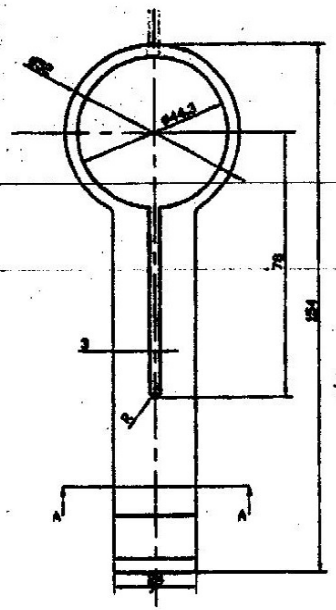
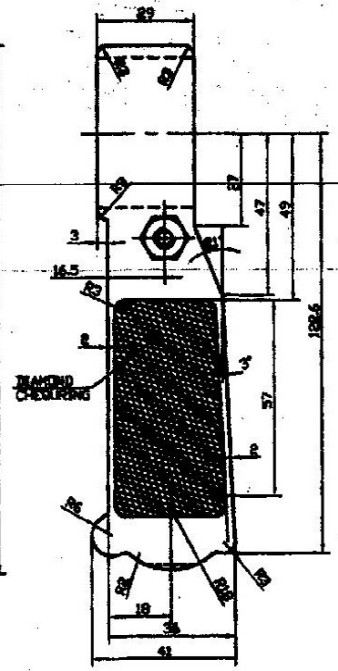
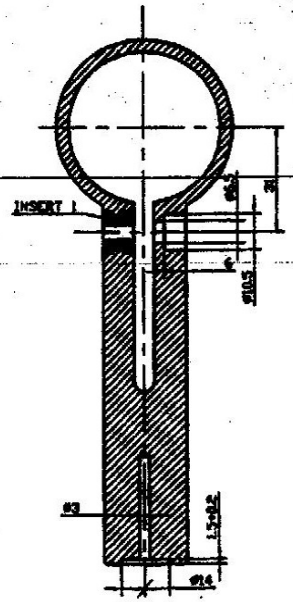
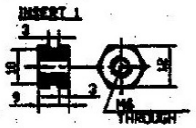








MATL :- STEEL BS970 pt.3:1991 Gr. 080 M-40(EN8)

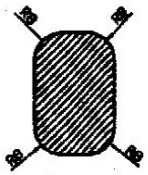
PROTECTIVE FINISH:- PHOSPHATE TO SPCN. IRS 0465-01-1989. CLASS II(ACCELERATED), OIL FINISH.

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.

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

MACHINING IS PERMISSIBLE TO MAINTAIN THE DIMN.



VIEW AT "A-A"

SEALED
DGM/QC

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

HOS/MPM
प्रमाणित प्रति / CERTIFIED COPY OF
ड्राइंग / लेआउट / गेज शिड्यूल
DRG/LAYOUT/GAUGE SCHEDULE
संख्या, AT THIS DATE 31.10.17
सी डी ओ / CDO
सहायक सेक्रेटरी, इशापुर
RIFLE FACTORY, ISHAPORE

ASSY. DRAWING NO:-	2013	NAME	DATE
INDIAN ORDNANCE FACTORIES RIFLE FACTORY ISHAPORE	DESIGNED	M HAIT	
	DRAWN		
	CHECKED		
	APPROVED		
TEAR GAS GUN FORE GRIP MOULDING	SCALE 1:1	DRAWING No. TGG-601	
		SHEET-1 OF-1	