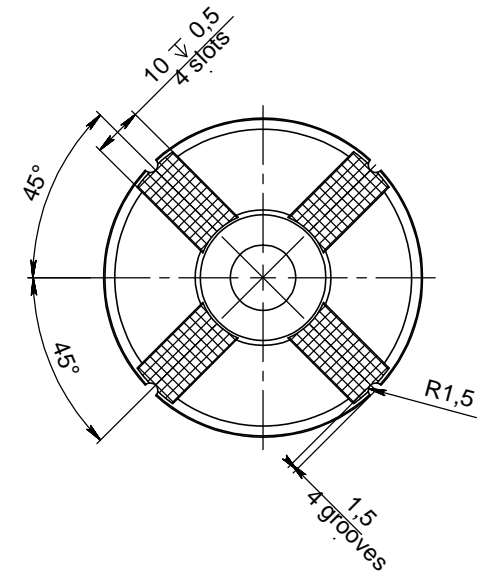


					19067-CX-60-Lamp1						
					Банка "Лампада-1"			Лит.	Масса	Масштаб	
Изм.	Лист	№ докум.	Подп.	Дата							
Разраб.				01.07.19							
Пров.											
Т.контр.											
					Стекло тарное			Лист		Листов	
Н.контр.											
Утв.											



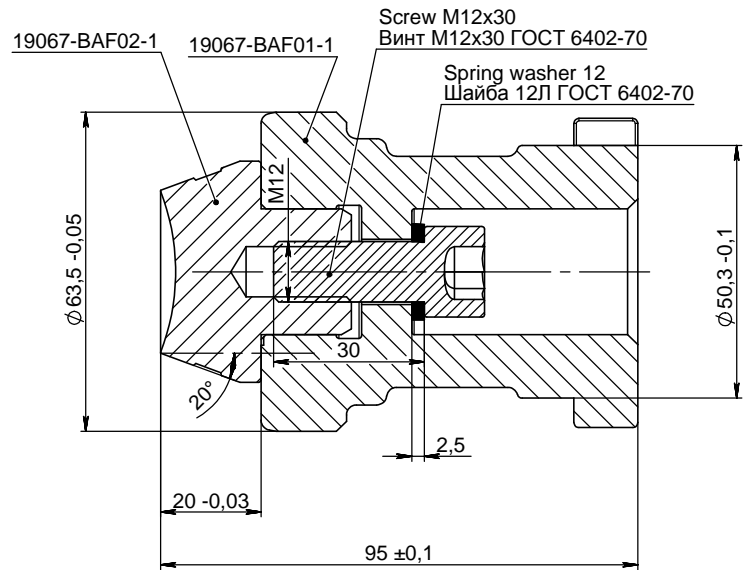
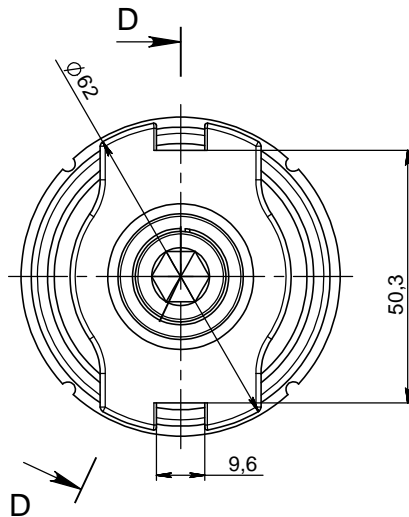
Technical drawing of a mechanical part showing a cross-section. The drawing includes the following dimensions and features:

- Overall width: 12.7 - 0.1
- Top fillet radius: $R1_{1.6}$
- Internal fillet radius: $R1$
- Internal chamfer: G
- Internal diameter: $\phi 62$
- Internal length: 1
- Welding details: Indicated by hatched areas and the word "welding".

1. Unspecified limit deviations of dimensions H12, h12, +/-IT12/2
2. Mark : 19067 / 0772V01-Lamp1
Mark ordinal number
Depth of engraving 0.3mm
3. Surfaces G must be welded HRC 32...38
4. * - Reference only dimensions

MATERIAL: МАТЕРИАЛ:	Cast Iron Чугун	MACHINE: МАШИНА: Bottero-PB-DG-5 1/2"	JOB TITLE/НАЗВАНИЕ РАБОТЫ: CX-60-Lamp1	SCALE: МАСШТАБ: 1:1
WELDING: НАПЛАВКА:	bayonet байонет		DRAWING NUMBER/НОМЕР ЧЕРТЕЖА: 19067-BAF1-2	
QUANTITY: КОЛИЧЕСТВО:		DATE: ДАТА: 03.07.19		

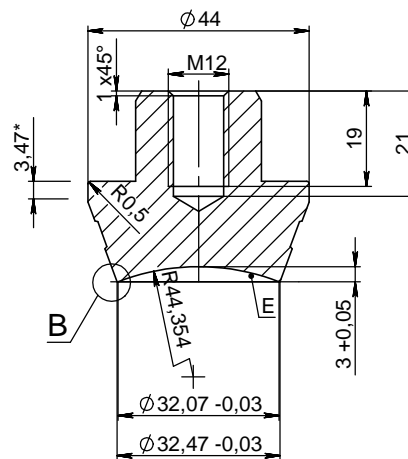
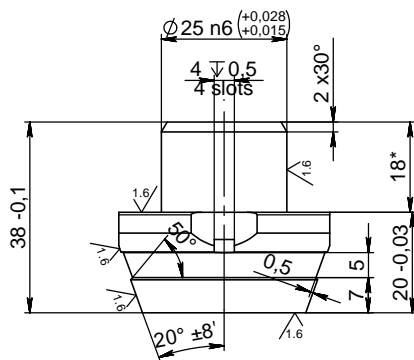
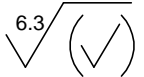
SECTION D-D



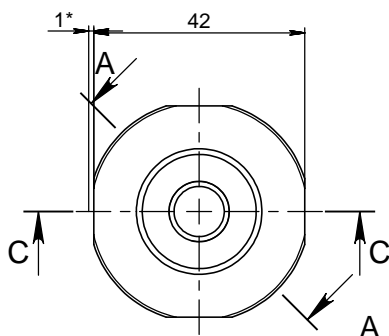
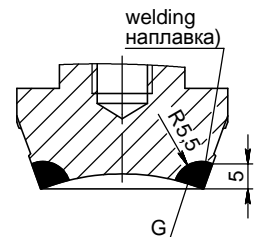
Screw M12x30
Винт М12х30 ГОСТ 6402-70

Spring washer 12
Шайба 12П ГОСТ 6402-70

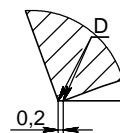
SECTION A-A



SECTION C-C

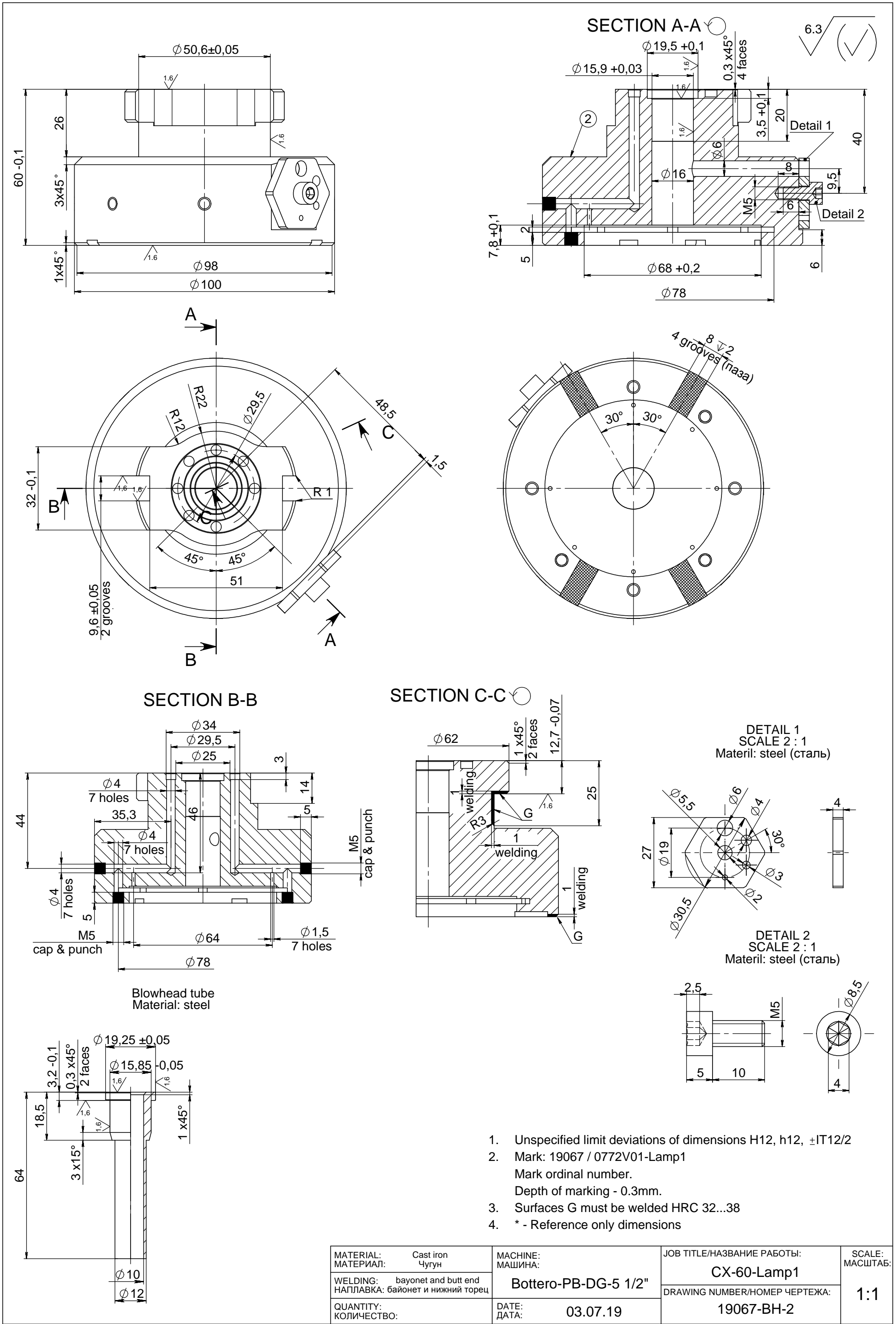


DETAIL VIEW B SCALE 5 : 1

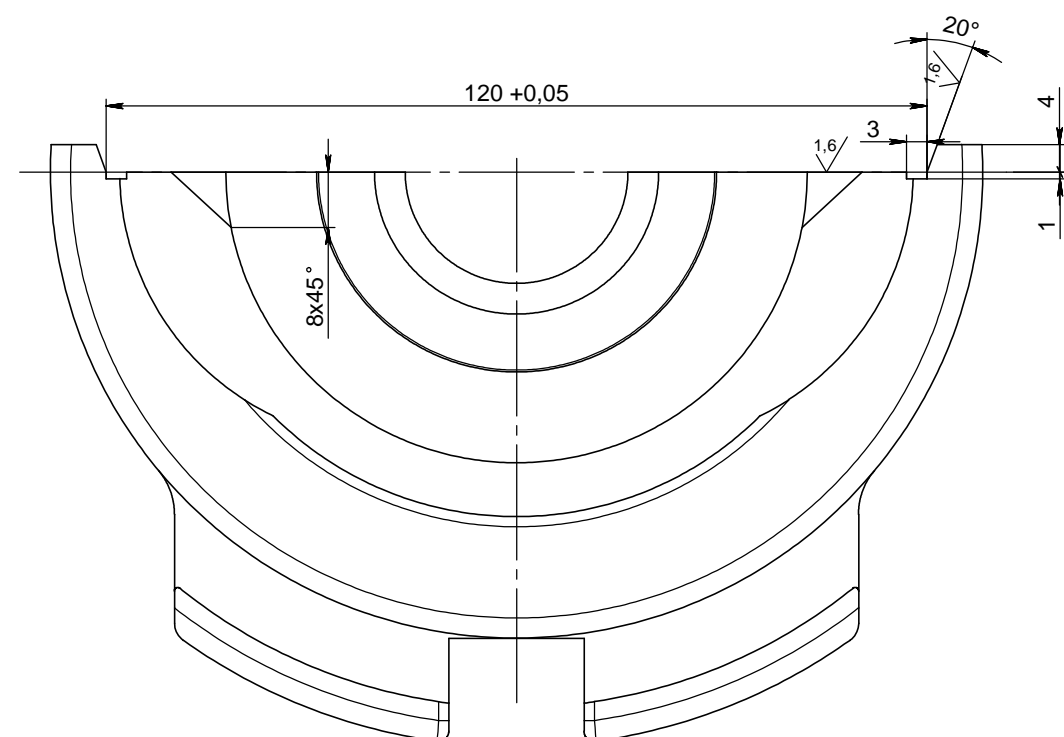


1. Unspecified limit deviations of dimensions H12, h12, +/-IT12/2
2. Mark: 19067 / 0772V01-Lamp1
Mark ordinal number.
Depth of marking - 0.3mm.
3. Surface E must be polished Ra 0,16
4. Keep sharp edge D
5. Edge D must be metallized HRC 32...38
6. * - Reference only dimensions

