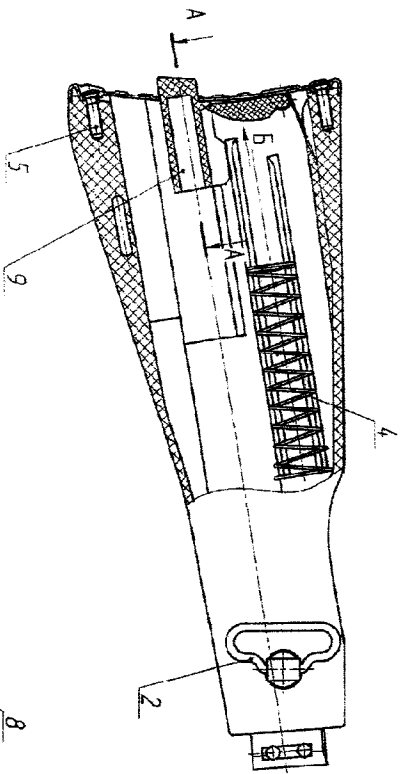
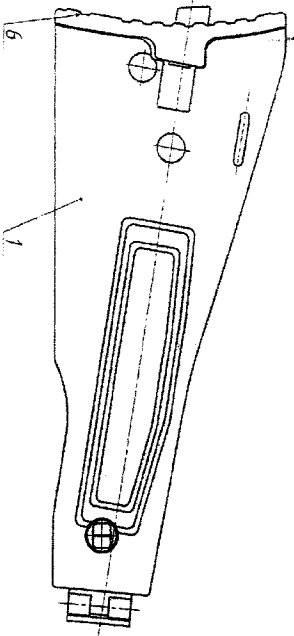
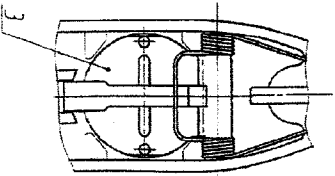
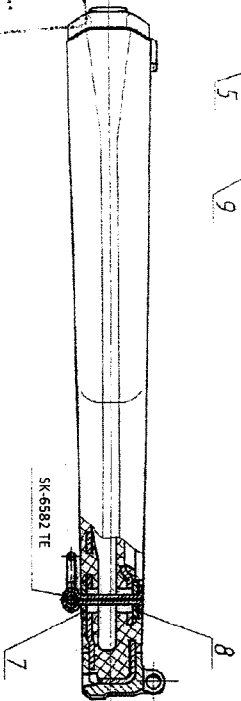


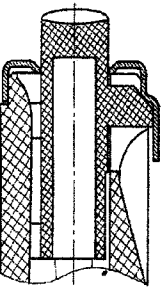
S.NO	NOMINCLATURE	QTY.	DRG. NO
1.	BUTTSTOCK	1	SK-6600 TE
2.	SWIVEL ASSEMBLY	1	SK-6597 TE
3.	BUTT PLATE COVER	1	SK-6596 TE
4.	SPRING	1	SK-6594 TE
5.	SCREW	2	SK-6533 TE
6.	BUTT PLATE	1	SK-6599 TE
7.	WASHER	1	SK-6528 TE
8.	WASHER	1	SK-6527 TE
9.	CATCH PUSHER	1	SK-6583 TE



B/2/1



A-A/2/1



- 1 Unbend ends of loop 67145-115-4/E2 ensuring free rotation of swivel pos. 2.
- 2 After unbending, ends of loop 67145-115-4/E2 to be coated with varnish based on polyvinylbutyral (MIL-1 GOST 9439-85 with modulus of grade A GOST 9307-78).
- 3 Screws pos. 5 should not rotate from torque 15 Nm.
- 4 Jamming of catch pusher pos. 9 is allowed if eliminated by butt plate cover pos. 3 turned through 80° and released. Check with installed gauge of accessories in container 6020(C)/E2 - type.

