

SECTION U-U

UN CONTROLLED COPY  
 CERTIFIED CORRECT COPY OF APPROVED  
 DRAWINGS AT THIS DATE... 06/7/23  
 DESIGN & DRAWING OFFICE,  
 ORDNANCE FACTORY, TIRUCHIRAPPALI-620 016.

**MARKING: - \* MANUFACTURER CODE  
 + BATCH/YEAR OF MANUFACTURE  
 ENGRAVING DEPTH 0.3MM & HEIGHT 3MM.**

ITEM NO.	PART NUMBER	QTY.
4	K-2056 Gas Tube Assy	1
3	K-2055 Leaf Spring Cylinder	1
2	K-2054-Front Cup	1
1	K-2082 Upper Hand Guard Picc	1

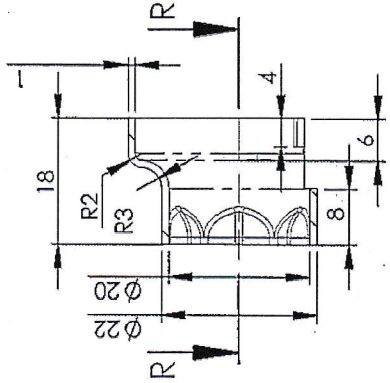
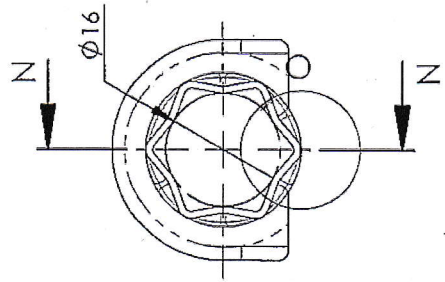
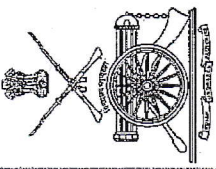
\*6 DA.No. 24/23  
 Dr. 04/07/23  
 \*5 DA.No. 84/21/16  
 Dr. 21/12/21  
 \*4 DA.No. 41/21/18  
 Dr. 27/12/21  
 \*3 DA.No. 27/21  
 Dr. 17/4/21  
 Redrawn by: [Signature]  
 APPROVED ON 19.8.19

TRACED	SIGNATURE & DATE	SCALE
DRAWN		NTS
CHECKED		OPC
QC/D&DO		1
OFFICER/PRODN		Weight(g)
DIV OFFICER/D&DO		
APPROVED ON 19.8.19		SHEETS: 1
SIC. & DATE		SHEET No.: 1

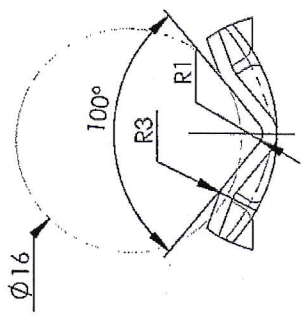
To be painted with Black PTFE (matt finish)  
 (Except Plastic part)  
 Note:  
 1. Paint should with stand temperature of 300-350 deg C.  
 2. Paint should not peel off and should have scratch resistance.

ORDNANCE FACTORY  
 TIRUCHIRAPPALI-16.

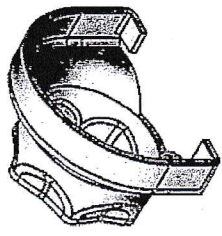
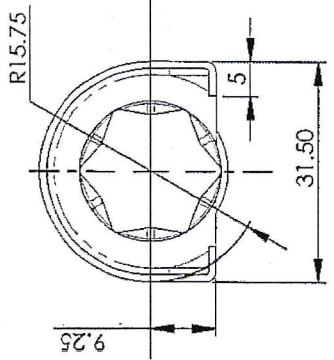




