

DETAILA

ITEM NO.	PART NUMBER	QTY.
1	PKM-7110 LEG LEFT WELD ASSY	1
2	PKM-7101 BRACKET BOTTOM	1
3	PKM-7102 BRACKET TOP	1
4	PKM-7103 AXIS BIPOD	1
5	PKM-7104 LOCK PIN	1
6	PKM-7005 HINGE PIN	2
7	PKM-7107 CLIP	1
8	PKM-7120 LEG RIGHT WELD ASSY	1
9	PKM-7105 SPRING BIPOD	1
10	PKM-7106 AXIS LEG	2

SECTION C-C

SECTION B-B

Material:	DWG Details	
	3rd Angle	SIGN DATE
Hardness:	DRAWN	AMM
	CHECKED	[Signature]
Finish:	HOS/D&DO	[Signature]
	OFFICER/Prod	[Signature]
Un Tolerated dimensions IS:2102 Medium	OFFICER/QC	
	DW OFFICER/100	[Signature]
PDM CONTROL		

sub: BIPOD ASSY.

FOR: GENERAL ASSY.

OF: KALASHNIKOV MACHINE GUN (PKM)

DWG: PKM-7100

No.: [Blank]

Wt. (Approx) gm

QPG

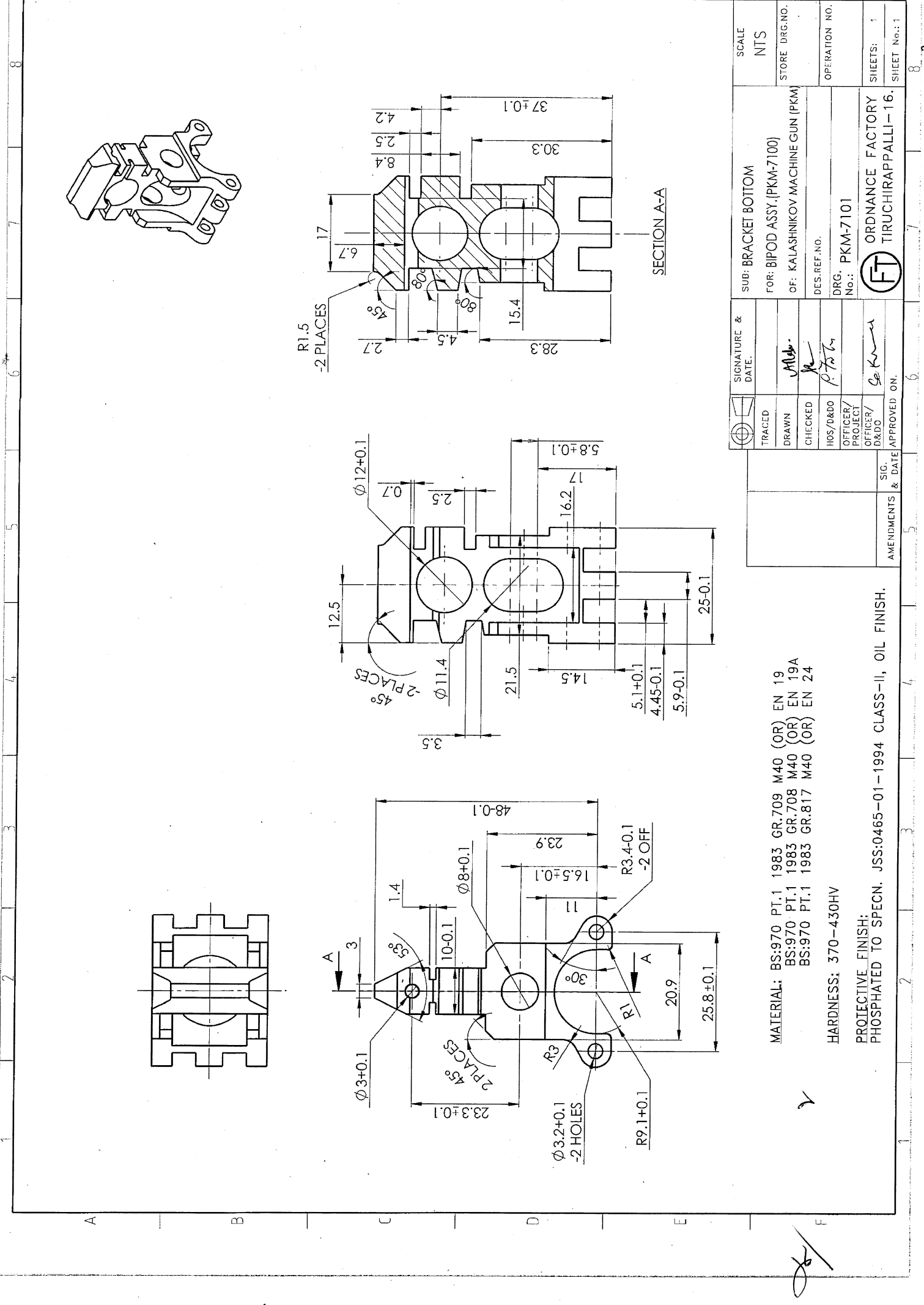
ORDNANCE FACTORY
TIRUCHIRAPPALLI-16.

FT

SHEET: 1 OF 1

[Handwritten signature]

[Handwritten mark]



MATERIAL: BS:970 PT.1 1983 GR.709 M40 (OR) EN 19
 BS:970 PT.1 1983 GR.708 M40 (OR) EN 19A
 BS:970 PT.1 1983 GR.817 M40 (OR) EN 24

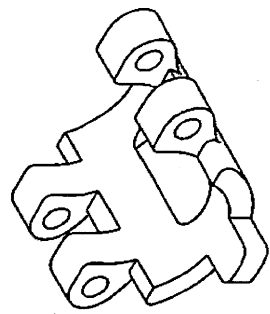
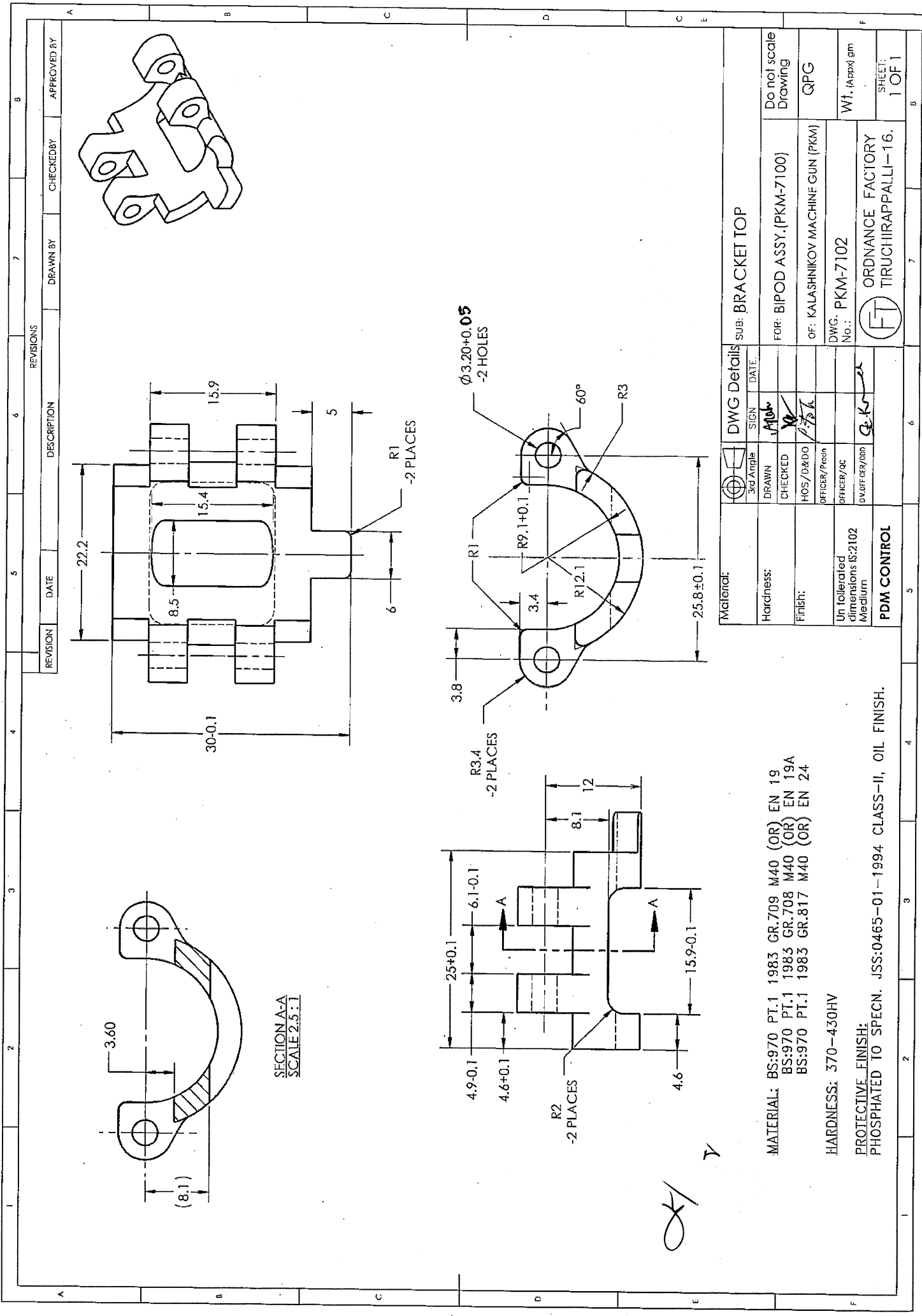
HARDNESS: 370-430HV

PROJECTIVE FINISH:
 PHOSPHATED TO SPECN. JSS:0465-01-1994 CLASS-II, OIL FINISH.

TRACED	SIGNATURE & DATE.	SUB: BRACKET BOTTOM	SCALE
DRAWN	<i>M. S.</i>	FOR: BIPOD ASSY. (PKM-7100)	NTS
CHECKED	<i>P. S.</i>	OF: KALASHNIKOV MACHINE GUN (PKM)	STORE DRG. NO.
HQS/D&DO	<i>P. S.</i>	DES. REF. NO.	OPERATION NO.
OFFICER/PROJECT	<i>S. K.</i>	DRG. No.: PKM-7101	
OFFICER/D&DO	<i>S. K.</i>		
APPROVED ON.			
SIG. & DATE			
AMENDMENTS			

ORDNANCE FACTORY
 TIRUCHIRAPPALLI-16.

