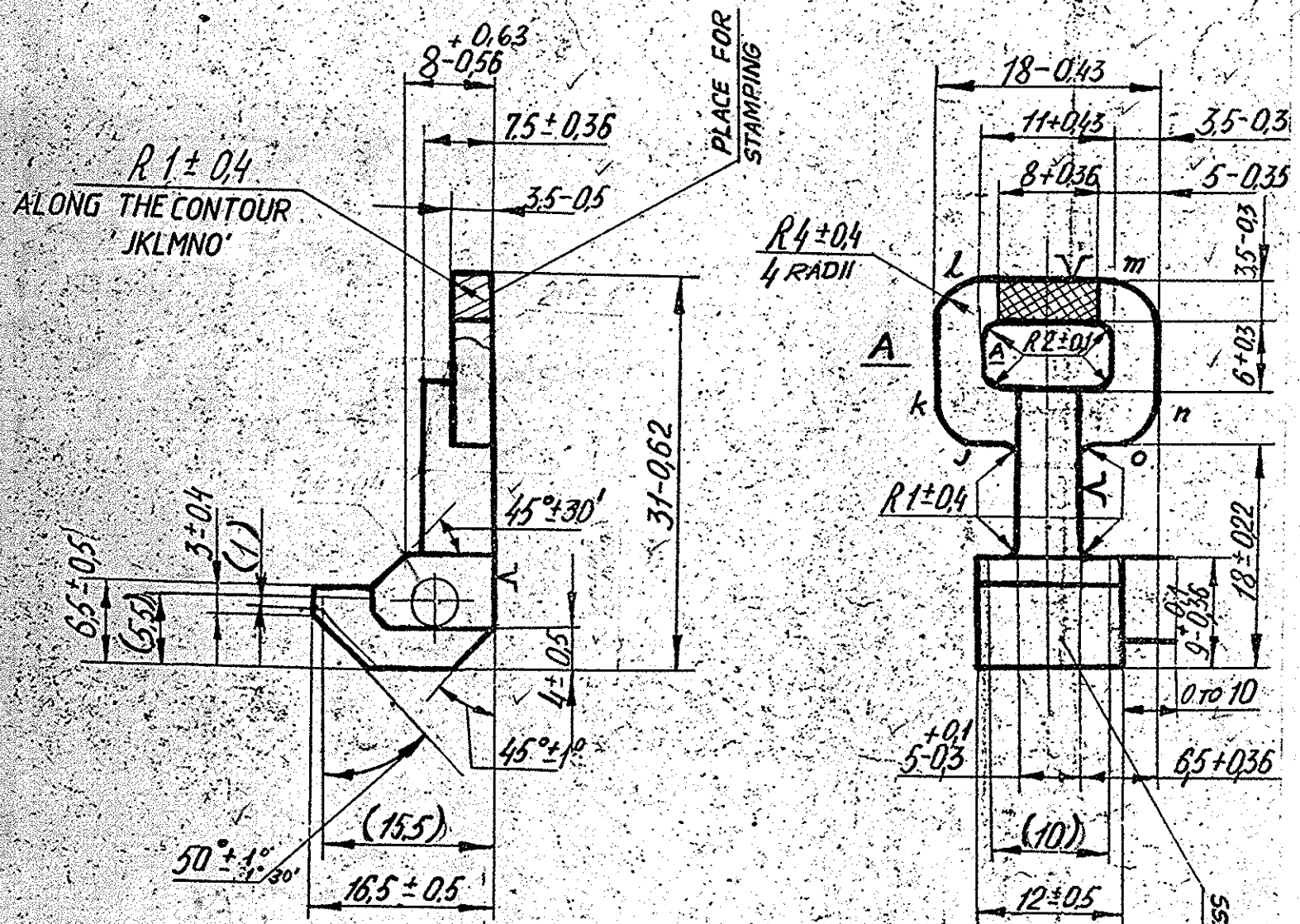


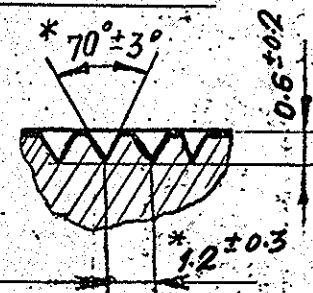
Details to be marked on the Tag

- Sl.no. of Tag
- Batch no.
- No. of compts. in the Batch
- Insp. mark of mould check
- Insp. mark of Component



