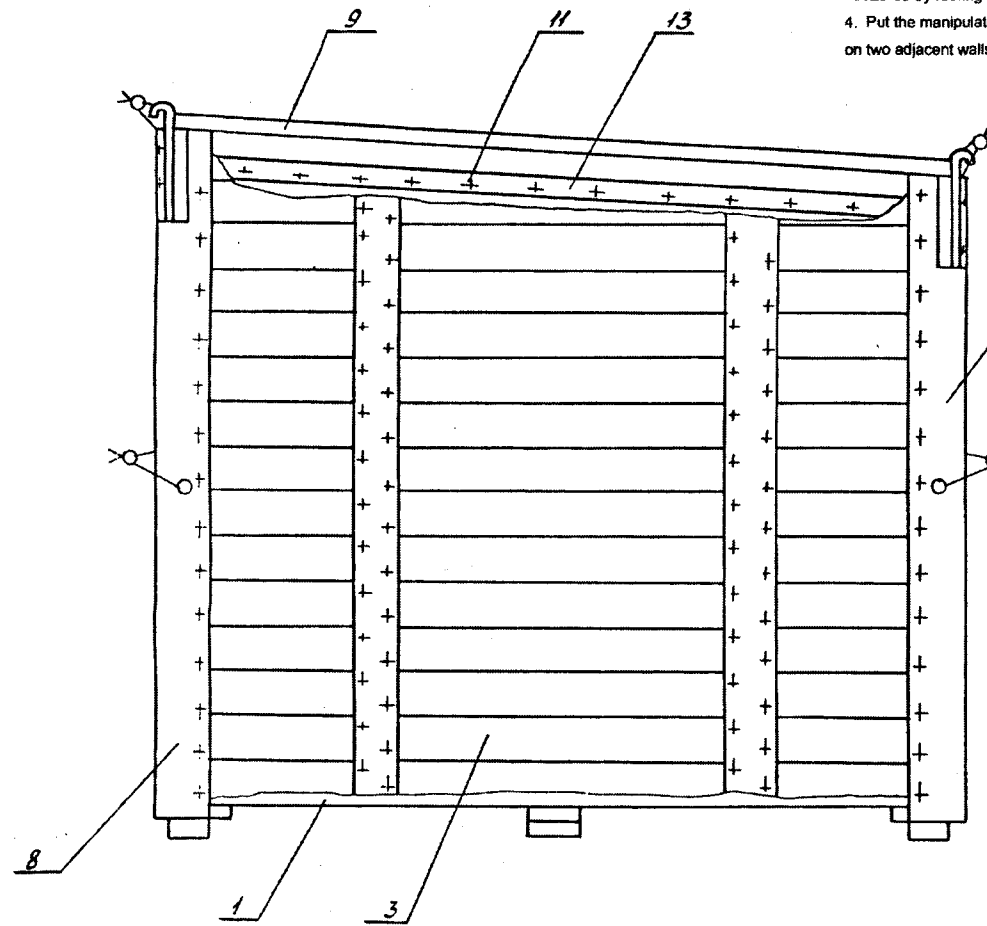
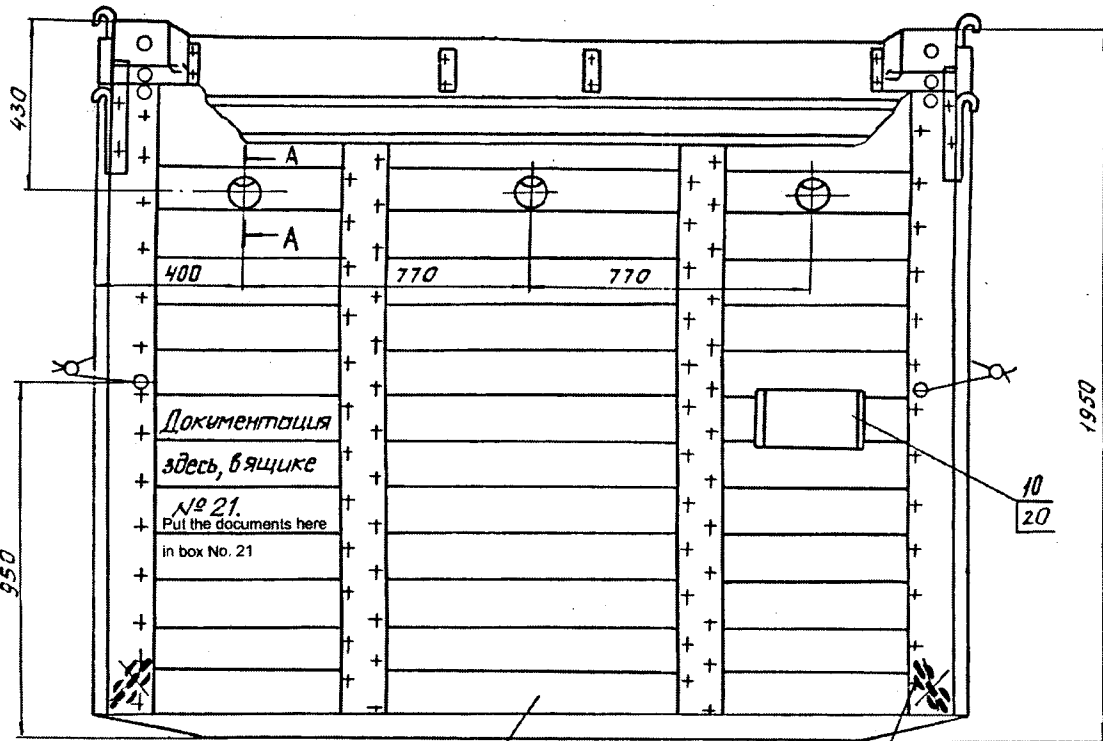


First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A3			AK-630-Ya Sb 200-1TR SB	Assembly drawing			
					<u>Assembly units</u>			
	A4	1		AK-630-Ya Sb200-1-1TR	Frame	1		
	A4	2		AK-630-Ya Sb200-1-2TR	Cross board	1		
	A4	3		AK-630-Ya Sb200-1-3TR	Longitudinal board	1		
	A4	4		AK-630-Ya Sb200-1-4TR	Cross board	1		
	A4	5		AK-630-Ya Sb200-1-5TR	Longitudinal board	1		
	A4	6		AK-630-Ya Sb200-1-6TR	Cover	1		
					<u>Components</u>			
Sign and D.	A4	7		AK-630-Ya 200-25TR	Corner strap	4		
	A4	8		AK-630-Ya 200-26TR	Corner strap	4		
	A4	9		AK-630-Ya 200-1-27TR	Upper strap	2		
	WD	10		AK-630-Ya 200-1-32TR	Pocket for packing list	1		
					1TR			
	WD	20		AK-630-Ya 200-1-50TR	Packet, polyethylene	1		
					film T 0.15x3000			
					grade 1 GOST 10354-82			
					B x H = 110± 5x150±5			
Date	AK-630-Ya Sb 200-1 TR							
	Amend.	Sheet	Doc. No.	Sign	Date			
Orig. Inv. No.	Developed by				Type	Sheet	Sheets	
	Checked by				A	1	2	
	Head of Q.C.D							
	Approved by							
				Transportation box No.1 TR				

1. After positioning of article on the frame, put the skids component 200-1-21 TR.
2. Cover the internal walls and the bottom of box with roof tracing paper P 350 GOST 2697-83 or by the paper DB GOST 8828-89 by roofing it with thick woolen cloth having dimension of 3.5 to 5.0x25 position 15 and with nails 2x2.5 position 11.
3. Cover the external surface of the cover of box in two layers, and the internal one - with 1 layer ruberoid RKK-350 GOST 10923-93 by roofing it up with thick woolen cloth having dimension of 3.5 to 5.0x25 position 15 and with nails position 14*.
4. Put the manipulated markings No. 1, 3, 11 (-) with dimensions for label No. 4 as per GOST 14192-96 on the left top corner on two adjacent walls.

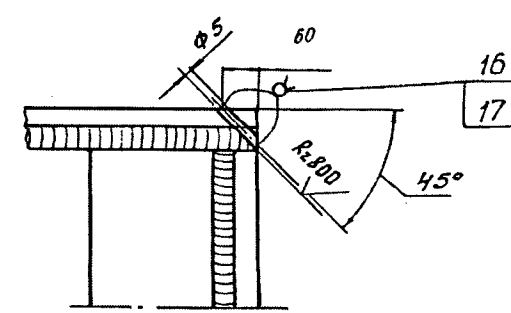


5. Make the inscriptions and markings with enamel PF-115 black GOST 6465-76. Arrange the font PO-24 GOST 2930-62 symmetrically. Mark the remaining transportation marking with paint on the front and side walls with the indication of index of article, box no., article no., in conformity with GOST 14192-96 and in conformity with agreement.
6. After corking, sew the box on the corners according to sketch and seal the box with wire KO 0.5 GOST 792-67 and 16 seals 1-6x10-AD1M GOST 18677-73.
7. Technical requirements as per GOST 10198-91.
8. Local shaving of each side with area not more than 20% with depth up to 1 mm and with finishing of Rz1200 is permitted.
9. Remaining technical specifications as per GOST V 6454-75 and GOST 10198-91.
10. Put the folder AK-630-Я 210-4 with operating documents in the poly-ethylene cover AK-630-Я 210-1, seal it. Put the packet with documents in the box no. 21.
11. Wrap up the packing list in water-proof paper DB GOST 8828-89 and put in packet position 20. Seal the ends of packet. It is permitted to use poly-ethylene sheet (film) M, linen 0.15x3000 of grade 1 GOST 10354-82 for the manufacturing of packet position 20.

1. После постановки изделия на каркас поставить бруска дет. 200-1-21ТР.
2. Внутренние стенки и дно ящика обить пергамином кровельным П-350 ГОСТ2697-83 или бумагой упаковочной ДБ ГОСТ 8828-89 с креплением ее дранью 3,5-5,0x25 поз. 15 и гвоздями 2x2,5 поз.11.
3. Наружную поверхность крышки ящика обить в два слоя, а внутреннюю 1 слой рубероидом РКК-350 ГОСТ 10923-93 с креплением дранью размером 3,5-5,0x25 поз. 15 и гвоздями поз.14*.
4. Манипуляционные знаки № 1, 3, 11 (↑) с размерами для ярлыка №4 по ГОСТ 14192-96 располагать в левом верхнем углу на 2-х соседних стенках.
5. Надписи и знаки выполнять эмалью ПФ-115 черная ГОСТ 6465-76. Шрифт ПО-24 ГОСТ 2930-62 располагать симметрично. Остальную транспортную маркировку нанести краской на передней и боковой стенках в соответствии с ГОСТ 14192-96 и договору с указанием индекса изделия, № ящика, № изделия.
6. После укупорки ящик прошить по углам согласно эскизу и опломбировать с использованием проволоки КО 0,5 ГОСТ 792-67 и 16 пломб 1-6x10-АД1М ГОСТ 18677-73.
7. Технические требования по ГОСТ 10198-91.
8. Допускается местная непростройка каждой стороны площадью не более 20%, глубиной до 1мм и чистой обработки Rz1200.
9. Остальные технические условия по ГОСТ В 6454-75 и ГОСТ 10198-91.
10. Пакет АК-630-Я 210-4 с н/с эксплуатационной документацией вложить в полиэтиленовый пакет АК-630-Я 210-1, заварить его. Пакет с документацией уложить в ящик №21.
11. Упаковочный лист завернуть в водонепроницаемую бумагу ДБ ГОСТ8828-89 и вложить в пакет поз. 20. Концы пакета заварить. Допускается применение пленки полиэтиленовой М, полотно 0,15x3000 сорт 1 ГОСТ10354-82 для изготовления пакета поз. 20.

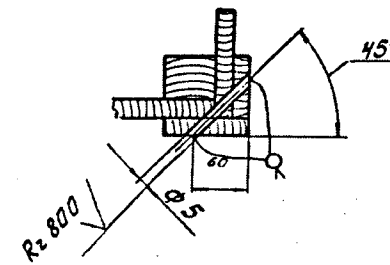
Drilling and sealing of top plank

Сверление и пломбировка верхней планки

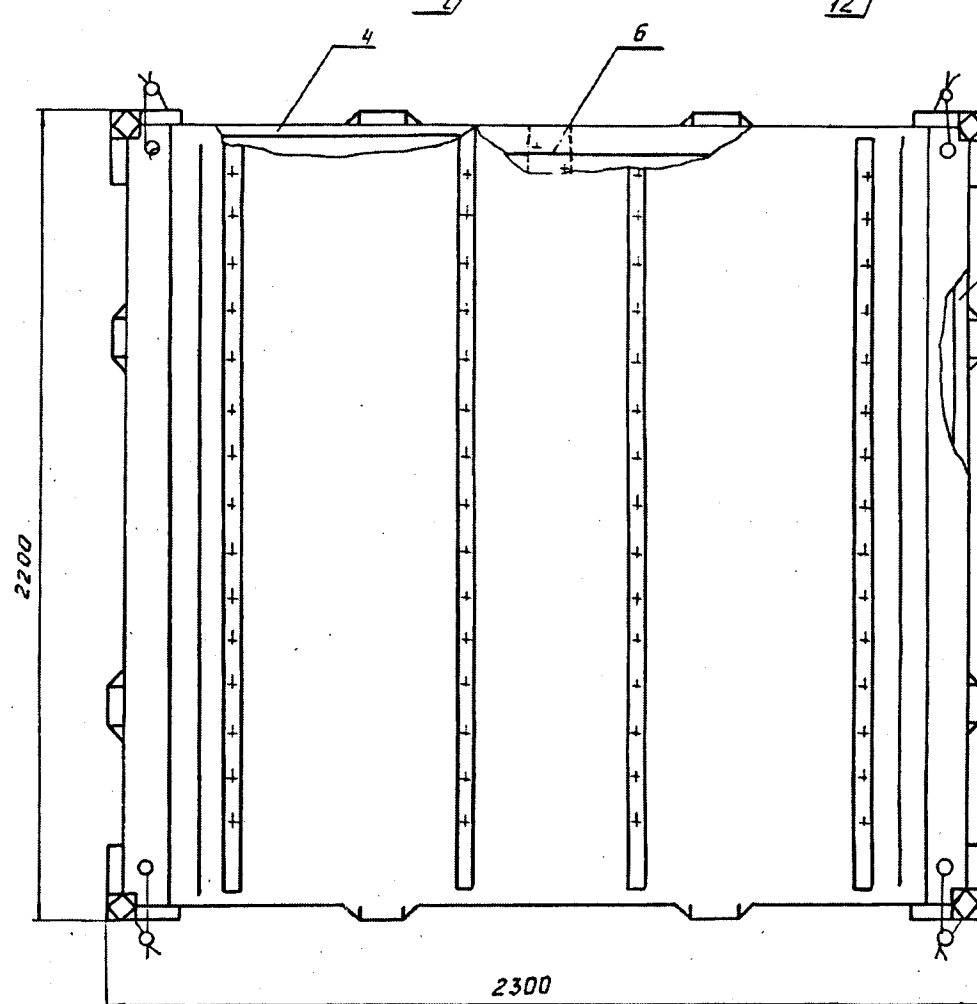


Drilling and sealing of angular cleats/planks

Сверление и пломбировка угловых планок



Шифр докум. Подп. и дата Изм. и дата Шифр и дата Шифр и дата
 Справа от Лев. примен.

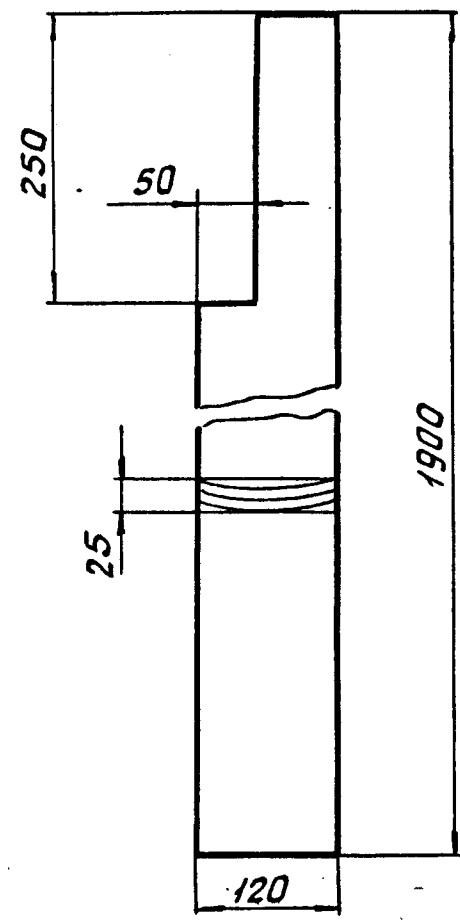


AK-630-Я Sb 200-1 TR SB

AK-630-Я СБ200-1ТР СБ		Type		Mass		Scale	
Изм./Лист	№ док-м.	Подп.	Дата	Лист	Масса	Масштаб	
Разраб.				A	840	1:10	
Проб.				Ящик транспортно-рабочий №1 ТР			
Т.контр.				Сборочный чертёж			
И.контр.				Transportation Box No. 1 TR			
Экз.				Assembly Drawing			
				Лист	Листов 1		
				Sheet	Total Sheets 1		

AK-630 -Ya 200-1-25TR

Rz 800 / √(√)

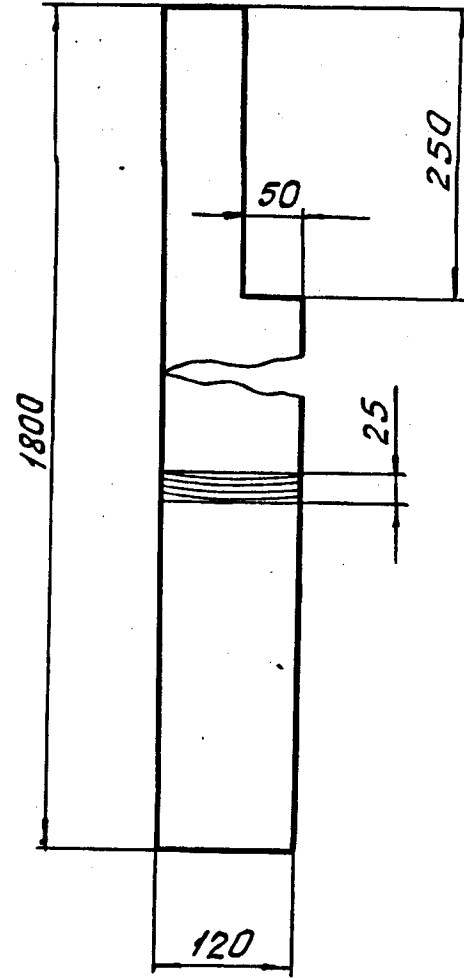


Maximum deviation of dimensions as per mean accuracy class GOST 6449.5-82.

Approved OGMet Orig. Inv. No.	and Date	Approved TOSb Alternate Inv. No.	Approved KTONI Sign and L.	Approved by shop Reference No.	First use																																																		
AK-630 -Ya 200-1-25 TR																																																							
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th>Amend.</th> <th>Sheet</th> <th>Doc. No.</th> <th>Sign</th> <th>Date</th> </tr> </thead> <tbody> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> </tbody> </table>						Amend.	Sheet	Doc. No.	Sign	Date																																													
Amend.	Sheet	Doc. No.	Sign	Date																																																			
Corner strap				Type A	Weight 5.7	Scale 1:5																																																	
Board-2Khv-25x125 GOST 8486-86				Sheet	Sheets 1																																																		
Copied by			Format A4																																																				

AK-630 -Ya 200-1-26TR

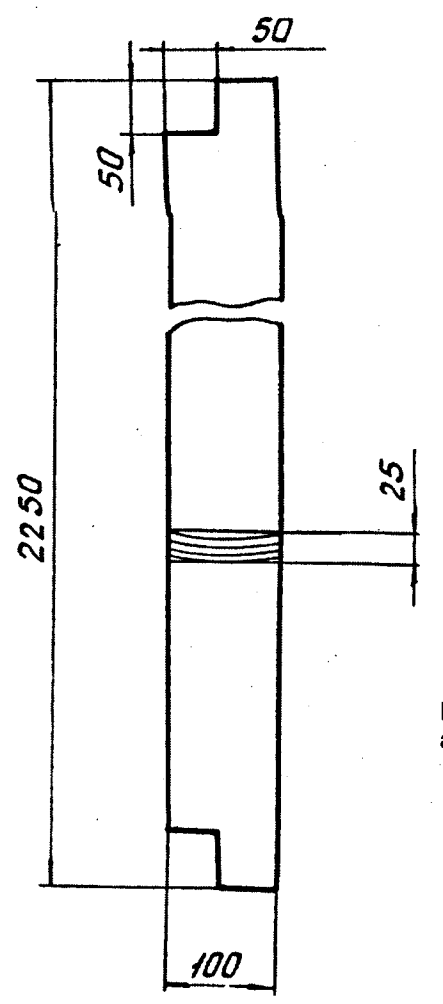
Rz 800
√(√)



Maximum deviation of dimensions as per mean accuracy class GOST 6449.5-82.

