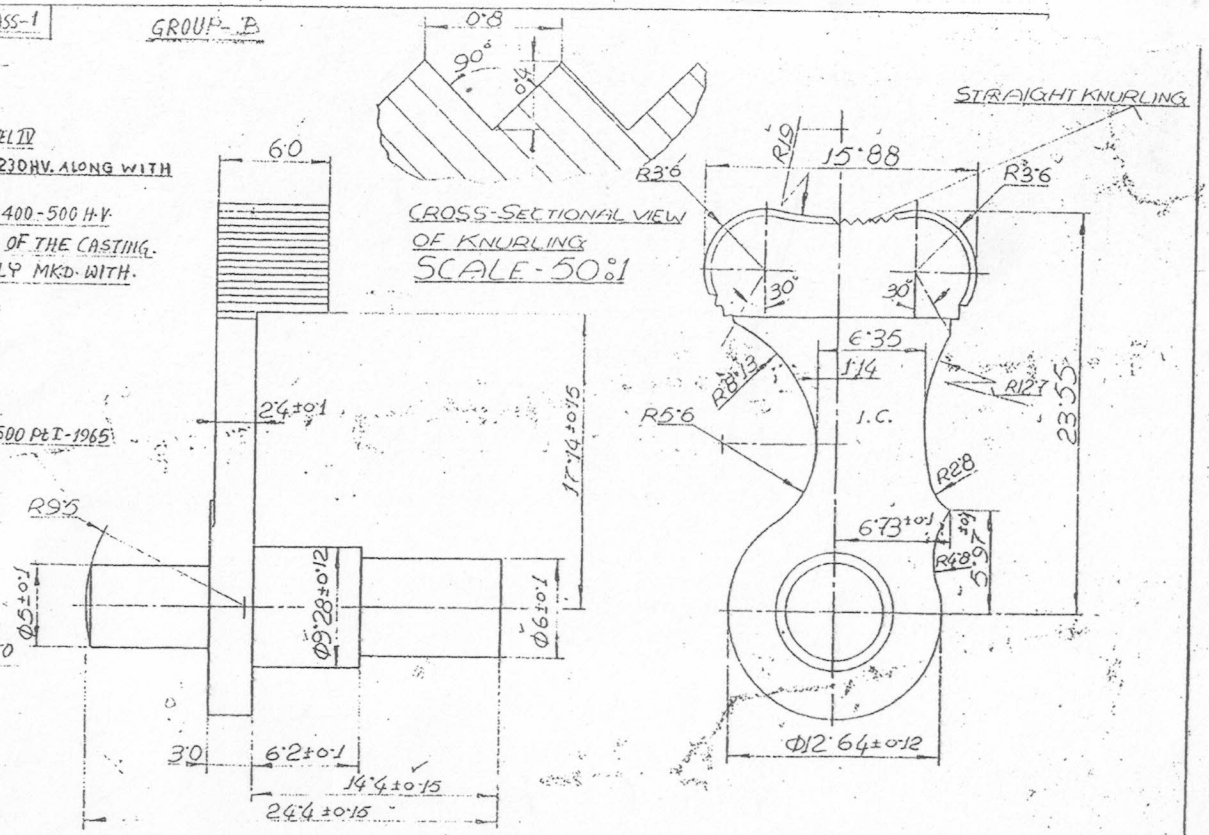
NOTES:- UNTOLERANCED DIMNS. TO BE AS PER IS:11166-1984 CLASS-1

1) CASTINGS SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT TEARS COLD SHUTS ETC. & SURFACE FINISH SHOULD BE SMOOTH.
2) VISUAL EXAMINATION SHOULD CONFORM TO CLAUSE 8.1 & 8.2 OF SPECN. IS: 10343-1982 & A.Q.L. (FOR THIS I.C.-1.5) OF IS: 2500 PT.1 INSPECTION LEVEL IV
3) CASTINGS ARE TO BE SUPPLIED IN ANNEALED CONDITION WITH 190-230 HV. ALONG WITH THE TEST COUPONS TO BE TESTED FOR HARDNESS AT ANNEALED CONDITION & ALSO AFTER FINAL HEAT TREAT TO ACHIEVE HARDNESS 400-500 H.V.
4) DECARBURISATION SHOULD NOT BE MORE THAN 2% OF THE THICKNESS OF THE CASTING.
5) ALL CASTINGS & REPRESENTATIVE TEST SAMPLES SHALL BE LEGIBLY MKD. WITH IDENTIFICATION MARK.
6) TEST SAMPLES SHOULD BE CAST FROM THE SAME MELT USED FOR MANUFACTURING OF THE CASTING & SHOULD BE MADE TO SATISFY THE SPECN. IS: 10343-1982.
9) MAGNETIC TEST FOR CRACK DETECTION TO BE CARRIED OUT IN SAMPLES AS PER INSPECTION LEVEL III AT AQL 0.65 AS PER IS: 2500 PT.I-1965
10) RADIOGRAPHIC ACCEPTANCE STD. SHALL BE AS PER ASTM-E-192.
(a) CASTING SHOULD BE SUBJECTED TO RADIOGRAPHY BY USING X-RAYS. GAMMA RAYS SHALL NOT BE PERMITTED AT ALL UP TO THE THICKNESS RANGE OF 25 mm.
(b) UNLESS OTHERWISE STATED THE RADIOGRAPHIC ACCEPTANCE STD. OF THE CASTING SHOULD BE AS FOLLOWS:- GAS HOLES LEVEL & FOREIGN MATL. LEVEL-5, SHRINKAGE ALL TYPE -3 (c) 100% OF THE ADVANCE SAMPLES SHALL BE SUBJECTED TO RADIOGRAPHIC TEST.