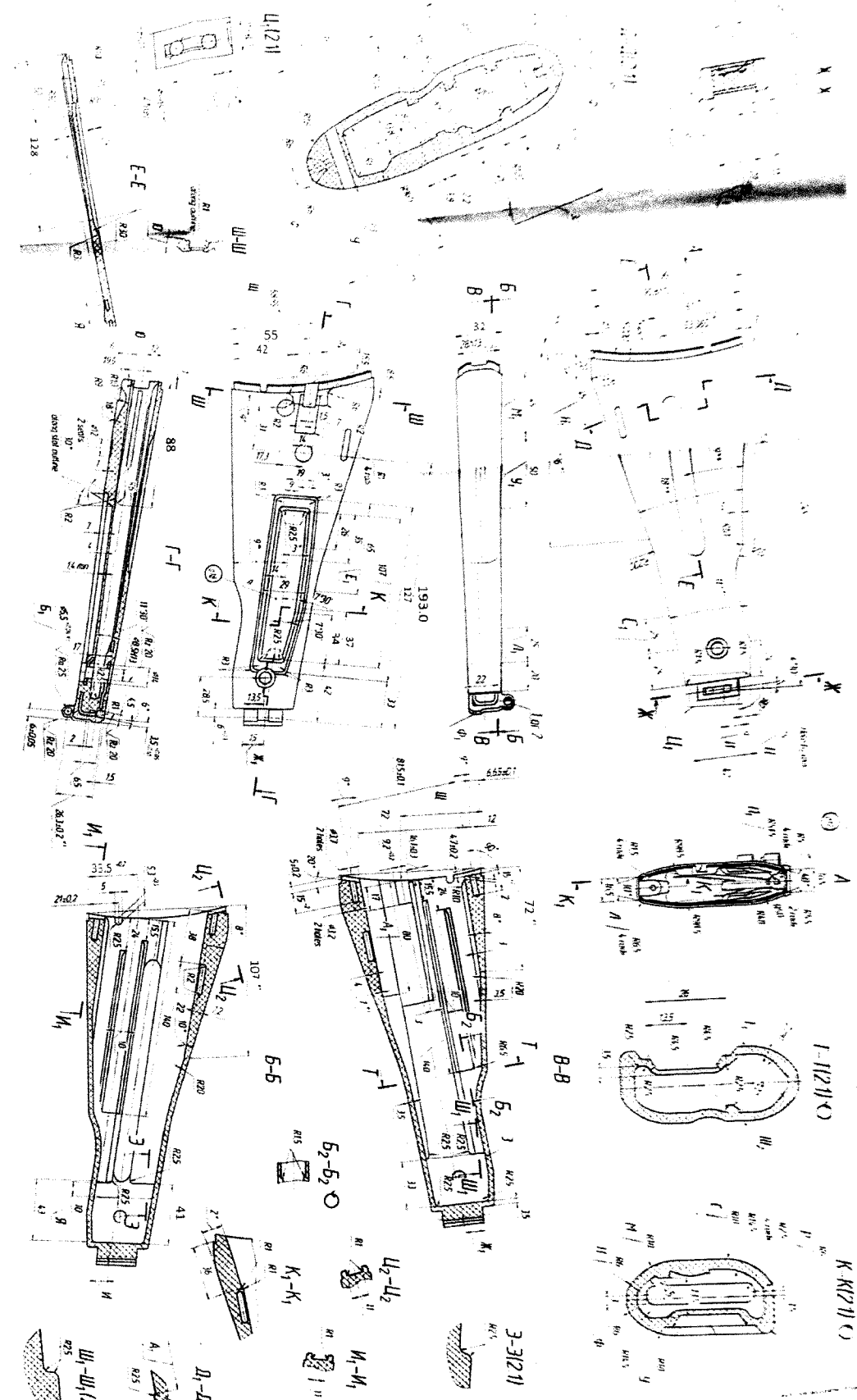
Weight 321 g

7.62x39mm AR-SAF

Butt assembly

Assembly drawing

SCALE 1:1 (N.T.S.)	SMALL ARMS FACTORY KANPUR	DRG. NO. SK-6650 TE
DATE 02.11.23		SHEET 1 OF 1



Handwritten notes and signatures:

Controlled copy 103/11/12

103/11/12

103/11/12

1. Buttstock end piece Assy., Drg. No. 6595 TE

2. Material:

1A-6-211 - D(C)M(C-21)
 FIRST Quality Grade,
 GOST 17648-83

WAIGHT: 270g

7.63x33mm AR-SAF
 BUTTSTOCK
 ASSEMBLY DRAWING

SK 6500 TE

DA NO

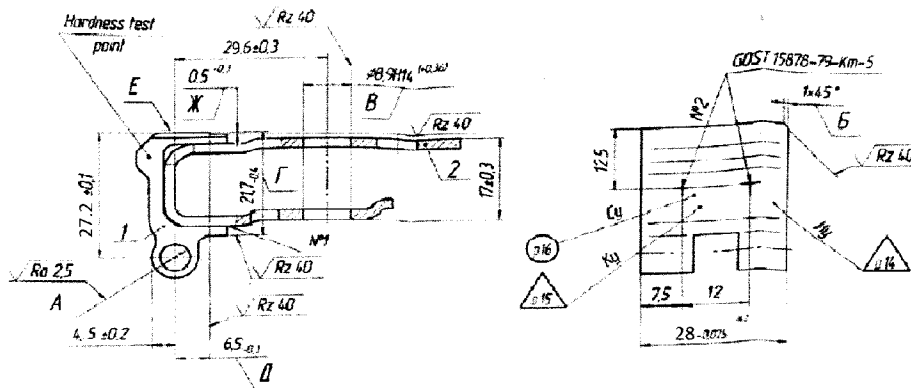
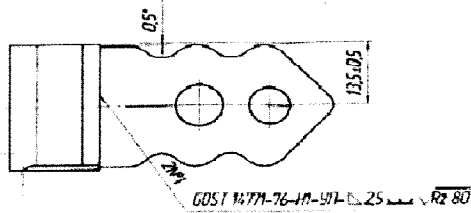


Table 1 In millimeters

Dimension	Selectivity group	
	1	2
A	05.6 ^{+0.04}	05.55 ^{+0.04}



- 1 68-72 HRA. At hardness test point local smoothing of surface is allowed of depth up to 0.1 mm
- 2 *Dimensions to be ensured by tool
- 3 *Dimension after coating
- 4 *Reference dimension
- 5 It is allowed to make dimensions A, B in assembly unit 6745-1.0815-1/E2
- 6 It is allowed to make dimension B in part pos. 2
- 7 100% of parts from lot to be checked for mechanical strength after heat treatment by applying dynamic load of 5 N m (0.5 kgf m) according to schematical diagram
- 8 Protruding of welded joint N¹ relative to part pos. 1 is up to 0.2 mm
- 9 2 mm under-run of welded joint N¹ from each side is allowed
- 10 Division of weld nuggel of spots N² is allowed at destruction of technological samples
- 11 Appearance according to control sample
- 12 Mill welded joints and portion of buttstock end piece until dimension B into dimensions F and X, inspect dimensions F and X from surface E
- 13 Welded joint N¹ GOST 14771-76-11-111 is allowed
- 14 Stamp according to 6745-1.0815-1/E2 after flaw detector check
- 15 Stamp according to 6745-1.0815-1/E2
- 16 Mark second group according to 6745-1.0815-1/E2
- 17 Coating is Chem Phos chr

