

AK-630 120-4

First use

Reference No.

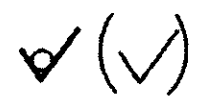
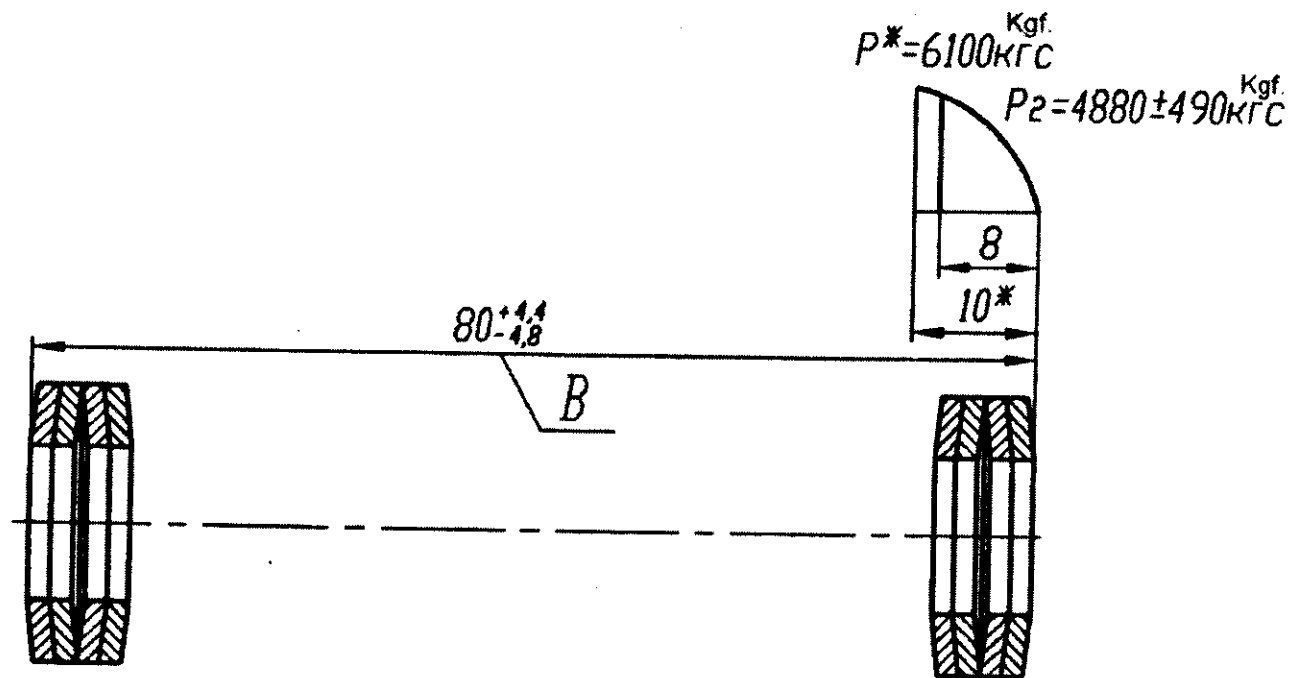
Sign and Date

Duplicate Inv. No

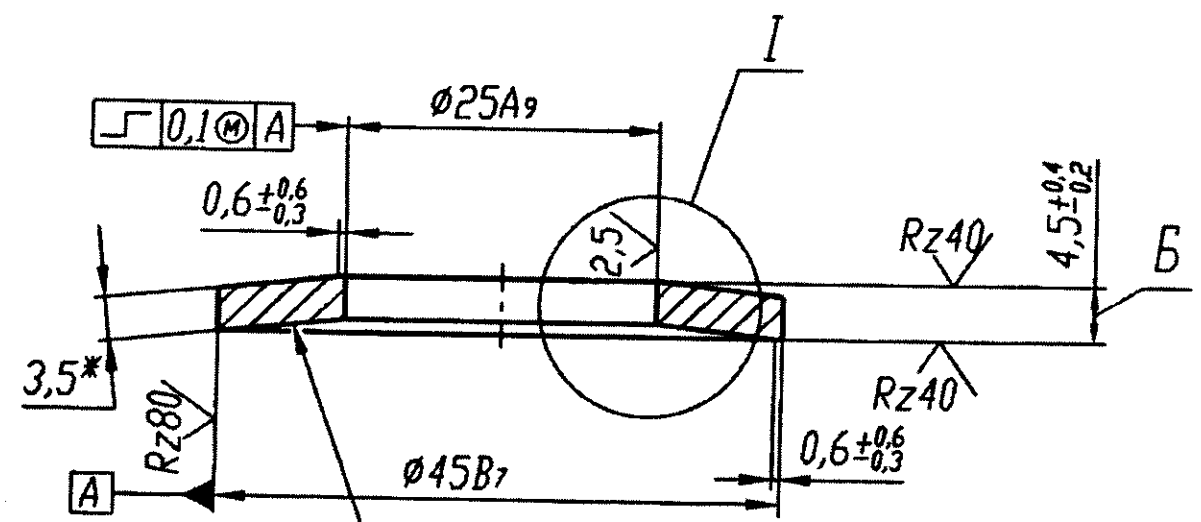
Alternate Inv. No

Sign and Date

Orig. inv. no.

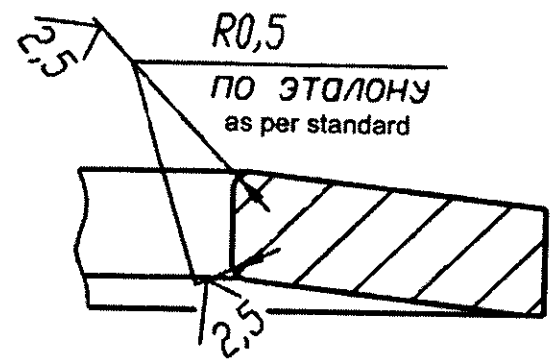


1. Substitute material- multi leaf spring strip steel A $\frac{4.0 - 60 \text{VGOST}7419 - 74}{65\text{S}2\text{VAGOST}14959 - 69}$ or sheet 4 65S2VA TU 14-1-723-73 with finish grinding to dimension $3.5_{-0.15}$ from two sides $^{1.25}\sqrt{}$.
2. $47.5 \dots 51.5 \text{ HRC}_E$. Burying is permissible up to 0.1 mm at place of grinding for checking hardness.
3. $E^* = 20\,000 \text{ kgf/mm}^2$, $\sigma^* = 323 \text{ kgf/mm}^2$.
4. Number of springs in set of Belleville springs $n = 20$.
5. Set assembled from components with dimension B, should have height of set within range of dimension B.
- 6.* Dimensions and parameters for reference.
7. Blunt sharp edges $\sim 0.4 \dots 0.6 \text{ mm}$ ensured by tool.
8. Brightening of surfaces after pre deformation is permissible.
9. Coating Chem.phos.accel.
- Lacquer BF-4 with Nigrozene 2 layers, made as per OST 3-4123-78 IV, OM2.
10. Other technical requirements as per GOST 3057-90.
11. Mark set of springs with Ш, Ч and stamp K, И on tag. Use in set.



Место испытания
ТВЕРДОСТИ
Place for checking
hardness

1(5:1)



					AK-630 120-4			
Amend.	Sheet	Doc.No.	Sign	Date	Belleville spring	Type	Weight	Scale
Developed by						A	0.018	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Multiple leaf spring strip steel A $\frac{3.5 - 60 \text{VGOST}7419 - 74}{65\text{S}2\text{VAGOST}14959 - 69}$			
Approved by								