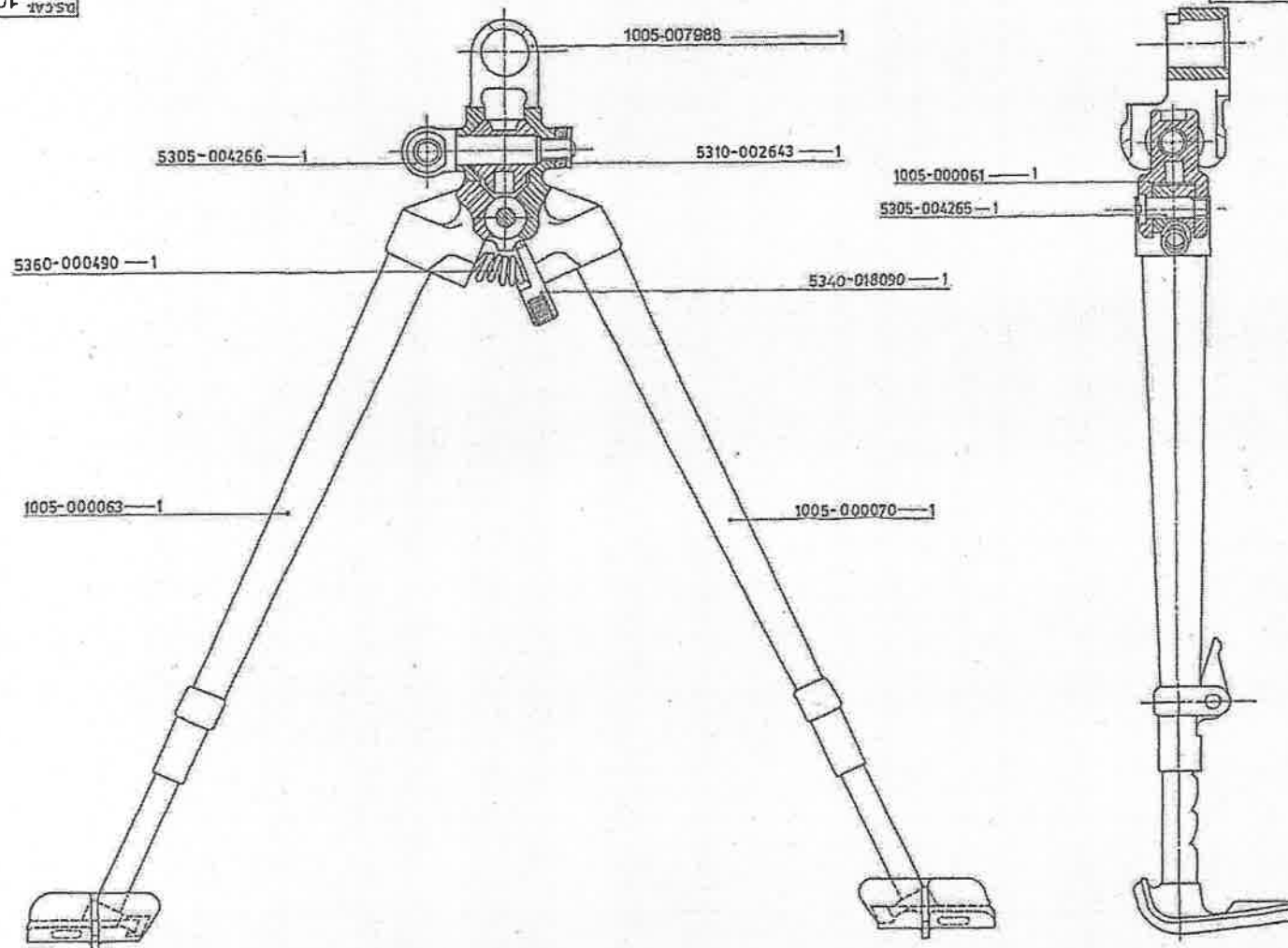


1005-557897

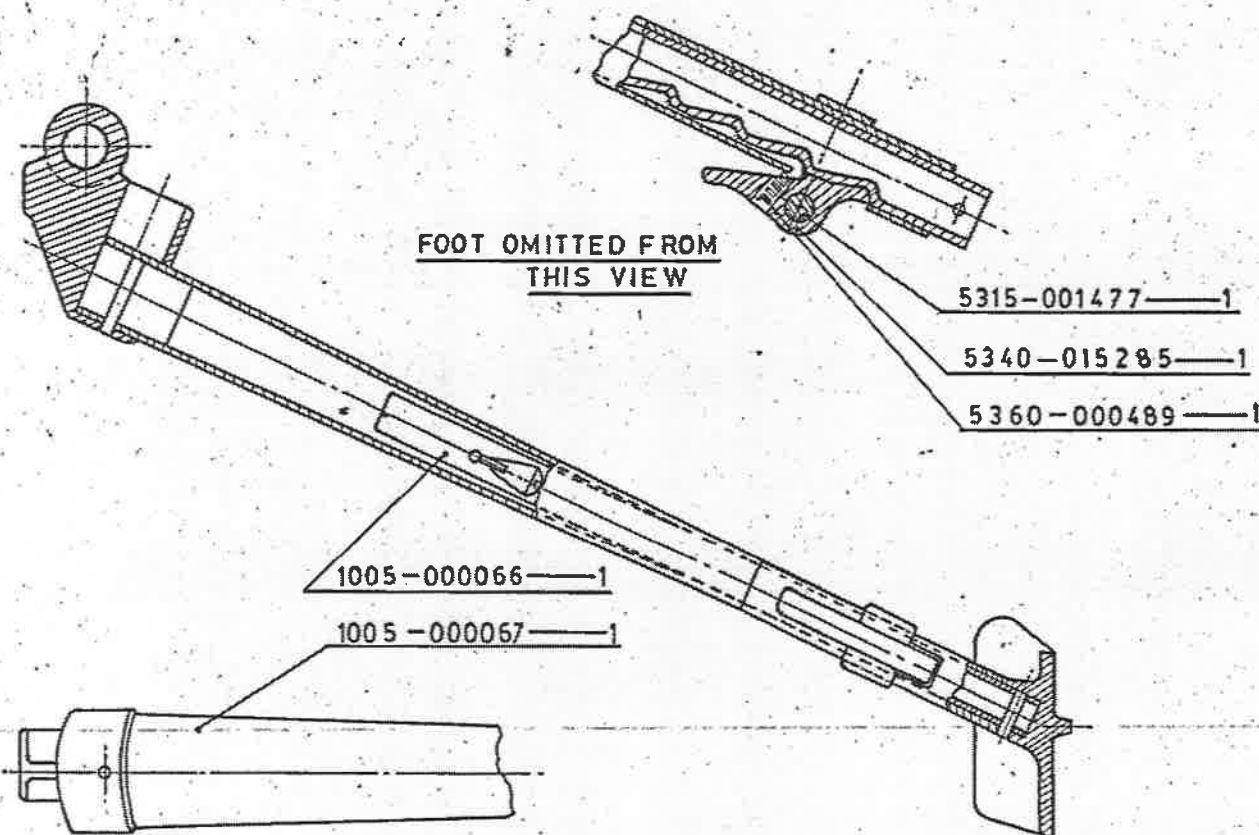
DRAWING CONVENTIONS CONFORM TO JSS-0104
DIMNS. ARE IN mm. (GEN. TOL. MEDIUM 15:2102)



DT. 01-11-08				DRN. <i>Handwritten</i>	CHKD. <i>Handwritten</i>	TRD.	COMP.	ANSP.	CQA(SA) TCHAPUR
SCALE: 1:1				EST. MASS.		APPROVED		ASSY.	1005-557868
DT. 17-11-08				I/C.D.O.		DT. 17-11-08		JTO	FOR COORD.
MATERIAL				NT/HARDNESS		DGNR'S REF.		ARDE SK-3145/75	
DATE AUTH.				BRIEF RECORD		ZONE I/C.D.O. GO.		PART No.	
SEALED > PROV SEALED DC No. 26429-SA DT. 17-11-08				SIGN		PROTECTIVE FINISH		DSCAT. No.	
NOMENCLATURE >				BIPOD ASSY. (FOR GM 5.56 mm 1A1)		ALL COMPONENTS TO BE PHOSPHATED TO SPECIAL JSS-0465-01-1994 CLASS II (ACCELERATED) OIL FINISH BEFORE ASSEMBLY.		JSSCAT. No.	
								1005-557897	

NO. 1005-000063
D.S.CAT.

DIMNS. ARE IN mm.



FOOT OMITTED FROM
THIS VIEW

5315-001477—1

5340-015285—1

5360-000489—1

1005-000066—1

1005-000067—1

METRIC

DRN.		CHD.		TRD. <i>88</i>		COMP. <i>H. H. H.</i>		AHSP, CQA(SA), ICHAPUR	
SCALE:— 1:1				EST. MASS:—				ASSY.	
DT. 07.7.2003.		<i>K. H. H.</i> I/C: D.O.		APPROVED, DT. 9.11.67.				P3/17694/S/30	
07.7.2003.		25793-SA		PROFORMA CHANGED, NEG. RE-TRACED & DRG. RE-SEALED.		<i>K. H. H.</i> C.D. D.O.		DGNR'S REF.	
				PREVIOUS D.C. NOS. 15105-SA, 17015-SA & 23359-SA		COPY. COPY.		PART. NO.	
DATE		AUTHY.		BRIEF RECORD		ZONE		DRG. NO.	
SEALED: D.C. No. 15105-SA. DT. 13.4.77.						SIGN.		D.S.CAT. NO. 1005-000063	
NOMENCLATURE:—				LEG, LEFT, MK.1.					
				PROTECTIVE FINISH:—					

