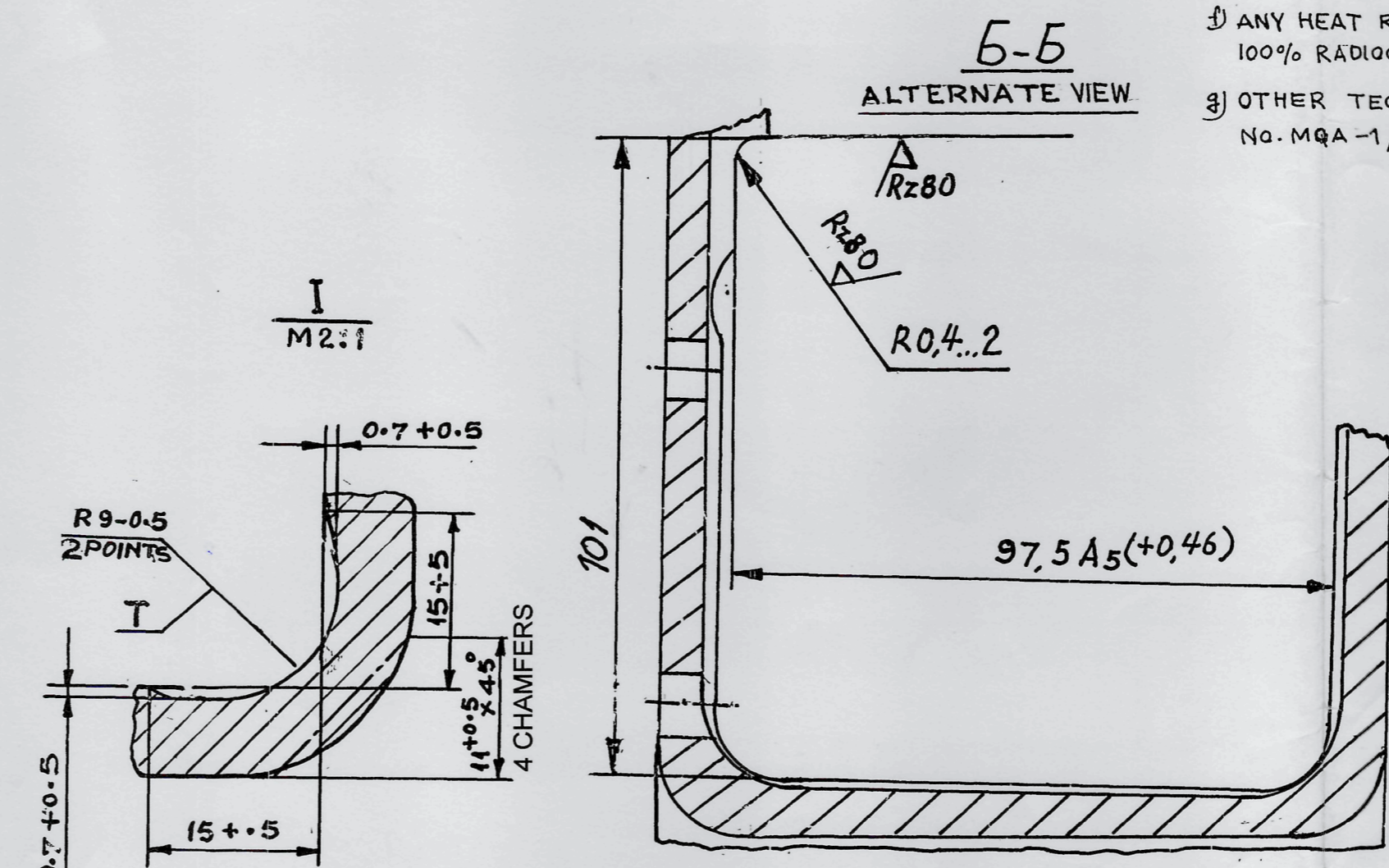
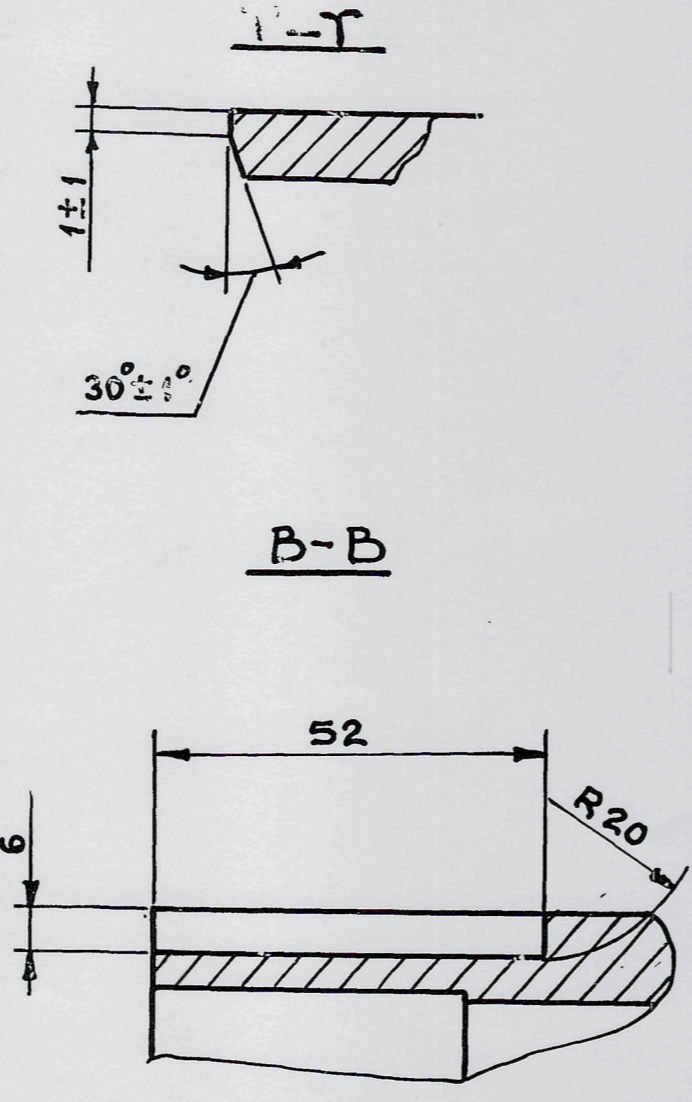
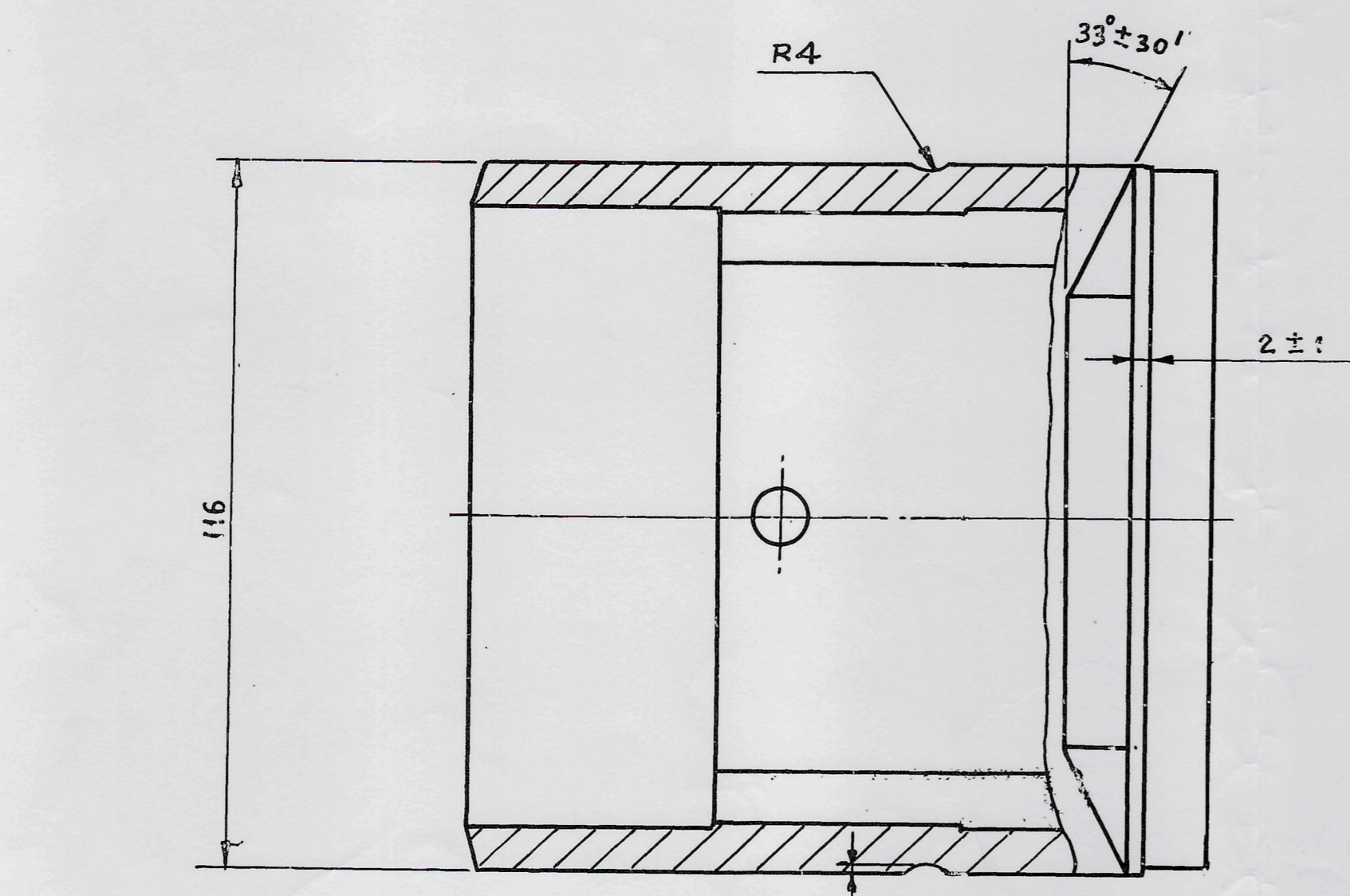
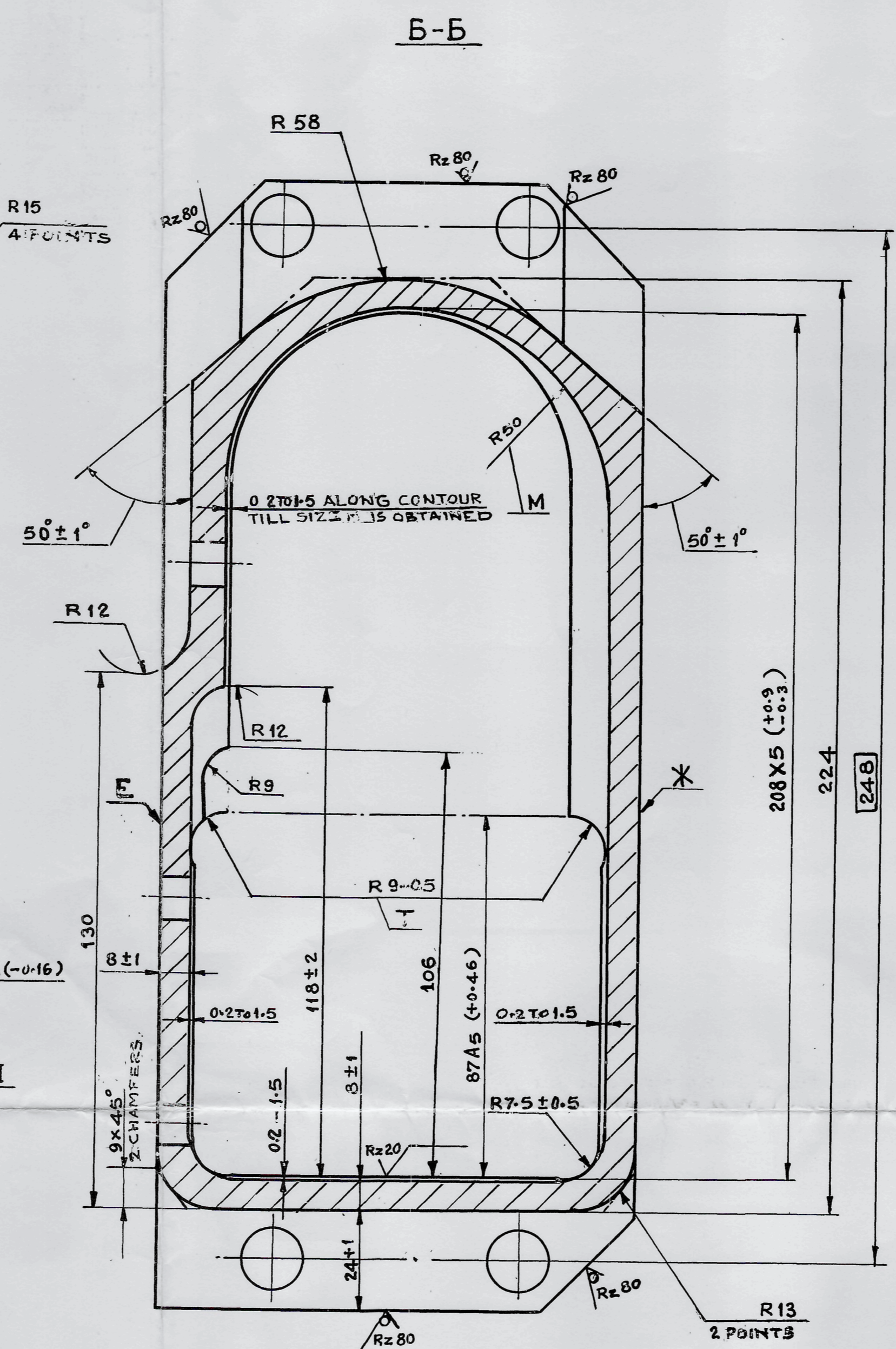
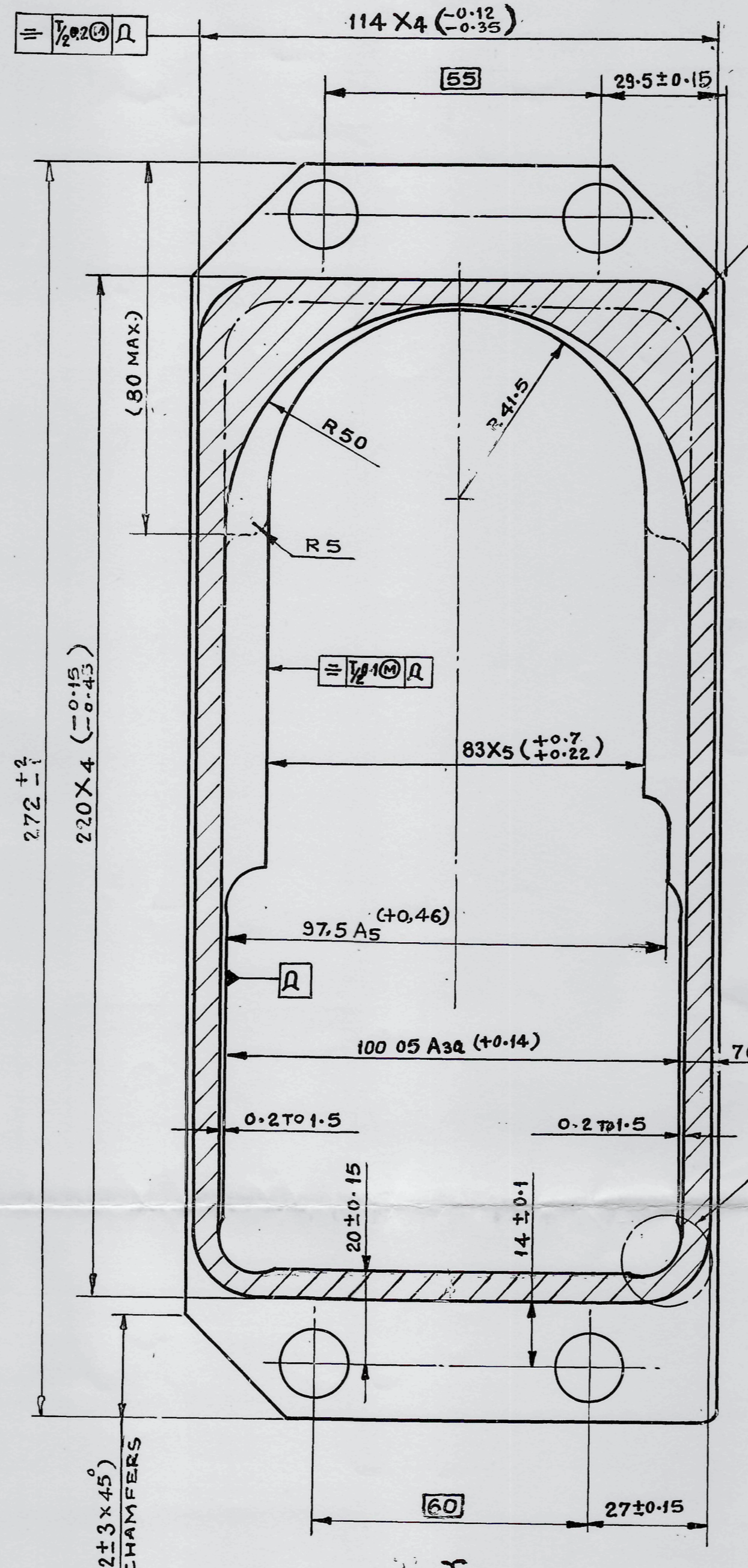
