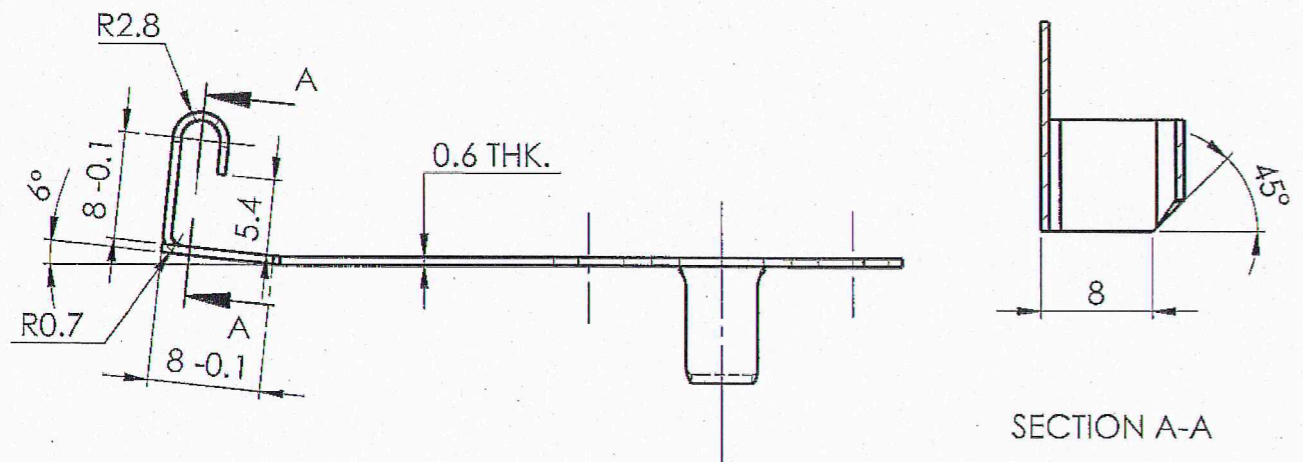


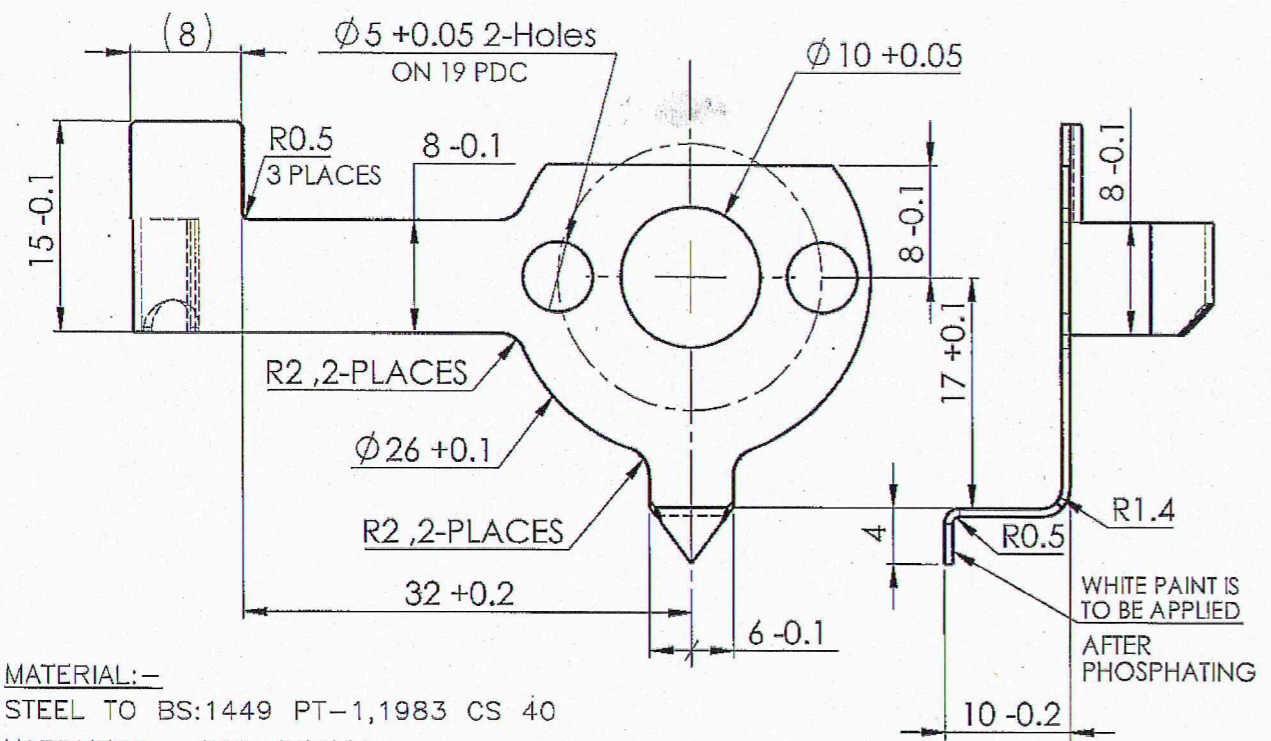
7

IN CONTROLLED COPY
CERTIFIED CORRECT COPY OF APPROVED
DRAWINGS AT THIS DATE. 23/01/24
DESIGN & DRAWING OFFICE,
ORDNANCE FACTORY, TIRUCHIRAPPALI-620 016.

DIMENSIONS ARE IN mm.
