

SKM-754*1-2

INCLUSION OF RADIOGRAPHIC
TEST DATA IN 1/92
QAE(SA)

MATERIAL VETTED

QAE(SA)

MATERIAL :- B.S. 3146 PT.1-74
TYPE CLA-5 GRA
TO ACHIEVE REQUIRED
MECHANICAL PROPERTIES

NOTES:-

- 1- SETTING TO BE CARRIED OUT BY THE SUPPLIER.
- 2- SHARP CORNERS MAY BE AVOIDED. UNSPECIFIED FILLET RADI 0.5MM MAX.
- 3- CAST MARK 'IC' SHOULD BE GIVEN AT PLACE MKD. THUS ⑩.
- 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 ACCEPTABLE 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 FURNISHED 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% CASTINGS WILL BE REQUIRED TO BE TESTED FOR MAGNETIC CRACK DETECTION TO ENSURE THAT CASTINGS ARE FREE FROM CRACKS.
- 9- SURFACES MKD. THUS ⑦ TO BE MACHINED AT OUR END.

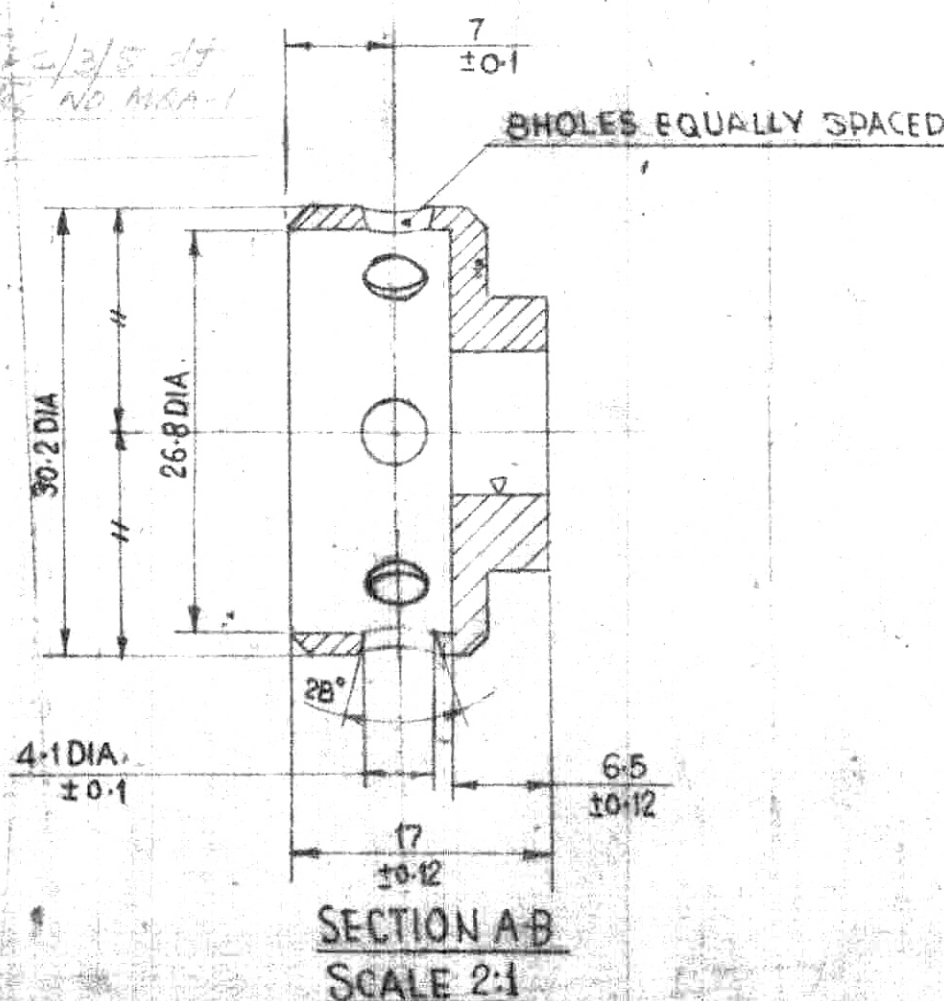
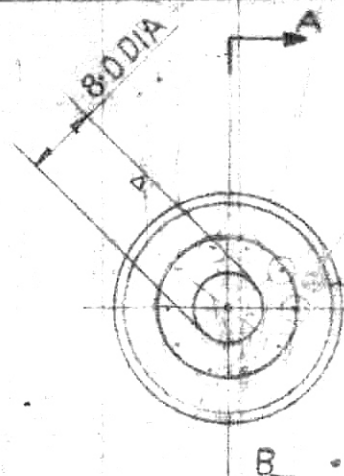
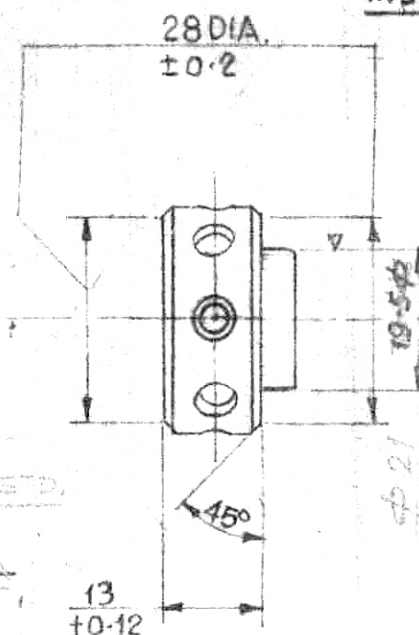
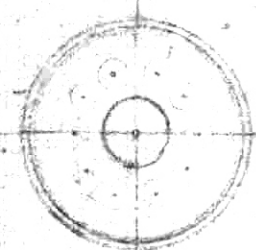
APPROX WEIGHT:-

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

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

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 0001 H/TC/CIM/INST-2



RADIOGRAPHIC ACCEPTANCE STD.
AS PER 45-34-1-1-2
FOR CATEGORIES ABC
CATEGORIES
DEF

ASTME-192 GRADE E
Ref:- CSA (SA) NO 2/2/3/5 dt
29/5/86 & CSA (MOT) NO MSA-1
INVS 7/86 3/6/86

D.A. NO. JWM/D SQA
M-36/86 (A) (SA)

1/11/86

DIMENSIONS ARE IN MM.

REF:- CONTROLLERATE OF QUALITY ASSURANCE (SMALL ARMS)
ISHAPUR LETTER NO 3/MG/1/5 DT. 23RD JUL 88

GUN MACHINE 7.62 MM.
TK-71 TURRET

NOB GAS REGULATOR SCREW, DRG. NO. 1012
SKETCH FOR INVESTMENT CASTING

SCALE
1:1



SMALL ARMS FACTORY
KANPUR

DRN. *[Signature]*
CHKD. *[Signature]*
APPROVED

DRAWING NO.

SKM-754*1-2

SHT. 1 OF 1