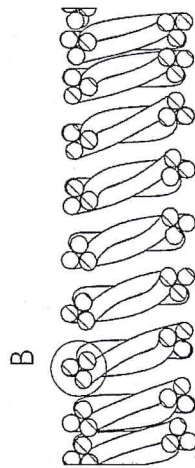
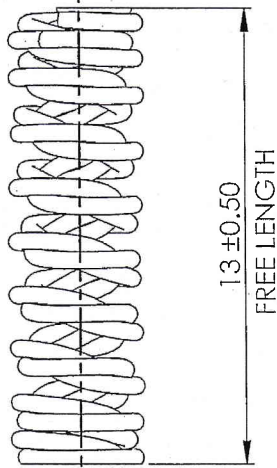
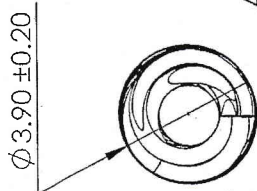
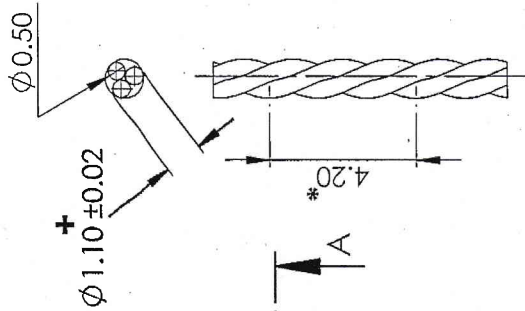


DETAIL B
SCALE 10 : 1



SECTION A-A
SCALE 5 : 1

A suitable number of Advance samples are to be tried out by fitment & firing before Bulk is produced

+ Must not produce any permanent set
Material:
 Steel IS: 4454 Pt.1 2001 Gr. DH (or)
 Steel IS: 4454 Pt.1 1981 Gr. 4
 Alternate Material:
 BS: 5216: 1975 Sec.4 Code 'M' Gr.5

Protective Finish:
 Accelerated Phosphating to Specn.
 JSS: 0465-01-1994 Class II, Oil Finish

Tempering/Stress Relief:
 200 °c to 240 °c for one Hour

Wire Dia. : 0.5 mm x 3 strands
 No. of coils : 7 ± 0.25
 Outer Dia. : 3.9 ± 0.2 mm
 Inner Dia. : 1.7 ± 0.2 mm

Direction of Spring Coiling : Right Hand
 Direction of Cable Braiding : Left Hand

One coil of each end to be closed to the axis of the Coil, leaving 3/4 of coil at each end non-effective.

Cramp Test:

Spring to be Tested before Gauging by compression to Solid Length for a period of 24 hours after which it must conform to the Free Length shown.

The spring to work freely in its loaded and unloaded condition in a Hole of ϕ 4.5 mm.

* Sizes & Parameters are given for Reference

	SIGNATURE & DATE.
	<i>[Signature]</i>
	<i>[Signature]</i>
	<i>[Signature]</i>
	<i>[Signature]</i>
	<i>[Signature]</i>
DA.No.: 40/21	SIG. & DATE
DT.: 27/07/2021	
AMENDMENTS	

SUB: Spring, Extractor	SCALE NTS
FOR: TRICHY ASSAULT RIFLE	QPG 1
OF: TRICHY ASSAULT RIFLE	Weight (g)
DES. REF. NO. K-2013 / K-2013-EXP	SHEETS: 1
DRG. No.: K-2013*	SHEET No.: 1
ORDNANCE FACTORY TIRUCHIRAPPALLI-16.	

UN CONTROLLED COPY
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 DRAWINGS AT THIS DATE: 06/15/22
 DESIGN & DRAWING OFFICE,
 ORDNANCE FACTORY, TIRUCHIRAPPALLI-620 016.