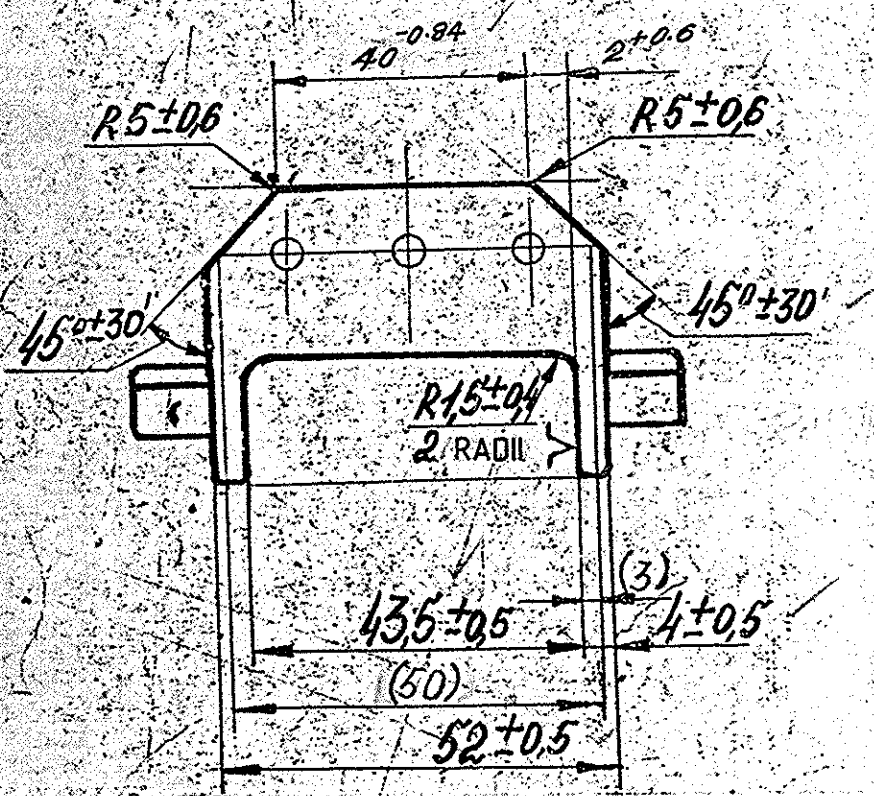


OTHER TECH. DETAILS ARE AS PER CQA (MET)
 INSPN. INST. NO. MQA-1/QA-1/12
 DE. 5-5-94



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
 STANDARDS FOR GAS HOLE AND FOREIGN MATERIALS :- LEVEL-5
 SHRINKAGE (ALL TYPES) LEVEL-3. ALSO REFER CQA [MET.] CHAPTER
 INSPECTION INSTRUCTION NO. MQA-1/QA-1/12 DE. 5-5-94
 FOR OTHER DETAILS.

HARDNESS: HB. 241 MAX.

1. SURFACE ROUGHNESS OF CASTINGS AS PER STD.
2. DRAFT ANGLE IS UP TO 1°.
3. UNSPECIFIED CASTING RADII UP TO 1mm.
4. MISALIGNMENT ALONG PARTING PLANE UPTO 0.2mm.
5. SINKAGE OF TRACES DUE TO EJECTOR IS PERMITTED UPTO ± 0.5mm. ON WORKING SURFACES.
6. STAMP THE SL. NO. OF TAG ON WHICH THE DETAILS ARE MARKED. STAMP INSPECTION MARK
7. SECTION A-A FOR MEASURING DEPTH OF DECARBURIZED LAYER.

Details to be marked on Tag	
Sl.no. of Tag	
Batch no.	
No. of comp. in the Batch	
Insp. mark of mould check	
VETTED FOR MATERIAL ONLY	
 ARAO SQA E(A) TRICHY	 Principal Scientific Officer, Quality Assurance Officer, Senior Quality Assurance Officer, Quality Assurance Estt. (Arms) Tiruchirappalli - 620 016

8. DIMENSION IN () ARE FOR REFERENCE ONLY.
 9. REFER ATTACHED SHEET FOR HEAT TREATMENT PROCESS DRG. NO: M 882

DA.12/98 D/12.7mm DE.30.11.98 MATL. FOR INDIA AMENDED DE. NO. 24192-SA. DE. 24.10.98		S. Roy 30.11.98		DA. NO. 7/98 D/12-7 DE. 7.6.98		S. Roy 7.6.98		DS. CAT NO. 1005007441		BRACKET CATCH REAR COVER.	
DA.12/98 D/12.7mm DE.30.11.98 MATL. FOR INDIA AMENDED DE. NO. 24192-SA. DE. 24.10.98		S. Roy 30.11.98		D.A. NO. 4/95 D.12.7mm DE. 4.3.95		S. Roy 4.3.95		SHEETS : 1		1 ST ANGLE	
DA.12/98 D/12.7mm DE.30.11.98 MATL. FOR INDIA AMENDED DE. NO. 24192-SA. DE. 24.10.98		S. Roy 30.11.98		MATERIAL FOR INDIA ADDED AMENDMENTS		S. Roy 12.91		SHEET No : 1		PROJECTION	
DA.12/98 D/12.7mm DE.30.11.98 MATL. FOR INDIA AMENDED DE. NO. 24192-SA. DE. 24.10.98		S. Roy 30.11.98		MATERIAL FOR INDIA ADDED AMENDMENTS		S. Roy 12.91		ALL DIMENSIONS ARE IN mm.		SCALE : 1:1	
DA.12/98 D/12.7mm DE.30.11.98 MATL. FOR INDIA AMENDED DE. NO. 24192-SA. DE. 24.10.98		S. Roy 30.11.98		MATERIAL FOR INDIA ADDED AMENDMENTS		S. Roy 12.91		CHECKED		DIV. OFFICER	
DA.12/98 D/12.7mm DE.30.11.98 MATL. FOR INDIA AMENDED DE. NO. 24192-SA. DE. 24.10.98		S. Roy 30.11.98		MATERIAL FOR INDIA ADDED AMENDMENTS		S. Roy 12.91		DRAWN		CASTING DRG. 6P11-6-20	
DA.12/98 D/12.7mm DE.30.11.98 MATL. FOR INDIA AMENDED DE. NO. 24192-SA. DE. 24.10.98		S. Roy 30.11.98		MATERIAL FOR INDIA ADDED AMENDMENTS		S. Roy 12.91		CHECKED		DRG. NO.: 62-C-6020-250-E-3	