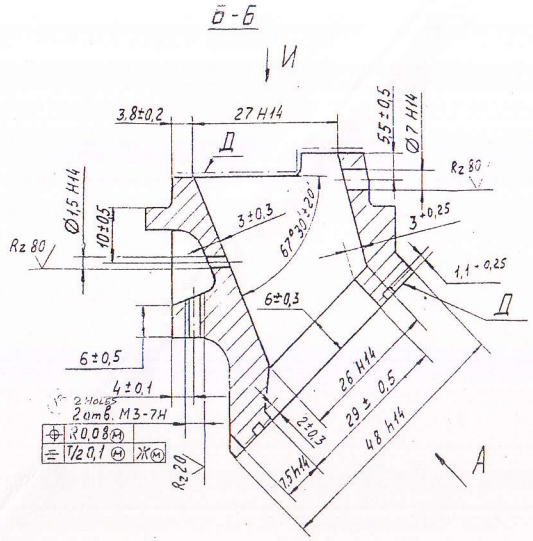
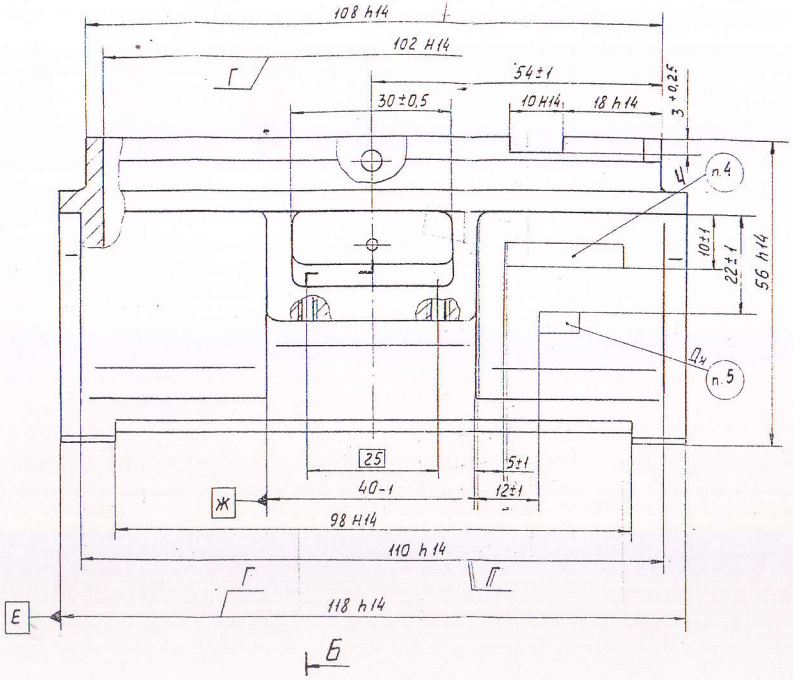
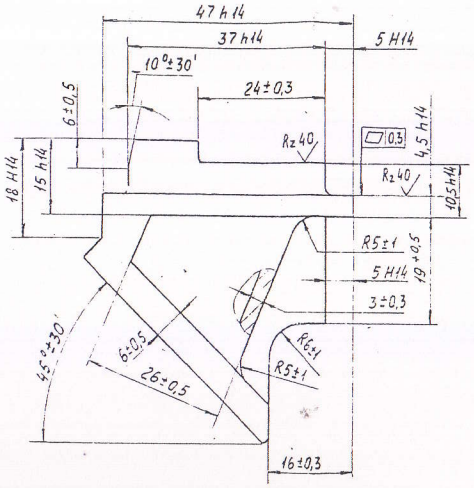
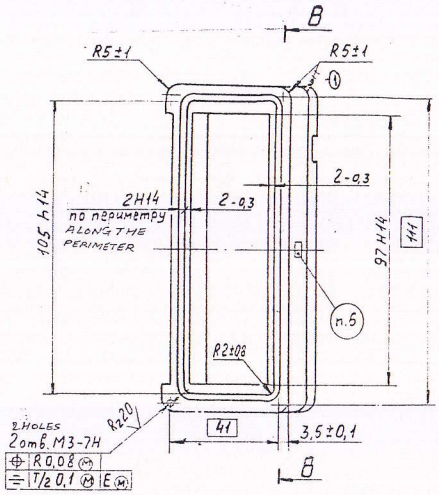


