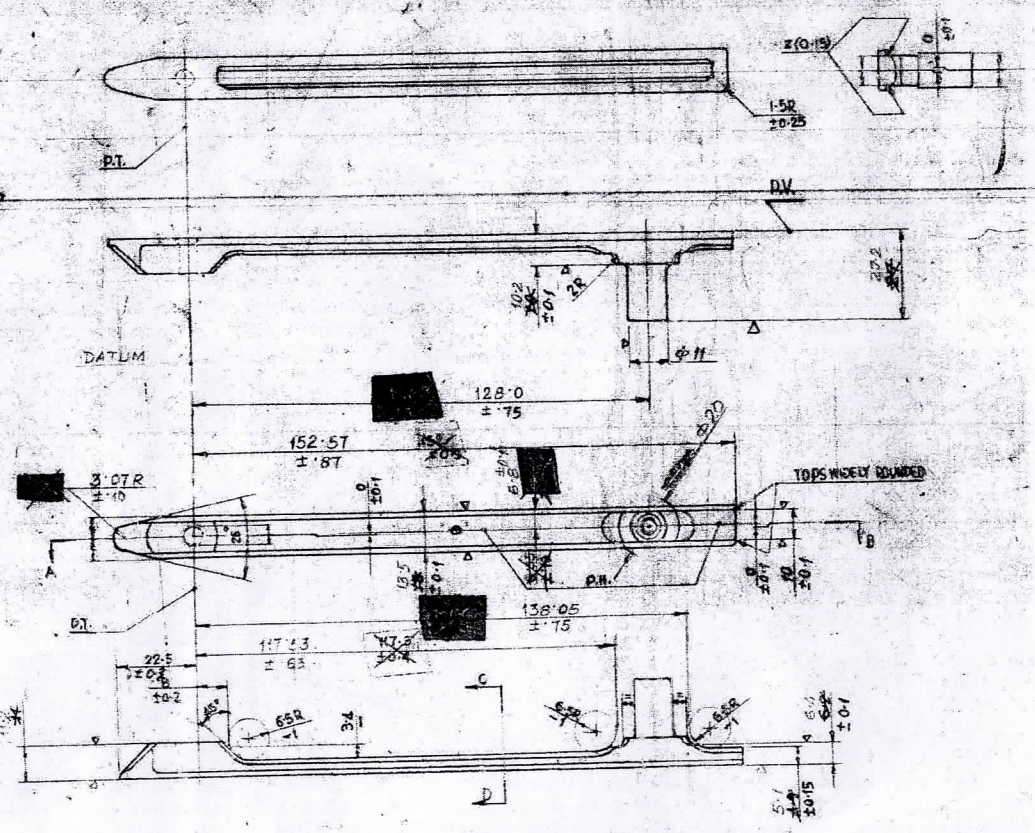
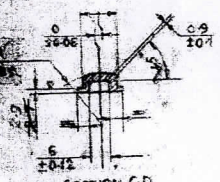
SKM-738 *3 *2

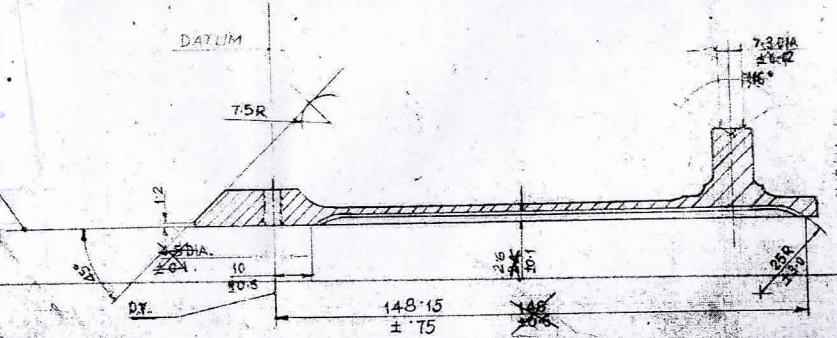
1

DAND	DATE	AMENDMENTS
M6/90	22-2-90	DRG. DIMS REVISED
M-21/91	26-12-91	NOTE FOR RADIOGRAPHIC TEST ADDED. ϕ45 ±0.1 ϕ73 ±0.2 16° DELETED. DIMS. REVISED.
M-2/92	10-1-92	
03/07	10.8.07	DIMN. ϕ22 ADD TO ϕ20





