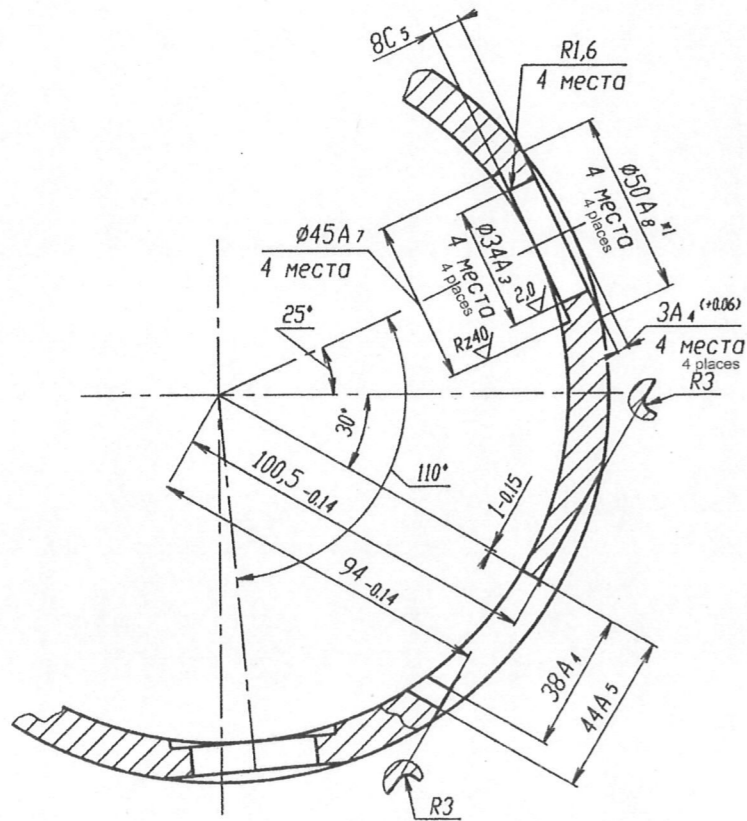


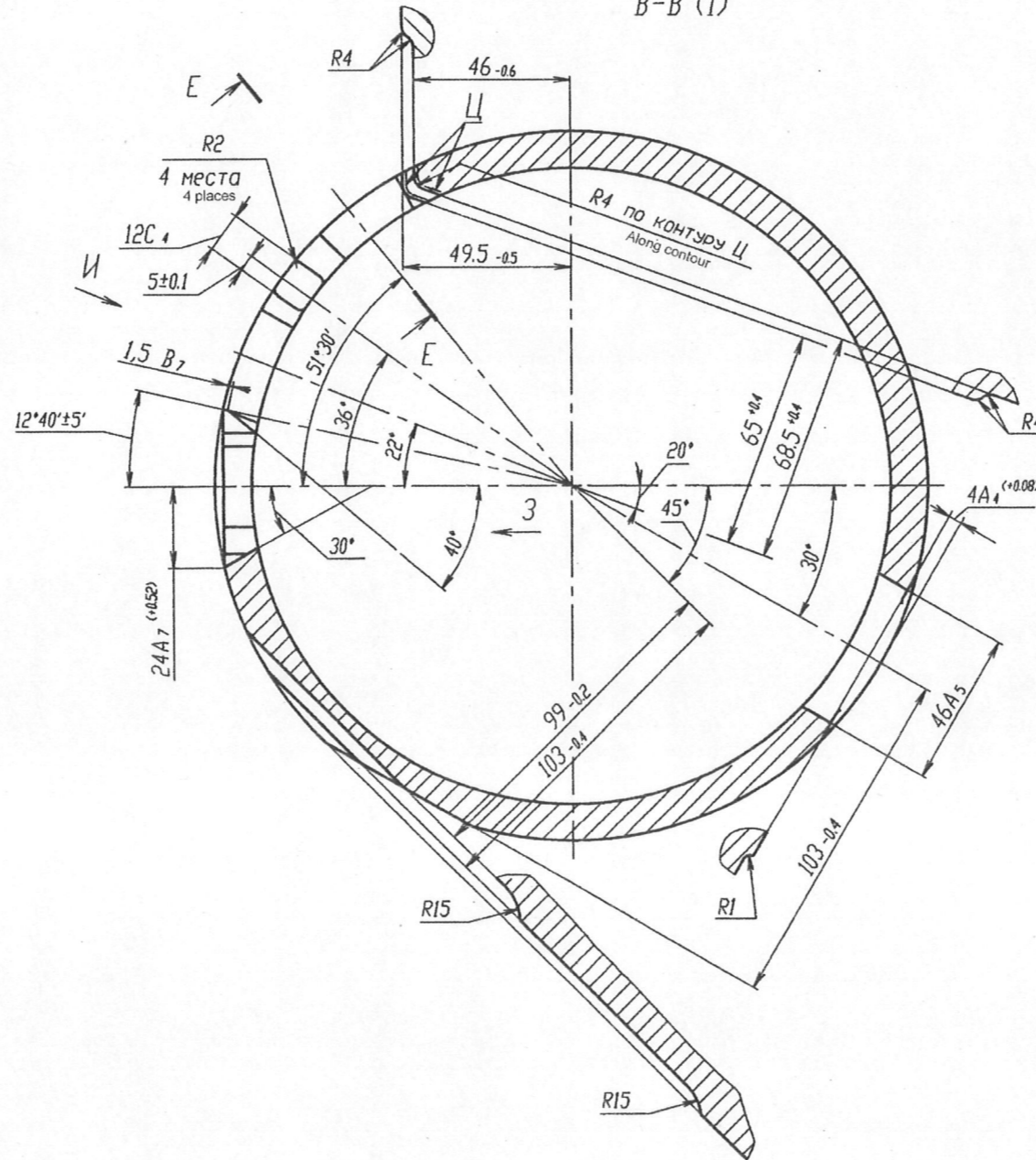
1. 66.5...70 HRA. Test the hardness of blank.
2. \*Dimensions not in projection.
3. \*Dimensions are ensured by tool.
4. Internal angle  $\alpha = 0.4$  mm.
5. Blunt edges  $R = 0.6$  mm.
6. Displacement of holes axis with dimensions in square bracket  $\pm 0.02$  mm along linear dimensions and  $\pm 40'$  along angular. Datum Y.T.
7. Tolerance along contour  $U_1 - 1$  mm.
8. Coating Chem. Phos. Anod. Cr.
9. Mark with letter size po-3 GOST 2930-62.
10. Mark complete number of article with letter size PO. 5 GOST 2930-62. Fill inscription with white enamel PB-115, GOST 6465-76 before preservation.
11. Stamp.
12. Carry out marking as per points 9,10 in AO-18.02.000 SB.

