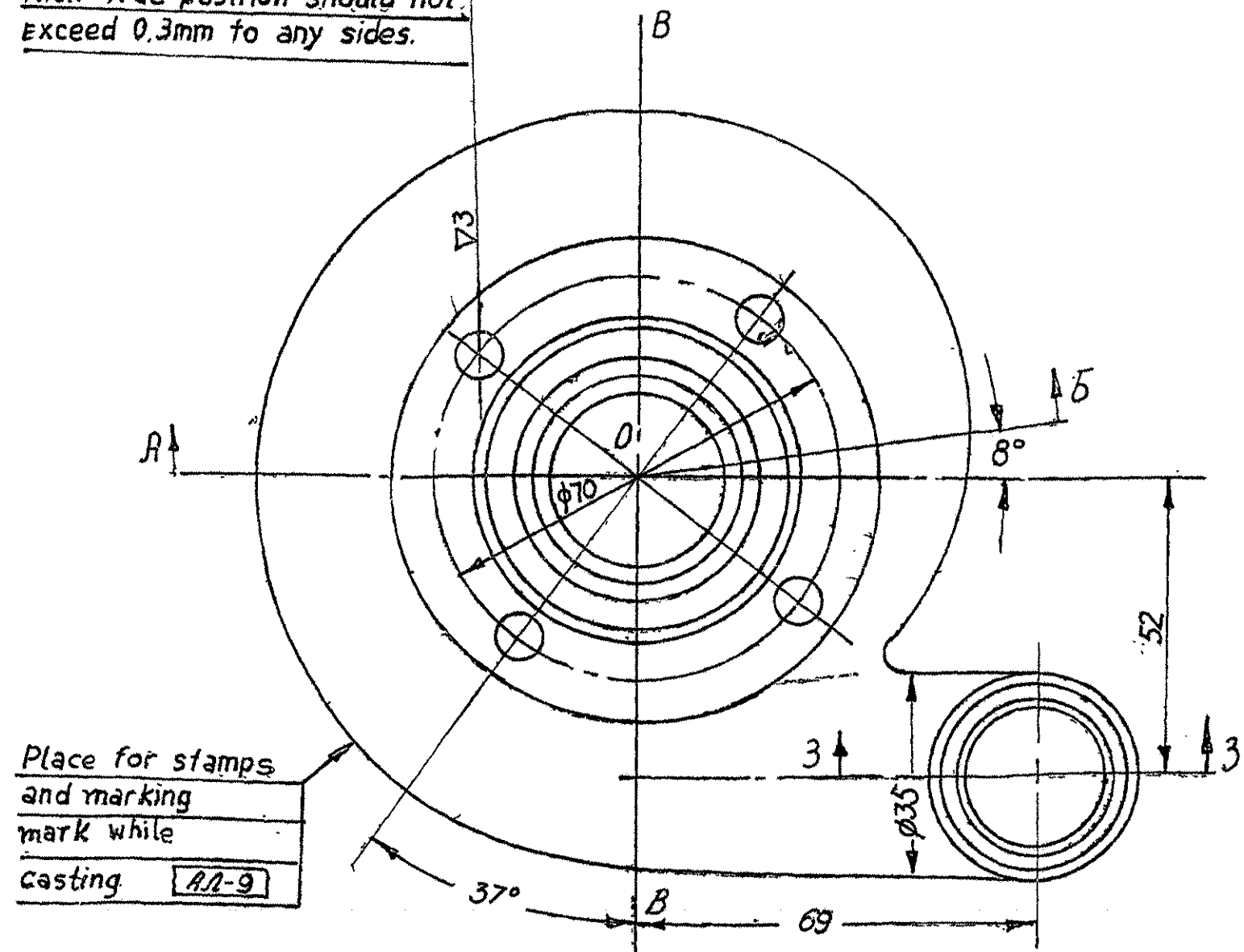
