

UN CONTROLLED COPY

CERTIFIED CORRECT COPY  
OF APPROVED DRAWING  
AT THIS DATE: 4/03/17

S. Vanhook

Design & Drawing Office  
Ordnance Factory,  
Viruchirappalli 630016

**MATERIAL IN CASTING ROUTE: -**

BS:3146 PART -1: 1974

TYPE - CLASS: 5 GRADE--A.

(NON-STRESSED COMPONENT)

RADIOGRAPHIC TEST AS PER ASTM-E-192

CAS HALL 1: EGGSTON MATERIAL 14 00 0

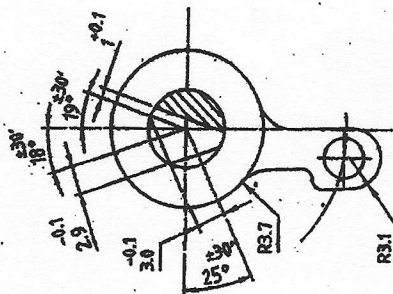
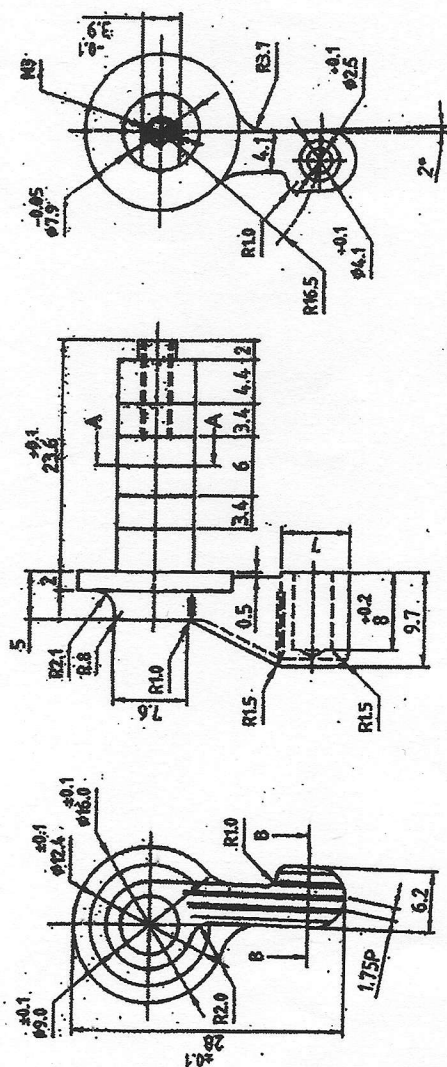
**SHRINKAGE (ALL TYPES) = 1.00 - 1.00**

CASTING SHOULD BE FREE FROM DEFECTS LIKE CRACKS

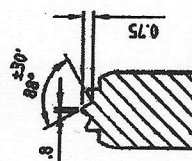
SEWING SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT TEARS, COLD SHUTS, ETC. AND SURFACE FINISH

**MUST BE SMOOTH.**

~~UNTOLERATED BURNS ARE AS PER IS : 11136-1984 CLASS 4~~



SECTION A-A



**SECTION B-B**  
**(ENLARGED)**

**MATERIAL : IS: 5517 -- 1993, GRADE -- 42Cr4Mo2**

(OR) BS:970, PART-3, 1991, GRADE - 709M40

ALTERNATE MATERIAL : En19

HARDNESS: 37 - 42 HRC

DIMENSIONS ARE IN: mm.

UNTOLERATED DIMNS. AS PER IS : 2102 (MED)

SHARP CORNERS SHOULD BE BLUNT TO R 0.5

**PROTECTIVE FINISH : PHOSPHATED TO SPECIFICATION. JSS : 0465-01-1988**

CLASS--1 (ACCELERATED) OIL FINISH.

|                                                                     |  |   |  |   |  |   |  |   |  |
|---------------------------------------------------------------------|--|---|--|---|--|---|--|---|--|
| MATERIAL : IS: 5517 - 1993, GRADE - 42Cr4Mo2                        |  | 1 |  | 2 |  | 3 |  | 4 |  |
| (OR) BS:970, PART-3, 1991, GRADE - 709M40                           |  |   |  |   |  |   |  |   |  |
| ALTERNATE MATERIAL : EN19                                           |  |   |  |   |  |   |  |   |  |
| HARDNESS: 37 - 42 HRC                                               |  |   |  |   |  |   |  |   |  |
| DIMENSIONS ARE IN mm.                                               |  |   |  |   |  |   |  |   |  |
| UNTOLERATED DIMNS. AS PER IS : 2102 (MED)                           |  |   |  |   |  |   |  |   |  |
| SHARP CORNERS SHOULD BE BLUNT TO R 0.5                              |  |   |  |   |  |   |  |   |  |
| PROTECTIVE FINISH : PHOSPHATED TO SPECIFICATION. JSS : 0465-01-1988 |  |   |  |   |  |   |  |   |  |
| CLASS-I (ACCELERATED) OIL FINISH.                                   |  |   |  |   |  |   |  |   |  |

|                         |  |                                 |  |                              |  |          |  |           |  |                |  |
|-------------------------|--|---------------------------------|--|------------------------------|--|----------|--|-----------|--|----------------|--|
| PART NO.                |  | DESCRIPTIONS & SIGNATURE & DATE |  | NO OFF                       |  | MATERIAL |  | TREATMENT |  | REMARKS        |  |
|                         |  | <br>L. Mahalingam<br>22/12/2014 |  | SUB: CHANGE LEVER L.H        |  |          |  |           |  | SCALE 2:1      |  |
| TRACED                  |  |                                 |  | FOR: TRIGGER GUARD SUB ASSY. |  |          |  |           |  | STORE DRG. NO. |  |
| DRAWN                   |  |                                 |  | OF: 30mm MSI                 |  |          |  |           |  |                |  |
| CHECKED                 |  |                                 |  | DES. REF. NO.                |  |          |  |           |  | OPERATION NO.  |  |
| HOS/DMDO                |  |                                 |  | DRG. No.:                    |  | 33P 3036 |  |           |  |                |  |
| FOR USE                 |  |                                 |  |                              |  |          |  |           |  |                |  |
| DAY/OFFICER             |  |                                 |  |                              |  |          |  |           |  |                |  |
| DDO                     |  |                                 |  |                              |  |          |  |           |  |                |  |
| APPROVED OR: 22/12/2014 |  |                                 |  |                              |  |          |  |           |  | SHEETS: 1      |  |
| AMENDMENTS & DATE       |  |                                 |  |                              |  |          |  |           |  | SHEET: No. 1   |  |