SHEETS: 1
 SHEET No.: 1



SECTION A-A
SCALE 2.5:1

REVISIONS		DESCRIPTION		DRAWN BY		CHECKED BY		APPROVED BY	
REVISION	DATE								
Material:		DWG Details		SUB: BRACKET TOP		Do not scale Drawing		QPG	
Hardness:		SIGN		DATE		FOR: BIPOD ASSY.(PKM-7100)		Wt. (approx) gm	
Finish:		DRAWN				OF: KALASHNIKOV MACHINE GUN (PKM)		SHEET: 1 OF 1	
Un tolerated dimensions IS:2102 Medium		CHECKED				DWG. No.: PKM-7102			
PDM CONTROL		HOS/D&DO				ORDNANCE FACTORY TIRUCHIRAPPALLI-16.			
		OFFICER/Presn							
		OFFICER/AC							
		DV/OFFICER/DIR							

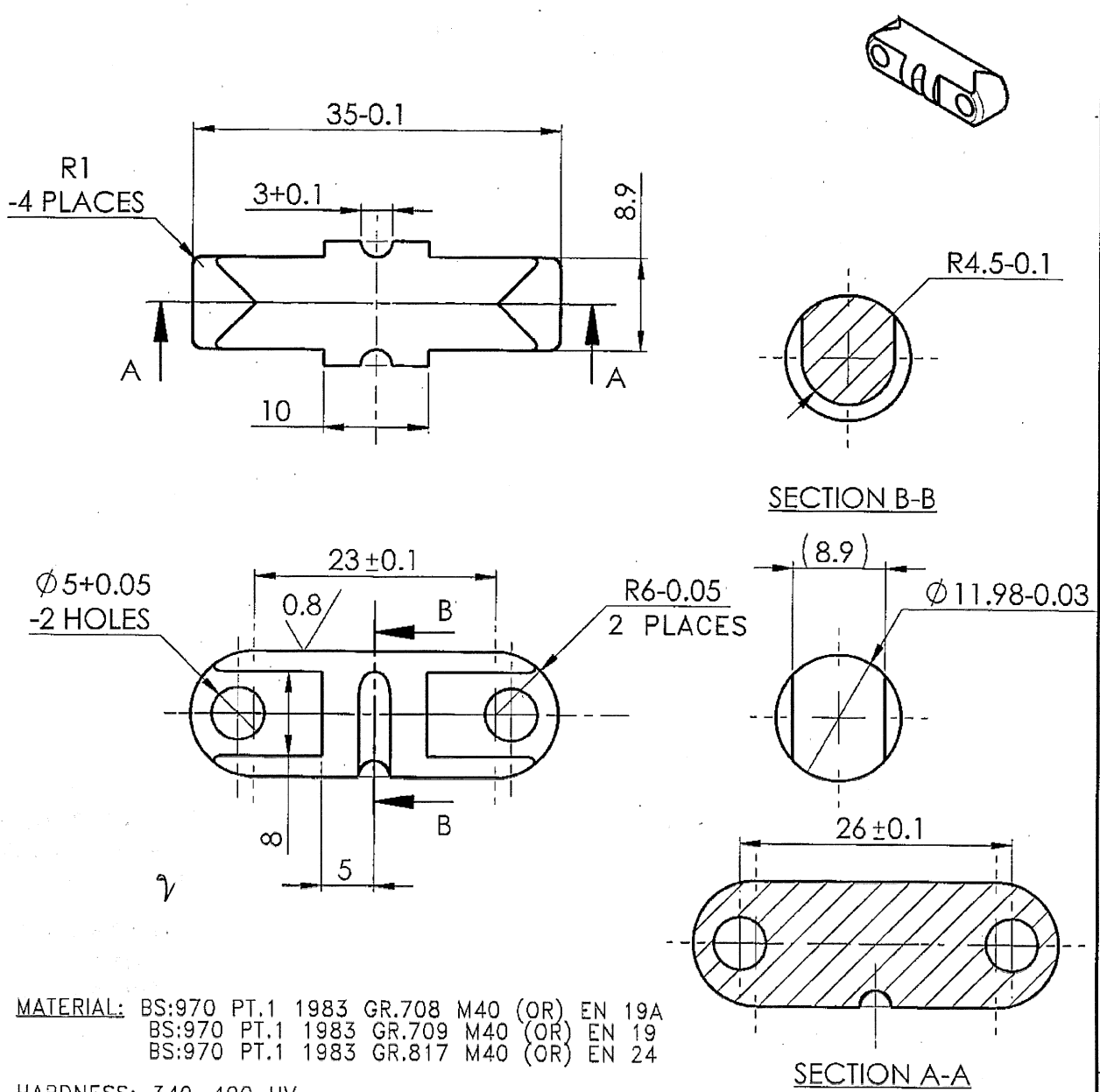
MATERIAL: BS:970 PT.1 1983 GR.709 M40 (OR) EN 19
 BS:970 PT.1 1983 GR.708 M40 (OR) EN 19A
 BS:970 PT.1 1983 GR.817 M40 (OR) EN 24

HARDNESS: 370-430HV

PROTECTIVE FINISH:
 PHOSPHATED TO SPECN. JSS:0465-01-1994 CLASS-II, OIL FINISH.

Handwritten signature and initials.

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



MATERIAL: BS:970 PT.1 1983 GR.708 M40 (OR) EN 19A
 BS:970 PT.1 1983 GR.709 M40 (OR) EN 19
 BS:970 PT.1 1983 GR.817 M40 (OR) EN 24

HARDNESS: 340-400 HV

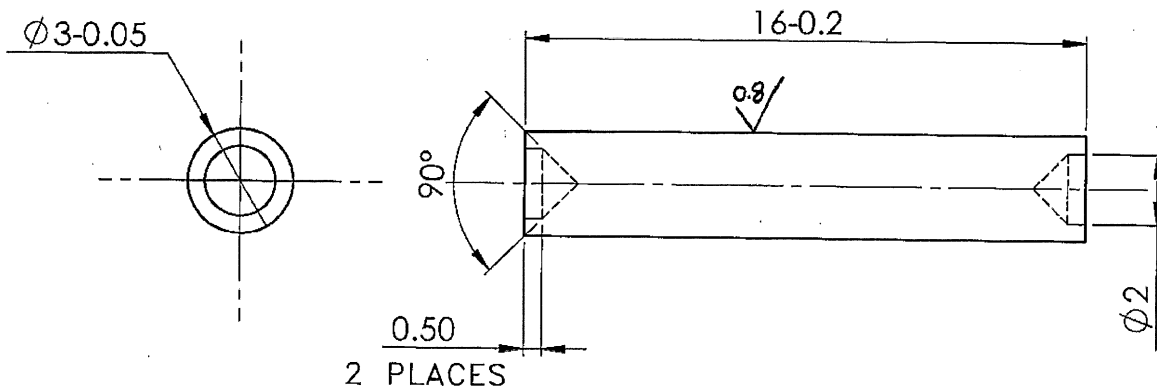
PROTECTIVE FINISH:
 PHOSPHATED TO SPECN. JSS:0465-01-1994 CLASS-II, OIL FINISH.

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
	SIGNATURE & DATE.	SUB: AXIS BIPOD			SCALE
	TRACED	FOR: BIPOD ASSY.(PKM-7100)			NTS
	DRAWN <i>Alu</i>	OF: KALASHNIKOV MACHINE GUN (PKM)			STORE DRG.NO.
	CHECKED <i>P.Tor</i>	DES.REF.NO.			OPERATION NO.
	HOS/D&DO <i>P.Tor</i>	DRG. No.: PKM-7103			
	OFFICER/PROJECT	ORDNANCE FACTORY TIRUCHIRAPPALLI-16.			SHEETS: 1
	OFFICER/D&DO <i>S.K</i>				SHEET No.: 1
AMENDMENTS	SIG. & DATE	APPROVED ON.			

DIMENSIONS ARE IN mm.

UNTOLERATED DIMNS. AS PER IS : 2102 (MED)

MARK DRAWING No.



MATERIAL: BS:970 PT.1 1983 GR.708 M40 (OR) EN 19A
 BS:970 PT.1 1983 GR.709 M40 (OR) EN 19

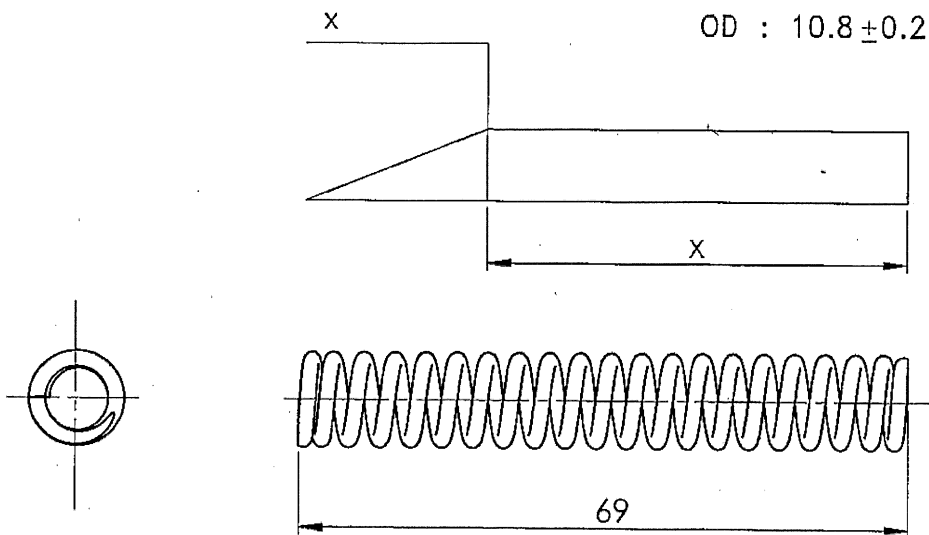
HARDNESS: 350-400 HV

PROTECTIVE FINISH:
 PHOSPHATED TO SPECN. JSS:0465-01-1994 CLASS-II, OIL FINISH.

AMENDMENTS	SIG. & DATE		SIGNATURE & DATE.	SUB: LOCK PIN	SCALE
		TRACED			FOR: BIPOD ASSY. (PKM-7100)
		DRAWN	<i>Amw.</i>	OF: KALASHNIKOV MACHINE GUN (PKM)	Weight (g)
		CHECKED	<i>Je</i>	DES. REF. NO.	REVISION.
		OIC/D&DO	<i>P. S. W.</i>	DRG. No.: PKM-7104	SHEETS: 1
		DIV. OFFICER/D&DO	<i>Se. K. S.</i>	ORDNANCE FACTORY TIRUCHIRAPPALLI-16.	SHEET No.: 1

DIMENSIONS ARE IN mm.
 UNTOLERATED DIMENSIONS AS PER IS:2102(MED)
 PROTECTIVE FINISH :- PHOSPATED TO SPEC:
 JSS:0465-01-1988 CLASS-I (ACCELERATED) OIL FINISH.

