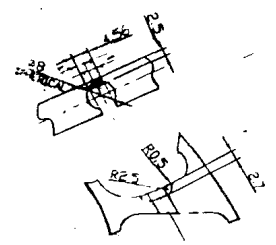
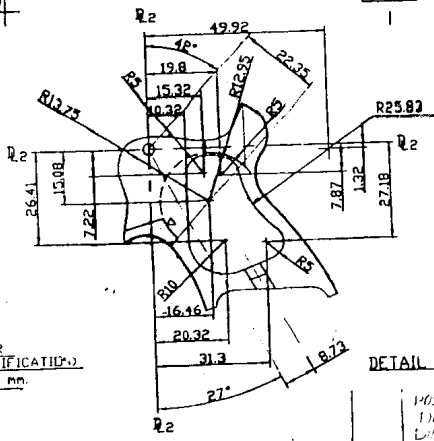
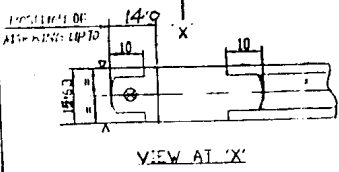
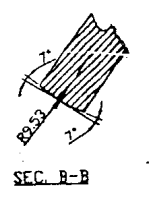
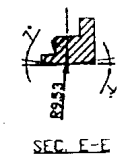
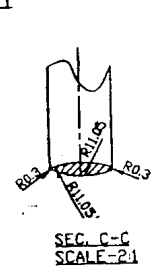
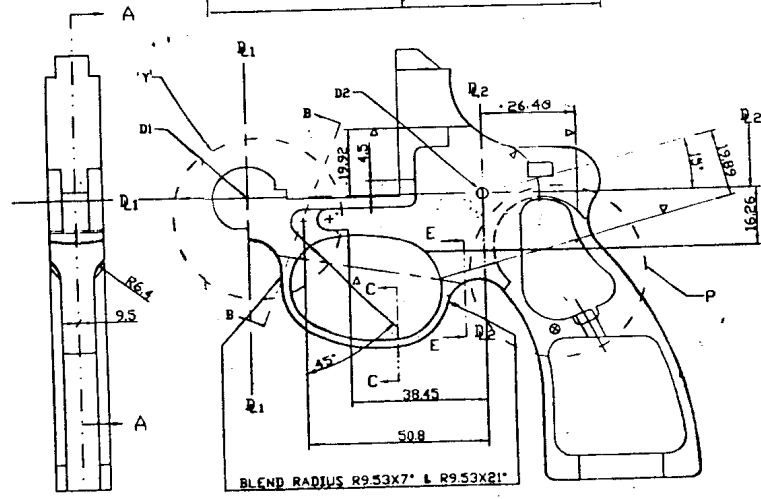
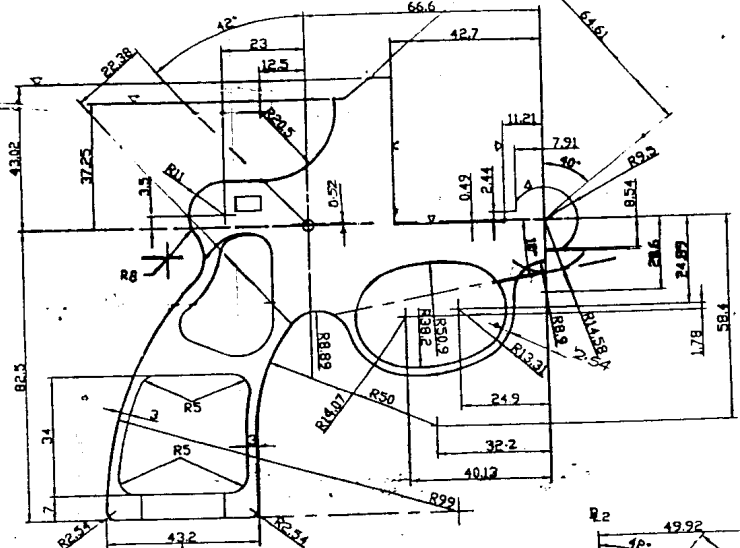
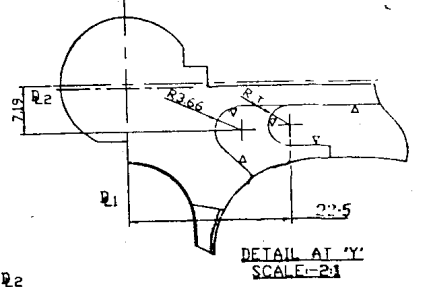
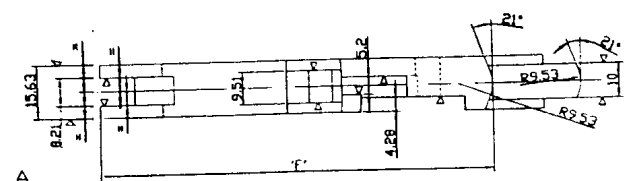
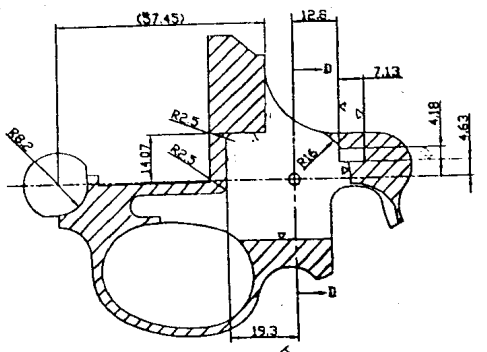
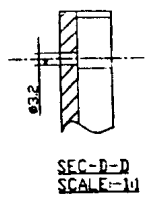