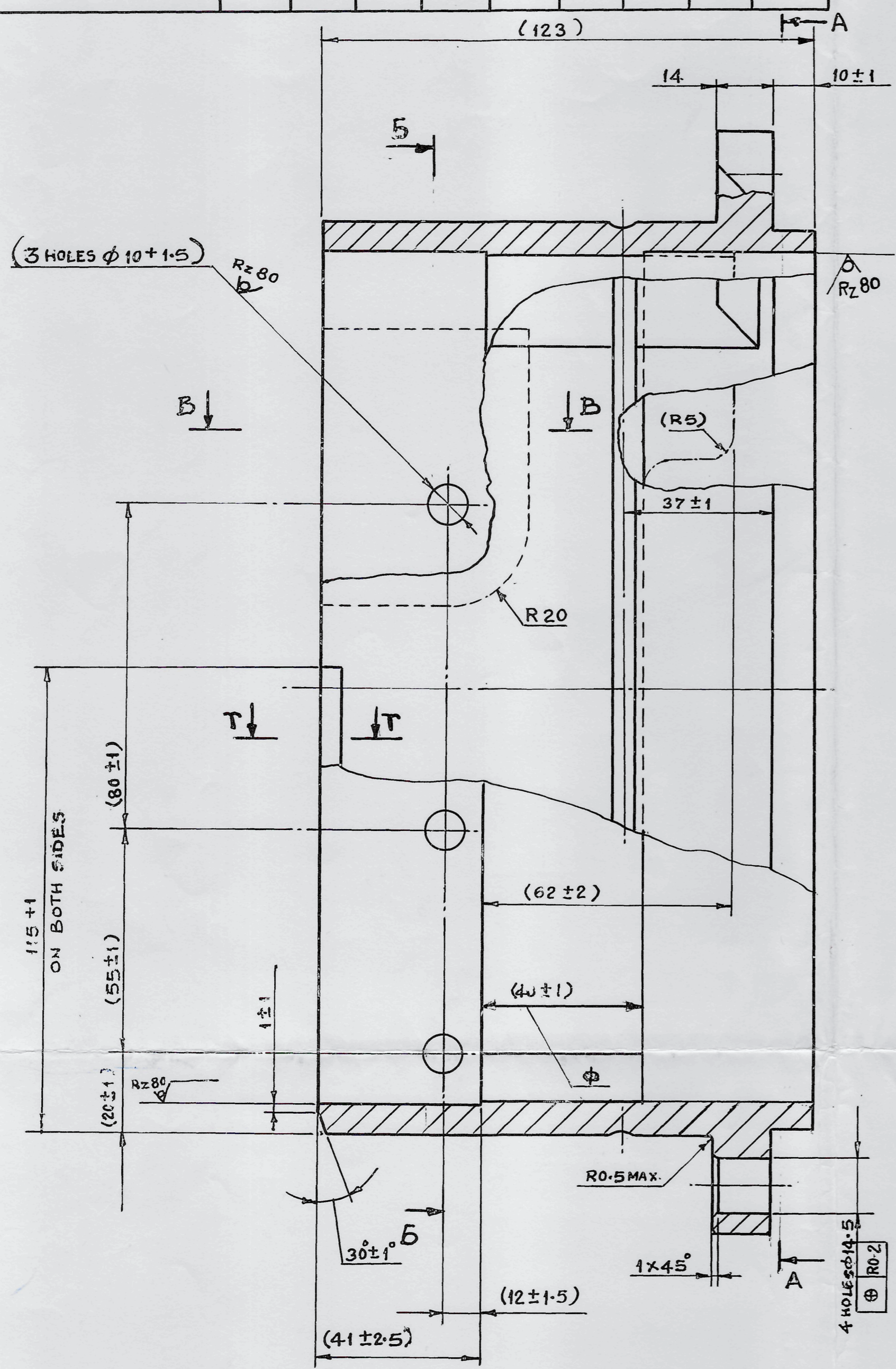


PART No.
675-51-313



- 207 TO 255 HB (DIA. 4.2 - 3.8). IT IS PERMISSIBLE TO CARRY OUT THERMAL TREATMENT AND HARDNESS TEST WHEN ASSEMBLED.
