



**APPROVED / CERTIFIED COPY OF**  
**DRG / LAYOUT / GAUGE SCHEDULE**  
**DATE / AT THIS DATE: 22.02.2010**  
**STANDARD CELL**  
**INDIAN ORDNANCE FACTORIES**  
**ISHAPORE**

APPROVED BY  
JMM/SC/MS

**NOTES:-**

- 1 ALL DIMS. ARE IN mm.
- 2 UNTOUCHED DIMS TO BE AS PER STD. I.S. 11166-1993 CLASS-1 OF FINISHMENT CASTING.
- 3 CASTING SHOULD BE FREE FROM DEFECTS LIKE CRACKS, WURFACE HOT TENS, COLD SHOTS, BLOW HOLES ETC. AND SURFACE FINISH SHOULD BE SMOOTH.
- 4 VISUAL EXAMINATION SHOULD CONFORM TO GAUGE 8, I AND 8.2 OF SPEC. I.S. 10343-1989 AND A.O.L. 2.5 OF I.S. 2500 P.1 INSPECTION LEVEL IV.
- 5 CASTINGS TO BE SUPPLIED IN HEAT TREATED CONDITION I.E. ANNEALING OR NORMALISING FOLLOWED BY HARDENING & TEMPERING SUITABLE TEMP. TO GIVE THE MECHANICAL PROPERTIES AS SPECIFIED IN THE DRAWING. HARDNESS OF 248-302 HB SHOULD BE ACHIEVED AFTER HARDENING & TEMPERING.
- 6 DECARBURISATION SHOULD NOT BE MORE THAN 1% OF THE THICKNESS OF THE CASTING.
- 7 TEST SAMPLES SHOULD BE CUT FROM THE SAME BOLT USED FOR MANUFACTURING OF THE CASTING AND SHOULD BE WIRE TO SATISFY THE SPEC. I.S. 10343-1989. RESULT OF THE TEST SHOULD BE FURNISHED ALONG WITH -NOTE
- 8 TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 1:10 SEC-1 OF SPEC. B.S. 3148 P.1, 1974.
- 9 ALL SWAMP EDGES AND BURNS IF ANY ARE TO BE REMOVED.
- 10 MAGNETIC TEST FOR CRACK DETECTION TO BE CARRIED OUT IN SAMPLES AS PER INSPECTION LEVEL IV AT A.O.L. 0.45 AS PER I.S. 2500 P.1, 1992
- 11 MANUFACTURERS SHOULD WITH 3 mm. SIZE TO BE STAMPED AS SHOWN IN CASTING.
- 12 RADIOGRAPHIC ACCEPTANCE STANDARD SHALL BE AS PER ASTM-E-192 CAS RULES & FOREIGN UNIT. LEVEL-5, SHRINKAGE LEVEL-3, CRACKS, COLD SHOTS, HOT TENS, ETC. ARE NOT ACCEPTABLE.
- 13 RADIOGRAPHIC TEST TO BE CARRIED OUT AS FOLLOWS:-  
 1) 10% FROM SAMPLE LOT FROM EACH SUPPLIER. THE LOT SHOULD NOT BE LESS THAN 10 NOS.  
 11) 5% FROM REPRESENTATIVE/BLK SUPPLY UNTIL THE PRODUCT IS ESTABLISHED BY THE VENDOR.  
 11.1) 10 TO 15 NOS. SAMPLE CASTING ONLY PASSED BY INSPECTOR IN RADIOGRAPHY TEST UNIT, DIMS ETC. TO BE SENT TO THIS FACTORY FOR MACHINING & FINISHING TRAIL BEFORE BLK SUPPLY.  
 14 MARKING TRACE TO BE REMOVED BY MACHINING FROM CASTING TO CONFORM DRAWING GEOMETRY.  
 15 TEST PIECE TO BE EXAMINED FOR TENSILE STRENGTH, 1200 VALUE, HARDNESS OF 248-302 HB AFTER HARDENING & TEMPERING.
- 16 ALL DRAWING DIMENSIONS TO BE CHECKED AFTER HEAT TREATMENT AS PER RTI GAUGE SCHEDULE.
- 17 THE SUPPLIER WILL MANUFACTURE 02 SETS OF INSPECTION GAUGE AND GET IT VERIFIED BY RTI.
- 18 MACHINABILITY TO BE TESTED BY DRILLING 2 Holes, THROUGH ON ATLEAST 02 SAMPLES.
- 19 THE SUPPLIER WILL MANUFACTURE 02 SETS OF INSPECTION GAUGE AND GET IT VERIFIED BY RTI.

**MATERIAL:**  
 BS: 3148 P.1, 1974 TYPE CA 5 Grade A  
**HEAT TREATMENT: 250-300 VPH**

<b>INDIAN ORDNANCE FACTORIES</b>		<b>SCALE</b>	
<b>RIFLE FACTORY</b>			
<b>ISHAPORE</b>		<b>DRAWING NUMBER</b>	
<b>12 BORE PUMP ACTION GUN</b>		<b>RFI.SK-8972-6</b>	
<b>1 C MAGAZINE TUBE LOCKING HOLDER</b>		<b>APPROVED: 11.7.2010</b>	
		<b>CHECKED</b>	
<b>SHEET</b>		<b>DATE</b>	
<b>OF</b>		<b>2013</b>	
<b>NAME</b>		<b>DATE</b>	
<b>DATE</b>		<b>NAME</b>	
<b>DATE</b>		<b>NAME</b>	