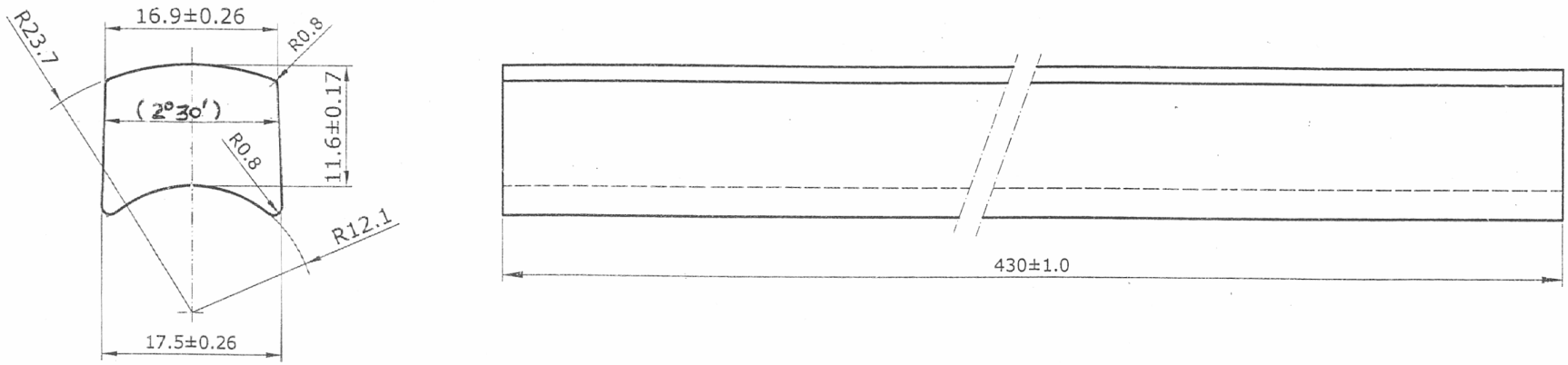
FORM No. OFC-110

DRG.No. SK-7894/B	FORG./ PATTN. ———	GEN. TOL.:- IS: 2102 (MED)	CONDITION :- ------	HARDNESS :- ------	FINISH :- ▽



1. **MATERAIAL SPECN.:-** JSS 4710-01:2007 (REVISION No.4) GRADE III (CUPRO-NICKEL)

% Cu	% Sn	% Pb	% Fe	% Ni	% As	% Sb	% Bi	% Mn	% O_2
95.0/96.0	0.1 Max	0.05 Max	0.1 Max	4.0/5.0	0.1 Max	0.01 Max	0.0025 Max	0.25 Max	0.08 Max

2. **DIMENSIONS & TOLERANCES:-** THE DIMENSIONS AND TOLERANCES SHALL BE AS SPECIFIED IN THE DRAWING/ORDER/CONTRACT

3. **SURFACE FINISH:-** AS PER CLAUSE 5.3 OF SPECN. JSS 4710-01:2007 (REVISION No.4)

4. **SAMPLING PLAN:-**

i) **FOR VISUAL & DIMENSIONS:-** SCALE OF SAMPLING AND PERMISSIBLE NUMBER OF DEFECTIVES AS PER TABLE 3 OF SPECN. JSS 4710-01:2007 (REVISION No.4)

ii) **FOR CHEMICAL ANALYSIS:-** QTY. 01 SAMPLE PER HEAT OR MELT AT MELTING PLATFORM FOR CHEMICAL ANALYSIS INCLUDING OXYGEN.

iii) **FOR EXTRUDED PRODUCT:-** SAMPLING POPULATION = 200 Kg OR PART THEREOF

No. OF SAMPLES FROM EXTRUDED BARS: 02 Nos. (01 No. FOR MECH.TEST & CHEMICAL ANALYSIS+01 No. FOR BEND TEST) FOR 200Kg OR PART THEREOF AS PER TABLE GIVEN BELOW

Sl.No.	TEST	METHOD SPECN	No. OF SAMPLE
1	**MECH.PROPERTIES** AS PER **TABLE 2** OF JSS 4710-01:2007 (REVISION No.4) GRADE III (CUPRO-NICKEL) IN **ANNEALED CONDITION**	IS:1608	01 No. PER 200 Kg OR PART THEREOF
2	**BEND TEST** (180° CLOSE) IN ANNEALED CONDITION	IS:1599	01 No. PER 200 Kg OR PART THEREOF
3	**CHEMICAL ANALYSIS (EXCLUDING O_2)**	APPROVED WORK INSTRUCTIONS OF TEST LAB	01 No. PER 200 Kg OR PART THEREOF.

5. **LOT TO BE FORMED AS PER CLAUSE 9.1 OF SPECN.:-** JSS 4710-01:2007 (REVISION No.4)

6. **CRITERIA FOR CONFORMITY:-** AS PER CLAUSE 10 OF JSS 4710-01:2007 (REVISION No.4)

7. **RE-TEST:-** IF THE RESULTS OF ANY TEST OR ANALYSIS DO NOT SATISFY THE REQUIREMENTS FOR ANY ONE OF THE CHARACTERISTICS, TWO MORE SAMPLES FOR THE SAME TEST FROM THE 200 Kg OR PART THREOF SHALL BE DRAWN AND SUBJECTED TO SIMILAR TEST OR ANALYSIS. IF THE RESULT OF BOTH THIS TESTS AND ANALYSIS SATISFY THE RELEVANT REQUIREMENTS, THE 200Kg OR PART THEREOF SHALL BE DEEMED AS CONFORMING TO THE SPECIFICATION OTHERWISE NOT. IN CASE OF FAILURE IN BEND TEST/MECHANICAL TEST. THE SUPPLIER MAY RE-ANNEAL ALL OF THE BLANKS REPRESENTED BY THE FAILED SAMPLES AND SUBMIT THEM FOR THE TESTS.

AUTHORITY: CQA(MET) LETTER No. CQA(M)/QA-2/130mm/AMN/V-23 DATED 18-02-2013

VETTED FOR MATERIAL ASPECT ONLY BY SQAE(A) KANPUR DT-22-02-95 (SK-7894/A)

THIS DRG.SUPERSEDES TO SK-7894/A

			2013	DATE	INTL.	ORDNANCE FACTORY, KANPUR
			PREPD.	09/03	G.P.Upadhyay	
			CHD.			**DRIVING BAND BLANK FOR BOTH BANDS**
01836 9.3.13	DRG. REVISED AS PER CQA(M) LETTER No. CQA(M)/ QA-2/130mm/AMN/V-23 DATED 18-02-2013	JWM/DO	JWM/DO	9/3		BODY, SHELL 130mm HE
			DO/DO			
			JWM/SM-II			
01203 26.8.01	SUPPLY CONDITION MODIFIED	Sd/- JWM/DO	DO/SM-II			ASSLY.& STORE DRG.NO. 2-01313535
			MASS			
D.A.NO. DATE	DETAILS	INTL.	MATERIAL :-			**DRG. No. SK-7894/B**
	REVISIONS		AS STATED			SCALE : 2:1 SHT 1 OF 1