

DRAWING CONFORMS TO IS: 6194
DIMENSIONS ARE IN MM. DEN. TOL. 'MEDIUM' TO G: 2.02

MATERIAL: SUITABLE ON SAMPLE TAG

1 YL OF M4
* MANUFACTURER'S CODE

MATERIAL: NYLON 6 (WITHOUT GLASS FILLER)
TO SATISFY THE FOLLOWING
PHYSICAL PROPERTIES:-

CHARACTERISTICS	UNIT	REQUIREMENTS
1. SPECIFIC GRAVITY		± 0.02
2. MELTING POINT	(Deg. C)	215 TO 225
3. WATER ABSORPTION	(%)	0.7 MAX.
4. TENSILE STRENGTH	(Mpa)	50 MIN.
5. ELONGATION AT BREAK	(%)	50 MIN.

NOTE:-
TOLERANCE FOR ANGLES $\pm 30^\circ$
FOLLOWING OF BUTT EXCLUDING 21.09
HOLE IS LEFT TO THE DISCRETION OF
MANUFACTURER TO ACHIEVE SPECIFIED
WEIGHT

STEEL INSERT SHOULD NOT BE ABOVE
THE LEVEL OF PLASTIC SURFACE
SURFACES MARKED A.B. & C ARE
IMPORTANT AND TO BE MANUFACTURED
STRICTLY AS PER SPECIFIED DIMS.
MACHINING IS PERMISSIBLE TO MAINTAIN
THE DIMS.

COLOR:-
COLOR 1: DARK BLUE GREY
COLOR CODE 895 TO SPEN IS 52002
ADDITION OF PIGMENT NOT PERMITTED

COATING:-
VAPOR COATING IN DARK BLUE GREY
COLOR CODE 895 TO SPEN IS 52002
OR MRF SHADE NO. BLACK 600 WITH
MATT FINISH



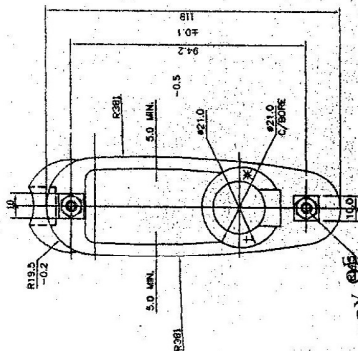
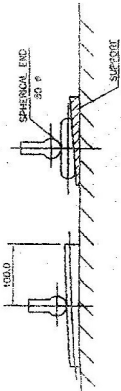
2013	NAME	DATE
DESIGNED	M. MIT	
DRAWN		
CHECKED		
APPROVED		
DRAWING NO.	TGG-401	
SCALE	1:1	
SHEET-1	OF-1	

DATE	DC RFI NO	SIGN
08/04/2014	09/025/114	

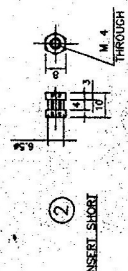
ASSY. DRAWING NO.-TGG-001	INDIAN ORDNANCE FACTORIES RIFLE FACTORY ISHAPORE
TEAR GAS GUN	BUTT

TEST TO BE CARRIED OUT IN FINAL STORE

90Kg.

