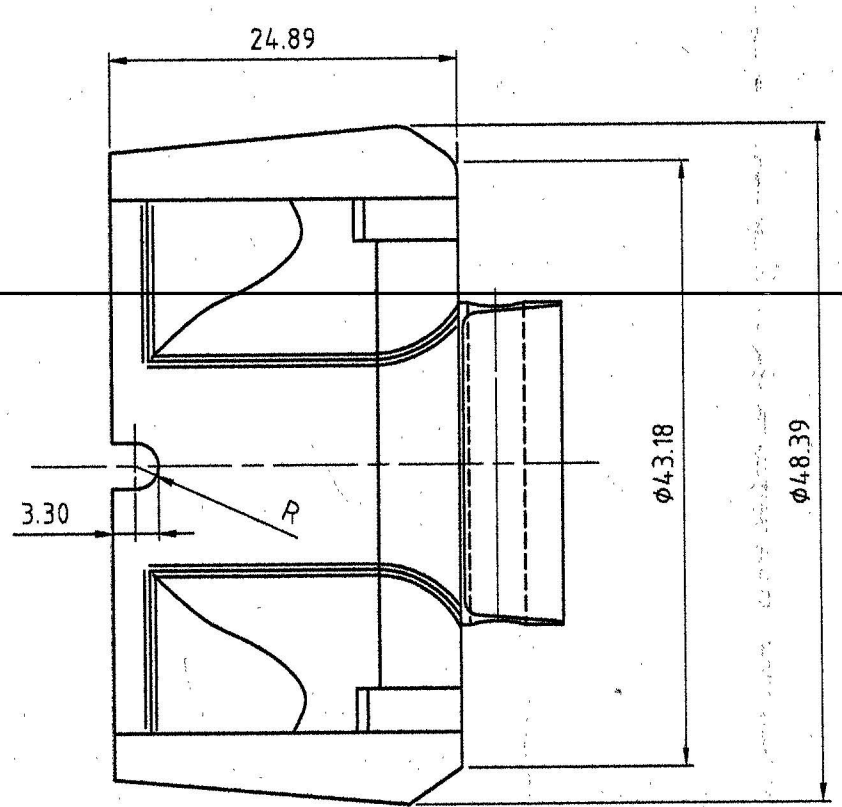
