

UN CONTROLLED COPY
 CERTIFIED CORRECT COPY OF APPROVED
 DRAWINGS AT THIS DATE 23/07/21
S. Venkatesh
 DESIGN & DRAWING OFFICE,
 ORDNANCE FACTORY, TIRUCHIRAPPALI - 620 016.

WELD AS PER SAMPLE
 STRESS RELIEVE AFTER WELDING

DRG. PROVISIONAL

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

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
					SCALE NTS
					STORE DRG. NO.
					OPERATION NO.
					SHEETS: 1
					SHEET No.: 1
					8

TRACED	DESCRIPTIONS & SIGNATURE & DATE	DES. REF. NO.
DRAWN	<i>S. Venkatesh</i>	DRG. No.: 44P 09000 *
CHECKED	<i>S. Venkatesh</i>	OF : 12.7 / 14.5 / 20 mm AMR
OFFICER / PRODIN. D&DO	<i>S. Venkatesh</i>	
OFFICER / PRODIN. D&DO	<i>S. Venkatesh</i>	
AMENDMENTS & DATE	APPROVED ON. 5/2006	



ORDNANCE FACTORY
 TIRUCHIRAPPALI - 16.

DRG. NO. 44P 09002*2

DIMENSIONS ARE IN mm.

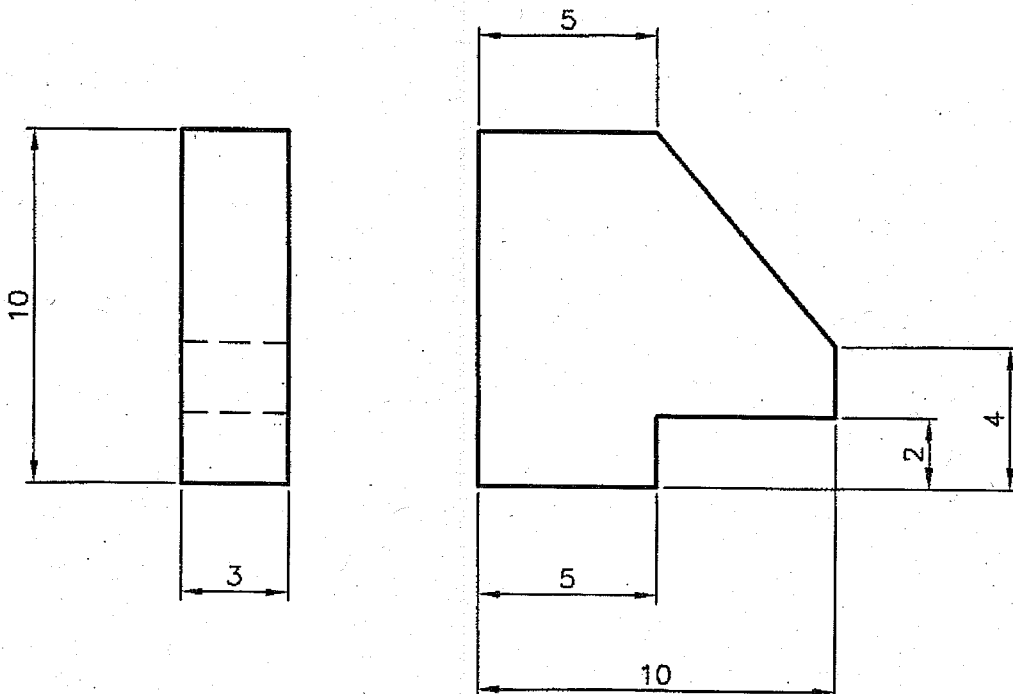
UN TOLERATED DIMNS. AS PER IS : 2102 (MED)

IMPORTANT DIMNS MKD THUS '⊕'.

'†' MARK DRAWING No.

SHARP CORNER'S TO BE BLUNT TO R0.2

44P 09002*




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 DRAWINGS AT THIS DATE. 23/02/21
 DESIGN & DRAWING OFFICE,
 ORDNANCE FACTORY, TIRUCHIRAPPALI - 620 016.

