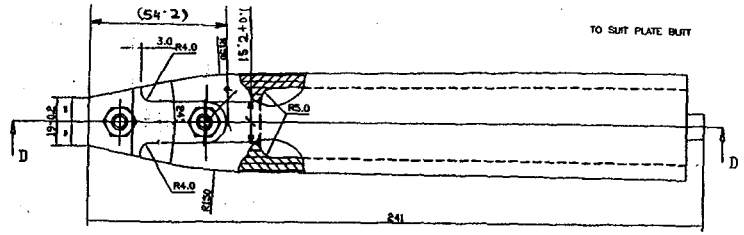
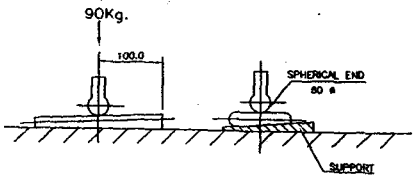


TEST TO BE CARRIED OUT ON FINAL STORE



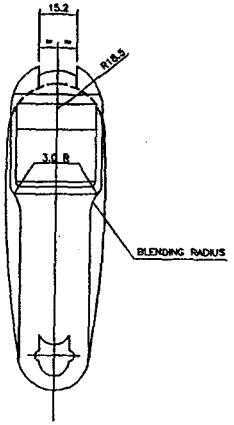
DRAWING CONVENTIONS CONFORM TO JSG : 0104
DIMNS. ARE IN mm. | GEN. TOL. "MEDIUM" TO IS: 2102

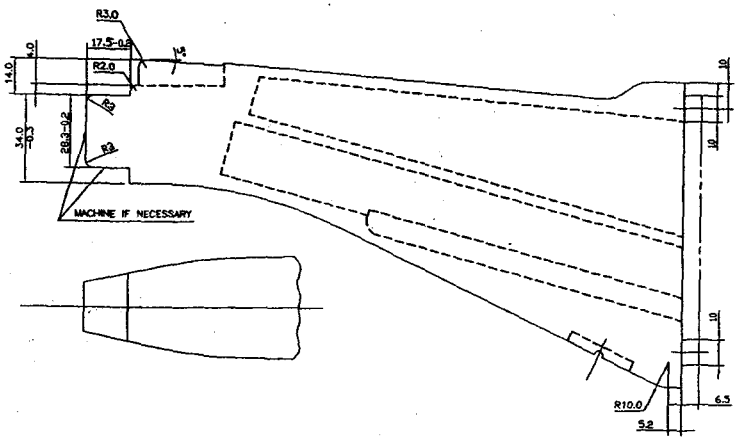
MARKING (SUITABLY) ON SAMPLE/TAG.

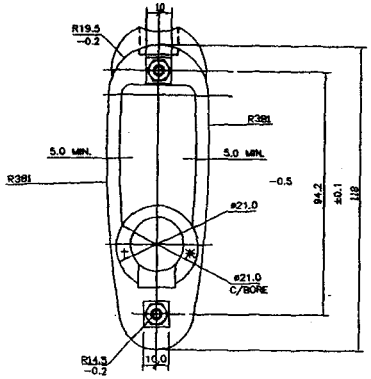
+ Yr OF Mfg.
* MANUFACTURER'S CODE.

MATERIAL :- NYLON 6 (WITHOUT GLASS FILLED) TO SATISFY THE FOLLOWING PHYSICAL PROPERTIES :-

	CHARACTERISTICS	UNIT	REQUIREMENTS
1.	SPECIFIC GRAVITY		1.06 ±0.02
2.	MELTING POINT	(Deg. C)	215 TO 225
3.	WATER ABSORPTION	(%)	0.7 MAX.
4.	TENSILE STRENGTH	(Mpa)	50 MIN.
5.	ELONGATION AT BREAK	(%)	60 MIN.







NOTE:-

TOLERANCE FOR ANGLES ± 30'

HOLLOWING OF BUTT EXCLUDING 21.0ø HOLE IS LEFT TO THE DISCRETION OF MANUFACTURER TO ACHIEVE SPECIFIED WEIGHT.

STEEL INSERT SHOULD NOT BE ABOVE THE LEVEL OF PLASTIC SURFACE.

