



1. STEEL GRADE, HEAT TREATMENT, METHOD OF ACCEPTANCE AND TESTING ARE ACCORDING TO EXISTING GOULFENT FOR COMPONENTS FROM SPECIAL STEEL. HARDNESS IS INDICED.
2. QUALITY CONTROL AND ACCEPTANCE RULES FOR THE EDGES CUT BY FLAME SHOULD CORRESPOND GOST B3-1302-85.
3. THE PART DISTORTION IS UP TO 4mm INSIDE AND UP TO 5mm OUTSIDE.
4. LOOSE FIT OF THE PART AGAINST COMMON PROFILE TEMPLATE MADE TO NOMINAL SIZES IS UP TO 0.1mm AT PLACES OF BEND R80 AND 225, AND IS UP TO 0.3mm ON AN UPPER EDGE FROM EACH SIDE R80 MAY BE CHECKED BY MEANS OF A LOCAL TEMPLATE.
5. AT THE PLACES OF BENDING THE METAL SURFACE MAY BE THINNEO TO 1mm.
6. DEVIATION OF THE PART PROFILE OF STAYENGS FROM TEMPLATES MADE TO NOMINAL SIZES, AND THEIR DISPLACEMENT FROM THE NOMINAL POSITION IS UP TO 0.5mm, IF NOT SPECIFIED OTHERWISE.
7. DEVIATION FOR PRESS-CUTTING FROM TEMPLATES, MADE OUT OF NOMINAL DIMENSIONS, UP TO 0.5mm.
8. PERMITTED TO ROUNDING THE CORNERS/ANGLES UP TO 5mm.
9. A PROJECTION WEB IS SHOWN ALONG SIZE 50 WITH CONVENTIONAL DOTTED LINES.
10. CONCENTRIC THREADED HOLES M12-7H, EXCEPT FOR THREE HOLES PARTICULARLY SPECIFIED, AT AN ANGLE OF 90-100° UP TO THE EXTERNAL DIAMETER OF THE THREAD FROM OUTSIDE.
11. PERMITTED TO DRILL AND WELD IN THREADED HOLES BY THE 2. AUSTENITE ELECTRODES, FOLLOWED BY THE SUBSEQUENT RECONDITIONING.
12. WHEN CHECKING THREADED HOLES M12-7H, A M3-60 GAUGE TIGHT SUGGESTION IS PERMISSIBLE.
13. MIN FLATNESS OF THE BOTTOM FOR 40mm DISTANCE (SHOULDER NOT EXCEED 7mm) (ON CONVENTIONAL DOTTED LINES).
14. ON THE DIMENSIONS MARKED BY THE DIM IS PERMITTED TO HAVE MACHINING ALLOWANCE FROM EACH SIDE FOR MATING PARTS, FOR WHICH THE VALUE SHOULD BE SPECIFIED IN PROCESS SHEETS. MACHINING WEB IS SHOWN ON THE DIMENSION 50 BY CONVENTIONAL DOT LINE.
15. DIMENSION CHECKING FOR 20x2 INHIT DIFFERENCES OF SURFACES (SECTION E-E) IS PERMITTED TO CARRY OUT SIMULTANEOUSLY RESPOND TO UP AXIS AT THE DISTANCE OF 400mm AND 100mm RESPOND TO LONGITUDINAL AXIS AS VIEWED FROM THE REAR.
16. STAMP THE COMPONENTS FROM INSIDE CHECK DIMENSION SIZES IN FLAT POSITION.
17. DIMENSION FOR REFERENCE.
18. TOLERANCE OF FLATNESS FOR THE EXTERNAL SURFACE OF THE BOTTOM OVER A DISTANCE OF 40mm MIN. FROM THE CONTOUR OF RECESS FOR THE ENGINE COMPARTMENT LOWER ACCESS DOOR IS 2mm PROJECTION 1mm ON THE OUTSIDE AND 0.5mm INSIDE.

PRINT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE
 BEAR PROCEEDING
 BEST PRACTICE TO BE STAMPED OR MARKED WHERE
 INDICATED THIS IS
 APPROVED BY LETTERS
 ALL SHARP EDGES AND CORNERS TO BE ROUNDED UNLESS
 OTHERWISE STATED IN DRAWING CORNERS TO HAVE R 0.5mm
 UNLESS OTHERWISE STATED IN DRAWING
 SIDE B INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

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| 1. ENK | 172 01 011-3 | MATERIAL | STEEL | LOAD ON | 172 BY 114 (5-2) |
| 2. ENK | 172 01 011-3 | SPECIAL STEEL | | | |
| 3. ENK | 172 01 011-3 | SEE ITEM 1. DE "A" | | | |
| 4. ENK | 172 01 011-3 | | | | |
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