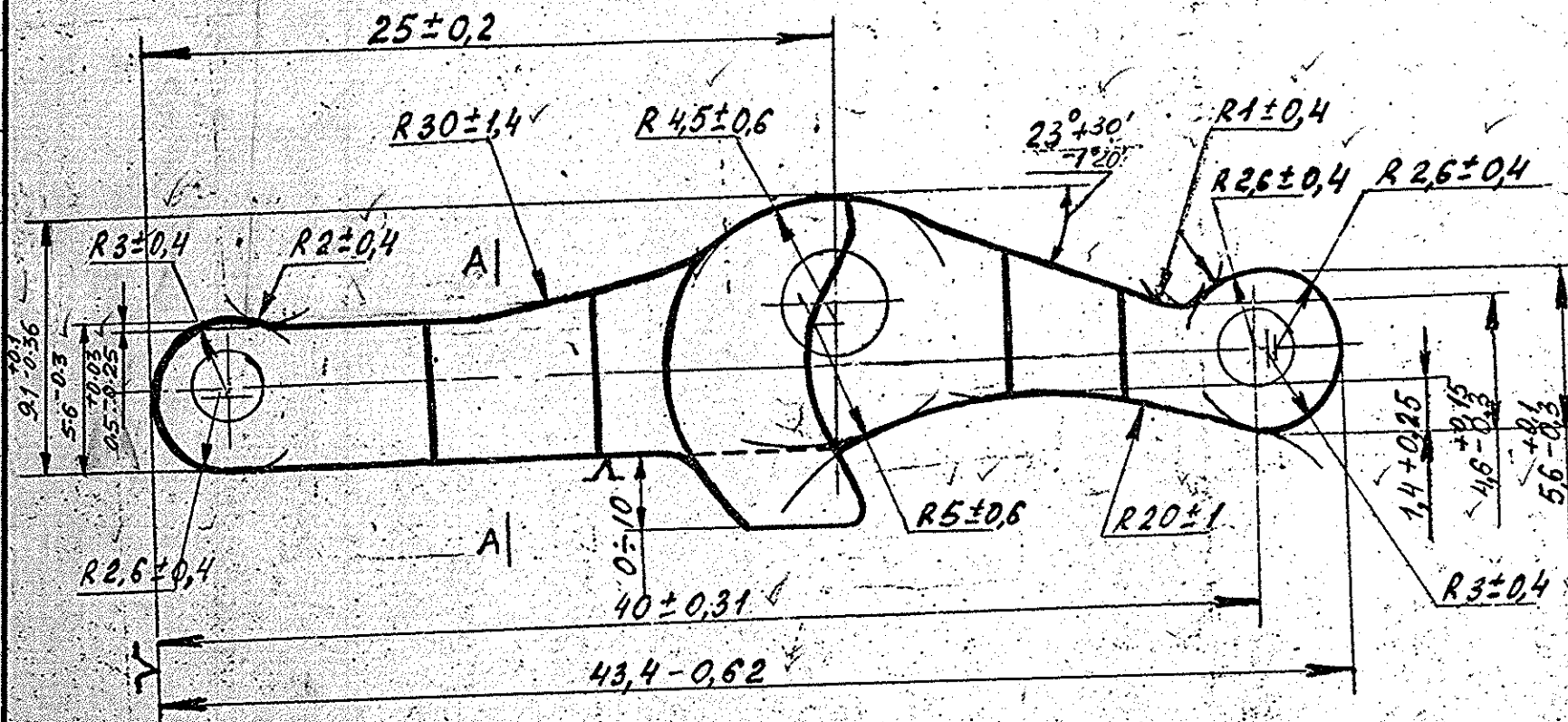
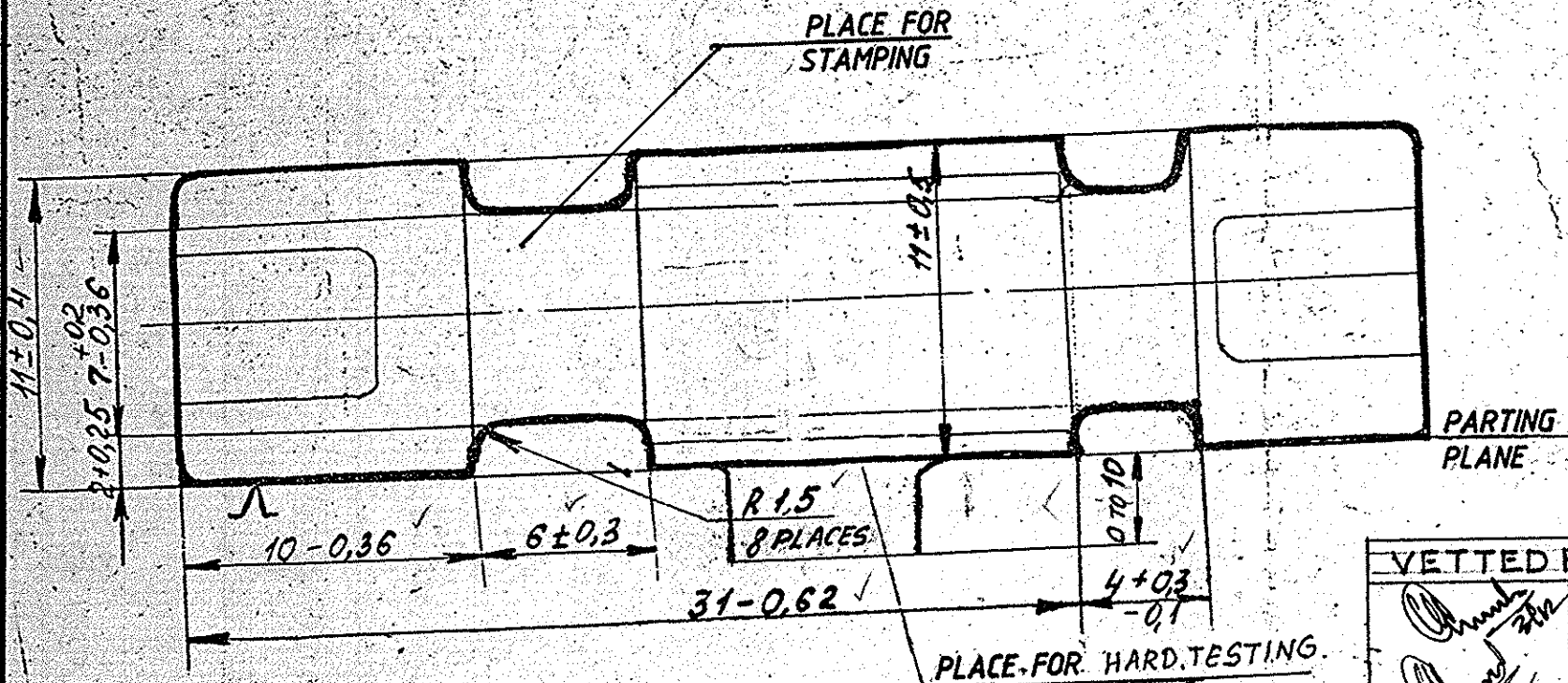


