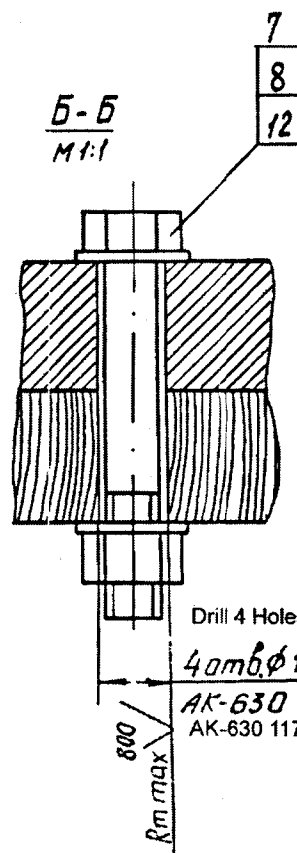
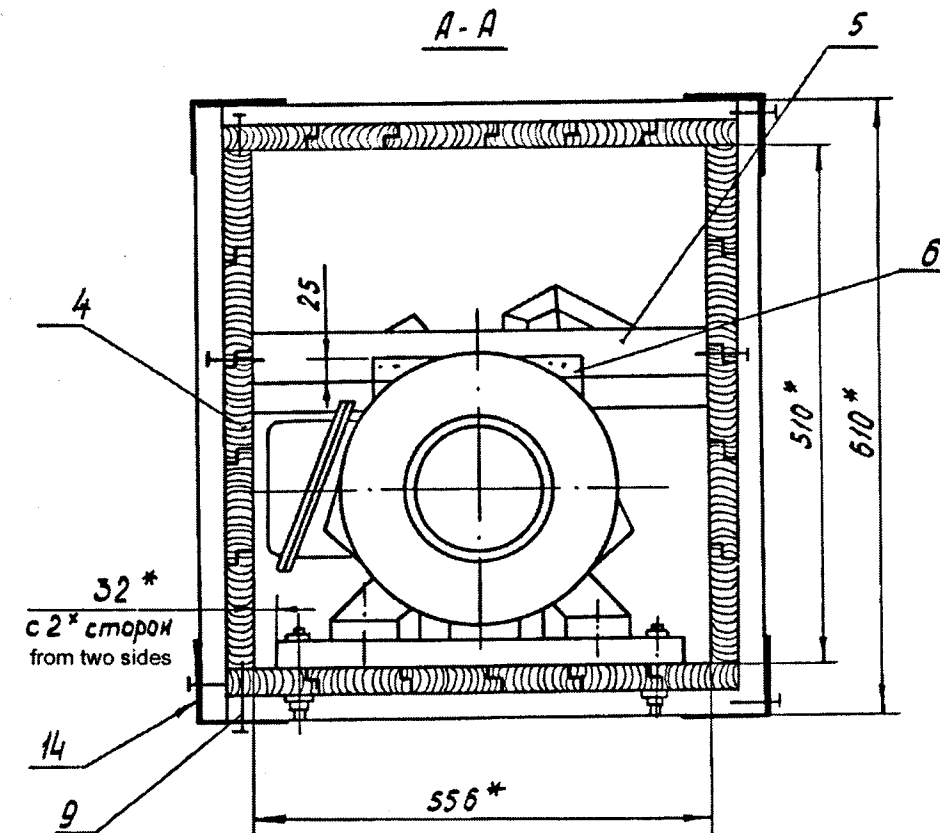
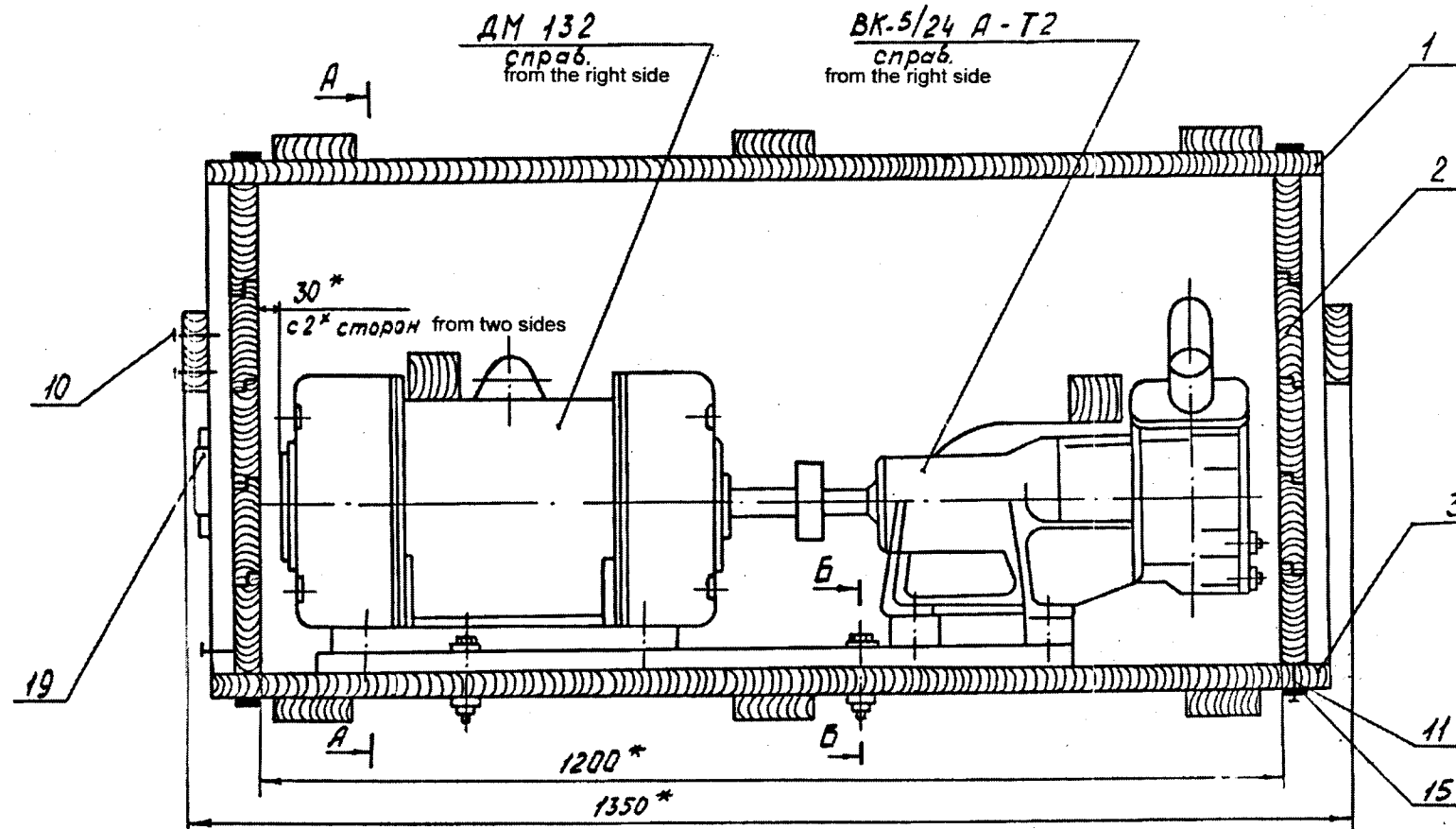


