

DIMENSIONS ARE IN mm.
 UNTOLERATED DIMNS. AS PER IS : 2102 (MED)
 IMPORTANT DIMNS. MARKED THUS : T.

SCALE : 1:1

MARKING ON TAG :
 YEAR OF MANUFACTURING,
 MANUFACTURER'S CODE &
 DRG. NO.

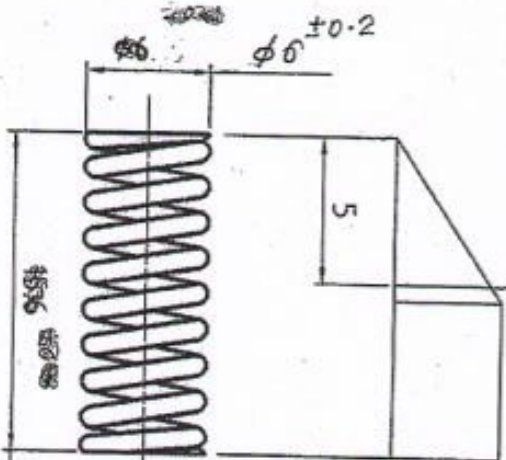
WIRE DIA: 1mm
 WOUND : R.H.
~~NO. OF EFF. COILS~~

NO. OF EFF. COILS -- 8.5 ± 0.5
 NO. OF COILS -- 10 ± 0.5

STRESS RELIEVED

ONE COIL AT EACH END TO BE
 CLOSED IN AND GROUND SQUARE
 TO THE AXIS OF THE COIL LEAVING
 3/4 OF THE COIL AT EACH END
 NON-EFFECTIVE

MEAN ϕ 5.0 ± 0.2
 SOLID LENGTH - 10.0



THE SPRING TO WORK FREELY IN ITS LOADED AND UNLOADED
 CONDITION IN THE HOLE DIA 6.5mm
CRAMP TEST: THE SPRING TO BE COMPRESSED TO A LENGTH
 OF 5mm FOR A PERIOD OF 12 HOURS BEFORE GAUGING.

MATL:- STEEL IS:454 PART I 2007 GR. 1

DRG. PROVISIONAL

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
	TRACED				SCALE NTS
	DRAWN				STORE DRG.NO.
	CHECKED				OPERATION NO.
	OFFICER/ PRDND.				SHEETS: 1
	OFFICER/ DADD				SHEET No.: 1
	APPROVED ON. 08/2005				

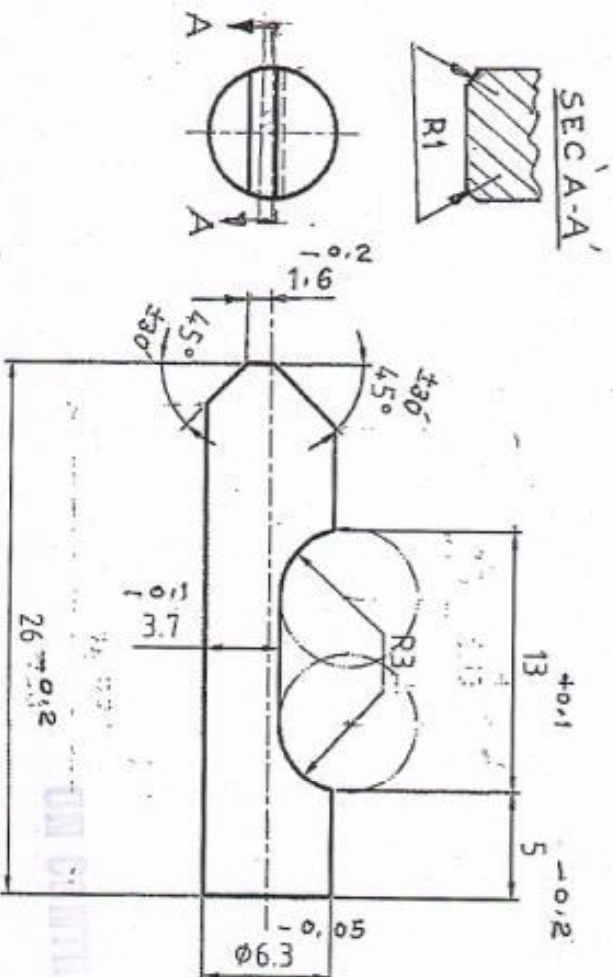
SUB: EXTRACTOR SPRING
 FOR: 14.5mm BOLT ASSY.
 OF: 14.5mm/20mm AMR.
 DES. REF. NO.
 DRG. No.: 44P 14001*2
 ORDINANCE FACTORY
 TRUCHIRAPPALLI-16.