UNTOLERATED DIMNS. AS PER IS : 2102 (MED)
REMOVE ALL SHARP EDGES AND BURRS.
DIMNS. ARE TO BE READ AS APPLYING AFTER PROTECTIVE FINISH.



SECTION A-A



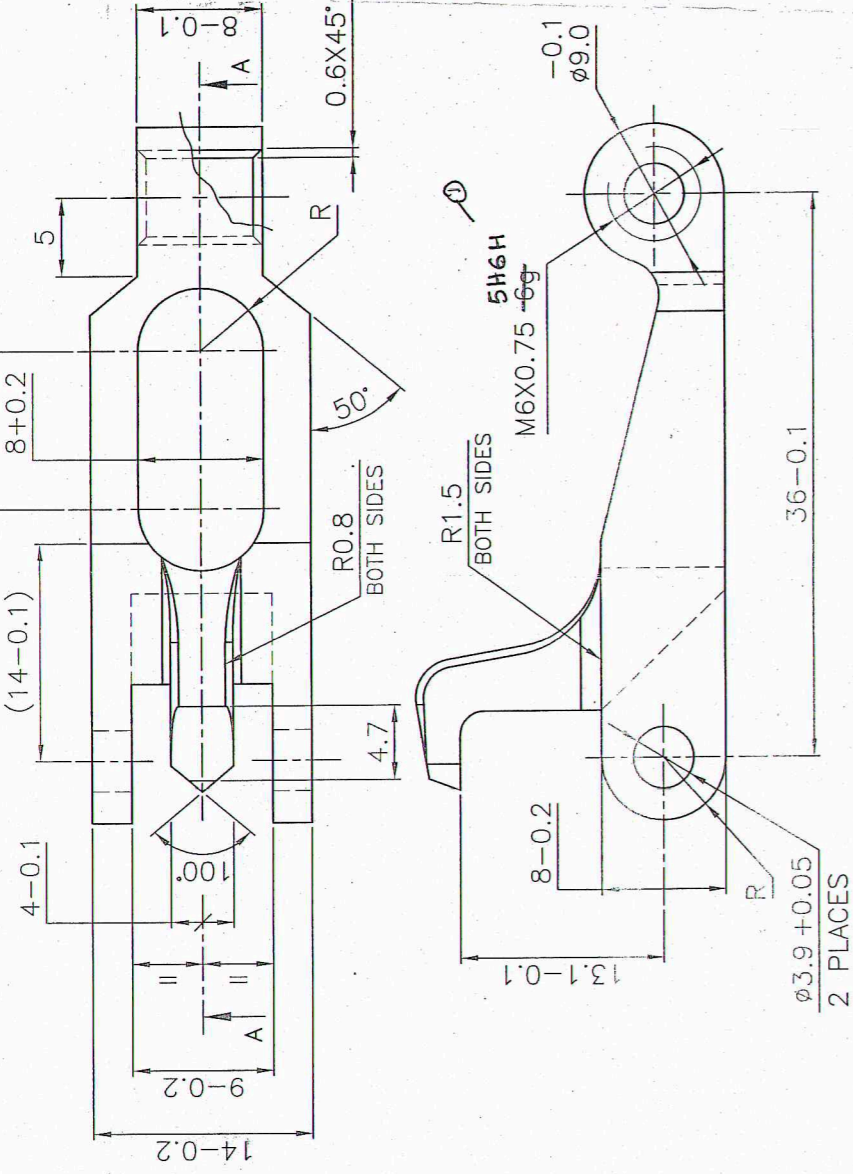
MATERIAL:-
STEEL TO BS:1449 PT-1,1983 CS 40
HARDNESS:- 300-350HV

