



880—75

880—75

1986

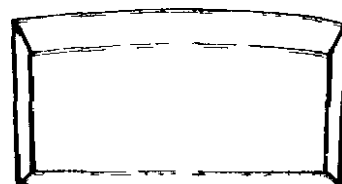
880—67

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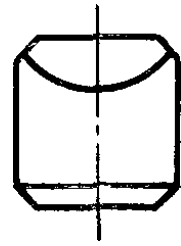
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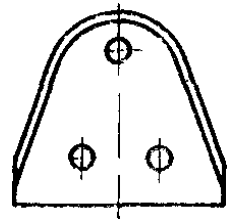
1985 . (1, 2,
6—79, 4—86).

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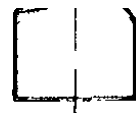
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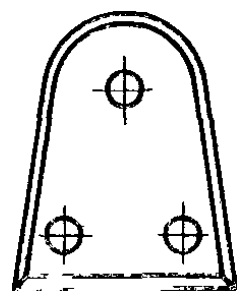
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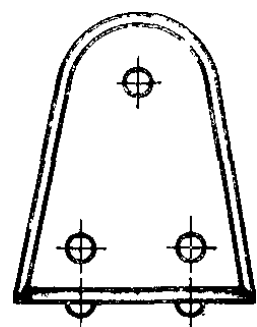
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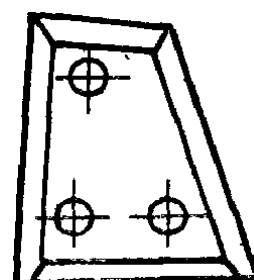
25	-				
26	-				
32	-				*
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34	-				

34

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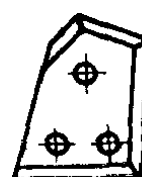
36

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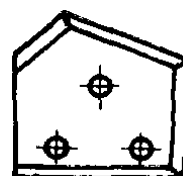
37

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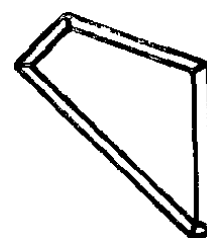
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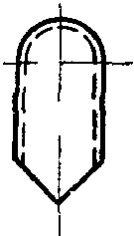


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53	- -	<table><tr><td></td><td>1- ,</td><td></td></tr><tr><td></td><td>1</td><td></td></tr></table>		1- ,			1				
	1- ,										
	1										
54	-	<table><tr><td></td><td>i</td><td></td></tr><tr><td></td><td>1</td><td></td></tr><tr><td></td><td>1</td><td></td></tr></table>		i			1			1	
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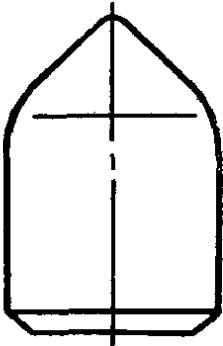
61

63	- -	<div></div> <div></div> <div></div>
64	-	

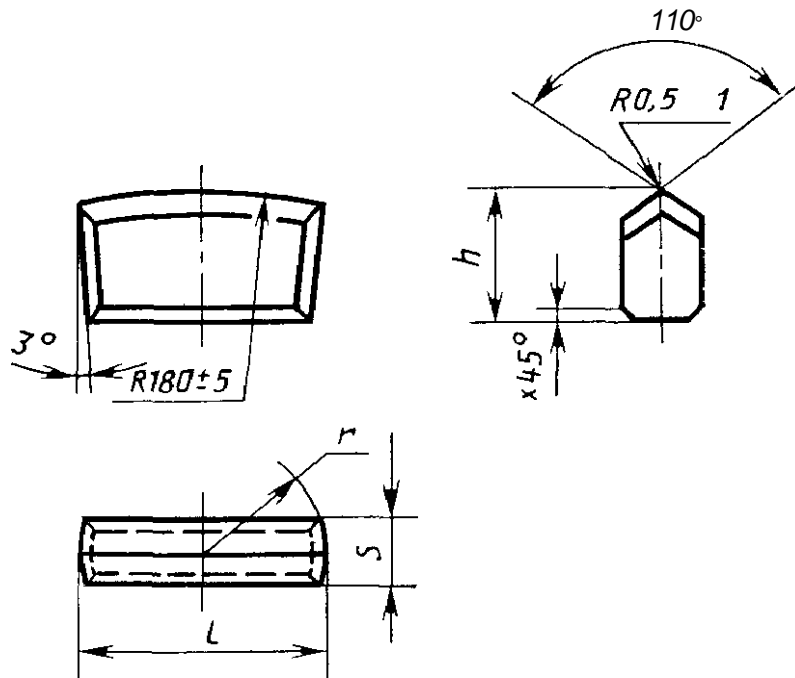
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* 1—35 . 2—20.



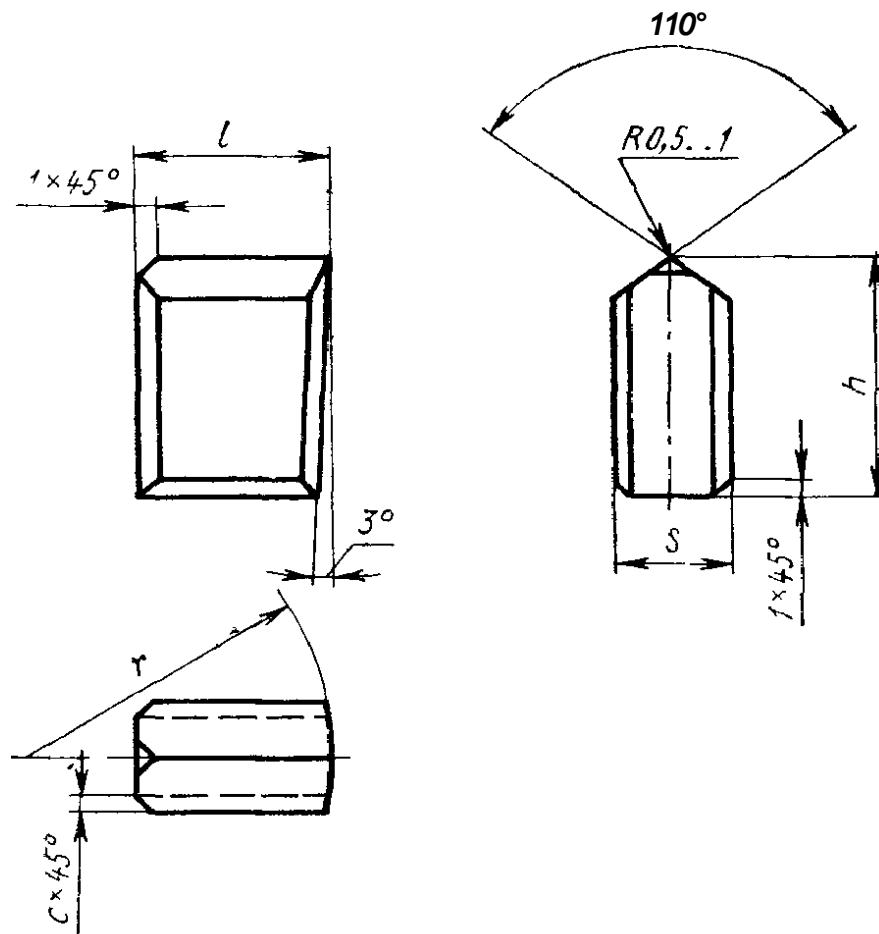
Черт.

2

	$\left(\begin{smallmatrix} 1 \\ +1 \end{smallmatrix}\right)$	$\left(\begin{smallmatrix} h \\ -0,8 \end{smallmatrix}\right)$	$\left(\begin{smallmatrix} s \\ +0,5 \end{smallmatrix}\right)$	$\left(\begin{smallmatrix} db \\ 1,0 \end{smallmatrix}\right)$
1101	28	16	7,5	14,0
1102	32			16,0
1103	36			18,0
1104				
1105	40		7,5	20,0
1106				
1107	43	18	9,5	21,5
1108	46			23,0
1109	52			26,0
1110	49			24,5

$R=120\pm5$

12



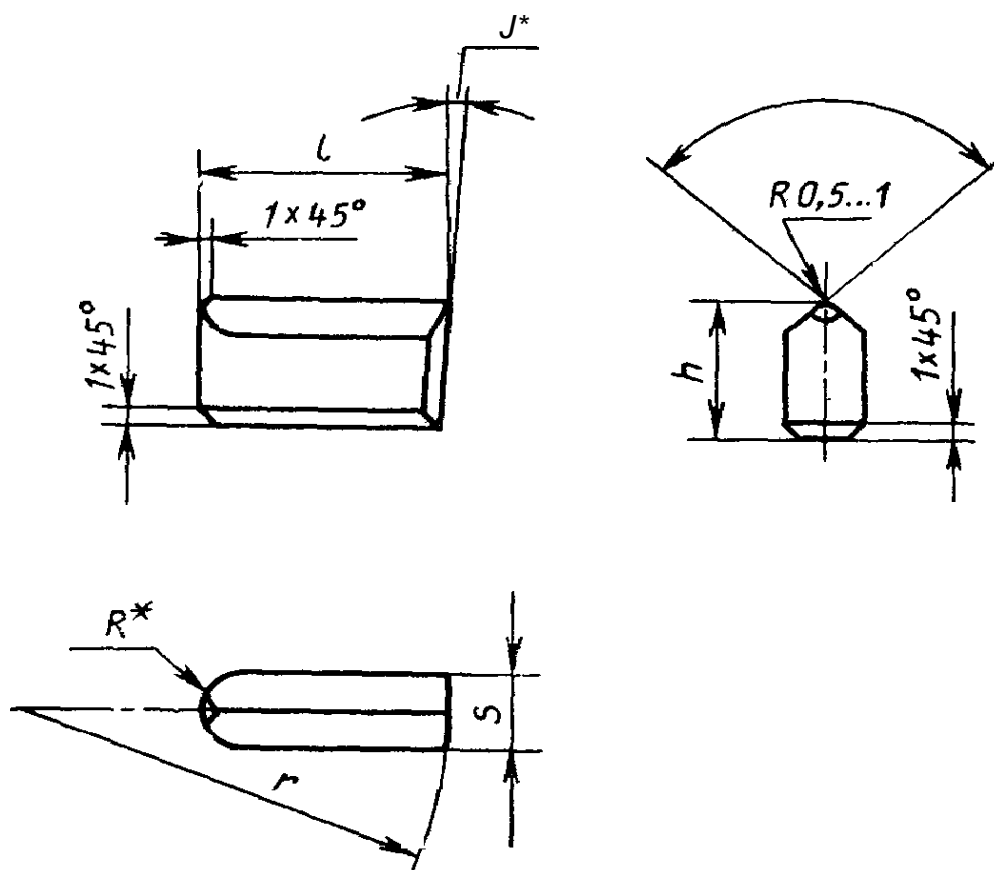
Черт. 2

3

	$\begin{pmatrix} t \\ \pm 0,5 \end{pmatrix}$	$\begin{pmatrix} h \\ -0,8 \end{pmatrix}$	$\begin{pmatrix} S \\ +0,5 \end{pmatrix}$	$\begin{pmatrix} \\ \pm 1,0 \end{pmatrix}$	$\begin{pmatrix} \\ \pm 0,5 \end{pmatrix}$
1201	12	16	7,5	16	1,0
1202	13				
1203	14		9,5	20	
1204	15		7,5	18	
1205			9,5	21	
1206	16	18		20	
1207	17				
1208	18	9,5	21	1,5	
1209	12		16	18	

