



1. technical requirements for threads - as per standard 82021-00.
2. dimensions with unspecified tolerances and the rest of the technical requirements as per standard 82052-00.
3. coating: cadmium, chromating as per 4311-104 with elimination of hydrogen embrittlement.
4. The thread may be made by rolling with the diameter of unthreaded portion within the pitch diameter of threads.
5. mechanical damages of cadmium coating such as scratches, nicks, and dents are allowed on assembly units, provided the steel is not exposed.
6. Alternate material: steel grades 40 and 50 GOST 1051-74.

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

Sl.No.	R	REMARKS
1.	1 M 12 X 1.5 to	ALL OTHER CONDITIONS AS PER STD. DRG.
2.	P.C.D. 11.026 +0.170 +0.095	

(B) HARDNESS:- 27-32 HRC.

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

EST. WT. 0.025 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 OUTSIDE R INSIDE-EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

**EXPLANATORY NOTE:-**

Material QUOTED : ROUND BAR GOST 7417-75  
45 GOST 1051-73

Alt Matl Quoted : 40 & 50 GOST 1050-74.

PARTIANS TO SIZED, COLD ROLLED OR COLD DRAWN STEEL WITH ROUND SECTION AS PER GOST 7417-75.

40, 45 & 50 ARE THE GRADES OF STEEL 1050-74.

a) CHEMICAL COMPOSITION : ( AS PER GOST 1050-74 ).

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C	Si	Mn	Cr	P	Cu	S	Ni
40	0.37-0.45	0.17-0.37	0.50-0.80	0.25	0.035	0.25	0.040	0.25
45	0.42-0.50	0.17-0.37	0.50-0.80	0.25	0.035	0.25	0.040	0.25
50	0.47-0.55	0.17-0.37	0.50-0.80	0.25	0.035	0.25	0.040	0.25

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

GRADE OF STEEL	TENSILE STRENGTH Kgf/mm <sup>2</sup> ( min )	YIELD POINT Kgf/mm <sup>2</sup> ( min )	% ELONGATION ( MIN )	% REDUCTION IN AREA ( min )	IMPACT STRENGTH Kgf/cm <sup>2</sup> ( min )
40	58	34	19	45	6
45	61	36	16	40	5
50	64	38	14	40	4

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

DRN	CHO	TCO	APPD	DATE	SCALE	DIMENSIONS IN mm.	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
				19-6-89	1:1					350-11
MATERIAL :- ROUND BAR * GOST 7417-75 45 GOST 1051-73						CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A D I		TITLE STUD M10 x 52		
USED ON Cb 3301-15-44 CB 3301-15-30 (C)										
AUTHY: Third Alt. Comp. Minutes Point 5 Dated 27-02-2009.										
USED ON NUMBERS ADDED										
AUTHY:- MIN. OF ALT. COM. MEET. POINT No.:- 2.12 Dt:- 07-02-07.										
REPAIR SIZE DIMENSION ADDED										
ISSUE	DATE	NATURE OF AMENDMENTS								