SECTION N-N



DETAIL O



**Material :** Steel Sheet 1.0 mm  
 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

**Hardened and Tempered to :** 290-350 HV

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

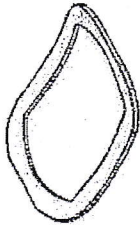
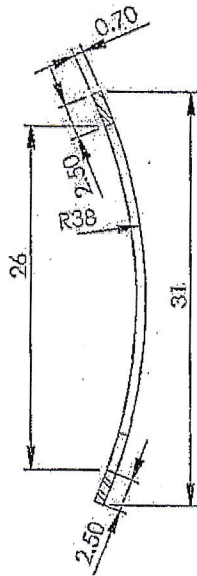
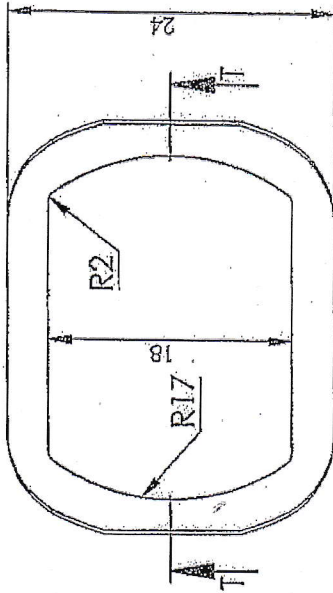
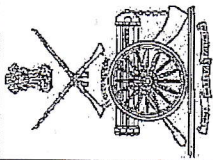
**Blunt Sharp Edges to 0.4 R**

AMENDMENTS & DATE	SIGNATURE & DATE.	SUB: <b>Front Cup</b> FOR: Upper Hand Guard Assy OF: TRICHY ASSAULT RIFLE DES. REF. NO. K-2054 DRG. TAR-K-2054 No.:	SCALE
			NTS
			QPG 1
			Weight (g)
			SHEETS: 1
			SHEET No.: 1



ORDNANCE FACTORY  
 TIRUCHIRAPPALLI-16.

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 DRAWINGS AT THIS DATE: 06/27/23  
 DESIGN & DRAWING OFFICE,  
 ORDNANCE FACTORY, TIRUCHIRAPPALI-620 016.



① Material : Steel Sheet 0.7mm  
 Pt. 5-1972  
 BS:970 Pt. 1-1983 Sec. 3 Gr.070 A78  
 Alt. Matl. Pt. 5-1972  
 BS:970 Pt. 1-1983 Sec. 3 Gr.070 A72  
 EN42(or) EN42J

Hardened and Tempered to: 475-550 HV  
 Protective Finish :  
 Accelerated Phosphating to Specn.  
 0465-01-1994 Class II Oil Finish

Blunt Sharp Edges to 0.4 R

SECTION-T

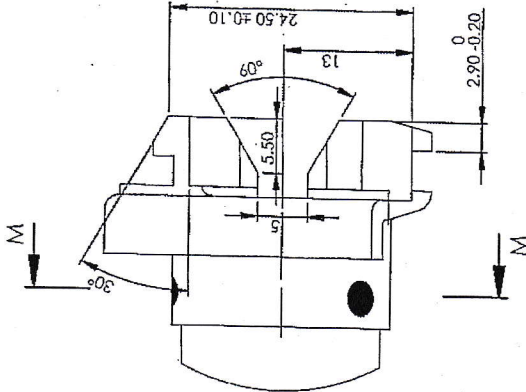
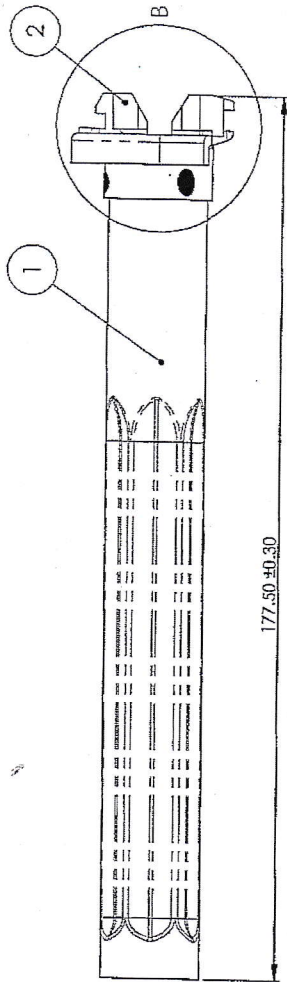
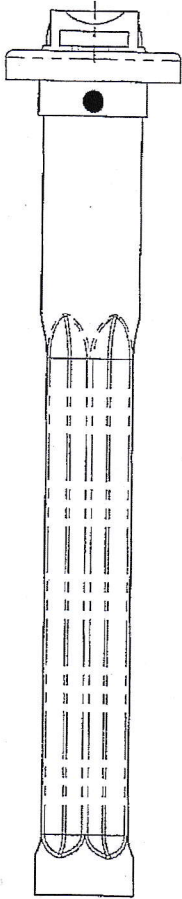
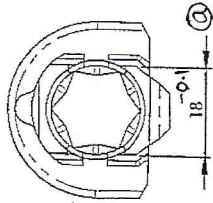
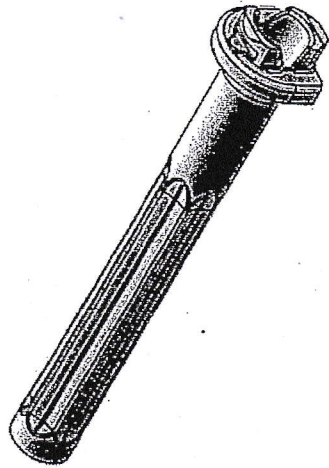
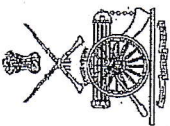
TRACED DRAWN CHECKED O/C/D&DO OFFICER/PRODN. DIV/OFFICER/D&DO	SIGNATURE & DATE:  <i>P. Forth</i>  <i>SKA</i> APPROVED ON: 17/09/2018	SUB: <b>Leaf Spring Cylinder</b> FOR: Lower Hand Guard Assy OF: TRICHY ASSAULT RIFLE DES. REF. NO. K-2055 DRG. No.: K-2055*	SCALE NTS
			Weight (g) SHEETS: 1 SHEET No.: 1