Approved OGMet	and Date	Approved TOSb	Approved KTONI	Approved by shop	First use
Orig. Inv. No.	Altermate Inv. No.	Dupl. Inv. No.	Sign and I.	Reference No.	
AK-630 -Ya 200-1-26 TR					
Amend.	Sheet	Doc. No.	Sign	Date	
Developed by					
Checked by					
Head of Q.C.D					
Design bureau chief					
Head of Q.C.D					
Approved by					
Corner strap					
		Type	Weight	Scale	
		A	5.4	1:5	
			Sheet	Sheets 1	
Board-2Khv-25x125					
GOST 8486-86					
Copied by			Format A4		

AK-630 -Ya 200-1-27TR



Rz 800
√(√)

Maximum deviation of dimensions as per mean accuracy class GOST 6449.5-82.

Approved OGMet		Approved TOSb		Approved KTONI		Approved by shop		First use	
Orig. Inv. No.		Alternate Inv. No.		Dupl. Inv. No.		Reference No.			
Sign.		Date		Sign and Date					
Amend.		Sheet		Doc. No.		Sign		Date	
Developed by									
Checked by									
Head of Q.C.D									
Design bureau chief									
Head of Q.C.D									
Approved by									
AK-630 -Ya 200-1-27 TR									
Upper strap				Type	Weight	Scale			
				A	5.6	1:5			
				Sheet	Sheets 1				
				Board-2Khv-25x125 GOST 8486-86					

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AK-630-Ya 200-1-32 TR

First use

Reference No.

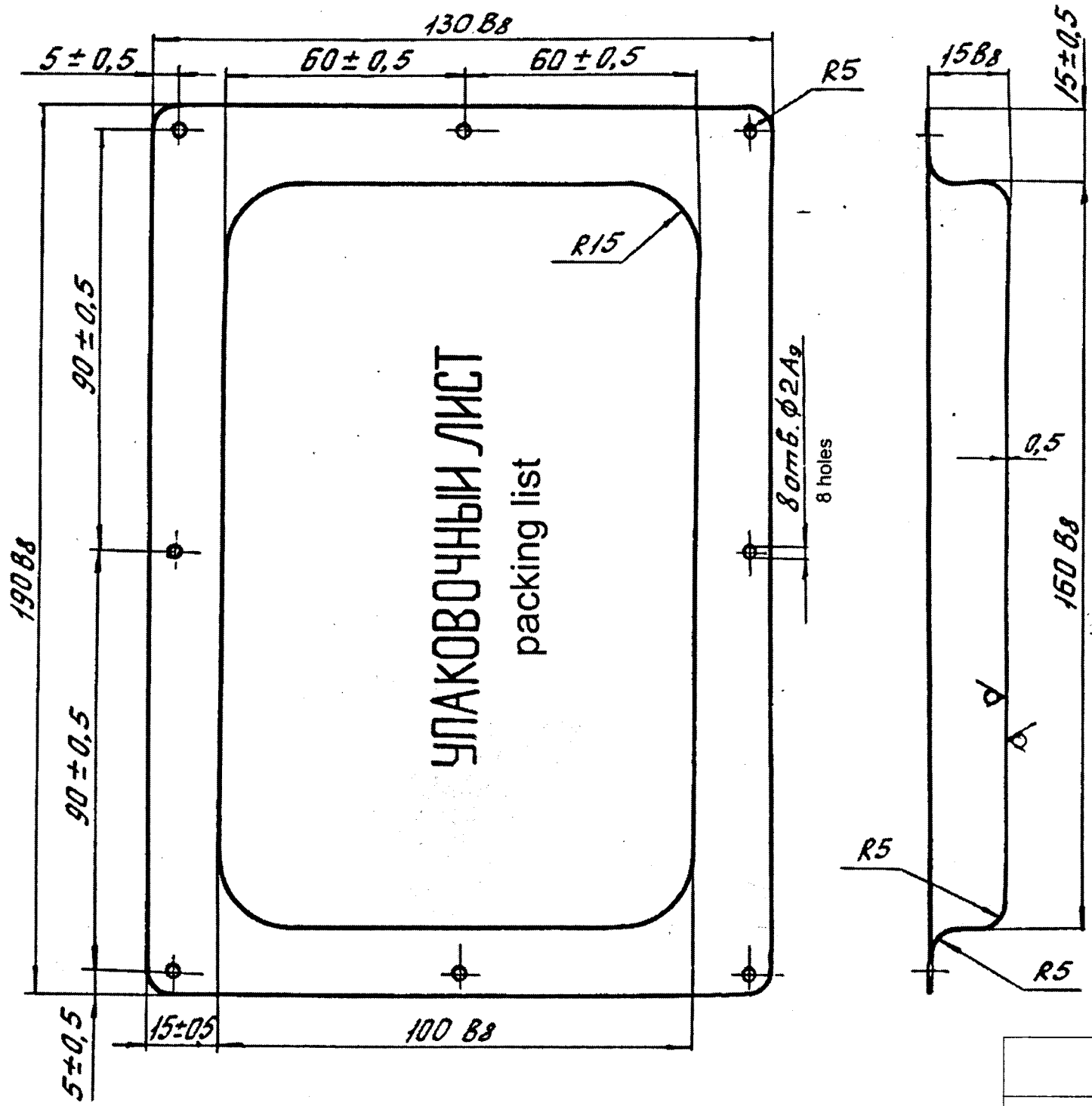
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

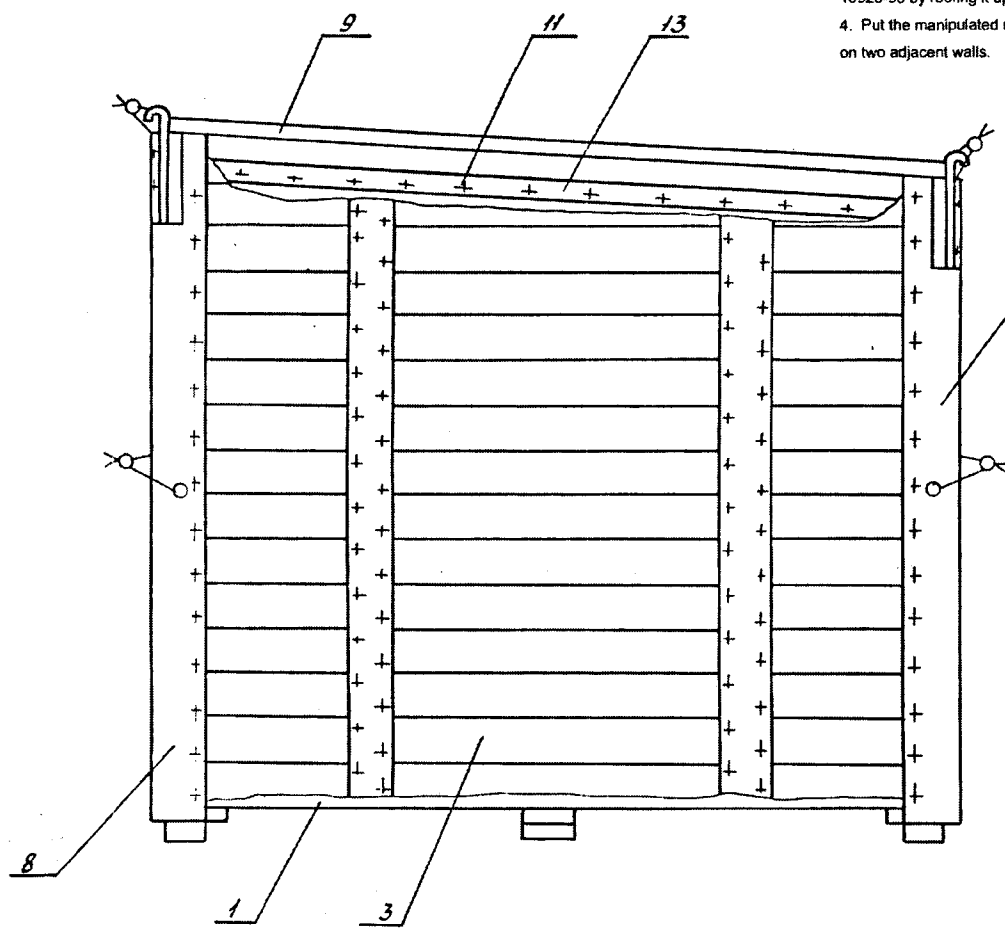
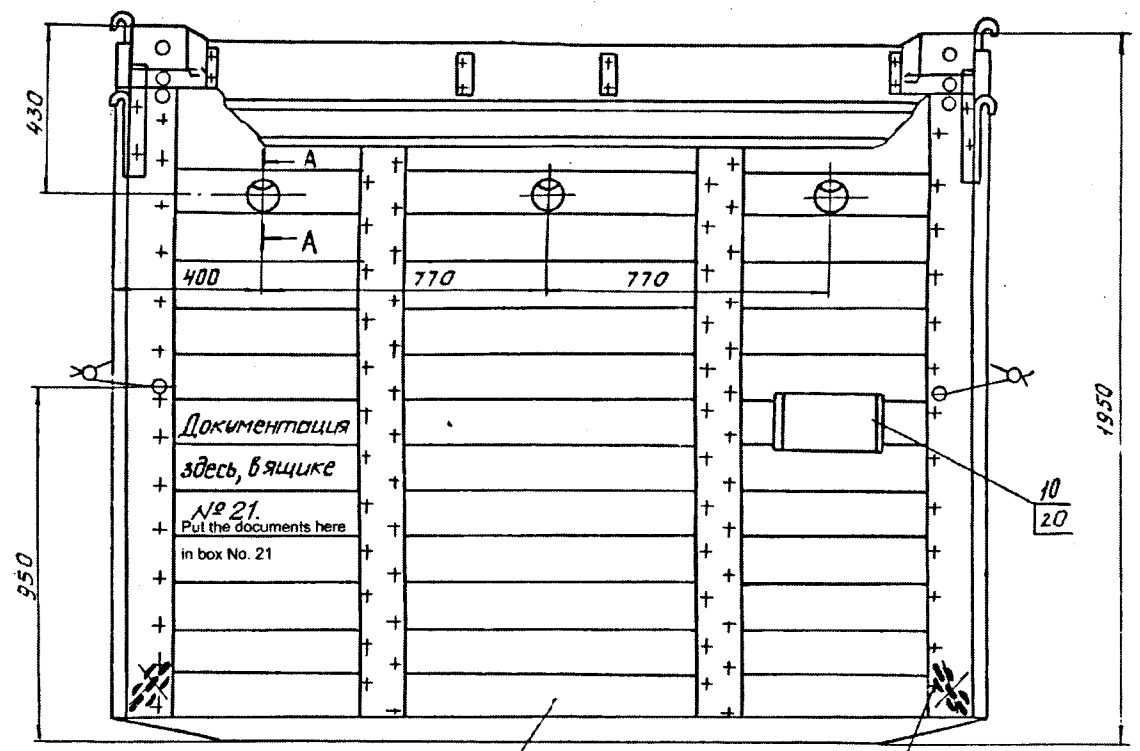


УПАКОВОЧНЫЙ ЛИСТ
packing list

1. Blunt sharp edges ~0.4 mm.
2. Coating: Cd12.Phos.
3. Apply inscriptions with enamel PF-115, white GOST 6465-76. Letter size PO-10 GOST 2930-62.
4. Inscriptions in English PACKING LIST.
5. Mark Ч, Ш and stamp K on tag.

					AK-630-Ya 200-1-32 TR			
Amend.	Sheet	Doc. No.	Sign	Date	Pocket for packing list 1TR	Type	Weight	Scale
Developed by						A		1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Sheet $\frac{B - PN - 0.5 \times 1000 \times 2000 \text{ GOST } 19904 - 74}{II - sh - VG - 08KPGOST9045 - 80}$			
Approved by								

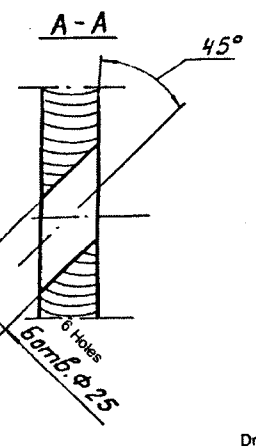
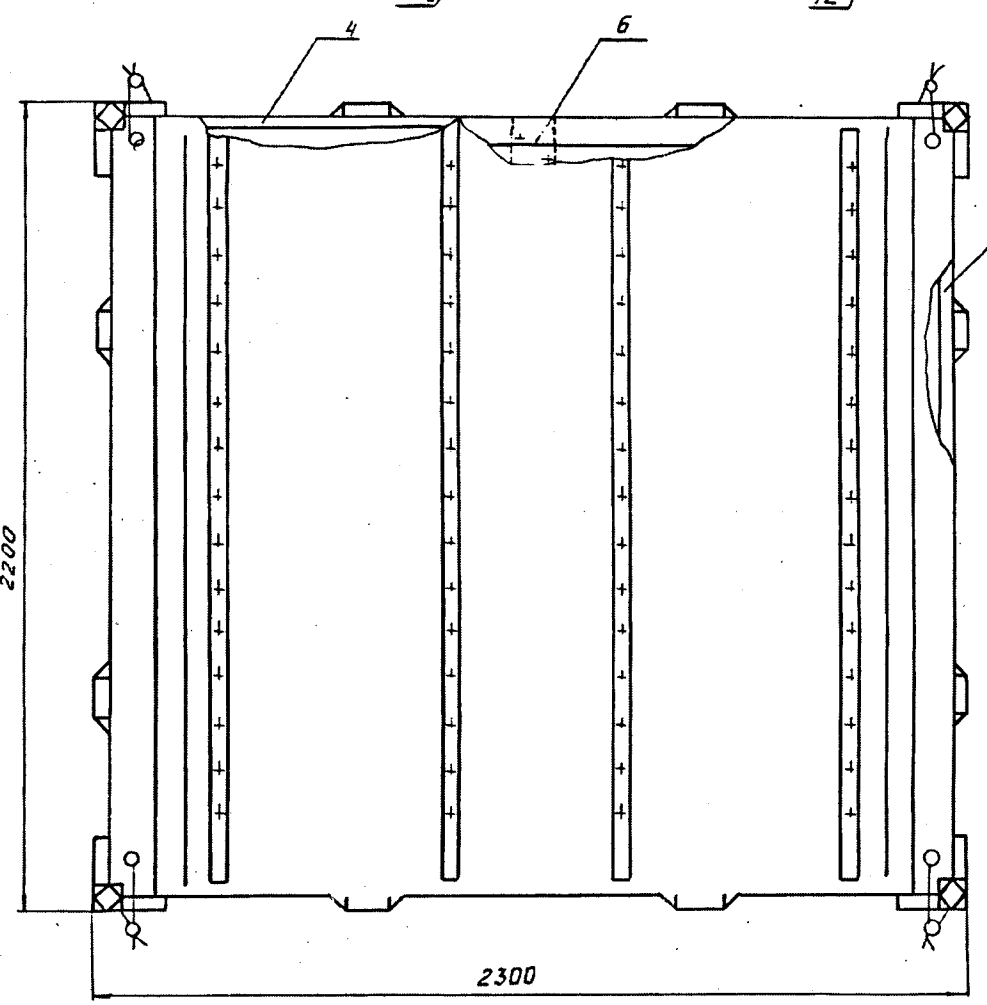
First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
				AK-630-Ya Sb 200-1TR SB	Assembly drawing			
Sign and Date					<u>Components</u>			
	A3	/	1	AK-630-Ya 200-1-1TR	Left rear support	1		
	A3	/	2	AK-630-Ya 200-1-2TR	Right rear support	1		
	A3	/	3	AK-630-Ya 200-1-3TR	Right front support	1		
	A3	/	4	AK-630-Ya 200-1-4TR	Left front support	1		
	A3	/	5	AK-630-Ya 200-1-5TR	Upper beam	2		
	A3	/	6	AK-630-Ya 200-1-6TR	Lower longitudinal beam	2		
	A3	/	7	AK-630-Ya 200-1-7TR	Lower cross beam	2		
	A3	/	8	AK-630-Ya 200-1-8TR	Lower longitudinal beam	1		
	A3	/	9	AK-630-Ya 200-1-9TR	Spacer bar	6		
	A2	/	10	AK-630-Ya 200-1-10TR	Cross bar	2		
	A4	/	11	AK-630-Ya 200-1-11TR	Strap	4		
	A4	/	12	AK-630-Ya 200-1-12TR	Clamp	54		
	Dupl. Inv. No.	A3	/	13	AK-630-Ya 200-1-13TR	Support bar	4	
		A3	/	14	AK-630-Ya 200-1-14TR	Longitudinal strut	4	
		A3	/	15	AK-630-Ya 200-1-15TR	Middle longitudinal beam	2	
		A3	/	16	AK-630-Ya 200-1-16TR	Support	2	
	Alternate Inv. No.	A3	/	17	AK-630-Ya 200-1-17TR	Jamb	4	
		A3	/	19	AK-630-Ya 200-1-19TR	Bolt	4	
		A3	/	20	AK-630-Ya 200-1-20TR	Washer	4	
	Orig. Inv. No.	A4	/	21	AK-630-Ya 200-1-21TR	Upper beam	2	
				AK-630-Ya Sb 200-1-1 TR				
				Frame				
Amend.	Sheet	Doc. No.	Sign	Date	Type	Sheet	Sheets	
Developed by					A	1	2	
Checked by								
Head of Q.C.D								
Approved by								



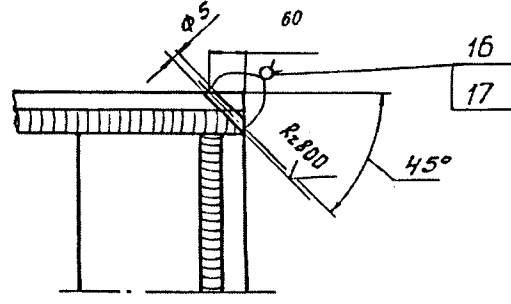
1. After positioning of article on the frame, put the skids component 200-1-21 TR.
2. Cover the internal walls and the bottom of box with roof tracing paper P 350 GOST 2697-83 or by the paper DB GOST 8828-89 by roofing it with thick woolen cloth having dimension of 3.5 to 5.0x25 position 15 and with nails 2x2.5 position 11.
3. Cover the external surface of the cover of box in two layers, and the internal one - with 1 layer ruberoid RKK-350 GOST 10923-93 by roofing it up with thick woolen cloth having dimension of 3.5 to 5.0x25 position 15 and with nails position 14.
4. Put the manipulated markings No. 1, 3, 11 (-) with dimensions for label No. 4 as per GOST 14192-96 on the left top corner on two adjacent walls.

5. Make the inscriptions and markings with enamel PF-115 black GOST 6465-76. Arrange the font PO-24 GOST 2930-62 symmetrically. Mark the remaining transportation marking with paint on the front and side walls with the indication of index of article, box no., article no., in conformity with GOST 14192-96 and in conformity with agreement.
6. After corking, sew the box on the corners according to sketch and seal the box with wire KO 0.5 GOST 792-67 and 16 seals 1-6x10-AD1M GOST 18677-73.
7. Technical requirements as per GOST 10198-91.
8. Local shaving of each side with area not more than 20% with depth up to 1 mm and with finishing of Rz1200 is permitted.
9. Remaining technical specifications as per GOST V 6454-75 and GOST 10198-91.
10. Put the folder AK-630-Я 210-4 with operating documents in the poly-ethylene cover AK-630-Я 210-1, seal it. Put the packet with documents in the box no. 21.
11. Wrap up the packing list in water-proof paper DB GOST 8828-89 and put in packet position 20. Seal the ends of packet. It is permitted to use poly-ethylene sheet (film) M, linen 0.15x3000 of grade 1 GOST 10354-82 for the manufacturing of packet position 20.

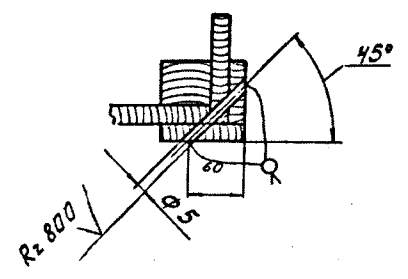
1. После постановки изделия на каркас поставить брусья дет. 200-1-21ТР.
2. Внутренние стенки и дно ящика обить пергамином кровельным П-350 ГОСТ2697-83 или бумагой упаковочной ДБ ГОСТ 8828-89 с креплением ее дранью 3,5-5,0x25 поз. 15 и гвоздями 2x2,5 поз. 11.
3. Наружную поверхность крышки ящика обить в два слоя, а внутреннюю 1 слой рубероидом РКК-350 ГОСТ 10923-93 с креплением дранью размером 3,5-5,0x25 поз. 15 и гвоздями поз.14.
4. Манипуляционные знаки № 1, 3, 11 (↑) с размерами для ярлыка №4 по ГОСТ 14192-96 располагать в левом верхнем углу на 2-х соседних стенках.
5. Надписи и знаки выполнять эмалью ПФ-115 черная ГОСТ 6465-76. Шрифт ПО-24 ГОСТ 2930-62 располагать симметрично. Остальную транспортную маркировку нанести краской на передней и боковой стенках в соответствии с ГОСТ 14192-96 и договору с указанием индекса изделия, № ящика, № изделия.
6. После укупорки ящик прошить по углам согласно эскизу и опломбировать с использованием проволоки КО 0,5 ГОСТ 792-67 и 16 plomb 1-6x10-АД1М ГОСТ 18677-73.
7. Технические требования по ГОСТ 10198-91.
8. Допускается местная непроstroжка каждой стороны площадью не более 20%, глубиной до 1мм и чистотой обработки Rz1200.
9. Остальные технические условия по ГОСТ В 6454-75 и ГОСТ 10198-91.
10. Папку АК-630-Я 210-4 с н/с эксплуатационной документацией вложить в полиэтиленовый пакет АК-630-Я 210-1, заварить его. Пакет с документацией уложить в ящик №21.
11. Упаковочный лист завернуть в водонепроницаемую бумагу ДБ ГОСТ8828-89 и вложить в пакет поз. 20. Концы пакета заварить. Допускается применение пленки полиэтиленовой М, полотно 0,15x3000 сорт 1 ГОСТ10354-82 для изготовления пакета поз. 20.



