



1. Surface finish of casting surfaces as per test specimen.
2. Casting accuracy 10 - 0 - 0 - 10 GOST 26645 - 85.
3. Check forging by x ray exposure as per technology of OGMet.
4. Unless otherwise specified casting radii of inner angles R ~ 5 mm; outer R ~ 3 mm.
5. Drafts as per GOST 3212 - 80 towards increase of dimensions.
6. Harden as per mode TCh.
7. Check oscillation sector with gauge.
8. Inspect casting dimensions as per inspection chart.
9. Mark П as per AK - 630 Tu, stamp.

Approved by shop  
Approved by KTONI  
Approved by TOSV  
Approved by OGMet  
First remarks  
Refer No.  
Duplicate Inv. No.  
Sign & Date  
Alternate Inv. No.  
Inv. No.

					AK-630 101-25		
Amend	Sheet	Doc. No.	Sign	Date	Type	Weight	Scale
					Cradle		
Developed by					A	45.0	1:2
Checked by					Sheet 1   Sheets 2		
Technician							
Head of bureau					Forging		
Head of Q.C.D					II - OST 3 - 4227 - 79		
Approved by					Amg6ch-3 - TAGOST1583-93		



