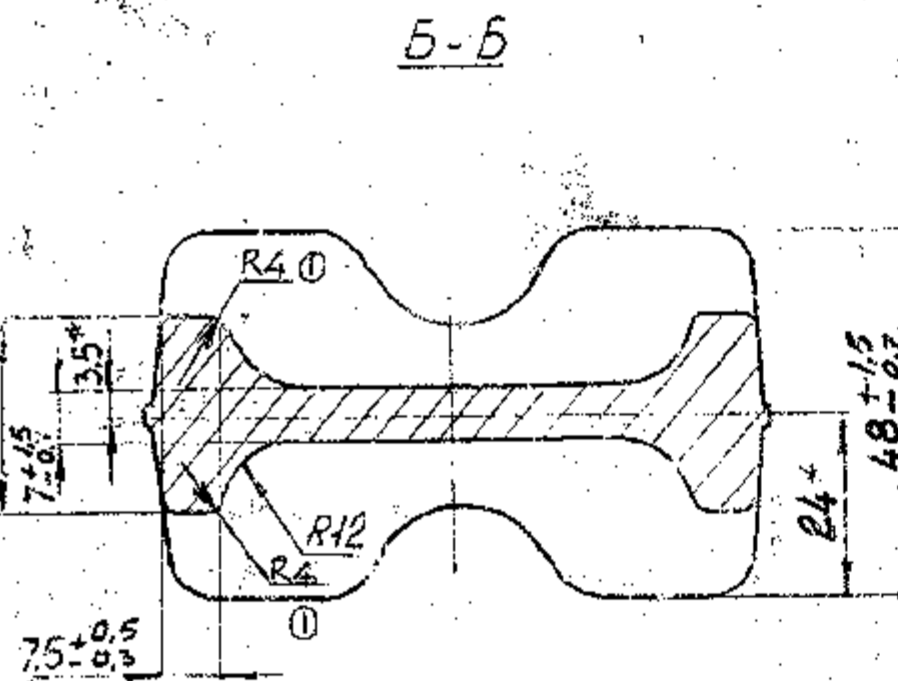
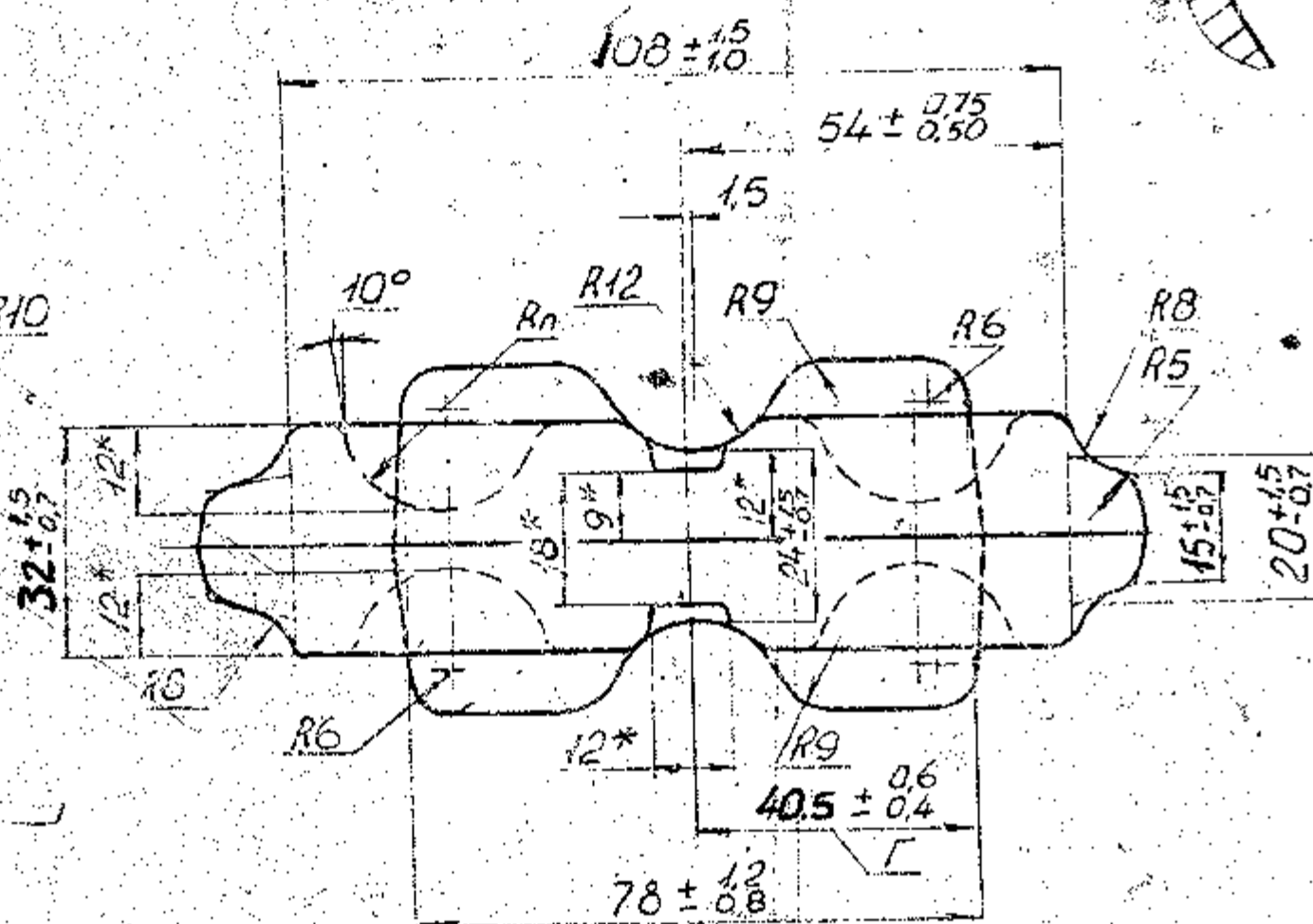
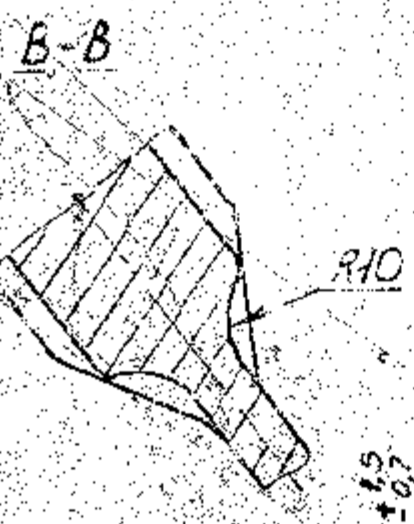
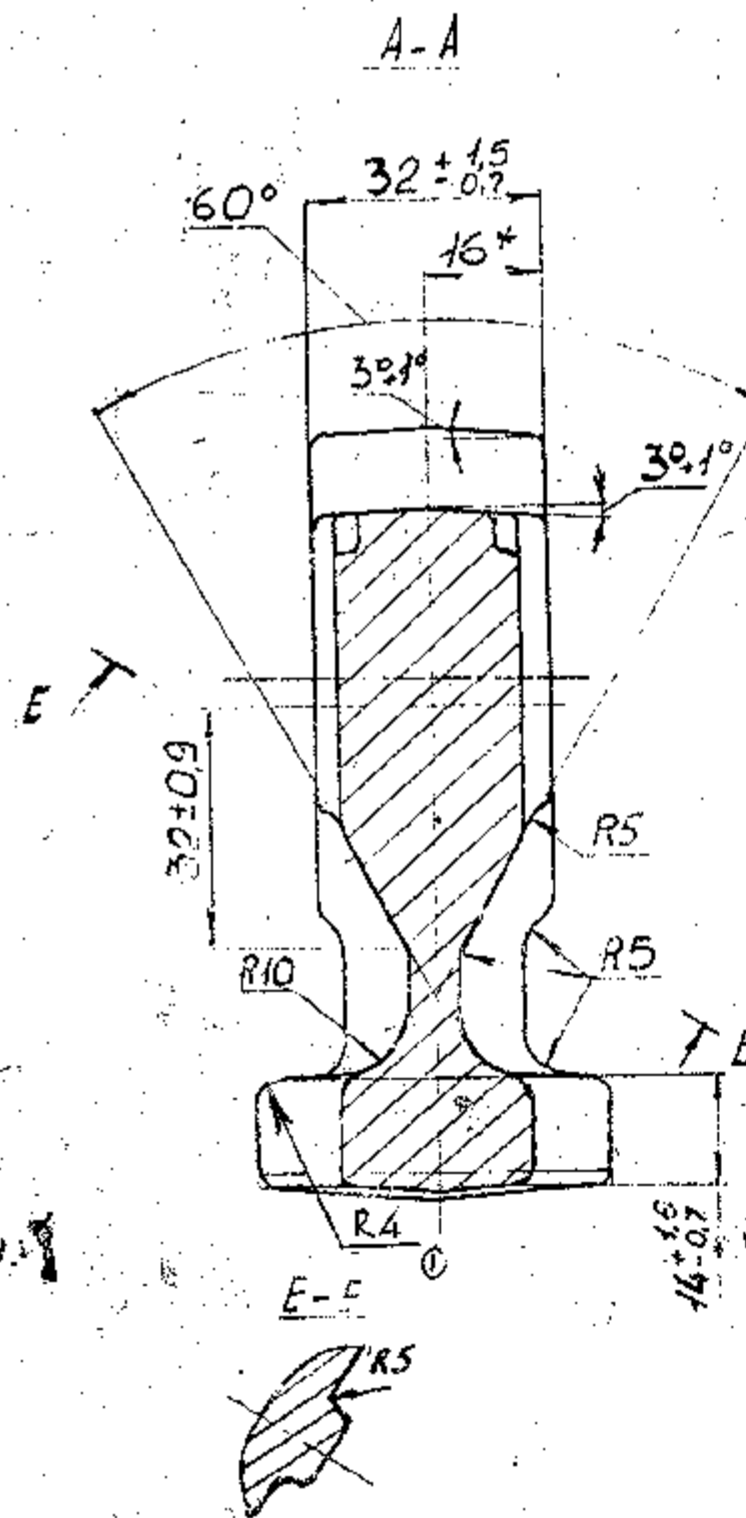
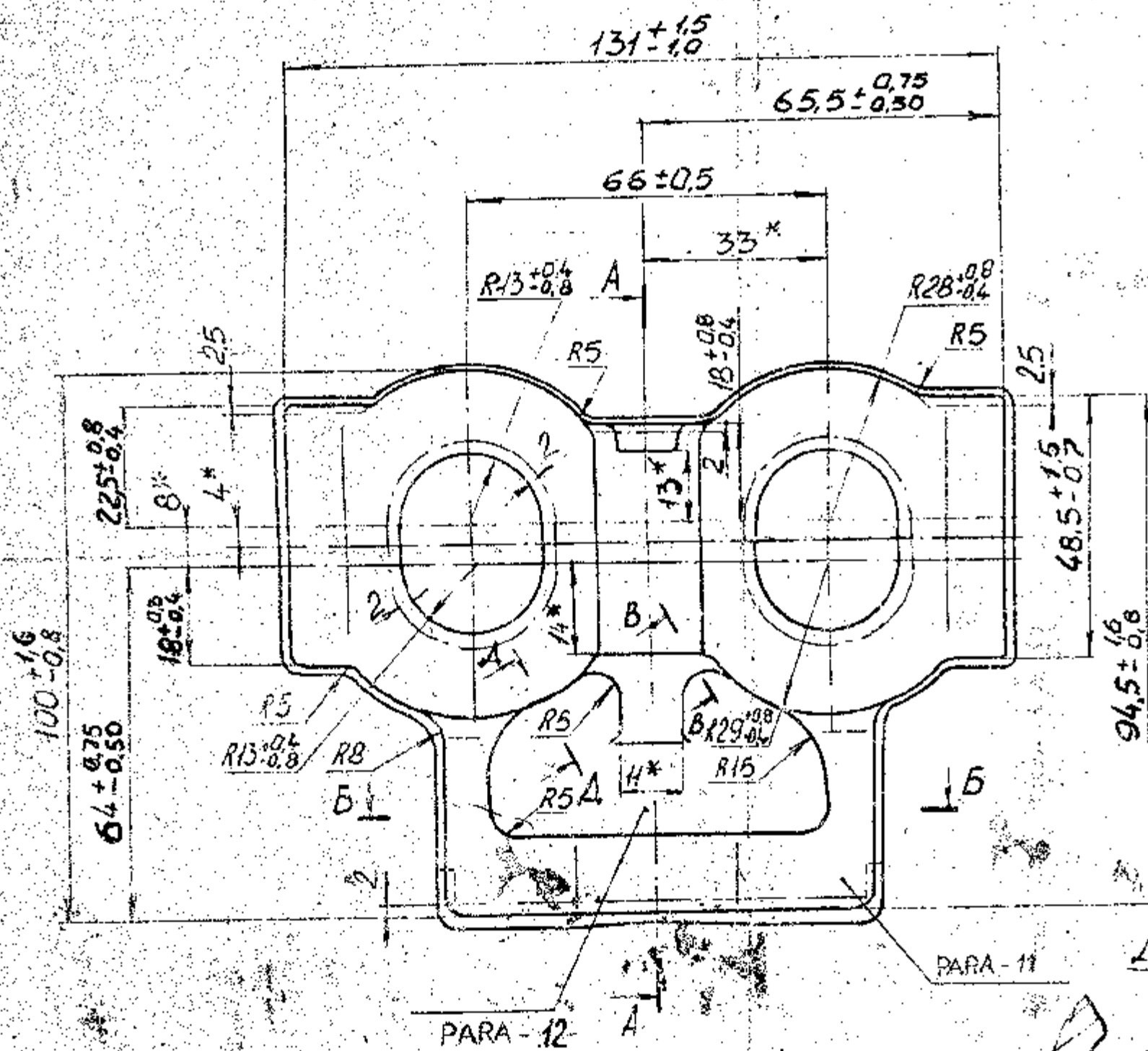


17-90-02
07-90-02



- HARDENING AND AGEING HB 10/1000 ≥ 90 ($\sigma_{min} < 3.7$).
- UNSPECIFIED DRAFTS 5° TO 7° .
- ROUNDING OFF UNSPECIFIED RADII R 3 MM.
- * DIMENSIONS ARE TO BE ENSURED BY TOOLS.
