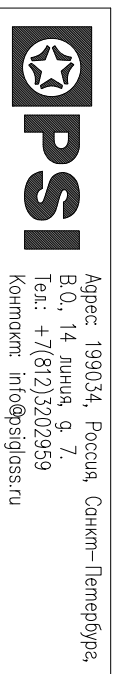


PSI logo

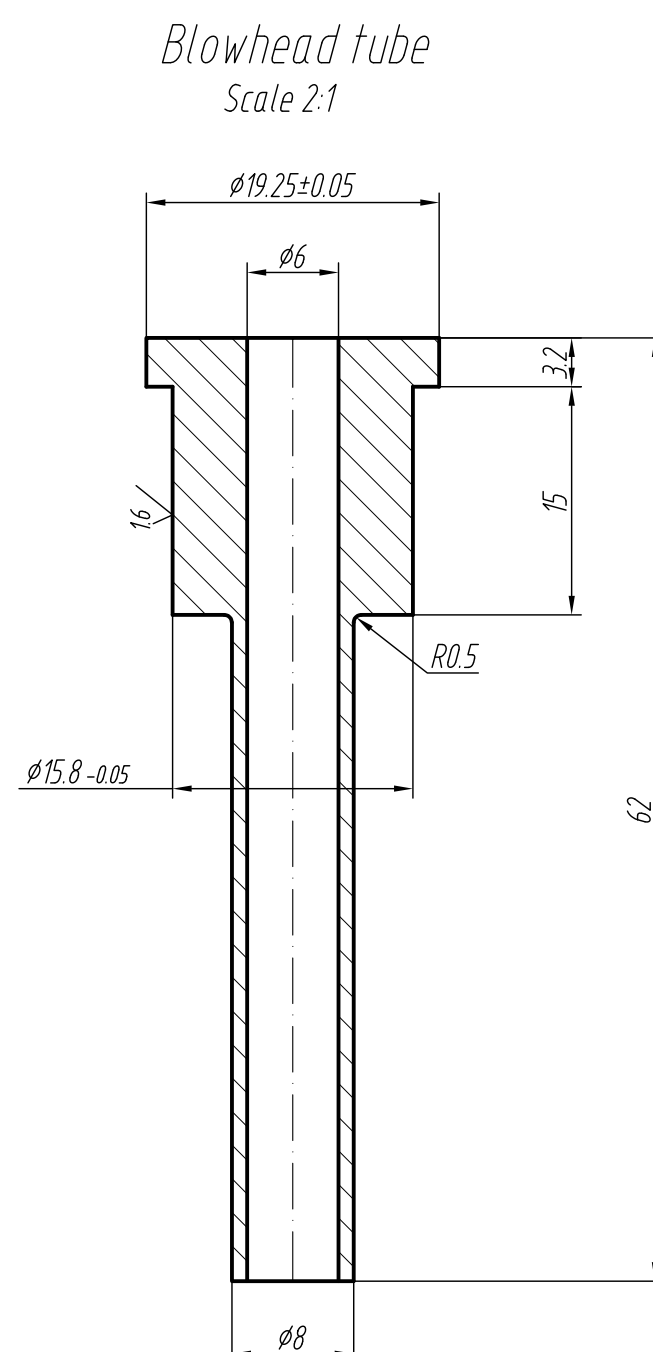
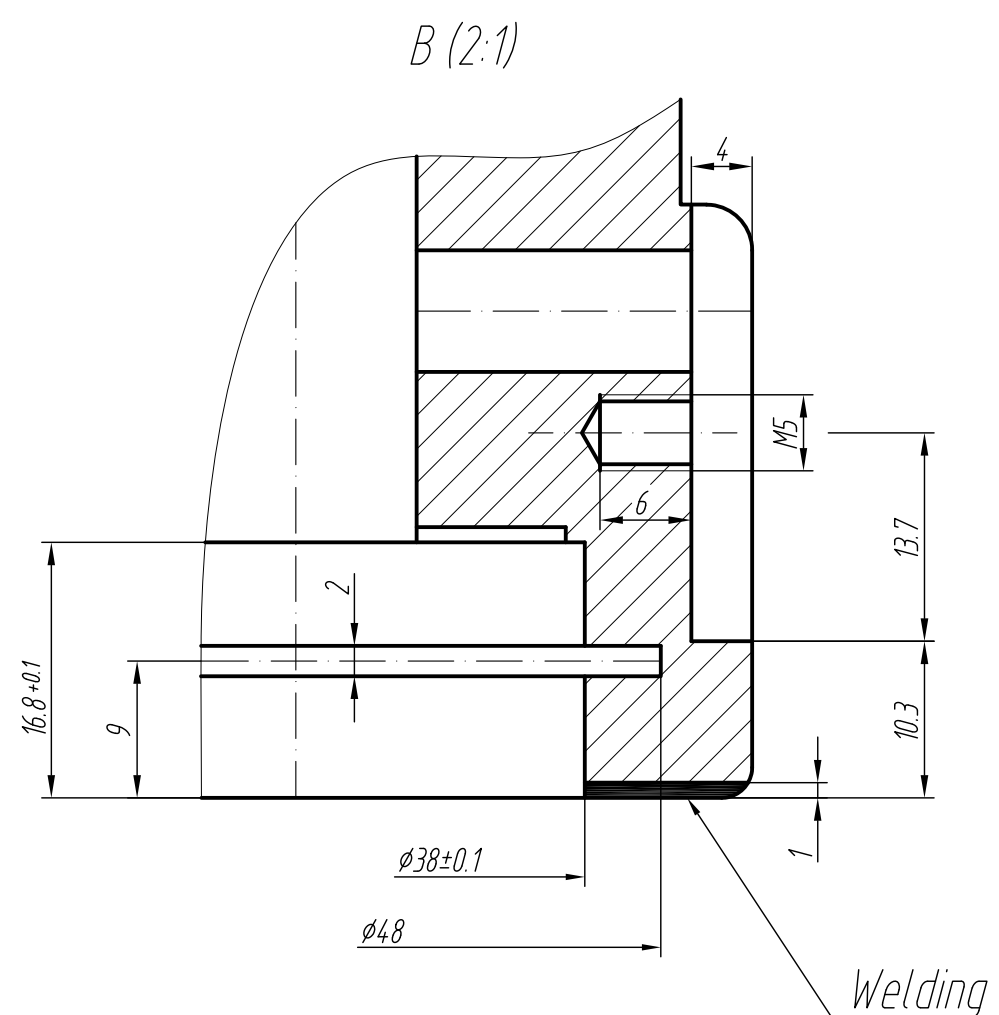
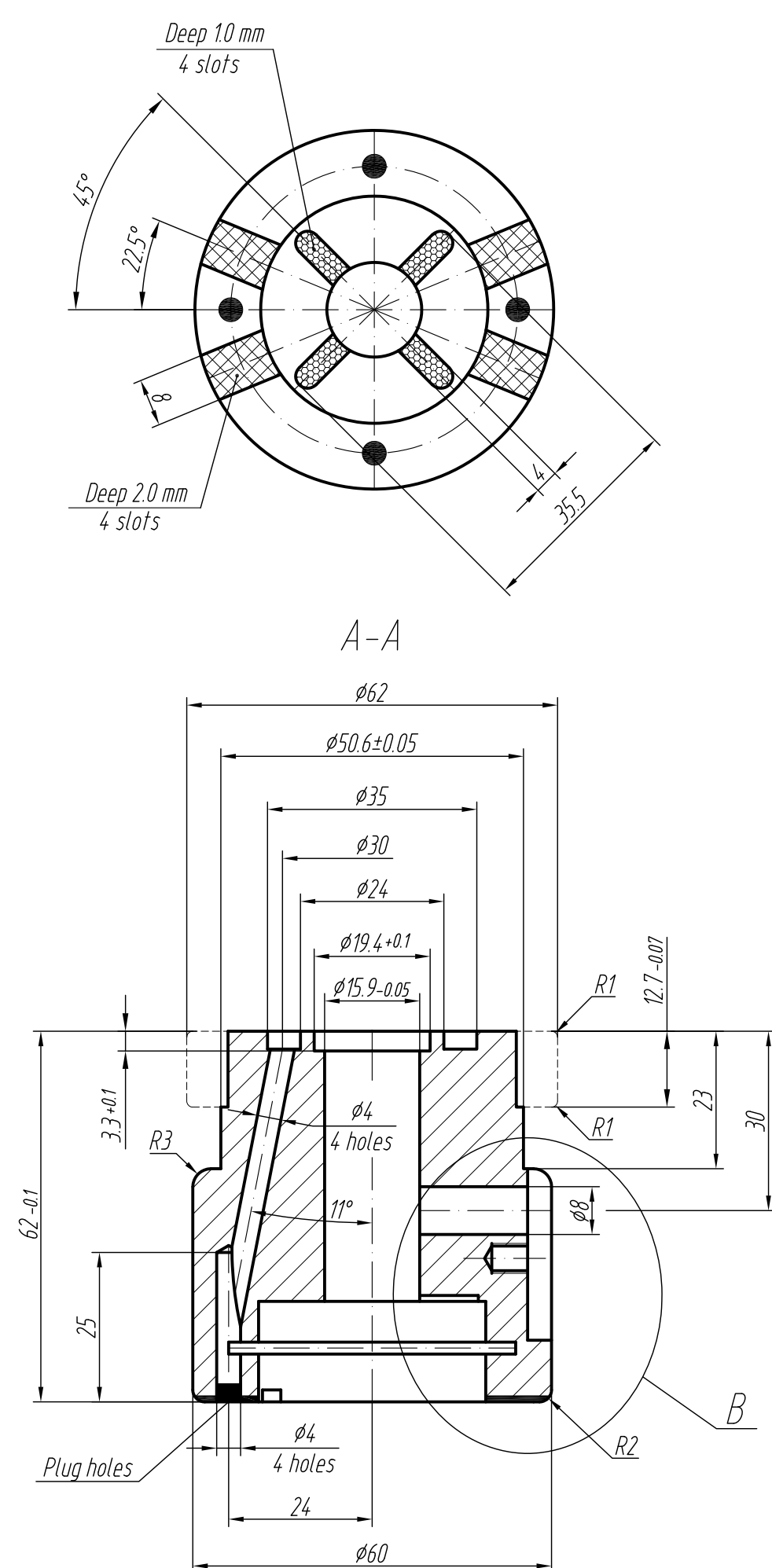
- 1 H14, h14, ±T14/2
 - 2 Keep sharp edges B
 - 3 *Reference only dimensions
 4. Hardness after welding HRC35..40.
 - 5 Mark- XXI-KPM-26-2-700-17-ExtraNew
- Mark- 5015
- Mark ordinal number (h=7) & PSI logo.
- Depth of marking-0.2...0.3 mm.

Milling of cavity must be performed according to the 3D model

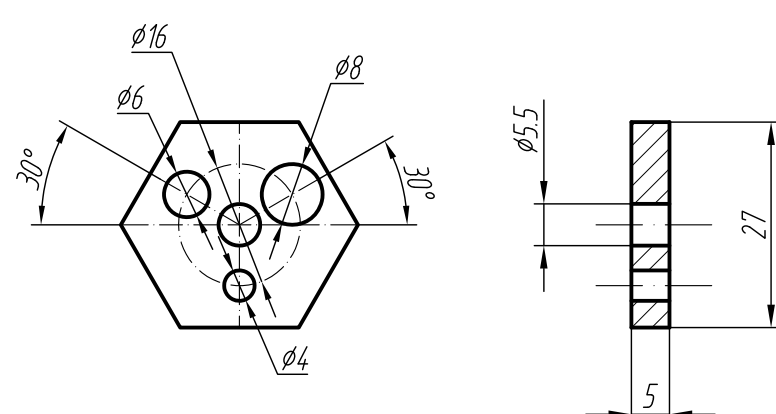
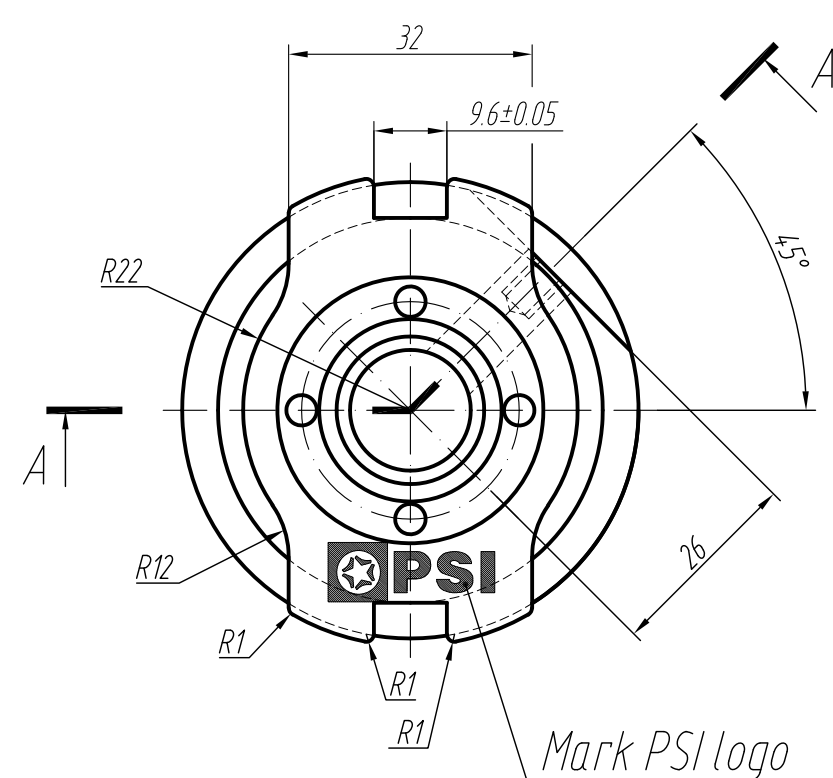
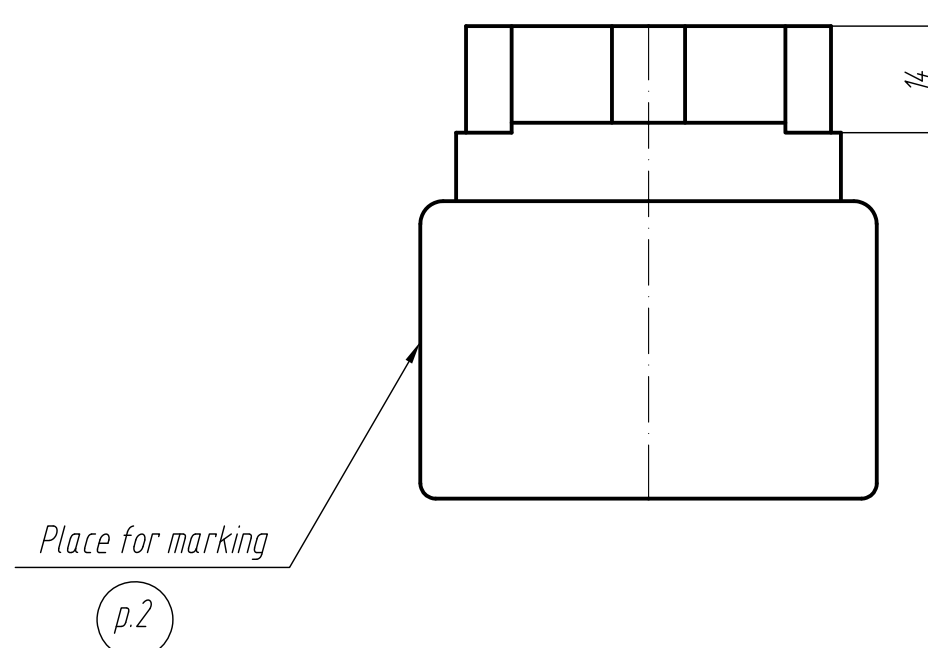
MATERIAL/ МАТЕРИАЛ:	CAST IRON (GS 900)	MACHINE/ МАШИНА:	EMHART GLASS-BB-DG 5 1/2"-8	SCALE/ МАШТАБ:	1:1
WELDING/ НАПЛАВКА:	MATCH (HRC 35..40)	DESIGNER/ ДИЗАЙНЕР:		DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:	5015-BAF-1
QUANTITY/ КОЛИЧЕСТВО:		DATE/ ДАТА:	24.04.20	JOB TITLE/ НАЗВАНИЕ РАБОТЫ:	XXI-KPM-26-2-700-17-ExtraNew
REVISIONS/ИЗМЕНЕНИЯ					
DATE/ДАТА					



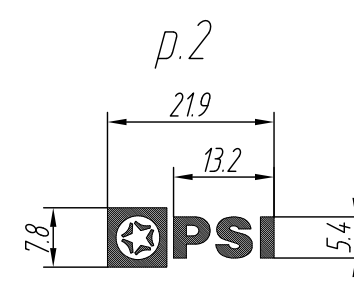
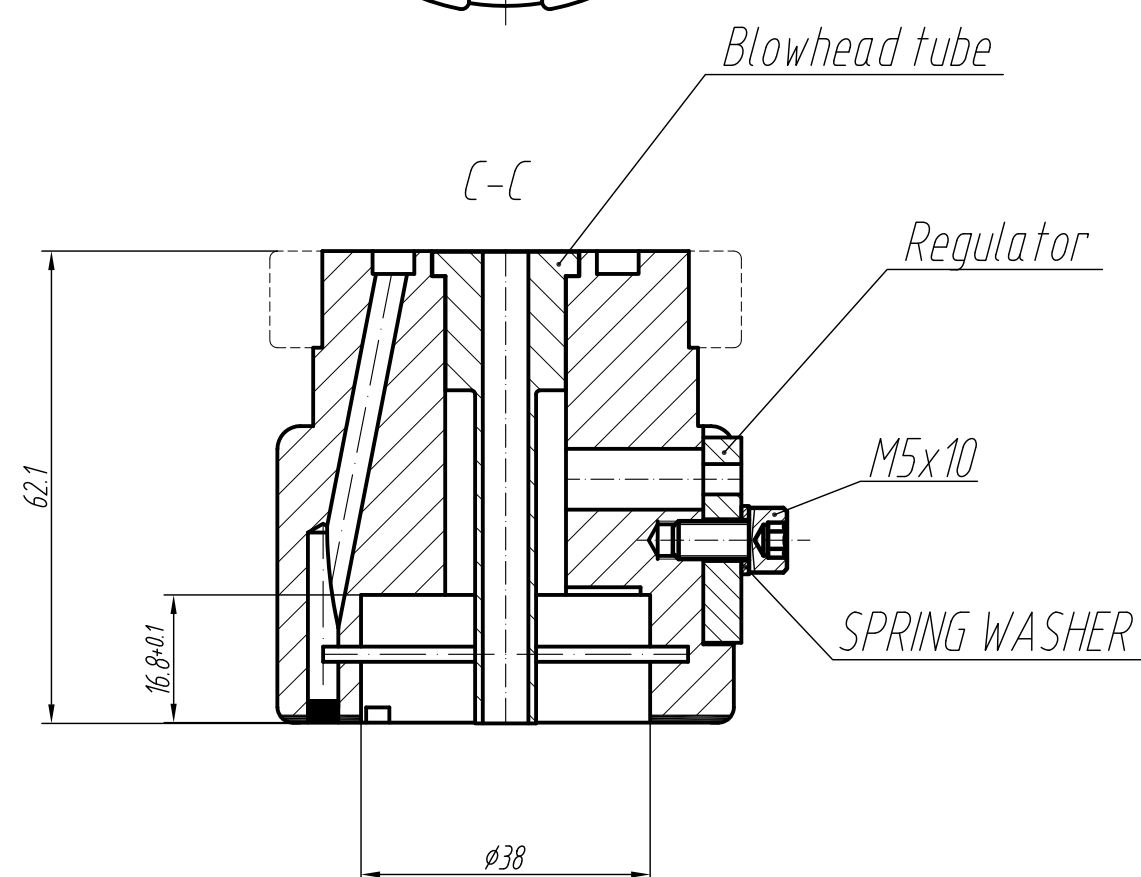
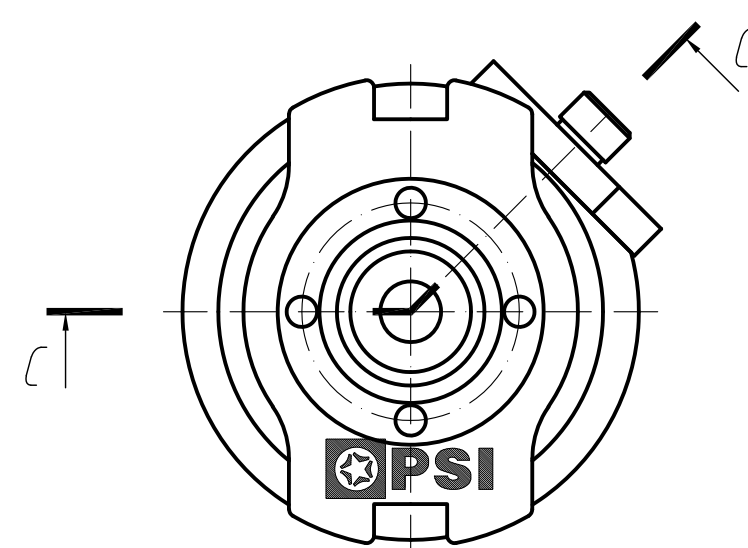
Appr: 199034, Подпись, Сокр-т, Инициалы, Б.О., 14 июня, 0.7, Тел.: +7(812)3020959, Коммент: info@psi-glass.ru