Drilling and sealing of top plank
Сверление и пломбировка верхней планки



Drilling and sealing of angular cleats/planks
Сверление и пломбировка угловых планок



Швы не паять. Паять и сварка вгон. шва. Швы не паять. Паять и сварка. Справ. шт. Перв. примен.

AK-630-Я СБ 200-1 ТР СБ		AK-630-Я СБ 200-1 ТР СБ	
Изм. Лист	№ док. м.	Подп.	Дата
Разраб.			
Проб.			
Т. экз. пр.			
И. экз. пр.			
Ящик транспортно-рабочий №1 ТР Сборочный чертеж		Лист	Листов 1
Transportation Box No. 1 TR		Sheet	Total Sheets 1
Assembly Drawing			

First use

Reference No.

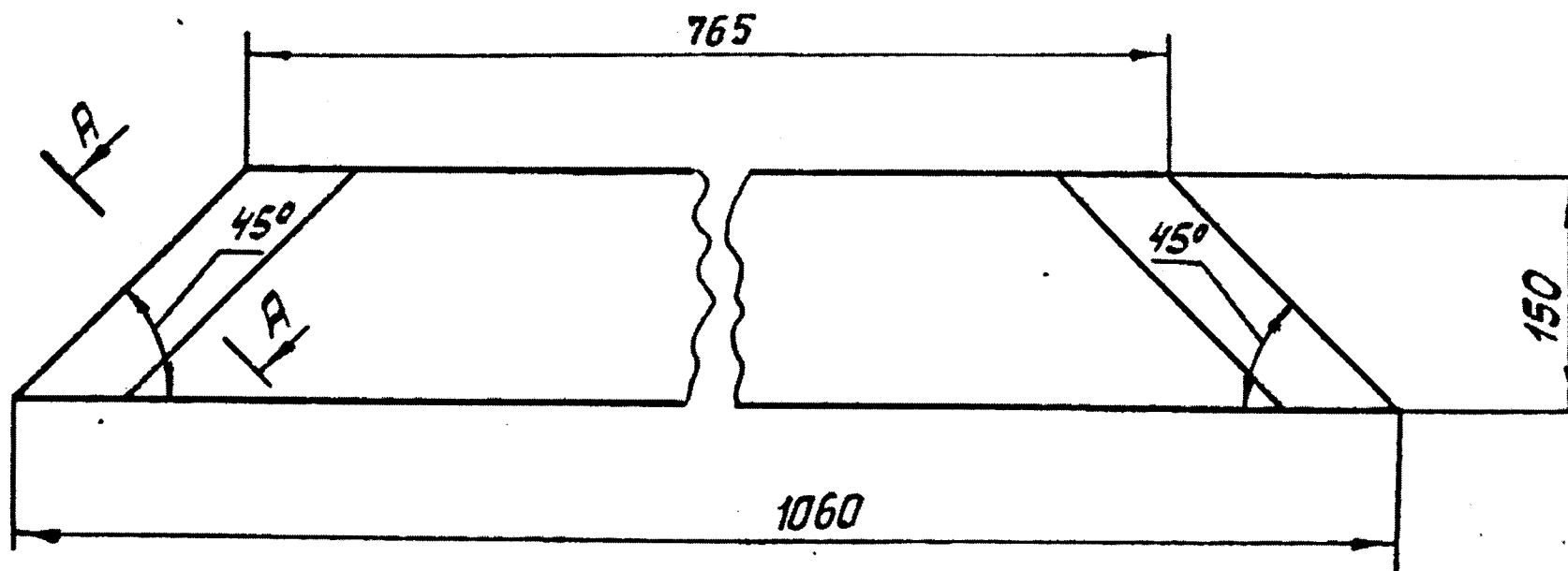
Sign and Date

Duplicate Inv. No

Alternate Inv. No

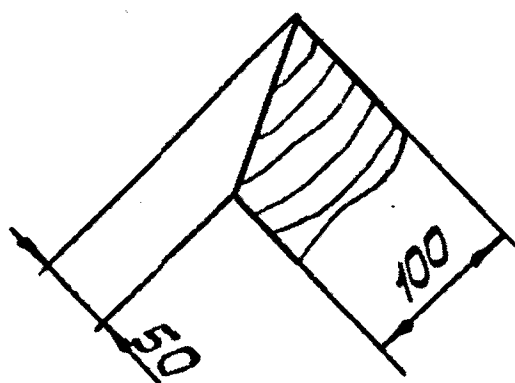
Sign and Date

Orig. inv. no.



Rz 500/√(✓)

A-A



Maximum deviation of dimensions as per standard accuracy class GOST 6449.5-82.

					AK-630-Ya 200-1-17 TR			
Amend.	Sheet	Doc.No.	Sign	Date	Post	Type	Weight	Scale
Developed by						A	14.3	1:5
Checked by						Sheet	Sheets	1
Head of Q.C.D					Beam-2KhV-100x100 GOST 8486-86			
Approved by								

AK-630 -Ya 200-1-11TR

First use					
Approved by shop Reference No.					
Approved KTONI Sign and Date					
Approved TOSb Dupl. Inv. No.					
Alternate Inv. No.					
Sign a.					
Date					
Approved OGI/Met Orig. Inv. No.					

Rz 160 $\sqrt{(\checkmark)}$

1.* Reference dimension.
 2. Blunt sharp edges ~0.6 mm.
 3. Coating: Cd6 Cr.
 4. Mark Ш, Ч and stamp K as per AK-630M TU I.

AK-630 -Ya 200-1-11 TR				
Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				

	Type	Weight	Scale
Strap	A	0.168	1:1
Sheet		Sheets 1	

Sheet $\frac{B - PN - 5GOST19903 - 74}{25 - 2 - TGOST1577 - 93}$

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AK-630 -Ya 200-1-12TR

Approved by shop	Reference No.	Approved by shop	Reference No.	First use													
Approved by shop	Reference No.	Approved by shop	Reference No.	First use													
Approved by shop	Reference No.	Approved by shop	Reference No.	First use													
Approved by shop	Reference No.	Approved by shop	Reference No.	First use													
Approved by shop	Reference No.	Approved by shop	Reference No.	First use													
Approved by shop	Reference No.	Approved by shop	Reference No.	First use													
Approved by shop	Reference No.	Approved by shop	Reference No.	First use	<p>1.* Dimensions ensured by tool. 2. Blank length L = 350 B_g. 3. Variation in height of faces A and B not more than 10 mm. 4. Cuts on legs are applied from two sides , with depth not more than 3 mm and width 2-3 mm. 5. Mark Ш, Ч and stamp K as per AK-630 M TU 1. 6. Coating: Chem.Phos.Oil.</p>												
Approved by shop	Reference No.	Approved by shop	Reference No.	First use	<p>AK-630 -Ya 200-1-12 TR</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 20%;"></td> <td style="width: 10%; text-align: center;">Type</td> <td style="width: 10%; text-align: center;">Weight</td> <td style="width: 10%; text-align: center;">Scale</td> </tr> <tr> <td style="text-align: center;">Clamp</td> <td style="text-align: center;">A</td> <td style="text-align: center;">0.7</td> <td style="text-align: center;">1:1</td> </tr> <tr> <td style="text-align: center;">Sheet</td> <td colspan="3" style="text-align: center;">Sheets 1</td> </tr> </table> <p>Wheel $V - 5GOST 7417 - 76$ $25 - T - VGOST 1051 - 75$</p>		Type	Weight	Scale	Clamp	A	0.7	1:1	Sheet	Sheets 1		
	Type	Weight	Scale														
Clamp	A	0.7	1:1														
Sheet	Sheets 1																
Approved by shop	Reference No.	Approved by shop	Reference No.	First use	<p>Copied by</p> <p>Format A4</p>												

AK-630 -Ya 200-1-20TR

First use					
Approved by shop					
Reference No.					
Approved KTONI					
Sign and Date					
Dupl. Inv. No.					
Approved TOSb					
Alternate Inv. No.					
Date					
Sign					
Approved OGMet					
Orig. Inv. No.					

1.* Reference dimension.
 2. Blunt sharp edges ~0.6 mm.
 3. Coating: Cd6 Cr.
 4. Mark Ш, Ч and stamp K as per AK-630M TU I.

AK-630 -Ya 200-1-20 TR					
Amend.	Sheet	Doc. No.	Sign	Date	
Washer					Type
					Weight
					Scale
					A
					0.9
					1:1
					Sheet
					Sheets 1
Sheet <i>B - PN - 5GOST19903 - 74</i>					
<i>25GOST1577 - 93</i>					

Copied by _____ Format A4

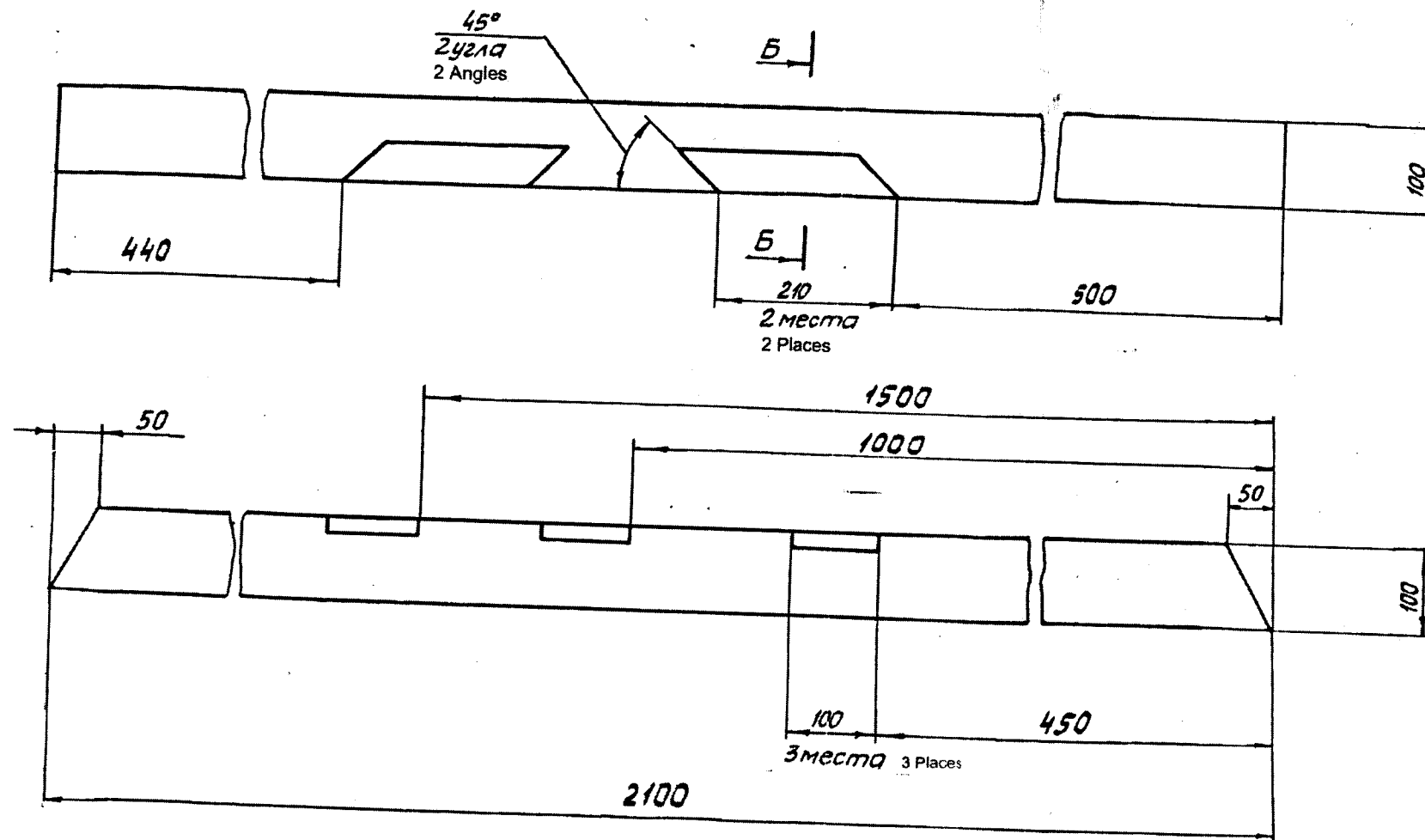
AK-630 -Ya 200-1-21TR

Approved by shop	Reference No.	Approved by KTONI	Sign and Date	First use	<p>View <i>Bуд А</i> Rz 500 ✓ (✓)</p> <p>View <i>Bуд Б</i></p>
Approved TOsb	Dupl. Inv. No.	Sign and Date	Sign and Date	First use	
Alternate Inv. No.	Dupl. Inv. No.	Sign and Date	Sign and Date	First use	
Date	Date	Date	Date	Date	
Sign.	Sign.	Sign.	Sign.	Sign.	
Approved OGMet	Orig. Inv. No.	Date	Date	Date	

Maximum deviation of dimensions as per mean accuracy class GOST 6449.5-82.

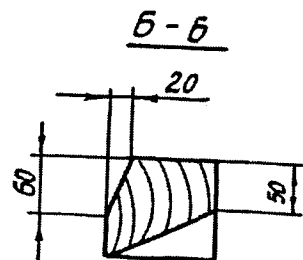
AK-630 -Ya 200-1-21 TR				
	Type	Weight	Scale	
Upper beam	A	22	1:5	
Beam-2Khv-100x100 GOST 8486-86	Sheet	Sheets 1		

Copied by _____ Format A4



Предельные отклонения размеров
по среднему классу точности ГОСТ 64495-82

Limiting deviations of dimensions as per medium class of accuracy
GOST 64495 - 82.



Изм. № подл. Подп. и дата. Изм. № доп. Подп. и дата. Справ. №

Изм. № подл. Подп. и дата. Изм. № доп. Подп. и дата. Изм. № доп. Подп. и дата.

AK - 630-Ya 200-1-10TR

				AK-630-Я 200-1-10TR		
				Балка Cross Beam		
				поперечная		
				Лист 1		
				Листов 1		
				Sheet Total Sheets 1		
				Бар 2 Kh V - 100 x 100		
				ГОСТ 8486 - 86		

Bar 2 Kh V - 100 x 100
GOST 8486 - 86.

First use

Reference No.

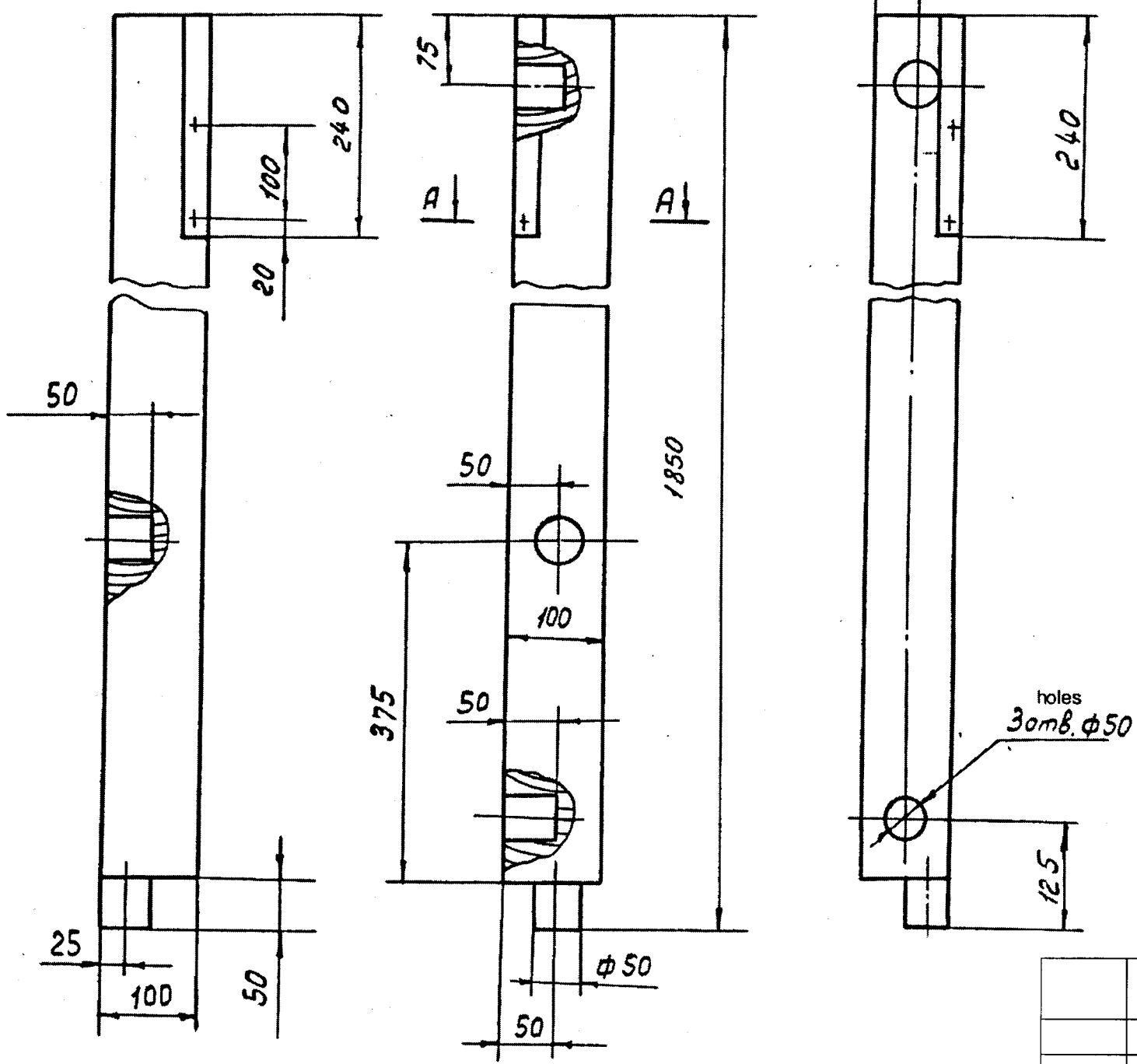
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



- 1. Maximum deviation of dimensions as per standard accuracy class GOST 6449.5-82.
- 2.* Finish as per component AK-630 200-1-11 TR.

					AK-630- Ya 200-1-1 TR			
Amend	Sheet	Doc.No.	Sign	Date	Left rear support	Type	Weight	Scale
Developed by						A	24	1:5
Checked by						Sheet	Sheets	1
Head of Q.C.D						Beam -2 KhV-100x100 GOST 8486-86		
Approved by								

First use

Reference No.

