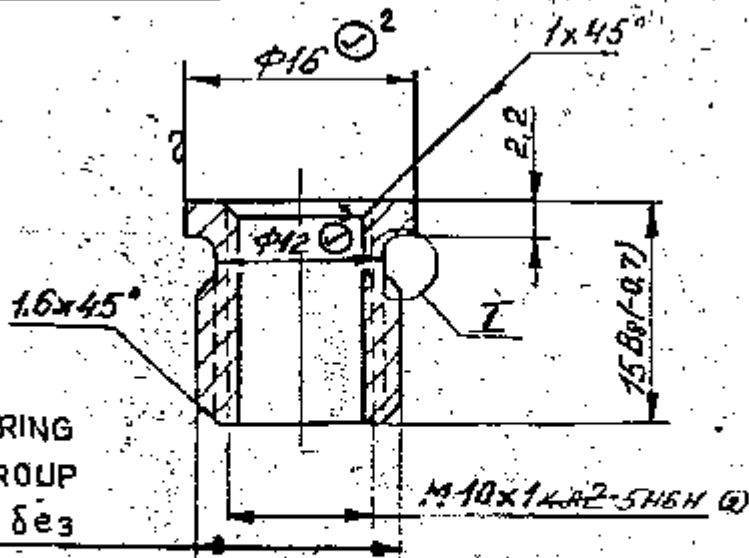


L 51-902

▽4 (▽)

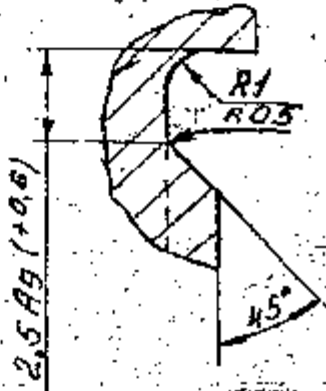


NOT CONSIDERING
 ACCURACY GROUP
 1 M14 X1.5 T1 2 δe3

Scale 5:1

REPAIR SIZE DIMENSIONS ARE ADDED WHERE INDICATED THUS BASED ON Lt. No. 82847/0H/4AD/ED DT. 13-1-95

S.No	R1	R2	REMARKS
1	M16x1.5 T1 2 δe3 φ 15.026 ±0.062 (MEAN)	M18x1.5 T1 2 δe3 φ 17.026 ±0.062 (MEAN)	1. MARK REPAIR SIZE CATEGORY R1, R2. 2. ALL OTHER SIZES SURFACE FINISH, MATERIAL AND TECHNICAL REQUIREMENTS ARE SAME.
2	φ 18	φ 20	
3	φ 13.8	φ 15.8	



- TECHNICAL REQUIREMENTS FOR THREAD SHOULD IN ACCORD WITH STANDARD 82021-00.
- DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE MAINTAINED AS PER ACCURACY CLASS 7 OST 1010.
- SHARP EDGES SHOULD BE BLUNTED.
- COATING : Zn 3, CHROMATIZING IN ACCORDANCE WITH UA 483-82.

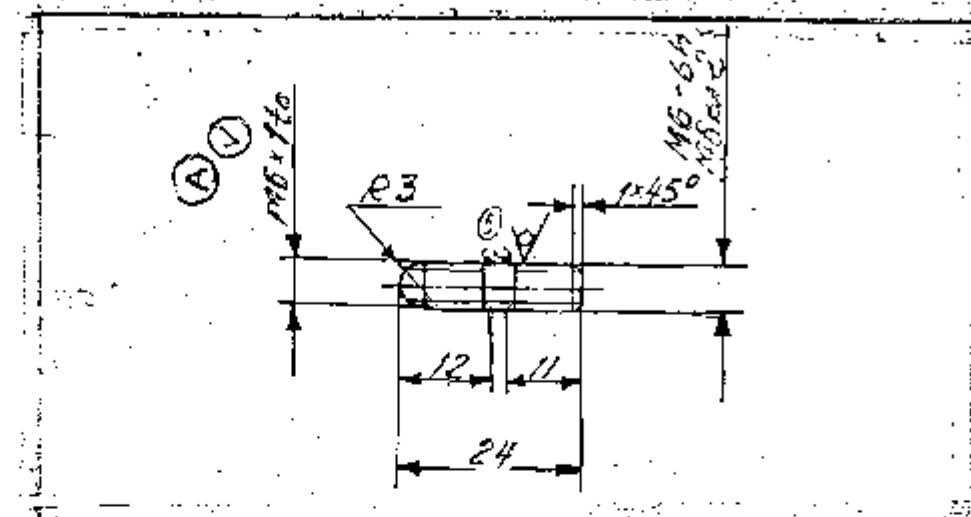
ALTERNATE MATERIAL: STEEL 080 M40 (EN 8) TO BS: 970
 Pt-1-1983 OR 45 CB TO IS: 1570

