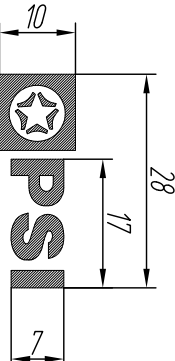


Glassforming surface

ENGRAVING PROFILE (10:1)

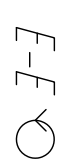
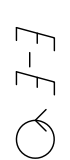
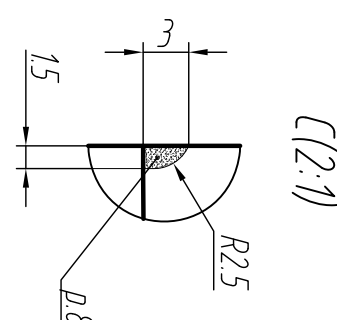
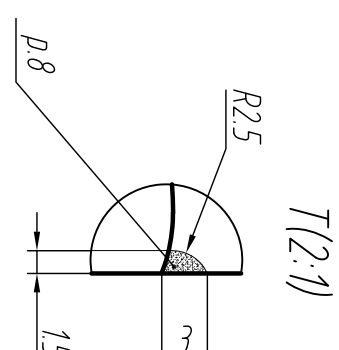
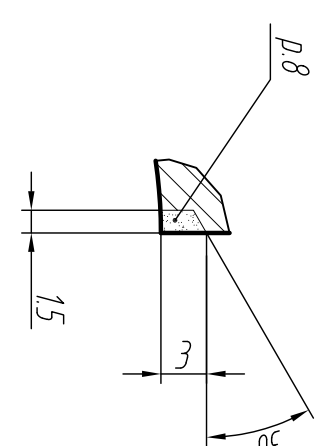


PSI logo

- 1 H14, h14, ±IT14/2
  - 2 Keep sharp edges B
  - 3 \*Reference only dimensions
  4. Hardness after welding HRC35..40.
  - 5 Mark- XXI-KPM-26-2-1000-18-ExtraNew
- Mark- 5017
- 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

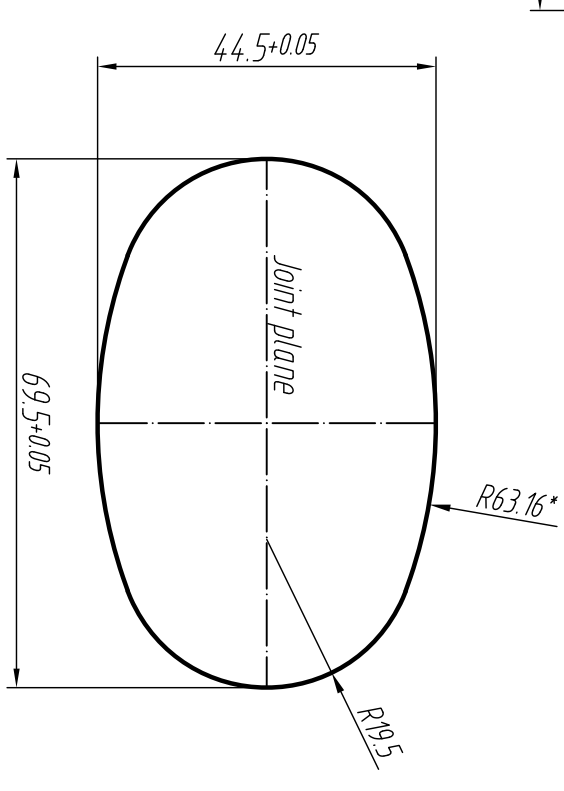
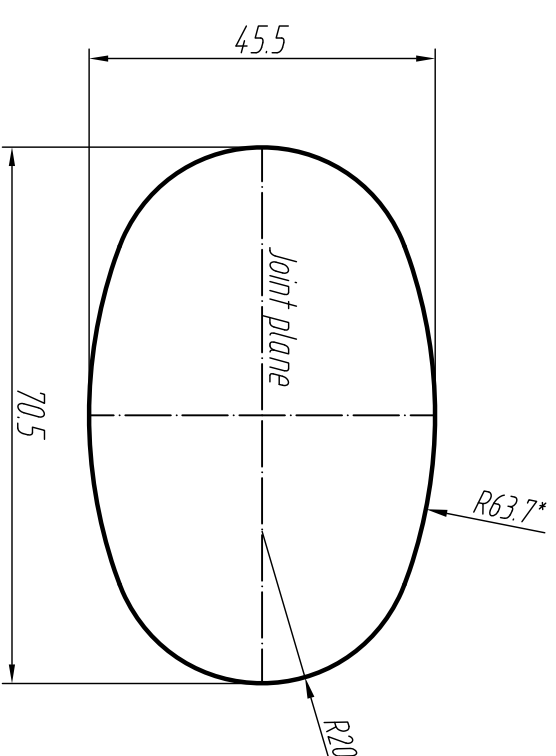
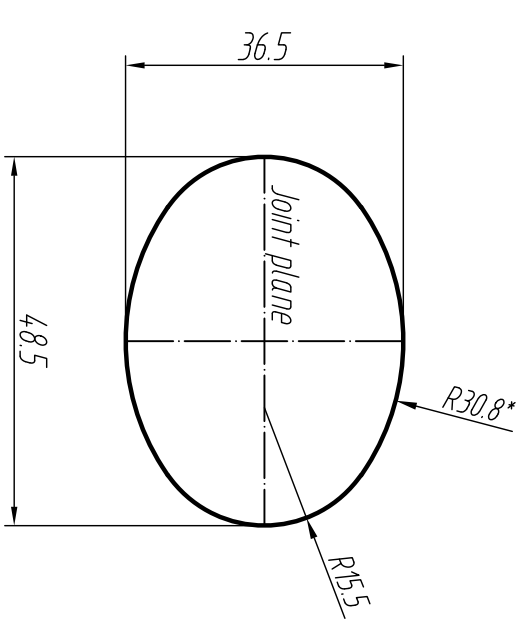
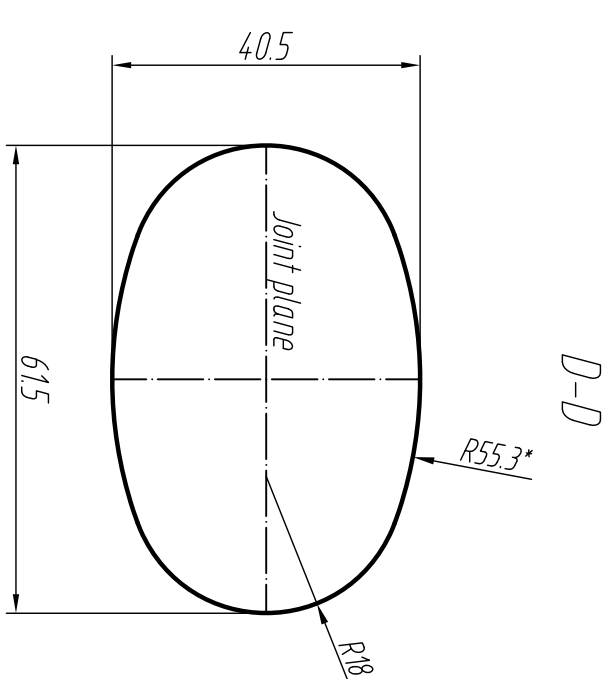
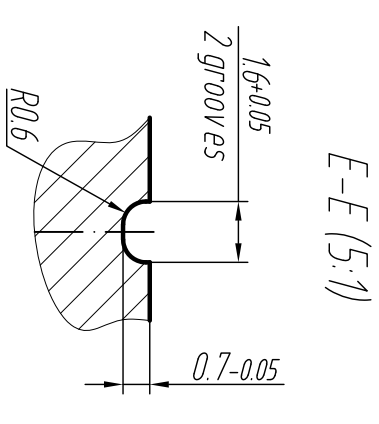
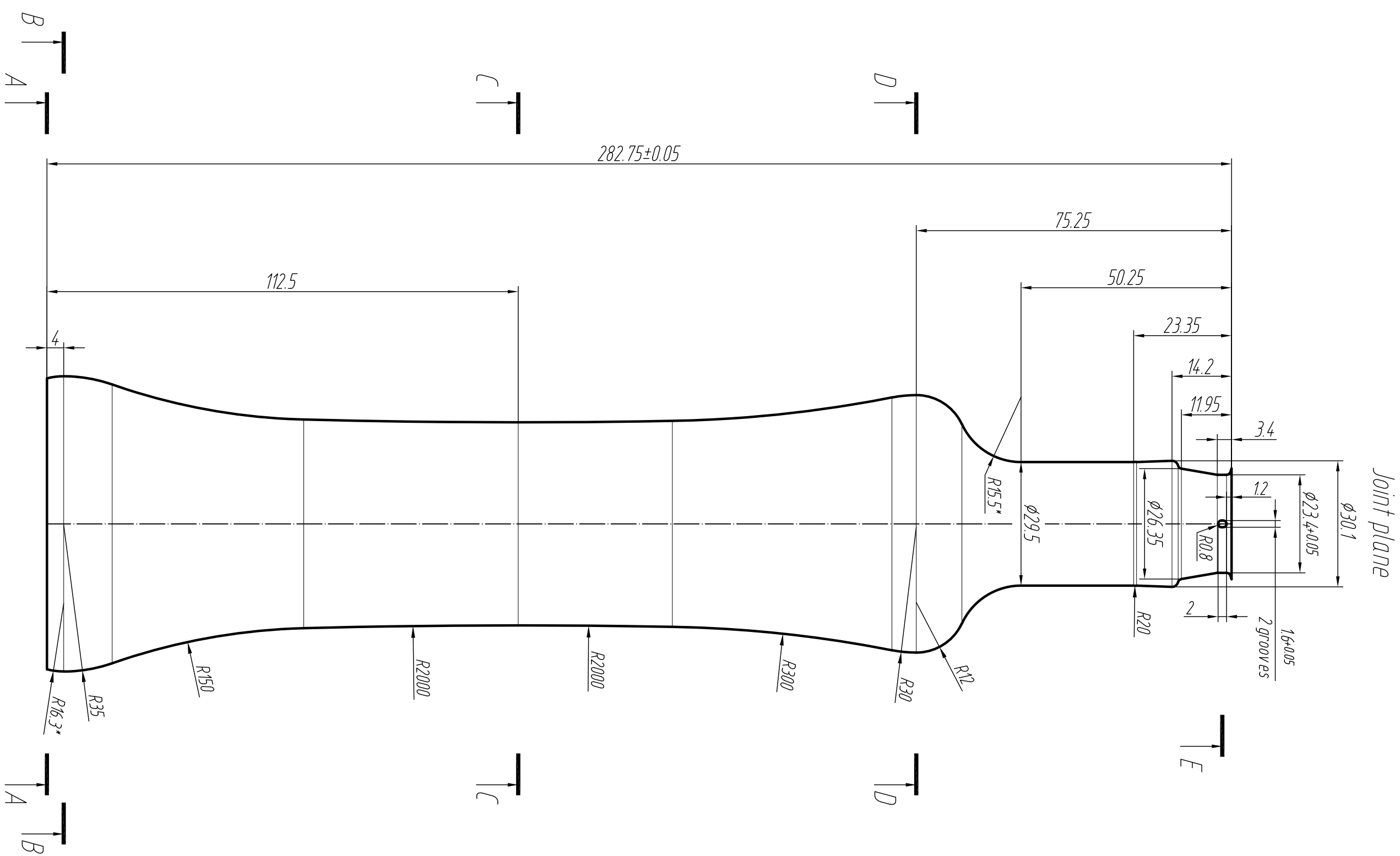
	MATERIAL/ МАТЕРИАЛ:	CAST IRON (GS 900)	MACHINE/ МАШИНА:	EMHART GLASS-BB-DG 5 1/2"-8	JOB TITLE/НАЗВАНИЕ РАБОТЫ:	XXI-KPM-26-2-1000-18-ExtraNew	SCALE/ МАШТАБ:	1:1
	WELDING/ ВАЙДАННЯ:	MATCH (HRC 35..40)	DESIGNER/ ДИЗАЙНЕР:		DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:	5017-BAF-1		
DATE/ДАТА	REVISIONS/ІЗМЕНЕННЯ			QUANTITY/ КОЛИЧЕСТВО:	DATE/ДАТА:	24.04.20		



