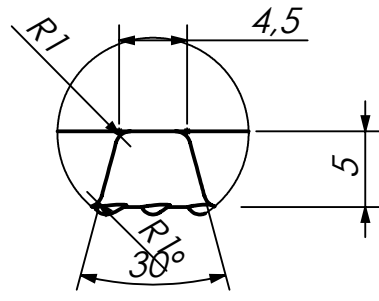
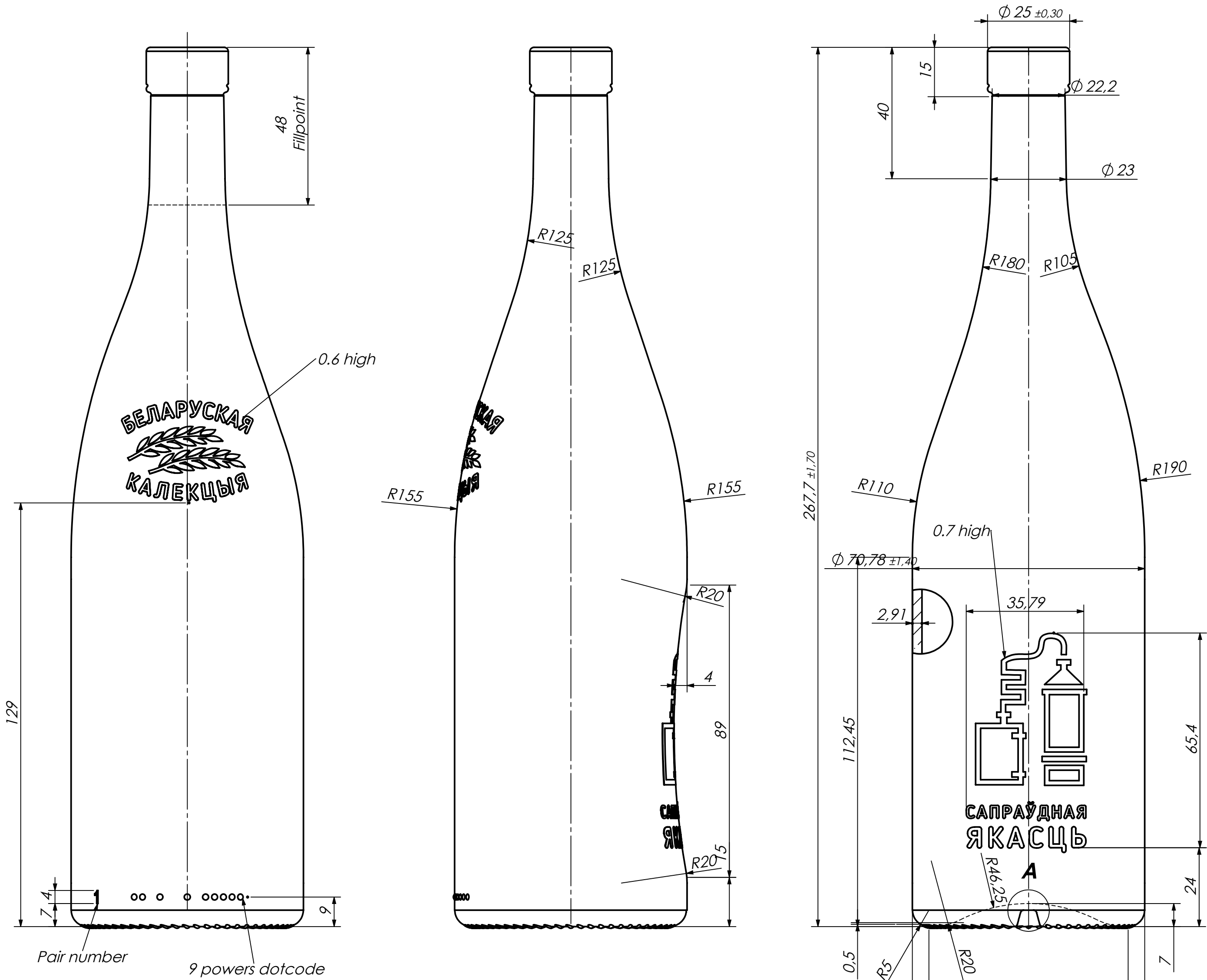
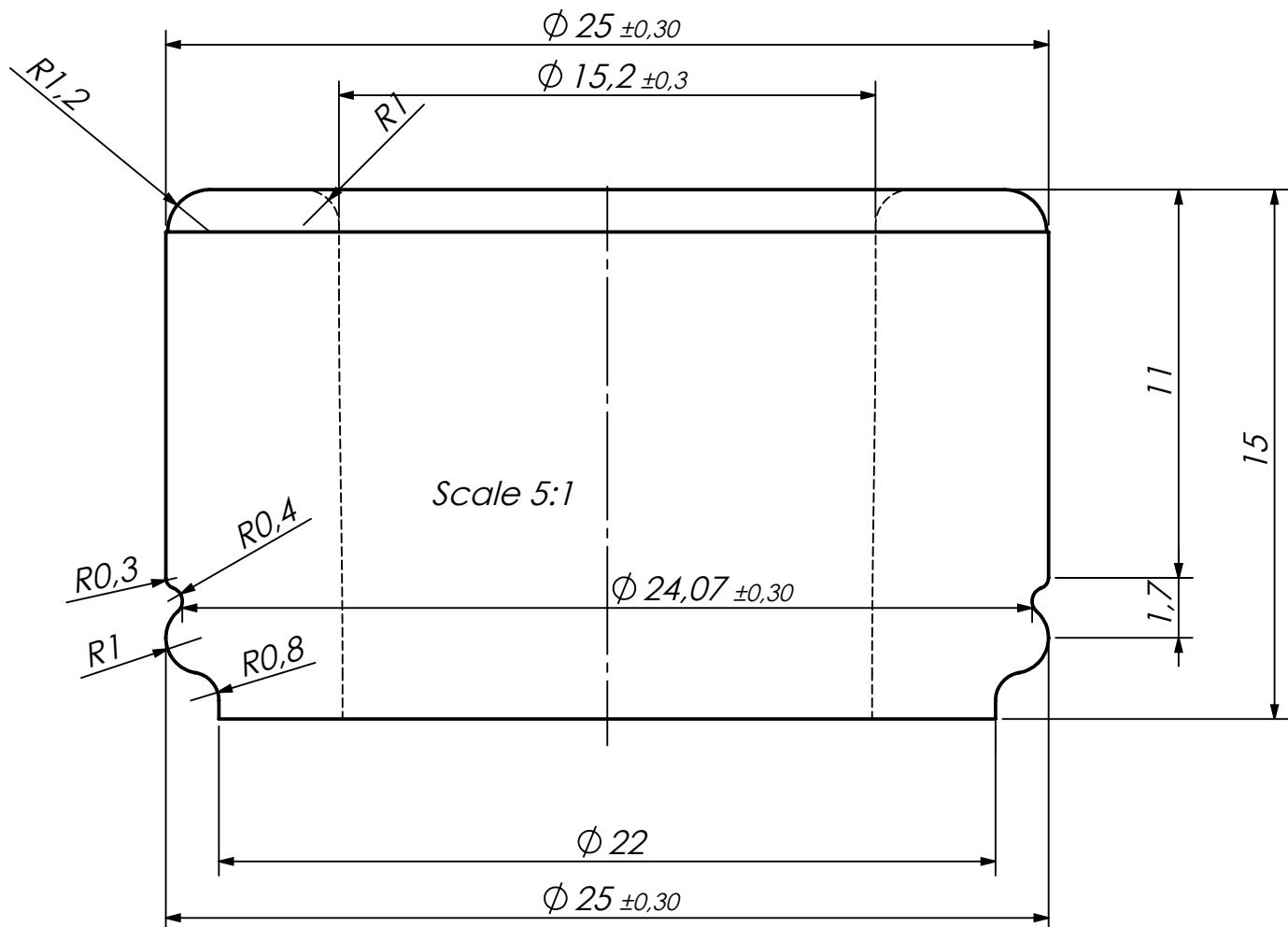
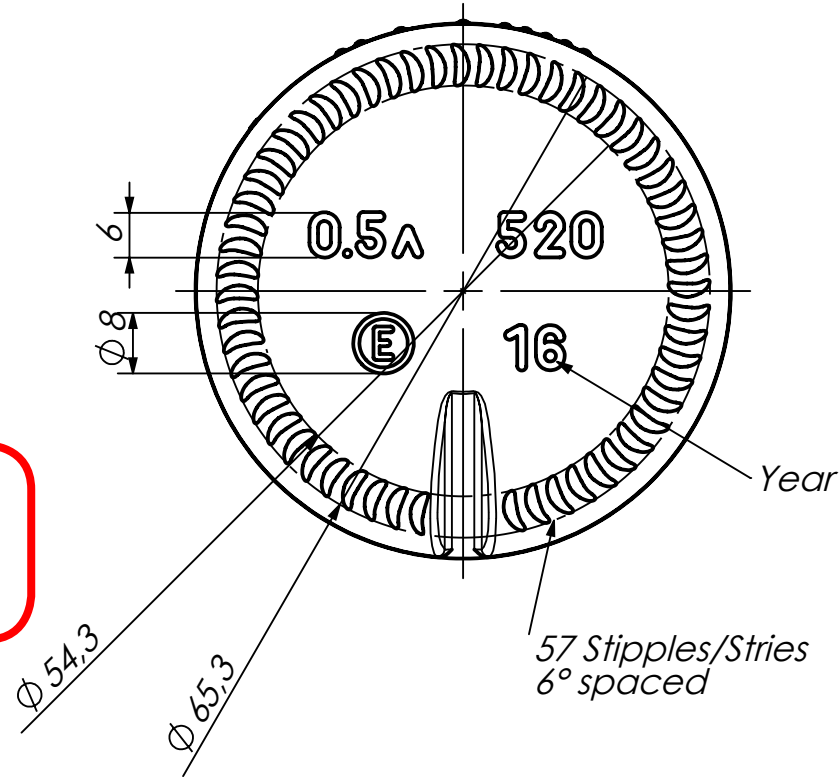


REVISIONS		
REV.	DESCRIPTION	DATE
A	article modified	8-4-2016



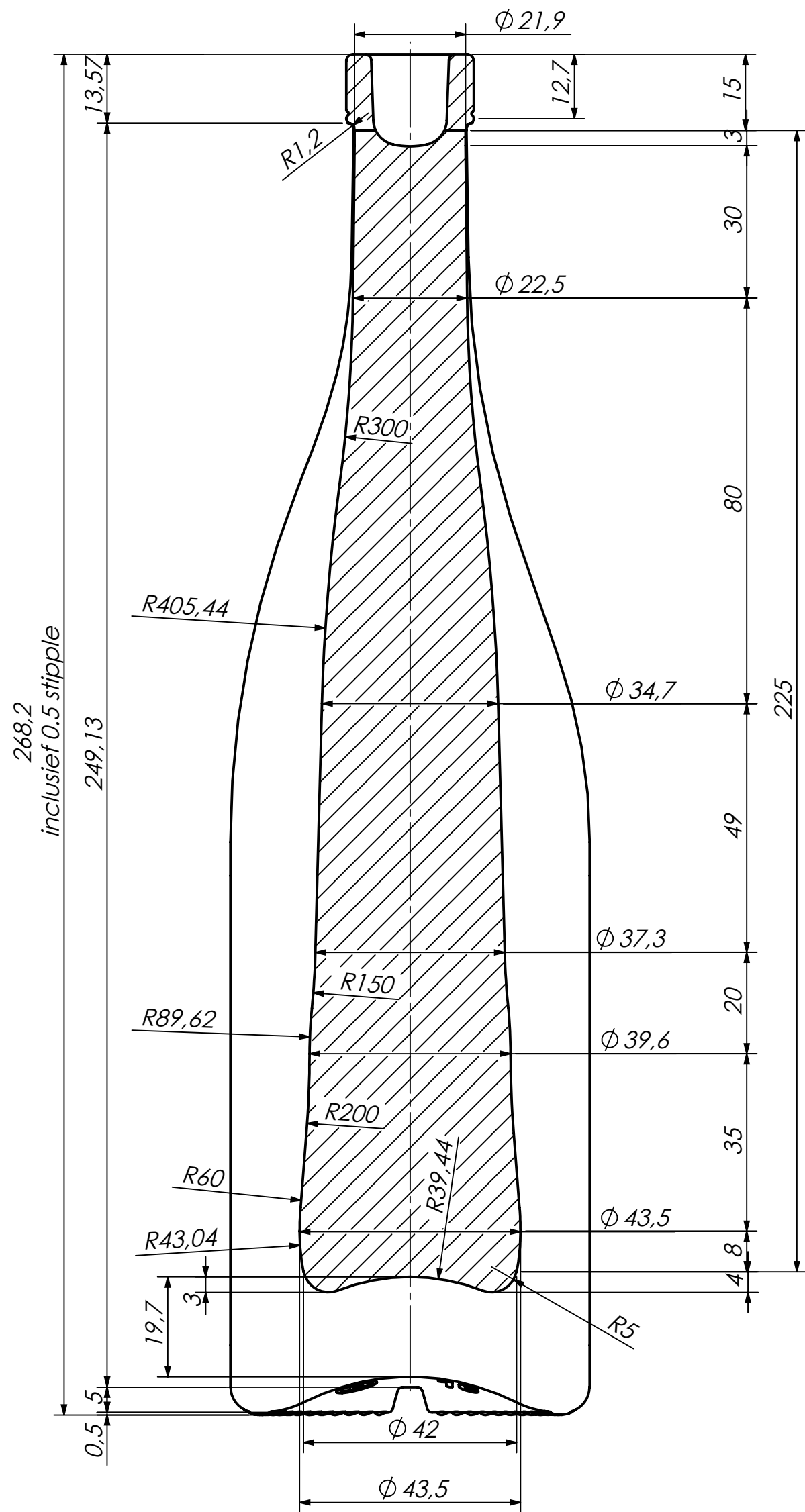
A (2 : 1)



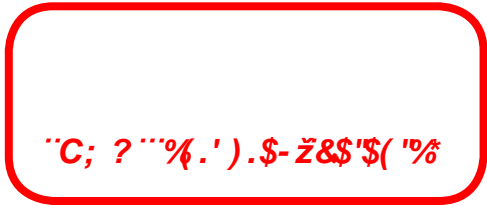
"C; ? ""%.' & %&S\$\$('%

500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ	
AS ALATI STUHNÉ Ltd -1986- TOOLS FOR MANUFACTURE OF CONTAINER GLASS AND MACHINE PARTS	
WEIGHT: 350gr ± 8	CUSTOMER: ELIVOZO
CAP. BRIMFULL: 520ml $\pm 10/-5$	COLOUR: Flint
CAP. FILLPOINT: 500ml	FINISH: P-25
WALL THICK: 3.1	JOB: AS384-01-01 A
DES D BY: JBB	DATE: 18-4-2016

REVISIONS		
REV.	DESCRIPTION	DATE
A	bottle modified/blk cavity modified	8-4-2016



CONTAINER SPECIFICATION DATA					
CAPACITY		GLASS DETAIL		NECK FINISH DETAIL	
BRIM FULL	520	WEIGHT	350,00	TYPE	P-25
FILL POINT	500	COLOUR	Amber	SPEC.	Gost
DESIGN DATA					
CONTAINER OVERALL HEIGHT		267	CHAMFER SEAT IN MOULD TOP		1,2
HEIGHT SHRINKAGE FACTOR GLASS		1,0045	MOULD NECK DIAMETER		22,2
HEIGHT CONTRACTION ALLOWANCE		1,20	BLANK NECK DIAMETER		21,9
O/HT. OF GLASS IN EQUIPMENT		268,20	RING NECK DIAMETER		22
FINISH HEIGHT		12,7	SEATED FINISH HEIGHT		13,57
MOULD EQUIPMENT DATA			EMHART 5 1/2 IS BB DG		
INVERT		90	BLANK HOLDER/ASS No.		23
MOULD HOLDER/ASS No		53	BLANK H-DIM		117,5
MOULD H-DIM		57,15	NECKRING DOVETAIL DIAMETER		89
BOTTOMPLATE DOVETAIL DIAMETER		92	BAFFLE FUNNEL DIAMETER		65,2
BLOWHEAD No.		1	TAKE OUT TONGUE No		1
VOLUME CALCULATIONS					
BLOWMOULD VOLUME CALCULATIONS					
GLASS VOLUME=GLASSWEIGHT /		2,48 DENSITY COLD GLAS			141,129
VOLUME COMPLETE COLD CONTAINER = GLASSVOLUME+BRIMFULL					661,129
VOL HOT CONTAINER= VOLUME COLD CONTAINER x			1,015 SINKAGE&SHRINKAGE		670,745
VOLUME MOULD+BOTTOM= VOLUME HOT CONTAINER -			6,595 SEATED FINISH		664,150
VOLUME BLOWMOULD CAVITY					653,058
VOLUME BOTTOM CAVITY					11,092
TOLERANCE ON TOTAL DISPLACEMENT					+/- 1
BLOW BLOW BLANKMOULD VOLUME CALCULATION					
		HOT GLASS DENSITY	x OVERCAPACITY %		
PARISON VOLUME = GLASSWEIGHT/		2,45	43,325		204,750
VOL. BLANK+BAFFLE =		VOL. PARISON -		4,319 NECKRING-PLG VOLUME	200,431
VOLUME BLANK CAVITY					190,024
VOLUME BAFFLE CAVITY					10,407
TOLERANCE ON TOTAL DISPLACEMENT					+/- 1,5



