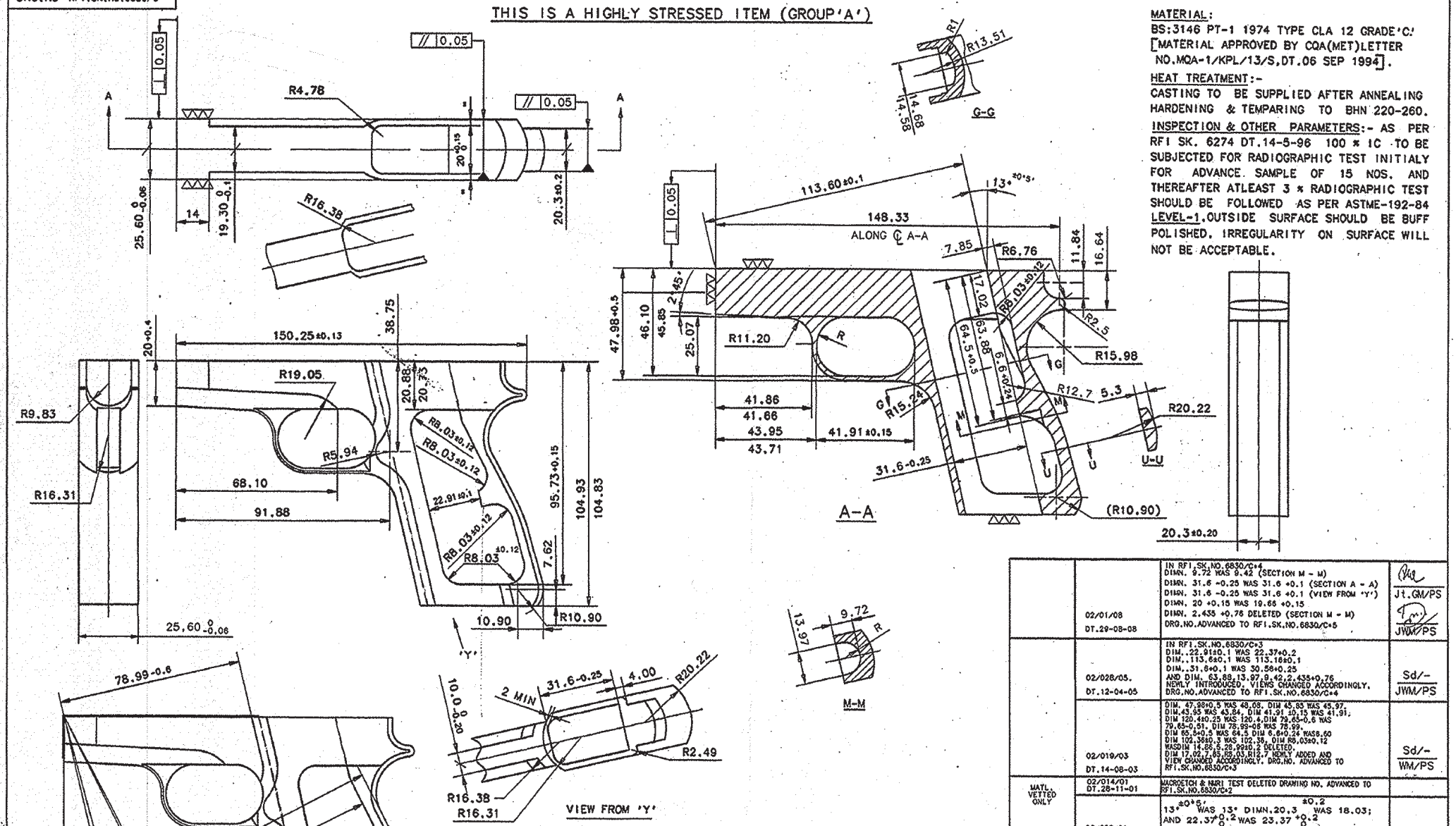
DRG.NO- RFI.SK.NO.6830/C*5

THIS IS A HIGHLY STRESSED ITEM (GROUP'A')



MATERIAL:
BS:3146 PT-1 1974 TYPE CLA 12 GRADE'C' [MATERIAL APPROVED BY CQA(MET)LETTER NO.MQA-1/KPL/13/S,DT.06 SEP 1994].

HEAT TREATMENT:-
CASTING TO BE SUPPLIED AFTER ANNEALING HARDENING & TEMPARING TO BHN 220-260.

INSPECTION & OTHER PARAMETERS:- AS PER RFI SK. 6274 DT.14-5-96 100 % IC TO BE SUBJECTED FOR RADIOGRAPHIC TEST INITIALY FOR ADVANCE SAMPLE OF 15 NOS. AND THEREAFTER ATLEAST 3 % RADIOGRAPHIC TEST SHOULD BE FOLLOWED AS PER ASTME-192-84 LEVEL-1.OUTSIDE SURFACE SHOULD BE BUFF POLISHED. IRREGULARITY ON SURFACE WILL NOT BE ACCEPTABLE.