MATERIAL :- BS-970 Pt.-1-1983 Gr.080 M40(OR) En8

ALT. MATL:- IS:5517-1993 DESIGN 40 C8 (OR) 55C6
 HARDNESS: 26-32 HRC

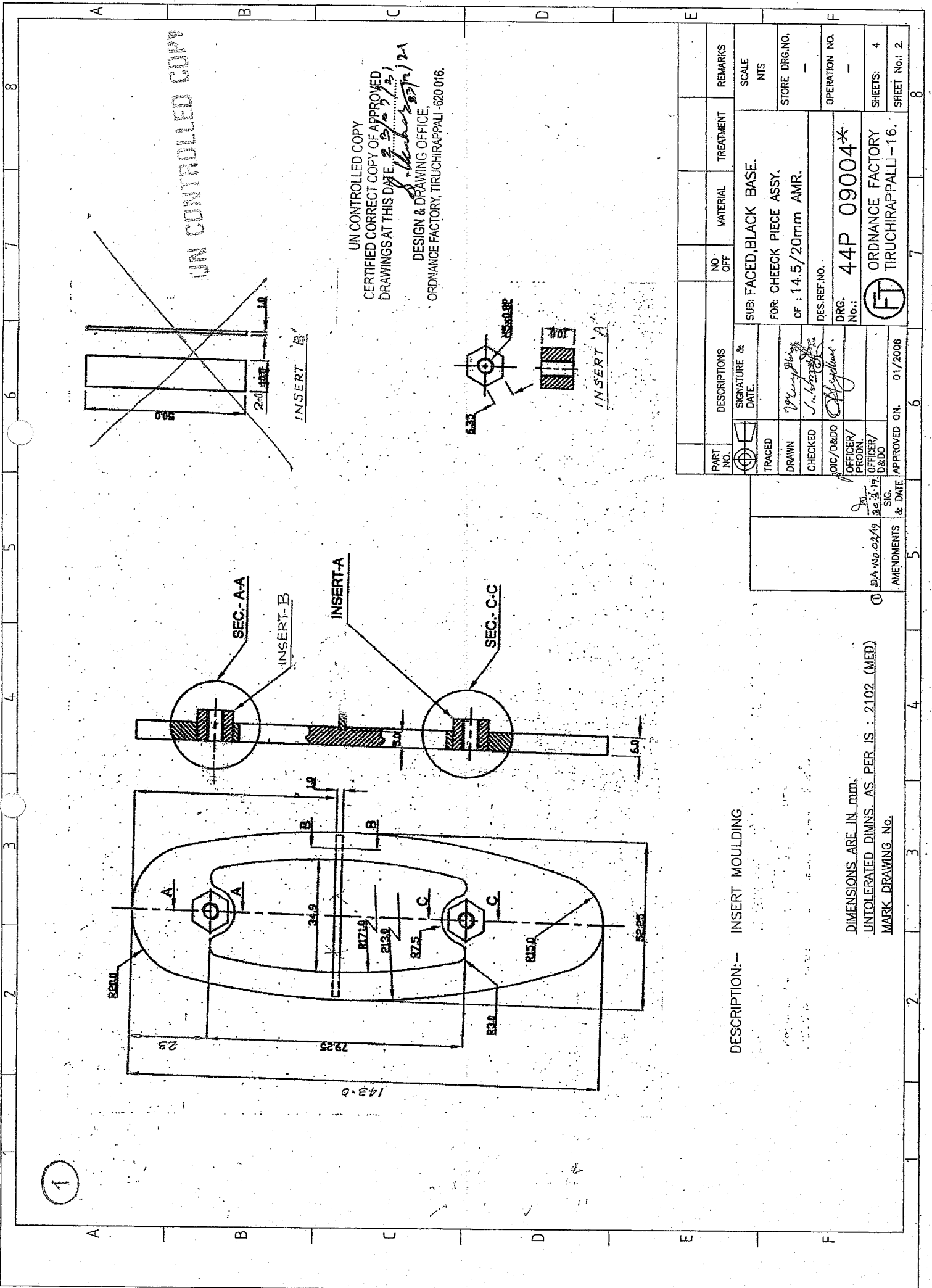
DRG. PROVISIONAL

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
⊕	SIGNATURE & DATE.	SUB: BOLT STOP.			SCALE NTS
TRACED		FOR: CHEEK PIECE ASSY.			STORE DRG.NO.
DRAWN	<i>V. Srinivas</i>	OF: 14.5/20MM AMR.			-
CHECKED	<i>S. Srinivas</i>	DES. REF. NO.			OPERATION NO.
OIC/D&DO	<i>A. Srinivas</i>	DRG. No.: 44P 09002*2			-
OFFICER/PRODN.		 ORDNANCE FACTORY TIRUCHIRAPPALI-16.			SHEETS: 1
OFFICER/D&DO					SHEET No.: 1
AMENDMENTS	SIG. & DATE	APPROVED ON.	02/2006		

DA. No. 018/21
 Dt. 10/07/21
 SL. No. 24
 DA. No. 002/19
 30.3.19

SIG. & DATE

APPROVED ON. 02/2006



PART NO.		DESCRIPTIONS		NO. OFF		MATERIAL		TREATMENT		REMARKS	
TRACED		SIGNATURE & DATE								SCALE	
DRAWN		20/03/15								NTS	
CHECKED		20/03/15								STORE DRG.NO.	
D/C/D&DO		20/03/15								OPERATION NO.	
OFFICER/PRODN.		20/03/15								SHEETS: 4	
OFFICER/D&DO		20/03/15								SHEET No.: 2	
APPROVED ON.		01/2006									
AMENDMENTS & DATE											
D.A. No. 02/19		20/03/15									
D.A. No. 09004*		ORDNANCE FACTORY									
D.A. No. 09004*		TIRUCHIRAPPALI-16.									

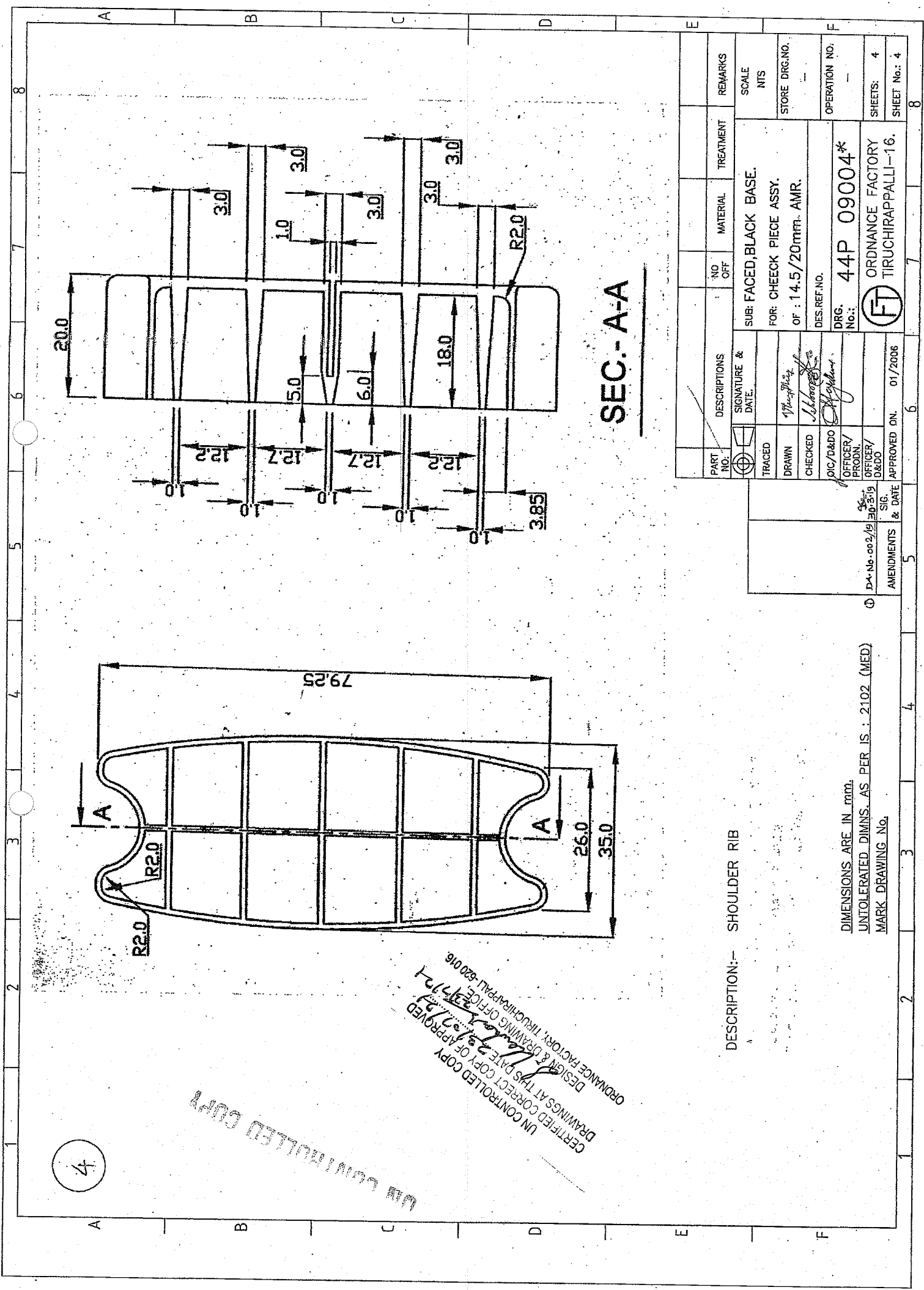
DESCRIPTION:- INSERT MOULDING

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

UN CONTROLLED COPY
 CERTIFIED CORRECT COPY OF APPROVED
 DRAWINGS AT THIS DATE 20/03/15
 DESIGN & DRAWING OFFICE
 ORDNANCE FACTORY, TIRUCHIRAPPALI-620 016.

