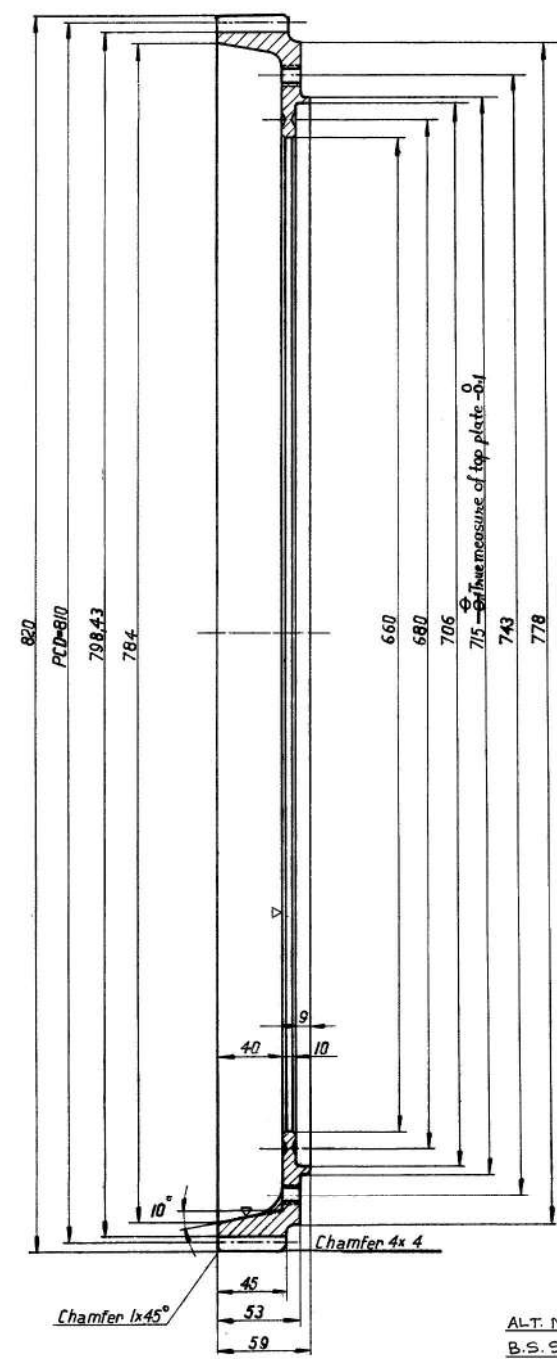
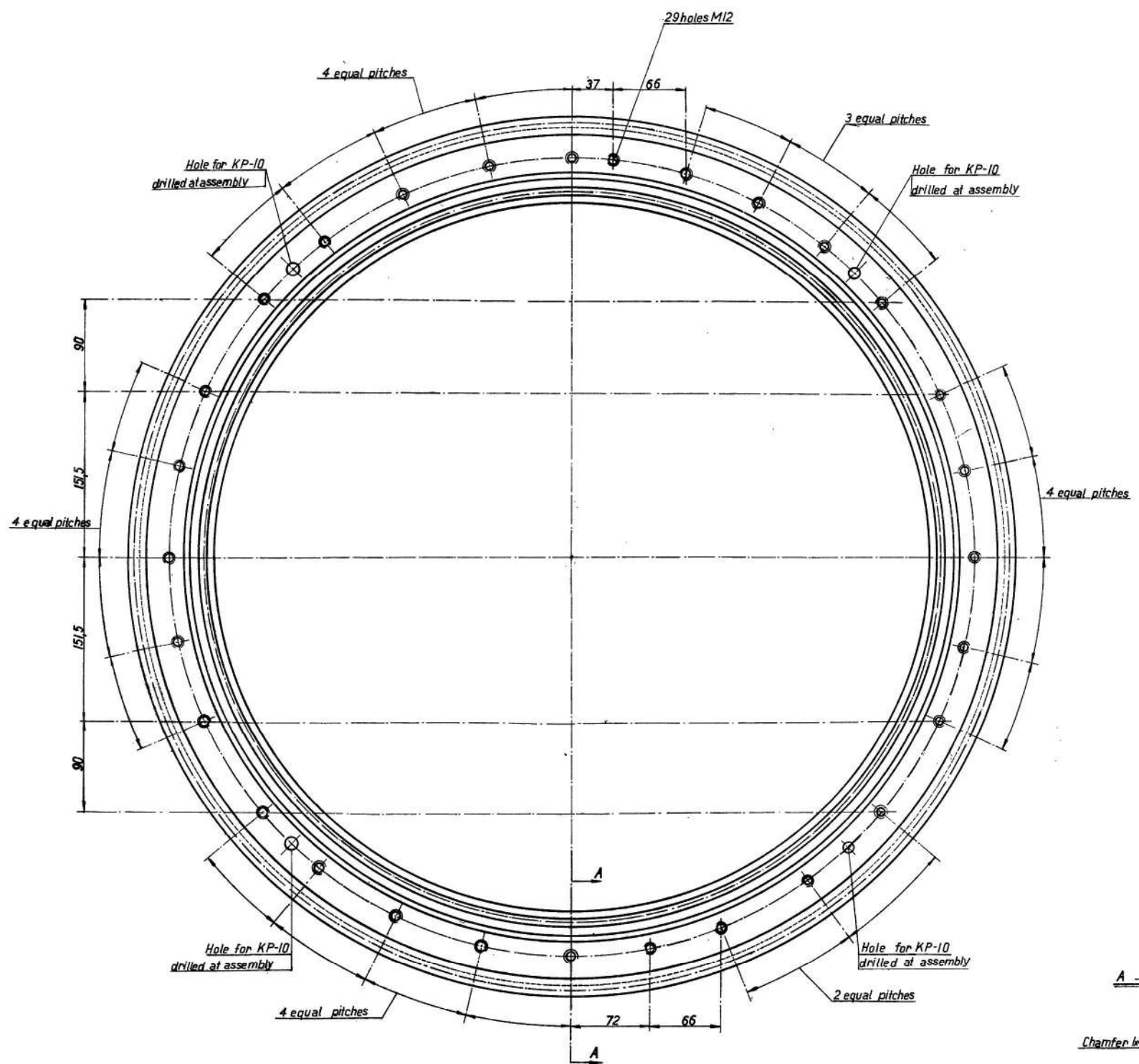
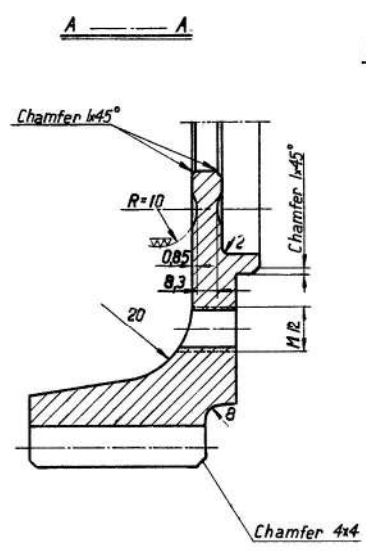


