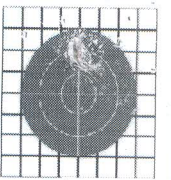
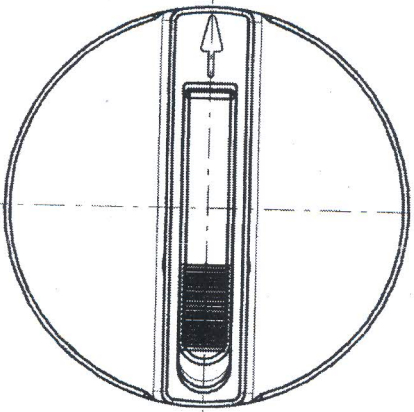
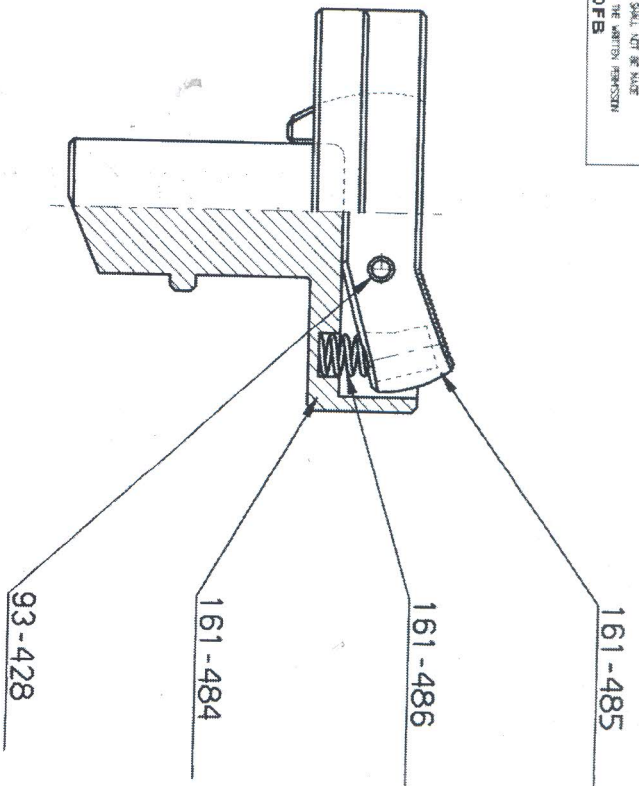


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 (PUNJAB) PUNE/STATE RESEARCH
 USE OR DISCLOSE IN WHOLE OR
 IN PART SHALL NOT BE MADE
 WITHOUT THE WRITTEN PERMISSION
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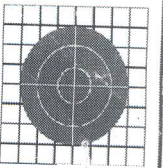