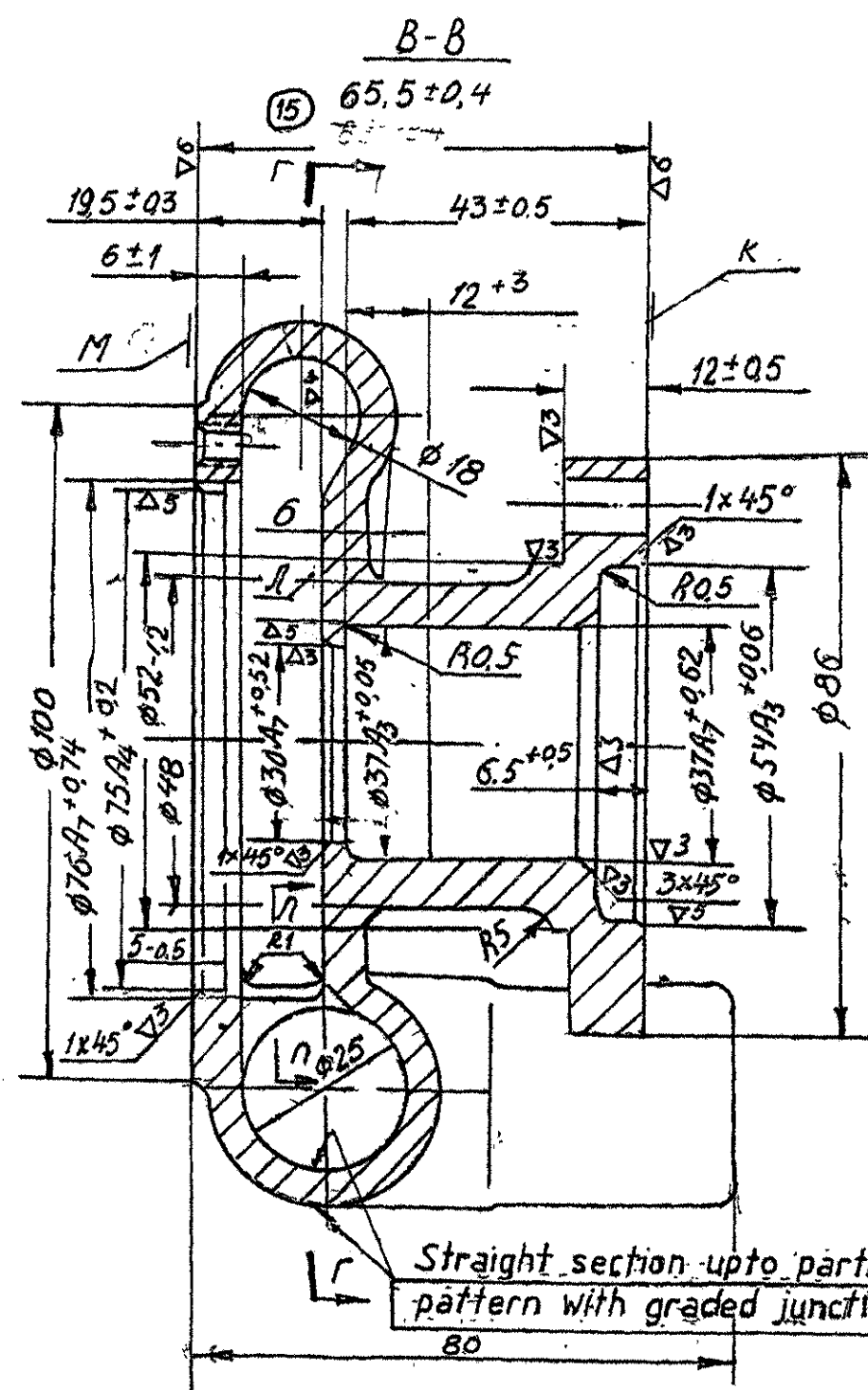


