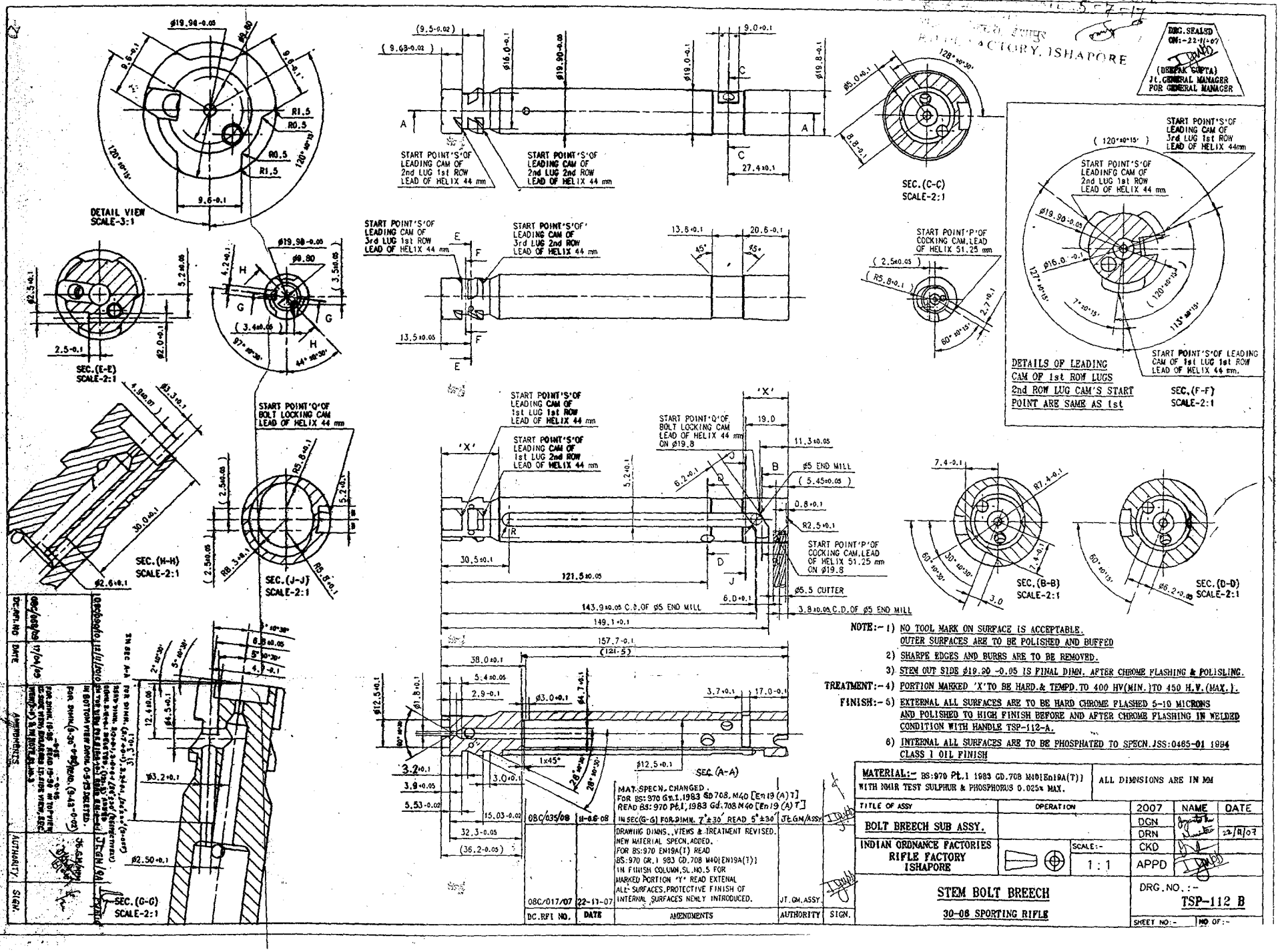
DETAIL VIEW SCALE-3:1
SEC.(E-E) SCALE-2:1
SEC.(H-H) SCALE-2:1
SEC.(J-J) SCALE-2:1
SEC.(G-G) SCALE-2:1
SEC.(C-C) SCALE-2:1
SEC.(F-F) SCALE-2:1
SEC.(B-B) SCALE-2:1
SEC.(D-D) SCALE-2:1
SEC.(A-A)
START POINT'S'OF LEADING CAM OF 2nd LUG 1st ROW LEAD OF HELIX 44 mm
START POINT'S'OF LEADING CAM OF 2nd LUG 2nd ROW LEAD OF HELIX 44 mm
START POINT'S'OF LEADING CAM OF 3rd LUG 1st ROW LEAD OF HELIX 44 mm
START POINT'S'OF LEADING CAM OF 3rd LUG 2nd ROW LEAD OF HELIX 44 mm
START POINT'S'OF LEADING CAM OF 1st LUG 1st ROW LEAD OF HELIX 44 mm
START POINT'S'OF LEADING CAM OF 1st LUG 2nd ROW LEAD OF HELIX 44 mm
START POINT'Q'OF BOLT LOCKING CAM LEAD OF HELIX 44 mm
START POINT'Q'OF BOLT LOCKING CAM LEAD OF HELIX 44 mm ON ø19.8
START POINT'P'OF COCKING CAM, LEAD OF HELIX 51.25 mm
START POINT'P'OF COCKING CAM, LEAD OF HELIX 51.25 mm ON ø19.8
DETAILS OF LEADING CAM OF 1st ROW LUGS 2nd ROW LUG CAM'S START POINT ARE SAME AS 1st
ø5 END MILL
ø5.5 CUTTER
3.8±0.05 C.D.OF ø5 END MILL
6.0±0.1
143.9±0.05 C.D.OF ø5 END MILL
149.1±0.1
157.7-0.1
(121.5)
30.5±0.1
121.5±0.05
NOTE:- 1) NO TOOL MARK ON SURFACE IS ACCEPTABLE. OUTER SURFACES ARE TO BE POLISHED AND BUFFED
2) SHARPE EDGES AND BURRS ARE TO BE REMOVED.
3) STEM OUT SIDE ø19.80 -0.05 IS FINAL DIMN. AFTER CHROME FLASHING & POLISLING.