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 दिनांक 24-04-2018

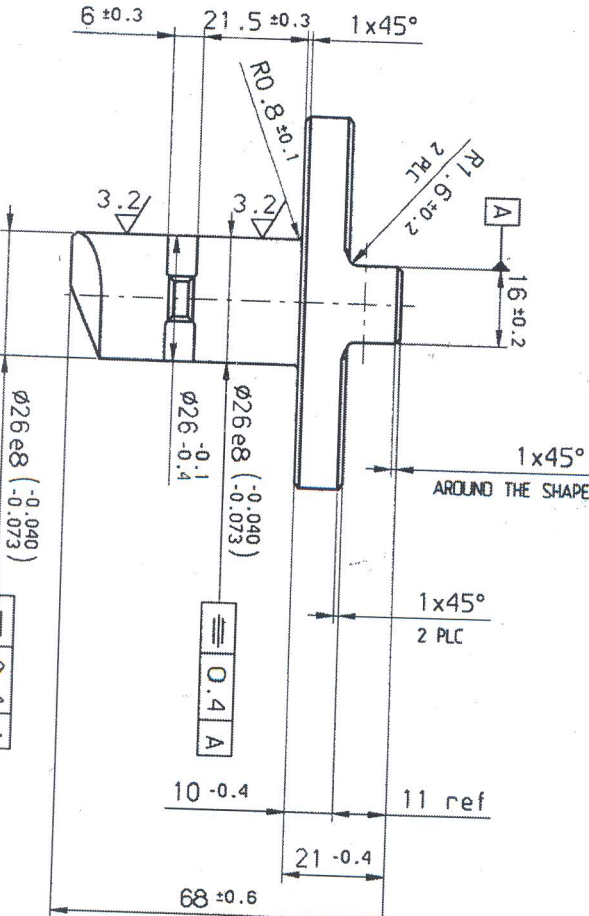
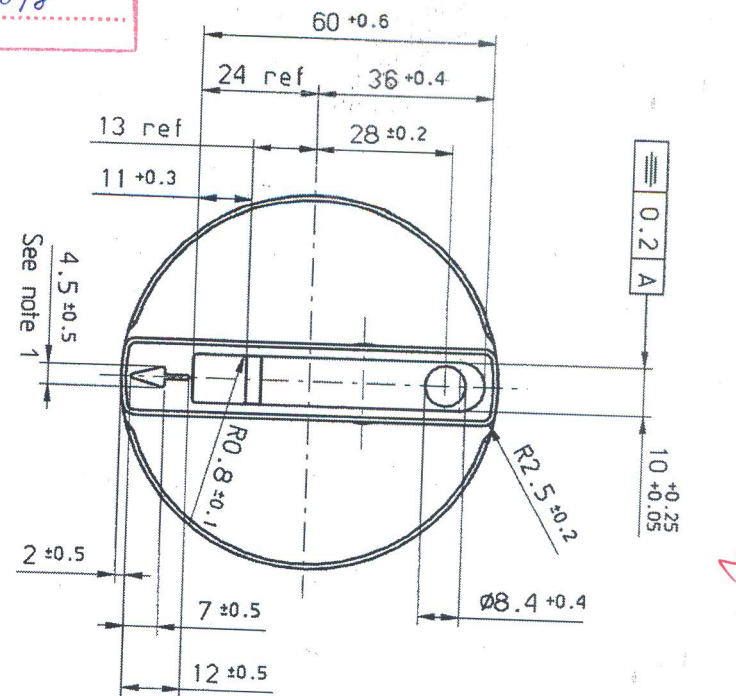
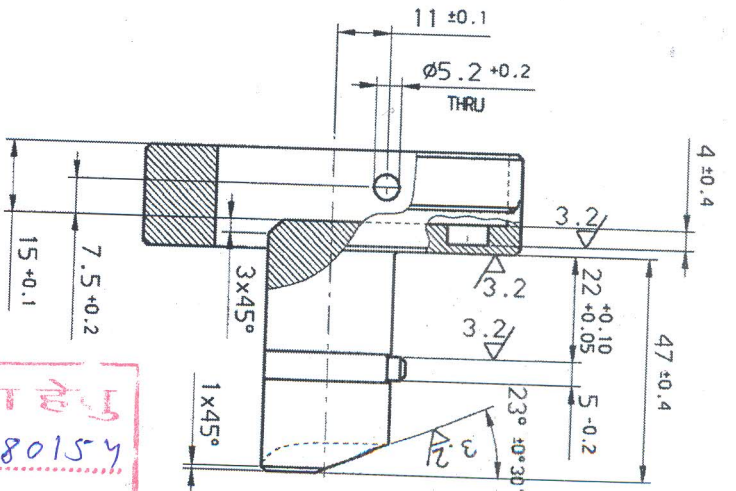
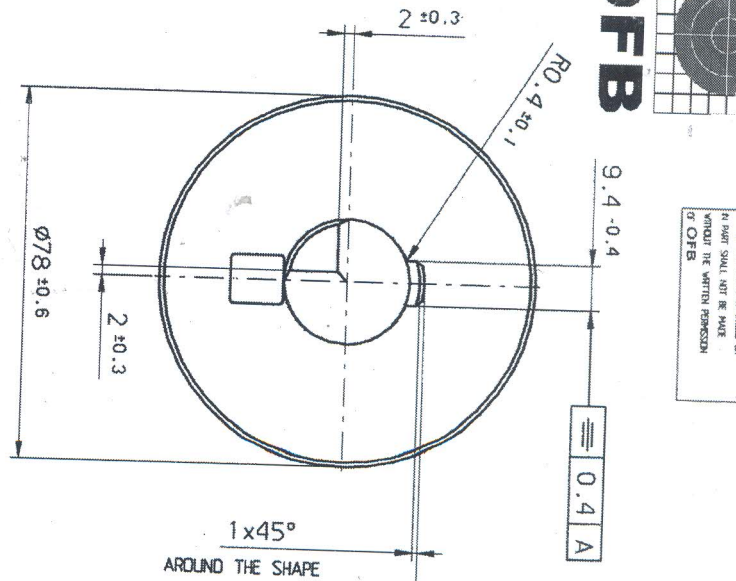
1

