



MANUFACTURER IDENTIFICATION MARK HERE (SEE NOTE-II)

05

16.5

THIS FACE SHOULD BE PERFECTLY SQUARED AND STRAIGHT.

A

1. DIMENS. ARE IN mm.

- 3
1. MAGNETIC TEST FOR CRACK DETECTION TO BE CARRIED OUT ON SAMPLES AS PER INSPECTOR LEVEL IV AT AWT 0.65 AS PER IS: 2500 Pt.1 1992.
- 2
4. ALL CASTINGS AND REPRESENTATIVE TEST SAMPLES SHALL BE LEGIBLY MARKED WITH MANUFACTURERS IDENTIFICATION MARK WITH 3mm SIZE
12. RADIOGRAPHIC ACCEPTANCE STANDARD SHALL BE AS PER ASTM-E-192. GAS HOLES LEVEL-5, FOREIGN MAT. LEVEL-5 AND SHRINKAGE (ALL TYPE) LEVEL-3
11. RADIOGRAPHIC TEST TO BE CARRIED OUT AS FOLLOWS:-
100% FROM SAMPLE LOT FROM EACH SUPPLIER. THE LOT SHOULD NOT BE LESS THAN 10 NOS.
2. FROM SECOND LOT FROM EACH SUPPLIER THE LOT SHOULD NOT BE LESS THAN 100 NOS.
17. FROM IN-PERMANENT BULK SUPPLY UNTIL THE PRODUCT IS ESTABLISHED BY VENDOR.
13. 10 TO 15 NOS. SAMPLE CASTING DULY PASSED BY INSPECTOR IN RADIOGRAPHIC TEST MAT. DIMS. ETC. TO BE SET-AS-NO. IN THIS FACTORY FOR MACHINING & FITMENT TRIAL BEFORE BULK SUPPLY.
- unified*
for 30/01/19

MATERIAL										
BS 3146 Pt. 1: 1974, TYPE CLA-B (SEE NOTE 5)										
COMPOSITION OF MATERIAL		C%	Si%	Mn%	Cu%*	Cr%*	Mg%*	Ca%*	S%	P%
		37 TO 45	2 TO 6	.5 TO 1.8	1/4	.3	1	3	.035	.035
		MAX.	MAX.	MAX.	MAX.	MAX.	MAX.	MAX.	MAX.	MAX.
* RESIDUAL, THE TOTAL AMOUNT OF THESE ELEMENTS SHALL NOT EXCEED 80										
INVESTMENT CASTING DRAWING										
ORGANANCE FACTORY BOARD.										
RILE FACTORY,										
SINGAPORE										
HINTLE 535 mm.										
HINGE COVER										
ARDE SK. 314.378										
D5 CAT No. 5340-01451										
SCALE: 1:1										
										
FOR SAMPLE										
25/11/95										
DAGAD										
D/M - 25/11/95										
ONLY MAIL VENTURE										
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verified, per 6/10/19