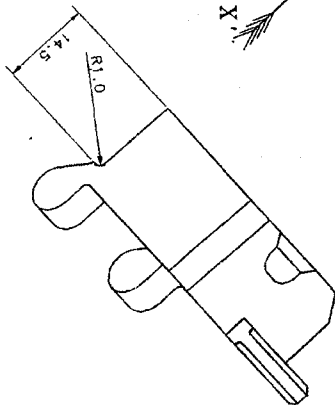


PART SECTION B-B



VIEW AT 'X'

HOS/M/M

22/5/77

NOTES:-

- 1 ALL DIMS. ARE IN MM.
- 2 UNWORKED DIMS. TO BE AS PER STD. I.S. 1116-1984 CLASS-1 OF HV CASTING.
- 3 CASTING SHOULD BE FREE FROM DEFECTS, LINGERS, HOT TEARS, COLD SHOTS ETC. AND SURFACE FINISH MUST BE SMOOTH.
- 4 VISUAL EXAMINATION SHOULD CONFORM TO CLAUSE 8.1 AND 8.2 OF SPEC. I.S. 1034-1982 AND A.O.L. 2.5 OF I.S. 2500 P.I. 1,1992.
- 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 BROMINATION 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. 1034-1982.
- 8 TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 1:10 SEP-1 OF SPEC. B.S. 3146 P.I. 1974 OR 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 IV AT A.O.L. 65 AS PER I.S. 2500 P.I. 1,1992.
- 11 MANUFACTURERS MARK WITH 3 mm. SIZE TO BE STAMPED AS SHOWN IN CASTING.
- 12 RADIOGRAPHIC ACCEPTANCE STANDARD SHALL BE AS PER ASTM-E-192 GAS HOLES & FORES (ON VOLT. LEVEL-5), SHRINKAGE LEVEL -3, CRACKS, COLD SHOTS, HOT TEARS ETC. NOT ACCEPTABLE.
- 13 RADIOGRAPHIC TEST TO BE CARRIED OUT AS FOLLOWS:-
 (i) 2% FROM SECOND LOT FROM EACH SUPPLIER; THE LOT SHOULD NOT BE LESS THAN 100 NOS.
 (ii) 1% FROM REMAINING BULK SUPPLY UNTIL THE PRODUCT IS ESTABLISHED BY VENDOR.
 (iii) 1% INGALE TRACE TO BE REMOVED BY MACHINING FROM CASTING TO CORRECT DRAWING GEOMETRY.

10 TO 15 NOS. SAMPLE CASTING DULY PASSED BY INSPECTOR IN RADIOGRAPH TEST, MNTL. DIMS. ETC. TO BE SENT TO THIS FACTORY FOR MACHINING & FITMENT TRIAL BEFORE BULK SUPPLY.

MATERIAL:- B.S. 3146 P.I. 1,1974 TYPE
CLASS GRADE-A

ALL DIMS. ARE IN MM.

2009	NAME	DATE
DRN.	J. CHAK	07-10
OKD.	D. B. SINGH	J.M.C.D.B.
APPD.	SHRI KUMAR	MWASRY

INDIAN ORDNANCE FACTORIES
RIFLE FACTORY
ISHAPUR

SCALE:- 2:1

RIFLE 5.56 mm. EXCALIBUR MK1
I.C. FOR CONNECTOR BUTT EXP

DRG. NO.:-
RFI/SK. 7593

SHEET 11 OF 1