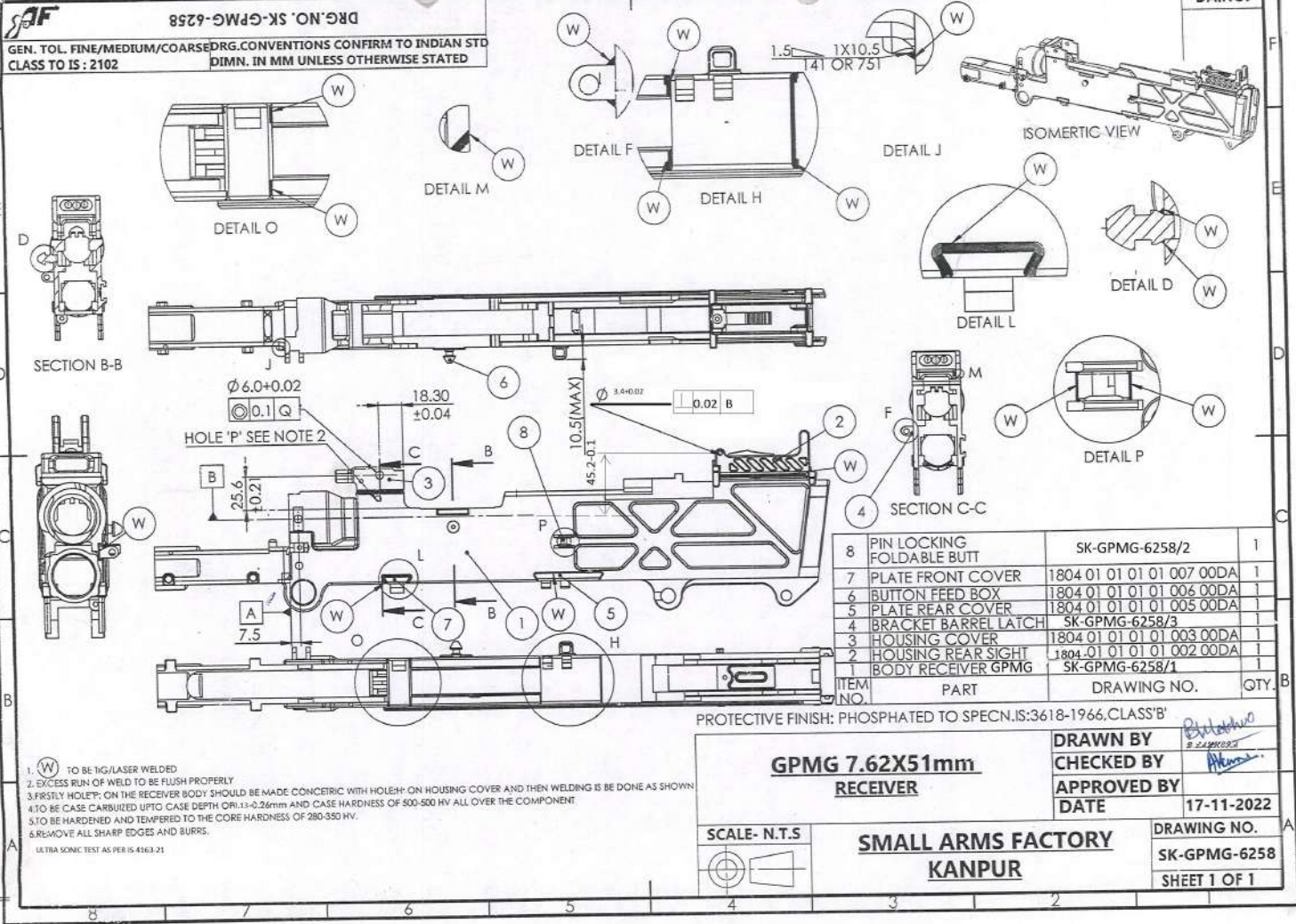




DRG. NO. SK-GPMG-6258

GEN. TOL. FINE/MEDIUM/COARSE DRG. CONVENTIONS CONFIRM TO INDIAN STD CLASS TO IS : 2102 DIMN. IN MM UNLESS OTHERWISE STATED

DA.NO.



8	PIN LOCKING FOLDABLE BUTT	SK-GPMG-6258/2	1
7	PLATE FRONT COVER	1804 01 01 01 01 007 00DA	1
6	BUTTON FEED BOX	1804 01 01 01 01 006 00DA	1
5	PLATE REAR COVER	1804 01 01 01 01 005 00DA	1
4	BRACKET BARREL LATCH	SK-GPMG-6258/3	1
3	HOUSING COVER	1804 01 01 01 01 003 00DA	1
2	HOUSING REAR SIGHT	1804-01 01 01 01 002 00DA	1
1	BODY RECEIVER GPMG	SK-GPMG-6258/1	1
ITEM NO.	PART	DRAWING NO.	QTY.