WIRE DIA : DIA.1.8 mm
 WOUND : R.H.(OR)L.H.
 No. OF EFFECTIVE COILS: 19
 No. OF COILS : 21
 SOLID LENGTH :
 OD : 10.8±0.2 mm



ONE COIL AT EACH END TO BE CLOSED IN AND
 GROUND SQUARE TO THE AXIS OF THE COIL
 LEAVING 3/4 OF THE COIL AT EACH END NON
 EFFECTIVE

SPRING TO BE STRESS RELEASED

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

MATERIAL:- STEEL IS:4454 PART 1-2001 Gr.DH

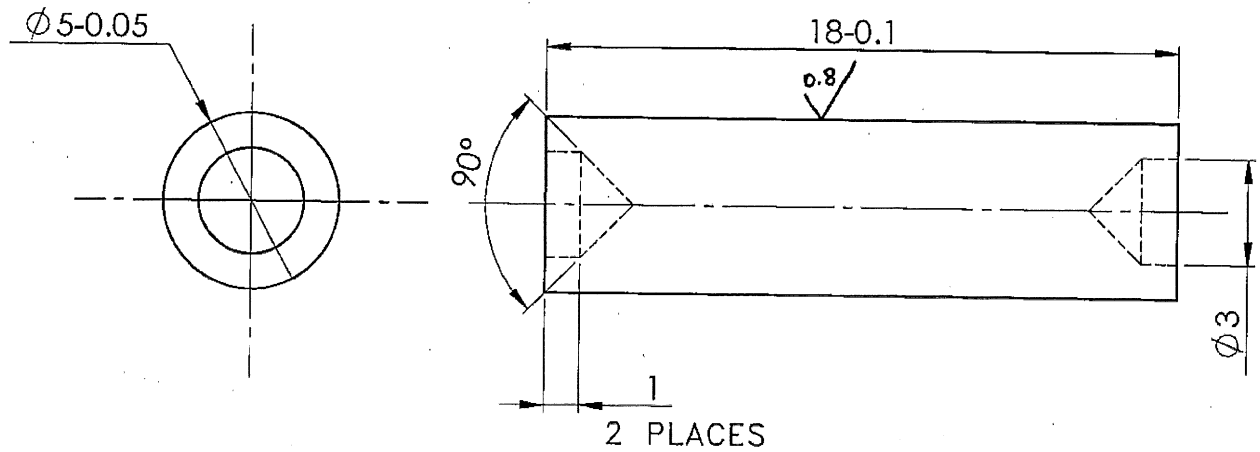
Handwritten signature

Handwritten mark

AMENDMENTS	SIG. & DATE		SIGNATURE & DATE.	SUB: SPRING BIPOD	SCALE NTS
		TRACED		FOR: BIPOD ASSY.(PKM-7100)	Weight (g)
		DRAWN	<i>Handwritten signature</i>	OF: KALASHNIKOV MACHINE GUN (PKM)	
		CHECKED	<i>Handwritten signature</i>	DES.REF.NO.	REVISION
		OIC/D&DO	<i>Handwritten signature</i>	DRG. PKM-7105	
		DIV.OFFICER/ D&DO	<i>Handwritten signature</i>	No.:	SHEETS: 1
			ORDNANCE FACTORY, TIRUCHIRAPPALLI-16.	SHEET No.: 1	

DIMENSIONS ARE IN mm.

UNTOLERATED DIMNS. AS PER IS : 2102 (MED)



MATERIAL: BS:970 PT.1 1983 SEC.3 GR.708 M40 (OR) EN 19A
BS:970 PT.1 1983 SEC.3 GR.709 M40 (OR) EN 19

HARDNESS: 340-400 HV

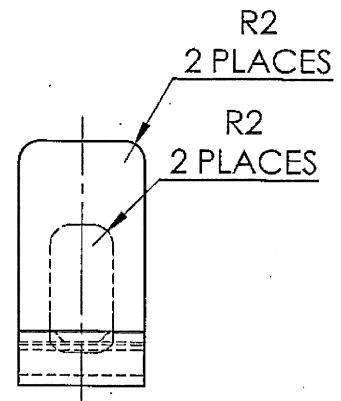
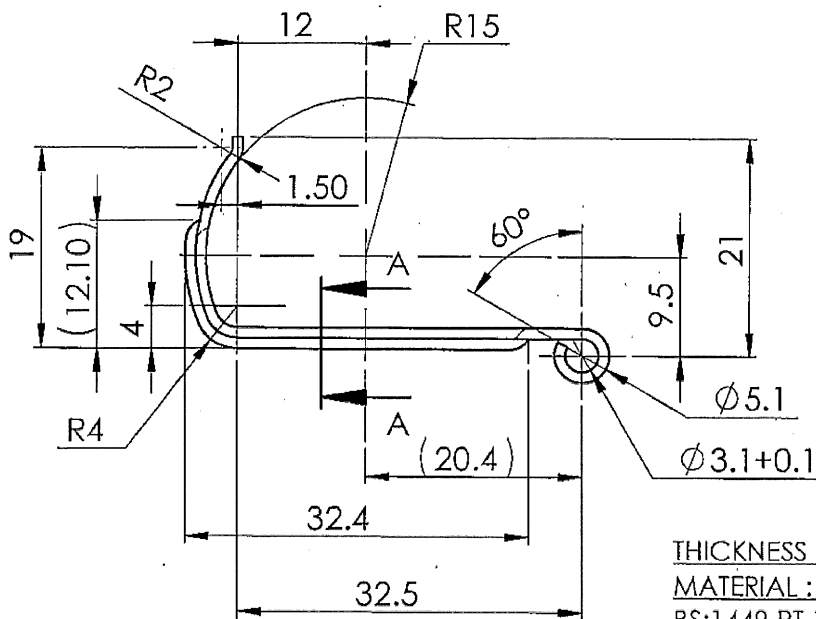
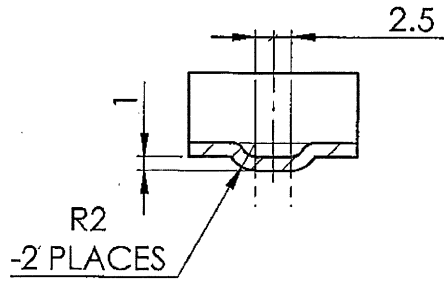
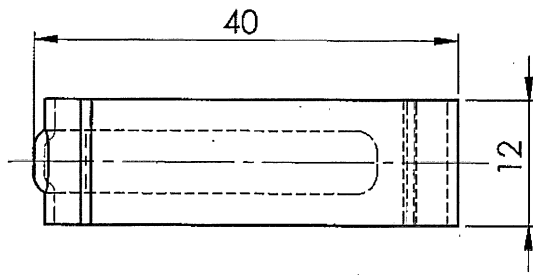
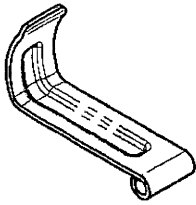
PROTECTIVE FINISH:

PHOSPHATED TO SPECN. JSS:0465-01-1994 CLASS-II, OIL FINISH.

ENDS TO BE KEPT SOFT FOR RIVETING PURPOSE

AMENDMENTS	SIG. & DATE		SIGNATURE & DATE.	SUB: AXIS LEG	SCALE
		TRACED		FOR: BIPOD ASSY. (PKM-7100)	NTS
		DRAWN	<i>M. Laksh.</i>	OF: KALASHNIKOV MACHINE GUN (PKM)	Weight (g)
		CHECKED	<i>[Signature]</i>	DES. REF. NO.	REVISION
		OIC/D&DO	<i>[Signature]</i>	DRG. No.: PKM-7106	SHEETS: 1
		DIV. OFFICER/D&DO	<i>[Signature]</i>	ORDNANCE FACTORY TIRUCHIRAPPALLI-16.	SHEET No.: 1

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



THICKNESS OF SHEET METAL - 1 mm

MATERIAL :

BS:1449 PT.1-1983 Gr.CS50 (OR)

IS:2507-1975 Gr.2 55 C6

HARDENESS: 440-500 HV

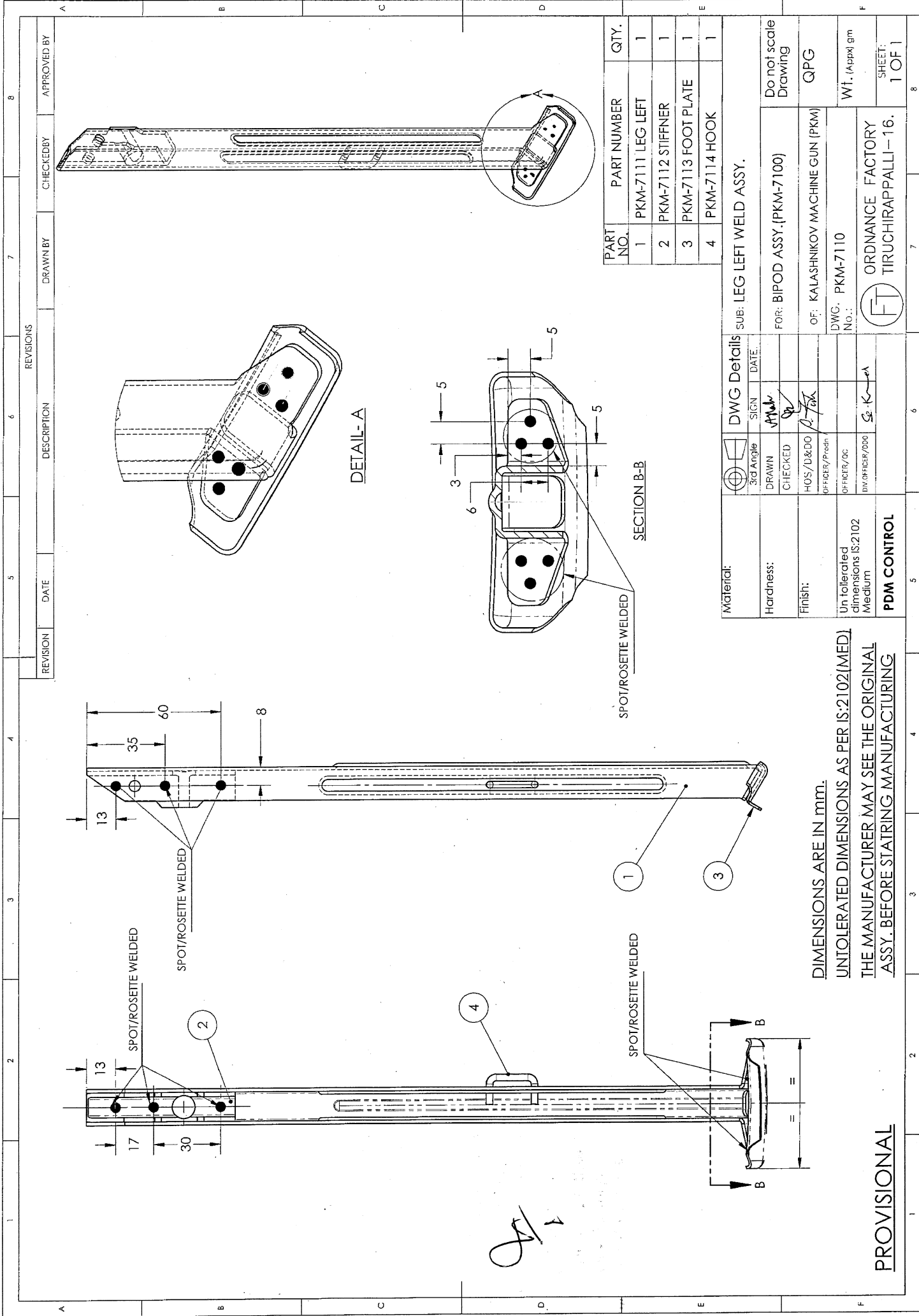
PROTECTIVE FINISH:

PHOSPHATED TO SPECN. JSS:0465-01-1994

CLASS-II, OIL FINISH.

