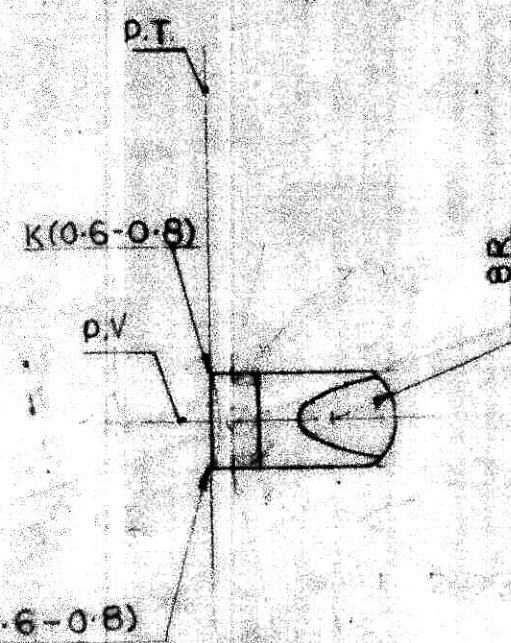


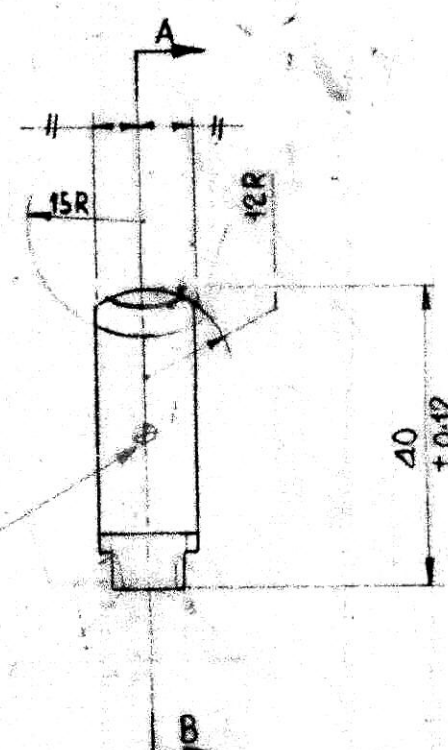
SKM-755 ¹²³



MATERIAL:- BS: 3146 Pt I - 1974
TYPE CLA-12 GRA

RADIOGRAPHIC ACCEPTANCE STANDARD
ASTM 446-84 LEVEL 3 OF CATEGORY
A,B,C (TYPES CA, CB, CC, CD) - 2
NIL FOR CATEGORY D,E,F&G

RADIOGRAPHIC TEST TO BE CARRIED OUT ON
10% OF THE LOT/BATCH



SKETCH SHOWING POSITION OF
'IC' MARK FOR SKM-753#2-3

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

(AUTHORITY CQA(SA) LETTER NO. 4/TC/H DT-11/91)
RADIOGRAPHIC ACCEPTANCE STD. ASTM-152
ASTM 446-84 LEVEL 3 FOR CATEGORIES
A,B,C (TYPES CA, CB, CC, CD) CATEGORIES
D,E,F&G NIL

[REF:- CONTROLLERATE OF QUALITY ASSURANCE (SMALL ARMS)
ISHAPUR LETTER NO. 2/MG/1/5 DT-23 JULY 85]

NOTES:-

- 1- SETTING TO BE CARRIED OUT BY THE SUPPLIER.
- 2- SHARP CORNERS MAY BE AVOIDED UNSPECIFIED FILLETRADI 0.5mm. MAX.
- 3- CAST MARK 'IC' SHOULD BE GIVEN AT A PLACE MKD. THUS @
- 4- CASTING SHOULD BE SUPPLIED IN ANNEALED CONDITION.
- 5- CASTING SHOULD BE FREE FROM CRACKS, BLOW HOLES AND ANY OTHER SURFACE DEFECTS.
- 6- 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.
- 7- ALONGWITH THE BULK SUPPLY THE MATERIAL TEST CERTIFICATE AND CHEMICAL ANALYSIS REPORT WILL REQUIRED TO BE FURNISHED FOR EACH CAST HEAD OF MATERIAL USED FOR POURING OF CASTING. ADEQUATE CARE SHOULD BE TAKEN TO ENSURE THAT THERE IS NO DECARBURISATION OF CASTINGS.
- 8- 100% CASTINGS WILL BE REQUIRED TO BE TESTED FOR MAGNETIC CRACK DETECTION TO ENSURE THAT CASTINGS ARE FREE FROM CRACKS.
- 9- SURFACES MKD. THUS ▽ TO BE MACHINED AT OUR END.

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

(TEST PIECE TO BE TESTED FROM ONE CASTING DULY
HARDENED AND TEMPERED FROM EACH CAST FOR MECHA-
NICAL PROPERTIES STIPULATED IN THE SPECIFICATION.
TEST PIECE SHOULD ALSO BE TESTED TO ATTAIN HARDNESS...

INSPECTION WILL BE GUIDED IN GENERAL AS PER CONTROLLERATE
OF INSPECTION (METALS) ISHAPUR NOW NAMED AS CONTROLLER-
ATE OF QUALITY ASSURANCE (METALS) ISHAPUR.
INSPECTION INSTRUCTION NO. FMR 0001 H/TC/CIM/INST-2

GUN MACHINE 7.62 MM.
TK-71 TURRET
CATCH CARRYING HANDLE DRG NO.16
SKETCH FOR INVESTMENT CASTING

SCALE 1:1
SMALL ARMS FACTORY
KANPUR

DRN. HKD. APPROVED
DRAWING NO. SKM-755
SHT. 1 OF 1

DA NO. 33/96	DAE(SA)	MATERIAL VETTED
07/04	QAE(SA)	QAE(SA)
		INCLUSION OF RADIOGRAPHIC TEST
		QAE(SA)

DA NO.
M-5/90
M-20/90
M-21/91
M-33/96
M-07/04

DIMENSIONS ARE IN MM.

SECTION-AB
SCALE 2:1