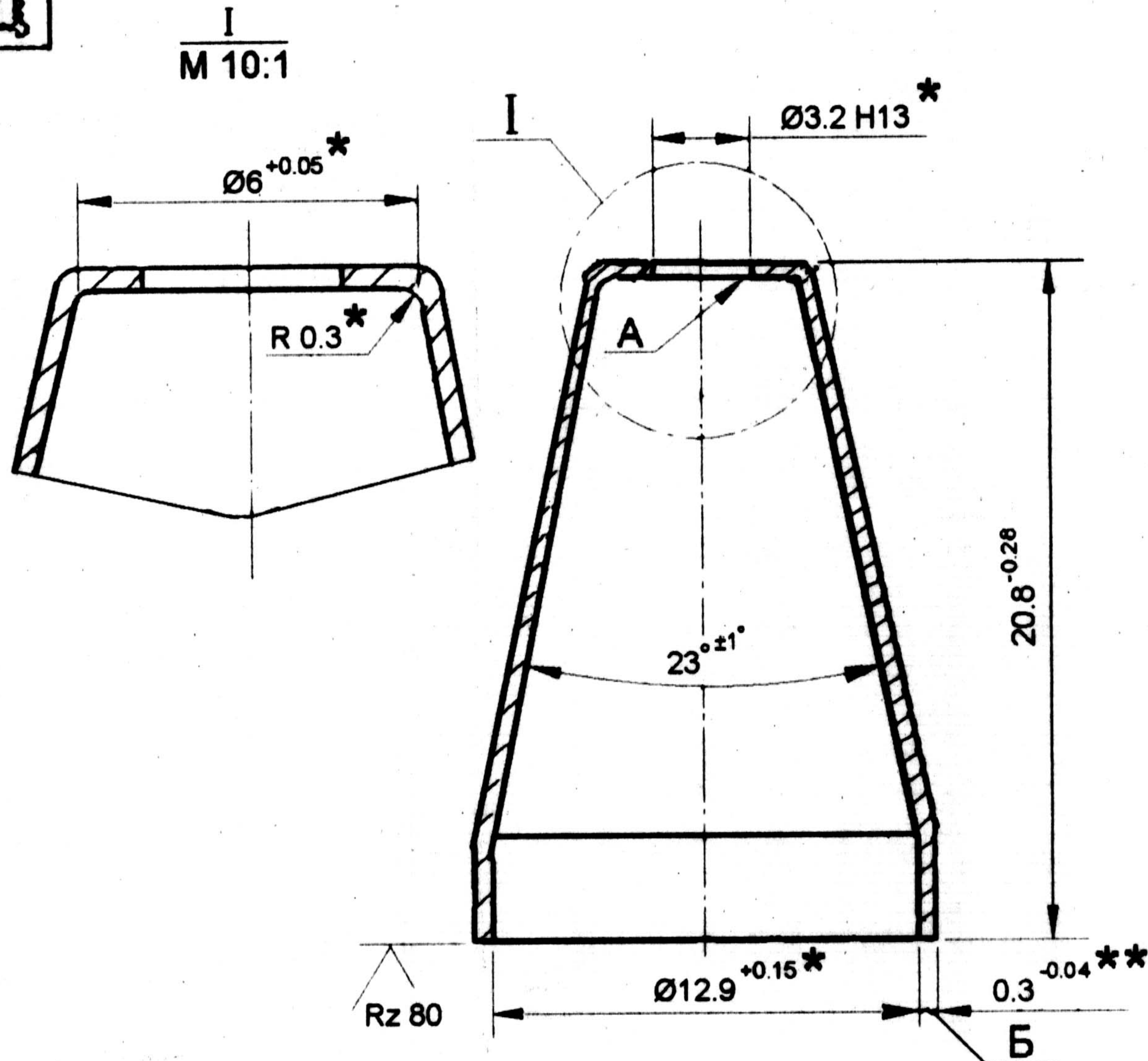


ЕСКА



1. Part should be manufactured with single technological annealing at a temperature of 600...700°C with holding time of 25...30 minutes which is carried out before final sizing. Hardness values should be between 90 to 110 HV.
2. Alternate material is band 08КП-ОМ-Т; 08-ОМ-В-08 КП-ОМ-Т- L4 GOST 503-81 not lower than second group.
3. * Dimensions ensured by tool.
4. ** Dimensions for reference.
5. Disturbance of metal continuity of part by the action of 0.02 MPa pressure for 5 seconds.
6. Coating should be in compliance with table.
7. The following is allowed :
 - a) Thinning at 30% or thickening at 15% from nominal dimension B of part wall at full length and thinning at 40% from nominal dimension B at 1/3 of length at the head part;
 - b) Ring impressions, minor marks, smoothed corrugations, minor cavities are allowed on part surfaces as well as small burrs on surface A as against the standard sample established by manufacture and agreed with customer representative at manufacturing plant;