UN CONTROLLED COPY

1



SEC.-A-A

DESCRIPTION:- SHOULDER RIB

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

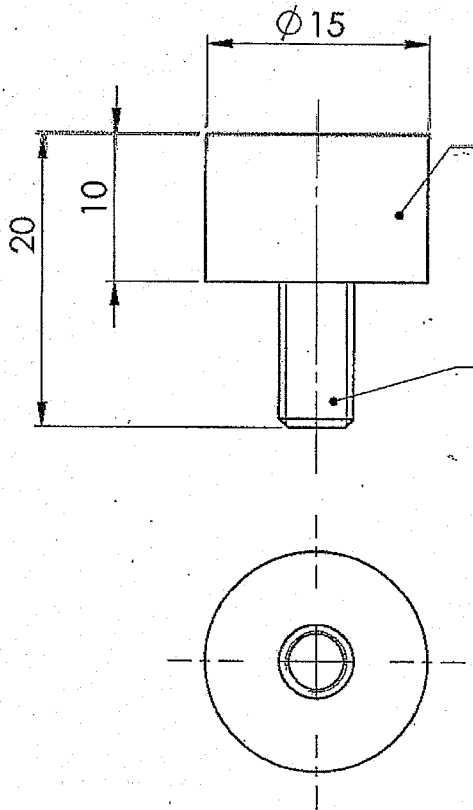
UN CONTROLLED COPY
 CERTIFIED CORRECT COPY OF APPROVED
 DRAWINGS AT THIS DATE 27/07/2006
 DESIGN & DRAWING OFFICE
 ORDNANCE FACTORY, TIRUCHIRAPPALLI-620 016

4

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
	SUB: FACED, BLACK BASE.				SCALE NTS
	FOR: CHECK PIECE ASSY.				STORE DRG.NO.
	OF: 14.5/20mm. AMR.				OPERATION NO.
	DES. REF. NO.				
	DRG. No.: 44P 09004*				SHEETS: 4
	ORDNANCE FACTORY TIRUCHIRAPPALLI-16.				SHEET No.: 4
	FT				
	SIGNATURE & DATE				
	TRACED				
	DRAWN				
	CHECKED				
	PICT/D&DO				
	OFFICER/PRODN.				
	OFFICER/D&DO				
	APPROVED ON: 01/2006				
	AMENDMENTS & DATE				
	P-4 No. -002/19				
	SIG 30/3/19				

DIMENSIONS ARE IN mm.

UN TOLERATED DIMNS. AS PER IS : 2102 (MED)



MATERIAL: 6 (OR) 66, GLASS FIBRE
 REINFORCED POLYAMIDE
COLOUR: BLACK MATT FINISH
MELTING POINT: NOT LESS THAN 200°C
 TO BE MOULDED ON STD. SCREW HEAD

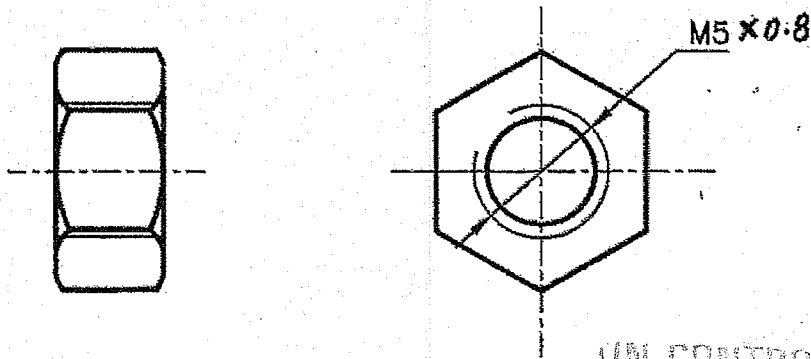
MATERIAL: IS:2269 2006 M5X10X0.8P
 12.9 HIGH TENSILE

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 DRAWINGS AT THIS DATE 23/02/21
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 ORDNANCE FACTORY, TIRUCHIRAPPALI - 620 016.

2	SCREW	1	REF.ABOVE	---	---
1	SOC.HEAD	1	REF.ABOVE	---	---
PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
	SIGNATURE & DATE.	SUB: SOC.HD.CAP SCREW			SCALE NTS
TRACED		FOR: CHEECK PIECE			STORE DRG.NO.
DRAWN		OF: 14.5/20 mm AMR			---
CHECKED		DES.REF.NO.			OPERATION NO.
HOS/D&DO		DRG. No.: 44P 09005			---
OFFICER/PRODN.		ORDNANCE FACTORY TIRUCHIRAPPALI-16.			SHEETS: 01
OFFICER/D&DO					SHEET No.: 01
AMENDMENTS	SIG. & DATE	APPROVED ON.			

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

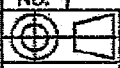



UN CONTROLLED COPY

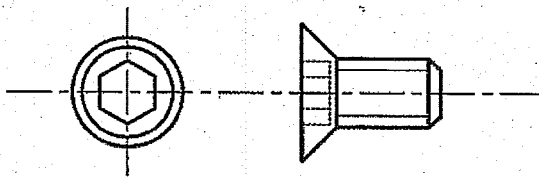
UN CONTROLLED COPY
 CERTIFIED CORRECT COPY OF APPROVED
 DRAWINGS AT THIS DATE 23/7/21
[Signature]
 DESIGN & DRAWING OFFICE,
 ORDNANCE FACTORY, TIRUCHIRAPPALI - 620 016.

