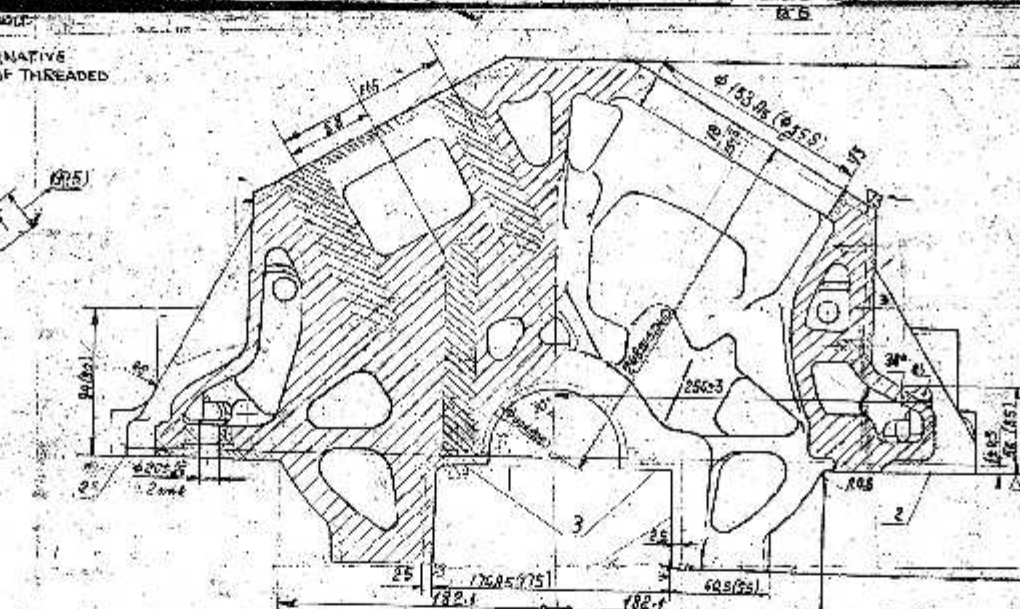
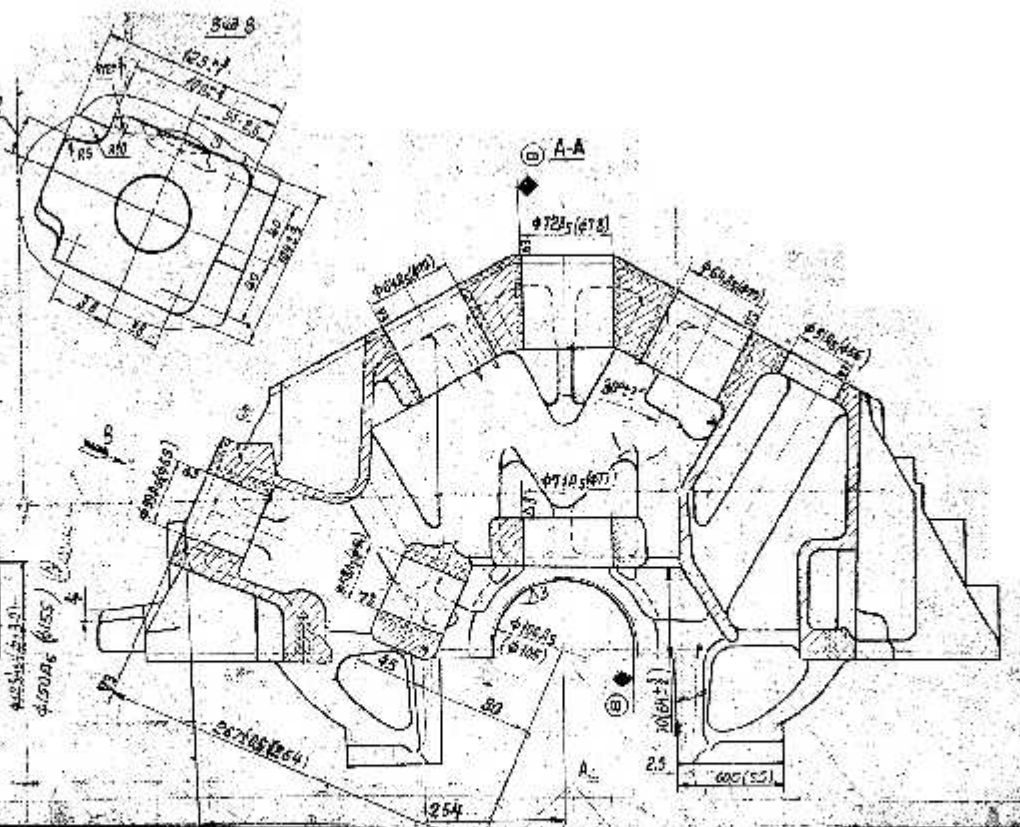
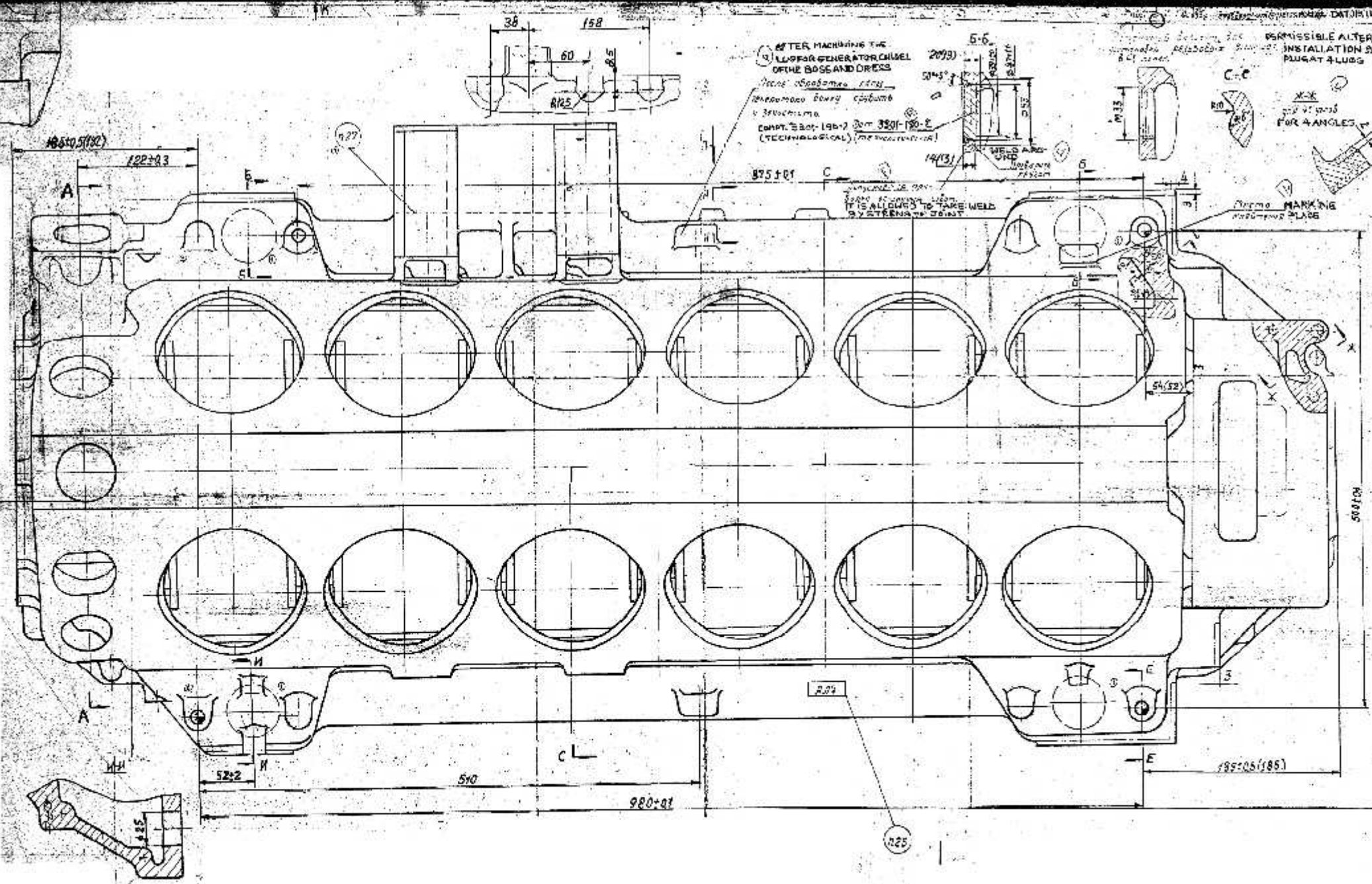
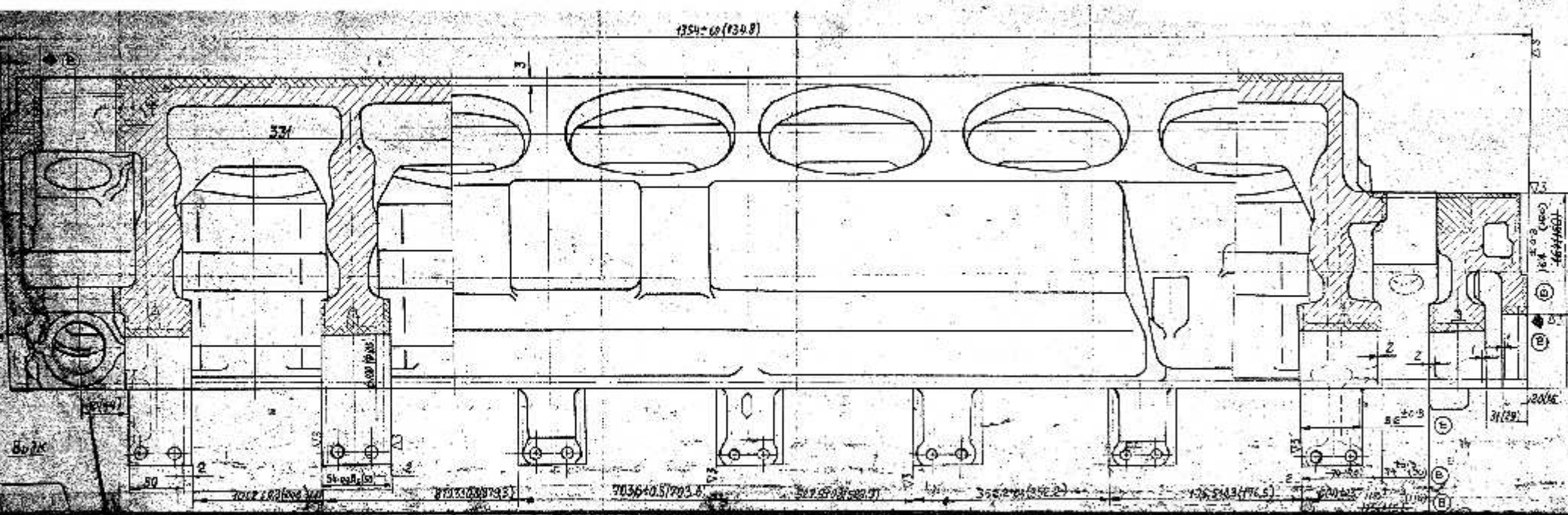


1754-60 (130.8)



1. REQUIREMENT FOR CASTING AS PER TECHNICAL REQUIREMENT...
2. INTERNAL AND EXTERNAL UNMACHINED SURFACES EXCEPT THE MAIN PATTERN SHOULD BE FINISHED WITH SILEXITE.
3. SURFACE FINISH OF THE UNMACHINED SURFACES SHOULD CONFORM TO THE STANDARD.
4. PENNANT TEST OF WATER PASSAGE SHOULD BE DONE BEFORE THE CASTING OF 4-8 MM JUNE TEMPERATURE 70-80°C SHOULD BE DONE FOR 5 MIN. BEFORE CASTING AND AFTER CASTING TEST SHOULD BE DONE IN THE LUB.
