

				f de la							Bla	nk 832	
(<u>a</u>			Tech	nological			rt				Sł	neet 1	
				for heat tr	reatment	t					Sh	Sheets 5	
	Article		Component	No.	Nomen	clatur poner		N	/laterial g	ade		ight of 1p. kg.	
	AO - 18		01.028		Shut			Stee	l 25Kh17	N2B-Sh		0.01	
	Sketch of Cor JCA 43 DC			Sketch JCAUS	of Specimer	40							
			Hecmo Hopsupossu Place for marking		275	-		Set					
					Mode								
Oper. No.	Nomenclati of operatio		Equipment	t ⁰ C of heating	Time of heating, min.	С	ooling		xture (0772	No.of fixtures	co	No.of mp.on ixture	
		Get	familiar with safet	y instructio	on No.10	0 an	d 0504	2520	0000014	1			
	Compone	ents f	or heat treatment	should be	dispatch	ned i	n batch	nes d	of same	melting],		
2	48 compo	nent	s (not more than)) each for a	a batch. I	Each	batch	sho	uld be re	eceived	l fror	n	
			op with certificate								- 2	1. 	
			ould have followi								umb	er and	
	batch nur				<u>, </u>					0			
0030			rade of steel of co	omponents	and spe	cime	ens						
0040			onents and spec					n a ti	۹)		-		
0040		•	· · · · · · · · · · · · · · · · · · ·				cacirii		0)				
0050	-	ardening with tie Electric furnace 1100- 20 Oil 4050 2							-	<u>I</u>			
	1.Heating		cabinet	1120	30	4	40-80°	4050		2		96	
	2. Washing		Washing machine	70-100°			Air	LK 0741- 4145					
	3. Cold machining	Cold In liquid nitrogen or		not above –70°	20					1		48	
r.										i nel			
4							<u></u>						
σV		Technical condition for φ % ak, kgm/cm ²		Qty .and type of test		st	Depth carbu layer,			and te	e	Polishing	
kg/mn	n ²	7			cimen					%			
				Separable	Imp	bact							
			Remark										
					No	o.p/p	Reaso	n for	amendme	ent Sig	gn	Date	
5°1													
29													

				Tech	nological	process (Chart				Sheet	t 2	
					for heat tr						Sheet	ts 5	
	Arti	icle		Component	No.	Nomencl		of N	laterial gr	ade	Weight comp.		
L	10	- 18		01.028	3	Shutte		Stee	I 25Kh17	N2B-Sh	~ 0.0		
								Set					
)						Mode							
Oper. No.		omenclatu of operatio		Equipment	t⁰C of heating	Time of heating, min.	Cool		xture (0772	No.of fixtures	No.e comp fixtu	o.on	
			Get fa	amiliar with safe	ety instructio	n No.100	and C	504252	000014	1			
	Remark:												
	С	onduct t	empe	ering after cold r	machining, r	ng, not earlier than 2 hours of attainment o							
				components									
		lount dia		· · · · · · · · · · · · · · · · · · ·						10.00			
0060		emperir											
	H	eating		Saltpeter tank	250-320°	120	Wate	r, air 🛛 🗸	012	1	19	2	
											_		
-	-												
0070		emove	diagra	am			5					-	
0070 0080		ntying	n of to	empering mode	by BTK as	nor diagra	am						
0080	-			dro sandblastir			ann.					12.	
0095				aces meant for			comp	onents a	and spe	cimens.			
		leaning	<u>. p.c</u>										
	-												
			Те	chnical condition f	or test			Depth of	Hardness	Tes place			
σ V kg/mm	1 ²	δ%	φ%	ak, kgm/cm ²		type of test cimen	t	carburizing layer, mm	HRCE	and te		lishir	
					Separable	Impa	act						
									<u> </u>				
				Remark									
						No.	$p/p \mid R$	eason for	amename	ent Sig	n ID)ate	