PROTECTIVE FINISH: PHOSPHATED TO SPECIFICATION JSS.0465-01-1988
CLASS-II (OIL FINISH)

AMENDMENTS	SIG. & DATE		SIGNATURE & DATE.	SUB: SIGHT ADJUSTING PLATE	SCALE
		TRACED		FOR: SIGHT ASSY	NTS
		DRAWN	<i>V. Sh</i>	OF: TAR UBGL	Weight (g)
		CHECKED		DES. REF. NO.	REVISION
		OIC/D&DO	<i>P. J. K.</i>	DRG. No.: 36P 1306	SHEETS: 1
				ORDNANCE FACTORY TIRUCHIRAPPALI-16.	SHEET No.: Sheet 1
			DATE: 26/9/20		

DIMENSIONS ARE IN mm.
 UNTOLERATED DIMNS. AS PER IS : 2102 (MED)
 SHARP CORNERS SHOULD BE BLUNT TO R 0.5

PROVISIONAL



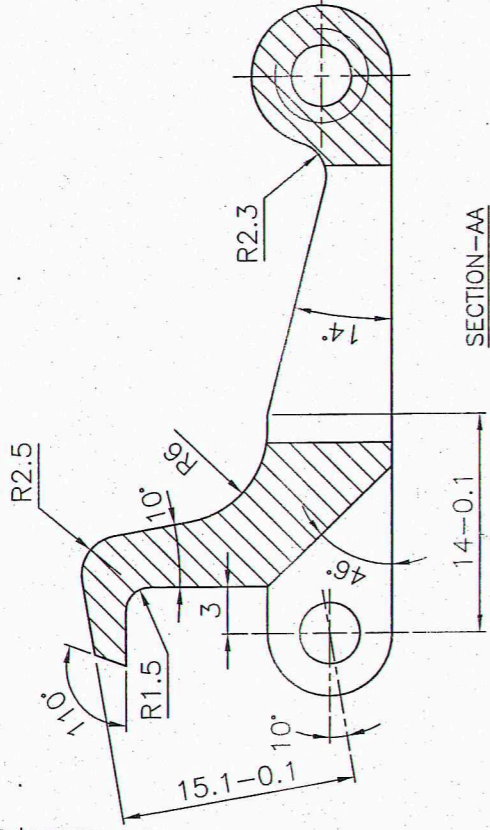
MATERIAL: STEEL BS:970 PT-1 1983 Sec.3 Gv.709 M40 (OR) EN19
ALT. MATERIAL: STEEL BS:970 PT-1 1983 Sec.3 Gv.708 M40 (OR) EN19A
HARDNESS: 39-46 HRC

NOTE:
 DIMENSIONS ARE TO BE READ AS APPLYING AFTER PROTECTIVE FINISH

HARDNESS: 300-350 HV

PROTECTIVE FINISH:
 PHOSPHATED TO SPECJSS-0405-01-1994 CLASS-II OIL FINISH

UN CONTROLLED COPY
 CERTIFIED CORRECT COPY OF APPROVED
 DRAWINGS AT THIS DATE: 25/01/24
 DESIGN & DRAWING OFFICE,
 ORDNANCE FACTORY, TIRUCHIRAPPALI-620 016.



