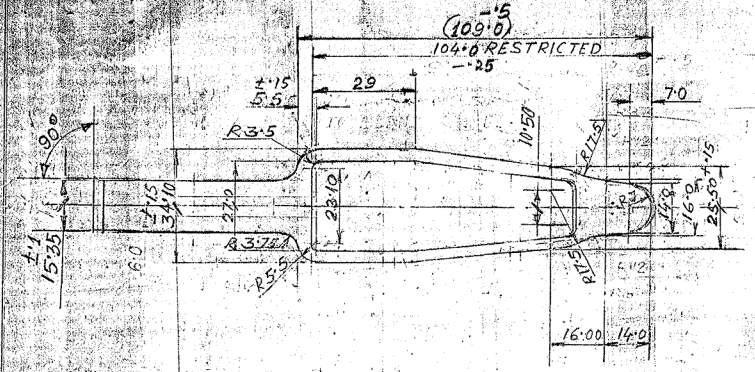
RFI. SK. 4312 *12

NOTE:- 5 TO 10 Nos. OF SAMPLE MUST BE APPROVED BY RFI BEFORE BULK SUPPLY.

MEDIUM STRESSED GR. D



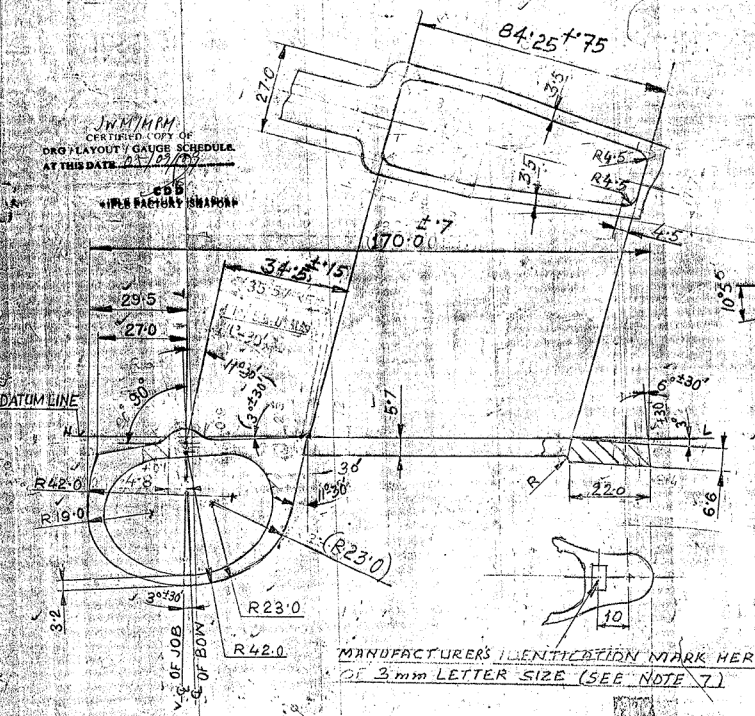
DCRFN & DATE	DETAILS OF AMENDMENTS & AUTHORITY	SIGN.
04/000/98 DT. 29/10/98	AT TOP VIEW FOR R10 READ R6, FOR R7 READ R5·25, DIMN. 9·0 NEWLY ADDED. IN BOTTOM VIEW FOR 22·0 READ 22·3. DRG. AMENDED ACCORDINGLY & ADVANCED TO RFI SK 4312*8 AUTHORITY:- VIDE MEMO No. 51/JWM/BT. GENERAL DT. 25-8-98.	WM/ASSY DO
04/009/98 DT. 12-98	DRG. REVISED. AUTHORITY:- (1) MEMO FROM JWM/BT TO JGM/DO No. 3/2/JWM/BT (GEN) DT. 23-11-98 (2) MINUTES OF THE MEETING IN THE OFFICE OF JGM/PL ON 21-11-98. DRG. AMENDED ACCORDINGLY & ADVANCED TO RFI SK. 4312*9	WM/ASSY DO JGM/DO
04/110/98 6-4-99	DRG. REVISED. TWO BRIDGE INSIDE THE CAVITY DELETED. DRG. AMENDED ACCORDINGLY. DRG. No. ADVANCED TO RFI SK. 4312*10	JGM/DO
30-6-03	IN NOTE 2," WITH 190-230 HV" ADDED. DRG. NO. ADVANCED TO RFI. SK. 4312 *11. AUTHY:- LETTER NO: RC(IM)/IC/QUALITY REVIEW DT. 04-3-03.	JT. GM/MKT
04/003/05 17-2-05	A VIEW SHOWING THE POSITION OF MANUFACTURER'S IDENTIFICTION MARK ADDED. THE DRG. NO. ADVANCED TO. RFI SK 4312*12	SH. G.M./MKT

