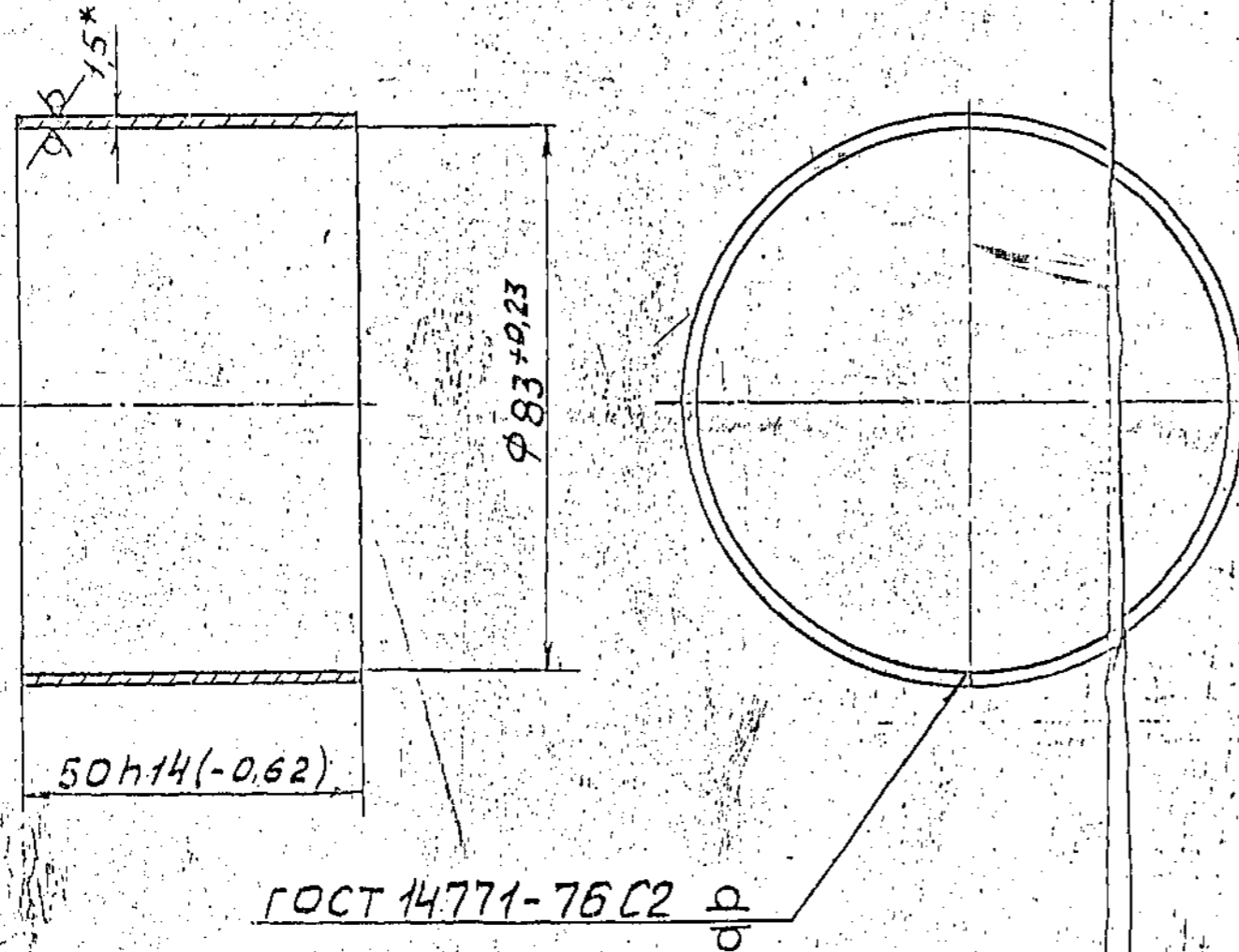


ЕСКА



(A) EQUIVALENT MATERIAL
04Cr.18Ni.10Ti.20 TOIS.6911 72

1. Заменитель материала сталь 12X18H10T-M3a ГОСТ 5582-75.
2. Трещины, рванины, расслоения и вмятины не допускаются.
- 3.* Размер для справок.

- 1) ALTERNATE MATERIAL: STEEL 12X18H10T M3a GOST 5582-75.
- 2) CRACKS, TEARS LAMINATION AND DENTS ARE NOT ALLOWED.
- 3) * DIMENSIONS FOR REFERENCE.

** SHEET 6-1,5 GOST 19904-74
12X18H10T-M2a GOST 5582-75

Ил. № подл. 36981 | Пост. в латы 4.12.85 | Ил. № подл. Пост. в латы 4.12.85
 Дwg. INDIANISED BASED ON RUSSIAN - ORIGINAL ISSUE (BK 84-824)

PILOT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

		EST. MASS 0,155 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)
A	28.8.10	4 th Alt Comm Mtg Minutes Point No.16 Dt. 26.10.09	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R. OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL: ** SEE ABOVE	USED ON:
DRN <i>[Signature]</i>	SCALE: 1:1	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A D I	
CHD <i>[Signature]</i>	DIMENSIONS IN mm	TITLE: BUSHING	
YCD <i>[Signature]</i>	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	
APPD <i>[Signature]</i>	ALL THREADS TO CONFORM TO	DRAWING NUMBER 418-85-5	

406 - BK84-824

DRAWING NUMBER

418-86

Rz320
✓ (✓)

EXPLANATORY NOTE :

5. REFERENCE MATERIAL QUOTED:

HOT ROLLED SHEET STEEL, INCREASED ACCURACY ON ROLLING ON 'A' 3mm THICK TO GOST 19903-74, ORDINARY SURFACE FINISH TO GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH QUALITY CARBON STRUCTURAL STEEL GRADE 10, AND REFERENCE NOTE '1', ON ALTERNATE MATERIAL STEEL GRADE 20 TO GOST 1050-74.

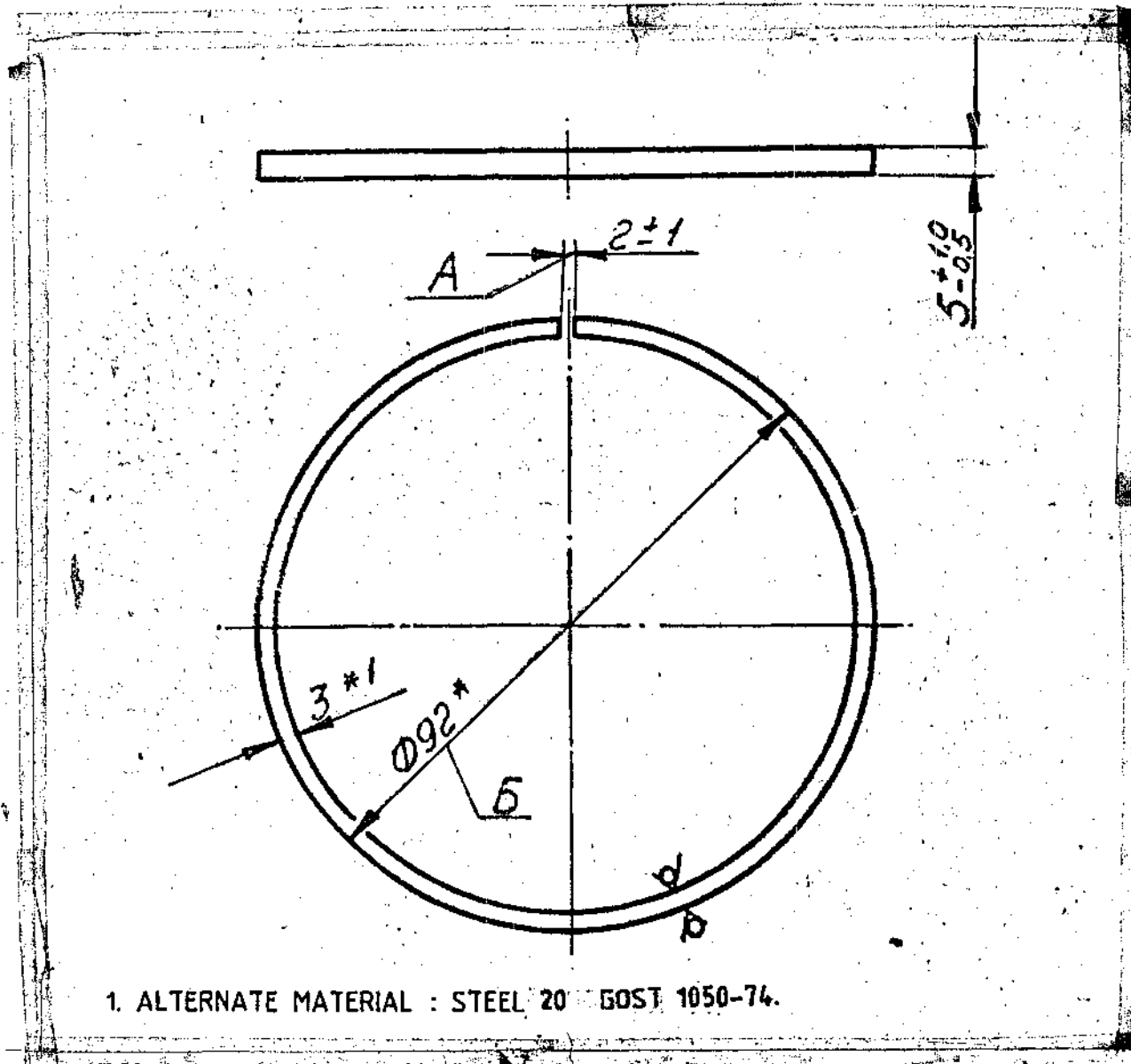
a) CHEMICAL COMPOSITION AS PER GOST 1050-74.

GRADE OF STEEL	CONTENT OF ELEMENTS %					REMARKS	
	C	Si	Mn	Cr	S		P
10	0.07 0.14	0.17 0.37	0.35 0.65	0.15	0.040	0.035	REFERENCE MATERIAL
20	0.17 0.24	0.17 0.37	0.35 0.65	0.25	0.040	0.035	ALTERNATE MATERIAL

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

b) MECHANICAL PROPERTIES AS PER GOST 16523-70

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kg/mm ²	RELATIVE ELONGATION %	REMARKS
10	30-42	26	Ref.Matl.
20	36-51	23	Alt.Matl.



1. ALTERNATE MATERIAL : STEEL 20 GOST 1050-74.

2. * DIMENSION IS TO BE ENSURED WITH TOOL.

3. *1 DIMENSION FOR REFERENCE.

4. DIMENSION 'A' IS TO BE CHECKED ON MANDRAL DIA 'B'.

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

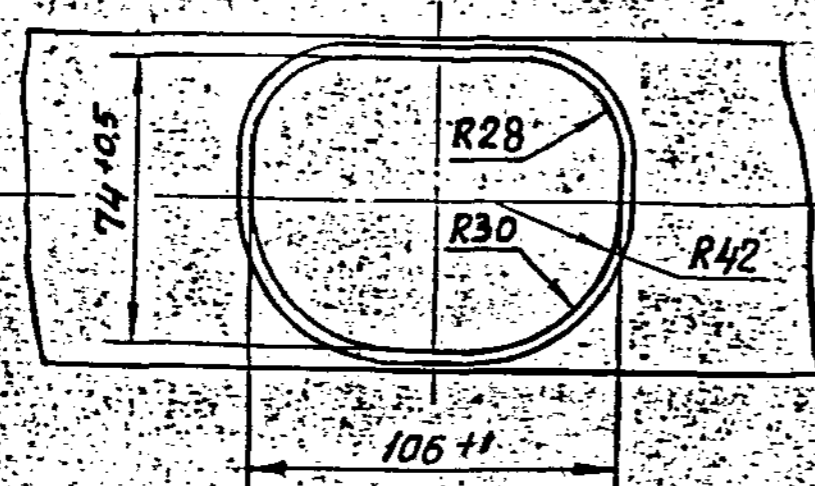
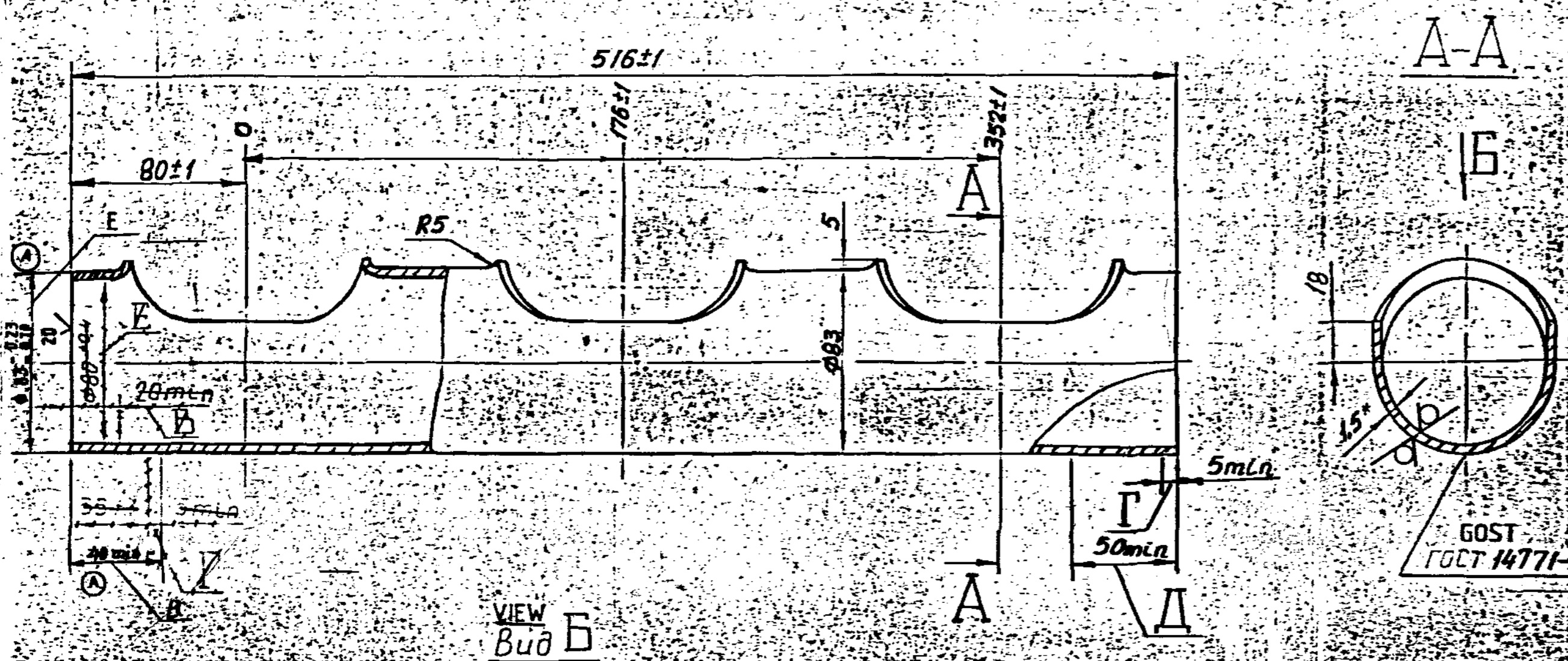
EST WT
0.038 Kg

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	<i>[Signature]</i>	MATERIAL:	USED ON:
CHD	<i>[Signature]</i>	SHEET A3 GOST 19903-74	CB 418-50-29
TCO	<i>[Signature]</i>	10 GOST 16523-70	CB 418-51-29
APPD	<i>[Signature]</i>	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)	
DATE	26-2-'86	AVADI	
SCALE: 1 : 1		TITLE:	RING
DIMENSIONS IN mm			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69		D S CAT NUMBER	DRAWING NUMBER
ALL THREADS TO CONFORM TO			
ISSUE	DATE	NATURE OF AMENDMENTS	

SIZE A3



EXPLANATORY NOTE :-

MATERIAL QUOTED : SHEET B 1.5 GOST 19904-74
12X18H10T-M2a GOST 5582-75

B = STANDARD ACCURACY.
1.5 = THICKNESS OF COLD ROLLED SHEET STEEL AS PER GOST 19904-74.
12X18H10T = GRADE OF STEEL.
M2a = PICKLED OR BRIGHT ANNEALED.

CHEMICAL COMPOSITION % (AS PER GOST 5632-72)
CARBON = 0.12 (MAX); SILICON = 0.8 (MAX); MANGANESE = 2.0 (MAX);
CHROMIUM = 17.0-19.0; NICKEL = 9.0-11.0; TITANIUM = 0.6-0.8

MECHANICAL PROPERTIES (AS PER GOST 5582-75)

HEAT TREATMENT
TEMPERING : AT 1050 TO 1080 °C
COOLING IN WATER OR IN AIR.
ULTIMATE STRENGTH kgf/mm^2 (MIN) = 54
YIELD POINT kgf/mm^2 (MIN) = 20
RELATIVE ELONGATION (MIN) = 40

TECHNICAL REQUIREMENTS- TRANSLATED.

1. Unspecified limit deviations of dimensions for cold stamping should be obtained upto 80 mm ± 0.5 above 80 mm upto 200 mm ± 1mm.
2. Cracks, fissures, laminations and dents are not allowed.
3. On section B to be calibrated upto dimension E.
4. Surface of welds along the external diameter on section Γ and along the internal diameter on section B should be dressed flush.
5. Up to two metal ruptures per flange are allowed with subsequent electric welding and with the dressing at the base of ruptures.
6. Welding on the inner side is allowed on Section A and B.
7. Pipe ovality except sections B and F is up to 4mm.
8. Alternative material : STEEL 12 X 18 H 10 T- M3a. GOST 5582-75.
9. * Dimension for reference.

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

EST. WT. 1.265 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.	

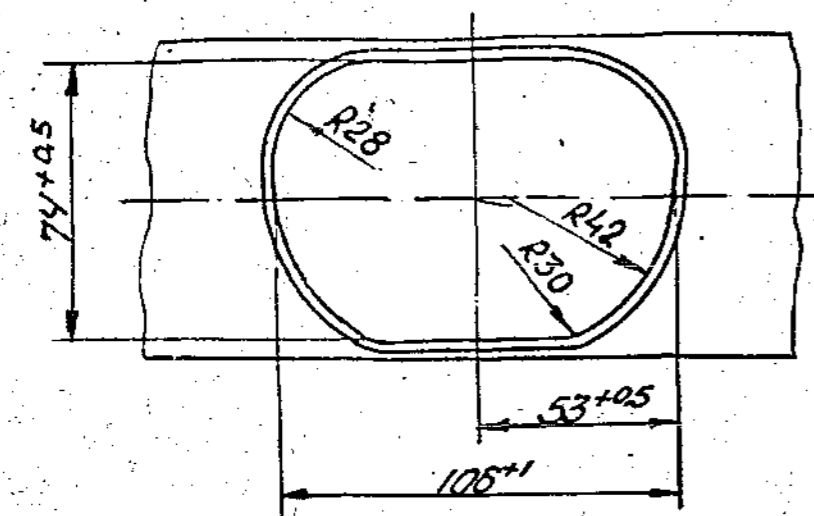
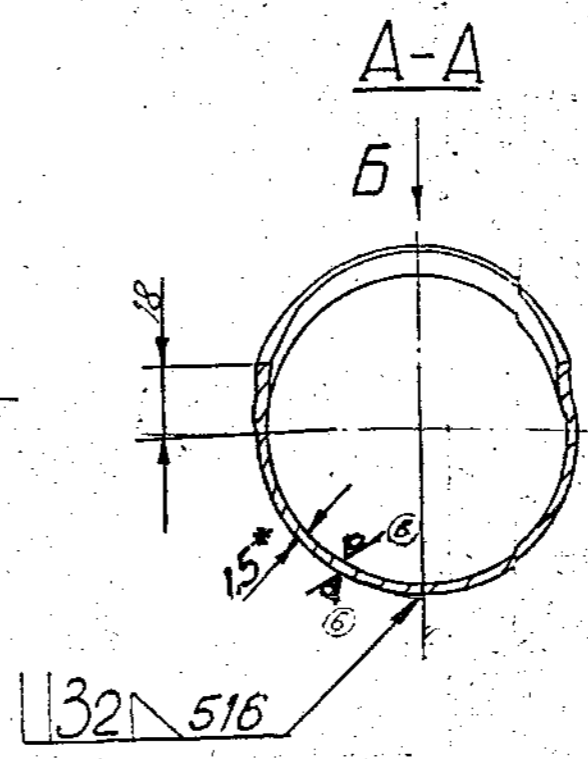
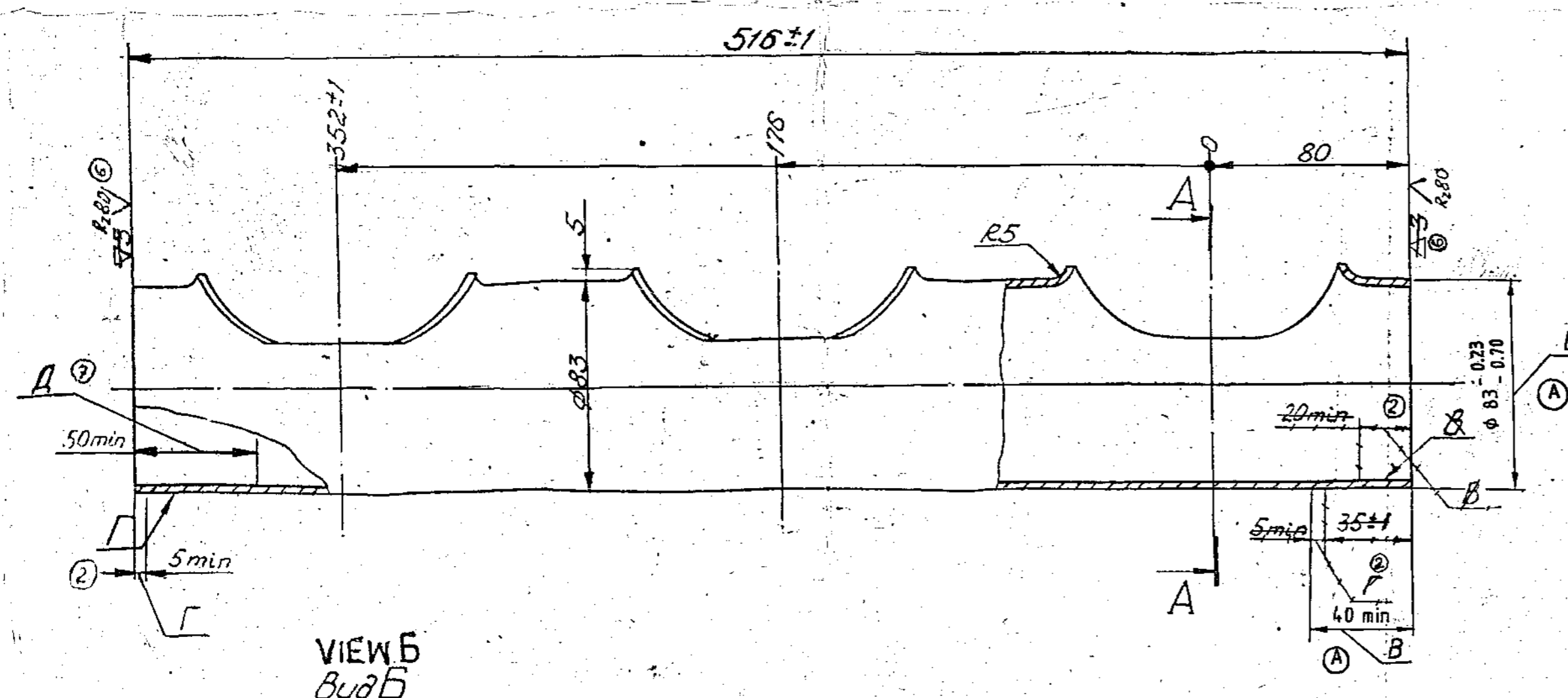
DRN	---	MATERIAL - SHEET	USED ON :-
CHD	Red	B 1.5 GOST 19904-74	CB 418-50-29
TCD	V. Mani	12X18H10T M2a GOST 5582-75	
APPD	---	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	29-1-88	A V A D I	
SCALE	1:2	TITLE	
DIMENSIONS IN mm.		PROTECTIVE PIPE, L.H.	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69		D S CAT NUMBER	
ALL THREADS TO CONFORM TO		DRAWING NUMBER	
A	26-10-88	418-90-5	
ISSUE	DATE	NATURE OF AMENDMENTS	

