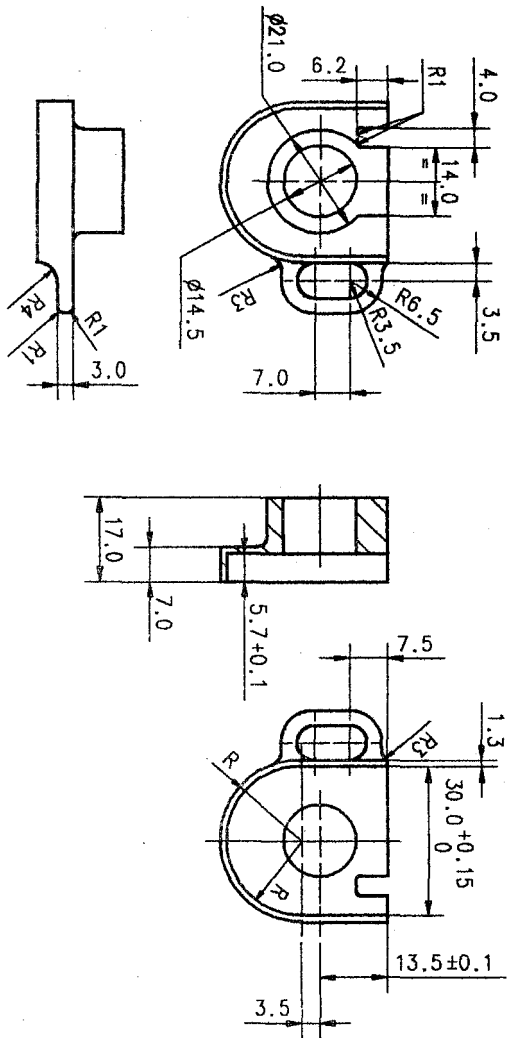




NOTES:-

- 1 ALL DIMS. ARE IN MM.
- 2 UNTOLERANCED DIMS. TO BE AS PER STD. I.S: 11166-1993 CLASS-1 OF INV. CASTING.
- 3 CASTING SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT TEARS, COLD SHUTS ETC. AND SURFACE FINISH MUST BE SMOOTH.
- 4 VISUAL EXAMINATION SHOULD CONFORM TO CLAUSE 8.1 AND 8.2 OF SPECN. I.S:10343-1993
- 5 DECURBURISATION 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. I.S: 10343-1989.
- 7 TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 1.10 SEC-1 OF SPECN. B.S:3146 1974
- 8 SHARP EDGES AND BURRS IF ANY ARE TO BE REMOVED.
- 9 MAGNETIC TEST FOR CRACK DETECTION TO BE CARRIED OUT IN SAMPLES AS PER INSPECTION LEVEL AT A.Q.L.O.65 AS PER I.S:2500 Pt.1, 1992
- 10 MANUFACTURERS SYMBOL WITH 3 mm. SIZE TO BE STAMPED AT 'X' MARK SHOWN IN CASTING.

- 11 RADIOGRAPHIC ACCEPTANCE STANDARD SHALL BE AS PER ASTM-E-192. GAS HOLES & FOREIGN MATL. LEVEL-5, SHRINKAGE LEVEL -3. CRACKS, COLD SHUTS, HOT TEARS ETC. NOT ACCEPTABLE.
- 12 RADIOGRAPHIC TEST TO BE CARRIED OUT AS FOLLOWS:-
100% FROM SAMPLE LOT FROM EACH SUPPLIER. THE LOT SHOULD NOT BE LESS THAN 10 NOS.
- 13 2% FROM SECOND LOT FROM EACH SUPPLIER THE LOT SHOULD NOT BE LESS THAN 100 NOS.
- 14 1% FROM REPEATATIVE/BULK SUPPLY UNTIL THE PRODUCT IS ESTABLISHED BY VENDOR.
- 15 10 TO 15 NOS. SAMPLE CASTING DULY PASSED BY INSPECTOR IN RADIOGRAPH TEST, MATL. DIMS. ETC. TO BE SENT TO THIS FACTORY FOR MACHINING & FITMENT TRIAL BEFORE BULK SUPPLY.
- 16 ALL DRAWING DIMENSIONS TO BE CHECKED AFTER HEAT TREATMENT AS PER RFI GAUGE SCHEDULE.
- 17 THE SUPPLIER WILL MANUFACTURE 02 SETS OF INSPECTION GAUGE AND GET IT VERIFIED BY RFI.
- 18 MACHINABILITY TO BE TESTED BY DRILLING 22.82 HOLE, THROUGH ON ATLEAST 02 SAMPLES.

MATERIAL:- BS:3146 PT 1 1974 TYPE CLA-12 GRADE C		ALL DIMENSIONS ARE IN MILLI METER IMPORTANT DIMENSIONS MARKED THUS Φ INFORMATION MARKED THUS ∇ TO BE MARKED ON	
TITLE OF COMP.	OPERATION	2016	NAME
INVESTMENT CASTING DRG. OF CUP		DGN.	DATE
INDIAN ORDNANCE FACTORIES RIFLE FACTORY ISHAPORE		DRN.	Number
		SCALE	1:1
		OKD.	
		APPD.	
7.62 mm. ASSAULT RIFLE (GHAATAK) CUP (AR/02/1-RFI)		DRG. NO.	RFI SK NO. 9835
		SHEET-	OF-