PROTECTIVE FINISH: PHOSPHATED TO SPECN.IS:3618-1966,CLASS'B'

**GPMG 7.62X51mm
RECEIVER**

DRAWN BY *Bhatnagar*
 CHECKED BY *S. SARKAR*
 APPROVED BY *Atm...*
 DATE 17-11-2022

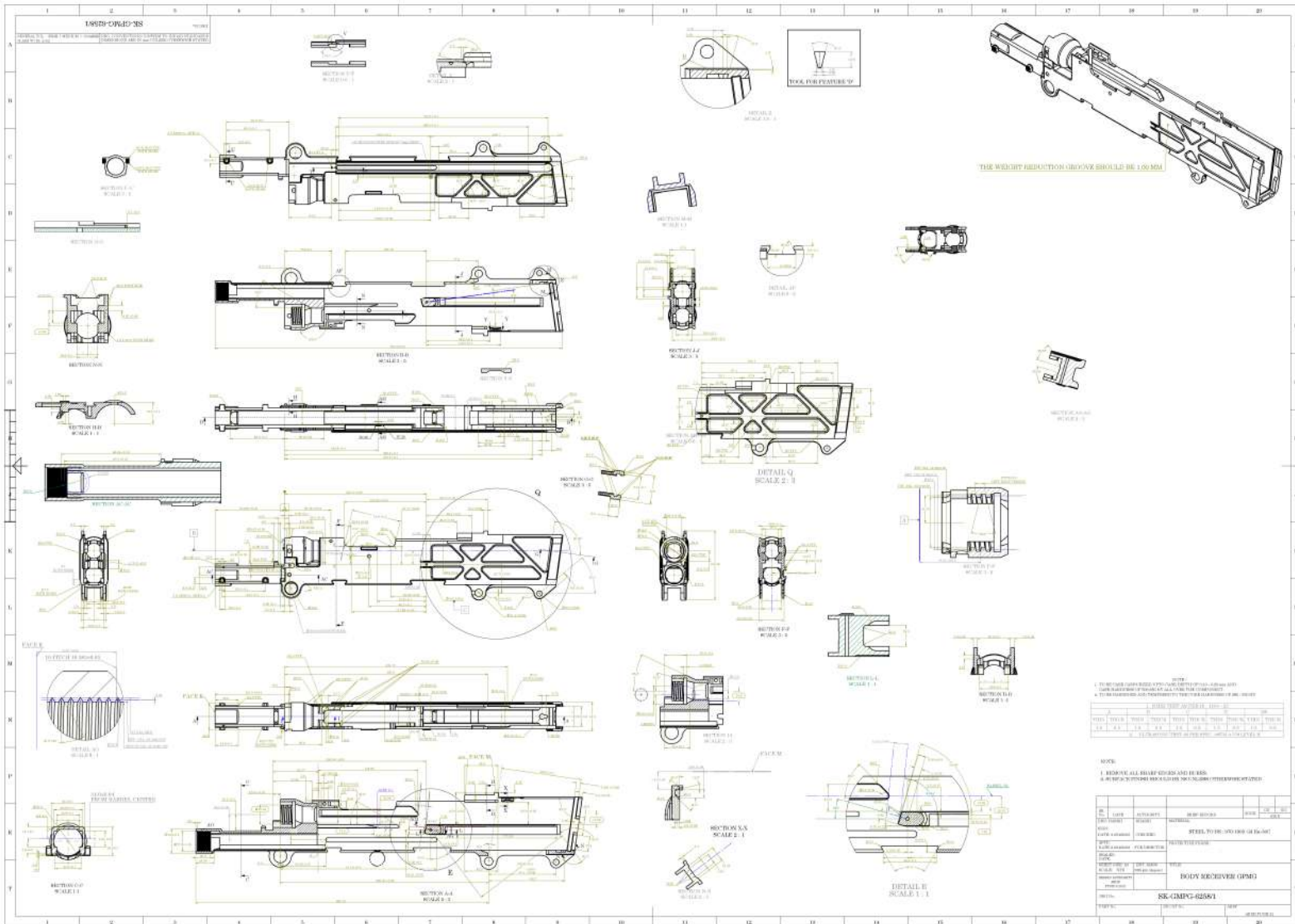
SCALE- N.T.S

**SMALL ARMS FACTORY
KANPUR**

DRAWING NO.
SK-GPMG-6258
SHEET 1 OF 1

1. (W) TO BE TIG/LASER WELDED
2. EXCESS RUN OF WELD TO BE FLUSH PROPERLY
3. FIRSTLY HOLE 'P' ON THE RECEIVER BODY SHOULD BE MADE CONCENTRIC WITH HOLE 'H' ON HOUSING COVER AND THEN WELDING IS BE DONE AS SHOWN
4. TO BE CASE CARBURIZED UP TO CASE DEPTH 0.13-0.26mm AND CASE HARDNESS OF 500-500 HV ALL OVER THE COMPONENT
5. TO BE HARDENED AND TEMPERED TO THE CORE HARDNESS OF 280-350 HV.
6. REMOVE ALL SHARP EDGES AND BURRS.