PROFILE OF TEETH

SCALE 5:1



1. SURFACE ROUGHNESS OF CASTINGS AS PER CHECKING SPECIMEN.
2. DRAFT ANGLE IS UP TO 1°.
3. UNSPECIFIED CASTING RADII UP TO 1.6 mm.
4. MISALIGNMENT ALONG PARTING PLANE UPTO 0.2mm.
5. SINKAGE OF TRACES DUE TO EJECTOR IS PERMITTED UPTO 0.2mm.
6. STAMP THE SL.NO. OF THE TAG ON WHICH THE DETAILS ARE MARKED
7. SECTION A-A FOR MEASURING DEPTH OF DECARBURIZED LAYER.

- \*DIMENSIONS PROVIDED WITH THE TOOL
9. PROFILE OF TEETH AS PER CHECKING SPECIMEN.
  10. DIMENSIONS IN ( ) ARE FOR REFERENCE ONLY
  11. REFER ATTACHED SHEET FOR HEAT TREATMENT PROCESS - DRG. NO. M 882

MATERIAL FOR INDIA:

BS. 3146 PT. 1 : 1974 TYPE CLA. 12 GR. A. TO GRADE B CASTINGS  
 RADIOGRAPHIC TEST AS PER ASTM-E-192 WITH ACCEPTANCE STANDARD FOR GAS HOLE AND FOREIGN MATERIALS: LEVEL-5  
 SHRINKAGE (ALL TYPES) LEVEL-3. ALSO REFER CRACMET  
 CHAPUR INSPECTION INSTRUCTION NO. MQA-1/RA-1/12  
 DE.5-5-94 FOR OTHER DETAILS.

Hardness HB 241 max

NOTE: MACRO-ETCH TEST IS TO BE CARRIED OUT AS PER ASTM E 381 WITH ACCEPTANCE STANDARD AS C<sub>2</sub>, R<sub>2</sub>, S<sub>2</sub>  
 MICROSCOPIC DETERMINATION OF NON-METALLIC INCLUSION RATING AS PER IS: 4163-82

DS.CAT. NO. 1005007177

TRIGGER

CASTING DRG. 6P11-7-16.

DRG. NO.: 62 C 7016 250 F-3

DA.No.12/98 D/12.7mm DC.30.11.98  
 MATL. FOR INDIA AMENDED  
 REF. DC. NO. 24191 SA. DE. 23.10.98  
 S. Raju  
 30.11.98

VETTED FOR MATERIAL ONLY

Principal Scientific Officer,  
 Quality Assurance Officer,  
 Senior Quality Assurance Officer,  
 Quality Assurance Unit (Arms)  
 Tiruchirappalli - 620 016.

ARAO  
 SQA(A)  
 TRICHY

E	DA NO. 3 D/12.7mm DC. 12.5.98 MATL. FOR INDIA AMENDED REF. DC. NO. 24064 SA. DE. 23.10.98	S. Raju 12.5.98
D	DA NO. 16 D/12.7mm DC. 16.9.95 GRADE 'A' TO GRADE 'B' AMENDED	S. Raju 16.9.95
C	DA NO. 4/95 D. 12.7mm DC. 4.3.95	S. Raju 4.3.95
AMENDMENTS	DESCRIPTION / DETAILS	SIG. & DATE

SHEETS : 1	1 <sup>ST</sup> ANGLE	PROJECTION	DRAWN	V/C PROJ.
SHEET No : 1	SCALE : 2:1	CHECKED	DIV. OFFICER	
ALL DIMENSIONS ARE IN mm.				