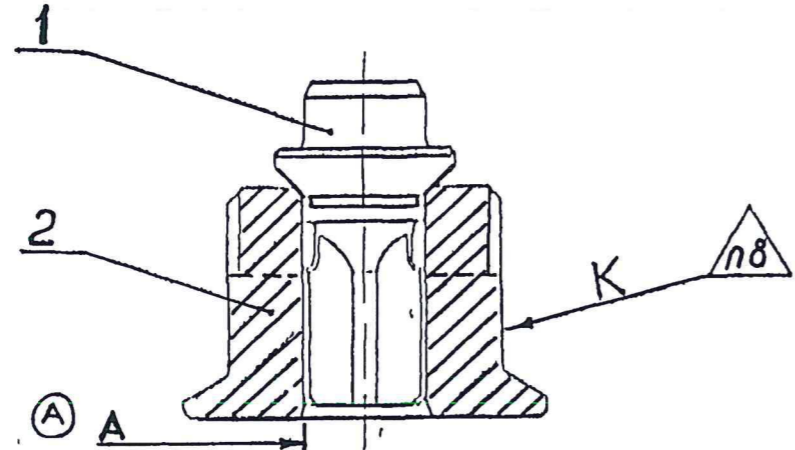


CB 3327-08-1A CB

ЕСКД

COMMON TO T-90
KVP NO 78253



- 1) DIAMETER OF HOLE OF LAPPED VALVE SEAT SHOULD BE 0 ± 0.05 mm.
- 2) LAPPED COMPONENTS VALVE AND VALVE SEAT MAKE UP A PAIR, IN WHICH REPLACEMENTS BY ANY COMPONENT FROM OTHER PAIR IS NOT ALLOWED.
- 3) ROUGHNESS OF LAPPED SURFACES SHOULD NOT BE WORSE THAN STANDARD.
- 4) VALVE MOVEMENT IN THE SEAT AS PER STANDARD.
- 5) THE PAIR SHOULD BE PRESURE-TESTED WITH AIR AT A PRESSURE OF 4 TO 7 Kgf/cm² PRESSURE TESTING AT A PRESSURE OF 4 . . 5,5 Kgf/cm² SHOULD BE CARRIED OUT FOR 15 SECOND AND AT A PRESSURE OF 5,5 . . 7 Kgf/cm² FOR 10 SECONDS.
- 6) CHECKING FOR TIGHTNESS AT CHAMFERS, SHOULD BE CARRIED OUT ON A SPECIAL FIXTURE WITH THE USE OF STANDARD PAIR IN ACCORDANCE WITH INSTRUCTIONS UB 47-1 BY A MIXTURE OF OIL AND DIESEL FUEL HAVING ANGLER VISCOSITY 1.9 ± 0.1 AT A TEMPERATURE OF 50°C.
 - a) BEFORE FILLING UP OF THE TANK THE MIXTURE SHOULD BE MIXED WELL.
 - b) BEFORE TEST THE PAIR SHOULD BE THOROUGHLY WASHED IN FILTERED DIESEL FUEL THERE SHOULD NOT REMAIN ANY PETROLATUM OR OTHER TYPES OF LUBRICANT ON THE VALVE AND SEAT SURFACES.
 - c) THE PAIR IS CONSIDERED FIT FOR SERVICE, IN CASE, THE TIME OF LOAD FALLING IS THE SAME AS THAT OF THE STANDARD PAIR LOAD.
- 7) PRESERVATION AND STORAGE OF PAIRS IN ACORDANCE WITH INSTRUCTION, I. ИЦЛ-1251, DEPENDING ON THE TERM OF STORAGE.
- 8) TO BE MARKED WITH PANTOGRAPH.

(A) 9. ROUGHNESS OF SURFACE A OF ITEM 1 SHOULD BE 0.32 AFTER LAPPING.