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

EST. MASS 0.009 kg		TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)	
A 13/09		3 rd ALTN. COMM. MIN POINT B DT. 27-2-09	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL- 16.560ST7417-75	USED ON- Cb 306-00-6
DWN	SCALE: 2:1	RO.BAR 45.60ST 1051-73	Cb 306-09-10
CHD	DIMENSIONS IN mm	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES) A V A III	
PCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: BUSH	
APPD	ALL THREADS TO CONFORM TO	D'S CAT NUMBER	DRAWING NUMBER
DATE 28-1-88			306 - 157



DRAWING NUMBER
350 03



(D) EQUIVALENT MATERIAL STEEL
45C8 TO IS:1570

1. DELETED.
2. TECHNICAL REQUIREMENTS FOR THREADS AS PER STANDARD 82021-00.
3. DIMENSIONS WITH UNSPECIFIED TOLERANCES AND THE REST OF THE TECHNICAL REQUIREMENTS AS PER STANDARD 82052-00.
4. COATING: CADMIUM 3, CHROMATIZING AS PER ULYN-104 WITH SUBSEQUENT ELIMINATION OF HYDROGEN EMBRITTLEMENT.
5. THE THREAD MAY BE MADE BY ROLLING WITH DIAMETER OF UN-THREADED PORTION WITH IN THE PITCH DIAMETER OF THREAD.
6. MECHANICAL DAMAGES OF THE CADMIUM COATING SUCH AS SCRATCHES, NICKS AND DENTS ARE ALLOWED ON ASSEMBLY UNITS, PROVIDED THE STEEL IS NOT EXPOSED.
7. ALTERNATE MATERIAL: STEEL GRADES 40 & 50 GOST 1050-74.
8. HARDNESS:- 27-32 HRC.

* ALT MATERIAL:-
STEEL 709 M40 (EN-19) TO
BS:- 970 PT.-1- 1983

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

EST WT 0.004 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

EXPLANATORY NOTE:

8. REFERENCE MATERIAL QUOTED:
COLD DRAWN SIZED ROUND BAR, 6.0 (-0.025)mm DIA TO GOST 7417-75 FROM HIGH GRADE SIZED STEEL NORMAL SURFACE QUALITY TO GOST 1051-73 AND MANUFACTURED IN ACCORDANCE WITH QUALITY CARBON STRUCTURAL STEEL GRADE 45 TO GOST 1050-74.
REFERENCE NOTE '7' ON ALTERNATE MATERIAL: QUALITY CARBON STRUCTURAL STEEL GRADE 40 AND 50 TO GOST 1050-74.
a) CHEMICAL COMPOSITION: AS PER GOST 1050-74.

GRADE OF STEEL	CONTENT OF ELEMENTS%						REMARKS
	C	Si	Mn	Cr	S	P	
45	0.42 - 0.50	0.17 - 0.37	0.50 - 0.80	0.25	0.040	0.035	Ref,Matl
40	0.37 - 0.45	0.17 - 0.37	0.50 - 0.80	0.25	0.040	0.035	Alt,Matl
50	0.47 - 0.55	0.17 - 0.37	0.50 - 0.80	0.25	0.040	0.035	Alt,Matl

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH

b) MECHANICAL PROPERTIES: AS PER GOST 1050-74.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	YIELD POINT Kgf/mm ²	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH Kgf/cm ²	HARDNESS B H N M A X	REMARKS
45	61	36	16	40	5	207	Ref,Matl
40	58	34	19	45	6	197	Alt,Matl
50	64	38	14	40	4	217	Alt,Matl

(A) 9. REPAIR SIZE DIMENSIONS ARE ADDED WHERE INDICATED THUS (A) BASED ON OVERHAUL SPECIFICATIONS PART III REPAIR DRAWINGS.

