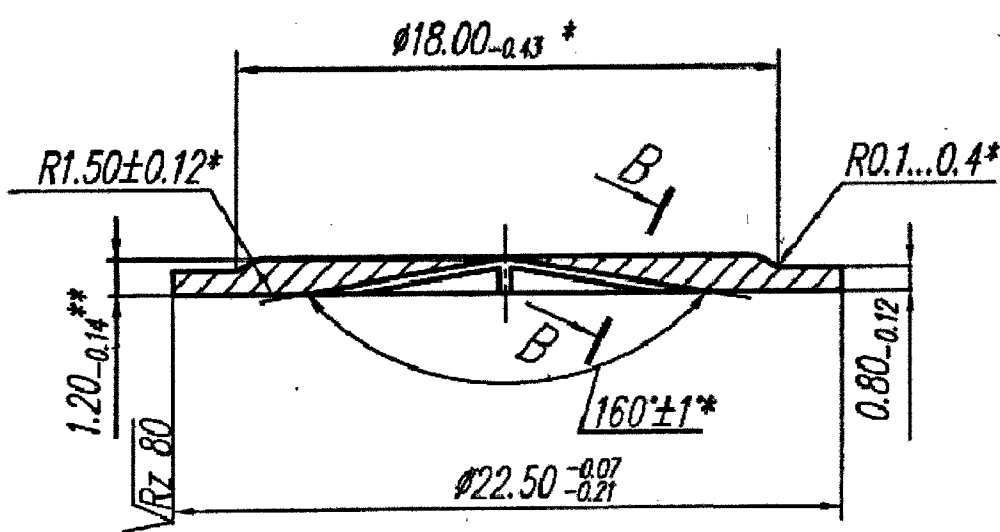
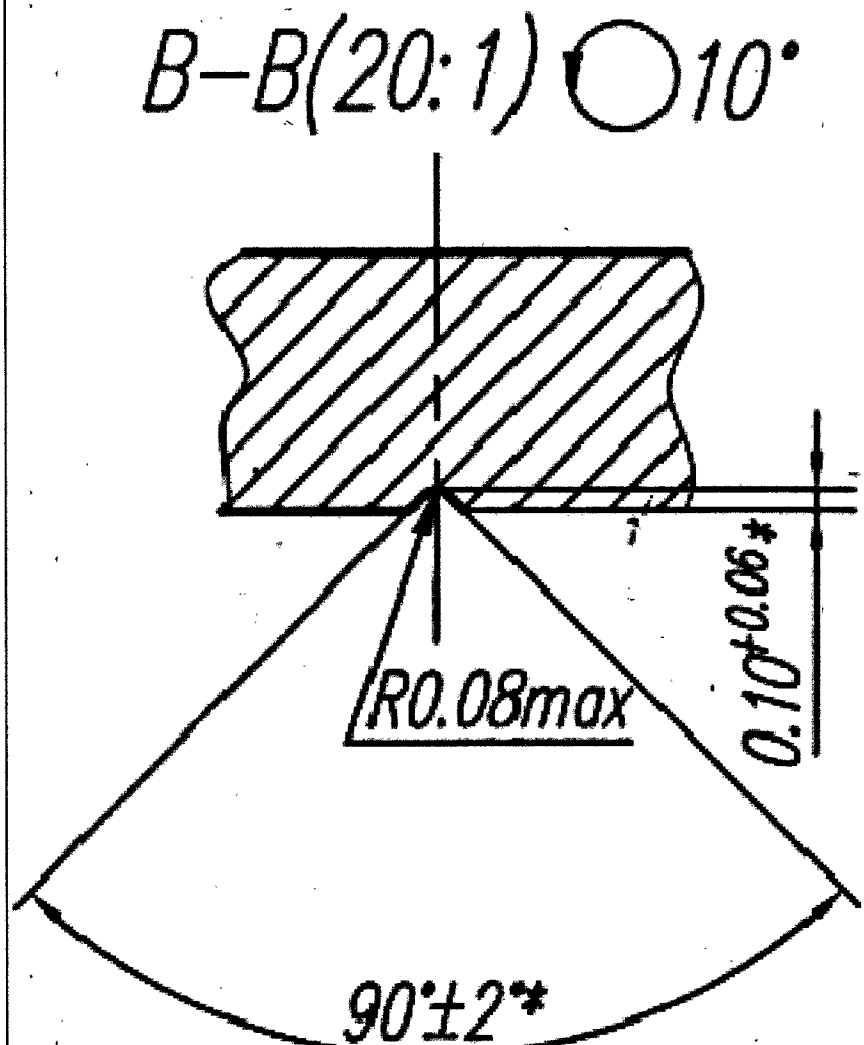
