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Latest Spec
as on 4.7.05

TELEGRAM : ASSURARM
TELEX : 021-8557
TELEPHONE : 556-0380

Ministry of Defence
Ministry of Defence (DGQA)
Controllerate of Quality Assurance (SA)
P.O. Ichapur - Nawabganj,
Dist. 24, parganas (North)
Pin. 743 144, West Bengal

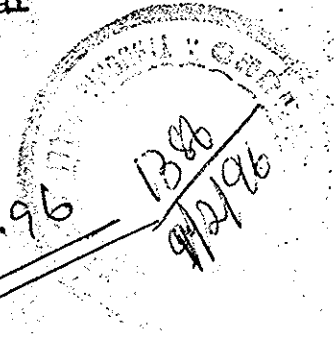
NO. 2202005

Dated. 3 Feb 1996

TO

The General Manager
Rifle Ft.
Ichapur - 743144

CISA-156 SA
DC No 23236 SA
Dt: 22.01.96



AMENDED DRAWING PARTICULARS: SUPPLY OF FUR PLASTIC FURNITURE
RIFLE 7.62mm 1A1

Reference

2. Certified/information copy/copies each of the following drawing particulars/as per the list attached is/are forwarded herewith to guide manufacture/inspection replacement:- Please destroy the old copies if any.

Drawing particulars.

Remarks.

Specn. CISA - 156(j)

copy

16/2

Mr. VRD
12/2/96

Kindly Acknowledge receipt.

(K.C. DAS)
J.S.O.
Asstt. Controller
for Controller Quality Assurance (S)

Encl o: One specn.
(one copy only)

Copy to:
i) The SRAO
SRAE (SA)
Ichapur - 743144
Encl o: - one specn.
(one copy only)

ii) The General Manager
ORD. FS, Tiruchirappalli
620016.
Encl o: - one specn.
(one copy only)

iii) The SRAO.
SRAE (Amal)
Tiruchirappalli - 620016.
Encl o: - one specn. (one copy only)

LAST D.C. 23236 - SA DATED 22.01.96

DEFINITION NO. CISA - 156 (i) (j)
APPROVED

PLASTIC FURNITURE

FOR
RIFLE 7.62mm 1A1

GENERAL

THIS SPECIFICATION IS THE PROPERTY OF THE DIRECTOR GENERAL OF QUALITY ASSURANCE AND MUST BE RETURNED TO THE CONTROLLER OF QUALITY ASSURANCE (SMALL ARMS), ICHAPUR, 24 PARGANAS (N) WEST BENGAL ON DEMAND.

THIS SPECIFICATION, or any pattern drawing or other information issued in connection therewith, SHOULD ONLY BE USED FOR specific enquiries, tenders or orders placed by a COMPETENT AUTHORITY under Ministry of Defence must not be used for any other purpose what so ever, WITHOUT THE SANCTION OF THE DIRECTOR GENERAL OF QUALITY ASSURANCE.

SCOPE

1. This specification governs manufacture inspection and test of the following stores for Rifle 7.62mm 1A1.

- (a) Butt Long Assembly (DS CAT NO. 1005 - 004057)
- (b) Butt Normal Assembly (DS CAT NO. 1005- 004025)
- (c) Butt Short Assembly (DS CAT NO. 1005- 004059)
- (d) Grip Pistol Assembly (DS CAT NO. 1005-004030)
- (e) Handle carrying Assembly (DS CAT NO. 1005-004051)
- (f) Guard Hand Left & Right Assembly (Plastic) No.2 (DS CAT NO. 1005 - 007723)

2. This Specification is a general guide for the contractor/ manufacturer for production of plastic furniture for Rifle 7.62mm 1A1. The dimensions and manufacturing details of the components are to be in conformity with the current issue of the relevant drawings.

3. Any question relating to this Specification, drawings or samples should be referred to the Controller of Quality Assurance (Small Arms), Ichapur, or to the Quality Assurance Officer duly authorized to act on his behalf.