Sl.No.	R	REMARKS
1	M6 x 1.25 to	ALL OTHER CONDITIONS AS PER STD. DRG.
2	PCD = 7.188 ± 0.152	

**
Cb 306-08-8, Cb 306-09-10,
Cb 401-03-6, Cb 3301-15-30,
Cb 306-08-13, Cb 306-09-13,
Cb 3308-04-26

ISSUE	DATE	NATURE OF AMENDMENTS
D	12-8-10	4 th Alt. Comm. Meeting Minutes Point No.11 Dt: 26-10-09
C	25.8.08	USED ON NUMBERS ADDED AUTHY:- MIN. OF ALT. COM. MEET.
B	11.01.08	POINT No.-2.12 Dt.- 07-02-07
A	6-9-95	REPAIR SIZE DIMENSION ADDED

DRN CHD TCD APPD DATE 30-5-86

MATERIAL ROUND BAR GOST 7417-75 * 45 GOST 1051-73

USED ON Cb 3301-15-44 ** (C) Cb 3338-402-4 Cb 3329-01-11

CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI

SCALE 1 : 1

DIMENSIONS IN mm

TOLERANCE ON DIMNS UNLESS OTHERWISE STATED

ALL THREADS TO CONFORM TO

TITLE: STUD M6 x 24

D S CAT NUMBER

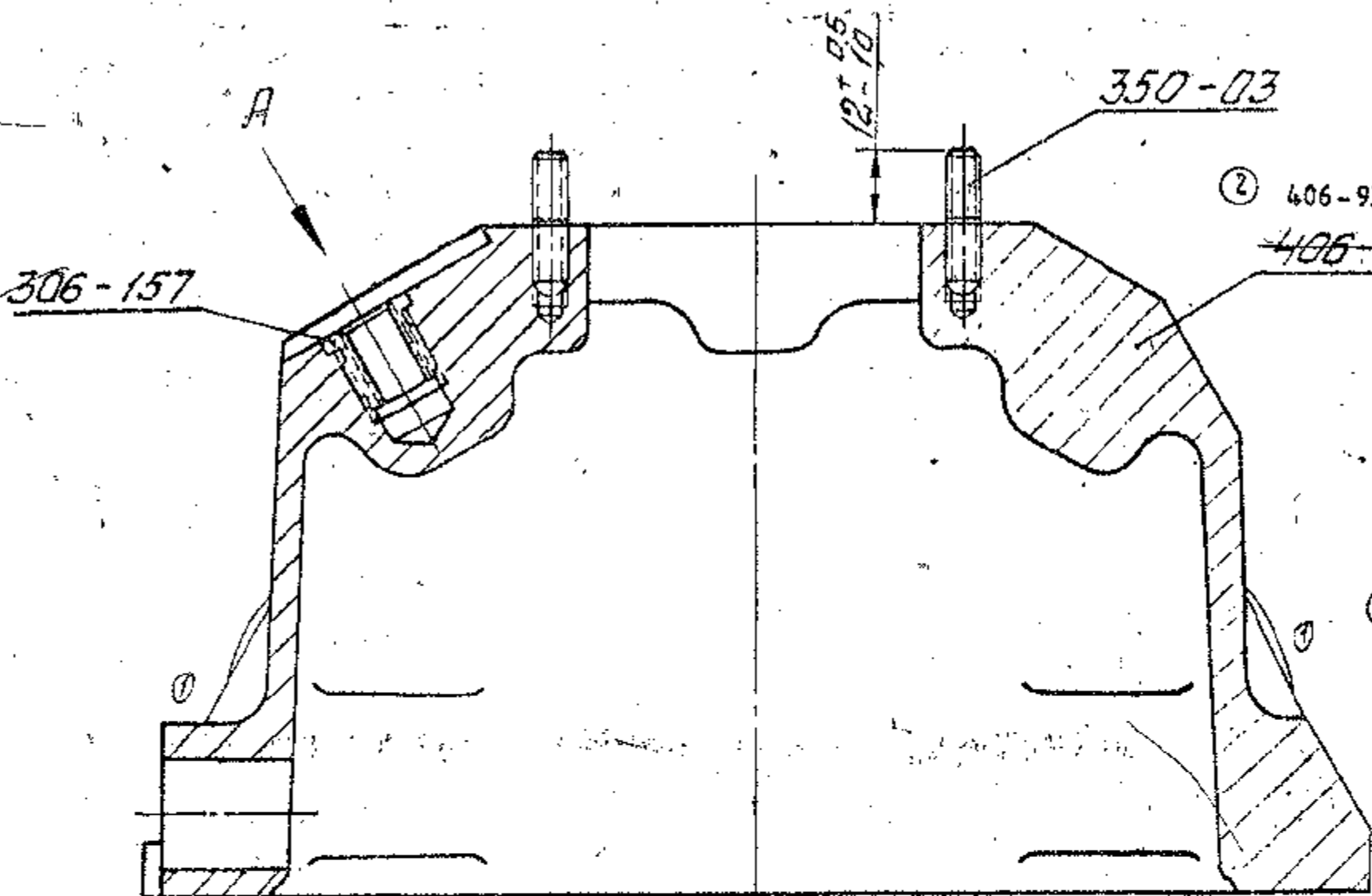
DRAWING NUMBER 350 03

COMMON TO V-92S2 ENGINE

(A-11)
SIZE A3



8-8U-30230



② 406-93-14
~~406-93-7~~

① Остальная графика и технические условия по чертежу СБ 406-08.