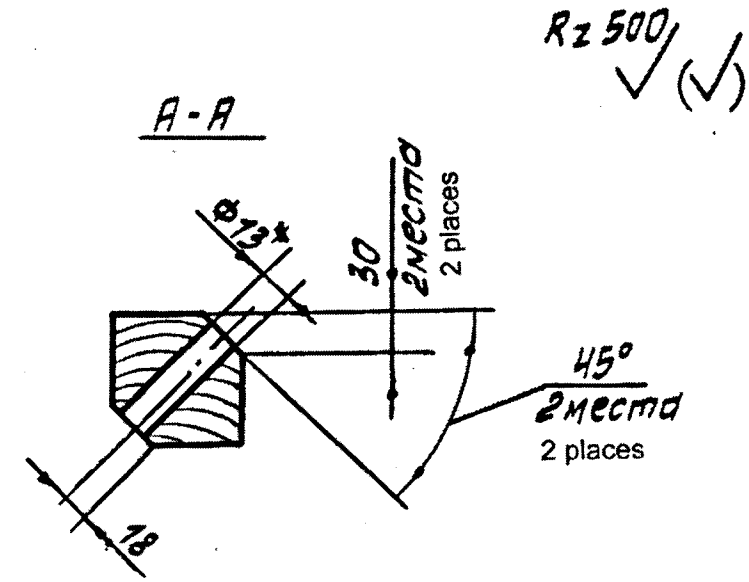
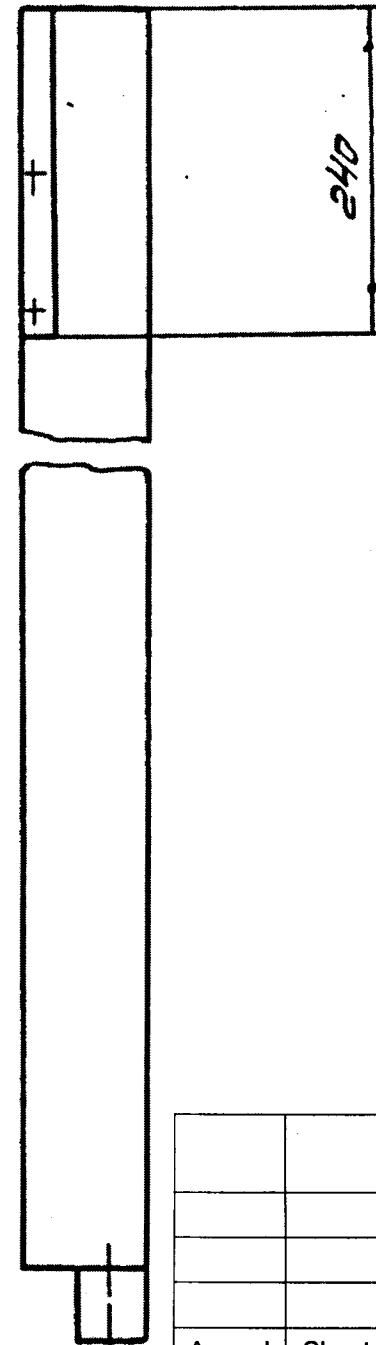
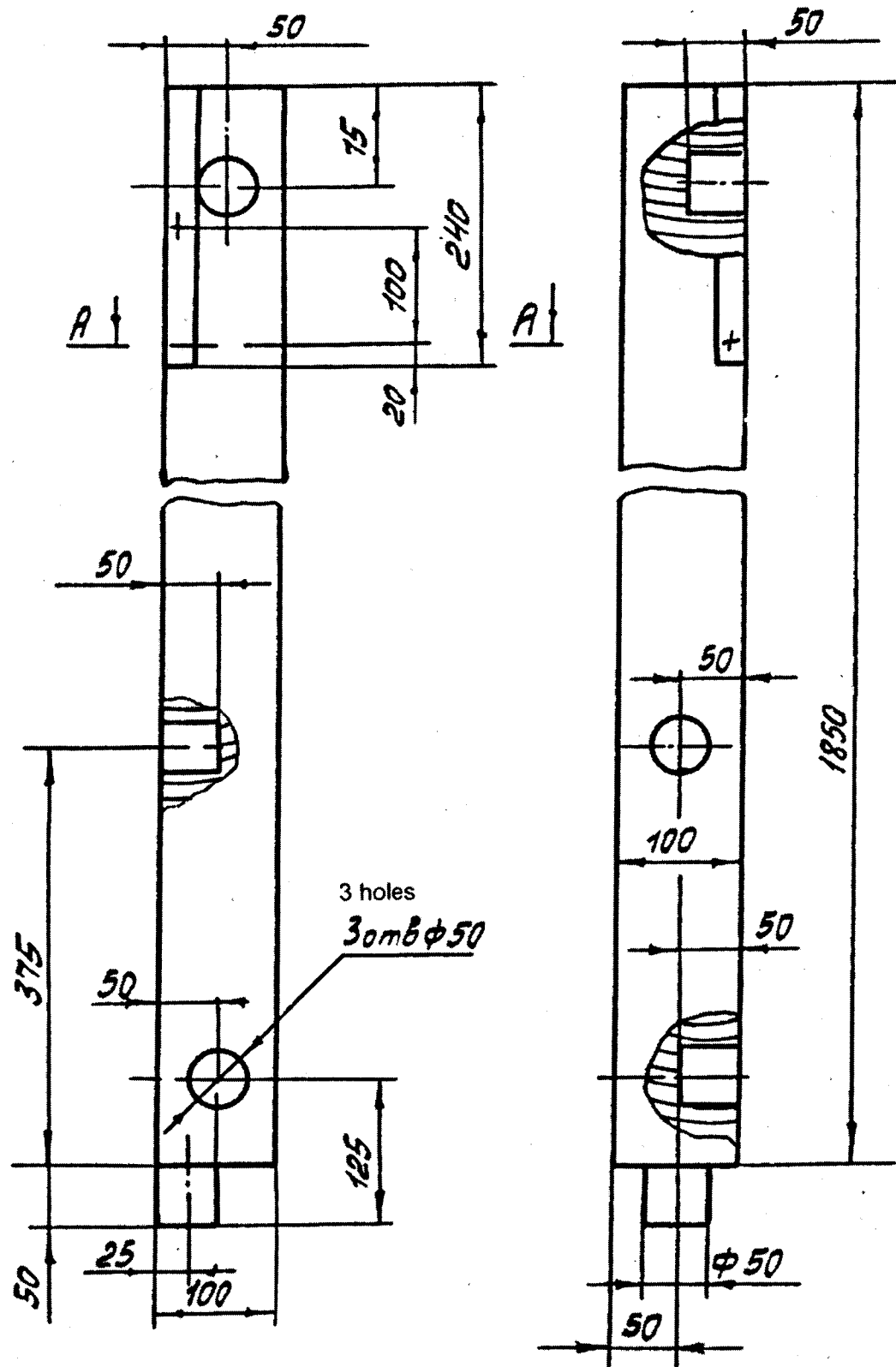
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. Maximum deviation of dimensions as per standard accuracy class GOST 6449.5-82.
2. Finish as per component AK-630 200-1-11 TR.

					AK-630- Ya 200-1-2 TR			
Amend	Sheet	Doc.No.	Sign	Date	Right rear support	Type	Weight	Scale
Developed by						A	24	1:5
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Beam -2 KhV-100x100 GOST 8486-86			
Approved by								

First use

Reference No.

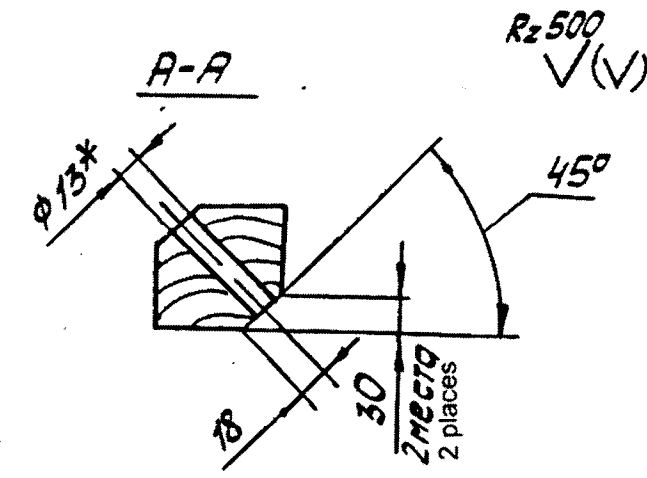
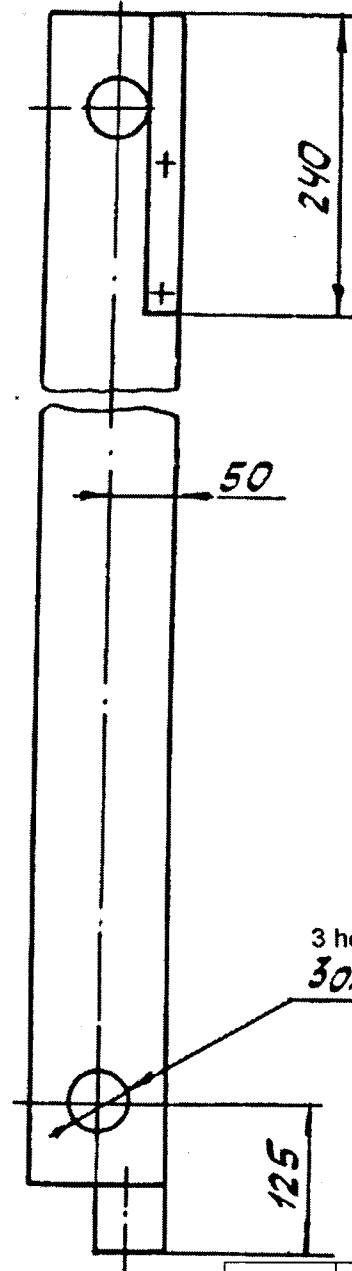
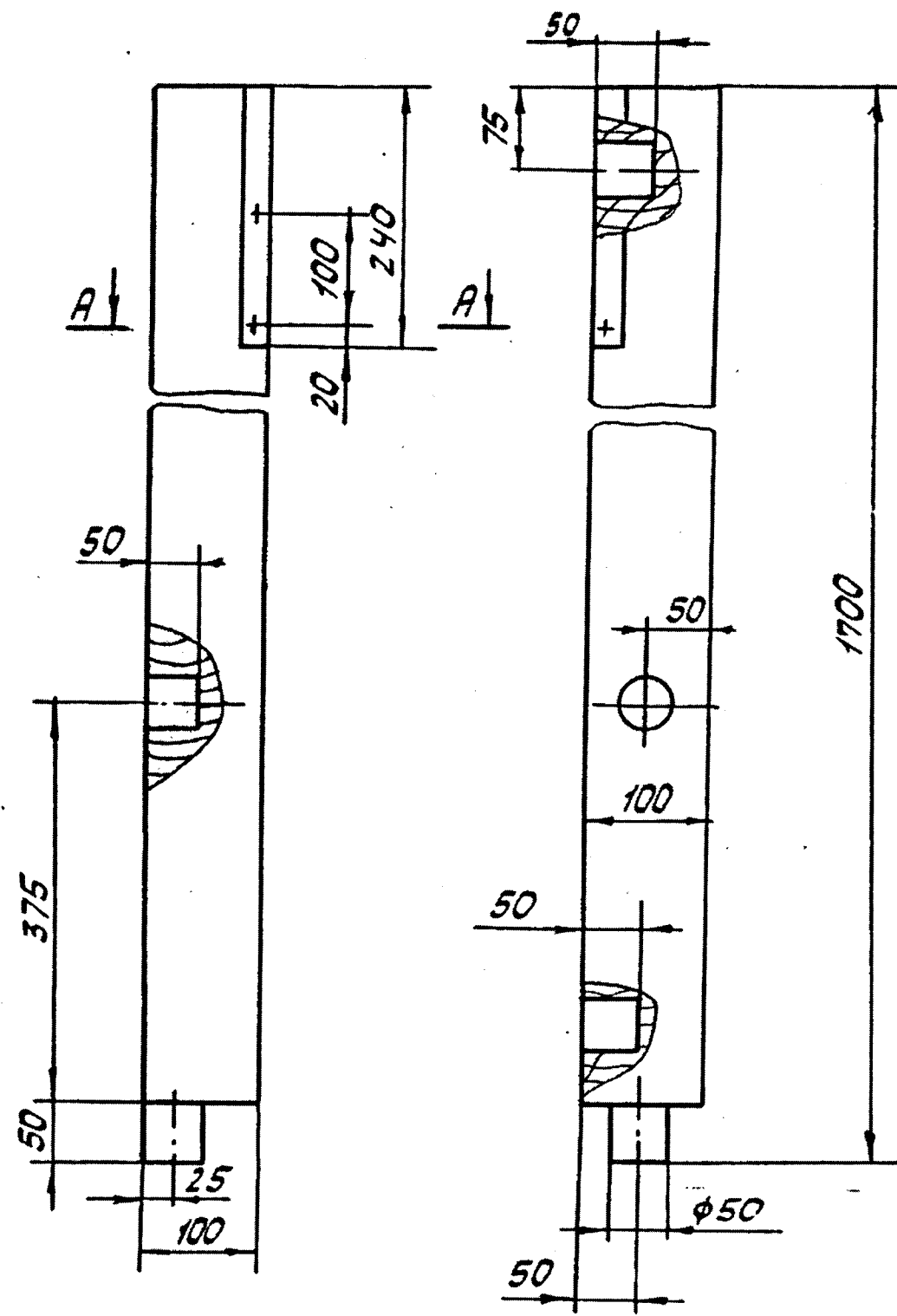
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



3 holes
30mm $\phi 50$.

1. Maximum deviation of dimensions as per standard accuracy class GOST 6449.5-82.
- 2.* Finish as per component AK-630 200-1-11 TR.

Amend	Sheet	Doc.No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

AK-630- Ya 200-1-3 TR

Right front support

Beam -2 KhV-100 x 100
GOST 8486-86

Type	Weight	Scale
A	17	1:2
Sheet	Sheets	1

First use

Reference No.

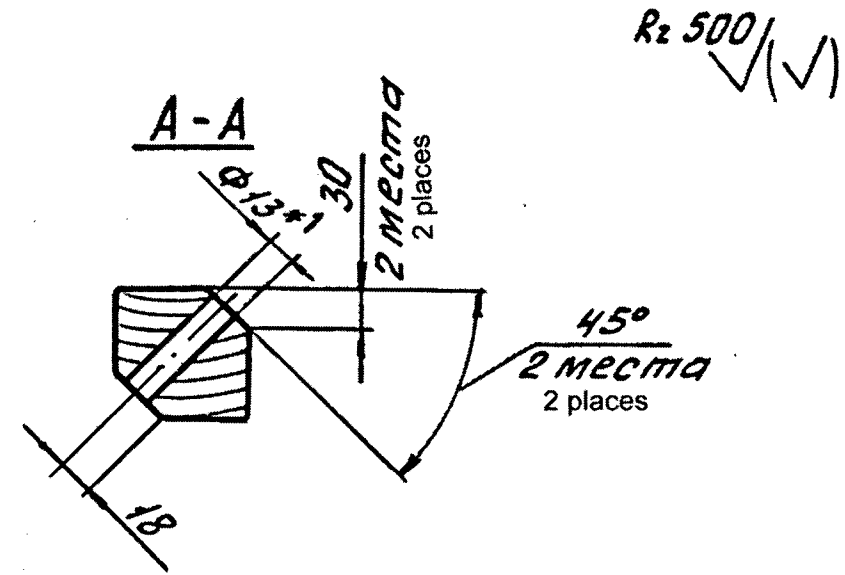
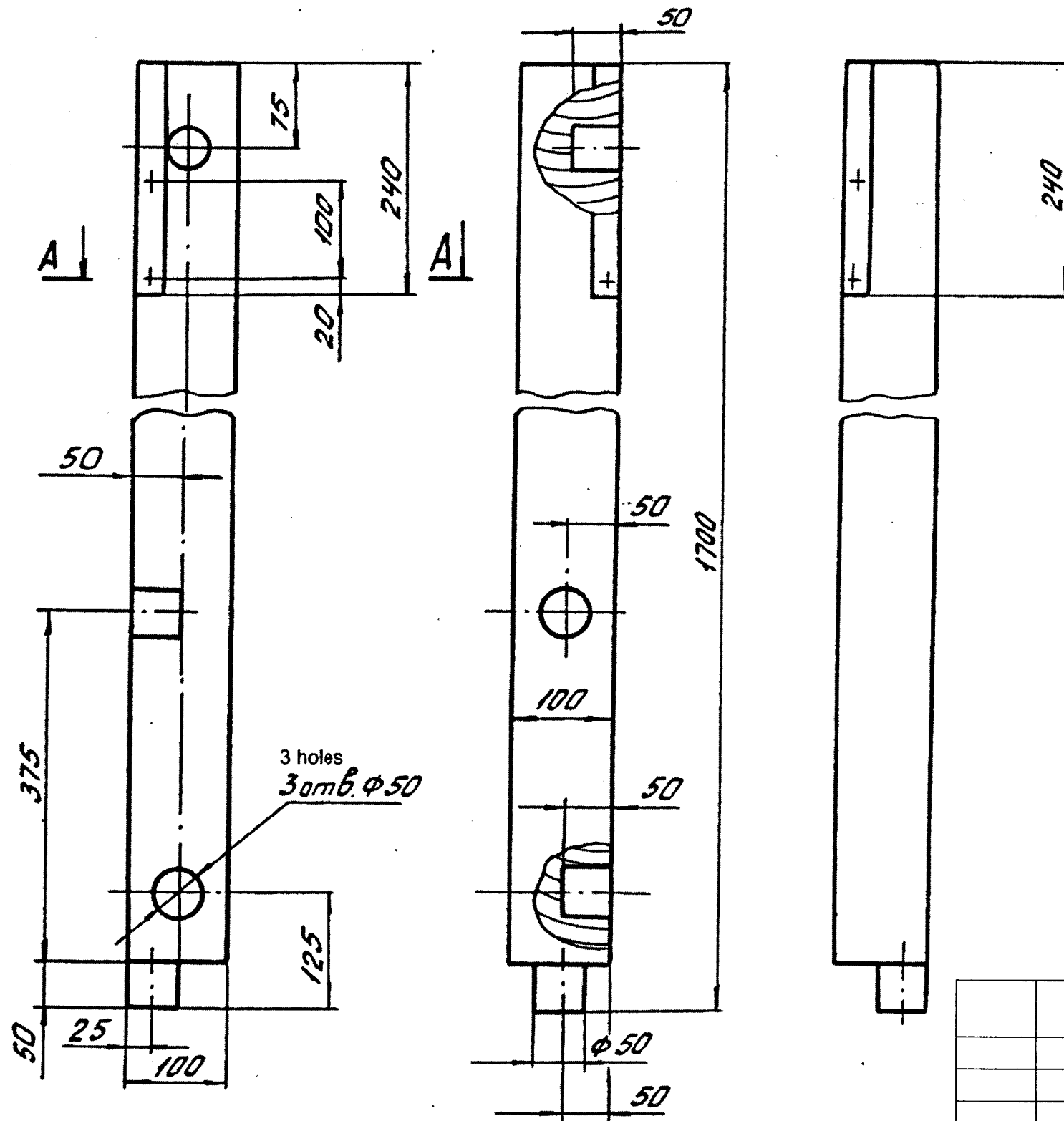
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



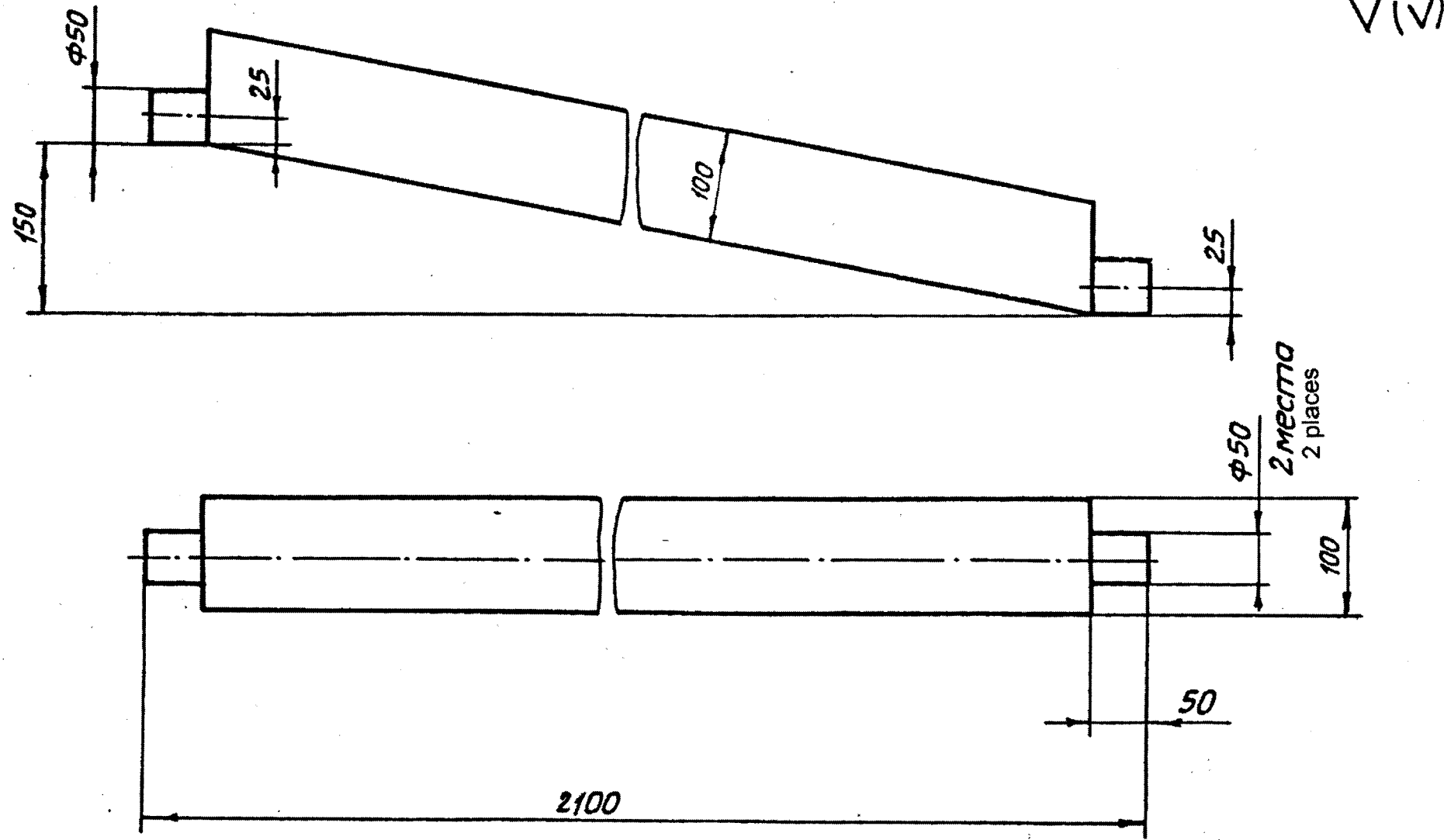
1. Maximum deviation of dimensions as per standard accuracy class GOST 6449.5-82.
2. *1 Finish as per component AK-630 200-1-11 TR.

					AK-630- Ya 200-1-4 TR			
Amend	Sheet	Doc.No.	Sign	Date	Left front support	Type	Weight	Scale
Developed by						A	17	1:5
Checked by						Sheet	Sheets	1
Head of Q.C.D					Beam -2 KhV-100 x 100 GOST 8486-86			
Approved by								

AK-630-Ya 200-1-5TR

First use

Reference No.



Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

Maximum deviations of unspecified dimensions as per standard accuracy class GOST 6449.5-82.

					AK-630-Ya 200-1-5TR			
Amend.	Sheet	Doc.No.	Sign	Date	Upper beam	Type	Weight	Scale
Developed by						A	21	1:5
Checked by						Sheet	Sheets	1
Head of Q.C.D					Beam-2KhV-100x100 GOST 8486-86			
Approved by								

AK-630-Ya 200-1-6 TR

First use

Reference No.

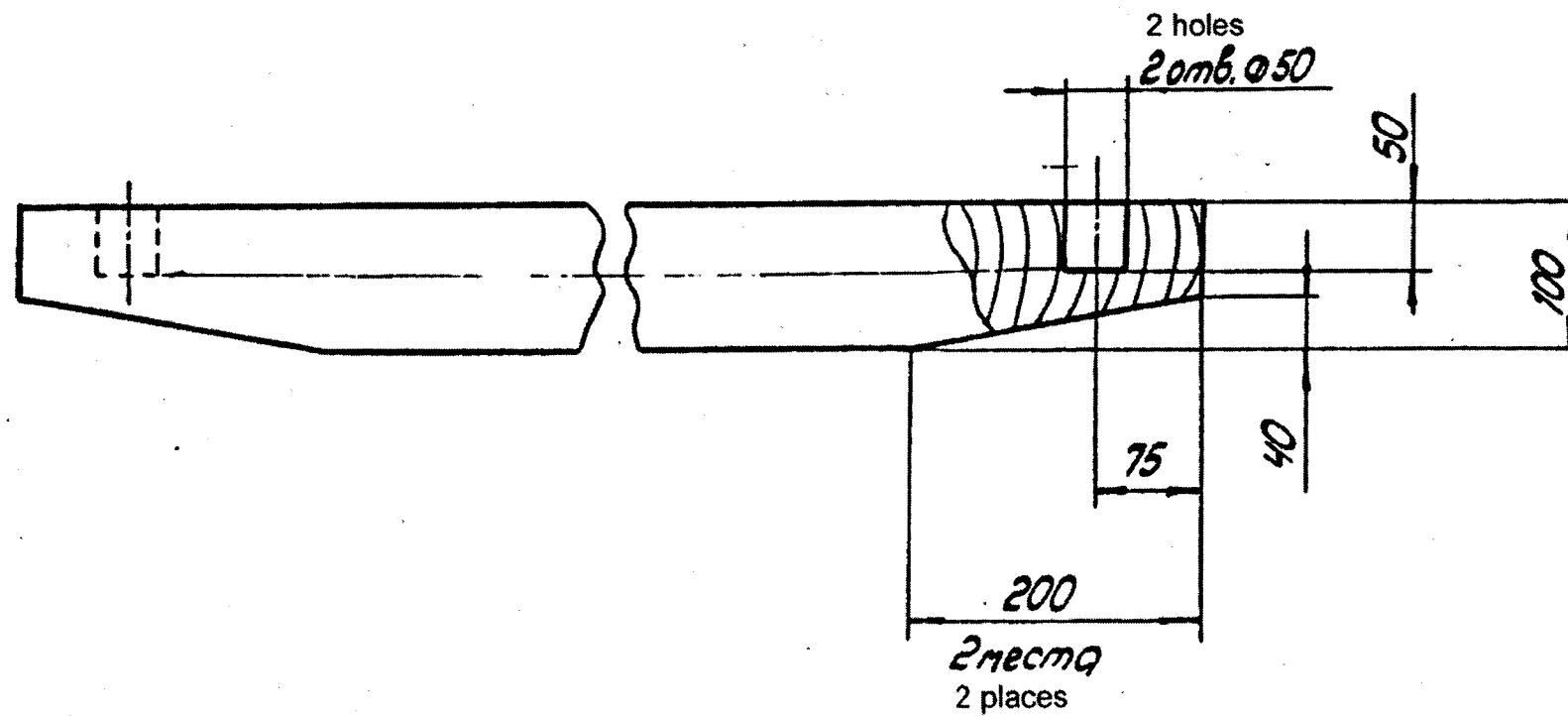
Sign and Date

Duplicate Inv. No

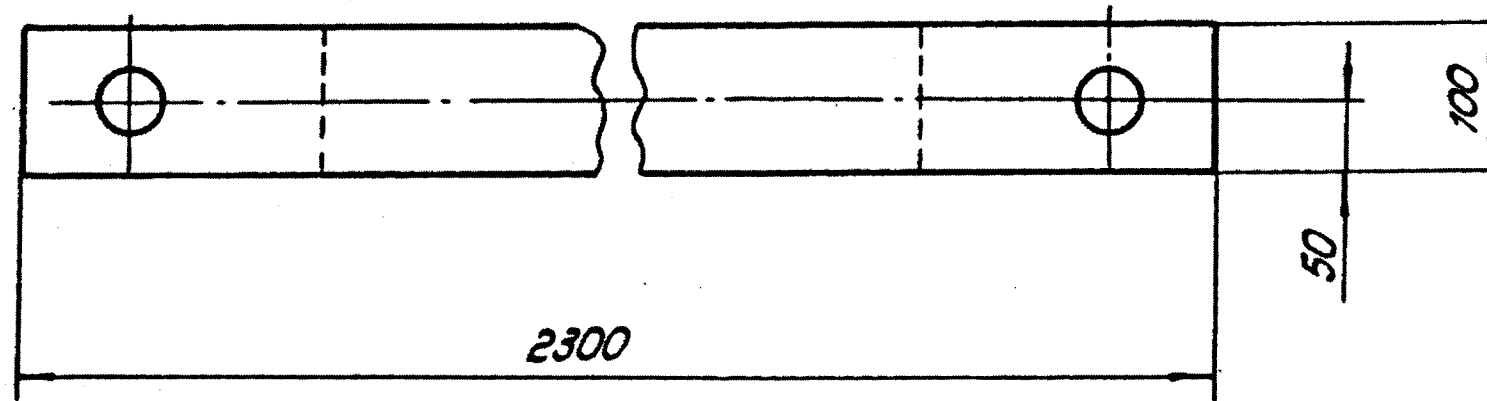
Alternate Inv. No

Sign and Date

Orig. inv. no.



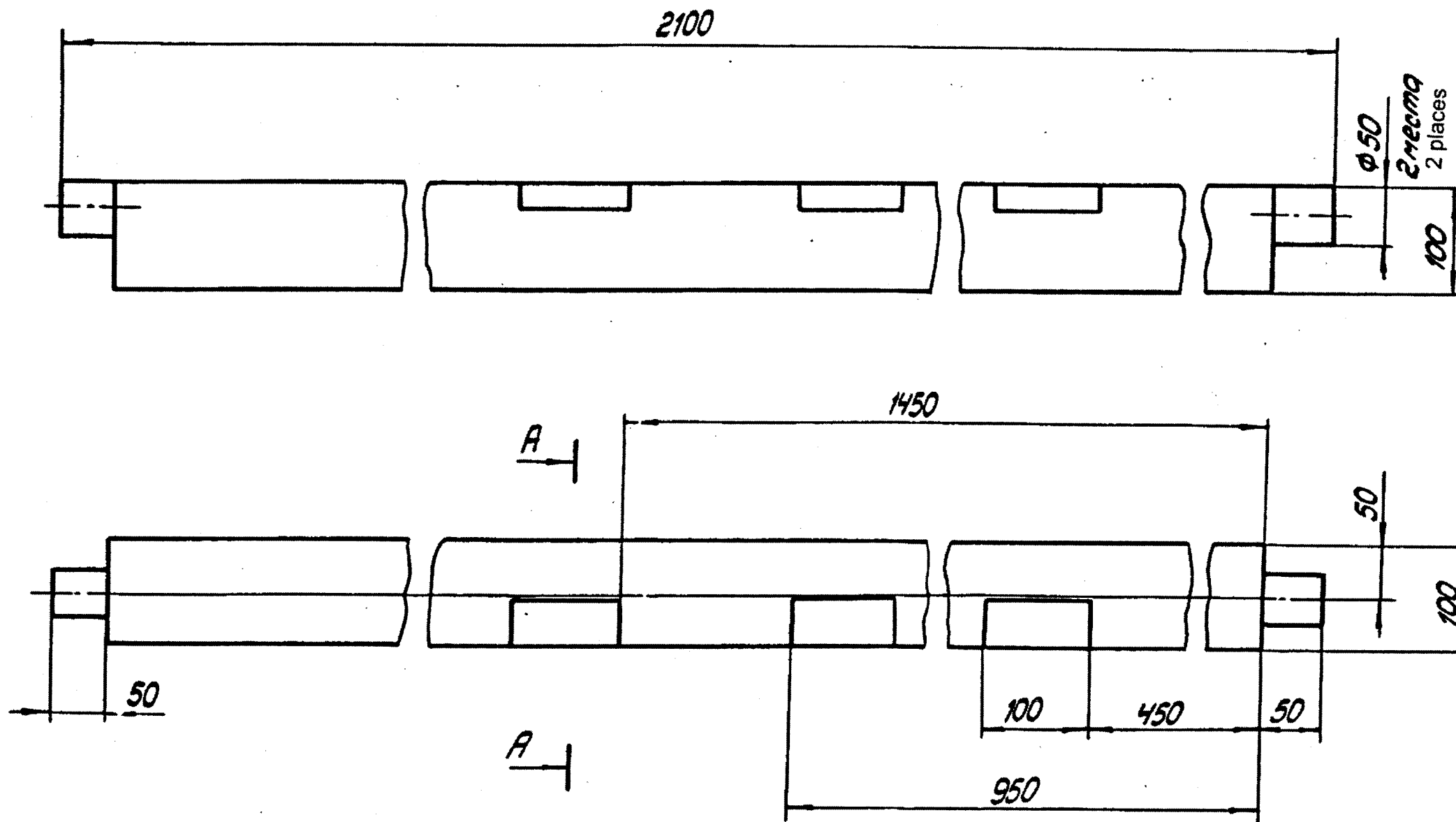
R_z 500/ (✓) (✓)



Maximum deviation of dimensions as per standard accuracy class GOST 6449.5-82.

					AK-630-Ya 200-1-6 TR			
Amend.	Sheet	Doc.No.	Sign	Date	Lower longitudinal beam	Type	Weight	Scale
Developed by						A	23	1:5
Checked by						Sheet	Sheets	1
Head of Q.C.D					Beam-2KhV-100x100 GOST 8486-86			
Approved by								

R_z 500
✓ (✓)



Maximum deviation of dimensions as per standard accuracy class GOST 6449.5-82.

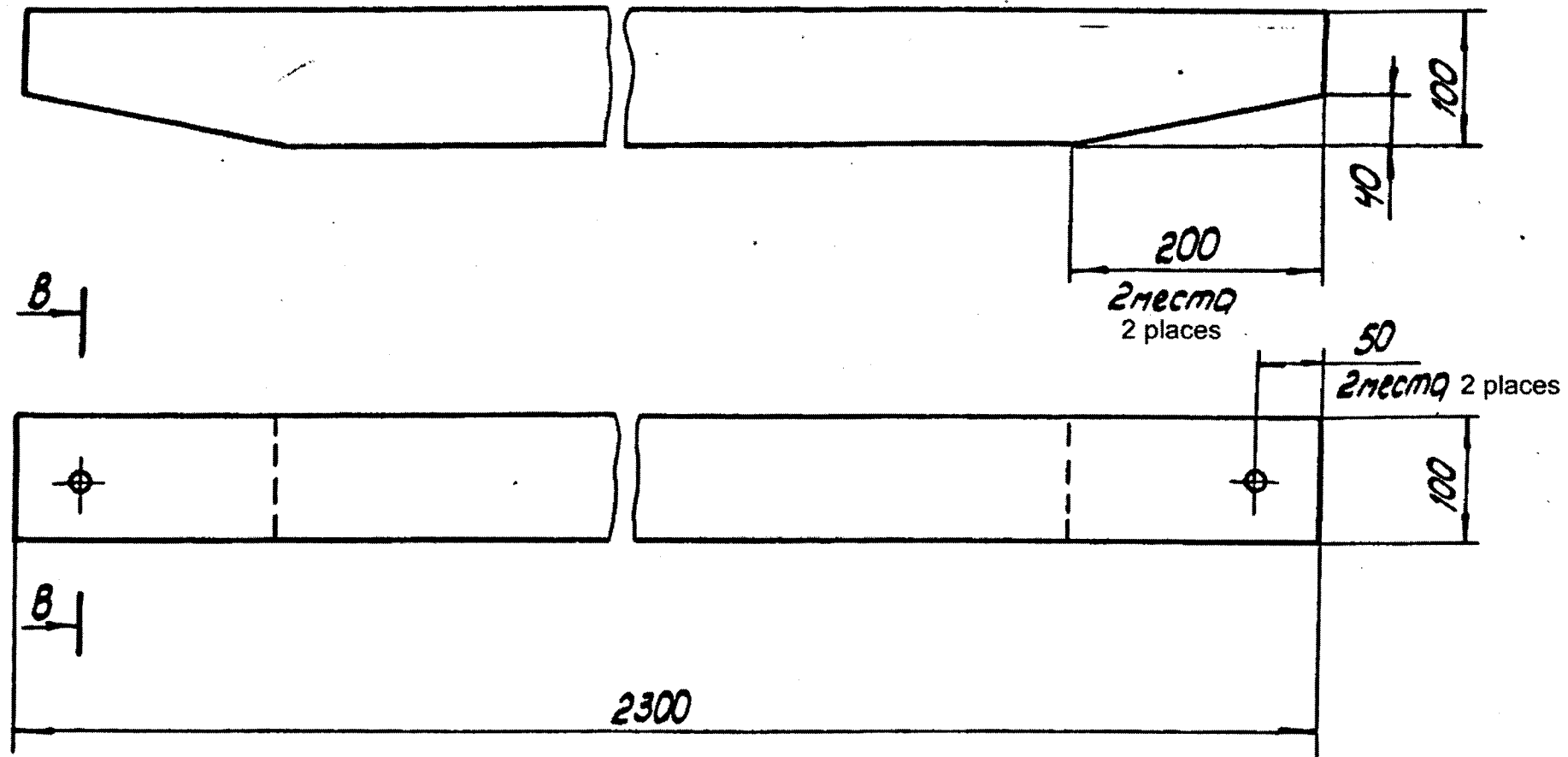
First use
Reference No.
Sign and Date
Duplicate Inv. No.
Alternate Inv. No.
Sign and Date
Orig. inv. no.

Amend.	Sheet	Doc.No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

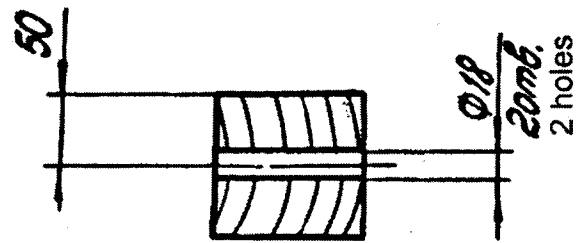
AK-630-Ya 200-1-7 TR			
Lower cross beam	Type	Weight	Scale
	A	21	1:5
Beam-2KhV-100x100 GOST 8486-86	Sheet	Sheets	1

AK-630-Ya 200-1-8 TR

R_z 500
√(√)



B-B



Maximum deviation of dimensions as per standard accuracy class GOST 6449.5-82.

First use
Reference No.
Sign and Date
Duplicate Inv. No.
Alternate Inv. No.
Sign and Date
Orig. inv. no.

					AK-630-Ya 200-1-8 TR			
Amend.	Sheet	Doc.No.	Sign	Date	Lower longitudinal beam	Type	Weight	Scale
Developed by						A	23	1:5
Checked by						Sheet	Sheets	1
Head of Q.C.D					Beam-2KhV-100x100 GOST 8486-86			
Approved by								

AK-630-Ya 200-1-9 TR

First use

Reference No.

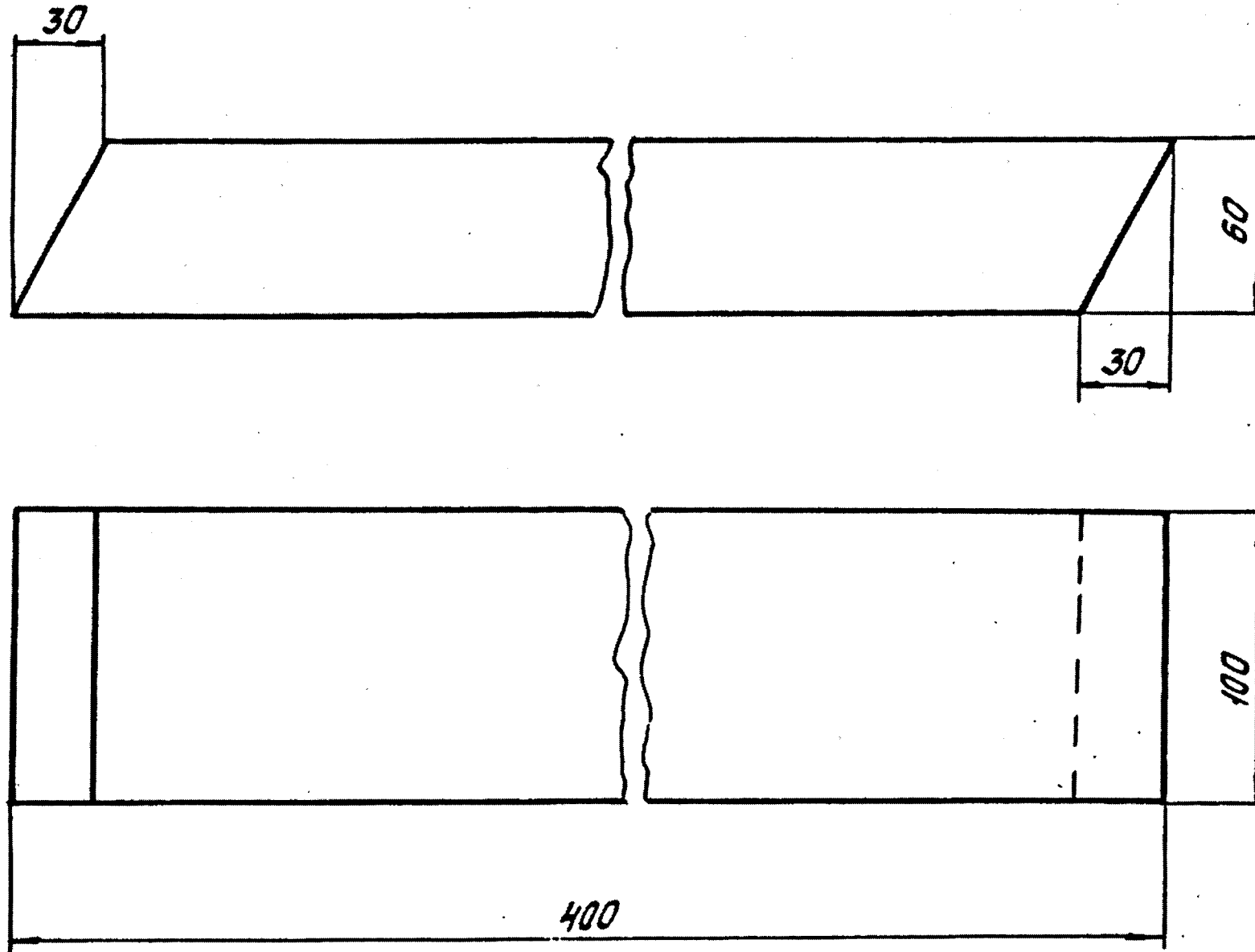
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



R2500/√(√)

Maximum deviation of dimensions as per standard accuracy class GOST 6449.5-82.

					AK-630-Ya 200-1-9 TR			
					Spacer bar	Type	Weight	Scale
Amend.	Sheet	Doc.No.	Sign	Date		A	24	1:2
Developed by						Sheet	Sheets	1
Checked by					Beam-2KhV-100x100 GOST 8486-86			
Head of Q.C.D								
Approved by								

AK-630-Ya 200-1-13 TR

First use

Reference No.