1. Reinforcing Plate, Drg. No.6584/TE
2. End Piece, Drg. No. 6585/TE

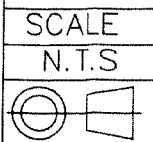
MATL. -

Weight 694 g

7.62x39mm AR-SAF

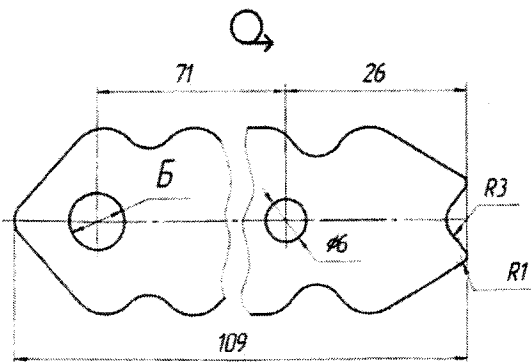
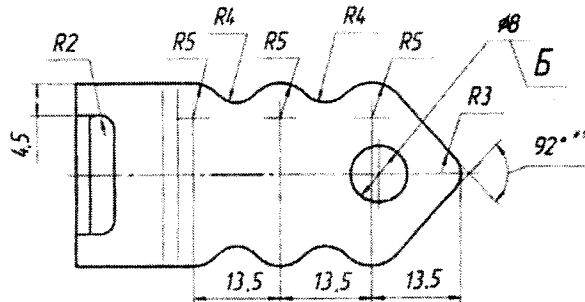
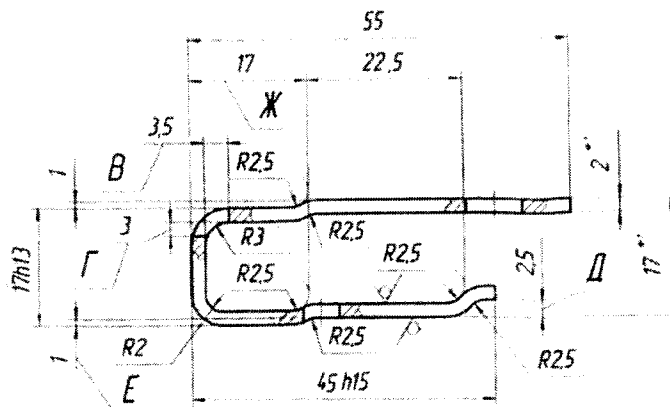
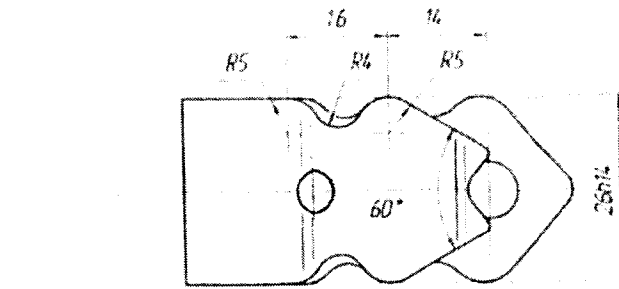
BUTTSTOCK END
PIECE ASSEMBLY
ASSEMBLY DRAWING

DRAWN	TRACED	CHKD.
S P SONI		
DATE	10.10.23	
APPROVED		
HOS/DDO		



SMALL ARMS FACTORY
KANPUR

DRG. NO.
SK-6595 TE



HOS/MMD
 Certified as correct copy
 Date: 03/11/23
 SW

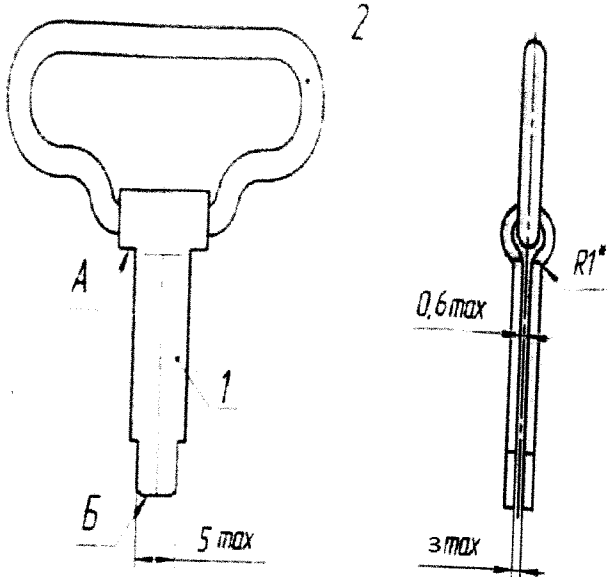
- 1 *Sheet 6T-6W-6A-1W-1H-1D-2x600x2000 GOST 19904-90
K4908 B4-11-40 GOST 16523-97
- 2 Dimensions with unspecified limit deviations to be ensured by tool
- 3 Unspecified tolerances according to 6T45-1 (8T9)/E2
- 4 *Reference dimensions
- 5 Appearance according to control sample
- 6 It is allowed to make slot with dimensions B and E when developed, it is allowed to make dimensions Δ, E, X in 6T45-1 (8T9)-5/E2

Sheet*

7.62x39mm AR-SAF		Weight: 34 g	
		DRAWN	SEEN BY
Reinforcing plate		DATE	109.10.2023
		APPROVED	
SCALE	SMALL ARMS FACTORY KANPUR	DRG. NO.	HOS/DDD
NIS		SK-6584/TE	
		SHT	1 OF 1

DRG. NO. SK-6597 TE

D.A. NO.



