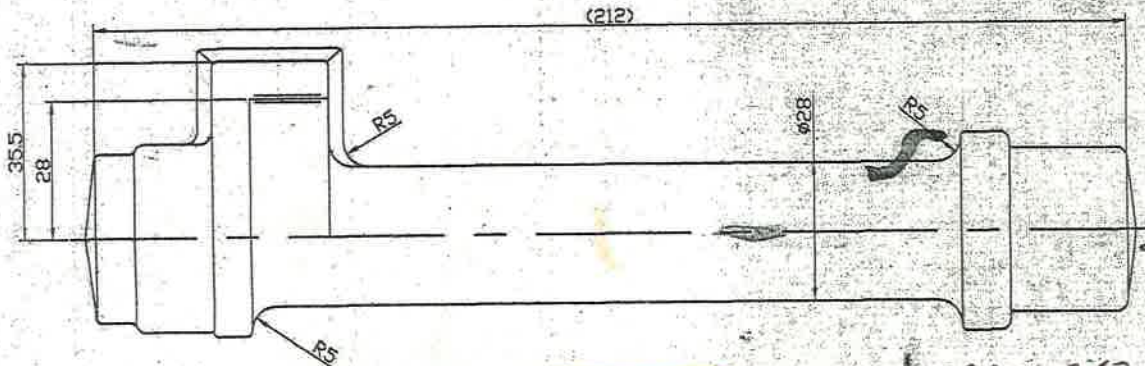
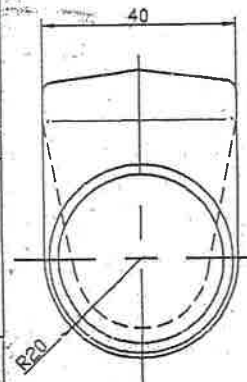
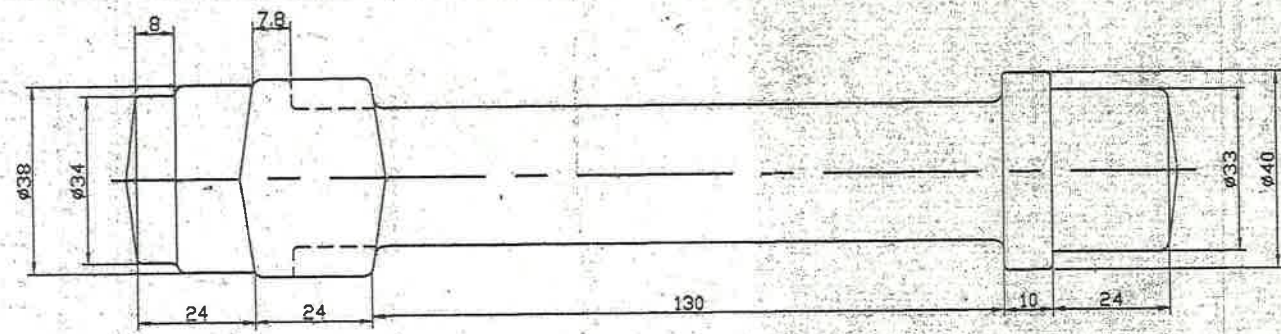


DRG. NO. SKM-306*

I.O.F.SA	F/DO	D.A.NO.
	Sd. A.N. KAPOOR	M-33/83
AK BOLA	Sd. A.N. KAPOOR	MATL. VETTED
ICHATTERJI	Sd. N.K. ROY	M-1/93
Sd. N.K. ROY	Sd. S.B. ANON	M-14/96
HT. & NO. added	Sd. A.N. KAPOOR	M-6/10

NMIR TEST added.
 15/6/14
 4/12/2010
 MA-2/14
 M-3/17



MATERIAL: BS 970 PT-1: 1996 GR060 A62 OR GR 060 A 67 OR GR 080 A 67

DRAFT ANGLE 7° ALL OVER

Inclusion	Thick	Thin
A	0.5	1.5 MAX
B	NIL	
C		
D		

HEAT TREATMENT-
 NORMALISED 75-90 Kg/mm².

NOTE
 ACCEPTANCE STANDARDS FOR MACRO ETCH TEST
 AND MICROSCOPIC DETERMINATION OF NON METALLIC
 INCLUSIONS FOR STEEL
 i) MACRO ETCH TEST AS PER ASTM E 381
 WITH ACCEPTANCE STANDARD AS C2, R2, S2
 ii) NMIR TEST AS PER IS: 4163-82

Inclusion Type	Thick	Thin
A, B, C, D	Nil	1.5 (max)

REF. COA (MET) Letter No. COA/M/0A-1/S.56mm
 Dt. 08 July 2014
 DIMENSIONS ARE IN mm.
 TOLERANCES ON ALL DIMNS. TO BE AS PER IS 3469 (PART I-III) 1974
 ALL SHARP CORNERS BLENDED TO 2.5 R-MAX.

ITEM	DESCRIPTION	NO'S	MATERIAL	TREATMENT	DIMNS.	STD.
STORE	MACHINEGUN 7.62mm					
PART	CYLINDER GAS	DRG NO.	NO. 12025 BA	D.A. NO.		

FORGING DRAWING

SECTION	MACHINE	SCALE	TRCD	CHKD	F/D.O	FTR	F/SY	DMP.3
ORDNANCE EQUIPMENT FACTORY KANPUR								

MACHINE GUN 7.62mm (TK-71) MAG
 CYLINDER GAS, D.S.CAT NO. 1005-006648

FORGING DRAWING

(TRUE COPY OF FORGING DRAWING NO SE-6)

SCALE 1:1
 SMALL ARMS FACTORY
 KANPUR

DRG NO SE-6	
DATE 13.9.73	SHEET 1/1
DRAWN (TRACED) CHECKED	
DATE	
APPROVED (PROV)	
DRG. NO. SKM-306* 345	
SHT. 1 OF 1	

ORIGINAL DATE OF APPROVAL 23.4.75

COMPD BY: Sd. A.N. KAPOOR 20.3.85

ORIGINAL