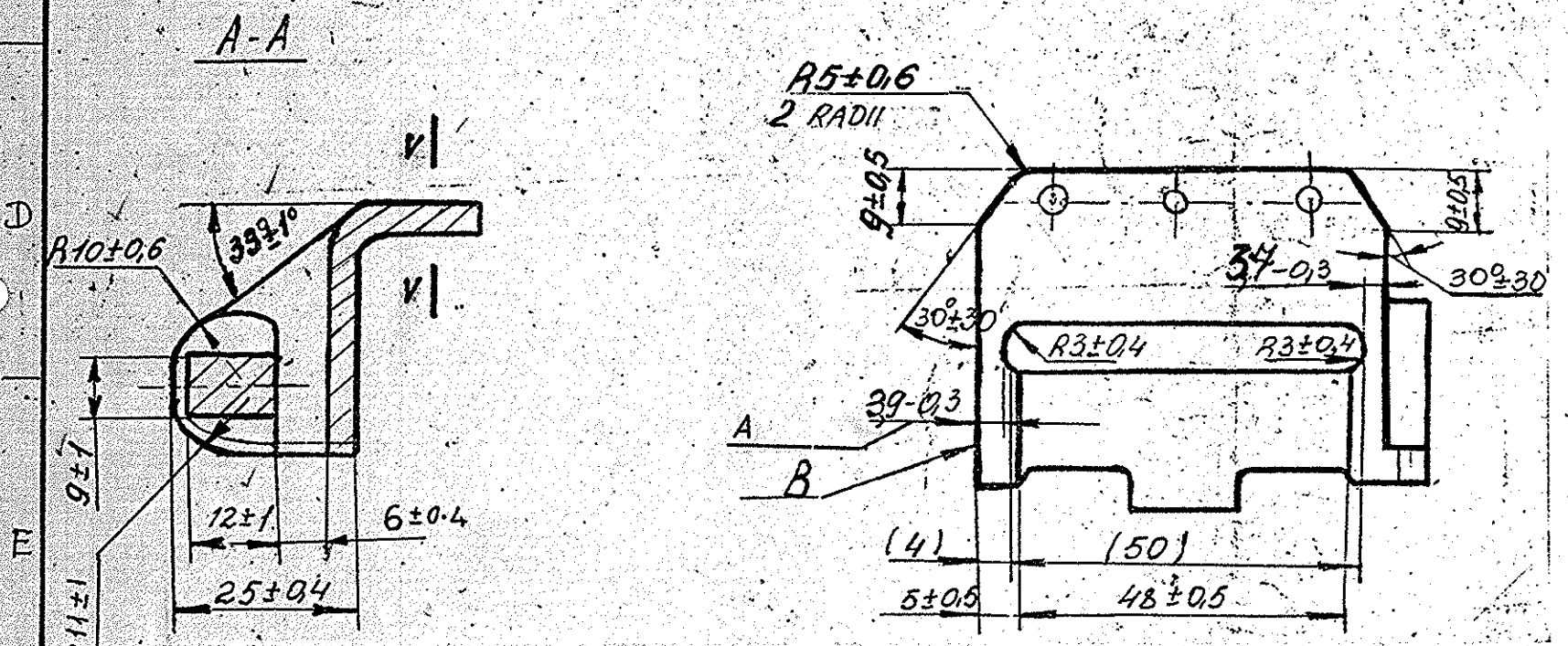
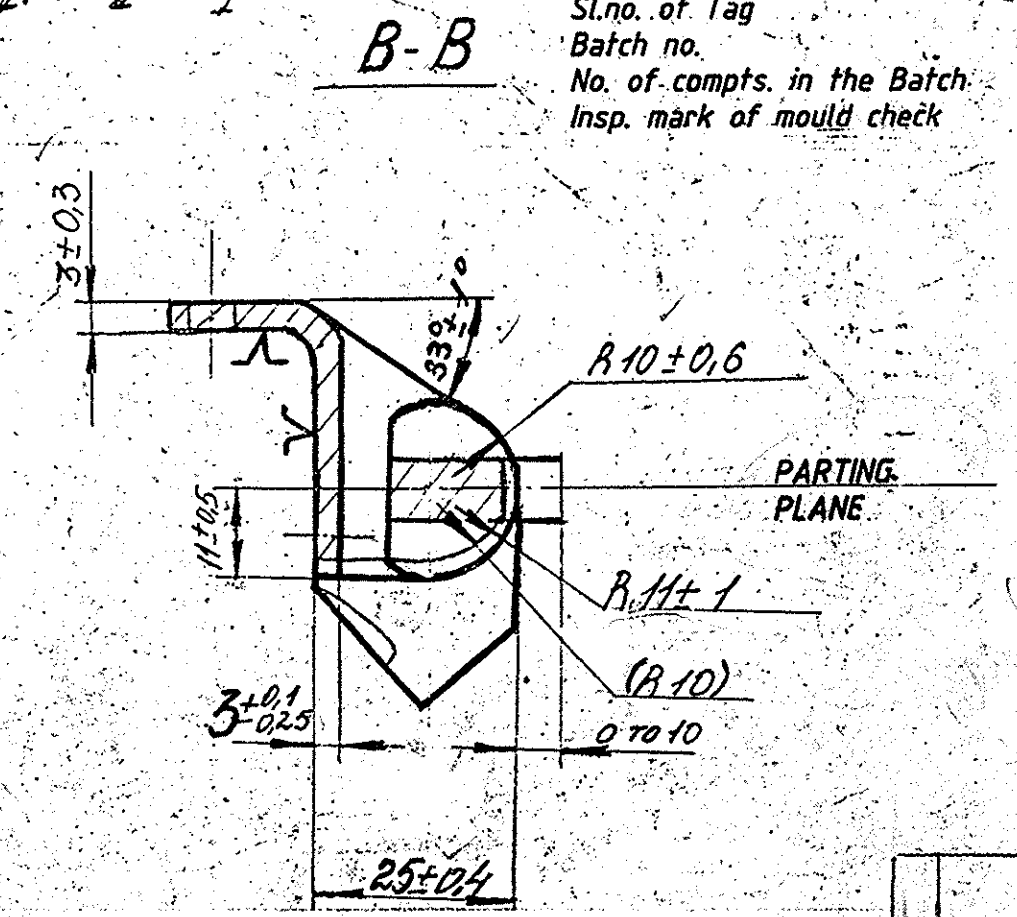