990000-5001
D.S.CAT

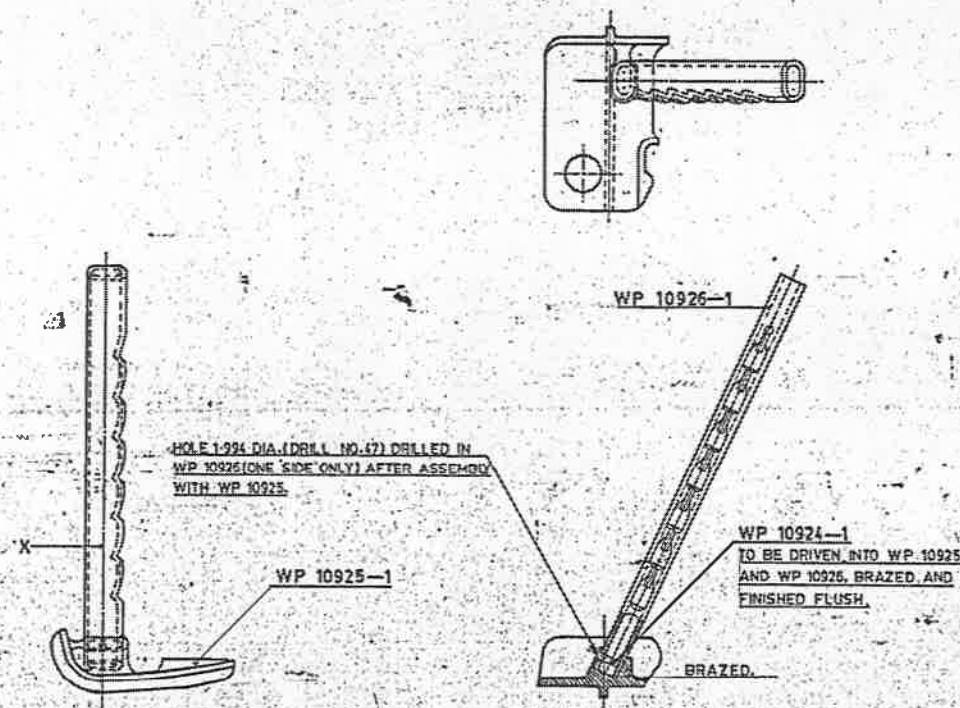
DIMNS. ARE IN mm

HEAT TREATMENT:-

TO BE COPPER BRAZED TO SHOE AND CARBURISED
TO A DEPTH OF 0.127 TO 0.254 AFTER ASSEMBLY.
HARDENED AND TEMPERED TO A H.V. OF 400 MN.
MEASURED AT POINT "X"

ALTERNATIVE HARDNESS NUMBER:-

57 HRD. MN.

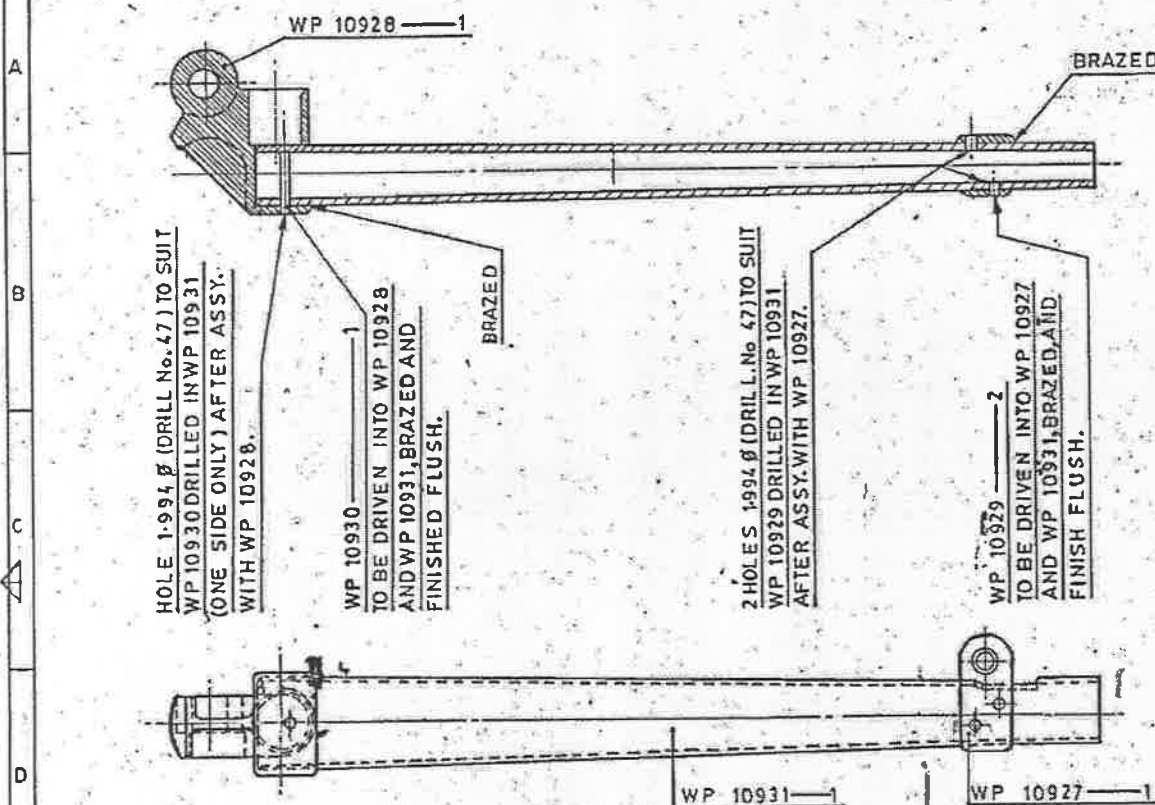


METRIC

DRN.	CHO.	TRD.	COMP. H.R.D.	AHSR CQA(SA), ICHAPUR
SCALE:- 1:1		EST. MASS:-	APPROVED. DT. 9.11.67	ASSY.
DT. 22-10-2002	V.C: D.O.		NEG. RE-TRACED	
22-10-02 25563-34	PROFORMA CHANGED, PROTECTIVE FINISH AMENDED, NEG. RE-TRACED AND DRG. RE-SEALED.			
	PREVIOUS D.C. NOS. 15238-SA, 16164-SA, 22011-SA & 23141-SA.			
DATE AUTHY.	BRIEF RECORD.	ZONE	V.C: D.O. 6.0.	DGNR'S REF. P3/17695/30
SEALED:- D.C. NO. 15238-SA, DT. 5.8.77			SIGN.	PART NO.
NOMENCLATURE:-	LEG		H.T./HARDNESS:- AS STATED	DRG. NO.
			PROTECTIVE PHOSPHATE TO SPECN. JSS 0465-01:1994	D.S.CAT. NO. 1005-000066
			FINISH:- CLASS-I OIL FINISH.	

190000-5001 ON
D.S.CAT. 1005-000067

DIMNS. ARE IN mm.

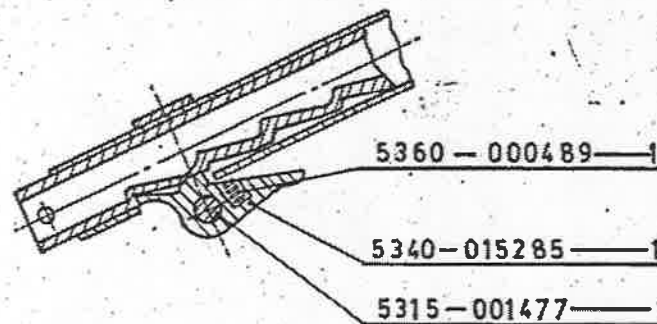


METRIC

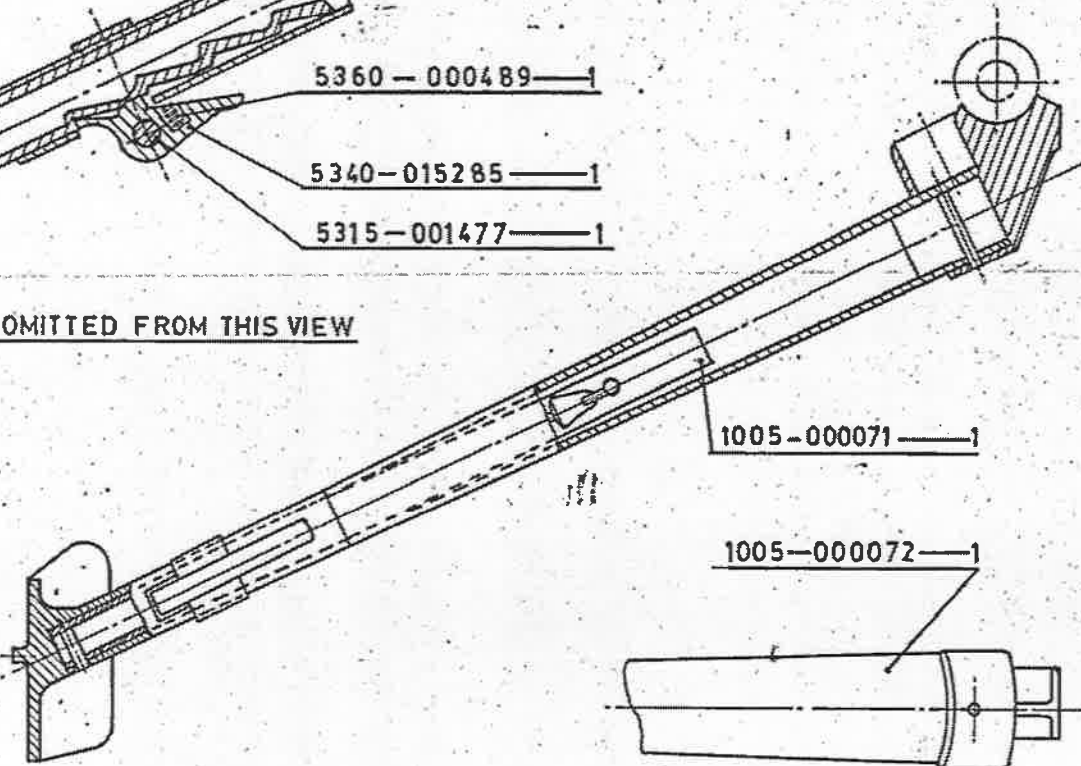
7-7-2003 25792-SA		PROFORMA CHANGED, NEG. RE-TRACED & DRG. RE-SEALED		DGN. CHD. TRD. <i>AC</i> COMP. <i>Handwritten</i>		AHSP. CQA(SA); ICHAPUR	
DATE		AUTHY.		SCALE: NOT TO SCALE		EST. MASS: -	
7-7-2003		25792-SA		DT. 7-7-2003		APPROVED. DT. 9.11.67.	
SEALD: D.C. NO. 15238-SA DT. 5.8.77.		BRIEF RECORD		SIGN.		(NEG. RE-TRACED)	
NOMENCLATURE: -		LEG		MATERIL: -		ASSY.	
PREVIOUS D.C. No. 15238-SA		ZONE		H.T/HARDNESS: -		DGNRS REF. P3/17696/30	
DATE		AUTHY.		PROTECTIVE FINISH: -		PART NO. :	
7-7-2003		25792-SA		SPECN.C/1719 PHOSPHATE 505.		DRG. NO.	
7-7-2003		25792-SA		SIGN.		D.S.CAT. NO. 1005-000067	

010000-5001
D.S. CAT. 1005-000070

DIMNS. ARE IN mm.



