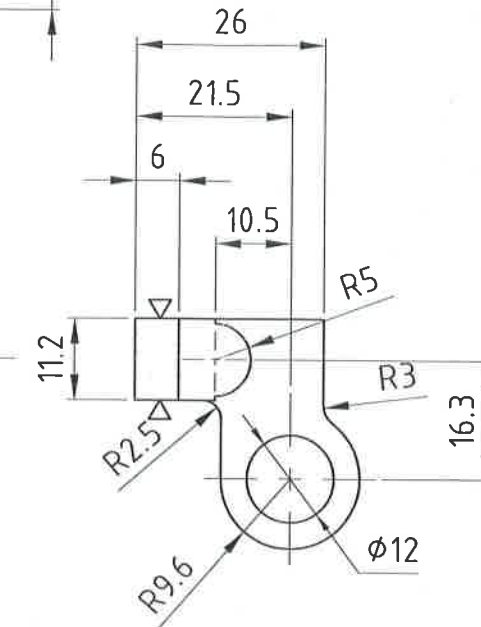


D.A. NO.

111



NOTE:-

1. SETTING TO BE CARRIED OUT BY SUPPLIER
2. SHARP CORNERS MAY BE AVOIDED, UNSPECIFIED FILLET RADII 0.5 MAX.
3. CAST MARK SHOULD BE GIVEN AT PLACE MARKED THUS x
4. CATEGORY OF CASTING 'A'
5. UNSPECIFIED TOLERANCE AS PER IS:III 66-1984 CLASS II OF INVESTMENT CASTING
6. SURFACES MARKED THUS '▽' TO BE MACHINED AT OUR END
7. RADIOGRAPHIC ACCEPTANCE STANDARD AS PER ASTM E-192
8. CASTING SHOULD BE FREE FROM DEFECTS LIKE CRACKS, HOT TEARS, COLD SHUT ETC. AND SURFACE FINISH SHOULD BE SMOOTH. VISUAL EXAMINATION SHOULD CONFORM TO CLAUSE 8.1 & 8.2 OF SPECIFICATION IS: 10343-1982 AND AQL (C=2.6) OF IS:2500 PT.1 . INSPECTION LEVEL IV MAX. PERMISSIBLE LIMIT FOR BEND IS 0.5mm IN TOTAL LENGTH

CONDITION:-

1. CASTING SHOULD BE SUPPLIED IN ANNEALED CONDITION. HARDNESS 220 HV MAX OR
2. CASTING SHOULD BE SUPPLIED IN 'T' CONDITION. HARDNESS 248-302 HV

MATERIAL: BS 3146:1974 Part 1 Class 5 Grade 'B'

USER SECTION

JWM/CNC

DRAWN TRACED CHKD.

Mayur

DATE 20-12-2017

APPROVED

JWM/DDO

DRG.NO.

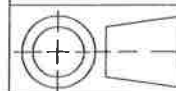
SK-JVPC- 598*

SHEET 1 OF 1

JVPC 5.56x30mm**COCKING BRACKET****DRG. NO. 0204-03-02-00-01-001-00XD**
SKETCH FOR INVESTMENT CASTING

SCALE

1 : 1

**SMALL ARMS FACTORY**
KANPUR

ALL DIMENSIONS ARE IN MM