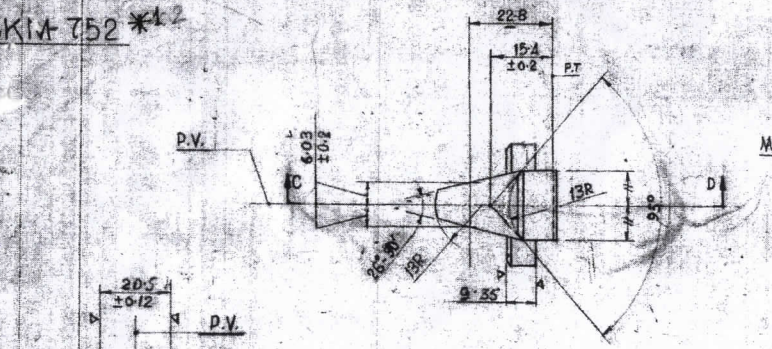
SKM-752 *12



MATERIAL:- B.S. 3146 Pt 1-74
TYPE CLA-3

DATE	DR.NO	AMENDMENT	FIDO
21-3-92	M3/92	VIEWS CORRECTED	
P.1.92	M 1/92	RADIOGRAPHIC TEST ADDED	
16.11.92	M3/92	RADIOGRAPHIC TEST ATTACHED	
21.1.93	M 31/92	2mm RADIUS ADDED	

NOTE:-

1- SETTING TO BE CARRIED OUT BY THE SUPPLIER.
2- SHARP CORNERS MAY BE AVOIDED UNSPECIFIED FILLET RADII 0·5mm. MAX.
3- CAST MARK 'IC' SHOULD BE GIVEN AT PLACE MKD. THUS ⊕
4- CASTING SHOULD BE SUPPLIED IN ANNEALED CONDITION.
5- CASTING SHOULD BE FREE FROM CRACKS, BLOW HOLES AND ANY OTHER SURFACE DEFECTS.
6- 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.
7- ALONGWITH THE BULK SUPPLY, THE MATERIAL TEST CERTIFICATE AND CHEMICAL ANALYSIS REPORT WILL REQUIRED TO BE FURNISHED FOR EACH CAST HEAD OF MATERIAL USED FOR POURING OF CASTING. ADEQUATE CARE SHOULD BE TAKEN TO ENSURE THAT THERE IS NO DECARBURISATION OF CASTINGS.
8- 100% CASTING WILL BE REQUIRED TO BE TESTED FOR MAGNETIC CRACK DETECTION TO ENSURE THAT CASTINGS ARE FREE FROM CRACKS.
9- SURFACES MKD. THUS ▽ TO BE MACHINED AT OUR END.

APPROX WEIGHT
UNSPECIFIED TOLERANCE ± 12mm FOR EACH 25·4mm.
ANGULAR TOLERANCE ± 30'
MIN. FILLET RADIUS 0·3mm.
FLATNESS ± 10/25·4 mm.

RADIOGRAPHIC ACCEPTANCE STD AS PER MIL-I-19 2 GRADE-A
AS PER ASTM-A 148-84 LEVEL-5
FOR RADIOGRAPHIC (TYPE CLA-3)
CASTINGS AS PER P.C. NO.

NOTE: 10% OF THE COMPONENTS FROM A PRELIMINARY LOT AND 5% FROM BULK COMPONENTS WILL BE SUBJECTED TO RADIOGRAPHIC TEST
(AUTHORITY: QI-(SA) LETTER NO. 4/MGH/1 DT. 6.11.91)

INSPECTION WILL BE GUIDED IN GENERAL AS PER CONTROLLERATE OF INSPECTION (METALS) ISHAPUR, NOW NAMED AS CONTROLLERATE OF QUALITY ASSURANCE (METALS) ISHAPUR.
INSPECTION INSTRUCTION NO FMR 0001 H/TC/CIM/INST-2

(TEST PIECE TO BE TESTED FROM ONE CASTING DULY HARDENED AND TEMPERED FROM EACH CAST FOR MECHANICAL PROPERTIES STIPULATED IN THE SPECIFICATION. TEST PIECE SHOULD ALSO BE TESTED TO ATTAIN THE HARDNESS OF ---)

SECTION AB
SCALE 2:1

PARTIAL SECTION C.D

Ref CQA(SA) letter no 2/Pt/315 dt 24 Aug 94

REF. CONTROLLERATE OF QUALITY ASSURANCE (SMALL ARMS) ISHADUR LETTER NO. 3/MGH/5 DT. 23 JULY 88

DIMENSIONS ARE IN MM.

MATERIAL VETTED
GAE(SA)

GUN MACHINE 7·62 MM
TK-71 TURRET
BRACKET CARRYING HANDLE, DRG. NO. 4015 AB
SKETCH FOR INVESTMENT CASTING

DRN.
CHKD.
APPROVED

SCALE 4:1

SMALL ARMS FACTORY
KANPUR

DRAWING NO.
SKM-752
SHT 1 OF 1