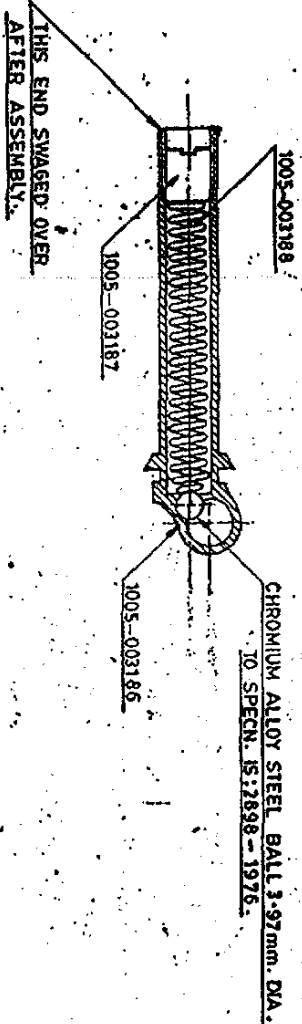


D.S.CAT. NO. 5360-007390



DIMNS. ARE IN mm.

NOTES:-

FOR EXPLANATION OF DIMENSIONING ETC. SEE C.S.A.I.D. NOTE SHEET NO.1.

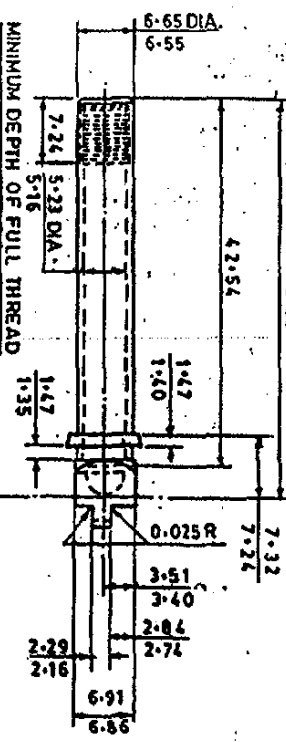
WHERE TOLERANCES ARE NOT SHOWN,

- I) DIMENSIONS IN WHOLE NUMBER ± 0.25 mm.
- II) DIMENSIONS WITH ONE DECIMAL PLACE ± 0.25 mm.
- III) DIMENSIONS WITH TWO DECIMAL PLACES ± 0.13 mm.

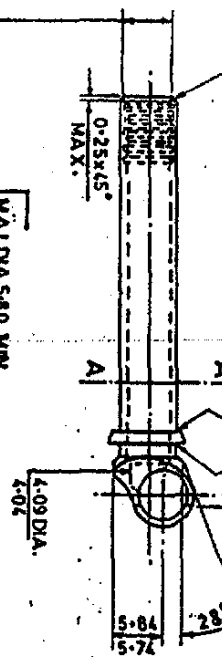
METRIC

DRN.	CHD.	TRD. <i>Shank</i>	COMP. <i>Welds</i>	ASFR. COA(SA) ICHAFUR
SCALE:- NOT TO SCALE.	EST. MASS:-	APPROVED	DI. 2.8-67	ASSY. 1005-003141
DI. 8.10.20M	MATERIAL:-	NEG. RE-TRACED		
	H.T./HARDNESS			
	PROTECTIVE FINISH:-			
	PHOSPHATE CLASS-II(ACCELERATED), OIL FINISH.			
DATE	AUTHY	ZONE	IC/D. O.	G.O.
29.12.84	DR. J. S. 27			
SEAL ED:-	D. C. NO. 11256-SA, DI. 3.5.72			
NOMENCLATURE:- GUIDE, SPRING, MAIN, ASSEMBLY.				
DRG. NO. D.S.CAT. 5360-007390				

981E00 - 50 01 D.S.CAT. NO. 45.95

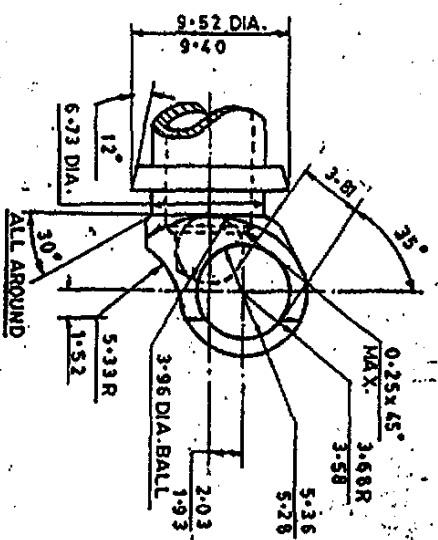


THIS EDGE SWAGED OVER AFTER ASSY.