MACHINING INSTRUCTIONS UNSPECIFIED TOLERANCES FOR DIMENSIONS AND ANGLES DIMENSIONS		I.D. No. 1921 Location. 01/04/01		18912-W DR. 27-5-2005 COA (W), JABALPUR	
HEAT TREATMENT		PART NO. SHARANG 130/155MM. UG. OFB. SIB		DRAWING SEALED DO NOT WRITE	
FINISH		ASSEMBLY 176-1002		18912-W DR. 27-5-2005 COA (W), JABALPUR	
MATERIAL		NAME SAFETY CATCH - FIRING MECH. ASSY.		18912-W DR. 27-5-2005 COA (W), JABALPUR	
APPROVED		SCALE 1:1 A3		18912-W DR. 27-5-2005 COA (W), JABALPUR	
DEVELOPMENT CENTRE, OFC, KANPUR		PART NO. 161-483		18912-W DR. 27-5-2005 COA (W), JABALPUR	

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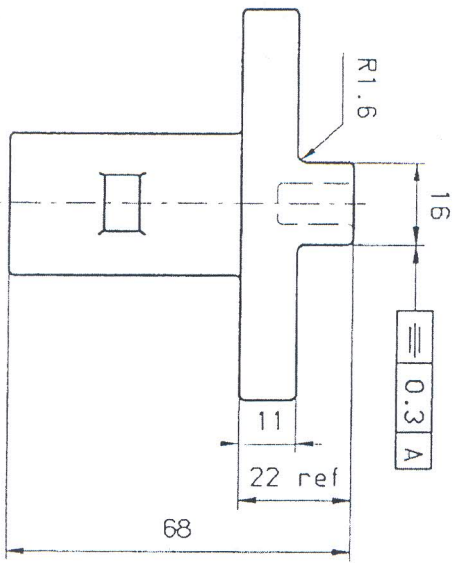
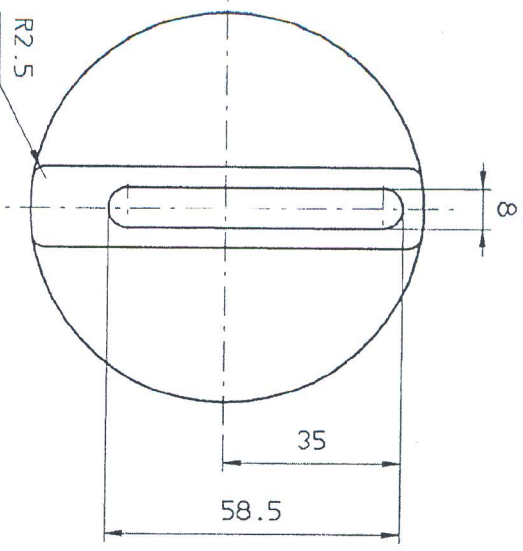
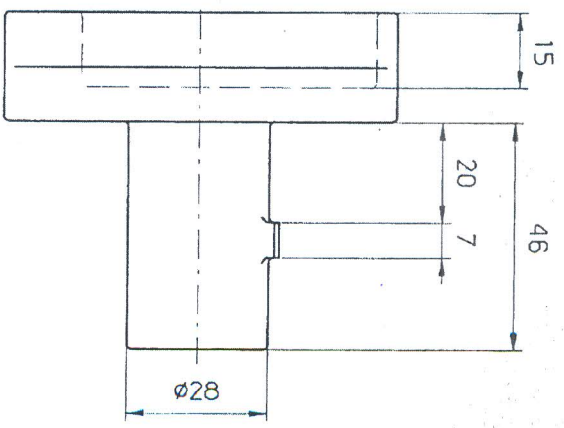
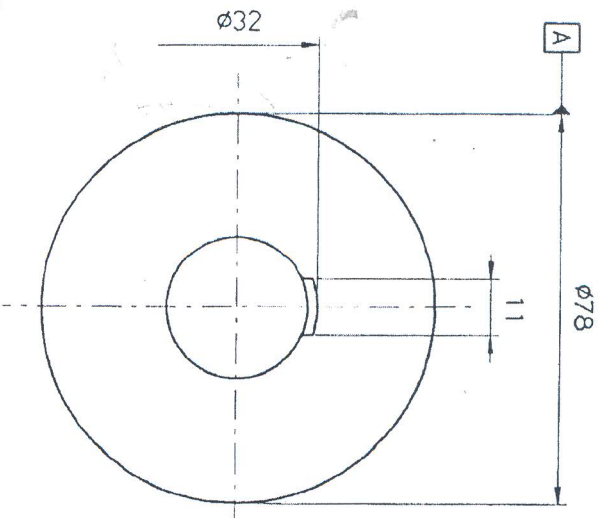
- NOTES:**
- 1 Engraved arrow: 1 mm depth, 0.5 mm width,
 - 2 Chamfered 0.5x45°

MATERIAL		HEAT TREATMENT		FINISH	
161-484-C		30-35 HRC		Phosphate coating in accordance with DDIP-8232 TYPE II cl. 2	
PART NO.		SHEET NO.		DATE	
SHARANG 130/155MM UG_OFB SUB		1 of 1		18/9/2018	
ASSEMBLY 161-483 (176-1002)		SCALE		DRAWING SEaled	