THE MANUFACTURER MAY SEE THE ORIGINAL COMPONENT BEFORE STATRING MANUFACTURING

AMENDMENTS	SIG. & DATE		SIGNATURE & DATE.	SUB: CLIP	SCALE NTS
		TRACED		FOR: BIPOD ASSY.(PKM-7100)	Weight (g)
		DRAWN	<i>Adh.</i>	OF: KALASHNIKOV MACHINE GUN (PKM)	
		CHECKED	<i>R</i>	DES.REF.NO.	REVISION
		OIC/D&DO.	<i>P. J. R.</i>	DRG. PKM-7107	SHEETS: 1 SHEET No.: 1
		OFFICER/ PRODN.		ORDNANCE FACTORY TIRUCHIRAPPALLI-16.	
		DIV.OFFICER/ D&DO	<i>Ge. Kumar</i>		



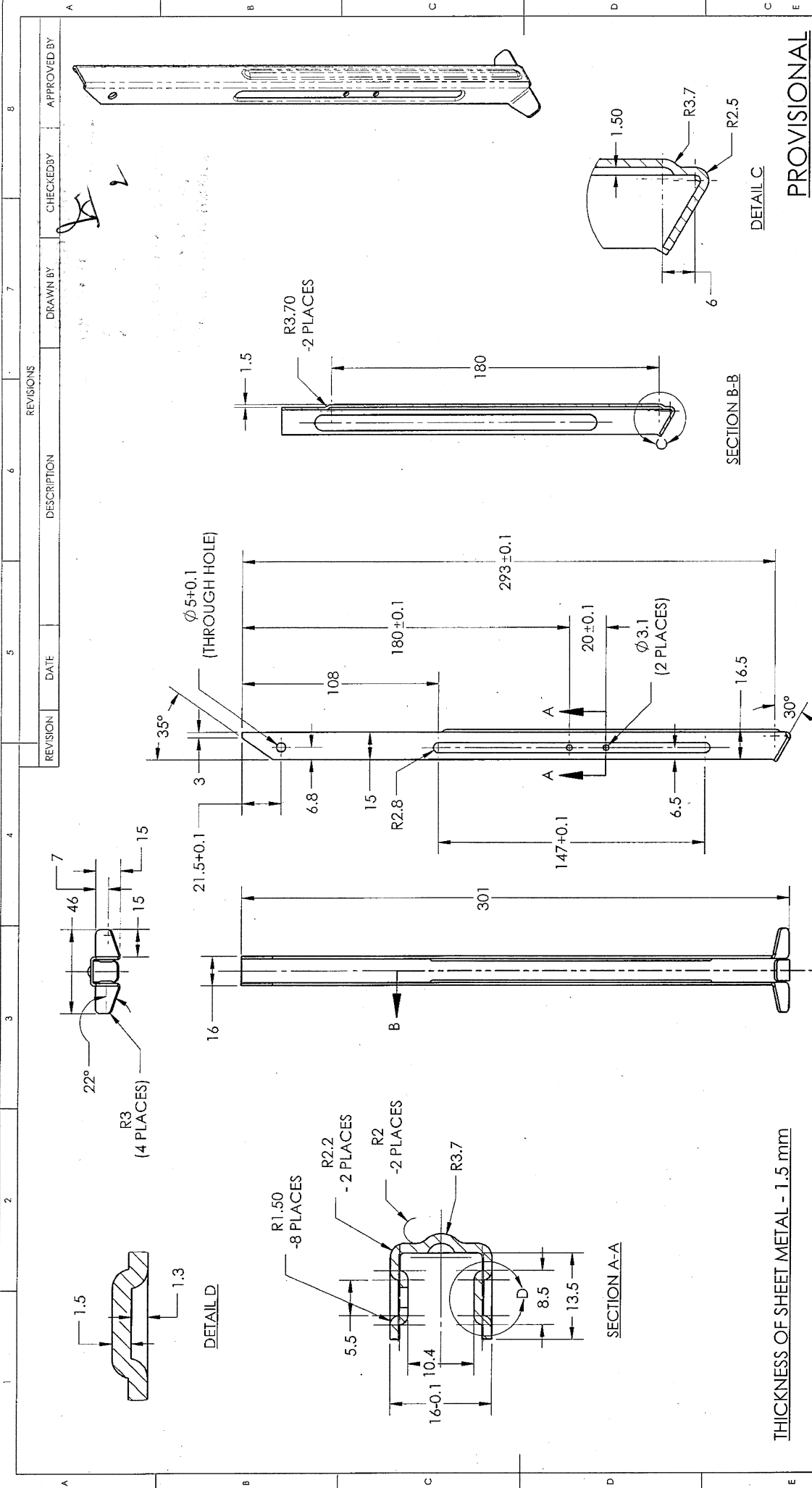
REVISION	DATE	DESCRIPTION	DRAWN BY	CHECKED BY	APPROVED BY

PART NO.	PART NUMBER	QTY.
1	PKM-7111 LEG LEFT	1
2	PKM-7112 STIFFNER	1
3	PKM-7113 FOOT PLATE	1
4	PKM-7114 HOOK	1

Material:	SUB: LEG LEFT WELD ASSY.	
Hardness:	FOR: BIPOD ASSY. (PKM-7100)	Do not scale Drawing
Finish:	OF: KALASHNIKOV MACHINE GUN (PKM)	QPG
Un tolerated dimensions IS:2102 Medium	DWC: PKM-7110	Wi. (Appx) gm
PDM CONTROL	ORDNANCE FACTORY TIRUCHIRAPPALLI - 16.	SHEET: 1 OF 1

DIMENSIONS ARE IN mm.
UNTOLERATED DIMENSIONS AS PER IS:2102 (MED)
THE MANUFACTURER MAY SEE THE ORIGINAL ASSY. BEFORE STATIRING MANUFACTURING

PROVISIONAL



THICKNESS OF SHEET METAL - 1.5 mm

MATERIAL:
 BS:1449 PT.1-1983 Gr.CS50 (OR)
 IS:2507-1975 Gr.2 55 C6

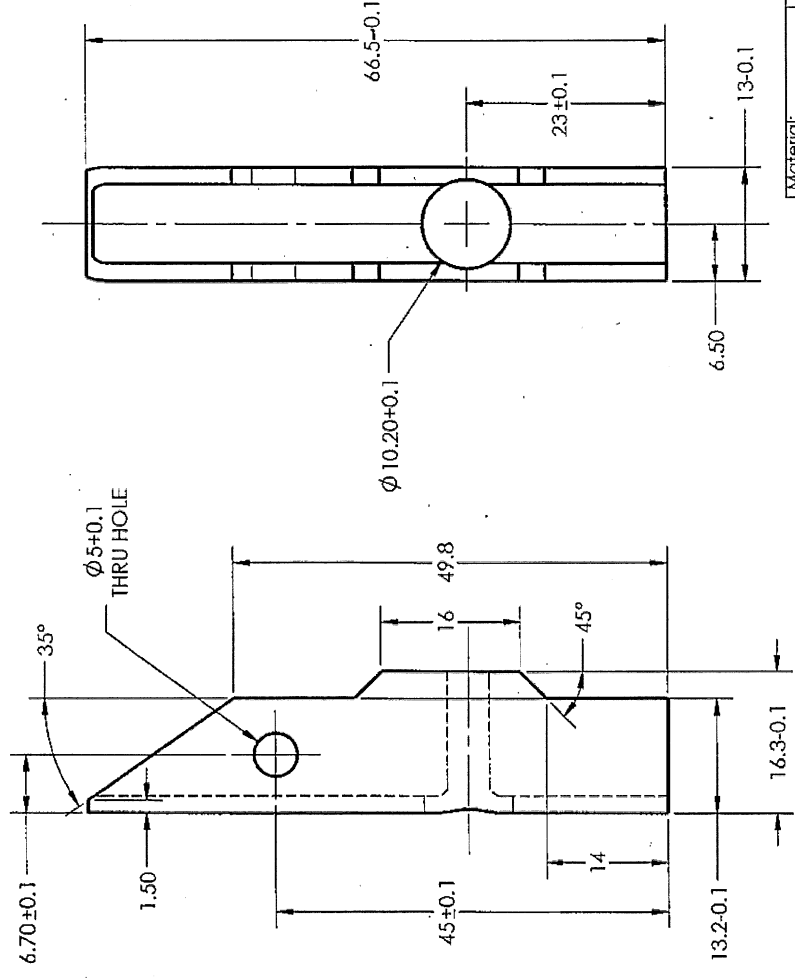
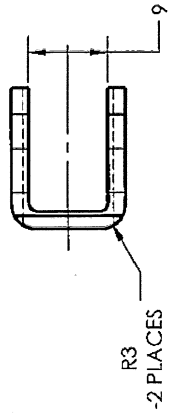
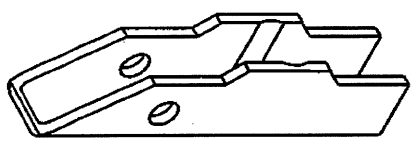
HARDNESS: 340-400 HV

PROTECTIVE FINISH:
 PHOSPHATED TO SPECN. JSS:0465-01-1994
 CLASS-II, OIL FINISH.

