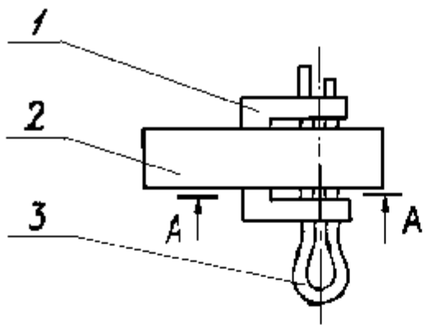
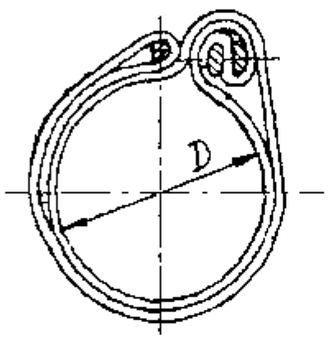
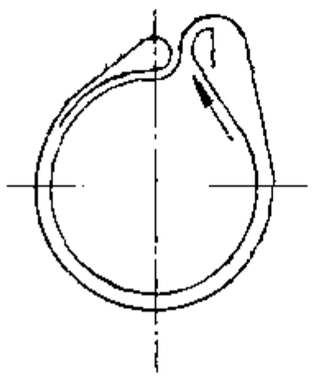
672-54-Sb2Sb



A - A



Band winding diagram



DESIGNATION	HOSE OUTER DIA, mm	MASS kg	DESIGNATION	HOSE OUTER DIA, mm	MASS kg
672-54-Sb 2	13 - 16	0.019	672-54-Sb 2-18	97 - 103	0.04
-01	17 - 20	0.019	-19	113 - 120	0.044
Ⓐ DS CAT. No. LV2/ICVS 4730 071487 -02	21 - 24	0.021	-20	121 - 130	0.046
-03	25 - 28	0.022	-21	230 - 235	0.072
-04	29 - 32	0.022	-22	310 - 318	0.095
Ⓐ LV2/ICVS. 4730 071489 -05	33 - 35	0.023			
-06	37 - 40	0.024			
Ⓐ LV2/ICVS. 4730 071488 -07	41 - 44	0.025			
Ⓐ LV2/ICVS 4730 071485 -08	45 - 48	0.026			
-09	49 - 52	0.026			
Ⓐ LV2/ICVS 4730 071483 -10	53 - 56	0.027			
-11	57 - 60	0.028			
Ⓐ LV2/ICVS 4730 071484 -12	61 - 64	0.029			
-13	65 - 68	0.03			
-14	77 - 80	0.033			
-15	81 - 84	0.033			
-16	85 - 88	0.034			
-17	93 - 96	0.037			

(3) when the clampis tightened, one end of band 2 should have at least two turns on cotter pin 3 and its second end should be unbent at approxmatel 1/4 of the hose circumference length.

DC(I)No. & DATE	ISSUE	AMENDMENTS
01047-ICV 18-07-07	Ⓐ	DS CAT PART No. ADDED AND NOMENCLATURE WAS "CLAMP HOSE".

APPROVED	
CHECKED	
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	

672-54-Sb2Sb

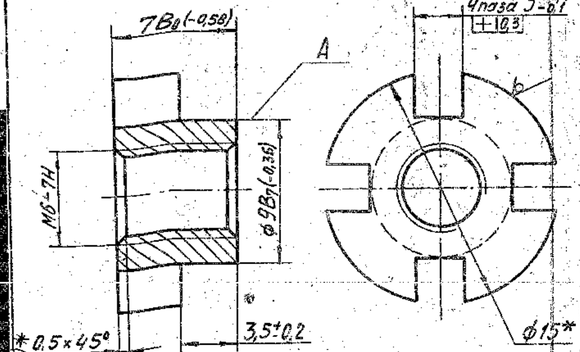
MULTIPURPOSE CLAMP

WEIGHT	SCALE
SEE TABLE	SEE TABLE

SHT 1 SHTS 1

A3

8-05-269



TECHNICAL CONDITIONS

*(1) Four grooves
*(2) Two chamfers
*(3) 1. Substitute for material - steels 25, 30, 35, 40 POCT 1050-74.
2. Incision into surface A not in excess of 0.3 mm is tolerable
3. *Size is given for reference.

APPROVED		672-30-8	
CHECKED			
CONTROLLERATE OF INSPECTION (ICV)	NUT	WEIGHT	SCALE
		0.002	5:1
	ROUND BAR 15(5) GOST 7417-75 20 GOST 1050-74	SHT	SHTS

8-05-269

672-30-8

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

1 NUT SHOULD BE MADE FROM STEEL GRADE 20, DIA 15 mm. CLASS OF ACCURACY 5 AS PER GOST-7417-75

2 CHEMICAL COMPOSITION AS PER GOST-1050-74 IS GIVEN BELOW:
CARBON - 0.17 - 0.24%
SILICON - 0.17 - 0.37%
MANGANESE - 0.35 - 0.65%
CHROMIUM - 0.25 (MAX).

3 MECHANICAL PROPERTIES OF STEEL GRADE 20 CONFORMS TO GOST-1050-74 ARE AS GIVEN BELOW:
YIELD POINT - 25 Kgf/mm² (MIN).
ULTIMATE TENSILE STRENGTH - 42 Kgf/mm² (MIN).
PERCENTAGE ELONGATION - 25% (MIN).
REDUCTION OF AREA - 55% (MIN.)
HARDNESS - 163 BHN (MAX).
RECOMMENDED HEATING TEMPERATURE DURING HEAT-TREATMENT PROCESS IS GIVEN BELOW:
NORMALISING - 900°C.
RECOMENDED MINIMUM HOLDING PERIOD:-
INCASE OF NORMALISING OR HARDENING - 30 MINUTES

4 ALTERNATE MATERIAL MAY BE MANUFACTURED FROM STEEL GRADES 25, 30, 35, 40 TO GOST-1050-74 HAVING THE FOLLOWING CHEMICAL COMPOSITION:-

STEEL GRADE	CARBON %	SILICON %	MANGANESE %	CHROMIUM %
25	0.22-0.30	0.17-0.37	0.50-0.80	0.25 (MAX).
30	0.27-0.35	0.17-0.37	0.50-0.80	0.25 (MAX).
35	0.32-0.40	0.17-0.37	0.50-0.80	0.25 (MAX).
40	0.37-0.45	0.17-0.37	0.50-0.80	0.25 (MAX).

5 MECHANICAL PROPERTIES OF STEEL GRADE 25, 30, 35, 40 OF GOST-1050-74 ARE AS FOLLOWS:-

STEEL GRADE	YIELD POINT Kgf/mm²	ULTIMATE TENSILE STRENGTH Kgf/mm²	PERCENTAGE ELONGATION %	REDUCTION OF AREA %	IMPACT STRENGTH Kgfm/cm²
25	28 (MIN)	46 (MIN.)	23	50	9
30	30 (MIN)	50 (MIN.)	21	50	8
35	32 (MIN.)	54 (MIN.)	20	45	7
40	34 (MIN.)	58 (MIN.)	19	45	6

HARDNESS WITHOUT HEAT TREATMENT 25, 30, 35, 40 ARE AS GIVEN BELOW:-

STEEL GRADE	25	30	35	40
B.H.N. (MAX.)	170	179	207	217

RECOMMENDED HEATING TEMPERATURE DURING HEAT TREATMENT OF BLANKS FOR CARRYING OUT THE TESTS OF MECHANICAL PROPERTIES ARE GIVEN BELOW:-

STEEL GRADE	25	30	35	40
NORMALISING	890°C	880°C	860°C	870°C

RECOMMENDED MINIMUM HOLDING PERIOD:-
IN CASE OF NORMALISING OR HARDENING - 30 MINUTES.

6 DIMENSIONS AS PER GOST-7417-75:-
1) DIA. OF ROUND BAR - 15 mm.
2) TOLERANCE OF BAR - -0.240 mm.
3) CLASS OF ACCURACY - 5
4) CROSS SECTION AREA - 176.5 mm²
5) WT. OF 1 M. LENGTH - 1.387 Kg.

7 SURFACE FINISH:-
▽ - SPECIFIED ROUGHNESS TO BE OBTAINED BY WITHOUT REMOVAL OF MATERIAL.
+0.3 - DETAIL NOT GIVEN IN SYMBOL BOOK.
Rz 80 (▽) - SPECIFIED ROUGHNESS TO BE OBTAINED BY MACHINING, THE Rz VALUE OF SURFACE FINISH TO BE OBTAINED BY MACHINING IS NOT MORE THAN 80 MICRONS.

DC(1)	DT	ZONE	BRIEF RECORD	SIGN.

INSCRIBED	
CHECKED	
APPROVED	
DATE	30.7.64
TOLERANCE UNLESS OTHER WISE SPECIFIED. GEN. DEC. ANG.	

D.R.G. NOT TO BE SCALED.
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.
ALL DIMENSIONS ARE IN MM. UNLESS OTHER WISE SPECIFIED.

PARTAINS TO

NUT

672-30-8

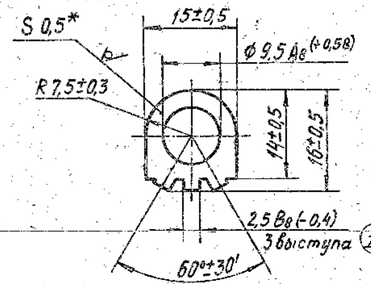
SCALE:-

CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT. PUNE.

672-31-11

Rz 320 (√)

Восстановленный подлинник №1



*(1). Three projections

1. Substitute for material - cr.5 ГОСТ 380-71 and steels 15, 20 ГОСТ 1050-74.
2. Coating: zinc 9 Cr. Remove hydrogen embrittlement.
3. Unspecified radii - 0.3 mm, maximum.
4. *Size is given for reference.