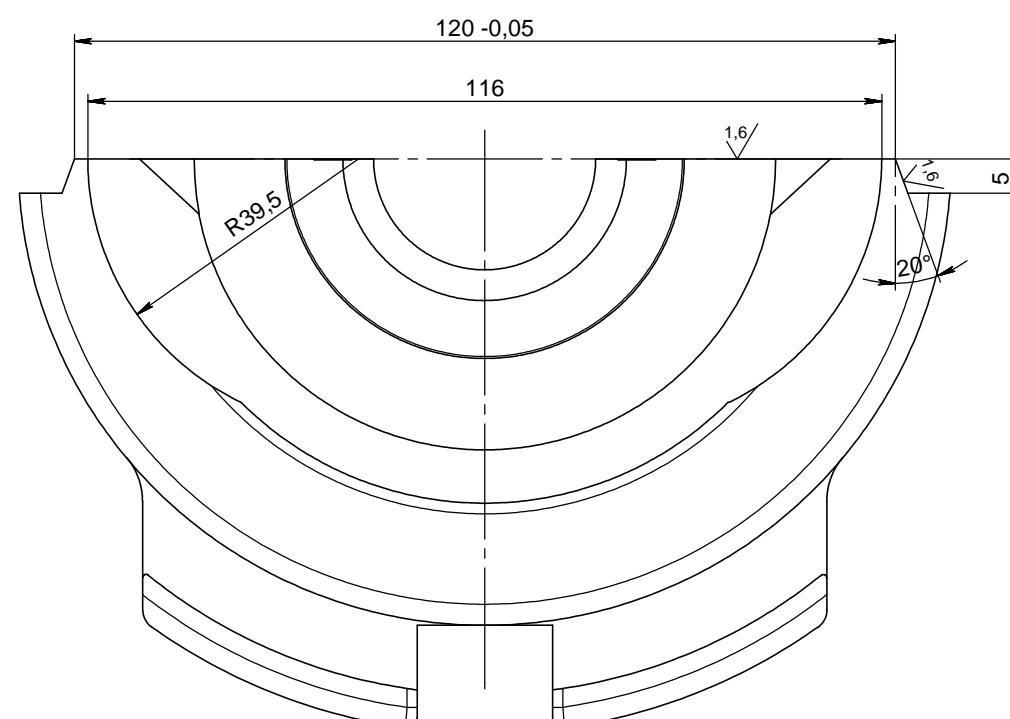
MATERIAL: МАТЕРИАЛ:	Cast Iron Чугун	MACHINE: МАШИНА:	JOB TITLE/НАЗВАНИЕ РАБОТЫ:	SCALE: МАСШТАБ:
WELDING: НАПЛАВКА:	match по рабочей кромке	Bottero-PB-DG-5_1/2"	CX-60-Lamp1	1:1
QUANTITY: КОЛИЧЕСТВО:		DATE: ДАТА:	DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:	
		03.07.19	19067-BAF2-2	



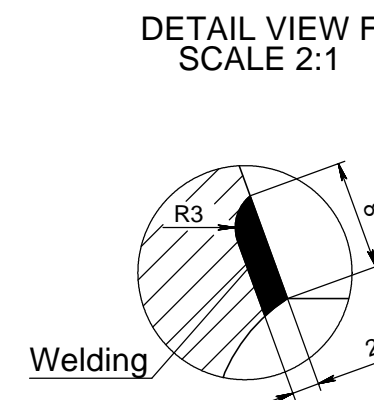
6.3



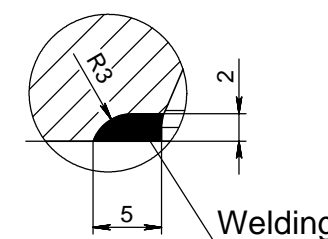
DETAIL A
(FEMALE HALF)



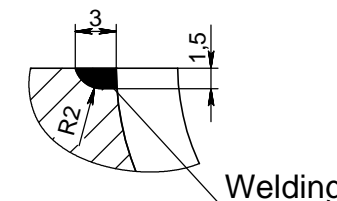
DETAIL B
(MALE HALF)



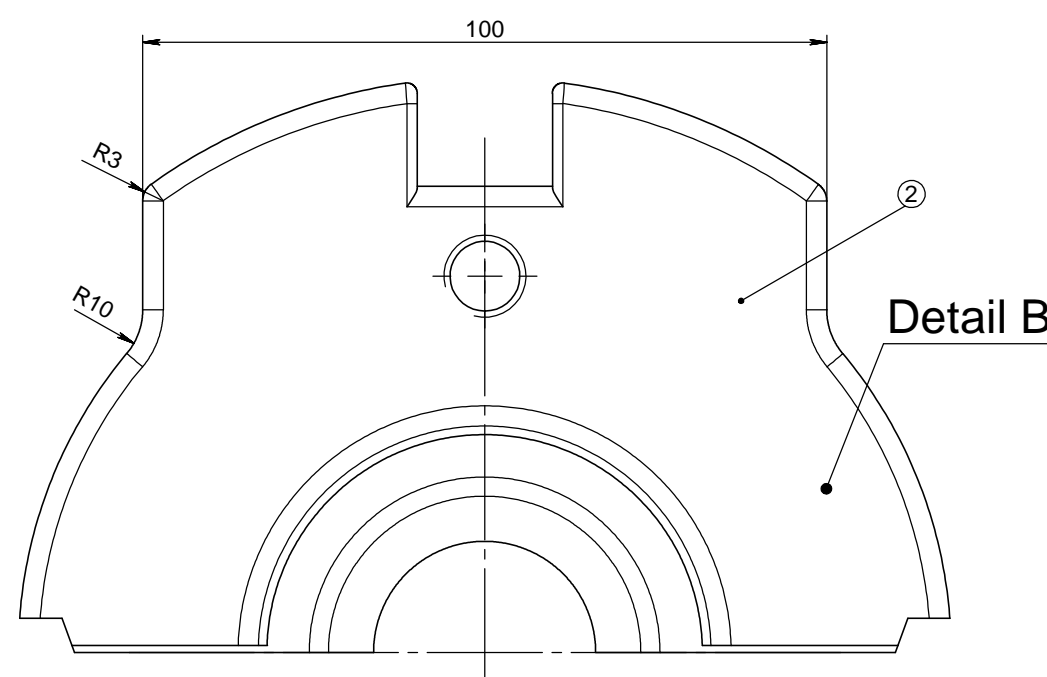
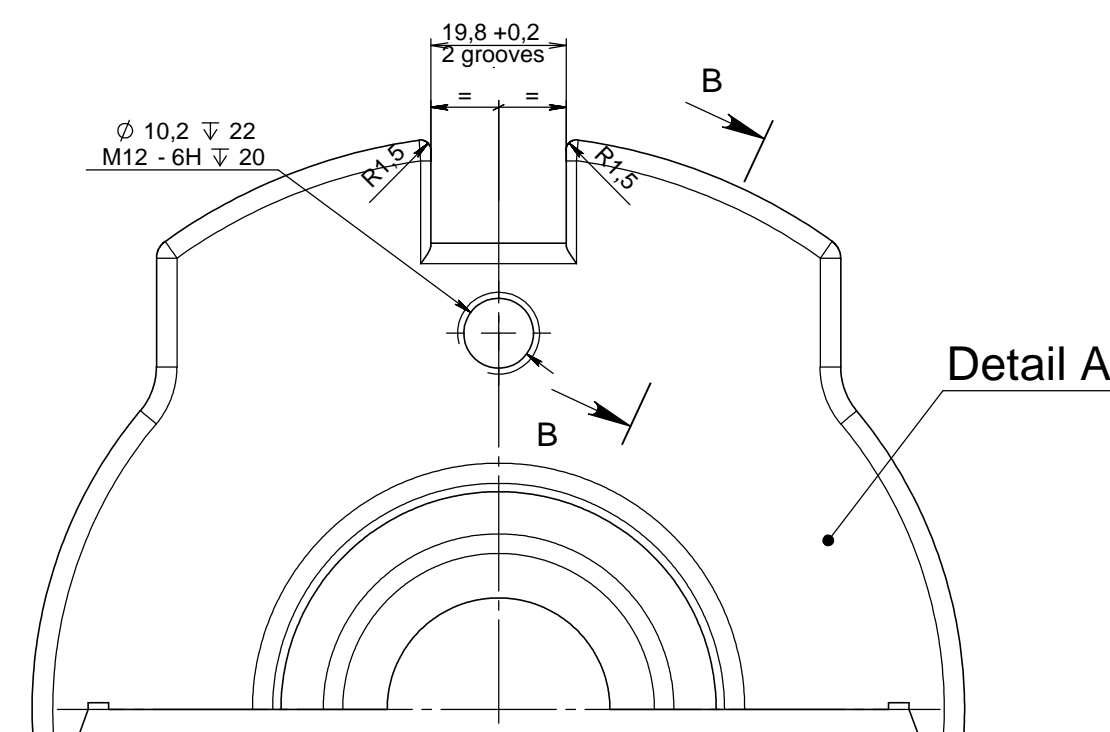
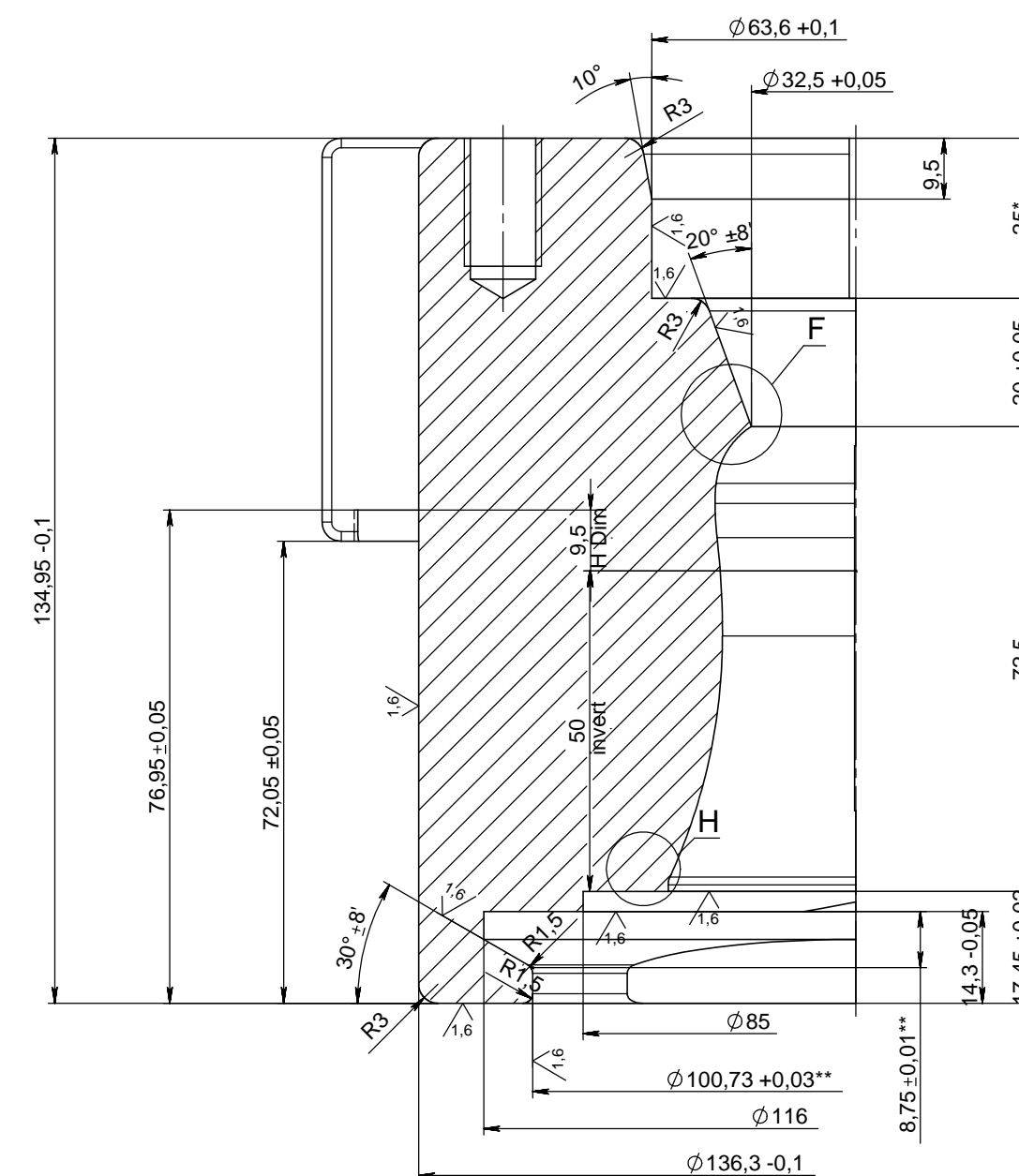
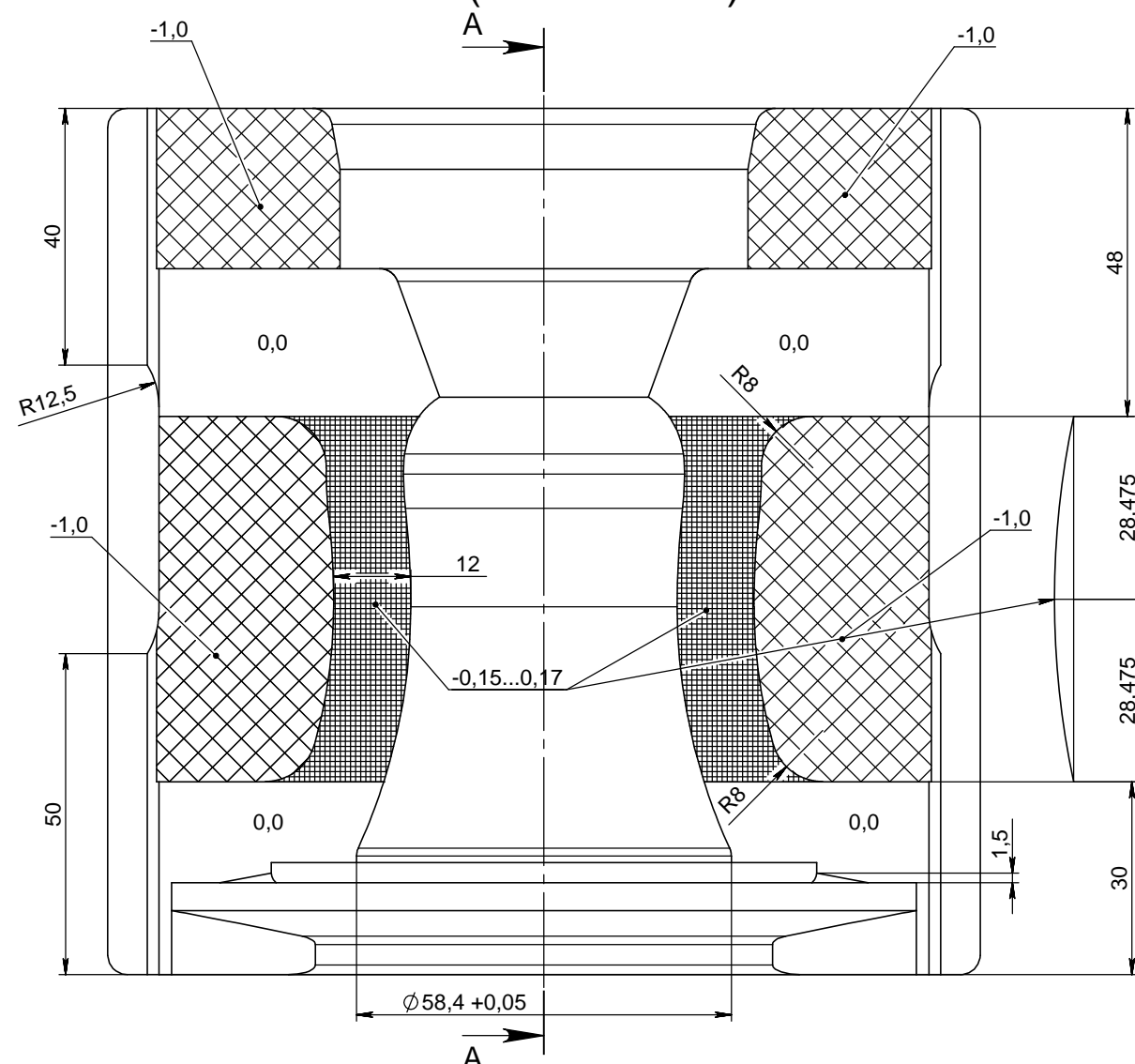
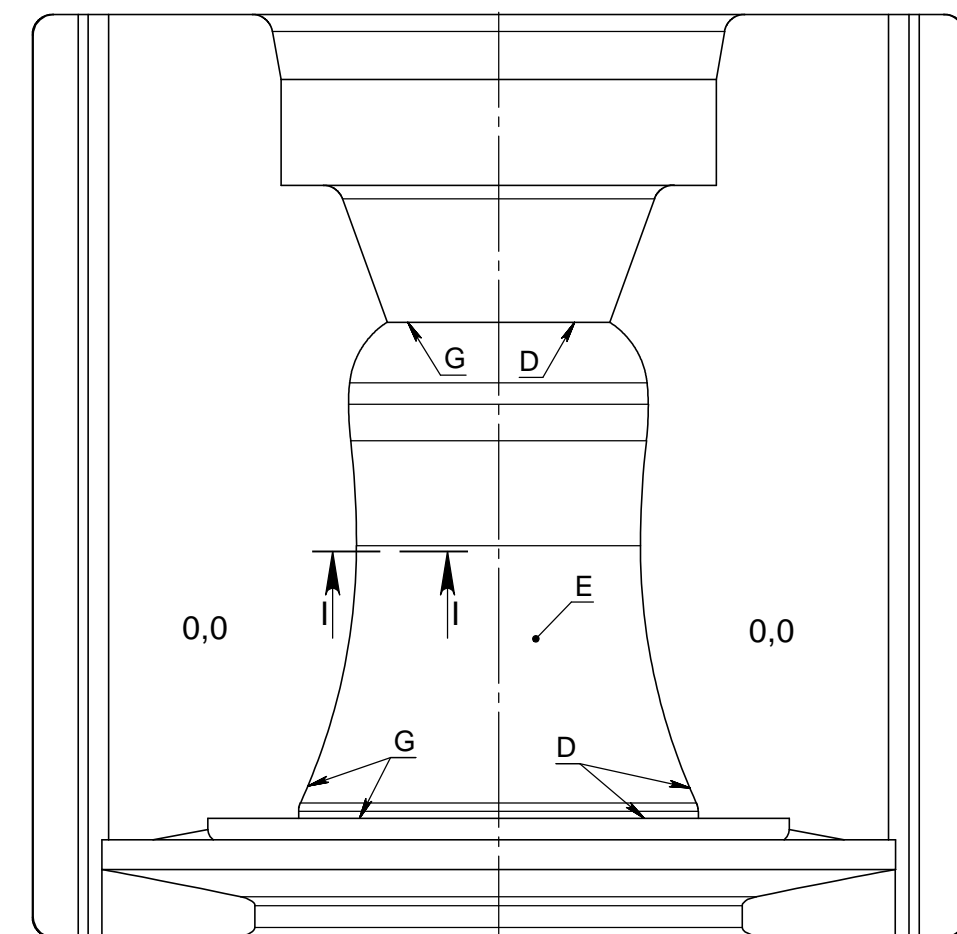
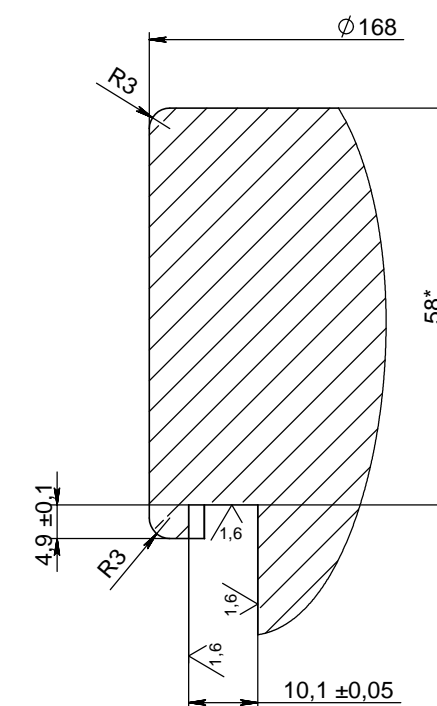
DETAIL VIEW H
SCALE 2:1