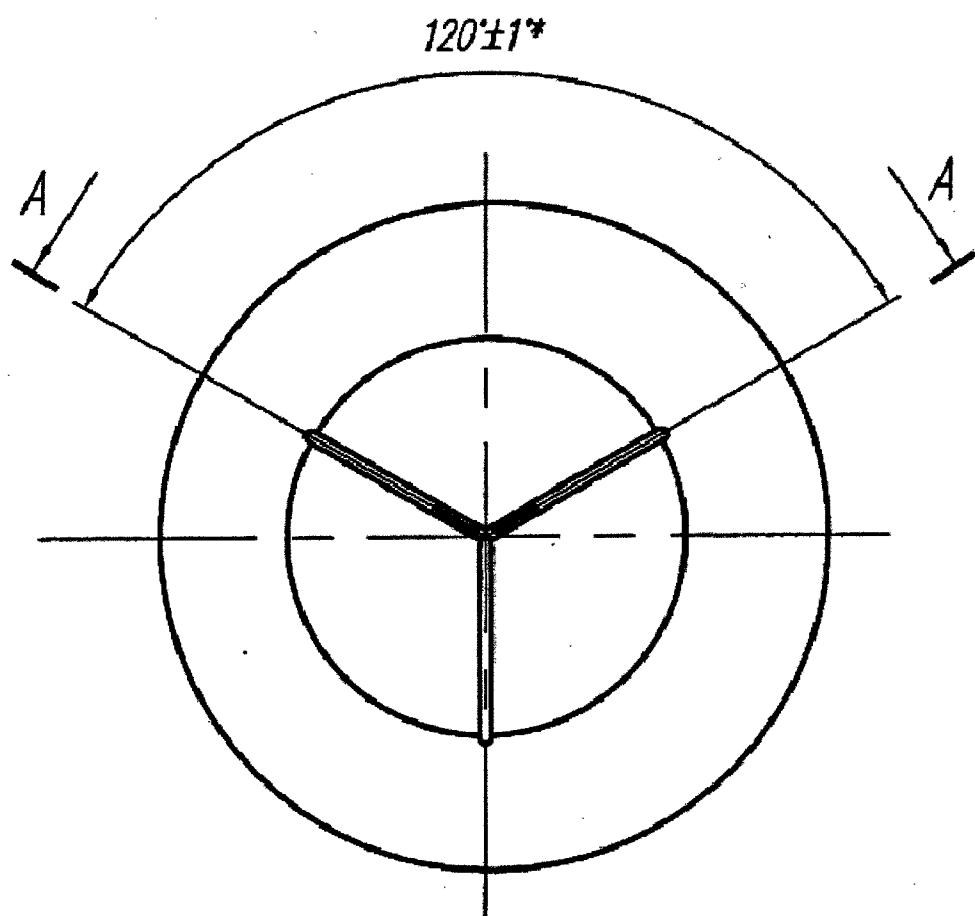


