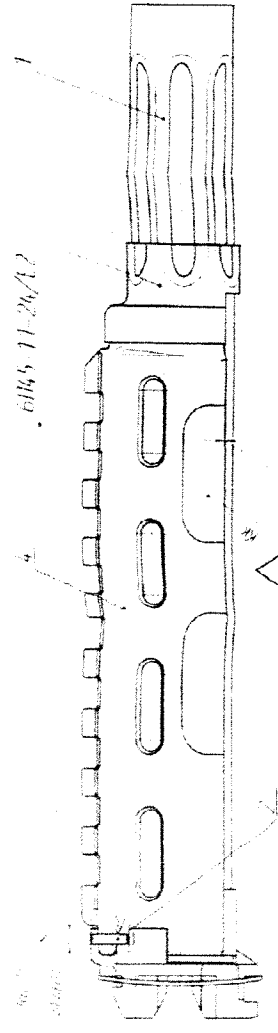


DRG. NO.-SK-6624/TE

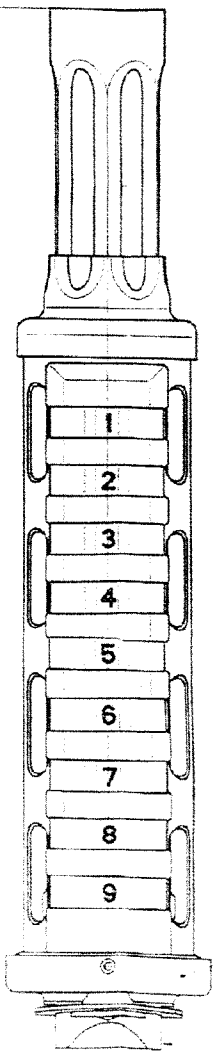
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1. Pin pos 2 to be pressed in first 4th stroke of spring
 6/15-11-25/F2 Profusion of pin over stroke of rest of stroke
 greater than 0.2 mm, depression is not greater than 0.1 mm

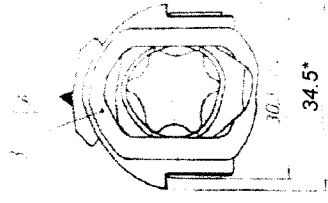
176.5*



6/15-11-25/F2

रिपोर्ट होस/ मम

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 क. प्रमाणित प्रमाणित
 Jr. Works Manager



- 1 * Reference dimensions
- 2 Ensure perpendicularity between all components
- base assembly pos 1 before drilling
- 3 Longitudinal and cross pass of hole must be drilled in same
 assembly is not allowed, ensure absence of any depression
- 6/15-11-24/L2
- 4 Pin pos 2 to be pressed in first 4th stroke of spring
- 6/15-11-25/F2 Profusion of pin over stroke of rest of stroke
 greater than 0.2 mm, depression is not greater than 0.1 mm
- 5 Stamp

S.NO.	NOMENCLATURE	DRG. NO.
1	BASE ASSEMBLY (a) TUBE (b) FRONT RING (c) REAR RING	SK-6625/TE SK-6626/TE SK-6627/TE SK-6628/TE
2	PIN	SK-6629/TE
3	SPRING	SK-6630/TE
4	HAND GUARD	SK-6631/TE

7.62X39mm AR-SAF

HAND GUARD ASSEMBLY
 ASSEMBLY DRAWING

SCALE
 1 : 1

SMALL ARMS FACTORY
 KANPUR

DRG. NO. J.W.M./DDO

SK-6624/TE

SHT. 1 OF 1

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DRG NO - ON - SK-6626/TE

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D.A. NO. 9

V/W

175.5₋₁

89.5 ± 0.5*

Rz 20

R15*

R100*

13.0*

Rz 20

φ20_{-0.28}

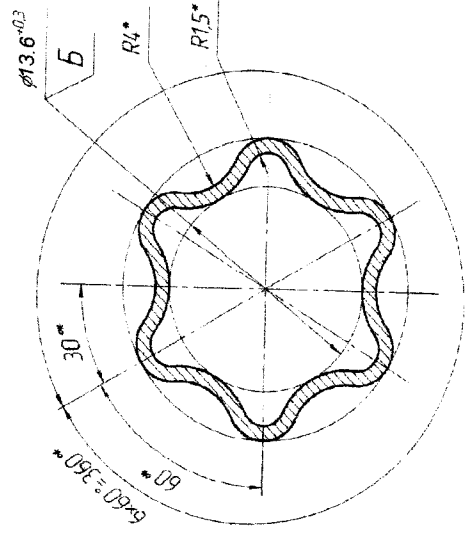
φ18_{+0.12}

R5*

R8*

8.7^{+1.3}

A-A (4:1)



- 1 *Dimensions to be ensured by tool.
- 2 ** Reference dimension.
- 3 Unspecified tolerances according to 6745-1.CITY/E2

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क. क. श्री
Jr. M.A.

