

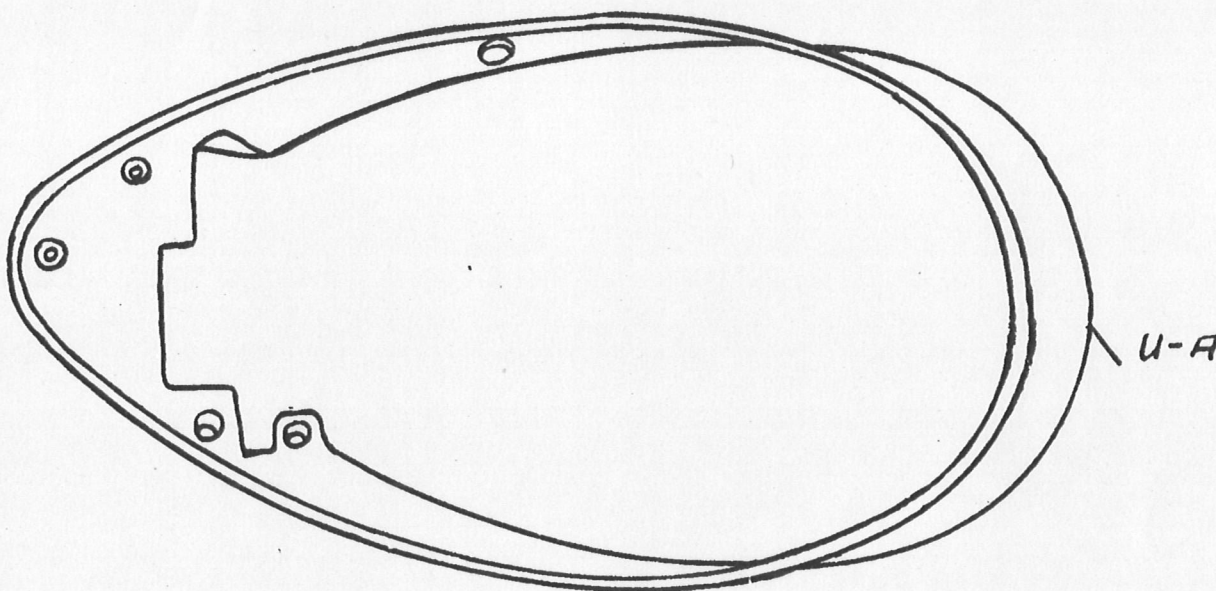
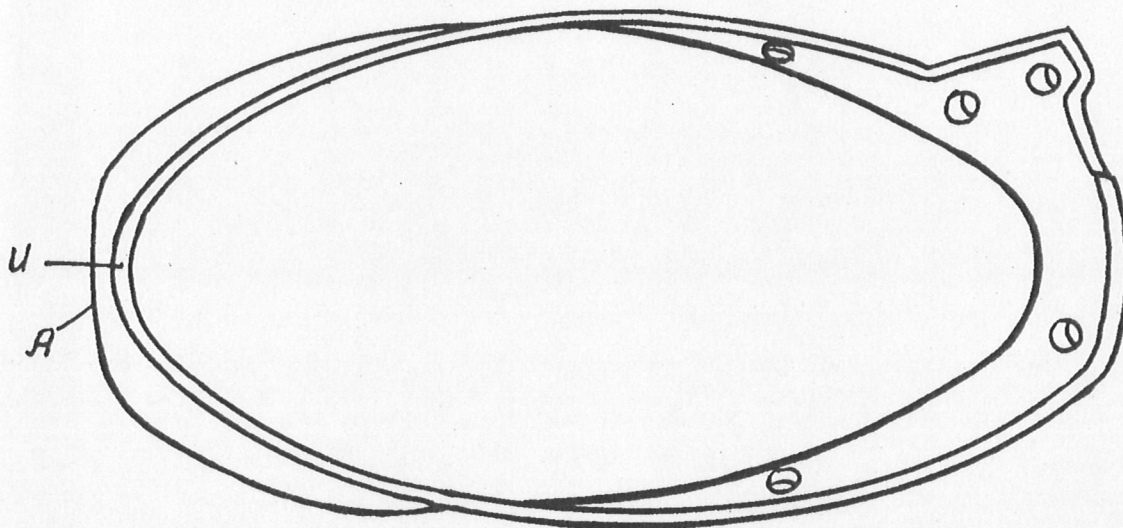
1. Alternate material steel 30KhN2MFA OST3-98-80.
2. 45.5...51.5 HRCe. Test hardness on blank.
3. Unspecified rounding off of radius should not be more than 15 mm.
4. * Dimensions are ensured by tool.
5. * dimensions not in projection.
6. Internal angle R=0.4 mm.
7. Blunt edges R=0.6 mm.
8. Displacement of axis of hole with dimension in square bracket ±0.02 for linear dimension and ± 40" for angular.
9. Surface finish Ц, Ю, Ш, H as per test specimen.
10. Tolerance along contour Ф and Э relative to surface K and hole T 0.2 mm. It is permissible check the contours Ф and Э relative to surface K and hole Y.
11. Tolerance on contours Ю, Ш, Ц, H 1 mm relative face Ч and axis of start of measurement.
12. Coating: Chem. Phos. Acc. Cr.
13. Mark with letter size PO-3 GOST 2930-62.
14. Stamp.
15. Local increase in dimensions Ф 30 A, to Ф 30.2 mm is permissible, except sections A, and B, is permissible.

First remarks
 Refer No.
 Duplicate Inv. No. / Sign & Date
 Alternate Inv. No.
 Sign & Date
 Inv. No.

					9-A-621.02.003		
Amend	Sheet	Doc. No.	Sign	Date	Camplate		
Developed by					Type	Weight	Scale
Checked by					О, I	3.3	1:1
Technician					Sheet	Sheets 1	
Head of bureau					Pipe 219X36 GOST 8732-78		
Head of Q.C.D					G30XH2MFA GOST 8731-87		
Approved by							

Technological process lay out for heat treatment				Sheet 1				
				sheets 2				
Article	Component No.	Nomenclature of component	Material grade	Weight of comp. kg.				
9-A-621	02.003	Cam plate	Steel 30KhN2MFA	~25				
			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							
	Components are delivered for heat treatment with accompanying sheet.							
0160	Inspection on steel scope.							
0170	Hardening in half blank.							
	1.Heating	El.furnace	850-870	60.	Oil 40-80°	4047	2	1
	Vertical furnace							
	2.Washing	Wash.machine	70-100					
0180	Tempering							
	Heating	Salt peter bathe	200-220	60.	Water, air	4012	1	1
0190	Filing of places for hardness checking.							
0200	Checking hardness.							
0210	Furnishing accompanying chart. Further machining..							
0480	Rechecking hardness of ready components (refer sheet 2)							
0485	Putting stamp "И" on components.							
0490	Furnishing accompanying chart.							
Technical condition for test				Carburization depth of layer,mm	Hardness HRC _E	Test place and test %	polishing	
C _s kg/mm ²	δ %	x %	ak, kgm/cm ²	Qty.and type of test samples		45.5-51.5	At point "A" 100% on flat	File, polishing wheel
				separable	impact			
Remarks								
				No.	Cause for amendment	Sign	Date	

Article	Comp.No.	Hardness Inspection chart after final machining
9-A-621	02.003	



	Hardness	Place and % of checking	Filing
	HRC _E 45.5-51.5		

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