

- Casting with soil form.
- Technical requirements for casting as per OST 3 - 4227 - 79. Check casting by x ray exposure as per OST 3 - 4227 - 79 point 4.10. On non machined surfaces of casting are permissible cavity units, slag inclusions, clogs and other defects present after carrying out finishing with diameter not more than 7 mm. Rough defects should not be above 1/3 of wall thickness of casting, but not more than 5 mm. Number of defects should not be more than 4 100 sq.cm area. Numbers of defects not more than 30 on casting are permissible. Thin surface porosity on 25% area of non machined surfaces is permissible, with number of pores on 1 sq. cm up to 5 numbers with diameter up to 2 mm.
- On machined surfaces of casting are permissible cavities, clogs, other defects present after carrying out finishing of them with diameter not above 6 mm, depth 4 mm with conditions that from opposite sides in that cross section are not similar defects. Number of defects should not be more than 3 numbers on 100 sq. cm area with condition of positioning of defects from each other at distance not less than 10 mm. Number of defects on casting not more than 30 numbers are permissible. Small defects with diameter up to 2 mm are permissible.
- Drafts as per GOST 3212 - 92.
- Unless otherwise specified radii of inner angles R = 3 mm, outer angles R = 5 mm.
- Casting accuracy 11 - 0 - 0 - 11 GOST 26645 - 85.
- Surface finish of non machined surfaces as per standard.
- Unspecified allowance for machining 8 mm.
- Harden as per mode T4.
- Check hardness HB on separately casted specimen.
- Displacement in casting on mould joints not more than 5 mm is permissible.
- *Dimensions are not certified.
- Mark П by casting with letter size 18P3 GOST 26008 - 85.
- Stamp.

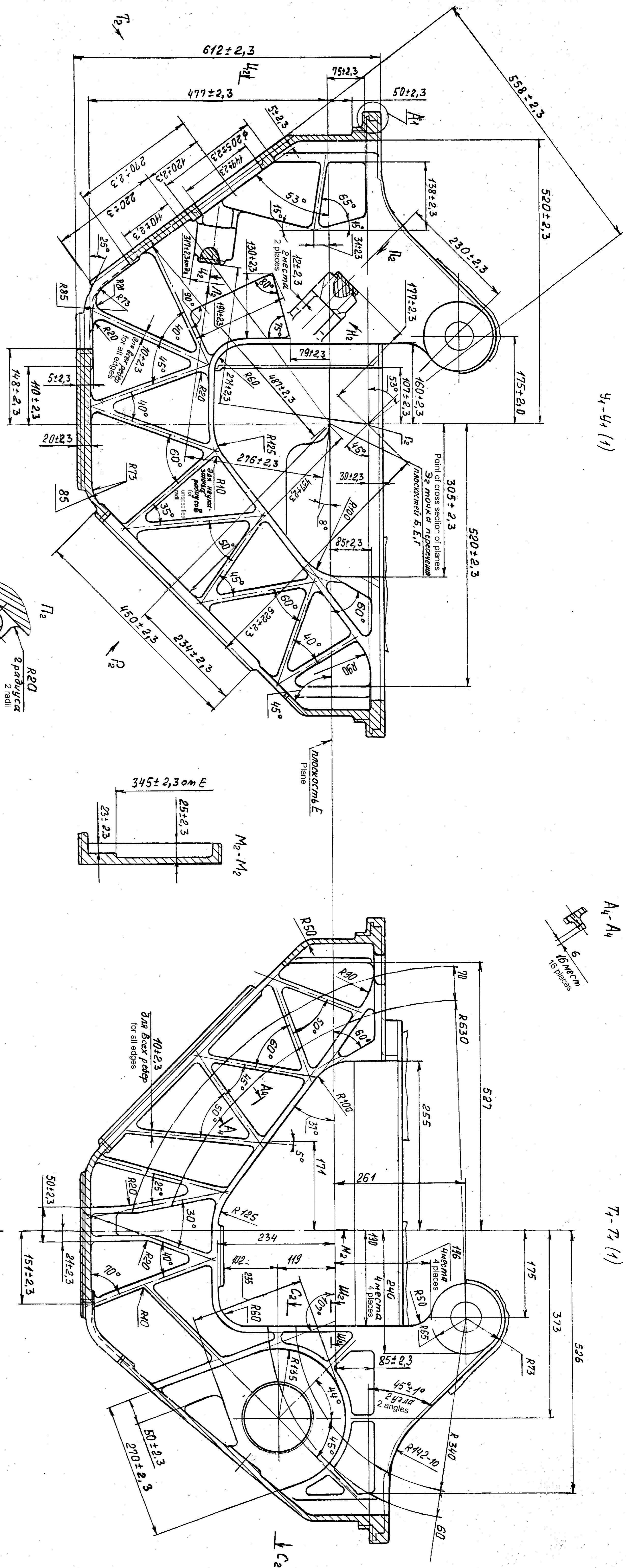
Inv. No.	Sign & Date
Alternate Inv. No.	Duplicate Inv. No.
Sign & Date	Sign & Date

AK-630 102-47				Type	Weight	Scale
Carriage				A	170.0	1:4
Casting				Sheet 1 of 3		
Approved by						

U₁-U₁ (1)

A₁-A₁

T₁-T₂ (1)



A₁ (1:1)

T₂

T₁

P₂

