

DRG. NO. :- SK-5377R

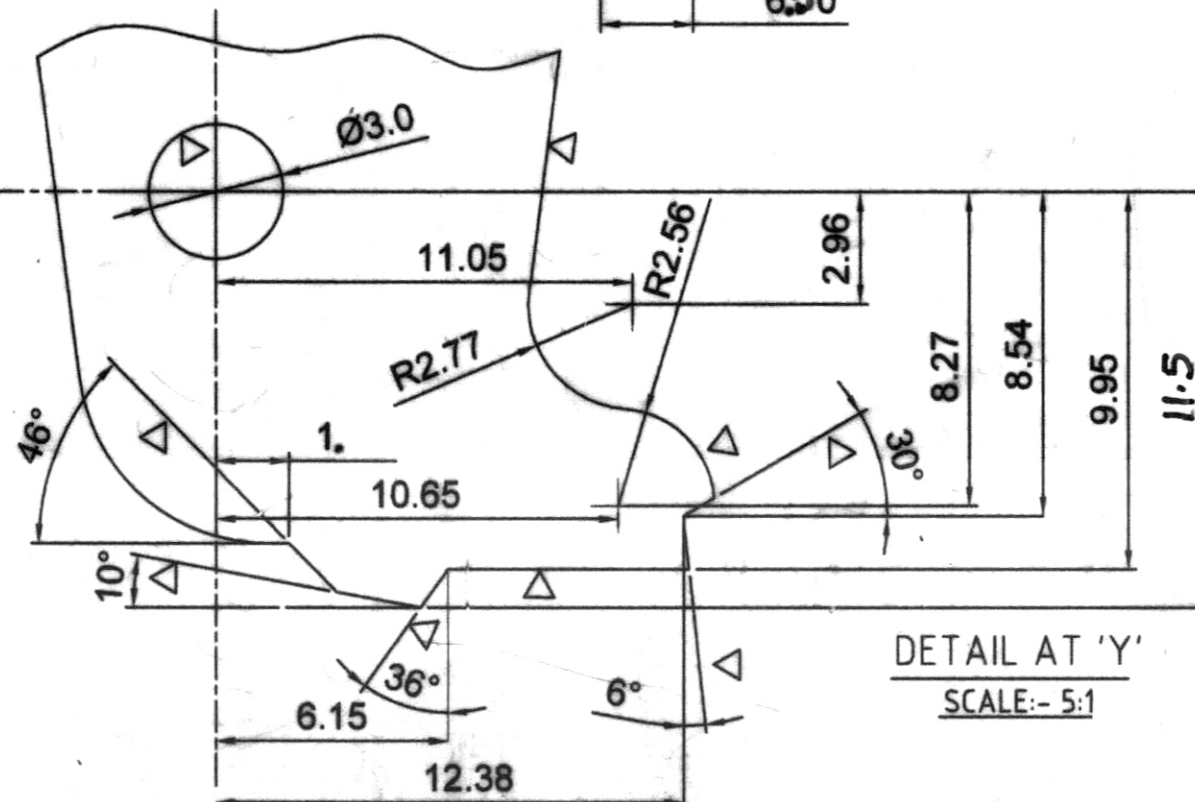
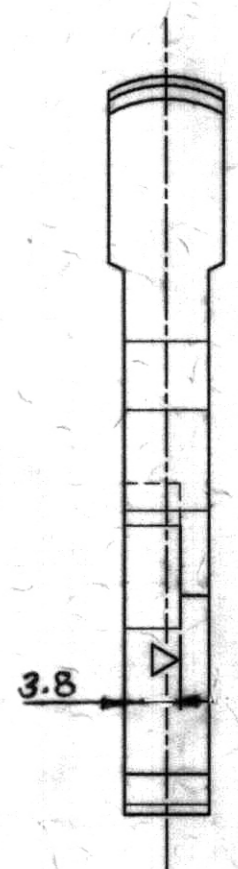
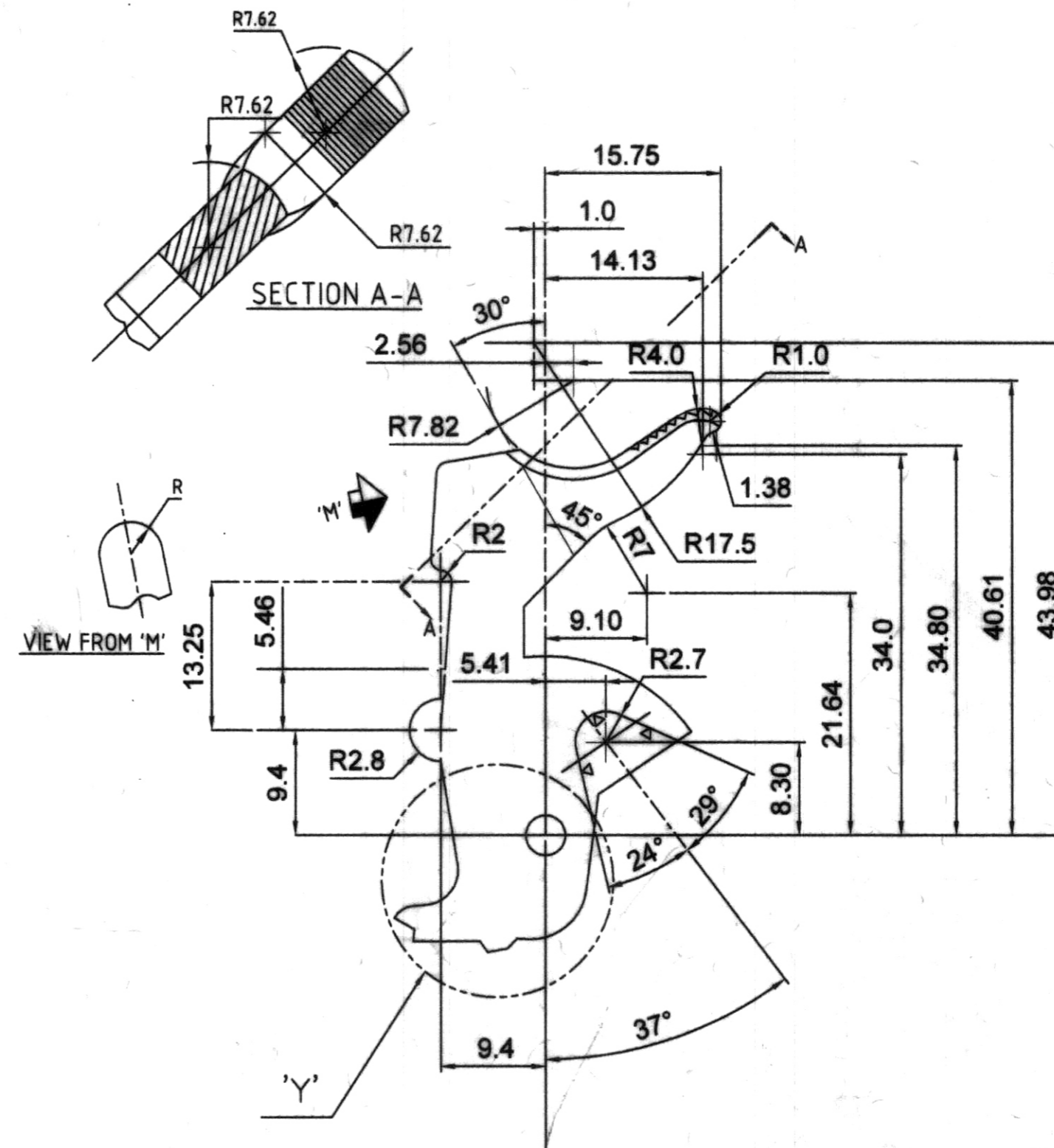
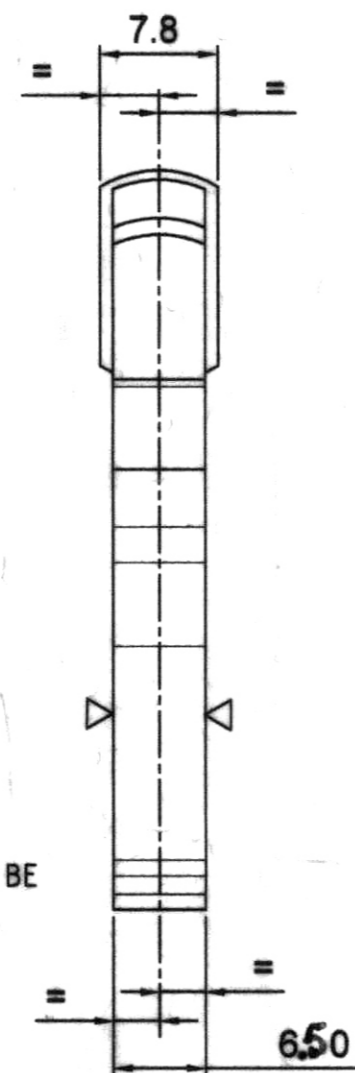