SECTION I-I
SCALE 2 : 1

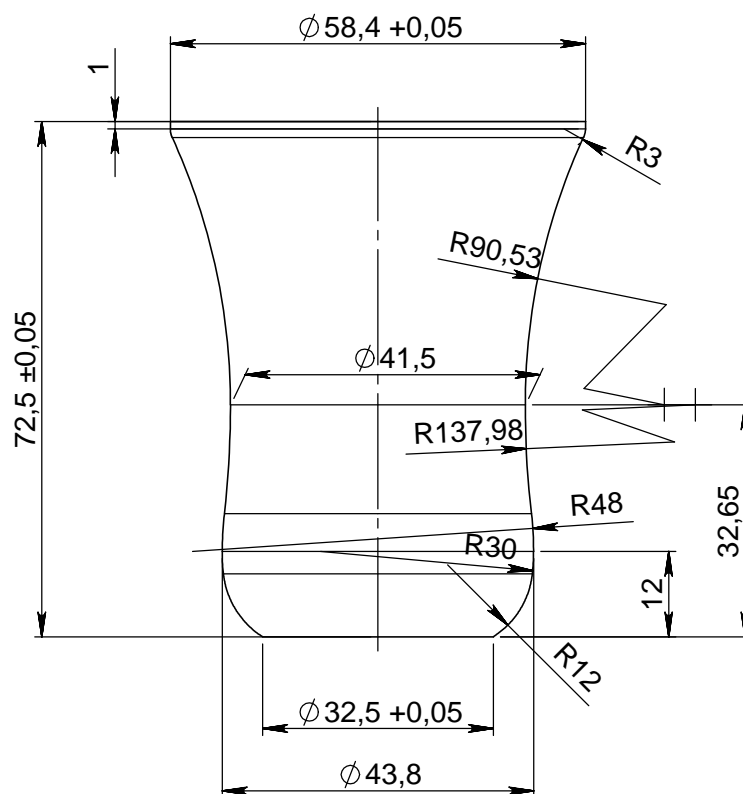


SECTION B-B



- Unspecified limit deviations of dimensions H14, h14, +/-IT14/2
- Mark: 19067 / 0772V01-Lamp1
Mark ordinal number
Depth of marking - 0.3mm.
- Details A and B must be marked with same ordinal number, processed and used together
- Edges G must be metallized HRc 32...38
- Forming surface E must be polished Ra 0,16
- Keep sharp edge D
- * - Reference only dimensions
- ** - Must be controlled using complex caliber
- - dimension must be controlled and additionally put on the checklist

ASSEMBLY NUMBER: НОМЕР СБОРКИ:	1	MATERIAL: МАТЕРИАЛ:	Cast iron Чугун	MACHINE: МАШИНА:	Bottero-PB-DG-5_1/2"	JOB TITLE/НАЗВАНИЕ РАБОТЫ:	CX-60-Lamp1	SCALE: МАСШТАБ:	1:1
INVERT CENTRE: ИНВЕРТ:	50	WELDING: НАПЛАВКА:	all edges по всем кромкам	DATE: ДАТА:	03.07.19	DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:	19067-BLK1-2		
'H' DIMENSION: РАЗМЕР 'H': (РАССТОЯНИЕ ОТ ОСИ ФОРМЫ ДО ВЕРХНЕЙ ГУБКИ)	9,5	QUANTITY: КОЛИЧЕСТВО:							

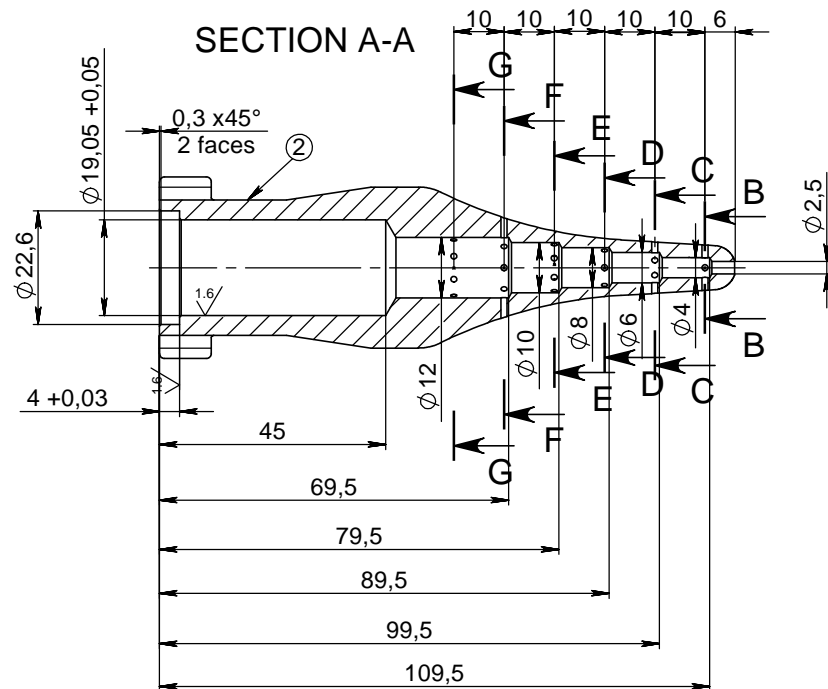
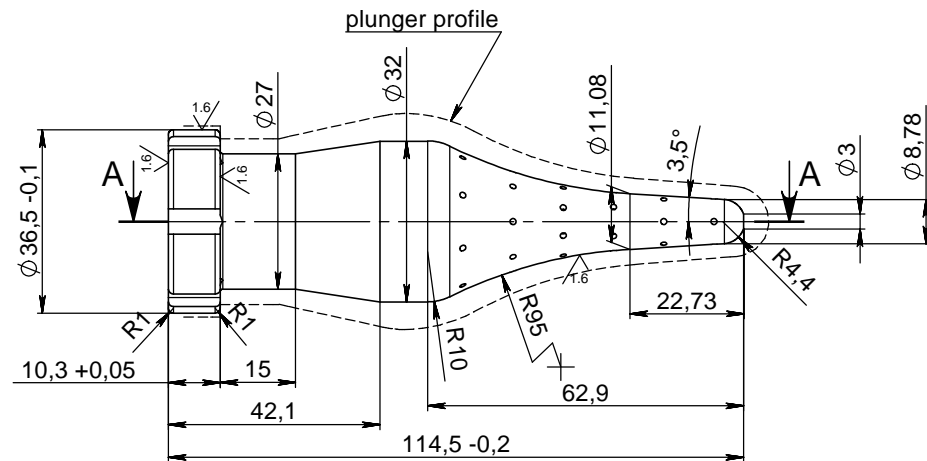


Displacement :

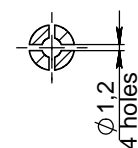
Blank mould	116,61 ml $\pm 0,6$ ml
Baffle	1,23 ml
Blank mould+Baffle	117,84 ml $\pm 0,6$ ml

