

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 GR B CASTINGS

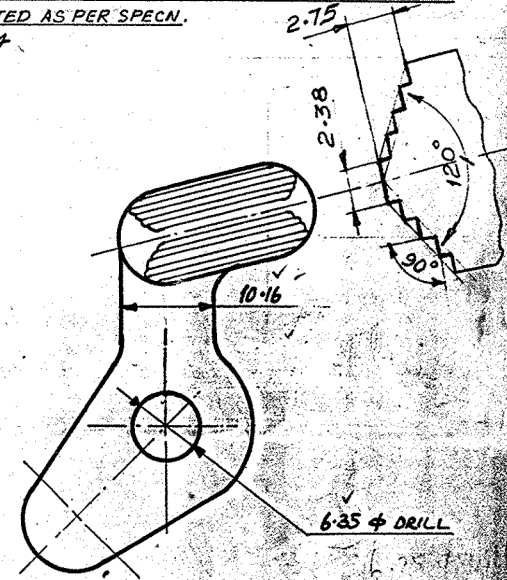
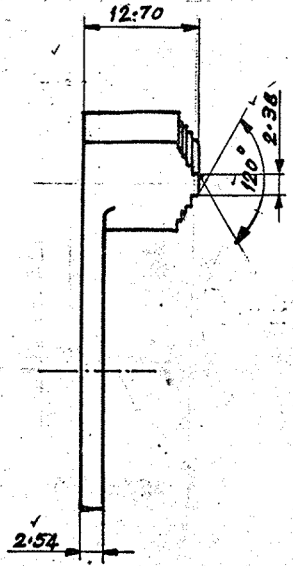
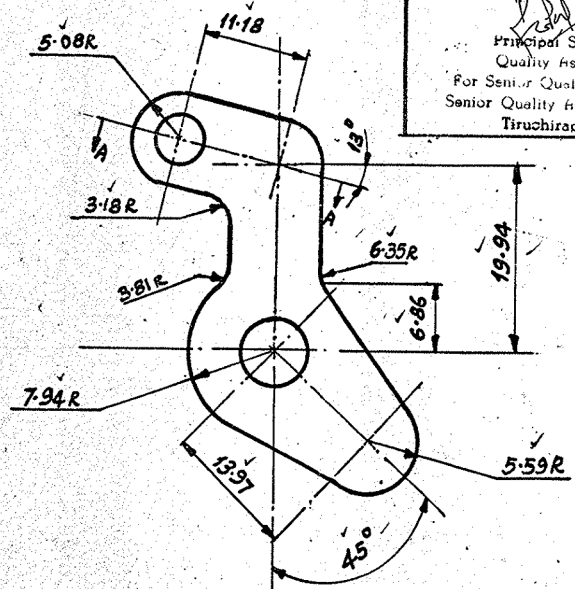
RADIOGRAPHIC ACCEPTANCE LIMITS

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

VISUAL EXAMINATION AS PER IS: 2500-PT. I: 1992 INSR LEVEL III AQL 1.5
 INVESTMENT CASTINGS ARE TO BE TESTED AS PER SPECN. NO. MBA-1/2 QAI/12 dt: 5.9.94

VETTED FOR MATERIAL ONLY

P. S. Raju
 Principal Scientific Officer,
 Quality Assurance Officer,
 For Senior Quality Assurance Officer,
 Senior Quality Assurance Estn (Hrms),
 Tiruchirappalli - 620 016.



ENLARGED VIEW OF SERRATION DETAILS

TOLERANCE CLAUSE AS PER SPEN. I.S. 11166 - 1984.
 (FOR INVESTMENT CASTINGS) CLAUSE I TO BE FOLLOWED.

ALL DIMNS. ARE IN MM

① INVESTMENT CASTING NORMALIZED & SOFTENED TO HARDNESS: 180 HV to 220 HV
~~HARDNESS - 240-250 HV (H-11-1100)~~

* AUTHY

CQA(SA) LETTER NO. 3/R/S/INVEST
 DT: 13-8-92 & NO. 022/10/000 DT: 23-9-93

- ① 08A/2006/R
 - 24A/95/R
 - 12A/95/R
 - 30A/94/R
 - 29A/92/R
 - 26A/90/12
 - 30A/91/R
- AMENDMENTS

INVESTMENT CASTING IN NORMALISED CONDITION.

DRN.	<i>Archie</i>	SCALE: 2:1	3RD & PROTN.	MATL: (INVESTMENT CASTING) B5-3146 Pt-1:1974 TYPE CLA-5 GR-A	DRG NO
CHD.	<i>Subramaniam</i> 23/9	<i>Archie</i> 23/9	DIV. OFFICER.	COMPONENT NO. 04-1312	TEND 658 G

(1005-001644)

LEVER CHANGE

RE-NEG. TAKEN ON 1/02

TCR 1312