LAYOUT

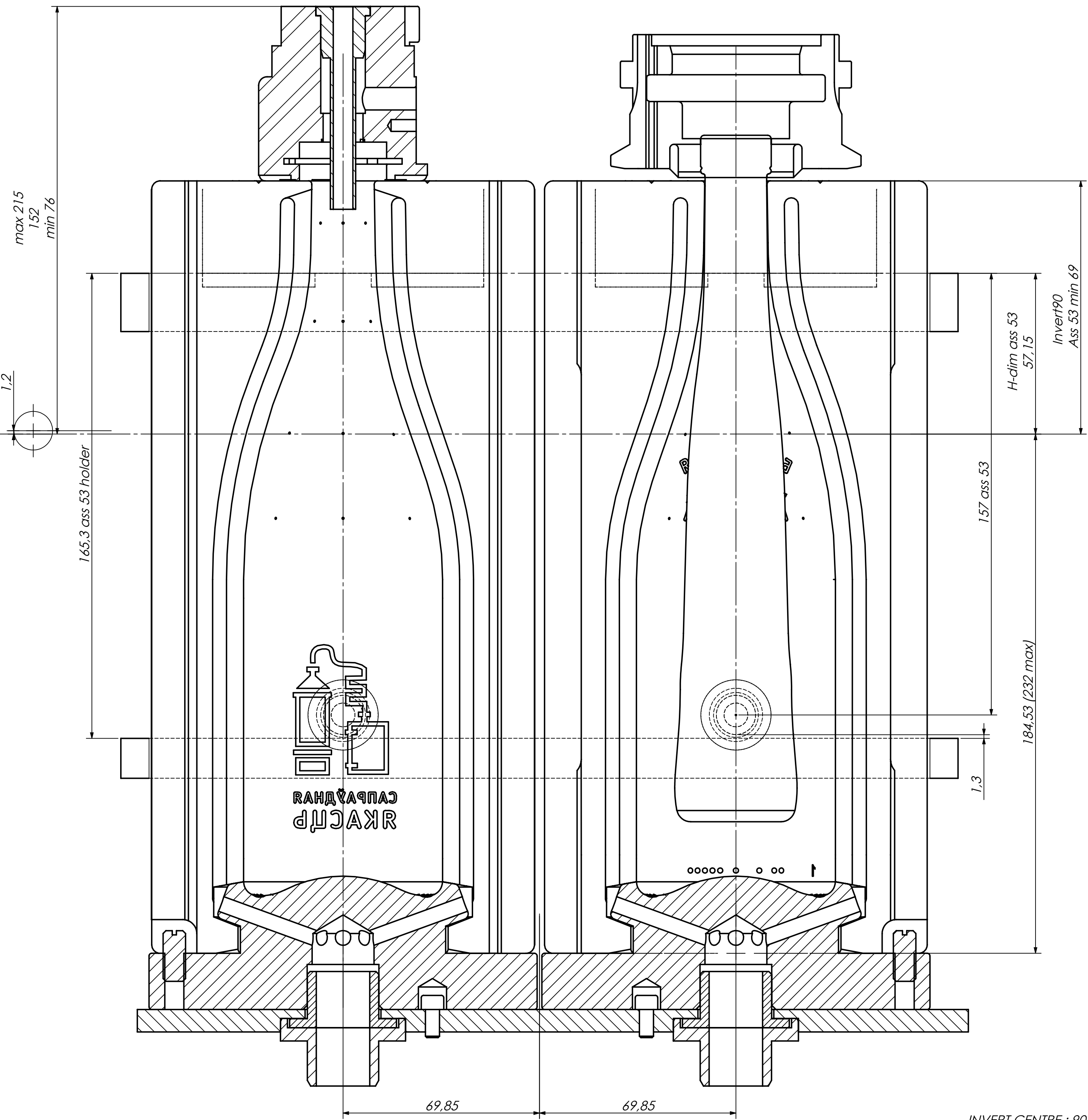
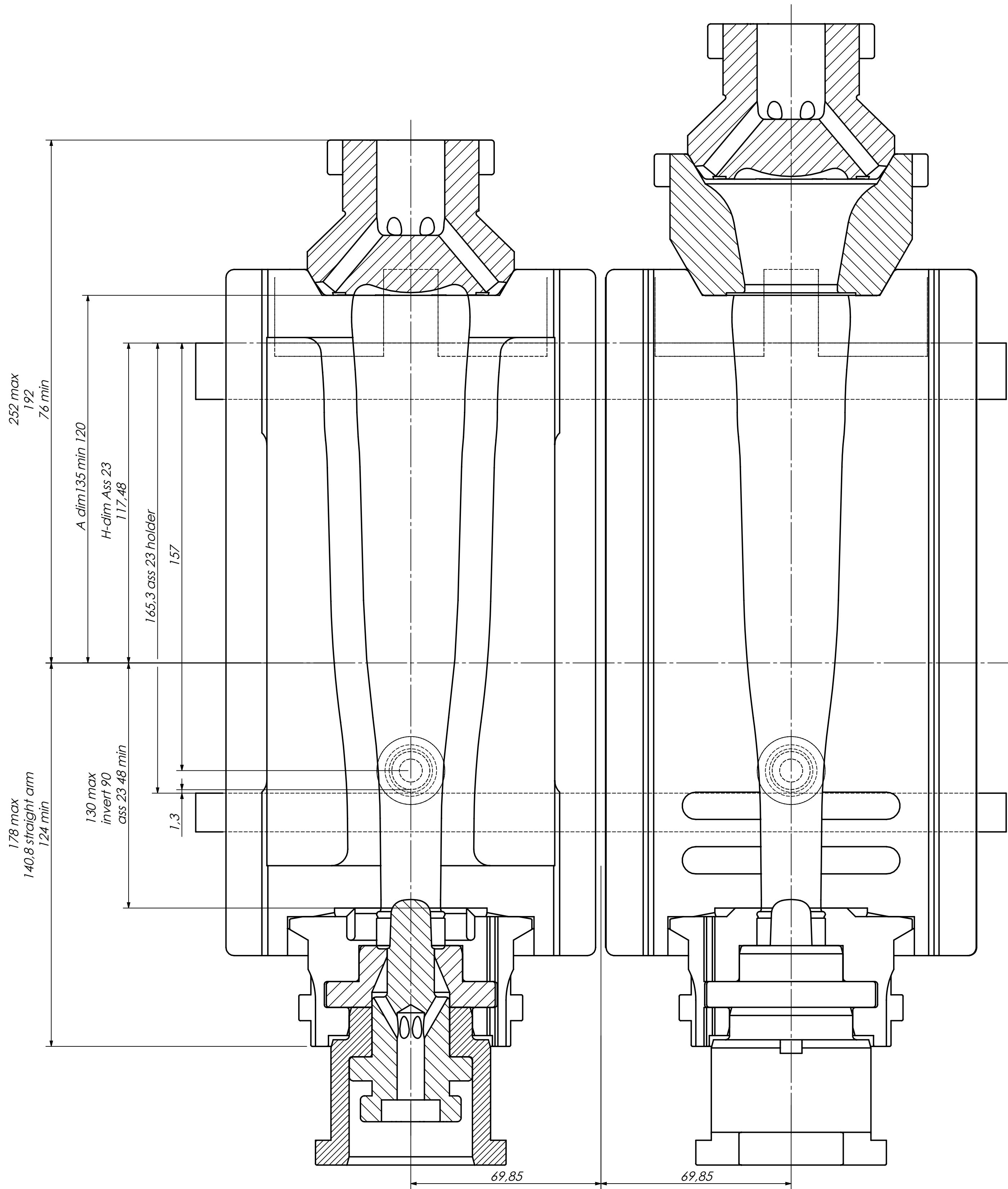
 **ALATI STUJNE Ltd**
TOOLS FOR MANUFACTURE OF CONTAINER GLASS AND MACHINE PARTS

DES D BY: JBB CUSTOMER: ELIVOZO

DATE: 18-4-2016 SUBJECT: 500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ

JOB: AS384-02-01 A

REVISIONS		
REV.	DESCRIPTION	DATE
A	drawn to scale after modifications.	8-4-2016

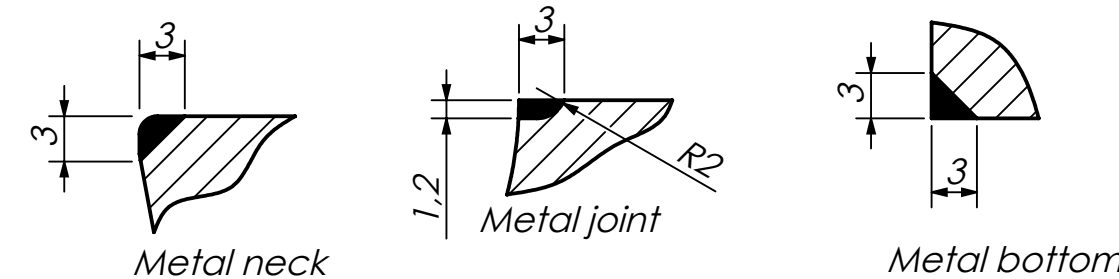
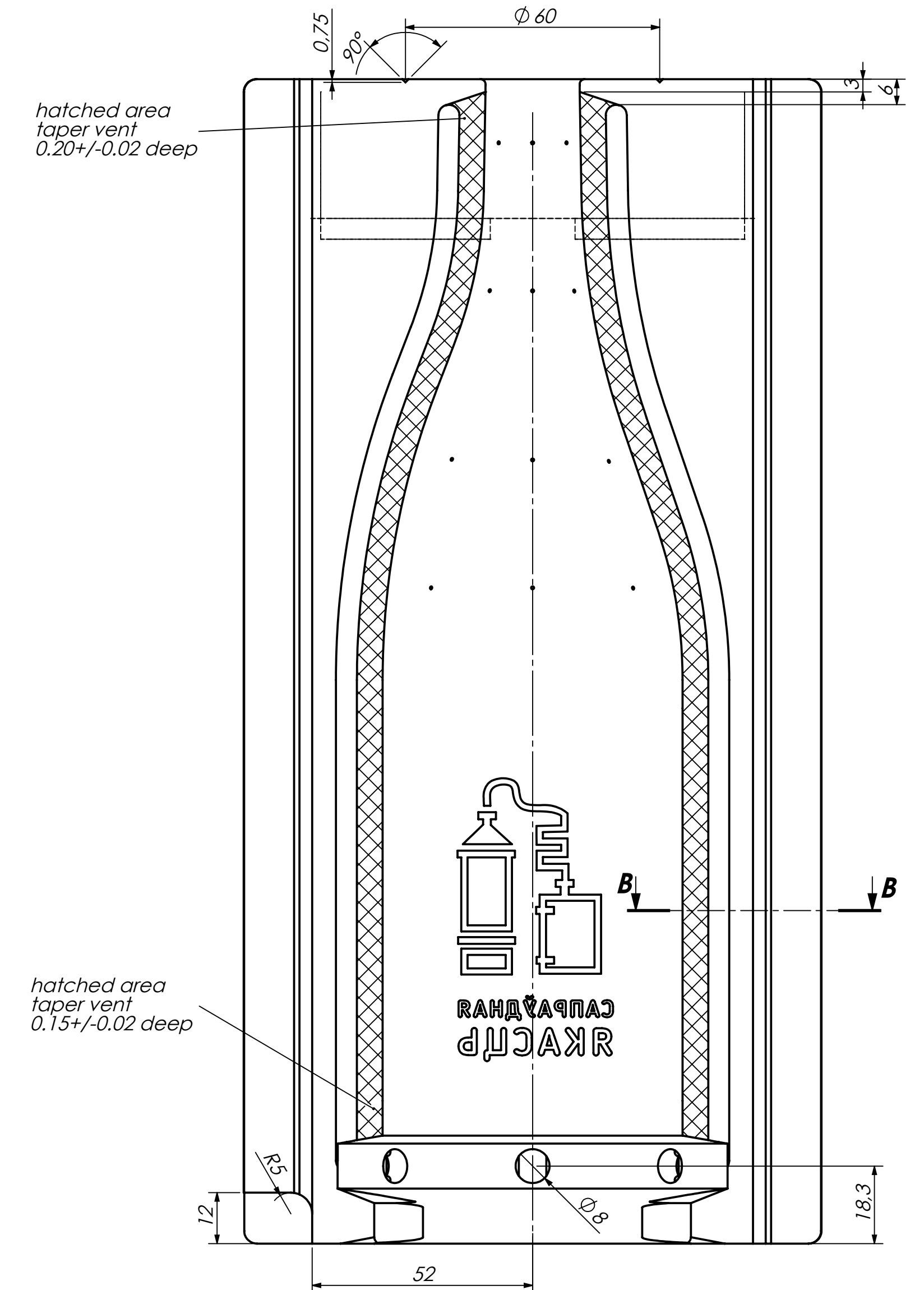
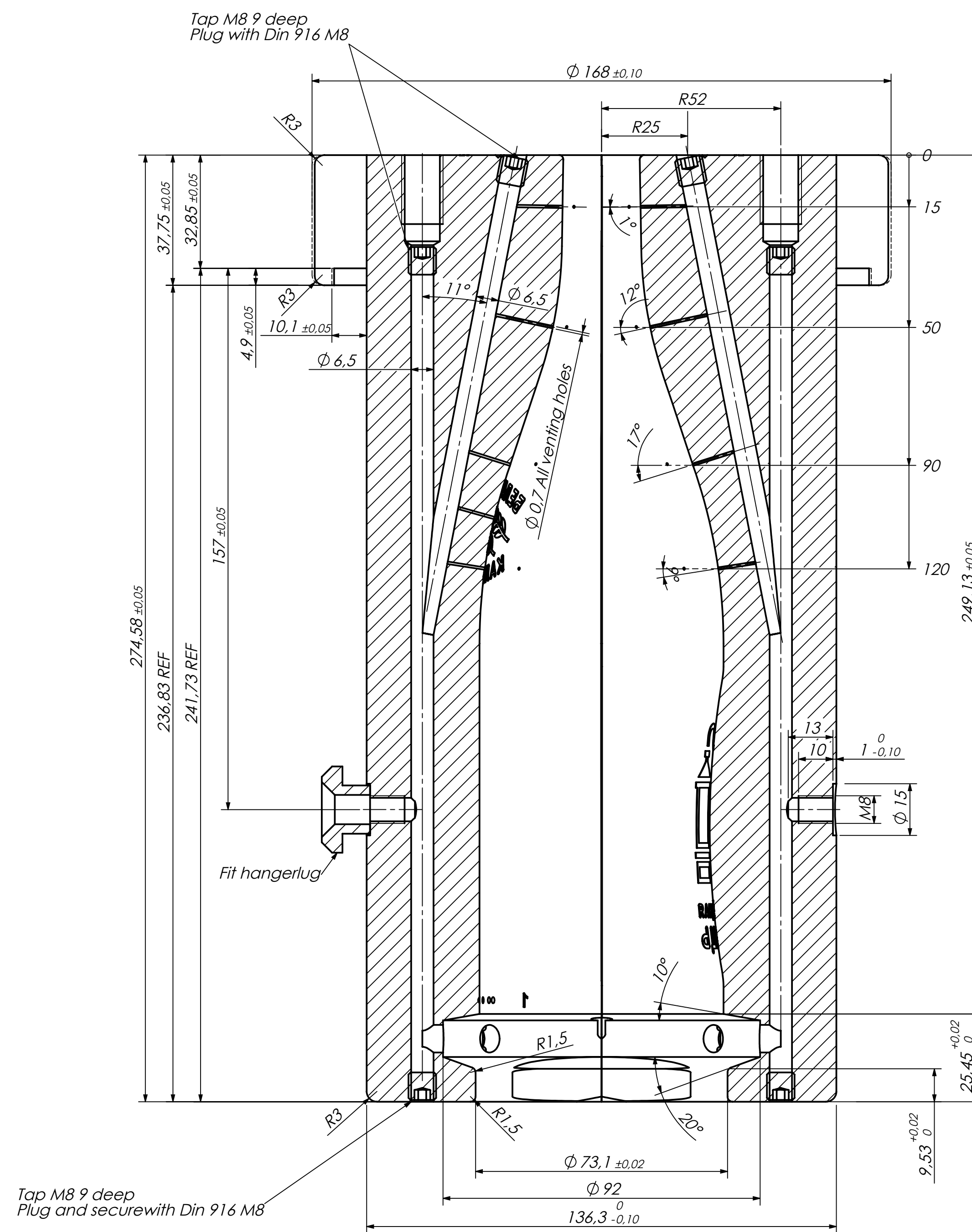
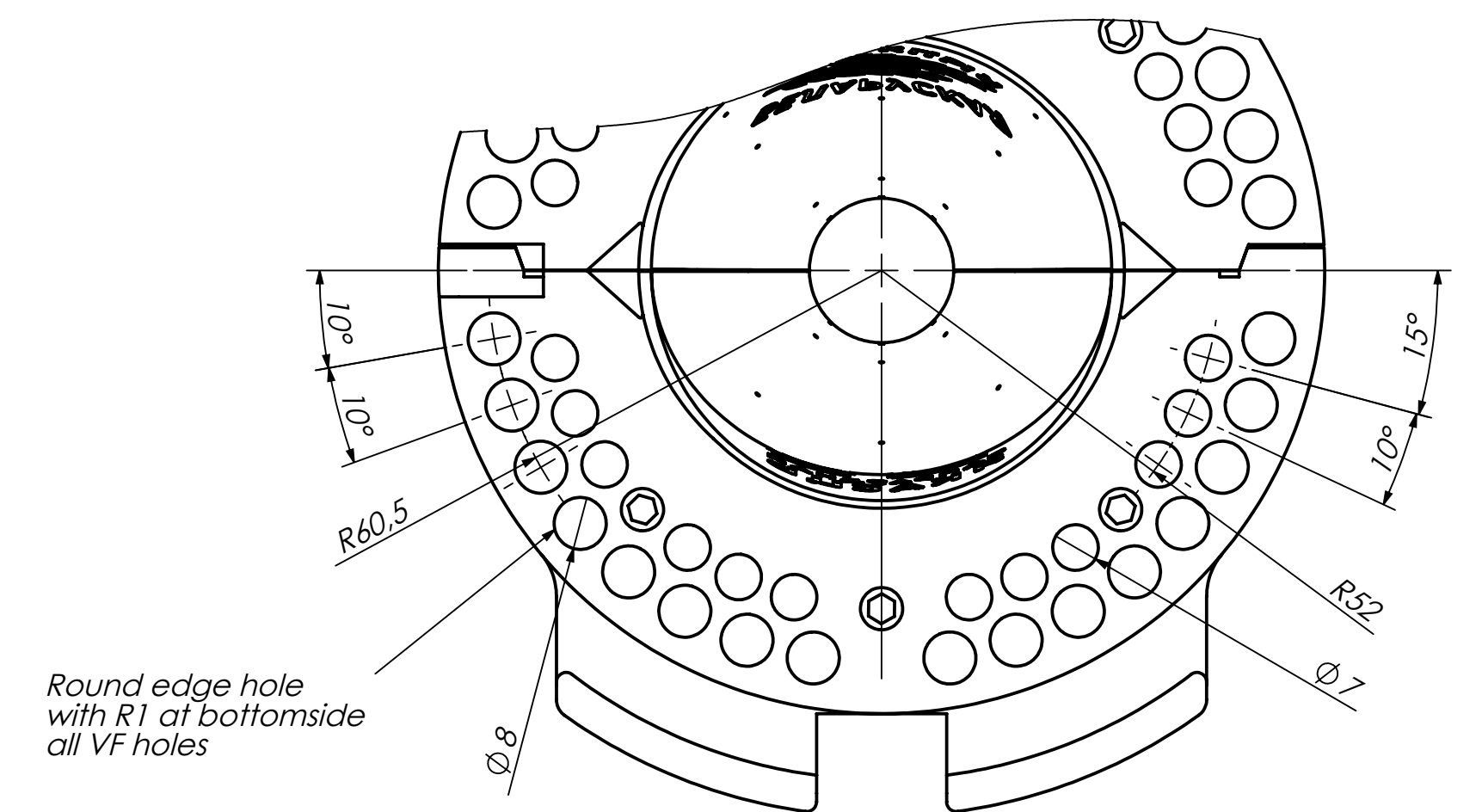


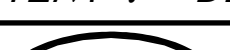
INVERT CENTRE : 90
H' DIMENSION : 0
ASSEMBLY : 23/53

