

1	NOMENCLATURE	INVESTMENT CASTING DRG. OF CUP		
2	DRG. NO./D. S. CAT NO.	RFI SK NO. 9835/A		
3	MATERIAL SPECIFICATION	BS:3146 PT I 1974 TYPE CLA-12 GRADE C		
4	CHEMICAL COMPOSITION	AS PER SPECIFICATION/DRAWING		
5	PHYSICAL PROPERTIES	AS PER SPECIFICATION/DRAWING		
6	DOCUMENT VERIFICATION	K) SUPPLY ORDER	E) MECHANICAL TEST CERTIFICATE	
		B) MIS	F) CRACK DETECTION CERTIFICATE	
		C) BATCH NO.	G) PRE-INSPECTION REPORT	
		D) CHEMICAL TEST CERTIFICATE	H) BATCH SIZE	
7	VISUAL CHECKING SHOULD CONFORM TO CLAUSE 8.1 & 8.2 OF SPECN IS:10343-1993	A) FOLLOW NOTES IN DRG.		
8	DIMENSIONAL CHECKING SAMPLE SIZE : AS PER NOTES GIVEN IN DRG.	SL. NO.	AUDIT POINTS/ DIMENSIONS	GAUGE NO. / METHOD
		1.	30.0+0.15	GE METHOD / GAUGE
		2.	13.5±0.1	GE METHOD / GAUGE
		3.	17.0	RFG-26304-AR
		4.	5.7+0.1	GE METHOD / GAUGE
		5.	Φ14.5	RFG-26306-AR RFG-26307-AR
		6.	Φ21.0	RFG-26303-AR
		7.	3.5+R6.5	GE METHOD / GAUGE
		8.	1.3 (both side)	GE METHOD / GAUGE
		9.	13.5+3.5+16.3	GE METHOD / GAUGE
		10.	14.0 with symmetry	GE METHOD / GAUGE
		11.	3.0	GE METHOD / GAUGE
12.	6.2	GE METHOD / GAUGE		
9	HEAT - TREATMENT	190 TO 230 H.V.		
10	CASE DEPTH	NA		
11	PROTECTIVE FINISH	SURFACE SHOULD BE SMOOTH AND FREE FROM CRACKS, HOT TEARS, COLD SHUTS, ETC		
12	OTHER TESTS	1) AS NOTED IN THE DRAWING		

NOTE :-

- 1) PHYSICAL PROPERTIES & OTHER TESTS AS PER REQUIREMENT OF RELEVANT SPECIFICATION.
- 2) TEST REPORT IS TO BE ISSUED FROM NABL APPROVED LAB./DGQA LAB./DGQA APPROVED LAB./ORDNANCE FACTORIES LAB.
- 3) RECORD OF TEST REPORT WITH REFERENCE TO MIS NO. ARE TO BE MAINTAINED.
- 4) ENSURE MARKING OF MANUFACTURER'S CODE ON THE STORE SUITABLY (IF MENTIONED IN DRAWING) & ENTRY OF LOT NO. & YEAR OF MANUFACTURE IN PRE-INSPECTION REPORT.
- 5) TEST PIECES (ALONGWITH THE COMPONENT) AS SPECIFIED IN THE GOVERNING SPECIFICATION ARE TO BE SUBMITTED FOR CHECKING CHEMICAL COMPOSITION & MECHANICAL PROPERTIES.

REP. OF ODC

REP. OF QC

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