

2A42 10 036

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| 18174-W PROV SEALING CANCELLED AND DRG 22-9-95 SEALED. | 18149-W IND MATL AMENDED. 22.7.95 |
| 18193-W NOTE No. 4 AMENDED. 30-11-95 | |

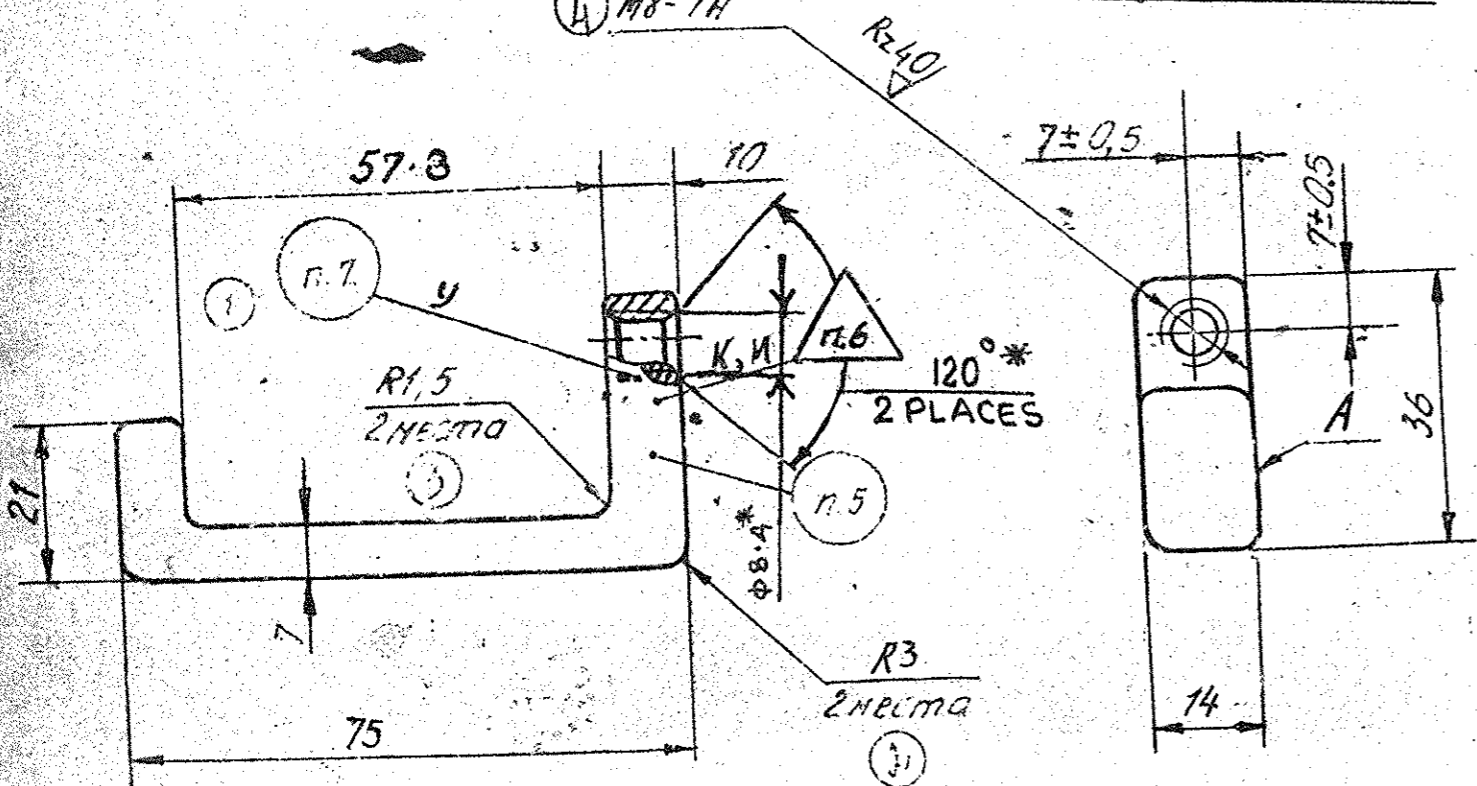
18283-W NOTE No. 4 AMENDED 19-8-96
 18412-W INDIG. MATL AMENDED 3-12-97