* - reference dimension
 ** - crosspoint dimension

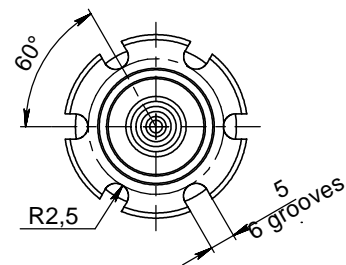
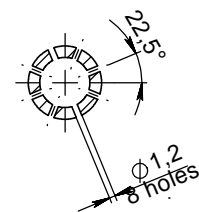
MACHINE: МАШИНА: Bottero-PB-DG-5 1/2"	JOB TITLE/НАЗВАНИЕ РАБОТЫ: CX-60-Lamp1	SCALE: МАСШТАБ: 1:1
	DRAWING NUMBER/НОМЕР ЧЕРТЕЖА: 19067-BLK12-2	
DATE: ДАТА: 03.07.19		



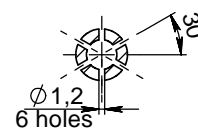
SECTION B-B



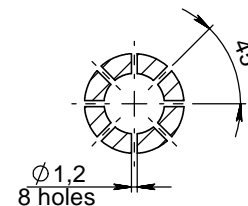
SECTION E-E



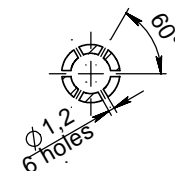
SECTION C-C



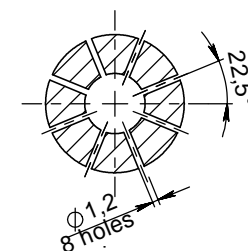
SECTION F-F



SECTION D-D



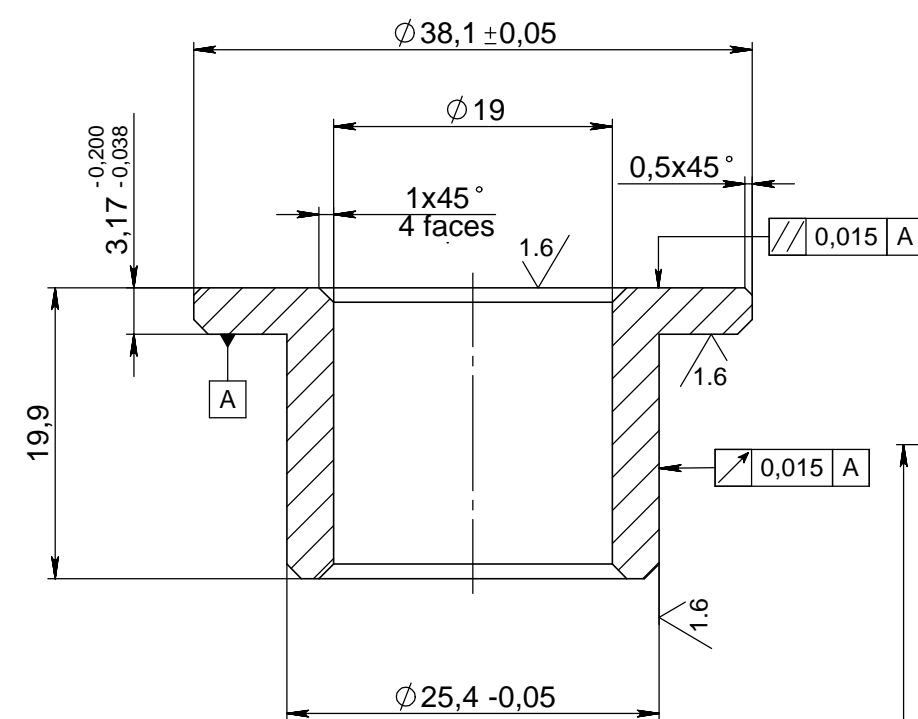
SECTION G-G



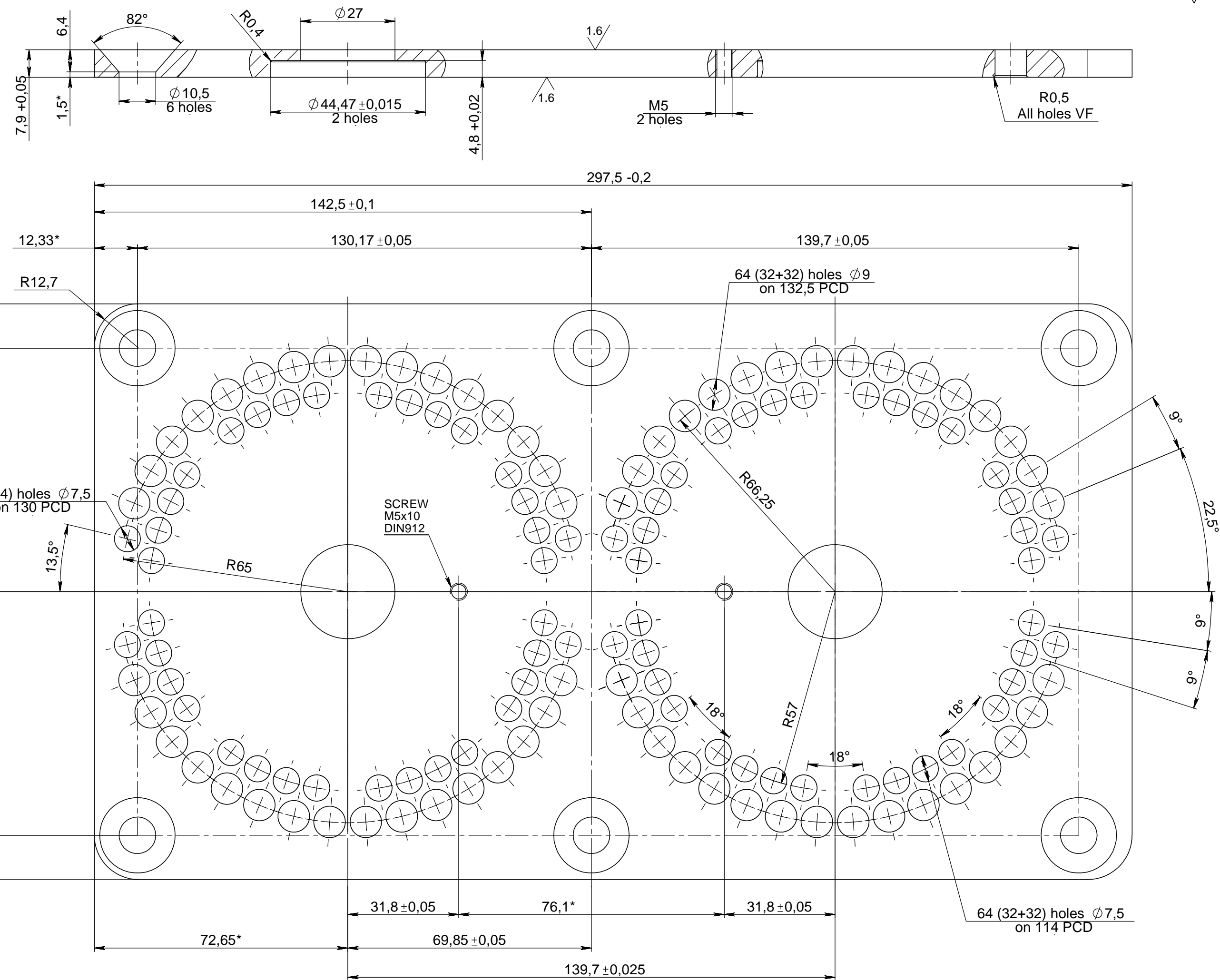
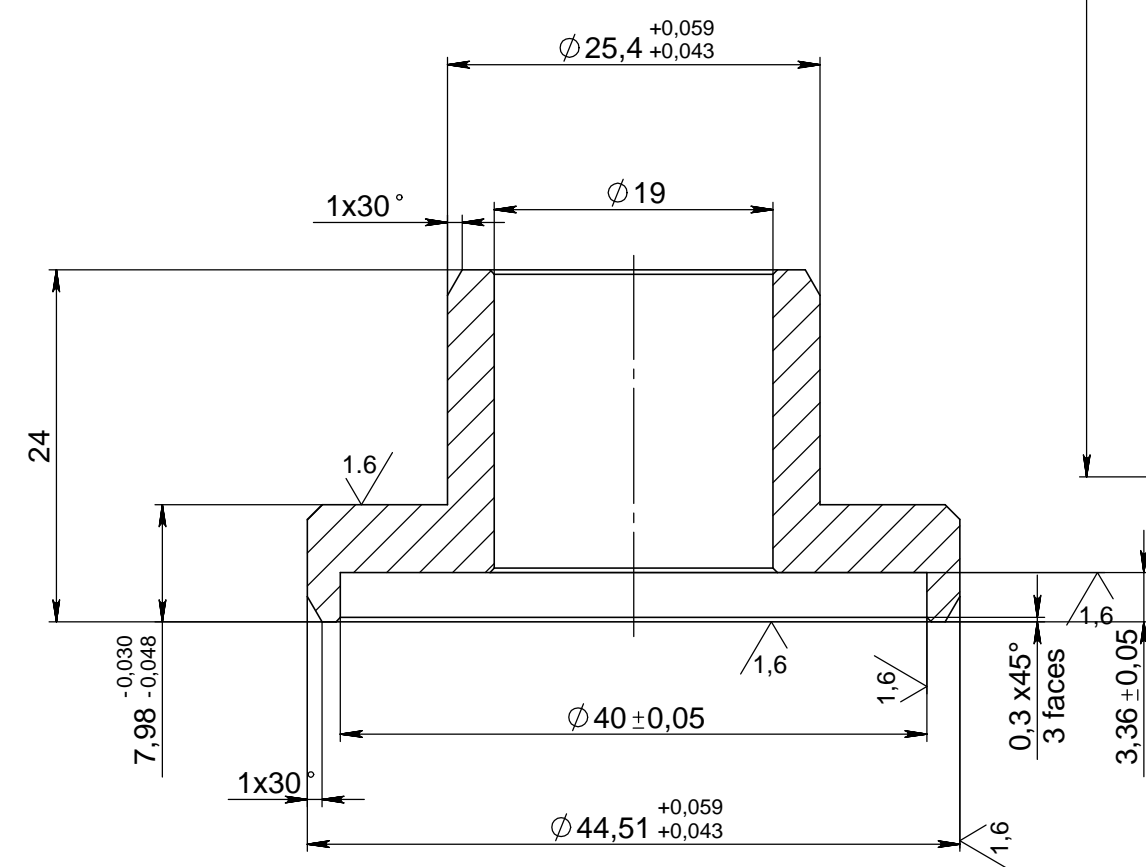
1. Unspecified limit deviations of dimensions H14, h14, +/-IT14/2
2. Mark detail's designation: 19067 / 0772V01-Lamp1
Mark ordinal number
Depth of engraving 0.3mm/ Height of font=5 mm
3. * - Reference only dimensions

MATERIAL: МАТЕРИАЛ:	Steel Сталь	MACHINE: МАШИНА:	JOB TITLE/НАЗВАНИЕ РАБОТЫ:	SCALE: МАСШТАБ:
WELDING: НАПЛАВКА:		Bottero-PB-DG-5_1/2"	CX-60-Lamp1	1:1
QUANTITY: КОЛИЧЕСТВО:		DATE: ДАТА:	DRAWING NUMBER/HOMEP ЧЕРТЕЖА:	
		03.07.19	19067-COO-2	

Locator
Scale 2 : 1
Material: steel



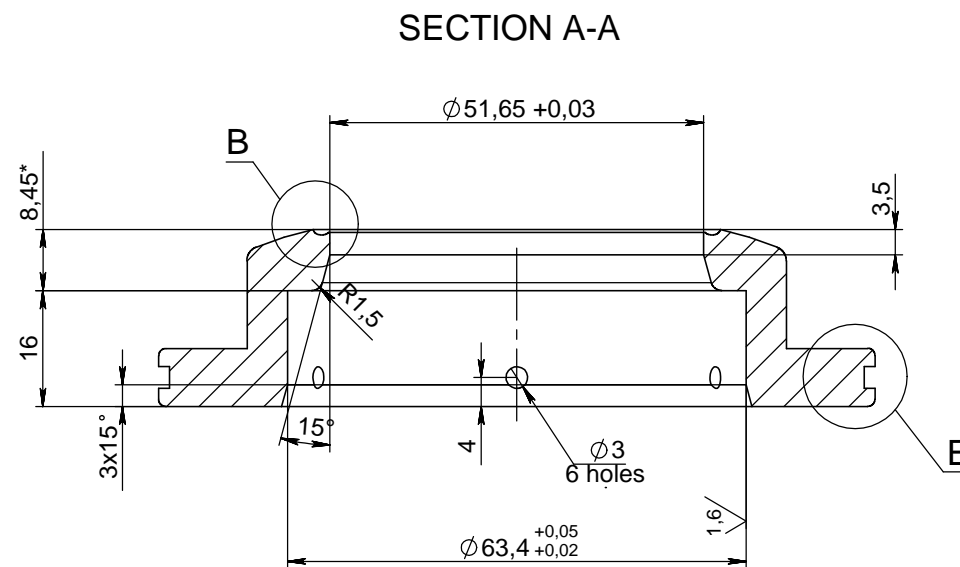
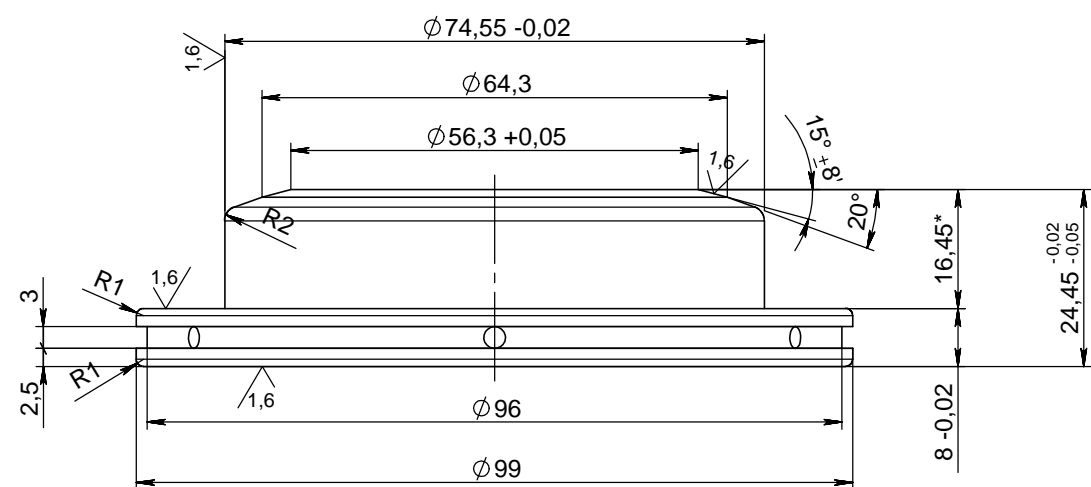
Retainer
Scale 2 : 1
Material: steel