°C; ? °°%(.')-Z&\$\$("%

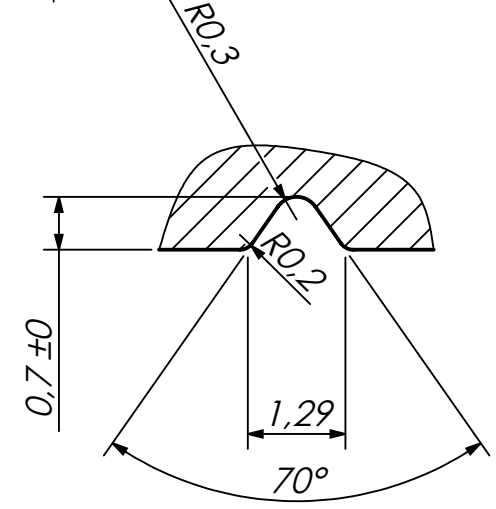
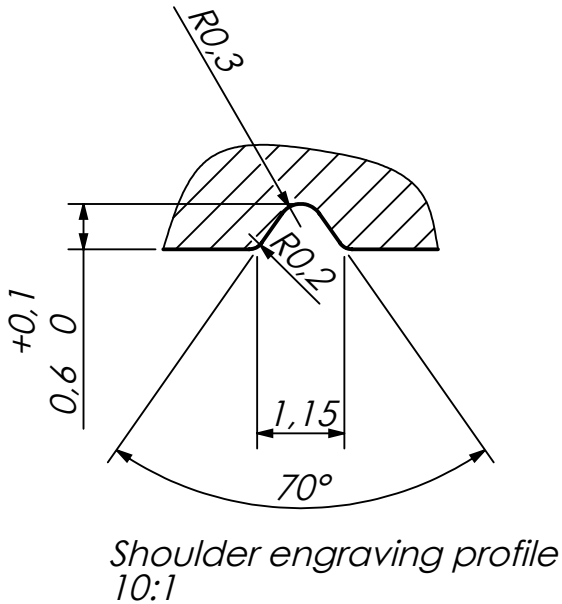
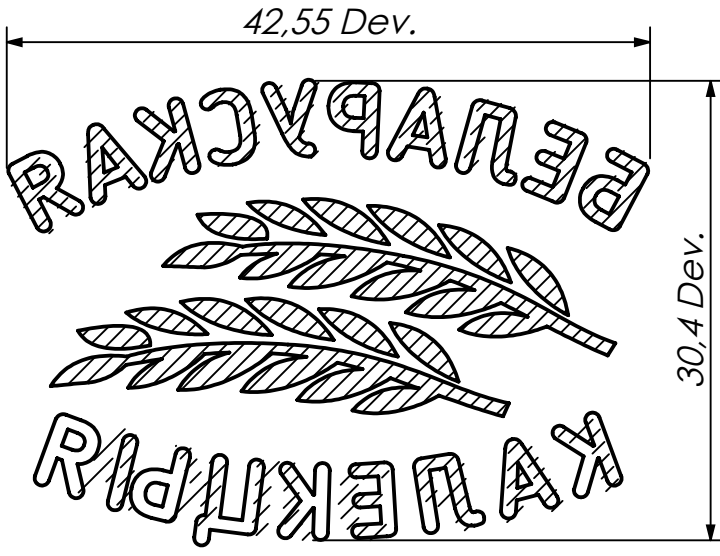
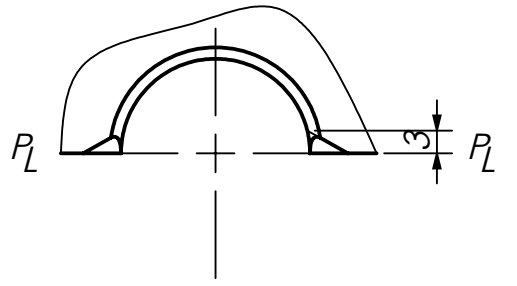
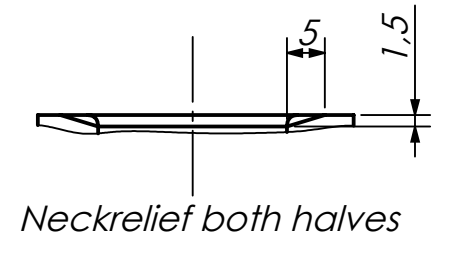
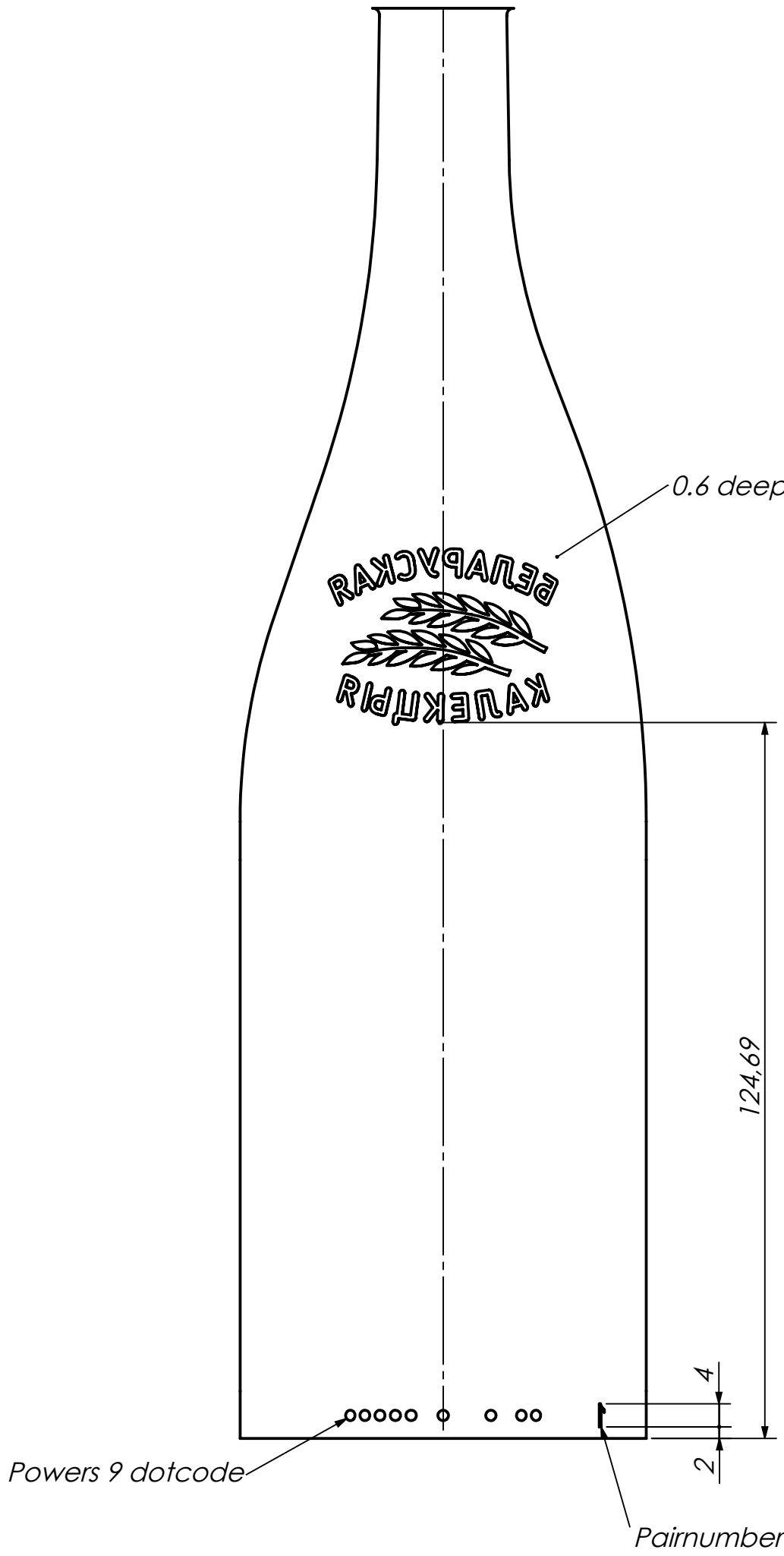
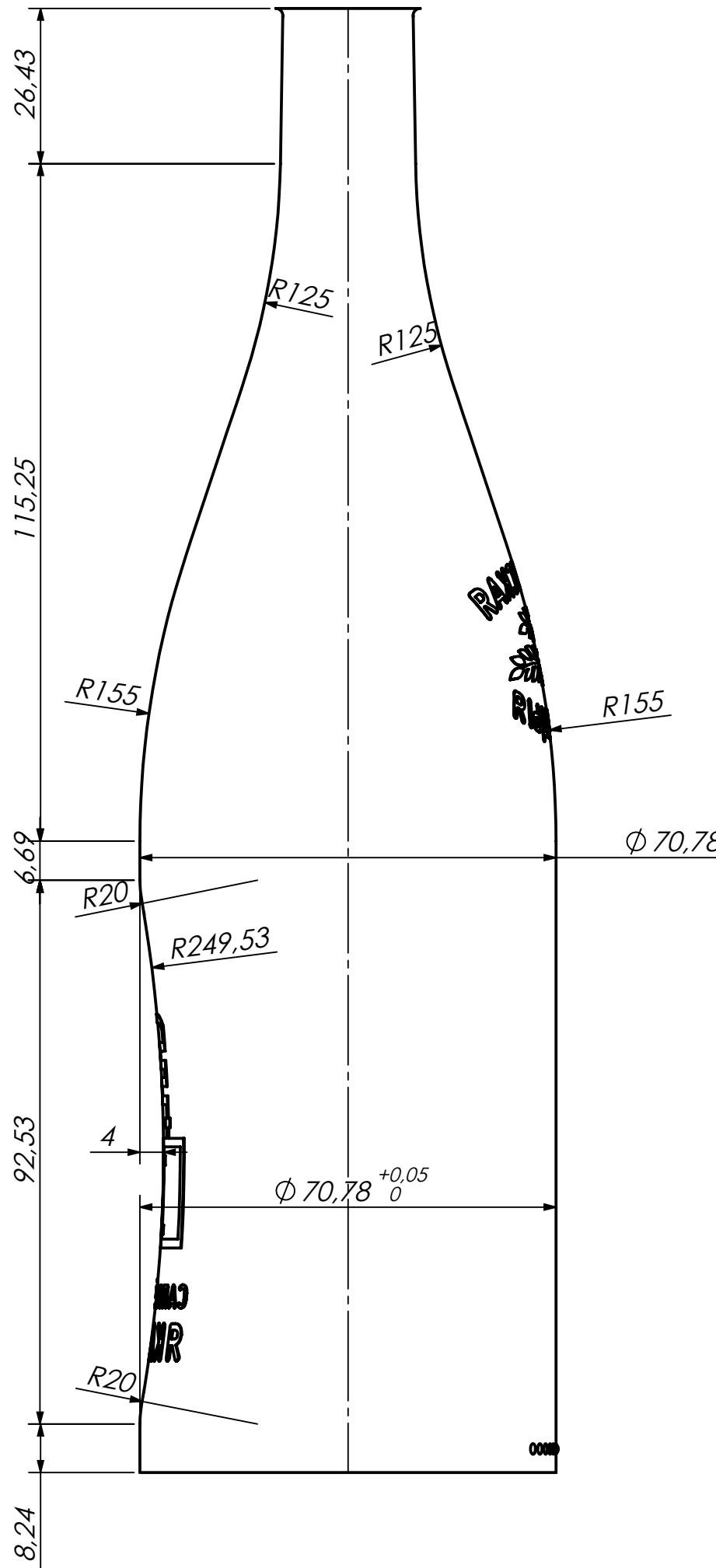
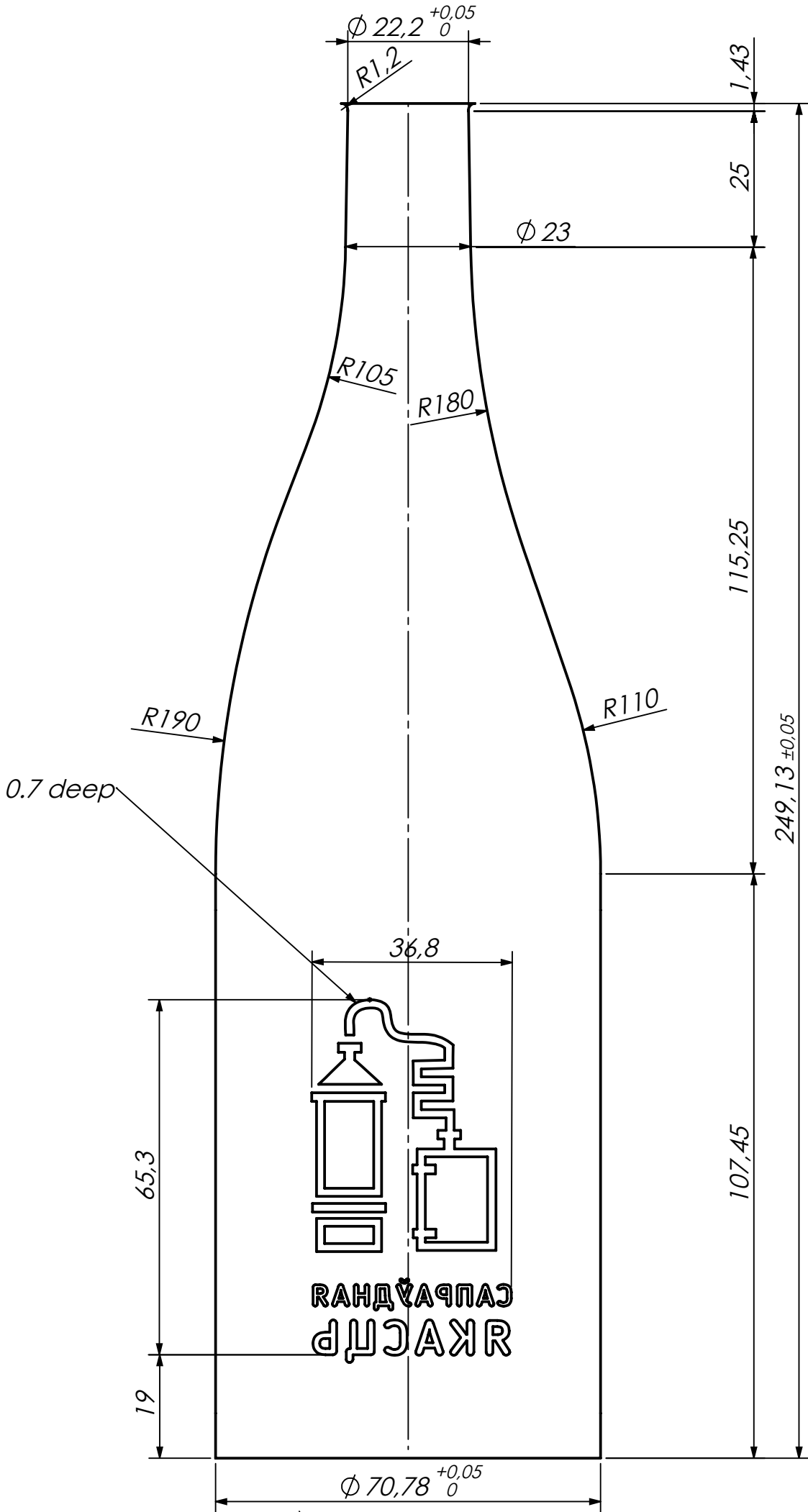
TOLERANCES : UNLESS OTHERWISE STATED DIMS. 0.0 ±0.2 DIMS. 0.00 ±0.05 HALF & HALF MAX : 0.20 CONCENTRICITY : 0.05	
MATERIAL :	MACH : 8B DG 5 1/2
QUANTITY :	SCALE : 1:1
DATE : 18-4-2016	DESIGNER : JBB
CUSTOMER : ELIVOZO	

ITEM : MACHINE SETUP	
AS ALATI STUHNE Ltd TOOLS FOR MANUFACTURE OF CONTAINER GLASS AND MACHINE PARTS	
TITLE : 500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ	
DRG No: AS384-02-02 A	



ITEM :	BLOWMOULD
 ALATI STUHNÉ Ltd TOOLS FOR MANUFACTURE OF CONTAINER GLASS AND MACHINE PARTS	
TITLE :	500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ
DRG No: AS384-03-01 A	

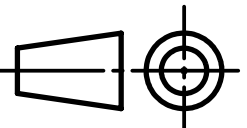
REVISIONS		
REV.	DESCRIPTION	DATE
A	Cavity modified	8-4-2016



Volume mould+bottom	664,15 ml	662,29 gr	+/- 1,5
Volume mould	653,06 ml	651,23 gr	
Volume bottom	11,09 ml		

1,0028 Conversion factor gr ml

“C; ? ”“%.(\$.&+Z&\$’\$(’%”

		TOLERANCES : UNLESS OTHERWISE STATED DIMS. 0.0 ±0.2 DIMS. 0.00 ±0.05 HALF & HALF MAX :0.20 CONCENTRICITY :0.05
MATERIAL :	MACH : BB DG 5 1/2	
QUANTITY : 2	SCALE : 1:1	
DATE :18-4-2016	DESIGNER: JBB	
CUSTOMER : ELIVOZO		

ITEM : MOULD CAVITY	
 ALATI STUHNE Ltd -1986- TOOLS FOR MANUFACTURE OF CONTAINER GLASS AND MACHINE PARTS	
TITLE : 500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ	
DRG No: AS384-03-12 A	

INVERT CENTRE : -
H' DIMENSION : -
ASSEMBLY : -

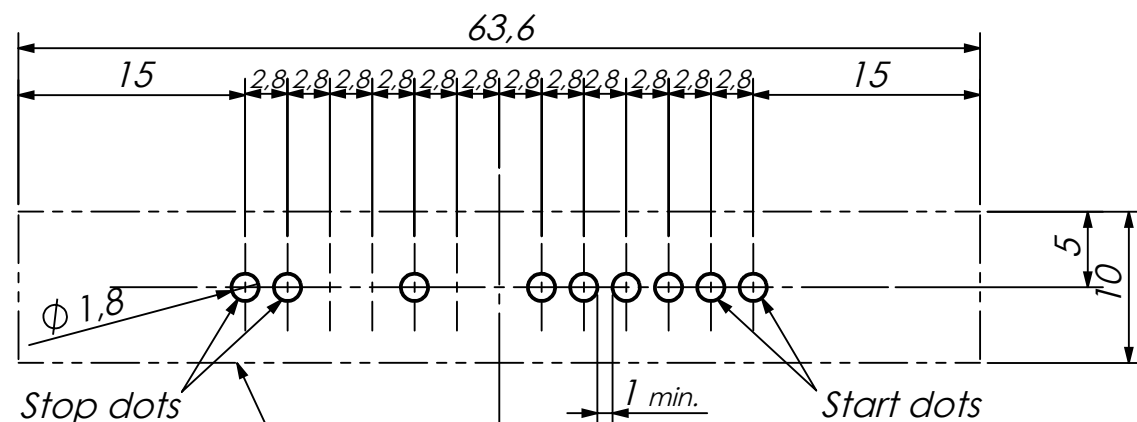
Dot position detail ("o" represent engraved "dots")

Cavity No.	14	13	12	11	10	9	8	7	6	5	4	3	2	1
01														
02														
03														
04														
05														
06														
07														
08														
09														
10														
11														
12														
13														
14														
15														
16														
17														
18														
19														
20														
21														
22														
23														
24														
25														
26														
27														
28														
29														
30														
31														
32														
33														
34														
35														
36														
37														
38														
39														
40														
41														
42														
43														
44														
45														
46														
47														
48														
49														
50														
51														
52														
53														
54														
55														
56														
57														
58														
59														
60														
61														
62														
63														
64														
65														
66														
67														
68														
69														
70														
71														
72														
73														
74														
75														
76														
77														
78														
79														
80														
81														
82														
83														
84														
85														
86														
87														
88														
89														
90														

Mould cavity view

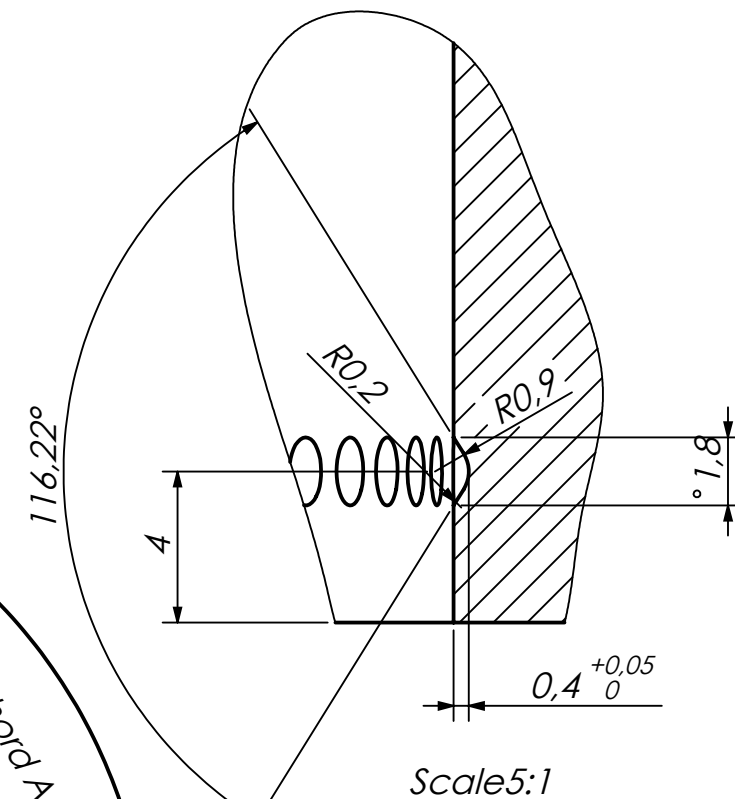
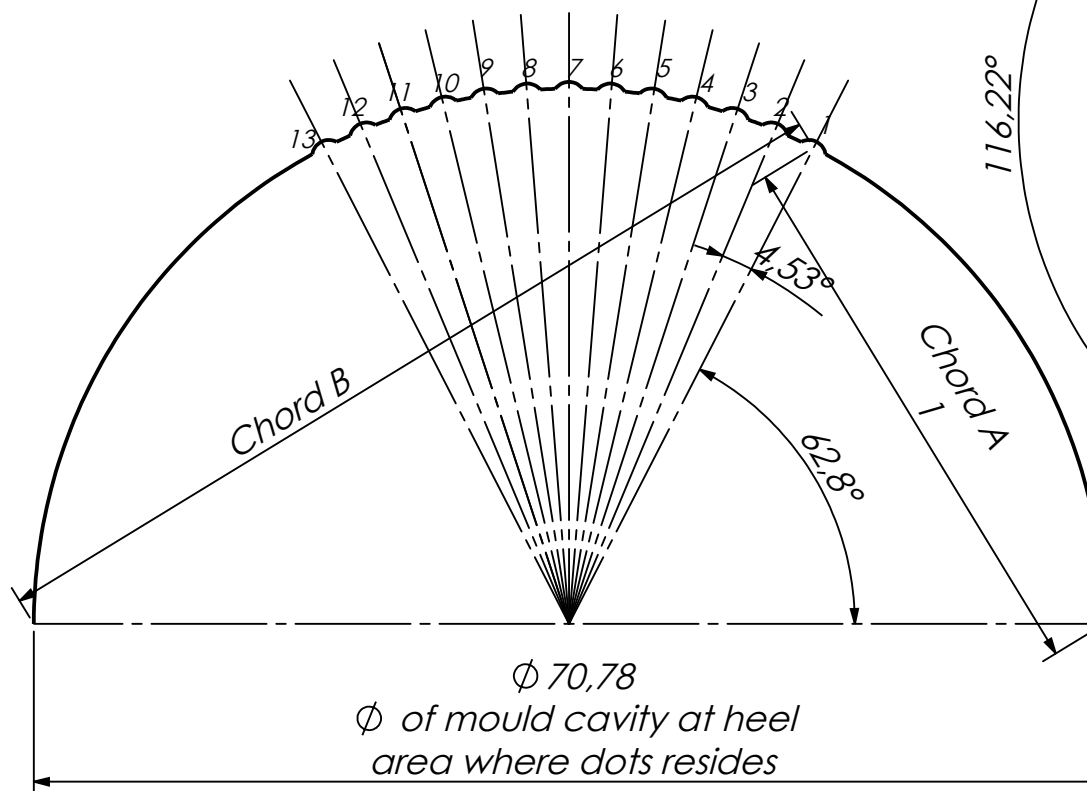
The chart shows the dot patterns as they appear when looking into the mould cavity held vertically in front of observer