→ IS: 14811-2000 in "O" Condition, Chemical Composition as per IS: 191-2007 Grade Cu FRTP-2 (Ref. CQA(Mat.)/QA-2/T-72/FSAPDS/Mango. Vol.12 dated 29.07.01).  
 → Shellac Based APC to Specification JSS 8010-63:2016 Rev.No.4 (Ref. CQA(ME)/T200/Gen(PC)/125mm FSAPDS/02 Dt. 05.04.2021

√Rz40(√)



Varnish BЛ-7-4 is intended for varnishing of parts and products; varnish BЛ-7-5 - for varnishing, sealing and glueing of parts and products.

Operating temperature of varnish coatings: from minus 60 to plus 80 °C - unlimited in time; at plus 150 °C - for 5 hours.

Phenol-polyvinylacetyl varnishes are a flammable, non-explosive material. Ethyl alcohol is inflammable liquid: maximum allowable concentration (MAC (ГДК)) in production floor area working air - 1000 mg/m<sup>3</sup>; flash-point - plus 13 °C. The shelf life of the varnish is 6 months after the manufacture date.

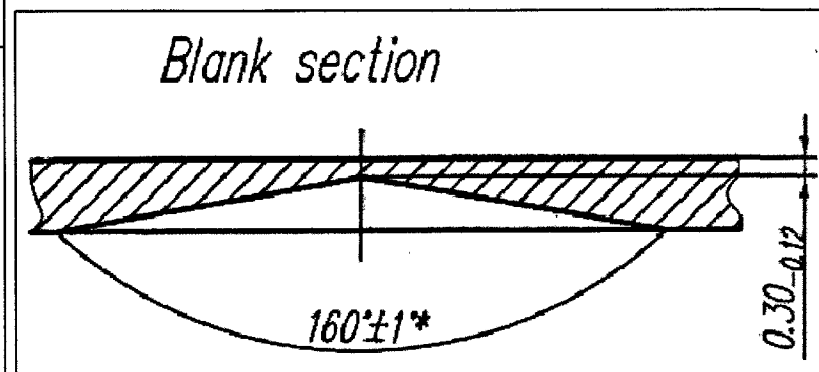
- 1 Anneal at the temperature of 500 to 600 °C
- 2\* Dimensions are provided by the measuring instruments.
- 3\*\* Reference dimensions.
- 4 Coating 06/ varnish BЛ-7-5 colored with rhodamine Ж TU 6-14-1058-79.

- 5 The following is allowed:
  - a) sheet ДПРМ 1,20 М1 or ДПРМ 1,20 М2 GOST 1173-2006;
  - b) tape ДПРМ 1,20 НД М1, ДПРМ 1,20 НД М2 or ДПРМ 1,20 НД М3 GOST 1173-2006;
  - c) bulging on the upper butt end up to 0.3 mm;
  - d) nonuniform color of varnished parts;
  - e) rhodamine "C" TU 6-14-1088-74 or any other neutral dye;
  - f) varnish BЛ-7-4 and varnish ЛШ-15 or ЛШ-20 OST 84 811-2002;
  - g) when manufacturing the part by die forming, change the material thickness at the discretion of the manufacturer.
- 6 The part shall have no cracks, scabs, cavities, holes, deep pot holes, scratches, unevenness.
- 7 Characteristics of special-purpose phenol-polyvinylacetyl varnishes:

Special-purpose phenol-polyvinylacetyl varnishes are solution of glue БФ-4 in ethyl alcohol. The varnish is a transparent slightly cloudy homogeneous liquid of a light yellow to dark yellow color without mechanical impurities.

Varnishes BЛ-7-4, BЛ-7-5, where: BЛ - varnish designation by chemical composition (phenol-polyvinylacetyl varnish);

7 - varnish group of purpose;  
 4, 5 - weight ratio of dry phenol-polyvinylacetyl residue.



REV.		DATE	DESCRIPTION	SIGN.	MATERIAL: AS ABOVE		आर्डनैन्स फैक्टरी अम्बाझरी ORDNANCE FACTORY AMBAZHARI
AMENDMENTS					NOMENCLATURE: COVER		
DIMENSIONS ARE IN mm					M/C:		REVIEW NO: 0
THIRD ANGLE PROJECTION					STORE: PRIMER GUV7-M		SHEET NO: 1
SCALE - 1:1							NO. OF SHEETS: 1
2021	NAME	DATE					OPERATION NO:
DRAWN	Kush	16/8/21					COMPT:
CHECKED		16/8/21					
HOS/CDD							
VERIFIED BY	JWM/FS						
APPROVED BY	DGM/FS						