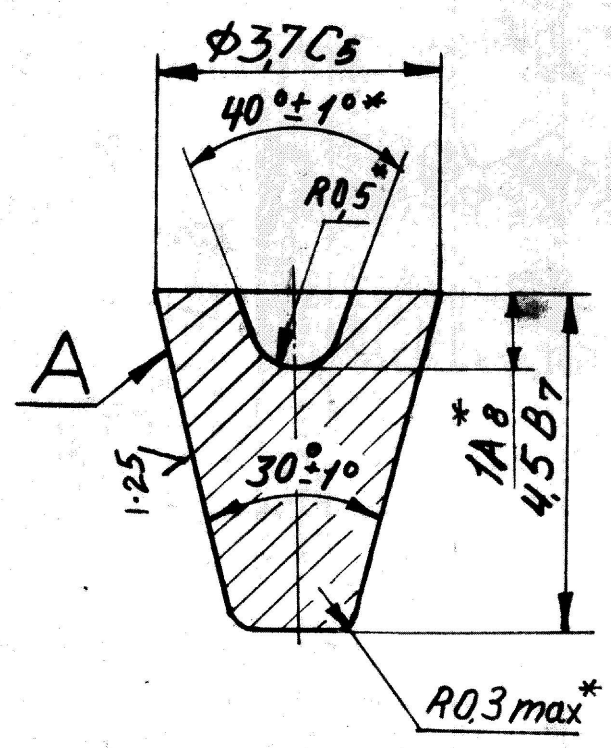


R220 ✓ (✓)



1. Anneal in closed metal pots filled with iron fillings. Provide neutral medium, Temp ~~max~~ 700 to 720 °C. Time 60 to 80 minutes. After annealing cool in water.
2. Dimensions ensured by tool.
3. Coating chemical passivation/varnish AM-3 as per OST B 84-811-73.
Technical requirements, rules of acceptance, methods of test, as per GOST 9501-78 and GOST 9302-79.
4. Misalignment of recess relative to surface A is ensured technologically. Check with standard of comparison having a wall thickness of 0.7 mm.
5. Permissible are :-
Copper crusher wire (GOST 4752-79).
Varnish grades AM-4 AM-5 (OST B 84-811-73).
6. General requirements as per OST B 84-10-77.

MATERIAL	RUSSIAN SPECIFICATION No	APPROVED INDIGENOUS EQUIVALENT/ALTERNATIVE
VARNISH AM-3, AM-4 AM-5	OST B 84-811-73	USS 8010-63-1991
COPPER	MI GOST 859-78	IS 6912-1985 ETP 'O' CONDITION.

R No	DATE	AUTHORITY	REVISION	ZONE	AHSP	D.O.	SIG.
	13-9-94	DC. 35802-A	MATERIAL TABLE ADDED				
	4-6-85	D.C.I. 33760-A	DRG SEALED PROV.				
			NOTE No 3 AMENDED.				

	3-027321	4B2
	CONICAL SHUTTER	2
	Copper MI as per GOST 859 - 78.	APPD <i>Saxwal</i>
		FOR CICA
		AHSP :- C.I.(A) KIRKEE