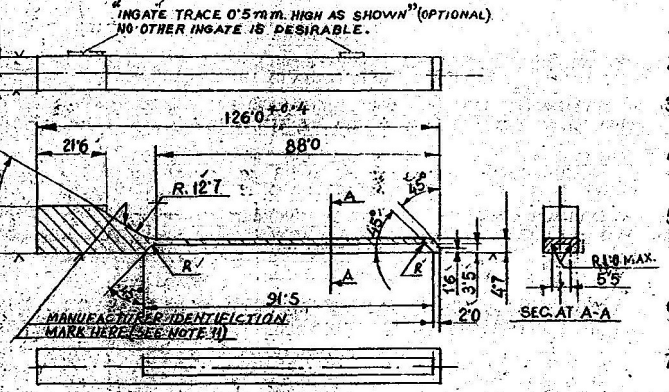
GROUP-C



1. DIMNS. ARE IN mm.
2. UNTOLERANCED DIMNS. TO BE AS PER STD. IS: 11166 - 1984 CLASS 1 OF INV. CASTING.
3. CASTINGS SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT TEARS, COLD SHUTS ETC. AND SURFACE FINISH MUST BE SMOOTH.
4. VISUAL EXAMINATION SHOULD CONFORM TO CLAUSE 8.1 AND 8.2 OF SPECN. IS: 10343-1982 AND AQL 2.5 OF IS: 2500 Pt. 1, 1992 INSPECTION LEVEL III
5. CASTINGS ARE TO BE SUPPLIED IN ANNEALED CONDITION ALONG WITH THE TEST SAMPLES TO BE TESTED FOR HARDNESS AT ANNEALED CONDITION AND ALSO AFTER FINAL HEAT TREATMENT. (SEE MATL.)
6. DECURBURISATION SHOULD NOT BE MORE THAN 2% OF THE THICKNESS OF THE CASTING.
7. TEST SAMPLES SHOULD BE CAST FROM THE SAME MELT USED FOR MANUFACTURING OF THE CASTING AND SHOULD BE MADE TO SATISFY THE SPECN. IS: 10343-1989
8. TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 1.1 SEC. 10 OF SPECN. BS 3146 Pt. 1: 1974, Gr. C.
9. SHARP EDGES & BURRS IF ANY ARE TO BE REMOVED.
10. MAGNETIC TEST FOR CRACK DETECTION TO BE CARRIED OUT IN SAMPLES AS PER INSPECTION LEVEL IV AT AQL 0.65 AS PER IS: 2500 Pt. 1 1992
11. ALL CASTINGS AND REPRESENTATIVE TEST SAMPLES SHALL BE LEGIBLY MARKED WITH MANUFACTURERS IDENTIFICATION MARK WITH 3mm SIZE.
12. RADIOGRAPHIC ACCEPTANCE STANDARD SHALL BE AS PER ASTM-E-192, GAS HOLES LEVEL-5, FOREIGN MATL. LEVEL-5 AND SHRINKAGE (ALL TYPE) LEVEL-3

RADIOGRAPHIC TEST TO BE CARRIED OUT AS FOLLOWS:-

i) 100% FROM SAMPLE LOT FROM EACH SUPPLIER THE LOT SHOULD NOT BE LESS THAN 10 NOS.
ii) 2% FROM SECOND LOT FROM EACH SUPPLIER THE LOT SHOULD NOT BE LESS THAN 100 NOS.
iii) 1% FROM REPEATATIVE BULK SUPPLY UNTILL THE PRODUCT IS ESTABLISHED BY VENDOR.

13. 10 TO 15 Nos. SAMPLE CASTING DULY PASSED BY INSPECTOR IN RADIOGRAPH TEST, MATL. DIMNS. ETC. TO BE SENT TO THIS FACTORY FOR MACHINING & FITMENT TRIAL BEFORE BULK SUPPLY.