Submitted against copy of the Specie
received from Specie at this date..... 02/2/96
by Controller Quality Assurance (SA
CISA (SA) Ichapur
to be destroyed
in accordance with the provisions of this Est. RFD

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CD

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Related Specifications (2)

Related Specifications

4. The following Specifications which form parts of the subject Specification, may be obtained as indicated against each.

(a) CISA/150 (LATEST ISSUE) Materials for Plastic furniture of Rifle 7.62mm 1A1 (to be obtained from Controller of Quality Assurance (Small Arms). P.O. Ichapur - Nawabganj, 24 parganas(N) West Bengal (743 144).

(b) Specification No. JSS:0465 -01-1988 (Latest issue) ~~specification~~ specification to govern protective finish (to be obtained from the Asst. Controller (Stock) (Army JSS Publication) Dept. of publication civil lines, Delhi - 110054.

(c) Specification No. JSS:8010 - 37 (Latest issue) for paint RFU finishing stoving Black, (DS CAT NO. 8010 -000473) ~~specification~~ **specification** for Small Arms (obtainable from the Asst. Controller (Stock) (Army JSS Publication) Dept. of publication civil lines; Delhi - 110054.

BS & IS Specifications referred to in the drawing are obtainable from Indian Standard Institution, Manak Bhavan, 9 Bahadur Shah Jafar Marg, New Delhi - 110002

Patterns

5. Any pattern or sample components issue to the contractor or manufacturer must be taken as a general guide to workmanship and finish and not as a guide to dimensions.

Definitions

6. The terms used in this Specification are defined as below:-

(a) Contractor or manufacturer means the Firm/Factory on whom order for supply of the stores has been placed by a competent authority under the Ministry of Defence, Govt. of India.

(b) Quality assurance Officer means the Controller, Controllerate of Quality Assurance (Small Arms), Ichapur or any other Officer duly authorised by him to act on his behalf.

(c) AHSP means the Authority Holding Sealed particulars i.e. the Controller, Controllerate of Quality Assurance (Small Arms) Ichapur (743 144)

Materials

7. General. The components are to be made from the materials specified on the drawings and the material must be in conformity with the relevant material Specifications. Should the contractor or manufacturer desire to employ any material differing from the specified one, he must obtain the prior sanction from the Controller of Quality Assurance (Small Arms), Ichapur on the deviation from stating the chemical and physical properties of the propose substitute material. Where no detail instructions are given, both material and workmanship must be of the highest standard and to the satisfaction of the Quality Assurance Officer. The Contractor or manufacturer should at once bring to the notice of the Quality Assurance Officer any defects which he may find in the material during or after machining/moulding and should not attempt rectification without the approval of the Quality Assurance Officer. Where Specifications are quoted, the latest issue are implied. The list of proprietary plastic materials approved for moulding of stores is shown in Specification No. CISA/150 (Latest Issue).

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8. Tests. The contractor/manufacturer shall notify the Quality Assurance Officer when he is in a position to commence work and shall inform him of all sub - contracts placed in connection with his contract as soon as these are placed, so that necessary arrangements for test of materials may be made by the Quality Assurance Officer. The Quality Assurance Officer on receipt of a notification from the contractor/manufacturer, may arrange to be represented at the work of the latter or at those of the ~~sub-contractors~~ sub - contractor. Before proceeding with the manufacturer, certificates of the chemical analysis and physical properties of the material must be forwarded to the Quality Assurance Officer and in all cases where tests are specified, the material must be submitted for testing ~~purpose~~ purposes. Technical data in respect of property, test, method & etc. for the materials are given in the Appendices to materials for Plastic furniture of Rifle 7.62mm 1A1 Specification No. CISA/150 (Latest issue)

9. Test Pieces. The contractor/manufacturer will provide free of charge such test pieces and finished parts as are required by the Quality Assurance Officer. The test pieces must be taken from a prolongation of the component moulding, which is truly representative of the component material or alternatively, such extra components will be provided in each batch for the tests which will involve ~~break~~ their destruction. The Quality Assurance Officer will notify the contractor/manufacturer of the number of test pieces initially required from each batch of material submitted.