Material-Steel

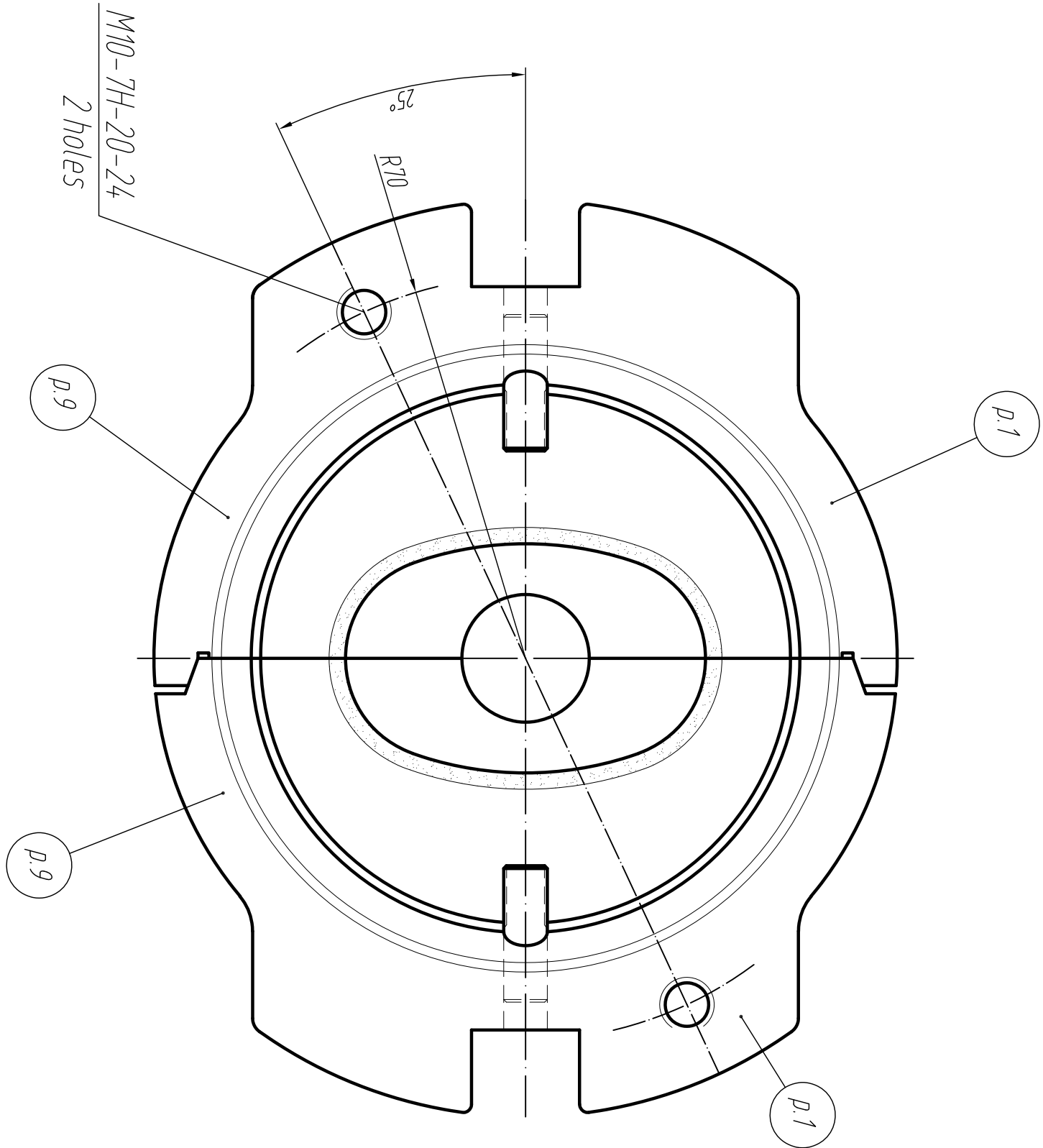


Material-Steel

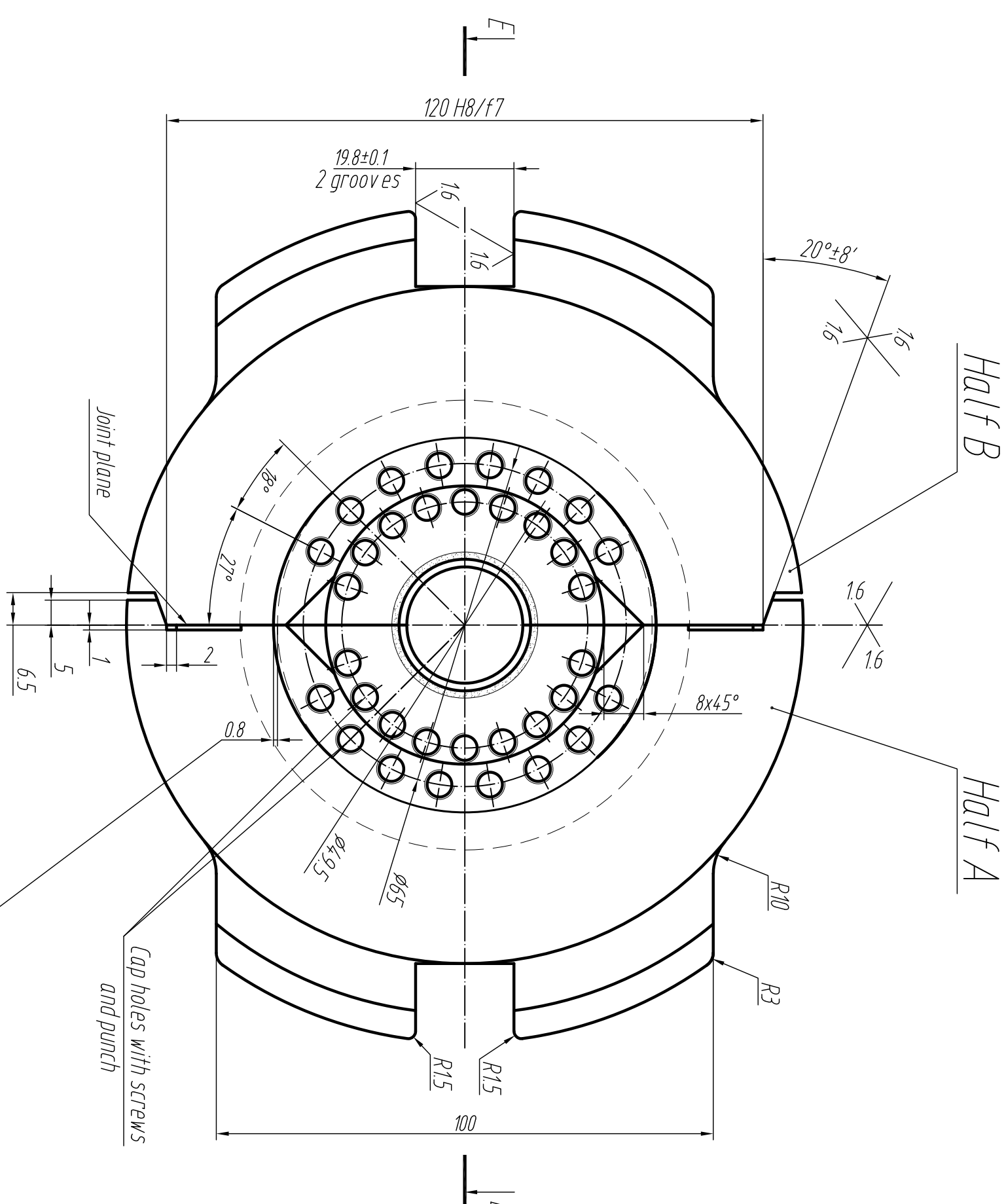
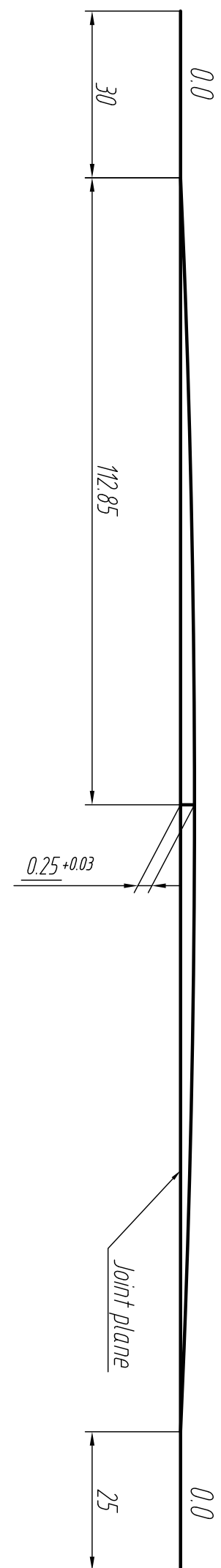
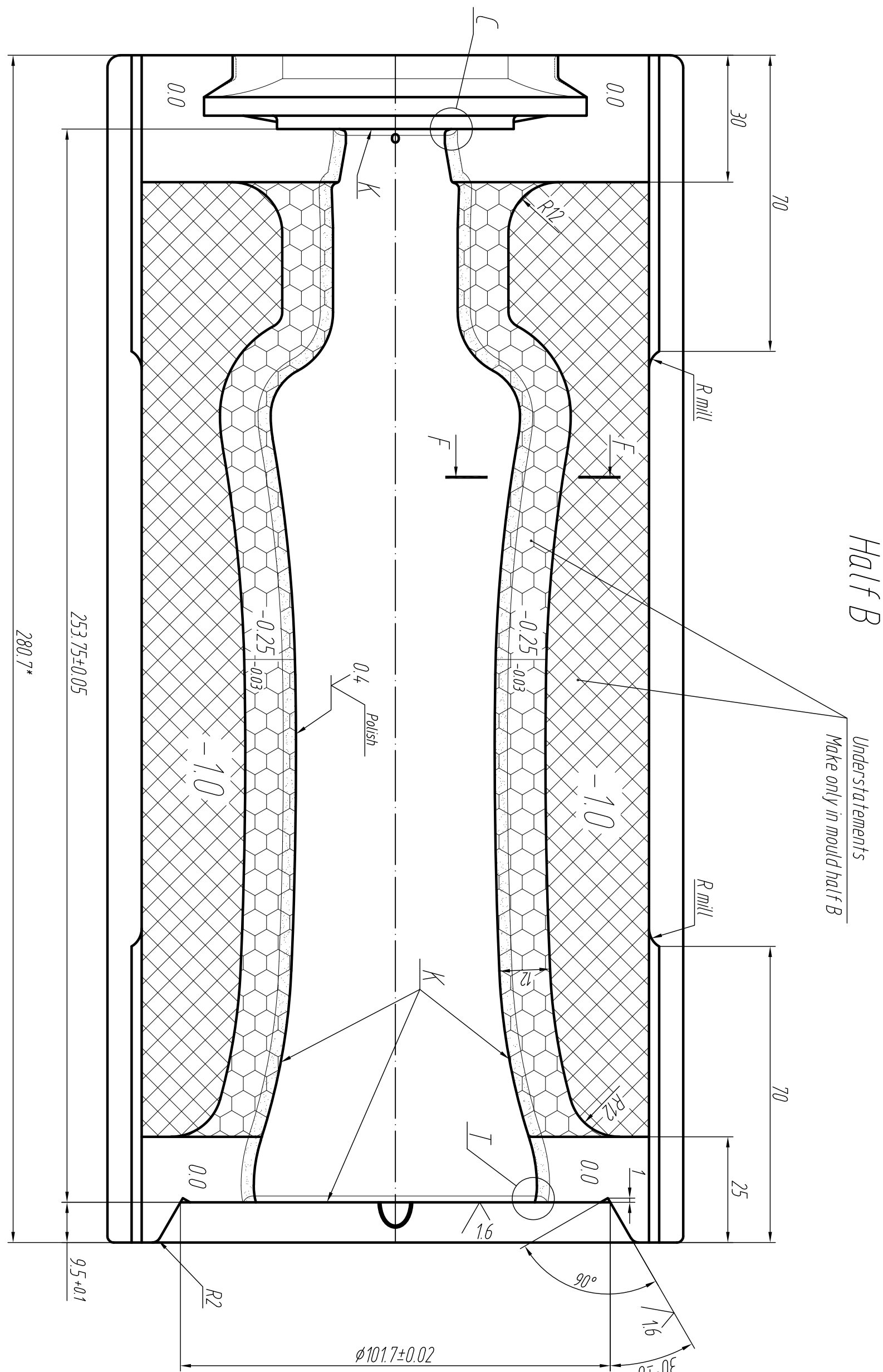
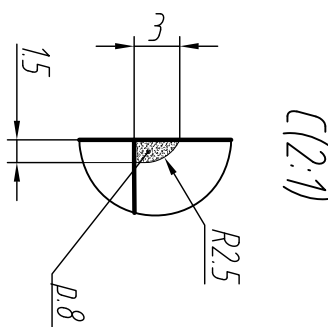
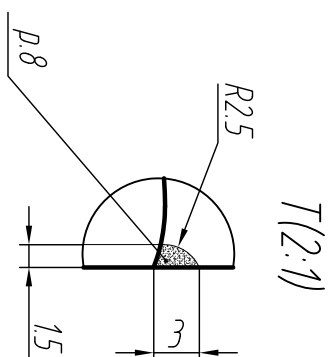
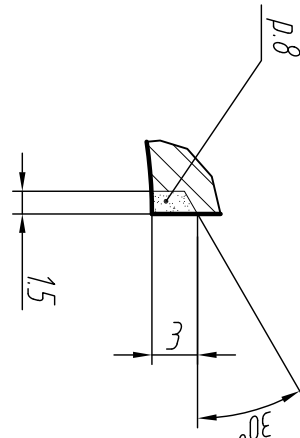


1. H14, h14, $\pm IT 14/2$.
2. Mark: XXI-KPM-26-2-700-17-ExtraNew
Mark: 5015
Mark ordinal number (h=8) & PSI logo.
Depth of marking-0.2..0.3 mm.

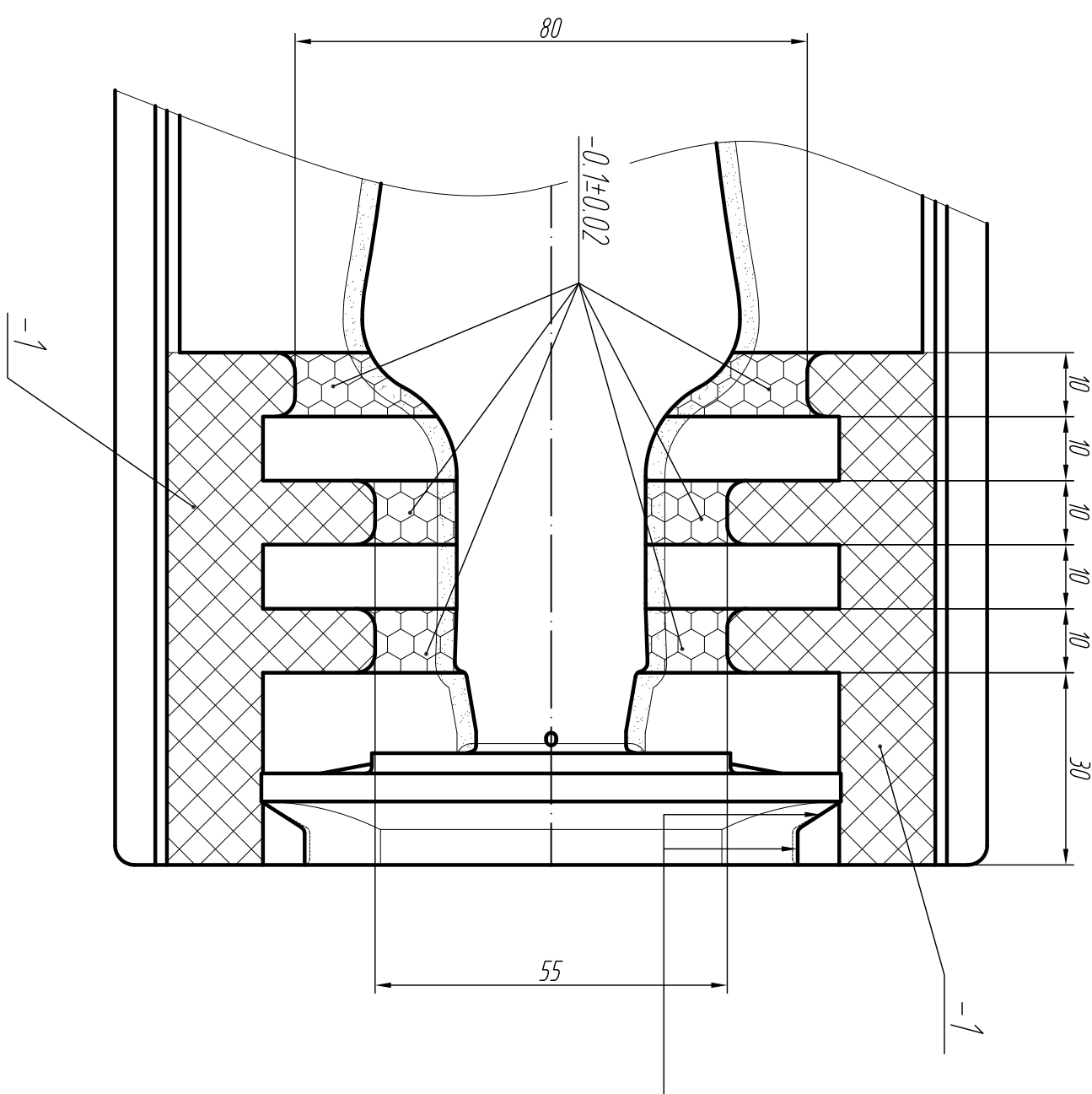
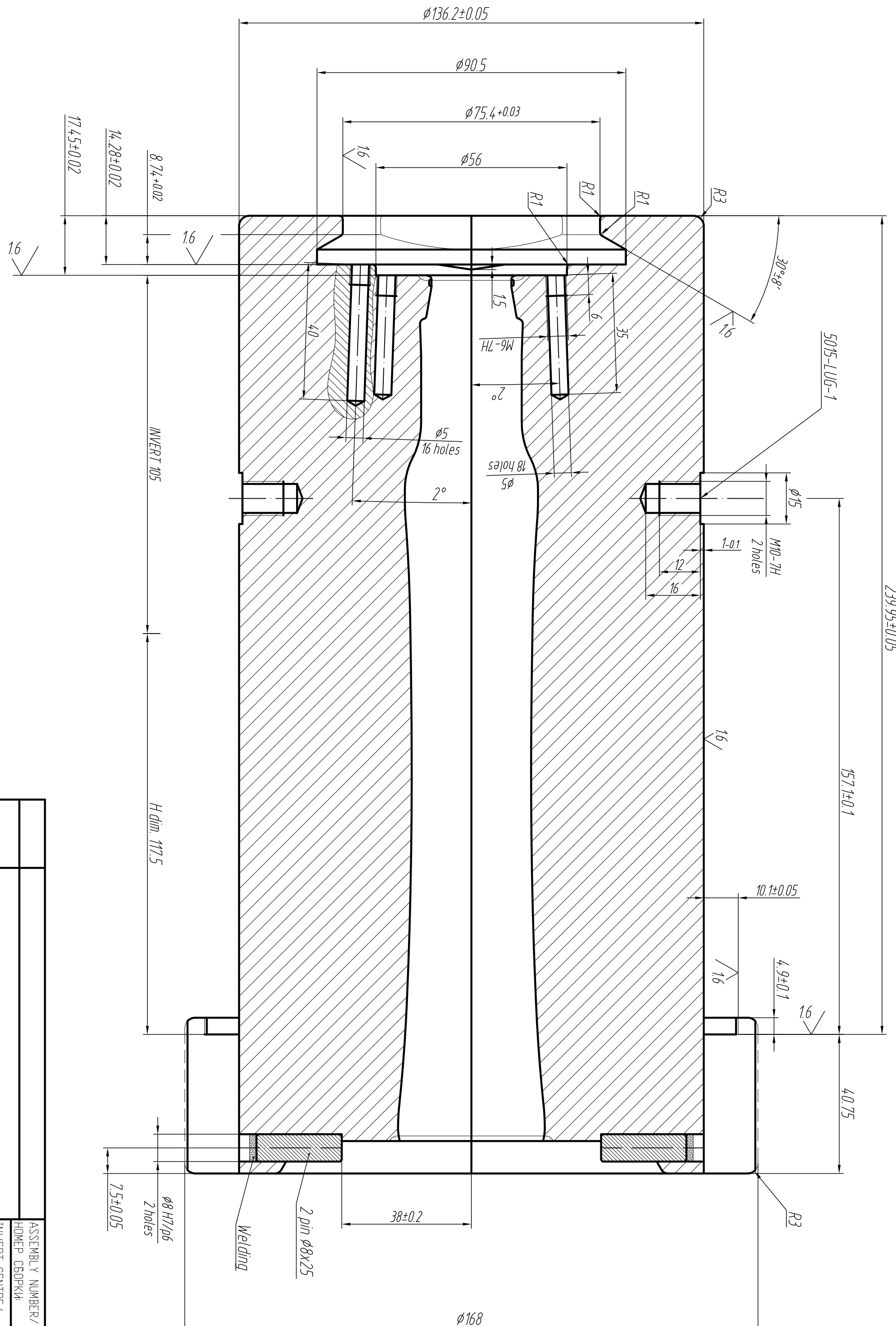
		MATERIAL/ МАТЕРИАЛ:	CAST IRON (GS900)	MACHINE/ МАШИНА:	EMHART GLASS-BB-DG 5 1/2" -8	JOB TITLE/НАЗВАНИЕ РАБОТЫ:	XXI-KPM-26-2-700-17-ExtraNew	SCALE/ МАСШТАБ:	1:1
		WELDING/ НАПЛАВКА:	Surface (HRC 35...40)	DESIGNER/ ДИЗАЙНЕР:		DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:			
		QUANTITY/ КОЛИЧЕСТВО:		DATE/ ДАТА:	24.04.20	5015-BH-1			
DATE/ДАТА	REVISIONS/ИЗМЕНЕНИЯ								



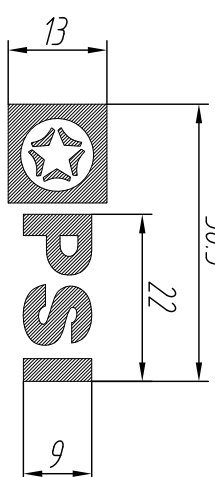
F-F(2:1)



E-E



- 1 Both halves of mold (A & B) must be marked with same ordinal number and used together
- 2 Gap in mold joint must be not more than 0.05 mm
- 3 Positional tolerance of forming cavity axis ± 0.1 mm Base – joint plane
- 4 Allowed deviation of forming cavity dimensions is not more than ± 0.05 mm except for dimensions that are specially shown
- 5 Keep sharp edges K
- 6 Reference only dimensions
- 7 H14, H14, H14/2
- 8 Hardness after welding HR35 4/0
- 9 Mark XXI-KPM-26-2-700-17-ExtraNew
- Mark-5075
- Mark ordinal number (n=10) & PSI logo
- Depth of marking 0.2-0.3 mm