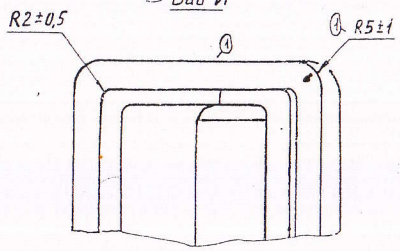




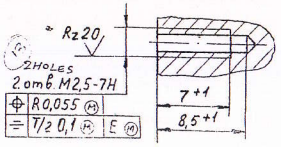
11 VIEW TURNED FOR CLARITY
Вид А повернуто.
М 1:1



10 VIEW
Вид И



В-В
М4:1



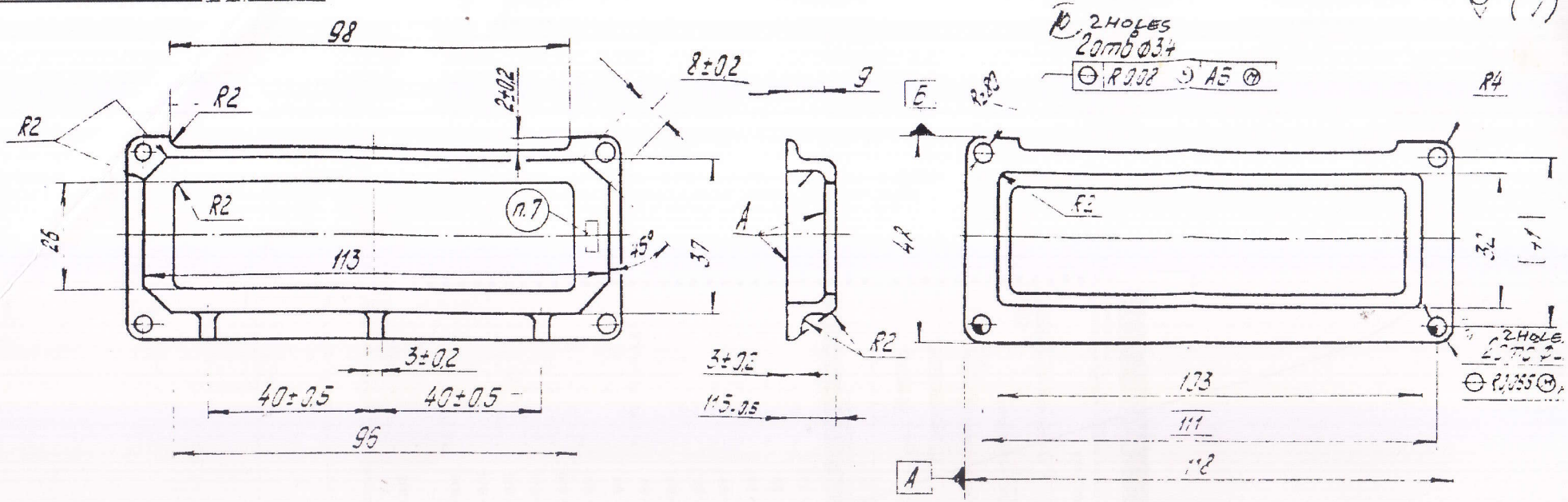
1. PRESSURE DIE CASTING GROUP I OST 3-4227-79.
2. DRAFT MAX. 40' IS MADE OUT OF TOLERANCE ALONG THE DIMENSION Г TOWARDS DECREASING SIDE.
3. UNSPECIFIED DIMENSIONS OF RADII — MAX. 2 MM.
4. TO BE MARKED "ТНПА-65А" WITH LETTER SIZE 4-ПЗ GOST 26.008-85.
5. TO BE MARKED AS PER ТУ3-3.878-83 WITH LETTER-SIZE 4-ПРЗ.
6. TO BE MARKED THE No. OF MOULD DUBBLER WITH LETTER SIZE 4-ПРЗ GOST 26.008-85.
7. BEFORE COATING: THE SURFACE BLOW THE MANUFACTURE-DCORUNDUM.
8. COATING: KHAKI ENAMEL ГФ 1426 V. УХЛ1 EXCEPT INTERNAL SURFACE AND SURFACE А. DRIPPING IS NOT ALLOWED.
MARKS VISIBLE WITHOUT MAGNIFIERS, CHARACTERISTICS OF SURFACE FINISH CONTOUR OF COATING AND NON HOMOGENIETY OF PATTERNS INDUCED BY CONDITION OF PAINTING SURFACE BEFORE PAINTING ARE ALLOWED.