EXPLANATORY NOTE ADDED ON 18-2-92



DRAWING NUMBER
418-90-7

Rz320
✓(M)



EXPLANATORY NOTE

10. REFERENCE MATERIAL QUOTED :
COLD ROLLED SHEET STEEL, STANDARD ACCURACY B, 1.5mm THICK TO GOST 19904-74, QUALITY ON SURFACE HEAT TREATED PICKLED TO M2a OR M3a TO GOST 5582-75 AND MANUFACTURED IN ACCORDANCE WITH HEAT RESISTING STEEL ALLOY OF GRADE 12X18H10T GOST 5632-72.

a) CHEMICAL COMPOSITION AS PER GOST 5632-72.

Gde. OF STEEL	CONTENT OF ELEMENTS %								
	C	Si	Mn	Cr	Ni	T	Fe	S	P
12X18H10T	M A X								
	0.12	0.8	2.0	17.0-19.0	9.0-11.0	5.0-0.8	Base	0.020	0.035

b) MECHANICAL PROPERTIES AS PER GOST 5582-75
SUPPLY CONDITION- COLD HARDENED
ULTIMATE TENSILE STRENGTH- 90 -110 Kgf/mm²
% ELONGATION - 10 Min.

1. CRACKS,FISSURES,LAMINATIONS,DENTS AND BURRS ARE NOT ALLOWED.
2. DIMENSIONS WITH UNSPECIFIED DEVIATIONS FOR COLD STAMPING SHOULD BE OBTAINED WITH TOLERANCE ±0.5mm.DIMENSIONS LESS THAN 80mm. AND WITH TOLERANCES ±1mm. FOR DIMENSIONS FROM 80mm TO 200mm.
3. THE PIPE SHOULD BE MACHINED TO DIAMETER=80As(+0,4) ON SECTION 'B' ON A LENGTH OF 20mm. FROM THE EDGE.
4. WELDS SHOULD BE DONE ARGON ARC WELDING OR BY CO₂ SHIELDED ARC WELDING WITH WIRE CB 08X20H9I 7T OR Cb 06X19H10T GOST 2246-70.
5. SURFACE OF WELDS ALONG THE EXTERNAL DIAMETER SHOULD BE DRESSED . FLUSH ON SECTIONS 'Г' AND ALONG THE INTERNAL DIAMETER ON SECTION 'Б'.
6. UPTO 2 METAL RUPTURES PER FLANGE ARE ALLOWED WITH SUBSEQUENT ELECTRIC WELDING AND WITH DRESSING AT THE BASE OF RUPTURES.
7. *DIMENSION FOR REFERENCE.
8. PIPE OVALITY EXCEPT SECTIONS 'Б' AND 'Г' SHOULD NOT EXCEED 4mm.
9. WELDING ON THE INNER SIDE IS ALLOWED ON SECTION

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

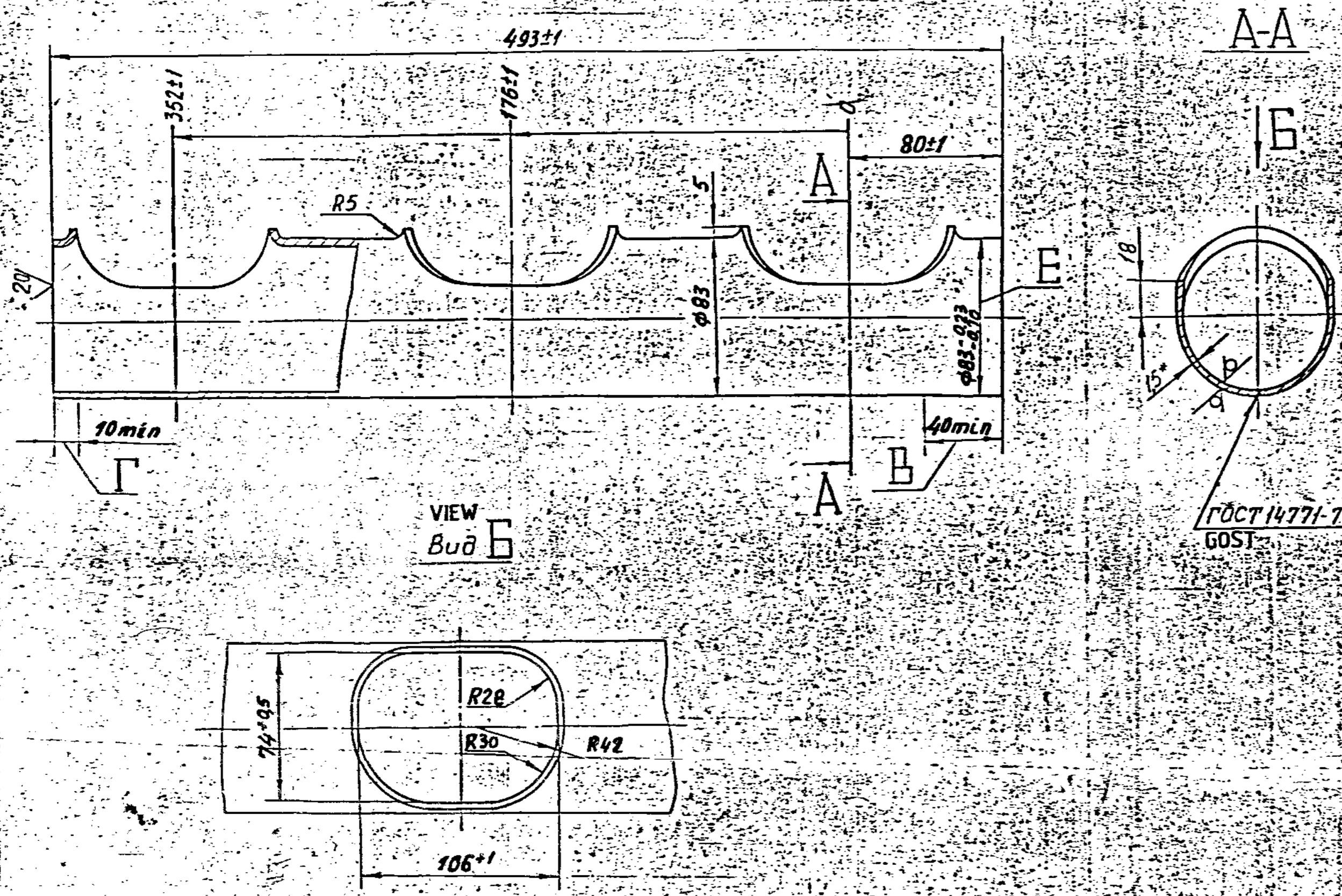
EST WT 1.265 Kg.	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	

*** GOST 5582-75

DRN CHD TCD APPD DATE SCALE DIMENSIONS IN mm TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69	<i>[Signature]</i> <i>[Signature]</i> <i>[Signature]</i> 26-2-86 1 : 2	MATERIAL SHEET 615 GOST19904-74 12X18H10T M2a OR M3a ***	USED ON CB 418-51-29
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES AVADI)		TITLE PROTECTIVE PIPE R.H.	
D S CAT NUMBER		DRAWING NUMBER 418-90-7	
ISSUE A	DATE 26.10.88	NATURE OF AMENDMENTS AUTHY BK 84 - 824	

DRAWING NUMBER
418-91-5

80/100



EXPLANATORY NOTE :-

MATERIAL QUOTED : SHEET Б 1.5 GOST 19904-74
12X18H10T-M2a GOST 5582-75

Б = STANDARD ACCURACY.
1.5 = THICKNESS OF COLD ROLLED SHEET STEEL AS PER GOST 19904-74.
12X18H10T = GRADE OF STEEL.
M2a = PICKLED OR BRIGHT ANNEALED.

CHEMICAL COMPOSITION % (AS PER GOST 5632-72)
CARBON = 0.12 (MAX) ; SILICON = 0.8 (MAX) ; MANGANESE = 2.0 (MAX) ;
CHROMIUM = 17.0-19.0 ; NICKEL = 9.0-11.0 ; TITANIUM = 0.6-0.8

MECHANICAL PROPERTIES (AS PER GOST 5582-75)

HEAT TREATMENT
TEMPERING AT 1050 TO 1080 °C
COOLING IN WATER OR IN AIR.
ULTIMATE STRENGTH Kgf/mm^2 (MIN) = 54
YIELD POINT Kgf/mm^2 (MIN) = 20
RELATIVE ELONGATION (MIN) = 40

TECHNICAL REQUIREMENTS - TRANSLATED.

1. Unspecified limit deviations of dimensions for cold stamping should be obtained upto $80 \text{ mm} \pm 0.5$ above 80 mm upto 200 mm $\pm 1 \text{ mm}$.
2. Cracks, fissures, laminations and dents are not allowed.
3. On section B, to be calibrated upto dimension E.
4. Surface of welds along the external diameter on sections B and Γ should be dressed flush.
5. Not more than 2 metal ruptures per flange are allowed with subsequent electric welding and with dressing at the base of ruptures.
6. Welding of both the ends of pipe on section $50-60 \text{ mm}$ is allowed.
7. Pipe ovality except section B and Γ is up to 4 mm.
8. Alternate material STEEL 12 X 18 H 10 T - M3a, GOST 5582-75.
9. * Dimension for reference.

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

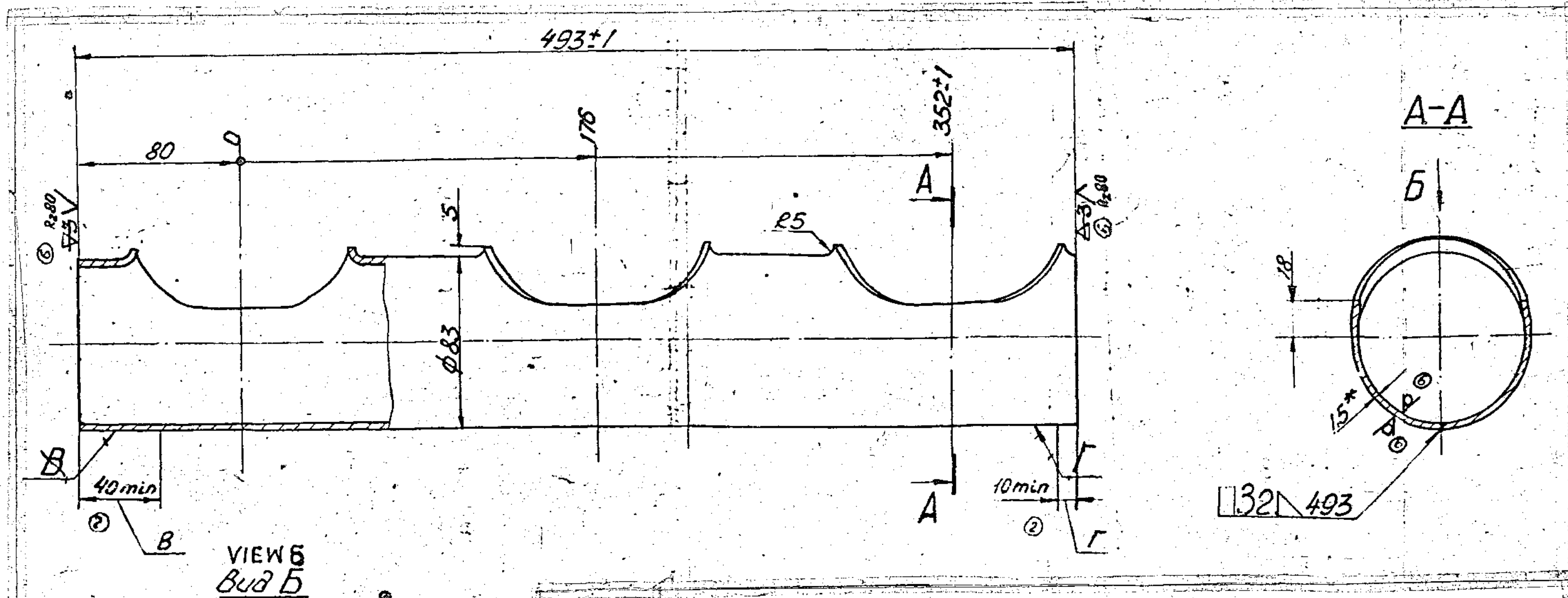
EST. WT. 1.22 kg. TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	TCO	APPD	DATE	SCALE	DIMENSIONS IN mm.	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	ALL THREADS TO CONFORM TO
				29-1-88	- 1:2			
MATERIAL - SHEET					USED ON -			
61.5 GOST 19904-74					C6 418-50-29			
12X18H10T M2a GOST 5582-75					CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)			
					A V A D I			
							TITLE	
							PROTECTIVE PIPE L.H.	
ISSUE					DATE		NATURE OF AMENDMENTS	
							D S CAT NUMBER	
							DRAWING NUMBER	
							418-91-5	

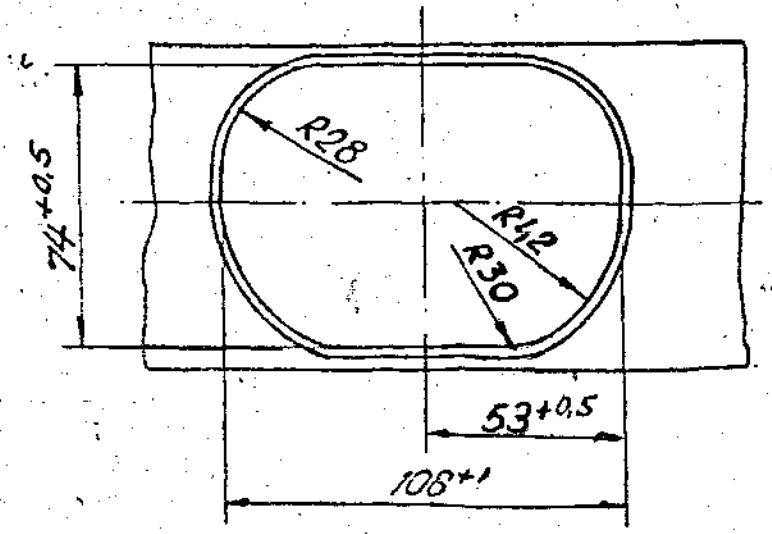
DRAWING CREATED BASED ON RUSSIAN ORIGINAL ISSUE 8 (8X 81-31)
EXPLANATORY NOTE ADDED ON 18-2-92

Rz320
✓(✓)



1. CRACKS, FISSURES, LAMINATIONS, DENTS AND BURRS ARE NOT ALLOWED.
2. DIMENSION WITH UNSPECIFIED DEVIATIONS FOR COLD STAMPING SHOULD BE DONE WITH TOLERANCE $\pm 0.5\text{mm}$ FOR DIMENSIONS LESS THAN 80mm AND WITH TOLERANCE $\pm 1\text{mm}$ FOR DIMENSIONS FROM 80mm UP TO 200mm.
3. THE PIPE SHOULD BE MACHINED TO DIAMETER $83 \times 5_{-0.23}^{+0.70}$ ON SECTION 'B' FROM THE EDGE.
4. WELDS SHOULD BE DONE BY ARGON-ARC WELDING OR BY CO₂ SHIELDED ARC WELDING WITH WIRE C6-08X20H9/7T OR C6-06X19H1-07 GOST 2246-70.
5. SURFACE OF WELDS ALONG THE EXTERNAL DIAMETER SHOULD BE DRESSED FLUSH ON SECTIONS 'B' AND 'A'.
6. UP-TO 2 RUPTURES PER FLANGE ARE ALLOWED. METAL WITH SUBSEQUENT ELECTRIC WELDING AND WITH DRESSING AT THE BASE OF RUPTURES.
7. * DIMENSION FOR REFERENCE.
8. PIPE OVALITY EXCEPT SECTIONS 'B' AND 'A' SHOULD NOT EXCEED 4 mm.
9. IT IS ALLOWED TO WELD BOTH ENDS OF PIPE ON THE INNER SIDE ON 'A' SECTION OF 50 TO 60mm.

VIEW B
Вид Б



EXPLANATORY NOTE

10. REFERENCE MATERIAL QUOTED :

COLD ROLLED SHEET STEEL, STANDARD ACCURACY B, 1.5mm THICK TO GOST 19904-74, QUALITY ON SURFACE HEAT TREATED PICKLED TO M2a OR M3a TO GOST 5582-75 AND MANUFACTURED IN ACCORDANCE WITH HEAT RESISTING STEEL ALLOY OF GRADE 12X18H10T GOST 5632-72.

a) CHEMICAL COMPOSITION AS PER GOST 5632-72.

Gde. OF STEEL	CONTENT OF ELEMENTS %									
	C	Si	Mn	Cr	Ni	T	Fe	S	P	
12X18H10T	M A X			17.0-19.0	9.0-11.0	5.0-0.8	Base	M A X		
	0.12	0.8	2.0					0.020	0.035	

b) MECHANICAL PROPERTIES AS PER GOST 5582-75

SUPPLY CONDITION- COLD HARDENED
 ULTIMATE TENSILE STRENGTH- 90 -110 Kgf/mm²
 % ELONGATION - 10 Min.

** GOST 5582-75.

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

EST WT 1.22 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	<i>As Blended</i>	MATERIAL:	SHEET B1.5 GOST 19904-74	USED ON	C6 418-51-29
CHD	<i>DoE</i>	TCD	12X18H10T-M2a OR M3a **	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APPD	<i>Kon'lon</i>	DATE	<i>24-2-86</i>	TITLE:	
SCALE: 1 : 2			DIMENSIONS IN mm		
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69			DRAWING NUMBER		
ALL THREADS TO CONFORM TO			D'S CAT NUMBER		
ISSUE	DATE	NATURE OF AMENDMENTS			

PROTECTIVE PIPE, R.H

DRAWING NUMBER
418-91-7

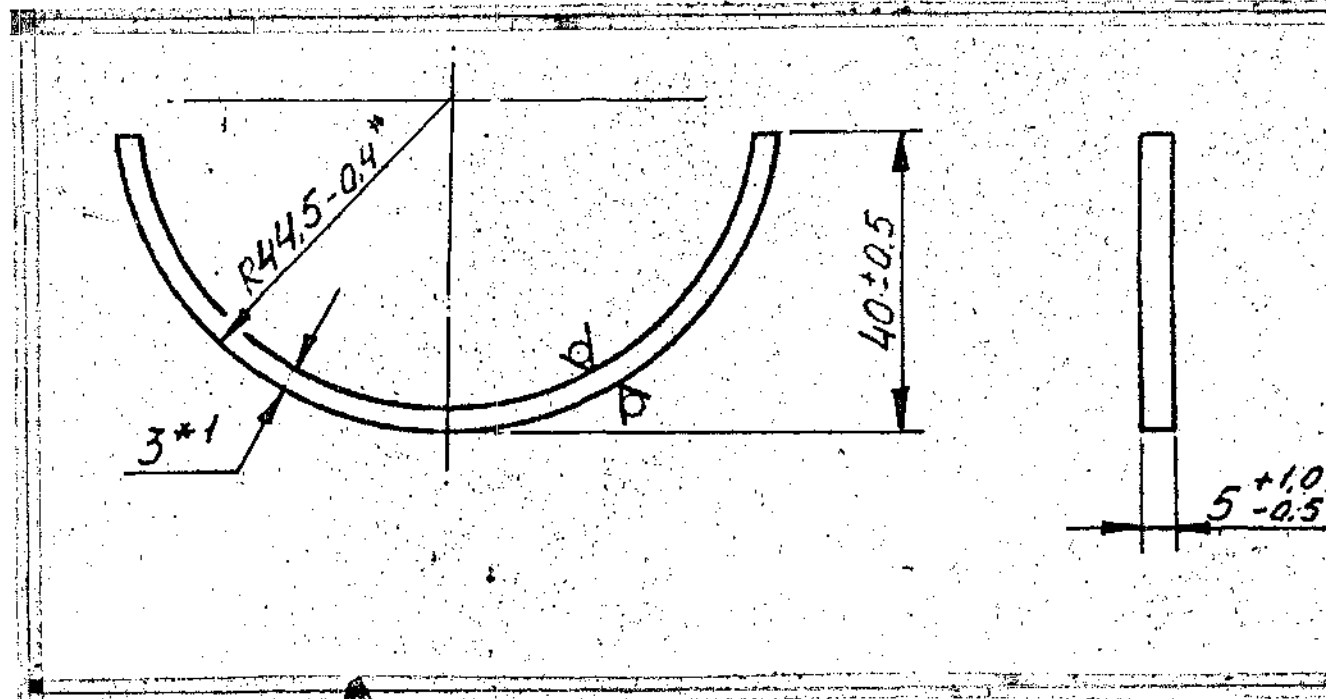
DRAWING NUMBER
418-101

EXPLANATORY NOTE :

4) REFERENCE MATERIAL QUOTED:

HOT ROLLED SHEET STEEL INCREASED ACCURACY ON ROLLING ON 'A' 3mm THICK TO GOST 19903-74, ORDINARY SURFACE FINISH TO GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH QUALITY CARBON STRUCTURAL STEEL GRADE 10, AND REFERENCE NOTE 1. ON ALTERNATE STEEL GRADES 20, 08Kn, 10Kn, GOST 1050-74.

