



1. Material, heat treatment, method of acceptance and testing should comply with the test for components made out of special steel. Hardness-medium.
2. Requirements for casting as per 172.01.175.
3. In not easily accessible places and in mating places presence of burr-on (cast break) are allowed.
3. Accuracy of casting 11T-0-9-0 ГОСТ 26461-85.
4. External draft: 1:50.
5. Dimension given in brackets and after welding the bracket on half.
6. Location of inner diameter of dimension β_1 (see $\Gamma-\Gamma$) is allowed by 0.4 ± 0.1 mm above the tolerance and screwing is of no-pace with a slight risk exceeding limits allowed.
7. Along dimension 3) shoulder is allowed by 0.1 mm (see $\Gamma-\Gamma$).
8. On surface β_1 shoulders allowed by 0.1 mm (see $\Gamma-\Gamma$).
9. Presence of technological ribs with section thickness are allowed in the case of $(\gamma-\gamma)$ change over from side view to the true wall from the inner side.
10. Dimension β_2 for threaded hole β_2 (see β_2) should not be less than 7mm over a distance of 30 mm from surface β_1 (see $\Gamma-\Gamma$), for the rest of the length should be not less than 11mm.
11. Dimension β_1 (see $\Gamma-\Gamma$) with surface finishing Rz=40 microns is to be maintained over the length of 220 mm, for rest of the length dimension β_1 is to be maintained with surface finishing Rz=80 microns in this case prove β_1 (see β_1) may not be made.
12. For ensuring dimension β_1 (see $\Gamma-\Gamma$) it may be removed.
13. Dimension β_1 is to be checked at a distance of not less than 22mm from surface β_1 (see $\Gamma-\Gamma$).
14. On surface β_1 (see $\Gamma-\Gamma$) spot marks bearing depth 0.1 mm are allowed.
15. On surface β_1 (see $\Gamma-\Gamma$) for rest of the length dimension with a value not exceeding 10 mm is allowed.
16. After recognizing technological ribs, shoulders are allowed between mating and casting surfaces by 0.1 mm.
17. Coming out of end to the thread of hole β_1 (see β_1) to the outside is allowed.
18. Once in a month, components is to be checked at random as per the weight. Maximum permissible weight is 0.6 kg.
19. Lines, designated with dot and dash line are to be made with dimension $\beta_1, \beta_2, \beta_3, \beta_4$ (see main view, β_1) along the entire length.
20. On surface β_1, β_2 (see view from the top) section without treating the casting surface with total area of not exceeding 20% are allowed.
21. Dimension β_1 is to be checked along the axis of hole β_1 (see $\Gamma-\Gamma$).
22. Dimensions for reference.
23. Value of preparation (see β_1) need not be checked.
24. Other requirements as per 220 T.YI.
25. Dimension and surface finishing are to be ensured with tool.
26. For ensuring dimension β_1 , machining of surface β_1 is allowed with surface finishing Rz=80 microns, within the limits of tolerance zone of dimension β_1 (see $\Gamma-\Gamma$).
27. On surface along dimension β_1, β_2 (see main view) black spots are allowed by not exceeding 1/10 of the total area.

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