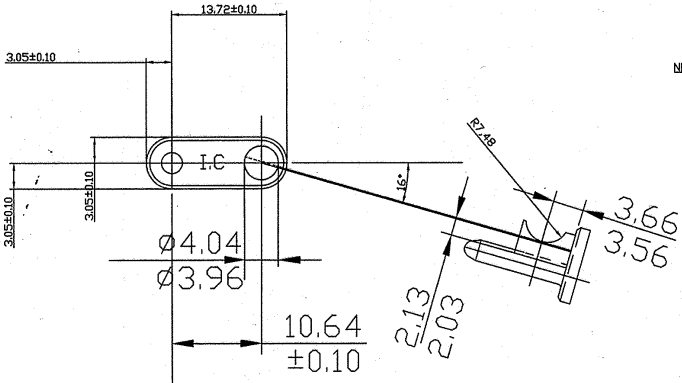
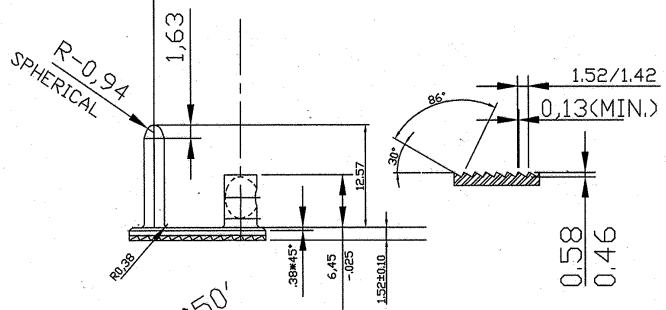
THIS IS A LESS STRESSED ITEM (GROUP-B)

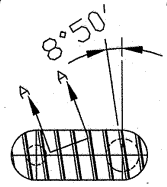
RFI.SK.-3568*3

THIS DRG. IS VETTED IN RESPECT OF MATERIAL BY ISA VIDE ISA LETTER NO. ISA/P/11 DT. 22-2-88

VETTED VIDE LETTER NO. 154/7/104 DT. 23.9.81.







PRECISION CAST.

SECTION A-A

ALL DIMNS. ARE IN MM.

NOTE:- WHERE TOLERANCES ARE NOT SHOWN,

1. DIMNS. IN WHOLE NUMBER ± .76mm,
2. DIMNS. WITH ONE DECIMAL PLACE, ± .25mm,
3. DIMNS.WITH TWO DECIMAL PLACES, ± .13mm,
4. FINISH DIMNS ARE GIVEN. SURFACES MUST BE SMOOTH FINISHED.
5. CASTING TO BE SUPPLIED IN NORMALISED CONDITION TO A HARDNESS OF 200-230 HB MAX.
6. MARK 'I.C' SUITABLY AS SHOWN.
7. THE CASTING SHOULD ATTAIN HARDNESS 450-520 HV AFTER HEAT TRETMENT (TO BE DONE BY R.F.I)
8. 100% IC IS TO BE SUBJECTED FOR RADIO GRAPHIC TEST. INITIALLY FOR ADVANGE SAMPLE OF 15 NOS. AND THEREAFTER AT LEAST 3% RADIOGRAPHIC TEST SHOULD BE FOLLOWED AS PER:- ASTM-192-84, LEVEL-1.

NOTE:- TOP EDGE OF 86° TO BE CENTRALLY LOCATED ON ℄ OF SHORT BOSS WITHIN ±0.05

FOR INSPECTION AND OTHER PRAMETERS RFI SK.-6274 TO BE REFERRED.

MATL. SPECN. 1) BS: 3146 Pt. 1 TYPE CLA-12 GRADE 'C'

2) DECARBURISATION SHOULD NOT EXCEED MORE THAN 2% OF THE BASIC SIZE (CLAUSE 1.9 OF BS: 3146 Pt.1)

DATE	AUTHORITY	DESCRIPTION	ZONE	SIGNATURE
26-11-13	D.C No. 02/02/13	NOTE (5) AMENDED.		
01/07/04	DC.NO. 02/023/04 ADVISED BY JT. GM/B AS PER FIRM LETTER UD/RFI/DS/7624 DT. 14-06-04 AND JWM/PS MEMO.NO PS/25 DT.19-6-04	TOLERANCE GIVEN AS PER I.C SPECIFICATION. FOR DIMNS. 1.57/1.47,3.07/3.02,10.67/10.62, 13.74/13.69 READ 1.52±0.10,3.05±0.10,10.64±0.10,13.72±0.10		
	DA.NO. 118/91	NOTE (8) ADDED		
	DA.NO. 106/86	MATL.SPECN.AMENDED & DECARBURISATION NOTE ADDED VIDE CI (MET.) LETTER NO. MQA-1/111/02 DT.18-4-86		
30-7-84	DA.NO 152/84	NOTE (7) ADDED		

MATERIAL:- STATED ABOVE		ALL DIMENTION ARE IN MM, IMPORTANT DIMENTIONS MARKED THUS ⊕ INFORMATION MARKED THUS † TO BE MARKED ON.		
TITEL OF TOOL	• OPERATION	2004	NAME	DATE
		DGN.		
		DRN.	A.K.G	29-6-04
		CKD.		
ORDNANCE FACTORY BOARD RIFLE FACTORY ISHAPORE	SCALE:- NOT TO SCALE	APPD.		
PISTOL AUTO 9 MM. 1A PIN ARM (I.C) (DS.CAT.NO.-1005-003203)		DRG.NO. R.F.I SK-3568*3		

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