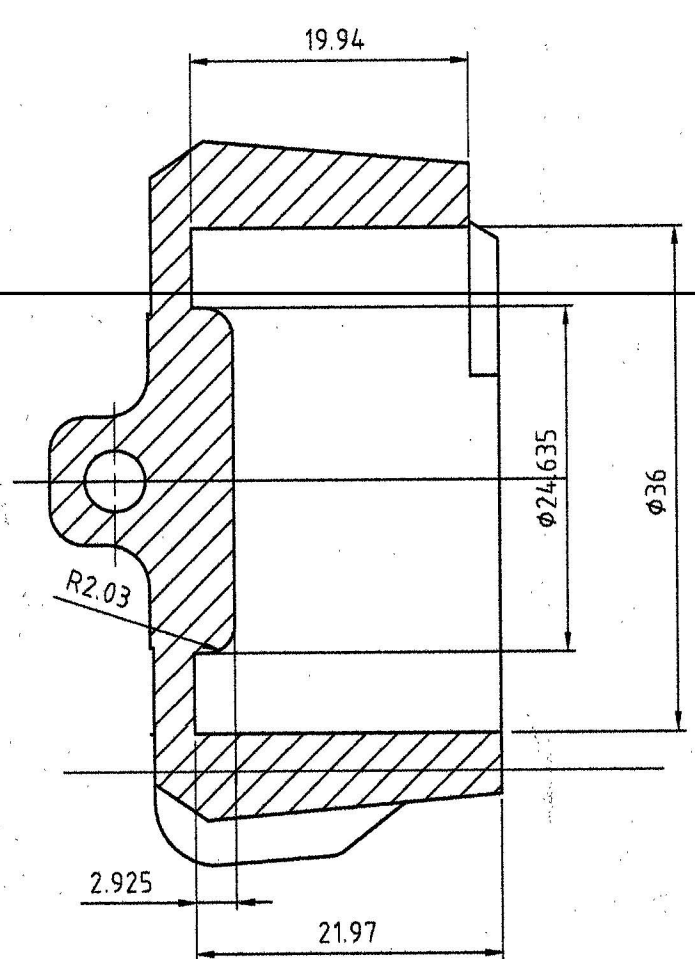