Technical drawing of a vertical rectangular object. The total height is 30.5. The top section has a width of 13 and a height of 22. This section contains a circular emblem with a five-pointed star. Below this is a section with a height of 9. The bottom section is a solid rectangular block with a width of 9.

**PSI**  
Адрес: 199034, Россия, Санкт-Петербург,  
Б-0, 14 линия, д. 7.  
Тел: +7(812)3302959  
Контакты: info@psi.su.ru

## Glasforming surface



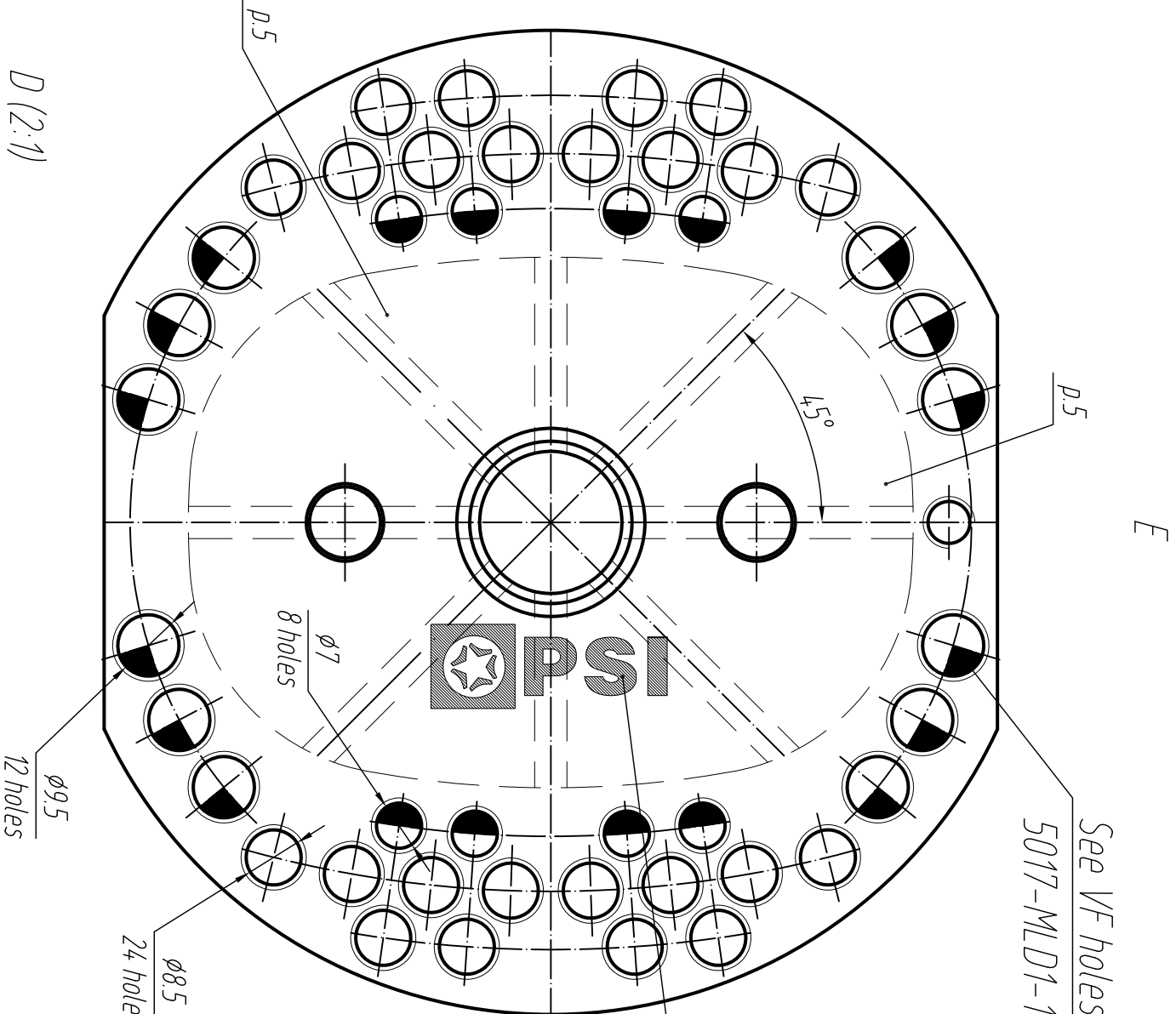
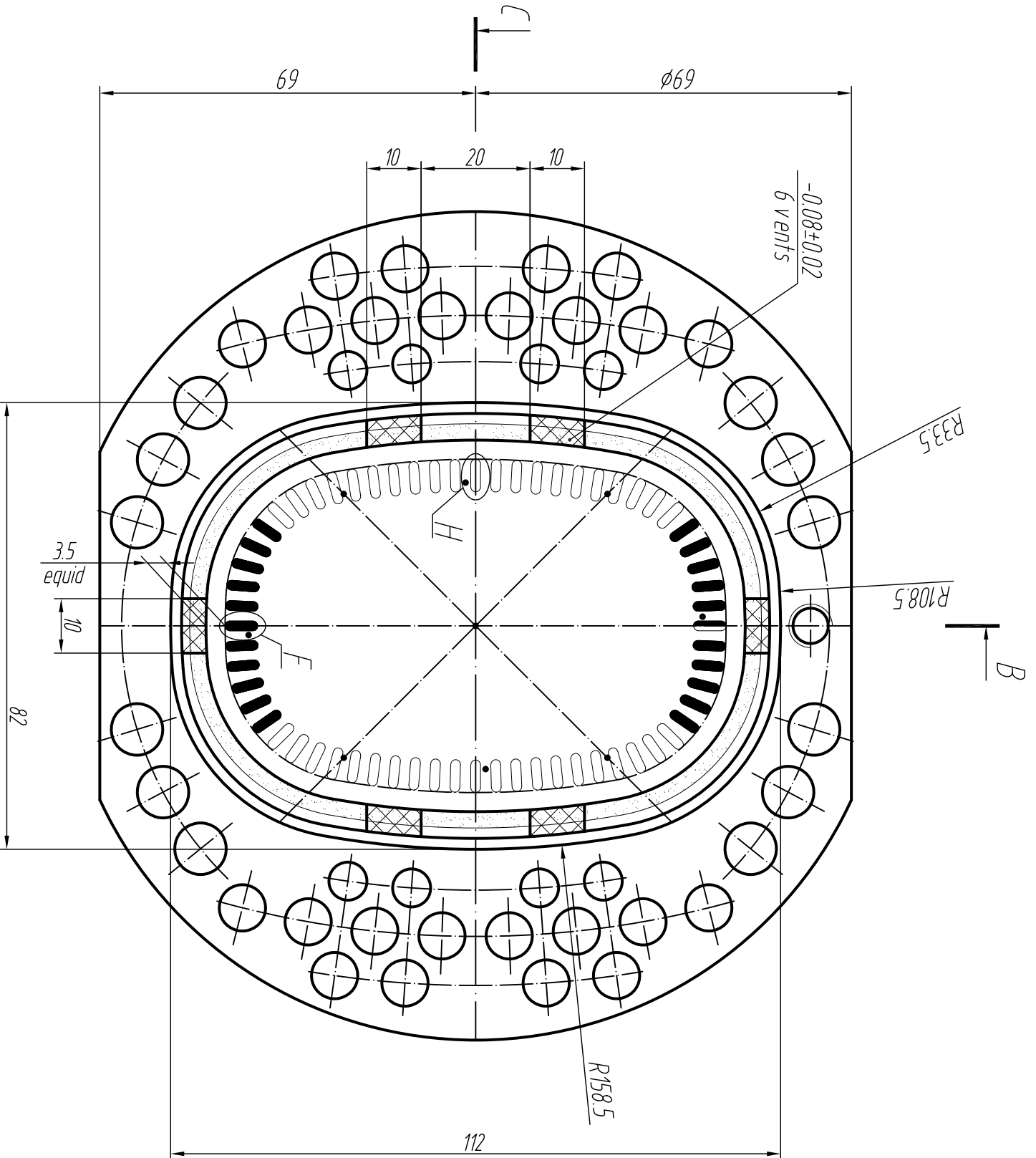
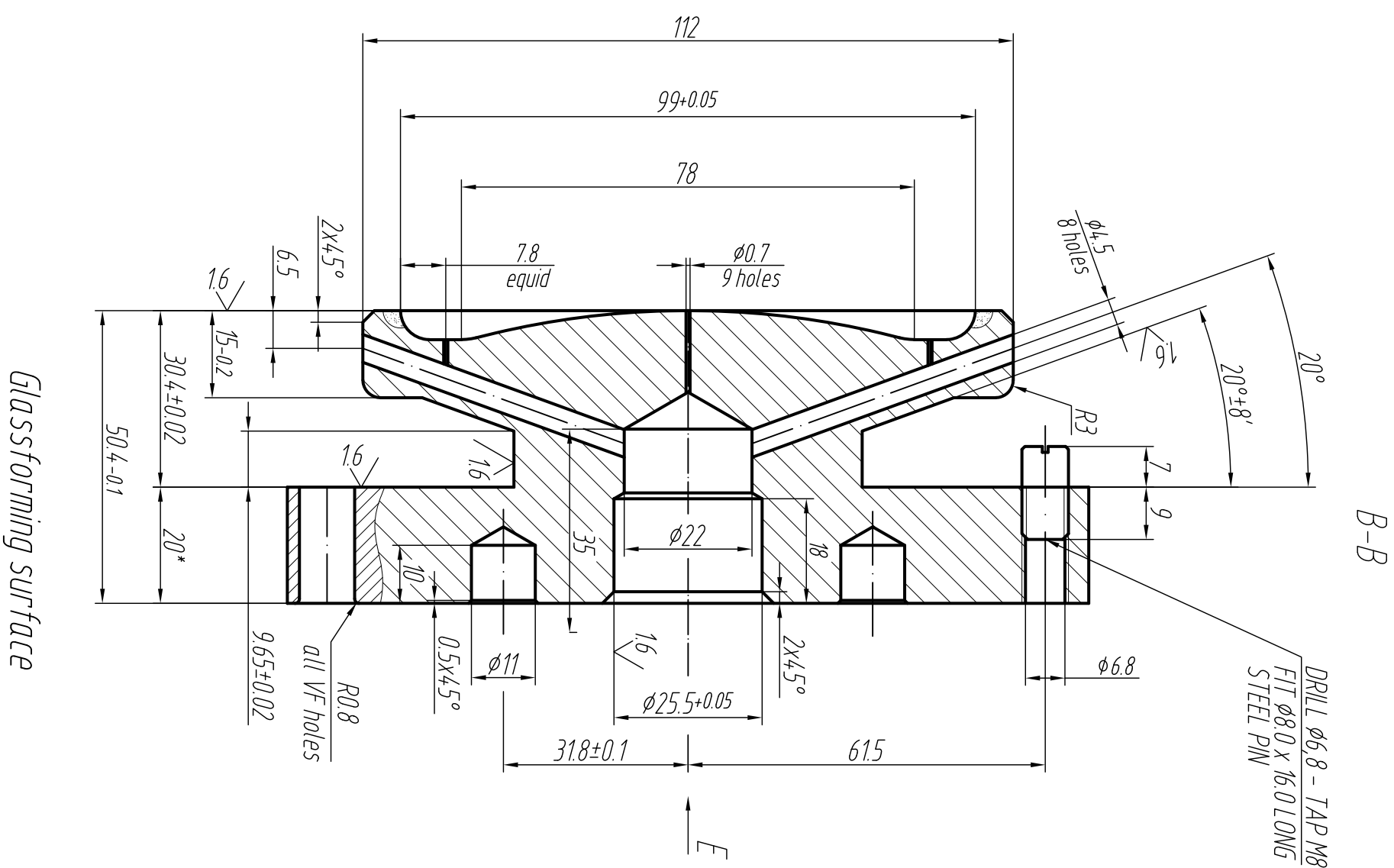
*Milling of cavity must be performed according to the 3D model*