ULTRA SONIC TEST AS PER IS 4163-21



THE WEIGHT REDUCTION GROOVES SHOULD BE 100 MM

NOTE

1. TO WEIGHT REDUCTION GROOVES SHOULD BE 100 MM
2. TO WEIGHT REDUCTION GROOVES SHOULD BE 100 MM

NO.	DATE	REVISION	BY	CHKD.
1	10/10/2018	ISSUED FOR MANUFACTURE
2	10/10/2018

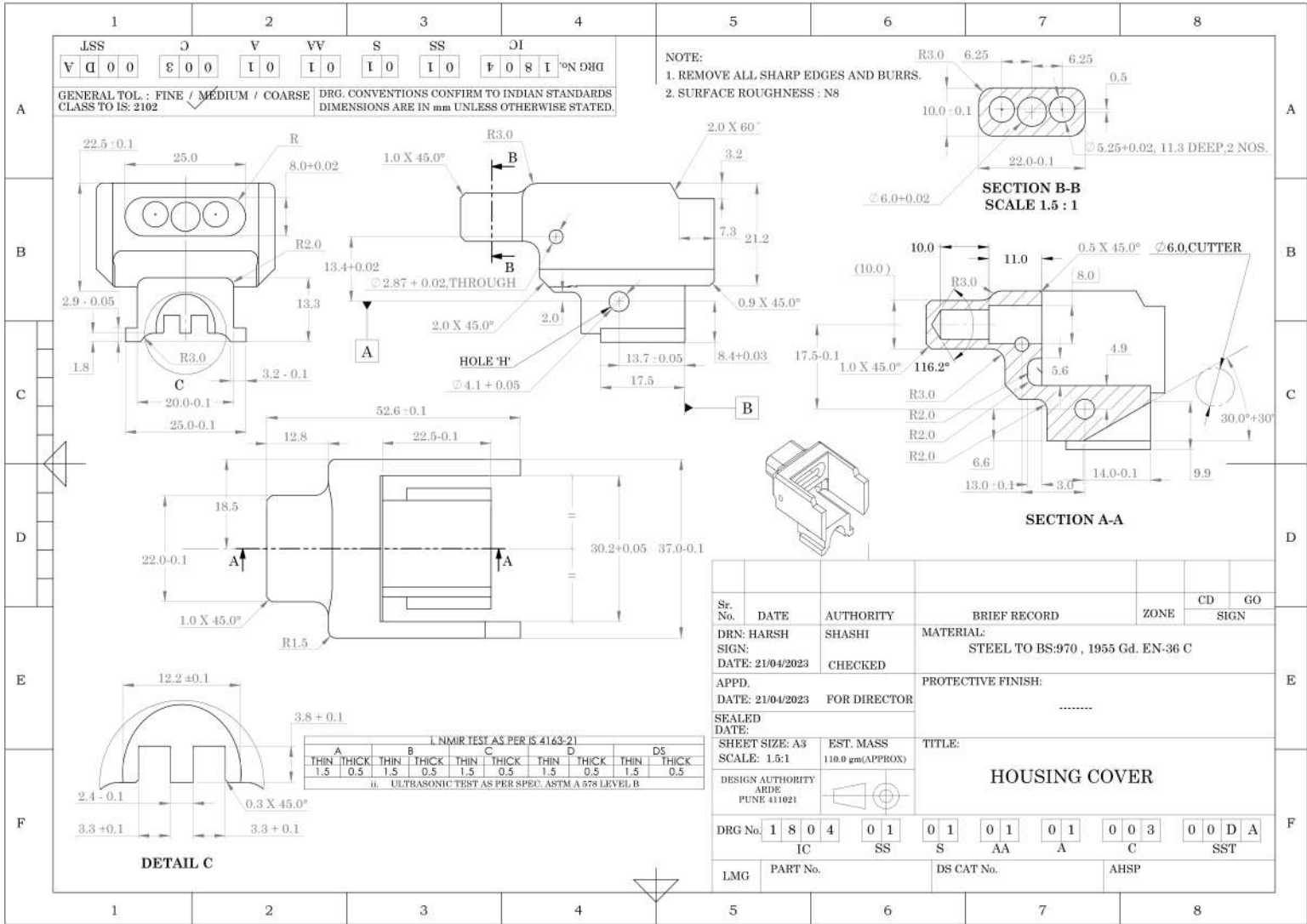
NOTE

1. ALL DIMENSIONS ARE IN MILLIMETERS UNLESS OTHERWISE SPECIFIED.
2. ALL DIMENSIONS ARE TO BE TAKEN TO THE CENTERLINE UNLESS OTHERWISE SPECIFIED.