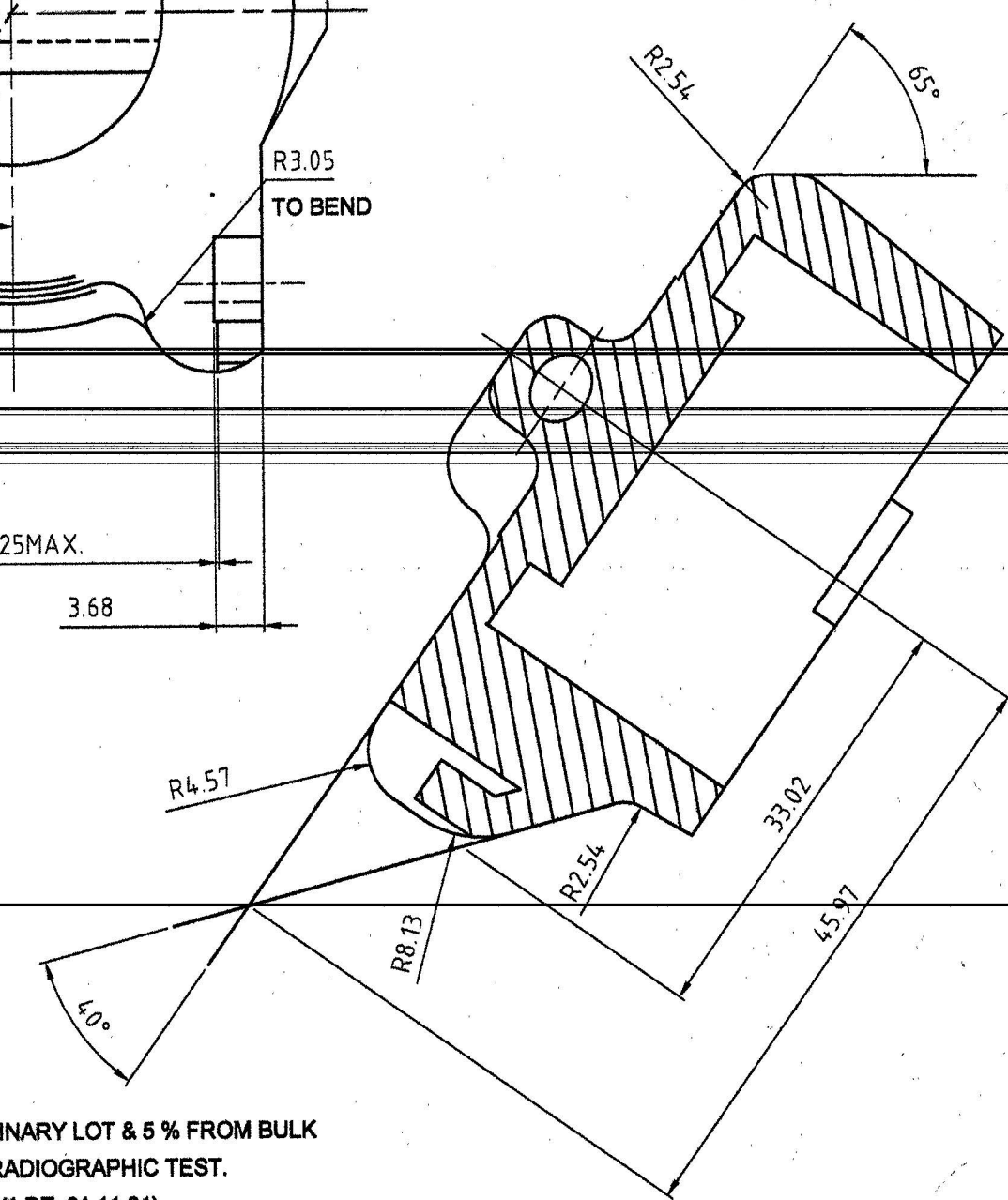
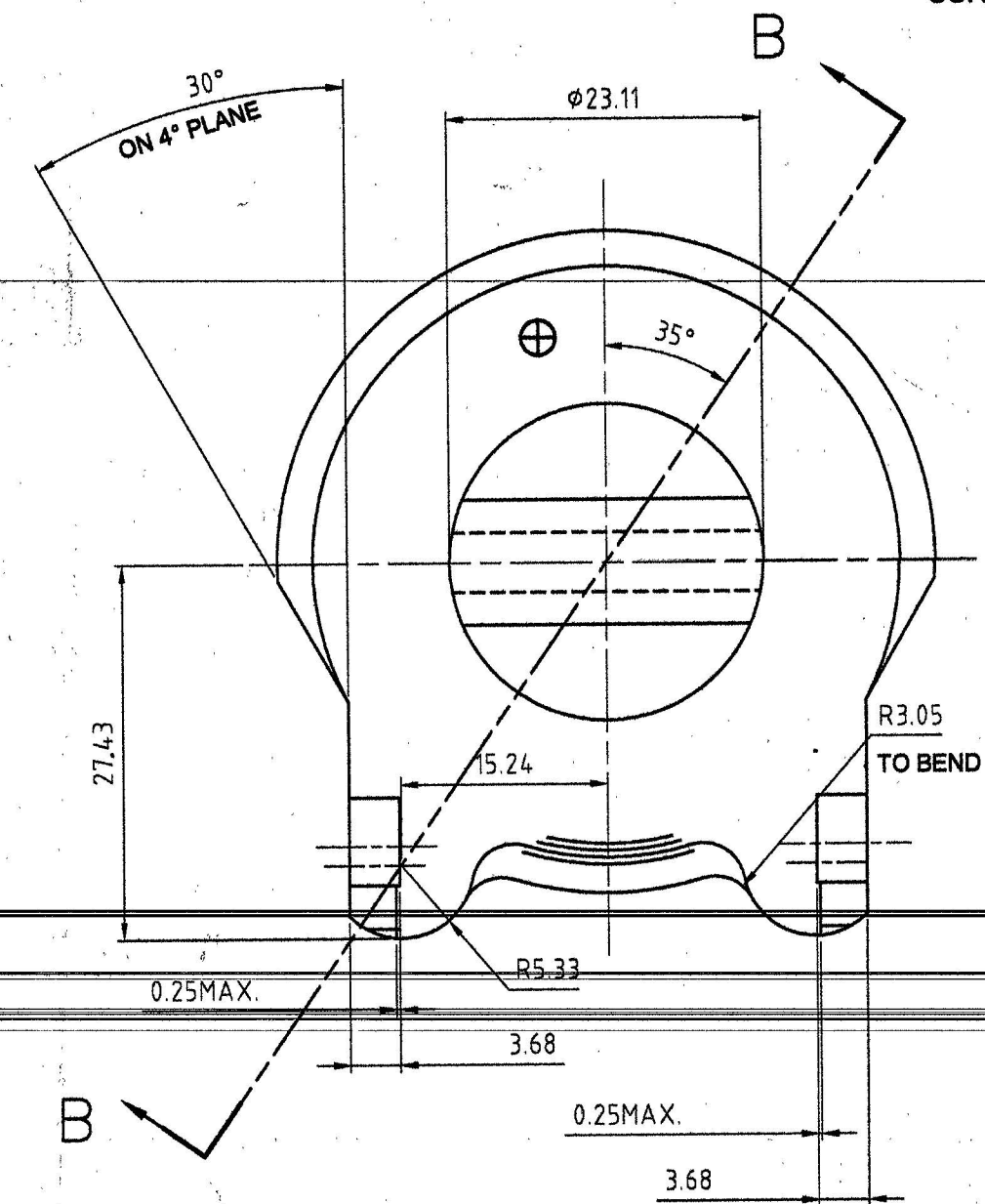
