

I.CI- RFI .SK, 4663					
SL. NO.	AUDIT POINTS	DRG. ZONE	GAUGE NO./METHOD	CLASS OF DEFECT (DCL)	ACCEPTANCE (AQL AS PER IS:2500)
10	20.8	C,D-5	G.E	MINOR	6.5
11	16.0	C-6	-DD-	-DD-	-DD-
12	16.0	D-4	-DD-	-DD-	-DD-
13	19.0	D-6	-DD-	-DD-	-DD-
14	10.3	C-6	-DD-	-DD-	-DD-
15	10.8	C-8	-DD-	-DD-	-DD-
16	2.0	E-7	-DD-	-DD-	-DD-

9 DETAILS OF TESTS/CHECKS & ACCEPTANCE CRITERIA.

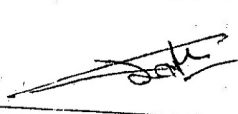
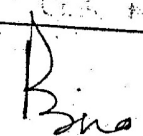
SL. NO.	TEST/CHECK	SAMPLE SIZE	ACCEPTANCE VALUES
I	HARDNESS	LEVEL-III, AQL-1.5.	190 TO 230 H.V.
II	SURFACE FINISH	GENERAL INSPECTION LEVEL-III AQL-1.5.	SMOOTH FINISH.

10 OTHER TESTS:-

- I) MAGNETIC TEST FOR CRACK DETECTION TO BE CARRIED OUT AS PER LEVEL-III, AQL-0.65. IS:2500:2000.
- II) RADIO GRAPHIC TEST :- 5% OF EACH CAST/HEAT.
(ASTM E192).
(VERIFIED FROM NABL LAB.

NOTE:-

- 1) PHYSICAL PROPERTIES & OTHER TESTS AS PER REQUIREMENT OF RELEVANT SPECN.
- 2) TEST REPORT IS TO BE ISSUED FROM NABL APPROVED LAB./DGQA LAB./DGQA APPROVED LAB./ORDNANCE FACTORIES LAB.
- 3) RECORD OF TEST REPORT WITH REFERENCE TO MIS NO. ARE TO BE MAINTAINED.
- 4) ENSURE MARKING OF MANUFACTURER'S CODE ON THE STORE SUITABLY & ENTRY OF LOT NO. & YEAR OF MANUFACTURE IN PRE INSPECTION REPORT.
- 5) TEST PIECES (CAST ALONG WITH THE COMPONENT) AS SPECIFIED IN THE GOVERNING SPECN. ARE TO BE SUBMITTED FOR CHECKING CHEMICAL COMPOSITION & MECHANICAL PROPERTIES.

APPROVED		
	RFI	SQAE(SA)