1. Диаметр отверстия доведенного седла клапана 0 ± 0.05 мм.
2. Притертые детали, клапан и седло клапана, составляют пару, в которой замена одной детали какой-либо деталью из другой пары не разрешается.
3. Шероховатость доведенных поверхностей не ниже эталона.
4. Движение клапана в седле по эталону.
5. Испытание на герметичность производить воздухом под давлением 0,4...0,7 МПа (4...7 кгс/см²). Испытание на герметичность производить под давлением 0,4...0,55 МПа (4...5,5 кгс/см²) в течение 15 с, под давлением 0,55...0,7 МПа (5,5...7 кгс/см²) - в течение 10 с.
6. Приемка на плотность по пояску производится на специальном приспособлении по эталонной паре согласно инструкции ИВ-47-1 на смеси масла и дизельным топливом, имеющей вязкость $1,9 \pm 0,1$ по Энглеру при 50 °С:
 - а) смесь перед заливкой в бак хорошо перемешать;
 - б) перед испытанием пару тщательно промыть в профилированном дизельном топливе. Не допускается наличие на поверхностях клапана и седла вазелина или других видов смазки;
 - в) пару считать годной по плотности в том случае, если падение груза произойдет за время не менее показания эталона.
7. Консервация и хранение пар по инструкции ИЦЛ-1251 в зависимости от срока хранения.
8. Клеить электроискровым способом.

