

DRG. NO: FS- 3227

6 Characteristics of special-purpose phenol-polyvinylacetyl varnishes:

Special-purpose phenol-polyvinylacetyl varnishes are solution of glue БФ-4 in ethyl alcohol. The varnish is a transparent slightly cloudy homogeneous liquid of a light yellow to dark yellow color without mechanical impurities.

Varnishes ВЛ-7-3, ВЛ-7-5, where: ВЛ - varnish designation by chemical composition (phenol-polyvinylacetyl varnish);

7 - varnish group of purpose;

3, 5 - weight ratio of dry phenol-polyvinylacetyl residue.

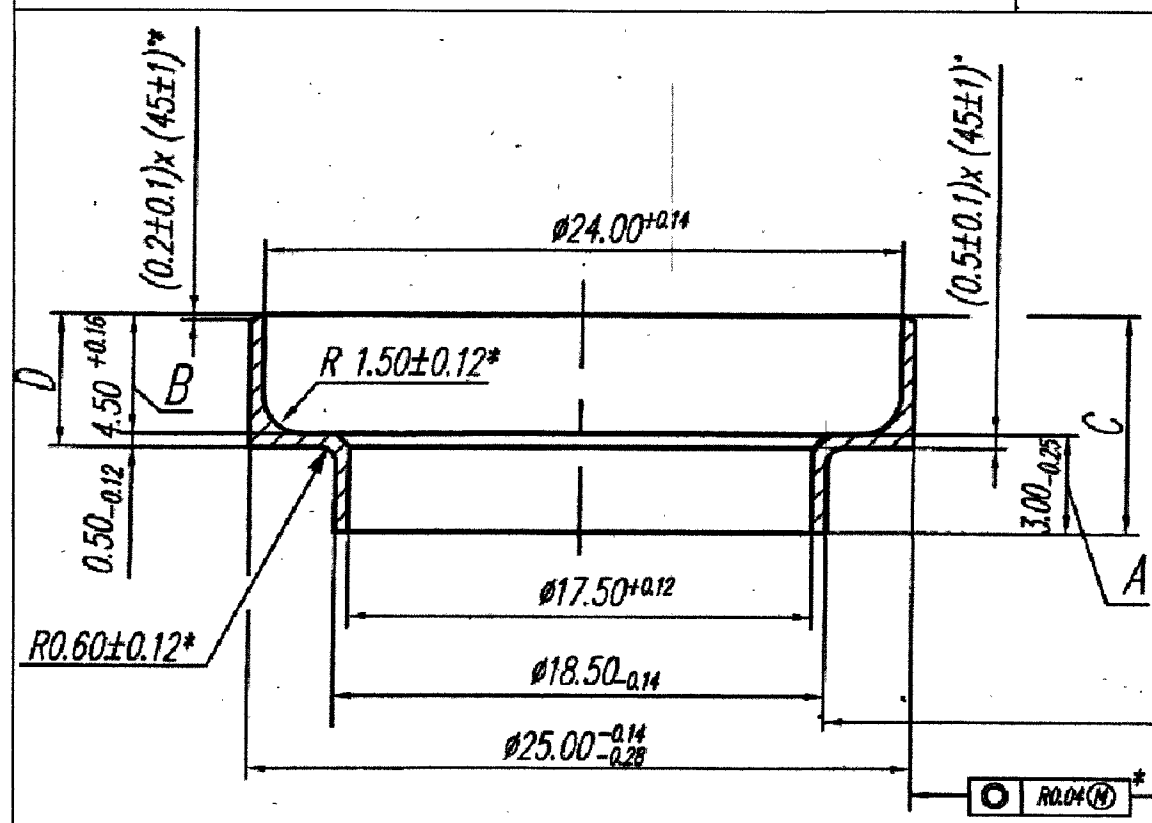
Varnish ВЛ-7-3 is intended for varnishing of parts and products; varnish ВЛ-7-5 - for varnishing, sealing and glueing of parts and products.

Operating temperature of varnish coatings: from minus 60 to plus 80 °C - unlimited in time; at plus 150 °C - for 5 hours.

Phenol-polyvinylacetyl varnishes are a flammable, non-explosive material. Ethyl alcohol is inflammable liquid: maximum allowable concentration (MAC (ПДК)) in production floor area working air - 1000 mg/m³; flash-point - plus 13 °C.

The shelf life of the varnish is 6 months after the manufacture date.

- 1 Anneal at the temperature of 500 to 600 °C. Dimensions shall be checked before annealing.
- 2* Dimensions are provided by the measuring instruments.
- 3 Coating 06/ varnish ВЛ-7-5.
- 4 The following is allowed:
 - a) Sheet ДПРНМ 1,0М1, ДПРНМ 1,0М2 GOST 1173-2006;
 - b) tape ДПРНМ 1,0НДМ1, ДПРНМ 1,0НДМ2 - or ДПРНМ 1,0НДМ3 GOST 1173-2006;
 - c) use the die forming method;
 - d) varnish ВЛ-7-3 and varnish ЛШ-5 OST 84 811-2002;
 - e) replace dimensions A and B with dimensions C = 7.50_{-0.36} mm and D = 5.00_{-0.16} mm respectively;
 - f) insignificant scores and dents on the parts outer surface with no damage to the coating.
- 5 The part shall have no cracks, scabs, cavities, holes, deep pot holes, scratches, unevenness.



ALT. MAT: -

- IS:14811-2000 IN 'O' CONDITION. CHEMICAL COMPOSITION AS PER IS:191-2007 GRADE Cu FRTP-2. (REF. NO. CQA(M)/QA-2/T-72/FSAPDS/MANGO/VOL.12)
- SHELLAC BASED APC TO SPEC JSS 8010-63:2016 (Rev.4)

$\sqrt{Rz20(\checkmark)}$

DIMENSIONS ARE IN mm				MATERIAL: SHEET 1,0 M3 GOST 1173-2006		आर्डनैन्स फैक्टरी अम्बाझरी	
THIRD ANGLE PROJECTION				NOMENCLATURE: BUSH		ORDNANCE FACTORY AMBAZHARI	
SCALE - NTS				M/C:		DRG. NO: FS- 3227	
2021				STORE:		REVIEW NO: 0	
DRAWN		NAME		DATE		SHEET NO: 1	
CHECKED		SIGNATURE		DATE		NO. OF SHEETS: 1	
HOS/CDD		SIGNATURE		DATE		OPERATION NO:	
VERIFIED BY		SIGNATURE		DATE		COMPT:	
APPROVED BY		SIGNATURE		DATE			
REV.	DATE	DESCRIPTION	SIGN.	AMENDMENTS			