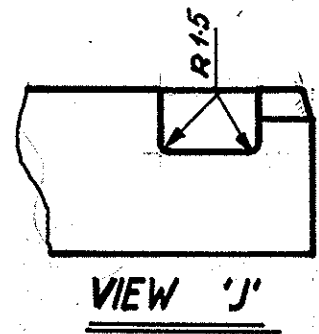


NETTED FOR MATERIAL ONLY

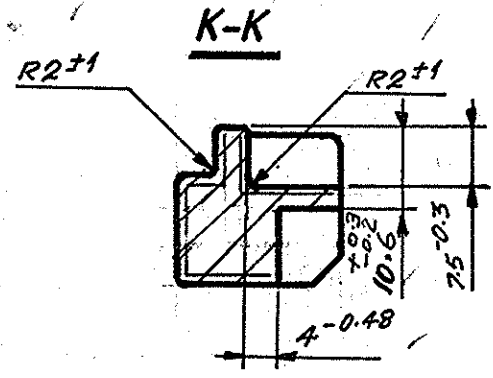
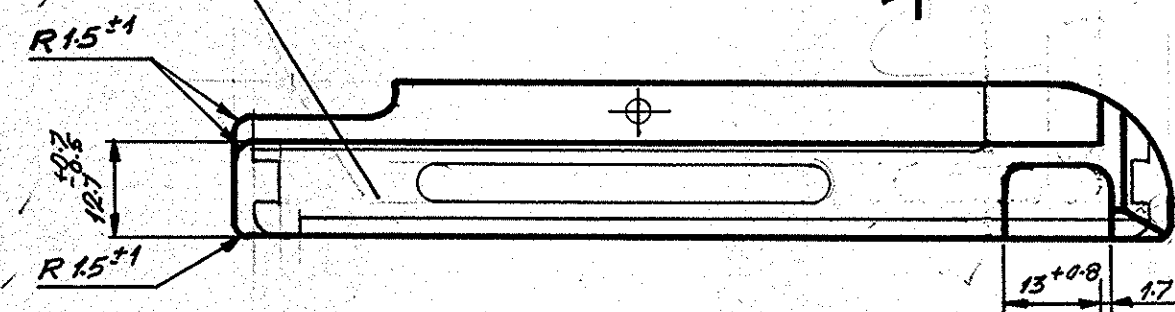
Number 2112
25/12
AQAD
SQAE(A)
TRICHY

Principal Scientific Officer,
Quality Assurance Officer,
For Senior Quality Assurance Officer,
Senior Quality Assurance Estt. (Arms)
Tiruchirapalli - 620 016.



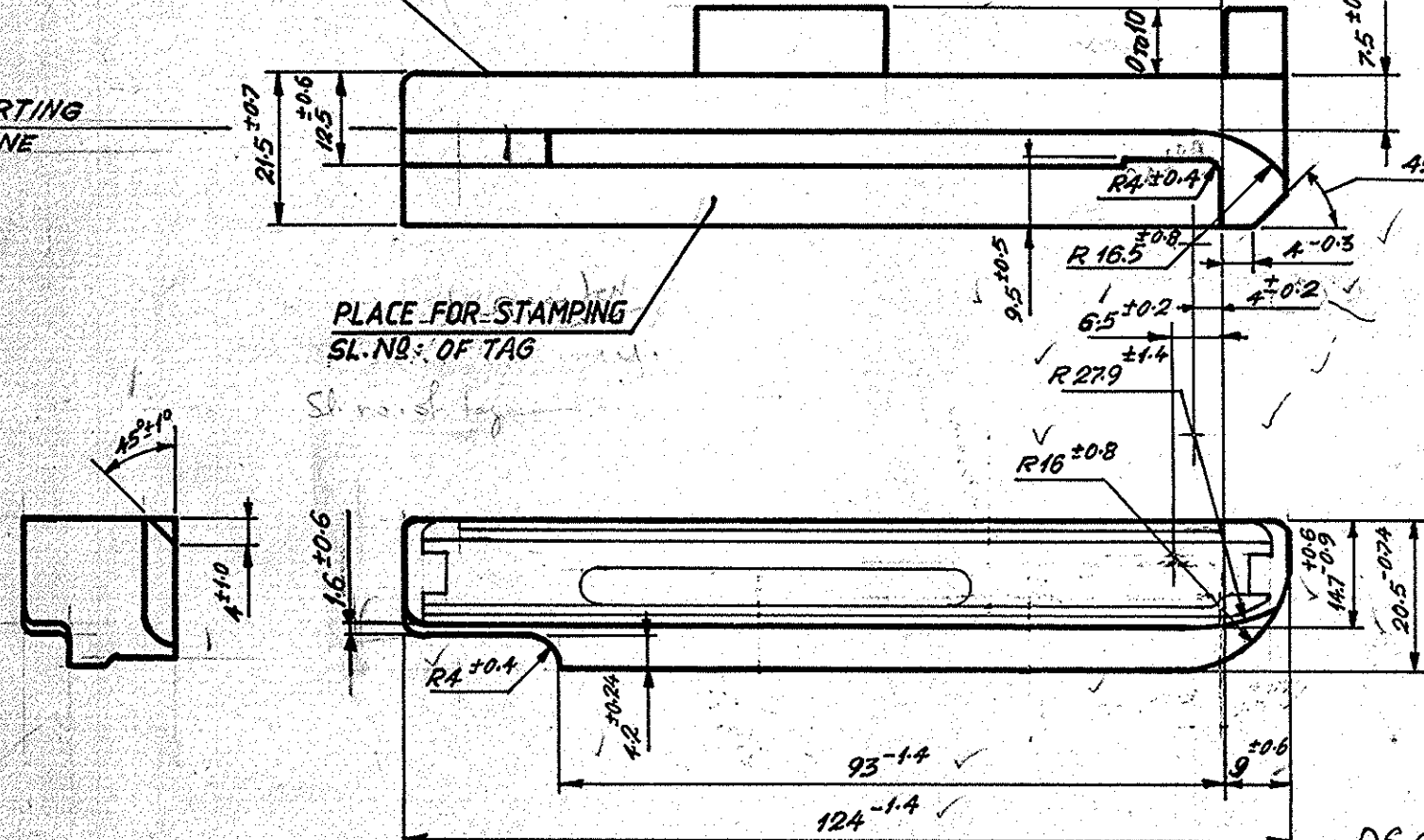
Details to be marked on Tag
Sl.no. of Tag
Batch no.
No. of comp. in the Batch
Insp. mark of mould check