AO-18.02.001				Type	Weight	Scale
Amend Sheet	Doc. No.	Sign	Date	Casing	D	20.8
Developed by						
Checked by				Pip 218X18 GOST 8732-78		
Head of bureau				B330GSA GOST 8731-97		
Head of OGD				Form A204		
Approved by						

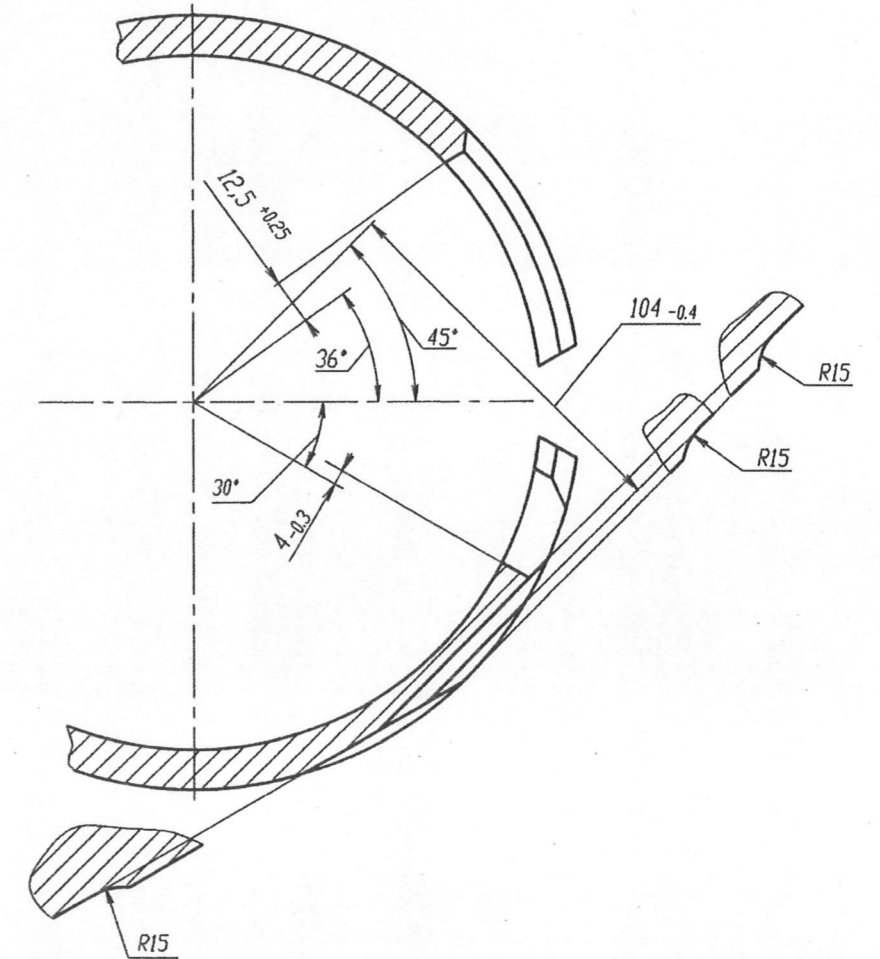
Б-Б (1)



