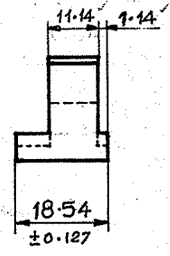
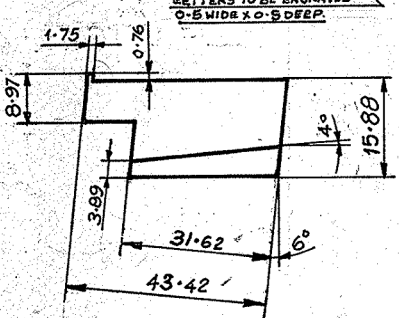


VETTED FOR MATERIAL ONLY

G.M.
(K.K. MURTHY)
 LT COL
 QUALITY ASSURANCE OFFICER
 for Sr. Quality Assurance Officer
 SQA E (A), TIRUCHIRAPALLI-620016

DIMENSION ARE IN MM.
TOLERANCE OF THE I.C. COMPONENT
IS: 11166-1984 CLASS-I TO BE FOLLOWED.



LETTERS TO BE ENGRAVED
 0.5 WIDE X 0.5 DEEP

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 GA. 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: 2500-P-I-1992 INSP. LEVEL III AQL 1.5
 INVESTMENT CASTINGS ARE TO BE TESTED AS PER
 SPECN. NO. MQA-1/RAI/12 dt. 5.5.94

MATERIAL:- BS:3146-Pt-1 1974 TYPE CLA-
 12 GR-A HARDNESS TO ACHIEVE
 H.V. 400-475.

CASTING TO BE IN THE NORMALISED
 CONDITION. HARDNESS 200-220 VHN

				AS STATED	AS STATED	-
ITEM NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS	
24/11/95/R 12A/95/R 1A/95/R 30A/94/R	SIGNATURE & DATE DRAWN: <i>[Signature]</i> CHECKED: <i>[Signature]</i> TRACED: TRACING CHECKED: T. Anubhavan 06/94 I/C DESIGN & DRG. OFFICE					SUB: RAMP BACK SIGHT REF: DS CAT. NO 1005-001606 INVESTMENT CASTING DES. REF NO: DRG. NO: TEND. 1100D
AMENDMENTS & DATE	SIGNATURE & DATE	APPROVED ON: 06/94	DIVISIONAL OFFICER ORDNANCE FACTORY, TIRUCHIRAPALLI.			SCALE: 1:1 STORE DRG NO ICR 1253 OPERATION NO SHEETS: 1 SHEET NO 1

REF:- No. P52/22/IC/14 DT. 24.5.94.