MATERIALS

STEEL TO BS:970 PT-1, 1983 Sec.3 Gv.709 M40 (OR) EN19
 STEEL TO BS:970 PT-1, 1983 Sec.3 Gv.708 M40 (OR) EN19A

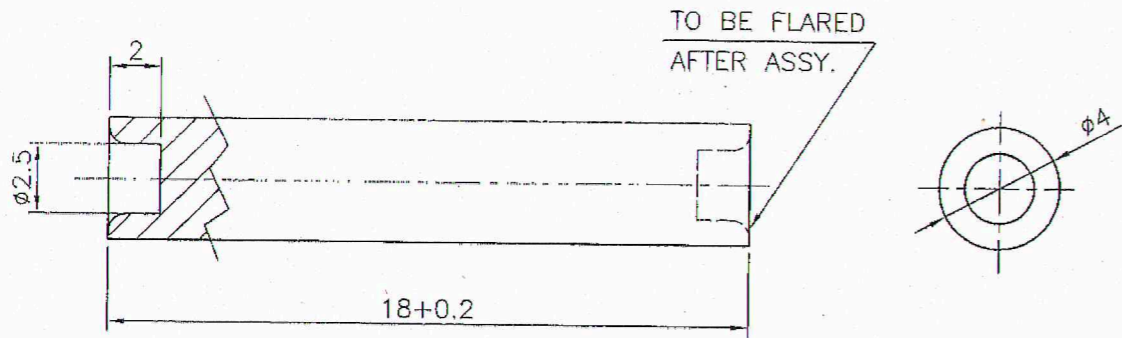
TRACED	SIGNATURE & DATE	SUB: FORE SIGHT SUPPORT	SCALE: NTS
DRAWN	<i>[Signature]</i>	FOR: SIGHT ASSY	STORE DRG. NO. ---
CHECKED	<i>[Signature]</i>	OF: BULGERIA UBGL	OPERATION NO. ---
HOS/D&DO		DES. REF. NO.	SHEETS: 1
OFFICER/PRODN.		DRG. No.: 36P 1307*	SHEET NO. 1
OFFICER/DESIGN			
AMENDMENTS & DATE APPROVED ON: 14.8.18		ORDNANCE FACTORY TIRUCHIRAPPALI-16.	

DA: Ab. 02/2024
 DT: 24/01/24

SIG. & DATE APPROVED ON: 14.8.18

DIMENSIONS ARE IN mm.
 UNTOLERATED DIMNS. AS PER IS : 2102 (MED)
 SHARP CORNERS SHOULD BE BLUNT TO R 0.5

UN CONTROLLED COPY
 CERTIFIED CORRECT COPY OF APPROVED
 DRAWINGS AT THIS DATE. 29/01/24
 DESIGN & DRAWING OFFICE,
 ORDNANCE FACTORY, TIRUCHIRAPPALI - 620 016.



NOTE:


REMOVE ALL SHARP EDGES AND BURRS
 DIMENSIONS ARE TO BE READ AS APPLYING AFTER PROTECTIVE FINISH

MATERIAL:

STEEL TO BS:970 PT-1,1983 GD.070 M55 "T" CONDITION OR (EN-9) OR
 STEEL TO BS:970 PT-1,1983 GD.080 M40 "T" CONDITION OR (EN-8)

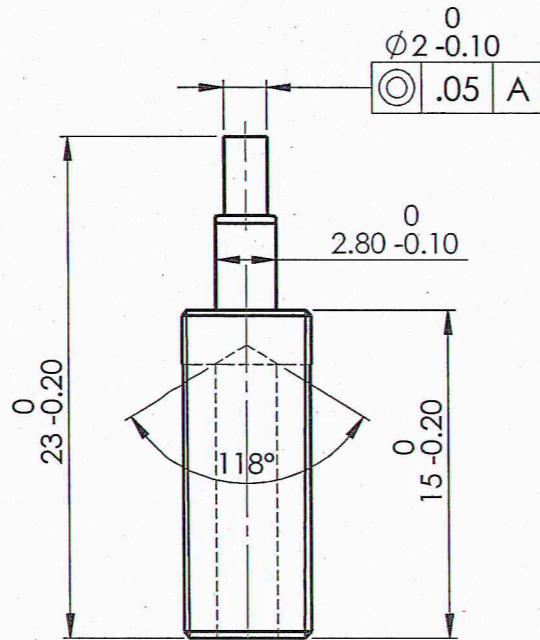
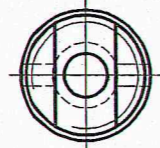
PROTECTIVE FINISH:

PHOSPATED TO SPECN.JSS-0465-01-1994,CLASS-II,OIL FINISH

PART NO.	DESCRIPTION	NO OFF	MATERIAL	TREATMENT	REMARKS
	SIGNATURE & DATE	SUB: FORE SIGHT SUPPORT RIVET			SCALE: N.T.S
	DRAWN	FOR: SIGHT ASSY			STORE NO.
	CHECKED <i>[Signature]</i>	OF: TAR UBGL			OPERATION NO.
	HOS/DDO <i>[Signature]</i>	DES. REF. NO.			
	NODAL OFFICER/ FOR MGL. <i>[Signature]</i>	DRG. NO. 36P 1308			
	OFFICER/ D&DO	 ORDNANCE FACTORY TIRUCHIRAPPALI			SHEETS: 1
AMENDMENTS	SIGN. & DATE	APPROVED ON.			SHEET NO: 1

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 24/01/24
 DESIGN & DRAWING OFFICE,
 ORDNANCE FACTORY, TIRUCHIRAPPALLI-520 016.



* Dimension prior to Hardening

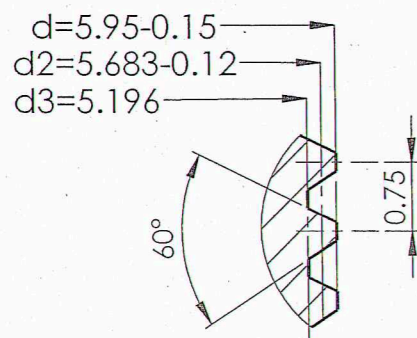
Material :
 Steel
 BS:970 Pt.1 1983 Sec.3 Gr.709 M40 (or) EN19
 Alt. Matl.
 BS:970 Pt.1 1983 Sec.3 Gr.708 M40 (or) EN19A

Hardness: 42 - 47 HRC

Protective Finish :
 Accelerated Phospating to Specn. 0465-01-1994
 Class II Oil Finish

Blunt Sharp Edges to 0.4 R

**Pilot sample to be get approved
 before bulk production**



Enlarged view at - B

DA.No.01/2024 Dt.:24/01/2024	SIG. & DATE	APPROVED ON. 24/01/2024	SIGNATURE & DATE.	SUB: Fore Sight	SCALE NTS
			TRACED	FOR: Sight Assy	QPG 1
			DRAWN	OF: TAR UBGL	Weight (g) 2.90 (Approx.)
			CHECKED	DES.REF.NO. K-1022*	SHEETS: 1
			HOS/D&DO	DRG. 36P 1309* No.:	SHEET No.: 1
AMENDMENTS			ORDNANCE FACTORY TIRUCHIRAPPALLI-16.		