APPROVED		672-31-11	
CHECKED			
CONTROLLERATE OF INSPECTION (ICV)	LOCK WASHER	WEIGHT 0·001	SCALE 2:1
		SHT 1	SHTS 1
	A0·5 GOST 19904-74 5-II-Г-10 GOST 16523-70		

Копировал Формат А4

11-IE-219

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

1. LOCK WASHER SHOULD BE MANUFACTURED FROM COLD ROLLED SHEET STEEL OF DEEP DRAWN QUALITY, GRADE 10 CONFORMING TO GOST-16523-70

2. CHEMICAL COMPOSITION

CHEMICAL COMPOSITION OF QUALITY CARBON STEEL GRADE 10, CONFORMING TO GOST-1050-74 (AS REFERRED IN GOST 16523-70) SHOULD BE AS FOLLOWS :-
CARBON — 0·7 - 0·14%
SILICON — 0·17 - 0·37%
MANGANESE — 0·35 - 0·65%
CHROMIUM — 0·15% (MAX).

3. MECHANICAL PROPERTIES :-

1) THE MECHANICAL PROPERTIES OF STEEL GRADE 10 CONFORMING TO GOST - 16523-70 SHOULD BE AS FOLLOWS :-
   a) TENSILE STRENGTH — 30 - 42 Kgf/mm²
   b) RELATIVE ELONGATION - 25% (MIN.)
2) DEPTH SPHERICAL HOLE DURING CUPPING TEST OF STEEL SHOULD CORRESPOND TO NORMS GIVEN BELOW :-
   DEPTH OF SPHERICAL HOLE - 5·0 mm (MIN.)
3) GRAIN SIZE FOR THE COLD ROLLED STEEL SHOULD NOT BE COARSER THAN 6TH NUMBER
4) STEEL SHOULD WITH STAND BENDING TEST OVER 180° IN COLD STATE WITH THICKNESS OF PACKINGS (SUPPORTS) IS 0
5) STEEL SHOULD BE HEAT TREATED.
6) THE SURFACE SHOULD HAVE FINISH NOT BELOW CLASS 6B (Rz = 0·8 MICRONS)

ALTERNATE MATERIAL :-
STEEL GRADE 15, 20 CONFORMING TO GOST - 1050-74

4. CHEMICAL COMPOSITION :-
CHEMICAL COMPOSION IS AS FOLLOWS :-

STEEL GRADE	CONTENT OF ELEMENTS %			
	CARBON	SILICON	MANGANESE	CHROMIUM
15	0·12 - 0·19	0·17-0·37	0·35 - 0·65	0·25 (MAX)
20	0·17 - 0·24	0·17-0·37	0·35 - 0·65	0·25 (MAX)

5. MECHANICAL PROPERTIES :-
MECHANICAL PROPERTIES OF STEEL GRADE 15, 20 CONFORMING TO GOST- 1050-74 ARE AS FOLLOWS :-

MECHANICAL PROPERTIES	STEEL GRADE	
	15	20
HEAT-TREAMENT OF BLANKS	NORMALISING	NORMALISING
YIELD POINT	23 Kgf/mm²	25 Kgf/mm²
ULTIMATE TENSILE STRENGTH	38 Kgf/mm²	42 Kgf/mm²
PERCENTAGE ELONGATION	27%	25%
REDUCTION OF AREA	55%	55%

6. HARDNESS - (WITHOUT HEAT TREATMENT OF STEEL)

STEEL GRADE
15 - 149 BHN (MAX).
20 - 163 BHN (MAX).

7. RECOMMENDED HEATING TEMPERATURE DURING HEAT TREATMENT OF BLANKS FOR CARRYING OUT TESTS OF MECHANICAL PROPERTIES ARE AS GIVEN BELOW :-

STEEL GRADE	HEATING TEMP °C (NORMALISING)
15	900
20	900

RECOMMENDED MINIMUM HOLDING PERIOD INCASE OF NORMALISING - 30 MINUTES

8. SURFACE FINISH :-
1) Rz 320 (√) : INDICATES SURFACE FINISH OF (Rz VALUE 320 MICRONS (MAX) ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.
2) ▽ : INDICATES SURFACE FINISH TO BE OBTAINED WITHOUT REMOVAL OF MATERIAL.

												INSCRIBED	
												CHECKED	
												APPROVED	
												DATE	31.7.86
												TOLERANCE UNLESS OTHERWISE SPECIFIED	
DC (D)	DT.	ZONE	BRIEF RECORD								SIGN.	GEN	DEC	ANG.

DRG. NOT TO BE SCALED
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF
ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE SPECIFIED

PARTAINS TO

LOCK WASHER

672-31-11

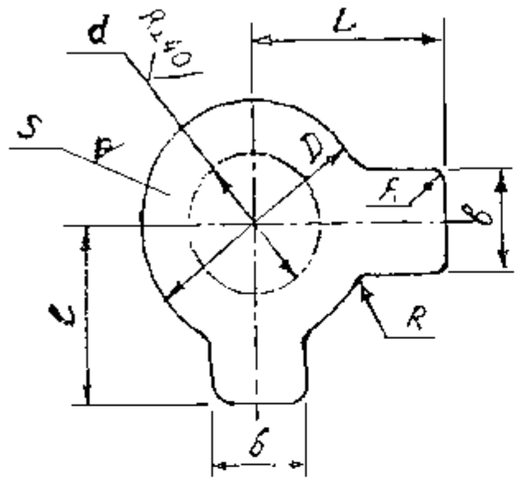
SCALE

CONTROLLERATE OF INSPECTION FIRE FIGHTING EQUIPMENT

14-A1

672-31-71

R 320



Designation	d, MM	D, MM	L, MM	l, MM	B, MM	S, MM	R, MM	Mass in Kg
672-31-71	$6.4^{+0.36}$	14	15	10	6	1	2	0.002
-01	$8.4^{+0.36}$		18	12	7			0.002
-02	$10.5^{+0.43}$	18	20	14	8			0.002
-03	$13^{+0.43}$	22	25	20	10	1.5		0.005

THE ABBRIVATIONS AND SYMBOLS ARE BASED ON RUSSIAN SPECIFICATIONS.

ALL DIMENSIONS ARE IN mm.

TECHNICAL CONDITIONS

1. Alternate material is steel 08кп 10kп, GOST 1050-74.
2. Unspecified limit deviations are ±0.5 mm
3. Misalignment of circumfarence D with respect to hole d and asymmetry of tabs with respect to axis of hole d should be 1mm.
4. Coating: Zinc-plated, 9 microns thick, chromatized Remove hydrogen embrittlement.

(A) ALTERNATE MATERIAL – STEEL Gde Fe 330 TO IS:1079-88

(B) EQ.MATERIAL – COLD ROLLED STEEL SHEET GRADE D/DD TO IS: 4030-74

(C) EQ.MATERIAL - STEEL GRADE - 'D' TO IS 513-86 FOR 672-31-71-02 AND 672-31-71-03.

DC(I)No. & DATE	ISSUE	AMENDMENTS
00862-ICV 31 MAY 01	(C)	EQ. MATERIAL ADDED.
00769-ICV 7 MAR 2000	(B)	EQ. MATERIAL ADDED.
00561-ICV 14 MAY 96	(A)	ALTERNATE MATERIAL ADDED. (1/96 N OF A)

GOLD ROLLED STEEL SHEET
Gde 'D' TO SPEC. IS:4030-75

NEAREST EQ. MATERIAL

STEEL 10 GOST 1050-74

ORGL MATERIAL:-

ALL SHARF EDGES & CORNERS TO BE ROUNDED OFF

DRG. NOT TO BE SCALED

SCALE: -

DATE : 09 MAR 90

DRN.

TCD.

CHD

APPD

WT :- (Kg) SEE TABLE

ALL THREADS TO CONFORM TO SPECIFICATION

TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED

STAMP OR ETCH, PART No. MANUFACTURER's NAME & YEAR OF MFR.

USED ON:

672-31-71

TAB WASHER

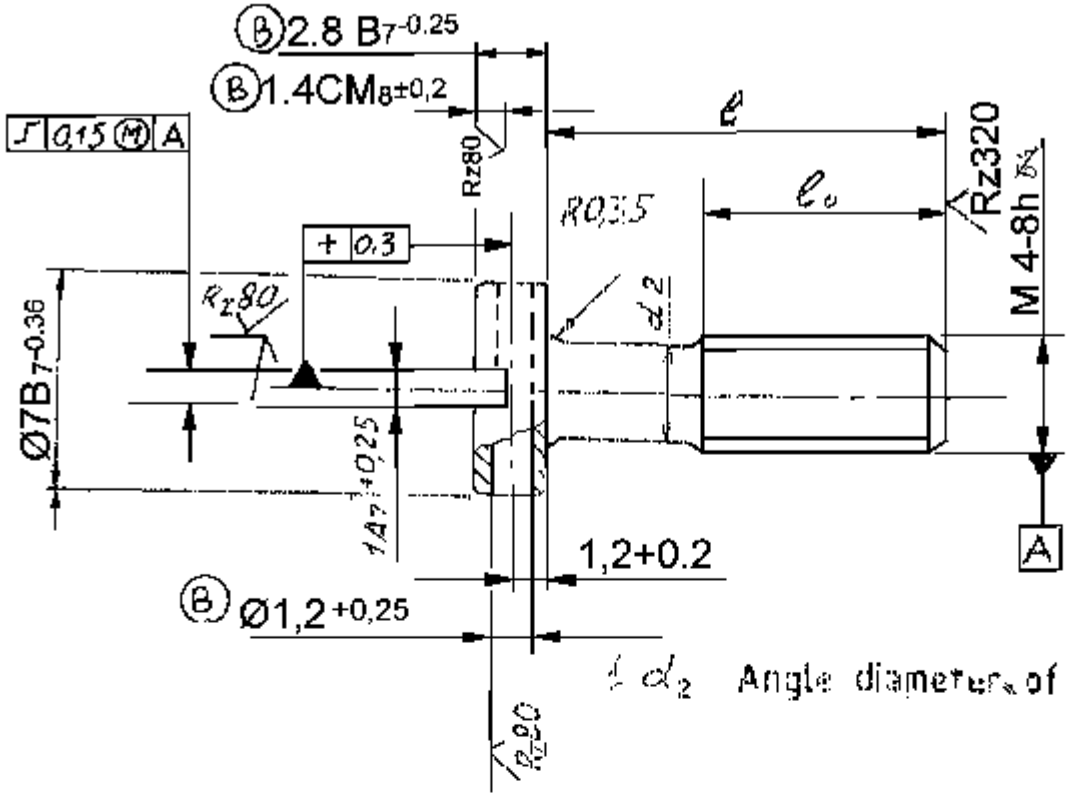
CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

