

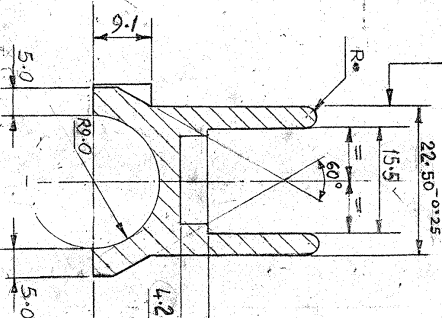
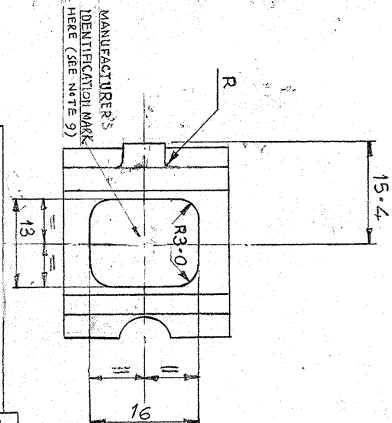
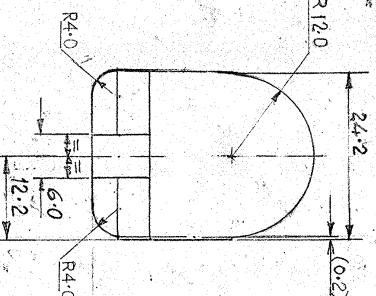
NON-STRESSED COMPT.
(CATEGORY - C)

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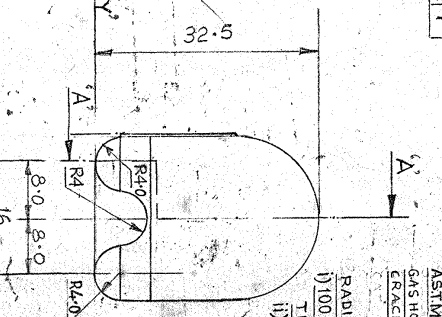
CHEMICAL COMPOSITION - THE STEEL SHALL CONTAIN:-

SLNO	GRADE - C	% MIN.	% MAX
1	CARBON	0.35	0.45
2	SILICON	0.2	0.6
3	MANGANESE	0.4	1.0
4	NICKEL	—	0.4
5	CHROMIUM	—	0.3
6	MOLYBDENUM	—	0.1
7	COPPER	—	0.3
8	SULPHUR	—	0.035
9	PHOSPHORUS	—	0.035

SL. NO 4,5,6&7 SHALL NOT EXCEED 0.80%



SECTION-A-A



NOTE :-

1. DIMMS ARE IN MM.
2. QUANTIFIED DIMMS, TO BE AS PER STD IS 11162-1984 CLASS I OF INVESTMENT CASTING.
3. CASTINGS TO BE FREE FROM DEFECTS LIKE CRACKS, HOT TEARS, COLD SHUTS ETC. AND SURFACE FINISH SHOULD BE SMOOTH.
4. CASTINGS ARE TO BE SUPPLIED IN 'ANNEALED CONDITION WITH 100 - 220 HV 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 THAN 2% OF THE THICKNESS OF THE CASTING.
6. TEST SAMPLES SHOULD BE CAST FROM THE SAME MELT USED FOR MANUFACTURING OF THE CASTING AND SHOULD BE MADE TO SATISFY THE SPECN. IS:10343-1982 AND TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 11.1 SPEC I OF SPECN BS 5146, PH 11/81, GRADE C.
7. SHARP EDGES & BURRS ARE TO BE REMOVED.
8. VISUAL EXAMINATION SHOULD CONFORM TO CLAUSE 8.18.2 OF SPECN IS:10343-1982 AND QALTA L1515, B-2-0, C-2-2.1 OF IS:12550 P11 INSPECTION LEVEL IV.
9. ALL CASTINGS AND REPRESENTATIVE TEST SAMPLES SHALL BE LEGIBLY MARKED WITH MANUFACTURER'S IDENTIFICATION MARK OF 3mm SIZE.

11. RADIOGRAPHIC ACCEPTANCE STANDARD SHALL BE AS PER
ASTM-E-192.

CRACKS, COLD SHUTS, HOT TEARS etc. NOT ACCEPTABLE

RADIOGRAPHIC TEST TO BE CARRIED OUT AS FOLLOWS:
1) 100% FROM SAMPLE LOT FROM EACH SUPPLIER:

ii) 2% FROM SECOND LOT FROM EACH SUPPLIER. THE LOT SHOULD NOT BE LESS THAN 100TONNES.

iii) FROM REEVENSTEIN, BULK SUPPLY DURING THE
PRODUCT IS ESTABLISHED BY THE FOLLOWING:
12-DIAMS. R9.0 AND 15.5 SYMMETRICITY OF
STRICTLY MAINTAINED. PERMISSIBLE
LIMIT 0.25-MAXIMUM MEASURED WITH
REFERENCE TO R9.0

13. 10 TO 15 NOS. SAMPLE CASTINGS, DURY PASSED BY INSPECTOR FOR MATH. DIMS., RADIOGRAPH TEST ETC. ARE TO BE SENT AGAIN, EACH SO TO R/L FOR MACHINING AND FITMENT TRIAL BEFORE BULK SUPPLY.
14. UNSPECIFIED CASTING RADI R/L

VETTE D FORM MAIL ONLY
D/M 25-6-66 3/19

TITLE OF DRG.	INVESTMENT CASTING DRG.

ORDNANCE FACTORY BOARD

RIFLE FACTORY

1 SHAPORE

RIFLE 5.56mm

ARDE SN NO 3143 DET NO 4
DISCART NO 1005 - 009012
SHT 1
OF 1