FOOT OMITTED FROM THIS VIEW



METRIC

07.7.2003.		25793-	PROFORMA CHANGED, NEG. RE-TRACED & ORG. RE-SEALED			DRN. ICHD.	TRD. <i>AE</i>	COMP. <i>Amman</i>	AHSP CQA(SA), ICHAPUR
			PREVIOUS D.C. NoS. 15105-SA, 17014-SA & 23350-SA.			SCALE: 1:1	EST. MASS: —		ASSY.
						DI. 07.7.2003.	APPROVED. DT. 9.11.67.		
							(NEG. RE-TRACED)		
DATE		AUTHY.	BRIEF RECORD	ZONE	I/C: DQ	G.O.	MATERIAL: —		DGNR'S REF. P3/17697/S/30
SEALED: —		D.C. No. 15105-SA, DT. 13.4.77.		SIGN.		H.T./HARDNESS: —		PART NO.	
NOMENCLATURE: —		LEG. RIGHT, MK.1.				PROTECTIVE FINISH: —		ORG. NO.	
								D.S. CAT. NO. 1005-000070	

120000-5001
D.S.CAT 1005-000071

DIMNS. ARE IN mm.

WP 10926-1

WP 10924-1 TO BE DRIVEN INTO
WP 10932 AND WP 10926, BRAZED
AND FINISHED FLUSH.

HOLE 1.994 DIA. (DRILL No. 47)
DRILLED IN WP 10926 (ONE SIDE
ONLY) AFTER ASSEMBLY WITH
WP 10932.

BRAZED

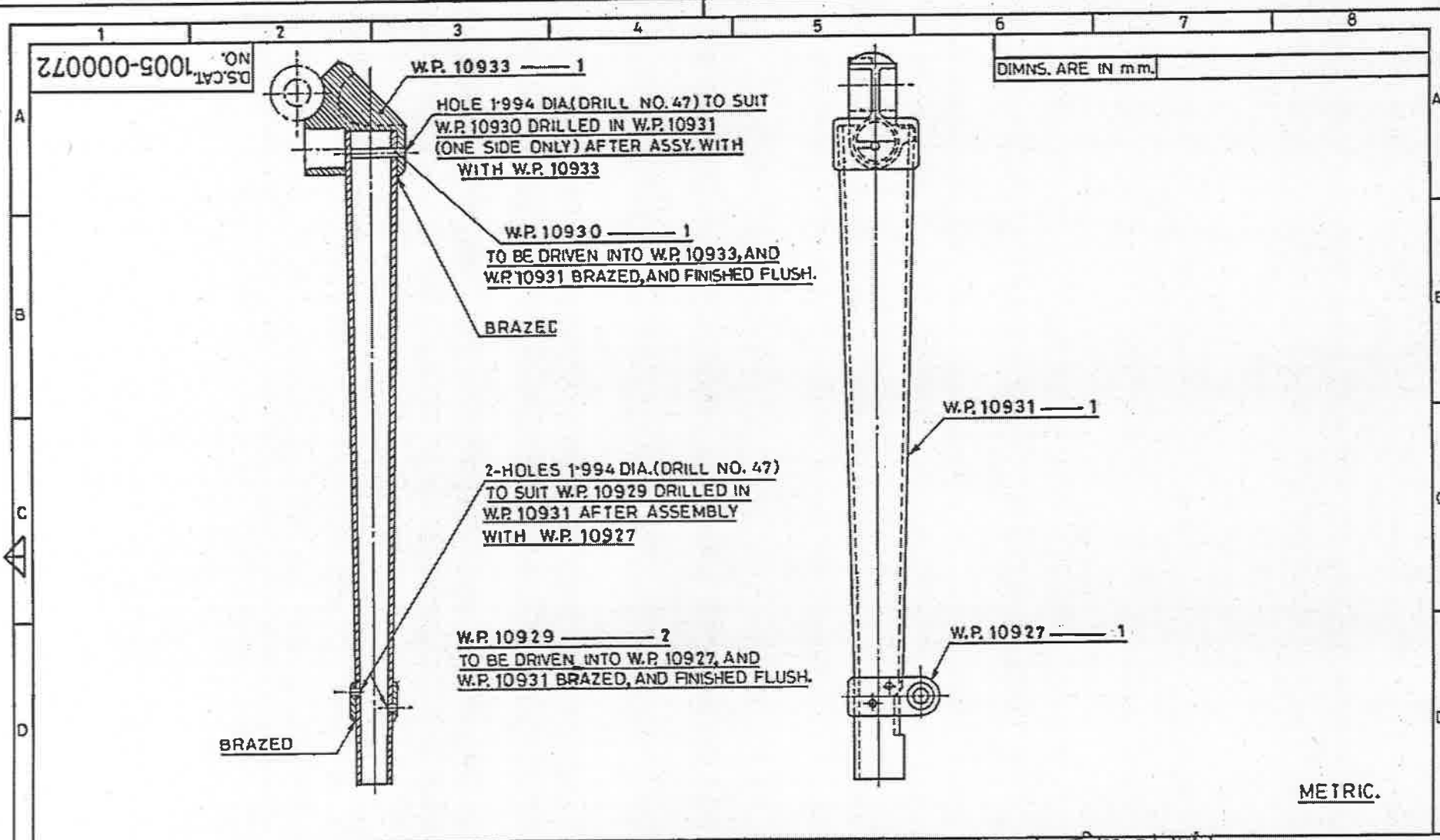
WP 10932-1

HEAT TREATMENT:-

TO BE COPPER BRAZED TO SHOE AND CARBURISED
TO A DEPTH OF 0.127 TO 0.254 AFTER ASSEMBLY.
HARDENED AND TEMPERED TO A H.V. OF 400 MIN.
MEASURED AT POINT 'X'.
ALTERNATIVE HARDNESS NUMBER 57 HRC MIN.

METRIC

19-6-99		24405-SA	PROFORMA CHANGED, NEG. RE-TRACED AND ORG. RE-SEALED	DRN. CHD. TRD. <i>Handa</i> COMP. <i>Handa</i>		AHSP. CQA(SA), ICHAPUR	
DATE AUTHY.		BRIEF RECORD		SCALE:- 1:1		EST. MASS.	
SEALED:- D.C. 15105-SA, DT. 13.6.77		PREVIOUS D.C. NOS. 15103-SA, 16305-SA, 20311-SA, 22009-SA, 22421-SA & 22707-SA.		DT. 19-6-99 <i>Anil</i> VC, D.O.		APPROVED. DT. 9.11.67 NEG. RE-TRACED	
NOMENCLATURE:-		LEG		MATERIAL:-		ASSY. 1005-000070	
ZONE		I/C, D.O. G.O. SIGN.		H.T./HARDNESS:-		DGNR'S REF. P3/17698/30	
PROTECTIVE PHOSPHATE TO SPECN. JSS:0465-01:1988		FINISH:- CLASS 1, OIL FINISH.		DRG. NO.		D.S.CAT. NO. 1005-000071	



09.01.2003.		25653-SA	PROFORMA CHANGED, NEG. RE-TRACED AND DRG. RE-SEALED.	DATE	AUTHY.	BRIEF RECORD.	ZONE	I/C, D.O.	G.O.	DATE	SCALE:- 1:1	TRD.	CHD.	TRD.	COMP.	AHSP CQA(SA), ICHAPUR	
			PREVIOUS DC NO 15104-SA					COPY	COPY		DI. 09. 01. 2003.	I/C, D.O.	NEG. RE-TRACED.	EST. MASS:-	APPROVED.	DT. 9. 11. 67.	ASSY.
																	OGNR'S REF. P3/17699/30
																	PART NO.
																	DRG. NO.
																	D.S.CAT. NO. 1005-000072

NOMENCLATURE:- **LEG.**

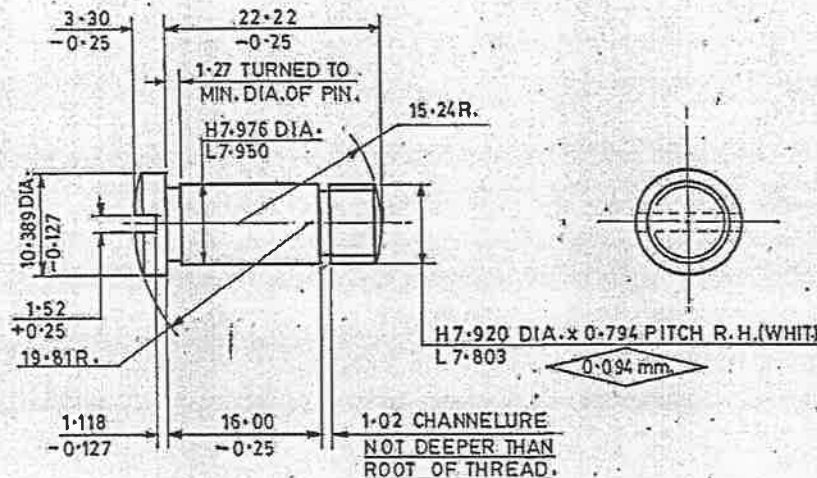
5305-004265 D.S. CAT. ON

FOR EXPLANATION SEE D.D. NOTE SHEET E & 10.
DIMNS. ARE IN mm.

TOLERANCE FOR UNTOLERANCED DIMENSIONS ± 0.13 .

HEAT TREATMENT :-

CASE CARBURISED TO A DEPTH OF 0.30mm. MIN.
HARDENED TO GIVE MICRO-HARDNESS OF 500 HV. MIN.