A3

672-35-3

16783-W PROV. SEALING
24-6-89 CANCELLED

Rz 40 (V)



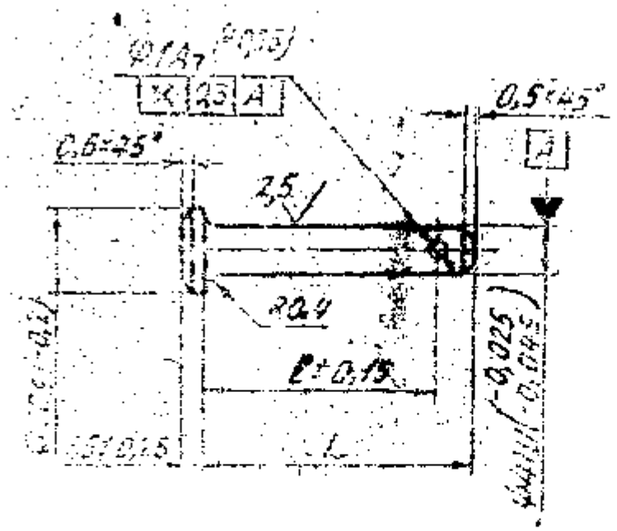
$\frac{1}{2}\,d_2$ Angle diameter of thread.

Designation	ℓ, MM	ℓ_o, not less than	Mass, kg.	DS CAT No.
672-35-3	10±0.5	10	0.0015	LV2/RCV-5305-015430 SCREW. MACHINE (A)
-01	12±0.5	12	0.0016	
-02	16±0.5	16	0.0019	
-03	20±0.6	14	0.0023	

1. Alternate material is steel 25,30,35,40 GOST 1050-74. When screws are made by cold upsetting, use steel 10 10kn, 20, 20kn, GOST 1050-74.
2. Coating: Zinc-plated, 9 microns thick, chromatized. Remove hydrogen embrittlement.

DC(I)No. & DATE	ISSUE	AMENDMENTS
11 AUG 04	(B)	D.O CORRECTION.
00551-ICV 20 MAR 96	(A)	DS CAT PART NO LV2/RCV-5305-015430 AND DESCRIPTION 'SCREW' MACHINE ADDED.

APPROVED	VASU	672-35-3	
CHECKED	AMISHRA		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		SCREW	WEIGHT: SEE TABLE; SCALE: 4:1; SHT 1 SHTS 1
		STEEL 45 GOST 1050-74	



1. HB 341 to 255 (ϕ3,3 to 3,8).
2. Alternate material is steel 38xC, 38xA, 40X, 40XC GOST 4543-71.
3. Coating: Zinc-plated, 9 microns thick, chromatized. Remove hydrogen embrittlement. Do not check coating in the hole.

Ⓐ **4. Equivalent material is 40Cr4 Mo3 to IS:5517.**

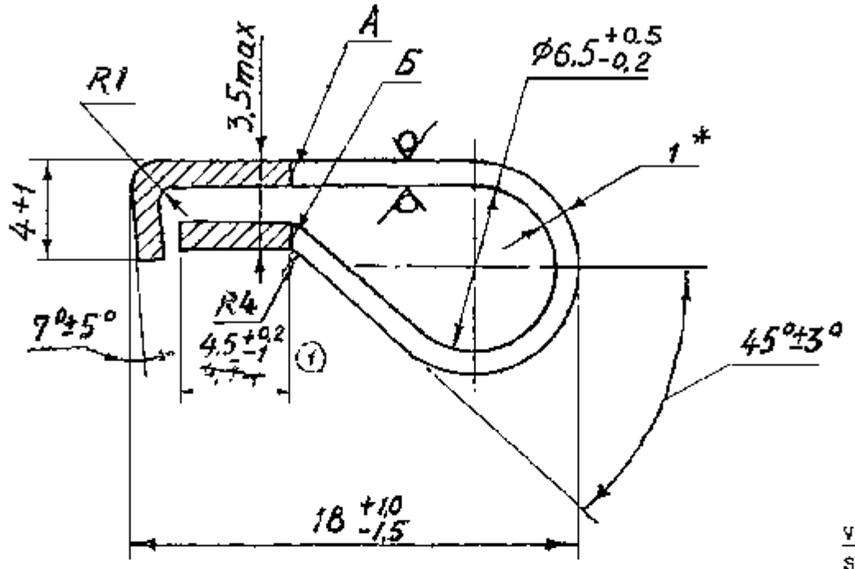
Designation	L, MM	ϕ MM	Mass kg.
672-47-5	16±0.43	13	0.002
-01	20±0.52	17	0.0024
-02	25±0.52	22	0.0029
-03	18±0.43	15	0.0017

00321 - ICV Sridevi 11 FEB 92	Ⓐ MD com	NOTE FOR EQUIVALENT MATERIAL ADDED
DC(I) No.&DATE	ISSUE	NATURE
AMENDMENTS		

APPROVED	M VASU	672-47-5	
CHECKED	H.M.Shaikh		
CONTROLLERATE OF INSPECTION (ICV)		AXLE	WEIGHT: For Table; SCALE: 2:1
		Round 8-5 FOCT 7417-75 bar 45X-B FOCT 1051-73	SHT: 350/376 SHTS

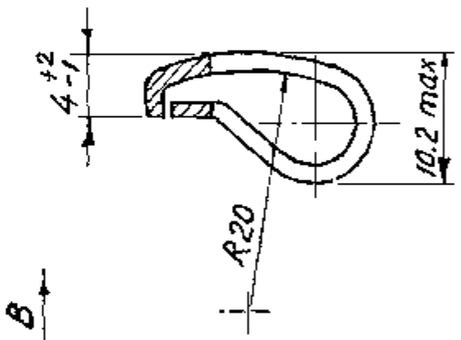
672-54-5

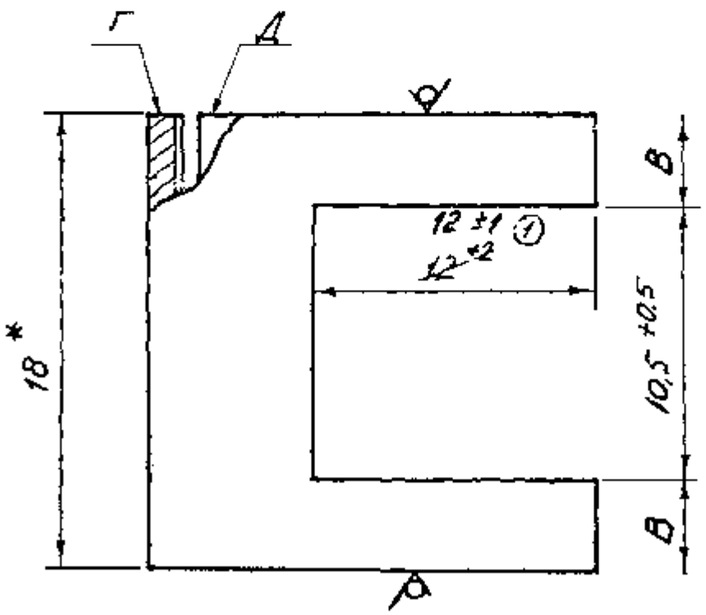
Kz320 (V1)



Version

Scale 2:1





TECHNICAL CONDITIONS

1. Substitute material: steel 08kn, 10kn, ГОСТ 1050-74.
2. Limit deviations of sizes are ±0.5 mm unless otherwise specified.
3. Displacement of surface A relative to surface Б should not exceed 1.8 mm
4. Displacement of surface Г relative to surface Д should not exceed 0.7 mm.
5. The difference of sizes B should not exceed 0.8 mm.
6. Cracks are intolerable.
7. Coating: zinc coating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness.
8. *Sizes for reference.

(A) 9. EQUIVALENT MATERIAL:- COLD ROLLED CARBON STEEL STRIP GRADE 'O' 1/4 HARD TO IS:513-86.

(B) EQUIVALENT MATERIAL:-COLD ROLLED STEEL STRIP GRADE 'D' TO IS:4030-74.

AMENDMENT		
DCN NO & DATE	ISSUE	NATURE
07089-ICV 19/05/2011	©	DS CAT NO' LV2/ICVs 4730-078657 ADDED AND NOMENCLATURE AMENDED AS "SPIKE MAST BASE"
00818-ICV 1.10.2009	(B)	EQ. MATERIAL ADDED.
00497-ICV 16-1-95	(A)	NOTE NO 9 FOR EQUIVALENT MATERIAL ADDED

APPROVED	
CHECKED	
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	

672-54-5

FRAME
SPIKE MAST BASE

BAND 10-M-A-1x18
GOST 503-81

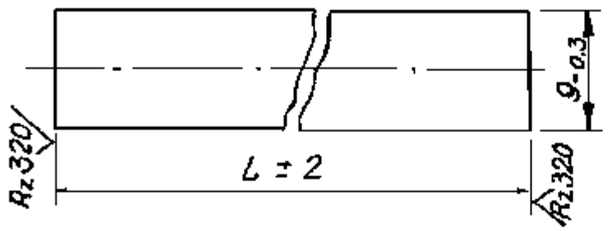
DS CAT PART No
LV2/ICVs 4730-078657

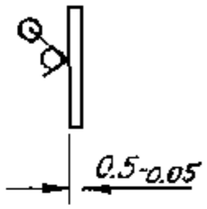
	WEIGHT	SCALE
	0.004	1:1

SHT 1 SHTS 1

A3

672-54-6





Designation	L, mm	Mass, kg	Designation	L. mm	Mass. kg
672-54-6	200	0.007	672-54-6-21	1700	0.060
-01	225	0.008	-22	2350	0.063
-02	250	0.009			
-03	275	0.01			
-04 (B)	300	0.011			
-05	325	0.012			
-06	350	0.012			
-07	375	0.013			
-08	400	0.014			
-09 (B)	425	0.015			
-10	450	0.016			
-11	475	0.017			
-12	500	0.018			
-13 (B)	525	0.019			
-14	600	0.022			
-15	625	0.022			
-16	650	0.023			
-17	725	0.026			
-18	800	0.028			
-19	920	0,033			
-20	980	0.035			

