

SHOWN RITE/CERTIFIED COPY OF
डाईग/लेआउट/गेज चिह्नपत्र H03/MPM
DRG/LAYOUT/GAUGE SCHEDULE
दिनांक/AT THIS DATE 29-10-17
सी डी डी/CDD
राइफल फॅक्टरी, ईशपूर
RIFLE FACTORY, ISHAPUR

SEEN & OK

JWM/CNC-1

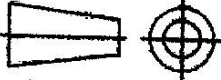
03.12.13

NOTES:-

1. ALL DIMS. ARE IN mm.
2. TOLERANCED DIMS. TO BE AS PER STD. I.S; 11166-1984 CLASS-1 OF INV. CASTING.
3. CASTING SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT TEARS, COLD SHOTS ETC. AND SURFACE FINISH MUST BE SATISFACTORY.
4. VISUAL EXAMINATION SHOULD CONFORM TO GAUGE B.1 AND B.2 OF SPECN. I.S: 10345-1982 AND A.Q.L. 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. DECARBURISATION 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 SPECN. I.S: 10343-1989.
8. TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 1:10 SEC-1 OF SPECN. 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.Q.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. NOT ACCEPTABLE.
13. 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) 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.
14. 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.
15. INGATE TRACE TO BE REMOVED BY MACHINING FROM CASTING TO CONFORM DRAWING GEOMETRY.
16. TEST PIECE TO BE EXAMINED FOR TENSILE STRENGTH, 1200 VALUE, HARDNESS OF 248-302 HB AFTER HARDENING & TEMPERING.
17. ALL DRAWING DIMENSIONS TO BE CHECKED AFTER HEAT TREATMENT AS PER RFI GAUGE SCHEDULE.
18. THE SUPPLIER WILL MANUFACTURE 02 SETS OF INSPECTION GAUGE AND GET IT VERIFIED BY RFI.
19. MACHINABILITY TO BE TESTED BY DRILLING Ø2 HOLES, THROUGH ON ATLEAST 02 SAMPLES.

MATERIAL:

STEEL BS: 3146 PART 1 1974 CLASS 5 GRADE A

TITLE OF	OPERATION NO.		2013	NAME	DATE
ORDNANCE FACTORY BOARD RIFLE FACTORY ISHAPORE		SCALE	DGN.	M.M.KARMAKAR	17-11-13
			DRN.		
			CKD.		
			APPD.		2/12
INVESTMENT CASTING SLIDING KNOB 12 BORE PUMP ACTION GUN			DRG No. RFI SK 9101		
			SHEET OF		