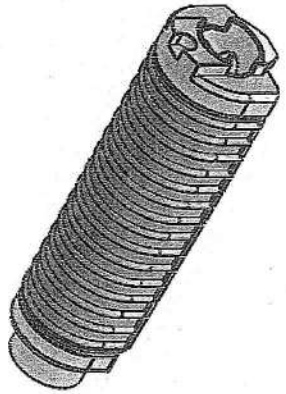


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ITEM NO.	PART NUMBER	QTY.
1	KC3-2056 Gas Tube Assy	1
2	KC3-2052 Upper Hand Guard	1
3	KC3-2054 Front Cup	1

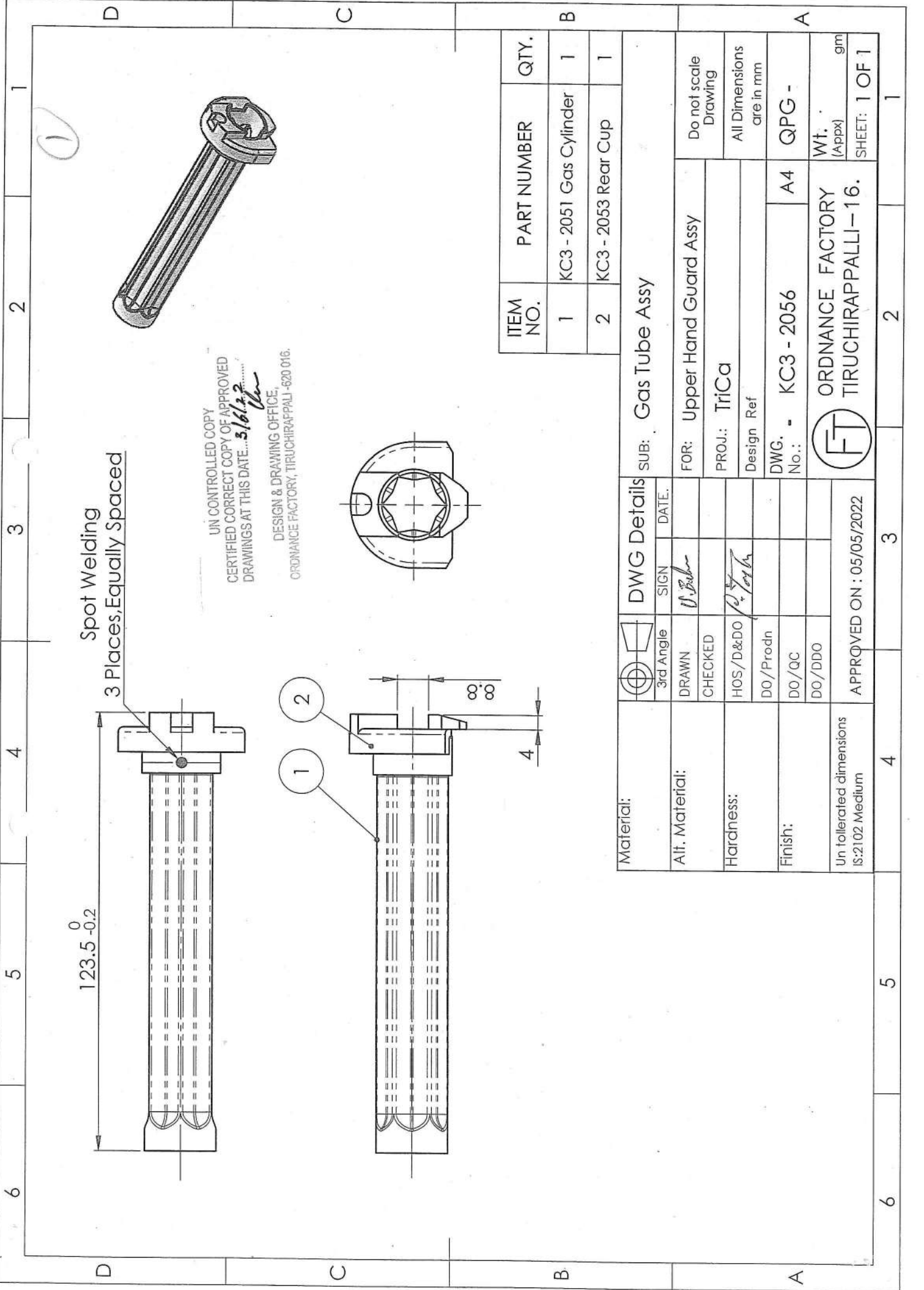
Material:	DWG Details	
	3rd Angle	DATE.
Alt. Material:	SIGN <i>V. Sathya</i>	
Hardness:	CHECKED	
Finish:	HOS/D&DO	
Un tolerated dimensions IS:2102 Medium	DO/Prodn	
	DO/QC	
	DO/DDO	

