

INDIGENOUS MATERIAL

- ⑤ ~~IS: 10343 Gr. 4D, OR BS: 3146 Pt.1-74, TYPE CLA-5 GRADE 'B'~~
~~IS: 10343 Gr. 4D, CASTING TO BE HEAT-TREATED TO ACHIEVE 41.5-51.5 HRC~~
~~SEPARATELY CAST TEST BARS SHALL MEET THE SPECIFIED MECH. PROPERTIES~~
~~INCLUDING IZOD IMPACT VALUE 14J. MIN.~~
~~OR~~
~~BS: 3146: Pt.1: 1974, TYPE CLA-5 GRADE 'B'~~

RADIOGRAPHIC TEST

- (a) RADIOGRAPHIC 'ACCEPTANCE' STANDARD OF THE CASTING SHOULD BE AS PER ASTM-E-192-Gr. 'A' ③
- (b) 100% OF THE ADVANCE SAMPLE (NOT LESS THAN 5) WILL BE SUBJECTED TO RADIOGRAPHIC TEST.
- (c) RADIOGRAPHIC TEST OF ADVANCE SAMPLE WILL BE CARRIED OUT BY CQA(MET) ICHAPUR.

OR

③ THE AREA QUALITY ASSURANCE OFFICER CONCERNED WOULD GET THE RADIOGRAPHIC TEST DONE IN HIS PRESENCE AND FORWARD THE PLATES TO CQA (MET) ICHAPUR FOR SENTENCE AND APPROVAL OF THE MOULD.

(d) BULK PRODUCTION WOULD COMMENCE ONLY AFTER MOULD AND MATERIAL HAS BEEN APPROVED BY CQA(MET) ICHAPUR.

(e) 5% OF THE CASTING SELECTED AT RANDOM FROM ^{THE} BULK WOULD BE SUBJECTED TO RADIOGRAPHIC TEST. THIS MAY BE DONE UNDER THE ARRANGEMENT OF THE AREA QUALITY ASSURANCE OFFICER AND SENTENCE MAY BE AWARDED BY HIM BASED ON THE STANDARD OF THE ADVANCE SAMPLES CLEARED BY CQA(MET) ICHAPUR.

REF. :- CONTROLLERATE OF QUALITY ASSU(W) JABALPUR LETTER NO. 50431/CQAIW/QA-11 DATED 14 MARCH 95.

⑤ CONTROLLERATE OF QUALITY ASSU(W) ICHAPUR
LETTER NO. MQA-3/LIN/3/W DL. 03 MAY 1995
INDIGENOUS MATERIAL: IS 10343 Gr. 4E WITH C% 0.45 - 0.50 AND MECHA-
NICAL PROPERTIES SPECIFIED IN THE SPECIFICATION FOR THE GRADE.
AUTHORITY: CQA(METALS) ICHAPUR LY. NO. MQA-3/ITS/B/I Dt. 6/11-6-97

⑥ MATERIAL:
IS: 10343-1999 Grade 19Q, WITH C% 0.45 - 0.5 ⑦

H ⑧	DA NO. 004/20 Dt. 30.06.20 Gr. A. Added	
G ⑦	DA No. 001/16. DC NO. 19446W 14.9.95	1.1.1b
F ⑥	DA NO. 007/14 Dt. 18.09.14	18/9/2011
E ⑤	DA NO. 052/97 Dt. 11-8-97	11/8/97
UPDATED.	DA NO. 022/97 Dt. 23-3-97	23/3/97
D ④	DA NO. 70/05 Dt. 21.8.95	Sadh
C ③	DA. 020/95 Dt. 11-4-95	Sadh 11-4-95
AMENDMENTS	DESCRIPTIONS	SIG. & DATE

CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE.....

17.11.2020
 Design & Drawing Office
 Ordnance Factory,
 Tiruchirappalli-620016

UN CONTROLLED COPY

SHEETS 2/2	APPROVED	<i>[Signature]</i> 12.4.95	ORDNANCE FACTORY	COMPONENT NO. 2442-05-089
<i>Sadh</i> 11-4-95 DRAWN	CHECKED	<i>[Signature]</i> 12.4.95 1/C.30mm D&DO	TIRUCHIRAPALLI	CATCH BODY DRG. NO. 64C 5089 250 H 3