Material:	DWG Details		SUB: LEG LEFT
	3-d Angle	SIGN DATE:	
Hardness:	DRAWN	CHECKED	FOR: LEG LEFT WELD ASSY. (PKM-7110)
Finish:	HOS/D&DO	OFFICER/Prod	OF: KALASHNIKOV MACHINE GUN (PKM)
	OFFICER/OC	OFFICER/OC	DWG: PKM-7111
Un tolerated dimensions IS:2102 Medium	DW OFFICER/DOD		Wt. (Approx) gm
PDM CONTROL	ORDNANCE FACTORY		QPG
	TIRUCHIRAPPALLI-16.		
			Do not scale Drawing

REVISION	DATE	DESCRIPTION	REVISIONS	DRAWN BY	CHECKED BY	APPROVED BY

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



THICKNESS OF SHEET METAL - 2 mm

MATERIAL:
 BS:1449 PT.1-1983 Gr.CS50 (OR)
 IS:2507-1975 Gr.2 55 C6

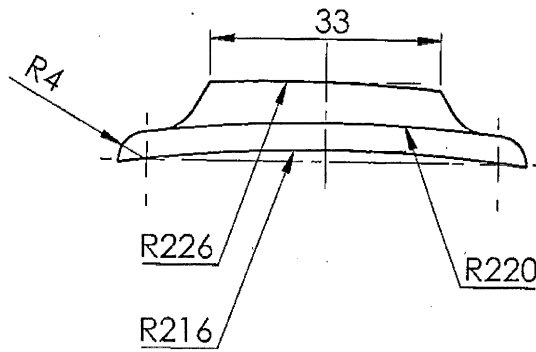
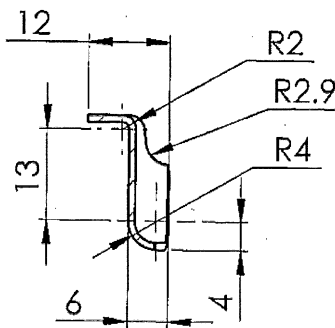
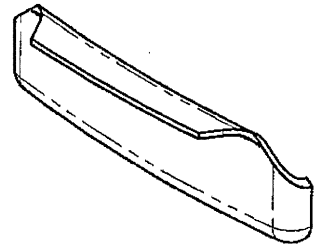
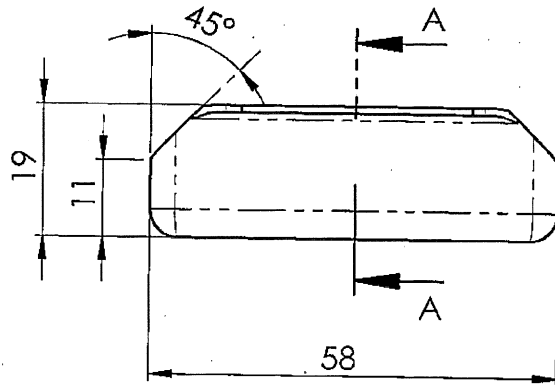
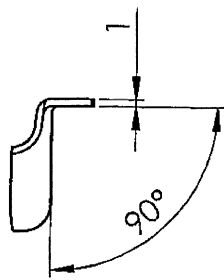
HARDNESS: 370-425 HV

PROTECTIVE FINISH:
 PHOSPHATED TO SPECN. JSS:0465-01-1994
 CLASS-II, OIL FINISH.

DWG Details		SUB: STIFFNER	
3rd Angle	SIGN	DATE	
DRAWN	<i>[Signature]</i>		LEG LEFT WELD ASSY.(PKM-7110) FOR LEG RIGHT WELD ASSY.(PKM-7120)
CHECKED	<i>[Signature]</i>		QPG
HOS/D&DO	<i>[Signature]</i>		OF: KALASHNIKOV MACHINE GUN (PKM)
OFFICER/Prod'n			DWG. PKM-7112
OFFICER/QC			No.:
BY/OFF GERN/DBD	<i>[Signature]</i>		Wt. (Appx) gm
			ORDNANCE FACTORY TIRUCHIRAPPALLI-16.
			FT
			SHEET- 1 OF 1

REVISION	DATE	DESCRIPTION	DRAWN BY	CHECKED BY	APPROVED BY

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



SECTION A-A

THICKNESS OF SHEET METAL - 1.5 mm

MATERIAL :
 BS:1449 PT.1-1983 Gr.CS50 (OR)
 IS:2507-1975 Gr.2 55 C6

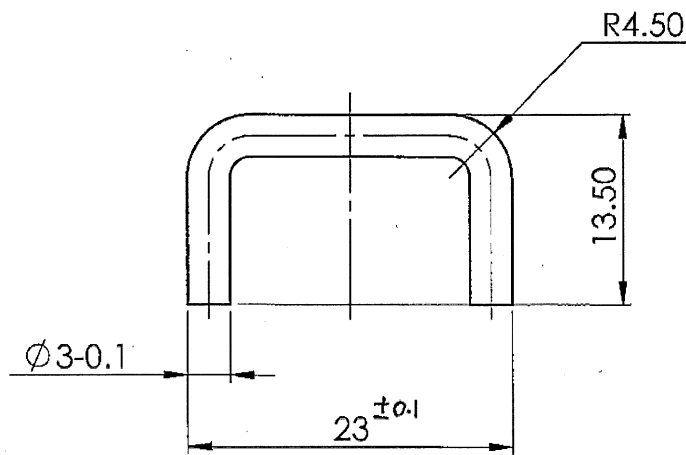
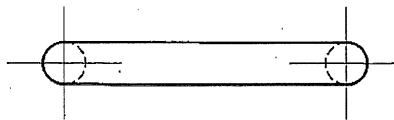
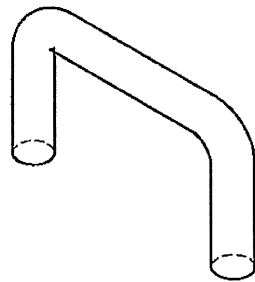
HARDENESS: 340-400 HV

PROTECTIVE FINISH:
 PHOSPHATED TO SPECN.
 JSS:0465-01-1994 CLASS-II, OIL FINISH.

LS/

AMENDMENTS	S.G. & DATE		SIGNATURE & DATE.	SUB: FOOT PLATE FOR: BIPOD ASSY.(PKM-7100) OF: KALASHNIKOV MACHINE GUN (PKM)	SCALE NTS
		TRACED			Weight (g)
		DRAWN	<i>ADG</i>	DES. REF. NO.	REVISION
		CHECKED	<i>[Signature]</i>	DRG. No.: PKM-7113	
		CIC/D&DO	<i>P. T. K</i>	ORDNANCE FACTORY TIRUCHIRAPPALLI-16.	SHEETS: 1
		DIV. OFFICER/D&DO	<i>[Signature]</i>		SHEET No.: 1

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



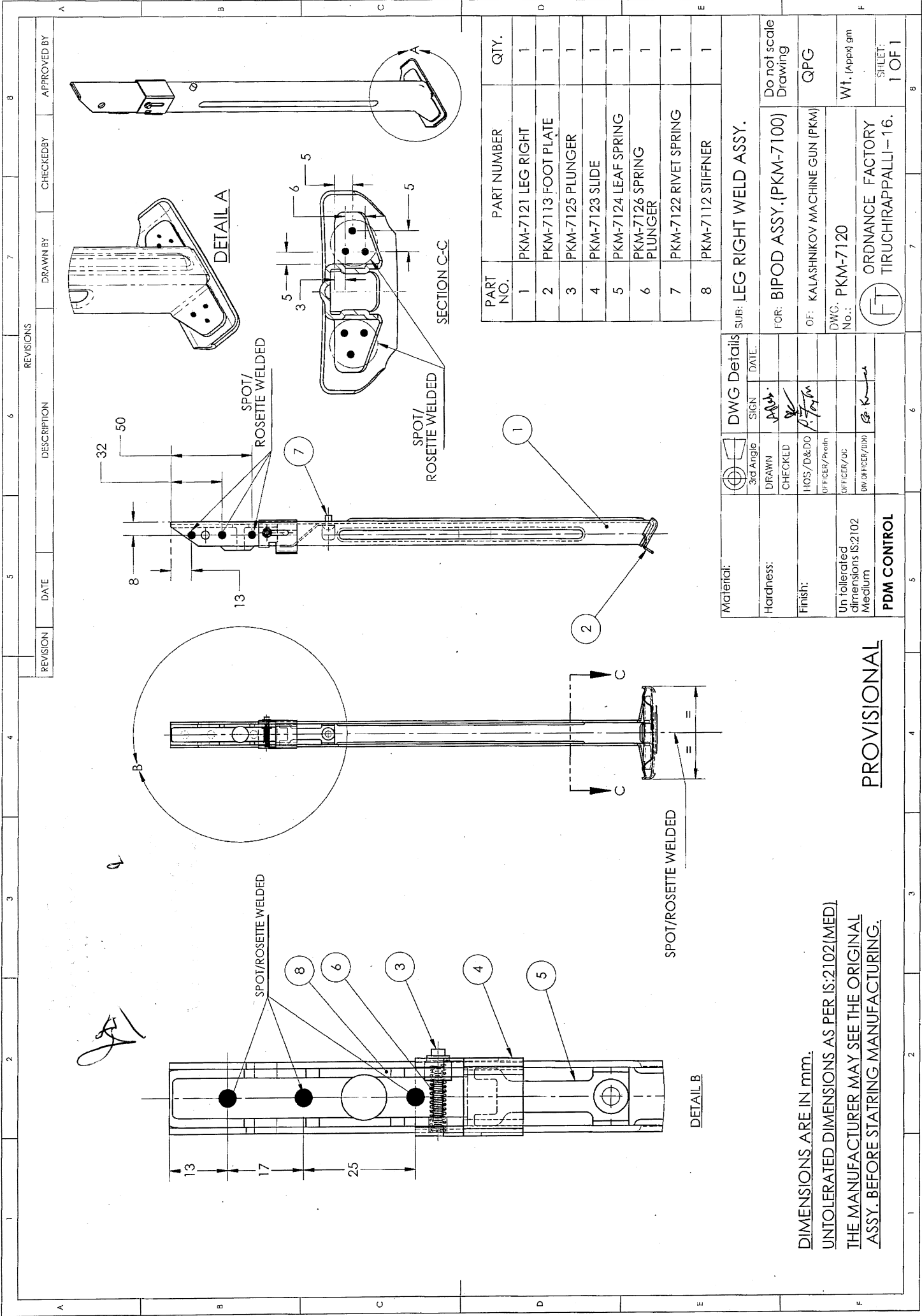
MATERIAL:

STEEL WIRE DIA. 3 mm
 IS:4454 PART-1 1981 GRADE-4

PROTECTIVE FINISH:

PHOSPHATED TO SPECN. JSS:0465-01-1994 CLASS-II, OIL FINISH.