(2) 1. Substitute material: steel 08kn, 10kn, ГОСТ 1050-74.
2. Coating: zinc plating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness.
3. The rest of the technical requirements are according to ГОСТ 503-81.
(A) 4. EQUIVALENT MATERIAL: COLD ROLLED CARBON STEEL-STRIP GRADE 'D' 1/4 HARD TO IS:513-86.
(B) EQ MATERIAL:- COLD ROLLED STEEL STRIP GRADE 'D', 'DD' OR 'EDD' KILLED STEEL TO IS: 4030-73

DCO No. & DATE	ISSUE	AMENDMENTS
00814-ICV 5-10-2000	(B)	EQ MATERIAL ADDED
00497-ICV 15-1-95	(A)	NOTE NO 4 FOR EQUIVALENT MATERIAL ADDED

APPROVED	
CHECKED	

CONTROLLERATE OF QUALITY ASSURANCE (ICV)

672-54-6

BAND

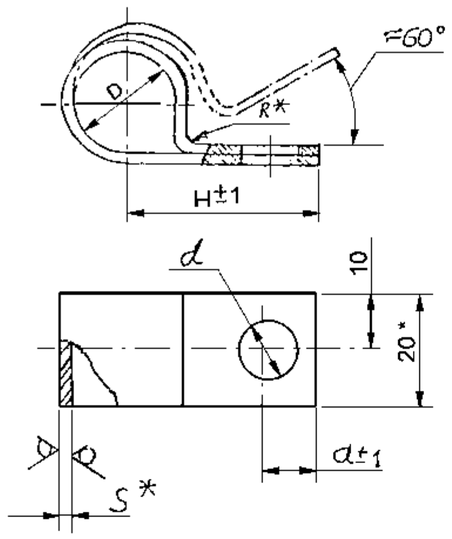
BAND 10-M-2-A-0.5x9 GOST 503-81

WEIGHT	SCALE
SEE TABLE	2:1

SHT 1 SHTS 1

A3

672-54-9



DESIGNATION	WIRE DIA mm	D, mm	d, mm	H, mm	α, mm	S,* mm	R, mm	MASS, Kgs.
672-54-9	4	3,5	7			0,5		0,0074
-01			9					
-02	6	5,5	7			0,8		0,008
-03						0,5		0,003
-04			9					
Ⓒ Ⓔ -05	8	7,5	7			0,8		0,008
-06			9					
-07			7	25	8	0,5		0,005
-08			9					
-09	10	9,5	7			0,8		0,008
-10			9					
-11			7			0,5	2	0,005
-12	12	11,5	7			0,8		0,009
-13			9					
-14			7			0,5		0,007
Ⓒ -15	15	14	7			0,8		0,016
Ⓓ DS CAT PART No. LV2/ICVs 5340-017034 -16			9	41	11			
-17			13					0,014
-18						1,5		0,026
-19	18	17	7			0,8		0,010
-20			9					
-21	20	19	7	30	8			0,011
-22	24	23						0,013
Ⓓ DS CAT PART No. LV2/ICVs 5340-017033 -23	27	26					4	0,015
Ⓓ DS CAT PART No. LV2/ICVs 5340-017032 -24	30	29		35				0,017
-25	32	31		40				0,018
-26	36	35						0,019
-27	42	41		45				0,023

TECHNICAL CONDITIONS

1. Substitute for material- steel 08kn, 10kn, 10, GOST 1050-74
2. Unspecified limit deviations of sizes +_ 0.5 mm.
3. *Sizes are given for reference.
4. Coating: Zinc plated 9 microns thick chromotized. Remove hydrogen embrittlement.

Ⓐ 5. EQ. MATERIAL:- Gde 'D' To IS: 513-86.

Ⓑ EQ. MATERIAL:- Cold rolled steel strip Gr 'D' or 'DD' To IS: 4030-74.

Ⓒ EQ. MATERIAL:- Cold rolled steel strip Grade 'D' killed steel To IS:- 4030-73 For 672-54-9-05 and 672-54-9-15.

Ⓔ EQ. MATERIAL:- Gde 'D' To IS: 513-94 (For 672-54-9-05).

THE ABBRIVATIONS AND SYMBOLS ARE BASED ON RUSSIAN SPECIFICATIONS.

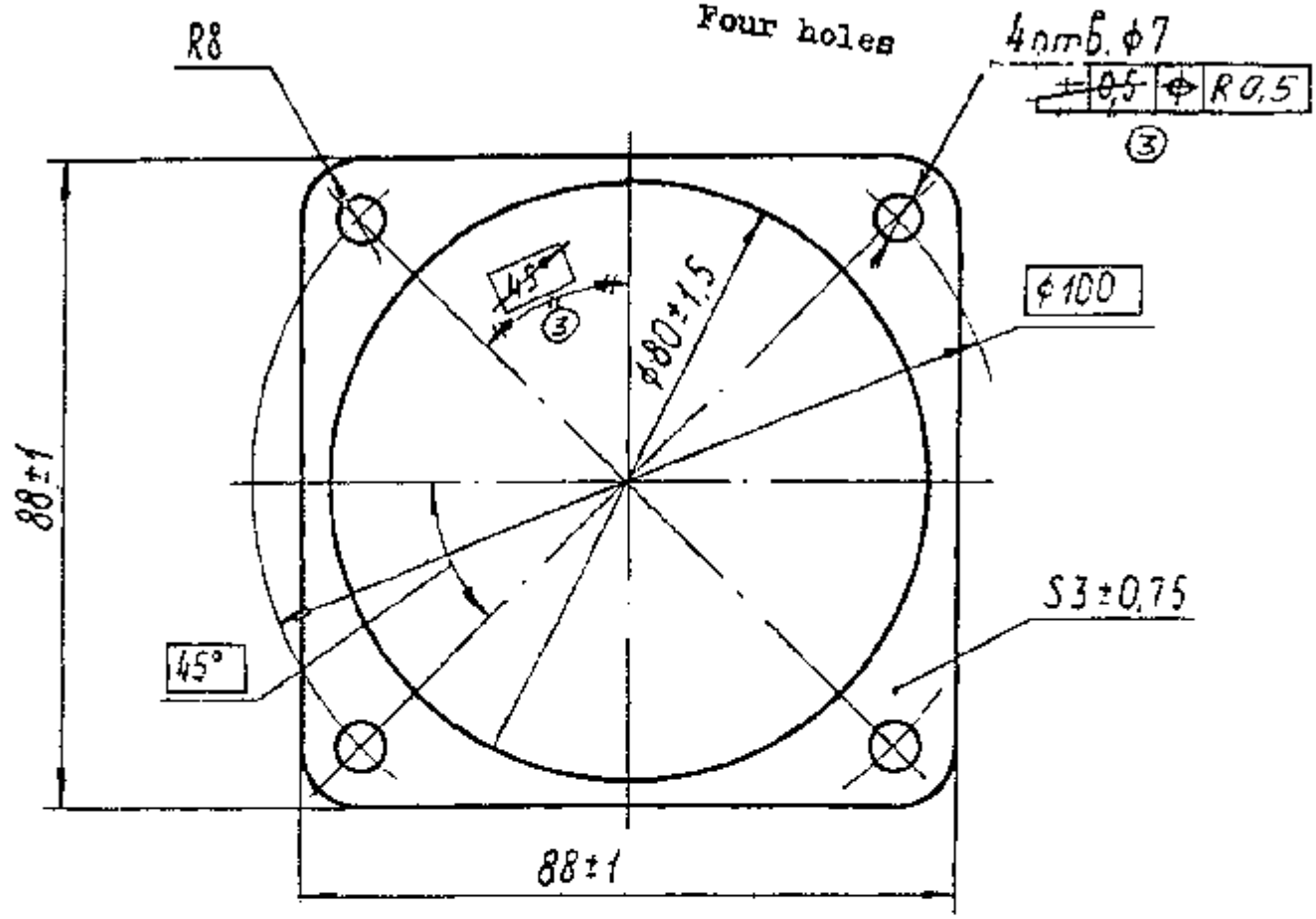
ALL DIMENSIONS ARE IN mm.

DC(I)No. & DATE	ISSUE	AMENDMENTS
01005-ICV 24-10-05	Ⓔ	EQ. MATERIAL ADDED.
01002-ICV 06-08-05	Ⓓ	DS CAT PART No. ADDED.
00818-ICV 11-10-2000	Ⓒ	EQ. MATERIAL ADDED.
00717-ICV 12-9-99	Ⓑ	EQ. MATERIAL ADDED.
0063-ICV 01-6-98	Ⓐ	Gde 'D' TO IS: 513-86 ADDED AS EQ. MATERIAL.

