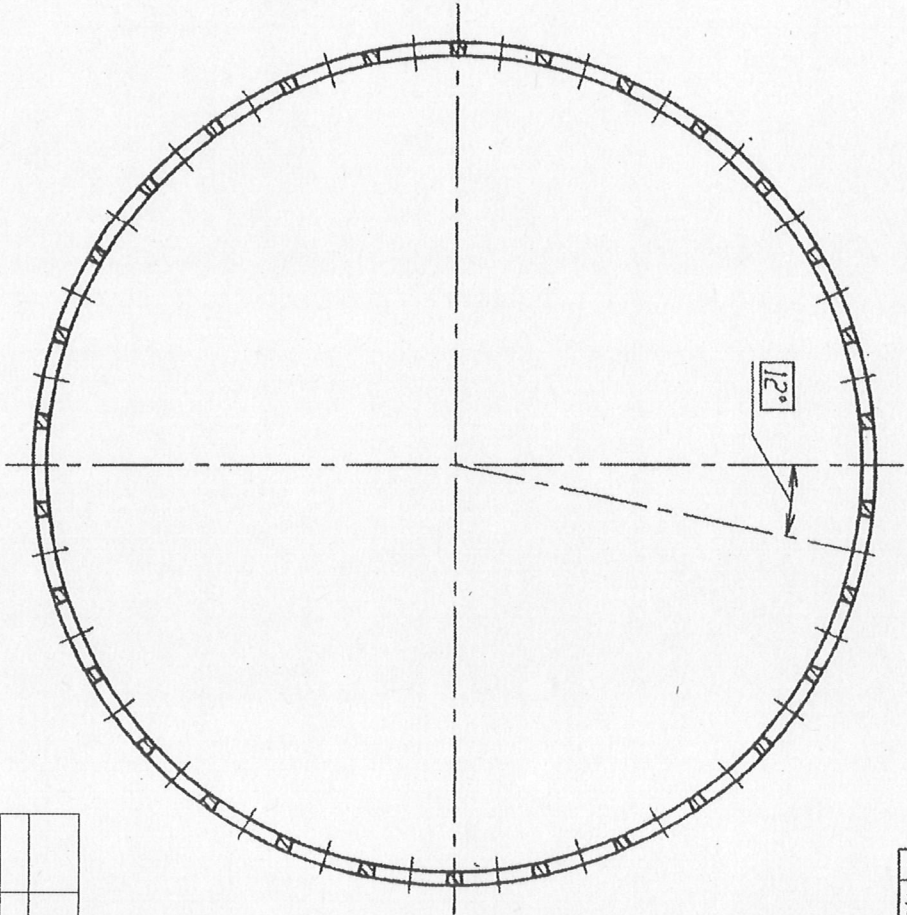


AO - 18.01.034

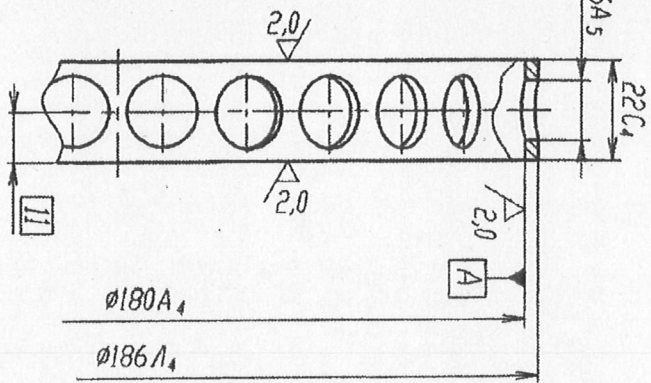
Reference No.	First use
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Orig. inv. no.	Sign and Date	Alternate Inv. No	Duplicate Inv. No	Sign and Date
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1. 34. 40.5 HRC<sub>e</sub>. Check hardness on 3-5% of the batch, but not less than 3 nos.
2. Blunt edges R~0.6 mm.
3. Coating Cd 9, phos. Cr-Oil.
4. Stamp K, N on batch tag.

+0.3 A  
30 holes  
30 OTB Ø16A5



RZ20  
A (M)

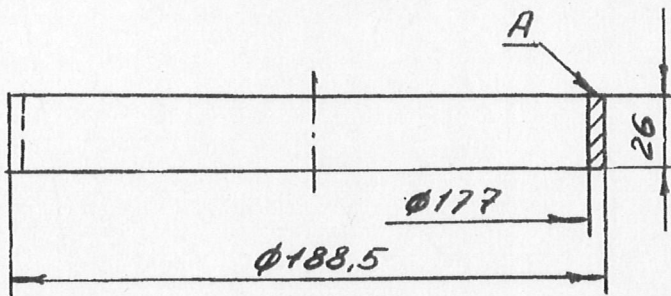
				AO - 18.01.34			
Armen.	Sheet	Doc. No.	Sign	Date	Spacer ring		
Developed by							
Checked by							
Head of Q.C.D							
Approved by					Pipe 194x25GOST8732 - 78 V30KMGSA GOST8731 - 87		
		Type	Weight	Scale			
		O <sub>2</sub>	1.19	1:1			
		Sheet	Sheets 1				

**Technological process Chart  
for heat treatment**

**Sheet 1**

**Sheets 2**

Article	Component No.	Nomenclature of component	Material grade	Weight of comp. kg.
AO - 18	01.034	Thrust ring	30KhGSA	~ 0.6



Set	
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Oper. No.	Nomenclature of operation	Equipment	Mode					
			t°C of heating	Time of heating, min.	Cooling	Fixture LK0772	No. of fixtures	No. of comp. on fixture
Get familiar with safety instruction No.100 and 05042520000014								
0040	Checking of grade of steel with steel scope							
0050	Hardening							
	Heating	Special electric furnace	500-600°	15	Shift to salt tank	4033	3	2
	Heating	Salt tank	870-890°	5	Saltpeter	4033	1	2
	Cooling	Saltpeter tank	180-200°	30	Water, air	4033	3	2
0060	Tempering							
	1. Heating	Electric furnace cabinet	480-550°	60	Water, air	4066	2	12
0070	Cleaning of places meant for checking of hardness							
0080	Checking of hardness							
0130	Preparation of accompanying documents							
	Machining							

Technical condition for test					Depth of carburizing layer, mm	Hardness HRC <sub>E</sub>	Test place and test %	Polishing
$\sigma V$ kg/mm <sup>2</sup>	$\delta$ %	$\varphi$ %	ak, kgm/cm <sup>2</sup>	Qty .and type of test specimen				
				Separable	Impact	34... 40.5	At pint "A" 100%	Polishing wheel

Remark:				
	No.p/p	Reason for amendment	Sign	Date