SURFACES MARKED A,B & C ARE IMPORTANT AND TO BE MANUFACTURED STRICTLY AS PER SPECIFIED DIMNS.

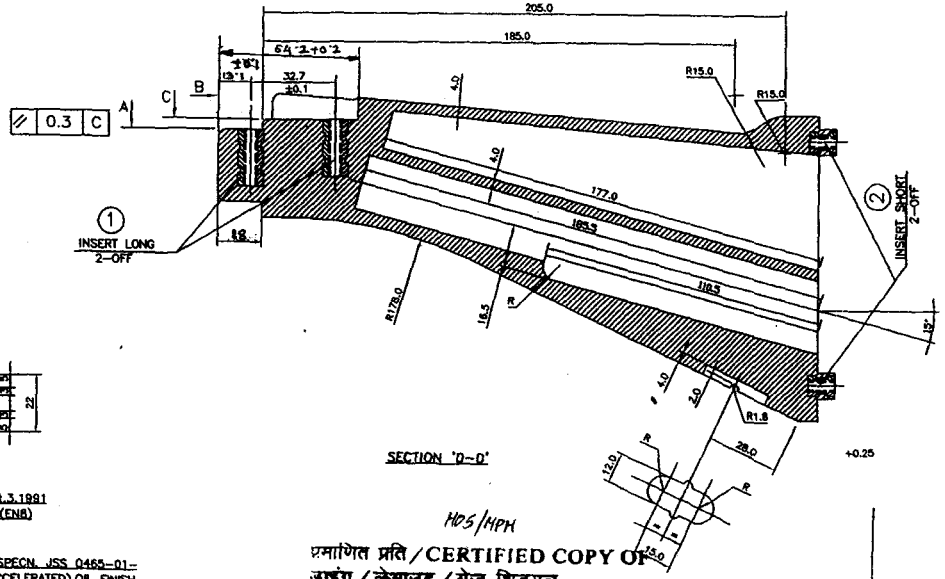
MACHINING IS PERMISSIBLE TO MAINTAIN THE DIMN.

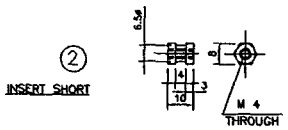
COLOUR:-

COLOUR : DARK BLUE GREY.
COLOUR CODE 695 TO SPCN IS 5:2007
ADDITION OF PIGMENT NOT PERMITTED

COATING:-

VAPOUR COATING IN DARK BLUE GREY COLOUR CODE 695 TO SPCN IS 5:2007 OR MRF SHADE NO. BLACK 600 WITH MATT FINISH

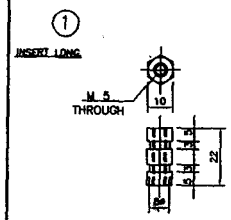




MATL :- STEEL BS:970 pt.3.1991 Gr. 080. M40 (EN8)

PROTECTIVE FINISH:-
PHOSPHATE TO SPECN. JSS 0465-01-1988.CLASS II(ACCELERATED).OIL FINISH

2-OFF PER MOULDING.POSITION AS SHOWN.



MATL :- STEEL BS:970 pt.3.1991 Gr. 080. M-40 (EN8)

PROTECTIVE FINISH:-
PHOSPHATE TO SPECN. JSS 0465-01-1988.CLASS II(ACCELERATED).OIL FINISH

2-OFF PER MOULDING.POSITION AS SHOWN.

HDS/HPH

प्रमाणित प्रति / CERTIFIED COPY OF
ड्राइंग / लेआउट / गेज शिडयूल
DRG/LAYOUT/GAUGE SCHEDULE
दिनांक / AT THIS DATE 29/05/16
सी डी डी / CDD
राइफल फैक्टरी, ईशापुर
RIFLE FACTORY, ISHAPORE

SEALED
DGHOC

DATE	DC RFI NO	SIGN
08/04/2014	09/025/14	

ASSY. DRAWING NO:-TGG-001	2013	NAME	DATE
INDIAN ORDNANCE FACTORIES RIFLE FACTORY ISHAPORE	DESIGNED	M HAIT	
	DRAWN		
	CHECKED		
	APPROVED		
TEAR GAS GUN BUTT	SCALE 1:1	DRAWING No. TGG-401	
		SHEET-1 OF-1	