** CB 327-00-47-01 (C)

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

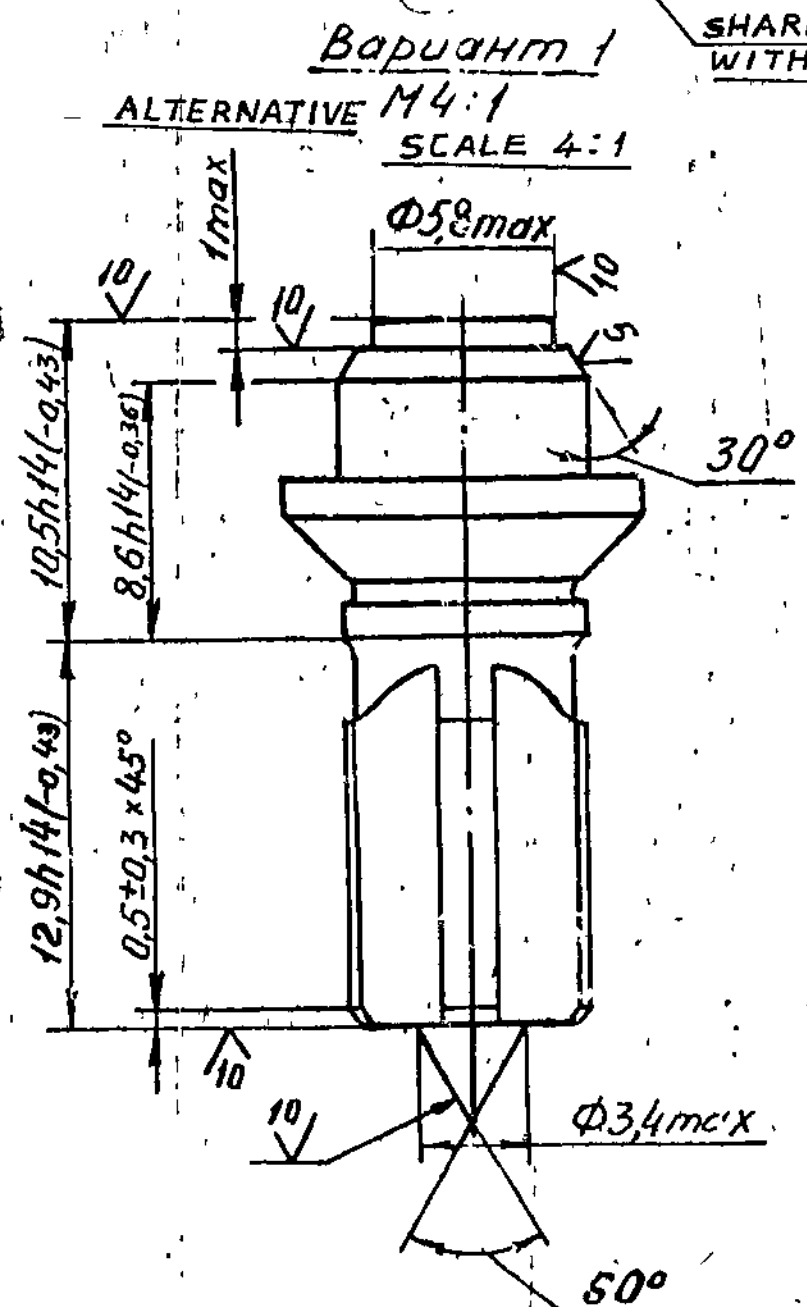
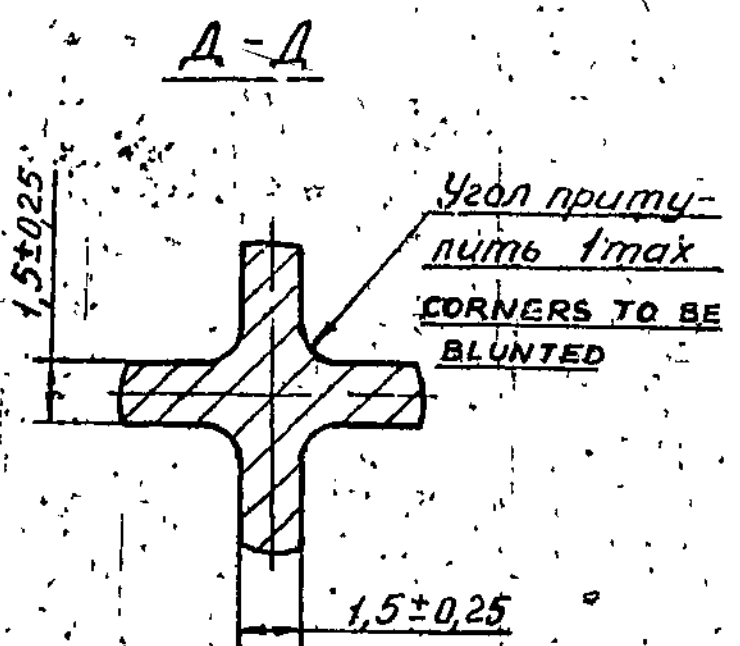
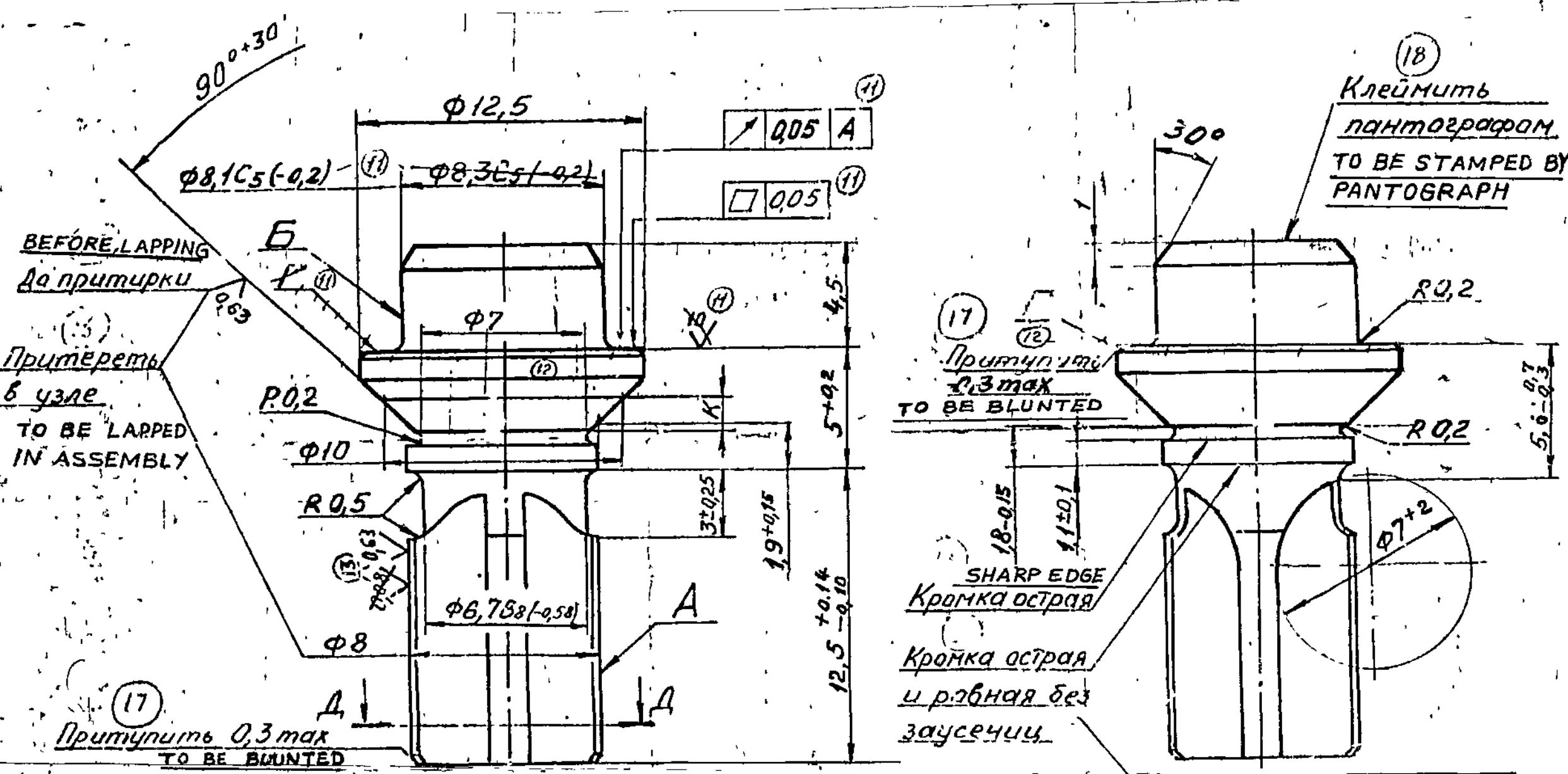
D	05.11.20	D.O. CORRECTION	ESL, PMS	TO BE STAMPED OR MARKED WHERE INDICATED THIS #
C	13.7.19	USED ON NUMBER ADDED.	0,031 Kg.	(1) (11111)
B	7.5.10	USED ON ADDED		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE (D)
A	3.2.97	AUTHORITY No BK 88-387		USED ON: 375-36-029CB (B) ** CB 327-00-45
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL	
DRN		SCALE: 2 : 1		CONTROL URATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A D I
CHK		DIMENSIONS IN mm		
TCU		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED		(D) DELIVERY DISCHARGE VALVE ASSY
APPD				
DATE	19-2-88	ALL THREADS TO CONFORM TO	D.S CAT NUMBER	DRAWING NUMBER CB 3327-08-1A CB