Half A

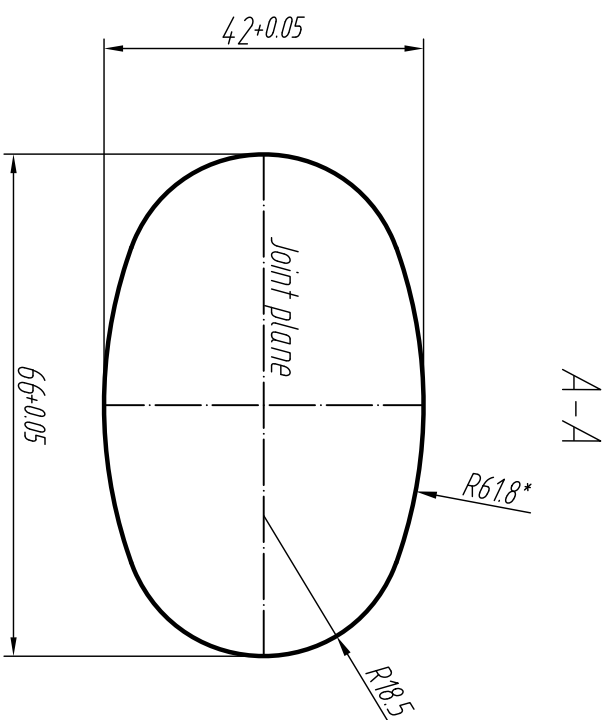
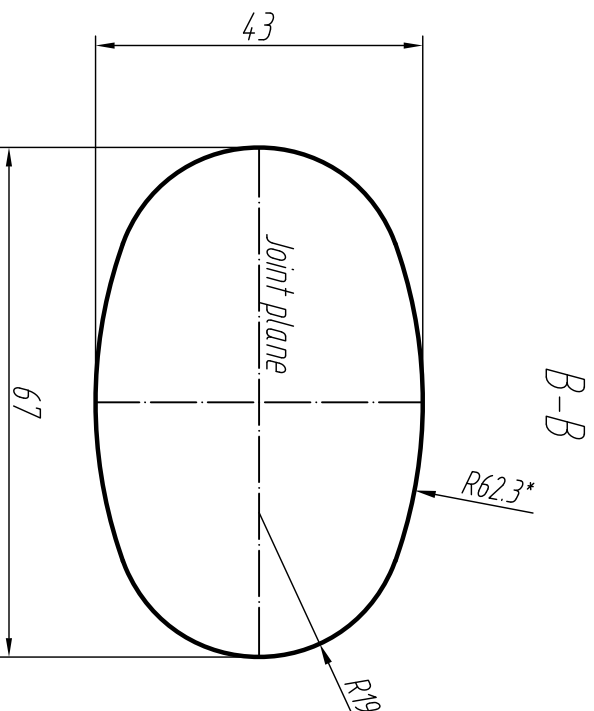
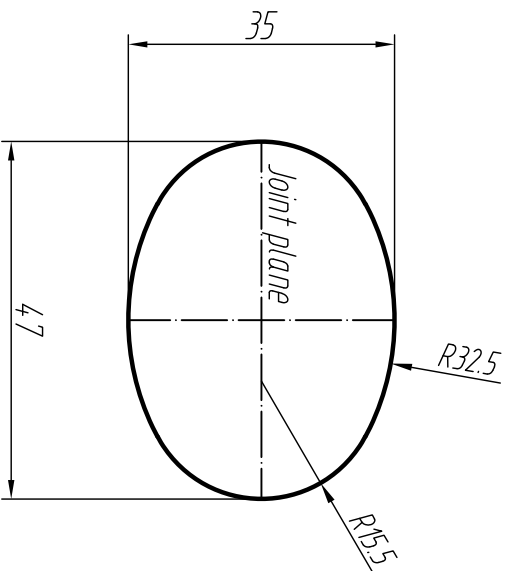
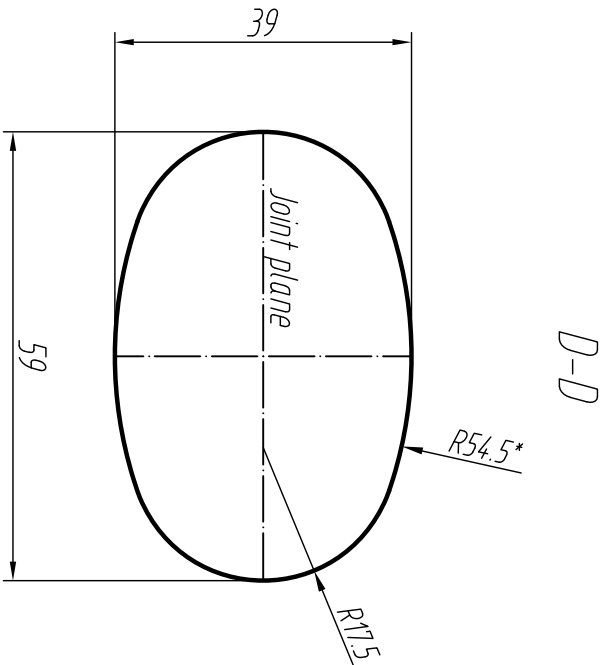
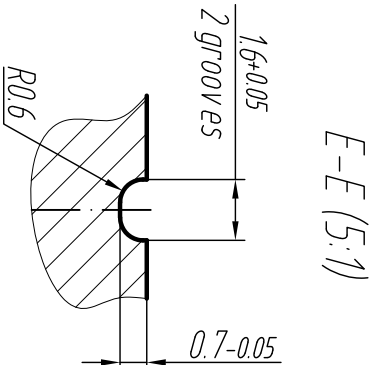
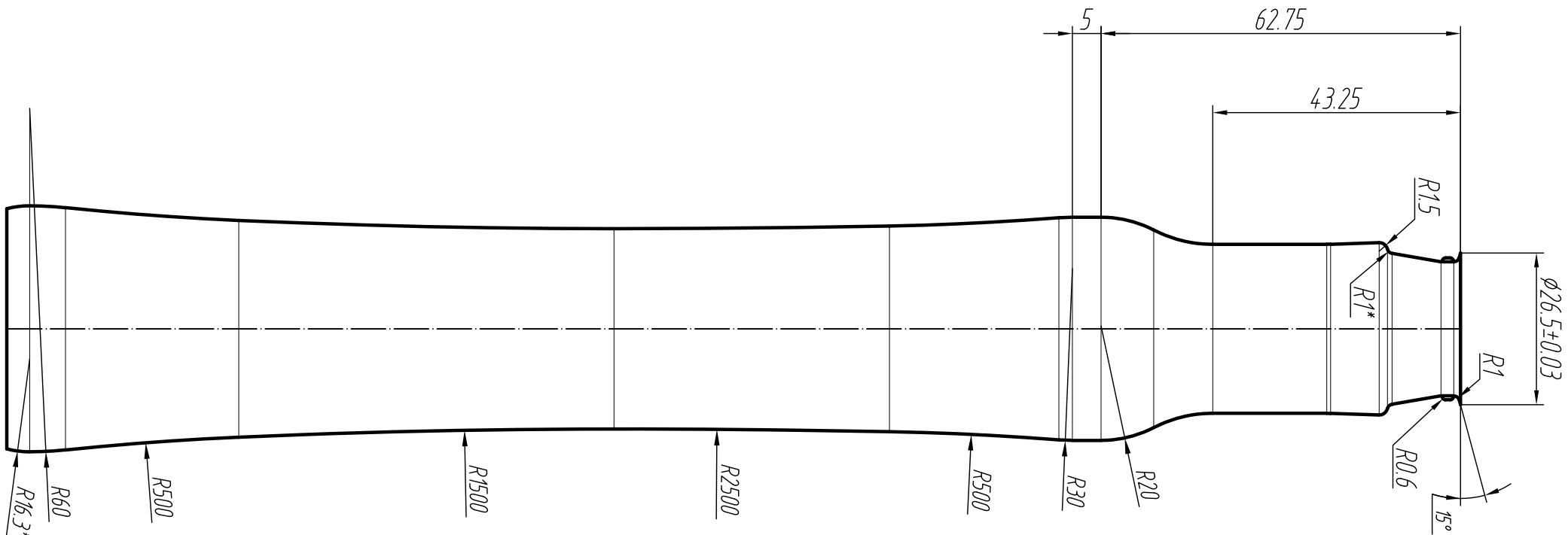
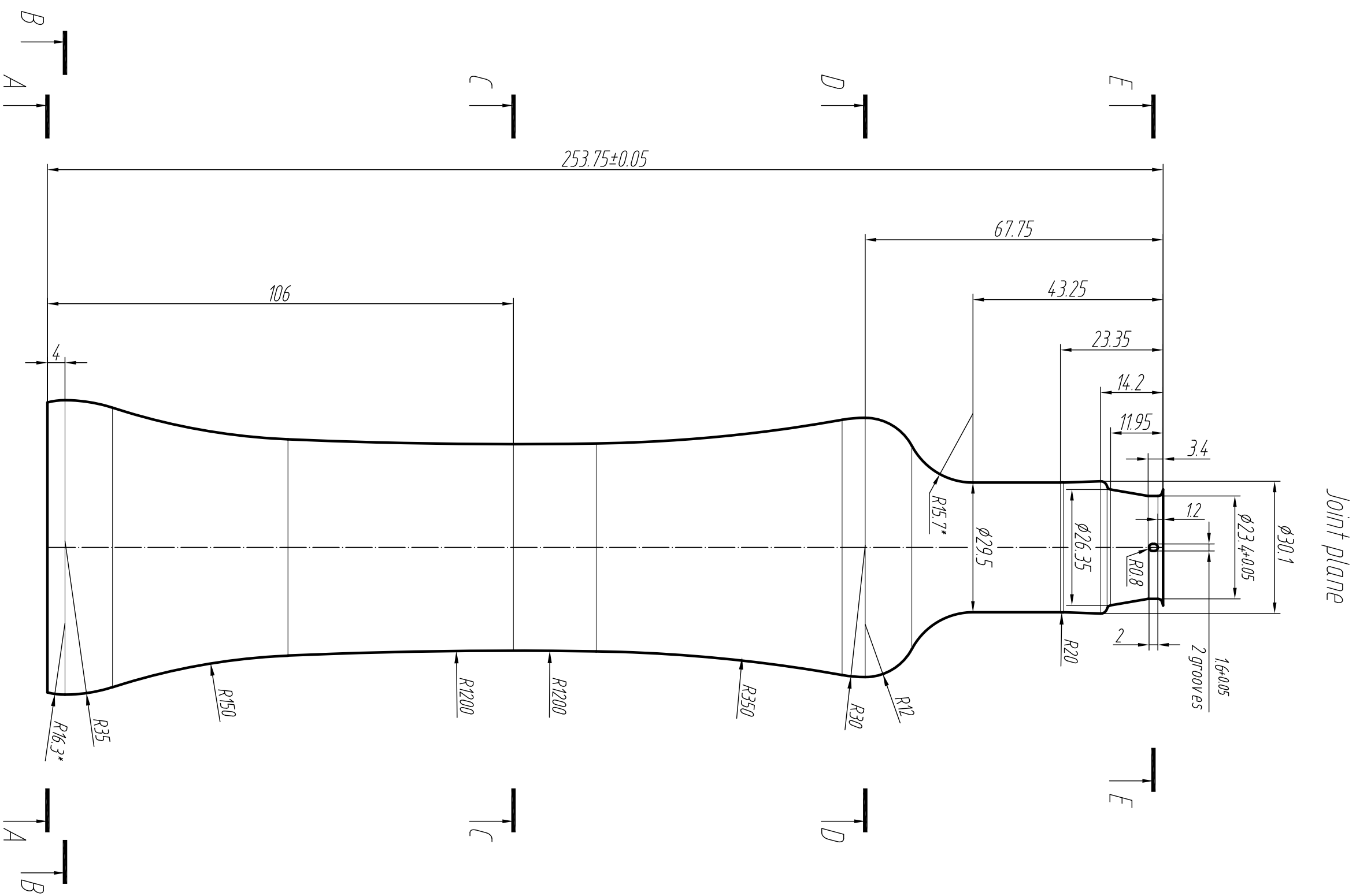
Half B

Half A

63/ (M)

DATE / DATA	24.04.20	REVISIONS / ИЗМЕНЕНИЯ	1	ASSEMBLY NUMBER / КОМПОНОВКА	23	MATERIAL / МАТЕРИАЛ	CAST IRON (GS800)	MACHINE / МАШИНА	EMHART GLASS-BB-005 V2-8	JOB TITLE / НАЗВАНИЕ ПРОЕКТА	XXI-KPM-26-2-700-17-ExtraNew	SCALE / МАСШТАБ	1:1
DATE / DATA	24.04.20	REVISIONS / ИЗМЕНЕНИЯ	1	ASSEMBLY NUMBER / КОМПОНОВКА	105	MATERIAL / МАТЕРИАЛ	WELDING / СВАРКА	DESIGNER / ПРОЕКТОР	ALL edges (HR 35..40)	DRAWING NUMBER / ЧЕРТЕЖ	5075-BLK-1-2	SCALE / МАСШТАБ	1:1

Glassforming surface

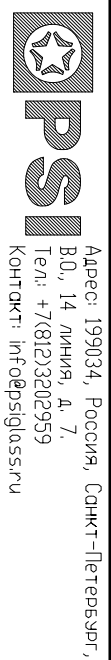


Milling of cavity must be performed according to the 3D model

Allowed deviation of forming cavity dimensions is not more than ±0.05 mm, except for dimensions that are specially shown.

* - Reference only dimensions

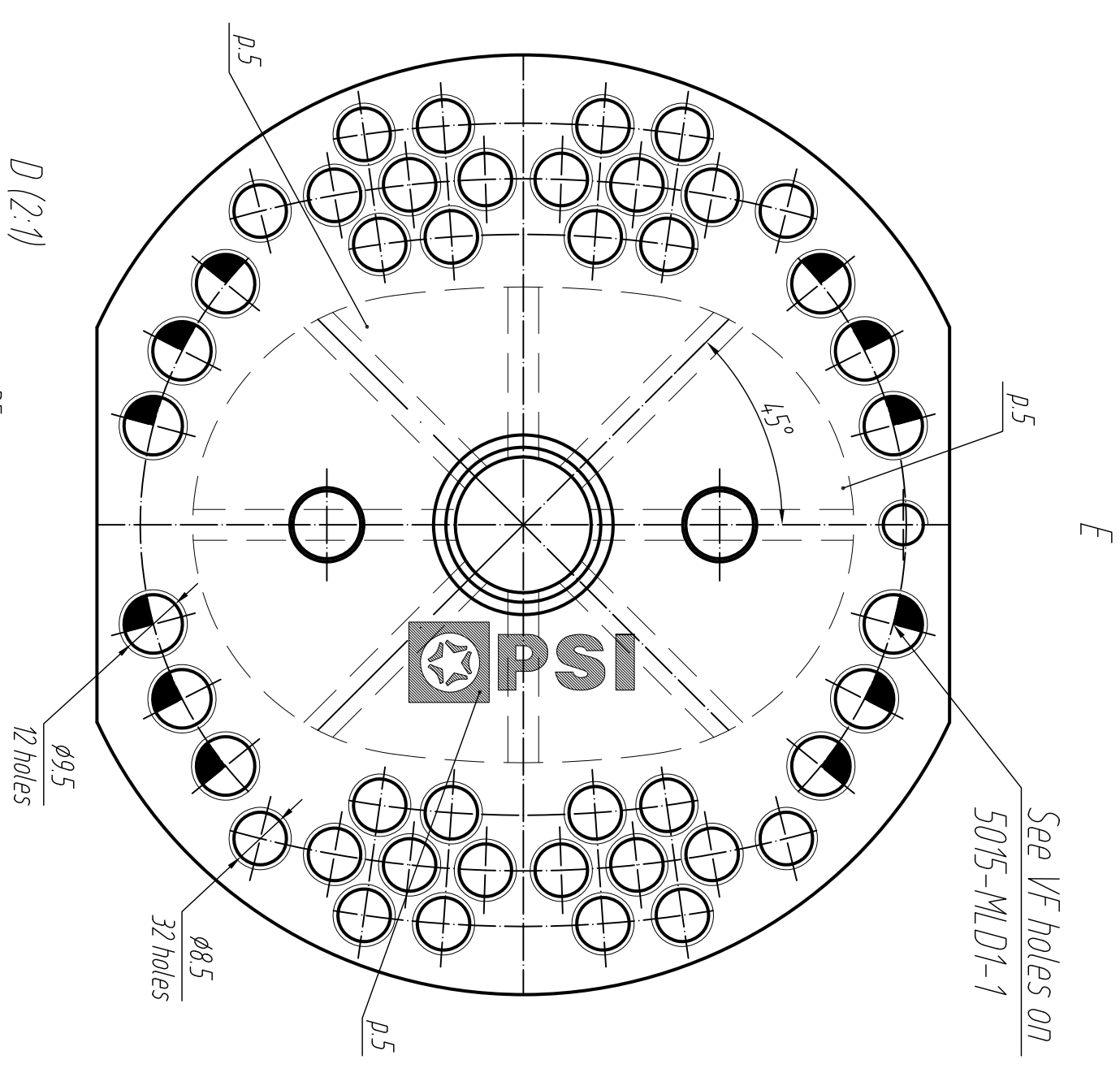
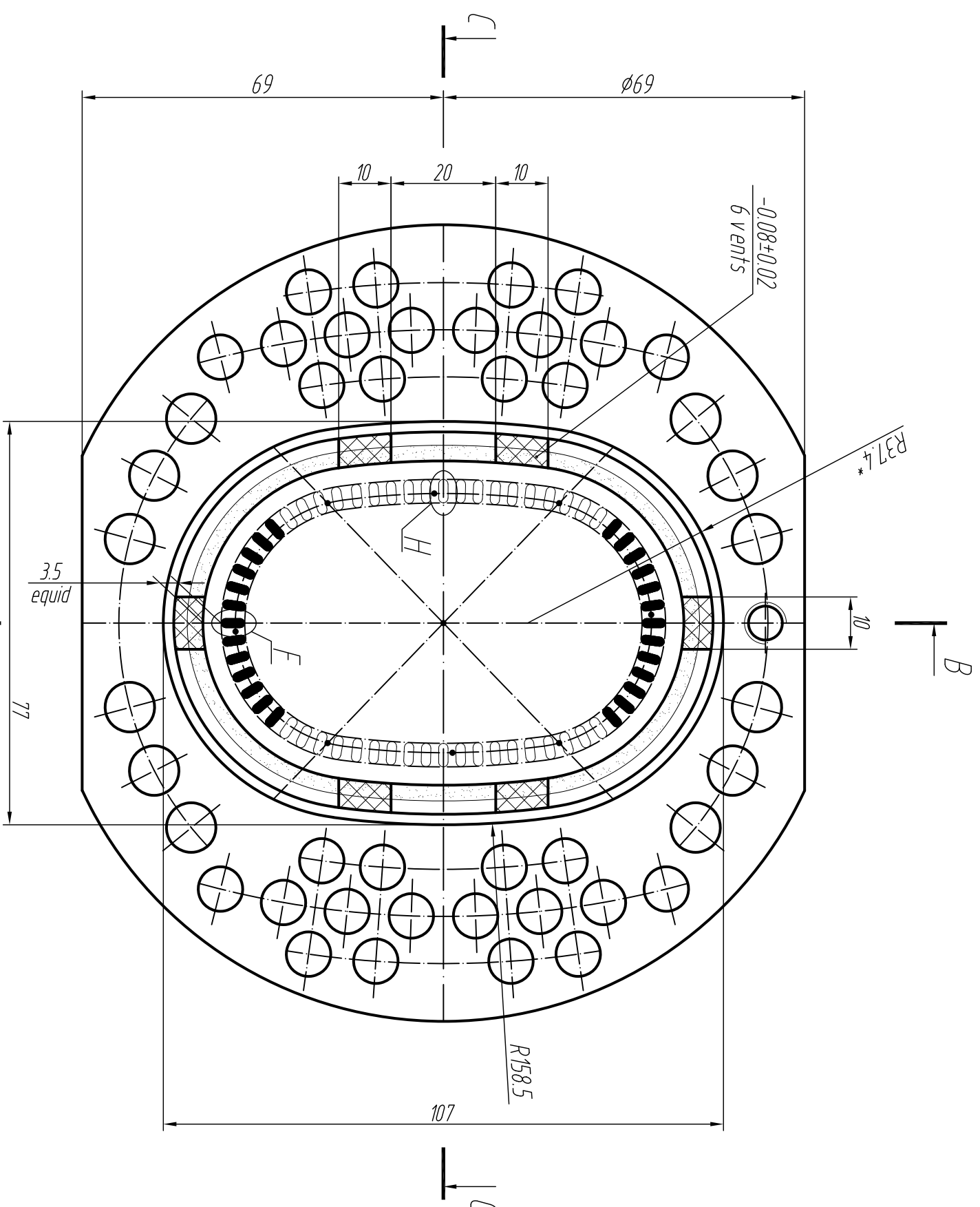
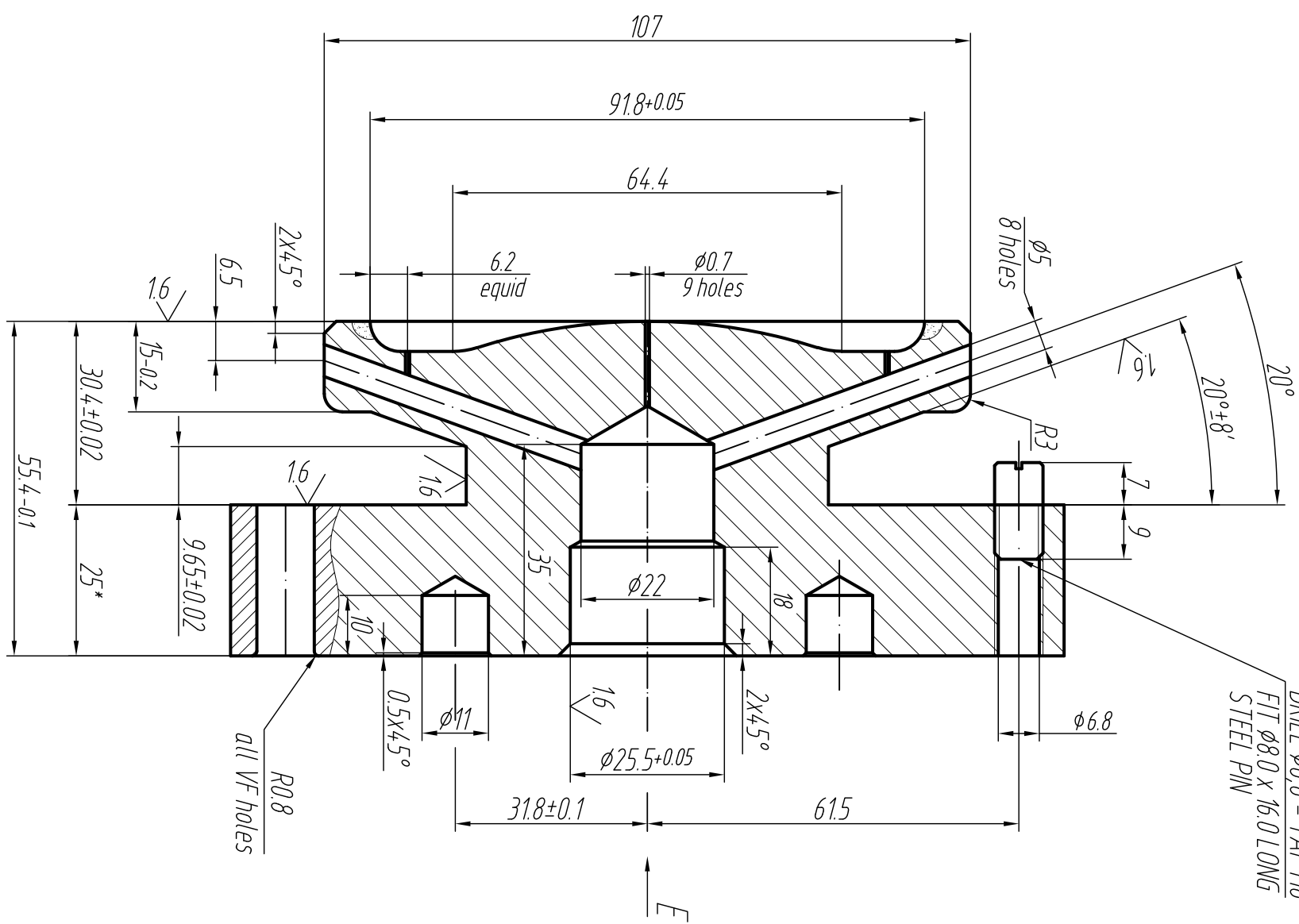
		DISPLACEMENT OF BLANK AND BAFFLE		356,6 ml	MACHINE/ МАШИНА:	ЕМАРТ GLASS-BB-DG 5 1/2"-8	JOB TITLE/НАЗВАНИЕ РАБОТЫ:	SCALE/ МАСШТАБ:
					DESIGNER/ ДИЗАЙНЕР:			
24.04.20		①			DATE/ DATA:	24.04.20	DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:	1:1
DATE/ DATA		REVISIONS/ИЗМЕНЕНИЯ						



