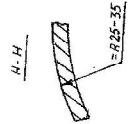
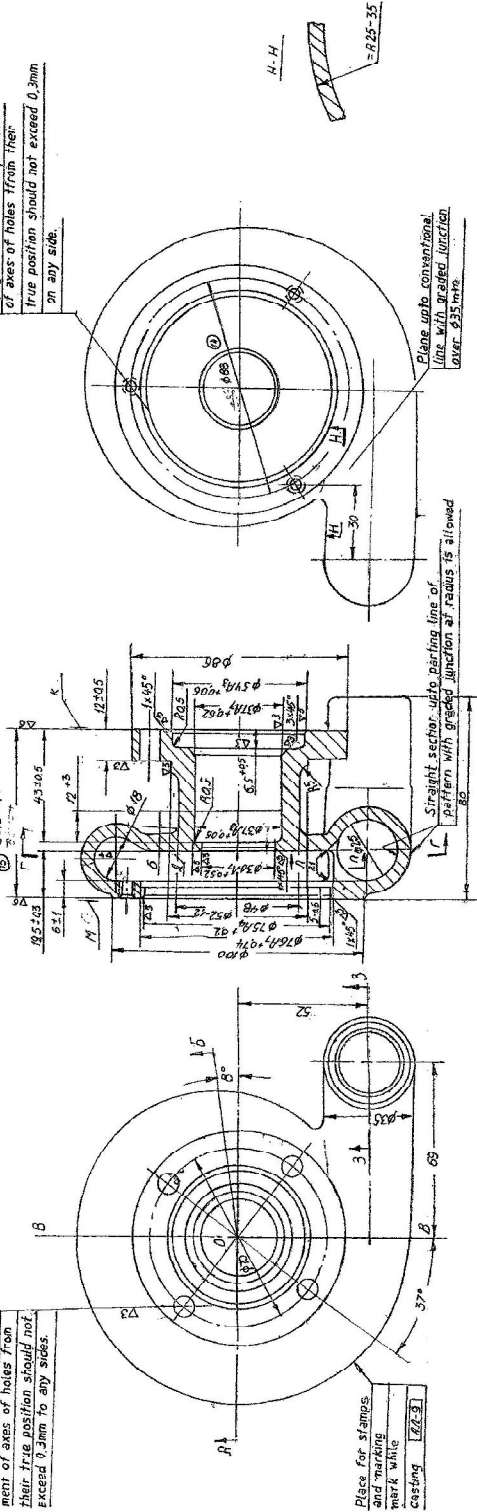


Unless otherwise specified.

1. Permissible pattern draft should not exceed 1:20 forward body increase.
2. Unfinished casting radii R are 3mm.
3. Permissible deviations for rough dimensions are as per class A GOST 209-75.
4. Casting should be cleaned from sand, burr, spot and flash.
5. The following is allowed with respect to Ø5K and burr-end "x":
  - a) run out of Ø75, Ø37 A<sub>1</sub> and Ø37 A<sub>2</sub> should not exceed 0.2mm.
  - b) run out of Ø30 should not exceed 0.3mm.
  - c) end play of surfaces "H" and "K" should not exceed 0.3mm.
6. Countersink all the threaded holes at angle 120° upto external diameter of threads.
7. Burrs are not allowed.
8. Bachelize internal non-machined surfaces.
9. After machining perform test for tightness with water at pressure of 1 atm. in this case leakage is not allowed.
10. Pump body may be made from alloy of AL-5 GOST 2885-75.
11. Other technical requirements for casting should be in compliance with Technical specifications (T1) in force for non-ferrous casting.
12. Mark "A.1.9" by embossing stamp or by means of casting. Depression of letter should not exceed 0.1mm and projection should not exceed 0.2mm.
13. Holes of Ø9 mm and 15 mm may be reduced by 0.1mm.
14. Check dimension of Ø16 in area of web (see section p-p).
15. For final machined part check possibility of setting bolt M6 Ø12x36019 GOST 1798-70 in hole of Ø9 mm from side of scroll, for providing transition of bolt machining or additional grinding is allowed to depth upto 2mm.