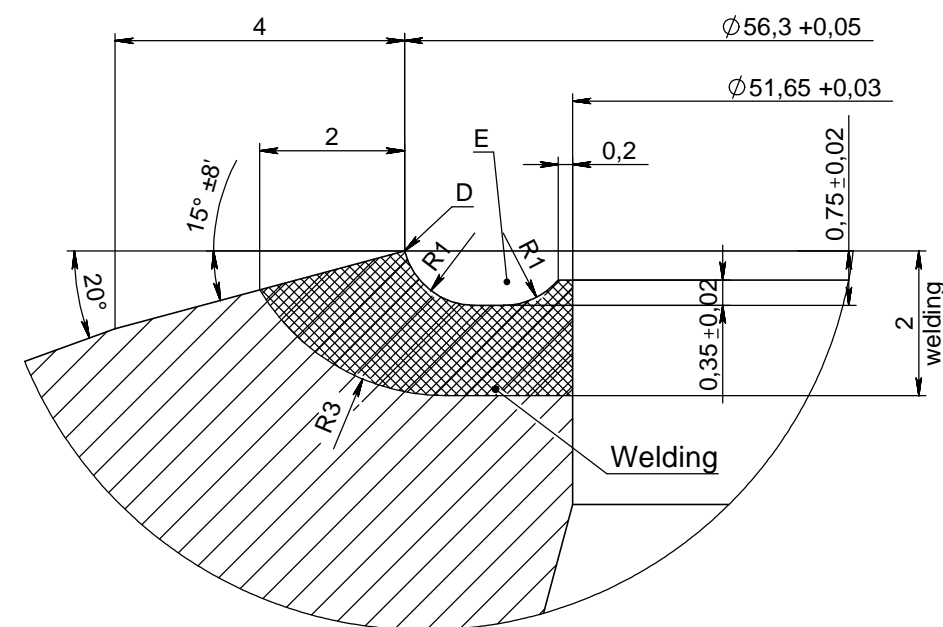
NAME	QUANTITY
Distribute plate	1
Locator	2
Retainer	2
Screw M5x10 DIN912	2

- Unspecified limit deviations of dimensions H12, h12, $\pm IT12/2$
- Mark: 19067 / 0772V01-Lamp1
Mark ordinal number
Depth of marking - 0.3mm.
- * - Reference only dimensions

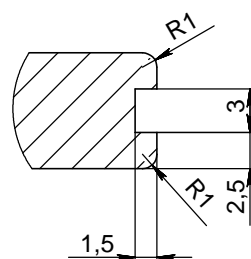
MATERIAL: МАТЕРИАЛ:	Сталь Steel	MACHINE: МАШИНА:	Bottero-PB-DG-5 1/2"	JOB TITLE/НАЗВАНИЕ РАБОТЫ:	CX-60-Lamp1	SCALE: МАСШТАБ:	1:1
WELDING: НАПЛАВКА:		DATE: ДАТА:	03.07.19	DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:	19067-DP-2		



DETAIL VIEW B
SCALE 10 : 1



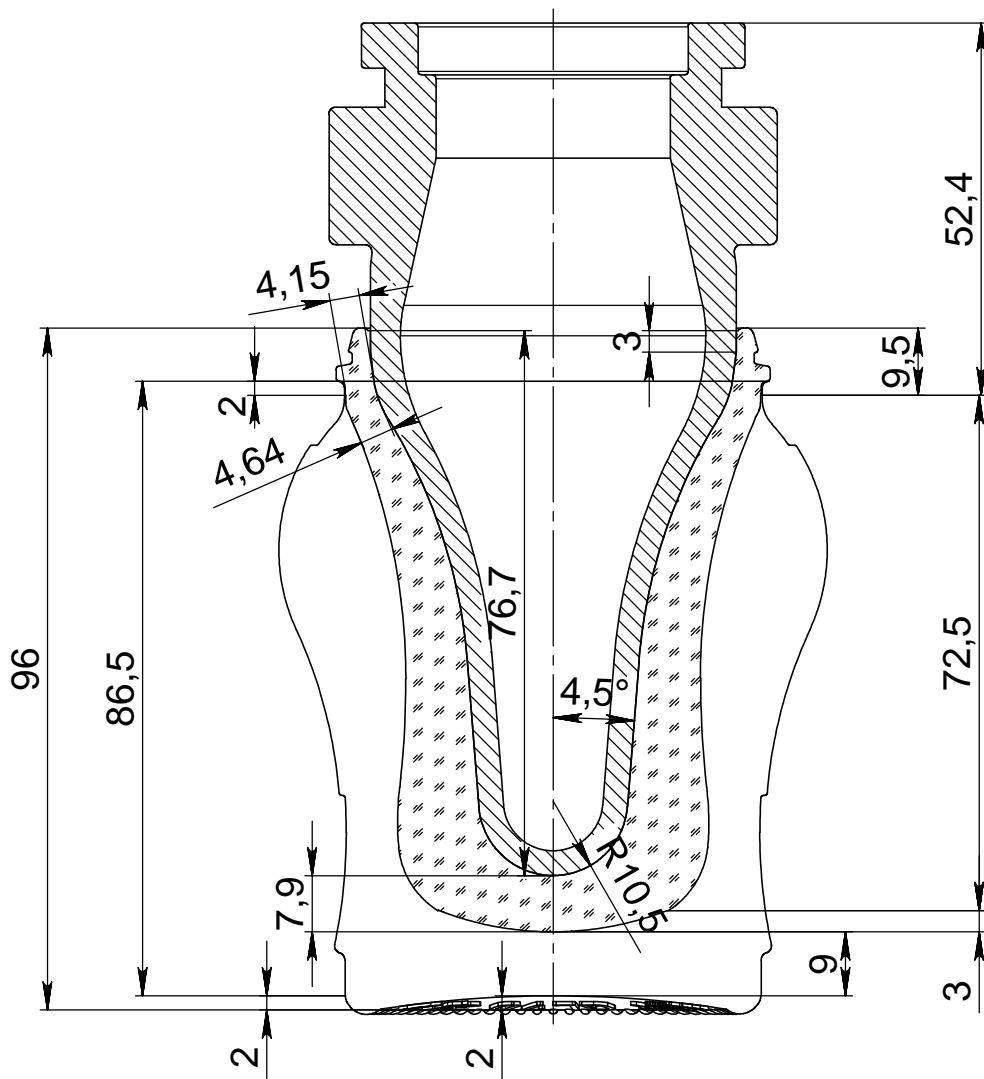
DETAIL VIEW E
SCALE 2 : 1



6 EQUALLY SPACED
HOLES $\phi 3,0$

1. Unspecified limit deviations of dimensions H14, h14, $\pm IT14/2$
2. Mark detail's designation: 19067 / 0772V01-Lamp1
Mark ordinal number
Depth of engraving 0.2mm/ Height of font=5 mm
3. Forming surface E must be welded 32...38 HRC and polished Ra 0,16
4. Keep sharp edge D
5. * - Reference only dimensions

MATERIAL: МАТЕРИАЛ:	Cast iron Чугун	MACHINE: МАШИНА:	JOB TITLE/НАЗВАНИЕ РАБОТЫ: CX-60-Lamp1	SCALE: МАСШТАБ: 1:1
WELDING: НАПЛАВКА:	cavity по формующей полости	Bottero-PB-DG-5_1/2"	DRAWING NUMBER/HOMEP ЧЕРТЕЖА: 19067-FGP-2	
QUANTITY: КОЛИЧЕСТВО:		DATE: ДАТА:	03.07.19	



P.B. BLANKMOULD DISPLACEMENT CALCULATIONS	
GLASS WEIGHT , g	190
GLASS WEIGHT / 2,43 CONSTANT, mls	78.19
+ DISPLACEMENT OF PLUNGER, mls	64.07
= DISPLACEMENT OF TOTAL PARISON, mls	142.26
- DISP'T OF SOLID FINISH, mls	24.43
= DISP'T OF BLANK+ BAFFLE (calculated), mls	117.83
DISP'T OF BLANK + BAFFLE (model), mls	117.84
- DISP'T OF BAFFLE CAVITY, mls	1.23
DISP'T OF BLANKMOULD CAVITY ONLY , mls	116.61
TOLERANCE ON TOTAL DISPLACEMENT	±0.3

MACHINE:
МАШИНА:
Bottero-PB-DG-5 1/2"

JOB TITLE/НАЗВАНИЕ РАБОТЫ:

CX-60-Lamp1

SCALE:
МАСШТАБ:

1:1

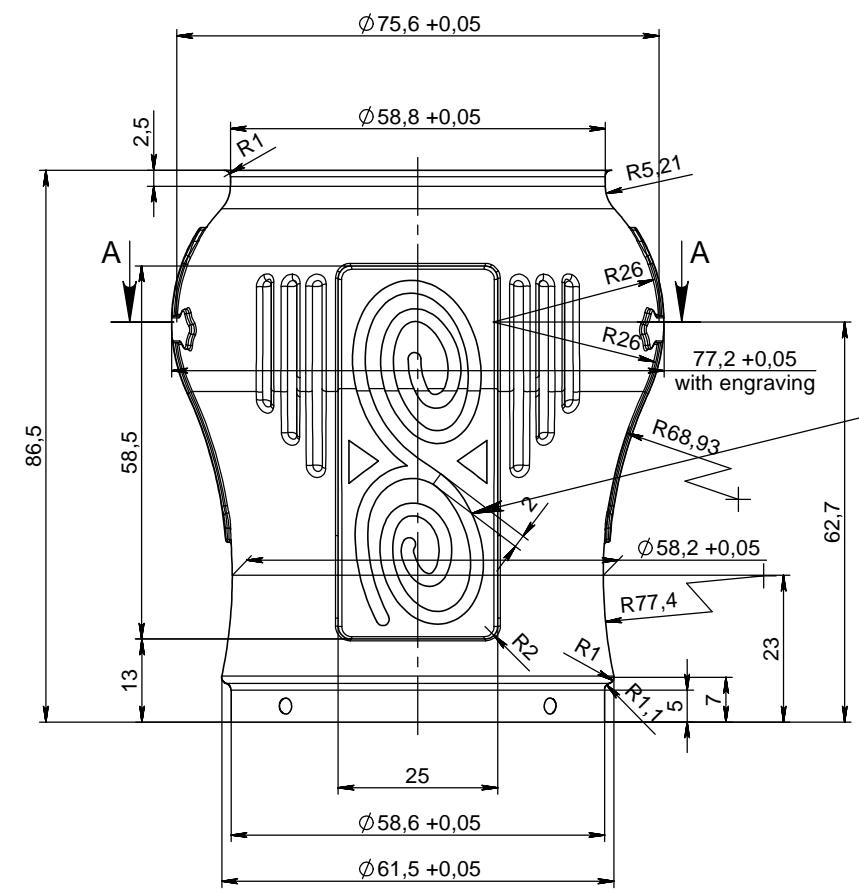
DATE:
ДАТА:
03.07.19

DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:

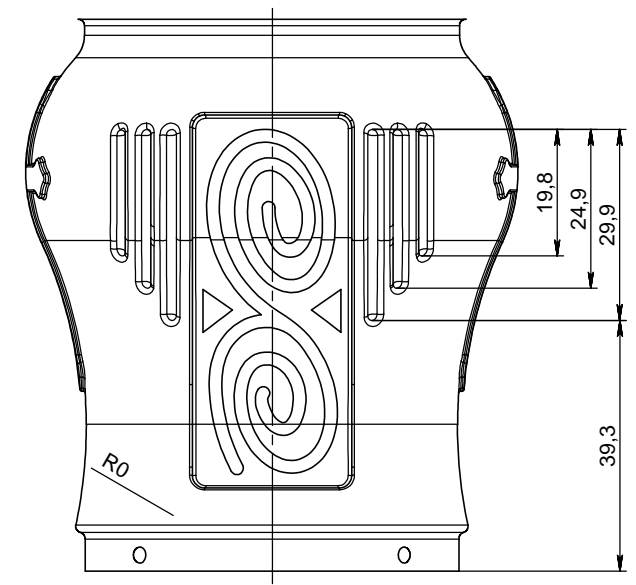
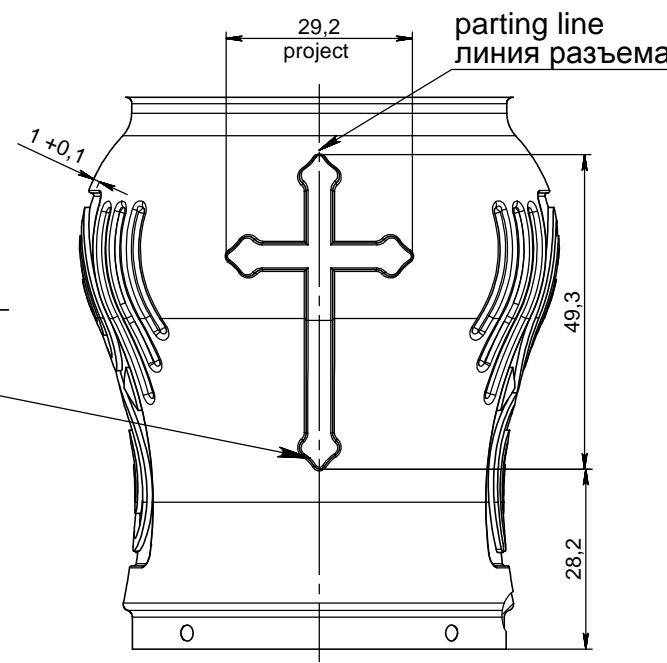
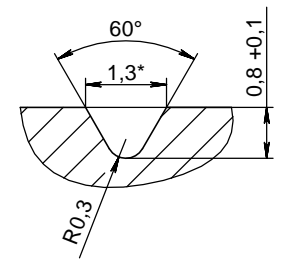
19067-LAY-2

ASSEMBLY NUMBER: НОМЕР СБОРКИ:	11	MATERIAL: МАТЕРИАЛ:	Cast iron Чугун	MACHINE: МАШИНА:		JOB TITLE/НАЗВАНИЕ РАБОТЫ:		SCALE: МАСШТАБ:	
INVERT CENTRE: ИНВЕРТ:	50	WELDING: НАПЛАВКА:	all edges по всем кромок	Bottero-PB-DG-5_1/2"		CX-60-Lamp1			
H' DIMENSION: РАЗМЕР Н' (РАССТОЯНИЕ ОТ ОСИ ФОРМЫ ДО ВЕРХНЕЙ ГРУБЫ)	9,5	QUANTITY: КОЛИЧЕСТВО:		DATE: ДАТА:	03.07.19	DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:		1:1	
						19067-MLD1-2			

Views in glass. Must be made mirrored in mould
Виды по стеклу. На форме выполнить зеркально



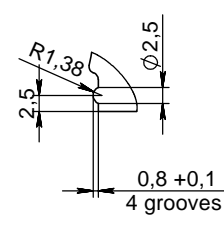
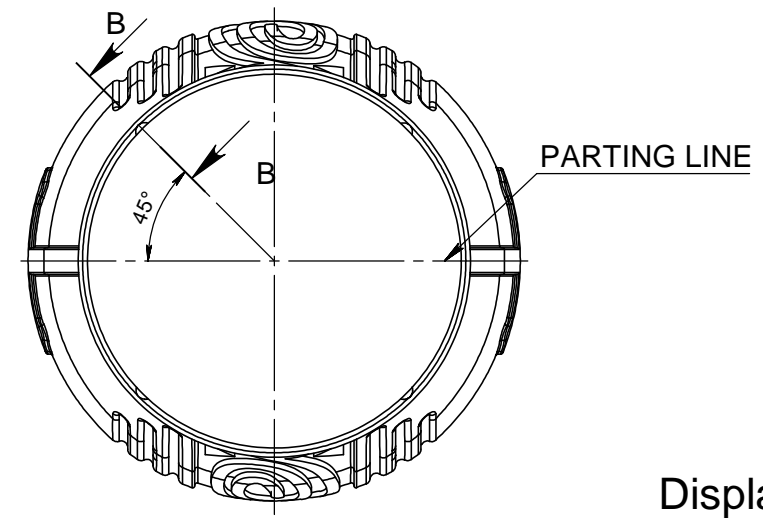
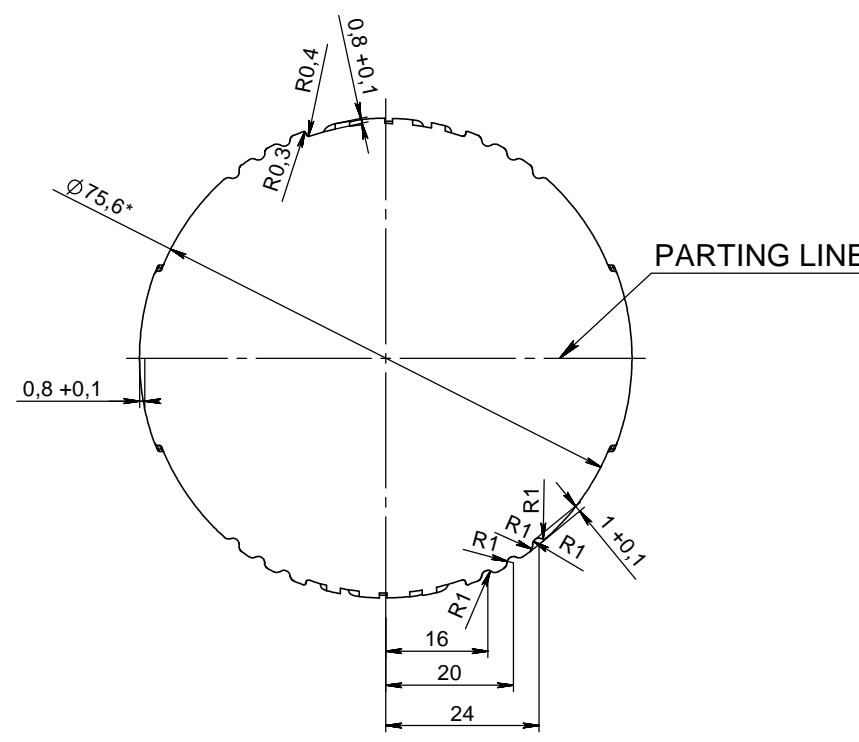
engraving cutter
профиль гравировки
Detail scale 10:1



SECTION A-A

BOTTOM VIEW

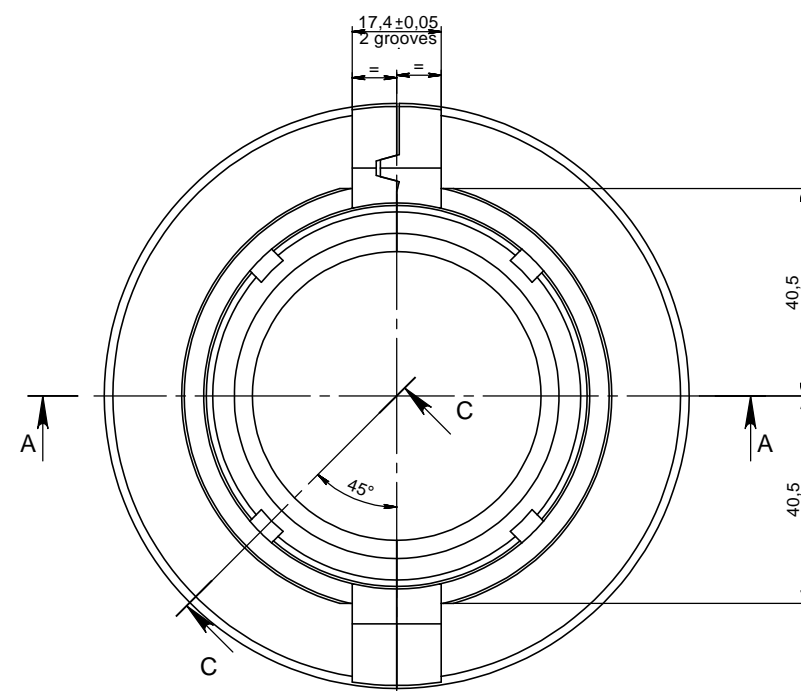
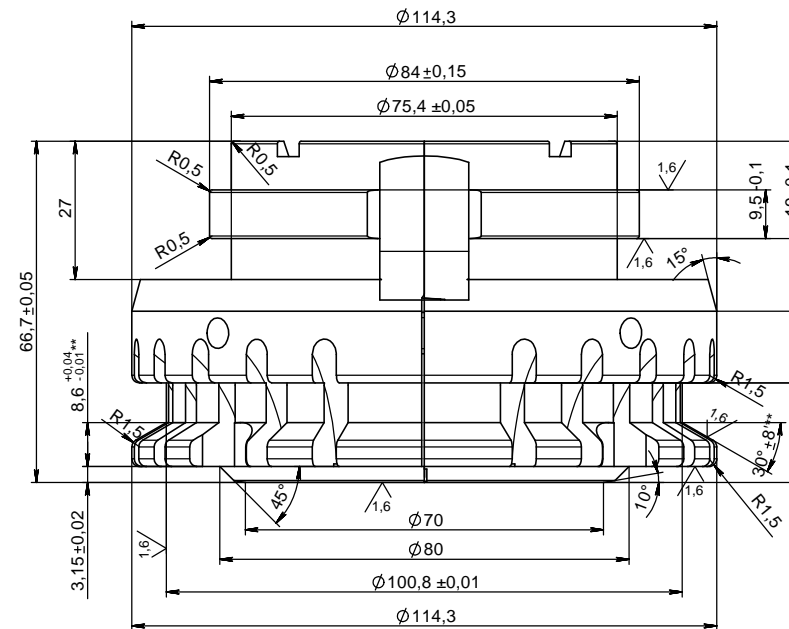
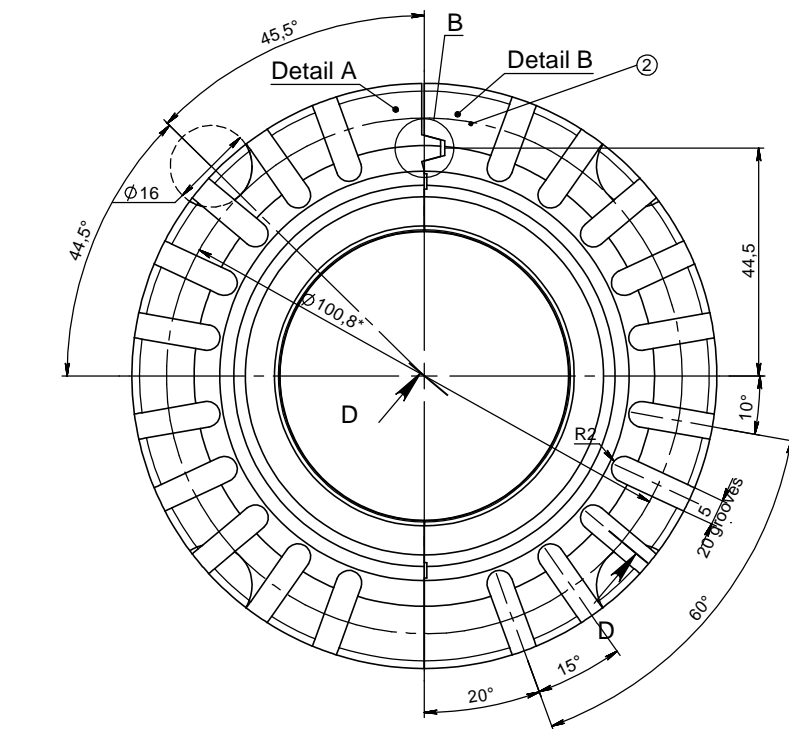
SECTION B-B



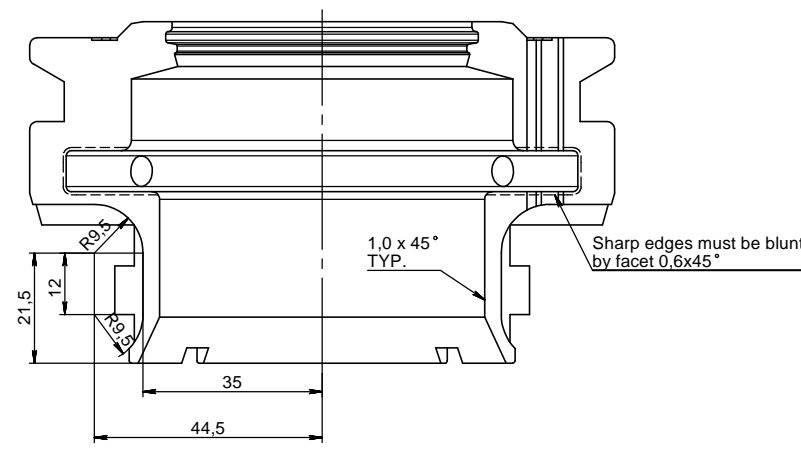
manufacture according to 3D-model
обрабатывать в соответствии с 3-D моделью

Displacement (объем) :	
Mould (форма)	283,9 $\pm 0,5$ ml
Bottom (поддон)	3,4 $\pm 0,5$ ml
Mould+Bottom (форма+поддон)	287,3 $\pm 0,5$ ml

