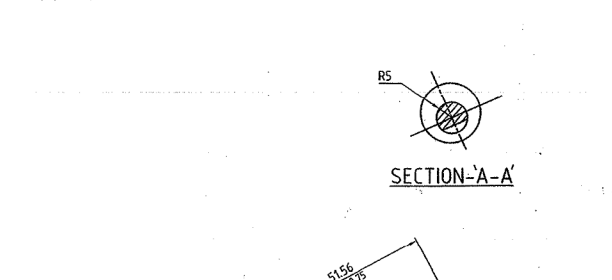
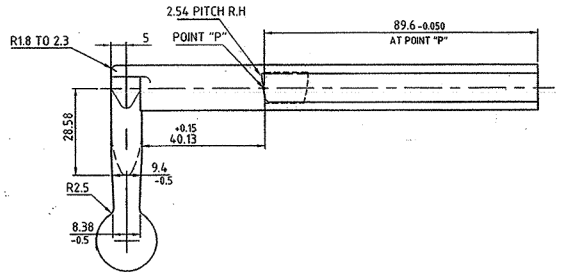
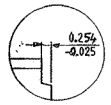
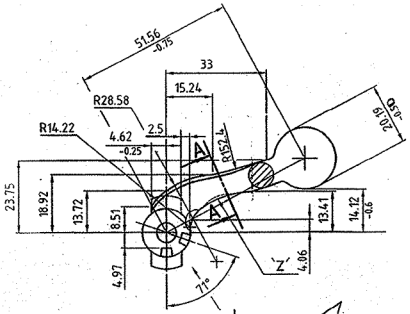
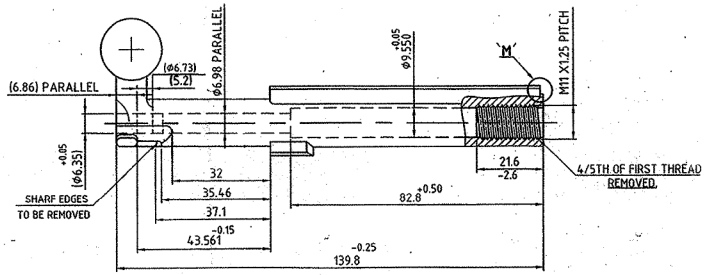


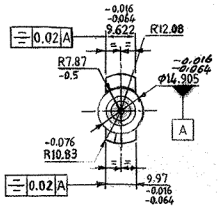


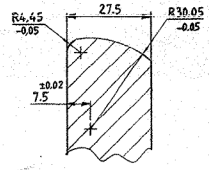


ENLARGED VIEW OF 'M'

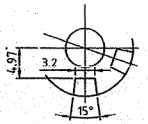




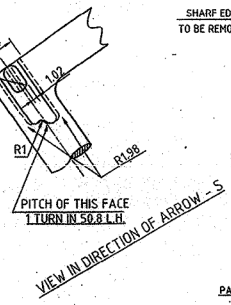




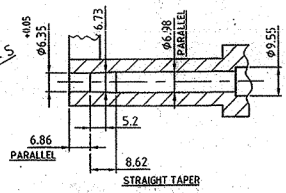
SECTION OF MILLING CUTTER 'Z'

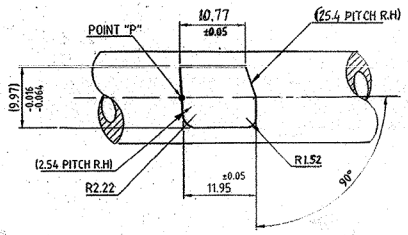


SCALE (2:1)



VIEW IN DIRECTION OF ARROW - S





ENLARGED VIEW

NOTES:-

1. DIMENSIIONS GIVEN ARE WHITE STAGE.

2. HELIX OF BOTH THE LUGS TO BE IDENTICAL, TO ENSURE UNIFORMITY OF THE HELIX. HELIX MILLING TO BE PERFORMED ON THE CNC. POINT "P" ON THE EITHER SIDE SHOULD MAINTAIN SYMENTRICITY OF 0.025 mm.

NOTE FOR MACHINING THE PROFILE AT ZONE "Z":-

TO FORM BODY SEATING AT 'Z'.
FIRST THE BOLT IS INVERTED AND TURNED CLOCKWISE ON ITS AXIS THROUGH AN ANGLE OF 40°45'

SECOND THE AXIS OF THE BOLT IS INCLINED AT AN ANGLE OF 7°23' BY RAISING THE FRONT END,&

THIRD WHEN IN THE AFORESAID POSITION THE BOLT IS SET TO THE SIDES OF THE MILLING CUTTER 'Z' AT AN ANGLE OF 3°10' FROM THE REAR END.

EXTRACT OF IS:2102 MED. & SURFACE ROUGHNESS VALUES

LINEAR DIMNS. ABOVE	UPTO&INCL	TOL.	ANGULAR DIMNS. LENGTH OF SHORTER SIDE OF ANGLE ABOVE	UPTO&INCL	TOLERANCE mm	DEGREE OR MINUTES
0.5	6	±0.1	–	10	±0.1	1°
6	30	±0.2	10	50	±0.2	30'
30	120	±0.3	50	120	±0.6	20'
120	315	±0.5	120		±0.8	10'
315	1000	±0.8				
1000	2000	±1.2				
2000	4000	±2				
4000	8000	±3				
8000	12000	±4				
12000	16000	±5				

SURFACE ROUGHNESS VALUES Ra IN MICRON MAX.

▽	▽▽	▽▽▽	▽▽▽▽
25	6.3	0.8	0.1

DIMENSIONS ARE IN mm.
IMPORTANT DIMNS. MARKED THUS ⊕
INFORMATION MARKED THUS ⊅ TO BE MARKED ON.
UNTOLERATED DIMNS. ASPER IS:2102 (MEDIUM)

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
	BOLT BREECH (WHITE STAGE)				

	SIGNATURE & DATE.
TRACED	
DRAWN	P.Purushothaman
CHECKED	
HOS/D&DO	
OFFICER/ PRODN.	
OFFICER/ D&DO	
APPROVED ON. 11.02.2015	

SUB: BOLT BREECH (WHITE STAGE)
OF: .315" SPORTING RIFLE
FOR:
DES.REF.NO. 29P 0013(M)
DRG. No.: TEND: 2369
ORDNANCE FACTORY TIRUCHIRAPPALLI–16.

SCALE	STORE DRG.NO.	OPERATION NO.	SHEETS:	SHEET No.:
NTS	29P 0013(M)	—	1	1

AMENDMENTS	SIGN. & DATE