M.S.X.0.45-6H (THREADS TO SPEC. IS 478-1967)

N.A. DIA. 5.80 MM. EFF. DIA. 5.508 ± 0.095 MINOR DIA. 5.313 ± 0.135 (R:H)



ENLARGED VIEW TO RIGHT OF LINE 'AA'

NOTE :-  
 WHERE TOLERANCES ARE NOT SHOWN:  
 I) DIMENSIONS IN WHOLE NUMBER ±0.25mm.  
 II) DIMENSIONS WITH ONE DECIMAL PLACE ±0.25mm.  
 III) DIMENSIONS WITH TWO DECIMAL PLACES ±0.13mm.  
 a) MACROETCH TEST TO ASTM E 381-1984 WILL BE AS PER COL. (C) OF SL. NO. 1 OF COA(SA) NOTE SHEET NO. 1.  
 b) NMIR TEST TO IS: 4163 WILL BE AS PER COL. (C) OF SL. NO. 3 OF COA(SA) NOTE SHEET NO. 1.

NOTE :-  
 FOR SPECIFICATION LATEST ISSUE SHOULD BE FOLLOWED

METRIC

1-1-1000/24885-SA	IN ASSY. COLUMN S.CAT. NO. 5360-007390 WASHINGS-003185								
ID-S-2000	PROGRAM CHANGED, ACTUAL SIZE VIEW DELETED, NEG. RE-TRACED AND DRG. RE-SEALED								
DATE AUTHY	PREVIOUS D.C. NOS. 10680-SA, 11331-SA, 11331-SA, 11331-SA, 11331-SA, 14662-SA, 15462-SA, 16702-SA, 17377-SA, 17661-SA, 18663-SA, 19543-SA, 21957-SA, 22660-SA, 23373-SA								
	BRIEF RECORD								
	SEALED:- D.C. NO. 11258-SA, DTS. 5.7.2.								

DRN	SCALE:- NOT TO SCALE	DRN	SCALE:- NOT TO SCALE
1-1-1000/24885-SA		1-1-1000/24885-SA	
1-1-1000/24885-SA		1-1-1000/24885-SA	
1-1-1000/24885-SA		1-1-1000/24885-SA	

DRN	SCALE:- NOT TO SCALE	DRN	SCALE:- NOT TO SCALE
1-1-1000/24885-SA		1-1-1000/24885-SA	
1-1-1000/24885-SA		1-1-1000/24885-SA	
1-1-1000/24885-SA		1-1-1000/24885-SA	

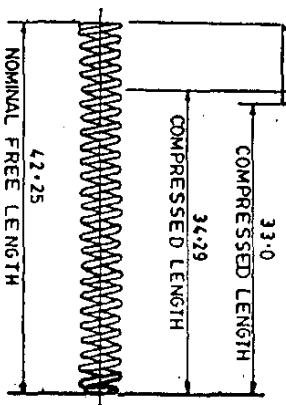
DRN	SCALE:- NOT TO SCALE	DRN	SCALE:- NOT TO SCALE
1-1-1000/24885-SA		1-1-1000/24885-SA	
1-1-1000/24885-SA		1-1-1000/24885-SA	
1-1-1000/24885-SA		1-1-1000/24885-SA	

NOMENCLATURE :- **GUIDE, SPRING, MAIN**

DRG. NO.	D.S. CAT. 1005-003186
PART NO.	
DRG. NO.	D.S. CAT. 1005-003186

881C00-5001  
D.S.CAT.  
35%

1.25 K.G.  
1.45 K.G.  
27.5%



DI.A OF WIRE 0.71  
MEAN DIA. OF SPRING 4.10  
TOTAL NO. OF COILS 25  
MAXIMUM SOLID HEIGHT 17.83  
SPRING TO BE WOUND RIGHT HAND.  
ONE END COIL TO BE CLOSED IN AND GROUND  
SQUARE TO THE AXIS OF THE SPRING.  
OTHER END TO HAVE ONE COMPLETE COIL  
REDUCED TO I.D. OF 2.62 TO BE CLOSED IN  
AND GROUND TO FORM BALL SEAT.



FOR EXPLANATION SEE C.S.A.I.D. NOTE SHEET NO.1  
UNITS ARE IN M.M.  
WHERE TOLERANCES ARE NOT SHOWN  
i) DIMENSIONS IN WHOLE NUMBER ±0.26mm.  
ii) DIMENSIONS WITH ONE DECIMAL PLACE ±0.25mm  
iii) DIMENSIONS WITH TWO DECIMAL PLACES ±0.13mm.

DEEP EIGN TEST AND OTHER TESTS  
SPECIFIED IN THE CONCERNED MATERIAL  
SPECN. MUST BE CARRIED OUT.

CRAMP TEST  
THE SPRING TO BE COMPRESSED TO A LENGTH  
OF 19.81 FOR A PERIOD OF 12 HOURS BEFORE  
GAUGING.

