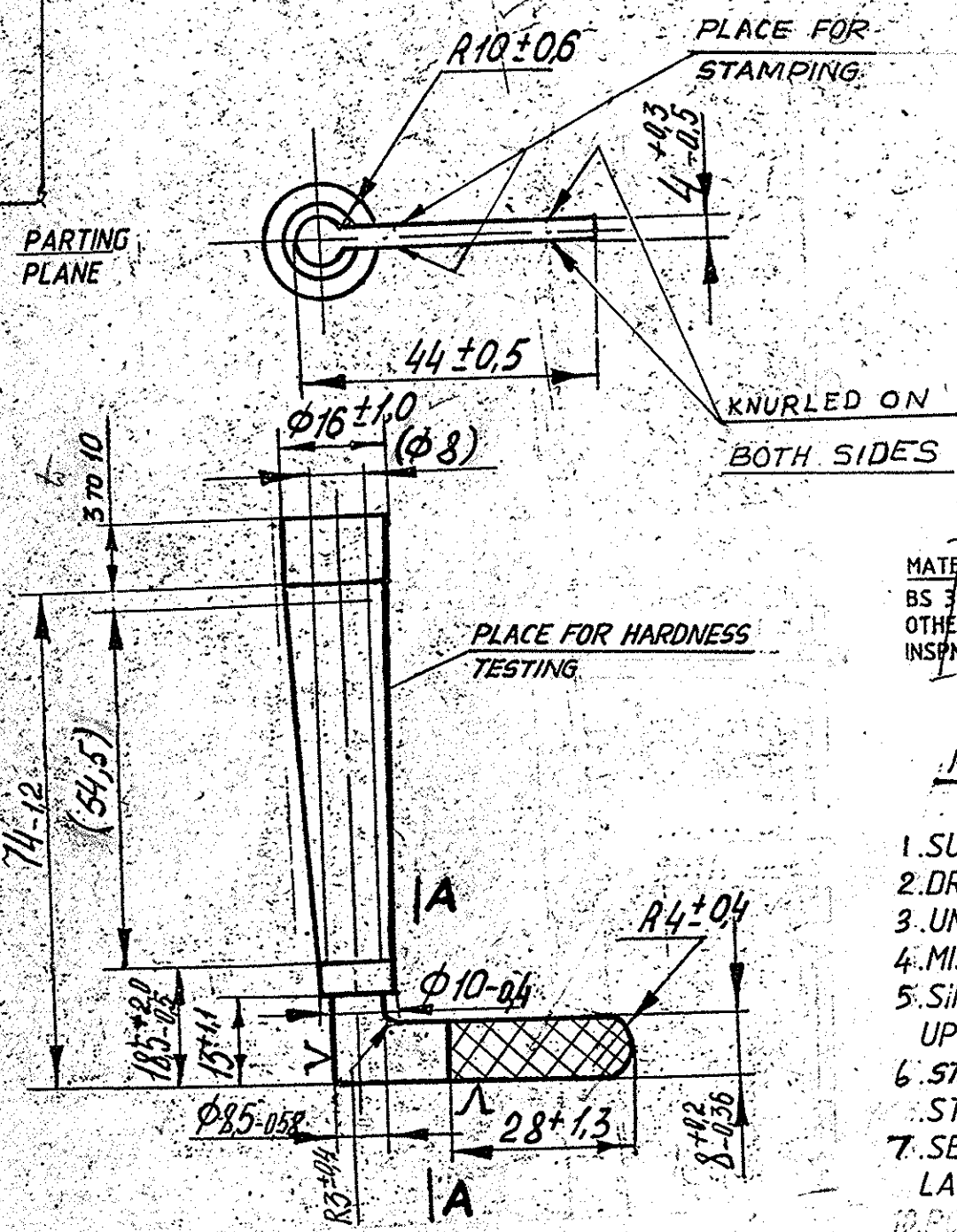


VETTED FOR MATERIAL ONLY

[Handwritten signatures]
 29/8

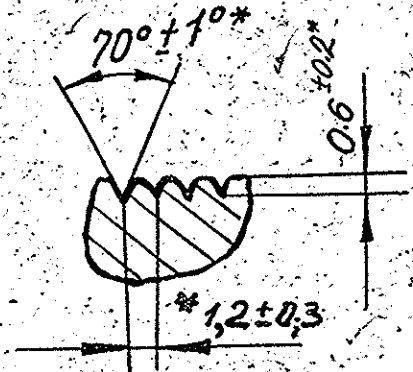
Principal Scientific Officer,
 Quality Assurance Officer,
 Senior Quality Assurance Officer,
 Quality Assurance Estt. (Arms)
 Tiruchirapalli - 620 016.

AQAD
 SQ AE (A)
 TRICHY



PROFILE OF KNURLING

SCALE:- 5:1



MATERIAL FOR INDIA:-
 BS 3146 PT 1 1974 TYPE CLA. 12 GRADE 'B'
 OTHER TECH. DETAILS ARE AS PER CQA (MET)
 INSPN. INST. No. MQA-1/QA-1/12 DE-5-5-94

HARDNESS HB 241 MAX.

1. SURFACE ROUGHNESS OF CASTINGS AS PER CHECKING SPECIMEN
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 0.2mm. ON WORKING SURFACES.
6. STAMP THE SL. NO. OF TAG ON WHICH THE DETAILS ARE MARKED
7. STAMP INSPECTION MARK
7. SECTION A-A FOR MEASURING DEPTH OF DECARBURIZED LAYER.

- * 8. DIMENSIONS FOR TOOL
- * 9. DIMENSIONS PROVIDED WITH DIE.
10. PROFILE OF TEETH AS PER CHECKING SPECIMEN.
11. REFER ATTACHED SHEET FOR HEAT TREATMENT PROCESS. DRG. NO: M 882

Details to be marked on the Tag

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

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 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.

				DS. CAT NO. 1005007444		HANDLE CATCH FRICTION.				
F	DA. 12/98 D/12.7mm DE. 30.11.98 MATL. FOR INDIA AMENDED DC. NO. 24192-SA - DC. 24.10.98	S. Raju 30.11.98	D	DA. NO. 4/95 D/12.7mm DE. 4.3.95	S. Raju 4.3.95	SHEETS : 1	1 ST ANGLE PROJECTION	<i>[Signature]</i> DRAWN	I/C PROJ.	CASTING DRG. 6P11-6-25
E	MATL. FOR INDIA AMENDED. 24097-SA DE. 5-5-98 DA. NO. 8/98 D/12.7mm DE. 16.6.98	S. Raju 16.6.98	C	MATL. FOR INDIA ADDED	<i>[Signature]</i> 12.12.91	SHEET No : 1	SCALE : 1:1	<i>[Signature]</i> CHECKED	DIV. OFFICER.	DRG. NO.: 62 C 6025 250 F 3
				DA. No. 20/90 d/19.9	<i>[Signature]</i> 13.9.90	ALL DIMENSIONS ARE IN mm.				
				AMENDMENTS	SIG. & DATE					