

DP-11.30.13-VCH

Primary Usage

Reference No.

Sign. and date

Copy inv. No.

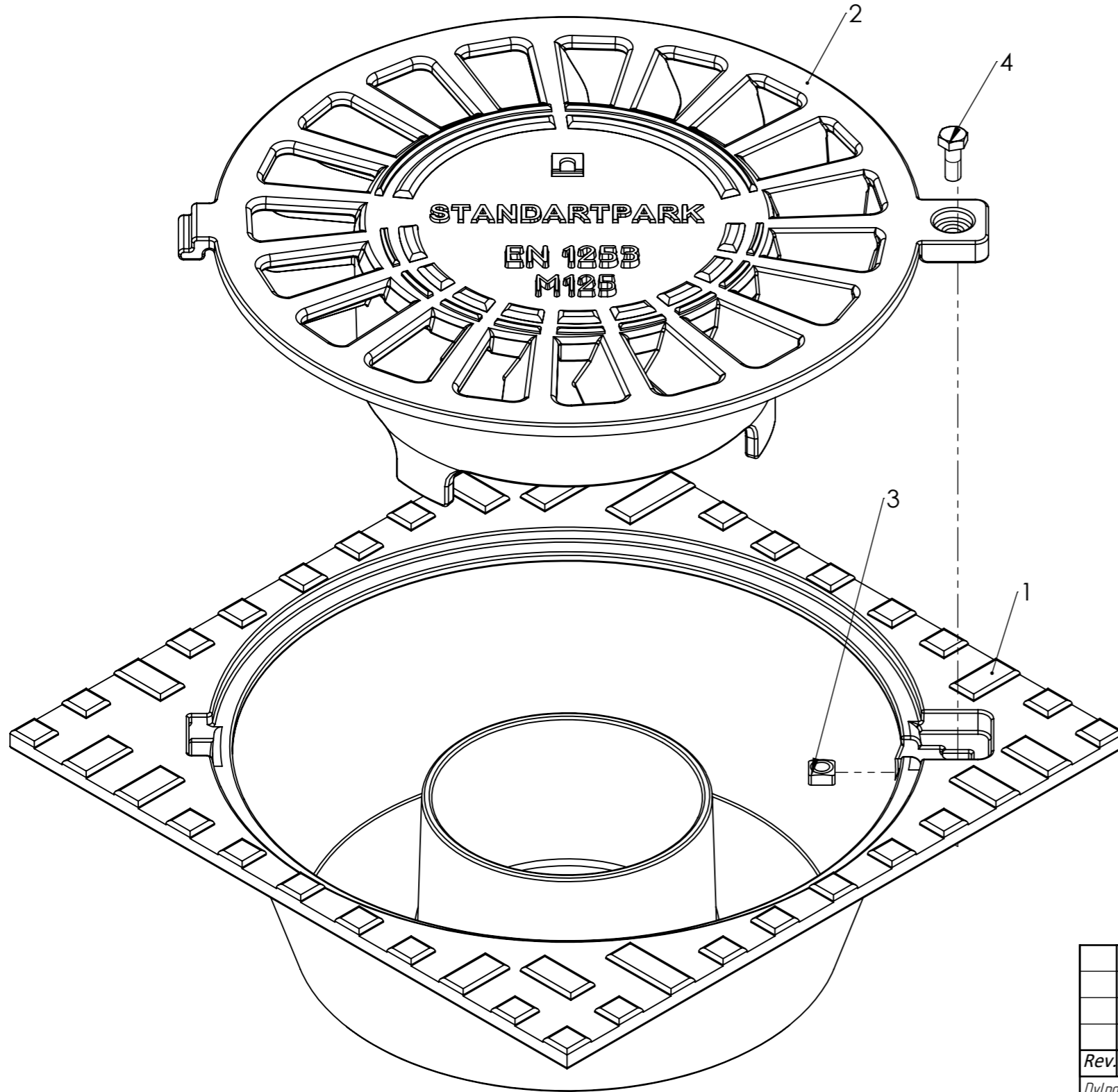
Repl. Inv. No.


Sign. and date

Orig. Inv. No.

ITEM NO.	PART NUMBER	DESCRIPTION	QTY
1	DP-11.30.13-VCH.001		1
2	DP-11.30.13-VCH.002		1
3		Square nut DIN 557	1
4	Bolt M6x16 DIN933 (EN ISO 4017)		1

1. To make molding according to GOST 26358-84;
2. Molding accuracy 9-0-0-9 GOST 26 645-85;
3. Unspecified casting slopes 3°, for inscriptions slop 10°
- 3.1 The outer edges of the upper part of the relief round of radius 1,5 mm; the inner edges of the bottom of the relief round of radius 1mm.
- 3.2 The edges of inscriptions round of radius 0,2 mm.
4. On molding allowed:
 - 4.1. Casting defects in the form of shells at any place on the back side of the grating diameter up to 3 mm, depth up to 2mm quantity up to 6 pcs per casting;
 - 4.2. Deflection of the half-mold up to 1,5mm, it does not affect on the basic dimensions of the casting (fastener assemblies, overall).
 - 4.3. Nicks, explosions inside the letters in the marking, provided the readability of the inscriptions
 - 4.4. Balance feeders up to 1mm, it does not affect the overall dimensions of castings
5. Casting paints in black color, thick of painting paint – min 40 mk;
6. On the front side of the casting defect is allowed "rugosity" length up to 15mm, width up to 1mm, depth up to 1mm;
7. On casting junctions is allowed.
 - 7.1. On the front side length up to 10mm, depth up to 1/3 of castings no more than 3 pcs. in the casting without group location
 - 7.2. On the reverse side up to 10 mm, depth up to 5mm, no more than 5 pcs. in the casting without group location
8. Casting clean from molding sand and burning-on, the remains of feeders cut off and clean
9. * - Sizes for notes;
10. Mark the article number – EN 124 C250 Font 6-Пp3 GOST 26.008-85 concave;
11. Mark the date of manufacture of the hatches in the format MMY Y (month, year). Font 5-Pr3 GOST 26.008-85 is concave.
12. To the drawing model L-60.80.16-GGG50-S5.000 STEP is attached, to clarify the geometry of the grating.
13. The font of the main inscriptions Arial is bold 10mm.



				Art. 3335313-5				
				DP-11.30.13-VCH				
Rev.	Sheet	Doc. No.	Sign.	Data	Trap type M125 GGG50	Let.	Weight (lb)	Scale
							9.26	1:2
						Sheet 1	Sheets 6	
						GGG50		
Reg. Doc. Ctrl	Dyka							
Aprvd by	Darel				Copied by Size A3			

DP-11.30.13-VCH

Primary Usage

Reference No.