4 holes $\phi 9A_7^{+0.36}$ equally spaced along circumference. Displacement of axes of holes from their true position should not exceed 0.3mm to any sides.

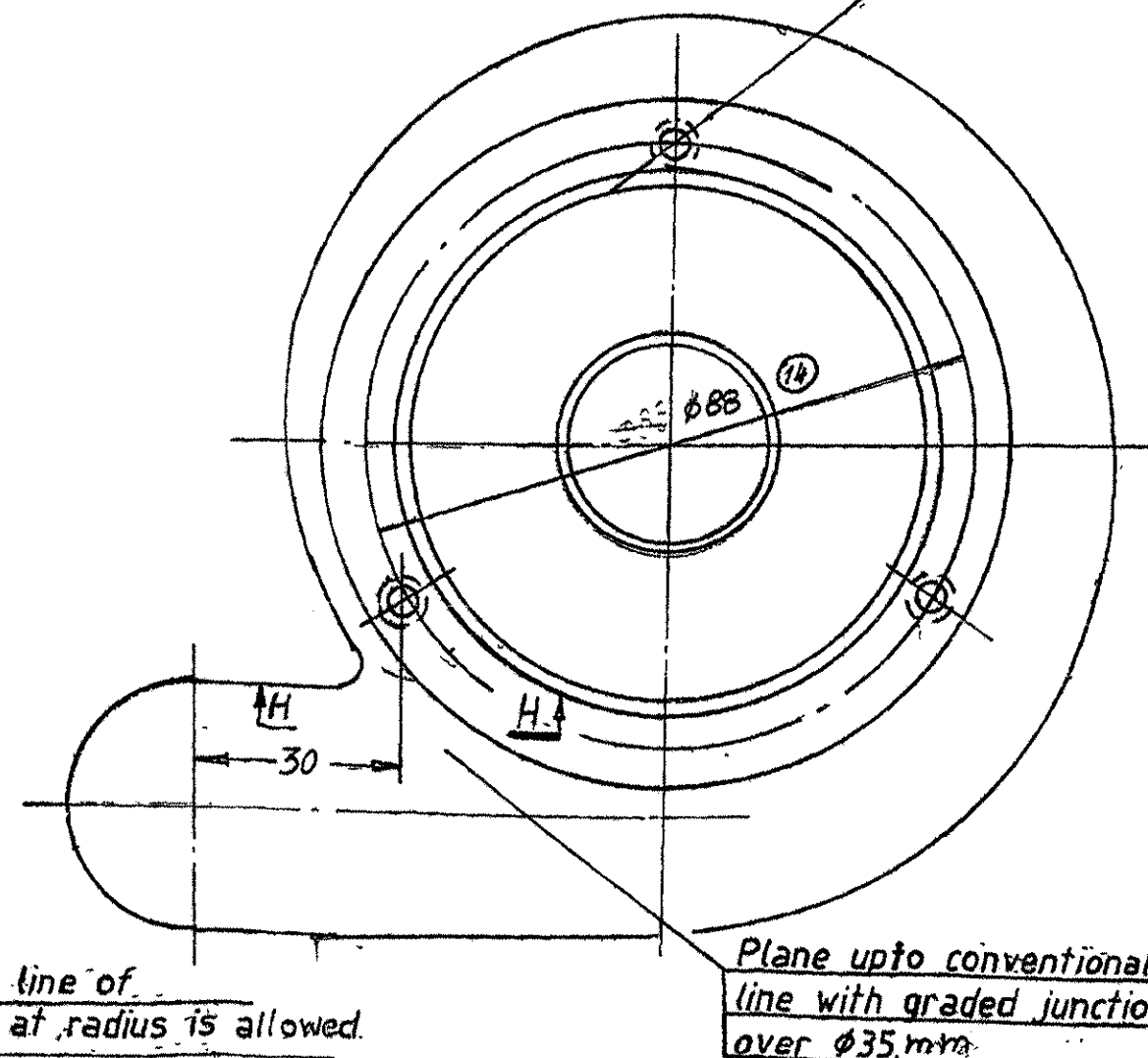


Place for stamps and marking mark while casting **A1-9**



