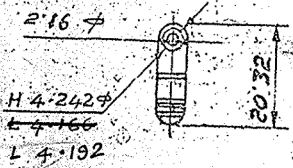


STRAIGHT KNURL 1:27 PITCH X .64
DEEP 5 KNURLS



TOLERANCE OF THE MACHINED COMPONENTS:-
WHERE TOLERANCES ARE NOT SHOWN DIMENSIONS IN WHOLE NUMBER OR WITH ONE DECIMAL PLACE ± 0.27 DIMENSIONS WITH TWO DECIMAL PLACES ± 0.13 .

TOLERANCE FOR ANGLES:-
ANGLES GIVEN IN DEGREES ± 30 MINUTES.
ANGLES GIVEN IN DEGREES & MINUTES ± 5 MINUTES.

TOLERANCE OF THE I.C. COMPONENTS:-
WHERE TOLERANCE NOT GIVEN GENERAL TOLERANCE I.S. 11166 CLAUSE I TO BE FOLLOWED. EXCESS MATERIAL FOR MACHINING IS ALLOWED. ABSENCE OF MATERIAL IS NOT ACCEPTABLE. REJECTION AT OUR END FOR WANT OF MATERIAL IS NOT ACCEPTABLE.

MATERIAL:- (FOR INVESTMENT CASTING)
CLA-1 gd B TO BS: 3146 Pt 1 74 IN ANNEALED & MACHINABLE CONDITION.

DIMENSIONS ARE IN mm.

<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
INVESTMENT CASTING STUDY TEAM		

1A/2002/R
24A/95/R
12A/95/R
30A/94/R

RADIOGRAPHIC TEST AS PER ASTM-E-192 GRADE B

NON-STRESSED COMPONENTS:-
100% FOR ADVANCE SAMPLES.
FOR BULK COMPONENTS, 5% OF EACH CAST/HEAT SHOULD BE SUBJECTED TO RADIOGRAPHY FOR GD 'B' CASTINGS.

RADIOGRAPHIC ACCEPTANCE LIMIT:-
GRADE B CASTINGS
GAS HOLES - LEVEL-5
FOREIGN MATERIAL - LEVEL-5
SHRINKAGE (ALL TYPES) - LEVEL-3

VISUAL EXAMINATION:-
AS PER IS: 26500-P4.1-1992 INSP. LEVEL III AQL 1.5
INVESTMENT CASTINGS ARE TO BE TESTED AS PER SPECN. NO: MQA-1/BA1/12 dt: 5/94

VETTED FOR MATERIAL ONLY

[Signature]
Regional Scientific Officer,
Quality Assurance Officer,
For Senior Quality Assurance Officer,
Senior Quality Assurance Est. (Grm's)
Tiruchirappalli - 620 016.

7A/06/R	DIMS. L 4.166 IS AMENDED TO L 4.192.	<i>[Signature]</i> 08/06	<i>[Signature]</i>
D.A. NO.	DESCRIPTION.	SIGN. & DT.	WM/ASSY.

AS STATED ABOVE		NO OFF	MATERIAL	TREATMENT	REMARKS
ITEM NO.	DESCRIPTIONS				
①	SIGNATURE & DATE				
DRAWN	<i>[Signature]</i>				
CHECKED	<i>[Signature]</i>				
TRACED					
TRACING CHECKED					
I/C DESIGN & DRG. OFFICE					
APPROVED ON:					
AMENDMENTS					
SIGNATURE & DATE					
DIVISION OFFICER					
SCALE: 1:1					
STORE DRG NO ICR 1297					
OPERATION NO					
DRG. NO: TEND. 921 E					
SHEETS: 1					
SHEET NO. 1					