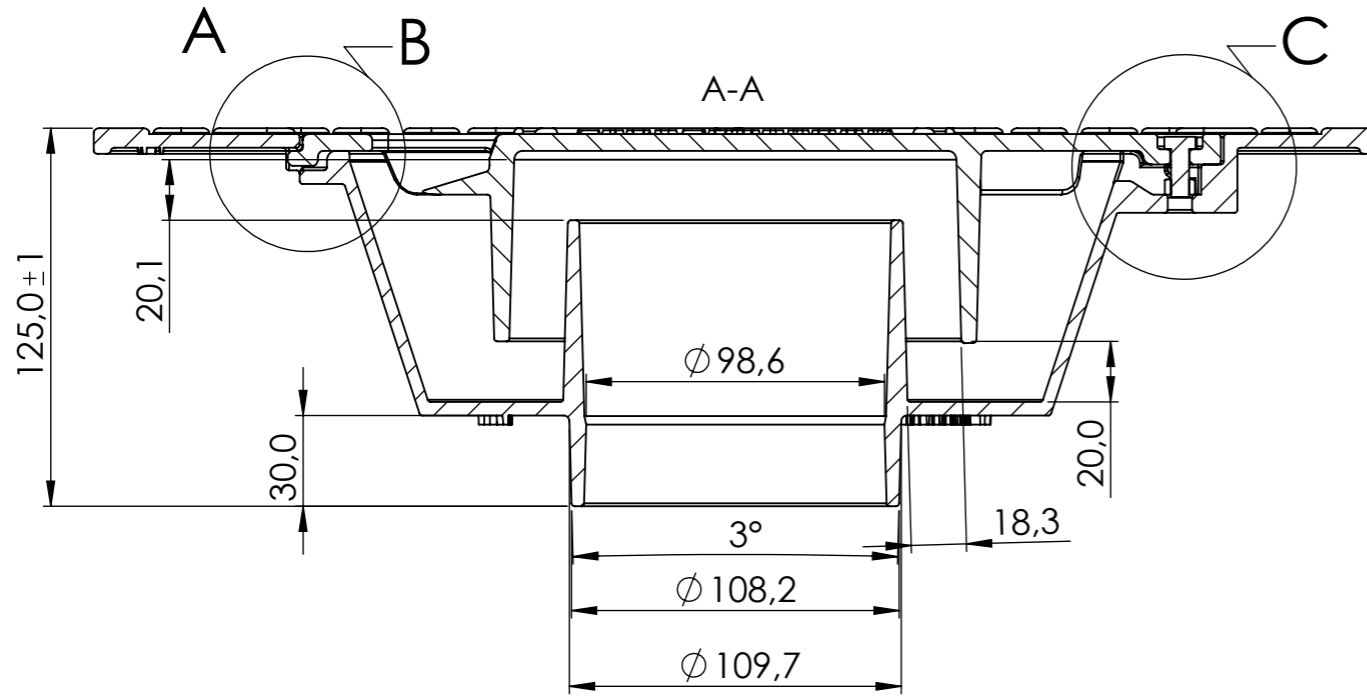
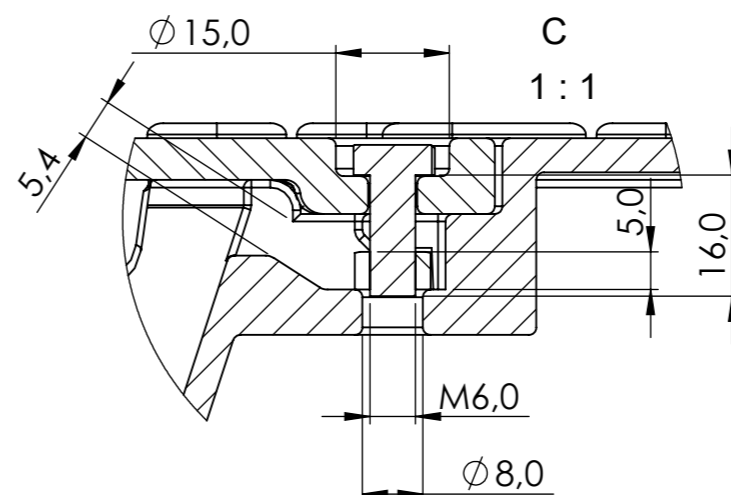
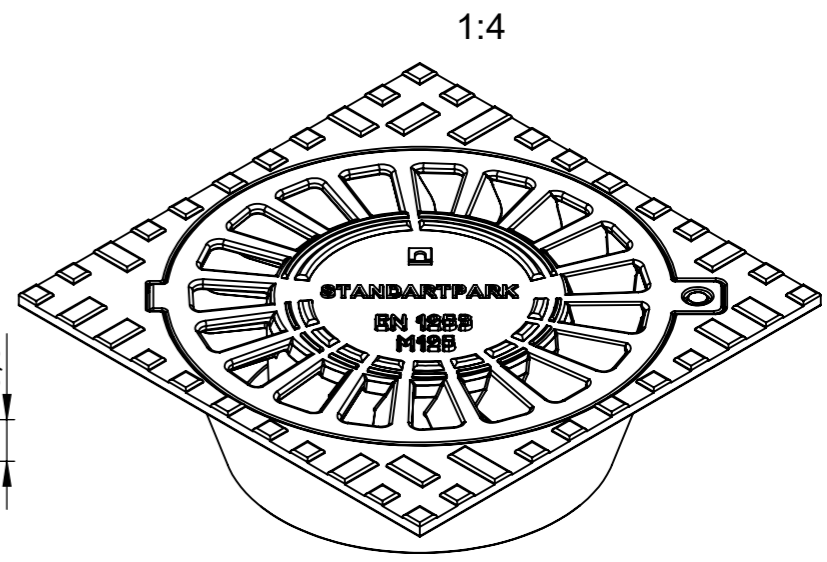
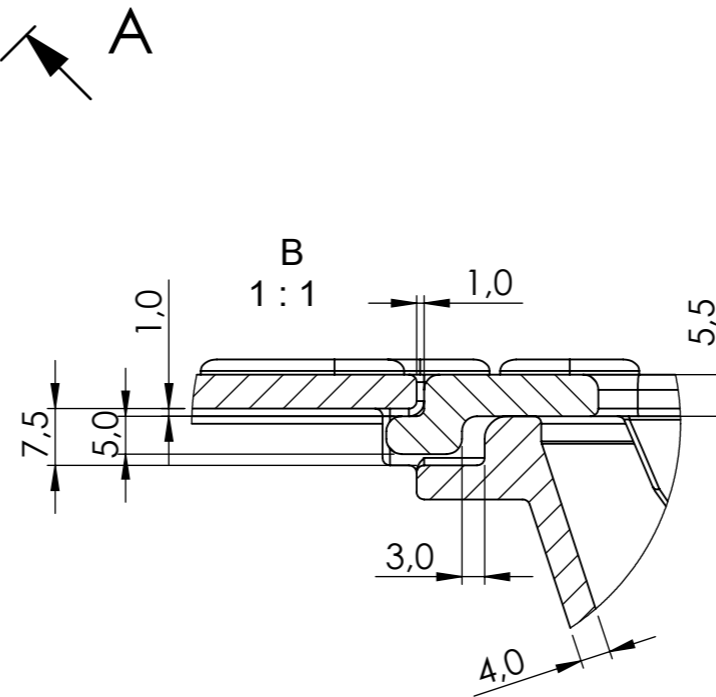
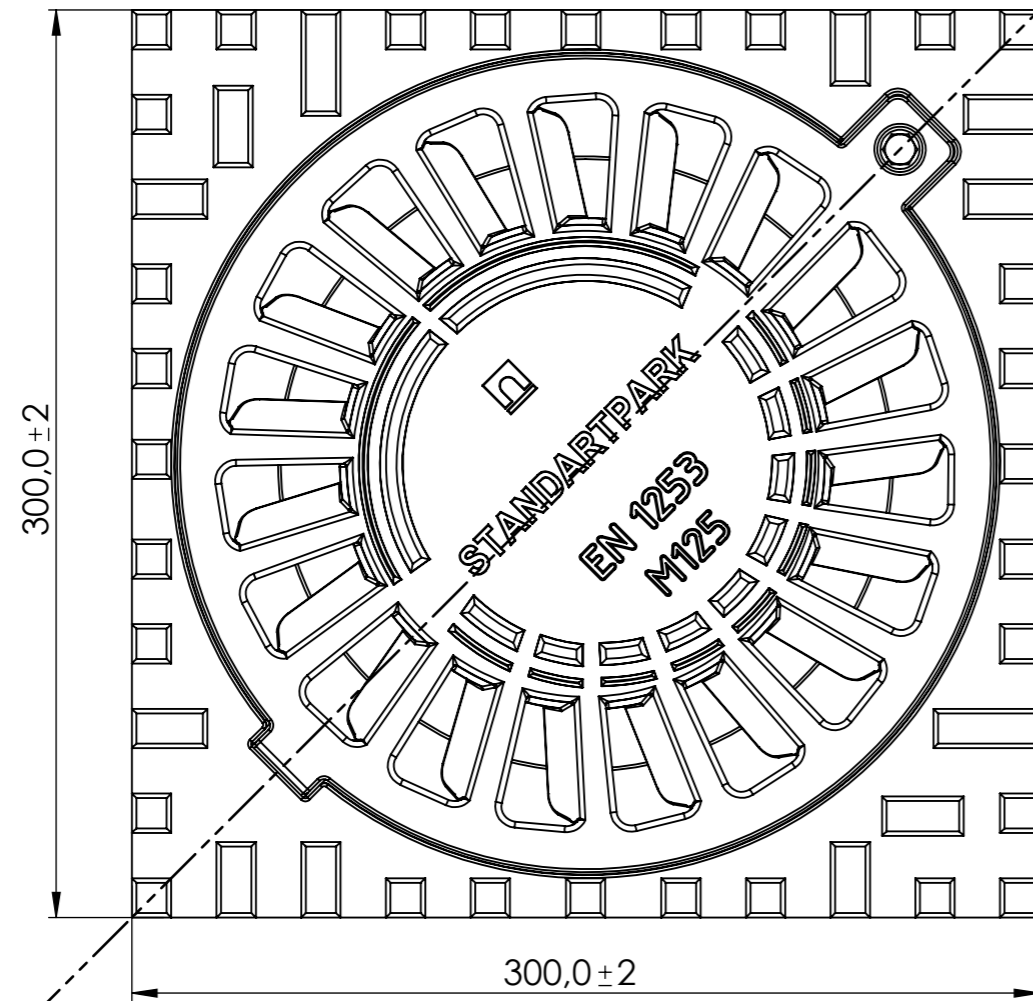
Sign. and date


