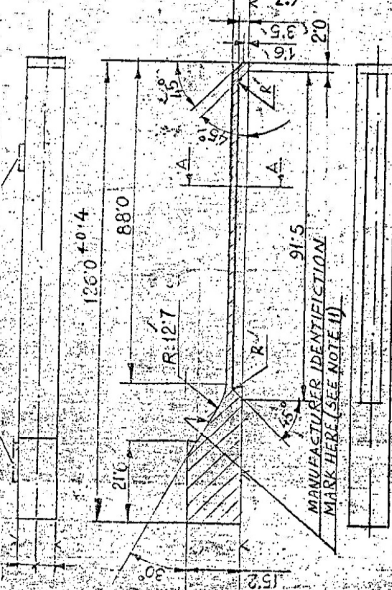


GROUP C

"INGATE TRACE 0.5 mm HIGH AS SHOWN" (OPTIONAL).
NO OTHER INGATE IS DESIRABLE.



R127 MAX. 5.5
SEC. AT A-A

MANUFACTURER IDENTIFICATION
MARK HERE (SEE NOTE 10)

1. DIMENS. ARE IN mm.
2. UNFOLERANCED DIMS TO BE AS PER STD. IS: 11166 - 1984.
3. CLASS-T OF INV. CASTING.
4. CASTINGS SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT TEARS, COLD SHUTS ETC. AND SURFACE FINISH MUST BE SMOOTH.
5. VISUAL EXAMINATION SHOULD CONFORM TO CLAUSE 8.11 AND 8.12 OF SPECN. IS: 10343 - 1982 AND AQL 1.2.5. C/D. R. 1.0. 0.18-2500 R. 1.1, 1992. INSPECTION LEVEL III.
6. CASTINGS ARE TO BE SUPPLIED IN ANNEALED CONDITION ALONG WITH THE TEST SAMPLES TO BE TESTED FOR HARDNESS AT ANNEALED CONDITION AND ALSO AFTER FINAL HEAT TREATMENT. (SEE MATL.)
7. DECURBURISATION SHOULD NOT BE MORE THAN 2% OF THE THICKNESS OF THE CASTING.
8. TEST SAMPLES SHOULD BE CAST FROM THE SAME MOLT USED FOR MANUFACTURING OF THE CASTING AND SHOULD BE MADE TO SATISFY THE SPECN. IS: 10343-1989.
9. TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 11.1 SEC. 10F SPECN. B.S. 3146 PL. 1.1974, G+C.
10. SHARP EDGES & BURRS IF ANY ARE TO BE REMOVED.
11. MAGNETIC TEST FOR CRACK DETECTION TO BE CARRIED OUT IN SAMPLES AS PER INSPECTION LEVEL II AT AQL 0.65 AS PER IS: 2500 R. 1.1, 1992.

12. 100% FROM SAMPLE LOT FROM EACH SUPPLIER. THE 10% SHOULD NOT BE LESS THAN 10 NOS.
13. 2% FROM SECOND LOT FROM EACH SUPPLIER. THE 10% SHOULD NOT BE LESS THAN 10 NOS.
14. 10% FROM REPEAT TREATMENT. BULK SUPPLY UNTIL THE PRODUCT IS ESTABLISHED BY VENDOR.
15. 10 TO 15 Nos. SAMPLE CASTING DULY PASSED BY INSPECTOR IN RADIOGRAPHIC TEST. MATERIALS ETC. TO BE SENT TO THE FACTORY FOR MACHINING & DELIVERY. THE DELIVERY SHOULD BE IN THE FORM OF BULK SUPPLY.

H08/mem

09-05-91

RIELE FACTORY, CHHAPORE

MATL: BS 3146 PL. 1.1974 TYPE CLA-8

HEAT TREATMENT: ANNEALED.

HARDNESS: 200 ± 30 HB.

MICROSTRUCTURE: COARSE PEARLITE.

Ingate shall be hard in per. Appman - E

Ingate shall be hard in per. Appman - E

VERIFIED FOR MATL. ONLY ONLY MATL. VERIFIED BY

D/M - 15.1.2010

C/M - 10.1.2010

12/4/10

12/4/10

12/4/10

12/4/10

12/4/10

12/4/10

INVESTMENT CASTING DRAWING

ORDNANCE FACTORY BOARD

RIELE FACTORY

CHHAPORE

RIELE 556MT

SLIDE (RETRACTING)