SUB: Upper Hand Guard Assy	
FOR: General Assy	Do not scale Drawing
PROJ.: TriCa	All Dimensions are in mm
Design Ref	
DWG. No.: KC3 - 2050	A4 QPG - 1
ORDNANCE FACTORY TIRUCHIRAPPALLI-16.	
Wt. (Appx) gm	SHEET: 1 OF 1

To be painted with Black PTFE (matt finish)
 (Except Plastic part)

Note:

1. Paint should with stand temperature of 300-350 °C.
2. Paint should not peel off and should have scratch resistance.



Spot Welding
3 Places, Equally Spaced

123.5 \pm 0.2

1
2

4

∞ ∞

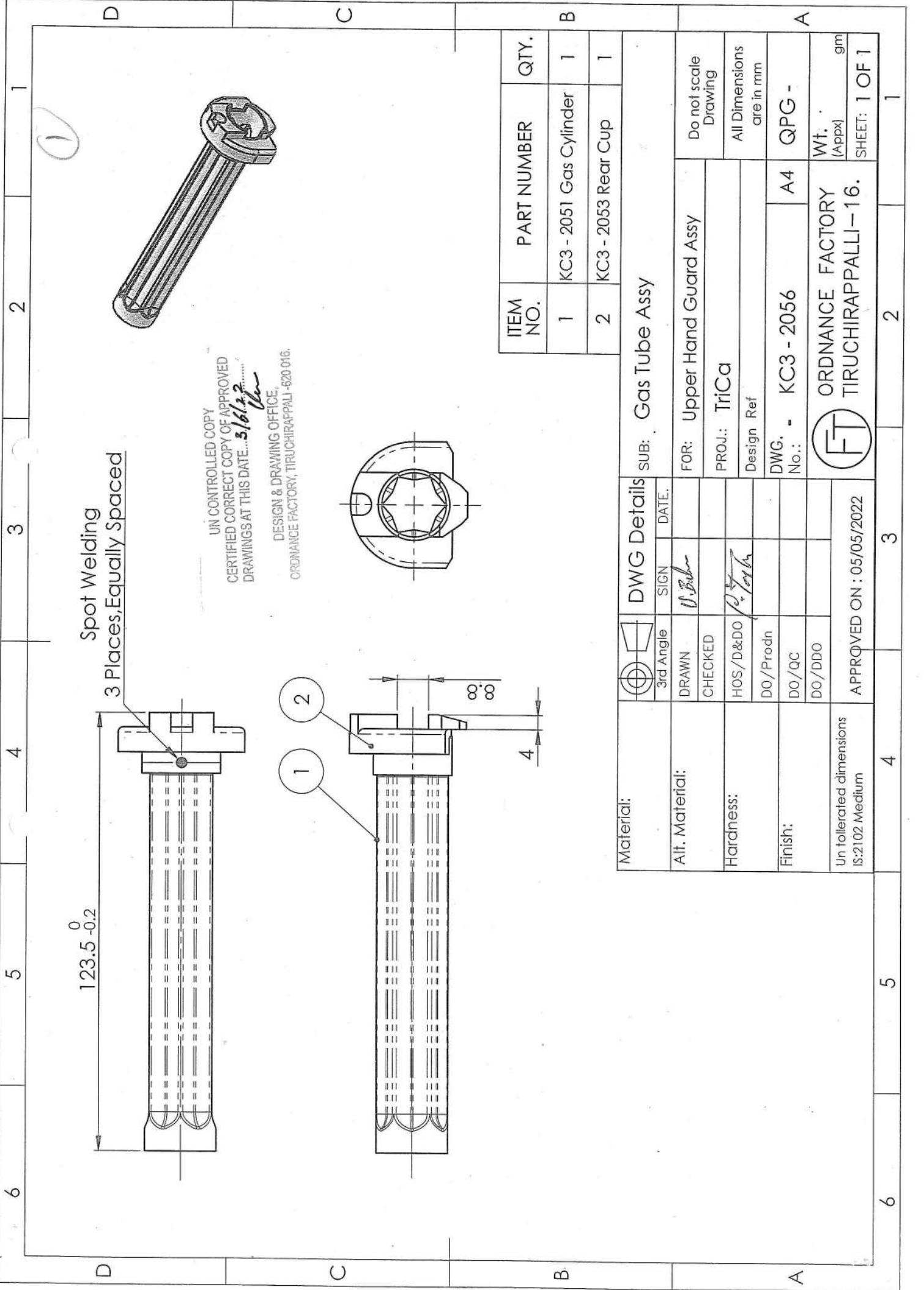
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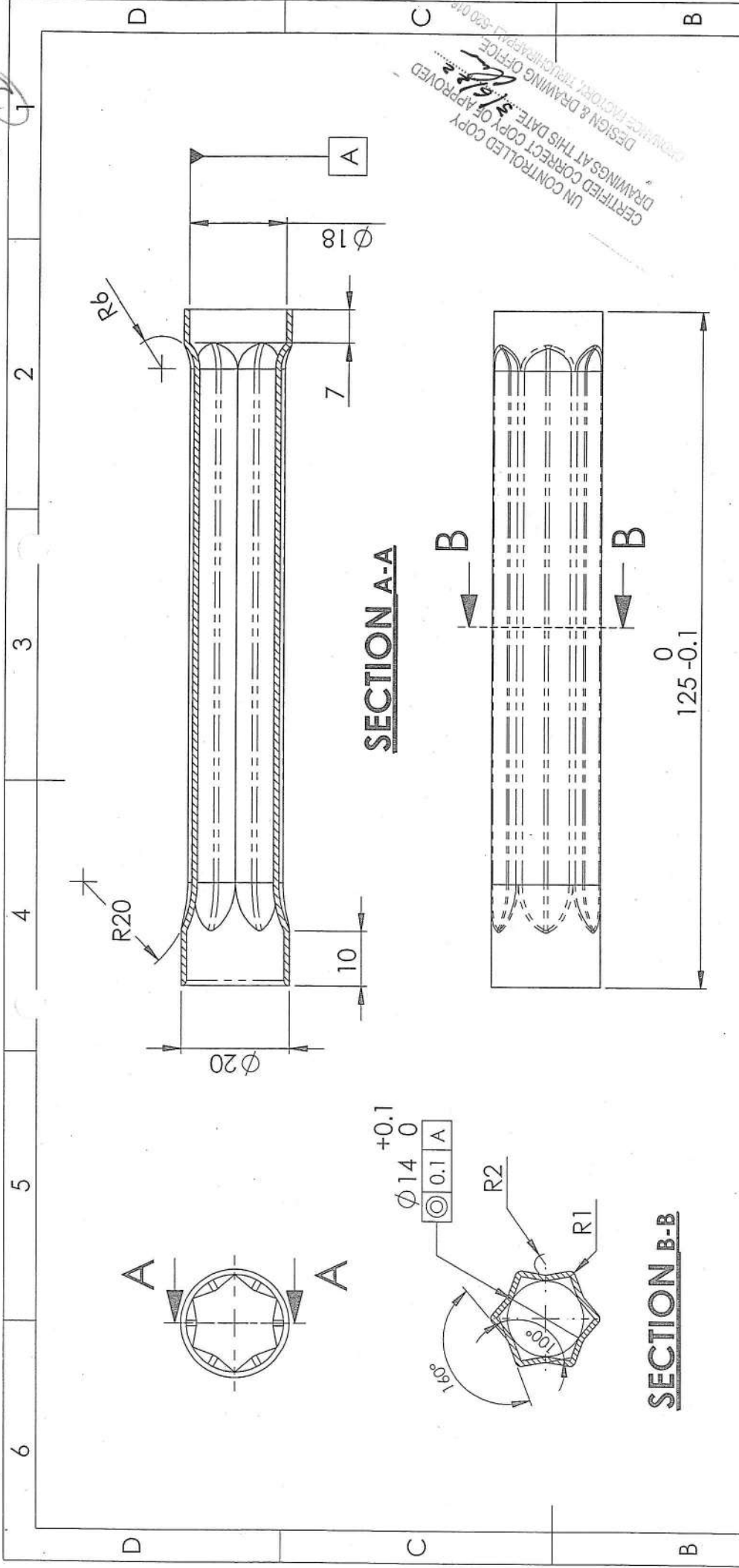
ITEM NO.	PART NUMBER	QTY.
1	KC3 - 2051 Gas Cylinder	1
2	KC3 - 2053 Rear Cup	1