HOS/MSD
03/10/23
sin

- 1 *Dimension to be ensured by tool
- 2 Misalignment of surfaces A is allowed within tolerance limits, of surfaces B is 0,8 mm max.
- 3 Coating is Chem. Phos. chr/impreg. with 6Φ-4 glue GOST 12172-2016 with nigrosine of grade A GOST 9307-78
- 4 Press swivel ring pos.2 providing free rotation of loop pos.1

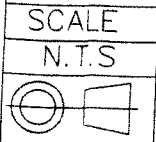
- 1. LOOP , Drg. no. SK-6582/TE
- 2. SWIVEL RING, Drg. No. SK-6590/TE

MATL. -

Weight 9g

7.62x39mm AR-SAF
Swivel assembly
Assembly drawing

DRAWN	TRACED	CHKD.
S P SONI		
DATE	10.10.23	
APPROVED		
HOS/DDO		

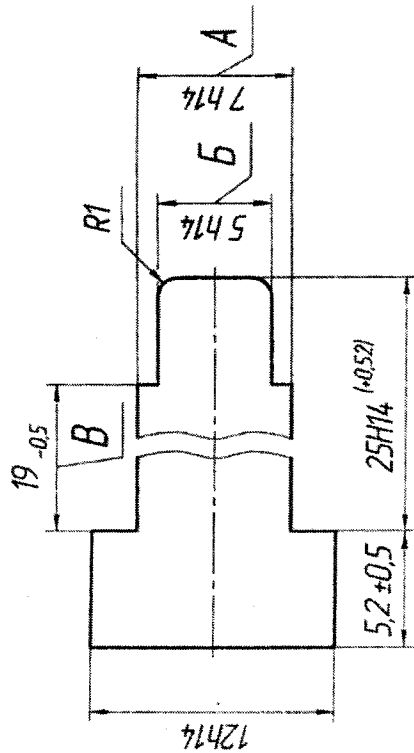
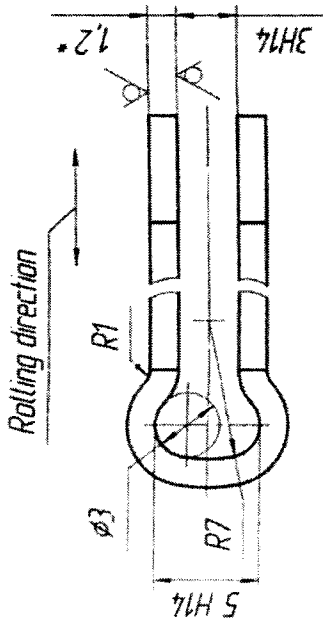


SMALL ARMS FACTORY
KANPUR

DRG. NO.
SK-6597 TE

SK-6582/TE

$\sqrt{Rz\ 4.0}$



- 1 Dimensions to be ensured by tool, except dimensions A, B and B.
- 2 Unspecified tolerances according to GOST 2284-79.
- 3 *Reference dimension.
- 4 Appearance according to control sample.

Strip 40-C-1-14
GOST 2284-79

7.62x39mm AR-SAF

Loop

Handwritten notes:
 1. 100% inspection
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 93. 100% inspection
 94. 100% inspection
 95. 100% inspection
 96. 100% inspection
 97. 100% inspection
 98. 100% inspection
 99. 100% inspection
 100. 100% inspection

Weight: 4g	
DRAWN	SEEN BY
DATE	13/09/2023
APPROVED	
F.O.S/DDO	

SCALE	NTS

SMALL ARMS FACTORY
KANPUR

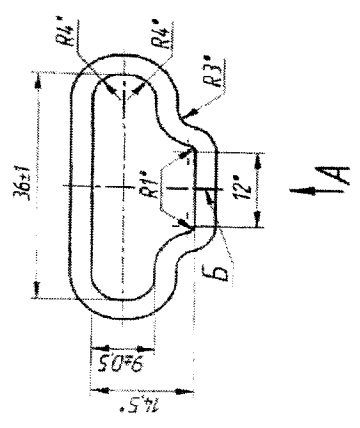
SK-6582/TE

SHT 1 OF 1

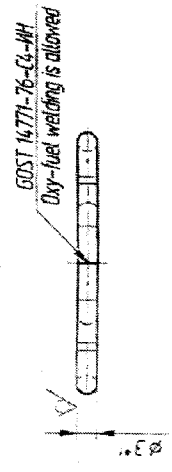
57

DRG. NO. SK-6590/TE

$\sqrt{Rz\ 20\ (\vee)}$



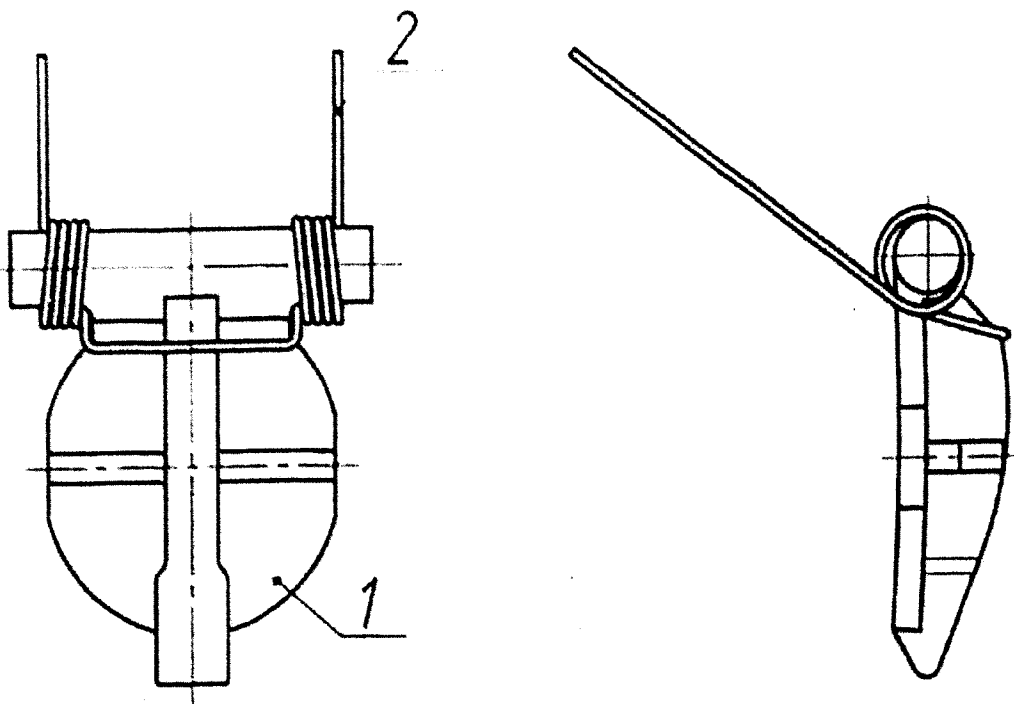
- 1 376.466 HV 5/10-15. Heat treatment is allowed in 6045-1C015-2/E2.
- 2 *Dimensions to be ensured by tool
- 3 *Reference dimensions.
- 4 Unspecified tolerances according to 6045-1C019/E2
- 5 Thickening by diameter up to 0.3 mm is allowed in welding point.
- 6 Overlap appearance and character according to control sample
- 7 Clearance not greater than 0.3 mm is allowed in junction point 5 before welding.