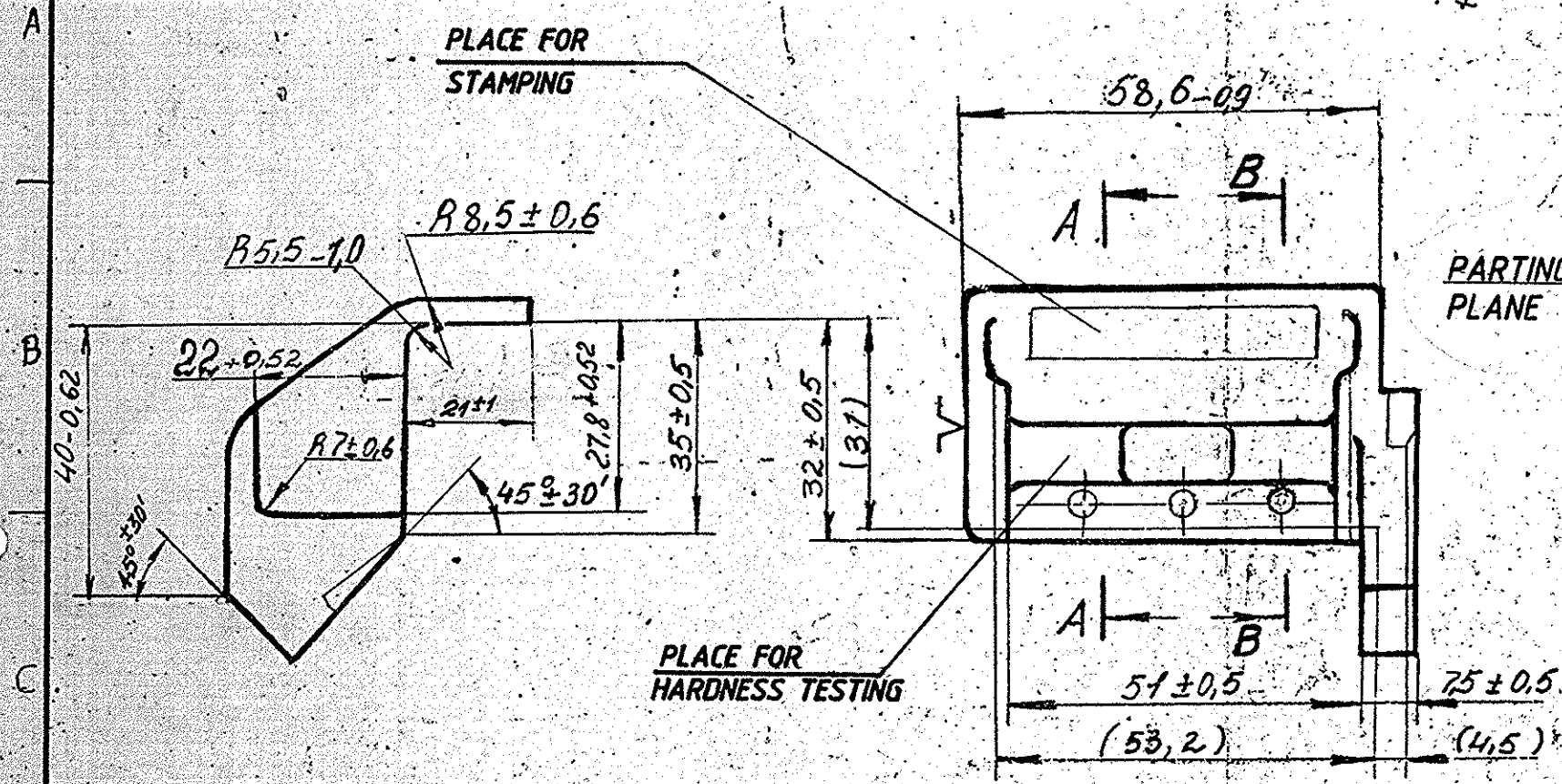