AMENDMENTS	SIG. & DATE		SIGNATURE & DATE.	SUB: HOOK	SCALE
		TRACED		FOR: LEG LEFT WELD ASSY.(PKM-7110)	NTS
		DRAWN	<i>AK</i>	OF: KALASHNIKOV MACHINE GUN (PKM)	Weight (g)
		CHECKED	<i>R</i>	DES. REF. NO.	REVISION
		O/C/D&DO.	<i>P. Taha</i>	DRG. No.: PKM-7114	SHEETS: 1
		OFFICER/PRODN.		ORDNANCE FACTORY TIRUCHIRAPPALLI-16.	SHEET No.: 1
		D.V.OFFICER/D&DO	<i>Se. K...</i>		



PART NO.	PART NUMBER	QTY.
1	PKM-7121 LEG RIGHT	1
2	PKM-7113 FOOT PLATE	1
3	PKM-7125 PLUNGER	1
4	PKM-7123 SLIDE	1
5	PKM-7124 LEAF SPRING	1
6	PKM-7126 SPRING PLUNGER	1
7	PKM-7122 RIVET SPRING	1
8	PKM-7112 STIFFNER	1

DWG Details	
3rd Angle	SIGN DATE
DRAWN	ASB
CHECKED	
HOS/D&DO	
OFFICER/Prdn	
OFFICER/QC	
OFFICER/DWG	

Material: _____

Hardness: _____

Finish: _____

Untolerated dimensions IS:2102 Medium _____

PDM CONTROL

SUB: LEG RIGHT WELD ASSY.

FOR: BIPOD ASSY.(PKM-7100)

OF: KALASHNIKOV MACHINE GUN (PKM)

DWG. PKM-7120

No.: _____

ORDNANCE FACTORY TIRUCHIRAPPALLI-16.

Do not scale Drawing

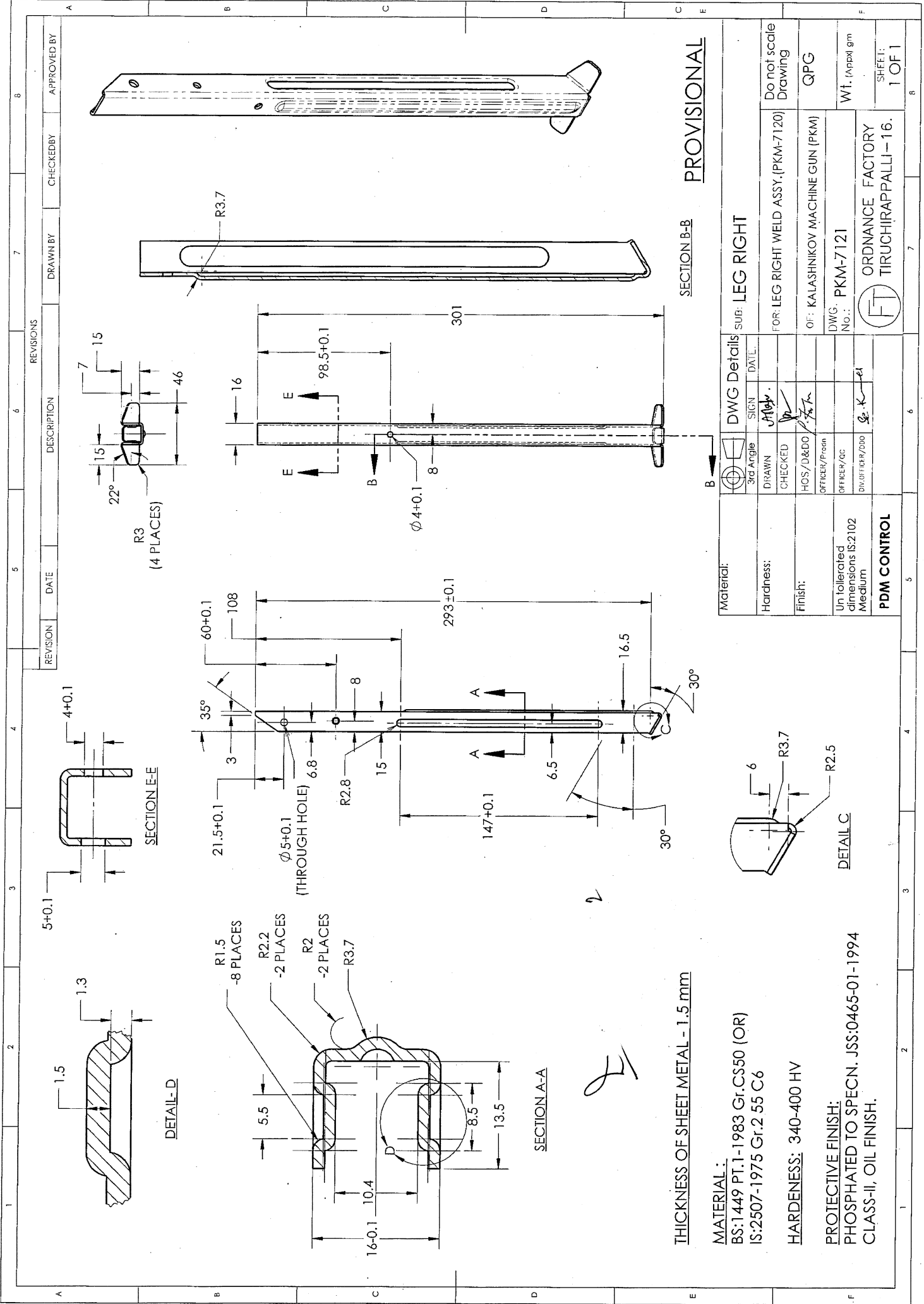
QPG

WT. (Apx) gm

SHEET: 1 OF 1

PROVISIONAL

DIMENSIONS ARE IN mm.
 UNTOLERATED DIMENSIONS AS PER IS:2102(MED)
 THE MANUFACTURER MAY SEE THE ORIGINAL ASSY. BEFORE STATING MANUFACTURING.



THICKNESS OF SHEET METAL - 1.5 mm

MATERIAL:

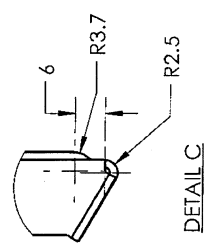
BS:1449 PT.1-1983 Gr.CS50 (OR)
IS:2507-1975 Gr.2 55 C6

HARDNESS: 340-400 HV

PROTECTIVE FINISH:

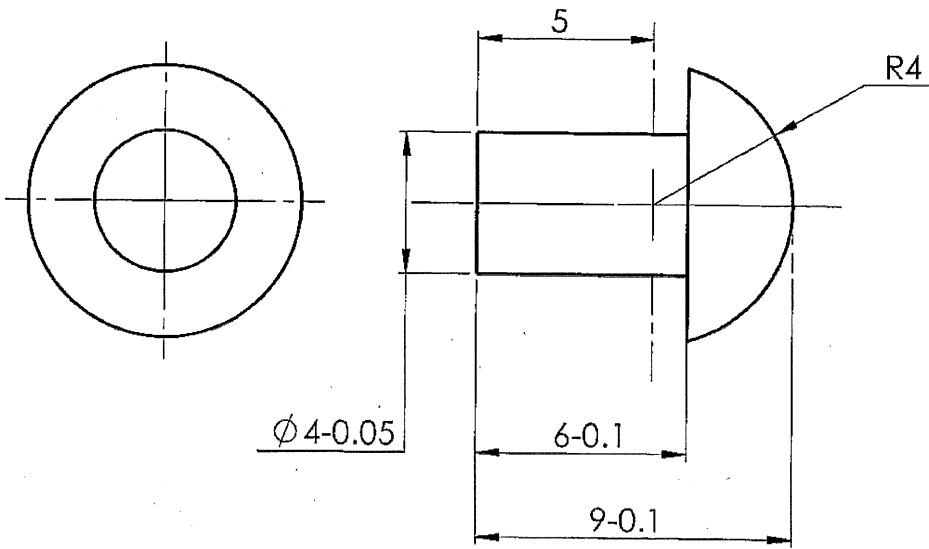
PHOSPHATED TO SPECN. JSS:0465-01-1994
CLASS-II, OIL FINISH.

Material:		DWG Details	
3rd Angle	SIGN	DATE	
DRAWN	<i>[Signature]</i>		
CHECKED			
HOS/D&DO	<i>[Signature]</i>		
OFFICER/Prsn			
OFFICER/CC			
DIV.OFFICER/DOO	<i>[Signature]</i>		
Un tolerated dimensions IS:2102 Medium		PDM CONTROL	



SUB: LEG RIGHT		Do not scale Drawing	
FOR: LEG RIGHT WELD ASSY.(PKM-7120)		QPG	
OF: KALASHNIKOV MACHINE GUN (PKM)		DWG. PKM-7121	
No.:		Wt. (Approx) gm	
ORDNANCE FACTORY		SHEET: 1 OF 1	
TIRUCHIRAPPALLI-16.			

