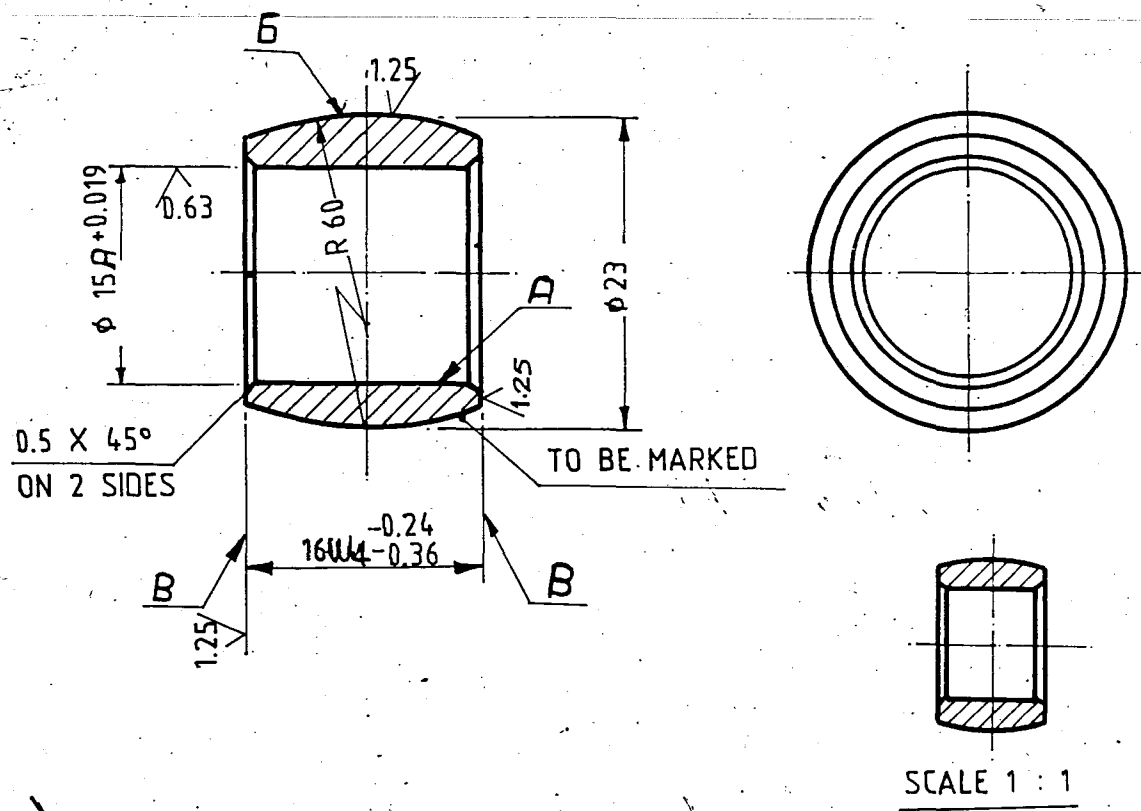


DRAWING NUMBER
315-622-2

✓(✓)



1. INSPECTION GROUP III, TT-11.
2. DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE OBTAINED AS PER A7 OR B7 OST 1010.
HRC₃61..... 64
3. ~~HRC = 60-63~~
4. RUN-OUT OF SURFACES "B" RELATIVE TO SURFACE "A" SHOULD NOT EXCEED AT DIA. 18mm.
5. RUN-OUT OF SURFACE "B" RELATIVE TO SURFACE "A" SHOULD NOT EXCEED 0.05mm.
6. SHIFT OF SPHERE CENTRE FROM THE AXIS OF SYMMETRY OF SURFACES "B" SHOULD NOT EXCEED 0.3mm.
7. SHARP EDGES SHOULD BE BLUNTED.
8. COATING :-CHEMICAL OXIDIZING, OIL FINISHING.

EXPLANATORY NOTE :

(B) MATERIAL QUOTED: STEEL U₃X15 GOST 801-78.
BALL BEARING STEEL WITH CHROMIUM (X) CONTENT 15% BY WEIGHT.

a) CHEMICAL COMPOSITION :

CARBON	= 0.95 - 1.05	COPPER	= 0.25 (max)
SILICON	= 0.17 - 0.37	NICKEL & COPPER	= 0.50 (max)
MANGANESE	= 0.20 - 0.40		
CHROMIUM	= 1.30 - 1.65		
SULPHUR	= 0.02 (max)		
PHOSPHORUS	= 0.02 (max)		
NICKEL	= 0.30 (max)		

* ROUND BLANK 25.5-Г-4 GOST 14955-77
U₃X 15-0-XB GOST 801-78

(C) EQUIVALENT MATERIAL
STEEL 535A 99 (EN31) TO BS: 970/103
CR 2 TO IS 4399-72

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

EST WT 0.0267 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

DRN	CHD	TCD	APPD	DATE	MATERIAL	USED ON
				08-5-86	SEE ABOVE * U₃X 15 GOST 801-78	CG 315-662-3
SCALE 2 : 1					CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI	
DIMENSION IN mm					TITLE	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED					ROLLER	
ALL THREADS TO CONFORM TO					DRAWING NUMBER	
ISSUE DATE NATURE OF AMENDMENTS					315-622-2	

DRAWING INDIANISED BASED ON ISSUE 3

KVD NO 78288

(A 6)

SIZE A3