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13



Черт. 3

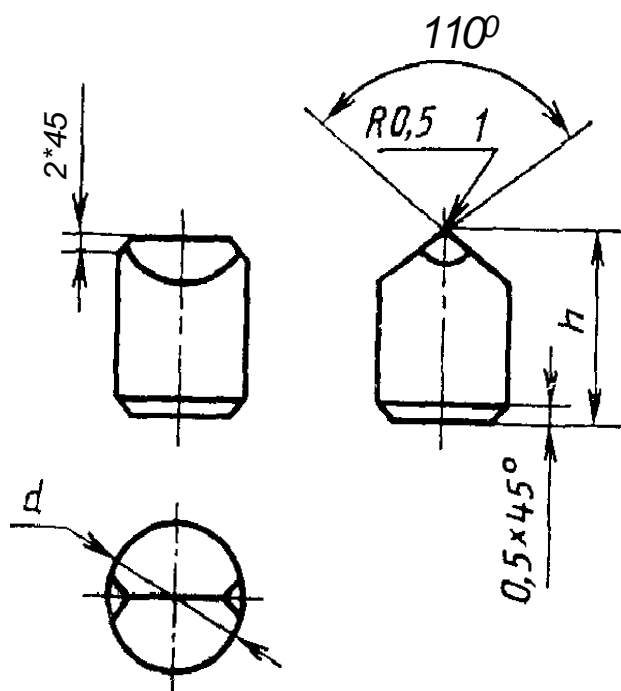
4

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	$\begin{pmatrix} 1 \\ \pm 0,5 \end{pmatrix}$	$\begin{pmatrix} - \\ 0,8 \end{pmatrix}$	$\begin{pmatrix} s \\ + 0,5 \end{pmatrix}$	R^*	$\begin{pmatrix} \pm 1,0 \end{pmatrix}$
1301	28	18	9,5	5	52
1302	32				78
1303	49				
1304	36				
1305	40				
1306	14				64
1307	16				
1308	16	20	11,5	6	30
1309	20				
1310	24				
1311	23	24	13,5	7	62
1312	37				

14

5

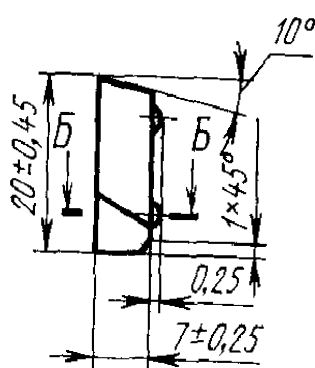
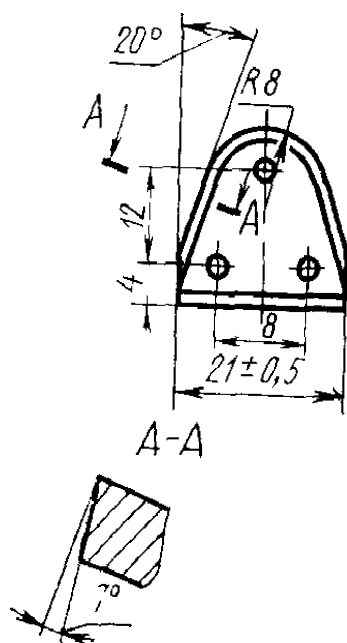


Черт. 4

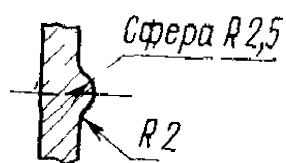
	d		h (± 0.4)
1401	8	-0,35	16
1402	10	-0,45	
1403	12	-0,60	
1404	14		
1405	15		
1406	16		
1407			
1408			
1409	18		
1410	20		
			20

2).

22

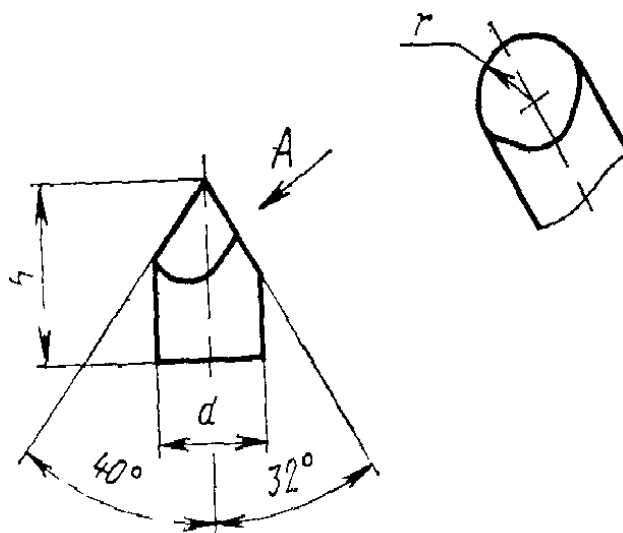


Б-Б



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23

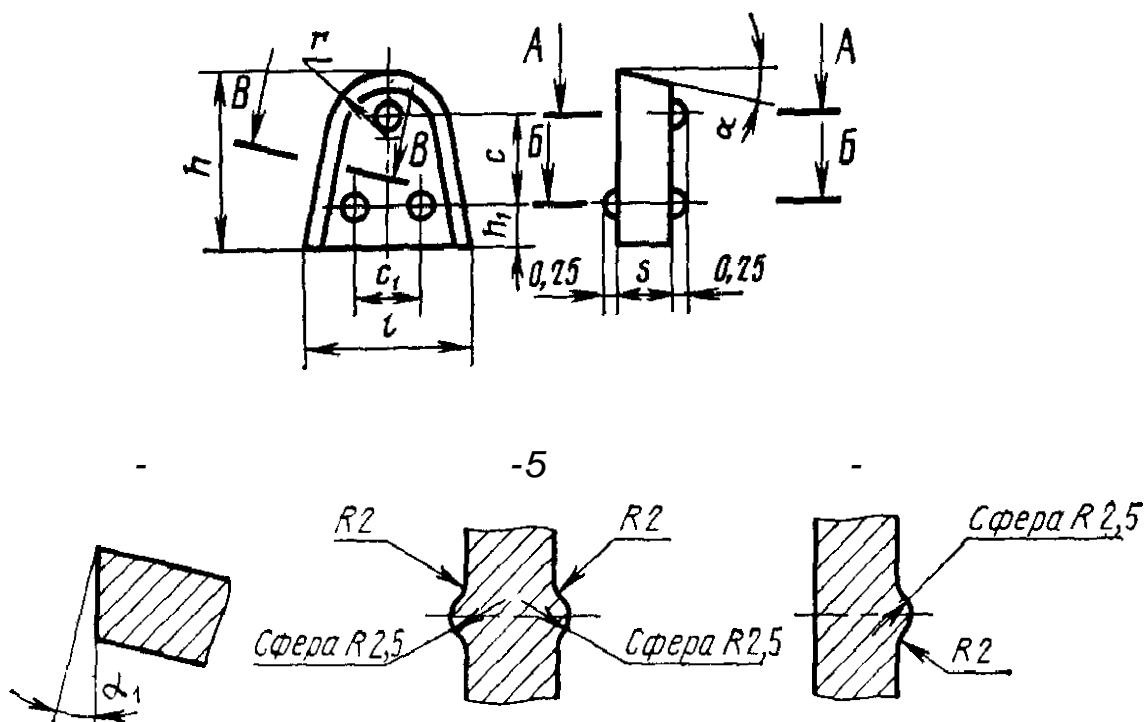


Черт. 7

6

	d		h		($\pm 0,25$) ,
	.	, .	.	, .	
2301	8,2	+0,3	14	$\pm 0,35$	4,5
2302			12		
2303*	10,0		16		5,5
2307	12,2		20	$\pm 0,40$	6,5

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Черт. 8

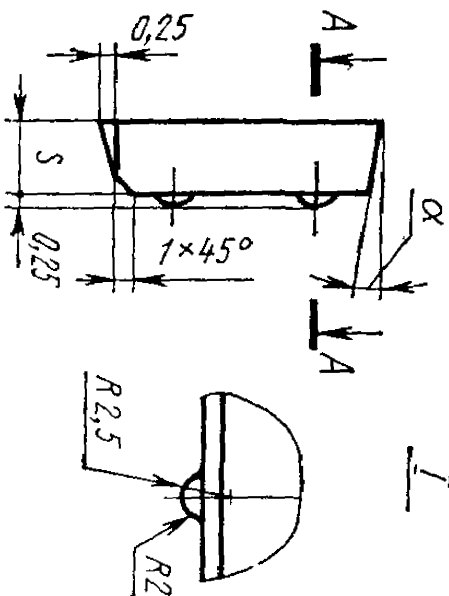
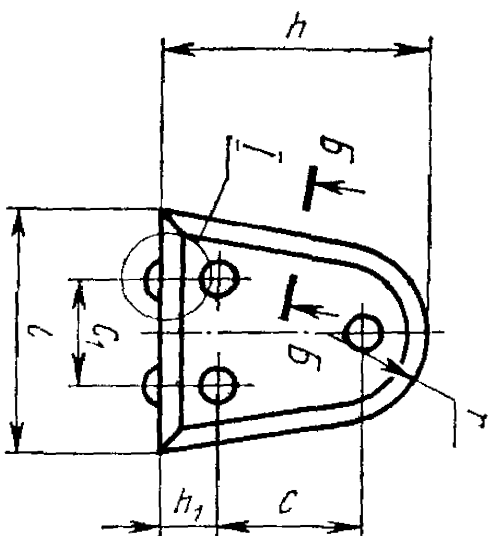
7

	h		l		S			ft.		Ci		at
						
2401	15	±0,4	12	±0,35	4,0	±0,20	4,5	2,5	8,0	6,5	10°	3°
2402					5,5	±0,25						
2403	21	±0,5	18	±0,45	7,0	±0,25	5,5	4,0	11,5	8,0	15°	