 - c) Manufacturing the part with one technological annealing after final sizing at a temperature of 450 °C - 500 °C for 25...30 minutes.
8. Other requirement are as per GOST B 84-264-81.
9. **INDIGENOUS MATL :-**
IS: 513-2008 Gr CR 3 OR Gd I CS OF BS:1449 SECTION 1.1:1991.

Designation

БШ 8.635.541

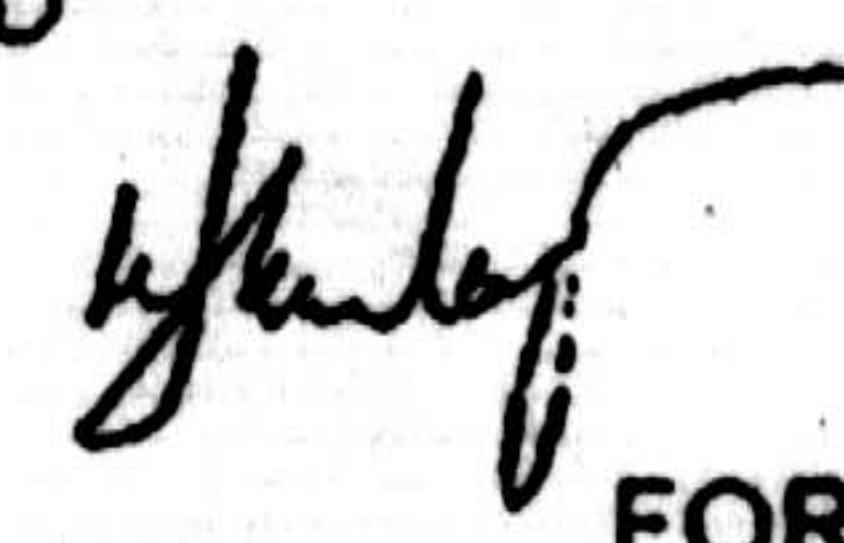
-01

Coating

КД.12 . xp.

Cadmium 12 V2 microns thick chromitized .

Cu3,Sn3, coating is allowed
alloy Cu Zn (70%) 3. Sn3

18-12-2012	DC 37327-A	NOTE AMMENDED		
		PREV. DC Nos. DC 34241-A, DC 36855-A & DC 37271	SD/-	SD/-
DATE	AUTHORITY	REVISION	SIG AHSP.	SIG D.O.
APPROVED		3-0126082	A3-БГ-81	
 FOR CQA(A)		БШ 8.635.541		
AHSP:- CQA(A) KIRKEE			SHEET	WEIGHT
SNC SH DOC No.			A	1.74g
SIGN			SCALE	
DATE			1:1	
DRAWN			TOTAL SHEETS	
EDT.CHKD				
F/M, DC.				
D.V.OFFR				
NAME			Band 08k - L4 OM-2-0.3	
SIGN			GOST 503 - 81	
DATE				