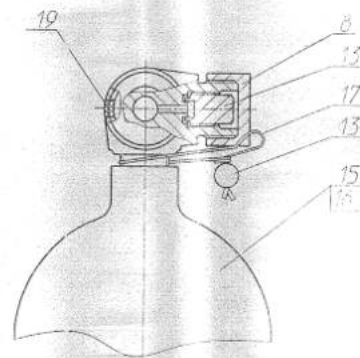




- 1 Dimensions for reference.
- 2 Fit the body of head, item 1 taking lead monoxide diluted in natural drying oil to GOST 7931-76.
- 3 Before tightening, fit the striker in such away that the locking ring fits into the appropriate slots in the taper and plug and reliably holds the striker in the indicated position. After that apply grease on the inner taper of plug with graphite paste GOST 5333-60, and tighten fully.
- 4 Inscribe serial no. of cylinder and actual weight of cylinder (Error in measurement ± 0.005 kg) as on the parts excepting nut, item 7 and gasket, item 9 on the body of head on the side opposite to filling pipe union by etching or punching method in letter type (ISO 5 GOST 2930-62).
- 5 Charge the cylinder with $(1.1^{+0.1})$ kg of chladon 11462 GOST 15899-93. After filling the cylinder with chladon, add nitrogen GOST 9293-74 at pressure (7.0 ± 0.5) MPa (70 ± 5) kgf/cm² at $25 \pm 10^\circ\text{C}$ temperature.
- 6 Coating to be carried out as follows:
 - Internal surface of cylinder, item 19, except threaded with Vamash G-85 or G-80 - 1.
 - External surfaces of cylinder, item 19, except surfaces of stamp, with Primer G-1 - 03K.
 - Enamel (10 - 115 or (116 - 223 red.
 - Surface of stamp - with Vamash KO - 85 or G-80 - 95
 - Stamp on surface of cylinder to be painted with Enamel (10 - 223 or (116 - 115 yellow or Enamel (10 - 223 or (116 - 115 black or Enamel MC-17 black.
 - Dimensions of outline and width of line to be determined at the time of painting.
 - Inscribe inscriptions and paint outlines with Enamel (10 - 223 or (116 - 115 yellow or Enamel (10 - 223 or (116 - 115 black or Enamel MC-17 black.
 - Inscribe letters and digits of inscription in letter type (10-8, 10-12 and 10-24 GOST 2930-62.
 - Requirements are as per 520 TY1
- 7 Mount the pressure indicator, item 14 in the position indicated in the drawing by sealing gasket, item 10, 11 and 12. Before fitment apply ANATHERM - 68 or ANATHERM - 18 TY-01-1215-76 or UNIGERM II TY 0-01-1309-85 to thread.
- 8 Weigh the charged and finally painted cylinder with inscription with all the parts, except nut, item 7 and gasket, item 9. Record the weight of cylinder (Error in measurement ± 0.005 kg) and date of weighing.
- 9 Test the charged cylinder for air tightness.
 - Hold it for four hours.
 - Weigh.
 - Apply soap water at the joints. There should not be any bubbles.
 - Test for airtightness by heating in water or air for four hours at $(95 \pm 5)^\circ\text{C}$. Cylinder head should not be removable in water.
 - Weigh. Difference in measurement $\pm$ permissible up to ± 0.005 kg.
- 10 Check error of pressure indicator before filling cylinder as per drawing 155-50-2334b-1.
- 11 Other requirements are as per specification 520 TY1.

THIS DRG IS BASED ON HVF DRG NO. 172.82.099-58

PART NUMBER SHOULD BE APPROVED BY: <u>ASST. COMMISSIONER</u> BEFORE MASS PRODUCTION.		QTY: <u>200</u> CRD: <u>200</u> APP: <u>66</u> DATE: <u>20 03 2011</u> SCALE: <u>1:1</u> DIMENSION IN: <u>mm</u> TOLERANCE ON FEEL: <u>0.05</u> TOLERANCE ON SIZE: <u>0.05</u> FINISH: <u>RA 0.8</u> M.T. TIE LOG TO: <u>CONTRACT</u>	MATERIAL: <u>SS 304</u> USED ON: <u>172 82 099spss</u> CONTRACT OR PATH OF QUALITY ASSURANCE: <u>172 82 099spss</u> PLANT NAME: <u>PUNE - 411 007</u> TITLE: <u>CYLINDER</u> <u>ISHTAR / DRAWING</u> DRAWN BY: <u>172 82 099spss</u>
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