(d) FOR BULK COMPONENTS, 5% OF EACH OF CAST/HEAR SHOULD BE SUBJECTED TO RADIOGRAPHIC TEST.
11) 10 TO 15 NOS. SAMPLES CASTING DULY PASSED BY INSPECTOR FOR RADIOGRAPHIC TEST, MAT. & DIMENSIONS ETC. ARE TO BE SENT TO THIS FACTORY FOR MACHINING & FITMENT TRIAL BEFORE BULK SUPPLY.

GROUP-B



MAT. B.S. 3146 PART I-1974, TYPE CLA-12 GR-A TO ACHIEVE HARDNESS 400-500 V.P.N. [AS PER CQA(MET), ISHAPORE, LETTER NO. MQA-1/02 INVEST. DT. 30-10-'92]

(SEE NOTE-3)

SL.NO	DATE	NATURE OF AMENDMENTS	SIGN.
3.	30-6-03	IN NOTE-3, "WITH 190-230 HV." ADDED. DRG. NO. ADVANCED TO RFI.SK.3712/C AUTHORITY:- LETTER NO. QC(IM)/IC/ QUALITY REVIEW. DT. 04-3-03.	JT. GM/ASY 30.6.03
2	5-12-95	NOTES FOR CONDITION REVISED. DRG. NO. ADVANCED TO RFI.SK-3712/B. AUTHORITY:- VIDE CQA(MET)'S LETTER NO. MQA-1/QA-I/12 DT. 5-5-95	AWM/QC
1.	27-8-93	REDESIGNED. DRG. NO. ADVANCED TO RFI.SK.3712/A	

AMENDMENTS

प्रमाण प्रति. CERTIFIED COPY OF
ड्राइंग / लेआउट / गेज शिड्यूल HOS/MPM
DRG/LAYOUT/GAUGE SCHEDULE
दिनांक / AT THIS DATE 24.03.18
सी डी डी / CDD
राइफल फैक्टरी, इशापुर
RIFLE FACTORY, ISHAPORE

ORDNANCE FACTORY BOARD
RIFLE FACTORY
ISHAPORE

	1993	NAME	DATE
DGN.		RKPaul	27.8
DRN.			
CKD.			
APPD.			

SCALE 5:1 (50:1)

BOLT LOCKING, I/C
0.315 SPORTING RIFLE

DRG. NO. RFI.SK.3712/C
SHEET 1 OF 1

Wt. 17 gms (approx) Ref: Jt. GM/PL Letter No. 56/P&P/5.56 Dt. 26-11-2011

(NOTE:- FOR MEDIK SUPPLY)