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	SK-6626/TE	
SHT.	1	OF 1

7.62X39mm AR-SAF
TUBE

SCALE
1 : 1

SMALL ARMS FACTORY
KANPUR

SHT. 1 OF 1

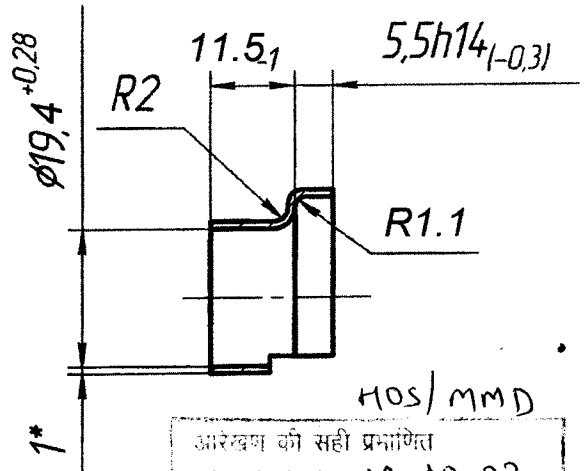
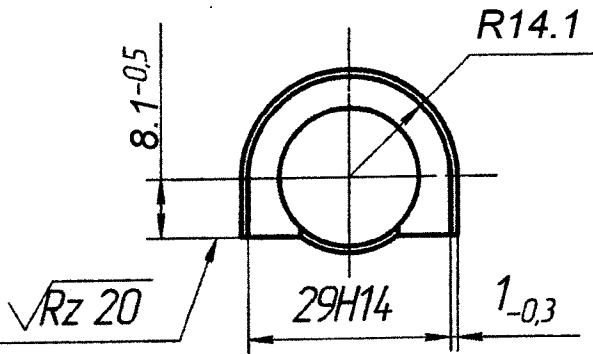
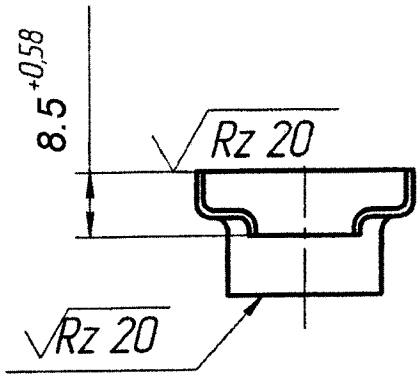
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COPY No. 1

✓/✓/✓



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क. सी. ...
Jr. ...

- 1 *Reference dimension.
- 2 Unspecified tolerances according to 6П45-1.ССТУ/Е2.
- 3 Appearance according to control sample.

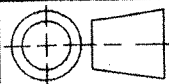
7.62X39mm AR-SAF

FRONT RING

DRAWN	TRACED	CHKD.
A.VERMA		
DATE	16-10-2023	
APPROVED		
JWM/DDO		

SCALE

1:1



SMALL ARMS FACTORY
KANPUR

DRG.NO.