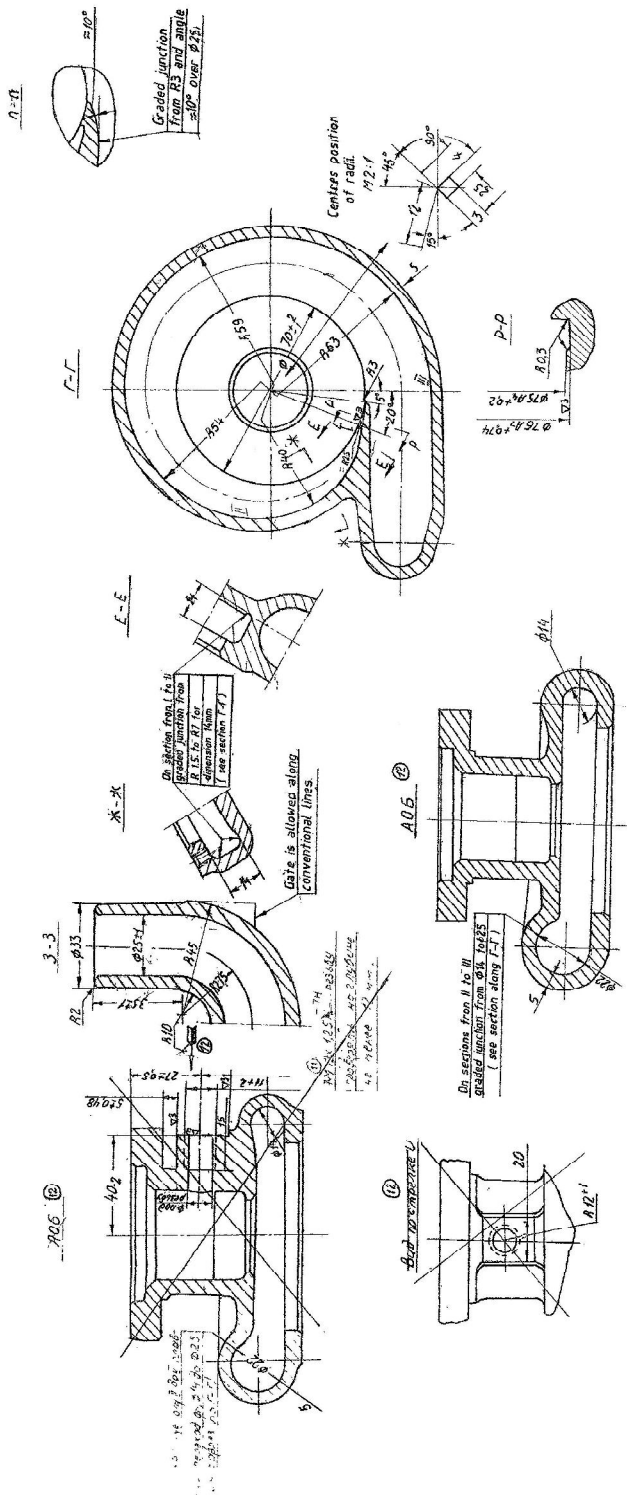
3 holes M6x1.7H equally spaced along circumference. Displacement of axes of holes from their true position should not exceed 0.3mm in any side.

4 holes Ø34±0.2K equally spaced along circumference. Displacement of axes of holes from their true position should not exceed 0.3mm in any side.

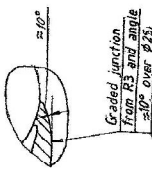


Place up to conventional limit with graded junction. Over 0.25mm

Straight sector upto parting line of pattern with graded junction. Radius is allowed



H-H



Place up to conventional limit with graded junction. Over 0.25mm

Straight sector upto parting line of pattern with graded junction. Radius is allowed

| DATE     | ISSUE | AMENDMENT                |
|----------|-------|--------------------------|
| 01.05.75 | 1     | 1. RADIATION TEST ADDED. |

NOTE- CASTING SHOULD BE TESTED FOR RADIOGRAPHIC TEST AS PER ASTM E-155-2000 LEVEL-1

USED ON: 5-83-78-4

| APPROVED | CHECKED | CONTROL RATE OF INSPECTION (ICV) | PUMP BODY | 0.08 | 1.17 | 1.50 | 3.1 |
|----------|---------|----------------------------------|-----------|------|------|------|-----|
|          |         |                                  |           |      |      |      |     |