- UNFILLING OF CORNERS SHOULD BE WITHIN 0.5 OF ACTUAL ALLOWANCE AT MACHINED SURFACES AND AT UNMACHINED SURFACES WITH IN TOLERANCE.
- NON FLATNESS NOT TO EXCEED 0.65 MM.
- SHIFT ALONG PARTING DIE LINE SHOULD NOT EXCEED 0.7 MM.
- BURR ALONG PERIMETER OF THE CUTTING ON SURFACES OF MACHINING SHOULD NOT EXCEED 2 MM, ON UNMACHINED SURFACES NOT TO EXCEED 1 MM.
- SEPARATE BLISTERS AS WELL AS DARK AND WHITE SPOTS AND STRIPS WITHOUT ROUGHNESS AND TEMPER COLOURS ARE ALLOWED ON MACHINED SURFACES LOCAL SURFACE ROUGHNESS WITH GRAPHITE TRACES OF DEPTH NOT EXCEEDING 1MM AND SPOT GRAPHITE INCLUSIONS ARE ALLOWED OCCASIONAL MINOR DEFECTS IN BASIC MATERIAL WITH IN THE REQUIREMENTS OF SPECIFICATION FOR SUPPLIED MATERIAL ARE ALLOWED ON UNMACHINED SURFACES.
- OXIDE SPOTS, BLISTERS, CAVITIES, SYMPTOMS OF SEGREGATION, POROSITY, DIRTS, SHRINKAGES, DENTS, FISSURES, NICKS AND OTHER MECHANICAL FAILURES NOT EXCEEDING 0.5 OF ACTUAL ALLOWANCE IN DEPTH ARE ALLOWED ON MACHINED SURFACES.
- MARK FIGURE "4" ON THE SIDE OF DIMENSION "C".
- MARK THE GRADE OF MATERIAL AS PER GOST 2171-13, TYPES 10-10 GOST 2930-62. MARKING BY PUNCHING IS ALLOWED. TYPE 10-5 GOST 2930-62.
- FORGINGS ARE TO BE PICKLED.
- OTHER REQUIREMENTS AS PER CTD 264-71.

SK/U/0604000/Forging
SK/U/0604100/Forging

ISSUE	DATE	REFERENCE	
1		931-84	20-06-40; 20-06-41
APPROVED			CAP AND MAIN BEARING
CHECKED			(FORGING)
DRAWN			AI GOST 4784-74
PREPARED			ENGINE FACTORY AVADI