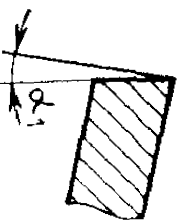
to 4* &J 03	<i>n</i> to 4* S3	•"1 to 4^ ta CO	<i>n</i> to 4-		
	K> si	to to	05	.	S*
	1+		1+ 4».	.	
	20	05		.	
	-	±0,40	-	.	
05		-4	4^	.	
	-		1+ N0	.	
	-4		4*	*	
	4^			S'	
' . "-4 !			—		
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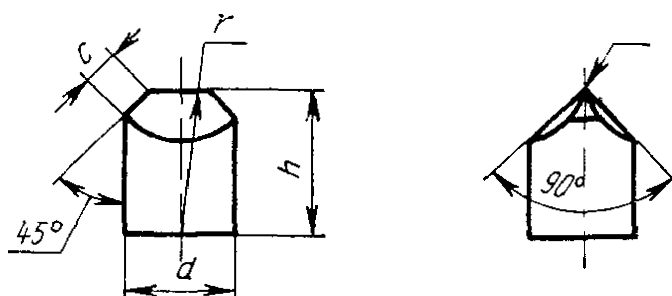


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R2,5

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Черт. 10

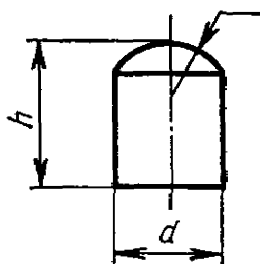
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	<i>d</i>		<i>h</i>					
	.	:	.	:	.	:	'1	
<u>2501</u>	<u>3,2</u>			<u>±0,20</u>				
<u>2502</u>				<u>±0,25</u>	8			
<u>2503</u>	4,2			<u>±0,20</u>				
<u>2504</u>								
<u>2505</u>	5,2		8		10			
<u>2506</u>				±0,25				
<u>2507</u>			10					
<u>2508</u>	6,2				12			
<u>2509</u>			<u>8</u>					
<u>2510</u>			<u>12</u>					
<u>2511</u>	7,2		<u>10</u>		14	±0,15	0,5	0,5
<u>2512</u>			<u>13</u>	±0,30				
<u>2513</u>		+ 0,3	<u>12</u>					
<u>2514</u>	8,2		21		16			
<u>2515</u>			<u>10</u>					
<u>2516</u>			21					
<u>2517</u>			<u>13</u>	±0,25				
<u>2518</u>	9,2		21		18			
<u>2519</u>			—					
<u>2520</u>			<u>16</u>					
<u>2521</u>			21					
<u>2522</u>	10,2		21	±0,30	20	<u>±0,20</u>	1,0	1,0
<u>2523</u>			<u>13</u>					
2524			12					

	<i>d</i>		<i>h</i>				
2525	11,2	0,3	16	—f— 0,30	22	±0,20	1,0
2526			15				
2527			14				
2528			13				
2529			12				
2530			11				
2531			10				
2532	12,3		18	±0,40	24		
2533			17				
2534			16	±0,30			
2535			15				
2536			14				
2537			13,3	19			
2538	18						
2539	17			—0.30			
2540	16						
2541	15						
2542	14,3	21	±0,40	28			
2543		20					
2544		18	-4-0.30				
2545		17					
2546		16					
2547		22			30		
2548	21						
2549	20						
2550	19						
2551	18						
2552	16,3	24		32			
2553		22					
2554		20					
2555		19					
2556		18					

26

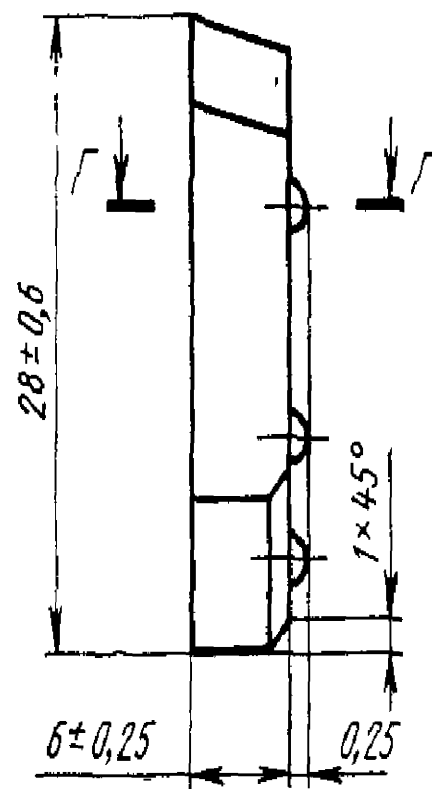
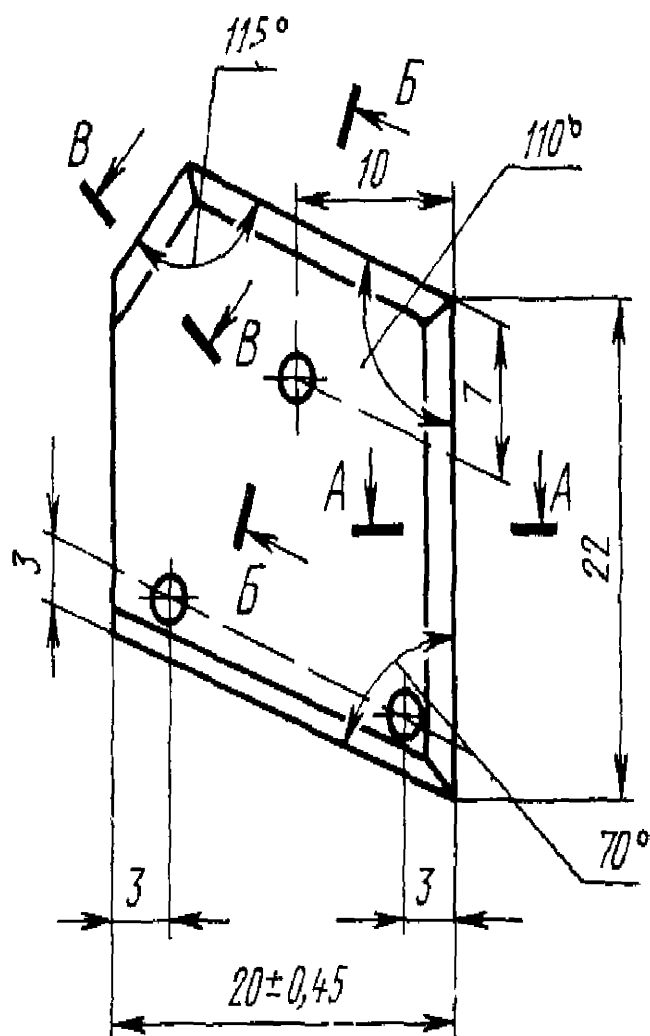
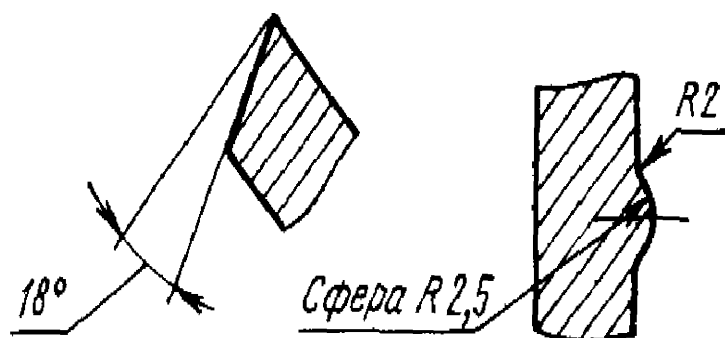
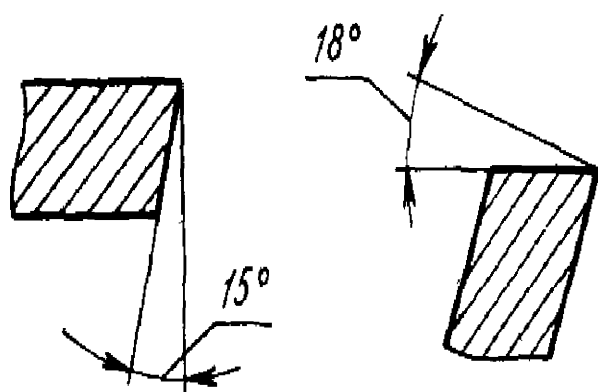


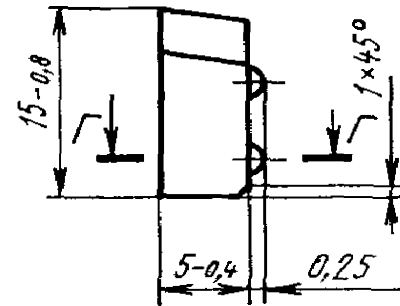
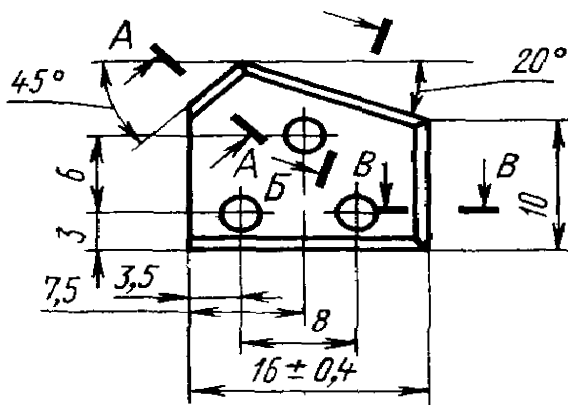
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	<i>d</i>		<i>h</i>					<i>d</i>		<i>h</i>			
	X
2601	3,2	+ 0,3	5	+ 0,20	1,8	±0,20	2620	8,2	+ 0,3	10	±0,25	4,5	±0,20
2602	4,2		6		2,3		-2621			9			
2603			5				2622			8			
2604	5,2		8	±0,25	2,8		2623			7			
2605			7				2624	14		+0,30	5,0	±0,25	
2606			6	±0,20			2625	13					
2607	6,2		9	±0,25	3,4		2626	12					
2608			8				±0,25	2627		11			
2609			7				2628	10		+0,25			
2610			6	±0,20			2629	9					
2611	7,2		11	±0,30	3,9		2630	8		±0,30	5,5		
2612			10	±0,25			2631	16					
2613			9				2632	15					
2614			8				2633	14					
2615			7				2634	13					
2616				+ 0,20			2635	12					
2617	8,2		13	±0,30	4,5		2636	—		±0,25			
2618			12				2637	10					
2619			11				2638	9					