PLACE FOR
STAMPING
INSPN. MARK



PLACE FOR
HARDNESS TESTING

PARTING
PLANE



PLACE FOR STAMPING
SL. NO. OF TAG

MATERIAL FOR INDIA :
BS 3146 PT 1 : 1974 TYPE CLA-12 GRADE 'A' TO GR. 'B' CASTINGS.
OTHER TECHNICAL DETAILS ARE AS PER CQA (MET)
INSPECTION INSTRUCTION NO. MQA-1/RA-1/12 DE. 5-5-94

Hardness HB 241 max.

1. SURFACE ROUGHNESS OF CASTINGS AS PER STANDARD.
2. DRAFT ANGLE IS UPTO 1°.
3. UNSPECIFIED CASTING RADII UPTO 1 mm.
4. MISALIGNMENT ALONG PARTING PLANE UPTO 02 mm.
5. SINKAGE OF TRACES DUE TO EJECTOR IS PERMITTED UPTO 0.5 mm. ON WORKING SURFACES.
6. STAMP SL. NO. OF TAG ON WHICH THE DETAILS ARE MARKED
7. STAMP INSPECTION MARK
8. SECTION A-A FOR MEASURING DEPTH OF DECARBURISED LAYER.
9. *DIMENSIONS FOR REFERENCE
10. REFER ATTACHED SHEET FOR HEAT-TREATMENT PROCESS - DRG. NO. 882

MATERIAL FOR INDIA:-
BS 3146 PT. 1: 74 TYPE CLA-12 GR. 'A' TO GR. 'B' CASTINGS.
RADIOGRAPHIC TEST AS PER ASTM E-192 WITH ACCEPTANCE STANDARDS FOR GAS HOLE AND FOREIGN MATERIALS:- LEVEL-5-SHRINKAGE (ALL TYPES) LEVEL-3 ALSO REFER CQA (MET) CHAPUR INSPECTION INSTRUCTION NO. MQA-1/RA-1/12 DE. 5-5-94. FOR OTHER DETAILS.

DS.CATNO. 1005007443

BLOCK GUIDE LEVER FEED.

E	DA.12/98 D/12.7mm DC.30.11.98	S. Raju 30.11.98	C	DIMS. 26.5±0.5, 0.5±0.3, 4.8±0.48 DELETED VIEW CORRECTED D.A. NO. 12/95 D.12.7mm DC.18.8.95	SHEETS : 1	1 ANGLE	Ganesh	I/C PROJ.	CASTING DRG. 6P11-6-22
	MATL. FOR INDIA AMENDED DC. NO. 24/92-SR. DC. 24.10.98		B	D.A. NO. 4/95 D.12.7mm DC. 4.3.95	SHEET No: 1	PROJECTION			
D	DA. NO. 7/98 D/12.7 DC. 7.6.98	S. Raju 7.6.98	AMENDMENTS		ALL DIMENSIONS	SCALE :	Shankar 4/5/97	DIV. OFFICER	DRG. NO.: 62 C 6022 250 E 3
						ARE IN mm.			

1 2 3 4 5 6 7 8