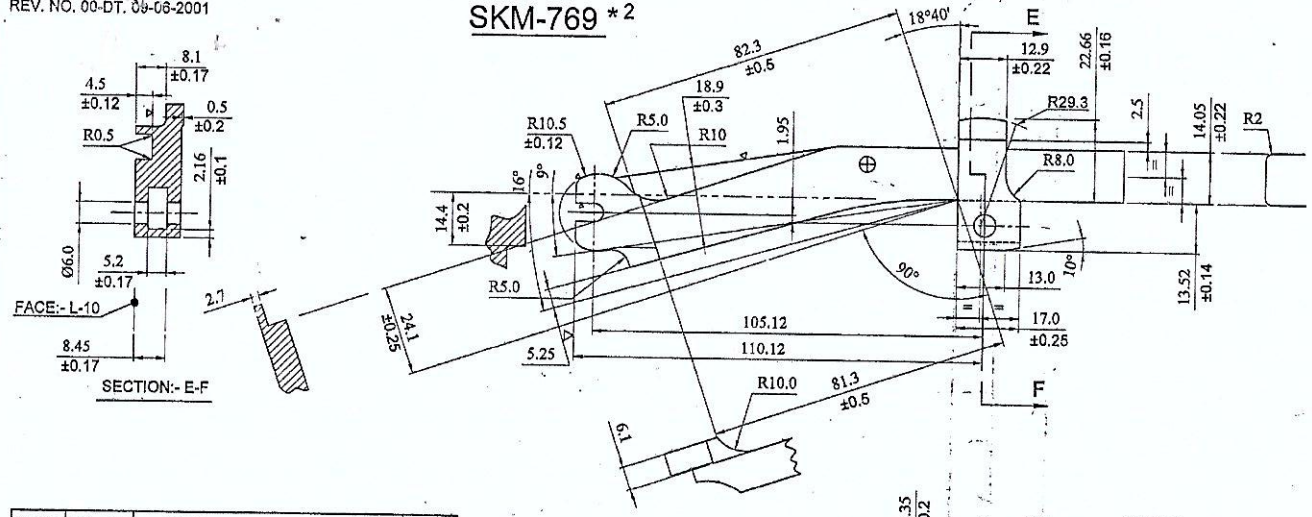
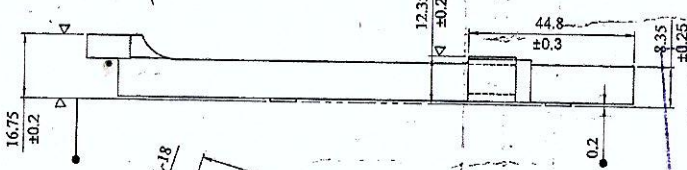
DRG. NO. SKM-769 *2

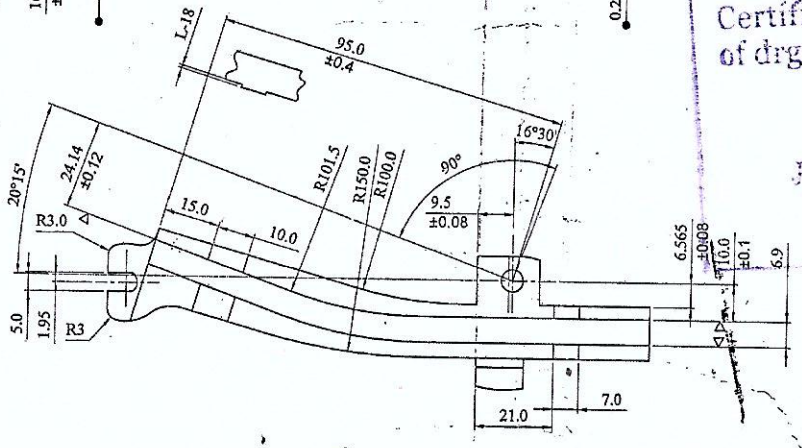
NO. QS/ISO-9000/DT/01
REV. NO. 00-DT. 09-06-2001