USE STANDARD M5x0.8P IS:1363 Pt.2, 2002 HIGH TENSILE

DRG.PROVISIONAL

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
 TRACED DRAWN <i>[Signature]</i> CHECKED <i>[Signature]</i> OIC/D&DO <i>[Signature]</i> OFFICER/ PRODN. OFFICER/ D&DO	SIGNATURE & DATE.	SUB: NUT M5x0.8P			SCALE NTS
		FOR: CHEEK PIECE ASSY.			STORE DRG.NO.
		OF: 14.5mm/20mm AMR.			OPERATION NO.
		DES.REF.NO.			
		DRG. No.: 44P 09006			SHEETS: 1
AMENDMENTS	SIG. & DATE	 ORDNANCE FACTORY TIRUCHIRAPPALI-16.			SHEET No.: 1
	APPROVED ON. 08/05				




DIMENSIONS ARE IN mm.
 UNTOLERATED DIMNS. AS PER IS : 2102 (MED)

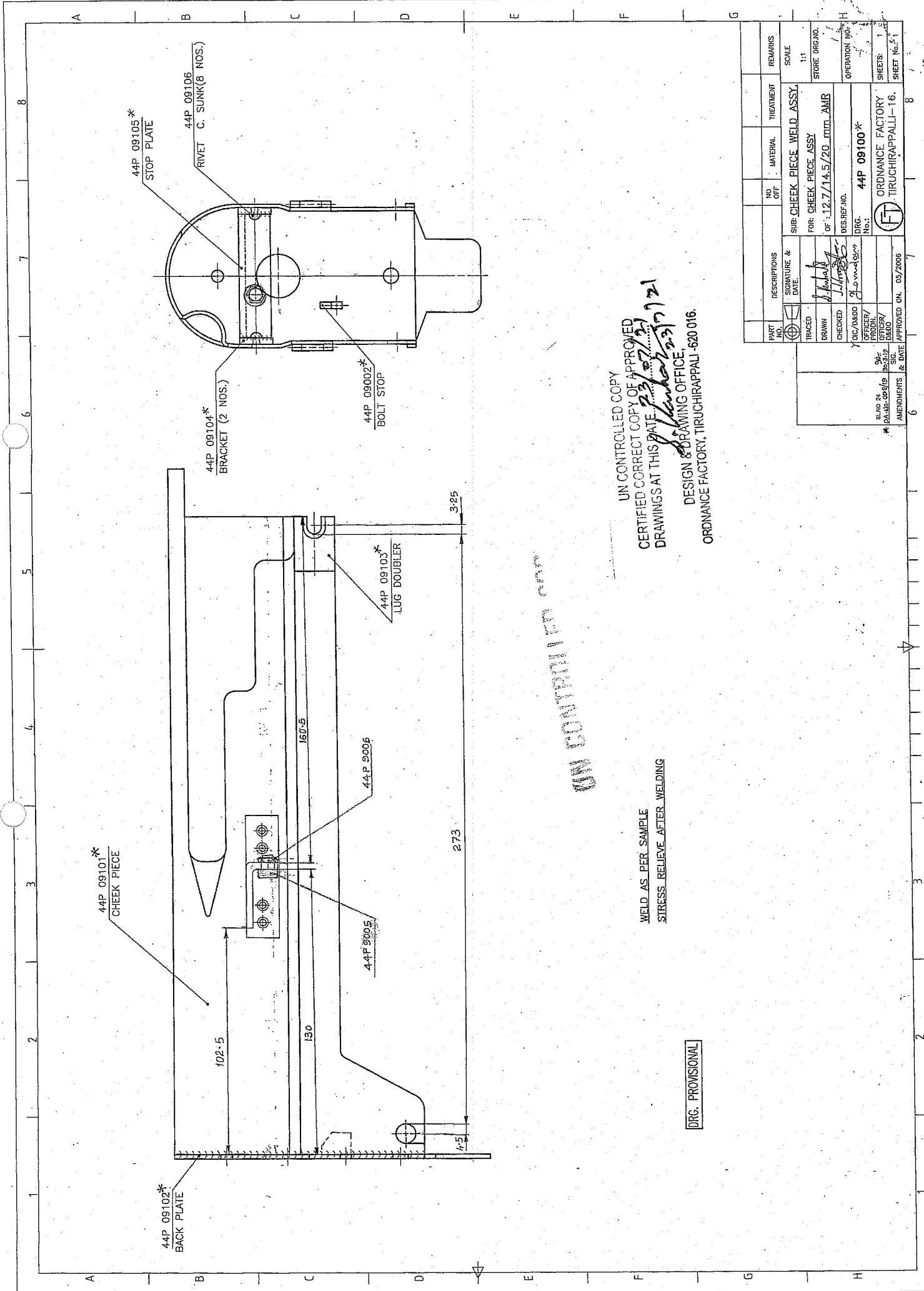


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 DRAWINGS AT THIS DATE: 23/07/21
S. Venkatesh
 DESIGN & DRAWING OFFICE,
 ORDNANCE FACTORY, TIRUCHIRAPPALI - 620 016.

STANDARD CSK. SOC. HD. CAP SCREW IS:6761-1994 M5 x 12 x 0.8 P 12.9 HIGH TENSILE

1	CSK. SOC. HD. CAP SCREW	1			
PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
	 	SIGNATURE & DATE.		SUB: CSK. SOC. HD. CAP SCREW	
	TRACED			SCALE NTS	
	DRAWN <i>AK</i>			FOR: CHEEK PIECE	
	CHECKED			OF: 14.5/20 mm AMR	
	HOS/DDO <i>AK</i>			DES. REF. NO.	
	OFFICER/ PRODN.			DRG. No.: 44P 09007	
	OFFICER/ D&DO			OPERATION NO.	
	APPROVED ON.			ORDNANCE FACTORY TIRUCHIRAPPALI-16.	
AMENDMENTS	SIG. & DATE			SHEETS: 01	
				SHEET No.: 01	



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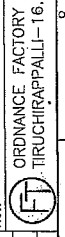
UN CONTROLLED COPY
 CERTIFIED CORRECT COPY OF APPROVED
 DRAWINGS AT THIS DATE 23/07/2019
(Signature)
 DESIGN & DRAWING OFFICE,
 ORDNANCE FACTORY, TIRUCHIRAPPALI - 620 016.