Handwritten notes:
 HOS/Man...
 03/11/23
 ...

DRAWN		TRACED		CHECKED	
APPROVED		DATE		09-10-2023	
J.W.M./DDO.		DRG. NO.		SK-6590/TE	
SCALE		1:1		SHT. 1 OF 1	
7.62X39mm AR-SAF		SWIVEL RING		SMALL ARMS FACTORY KANPUR	

1	2	3	4	5	6	7	8	9
A	B	C	D	E	F	G	H	



7.62x39mm AR-SAF
 मॉडेलिंग डिजाइन
 Certified as per
 03/10/23
 HOS/MSD

Weight 2.8 g

S.NO	NOMINCLATURE	QTY.	DRG. NO
1.	BUTT PLATE COVER	1	SK-6581 TE
2.	SPRING	1	SK-6541 TE

7.62x39mm AR-SAF

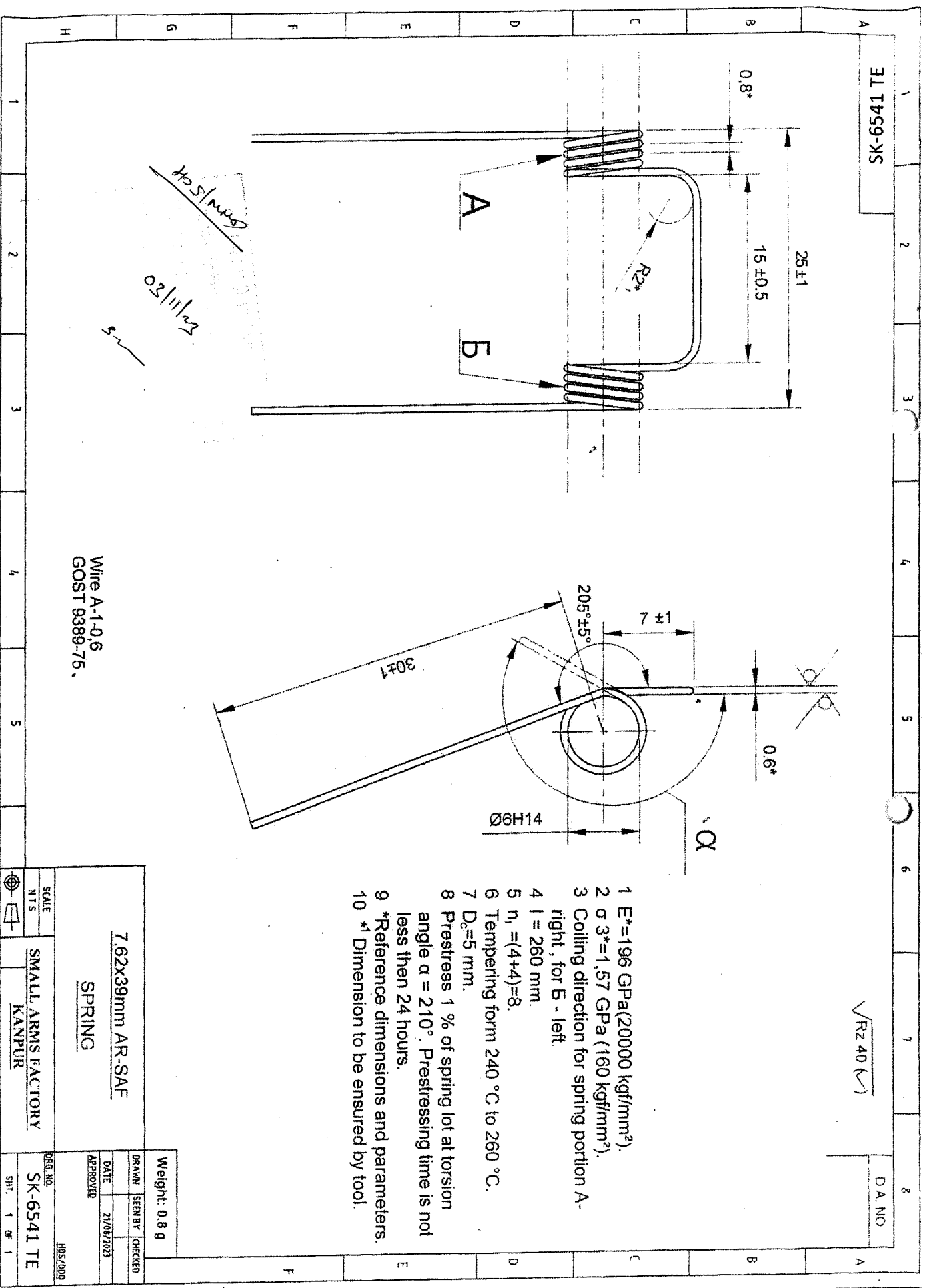
Butt plate cover
Assembly drawing

DRAWN	TRACED	CHKD.
S.P. SONI		
DATE	10.10.23	
APPROVED		
HOS/DDO		

SCALE
N.T.S

SMALL ARMS FACTORY
KANPUR

DRG.NO.
SK-6596 TE



SK 1459-KS

$\sqrt{Rz 40}$

D.A. NO.