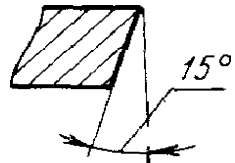
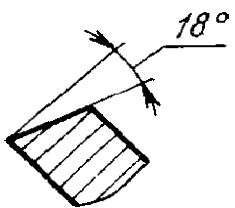
	<i>d</i>		<i>h</i>					<i>d</i>		<i>h</i>		
	·	· ·	$\frac{x}{2}$ <i>X</i>	· ·	·	· ·		·	· ·	$\frac{h}{2}$	· ·	·
2639	11,2		16	-4-0.30	6,0		2662	14,3		21		7,5
2640			15				2663			20		
2641			14				2664			18		
2642			13				2665			17		
2643			12				2666			16		
2644			11				2667			15		
2645			10				2668			14		
2646	12,3	4-0,3	18		6,5	±0,25	2669	15,3	+ 0,4	13	±0,40	8,0
2647			17				2670			22		
2648			16				2671			21		
2649			15				2672			20		
2650			14				2673			19		
2651			13				2674			18		
2652			12				2675			17		
2653	13,3		11	±0,30	7,0		2676	16,3		16		8,5
2654			19				2677			15		
2655			18				2678			24		
2656			17				2679			22		
2657			16				2680			20		
2658			15				2681			19		
2659			14				2682			18		
2660			13	±0,40			2683			17		
2661			12				2684			16		

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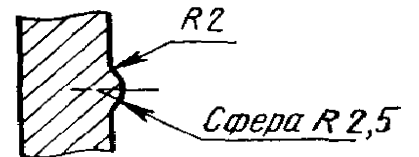
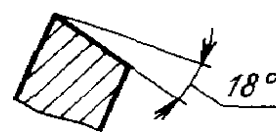
A-A

B-B



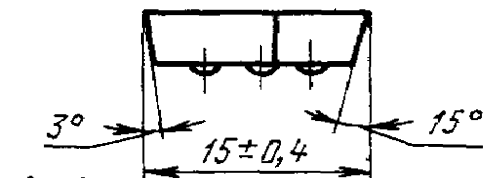
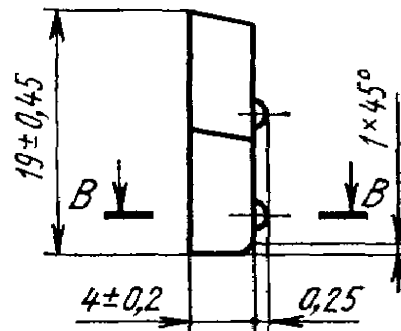
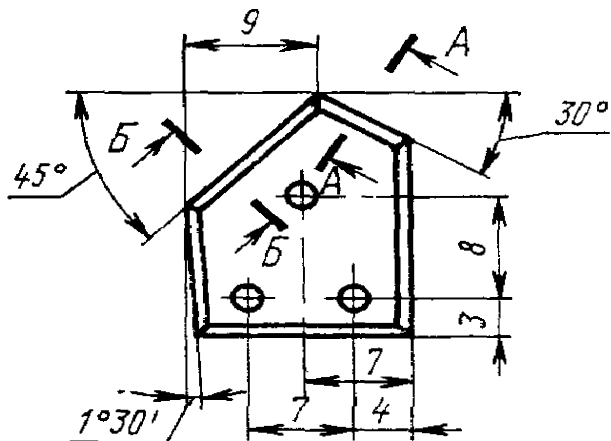
B-B

Г-Г



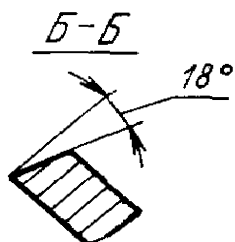
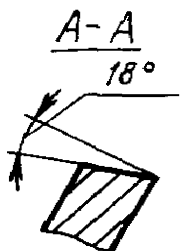
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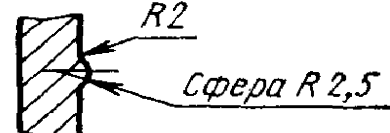


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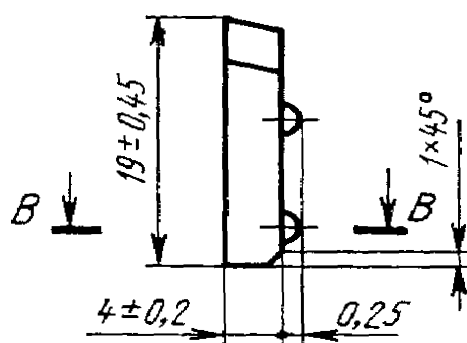
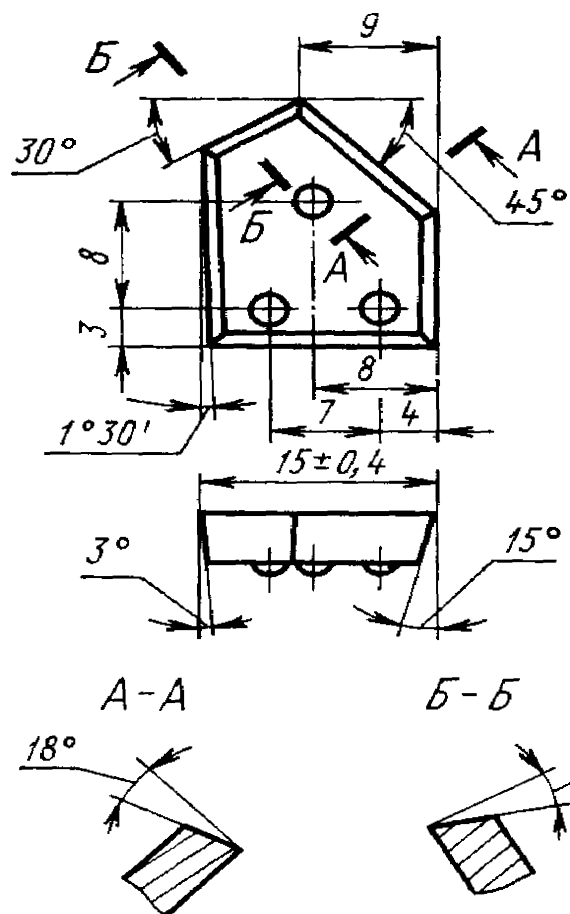
B-B



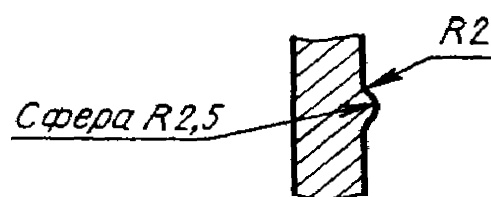
B-B



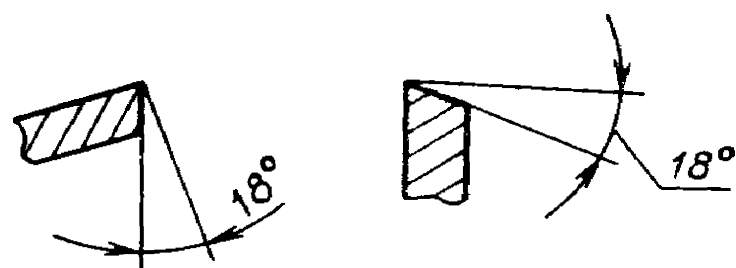
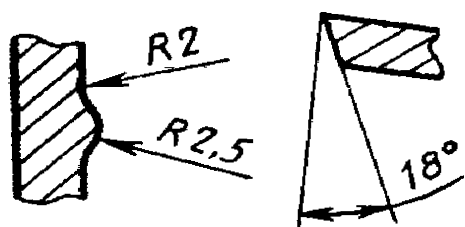
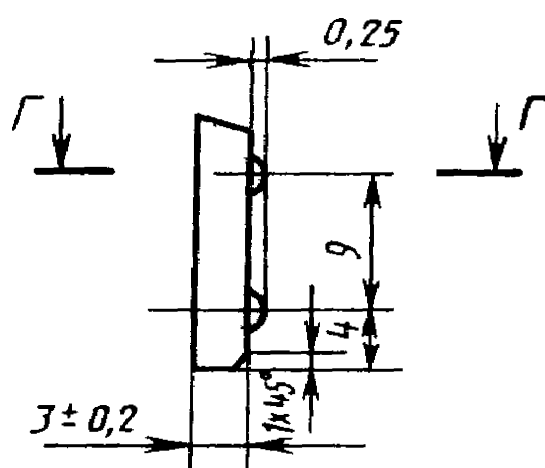
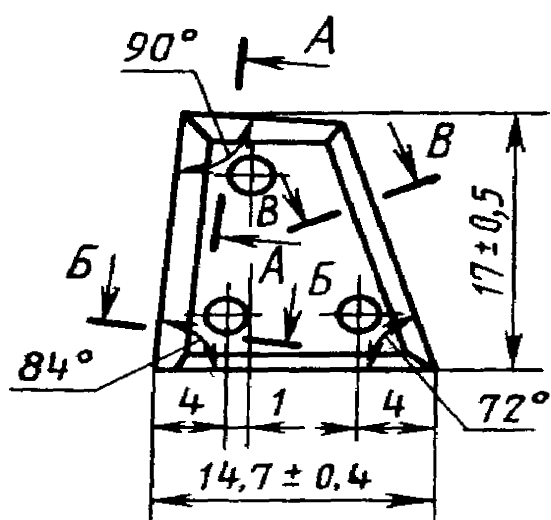
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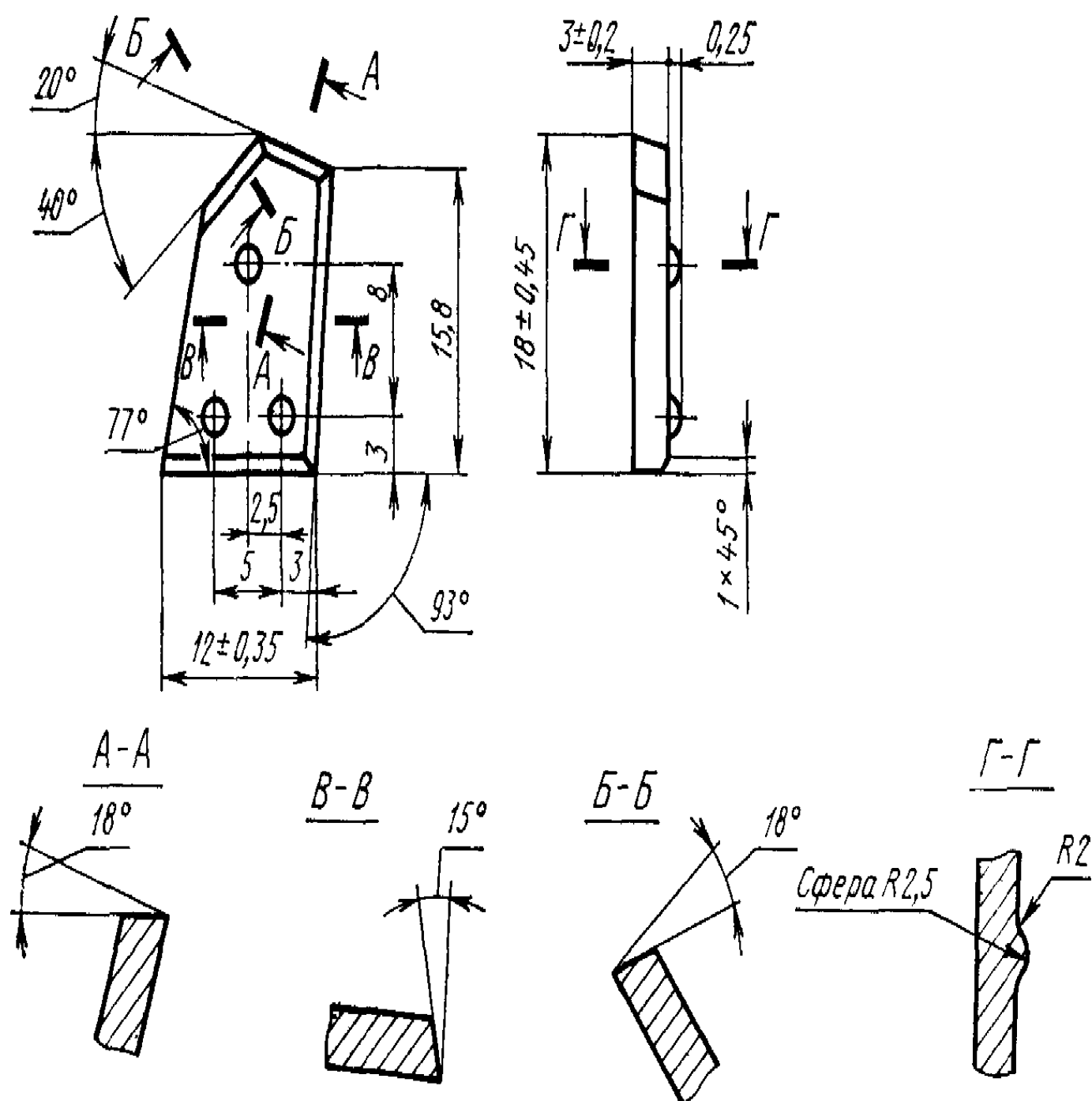
B-B