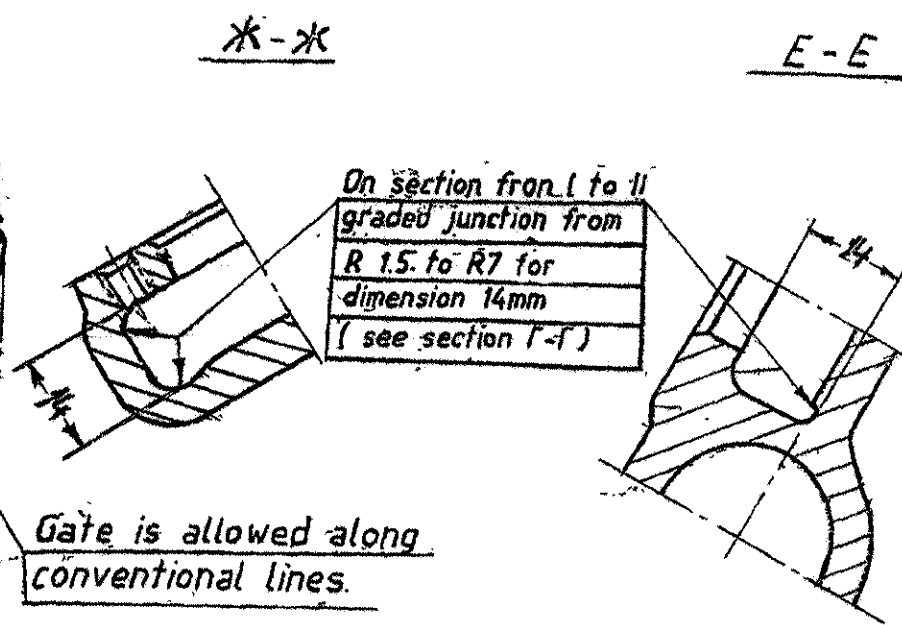
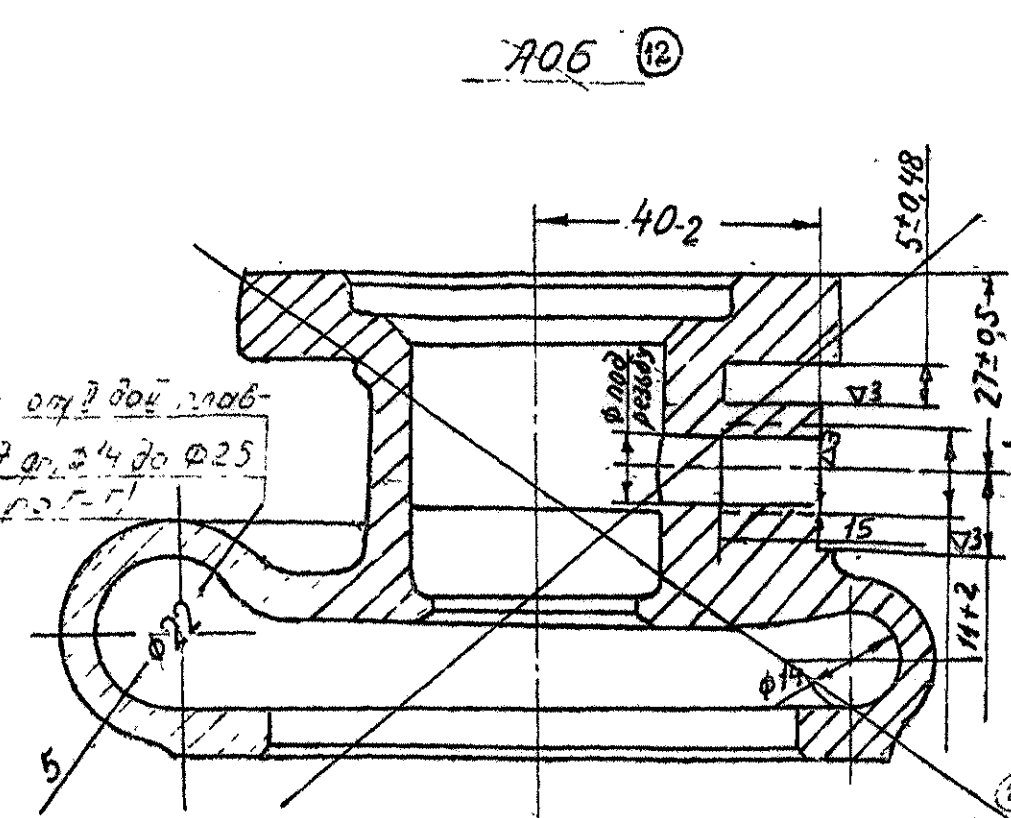
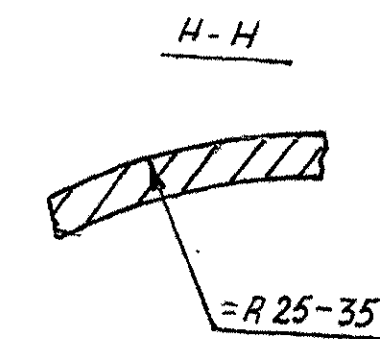
Straight section upto parting line of pattern with graded junction at radius is allowed.