THE SPRING WHEN COMPRESSED TO 33.0 IS TO  
WORK FREELY IN A BORE OF 5.16 DIA.

SPRING LOADING-STATIC.  
ALL SET IS TO BE REMOVED FROM SPRING  
BEFORE TESTING AND GAUGING.

होस/मपम  
प्रमाणित प्रति/CERTIFIED COPY OF  
समस्या/वेगनाए/भत फिस्ट्रन  
DRG/LAYOUT/GAUGE SCHEDULE  
दिनांक/AT THIS DATE...10-2-17  
श्री सी जी/CDD  
उत्पन्न कारखाना/फाक्ट्री  
RIFLE FACTORY, ISHAPORR

16.04.16	26B16SN	MATERIAL AMENDED.				DRN	CHD.	TRD	CHK	COMP.	AHSP	COA(SA)ICHAPUR
10-11-2000	244568-SA	PROGRAM CHANGED. ACTUAL SIZE VIEW DELETED, PROTECTIVE FINISH AM IN D.O. NEG. RE-TRACED AND DMG. RE-SEAL ED. PREVIOUS D.C. NOS: 10888-SA, 11758-SA, 11458-SA, 16002-SA, 22642-SA, 22686-SA, 23892-SA & 2458-SA.				SCALE:- 2:1	APPROVED	DT 2.8.67			ASSY	3360-007390
DATE	AUTHY.	BRIEF RECORD	ZONE	UC/DO	GO	MATERIAL:-	IS: 4454	PT. 1: 200d	Gmuda	DH.	DRG'S	CISA 333/8/3
SEALED :-	D.C. NO. 11258-SA,	DT. 5.5.72.				H.T/HARDNESS:-					PART NO.	
NOMENCLATURE :-							PROTECTIVE PHOSPHATE TO SPECL JSS: 0465-01:1988 FINISH :- CLASS III (ACCELERATED) JOIL FINISH.					
							D.S.CAT NO. 1005-003188					

1005-003187

FOR EXPLANATION SEE C SAID. NOTE SHEET NO. 1

D.S.CAT DIMS. ARE IN mm.

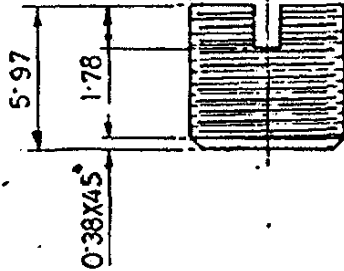
MAJ. DIA. 5.78

EFF. DIA. 5.488

MINOR  $\varnothing$  5.228

0.89

M5.8x45-6g  
(THREAD TO  
SPECN. IS: 4218-  
1967)



ACTUAL SIZE

NOTES :-

MACROETCH TEST WILL BE AS PER COL (d) OF SL. NO. 1 OF CQA(SA) NOTE SHEET NO. 1.

WHERE TOLERANCES ARE NOT SHOWN.

I) DIMENSIONS IN WHOLE NUMBER

$\pm 0.76$  mm.

II) DIMENSIONS WITH ONE DECIMAL PLACE

$\pm 0.25$  mm.

III) DIMENSIONS WITH TWO DECIMAL

PLACES  $\pm 0.13$  mm.

METRIC

1-11-2000	24858-SA	IN ASSY. COLUMN D.S.CAT. NO. 5360-007390 WAS 1005-003185		<i>Arlo</i>	<i>JM</i>
03-4-99	24311-SA	PROFORMA CHANGED, NEG. RE-TRACED AND DRG. RE-SEALED.		<i>Arlo</i>	<i>SA</i>
		PREVIOUS D.C. NOS. 10688-SA, 11258-SA, 11885-SA, 14459-SA, 16100-SA, 19492-SA, 20764-SA, 22642-SA & 23542-SA.			COPY.

DATE AUTH. BRIEF RECORD ZONE I/C; D.O. G.O. SEATED:- D.C. 11258-SA, DT. 5.5.72 SIGN.

DRN. CHD. TRD. SHANUDD COMP. *Arlo* AHSP. CQA(SA), ICHAPUR  
SCALE:- 1:1 & 4:1 EST. MASS. ASSY. 5360-007390  
DT. 3-4-99 *Arlo* APPROVED. DT. 2.8.67 NEG. RE-TRACED I/C; D.O.

MATERIAL:- BS: 970 Pt. 3-1991 GR. 070 M20 OR IS: 4431: 1978 GR. 11 C-10 S-25

H.T./HARDNESS. DGNR'S. CISA/333/8/1 REF.

PROTECTIVE FINISH AS ON ASSY. PART NO.

NOMENCLATURE **PLUG, GUIDE** DRG. NO.

D.S.CAT. NO. **1005-003187**