Tolerance between dots ± 0.25



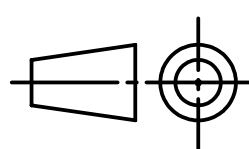
Window designating clear area around dotcode
(No heel engraving within windows specified area)

	Chord A	Chord B
1	36,88	60,41
2	39,24	58,91
3	41,54	57,31
4	43,77	55,62
5	45,94	53,85
6	48,03	51,99
7	50,05	50,05
8	51,99	48,03
9	53,85	45,94
10	55,62	43,77
11	57,31	41,54
12	58,91	39,24
13	60,41	36,88



INVERT CENTRE : -
H' DIMENSION : -
ASSEMBLY : -

“C; ? ”%.(%&+ž&\$’\$(’%”



TOLERANCES : UNLESS OTHERWISE STATED
DIMS. 0.0 ± 0.2
DIMS. 0.00 ± 0.05
HALF & HALF MAX : 0.20
CONCENTRICITY : 0.05

ITEM : POWERS 16049A DOTCODE



ALATI STUHNE Ltd

TOOLS FOR MANUFACTURE OF CONTAINER GLASS AND MACHINE PARTS

TITLE : 500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ

DRG No: AS384-03-13 A

REVISIONS

REV.	DESCRIPTION	DATE
A	dia 70.6 70.52	8-4-2016

MATERIAL : -

MACH : BB DG 5 1/2

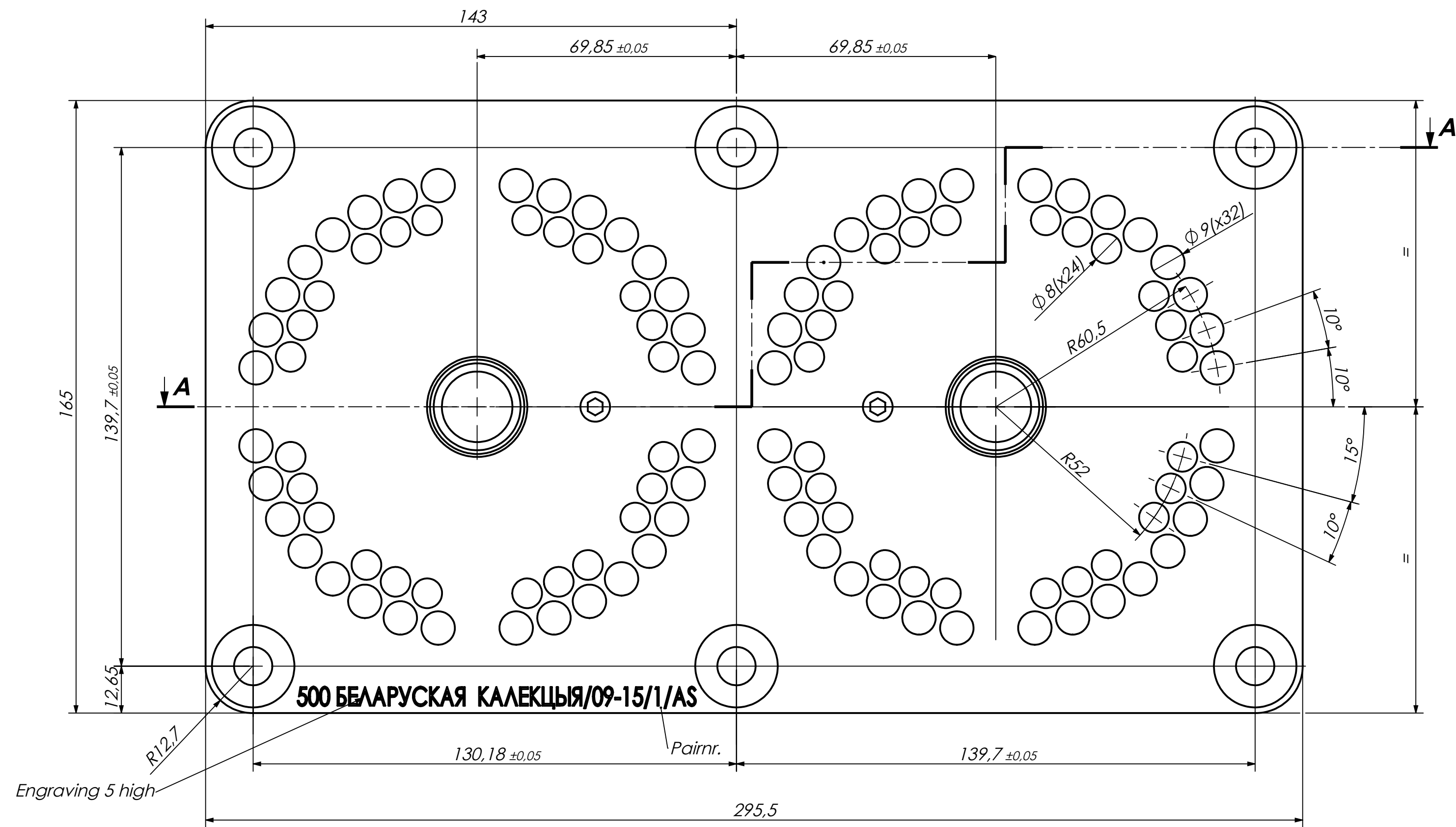
QUANTITY : 2

SCALE : 2:1

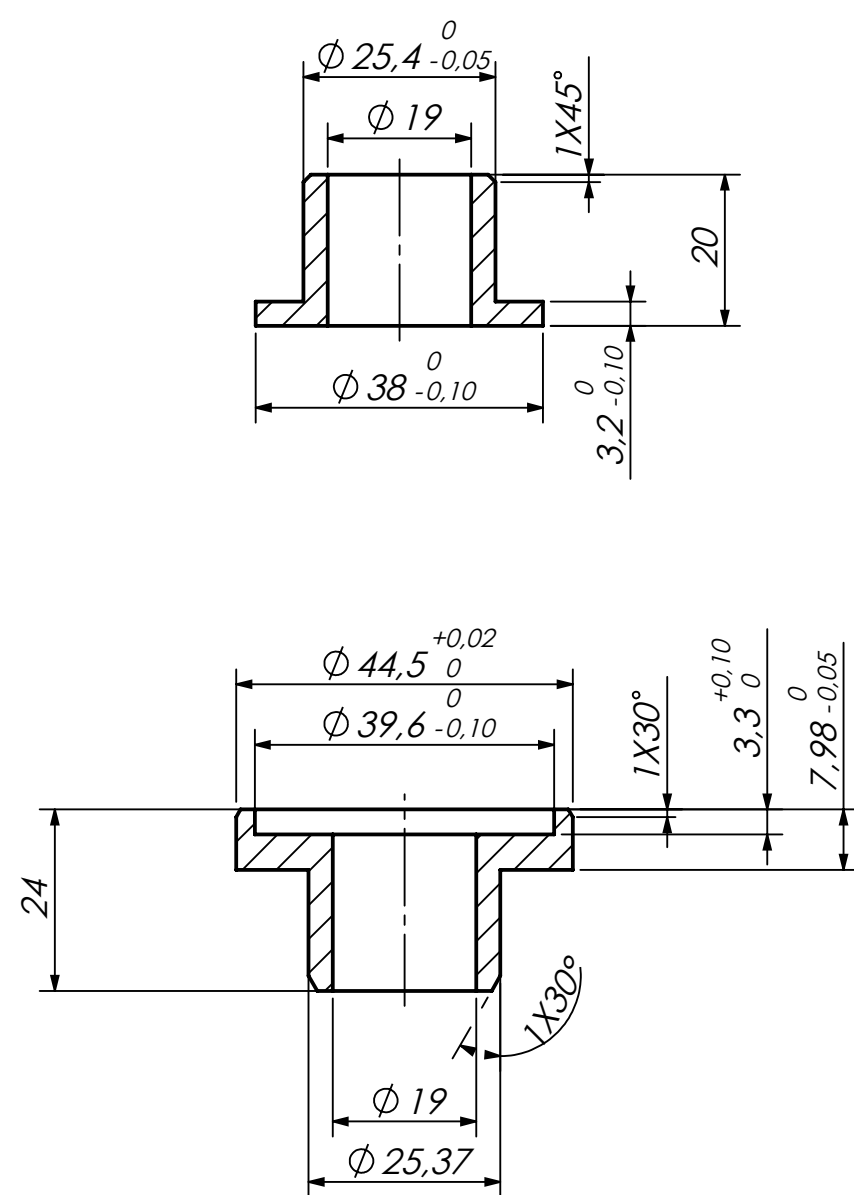
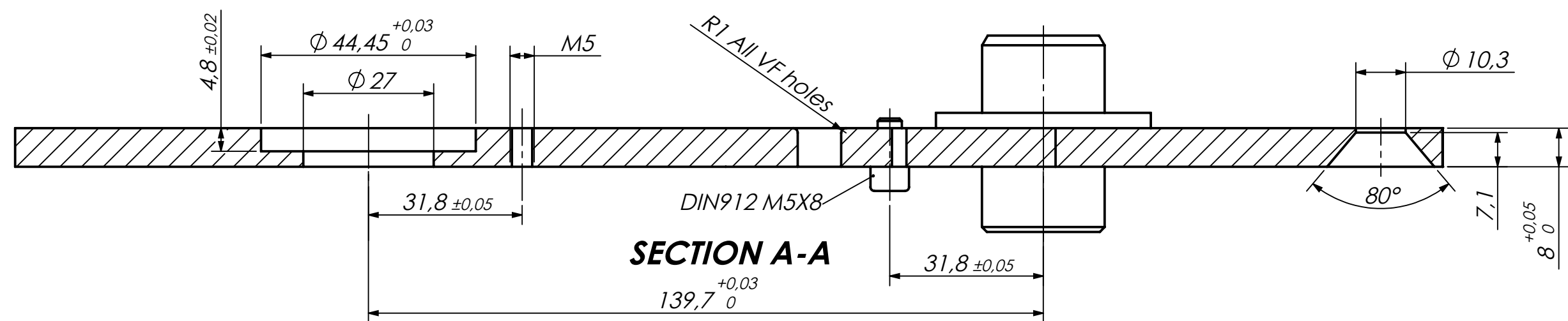
DATE : 18-4-2016

DESIGNER: JBB

CUSTOMER : Veralia Zorya

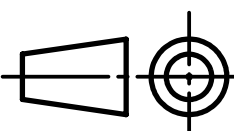



Engraving 5 high

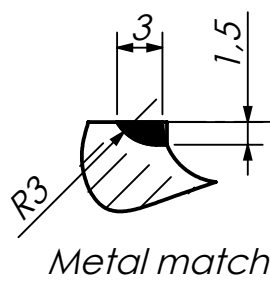
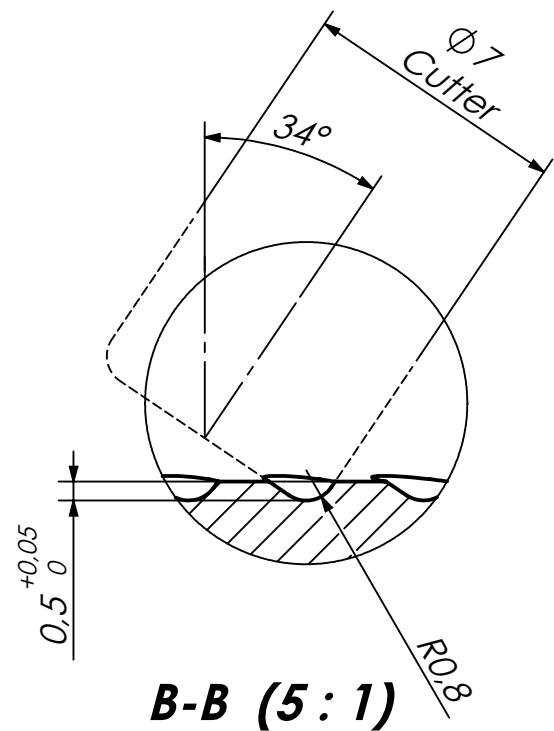
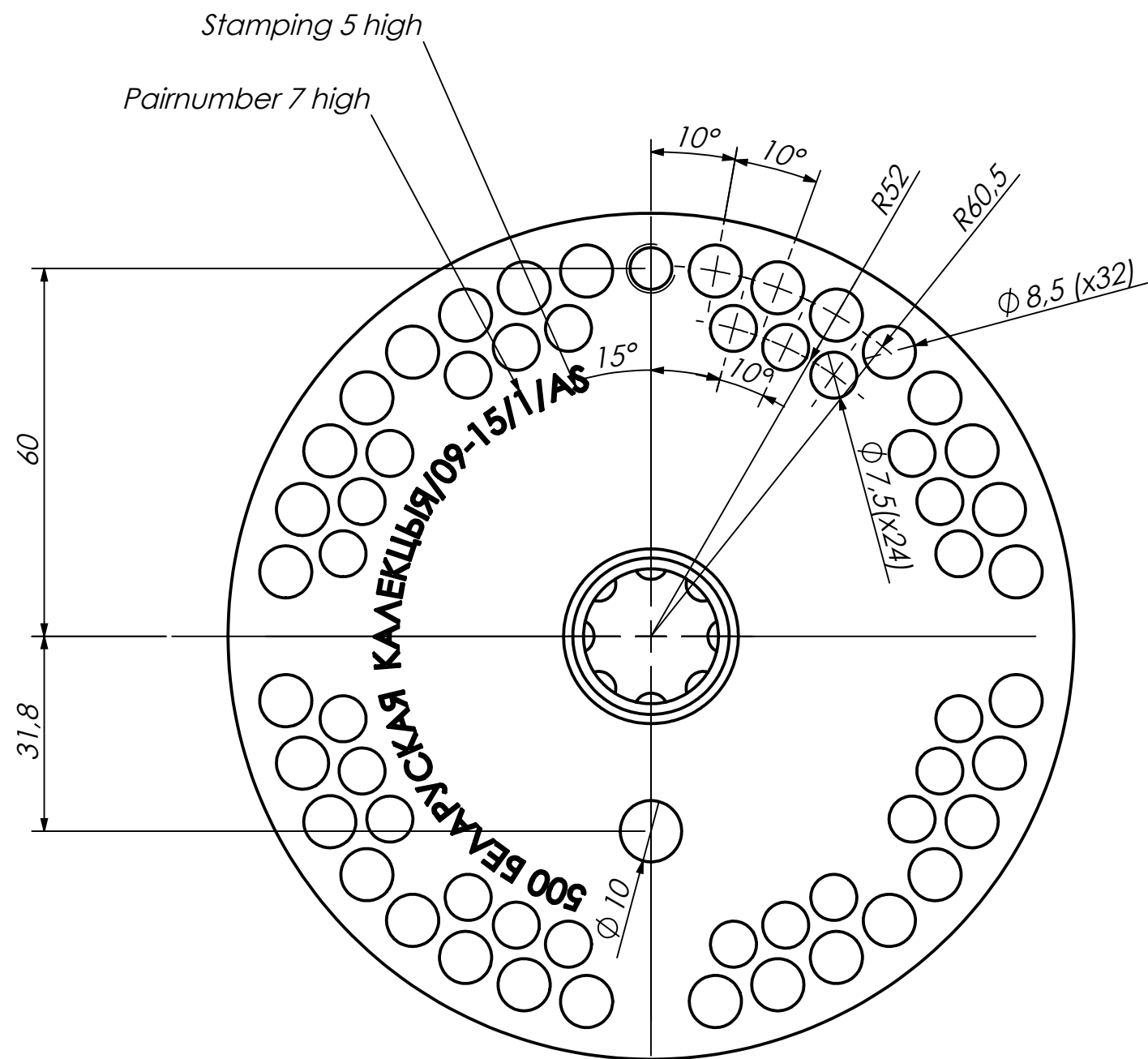
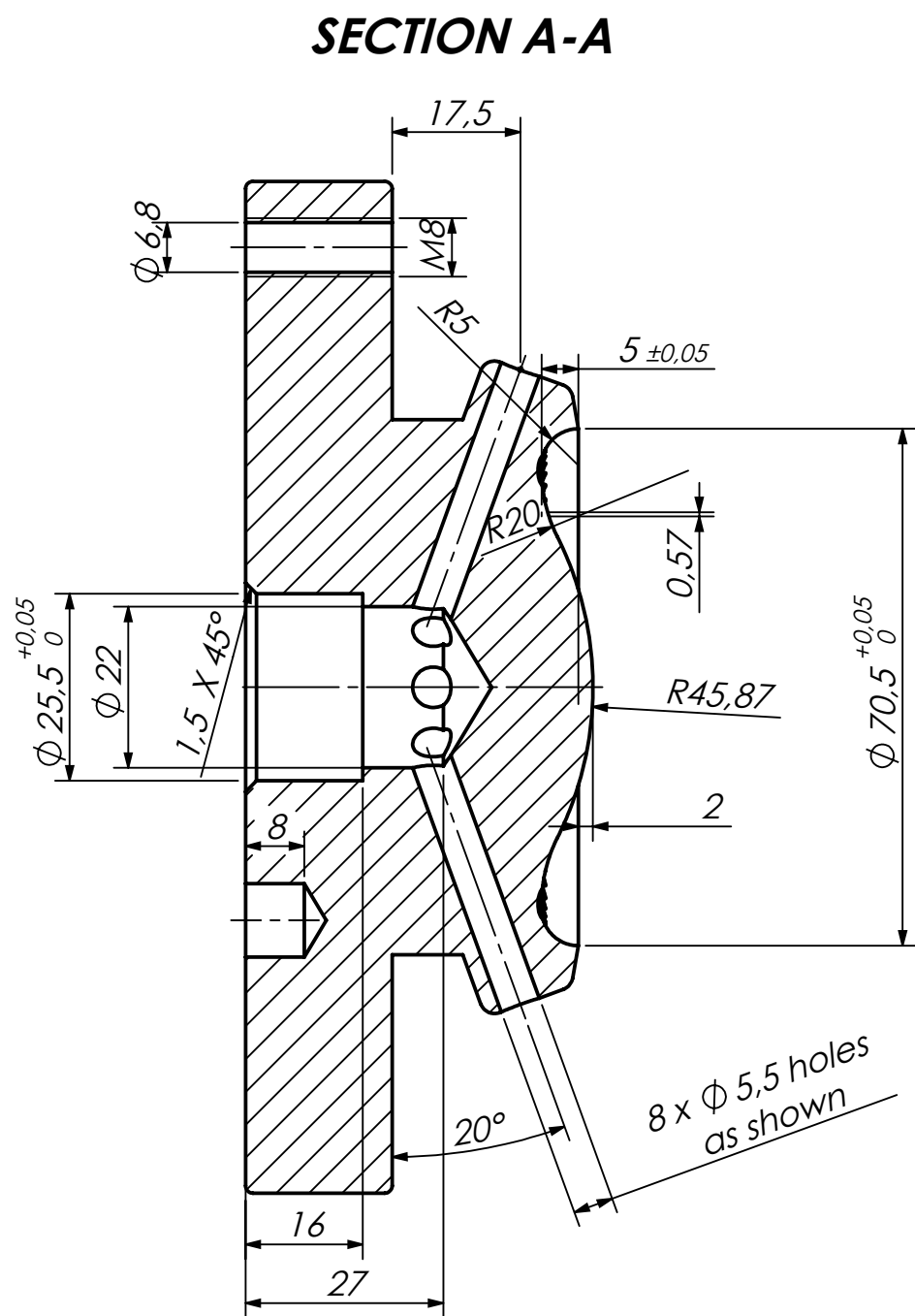
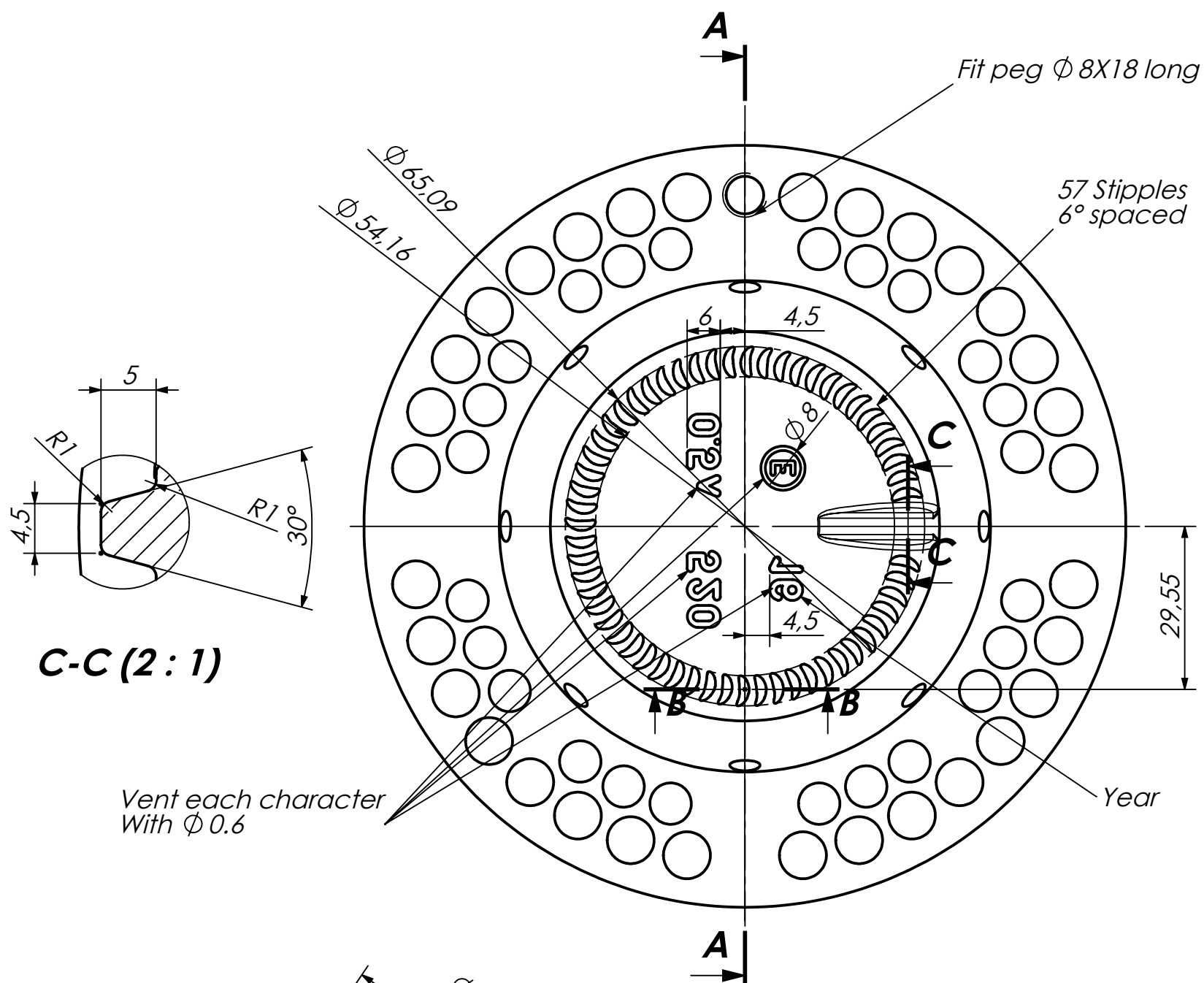
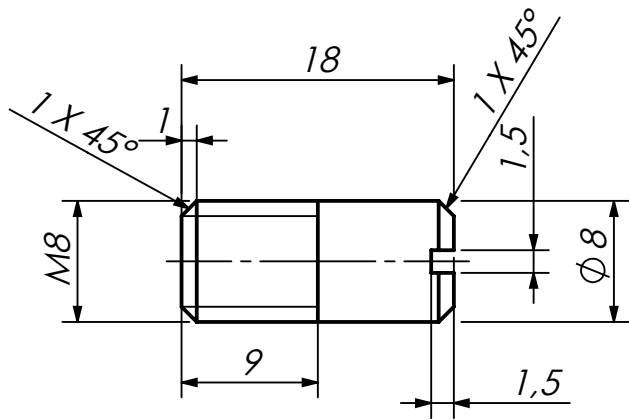
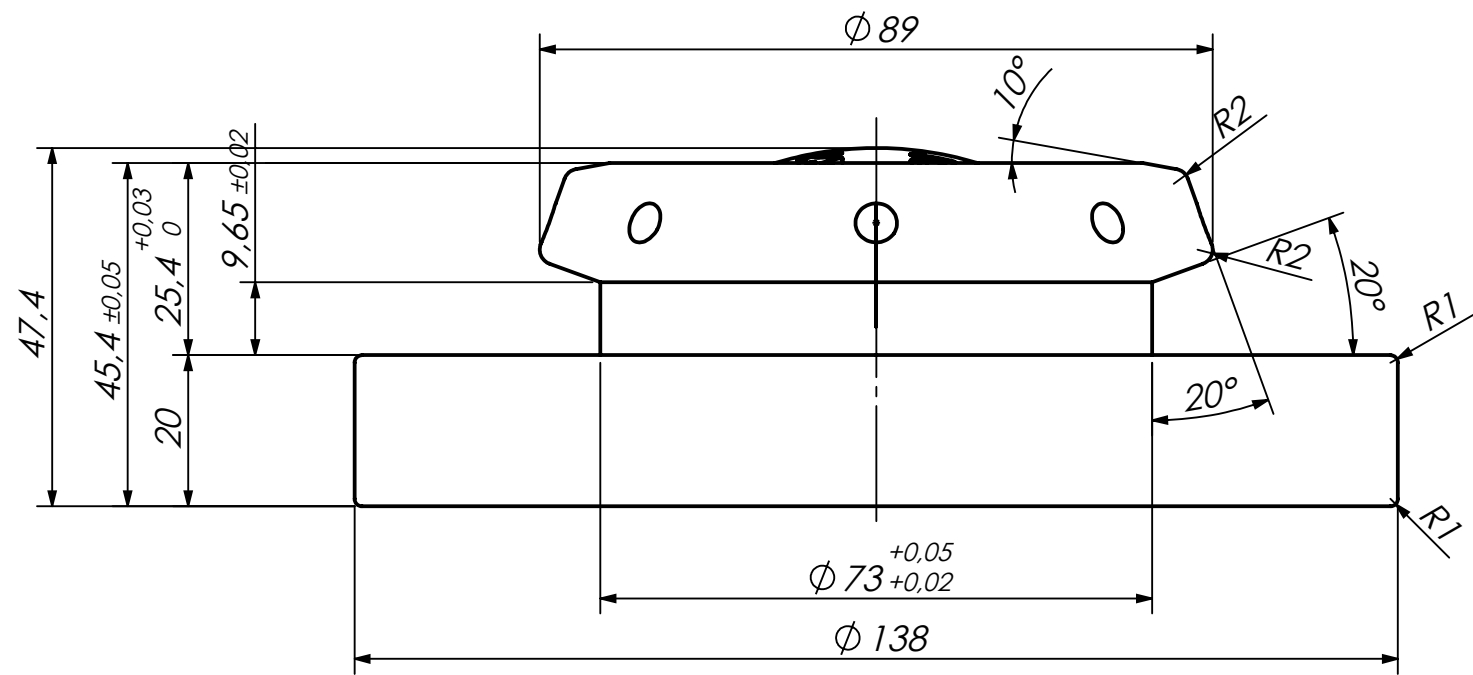


