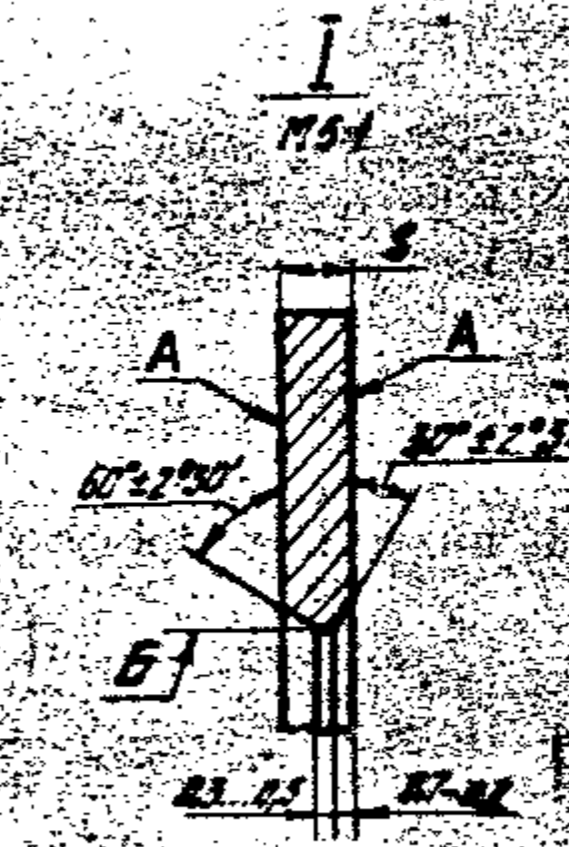
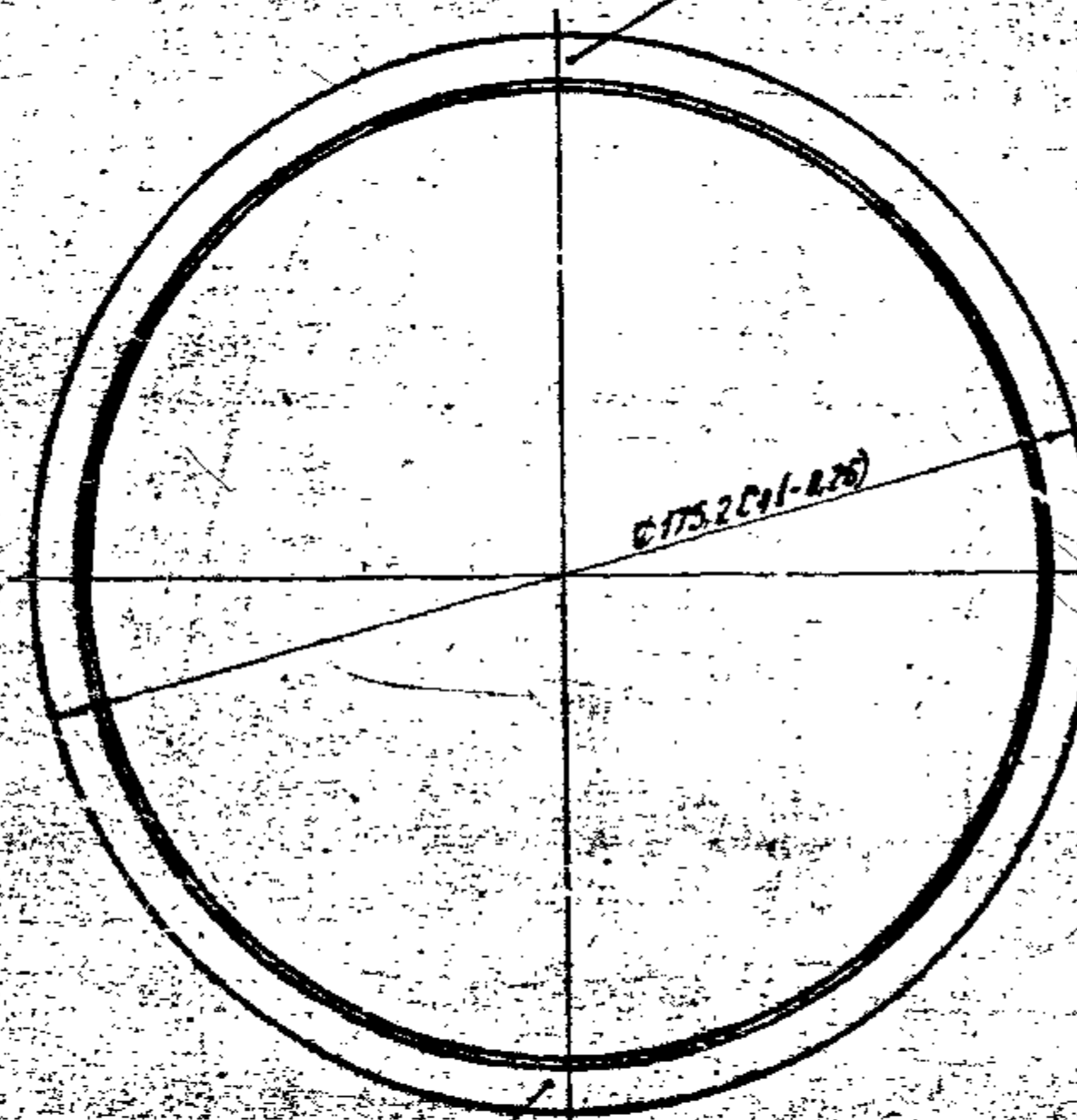