10. Manufacture The contractor/manufacturer shall provide the Quality Assurance Officer with the components of plastic furniture will consist of the parts enumerated in the drawing schedule, as shown against each here under:-

<u>Nomenclature of store</u>	<u>DS CAT NO</u>	<u>Design Reference</u>
Butt Long Assembly (Plastic)	1005-004057	
Butt Normal Assembly (Plastic)	1005-004025	CISA/WPN 537
Butt Short Assembly (Plastic)	1005-004059	
Butt Long Sub-Assembly (Plastic)	1005 - 005449	
Butt Normal Sub-Assembly (Plastic)	1005-005450	CISA - 369
Butt Short Sub-Assembly (Plastic)	1005-005451	

Manufacture The contractor/manufacturer shall provide the Quality Assurance Officer with the components of plastic furniture will consist of the parts enumerated in the drawing schedule, as shown against each here under:-

(40)

Nomenclature of store
Butt Assembly(Contd)

DS Cat No

Design.Reference

Butt Long	1005-004058	CIA/WPN 538 sht.2
Butt Short	1005-004060	CIA/WPN 538 sht.1
Butt Normal	1005-004026	
Tube,Oil Bottle	1005-004027	CIA/WPN 539
Tie Plate(For Short Butt)	1005-005447	CIA/WPN 540 SHT.2
Tie Plate(For Normal Butt)	1005-004028	CIA/WPN 540 SHT.1
Tie Plate(For Long Butt)	1005-005711	CISA/445
Screw	5305-005009	CIA/WPN 541 SHT.1
Screw	5305-005010	CIA/WPN 541 SHT.2
Braket Sling	1005-001608	ARDE 657/32
Loop Sling Rear	1005-001660	ARDE 657/163
Plate Bracket Sling	1005-001664	ARDE 657/149
Plate Butt Assembly	1005 - 001665	ARDE 657/227
Plate Butt	1005- 001666	ARDE 657/231
Screw Spring Trap	5305 005002	CISA/85
Spring Trap	1005- 001668	ARDE 657/228
Trap Butt Plate	1005- 001669	CIA/WPN/224/1
Pin Trap	5315- 001774	CIA/WPN/224/2
Trap	1005- 001671	ARDE 657/230
<u>Grip pistol Assembly</u>		
Grip pistol Assembly (Plastic)	1005- 004030	CISA 291 SHT.3
Grip pistol Sub-Assy.	1005- 005452	CISA 291 SHT.9
Bushing pistol Grip Screw	1005- 001616	ARDE 657/268
Guard Trigger Assy.(Plastic)	1005- 005670	CISA 291 SHT.8
Cover Pistol Grip	1005- 001620	ARDE 657/278
Filler Piece	1005- 005671	CISA 291 SHT.7
Guard Trigger	1005- 001622	ARDE 657/275
Pin Hinge Guard Trigger	5315- 001768	ARDE 657/276
Plate pistol Grip Assy.	1005- 005712	ARDE 657/279
Bussing Trigger Spring	1005- 001625	ARDE 657/281
Plunger	- - - - -	- - - - -
Plate pistol Grip	1005- 005713	ARDE 657/280
Plunger Triggerr Spring	1005- 001627	ARDE 657/266
Screw Pistol Grip Cover	5305-0 005001	ARDE 657/272
Spring Trigger	5360 - 000739	ARDE 657/267
Grip Pistol	1005- 004031	CISA 291 SHT.1
Screw pistol Grip plate	5305- 005176	CISA 291 SHT.6