Черт. 15
Форма Г36

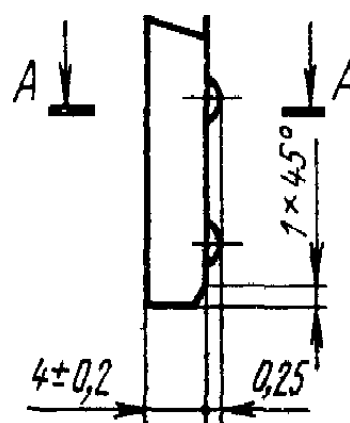
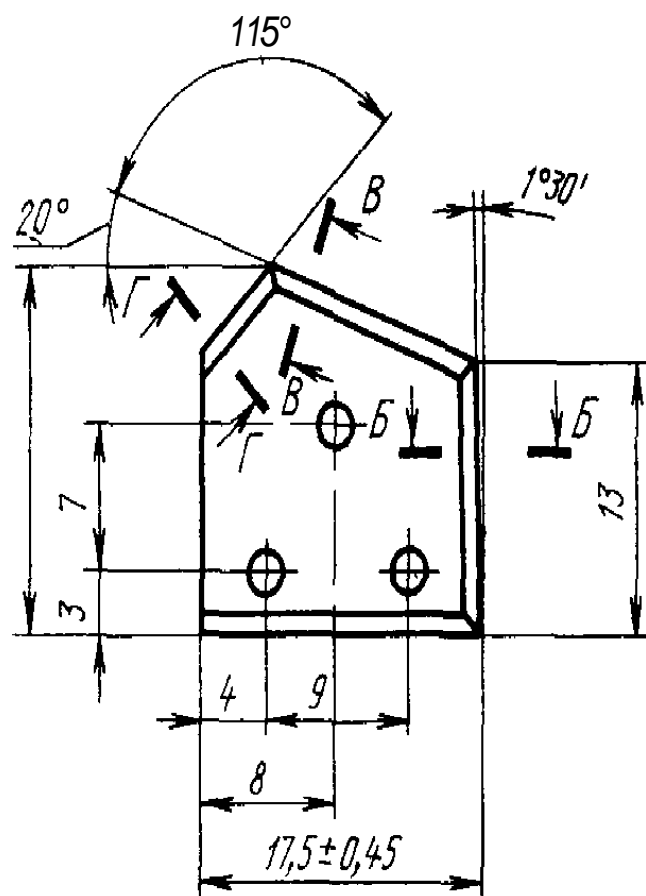


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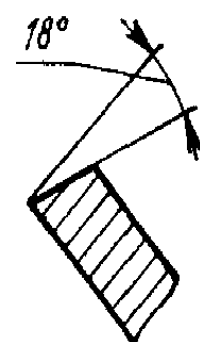
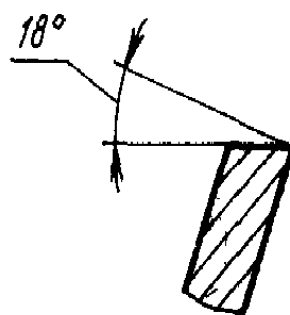
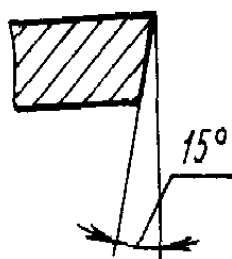
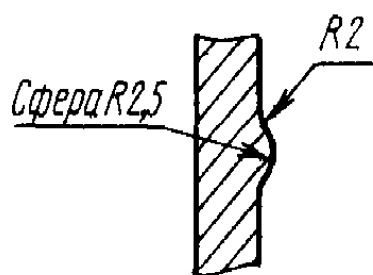


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5-5

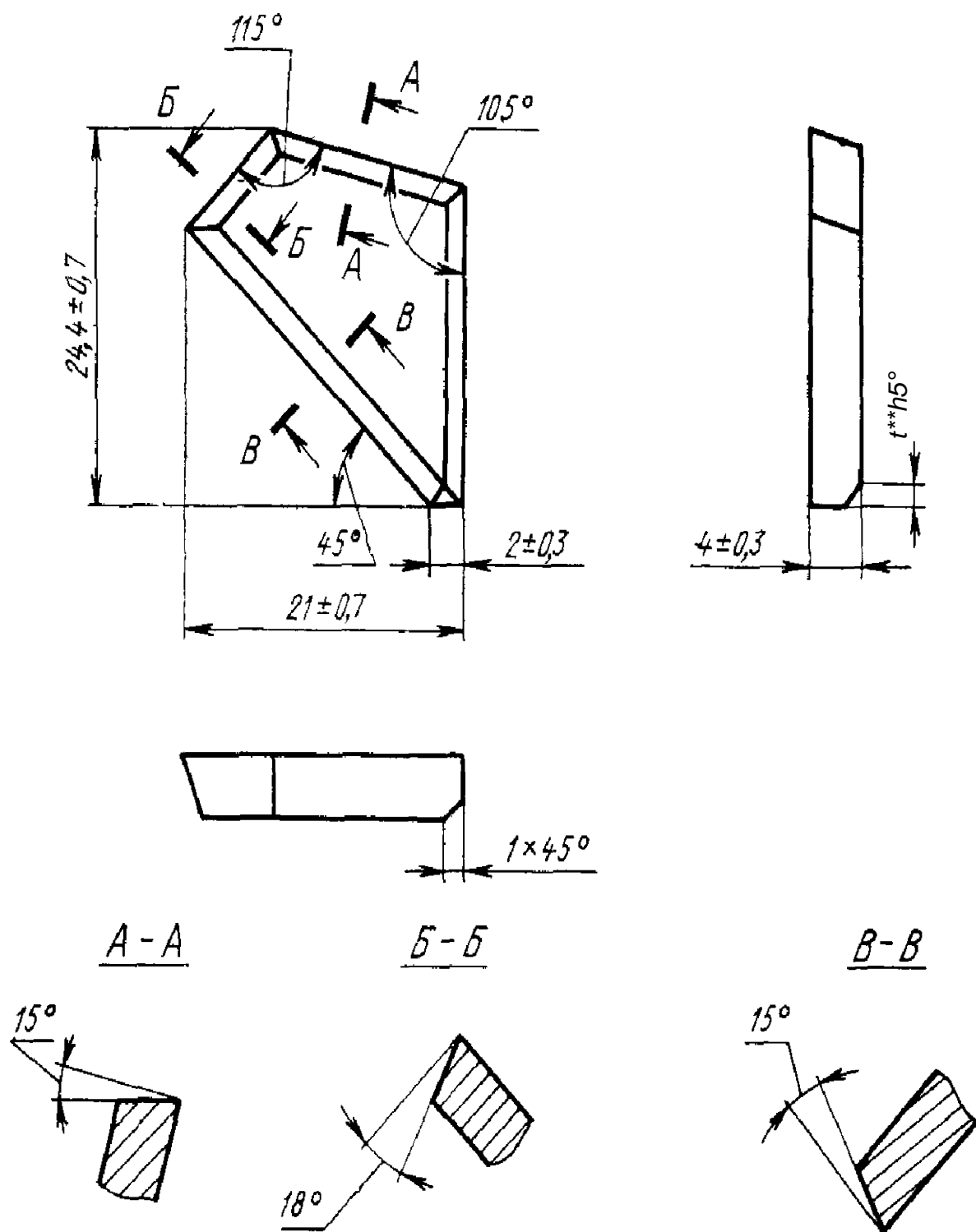
-8

-



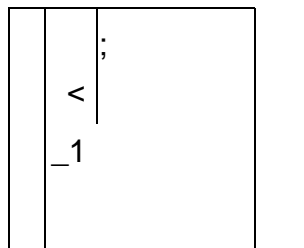
.18

40



Черт 20*

41



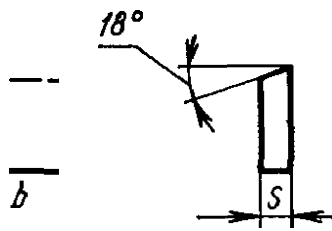
.21

1 1

			<i>k</i>		£	

4101	3,0	±0,20	15	±0,40	1,5	±0,15
4102	6,0	±0,25	20	±0,45	4,0	±0,20
4103	8,0				6,0	±0,25
4104	7,5	±0,20	15	±0,25	0,7	
4105	8,5					
4106	9,5					