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

\* - Reference only dimensions

			MACHINE / МАШИНА	EWHART GLASS-BB-DG 5 1/2"-8	JOB TITLE/НАЗВАНИЕ РАБОТЫ	SCALE/ МАШТАБ
			DESIGNER/ ДИЗАЙНЕР	XXI-RPM-26-2-1000-18-ExtrudNew		
24.04.20	①	DISPLACEMENT OF BLANK AND BAFFLE	DATE/ ДАТА	5217-BLK2-2		1:1
	РЕВИЗИОНС/ИЗМЕНЕНИЯ					

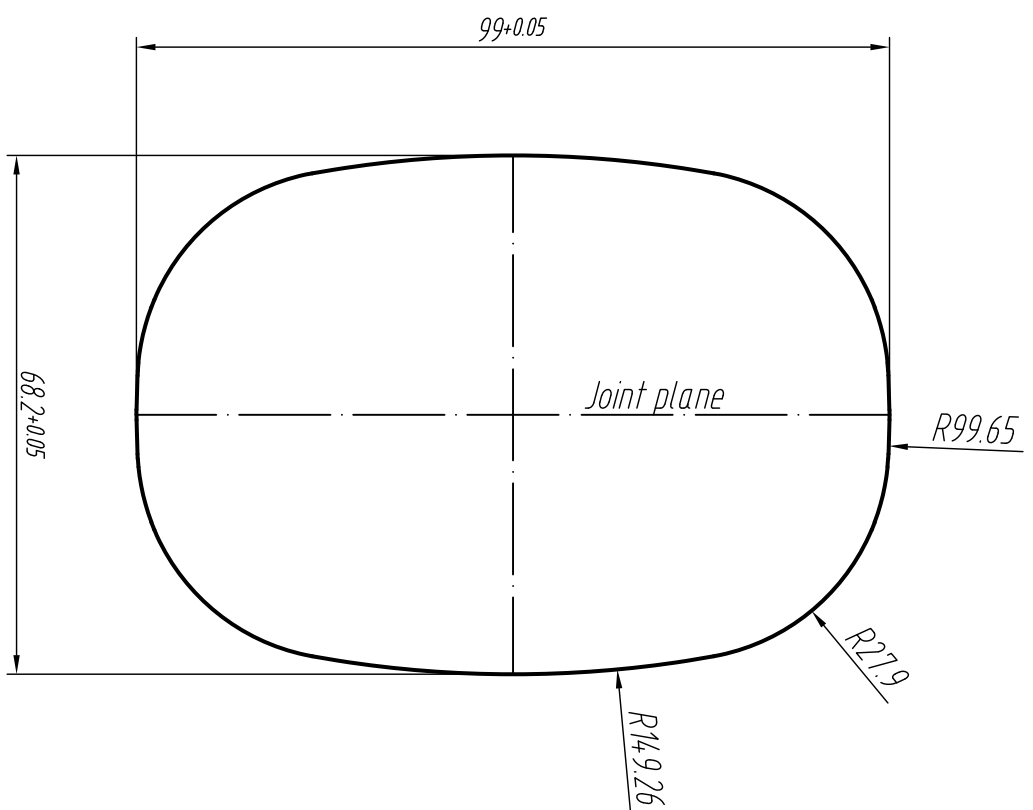
6.3 / (N)