VETTED
I/C Q.A.
I/C USER

1. Литье по заблением гр. I ОСТ 3-4227-
2. Литейный уклон не более 40' выполняется вне допуска по размерам Г в сторону уменьшения.
3. Неуказанные размеры радиусов не более 2 мм.
4. Маркировать ~~по ТУ 3-3.878-83~~:
Ч - „ТНПА-65А" шрифтом ~~АО-4, знак М-4~~ 4 ГОСТ 26.
5. Маркировать по ТУ 3-3.878-83 шрифтом ~~АО-4~~ 4-Пр3.
6. Маркировать номер дублера формы шрифтом ~~АО-4 ГОСТ 2930-62~~. 4-Пр3 ГОСТ 26.008-8
7. Перед покрытием поверхности обдуть элек рокорундом.
8. Покрытие эмаль ГФ-1426 защитная ~~ГОСТ 6745-79~~. V. УХЛ1, кроме внутренних и поверхн. поверхностей V
Потеки не допускаются.
Допускаются увеличительных приборов риски, особенности рельефа фактуры покрытия и неоднородность рисунка, вызванные состоянием окрашиваемой поверхности окраски.
9. Остальные технические требования по ТУ 3-3.878-83.

D.C.(I):-5422-I DRG. SEALED.			5.10.90	2		АЦ 990-87		5.10.87
D.C.(II):-1418-I(P). DRG. PROV. SEALED.			21.3.90	1		АЦ 298-87		7.04.87
					Нов	АЦ 76-87		28.11.87
				Изм.	Лист	№ докум.	Подп.	Дата
				Разраб.		Абызова		23.12.86
				Пров.		Чадчин		5.10.90
				Т.кон.		Остряковой		17.10.90
AMENDMENTS.		SIG.	DATE.					

GROUP No. 47 37.5 KP FOLDER/SHEET
DRG. No. АЦ 8.020.387
BODY
SHEET WEIG 0.1
ALUMINIUM ALLOY



6. COATING: KHAKI ENAMEL ГФ-1426 GOST 6745-79 V.
Yx П1 EXCEPT THE SURFACE A.
DRIPPING IS NOT ALLOWED.
MARKS VISIBLE WITHOUT MAGNIFIERS, CHARACTERISTIC. SURFACE FINISH OF COATING AND NON-HOMOGENIETY OF PATTERN, INDUCED BY CONDITION OF PAINTING SURFACE BEFORE COATING ARE ALLOWED.

7. TO BE MARKED THE NO. OF MOULD DUBBLER WITH LETTERSIZE 4-ПР3 GOST 26.008-85.

8. BEFORE COATING OF SURFACE, BLAST WITH ELECTRO CORUNDUM.

1. PRESSURE DIE CASTING GROUP I OST 3-4227-79
2. UNSPECIFIED CASTING RADII UPTO 1 mm.
3. DRAFTS - 30'
4. UNSPECIFIED LIMIT DEVIATION ON RADII:
FROM R1 TO R3 ±0.5 mm.
FROM R3 TO R6 ±1 mm.
5. UNSPECIFIED LIMIT DEVIATION ON DIMENSIONS:
OF HOLES -- AS PER H14
OF SHAFTS - AS PER h14
REST AS PER ±JT/2

VETTED
I/C O.A.
I/C DSEP

D.C.(I):-5422-I DRG SEALED.		5.10.90	
D.C.(I):-1418-I(P). UPDATED DRG. PROV. SEALED IN SUPERSESSION OF EXISTING ONE.		21.3.90.	
AMENDMENTS.		SIG.	DATE.

1	AЦ 990-87		5.10.8
ЗАМ	AЦ125-85	(подп)	(дата)
	Прусова	(подп)	(дата)
	Пяскин	(подп)	(дата)
	Костомлова	(подп)	(дата)
	Царькова	(подп)	(дата)

GROUP No. 41315 XD FOLDER/SHEET No. 25

DRC No. AЦ 8.636.448

HOLDER	SHEET	WEIGHT	SC
		19	1.

ALUMINIUM ALLOY
MATERL AA2 GOST 2585-75

OPTO ELECTRONICS FACT
DEHRADUN

24001 Подп. Дата

D.C.(I):-1237-I(P), 1418-I(P), 5422-I.

AЦ 6.436.219/AЦ3.895.05