

GROUP-B

15. 10343-1982 K A & L (FOR THIS I.C. - 15) OF 15: 2500 P6.1 INSPECTION LEVEL IV

3. THE TEST SPECIMENS ARE TESTED FOR HARDNESS AT ANNEALED CONDITION & ALSO AFTER FINAL HEAT TREAT TO ACHIEVE HARDNESS 400-500 H.V.

4) DEARBURISHMENT SHOULD NOT BE MORE THAN 2% OF THE THICKNESS OF THE CASTING.
5) ALL CASTINGS & REPRESENTATIVE TEST SAMPLES SHALL BE LEGIBLY MKD WITH IDENTIFICATION MARK.

6) TEST SAMPLES SHOULD BE CAST FROM THE SAME MELT USED FOR MANUFACTURING OF THE CASTING & SHOULD BE MADE TO SATISFY THE SPECN. IS. 10343-1962.

9) MAGNETIC TEST FOR CRACK DETECTION TO BE CARRIED OUT IN SAMPLES AS PER INSPECTION LEVEL III AT AQL 0.65 AS PER IS:2500 PRT-1965

10. CASTING SHOULD BE SUBJECTED TO RADIOGRAPHY BY USING X-RAYS. GOMMA RAYS SHALL NOT BE PERMITTED AT ALL UNLESS THE THICKNESS RANGE OF 25 mm.

(b) UNLESS OTHERWISE STATED THE RADIOGRAPHIC ACCEPTANCE STD. OF THE CASTING SHOULD BE AS FOLLOWS:-

-3. (c) 100% OF THE ADVANCE SAMPLES SHALL BE SUBJECTED TO DADUOGRAPHIC TEST.

1) 10 TO 15 Nos. SAMPLES CASTING DULY PASSED BY INSPECTOR FOR
SUBJECTED TO RADIOGRAPHIC TEST.
2) EACH OF CAST/HEAR SHOULD BE
WELDED BY COMPONENTS.

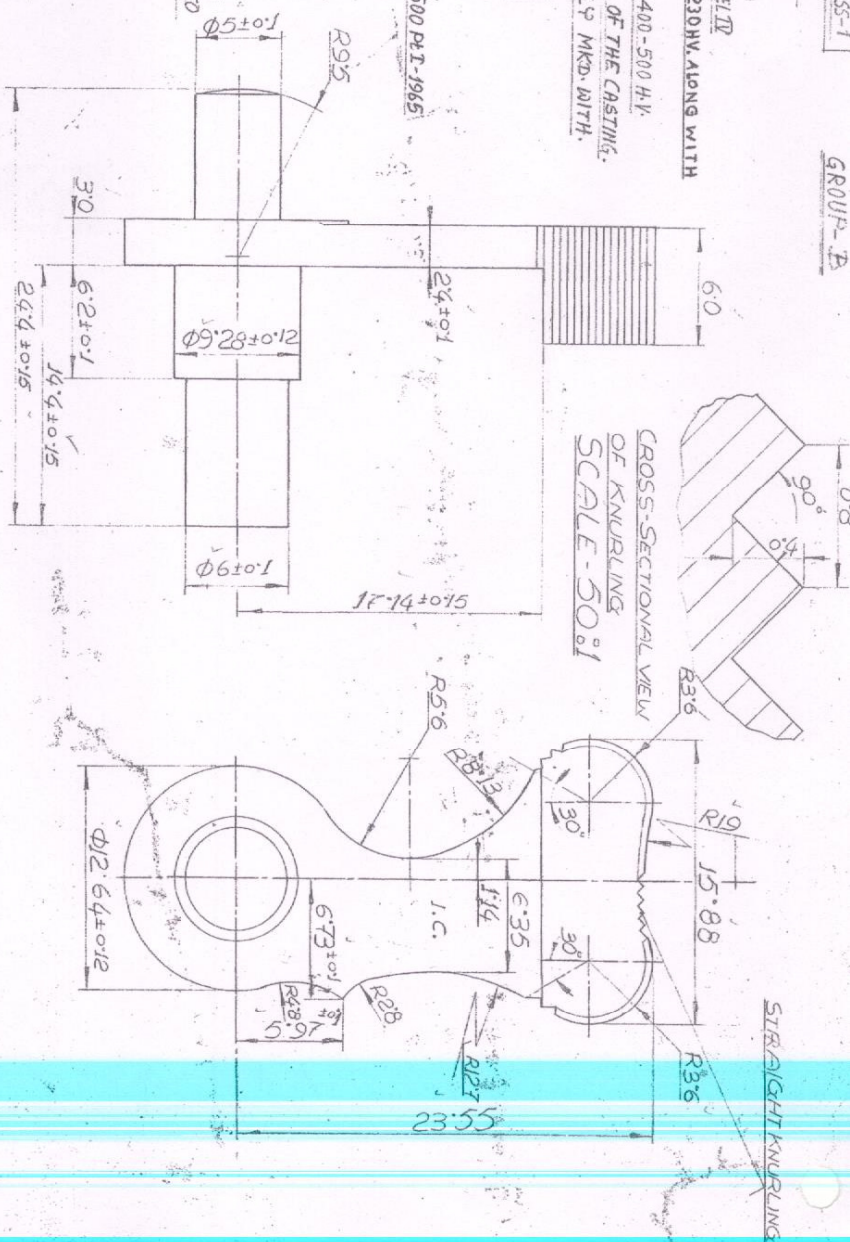
KINOKRAPHIC TESTS, MAT. DIMENSIONS ETC. ARE TO BE SENT TO THIS FACTORY FOR MACHINING & FITMENT TRIAL BEFORE BULK SUPPLY.

3.	30-6-03	IN NOTE 3, "WITH 190-230 HV," ADDED. ORG. NO. ADVANCED TO REL:SK. 3712/C AUTHORITY: LETTER NO. 62(LN)/ICL QUALITY REVIEW. DT. 04-3-03.	 J. L. SMITH 10/6/03
2.	5-12-95	NOTES FOR CONDITION REVISED. ORG. NO. ADVANCED TO REL:SK-3712/D. AUTHORITY: WIDE C&A (MET)'S LETTER NO. MGH-4190-111E DT. 5-6-95	 J. L. SMITH 10/6/03
1.	27-8-33	REDESIGNED. ORG. NO. ADVANCED TO REL:SK-3712/A	 J. L. SMITH 10/6/03

RECOMMENDATIONS

WT: 17 gm / 3 gm / 5 gm JT: GM / PL Litter no. 56 / P 2 P / 5, 56 Dt. 26-11-2011

(NOTE: FOR MEDAK SUPPLY)



H105/MPH

प्रमाणित प्रती / CERTIFIED COPY OF

DRG/LAYOUT/GAUGE SCHEDULE

10/10/2016

THE FACTORY, ISHAPPORE

1953	NAME	DATE
DGM	AKA	278
DBT		
CKO	NO	
APPD	MM	28170
DRAWING		
RFL 543721C		
SHEET 001		

MAT. B.S. 3146 PART-1-1974, TYPE CLA-12 GR-A

TO ACHIEVE HARDNESS 400-500 HKN.
[AS PER COM(MET), SINGAPORE, LETTER NO. MOD-102

(SEE NOTE-3)