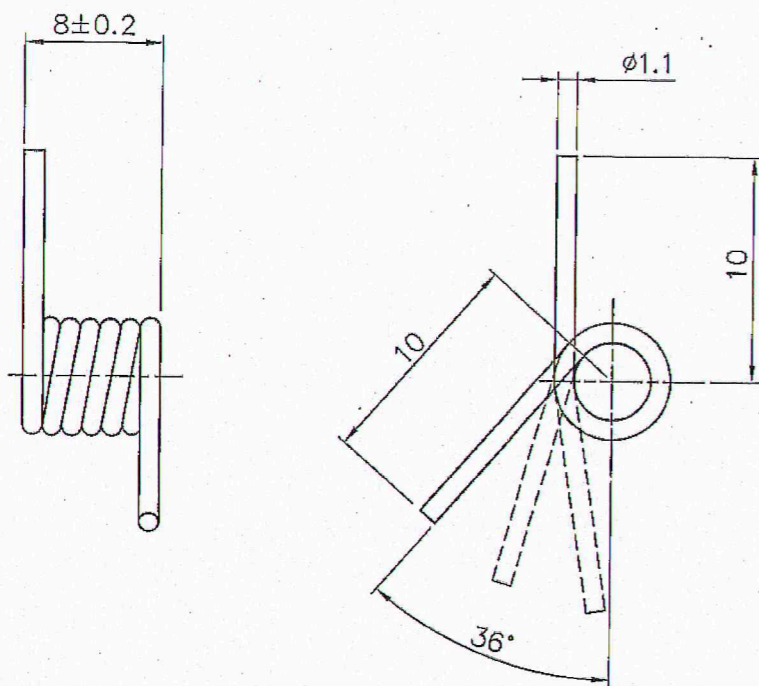
11

PROVISIONAL

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

UN CONTROLLED COPY
CERTIFIED CORRECT COPY OF APPROVED
DRAWINGS AT THIS DATE: 23/01/24
DESIGN & DRAWING OFFICE,
ORDNANCE FACTORY, TIRUCHIRAPPALI - 620 016.

WIRE DIA - $\phi 1.1$
INNER DIA - 4.6 ± 0.2
WOUND - RH (OR) LH
ANGULAR TOLERANCES ARE $\pm 1^\circ$
NO. OF EFFECTIVE COILS - 5.75
STRESS RELIEF: -200°C TO 220°C FOR 1 Hr.



MATERIAL: IS 4454: Pt.1:1981, Gr.4
OR
IS 4454: Pt.1:2001, Gr.DH

PROTECTIVE FINISH: -
PHOSPHATE TO SPECN JSS:0465-01:1994, CLASS-II, OIL FINISH

Dr
HT/HOS

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
	SIGNATURE & DATE.				SCALE NTS
	TRACED				STORE DRG.NO.
	DRAWN <i>A. Ach</i>				OPERATION NO.
	CHECKED <i>P. Singh</i>				
	HOS/D&DO <i>P. Tosh</i>				
	OFFICER/PRODN.				
	OFFICER/D&DO				
	APPROVED ON.				

SUB: FORE SIGHT SPRING
FOR: SIGHT ASSY
OF: TAR UBGL

DES. REF. NO.
DRG. No.: 36P 1310 *

ORDNANCE FACTORY
TIRUCHIRAPPALI-16.

