



प्रमाणित प्रती / CERTIFIED COPY OF
 ड्राइंग / नक्शा / गजत / निरखल H 02 / M/PN
 DRG/LAYOUT/GAUGE SCHEDULE
 दिनांक / AT THIS DATE. 01.04.17
 श्री श्री श्री / CDD
 गणेश, केशरी, श्याम
 R.F.I. FACTORY, ISHAPORE

NOTES:-

- 1 ALL DIMS. ARE IN MM.
- 2 ENLARGED DIMS. TO BE AS PER STD. 1.5: 11195-1983 CLASS-1 OF INV. CASTING.
- 3 CASTING SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT TEARS, COLD SHOTS ETC. AND SURFACE FINISH MUST BE SMOOTH.
- 4 VISUAL EXAMINATION SHOULD CONFORM TO CLAUSE 6.1 AND 6.2 OF SPECN. 1.5:10343-1983
- 5 DEBURRING SHOULD NOT BE MORE THAN 2% OF THE THICKNESS OF THE CASTING.
- 6 TEST SAMPLES SHOULD BE CAST FROM THE SAME MELT USED FOR MANUFACTURING OF THE CASTING AND SHOULD BE MADE TO SATISFY THE SPECN. 1.5: 10343-1983.
- 7 TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 1.10 SEC-1 OF SPECN. R.S.3146 1974
- 8 SHARP EDGES AND BURRS IF ANY ARE TO BE REMOVED.
- 9 MAGNETIC TEST FOR CRACK DETECTION TO BE CARRIED OUT IN SAMPLES AS PER INSPECTION LEVEL AT A.O.L. Q.85 AS PER 1.5:2500 Pt.1,1992
- 10 MANUFACTURERS SAMPLE WITH 3 mm. SIZE TO BE STAMPED AT X. MARK SHOWN IN CASTING.
- 11 RADIOGRAPHIC ACCEPTANCE STANDARD SHALL BE AS PER ASTM E-182 GAS HOLES & FOREIGN MAT. LEVEL-5 SHRINKAGE LEVEL -3 CRACKS, COLD SHOTS, HOT TEARS ETC. NOT ACCEPTABLE.
- 12 RADIOGRAPHIC TEST TO BE CARRIED OUT AS FOLLOWS:-
 (i) 2% FROM SECOND LOT FROM EACH SUPPLIER THE LOT SHOULD NOT BE LESS THAN 10 NOS.
 (ii) 1% FROM REPEATITIVE/BULK SUPPLY UNTIL THE PRODUCT IS ESTABLISHED BY VENDOR.
- 13 TO 15 NOS. SAMPLE CASTING DUTY PASSED BY INSPECTOR IN RADIOGRAPHY TEST, MATL. DIMS. ETC. TO BE SENT TO THIS FACTORY FOR MACHINING & FITMENT TRIAL BEFORE BULK SUPPLY.
- 14 ALL DRAWING DIMENSIONS TO BE CHECKED AFTER HEAT TREATMENT AS PER RFI GAUGE SCHEDULE.
- 15 THE SUPPLIER WILL MANUFACTURE 02 SETS OF INSPECTION GAUGE AND GET IT VERIFIED BY RFI.
- 16 MACHINABILITY TO BE TESTED BY DRILLING Ø2.82 HOLE, THROUGH ON ATLEAST 02 SAMPLES.

MATERIAL:- BS:3146 PT 1 1974 TYPE CL-A-12 GRADE C		ALL DIMENSIONS ARE IN MILLI METER IMPORTANT DIMENSIONS MARKED THIS ⬥ INFORMATION MARKED THIS T TO BE MARKED ON	
TITLE OF COMP.	OPERATION	SCALE	APD.
INVESTMENT CASTING DRG. OF BRACKET BACK SIGHT		1:1	
INDIAN ORDNANCE FACTORIES RIFLE FACTORY SIMPUR			
7.62 mm. ASSAULT RIFLE (GHATAK) BRACKET BACK SIGHT (AR/02/3-RF1)		DRG. NO.	RFI SK NO. 983H
		SHEET	OF