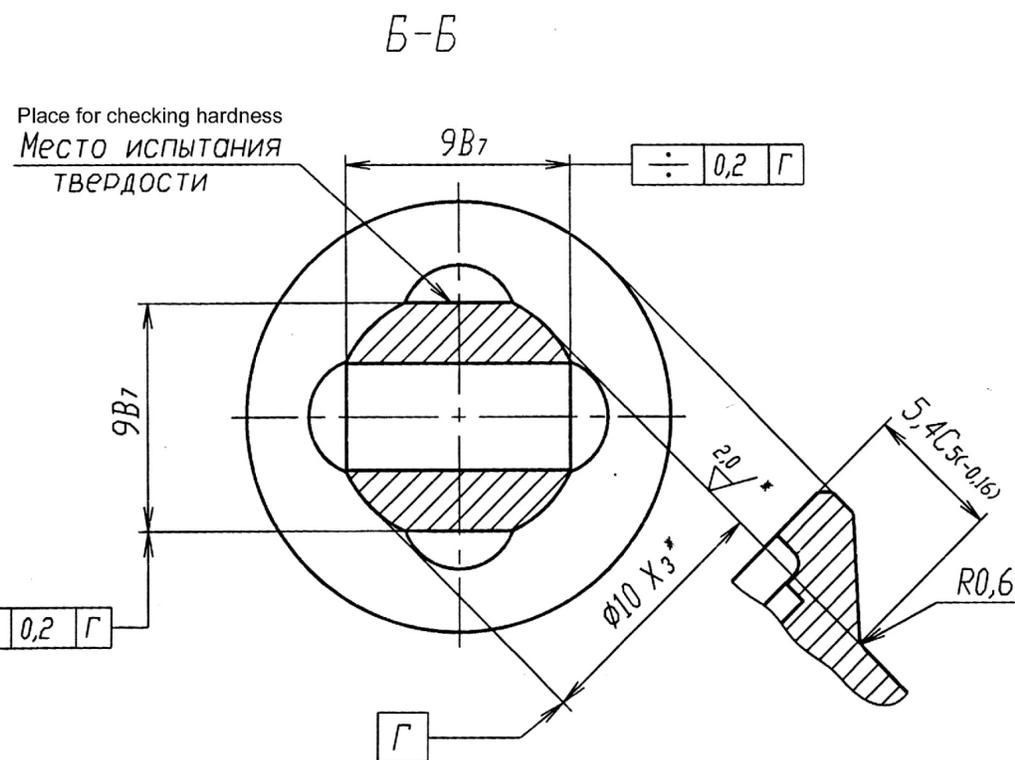
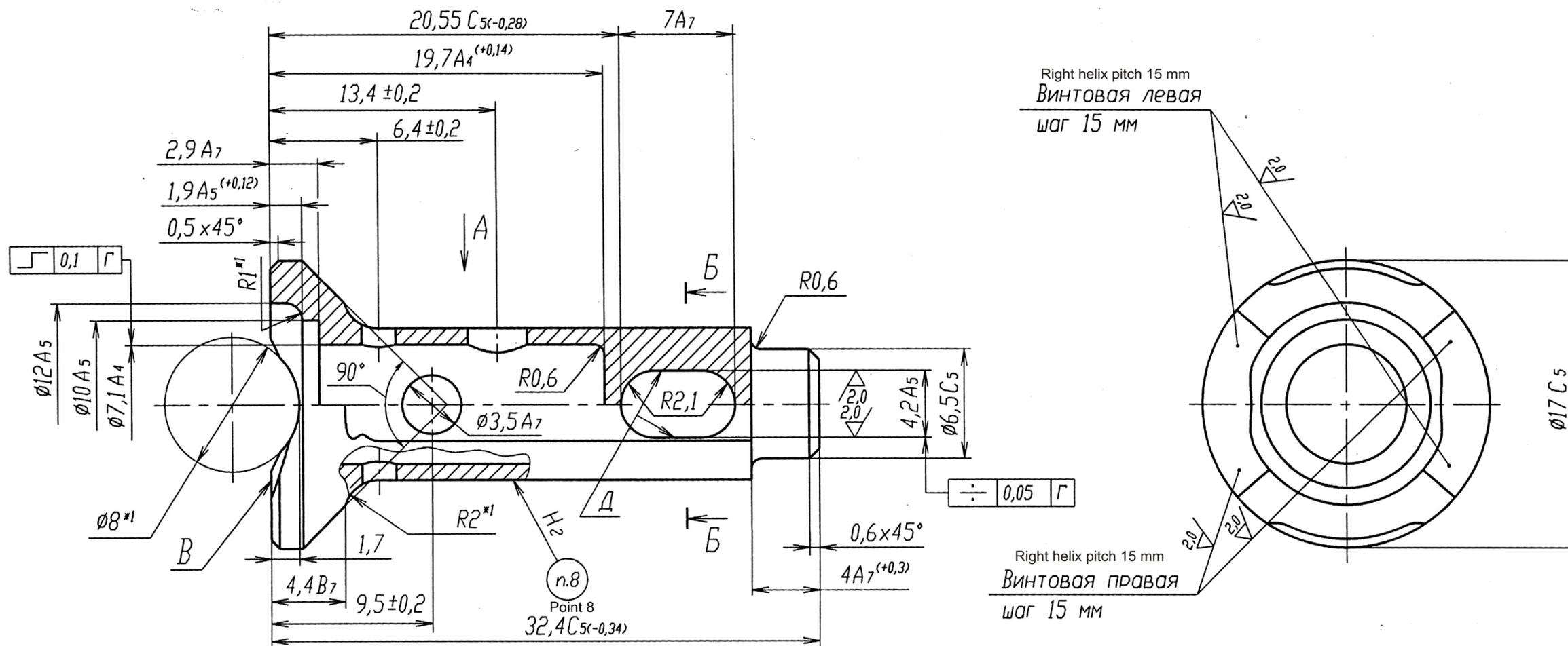