WELD AS PER SAMPLE
 STRESS RELIEVE AFTER WELDING

DRG. PROVISIONAL

PART NO.	DESCRIPTIONS	NO. OFF	MATERIAL	TREATMENT	REMARKS
	SUB. CHEEK PIECE WELD ASSY.				SCALE 1:1
	FOR CHEEK PIECE ASSY				STORE DRG. NO.
	OF : 12.7/14.5/20 mm AMR				OPERATION NO.
	DES. REF. NO.				SHEETS: 1
	DRG. No.: 44P 09100*				SHEET No.: 1
	OFFICER / PRODN.				
	OFFICER / SIG.				
	APPROVED ON: 05/2006				

SI No 24	04
DAL/05/09/19	15/3/12
AMENDMENTS & DATE	

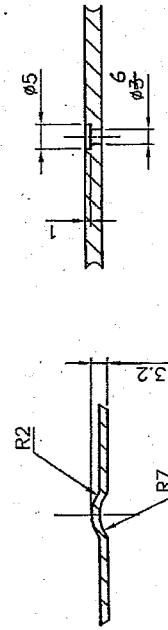
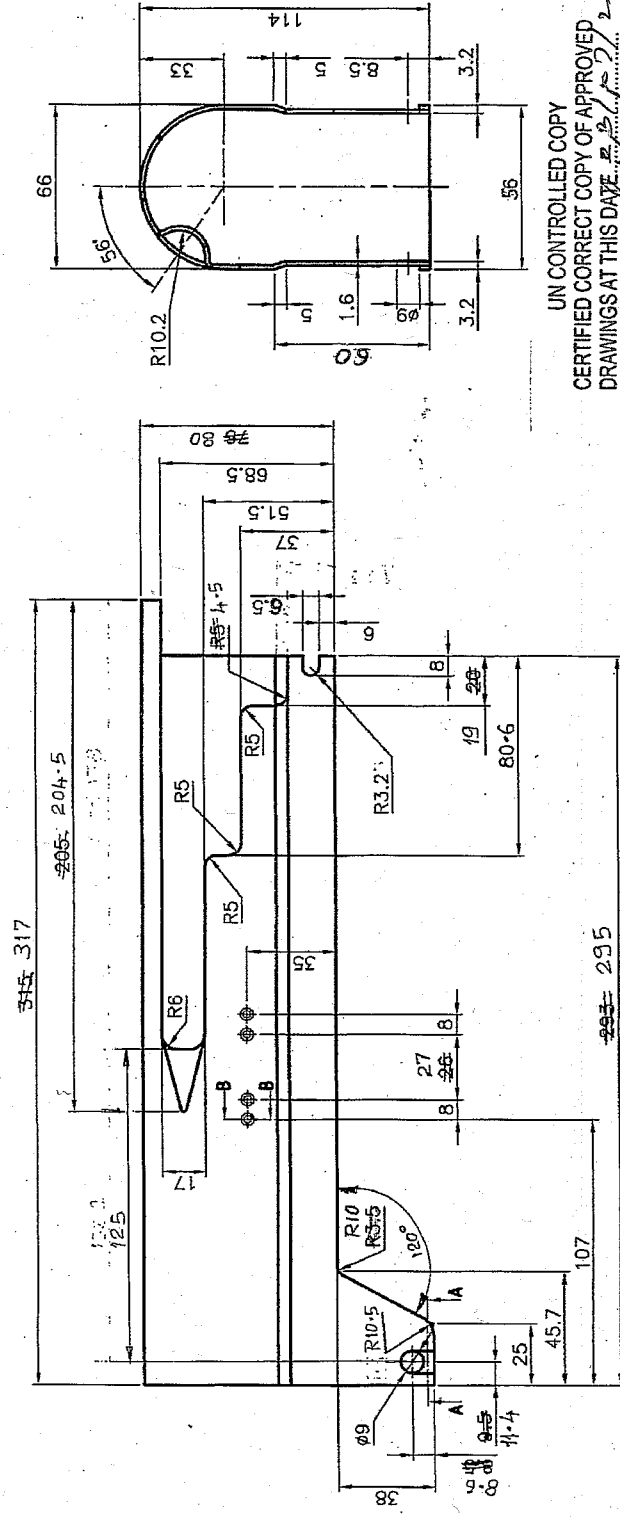


ORDNANCE FACTORY
 TIRUCHIRAPPALI - 16.

V. S. S. S. S.

44P 09101**

NOTE: DRG. PROVISIONAL
PRIOR SAMPLE MUST BE SUBMITTED AND GET
APPROVED BEFORE BULK SUPPLY.



SECTION-A-A SECTION-B-B

(ENLARGED VIEWS)

IMPORTANT DIMENSIONS MARKED THUS 'Φ'.
INFORMATION MARKED THUS 'T' TO BE MARKED ON GAUGE.
DIMENSIONS ARE IN mm.
INTOLERATED DIMS. AS PER IS : 2102 (MED).
T. MARK DRAWING NO.

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CERTIFIED CORRECT COPY OF APPROVED
DRAWINGS AT THIS DATE 23/02/21
S. Menon 33721
DESIGN & DRAWING OFFICE,
ORDNANCE FACTORY, TIRUCHIRAPPALI-620 016.

MATERIAL: IS: 2507-1975 GR.I DESIGN. 45C8
(OR) 55C6
HARDNESS: RC 35-40

MATERIAL: -1988
BS:1449 Pt-1 ACS-3, SEC.-2 (OR)
IS:513:1973 DD

PART NO.	DESCRIPTIONS & DATE.	NO. OFF.	MATERIAL	TREATMENT	REMARKS
	SUB: CHECK PIECE.				SCALE NTS
	FOR: CHECK PIECE ASSY.				STORE DRG.NO.
	OF: 14.5/20mm AMR.				OPERATOR NO.
	DES. REF. NO.				
	DRG. No.: 44P 09101*2				
	ORDNANCE FACTORY TIRUCHIRAPPALI-16				
	APPROVED ON: 02/2006				SHEETS: 01
					SHEET No.: 01

