

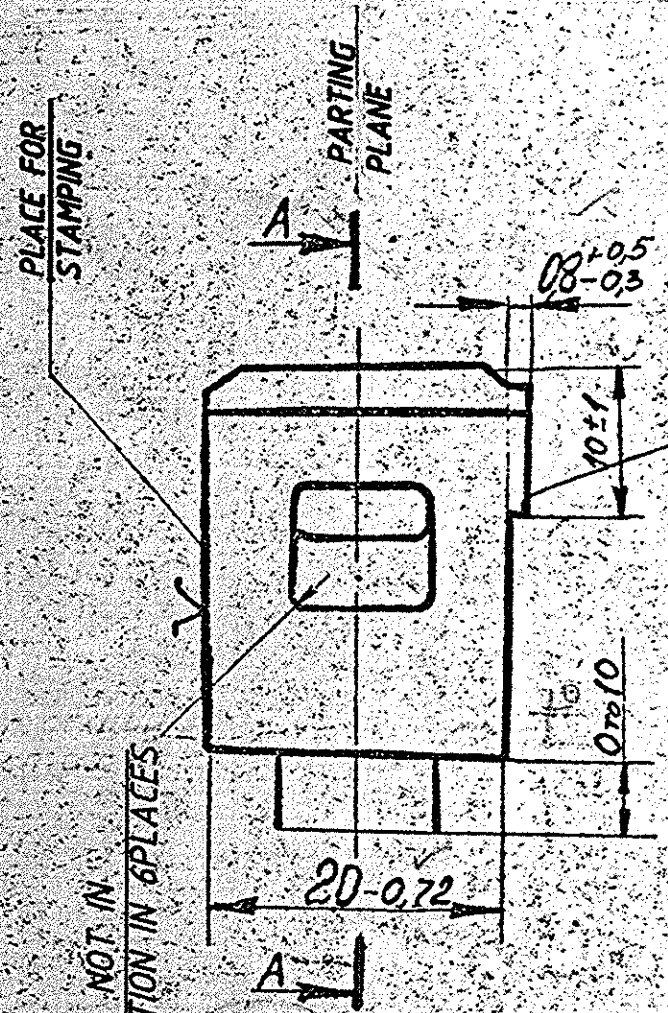
Amudha 25/12
Amudha 25/12
 AQAD
 SQAE(A)
 TRICHY

P. J. N.
 Principal Scientific Officer,
 Quality Assurance Officer,
 For Senior Quality Assurance Officer,
 Senior Quality Assurance Est. (Arms),
 Tiruchirappalli - 620 016.

