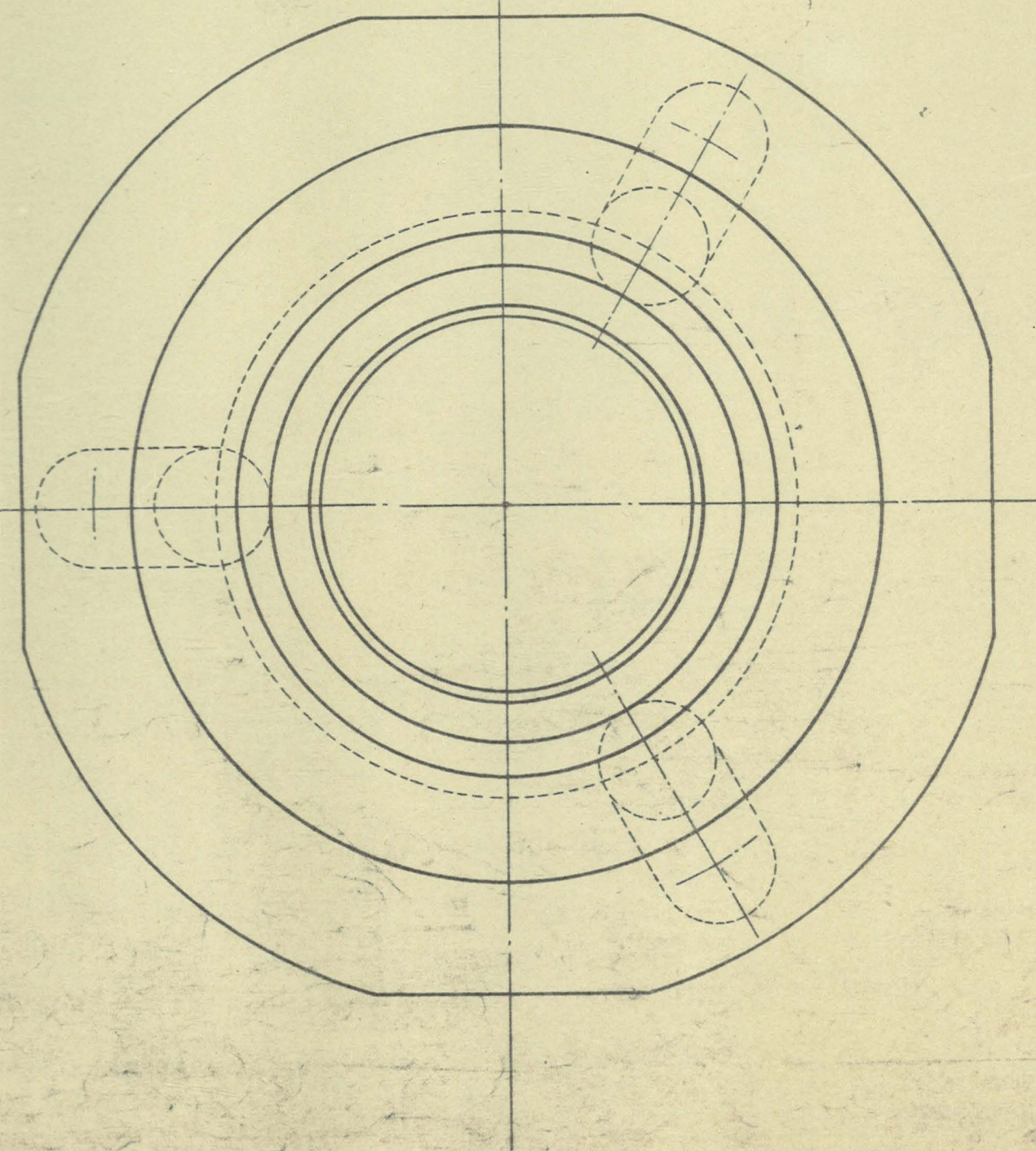
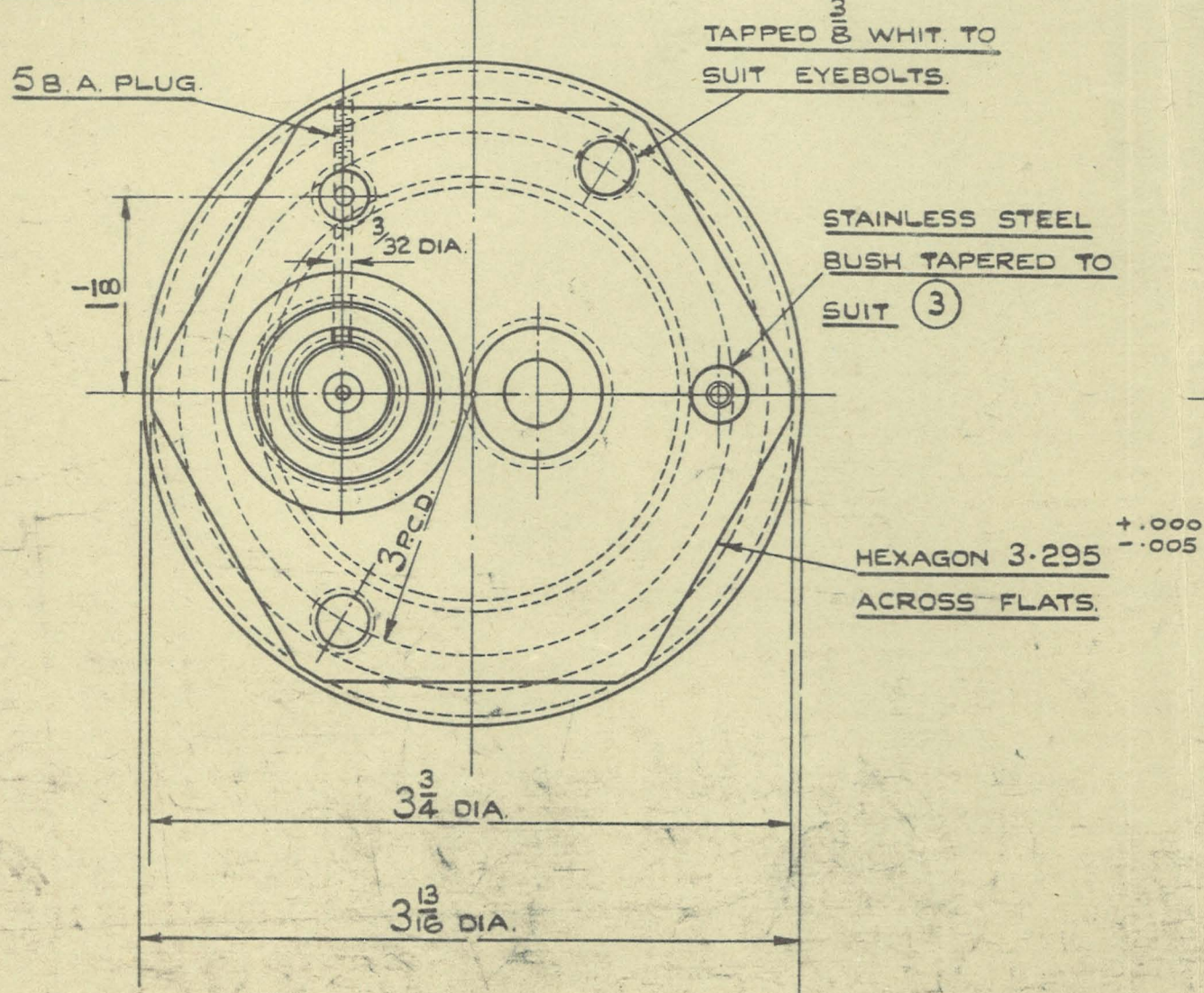
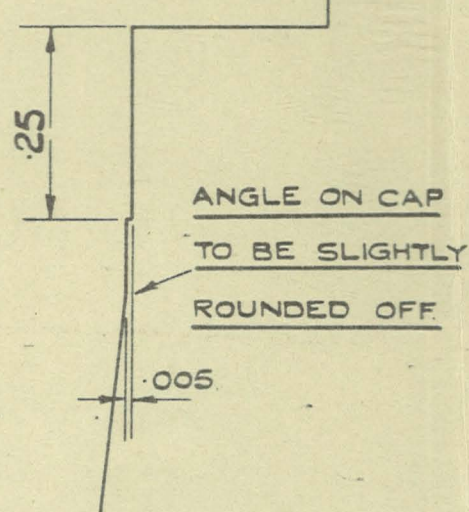
INTERNAL SURFACE TO
 BE A GOOD M/C FINISH.

