

NOTES:-

- 1 ALL DIMS ARE IN mm.
- 2 UNFURNISHED DIMS TO BE AS PER STD. I.S. 1186-1993 CLASS-1 OF INVESTMENT CASTING.
- 3 CASTING SHOULD BE FREE FROM DEFECTS LIKE CRACKS, WARPAGE HOT TEARS COLD SHOTS BLOW HOLES ETC. AND SURFACE FINISH SHOULD BE SMOOTH.
- 4 VISUAL EXAMINATION SHOULD CONFORM TO GAUGE B.1 AND B.2 OF SPECN. I.S. 10343-1999 AND A.O.L. 2.5 OF I.S. 2500 Pt. 1 INSPECTION LEVEL IV.
- 5 CASTINGS TO BE SUPPLIED IN HEAT TREATED CONDITION I.E. ANNEALING OR NORMALISING FOLLOWED BY HARDENING & TEMPERING SUITABLE TEMP. TO GIVE THE MECHANICAL PROPERTIES SPECIFIED IN THE DRAWING. HARDNESS OF 248-302 HB SHOULD BE ACHIEVED AFTER HARDENING & TEMPERING.
- 6 DECARBURISATION SHOULD NOT BE MORE THAN 1% OF THE THICKNESS OF THE CASTING.
- 7 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. 10343-1999. RESULT OF THE TEST SHOULD BE FURNISHED ALONG WITH I-NOTE
- 8 TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 1:10 SEC-1 OF SPECN. B.S. 3146 Pt. 1, 1974.
- 9 ALL SHARP EDGES AND BURRS IF ANY ARE TO BE REMOVED.
- 10 MAGNETIC TEST FOR CRACK DETECTION TO BE CARRIED OUT IN SAMPLES AS PER INSPECTION LEVEL IV AT A.O.L. 0.65 AS PER I.S. 2500 Pt. 1, 1992
- 11 MANUFACTURERS SYMBOL WITH 3 mm. SIZE TO BE STAMPED AS SHOWN IN CASTING.
- 12 RADIOGRAPHIC ACCEPTANCE STANDARD SHALL BE AS PER ASTM-E-192 GAS HOLES & FOREIGN MATL LEVEL-5, SHRINKAGE LEVEL -3 CRACKS, COLD SHOTS, HOT TEARS ETC. ARE NOT ACCEPTABLE.

RADIOGRAPHIC TEST TO BE CARRIED OUT AS FOLLOWS:-

- i) 100% FROM SAMPLE LOT FROM EACH SUPPLIER. THE LOT SHOULD NOT BE LESS THAN 10 NOS.
- ii) 5% FROM REPEATATIVE/BULK SUPPLY UNTIL THE PRODUCT IS ESTABLISHED BY THE VENDOR.
- iii) 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.
- 14 INKATE TRACE TO BE REMOVED BY MACHINING FROM CASTING TO CONFORM DRAWING GEOMETRY.
- 15 TEST PIECE TO BE EXAMINED FOR TENSILE STRENGTH, 1200 VALUE. HARDNESS OF 248-302 HB AFTER HARDENING & TEMPERING.
- 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 Ø2 HOLES, THROUGH ON ATLEAST 02 SAMPLES.
- 19 THE SUPPLIER WILL MANUFACTURE 02 SETS OF INSPECTION GAUGE AND GET IT VERIFIED BY RFI.

MATERIAL:

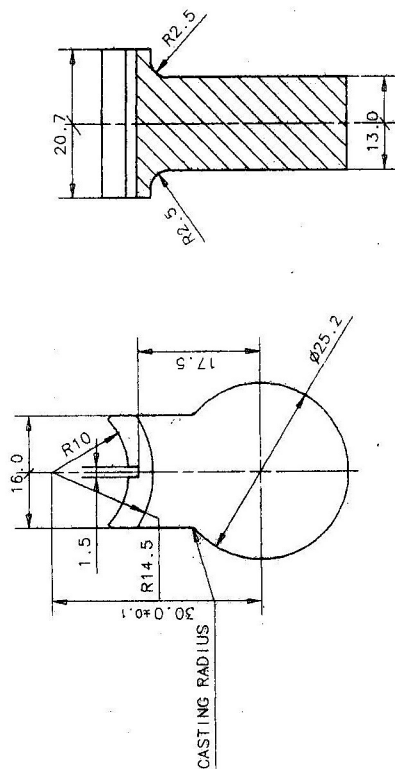
BS: 3146 Pt. 1 1974 TYPE CLA 5 Grade A

HEAT TREATMENT: 250-300 VPN

Jwm/V. Cell

23/3/99

Jm



INDIAN ORDNANCE FACTORIES RIFLE FACTORY ISHAPORE

2013	NAME	DATE
DRAWN	M. M. KARNADAR	22.8.19
CHECKED		
APPROVED	Jt. GM/O	
DRAWING NUMBER	RFI, SK-8972-G	
SHEET	OF	

APPROVED BY
JWM/SC/MS

12 BORE PUMP ACTION GUN
1 C MAGAZINE TUBE LOCKING HOLDER

