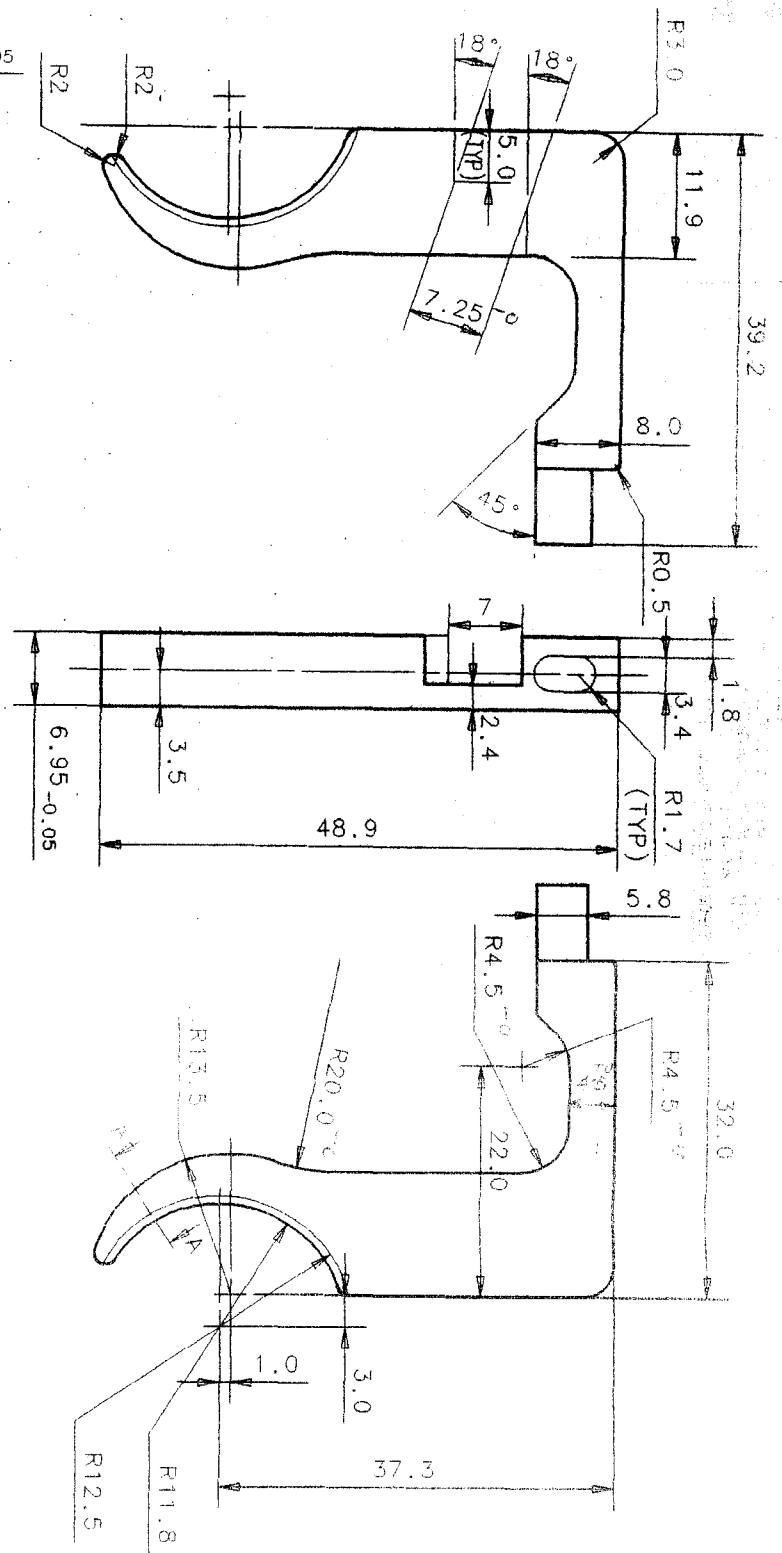




SECTION A-A

405/MPM

प्रमाणित प्रति / CERTIFIED COPY OF
ड्राइंग / ड्राइंग / गेज चिह्नित
DRA/LAYOUT/GAUGE SCHEDULE
दिनांक / AT THIS DATE: 09-08-14
श्री सी.डी./CDD - 82
इशपूर कारखाना, इशपूर
RIFLE FACTORY, ISHAPUR

SEEN & OK
JWM/CNG-1

MATERIAL:

6513146 PART 1 1075 CLASS 5 GRADE A

TITLE OF		OPERATION NO.		2013	NAME	DATE
ORDNANCE FACTORY BOARD				DEN.	M. M. KAMARKAR	11-11-13
RIFLE FACTORY				DEN.		
ISHAPUR				SCALE		
INVESTMENT CASTING				CDD.		
TRIGGER				APPD.		
				DRG No.		

NOTES:-

- 1 ALL DIMS. ARE IN MM.
- 2 UNDIMENSIONED DIMS. TO BE AS PER STD. I.S. 1116-1984 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 A.1 AND A.2 OF SPECN. I.S. 10343-1982 AND A.O.L. 2.5 OF I.S. 2200 P.1.1 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 REORGANISATION 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 PL. 1974 OR C. SHARP EDGES AND BIRDS IF ANY ARE TO BE REMOVED.
- 9 MAGNETIC TEST FOR CRACK DETECTION TO BE CARRIED OUT IN SAMPLES AS PER INSPECTION LEVEL AT A.O.L. 0.65 AS PER I.S. 2500 PL. 1.1 1992.
- 10 MANUFACTURERS SYMBOL WITH 3 mm. SIZE TO BE STAMPED AS SHOWN IN CASTING.
- 11 RADIOGRAPHIC ACCEPTANCE STANDARD SHALL BE AS PER ASTM E-192 GAS HOLES & FOREIGN MAT. LEVEL-5, SHRINKAGE LEVEL -3, CRACKS, COLD SHOTS, HOT TEARS ETC. NOT ACCEPTABLE.
- 12 RADIOGRAPHIC TEST TO BE CARRIED OUT AS FOLLOWS:- 100% FROM SAMPLE LOT FROM EACH SUPPLIER. THE LOT SHOULD NOT BE LESS THAN 10 NOS.
- 13 1) 2% FROM SECOND LOT FROM EACH SUPPLIER THE LOT SHOULD NOT BE LESS THAN 100 NOS.
- 14 2) 2% FROM REPEATATIVE BULK SUPPLY UNTIL THE PRODUCT IS ESTABLISHED BY VENDOR.
- 15 13 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.
- 16 14 INHATE TRACE TO BE REMOVED BY MACHINING FROM CASTING TO CONFORM DRAINING GEOMETRY.
- 17 15 TEST PIECE TO BE EXAMINED FOR TENSILE STRENGTH, 1200 VALUE, HARDNESS OF 240-302 HB AFTER MACHINING & TEMPERING.
- 18 16 ALL DRAWING DIMENSIONS TO BE CHECKED AFTER HEAT TREATMENT AS PER RFI GAUGE SCHEDULE.
- 19 17 THE SUPPLIER WILL MANUFACTURE 02 SETS OF INSPECTION GAUGE AND GET IT VERIFIED BY RFI.
- 20 18 MACHINABILITY TO BE TESTED BY DRILLING 42 HOLES, THROUGH ON ATLEAST 02 SAMPLES.

RFI SK 9100