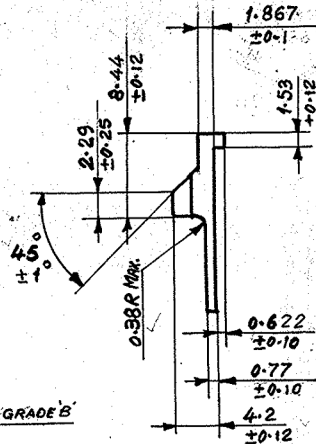
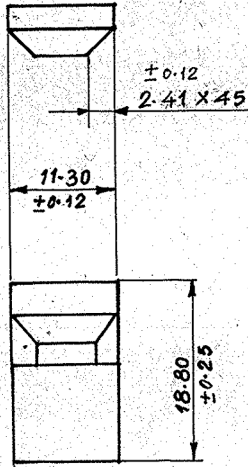


TOLERANCE OF THE MACHINED COMPONENT:-
 WHERE TOLERANCES ARE NOT SHOWN DIMS. IN
 WHOLE NUMBER OR WITH ONE DECIMAL PLACE
 ± 0.27 MM. TWO DECIMAL PLACES ± 0.127 MM.
TOLERANCE FOR ANGLES:-
 ANGLES GIVEN IN DEGREES ± 30 MINUTES.
 ANGLES GIVEN IN DEGREES & MINUTES ± 5 MIN.

TOLERANCE OF THE I.C COMPONENTS:-
 WHERE TOLERANCES NOT GIVEN GENERAL
 TOLERANCE I.S. 11166 CLAUSE I TO BE
 FOLLOWED. EXCESS MATL. FOR MACHINING
 IS ALLOWED. ABSENCE OF MATL. IS NOT
 ACCEPTABLE. REJECTION AT OUR END FOR
 WANT OF MATL. IS NOT ACCEPTABLE.



D.A.No
 30A/94/R
 12A/95/R
 22A/95/R
 24A/95/R
 29A/95/R

EDGES BROKEN 0.25
 DIMS. ARE IN MM.

RADIOGRAPHIC TEST AS PER ASTM-E-192 GRADE B
 NON-STRESSED COMPONENTS:-

100% FOR ADVANCE SAMPLES.
 FOR BULK COMPONENTS, 5% OF EACH CAST/HEAT SHOULD BE
 SUBJECTED TO RADIOGRAPHY FOR G.D. B' CASTINGS.

RADIOGRAPHIC ACCEPTANCE LIMIT:-
 GRADE B
 CASTINGS
 GAS HOLES - LEVEL - 5
 FOREIGN MATERIAL - LEVEL - 5
 SHRINKAGE (ALL TYPES) - LEVEL - 3

VISUAL EXAMINATION:-
 AS PER IS 2500-PC-1-1992 INSP. LEVEL III. AQL 1.5 (INVESTMENT
 CASTINGS ARE TO BE TESTED AS PER SPECN.
 NO. MRA-1/QA1/12 dt. 2.5.94)

VERIFIED FOR MATERIAL ONLY
 AS PER LAST DC (I) No.
 DT.

P.P.H.
 29/11/93
 P.P.O.,
 QUALITY ASSURANCE OFFICER,
 For Senior Quality Assurance Officer,
 Senior Quality Assurance Engr. (Areas)
 TIRUCHIRAPPALLI - 620 016.

DRAWING UPDATED ON 20-11-93

MATL: (INVESTMENT CASTING)
 BS-3146 PE-1: 1974 TYPE CLA-2
 (IN NORMALISED CONDITION)

3RD ANGLE
PROTECTION.

SCALE: 2:1

DRAWN *Arundhan*
CHECKED *Arundhan*
 10-8-82

APPROVED: 8/82

DRG. NO.

TITLE:-
 LOCATING PIECE

P. M. M.
 P.F. D.D. OFFICE P. MANAGER.

TEND-255

D.S. CAT. No. 1005-1743 (ICR 1505)