AMENDMENTS DA no: 53/19 dt: 11-12-19 ①	SIG. & DATE <i>Mull.</i> 11-12-19
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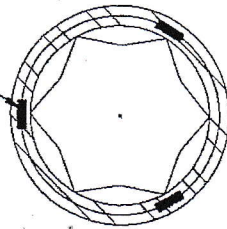
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 ORDNANCE FACTORY, TIRUCHIRAPPALLI-16  
 06/12/23



ORDNANCE FACTORY  
 TIRUCHIRAPPALLI-16.



Spot Welding  
3 Places



SECTION M-M

DETAIL B

Gas Tube Assy is to be painted with Black PTFE (MATT Finish) \*2  
(Sample to be approved before bulk supply)  
Note:- 1. Paint should withstand temp of 300 - 350°C  
2. Paint should not peel off and have scratch resistance

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DRAWINGS AT THIS DATE: 06/17/23  
DESIGN & DRAWING OFFICE,  
ORDNANCE FACTORY, TIRUCHIRAPPALLI-620 016.

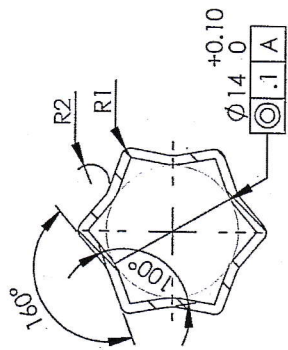
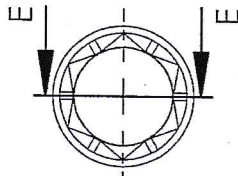
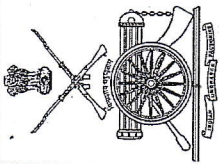
ITEM NO.	PART NUMBER	QTY.
2	K-2053 Rear Cup ✓	1
1	K-2051 Gas Cylinder ✓	1

SUBJECT	Gas Tube Assy
FOR	Upper Hand Guard Assy
OF	TRICHY ASSAULT RIFLE
DESIGN REF. NO.	K-2050
DRG. No.	TAR-K-2056 *3
FACTORY	ORDNANCE FACTORY TIRUCHIRAPPALLI - 16.
SHEET No.	1
SHEET No.	1