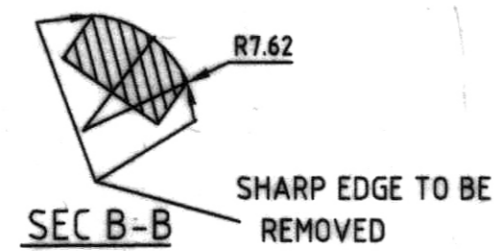
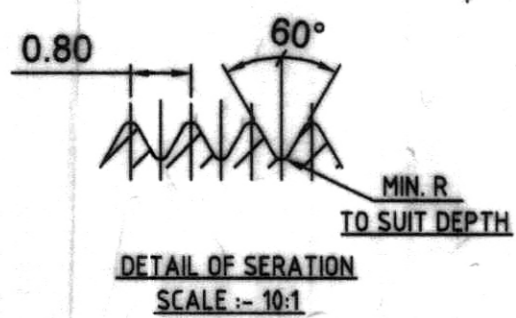
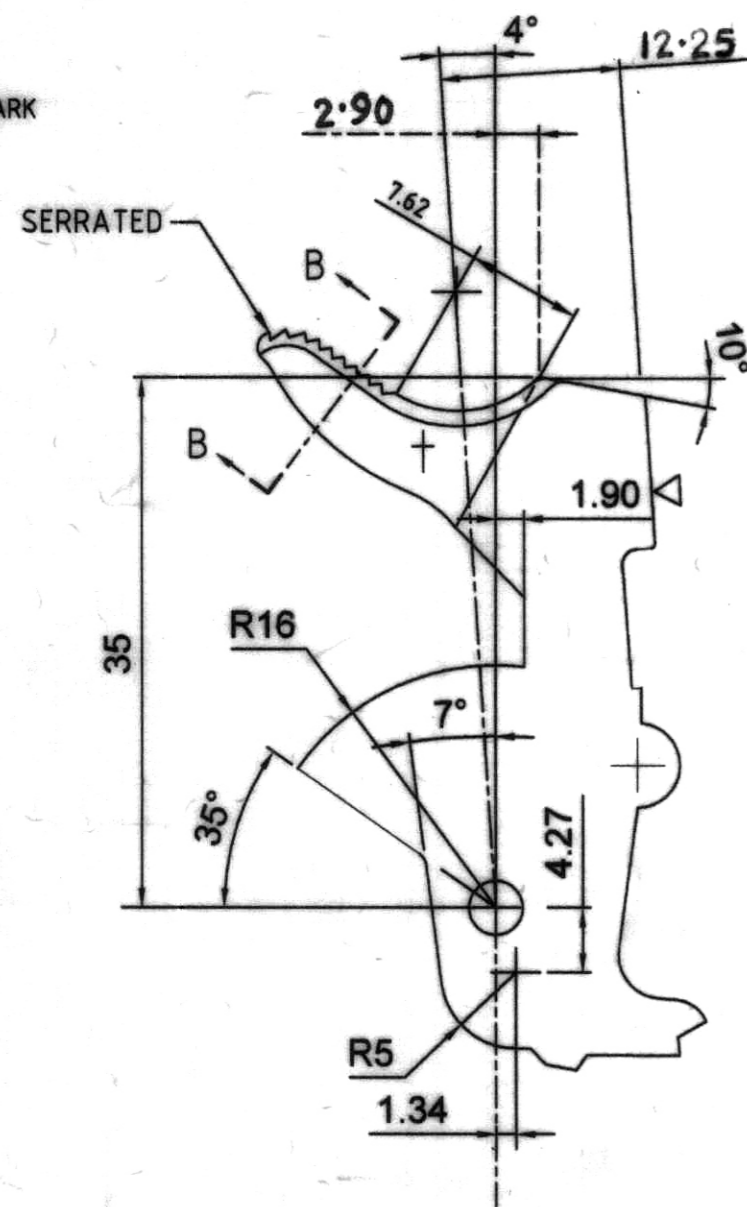
NO. QS/ISO-9000/DO/01  
REV. NO. 00-DT. 09-06-2001

