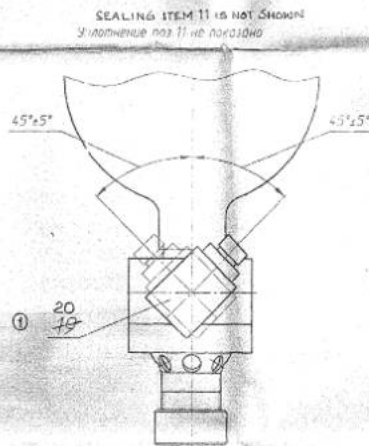




SEALING ITEM 11 IS NOT SHOWN
Упаковка поз 11 не показана

- 1 *Dimensions are for reference.
- 2 Head body item 1 should be installed in lead monoxide diluted in natural vanash GOST 7931-76
- 3 Before screwing up the plug, striker should be installed so that locking ring is in corresponding grooves of striker and plug. Striker should be reliably fixed in specified position after that inner taper of plug should be lubricated with graphite lubricant GOST 3333-80 and tightened with torque (250±20) Nm ($\pm 25\%$) Kgf-m).
- 4 Serial number of cylinder and actual weight of cylinder (measuring error ± 0.005 kg) with all components except nut item 12 and gasket item 13 should be inscription the body of head by etching or punching with type ПН-5 GOST 2930-62. Position of inscription (relative to the axis of cylinder is optional).
- 5 Charge cylinder with 2.0... kg chladone 13B1, TY 6-02-1104-87 or fill chladone 13B1 TY 2412-06-0480698-88. After filling with chladone cylinder should be added with nitrogen GOST 9293-74 at pressure 76×10^5 MPa (70×10^5 Kgf/cm²) at (20±5) °C temperature.
- 6 Coating

Inner surface of cylinder item 21 except thread.
Vanash ГФ-65 or ПВС-1 21

External surface of cylinder item 19 except surface of stamp.
Primer ПН-03K
Enamel ПН-115 or ПН-223 red.

Surface of stamp:
Vanash КО-85 or П-05

Surface of stamp outlined with frame.
Enamel ПН-223 or ПН-115 Yellow or
Enamel ПН-223 or ПН-115 Black or
Enamel MC-17 Black.

Dimensions of frame and width of space of outline should be determined to suit the place. Inscriptions and frame should be applied with
Enamel ПН-223 or ПН-115 Yellow or
Enamel ПН-223 or ПН-115 Black or
Enamel MC-17 Black.

Letter and digit s of the inscriptions should be applied with type ПН-8, ПН-12 and ПН-24 GOST 2930-62

Requirements should be as per specifications 520 TY5.
- 7 Pressure indicator item 20 should be installed in a position specified in the drawing by setting gaskets item 14, 15 & 16. Before installing thread should be lubricated with Anstern-68 or Anatern-10 TY 6-01-4245-79 or Ungermil IT TY 6-01-1303-85. с TY 2257-399-0
- 8 Weigh the loaded and finally painted cylinder with all components except nut item 12 and gasket item 13 and inscribe the weight of the cylinder (Measuring error ± 0.005 kg) and date of weighing. inscription with
- 9 Charged cylinder should be tested for air tightness.

- Hold for four hours
 - Weigh.
 - Mixing place should be applied with soap water. Bubbles are not allowed.
 - To be tested for air tightness by heating in water or air medium for four hours at temperature plus (± 5) °C. Head of the cylinder should not dip into the water.
 - To be weighed. Difference in measurement should be ± 0.005 Kg.
- 10 Transportation of cylinder with head upward is not allowed.
- 11 Fast operation of cylinder should be insured by design and dimensions of the components of head of the cylinder.
- 12 After testing of air tightness install sealing item 11.
- 13 On the gasket item 10 on the side with chamber, grease used in the article may be applied.
- 14 Cylinder assembly should be in compliance with requirements 155.69.233eb-1TY
- 15 Other requirements should be as per specifications 520 TY1.

THIS DRG IS BASED ON WVF DRG NO 155.59.233-16A

			DOR	MATERIALS	USED ON
			CRD		
			APPO		
			DATE	20 09 2011	
			SCALE	1:1	
			EXTENSION		
			NOTE ITEM WAS IN SYSTEM		
			WAS 46.2V & 0.1-1310-79		
			NOTE EXTEN NO WAS 19		
			ITEM NO WAS 19		
			ITEM NO WAS 20		
			ALL LEADS TO		
			CONVERT TO		
			DATE		
			NATURE OF AMENDMENT		

CONTROLLERATE OF QUALITY ASSURANCE
 ATNH CAMP, CH-41, 207
 JALPAIGURI

CYLINDER

ASSEMBLY DRAWING

DRAWING NUMBER
155-59.2335b-158

PILOT SAMPLE SHOULD BE APPROVED BY A TSP

FILE NO.	TO BE STAMPED OR MARKED WHEN INDICATED THIS * (LETTERS
7-3	

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MACHINED CORNERS TO HAVE R. ON INSIDE R. INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.