NEAREST EQ. MATERIAL		
BAND 10-M-HT-2-S, GOST 503-81		
ORGL MATERIAL:-		
ALL SHARF EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART No. MANUFACTURER's NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON: 675-05-Sb2
SCALE:		
DATE : 27-2-91		
DRN.	WT :- (Kg) SEE TABLE	672-54-9
TCD.		
CHD		CLAMP
APPD		

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

675-71-144



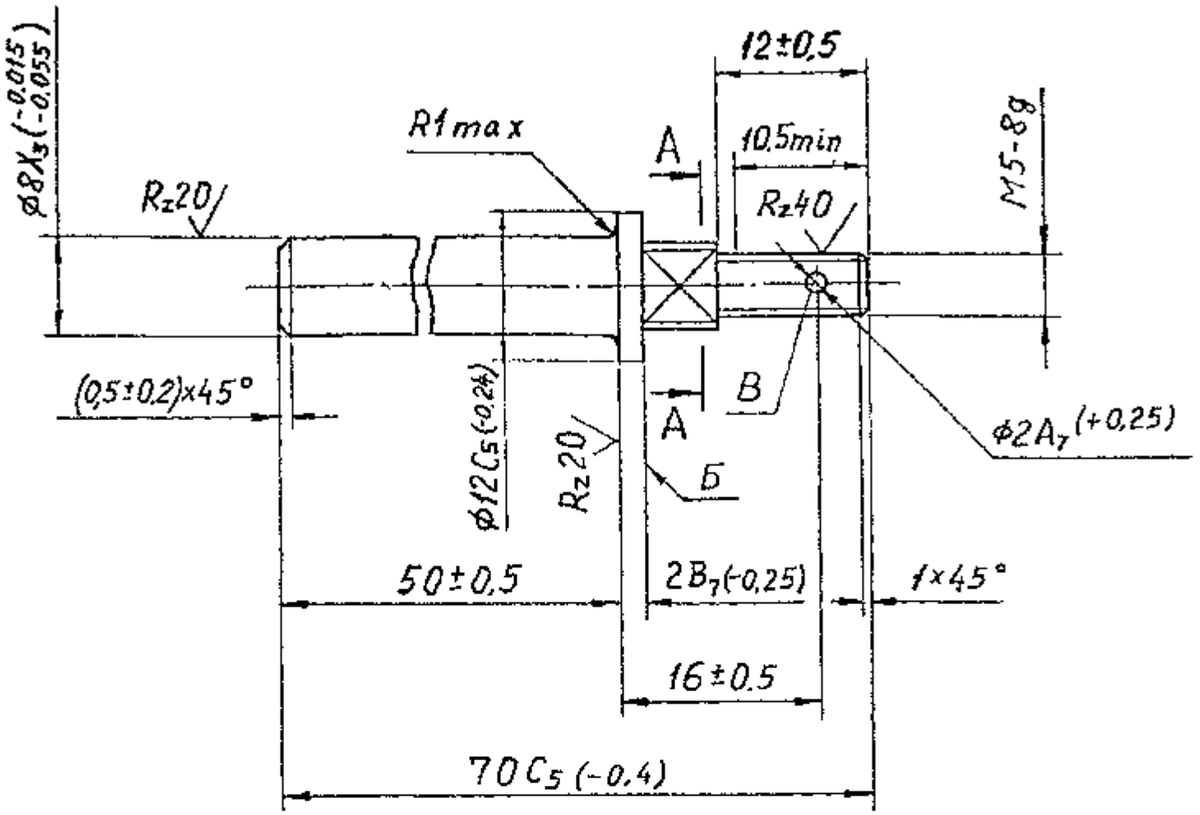
Other requirements - according to TY 005216-75 for article of code 254311.

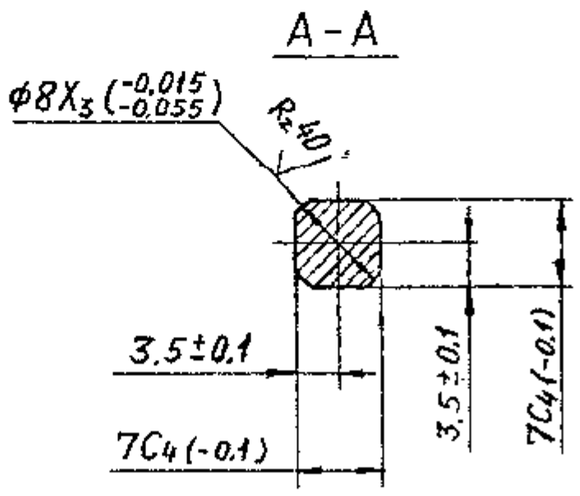
APPROVED		675-71-144
CHECKED		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	GASKET	WEIGHT: 0.012 SCALE: 1:1 SHT 1 SHTS 1
	Plate 254311-3 rubber 637 TY 005216-75	

A4

675-71-148

$R_z 80$ (√)





1. Substitute for material - steel 38XC ГОСТ 4543-71.
2. Unspecified radii - 0.5 mm, maximum.
3. Shoulder up to 0.5 mm on end face Б is tolerable.
4. Location of hole B relative to square - arbitrary.

APPROVED	
CHECKED	
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	

675-71-148

SHAFT

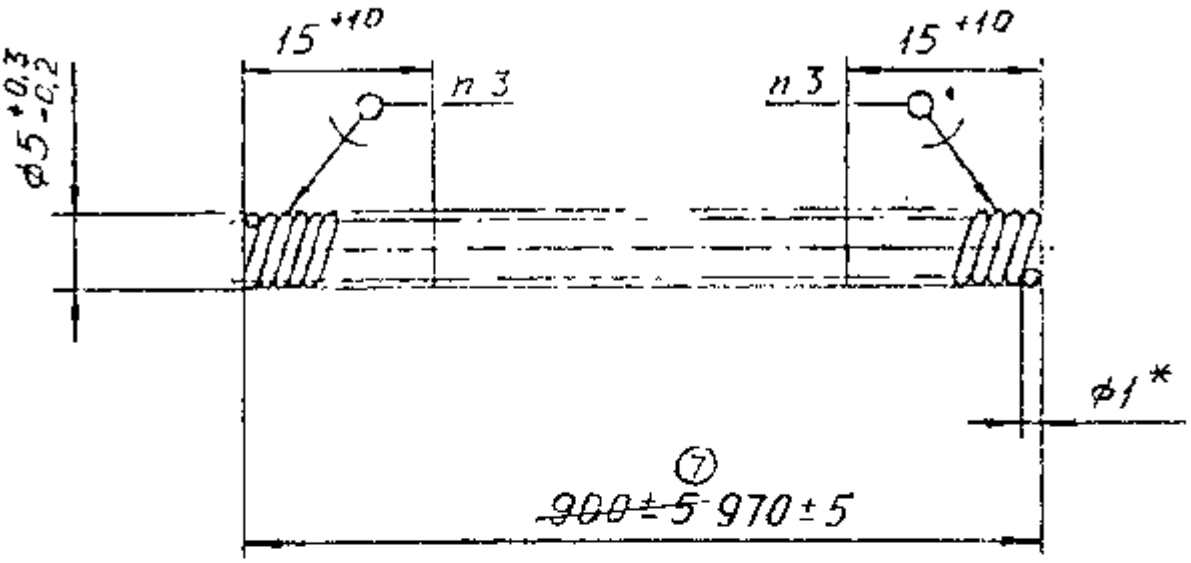
	WEIGHT	SCALE
	0.027	2:1

SHT SHTS

Round bar 18-B Gost 2590-71 / 20x13 Gost 5632-72

A3

675-71-155



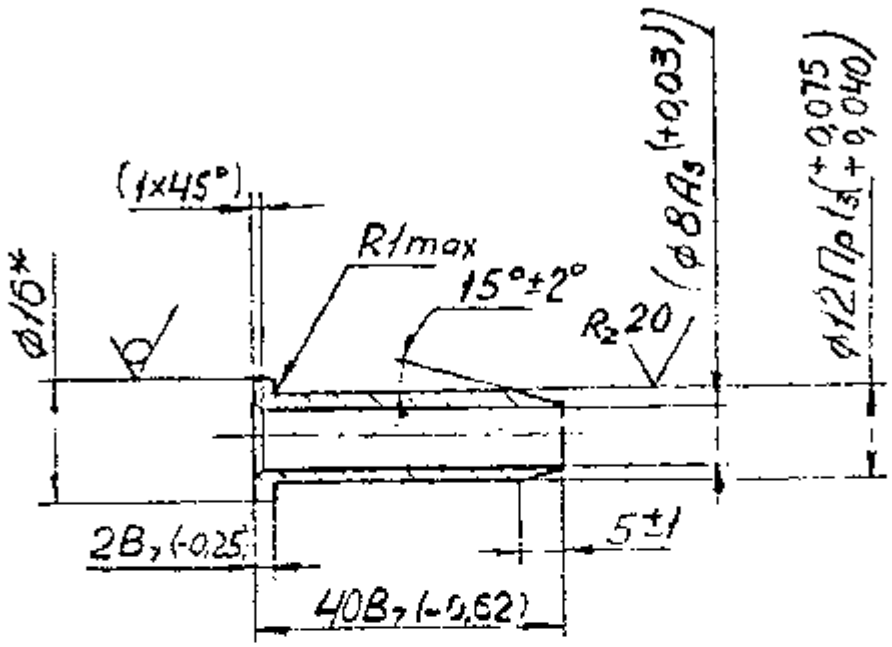
1. Cracks, dents and notches on surface of sheath are not tolerable.
2. Coating: ch. phosphatized Cr. accelerated, oiled KO-815, ГОСТ 11066-74 or preservation oil K-17 ГОСТ 10877-76. Coating between turns may not be checked.
3. Solder 4НОСОу30-2 ГОСТ 21930-76.
4. Winding - uniform, tight. Gaps between turns are not tolerable.
5. Extended length of sheath - (15,780±20) mm.
6. *Size is given for reference.
7. Direction of winding - arbitrary.

