

NOTE: - 5 TO 10 Nos. OF SAMPLE MUST BE APPROVED BY RFI BEFORE BULK SUPPLY.

DCRF1
&
DATE

DETAILS OF AMENDMENTS & AUTHORITY SIGN

04/08/98 AT TOP VIEW FOR R10 READ R6, FOR R7
BT. READ R5'25" DIMN. 9'0" NEWLY ADDED.
29/10/98 AT BOTTOM VIEW FOR 22'0" READ 22'5"
DRG. AMENDED ACCORDINGLY & ADVANCED
TO RF1 SK. 4312*8
AUTHORITY: ~ VIDE MEMO NO. 51/JWM/BT.
GENERAL DT. 25-8-98.

WMA/AS
8/9

04/09/92 DRG: REVISED.
 DT 15-92 AUTHORITY: - ① MEMO FROM JWM/BT TO
 JWM/DO. NO. 3/2/JWM/BT (GEN) DT. 23-11-98.
 (2) MINUTES OF THE MEETING IN THE
 OFFICE OF JGM/PL ON 21-11-98.
 DRG. AMENDED ACCORDINGLY &
 ADVANCED TO RFI SK. 4312*9

04/11/99 DRG. REVISED. TWO BRIDGE INSIDE
6-4-99 THE CAVITY DELETED.
DRG. AMENDED ACCORDINGLY.
DRG. NO. ADVANCED TO RFISK.431

3006-03 IN NOTE 2, " WITH 190-230 HV " ADDED,
DRG. NO. ADVANCED TO REL. SK. 4312 *II.
AUTHY: - LETTER NO. 8C(IM) /IC/ QUALITY REVIEW
DT. 04-3-03.

04/003/ A VIEW SHOWING THE POSITION OF MANUFACTURER'S IDENTIFICATION MARK ADDED. *12
05
17-2-05 THE DRG. NO. ADVANCED TO RFI SK 4312

✓ UNTOLERATED DIMENSIONS ARE AS PER STD. IS: 11166-1984 CLASS-II

NOTES FOR CONDITION OF SUPPLY

- 1) ALL DIMENSIONS ARE IN M.M.
- 2) CASTINGS TO BE SUPPLIED IN ANNEALED CONDITION WITH 190-230 HV.
- 3) ALL SHARP CORNERS ARE TO BE REMOVED.
- 4) CASTINGS SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT-TEARS, COLD SHUTS ETC. AND SURFACE FINISH SHOULD BE SMOOTH.
- 5) VISUAL EXAMINATION SHOULD CONFORM TO CLAUSE 0-1 AND 0-2 OF SPECN. IS: 10343-1989 AND A.Q.L (FOR A-1,5, B-1.5, C-2.5) OF IS: 2500 PART-1 1992, INSPECTION LEVEL-III.
- 6) DECARBURISATION SHOULD NOT BE MORE THAN 2% OF THE THICKNESS OF THE CASTINGS.
- 7) ALL CASTINGS AND REPRESENTATIVE SAMPLES SHALL BE LEGIBLY MARKED WITH IDENTIFICATION MARK.
- 8) TEST SAMPLES SHOULD BE CAST FROM THE SAME MATERIAL USED FOR MANUFACTURING OF THE CASTINGS AND BE MADE TO SATISFY SPECN. IS:10343-1989 OR BS:3146 PART-I 1974.
- 9) MAGNETIC TEST FOR CRACK DETECTION SHOULD BE CARRIED OUT IN SAMPLES AS PER INSPECTION LEVEL -IV AT AQL 0.65 AS PER IS: 2500 PART-1, 1992.
- 10) RADIOGRAPHIC ACCEPTANCE STD. AS PER REF. SK.No. 6274.

25.8.36 $\phi 6$ HOLE AND 8.4 DIMENSIONS TO BE DELETED
FOR DIMENSIONS 5.2 IN ELEVATION AND R-7
IN PLAN VIEW READ DIMN. 4.8 & R-10, RESPECTIVELY.
DIMENSION 170.6 TOTAL LENGTH NEWLY ADDED.
AT ENLARGED VIEW OF BOW FOR R19.0 READ R 10.0
DRG. No. ADVANCED TO REI SK. 4312*7

25.10.95	MATL. FOR BS: 3146 Pt. I: 1974 TYPE CLA. GRADE - I C. READ BS: 3146 Pt. I: 1974 TYPE, CLA. I. GRADE 'C'. DRG. No. ADVANCED TO RFI \$K. 4312 * 6
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3.7.95 DIMN. OF RIB 4-0 IS SHOWN TO AUXILIARY VIEW IN PLACE OF PLAN VIEW. THE SAME DELETED FROM PLAN VIEW. THE ORIGIN OF $11^{\circ}30'$ IS 2.5 OFF SET FROM THE DATUM LINE IN THE MAIN VIEW. AUXILIARY VIEW OF "IN SIDE OF BOW" IS AMENDED ACCORDINGLY. LENGTH OF "INSIDE OF BOW" WILL BE 52 FOR 53 DRG.No. ADVANCED TO RFI. SK. 4312⁵

4-5.95 DRG. REVISED AS PER RD/SK/273-SP
DRG.No. ADVANCED TO RFI SK.4312

DATE	AMENDMENTS	SIGN
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MATERIAL:- BS: 3146 Pt I: 1974, TYPE CLA. 1 -
GRADE - C. (SEE NOTE 2)

ASSY. DRG. No.

ORDNANCE FACTORY BOARD
RIFLE FACTORY
ISHAPORE

SCALE- $\frac{1}{2}$:1
(2:1)

0.315 SPORTING RIFLE
GUARD TRIGGER
INVESTMENT CASTING

1996	NAME	DATE
DRN.	<i>Wang</i>	25.7.96
TCD.		
CKD.	<i>W. Wang</i>	
APPVD.	<i>Wang</i>	4.9.96
DRG. No.		
R.F.I. SK.-4312*12		
SHT-1 OF-1		

Wt. 172 gm (100) Ref. - Jt. GM/PL letter NO. 56/P&P/5.56 dt. 26-11-2011