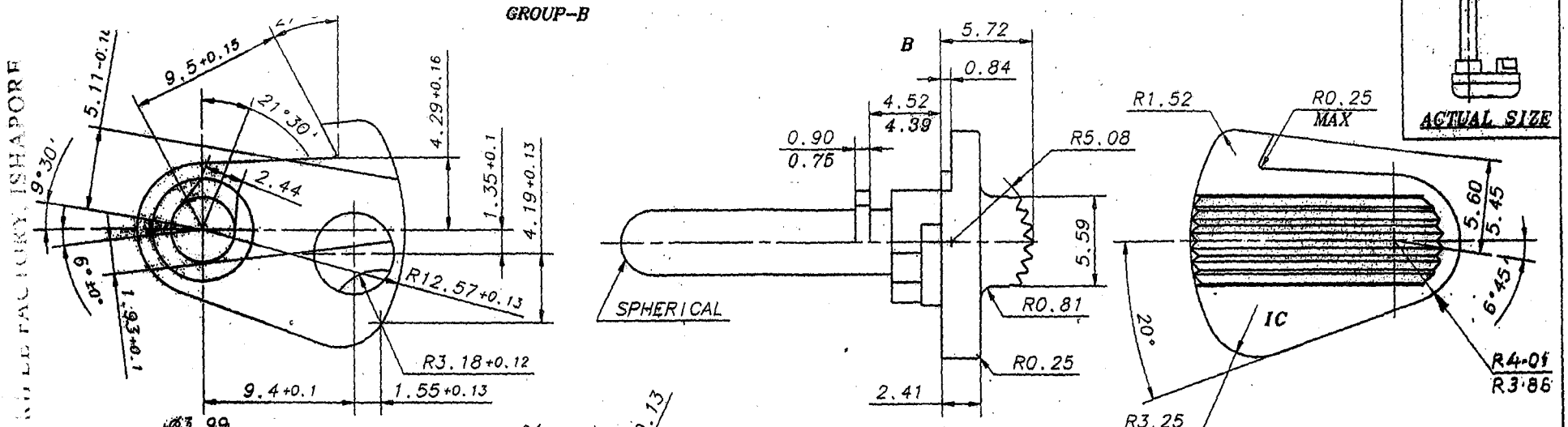
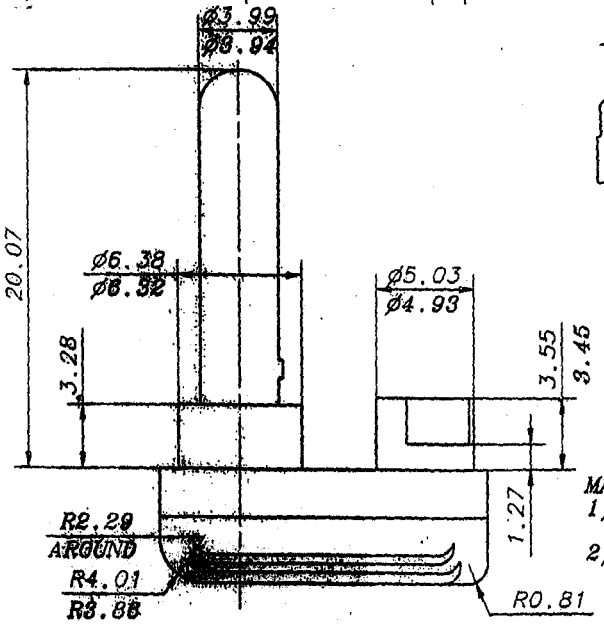
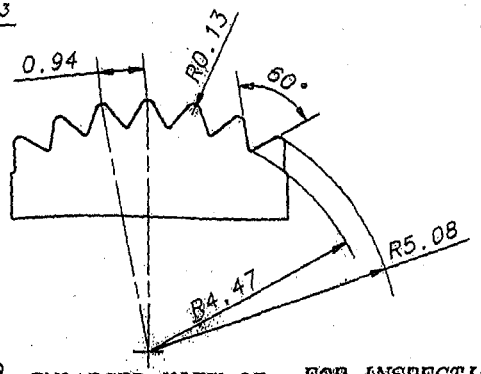
19-07-20

JWM/MPM

GROUP-B







ENLARGED VIEW OF SERRATION

FOR INSPECTION AND OTHER PARAMETERS RFI.SK.-6274, DATED-14.05.96 TO BE FOLLOWED.

