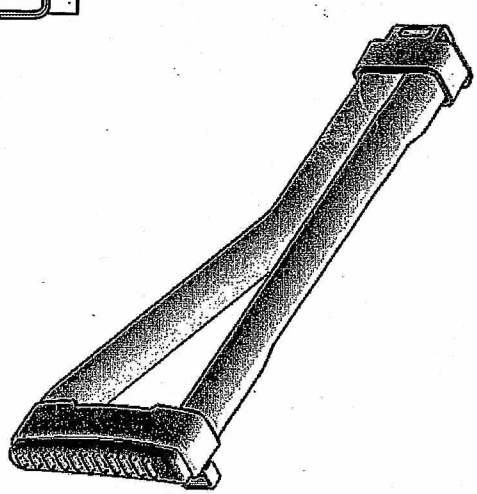
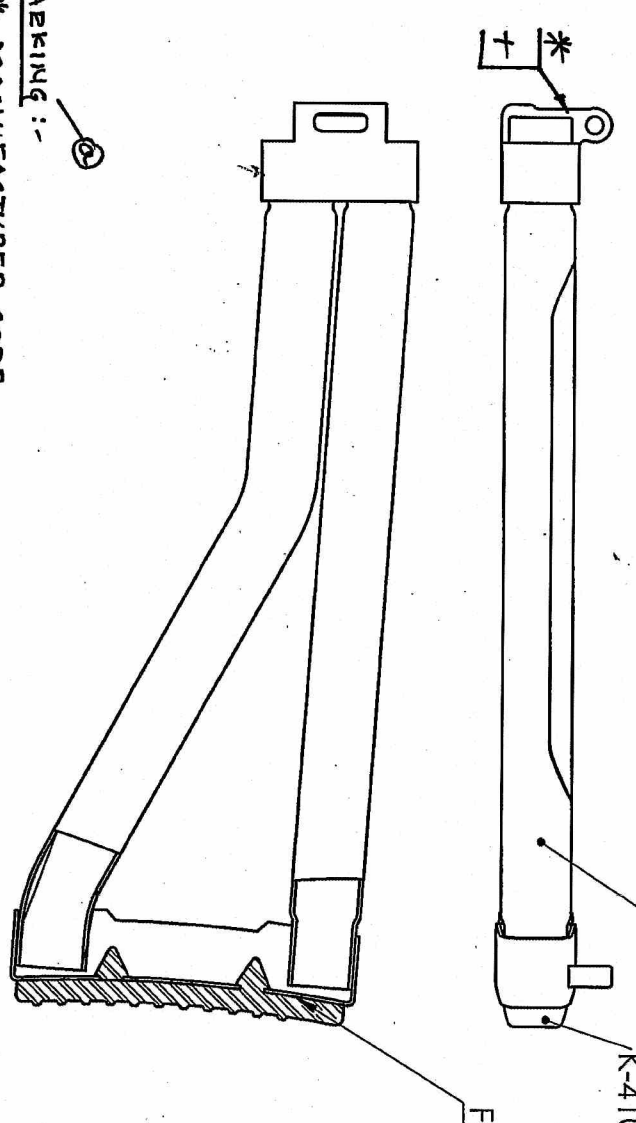


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 Tiruchirappalli-620016

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MARKING :-
 * MANUFACTURER CODE
 + BATCH / YEAR OF MANUFACTURE
 ENGRAVING DEPTH 0.1MM & HEIGHT 2.5MM.

