



SECTION A-A

DETAIL OF X

SCALE: 2

- 1) UNTEMPERED DIAMS ARE TO BE AS PER STD. IS-1116-1984-CLASS-2 OF I.C. EXCEPT OTHERWISE SPECIFIED
- 2) CASTING SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT TEARS, COLD SHOTS ETC. AND SURFACE FINISH SHOULD BE SMOOTH WITHOUT BEND OR TWIST BEYOND 0.1
- 3) VISUAL EXAMINATION SHOULD CONFORM TO CLAUSE 8.1 AND 8.2 OF SPECIFICATION IS : 10343 - 1982 AND AQ. 2.0 OF IS : 2500 PT 1*1 INSPECTION LEVEL III.
- 4) CASTING ARE TO SUPPLIED IN ANNEALED CONDITION ALONG WITH THE TEST SAMPLES, TO BE TESTED FOR HARDNESS AT ANNEALED CONDITION AND ALSO AFTER FINAL HEAT TREATMENT
- 5) DECARBURISATION SHOULD NOT BE MORE THEN 2% OF THE THICKNESS OF THE CASTING
- 6) ALL CASTING AND REPRESENTATIVE TEST SAMPLES SHOULD BE LEGIBLY MARKED WITH MANUFACTURE'S IDENTIFICATION MARK OF 3 MM SIZE
- 7) TEST SAMPLE SHOULD BE CAST FROM THE SAME MELT USED FOR MANUFACTURING OF THE CASTING AND SHOULD BE MADE TO SATISFY THE SPECN. IS : 10343 - 1982.
- 8) MAGNETIC TEST FOR CRACK DETECTION TO BE CARRIED OUT IN SAMPLES AS PER INSPECTION LEVEL IV AT AQ. 0.65 AS PER IS : 2500 PT1 1965
- 9) RADIOGRAPHIC ACCEPTANCE STANDERD SHALL BE AS PER A.S.T.M. E-192. GAS HOLES LEVEL-5, FOREIGN METAL LEVEL 5 AND SHRINKAGE (ALL TYPE) LEVEL-3

RADIOGRAPHIC TEST TO BE CARRIED OUT AS FOLLOWS

- 1) 100% FROM SAMPLE LOT FROM EACH SUPPLIER. THE LOT SHOULD NOT BE LESS THEN 10 NOS
- 11) 2% FROM SECOND LOT FROM EACH SUPPLIER. THE LOT SHOULD NOT BE LESS THEN 100 NOS
- 111) 1% FROM RESPECTIVE / BULK SUPPLY UNTIL THE PRODUCT IS ESTABLISHED BY THE VENDOR

CERTIFIED COPY OF
TYPE / RANGE / FOR ISSUE HES / IN PM
REGAINOUT/GAUGE SCHEDULE
DATE AT THIS DATE 19.06.97
NO. 868/CDD
SIGNED [Signature] Manager
MELB FACTORY, ISHAPONE

IC MATERIAL : IS : 10343- 1989			ALL DIMNS. ARE IN mm.			
GRADE : 28						
ALT. MAT. : BS 3146:1974 PART 1			CLASS 2			
TITLE OF		OPERATION		2005	NAME	DATE
INDIAN ORDNANCE FACTORIES RIFLE FACTORY -ISHAPORE				DGN.	J. CHAK.	16-08
RIFLE 5.56 mm. EXCALIBUR 4		SCALE :- (2:1)		DRN.	S. BIS	04-17
PICATINNY RAIL TOP - (IC)		APPD.				
DRG. NO. :-		RF 1. SK. 7626/S				
SHEET 1		OF 1				