BODY-SAFETY CATCH		1:1		DRAWING SEaled	
NAME		APPROVED		DRAWING SEaled	
161-484-C		[Signature]		DRAWING SEaled	
DEVELOPMENT CENTRE		DATE		DRAWING SEaled	
161-484-C		01.01.2007		DRAWING SEaled	
COA (W), JABALPUR		DATE		DRAWING SEaled	
[Signature]		01.01.2007		DRAWING SEaled	
[Signature]		01.01.2007		DRAWING SEaled	

PART NO. 161-484

I.D. No. 1922

- NOTES:**
1. Casting according to spec. No 342 CLASS C
 2. Unspecified Radluses are R1



Dimensions without tolerances		
from	to	tol.
6	10	±0.10
10	14	±0.12
14	18	±0.15
18	24	±0.20
24	30	±0.25
30	40	±0.30
40	50	±0.37
50	65	±0.44
65	80	±0.52

MACHING INSTRUCTIONS
 UNSPECIFIED DIMENSIONS FOR DIMENSIONS AND ANGLES
 ANGLES ±30°

HEAT TREATMENT
 30-35 HRC

FINISH

MATERIAL
 LZ17MO4

380154
 24-04-2018

For Grade Only

ITEM	DESCRIPTION	CONDENENT	ADDT	STDE. EST. NO.	MATERIAL	TREATMENT	REMARKS
SCALE	M/T/S						
DESIGNED							
CHECKED							
DATE							
NAME							
SAFETY CATCH BODY							
CASTING							
DESIGN							
DATE							
NO.							
APPROVED							
DATE							
NO.							
161-484C							
FIELD EQUI. FACTORY							
KAMPUR							
APPROVED							
161-484C							
SHT. NO. 1							