INVERT CENTRE : -
H' DIMENSION : -
ASSEMBLY : -

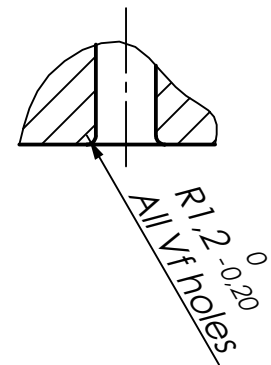
©; ? ""%.(.(.-ž&\$'\$('%

		TOLERANCES : UNLESS OTHERWISE STATED DIMS. 0.0 ±0.2 DIMS. 0.00 ±0.05 HALF & HALF MAX : 0.20 CONCENTRICITY : 0.05		ITEM : VERTIFLOW PLATE	
MATERIAL : Steel		MACH : BB DG 5 1/2		 ALATI STUHNE Ltd -1986- TOOLS FOR MANUFACTURE OF CONTAINER GLASS AND MACHINE PARTS	
QUANTITY : 2		SCALE : 1:1		TITLE : 500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ	
DATE :18-4-2016		DESIGNER: JBB		DRG No: AS384-03-21	
CUSTOMER : ELIVOZO					

REVISIONS		
REV.	DESCRIPTION	DATE
A	Cavity modified and engraving modified	8-4-2016



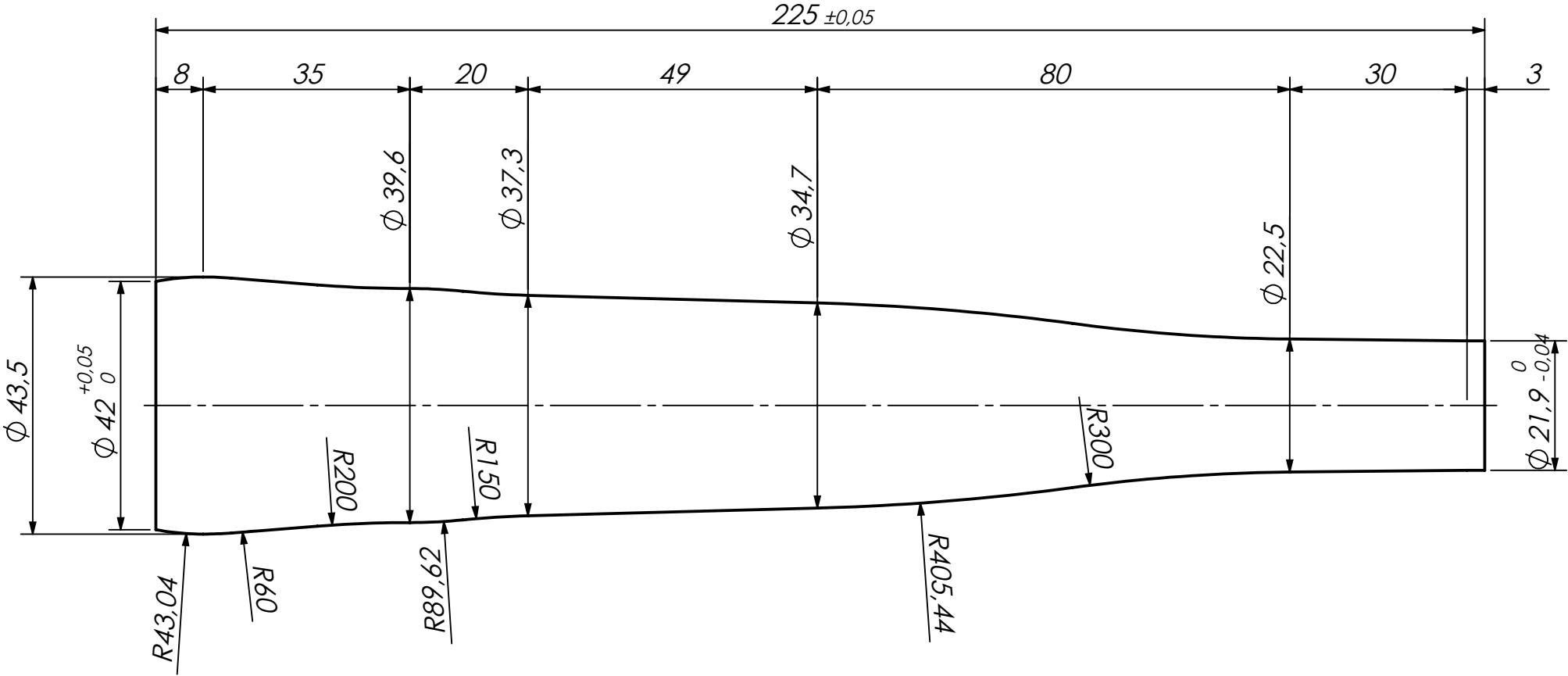
"C; ?""%.(.).%Z&\$\$("%



INVERT CENTRE :-
H' DIMENSION :-
ASSEMBLY :-

<p>TOLERANCES : UNLESS OTHERWISE STATED DIMS. 0.0 ±0.2 DIMS. 0.00 ±0.05 HALF & HALF MAX :0.20 CONCENTRICITY :0.05</p>		ITEM : BOTTOMPLATE
<p>MATERIAL : STANDARD G3 MACH : BB DG 5 1/2</p>		<p>AS ALATI STUHNE Ltd</p> <p>TOOLS FOR MANUFACTURE OF CONTAINER GLASS AND MACHINE PARTS</p>
<p>QUANTITY : 2</p>		TITLE : 500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ
<p>DATE :18-4-2016</p>		DRG No: AS384-04-01 A
<p>CUSTOMER : ELIVOZO</p>		

REVISIONS		
REV.	DESCRIPTION	DATE
A	cavity modified	8-4-2016

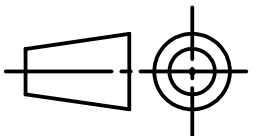



Volume blank+baffle	200,43 ml	199,87 gr	+/- 1,5
Volume blank	196,62 ml	196,07 gr	
Volume baffle	3,81 ml		

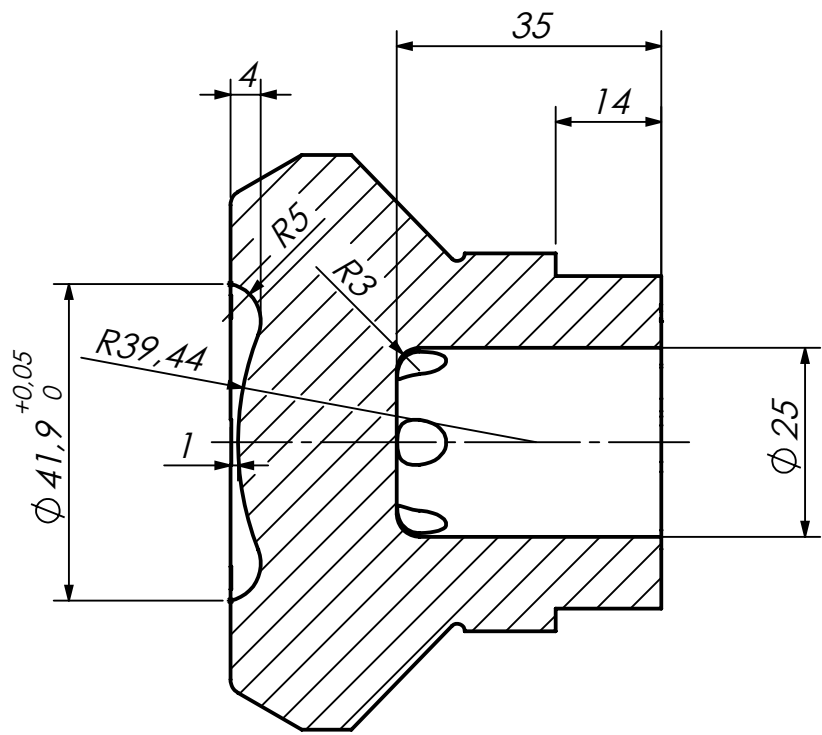
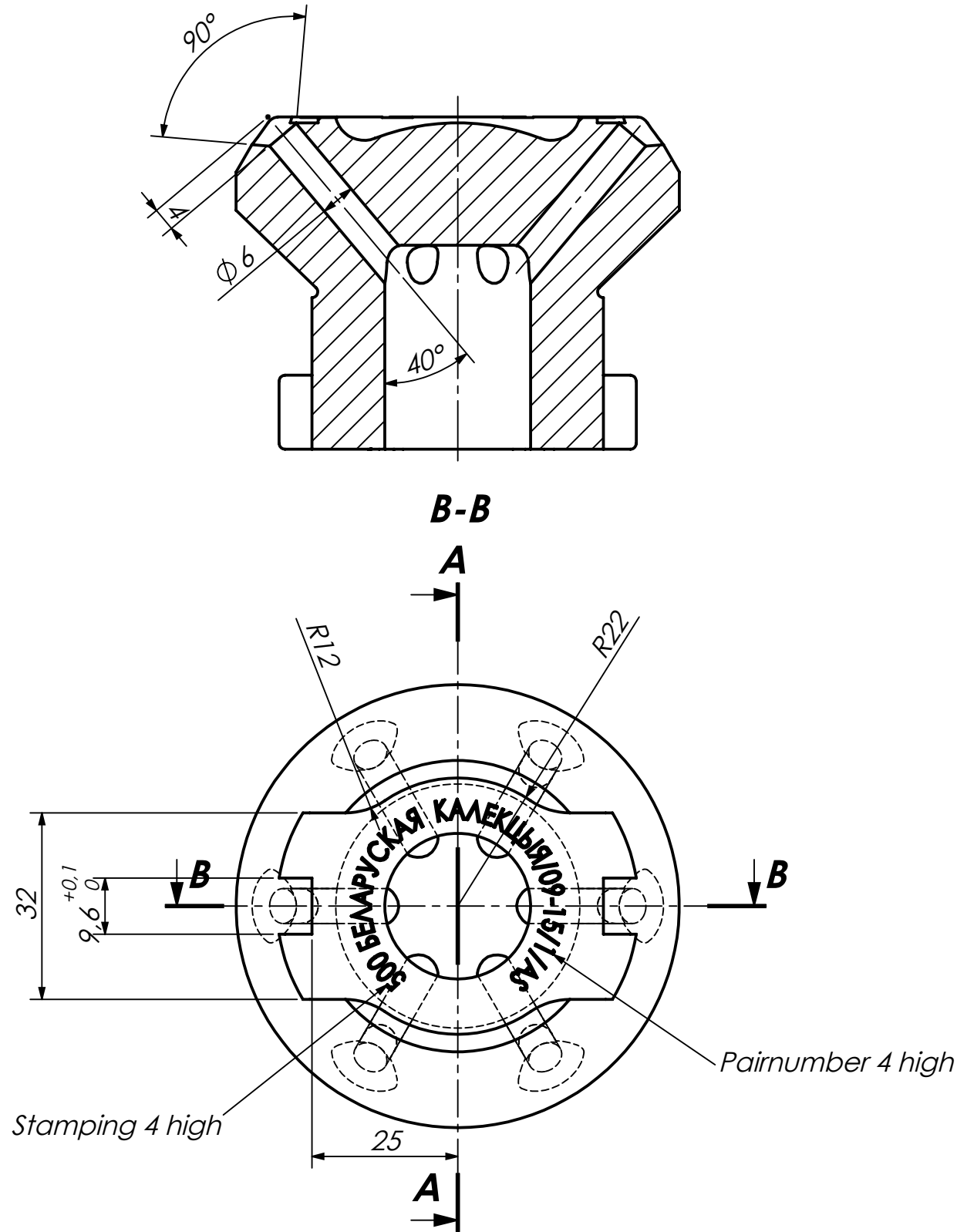
1,0028 Conversion factor gr ml