AMENDMENTS & DATE
S1 No. 01 30/3/19
D.A. No. 02/19
D.A. No. 02/19
SIC

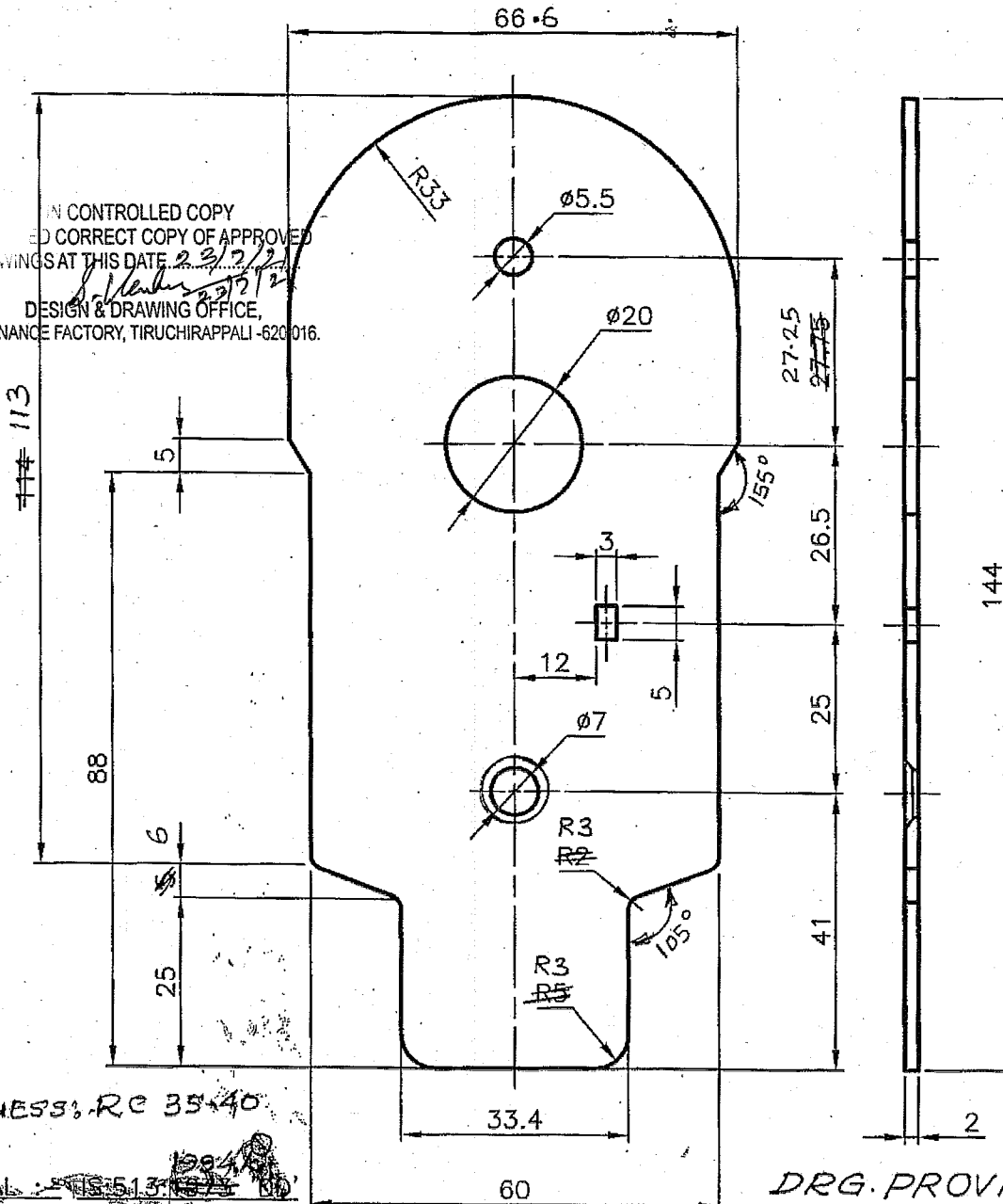


DRG. NO. 44P 09102*2

DIMENSIONS ARE IN mm.
 UNTOLERATED DIMNS. AS PER IS : 2102 (MED)
 IMPORTANT DIMNS MKD THUS'⊕'.
 '†' MARK DRAWING No.
 SHARP CORNER'S TO BE BLUNT TO R0.2

44P 09102*2

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 DRAWINGS AT THIS DATE 23/2/21
 DESIGN & DRAWING OFFICE,
 ORDNANCE FACTORY, TIRUCHIRAPPALI - 620 016.



HARDNESS: RC 35-40

MATERIAL: IS 513

DRG. PROVISIONAL

MATERIAL: IS: 2507-1975 G.I., DESIGN: AS CB (OR) 5506
 TEMPERATURE: 150°C

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
⊕	SIGNATURE & DATE.	SUB: BACK PLATE.			SCALE NTS
TRACED		FOR: CHEEK PIECE ASSY.			STORE DRG. NO.
DRAWN	<i>V. Srinivas</i>	OF: 14.5/20MM AMR.			-
CHECKED	<i>L. Srinivas</i>	DES. REF. NO.			OPERATION NO.
POIC/D&DO	<i>A. Srinivas</i>	DRG. No.: 44P 09102*2			-
OFFICER/PRODN.		ORDNANCE FACTORY TIRUCHIRAPPALI-16.			SHEETS: 1
OFFICER/D&DO					SHEET No.: 1
AMENDMENTS	SIG. & DATE	APPROVED ON.	02/2006		

DA No. 018/21
 Dt. 17/07/2021
 Sl. No. 24
 DA No. 002/19 30.3.19

SIG. & DATE

APPROVED ON. 02/2006

DRG. NO. 44P 09103 * 2

DIMENSIONS ARE IN mm.

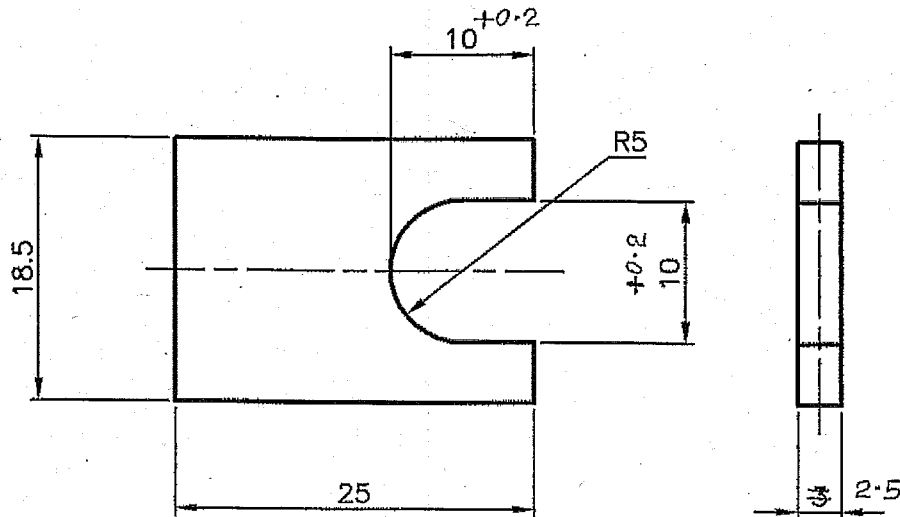
UNTOLERATED DIMNS. AS PER IS : 2102 (MED)

IMPORTANT DIMNS MKD THUS '⊕'.