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



GRADE OF STEEL	CONTENT OF ELEMENTS %						REMARKS
	C	Si	Mn	Cr	S	P	
10	0.07 0.14	0.17 0.37	0.35 0.65	0.15	0.040	0.035	Ref. Matl
20	0.17 0.24	0.17 0.37	0.35 0.65	0.25	0.040	0.035	Ref. Matl
08 Kn HOT ROLLED STEEL	0.05 0.11	0.03 MAX	0.25 0.50	0.10	0.040	0.035	Ref. Matl
10 Kn HOT ROLLED STEEL	0.07 0.14	0.07 MAX	0.25 0.50	0.15	0.040	0.035	Ref. Matl

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

b) MECHANICAL PROPERTIES AS PER GOST 16523-70.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	RELATIVE ELONGATION %	REMARKS
10	30-42	26	Ref. Matl.
20	36-51	23	Alt. Matl.
08Kn	27-39	28	Alt. Matl.
10Kn	28-40	26	Alt. Matl.

- ALTERNATE MATERIAL: STEEL GRADES 20, 08Kn, 10Kn GOST 1050-74.
- * DIMENSION IS TO BE ENSURED WITH TOOL.
- *1 DIMENSION FOR REFERENCE.

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

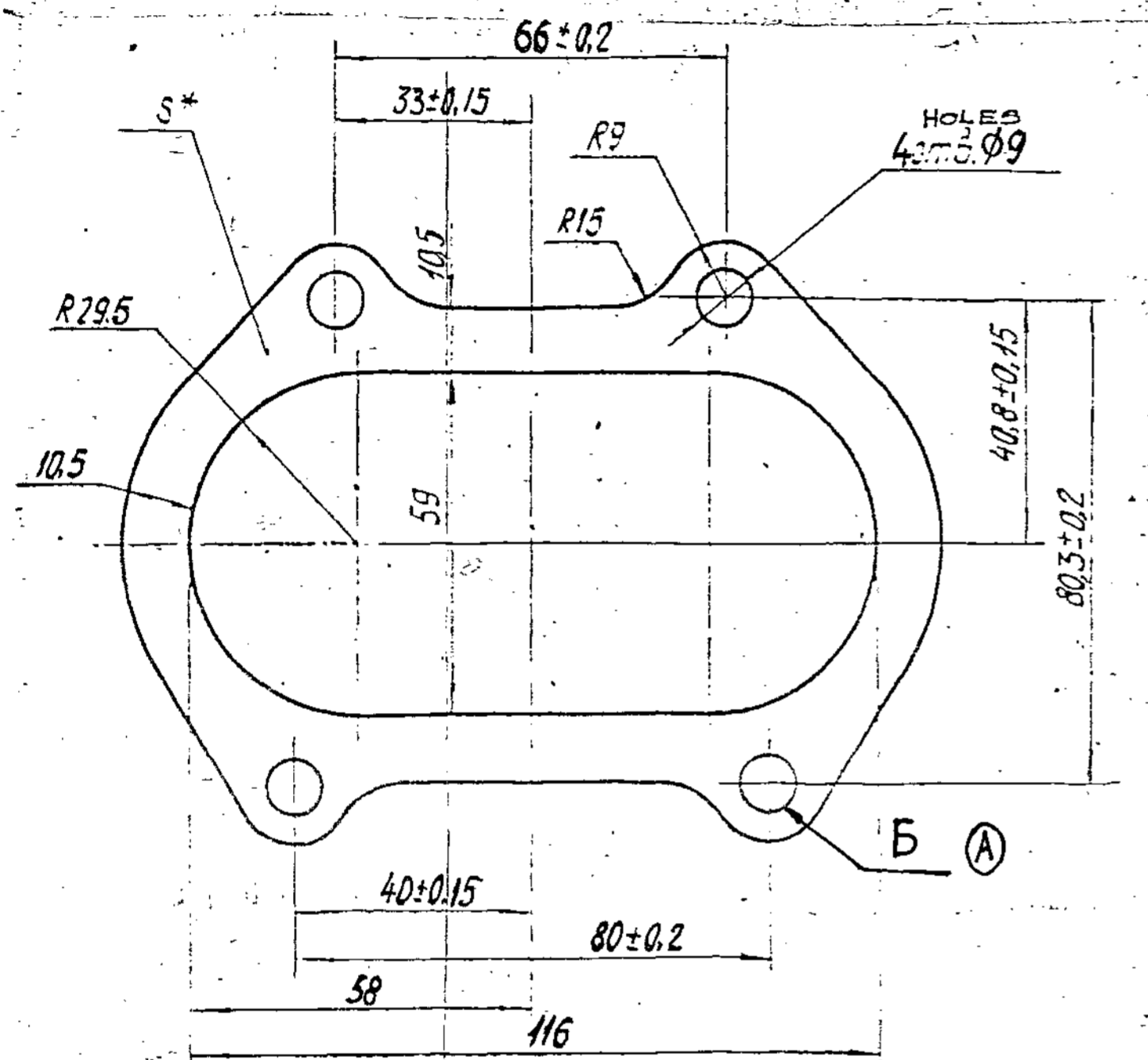
EST WT 0.015 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS II (LETTERS)

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	<i>[Signature]</i>	MATERIAL:	A3 GOST 19903-74	USED ON:	CB 418-50-29
CHD	<i>[Signature]</i>	SHEET	10 GOST 16523-70		CB 418-51-29
TCD	<i>[Signature]</i>	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI			
APPD	<i>[Signature]</i>				
DATE	26.2.86	TITLE: SEMI RING			
SCALE:	1 : 1				
DIMENSIONS IN mm		D S CAT NUMBER		DRAWING NUMBER 418-101	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69					
ALL THREADS TO CONFORM TO					
ISSUE	DATE	NATURE OF AMENDMENTS			

DRAWING NUMBER

3306-99



DIMENSIONS IN mm
РАЗМЕРЫ в мм

S*	Пределы TOLERANCE отклонения	Вес WEIGHT кг
0.25	-0.04	0.0075
0.28	-0.04	0.0084
0.30	-0.04	0.009
0.35	-0.04	0.0105

1. Заменитель материала лента ДПРМТ НД-М3 ГОСТ 1173-77.
2. Неуказанные предельные отклонения размеров ±0.5 мм.
3. * Размер для справок.

1. ALTERNATE MATERIAL: STRIP ДПРМТ НД-М3 ГОСТ 1173-77
2. UNSPECIFIED TOLERANCES FOR DIMENSIONS ±0.5mm
3. * DIMENSION FOR REFERENCE.

(A) HOLES B AND EXTERNAL OUTLINE ARE ALLOWED TO BE MADE WHEN ASSEMBLED.

EXPLANATORY NOTE:-

THE COMPONENT SHOULD BE MANUFACTURED FROM FIRE REFINED COPPER-STRIP COLD ROLLED (A) RECTANGULAR SECTION (RP), TOLERANCE ON THICKNESS 0.04mm SPECIFIED IN TABLE COLUMN ON DRAWING AS PER NORMAL ACCURACY (H) NON STANDARD LENGTH (HA) COPPER GRADE M3 TO GOST 1173-77. ALTERNATIVELY THE SUBJECT ITEM MAY BE PRODUCED FROM FIRE REFINED COPPER-STRIP COLD-ROLLED (A) RECTANGULAR SECTION (RP), HARD (T), NON STANDARD LENGTH (HA) TO GOST 1173-77. CHEMICAL COMPOSITION SHOULD BE AS PER GOST 859-78 AND MECHANICAL PROPERTIES AS PER GOST 1173-77 ARE AS UNDER.

CHEMICAL COMPOSITION%:- AS PER GOST 859-78.

MANUFACTURING METHOD	GRADE OF COPPER	Cu+Ag NOT LESS THAN	IMPURITIES NOT MORE THAN										
			Bi	Sb	As	Fe	Ni	Pb	Sn	S	O	Zn	P
FIRE REFINED	M3	99.5	0.003	0.05	0.01	0.05	0.20	0.05	0.05	0.01	0.08	-	-

MECHANICAL PROPERTIES:- AS PER GOST 1173-77.

MANUFACTURING METHOD	GRADE OF COPPER	MATERIAL CONDITION	TENSILE STRENGTH		ELONGATION %
			Kgf/mm ²	MPa	
FIRE REFINED	M3	SOFT	20	196.0	30
FIRE REFINED	M3	HARD	30	294.0	3

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE 6 : (BK 82-437)

KVD No:- 78410.

DRG. REDRAWN.

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

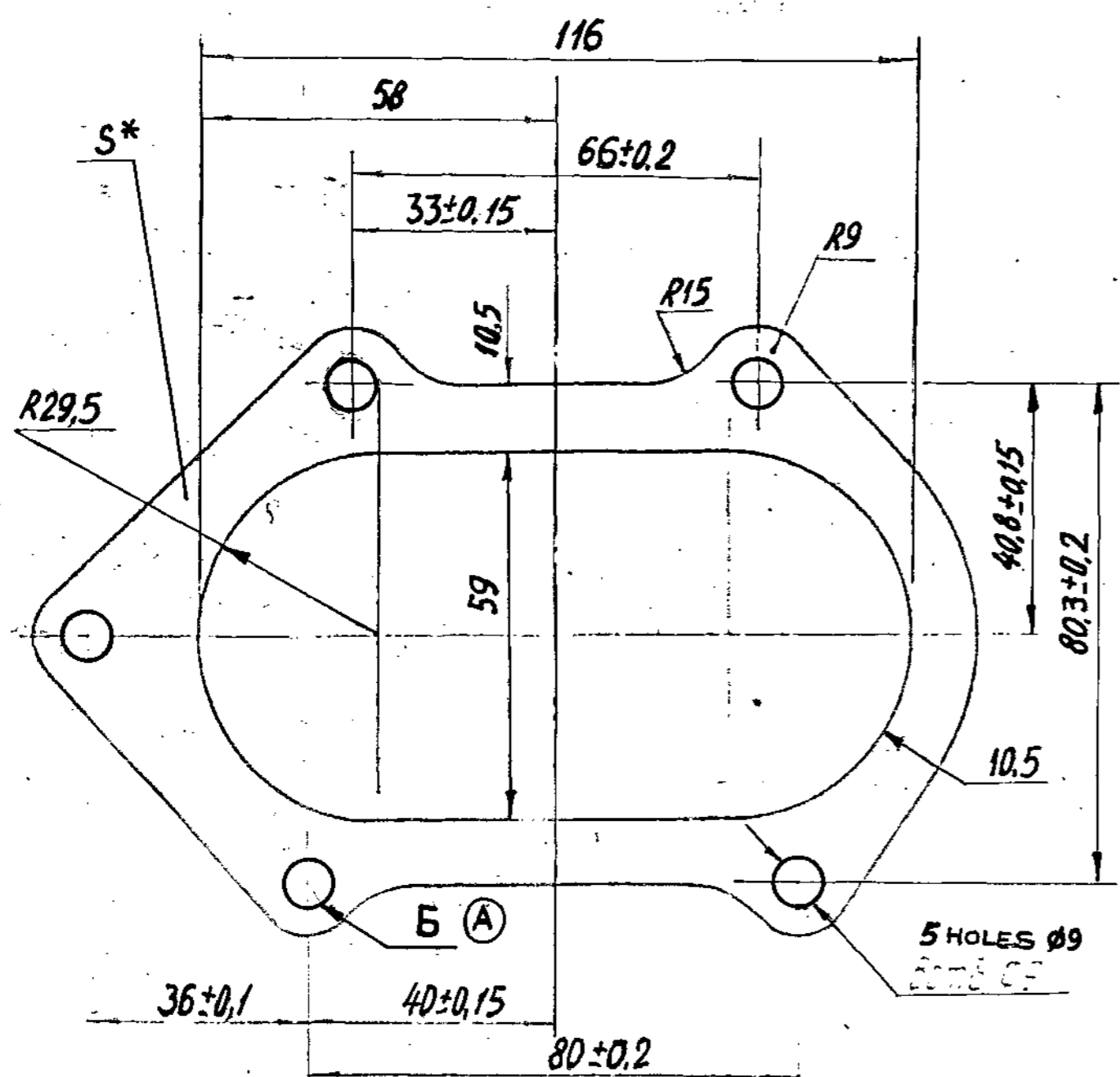
EST. WT. TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	TCD	APPD	DATE	SCALE	DIMENSIONS	TOLERANCE	TITLE	USED ON
				23-8-1988	1:1	mm.	UNLESS OTHERWISE STATED IS 2102-69	TOP PLATE	C63306-15C5
MATERIAL :- STRIP ДПРМТ НД-М3 ГОСТ 1173-77								CONTROL RATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A O I	
AUTHY NOTN. No BK 86-763								DRAWING NUMBER 3306-99	
ISSUE	DATE	NATURE OF AMENDMENTS			D S CAT NUMBER				

A-5
23

DRAWING NUMBER
3306-99-2



DIMENSIONS IN MM

S*	TOLERANCE	MASS Kg
0,25	-0,04	0,01
0,28	-0,04	0,0112
0,30	-0,04	0,012
0,35	-0,04	0,014

30.04.01.010 10.04.01.010 10.04.01.010
10.04.01.010 10.04.01.010 10.04.01.010
10.04.01.010 10.04.01.010 10.04.01.010

1. ALTERNATE MATERIAL: STRIP Д П ПТ Н Д, М3 ГОСТ 1173-77
2. UNSPECIFIED TOLERANCES FOR DIMENSIONS ±0.5mm.
3. DIMENSION FOR REFERENCE.
4. HOLES B AND EXTERNAL OUTLINE ARE ALLOWED TO BE MADE WHEN ASSEMBLED.

EXPLANATORY NOTE:-

THE COMPONENT SHOULD BE MANUFACTURED FROM FIRE REFINED COPPER-STRIP COLD ROLLED (A) RECTANGULAR SECTION (MP) TOLERANCE ON THICKNESS 0.04mm SPECIFIED IN TABLE COLUMN ON DRAWING AS PER NORMAL ACCURACY (M) NON STANDARD LENGTH (H) COPPER GRADE M3 TO GOST 1173-77. ALTERNATIVELY THE SUSPECT ITEM MAY BE PRODUCED FROM FIRE REFINED COPPER-STRIP COLD-ROLLED (A) RECTANGULAR SECTION (MP), HARD (T) STANDARD LENGTH (H) TO GOST 1173-77. CHEMICAL COMPOSITION SHOULD BE AS PER GOST 859-78 AND MECHANICAL PROPERTIES AS PER GOST 1173-77 ARE AS UNDER.

CHEMICAL COMPOSITION %:- AS PER GOST 859-78

MANUFACTURING METHOD	GRADE OF COPPER	Cu+Ag	IMPURITIES NOT MORE THAN										
		NOT LESS THAN	Bi	Sb	As	Fe	Ni	Pb	Sn	S	O	Zn	P
FIRE REFINED	M3	99.5	0.003	0.05	0.01	0.05	0.20	0.05	0.05	0.01	0.08	-	-

MECHANICAL PROPERTIES:- AS PER GOST 1173-77

MANUFACTURING METHOD	GRADE OF COPPER	MATERIAL CONDITION	TENSILE STRENGTH		ELONGATION
			Kgf/mm ²	Mpa	%
FIRE REFINED	M3	SOFT	20	196.0	30
FIRE REFINED	M3	HARD	30	294.0	3

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

EST. WT. SEE TABLE 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.

DRN	5.10.99	MATERIAL	STRIP A1PHM	USED ON	C8 3306-15-2 c8
EDD	10.10.99		M3 GOST 1173-77		
TEC	10.10.99				
APPD	10.10.99				
DATE	23-8-88				
SCALE	1:1				
DIMENSIONS	IN mm				
TOLERANCE ON DIMS	UNLESS OTHERWISE STATED IS 2102-69				
ALL THREADS TO CONFORM TO					
ISSUE	11.10.99	AUTHY NOTN - No. BK 86-763			
DATE		NATURE OF AMENDMENTS			

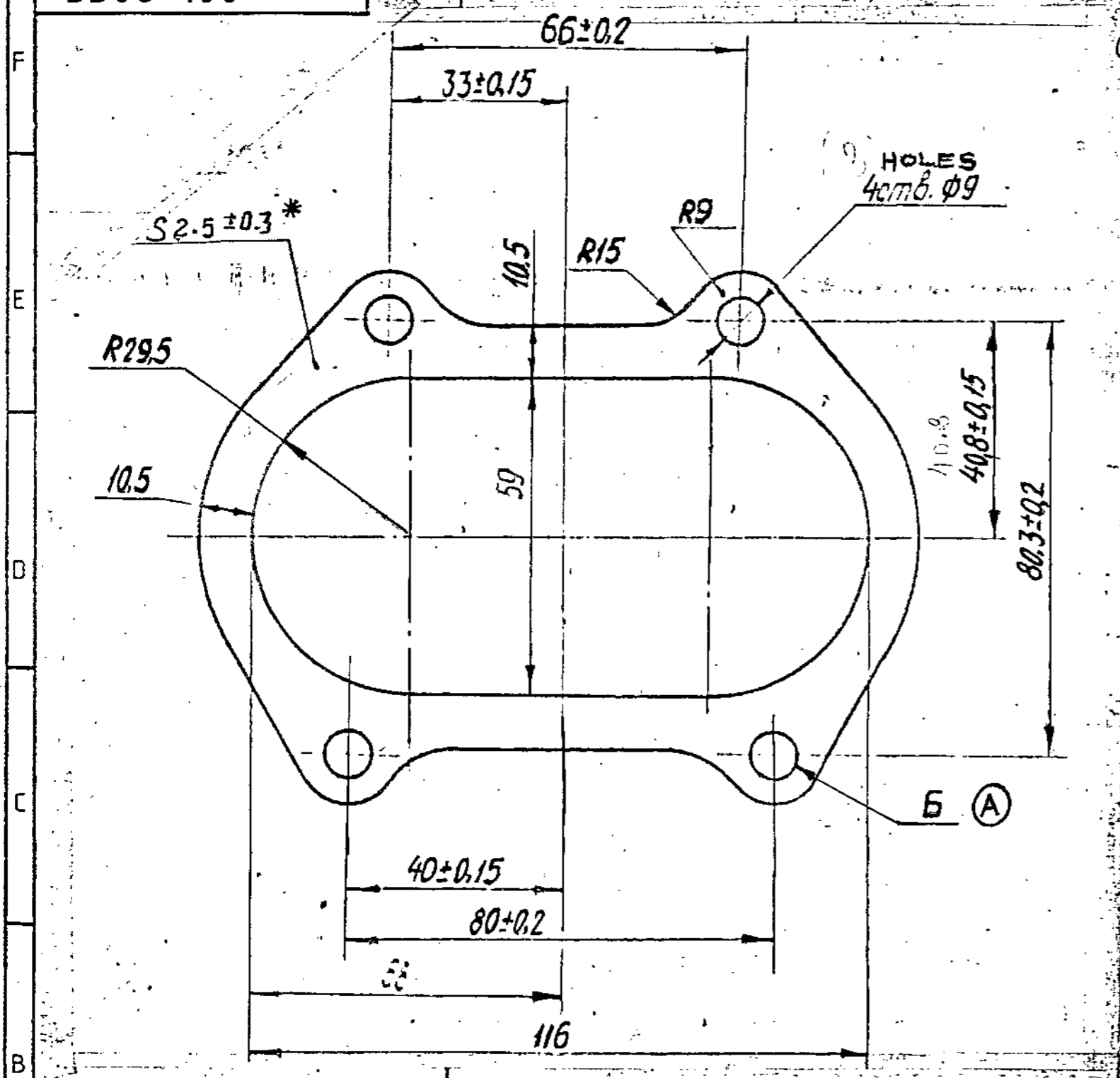
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)
A V A D I

TITLE
TOP PLATE

D S D N NUMBER
DRAWING NUMBER
3306-99-2

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE 5: (BK 82-437)
KVD No.:- 78411.
DRG. REDRAWN.
A-5
24
E A2

DRAWING NUMBER
3306-100



1. UNSPECIFIED TOLERANCES FOR DIMENSIONS = 0.5mm.
2. *DIMENSION FOR REFERENCE.
3. HOLES 'B' AND EXTERNAL OUTLINE ARE ALLOWED TO BE MADE WHEN ASSEMBLED.