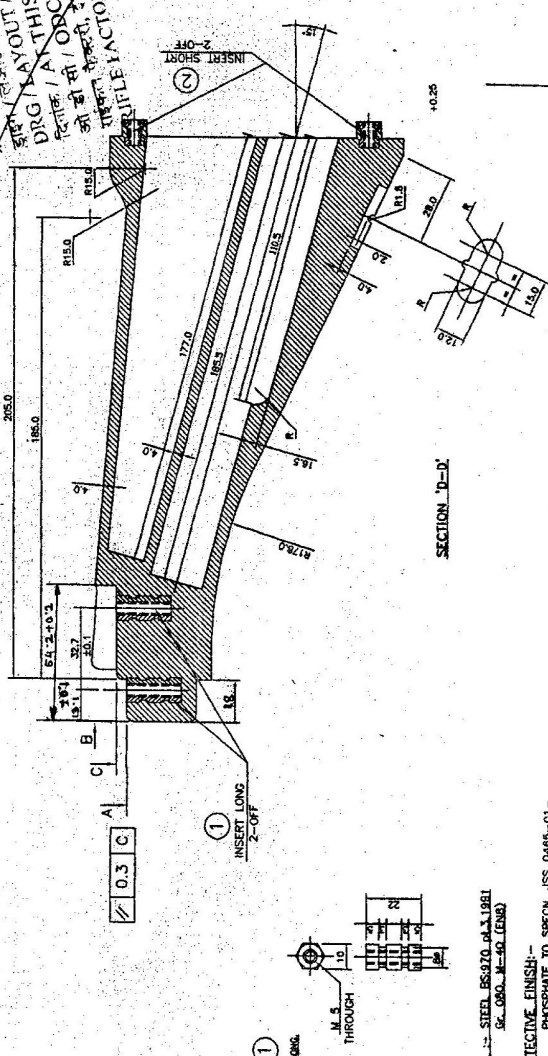
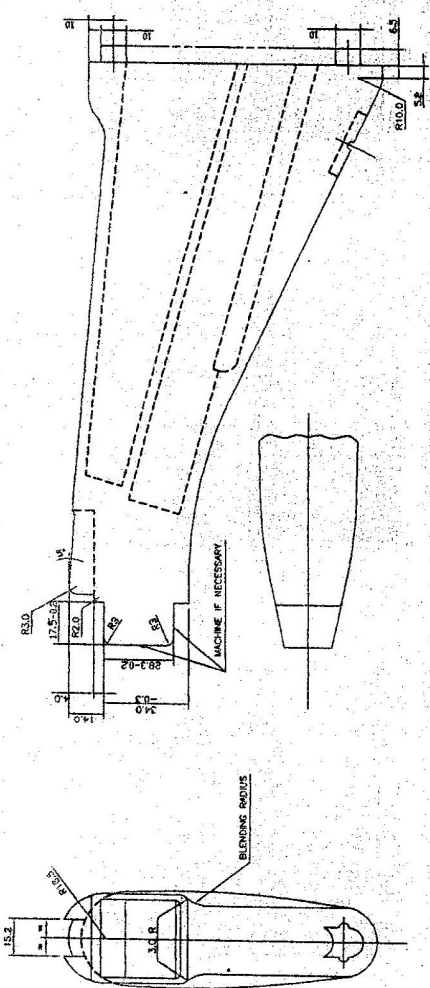
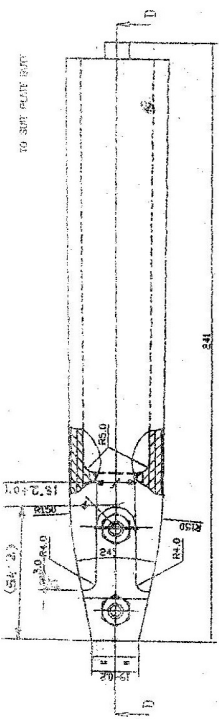


REPAIR / CERTIFIED COPY
DATE / BY / MFG
DRG / LAYOUT / GAUGE SCHEDULE
DATE / BY / MFG
RIFLE FACTORY, ISHAPORE



MATL:- STEEL BS-970 Q.1.1981
Gr. 080 M40 (EN8)

PROTECTIVE FINISH:-
PHOSPHATE TO SPECN. ISS. 0445-01-
1988 (CLASS. ACCELERATED) OIL FINISH
2-OFF PER Moulding POSITION AS SHOWN.



SECTION 'D-D'

MATL:- STEEL BS-970 Q.1.1981
Gr. 080 M40 (EN8)

PROTECTIVE FINISH:-
PHOSPHATE TO SPECN. ISS. 0445-01-
1988 (CLASS. ACCELERATED) OIL FINISH
2-OFF PER Moulding POSITION AS SHOWN.

Noted
11/11