Orig. Inv. No.	Sign and Date	Alternate Inv. No.	Dupl. Inv. No.	Sign and Date	Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks	
9-A-621.05.020												
	Amend.	Sheet	Doc. No.	Sign	Date							
	Developed by									Type	Sheet	Sheets
	Checked by									02		1
	Head of Q.C.D											
	Approved by											
Firing pin												
Materials												
			5					Moulding material AG-4V		6	gm	
								GOST 20437-89				
Components												
	A2		1	✓				9-A-621.05.005	Plunger	1		
	A4		2	✓				9-A-621.05.006	Bush	1		
	A3		3					9-A-621.05.007	Firing pin	1		
	A4		4	✓				9-A-621.05.015	Bush	1		
Documents												
	A4							9-A-621.05.020 SB	Assembly drawing			
First use												



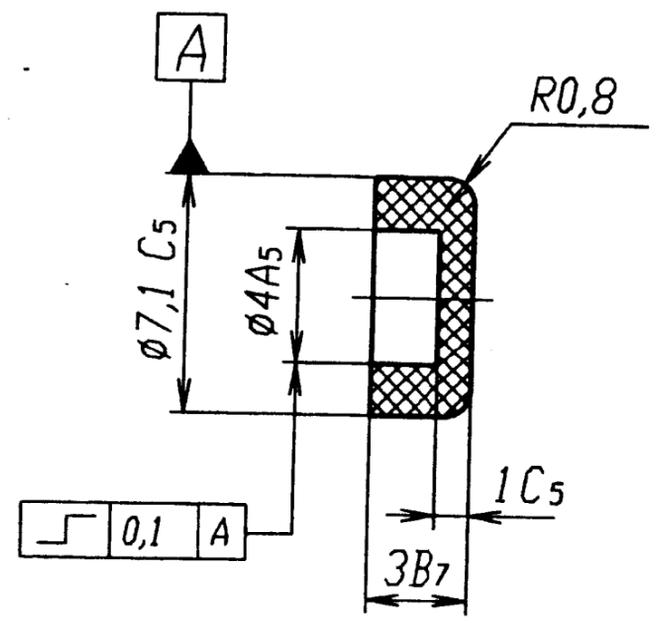
1. HRCe 38.5.....45.5.
2. Check hardness of 2-3 % from batch , but not less than on 3 pieces .
3. * Dimension and surface finish after coating .
- 4.*1 Dimensions are ensured by tool .
5. Blunt edges R 0.6 mm .
6. Tolerance on contour of helix surface relative to surfaces B, Г and Д is 0.2 mm .
7. Coating : Cad 9 Phos. Accel. Cr.
8. Mark with letter size PO. 5 as per GOST 2930-62.
9. Stamp K,И on batch tag .