Wire A-1-0,6
GOST 9389-75.

- 1 $E^* = 196 \text{ GPa}$ (20000 kgf/mm²).
- 2 $\sigma_3^* = 1,57 \text{ GPa}$ (160 kgf/mm²).
- 3 Coiling direction for spring portion A - right, for B - left.
- 4 $l = 260 \text{ mm}$.
- 5 $n_1 = (4+4) = 8$.
- 6 Tempering form 240 °C to 260 °C.
- 7 $D_s = 5 \text{ mm}$.
- 8 Prestress 1 % of spring lot at torsion angle $\alpha = 210^\circ$. Prestressing time is not less than 24 hours.
- 9 *Reference dimensions and parameters.
- 10 *1 Dimension to be ensured by tool.

Handwritten notes:
 20/1/20
 20/1/20
 20/1/20

SCALE		7.62x39mm AR-SAF	
NTS		SPRING	
DRAWN		SMALL ARMS FACTORY	
SEEN BY		KANPUR	
CHECKED			
DATE		21/08/2023	
APPROVED			
DREG. NO.		SK-6541 TE	
SHT. 1 OF 1		105/000	

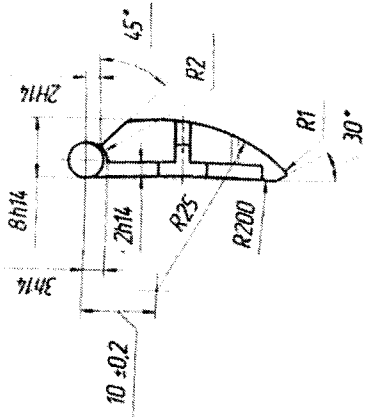
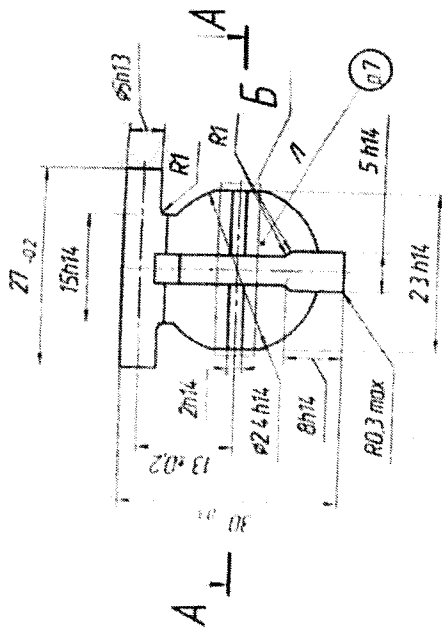
Weight: 0.8 g

1405 (mm)

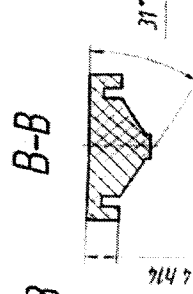
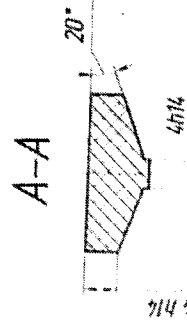
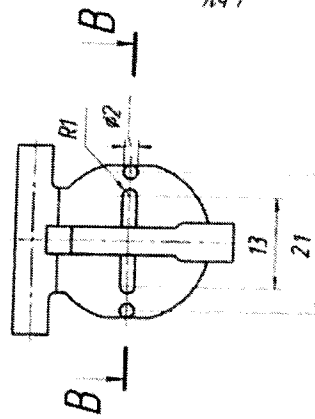
0311129

√ Ra 2.5 (/)

SK6581/TE



B Variant



- 1 *Polyamide PA 6-21-11 MC-21 quality grade 1 GOST 17648-83
- 2 Polyamide coloring agent is carbon black of grade K354 GOST 7885-86, or BASFO concentrate. TU 2016.59-001-23124.265-2018, PA-901/12-PA, black (2 %)
- 3 Rounding radii and inner radii are 0.5 mm
- 4 Unspecified tolerances according to 6h14-1(6T)/E2
- 5 *Roughness to be ensured by tool
- 6 Deflashing with roughness / Rz 40 according to control sample
- 7 Mark mold number and mold cavity number Font 2-1p3 GOST 26008-85.

