

INDIGENOUS MATERIAL

- ⑤ IS 10343 Gr. 4E OR IS 3146 PL 17.1 TYPE CLA-5 GRADE #
- ⑥ IS 10343 Gr. 4E CASTING TO BE HEAT-TREATED TO ACHIEVE 41.5/51.5 HRC SEPARATELY CAST TEST BARS SHALL MEET THE SPECIFIED MECH. PROPERTIES INCLUDING IZOD IMPACT VALUE 14J MIN.

RADIOGRAPHIC TEST

- (a) RADIOGRAPHIC ACCEPTANCE STANDARD OF THE CASTING SHOULD BE AS PER ASTM-E-192
- (b) 100% OF THE ADVANCE SAMPLE (NOT LESS THAN 5) WILL BE SUBJECTED TO RADIOGRAPHIC TEST.
- (c) RADIOGRAPHIC TEST OF ADVANCE SAMPLE WILL BE CARRIED OUT BY CQA(MET) ICHAPUR.

OR

THE AREA QUALITY ASSURANCE OFFICER CONCERNED WOULD GET THE RADIOGRAPHIC TEST DONE IN HIS PRESENCE AND FORWARD THE PLATES TO TO CQA (MET) ICHAPUR FOR SENTENCE AND APPROVAL OF THE MOULD.

(d) BULK PRODUCTION WOULD COMMENCE ONLY AFTER MOULD AND MATERIAL HAS BEEN APPROVED BY CQA(MET) ICHAPUR.

(e) 5% OF THE CASTING SELECTED AT RANDOM FROM ^{THE} BULK WOULD BE SUBJECTED TO RADIOGRAPHIC TEST. THIS MAY BE DONE UNDER THE ARRANGEMENT OF THE AREA QUALITY ASSURANCE OFFICER AND SENTENCE MAY BE AWARDED BY HIM BASED ON THE STANDARD OF THE ADVANCE SAMPLES CLEARED BY CQA(MET) ICHAPUR.

REF. :- CONTROLLERATE OF QUALITY ASSU(W) JABALPUR LETTER NO. 50431/CQAW/QA-11 DATED 14 MARCH 95.

GUIDELINES FOR PROCUREMENT AND INSPECTION OF INVESTMENT CASTING. REF. CONTROLLERATE OF QUALITY ASSURANCE (METALS) LETTER NO. MQA-1/QA1/1.2 DATED 05-MAY '94.

CONTROLLERATE OF QUALITY ASSU(M) ICHAPUR L. NO. MQA-3/LIN/3/W Dt. 03 MAY 1995

- ⑤ MATL. : 23 X GC 2. M Φ 74 MECH. PROPERTIES :- ULTIMATE STRENGTH 130 Kgf/mm² AND YIELD STRENGTH 110 Kgf/mm² ARE ALSO BE ACCEPTABLE.

⑥ INDIGENOUS MATERIAL: IS 10343 Gr 4E WITH C.Y. 0.45-0.50 AND MECHANICAL PROPERTIES SPECIFIED IN THE SPECIFICATION FOR THE GRADE AUTHORITY: CQA(METALS) ICHAPUR LY. NO. MQA-3/ITS/B/2 Dt. 6/11-6-97

G ⑥	DA No. 052/97 Dt 11-8-97	S. 11/8/97
UPDATED.	DA No. 022/97 Dt. 23-3-97	23/3/97
⑥ F	DA No. 67/95 Dt. 2-8-95	
⑥ E	DA. 020/95 Dt. 11-4-95	Sadhi 11-4-95
AMENDMENTS	DESCRIPTIONS	SIG. & DATE

MATEL:-

IS:10343-1999 Gr.19Q

DA.No. 008/14 Dt.04.12.2014
REF.Lr. No. 2B1/304/CQAW/BMP-II/MATL. Dt. 07.11.2014

SHEETS 2/2	APPROVED	<i>[Signature]</i> 12-4-95 W/M/MV	ORDNANCE FACTORY	COMPONENT NO. 2A42-05-21 & 2A42-05-024 RH & LH FEED PAWLS
DRAWN <i>Sadhi</i> 11-4-95	CHECKED	<i>[Signature]</i> 12-4-95 1/C.30mm D&DO	TIRUCHIRAPALLI	DRG. NO. 64C 5021 250G 3