Material:		SUB: Gas Tube Assy	
Alt. Material:		FOR: Upper Hand Guard Assy	
Hardness:		PROJ.: TriCa	
Finish:		Design Ref	
Un tollerated dimensions IS:2102 Medium		DWG. No.: KC3 - 2056	
APPROVED ON : 05/05/2022		A4	
APPROVED ON : 05/05/2022		QPG -	
APPROVED ON : 05/05/2022		Wt. (Appx) gm	
APPROVED ON : 05/05/2022		SHEET: 1 OF 1	



ORDNANCE FACTORY
TIRUCHIRAPPALI - 16.





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Material: As Above	DWG Details		SUB: Gas Cylinder	
	3rd Angle	SIGN	DATE	
Alt. Material:	DRAWN	<i>V. Balan</i>		FOR: Upper Hand Guard Assy
Hardness:	CHECKED			PROJ.: TriCa
360 - 440 HV	HOS/D&DO	<i>P. Jayan</i>		Design Ref
Finish: Phosphating to JSS:0465-01-1994, Class-II OIL finish	DO/QC			DWG. No.: KC3 - 2051 - A4
	DO/DDO			QPG - 1
Un tolerated dimensions IS:2102 Medium				WT. (Appx) gm
				FT ORDNANCE FACTORY TIRUCHIRAPPALLI-16.
				SHEET: 1 OF 1

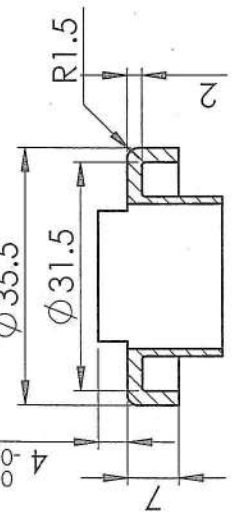
Material : Seamless Tube
 BS:6323 Pt.4 1982 Des CF-S11BK
 (or)
 BS:6323 Pt.4 1982 Des CF-S10 BK
 Blunt Sharp Edges to 0.4 R

6 5 4 3 2 1

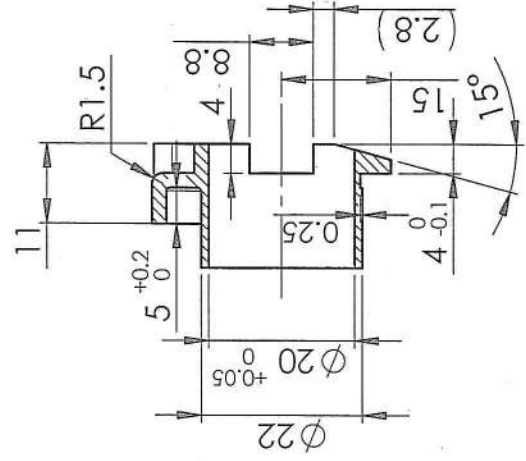
D C B A

6 5 4 3 2 1

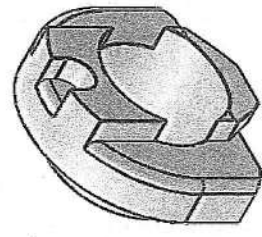
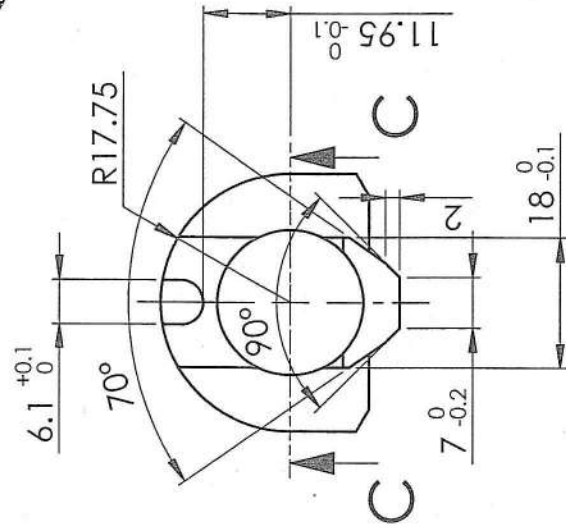
6 5 4 3 2 1