7776-W 17-11-60	DRG SEALED PROV				
PREV D C No 10981-W & 12709-W / DATE 28-10-69					
15441-W 13-12-79	ALT. MATL. AMENDED.				
17020-W 21-2-91	ALT. MATL. AMENDED.				



Module = 5  
 Number of teeth = 162  
 P.C.D. = 810  
 Pressure angle = 20°



ALT. MATL. :-  
 B.S. 970 Pt 1, 1983, GR 835 M 30  
 HEAT TREATED TO ACHIEVE THE FOLLOWING PROPERTIES  
 UTS = 115 Kg/mm<sup>2</sup> (MIN)  
 0.2% PROOF STRESS = 95 Kg/mm<sup>2</sup> (MIN)  
 ELONGATION = 12% (WITH GAUGE LENGTH 5.65√S<sub>0</sub>)  
 HARDNESS = HB 350-380

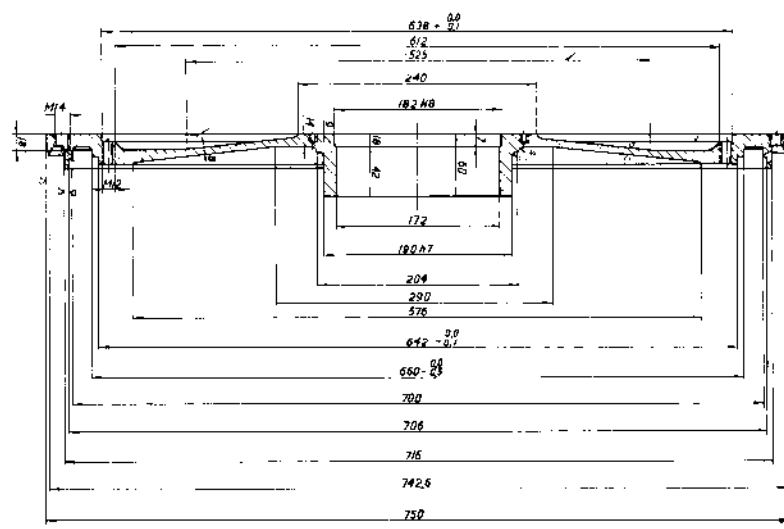
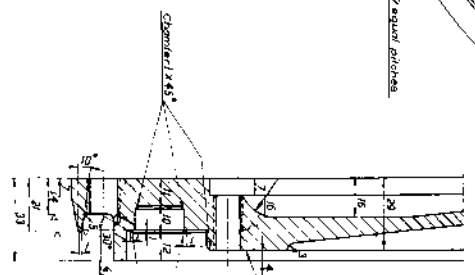
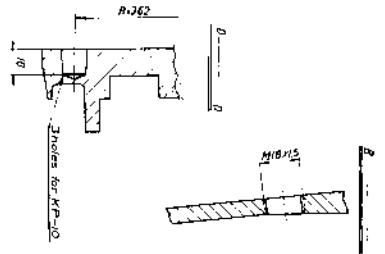
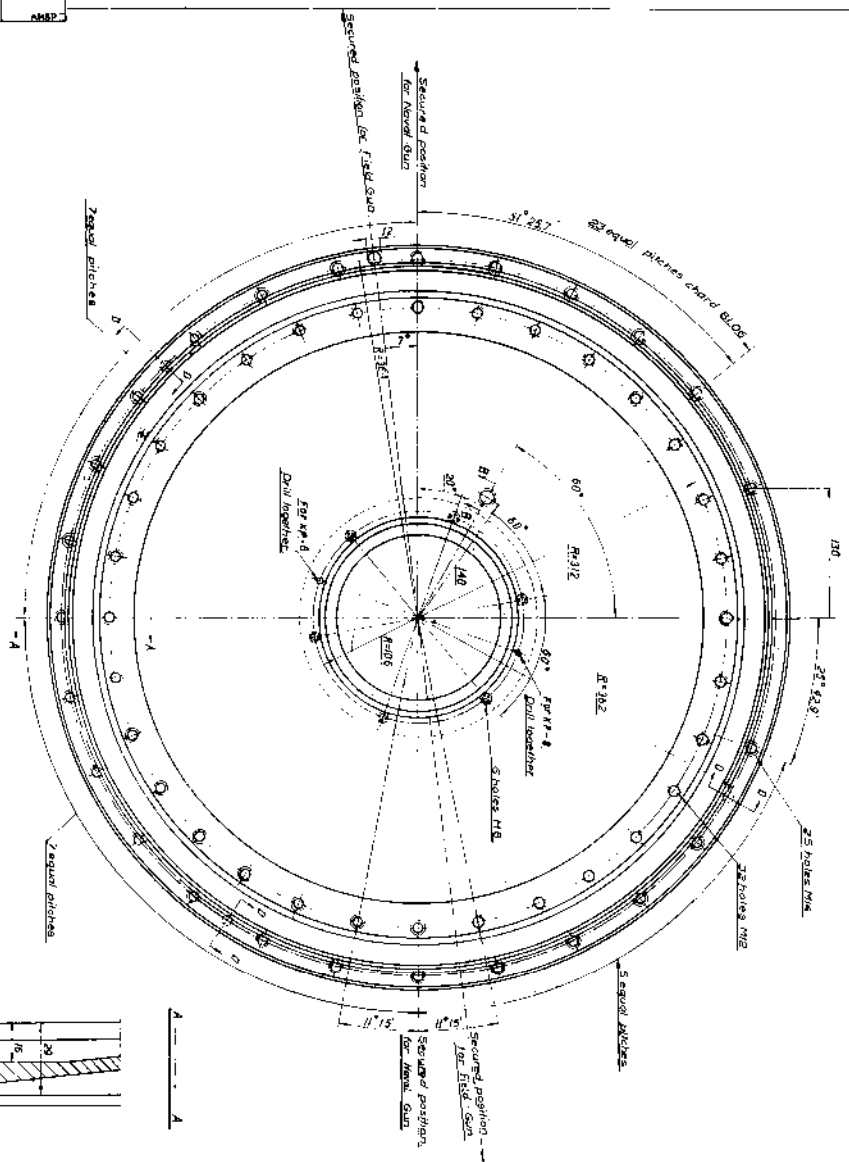
SURFACE TREATMENT TO SPEC Y051

40 MM A.A. GUN L/70 Mounting body		Rack	रैक	NR75	To be hardened and tempered to H <sub>350-380</sub>
5-937	1/2				
				3013787	

28-10-79 DILAPIDATED CL NEG REPLACED  
 CHECKED CHIEF D/MAN  
 28-10-79



16-3-78	UNLAPIMATED CL WEB REPLACED
Checked	By: MAN DO AND



To be ground at assembly to give max. clearance in the bolt bearing

Spot on to bolt nose

Surface treatment Y202-1-302

252 surfaces not specified

Part	Qty	Part No.	Description	Rev.	Date
7	1	3014767-2	SHG SEALER	1	18/18