3 holes $M6 \times 7H$ equally spaced along circumference. Displacement of axes of holes from their true position should not exceed 0.3mm on any side.

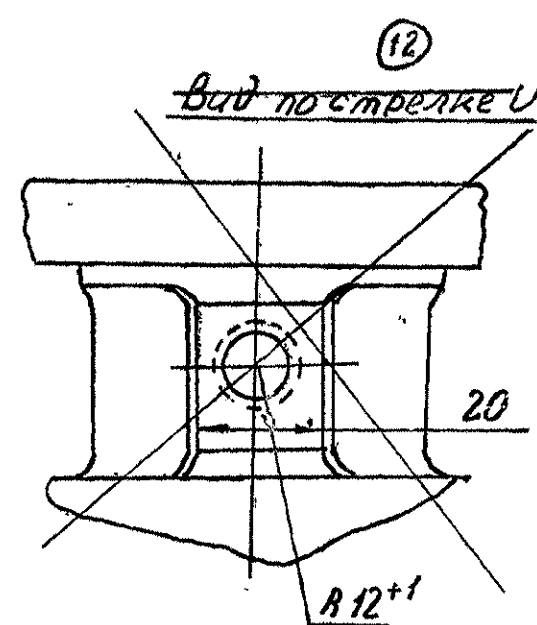