RIELE SK 3143/30

RIELE SK NO. 5709

RIELE SK NO. 5709

RIELE SK NO. 5709

RIELE SK NO. 5709

RIELE SK NO. 5709

RIELE SK NO. 5709

RIELE SK NO. 5709

NO.	DATE	TIME	ZONE	SIGN	AUTHORITY	REMARKS
1	01/03/18	10:00	04			FOR MATL IS: 10343-89
2	01/03/18	10:00	04			READ MATL BS 3146 PL 1.1974
3	01/03/18	10:00	04			DRG NO. 1264-04
4	01/03/18	10:00	04			TO REFSK-5709-13
5	01/03/18	10:00	04			FACTORY IDENTIFICATION
6	01/03/18	10:00	04			FROM ZONE 1
7	01/03/18	10:00	04			TO REFSK-5709-13
8	01/03/18	10:00	04			TO REFSK-5709-13
9	01/03/18	10:00	04			TO REFSK-5709-13
10	01/03/18	10:00	04			TO REFSK-5709-13
11	01/03/18	10:00	04			TO REFSK-5709-13
12	01/03/18	10:00	04			TO REFSK-5709-13
13	01/03/18	10:00	04			TO REFSK-5709-13
14	01/03/18	10:00	04			TO REFSK-5709-13
15	01/03/18	10:00	04			TO REFSK-5709-13
16	01/03/18	10:00	04			TO REFSK-5709-13
17	01/03/18	10:00	04			TO REFSK-5709-13
18	01/03/18	10:00	04			TO REFSK-5709-13
19	01/03/18	10:00	04			TO REFSK-5709-13
20	01/03/18	10:00	04			TO REFSK-5709-13
21	01/03/18	10:00	04			TO REFSK-5709-13
22	01/03/18	10:00	04			TO REFSK-5709-13
23	01/03/18	10:00	04			TO REFSK-5709-13
24	01/03/18	10:00	04			TO REFSK-5709-13
25	01/03/18	10:00	04			TO REFSK-5709-13
26	01/03/18	10:00	04			TO REFSK-5709-13
27	01/03/18	10:00	04			TO REFSK-5709-13
28	01/03/18	10:00	04			TO REFSK-5709-13
29	01/03/18	10:00	04			TO REFSK-5709-13
30	01/03/18	10:00	04			TO REFSK-5709-13
31	01/03/18	10:00	04			TO REFSK-5709-13
32	01/03/18	10:00	04			TO REFSK-5709-13
33	01/03/18	10:00	04			TO REFSK-5709-13
34	01/03/18	10:00	04			TO REFSK-5709-13
35	01/03/18	10:00	04			TO REFSK-5709-13
36	01/03/18	10:00	04			TO REFSK-5709-13
37	01/03/18	10:00	04			TO REFSK-5709-13
38	01/03/18	10:00	04			TO REFSK-5709-13
39	01/03/18	10:00	04			TO REFSK-5709-13
40	01/03/18	10:00	04			TO REFSK-5709-13
41	01/03/18	10:00	04			TO REFSK-5709-13
42	01/03/18	10:00	04			TO REFSK-5709-13
43	01/03/18	10:00	04			TO REFSK-5709-13
44	01/03/18	10:00	04			TO REFSK-5709-13
45	01/03/18	10:00	04			TO REFSK-5709-13
46	01/03/18	10:00	04			TO REFSK-5709-13
47	01/03/18	10:00	04			TO REFSK-5709-13
48	01/03/18	10:00	04			TO REFSK-5709-13
49	01/03/18	10:00	04			TO REFSK-5709-13
50	01/03/18	10:00	04			TO REFSK-5709-13
51	01/03/18	10:00	04			TO REFSK-5709-13
52	01/03/18	10:00	04			TO REFSK-5709-13
53	01/03/18	10:00	04			TO REFSK-5709-13
54	01/03/18	10:00	04			TO REFSK-5709-13
55	01/03/18	10:00	04			TO REFSK-5709-13
56	01/03/18	10:00	04			TO REFSK-5709-13
57	01/03/18	10:00	04			TO REFSK-5709-13
58	01/03/18	10:00	04			TO REFSK-5709-13
59	01/03/18	10:00	04			TO REFSK-5709-13
60	01/03/18	10:00	04			TO REFSK-5709-13
61	01/03/18	10:00	04			TO REFSK-5709-13
62	01/03/18	10:00	04			TO REFSK-5709-13
63	01/03/18	10:00	04			TO REFSK-5709-13
64	01/03/18	10:00	04			TO REFSK-5709-13
65	01/03/18	10:00	04			TO REFSK-5709-13
66	01/03/18	10:00	04			TO REFSK-5709-13
67	01/03/18	10:00	04			TO REFSK-5709-13
68	01/03/18	10:00	04			TO REFSK-5709-13
69	01/03/18	10:00	04			TO REFSK-5709-13
70	01/03/18	10:00	04			TO REFSK-5709-13
71	01/03/18	10:00	04			TO REFSK-5709-13
72	01/03/18	10:00	04			TO REFSK-5709-13
73	01/03/18	10:00	04			TO REFSK-5709-13
74	01/03/18	10:00	04			TO REFSK-5709-13
75	01/03/18	10:00	04			TO REFSK-5709-13
76	01/03/18	10:00	04			TO REFSK-5709-13
77	01/03/18	10:00	04			TO REFSK-5709-13
78	01/03/18	10:00	04			TO REFSK-5709-13
79	01/03/18	10:00	04			TO REFSK-5709-13
80	01/03/18	10:00	04			TO REFSK-5709-13
81	01/03/18	10:00	04			TO REFSK-5709-13
82	01/03/18	10:00	04			TO REFSK-5709-13
83	01/03/18	10:00	04			TO REFSK-5709-13
84	01/03/18	10:00	04			TO REFSK-5709-13
85	01/03/18	10:00	04			TO REFSK-5709-13
86	01/03/18	10:00	04			TO REFSK-5709-13
87	01/03/18	10:00	04			TO REFSK-5709-13
88	01/03/18	10:00	04			TO REFSK-5709-13
89	01/03/18	10:00	04			TO REFSK-5709-13
90	01/03/18	10:00	04			TO REFSK-5709-13
91	01/03/18	10:00	04			TO REFSK-5709-13
92	01/03/18	10:00	04			TO REFSK-5709-13
93	01/03/18	10:00	04			TO REFSK-5709-13
94	01/03/18	10:00	04			TO REFSK-5709-13
95	01/03/18	10:00	04			TO REFSK-5709-13
96	01/03/18	10:00	04			TO REFSK-5709-13
97	01/03/18	10:00	04			TO REFSK-5709-13
98	01/03/18	10:00	04			TO REFSK-5709-13
99	01/03/18	10:00	04			TO REFSK-5709-13
100	01/03/18	10:00	04			TO REFSK-5709-13

FOR MATL IS: 10343-89

READ MATL BS 3146 PL 1.1974

DRG NO. 1264-04

TO REFSK-5709-13