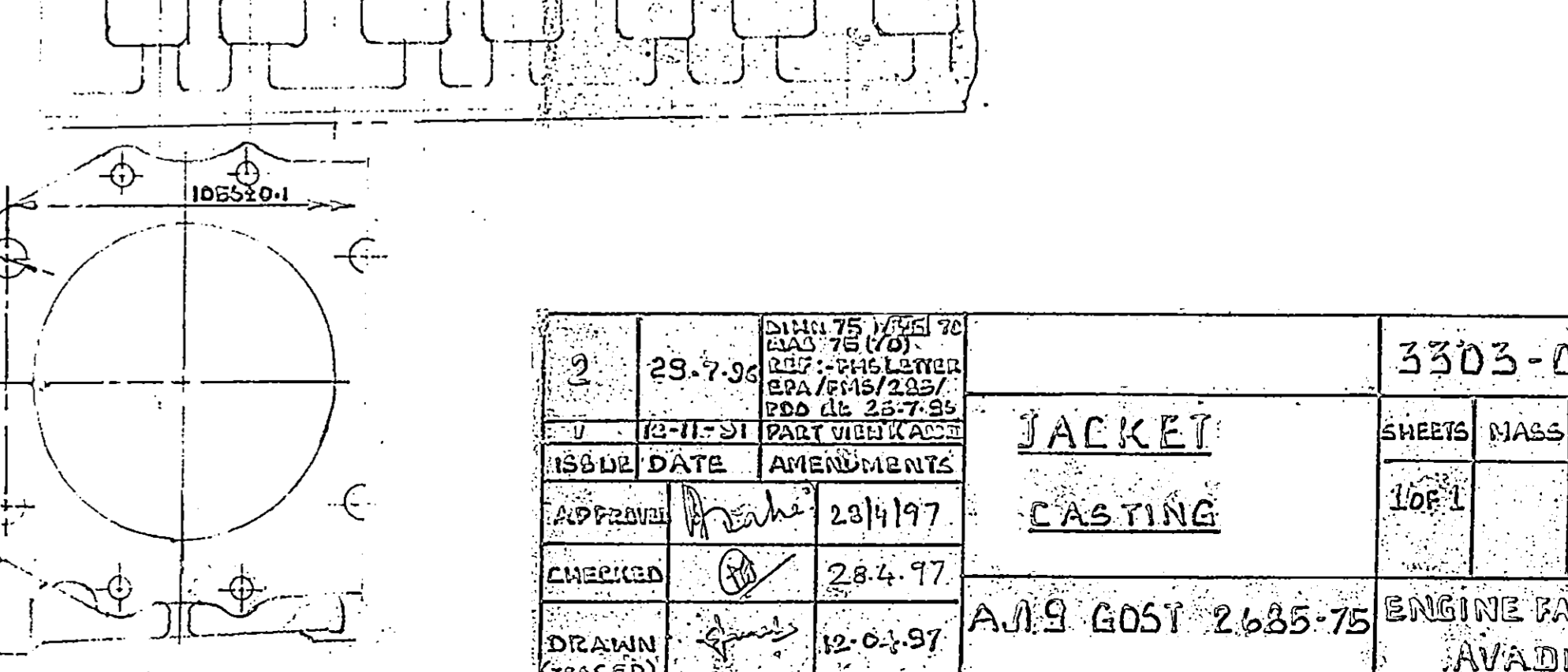
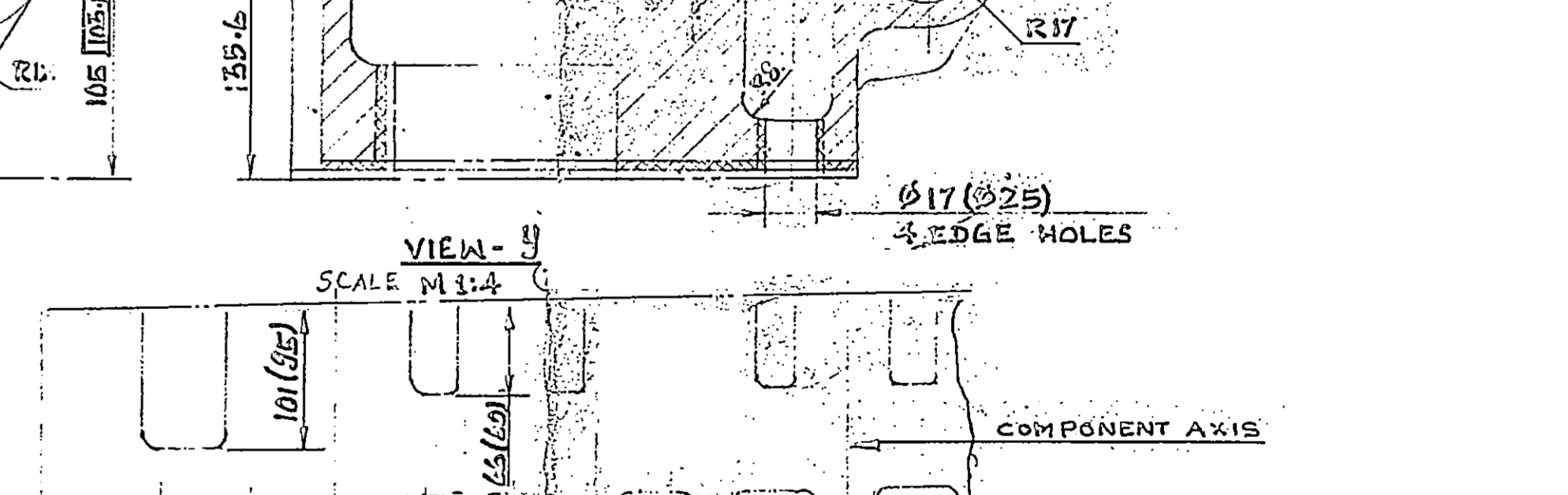
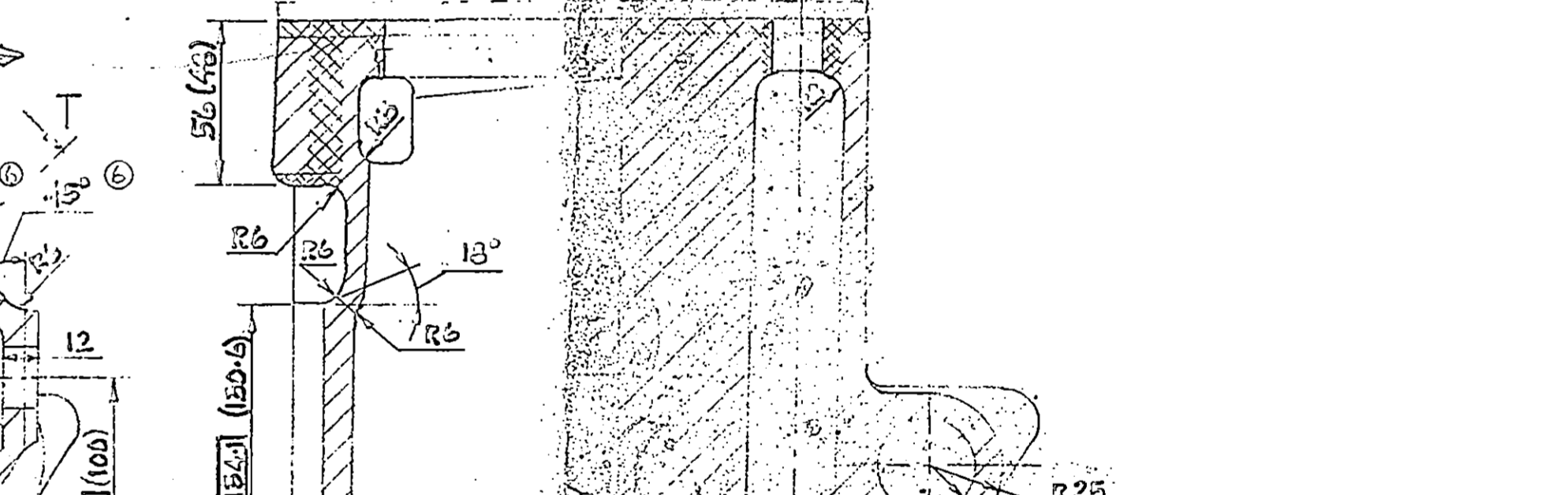
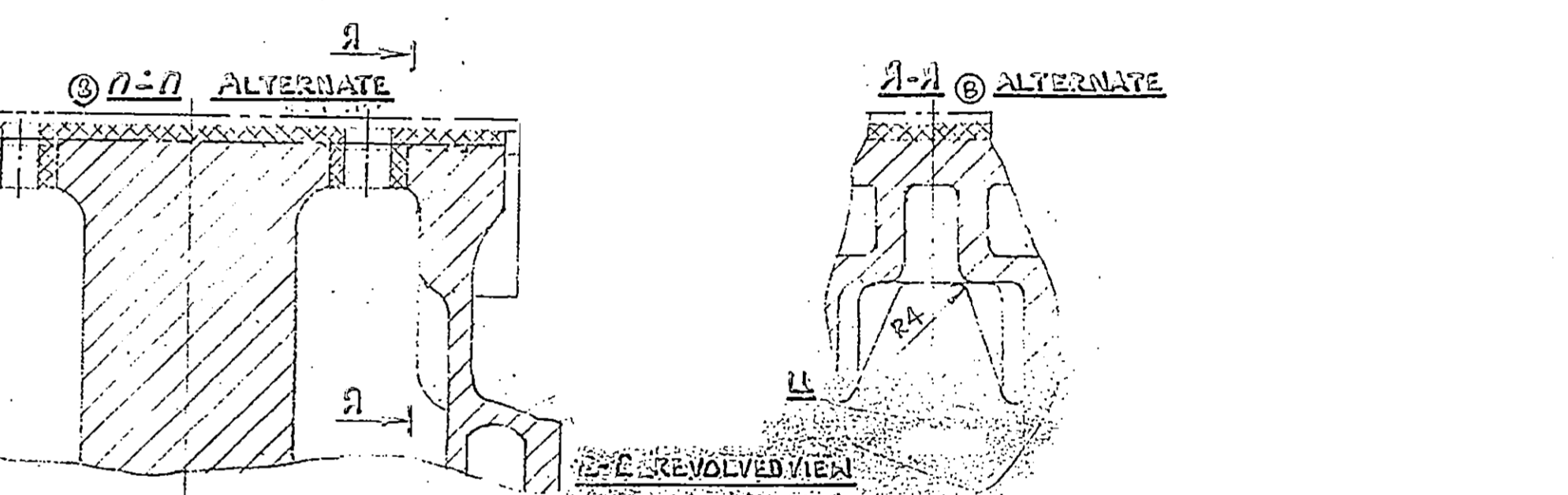


1. METAL MOLD CASTING.
2. REQUIREMENT OF CASTING AS PER TTN 27-75.
3. PRESSURE TEST THE WATER PASSAGE AND POCKETS OF ANCHOR STOPS WITH WATER AT A TEMPERATURE OF 30-50°C UNDER THE PRESSURE OF 3-5 ATM FOR 5 MINUTES. IT IS ALLOWED TO PRESSURE TEST WITH IN THE WATER TANK UNDER THE PRESSURE OF 2-3 KG/CM² LEAKAGE OF AIR IS NOT ALLOWED.