- NOTE :-**
1. SURFACE MARKED THUS '▽' INDICATES MACHINING AT OUR END.
  2. SHARP CORNERS MAY BE AVOIDED, UN SPECIFIED FILLET RADII 0.5mm (MAX.)
  3. CAST MARK "IC" SHOULD BE GIVEN AT PLACE MARKED. ⊗ ALONG WITH MANUFACTURER'S INITIAL, BATCH No. & YEAR OF MANUFACTURE
  4. CASTING SHOULD BE SUPPLIED IN FULLY ANNEALED CONDITION.
  5. SETTING TO BE CARRIED OUT BY SUPPLIER.
  6. DIMNS. ARE IN m.m.
  7. CASTING SHOULD BE FREE FROM CRACKS, BLOW HOLES AND ANY OTHER SURFACE DEFECTS.
  8. BEFORE BULK PRODUCTION CLEARANCE WILL BE GIVEN. PILOT BATCH OF 10 CASTINGS WILL BE REQUIRED TO BE SUBMITTED ALONG WITH THE DIMENSIONAL CRITICAL EXAMINATION REPORT AND MATERIAL TEST CERTIFICATE. IF THE PILOT BATCH IS NOT ACCEPTABLE FURTHER BATCHES OF 10 EACH WILL BE REQUIRED TILL CLEARANCE IS GIVEN TO START BULK PRODUCTION.