SK-6627/TE

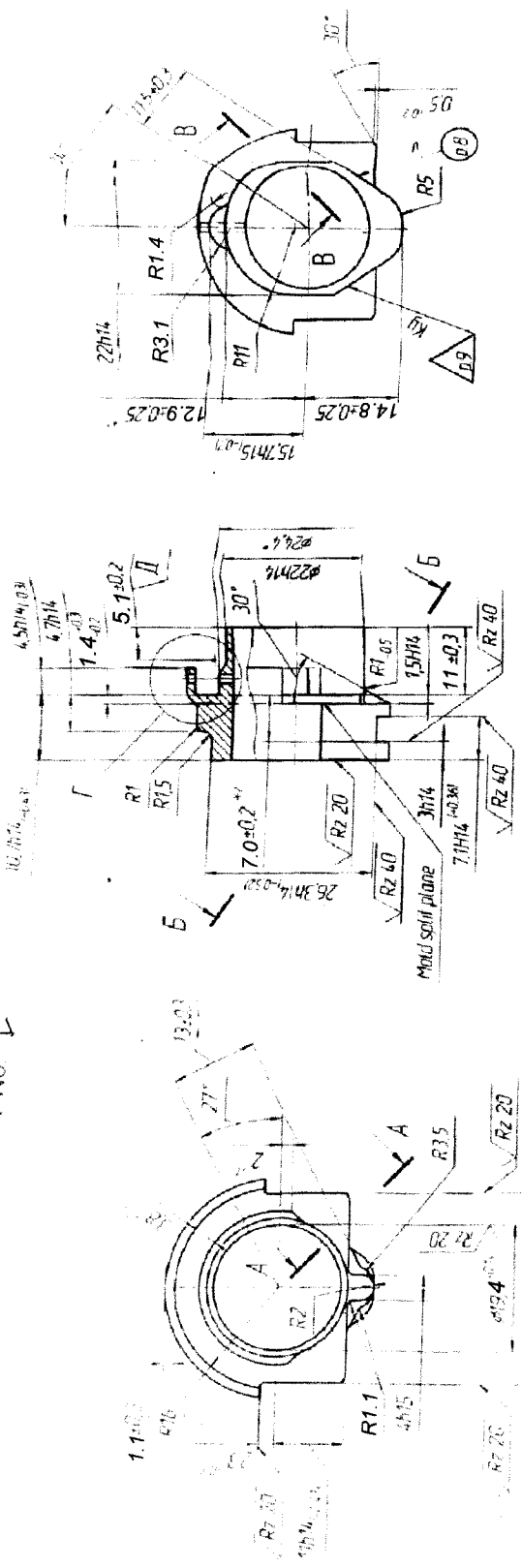
SHEET 1 OF 1

DRG. NO.-SK-6628/TE

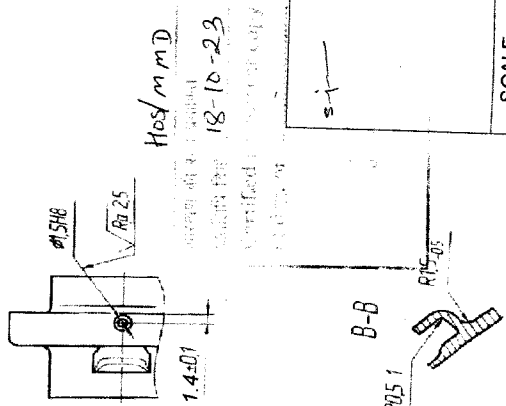
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D.A. NO.



- 1 * Reference dimensions
- 2 *1 Dimension for positioning hole axis in casting
- 3 *2 Dimension for casting contouring
- 4 Unspecified cast rounding radii of outer and inner angles are 0.5 mm
- 5 Partem draft angles are within dimensional tolerance
- 6 Unspecified tolerances according to G145-168TY/E2
- 7 Quantity, size and position of cast defects, mold split trace - according to control sample
- 8 Mark mold number using font 3-flp3 GOST 26.008-85
- 9 Stamp.



18-10-23
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 18-10-23

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J.W.M./DDO.		
DRG. NO.		
SK-6628/TE		
SHT 1 OF 1		

7.62X39mm AR-SAF
 REAR RING
 SMALL ARMS FACTORY
 KANPUR

SCALE
 1:1

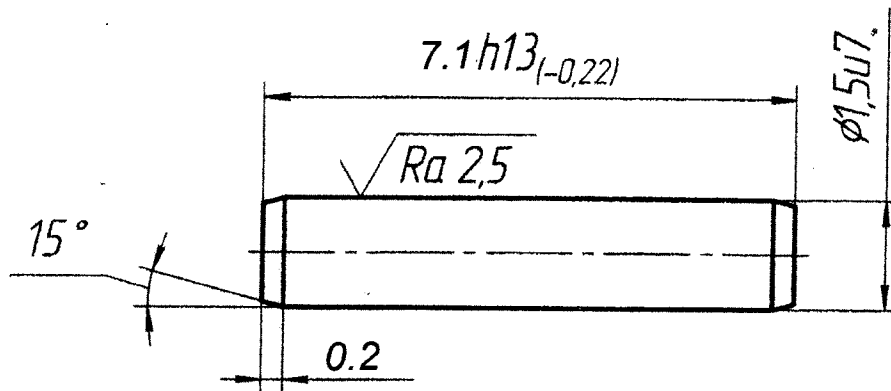
DRG. NO. SK-6629/TE

D.A. NO.