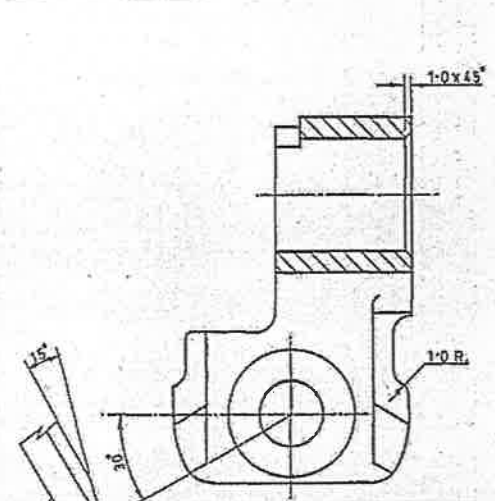


METRIC

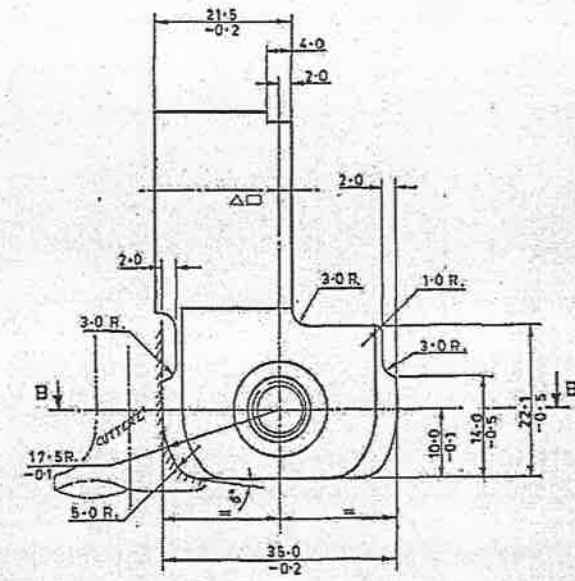
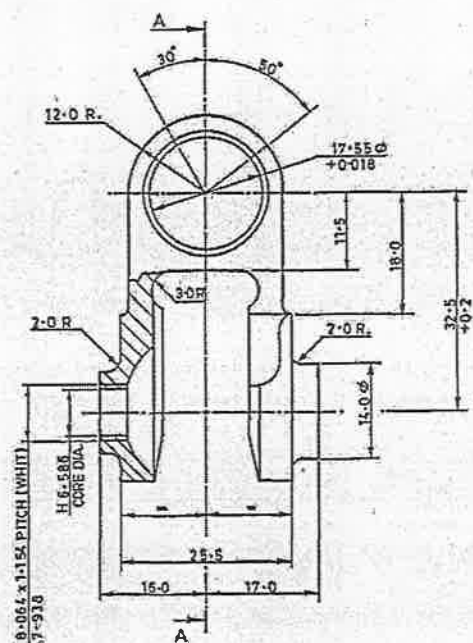
28.09.16		26951-SA	MATERIAL AMENDED.	APPROVED	DRN.	CHD.	TRD. <i>SK</i>	COMP. <i>APPROVED</i>	AHSP, CQA(SA), ICHAPUR	
4-7-2003		25791-SA	PROFORMA CHANGED, ACTUAL SIZE VIEW DELETED, PROTECTIVE FINISH AMENDED, NEG. RE-TRACED AND DRG. RE-SEALED	CD	SCALE :- 2:1	EST. MASS :-	APPROVED, DT. 9.11.67.	(NEG. RE-TRACED)	ASSY.	
			PREVIOUS D.C. NOS. 15147-SA, 15486-SA, 16353-SA, 19515-SA, 22233-SA, 22488-SA AND 23512-SA.	COPY	DT. 4-7-2003	I/C:D.O.	MATERIAL :- IS: 4432-1988, STEEL DESIGNATION 10C4		DGMR'S REF. M.G.DET.NO.1337	
DATE	AUTHY.	BRIEF RECORD		ZONE	I/C:D.O.	G.O.	H.T/HARDNESS:- AS STATED		PART NO.	
SEALED :-		D.C.NO. 15147-SA, DT.18.5.77.		SIGN.		PROTECTIVE FINISH :-		DRG. NO.	D.S. CAT. NO. 5305-004265	
NOMENCLATURE :- SCREW, BRACKET, BIPOD.					PHOSPHATE TO SPECN. JSS 0465-01:1994 CLASS-II (ACCELERATED), OIL FINISH.					

886700-007988

DRG. CONVENTIONS CONFORM TO JSS.0104.
DIMNS. ARE IN mm. GEN. TOL. MEDIUM 1S: 210Z.



SECTION 'A-A'

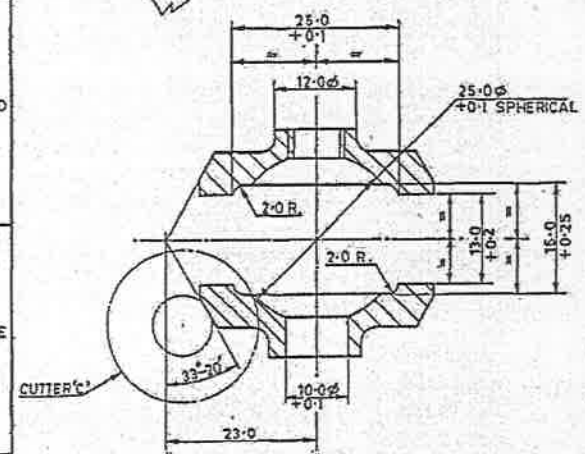


NOTES:-

- REMOVE ALL SHARP EDGES AND BURRS.
- TOLERANCE FOR ANGLES $\pm 30'$.
- CASE HARDENED TO A DEPTH OF 0.2 TO 0.5.

MARKING NOTE:-

- TO BE MARKED ON COMPONENT BY STAMPING IN 2mm LETTER SIZE
- △ MANUFACTURER'S CODE
- Yr. of Mfg.



SECTION 'B-B'

DRN. <i>Am</i> ICHD. <i>Am</i> TRO. <i>Am</i> COMP. <i>Am</i>		AHSP CQA(SA), ICHAPUR	
SCALE: 2:1		EST. MASS: APPROVED	
DATE 17-11-08		JTO FOR (SACAL)	
22.11.16 26974-SA	MATERIAL AMENDED:-	ASSY. 1005-557897	
17-11-08 26430-SA	DRG. SEALED PROV.	DGR'S RE: ARDE SK.3145/43	
PREVIOUS DRG. NO. 25918-SA		PART NO.	
DATE AUTHY	BRIEF RECORD	DRG. NO.	
SEALED:- PROV SEALED DRG 26430-SA Dr. 17-11-08.		D.S. CAT. NO. 1005-007988	
SIGN.			
NOMENCLATURE:-			
HOUSING BIPOD			
MATERIAL:- IS: 4432-1988, DESIGNATION 13Ni13CrS.			
HT/HARDNESS:- 550 TO 600 H.V.			
PROTECTIVE PHOSPHATE TO SPECN. JSS-0465-01:1994			
FINISH:- CLASS II (ACCELERATED), OIL FINISH.			

992700-5305
D.S. CAT. NO. 5305-004266

FOR EXPLANATION SEE D.D. NOTE SHEET E & 10
DIMNS. ARE IN mm.

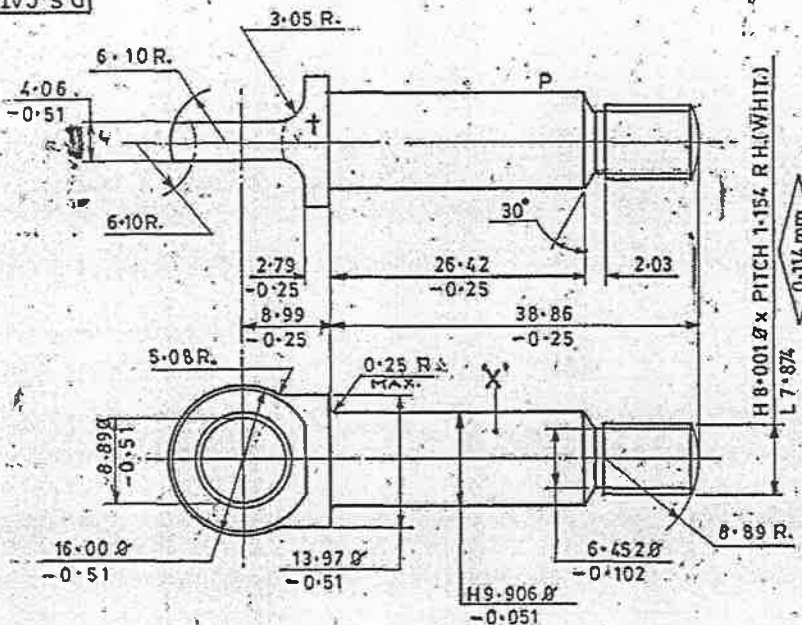
TOLERANCE FOR UNTOLERANCED DIMENSIONS ± 0.13
ANGLES GIVEN IN DEGREES ± 5 MINUTES.
ANGLES GIVEN IN DEGREES & MINUTES ± 2 MINUTES.

† MANUFACTURER'S CODE TO BE MARKED HERE.

HEAT TREATMENT :-

HARDENED AND TEMPERED TO 200-400 H.V.
MEASURED AT POINT 'X'.

ALTERNATIVE HARDNESS NUMBER-ROCKWELL
D38-57.

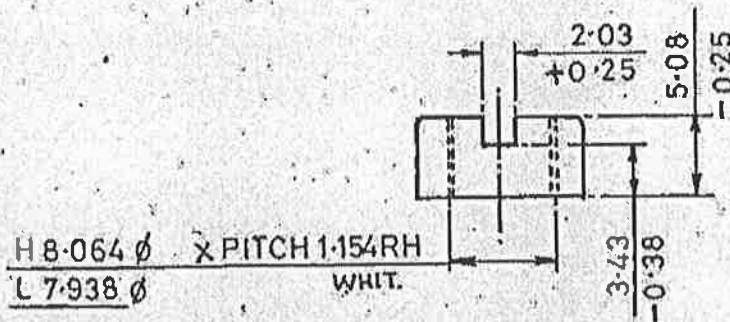


METRIC

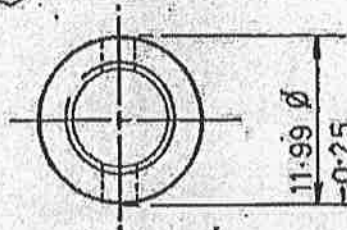
25.11.16	26977-SA	MATERIAL AMENDED.	DRN.	CHD.	TRD. <i>in Chd</i>	COMP. <i>in Comp</i>	AHSP.CQA(SA), ICHAPUR
11-7-2003	25797-SA	PROFORMA CHANGED, ACTUAL SIZE VIEW DELETED, PROTECTIVE FINISH AMENDED, NEGATIVE RE-TRACED AND DRAWING RE-SEALED.	SCALE :- 2:1		EST. MASS :-		ASSY.
		PREVIOUS D.C. NOS. 15145-SA, 15686-SA, 16353-SA, 19516-SA, 22233-SA, 22484-SA AND 23518-SA	DT. 11-7-2003	1/C; D.O.	APPROVED DT. 9.11.67.	(NEG RE-TRACED)	DGNR'S REF. MG: DET. NO. 1344
DATE	AUTHY.	BRIEF RECORD	COPY	COPY	MATERIAL :- IS: 4434-1988 DESIGNATION 15C8.		PART NO.
SEALED :-	D.C. NO. 15145-SA, DT. 18.5.77.		SIGN.		H.T./HARDNESS :- AS STATED		DRG. NO.
NOMENCLATURE :- SCREW; SLEEVE BIPOD.			PROTECTIVE PHOSPHATE: TO SPECN. JSS 0465:01-1994			D.S. CAT. 5305-004266	
			FINISH :- CLASS-II (ACCELERATED) OIL FINISH.			NO.	

