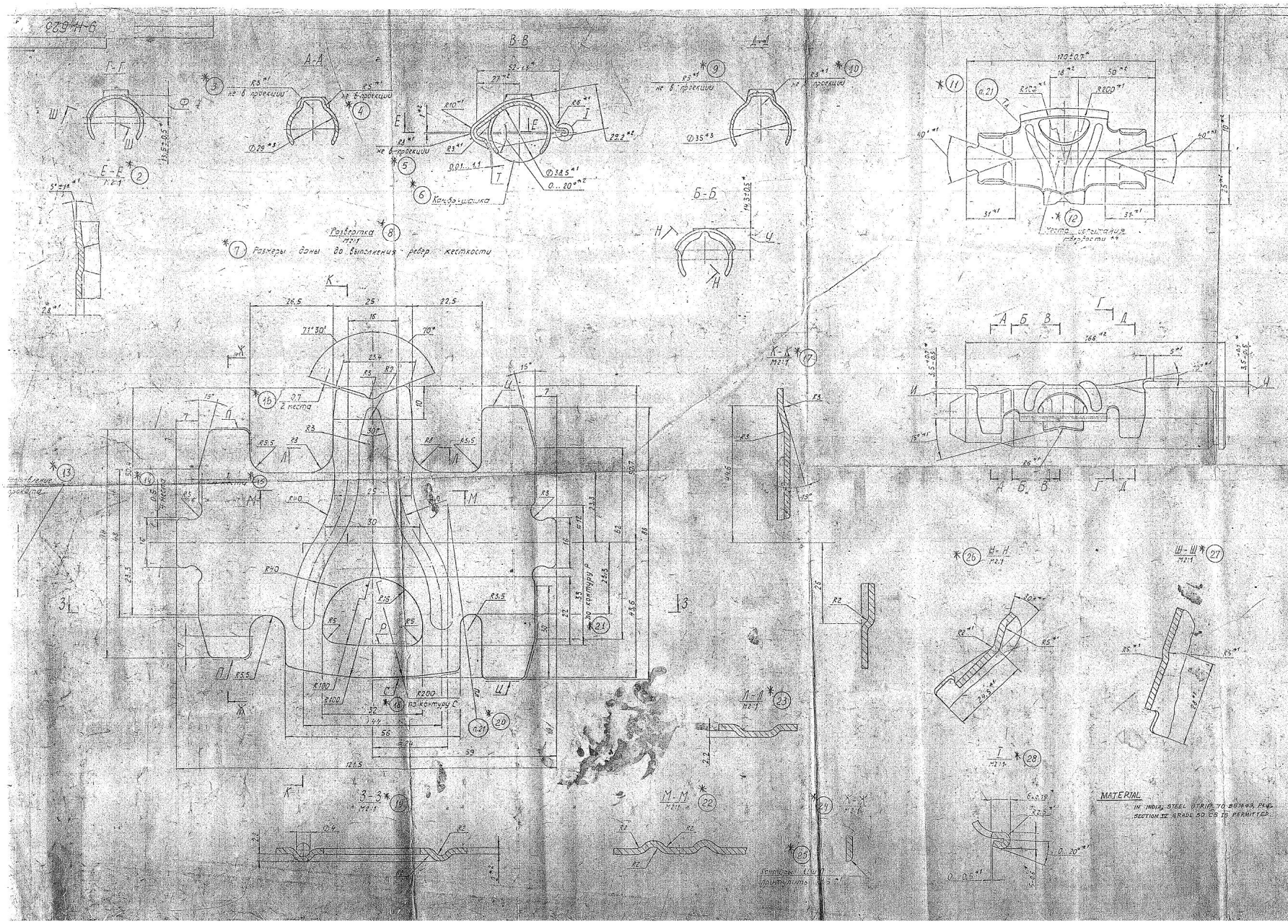

1. HRc 43.5 to 47.5
2. Round off outer angles to the radius of R=2 mm of the surface of the developed view.
3. Perform complete check of sizes. Check sizes H, T, Ч by the block gauge.
4. Sizes with sign *1, sizes of the developed part and stiffening ribs are given for a gauge and are not checked in the ready link.
5. *2 Sizes are given for reference.
6. *3 It is permissible to correct the sizes during the production process to ensure a pushing force.
7. *4 Measure hardness in the zone between the stiffening ribs in the places free of marking.
8. Round off sharp edges at least to 0.1 mm by tumbling.
9. To ensure the drawing sizes of the link, it is permissible to correct the sizes of the developed part.
10. Check sizes Y and Ф simultaneously with the same gauge.
11. Limit deviations for linear sizes of the developed part are ±0.2 mm.
12. Lack of parallelism of the hinge web relative to the link axis and deflection of the web are permissible on condition that the prescribed sizes and the requirements of Items 15, 16, 17 of the Drawing are observed.
14. The break force of the link should not be less than 8820 N (900 kgf).
15. When the belt is made fan-shaped:
    15.1. diameter of the circle with the projectiles facing outwards (as to the case bottom) should be 800 mm, maximum;
    15.2. diameter of the circle with the projectiles facing inwards (as to the projectile points) should be 220 mm, maximum.
16. A rolled portion of the belt, turned through 180°, should include 14 cartridges, maximum.
17. A pushing force of the block gauge into the link should be 784 N (80 kgf), minimum.
18. Permissible one-side increase of clearance T is up to 1.5 mm.
