



1. Требования, предъявляемые к отливке, по ТМ 65-78.
 2. $HV \geq 80$.
 3. Заменитель материала АЛ9 ГОСТ 2685-75.
 4. Допуски на свободные размеры отливки выполнять для диаметрических и линейных размеров до 50 мм ± 0.15 мм, св. 50 мм ± 0.2 мм, для радиусов с округлением от 3 до 10 мм ± 0.15 мм.
 5. Неуказанные предельные отклонения размеров механической обработки отверстий по H14, валов по h14, остальных $\pm IT14$.
 6. Поверхности Г и Д проверять по краске. Прилегание должно быть равномерным и составлять не менее 50% поверхности.
 7. Допускается в месте Е зачистка литья R 3 мм или фаской $3 \times 45^\circ$.
 8. Маркировать по ГОСТ 2171-79 шрифтом ПО-10 ГОСТ 2930-62.
 9. Допускается маркировать ударным способом.
 * Размеры обеспечить инструментом.

- 1) REQUIREMENTS FOR CASTING ARE IN ACCORDANCE WITH T M 65-78.
- 2) $BHN \geq 80$.
- 3) ALTERNATE MATERIAL : A19 GOST 2685-75.
- 4) TOLERANCE ON FREE DIMENSIONS OF CASTING ARE TO BE MADE FOR DIAMETRICAL AND LINEAR DIMENSIONS UP TO 50mm ± 0.15 mm, CB 50mm FOR ROUNDING OFF RADII FROM 3 TO 10mm ± 0.15 mm.
- 5) UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS OF MACHINING OF HOLES AS PER H14, SHAFTS AS PER h14, OTHER DIMENSIONS $\pm IT14$.
- 6) SURFACES Г AND Д ARE TO BE CHECKED BY BLUEING. THE IMPRINT SHOULD BE UNIFORM AND SHOULD COVER AT LEAST 50% OF THE SURFACE.
- 7) GRINDING OF CASTING R3mm OR CHAMFER $3 \times 45^\circ$ IS ALLOWED ON AREA E.
- 8) TO BE MARKED AS PER GOST 2171-79 WITH TYPE ПО-10, GOST 2930-62, MAY BE MARKED BY PUNCHING.
- 9) * DIMENSIONS TO BE ENSURED BY TOOLING.

EXPLANATORY NOTE :-
MATERIAL QUOTED : A19 GOST 2685-75
 A19 = GRADE OF MATERIAL
CHEMICAL COMPOSITION :-
ALUMINIUM BASE
 Mg = 0.2-0.4 ; Si = 6.0-8.0
ADMIXTURES % MAXIMUM
 IRON = 1.00 ; Mn = 0.50 ; Cu = 0.20 ; Zn = 0.30 ;
 Ti = 0.01 ; Pb = 0.05 ; Be = 0.10 ; Zr = 0.15.
TOTAL OF CALCULATED ADMIXTURES = 150
MECHANICAL PROPERTIES: (CHILL MOULD CASTING)
 PARTIAL RESISTANCE kgf/mm^2 (MAX) = 21
 SPECIFIC ELONGATION % (MAX) = 2

PLOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BJK PRODUCTION.

EST. MASS TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
 ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	TCO	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69	ALL THREADS TO CONFORM TO
				29-3-68	1:1			
MATERIAL : A19 GOST 2685-75						USED ON : CB 3300-00-17		
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)						TITLE : BEARING		
D S LAT NUMBER						DRAWING NUMBER : 308-14-11		
ISSUE	DATE	NATURE OF AMENDMENTS						