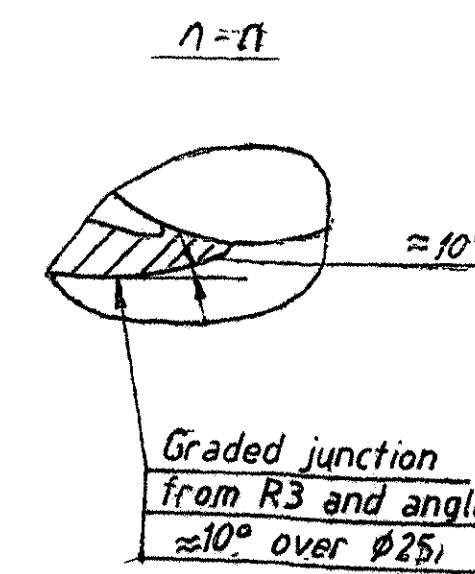
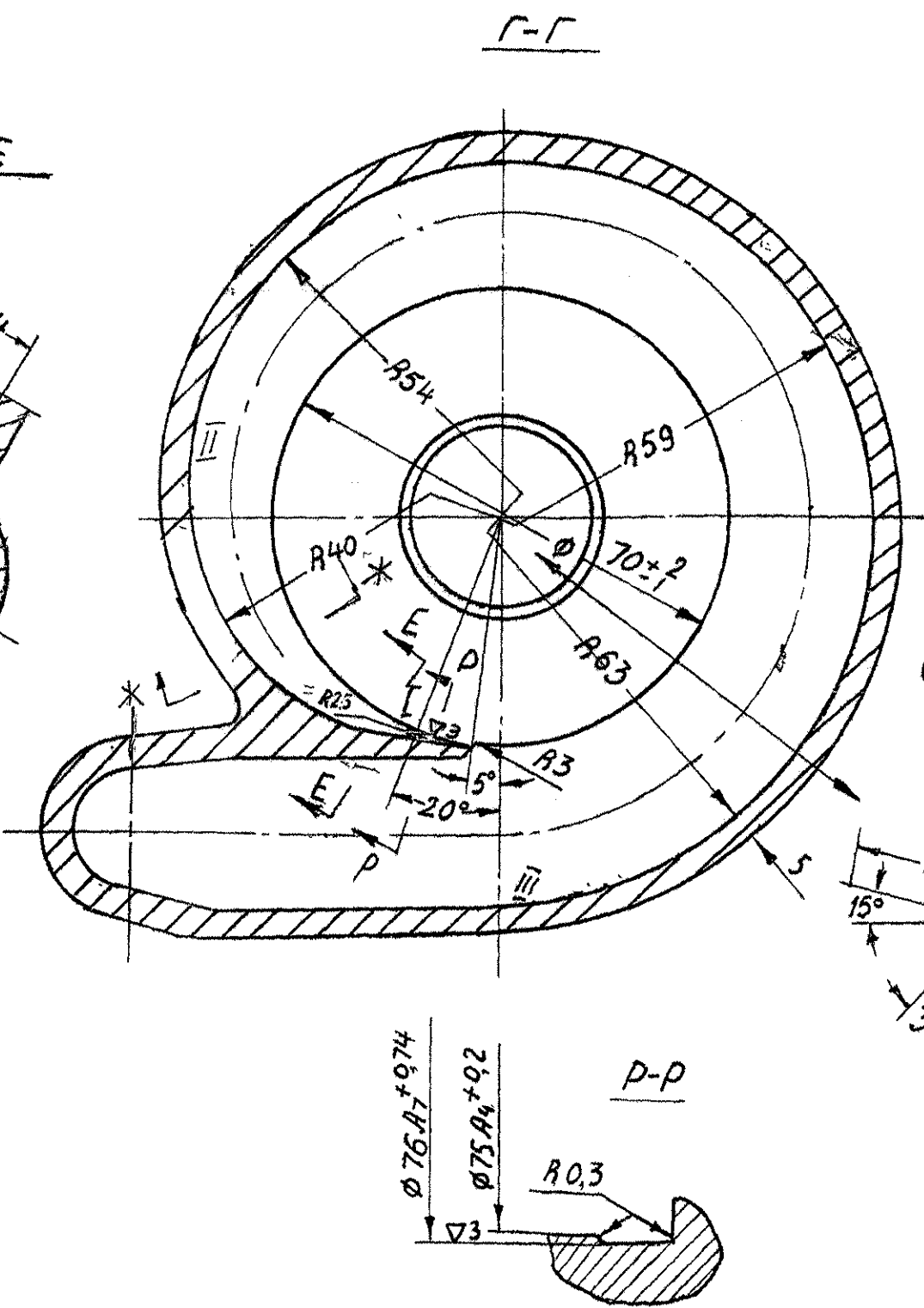


Plane upto conventional line with graded junction over $\phi 35$ mm.