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<u>Nomenclature of Store</u>	<u>DS Cat No.</u>	<u>Design Reference</u>
<u>Handle Carrying Assembly.</u>		
Handle Carrying Assy. (Plastic)	1005 - 004051	CIA/WPN/499
Rod	1005 - 004052	CIA/WPN/500
Handle	1005 - 004053	CIA/WPN/501
Spring Washer	5310 - 003167	CIA/WPN/502
Washer	5310 - 003168	CIA/WPN/503
<u>Guard Hand Left & Right Assembly (Plastic) NO. 2</u>		
Guard Hand Left & Right Assy. (Plastic) NO. 2	1005 - 007723	CQA(SA) - 91
Guard Hand Left Sub - Assy. (Plastic) NO. 2	1005 - 007504	CISA - 911
Guard Hand Left	1005 - 007505	CISA - 911/1
Nut Guard Hand Screw	5310 - 003171	ARDE - 657/159
Guard Hand Right Sub - Assy. (Plastic) NO. 2	1005 - 007507	CISA - 912
Guard Hand Right	1005 - 007506	CISA - 912/1
Sleeve Hand Guard	1005 - 001593	ARDE - 657/158
Washer Lock (Tooth Type) External Tooth	1005 - 001718	CISA - 18
Screw Hand Guard	5305 - 005008	ARDE - 657/25

No component/part as mentioned above will be built up or repaired in any way contrary to the drawing or specification without prior sanction from the Quality Assurance Officer. Where the drawings or the specification permit a choice of alternative material for a particular component, the contractor/manufacturer is required to notify the Quality Assurance Officer in writing which of the permitted alternatives he proposes to utilise. If the choice of the alternative materials/designs is changed during the course of contract or order, the contractor/manufacturer should obtain prior sanction from the AHSP or the deviation/concession form submitted through the Quality Assurance Officer. Where ~~xxxxxx~~ concessions or deviations are required to facilitate manufacture, contractor or manufacturer should obtain prior sanction from the AHSP, on the deviation/concession form submitted through the Quality Assurance Officer. Such deviation/concession when granted will imply for a specific quantity against a specific order, and will not be valid for further quantities/orders unless permitted on fresh deviation/concession form.

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11. The contractor/manufacturer must ensure that the plastic furniture is built-up only with the accepted components, which bear the examiners view mark or the acceptance lable, in case the marking is not feasible.

Submission for Inspection

- 12.. All the burrs must be removed from the metal components and excess material or flashes from moulded components by the contractor/manufacturer before these are submitted for inspection.

13. All components submitted for inspection must bear IS catalogue Number stamped or embossed on them where practicable.

14. Inspection on the work in progress during manufacture, will be carried out by the Quality Assurance Officer or by his deputy. Proper facilities for inspection should be provided by the manufacturer or contractor.

15. Contractor/manufacturers are advised to submit sample delivery of components. Sub - assemblies, assemblies and subsequently complete assembled part to the Quality Assurance Officer for approval, before proceeding with delivery in bulk.

16. If found convenient to both the parties, the inspection may be carried out at the contractor's/manufacturer's premises, in which case suitable accommodation and allied facilities must be provided free of charge by the contractor/manufacturer.

17. If it is found that defects involved rejection of either component parts, sub-assemblies or assemblies, exist in 25% of the consignment, the whole consignment may be rejected without further examination.

18. The method of gauging and testing will be shown and explained to the contractor/manufacturer or his representative on notice being given to the Quality Assurance Officer.

General

19. Notwithstanding any clause or clauses appearing in this specification governing supply on material for the plastic furniture or ~~components~~ components there of, the plastic furniture or any component part shall be liable to rejection, should faults or defects, which in his opinion, render it unsuitable for use, be found by the Quality Assurance Officer. The contractor/manufacturer is solely responsible for correctness of manufacture, for rectification if carried out by him, and for compliance with the terms of this specification, drawings and contract governing supply, non - compliance thereof will ~~render~~ render the plastic furniture or part thereof liable to rejection at any stage of manufacture. Any dispute with regard to manufacture/inspection/rejection will be ~~referred~~ referred to the Controller Controllerate of Quality Assurance ~~(Small Arms)~~ (Small Arms), Ichapur whose decision in the matter will be final and binding on the contractor/manufacturer.

(7)

20. Marking. Marking on the plastic furniture will be carried out as specified in the drawing. The components should bear the manufacturer's code or symbol and catalogue number for identification.

21. Finish. All traces of surface flaws, blisterings, moulding mark, etc. on the component, and assemblies shall be removed and the finish carried out as specified in subsequent paragraph for each component or as specified in the relevant drawing.

