

$$X = \frac{m_0}{m} 100,$$

Where X = Content of residue after heating, %;
m₀ - Weight of seal after drying, gm,
m - Weight of seal before drying, gm.

For the test result take mean value of the results of two parallel determinations.

4.5. Test on operating pressure.

4.5.1. Equipment.

Dead weight pressure gauge tester МП -600 of gauge pressure as per GOST 8291-69;

Standard pressure gauge upto 25 MPa as per GOST 6521-72;

Potential meter ППР-4.05 as per GOST 7164-78;

~~Thermo couple~~ XA
Electric heater in 1000 W;

Glass thermometer as per GOST 2045-71;

Flange joint (appendix 2);

Dynamometric wrench ДК-25 as per specifications

105-6-01-0081-74.

4.5.2. Test

Liquid seal of grade ГМЖК-244 should be applied on both adjacent surface of flange joint and should be held for 3-5 minutes.

Flange joints with bolts should be tightened with dynamometric wrench ДК-25 with torque (50±1) N.m. Test for operating pressure should be carried out on stand (appendix 3) at temperature (20±5), (80±5), 150±5 °C. When heating flange joints up to the required temperature using hydraulic press

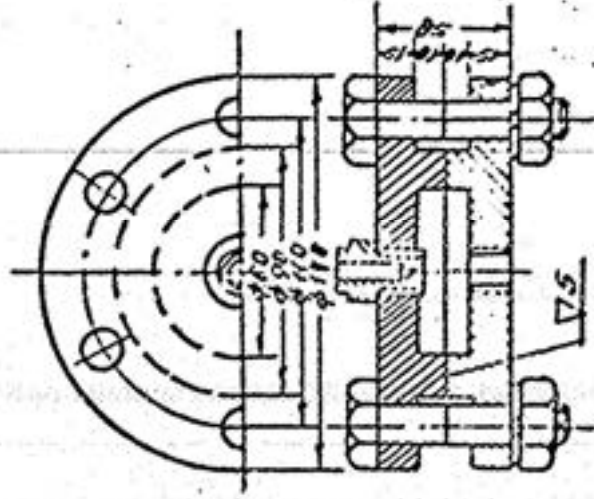
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Appendix 2 for specification
TY 6-05-251-80-82, obligatory.



3a) Фланцевое соединение

Flange joint.

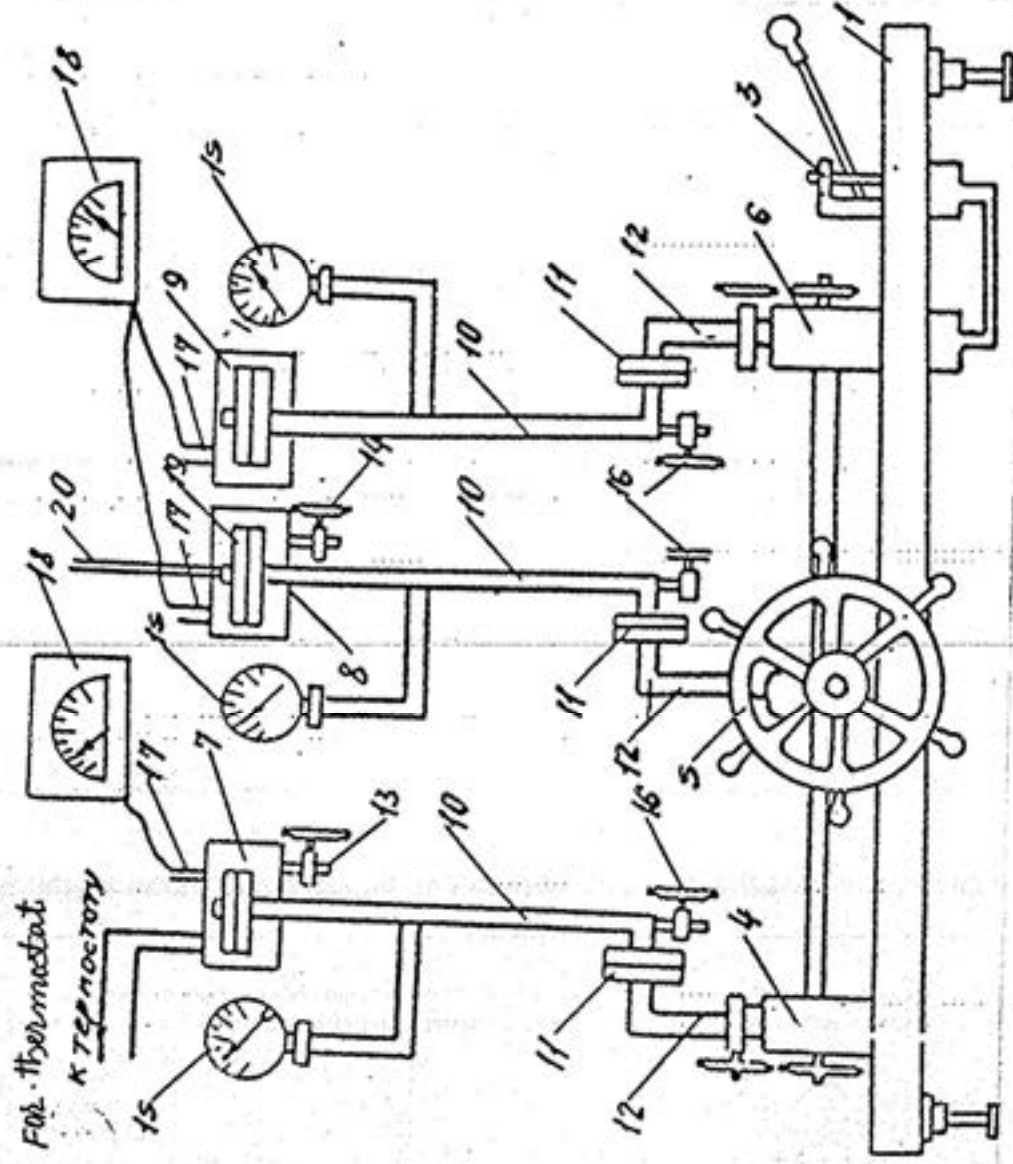
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Installation for testing liquid
seal of grade ГИП К-244.



