

GROUP - A

NOTE :-

- 1 DIMENSIONS ARE IN mm
- 2 UNTOLERANCED DIMS. TO BE AS PER STD. IS: 11166- 1982.
- 3 CLASS-I OF INV. CASTING
- 4 CASTING SHOULD BE FREE FROM DEFECTS LIKE CRACKS ,
HOT TEARS, COLD SHUTS ETC. AND SURFACE FINISH MUST
BE SMOOTH FINISHED
- 5 CASTING TO BE SUPPLIED IN ANNEALED CONDITION
WITH 100-230 HV ALONG WITH TEST SAMPLES TO BE TESTED
FOR HARDNESS AT ANNEALED CONDITION/AND ALSO AFTER
FINAL HEAT -TREATMENT WITH 300-350HV BELOW LINE X-X
- 6 DE-CORROSION SHOULD NOT BE MORE THAN 2% OF
THE THICKNESS
- 7 TEST PIECES SHOULD BE PREPARED IN ACCORDANCE WITH
SPECN IS10343 , 1982 . TEST PIECES SHOULD BE CAST
FROM SAME FURNACE MELT USED FOR CASTINGS
- 8 ALL CASTINGS & REPRESENTATIVE TEST SAMPLE
SHALL BE LEGIBLY MARKED WITH MANUFACTURER S
IDENTIFICATION SYMBOL (3 mm SIZE)
- 9 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. II IN 1945
- 10 TEST PIECES SHOULD CONFORM TO MECH. PROPERTIES
AS LAID DOWN IN SEC. 2 OF BS3146 P.11,1974 FOR CLAZ II
RADIOGRAPHIC ACCEPTANCE STANDARD AS PER
SPECN ASTM E-192 . GAS HOLES &
SHRINKAGE LEVEL (ALL TYPES) -3, CRACKS, COLD SHUTS,
HOT TEARS ETC. NOT ACCEPTABLE.
- 11 CASTINGS SHOULD BE TESTED WITH X RAYS, GAMA RAYS
WILL NOT BE PERMITTED FOR RADIOGRAPHIC TEST UP TO 25 mm
THICKNESS
- 12 100% OF THE ADVANCE SAMPLE SHALL BE SUBJECTED TO
RADIOGRAPHIC TEST
- 13 FOR BULK COMPONENTS, 5% OF EACH CAST / HEAT SHOULD
BE SUBJECTED TO RADIOGRAPHIC TEST
- 14 SHARP EDGES & BURRS IF ANY ARE TO BE REMOVED
- 15 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
- 16 VISUAL EXAMINATION - SHOULD CONFORM TO CLAUSE 8.1.8 & 8.1.9
OF SPECN IS: 10343 AND A.Q.L 15 OF IS: 2500 PT.1
- 17 INSPECTION LEVEL IV
- 18 INGATE TRACE TO BE REMOVED FROM CASTING TO
CONFORM DRAWING GEOMETRY

MATL :-

BS 3146 Pt.1:1974. TYPE-CLA- 12 GRADE -C (SEE NOTE-4)

RESIDUALS Material shall be tested as per Appendix D of (CALFAGARD) Specn.

COMPOSITION OF MATERIAL	C%	Si	Mn	Ni%	Cr	Mo	Cu%	S	P
% MIN.	0.55	0.3	0.5	-	0.8	0.2	-	-	-
% MAX.	0.65	0.8	1.0	0.4	1.5	0.4	0.3	0.035	0.035

TITLE OF TOOL		2403	NAME	DATE
INVESTMENT	CASTING DRAWING	DON	AKHOSH	
		CHRO.	<i>[Signature]</i>	
ORDNANCE FACTORY BOARD RIFLE FACTORY BIMAPORE	SCALE  1 : 1	APPD.		
		DRGNO-		
	RIFLE 5.56 mm			
	PETAINER SPRING RECOIL (MODIFIED) AS PER I/G/ENE NEW DELHI			
			RFI SK- 8064 - S	
		SHEET	OF	

VETTED FOR MATERIAL

VETTED FOR MATL. ONLY

D/M - 6/5/07
1/C QA & S - N/A
10/13/07

8/51
JTO
FOR SGAO
SGAE (5A)

NETTED FOR MATH. ONLY

12/11/18

AE(D/A)
F/c P + tc section

Date :- 12 Apr 2018.

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रिजल्ट / AT THIS DATE. 04.05.2019
सर्वोच्च निदेशक, इलाहाबाद
RIELE FACTORY, ISHAPORE

Wt. 45 gms. AS per JHGM/PL letter NO. 56/P&P/5-56 DA 26-11-2011