NO.	DATE	REVISION	BY	CHKD.
1	10/10/2018	ISSUED FOR MANUFACTURE
2	10/10/2018

NO.	DATE	REVISION	BY	CHKD.
1	10/10/2018	ISSUED FOR MANUFACTURE
2	10/10/2018

SS-CMPG-62581



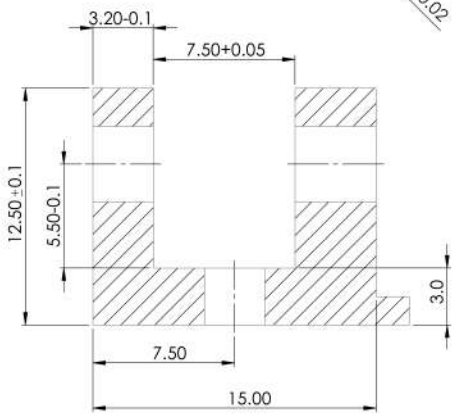
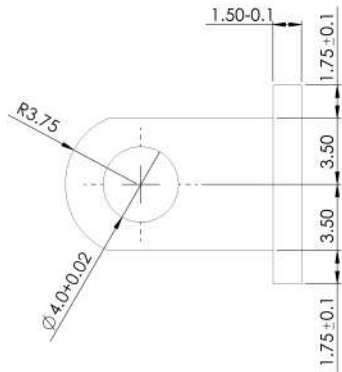
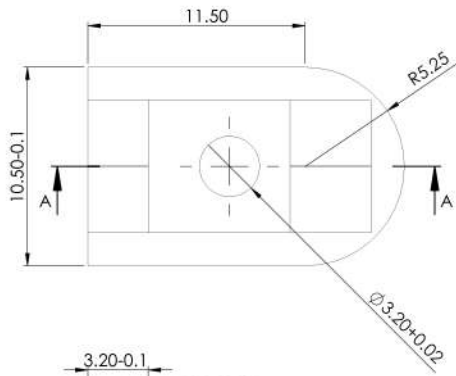
Sr. No.	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO
DRN: HARSH	SHASHI	MATERIAL:	STEEL TO BS:970 , 1955 Gd. EN-36 C			
SIGN: DATE: 21/04/2023	CHECKED	PROTECTIVE FINISH:			
APPD. DATE: 21/04/2023	FOR DIRECTOR					
SEALED DATE:		TITLE:	HOUSING COVER			
SHEET SIZE: A3	EST. MASS					
SCALE: 1.5:1	110.0 gm(APPROX)					
DESIGN AUTHORITY						
ARDE PUNE 411021						
DRG No. 1 8 0 4 0 1	0 1	0 1	0 1	0 0 3	0 0 D A	
IC	SS	S	AA	A	C	SST
LMG	PART No.	DS CAT No.	AHSP			



DRG. NO. SK-GPMG-6258/3

DA.NO.

GEN. TOL. FINE/MEDIUM/COARSE DRG. CONVENTIONS CONFIRM TO INDIAN STD CLASS TO IS : 2102
DIMN. IN MM UNLESS OTHERWISE STATED



i. NMIR TEST AS PER IS 4163-21

A		B		C		D		DS	
THIN	THICK	THIN	THICK	THIN	THICK	THIN	THICK	THIN	THICK
1.5	0.5	1.5	0.5	1.5	0.5	1.5	0.5	1.5	0.5

ii. ULTRASONIC TEST AS PER SPEC. ASTM A 578 LEVEL B

MATERIAL: STEEL TO BS 970,1955 Gd .EN-36C
SURFACE ROUGHNESS N8
REMOVE ALL SHARP EDGES AND BURRS

GPMG 7.62X51mm BRACKET BARREL LATCH	DRAWN BY	S. JAKHORA
	CHECKED BY	
SCALE- N.T.S 	APPROVED BY	
	DATE	17-11-2022
SMALL ARMS FACTORY KANPUR		DRAWING NO. SK-GPMG-6258/3
		SHEET 1 OF 1