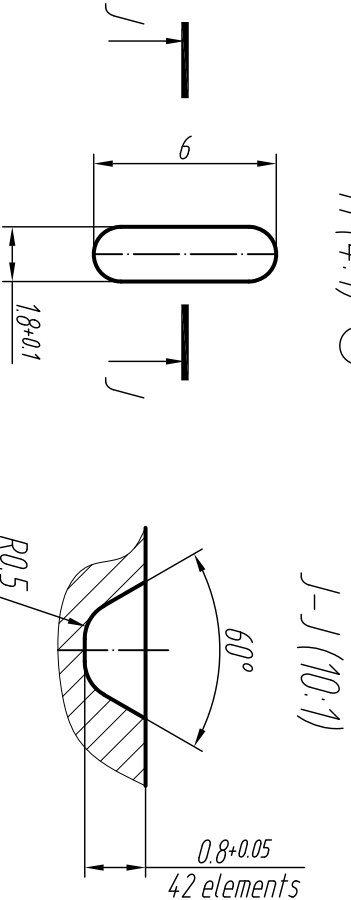
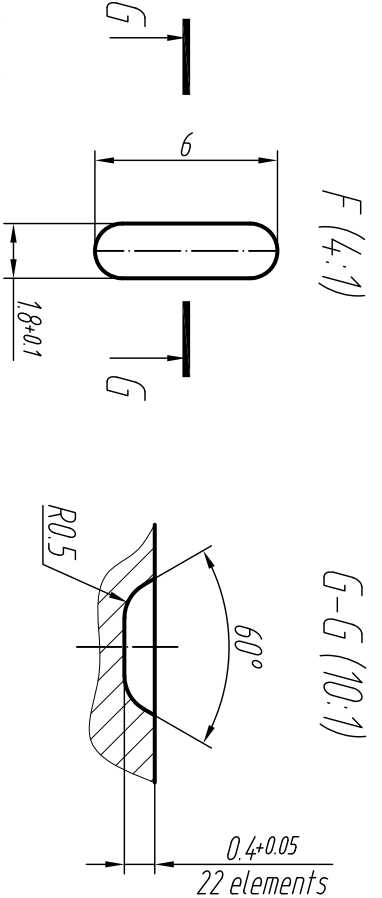
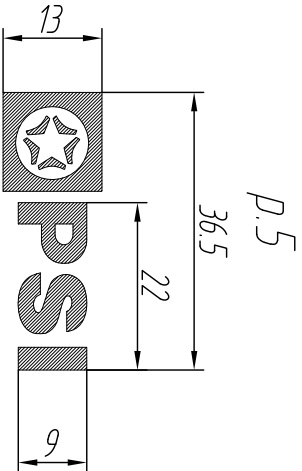
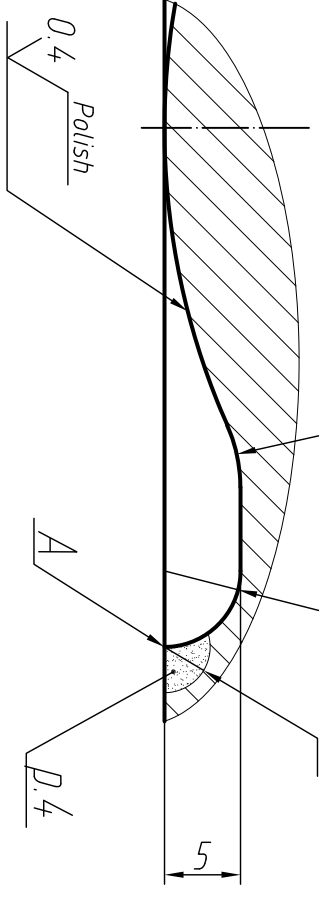
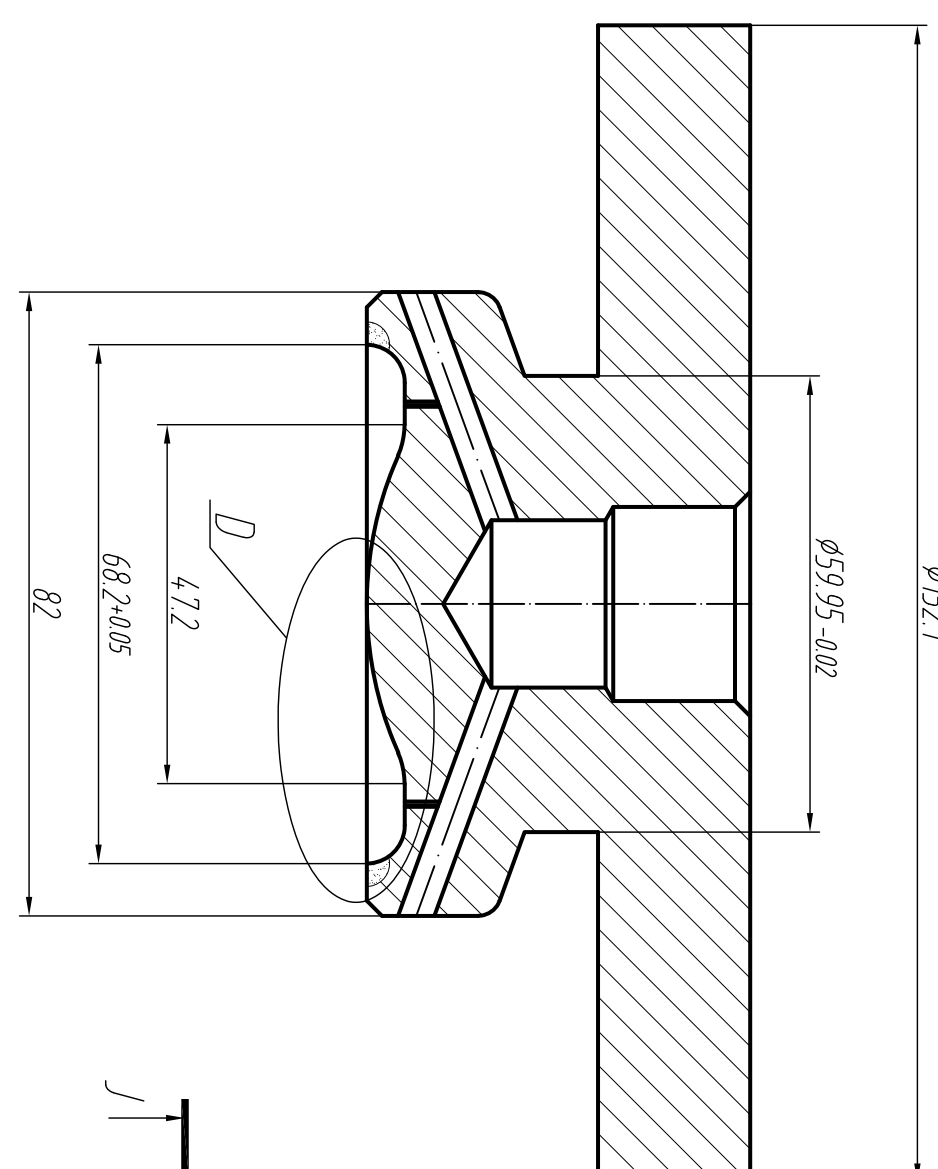
**B**

$\phi 152.1$   
 $\phi 59.95 \pm 0.02$   
82  
47.2  
 $68.2 \pm 0.05$

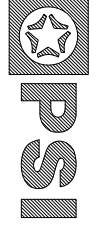
**C-C**



Glasforming surface



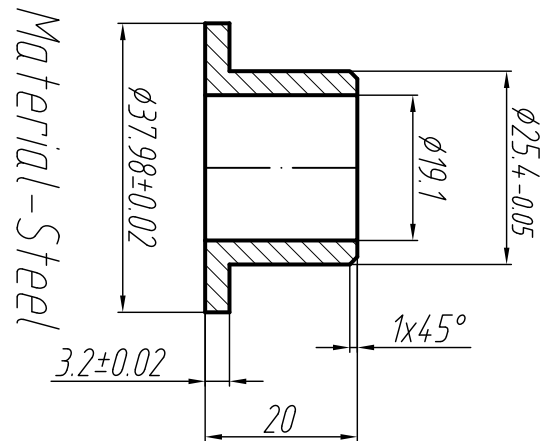
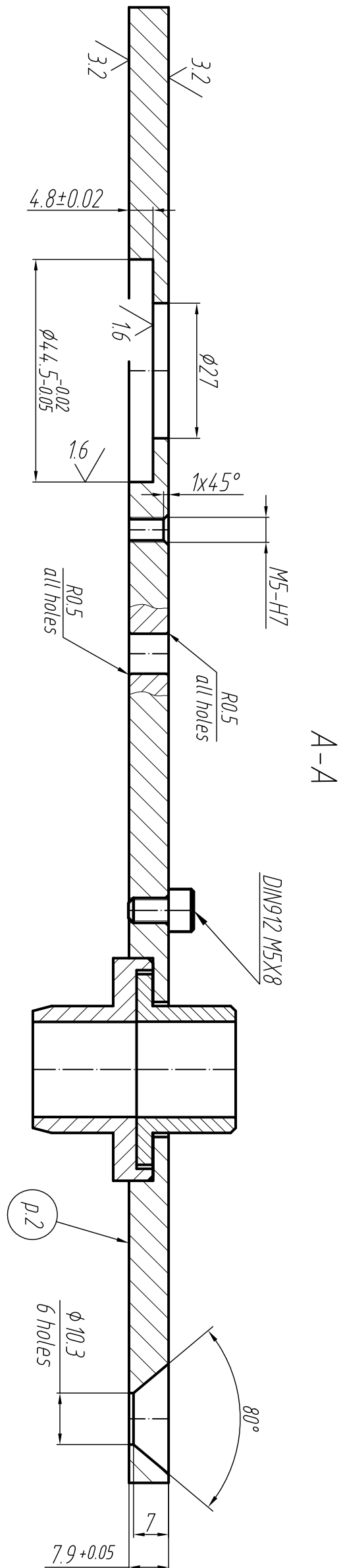
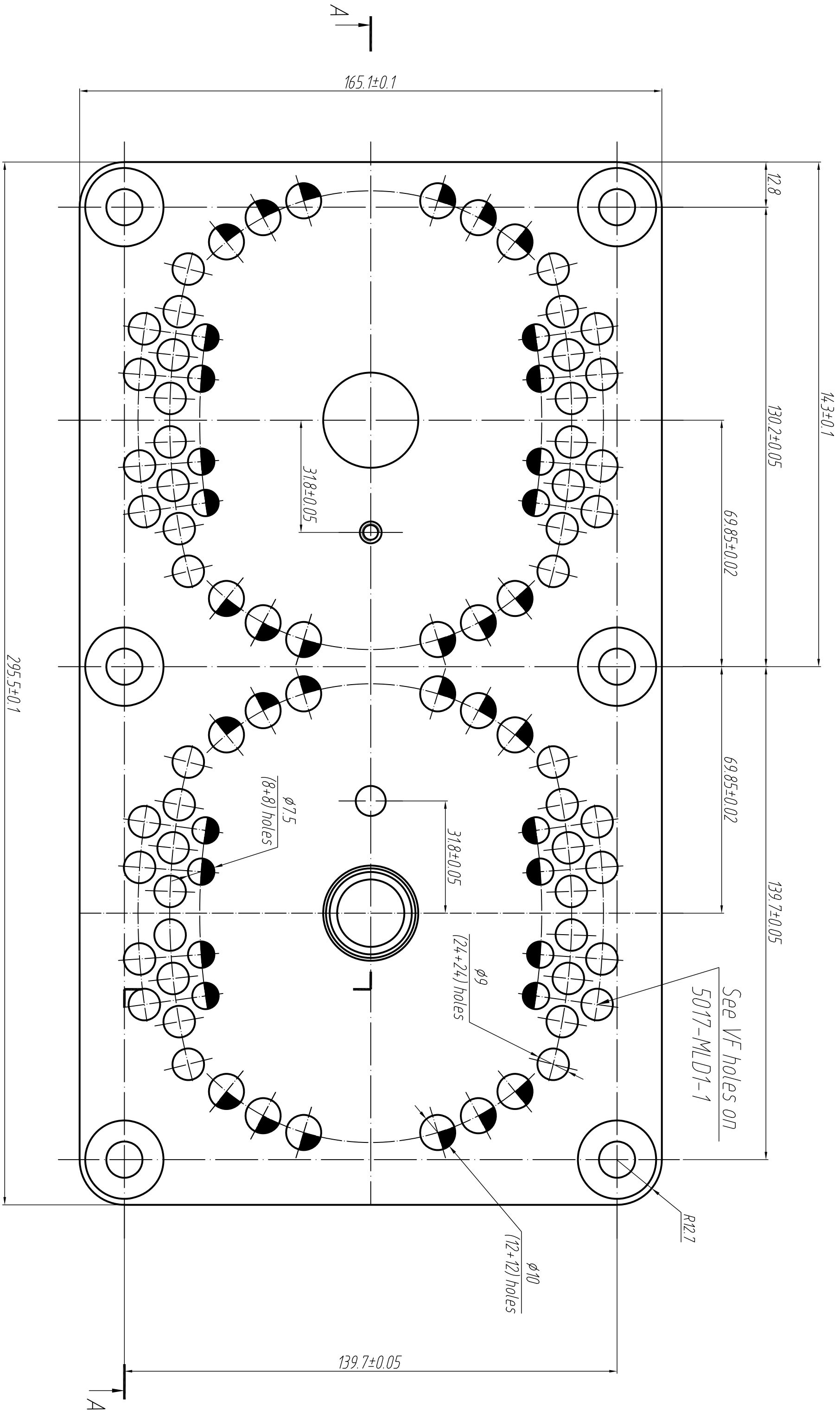
- 1 H14, h14,  $\pm IT14/2$
  2. Keep sharp edges A.
  3. \*Reference only dimensions
  4. Hardness after welding HRC35..40.
  - 5 Mark- XXI-KPM-26-2-1000-18-ExtraNew
- Mark- 5017  
Mark ordinal number (h=10) & PSI logo.  
Depth of marking-0.2...0.3 mm.