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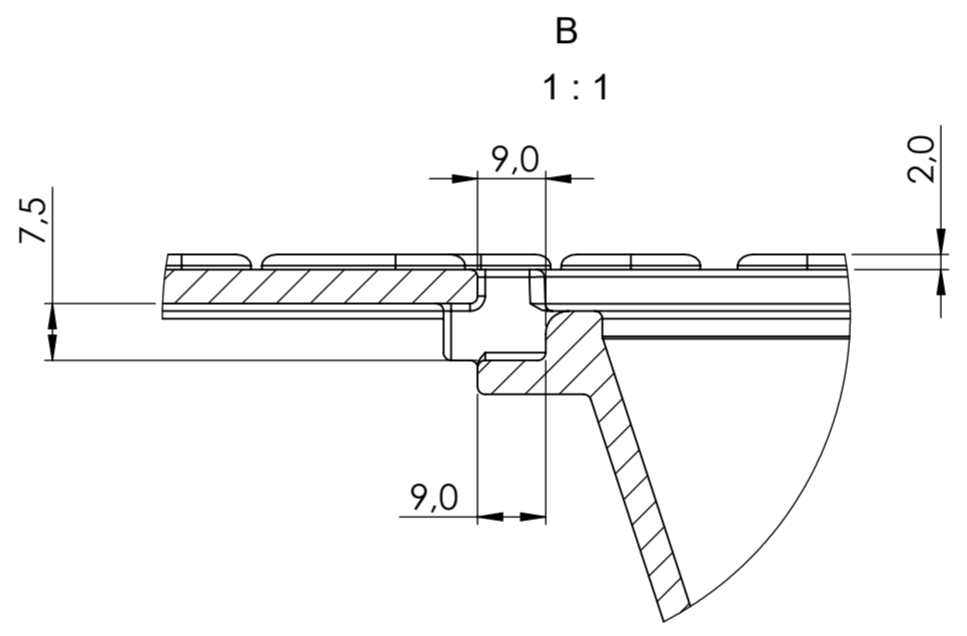
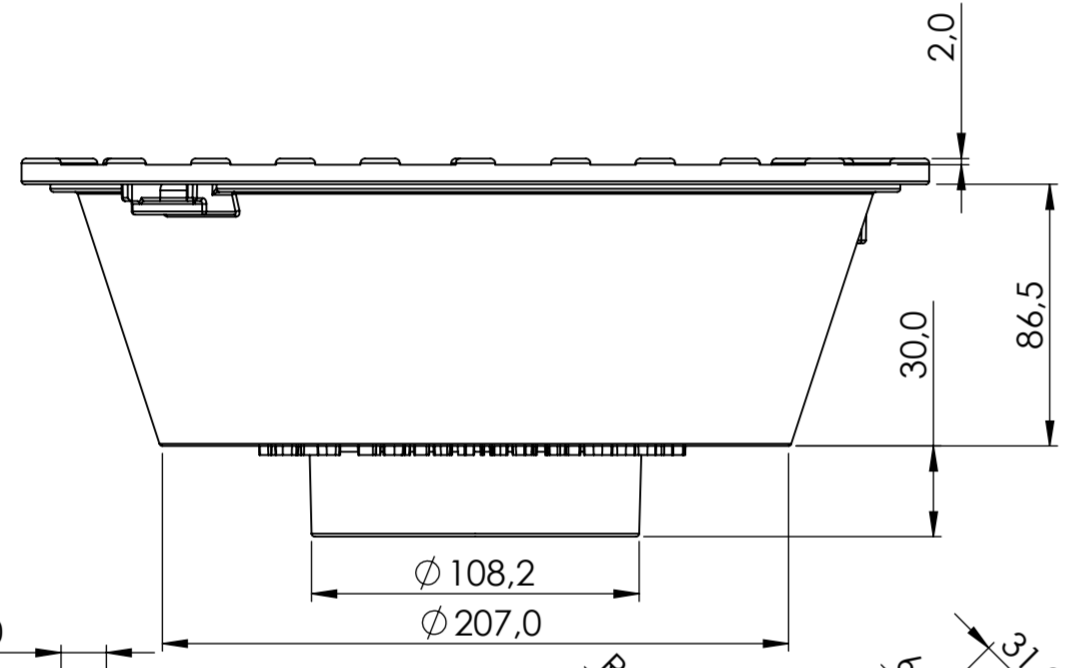
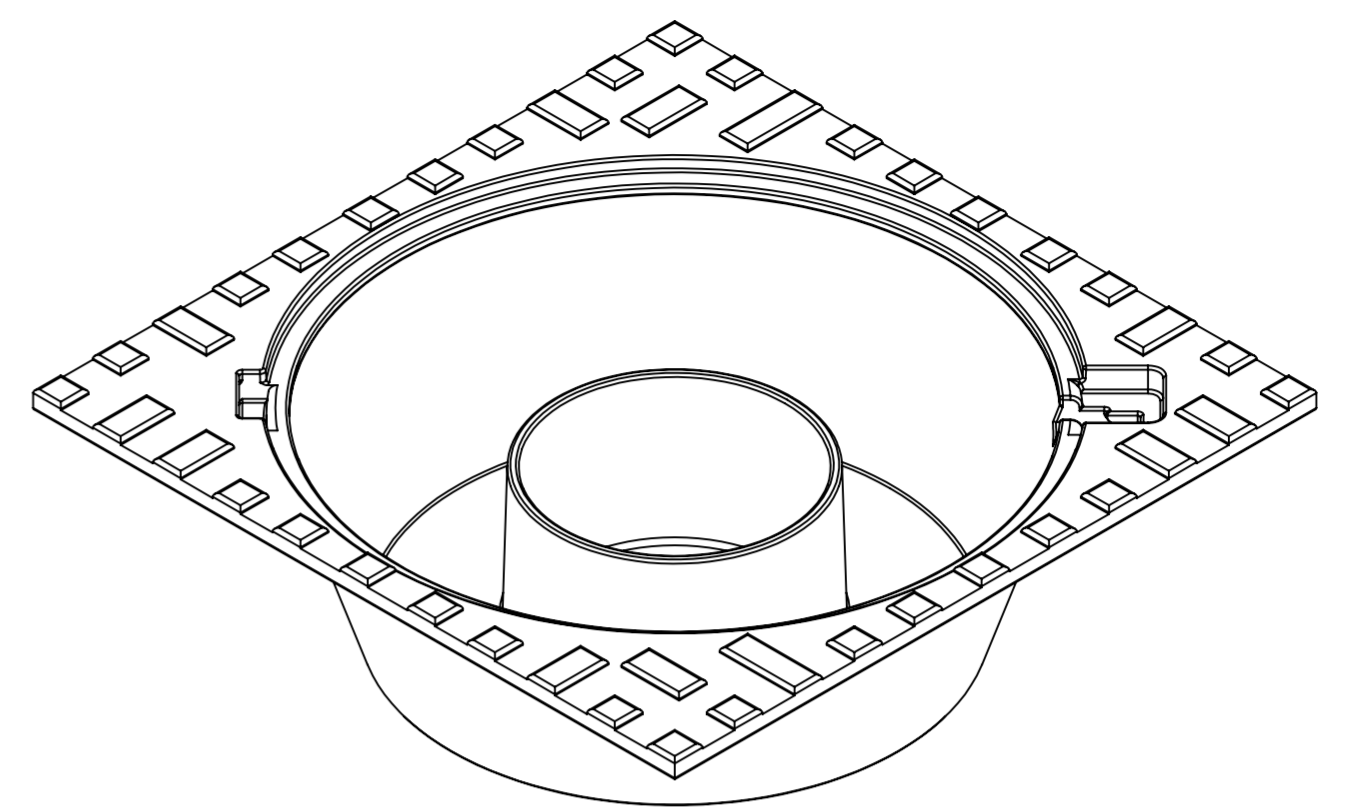
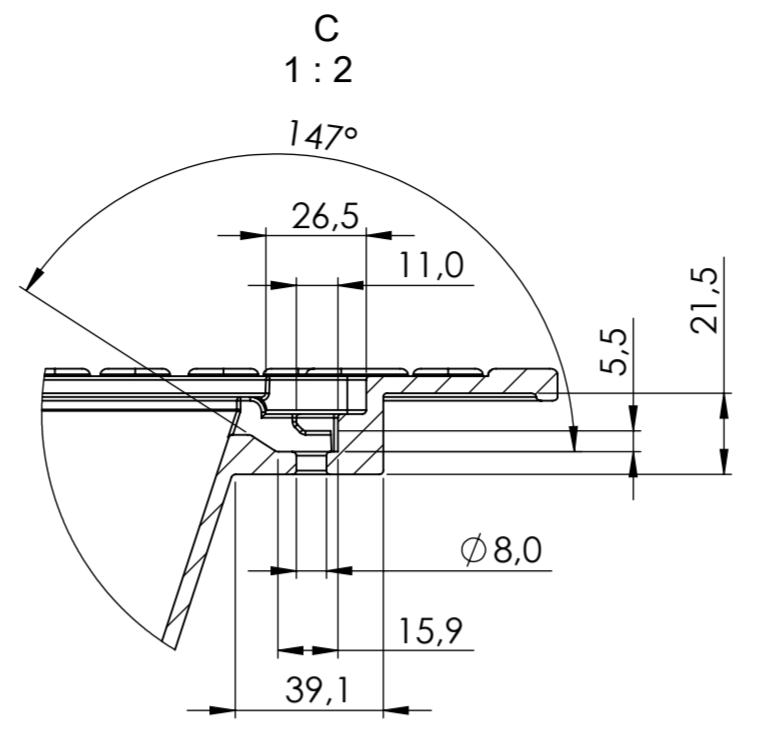
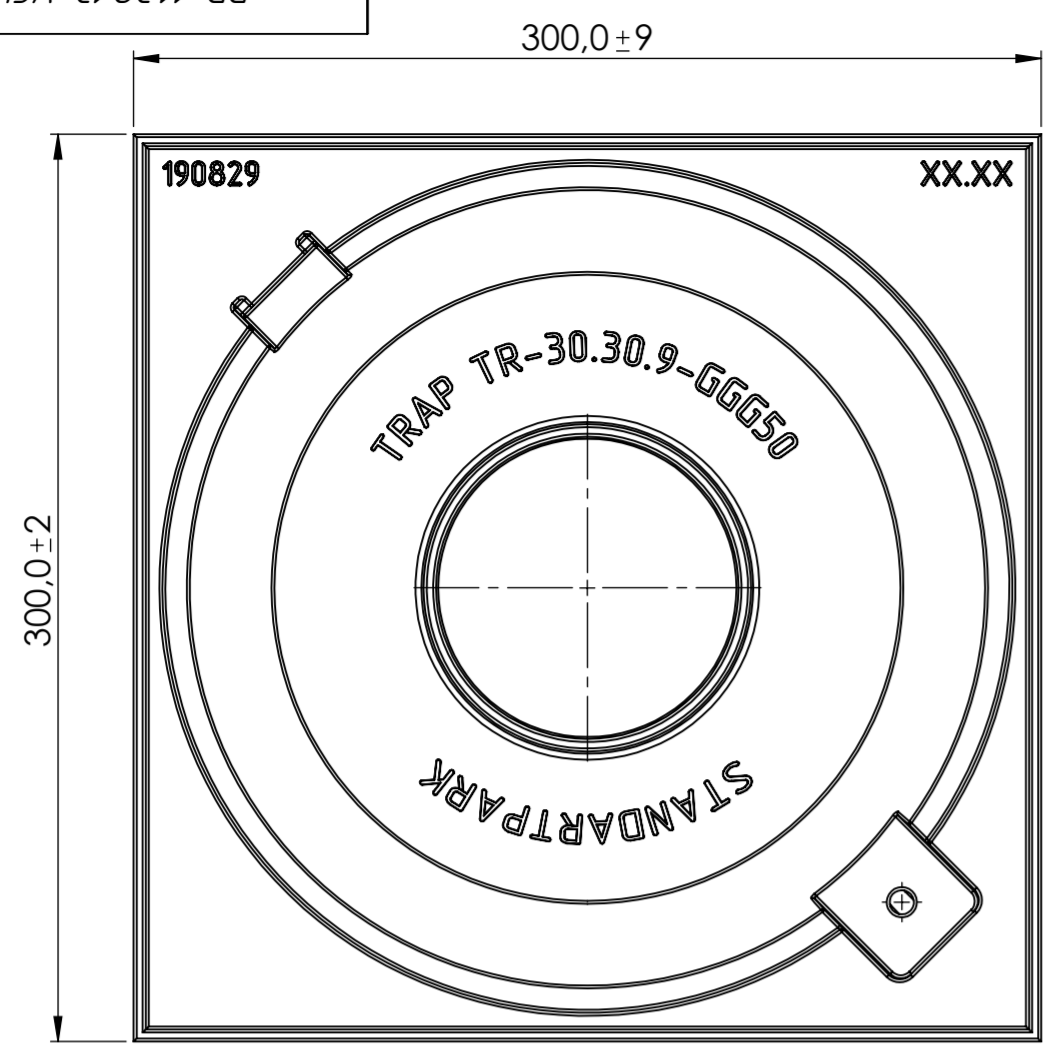
Repl. Inv. No.

