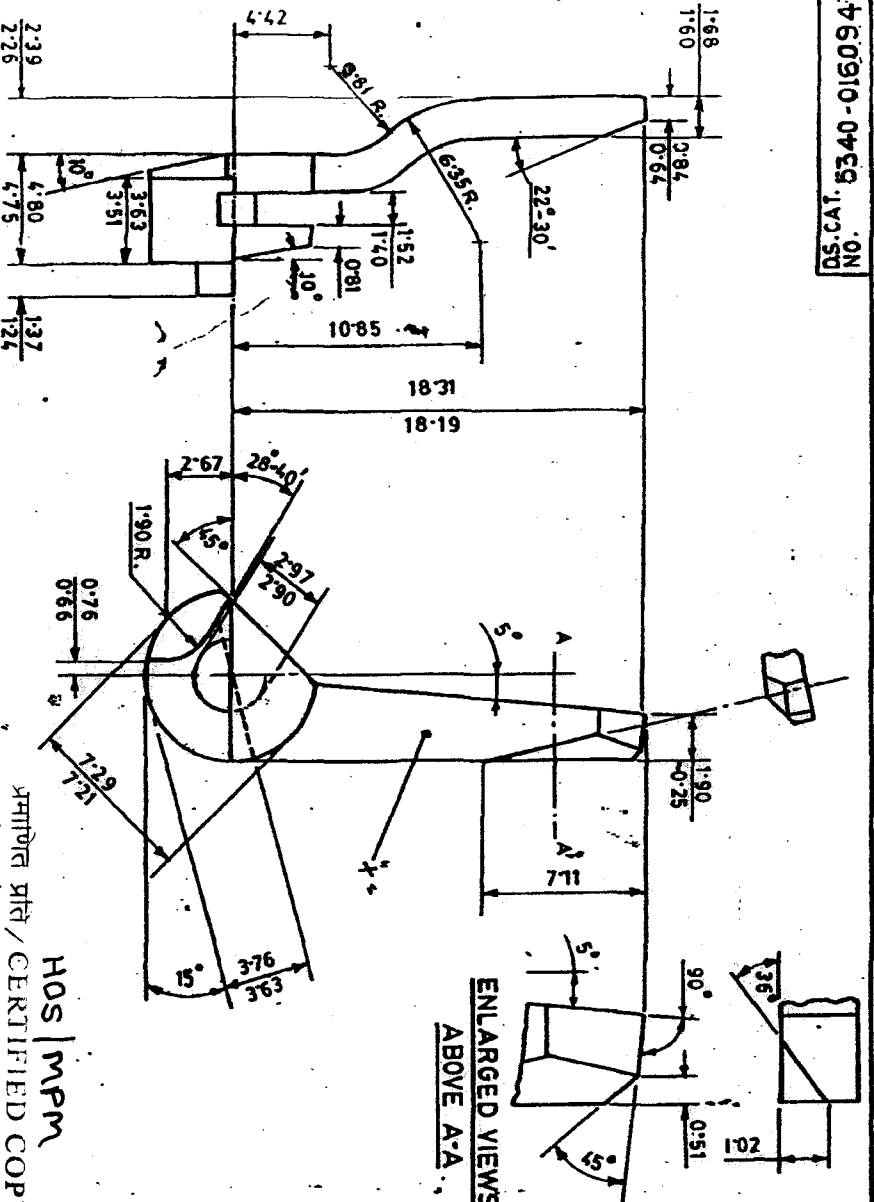


160910-0469 1.V.1.00



ENLARGED VIEWS  
ABOVE A-A

FOR EXPLANATION SEE C.S.A.I.D NOTE SHT. NO.1  
DIMNS. ARE IN M.M.

NOTE:  
WHERE TOLERANCES ARE NOT SHOWN  
DIMENSIONS IN WHOLE NUMBER ±0.25mm.  
DIMENSIONS WITH ONE DECIMAL PLACE ±0.25mm.  
DIMENSIONS WITH TWO DECIMAL PLACES ±0.13mm.

DECARBURIZATION SHOULD NOT EXCEED MORE  
THAN 2% OF THE BASIC SIZE.

MACHINING OPERATION OF 36° ANGLE CHAMFER  
BEFORE 22°30' & 45° CHAMFER ADDED.

(Q) MACROETCH TEST TO ASTM 361-1984 WILL BE  
AS PER COL(C) OF SL.NO.1 OF COA(SA) NOTE SHEET  
NO.1

(BINIR TEST TO IS:4163 WILL BE AS PER COL(C)  
OF SL.NO.3 OF COA(SA) NOTE SHEET NO.1

HEAT TREATMENT:-  
HARDEN & TEMPER GENERALLY TO A H.V.  
450-520 EQUIVALENT TO ROCKWELL 'D' 59-63  
MEASURED AT POINT 'X'

INVESTMENT CASTING:-  
MATERIAL BS 3146 PT. 1:1974 TYPE CLA 12 GR. C,  
HARDENED & TEMPERED TO 450-520 HV &  
COA (METAL) INSPECTION INSTRUCTION NO:  
EMR 0001H/T/C/GM/INST-2

HOS | MPM  
भारतीय शक्ति / CERTIFIED COPY OF  
ड्राइंग / लेआउट / गेज रिडयूल  
DRG/LAYOUT/GAUGE SCHEDULE  
दिनांक / AT THIS DATE... 7... 7... 17  
सी डी डी / CDD  
राइफल फैक्टरी, इशापुर

RIFLE FACTORY ISHAPUR

10-06-1626827-SA	MATERIAL AMENDED.	DRN.	CHD.	TRD. GANESH COMR. Ishapur	APPROVED	DI. 2-8-87	AHSP. COA(SA) (CHAPUR
02-7-2061	23055-SAS-DAYAN 5340-016094 WAS 1005-003157	SCALE:- NOT TO SCALE	EST. MASS	DI. 2-8-87	ASSY.	1008-003143	
08-9-99	PROGRAM CHANGED. ACTUAL SIZE VIEW DELETED. NEAT TREATMENT AMENDED. RE-RELEASED AND DRG. RE-RELEASED. PREVIOUS DC.NOS. 10688-5A1 11288-5A, 11888-5A, 114441-5A, 120021-5A, 21961-5A, 22660-5A, 22747-5A.	DI. 8-9-99	I/C: D.O.	NEG. RE-TRACED	REF.	DGNR'S CISA/333/1/4	
DATE	AUTHY.	BRIEF RECORD	ZONE	W/O	G.O.	H/HARDNESS:-	
SEALED:-	DC.NO. 11258-SA, DI. 5.5.72					PROTECTIVE FINISH:-	PHOSPHATE TO SPECN. JS:0465-01:1988 CLASS 1 OIL FINISH.
NOMENCLATURE							
<b>LEVER, TRIPPING</b>							
DRG NO. 5340-016094							

METRIC