UNTOLERATED DIMENSIONS ARE AS PER STD. IS:11166-1984 CLASS-II

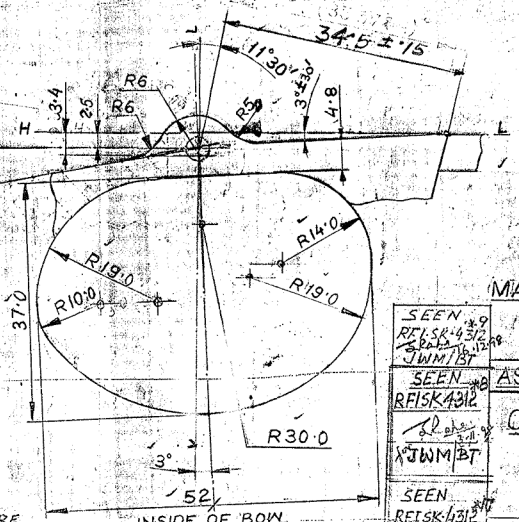
NOTES FOR CONDITION OF SUPPLY

1) ALL DIMENSIONS ARE IN M.M.
2) CASTINGS TO BE SUPPLIED IN ANNEALED CONDITION WITH 190-230 HV.
3) ALL SHARP CORNERS ARE TO BE REMOVED.
4) CASTINGS SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT-TEARS, COLD SHUTS ETC. AND SURFACE FINISH SHOULD BE SMOOTH.
5) VISUAL EXAMINATION SHOULD CONFORM TO CLAUSE 0·1 AND 0·2 OF SPECN. TS-10343-1989 AND A.Q.L (FOR A-1.5, B-1.5, C-2.5) OF IS:2500 PART-1 1992, INSPECTION LEVEL-III.
6) DECARBURISATION SHOULD NOT BE MORE THAN 2% OF THE THICKNESS OF THE CASTINGS.
7) ALL CASTINGS AND REPRESENTATIVE SAMPLES SHALL BE LEGIBLY MARKED WITH IDENTIFICATION MARK.
8) TEST SAMPLES SHOULD BE CAST FROM THE SAME MATERIAL USED FOR MANUFACTURING OF THE CASTINGS AND BE MADE TO SATISFY SPECN. IS:10343-1989 OR BS:3146 PART-1 1974.
9) MAGNETIC TEST FOR CRACK DETECTION SHOULD BE CARRIED OUT IN SAMPLES AS PER INSPECTION LEVEL -IV AT AQL 0·65 AS PER IS:2500 PART-1, 1992.
10) RADIOGRAPHIC ACCEPTANCE STD. AS PER RFI. SK. No. 6274

25.8.96	Φ6 HOLE AND 8·4 DIMENSIONS TO BE DELETED FOR DIMENSIONS 5·2 IN ELEVATION AND R-7 IN PLAN VIEW READ DIMN. 4·8 & R-10 RESPECTIVELY. DIMENSION 170·6 TOTAL LENGTH NEWLY ADDED. AT ENLARGED VIEW OF BON FOR R19·0 READ R10·0 DRG. No. ADVANCED TO RFI. SK. 4312*5	AWM/GC
25.10.95	MATL. FOR BS:3146 Pt.I:1974 TYPE CL.A. GRADE-IC. READ BS:3146 Pt.I:1974 TYPE CL.A.1 GRADE 'C'. DRG. No. ADVANCED TO RFI SK. 4312*6	SD/AK SAHA AWM/G.C.
3.7.95	DIMN. OF RIB 4·0 IS SHOWN TO AUXILIARY VIEW IN PLACE OF PLAN VIEW. THE SAME DELETED FROM PLAN VIEW. THE ORIGIN OF 11°30' IS 2·5 OFF SET FROM THE DATUM LINE IN THE MAIN VIEW. AUXILIARY VIEW OF "IN SIDE OF BON" IS AMENDED ACCORDINGLY. LENGTH OF 'INSIDE OF BON' WILL BE 52 FOR 53 DRG. No. ADVANCED TO RFI. SK. 4312*5	SD/- JWM/D.O
4-5.95	DRG. REVISED AS PER RD/SK/273-SP DRG. No. ADVANCED TO RFI SK. 4312*4	SD/- JWM/D.O
DATE	AMENDMENTS	SIGN.



MANUFACTURERS IDENTIFICATION MARK HERE OF 3mm LETTER SIZE (SEE NOTE 7)



SCALE - 2:1

IN MM/MM CERTIFIED COPY OF DRG/LAYOUT/GAUGE SCHEDULE AT THIS DATE 21/03/97 CDS RIFLE FACTORY ISHAPORE

SEEN RFI SK 4312 *9 JWM/BT 16.12.98

SEEN RFI SK 4312 *8 JWM/BT

SEEN RFI SK 4312 *7 JWM/BT

MATERIAL:- BS:3146 Pt.I:1974, TYPE CL.A.1 - GRADE-C. (SEE NOTE 2)

ASSY. DRG. No.

ORDNANCE FACTORY BOARD
RIFLE FACTORY
ISHAPORE

	1996	NAME	DATE
DRN.			25.7.96
TCD.			
CKD.			
APPVD.			4.9.96

SCALE - 1:1 (2:1)

0·315 SPORTING RIFLE GUARD TRIGGER INVESTMENT CASTING

DRG No. R.F.I. SK.- 4312*12

SHT.-1 OF-1