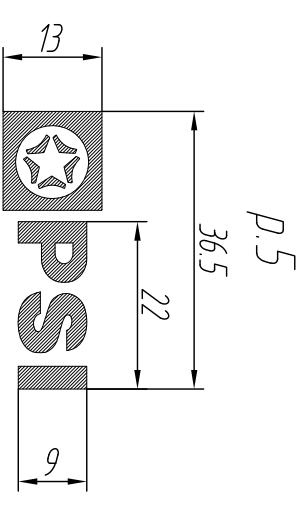
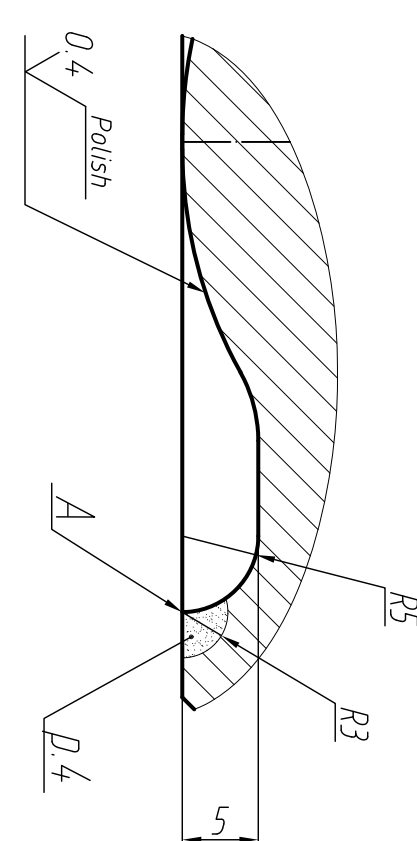
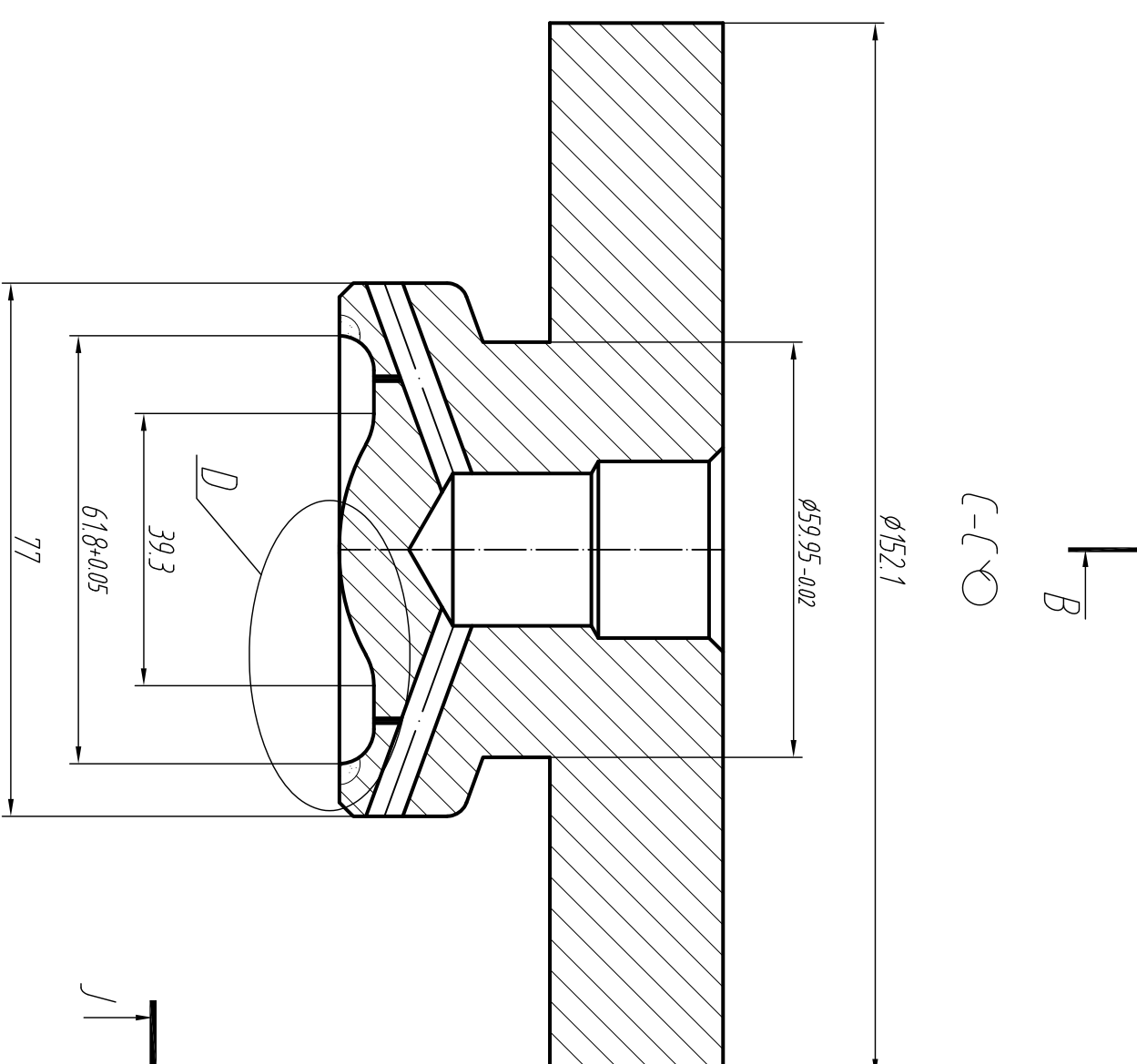
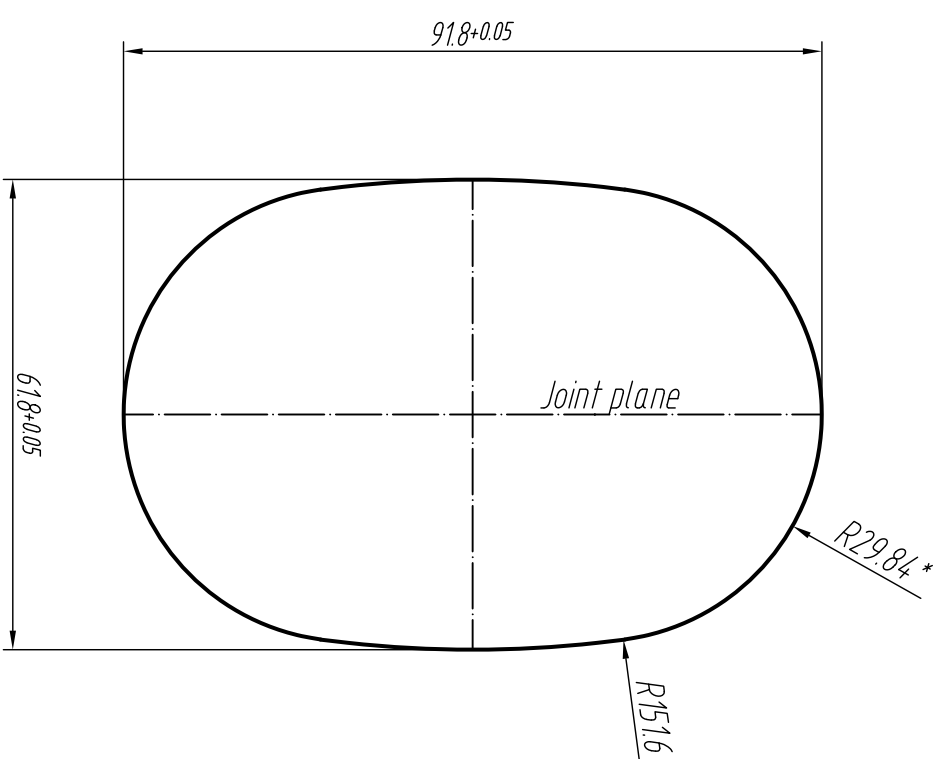
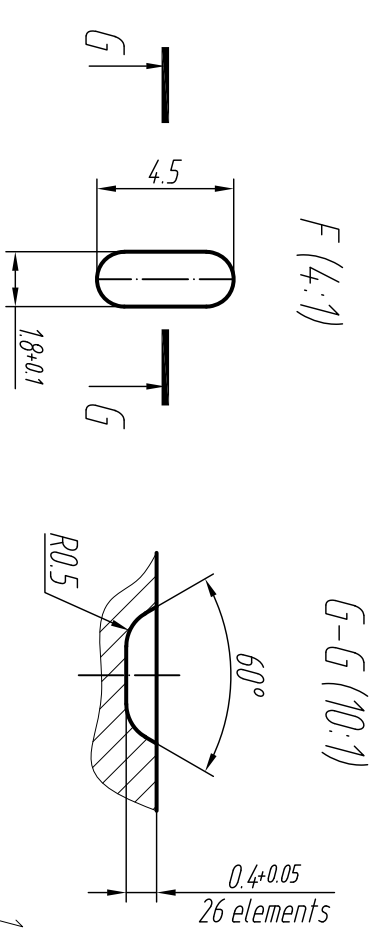
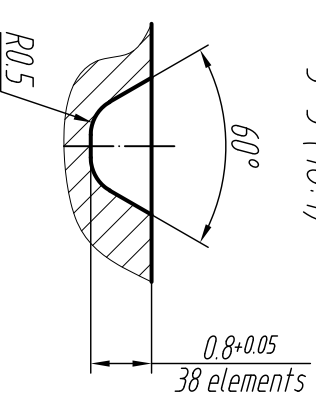
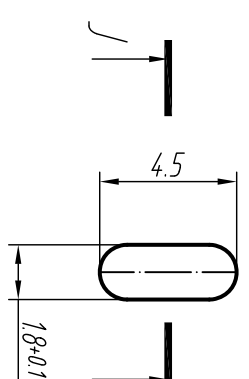
3)



DRILL Ø6,8 - TAP M8
/ FIT Ø8.0 x 16.0 LONG
STEEL PIN



Glasforming surface

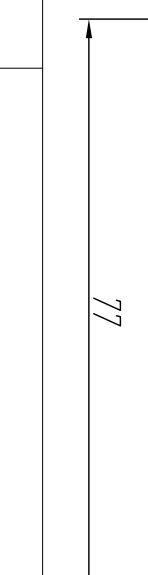

 $H(4:1) \simeq$
$$J-J(10:1)$$


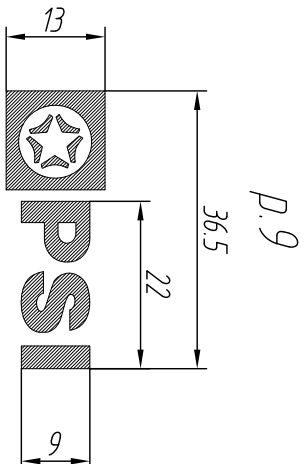
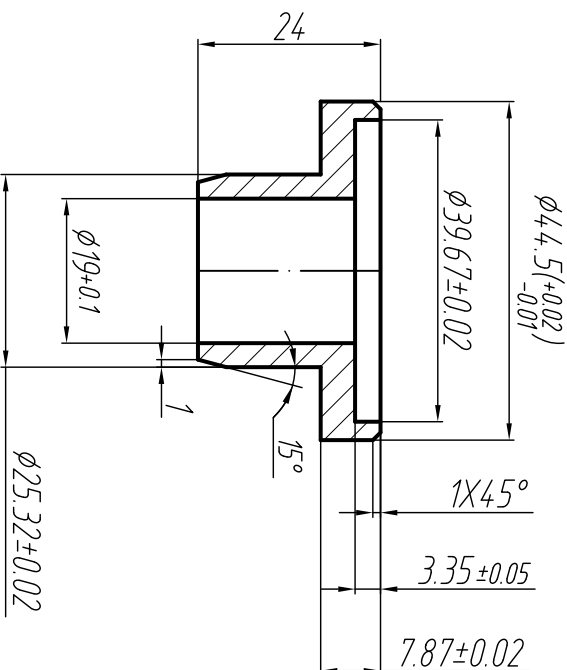
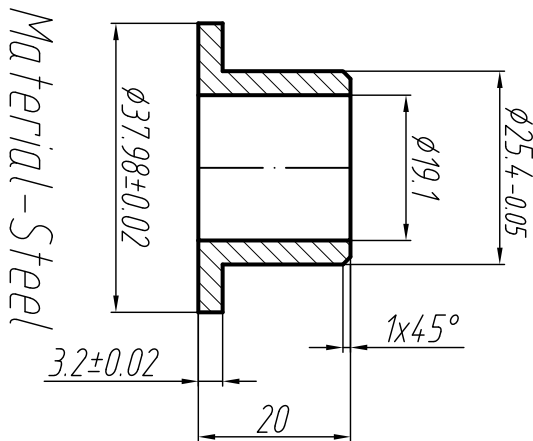
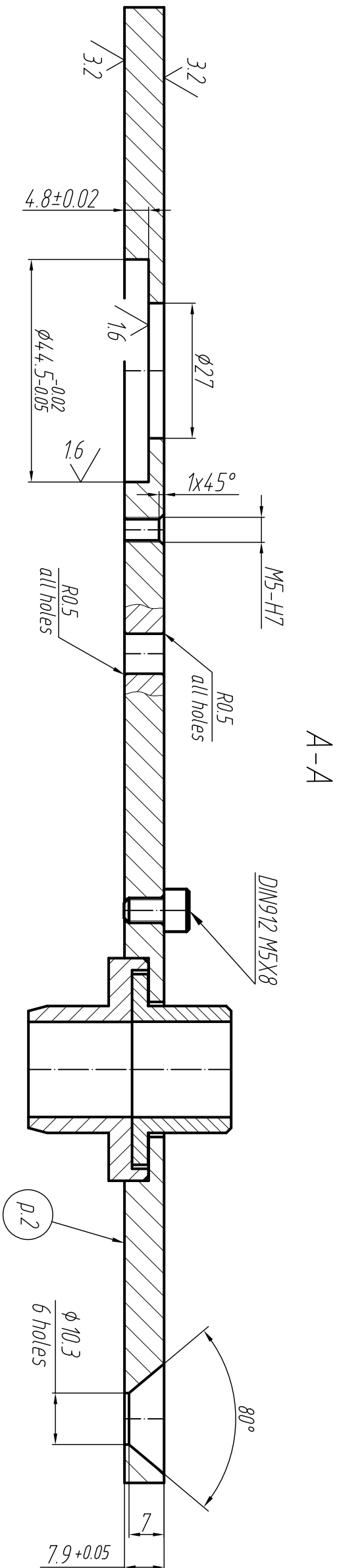
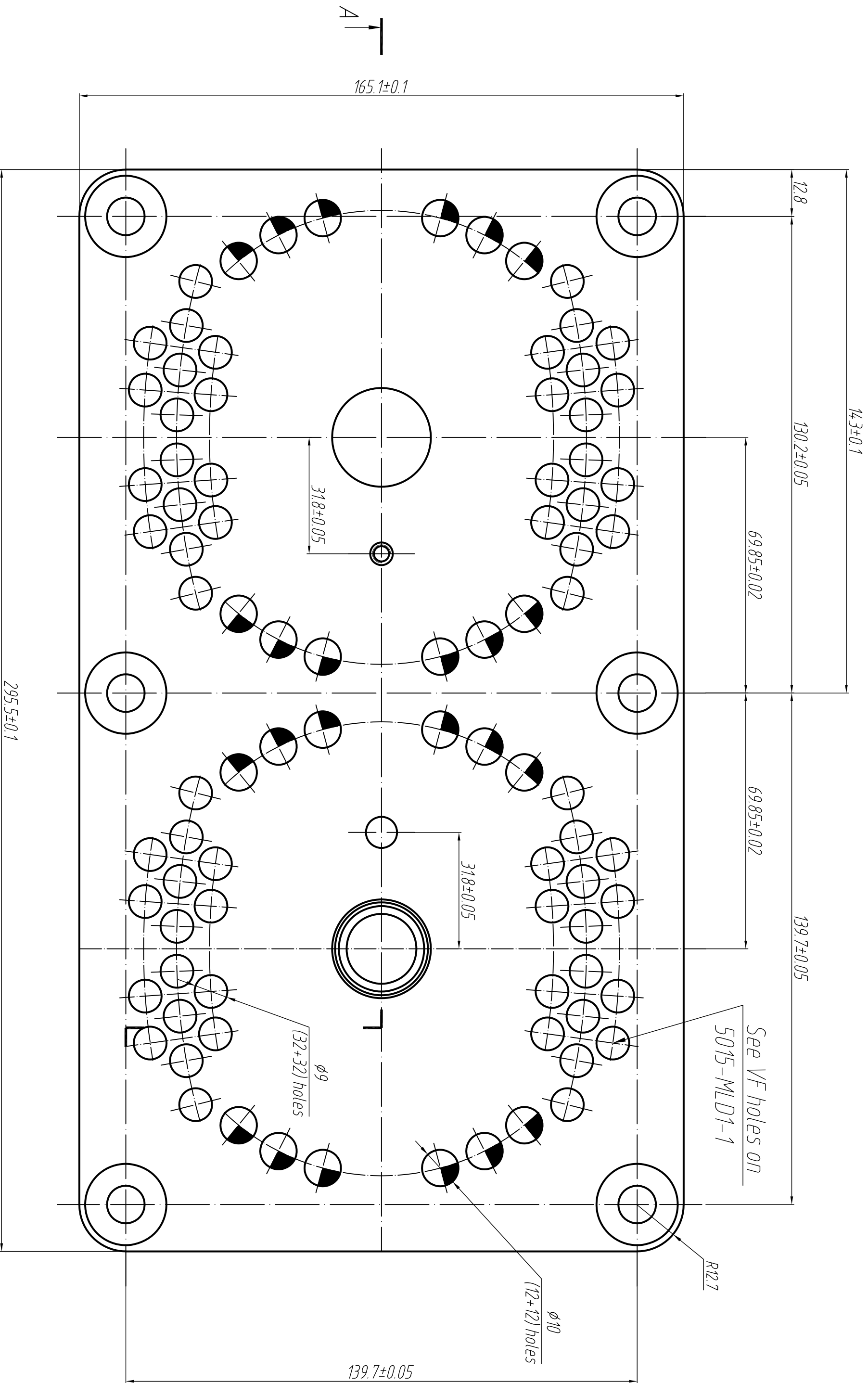
1. H14, H14, ±IT14/2.
2. Keep sharp edges A.
3. *Reference only dimensions
4. Hardness after welding HRC35, 40.
5. Mark-XXI-KPM-26-2-700-17-ExtraNew

Mark-5015

Mark ordinal number (h=10) & PSI logo.

Depth of marking-0,2...0,3 mm.

				<div>Адрес: 199034, Россия, Санкт-Петербург Б.О., 14 линия, д. 7 Тел.: +7 (812) 3202359 Комплект: info@psigrass.ru</div>	
		MATERIAL / МАТЕРИАЛ:	CAST IRON (GS900)	MACHINE / МАШИНА:	EMHART GLASS-BB-DG-5 1/2"-8
		WELDING / СВАРКА:	MATCH (HR33 35...40)	DESIGNER / ДИЗАЙНЕР:	
		QUANTITY / КОЛИЧЕСТВО:		DATE / ДАТА:	24.04.20
DATE / ДАТА:		REVISIONS / ИЗМЕНЕНИЯ:		DRAWING NUMBER / НОМЕР ЧЕРТЕЖА: 5015-B01-1	
				SCALE / МАШТАБ:	1 : 1

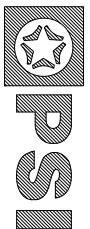


1 H14, h14, ±IT14/12
2 Mark- XXI-KPM-26-2-700-17-ExtraNew

Mark: 5015

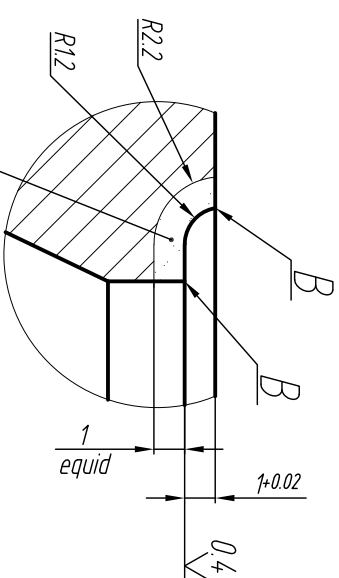
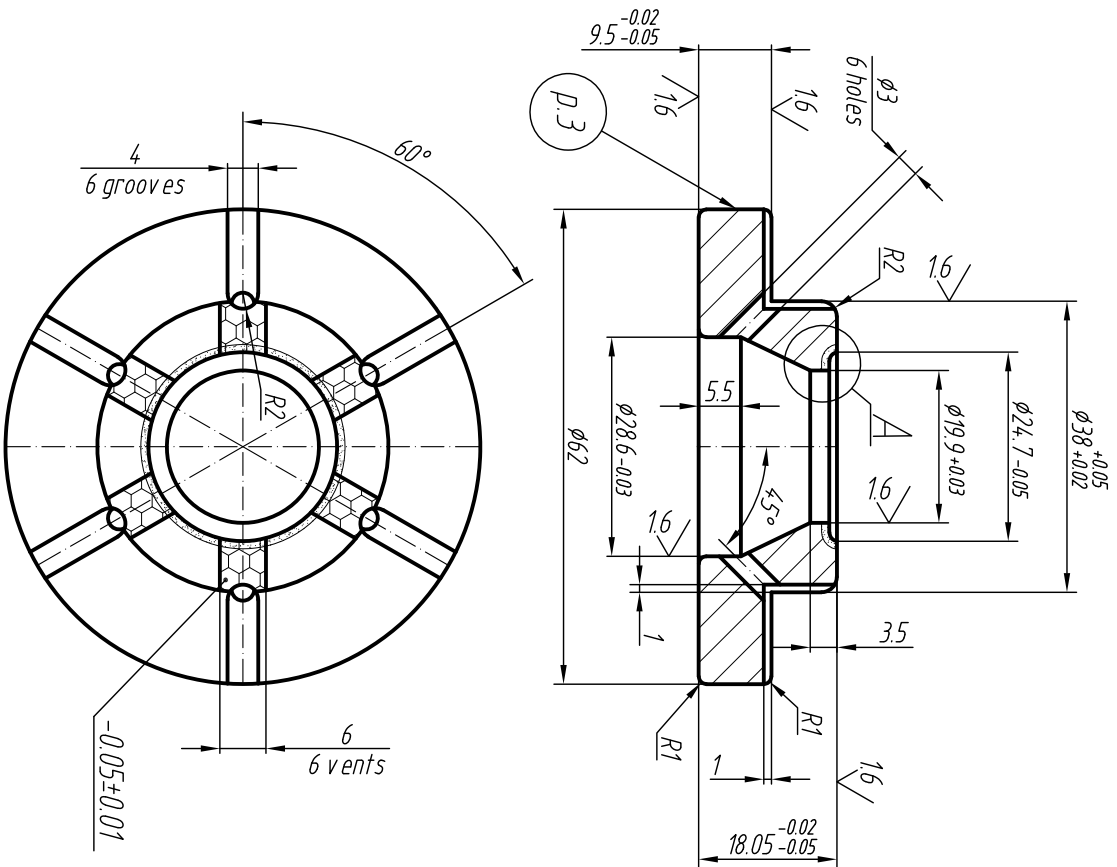
Mark ordinal number (h=10) & PSI logo.

Depth of marking - 0.2-0.3mm.



Адрес: 199034, Россия, Санкт-Петербург,
Б.О. 14 линия, д. 7
Тел.: +7(812)3202959
Контакт: info@psiglass.ru

MATERIAL / МАТЕРИАЛ:	STEEL	MACHINE / МАШИНА:	EMHART GLASS-BB-DG 5 1/2"-8	JOB TITLE / НАЗВАНИЕ РАБОТЫ:	XXI-KPM-26-2-700-17-ExtraNew	SCALE / МАШТАБ:	1:1
WELDING / СВАРКА:		DESIGNER / ДИЗАЙНЕР:		DRAWING NUMBER / НОМЕР ЧЕРТЕЖА:	5015-DPL-1		
QUANTITY / КОЛИЧЕСТВО:		DATE / ДАТА:	24.04.20				
REVISIONS / ИЗМЕНЕНИЯ							
DATE / ДАТА							

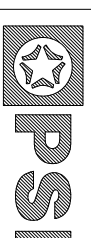


A (4:1)

6.3 / (✓)

hard welded profile
35-40HRc

1. H14, h14, ±IT14/2.
 2. Keep sharp edge B.
 3. Mark: XXI-KPM-26-2-700-17-ExtraNew
- Mark: PSI/5015
Mark ordinal number.
Depth of marking - 0.2-0.3 mm.
Remove all burrs and wire-edges
after marking is done



Адрес: 199034, Россия, Санкт-Петербург,
Б.О., 14 линия, г. 7.
Тел.: +7(812)3202959
Контакт: info@psiglass.ru

JOB TITLE/НАЗВАНИЕ РАБОТЫ:

XXI-KPM-26-2-700-17-ExtraNew

DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:

5015-FGP-1

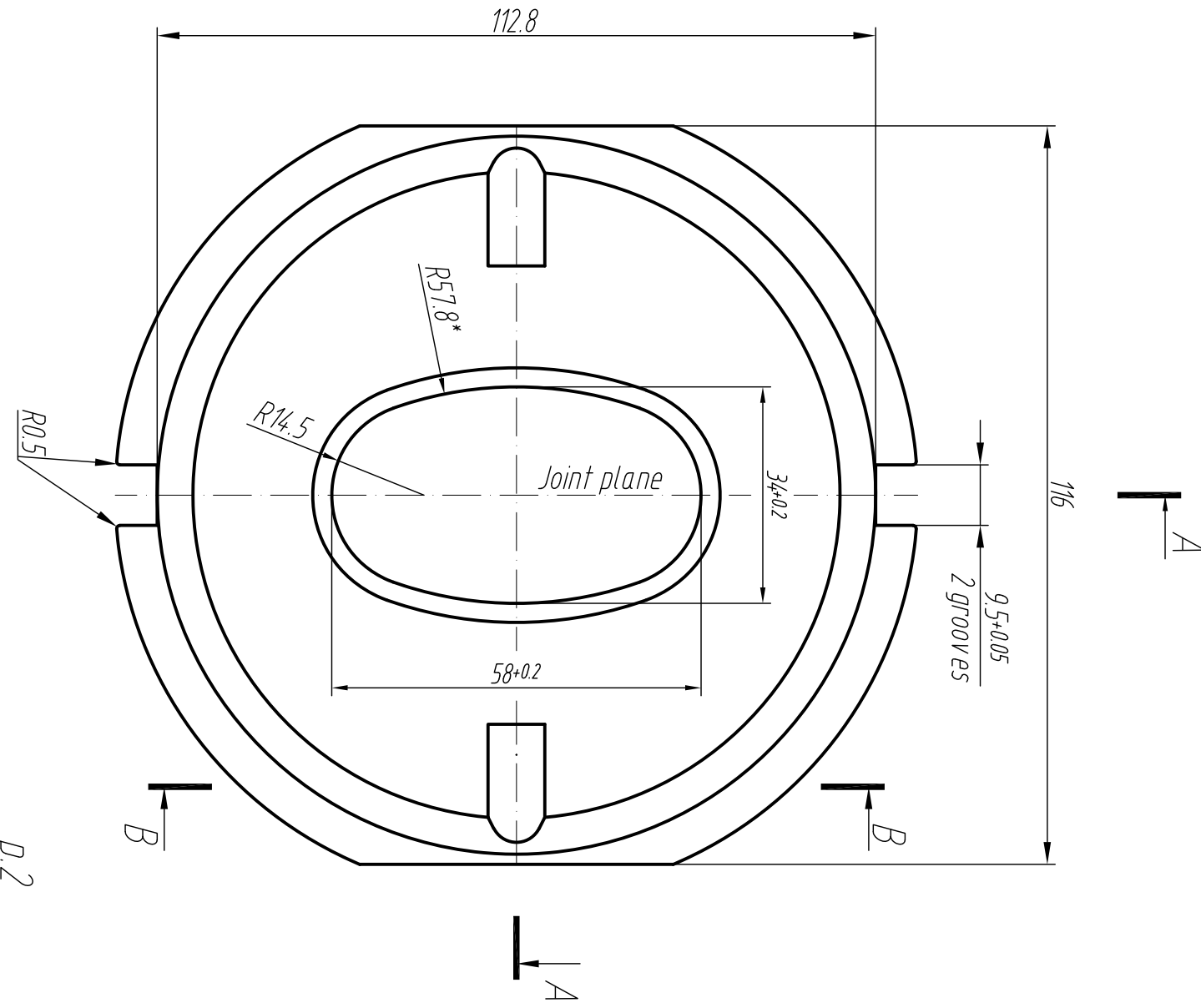
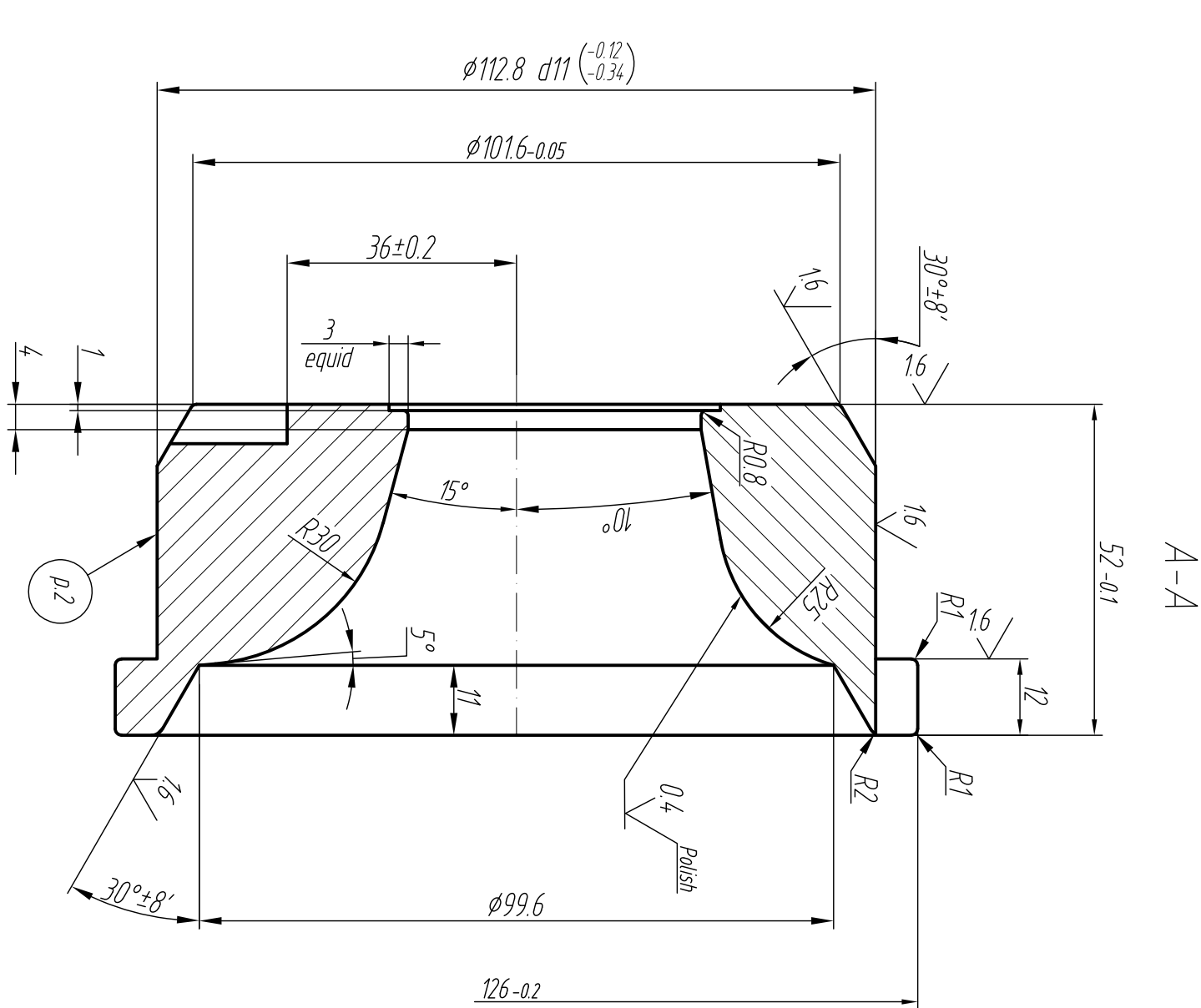
SCALE/
МАСШТАБ:

1:1

DATE / DATA	REVISIONS / ИЗМЕНЕНИЯ
MATERIAL / МАТЕРИАЛ:	CAST IRON (GS 900)
WELDING / СВАРКА:	Cavity (HRC 35...40)

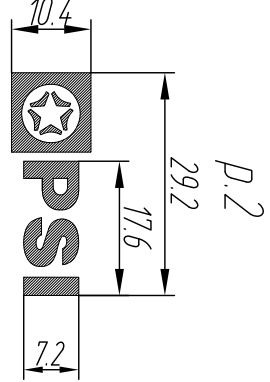
MACHINE / МАШИНА:	EMHART GLASS-BB-DG 5 1/2"-8
DESIGNER / ДИЗАЙНЕР:	
DATE / DATA:	24.04.20

6.3 / (✓)



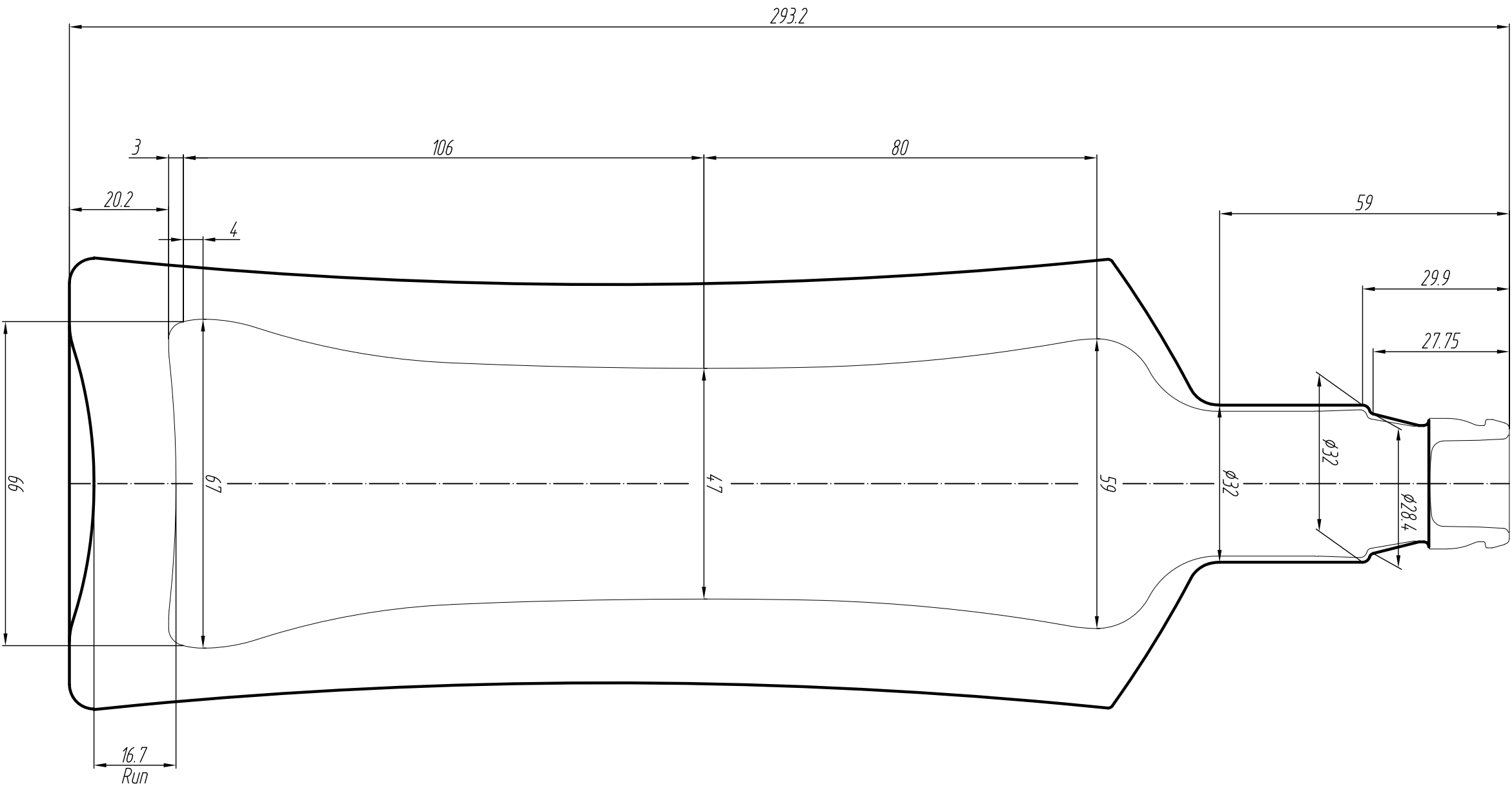
1. H14, h14, ±IT14/2.
2. Mark: XXI-KPM-26-2-700-17-ExtraNew
Mark: 5015
Mark ordinal number (h=7) & PSI logo.
Depth of marking-0.2...0.3 mm.

Адрес: 199034, Россия, Санкт-Петербург,
В.О., 14 линия, д. 7.
Тел.: +7(812)3202959
Контакт: info@psiglass.ru

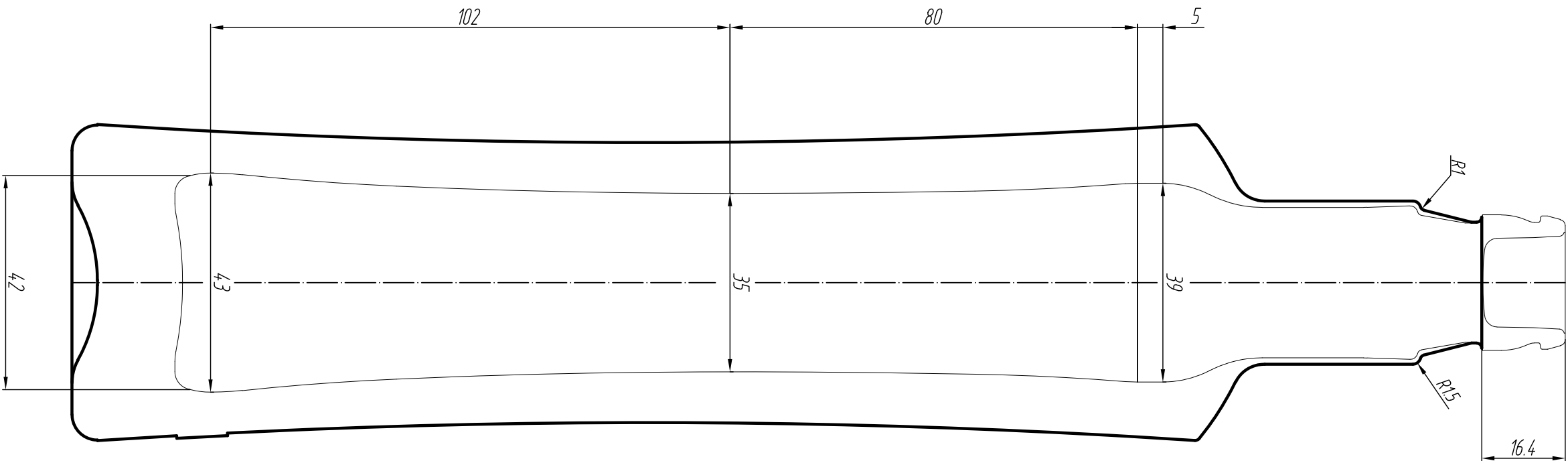


	MATERIAL/ МАТЕРИАЛ:	CAST IRON (GS900)	MACHINE/ МАШИНА:	EMHART GLASS-BB-DG 5 1/2"-8	JOB TITLE/НАЗВАНИЕ РАБОТЫ:	XXI-KPM-26-2-700-17-ExtraNew	SCALE/ МАСШТАБ:	1:1
	WELDING/ ВАРКА:		DESIGNER/ ДИЗАЙНЕР:		DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:	5015-FUN-1		
DATE / DATA	REVISIONS / ИЗМЕНЕНИЯ	QUANTITY / КОЛИЧЕСТВО:	DATE / DATA:	24.04.20				

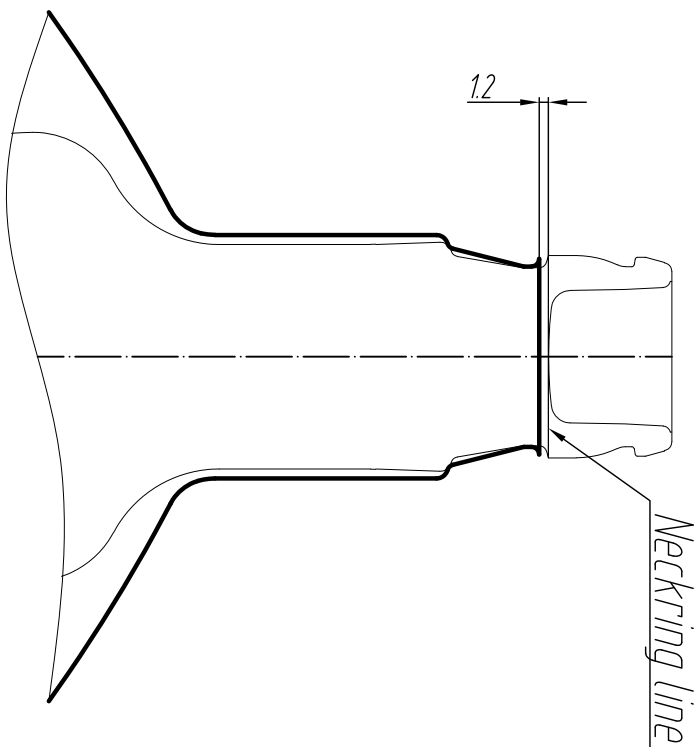
Joint plane



A

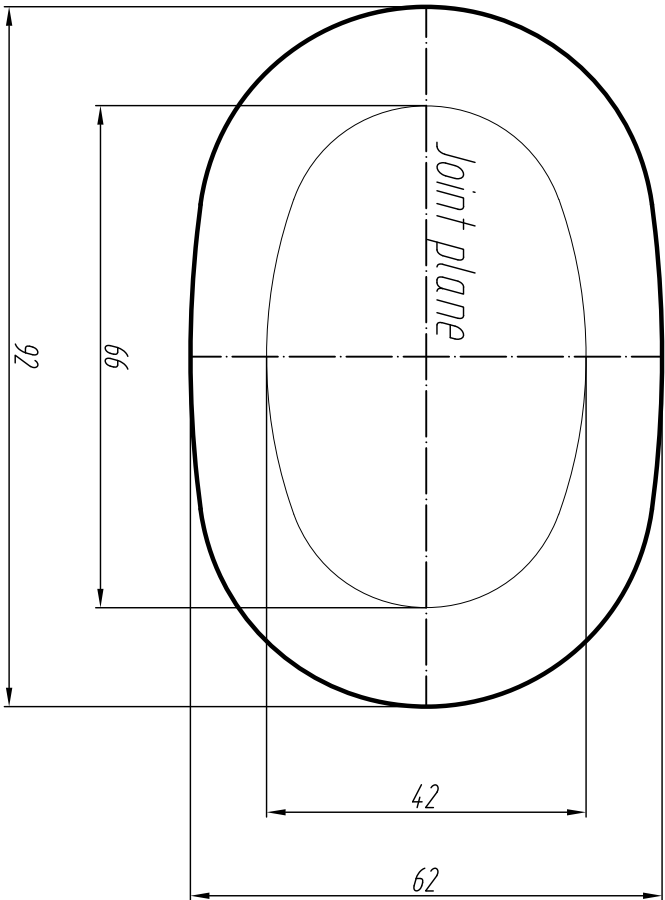


A



Neckring line

A-A



BLANK DISPT CALCULATION

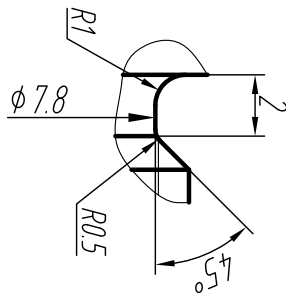
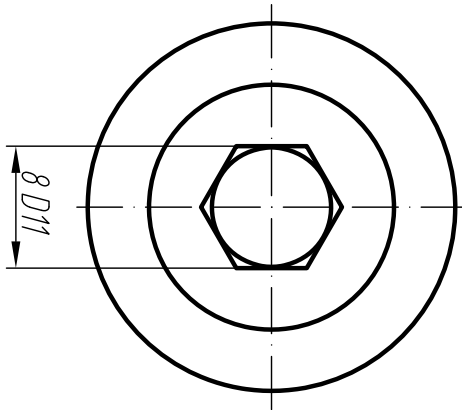
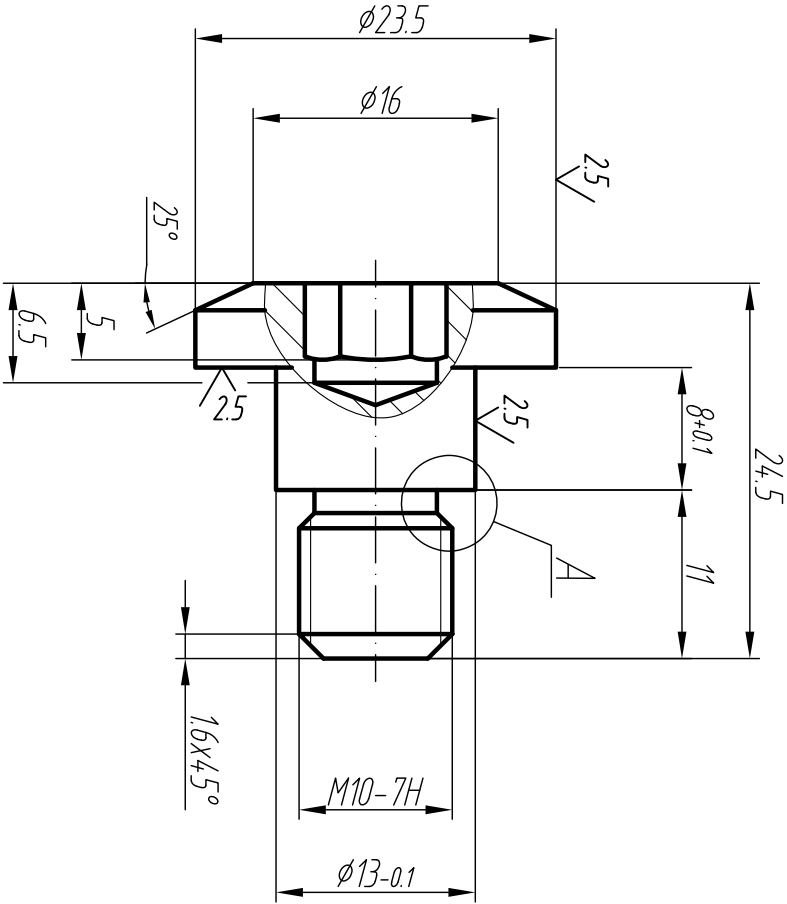
GLASS WEIGHT	244.9 (600 gr (2.45))
OVER CAPACITY	4.75 %
DISPLACEMENT OF BLANK + BAFFLE + NECK RING - PLUNGER	3612 ml
DISPLACEMENT OF BLANK AND BAFFLE	356.6 ml

		MACHINE / МАШИНА	ЕМНАРТ GLASS-BB-DG 5 1/2" -8	JOB TITLE/НАЗВАНИЕ РАБОТЫ	SCALE / МАСШТАБ
		DESIGNER / ДИЗАЙНЕР		XXI-KPM-26-2-700-17-ExtrnNew	
24.04.20	①	DATE / ДАТА	24.04.20	DRAWING NUMBER/НОМЕР ЧЕРТЕЖА	1 : 1
		REVISIONS/ИЗМЕНЕНИЯ			

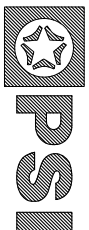


199034, Россия, Санкт-Петербург,
БО., 14 линия, д. 7,
Тел.: +7(812)3202959
e-mail: info@psiglass.ru

6.3 / (✓)



1. H12, h12, ±IT12/2.



Адрес: 199034, Россия, Санкт-Петербург,
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Тел.: +7(812)3202959
Контакт: info@psiglass.ru

DATE / DATA	REVISIONS / ИЗМЕНЕНИЯ

MACHINE / МАШИНА: EMHART GLASS-BB-DG-5 1/2"-8

JOB TITLE / НАЗВАНИЕ РАБОТЫ: XXI-KPM-26-2-700-17-ExtraNew

MATERIAL / МАТЕРИАЛ: STEEL

DESIGNER / ДИЗАЙНЕР:

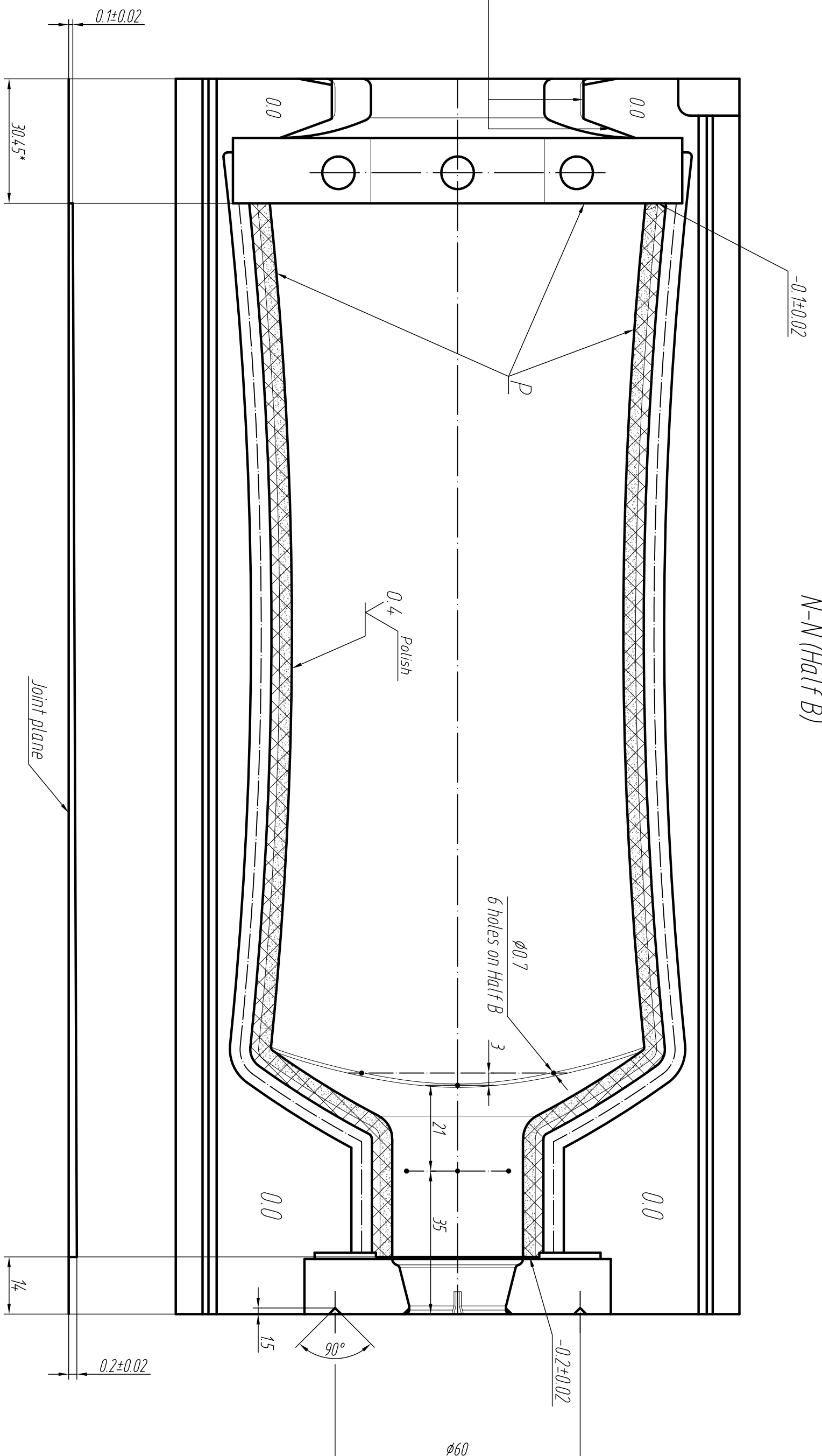
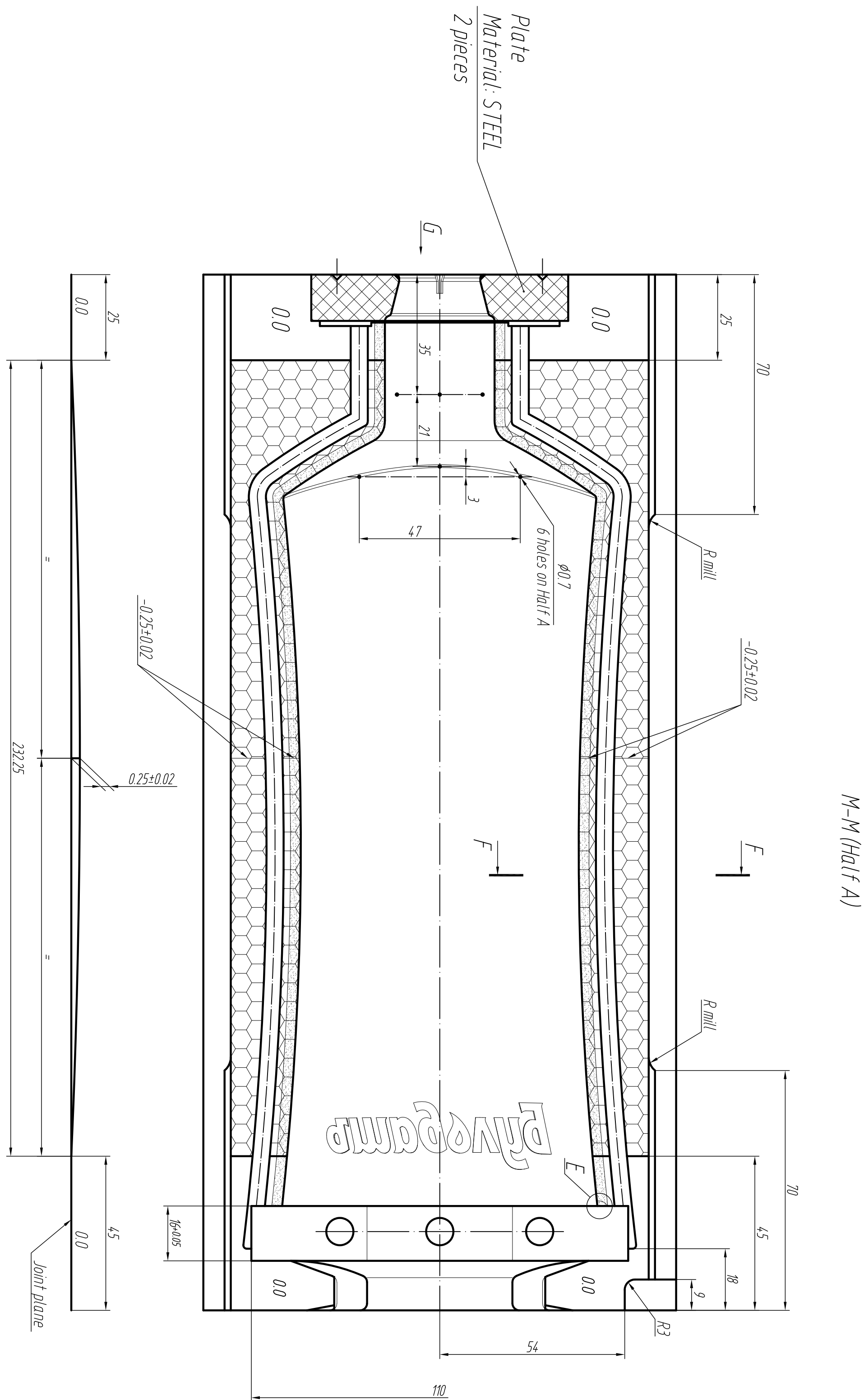
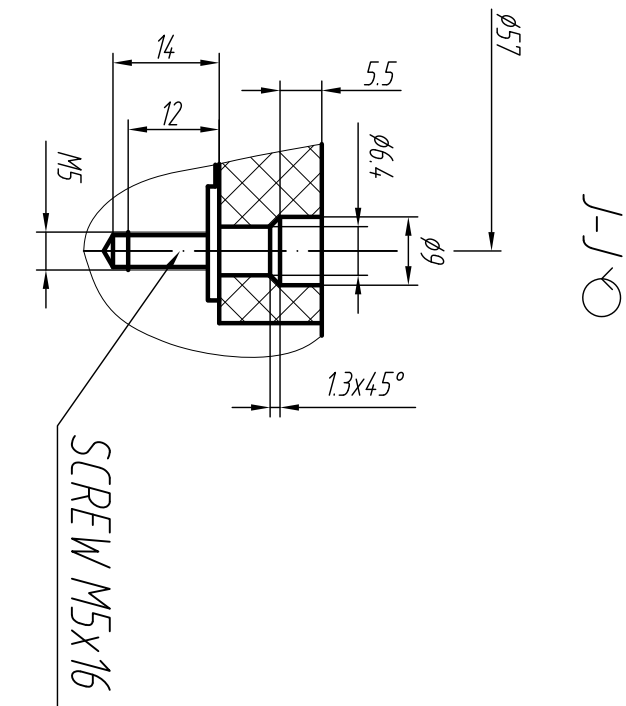
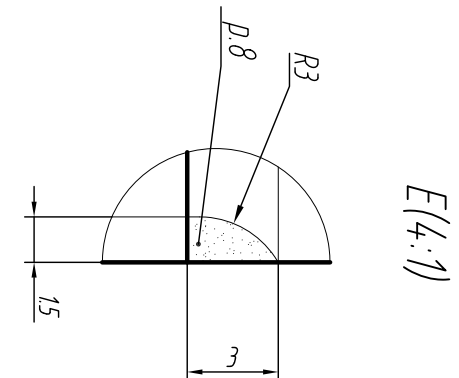
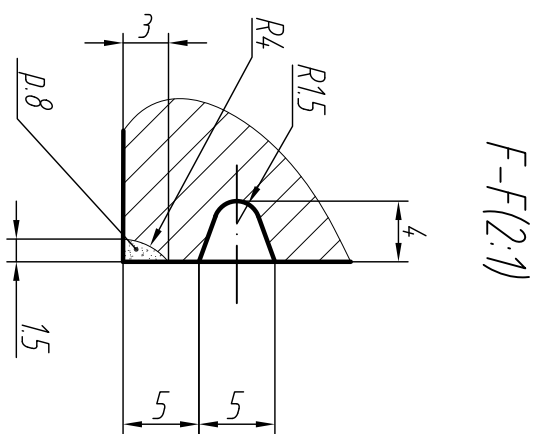
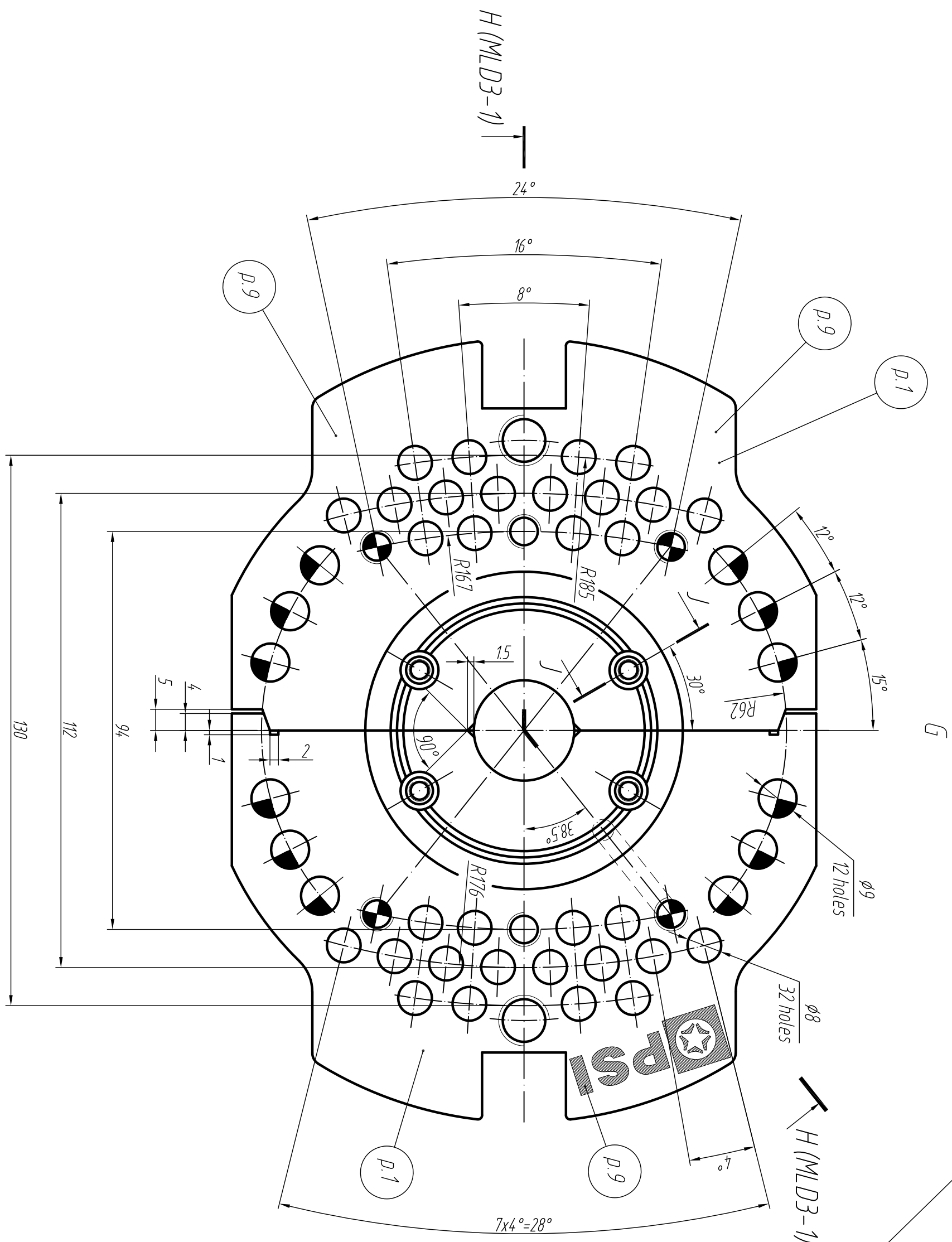
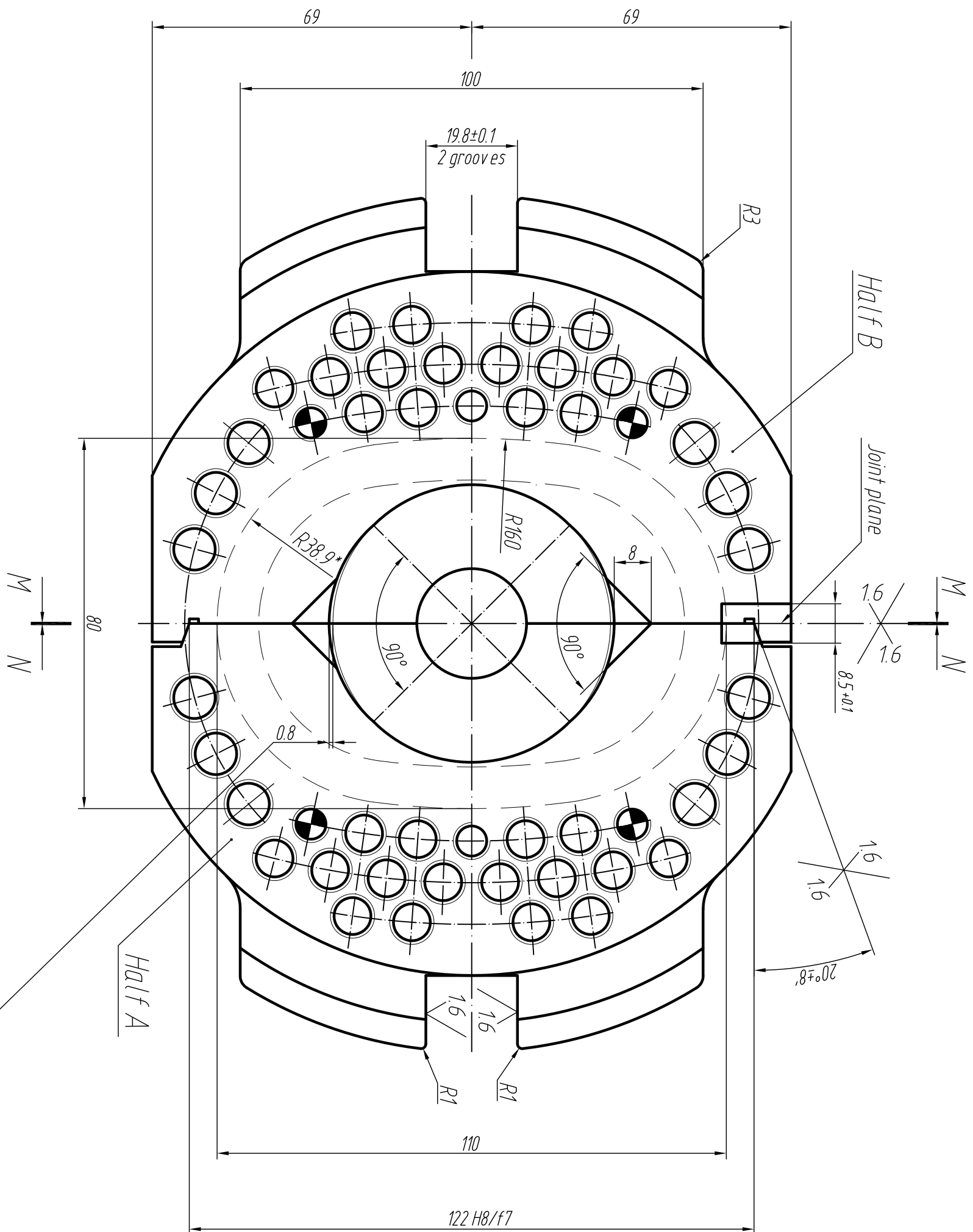
SCALE / МАСШТАБ: 2:1

WELDING / НАПЛАВКА:

DATE / DATA: 24.04.20

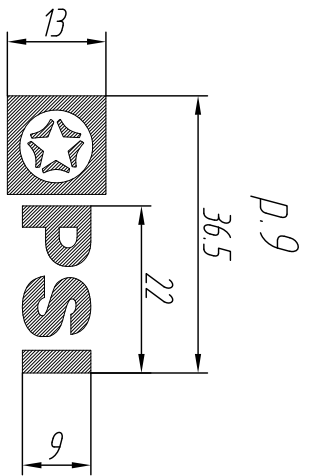
DRAWING NUMBER / НОМЕР ЧЕРТЕЖА: 5015-LUG-1

QUANTITY / КОЛИЧЕСТВО:



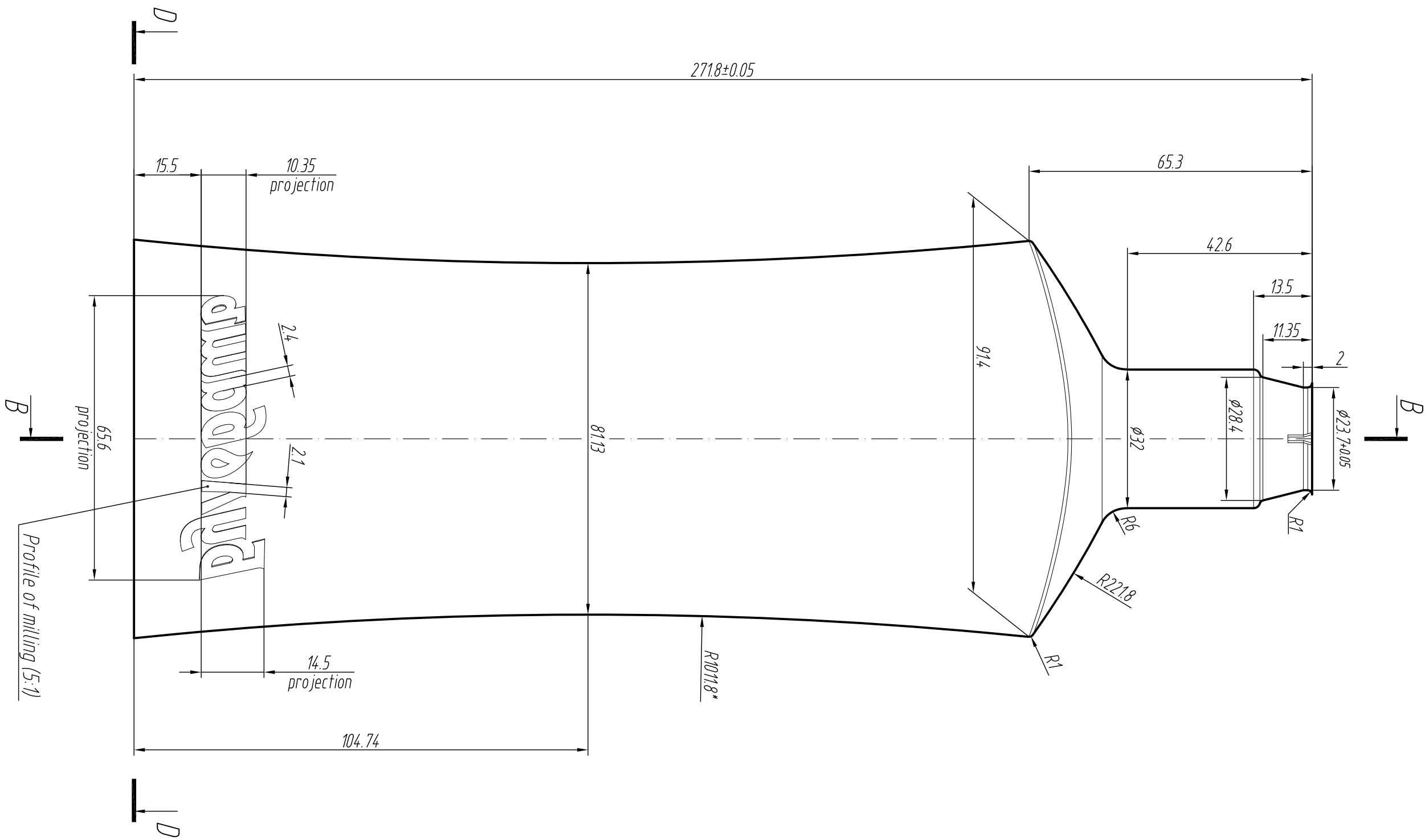
- Both halves of mold (A & B) must be marked with same ordinal number and used together.
- Gap in mold joint must be not more than 0.05 mm.
- Positional tolerance of forming cavity axis T 0.1 mm. Base - joint plane.
- Allowed deviation of forming cavity dimensions is not more than ±0.05 mm, except for dimensions that are specially shown.
- Keep sharp edges P.
- Reference only dimensions
- H14, h14, ±11/4, /2.

- Hardness after welding HRC 35-40.
- Mark XXI-KPM-26-2-700-17-ExtraNew
- Mark 5015
- Mark ordinal number (h=8) & PSI logo
- Depth of marking-0.2-0.3 mm
- Top holes with screws M8x8 and punch.



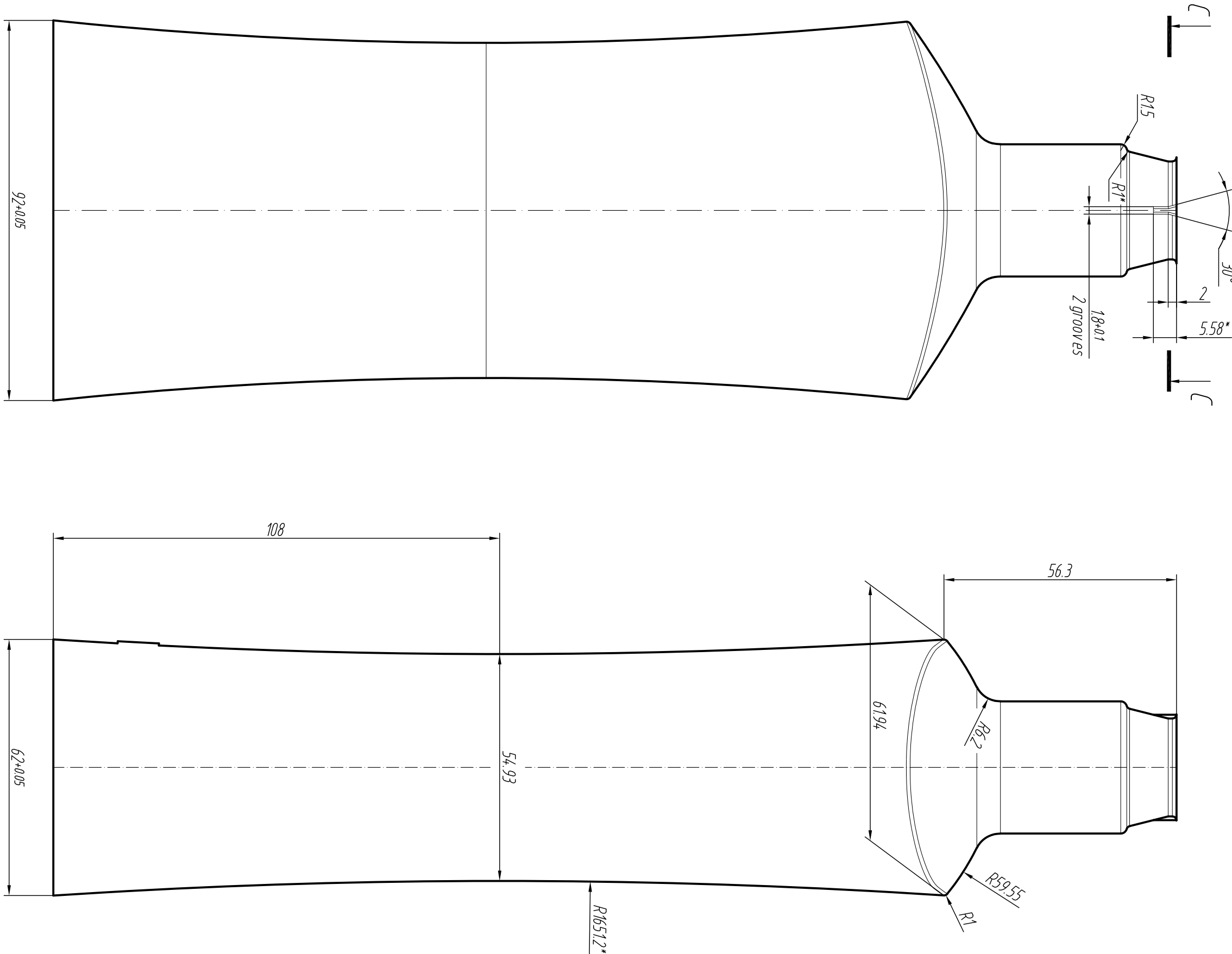
24.04.20	ASSEMBLY NUMBER/ СБОРКА	53	MATERIAL/ МАТЕРИАЛ	CAST IRON (GS900)	MACHINE/ МАШИНА	EMART GLASS-BB-065V2-8	JOB TITLE/НАЗВАНИЕ ПРОЕКТА	XXI-KPM-26-2-700-17-ExtraNew	SCALE/ МАСШТАБ	1:1
24.04.20	INVERT. CENTRE/ ИНВЕРТ. ЦЕНТР	105	WELDING/ СВАРКА	Base and edges (HRC 35-40)	DESIGNER/ ПРОЕКТИРОВЩИК	DATE/ ДАТА	DRAWING NUMBER/НОМЕР ЧЕРТЕЖА	5015-MLD1-3		
	REVISIONS/ИЗМЕНЕНИЯ	5715	HY. DIMENSION/ КОМПЛЕКТ							
	DATE/ДАТА									