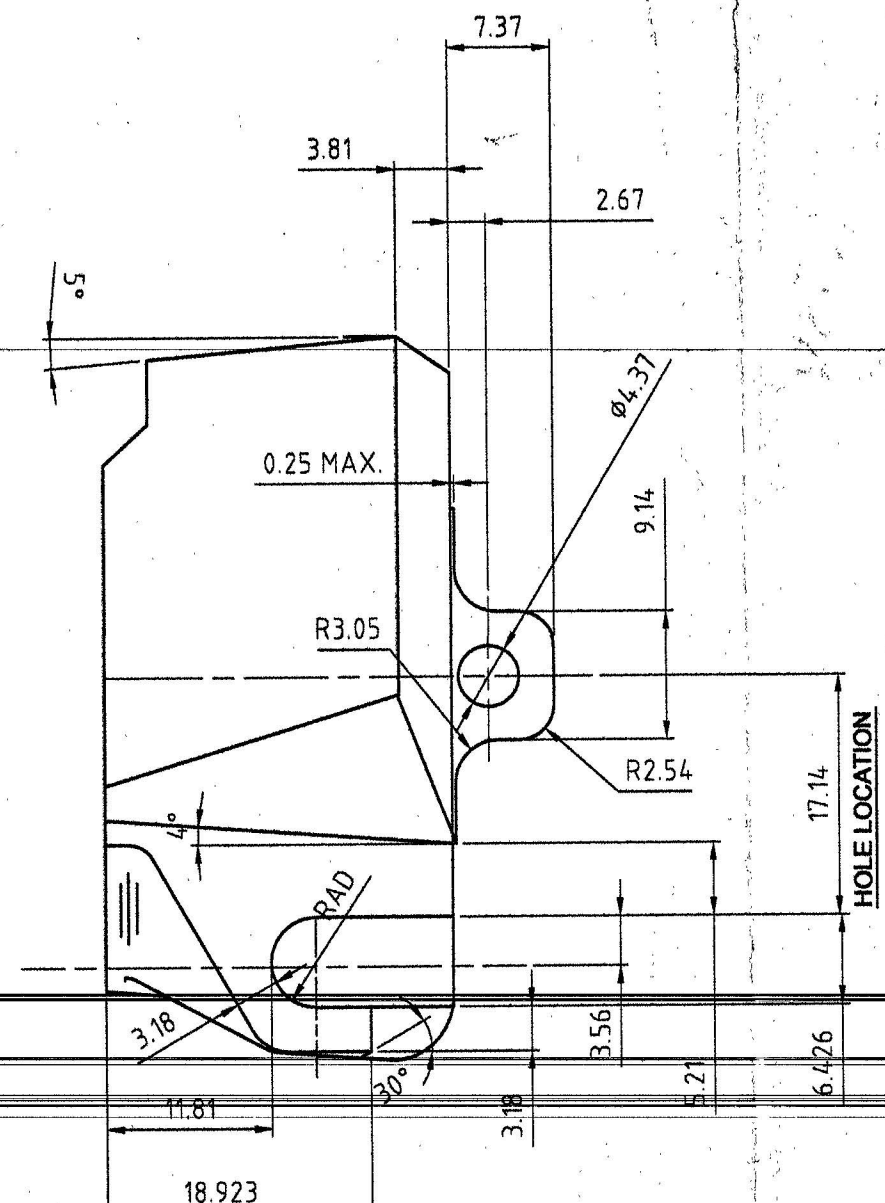