22. The contractor/manufacturer must in all case inform the inspecting officer before commencing the finishing process, and will submit samples of the finish for approval. When the contractor/manufacturer desires to employ finishes other than the approved process, prior approval must be obtained from the inspecting officer to whom samples representing the finish should be forwarded.

INSPECTION

23. General. All components and assemblies/sub-assemblies shall be examined, gauged and tested as may be necessary to ensure that they conform to the dimensions, tests and conditions laid down on the drawings or instructed by the Quality Assurance Officer.

24. Butt Assembly

(a) Butt long(DS Cat.No.1005 - 004057), Butt Normal(DS Cat NO. 1005 - 004025) and Butt short(DS Cat.NO.1005 - 004059) will be checked as per drawing and details of latest issue.

(b) The Butts will be examined for surface finish, and must be free from scratches, dents and superficial foulings. External surface of Butt should be matt finish.

(c) The Butts shall be free from blemishes ^{and there} should be no cracks, distortion or deformity.

(d) All metal components/fittings should conform to the drawings, and should be assembled properly.

(e) Matt finish is required for the butt and the degree of roughness on the surface will be as per specimen certified by Controller, Controllerate of Quality Assurance(Small Arms) Ichapur.

25. Grip Pistol Assembly

(a) Grip Pistol Assembly will be checked as per drawing (DS Cat. NO.1005 - 004030) and its details of latest issue.

(b) The Grip pistol Assembly must be free from scratches, dents and superficial foulings.

(c) The Grip pistol shall be free from ^{cracks} distortion or ~~dist~~ after finish. External surface should be crocodile leather finish.

~~deformity~~

(8)

Grip pistol Assembly (Contd)

- (d) At the discretion of the Quality Assurance Officer a ~~percentage~~ percentage of the grips may be sectionised to assess/examine the condition of the embedded ~~part~~ portion of the inserts after moulding.
- (e) All metal components/fittings should conform to the drawing and should be assembled properly.

26. Handle Carrying Assembly

- (a) Handle Carrying Assembly will be checked as per drawing and its details of latest issue.
- (b) Handle Carrying Assembly should be free from cracks, distortion or deformity.
- (c) All metal components/fittings should conform to the drawing and should be assembled properly.

27. Guard Hand Left and Right Assy.(Plastic) NO.2

- (a) Guard Hand Left and Right Assy.(plastic) No.2 will be checked as per drawing and its details of latest issue.
- (b) The Guard Hand Left and Right Assy.(plastic) NO.2 should be free from cracks, distortion/deformation and surface blemish; and gas vents and holes should be finished smooth. External surface should be of matt finish.
- (c) There should not be any flow of the moulding compound over the portion of metal inserts which remain exposed.
- (d) All edges of the plastic portion of the Guard hand should be finished smooth, and the fabric threads should be properly embedded.
- (e) All metal components/fittings should conform to the drawing and should be assembled properly.

Final Inspection

28. After satisfactory completion of ^(thorough) ~~the~~ examination tests, each and every assembly/component parts of the plastic furniture will be examined, and any rectification, if found ~~xxxx~~ necessary must be carried out by the contractor/manufacturer, at his own expense.

29. It must be ensured that -

- (a) All the components of each assembly are correctly secured.
- (b) None of the comprising parts of the assembly/sub-assembly is damaged or distorted.

(9)

Preservation Identification and Packing

30. After final acceptance, all component parts/assemblies of the plastic furniture will be thoroughly cleaned and dried and preservative applied in a manner that the metallic parts are protected from rust during storage and transport.

31. Each plastic furniture being duly labelled with its DS Catalogue Number and designation, will be packed suitably in a card - board box or wooden case of suitable size and in quantity as convenient. The ~~pack~~ package should be strong enough to withstand the hazards of transit. Each sub - assembly should be ~~wr~~ wrapped in paper craft, before being packed in the card - board box/ wooden case.

ICHAPUR

Dated, 10 May '74

Sd/ - XXXXXXXXXXXXX

(A K GUPTA)

Lt. Col.

Offg. Controller of Inspection
(Small Arms)