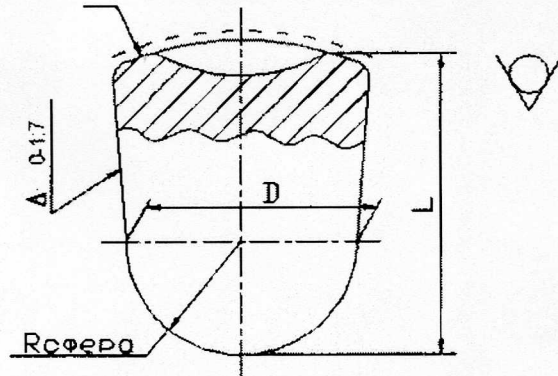


1. Technical requirements cylpebs 18 mm, 25 mm, 32 mm.

1.1. 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

Diameter of cylinder (D)	Limit deviation	Length of cylinder (L)	Radius of a curve of the lower end face	Acceptable taper
18 mm	± 1,0	from 18 to 30 mm	D/2	0 - 1 : 7
25 mm		from 25 to 38 mm		0 - 1 : 7
32 mm		from 32 to 44 mm		0 - 1 : 7



• Fig. 1

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

Table 2

Type of cylpebs	Hardness, HRC	
	Group I	Group II
Cast-iron cylpebs	No less than 43,5	No less than 50,0

Example of identification number of cast-iron cylpebs with a diameter of 25 mm and the hardness not less than 50 HRC by their order:

Cast-iron cylpebs 25 x (25 - 38) TU 1172-001-00282205-2010, Group II.

1.3. 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
3.0 - 4.0	1.0 - 2.0	≤0.15

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

1.5. 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.