					9-A-621.05.005			
Amend	Sheet	Doc. No.	Sign	Date	Plunger	Type	Weight	Scale
Developed by	Checked by	Technician	Head of bureau	Head of QCD		O ₂	0.0115	5:1
Inv. No.	Sign and Date	Alternate Inv. No.	Duplicate Inv. No.	Sign and Date	Sheet		Sheets 1	
					Steel 50 GOST 1050-74			
					Approved by			

9-A-621.05.006

Approved OGMet	Orig. Inv. No.	Sign and Date	Approved Inv. No.	Dupl. Inv. No.	Sign and Date	Approved KTONI	Reference No.	Approved by shop	First use
	Sign and Date								

0,63  Press mould
ДЛЯ ПРЕССФОРМЫ



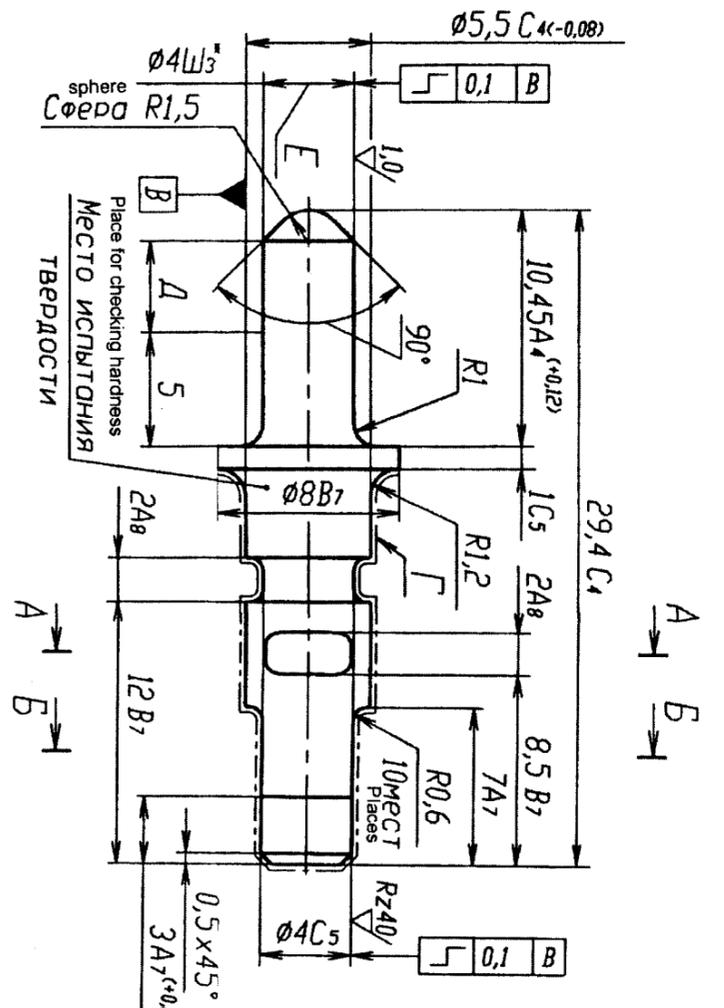
1. Inner angles R~0.4 mm.
2. Blunt edges R~0.4 mm.
3. Stamp K on batch tag.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				

9-A-621.05.006			
Firing pin bush	Type	Weight	Scale
	O ₂	0.002	5:1
Moulding material	Sheet Sheets 1		

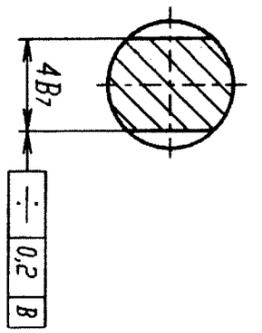
Orig. inv. no.	Sign and Date	Alternate Inv. No.	Duplicate Inv. No.	Sign and Date	Reference No.	First use
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9-A-621.05.007

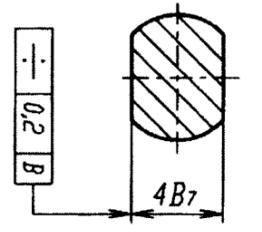


Rz20
▽(✓)

A-A



B-B



Место для проверки твердости
Place for checking hardness

1. HRC_E 43.5, 51.5
2. Check hardness on 3-5% of the batch but not less than 3 nos.
3. * Dimension after coating
4. Round off blunt edges R~0.6 mm.
5. Inner angles R~0.4 mm.
6. Coating : Kh18 hard, except surface F. Surface F - Chem: Phos, accel, Cr.
7. Presence of chromium on surface F is permissible.
8. Stamp K, N on batch tag.
9. Center holes not permissible.
9. after chromium plating, increase in diameter E up to dimension 3.99 mm on section D is permissible.

Amend.	Sheet	Doc No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

9-A-621.05.007			
Firing pin	Type	Weight	Scale
	O ₂	0.008	5:1
Steel 30KH2MFA GOST 4543-71	Sheet	Sheets	1