ITEM NO.	PART NUMBER	QTY.	AMENDMENTS	SIG. & DATE	CHECKED	DRAWN	TRACED	SIGNATURE & DATE
2	K-4105 Rubber Plate	1	DA.No: 51/20 Dt: 28/6/2020	Se K				
1	K-4120 Butt Frame Weld Assy	1	DA.No: 45/19 Dt: 09-11-19	Se K				
			DA.No: 27/19	30-7-19				

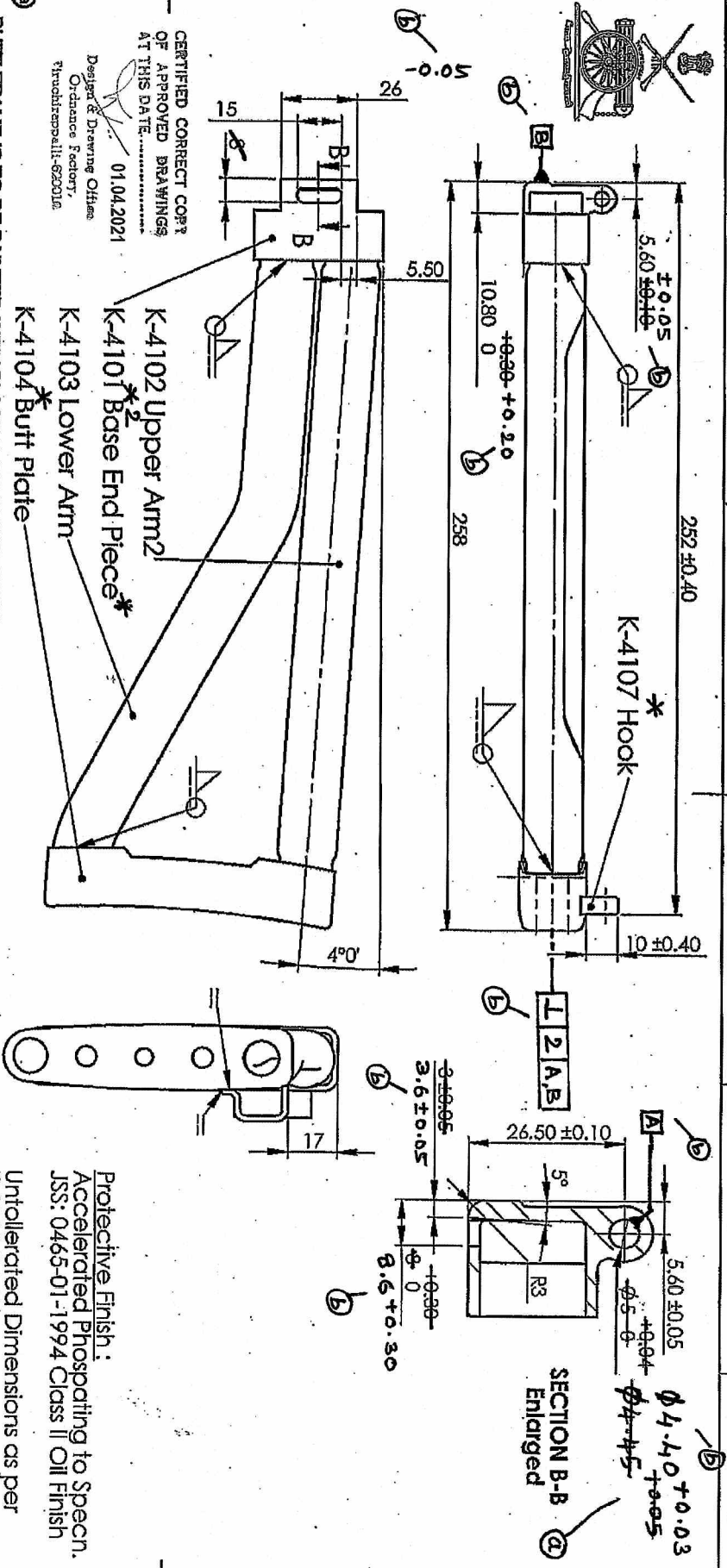
SUB: **Side Foldable Butt Assy**
 FOR: General Assy
 OF: TRICHY ASSAULT RIFLE
 DES. REF. NO. K-4110

DRG. No.: TAR-K-4110 *~~4~~5
 ORDNANCE FACTORY
 TIRUCHIRAPPALLI-16.