EXPLANATORY NOTE:-

THE COMPONENT SHOULD BE MANUFACTURED FROM CHRYSOTILE ASBESTOS MILLBOARD OF GRADE-KAT TO GOST 2850-80. PHYSICAL AND MECHANICAL PARAMETERS OF MILLBOARD MUST CONFORM TO NORMS SPECIFIED AS UNDER AS PER GOST 2850-80.

SL No:-	PARAMETER	NORMS FOR GRADE KAT
1	DENSITY. Kg/m ³	900 TO 1200
2	ULTIMATE TENSILE STRENGTH MPa (Kgf/cm ²), NOT LESS THAN IN LONGITUDINAL DIRECTION:- IN TRANSVERSE DIRECTION:-	2.5 (25) 1.5 (15)
3	MOISTURE CONTENT % (MAX)	3
4	LOSS OF WEIGHT BY CALCINATION % (MAX)	18
5	NON-INFLAMMABILITY (RESISTANCE TO FIRE)	MUST NOT BURN OR GET CHARGED

KVD No:- 78412.

DRG. REDRAWN.

2 324 222-157 10/12/88 10/12/88
137 1107 11-22-88 1000-1972

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

EST. WT. 0.0103Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS \equiv (LETTERS)

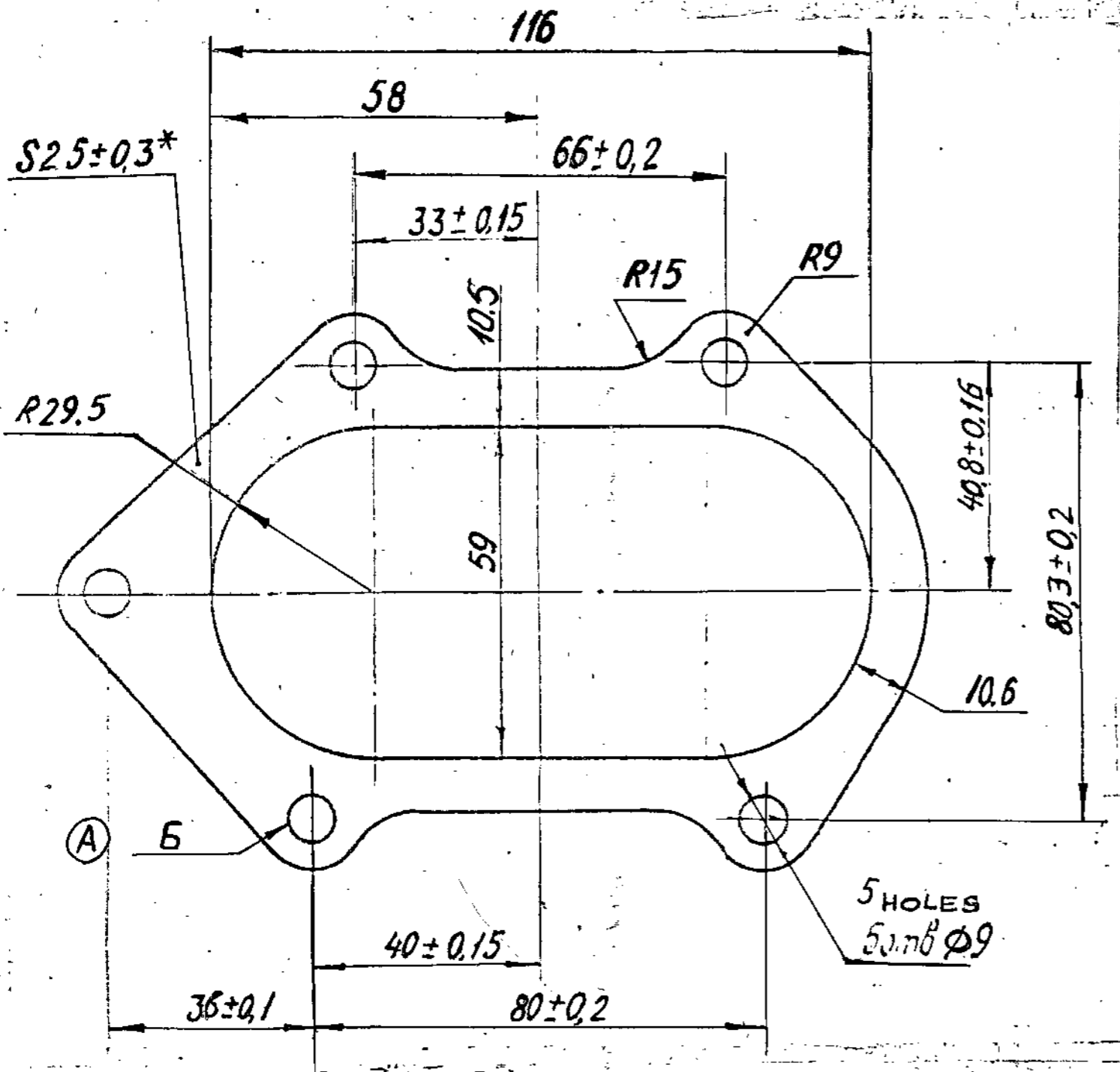
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	11/10/99	MATERIAL:- ASBESTOS BOARD KAT 2.5 GOST 2850-80.	USED ON
CHD			
TEC			
APPD			
DATE	26-8-1988	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES) AVADI	
SCALE:-	1 : 1		
DIMENSIONS IN mm		TITLE GASKET	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS:2102-69			
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER 3306-100
A	11.10.99	AUTHY NOTN.No. BK 86-763	
ISSUE	DATE	NATURE OF AMENDMENTS	

A-5
25
SIZE A3

DRAWING NUMBER

3306-100-2



1 UNSPECIFIED TOLERANCES FOR DIMENSIONS ±0.5mm.

2 *DIMENSION FOR REFERENCE.

(A) 3. HOLES 'B' AND EXTERNAL OUTLINE ARE ALLOWED TO BE MADE WHEN ASSEMBLED.

EXPLANATORY NOTE:-

THE COMPONENT SHOULD BE MANUFACTURED FROM CHRYSOTILE ASBESTOS MILLBOARD OF GRADE 'KA1' TO GOST 2850-80. PHYSICAL AND MECHANICAL PARAMETERS OF MILLBOARD MUST CONFORM TO NORMS SPECIFIED AS UNDER AS PER GOST 2850-80.

SL No:-	PARAMETER	NORMS FOR GRADE KA1
1	DENSITY Kg/m ³	900 TO 1200
2	ULTIMATE TENSILE STRENGTH MPa (Kgf/cm ²), NOT LESS THAN IN LONGITUDINAL DIRECTION:- IN TRANSVERSE DIRECTION:-	2.5 (25) 1.5 (15)
3	MOISTURE CONTENT % (MAX)	5
4	LOSS OF WEIGHT BY CALCINATION % (MAX)	18
5	NON-INFLAMMABILITY (RESISTANCE TO FIRE)	MUST NOT BURN OR GET CHARGED

KVD No:- 784,13.

DRG. REDRAWN.

2	VAR	EX-22-437	10/12/88	10/12/88

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

EST. WT. TO BE STAMPED OR MARKED WHERE INDICATED THUS $\frac{2.03}{\text{---}}$ (LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R. OUT SIDE INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

DRN	13. Kalashin	MATERIAL:- ASBESTOS BOARD KA12.5 GOST 2850-80	USED ON
APPD	13. Kalashin	CONTROL RATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	26-8-1988	SCALE:- 1:1	
DIMENSIONS IN mm		TOLERANCE-ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69	
ALL THREADS TO CONFORM TO		D S CAT NUMBER	
ISSUE DATE	A 11.10.99	NATURE OF AMENDMENTS	
			DRAWING NUMBER 3306-100-2

A-5
26

DRAWING NUMBER
3306-101

DIMENSIONS IN mm.

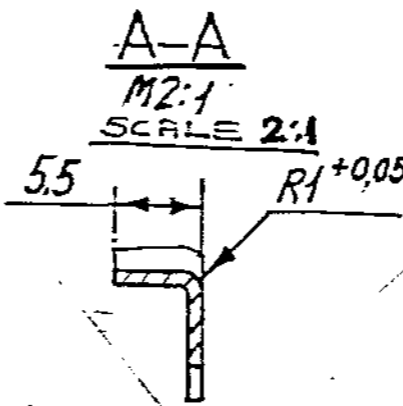
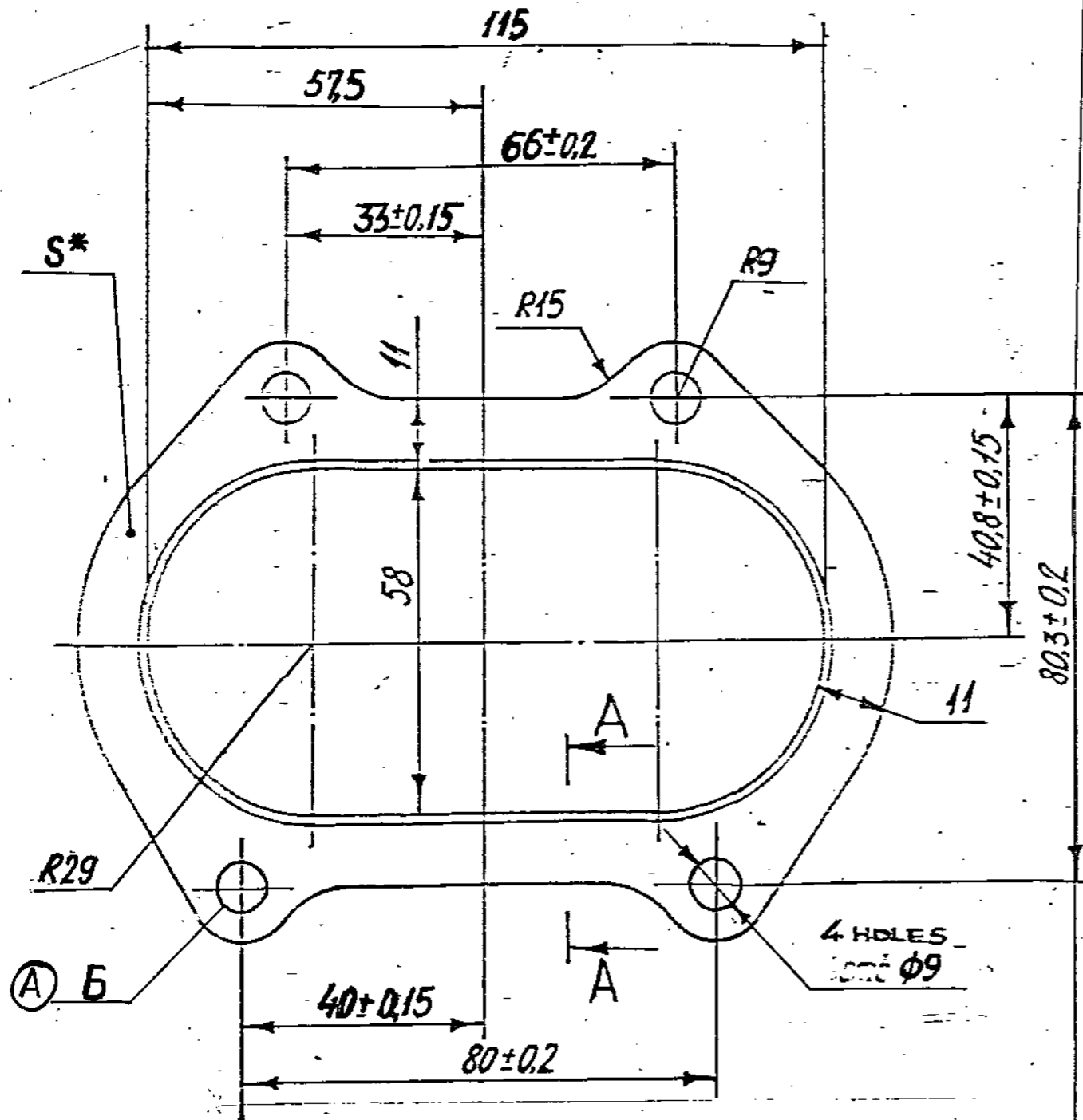
S*	TOLERANCE	MASS Kg.	REMARKS.
0.25	-0.04	0.011	
0.28	-0.04	0.0123	
0.30	-0.04	0.0132	
0.35	-0.04	0.0154	

1. ALTERNATE MATERIAL: STRIP АПРМН HА M3 GOST 1173-77.

2. UNSPECIFIED TOLERANCES FOR DIMENSIONS ±0.5mm.

3. * DIMENSION: FOR REFERENCE.

④ 4. HOLES "B" AND EXTERNAL OUTLINE ARE ALLOWED TO BE MADE WHEN ASSEMBLED.



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

EST. WT. TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	<i>Subbarao</i>	MATERIAL:- STRIP АПРМН HА M3 GOST 1173-77	USED ON CB-3306-15.
CHK	<i>[Signature]</i>	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES) AVADI	
TCD			
APPD	<i>[Signature]</i>	TITLE BOTTOM PLATE	
DATE	16-11-08		
SCALE:-	1:1	D S CAT NUMBER	
DIMENSIONS IN mm TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS:2102-69			
ALL THREADS TO CONFORM TO		DRAWING NUMBER 3306-101	
ISSUE DATE	11.10.99 AUTHY NOTN No.BK 86-763		
NATURE OF AMENDMENTS			

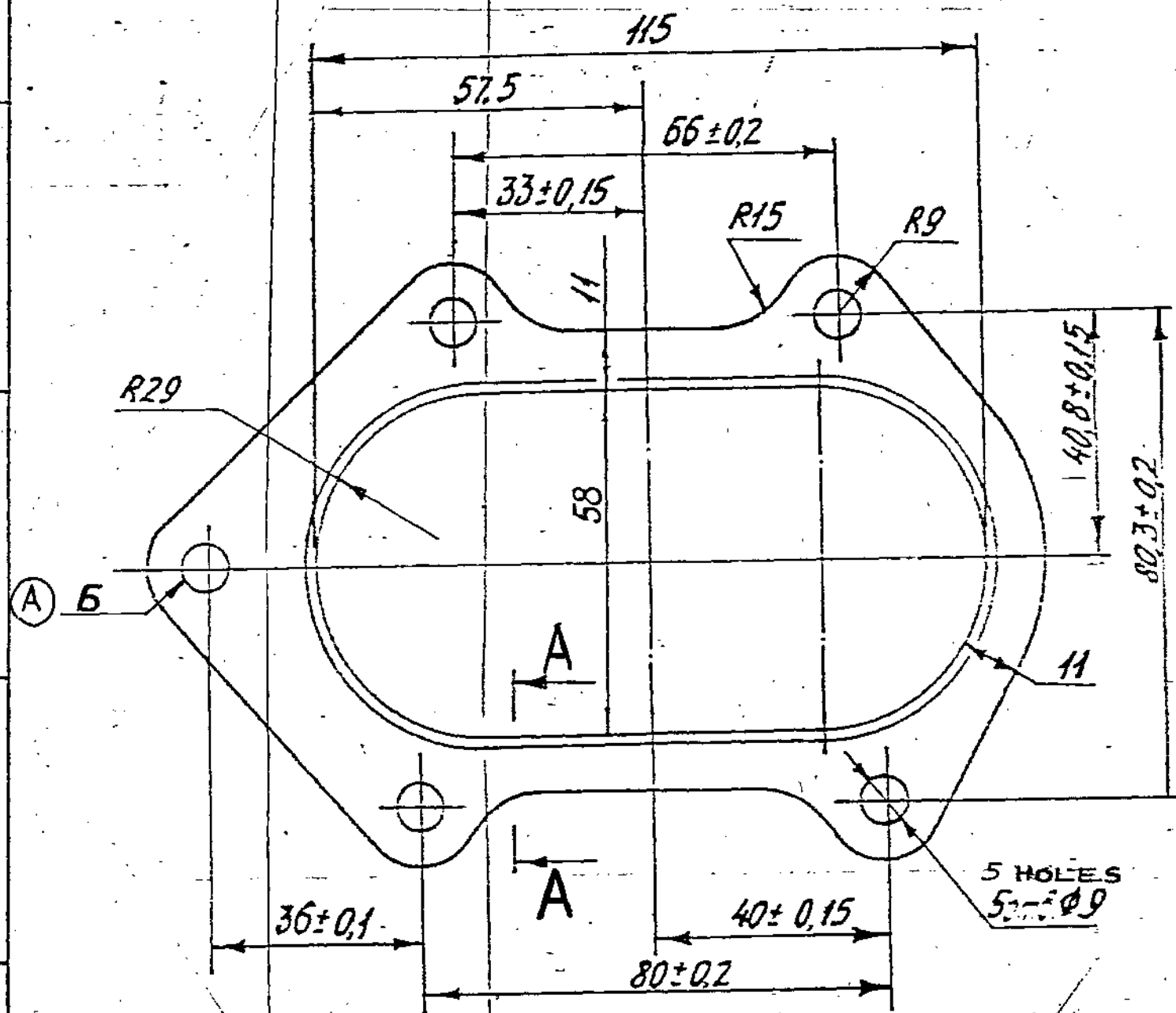
5
7
A3

DRAWING NUMBER

3306-101-2

DIMENSION IN mm

S*	TOLERANCE	MASS Kg
0,25	-0,04	0,013
0,28	-0,04	0,0145
0,30	-0,04	0,0156
0,35	-0,04	0,0182



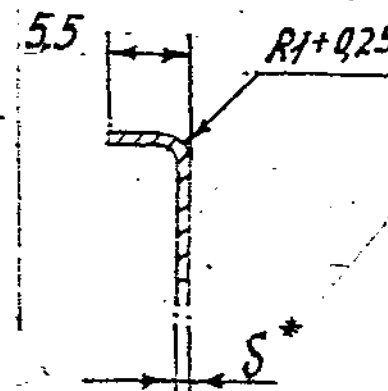
1. ALTERNATE MATERIAL : ДПРПТ МДМЗ ГОСТ 1173-77.

2. UNSPECIFIED TOLERANCES FOR DIMENSIONS $\pm 0,5$ mm.

3. DIMENSION FOR REFERENCE.

(A) 4. HOLES 'B' AND EXTERNAL OUTLINE ARE ALLOWED TO BE MADE WHEN ASSEMBLED.

A-A
M2:1
SCALE 2:1



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

EST WT
SEE TABLE

TO BE STAMPED OR MARKED WHERE INDICATED THIS # (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.

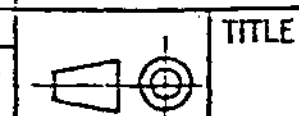
DRN
CHD
TED
APPD
DATE
SCALE :- 1 : 1

MATERIAL :-
СТРП, ДПРПМ
МДМЗ ГОСТ 1173-77.

USED ON :-
СБ 3306-15-2

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)
AVADI

DIMENSIONS IN MM
TOLERANCE ON DIMNS
UNLESS OTHERWISE
STATED IS: 2102-69



TITLE

BOTTOM PLATE

ALL THREADS TO
CONFORM TO.

D S CAT NUMBER

DRAWING NUMBER
3306-101-2

ISSUE DATE NATURE OF AMENDMENTS

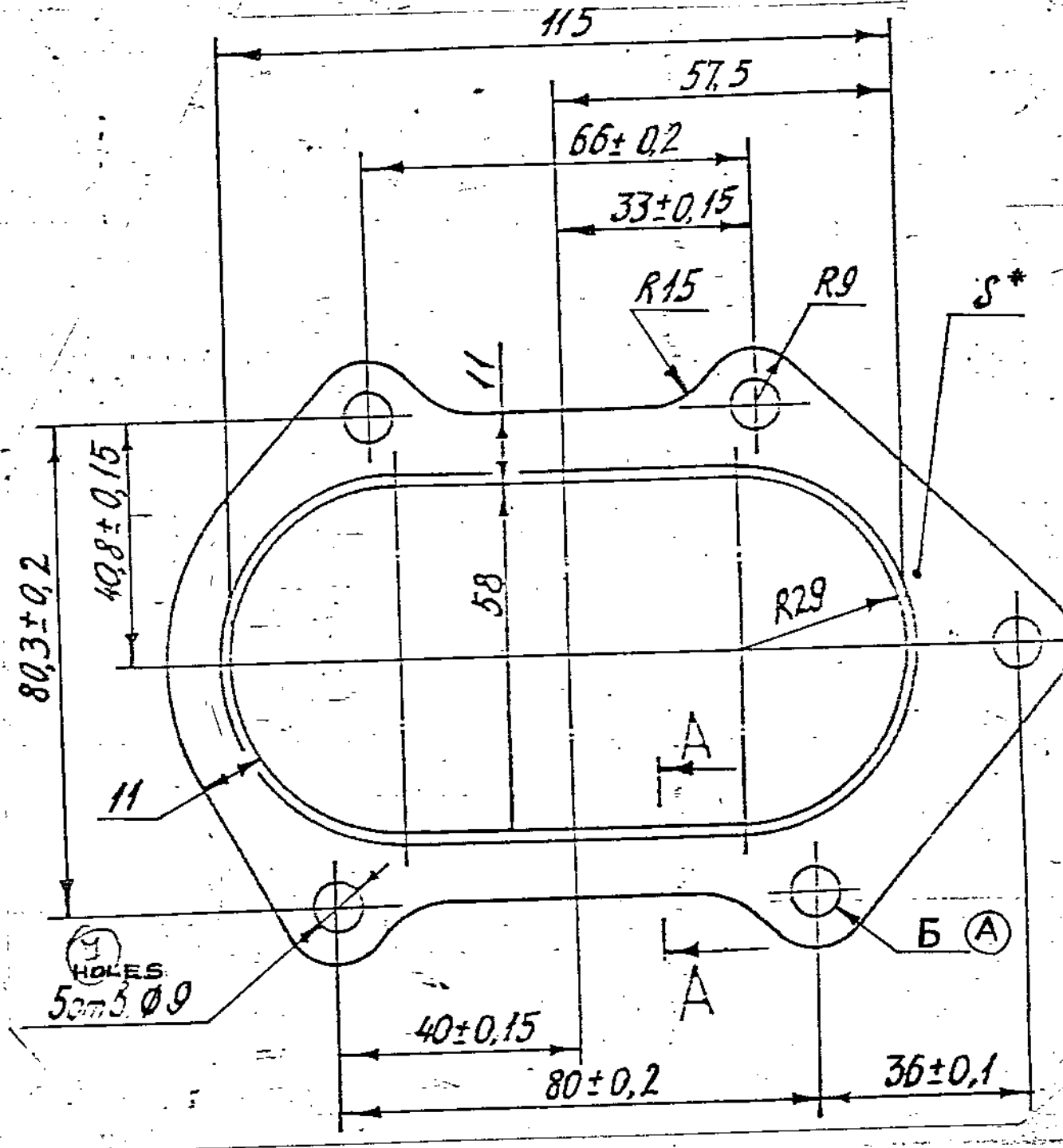
A-5
28

SIZE A3

DRAWING NUMBER
3306-101-3

DIMENSION IN mm.