IND. MATL: IS:10343 GR 4D OR BS:3146 PT:174,
 TYPE CLASS GRB, CASTING TO BE HEAT TREATED
 TO ACHIEVE 41.5-51.5 HRC. SEPARATELY CAST TEST BARS
 SHALL MEET THE SPECIFIED MECH PROPERTIES
 INCLUDING IZOD IMPACT VALUE 14 J MIN
 (AUTHORITY: MBA-3/TS/B/1 d. 6/11 JUN 97)

AMENDMENT NOTICE NO.
 2A42-1156T-88 dtd. 12-4-88
 (P-89/2869)

INDIGENOUS MATERIAL:
 IS:10343 Gr 4E WITH C/.0.45-0.50
 AND MECHANICAL PROPERTIES SPECIFIED
 IN THE SPECIFICATION FOR THE GRADE
 (AUTHORITY: MBA-3/TS/B/1 d. 6/11 JUN 97)

*e) 5% OF THE CASTING SELECTED AT RANDOM FROM THE BULK
 WOULD BE SUBJECTED TO RADIOGRAPHIC TEST. THIS MAY BE
 DONE UNDER THE ARRANGEMENT OF THE AREA QUALITY ASSURANCE
 OFFICER AND SENTENCE MAY BE AWARDED BY HIM BASED ON THE
 STANDARD OF THE ADVANCE SAMPLES CLEARED BY CQA(MET) ICHAPUR.



1. Unspecified casting radii, R=1.6 mm.
2. Permissible on surface A is a pouring gate residue not exceeding 0.3 mm in height. Machine R40.
3. HRC₅ 41.5 to 51.5. Perform hardness test with 2% of parts of a lot, but at least 3 pieces.
4. Coating: accelerated electroless phosphating with chromate treatment/impregnation with adhesive 60-4, TOCT 12172-74 and nigrosine, grade A TOCT 9307-78 (1) or phosphating (accelerated) grade 1 to JSS: 8465-01-88, with coating of dunlop adhesive S 758 & nigrosine to JSS: 1036.
5. Mark as follows: P.y. mould consecutive No., mould seat No. with type NO-3, TOCT 2930-62.
6. Stamp.
7. Mark Part consecutive No. with type NO-3, TOCT 2930-62.
8. *DIM ENSURED BY TOOL
9. (X)

9. a) RADIOGRAPHIC ACCEPTANCE STANDARD OF THE CASTING SHOULD BE AS PER ASTM-E-4. 6-8, LEVEL II.
- b) 100% OF THE ADVANCE SAMPLE (NOT LESS THAN 5) WILL BE SUBJECTED TO RADIOGRAPHIC TEST.
- c) RADIOGRAPHIC TEST OF ADVANCE SAMPLES WILL BE CARRIED OUT BY CQA(MET) ICHAPUR

OR
 THE AREA QUALITY ASSURANCE OFFICER CONCERNED WOULD GET THE RADIOGRAPHIC TEST DONE IN HIS PRESENCE AND FORWARD THE

PLATES TO CQA(MET) ICHAPUR FOR SENTENCE AND APPROVAL OF THE MOULD.

- d) BULK PRODUCTION WOULD COMMENCE ONLY AFTER THE MOULD AND MATERIAL HAS BEEN APPROVED BY CQA(MET) ICHAPUR

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| 18100-W 10-3-95 | ALT MATL AMENDE & NOTE No. 9 ADDED. | 18V1V C/D |
| 17928-W 16-3-94 | INDIGS MATL AMENDED. | 18V1V C/D |
| 17755-W 14-10-93 | DRG AMENDED. | 18V1V C/D |
| 17751-W 11-10-93 | INDIGS EQUIV MATL ADDED & NOTE No. 4 AMENDED. | 18V1V C/D |
| 17220-W 11-2-92 | DIMN. 57.8 WAS 57. (R) | 18V1V C/D |
| 16407-W 20-2-86 | DRG SEALED PROV. | |

APPROVED [Signature]
 CHECKED [Signature]
 CONTROLLERATE OF INSPECTION (ICV)

2A42.10.036 7
 CLAMP
 WEIGHT 90g
 SCALE 1:1
 SMT SMTS 1
 CASTING II OCT 3-1365-79
 C9070

42/02236