'†' MARK DRAWING No.

SHARP CORNER'S TO BE BLUNT TO R0.2

44P 09103*



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DRAWINGS AT THIS DATE 23/7/21

DESIGN & DRAWING OFFICE,
ORDNANCE FACTORY, TIRUCHIRAPPALI - 620 016.

MATERIAL :- BS-970 Pt.-1-1983 Gr.080 M40 (EN8)

ALT. MATL: IS: 5517-1993, DESIGN 40 C8

HARDNESS: 26-32 HRC

DRG. PROVISIONAL

(OR) 55 C8

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
⊕	SIGNATURE & DATE.	SUB: LUG DOUBLER			SCALE NTS
TRACED		FOR: CHEEK PIECE WELD ASSY.			STORE DRG. NO.
DRAWN	<i>Prasanna</i>	OF: 14.5/20MM AMR.			-
CHECKED	<i>S. Narayana</i>	DES. REF. NO.			OPERATION NO.
QC/D&DO	<i>S. Narayana</i>	DRG. No.: 44P 09103*2			-
OFFICER/PRDN.		ORDNANCE FACTORY TIRUCHIRAPPALI-16.			SHEETS: 1
OFFICER/D&DO					SHEET No.: 1
AMENDMENTS	SIG. & DATE	APPROVED ON.	02/2006		

DA No. 012/29
Dt. 10/7/21
Sl. No. 24
DA No. 002/19
30.3.19

SIG. & DATE

APPROVED ON. 02/2006

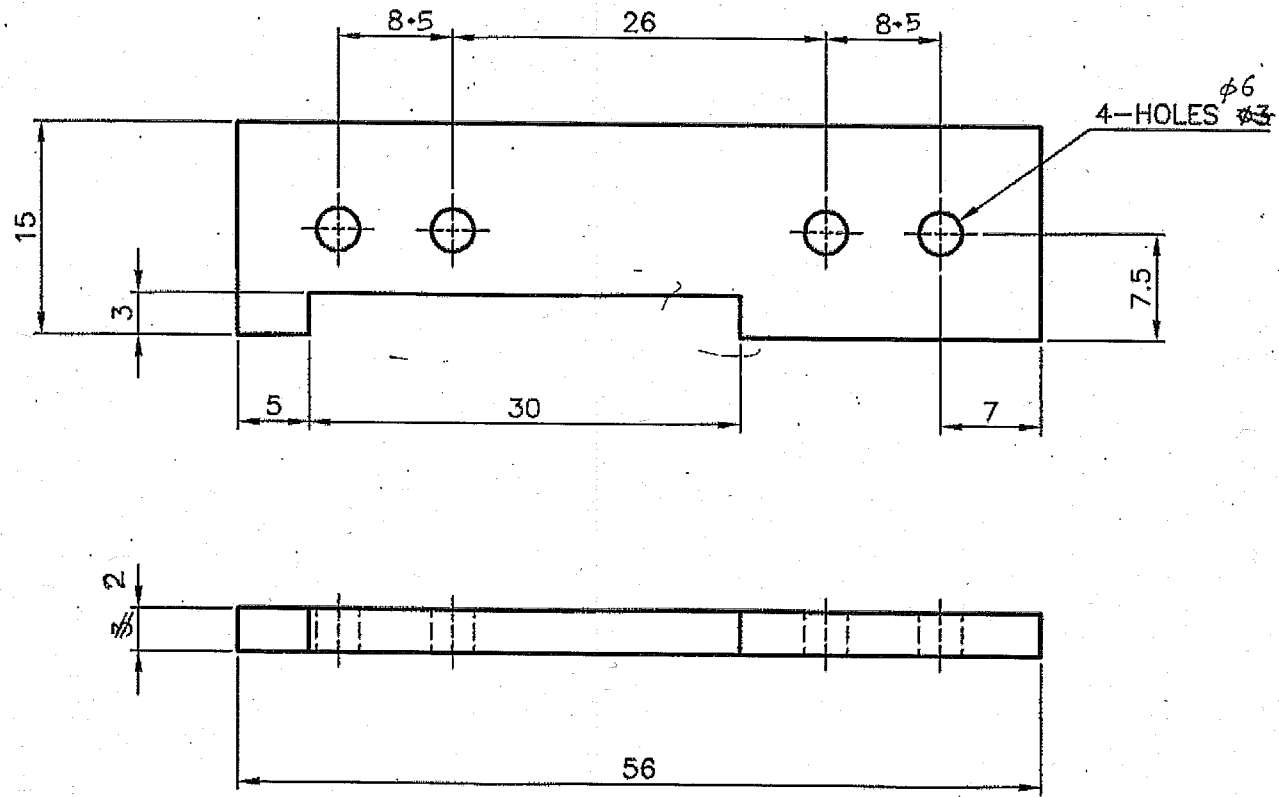


ORDNANCE FACTORY
TIRUCHIRAPPALI-16.

DRG. NO. 44P 09104*

DIMENSIONS ARE IN mm.
 UNTOLERATED DIMNS. AS PER IS : 2102 (MED)
 IMPORTANT DIMNS MKD THUS '⊕'.
 '†' MARK DRAWING No.
 SHARP CORNER'S TO BE BLUNT TO R0.2

†
 44P 09104*



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DESIGN & DRAWING OFFICE,
 ORDNANCE FACTORY, TIRUCHIRAPPALI - 620 016.

DRG. PROVISIONAL

MATERIAL :- BS-970 Pt.-1-1983 Gr.080 M40 (En8)

ALT. MATL: IS : 5517-1993, DESIGN 40 CB-⊕ (OR) 55CB
 HARDNESS: 16-32 HRC

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
	SIGNATURE & DATE.	SUB: BRACKET.			SCALE NTS
	TRACED	FOR: CHEEK PIECE WELD ASSY.			STORE DRG.NO.
	DRAWN <i>V. Srinivas</i>	OF: 14.5/20MM AMR.			-
	CHECKED <i>S. Subramanian</i>	DES. REF. NO.			OPERATION NO.
	OIC/D&DO <i>S. Subramanian</i>	DRG. No.: 44P 09104*2			-
	OFFICER/PRODN.	ORDNANCE FACTORY TIRUCHIRAPPALLI-16.			SHEETS: 1
	OFFICER/D&DO				SHEET No.: 1
AMENDMENTS	SIG. & DATE	APPROVED ON.	02/2006		