S *	TOLERANCE	MASS / Kg
0,25	-0,04	0,013
0,28	-0,04	0,0145
0,30	-0,04	0,0156
0,35	-0,04	0,0182

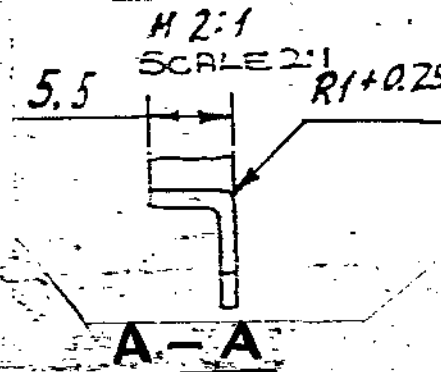


1. ALTERNATE MATERIAL : ДП ПНТ Н,Д,МЗ GOST 1173-77.

2. UNSPECIFIED TOLERANCES FOR DIMENSION B ± 0.5mm.

3. * DIMENSION FOR REFERENCE.

4. HOLES B AND EXTERNAL OUT LINE ARE ALLOWED TO BE MADE WHEN ASSEMBLED.

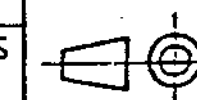


PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

EST WT TO BE STAMPED OR MARKED WHERE SEE TABLE 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	<i>Ushakova</i>	MATERIAL	STRIP ДПНН Н,Д,МЗ GOST 1173-77	USED ON	CG 3306-15-3
CHD	<i>Ushakova</i>				
TCD	<i>Ushakova</i>				
APPD	<i>Ushakova</i>				
DATE	16-11-98				
SCALE	1:1				
DIMENSIONS IN mm					
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 2102-69					
ALL THREADS TO CONFORM TO					
ISSUE	DATE	NATURE OF AMENDMENTS			
A	11.10.93	AUTHY NOTN. No. BK 86-763			



TITLE
BOTTOM PLATE

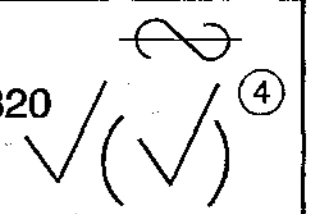
D S CAT-NUMBER
DRAWING NUMBER
3306-101-3

A5
29

DRAWING NUMBER
3318-06-4

SHEET No. 1 OF 1

EXPLANATORY NOTE :-

Rz 320 

MATERIAL QUOTED : SHEET A2 GOST 19904 - 74
II - Γ - 10 GOST 16523 - 70

- A = HIGH ACCURACY
- 2 = THICKNESS OF COLD ROLLED SHEET STEEL TO GOST 19904 - 74
- II = GROUP FOR QUALITY OF SURFACE FINISH.
- Γ = CAPABILITY TO DRAW - DEEP DRAWN
- 10 = GRADE OF STEEL

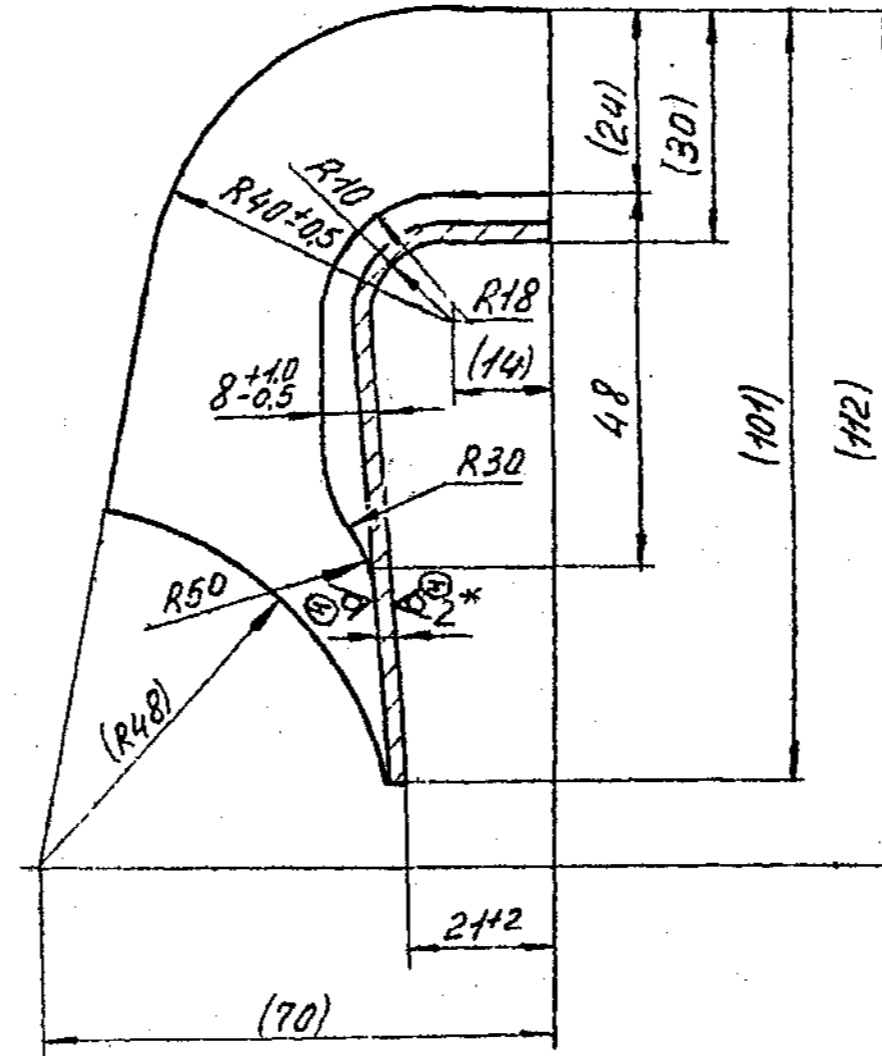
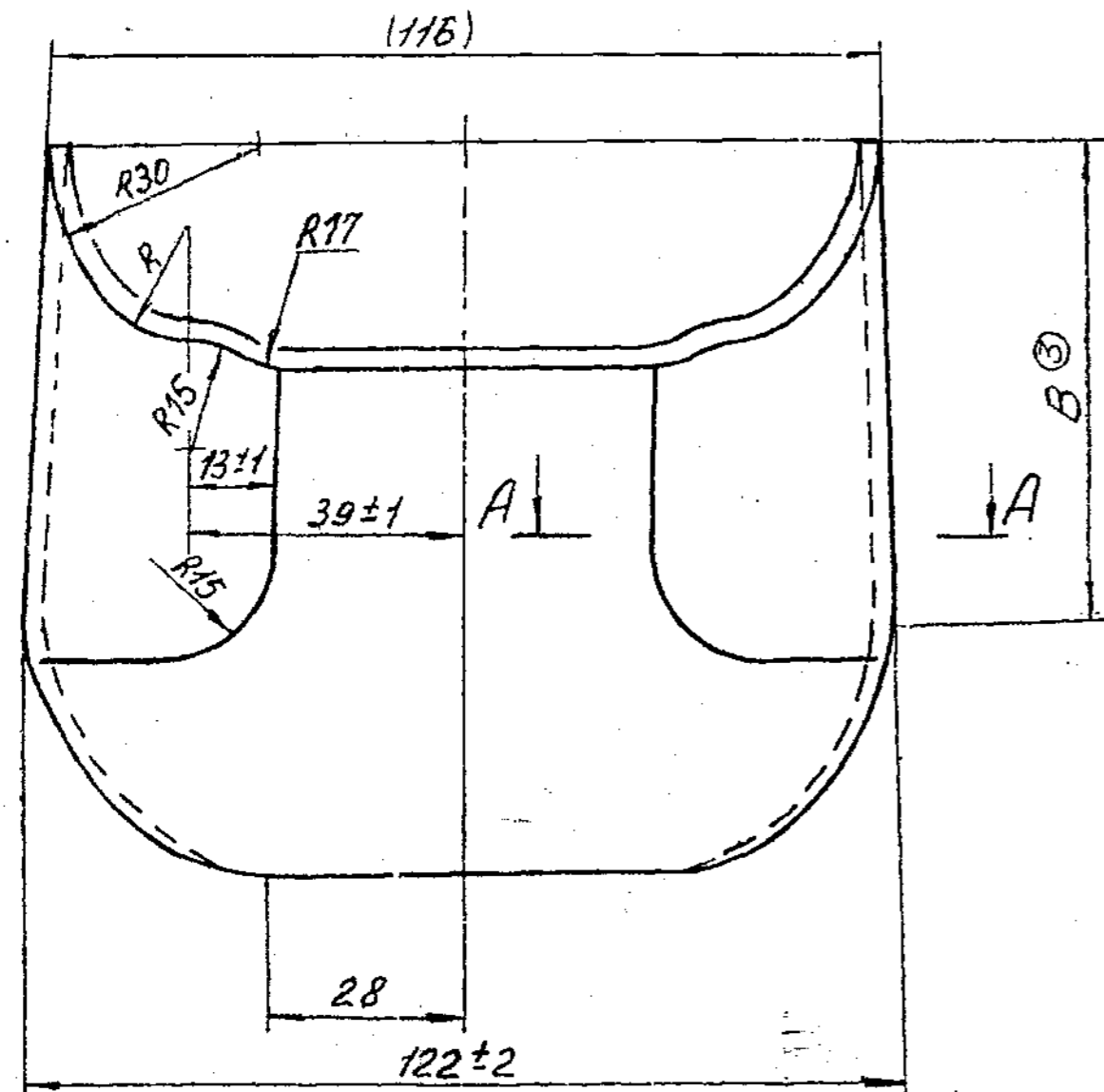
CHEMICAL COMPOSITION % (AS PER GOST 1050 - 74)

CARBON = 0.07 - 0.14 ; SILICON = 0.17 - 0.37
MANGANESE = 0.35 - 0.65
CHROMIUM = 0.15 (MAX) ; SULPHUR = 0.040 (MAX)
PHOSPHORUS = 0.035 (MAX) ; COPPER = 0.25 (MAX)
NICKEL = 0.25 (MAX)

MECHANICAL PROPERTIES (AS PER GOST 16523 - 70)

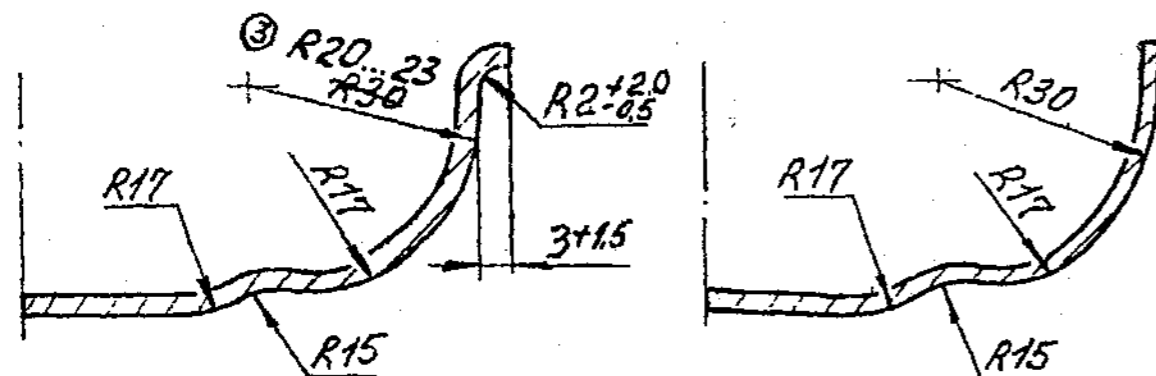
ULTIMATE TENSILE STRENGTH $Kgf/mm^2 = 30 - 42$
% ELONGATION (MIN) = 25

2. DIMENSIONS WITH UNSPECIFIED TOLERANCES FOR COLD STAMPING SHOULD BE OBTAINED WITH TOLERANCE ± 2 mm.
3. MATERIAL THICKNESS IN THINNED PLACES SHOULD NOT BE LESS THAN 1.5 mm.
4. RUPTURE HOLES, LAMINATIONS, DENTS AND OTHER DEFECTS ARE NOT ALLOWED.
5. DIMENSIONS IN BRACKETS SHOULD BE OBTAINED WITH ACCURACY ± 1 mm.
6. BEFORE PUTTING INTO PRODUCTION, THE MATERIAL SHOULD BE CHECKED FOR WELDABILITY AS PER SPECIFICATIONS OF THE WELDING DEPARTMENT.
7. * DIMENSIONS FOR REFERENCE.
8. WHEN MANUFACTURING AS PER ALTERNATIVE SMOOTH TRANSITION OF R30 TO R20 TO 23 SHOULD BE ENSURED ON SECTION " B "



A-A ALTERNATIVE

A-A



ⓑ EQUIVALENT MATERIAL
Gr. DD IS: 513-1994

Ⓐ ALTERNATIVE MATERIAL :- SHEET A-ΓB-0-2.0 GOST 19904 - 74
II - BF 08 ΓC GOST 9045 - 80

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

EST. WT. (Kg) 0.229 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.

DRN	APPD	DATE	SCALE:- 1:1	MATERIAL:- SHEET A2 GOST 19904 - 74 II - Γ - 10 GOST 16523 - 70	USED ON:- Cb 411-50-29 Cb 411-51-29
CHD		11/01/07	DIMENSIONS IN mm	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
			TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 2102-69	TITLE:- LOWER HALF OF BRANCH PIPE	
B	23.10.10	4 th Alt. Comm. Mtg. Minutes Point. No.1 dt. 26.10.09	ALL THREADS TO CONFORM TO IS: 4218 Pt. IV	D S CAT NUMBER	DRAWING NUMBER 3318-06-4
A	18.9.89	AUTHY. BK. 84 - 779 & 85 - 788			
ISSUE	DATE	NATURE OF AMENDMENTS			

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 4

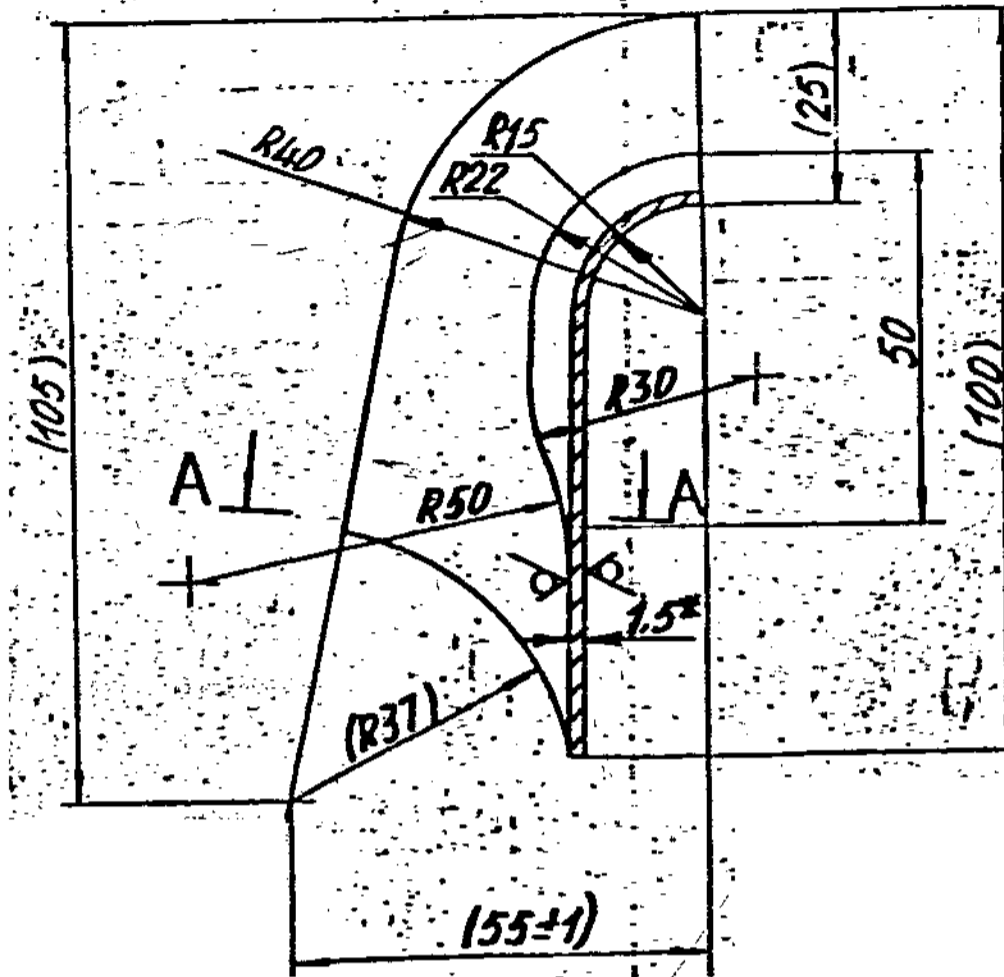
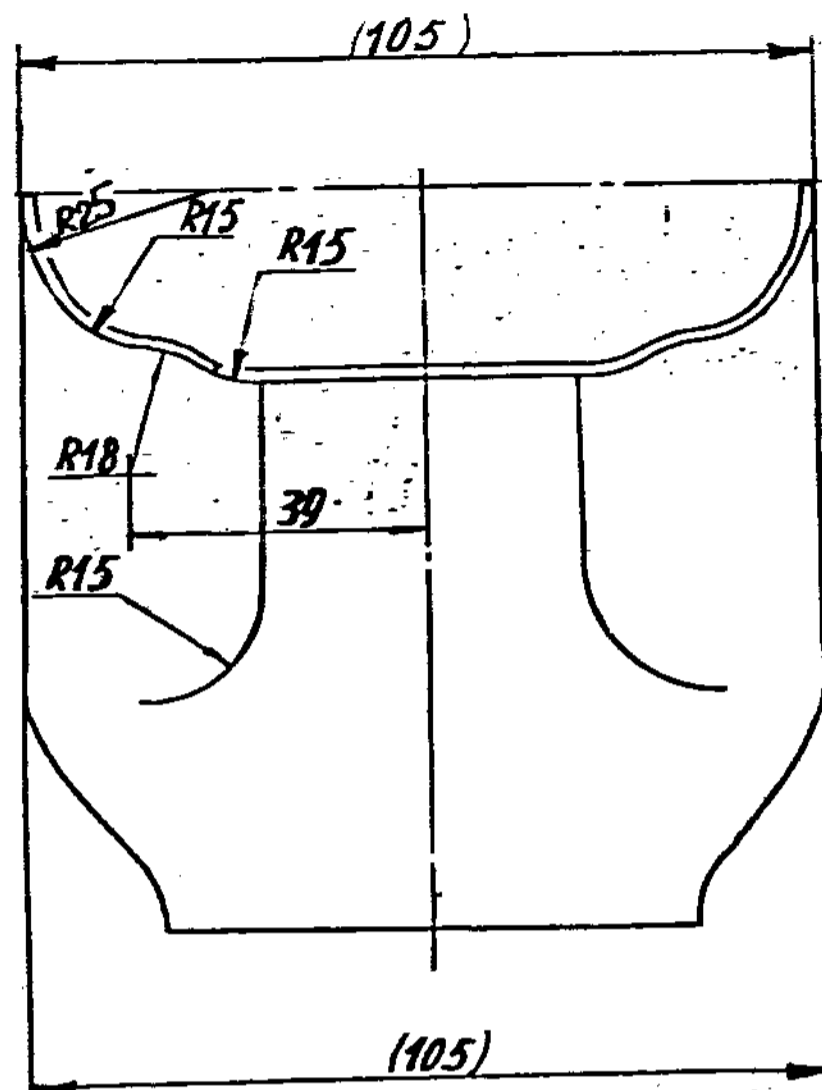
F - A
6
SIZE A2

DRAWING NUMBER
318-20-5

RZ 80/ (✓)

TECHNICAL REQUIREMENTS - TRANSLATED

1. DIMENSIONS WITH UNSPECIFIED DEVIATIONS FOR COLD STAMPING SHOULD BE OBTAINED WITH ACCURACY $\pm 0.5\text{mm}$.
2. MATERIAL THICKNESS IN THINNED PLACES SHOULD BE 1mm MIN.
3. CRACKS, LAMINATIONS, DENTS, ARE NOT ALLOWED.
4. DIMENSION IN BRACKETS SHOULD BE ENSURED AFTER ASSEMBLY.
5. * DIMENSION FOR REFERENCE.



