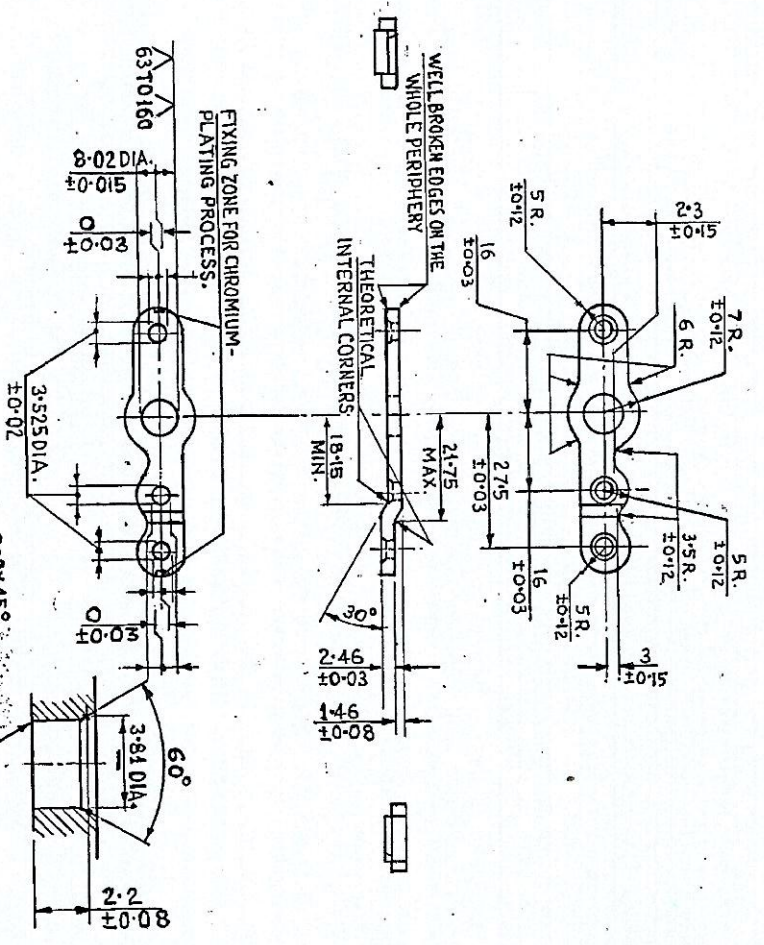


A
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P
Q



THESE DIMENSIONS ARE REQUIRED AFTER HARD CHROMIUM-PLATING.
THICKNESS :- 0.005 MIN.

MATERIAL :-
STEEL STRIP TO SPECN. BS 1449: PART 1:1985 GR 60

PROTECTIVE FINISH :-
CHROMIUM PLATED

NOTE :-
ACCEPTANCE STANDARDS FOR MACRO ETCH TEST AND MICROSCOPIC DETERMINATION OF NON METALLIC INCLUSIONS FOR STEEL
1) MACRO ETCH TEST AS PER ASTM E 381 WITH ACCEPTANCE STANDARD AS G2.R2.S2.
2) NMIR TEST AS PER IS: 4163-82.

Hallway
23.03.2003
Smit Kumar

25303-23-01-1002	RECORD RECEIPT CANCELLED AND DRD SEALED AT RISH	D.S. CAT No. 1005-006636	DATE NAME	ASSY. D.S. CAT No. 1005-006636	EQ(SA) - CHAPUR
22280-22-9-93	NOTE FOR MACRO ETCH TEST AND NMIR TEST ADDED	D.S. CAT No. 1005-006636	DGN. RND. 16.A.90	MATL. AS STATED	APPROVED DT.
22012-22-10-92	MATL. AMENDED	D.S. CAT No. 1005-006636	CHKD. 16.A.90	DIMENSIONS ARE IN MILLIMETERS	CL. NEG. RE-TRACED
21679-14-92	IV ASSEMBLY COLUMN	CL. NEG. RE-TRACED	SCALE: 1:1 & 5:1	LINK (LOWER)	DRG. NO. A-1314
20627-12.6.90	PREVIOUS DRD COPY	CL. NEG. RE-TRACED AS A RECORD OF RECEIPT.	SEALD: D.S. CAT NO. 25303-5A		PART NO. 65
	AUTH. DATE ZONE	BRIEF RECORD	SIG.	DT: 23-03-2002	D.S. CAT NO. 1005-006636

160

20.05.03

MAG. 7.62 mm

PH-V-33

TK-71-TURRET.

DRAFT QUALITY ASSURANCE PLAN

SL.43 Nomenclature :- LINK (LOWER)

DRAWING No.	65 D	QPL/023/DO/
DS CAT No.	1005-000469	
MATERIAL SPECIFICATION	STEEL STRIP TO SPECN. BS 1949 PT.1:1983 Gr 60	
MATERIAL VERIFICATION	i) Verification of GM/SAF / Note & Test certificate at MIS Stage. ii) if GM/SAF is the Inspecting Officer [a] Verification of Test Certificate and relevant documents. [b] if required material sample drawn from run of production may be send to CQA {MET} for metallurgical verification. iii) Whether specified material for the component issued to the pipeline of production.	

DIMENSIONAL, CHECKING AND GAUGE SCHEDULE /CONTROL POINTS.

SL. No	SURVEILLANCE POINTS	DRG ZONE	GAUGE No./METHOD	GAUGE NO. CQA (SA) GAUGE DRAWING NO.
1	1.46 ± 0.00		GM-65D/3 (Slip)	
2	φ 3.525 ± 0.02		GM 65D/4 (Go Plug)	
3	φ 3.525 ± 0.02		GM 65D/4B (Not go Plug)	
4	φ 8.02 ± 0.015		GM 65D/4c (Go Plug)	
5	φ 8.02 ± 0.015		GM 65D/4D (Not go Plug)	
6	16.0 ± 0.03 & 27.5 ± 0.03		GM 65D/4A U/W (Receiver)	
7	2.46 ± 0.03		GM-65D/4 BY GE Method.	

HEAT TREATMENT:-

PROTECTIVE FINISH: CHROMIUM PLATED
 PHOSPHATED TO SPECIFICATION JSS-0465-01 1988
 CLASS-II, OIL FINISH (ACCELERATED)

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