MATERIAL FOR INDIA:-  
 BS 3146 PT.1 1974 TYPE CLA. 12 GRADE 'A' TO 'GR' B CASTINGS.  
 OTHER TECH. DETAILS ARE AS PER COAIMET  
 INSPN. INST. NO. MRA-1/QA-1/12 DE 5-5-94

Details to be marked on the Tag  
 Sl.no. of Tag  
 Batch no.  
 No. of compts. in the Batch  
 Insp. mark of mould check



HARDNESS HB 241 MAX.

1. SURFACE ROUGHNESS OF CASTINGS AS PER STANDARD.
2. DRAFT ANGLE IS UP TO 1°.
3. UNSPECIFIED CASTING RADII UP TO 1mm.
4. MISALIGNMENT ALONG PARTING PLANE UPTO 0.2mm.
5. SINKAGE OF TRACES DUE TO EJECTOR IS PERMITTED UPTO 0.5mm. ON WORKING SURFACES.
6. STAMP THE SL. NO. OF THE TAG ON WHICH THE DETAILS ARE MARKED STAMP INSPECTION MARK
7. SECTION V-V FOR MEASURING DEPTH OF DECARBURIZED LAYER.
8. ON SURFACE 'B' PROJECTION DUE TO PARTING PLANE OF THE DIE IS TO BE GROUND.
9. DECREASE OF DIMENSION 'A' UP TO 34mm IS PERMITTED.
10. REFER ATTACHED SHEET FOR HEAT TREATMENT PROCESS DRG. NO. M.BB2
11. DIMNS WITHIN ( ) INDICATE AFTER MACHINING.

MATERIAL FOR INDIA:-  
 BS: 3146 PT.1:74 TYPE CLA. 12 GR. 'A' TO 'GR' B CASTINGS.  
 RADIOGRAPHIC TEST AS PER ASTM-E-192 WITH ACCEPTANCE STANDARDS FOR GAS HOLE AND FOREIGN MATERIALS. LEVEL-5  
 SHRINKAGE [ALL TYPES] LEVEL-3. ALSO REFER CQA(MET) ICHAPUR INSPECTION INSTRUCTION NO. MRA-1/QA-1/12 DE 5-5-94 FOR OTHER DETAILS

COMPONENT DRG. NO. 6P11-6-19  
 BRACKET HOLDING FRONT COVER

DA NO. 7/98 D/127 DE. 7-6-98	S. Raju 2-6-98	DA NO. 4/95 D. 12-7mm DE. 2-3-95	S. Raju 4-3-95	SHEETS : 1	1 <sup>ST</sup> ANGLE PROJECTION	Drawn	I/C PROJ.	CASTING DRG. 6P11-6-19
DA NO. 14/95 D/27 DE. 3-9-95	S. Raju 2-6-98	MATERIAL FOR INDIA ADDED	CNV/12/2/91	SHEET No : 1	SCALE : 1:1	Checked	DIV. OFFICER	DRG. NO.: 62 C. 6019 250 F3
AMENDMENTS	SIG. & DATE			ALL DIMENSIONS ARE IN mm.				

DS CAT NO. 1005007440

VETTED FOR MATERIAL ONLY  
 Principal Scientific Officer,  
 Quality Assurance Officer,  
 Senior Quality Assurance Officer,  
 Junior Quality Assurance Estt. (Arms),  
 Tiruchirappalli-620 016  
 ARAO  
 SRAE(A)  
 TRICHY.

S. Raju  
 30-11-98  
 DA. 12/98. D/12-7mm DE. 30-11-98  
 MATL. FOR INDIA AMENDED  
 DC. NO. 24/92-SA. DE. 24-10-98