APPROVED		675-71-155	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		SHEATH	WEIGHT 0.098 SCALE 2:1
		Wire II-1.0 Gost 9389-75	SHT SHTS

A4

675-71-157

$R_z 80$ ∨(∨)



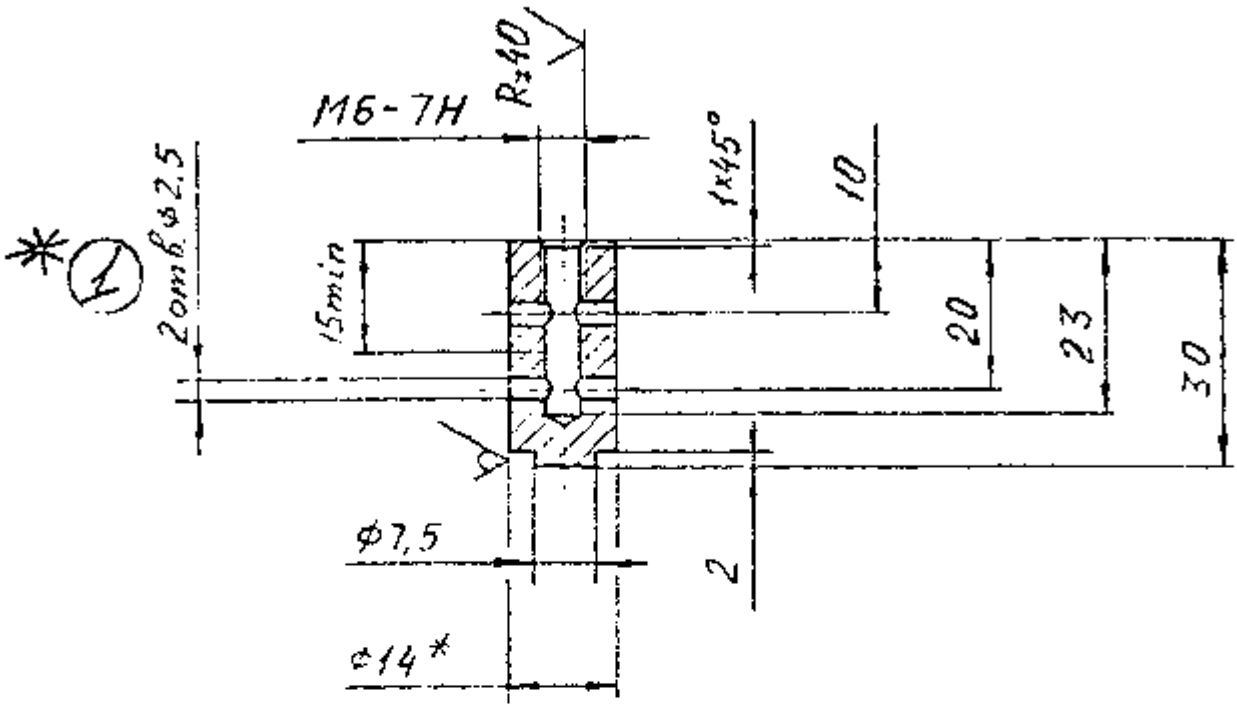
1. Substitute for material - brass rod ЛС63-3т. кр.Н.ЦТ-16 ГОСТ 2060-73.
2. Sizes in brackets - after assembly.
3. *Sizes are given for reference.

APPROVED		675-71-157	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		BUSHING	WEIGHT 0.02 / SCALE 1:1
		Rod ЛС-59-1т. кр.Н.Т-16 Gost 2060-73	SHT 1 SHTS 1

A4

675-71-160

$R_z 80$ V(V)



*(2) TECHNICAL CONDITIONS

*(1) Two holes

(2) 1. Substitute for material - steels 10, 15 ГОСТ 1050-74.

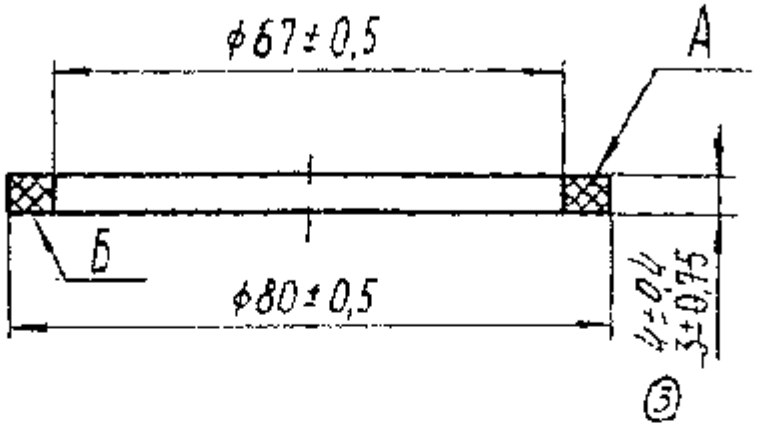
* 2. Unspecified limit deviations of sizes: for holes - according to A_7, for shafts - according to B_7, others - according to CM_8.

3. *Size is given for reference.

APPROVED		675-71-160	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		BOSS	WEIGHT 0.0246 / SCALE 1:1
		Round bar 14-5 Gost 7417-75 / 20-H. 5.B Gost 1050-74.	SHT 1 SHTS 1

A4

675-71-167



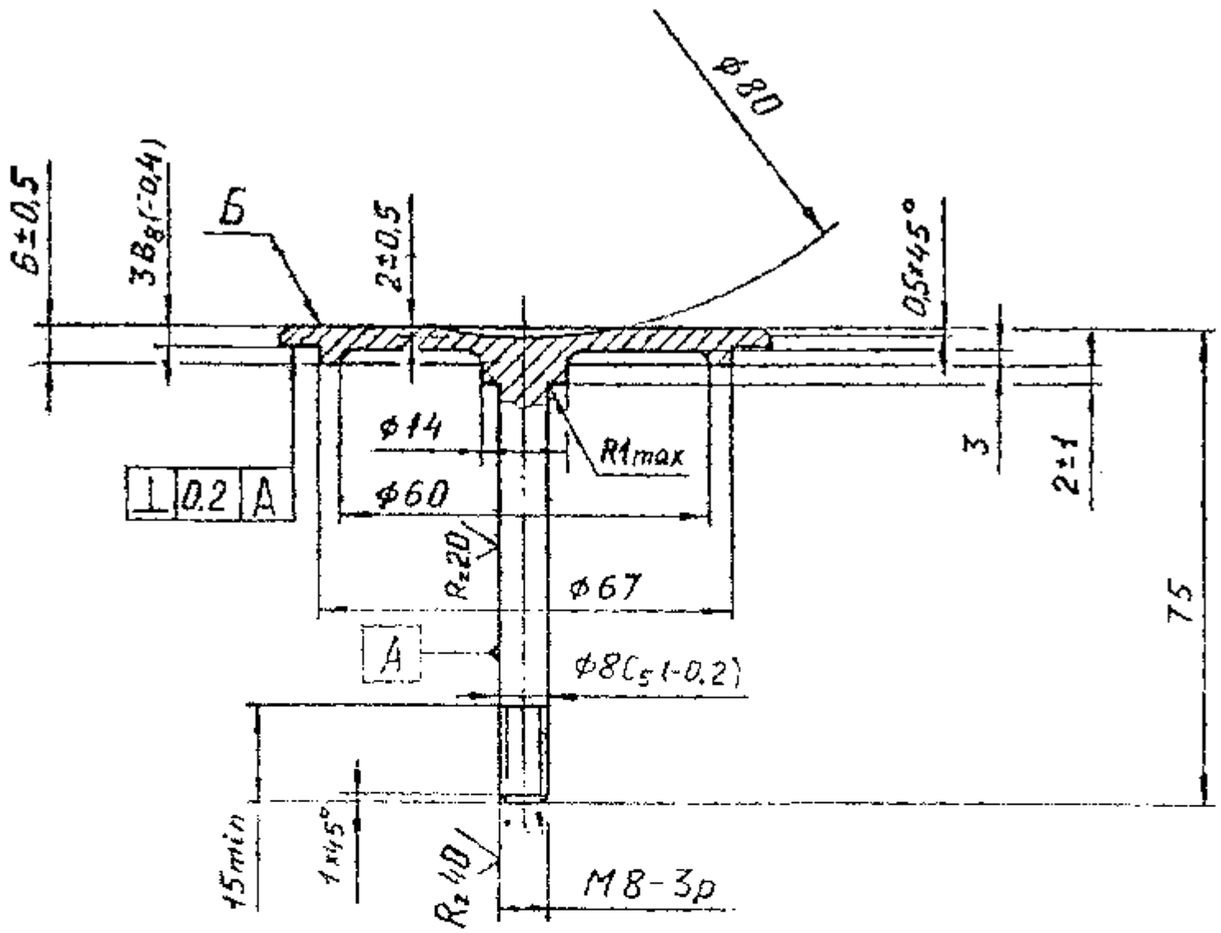
1. Other requirements - according to TY 005216-75 for item of code 254311.
2. It is allowed to manufacture by molding; in this case, rounding radii on surfaces A and B - 0.5 mm, maximum.

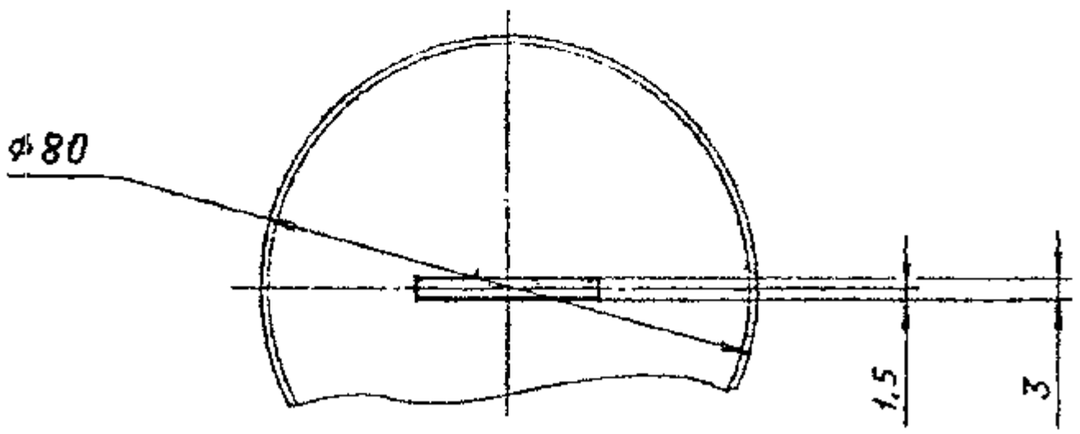
APPROVED		675-71-167	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	GASKET	WEIGHT: 0.009	SCALE: 1:1
	Plate 254311-3 Rubber 1847 Ty 005216-75	SHT 1	SHTS 1

A4

675-71-168

$R_z 80$ ∨(∨)





1. HB 255 to 302 (Ø 3.8 to 3.5).
2. Substitute for material - steel 30X13 ГОСТ 5632-72.
3. Unspecified limit deviations of sizes: for holes - according to A_7, for shafts - according to B_7, others - according to CM_8.
4. Unspecified radii - 5 mm, maximum.
5. Centre-hole trace not in excess of Ø 5 mm on surface Б is tolerable.