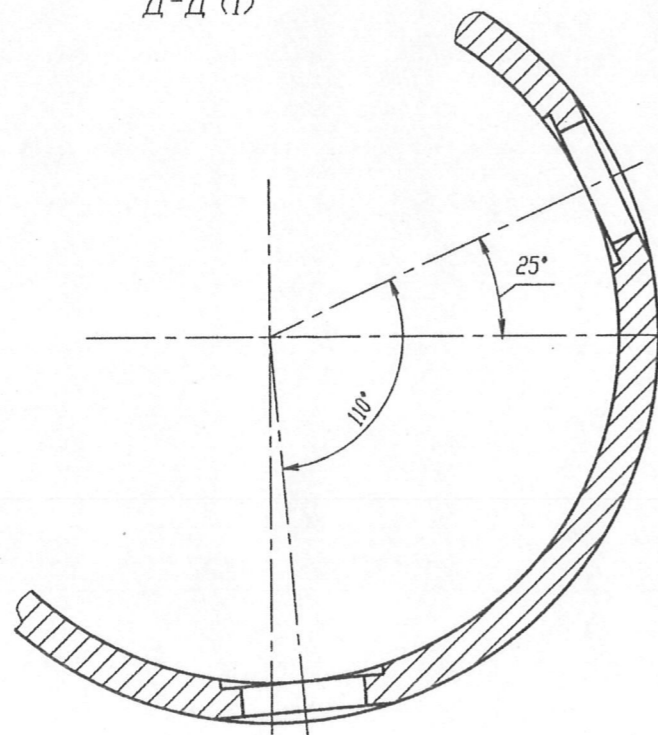
В-В (1)



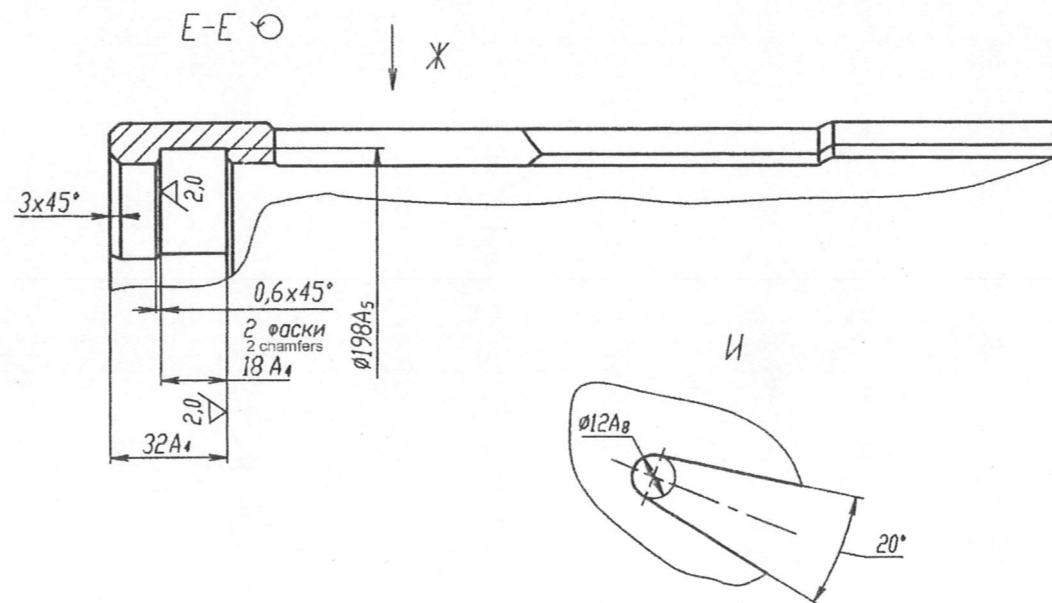
Г-Г (1)