AMENDMENTS & DATE
 DA. No. 017/9
 Dt. 03/11/9
 DA. No. 001/9
 31/11/9
 02.03.19

CERTIFIED CORRECT COPY
 OF APPROVED DRAWINGS
 AT THIS OFFICE
 27/09/19

DRG. NO. 44P 1 2002

DIMENSIONS ARE IN mm.
 UNTOLERATED DIMNS. AS PER IS : 2102 (MED)
 MARK DRAWING No.
 SHARP CORNERS TO BE BLUNT TO R0.2



MATERIAL:- 17/4 BHSS
 ALT. MATL: EN 19
 CHROME PLATED THICKNESS: 0.010

+0.005
 DRG. PROVISIONAL

0.4

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS

TRACED	SIGNATURE & DATE	SUB: EJECTOR	SCALE
DRAWN		FOR: 14.5mm BOLT ASSY.	STORE DRG. NO.
CHECKED		OF: 14.5mm/20mm AMR.	
OIC/D&DO		DES. REF. NO.	OPERATION NO.
OFFICER/PRODN.		DRG. No.: 44P 14002	
D&DO			

AMENDMENTS	SIG. & DATE	APPROVED ON. 07/05	ORDNANCE FACTORY TIRUCHIRAPPALLI-16.
			SHEETS: 1
			SHEET No.: 1

DR. NO: 006/07
 4/10/07

PERMITTED PROTECT COPY
 OF APPROVED DRAWING
 AT THIS OFFICE
 12/10/09
 K

UN CONTROLLED COPY



SCALE :1:1

DIMENSIONS ARE IN mm.
 UNTOLERATED DIMNS. AS PER IS : 2102 (MED)
 IMPORTANT DIMNS. MARKED THUS : T.

MARKING ON TAG :

YEAR OF MANUFACTURING,
 MANUFACTURER'S CODE &
 DRG. NO.

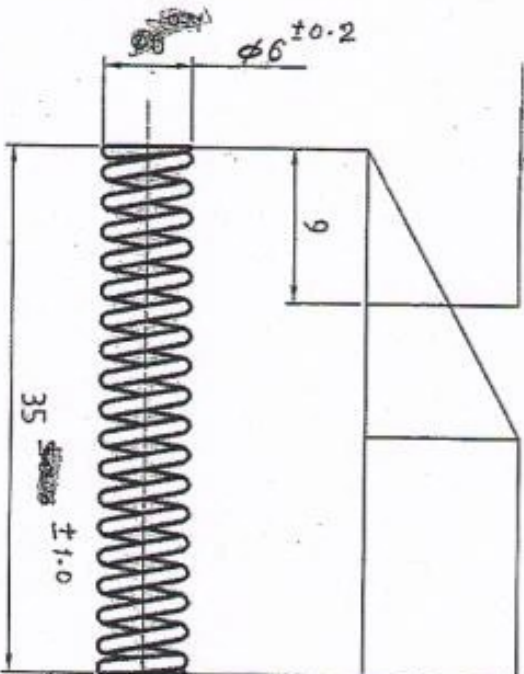
WIRE DIA: \varnothing mm 1.1mm
 WOUND : R.H.

No. of EFFECTIVE COILS - 16.5 ± 0.5
 No. of COILS - 18.0 ± 0.5

STRESS RELIEVED

- ONE COIL AT EACH END TO BE CLOSED IN AND GROUND SQUARE TO THE AXIS OF THE COIL LEAVING 3/4 OF THE COIL AT EACH END NON-EFFECTIVE

SOLID LENGTH - 18.0 ± 0.2
 MEAN DIA = \varnothing 4.9 ± 0.2



$\pm 1.0\%$ GD&S
 6.9 kg force exerting

THE SPRING TO WORK FREELY IN ITS LOADED AND UNLOADED CONDITION IN THE HOLE DIA 6.35mm
 CRAMP TEST: THE SPRING TO BE COMPRESSED TO A LENGTH OF 9mm FOR A PERIOD OF 12 HOURS BEFORE GAUGING.