Polyamide*

Weight: 2 g

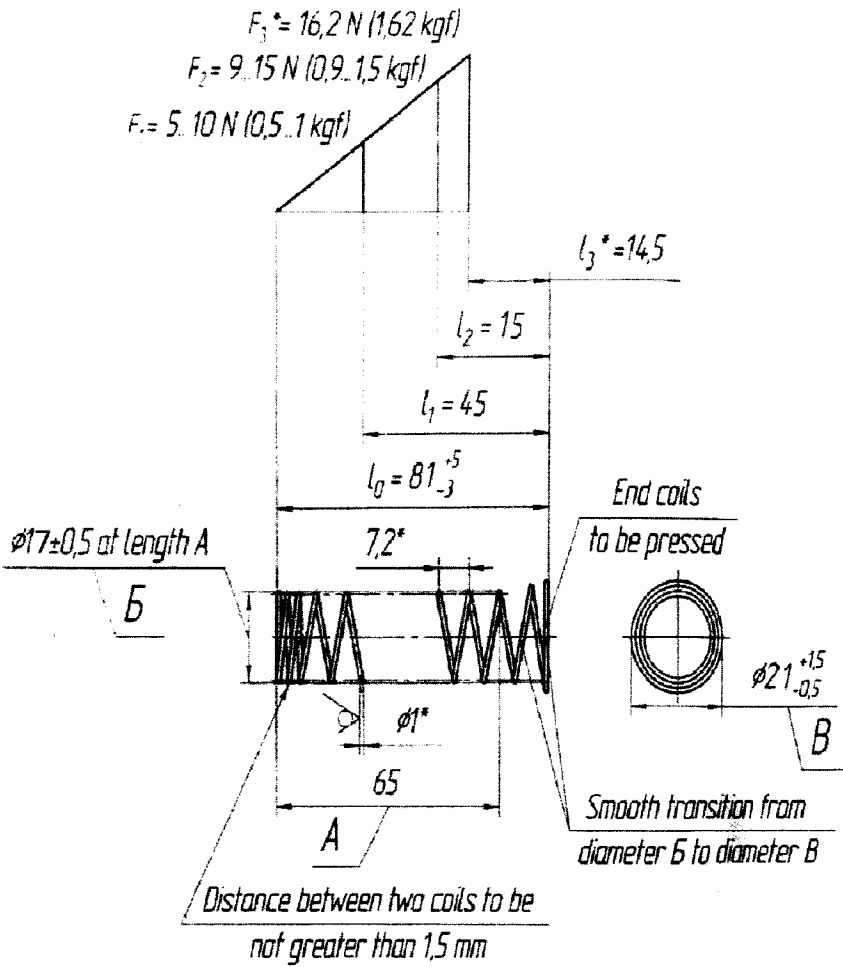
7.62x39mm AR-SAF

Buff-plate cover

SCALE	1:1	DATE	09.10.2023
DATE	09.10.2023	APPROVED	
DRAWN	SEEN BY	CHECKED	
7.62x39mm AR-SAF		Weight: 2 g	
Buff-plate cover		Polyamide*	
SCALE	1:1	DATE	09.10.2023
DATE	09.10.2023	APPROVED	
DRAWN	SEEN BY	CHECKED	
7.62x39mm AR-SAF		Weight: 2 g	
Buff-plate cover		Polyamide*	
SMALIT ARMS FACTORY		SK-6581/TE	
KANTUR		SHI 1 OF 1	

(JJ)

$\sqrt{Rz 20 (\sqrt{V})}$



H.S. (mm)
03/11/23
51

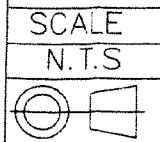
- 1 $G^* = 78,4 \text{ GPa}$ (8000 kgf/mm²).
- 2 $\tau_3^* = 0,625 \text{ GPa}$ (62,5 kgf/mm²).
- 3 Spring coiling direction - left. Right coiling direction is allowed.
- 4 $n = 11$.
- 5 $n_1 = 13 \pm 1$.
- 6 Tempering from 240 °C to 260 °C.
- 7 $l = 766 \text{ mm}$.
- 8 *Reference dimensions and parameters.
- 9 Force to be checked at l_2 only.

MATL. -

Wire 1-1.0
GOST 9389-75
Weight 4.6 g

7.62x39mm AR-SAF
Spring

DRAWN	TRACED	CHKD.
S.P. SONI		
DATE	10.10.23	
APPROVED		
HOS/DDO		

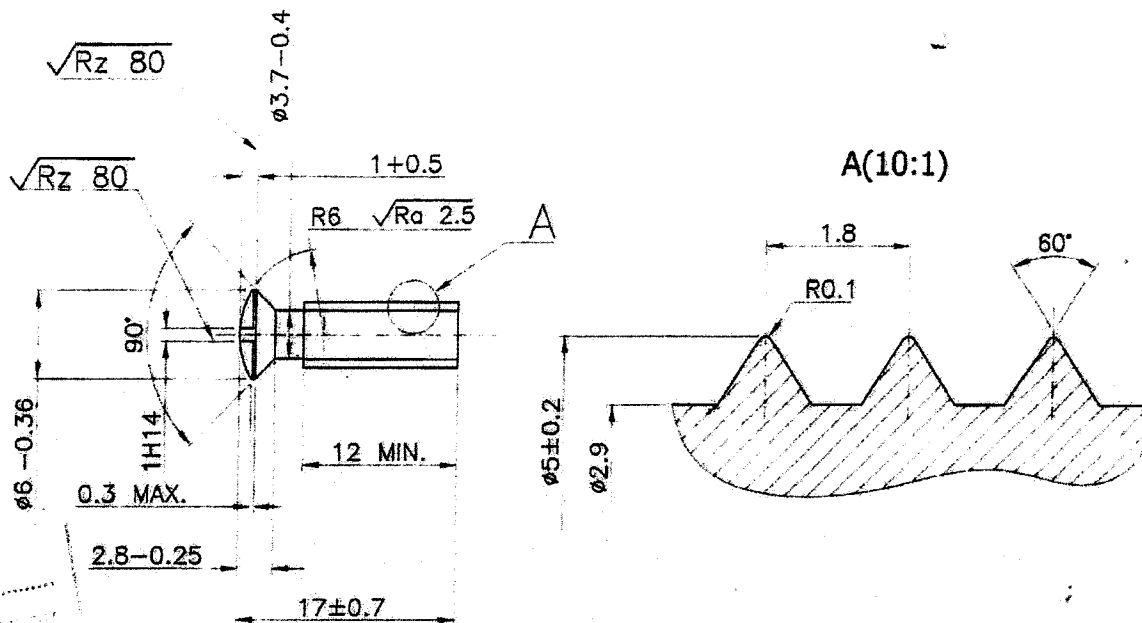


SMALL ARMS FACTORY
KANPUR

DRG. NO.
SK-6594 TE

SK-6533 TE

$\sqrt{Rz} 20 (\checkmark)$



MATL.:- Wire 3.5-35
GOST 5663-79

Weight:- 1.5 g

- 1 34...41.5 HRC.
- 2 Unspecified tolerance according to 61745-1, COTY/E2.
- 3 Displacement of slotted head or drive relative to shank is allowed up to 0.3 mm.
- 4 Incomplete thread profile on two turns on portion where threading shapes into smooth shank is allowed.
- 5 Coating is Chem. Phos. chr/impreg. with 5φ-4 glue GOST 12172-2016 with nigrosine grade A GOST 9307-78.