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



Handwritten mark

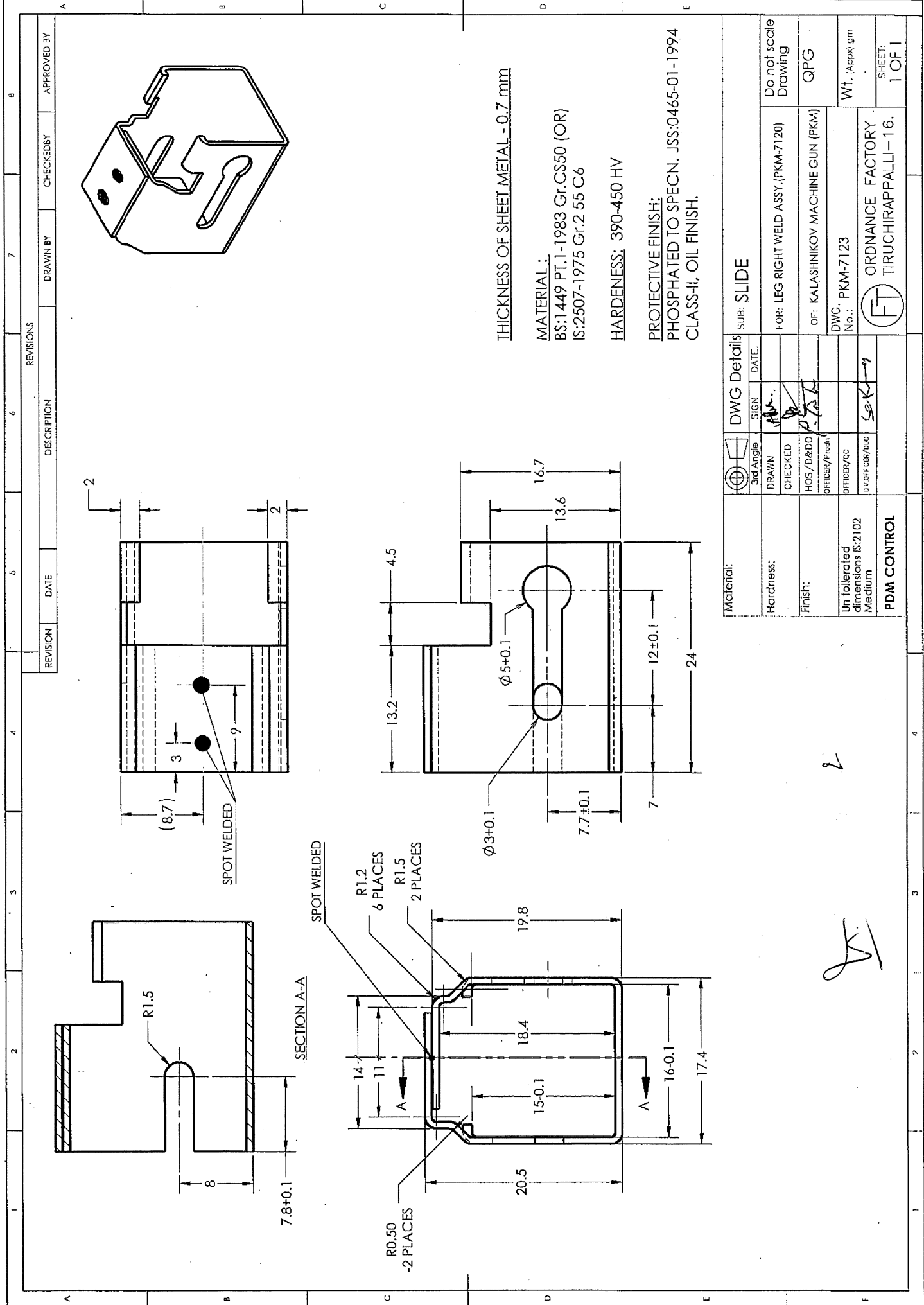
MATERIAL: BS:970 PT.1 1983 GR.080 M40 (OR) En 8

HARDNESS: 190-250HV

PROTECTIVE FINISH:

PHOSPHATED TO SPECN. JSS:0465-01-1994 CLASS-II, OIL FINISH.

AMENDMENTS	SIG. & DATE	SIGNATURE & DATE.		SUB: RIVET SPRING FOR: LEG RIGHT WELD ASSY.(PKM-7120) OF: KALASHNIKOV MACHINE GUN (PKM)	SCALE NTS
		TRACED			Weight (g)
		DRAWN	<i>Handwritten signature</i>	DES. REF. NO.	REVISION
		CHECKED	<i>Handwritten signature</i>	DRG. No.: PKM-7122	
		OIC/D&DO	<i>Handwritten signature</i>	ORDNANCE FACTORY TIRUCHIRAPPALLI-16.	SHEETS: 1
		OFFICER/ PRODN.			SHEET No.: 1
		DIV. OFFICER/ D&DO	<i>Handwritten signature</i>		



THICKNESS OF SHEET METAL - 0.7 mm

MATERIAL:
BS:1 449 PT.1-1983 Gr.CS50 (OR)
IS:2507-1975 Gr.2 55 C6

HARDNESS: 390-450 HV

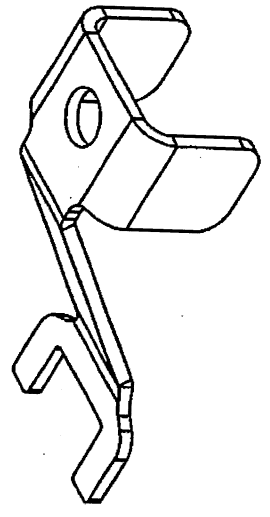
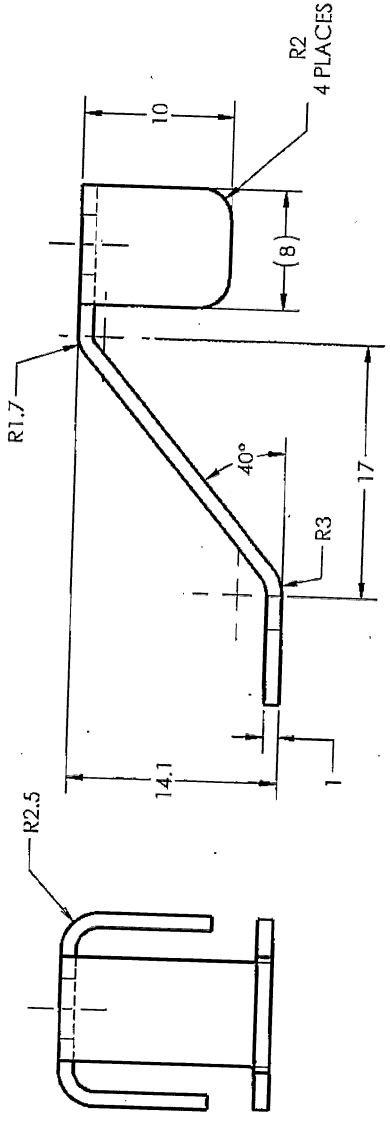
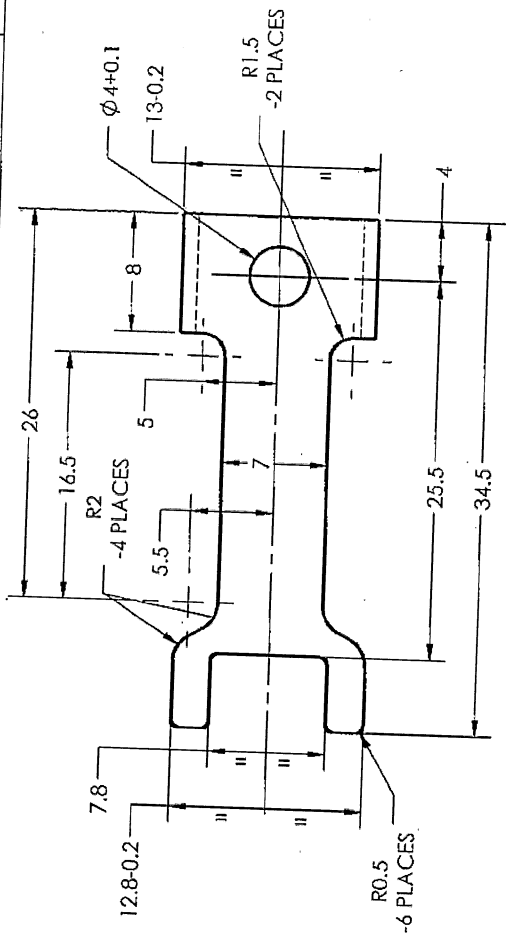
PROTECTIVE FINISH:
PHOSPHATED TO SPECN. JSS:0465-01-1994
CLASS-II, OIL FINISH.

REVISION	DATE	DESCRIPTION	DRAWN BY	CHECKED BY	APPROVED BY

Material:	DWG Details	SUB: SLIDE	
	3rd Angle	SIGN	DATE:
Hardness:	DRAWN	FOR: LEG RIGHT WELD ASSY.(PKM-7120)	Do not scale Drawing
Finish:	CHECKED	OF: KALASHNIKOV MACHINE GUN (PKM)	GPG
	HOS / D&DO	DWG. PKM-7123	Wt. (Appx) gm
Un tolerated dimensions IS:2102 Medium	OFFICER/INCH	No.:	ORDNANCE FACTORY
	OFFICER/DC		TIRUCHIRAPPALLI-16.
PDM CONTROL	BY OFF GSE/WDG		FT
			SHEET: 1 OF 1

Handwritten signature and number '2'.

REVISION	DATE	DESCRIPTION	REVISIONS	DRAWN BY	CHECKED BY	APPROVED BY



THICKNESS OF SHEET METAL - 1 mm

MATERIAL :

BS:1 449 PT.1-1983 Gr.CS80

ALT.MATERIAL - 1:

IS:2507-1975 Gr.7 85 C6

ALT.MATERIAL - 2:

EN-42G (OR) EN-42J

HARDNESS: 420-480 HV

PROTECTIVE FINISH:

PHOSPHATED TO SPECN. JSS:0465-01-1994
CLASS-II, OIL FINISH.

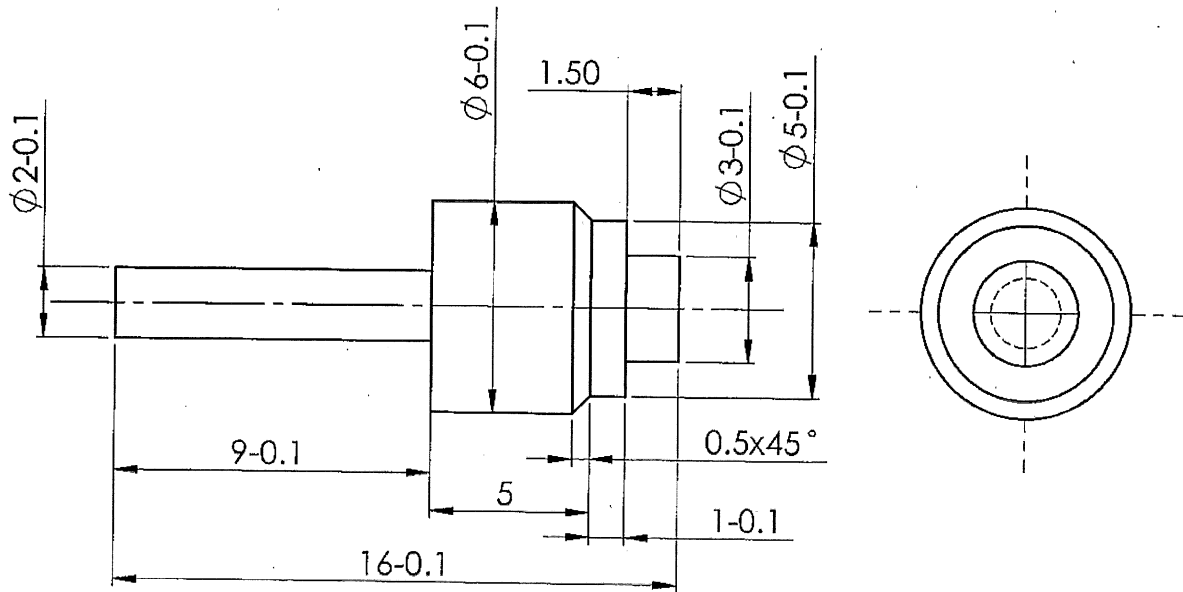
DIMENSIONS ARE IN mm.