SECTION C-D



SECTION-AB

NOTE:-

1- SETTING TO BE CARRIED OUT BY SUPPLIER.
2- SHARP CORNERS MAY BE AVOIDED UNSPECIFIED FILLET RADIUS 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 AND OTHER SURFACE DEFECTS.
6- BEFORE BULK PRODUCTION CLEARANCE WILL BE GIVEN ON 01 BATCH OF 10 CASTINGS WILL BE REQUIRED TO BE SUBMITTED ALONG WITH THE DIMENSIONAL CRITICAL EXAMINATION REPORT AND MATERIAL TEST CERTIFICATE IF THE PILOT BATCH IS NOT ACCEPTABLE FURTHER BATCHES OF 10 EACH WILL BE SUBMITTED. FIELD CLEARANCE IS GIVEN TO START BULK PRODUCTION.

7- ALONGWITH THE BULK SUPPLY THE MATERIAL TEST CERTIFICATE AND CHEMICAL ANALYSIS REPORT WILL BE REQUIRED TO BE FURNISHED FOR EACH CAST HEAD OF MATERIAL USED FOR POURING OF CASTING.
8- ADEQUATE CARE SHOULD TO BE TAKEN TO ENSURE THAT THERE IS NO DECARBURISATION OF CASTINGS.
9- 100% CASTINGS WILL BE REQUIRED TO BE TESTED FOR MAGNETIC CRACK DETECTION TO ENSURE THAT CASTINGS ARE FREE FROM CRACKS.
10- SURFACES MKD. THUS ▽ TO BE MACHINED AT OUR END.

APPROX. WEIGHT:-

UN SPECIFIED TOLERANCE ±.12 FOR EACH 25.4 MM.
ANGULAR TOLERANCE ±30'
MIN. FILLET RADIUS 0.3mm.
FLATNESS:- ±.10/25.4mm.

(TEST PIECE TO BE TESTED FROM ONE CASTING ONLY. HARDENED AND TEMPERED FROM EACH CAST FOR MECHANICAL PROPERTIES STIPULATED IN THE SPECIFICATION

MATERIAL:- IS:10343-1999 GRADE 15Q.

(REF.- CONTROLLERATE OF QUALITY ASSURANCE (SMALL ARMS) ISHAPUR LETTER NO 3/MG/1/5 DT. 28 FEB 08)
(REF.- C QA (SA) LETTER NO 2/2C1/3/5 DT. 24-5-96) & C QA (MET) letter no MAT-1/INST-2 dt. 5th June '16

NOTE: 5% OF THE CASTINGS FROM ANY BATCH OF EACH SUPPLIER WILL BE SUBJECTED TO RADIOGRAPHIC TEST AND THEREAFTER NO RADIOGRAPHIC TEST WILL BE DONE. IF REJECTIONS FROM THAT SUPPLIER WILL BE DONE.

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

RADIOGRAPHIC ACCEPTANCE STD. ~~ASTME 446-84 LEVEL-3 FOR CATAGORIES A B (TYPE CA, CB, CC, CD) CATAGORIES DE & G NIL~~
ASTME 192 GRADE-B

GUN MACHINE 7.62 MM.
TK 71 TURRET
BOD: COCKING SLIDE DRG. NO. 1050 A
SKETCH FOR INVESTMENT CASTING

SCALE 1:1

SMALL ARMS FACTORY
KANPUR

DRN.
CHK.
APPROVED
DRAWN

DIMENSIONS ARE IN MM.

Hof/MCO
28/10/20