DA.No. 64/20
 Dt. 22/10/20

SCALE NTS
 QPG 1
 Weight(g)

SHEETS: 1
 SHEET No.: 1



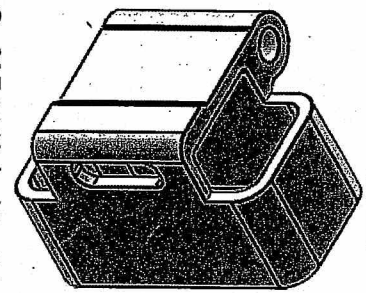
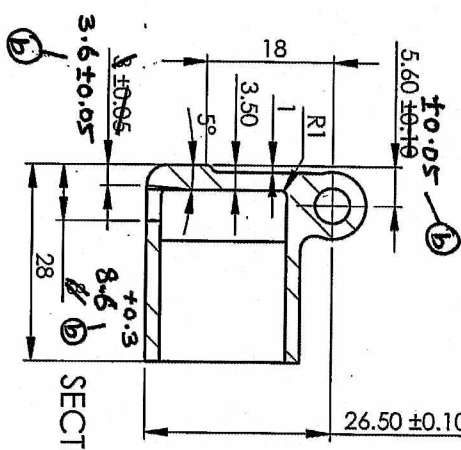
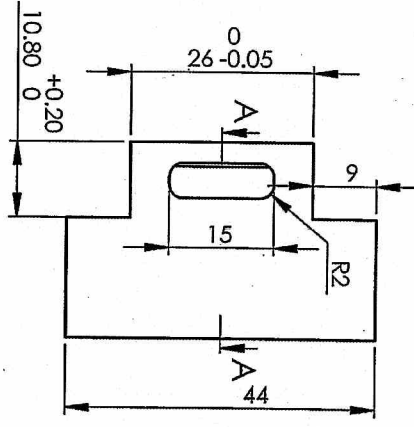
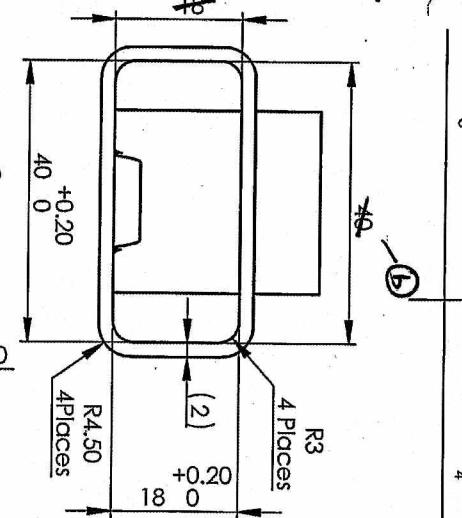
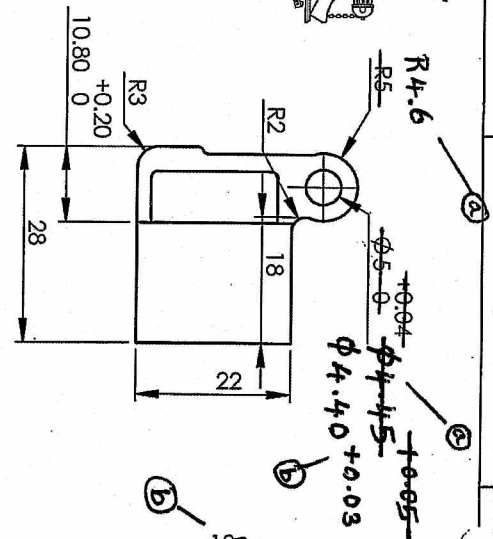
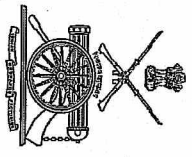
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Thiruchirappalli-620016

BUTT FRAME IS TO BE PAINTED WITH BLACK PTFE (MATT) FINISH!
(Sample to be approved before bulk supply)
Note:- 1. Paint should withstand temp of 300 - 350°C
2. Paint should not peel off and have scratch resistance