1 - Pressure gauge of gauge pressure
МП-600

2 - Hand wheel

3 - Plunger pump

4, 5, 6 - Stand

7, 8, 9 - Electric heater

10 - Connecting tube

11 - Membrane

12 - auxiliary tube

13, 14, 16 - Drain cock.

15 - Standard pressure gauge

17 - Thermo couple

18 - Potentiometer

19 - Flange joint

20 - Glass thermometer.

Appendix 4

List of standard technical documents referred in the text of present specifications.

GOST 380-71	Carbon steel of ordinary quality.
GOST 2768-79	Commercial acetone
TYG -531.639-78	Laboratory electric desiccator
GOST 7148-70	Weighing bottles
GOST 24104-80E	General purpose and standard physical balance
GOST 6371+75	Desiccators
TY 6-19-110-78	Polyethylene covers
GOST 2991-76	Inseparable card board boxes for load with weight upto 500 kg. <i>products of chemical industry</i>
GOST 18573-78	Flask cans for paints and varnish materials.
GOST 5799-78	
GOST 6128-81	Metallic cans/jars for chemical products.
GOST 14192-77	Marking of weights
(CT CЭB257-80)	
GOST 8291-69	Piston pressure gauge
GOST 6521-72	Standard deformation pressure and vacuum gauges with specified scales.
GOST 7164-78	Self balancing servo instruments of GSP
GOST 2045-71	Glass mercury thermometer
TY 105-6-01-0081-74	Dynamometric wrench.
GOST 20799-75	Industrial oil for general purpose
GOST 2084-77	Petrol
GOST 1667-68	Motor fuel for medium and low speed diesel engines.

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L I S T

of materials included in the composition of liquid seal of grade ГВП. К - 244.

Material

Existing standard technical document.

- | | |
|--|-------------------|
| 1. Carboxyl containing butadiene acrylonitrile rubber CKH-26-1 A | TY 38-10316-76 |
| 2. Phenyl glycide ether | TY 6-09-08-715-75 |
| 3. Suspended polyvinyl-chloride of grade PVC - C 70 | GOST 14332-69 |
| 4. Polyvinyl butyral | GOST 9439-73 |
| 5. Processed kaoline for chemical industry. | GOST 19607-74 |
| 6. Dibutyl phthalate | GOST 8728-77E |

