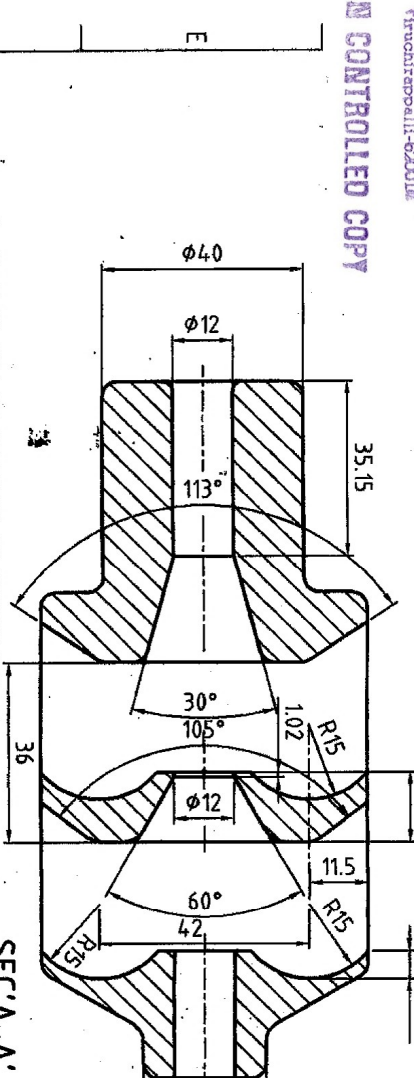
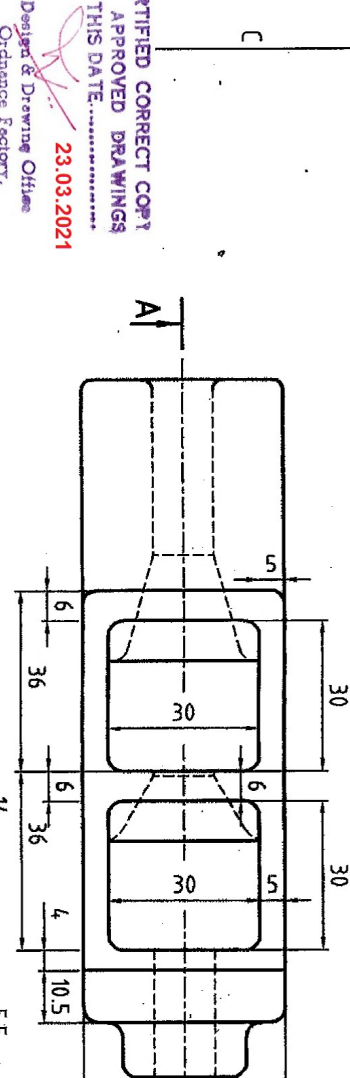
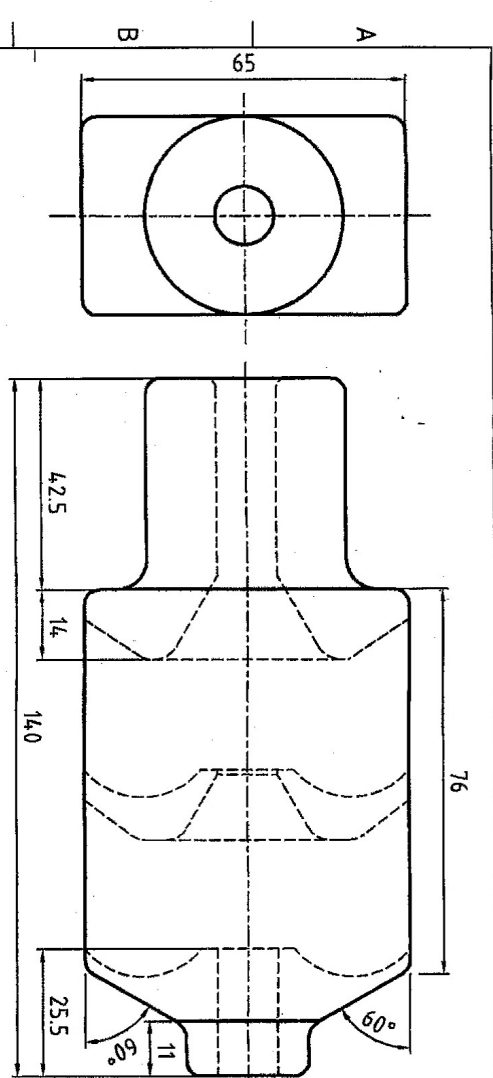


