



NOTES:-

- 1 ALL DIMS. ARE IN MM.
- 2 UNDRANGED DIMS. TO BE AS PER STD. I.S. 1166-1984 CLASS-1 OF HW. 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 8.1 AND 8.2 OF SPEC. I.S. 10343-1989 AND A.O.L. 2.3 OF I.S. 2260 P.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 SPEC. I.S. 10343-1989.
- 8 TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 1.10 SEC-1 OF SPEC. B.S. 3146 PL. 1974 Gr. C. SHARP EDGES AND BURS 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. 2590 PL. 1, 1982.
- 10 MANUFACTURERS SHOULD 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:- 10% FROM SAMPLE LOT FROM EACH SUPPLIER THE LOT SHOULD NOT BE LESS THAN 10 NOS.
- 13 2% FROM SECOND LOT FROM EACH SUPPLIER THE LOT SHOULD NOT BE LESS THAN 100 NOS.
- 14 1% FROM REPEATATIVE/BULK SUPPLY UNTIL THE PRODUCT IS ESTABLISHED BY VENDOR.
- 15 10 TO 15 NOS. SAMPLE CASTING DAILY PASSED BY INSPECTOR IN RADIOGRAPH TEST, MAT. DIMS, ETC. TO BE SENT TO THIS FACTORY FOR MACHINING & FITMENT TRIAL BEFORE BULK SUPPLY.
- 16 INMATE TRACE TO BE REMOVED BY MACHINING FROM CASTING TO CONFORM DRAWING GEOMETRY.
- 17 TEST PIECE TO BE EXAMINED FOR TENSILE STRENGTH, 120° VALUE, HARDNESS OF 240-302 HB AFTER HARDENING & TEMPERING.
- 18 ALL DRAWING DIMENSIONS TO BE CHECKED AFTER HEAT TREATMENT AS PER RTI GAUGE SCHEDULE.
- 19 THE SUPPLIER WILL MANUFACTURE 02 SETS OF INSPECTION GAUGE AND GET IT VERIFIED BY RTI.
- 20 MACHINABILITY TO BE TESTED BY DRILLING 40 HOLES, THROUGH ON ATLEAST 02 SAMPLES.

SEEN & OK
JWM/CNG-1

405/M2M

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 DRAWING / GAUGE SCHEDULE
 ड्राइंग / AT THIS DATE: 09-08-16
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 RIFLE FACTORY, ISHAPORE

MATERIAL: 651346 PART 2 1974 CLASS 5 GRADE A.

TITLE OF	OPERATION NO.	2013	NAME	DATE
ORDNANCE FACTORY BOARD		DRN.	M. M. KARBARKAR	11-11-13
RIFLE FACTORY		APPD.		
ISHAPORE				

TITLE OF	OPERATION NO.	SCALE	APPD.	DRG No.
ORDNANCE FACTORY BOARD				
RIFLE FACTORY				
ISHAPORE				

INVESTMENT CASTING

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REISK 9100