5310-002643

ON DRAWING CONVENTIONS CONFORM TO JSG - 0104
DIMNS. ARE IN mm.



H8-064 ϕ X PITCH 1.154 RH
L 7.938 ϕ WHIT.
CORE ϕ H6-586- $\diamond$ 051



ACTUAL SIZE

METRIC

NOTE :-
FOR EXPLANATION OF DETAILS
WHEREVER NOT SPECIFIED REFER
D.D.NOTE SHEET N8 E (LATEST ISSUE)

TOLERANCE FOR UNTOLERANCED
DIMENSIONS $\pm .13$

28-09-16	26951-SA	MATERIAL AMENDED.		AKS	DT. 06-4-95	DT. 06-4-95	DT. 06-4-95
8-10-96	23518-SA	MATERIAL AMENDED.		AKS	DT. 06-4-95	DT. 06-4-95	DT. 06-4-95
6-4-95	22933-SA	NEG. RE-TRACED & ORG. RE-SEALED.		AKS	DT. 06-4-95	DT. 06-4-95	DT. 06-4-95
		PREVIOUS D.D. NOS. 15145-SA, 15664-SA, 15686-SA, 16353-SA, 19515-SA, 22136-SA, 22233-SA, 22491-SA.		AKS	DT. 06-4-95	DT. 06-4-95	DT. 06-4-95
DATE	AUTHY	BRIEF RECORD	ZONE	I/C, D.O.	G.O.	SIGN.	
SEALED.	DC(I) NO.	15145-SA.	DT.	18577			
DRN	CHD	TRD	COMP	ASSY.			
SCALE.	2:1 & 1:1	EST MASS.					
MFG/INSP INSTRUCTIONS							
DT. 06-4-95	APPROVED	FOR CQA(SA)					
MATERIAL	IS: 4432-1988 STEEL DESIGNATION	AHSP	CQA(SA), CHAPUR				
H.T./HARDNESS	SURFACE HARDENED TEMPERED AT 320°C FOR 10 MINUTES.	DGNR'S REF.	M.G. DET. NO. 1272				
PROTECTIVE FINISH.	PHOSPHATE TO SPECN. JSS. 0465-01; 1988 CLASS-I OIL FINISH.	PART NO.					
NOMENCLATURE	NUT, SCREW, BIPOD, SLEEVE	ORG. NO.					
		DS. CAT. NO.	5310-002643				

227100-61ES

ON FOR EXPLANATION SEE D.D. NOTE SHEET. NO.E & 10.
DIMNS. ARE IN mm.

TOLERANCE FOR UNTOLERANCED
DIMENSIONS ± 0.13 .

ANGLES GIVEN IN DEGREES ± 5 MINUTES

ANGLES GIVEN IN DEGREES & MINUTES ± 2
MINUTES.

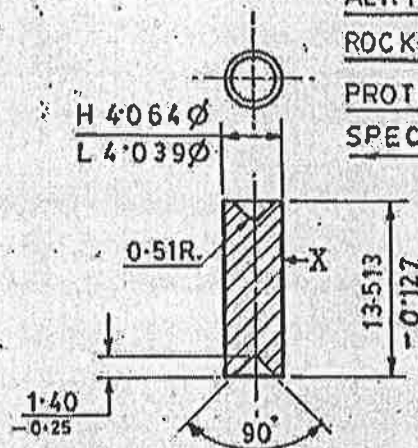
HEAT-TREATMENT: — HARDENED TO A
H.V. OF 300 MIN. MEASURED AT POINT 'X'.
ENDS TO BE SOFTENED.

ALT. HARDNESS NUMBER: —

ROCK-WELL D50 MIN.

PROTECTIVE FINISH: — PHOSPHATE TO
SPECN. JSS-0465-01-1994 CLASS II.
(ACCELERATED), OIL FINISH.

OR
LEFT AS FROM HEAT-TREATMENT.



METRIC

28-09-16	26951-SA	MATERIAL AMENDED.			
27.12.2002.	25634-SA	PROFORMA CHANGED, ACTUAL SIZE VIEW DELETED, PROTECTIVE FINISH AMENDED, NEG. RE-TRACED AND DRG. RE-SEALED.			
		PREVIOUS D.C. NOS 15145-SA, 15686-SA, 16219-SA, 19534-SA, 22482-SA & 23518-SA.			
DATE	AUTHY.	BRIEF RECORD	ZONE	I/C: D.O.	G.O.
SEALED: —	D.C. NO 15145-SA, DT. 18-5-77			SIGN.	

DRN.	CHD.	TRD.	COMP.	AHSP CQA(SA), ICHAPUR
SCALE: — 2:1		EST. MASS: —		
DT. 27.12.2002.	I/C: D.O.	APPROVED (NEG. RE-TRACED)	DT. 8-11-67	ASSY.

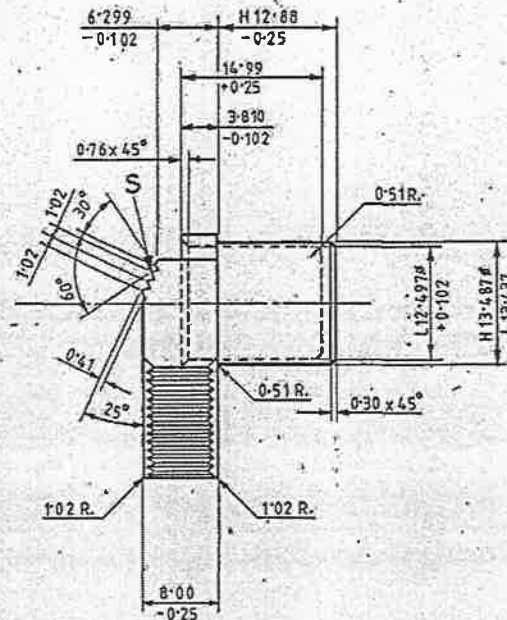
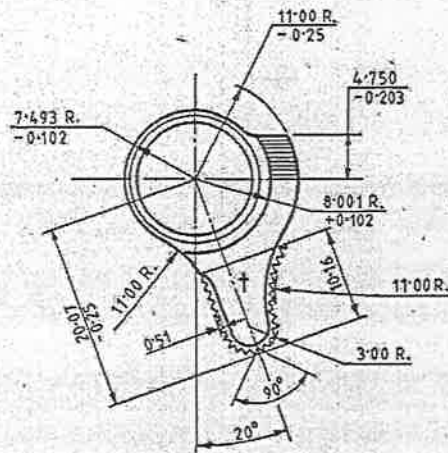
D MATL: — IS: 5517-1993, DESIGNATION 35Mn6Mo3.	
H.T./HARDNESS: — AS STATED	DGMR'S REF. M.G.DET.NO. 1282.
PROTECTIVE FINISH: — AS STATED	PART NO.
NOMENCLATURE: — PIN, CATCH, LEG, BIPOD	DRG. NO.
	D.S. CAT. NO. 5315-001477

1176

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060810-0789 D.S. CAT. 5340-018090

FOR EXPLANATION SEE D.D. NOTE SHEET E & 10.
DIMNS. ARE IN mm.



TOLERANCE FOR UNTOLERANCED DIMENSIONS ± 0.13 .
ANGLES GIVEN IN DEGREES ± 5 MINUTES.
ANGLES GIVEN IN DEGREES & MINUTES ± 2 MINUTES.

† MANUFACTURER'S CODE TO BE MARKED HERE.

MATERIAL :-

IS: 5517-1993, DESIGNATION 40 C8.17

INVESTMENT CASTING MATERIAL :-

IS: 10343-1999 GRADE 3A.

HEAT TREATMENT :-

SERRATIONS 'S' TO BE LOCALLY HEAT TREATED TO
300-400 H.V.

ALTERNATIVE HARDNESS NO. :-

ROCKWELL D50-57

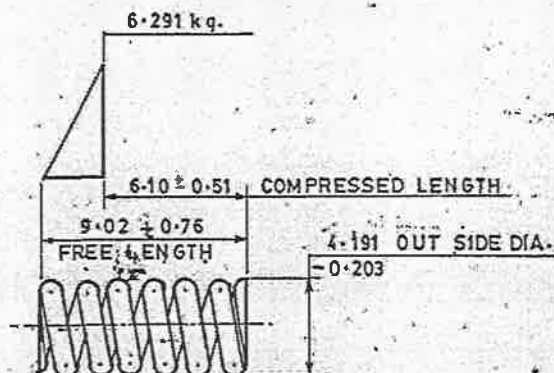
METRIC

05.10.16	26955-SA	MATERIAL AMENDED.	DRN.	CHD.	TRD.	COMP.	AHSR CQA(SA), ICHAPUR
20.01.2003.	25666-SA	PROFORMA CHANGED, ACTUAL SIZE VIEW DELETED, PROTECTIVE FINISH AMENDED, NEG. RE-TRACED AND ORG. RE-SEALED.	SCALE :- 2:1	EST. MASS :-	APPROVED	DT. 9-11-67	ASSY.
		PREVIOUS D.C. NO. 15148-SA, 16036-SA, 21195-SA, 27.86-SA, 23524-SA, 23563-SA AND 24879-SA.	COPY	COPY	(NEG. RE-TRACED)		
DATE	AUTHY.	BRIEF RECORD	ZONE	I/C.D.O.	G.O.		
SEALED :- D.C. NO. 15148-SA, DT. 18-5-77			SIGN.				
NOMENCLATURE :-			H.T./HARDNESS :- AS STATED			DGNR'S REF. M.G.DET. No. 1389	
STOP, LEG, BIPOD			PROTECTIVE PHOSPHATE TO SPECN. JSS. 0465-01:1994			PART. NO.	
			FINISH :- CLASS 1, OIL FINISH			ORG. NO.	
						D.S. CAT. NO. 5340-018090	

687000-0989
D.S.CAT
17030

FOR EXPLANATION SEE D.D. NOTE SHEET E. & 10
DIMNS. ARE IN m.m.

