

DAVID QAE(SA)	MATERIAL VETTER
22/9/96	QAE(SA)
	INCLUSION OF QAE(SA) EAST DRAIN M11/92 VETTER
	QAE(SA)

NOTE:

- 1- SETTING TO BE CARRIED OUT BY THE SUPPLIER.
- 2- SHARP CORNERS MAY BE AVOIDED UNSPECIFIED FILLET RADIUS
0.5mm. MAX.
- 3- CAST MARK 'IC' SHOULD BE GIVEN AT PLACE MKD. THUS ⊕
- 4- CASTING SHOULD BE SUPPLIED IN ANNEALED CONDITION.
- 5- CASTING SHOULD BE FREE FROM CRACKS, BLOW HOLES AND
ANY OTHER SURFACE DEFECTS.
- 6- BEFORE BULK PRODUCTION CLEARANCE WILL BE GIVEN PILOT
BATCH OF 10 CASTINGS WILL BE REQUIRED TO BE SUBMITTED
ALONGWITH THE DIMENSIONAL CRITICAL EXAMINATION REPORT AND
MATERIAL TEST CERTIFICATE. IF THE PILOT BATCH IS NOT ACCEP-
-TABLE FURTHER BATCHES OF 10 EACH WILL BE REQUIRED TILL
CLEARANCE IS GIVEN TO START BULK PRODUCTION.
- 7- ALONGWITH THE BULK SUPPLY, THE MATERIAL TEST CERTIFICATE
AND CHEMICAL ANALYSIS REPORT WILL REQUIRED TO BE FURNISH-
-ED FOR EACH CAST HEAD OF MATERIAL USED FOR POURING OF
CASTING. ADEQUATE CARE SHOULD BE TAKEN TO ENSURE THAT
THERE IS NO DECARBURISATION OF CASTINGS.
- 8- 100% CASTING WILL BE REQUIRED TO BE TESTED FOR MAGNETIC CRACK
DETECTION TO ENSURE THAT CASTINGS ARE FREE FROM CRACKS.
- 9- SURFACES MKD. THUS ▽ TO BE MACHINED AT OUR END.

APPROX WEIGHT _____
UNSPECIFIED TOLERANCE ± 12 mm FOR EACH 25.4 mm
ANGULAR TOLERANCE $\pm 30'$
MIN. FILLET RADIUS 0.3 mm.
FLATNESS $\pm 10/25.4$ mm.

RADIOGRAPHIC ACCEPTANCE STD. ASTM A-192 GRADE-B

~~ASIME-443-84-LEVEL-3~~

~~FOR A TAGOREFA SC TYPE CUBER~~

~~SECRET~~

ADONIS 0013-788X(2015)00000-0

NOTE: 10% OF THE COMPONENTS FROM PRELIMINARY LOT, AND 5% FROM BULK COMPONENTS WILL BE SUBJECTED TO RADIOGRAPHIC TEST.

(AUTHORITY: COA(34) LETTER NO. 41741 DT 4-11-91)

INSPECTION WILL BE GUIDED IN GENERAL AS PER CONTROLLERATE
OF INSPECTION (METALS) ISHAPUR, NOW NAMED AS CONTROLLERATE
OF QUALITY ASSURANCE (METALS) ISHAPUR.
INSPECTION INSTRUCTION NO FMR 0001H/TC/CIM/INST-2.

(TEST PIECE TO BE TESTED FROM ONE CASTING DULY HARDENED AND TEMPERED FROM EACH CAST FOR MECHANICAL PROPERTIES STIPULATED IN THE SPECIFICATION. TEST PIECE SHOULD ALSO BE TESTED TO ATTAIN THE HARDNESS OF —)

SECTION AB
SCALE: 2:1

Ref CQA(SA) letter no 2/P/3/E dt 29 May '86
REF. CONTROLLERATE OF QUALITY ASSURANCE (SMALL ARMS)
ISHADUR LETTER NO. 3/MGH/8 DT 23 JULY 88.

PARTIAL SECTION C-D

GUN MACHINE 7.62MM.
TK-71 TURRET
BRACKET CARRYING HANDLE, DRG. NO. 4015
SKETCH FOR INVESTMENT CASTING

SCALE
1:1



SMALL ARMS FACTORY
KANPUR

DRN:	6-27-72
CHKD.	<i>WJL</i>
APPROVED	
	
DRAWING NO.	
SKM-752	
SUT. OF	