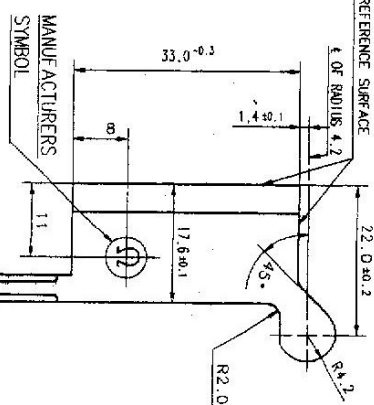
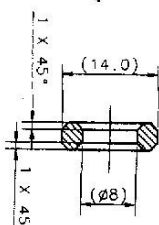
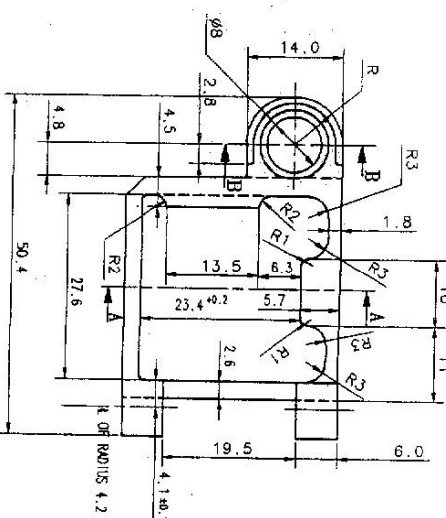
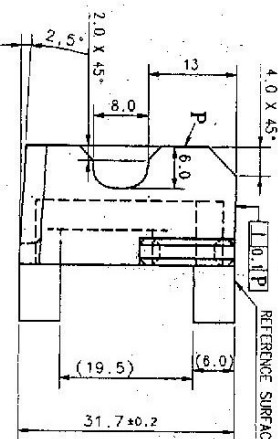
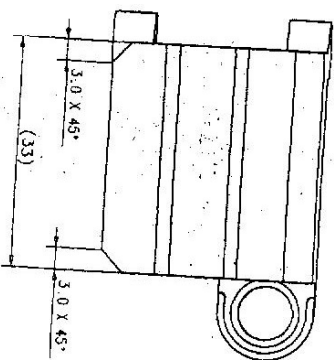
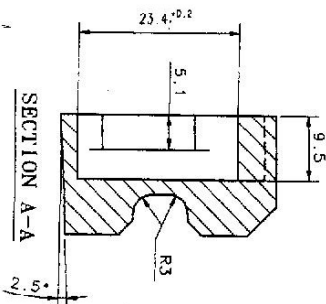


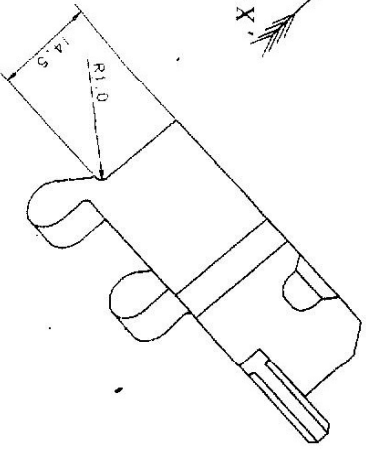
REFERENCE SURFACE
4.0 OF RADIUS 4.2



SECTION A-A



PART SECTION B-B



VIEW AT 'X'

HOS/MPM
DRAWING NO. / CERTIFIED COPY OF
DRG. NO. / DATE / SCHEDULE
RIFLE / AT THIS DATE 16-11-17
RIFLE FACTORY, ISHAPUR

NOTES:-

GROUP-C

1. ALL DIMS. ARE IN mm.
2. UNDIMENSIONED DIMS. TO BE AS PER STD. 1.5.11166-1984 CLASS-1 OF 1st CASTING.
3. CASTING SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT TEARS, COLD SHOTS ETC. AND SURFACE FINISH MUST BE SMOOTH.
4. VISUAL EXAMINATION SHOULD CONFORM TO GAUGE 8.1 AND 8.2 OF SPEC. 1.5.10343-1982 AND A.Q.1.2.5 OF 1.5.2500 P.L.1 INSPECTION LEVEL III.
5. CASTINGS ARE TO BE SUPPLIED IN ANNEALED CONDITION WITH 190-230 HV ALONG WITH TEST SAMPLES TO BE TESTED FOR HARDNESS AT ANNEALED CONDITION AND ALSO AFTER FINAL HEAT TREATMENT.
6. DECORATION SHOULD NOT BE MORE THAN 2% 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 SPEC. 1.5.10343-1989.
8. TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 1.10 SEC-1 OF SPEC. 8.5.3146 P.L.1974 OR C.
9. SHARP EDGES AND BORES 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.Q.1.0.65 AS PER 1.5.2500 P.L.1, 1992.
11. MANUFACTURERS SHALL WITH 3 mm. SIZE TO BE STAMPED AS SHOWN IN CASTING.
12. RADIOGRAPHIC ACCEPTANCE STANDARDS SHALL BE AS PER ASTM E-172 LAS HOLES & TORSION MTL. LEVEL-5. SPRINGING LEVEL-3. CRACKS, COLD SHOTS, HOT TEARS ETC. NOT ACCEPTABLE.
13. RADIOGRAPHIC TEST TO BE CARRIED OUT AS FOLLOWS:-
(i) 2% FROM SAMPLE LOT FROM EACH SUPPLIER. THE LOT SHOULD NOT BE LESS THAN 10 NOS.
(ii) 2% FROM SECOND LOT FROM EACH SUPPLIER. THE LOT SHOULD NOT BE LESS THAN 100 NOS.
(iii) 1% FROM REPELATIVE/BULK SUPPLY UNTIL THE PRODUCT IS ESTABLISHED BY VENDOR.
14. INGATE TRACE TO BE REMOVED BY MACHINING FROM CASTING TO CONFORM DRAWING GEOMETRY.

10 TO 15 NOS. SAMPLE CASTING DULY PASSED BY INSPECTOR IN RADIOGRAPH TEST MTL. DIMS. ETC. TO BE SENT TO THIS FACTORY FOR MACHINING & FITMENT TRIAL BEFORE BULK SUPPLY.

UPDATED AS ON 29-07-2016 ON THE BASIS OF FEED BACK FROM USER SECTION AND SUPPLIERS

MATERIAL:- B.S. 3146 P.L.1974 TYPE
CLA 5 GRADE-A

ALL DIMS. ARE IN mm.

INDIAN ORDNANCE FACTORIES	SCALE:-	2:1	DRG. NO.:-
RIFLE FACTORY	2:1	DRG. NO.:-	RF1/SK. 7596
ISHAPUR	2:1	DRG. NO.:-	RF1/SK. 7596
RIFLE 5.56 mm. EXCALIBUR MK1	2:1	DRG. NO.:-	RF1/SK. 7596
1. C FOR CONNECTOR BUTT EXR	2:1	DRG. NO.:-	RF1/SK. 7596

SHEET 1 OF 1