

DRG. NO. SK-5375R
NO. QS/ISO-9000/DO/01
REV. NO. 00-DT. 09-06-2001

SEC.- D-D
SCALE :- 1 : 1

SEC.- A-A

VIEW AT 'X'

MATERIAL :- B.S. 3146 PART -1 : 1974 CLA 5A
HEAT TREATMENT- ANNEALING
(TEST PIECE IS TO BE TESTED FROM ONE CASTING DULY
HARDENED AND TEMPERED FROM EACH CAST FOR MECHANICAL
PROPERTIES STIPULATED IN THE SPECIFICATION.)
UNSPECIFIED TOL :- + 0.10m.m. FOR EACH 25 m.m.
ANGULAR TOL :- + 30°
MIN. FILLET RADIUS :- 0.3 m.m.

NOTE :-

1. SURFACE MARKED THUS '▽' INDICATES MACHINING AT OUR END.
2. SHARP CORNERS MAY BE AVOIDED, UN SPECIFIED FILLET RADIUS 0.5mm (MAX.)
3. MANUFACTURER'S INITIAL, YEAR OF MANUFACTURE & BATCH NO. SHOULD BE MARKED ON THE SURFACE MARKED THUS ⊗
4. CASTING SHOULD BE SUPPLIED IN FULLY ANNEALED CONDITION.
5. SETTING TO BE CARRIED OUT BY SUPPLIER.
6. DIMNS. ARE IN m.m.
7. CASTING SHOULD BE FREE FROM CRACKS. BLOW HOLES AND ANY OTHER SURFACE DEFECTS.
8. BEFORE BULK PRODUCTION CLEARANCE WILL BE GIVEN , PILOT BATCH OF 10 CASTINGS WILL BE 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.

9. EACH PILOT BATCH BEFORE THE BULK PRODUCTION CLEARANCE WILL HAVE TO BE TESTED FOR RADIOGRAPH TO INSURE QUALITY AND SOUNDNESS OF THE CASTINGS THERE AFTER 5% CASTING FROM THE BULK SUPPLY SHALL BE REQUIRED TO BE EXAMINE FOR RADIOGRAPHIC TEST BY THE FIRM & SUCH RECORDS PROVIDED TO US.
10. ALONGWITH THE BULK SUPPLY THE MATERIAL TEST CERTIFICATE AND CHEMICAL ANALYSIS REPORT WILL BE REQUIRED TO BE FURNISHED FOR EACH CAST/ HEAT. OF MATERIAL USED FOR POURING OF CASTINGS.
11. ADEQUATE CARE SHOULD BE TAKEN TO ENSURE THAT THERE IS NO DECARBURISATION OF THE CASTINGS.
12. 100% CASTING WILL BE REQUIRED TO BE TESTED FOR MAGNETIC CRACK DETECTION TO ENSURE THAT CASTINGS ARE FREE FROM CRACKS.
13. APPROXIMATE WEIGHT : 270 g
14. ZONE MARKED 'F' HAVE FLATNESS $\pm 0.1/25.4\text{m.m.}$

DETAIL AT'Y
SCALE:-2:1

SEC. C-C
SCALE-2:1

BLEND RADIUS R9.53X7° & R9.53X21°

AT ZONE E, F-1:- DIMS. 7-93,
39-27 & 34-0-DELETED
AT ZONE E-1:- DIM R10 ALTERED
TO R110
AT ZONE F-1:- DIM. R10 ALTERED
TO R8-0 & DRG. No ADVANCED TO

DRG. No. ADVANCED TO #2
SK-5375R

AT ZONE:- E.F. 1,2 :- DIM 24-0 WAS 36-45,
12-5 WAS 12-05, R 20-5 WAS 20-09,
3-5 WAS 3-56, 23-0 WAS 20-51,
R 10 WAS R 12.

AT ZONE F.G. 2,3 :-
DIM R 50-0 & R 30-2 :- ADDED.

IN ZONE A-2,3
DIM. 12.80 WAS 10.88

02 $\frac{05}{07}$	17/07
20-3-0	11/07
DATE	D.A. NO

<u>VOLVER 32 (7.65mm)</u> <u>DRG.NO. PHMK-III-2-1</u> <u>FOR INVESTMENT CASTING</u>	DRAWN <i>sh</i>	TRACED	CHECKED <i>sh</i>
	KAU	DATE 23-05-2006	
	APPROVED		
	<i>25-5-06</i> J.W.M./DO		
	DRG. NO.		
<u>SMALL ARMS FACTORY</u> <u>KANPUR</u>	SK-5375R		
	SHT 1 OF 1		

REVOLVER 32 (7.65mm)
BODY DRG.NO. PHMK-III-2-1
SKETCH FOR INVESTMENT CASTING

SCALE	<u>SMALL ARMS FACTORY</u> KANPUR
1:1(2:1)	

DETAIL AT 'P'

SPHERICAL