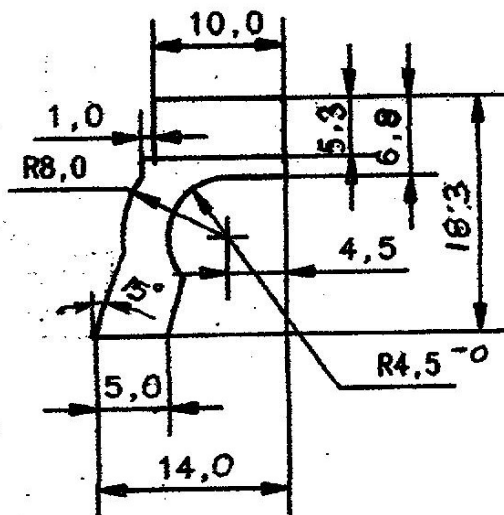
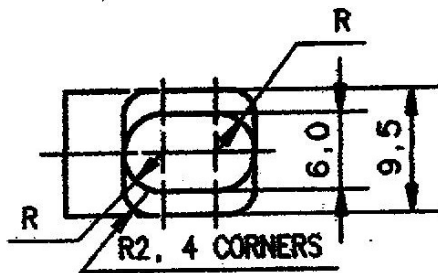




प्रमाणित प्रति / CERTIFIED COPY OF
 ड्राइंग / लेआउट / गेज शिड्यूल HOS/MPM
 DRG/LAYOUT/GAUGE SCHEDULE
 दिनांक / AT THIS DATE. 14.10.17
 सी डी डी / CDD
 राइफल फैक्टरी, ईशापुर
 RIFLE FACTORY, ISHAPORE

SEEN & OK

JWM/CNC-1 / 03.12.17

NOTES:-

- 1 ALL DIMS. ARE IN mm.
- 2 UNTOLERANCED DIMS. TO BE AS PER STD. I.S. 11106-1984 CLASS-1 OF INV. 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. I.S. 10343-1982 AND A.O.I. 2.5 OF I.S. 2500 Pt.1 INSPECTION LEVEL IV.
- 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 DECORUMISATION 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. I.S. 10343-1980.
- 8 TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 1:10 SEC-1 OF SPEC. B.S. 3146 Pt.1974 Gr.C.
- 9 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 AT A.O.I. 0.05 AS PER I.S. 2500 Pt.1, 1982.
- 11 MANUFACTURERS SYMBOL WITH 3 mm. SIZE TO BE STAMPED AS SHOWN IN CASTING.
- 12 RADIOGRAPHIC ACCEPTANCE STANDARD SHALL BE AS PER ASTM-E-112, GAS HOLES & FOREIGN MATL. LEVEL-5, SHRINKAGE LEVEL -3, CRACKS, COLD SHOTS, HOT TEARS ETC. NOT ACCEPTABLE.
- i) RADIOGRAPHIC TEST TO BE CARRIED OUT AS FOLLOWS:-
 100% 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 REPEATATIVE/BULK SUPPLY UNTIL THE PRODUCT IS ESTABLISHED BY VENDOR.
- 13 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 INGATE TRACE TO BE REMOVED BY MACHINING FROM CASTING TO CONFORM MOUNTING GEOMETRY.
- 15 TEST PIECE TO BE EXAMINED FOR TENSILE STRENGTH, 1200 VALUE, HARDNESS OF 240-302 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 02 HOLES, THROUGH OR ATLEAST 02 SAMPLES.

MATERIAL:

STEEL BS:3146 PART I 1974 CLASS 5 GRADE A.

TITLE OF	OPERATION NO.		2013	NAME	DATE
			DGN.	M.M.KARMAKAR	11-11-13
			DRN.		
			CKD.		
ORDNANCE FACTORY BOARD RIFLE FACTORY ISHAPORE		SCALE	APPD.		
INVESTMENT CASTING TRIGGER LOCKING BRACKET 12 BORE PUMP ACTION GUN			DRG No.		
			RFI SK 9102		
			SHEET OF		

Updated on 01.04.2016.