8	1	3014767-3	25 HOLE DIA 1/2\"/>		
9	1	3014767-4	25 HOLE DIA 1/2\"/>		
10	1	3014767-5	25 HOLE DIA 1/2\"/>		
11	1	3014767-6	25 HOLE DIA 1/2\"/>		
12	1	3014767-7	25 HOLE DIA 1/2\"/>		
13	1	3014767-8	25 HOLE DIA 1/2\"/>		
14	1	3014767-9	25 HOLE DIA 1/2\"/>		
15	1	3014767-10	25 HOLE DIA 1/2\"/>		
16	1	3014767-11	25 HOLE DIA 1/2\"/>		
17	1	3014767-12	25 HOLE DIA 1/2\"/>		
18	1	3014767-13	25 HOLE DIA 1/2\"/>		
19	1	3014767-14	25 HOLE DIA 1/2\"/>		
20	1	3014767-15	25 HOLE DIA 1/2\"/>		
21	1	3014767-16	25 HOLE DIA 1/2\"/>		
22	1	3014767-17	25 HOLE DIA 1/2\"/>		
23	1	3014767-18	25 HOLE DIA 1/2\"/>		
24	1	3014767-19	25 HOLE DIA 1/2\"/>		
25	1	3014767-20	25 HOLE DIA 1/2\"/>		
26	1	3014767-21	25 HOLE DIA 1/2\"/>		
27	1	3014767-22	25 HOLE DIA 1/2\"/>		
28	1	3014767-23	25 HOLE DIA 1/2\"/>		
29	1	3014767-24	25 HOLE DIA 1/2\"/>		
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42	1	3014767-37	25 HOLE DIA 1/2\"/>		
43	1	3014767-38	25 HOLE DIA 1/2\"/>		
44	1	3014767-39	25 HOLE DIA 1/2\"/>		
45	1	3014767-40	25 HOLE DIA 1/2\"/>		
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97	1	3014767-92	25 HOLE DIA 1/2\"/>		
98	1	3014767-93	25 HOLE DIA 1/2\"/>		
99	1	3014767-94	25 HOLE DIA 1/2\"/>		
100	1	3014767-95	25 HOLE DIA 1/2\"/>		

