

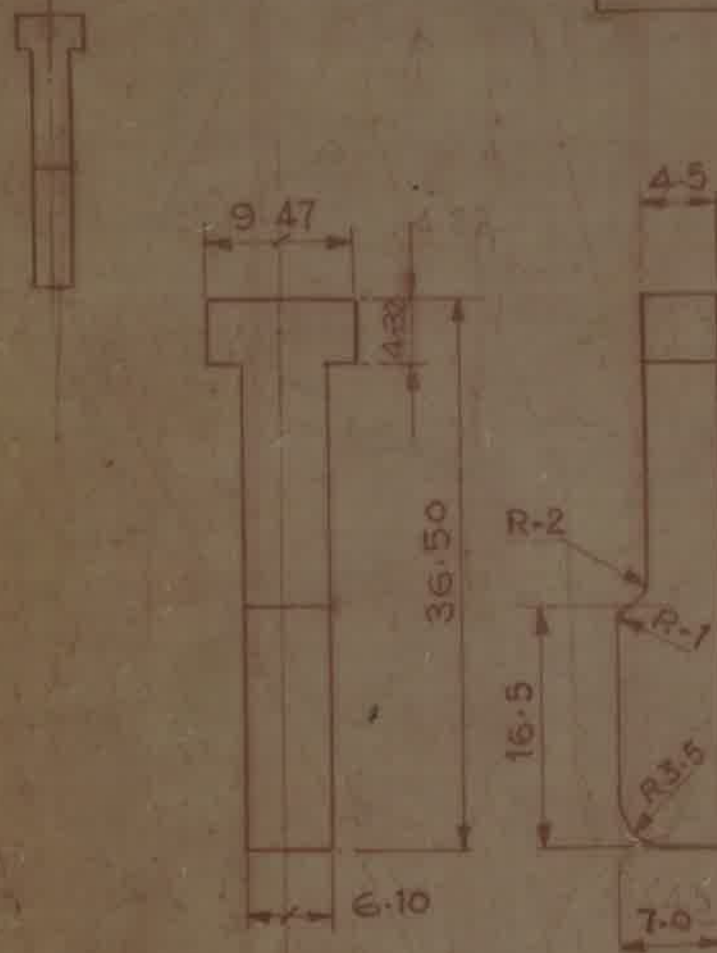
SK-3715*

MATL. VETTED

QAE (SA)

INCLUSION RADIOGRAPHIC TEST
D.A. NO. 105/91 VETTEDQAE (SA)
KANPUR

ACTUAL SIZE



ACCEPTANCE STANDARD

AS PER ASTM E-192

CATEGORY OF CASTING - 'B'

MATERIAL: B.S. 3146 PT.1 1974 TYPE CLA-1 GRA

REF: (CQA(SA) CHAPORE LETTER NO MQA-1/02/INVEST DATED 30.6.88)

INSPECTION WILL BE GUIDED IN GENERAL AS PER CONTROLLERATE
OF INSPECTION (METALS) CHAPORE NOW NAMED AS CONTROLLERATE
OF QA METALS CHAPORE. INSD. INS. NO. FMRO/CH/TC/CI/INST. 2

DIMNS ARE IN MM

12/7/96	16-12-96	NOTE NO-4 amended Category of Casting added ASTME-192 WAS ASTM E-446-B4	IC D
28/83	22.2.83	D. S. CHAPORE INSD. NO. 1005-006886 WAS CISA-633	
105/91	30.12.91	NOTE FOR RADIOGRAPHIC TEST & ACCEP. STD. ADDED	

NOTES:- 1- SETTING TO BE CARRIED OUT BY SUPPLIER.

2. SHARP CORNERS MAY BE AVOIDED, UNSPECIFIED FILLET RADIUS
0.5mm. MAX.

3. CAST MARK 'IC' SHOULD BE GIVEN AT PLACE MTD. THIS @

4. CASTING SHOULD BE SUPPLIED IN 'AS CAST' CONDITION.

5. CASTING SHOULD BE FREE FROM CRACKS, BLOW HOLES & ANY
OTHER SURFACE DEFECTS.6. BEFORE BULK PRODUCTION CLEARANCE WILL BE GIVEN. PRIOR
BATCH OF 10 CASTING WILL BE REQUIRED TO BE SETTLED
ALONG WITH THE DIMENSIONAL CRITICAL EXAMINAT. REPORT
& MATL. TEST CERTIFICATE. IF THE BATCH IS NOT ACCEPTA-
BLE FURTHER BATCHES OF 10 EACH WILL BE REQUIRED TILL
CLEARANCE IS GIVEN TO START BULK PRODUCTION.7. EACH PILOT BATCH BEFORE THE BULK PRODUCTION CLEARANCE
WILL HAVE TO BE TESTED FOR RADIOGRAPH TO ENSURE QUALITY
& SOUNDNESS OF CASTINGS. THERE AFTER 5% CASTING FROM
THE BULK SUPPLY SHALL BE REQUIRED TO BE EXAMINED FOR
RADIOGRAPHIC TEST BY THE FIRM & SUCH RECORDS PROVIDED
TO US.8. ALONG WITH THE BULK SUPPLY THE MATL. TEST CERTIFICATE
& CHEMICAL ANALYSIS REPORT WILL BE REQUIRED TO BE FUR-
NISHED FOR EACH CAST/HEAT OF MATL. USED FOR POURING OF
CASTING.9. ADEQUATE CARE SHOULD BE TAKEN TO ENSURE THAT THERE IS
NO DECARBURISATION OF CASTING.10. 100% CASTINGS WILL BE REQUIRED TO BE STATED FOR MAGNE-
TIC CRACK DETECTION TO ENSURE THAT CASTINGS ARE FREE
FROM CRACKS.

11. SURFACES MARKED THUS ▽ TO BE MACHINED AT OUR END.

12. APPROX WEIGHT:-

UNSPECIFIED TOLERANCE $\pm 12\text{mm}$. FOREACH 25.4mm.ANGULAR TOLERANCE $\pm 30^\circ$

MIN. FILLET RADIUS 0.3mm.

FLATNESS $\pm .10/25.4\text{mm}$.MATERIAL:- TEST PIECE IS TO BE TESTED FROM ONE CASTING DULY HARD-
ENED & TEMPERED FROM EACH CAST FOR MECHANICAL PROPERTIES
STIPULATED IN THE SPECIFICATION.13- 5% OF THE COMPONENTS FROM FIRST BATCH FROM EACH
SUPPLIER WILL BE SUBJECTED TO RADIOGRAPHIC TEST AND
THEREAFTER NO RADIOGRAPHIC TEST FOR SUBSEQUENT SUP-
PLIES FROM THAT SUPPLIER WILL BE DONE.

(AUTHORITY: CQA(SA) LETTER NO. 4/TC/1 DT 1-11-88)

CARBINE MACHINE 9mm 1A

LEVER LOCKING

D.S. CAT. NO. 1005-006886

DRG. NO. CISA-633

SKETCH FOR INVESTMENT CASTING

SCALE

1:1.2:1

KANPUR

SMALL ARMS FACTORY.

KANPUR

DRN. CHKD. APPROVED

APPROVED

19.7.98

18.7.98

DRG NO

SK-3715*

SHT 1- OF 1