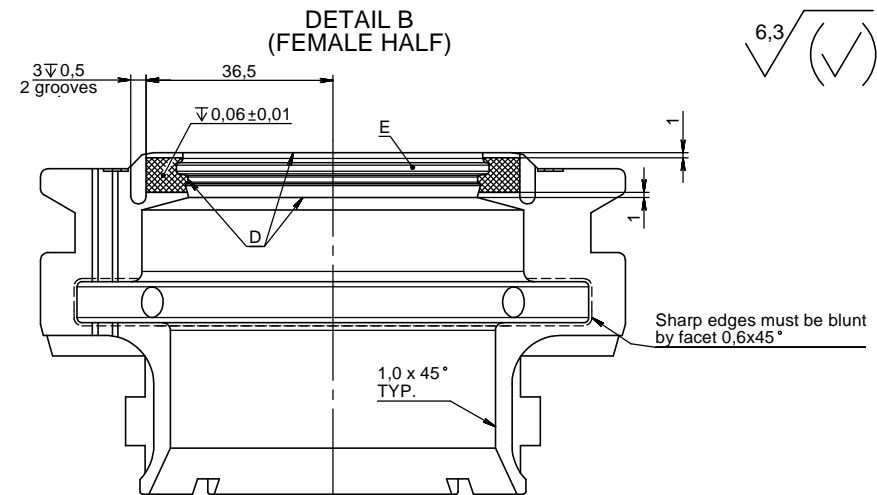
MACHINE: МАШИНА:	JOB TITLE/НАЗВАНИЕ РАБОТЫ:	SCALE: МАСШТАБ:
Bottero-PB-DG-5_1/2"	CX-60-Lamp1	1:1
DATE: ДАТА:	DRAWING NUMBER/HOMEP ЧЕРТЕЖА:	
03.07.19	19067-MLD12-2	



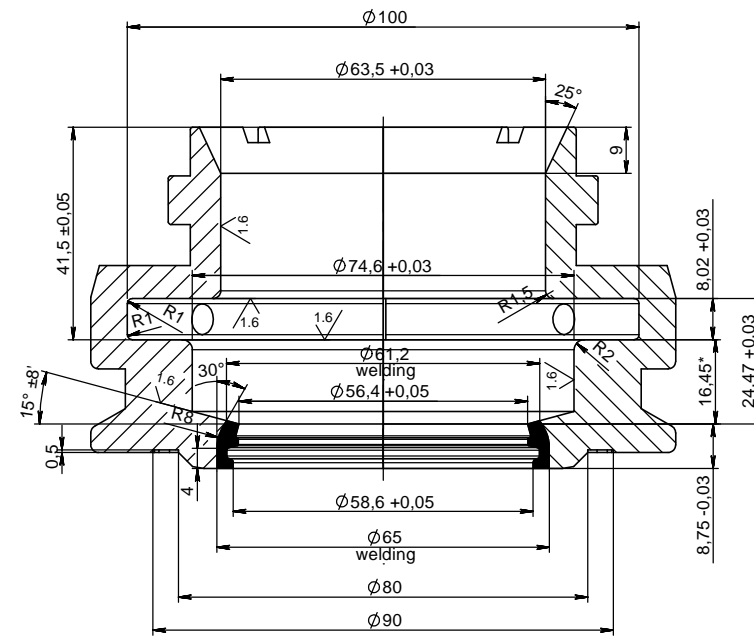
DETAIL A
(MALE HALF)



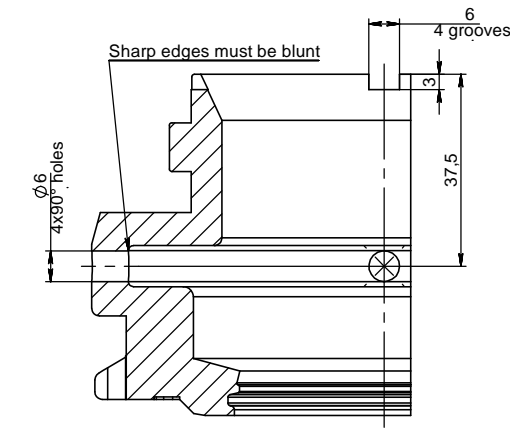
DETAIL B
(FEMALE HALF)



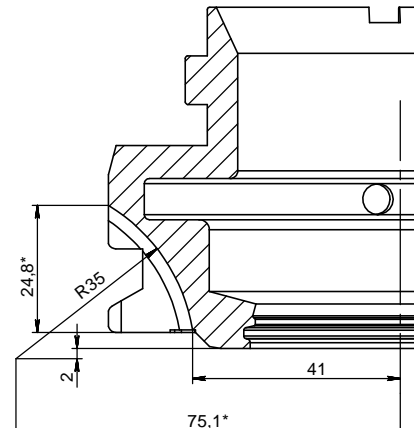
SECTION A-A



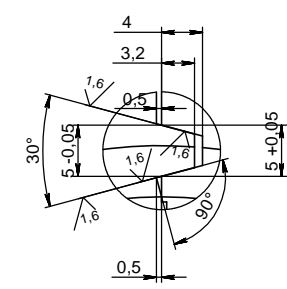
SECTION C-C



SECTION D-D

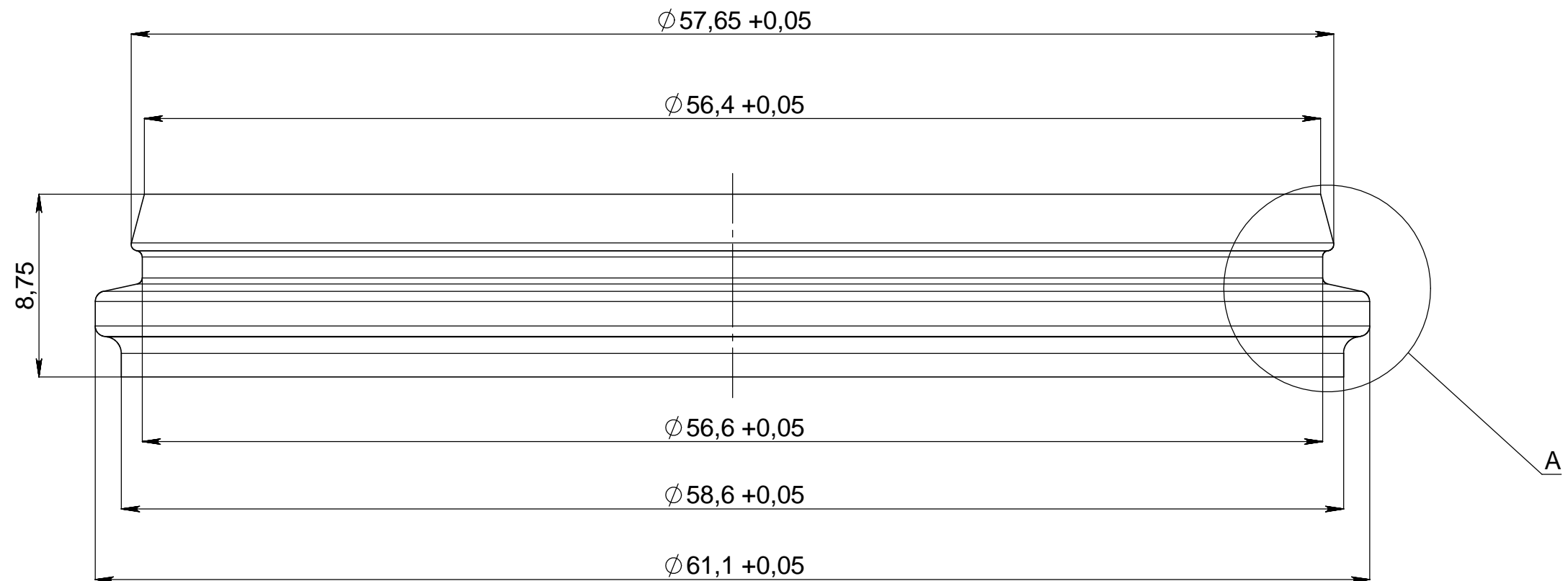


DETAIL VIEW C
SCALE 2:1

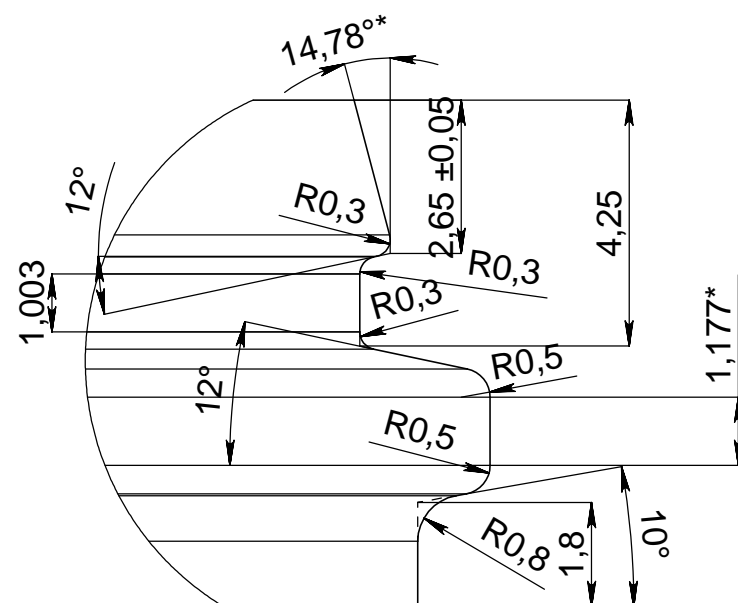


1. Unspecified limit deviations of dimensions H12, h12, $\pm IT12/2$
2. Mark: 19067 / 0772V01-Lamp1
Mark ordinal number
Depth of marking - 0.3mm.
3. Details A and B must be marked with same ordinal number, processed and used together
4. Forming surface E must be welded 32...38 HRC and polished Ra 0,16
5. Keep sharp edge D
6. * - Reference only dimensions
7. ** - Must be controlled using complex caliber

MATERIAL: МАТЕРИАЛ:	Bronze Бронза	MACHINE: МАШИНА:		JOB TITLE/НАЗВАНИЕ РАБОТЫ:	SCALE: МАСШТАБ:
WELDING: НАПЛАВКА:	cavity по формирующей полости	Bottero-PB-DG-5_1/2"		CX-60-Lamp1	1:1
QUANTITY: КОЛИЧЕСТВО:		DATE: ДАТА:	03.07.19	DRAWING NUMBER/НОМЕР ЧЕРТЕЖА:	19067-NR1-2

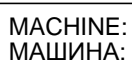


DETAIL VIEW A
SCALE 8 : 1



* - reference dimension
** - crosspoint dimension

MACHINE: МАШИНА: Bottero-PB-DG-5 1/2"	JOB TITLE/НАЗВАНИЕ РАБОТЫ: CX-60-Lamp1	SCALE: МАСШТАБ: 4:1
	DRAWING NUMBER/НОМЕР ЧЕРТЕЖА: 19067-NR12-2	
DATE: ДАТА:	03.07.19	

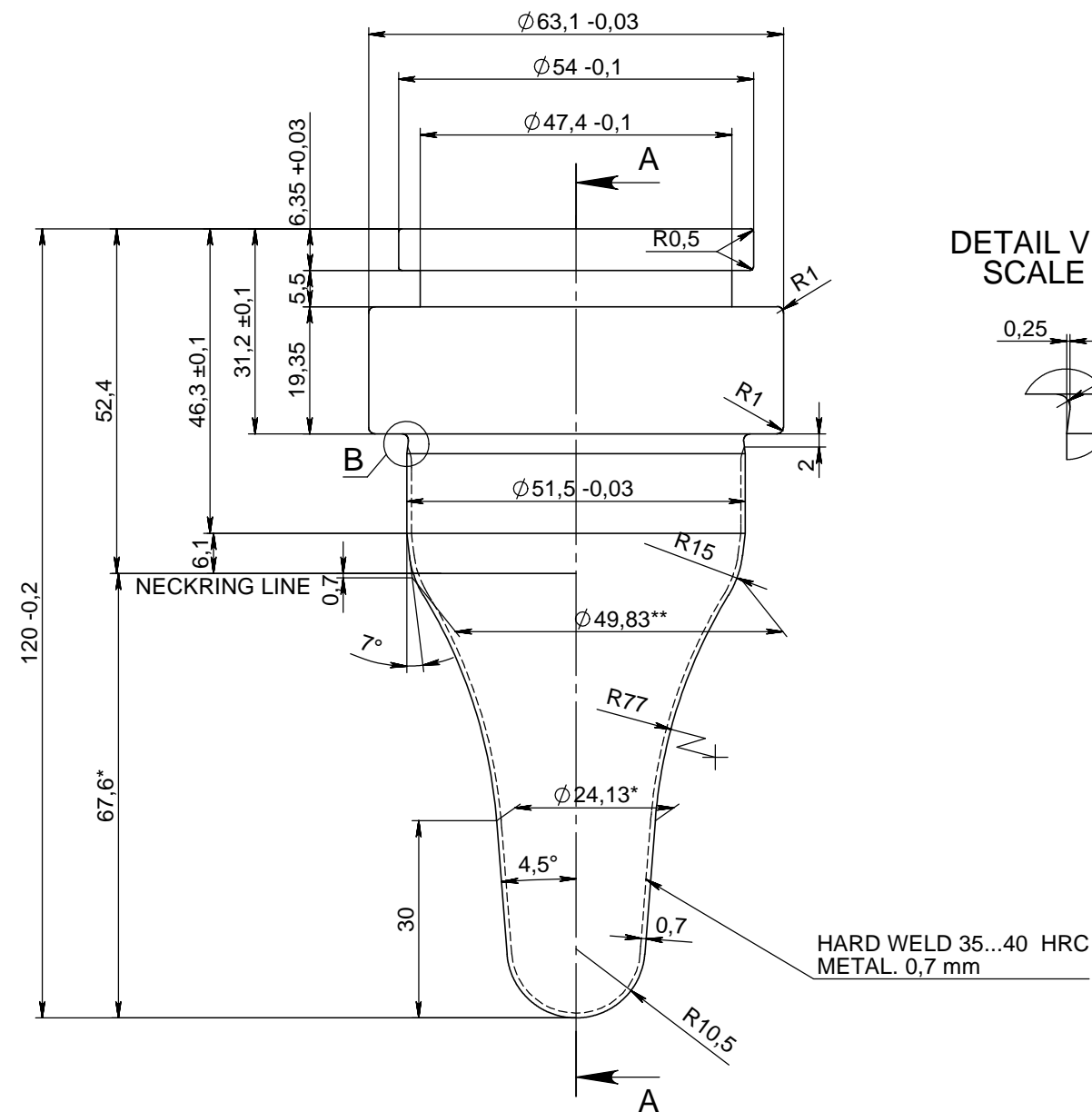


SCALE:
МАСШТАБ:

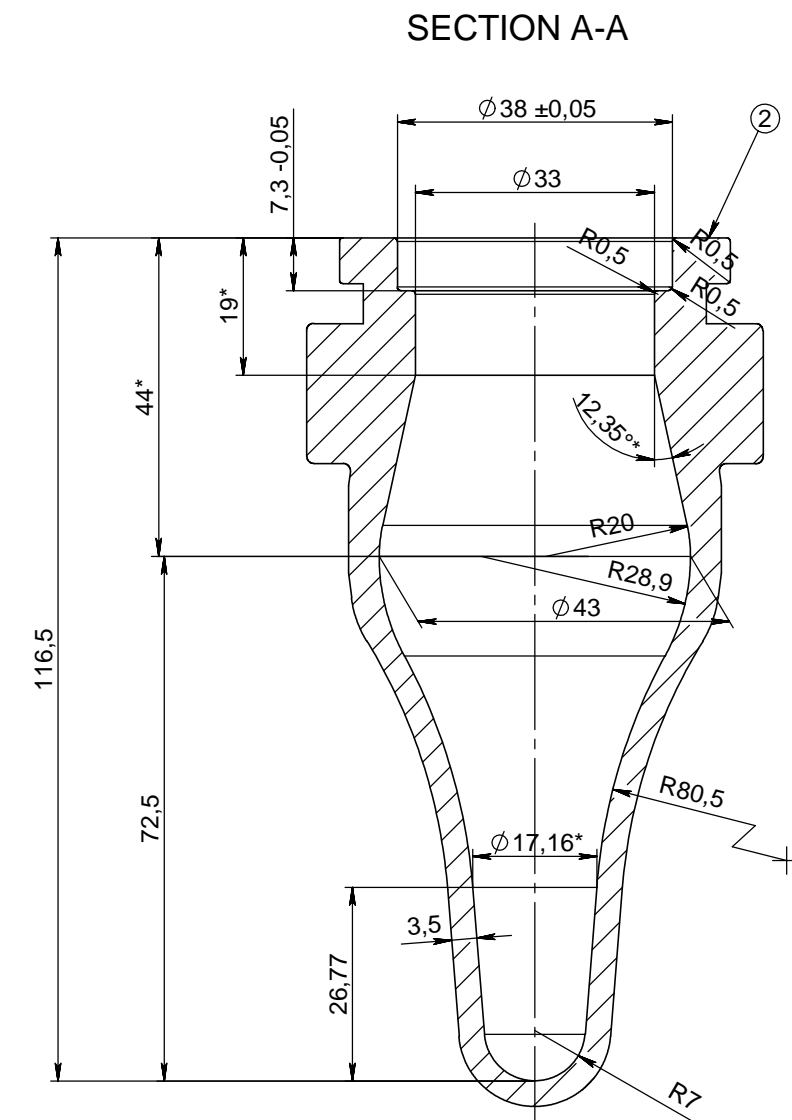
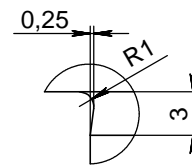
1:1

DATE:
DATA:

03.07.19

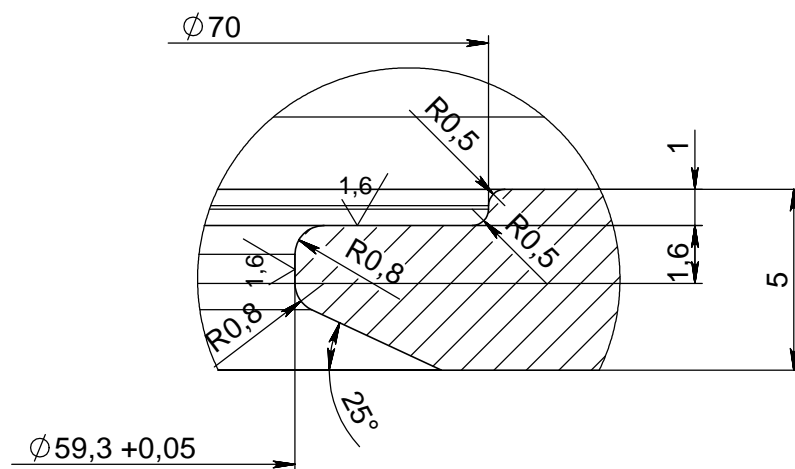
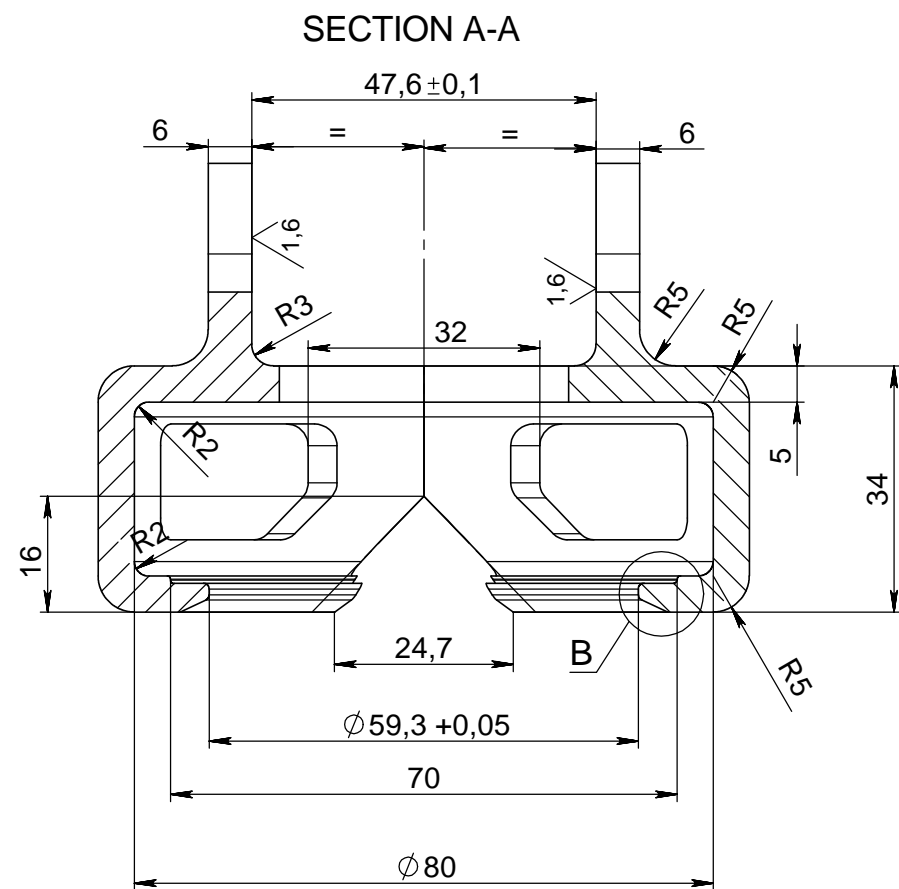
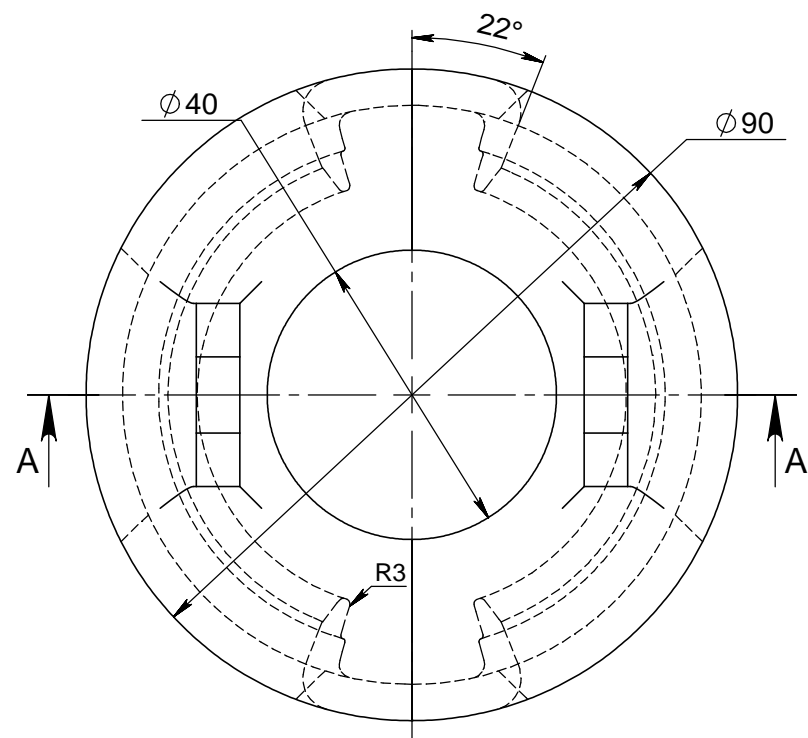


DETAIL VIEW B
SCALE 2 : 1

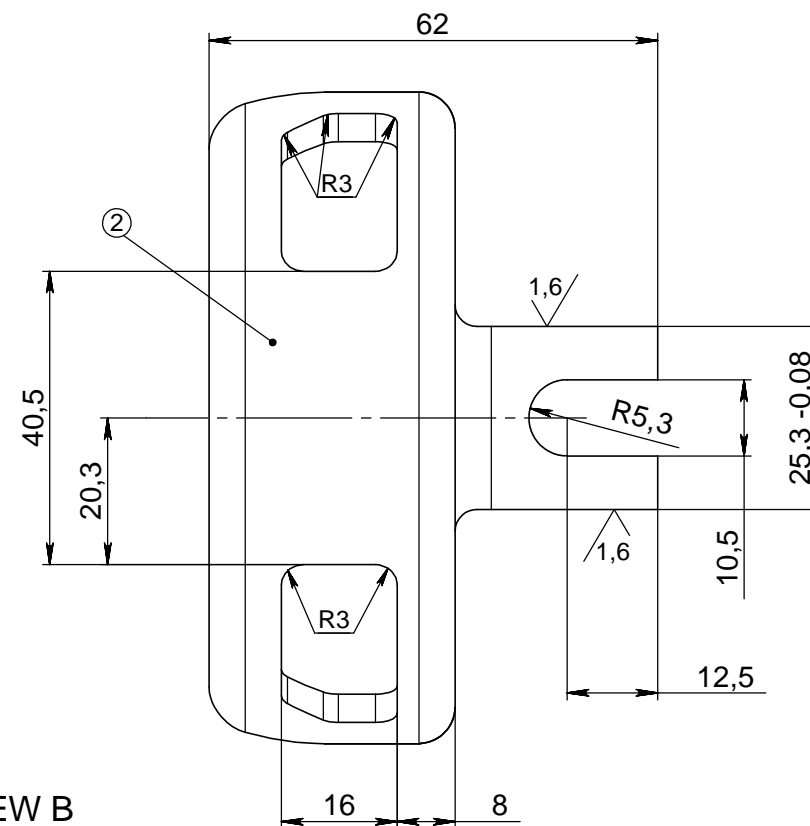


1. Unspecified limit deviations of dimensions H14, h14, +/-IT14/2
2. Mark: 19067 / 0772V01-Lamp1
Mark ordinal number
Depth of marking - 0.3mm.
3. Forming surface must be welded 35...40 HRC and polished Ra 0,16
4. * - Reference only dimensions
5. ** - Crosspoint dimensions

MATERIAL: МАТЕРИАЛ:	Steel Сталь	MACHINE: МАШИНА:	JOB TITLE/НАЗВАНИЕ РАБОТЫ: CX-60-Lamp1	SCALE: МАСШТАБ: 1:1
WELDING: НАПЛАВКА:	tip по формирующей поверхности	Bottero-PB-DG-5 1/2"	DRAWING NUMBER/HOMEP ЧЕРТЕЖА: 19067-PL-3	
QUANTITY: КОЛИЧЕСТВО:		DATE: ДАТА:	03.07.19	



DETAIL VIEW B
SCALE 5 : 1



6,3 (✓)

1. Unspecified limit deviations of dimensions H14, h14, +/-IT14/2
2. Mark: 19067 / 0772V01-Lamp1
Mark ordinal number.
Depth of marking - 0.3mm.
3. Make in pairs, mark with same ordinal number & use together
4. * - Reference only dimensions

MATERIAL: МАТЕРИАЛ:	Bronze Бронза	MACHINE: МАШИНА:	JOB TITLE/НАЗВАНИЕ РАБОТЫ: CX-60-Lamp1	SCALE: МАСШТАБ: 1:1
WELDING: НАПЛАВКА:		Bottero-PB-DG-5_1/2"	DRAWING NUMBER/HOMEР ЧЕРТЕЖА:	
QUANTITY: КОЛИЧЕСТВО:		DATE: ДАТА: 03.07.19	19067-TOT-2	

сборка_держателей_19067

Сборка 1
Hdim=9,5
invert=50
посадка формы $\phi 136.3$

Сборка 11
Hdim=9,5
invert=50
посадка формы $\phi 152.2$

