

2. Technical requirements cylpebs 12 mm, 16 mm.

2.1. The shape and the sizes of the cast-iron cylpebs have to correspond to the shape and the sizes specified on the figure 1 in the table 1

Table 1

D1, mm	D2, mm	L, mm	Acceptable taper
12 ±1,5	17 ±2,5	17 ±3	0-1:4
16 ±1,5	20 ±2,5	22 ±4	0-1:5

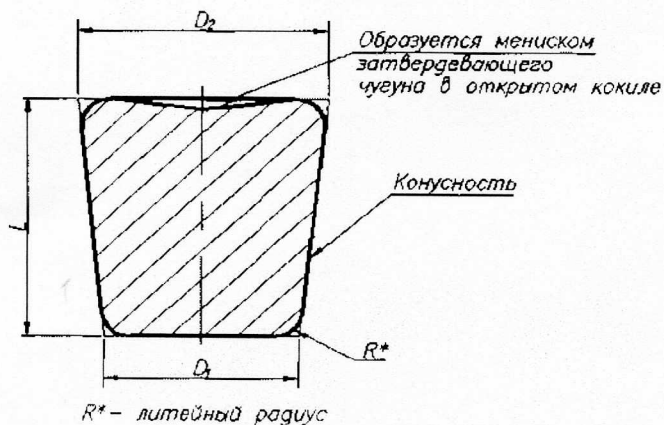


Fig. 1

2.2. Depending on hardness on a surface the cast-iron cylpebs are subdivided into groups specified on the table 2:

Table 2

Type of cylpebs	Hardness, HRC			
	Group I	Group II	Group III	Group IV
Cast-iron cylpebs	Not less than 43,5	Not less than 50,0	Not less than 50 on surface and 50 in the middle	Not less than 55 on surface and 55 in the middle

Example of identification number of cast-iron cylpebs by their order:

**Cast-iron cylpebs 12 TU 1172-014-00282205-2014 Group II or
Cast-iron cylpebs 16 TU 1172-014-00282205-2014 Group III**

2.3. The chemical composition of cast-iron cylpebs has to meet the standards specified in the table 3.

Table 3

Cast-iron cylpebs		
Content of elements, %		
C	Si	S
2.8 - 4.0	0.8 - 2.5	≤ 0.15

2.4. The cylpebs are cast by filling of the melted cast iron in the casting mold.

2.5. The surface of the cast-iron cylpebs has to be free of defects. Inflow and sink holes of less than 3 mm aren't a rejection sign as don't influence technical characteristics of the cast-iron cylpebs.