- THE PART MAY BE MADE ACCORDING TO THE THICKENED DASH-AND-DOT LINE.
- UNSPECIFIED LIMIT DEVIATIONS OF SIZES OBTAINED BY CASTING ACCORDING TO ACCURACY CLASS III. TOCT 2009-55; SIZES OBTAINED BY REMOVING THE LAYER OF METAL ARE AS FOLLOWS: HOLES ACCORDING TO A7; SHAFTS ACCORDING TO B7; OTHER VALUES ACCORDING TO CM 8.
- PROVIDE SIZES GIVEN OUT OF BRACKETS WHEN ASSEMBLED.
- OTHER REQUIREMENTS ACCORDING TO STANDARD OCT 3-4365-79.
- CORRECT THE DEFECTS ACCORDING TO INSTRUCTIONS WTC 0301-77.
- OBTAIN RADII T AT LENGTH ϕ ; AT THE REMAINING LENGTH CHECK THEM WITH TOOLS.
- AUXILIARY HOLES ARE PERMISSIBLE ON SURFACES E AND X. HOLES ARE NOT TO EXCEED 12 mm. IN DIA. AND THEY ARE TO BE LOCATED NOT NEAR THAN 10 mm. FROM THE PART END FACE AND FROM THE MACHINED HOLES.