SHEETS: 1
SHEET No.: 1

06/19
25/06/19

SIG. & DATE

AMENDMENTS

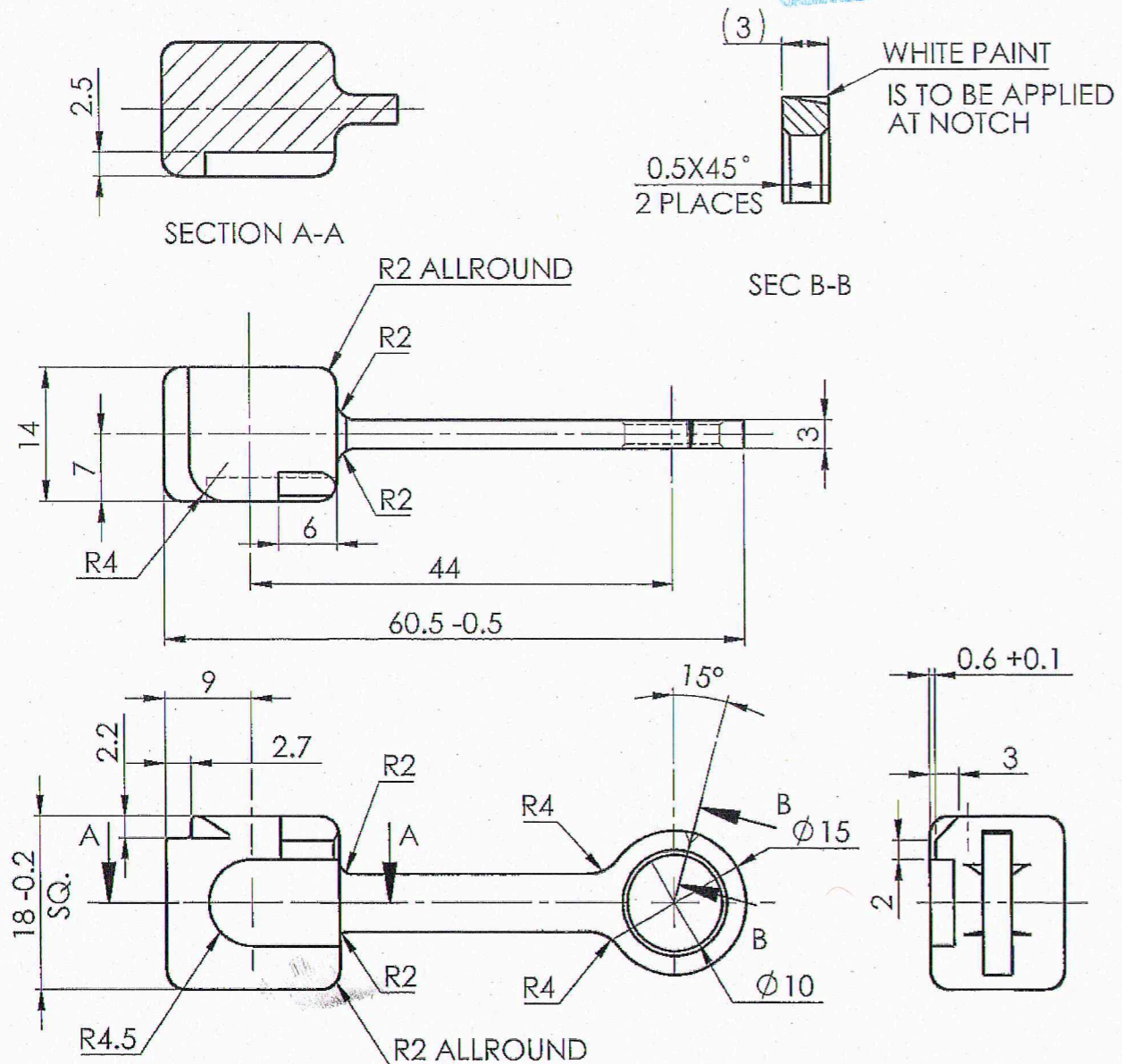
12

DIMENSIONS ARE IN mm.

UNTOLERATED DIMNS. AS PER IS : 2102 (MED)

SHARP CORNERS SHOULD BE BLUNT TO R 0.5

UN CONTROLLED COPY
CERTIFIED CORRECT COPY OF APPROVED
DRAWINGS AT THIS DATE. 22/01/24
DESIGN & DRAWING OFFICE,
ORDNANCE FACTORY, TIRUCHIRAPPALLI-620 016.



MATERIAL:-



STEEL TO BS:970 PT-1,1983 GD.070 M55 OR EN-9

STEEL TO BS:970 PT-1,1983 GD.080 M40 OR EN-8

HARDNESS:- 300-350HV

PROTECTIVE FINISH: PHOSPHATED TO SPECIFICATION JSS.0465-01-1988

CLASS-II (OIL FINISH)

AMENDMENTS	SIG. & DATE	 SIGNATURE & DATE.	SUB: PENDULAM	SCALE
		TRACED	FOR: SIGHT ASSY	NTS
		DRAWN <i>V.S.</i>	OF: TAR UBGL	Weight (g)
		CHECKED	DES. REF. NO.	REVISION
		OIC/D&DO <i>V.S.</i>	DRG. No.: 36P 1311	SHEETS: 1
		OFFICER/PRODN.	 ORDNANCE FACTORY TIRUCHIRAPPALLI-16.	SHEET No.: sheet
DIV. OFFICER/D&DO <i>V.S.</i>	DATE: 26/9/20			