SL. No.	DESCRIPTION	AUTHORITY	SIGN.	ZONE	DC (RFI) NO.
9	FOR: MATL. IS: 10343-89 Gd. 1B READ: MATL. BS 3146 Pt. I 1974 TYPE CLA. 8 DRG. NO. ADV. TO RFI. SK. 5709 *14	As per CQA(SA) letter No. S/INSAS/R/DRG. DT. 26.3.2018			01/003/18 Dt. 03-04-2018
8	FOR DIM. 126.0 READ 126 ± 0.4 DRG. NO ADVANCED TO RFI SK-5709 *13	AS PER JNM/M MEMO NO. MTM/SC/09-10/02 DATED 02/04/09	JNM/CAO	E-7	01/022/09 Dt. 08-04-09
7	PLACE OF MANUFACTURER IDENTIFICATION MARK CHANGED FROM ZONE E-5, 7 TO E-7, 8 DRG. ADV. TO RFI. SK. 5709 *12	AS SUGGESTED BY H. GM/ASSY.	JNM/CAO	DE-7, 8	05.03.02
6	R 1'0 MAX. ADDED. DRG. NO. ADV. TO RFI. SK. 5709 *11	COMPT. DRG AMENDED VIDE 25232-SA. DT. 03.9.2018		DE-5, 6	02-09-02
5	IN NOTE NO-5 "SEE MATL" ADDED. "HEAT TREATMENT:- ANNEALED HARDNESS:- 200-230 HB MICROSTRUCTURE:- COARSE PEARLITE" ADDED. DRG. NO. ADVANCED TO RFI. SK. 5709 *10	(MTM/SC/M) NOTE SHEET NO. 8 (MATL. NUMBER TENDER) DR. RETRACTING (A&S) 1313 L.P. DT. 21.0.88 & REMARKS OF 7MM/RAD. REGARDING HARDNESS OF IC IN ANNEALED CONDITION.	DGM/RKD	DE-4, 5 B-5	Dt. 10.11.2K.
4	MATL. "IS: 10343-89 GRADE 1.B" WAS "BS: 3146 PT. 1: 1974 TYPE CLA: 8" DRG. NO. ADV. TO RFI. SK. 5709 *9	CQA(MET) LETTER NO. MQA-1/TS/A. DT. 13-7-99		B-4, 5	
3	IC. MARK DELETED. NOTE NO. 11 REVISED. DRG. NO. ADV. TO RFI. SK. 5709 *8	LIAISON MEETING MINTS NO. RFI/K(A/S) SQAE/02 DT. 10.2.97		E-7 E.1-3	01/067/97 dt. 8.3.97
2	NOTE No. 4 FOR VISUAL EXAM CHANGED. DRG. No. ADVANCED TO R.F.I. SK. No. 5709 *7	CQA MET. LETTER No. MQA-1/INVEST DATE:- 5-7-95		E-4, 5	
1	FRESH NEGATIVE PREPARED AND NOTES REVISED. DRG. No. ADVANCED TO R.F.I. SK. No. 5709 *6	CQA(MET)'S LETTER NO. MQA-1/QA-I/12 DT. 5.5.94			

Ref. to J.C.- H.GM/Assy. Suggested in Unit Decision vide letter no. DC/RFI/DS dt. 21/02/02 Wt. 609mm/Ref. Jt. GM/PL Letter No. 56/PEP/6-56 dt. 26-11-2014

HOS/MPM

प्रमाणित प्रति / CERTIFIED COPY OF
ड्राइंग / लेआउट / गेज शिडयूल
DRG/LAYOUT/GAUGE SCHEDULE
सेवाक / AT THIS DATE 16-4-18
सी डी ओ.
राइफल फ ... PORE
RIFLE F...

MATL.:- BS: 3146 Pt I: 1974 TYPE CLA-8
HEAT TREATMENT:- ANNEALED.
HARDNESS:- 200-230 HB.
MICROSTRUCTURE:- COARSE PEARLITE.
Material shall be tested as per Appendix-E of CQA(SA) - 2(e) specn.

VETTED FOR MATL. ONLY	ONLY MATL. VETTED BY
12/4/18 [RK CHAURASIA, AE(QA)] I/c P&TC Section SQAE(SA), ISHAPUR	D/M - SS 21/5/01; C/M - NOT 21/5/01; SQAE(SA) ISHAPUR

INVESTMENT CASTING DRAWING

ORDNANCE FACTORY BOARD
RIFLE FACTORY,
ISHAPORE.

	NAME	DATE
DRN.		
CHD.		25.9.95
APPVD.	(JWMLC)	29.9.95

SCALE-1:1

RIFLE 5.56mm.
SLIDE (RETRACTING)
ARDE SK. 3143/30
D.S. CAT. No. 1005 - 007786

DRG. No.
R.F.I. SK. No. 5709 *14

SHEET - 1 OF - 1