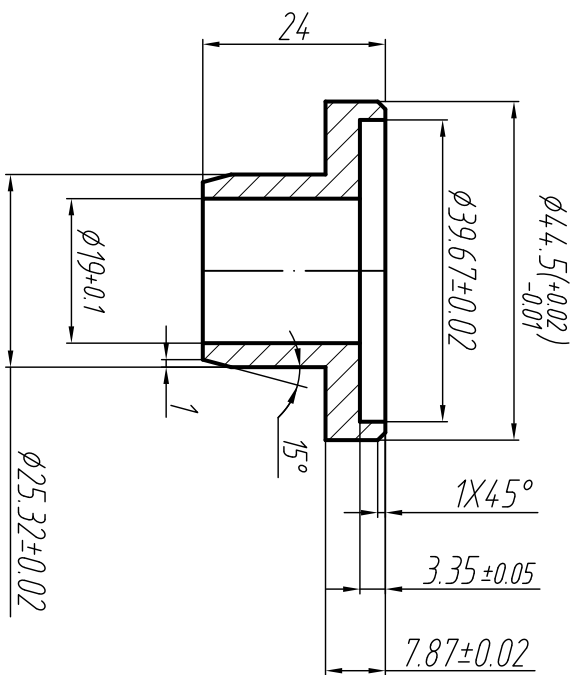
Адрес: 199034, Россия, Санкт-Петербург,  
Б-0, 14 линия, д. 7.  
Тел.: +7(812)302959  
Контакт: info@psiglass.ru

	MATERIAL/ МАТЕРИАЛ:	CAST IRON (GS900)	MACHINE/ МАШИНА:	EHHART GLASS-BB-DG 5 1/2"-8	JOB TITLE/НАЗВАНИЕ РАБОТЫ:	XXI-KPM-26-2-1000-18-ExtraNew	SCALE/ МАСШТАБ:	1:1
	WELDING/ НАН/АВКА:	MATCH (HRC3 35..40)	DESIGNER/ ДИЗАЙНЕР:		DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:	5017-BOT-1		
DATE/ДАТА	REVISIONS/ИЗМЕНЕНИЯ	QUANTITY/ КОЛИЧЕСТВО:	DATE/ ДАТА:	24.04.20				

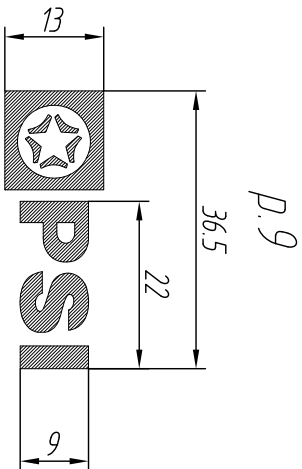
Milling of cavity must be performed according to the 3D model



Material - Steel



Material - Steel

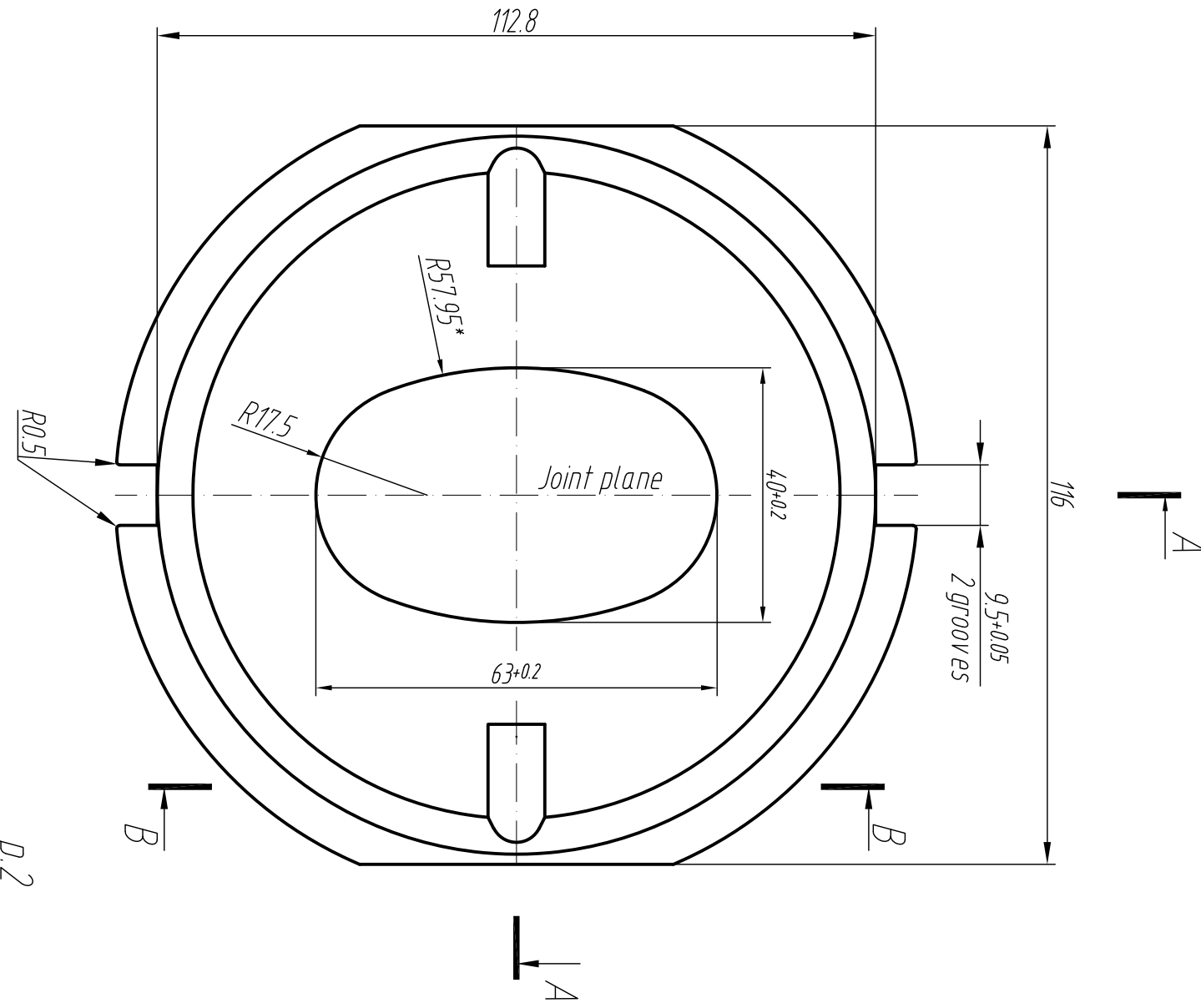
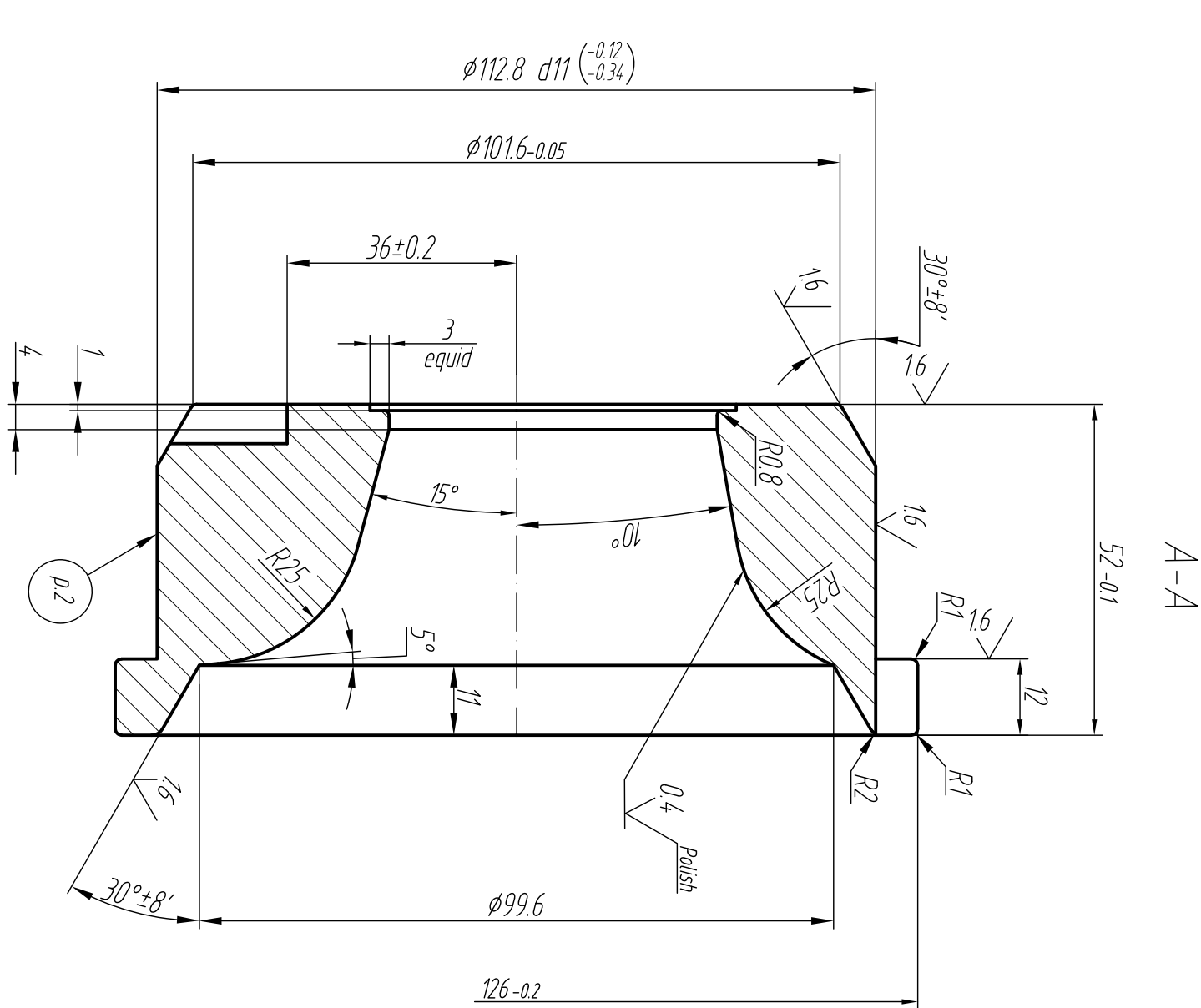