Details to be marked on the Tag

- Sl.no. of Tag
- Batch no.
- No. of compts. in the Batch
- Insp. mark of mould check
- Insp. mark of Component



1. SURFACE ROUGHNESS OF CASTINGS AS PER STANDARD.
2. DRAFT ANGLE IS UP TO 1°.
3. UNSPECIFIED CASTING RADII UP TO 1.6mm.
4. SINKAGE OF TRACES DUE TO EJECTOR IS PERMITTED UPTO 0.5mm. ON WORKING SURFACES
5. STAMP THE SL. NO. OF TAG ON WHICH THE DETAILS ARE MARKED
6. SECTION A-A FOR MEASURING DEPTH OF DECARBURIZED LAYER.
- 7 REFER ATTACHED SHEET FOR HEAT TREATMENT DRG. NO. M882



MATERIAL FOR INDIA:-

BS: 3146 PT. 1: 1974 TYPE CLA-12 GR. A TO GR. B CASTINGS.  
 RADIOGRAPHIC TEST AS PER ASTM- E-192 WITH ACCEPTANCE STANDARDS FOR GAS HOLE AND FOREIGN MATERIAL: LEVEL-5 SHRINKAGE (ALL TYPES) LEVEL-3 ALSO REFER CQA (MET) ICHAPUR INSPECTION INSTRUCTION NO. MRA-1/QA-1/12 DE. 5-5-94 FOR OTHER DETAILS.

HARDNESS HB 241 MAX

VETTED FOR MATERIAL ONLY	
<i>[Signature]</i>	Principal Scientific Officer, Quality Assurance Officer, Senior Quality Assurance Officer, Quality Assurance Estt. (Arms) Tiruchirapalli - 620 016.
<i>[Signature]</i>	AGAO SQAE(A) TRICHY.

MATERIAL FOR INDIA:-  
 BS 3146 PT. 1/1974 TYPE CLA. 12 GRADE A TO GR. B CASTINGS  
 OTHER TECH. DETAILS ARE AS PER CQA (MET)  
 INSPN. INST. No. MRA-1/QA-1/12 DE. 5-5-94

NOTE: MACRO ETCH TEST IS TO BE CARRIED OUT AS PER ASTM E 381 WITH ACCEPTANCE STANDARD AS C2, R2, S2.  
 MICROSCOPIC DETERMINATION OF NON-METALLIC INCLUSION RATING AS PER IS: 4163-82.

E	DA NO. 3. D/12.7mm DE. 12.5.98 MATL. FOR INDIA AMENDED REF. DC. NO. 24064-SA. DE. 24.3.98	S. Rap 12.5.98
D	D.A. NO. 16/95 D. 12.7mm DE. 16.9.95 GRADE 'A' TO GRADE 'B' Amended	S. Rap 16.9.95
C	D.A. NO. 4/95 D. 12.7mm DE. 4.3.95	S. Rap 4.3.95
B	MATERIAL FOR INDIA ADDED	S. Rap 12.9.95
F	AMENDMENTS	SIG. & DATE
	DESCRIPTION / DETAILS	

DS. CAT NO. 1005007172				LEVER SEAR	
SHEETS : 1	1 ANGLE	<i>[Signature]</i>	I/C PROJ.	CASTING DRG.	
SHEET NO : 1	PROJECTION	DRAWN		6P11-7-9	
ALL DIMENSIONS ARE IN mm.	SCALE- 4:1	CHECKED	DIV. OFFICER.	DRG. NO.: 62 C 7009 250 F 3	

F	DA NO. 12/98 D/12.7mm DE. 30.11.98 MATL. FOR INDIA AMENDED. REF. DC. NO. 24191-SA. DE. 23.10.98	S. Rap 30.11.98
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