First Use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
					<u>Documents</u>			
Reference No.	A2	/		AK-630-Ya Sb 200-3TR SB	Assembly drawing			
	A4	/	1	AK-630-Ya Sb 200-3-1TR	Upper cover	1		
	A4	/	2	AK-630-Ya Sb 200-3-2TR	Face wall	2		
	A4	/	3	AK-630-Ya Sb 200-3-3TR	Bottom	1		
	A4	/	4	AK-630-Ya Sb 200-3-4TR	Side wall	2		
					<u>Components</u>			
Sign and Date	WD	/	5	AK-630-Ya 200-3-1TR	Board-2 Khv-50 x 125 GOST 8486-86 BxHxL= 50±2x50±2x556±5	2		
	WD	/	6	AK-630-Ya 200-3-2TR	Felt G PrA 8x10Cx200 GOST 6418-81	2		
Dupl. Inv. No.					<u>Standard articles</u>			
			7		Bolt M12-8gx90.109.40Kh.029 GOST 7798-70	4		
			8		Nut 2M12-6G.10.40Kh.026 GOST 5915-70	4		
Sign and Date					<b>AK-630-Ya Sb 200-3 TR</b>			
	Amend.	Sheet	Doc. No.	Sign	Date			
Orig. Inv. No.	Developed by					Type	Sheet	Sheets
	Checked by					A	1	2
	Head of Q.C.D					<b>Transportation box 4TR</b>		
	Approved by							





