



1. NON-FLATNESS OF SURFACES B AND F SHOULD NOT EXCEED 0.15mm NON-FLATNESS BEYOND THE LIMITS OF DIMENSION A SHOULD NOT EXCEED 0.3mm.
2. VARIATION OF DIMENSION A SHOULD NOT EXCEED 1mm.
3. ROCKWELL HARDNESS SHOULD BE C = 28 TO 37.
4. SUBJECT THE FINISHED PART TO TEMPERING TO REMOVE STRESS.
5. CHECK POSITION OF SLOTS WITH COMBINATION GAUGE WITH THREE UNIFORMLY ARRANGED SQUARE LOCK-PINS AND DATUM SURFACE CENTERED AGAINST SURFACE D. EDGES OF LOCK-PINS SHOULD BE PARALLEL TO THE PLANE PASSING THROUGH THE AXIS OF LOCK-PIN AND DATUM SURFACE. DIAMETER OF THE DATUM SURFACE SHOULD BE $\phi 238$. SIDE OF THE LOCK-PIN SQUARE SHOULD BE 13.85. NON-PARALLELITY OF SLOT EDGE AND LOCK-PIN EDGE IN THE FIXTURE SHOULD NOT EXCEED 0.05mm.
6. BLUNT SHARP EDGES.
7. UNIVERSAL METHOD OF CHECKING FOR THE ARRANGEMENT OF SLOTS IS ALLOWED. IN THIS CASE DEVIATIONS OF THE SLOT SYMMETRY AXES FROM TRUE POSITION SHOULD NOT EXCEED 0.15mm. NON-PARALLELITY OF SLOT EDGES WITH RESPECT TO THE PLANE PASSING THROUGH THE AXIS OF SURFACE D, AND THE SLOT SHOULD NOT EXCEED 0.05mm.
8. BALL IMPRESSION LEFT AFTER HARDNESS CHECKING IS ALLOWED ON SECTION *.
9. DISC MAY BE MADE AS PER CONVENTIONAL DOTTED-LINE.
10. DIFFERENCE IN DIMENSION E SHOULD NOT EXCEED 2mm. DECREASE IN ONE OF THE SPECIFIED, DIMENSIONS TO 2.5mm AND INCREASE IN THE OTHER DIMENSION UPTO 5mm AND ALSO MACHINING OF SURFACE M ON THE SIDE OF GREATER DIMENSION ARE ALLOWED.
12. OXIDE FILM FROM THERMAL STABILIZATION IS ALLOWED ON SURFACES OF DISC.

APPROVED	<i>[Signature]</i> H VASU	765-12-342	264 of 453
CHECKED	<i>[Signature]</i>	DISC	
CONTROLLERATE OF INSPECTION (ICVI)		0.53	1:1
		SHT	SHTS
		G5T GOST 14959-79	