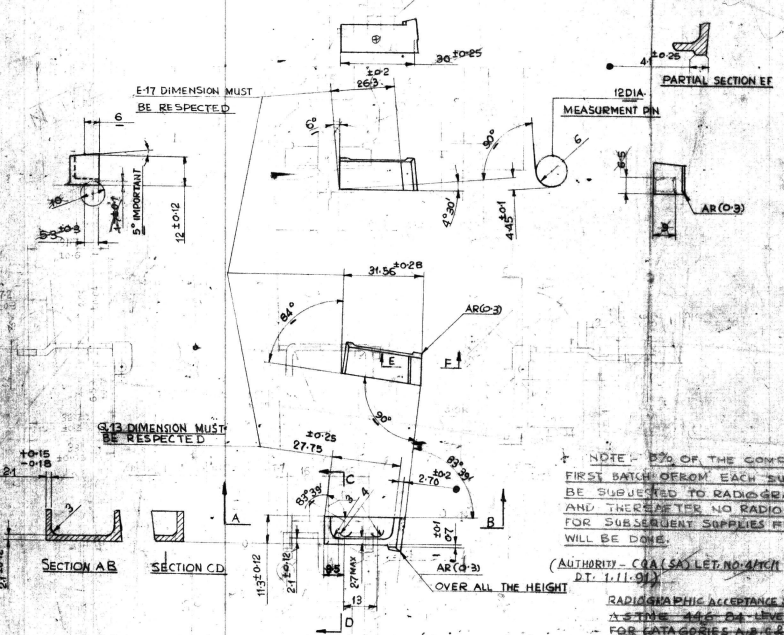


SKM-775*1



NOTE :-

1. SETTING TO BE CARRIED OUT BY THE SUPPLIER.
2. SHARP CORNERS MAY BE AVOIDED UNSPECIFIED FILLET RADIUS 0.3mm MAX.
3. CAST MARK 'C' 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 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 BE REQUIRED TO BE FURNISHED FOR EACH CAST HEAD OF MATERIAL USED FOR POURING OF CASTINGS.
8. ADEQUATE CARE SHOULD BE TAKEN TO ENSURE THAT THERE IS NO DECARBURISATION OF CASTINGS.
9. 100% CASTINGS WILL BE REQUIRED TO BE TESTED FOR MAGNETIC CRACK DETECTION TO ENSURE THAT CASTINGS ARE FREE FROM CRACKS.
10. SURFACES MKD. THUS TO BE MACHINED AT OUR END.
11. APPROX WEIGHT :-

UNSPECIFIED TOLERANCE: ± 0.12mm FOR EACH 25.4mm.
ANGULAR TOLERANCE: ± 30°
MIN. FILLET RADIUS: 0.2mm.
FLATNESS: ± 0.10/25.4mm.

NOTE :- 5% OF THE COMPONENTS FROM FIRST BATCH OF EACH SUPPLIER WILL BE SUBJECTED TO RADIOGRAPHIC TEST. AND THEREAFTER NO RADIOGRAPHIC TEST FOR SUBSEQUENT SUPPLIES FROM THAT SUPPLIER WILL BE DONE.

(AUTHORITY - CQA (SALLET NO. 4/1/11) DT: 1.11.01)

RADIOGRAPHIC ACCEPTANCE STD.
ASTM E 146 - 84 LEVEL 2
FOR CATEGORIES A, B, C, D
(TYPE 1, 2, 3, 4, 5, 6, 7, 8, 9, 10)
CATEGORIES DEFECTS
ASTM E 192
GRADE - B

(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 72-75 HRA.)

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/TCIM/INST-2

MATERIAL:- MATERIAL FOR INVESTMENT CASTING AS PER RADIOGRAPHIC ACCEPTANCE STANDARD ASTM E 146-84 LEVEL-2 BS 3146 DT. 1.1.1974 TYPE CLA-4

OR
AS PER AISI 8650 (HIGH SILICON) REF: CQA (SALLET NO. 4/1/11) DT: 1.11.01
C: 0.45 - 0.55
Mn: 0.50 - 1.00
S: 0.00 - 0.20
Ni: 0.20 - 0.70
Cr: 0.40 - 0.60
Mo: 0.15 - 0.30

REF: AS PER CISA DRAWING NO. A3-43
PART NO. 0566

GUN MACHINE 7.62 MM.
TK-71 TURRET
STOP CARTRIDGE DRG. NO. 0566
SKETCH FOR INVESTMENT CASTING

SCALE
1:1

SMALL ARMS FACTORY
KANPUR

DRN. CHKD. APPROVED
DRAWING NO. SKM-775
SHT. 1 OF 1