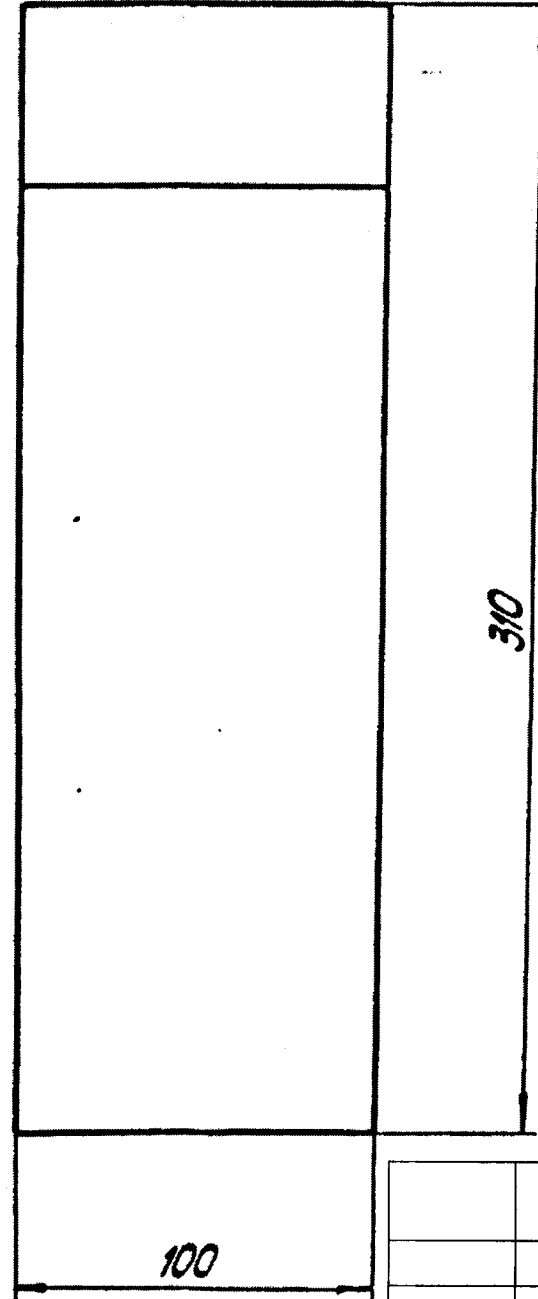
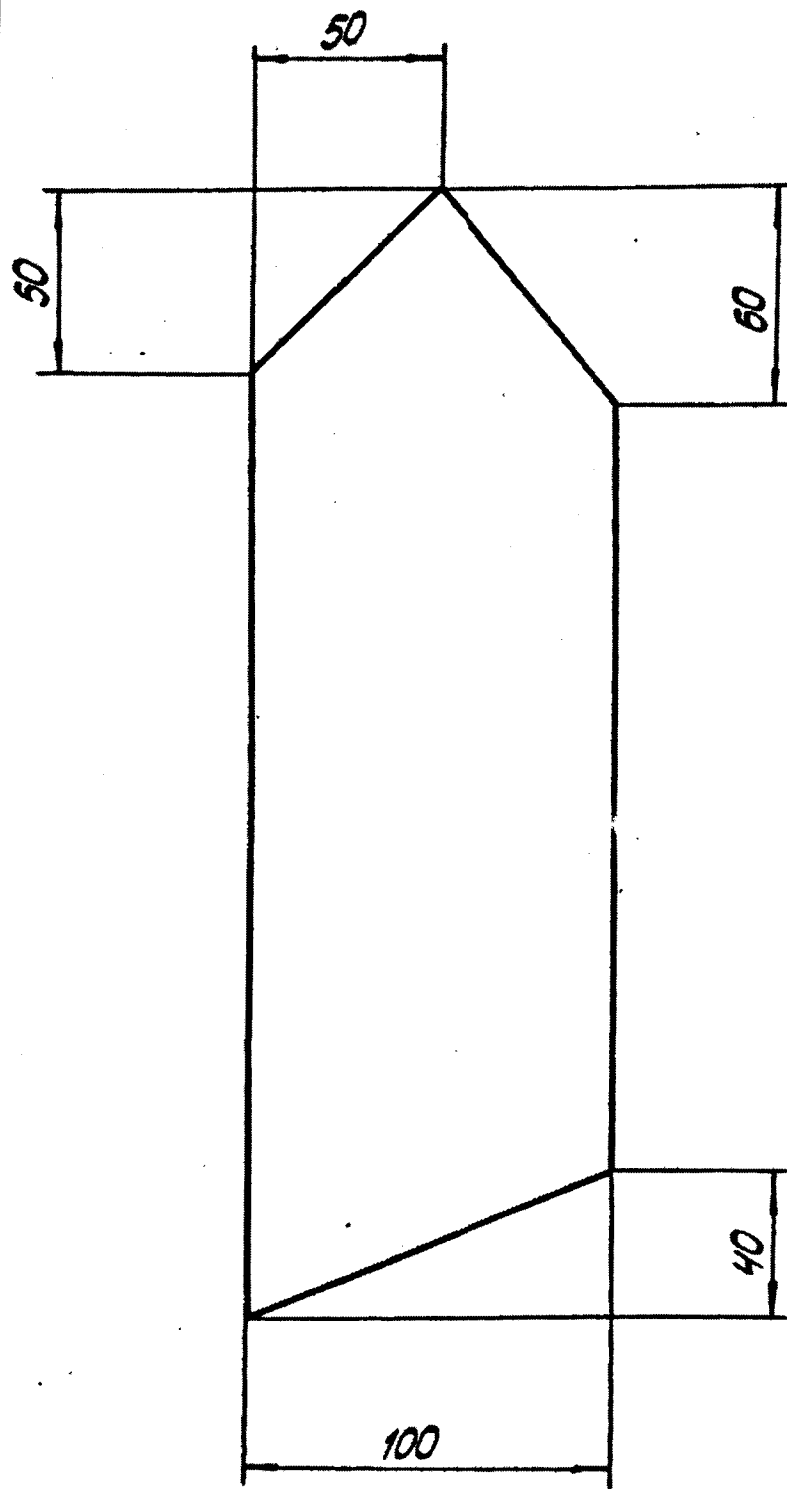
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



R_z 500 / (✓)

Maximum deviation of dimensions as per standard accuracy class GOST 6449.5-82.

AK-630-Ya 200-1-13 TR

Amend.	Sheet	Doc.No.	Sign	Date

AK-630-Ya 200-1-13 TR		
Type	Weight	Scale
Support bar	3.1	1:2
Sheet	Sheets	1
Beam-2KhV-100x100 GOST 8486-86		

AK-630-Ya 200-1-14 TR

First use

Reference No.

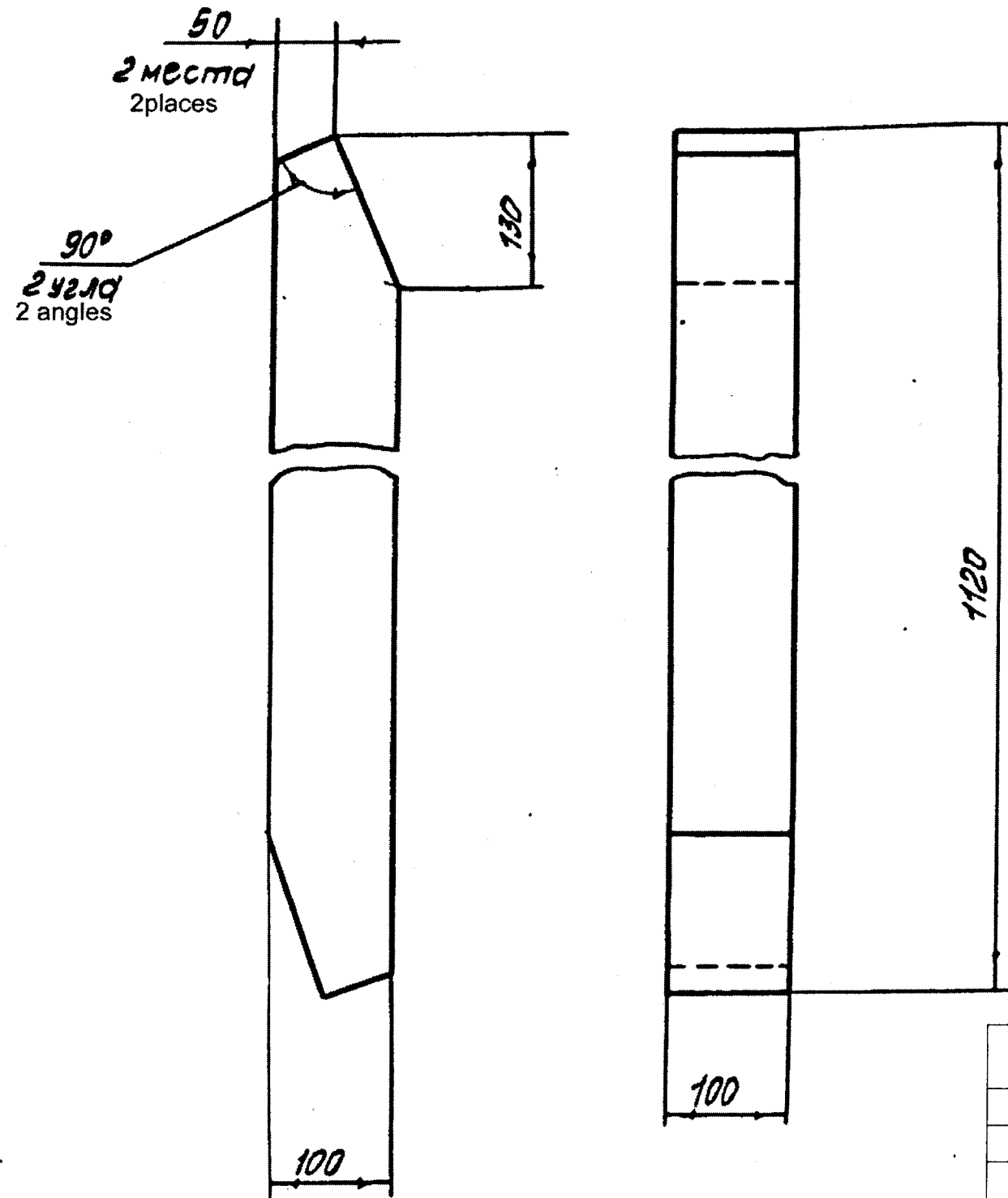
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



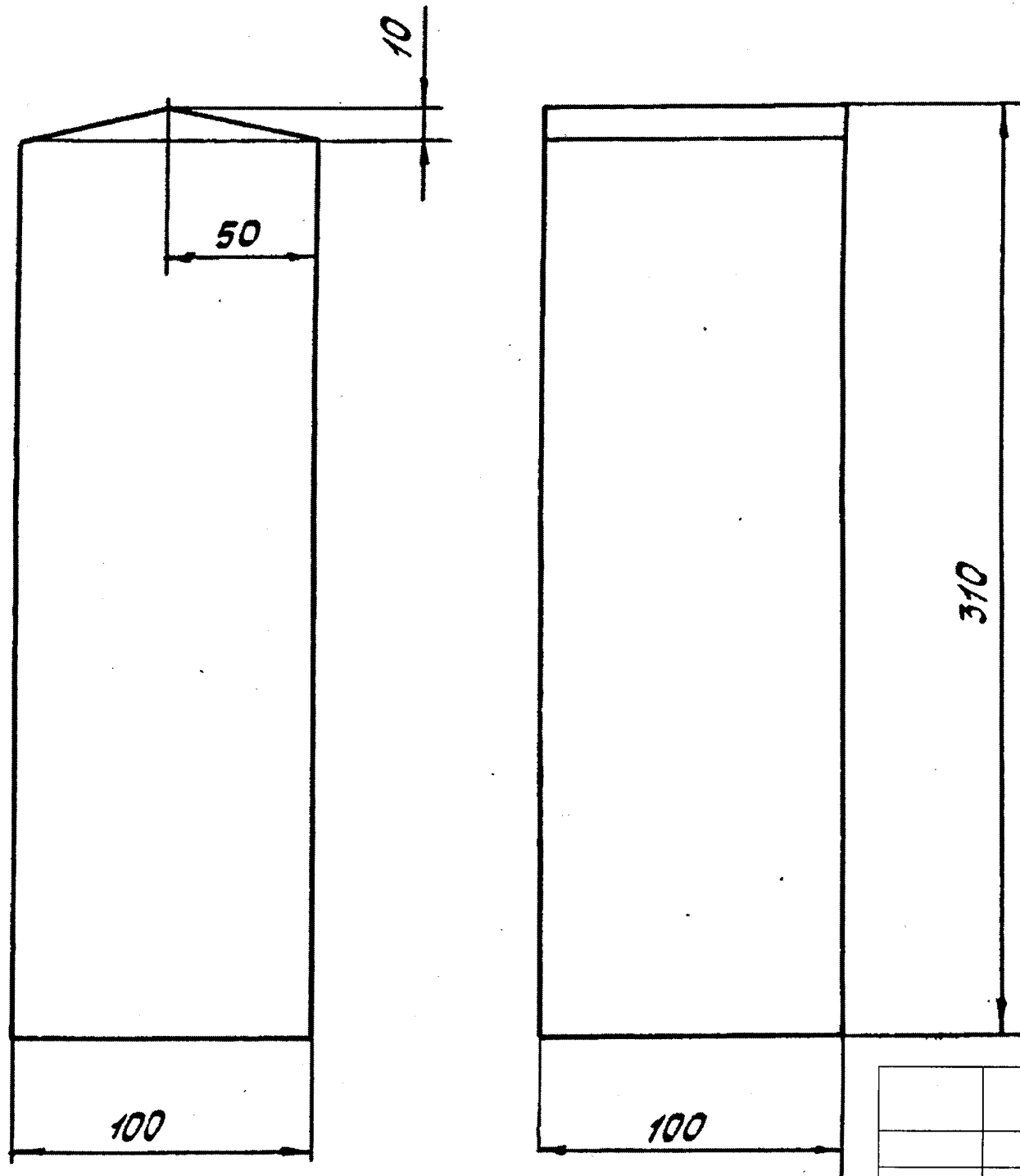
Rz 500
√(√)

Maximum deviation of dimensions as per standard accuracy class GOST 6449.5-82.

					AK-630-Ya 200-1-14 TR			
Amend.	Sheet	Doc.No.	Sign	Date	Longitudinal joist	Type	Weight	Scale
Developed by						A	12	1:5
Checked by						Sheet	Sheets	1
Head of Q.C.D					Beam-2KhV-100x100 GOST 8486-86			
Approved by								

AK-630-Ya 200-1-16 TR

Rz 500
√ (√)



Maximum deviation of dimensions as per standard accuracy class GOST 6449.5-82.

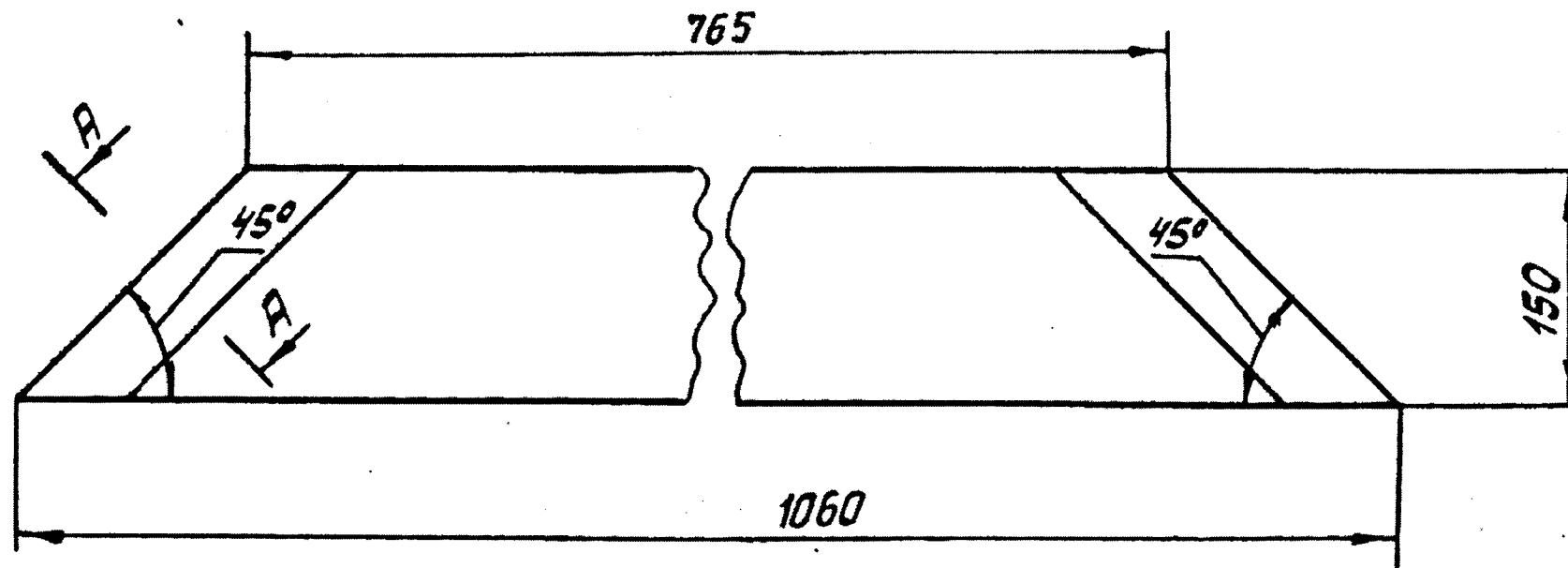
Orig. inv. no.	Sign and Date	Alternate Inv. No	Duplicate Inv. No	Sign and Date	Reference No.	First use
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					AK-630-Ya 200-1-16 TR			
Amend.	Sheet	Doc.No.	Sign	Date	Support	Type	Weight	Scale
Developed by						A	3.1	1:2
Checked by						Sheet	Sheets	1
Head of Q.C.D					Beam-2KhV-100x100 GOST 8486-86			
Approved by								

AK-630-Ya 200-1-17 TR

First use

Reference No.



Rz 500/√(√)

Sign and Date

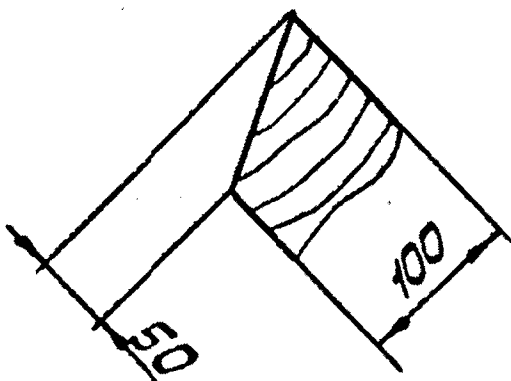
Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

A-A



Maximum deviation of dimensions as per standard accuracy class GOST 6449.5-82.

					AK-630-Ya 200-1-17 TR			
Amend.	Sheet	Doc.No.	Sign	Date	Post	Type	Weight	Scale
Developed by						A	14.3	1:5
Checked by						Sheet	Sheets	1
Head of Q.C.D					Beam-2KhV-100x100			
Approved by					GOST 8486-86			

First use

Reference No.

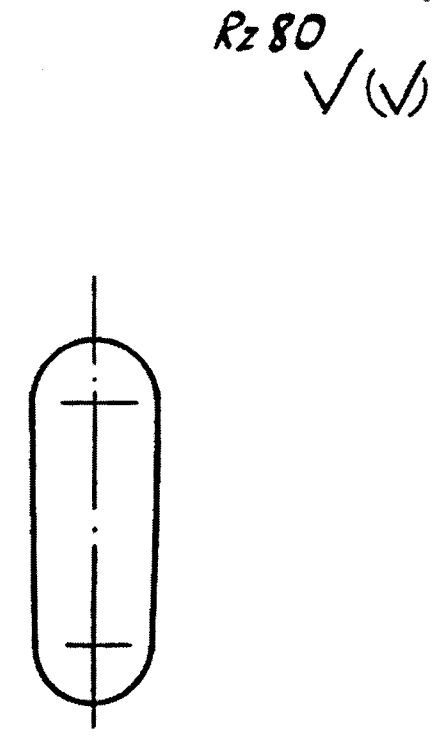
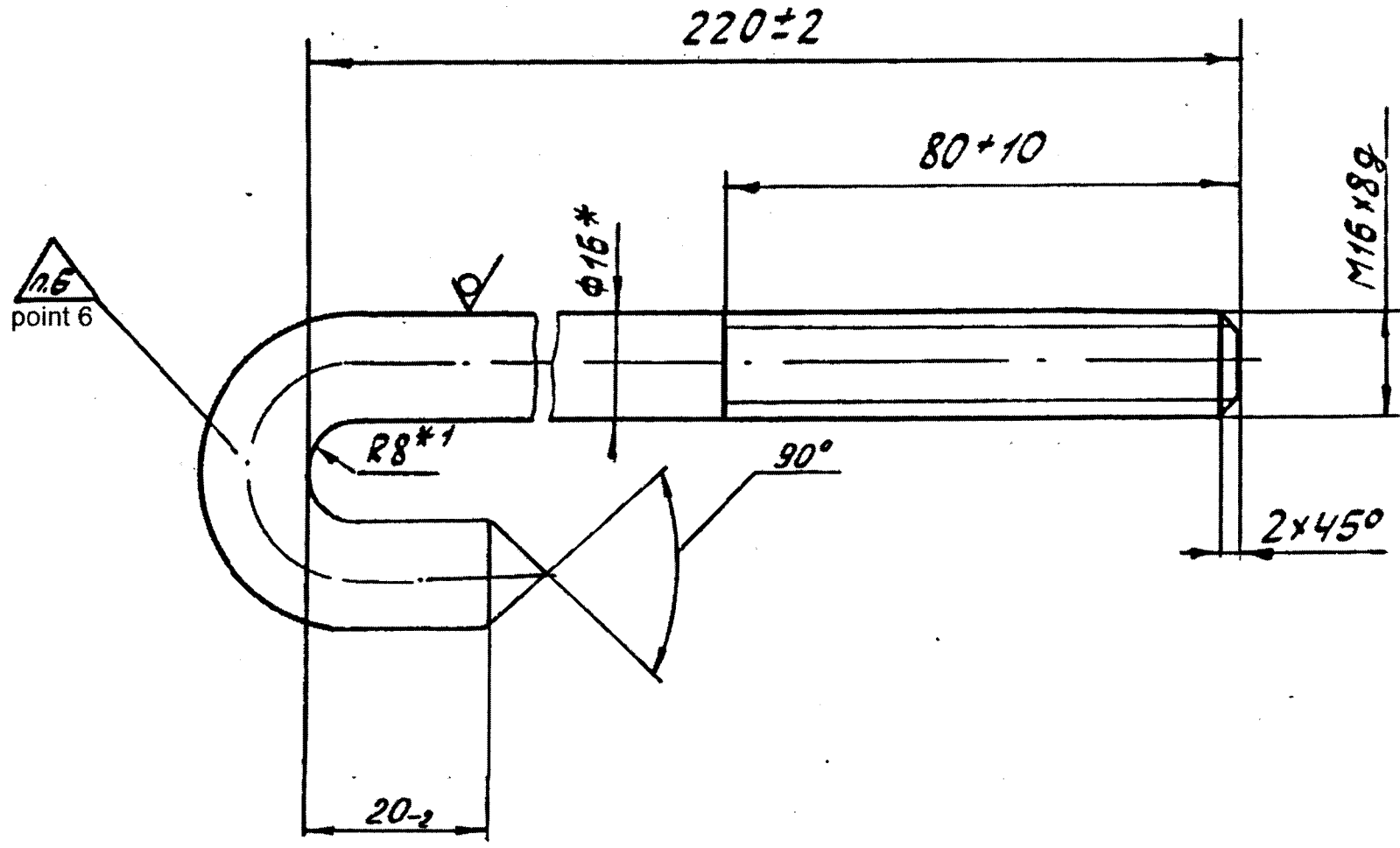
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



- 1.* Reference dimension.
- 2.*1 Dimension ensured by tool.
- 3. Blunt sharp edges.
- 4. Decrease in thickness along bending radius up to 14 mm is permissible.
- 5. Coating: Cd6 Cr.
- 6. Stamp K as per AK-630M TU1.
- 7. Substitute material- steel 35 GOST 1050-88.
- 8. Mark Ш, Ч on tag.