EXPLANATORY NOTE :-

MATERIAL QUOTED : SHEET Б 1.5 GOST 19904-74
12X18H10T-M2a OR M3a GOST 5582-75

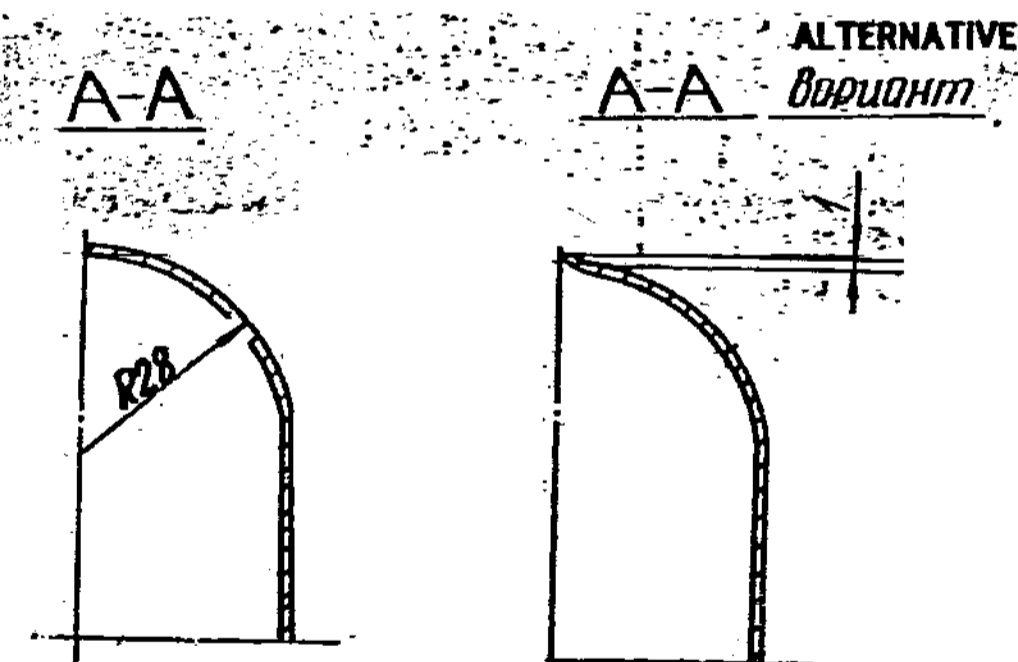
Б = STANDARD ACCURACY.
1.5 = THICKNESS OF COLD ROLLED SHEET STEEL AS PER GOST 19904-74
12X18H10T = GRADE OF STEEL.
M2a OR M3a = PICKLED & BRIGHT ANNEALED.

CHEMICAL COMPOSITION% (AS PER GOST 5632-72)
CARBON = 0.12 (MAX); SILICON = 0.8 (MAX); MANGANESE = 2.0 (MAX);
CHROMIUM = 17.0-19.0; NICKEL = 9.0-11.0; TITANIUM = 0.6-0.8

MECHANICAL PROPERTIES (AS PER GOST 5582-75)

HEAT TREATMENT

TEMPERING AT 1050 TO 1080°C
COOLING IN WATER OR IN AIR.
ULTIMATE STRENGTH Kgf/mm^2 (MIN) = 54
YIELD POINT Kgf/mm^2 (MIN) = 20
RELATIVE ELONGATION (MIN) = 40



**
SHEET: Б 1.5 GOST 19904-74
12x18H10 -M2a (ORM3a) GOST 5582-75

EXPLANATORY NOTE ADDED ON 18-2-92

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

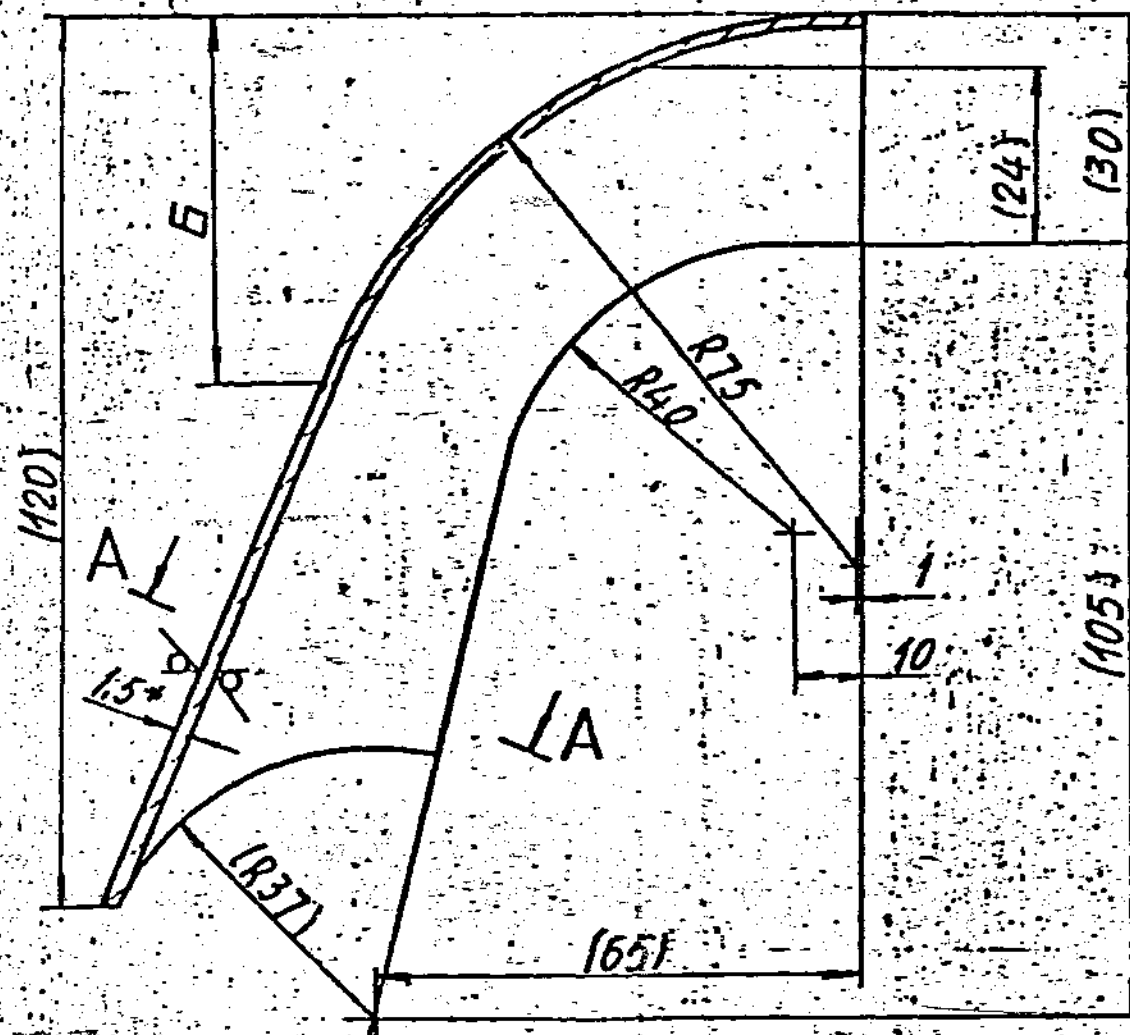
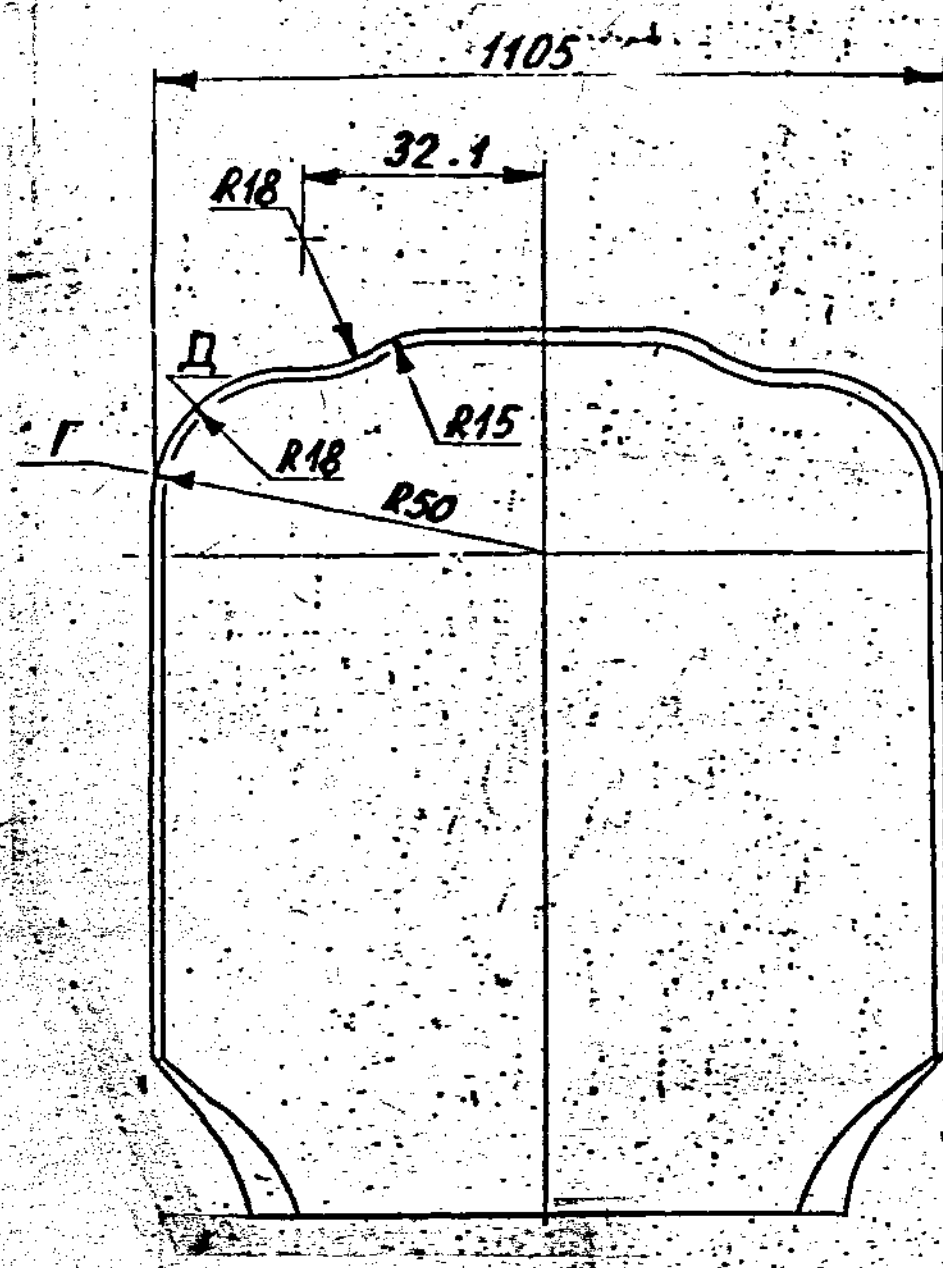
EST. WT. 0.135 kg TO BE STAMPED OR MARKED WHERE INDICATED THIS * LETTERS!

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	---	MATERIAL	SEE ABOVE **	USED ON	C5318-22-5
CHD	---	CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES)	A V A D I		
TCD	---	TITLE	LOWER PART OF SCREEN		
APPD	---	D S CAT NUMBER	DRAWING NUMBER		
DATE	29-1-88	318-20-5			
SCALE	1:1				
DIMENSIONS IN	mm				
TOLERANCE ON DIMS	UNLESS OTHERWISE STATED IS 2Y2-69				
ALL THREADS TO	CONFORM TO				
ISSUE	DATE	NATURE OF AMENDMENTS			

DRAWING NUMBER
318-21-5

80° (✓)



EXPLANATORY NOTE :-

MATERIAL QUOTED : SHEET B 1.5 GOST 19904-74
12X18H10T-M2a OR M3a GOST5582-75

B = STANDARD ACCURACY.

1.5 = THICKNESS OF COLD ROLLED SHEET STEEL AS PER GOST 19904-74.
12X18H10T = GRADE OF STEEL.

M2a OR M3a = PICKLED OR BRIGHT ANNEALED.

CHEMICAL COMPOSITION % (AS PER GOST 5632-72)

CARBON = 0.12 (MAX); SILICON = 0.8 (MAX); MANGANESE = 2.0 (MAX);
CHROMIUM = 17.0-19.0; NICKEL = 9.0-11.0; TITANIUM = 0.6-0.8

MECHANICAL PROPERTIES (AS PER GOST 5582-75)

HEAT TREATMENT

TEMPERING AT 1050 TO 1080 °C
COOLING IN WATER OR IN AIR.

ULTIMATE STRENGTH Kgf/mm^2 (MIN) = 54

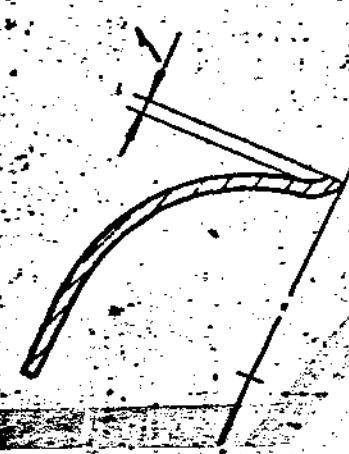
YIELD POINT Kgf/mm^2 (MIN) = 20

RELATIVE ELONGATION (MIN) = 40

A-A

A-A

ALTERNATIVE
ВЕРСИЯ



TECHNICAL REQUIREMENTS - TRANSLATED

- UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS FOR COLD STAMPING SHOULD BE OBTAINED WITH ACCURACY $\pm 0.5mm$.
- MATERIAL THICKNESS IN THE THINNED PLACES SHOULD BE NOT LESS THAN 1mm.
- CRACKS, LAMINATIONS, DENTS, ARE NOT ALLOWED.
- SMOOTH TRANSITION OF RADIUS B TO RADIUS Γ AND RADIUS A SHOULD BE ENSURED ON SECTION B.
- DIMENSIONS GIVEN IN BRACKETS ARE TO BE ENSURED AFTER ASSEMBLY.
- * DIMENSIONS FOR REFERENCE.

Ⓐ EQUIVALENT MATERIAL
04 Cr.18 Ni 10 Ti 20 TO IS: 6911-72

**
SHEET: B 1.5 GOST 19904-74
12X18H10T-M2a OR M3a
GOST 5582-75

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

EST. WT. 0.235 kg.	TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)
-----------------------	--

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R- OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

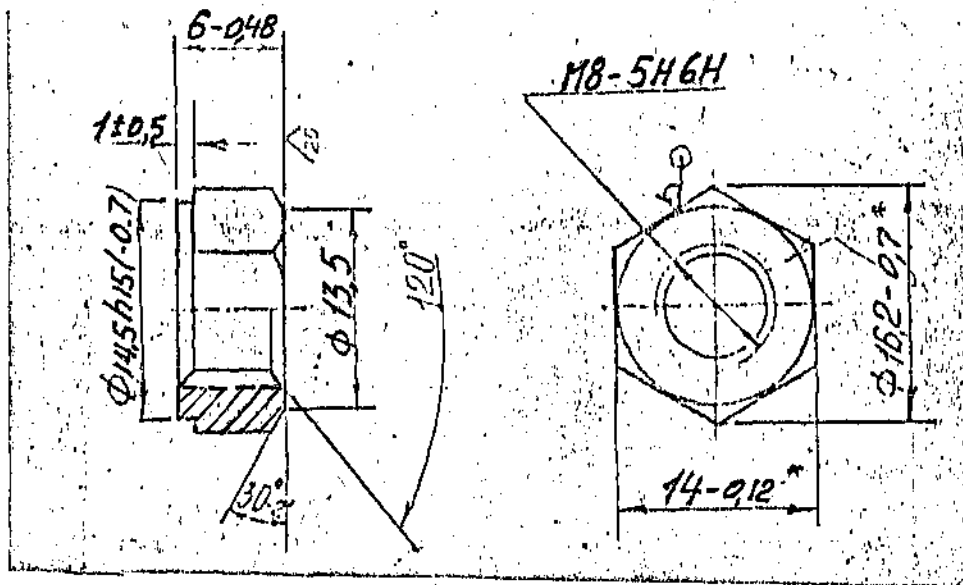
DRN	CHD	TCD	APPD	DATE	SCALE	DIMENSIONS IN mm.	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69
				29-1-88	1:1		
				MATERIAL :-		USED ON :-	
				SEE ABOVE **		CB 318-22-5	
				CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)			
				A V A D I			
				TITLE		UPPER PART OF SCREEN	
				D S CAT NUMBER		DRAWING NUMBER	
						318-21-5	
ISSUE	DATE	NATURE OF AMENDMENTS					
A	28.8.10	4 th ALT Comm Meeting Minutes Point No. 16 Dated 26.10.09					

DRAWING BASED ON RUSSIAN ORIGINAL ISSUED (AK 87-31)

EXPLANATORY NOTE ADDED ON 18-2-92

SIZE A2

DRAWING NUMBER
351-025



1. ROLLED STOCK OF GROUP 'B' CLASS 4 GOST 1051-73 MAY BE USED. TO ENSURE HIGH QUALITY OF COATING, IT IS ALLOWED TO ELIMINATE SURFACE DEFECTS OF ROLLED STOCK WITH DECREASE OF DIMENSIONS AS PER ACCURACY CLASS
2. ALTERNATE MATERIAL : STEEL, GRADES 40 & 50, GOST 1050-74.
3. THE REST OF THE TECHNICAL REQUIREMENTS AS PER STANDARD 82052-00.
4. COATING : Cu, 6 AS PER UA- 236 - 76.
5. COATING : Cu, 6 Cr, 6,
6. * DIMENSIONS FOR REFERENCE.

Ⓐ EQUIVALENT MATERIAL STEEL
45C8 TO IS:1570

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

A-11
30

		EST. WT. 0.0055 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.	
-A	13.8.10 4 th Alt. Comm. Meeting Minutes Point No.11 Dt:26-10-09	MATERIAL:- HEXAGON BAR 14-4 GOST 8560-70 45-5 GOST 1051-73	USED ON : 3300-00-27CX
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN	9/27/08	SCALE:- 2 : 1 DIMENSIONS IN mm	
CHD		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS 2102 -69	
TCD		ALL THREADS CONFORM TO	
APPD		TITLE NUT M8	
DATE	27/8/08	D S CAT NUMBER	DRAWING NUMBER 351-025

SIZE A4

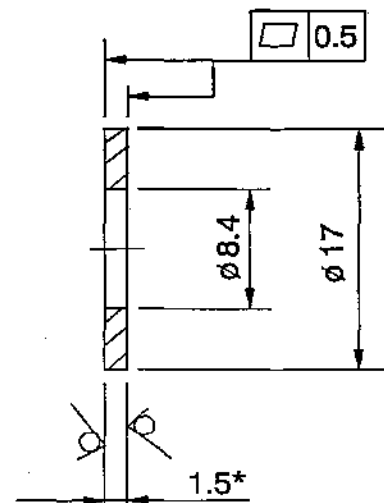
DRAWING NUMBER
353-03-3

SHEET No. 1 OF 1

20/ (M)

P. Janardhanan
(P. JANARDHANAN)
Dt. 15 Nov '10 JTO (D)

DRG. REINDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NIL



1. ALTERNATE MATERIAL IS STEEL 08 to GOST 9045-80.
2. REQUIREMENTS FOR STAMPING AS PER STANDARD 82050-16.
UJ-749-88
3. COATING Zn 15 Cr AS PER UJ-483-82 WITH REMOVAL OF HYDROGEN EMBRITTLEMENT.
4. IN TROPICALIZED MAKE THE COATING IS Ka9 XP AS PER UJ-589-84 WITH REMOVAL OF HYDROGEN EMBRITTLEMENT.
5. FINISH PARAMETER OF MACHING SURFACES ARE TO BE ENSURED WITH THE TOOL.
6. * DIMENSIONS FOR REFERENCE.

Ⓐ EQUIVALENT MATERIAL Gr. D
IS: 513-1994

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

EST. WT. (Kg) 0.002 TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)

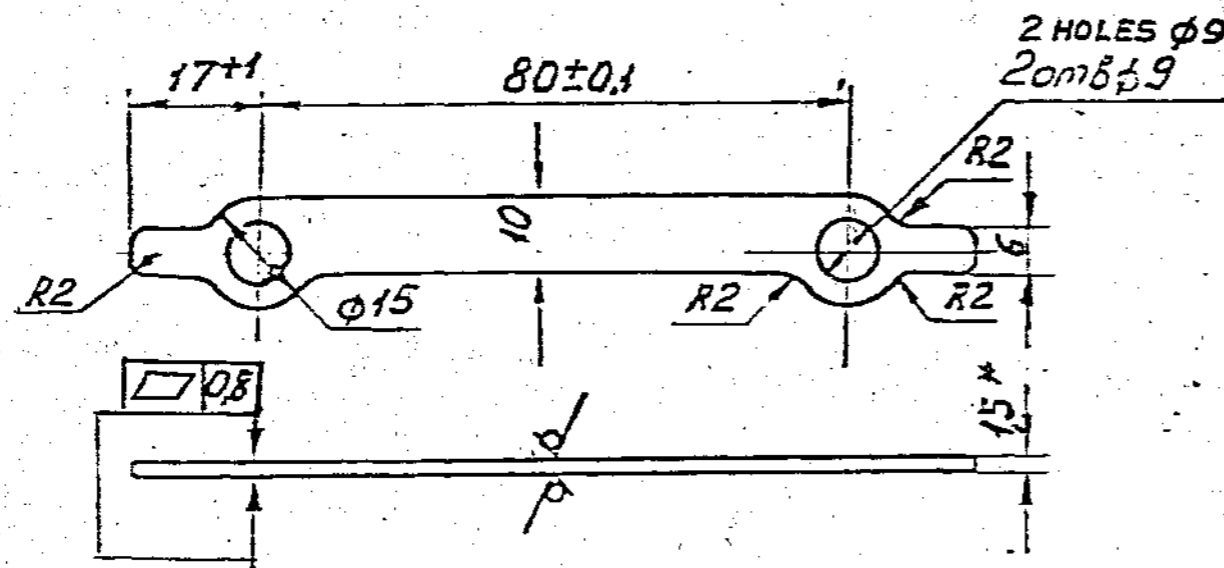
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

			DRN	Sd/=	MATERIAL:- SHEET	USED ON:- Cb 418-00-6
			CHD	Sd/=	A1.5 GOST 19904-74	
			APPD	Sd/=	5-11-Г-10 GOST 16523-70	
			DATE	Nov 2010	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
			SCALE:- 2 : 1			
			DIMENSIONS IN mm		TITLE :-	
			TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69		BRIGHT WASHER	
			ALL THREADS TO CONFORM TO IS : 4218,PART-4.		D S CAT NUMBER	DRAWING NUMBER
			ISSUE	DATE		353-03-3
			A	13.11.10	4 th Alt. Comm. Mtg. Minutes Point No.1 Dated 26.10.09	
					NATURE OF AMENDMENTS	

SIZE A3

DRAWING NUMBER
353 - 68

20 ✓
M1



TECHNICAL REQUIREMENTS

1. REQUIREMENTS FOR STAMPING AS PER STANDARD 82050 - 16.
2. THE COMPONENT, SHOULD BE STRAIGHTENED AFTER STAMPING.
3. COATING Zn 15 Cr AS PER ИЦЛ - 432 - 82 WITH REMOVAL OF HYDROGEN EMBRITTLEMENT.
4. COATING: Cd 9, CHROMATISING AS PER ИЦЛ - 104 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT DURING TROPICAL MANUFACTURE.
5. REQUIRED SURFACE FINISHING OF MACHINING SURFACES SHOULD BE ENSURED BY TOOL.
6. * DIMENSION FOR REFERENCE.