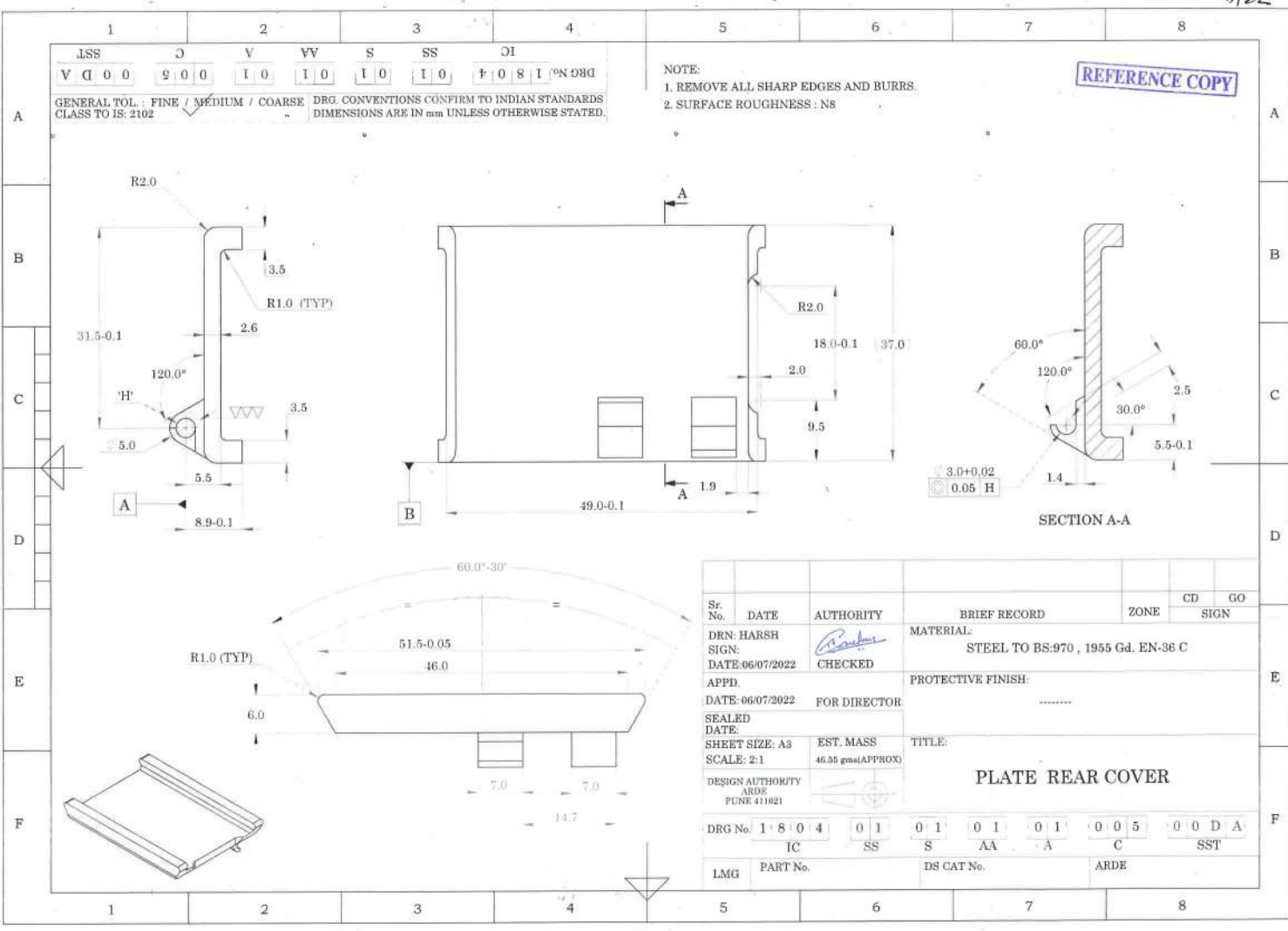
7/22

LSS	0	V	VV	S	SS	DI
V	0	0	0	1	0	1
0	0	1	0	1	0	1

GENERAL TOL : FINE / MEDIUM / COARSE DRG. CONVENTIONS CONFIRM TO INDIAN STANDARDS
CLASS TO IS: 2102 DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED.

NOTE:
1. REMOVE ALL SHARP EDGES AND BURRS.
2. SURFACE ROUGHNESS : NS

REFERENCE COPY



Sr. No.	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO
DRN: HARSH			MATERIAL:			
SIGN:			STEEL TO BS:970 , 1955 Gd. EN-36 C			
DATE: 06/07/2022		CHECKED	PROTECTIVE FINISH:			
APPD:						
DATE: 06/07/2022		FOR DIRECTOR				
SEALED			TITLE:			
DATE:			PLATE REAR COVER			
SHEET SIZE: A3		EST. MASS				
SCALE: 2:1		46.55 gms (APPROX)				
DESIGN AUTHORITY						
ARDE						
PUNE 411021						
DRG No.	1	8	0	4	0	1
	0	1	0	1	0	1
	0	1	0	1	0	0
	0	0	5	0	0	D A
	IC	SS	S	AA	A	C
						SST
LMG	PART No.	DS CAT No.	ARDE			

