

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

VETTED FOR MATERIAL ONLY

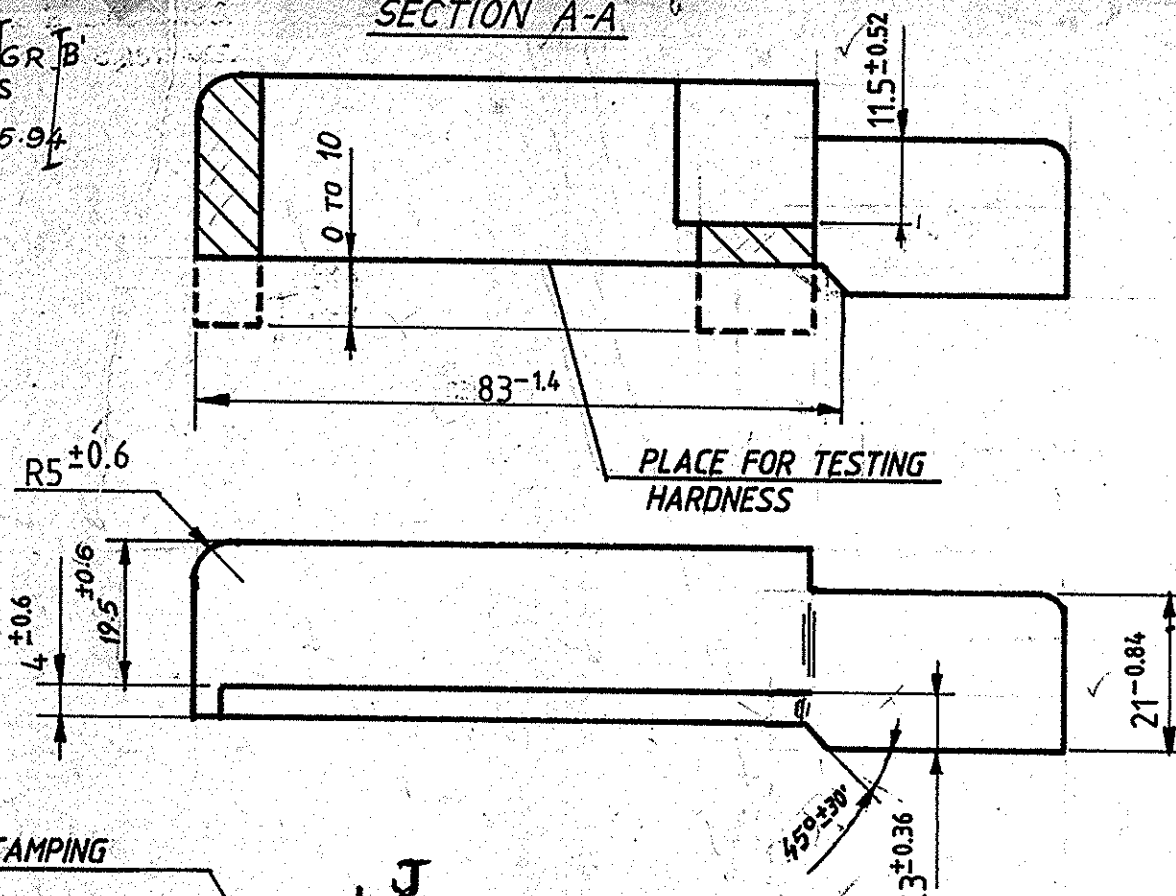
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ARAO
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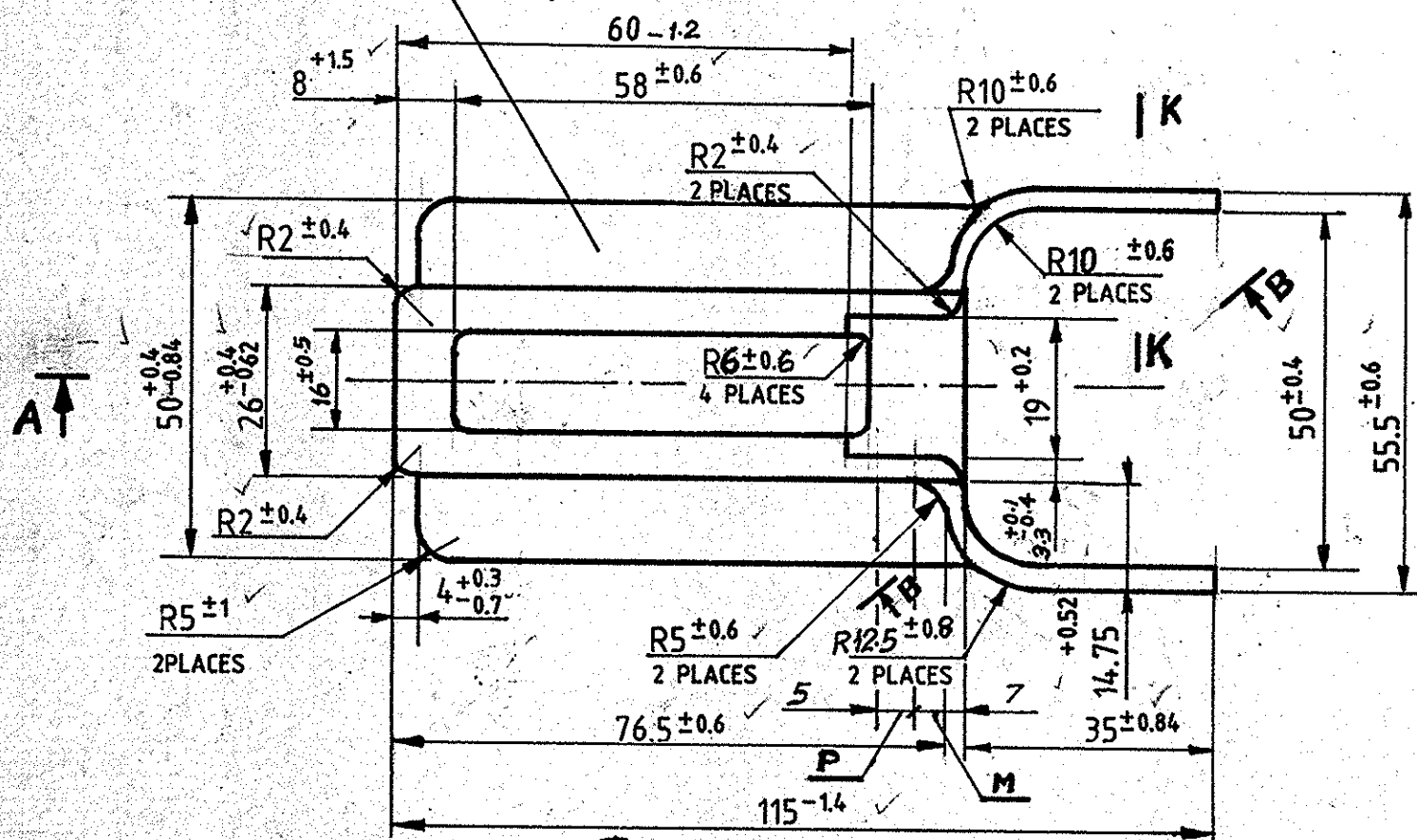
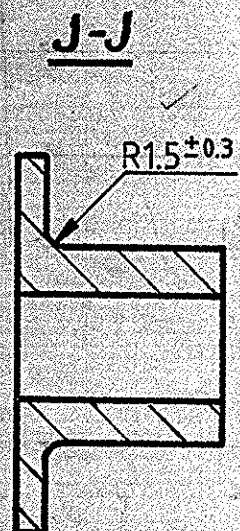
Principal Scientific Officer,
 Quality Assurance Officer,
 Senior Quality Assurance Officer,
 Quality Assurance Estt. (Arjats)
 Tiruchirappalli - 620 016.