		nological p for heat tro		ature of nent	Mater Steel 25k	al grad h17N2	e	Sheet 3 Sheets 5 Weight of comp. kg. 0.01
	Component N		Nomencla	nent			e	Weight of comp. kg.
	-	No.	compo	nent			e	comp. kg.
	01.028				Steel 25k	(h17N2		
					Set			
			Mode					
ure on	Equipment	t ⁰ C of heating	Time of heating, min.	Cooling	Fixture LK0772		lo. of ctures	No. of comp. on fixture
Get f	amiliar with safet	ty instructio	n No.100	and 050	4252000	0014		
f tech ch of 4 ion of g of st n ca meta	ardness of componical inspection 48 pcs for testing certificate after p tamp "I" on tag se of unsatisfact llurgical engineer	dispatches g impact vis positive cor ory results r are obtain	2 specim cosity (4 s nclusion o of impact ned then e	ens to O specimer f OGMet viscosity ither rep	GMet ns remain as per th eat impac	in sho nose s	op) pecifie osity te	est
			type of test	carb	th of urizing r, mm	dness C _E	Test place and test	Polishing
φ /0	not less than 4	sper Separable	cimen Impa		45.			
L	Remark:		No.;)/p Reas	on for ame	ndment	t Sign	Date
		4	4 Separable	Remark:	Remark:	4 Separable Impact 45. 51. 51.	4 Separable Impact 45.5 8 51.5 51.5	4 Separable Impact 45.5 51.5 A and B 100% Remark:

											Blank 832/2 Sheet 4	
'n			Тес	hnological p for heat tr		nart						
				for near th	Nomenclat	ture of	1				heets 5 eight of	
	Article		Componen	t No.	compor		N	<i>I</i> aterial	grade	со	mp. kg.	
ŀ	AO - 18		01.02	8	Shutter		Stee	el 25Kh1	7N2B-Sh	n ~	0.015	
			¢35,8	h+++++++++++++++++++++++++++++++++++++								
							Set					
					Mode							
Oper. No.	Nomenclatu of operation		Equipment	t ⁰ C of heating	Time of heating, min.	Cooling	oling Fix		No. of fixture		No. of omp. on fixture	
	Get familia	ar with	safety instruct	ion No.100 a		200000	14					
0.1.10				and atmans offer								
0143	Tempering	tor re	moval of inter	nai stress afte	er grinaing.							
			Electric furnace	440,4000	0.0	٨١٣	- De	akat			48	
	Heating		cabinet	140-160°	6.0-	Air	Da	Basket			40	
	이 아이는 것은 것은 것을 알려야 한다. 것을 가지 않는 것을 알려야 한다.			이 집에 관계하는 것 같이 많이 많이 했다.	6.5							
					1				1			
	Inspection	of ten	npering mode	by BTK								
				and the second second								
			npering mode tempering not	and the second second	hours from	ı start o	f opera	ation 0	130			
	Time of st	arting	tempering not	later than 24			f opera	ation 0	130			
	Time of st	arting t	tempering not grinding of fac	later than 24 es (operation	0130) and		fopera	ation 0	130			
	Time of st	arting t	tempering not	later than 24 es (operation	0130) and		fopera	ation 0	130			
	Time of st	arting t	tempering not grinding of fac	later than 24 es (operation	0130) and		fopera	ation 0	130			
	Time of st	arting t	tempering not grinding of fac	later than 24 es (operation	0130) and		fopera	ation 0	130			
	Time of st	arting t	tempering not grinding of fac	later than 24 es (operation	0130) and		fopera	ation 0	130			
	Time of st	arting t me of <u>c</u> tempe	tempering not grinding of fac ering should be	later than 24 es (operation e specified in	0130) and	time of				Test		
	Time of sta Starting tir starting of	arting t me of <u>c</u> tempe	tempering not grinding of fac ering should be	later than 24 es (operation e specified in for test	0130) and certificate	time of	pth of burizing	Hardne	155 I	olace	Polishin	
σV kg/mn	Time of sta Starting tir starting of	arting t me of <u>c</u> tempe	tempering not grinding of fac ering should be	later than 24 es (operation e specified in	0130) and certificate	time of	pth of		155 I		Polishin	
σV kg/mn	Time of sta Starting tir starting of	arting t me of <u>c</u> tempe	tempering not grinding of fac ering should be	later than 24 es (operation e specified in for test	0130) and certificate	time of	pth of burizing	Hardne	155 I	olace nd test	Polishin	
σ V kg/mn	Time of sta Starting tir starting of	arting t me of <u>c</u> tempe	tempering not grinding of fac ering should be	later than 24 es (operation e specified in for test Qty .and type	0130) and certificate of test specir	time of	pth of burizing	Hardne	155 I	olace nd test	Polishin	
σV kg/mn	Time of sta Starting tir starting of	arting t me of <u>c</u> tempe	tempering not grinding of fac ering should be	later than 24 es (operation e specified in for test Qty .and type	0130) and certificate of test specir	time of	pth of burizing	Hardne	155 I	olace nd test	Polishin	
σV kg/mn	Time of sta Starting tir starting of	arting t me of <u>c</u> tempe	tempering not grinding of fac ering should be	later than 24 es (operation e specified in for test Qty .and type	0130) and certificate of test specir	time of	pth of burizing	Hardne	155 I	olace nd test	Polishin	
σ V kg/mn	Time of stating tir Starting tir starting of	arting t me of <u>c</u> tempe	tempering not grinding of fac ering should be	later than 24 es (operation e specified in for test Qty .and type	0130) and certificate of test specir	time of	pth of burizing	Hardne	155 I	olace nd test	Polishin	
kg/mn	Time of stating tir Starting tir starting of	arting t me of <u>c</u> tempe	tempering not grinding of fac ering should be	later than 24 es (operation e specified in for test Qty .and type	0130) and certificate of test specir	time of	pth of burizing	Hardne	155 I	olace nd test	Polishin	
kg/mn	Time of stating tir Starting tir starting of	arting t me of <u>c</u> tempe	tempering not grinding of fac ering should be	later than 24 es (operation e specified in for test Qty .and type	0130) and certificate of test specir	time of De can nen lay	pth of burizing er, mm	Hardne	ISS ar	olace nd test	Polishin	