1. Требования, предъявляемые к штамповке, по нормам 82050-16.
 2. После штамповки править [ⓑ] ИЦЛ-432-82.
 3. Покрытие Ц15.хр по ИЦЛ-104 с последующим удалением водородной хрупкости.
 4. В тропическом исполнении покрытие Кд 9хр по ИЦЛ-104 с последующим удалением водородной хрупкости.
 5. Параметр шероховатости обрабатываемых поверхностей обеспечивается инструментом.
 6.* Размер для справок.

ⓑ EQUIVALENT MATERIAL
Gr. O IS: 513-1994

DRG INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE (PK 02 - 207)

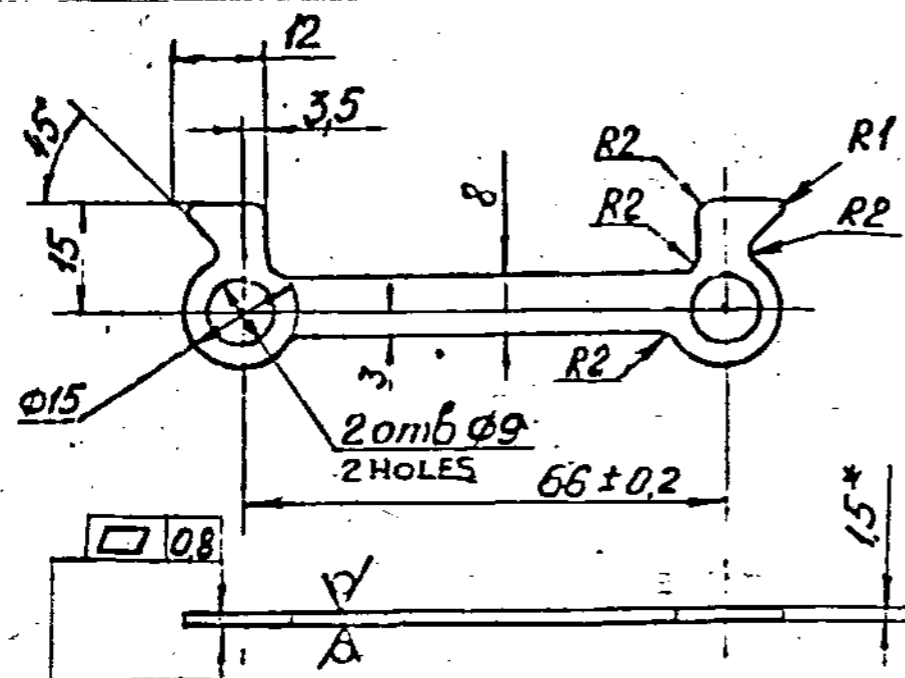
DRN CHD TCD APPD DATE 8 MAR 89 SCALE: 1:1		MATERIAL:- STRIP 08 пс - М - 2 - 15 GOST 503 - 21 - 81 ⓑ	USED ON GENERAL ASSY.
PILOT SAMPLE SHOULD BE APPROVED BY A H S P, BEFORE BULK PRODUCTION		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
EST. WT. 0.0075 Kg.	TO BE STAMPED OR MARKED WHERE INDICATED THIS ≡ (LETTERS)	DIMENSIONS IN mm TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69	TITLE LOCK WASHER 9
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE		ALL THREADS TO CONFORM TO	D S CAT NUMBER DRAWING NUMBER 353 - 68
ISSUE DATE NATURE OF AMENDMENTS		B 17-3-10 4th Alt. Comm. Mt. Minutes Pt. No. 1 Of. 26.10.09 A 10-3-89 AUTHY. BK 83-126	

11
SIZE A3



DRAWING NUMBER
353 - 69 - 5

20/ (✓)



TECHNICAL REQUIREMENTS

1. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS SHOULD BE OBTAINED WITH ACCURACY OF ± 0.3 mm.
2. TO BE STRAIGHTENED AFTER STAMPING.
3. COATING : Zn 15, CHROMATIZING AS PER УЛ 483 - 82 WITH ELEMINATION OF HYDROGEN EMBRITTLMENT.
4. IN TROPICALIZED CONSTRUCTION, COATING : Cd.9, CHROMATIZING AS PER УЛ - 104 WITH ELEMINATION OF HYDROGEN EMBRITTLMENT.
5. * DIMENSION FOR REFERENCE.

1. Неуказанные предельные отклонения размеров выполнять с точностью $\pm 0,3$ мм.
2. После штамповки править.
3. Покрытие Ц15.Хр по УЛ-483-82 с удалением водородной хрупкости.
4. В тропическом исполнении покрытие КД9.Хр по УЛ-104 с удалением водородной хрупкости.
5. * Размер для справок

(A) EQUIVALENT MATERIAL
Gr. O IS: 513-1994

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION		DRN		MATERIAL:- BAND 08nc - M-2-1.5 GOST 503 - 81	USED ON CS418-00.6 GENERAL ASSY.
EST. WT. 0.0093 Kg.	TO BE STAMPED OR MARKED WHERE INDICATED THIS # 1 LETTERS!	CHD		APPO	CONTROLLERATE OF QUALITY ASSURANCE-HEAVY VEHICLES! AVADI
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE		TCD		DATE	
		SCALE:-	1 : 1	04 MAR 89	
		DIMENSIONS IN mm TOLERANCE ON DIMMS UNLESS OTHERWISE STATED IS:2102-69.		TITLE	WASHER
		ALL THREADS TO CONFORM TO		D S CAT NUMBER	
		ISSUE DATE	17-3-10	NATURE OF AMENDMENTS	DRAWING NUMBER 353 - 69 - 5

SIZE A3



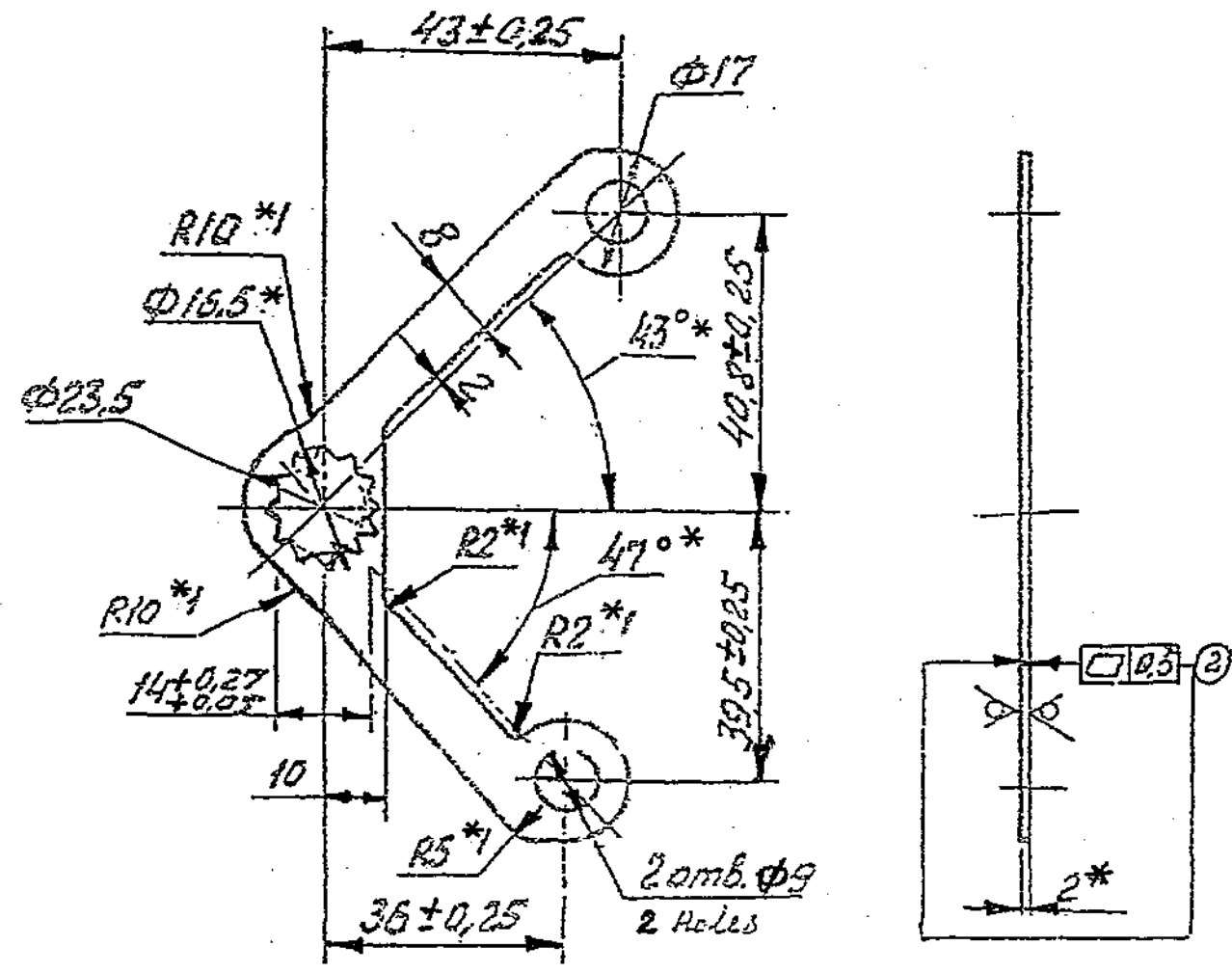
DRAWING NUMBER
353-104

SHEET No. 1 OF 1

20

Pravindray
(P. JANARDHANAN)
JTO (D)
Dt. 15 Nov '10

DRG. REINDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NIL



1. ALTERNATE MATERIAL IS STEEL 0.8 TO GOST 9045-80.
2. UNSPECIFIED TOLERANCES ON DIMENSIONS ARE TO BE MAINTAINED WITH AN ACCURACY OF 0.3mm.
3. COATING : Zn 15, Cr AS PER U/A-483-82 WITH REMOVAL OF HYDROGEN EMBRITTLEMENT
4. * DIMENSIONS FOR REFERENCE.
5. *1 DIMENSIONS ARE TO BE ENSURED WITH THE TOOL.

Ⓐ EQUIVALENT MATERIAL Gr. 0
IS: 513-1994

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

EST. WT. (Kg) TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)
0.019

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R. OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

			DRN	Sd/=	MATERIAL :- SHEET	USED ON :- Cb 418-00-6
			CHD	Sd/=	A2 GOST 19904-74	
			APPD	Sd/=	11-BF-08Mk GOST 9045-80	
			DATE	Nov 2010	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
			SCALE:- 1 : 1			
			DIMENSIONS IN mm		TITLE :- WASHER	
			TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69			
			ALL THREADS TO CONFORM TO IS : 4218, PART-4.		D S CAT NUMBER	DRAWING NUMBER
			A	13.11.10		353-104
			ISSUE	DATE	NATURE OF AMENDMENTS	

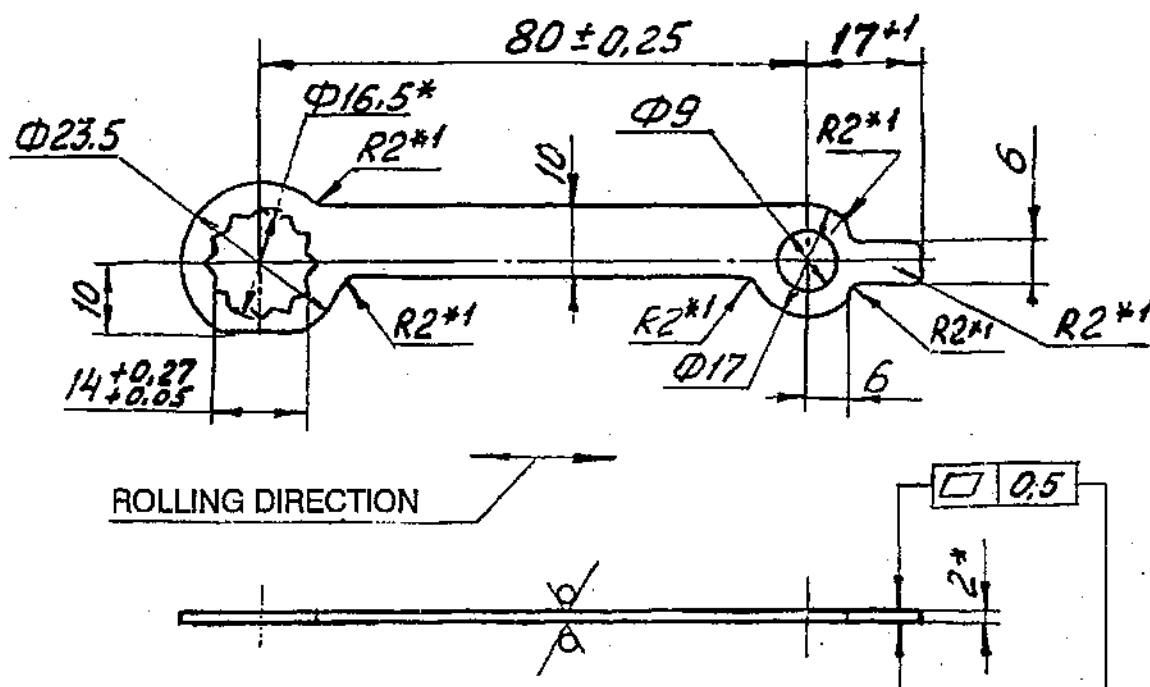
F-
SIZE A3

DRAWING NUMBER
353-105

SHEET No. 1 OF 1

20/ (✓)

ЕСКД



1. ALTERNATE MATERIAL IS STEEL 08 to GOST 9045-80.
2. UNSPECIFIED TOLERANCES ON DIMENSIONS ARE TO BE MAINTAINED WITH AN ACCURACY OF $\pm 0.3\text{mm}$.
3. COATING Zn 15 Cr AS PER UА-483-82 WITH REMOVAL OF HYDROGEN EMBRITTLEMENT.
4. * DIMENSIONS FOR REFERENCE.
5. * DIMENSIONS ARE TO BE ENSURED WITH THE TOOL.

Ⓐ EQUIVALENT MATERIAL Gr. 0
IS: 513-1994

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

EST. WT. (Kg) 0.016 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	Sd/=	MATERIAL :- SHEET	USED ON :- Cb 418-00-6
			CHD	Sd/=	A2 GOST 19904-74	
			APPD	Sd/=	11-BF-08Mk GOST 9045-80	
			DATE	Nov 2010	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
			SCALE:- 1 : 1			
			DIMENSIONS IN mm		TITLE :-	
			TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69		WASHER	
			ALL THREADS TO CONFORM TO IS : 4218,PART-4.		D S CAT NUMBER	DRAWING NUMBER
						353-105
A	13.11.10	4 th Alt. Comm. Mtg. Minutes Point No.1 Dated 26.10.09	ISSUE	DATE	NATURE OF AMENDMENTS	

Prepared by
(P. JANARDHANAN)
Dt. 15 Nov 10 JTO (D)

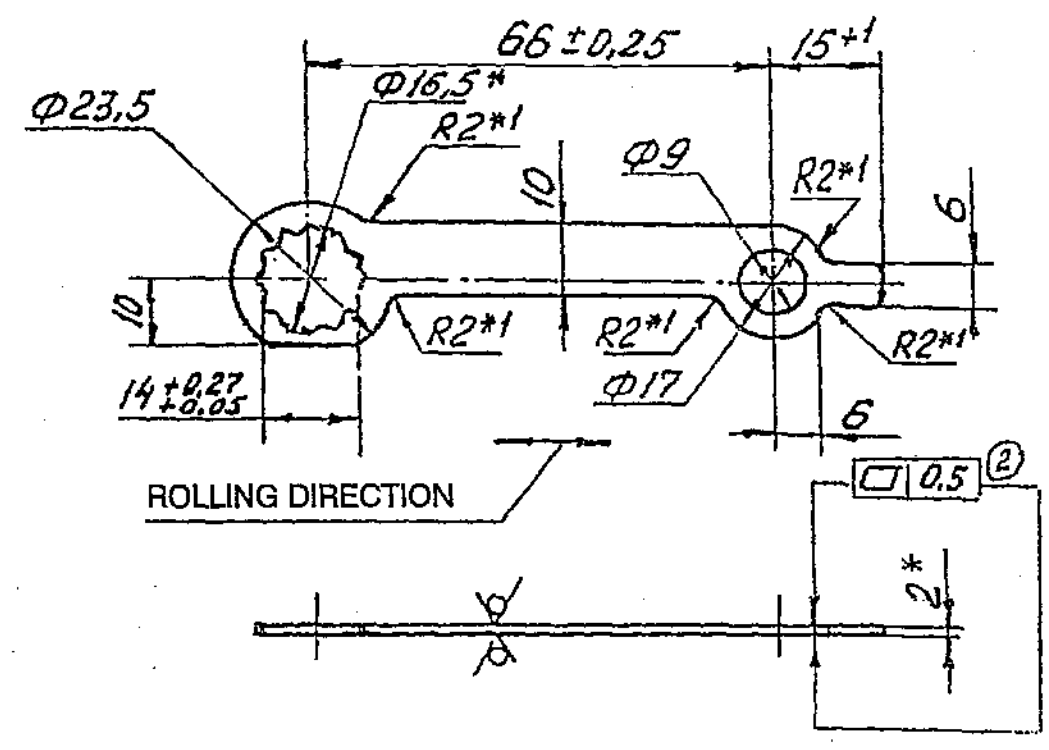
DRG. REINDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NIL

F-
SIZE A3

20/ (✓)

P. JANARDHANAN
 Dt: 15 Nov 10 JTO (D)

ECKA



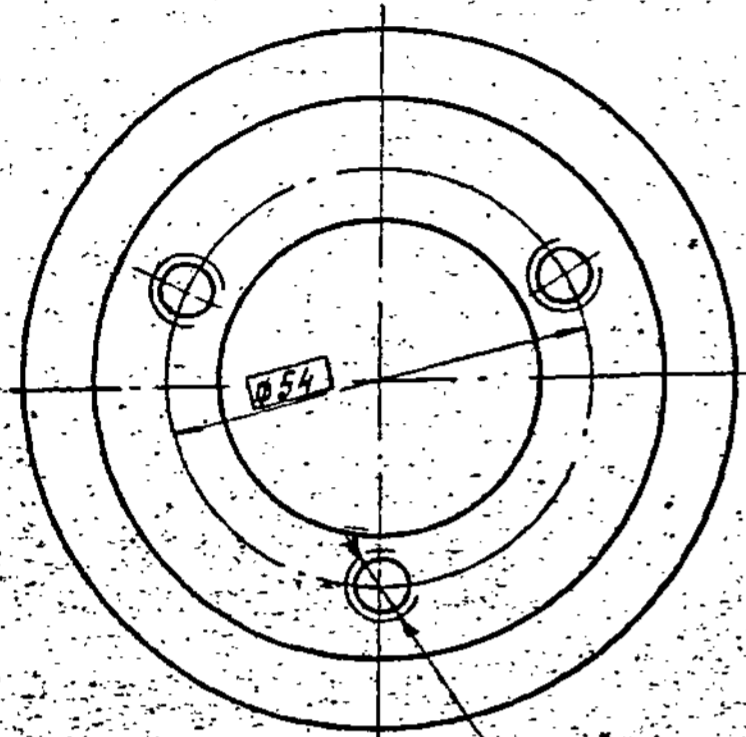
1. ALTERNATE MATERIAL IS STEEL 08 TO GOST 9045-80.
2. UNSPECIFIED TOLERANCES ON DIMENSIONS ARE TO BE MAINTAINED WITH AN ACCURACY OF $\pm 0.3\text{mm}$.
3. COATING Zn 15 Cr AS PER QA-483-82 WITH REMOVAL OF HYDROGEN EMBRITTLEMENT.
4. * DIMENSIONS FOR REFERENCE.
5. * DIMENSIONS ARE TO BE ENSURED WITH THE TOOL.