SECTION A-A



PLACE FOR TESTING
 HARDNESS

PLACE FOR STAMPING



B-B

F	DA.12/98 D/127 mm Db. 30.11.98 MATL. FOR INDIA AMENDED REF. DC. NO. 24191-SA DE. 23-10-98	S. Raj 30/11/98
E	DA. NO. 3. D/127 mm 12-5-98 MATL. FOR INDIA AMEND REF. DC. 24064-SA-24398 12-5-98	S. Raj 12-5-98
D	DA. No. 2/95 D-127 DE 17-2-95	S. Raj 17-2-95

C	DA. NO. 4/93 D/127 DE 19-93	S. Raj 19-93
B	MATL. FOR INDIA ADDED	S. Raj 19-93
A	AMENDMENTS	S. Raj 19-93

SHEETS : 1	1 ANGLE PROJECTION	DRAWN
SHEET NO. 1	SCALE : 1:1	CHECKED
ALL DIMENSIONS ARE IN mm.		

DS: CAT NO. 1005007167	
SUB:-	SIGHT BED BODY TRIGGER MECH.

CASTING DRG.	6P11-7-2
DRG. NO. : 62 C 7102 250 F. 3	

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 0.2 mm.
6. STAMP THE SL. NO. OF THE TAG ON WHICH THE DETAILS ARE MARKED. STAMP INSPECTION MARK
7. SECTION K-K FOR MEASURING DEPTH OF DECARBURISED LAYER.

B. REFER ATTACHED SHEET FOR HEAT TREATMENT PROCESS [DRG-NO: M882]
 9. CASTING RADIUS R 2.5 IS PERMITTED ON THE SECTION 'M'.
 SMOOTH TRANSITION FROM R 2.5 TO R 1 ON SECTION 'P'
 HARDNESS. HB. 241 max.

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 STANDARD FOR GAS HOLE AND FOREIGN
 MATERIAL:- LEVEL-5 SHRINKAGE (ALL TYPES):-LEVEL-3
 ALSO REFER CQA (MET) ICHAPUR, INSPECTION
 INSTRUCTION NO. MQA-1/QA-1/12 DE. 5-5-94
 FOR OTHER DETAILS.

DETAILS TO BE MARKED ON TAG:
 SL. NO. OF TAG
 BATCH NO.
 NO. OF COMPTS. IN THE BATCH.
 INSP. MARK OF MOULD CHECK.