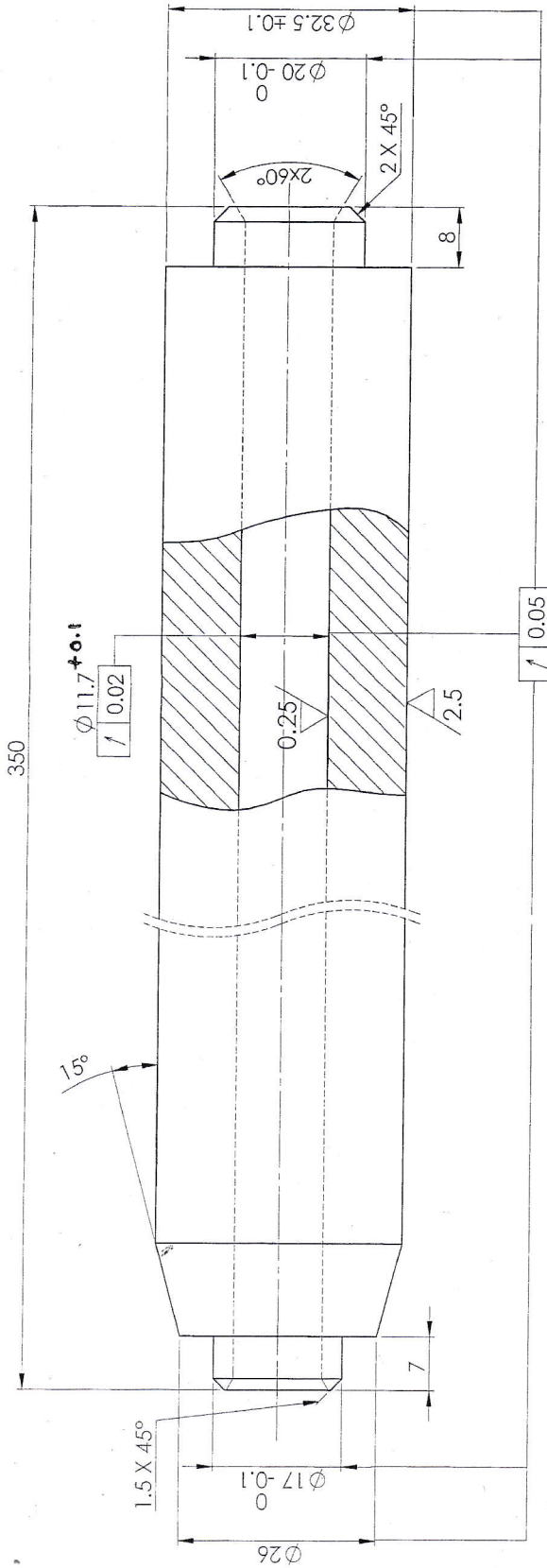


BEFORE COLD SWAGING WITH CHAMBER

RAW MATERIAL :- $\phi 34 \times 350 \pm 3$



MATERIAL :-

STEEL TO JSS 9510-06-2012 CODE REF 'B'

MACRO-ETCH NON METALLIC INCLUSION RATING TEST AND DETERMINATION OF NON METALLIC INCLUSION IN STEEL AS PER COLUMN (a) OR (b) OF CQA(SA) NOTE SHEET No.1. $\Sigma S+P < 0.022 \%$

ALT.MATL :-

BS:970 PI-11983 Gr.708M40 'T' CONDITION

The Steel should be produced by secondary refining route.
The following restriction S&P contents should apply for both
The above specification. S = 0.015 max. P = 0.015 max. S&P combined 0.022 max.

0.010

HARDNESS :- 248-302 HB
BLUNT SHARP EDGES 0.4mm

STRAIGHTNESS OF BORE :-

A PLUG GAUGE OF 150mm LONG 0.015mm LESS THAN THE ACTUAL BORE SIZE SHOULD PASS THROUGH WHEN THE BARREL IS PLACED VERTICALLY.

DRILLING FROM ONE SIDE ONLY.

THERE SHOULD NOT BE ANY MARKS INSIDE THE BORE.

Material:	DWG Details	SIGN	DATE	SUB: BEFORE COLD SWAGING BLANK WITH CHAMBER	
				FOR: BARREL	
Alt. Material:	CHECKED	V. Eshu		PRGJ.: TRICHY ASSAULT RIFLE	Do not scale Drawing
Hardness:	HOS/D&DO	K. F.		Design Ref TEND 2226*2	All Dimensions are in mm
Finish:	DO/Prodn			DWG. - TEND 2689 *	A3 QPG -
Un tolerated dimensions IS:2102 Medium	DO/QC			No.:	WT. (Appx) gm
APPROVED ON: 29/01/2022	DO/DDO				SHEET: 1 OF 1

11.9
THIRUPATI
HOS/PS-4

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CERTIFIED CORRECT COPY
DESIGN & DRAWING OFFICE
ORGANANCE FACTORY, TIRUCHIRAPPALLI-620010
DRAWINGS AT THIS DATE: 06/06/22
DA-NO. 020/23
DS/06/2023
APPROVED DATE