MATERIAL / МАТЕРИАЛ:	STEEL	MACHINE / МАШИНА:	EMHART GLASS-BB-DG5 1/2"-8	JOB TITLE / НАЗВАНИЕ РАБОТЫ:	XXI-KPM-26-2-1000-18-ExtraNew	SCALE / МАСШТАБ:	1:1
WELDING / СВАРКА:		DESIGNER / ДИЗАЙНЕР:		DRAWING NUMBER / НОМЕР ЧЕРТЕЖА:	СГ117_ДП1_1		
QUANTITY / КОЛИЧЕСТВО:		DATE / ДАТА:	21.01.20				

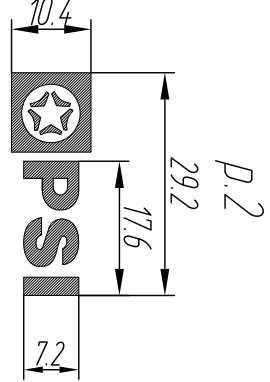
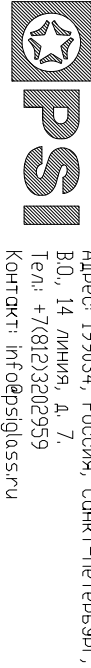
1. H14, h14, ±IT14/12.  
2. Mark: XXI-KPM-26-2-1000-18-ExtraNew  
Mark: 5017  
Mark ordinal number (h=10) & PSI logo.  
Depth of marking - 0.2-0.3mm.

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

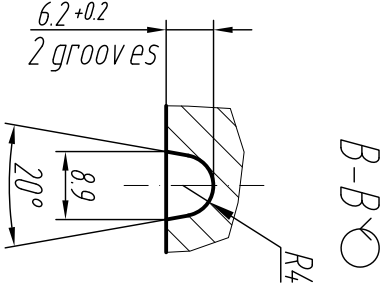
6.3 / (✓)



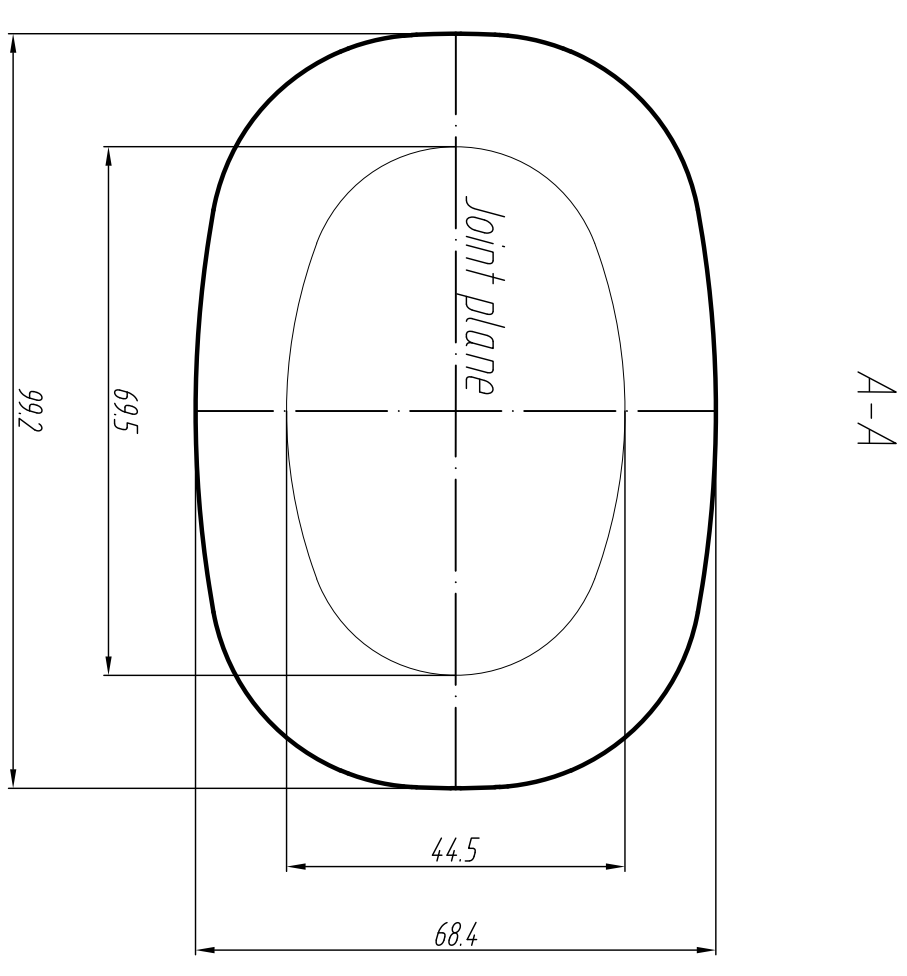
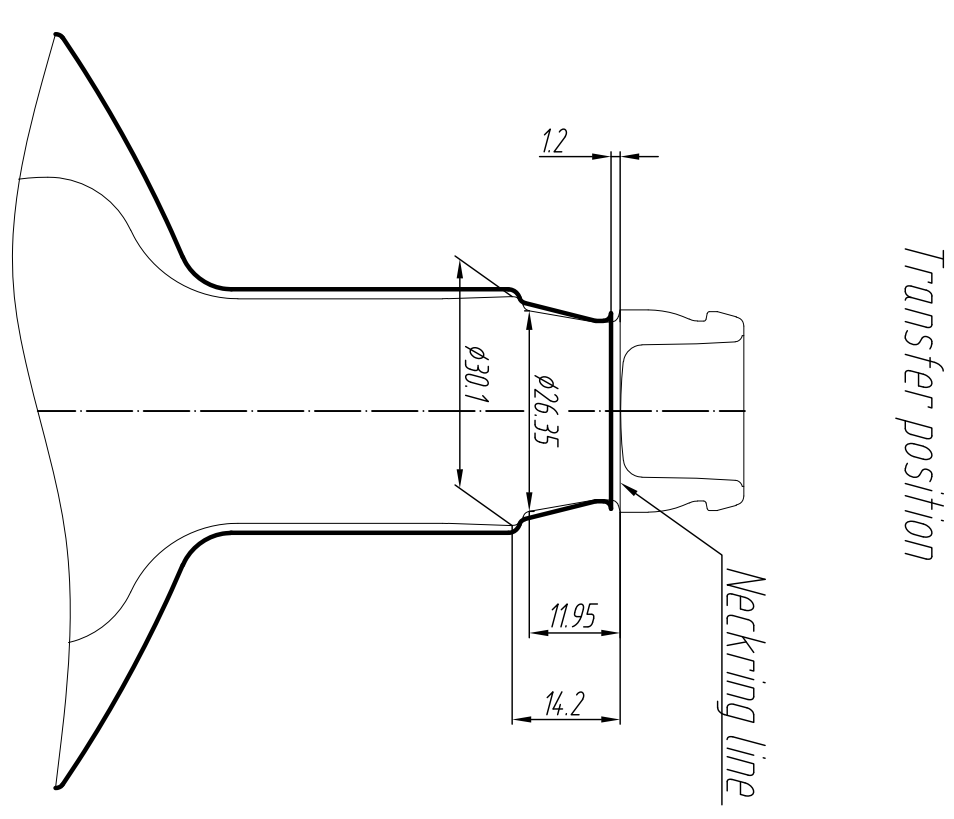
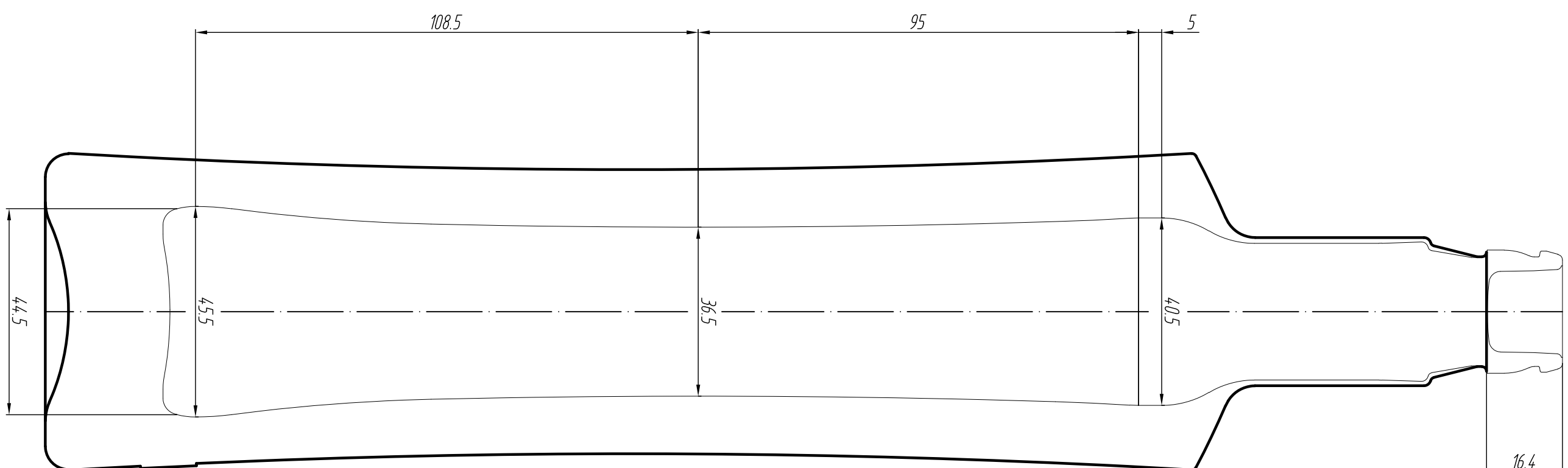
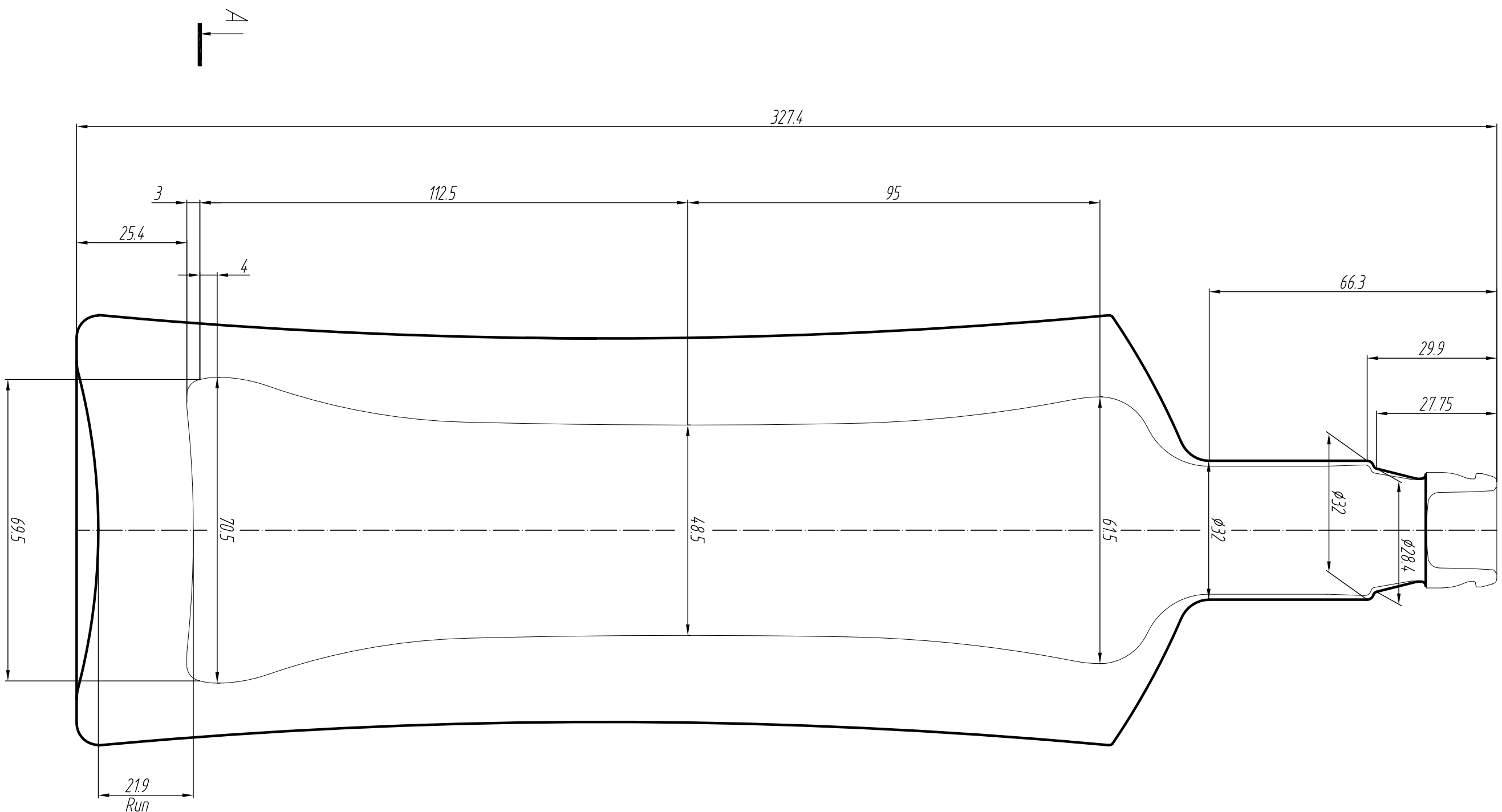
1. H14, h14, ±IT14/2.  
2. Mark: XXI-KPM-26-2-1000-18-ExtraNew  
Mark: 5017  
Mark ordinal number (h=7) & PSI logo.  
Depth of marking-0.2...0.3 mm.