SECTION C-C



SECTION B-B



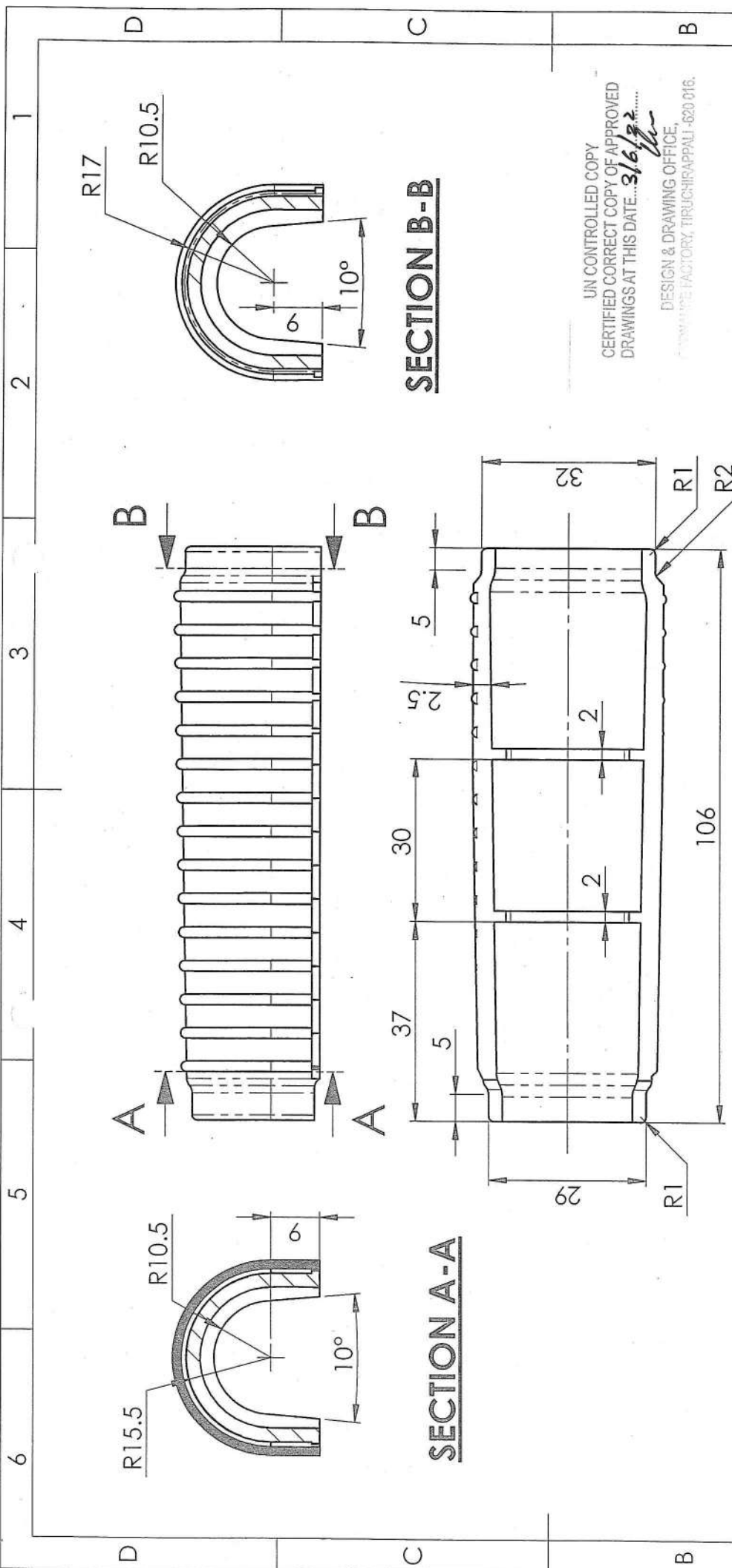
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For Casting

BS:3146 Pt-1, 1974 Class:5, Grade:A
 Non Stressed Component.
 Radiographic Test as per ASTM-E-192
Acceptance Standard:
 Gas hole & Foreign Material : Level-3
 Shrinkage (All Types) : Level 3.
 Blunt Sharp Edges to 0.4R.