**SUPERSEDES 3014767-2**

AT MAIL - STEEL BS 820 PL 13 BS 827 MAND  
 AT SURFACE TREATMENT TO SPEC Y202

Part	Qty	Part No.	Description	Rev.	Date
1	1	3014767-1	FLANGE FOR KP-10	1	18/18
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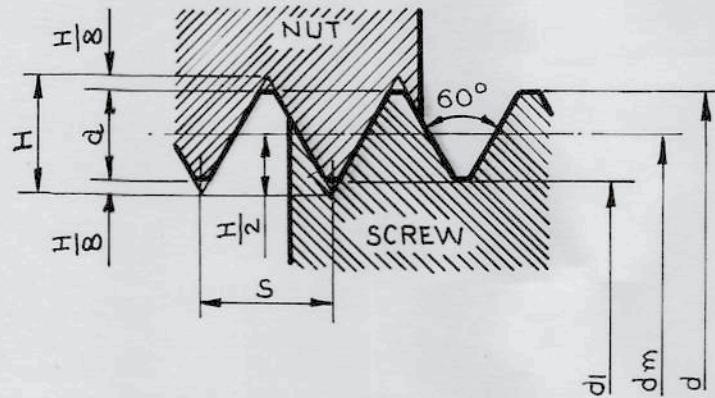








S = 4  
H = 3.464  
a = 2.328  
d<sub>m</sub> = d - a  
d<sub>i</sub> = d - 2a



ROUNDED BOTTOM OF THE THREADS IS ALSO PERMITTED

THREAD ACCORDING TO THIS TAB ARE DESIGNATED

Md x S E x M 125 x 4

DIMENSIONS LISTED CORRESPOND TO SMS - 185 A

d	d <sub>i</sub>	d <sub>m</sub>
* 56	50.804	53.402
58	52.804	55.402
* 60	54.804	57.402
62	56.804	59.402
* 64	58.804	61.402
65	59.804	62.402
* 68	62.804	65.402
70	64.804	67.402
* 72	66.804	69.402
75	69.804	72.402
* 76	70.804	73.402
78	72.804	75.402
* 80	74.804	77.402
82	76.804	79.402
85	79.804	82.402
88	82.804	85.402
90	84.804	87.402
92	86.804	89.402
96	89.804	92.402
98	92.804	95.402
100	94.804	97.402
105	99.804	102.402
110	104.804	107.402
115	109.804	112.402
120	114.804	117.402
125	119.804	122.402
130	124.804	127.402
135	129.804	132.402
140	134.804	137.402
145	139.804	142.402
150	144.804	147.402

d	d <sub>i</sub>	d <sub>m</sub>
155	149.804	152.402
160	154.804	157.402
165	159.804	162.402
170	164.804	167.402
175	169.804	172.402
180	174.804	177.402
185	179.804	182.402
190	184.804	187.402
195	189.804	192.402
200	194.804	197.402
210	204.804	207.402
220	214.804	217.402
230	224.804	227.402
240	234.804	237.402
250	244.804	247.402
260	254.804	257.402
270	264.804	267.402
280	274.804	277.402
290	284.804	287.402
300	294.804	297.402
310	304.804	307.402
320	314.804	317.402
330	324.804	327.402
340	334.804	337.402
350	344.804	347.402
360	354.804	357.402
370	364.804	367.402
380	374.804	377.402
390	384.804	387.402
400	394.804	397.402

TRACED AT CGA(W) JABALPUR	G.P. Srinivasulu C/D MAN				
	CHECKED				
	TRACED	29-9-04	18883-W	HINDI NOMEN ADDED	
	DATE	15-10-02		RETRACED WITHOUT CHANGE	
	AUTHORITY		NATURE	SIG DO	SIG AHSP
DRG SEALED <b>PROV:-</b> DC No. 7507-W/DT-22-12-59					