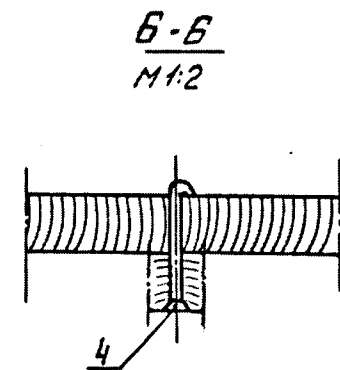
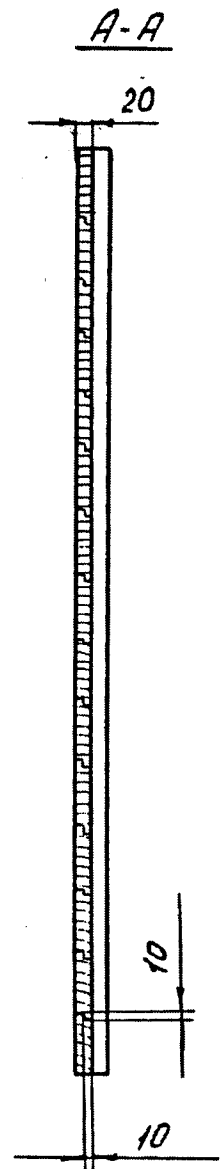
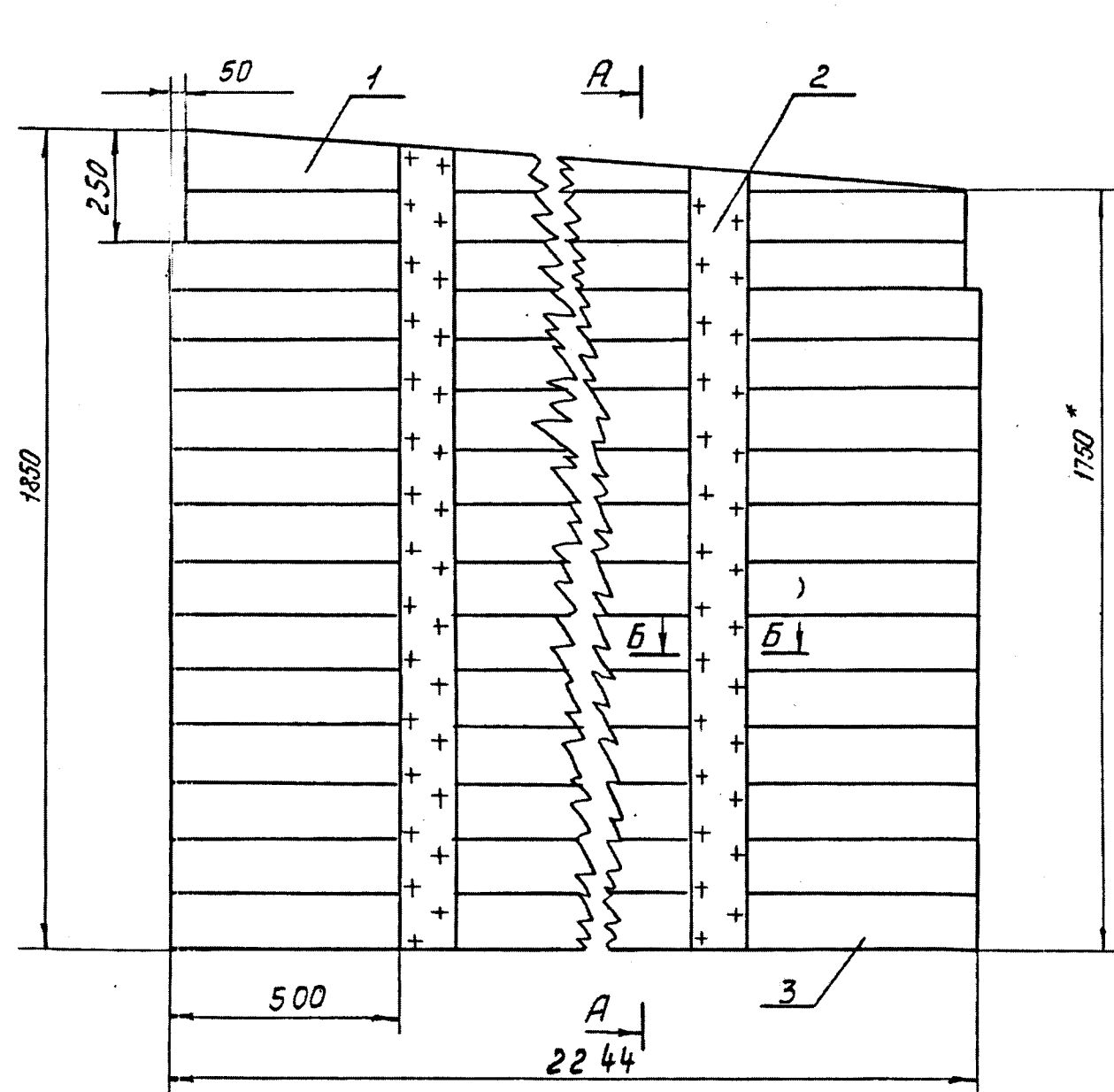
					AK-630-Ya 200-1-19 TR			
Amend.	Sheet	Doc. No.	Sign	Date	Bolt	Type	Weight	Scale
Developed by						A	0.3	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Wheel			
Approved by						$\frac{16-h12GOST7417-75}{25-V-NGOST1051-73}$		

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
Reference No.					<u>Documents</u>		
	A2	/		AK-630-Ya Sb 200-1-2TR SB	Assembly drawing		
					<u>Components</u>		
	WD	/	1	AK-630-Ya 200-1-29TR	Board-2 Khv-25 x 125 GOST 8486-86 L = 1750 ± 5	2	
	WD	/	2	AK-630-Ya 200-1-31TR	Board-2 Khv-25 x 100 GOST 8486-86 L = 2290 ± 5	16	
	WD	/	3	AK-630-Ya 200-1-36TR	Board-2 Khv-25 x 150 GOST 8486-86 L = 2290 ± 5	1	
					<u>Standard articles</u>		
			4		Nails K 3x70 GOST 4028-63	52	
Sign and Date							
Dupl. Inv. No.							
Alternate Inv. No.							
Sign and Date							
Orig. Inv. No.							

					AK-630-Ya Sb 200-1-2 TR		
Amend.	Sheet	Doc. No.	Sign	Date			
Developed by					Type	Sheet	Sheets
Checked by					A		1
Head of Q.C.D.					Cross board		
Approved by							

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
Reference No.					Documents		
	A2			AK-630-Ya Sb 200-1-3TR SB	Assembly drawing		
					Components		
	WD		1	AK-630-Ya 200-1-32ATR	Board-2 Khv-25 x 150 GOST 8486-86 L = 2244 ± 5	1	
	WD		2	AK-630-Ya 200-1-33TR	Board-2 Khv-25 x 125 GOST 8486-86 L = 1800 ± 5	2	
	WD		3	AK-630-Ya 200-1-34TR	Board-2 Khv-25 x 100 GOST 8486-86 L = 2244 ± 5	19	
					Standard articles		
			4		Nails K 3x70 GOST 4028-63	60	
Orig. inv. No.	Amend. Sheet Doc. No. Sign Date				AK-630-Ya Sb 200-1-3 TR		
	Developed by						
	Checked by						1
	Head of Q.C.D				Longitudinal board		
	Approved by						

Rz 500/✓



- 1.* Размер для справок.
2. Предельные отклонения размеров по среднему классу точности ГОСТ6449.5-82.
3. Соединение досок в четверть К-2 по ГОСТ9330-76.
4. Для спецпоставок доски обрезные, без обзола, строганные, отверстия от сучков не допускаются.
5. Допускается набор размеров 1850 из досок - 2 хв. - 25 ГОСТ8486-86 различной ширины но не менее 70мм.

- 1.* - Dimension for reference.
2. Limiting deviations of dimensions as per medium class of accuracy GOST 6449.5-82.
3. Joining of boards for quarter K-2 as per GOST 9330-76.
4. For the special supply, the board, which are trimmed, without wane, dressed, have holes of knots, are not permitted.
5. The selection of dimensions 1850 of the board - 2 kh v. - 25 GOST 8486-86 of different width but not less than 70mm is permitted.

Инв.№ подл. Подп. и дата. / Взам.инв.№ Инв.№ дубл. Подп. и дата. / Справ.№ / Перв.ручен.

AK-630-Яa SB 200-1-3 TR SB

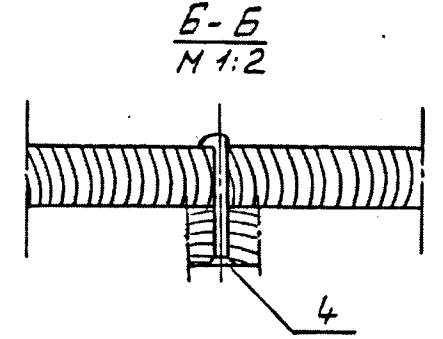
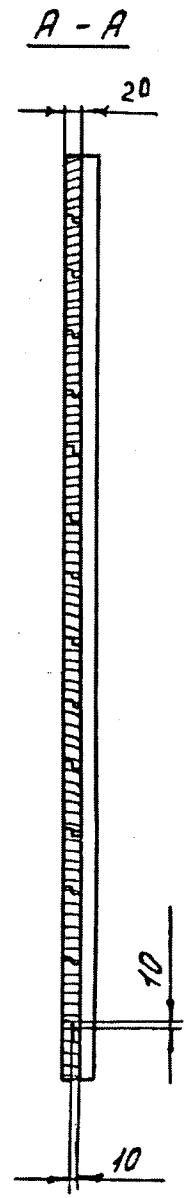
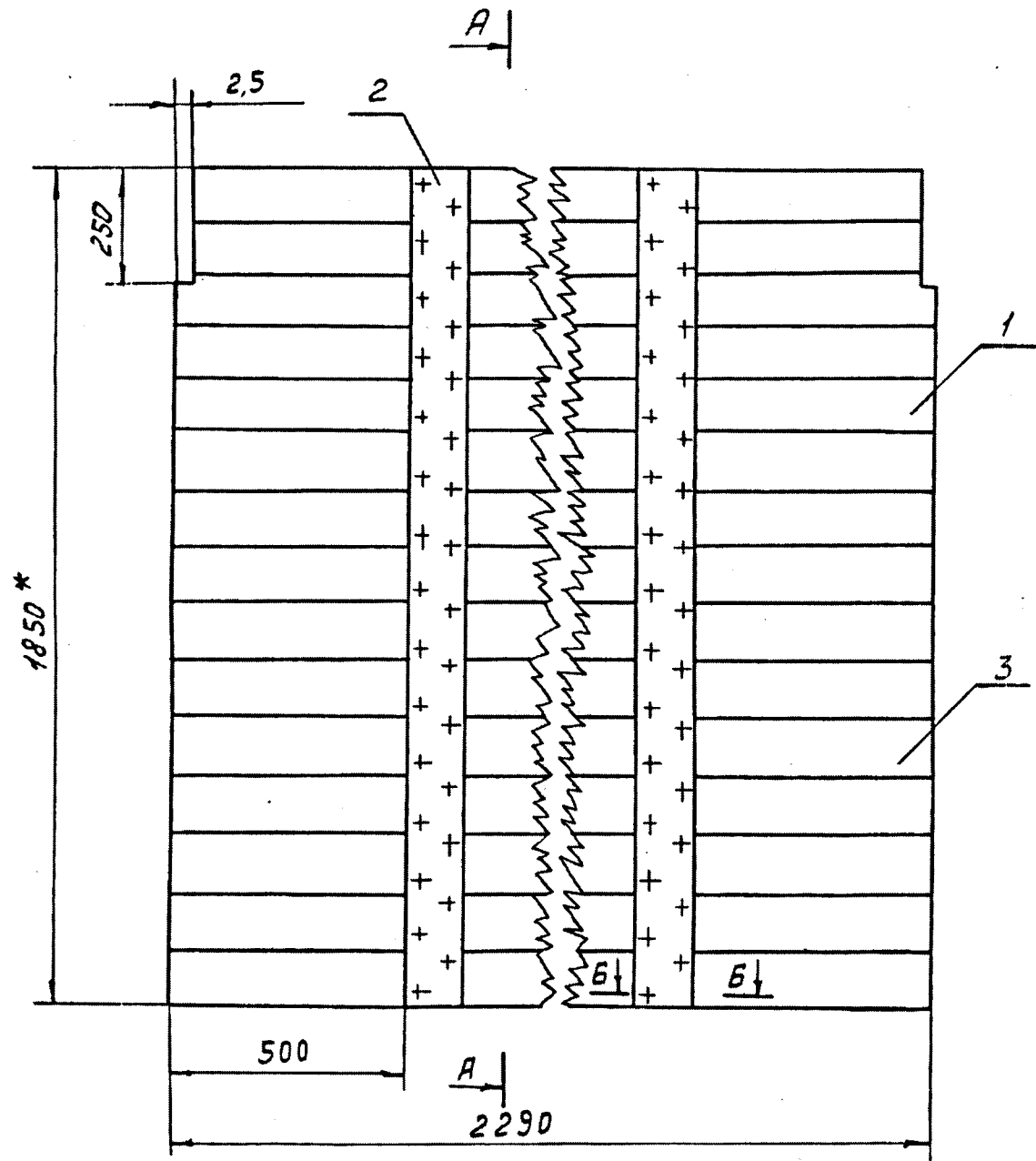
Изм./Лист		№ докум.		Подп.	Дата	AK-630-Я СБ200-1-3ТРСБ		
Разраб.		Проб.		Т.контр.		Щит Longitudnal пробольный Board		Type Mass Scale
Н.контр.		Утв.		А		107		1:10
Лист		Листов		1		1		1
Sheet		Total Sheets		1		1		1

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A2			AK-630-Ya Sb 200-1-4TR SB	Assembly drawing			
					<u>Components</u>			
	WD	1		AK-630-Ya 200-1-30TR	Board-2 Khv-25 x 150 GOST 8486-86 L = 2290 ± 5	1		
	WD	2		AK-630-Ya 200-1-35TR	Board-2 Khv-25 x 100 GOST 8486-86 L = 1850 ± 5	2		
	WD	3		AK-630M-Ya 200-1-36TR	Board-2 Khv-25 x 100 GOST 8486-86 L = 2290 ± 5	19		
					<u>Standard articles</u>			
			4		Nails K 3x70 GOST 4028-63	70		
Sign a Orig. Inv. No.	AK-630-Ya Sb 200-1-4 TR							
	Amend.	Sheet	Doc. No.	Sign	Date			
	Developed by					Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D					Cross board		
Approved by								

AK-630-Я sb 200-1-4 TRSB

AK-630-Я sb 200-1-4 TRSB

Rz 500
✓(✓)



- 1.* Размер для справок.
 2. Предельные отклонения размеров по среднему классу точности ГОСТ6449.5-82.
 3. Соединение досок в четверть К-2 по ГОСТ 9330-76.
 4. Для спецпоставок доски обрезные, без обзола, строганные, отверстия от сучков не допускаются.
 5. Допускается набор размера 1850 из досок - 2 kh v. - 25 ГОСТ 8486-86 различной ширины но не менее 70мм.
- 1.* - Dimension for reference.
 2. Limiting deviations of dimensions as per medium class of accuracy GOST 6449.5-82.
 3. Joining of boards for quarter K-2 as per GOST 9330-76.
 4. For the special supply, the board, which are trimmed, without wane, dressed, have holes of knots, are not permitted.
 5. The selection of dimension 1850 of the board - 2 kh v. - 25 GOST 8486-86 of different width but not less than 70mm is permitted.

Справ. №
Перв. пр. №

Изм. № подл. Подп. и дата.
Изм. инд. № Инд. № дубл. Подп. и дата.

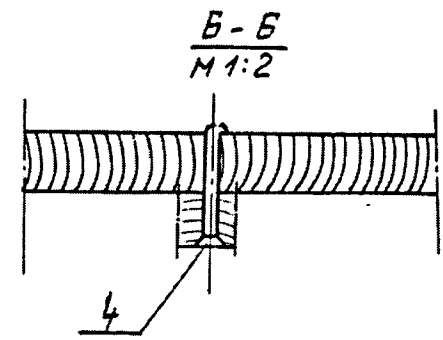
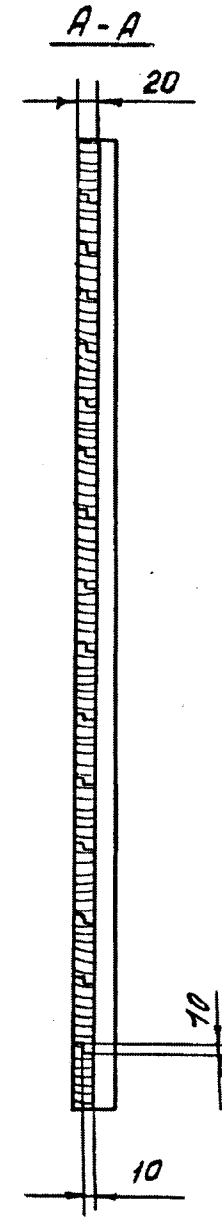
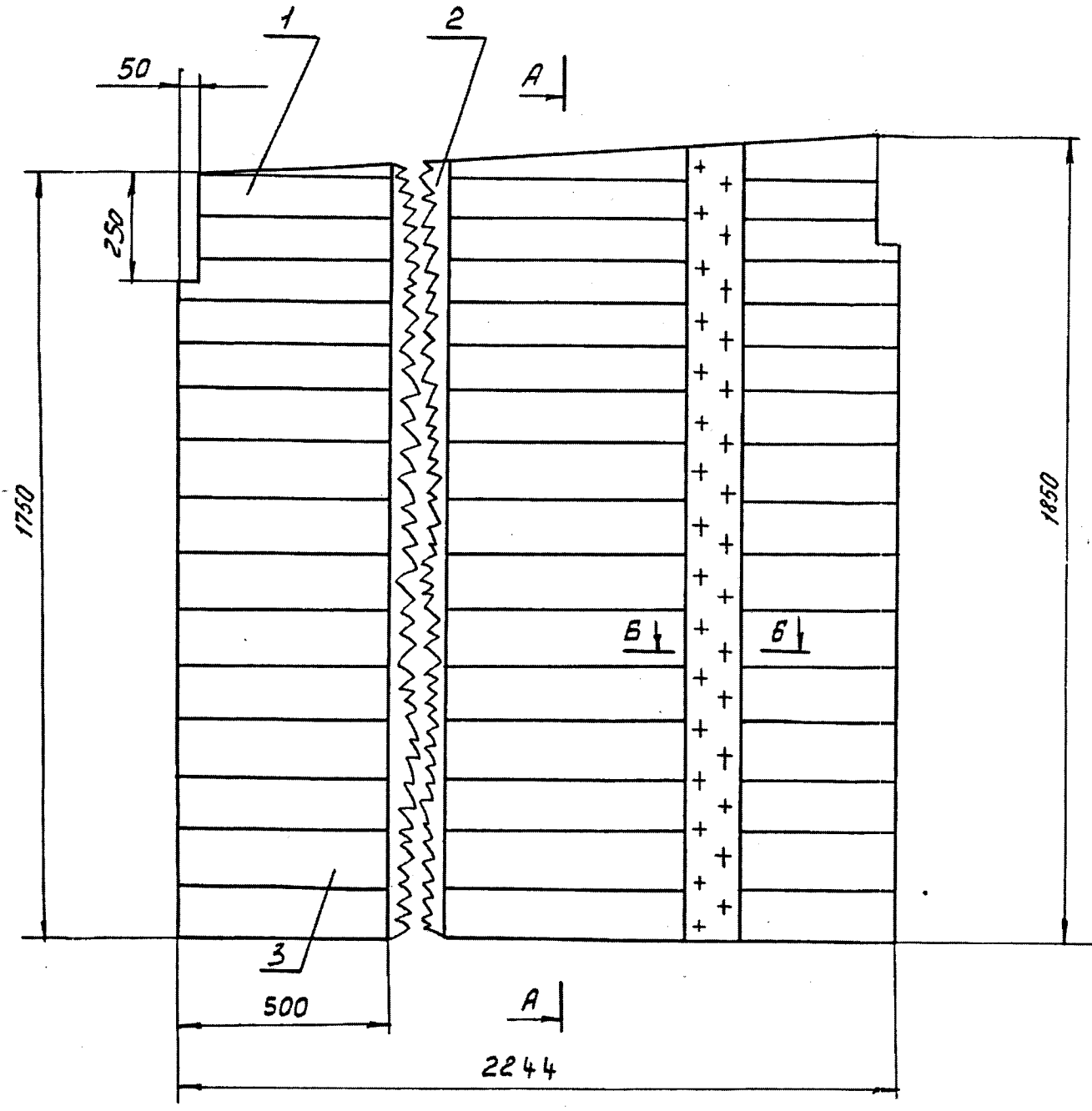
AK-630-Я sb 200-1-4 TRSB

				AK-630-Я sb 200-1-4 TRSB		
				Щит Cross Board		
				поперечный		
				сборочный чертеж		
				Assembly Drawing		
Изм. Лист	№ докум.	Подп.	Дата	Лист	Масса	Масштаб
Разраб.				A	110	1:10
Проб.				Лист	Листов	1
Т. контр.				Sheet	Total Sheets	1
И. контр.						
Чтб.						