1. \* - Dimensions for reference.
2. Cover the angles of box with steel strip position 15.
3. 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 17 and with nails position 11.
4. On the cover of box and on the front wall, put the box no., index and the number of article AK-630M and its number.
5. Put the manipulated markings No. 1, 3, 11, 9 with dimensions for label No. 4 as per GOST 14192-96 on the left top corner on two adjacent walls, except the marking No. 9.
6. 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 wall and the cover in conformity with GOST 14192-96 and in conformity with agreement.
7. Remaining technical requirements as per GOST V 6454-75.
8. Fasten the article with bolts position 7 and with beams (timber) position 5.
9. After corking, seal the box with wire KO 0.5 GOST 792-67 and 4 seals 1-6x10-AD1M GOST 18677-73 at two places for fastening of strip for lock.
10. Local shaving of each side with area not more than 20 % with depth up to 1 mm and with finishing of Rz1200 is permitted.

1. \*Размеры для справок.
2. Углы ящика обить стальной лентой поз.15.
3. Внутренние стенки и дно ящика обить пергамином кровельным П-350 ГОСТ 2697-83 или бумагой ДБ ГОСТ 8828-89 с креплением ее дранью размером 3.5-5.0x25 поз.17 и гвоздями поз.11.
4. На крышке ящика и на передней стенке ящика ставить № знака, индекс изделия АК-630М и его номер.
5. Манипуляционные знаки № 1,3,11,9 ( ) с размерами для ярлыка №4 по ГОСТ 14192-96 располагать в левом верхнем углу на 2-х соседних стенках, кроме знака №9.
6. 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 стенке и крышке в соответствии с ГОСТ 14192-96 и договора.
7. Остальные технические условия по ГОСТ В 6454-75.
8. Изделие закрепить болтами поз.7 и брусками поз.5.
9. После укупорки ящик опломбировать с использованием проволоки КО 0,5 ГОСТ 792-67 и 4х пломб I-6x10-AD1M ГОСТ 18677-73 в 2х местах крепления ленты в замок.
10. Допускается местная непро stroжка каждой стороны площадью не более 20%, глубиной до 1мм и чистой обработкой Rz 1200.

AK-630-Я Sb 200-3 TRSB

				AK-630-Я Sb 200-3 TRSB		
				Type	Mass	Scale
				Лист	Масса	Масштаб
				A	180	1:5
				Ящик транспортно-рабочий №4 ТР		
				Сборочный чертёж		
				Лист	Листов 1	
				Sheet	Total Sheets 1	
				Transportation Box No. 4 TR		
				Assembly Drawing		

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
Reference No.					<u>Documents</u>		
	A3	/		AK-630-Ya Sb 200-3-1TR SB	Assembly drawing		
					<u>Components</u>		
	WD	/	1	AK-630-Ya 200-3-3TR	Board-2 Khv-25 x 150 GOST 8486-86 L = 1300 ±5	1	
	WD	/	2	AK-630-Ya 200-3-3TR	Board-2 Khv-25 x 125 GOST 8486-86 L = 1300 ± 5	4	
	WD	/	3	AK-630-Ya 200-3-5TR	Board-2 Khv-25 x 100 GOST 8486-86 L = 610 ± 5	3	
					<u>Standard articles</u>		
			4		Nails K 2.5x60 GOST 4028-63	30	
Sign and Dupl. Inv. No.							
Alternate inv. No.							
Sign and Date							
Orig. Inv. No.							

					<b>AK-630-Ya Sb 200-3-1TR</b>			
Amend.	Sheet	Doc. No.	Sign	Date	<b>Upper cover</b>	Type	Sheet	Sheets
Developed by						A		1
Checked by								
Head of Q.C.D								
Approved by								

First use

Reference No.