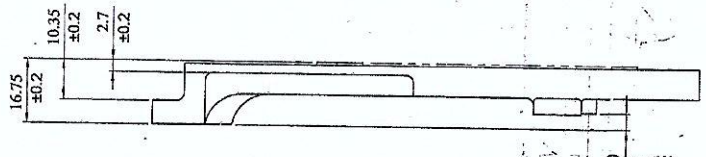
SKM-769 *2



DATE	D.A. NO.	AMENDMENT	F/DO
07-08-90	M-23/90	DIMS. R5, R100, R150 ADDED & DINS. 1.3,R1, 0.15 MAX, 14, 5 & 2 DELETED.	Sd.....
09-1-92	M-1/92	RADIOGRAPHIC TEST ADDED	Sd.....
08-08-92	M-20/92	DIM. 10 IN ZONE S-14 DELETED. NOTE :- (IN ZONE R3) ADDED	Sd.....







NOTE :-
COMPONENT SHOULD BE SUPPLIED IN NORMALISED, ANNEALED & GRAIN REFINED CONDITION. COMPONENT SHOULD BE SET STRAIGHT.

REF. :- CONTROLLER OF INSPECTION (METAL)
LETTER NO. FMR 0236 G/S/TS Dt. 12-09-79

REF. :- CHANNEL FEED . NO. 36020/4802
PLANCHE L-459 (CLASS- 0072)

DIMENSIONS ARE IN mm.

D.A. NO.	JWM/D	SQAE (SA)	MATERIAL VETTED
M-37 / 96	Sd....		QAE (SA)
		(N.L.VERMA)	INCLUSION OF RADIOGRAPHIC TEST D.A. NO. M-1/92 VETTED
			QAE (SA)

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 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 BE REQUIRED TO BE FURNISED FOR EACH CAST HEAD OF MATERIAL USED FOR POURING OF CASTINGS. ADEQUATE CARE SHOULD BE TAKEN TO ENSURE THAT THERE IS NO DECARBURISATION OF CASTINGS.
8. 100% CASTINGS WILL BE REQUIRED TO BE TESTED FOR MAGNETIC CRACK DETECTION TO ENSURE THAT CASTINGS ARE FREE FROM CRACKS.
9. SURFACE MKD. ▽ TO BE MACHINED AT OUR END.

Certified as correct copy of drg. on 2-9-19
Jr. Works Manager

APPROXIMATE WEIGHT:-
UNSPECIFIED TOLERANCE ±0.12mm. FOR EACH 25.4mm.
ANGULER TOLERANCE ± 30'
MINIMUM FILLET RADIUS 0.3mm.
FLATNESS :- ±10/25.4mm.

NOTE :- 10% OF THE COMPONENTS FROM PRELIMINARY LOT AND 5% FROM BULK COMPONENTS WILL BE SUBJECTED TO RADIOGRAPHIC TEST.
AUTHORITY- CQA (SA) LETTER NO. 4/TC/I Dt. 01-11-91
TEST PIECE TO BE TESTED FROM ONE CASTING DULY HARDENED AND TEMPERED FOR EACH CAST FOR MECHANICAL PROPERTIES STIPULATED IN THE SPECIFICATION .
RADIOGRAPHIC ACCEPTANCE STD.
ASTM - E 192
GRADE -B
REF. :- CQA(SA) LETTER NO. 2/PC/3/5/ Dt. 24-05-96 & CQA(MET) LETTER NO. MQA- 1/INVEST Dt. 05-06-96

MATERIAL:-
B.S. 3146 PT-1 1974 TYPE CLA-4
OR AS PER AISI 8650 (HIGH SILICON)
C= 0.45-0.55 , Ni= 0.4- 0.7 , Mn= 0.5 -1.0
Cr= 0.4-0.6 , Si= 0.8- 1.2 , Mo=0.15 -0.3

GUN MACHINE 7.62mm.
TK-71 TURRET
FEED ARM ,DRG. NO. 0072
SKETCH FOR INVESTMENT CASTING

DRAWN	TRACED	CHECKED
DATE	27-11-2004	
APPROVED	J.W.M./DO.	

SCALE 1:1

SMALL ARMS FACTORY
KANPUR

DRG. NO. SKM-769 *2