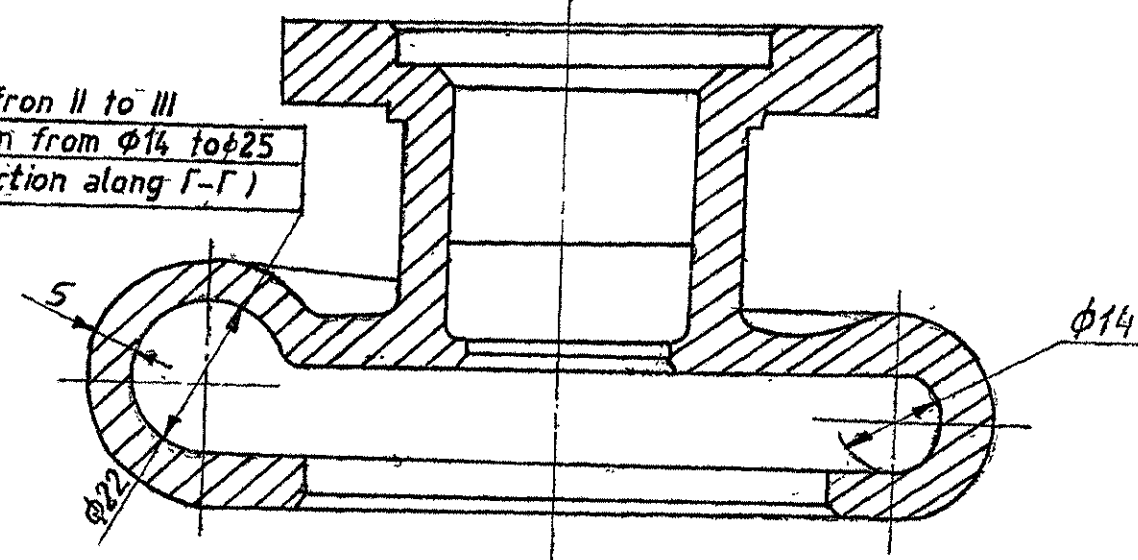
- 1 Permissible pattern draft should not exceed 1:20 towards body increase.
- 2 Unspecified casting radii R are 3mm.
- 3 Permissible deviations for rough dimensions are as per class II GOST 2009-55.
- 4 Casting should be cleaned from sand, burnt spot and other layers.
- 5 The following is allowed with respect to $\phi 54$ and butt-end "K":
 - a) run out of $\phi 75$, $\phi 37 A_7$ and $\phi 37 A_3$ should not exceed 0.2mm.
 - b) run out of $\phi 30$ should not exceed 0.3mm.
 - c) end play of surfaces "N" and "M" should not exceed 0.15mm.
- 6 Countersink, all the threaded holes at angle 120° upto external diameter of threads.
- 7 Burrs are not allowed.
- 8 Backelize 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 2685-75.
- 11 Other technical requirements, for casting, should be in compliance with Technical specifications (TY) in force for non-ferrous casting.
- 12 Mark **A1-9** by embossing stamp or by means of casting. Depression of letter should not exceed 1mm and projection should not exceed 2mm.
- 13 Holes of $\phi 9$ mm and $\phi 5$ mm may be reduced by 0.1mm.
- 14 Check dimension of $\phi 75$ in area of web (see section p-p).
- 15 For final machined part check possibility of setting bolt M8 $60 \times 25.46.019$ GOST 7796-70 in hole of $\phi 9$ mm from side of scroll. For providing transition of bolt machining or additional grinding is allowed to depth upto 2mm.



Gate is allowed along conventional lines.



On sections from II to III graded junction from $\phi 14$ to $\phi 25$ (see section along G-G)



01066-1CV	DS CAT No. LV2/ICVS-4730-077401 ADDED.
01/10/09	
DATE	ISSUE
	AMENDMENT

USED ON: 54-83-78-A

APPROVED	54-83-004-1
CHECKED	DS CAT No. LV2/ICVS-4730-077401
CONTROLLERATE OF INSPECTION (ICV)	PUMP BODY
	A1-9
	GOST 2685-75