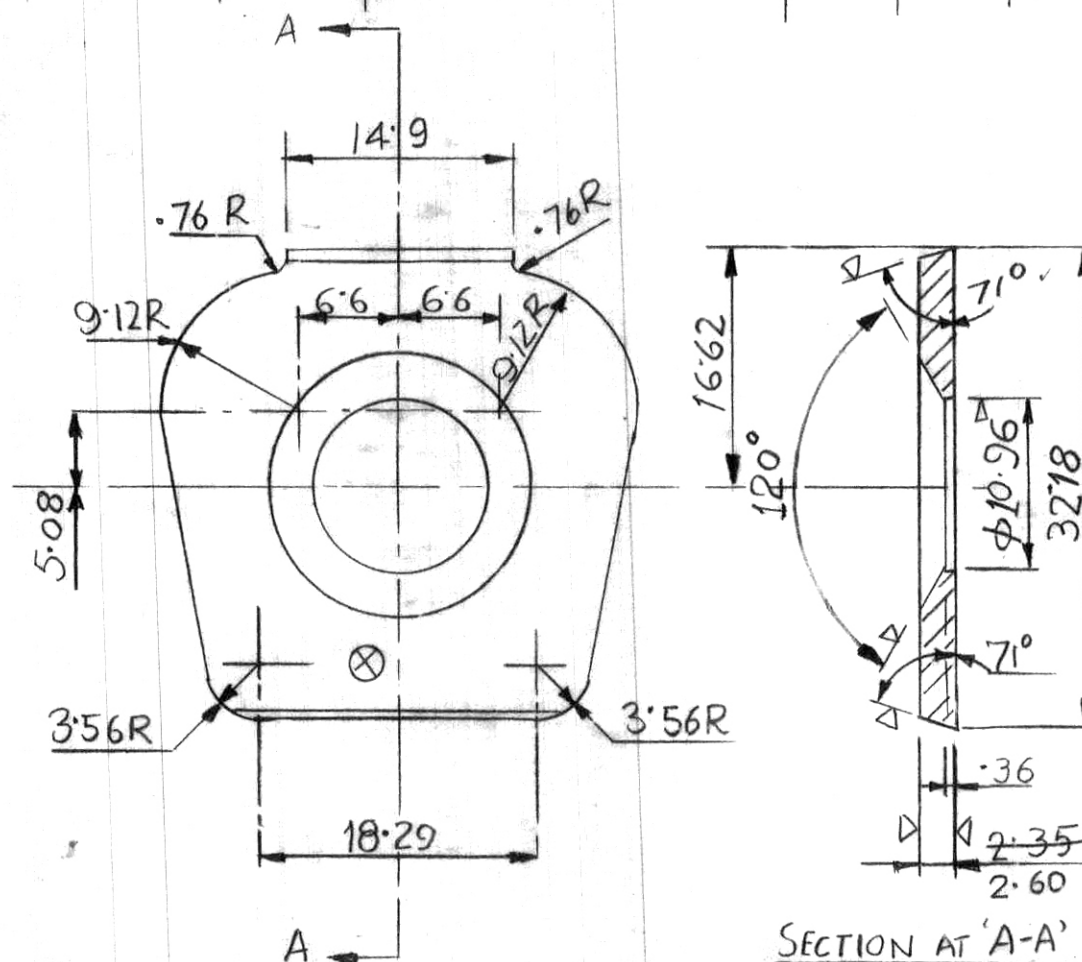


5998-SK-3665 DRG. NO. SK-3665

DATE	D.A. NO.	NATURE	I/C.D.O.	AWM
24-3-88	44/88	CLAUSE NO 6 DELETED	Sd. N.K. ROY	Sd. B.R. ARORA
24-1-2001	12/2001	DIM. 2.35 ALTERED TO 2.60 AND DRG. NO. ADVANCED TO SK 3665*	Sd. K. ALI	
9-4-04	35/04	NOTE NO. 13:- ADDED	V. Sharma	



MATERIAL-BS 3146 PT-1-1974. TYPE-CLAB

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

DIMENSIONS ARE IN m.m.

NOTE

1. SHARP CORNERS MAY BE AVOIDED UNSPECIFIED FILLET RADII 0.5 m.m. MAX.
2. CASTING MARK 'IC' SHOULD BE GIVEN AT PLACE MARKED.
3. CASTING SHOULD BE SUPPLIED IN FULLY ANNEALED CONDITION.
4. CASTING SHOULD BE FREE FROM CRACKS, BLOW HOLES ANY OTHER SURFACE DEFECTS.
5. BEFORE BULK PRODUCTION CLEARANCE WILL BE GIVEN PILOT BATCH OF 10 CASTINGS WILL BE REQUIRED TO BE SUBMITTED ALONGWITH THE DIMENSIONAL CRITICAL EXAMINATION REPORT & 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.
6. EACH PILOT BATCH BEFORE THE BULK PRODUCTION CLEARANCE WILL HAVE TO BE TESTED FOR RADIOGRAPH TO ENSURE QUALITY & SOUNDNESS OF THE CASTINGS THEREAFTER 5% CASTING FROM THE BULK SUPPLY SHALL BE REQUIRED TO BE EXAMINED FOR RADIOGRAPHIC TEST BY THE FIRM & SUCH RECORDS PROVIDED TO US.
7. ALONGWITH THE BULK SUPPLY THE MATERIAL TEST CERTIFICATE & CHEMICAL ANALYSIS REPORT WILL BE REQUIRED TO BE FURNISHED FOR EACH CAST/HEAT OF MATERIAL USED FOR POURING OF CASTINGS.
8. ADEQUATE CARE SHOULD BE TAKEN TO ENSURE THAT THERE IS NO DECARBORISATION OF THE CASTINGS.
9. 100% CASTINGS WILL BE REQUIRED TO BE TESTED FOR MAGNETIC CRACK DETECTION TO ENSURE THAT CASTINGS ARE FREE FROM CRACKS.
10. SURF. MKD. THUS TO BE MACHINED AT OUR END
11. APPROX. WEIGHT:- 11 GRAMS
12. SETTING TO BE CARRIED OUT BY SUPPLIER
13. MANUFACTURER'S INITIAL, BATCH. NO. & YEAR OF MANUFACTURE SHOULD BE MARKED ON THE SURFACE MKD. THUS

UNSPECIFIED TOLERANCE
± 0.12 M.M. FOR EACH 25.4 M.M.
ANGULAR TOLERANCE ± 30'
MIN. FILLET RADIUS 0.3 M.M.
FLATNESS ± 10/25.4 M.M.

SHIELD
DRG. NO. PH1-1
SKETCH FOR INVESTMET CASTING

SCALE

2:1



SMALL ARMS FACTORY,
KANPUR.

DRAWN TRACED CHKD

Sd. S.K. MISHRA Sd. K. ALI

DATE 14-11-02

APPROVED

Sd. N.K. ROY JWM/D.O.

DRG. NO.

SK 3665*

SHEET 1 OF 1

COMPARED BY- 14-11-02

ORIGINAL APPROVAL DATE: 22-1-88