AKTIEBOLAGET

BOFORS

KKD/

**SCREW COUNTERSUNK HEAD**

**FS M THREAD AS PER N2-1**

स्क्र काउंटरसंक हेड

एफ एस, एम- थ्रेड हेस पर एन 2-1

REG 16 14 3

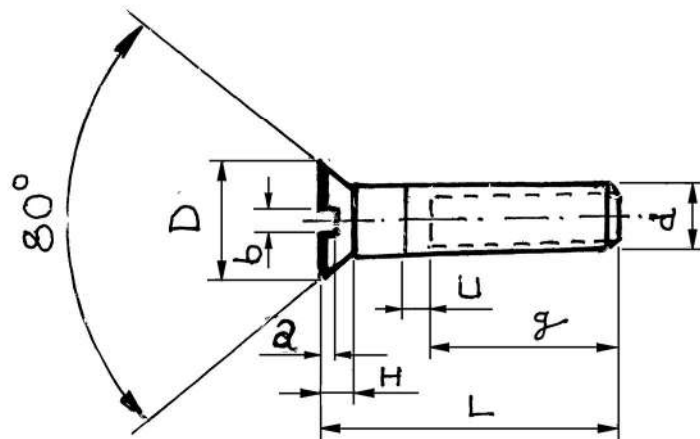
GR 20 N2-29

DATUM 5-6-1948

BLAD<sub>1</sub> NR

In

D	4	5.5	7	9	11	14	18	22	28	35	42
H	1.1	1.6	1.9	2.5	3.1	3.7	4.9	6.1	7.3	9.1	10.9
a	0.6	0.8	1	1.2	1.5	1.8	2.4	3	3.5	4.5	5
b	0.6	0.8	1	1.2	1.2	1.8	1.8	2.5	3	4	5
d	2.3	3	4	5	6	8	10	12	16	20	24



L g	L g	L g	L g	L g	L g	L g	L g	L g	L g	L g	L g
3 X	4 X	5 X	6 X	8 X	10 X	12 X	14 X	19 X	22 X	25 X	
4 X	5 X	6 X	8 X	10 X	12 X	14 X	16 X	19 X	22 X	25 X	30 X
5 X	6 X	8 X	10 X	12 X	14 X	16 X	19 X	22 X	25 X	30 X	35 X
6 X	8 X	10 X	12 X	14 X	16 X	19 X	22 X	25 X	30 X	35 X	40 X
8 X	10 X	12 X	14 X	16 X	19 X	22 X	25 X	30 X	35 X	40 X	45 X
10 X	12 X	14 X	16 X	19 X	22 X	25 X	30 X	35 X	40 X	45 X	50 X
12 8	14 X	16 X	19 X	22 X	25 X	30 X	35 X	40 X	45 X	50 X	55 X
	16 12	19 X	22 X	25 X	30 X	35 X	40 X	45 X	50 X	55 X	60 X
		22 16	25 19	30 19	35 22	40 25	45 30	55 35	60 40	65 X	
			30 19	35 19	40 22	45 25	50 30	60 35	65 40	70 X	
			35 19	40 19	45 22	50 25	55 30	65 35	70 40	75 50	
				45 19	50 22	55 25	60 30	70 35	75 40	80 50	
				50 19	55 22	60 25	65 30	75 35	80 40	90 60	
				60 22	65 25	70 30	80 35	90 50	100 60		
					70 25	75 30	90 45	100 50	110 60		
					75 25	90 30	100 45	110 50	120 60		
							110 45	120 50	130 60		

NOTE:- FS-8x19 USED WITH IAN 41 A WILL BE OF MATL. BRASS TO SPEC. BS 2874 CZ 115 COLD-WORKED & STRESS RELIEVED.

DESIGNATION:- FS-d x L  
 EXAMPLE :- FS-12 x 50

U-THREAD RUN-OUT  
 X- FULL THREADED SCREW

MANUFACTURED IN TOLERANCE CLASS '1'  
 COLD-PRESSED OR TURNED SEE TABLE N2-82.

MATERIAL IN DURABILITY CLASS D 60  
 DIMENSIONS CONFORM WITH SMG-20

UNDERLINED DIMENSIONS FX AB  
 BOFORS STOCK.

GALVANISING TO BOFORS SPECIFICATION Y053.

FOR HOLES, SERIES 1

2.5	3.2	4.3	5.3	6.4	8.4	10.5	13	17	21	25
-----	-----	-----	-----	-----	-----	------	----	----	----	----

ALT MATL:- BS 970 Pt-1: 1983, 080 M40 (NORMALISED)

24-3-98 RETRACED WITHOUT CHANGE

18-01-18	19644-W	NOMENCLATURE AMENDED.		
29-09-04	18883-W	HINDI NOMEN ADDED		
		PREV DC Nos:- 7507-W, 9517-W, 13821-W, 15302-W & 17161-W DT. 5-12-91		
DATE	AUTHORITY	NATURE	SIG AHSP	SIG DO
DRG SEALED:- DC No 7507-W DATE:- 22-12-59 DOC QA(W)				

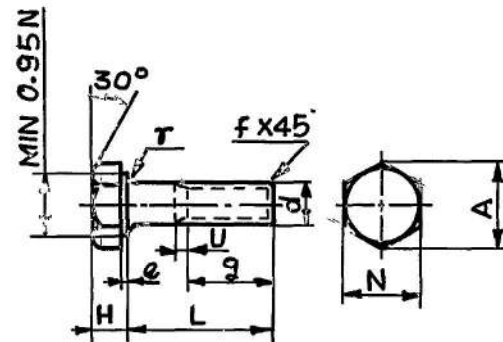
PART No.