Half "A"

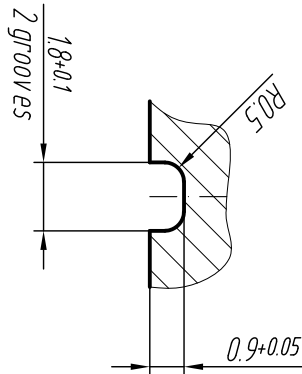


Glassforming surface

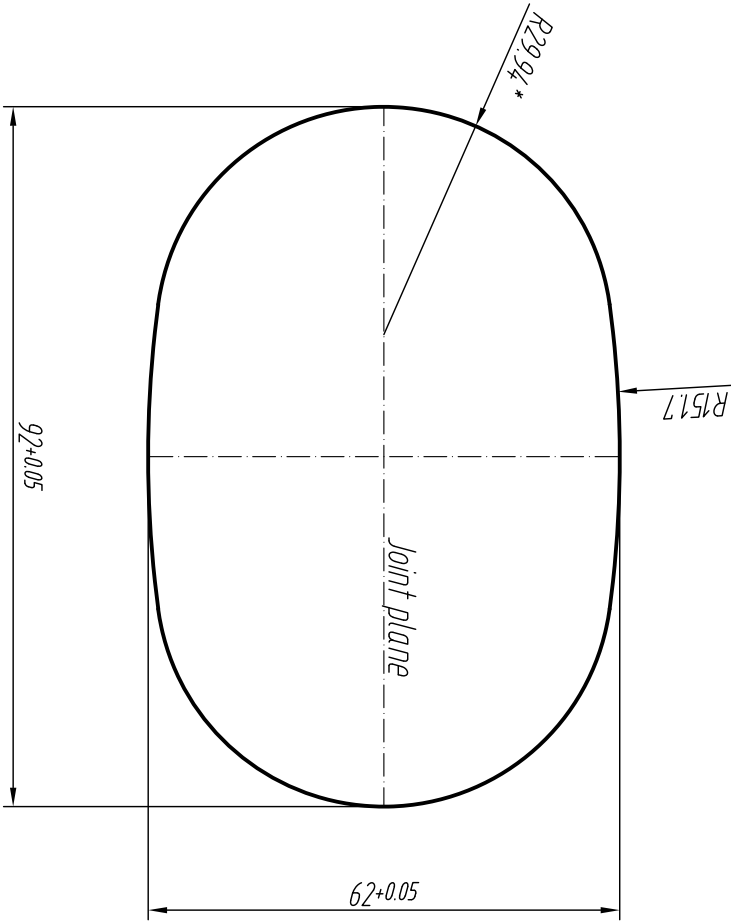
Half "B"



C-C (5:1)



D-D

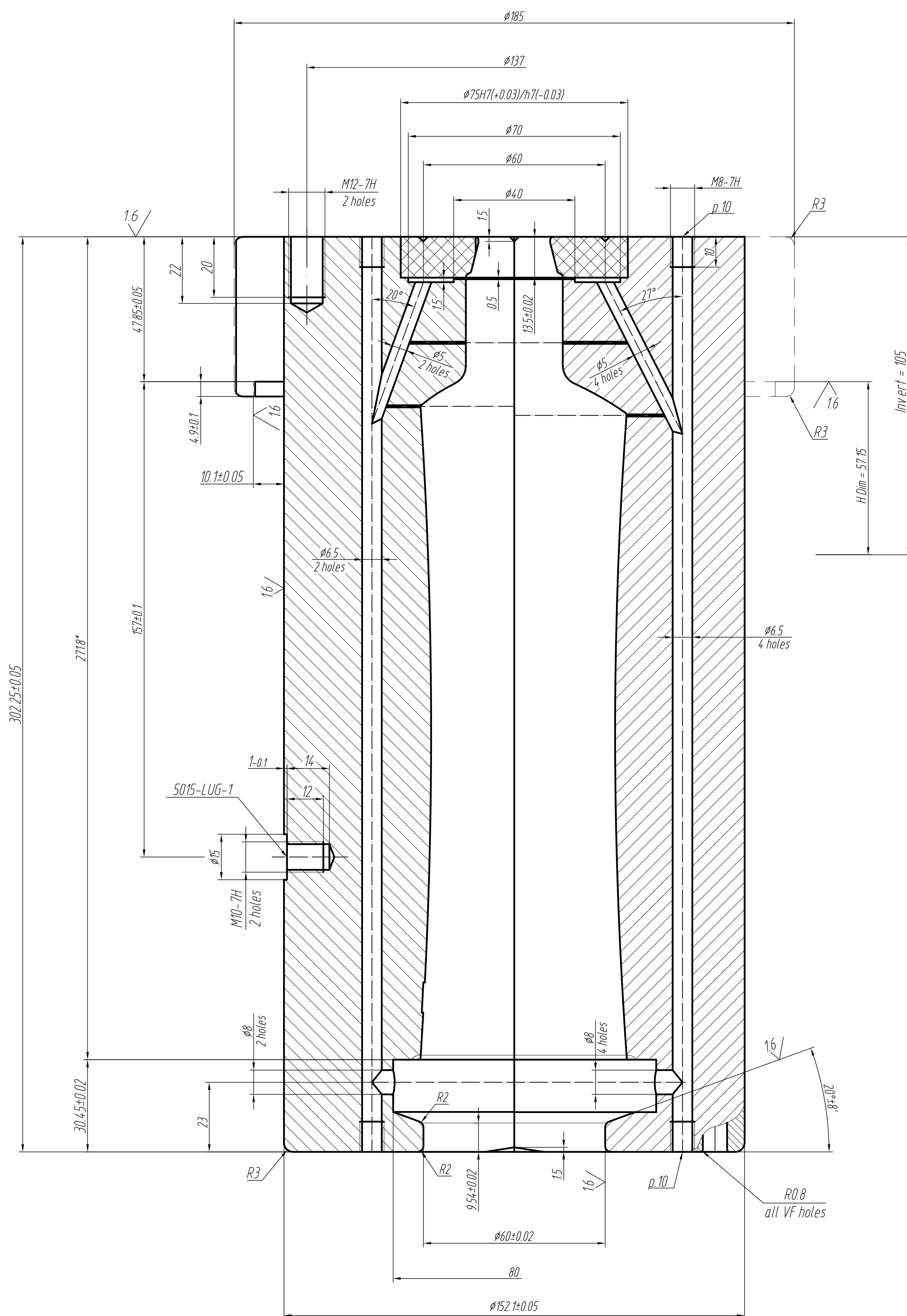


MOULD+BOTTOM/ объем форма + поддон - 964 ml

Milling of cavity must be performed according to the 3D model
Allowed deviation of forming cavity dimensions is not more than ±0.05 mm.
except for dimensions that are specially shown.

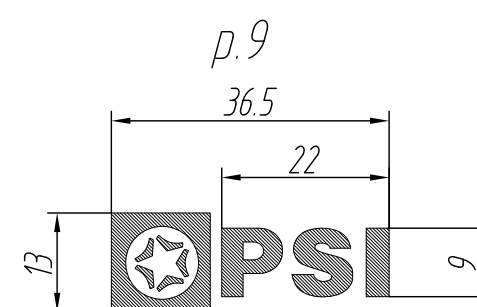
	MACHINE/ МАШИНА:	EMHART GLASS-BB-DG 5 1/2"-8	JOB TITLE/НАЗВАНИЕ РАБОТЫ:	XXI-KPM-26-2-700-17-ExtraNew	SCALE/ МАШТАБ:
24.04.20	DESIGNER/ ДИЗАЙНЕР:		DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:	5015-MLD2-2	1:1
DATE/ДАТА	REVISIONS/ИЗМЕНЕНИЯ	DATE/ДАТА:			


H-H (MLD1-1)

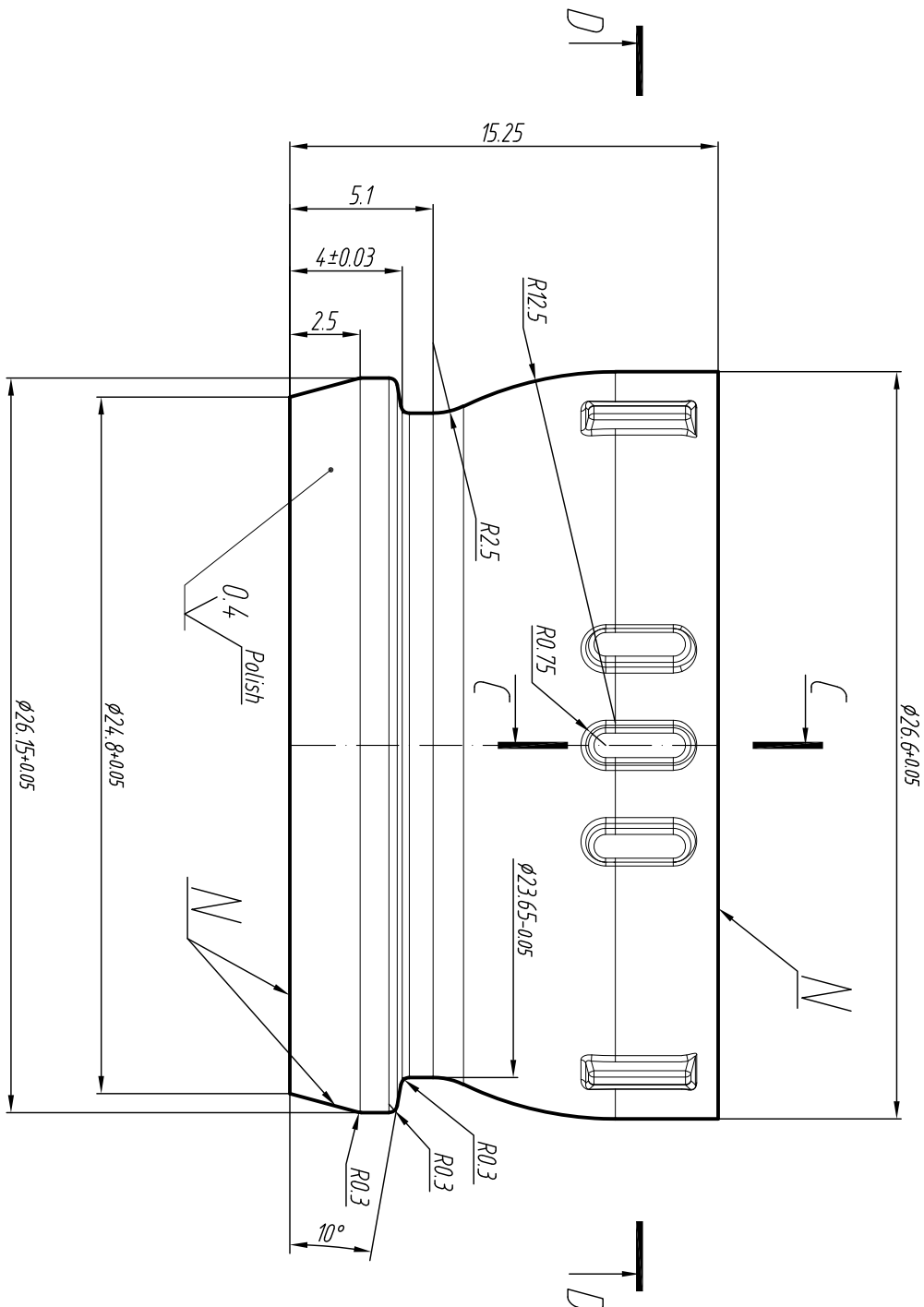
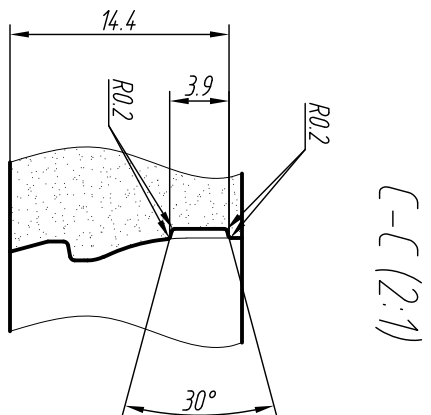
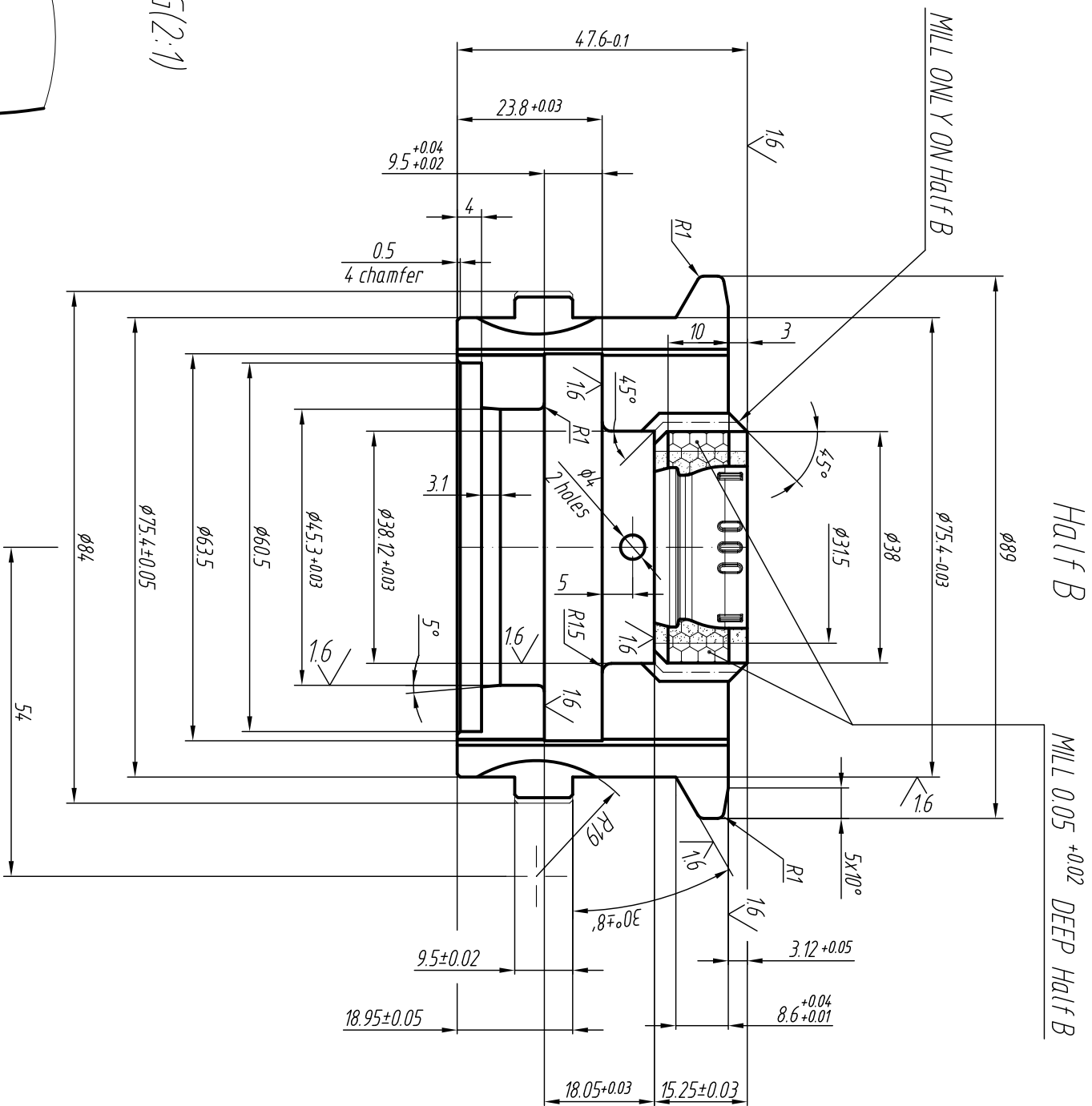


1. Both halves of mould (A & B) must be marked with same ordinal number and used together.
2. Gap in mould joint must be not more than 0.05 mm.
3. Positional tolerance of forming cavity axis T 0.1mm. Base – joint plane
4. Allowed deviation of forming cavity dimensions is not more than ± 0.05 mm, except for dimensions that are specially shown.
5. Keep sharp edges P.
6. *Reference only dimensions
7. H14, h14, $\pm T14/2$

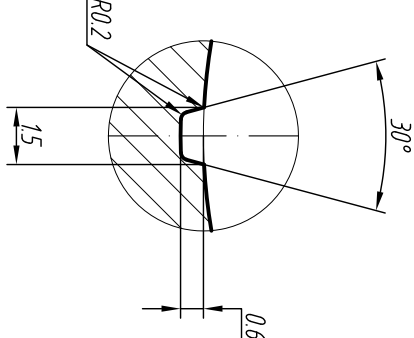
8. Hardness after welding HRC335.40.
9. Mark: XXI-KPM-26-2-700-17-ExtraNew
Mark: 5015
Mark ordinal number (h=8) & PSI logo.
Depth of marking-0.2..0.3 mm.
10. Cap holes with screws M8x8 and punch.



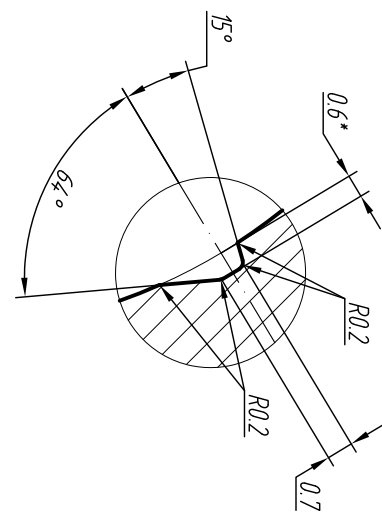
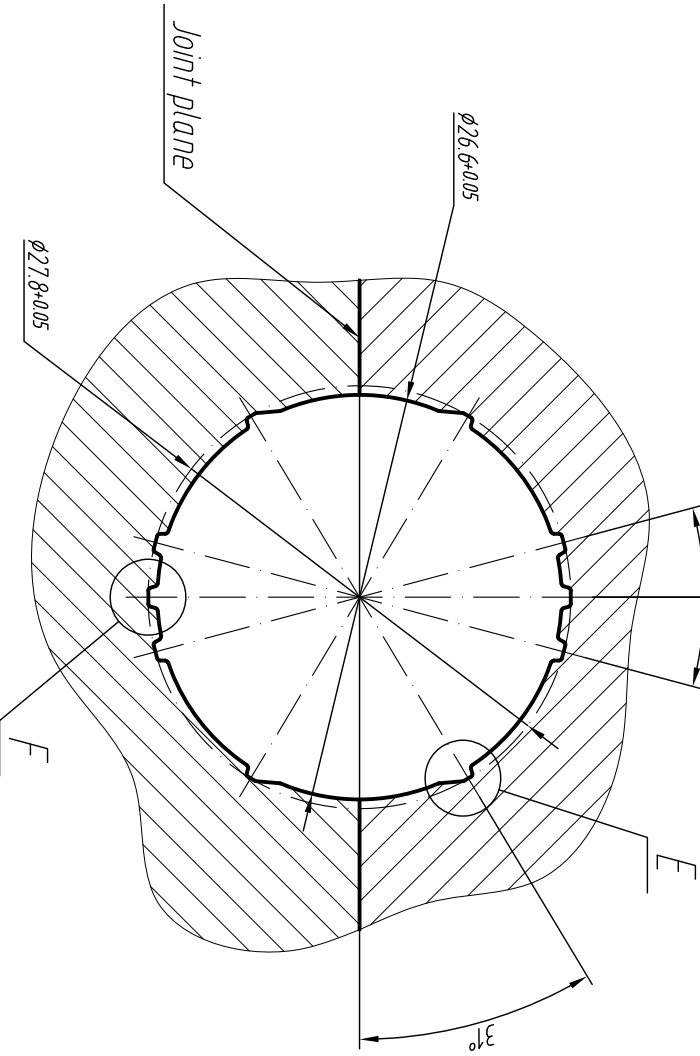
 PSI		Адрес: 199034, Россия, Санкт-Петербург, В.О., 14 линия, д. 7. Тел.: +7(812)3202959 Контакт: info@psiglass.ru	
JOB TITLE/НАЗВАНИЕ РАБОТЫ: XXI-KPM-26-2-700-17-ExtraNew		SCALE/ МАСШТАБ:	
DRAWING NUMBER/НОМЕР ЧЕРТЕЖА: 5015-MLD3-3		1:1	



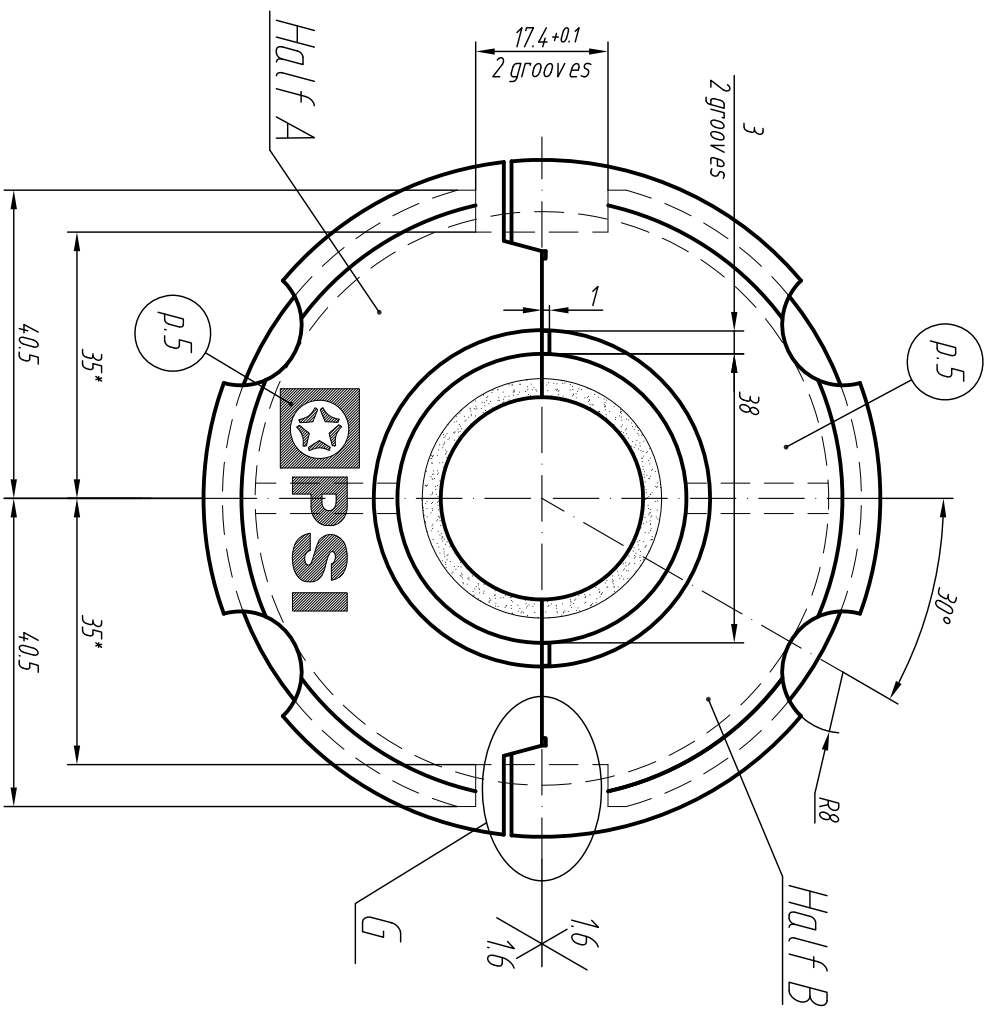
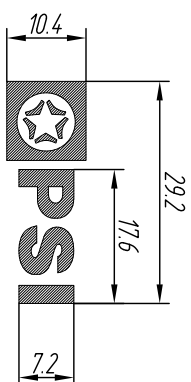
F (5:1)