DA. No. 011/21
 DE. 10/7/21
 SI. No. 44
 DA. No. 002/19

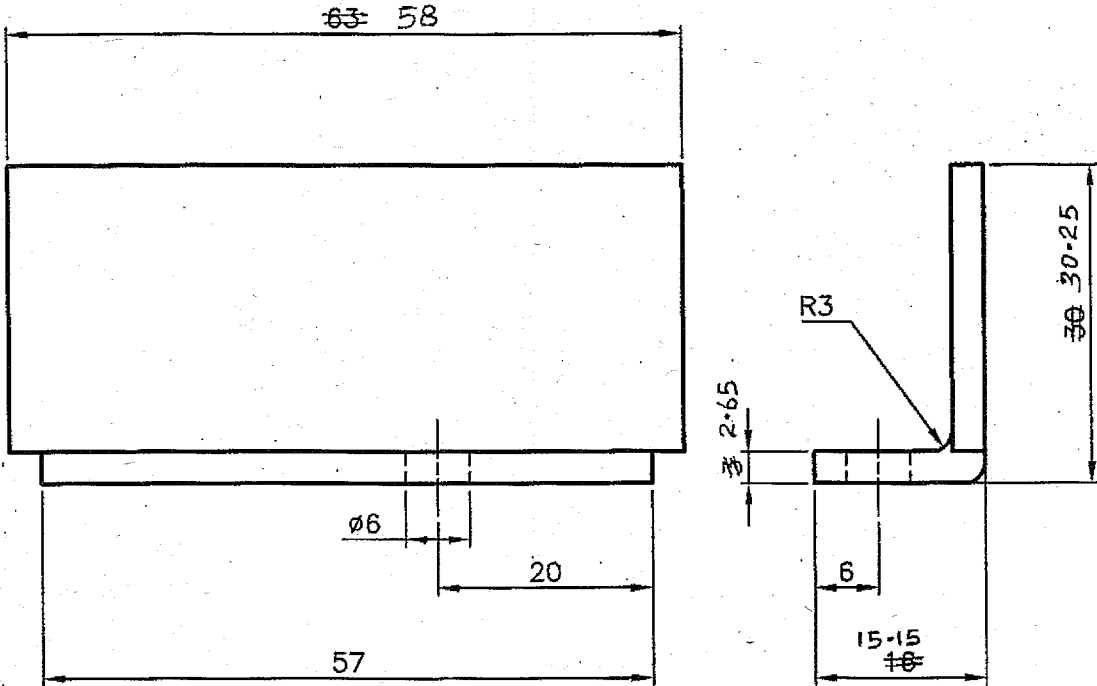
S. Subramanian
 30.3.19

①

DRG. NO. 44P 09105 * 2

DIMENSIONS ARE IN mm.
 UNTOLERATED DIMNS. AS PER IS : 2102 (MED)
 IMPORTANT DIMNS MKD THUS '⊕'.
 '†' MARK DRAWING No.
 SHARP CORNER'S TO BE BLUNT TO R0.2

44P 09105*



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 ORDNANCE FACTORY, TIRUCHIRAPPALI - 620 016.

DRG. PROVISIONAL

MATERIAL :- BS-970 Pt.-1-1983 Gr.080 M40 (EN-8)
 ALT. MATL: IS:5517-1993, DESIGN. 40 C8 (OR) 55C8
 HARDNESS: 26-32 HRC

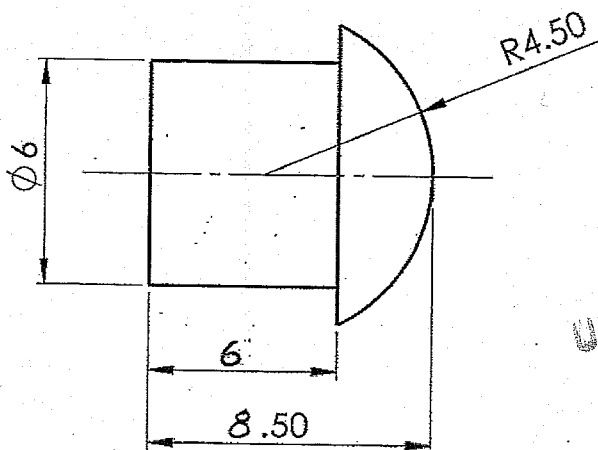
PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
	SIGNATURE & DATE.	SUB: STOP PLATE.			SCALE NTS
	TRACED	FOR: CHEEK PIECE WELD ASSY.			STORE DRG.NO.
	DRAWN <i>V. Venkatesh</i>	OF: 14.5/20MM AMR.			" -
	CHECKED <i>L. Lakshmi</i>	DES. REF. NO.			OPERATION NO.
	DIC/D&DO <i>A. Jayalaxmi</i>	DRG. No.: 44P 09105 * 2			-
	OFFICER/PRODN.	ORDNANCE FACTORY TIRUCHIRAPPALLI-16.			SHEETS: 1
	OFFICER/D&DO				SHEET No.: 1
AMENDMENTS	SIG. & DATE	APPROVED ON.	02/2006		

DA. NO. 010/2/19/21
 DC. 16/7/21
 ST. No. 44
 DA. NO. 002/19/30.3.19

①

DIMENSIONS ARE IN mm.
 UNTOLERATED DIMENSIONS AS PER IS:2102(MED)

PROTECTIVE FINISH :- PHOSPATED TO SPEC:
 JSS:0465-01-1988 CLASS-I (ACCELERATED) OIL FINISH.




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 DRAWINGS AT THIS DATE 23/02/21
S. Shankar
 DESIGN & DRAWING OFFICE,
 ORDNANCE FACTORY, TIRUCHIRAPPALI - 620 016.

MATERIAL:-
 BS 970 PT. 1 1983 GR. 709 M40 (EN19) OR
 BS 970 PT. 1 1983 GR. 708 M40 (EN19A) OR
 IS : 5517-1993 DESIGN. 50C8 LRS-30mm

HARDNESS:- 26 To 32 HRC

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
		01			
	SIGNATURE & DATE. TRACED DRAWN <i>A. A.</i> CHECKED HOS/D&DO <i>[Signature]</i> OFFICER/PROJECT OFFICER/D&DO		SUB: RIVET, C.SUNK FOR: CHEECK PIECE ASSY. OF: 14.5/20 mm AMR DES. REF. NO. DRG. No.: 44P 09106		SCALE NTS STORE DRG. NO. OPERATION NO.
AMENDMENTS	SIG. & DATE	APPROVED ON. 25.04.2019 		ORDNANCE FACTORY TIRUCHIRAPPALI-16. SHEETS: 1 SHEET No.: 1	