

Rz20 (✓)

1. 43.5...51.5 HRCe.
2. Internal angle  $R \approx 0.6$  mm.
3. Blunt edge  $R \approx 0.6$  mm.
4. Coating Cad. 12. phos. accelerat. chrome / impregn. adhesive BF 4 GOST 12172 74, 1 layer, except surfaces B, Д after approval test. Surface B, Д X<sub>max</sub> 30...45. Dimensions are given after chrome plating.
5. Sagging of chrome on face K and Г, in slots A and B in hole B is permissible.
6. Displacement of axis of slots A from nominal position should not be more than 0.03 mm. Base hole B.
7. Mark with letter size PO 3 GOST 2930 62.
8. Stamp.
9. \*Dimension not in projection.
10. Wall deviation on section diameter E should not be more than 0.3 mm.

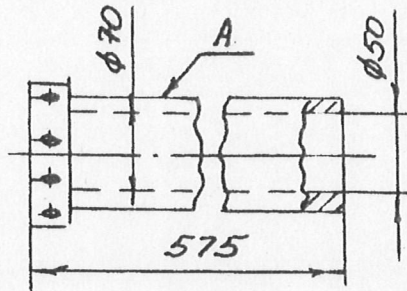
AO - 18.01.022					Type	Weight	Scale	
Amend	Sheet	Doc. No	Sign	Date	Nut	0,	1.475	1:1
Developed by								
Checked by								
Technician								
Head of bureau								
Head of Q.C.D								
Approved by								
					Tube	76x14GOST8732-78		
						V30KhGSAGOST8731-87		

### Technological process Chart for heat treatment

Sheet 1

Sheets 3

Article	Component No.	Nomenclature of component	Material grade	Weight of comp. kg.
AO - 18	01.022	Nut	Steel 30KhGSA	~ 8.0



Set

Oper. No.	Nomenclature of operation	Equipment	Mode			Fixture LK0772	No. of fixtures	No. of comp. on fixture
			t°C of heating	Time of heating, min.	Cooling			

Get familiar with safety instruction No.100 and 05042520000014

0070	Checking of grade of steel by steel scope							
0075	Tying							
0080	Hardening of semi finished blanks							
	1.Heating	Electric furnace cabinet	870-890°	60	Oil 40-80°	4050	2	2
	2. Washing	Washing machine	70-100°					
0090	Tempering							
	Heating	Electric furnace cabinet	360-420°	60	Air	4012	1	2
0100	Sandblasting with metallic sand							
0110	Untying							
0120	Cleaning of places meant for checking of hardness							
0130	Checking of hardness							
0140	Preparation of accompanying charts							
	Machining							

Technical condition for test					Depth of carburizing layer, mm	Hardness HRC <sub>E</sub>	Test place and test %	Polishing
$\sigma_V$ kg/mm <sup>2</sup>	$\delta$ %	$\varphi$ %	ak, kgm/cm <sup>2</sup>	Qty .and type of test specimen				
				Separable	Impact	Drawing 43.5...51.5	At point A 100	File, Polishing wheel
						1.5 accept 44...		
						51.5		

Remark:

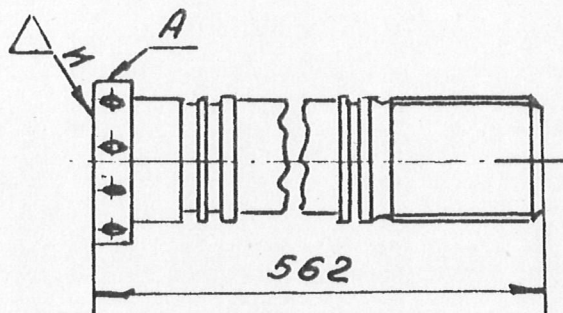
No.p/p	Reason for amendment	Sign	Date
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**Technological process Chart  
for heat treatment**

**Sheet 2**  
**Sheets 3**

Article	Component No.	Nomenclature of component	Material grade	Weight of comp. kg.
AO - 18	01.022	Nut	Steel 30KhGSA	1.475



Set

Oper. No.	Nomenclature of operation	Equipment	Mode			Fixture LK0772	No. of fixtures	No. of comp. on fixture
			t°C of heating	Time of heating, min.	Cooling			

Get familiar with safety instruction No.100 and 05042520000014

0211	Tempering for removal of stress after machining							
	Heating	Electric furnace cabinet	140-160°	120	Air			
0212	Inspection of mode by BTK							
0215	Preparation of accompanying documents							
0220	Rechecking of hardness							
0225	Stamping of stamp "I" on component							
0230	Preparation of accompanying documents							

Technical condition for test					Depth of carburizing layer, mm	Hardness HRC <sub>E</sub>	Test place and test %	Polishing
$\sigma_V$ kg/mm <sup>2</sup>	$\delta$ %	$\varphi$ %	ak, kgm/cm <sup>2</sup>	Qty. and type of test specimen				
				Separable	Impact			
						43.5... 51.5	At point A 100%	

Remark				
	No.p/p	Reason for amendment	Sign	Date