REFERENCE COPY

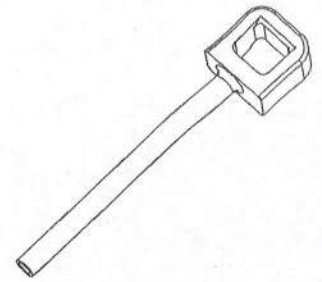
1	2	3	4															
LSS	O	V	VV															
V D 0 0	L 0 0	I 0	I 0															
SS	O	O	O															
I 0	I 0	I 0	I 0															
DRG No. 1 8 0 4			DRG No. 1 8 0 4															
A	GENERAL TOL. : FINE / MEDIUM / COARSE CLASS TO IS: 2102		DRG. CONVENTIONS CONFIRM TO INDIAN STANDARDS DIMENSIONS ARE IN mm UNLESS OTHERWISE STATED.															
B																		
C																		
D	<p>NOTE:</p> <ol style="list-style-type: none"> REMOVE ALL SHARP EDGES AND BURRS. SURFACE ROUGHNESS : N8 																	
E	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Sr. No.</td> <td style="width:15%;">DATE</td> <td style="width:20%;">AUTHORITY</td> <td style="width:30%;">BRIEF RECORD</td> <td style="width:10%;">ZONE</td> <td style="width:10%;">CD</td> <td style="width:10%;">GO</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> <td colspan="2" style="text-align:center;">SIGN</td> </tr> </table>			Sr. No.	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO						SIGN		
Sr. No.	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO												
					SIGN													
F	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:25%;">DRN: AKASH SIGN: DATE:06/07/2022</td> <td style="width:25%; text-align:center;"> CHECKED </td> <td style="width:50%;">MATERIAL: STEEL TO BS:970 , 1955 Gd. EN-36 C</td> </tr> <tr> <td>APPD. DATE:06/07/2022 FOR DIRECTOR</td> <td></td> <td>PROTECTIVE FINISH: ---</td> </tr> <tr> <td>SEALED DATE:</td> <td>EST. MASS 3.84 grams(Approx)</td> <td>TITLE: BUTTON FEED BOX</td> </tr> <tr> <td>SHEET SIZE: A4 SCALE: 2:1</td> <td style="text-align:center;"> </td> <td></td> </tr> <tr> <td>DESIGN AUTHORITY ARDE PUNE 411021</td> <td></td> <td></td> </tr> </table>			DRN: AKASH SIGN: DATE:06/07/2022	 CHECKED	MATERIAL: STEEL TO BS:970 , 1955 Gd. EN-36 C	APPD. DATE:06/07/2022 FOR DIRECTOR		PROTECTIVE FINISH: ---	SEALED DATE:	EST. MASS 3.84 grams(Approx)	TITLE: BUTTON FEED BOX	SHEET SIZE: A4 SCALE: 2:1			DESIGN AUTHORITY ARDE PUNE 411021		
DRN: AKASH SIGN: DATE:06/07/2022	 CHECKED	MATERIAL: STEEL TO BS:970 , 1955 Gd. EN-36 C																
APPD. DATE:06/07/2022 FOR DIRECTOR		PROTECTIVE FINISH: ---																
SEALED DATE:	EST. MASS 3.84 grams(Approx)	TITLE: BUTTON FEED BOX																
SHEET SIZE: A4 SCALE: 2:1																		
DESIGN AUTHORITY ARDE PUNE 411021																		
1	2	3	4															

SK-GPMG- 6258/2

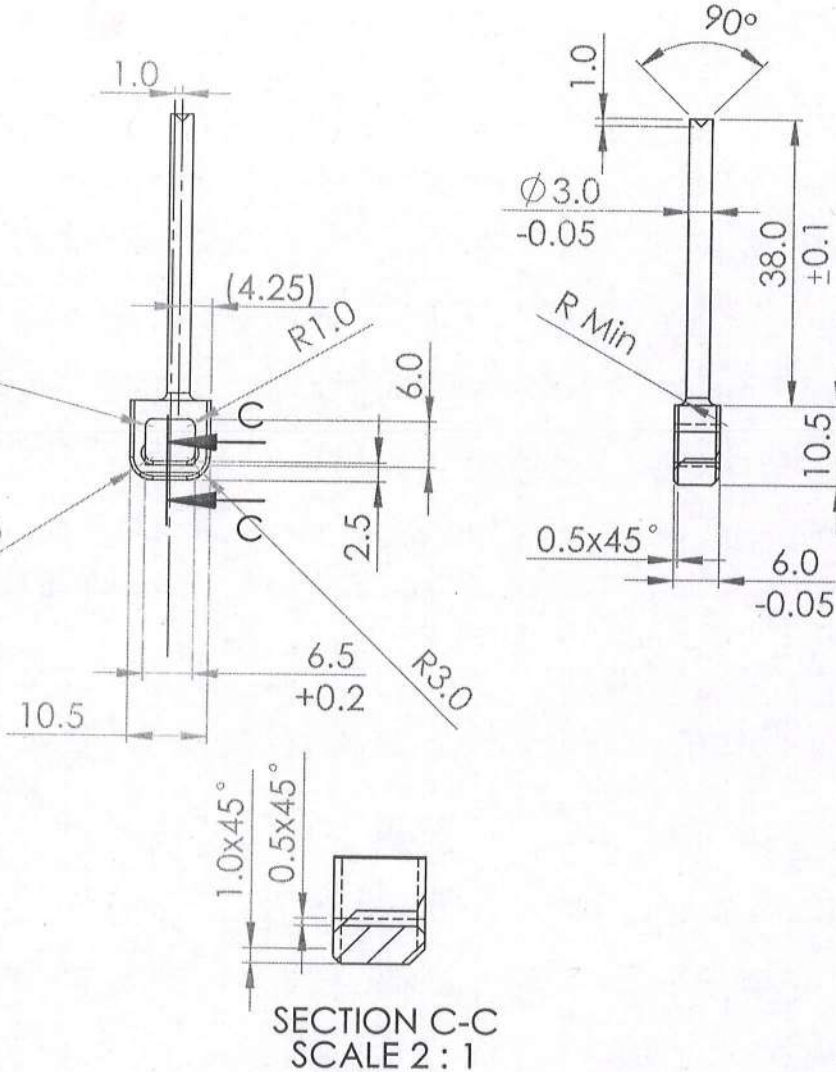
DRG. NO.