3 FEET EQUALLY SPACED.

METHOD OF SECURING 5 B.A. PLUG
 IN ITEM 2.

- (a) SQUARE THE OUTER LIP OF TAPPED HOLE TO THE BOTTOM OF THREAD.
- (b) MAKE A LONG SCREW OF SILVER STEEL A TIGHT FIT & SCREW HOME (SCREW TO BE COVERED WITH WHITE LEAD).
- (c) CUT OFF SCREW CLOSE TO THE MAIN THREAD PROFILE & FILL UP THE SQUARE CORNERS BY FINE CENTRE POPS.
- (d) FILE OFF SURPLUS METAL & POLISH TO PROFILE OF MAIN THREAD.

ENLARGED VIEW
 SHOWING REDUCTION
 IN DIA. OF PARALLEL
 PORTION.



I.N.O. (S) 738.F.

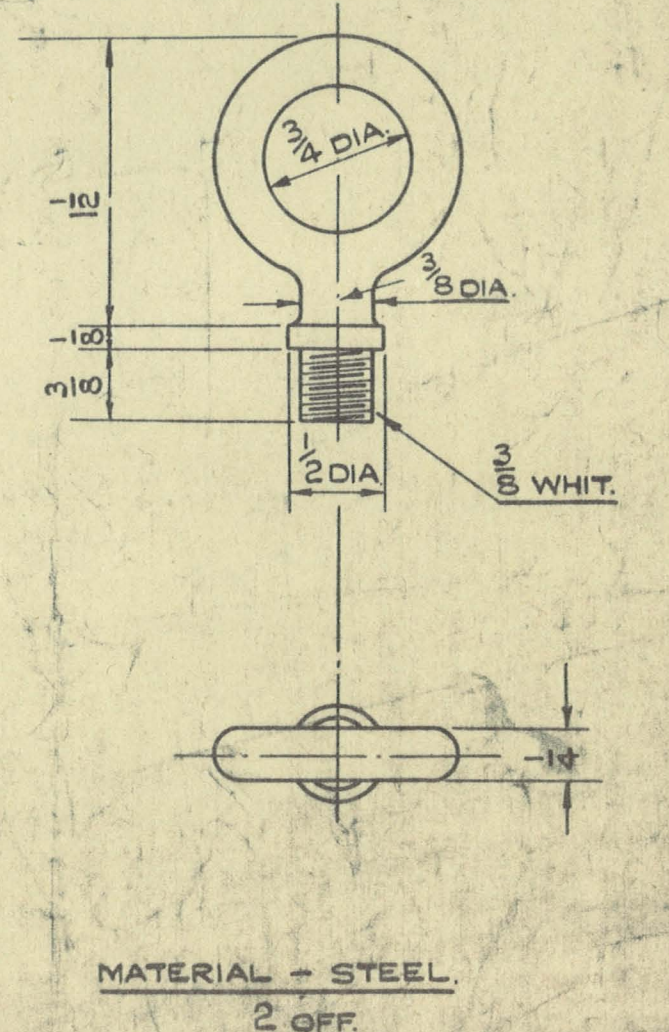
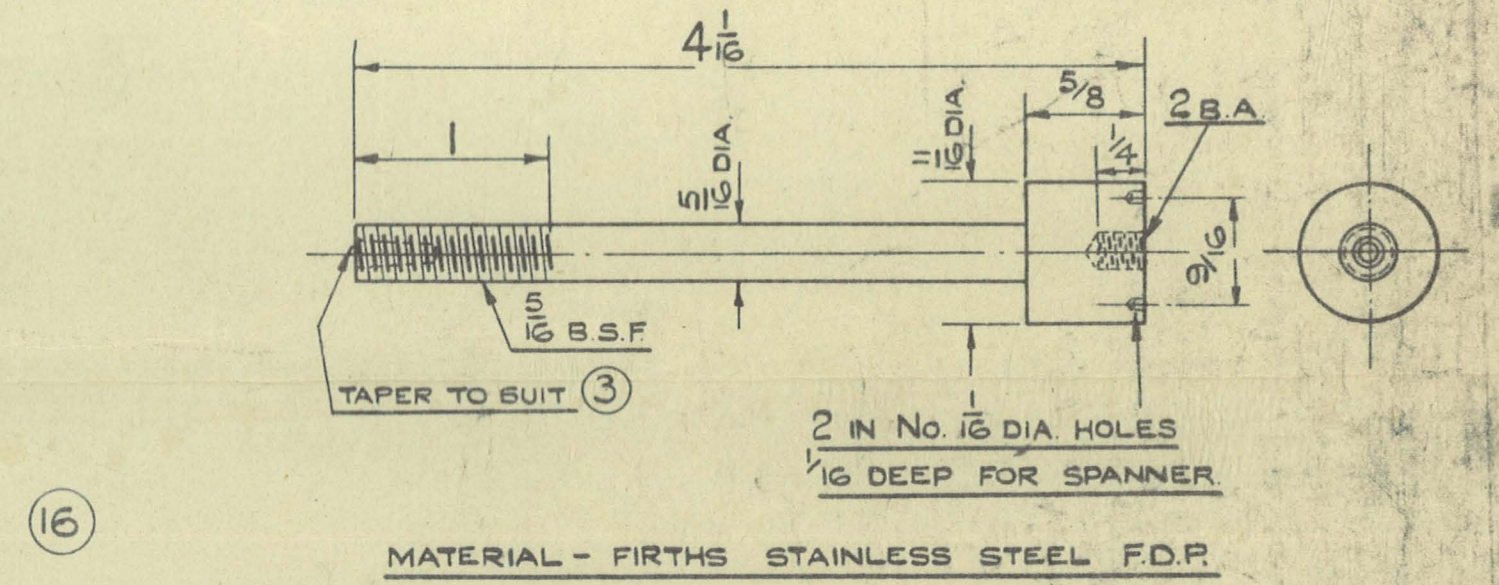
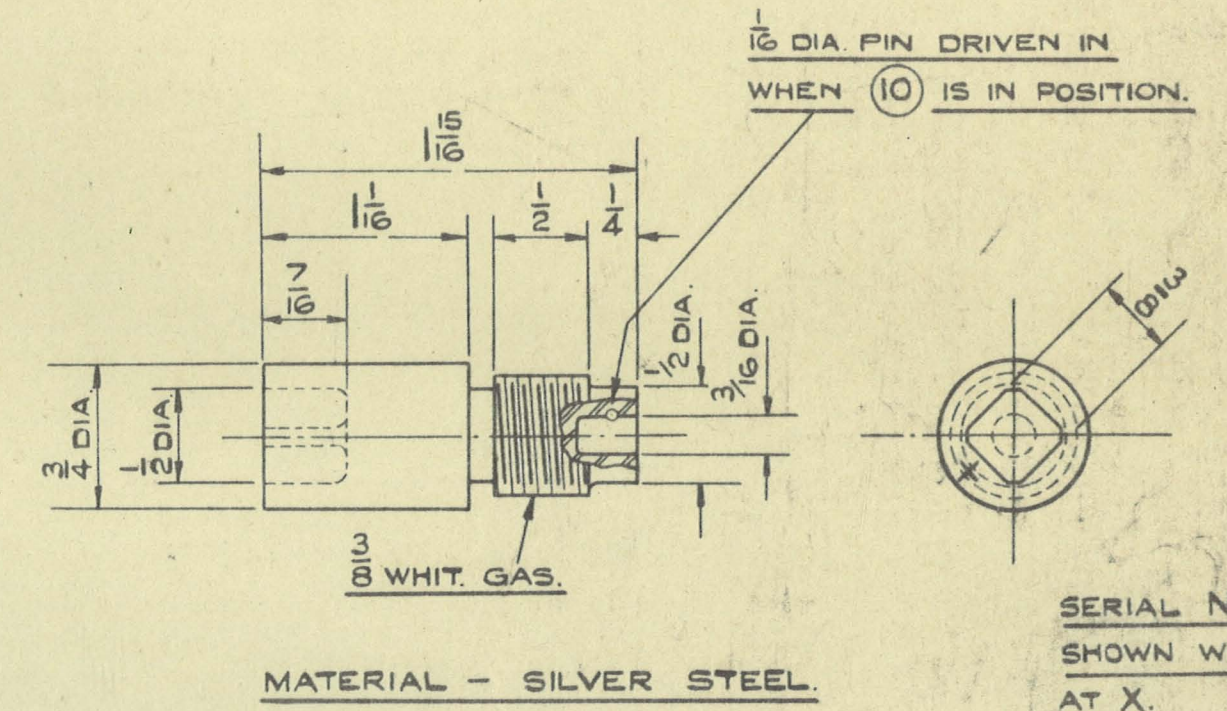
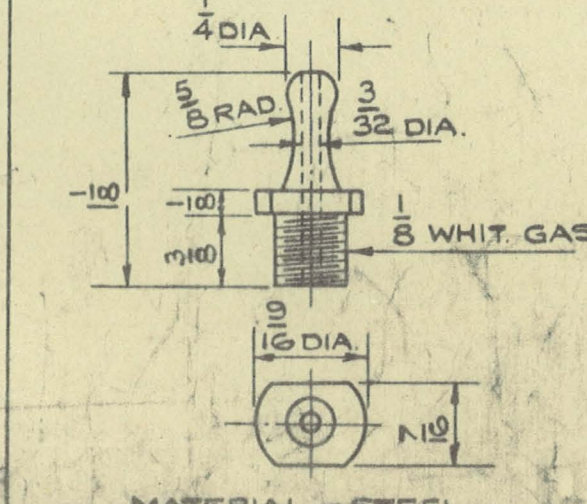
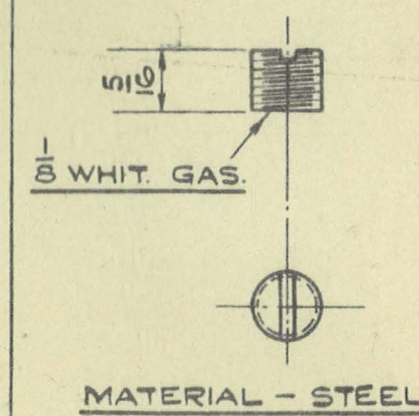
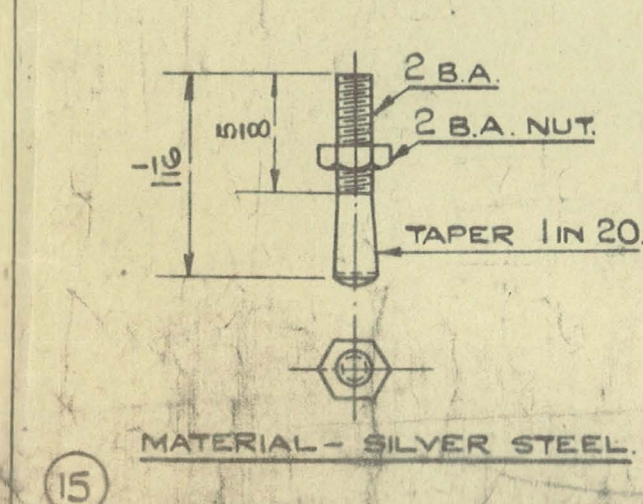