51



. 22

1 2

			<i>h</i>		S ($\pm 0,2$)
5101	5,0	— 0.20	7	$\pm 0,25$	3
5102	7,5	$\pm 0,25$	10	$\pm 0,30$	
5103	8,5	$\pm 0,30$	8	$\pm 0,25$	
5 4			10	$\pm 0,30$	
5105	10,0		14	$\pm 0,40$	4
5106	1.5	$\pm 0,10$	12	$\pm 0,35$	3
5107	4,0	$\pm 0,20$	10	$\pm 0,30$	4
5108	3,0		8	$\pm 0,25$	3
5109	2,5	$\pm 0,15$	12	$\pm 0,35$	
5110	2,0				
5111	3,0		20	$\pm 0,50$	4

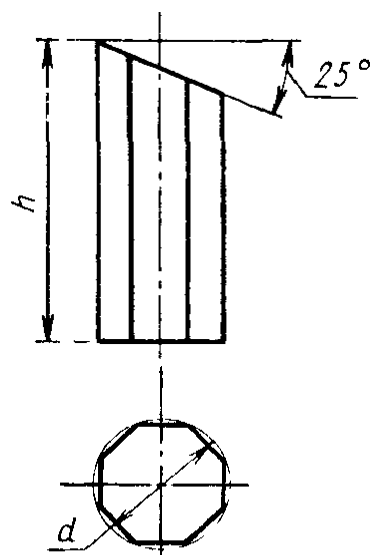
25°.

1X45°

5110

5111—

53



Черт. 23

13

	d ($\pm 0,2$)	h	
5301	5	5	$\pm 0,20$
5302		8	$\pm 0,25$
5303		10	$\pm 0,30$
5304	7	15	
5305		20	$\pm 0,40$

5301— 5303

25°*

54



. 24

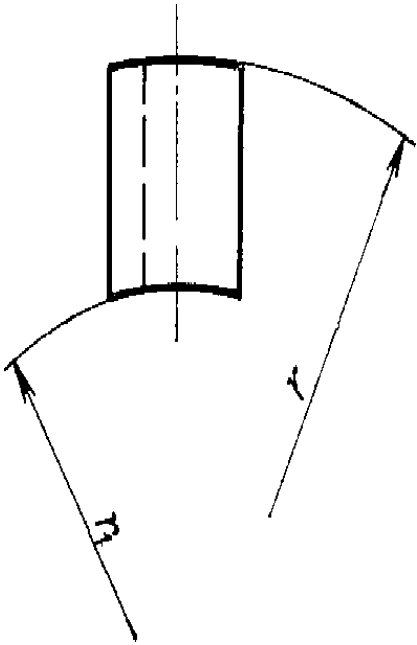
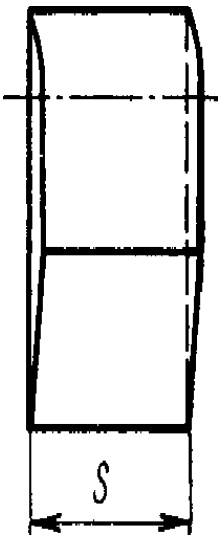
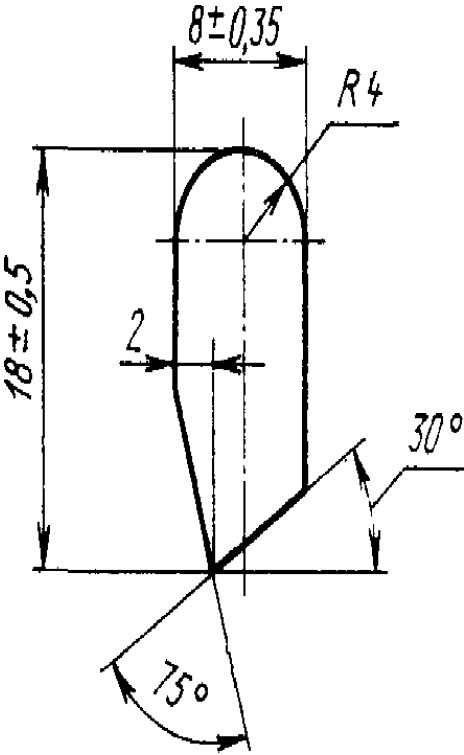
14

	d ($+0,3$)	h			d ($+0,3$)	h	
5401	3,2	3	$\pm 0,15$	5408	7,2	5	$\pm 0,20$
5402	4,2	4		5409	8,2	8	$\pm 0,25$
5403	5,2	5	$\pm 0,20$	5410		7	
5404		4	$\pm 0,15$	5411		6	$\pm 0,20$
5405	6,2	6	$\pm 0,25$	5412	10,2	8	$\pm 0,25$
5406		5	$\pm 0,20$	5413	12,2	10	$\pm 0,30$
5407	7,2	6	$\pm 0,25$	5414		8	$\pm 0,25$

55

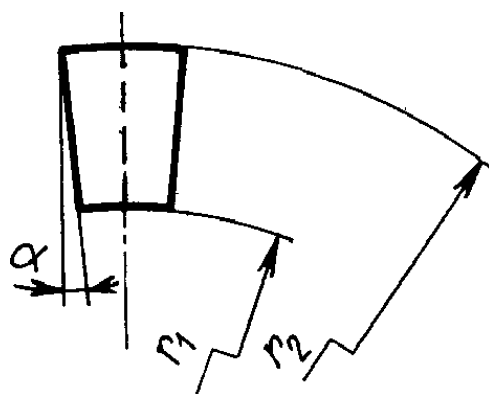
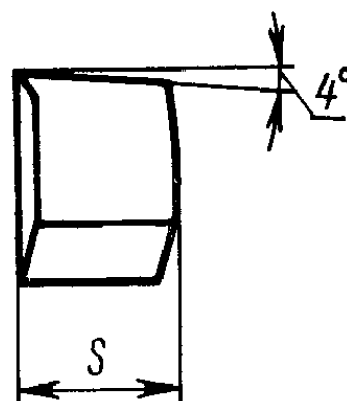
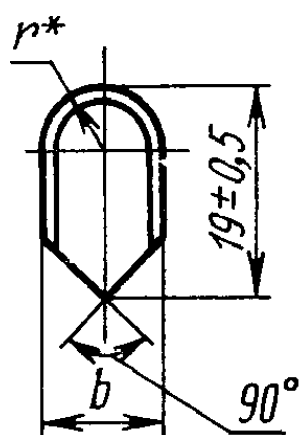
15

	s ($\pm 0,35$)		l
		± 1	
5501	10,7	29,5	19,5
5502	17,7	38,0	21,0



.25

57



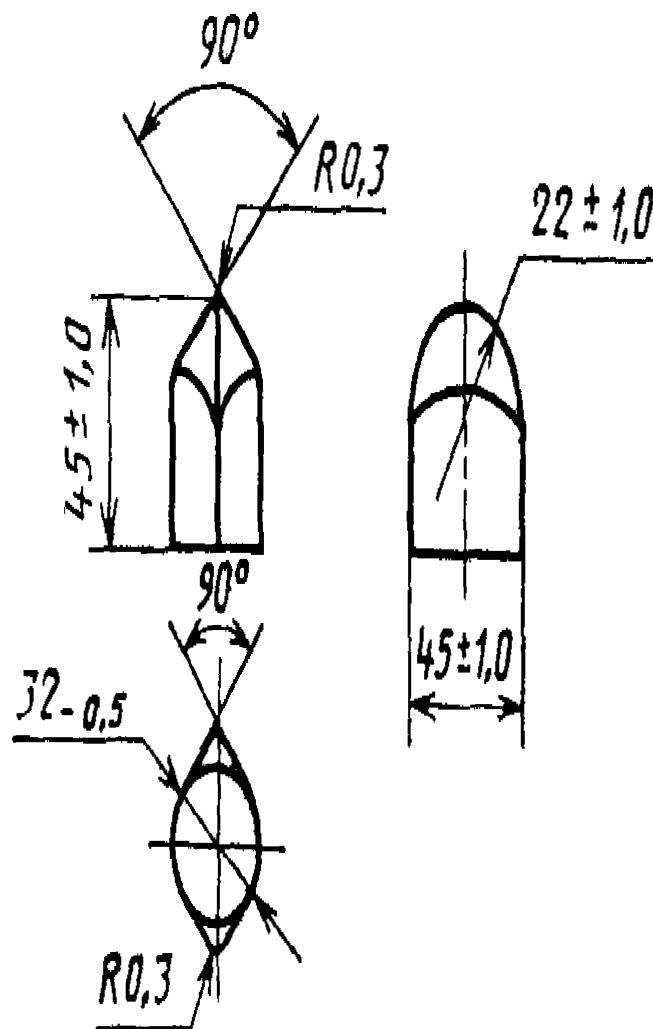
*

. 26

16

	(±0,35) °	(±0,4) °		1	2	
				±1		
5701	10,7	9	4.5	19,5	29,5	2°
5702	12,7	10	5,0	26,0	38,0	4°
5703	14,7	11	5,5	43,0	57,5	