20-01-52



GROUPS OF RINGS AS PER SIZES					
1 GROUP	2 GROUP	3 GROUP	4 GROUP	5 GROUP	6 GROUP
1.8 ± 0.02	1.9 ± 0.02	2.0 ± 0.02	2.1 ± 0.02	2.2 ± 0.02	2.3 ± 0.02
INTERMEDIATE GROUPS OF RINGS AS PER SIZES					
1-2	2-3	3-4	4-5	5-6	
1.85 ± 0.02	1.95 ± 0.02	2.05 ± 0.02	2.15 ± 0.02	2.25 ± 0.02	

EXPLANATORY NOTE :

8. REFERENCE MATERIAL QUOTED :- PIPE M3 П P 180x15 GOST 617-72.

M3 = MATERIAL GRADE.
180 = OUTER DIAMETER.
15 = WALL THICKNESS.

CHEMISTRY (M3 AS GIVEN IN GOST 859-78)
Cu + Ag = 95.5 (min) (Ag. S SHOULD NOT EXCEED 0.003%)^(A)
99.5

IMPURITIES

BISMUTH	=	0.003 max
ANTIMONY	=	0.05 max
ARSENIC	=	0.01 max
IRON	=	0.05 max
NICKEL	=	0.2 max
LEAD	=	0.05 max
TIN	=	0.05 max
SULPHUR	=	0.01 max

PHYSICAL PROPERTIES :

MATERIAL CONDITION	=	EXTRUDED
TENSILE STRENGTH	=	19 Kgf/mm ² (min)
ELONGATION	=	30 % (min)

EXTRUDED PIPE SHOULD WITH STAND HYDRAULIC PRESSURE CALCULATED BY FORMULA

$$P = \frac{1100 \times S}{D_i}$$

WHERE S = WALL THICKNESS
D_i = INTERNAL DIAMETER

TESTING AT 70 Kgf/cm² CAN BE DONE UPON MUTUAL AGREEMENT.

^(B) * CB 20-01-00-B

- INSPECTION GROUP IV AS PER TECHNICAL REQUIREMENTS 11-11 HB 43 TO 50: CHECK HARDNESS OF ONE ANNEALED RING FROM THE BATCH OF 50 PIECES MADE OF ONE AND THE SAME BLANK (PIPE) DIFFERENCE IN HARDNESS OF THE PARTS UNDER CHECK SHOULD NOT EXCEED 5.
- SURFACES A SHOULD BE KEPT FREE FROM METALLURGICAL DEFECTS VISIBLE TO THE NAKED EYE DENTS, NICKS, NOTCHES DIRECTED RADIALLY NOTCHES WHICH ARE NOT MORE THAN 0.1MM DEEP AND NOT DIRECTED RADIALLY ARE ALLOWED IF THEY ARE 4MM SHORT OF SURFACE 5.
- RINGS SHOULD BE ARRANGED BY GROUPS AS PER SIZES.
- IT IS ALLOWED TO MANUFACTURE 25 PERCENT (MAX) OF RINGS AS PER SIZE 5 OF INTERMEDIATE GROUPS BY MARKING THEM AS INDICATED IN TABLE.
- GRINDINGS OF SURFACES A DRESSING OF SURFACES A NICKS, NOTCHES AND OTHER DEFECTS ON SURFACES A ARE NOT ALLOWED DRESSING OF SURFACES IS ALLOWED AS PER TECHNICAL REQUIREMENTS.
- APPLY STAMP BY USING ACID-FREE METHOD USING ACID-FREE METHOD USING TYPE TIO-5 GOST 2930-62.
- MARK GROUP NUMBER AS PER SIZE 5 USING ACID-FREE METHOD USING TYPE TIO-5 GOST 2930-62.

** CQA (HV) 5.06.001E
* PPE 10
* P 180x15 GOST 617-72 * KVD 10 63018

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

B	19-03-15	Pl. 11 of 2th All. Comm. Meeting Dt. 11-4-12	EST. MASS 0.07 Kg	TO BE STAMPED OR MARKED WHERE INDICATED IN THIS DRAWING (LETTERS)
A	20-01-52	AUTHY. CEP LE No. 2721	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL :- * SEE ABOVE	USED ON :- ** CB 20-01-00-B
DRN	19/03/52	SCALE :- 1:1	DIMENSIONS IN mm	
ENG	19/03/52	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APPD	19/03/52	ALL THREADS CONFORM TO	TITLE :- GAS JOINTSEALING RING	
DATE	19/03/52		D S CAT NUMBER	DRAWING NUMBER 20-01-52

KVD No. 63018

(A7)