(A) EQUIVALENT MATERIAL Gr. 0
IS: 513 - 1994

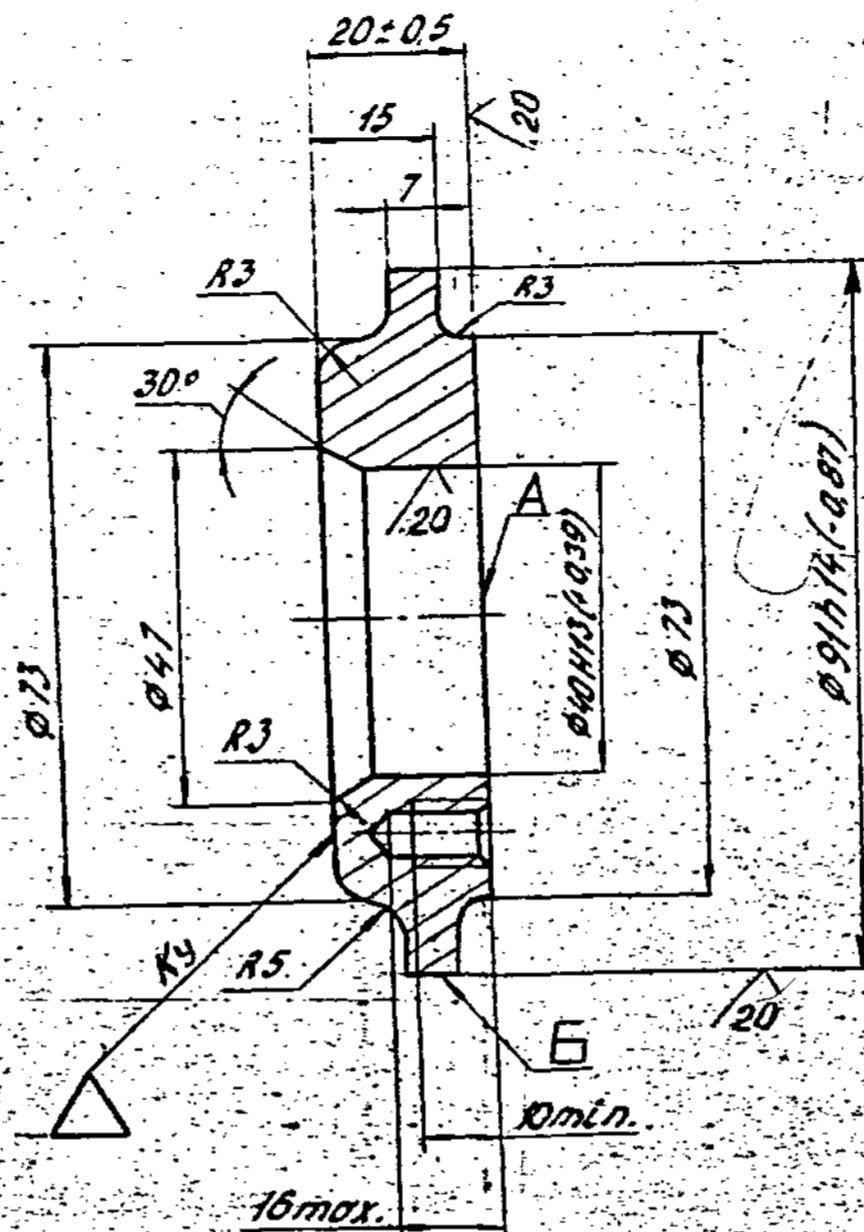
DRG. REINDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NIL

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.		DRN	Sd/=	MATERIAL :- SHEET	USED ON :- Cb 418-00-6
EST. WT. (Kg) 0.014 TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)		CHD	Sd/=	A2 GOST 19904-74	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		APPD	Sd/=	11-BГ-08Mk GOST 9045-80	
		DATE	Nov 2010	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
		SCALE:- 1 : 1		TITLE :-	
		DIMENSIONS IN mm		WASHER	
		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69			
		A	13.11.10	ALL THREADS TO CONFORM TO IS : 4218, PART-4.	D S CAT NUMBER
		ISSUE	DATE	NATURE OF AMENDMENTS	DRAWING NUMBER
					353-106

F-
SIZE A3



HOLES
30mm MB-7H



1. ALTERNATE MATERIAL STEEL GRADES CM 3KT GOST 380-71.
2. TECHNICAL REQUIREMENTS FOR THREAD ARE AS PER STANDARD 82021-00.
3. REQUIREMENTS FOR STAMPING AS PER GOST 1505-74.
4. DISPLACEMENT OF AXES OF HOLES FROM TRUE POSITION SHOULD NOT EXCEED 0.2 mm (MMC)
5. NONFLATNESS OF SURFACE A SHOULD NOT EXCEED 0.1 mm.
6. ON SURFACE A TOOL MARKS ARE ALLOWED. THROUGH RADIAL MARKS ARE NOT ALLOWED.
7. ON UNMACHINED AREAS, LOCAL DEPRESSION UP TO 0.5 mm IS ALLOWED.
8. LOCAL DECREASE OF SURFACE B TO A DEPTH UP TO 4mm WITH ROUGHNESS R_a AND SMOOTH TRANSITION IS ALLOWED.

EXPLANATORY NOTE:-

MATERIAL QUOTED: STEEL 5CT GOST 380-71
5 = CATEGORY OF STEEL (KILLED)
CT = GRADE OF STEEL

CHEMICAL COMPOSITION %

CARBON = 0.28-0.37
SILICON = 0.15-0.35
MANGANESE = 0.50-0.80
PHOSPHORUS = 0.04
SULPHUR = 0.05
CHROMIUM = 0.30
NICKEL = 0.30
COPPER = 0.30
ARSENIC = 0.08

MECHANICAL PROPERTIES:

TENSILE STRENGTH Kgf/mm^2 = 58-64
STRESS AT YIELD POINT Kgf/mm^2 = 23 (MIN)
RELATIVE ELONGATION % = 19 (MIN)

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

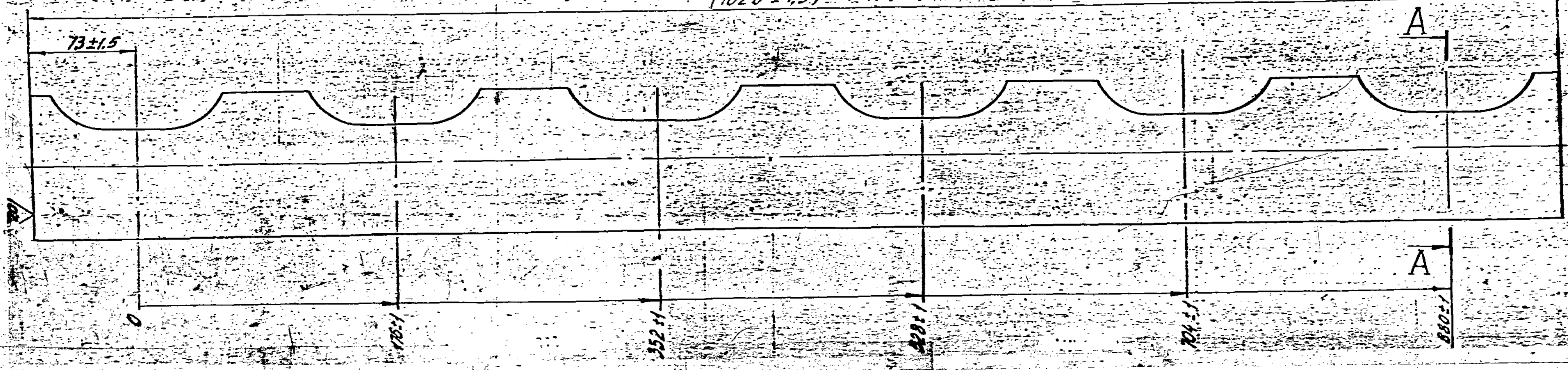
EST. WT. 0.562 kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED. UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT - SIDE R INSIDE. EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

DRN	Ganji	MATERIAL -	STEEL 5CT	USED ON	CB 418-50-29
CHD	Ganji	GOST 380-71		CB 418-51-29	
TEO	Ganji	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)			
APPD	v. Ramond	A V A D I			
DATE	2-3-92	TITLE: FLANGE			
SCALE	1:1	D S CAT NUMBER			
DIMENSIONS IN mm		DRAWING NUMBER			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69		418-11-1			
ALL THREADS TO CONFORM TO					

DRAWING NUMBER
418-23-4

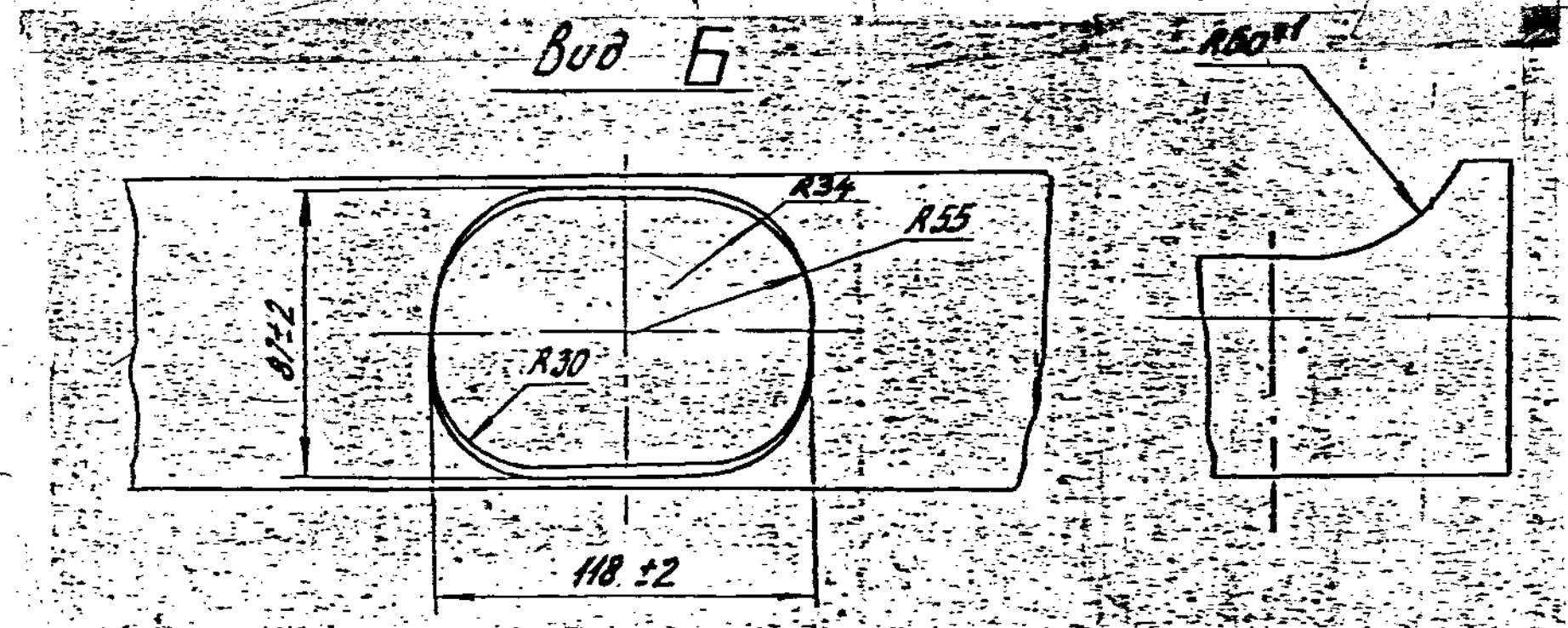
50 ✓ (✓)

(1026 ± 1.5)



VIEW B

TURNED VIEW
ALTERNATIVE



A-A

TECHNICAL REQUIREMENTS-TRANSLATION

1. Before Welding Pipe Should be Subjected to heat treatment.
2. Dimension given in brackets are to be ensured after assembly.
3. * Dimension for reference.
4. #1 Dimension to be ensured by tooling.

EXPLANATORY NOTE:-

MATERIAL QUOTED: PIPE 96x2-20A TY 14-159-21-72
 MAJOR DIAMETER = 96 mm ± 0.8 %
 WALL THICKNESS = 2 mm ± 10 %
 20A = GRADE OF STEEL
 CHEMICAL COMPOSITION %

CARBON	= 0.17-0.24	} MAXIMUM
SILICON	= 0.17-0.37	
MANGANESE	= 0.35-0.65	
CHROMIUM	= 0.25	
NICKEL	= 0.25	
SULPHUR	= 0.035	
PHOSPHORUS	= 0.035	

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

EST. WT. 4.3 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.

SCALE: 1:2	MATERIAL: PIPE 96x2-20A TY 14-159-21-72	USED ON: C5 418-50-29 C5 418-51-29
DATE: 7-4-88	CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES)	A V A D I
DIMENSIONS IN mm.	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69	TITLE: PIPE
ISSUE	DATE	NATURE OF AMENDMENTS
ALL THREADS TO CONFORM TO		D S CAT NUMBER
		DRAWING NUMBER: 418-23-4

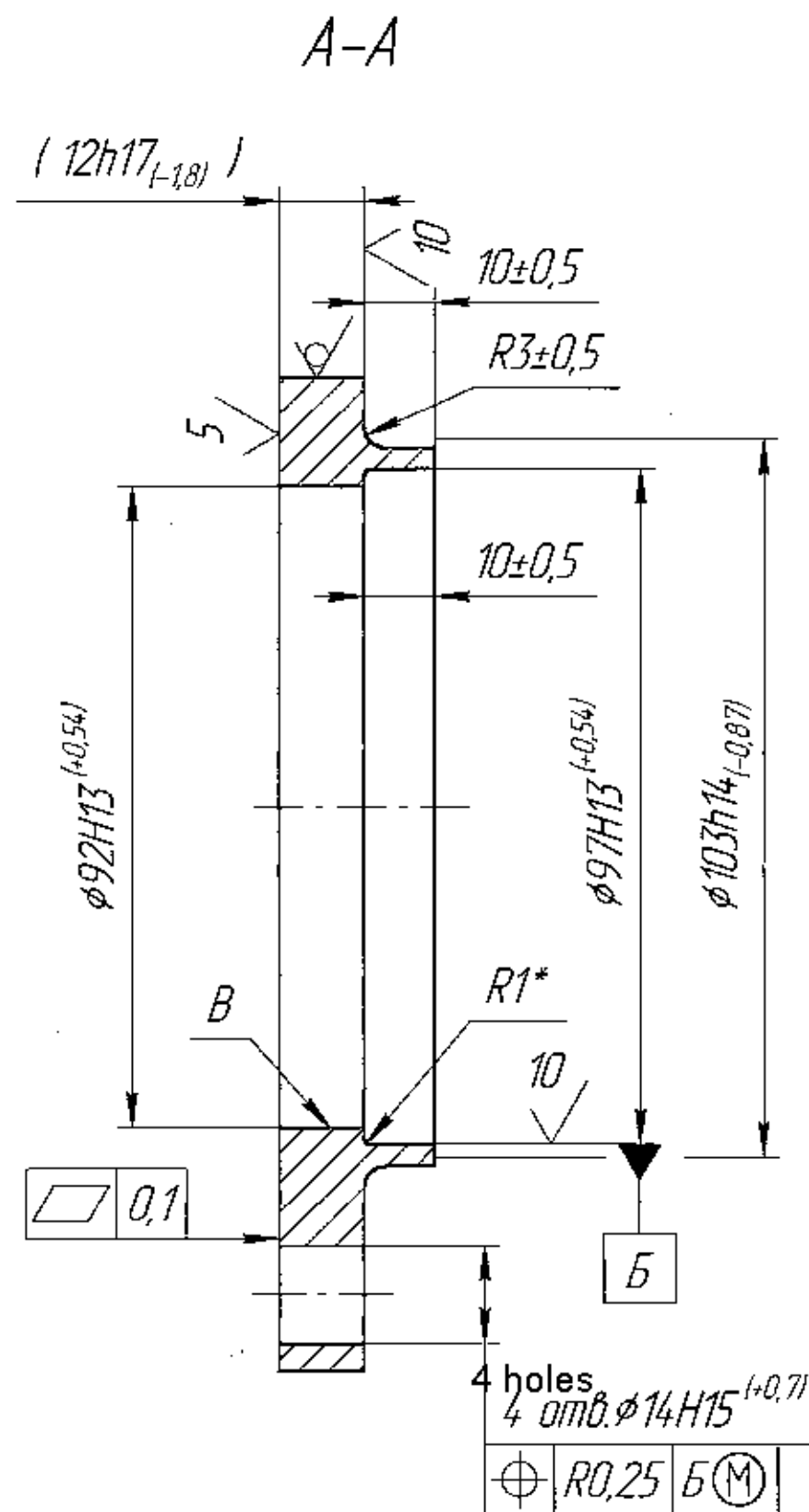
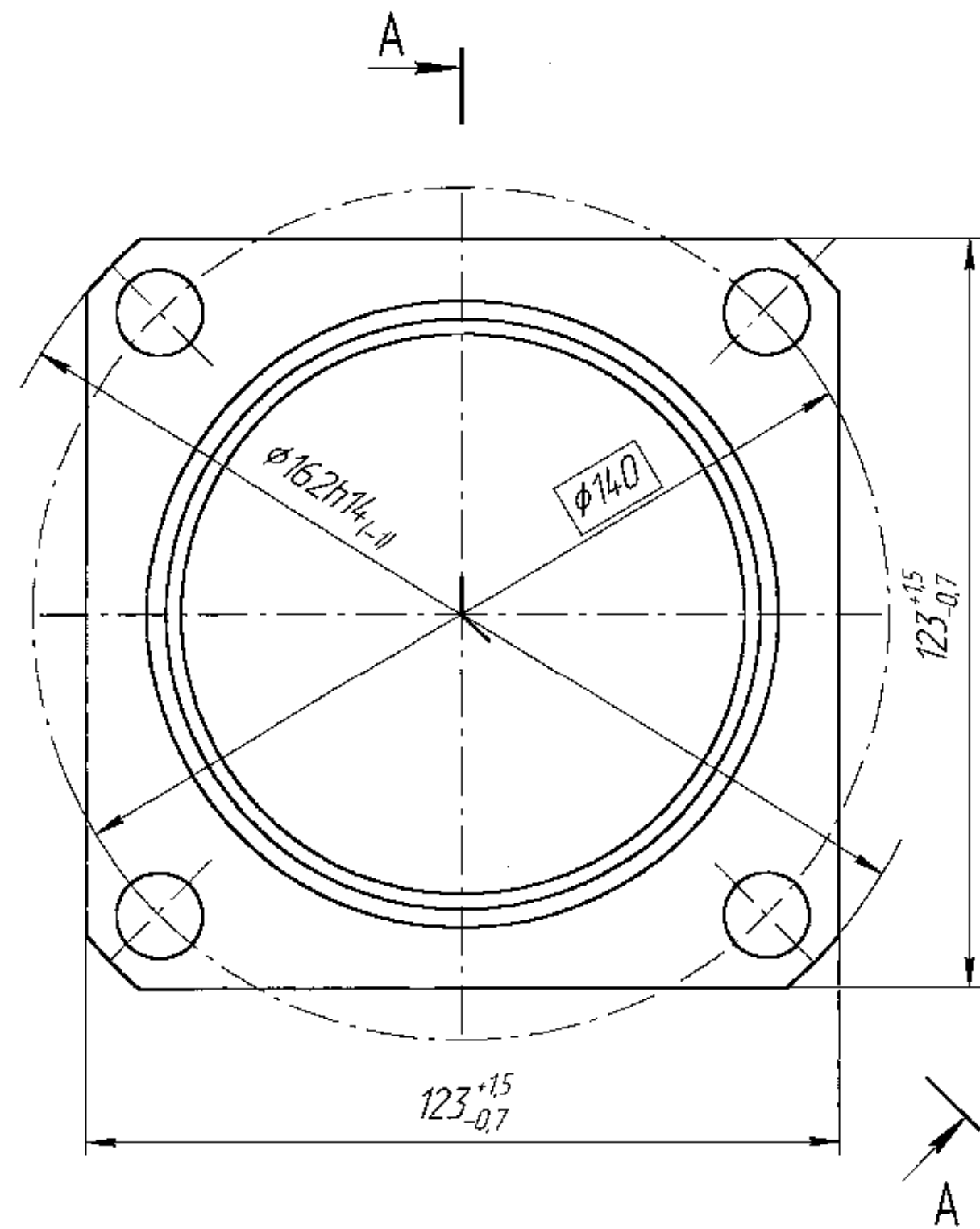
EXPLANATORY NOTE ADDED ON 18-2-92





418-55-4

20 ✓ (✓)



1. Заготовка: Поковка стальная штампованная по ГОСТ 7505-89.
2. Заменитель материала сталь 35 ГОСТ 1050-88.
3. Размер в скобках - после сборки.
4. На поверхности B допускаются следы от выхода инструмента.
5. * Размер обеспечить инструментом.
6. На необработанных поверхностях допускаются местные углубления не более 1 мм.

1. Blank: Forged blank of steel forging as per GOST 7505-89.
2. Alternative material, steel 35 GOST 1050-88.
3. Dimension in brackets - after assembly.
4. Traces of tool marks are permitted on surface B.
5. *Ensure the dimension by tool.
6. Local depressions not exceeding 1mm are permitted on un-machined surfaces.

Инд. № подл. 45083
 Подп. и дата
 Взам. инв. № Инв. № дубл.
 Подп. и дата

Doc. No.	91-331	Sign.	Date
9 Sheet	91-531	Подп.	Дата
Trans. & Ckd. by: Mts SWYAZ			
Authenticated by:			
Approved by:			
Engine Factory, Avadi			

418-55-4		
Letter	Weight	Scale
Лит.	Масса	Масштаб
A	0,718	1:1
Лист		Листов 1
Sheet		
Steel 20 GOST 1050-88 Сталь 20 ГОСТ 1050-88		

F-153 45/14

Формат А4х3