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE No. 2 BK 85-815.

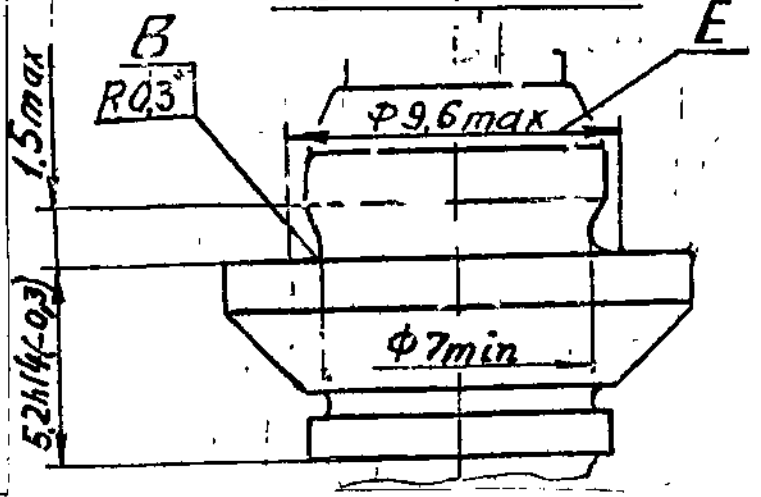
DRAWING NUMBER
3327-59-1A

5 (V)

- CONTROL GROUP III ACCORDING TO TT-11.
- HRC₃ ≥ 60 ; HRC₃ ≥ 57 IS ALLOWED ON THE UPPER AND LOWER FACES AFTER FINAL GRINDING. THE HARDNESS CAN ALSO BE CHECKED BY A TEST FILE WITH RANDOM INSPECTION ACCORDING TO ROCK WELL.
- MAINTAIN THE DIMENSIONS ACCORDING TO 7th CLASS OF ACCURACY OST-1010.
- ENSURE TAPER OF THE SURFACE 'A' WITHIN THE LIMITS 0.007... 0.012 mm WITH LARGE DIAMETER FROM THE SIDE OF THE CONE 90°+30'.
- RUN-OUT OF THE SURFACE 'B' RELATIVE TO THE SURFACE 'A' NOT MORE THAN 0.15 mm.
- DO NOT BLUNT THE EDGE 'Г'. BURRS ARE NOT ALLOWED.
- TRACES OF GRINDING ARE NOT ALLOWED ON THE LAPPED SURFACE 'A'; COMPARE WITH THE STANDARD.
- MAINTAIN THE ANGLE 90°+30' AND ROUGHNESS OF THE SURFACE OF THE CONE 90°+30' ON THE SECTION 'K'.
- SHARP EDGES, EXCEPT THOSE INDICATED ON THE DRAWING ARE NOT ALLOWED.
- COATING, CHEMICAL OXIDIZING WITH OIL FINISH, EXCEPT THE SURFACE 'A' AND THE CONE. LOCAL DAMAGES OF THE COATING ARE ALLOWED DURING MACHINING.
- RADIUS 'B' SHOULD NOT GO BEYOND THE LIMITS Ø E.
- * DIMENSION IS TO BE ENSURED BY TOOL.