NOM. SIZE & FIT	DEVIATION

DRG. NO. SK-01397

- NOTE:-**
1. SURFACE MARKED THUS ∇ INDICATES MACHINING AT OUR END.
 2. SHARP CORNERS MAY BE AVOIDED. UNSPECIFIED FILLET RADIUS 0.5mm(MAX.)
 3. MANUFACTURE'S INITIAL, YEAR OF MANUFACTURE & BATCH NO. SHOULD BE MARKED ON THE SURFACE MARKED THUS \odot
 4. CASTING SHOULD BE SUPPLIED IN FULLY ANNEALED CONDITION.
 5. SETTING TO BE CARRIED OUT BY SUPPLIER.
 6. DIMENSIONS ARE IN MM.
 7. CASTING SHOULD BE FREE FROM CRACKS, BLOW HOLES AND ANY OTHER SURFACE DEFECTS.
 8. 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.
 9. EACH PILOT BATCH BEFORE THE BULK PRODUCTION CLEARANCE WILL HAVE TO BE TESTED FOR RADIOGRAPH TO INSURE QUALITY AND SOUNDNESS OF THE CASTING THERE AFTER SX CASTING FROM THE BULK SUPPLY SHALL BE REQUIRED TO BE EXAMINE FOR RADIOGRAPHIC TEST BY THE FIRM & SUCH RECORD PROVIDED TO US.
 10. ALONGWITH THE BULK SUPPLY THE MATERIAL TEST CERTIFICATE AND CHEMICAL ANALYSIS REPORT WILL BE REQUIRED TO BE FURNISHED FOR EACH CASTING/HEAT OF MATERIAL USED FOR POURING OF CASTINGS.
 11. ADEQUATE CARE SHOULD BE TAKEN TO ENSURE THAT THERE IS NO DECARBURISATION OF THE CASTING.
 12. 100% CASTING WILL BE REQUIRED TO BE TESTED FOR MAGNETIC CRACK DETECTION TO ENSURE THAT CASTING ARE FREE FROM CRACKS.
 13. APPROXIMATE WEIGHT-270g
 14. ZONE MARKED 'F' HAVE FLATNESS $\pm 0.1/25.4$ mm



MATERIAL :- BS.9146 PART-1 -1974 CLA. 5A
HEAT TREATMENT-ANNEALING
(TEST PIECE IS TO BE TESTED FROM ONE CASTING DULY PREPARED & TEMPERED FROM EACH CAST FOR MECHANICAL PROPERTIES STIPULATED IN THE SPECIFICATION)
UNSPECIFIED TOLERANCE- ± 0.10 mm FOR EACH 25 mm.
ANGULAR TOLERANCE- ± 0.30
MIN. FILLET RADIUS-0.3mm

POSITION OF MARKING UP TO 14 MARKS
DIM. 7.25, 39.278, 34.6, 11.11, 11.11
LARGEST RADIUS 11.05 - RIGIDLY CHECKED
AUTHORITY - REV. 1/10/2004

ITEM	DESCRIPTION	NOOFF	MATERIAL	TREATMENT	STD.	REMARKS
SCALE:-	1:1		COMPONENT	STOR. DRG. NO.		FIELD GUN FACTORY KANPUR
UNSPECIFIED TOLERANCES IS :-	± 0.102 (MCDLMO)		32 REVOLVER BODY MK-III			APPROVED
2004	DATE	NAME				J.C. WARD/J.C. WARD
DRN.	276					DRG. NO. 01397
CHD.						SHT. 1
TCD.						SHT. NO. 1
COMP.						
J.W.M/D.D.						
J.W.M/SEC.						

BODY SKETCH FOR INVESTMENT CASTING

FG-14

APPD