INVERT CENTRE :-
H' DIMENSION :-
ASSEMBLY :-

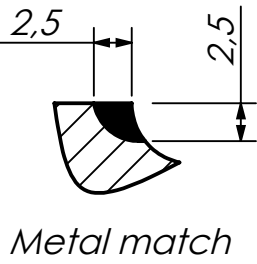
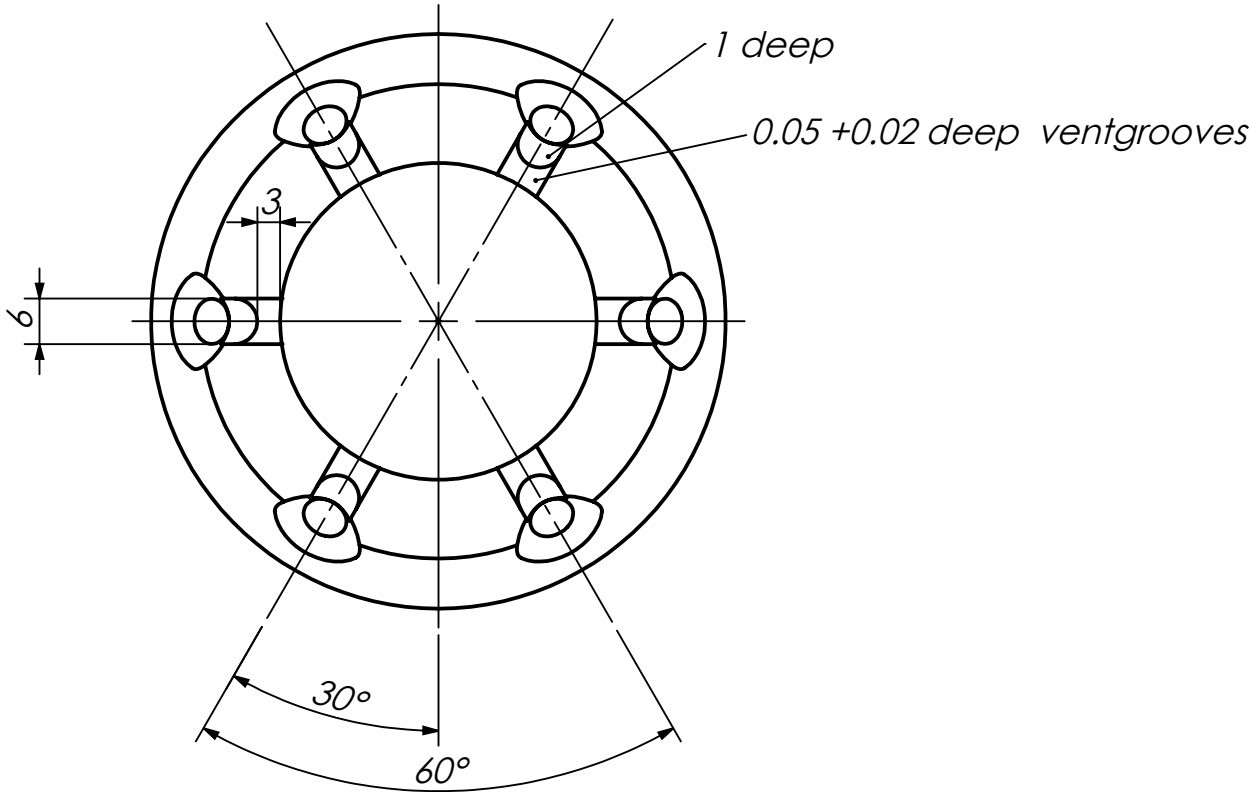
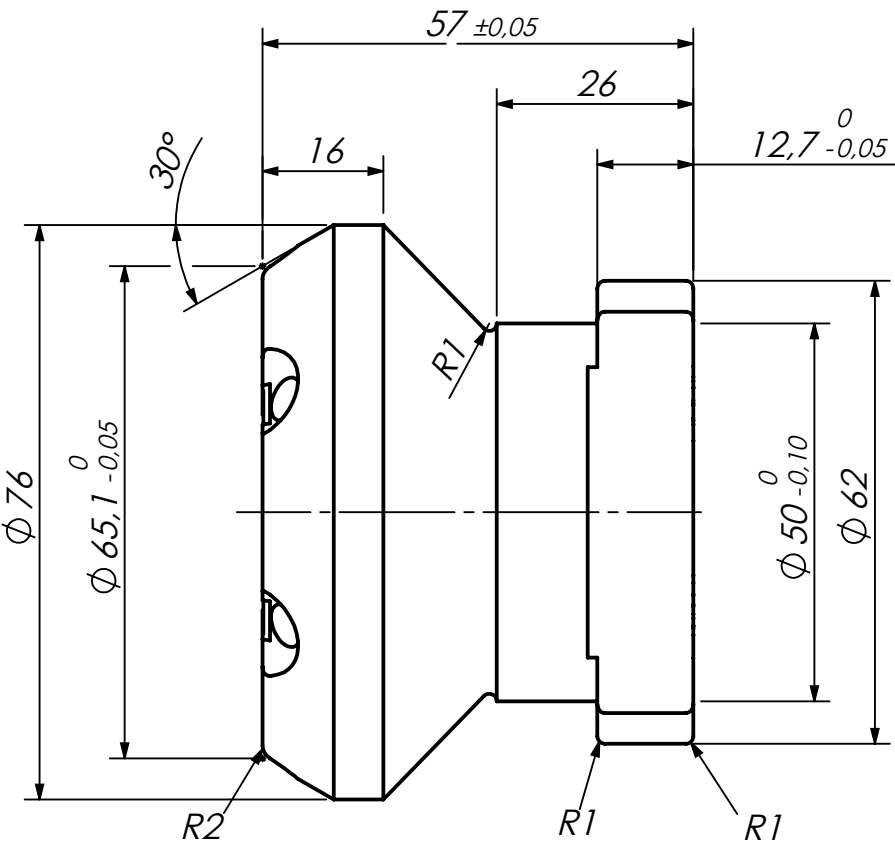


<div></div> <div>TOLERANCES : UNLESS OTHERWISE STATED DIMS. 0.0 ±0.2 DIMS. 0.00 ±0.05 HALF & HALF MAX :0.20 CONCENTRICITY :0.05</div>		ITEM : BLANK CAVITY	
		<div> ALATI STUHNE Ltd</div> <div>TOOLS FOR MANUFACTURE OF CONTAINER GLASS AND MACHINE PARTS</div>	
MATERIAL : -	MACH : BB DG 5 1/2	TITLE : 500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ	
QUANTITY : 2	SCALE : 1:1		
DATE :18-4-2016	DESIGNER: JBB	DRG No: AS384-05-12 A	
CUSTOMER : ELIVOZO			

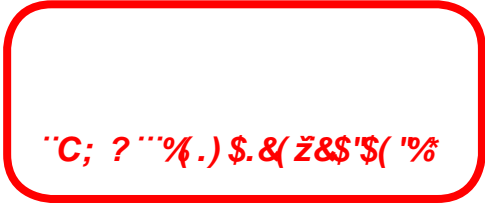
REVISIONS		
REV.	DESCRIPTION	DATE
A	match dia was 41.4	8-4-2016

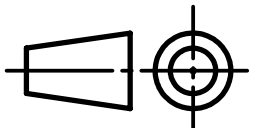



SECTION A-A

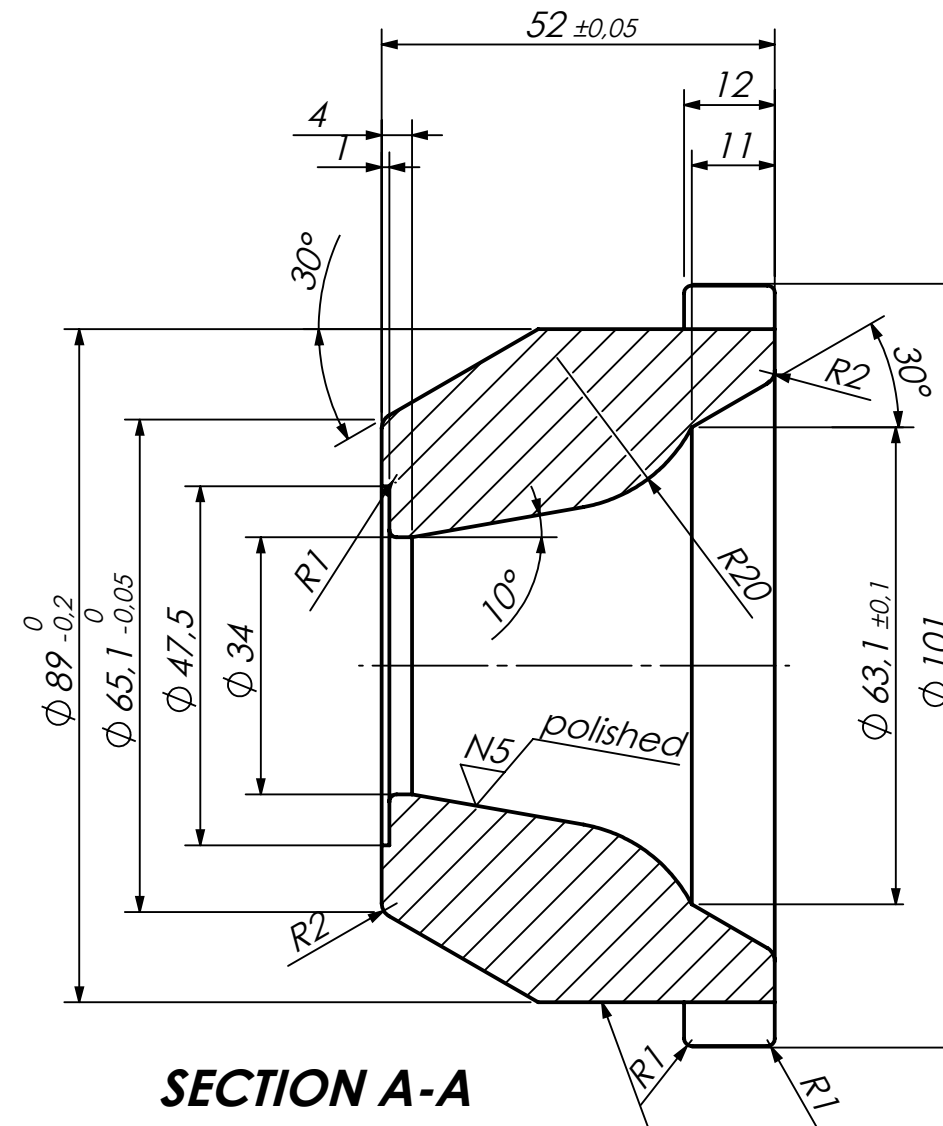
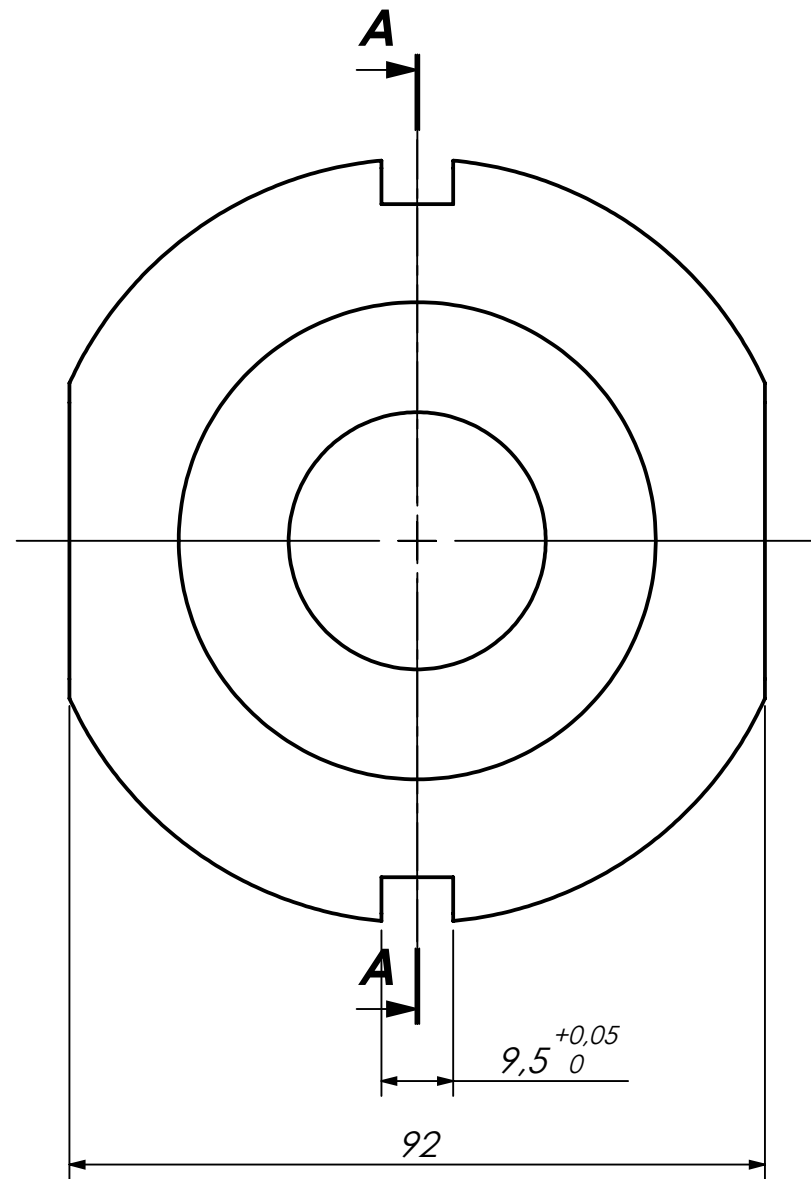


INVERT CENTRE :-
H' DIMENSION :-
ASSEMBLY :-



 TOLERANCES : UNLESS OTHERWISE STATED DIMS. 0.0 ±0.2 DIMS. 0.00 ±0.05 HALF & HALF MAX :0.20 CONCENTRICITY :0.05		ITEM : BAFFLE
MATERIAL : STANDARD GL	MACH : BB DG 5 1/2	 ALATI STUHNE Ltd <small>TOOLS FOR MANUFACTURE OF CONTAINER GLASS AND MACHINE PARTS</small>
QUANTITY : 2	SCALE : 1:1	
DATE :18-4-2016	DESIGNER: JBB	
CUSTOMER : ELIVOZO		DRG No: AS384-06-01 A

N8/ N5/ POLISH/

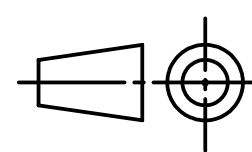


SECTION A-A

stamping 4 high
500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ/month-year/pairn./AS

INVERT CENTRE :-
H' DIMENSION :-
ASSEMBLY :-

"C; ? ""%.)\$.', ž&\$'\$('%



TOLERANCES : UNLESS OTHERWISE STATED
DIMS. 0.0 ±0.2
DIMS. 0.00 ±0.05
HALF & HALF MAX :0.20
CONCENTRICITY :0.05

ITEM : FUNNEL



ALATI STUHNE Ltd

TOOLS FOR MANUFACTURE OF CONTAINER GLASS AND MACHINE PARTS

MATERIAL : STANDARD CI

MACH : BB DG 5 1/2

QUANTITY : 2

SCALE : 1:1

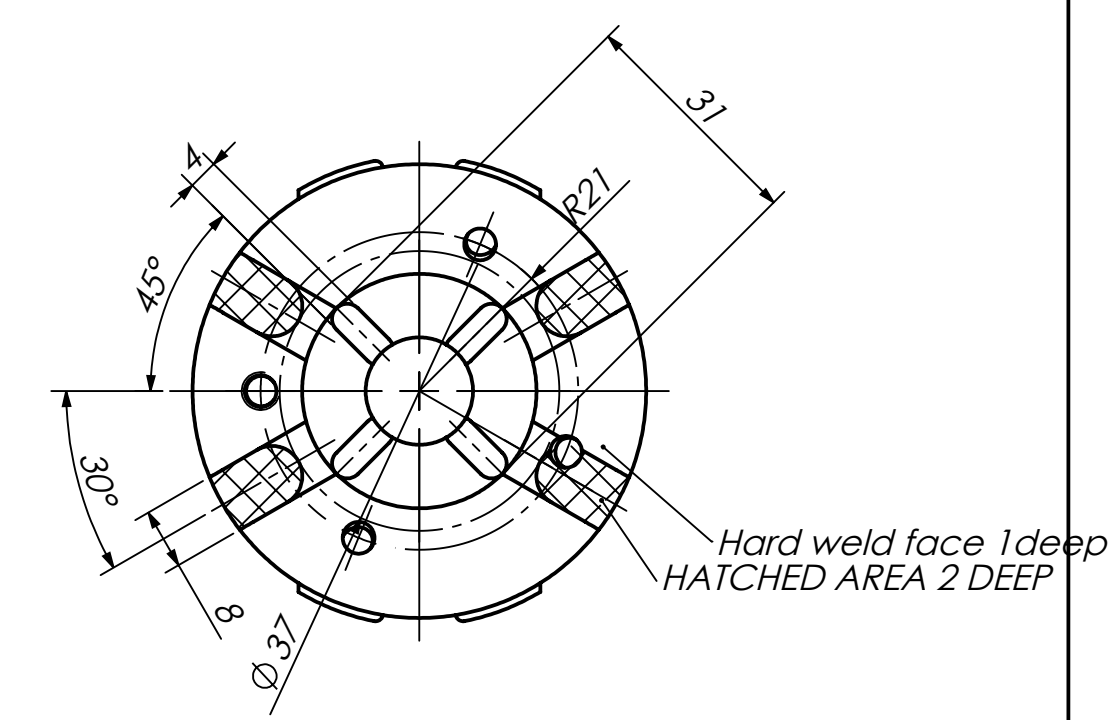
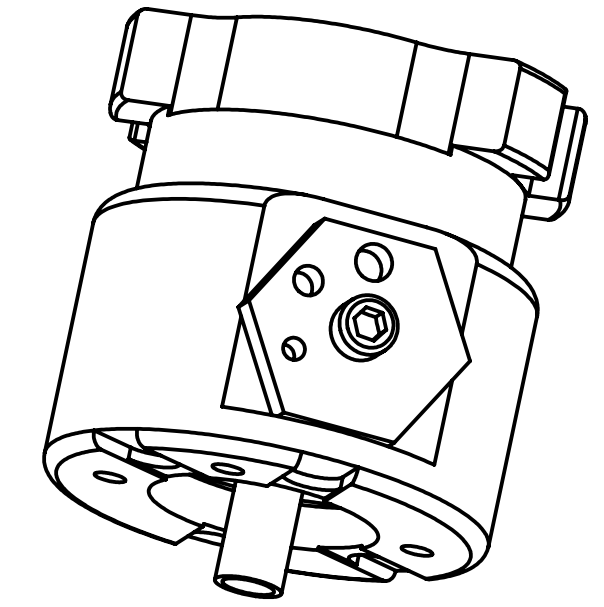
DATE :18-4-2016

DESIGNER: JBB

CUSTOMER : ELIVOZO

TITLE : 500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ

DRG No: AS384-07-01



“C; ? ""%(.) %' - ž&\$'\$(' %*

TOLERANCES : UNLESS OTHERWISE STATED
DIMS. 0.0 ±0.2
DIMS. 0.00 ±0.05
HALF & HALF MAX :0.20
CONCENTRICITY :0.05

ITEM : BLOWHEAD

**ALATI STUHNE Ltd**

TOOLS FOR MANUFACTURE OF CONTAINER GLASS AND MACHINE PARTS

TITLE :	500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ
---------	-------------------------