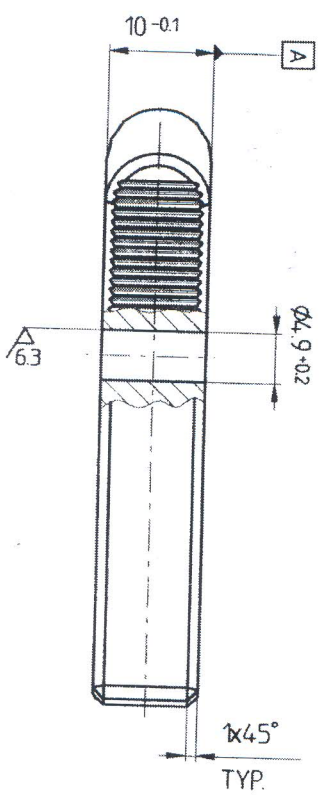
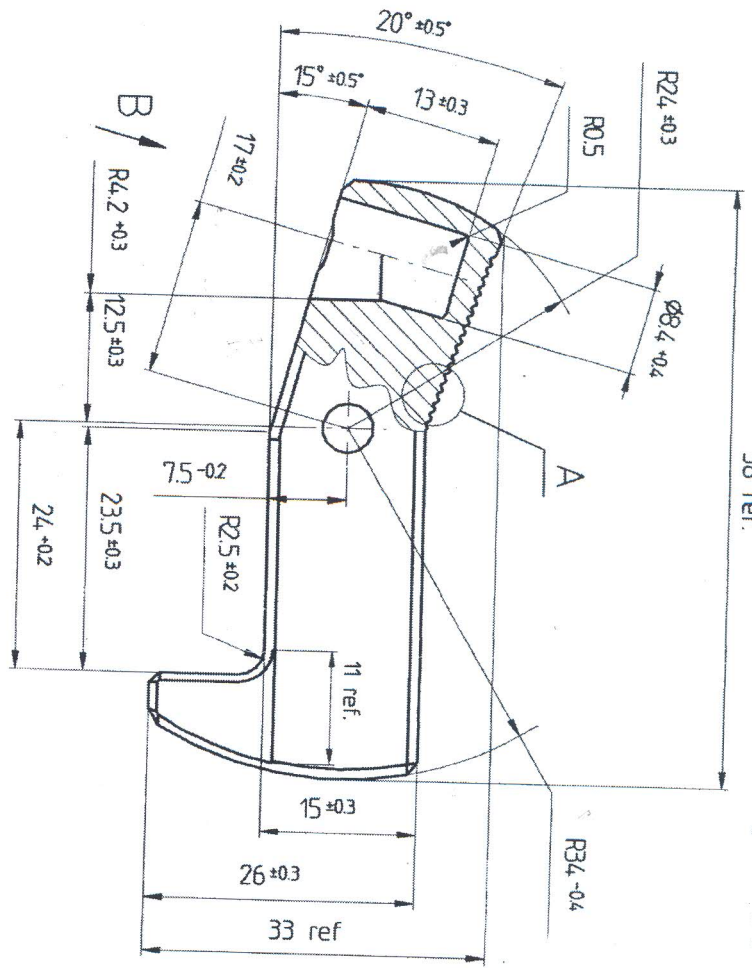


