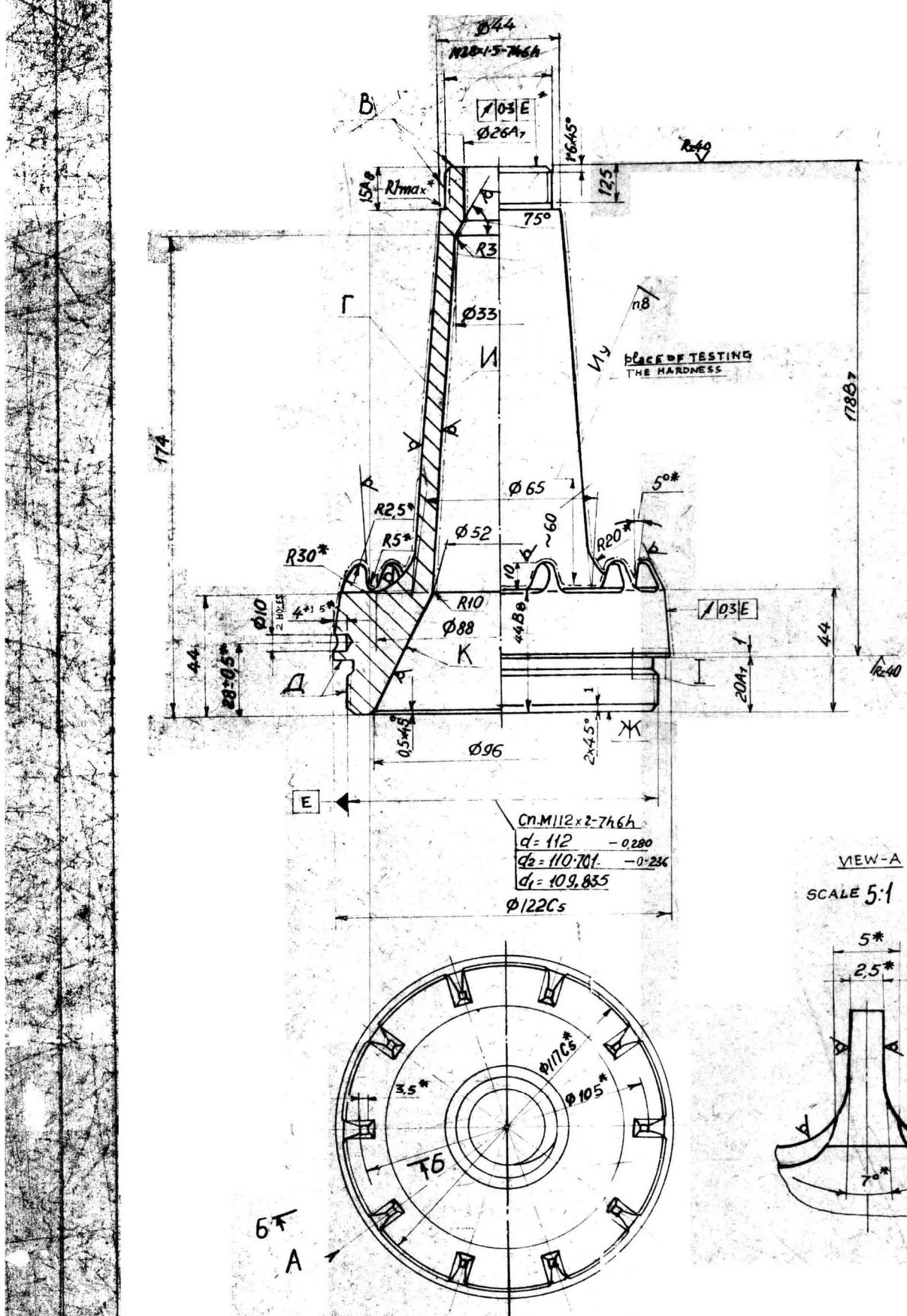


866620-4

Rz80 ✓(✓)



- Mechanical properties: $G\Gamma \geq 50 \text{ kg/mm}^2$, $\delta \geq 5\%$ determined on certified samples.
 - It is permitted:
 - On surface K not above 35 mm from the surface Λ cavities of depth not more than 4 mm and diameter not more than 5 mm in quantity 6 pieces, or depth not more than 3 mm and diameter not more than 8 mm in qty. of 4 pieces; distance between those should not be less than 20 mm;
 - On surface K_A ^{above} 35 mm from the surface Λ and on the surfaces Λ, Λ_K cavities (pits) of depth not more than 2 mm and having diameter not more than 3 mm, or depth not more than 0.5 mm and having diameter not more than 5 mm of qty. 6 pieces, not closely positioned and not coinciding with the defects on surface Γ ;
 - On surface K and Λ , flows and (excess metal) bulges of metal without sharp edges of height not more than 1 mm, having diameter not more than 15 mm and in qty. not more than 3 pieces, caused by minor mechanical damages of rod; traces without sharp edges due to the roughness of Rod surface;
 - mechanical machining of surface K along straight directions without forming R10 mm.
 - Permissible deviations of the casting dimensions of class II accuracy is as per GOST 2003-55.
 - * Dimensions are ensured by tooling.
 - Coating of surface Γ , primer BL-02.
 - Primer AK-070, Enamel XB-124, grey as per OST B-84-1384-76
 - Surfaces Λ , K, Λ_K . Varnish MA-92 as per OST B-84-1384-76
 - Primer BL-02 GOST 12707-77
 - Primer AK-070 OST 6-10-401-76
 - Varnish MA-92 GOST 15865-70
 - Enamel XB-124, Grey GOST 10144-74
 - Coat-surfaces B and Λ_B with shell grease GOST 3260-75
 - TEST FOR SHELL GREASE
 - Remaining technical requirements as per OST B-84-485-71.
 - * FOR INDIGENOUS PRODUCTION PAINT TO SPEC. IS:169 SHADE NUMBER BUFF (JSC 349 OF SPEC. IS-5) WILL BE USED IN LIEU OF ENAMEL XB-124 GREY.
 - HARDNESS RANGE 197 TO 302 BHN (BALL DIA. 10 mm, LOAD 3000 Kg., LOADING TIME 10-18 SEC.)

10. FOLLOWING ALTERNATIVE INDIGENOUS COATING MATERIAL
ARE PERMITTED:

FOR PERMITTED INDIGENOUS MATERIAL
SPECIFICATION

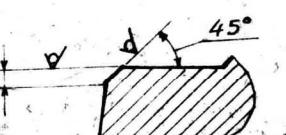
TO 6051 12707-77
PRIMER AK-070 J58, 4-63-05 (b)
TO SPECN. OST

SHELL GREASE TO

MINERAL JELLY TO SPECN.
166. 1922. 22

A technical drawing of a stepped component. The top part has a total width of 5* and a height of 2.5*. The bottom part is a semi-circular base with a radius of R5*. The angle between the vertical wall and the base is 70°*. The drawing includes several dimension lines and feature labels.

6-5 ROTATED
SCALE 5:1



CASTING 40ХЛ ГОСТ 977-75

MASS - 3.200±0.074 kg		36K 14.M
4-025998		002
HEAD	APPD	<i>71 Sed FOR C (A)</i>
SCALE - 1.1	AHSP - C (A) KIRKEE	