4. UNMACHINED SURFACES SHOULD BE CLEANED AS PER INSTRUCTION/ MASTERPIECE.
5. IT IS PERMITTED TO MARK THE PUNCHING OF HEAT NO ON THE SIDE OF FLANGE END.
6. DIMENSIONS IN BRACKETS () ARE GIVEN FOR FINISHED COMPONENT.
7. DIMENSIONS IN [] ARE GIVEN FOR ZERO OPERATIONS.
8. MOLD MARKS DUE TO THE REMOVAL OF RISERS BY 55° ON THE SURFACE "U" ARE ALLOWED.
9. MOLD MARKS DUE TO THE REMOVAL OF RUNNER BY 55° ON THE SURFACE "U" ARE ALLOWED.
10. DATUM SURFACES OF ZERO OPERATIONS ARE SHOWN BY THE SIGN ↯
11. CASTING BEFORE ZERO OPERATIONS ARE SHOWN BY THE LINES -----
12. MARK THE GRADE OF MATL AS PER GOST 2171-79 LETTER 10-10 GOST 2930-62.
13. DIMENSION DR 25.5 MAX SHOULD BE ENSURED ON HEIGHT 28.5 FROM THE SURFACE 1-0 24-FILE GENERATING THE WALL THICKNESS, IT IS ALLOWED TO DRESS ON THE ENTIRE CONTOUR WITH SMOOTH TRANSITION.



2	29.7.36	3303-06-2	3303-06-2
U	12-11-51	JACKET	SHEETS MASS SCALE
	DATE	CASTING	106-1 1:2
APPROVED	28/4/77		
CHECKED	28.4.77	ALL GOST 2685-75	ENGINE FACTORY
DRAWN (GRADED)	12-6-79		AVADI