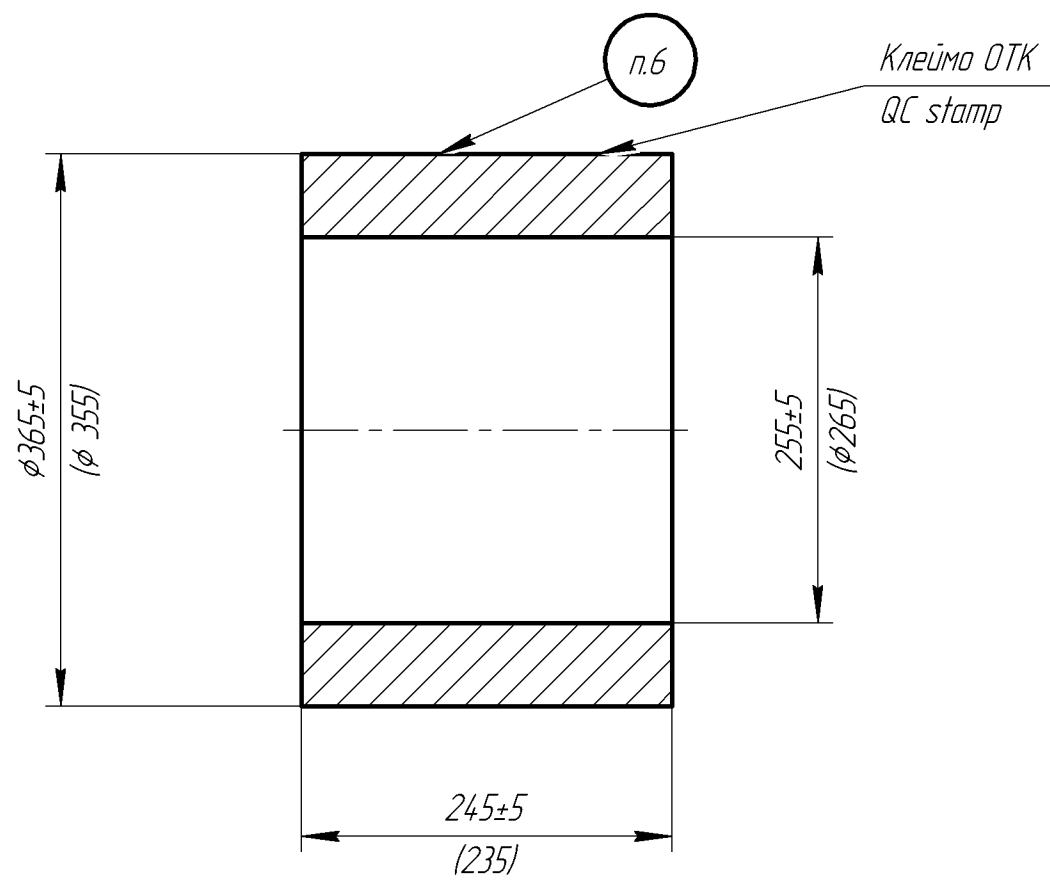


Инв. № подл.

1. 10ГН2МФА-А, КП 30, Gr. V, TcO -10 °C per Specification TY 0893-014-00212179-2004.
Allowed to be made of steel grade 10ГН2МФА-ВД or 10ГН2МФА-Ш.
2. Workpiece per single part AM110.06.00.941.
3. Dimensions given in parentheses are finished ones.



4. Sharp edges to be made blunt to provide chamfer $2 \times 45^\circ$;
5. Mechanical tests and critical brittle point verification shall be carried out using samples:
- After a minimum heat treatment cycle:
- to be loaded in furnace at a temperature of 300°C max;
 - to be heated up at a rate not greater than 60°C per hour to reach the temperature of 640°C to 660°C ;
 - aging at a temperature of $640 \dots 660^\circ\text{C}$ for $8 \dots 8.5$ hours;
 - to be cooled down at a rate not greater than 60°C per hour to a maximum temperature of 300°C , followed by air cooling;
- After a maximum heat treatment cycle:
- to be loaded in furnace at a temperature of 300°C max;
 - to be heated up at a rate not greater than 50°C per hour to reach the temperature of 640°C to 660°C ;
 - aging at a temperature of $640 \dots 660^\circ\text{C}$ for $14 \dots 15$ hours;
 - to be cooled down at a rate not greater than 50°C per hour to a maximum temperature of 300°C , followed by air cooling.
6. To be punch marked in font 8-Пз per GOST 26.008-85 is the following: designation, heat number, forging number.

						ПМ110.06.911									
									Лист.	Масса	Масштаб				
Изм.	Лист	№ докум.	Подп.	Дата	Заготовка штуцера Nozzle workpiece									103	1:5
Разраб.															
Пров.															
Т.контр.															
Н.контр.					См. ТТ п. 1 See Technical Requirements, Item 1						Лист		Листов 1		
Утв.															