N2-71

DIMENSIONS ARE IN mm.

AKTIEBOLAGET  
BOFORS

16.14.1

BLAD NR  
1PORTS PA  
BLAD NR

DESIGNATION:- B6LS-d x L D80

(PREVIOUS DESIGNATION BOFO-80-d x L)

EXAMPLE:- B6LS-6 x 35 D80

G=WEIGHT OF HEAD IN GRAMMES

U=THREAD RUN OUT

X=FULL THREADED SCREW

MANUFACTURED IN TOLERANCE CLASS 1, COLD PRESSED,

SEE TABLE N2-82

MATERIAL IN DURABILITY CLASS D80

DIMENSIONS CONFORM WITH SMS 1414

UNDERLINED DIMENSIONS EX-AB BOFORS STOCK

"GALVANISING TO BOFORS SPECIFICATION Y054"

G	0.2	0.4	0.9	2.0	2.6	7.7	13.5	20	28	39	75	112
N	4	5	7	8	10	12	15	18	21	24	30	34
A	4.6	5.8	8.0	9.2	11.5	13.8	17.3	20.8	24.2	27.7	34.6	39.2
H	1.6	2	2.2	3.5	4.2	5.5	7	8	9	11	13	16
e				0.2	0.3	0.4	0.4	0.4	0.4	0.4	0.4	0.5
f	0.4	0.5	0.8	0.8	1	1.2	1.5	2	2	3	2.5	3
r	0.2	0.2	0.2	0.2	0.3	0.3	0.3	0.5	0.5	0.8	1	1.5
d	2.3	3	4	5	6	8	10	12	14	16	20	24

L	g	L	g	L	g	L	g	L	g	L	g	L	g	L	g	L	g	L	g				
4	X	4	X	6	X	8	X	10	X	12	X	14	X	19	X	16	X	25	X	35	X	50	X
5	X	5	X	8	X	10	X	12	X	14	X	16	X	22	X	19	X	30	X	40	X	55	X
6	X	6	X	10	X	12	X	14	X	16	X	19	X	25	X	22	X	35	X	45	X	60	X
8	X	8	X	12	X	14	X	16	X	19	X	22	X	30	X	25	X	40	X	50	X	65	50
10	8	10	X	14	X	16	X	19	X	22	X	25	X	35	X	30	X	45	35	55	40	70	50
12	8	12	X	16	X	19	X	22	X	25	X	30	X	40	30	35	30	50	35	60	40	75	50
14	8	14	X	19	16	22	X	25	19	30	22	35	25	45	30	40	30	55	35	65	40	80	50
16	8	16	12	22	16	25	19	30	19	35	22	40	25	50	30	45	30	60	35	70	40	85	60
19	8	19	12	25	16	30	19	35	19	40	22	45	25	55	30	50	30	65	35	75	40	100	60
22	8	22	12	30	16	35	19	40	19	45	22	50	25	60	30	55	30	70	35	80	40	110	60
25	8	25	12	35	16	40	19	45	10	50	22	55	25	65	30	60	30	75	35	90	50	120	60
30	8	30	12	40	16	45	19	50	19	55	22	60	25	70	30	65	30	80	35	100	35	120	60
35	8	35	12	45	16	50	19	55	19	60	22	65	25	75	30	70	30	90	45	110	50	140	60
40	8	40	12	50	16	55	19	60	19	65	22	70	25	80	30	75	30	100	45	120	50	150	60
45	8	45	12	55	16	60	19	65	19	70	22	75	25	90	40	80	30	110	45	130	50	160	60
50	8	50	12	60	16	65	19	70	19	75	22	80	25	100	40	90	30	120	45	140	50	180	80
55	8	55	12	65	16	70	19	75	19	80	22	90	35	110	40	100	45	130	50	150	50	200	80
60	8	60	12	70	16	75	19	80	19	90	30	100	35	120	40	110	40	140	45	160	50		

29-9-04 18883-W HINDI NOMEN ADDED

29-5-91 RETRACED WITHOUT CHANGE

PREV DC I Nos. 7507-W, 9517-W,  
10481-W, 10690-W, 11794-W, 14268-W,  
15205-W & 17050-W, DT. 11-4-91

DATE AUTHORITY ZONE NATURE SIG AHSP SIG DO

AMENDMENTS

DRG. SEALED PROV:- DC (I) No. 7507-W  
DT. 22-12-59 DO CQA(W)

DRN:- CHD:- ASSY DRG:- CQA(W) JABALPUR

TCD:- P.D. SAMAD CHD:- DATE:-

AHSP SCALE:-

CHIEF D' MAN DO FOR CQA(W) ESTD MASS:-

MATERIAL:- STEEL BS 970 PART 1: 1983 605 M36 DESIGN NO.