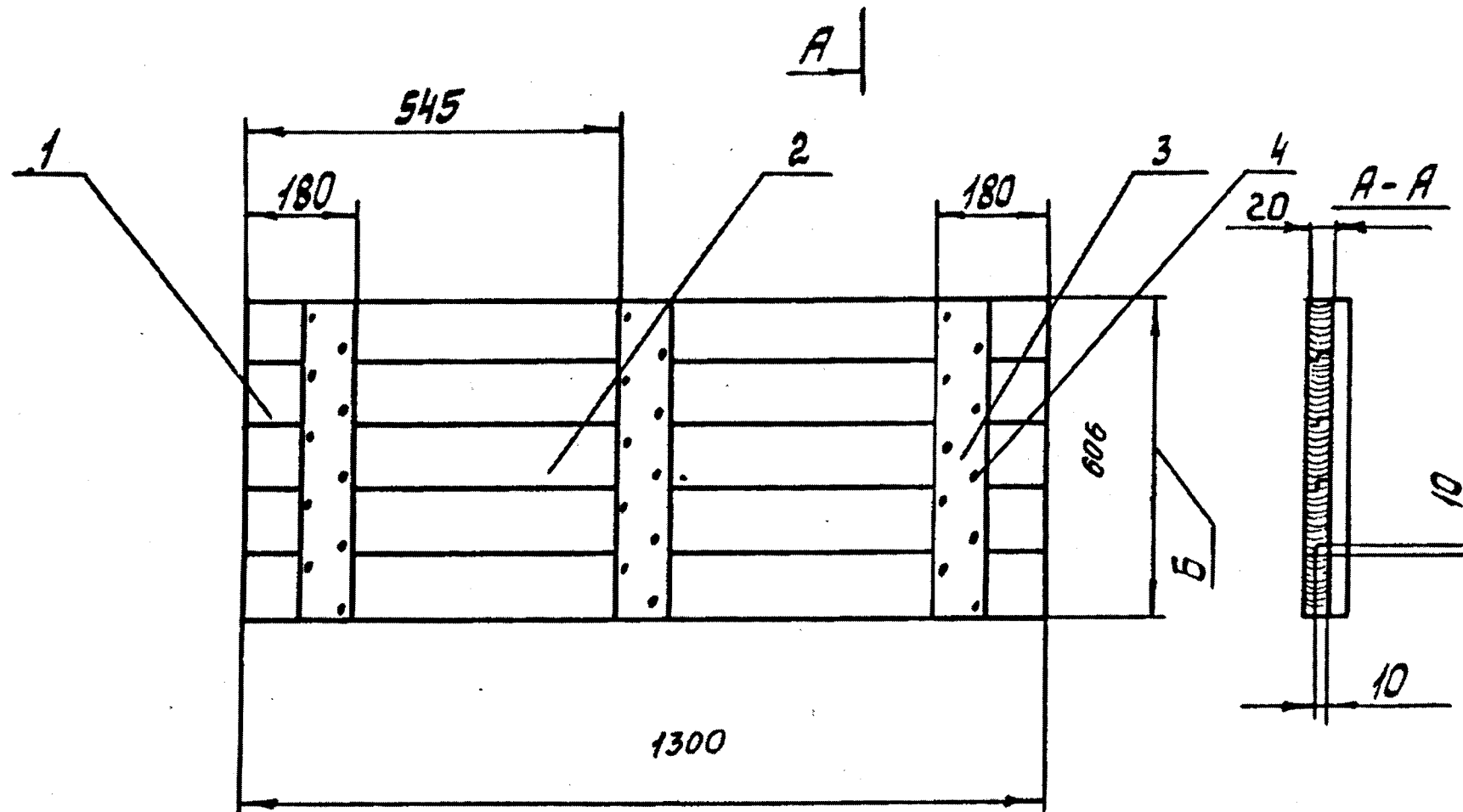
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