DRG No: AS384-08-01

MATERIAL : Steel

MACH : BB DG 5 1/2

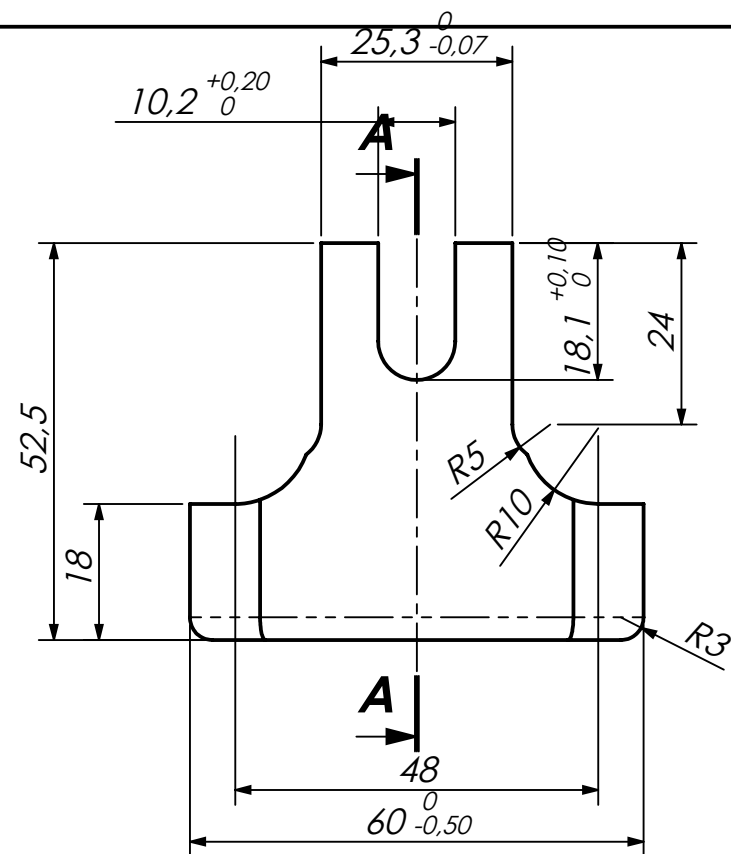
QUANTITY : 2

SCALE : 1:1

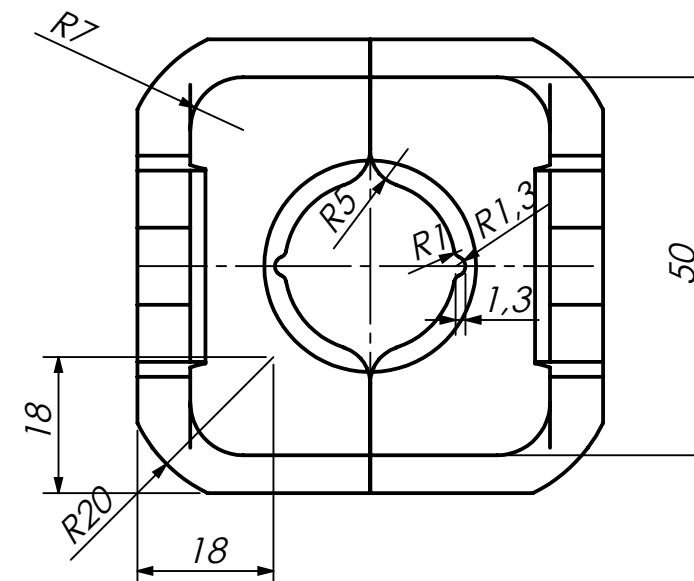
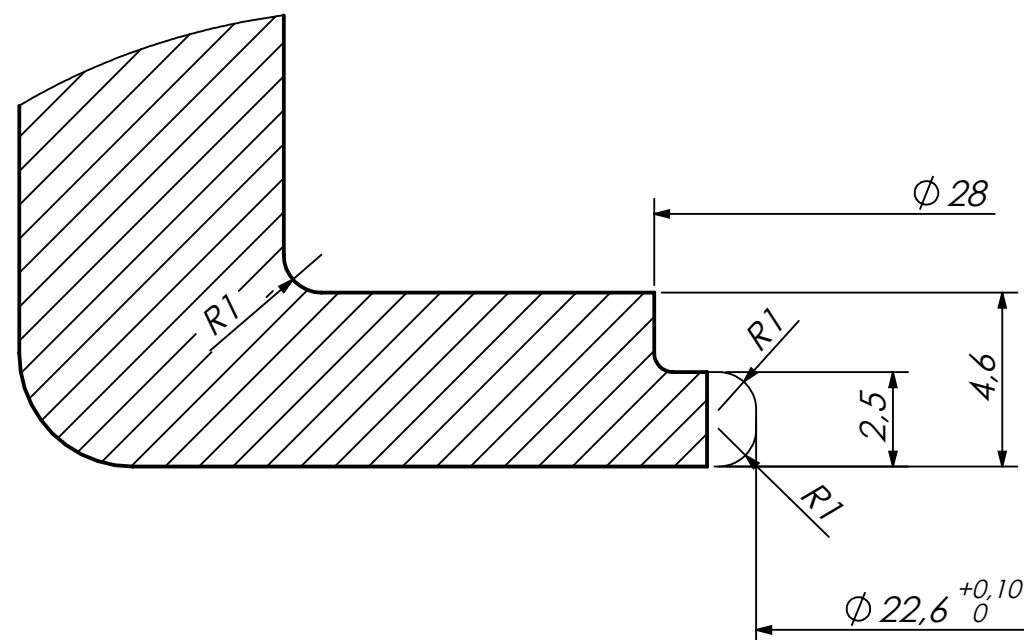
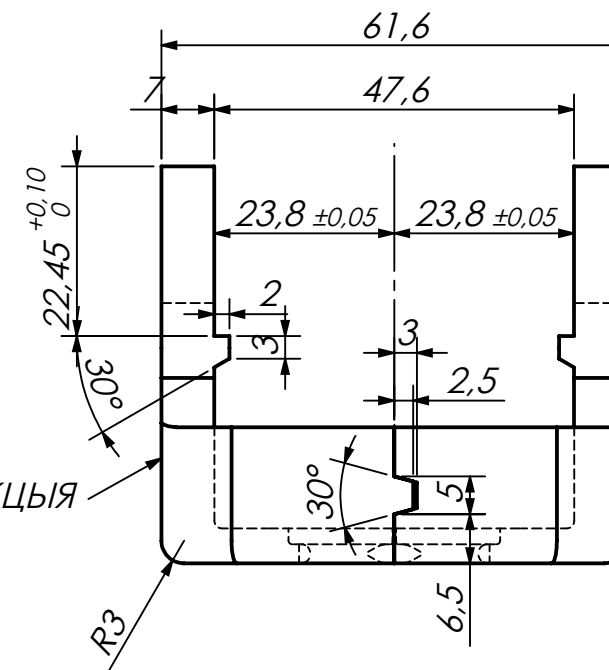
DATE:18-4-2016

DESIGNER: JBB

CUSTOMER : ELIVOZO



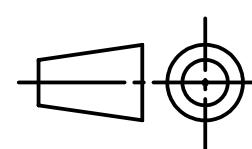
Stamp
500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ
/month/year/pairnr./AS



INVERT CENTRE : -
H' DIMENSION : -
ASSEMBLY : -

A-A (5 : 1)

“C; ? ”“% .) %) +ž&\$'\$('“%



TOLERANCES : UNLESS OTHERWISE STATED
DIMS. 0.0 ±0.2
DIMS. 0.00 ±0.05
HALF & HALF MAX : 0.20
CONCENTRICITY : 0.05

MATERIAL : Bronze

MACH : BB DG 5 1/2

QUANTITY : 2

SCALE : 1:1

DATE : 18-4-2016

DESIGNER : JBB

CUSTOMER : Kavminsteklo

ITEM : TAKE OUT TONGUE

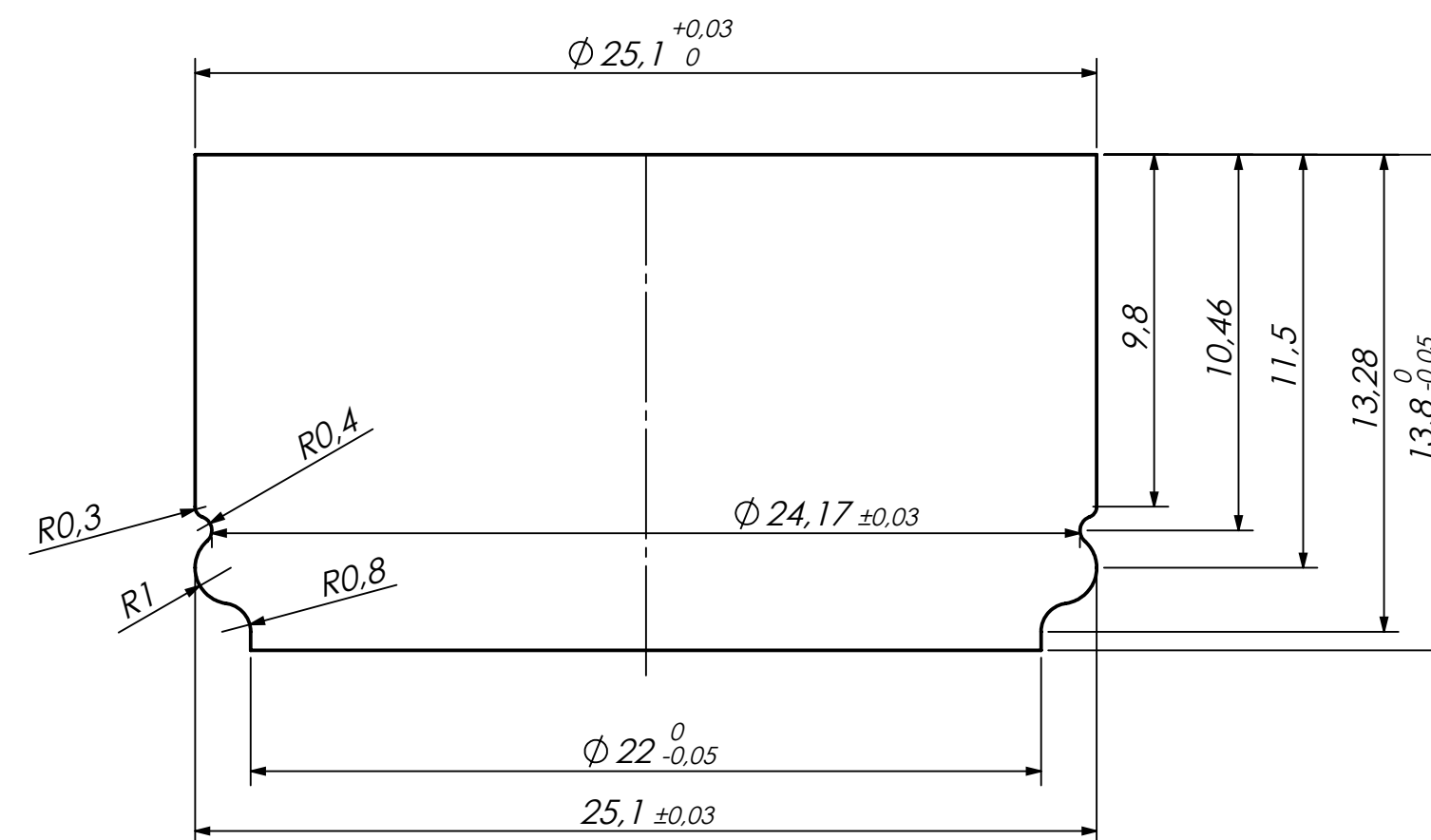
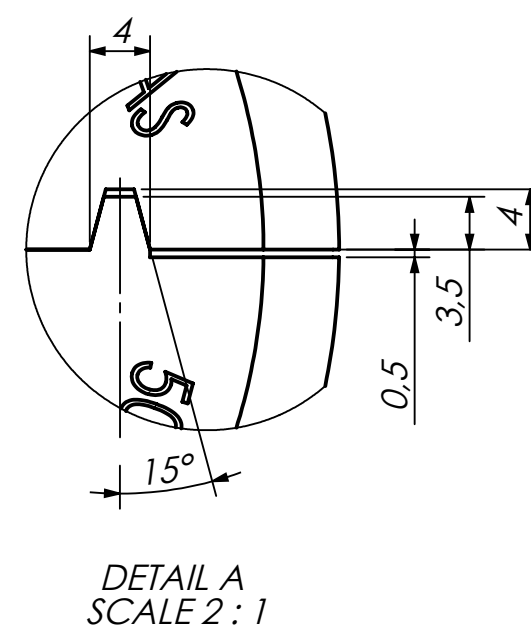
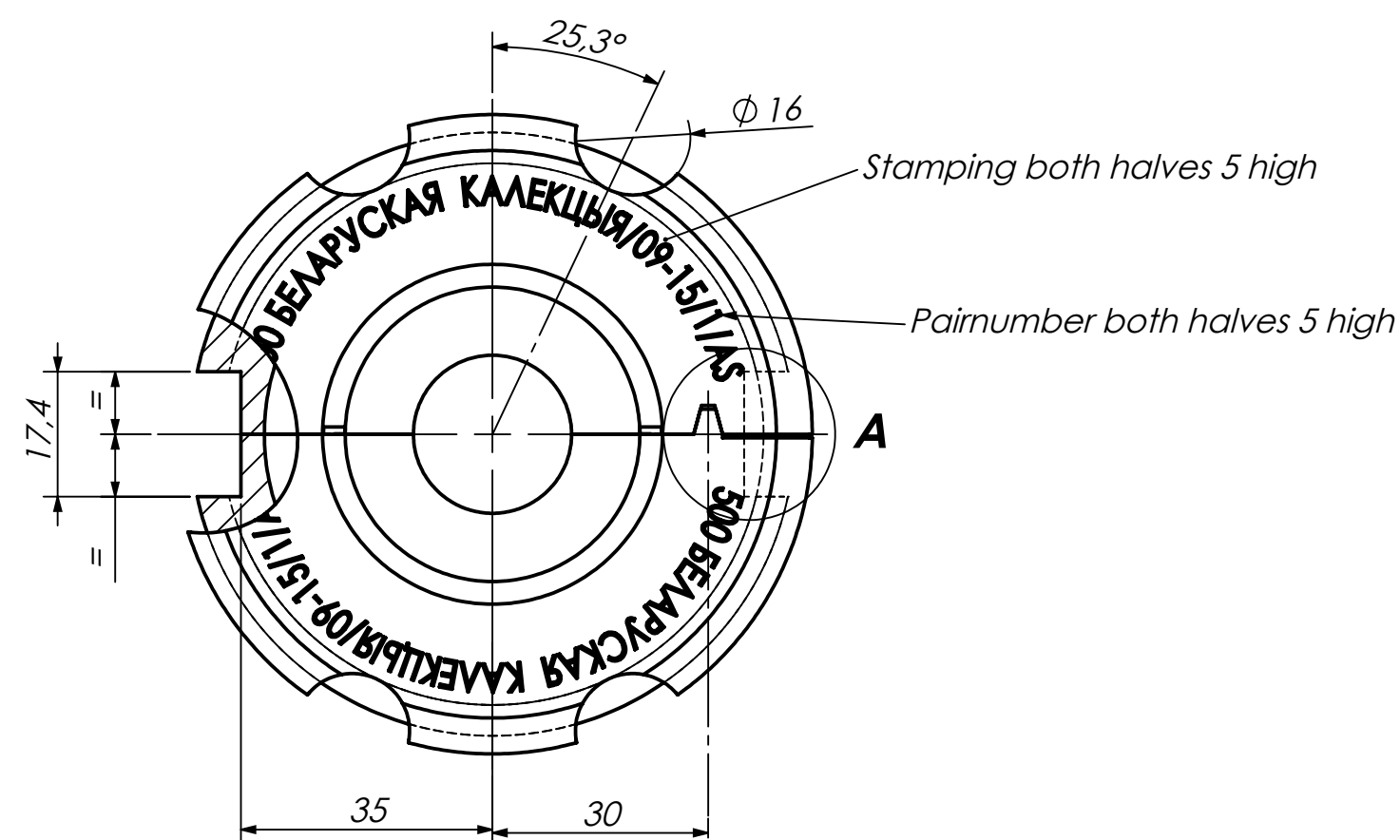
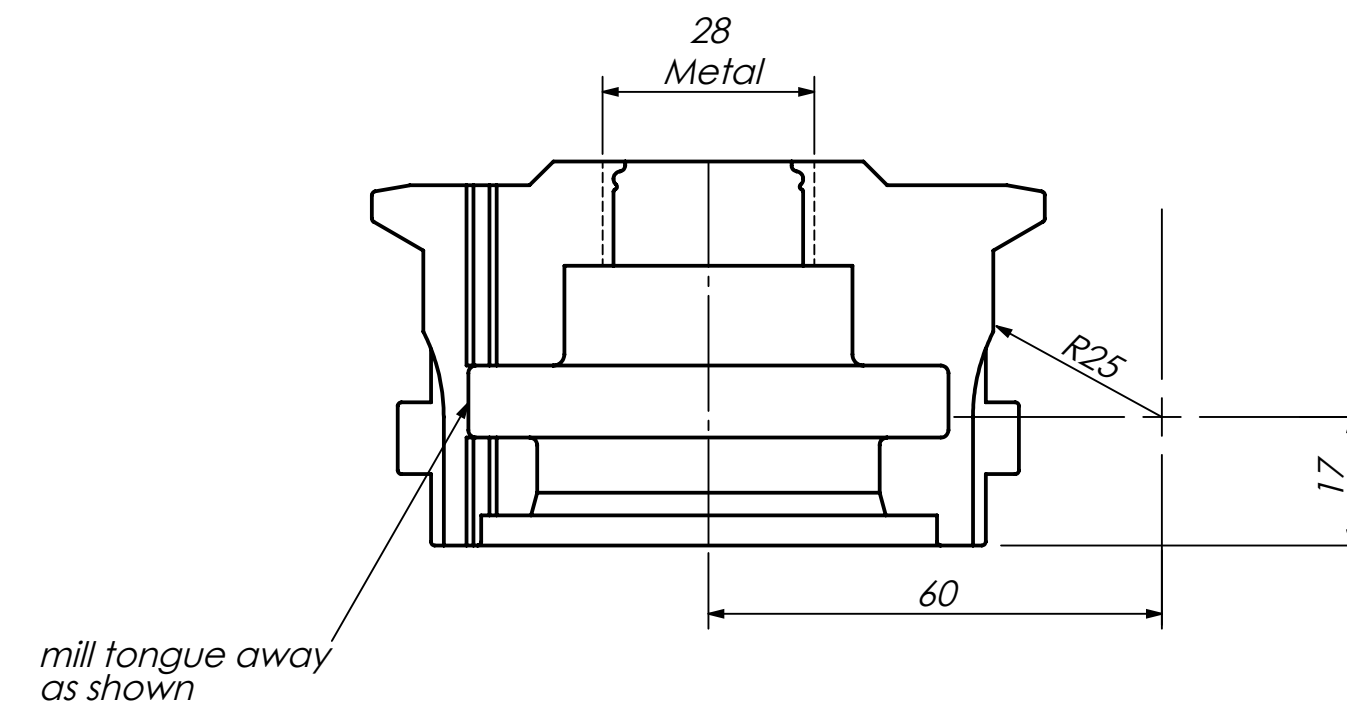
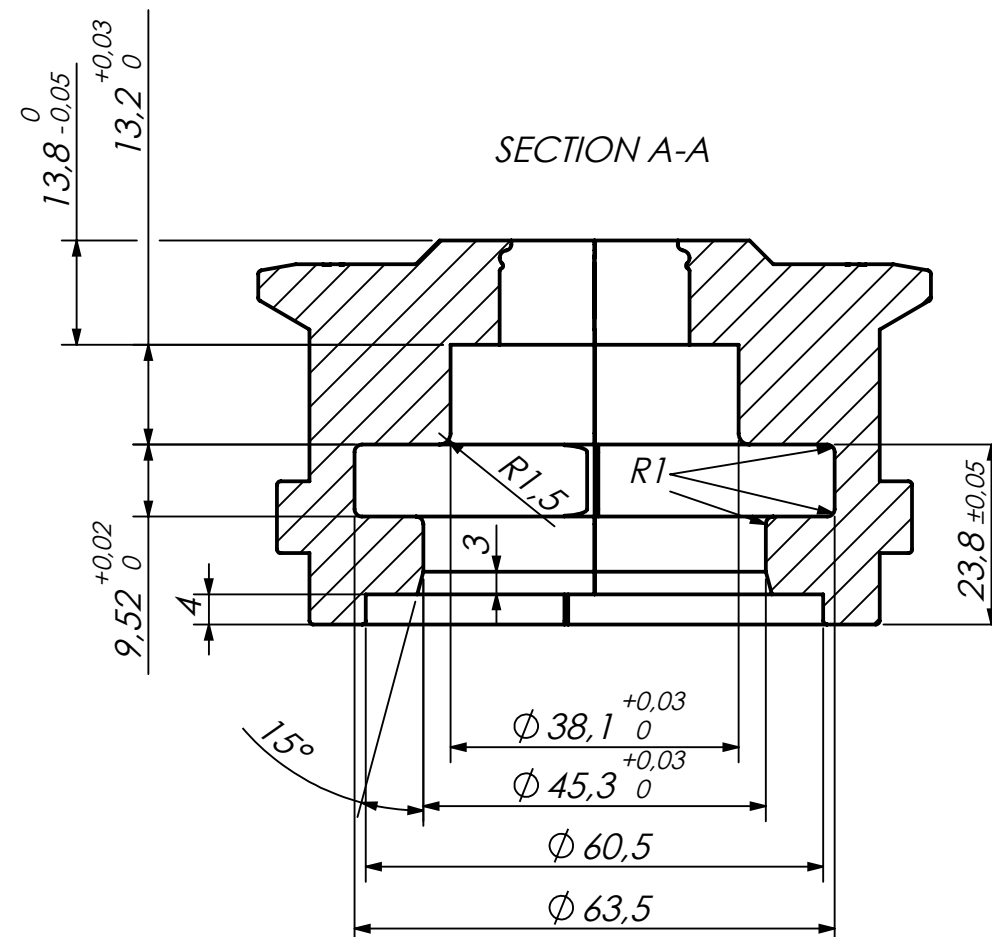
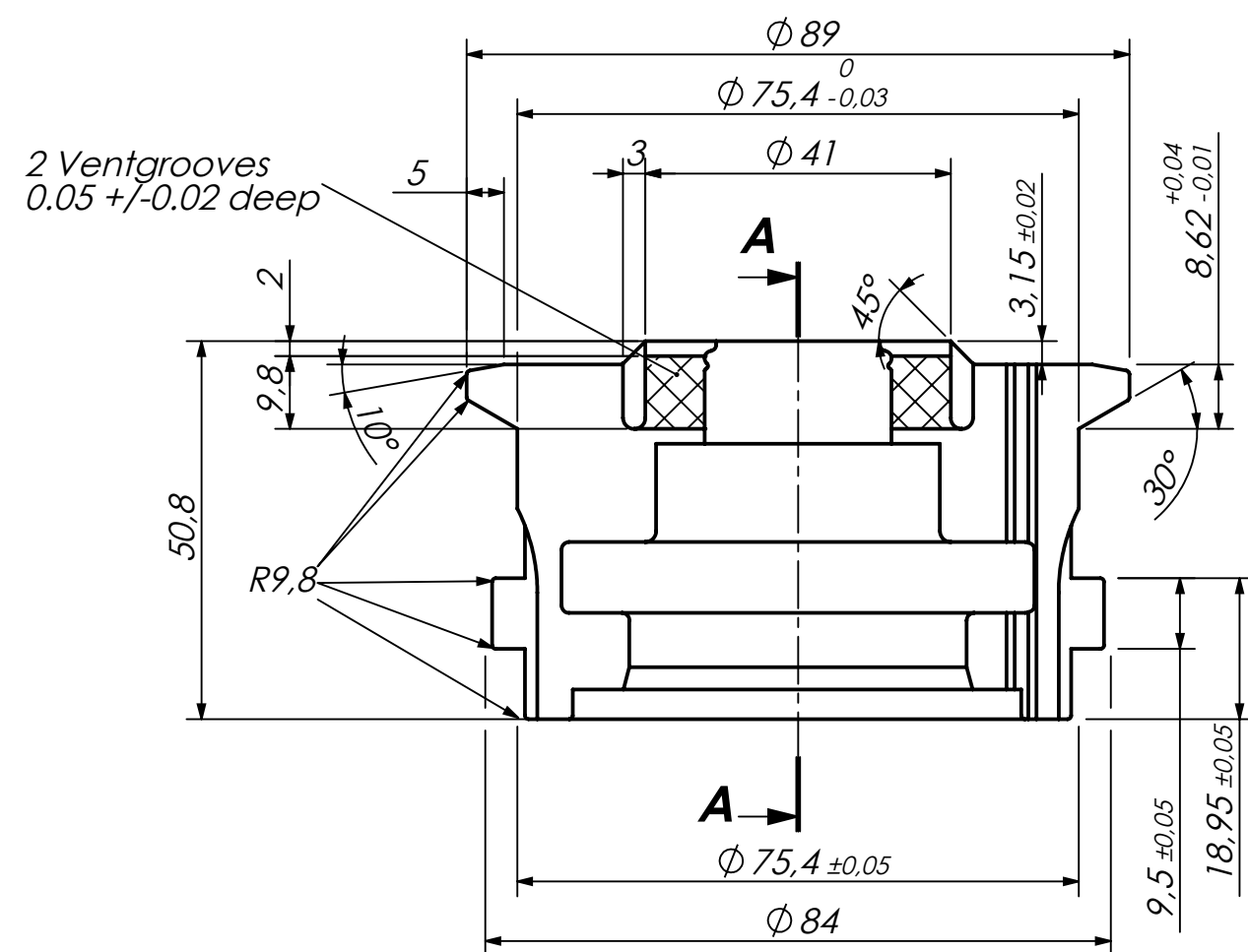