ITEM NO.	PART NUMBER	QTY.	AMENDMENTS	SIG. & DATE	APPROVED ON	SUBJECT	SCALE
5	K-4101 Base End Piece	1	DA No. 64/20 Dt. 22/10/20	TRACED	DATE:	SUB: Butt Frame Weld Assy	SCALE NTS
4	K-4107 Hook	1	DA No. 51/20 Dt. 29/01/2022	BARAWN		FOR: SF Butt Assy K-4110	QPG
3	K-4104 Butt Plate	1	DA No. 45/19 Dt. 09-11-19	CHECKED		OF: TRICHY ASSAULT RIFLE	1
2	K-4103 Lower Arm	1	DA NO 27/18	OIC/D&DO OFFICER/ PRDN.		DES. REF. NO. K-4110	Weight(g) 341.82
1	K-4102 Upper Arm	1		DIV. OFFICER/ D&DO		DRG. No.: TAR-K-4120 *34	SHEETS: 1
						ORDNANCE FACTORY THIRUCHIRAPPALLI-16.	SHEET No.: 1

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Protective Finish:
Accelerated Phosphating to Specn.
JSS: 0465-01-1994 Class II Oil Finish
Untolerated Dimensions as per
IS:2102 (MED)



Material :- Steel
 BS:970 Pt.1 1983 Gr 817 M40 (or) En-24
 BS:970 Pt.1 1983 Gr 709 M40 (or) En-19
 BS:970 Pt.1 1983 Gr 708 M40 (or) En-19A
 BS:970 Pt.1 1983 Gr 070 M55 (En-9)

Casting Route:

For Casting route
 BS:3146 PART-1, 1974 Class:5, Grade:A
 Non Stressed Component
 Radiographic Test as per ASTM-E-192

Acceptance Standard:-

Gas hole & Foreign Material: Level-3
 Shrinkage (All Types) : Level 3
Note:-
 Tolerance as per IS:11166 Class-1
 Flatness Tolerance : ±0.1 / 25.4mm
 Casting Radius 0.5 mm

Acceptance Standard:-
 Gas hole & Foreign Material: Level-3
 Shrinkage (All Types) : Level 3

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Hardness: 290-360 HV

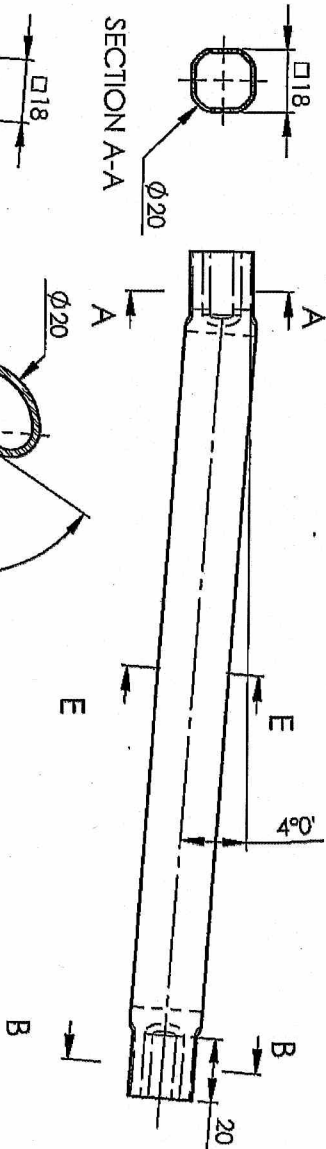
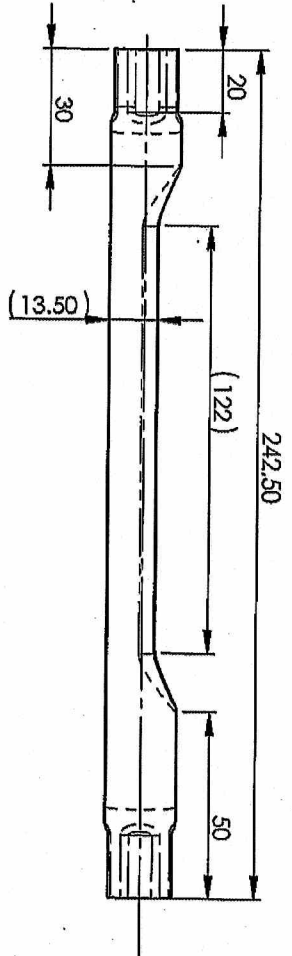
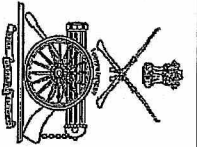
Protective Finish:

Accelerated Phosphating to Specn.
 JSS: 0465-01-1994 Class II Oil Finish

Untolerated Dimensions as per
 IS:2102 (MED)

DR. No. 51/20	DR. 28/19/2020	DR. No: 45/19	DR. 09-11-19
CHECKED			
DRAWN			
TRACED			
SIGNATURE & DATE			
SIG. & DATE			
APPROVED ON. 30/08/2018			

SUB: Base End Piece	SCALE NTS
FOR: Buttweld Assy K-4120	QPG 1
OF: TRICHY ASSAULT RIFLE	Weight(g)
DES. REF. NO. K-4101	
DRG. No.: TAR-K-4101-2	SHEETS: 1
ORDNANCE FACTORY TIRUCHIRAPPALLI-16.	SHEET No.: 1



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Material :- Cold Drawn Seamless Steel Tube - Dia20 x1
 BS:6323 Pt.4 1982 Desig: CFS 3 BK
 BS:6323 Pt.4 1982 Desig: CFS 4 BK
 BS:6323 Pt.4 1982 Desig: CFS 5 BK
 BS:6323 Pt.4 1982 Desig: CFS 6 BK
 BS:6323 Pt.4 1982 Desig: CFS 7 BK
 BS:6323 Pt.4 1982 Desig: CFS 8 BK
 BS:6323 Pt.4 1982 Desig: CFS 9 BK
 BS:6323 Pt.4 1982 Desig: CFS 10 BK
 BS:6323 Pt.4 1982 Desig: CFS 11 BK

IS:3074-2005 Sec.2 CDS-1, Annealed
 IS:3074-2005 Sec.2 CDS-2, Annealed
 IS:3074-2005 Sec.2 CDS-3, Annealed
 IS:3074-2005 Sec.2 CDS-4, Annealed
 IS:3074-2005 Sec.2 CDS-5, Annealed
 IS:3074-2005 Sec.2 CDS-6, Annealed
 IS:3074-2005 Sec.2 CDS-7, Annealed
 IS:3074-2005 Sec.2 CDS-9, Annealed
~~IS:3074-2005 Sec.2 CDS-4, Annealed~~

CEW Pipes
 IS:3074-2005 Sec.2 CDS-1, Annealed
 IS:3074-2005 Sec.2 CDS-2, Annealed
 IS:3074-2005 Sec.2 CDS-3, Annealed

SECTION E-E
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 AT THIS DATE.....**

01.04.2021

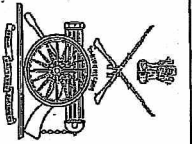
Designed & Drawing Officer
 Ordnance Factory,
 Tiruchirappalli-620016

Protective Finish:
 Accelerated Phosphating to Specn.
 JSS: 0465-01-1994 Class II Oil Finish
 Untolerated Dimensions as per
 IS:2102 (MED)

TRACED	SIGNATURE & DATE
DRAWN	
CHECKED	
OIC/D&DO	
OFFICER/PRODN.	
DV/OFFICER/D&DO	
APPROVED ON. 30/08/2018	

SUB:	SCALE
UPPER ARM	NTS
FOR: Buttweldassy K-4120	QPG
OF: TRICHY ASSAULT RIFLE	1
DES.REF.NO. K-4102	Weight(g)
DRG. TAR-K-4102	
No.:	
ORDNANCE FACTORY TIRUCHIRAPPALLI-16.	SHEETS: 1
	SHEET No.: 1



