



1. MATERIAL SUBSTITUTE 414N GOST 2648-75.
2. REQUIREMENTS TO CASTINGS ACCORDING TO GOST 3-4271-79, GROUP II AND SPEC. AA 310-5/17, EDITION 3. CASTING ACCURACY IS 8-9T GOST 26445-86, 10B 3/0.
3. NON-INDICATED RADII OF CASTING ARE 3...5mm.
4. HOLE THREADS 3 AND 9 ACCORDING TO NORMAL 8520-12 (ISSUE 7), THREAD 8 ACCORDING TO NORMAL 8520-14 (ISSUE 7).
5. NON-INDICATED LIMIT DEVIATIONS OF DIMENSIONS: $M14 \pm 0.14$, $M14 \pm 0.14$.
6. POSITIONAL ALLOWANCE OF THE AXES OF HOLES K, FROM THE AXIAL PLANE PASSING THROUGH THE AXIS OF TWO EXTREME OF THEM IS 0.03mm.
7. CHECK THE SQUARENESS OF FACE C, BY BLENDING TO THE AXIS OF HOLE K, THE BAND SHOULD BE CONTINUOUS, THE TRACE - 80% MIN OF THE SURFACE.
8. IT IS ALLOWED TO CHECK THE SQUARENESS OF THE SURFACES OF FACINGS TO THE AXES OF THE CORRESPONDING THREADS WITH CALIBRE BY BLENDING. THE BAND SHOULD BE CONTINUOUS ALONG THE CIRCLE.
9. IT IS ALLOWED TO CHECK THE FLATNESS ALLOWANCE OF SURFACE F, IN UNIT C.6.20-27-01-7.
10. CIRCULAR CLEARANCES (DEPRESSIONS) OF WHICH 3mm MAX ARE ALLOWED ON SURFACE H; CHECK THE FORM DEVIATIONS OF SURFACE H, BY BLENDING, THE ALLOWING SHOULD BE UNIFORM AND CONTINUOUS, 75% MIN OF THE SURFACE.
11. IT IS ALLOWED TO CHECK THE RUNOUT ALLOWANCE OF SURFACE H; IN G.20-27-01-7.
12. FINISH ACCORDING TO THE DIMENSIONS IN THE CIRCULAR BRACKETS IN THE UNITS:
 H₁ - ACCORDING TO G.20-27-01-4
 H₂ - ACCORDING TO G.20-27-01-7
 H₃ - ACCORDING TO G.20-27-01-7
13. IT IS ALLOWED TO MAKE HOLE M₂ OF $\phi 0.5$ mm.
14. IT IS ALLOWED TO PLACE HOLES A₂ ON ANY SIDE OF HOLE K₂.
15. BACKGROUNDS ARE ALLOWED ON SURFACE B.
16. CAST THE CAST, NON-INDICATED SURFACES OF THE INNER HOLLOW CLEAN.
17. PROVISION OF HOLES A₁ (SUCTION CHANNELS) ON FACES C₁ IS NOT ALLOWED.
18. WHEN MAKING THE PUMPS FOR COOPERATION, MAKE ACCORDING TO DIMENSIONS 15502; 15503; 15504; 15505; 15506; 15507; 15508; 15509; 15510; 15511; 15512; 15513; 15514; 15515; 15516; 15517; 15518; 15519; 15520; 15521; 15522; 15523; 15524; 15525; 15526; 15527; 15528; 15529; 15530; 15531; 15532; 15533; 15534; 15535; 15536; 15537; 15538; 15539; 15540; 15541; 15542; 15543; 15544; 15545; 15546; 15547; 15548; 15549; 15550; 15551; 15552; 15553; 15554; 15555; 15556; 15557; 15558; 15559; 15560; 15561; 15562; 15563; 15564; 15565; 15566; 15567; 15568; 15569; 15570; 15571; 15572; 15573; 15574; 15575; 15576; 15577; 15578; 15579; 15580; 15581; 15582; 15583; 15584; 15585; 15586; 15587; 15588; 15589; 15590; 15591; 15592; 15593; 15594; 15595; 15596; 15597; 15598; 15599; 15600; 15601; 15602; 15603; 15604; 15605; 15606; 15607; 15608; 15609; 15610; 15611; 15612; 15613; 15614; 15615; 15616; 15617; 15618; 15619; 15620; 15621; 15622; 15623; 15624; 15625; 15626; 15627; 15628; 15629; 15630; 15631; 15632; 15633; 15634; 15635; 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