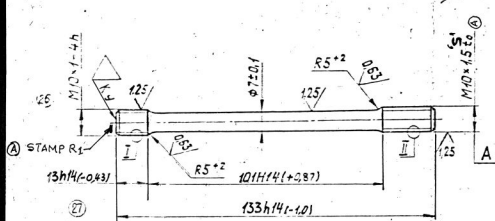


20-06-152



TECHNICAL REQUIREMENTS - IN RUSSIAN

- 1 Группа контроля III по ТТ-И.
- 2 НРВ 44... 49. Закалка изотермическая.
- 3 Биения от прогиба при обработке не более 0.1 мм.
- 4 Резьбу А выполнять по нормам 82020-12 в п. 4, кроме внутреннего диаметра и радиуса фаски.
- 5 Полировать гайки.
- 6 Размеры обеспечить с точностью.
- 7 Деталь проверить на соответствие в электролите по инструкции УБ-20-17.
- 8 Проверить хим. состав.

REPAIR SIZE DIMENSION

CATEGORY	DESIGNATION OF SIZE	DIMENSION'S
20-06-152 RI	DIAMETER	12.5 ± 0.05
	DIMETRAL PITCH	1.5 ± 0.025

STAMP RI WHERE MARKED THUS -

26	1586-87	
27	1587-87	
28	1588-87	
29	1589-87	
30	1590-87	
31	1591-87	
32	1592-87	
33	1593-87	
34	1594-87	
35	1595-87	
36	1596-87	
37	1597-87	
38	1598-87	
39	1599-87	
40	1600-87	

Копировать кодировку Показат 12

R_z 80

EXPLANATORY NOTE :

9. REFERENCE MATERIAL QUOTED : 30X1 CHA TY 14-1-950-74.
STRUCTURED ALLOYED STEEL TO GRADE 30X1 CHA.

a) CHEMICAL COMPOSITION :

CARBON	= 0.27 - 0.33
SILICON	= 0.90 - 1.20
MANGANESE	= 1.00 - 1.30
CHROMIUM	= 0.90 - 1.20
NICKEL	= 1.40 - 1.80
SULPHUR	= 0.025 (max)
PHOSPHORUS	= 0.025 (max)

b) MECHANICAL PROPERTIES :

ULTIMATE TENSILE STRENGTH Kgf/mm ²	= 160 (min)
YIELD POINT Kgf/mm ²	= 140 (min)
% RELATIVE ELONGATION	= 9 (min)
% RELATIVE REDUCTION IN ACCROSS SECTIONAL AREA	= 45 (min)
IMPACT STRENGTH Kgf/cm ²	= 6 (min)

TECHNICAL REQUIREMENTS - TRANSLATED

20-06-152
Joint Pin
(Sheet 1)

1. Control group III to TT-11.
2. НРВ 44... 49. Isothermal hardening.
3. Non-indicated limit deviations of dimensions: shafts by B₁; the rest by C₁.
4. When machining run out from bonding should be no more than 0.1 mm.
5. Make A thread to 82020-12 normal, issue 4 bevelled inner diameter and depression radius.
6. Polish fillets.
7. Provide dimensions with scale.
8. Check the part with magnetic flux detector by instruction.
9. Conting : 1mm.0mm.0mm.

**
CQAIHV15.06.605E
CQAIHV15.06.609E

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION			
B	15.15	PLT of 7th All-Comm. Meeting Dt. 14.12	EST MASS TO BE STAMPED OR MARKED WHERE INDICATED THIS #
A	23-86	DATE OF SPEC. FOR BULK	0.054 kg
ISSUE DATE		NATURE OF AMENDMENTS	
DRN		SCALE: 1:1	
CDN		DIMENSIONS IN mm	
TCD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	
APPD		DATE	
DATE	07-9-87	ALL THREADS CONFORM TO	
		MATERIAL	30X1 CHA TYPEN 14-1-950-74
		CONTROLLER/DATE OF INSPECTION	HEAVY INDUSTRIES LTD. CHENNAI
		TITLE	JOINT PIN
		D S CAT NUMBER	20-06-152