PROTECTIVE FINISH:-

PART No. N2-71

DS CAT No.

SCREWS  
HEXAGONAL, POLISHED, SMALL GRIP  
TYPE: B6LS, M-THREAD AS PER N2-1स्कूज हेक्जागोनल, पॉलिशड, स्माल ग्रीप  
टाइप : बी 6 स्ल एस स्म-  
थ्रेड सेज पर स्न 2-1



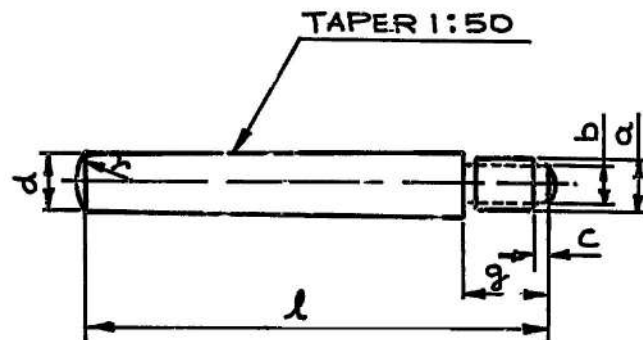


**PIN , TAPER , SCREWED TYPE-KPG  
M-THREAD AS PER N2-1 METRIC SIZES**

TAB 1332

In N4-16

पिन, टेपर, स्कूड टाइप-के पी जी एम-थ्रेड एस पर एन 2-1  
मेट्रिक साइजेस



SURFACE TREATMENT TO Y050

DESIGNATION-KPG - d x L

EXAMPLE-KPG - 8 x 30

MATERIAL-N62, N6L OR EQUAL

MATLIN INDIA-BS:970, Pt-1-1983, Gde 150M36  
CONDITION R.

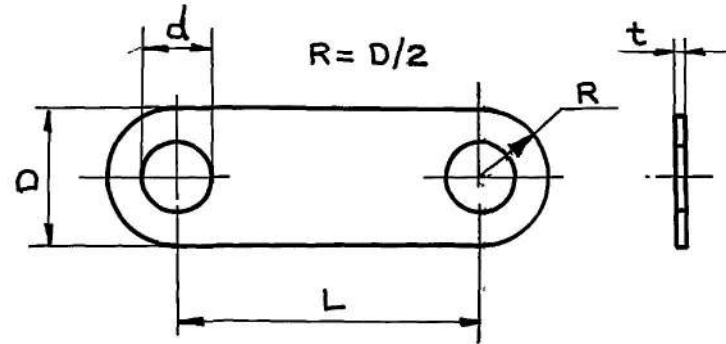
d	5	6	8	10	13	16
a	M5	M6	M8	M10	M12	M16
b	3.5	4.5	6	7	9	12
c	2	2	2	3	3	3
g	8	9	11	13	15	17
r	6	6	10	10	15	15
NUT	LB6 M-5	LB6 M-6	LB6 M-8	LB6 M-10	LB6 M-12	LB6 M-16
	18					
	20	20				
	22	22	22			
	24	24	24			
	26	26	26			
	28	28	28			
	30	30	30	30		
	32	32	32	32		
	36	36	36	36	36	
	40	40	40	40	40	40
	45	45	45	45	45	45
	50	50	50	50	50	50
	60	60	60	60	60	60

AHSP	FOR CQA(W)
DO	
C/D MAN	
CHECKED	
TRACED	

29-09-04	18883-W	HINDI NOMEN ADDED		MV
05-02-07	19029-W	MATL. IN INDIA. AMENDED.		ON
22-11-85		NEW POLY NEGATIVE PREPARED.		14V
		PREV. DC Nos. 7507-W & 11493-W / DT-4-4-67		
DATE	AUTHORITY	NATURE	SIG AHSP	SIG DO
DRG. SEALED PROV. DC No. 7507-W 22-12-59				

PART No.

N5-9



d	D	t	TOOL
5.8	12	0.5	
7	16	0.5	KD-106
9.5	19	0.75	
11.5	22	0.75	KD-104
14	28	0.75	KD-105
16	28	0.75	
18	34	0.75	KD-111
23	42	1	
27	48	1	

## NOTE :-

N5-9-14X43  
 N5-9-14X72  
 N5-9-14X78  
 N5-9-14X80  
 N5-9-14X96

WHEN USED WITH  
 IAN 71A, MATL WILL  
 BE COPPER TO SPEC.  
 BS: 2870 C 106

DESIGNATION - N5-9-d x L

EXAMPLE - N5-9-14 X 50

MATL- HR 43/25, BS: 1449, PART-I-1983.