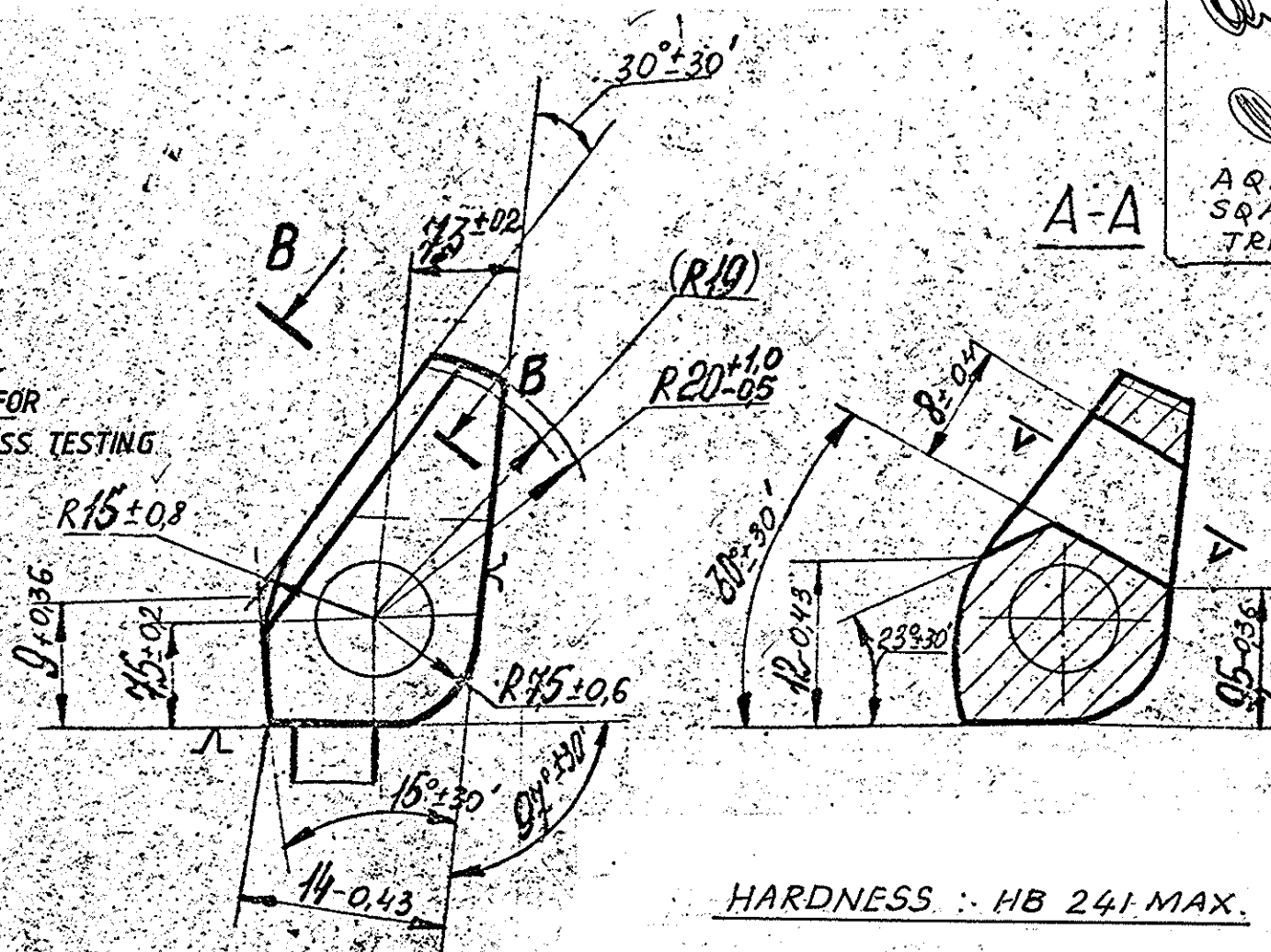
Details to be marked on the Tag

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

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



PLACE FOR
 HARDNESS TESTING

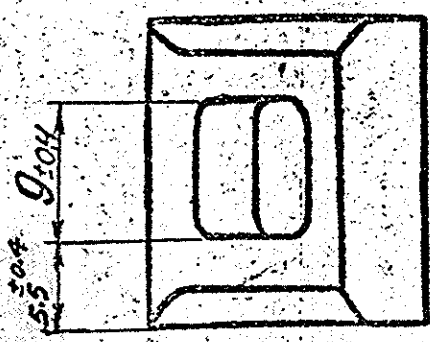
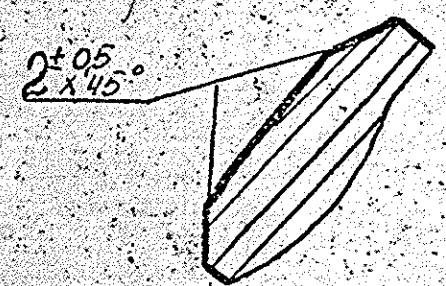


A-A

HARDNESS : HB 241 MAX.

R1.5±0.4 NOT IN
 PROJECTION IN 6 PLACES

B-B



1. SURFACE ROUGHNESS OF CASTINGS AS PER STANDARD.
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.
6. STAMP THE SL.NO. OF TAG ON WHICH THE DETAILS ARE MARKED.
7. SECTION V-V FOR MEASURING DEPTH OF DECARBURIZED LAYER.
8. DIMENSIONS IN () ARE FOR REFERENCE ONLY.
9. REFER ATTACHED SHEET FOR HEAT TREATMENT PROCESS DRG.No. M882

MATERIAL FOR INDIA:-
 BS. 3146 PT.1: 74 TYPE CLA.-12-GR. A CASTINGS.
 RADIOGRAPHIC TEST AS PER ASTM-E-392 WITH ACCEPTANCE STANDARDS FOR GAS HOLE
 AND FOREIGN MATERIALS :- LEVEL : 3 SHRINKAGE [ALL TYPES] LEVEL - 2. ALSO
 REFER CQA (MET.) CHAPUR INSPECTION INSTRUCTION NO. MQA-1/RA-1/12 DE. 5-5-94
 FOR OTHER DETAILS.

E		DA.No.12/98 D/12.7mm Dt. 30.11.98 MATL. FOR INDIA AMENDED REF. DC NO. 24193-SA. DE. 26.10.98		S. Raju 30.11.98		C		D.A. NO. 4/95 D.12.7mm DE. 4.3.95		S. Raju 4.3.95		DS. CAT NO. 534001115B		CATCH FRICTION COVERFEED.	
D		MATERIAL FOR INDIA AMENDED. 24097-SA DE. 5-5-98 DA NO. 8/98 D/12.7mm Dt. 16.6.98		S. Raju 16.6.98		B		MATL FOR INDIA ADDED		SIGN. & DATE		SHEETS : 1		1 ST ANGLE	
												SHEET No : 1		PROJECTION	
												ALL DIMENSIONS ARE IN mm.		SCALE : 2:1	
												DRAWN		CHECKED	
												DIV. OFFICER		CASTING DRG. 6P11-6-23	
														DRG. NO. : 62 C 6023 250 E 3	