Technical requirements
for manufacturing of pipes of
pneumatic system.

765-78-101 TT.

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These technical requirements apply to the ~~pneumatic system~~ pipeline of the item, pneumatic system.

I. Technical requirements.

1.1 The pipe surface should be free of cracks, visible notches and other surface defects.

Burrs are not acceptable at the pipe ends.

1.2 Minimum bending radius should be R20 along the pipe axis (if not specified otherwise in the drawings). Ovality at bends should not exceed 1mm. Carrugations are not acceptable.

1.3 If no specific instructions regarding the shape is given in the drawings, bend the pipes, provide the dimensions and relative position of parts as per the standards, made in ~~situ~~ situ.

1.4 Connect the pipe lines to fittings by brazing with solder ~~in case~~ J163 GOST 15527-70, in this case:

1.4.1 The ~~brazed~~ brazed joints should be air tight when tested by air at ~~pressure specified in the drawings~~ pressure, P_{test}, specified in the drawing.

1.4.2 Lack of solder penetration of the joint (poor filling of the joint with solder) in the lower section of the joint should not exceed 50% of the lap.

1-4-3 Clustered porosity and lack of fusion (lack of joint between base metal and solder) are not allowed.

1.4.4 Other requirements are as per OST 3-3619-77.

1.5 It is permitted to weld the pipelines to fittings as per GOST 16037-80-H1-r-Δ2, in this case:

1.5.1 The welds should be solid and of uneven section, ensuring air tightness when tested by air at pressure P_{test} specified in the drawing.

1.6 After welding or brazing of parts, having thread, calibrate the thread.

1.7 After welding the pipeline wash them inside with ~~the~~ circulating gasoline solvent GOST 3134-78 at a flow of atleast 2 liters through the pipeline.

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1.8 Primer ФЛ-03К and blue enamel ПФ223 GOST 14923-78 are used for ~~surfaces and varnish~~ coating the external surfaces and varnish ГФ95 GOST 8018-70 for internal surfaces as per instructions НЛ-09-73.

1.8.1 Paint and varnish coatings on the threaded surfaces and surfaces to be sealed are not allowed.

1.8.2 Partial or complete lack of paint and varnish coating is allowed on the nipples under and on the coupling nuts.

2. Quality inspection.

2.1 After the welding, test all the pipes for air tightness in a water ~~batch~~ bath with air at pressure P test as specified in the drawing.

2.2 After completion of washing as per item 1-7 and varnishing, subject 5% of pipes (but not less than 2pieces) from each batch to test washing with gasoline-solvent GOST 3134-78, for this ~~purpose~~ purpose drain the gasoline-solvent from the pipeline through filter paper GOST12026-76, which should not reveal any traces of contamination, visible to the naked eye.

2.3 In case of unsatisfactory results obtained during the test mashing, the whole batch of pipes is subjected to repeated mashing.

3. Transportation and Storage

3.1 Seal the pipe ends with auxiliary plugs during transportation and storage.

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