Material: BS 970 Pt-1, 1983 070M55 (EN-9)	3rd Angle	DWG Details		SUB: Rear Cup	Do not scale Drawing
		SIGN	DATE:		
Alt. Material: BS 970 Pt-1, 1983 080M40 (EN-8)	DRAWN	HOS/D&DO	PROJ.: TriCa	Design Ref	QPG - 1
Hardness: 290 - 350 HV	CHECKED				
Finish: Phosphating to JSS:0465-01- 1994, Class-II OIL finish	DO/QC	DO/DDO	ORDNANCE FACTORY TIRUCHIRAPPALLI-16.		WT. (Appx) gm
Un tollerated dimensions IS:2102 Medium	APPROVED ON : 05/05/2022		SHEET: 1 OF 1		

6 5 4 3 2 1

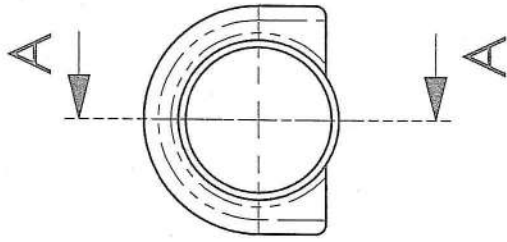
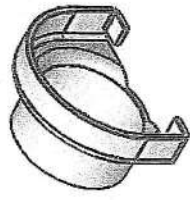


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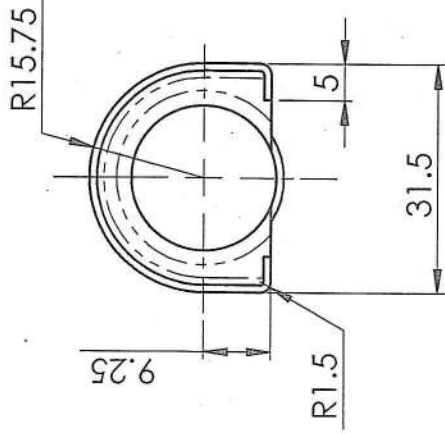
Material :
 Glass Fibre Reinforced Polyamide
 Nylon-6 (or) 66
 Melting Point Not less than 200 °C

Material:	SUB: Upper Hand Guard		DWG Details		A	
	Alt. Material:	FOR: Upper Hand Guard Assy	3rd Angle	SIGN	DATE	Do not scale Drawing
Hardness:	PROJ.: TriCa	DESIGN Ref	DRAWN	<i>V. Subu</i>		All Dimensions are in mm
Finish: Black Matt Finish	DWG. No.:	KC3 - 2052	CHECKED	<i>P. Jothi</i>		QPG -
	ORDNANCE FACTORY TIRUCHIRAPPALI - 16.		DO/Prodn			A4
Un tolerated dimensions IS:2102 Medium	APPROVED ON: 05/05/2022		DO/QC			SHEET: 1 OF 1
			DO/DDO			

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SECTION A-A



SECTION B-B

Material: Sheet - 1.0mm

- BS:1449 Pt.1 1983 Gr.CS40 Sec-4
- (or) BS:1449 Pt.1 1983 Gr.CS50 Sec-4
- (or) BS:1449 Pt.1 1983 Gr.CS60 Sec-4
- (or) BS:1449 Pt.1 1983 Gr.CS70 Sec-4
- (or) BS:1449 Pt.1 1983 Gr.CS80 Sec-4

Blunt Sharp Edges to 0.4R.

Material: As Above	DWG Details		SUB: Front Cup		Do not scale Drawing
	3rd Angle DRAWN	SIGN <i>V. Subram</i>	DATE:	FOR: Upper Hand Guard Assy	
Alt. Material:	CHECKED		PROJ.: TriCa	Design Ref	QPG - 1
Hardness: 290 - 350 HV	HOS/D&DO		DWG: KC3 - 2054-		
Finish: Phosphating to JSS:0465-01- 1994, Class-II OIL finish	DO/Prodn		No.:	ORDNANCE FACTORY TIRUCHIRAPPALLI-16.	SHEET: 1 OF 1
Un tolerated dimensions IS:2102 Medium	DO/QC				
	DO/DDO				