Вариант 2
ALTERNATIVE 2



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

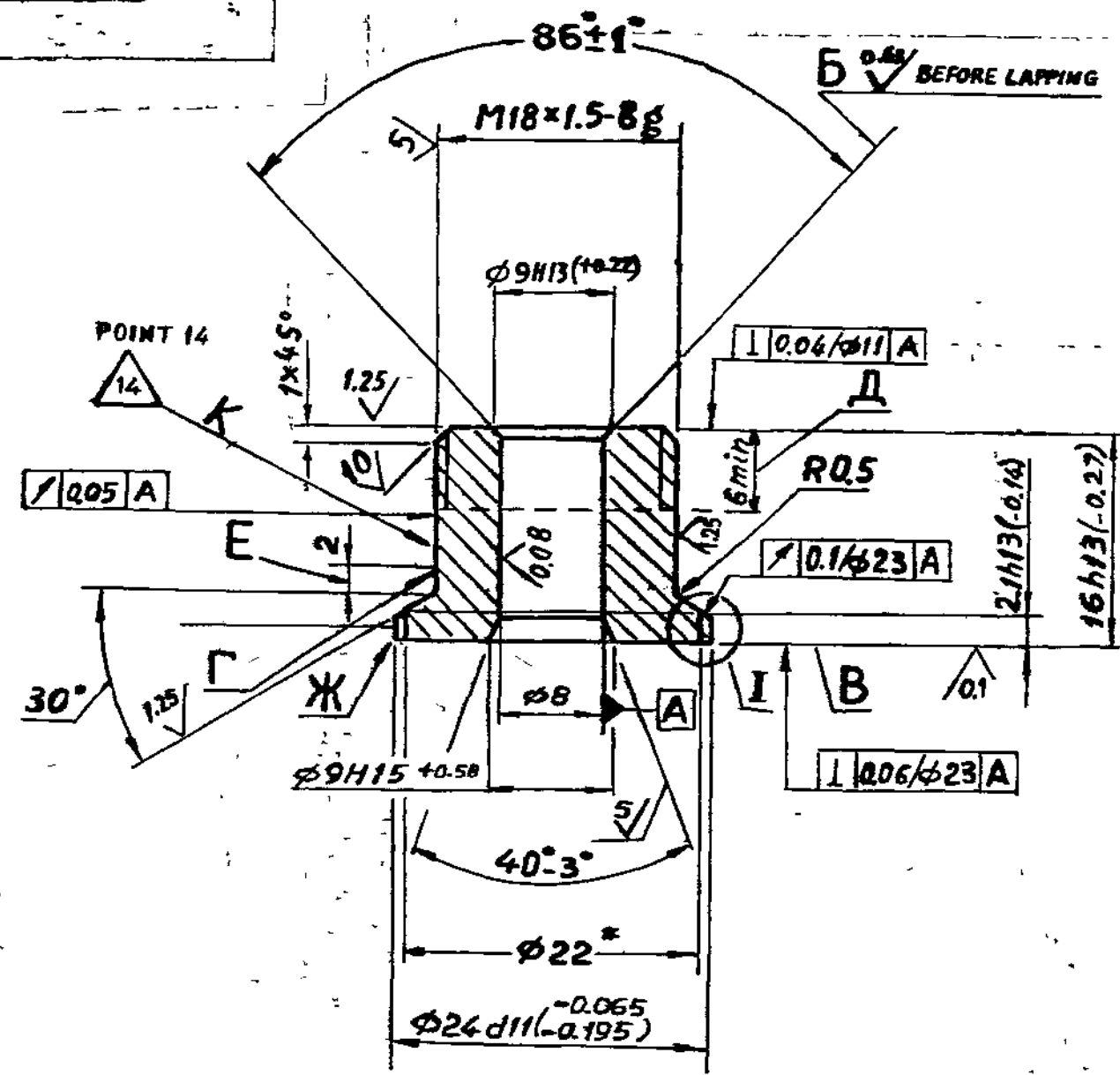
EST. WT. 0.006 kg
TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFER; ARE PERMISSIBLE.

