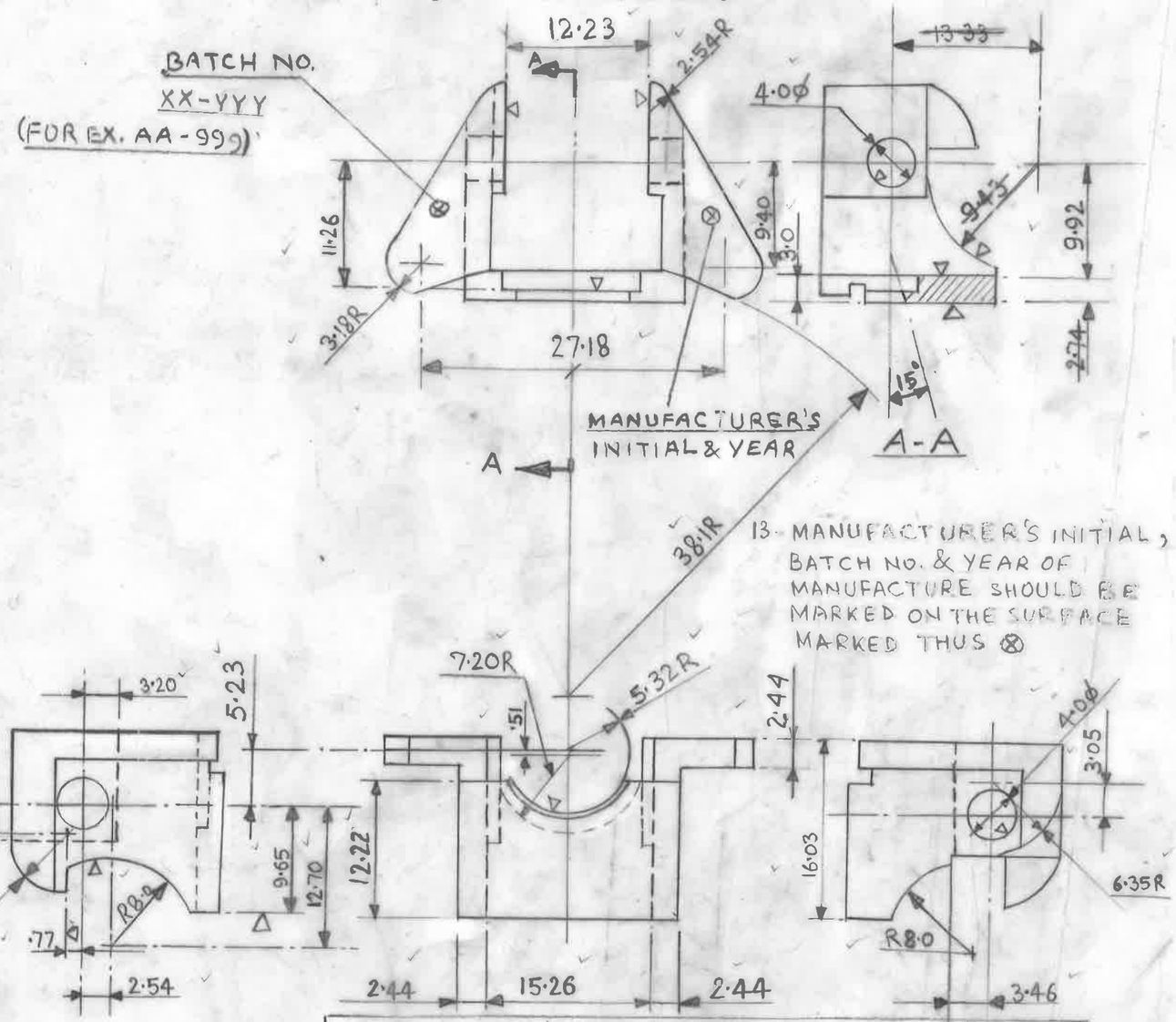
DRG. NO. SK-3411 *1

| DATE | DA NO. | NATURE | I.C/DO |
|---|---|---|---|
| 24.3.88 | 44/88 | CLAUSE NO 6 DELETED | |
| 25.5.89 | 62/89 | IN SECTIONE VIEW A-A, DIM. 2.74 DELETED | |
| 27.3.95 | 19/95 | MATL. REVISED. | |

D.A. NO.




13. MANUFACTURER'S INITIAL, BATCH NO. & YEAR OF MANUFACTURE SHOULD BE MARKED ON THE SURFACE MARKED THUS ⊗

NOTE:-

1. SHARP CORNERS MAY BE AVOIDED. UNSPESIFIED FILLET RADII 0.5 mm 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 AND ANY OTHER SURFACE DEFECTS.
5. BEFORE BULK PRODUCTION CLEARANCE WILL BE GIVEN PILOT BATCH OF 10 CASTINGS WILL BE REQUIRED TO BE SUBMITTED ALONG WITH 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. THERE AFTER 5% CASTINGS FROM THE BULK SUPPLY SHALL BE REQUIRED TO BE EXAMINED FOR RADIOGRAPHIC TEST BY THE FIRM & SUCH RECORDS PROVIDED TO US.~~
7. ALONG WITH 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 DECARBURISATION 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 12 gms.
12. SETTING TO BE CARRIED OUT BY SUPPLIER.

UNSPECIFIED TOLERANCE

± 0.10MM FOR EACH 25.4MM.
ANGULAR TOLERANCE ± 30'
MIN. FILLET RADIUS 0.3MM.
FLATNESS:- ± .10/25.4MM)

MATERIAL:- BS 3146 PT 1.1974 TYPE 12 GRADE 'A'
~~BS 970 EN9 OR EQUIVALENT MATERIAL TO GIVE EQUIVALENT OR BETTER MECHANICAL / PHYSICAL PROPERTIES.~~
(TEST PIECE IS TO BE TESTED FROM ONE CASTING DULY HARDNED & TEMPERED FROM EACH / CAST FOR MECHANICAL PROPERTIES STIPULTED IN THE SPECIFICATION.)

| DATE | DA NO. | NATURE | JWM(DO) |
|---|---|---|---|
| 11.05.10 | 10/10 | PLACE FOR MARKING INFORMATION SHOWN PROPERLY | |
| 9-4-04 | 35/04 | NOTE NO. 13:- ADDED | |
| 30-5-98 | 73/98 | IN L.H. SIDE VIEW - DIMS. R 8.0, 2.54 ± 0.025 & 12.70 ± 0.025 ADDED. IN R.H. SIDE VIEW DIM. R 8.0 WAS 10.33 R. IN SEC. A.A :- DIMS. 9.43 R & 13.33 DELETED & DRG. NO. ADVANCED TO SK 3411 * | |

DIMENSIONS ARE IN m.m.
DIM. MKD. ⌒ NTS

# CAM CYLINDER

DRG. NO. PH 1/4

SKETCH FOR INVESTMENT CASTING

| DRAWN | TRACED | CHKD |
|---|---|---|
| Sd. K. ALI | | Sd. xxx |
| DATE | 21-11-02 | |

APPROVED
Sd. H.B. SARKAR — JWM/D.O. 21/11

SCALE 2:1

SMALL ARMS FACTORY, KANPUR.

DRG. NO. SK-3411 *1

SHEET 1 OF 1

COMPARED:- 21-11-02

ORIGENAL DATE OF APPROVEL 25-6-86