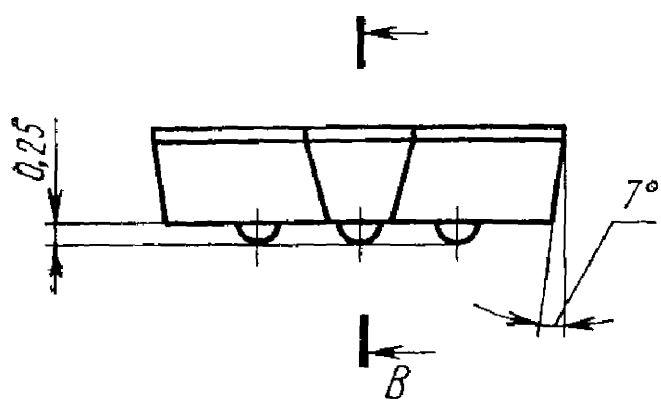
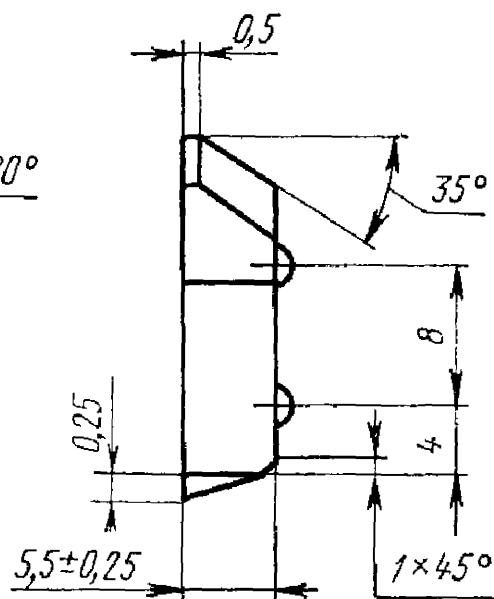
60



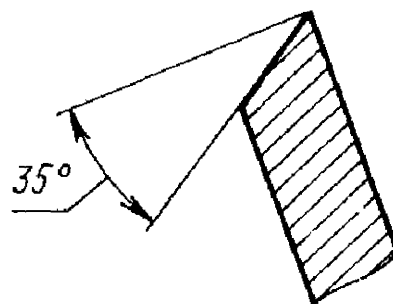
Черт. 29*

* . 27,28

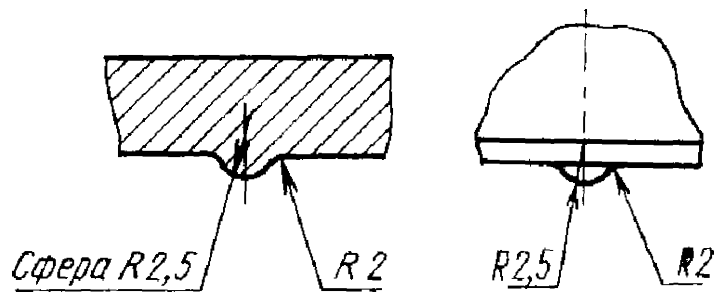
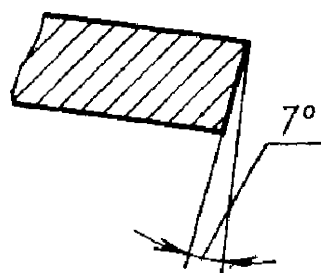
61



Б-Б



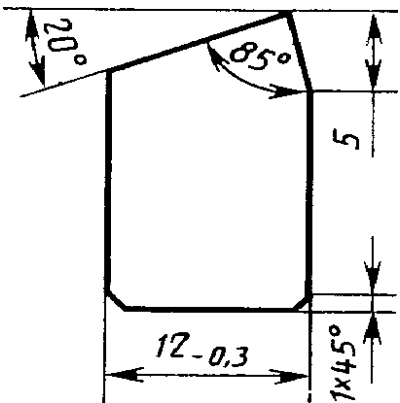
B-B



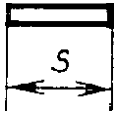
19**

63

	$\begin{matrix} s \\ (\pm 0,4) \end{matrix}$
6301	6
6302	8
6303	10

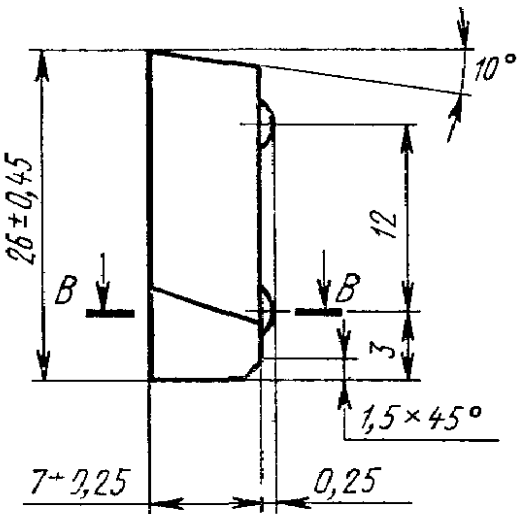
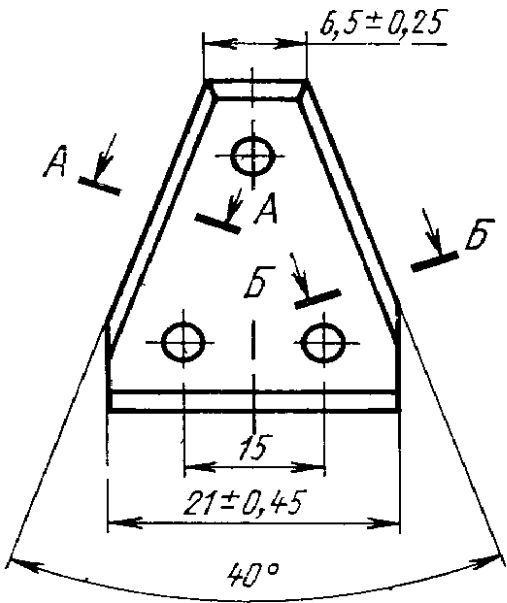


«5
+1



, 32**

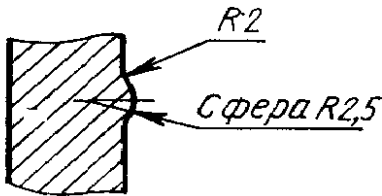
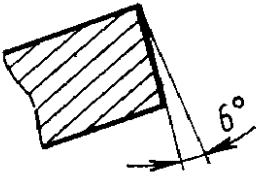
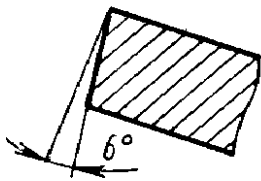
64



A-A

B-B

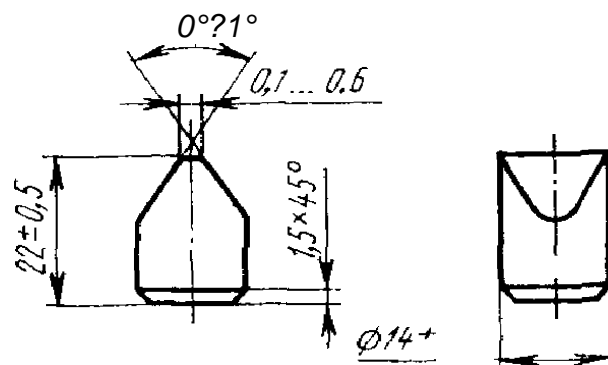
B-B



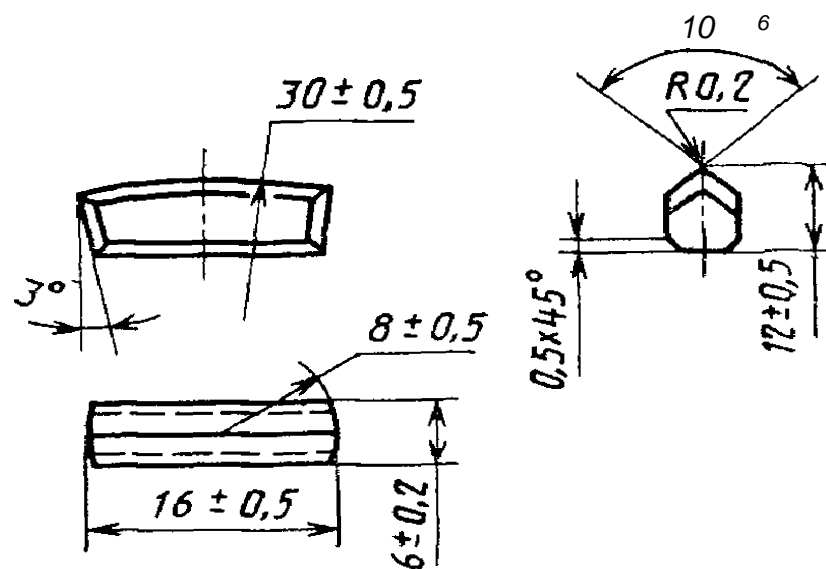
33

* . 31
** . 17, 18

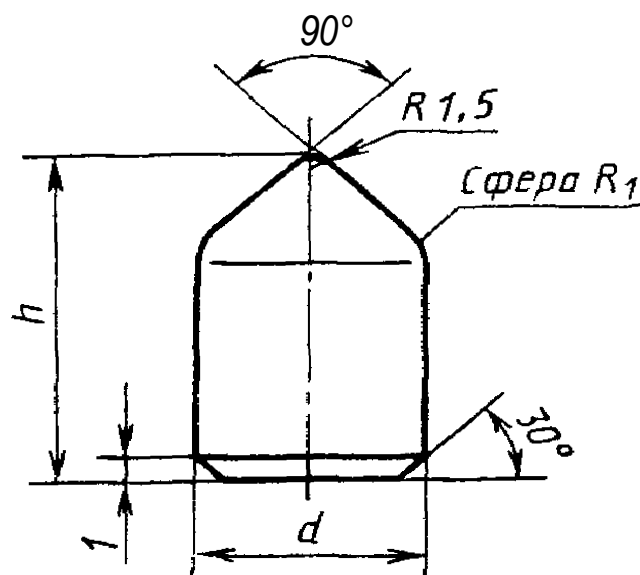
65



Черт. 34
Форма Г66



Черт. 35
Форма Г67



2 1 *

	<i>d</i>		<i>h</i>		*1
	
6701	7	0,3	15	+0,45	3,5
6702	9	±0,3	17	±0,45	4,5
67 03	12	± >	20	+0,60	6,0
6704	16	±0,3	24	±0,60	8,0

* . 20 .

() .

15 (16) :

, — 5 (6) —

. 2—21.

11 — 16 , 5 — 7,5 , = 14 : 8- , /= 28 ,

19 6533 2852 1101 880—75

:

1101 8— 880—75.