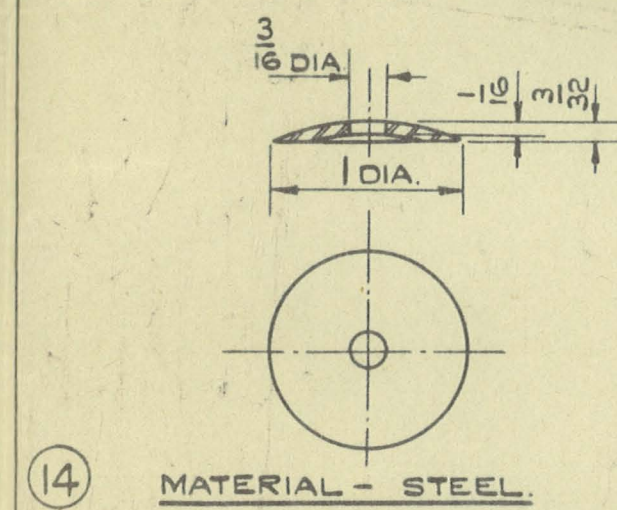
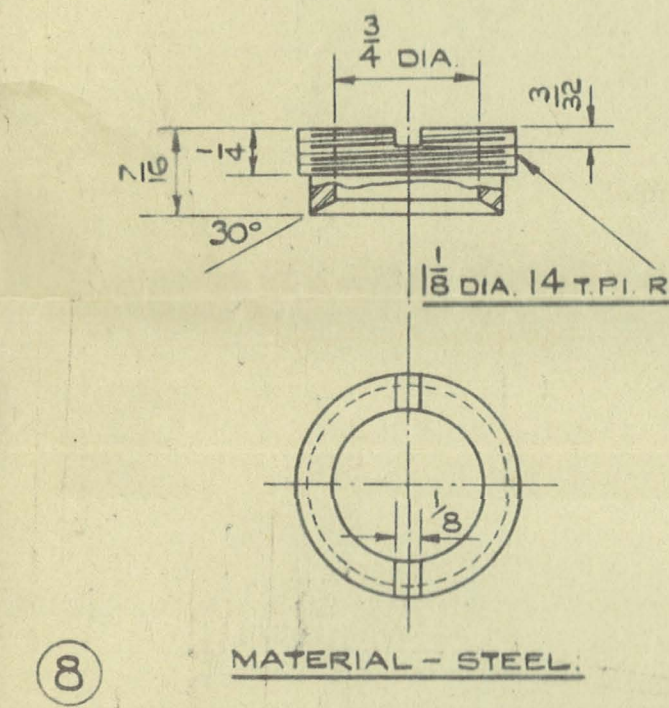
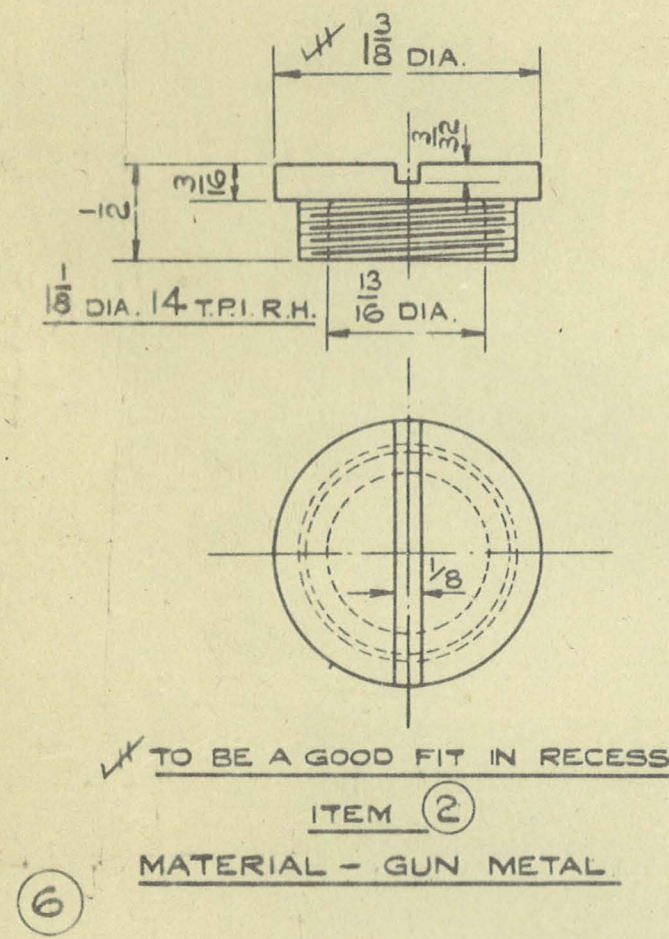
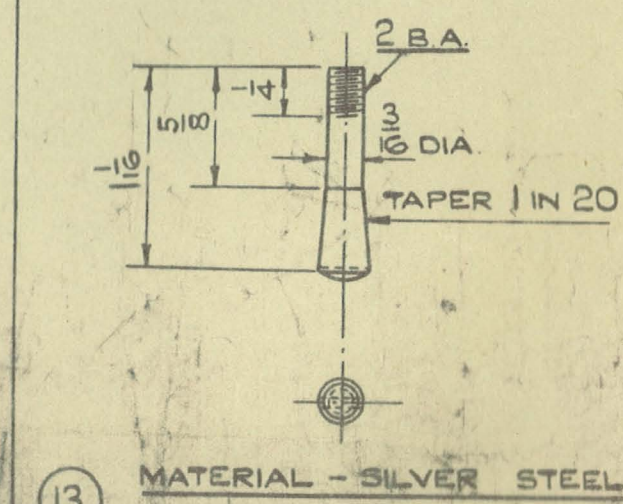
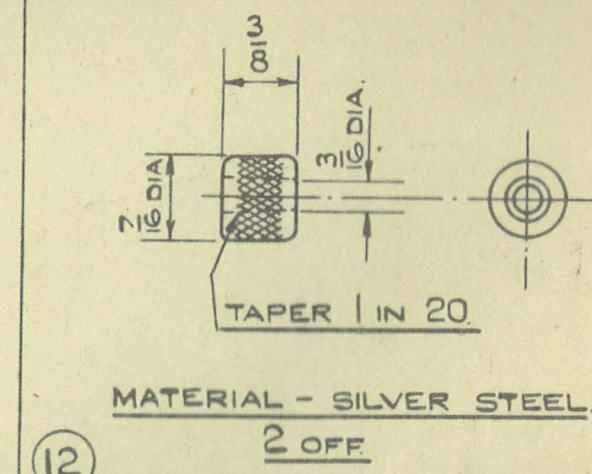
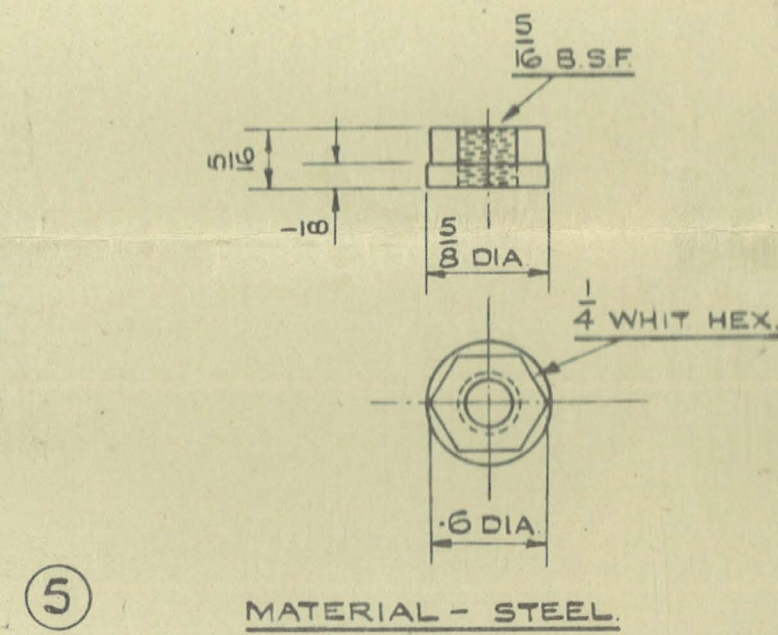
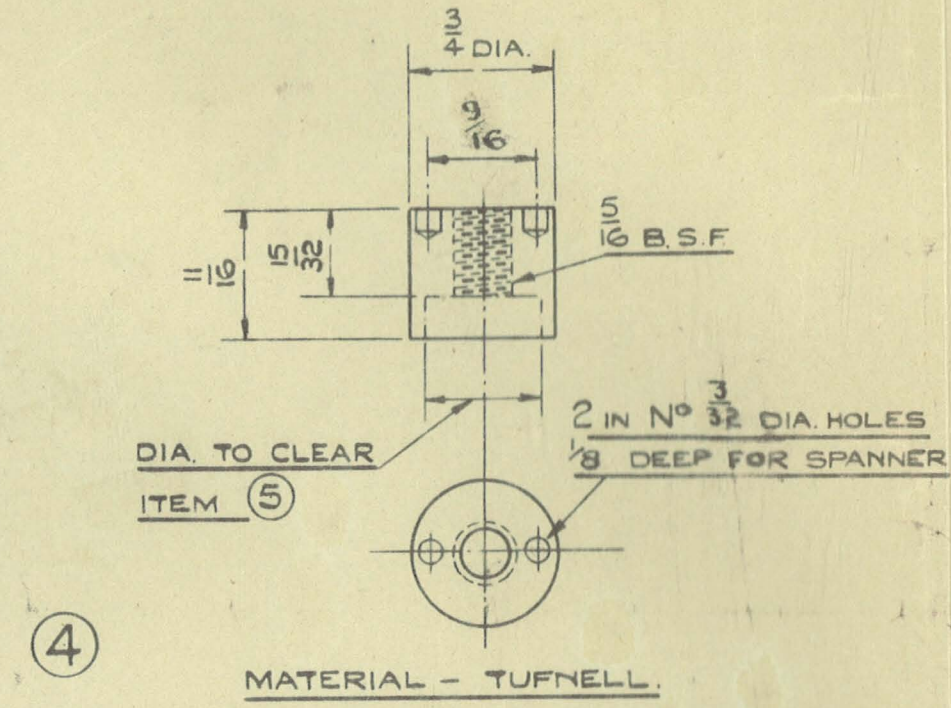