MATERIAL * 15/10343-99 GR. 29 Q

COMPOSITION OF MATERIAL		MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX	MIN	MAX
CM	SI%	Mn%	NI%	Cr%	MO%	Cu%	S%	P%					
0.55	0.8	1.0	0.6	1.2	0.1	0.3	0.435	0.035					



UN CONTROLLED COPY

CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE: 23.03.2021

Design & Drawing Office
Ordnance Factory,
Trichirappalli-620016

SUITABLE INGATE POSITION MAY BE SELECTED BY MANUFACTURER
MAX. PERMISSIBLE TRACE HEIGHT IS 0.05

DIMENSIONS ARE IN mm.
UNTOLERATED DIMNS. AS PER IS : 11166-1984
CLASS-1 OF INVESTMENT CASTING.

SEC'A-A'

AMENDMENTS	DATE	SIG.	APPROVED ON	DATE
SI/40/12	30.11/19			
SI/40/02/19	30.11/19			

PART NO.	DESCRIPTIONS & DATE	NO OFF	MATERIAL	TREATMENT	REMARKS
TRACED					
DRAWN					
CHECKED					
QC/DADO					
OFFICER/PRODN.					
OFFICER/DRG.					
DRG. NO.:	SUB: INVESTMENT CASTING DRG.		SCALE		
	FOR: 14.5mm CAST MUZZLE BRAKE		N/S		
	OF: 14.5/20mm AMR		STORE DRG. NO.		
	DES. REF. NO.		44P 17001		
	DRG. NO.:		OPERATION NO.		
	TEND 1790*				
	ORDNANCE FACTORY TRICHIRAPPALLI-16.		SHEETS: 1		
			SHEET NO.: 1		

- CASTING SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT TEARS, COLD SHUTS, ETC., AND SURFACE FINISH SHOULD BE SMOOTH. VISUAL EXAMINATION SHOULD CONFORM TO CLAUSE 8.1 & 8.2 OF SPECN. IS:10343-1982 & A.Q.L. 1.5 OF IS:2500 PT.1 INSPECTION LEVEL IV
- MAX. PERMISSIBLE LIMIT FOR BEND IS 0.1 IN TOTAL LENGTH.
- CASTINGS ARE TO BE SUPPLIED IN ANNEALED CONDITION ALONG WITH THE TEST SAMPLES TO BE TESTED FOR HARDNESS AT ANNEALED CONDITION AND ALSO FOR FINAL HEAT TREATMENT.
- TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 1.10 METHOD (1) OF BS 3146 PT.1.1974 AND 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
- SHARP EDGES & BURRS IF ANY TO BE REMOVED
- 100% MAGNETIC TEST FOR CRACK DETECTION TO BE CARRIED OUT IN SAMPLES AS PER INSPECTION LEVEL IV AT AQL 0.65 AS PER IS:2500 PT.1.1965
- RADIOGRAPHIC ACCEPTANCE STANDARD SHALL BE AS PER ASTM-E 192
- CASTINGS SHOULD BE SUBJECTED TO RADIOGRAPHY BY USING X-RAYS, GAMMA RAYS SHALL NOT BE PERMITTED AT ALL UP TO THE THICKNESS RANGE OF 25mm.
- UNLESS OTHERWISE STATED THE RADIOGRAPHY ACCEPTANCE STANDARD OF THE CASTING SHOULD BE AS FOLLOWS.
 - GAS HOLES LEVEL - 3
 - FOREIGN MAT. LEVEL - 3
 - SHRINKAGE CALL TYPE - 2
- 100% OF THE ADVANCE SAMPLES SHALL BE SUBJECTED TO RADIOGRAPHIC TEST