TRACED	SIGNATURE & DATE
DRAWN	
CHECKED	
DIC/D&DO	
OFFICER/PRODN.	
D&DO	
APPROVED ON: 27/08/2018	

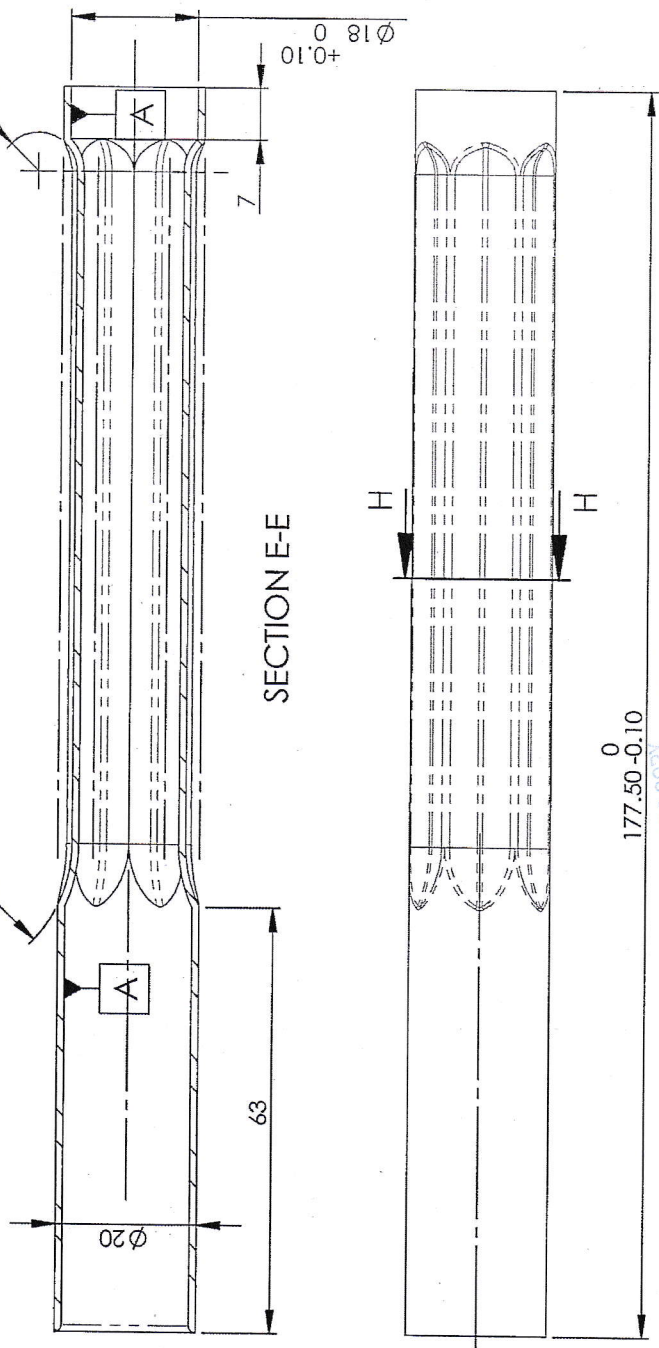
DA. No. 49/21  
Dt. 27/9/21  
DA. No. 27/21  
17/1/21  
DA. No. 27/19  
30.07.19

8 7 6 5 4 3 2 1



SECTION H-H  
Enlarged

SECTION E-E



ALT. MATERIAL :- ASTM A213/T22

Material : Seemless Steel Tube

BS:6323 Pt.4 1982 Des CF-S11BK  
(or)

BS:6323 Pt.4 1982 Des CF-S10 BK

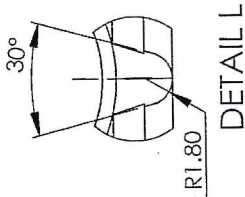
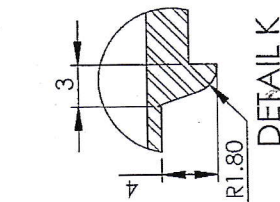
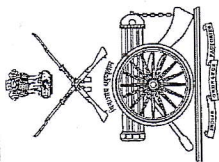
Hardened and Tempered to : 360-440 HV

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

Blunt Sharp Edges to 0.4 R  
Untolerated Dimensions as per IS:2102 MED

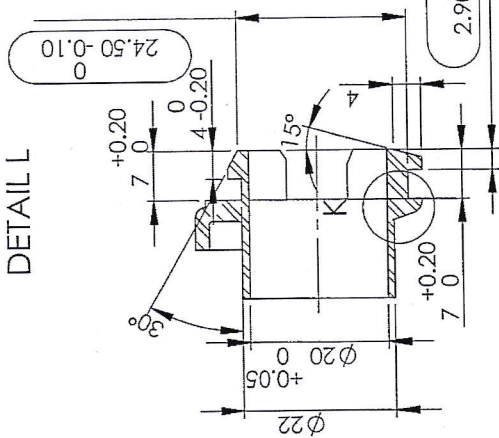
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CERTIFIED CORRECT COPY OF APPROVED  
DRAWINGS AT THIS DATE: 06/17/23  
*[Signature]*  
DESIGN & DRAWING OFFICE,  
ORDNANCE FACTORY, TIRUCHIRAPPALI-620 016.