Sign. and date

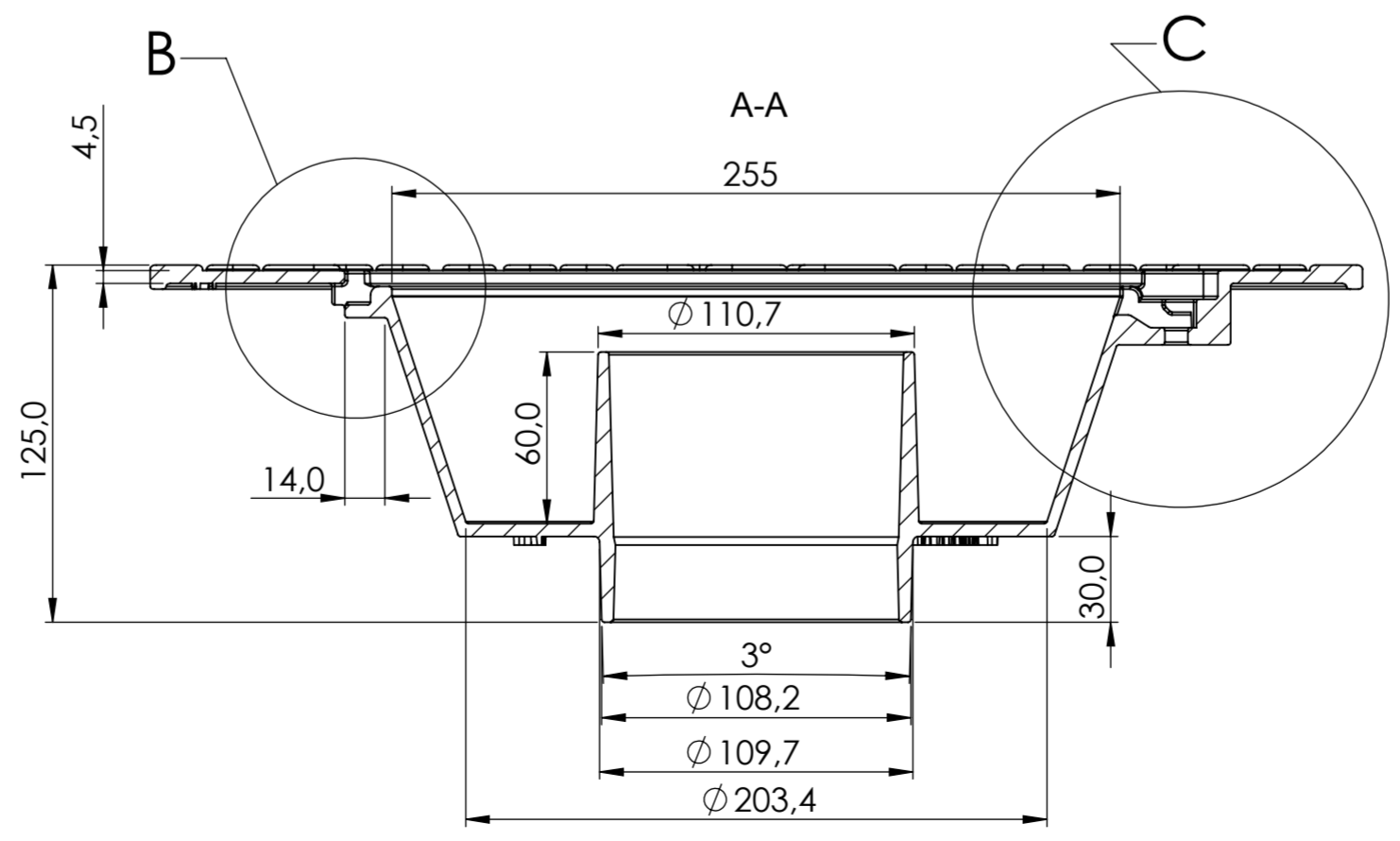
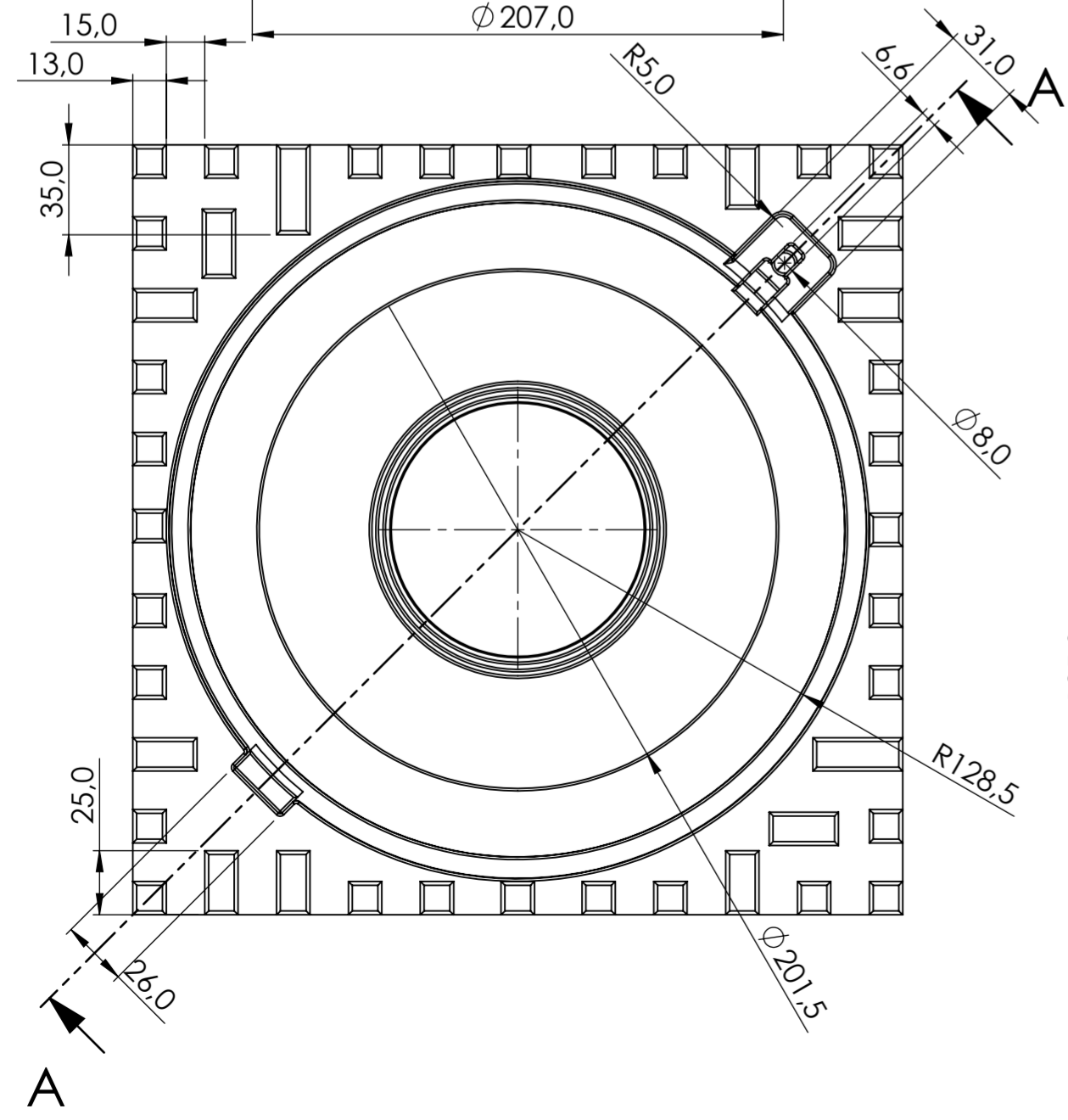
Orig. Inv. No.



