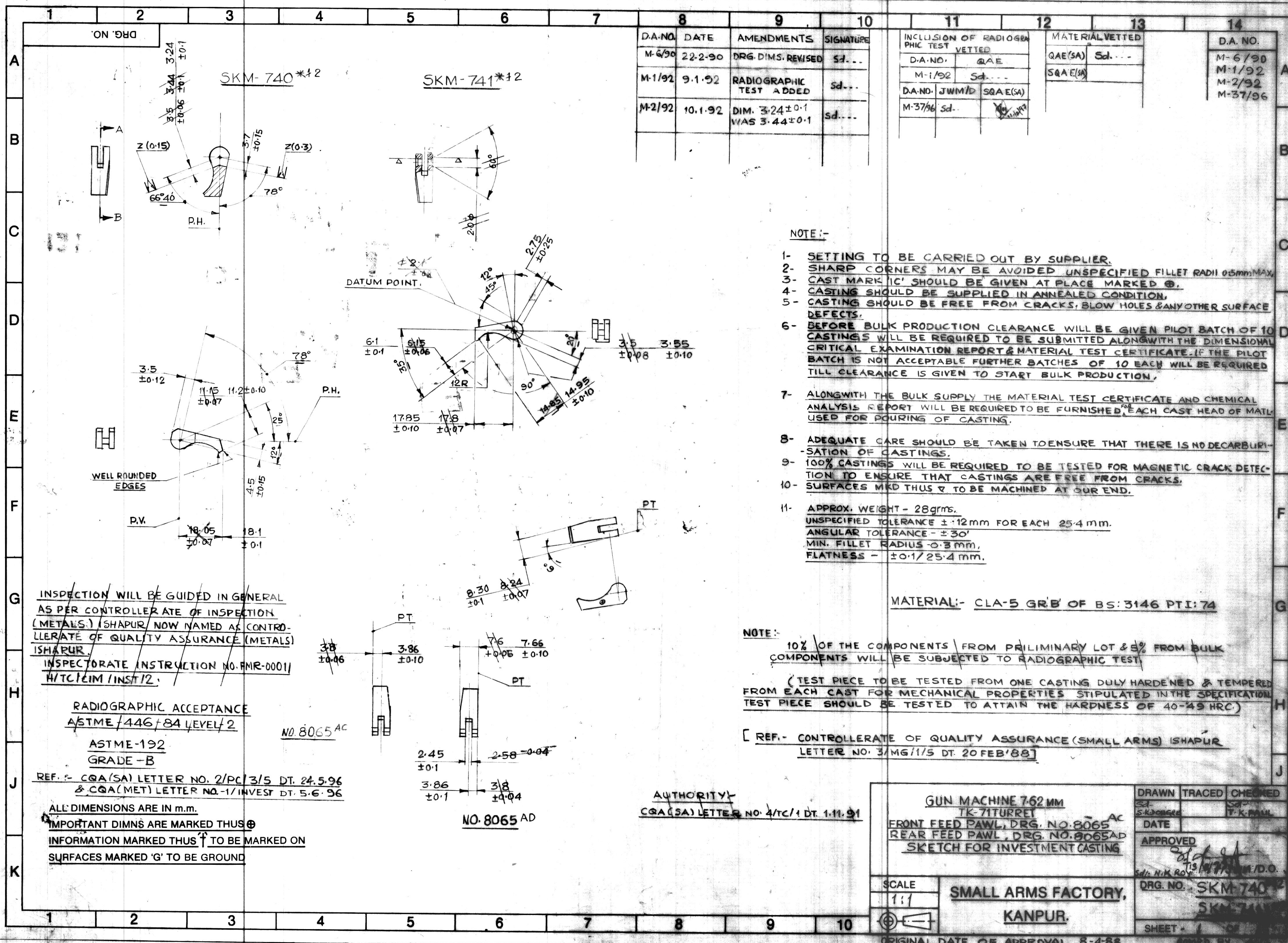




D.A. NO.	DATE	AMENDMENTS	SIGNATURE
M-6/90	22-2-90	DRG. DIMS. REVISED	Sd...
M-1/92	9.1.92	RADIOGRAPHIC TEST ADDED	Sd...
M-2/92	10.1.92	DIM. 3.24±0.1 WAS 3.44±0.1	Sd....