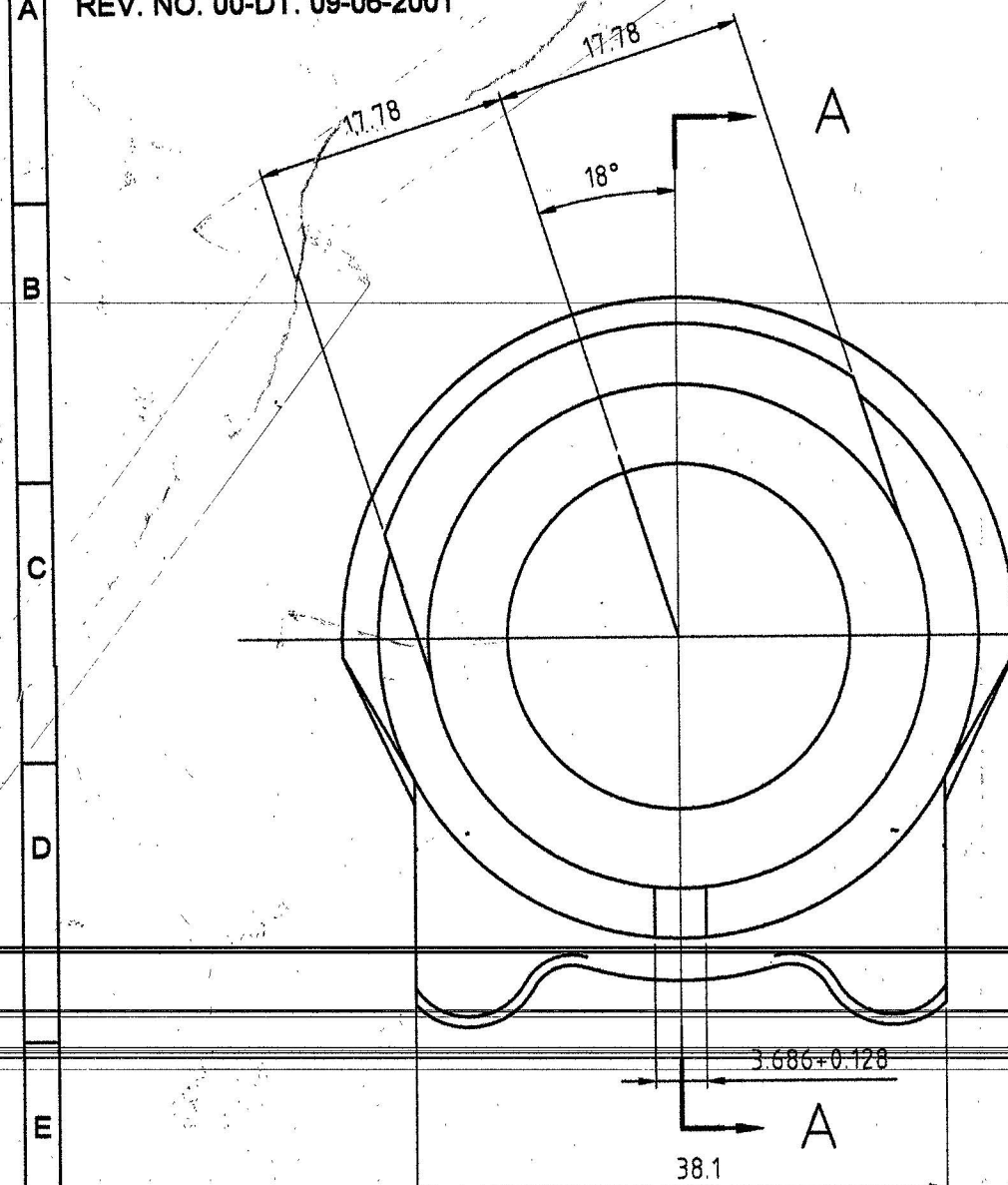