				Art. 3335313-5				
				DP-11.30.13-VCH				
Rev.	Sheet	Doc. No.	Sign.	Data	Trap type M125 GGG50	Let.	Weight (lb)	Scale
							9.26	1:25
						Sheet 2	Sheets 6	
						GGG50		
Reg. Doc. Ctrl	Dyka							
Aprvd by	Darel				Copied by Size A3			



1. To make molding according to GOST 26358-84;
2. Molding accuracy 9-0-0-9 GOST 26 645-85;
3. Unspecified casting slopes 3°, for inscriptions slope 10°
- 3.1 The outer edges of the upper part of the relief round of radius 1.5 mm, the inner edges of the bottom of the relief round of radius 1mm.
- 3.2 The edges of inscriptions round of radius 0.2 mm.
4. On molding allowed:
 - 4.1 Casting defects in the form of shells at any place on the back side of the grating diameter up to 3 mm, depth up to 2mm quantity up to 6 pcs per casting;
 - 4.2 Deflection of the half-mold up to 1.5mm, it does not affect on the basic dimensions of the casting (fastener assemblies, overall).
 - 4.3 Nicks, explosions inside the letters in the marking, provided the readability of the inscriptions
 - 4.4. Balance feeders up to 1mm, it does not affect the overall dimensions of castings
5. Casting paints in black color, thick of painting paint – min 40 мк;
6. On the front side of the casting defect is allowed "rugosity" length up to 15mm, width up to 1mm, depth up to 1mm;
7. On casting junctions is allowed.
 - 7.1. On the front side length up to 10mm, depth up to 1/3 of castings no more than 3 pcs. in the casting without group location
 - 7.2. On the reverse side up to 10 mm, depth up to 5mm, no more than 5 pcs. in the casting without group location
8. Casting clean from molding sand and burning-on, the remains of feeders cut off and clean
9. * - Sizes for notes;
10. Mark the article number – EN 124 C250 Font 6-Пp3 GOST 26.008-85 concave;
11. Mark the date of manufacture of the hatches in the format MMY Y (month, year). Font 5-Pr3 GOST 26.008-85 is concave.
12. To the drawing model L-60.80.16-GGG50-S5.000 STEP is attached, to clarify the geometry of the grating.
13. The font of the main inscriptions Arial is bold 10mm.



Primary Usage
Reference No.
Sign. and date
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Sign. and date
Orig. Inv. No.

				Art. 3335313-5			
				DP-11.30.13-VCH.001			
Rev. Sheet	Doc. No.	Sign.	Data	Trap type M125 GGG50	Let.	Weight (lb)	Scale
Dvlpd by	Prakapenka		29.08.2019			5.11	1:2.5
Chkd by	Kachanovskyy			GGG50	Sheet 3	Sheets 6	
Tech. Ctrl	Tsyurak				standartpark		
Reg. Doc. Ctrl	Dyka						
Aprvd by	Darel						

Primary Usage

Reference No.