FOR LOCKING PLATES UP TO  $d=14$ , L IS TO BE CHOSEN FROM 20 TO 100 mmFOR LOCKING PLATES LARGER THAN  $d=14$ , L IS CHOSEN FROM 40 TO 150 mm

MATERIAL - B4

 AKTIEBOLAGET  
 BOFORS

1-3-07	19036-W		MATL. AMENDED.			DRN-	CHD-	ASSY.DRG-	CQA(W) JABALPUR
138-05			RETRACED WITHOUT CHANGE			TCD- <i>P. Anon</i>	CHD- <i>ms</i>	DATE - 1.10.48	
			PREV DC Nos- 7814-W, 11811-W, 13839-W & 18883-W - DT-29.9.04			<i>Ashtayande</i> C/D MAN	DO	SCALE - ESTD, mass -	
DATE	AUTHORITY	ZONE	NATURE	SIG AHSP	SIG DO				DESIGN No.
AMENDMENTS						MATL- AS SHOWN ABOVE			
DRG SEALED PROV- 7814-W 9-2-61						DO CQA(W)			PART No. N5-9

PLATE LOCKING METRIC SIZES

प्लेट लॉकिंग मेट्रिक साइजेस

In

DS CAT No.



AKTIEBDLAGET

BOFORS

**RIVET COUNTERSUNK**

**HEAD**

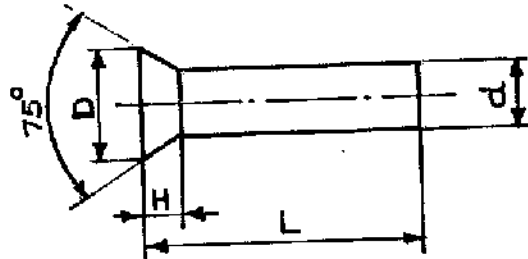
COPPER  
METRIC SIZE

ln

REG 16 12 2

GR 12 NI-14

2-6-1947



D <sub>abt</sub>	2.5	3.5	4.6	5.3	7.1	8.8	10.6	14.1
H	0.7	1	1.3	1.5	2	2.5	3	4
d	1.4	2	2.6	3	4	5	6	8

RIVET LENGTH = L

3	3	4	4	6	8	10	12
4	4	5	5	8	10	12	14
5	5	6	6	10	12	14	16
6	6	8	8	12	14	16	18
8	8	10	10	14	16	18	20
10	10	12	12	16	18	20	22
12	12	14	14	18	20	22	24
	14	16	16	20	22	24	26
	16	18	18	22	24	26	28
		20	20	24	26	28	30
			22	26	28	30	32
				28	30	32	34
				30	32	34	36
					34	36	38
					36	38	40
					38	40	42
					40	42	45
					42	45	48
						48	50
						50	

DESIGNATION : NI-14-d

EXAMPLE : NI-14-5x10

MATERIAL : SOFT COPPER

MATL IN INDIA :- COPPERTO

SPEC IS 288-1960.

DO

G.P. Sharma  
CID MAN

SKT  
CHECKED

26-9-02		RETRACED WITHOUT CHANGE	
		PREV DC Nos:- 7814-W & 11793-W/DT-14-12-67	

SRSINGH  
TRACED

DATE	AUTHORITY	NATURE	SIG DO	SIG AHSP
DRG SEALED PROV:- DC No. 7814-W				
DT 9-2-61				DO CBA(W)

दूरभाष: 0761-2330110  
 TELE : 0761-2330110  
 फ़ैक्स: 0761-2330326/2334 058  
 FAX : 0761-2330326/2334058  
 E.Mail- cqawjab-dgqa@nic.in



भारत सरकार  
 GOVERNMENT OF INDIA  
 रक्षा मंत्रालय (गु आ म नि)  
 MINISTRY OF DEFENCE (DGQA)  
 गुणता आश्वासन नियंत्रणालय (शस्त्र)  
 CONTROLLERATE OF QUALITY ASSURANCE (W)  
 जी सी एफ़ डाकघर, जबलपुर (म.प्र.) 482011  
 GCF PO, JABALPUR (M.P.) 482011

A N I S O 9 0 0 1 : 2 0 1 5 C E R T I F I E D A H S P

License No. CRO / QM / L-8003964

संख्या 2A1/003/CQAW/DRG/SP

०१ जुलाई 2022

The General Manager  
 Gun Carriage Factory  
 GCF P.O., **JABALPUR- 482 011**

**DEMAND OF DRAWING: 40mm L-70 GUN**

→ P 47

1. Please refer your letter No. GCF/SC/281/Drg Demand/05/2022 dated 26 May 2022.
2. Assy drawing for Rack Traversing to Part No. IMB 000460 CN demanded vide your letter under reference is not available with this AHSP.
3. However, as per the documents held with this Controllerate, Rack Traversing to Part No. IMB 000460 CN comprising of 17 items & details of items are enclosed herewith as Appx 'A'.
4. In view of the above, you may demand the drg of items enlisted at Appx 'A' except for the standard item viz. Ball Bearing Dia 5/8" & Bearing Ball Journal Single Row (SKF 6038C152) through Resident SQAE (A) Jabalpur.

Encl : Appx 'A'

(M Balagopal)  
 Lt Col  
 Dy Controller  
 for Controller

**Copy to:-**

The Senior Quality Assurance Officer  
 Senior Quality Assurance Estt (Armts)  
 GCF P.O., **JABALPUR- 482 011**

1. Refer text above.
2. For info please.

FR / BR  
 47  
 48  
 56  
 57