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$\sqrt{Rz 20 (\checkmark)}$



1 397 ... 485 HV 0,1 % of parts from lot but not less than 3 pcs to be checked.

2 Unspecified tolerances according to 6П45-1.08ТУ/Е2 *pos/mm D*

3 Coating is Chem. Phos. chr. with oiling.

4 Stamp K, VI on lot label.

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Signature

7.62X39mm AR-SAF

PIN

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SCALE

1:1



SMALL ARMS FACTORY
KANPUR

DRG. NO.

SK-6629/TE

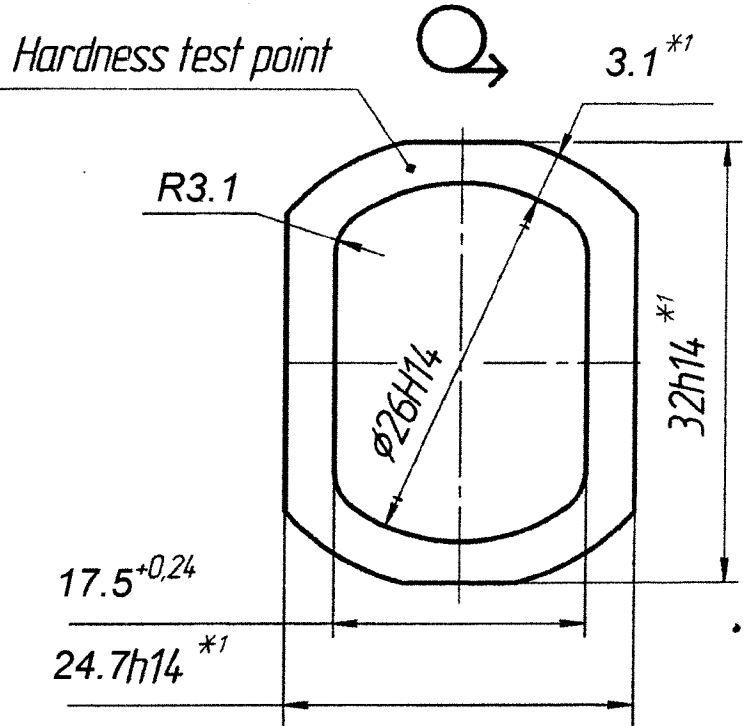
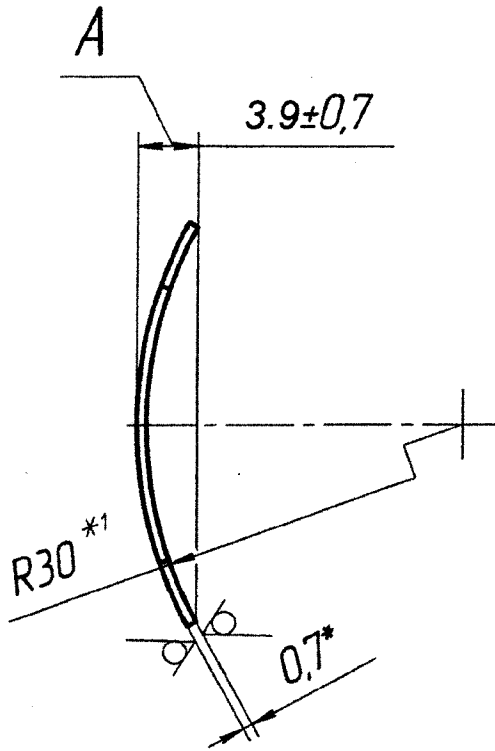
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DRG. NO.-SK-6630/TE

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D.A. NO.

$\sqrt{Rz 40 (\checkmark)}$



1 73,5.76 HRA 10 % parts from lot, but not less than 5 pcs to be checked.

2 *Reference dimension.

3 *1 Dimensions to be ensured by tool.