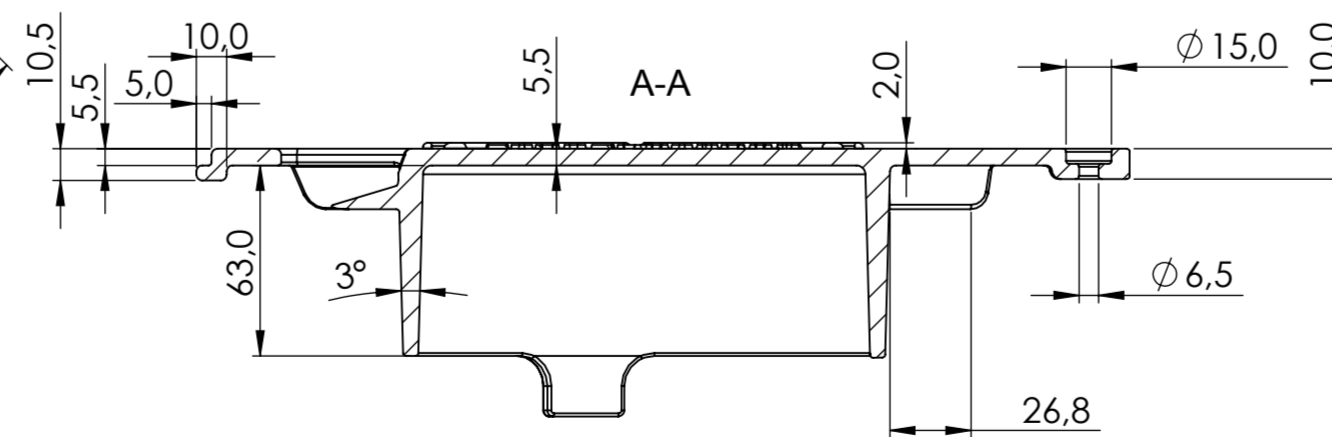
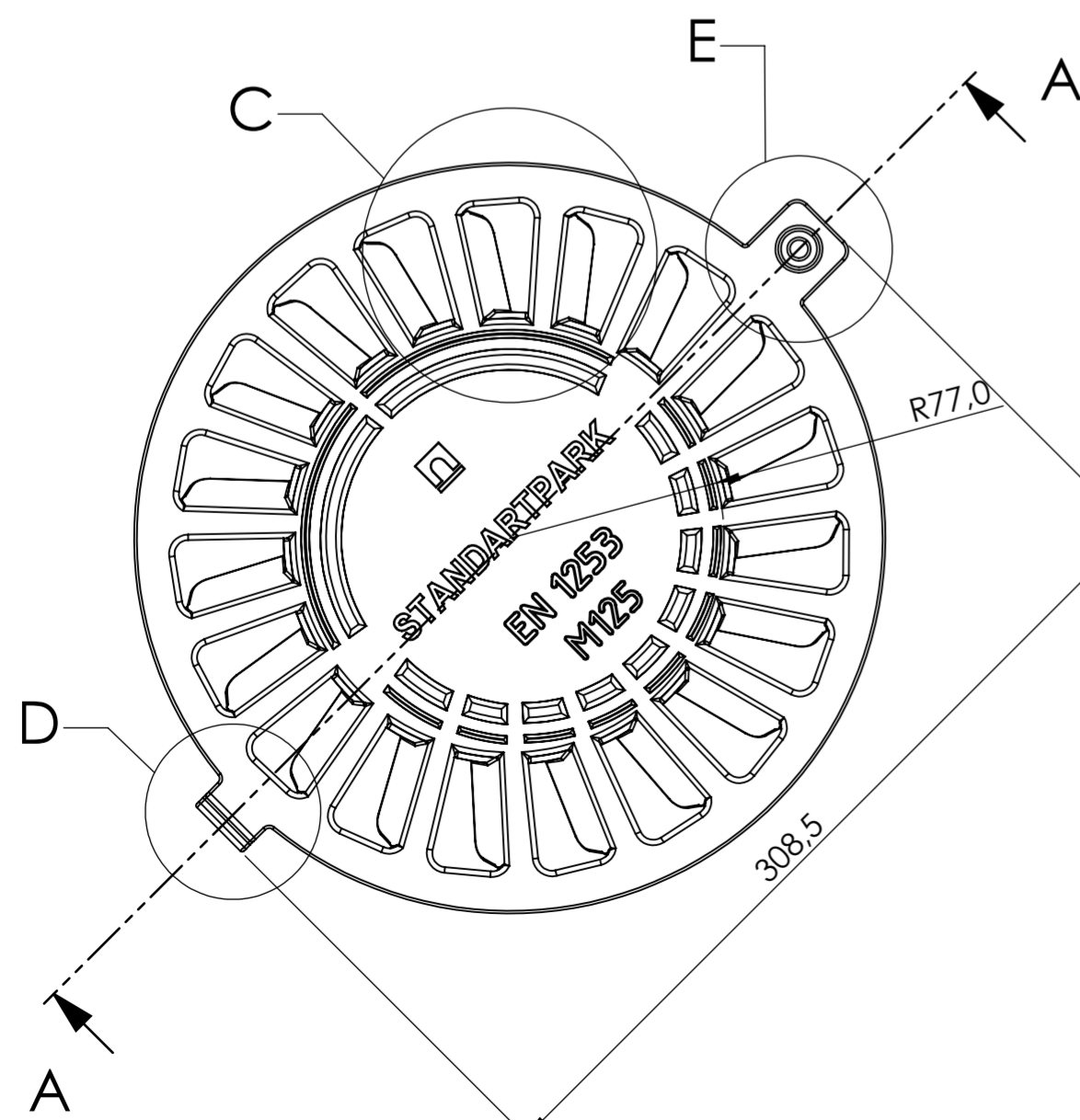
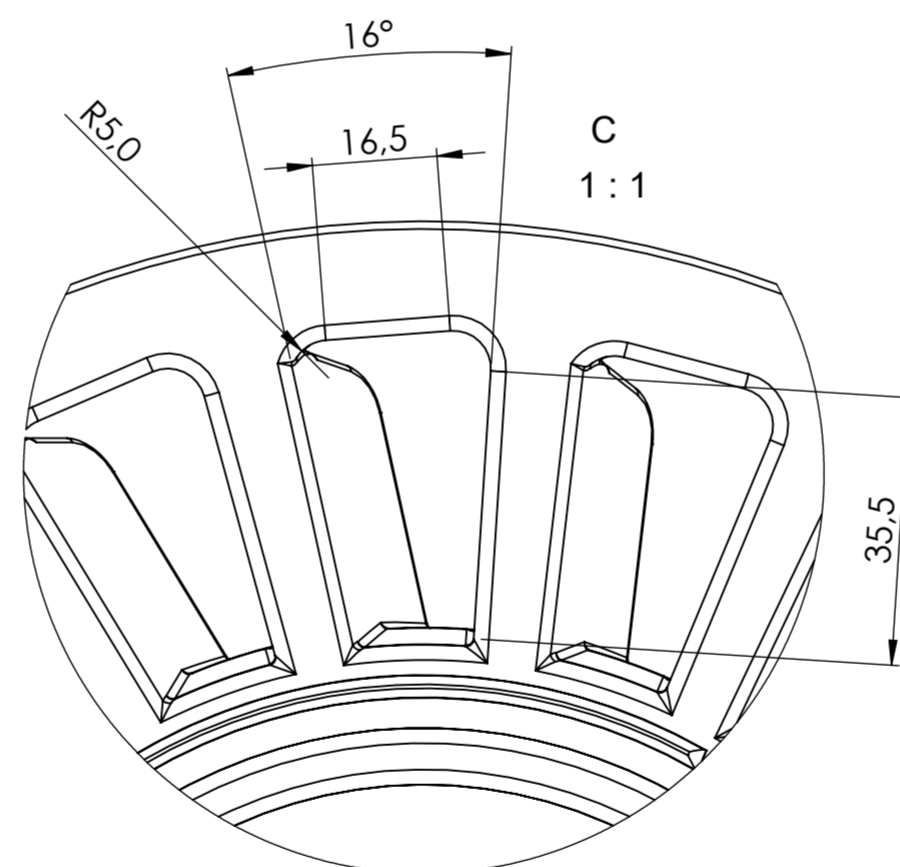
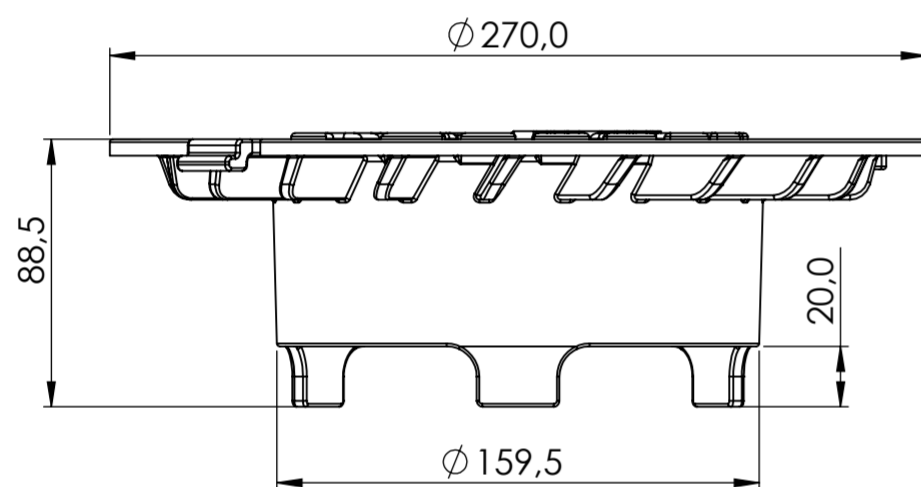
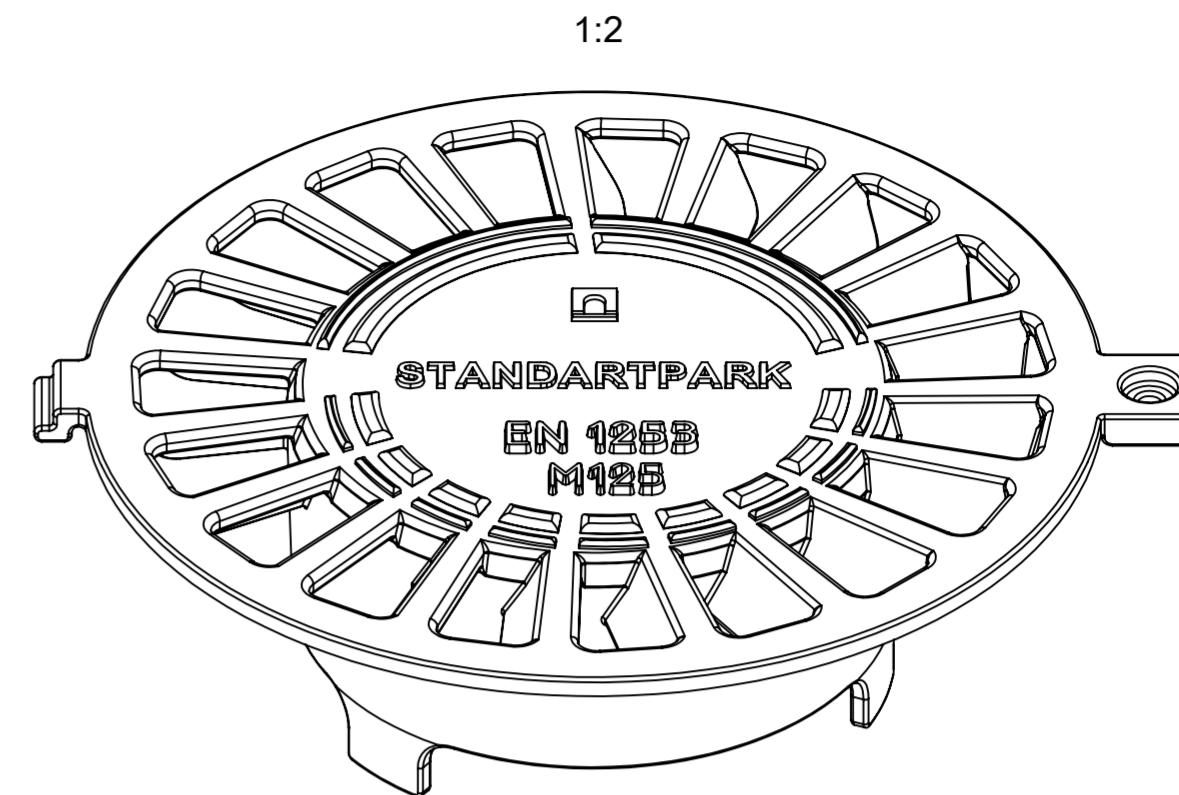
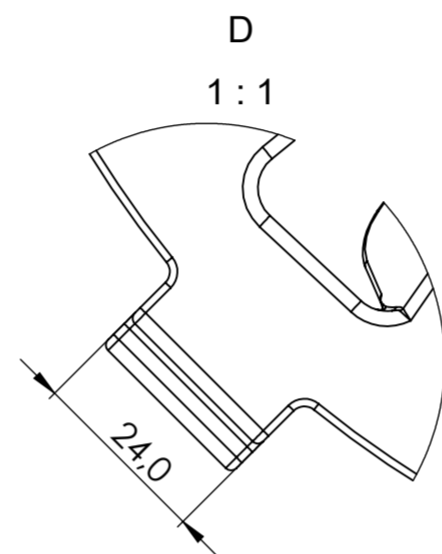
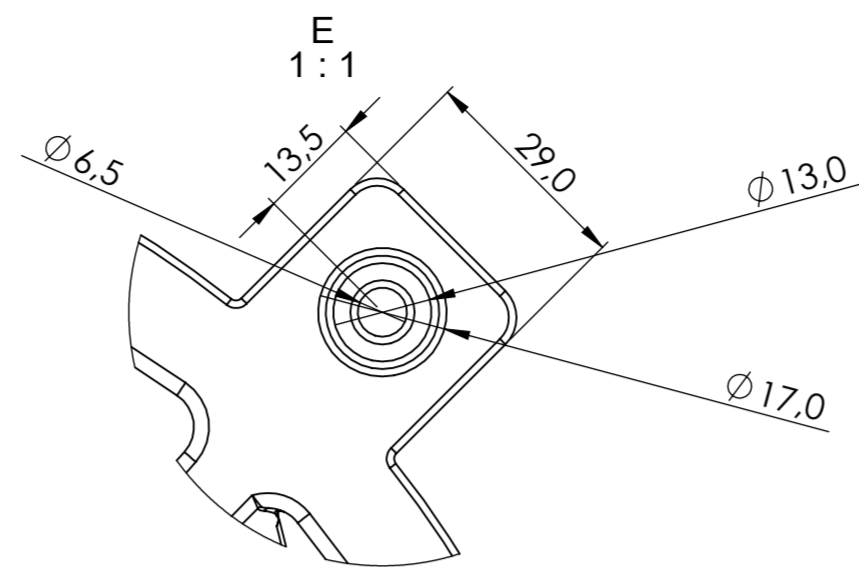
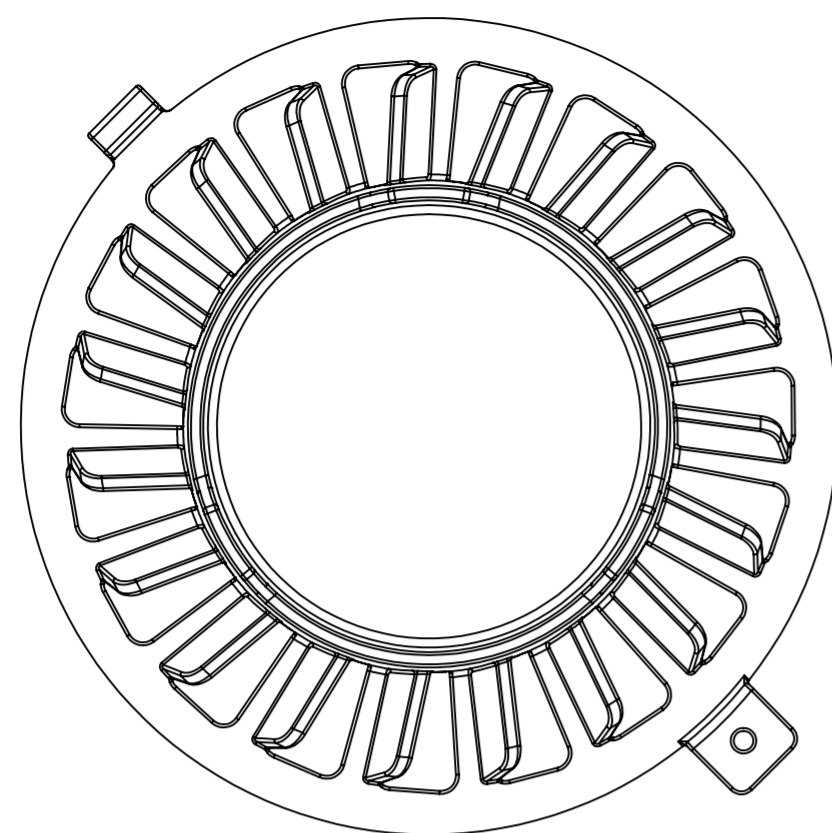
Sign. and date

