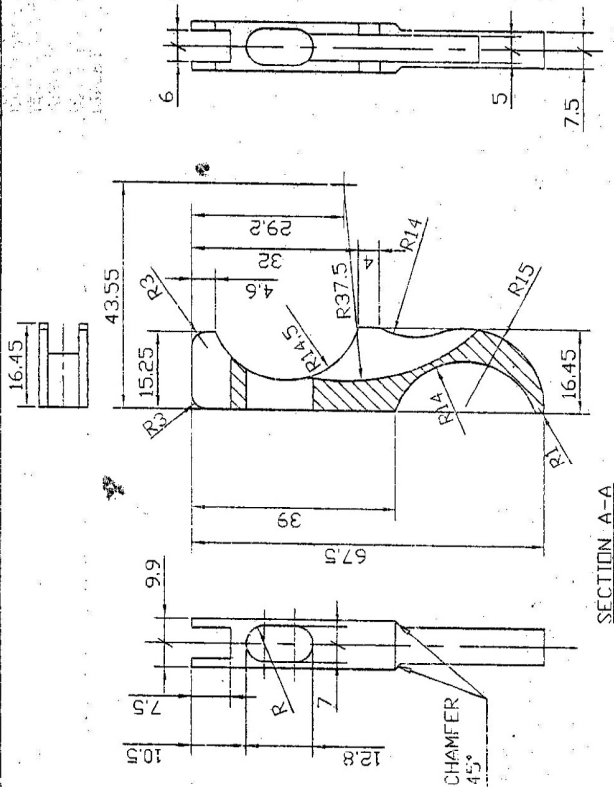


H08/MPM

22-07-19



SECTION A-A

NOTES:-

1. DIMENSIONS WITHOUT TOLERANCE TO BE AS PER STD. I.S. 11166-1993 CLASS - 2 OF INVESTMENT CASTING.
2. CASTINGS SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT TEARS, COLD SHOTS, BLOW HOLES ETC. AND SURFACE FINISH SHOULD BE SMOOTH.
3. VISUAL EXAMINATION SHOULD CONFORM TO CLAUSE 8.1 & 8.2 OF SPECN. I.S. 10343-1999 AND AQL(2.5) OF I.S. 2500 Pt. 1 INSPECTION LEVEL IV.
4. DECARBURISATION SHOULD NOT BE MORE THAN 2% OF THE THICKNESS OF THE CASTING.
5. TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 110 METHOD (1) OF BS 3145 Pt. 1 1974. TEST PIECES SHOULD BE CAST FROM THE SAME MELT USED AND SHOULD BE MADE TO SATISFY THE SPECN. IS 10343-1999. RESULT OF TEST SHALL BE FURNISHED ALONG WITH INVOICE.
6. SHARP EDGES IF ANY ARE TO BE REMOVED.
7. ALL CASTINGS & REPRESENTATIVE TEST SAMPLES SHALL BE LEGIBLY ENGRAVED WITH MANUFACTURER'S IDENTIFICATION MARK OF SUITABLE SIZE AT THE DESIGNATED AREA.
8. 10 TO 15 NOS. SAMPLE CASTING DUELY PASSED BY INSPECTOR IN RADIOGRAPHIC TEST, MATERIAL, DIMENSIONS ETC. TO BE SENT AGAINST EACH S.D. TO THIS FACTORY FOR FITMENT TRIAL BEFORE BULK SUPPLY.

DC REFNO.	DATE	AMENDMENTS	SIGN.
09/008/19	19-07-2019	FOR FINISH -PHOSPHATED TO SPECN/MPN/GEN-3/CLASS II OIL FINISH. REDAFINISH -IC SHOULD BE PRESERVED WITH OIL.	

INSPECTION CRITERIA:

1. 100% MAGNETIC TEST FOR CRACK DETECTION TO BE CARRIED OUT IN SAMPLES AS PER INSPECTION LEVEL IV AT AQL 0.65 AS PER I.S.2500 Pt. 1 1965
2. RADIOGRAPHIC STANDARD AS PER ASTM-E-192 GAS HOLE & FOREIGN MATERIAL LEVEL 5, SHRINKAGE LEVEL 3, CRACKS, COLD SHOTS, HOT TEARS ETC. ARE NOT ACCEPTABLE.
 - a. 100% OF THE ADVANCE SAMPLES SHALL BE SUBJECTED TO RADIOGRAPHIC TEST
 - b. FOR BULK COMPONENTS, 5% EACH OF CAST/HEAT SHOULD BE SUBJECTED TO RADIOGRAPHIC TEST UNTIL THE PRODUCTION IS ESTABLISHED BY THE VENDOR.
3. TEST PIECE TO BE EXAMINED FOR TENSILE STRENGTH & T20D VALUE
4. MACHINABILITY TO BE TESTED BY DRILLING Ø2.5 HOLES THROUGH AND THROUGHOUT AT LEAST 02 SAMPLES.
5. ALL DRGS. DIMNS. ARE TO BE CHECKED AFTER FINAL HEAT TREATMENT.
6. THE SUPPLIER WILL MANUFACTURE 02 SETS OF INSPECTION GAUGE AND GET IT VERIFIED BY RFI.

TREATMENT:- CASTING TO BE SUPPLIED FINALLY AFTER ANNEALING, TEMPERING & HARDENING TO DHN 248-302

FINISH :- IC SHOULD BE PRESERVED WITH OIL.

CHEMICAL COMPOSITION OF MATERIAL :-

C%	Mn%	Cr%	Mo%	Si%
0.55-0.65	0.5 - 1.0	0.8 - 1.5	0.2 - 0.4	0.3 - 0.8

CASTING MATERIAL :- BS:3146 PT-1 1974,
TYPE CLASS 12 GR 'C'

ALL DIMENSIONS ARE IN mm.

TITLE OF COMP.DRG.	OPERATION	2019	NAME	DATE
INVESTMENT CASTING DRG.		DGN.	M. HATTI	19/7/19
INDIAN ORDNANCE FACTORIES RIFLE FACTORY ISHAPORE	SCALE 1:1	DRN.		15/07/19
		CKD.		20-7-19
		APPD.		
		DRG.NO.		
		RFI SKNI		9093-1007A
		SHEET NO.		1/1

TRIGGER

IGG-204

TEAR GAS GUN