TOLERANCE FOR UNTOLERANCED DIMENSIONS ± 0.13



DIA. OF WIRE 0.813 APPROX.

MAY BE WOUND LEFT AND RIGHT HAND.

NUMBER OF EFFECTIVE COILS EQUALLY SPACED 6

TOTAL NUMBER OF COILS 7,

END COILS TO BE CLOSED IN, GROUND SQUARE TO THE AXIS
OF THE SPRING AND SHARP EDGES REMOVED.

THE SPRING IS TO WORK FREELY IN ITS LOADED AND
UNLOADED CONDITIONS IN A BORE OF 4.39 DIA.

SPRING TO BE TESTED BEFORE GAUGING BY COMPRESSION
TO A LENGTH OF 6.10 FOR A PERIOD OF 12 HOURS AFTER
WHICH IT MUST CONFORM TO THE FREE LENGTH SHOWN.

METRIC

DRN.	CHD.	TRD.	COMP.	ASHP CQA(SA) ICHAPUR
SCALE :- 5:1		EST. MASS		ASSY.
DT. 7-9-2001	1/C.D.O.	APPROVED DT. 9.11.67,	NEG. RE-TRACED	
MATERIAL :- IS: 4454 PL: 2001 Grade DM.				DGNR'S REF. M.G. DET. NO. 1365
H.T/HARDNESS :- LOW TEMPERATURE TREATMENT.				PART NO.
PROTECTIVE PHOSPHATE TO SPECN. JSS: 0465-01:1988				DRG. NO.
FINISH :- CLASS II (ACCELERATED) OIL FINISH.				D.S.CAT. NO. 5360-000489

25.11.66 26977-SA MATERIAL AMENDED.

7-9-2001 25115-SA PROFORMA CHANGED, ACTUAL SIZE VIEW DELETED,
NEG. RE-TRACED AND DRG. RE-SEALED

PREVIOUS D.C. NOS. 15145-SA, 15686-SA,
17971-SA AND 22482-SA.

DATE AUTH. BRIEF RECORD ZONE 1/C.D.O. G.O.

SEALED:- D.C. NO. 15145-SA, DT. 10.5.77.

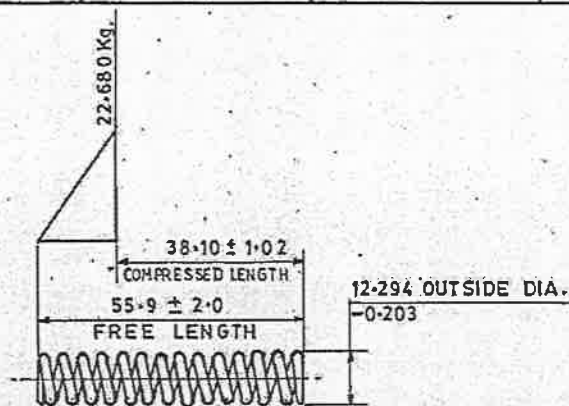
NOMENCLATURE:- SPRING, CATCH, LEG, BIPOD.

067000-09ES 'ON
143 CAT

FOR EXPLANATION SEE D.D. NOTE SHEET 'E'.

DIMNS. ARE IN m.m.

TOLERANCE FOR UNTOLERANCED DIMENSIONS ± 0.13



DIA. OF WIRE 2.032 APPROX.
MAY BE WOUND LEFT OR RIGHT HAND.

NUMBER OF EFFECTIVE COILS, EQUALLY SPACED, 12 1/2
TOTAL NUMBER OF COILS 13 1/2.
END COILS TO BE CLOSED IN, GROUND SQUARE TO THE
AXIS OF THE SPRING AND SHARP EDGES REMOVED.

THE SPRING IS TO WORK FREELY IN ITS LOADED AND
UNLOADED CONDITIONS IN A BORE OF 12.45 DIA.

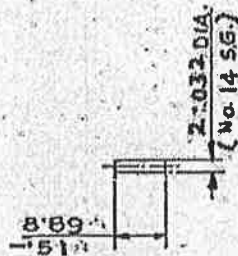
SPRING TO BE TESTED BEFORE GAUGING BY COMPRESSION
TO A LENGTH OF 28.96 FOR A PERIOD OF 12 HOURS AFTER
WHICH IT MUST CONFORM TO THE FREE LENGTH SHOWN.

METRIC

25.11.66 26977-SA		MATERIAL AMENDED.		DRN.	CHD.	TRD. <i>Sub. Chd.</i>	COMP. <i>H. B. B. B.</i>	AHSP CQA(SA) ICHAPUR
28.6.2000 24763-SA		PROFORMA CHANGED, NEG. RE-TRACED AND DRG. RE-SEALED.		SCALE :- 1:1		EST. MASS APPROVED DT. 9.11.67		ASSY.
		PREVIOUS D.C. NOS. 15145-SA, 15606-SA, 17570-SA AND 22123-SA.		DT. 28-6-2000 <i>Sub. Chd.</i> 1/C & D.O.		NEG. RE-TRACED		
DATE AUTHY.		BRIEF RECORD		ZONE	1/C & D.O.	G.O.		DGNR'S REF. MG.DET. NO. 1360
SEALED :-		D.C. NO. 15145-SA, DT. 18.5.77		SIGN.		H.T/HARDNESS :- LOW TEMPERATURE TREATMENT.		PART NO.
NOMENCLATURE :- SPRING, BIPOD				PROTECTIVE PHOSPHATE TO SPECN. JSS: 0465-01:1988 FINISH :- CLASS III (ACCELERATED), OIL FINISH OR OIL BLACKED.				DRG. NO.
								D.S. CAT. 5360-000490 NO.

PART No.
WP 10924

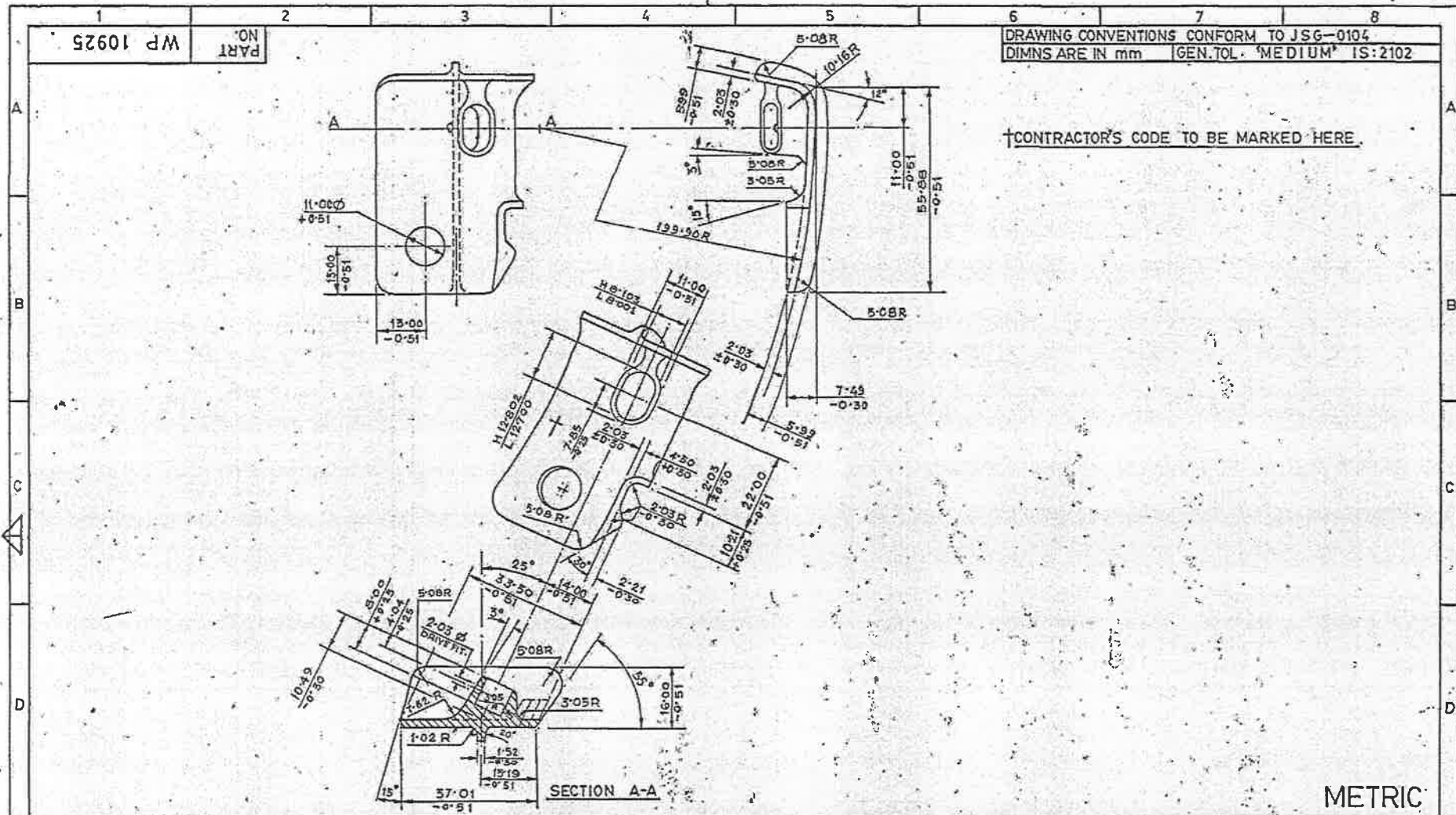
FOR EXPLANATION SEE DD NOTE SHEET E OF CA. THE NOTE SHEET NO. 1.
THIRD ANGLE PROJECTION. DIMENSIONS ARE IN MILLIMETRES.



TO BE DRIVEN INTO "SHOE" AND "TUBE, LOWER"
BRAZED, AND FINISHED FLUSH.

METRIC

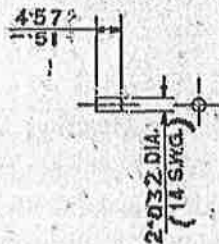
				ASSY. DRG. 1005-000066			
				INSP. INSTRNS.			
				DRAWN		CHECKED	TRACED
				Bsa ka		M. G. DET.	
				APPROVED			
				FOR CISA			
28.11.16	26978-SA	MATERIAL AMENDED		DATE: 9.11.67			
16-8-78	15713-SA	DRAWING SEALED.		M. G. DET. No. 1315			
DATE	AUTHY.	ZONE	NATURE	PART No.			
			AMENDMENTS	WP 10924			
SEALED:- DC(1) 15713-SA DT. 16-8-78.				CISA.			
MATERIAL:- 1ST 280-2.006 CONDITION, SOFT DRW/4 HARD				ICHAPUR			
PROTECTIVE FINISH:-							
ESTIMATED WEIGHT:-							
SCALE:- 1/1.							
PIN, FIXING, SHOE, BIPOD.							