MATL:- STEEL IS:4454 PART I-2001 GR. ^{DH}A

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CERTIFIED CORRECT COPY
 OF APPROVED DRAWINGS
 AT THE
 Design & Development
 Engineering Office,
 Tiruchirappalli-620016

22/01/19

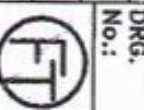
PART NO.		DESCRIPTIONS & SIGNATURE & DATE		NO OFF	MATERIAL	TREATMENT	REMARKS
TRACED							SCALE NTS
DRAWN		R. NINGI					STORE DRG.NO.
CHECKED		<i>[Signature]</i>					OPERATION NO.
OIC/D&DO		<i>[Signature]</i>					
OFFICER/ PRDNL.		<i>[Signature]</i>					
OFFICER/ D&DO		<i>[Signature]</i>					
APPROVED ON. 08/2005							
SUB: <u>EJECTOR SPRING</u>		FOR: <u>14.5mm BOLT ASSY.</u>					
DES. REF. NO.		OF: <u>14.5mm/20mm AMR.</u>					
DRG. No.:		44P 14003*2					
ORDNANCE FACTORY		TIRUCHIRAPPALLI-16.					
SHEETS: 1							
SHEET No.: 1							

*

DA.No. 018/19
 Dt. 03/07/19
 DA.No.001/19

Sig. *[Signature]*
 Dt. 08-3-19

OFFICER/ PRDNL.
 OFFICER/ D&DO



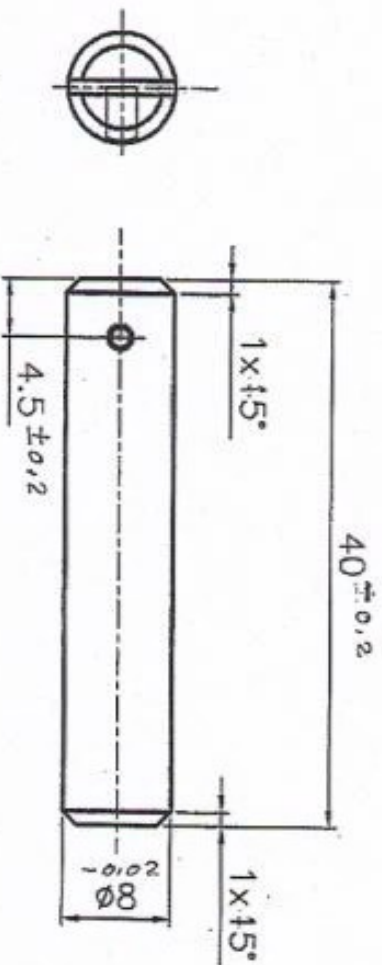
ORDNANCE FACTORY
 TIRUCHIRAPPALLI-16.

SHEETS: 1
 SHEET No.: 1

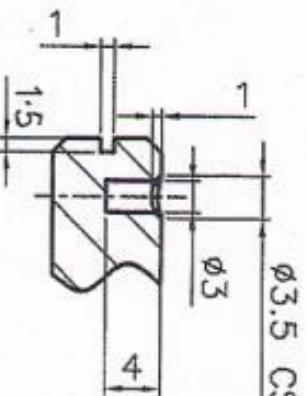
DRG. PROVISIONAL COPY

*4041 P44 ON DRG

DIMENSIONS ARE IN mm,
UNTOLERATED DIMNS. AS PER IS : 2102 (MED)
MARK DRAWING No.



CERTIFIED CORRECT COPY
OF APPROVED DRAWINGS
AT TRUCHIRAPPALLI
DRG. S. IYER
ORDNANCE FACTORY,
TRUCHIRAPPALLI-60012



HARDNESS: 890-450 HV

IS: 6527-1995, DESIGN. XCA C-18 N:10,

MATERIAL: ~~17-7 PH SS~~

ALT. MATL: EN 19 CHROME PLATED, THICKNESS: 0.010 ± 0.005 0.4 ∇

DRG. PROVISIONAL

UNCONTROLLED COPY

PART NO.	DESCRIPTIONS	SIGNATURE & DATE	NO OFF	MATERIAL	TREATMENT	REMARKS
	TRACED					
	DRAWN	R. Nave				SCALE NTS
	CHECKED	Subir K.				STORE DRG. NO.
	OIC/D&DO					OPERATION NO.
	OFFICER/PRODN.					
	OFFICER/D&DO					
SUB: BOLT LEVER PIVOT PIN						
FOR: 14.5mm BOLT ASSY.						
OF: 14.5mm/20mm AMR						
DES. REF. NO.						
DRG. No.: 44P 14004*						
ORDNANCE FACTORY TRUCHIRAPPALLI-16.						
SHEETS: 1						
SHEET No.: 1						

F DR. NO. 006/07
DR. No. 88 DA No. 82/19
SIG. DATE 14/10/07
30.3.19

AMENDMENTS & DATE
APPROVED ON: 07/05

1 2 3 4