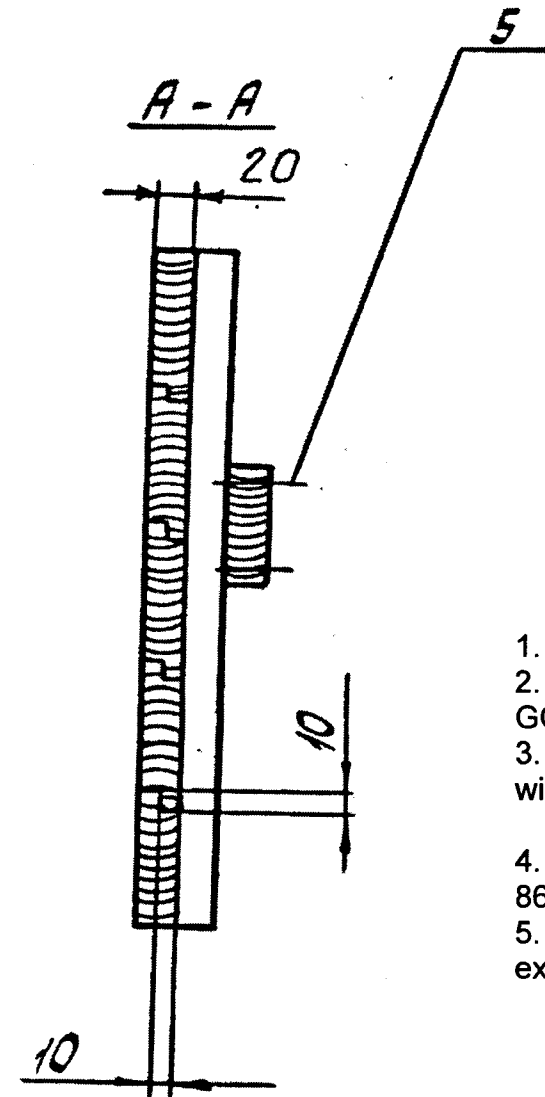
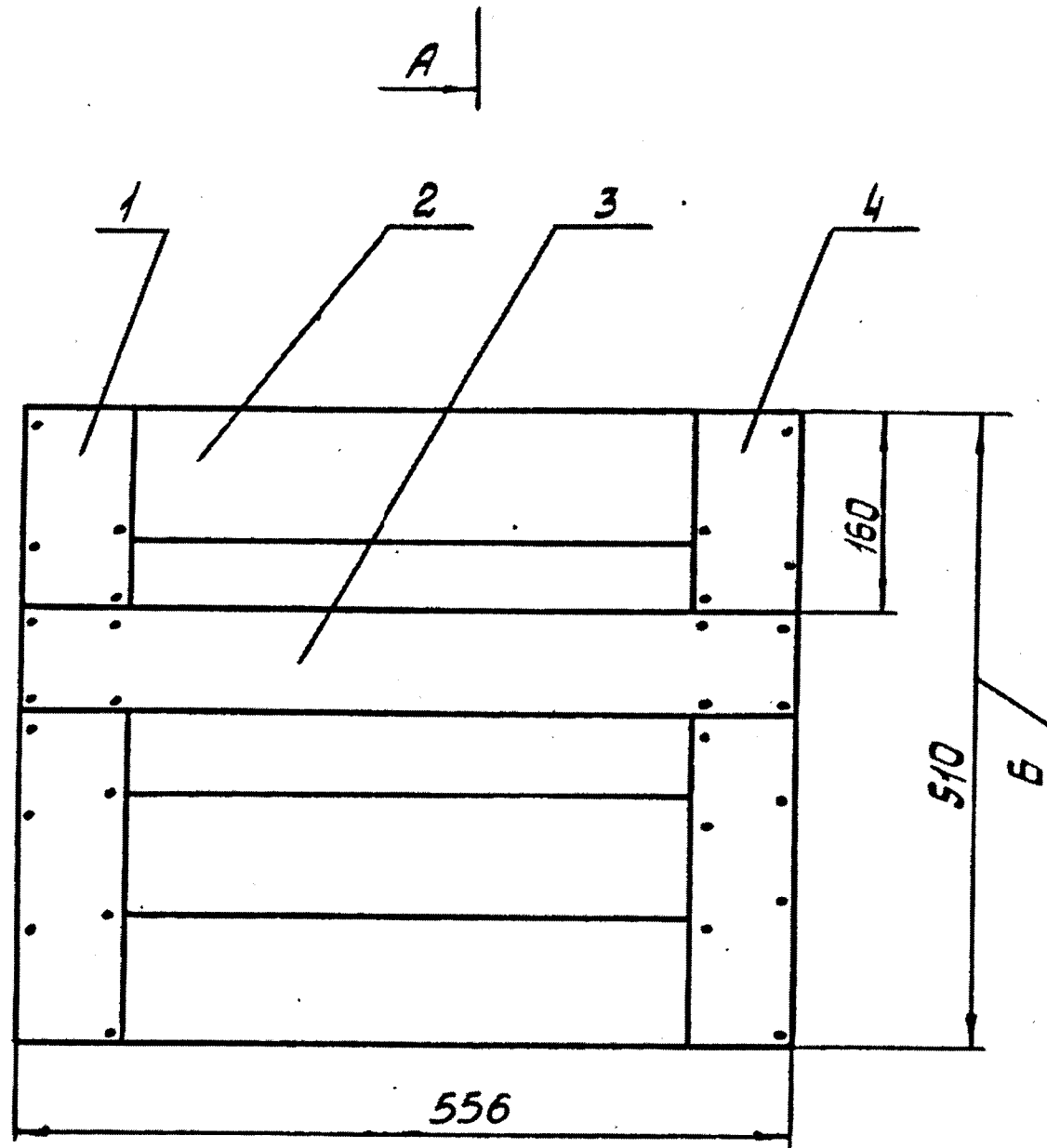
Rz 500/√(√)