D-D (2:1)



P.5



TOLERANCES UNLESS OTHERWISE STATED : ±0.05

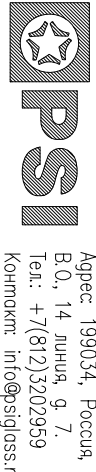
* - Reference only dimensions

1. H14, h14, ±IT14/12.
2. Positional tolerance of forming cavity axis T0.1 mm. Base - joint plane.
3. Keep sharp edges N.
4. Gap in joint of ring must be not more than 0.05 mm.
5. Mark: XXI-KPM-26-2-700-17-ExtraNew

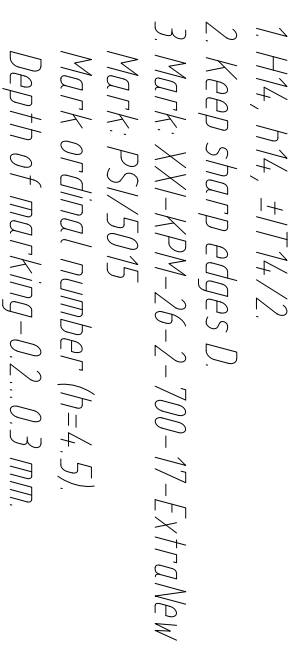
Mark: 5015

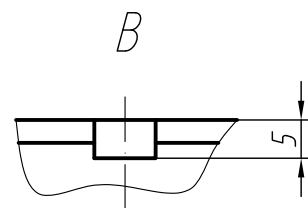
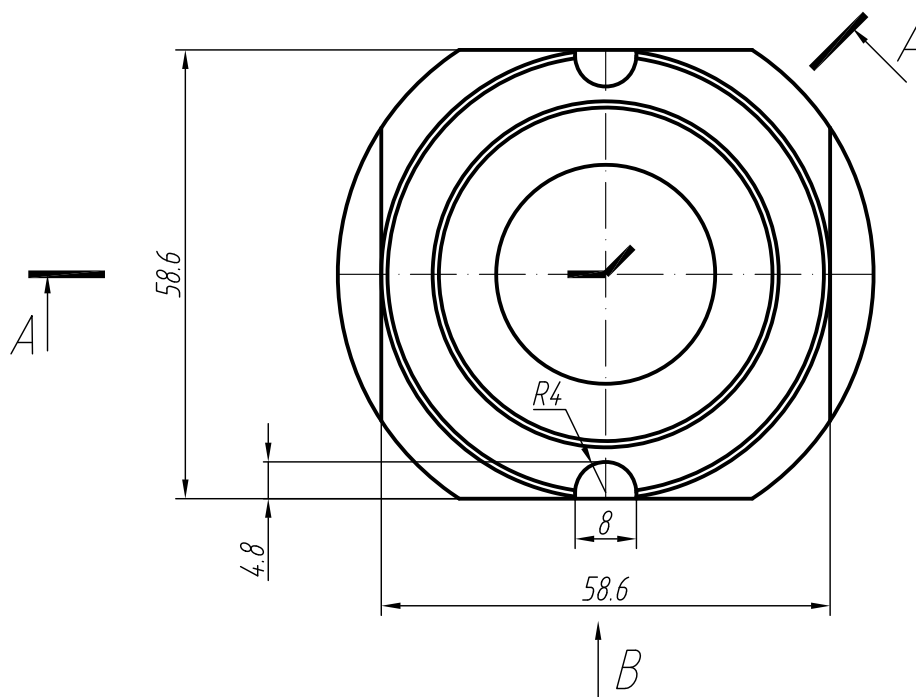
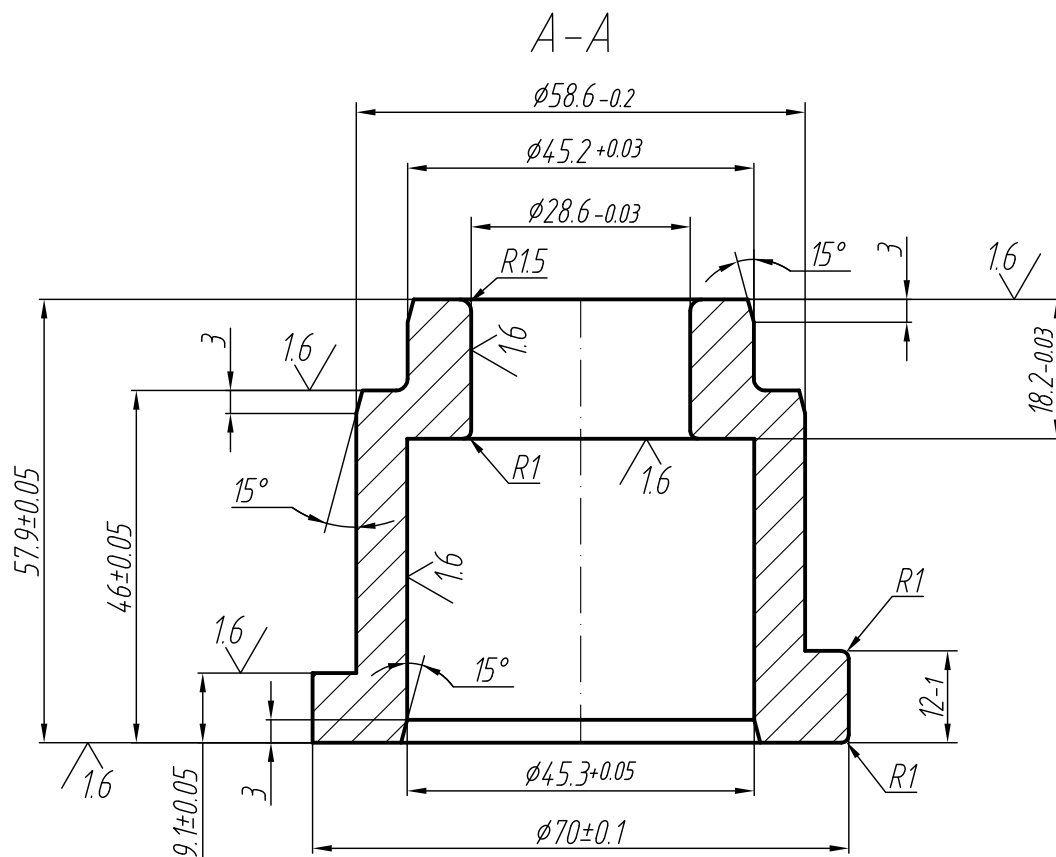
Mark ordinal number (h=7) & PSI logo
Depth of marking-0.2..0.3 mm.

		MATERIAL/ МАТЕРИАЛ:	Bronze (GS 889)	MACHINE/ МАШИНА:	EMHART GLASS-BB-DG 5 1/2"-8	JOB TITLE/НАЗВАНИЕ РАБОТЫ:	XXI-KPM-26-2-700-17-ExtraNew	SCALE/ МАСШТАБ:	1:1
		WELDING/ НАПЛАВКА:	Cavity (HRC 35..40)	DESIGNER/ ДИЗАЙНЕР:		DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:	5015-NR-1		
		QUANTITY/ КОЛИЧЕСТВО:		DATE/ ДАТА:	24.04.20				
		REVISIONS/ИЗМЕНЕНИЯ							
		DATE/ДАТА							



Адрес: 199034, Россия, Санкт-Петербург,
Б.О., 14 этаж, 9-7,
Тел.: +7(812)3202959
Контакт: info@psi-glass.ru


$$\sqrt{6.3}$$




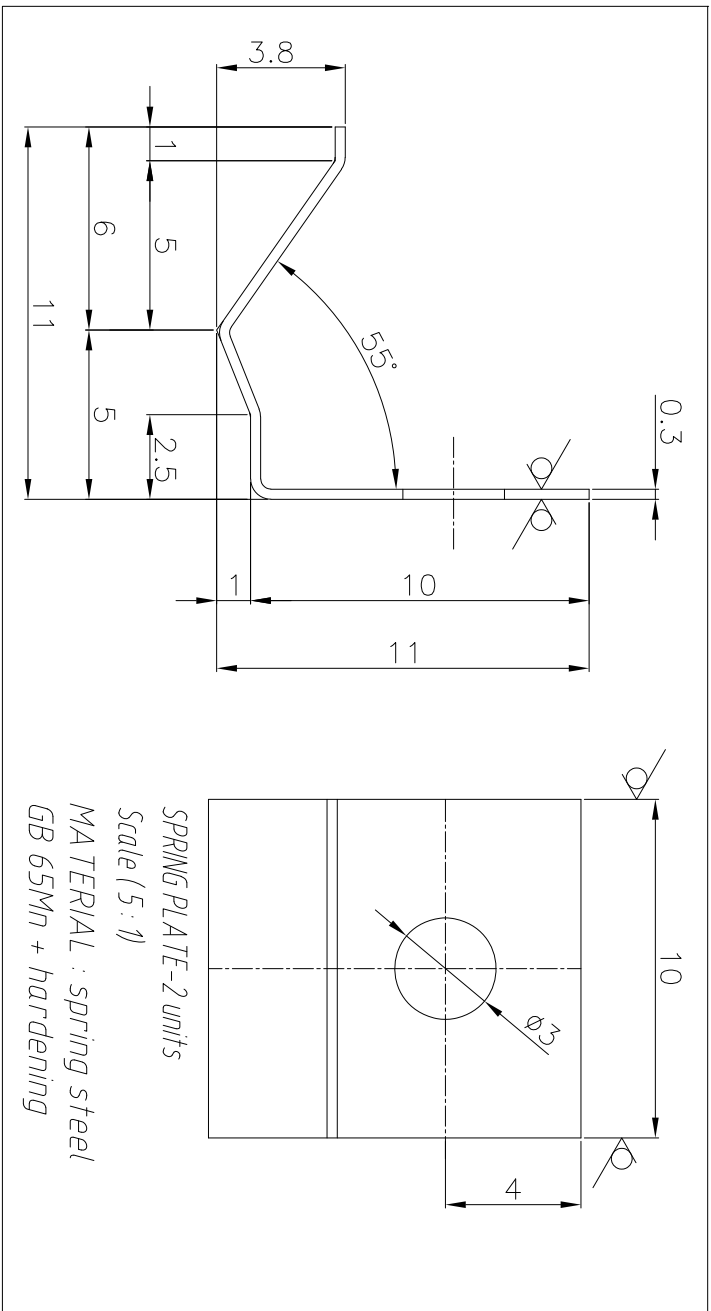
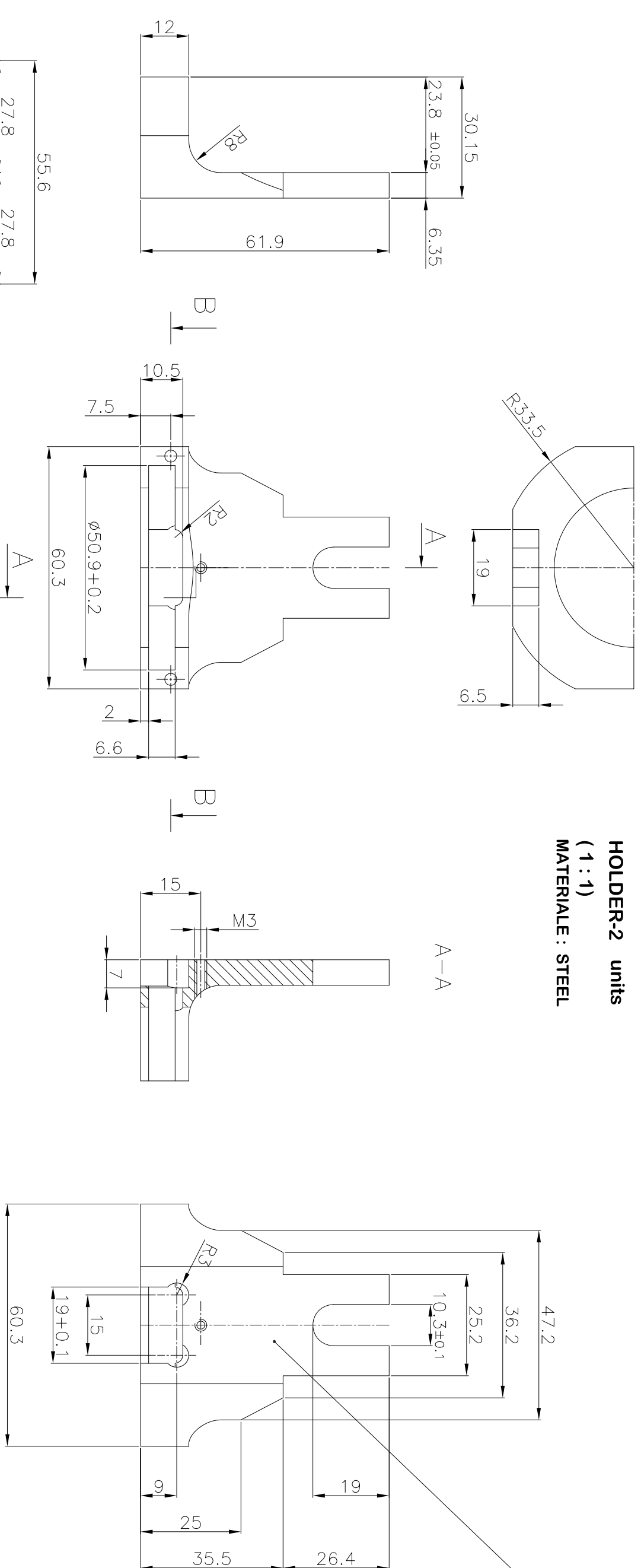
1. H14, h14, ±IT14/2.
2. Mark: XXI-KPM-26-2-700-17-ExtraNew
Mark: PSI/5015
Mark ordinal number (h=4.5).
Depth of marking-0.2...0.3 mm.

DATE/ДАТА	REVISIONS/ИЗМЕНЕНИЯ
MATERIAL/МАТЕРИАЛ:	CAST IRON (GS 900)
WELDING/НАПЛАВКА:	
QUANTITY/КОЛИЧЕСТВО:	

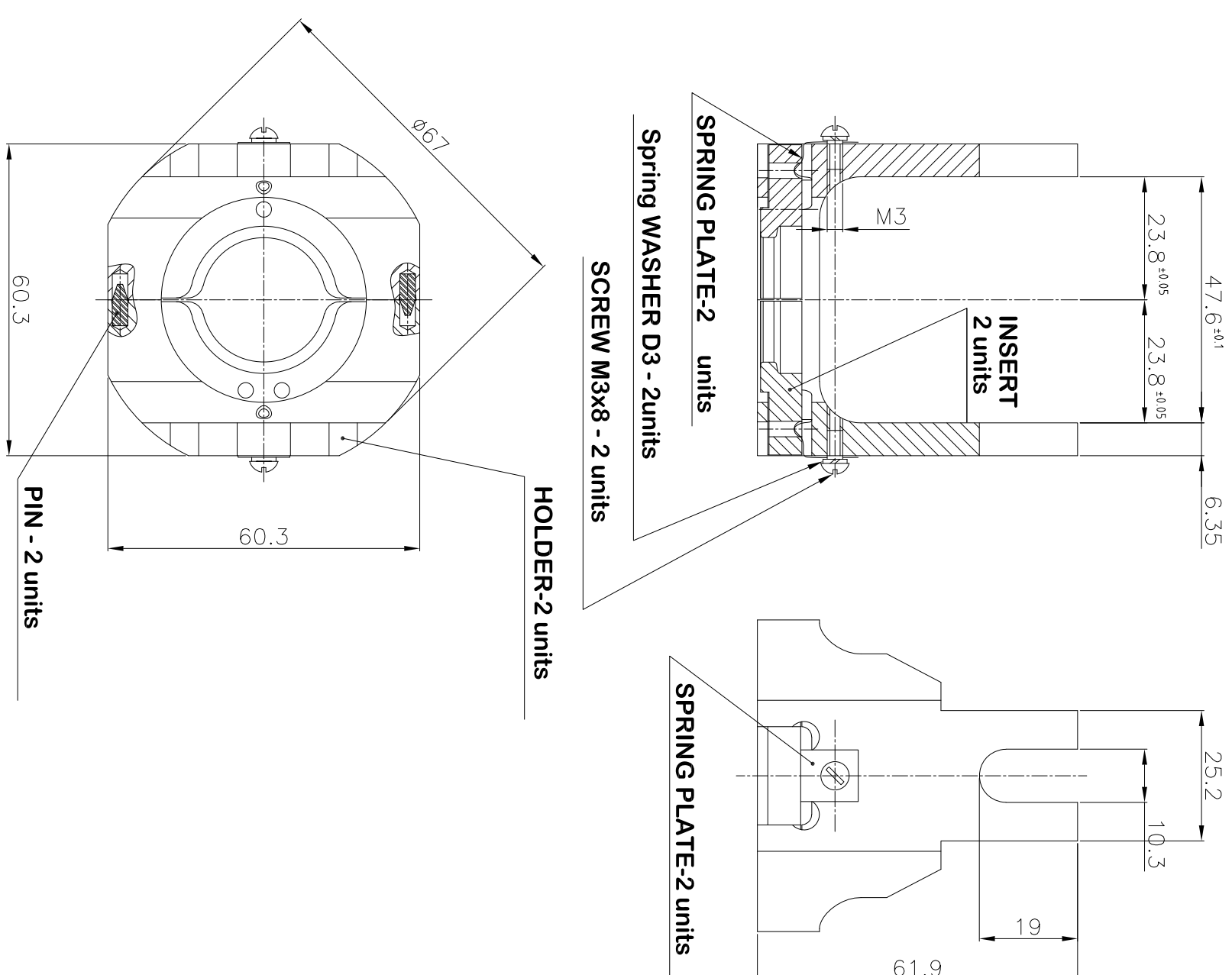
MACHINE/МАШИНА:	EMHART GLASS-BB-DG 5 1/2"-8
DESIGNER/ДИЗАЙНЕР:	
DATE/ДАТА:	24.04.20

		Адрес: 199034, Россия, Санкт-Петербург, В.О., 14 линия, г. 7. Тел.: +7(812)3202959 Контакт: info@psiglass.ru	
JOB TITLE/НАЗВАНИЕ РАБОТЫ:		SCALE/ МАСШТАБ:	
XXI-KPM-26-2-700-17-ExtraNew			
DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:		1:1	
5015-THI-1			

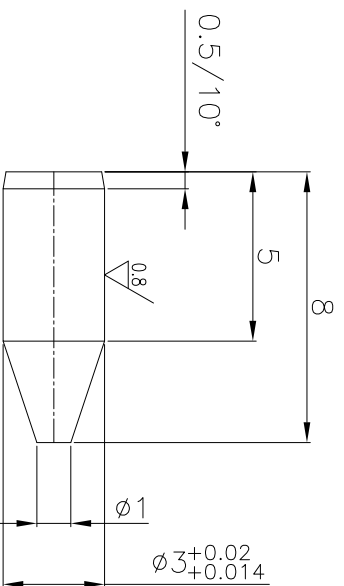
ASSEMBLE 1:1



Mark: PSI/5015
Make in pairs, mark with same ordinal number & use together
Depth of marking – 0.3mm

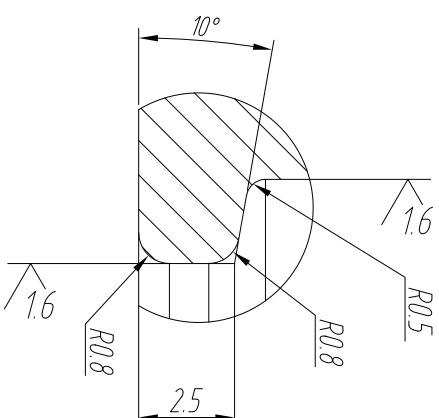
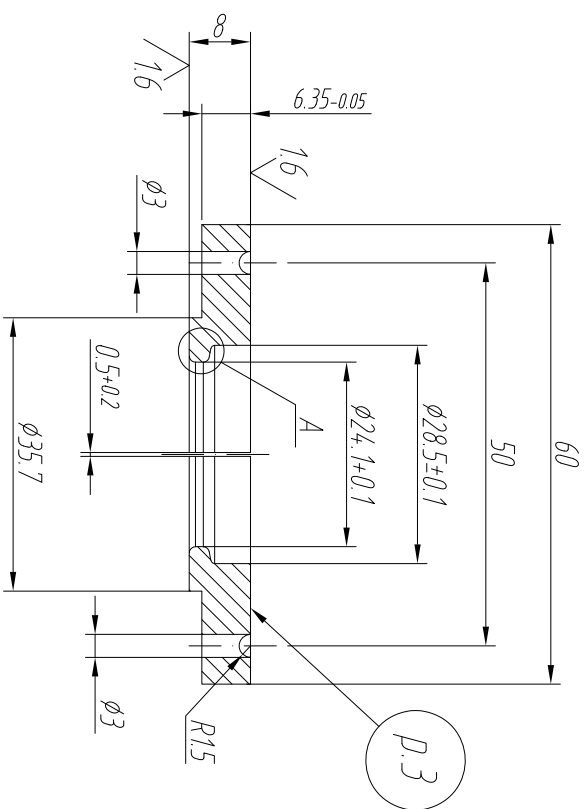


**PIN - 2 units
(5 : 1)
MATERIALE: STEEL**



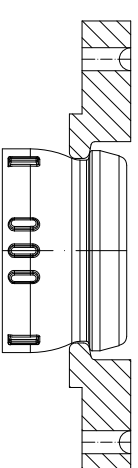
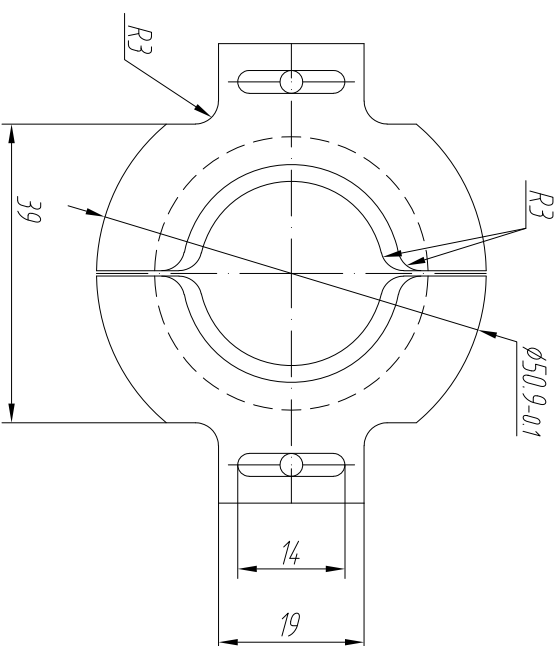
1. Unspecified limit deviations of dimensions $H14$, $h14$, $+/-IT14/2$
2. * - Reference only dimensions

	MATERIAL/ МАТЕРИАЛ	Steel	MACHINE/ МАШИНА	EMHART GLASS-88-DIG 5 1/2"-8	JOB TITLE / НАЗВАНИЕ ПРОЕКТА XXI-KPM-26-2-700-17-ExtraNew	SCALE/ МАСШТАБ: 1:1
	WELDING/ ВАРКА		DESIGNER/ ПРОЕКТИРОВЩИК			
DATE / DATA	REVISIONS / ИЗМЕНЕНИЯ	QUANTITY / КОЛИЧЕСТВО	DATE / ДАТА	24.04.20	DRAWING NUMBER / НОМЕР ЧЕРТЕЖА 5015-101-1	



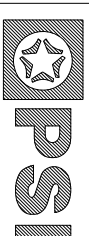
A (5:1)

6.3 / (✓)



ASSEMBLE

1. H14, h14, $\pm 1/14/2$.
2. * - Reference only dimensions.
3. Mark: PSI/4691



Адрес: 199034, Россия, Санкт-Петербург,
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Тел.: +7(812)202959
Контакт: info@psiglass.ru

MATERIAL / МАТЕРИАЛ: Graphite

JOB TITLE / НАЗВАНИЕ РАБОТЫ:

XXI-KPM-26-2-700-17-ExtraNew (VH)

SCALE / МАСШТАБ:

DRAWING NUMBER / НОМЕР ЧЕРТЕЖА:

5016-INS-1

1:1

DATE / ДАТА

REVISIONS / ИЗМЕНЕНИЯ

QUANTITY / КОЛИЧЕСТВО:

DATE / ДАТА

24.04.20