9. ALONG WITH THE BULK SUPPLY THE MATERIAL TEST CERTIFICATE AND CHEMICAL ANALYSIS REPORT WILL BE REQUIRED TO BE FURNISHED FOR EACH CAST/ HEAT. OF MATERIAL USED FOR POURING OF CASTINGS.
10. ADEQUATE CARE SHOULD BE TAKEN TO ENSURE THAT THERE IS NO DECARBURISATION OF THE CASTINGS.
11. 100% CASTING WILL BE REQUIRED TO BE TESTED FOR MAGNETIC CRACK DETECTION TO ENSURE THAT CASTINGS ARE FREE FROM CRACKS.
12. APPROXIMATE WEIGHT : 27 g

DATE	D.A. No.	NATURE	J.W.M./D.O.
26-8-07	38/07	AT ZONE J-6,9:- DIM 1.0 WAS DIM 1.93 & 11.5 WAS 10.97 AND DRG. No ADVANCED TO SK-5377R*	<i>[Signature]</i> 26-8-07
09-9-07	41/07	AT ZONE G-7 :- DIM. 6.50 WAS " 6.10. & DRG. No. ADVANCED TO SK-5377R	<i>[Signature]</i> 09-9-07

MANUFACTURER MARK  
BATCH NO.  
YEAR



**MATERIAL :-** B.S. 3146 PART -1 : 1974 TYPE CLA 12 GRADE 'A'  
**HEAT TREATMENT- ANNEALING**  
(TEST PIECE IS TO BE TESTED FROM ONE CASTING DULY HARDENED AND TEMPERED FROM EACH CAST FOR MECHANICAL PROPERTIES STIPULATED IN THE SPECIFICATION.)  
**UNSPECIFIED TOL :-** ± 0.10m.m. FOR EACH 25 m.m.  
**ANGULAR TOL :-** ± 30'  
**MIN. FILLET RADIUS :-** 0.3 m.m.  
**FLATNESS ±0.1/25mm**

<b>HAMMER</b>		
<b>DRG. NO. PHMK-III- 6-1</b>		
<b>SKETCH FOR INVESTMENT CASTING</b>		
DRAWN <i>[Signature]</i> KALU	TRACED	CHECKED <i>[Signature]</i>
DATE 16-05-2006		APPROVED <i>[Signature]</i> J.W.M./D.O.
SCALE 1:1 (2:1, 5:1 & 10:1)		DRG. NO. <b>SK-5377R</b>
SMALL ARMS FACTORY KANPUR.		SHEET 1 OF 1