TRACED DRAWN CHECKED OIC/D&DO OFFICER/PRDND. DIV. OFFICER/D&DO	SIGNATURE & DATE.	SUB: <b>GAS Cylinder</b>	SCALE NTS
		FOR: Upper Hand Guard Assy	QPG 1
		OF: TRICHY ASSAULT RIFLE	Weight (g)
		DES. REF. NO. K-2051	
		DRG. No.: TAR-K-2051 *	
		ORDNANCE FACTORY TIRUCHIRAPPALI-16.	SHEETS: 1
			SHEET No.: 1
AMENDMENTS	SIG. & DATE		
① DA No. 27/21 Dt. 17/1/2021	<i>[Signature]</i> 10/08/2018		

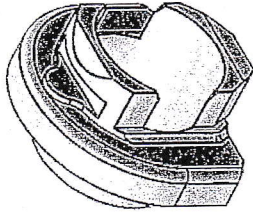
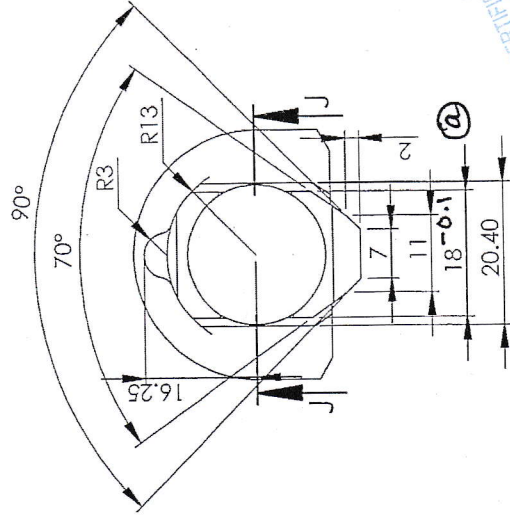
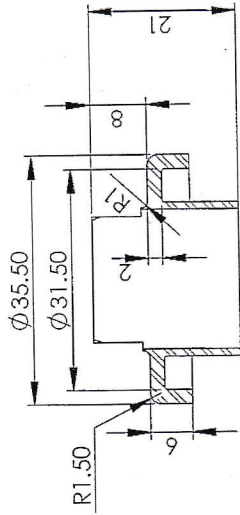


DETAIL L

DETAIL K



SECTION I-I



**Material :- Steel**  
 BS:970 pt.1 1983 Gr.070 M55 (En-9)  
 BS:970 pt.1 1983 Gr.080 M40 (En-8)

Hardened & Tempered to : 290-350HV

**for Casting**  
 BS:3146 PART-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

**Protective Finish:**  
 Phosphating to Specn.  
 0465-01-1994 Class II Oil Finish

Blunt Sharp Edges to 0.4 R  
 Untolerated Dimensions as per IS:2102 MED

CERTIFIED CORRECT COPY OF ORIGINAL DRAWING  
 DESIGN & DRAWING OFFICE  
 ORDNANCE FACTORY, TIRUCHIRAPPALLI-64

TRACED DRAWN CHECKED OIC/D&DO OFFICER/PRODN. DIV.OFFICER/D&DO	SIGNATURE & DATE.	SUB: <b>REAR CUP</b>	SCALE: NTS
		FOR: Upper Hand Guard Assy	QPG 1
		OF: TRICHY ASSAULT RIFLE	Weight (g)
		DES. REF. NO. K-2053	
		DRG. No.: <b>TAR-K-2053*</b>	
		ORDNANCE FACTORY TIRUCHIRAPPALLI-16.	SHEETS: 1
			SHEET No.: 1

AMENDMENTS	SIG. & DATE
DA.No. 49/21 27/09/21	 10/08/2018