

INDIGENOUS MATERIAL

⑤ ~~IS: 10343 Gr. 4D OR BS: 3146 Pt-1 1974, TYPE CLA-5 GRADE L~~  
 ④ ~~IS: 10343 Gr. 4D, CASTING TO BE HEAT-TREATED TO ACHIEVE 415-51.5 HRC~~  
 SEPARATELY CAST TEST BARS SHALL MEET THE SPECIFIED MECH. PROPERTIES INCLUDING IZOD IMPACT VALUE 14J MIN.

~~OR~~

~~BS: 3146. Pt.1: 1974, TYPE CLA-5 GRADE 'B'~~

RADIOGRAPHIC TEST

(a) RADIOGRAPHIC ACCEPTANCE STANDARD OF THE CASTING SHOULD BE AS PER ASTM-E-192

(b) 100% OF THE ADVANCE SAMPLE (NOT LESS THAN 5) WILL BE SUBJECTED TO RADIOGRAPHIC TEST.

(c) RADIOGRAPHIC TEST OF ADVANCE SAMPLE WILL BE CARRIED OUT BY CQA(MET) ICHAPUR.

OR

③ THE AREA QUALITY ASSURANCE OFFICER CONCERNED WOULD GET THE RADIOGRAPHIC TEST DONE IN HIS PRESENCE AND FORWARD THE PLATES TO TO CQA (MET) ICHAPUR FOR SENTENCE AND APPROVA.. OF THE MOULD.

(d) BULK PRODUCTION WOULD COMMENCE ONLY AFTER MOULD AND MATERIAL HAS BEEN APPROVED BY CQA(MET) ICHAPUR.

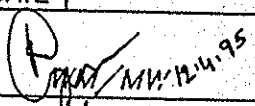
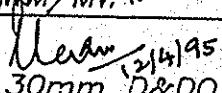
(e) 5% OF THE CASTING SELECTED AT RANDOM FROM <sup>THE</sup> BULK WOULD BE SUBJECTED TO RADIOGRAPHIC TEST. THIS MAY BE DONE UNDER THE ARRANGEMENT OF THE AREA QUALITY ASSURANCE OFFICER AND SENTENCE MAY BE AWARDED BY HIM BASED ON THE STANDARD OF THE ADVANCE SAMPLES CLEARED BY CQA(MET) ICHAPUR.

REF. :- CONTROLLERATE OF QUALITY ASSU(W) JABALPUR LETTER NO. 50431/CQA(W)/QA-11 DATED 14 MARCH 95.

⑤ CONTROLLERATE OF QUALITY ASSU (M) ICHAPUR LETTER MQA-3/LIW/3/W Dt. 03 MAY 1995

INDIGENOUS MATERIAL: IS 10343 GY 4E WITH C% 0.45-0.50 AND MECHANICAL PROPERTIES SPECIFIED IN THE SPECIFICATION FOR THE GRADE  
AUTHORITY: CQA (METALS) ICHAPUR, LY. NO. MQA-3/TS/B/I Dt 6/11-6-97

E ⑤	DA NO. 052/97 Dt. 11-8-97	Jt 11/8/97
UPDATED	DA NO. 022/97 Dt. 23-3-97	Jt 23/3/97
D ④	DA NO. 70/95 Dt. 7-8-95	Sathi
C ③	DA NO. 020/95 Dt. 11-4-95	Sathi 11-4-95
AMENDMENTS:	DESCRIPTIONS	SIG. & DATE

SHEETS 2/2	APPROVED	 P. Mahalingam 11/11/95	ORDNANCE FACTORY	COMPONENT NO. 2442-05-112 ARM
Sathi DR:WN	CHECKED		 V. Senthil Kumar 12/14/95 1/C.30mm D&DO	TIRUCHIRAPALLI