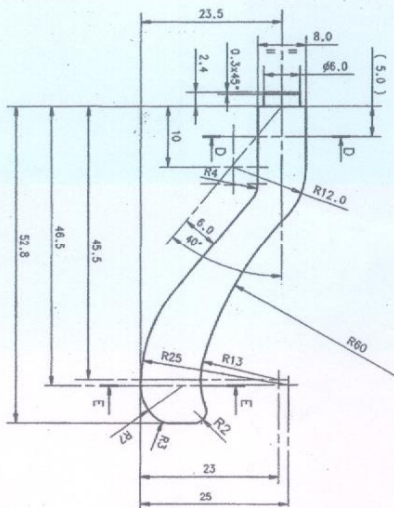
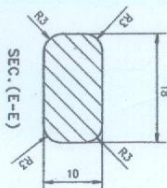
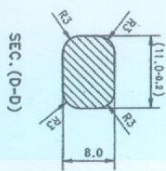
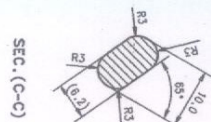
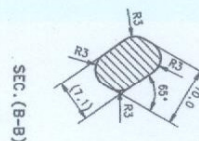
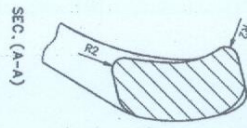
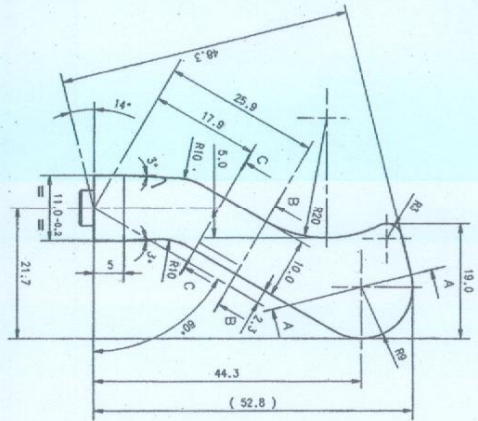


HO5/MPH



04/09/18	02.02.10	DATE	1. CASTING MATERIAL CHANGED. P. 8.5:316 PT. 1, 1974 TYPE CLA.12 GRADE "B" P. 8.5:316 PT. 1, 1974 TYPE CLA.4 2. CHEMICAL COMPOSITION ADDED. 3. HEAT TREATMENT CHANGED. FOR INR 820-300 HAD INR 542-302	ADDITIONS	11 CM. / 0A	AUTHORITY
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JL CH/NA AUTHORITY DATE	TITLE OF COMP. DRG. INVESTMENT CASTING DRG. INDIAN ORNANCE FACTORIES RIFLE FACTORY ISMAPORE	OPERATION 	SCALE 2:1	2008	NAME	DATE
				DRG. NO. :- TSP-112-A	DRN. 14050	10/07/08
				30-06 SPORTING RIFLE		
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				DRG. NO. :- TSP-112-A	DRN. 14050	10/07/08

CHEMICAL COMPOSITION OF MATERIAL :-

CN	Mos	Crs	Mos
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FINISH :- PHOSPHATED TO SPECN.WPN/GEN-3/CLASS II OIL FINISH.

TEMPERING & HARDENING TO BHN 248-302

TEMPERING & HARDENING TO BHN 248-302

CASTING MATERIAL :- B.S.: 3146 PT-1 1974,
TYPE CLA 4

ALL DIMENSIONS ARE IN mm

ALL DIMENSIONS ARE IN CM

TITLE OF COMP.DRG.

	OPERATION
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[illegible]

INVESTMENT CASTING DRG.

DEG.	
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10/6	11/10/2018	DRN.
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RIFLE FACTORY
ИЗНАВОДЪ

APPD	✓	Dr. A. C.
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HANDLE BO

J. BOLT BRECH

DRG.NO.:-

30-06 SP0

SPORTING RIFLE

RF-1 SK. NO. 8273

- NOTES:-
- SCALE-1:1
1. DIMENSIONS WITHOUT TOLERANCE TO BE AS PER STD. I.S. 11160-1993 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 6.1 & 6.2 OF SPECN. I.S.: 10343-1999 AND A.Q.L.(2.5) OR I.S.: 2500 Pt. 1 INSPECTION LEVEL IV.
 3. DECARBURISATION SHOULD NOT BE MORE THAN 2% OF THE THICKNESS OF THE CASTING.
 4. TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 1:10 NOTED (1) OF BS 3146 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 I-NOTE.
 5. SHARP EDGES IF ANY ARE TO BE REMOVED.
 6. ALL CASTINGS & REPRESENTATIVE TEST SAMPLES SHALL BE LEGIBLY ENGRAVED WITH MANUFACTURER'S IDENTIFICATION MARK OF SUITABLE SIZE AT THE DESIGNATED AREA.
 7. 10 TO 16 MS. SAMPLE CASTING DUELY PASSED BY INSPECTOR IN RADIOGRAPHIC TEST MATERIAL, DIMENSIONS ETC. TO BE SENT AGAINST EACH S.O. TO THIS FACTORY FOR FURTHER TREAT BEFORE BULK SUPPLY.
- INSPECTION CRITERIA:

INSPECTION CRITERIA:

1. 100% MAGNIFIC TEST FOR CRACK DETECTION TO BE CARRIED OUT IN SAMPLES AS PER INSPECTION LEVEL IV AT A Q.T. 0.65 AS PER I.S.:2560 PT. 1, 1965
2. RADIOGRAPHIC STANDARD AS PER ASTM-E-192 GAS DYE & PORENCE MATERIAL LEVEL-5 SRRIMARKS, LEVEL 3, CRACKS, COLD SHOTS, HOT TARS ETC. ARE NOT ACCEPTABLE.
- a. 100% OF THE ADVANCE SAMPLES SHALL BE SUBJECTED TO RADIOGRAPHIC TEST.
- b. FOR BULK COMPONENTS, 25 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 & 1200 VALUE.
4. MACHINABILITY TO BE TESTED BY DRILLING $\phi 2.5$ HOLES THROUGH AND THROUGH ON ATLEAST 02 SAMPLES.
5. ALL DRESS. DIMS. ARE TO BE CHECKED AFTER FINAL HEAT TREATMENT.
6. THE SUPPLIER WILL MANUFACTURE 02 SETS OF INSPECTION GAUGE AND GET IT VERIFIED BY INT.