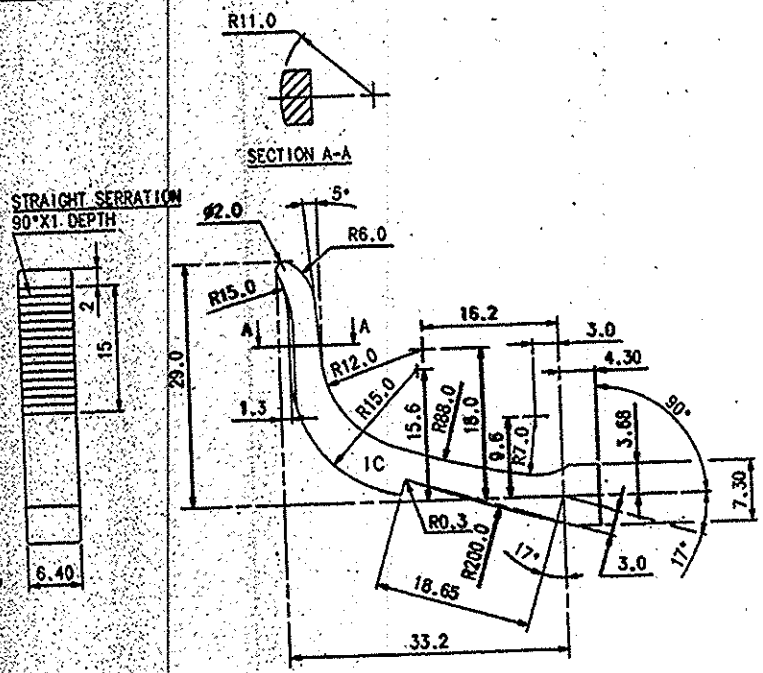

MATL:- BS:3146 PT-1 1974 CLA-12 GRADE-B (SEE NOTE-7)

AUTHORITY FOR MATL:-VIDE CDA(MET) LETTER NO. MOA-1/02/TS.DT.15-12-93

DATE	DETAIL OF AMENDMENTS	REASON	SIGNATURE
08-03-07	SERRATION ADDED. ø 0.5 ALTERED TO ø 2.0 AND NEW DRAWING PREPARED. DRG. ADVANCED TO RFI SK.NO:5743*5	CUSTOMER'S FEED BACK REPORT	JT.GM/ASSY
30-06-03	IN NOTE NO.7, "WITH 190-230 HV", ADDED. DRG. ADVANCED TO RFI SK.NO:5743*4. AUTHY:- LETTER NO.QC(IM)/IC/QUALITY REVIEW DT-04-03-03		JT.GM/ASSY
29-02-96	NOTES FOR CONDITION REVISED. DRG. ADVANCED TO RFI SK.NO:5743*3	UPDATING OF NOTES	Sd/- AMM/QC
14-12-94	REDESIGNED & DRG. ADVANCED TO RFI SK.NO:5743*2	SIMPLICATION & ECONOMICAL	Sd/- MM/TS

NOTES:

1. ALL DIMENSIONS ARE IN mm.
2. UNCONTROLLED DIMENSIONS TO BE AS PER STD. IS:11156-1984 CLASS-1.
3. 10 TO 15 NOS. SAMPLE CASTINGS DULY PASSED BY INSPECTOR IN RADIOGRAPHIC TEST, MATL, DIMS, ETC. TO BE SENT AGAINST EACH S.O. TO THIS FACTORY FOR MACHINING AND FITMENT TRIAL BEFORE BULK SUPPLY.
4. MAGNETIC TEST TO BE CARRIED OUT FOR CRACK DETECTION IN SAMPLES AS PER INSPECTION LEVEL-III AT AQL 0.65 AS PER IS:2500 PT-1 1965.
5. CASTINGS SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT TEARS, COLD SHUTS, BLOW HOLES ETC. & SURFACE FINISH SHOULD BE SMOOTH. SHARP EDGES & BURRS IF ANY ARE TO BE REMOVED.
6. VISUAL EXAMINATION SHOULD CONFORM TO CLAUSE 8.1 & 8.2 OF SPECN. IS:10343-1982 & AQL 1.5 OF IS:2500 PT-1 INSPECTION LEVEL IV.
7. CASTINGS ARE TO SUPPLIED IN ANNEALED CONDITION WITH 190-230 HV ALONG WITH THE TEST SAMPLES, TO BE TESTED FOR HARDNESS AT ANNEALED CONDITION & ALSO AFTER HEAT TREATMENT. I.C. TO BE STAMPED WITH 3mm SIZE AS SHOWN.
8. DECARBURISATION SHOULD NOT BE MORE THAN 2% OF THE THICKNESS OF THE CASTING.
9. ALL CASTINGS & REPRESENTATIVE TEST SAMPLES SHALL BE LEGIBLY MARKED WITH MANUFACTURER'S IDENTIFICATION MARK OF 3mm SIZE.
10. TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 1:10 METHOD (1) OF BS:3146 PT-1-1974. TEST SAMPLES SHOULD BE CAST FROM THE SAME MELT USED FOR MANUFACTURING OF CASTING AND SHOULD BE MADE TO SATISFY THE SPECN. IS:10343-1982. RESULT OF TEST SHALL BE FURNISHED ALONG WITH I-NOTE.
11. RADIOGRAPHIC ACCEPTANCE STANDARD SHALL BE AS PER ASTM-E-192.
    (a) CASTINGS SHOULD BE SUBJECTED TO RADIOGRAPHY BY USING X-RAYS, GAMMA RAYS SHALL NOT BE PERMITTED AT ALL UP TO THE THICKNESS RANGE 0.25mm.
    (b) UNLESS OTHERWISE STATED THE RADIOGRAPHIC ACCEPTANCE STD. OF THE CASTING SHOULD BE AS FOLLOWS:- GAS HOLES & FOREIGN MATERIAL- LEVEL-3. SHRINKAGE ALL TYPE-2.
    (c) 100% OF THE ADVANCED SAMPLES SHALL BE SUBJECTED TO RADIOGRAPHIC TEST.
    (d) FOR BULK COMPONENTS 5% EACH OF CAST SHOULD BE SUBJECTED TO RADIOGRAPHIC TEST UNTILL THE PRODUCTION IS ESTABLISHED BY VENDOR.

TITLE OF	OPERATION	2007	NAME	DATE
		DGN	SEKHAR	08-03
		DRN		
ORDNANCE FACTORY BOARD RIFLE FACTORY ISHAPORE	SCALE:- 2:1	CKD		
		APPD		

INVESTMENT CASTING FOR CATCH MAGAZINE (.315" SPORTING RIFLE)

DRG.NO: RFI.SK:5743*5

SHEET NO:- 1 NO OF:- 1