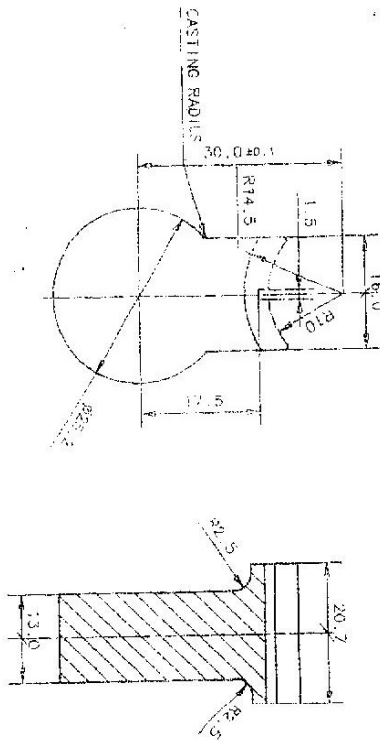




NOT A TRUE COPY OF
DRAWING FOR THE BORE
RIFLE LOCKING HOLDER
DRAWING NO. 83-01-17
DATE 10/10/18
BY
MILITARY FACTORY, ISHAPORE

NOTES:-

1. ALL DIMS. ARE IN mm.
 2. UNOBTAINED DIMS. TO BE AS PER STD. I.S. 11168-1993 CLASS-1 OF INVESTMENT CASTINGS.
 3. CASTING SHOULD BE FREE FROM DEFECTS LIKE CRACKS, WARPAGE, HOT TEARS, COLD SHOTS, BLOW HOLES ETC. AND SURFACE FINISH SHOULD BE SMOOTH.
 4. VISUAL EXAMINATION SHOULD CONFORM TO GAUGE 8.1 AND 8.2 OF SPEC. I.S. 10343-1999 AND A.O.L. 2.5 OF I.S. 2500 P.I.1 INSPECTION LEVEL IV.
 5. CASTINGS TO BE SUPPLIED IN HEAT TREATED CONDITION i.e. Annealing or Normalizing, FOLLOWED BY MACHINING & TEMPERING SUITABLE TO GIVE THE MECHANICAL PROPERTIES SPECIFIED IN THE DRAWING. HARDNESS OF 240-302 HRC 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 CAST FROM THE SAME MELT USED FOR MANUFACTURING OF THE CASTING AND SHOULD BE MADE TO SATISFY THE SPEC. I.S. 10343-1999. RESULT OF THE TEST SHOULD BE FURNISHED ALONG WITH I-NOTE.
 8. TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 11.10 SEC-1 OF SPEC. B.S. 3146 Pt.1/1974.
 9. ALL SHARP EDGES AND BURS 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. 0.65 AS PER I.S. 2500 P.I.1, 1992.
 11. MANUFACTURERS SYMBOL WITH 3 mm. SIZE TO BE STAMPED AS SHOWN IN CASTING.
 12. RADIOGRAPHIC ACCEPTANCE STANDARD SHALL BE AS PER ASME-SE-192 GAS HOLES & FOREIGN MAT. LEVEL-5. SHRINKAGE LEVEL -3. CRACKS, COLD SHOTS, HOT TEARS ETC. ARE NOT ACCEPTABLE.
- 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.
 - 2) 5% FROM REPEATATIVE/BULK SUPPLY UNTIL THE PRODUCT IS ESTABLISHED BY THE VENDOR.
 - 3) 10 TO 15 NOS. SAMPLE CASTING DAILY PASSED BY INSPECTOR IN RADIOGRAPH TEST. MAT. DIMS. ETC. TO BE SENT TO THIS FACTORY FOR MACHINING & FITMENT TRIAL BEFORE BULK SUPPLY.
 - 4) INMATE TRACE TO BE REMOVED BY MACHINING FROM CASTING TO CONFORM DRAWING GEOMETRY.
 - 5) TEST PIECE TO BE EXAMINED FOR TENSILE STRENGTH, ELONG. VALUE, HARDNESS OF 240-302 HRC AFTER HARDENING & TEMPERING.
 - 6) ALL DRAWING DIMENSIONS TO BE CHECKED AFTER HEAT TREATMENT AS PER RTI GAUGE SCHEDULE.
 - 7) THE SUPPLIER WILL MANUFACTURE 02 SETS OF INSPECTION GAUGE AND GET IT VERIFIED BY RTI.
 - 8) WORKMANLIABILITY TO BE TESTED BY DRILLING 62 HOLES, THROUGH OR ATLEAST 02 SAMPLES.
 - 9) THE SUPPLIER WILL MANUFACTURE 02 SETS OF INSPECTION GAUGE AND GET IT VERIFIED BY RTI.

MATERIAL:

BS: 3146 Pt.1 1974 TYPE CLA 5 Grade A

HEAT TREATMENT: 250-300 VPK

INDIAN ORDNANCE FACTORIES RIFLE FACTORY ISHAPORE

12 BORE PUMP ACTION GUN	SCALE	2013	NAME	DATE
GUN MAGAZINE TUBE LOCKING HOLDER			M. M. KARNAD 22/01/18	
		CHECKED		
		APPROVED		
		DRAWING NUMBER		
		RFI. SK-8972-G		
		SHEET		
		OF		

APPROVED BY
JMM/SC/MS