OTHER SKETCHES AND SPECIFICATIONS ARE AS PER DRAWING СБ 406-08.

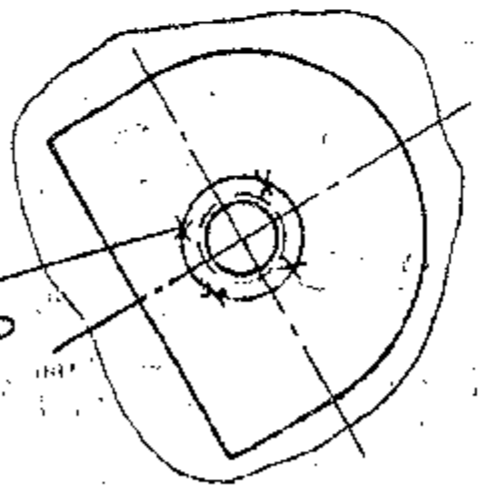
① SET THE BUSH ITEM 2 ON SEALING COMPOUND ANAEROBIC ANATERM-5МАТ 2257-339-00208947-2000 AS PER ИЛ-652-86.

② * СБ 406-12-77

VIEW A
 ВУД А

27.12.77
 28.12.77
 29.12.77
 30.12.77
 31.12.77
 01.01.78
 02.01.78
 03.01.78
 04.01.78
 05.01.78
 06.01.78
 07.01.78
 08.01.78
 09.01.78
 10.01.78
 11.01.78
 12.01.78
 13.01.78
 14.01.78
 15.01.78
 16.01.78
 17.01.78
 18.01.78
 19.01.78
 20.01.78
 21.01.78
 22.01.78
 23.01.78
 24.01.78
 25.01.78
 26.01.78
 27.01.78
 28.01.78
 29.01.78
 30.01.78
 31.01.78
 01.02.78
 02.02.78
 03.02.78
 04.02.78
 05.02.78
 06.02.78
 07.02.78
 08.02.78
 09.02.78
 10.02.78
 11.02.78
 12.02.78
 13.02.78
 14.02.78
 15.02.78
 16.02.78
 17.02.78
 18.02.78
 19.02.78
 20.02.78
 21.02.78
 22.02.78
 23.02.78
 24.02.78
 25.02.78
 26.02.78
 27.02.78
 28.02.78
 29.02.78
 30.02.78
 31.02.78
 01.03.78
 02.03.78
 03.03.78
 04.03.78
 05.03.78
 06.03.78
 07.03.78
 08.03.78
 09.03.78
 10.03.78
 11.03.78
 12.03.78
 13.03.78
 14.03.78
 15.03.78
 16.03.78
 17.03.78
 18.03.78
 19.03.78
 20.03.78
 21.03.78
 22.03.78
 23.03.78
 24.03.78
 25.03.78
 26.03.78
 27.03.78
 28.03.78
 29.03.78
 30.03.78
 31.03.78
 01.04.78
 02.04.78
 03.04.78
 04.04.78
 05.04.78
 06.04.78
 07.04.78
 08.04.78
 09.04.78
 10.04.78
 11.04.78
 12.04.78
 13.04.78
 14.04.78
 15.04.78
 16.04.78
 17.04.78
 18.04.78
 19.04.78
 20.04.78
 21.04.78
 22.04.78
 23.04.78
 24.04.78
 25.04.78
 26.04.78
 27.04.78
 28.04.78
 29.04.78
 30.04.78
 31.04.78
 01.05.78
 02.05.78
 03.05.78
 04.05.78
 05.05.78
 06.05.78
 07.05.78
 08.05.78
 09.05.78
 10.05.78
 11.05.78
 12.05.78
 13.05.78
 14.05.78
 15.05.78
 16.05.78
 17.05.78
 18.05.78
 19.05.78
 20.05.78
 21.05.78
 22.05.78
 23.05.78
 24.05.78
 25.05.78
 26.05.78
 27.05.78
 28.05.78
 29.05.78
 30.05.78
 31.05.78
 01.06.78
 02.06.78
 03.06.78
 04.06.78
 05.06.78
 06.06.78
 07.06.78
 08.06.78
 09.06.78
 10.06.78
 11.06.78
 12.06.78
 13.06.78
 14.06.78
 15.06.78
 16.06.78
 17.06.78
 18.06.78
 19.06.78
 20.06.78
 21.06.78
 22.06.78
 23.06.78
 24.06.78
 25.06.78
 26.06.78
 27.06.78
 28.06.78
 29.06.78
 30.06.78
 31.06.78
 01.07.78
 02.07.78
 03.07.78
 04.07.78
 05.07.78
 06.07.78
 07.07.78
 08.07.78
 09.07.78
 10.07.78
 11.07.78
 12.07.78
 13.07.78
 14.07.78
 15.07.78
 16.07.78
 17.07.78
 18.07.78
 19.07.78
 20.07.78
 21.07.78
 22.07.78