19. It is permissible to check clearance T by block gauges with the reduced diameter in the area of measurement, at which a clearance value is increased by the half of the reduced value of diameter of the block gauge.
20. See other requirements for manufacture and acceptance of the link in the Specification 9-Н-623 ТУ.
21. Mark and stamp according to 9-Н-623 ТУ using type 2.5 or 3.Н.ГОСТ.007.
22. Coating: electroless phosphatizing /primer ФЛ-093/, grey (1), ОСТ 6-10-427-75.IV.ОН2.
    Permissible coating: electroless phosphatizing with subsequent accelerated cromate treatment and impregnation (varnish is made on the base of glue БФ-2Н, ГОСТ 12172-74, with nigrosine, mark А, ГОСТ 9307-78 (3).
    For primer ФЛ-093, follow the technical requirements, acceptance rules and check procedure according to ОСТ В 84-1738-79, and for the varnish on the base of glue БФ-2Н - to ГОСТ 9.301-78, ГОСТ 9.302-79.

*(2) Б-Б Scale 2:1
*(3) projection is not shown
*(4) projection is not shown
*(5) projection is not shown
*(6) Block gauge
*(7) Sizes before making stiffening ribs
*(8) Developed view Scale 2:1
*(9) projection is not shown
*(10) projection is not shown
*(11) Item 21
*(12) Place of test for hardness *4
*(13) Direction of rolling
*(14) 4 places
*(15) 4 places
*(16) 2 places
*(17) К-К Scale 2:1
*(18) along contour С
*(19) А-А Scale 2:1
*(20) Item 21
*(21) along contour Р
*(22) М-М Scale 2:1
*(23) Л-Л Scale 2:1
*(24) Х-Х Scale 2:1
*(25) Contours Н and Н *1 Round off to R1.2
*(26) Н-Н Scale 2:1
*(27) Ш-Ш Scale 2:1
*(28) Т Scale 2:1

21-1-88	PC 352474	MATERIAL FOR INDIA ADDED			APPROVED
15-3-88	PC-3434SA	DRA. PROV. SEALED			FORGING
DATE	AUTHORITY	REVISION			

APPROVED
CHECKED
CONTROLLERATE OF INSPECTION (ICV)

9-Н-623

LINK

STRIP 60PA-I-C-2X150 ТУ 14-1-2501-79

WEIGHT	SCALE
0.114	1:1
SHT	SHTS
184	184

ANSR-C-2-4(A) NIKKEI