28.11.16		26979-SA	MATERIAL AMENDED			DRG. CHD. TRD: <i>Deo</i> COMP. <i>Shankar</i>		A&P CQA(SA), ICHAPUR	
21.2.97		23694-SA	PROFORMA CHANGED, EXPLANATION NOTE DELETED, CONVENTION NOTE ADDED, TOL. NOTE AMENDED, NEG. RE-TRACED AND DRG. RE-SEALED.			SCALE: 1:1		EST. MASS	
			PREVIOUS D.C. NOS. 15713-SA, 16711-SA, 19617-SA, 21237-SA & 23651-SA			APPROVED DT. 9.11.67		ASSY. 1005-000066	
DATE AUTHY.		BRIEF RECORD		ZONE I/C: D.O. G.O.		DT. 24-2-97		NEG. RE-TRACED	
SEALED		DC 15713-SA, DT. 16-9-78		SIGN:		MATERIAL IS: 5517-1993 DESIGNATION 15 CB OR INVESTMENT CASTING MATERIAL. IS: 10343-1999 GRADE: 1A			
NOMENCLATURE SHOE, BIPOD, LEFT, MK.1.				HT/HARDNESS				DGNR'S REF. MG.DET.NO. 1350	
				PROTECTIVE FINISH				PART NO. WP 10925	
				STATED IN ASSY.				DRG.NO.	
								DS. CAT. NO.	

PART NO.

WP 10929

FOR EXPLANATION SEE DD NOTE SHEET EP 3 OF DET 11510
THIRD ANGLE PROJECTION. DIMENSIONS ARE IN MILLIMETRES.

TO BE DRIVEN INTO WP 10927 & WP 10931 BRAZED AND FINISHED FLUSH.

MATERIAL:-

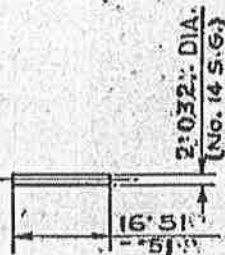
15:280 - 2006 CONDITION SOFT OR 1/4 HARD

METRIC

			ASSY. DRG. 1005-000067	
			INSP. INSTRS.	
			DRAWN	CHECKED
			TRACED	TRN. CHD.
			APPROVED	
28.11.16	269783A		MATERIAL AMENDED	
16-8-78	15713-SA		DRAWING SEALED.	
DATE	AUTHY.	ZONE	NATURE	
AMENDMENTS			DATE:- 8.11.67	
SEALED :- DC(1) 15713-SA DT. 16-8-78			DESIGNER'S REF.	
MATERIAL :- AS ABOVE, 15-280 (SOFT OR 1/4 HARD) BRIGHT			M.G. DET. NO. 1317	
PROTECTIVE FINISH:-			PART NO.	
ESTIMATED WEIGHT:-			WP 10929	
SCALE :- 1/1			CISA ICHAPUR.	
PIN, BRACKET, BIPOD, LEG, CATCH				

PART NO.
WP 10930

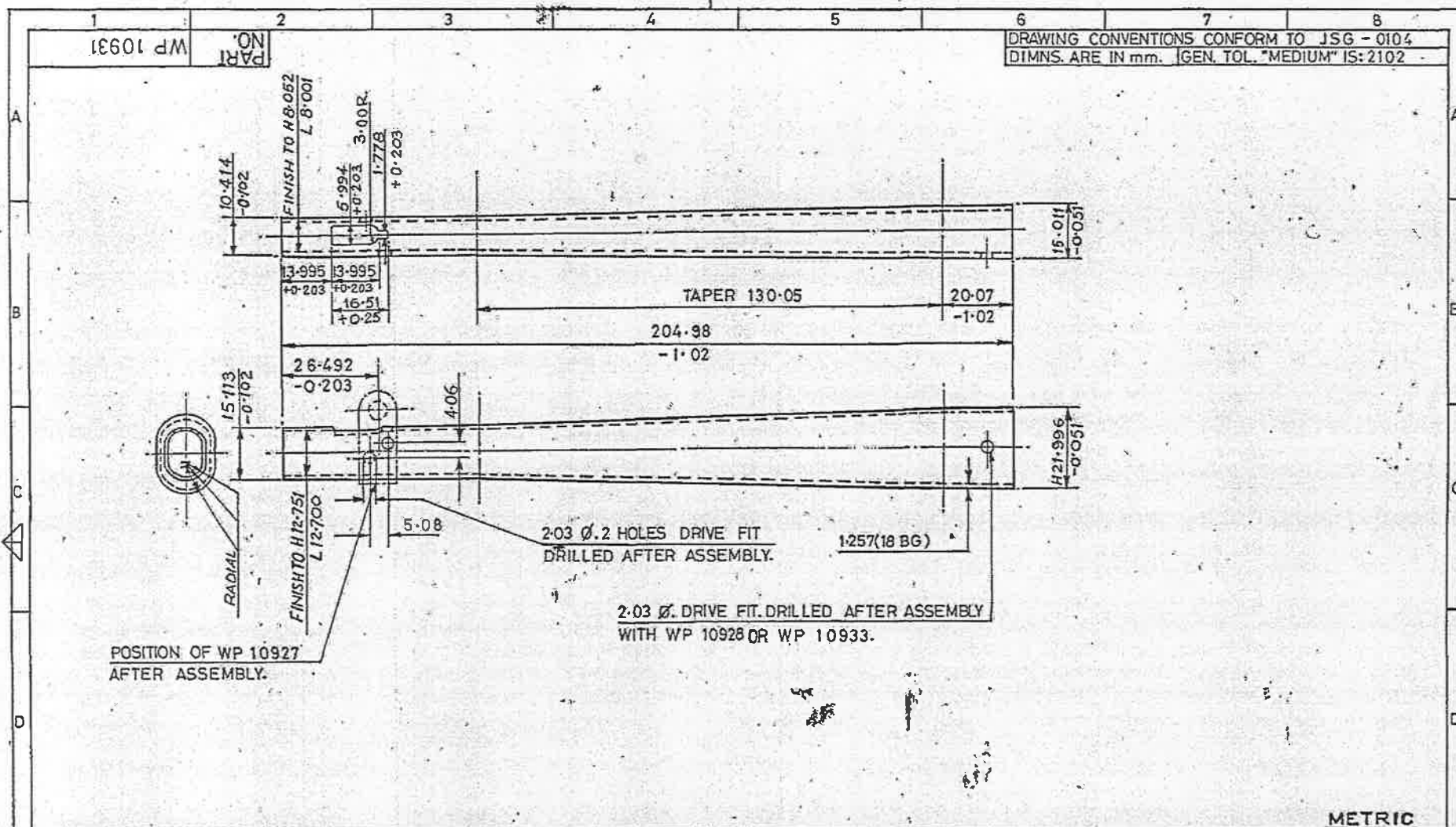
FOR EXPLANATION SEE DD NOTE SHEET E-1 (ARDE NOTIFICATION)
THIRD ANGLE PROJECTION. DIMENSIONS ARE IN MILLIMETRES.



TO BE DRIVEN INTO "CAP" AND "TUBE" UPPER BRAZED, AND FINISHED FLUSH.

METRIC

				ASSY. DRG. 1005-000067			
				INSP. INSTRNS			
				DRAWN/CHECKED		TRACED/TRY. CHD.	
						18/5/67	
28.11.16 26978-SA				MATERIAL AMENDED		APPROVED:-	
16-8-78 15713-SA				DRAWING SEALED.		FOR CISA	
DATE AUTHY. ZONE				NATURE		SIG.	
				AMENDMENTS		DATE:- 9.11.67	
SEALED:- DC(1) 15713-SA DT. 16-8-78.						DESIGNER'S REF	
MATERIAL:- IS:280.-200G CONDITION 505T OR 1/4 HARD 511T.						M.G. DET. No. 1318.	
PROTECTIVE FINISH:-						PART No.	
ESTIMATED WEIGHT:-						WP 10930	
SCALE:- 1/1.						CISA	
PIN, FIXING, CAP, BIPOD						ICHAPUR	