TREATMENT:- 4) PORTION MARKED 'X' TO BE HARD.& TEMPD. TO 400 HV(MIN.)TO 450 H.V.(MAX.).
FINISH:- 5) EXTERNAL ALL SURFACES ARE TO BE HARD CHROME FLASHED 5-10 MICRONS AND POLISHED TO HIGH FINISH BEFORE AND AFTER CHROME FLASHING IN WELDED CONDITION WITH HANDLE TSP-112-A.
6) INTERNAL ALL SURFACES ARE TO BE PHOSPHATED TO SPECN.JSS:0465-01 1994 CLASS 1 OIL FINISH
MATERIAL:- BS:970 Pt.1 1983 GD.708 M40[En19A(T)] WITH NMIR TEST SULPHUR & PHOSPHORUS 0.025% MAX.
ALL DIMNSIONS ARE IN MM
TITLE OF ASSY
BOLT BREECH SUB ASSY.
OPERATION
INDIAN ORDNANCE FACTORIES RIFLE FACTORY ISHAPORE
SCALE:- 1:1
2007
NAME
DATE
DGN
DRN
CKD
APPD
22/11/07
STEM BOLT BREECH
30-06 SPORTING RIFLE
DRG.NO.:- TSP-112 B
SHEET NO:-
NO OF:-
DC.RFI NO.
DATE
AMENDMENTS
AUTHORITY
SIGN.
08C/035/08
11-06-08
MAT.SPECN. CHANGED. FOR BS:970 Gt.1.1983 GD.708, M40 [En19 (A) T] READ BS:970 Pt.1, 1983 Gd.708 M40 [En19 (A) T]
IN SEC(G-G) FOR DIMN. 7°±30' READ 5°±30'
JT.GM/ASSY
08C/017/07
22-11-07
DRAWING DIMNS., VIEWS & TREATMENT REVISED. NEW MATERIAL SPECN. ADDED. FOR BS:970 EN19A(T) READ BS:970 GR.1 983 GD.708 M40[EN19A(T)] IN FINISH COLUMN, SL.NO.5 FOR MARKED PORTION 'Y' READ EXTENAL ALL SURFACES, PROTECTIVE FINISH OF INTERNAL SURFACES NEWLY INTRODUCED.
JT.GM.ASSY
DRG. SEALED ON:- 22-11-07
(DEEPAK GUPTA) JT. GENERAL MANAGER FOR GENERAL MANAGER
INDIAN ORDNANCE FACTORY, ISHAPORE