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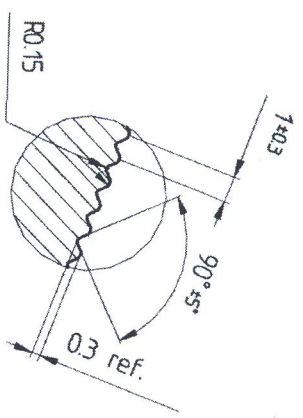
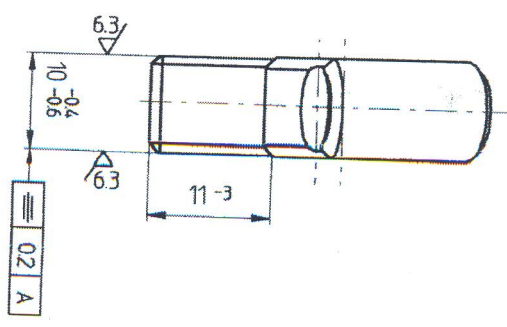
1 All other dimensions see casting drawing 161-485-C.

NOTES:



के.व. सिंघात देव
 38015-y
 24-04-2018

DATE:	01.01.2007	ALTERNATE/INDIGENOUS MATERIAL SPECN:	BS-3146-1974 CL-A-3 grade A The chemical composition shall be C% = 0.38-0.45, Si% = 0.40 (max), S% = 0.035 (max), P% = 0.035 (max), Cr% = 0.90-1.20 Mn% = 0.15-0.30 (REF. COA (V) JABALPUR LNO. 382402/COA/W/011 Dn. 12 HELY 2003)
DATE:	18/9/2005	DRAWING SEALED BY:	DO (CA/W)
DATE:	27-5-2005	DRAWING SEALED BY:	DO (CA/W)



DETAIL A

VIEW B

I.D. No. 1924
 Location: 01/04/01...

SCALE: 5:1
 DRAWING SEALED BY: DO (CA/W)
 CQA (W), JABALPUR

32 (63)
 MACHINING INSTRUCTIONS
 UNSPECIFIED TOLERANCES FOR DIMENSIONS AND ANGLES
 ANGLES
 HEAT TREATMENT

SHARANG 130/155MM JG OFB SLB

161-483 176-1157 (176-1002)
 ASSSEMBLY 161-681 (176-8001)

1 of 1
 A3

PHOSPHATE COATING ACCORDING TO DDD-P-6232 THE H CL 2
 MATERIAL 161-485-C

NAME PLUNGER

PART NO. 161-485

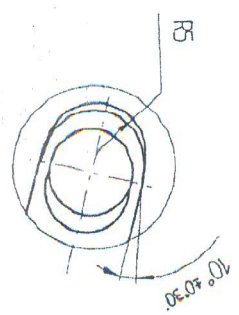
APPROVED	DATE	BY
DO (CA/W)	18/9/05	DO (CA/W)
DO (CA/W)	27/5/05	DO (CA/W)

