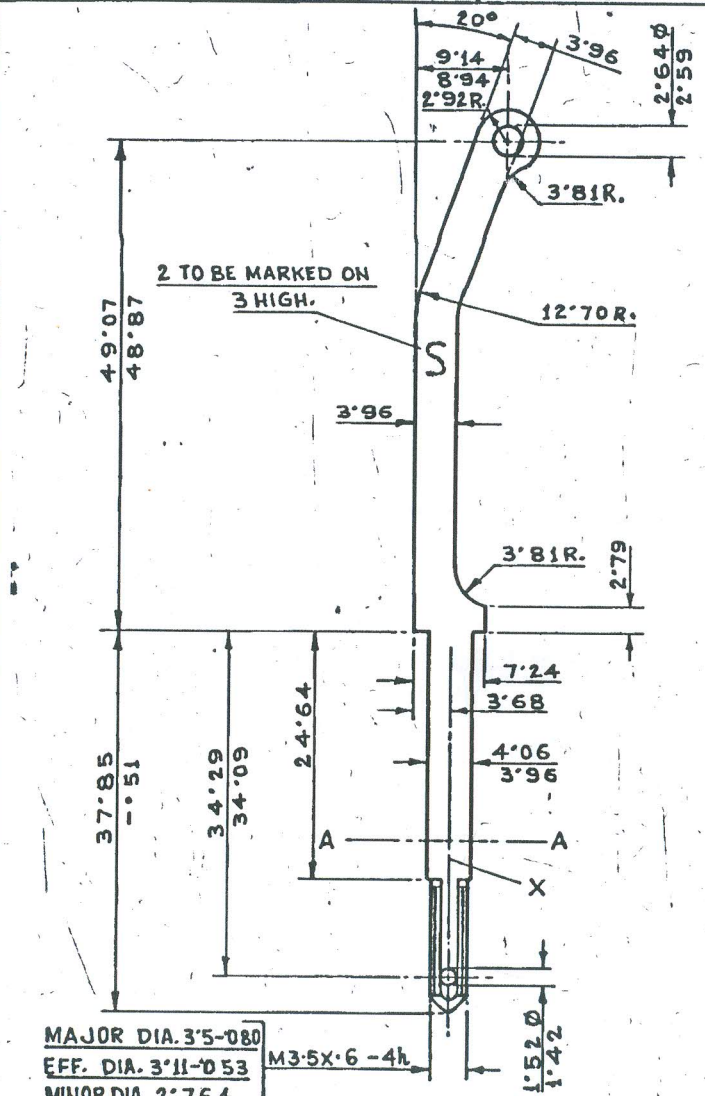

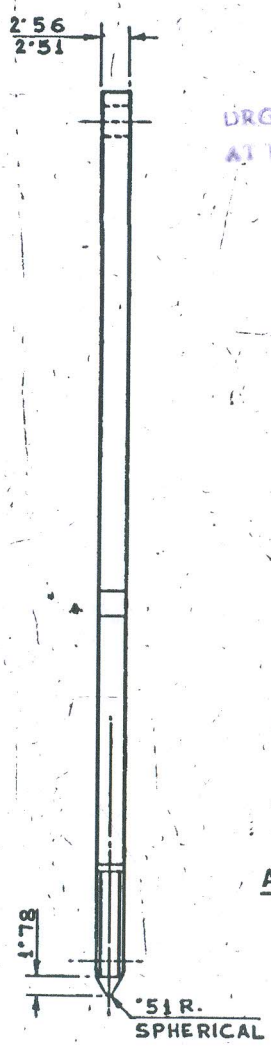

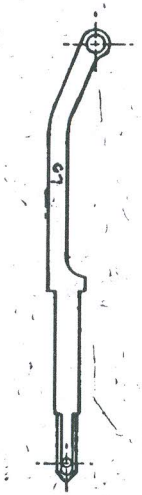

ACTUAL SIZE

H05/VDL

CERTIFIED COPY
DRG / LAYOUT / GAUGE SCHEDULE
AT THIS DATE 18-7-12
CDO
BIBLE FACTORY ICHAPORE

FOR EXPLATION OF DIMENSIONING ETC.
SEE CSAID NOTE SHEET No.1 (LATEST ISSUE).

MATERIAL:-
STEEL BS 5770 PT. II 1981 Gr. 70
OR
IS:2507-1975 Grd. 6 (80 C-6).

HEAT TREATMENT:-
LOCALLY HARDEN AND TEMPER THREAD END FROM LINE A-A TO A D.P.N. 350-420 EQUIVALENT TO ROCK WELL 'D' 52-59 TESTED AT POINT 'X'.

PROTECTIVE FINISH:-
PHOSPHATE TO SPECN. JSS 0465-01: 1988 CLASS II (ACCELERATED), OIL FINISH.

NOTE:-
CORNERS & FILLETS TO BE RADIUSED TO ·38 MAX. R.

~~ACCEPTANCE STANDARDS FOR MACRO ETCH TEST AND MICROSCOPIC DETERMINATION OF NON METALLIC INCLUSIONS FOR STEEL~~
~~I) MACRO ETCH TEST AS PER ASTME 381 WITH ACCEPTANCE STANDARD AS $C_2R_2S_2$.~~
~~II) NMIR TEST AS PER IS: 4163-82.~~

(c). MACROETCH TEST TO ASTME 381-1984 WILL BE AS PER COL. (c) OF SL.NO.1 OF CQA(SA) NOTE SHEET NO.1.
(d). NMIR TEST TO IS: 4163 WILL BE AS PER COL. (c) OF SL. No. 3 OF CQA(SA) NOTE SHEET NO.1.

AUTHY.	DATE	ZONE	BRIEF RECORD	SIG.
25056-SA	02-7-2001		D.S.CAT. NO. 3040-003489 WAS 1005-003161.	
22640-SA	18.8.94		NOTE FOR MACROETCH TEST AND NMIR TEST AMENDED	
22523-SA	4-5-94		PROFORMA CONVERTED TO A3 SIZE, NEG. RE-TRACED AND DRG. RE-SEALED.	
			PREVIOUS D.C. NOS. 10688-SA, 11258-SA, 14446-SA, 15303-SA, 20624-SA, 20638-SA, 21586-SA, 21963-SA & 22156-SA.	COPY

	DATE	NAME
DGN.		
DRN.		
CHD.		
TRD.	7-1-94	Shamrao
COMP.		

DT. 6.5.94 I/C; D.O.
SCALE:- 2:1
SEALED:- D.C. No. 11258-SA, DT. 5.5.72

ASSY. 1005-003159
MATERIAL:- AS STATED
DIMENSIONS ARE IN MILLIMETRES

LINK, HAMMER

CQA(SA) ICHAPUR
APPROVED. DT. 2.8.67
NEG. RE-TRACED
DESIGNER'S REF. CISA/333/3/1
D.S. CAT. NO. 3040-003489