1. Joining of boards in ¼ K-2 as per GOST 9330-76.
2. Maximum deviation of dimensions as per standard accuracy class GOST 6449-5-82
3. For special supply the boards should be made from edged board, without waness, dressed, holes due to knots not permissible.
4. It is permissible to make size Б from boards 2 Khv-25 GOST 8486-86 of different width if they are not less than 70 mm.
5. Absence of localized dressing in shape from each side in area not exceeding 20% , depth up to 1 mm is permissible.  
Surface finish  $Rz 1200\sqrt{\quad}$ .

					AK-630-Ya Sb 200-3-1 TR SB			
Amend.	Sheet	Doc.No.	Sign	Date	Upper cover Assembly drawing	Type	Weight	Scale
Developed by						A	12	1:10
Checked by								
Head of Q.C.D								
Approved by								
						Sheets 1		

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					Documents			
	A3	/		AK-630-Ya Sb 200-3-2TR SB	Assembly drawing			
					Components			
	WD	/	1	AK-630-Ya 200-3-6TR	Board-2 Khv-25 x 100 GOST 8486-86 L = 510 ± 5	2		
	WD	/	2	AK-630-Ya 200-3-7TR	Board-2 Khv-25 x 100 GOST 8486-86 L = 560 ± 5	6		
	WD	/	3	AK-630-Ya 200-3-8TR	Board-2 Khv-25 x 100 GOST 8486-86 L = 560 ± 5	1		
					Standard articles			
			4		Nails K 2.5x60 GOST 4028-63	20		
			5		Nails K 3x70 GOST 4028-63	8		
Sign and								
	Dupl. Inv. No.							
Alternate Inv. No.								
Date								
	<b>AK-630-Ya Sb 200-3-2 TR</b>							
Sign	Amend.	Sheet	Doc. No.	Sign	Date			
	Developed by					Type	Sheet	Sheets
Orig. Inv. No.	Checked by					A		1
	Head of Q.C.D							
	Approved by							
						<b>Face wall</b>		

Rz 500/ (✓)



1. Joining of boards in ¼ K-2 as per GOST 9330-76.
2. Maximum deviation of dimensions as per standard accuracy class GOST 6449-5-82
3. For special supply the boards should be made from edged board, without waness, dressed, holes due to knots not permissible.
4. It is permissible to make size B from boards 2 Khv-25 GOST 8486-86 of different width if they are not less than 70 mm.
5. Absence of localized dressing in shape from each side in area not exceeding 20% , depth up to 1 mm is permissible.  
Surface finish  $Rz 1200\sqrt{}$ .

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 Sb 200-3-2 TR SB

Face wall  
Assembly drawing

Type	Weight	Scale
A	4.8	1:5
Sheets		1



First use

Reference No.