INCLUSION OF RADIOGRAPHIC TEST VETTED		
D.A. NO.	QAE	
M-1/92	Sd...	
D.A. NO.	JWM/D	SQAE(SA)
M-37/96	Sd...	

MATERIAL VETTED		D.A. NO.
QAE(SA)	Sd...	M-6/90
SQAE(SA)		M-1/92
		M-2/92
		M-37/96

NOTE:-

- 1- SETTING TO BE CARRIED OUT BY SUPPLIER.
- 2- SHARP CORNERS MAY BE AVOIDED UNSPECIFIED FILLET RADII 0.5mm MAX.
- 3- CAST MARK 'IC' SHOULD BE GIVEN AT PLACE MARKED ⊕.
- 4- CASTING SHOULD BE SUPPLIED IN ANNEALED CONDITION.
- 5- CASTING SHOULD BE FREE FROM CRACKS, BLOW HOLES & ANY OTHER SURFACE DEFECTS.
- 6- BEFORE BULK PRODUCTION CLEARANCE WILL BE GIVEN PILOT BATCH OF 10 CASTINGS WILL BE REQUIRED TO BE SUBMITTED ALONG WITH THE DIMENSIONAL CRITICAL EXAMINATION REPORT & 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- ALONG WITH THE BULK SUPPLY THE MATERIAL TEST CERTIFICATE AND CHEMICAL ANALYSIS REPORT WILL BE REQUIRED TO BE FURNISHED FOR EACH CAST HEAD OF MATL. USED FOR POURING OF CASTING.
- 8- ADEQUATE CARE SHOULD BE TAKEN TO ENSURE THAT THERE IS NO DECARBURIZATION 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 - 28grms.
UNSPECIFIED TOLERANCE ± 0.12mm FOR EACH 25.4 mm.
ANGULAR TOLERANCE - ± 30°
MIN. FILLET RADIUS 0.3mm.
FLATNESS - ± 0.1/25.4 mm.

MATERIAL:- CLA-5 GR'B OF BS: 3146 PTI: 74

NOTE:-

10% OF THE COMPONENTS FROM PRELIMINARY LOT & 5% FROM BULK COMPONENTS WILL BE SUBJECTED TO RADIOGRAPHIC TEST.
(TEST PIECE TO BE TESTED FROM ONE CASTING DULY HARDENED & TEMPERED FROM EACH CAST FOR MECHANICAL PROPERTIES STIPULATED IN THE SPECIFICATION. TEST PIECE SHOULD BE TESTED TO ATTAIN THE HARDNESS OF 40-49 HRC)

[REF:- CONTROLLERATE OF QUALITY ASSURANCE (SMALL ARMS) ISHAPUR
LETTER NO. 3/MG/1/5 DT. 20 FEB/88]

AUTHORITY:-
CQA(SA) LETTER NO. 4/TC/1 DT. 1.11.91

GUN MACHINE 7.62 MM TK-71 TURRET FRONT FEED PAWL, DRG. NO. 8065 AC REAR FEED PAWL, DRG. NO. 8065 AD SKETCH FOR INVESTMENT CASTING		DRAWN SKJONGRE	TRACED T.K. RAUL	CHECKED Sd...
DATE		APPROVED Sd/ NIK ROY		
SCALE 1:1		DRG. NO. SKM-740		
SMALL ARMS FACTORY, KANPUR.		SHEET - 1 OF 1		
ORIGINAL DATE OF APPROVAL 8-4-88				

INSPECTION WILL BE GUIDED IN GENERAL AS PER CONTROLLERATE OF INSPECTION (METALS) ISHAPUR NOW NAMED AS CONTROLLERATE OF QUALITY ASSURANCE (METALS) ISHAPUR.
INSPECTORATE INSTRUCTION NO. FMR-00011
H/TC/1/M/INST/2.

RADIOGRAPHIC ACCEPTANCE
ASTME/446/84 LEVEL 2
ASTME-192
GRADE - B

REF:- CQA(SA) LETTER NO. 2/PC/3/5 DT. 24.5.96
& CQA(MET) LETTER NO. 1/INVEST DT. 5.6.96
ALL DIMENSIONS ARE IN m.m.
IMPORTANT DIMNS ARE MARKED THUS ⊕
INFORMATION MARKED THUS † TO BE MARKED ON
SURFACES MARKED 'G' TO BE GROUND

NO. 8065 AC

NO. 8065 AD