 23.07.78
 24.07.78
 25.07.78
 26.07.78
 27.07.78
 28.07.78
 29.07.78
 30.07.78
 31.07.78
 01.08.78
 02.08.78
 03.08.78
 04.08.78
 05.08.78
 06.08.78
 07.08.78
 08.08.78
 09.08.78
 10.08.78
 11.08.78
 12.08.78
 13.08.78
 14.08.78
 15.08.78
 16.08.78
 17.08.78
 18.08.78
 19.08.78
 20.08.78
 21.08.78
 22.08.78
 23.08.78
 24.08.78
 25.08.78
 26.08.78
 27.08.78
 28.08.78
 29.08.78
 30.08.78
 31.08.78
 01.09.78
 02.09.78
 03.09.78
 04.09.78
 05.09.78
 06.09.78
 07.09.78
 08.09.78
 09.09.78
 10.09.78
 11.09.78
 12.09.78
 13.09.78
 14.09.78
 15.09.78
 16.09.78
 17.09.78
 18.09.78
 19.09.78
 20.09.78
 21.09.78
 22.09.78
 23.09.78
 24.09.78
 25.09.78
 26.09.78
 27.09.78
 28.09.78
 29.09.78
 30.09.78
 31.09.78
 01.10.78
 02.10.78
 03.10.78
 04.10.78
 05.10.78
 06.10.78
 07.10.78
 08.10.78
 09.10.78
 10.10.78
 11.10.78
 12.10.78
 13.10.78
 14.10.78
 15.10.78
 16.10.78
 17.10.78
 18.10.78
 19.10.78
 20.10.78
 21.10.78
 22.10.78
 23.10.78
 24.10.78
 25.10.78
 26.10.78
 27.10.78
 28.10.78
 29.10.78
 30.10.78
 31.10.78
 01.11.78
 02.11.78
 03.11.78
 04.11.78
 05.11.78
 06.11.78
 07.11.78
 08.11.78
 09.11.78
 10.11.78
 11.11.78
 12.11.78
 13.11.78
 14.11.78
 15.11.78
 16.11.78
 17.11.78
 18.11.78
 19.11.78
 20.11.78
 21.11.78
 22.11.78
 23.11.78
 24.11.78
 25.11.78
 26.11.78
 27.11.78
 28.11.78
 29.11.78
 30.11.78
 31.11.78
 01.12.78
 02.12.78
 03.12.78
 04.12.78
 05.12.78
 06.12.78
 07.12.78
 08.12.78
 09.12.78
 10.12.78
 11.12.78
 12.12.78
 13.12.78
 14.12.78
 15.12.78
 16.12.78
 17.12.78
 18.12.78
 19.12.78
 20.12.78
 21.12.78
 22.12.78
 23.12.78
 24.12.78
 25.12.78
 26.12.78
 27.12.78
 28.12.78
 29.12.78
 30.12.78
 31.12.78

② Роккерный
 TO BE PUNCH-LOCKED



ITEM NO	PART NO	NOMENCLATURE	QTY	REMARKS
№	Обозначение	Наименование	Кол.	Примечание
1	406-93-14	CYLINDER HEAD COVER RH	1	
3	350-03	Шпилька М6x24	24	
2	306-157	Втулка BUSH	2	
1	406-93-7	CYLINDER HEAD COVER, R.H.	1	

* PILOT SAMPLE SHOULD BE APPROVED BY A IIS P BEFORE BULK PRODUCTION

EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS R
2	9.9.15
1	7.2.89
ISSUE DATE	NATURE OF AMENDMENTS
OWN	SCALE: 1:1
CHD	DIMENSIONS IN mm
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED
APPD	ALL THREADS TO CONFORM TO
DATE 28.1.88	
	USED ON: * СБ 406-12-77
	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A III
	TITLE: CYLINDER HEAD COVER R.H.
	D'S CAT NUMBER
	DRAWING NUMBER СБ 306-08-8