Формат А5

AK-630-Я Sb 200-1-5 TRSB
AK-630-Я Sb 200-1-5 TRSB

R_z 500
✓(✓)



1. Предельные отклонения размеров по среднему классу точности ГОСТ 6449.5-82.
 2. Соединение досок в четверть К-2 по ГОСТ 9330-76.
 3. Для спецпоставок доски обрезные, без обзола, строганные, отверстия от сучков не допускаются.
 4. Допускается набор размера 1850 из досок - 2 хв.-25 ГОСТ 8486-86 различной ширины но не менее 70мм.
1. Limiting deviations of dimensions as per medium class of accuracy GOST 6449.5-82.
 2. Joining of boards for quarter K-2 as per GOST 9330-76.
 3. For the special supply, the board, which are trimmed, without wane, dressed, have holes of knots, are not permitted.
 4. The selection of dimension 1850 of the board - 2 kh v. - 25 GOST 8486-86 of different width but not less than 70mm is permitted.

Справ. №
Перв. примен.
Изд. № подл.
Подл. и дата
Изм. № докл.
Подл. и дата
Изм. № докл.
Подл. и дата

AK-630-Я Sb 200-1-5 TRSB

				AK-630-Я СБ200-1-5 ТРСБ		
				Type	Mass	Scale
Изм./Лист	№ док-м.	Подп.	Дата	Цит	Longitudinal	Лист
Разраб.				продольный	Board	Масса
Проб.				сборочный чертёж	Assembly Drawing	Масштаб
Т.контр.						1
И.контр.						Листов
Члб.						1
				Лист	Листов	1
				Sheet	Total Sheets	1

Формат А2

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
Reference No.					<u>Documents</u>		
	A2	/		AK-630-Ya Sb 200-1-6TR SB	Assembly drawing		
					<u>Components</u>		
	WD	/	1	AK-630-Ya 200-1-37TR	Board-2 Khv-25 x 100 GOST 8486-86 BxHxL= 25±1x50±1x2250±5	2	
	WD	/	2	AK-630-Ya 200-1-38TR	Board-2 Khv-25 x 125 GOST 8486-86 L = 2250 ± 5	1	
	WD	/	3	AK-630-Ya 200-1-39TR	Board-2 Khv-25 x 100 GOST 8486-86 L = 2350 ± 5	26	
					<u>Standard articles</u>		
			5		Nails K 3x70 GOST 4028-63	92	
Sign and D.							
Dupl. Inv. No.							
Alternate Inv. No.							
Sign and Date							
Orig. Inv. No.							

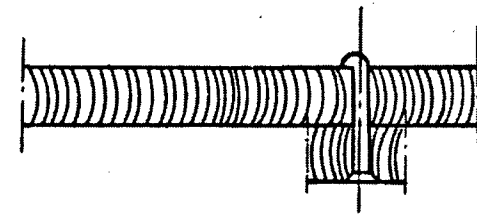
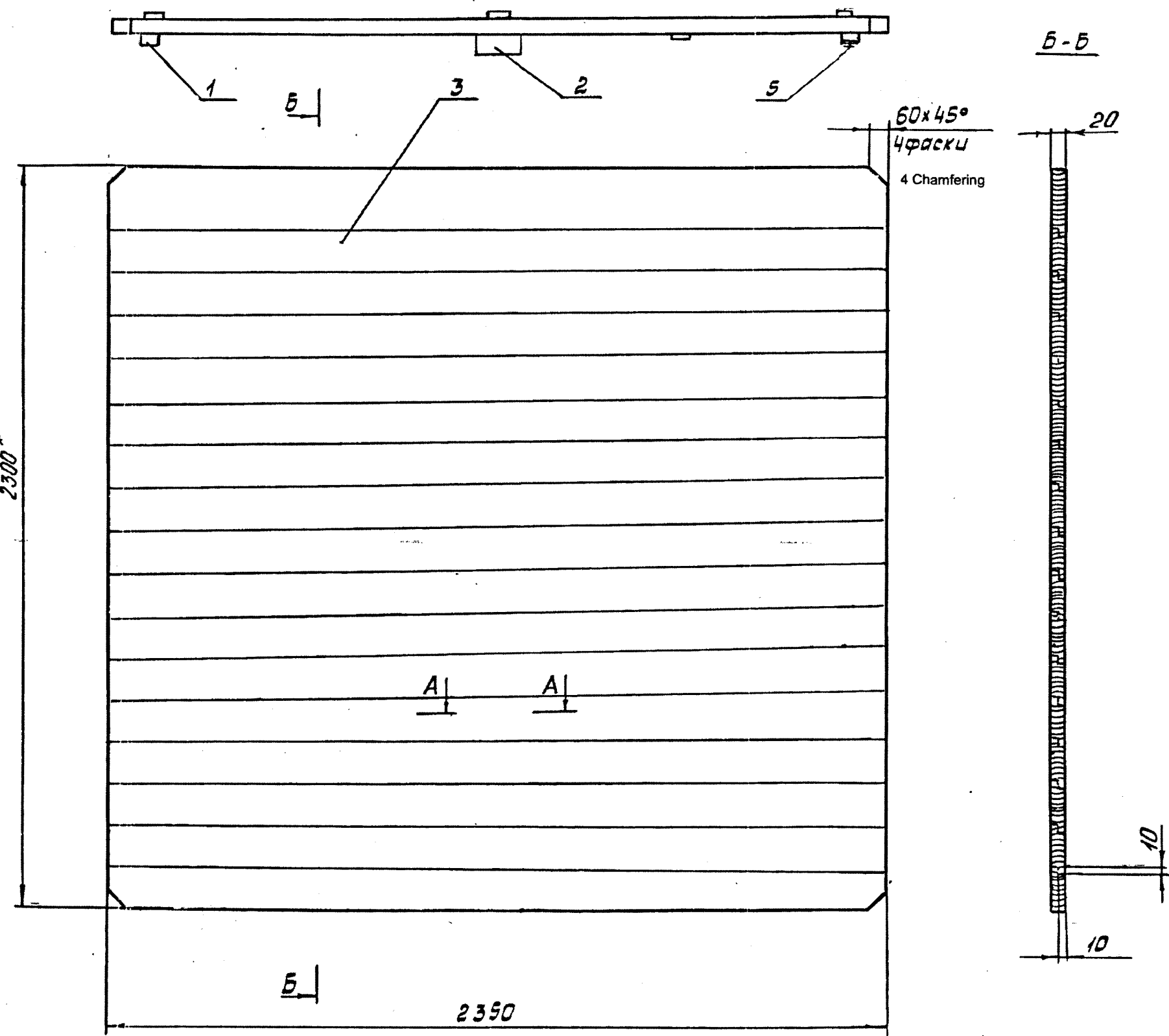
					AK-630-Ya Sb 200-1-6 TR			
Amend.	Sheet	Doc. No.	Sign	Date				
Developed by					Cover	Type	Sheet	Sheets
Checked by						A		1
Head of Q.C.D.								
Approved by								

AK-630-Я СБ200-1-6 ТРСБ

AK-630-Я Sb 200-1-6 TRSB

Rz 500/ (✓)

A-A
1:2



- 1.* Размеры для справок.
- 2. Соединение досок в четверть К-2 по ГОСТ9330-76.
- 3. Предельные отклонения размеров по среднему классу точности ГОСТ6449.5-82.
- 4. Для спецпоставок доски обрезные, без обзола, строганные, отверстия от сучков не допускаются.
- 5. Допускается набор размера 2300 из досок – 2 хв.-25 ГОСТ 8486-86 различной ширины но не менее 70мм.

- 1.* - Dimensions for reference.
- 2. Joining of boards for quarter K-2 as per GOST 9330-76.
- 3. Limiting deviations of dimensions as per medium class of accuracy GOST 6449.5-82.
- 4. For the special supply, the board, which are trimmed, without wane, dressed, have holes of knots, are not permitted.
- 5. The selection of dimension 2300 of the board - 2 kh v. - 25 GOST 8486-86 of different width but not less than 70mm is permitted.

Спроб. №

Инв.№ подл. Подп. и дата. Взам.инв.№ Инв.№ подл. Подп. и дата.

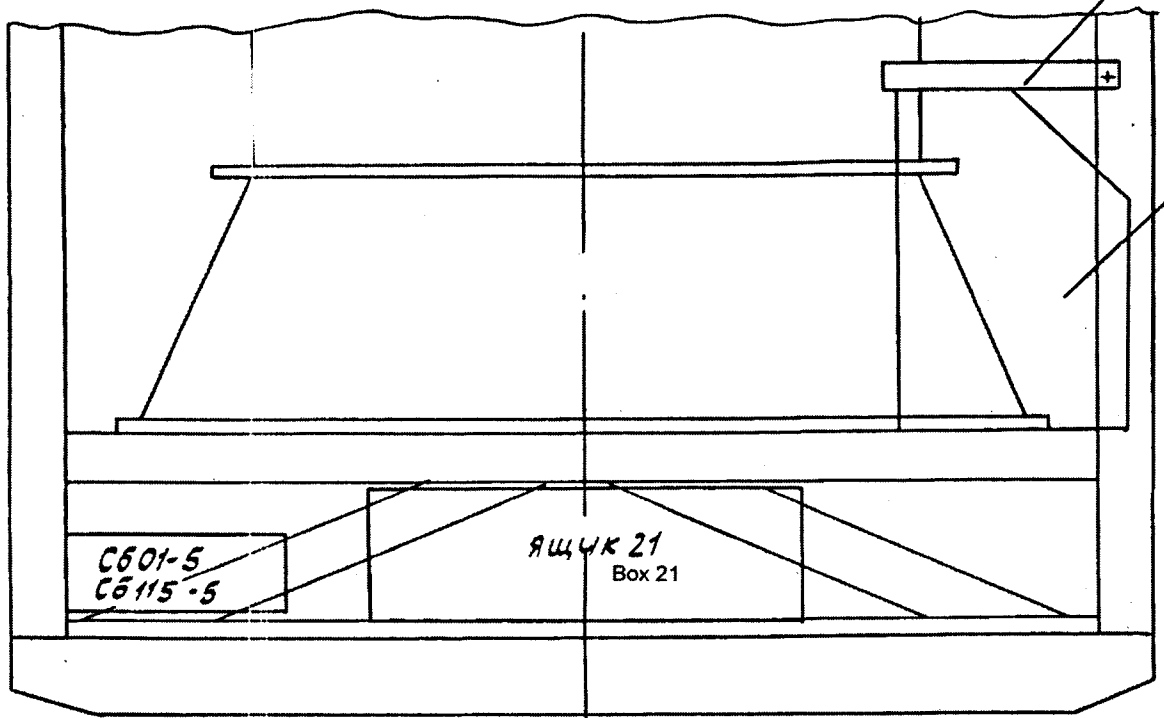
AK-630-Я Sb 200-1-6 TRSB

				AK-630-Я СБ200-1-6 ТРСБ		
				Type	Mass	Scale
Изм./Лист	№ док.	Подп.	Дата	Крышка	Cover	1/1
Разраб.				Сборочный чертеж		
Проб.				Лист	Листов 1	
Т.контр.				Sheet	Total Sheets 1	
Н.контр.				Assembly Drawing		
Удб.						

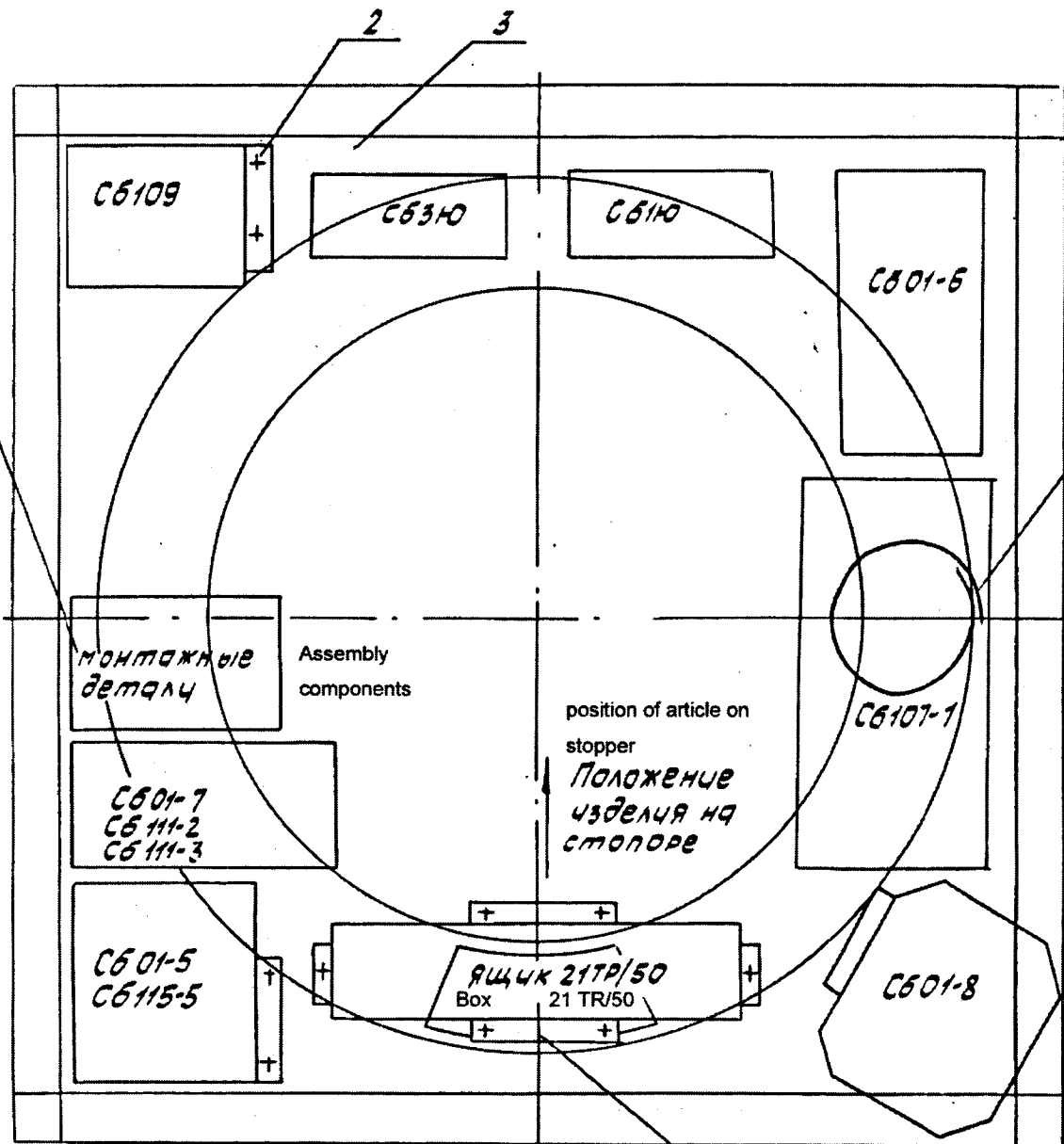
ФОРМАТ А3

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					Components			
	WD	/	1	AK-630-Ya Sb 200-14-1	Board-2 Khv -50 x 100 GOST 8486-86 B x H x L = 50 ± 2 x 50 ± 2 x 500 ± 5	2		
	WD	/	2	AK-630-Ya Sb 200-14-2	Board-2Khv -50 x 100 GOST 8486-86 B x H x L = 50 ± 2 x 50 ± 2 x 300 ± 5	8		
	WD	/	5	AK-630-Ya Sb 200-14-3	Cover. Polyethylene film T 0.15x3000, grade 1 400x500 GOST 10354-82	1	0.4 sq.m.	
	WD	/	6	AK-630-Ya Sb 200-14-4	Tag. Tin 50-GZhR-II TU 14-14214-87 90 ± 0.5 x 150 ± 0.5	1	Weight- -0.022 kg	
					Standard articles			
Dupl. Inv. No.			3		Nails 2 x 25 GOST 4029-63	30		
			4		Nails K 3 x 80 GOST 4028-63	10		
Alternate Inv. No.					Materials			
			7		Paper BP-3-35 Roll 830 GOST 9569-79	5	m	
Sign and Date	AK-630M-Ya Sb 200-14 TR							
	Amend.	Sheet	Doc. No.	Sign	Date			
Orig. Inv. No.	Developed by					Type	Sheet	Sheets
	Checked by					A	1	2
	Head of Q.C.D					Diagram for arranging sub assemblies in box 1 TR		
	Approved by							

View A
Вид А



Top view
Вид сверху



Hose VG (III)
Рукав ВГ(III)
-10-31,5-47хЛ

примен.

Справ. №

Инд. № подл. Подп. и дата. Взам. инв. № Инв. № дубл. Подп. и да

1. Volume of packing - according to packing list 1.
2. Fasten Sb01-8 downward with 2 bolts to the timber (beam) of frame (ref. Sb200-1TR), and upward - with planks position 1 as per the place.
3. Fasten each place cross-wise (across) by metallic strip M - 0.4 x 20 GOST 3560-73 in 2 rows with nails position 3 as per the place.
4. Positioning of sub-units in somewhat different manner is permitted at the bottom of box 1MTR.
5. Use nails position 4 for fastening of plank position 1.
6. For AK-630, the laying of sub-units in the box is similar.
7. After having wrapped in paper BP-3-35 GOST 9569-79 and after having already put the metallic tag on each package with the indication of the contents of package and the purpose of components on it, arrange the set of assembly components of article AK-630, AK-630M according to section 5 of group list AK-630M D inv. No. 38-4313 according to their purpose and preserve. Tie each package with thread Sh L 1.67 (06) P "a" GOST 17308-88. Put the packages with assembly components in the cover position 5 made of poly-ethylene sheet having dimension 400x500mm. Seal the ends of cover with electric iron or electric nippers.
8. It is permitted to use the poly-ethylene sheet M, linen of 0.15x3000 of grade 1 GOST 10354-82 for the making of cover position 5.

7. Комплект монтажных деталей изделий АК-630, АК-630М согласно раздела 5 ведомости комплектации АК-630М Д инв. № 38-4313 расположить согласно их назначения, законсервировать, завернув в свертки в бумагу БП-3-35 ГОСТ 9569-79, предварительно положив в каждый сверток металлическую бирку с указанием в ней состава свертка и назначения деталей. Каждый сверток обвязать шпагатом ШЛ 1.67 (06) П "а" ГОСТ 17308-88. Свертки с монтажными деталями уложить в чехол поз. 5 из пленки полиэтиленовой размером 400x500 мм. Концы чехла сварить электроутюгом или электроципочами.

8. Допускается применение пленки полиэтиленовой М, полотно 0.15x3000 1 сорт ГОСТ 10354-82 для изготовления чехла поз. 5.

1. Объем укладки согласно упаковочному листу 1.
2. SB01-8 внизу крепить 2 болтами к брусам каркаса (см. SB200-1TR) сверху - планками поз. 1 по месту.
3. Каждое место крепить поперек металлической лентой M - 0.4x20 ГОСТ 3560-73 в 2 ряда гвоздями поз. 3 по месту.
4. Допускается иное расположение узлов на дне ящика 1MTR.
5. Гвозди поз. 4 применять для крепления планки поз. 1.
6. Для АК-630 укладка узлов в ящике аналогична.

AK-630-Я Sb 200-14TRSB

AK-630-Я Sb 200-14TRSB				Type	Mass	Scale
Изм./Лист	№ док. инв.	Подп.	Дата	Лист	Масса	Масштаб
Разраб.				А	-	1:10
Проб.						
Т. контр.						
И. контр.						
Утв.						
Lay out diagram of sub-units in Box No. 1 TR				Sheet	Total Sheets 1	