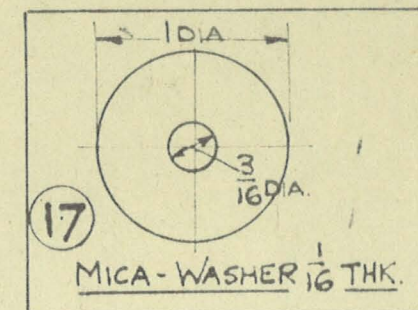
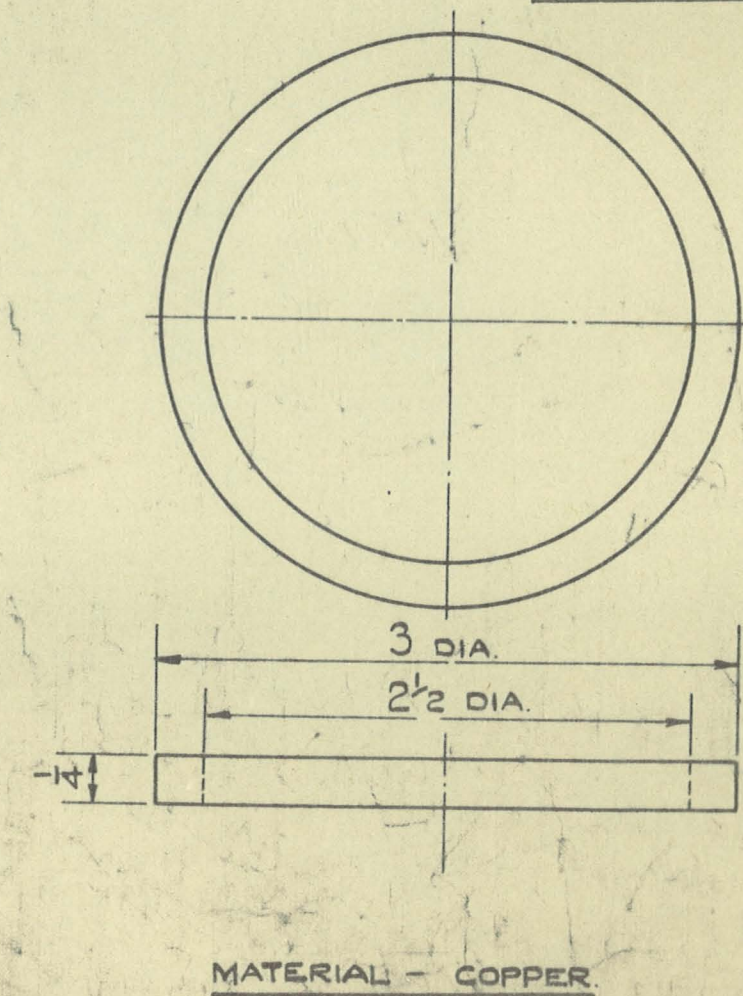
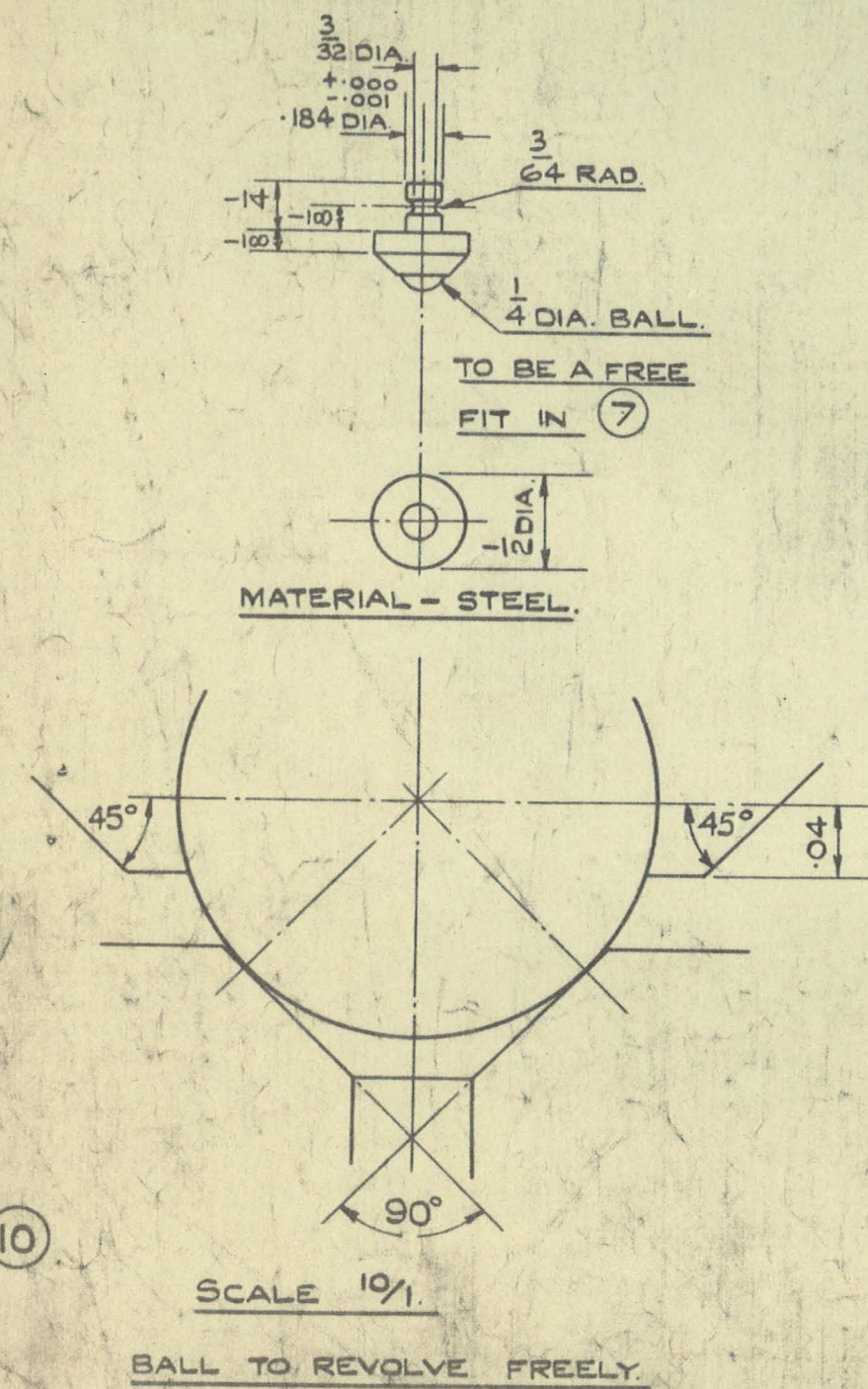
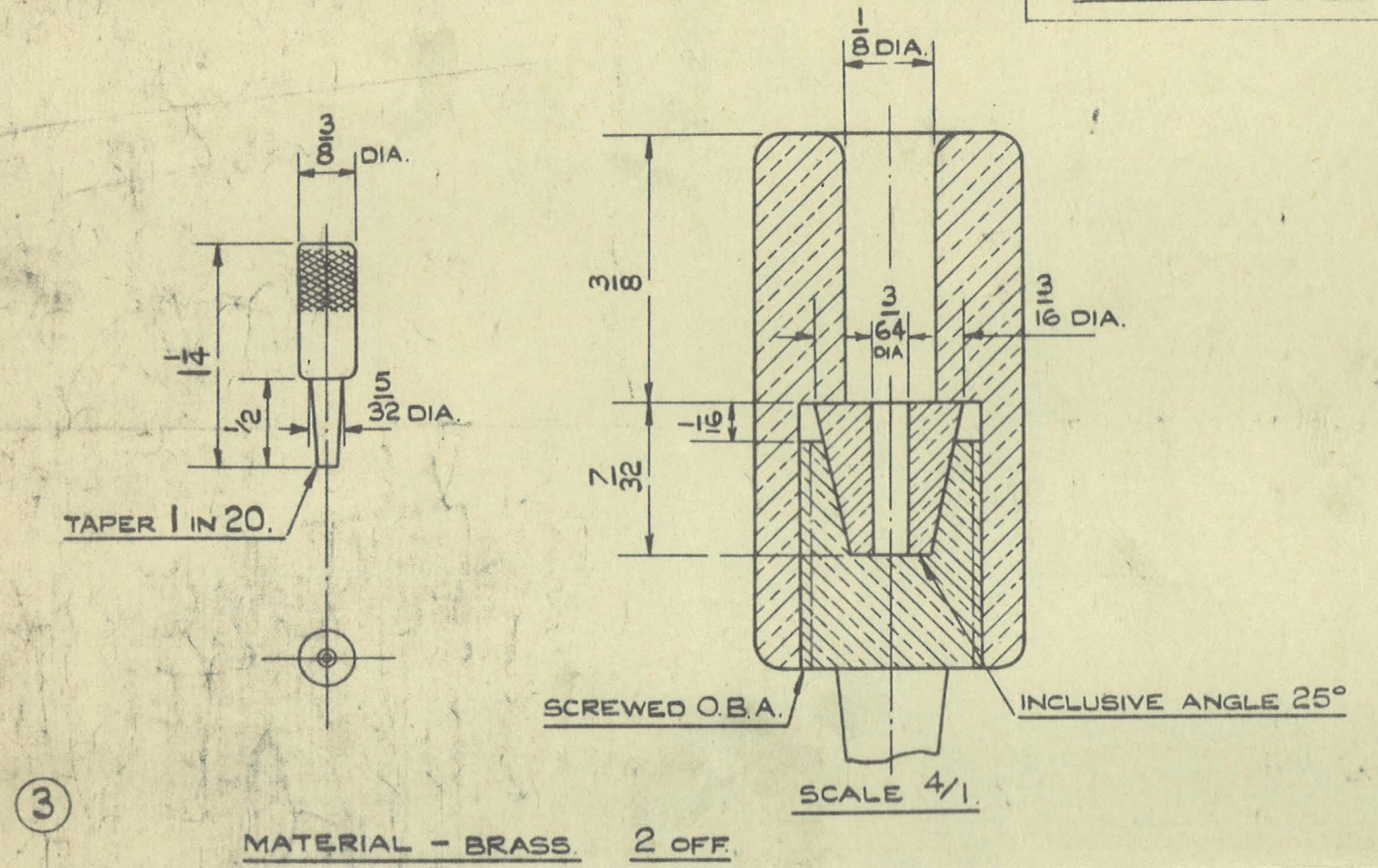
10-11-44. P.W.
5-9-40. K.B. 1-11-50 R.M.
10-3-44. C.G.

MATERIAL - AS SHOWN.

SCALE - FULL SIZE.

SHEET 3 OF 4.

DETAILS.



SERIAL No. TO BE SHOWN WHERE MARKED AT X.

I.NO. (5) 738^F

10-3-44 G.G. 10-11-44 D.W.
5-3-40 K.B. 1:1150.R.M.
21-10-40 K.B.
MATERIAL:- AS SHOWN.

SCALE:- FULL SIZE.

SHEET 4 OF 4

TOOLS, VARIOUS.