THIS IS A LESS STRESSED ITEM(GROUP-B)

NOTE:-
1) DIMNS.WITH TOLERANCE TO BE MAINTAINED.
2) TOLERANCES ON UNTOLERATED DIMENSIONS±0.13.
3) FINISH DIMENSIONS ARE GIVEN SURFACES MUST BE SMOOTH FINISH.
4) CASTING TO BE SUPPLIED IN ANNEALED CONDITION TO A HARDNESS OF 200-230 HB MAX.
5) THE CASTING SHOULD ATTAIN HARDNESS 450-520 H.V. AFTER HEAT TREATMENT (SAMPLES TO BE SUBMITTED)
6) MARK 'IC' SUITABLY AS SHOWN.
7) 100% INVESTMENT CASTING IS TO BE SUBJECTED FOR RADIOGRAPHIC TEST INITIALLY FOR ADVANCE SAMPLES OF 15 NOS. AND THERE AFTER AT LEAST 3% RADIOGRAPHIC TEST SHOULD BE FOLLOWED AS PER :-ASTM-E-192-84 LEVEL-1.

MATERIAL SPECIFICATION:-
1) BS: 3146 PART 1:1974 TYPE CLA-12 GRADE 'C'
2) DECARBURISATION SHOULD NOT EXCEED MORE THAN 2% OF THE BASIC SIZE (CLAUSE 1.9 OF BS:3146 PT.1:1974).

PRECISION CAST

† RFI.SK.NO.3571 #3

MATERIAL	ALL DIAMENSIONS ARE IN MILLI METRE IMPORTANT DIAMENSIONS MARKED THUS ● INFORMATION MARKED THUS † TO BE MARKED ON

TITLE OF	OPERATION	2005	NAME	DATE
CATCH SAFETY (I.C)		RE.DRN.	R.CHAKRABORTY	6-9-2005
ORDNANCE FACTORY BOARD RIFLE FACTORY ISHAPORE	SCALE 2:1 (10:1)	CKD.	[signature]	7/9/05
		APPD.	[signature]	

PISTOL AUTO 9mm1A
CATCH SAFETY
CISA/333/12/4,DS.CAT.-1005-003152

DRG.NO. RFI.SK.NO. 3571 #3
SHEET- OF-

NOTE (IX) ADDED	08/98
NOTE (VII) [illegible] ISHAPORE [illegible] DT.23-12-[illegible]	118/91
DIM.11.[illegible] DIM.3.66/[illegible] VIEWS [illegible]	216/88
MATL.SPEC[illegible] DECARBURISA[illegible] ADDED [illegible] LETTER NO[illegible]	106/86
DA.NO.[illegible] NOTE [illegible]	166/85
DESCRIPTION	D.G.NO.

TITLE, NOTE AMENDED & DRG.NO. ADVANCED TO RFI.SK 3571 #3 — 02/01/10 Dt. 7/4/10

NOTE-(IX)
CASTINGS SHALL BE EXAMINED FOR FREEDOM OF SURFACE DEFECT BY:- MAGNETIC PARTICLE INSPECTION.
THIS HAS REFERENCE TO:-
CQA(MET)NO.MQA-1/KPL/10/S,20.2.92.
CQA(SA)NO. 1/PC/4/5, DT.23.3.92.

VETTED VIDE LETTER NO.ISA/T/104 DT. 23.9.81. THIS DRG IS VETTED IN RESPECT OF MATERIAL BY ISA VIDE ISA LETTER NO. ISA/P/11,DT.22-2-88

H29