GEN. TOL. FINE/MEDIUM/COARSE
CLASS TO IS: 2102

DRG. CONVENTIONS CONFIRM TO INDIAN STD.
DIMN. IN mm UNLESS OTHERWISE STATED



ISOMETRIC VIEW
SCALE 2:1



MATERIAL:- STEEL TO BS : 970:1995 Gd En-36C

PROTECTIVE :- Phosphate to SPECN.
FINISH JSS:0465-01-1988

CLASS II(Accelerated)
Oil Finish

GPMG/MMG 7.62X51mm
PIN LOCKING FOLDABLE BUTT

DRAWN BY	<i>Bilal</i> KRAJESH LAKHERA
CHECKED BY	
APPROVED BY	<i>[Signature]</i>
DATE	07-08-2023

SCALE 1:1

SMALL ARMS FACTORY
KANPUR

DRAWING NO.
SK-GPMG- 6258/2

SHEET 1 OF 1

QUALITY ASSURANCE PLAN		QAP No.: ARDE/QAP/MMG/GPMG 7.62/BODY HOUSING RECEIVER ASSEMBLY	
Issue No. 1	Date	Revision No. 01	Date
Component / Assembly		Receiver	
		Page 1 of 4	

- Drawing no. : SK-GPMG-6258
- Method of Manufacture : Machining
1. Receiving inspection :
- 1.1. Raw Material : Steel to BS 970:1995GdEn 36C
- 1.2. Tests/ Checks and Acceptance Criteria for Raw Material:

Bu
Not mod
mill

S. No.	Test / Check	Parameter	Acceptance Value
1.	Chemical Analysis	Chemical Composition	As per Spec.
2.	Ultra-sonic Test As per ASTM A 578 LEVEL B	Cracks	No Crack Permitted
3.	Non - Metallic Inclusion Test	IS 4163-21	As per specification
4.	Mechanical Properties (Post heat treatment as per drawing)	Tensile Strength, MPa	As per specification
		0.2 % Proof Stress, MPa, min	As per specification
		% Elongation, min	As per specification

4. In - Process Inspection : Nil
5. Stage Inspection : Tool Marks, Scratch Marks dull surface, Surface Irregularities, Superficial Cracks Etc. to be inspected as per 6.1.1 Sr. No. 2
6. Final Inspection :
- 6.1. Visual Examination :
- 6.1.1. Feature for Visual Examination And Acceptance Criteria:

S. No.	Details of Features	Sample Size	Acceptance Criteria
1.	Sharp edges , Burrs	100%	Not allowed
2.	Tool Marks, Scratch marks, Dull surface, Surface irregularities, Superficial cracks, Weld beds Etc.	100%	Not Allowed
3.	All features like Chamfers, Radius, Undercut etc	100%	To be present

Prepared By:	Sc.'B'	Recommended By:	Sc.'E'
	SK Sharma		Bhupinder Singh

QUALITY ASSURANCE PLAN		QAP No.: ARDE/QAP/MMG/GPMG 7.62/BODY HOUSING RECEIVER ASSEMBLY		
Issue No. 1	Date	Revision No. 01	Date	Page 2 of 4
Component / Assembly		Receiver		

4.	Identification mark	100%	To be present
----	---------------------	------	---------------

6.2. Dimensional Inspection :

6.2.1. Critical Dimension : Sample Size – 100%

S.NO.	DIMENSIONS	Drawing no.	ZONE	METHOD OF INSPECTION
1.	206.56±0.05	BODY RECEIVER SK-GPMG- 6258/1	P – 5	G-9918
2.	12.52±0.04		P – 14	GLSK-R-1011
3.	213.0±0.05		J – 6	GLSK-R-1039
4.	20.33±0.04		K – 7	GLSK-R-1039
5.	74°		P – 15	GLSK-R-1011
6.	27.17±0.02		K – 7	GLSK-R-1039
7.	123.80±0.04		J – 6	GLSK-R-1039
8.	104.50±0.03		J – 4	GLSK-R-1039
9.	92.0±0.15		J – 7	GLSK-R-1039
10.	36.0±0.03		R – 4	GLSK-R-1039
11.	Φ23.0±0.02		P – 6	GLSK-R-1031
12.	13.58 Basic		R – 16	
13.	30.0±0.1		N-8	GLSK-R-1036 & GLSK-R-1016
14.	36.5-0.1(WIDTH FOR HOUSING TRIGGER)		G-8	
15.	20.5±0.1		G-7-8	
16.	1.0±0.1		T-8	
17.	37.0-0.1		G-7	