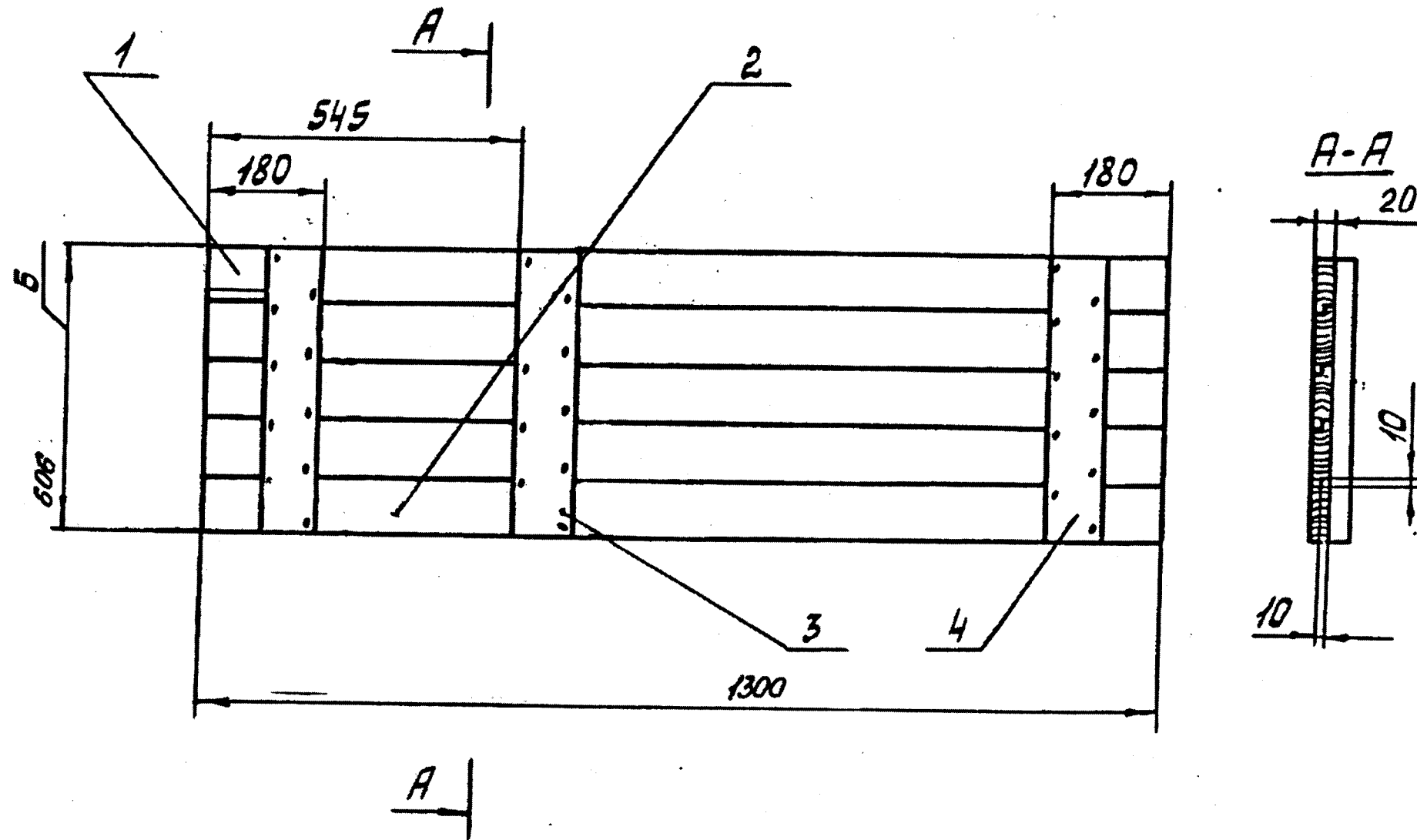
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz 500  
(V)

1. Joining of boards in ¼ K-2 as per GOST 9330-76.
2. Maximum deviation of dimensions as per standard accuracy class GOST 6449-5-82
3. For special supply the boards should be made from edged board, without waness, dressed, holes due to knots not permissible.
4. It is permissible to make size B from boards 2 Khv-25 GOST 8486-86 of different width if they are not less than 70 mm.
5. Absence of localized dressing in shape from each side in area not exceeding 20% , depth up to 1 mm is permissible.  
Surface finish Rz 1200√.

Amend.	Sheet	Doc.No.	Sign	Date

AK-630-Ya Sb 200-3-3 TR SB			
Type	Weight	Scale	
		A	12
Bottom Assembly drawing		Sheets 1	

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
Reference No.					Documents		
	A3	/		AK-630-Ya Sb 200-3-4TR SB	Assembly drawing		
					Components		
	WD	/	1	AK-630-Ya 200-3-12TR	Board-2 Khv-25 x 100 GOST 8486-86 L = 610 ± 5	3	
	WD	/	2	AK-630-Ya 200-3-13TR	Board-2 Khv-25 x 100 GOST 8486-86 L = 1300 ± 5	6	
					Standard article		
Sign and			3		Nails K 2.5x60 GOST 4028-63	30	
Dupl. Inv. No.							
Alternate Inv. No.							
Sign and Date					<b>AK-630-Ya Sb 200-3-4 TR</b>		
	Amend.	Sheet	Doc. No.	Sign	Date		
Orig. Inv. No.	Developed by				Type		
	Checked by				Sheet		
					A		
	Head of Q.C.D				Sheets		
Approved by				<b>Side wall</b>			1

First use

Reference No.