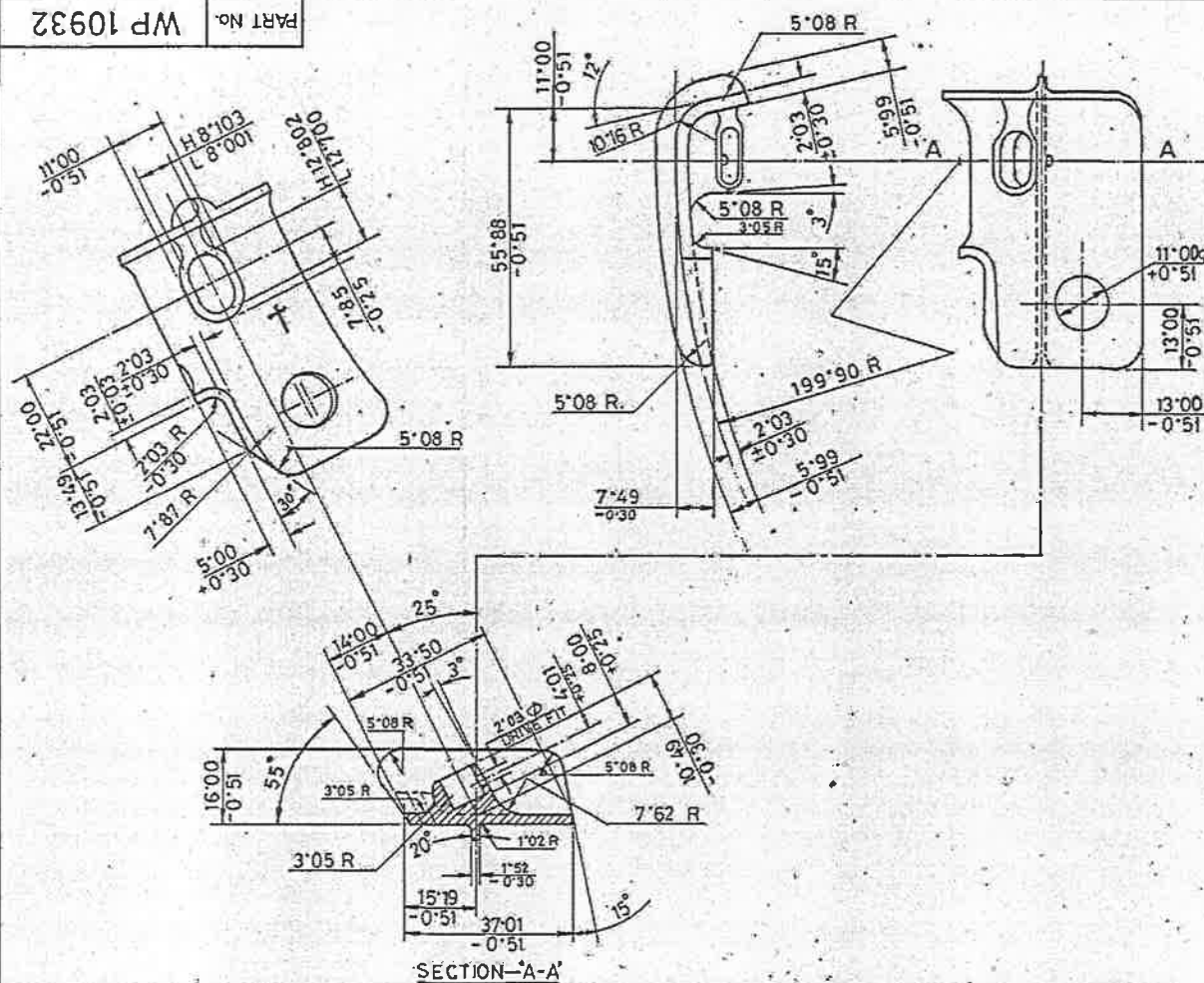


				METRIC			
				DRN.	CHD.	TRD. <i>W. S. S. S.</i>	COMP. <i>W. S. S. S.</i>
				SCALE: 1:1		EST. MASS.	
				APPROVED <i>And</i>		DT. 9.11.67	
				NEG. RE-TRACED.			
28.11.16	26979-SA	MATERIAL AMENDED.		DT. 15.5.97	IS 3074:1979 DESIGNATION CDS-4		
15-5-97	23829-SA	PROFORMA CHANGED, PROTECTIVE FINISH, TOLERANCE & EXPLANATION NOTE AMENDED, NEG. RE-TRACED & DRG. RE-SEALED.					
		PREVIOUS D.C. NOS. 15713-SA, 15897-SA, 17705-SA, 22133-SA, 22479-SA & 23594-SA.					
DATE	AUTHY.	BRIEF RECORD	ZONE	V.C.D. O.G.O.	HT/ HARDNESS		
SEALED: D.C. 15713-SA, DT. 16.8.78				SIGN.			
NOMENCLATURE				TUBE, BIPOD, UPPER			
				PROTECTIVE FINISH: PHOSPHATE TO SPECN. JSS: 0465-01: 1988 CLASS 1 PAINT R.F.U. STOVING BLACK TO SPECN. JSS: 8010-37 MATT. FINISH ON EXTERIOR SURFACES ONLY AFTER ASSEMBLY.			
				AHSP CQA(SA), ICHAPUR			
				ASSY. 1005-000067			
				DGNR'S REF M.G.DET.1407			
				PART NO. WP 10931			
				DRG. NO.			
				D.S. CAT. NO.			

PART No. WP 10932

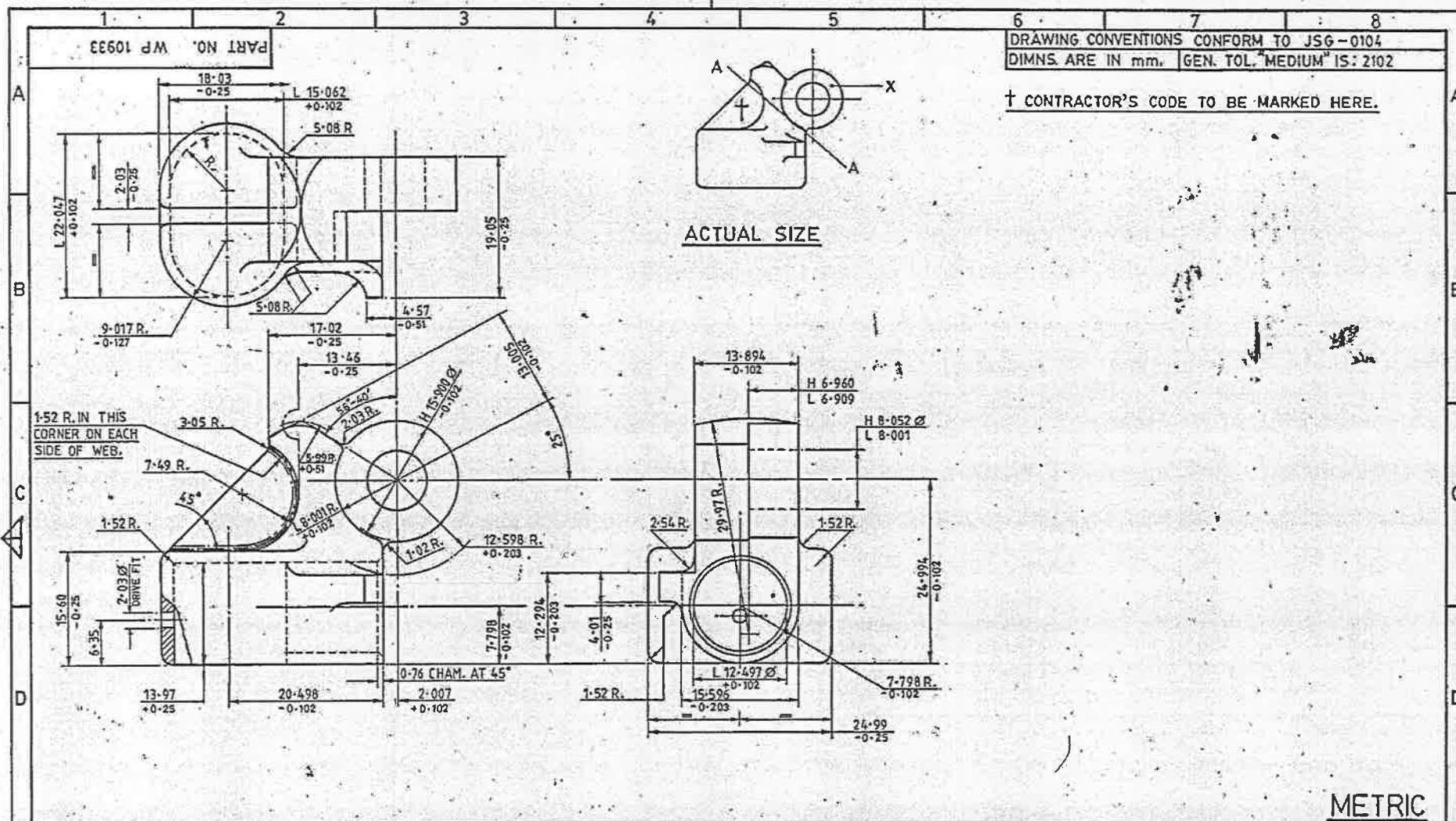
DRAWING CONVENTIONS CONFORM TO JSG-0104
DIMNS. ARE IN mm. GEN. TOL. 'MEDIUM' 15:2102

† CONTRACTOR'S CODE TO BE MARKED HERE.



METRIC

28.11.16	26979-SA	MATERIAL AMENDED			DRN.	CHD.	TRD.	S.K.P.	COMP.	AHSP	COA(SA), ICHAPUR
21.2.97	23694-SA	PROFORMA CHANGED, EXPLANATION NOTE DELETED, CONVENTION NOTE ADDED, TOL. NOTE AMENDED, NEG. RETRACED AND DRG. RE-SEALED.			SCALE :- 1:1					EST. MASS	
		PREVIOUS D.C. Nos. 15713-SA, 16711-SA, 19617-SA, 21237-SA, 23555-SA.			DT. 24-2-92					APPROVED DT. 9.11.67	ASSY. 1005-000071
DATE	AUTHY.	BRIEF RECORD	ZONE	COPY	COPY	MATERIAL	15:4432-1988 DESIGNATION 15 CB OR INVESTMENT CASTING MATERIAL:- 15:10343-1399	1/C: D.O.		NEG. RE-TRACED.	DGNR'S REF. MG. DET. No. 1351
SEALED		D.C. No. 15713-SDT. 16.8.78		1/C: D.O.	G.O.	H.T/HARDNESS					PART. No. WP10932
NOMENCLATURE		SHOE, BIPOD, RIGHT, MK.1.		SIGN.		PROTECTIVE FINISH	STATED IN ASSY.				DRG. No.
											D.S. CAT. No.



28-11-16 26979-2		MATERIAL AMENDED	AKHARU. L.P. CO.		DRN.	CHD.	TRD. HANSEN	COMP. M. B. B. B.	AHSP. CQA(SA), ICHAPUR
2-5-97 23821-SA		PROFORMA CHANGED, EXPLANATION & TOL. NOTE AMENDED, NEGATIVE RE-TRACED AND DRAWING RE-SEALED.	ANB COE		SCALE: 2:1 & 1:1		EST. MASS.		ASSY. 1005-000072
DATE AUTHY.		BRIEF RECORD	ZONE I/C D.O. G.O.		DT. 07-5-97		APPROVED, DT. 9-11-67 (NEGATIVE RE-TRACED)		
SEALED: D.C. 15713-SA, DT. 16-8-78			SIGN.		MATERIAL: 1575517-1993 DESIGNATION 40 CA, OR INVESTMENT CASTING MATERIAL IS: 10343-1999 GRADE 3A.				DGNR'S REF. MG. DET. NO. 1219
NOMENCLATURE: CAP. LEG, BIPOD, RIGHT.					H.T./HARDNESS: HINGE END BEYOND LINE 'A-A' TO BE HARDENED AND TEMPERED TO A H.V. OF 350-450 MEASURED AT POINT 'X'. ALTERNATIVE HARDNESS NO.: ROCKWELL D38-57.				PART NO.. WP 10933
					PROTECTIVE FINISH PHOSPHATE TO SPECN. JSS 0465-01:1988 CLASS-1, OIL FINISH AFTER ASSEMBLY.				DRG. NO.
									DS. CAT. NO.