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MASTER COPY

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TY 14-1-2982-80

HOT-ROLLED RINGS FROM STEEL
OF GRADES 45 x H and 45 x HM
FOR TURRET RINGS
TECHNICAL SPECIFICATIONS
TY 14-1-2982-80



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ALL SHEET	No. OF DOCUMENT	SIGNATURE	DATE
TYPED	12/84	[Signature]	19/11/84
CHECKED	[Signature]	[Signature]	27/12/84
APPROVED	[Signature]	[Signature]	3/1/85

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1	9

2.5 Defects (laps, skins, rolled bubbles and dirt etc) are allowed on surface of the rings as well as unevenness on the faces having depth of occurrence of maximum 75% of the actual onside allowance for machining.

Fins are allowed on inner diameter of the rings.

3. ACCEPTANCE RULES AND TEST PROCEDURES

3.1 Checking the production and quality as well as acceptance of the rings are carried out by QID of the supplying factory in compliance with requirements of the present technical specifications and with the specification-charts or drawings, agreed upon.

3.2 Rings to be accepted are presented in batches. The batch includes rings of the same melt of steel in one or several standard sizes.

3.3 In order to check the surface hardness in delivery condition, three rings-upper, middle and lower along height of the charge (stack) from each charge (stack) are tested. Measurement of Brinell hardness is carried out in compliance with Gost 9012-59 at one point on the side surface of the ring by means of ball of diameter 10mm at a load of 300 Kgf. Hardness number (diameter of imprint) is marked near the place of measurement.

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on the defective half and the marking 'reject' is written with paint. Such rings are noted as '50%' in the certificate. The defective half is delivered at the price of scrap.

4.3 The rings to be shipped are accompanied with certificate in which specified are: melt number, grade of steel, chemical analysis of melt, ordinal number of the rings, code, hardness on the surface and in the cross-section, mechanical properties and the macro-structure

Drawn up basing on the condition on 01.09.83
It is correct!

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