



1. Mechanical properties:  $\sigma_T \geq 50 \text{ kgf/mm}^2$ ;  $\delta > 5\%$  determined on certified samples.
2. It is permitted:
  - a) On surface K not above 35 mm from the surface K 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;
  - b) On surface K, 35 mm from the surface K and on the surfaces N, 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 K;
  - c) On surface K and N, flows and (excess metal) buldge 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;
  - d) mechanical machining of surface K along straight directions without forming R 10 mm.
3. Permissible deviations of the casting dimensions of class II accuracy is as per GOST 2003-55.
- 4.\* Dimensions are ensured by tooling.
5. Coating of surface  $\Gamma$ , primer B.1-02.
  - Primer AK-070, Enamel XB-124, grey as per OST B-84-1384-76
  - Surfaces N, K, X Varnish MA-92 as per OST B-84-1384-76
  - Primer B.1-02 GOST 12707-77
  - Primer AK-070 OST 6-10-401-76
  - Varnish MA-92 GOST 15865-70
  - Enamel XB-124, Grey GOST 10144-74
6. Coat surfaces B and A with shell grease GOST 3260-75
7. Remaining technical requirements as per OST B 84-485-71.
- 8.\* FOR INDIGENOUS PRODUCTION PAINT TO SPEC. 15-16B SHADE WHITE BUFF (JSC 359 OF SPEC. 15-5) WILL BE USED IN LIEU OF ENAMEL XB-124 GREY.
9. 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
PRIMER B.1-02 TO GOST 12707-77	JSS 8010-28, JSS 1-63-03 (b)
PRIMER AK-070 TO SPECN. OST 6-10-401-76	JSS 1-63-03 (b)
SHELL GREASE TO GOST 3260-75	MINERAL JELLY TO SPECN. JSS 8030-03

NO.	DC	DATE	DESCRIPTION	REV.	ZONE
1	12.8	DC 35862-A	TOL. ON MASS ADDED.		
2	30.7.91	DC 35857-A	NOTE NO. 10 ADDED.		
3	28-10-91	DC 35206-A	NOTE 9 RE. HARDNESS RANGE ADDED.		
4	2.7.90	DC 34909-A	MASS ADDED.		
5	11.8.90	DC 34862-A	INNOTE 8 PRINT MIDDLE BUFE BELE ADDED.		
6	16.8.88	DC 34401-A	NOTE NOT AMENDED.		
7	10.11.87	DC 34257-A	2 HOLES WAS 20 HOLES.		
8	10.11.87	DC 34257-A	KEY SLOT CAVITY 4*15 WAS 4*15.		
9	10.11.87	DC 34257-A	DRY SEALED PROV.		
10			REVISION		
11			ZONE		

CASTING 40X11 GOST 977-75

MASS - 5.200±0.074 kg   35K 14 M	
4-025998	002
HEAD	APRD
	FOR C.I.A.S.
SCALE - 1:1	AHSP - C.I.(A) KIRKEE