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DWG NO 066628A-00

SH 1

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SHEET REV RECORD

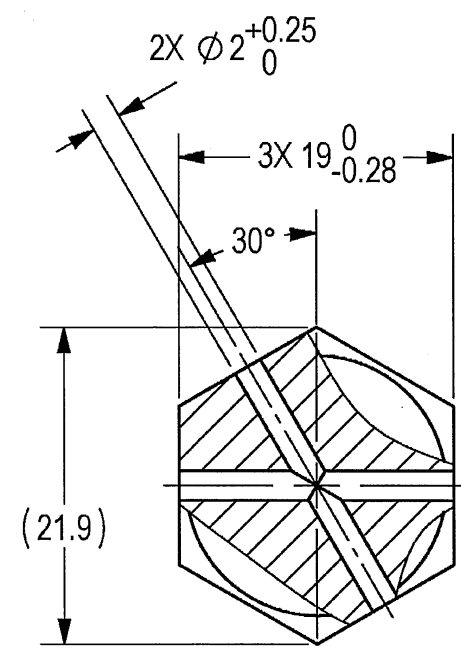
ALL SHEETS ARE THE SAME REVISION

REVISION RECORD

REV	ECO	DESCRIPTION	DATE	APVD	
02		Freeze	03-Apr-13		
03		Freeze	01-Dec-13		
04		Restricted	28-May-14	L. Goldshtein	
05	VY57/00	Restricted	16-Sep-14	D. Nave	
--	T00065	Identical To Previous	Released	09-Apr-18	L. Goldshtein

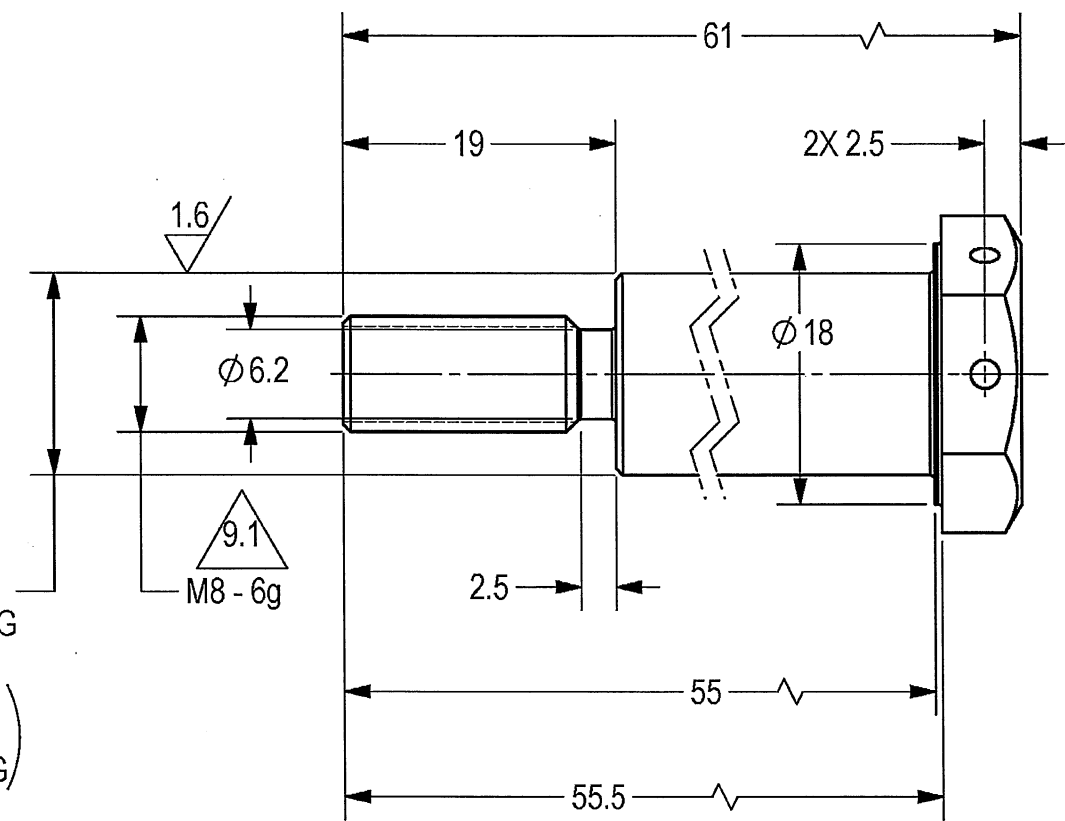
NOTES:

- INTERPRET THIS DRAWING IAW ASME Y14.100M.
- MATERIAL: ALLOY STEEL BAR RND SAE 4130 NORMALIZED PER SAE-AMS-S-6758 OR SAE 4340 NORMALIZED PER SAE-AMS-S-5000.
- UNLESS OTHERWISE SPECIFIED, UNDEFINED MACHINED FILLET RADII SHALL BE 0.2...0.3.
- DEBURR AND REMOVE SHARP EDGES, APPROX. 0.2X45 Deg.
- ALL DIMENSIONS ARE AFTER HEAT TREATMENT AND BEFORE COATING.
- DEFINED DIMENSION ARE AFTER HEAD TREATMENT AND AFTER COATING.
- GENERAL TOLERANCES ACCORDING TO ISO 2768-m.
- HEAT TREATMENT TO 35 ± 3 HRC PER AMS 2759/1.
- COATING: A DRY FILM LUBRICATION IN A FLUOROPOLYMER ORGANIC RESIN CLASS 2 COLOR MATTE BLACK TYPE I; 5-13 MICRON THICK PER VS-1-3-1-165 (OR EQUIVALENT).
- PROTECT THREAD AFTER PHOSPATE.
- QUALITY ASSURANCE PROVISIONS:
 - QUALITY ASSURANCE PROVISIONS FOR THIS ITEM PER RDMQD00012P.
 - PARENTHETICAL FIGURES ARE FOR REFERENCE ONLY.
 - PACKAGING AND PACKING: THE FINISHED PART SHALL BE PRESERVED AND PACKAGED IN ACCORDANCE WITH MANUFACTURER'S BEST COMMERCIAL PRACTICE.
 - IDENTIFY PER MIL-STD-130 PARA 4.1.B, BY LABELING ITS CONTAINER WITH THE PART NUMBER. CHARACTERS MINIMUM TEXT HEIGHT 1.25 MM.



Ø 14 -0.052/-0.079 BEFORE COATING

Ø 14 -0.032/-0.059 AFTER COATING

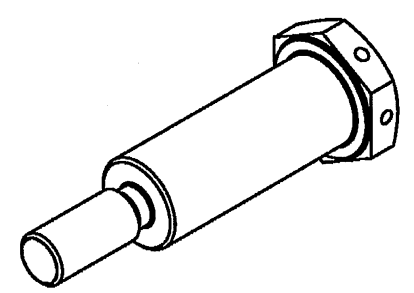


B

B

A

A



(WEIGHT: 0.065 Kg APPROX.)

SEE ATTACHED MEDIA

3.2/ (1.6/)

UNLESS OTHERWISE SPECIFIED		SIGNATURE		DATE		ORDNANCE FACTORY TIRUCHIRAPPALLI			
DIMENSIONS ARE IN MM PER ASME Y14.5M -1994		DRAWN		11/9/20		TITLE: SCREW HEAD COCKING			
TOLERANCES LINEAR SEE NOTE 7		CHECKED		3/9/20		FOR: STAND WEAPON ASSY OF: 12.7MM SRCG			
ANGULAR SEE NOTE 7		HOS/DDO				SIZE: B			
1st. ANGLE PROJECTION		OFFICER/PRODN				CAGE CODE: 2291A		DWG NO: 066628A-00	
SURFACE TEXTURE IN Micro Meter		OFFICER/QC				SCALE: 2:1		AUTOMATED DRAWING (SW)	
PROJECT OFFICER		OFFICER/DDO		3/9		SHEET 1 OF 1			

PLM Control

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