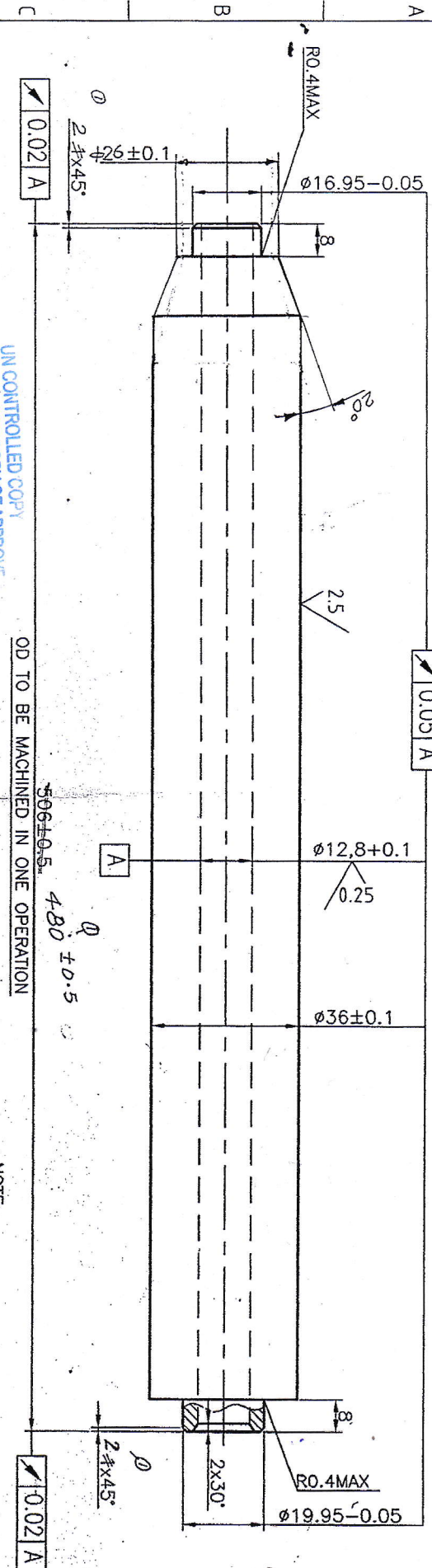


INPUT BARREL BLANK (WITH CHAMBER) 0.315" SPORTING RIFLE



UN CONTROLLED COPY
 CERTIFIED CORRECT COPY OF APPROVED
 DRAWINGS AT THIS DATE: 07/19/25

DESIGN & DRAWING OFFICE,
 ORDNANCE FACTORY, TRUCHARAPPAH-620 016

THERE SHOULD NOT BE ANY MARKS
 INSIDE THE BORE

MATERIAL:-
 SPECN. JSS:9510-06-2000 (REVISION 3)

CODE REF. 'B' - 'T' CONDITION

ALT. MATERIAL:-
 SPECN. BS970 PT.1-1983 GR.708M40

'T' CONDITION

STRAIGHTNESS OF BORE:-
 A PLUG OF 150 LONG 0.020 LESS
 THAN THE ACTUAL BORE SHOULD
 PASS THROUGH WHEN BARREL
 IS PLACED VERTICALLY.

HARDNESS 255HB MAX.
 MAX. DIFFERENCE = 20HB ON SAME BLANK
 DRILLING TO BE DONE FROM ONE SIDE ONLY

Approved By

J.T. GM / M

EXPTL.

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

NOTE:-
 THE STEEL SHOULD BE PRODUCED BY
 SECONDARY REFINING ROUTE
 THE STEEL SHALL BE CALCIUM SILICIDE TREATED

THE FOLLOWING RESTRICTIONS
 IN S&P CONTENTS
 WILL APPLY FOR BOTH THE ABOVE SPECN.

%S=0.010 MAX.
 %P=0.015 MAX.
 (%S+%P)=0.022 MAX.

NMIR TEST AS PER IS:4163 (FIG.2)
 THIN - ABCD - 2 MAX. FOR EACH TYPE
 THICK - 0.5 MAX. FOR A&D
 AND NIL FOR B&C

PART NO.	DESCRIPTIONS	SIGNATURE & DATE	NO. OF	MATERIAL	TREATMENT	REMARKS
1	INPUT BARREL BLANK BEFORE COLD SWAGING FOR BARREL (WITH CHAMBER) OF 0.315" SPORTING RIFLE	<i>[Signature]</i> 11/02				
DRG. No.: TEND 1745 * ORDNANCE FACTORY TRUCHARAPPAH-16.						
OPERATION NO. 29P0001						SCALE 1:1
STORE DRG. NO. 29P0001						SHEETS: 01 SHEET No.: 01

AMENDMENTS	SIG.	DATE
1	<i>[Signature]</i>	11/02

DR. No. 002/05

1 2 3 4 5 6 7 8