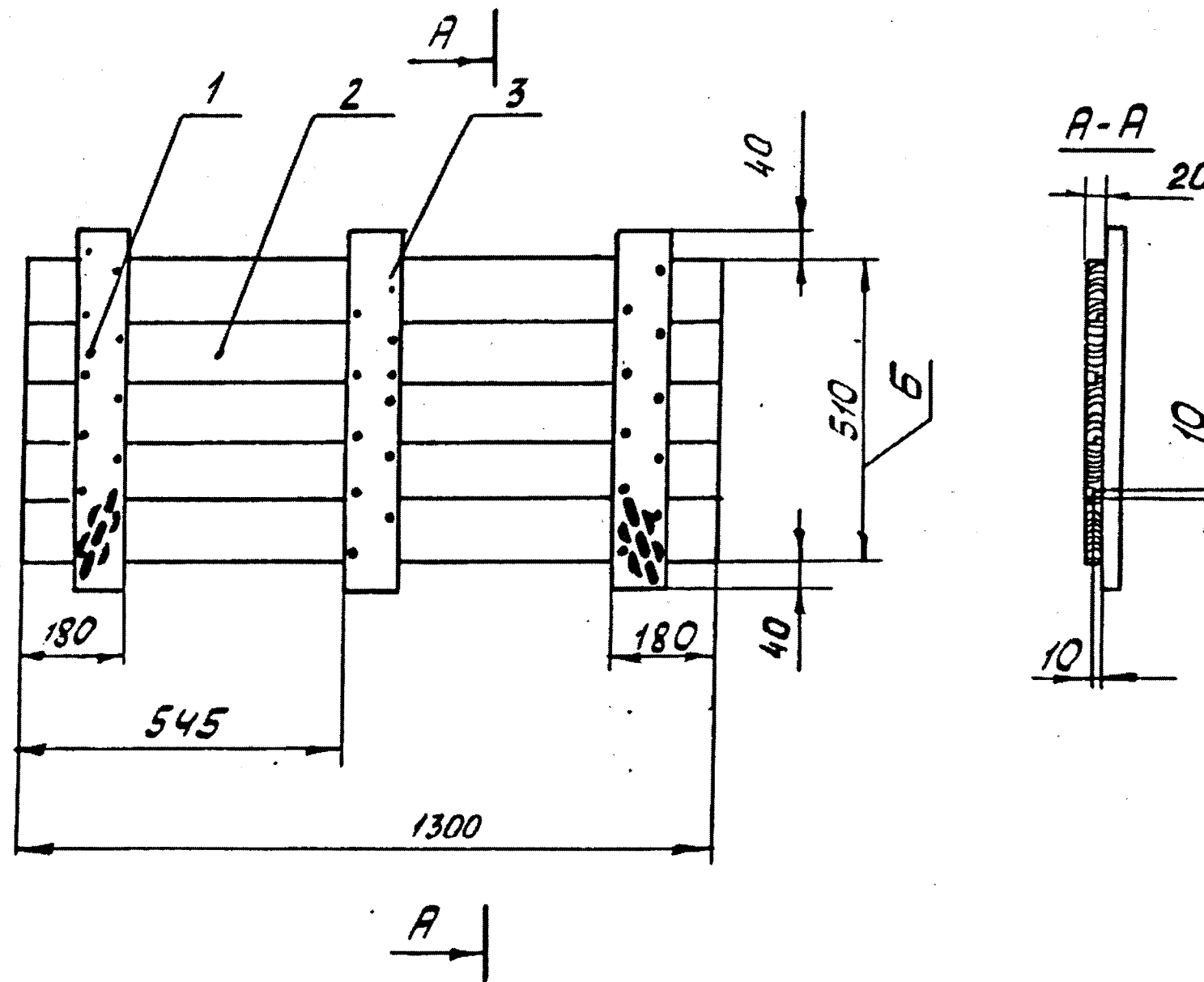
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz 500/ (✓)

1. Joining of boards in ¼ K-2 as per GOST 9330-76.
2. Maximum deviation of dimensions as per standard accuracy class GOST 6449-5-82
3. For special supply the boards should be made from edged board, without waness, dressed, holes due to knots not permissible.
4. It is permissible to make size Б from boards 2 Khv-25 GOST 8486-86 of different width if they are not less than 70 mm.
5. Absence of localized dressing in shape from each side in area not exceeding 20% , depth up to 1 mm is permissible.  
Surface finish  $Rz 1200 \checkmark$ .

					AK-630-Ya Sb 200-3-4 TR SB			
Amend.	Sheet	Doc.No.	Sign	Date	Side wall Assembly drawing	Type	Weight	Scale
Developed by						A	12	1:10
Checked by						Sheets 1		
Head of Q.C.D								
Approved by								