- RADIOGRAPHIC TEST SHALL BE CARRIED OUT AS PER ASTM-E 192 WITH THE FOLLOWING ACCEPTANCE STANDARD:
"LEVEL 3 FOR GAS HOLES AND FOREIGN MATERIAL. LEVEL 3 FOR SHRINKAGE OF ALL TYPES CRACKS, HOT TEARS, COLD SHOTS ARE NOT ACCEPTABLE"
- 100% OF THE ADVANCE SAMPLES SHALL BE SUBJECTED TO RADIOGRAPHIC TEST.
- RADIOGRAPHIC TEST OF ADVANCE SAMPLE SHALL BE CARRIED OUT BY CQA (MET), (CHAPUR OR THE AREA QUALITY ASSURANCE OFFICER CONCERNED SHOULD GET THE RADIOGRAPHIC TEST DONE IN HIS PRESENCE AND FORWARD THE PLATES ALONGWITH RADIOGRAPHIC TEST CERTIFICATE TO CQA (MET) (CHAPUR, FOR SENTENCE AND APPROVAL OF THE MOULD.
- IN CASE OF NON-CONFORMANCE OF ANY CASTING OF FIRST LOT OF ADVANCE SAMPLES TO THE SPECIFIED ACCEPTANCE STANDARD, FRESH LOT OF ADVANCE SAMPLES SHALL BE MANUFACTURED AND SUBJECTED TO RADIOGRAPHIC EXAMINATION TILL THE ENTIRE LOT IS FOUND SATISFACTORY AND BULK PRODUCTION CLEARANCE IS GIVEN.
- FOR BULK COMPONENT, 5% OF EACH COST/HEAT SELECTED AT RANDOM SHOULD BE SUBJECTED TO RADIOGRAPHIC TEST. FAILURE OF ANY SAMPLE WOULD RENDER THE LOT UNACCEPTABLE. SENTENCE MAY BE AWARDED BY AREA QUALITY ASSURANCE OFFICER BASED ON THE STANDARD OF ADVANCE SAMPLES APPROVED BY CQA (MET).
- ANY HEAT REJECTED IN RADIOGRAPHIC TEST MAY BE WEADED OUT BY 100% RADIOGRAPHY AT PRODUCER'S COST IF HE SO DESIRES.
- OTHER TECHNICAL DETAILS AS PER CQA (MET) (CHAPUR INSTRUCTIONS No. MQA-1/QA-1/12.

INDIGS MATL:-
TYPE CLA-12, GRADE A TO BS 13146
PT 1-7A TO ACHIEVE REQUIRED
HARDNESS 207 TO 255 HB.

19665-W 17-4-10	NOTE No 1 AMDT	me
18845-W 13-01-04	HINDI NOMEN ADDED	me

18347-W 22-2-97	NOTE AMENDED	me
18174-W 22-9-95	PROV. SEALING CANCELLED AND DRG SEALED.	me
16407-W 20-2-86	DRG SEALED PROV.	me
17950-W 21-4-94	INDIGS MATL AMENDED.	me
17770-W 27-10-93	INDIGS MATL ADDED.	me
17319-W 13-6-92	ZONE- E - SECTIONS B-B E - WAS E - H-7-D7 - SECTION A-A DIM LINE CORRECTLY SHOWN DIM D-9 & 10 FEATURE LINE CORRECTED.	me

26-2-92	17234-W	NOTE NO 9 ADDED.	DRN:-	CHD:-	ASSY DRG:-
24-10-90	16362-W	R9 DIM 106 GEOMETRICAL CHANGES IN VIEW & NOTE NO 1 AMENDED.	TCO:- Jadhav S.R.	CHD:-	DATE:-
23-12-87		RETRACTED WITHOUT CHANGE	SIGN: [Signature]	DO FOR CQA (W)	SCALE:- 1:1
DATE	AUTHORITY	ZONE	NATURE	AMENDMENTS	PROTECTIVE FINISH:-
				18174-W 22-9-95	EST. MASS:- 5-1
				D.O. CQA (W)	DESIGN NO
					PART No.
					675-51-313
					D.S.CAT.No.

HOUSING हाउसिंग