4 Coating is Chem. Phos. chr/impreg. with БФ-4 glue GOST 12172-2016 with nigrosine of grade A GOST 9307-78.

5 It is allowed to apply coating together with base assembly 6П45-1.СД1-2/Е2.

6 Prestress 5 % of springs from lot if dimension A is from 0,7 to 1,2 mm.

105/mm) Prestressing time is 24 hours.

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SPRING

क. कार्यालय
Jr. Work

SCALE

1:1



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KANPUR**

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DATE

16-10-2023

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DRG.NO.

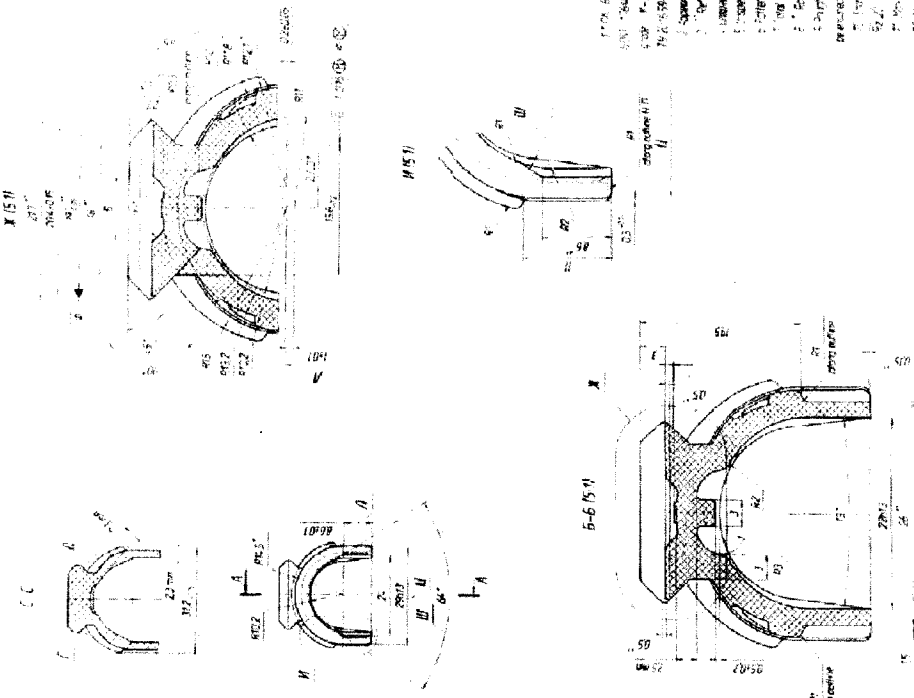
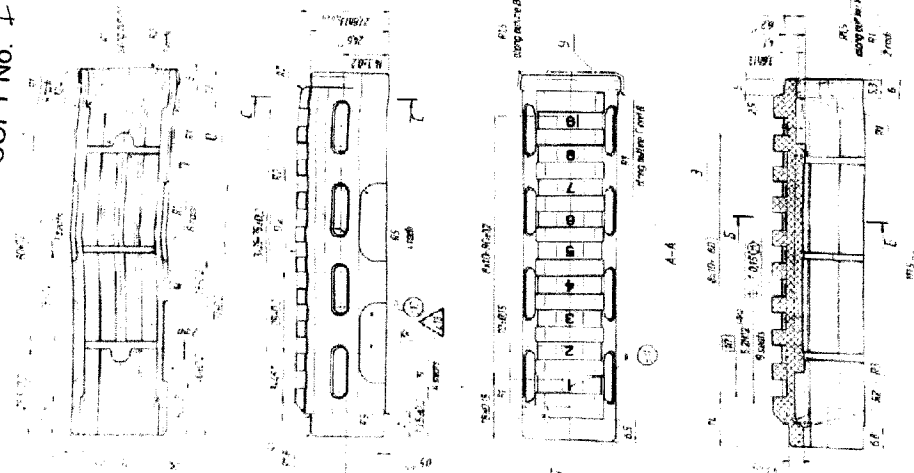
SK-6630/TE

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DRG. NO.-SK-6631/TE

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Checked by: HOS/mmd
 Drawn by: HOS/mmd
 Date: 18.10.23
 Certified as correct copy of drg. (as per)

Sd/-
 HOS/mmd
 Jr. Wg.

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7.62X39mm AR-SAF

HAND GUARD

SMALL ARMS FACTORY
KANPUR

SCALE

1:1



1

2

3

4

5

6

7

8

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