7.62X39mm AR-SAF

Screw

DRAWN.	TRACED	CHECKED
--------	--------	---------

S.P. SONI	
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DATE	16.08.2023
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APPROVED

HOS/DDO

SCALE

5:1



SMALL ARMS FACTORY
KANPUR

DRAWING NO.

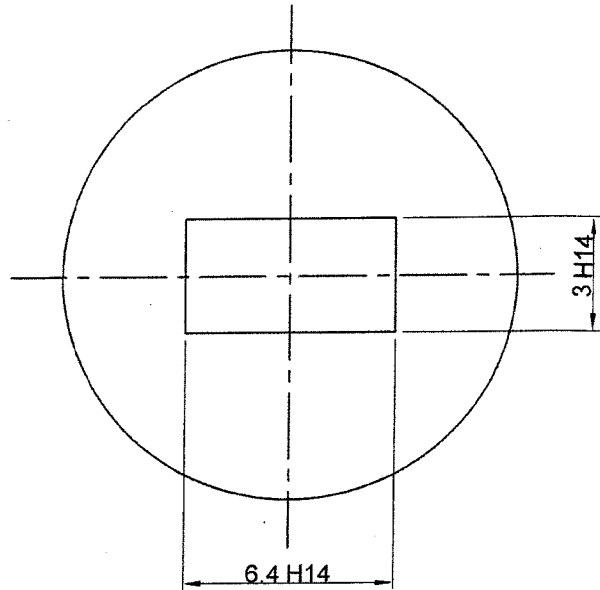
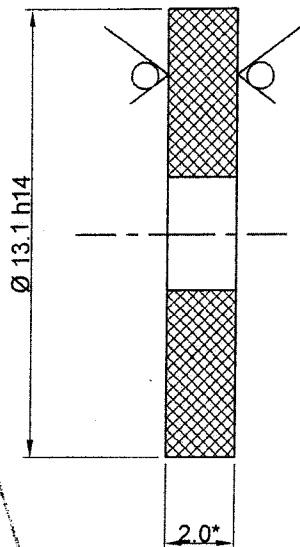
SK-6533 TE

SHEET 1 OF 1

DRG. SK-6527 TE

D.A. NO.

✓ Rz 40(✓)



NOTE:-

1. * Reference dimension.

2. Coating is Chem. Phos. chr./impreg. with 60-4 glue.

GOST 12172-2016 with nigrosine of grade A GOST 9307-78.

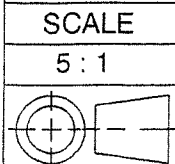
MATL.:- 6T-7H-HO-2 GOST 19904-90
K490B 4-II-40 GOST 16523-97

Weight:- 1.6g

7.62X39mm AR-SAF

Washer

DRAWN	TRACED	CHKD.
A.VERMA		
DATE	10-08-2023	
APPROVED		
JWM/DDO		



SCALE

5 : 1

SMALL ARMS FACTORY
KANPUR

DRG. NO.

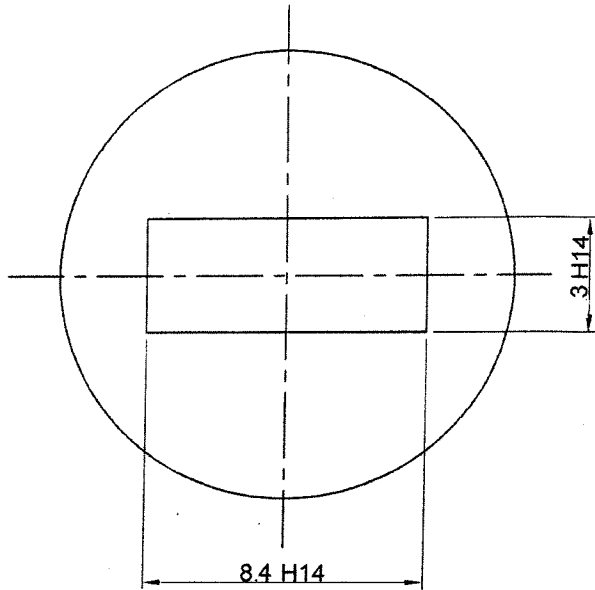
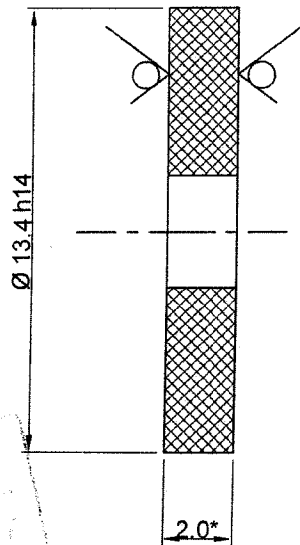
SK-6527 TE

SHEET 1 OF 1

SK-6528 TE

D.A. NO.

✓ Rz 40(✓)



Handwritten notes:
 HOS/MSD
 02/11/23
 SK

NOTE:-

1. * Reference dimension.

2. Coating is Chem. Phos. chr./impreg. with 60-4 glue.

GOST 12172-2016 with nigrosine of grade A GOST 9307-78.

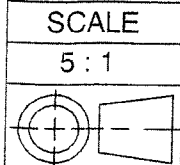
MATL.:- 6T-ПH-HO-2 GOST 19904-90
K490B 4-II-40 GOST 16523-97

Weight:- 1.5g

7.62X39mm AR-SAF

Washer

DRAWN	TRACED	CHKD.
A.VERMA		
DATE	10-08-2023	
APPROVED		
JWM/DDO		



SMALL ARMS FACTORY
KANPUR

DRG.NO.
SK-6528 TE
SHEET 1 OF 1