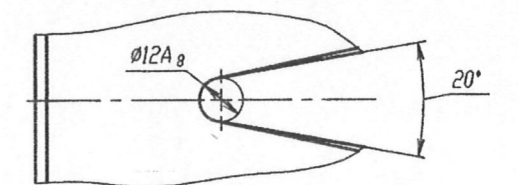
Д-Д (1)



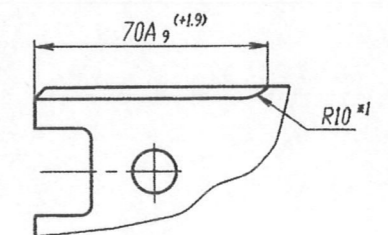
Е-Е (1)



Ж



З



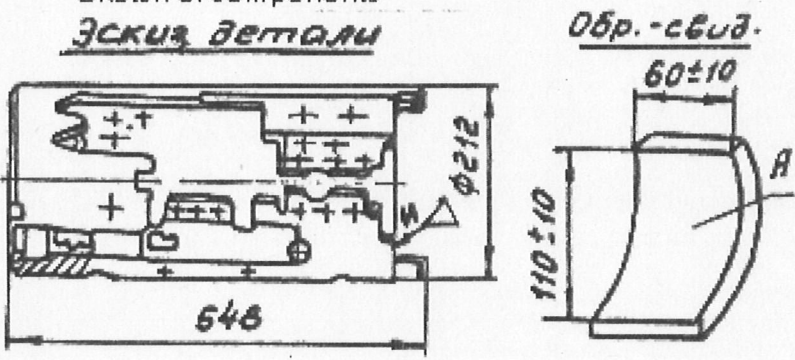
Inv. No. Sign & Date Alternate Inv. No. Duplicate Inv. No. Sign & Date Reference No. First remarks





Technological process lay out for heat treatment				Sheet 1					
				sheets 2					
Article		Component No.	Nomenclature of component		Material grade	Weight of comp. kg.			
AO-18		02.001	Casing		Steel 30KhGSA	~40			
					Set				
Oper.No.	Nomenclature of operation	equipment	Mode			Fixture LK0772	No.of fixtures	No.of comp.on fixture	
			t°C of heating	Time of heating, min.	Cooling				
Get familiar with safety instruction No.100 and 05042520000014									
0080	Inspection of steel grade on steel scope.								
0090	Hardening								
	1.Heating	El.furnace	850-870	60	Oil 40-80°	Furnace		2	
	2.Washing	Wash.machine	70-100						
0100	Tempering								
	Heating	El.furnace	480-520	120	Air	Furnace		4	
0110	Polishing for checking hardness.								
0120	Checking hardness.								
0170	Preparation of accompanying chart.								
	Send components to machine shop.								
Technical condition for test			Carburization depth of layer,mm		Hardness HRC <sub>E</sub>	Test place and test %	polishing		
C <sub>s</sub> kg/mm <sup>2</sup>	δ %	x %	ak, kgm/cm <sup>2</sup>	Qty.and type of test samples		Drawing Acceptance	66.5..70 35.5-40.5 HRC	At point "A" 100% on flat	Refer remark
				separable	impact				
Remarks									
Carry out polishing with file or reverse side of polishing wheel.									
			No.	Cause for amendment		Sign	Date		



Department of chief metallurgist	Technological process lay out for heat treatment				Sheet 2			
					sheets 2			
Article		Component No.		Nomenclature of component	Material grade	Weight of comp. kg.		
AO-18		02.001		Casing	Steel 30KhGSA	~20.5		
<p>Sketch of components <i>ЗСКУЗ ВЕТЛАМ</i></p> 					No.of equipment			
					t int.			
					t optimum			
					t service+ t adjust.			
					set up time			
					Time/piece			
Get familiar with safety instruction No.100 and 050425200000014					N			
Oper.No.	Nomenclature of operation	equipment	Mode			Fixture LK0772	No.of fixtures	No.of comp.on fixture
			t°C of heating	Time of heating, min.	Cooling			
0440	Rechecking hardness of ready components on specimen. Components are delivered for rechecking of hardness with specimen.							
	Specimen are cut out from components, should have serial No. of component, certified with QCD stamp.							
0450	Putting stamp "I" on components.							
0530	Furnishing accompanying sheet.							
Technical condition for test				Carburization depth of layer,mm	Hardness HRC <sub>E</sub>	Test place and test %	polishing	
C <sub>s</sub> kg/mm <sup>2</sup>	δ %	x %	ak, kg/cm <sup>2</sup>	Qty.and type of test samples		Acceptance Drawing	34..40.5 HRC 66.5.70	On specimen for each batch
				separable	impact			
Remarks								
No.	Cause for amendment			Sign		Date		