6.2.2. Major Dimensions : 100%

S.NO.	DIMENSIONS	ZONE	METHOD OF INSPECTION
1.	65.0±0.1	L – 4	TO BE CHECK BY FITMENT WITH HAND GUARD AND SCREW
2.	Section P-P	J - 15	G-8055,G-7306,G-7307,G-7308 , G-13806 & G-8017
3.	Detail AO	N – 2	G-7917
4.	94.0±0.1	L – 4	TO BE CHECK BY FITMENT WITH HAND GUARD AND SCREW
5.	Ø11.2 + 0.025	L – 8	GLSK-R-1013 & G-8062
6.	Ø8.0±0.025	K – 9	GLSK-R-1012
7.	5.635 ±0.040	P – 10	GLSK-1037& GLSK-1038
8.	5.0±0.045	P – 10	GLSK-R-6355
9.	34.6±0.1	J – 10	GLSK-R-1034 & GLSK-R-1035

Prepared By:	Sc.'B'	Recommended By:	Sc.'E'
	SK Sharma		Bhupinder Singh

QUALITY ASSURANCE PLAN

QAP No.: ARDE/QAP/MMG/GPMG 7.62/BODY HOUSING RECEIVER ASSEMBLY

Issue No. 1

Date

Revision No. 01

Date

Page 3 of 4

Component / Assembly

Receiver

10.	30.0-0.0	N - 1 0	MAG GAUGE
11.	Ø6.05±0.1 & POSITION 21.83	K - 4	GLSK-R-6534 ,GLSK-R-6353
12.	Ø18.03±0.05	L-5	
13.	Ø6.0+0.02(B-6)	HOUSING	GLSK-R-1023
14.	Ø5.3+0.02(A-8)	COVER 1804	GLSK-R-1022
15.	Ø4.1+0.05 (C-3)	01 01 01 01	GLSK-R-1021
16.	Ø2.87+0.02 (B-3)	003 00DA	GLSK-R-1018
17.	37.0-0.1(D-4)		G-11483
18.	11.0(B-7)		
19.	20.65+0.1(B-7)	HOUSING	GLSK-R-1030
20.	Ø7.05+0.02(B-9)	REAR SIGHT	GLSK-R-1024
21.	Ø3.4±0.02(C-5)	1804 01 01	
22.	37.0(B2,3)	01 01 002	
23.	1.0±0.1(C-7)	00DA	
24.	20.5+0.1(C-8)		GLSK-R-1029
25.	12.0+0.1(E-11)	COCKING	GLSK-R-1026 & GLSK-1027
26.	9.0+0.1(E-11)	SLIDE SLOT	GLSK-R-1025
27.	Ø3.0+0.02(C-7)	PLATE REAR	GLSK-R-1019
28.	31.5—0.01(C-1)	COVER 1804 01 01 01 01 005 00DA	
29.	Ø4.0+0.02(D-5)	BRACKET BARREL LATCH SK-GPMG- 6258/3	GLSK-R-1017
30.	SLIDE GAUGES FOR RECEIVER		G-10410,G-9431,G-10727&G-9296
31.	Ø3+0.012	(L-7)	GLSK-R-1015
32.	30.0+0.05	(L-12)	GLSK-R-1032
33.	20.5+0.1	L-2	
34.	45.2-0.1(C-5)	(RECEIVER)	
35.	Ø3.4±0.020(D-4)	SK-GPMG- 6258	GLSK-R-1020
36.	10.5(D-5)		
37.	Ø6.0+0.02(D-7)		
38.	18.30±0.04(D-6)		
39.	25.6±0.21(C-7)		
40.	7.5(B-7)		
41.	4.97±0.035(A-2)	BUTTON	
42.	Ø5.0±0.06(B-2)	FEED BOX 18040101 01 01 007 00DA	

Prepared By:

Sc.'B'

SK Sharma

Recommended By:

Sc.'E'

Bhupinder Singh

QUALITY ASSURANCE PLAN		QAP No.: ARDE/QAP/MMG/GPMG 7.62/BODY HOUSING RECEIVER ASSEMBLY	
Issue No. 1	Date	Revision No. 01	Date
Component / Assembly		Receiver	
Page 4 of 4			

43.	Ø3.0+0.05(C-3)	PLATE FRONT COVER 1804 01 01 01 01 006 00DA	
44.	37.0-0.1(B-3)		
45.	6.5+0.2(D-3)	SK-GPMG- 6258/2	
46.	1X45°(C-3)		
47.	6(D-3)		

6.3. Minor dimensions : all remaining dimensions (sample 2% of the lot. Minimum 2 QTY)

6.4. Tests on Finished items : As in Drawings.

6.4.1. Details of Tests / Checks on finished items and Acceptance Criteria.

S. No.	Test / Check	Sample Size	Acceptance Values
1.	Surface Roughness	100%	As per Spec.

7. Details of tests and other information: As in Drawings.

Prepared By:	Sc.'B'	Recommended By:	Sc.'E'
	SK Sharma		Bhupinder Singh