

## DIMENSIONS WITHOUT TOLERANCE TO BE AS PER STD. I. S. 11166-1993 CLASS - 2 OF INVESTMENT CASTING.

- CASTINGS SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT TEARS, COLD SHUTS, BLOW HOLES ETC. AND SURFACE FINISH SHOULD BE SMOOTH. VISUAL EXAMINATION SHOULD CONFORM TO CLAUSE 8.1 & 8.2 OF SPECN. I. S.: 10343-1999 AND A. O. L. (2.5) OF I. S.: 2500 Pt. I INSPECTION LEVEL IV.
- DECARBURISATION SHOULD NOT BE MORE THAN 2% OF THE THICKNESS OF THE CASTING
- TEST PIECES SHOULD BE TESTED IN ACCORDANCE WITH CLAUSE 1: 10 MOTHOD (1) OF BS 3146 Pt. 1 1974 TEST PIECES SHOULD BE CAST FROM THE SAME MELT USED AND SHOULD BE MADE TO SATISFY THE SPECN. IS: 10343-1999. RESULT OF TEST SHALL BE FURNISHED ALONG WITH I-NOTE.
- ب SHARP EDGES IF ANY ARE TO BE REMOVED.
- ALL CASTINGS & REPRESENTATIVE TEST SAMPLES SHALL BE LEGIBLY ENGRAVED WITH MANUFACTURER'S IDENTIFICATION MARK OF SUITABLE SIZE AT THE DESIGNATED AREA
- 10 TO 15 NOS. SAMPLE CASTING DUELY PASSED BY INSPECTOR IN RADIOGRAPHIC TEST MATERIAL, DIMENSIONS ETC. TO BE SENT AGAINST EACH S.O. TO THIS FACTORY FOR FITMENT TRIAL BEFORE BULK SUPPLY.

## TROPART TRACE

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## INSPECTION CRITERIA

- 100% MAGNETIC TEST FOR CRACK DETECTION TO BE CARRIED OUT IN **SAMPL**ES AS PER INSPECTION LEVEL IV AT A. O. L. O. 65 AS PER I. S. ; 2500 Pt. I 1**965**
- ίņ RADIOGRAPHIC STANDARD AS PER ASTM-E-192 GAS HOLE & FOREIGN MATERIAL LEVEL-5, SHRINKAGE LEVEL 3, CRACKS, COLD SHUTS, HOT TEARS ETC. ARE NOT ACCEPTABLE.
- 100% OF THE ADVANCE SAMPLES SHALL BE SUBJECTED TO RADIOGRAPHIC TEST.
- FOR BULK COMPONENTS, 5% EACH OF CAST/HEAT SHOULD BE SUBJ**ECTED** TO RADIDGRAPHIC TEST UNTIL THE PRODUCTION IS ESTABLISHED BY **THE** VENDOR
- ω TEST PIECE TO BE EXAMINED FOR TENSILE STRENGTH & IZOD VALUE
- 4. MACHINIABILITY TO BE TESTED BY DRILLING 02.5 HOLES THROUGH AND THROUGH ON ATLEAST 02 SAMPLES.
- ب ALL DRGS. DIMNS. ARE TO BE CHECKED AFTER FINAL HEAT TREATMENT
- è THE SUPPLIER WILL MANUFACTURE 02 SETS OF VERIFIED BY  $\ensuremath{\mathsf{RFI}}$  . INSPECTION GAUGE AND GET IT

TREATMENT: - CASTING TO BE SUPPLIED FINALLY AFTER ANNELING TEMPERING & HARDENING TO BHN 248-302

FINI SH HARDNESS: -: - PHOSPHATED TO SPECN. WPN/GEN-3/CLASS II DIL FINISH. 228 TO 285 BHN

ALL DIMENSIONS ARE IN mm.  2015 NAME DATE DGN. DRN. DRN. 1 APPD. 1 APPD. 1 APPD. 1 APPD. 1 RF I SK-9727*AR SHEET MA. NO. OF
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