	MATERIAL/ МАТЕРИАЛ:	CAST IRON (GS900)	MACHINE/ МАШИНА:	EMHART GLASS-BB-DG 5 1/2"-8	JOB TITLE/НАЗВАНИЕ РАБОТЫ:	XXI-KPM-26-2-1000-18-ExtraNew	SCALE/ МАСШТАБ:
	WELDING/ ВАЛ/ВАРКА:		DESIGNER/ ДИЗАЙНЕР:		DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:	5017-FUN-1	1:1
DATE/ДАТА	REVISIONS/ИЗМЕНЕНИЯ	QUANTITY/ КОЛИЧЕСТВО:	DATE/ ДАТА:	24.04.20			




Joint plane



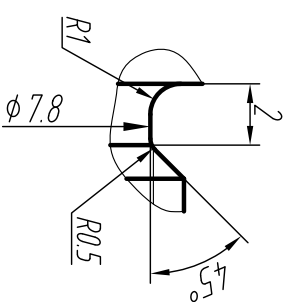
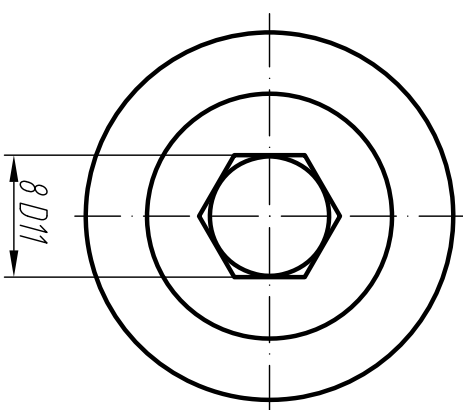
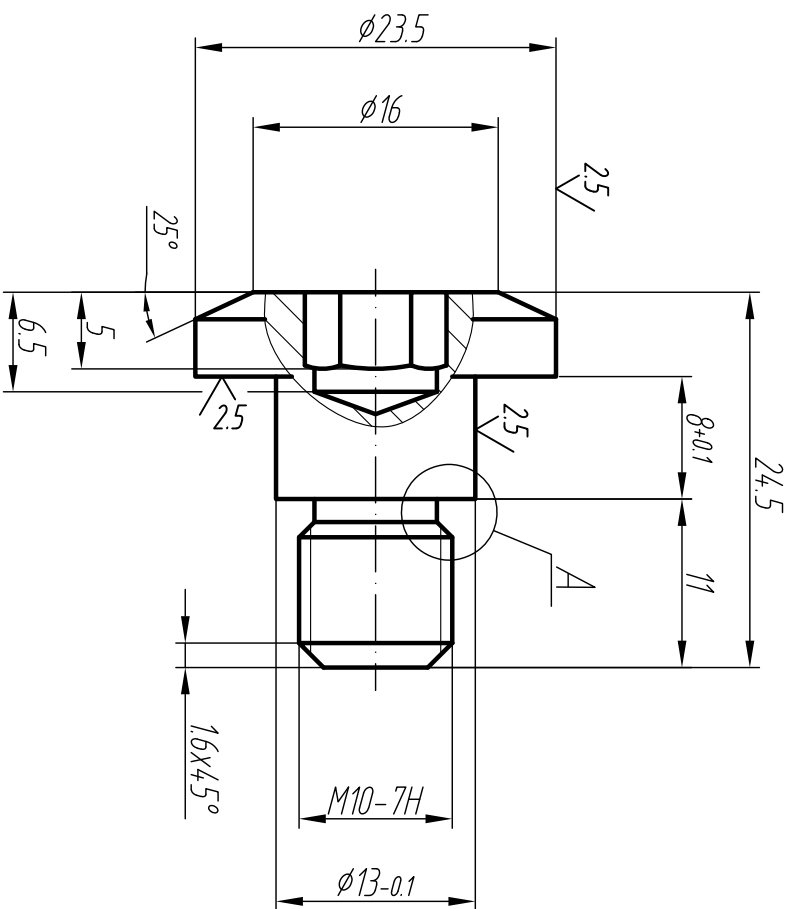
GLASS WEIGHT	285.7 (700 gr./2.45)
OVER CAPACITY	48.4 %
DISPLACEMENT OF BLANK + BAFFLE + NECK RING + PLUNGER	423.9 ml
DISPLACEMENT OF BLANK AND BAFFLE	419.3 ml

## BLANK DISPT CALCULATION

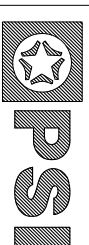
	MACHINE / МАШИНА	JOB TITLE / НАЗВАНИЕ РАБОТЫ:	SCALE / МАШШТАБ:
	DESIGNER / ДИЗАЙНЕР:	XXI-KPM-26-2-1000-18-ExtraNew	
24.04.20	①	DRAWING NUMBER / НОМЕР ЧЕРТЕЖА:	1:1
DATE / DATA	REVISIONS / ИЗМЕНЕНИЯ	DATE / DATA:	
		24.04.20	
		5017-LAY-2	

 <p>199034, Россия, Санкт-Петербург, В.О., 14 линия, д. 7 Тел: +7(812)3202959 e-mail: info@psiclass.ru</p>	<p>ДЖБ ТИТЛЕ/НАЗВАНИЕ РАСЧЕТЫ:</p> <p>XVI-KPM-26-2-1000-18-ExtraNew</p> <p>SCALE/ MAGNITAB:</p>
<p>DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:</p> <p>5017-LAY-2</p>	<p>1:1</p>

6.3 / (✓)



1. H12, h12, ±IT12/2.



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

DATE / DATA	REVISIONS / ИЗМЕНЕНИЯ

MATERIAL / МАТЕРИАЛ:	STEEL
WELDING / СВАРКА:	
QUANTITY / КОЛИЧЕСТВО:	

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

JOB TITLE / НАЗВАНИЕ РАБОТЫ:

XXI-KPM-26-2-1000-18-ExtraNew

DRAWING NUMBER / НОМЕР ЧЕРТЕЖА:

5017-LUG-1

SCALE / МАСШТАБ:

2:1

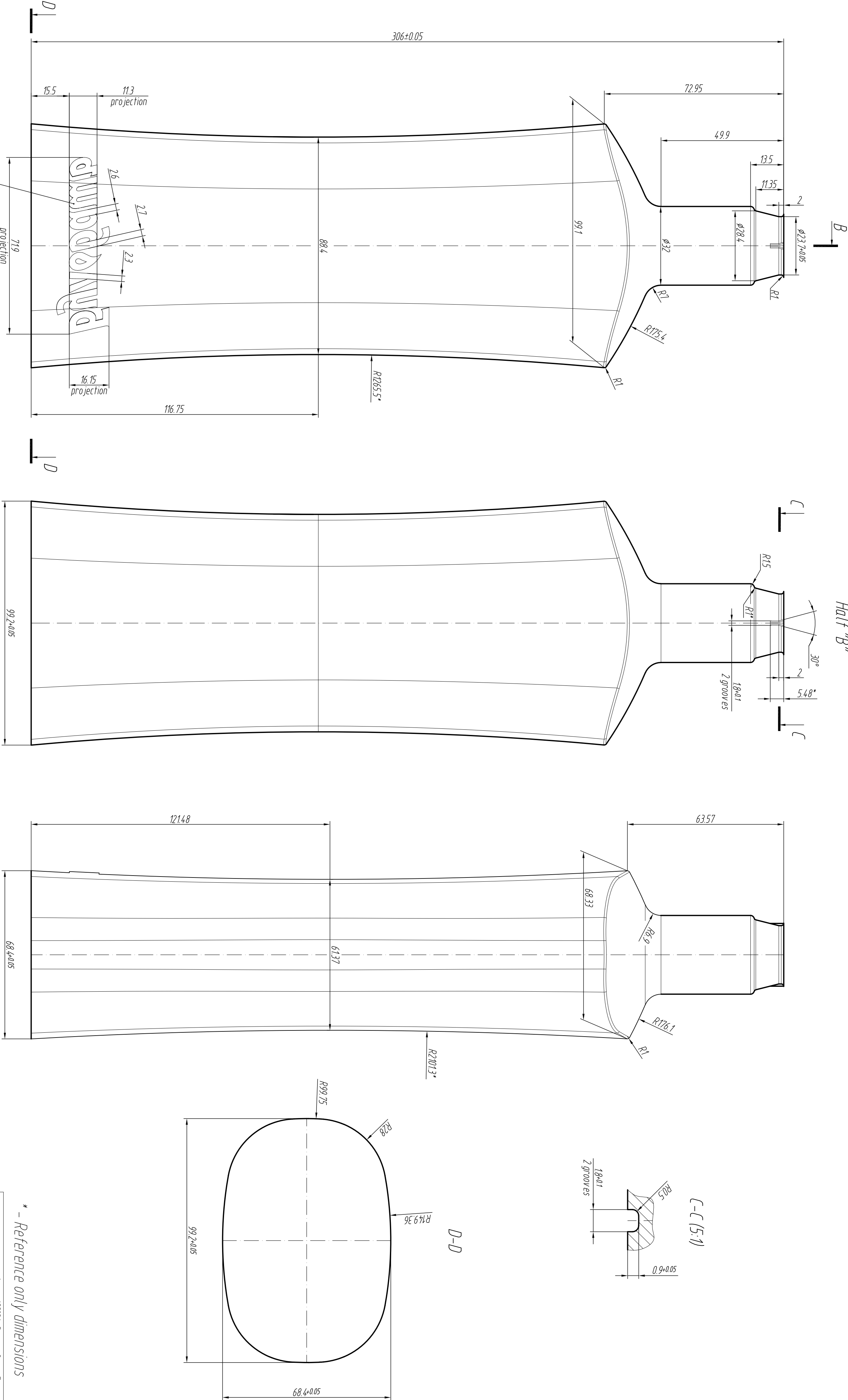




Half "A"


Glassforming surface

Half "B"

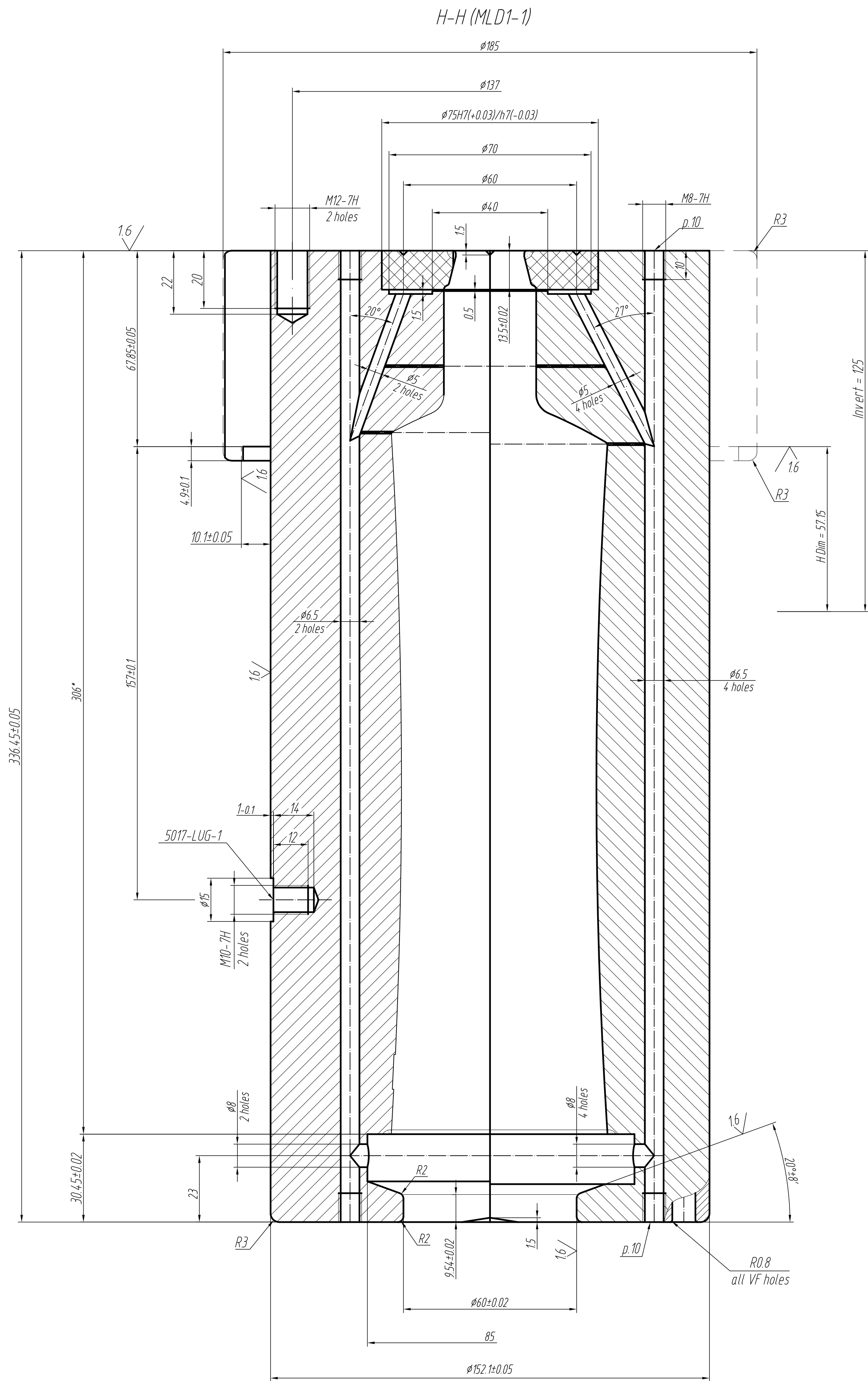


\* - Reference only dimensions

		MACHINE/ МАШИНА:	ЕМАРТ GLASS-BB-DG 5 1/2"-8	JOB TITLE/НАЗВАНИЕ РАБОТЫ:	XXI-KPM-26-2-1000-18-ExtraNew	SCALE/ МАШТАБ:	1:1
		DESIGNER/ ДИЗАЙНЕР:					
DATE/ДАТА	24.04.20			REVISIONS/ИЗМЕНЕНИЯ	①		
		DATE/ ДАТА:	24.04.20				



Адрес: 199034, Россия, Санкт-Петербург,  
БД, 14 линия, д. 7  
Тел: +7(812)3202959  
Контакты: info@psi-glass.ru



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.

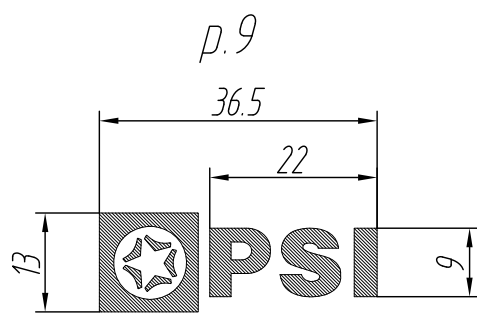
6. \*Reference only dimensions

7. H14, h14, ±IT14/2.
8. Hardness after welding HRC35..40.

9. Mark: XXI-KPM-26-2-1000-18-ExtraNew  
Mark: 5017  
Mark ordinal number (h=8) & PSI logo.  
Depth of marking-0.2...0.3 mm.

10. Cap holes with screws M8x8 and punch.

11. Cap holes with screws M6x8 and punch.



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

24.04.20	①	ASSEMBLY NUMBER/ НОМЕР СБОРКИ:	53	MATERIAL/ МАТЕРИАЛ:	CAST IRON (GS900)	MACHINE/ МАШИНА:	EMHART GLASS-BB-DG 5 1/2"-8	JOB TITLE/НАЗВАНИЕ РАБОТЫ:	XXI-KPM-26-2-1000-18-ExtraNew	SCALE/ МАСШТАБ:  1:1
		INVERT CENTRE/ ИНВЕРТ:	125	WELDING/ НАПЛАВКА:	Base and seams (HRC 35..40)	DESIGNER/ ДИЗАЙНЕР:		DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:	5017-MLD3-2	
		'H' DIMENSION/ РАЗМЕР 'H': (РАССТОЯНИЕ ОТ ОСИ ФОРМЫ ДО ВЕРХНЕЙ ГРУБЫ)	57.15	QUANTITY/ КОЛИЧЕСТВО:		DATE/ ДАТА:	24.04.20			