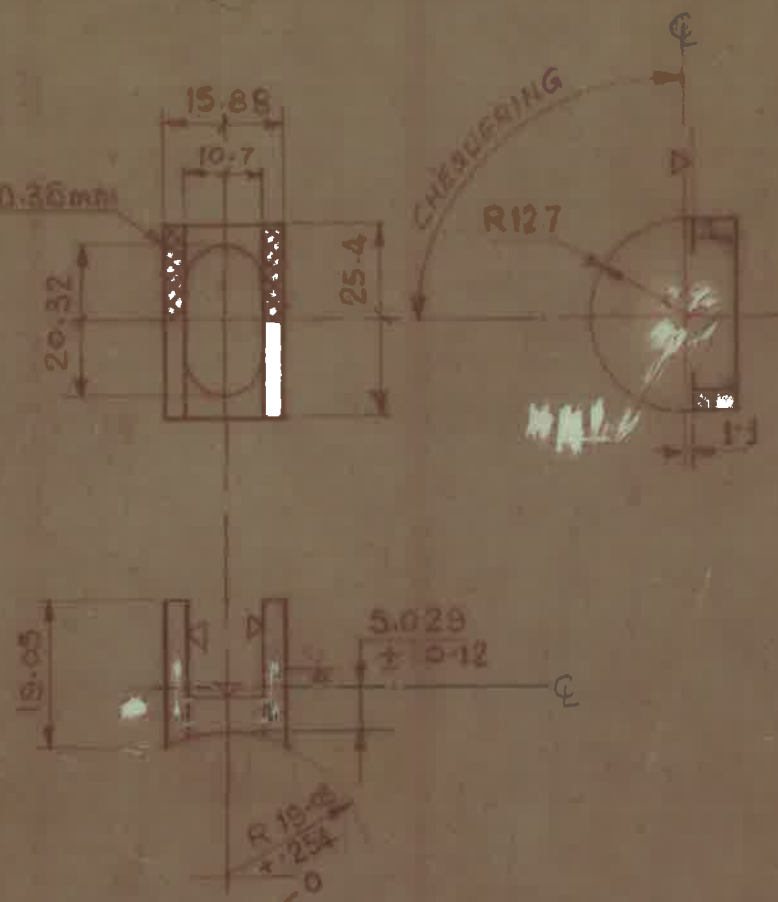


SK. 3713*

MATERIAL VETTED	
QAE (SA)	15.11.95
INCLUSION RADIOGRAPHIC TEST D-A-NO-105/91 VETTED	
QAE (SA)	15.11.95
KANPUR	

DIAMOND KNURLING 0.36mm
DEPTH

NOTES:- 1. SETTING TO BE CARRIED OUT BY SUPPLIER.

2. SHARP CORNERS MAY BE AVOIDED UNSPECIFIED FILLET RADIUS 0.5mm - MAX.

3. CAST MARK 'IC' SHOULD BE GIVEN AT PLACE MKD. THUS @.

4. CASTING SHOULD BE SUPPLIED IN ANNEALED CONDITION.

5. CASTING SHOULD BE FREE FROM CRACKS, BLOW HOLES & ANY OTHER SURFACE DEFECTS.

6. BEFORE BULK PRODUCTION CLEARANCE WILL BE GIVEN. PILOT BATCH OF 10 CASTING WILL BE REQUIRED TO BE SUBMITTED ALONG WITH THE DIMENSIONAL CRITICAL EXAMINATION REPORT & MATL. TEST CERTIFICATE. IF THE BATCH IS NOT ACCEPTABLE FURTHER BATCHES OF 10 EACH WILL BE REQUIRED TILL CLEARANCE IS GIVEN TO START BULK PRODUCTION.

7. ALONG WITH THE BULK SUPPLY THE MATL. TEST CERTIFICATE & CHEMICAL ANALYSIS REPORT WILL BE REQUIRED TO BE FURNISHED FOR EACH CAST/HEAT OF MATL. USED FOR POURING OF CASTING.

8. ADEQUATE CARE SHOULD BE TAKEN TO ENSURE THAT THERE IS NO DECARBURISATION OF CASTING.

9. 100% CASTINGS WILL BE REQUIRED TO BE TESTED FOR MAGNETIC CRACK DETECTION TO ENSURE THAT CASTINGS ARE FREE FROM CRACKS.

10. SURFACES MARKED THUS TO BE MACHINED AT OUR END.

11. APPROX. WEIGHT:-

UNSPECIFIED TOLERANCE $\pm .12$ mm. FOR EACH 25.4 mm.
 ANGULAR TOLERANCE ± 30
 MIN. FILLET RADIUS 0.3mm.
 FLATNESS $\pm .10/25.4$ mm.

(TEST PIECE IS TO BE TESTED FROM ONE CASTING DULY HARDENED & TEMPERED FROM EACH CAST FOR MECHANICAL PROPERTIES STIPULATED IN THE SPECIFICATION.)

12. 5% OF THE COMPONENTS FROM FIRST BATCH FROM EACH SUPPLIER WILL BE SUBJECTED TO RADIOGRAPHIC TEST AND THEREAFTER NO RADIOGRAPHIC TEST FOR SUBSEQUENT SUPPLIES FROM THAT SUPPLIER WILL BE DONE.

(AUTHORITY - CGA (SA) LETTER NO. 4/TEL/DT. 1.11.91)

RADIOGRAPHIC

ACCEPTANCE STANDARD AS PER ASTM E-192 CATEGORY OF CASTING - 3

MATL: BS3145 PT. 1 - 1974 TYPE CLA-1 GRADE-A
 (REF. CGA (MET) LETTER NO. MGA 1/02/INVEST)
 DATED 20th MAY 88

INSPECTION WILL BE GUIDED IN GENERAL AS PER CONTROLLERATE
 OF INSPECTION (METALS) CHANDAPUR NOW NAMED AS CONTROLLERATE
 OF QUALITY (METAL) CHANDAPUR, IN P. IN. NO. FMR0001H/TC/C/M/INVT-2.

60/98	4.5.98	ACCEPTANCE STD. REVISED
67/95	15.11.95	$\phi 5.7$ HOLE DELETED
105/91	30.12.91	NOTE FOR RADIOGRAPHIC TEST & ACCEPT. STD. ADDED
DA NO	DATE	AMENDMENT
42/93	14.3.93	DIM $\phi 5.7$ & DIM $\phi 5.029 \pm 0.12$ WERE $\phi 5.7 \pm 0.12 - 0$
		CHEQUERING NOTE ADDED

DIMENSIONS ARE IN MM.

CARBINE MACHINE 9 mm 1A
 GUARD BACK SIGHT
 DRG. NO. D.S. CAT. NO 1005-000866
 SKETCH FOR INVESTMENT CASTING

SCALE

1:1

SMALL ARMS FACTORY
 KANPUR.

DRN.

CHKD.

APPROVED.

DRAWING No.

SK-3713*

SHT. 1