APPROVED		675-71-168	
CHECKED			WEIGHT: 0.156 SCALE: 1:1
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		VALVE	SHT SHTS
		Steel 20X13 Gost 5632-72	

A3

675-71-172

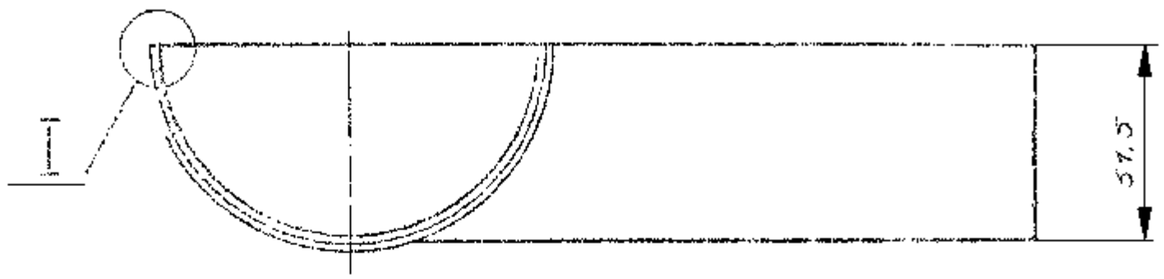
Черт. 1, 2 - изображено. (1)*

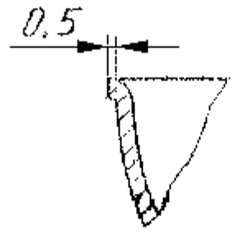
Черт. 1-1-172-01 - зеркальное отражение. (2)*

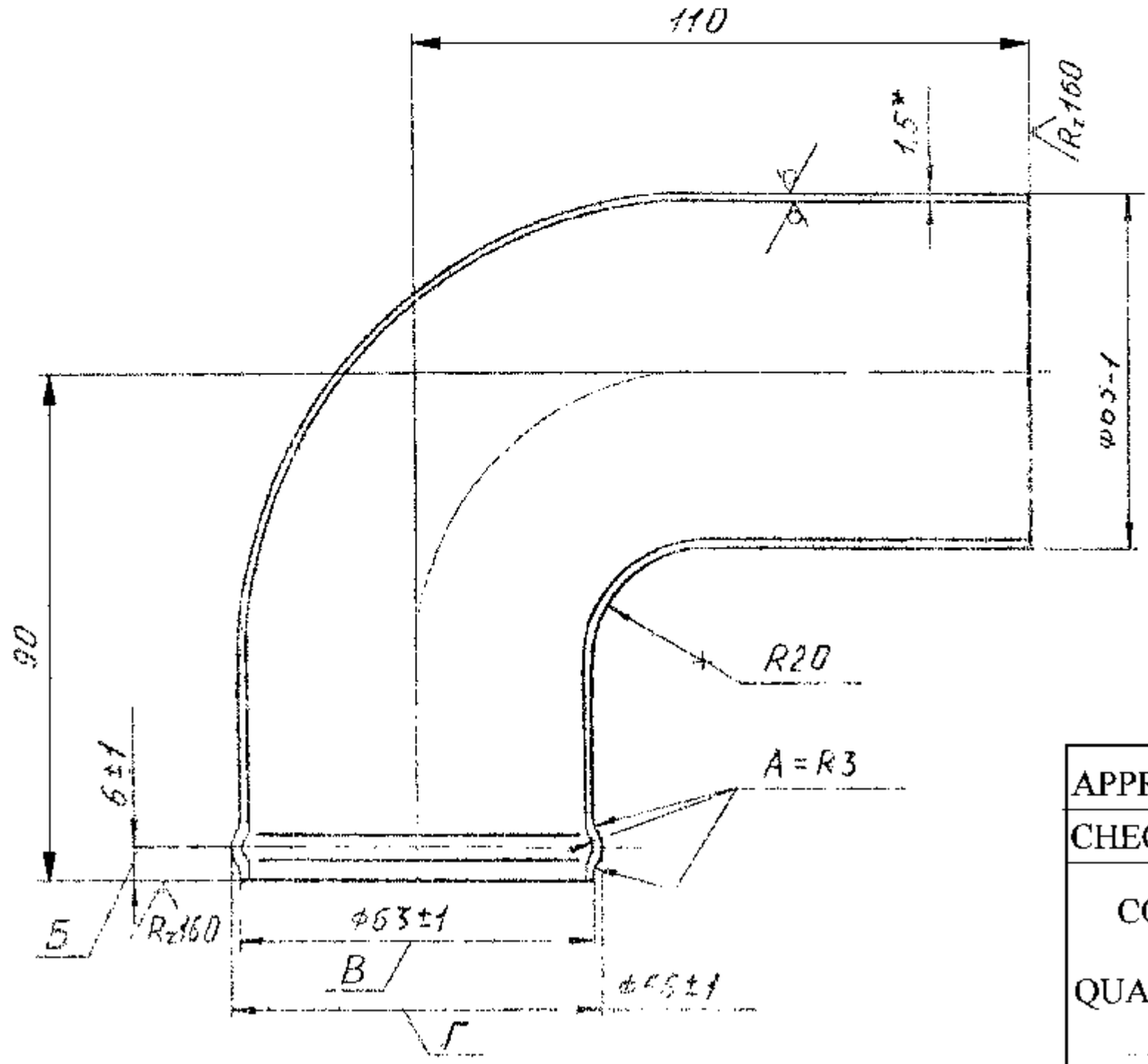
$R_z 320$ √(1)

(3)* I Вариант

M2:1







*(1) Shown here

*(2) Mirror reflection

*(3) I Version

Scale 2:1

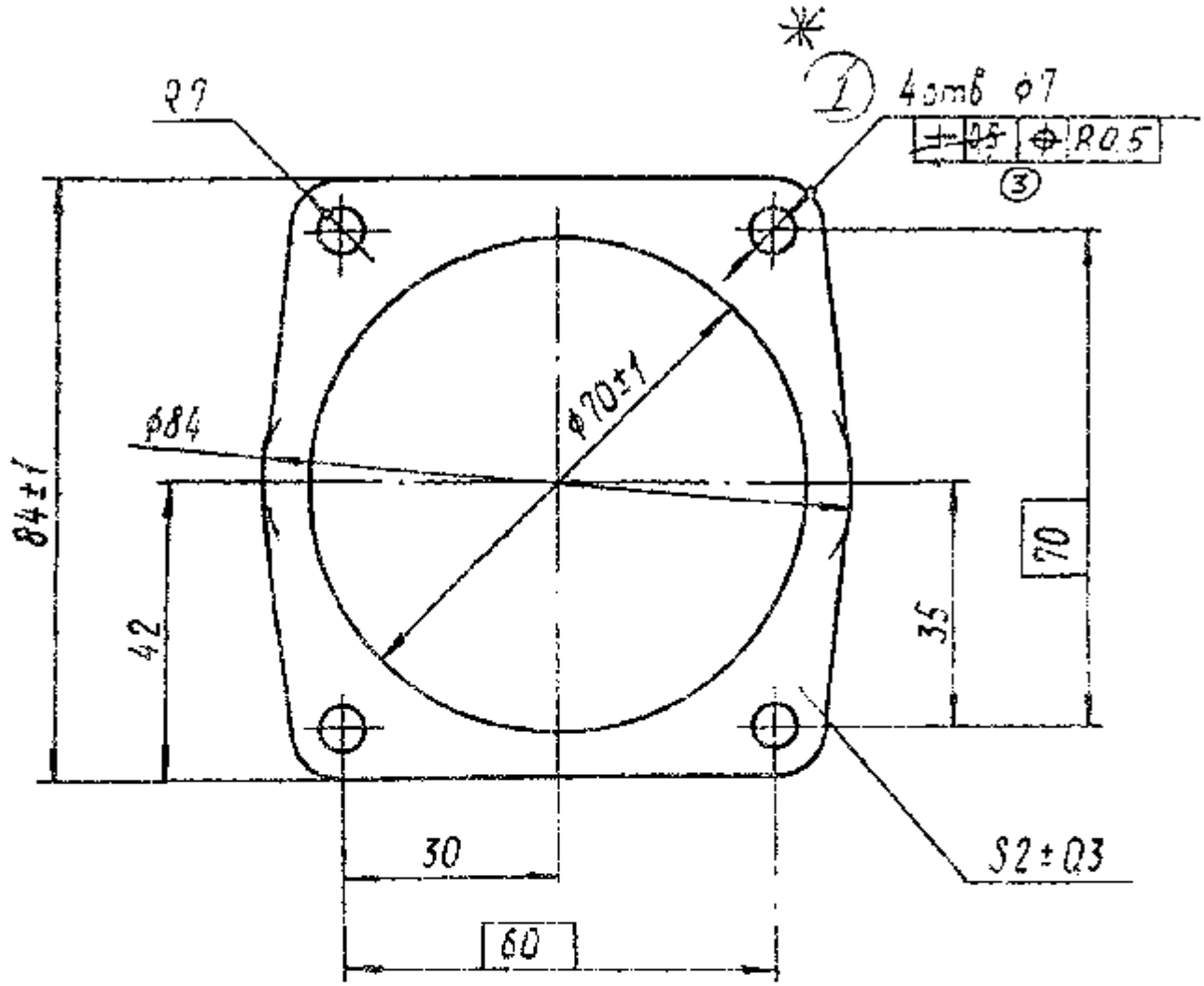
1. Substitute of material - sheet АМцМ-1,5 ГООТ 21631-76.
2. Unspecified limit deviations of sizes - ±0.5 mm.
3. It is allowed to manufacture sizes А, Б, В and Г in assembly.
4. *Size is given for reference.

