

DATE	DC RFT NO	SIGN

**INSPECTION CRITERIA:**

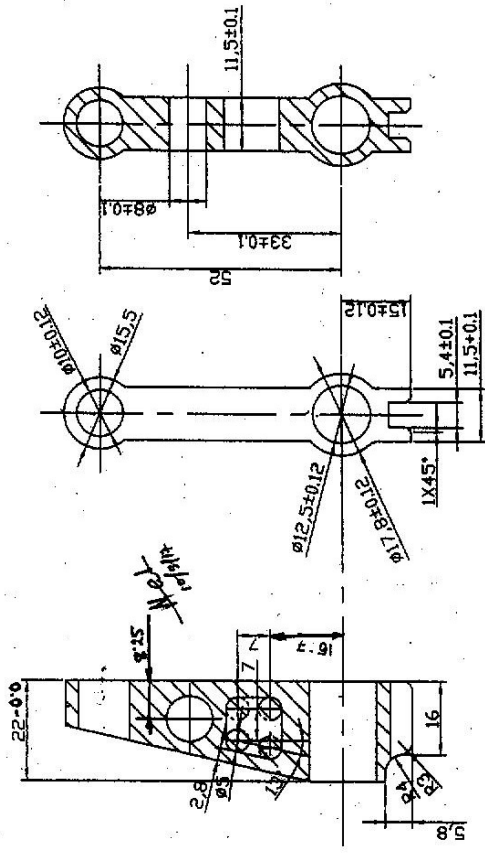
- 100% MAGNETIC TEST FOR CRACK DETECTION TO BE CARRIED OUT IN SAMPLES AS PER INSPECTION LEVEL IV AT AQL. 0.65 AS PER I.S. 2500 Pt. 1 1965
- RADIOGRAPHIC STANDARD AS PER ASTM-E-192 GAS HOLE & FOREIGN MATERIAL LEVEL-5, SHRINKAGE LEVEL 3, CRACKS, COLD SHUTS, HOT TEARS ETC. ARE NOT ACCEPTABLE.
  - 100% OF THE ADVANCE SAMPLES SHALL BE SUBJECTED TO RADIOGRAPHIC TEST.
  - FOR BULK COMPONENTS, 5% EACH OF CAST/HEAT SHOULD BE SUBJECTED TO RADIOGRAPHIC TEST UNTIL THE PRODUCTION IS ESTABLISHED BY THE VENDOR.
- TEST PIECE TO BE EXAMINED FOR TENSILE STRENGTH & IZOD VALUE.
- MACHINABILITY TO BE TESTED BY DRILLING Ø25 HOLES THROUGH AND THROUGH ON ATLEAST 02 SAMPLES.
- ALL DRGS. DIMNS. ARE TO BE CHECKED AFTER FINAL HEAT TREATMENT.
- THE SUPPLIER WILL MANUFACTURE 02 SETS OF INSPECTION GAUGE AND GET IT VERIFIED BY PFI.

TREATMENT:- CASTING TO BE SUPPLIED FINALLY AFTER ANNEALING, TEMPERING & HARDENING TO BHN 248-302

FINISH :- PHOSPHATED TO SPECN:WPN/GEN-3/CLASS II OIL FINISH.

HARDNESS:- 228 TO 285 BHN

CASTING MATERIAL :- BS-3146 PT-1 1974, TYPE CLASS 10		ALL DIMENSIONS ARE IN MM.	
TITLE OF COMP DRG.	OPERATION	2016 DGN.	NAME
INVESTMENT CASTING DRG.		DRN.	DATE
INDIAN ORDNANCE FACTORIES RIFLE FACTORY ISHAPORE	SCALE 1:1	CKD.	
IC DRAWING OF BRACKET FORE SIGHT		APPD.	
7.62 mm ASSAULT RIFLE (GHATAK)		DRG. NO.:-	
		RFI SK-9919 AR	
		SHEET NO.	TOTAL



आपका प्रति / CERTIFIED COPY OF  
 ड्रिंग / ड्रिंग / या रिफरेंस 1166/1993  
 DRG/LAYOUT/GAUGE SCHEDULE  
 जारी / AT THIS DATE. 7-8-17  
 श्री सी सी / CDD  
 रीफरेंस नंबर / 1166  
 RIFLE FACTORY, ISHAPORE

**NOTES:-**

- DIMENSIONS WITHOUT TOLERANCE TO BE AS PER STD. IS. 1166-1993 CLASS - 2 OF INVESTMENT CASTING.
- CASTINGS SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT TEARS, COLD SHUTS, BLOW HOLES ETC. AND SURFACE FINISH SHOULD BE SMOOTH.
- VISUAL EXAMINATION SHOULD CONFORM TO CLAUSE 8.1 & 8.2 OF SPECN. IS. 10343-1999 AND AQL(2.5) OF IS. 2500 Pt. 1 INSPECTION LEVEL IV.
- DECARBURISATION SHOULD NOT BE MORE THAN 2% OF THE THICKNESS OF THE CASTING.
- TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 140 METHOD (D) OF BS 3146 Pt. 1 1974 TEST PIECES SHOULD BE CAST FROM THE SAME MELT USED AND SHOULD BE MADE TO SATISFY THE SPECN IS:10343-1999. RESULT OF TEST SHALL BE FURNISHED ALONG WITH I-NOTE.
- SHARP EDGES IF ANY ARE TO BE REMOVED.
- ALL CASTINGS & REPRESENTATIVE TEST SAMPLES SHALL BE LEGIBLY ENGRAVED WITH MANUFACTURER'S IDENTIFICATION MARK OF SUITABLE SIZE AT THE DESIGNATED AREA.
- 10 TO 15 NOS. SAMPLE CASTING DUELY PASSED BY INSPECTOR IN RADIOGRAPHIC TEST, MATERIAL, DIMENSIONS ETC. TO BE SENT AGAINST EACH S.D. TO THIS FACTORY FOR FITMENT TRIAL BEFORE BULK SUPPLY.