	a.												nk 832
8				Тес	chnological I		har	t			eet 5		
				s	for heat tr					к х			ets 5
	Artic	cle		Componen	t No.	Nomencla compo			Ma	terial gr	ade		jht of 5. kg.
ŀ	40 -	18		01.02	8	Shutte			Steel 2	25Kh17I	V2B-Sh		0008
				Ø 35,8	**								
					2				Set				
						Mode							
Oper. No.	of	menclatu f operatio	n	Equipment	t ⁰ C of heating	Time of heating, min.		oling	Fixtu LK07		No. of fixtures	con	o. of np. on cture
10 J.	Ge	et familia	ar with	safety instruct	ion No.100 a	nd 050425	200	0001	4				
04.40	Ta				a al atraa afte								
0143	Ie	mpering	g for re	emoval of interr	hal stress afte	er turning							
				Electric furnace	440,4000	0.0		۸ :	Deel				40
	Не	ating	<u>, 1</u> 97	cabinet	140-160°	6.0-		Air	Basl	kei			48
						6.5			- 			-	
<u> </u>			1.1.										
	Ins	spection	ofter	npering mode	by BTK								
		poonor		inporting mode	<i>b</i> j b i x		-						
	Tir	ne of st	arting	tempering not	later than 24	hours from	n sta	art of	turning	(opera	ation 01	50)	
				operation 0150		oortificato		2					
	Sta	arting of	temp	ering should be	e specilied in	centificate					• • • •		
							1. 1						
$\sigma V = \sigma V$			Те <i>ф</i> %	chnical condition ak, kgm/cm ²	for test Qty .and type	of tost speci	mon	- carbu	pth of Hardness plac burizing HRC _E and t		est F	Polishing	
kg/mm	1 ²	δ%	φ. 70	ak, kyni/chi			men				%		
					Separable	Impa	ct						
i de la composición de			2					1					
													(
Remar	۴:										R C		
						No.p	/p	Reaso	n for am	endmei	nt Sig	n	Date
		<u> </u>					·						
33									1. N.				
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