DRN	CHC	TCD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-67	MATERIAL - STEEL	USED ON :-	
				30.05.97	5:1			W X 10 GOST 801-78	CS 3327-08-1A	
CONTRILLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A 01							TITLE : DELIVERY VALVE			
ISSU. DATE							D S CAT NUMBER		DRAWING NUMBER	
C 30-6-97 AUTHY BK No: 86-721A, DC 387									3327-59-1A	
NATURE OF AMENDMENTS										

COMMON TO T-90

1-09-12EE

(V)



ALTERNATIVE M5:1



1. CONTROL GROUP III ACCORDING TO TT-11.
2. HRC₃ = 62 64 .
3. UNINDICATED LIMIT DEVIATIONS OF DIMENSIONS H14, ±IT14
4. SURFACES A AND B ARE LAPPED IN THE ASSEMBLY UNIT.
5. TRACES OF GRINDING ARE NOT ALLOWED ON THE LAPPED SURFACES A AND B, THE PRESENCE OF INSIGNIFICANT, HARDLY VISIBLE MARKS ARE ONLY ALLOWED. COMPARE WITH THE STANDARD.
6. GRIND THE SCREW THREAD AND SURFACE Γ UPTO $\phi 17f9(-0.018/-0.059)$ mm. $\phi 17d11(-0.05/-0.16)$ mm ALLOWED ALONG THE LENGTH OF THE THREAD Δ.
7. CHECK THE STRAIGHTNESS OF THE FACE B BY A TOOLMAKERS STRAIGHT EDGE OF THE CLASS OF ACCURACY 0, GOST 8026-75; CLEARANCE NOT ALLOWED.
8. SCUFFING FROM THE FRICTION OF THE FACE AGAINST THE MANDREL IS ALLOWED ON FACE B
9. ENSURE THE TAPER OF THE SURFACE A WITHIN THE LIMITS 0.001 ... 0.003 mm AGAINST THE LARGE DIAMETER FROM THE SIDE OF THE FACE A.
10. COMING OUT OF THE SCREW THREAD ON THE SECTION E IS NOT ALLOWED.
11. BLUNT THE EDGE * BY THE RADIUS OR CHAMFER NOT MORE THAN 0.5 mm.
12. COATING OF CHEMICAL OXIDIZING WITH OIL FINISHING EXCEPT ON SURFACES A, B, B. LOCAL DAMAGE OF THE COATING IS ALLOWED DURING MACHINING.

13. SPOTS OF BLACK TRACES FROM A PRECEDING OPERATION ARE ALLOWED ON THE SCREW THREAD.
14. STAMPING BY PUNCHING .
15. * DIMENSIONS FOR REFERENCE .

EXPLANATORY NOTE

THE COMPONENT SHOULD BE MANUFACTURED FROM HOT ROLLED CALIBERATED ROUND WITH SPECIAL SURFACE FINISH BALL BEARING STEEL GRADE WX15 TO GOST 801-78.

CHEMICAL COMPOSITION % :- AS PER GOST 801-78.

STEEL GRADE	C	Si	Mn	Cr	S	P	Ni	Cu	Ni+Cu
WX15	0.95-1.05	0.17-0.37	0.20-0.40	1.30-1.65	0.02	0.027	0.30	0.25	0.5

HARDNESS :- MB 179 TO 207 INDENTATION DIAMETER 4.5 TO 4.2mm

DRO INTRODUCED VIDE NOTN NO. BK 05-814 COMMON TO T-90

A8

EST. MASS 0.025 Kg		TO BE STAMPED OR MARKED WHERE INDICATED THIS BY LETTERS	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED ROUNDED CORNERS TO HAVE A OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE			
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL	STEEL WX15 USED IN GOST 801-78
SCALE	2:1	CONTROL	STATE OF QUALITY ASSURANCE (HEAVY VEHICLES)
TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED	TITLE DELIVERY VALVE SEAT		
ALL THREADS TO CONFORM TO	DRAWING NUMBER	3327-60-1	

3.12	15087-125	12/12/78
5.12	15087-125	12/12/78
5.13	15087-125	12/12/78
5.14	15087-125	12/12/78