DEVELOPMENT CENTRE, ORDNANCE ENG. KANPUR

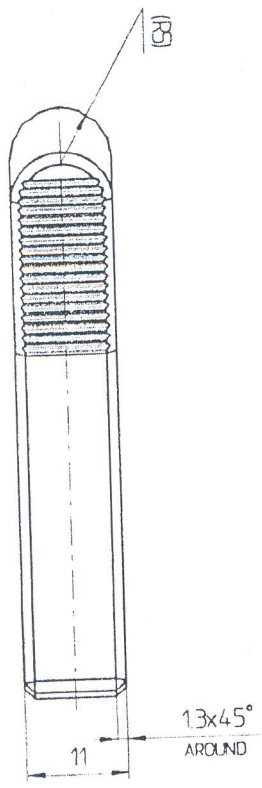
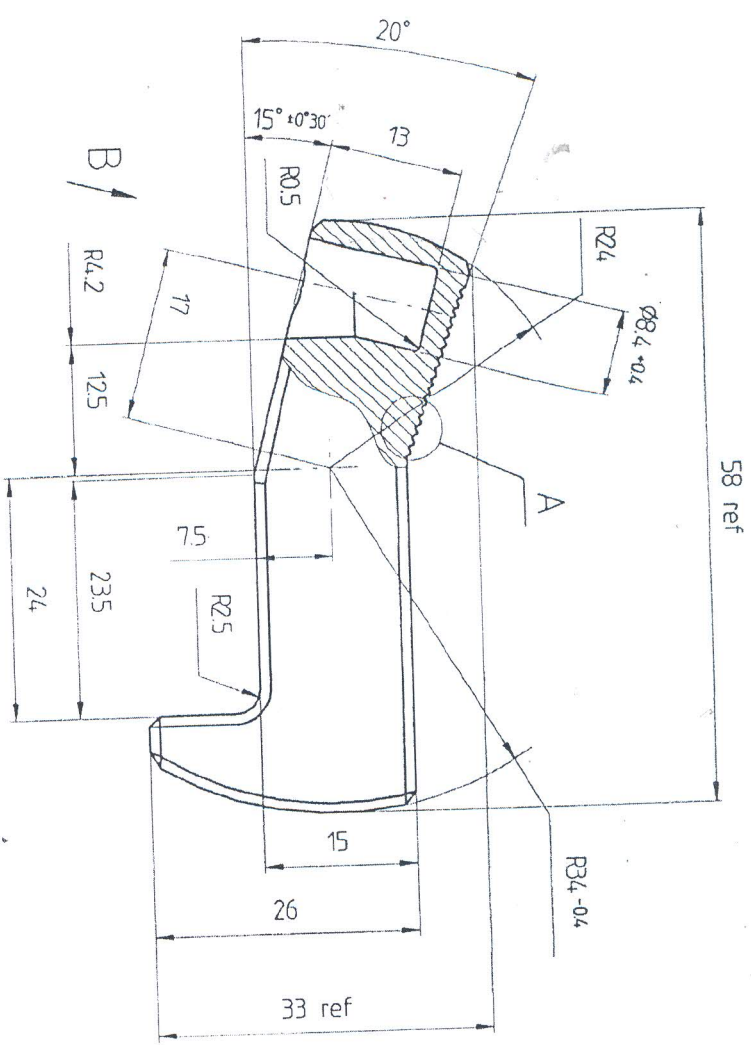
3A

NOTES:

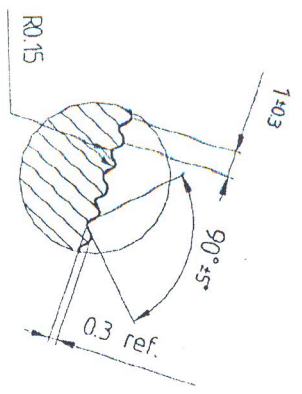
1. ACCORDING TO SPEC. No. 342 CL. D
2. Round edges R0.3 to R0.5



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VIEW B



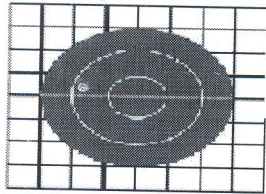
DETAIL A
SCALE 5:1

Dimensions without tolerances		
from	to	tol.
6	10	± 0.10
6	10	± 0.12
10	14	± 0.15
14	18	± 0.20
18	24	± 0.25
24	30	± 0.30
30	40	± 0.37

for frede Only

MAKING INSTRUCTIONS
UNSPECIFIED TOLERANCES FOR DIMENSIONS AND ANGLES DIMENSIONS
ANGLES 130°
HEAT TREATMENT NORMALIZED
FINISH
MATERIAL PRECISION CASTING 42CrMo4