NOTIFICATION NO. 1

on the amendment for specifications

TY 6-05-251-80-83

LIQUID SEAL FOR SEALING DETACHABLE

CONCRETE JOINTS

Grade ГИП K-244

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NOTIFICATION NO. 2

about the amendment for specifications

TY 6-05-251-80-83

LIQUID SEAL FOR SEALING DETACHABLE JOINTS

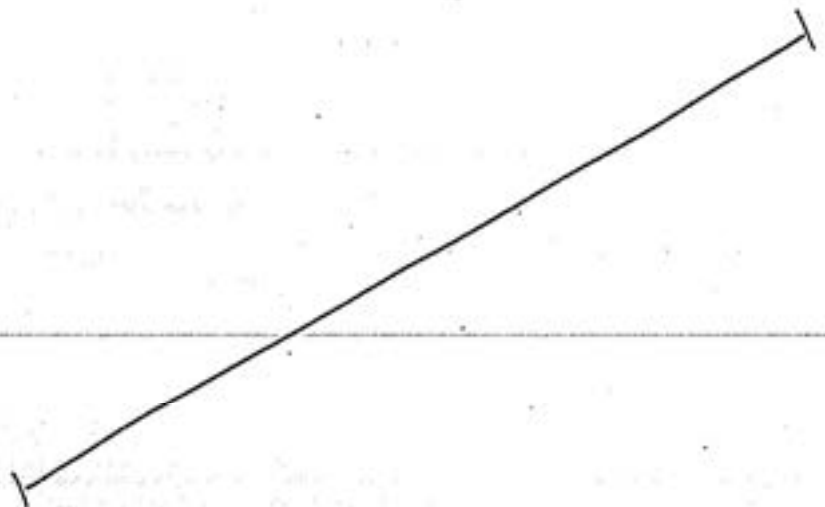
Grade ГИП. К - 244

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									TY 6-05-251-80-83

Section 7, para 7.4 should be given in the new edition : " Manufacturing plant guarantys the stability of liquid seal of grade ГВП К-244 in the machine oil of grade "C" at a temperature $(100 \pm 2)^{\circ}\text{C}$, diesel oil as per GOST 1667-68 and in water and in petrol of grade А-72 as per GOST 2084-77 for 24 hrs.

In this case loss in the oil should be (max) as follows:

In the machine oil	-	5.0 %
In the diesel oil	-	5.0 %
In the water	-	1.5 %
In the petrol	-	5.0 %



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AMENDMENT NO. 3

For specifications TY 6-05-251-80-83

LIQUID SEAL FOR SEALING
DETACHABLE JOINTS

Grade Г И П К-244

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Amendment No 3 TY 6-05-251-80-83

Set duration of specifications Ty 6-05-251-80-83 without its restriction Section 1. Para 1.2, Para 4 of the table. Amend the name of the characteristic to "Fraction of total mass of non volatila matter ".

Section 4. Para 4.3.1. 6th short line.

Reference GOST No: GOST 2768-79 is changed to GOST 2768-84.

Section 4. Para 4.4. The following should ^{be} given in the new wordings.

" Determination of fraction of total mass of non-volatile metter. "

Para 4.4.1. Second short line. Reference No if the specification TY 6-531-639-78 is changed to specifications TY 16-531. 639-78.

Para 4.4.1. Fourth short line, Reference on GOST-No¹⁰ GOST 7148-70 is changed to GOST 23932-79E.

Para 4.4.1. Sixth short line Reference on GOST 6371-75 is changed to GOST 23932-79E.

Para 4.4.3. - Second short line is given in the following wordings "Fraction of total mass of non valatile matters are calculated as per the following formula ".

Para 4.4.3. Fourth short line is given in the following wordings.

" Fraction of total mass of nonvolatile matters, % "

Para 4.5.1. Third line Reference on GOST No. GOST 8291-69 in changed to GOST 8291-83.

Section 5 para 5.1.3. Third line. Reference on GOST NO. 2991-76 is changed to GOST 2991-85.

Sheet 15. Appendix 4.

Change the given references in the standard technical documents as follows.

GOST 2768-79 to GOST 2768-84;

TY 6-531.639-78 to TY 16-531.639-78;

GOST 7148-70 to GOST 23932-79E;

GOST 6371-75 to GOST 23932-79E;

GOST 2291-76 to GOST 2991-85;

GOST 8291-69 to GOST 8291-83

Sheet 16 Appendix 5. Amend the following references in the standard Technical Document.

GOST 14332-69 to GOST 14332-78;

GOST 9439-73 to GOST 9439-85;

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14/11/90

LIQUID SEAL FOR SEALING DETACHABLE

JOINTS GRADE ГПНК-244

SPECIFICATIONS

TY 6-05-251-80- 83

(Instead of TY 6-05-251-80-78)

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Translated by	Authenticated by	ARMOURD VEHICLE PROJECT AYADI
SUSSELA - KUMARI.K		
Date	Compiled by	SPECIFICATION No. TY 6-05-251-80-83
26-12-90	SG/D.K.SHARAN	
		Page No. 1 of 2.5
		Approved by <i>[Signature]</i>

Para-meters	Standard	Test procedure
(1)	ГНПК-244 (2)	(3)

1. External appearance Uniform viscous mass without mechanical impurities of brown to dark-brown colour. As per para 4.1.

2. Viscosity, as per viscosimeter, Bruklilda, at $(50 \pm 2)^\circ\text{C}$, Pa in range 100-170 As per para 4.2.

3. Flow at $(20 \pm 2)^\circ\text{C}$, mm, max 15 As per para 4.3.

4. Residue after holding at 100°C , to mass, min.

a) for 1 hr. 99.2 As per para 4.4.

b) upto fixed weight. 99.0

5. Operating pressure, MPa, min. As per para 4.5.

a) At temperature $(20 \pm 2)^\circ\text{C}$ 15.0

b) At temperature $(80 \pm 5)^\circ\text{C}$ 10.0

c) At temperature $(150 \pm 5)^\circ\text{C}$ 8.0

NOTE: 1. Upon agreement with the consumer, seal may be manufactured with low viscosity 10-90 Pa.Sec. and with flow not more than 20 mm.

2. Parameters as per para 5 is optional.

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