NO. QS/ISO-9000/DO/01
REV. NO. 00-DT. 09-06-2001

DIMENSIONS ARE IN mm.
INFORMATION MKD. THUS 'T' TO BE MKD. ON
SURFACES MKD. 'G' TO BE GRD.

D.A. NO.

57 / 93
55 / 03
105 / 05



NOTE : 10% OF THE COMPONENTS FROM PRELIMINARY LOT & 5 % FROM BULK COMPONENTS WILL BE SUBJECTED TO RADIOGRAPHIC TEST.
(AUTHORITY - CQA (SA) LETTER NO. 4/TC/1 DT. 01.11.91)
I.C DESIGN ACCEPTED AFTER FIRING TRIAL VIDE BRIEF (POINT NO. 9) OF MEETING ON R & D DT 06.10.94

MATL:- BS : 3148 PT 1 - 1974 TYPE CLA - 1 GR 'A'

RADIOGRAPHIC TEST : ASTM E 446 - 84 LEVEL 2 FOR ALL CATEGORIES
(AUTHORITY : CQA (MET) LETTER NO. MQA - 1/02 INVEST DT 26.05.89)
CATEGORY OF COMPONENTS 'B'

- 7) ALONGWITH THE BULK SUPPLY THE MATL. TEST CERTIFICATE & CHEMICAL ANALYSIS REPORT WILL BE REQUIRED TO BE FURNISHED FOR EACH CAST/HEAT OF MATL. USED FOR POURING OF CASTING.
- 8) ADEQUATE CARE SHOULD BE TAKEN TO ENSURE THAT THERE IS NO DECARBURISATION OF CASTING.
- 9) SURFACE MARKED THUS '▽' TO BE MACHINED AT OUR END.
- 10) APPROX. WEIGHT :-
UNSPECIFIED TOLRANCE $\pm 0.12\text{mm}$ FOR EACH 25.4 mm.
ANGULAR TOLRANCE $\pm 30^\circ$
MIN. FILLET RADIUS 0.3mm
FLATNESS $\pm 0.10/25.4\text{mm}$
(TEST PIECE IS TO BE TESTED FROM ON CASTING DULY HARDENED & TEMPERED FROM EACH CAST FOR MECHANICAL PROPERTIES STIPULATED IN THE SPECIFICATION.)

NOTES:-

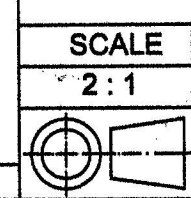
- 1) SETTING TO BE CARRIED OUT BY SUPPLIER.
- 2) SHARP CORNERS MAY BE AVOIDED, UNSPECIFIED FILLET RADII 0.5mm MAX.
- 3) CAST MARK 'IC', MANUFACTURES INITIAL, YEAR OF MANUFACTURE, & BATCH NO. SHOULD BE GIVEN AT PLACE MKD. THUS ⊕
- 4) CASTING SHOULD BE SUPPLIED IN ANNEALED CONDITION.
- 5) CASTING SHOULD BE FREE FROM CRACKS, BLOW HOLES & ANY OTHER SURFACE DEFECTS.
- 6) BEFORE BULK PRODUCTION CLEARANCE WILL BE GIVEN. PILOT BATCH OF 10 CASTING WILL BE REQUIRED TO BE SUBMITTED ALONGWITH THE DIMENSIONAL CRITICAL EXAMINATION REPORT & MATL. TEST CERTIFICATE. IF THE BATCH IS NOT ACCEPTABLE FURTHER BATCHES OF 10 EACH WILL BE REQUIRED TILL CLEARANCE IS GIVEN TO START BULK PRODUCTION.

SECTION A - A

SECTION B - B

SUB M/C GUN 9 mm CARBINE 1A1
CAP

DRG NO. DS CAT NO 1005-000860
SKETCH FOR INVESTMENT CASTING



SMALL ARMS FACTORY
KANPUR

DRAWN	TRACED	CHKD.
DATE	14/12/2005	
APPROVED		
DRG. NO.	SK - 3870	2
SHEET	1	OF 1

ORIGINAL