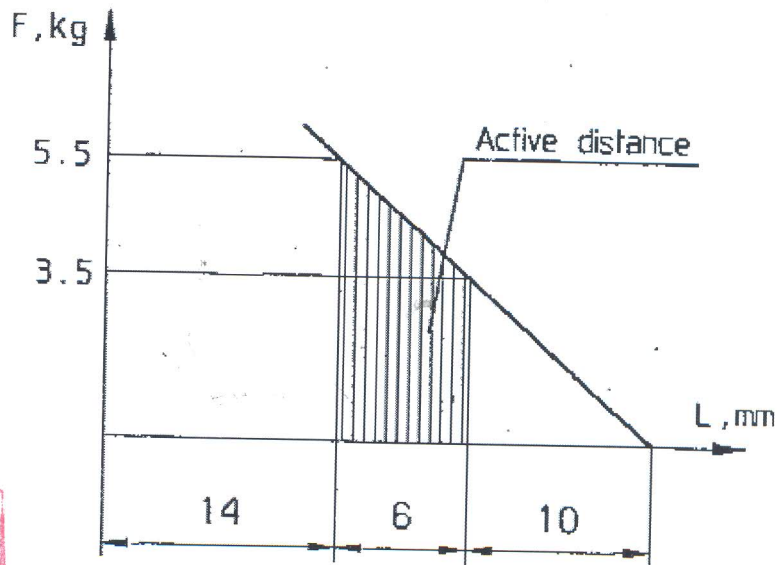
ITEM	DESCRIPTION	COMPONENT	QTY	STOR. DEPT. NO.	MATERIAL	TREATMENT	REMARKS
SCALE	NTS			161-485-C	FIELD EUN FACTORY KANPUR		
UNSPECIFIED TOLERANCES IS: 2112 (PER ISO 2018)							
DATE NAME							
2018							
CHD.							
TOL.							
DATE							
APPROVED							
PLUNGER-CASTING							
FIG. NO. 161-485-C							
SHT. NO. 1							



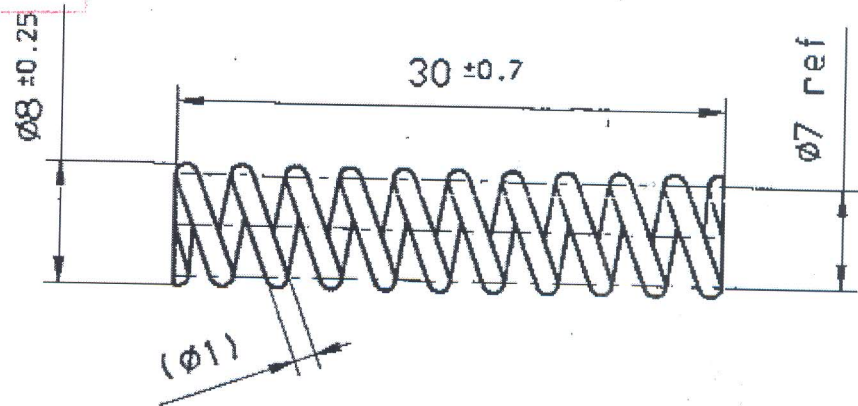
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 दिनांक 24-04-2018



RIGHTHANDED: LEFTHANDED:
 NUMBER OF COILS: 9+1.5
 FORM OF ENDS: BENT: GROUND:
 PRECISION GRADE: DIN 2095 1 2 3
 PLATING: Zinc plating acc. to ASTM B633 TYPE II SC1

ID. No. 2010
 Location 01/04/02

18909-W DRAWING SEALED
 Dt. 04-05-2005 DO/DO
 CQA (W), JABALPUR

MACHINING INSTRUCTIONS
 UNSPECIFIED TOLERANCES
 FOR DIMENSIONS AND ANGLES
 DIMENSIONS
 ANGLES
 HEAT TREATMENT
 FINISH
 MATERIAL
 Wire DIN 2076-B-1

SHARANG 130/155MM_UG_OFB_SLB
 PART NO
 161-483, 161-489 (176-1002)
 ASSEMBLY 176-2000; 161-681 (176-8001)
 NAME
 SPRING

UPDATED
 Sht. of:
 A4
 SCALE
 PREP'D
 GHD
 JWM/DO
 APPROVED
 DO/DO DIR/ODG
 ORDNANCE
 DEVELOPMENT CENTRE,
 OFC, KANPUR
 PART NO.
 161-486