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Orig. Inv. No.



1. To make molding according to GOST 26358-84;
2. Molding accuracy 9-0-0-9 GOST 26 645-85;
3. Unspecified casting slopes 3°, for inscriptions slope 10°
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 - 4.4 Balance feeders up to 1 mm, it does not affect the overall dimensions of castings
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 - 7.2. On the reverse side up to 10 mm, depth up to 5 mm, no more than 5 pcs. in the casting without group location
8. Casting clean from molding sand and burning-on, the remains of feeders cut off and clean
9. * - Sizes for notes;
10. Mark the article number - EN 124 C250 Font 6-Пp3 GOST 26.008-85 concave;
11. Mark the date of manufacture of the hatches in the format MMY (month, year). Font 5-Pr3 GOST 26.008-85 is concave.
12. To the drawing model L-60.80.16-GGG50-S5.000 STEP is attached, to clarify the geometry of the grating.
13. The font of the main inscriptions Arial is bold 10 mm.

				DP-11.30.13-VCH.002			Art. 3335313-5	
Rev.	Sheet	Doc. No.	Sign.	Data	Trap type M125 GGG50	Let.	Weight (lb)	Scale
				29.08.2019			3.28	1:2.5
						Sheet 4	Sheets 6	
Reg. Doc. Ctrl.	Dyka				GGG50			
Aprvd by	Darel							

DP-11.30.13-VCH

Primary Usage

Reference No.