5. CASTING DIMENSIONS WITHOUT THE PARTS SHOULD BE DONE UP TO 300 MM WITH AN ACCURACY OF ±0.15, ABOVE 300 MM WITH AN ACCURACY OF ±0.2, ABOVE 600 MM WITH AN ACCURACY OF ±0.3, ABOVE 1000 MM WITH AN ACCURACY OF ±0.4.
6. CASTING WALL THICKNESS UP TO 10 MM SHOULD BE DONE WITH AN ACCURACY OF ±0.15, ABOVE 10 MM WITH AN ACCURACY OF ±0.2.
7. UNSPECIFIED CASTING RADIUS SHOULD BE 2-3 MM.
8. SYMBOL ϕ INDICATES DRYING SURFACES.
9. DIMENSIONS GIVEN IN BRACKETS ARE FOR FINISH MACHINED SURFACES.
10. ROUNDS OF SURFACES ϕ OVER THE PARTING LINE SURFACE SHOULD BE ALLOWED.
11. SUPERFINISH OF SURFACE 2 AND 3 NOT MORE THAN 0.5 MM.
12. NON PERpendicular OF SURFACE A, 2 AND 3 ON A LENGTH OF 100 MM, NOT MORE THAN 0.5 MM.
13. BUCKLING ALONG THE SURFACES A, 2 AND 3 NOT MORE THAN 0.5 MM.
14. SHIFT OF SURFACE 2 AND 3 WITH RESPECT TO THE VERTICAL PLANE WHICH GOES THROUGH THE MAIN BRACING JOURNAL AIS, SHOULD NOT EXCEED 0.5 MM.

SK-E/1013001

NOMENCLATURE DRAWING	
CRANK CASE, UPPER	8801-16-84
(CASTING)	8801-16-24
AFTER ZERO OPERATION	
DATE	29/2
APPROVED	
DRAWN	