



$\sqrt{Rz40}$

- 1 Anneal at the temperature of 500 to 600 °C.
- 2* Dimensions are provided by the measuring instruments.
- 3** Reference dimensions.
- 4 Coating 06 / varnish ВЛ-7-5.
- 5 The following is allowed:
 - a) sheet ДПРНМ 1,50М1, ДПРНМ 1,50М2 GOST 1173-2006;
 - b) tape ДПРНМ 1,50НДМ1, ДПРНМ 1,50НДМ2 or ДПРНМ 1,50НДМ3 GOST 1173-2006;
 - c) insignificant scores and dents on the part outer surface with no damage to the coating;
 - d) varnish ВЛ-7-3 and varnish ЛШ-5 OST 84 811-2002.
- 6 The part shall have no cracks, scabs, cavities, holes, deep pot holes, scratches, unevenness.

7 Characteristics of special-purpose phenol-polyvinylacetyl varnishes:
 Special-purpose phenol-polyvinylacetyl varnishes are solution of glue БФ-4 in ethyl alcohol. The varnish is a transparent slightly cloudy homogeneous liquid of a light yellow to dark yellow color without mechanical impurities.
 Varnishes ВЛ-7-3, ВЛ-7-5, where: ВЛ - varnish designation by chemical composition (phenol-polyvinylacetyl varnish);
 7 - varnish group of purpose;
 3, 5 - weight ratio of dry phenol-polyvinylacetyl residue.
 Varnish ВЛ-7-3 is intended for varnishing of parts and products; ВЛ-7-5 - for varnishing, sealing and glueing of parts and products.
 Operating temperature of varnish coatings: from minus 60 to plus 80 °C - unlimited in time; at plus 150 °C - for 5 hours.
 Phenol-polyvinylacetyl varnishes are a flammable, non-explosive material. Ethyl alcohol is inflammable liquid: maximum allowable concentration (MAC (ПДК)) in production floor area working air - 1000 mg/m³; flash-point - plus 13 °C.
 The shelf life of the varnish is 6 months after the manufacture date.

ALT. MATERIAL-

IS:14811-2000 IN "O" CONDITION. CHEMICAL COMPOSITION AS PER IS:191-2007 GRADE Cu FRTP-2.
 (REF. NO. CGA(M)/QA-2/T-72/FSAPDS/MANGO/VOL.12 DT. 20.07.2021).
 SHELLAC BASED ADCTO SPECIFICATION JSS: 8010 - 63: 2016 (REV. NO. 4) (REF. CGA(ME)/7200/GEN. (PC)/125MM FSAPDS/02. FSAPDS (AMK939) /02, DATED. 05.04.2021

REV.	DATE	DESCRIPTION	SIGN.
AMENDMENTS			

DIMENSIONS ARE IN mm		
THIRD ANGLE PROJECTION		
SCALE - 1:1		
2021	NAME	DATE
DRAWN	Kush	16/8/21
CHECKED	[Signature]	16/8/21
HOS/CDD		
VERIFIED	JWM/FS	[Signature]
APPROVED	DGM/FS	[Signature]

MATERIAL:	AS ABOVE
NOMENCLATURE:	BOWL
M/C:	
STORE:	

आईनैन्स फैक्टरी अम्बाझरी	
ORDNANCE FACTORY AMBAZHARI	
DRG. NO:	FS- 3228
REVIEW NO:	0
SHEET NO:	1
NO. OF SHEETS:	1
OPERATION NO:	
COMPT:	