UNTOLERATED DIMNS. AS PER IS : 2102 (MED)

Material:	Hardness:	Finish:	Un Tolerated dimensions IS:2102 Medium	PDM CONTROL	DWG Details		SUB: LEAF SPRING		Do not scale Drawing	
					3rd Angle	SIGN	DATE	FOR: LEG RIGHT WELD ASSY (PKM-7120)	QPG	
					DRAWN	CHECKED	HOS/D&DO	OFFICER/Prodn	DWC: PKM-7124	Wt. (approx) gm
					OFFICER/QC	DV OFF CLR/DKO	OFFICER/Prodn	OFFICER/QC	No.:	SHEET: 1 OF 1

(Handwritten signature)

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



LS/ *2020*

MATERIAL: BS:970 PT.1 1983 GR.708 M40 (OR) EN 19A
 BS:970 PT.1 1983 GR.709 M40 (OR) EN 19

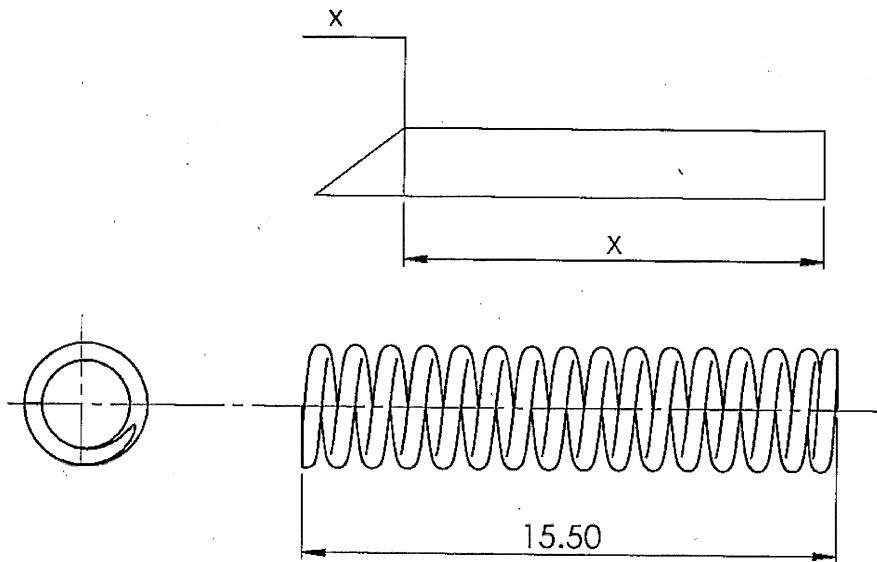
HARDNESS: 370-430 HV

PROTECTIVE FINISH:
 PHOSPHATED TO SPECN. JSS:0465-01-1994 CLASS-II, OIL FINISH.

AMENDMENTS	SIG. & DATE		SIGNATURE & DATE.	SUB: PLUNGER	SCALE
		TRACED			FOR: LEG RIGHT WELD ASSY.(PKM-7120)
		DRAWN	<i>VAH.</i>	OF: KALASHNIKOV MACHINE GUN (PKM)	Weight (g)
		CHECKED	<i>JK</i>	DES. REF. NO.	REVISION
		OIC/D&DO	<i>P. Toth</i>	DRG. No.: PKM-7125	SHEETS: 1
		DIV.OFFICER/D&DO	<i>Se. K...</i>	ORDNANCE FACTORY TIRUCHIRAPPALLI-16.	SHEET No.: 1

DIMENSIONS ARE IN mm.
 UNTOLERATED DIMENSIONS AS PER IS:2102(MED)
 PROTECTIVE FINISH :- PHOSPATED TO SPEC:
 JSS:0465-01-1988 CLASS-I (ACCELERATED) OIL FINISH.

WIRE DIA : DIA.0.5 mm
 WOUND : R.H.(OR)L.H.
 No.OF EFFECTIVE COILS: 15
 No.OF COILS : 16
 SOLID LENGTH :
 OD : 3.5±0.2 mm



ONE COIL AT EACH END TO BE CLOSED IN AND
 GROUND SQUARE TO THE AXIS OF THE COIL
 LEAVING 3/4 OF THE COIL AT EACH END NON
 EFFECTIVE

SPRING TO BE STRESS RECEIVED

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

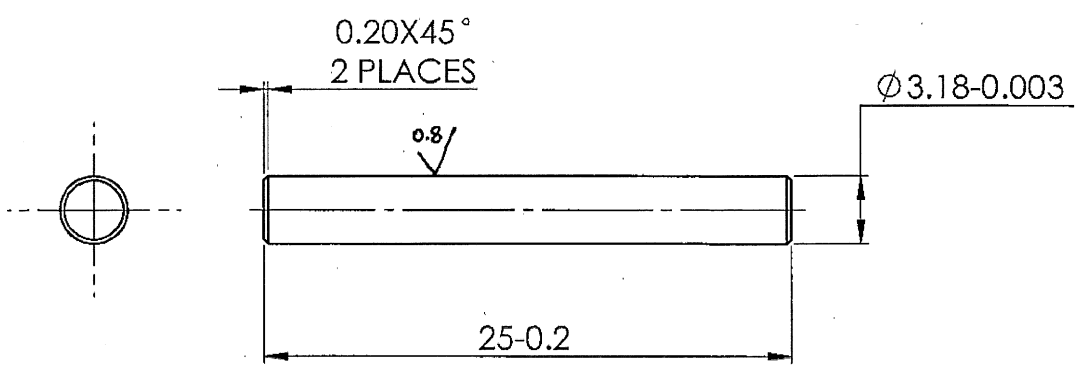
MATERIAL:- STEEL IS:4454 PART 1-2001 Gr.DH

Handwritten mark

Handwritten mark

AMENDMENTS	SIG. & DATE		SIGNATURE & DATE.	SUB: SPRING PLUNGER	SCALE NTS
		TRACED		FOR: LEG RIGHT WELD ASSY.(PKM-7120)	Weight (g)
		DRAWN	<i>Mish</i>	OF: KALASHNIKOV MACHINE GUN (PKM)	
		CHECKED	<i>RC</i>	DES.REF.NO.	REVISION
		OIC/D&DO	<i>Starb</i>	DRG. No.: PKM-7126	
		OFFICER/ PRODN.		ORDNANCE FACTORY TIRUCHIRAPPALLI-16.	
DIV.OFFICER/ D&DO	<i>SeK</i>	SHEETS: 1			
					SHEET No.: 1

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



Handwritten marks: a signature and the letter 'Y'.

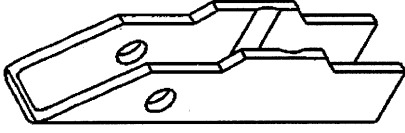
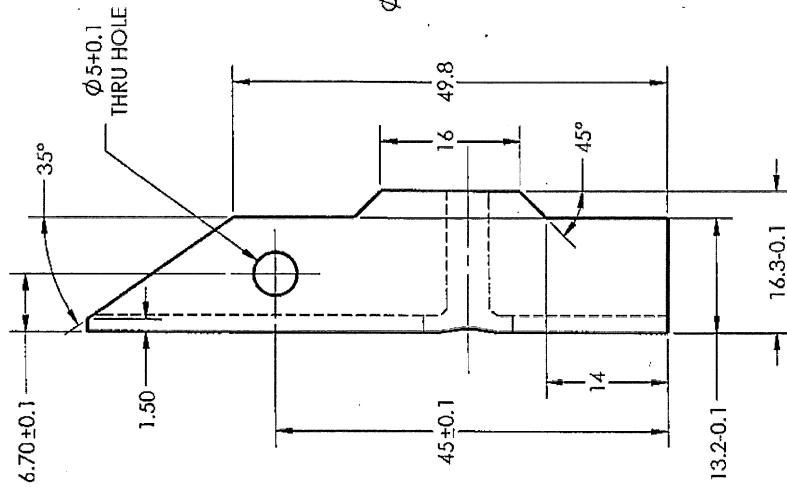
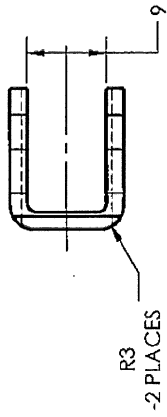
MATERIAL: BS:970 PT.1 1983 GR.708 M40 (OR) EN 19A
 BS:970 PT.1 1983 GR.709 M40 (OR) EN 19

HARDNESS: 370-425 HV

PROTECTIVE FINISH:
 PHOSPHATED TO SPECN. JSS:0465-01-1994 CLASS-II, OIL FINISH.

AMENDMENTS	SIG. & DATE		SIGNATURE & DATE.	SUB: HINGE PIN FOR: BIPOD ASSY. (PKM-7100) OF: KALASHNIKOV MACHINE GUN (PKM) DES. REF. NO. DRG. No.: PKM-7005 ORDNANCE FACTORY TIRUCHIRAPPALLI-16.	SCALE NTS
		TRACED			Weight (g)
		DRAWN	<i>Handwritten signature</i>		REVISION
		CHECKED	<i>Handwritten signature</i>		SHEETS: 1
		OIC/D&DO	<i>Handwritten signature</i>		SHEET No.: 1
		OFFICER/PRODN.			
DIV. OFFICER/D&DO	<i>Handwritten signature</i>				

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



THICKNESS OF SHEET METAL - 2 mm

MATERIAL:
 BS:1449 PT.1-1983 Gr.CS50 (OR)
 IS:2507-1975 Gr.2 55 C6

HARDNESS: 370-425 HV

PROTECTIVE FINISH:
 PHOSPHATED TO SPECN. JSS:0465-01-1994
 CLASS-II, OIL FINISH.

Handwritten signature

Material:		DWG Details		SUB: STIFFNER	
3rd Angle	DRAWN	SIGN	DATE	LEG LEFT WELD ASSY.(PKM-7110)	Do not scale Drawing
	CHECKED	<i>[Signature]</i>		FOR: LEG RIGHT WELD ASSY.(PKM-7120)	QPG
	HQS/D&DO	<i>[Signature]</i>		OF: KALASHNIKOV MACHINE GUN (PKM)	
	OFFICER/Prod'n			DWG. PKM-7112	Wt. (Appx) gm
	OFFICER/QC			No.:	
	BY/HT DES/100	<i>[Signature]</i>			
Un Tolerated dimensions IS:2102 Medium				ORDNANCE FACTORY TIRUCHIRAPPALLI-16.	
PDM CONTROL				SHEET 1 OF 1	