ALATI STUHNE Ltd

TOOLS FOR MANUFACTURE OF CONTAINER GLASS AND MACHINE PARTS

TITLE : 500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ

DRG No: AS384-09-01

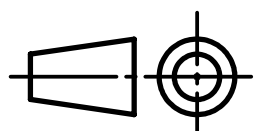



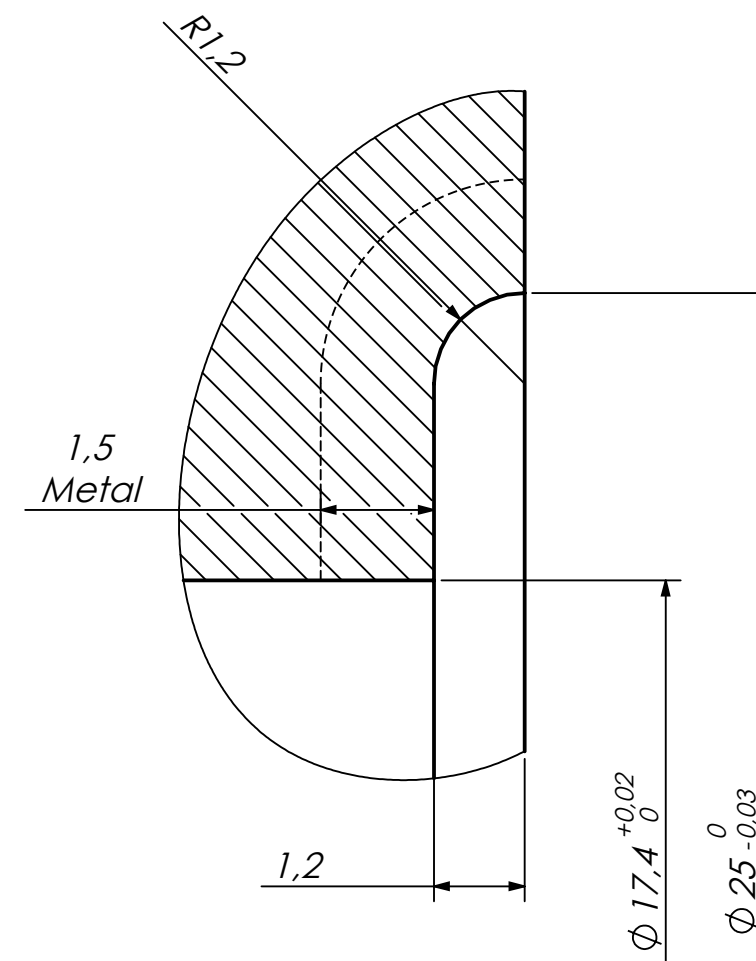
Scale 5:1

Cavity hard welded 1 mm bigger then biggest diameter

INVERT CENTRE : -
H' DIMENSION : -
ASSEMBLY : -

"C; ? ""%.) & % Ž&\$\$("%

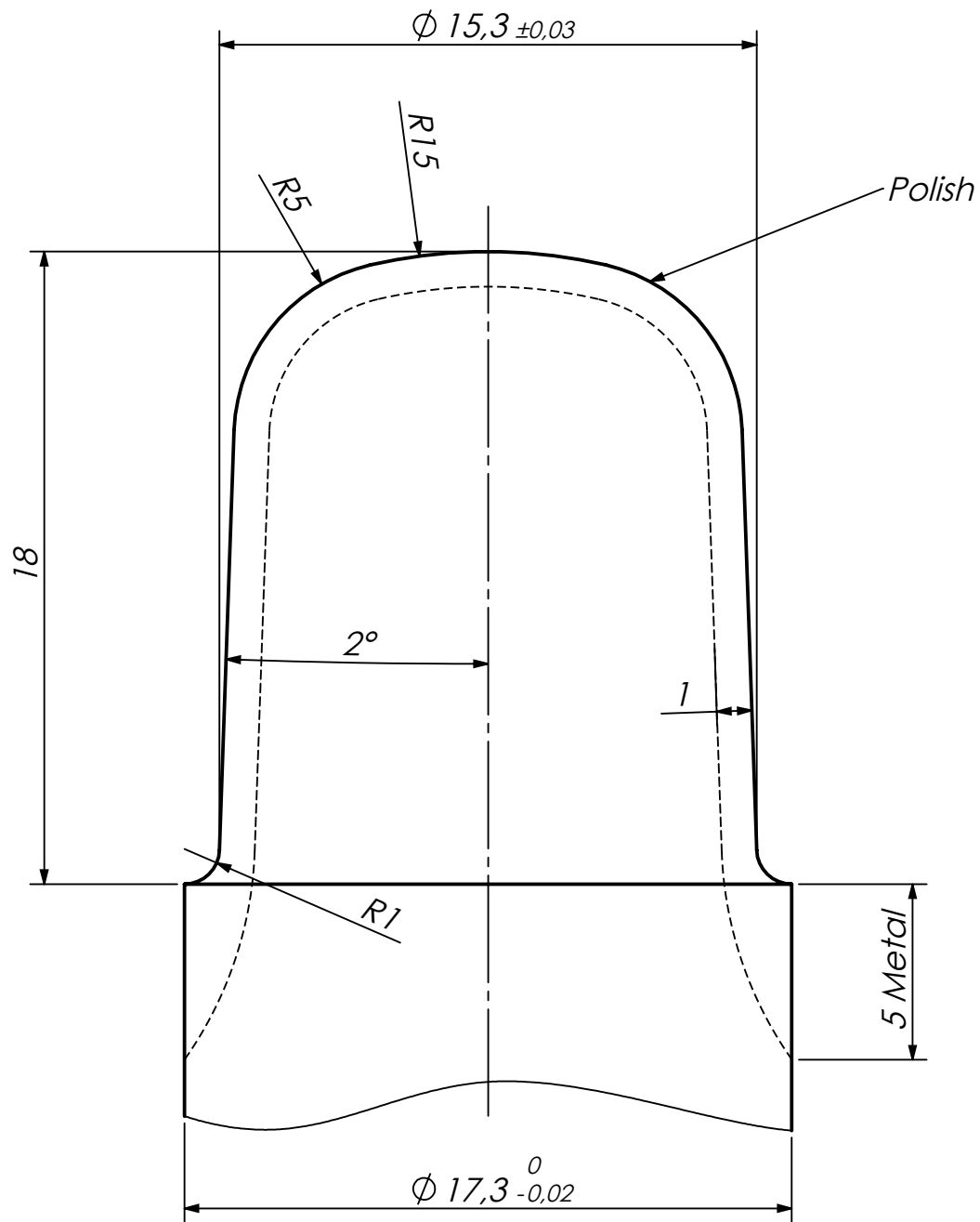
		TOLERANCES : UNLESS OTHERWISE STATED DIMS. 0.0 ±0.2 DIMS. 0.00 ±0.05 HALF & HALF MAX :0.20 CONCENTRICITY :0.05		ITEM : NECKRING	
MATERIAL : STANDARD CI		MACH : BB DG 5 1/2		 ALATI STUHNE Ltd TOOLS FOR MANUFACTURE OF CONTAINER GLASS AND MACHINE PARTS	
QUANTITY : 2		SCALE : 1:1		TITLE : 500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ	
DATE :18-4-2016		DESIGNER: JBB		DRG No: AS384-10-01	
CUSTOMER : ELIVOZO					



DRG No: AS384-11-01

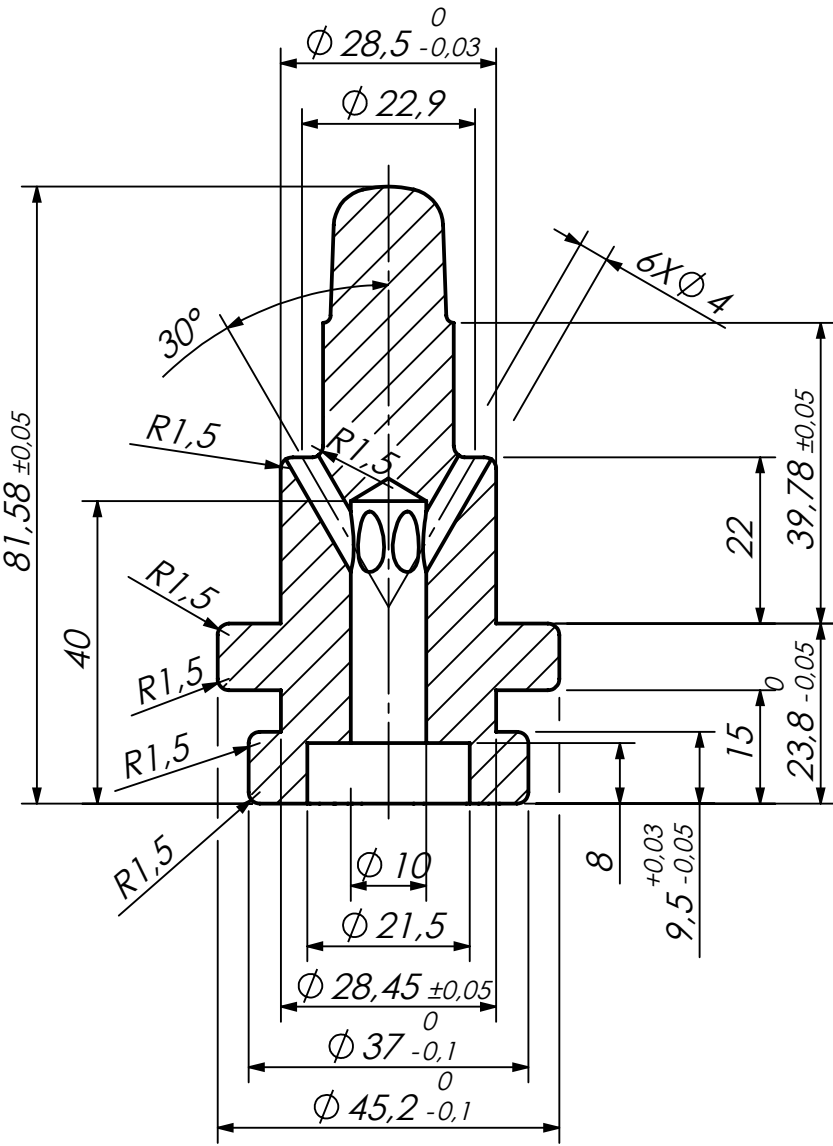
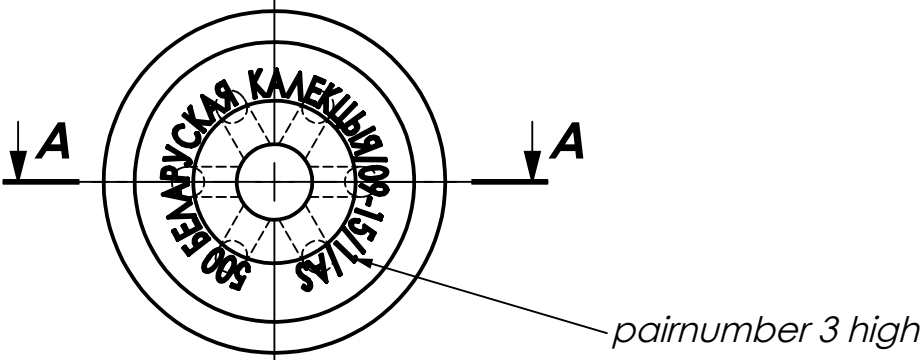
DRG No: AS384-11-01

HARD WELD PLUNGER TIP 1 MM DEEP



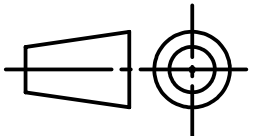

Scale 5:1

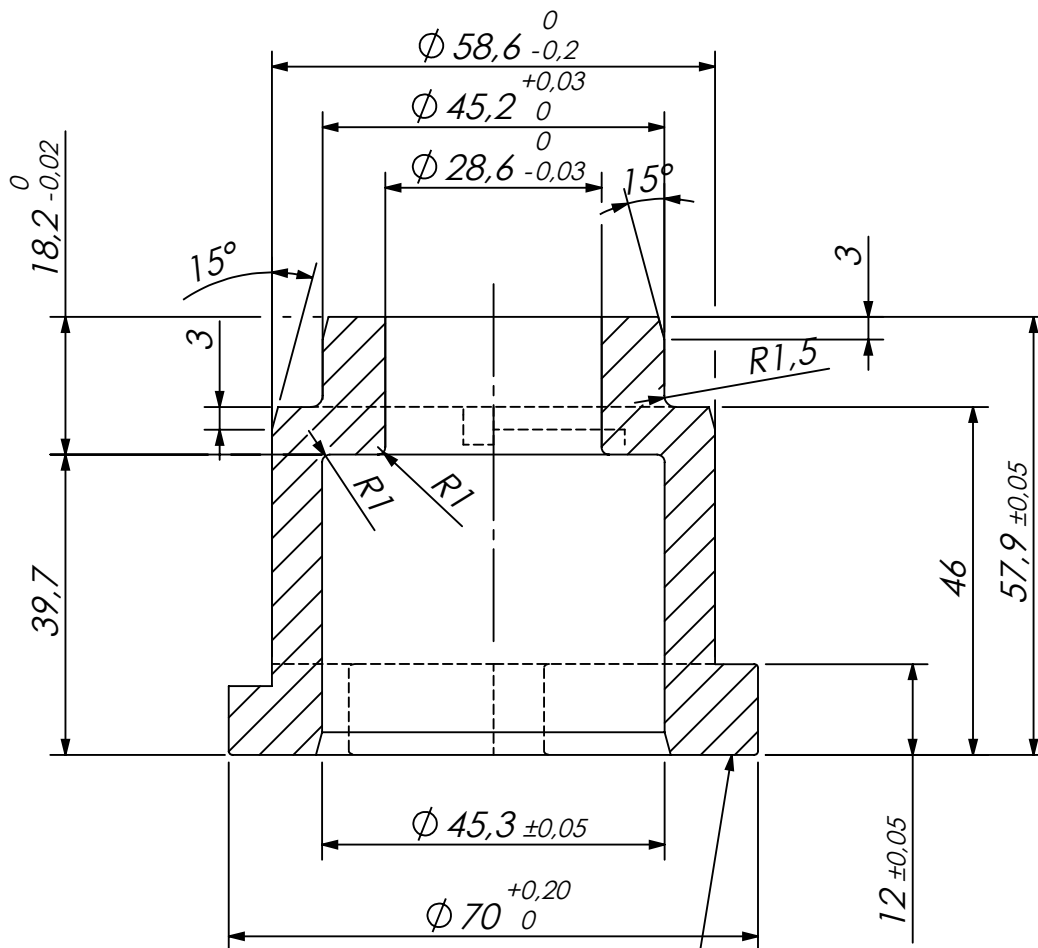
“C; ? “% .) & (\$Z&\$'\$(' %



SECTION A-A

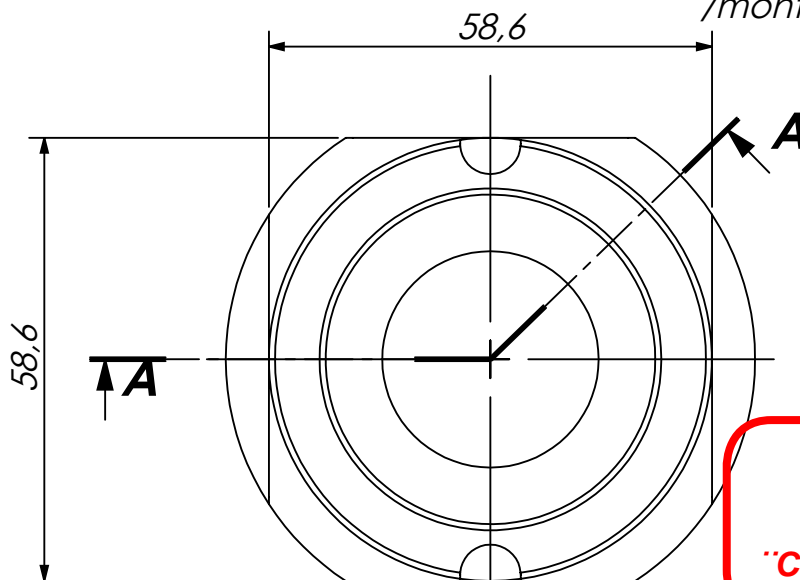
INVERT CENTRE :-
H' DIMENSION :-
ASSEMBLY :-

 <p>TOLERANCES : UNLESS OTHERWISE STATED DIMS. 0.0 ±0.2 DIMS. 0.00 ±0.05 HALF & HALF MAX :0.20 CONCENTRICITY :0.05</p>		ITEM : PLUNGER	
MATERIAL : Aisi 304		 ALATI STUHNE Ltd TOOLS FOR MANUFACTURE OF CONTAINER GLASS AND MACHINE PARTS	
QUANTITY : 2		TITLE : 500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ	
DATE :18-4-2016		DRG No: AS384-12-01	
CUSTOMER : ELIVOZO			
MACH : BB DG 5 1/2		SCALE : 1:1	
DESIGNER: JBB			

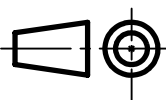


SECTION A-A

stamping 4 high
500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ
/month-year/pairnr./AS



“C; ? ““%.)’ .& ž&\$’\$(‘%”



TOLERANCES : UNLESS OTHERWISE STATED
DIMS. 0.0 ± 0.2
DIMS. 0.00 ± 0.05
HALF & HALF MAX : 0.20
CONCENTRICITY : 0.05

ITEM : THIMBLE



ALATI STUHNE Ltd

MATERIAL : Steel

MACH : BB DG 5 1/2

TOOLS FOR MANUFACTURE OF CONTAINER GLASS AND MACHINE PARTS

QUANTITY : 2

SCALE : 1:1

TITLE : 500 БЕЛАРУСКАЯ КАЛЕКЦЫЯ

DATE : 18-4-2016

DESIGNER: JBB

DRG No: AS384-14-01

CUSTOMER : ELIVOZO