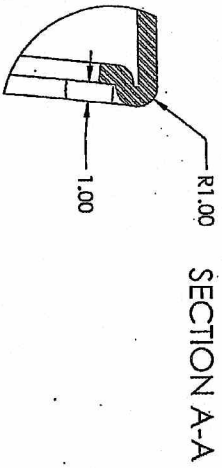
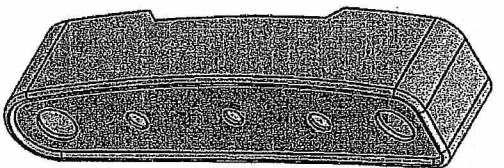
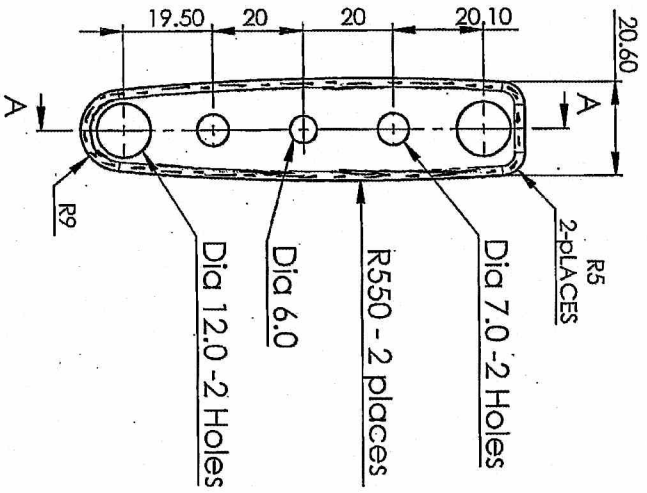
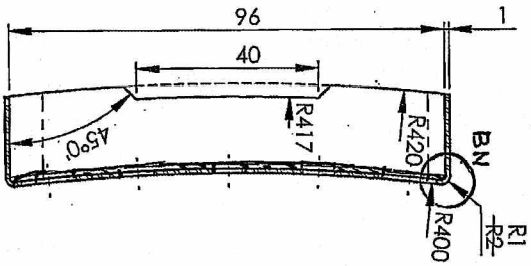


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01.04.2021

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DETAIL -BN-
SCALE 4:1

Hardness: 290-360 HV

Protective Finish:
Accelerated Phosphating to Specn.
JSS: 0465-01-1994 Class II Oil Finish
Untolerated Dimensions as per
IS:2102 (MED)

Material :- Steel Sheet 1.0mm
BS:1449 Pt.1 1983 Gr CS40 Sec-4
BS:1449 Pt.1 1983 Gr CS50 Sec-4
BS:1449 Pt.1 1983 Gr CS60 Sec-4
BS:1449 Pt.1 1983 Gr CS70 Sec-4
BS:1449 Pt.1 1983 Gr CS80 Sec-4

<p>DA.No.64/20 Dt.:22/10/20</p>		<p>SIG. & DATE</p>		<p>AMENDMENTS</p>	
<p>TRACED</p>		<p>SIGNATURE & DATE</p>		<p>SUB: Butt Plate</p>	
<p>DRAWN</p>		<p>DATE</p>		<p>FOR: ButtFrameWeldassy K-4120</p>	
<p>CHECKED</p>		<p>DATE</p>		<p>OF: TRICHY ASSAULT RIFLE</p>	
<p>OIC /D&DO</p>		<p>DATE</p>		<p>DES. REF. NO. K-4104</p>	
<p>OFFICER/ PRODN.</p>		<p>DATE</p>		<p>DRG. No.: TAR-K-4104 *</p>	
<p>DIV/OFFICER/ D&DO</p>		<p>DATE</p>		<p>Weight(g)</p>	
<p>APPROVED ON. 30/08/2018</p>		<p>DATE</p>		<p>SHEETS: 1</p>	
<p>APPROVED ON. 30/08/2018</p>		<p>DATE</p>		<p>SHEET No.: 1</p>	

ORDNANCE FACTORY
TIRUCHIRAPPALLI-16.

SCALE
NTS
QPG
1