	02/01/08 DT.29-08-08	IN RFI.SK.NO.6830/C*4 DIMN. 9.72 WAS 9.42 (SECTION M - M) DIMN. 31.6 -0.25 WAS 31.6 +0.1 (SECTION A - A) DIMN. 31.6 -0.25 WAS 31.6 +0.1 (VIEW FROM 'Y') DIMN. 20 +0.15 WAS 19.66 +0.15 DIMN. 2.435 +0.76 DELETED (SECTION M - M) DRG.NO.ADVANCED TO RFI.SK.NO.6830/C*5	Jt.GM/PS JWM/PS
	02/028/05. DT.12-04-05	IN RFI.SK.NO.6830/C*3 DIM.,22.91±0.1 WAS 22.37+0.2 DIM.,113.6±0.1 WAS 113.16±0.1 DIM.,31.6+0.1 WAS 30.56+0.25 AND DIM. 63.88,13.97,9.42,2.435+0.76 NEWLY INTRODUCED. VIEWS CHANGED ACCORDINGLY. DRG.NO.ADVANCED TO RFI.SK.NO.6830/C*4	Sd/- JWM/PS
	02/019/03 DT.14-08-03	DIM. 47.98+0.5 WAS 48.03. DIM 45.85 WAS 45.97 DIM.43.95 WAS 43.54, DIM 41.91 ±0.15 WAS 41.91; DIM 120.4±0.25 WAS 120.4,DIM 79.65-0.6 WAS 79.65-0.51. DIM 78.99-06 WAS 78.99. DIM 65.6+0.5 WAS 64.5 DIM 6.6+0.24 WAS6.50 DIM 102.3680.3 WAS 102.38, DIM R0.0080.12 WASDIM 14.86,5.28,99±0.2 DELETED. DIM 17.02,7.85,R8.03,R12.7 NEWLY ADDED AND VIEW CHANGED ACCORDINGLY. DRG.NO. ADVANCED TO RFI.SK.NO.6830/C*3	Sd/- WM/PS
MATL. VETTED ONLY	02/014/01 DT.28-11-01	MACRODTCH & NDRI TEST DELETED DRAWING NO. ADVANCED TO RFI.SK.NO.6830/C*2	
	02/008/01 DT.15-9-01	13° ±0°5' WAS 13° DIMN.20.3 ±0.2 WAS 18.03; AND 22.37 +0.2 -0.2 WAS 23.37 +0.2 -0.2 DIM.20.98 ±0.2 ;5.28 & 14.86 NEWLY ADDED. DRG.NO.ADVANCED TO RFI SK.NO.6830/C*	
sd/- DAQAO	DC/RFI/NO	AMENDMENT	SIGNATURE

FOR UNTOLERATED DIMENSIONS IS:11166-1993,CLASS-1 TO BE FOLLOWED. SQUARENESS & 13°±0°5' ANGLE TO BE MAINTAINED.

DRG.PREPARED AS PER MEMO NO.- PS/CNC/06 DT.17-03-2001 FROM JWM/PS THROUGH WM/PS AND JT.GM/PS WITH MARKED RFI.SK.6830.

DRG.AMENDED AS PER MEMO NO.JWM/MPM-II/NO.BS00200059/RFI/9mm/MPM-II DATED 17-06-03 AND MEMO OF JWM/PS.NO./PS/25/DO.DT.04-08-03. AND PROPOSED BY M/S UNIDERITEND LIMITED,THANE,WITH RECTIFIED COPY OF RFI.SK.NO.6830/C*2

AS PER LETTER NO.-PS/25/DEV/01 DATED 9/4/2005,DRG. RFI.SK.NO.7650(EXPTL) WAS PREPARED AS PER MEMO NO.-PS/CNC/06. DATED 17/3/2001 FROM JWM/PS THROUGH WM/PS AND Jt.GM/PS WITH MARKED RFI.SK.6830/C*3 AND THE FINAL DRAWING HAS BEEN PREPARED (RFI.SK.NO.-6830/C*4 BASED ON THAT EXPTL. DRG.

DRAWING AMMENDED AND DRG. NO. ADVANCED TO RFI SK 6830/C*5 AS PER JWM/PS (THROUGHAWM/PS & JT.G.M./PS) LETTER NO. PS/CNC/BODY/DRG/08 DATED 14-08-2008.

MATERIAL SEE NOTES			ALL DIMENSIONS ARE IN MILLIMETER IMPORTANT DIMENSIONS ARE MARKED THUS ⊕ INFORMATION MARKED THUS ☆ TO BE MARKED ON	
TITLE OF	OPERATION	2008	NAME	DATE
INVESTMENT CASTING		DGN		
		DRN	R.CHAKRABORTY	29-08-08
ORDNANCE FACTORY BOARD RIFLE FACTORY ISHAPORE	SCALE 1:1	CKD		
		APPD		29/08/08
PISTOL AUTO 9mm 1A BODY [DS. CAT. NO. 1005-003145]		DRG.NO. RFI.SK.6830/C*5		
		SHEET NO:- 1	NO OF:- 1	