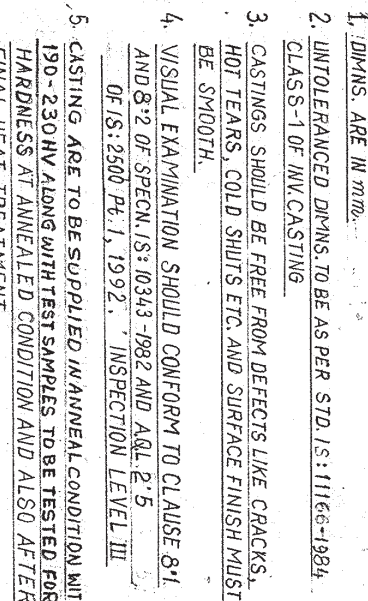


GROUP-C



1. DIMNS. ARE IN mm.
2. UNTOLEANCED DIMNS. TO BE AS PER STD. IS: 11166-1984
CLASS-1 OF INV. CASTING
3. CASTINGS SHOULD BE FREE FROM DEFECTS LIKE CRACKS,
HOT TEARS, COLD SHUTS ETC. AND SURFACE FINISH MUST
BE SMOOTH.
4. VISUAL EXAMINATION SHOULD CONFORM TO CLAUSE 8.1
AND 8.2 OF SPECN. IS: 10343-1982 AND AQL 2.5
OF IS: 2500 Pt. I, 1992. INSPECTION LEVEL III
5. CASTING ARE TO BE SUPPLIED IN ANNEAL CONDITION WITH
190-230 HV ALONG WITH TEST SAMPLES TO BE TESTED FOR
HARDNESS AT ANNEALED CONDITION AND ALSO AFTER
FINAL HEAT TREATMENT.
6. DECURBURISATION 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.
IS: 10343-1982.
8. TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH
CLAUSE 1:1 SEC.-1 OF SPECN. BS 3146 Pt.1/1974
9. SHARP EDGES & 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 AQL 0.65 AS
PER IS: 2500 Pt.1 1992.

ALL CASINGS AND REPRESENTATIVE TEST SAMPLES SHALL BE
TESTED BY MARKED WITH MANUFACTURER'S IDENTIFICATION MARK

LEIGIBLE, MARKED WITH MANUFACTURE IDENTIFICATION MARK
WITH 3 mm. SIZE.

12. RADIOGRAPHIC ACCEPTANCE STANDARD SHALL BE PER ASTM-E-192, GAS HOLES LEVEL-5, FOREIGN MAT. LEVEL-5 AND SHRINKAGE (ALT TYPE) LEVEL-3

i) RADIOGRAPHIC TEST TO BE CARRIED OUT AS FOLLOWS:-
100% FROM SAMPLE LOT FROM EACH SUPPLIER. THE LOT
SHOULD NOT BE LESS THAN 10 NOS.

(ii) 2% FROM SECOND LOT FROM EACH SUPPLIER THE LOT SHOULD NOT BE LESS THAN 100 NOS.

iii) 1% FROM REPEATATIVE / BULK SUPPLY UNTILL THE PRODUCT IS ESTABLISHED BY VENDOR.

13-1070 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.

MATL. 3

BS 3146 Pt.1: 1974, TYPE CLA-8 (SEE NOTE.5)

COMPOSITION OF MATERIAL.	C%	Si%	Mn%	Ni, %	Cr, %	Mo, %	Cu, %	S%	P%
37 TO	.2 TO	.5 TO	.4	.3	.1	3	.035	.035 +	
.45	.6	.8	MAX.	MAX.	MAX.	MAX.	MAX.	MAX.	

*RESIDUAL. THE TOTAL AMOUNT OF THESE ELEMENTS SHALL NOT EXCEED 8.

INVESTMENT CASTING, DRAWING

ORDNANCE FACTORY BOARD

RIFLE FACTO
ISHAPORE

SCALE:- 1:1	RIFLE 5.56 mm.
	ENGINE COVER

HINGE COVER
ARDE SK. 3143/1
D.S. CAT. NO. 3143/1

(R.I. 5N60503)