/— 13 , 5 — 4 , = 4,5 , $hi = 3$, =9 , \ = 6 ,
 os = 10°, cci = 3° :

19 6533 2859 24 —02 880—75

:

24 : 24 —02 8— 880—75.

1, 2. (, , 1, 2).
 3. —

(, . 1).
 4. —

:

5° + ;
 . 5° 15° ±1°;
 . 15° ±2°.

5. , , 24, 24 , 25, 26 67

(, . 2).

6. 23, 25, 26 54
- -

7. 34, 34, 36, 37 25°.
(, . 2).

8. 2601— 2605

0,3 .

9. 11, 12, 13, 14, 23, 24 65 -
30-50 . ,

0,1 .

65 014+⁰⁻³

(, . 1).

10. 3882-74.

11. - 4411-79.

12.

.

-			-	-		-
			,			,

1101		43.5		1107		94,8
1102		50.9		1108		103.5
1103		56.9	11	1109	6	113,1
1104		70.1		1110		111.6
1105	15	58,7				
1106		82.5				
1107		89.1		1201		18.5
1108		97,3		1202		20,2
1109		106,3		1203		26.6
1110		106,0		1204	15	23,4
				1205		29,0
				1206		34,8
1101		44.6		1207		30.3
102		52.2		1208		39.4
1103		58.3				
1104		71,8				
1105	11	60,1		1201		18,9
1106		84,5		1202		20.7
1107		91.3		1203		27.3
1108		99.7		1204	11	24.0
1109		108,4		1205		29.7
1110		108,0		1206		35,6
			12	1207		31.0
				1208		40.4
1101		45.7				
1102		53.5				
1103		59.8				
1104		73.6		1201		19.4
1105	8	61.6		1202		21,2
1106		86,6		1203		27,9
1107		93,5		1204	8	24,6
1108		102,1		1205		30.5
1109		111,6		1206		36.5
		110,3		1207		31,8
				1208		41,3
1101		46,3				
1102		54,2				
1103	6	60,6		1201		19,7
1104		74.6		1202	6	21,5
1105		62,5		1203		28,3
1106		87.7		1204		24,9

-			-	-			-
12	1205 1206 1207 1208 1209 1209 1209 1209	6 6 6 6 15 11 8 6	30,9 37,0 32,2 41,9 23,2 23,8 24,4 24,7		1404 1405 1406 1407 1408 1409 1410	15	39,0 42,0 48,0 54,0 48,0 49,0 58,5
13	1301 1302 1303 3304 1305 1306 1307 1308 1309 1310 1311 1312	15	54,0 63,3 102,0 72,3 81,9 39,6 40,3 45,3 57,3 69,2 93,7 162,9	14	1401 1402 1403 1404 1405 1406 1407 1408 1409 1410		10,3 15,5 22,7 40,7 43,4 49,1 56,7 49,6 50,1 59,4
	1301 1302 1303 1304 1305 1306 1307 1308 1309 1310 1311 1312		55,7 65,3 105,2 74,2 83,9 40,2 40,9 46,0 58,1 70,2 95,2 165,3	22	—	6	33,0
	1301 1302 1303 1304 1305 1306 1307 1308 1309 1310 1311 1312		57,5 67,3 108,5 76,5 86,0 41,3 42,0 47,2 59,8 72,2 97,8 169,9	23	2301 2302 2303 2307 2301 2302 2303 2307	8	9,2 7,7 16,2 26,1 8,8 7,4 15,5 25,0
	1301 1302 1303 1304 1305 1306 1307 1308 1309 1310 1311 1312		57,5 67,3 108,5 76,5 86,0 41,3 42,0 47,2 59,8 72,2 97,8 169,9	24	2401 2402 2403	8	9,0 12,0 25,0
	1301 1302 1303 1304 1305 1306 1307 1308 1309 1310 1311 1312		57,5 67,3 108,5 76,5 86,0 41,3 42,0 47,2 59,8 72,2 97,8 169,9	24	24 -02 24 -03 24 -05 24 -06	8	8,9 26,1 46,8 35,3
	1301 1302 1303 1304 1305 1306 1307 1308 1309 1310 1311 1312		57,5 67,3 108,5 76,5 86,0 41,3 42,0 47,2 59,8 72,2 97,8 169,9	25	2501 2502 2503 2504 2505 2506 2507 2508 2509 2510 2511 2512 2513 2514	15;	0,6 1,2 1,0 2,4 2,1 1,8 3,8 3,1 2,9 6,7 4,4 9,0 7,7 7,0
14	1401 1402 1403	15	10,0 15,0 22,0				

25			2515	6,2		2606	1.7
			2516	11,0		2607	4.1
			2517	10,0		2608	3.0
			2518	9.0		2609	2.5
			2519	8.1		2610	2.2
			2520	16,2		2611	5.9
			2521	15.0		2612	5.3
			2522	13,9		2613	4.7
			2523	12,8		2614	4.1
			2524	11,6		2615	3.5
			2525	17.7		2616	2.9
			2526	16.4		2617	9;i
			2527	15.5		2618	8.4
			2528	14.0		2619	7.6
			2529	12.7		2620	6.8
			2530	11.6		2621	6,0
			2531	10.5		2622	5.2
			2532	24.8		2623	4.4
			2533	24.6		2624	12.3
			2534	23.0		2625	11.3
		15;	2535	19.8		2626	10.3
		11	2536	18,2		2627	9.3
			2537	30.5		2628	8.4
			2538	27.7		2629	7.4
			2539	26,2	26	2630	6.4
			2540	24.6		2631	17.3
			2541	23.1		2632	16,0
			2542	39.2		2633	14.9
			2543	38.9		2634	13,7
			2544	33.9		2635	13.2
			2545	30.2		2636	11.2
			2546	26.9		2637	10,0
			2547	46.8		2638	8,8
			2548	44.2		2639	20.5
			2549	41.6		2640	19.1
			2550	39.1		2641	17.6
			2551	36,5		2642	16.2
			2552	58.2		2643	14.7
			2553	52.4		2644	13,3
			2554	46.5		2645	11.8
			2555	43.6		2646	27.8
			2556	40.7		2647	26,1
26			2601	0,5		2648	24.2
			2602	1,0		2649	22.5
		8	2603	0,8		2650	20,7
				2,2		2651	18.9
			2605	1,9		2652	17.2
						2653	15.5
						2654	34.1

26	2655		32.0		4101		1,0
	2656		29.9		4102		7.1
	2657		27.9		4103	6	14,2
	2658		25.9		4104		1.2
	2659		23.8		4105		1,3
	2660		21.8		4106		1,5
	2661		19.7				
	2662		43.7				
	2663		41.3	41			
	2664		36,5		4101		0,9
	2665		34.2		4102		7.0
	2666		31.8		4103	8	14,0
	2667		29.4		4104		1.1
	2668		27.0		4105		1,2
	2669	8	24.7		4106		1,4
	2670	8	52.1				
	2671		49.4				
	2672		46.7				
	2673		44.0				
	2674		41.2		5101		1.5
	2675		38.5		5102		3.2
	2676		36.8		5103		2,9
	2677		35.8		5104		3.6
	2678		64,7		5105		7,8
	2679		58.5		106		0,8
	2680		52.3		5107		2.3
2681		49.2		5108		1,1	
2682		46.1		5109		1.4	
2683		43.0		5110		1,0	
2684		40.0		5111		3.5	
32	—		30,0	51			
	—		14,0			1.4	
						3.1	
						2,8	
34	—		11,8			3.5	
						7,7	
34	—		11,8			0,8	
		8			8	2,2	
						1,0	
36	—		10,0			1.3	
37	—		8,0			3.4	
38	—.		14,0				
40	—		14,9				

-			-	-			-
			,				,

53	5301	8	1,6	60	6010	6	492,0
	5302		2,2	61	—	8	30,0
	5303		2,3				
	5304		7,5				
	5305		10,0	63	6301 6302 6303	8	17.4 22,0 27.4
54	5401	0,3	64	—	41,5		
	5402	0,8					
	5403	1.5					
	5404	1,0	65	—			39,5
	5405	2.6					
	5406	1,8					
	5407	3,6	1'66	6601	6	20,0	
	5408	3,4		6602 6603 6604	5	22,0 38,0 44,0	
	5409	6,2					
	5410	5,9					
	5411	5,0					
	5412	9,8		6602	8	23,0	
	5413	16,7					
	5414	13,3					
55	5501	15	22,0	67	6701	8	8,8
	5502		36,5		6702		14,4
57	5701	20,0	6703		28,8		
	5702	26,3	6704		58,7		
	5703	30,8					

(, . **1,2).**

11	15 8- 6-	19 6527 2852 19 6534 2852 19 6533 2852 19 6532 2852
12	15 1 8- 6-	19 6527 2853 19 6534 2853 19 6533 2853 19 6532 2853
13	15 11- 8-	19 6527 2854 19 6534 2854 19 6533 2854
14	15 -	19 6527 2855 19 6534 2855
22	6-	19 6532 2856
23	8 11-	19 6525 2857 19 6537 2857
24	8-	19 6533 2858
24	8-	19 6533 2859
25	15 -	19 6527 2860 6537 2860
26	BK8-B 8-	19 6533 2861 19 6535 2861

32	8	19 6525 2862
	8	19 6525 2863
34	8	19 6525 2864
34	8	19 6525 2865
36	8	19 6525 2866
37		19 6525 2867
38	8	19 6525 2868
40		19 6525 2877
41	8	19 6524 2870 19 6525 2870
51	8	19 6524 2871 19 6525 2871
53	8	19 6525 2872
54	6- 4-	19 6532 2873 19 6531 2873
55	15	19 6527 2874
57	15	19 6527 2878
60	6	19 6524 2880
61	8-	19 6533 2881
63	8	19 6525 2883
64	8	19 6525 2884
65	8	19 6525 2885
66	6- 15 8-	19 6532 2886 19 6527 2886 19 6533 2886
67	8-	19 6533 2887

(, . 2).

3 880—75

25.01.89

01.07.89

2. 11 4107, 4108
:

			<i>h</i>		<i>S</i>	
4107		±0,15	10	±0,25	→ »	±0,15
4108	3,0	±0,20			1.5	

(. . 84)

Приложение 1. Таблицу дополнить номерами изделий Т4107, Т4108 и со-
ответствующими значениями

Форма изделия	Номер изделия	Марка твердого сплава	Ориентировочная масса изделия, г
Т41	Т4107	ВК6, ВК8	0,5
	Т4108		0,7

ИВС № 4 1989 г.)

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