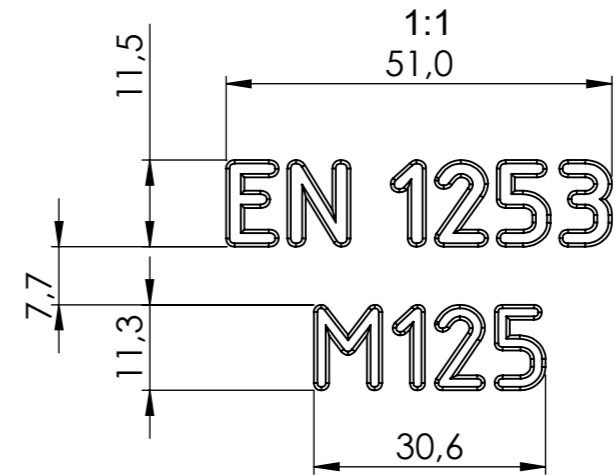
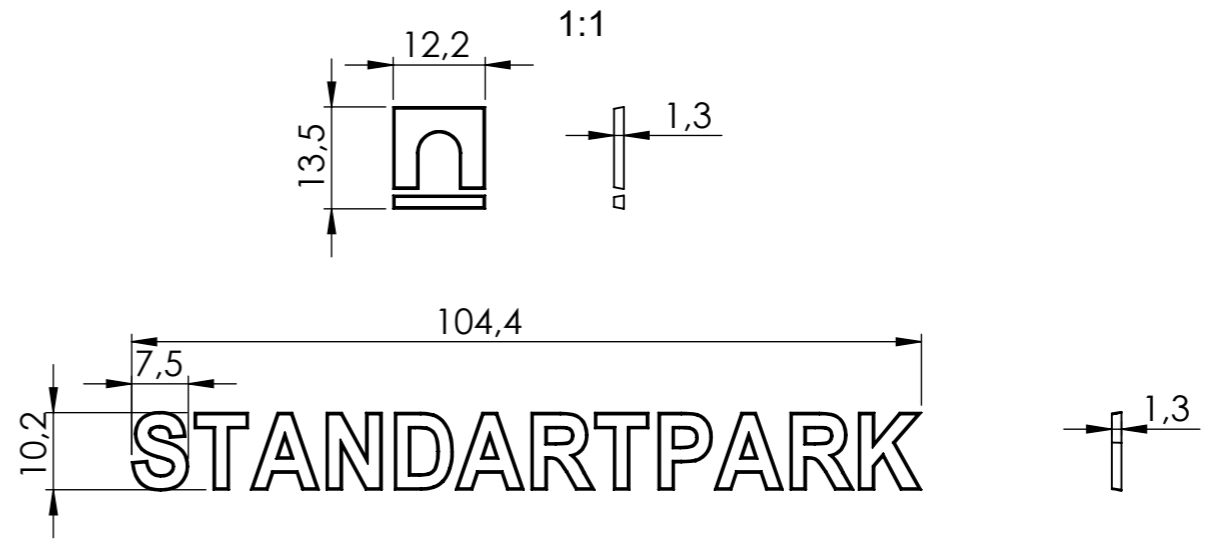
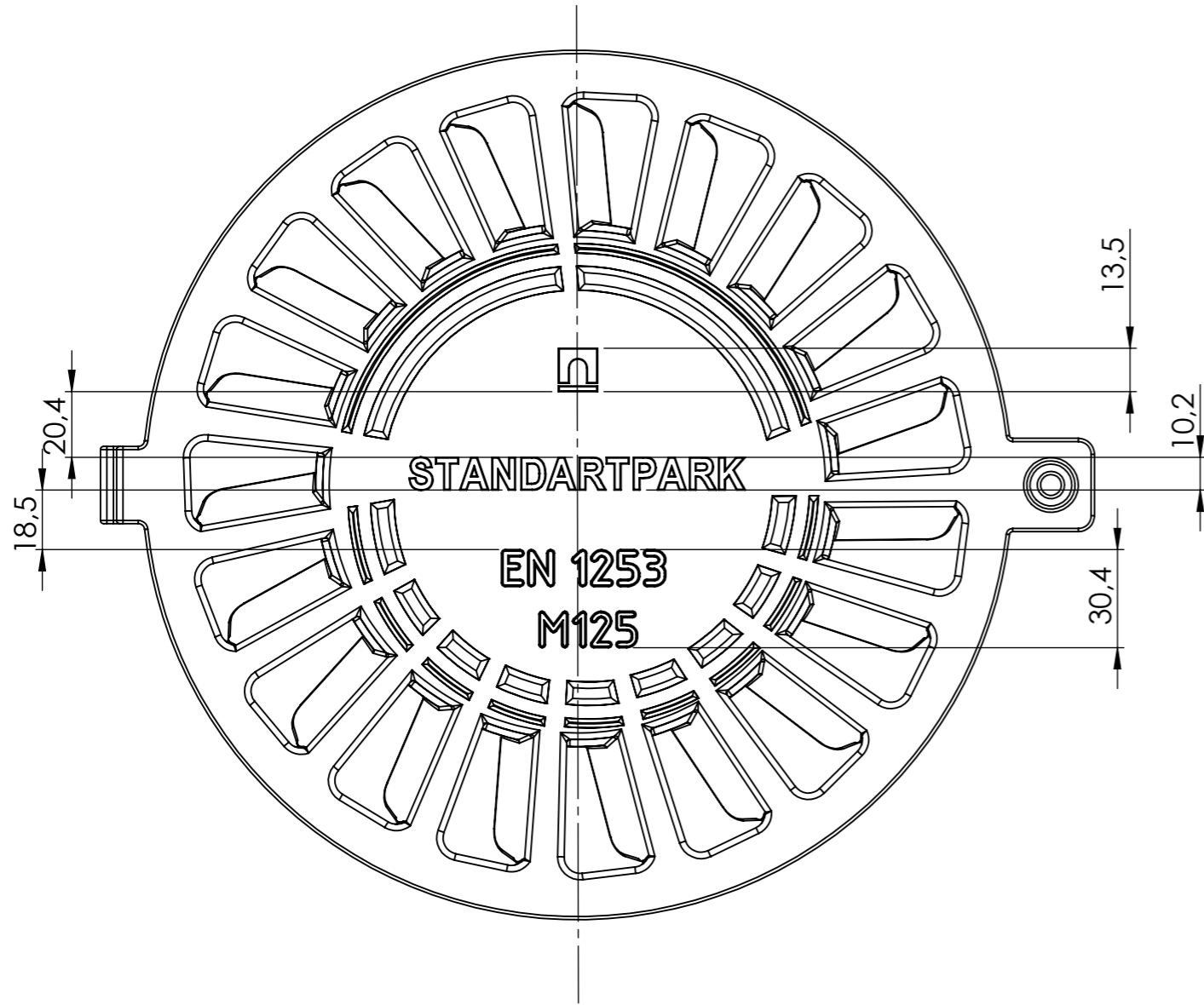
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Sign. and date

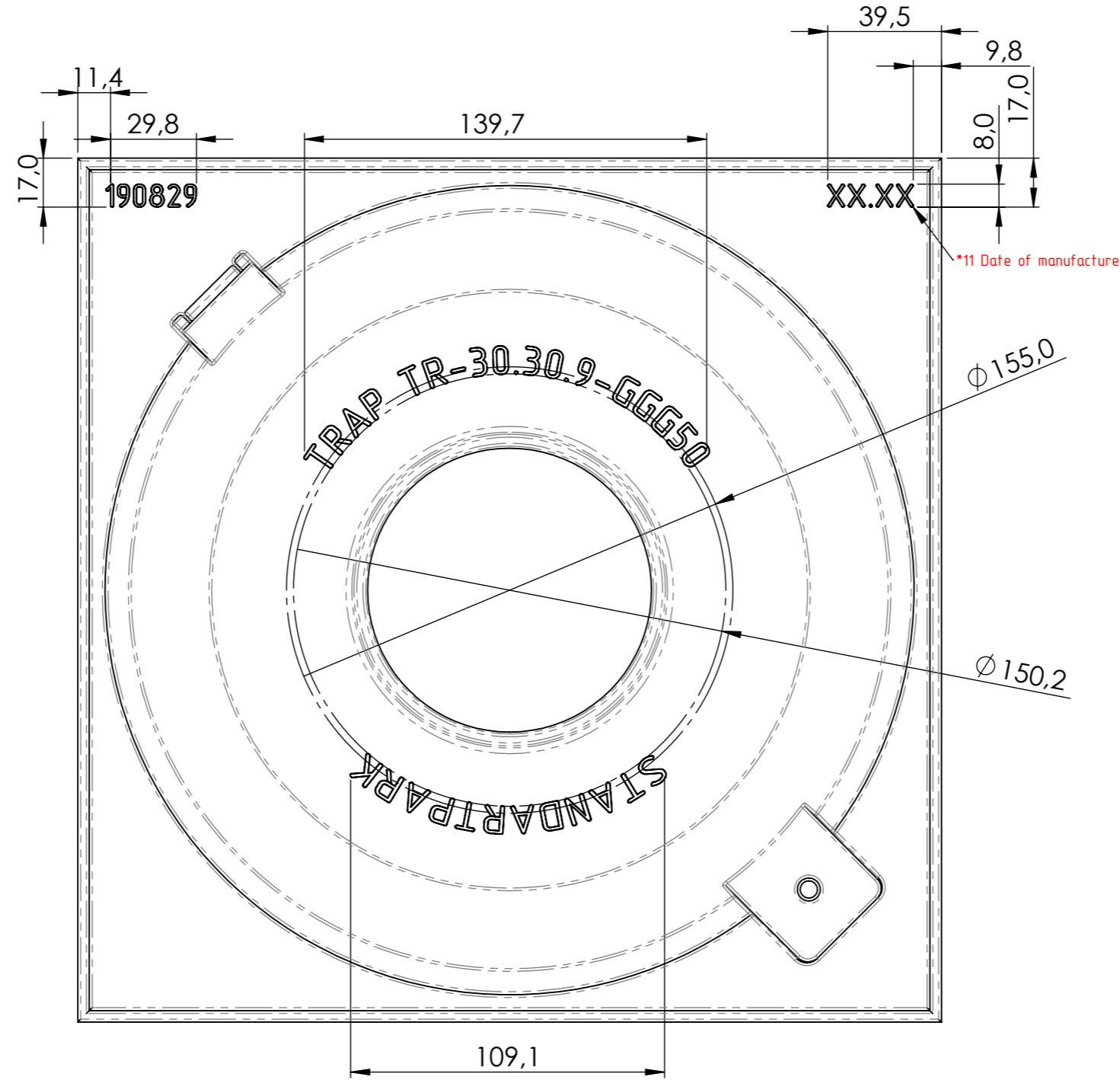
Orig. Inv. No.



				DP-11.30.13-VCH			Art.	3335313-5
Rev.	Sheet	Doc. No.	Sign.	Data	Cover "Inscriptions on top"	Let.	Weight (lb)	Scale
				29.08.2019			9.26	1:25
Dvlpd by		Prakopenko				Sheet 5	Sheets 6	
Chkd by		Kachanovskyy						
Tech. Ctrl		Tsyurak						
Reg. Doc. Ctrl		Dyka			GGG50			
Aprvd by		Darel						

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				DP-11.30.13-VCH			Art. 3335313-5		
Rev.	Sheet	Doc. No.	Sign.	Data	Cover "Marking bottom"	Let.	Weight (lb)	Scale	
								9.26	1:25
Dvlpd by		Prakopenko		29.08.2019					
Chkd by		Kachanovskyy							
Tech. Ctrl		Tsyurak				Sheet 6		Sheets 6	
Reg. Doc. Ctrl		Dyka			GGG50				
Aprvd by		Darel							