APPROVED		675-71-172	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		BRANCH PIPE HALF	WEIGHT 0.065 / SCALE 1:1
		Sheet АМцМ-1.5 Gost 21631-76	SHT / SHTS

A3

Rz 320 ✓ (✓)

675-71-263



TECHNICAL CONDITIONS

*(1) Four holes

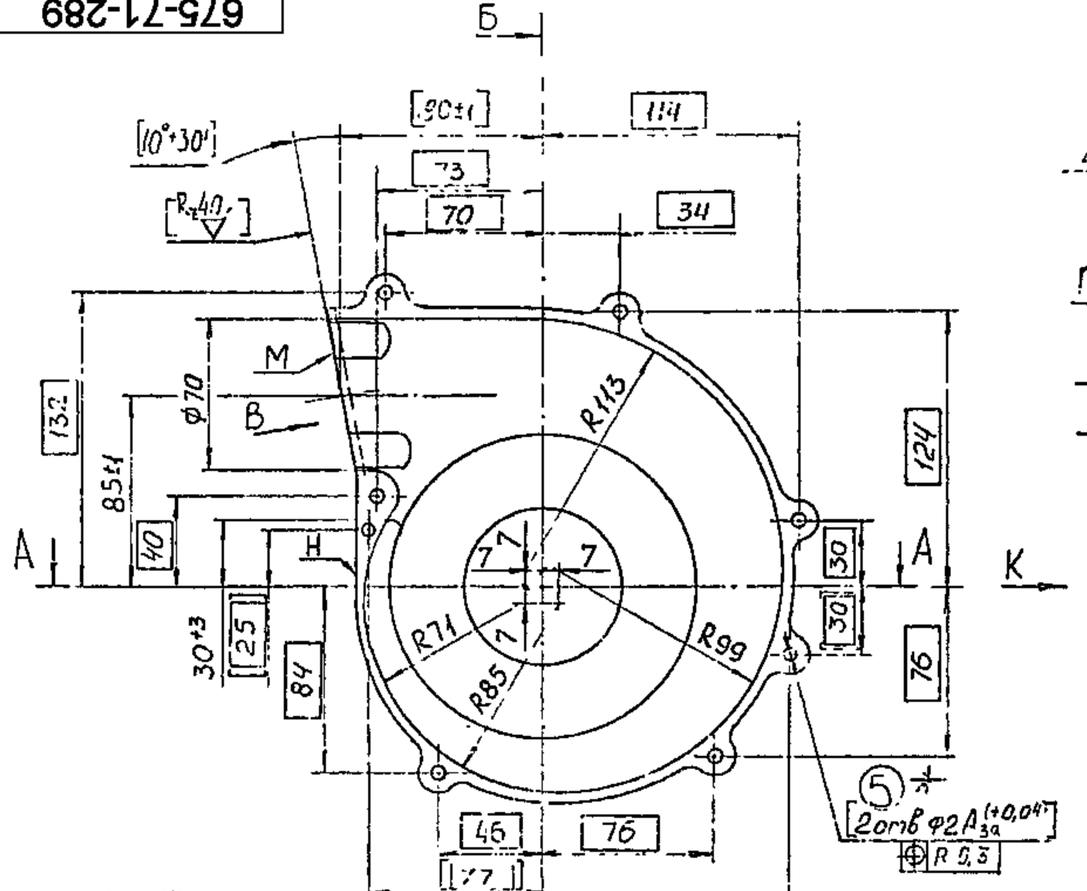
*(2) Other requirements - according to TY 005216-75 for article of code 254311.

APPROVED		675-71-263	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		GASKET	WEIGHT 0.009 / SCALE 1:1
		Plate 254311-2 Rubber 637 TY 005216-75	SHT 1 SHTS 1

A4

675-71-289

R2.40 (V)



*

(12) TECHNICAL CONDITIONS

*(1) I
Scale 1:1

*(2) Four holes

*(3) View B

*(4) Two holes

(5) Two holes

(6) 5 around contour

(7) View K

*(8) И - И
Scale 1:1

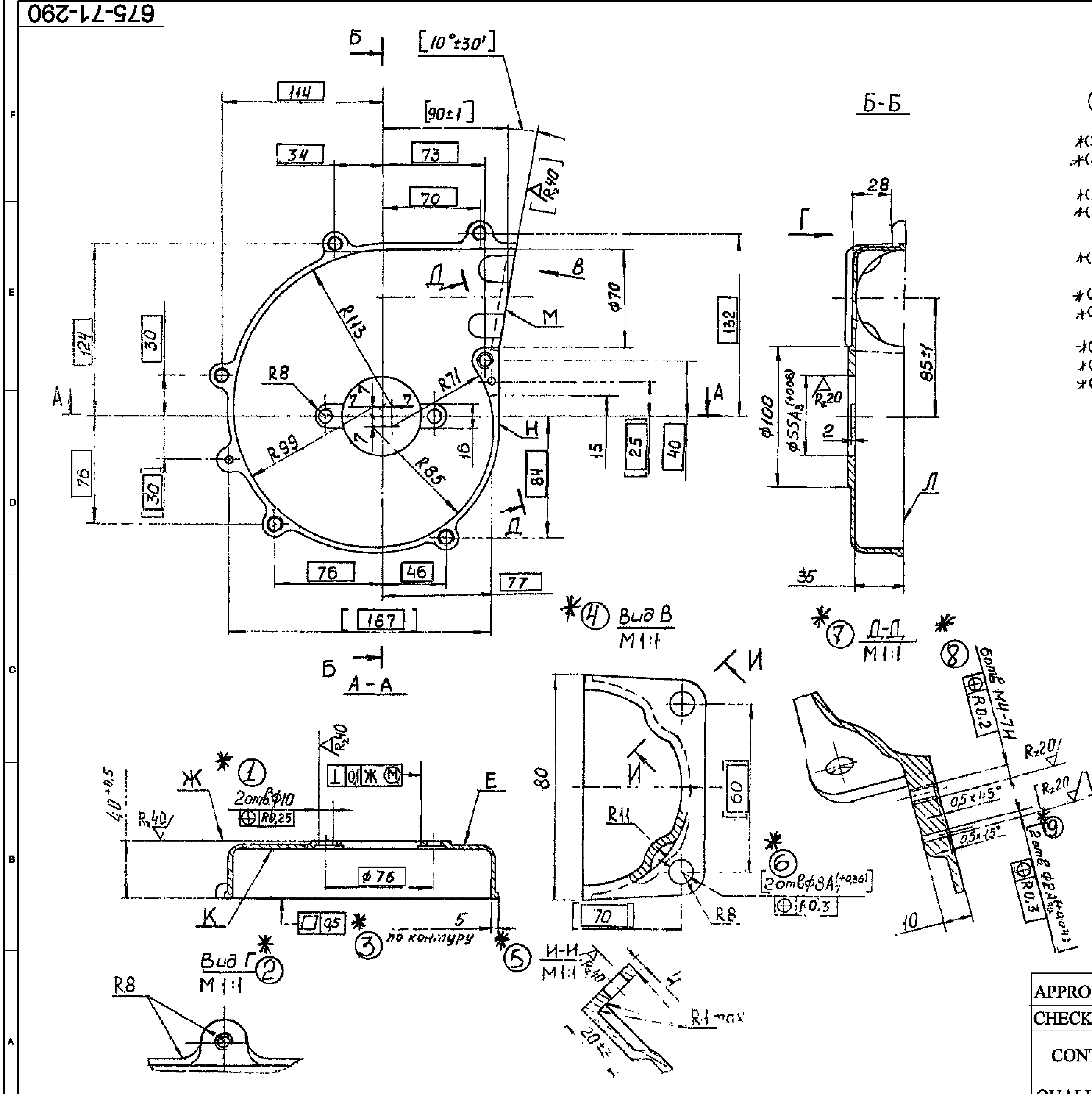
(9) View Г
Scale 1:1

*(10) Six holes

*(11) Д - Д
Scale 1:1

(12) 1. Substitute for material - АЛ9 ГОСТ 2685-75.
2. Unspecified casting radii - 6 mm, maximum.
3. Unspecified wall thickness - 3 mm.
4. Drafts - 2°, maximum.
5. Net scoring not more than 0.5 mm high on surface E and П is tolerable.
6. Pusher traces not in excess of 0.5 mm on surface П are tolerable.
7. Other requirements to casting - according to ТТАЛ-370.
8. Manufacture according to ТТШ-408 is allowed.
9. Coating: phenol-formaldehyde lacquer ЛБС-1 ГОСТ 901-78 according to Instructions 053.25273.000.10.
10. Unspecified limit deviations of sizes - ±0.5 mm.
11. Machine to sizes in brackets together with part 675-71-290 and gasket of (1.2±0.2) mm between them.
12. Use parts together.
13. Incision into surface H not in excess of 3 mm during machining of surface M is tolerable.

APPROVED		675-71-289	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		VOLUTE	WEIGHT 0.56 / SCALE 1:2
			SHT 1 SHTS 1
		A2 Gost 2885-75	



Rz 40 (✓)

⑩ TECHNICAL CONDITIONS

*(1) Two holes
*(2) View Г
Scale 1:1
*(3) Around contour
*(4) View B
Scale 1:1
*(5) И - И
Scale 1:1
*(6) Two holes
*(7) Д - Д
Scale 1:1
*(8) Six holes
*(9) Two holes
*(10)
1. Substitute for material - АЛ9 ГОСТ 2685-75.
2. Unspecified casting radii - 6 mm, maximum.
3. Unspecified wall thickness - 3 mm.
4. Drafts - 2°, maximum.
5. Net scoring not more than 0.5 mm high on surface E is tolerable.
6. Pusher traces not in excess of 0.5 mm on surfaces K and И are tolerable.
7. Other requirements to casting - according to ТТАЛ-370.
8. Manufacture according to ТТЦЛ-408 is allowed.
9. Coating: phenol-formaldehyde lacquer ЛБС-1 ГОСТ 901-78 according to Instructions 053.25273.000.10.
10. Unspecified limit deviations of sizes - ±0.5 mm.
11. Machine to sizes in brackets together with part 675-71-289 and gasket of (1.2±0.2) mm between them.
12. Use parts together.
13. Incision into surface H not in excess of 3 mm during machining of surface M is tolerable.

APPROVED		675-71-290	
CHECKED			WEIGHT 0.53 / SCALE 1:2
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		WALL	SHT 1 SHTS 1
		АЛ2 Gost 2685-75	

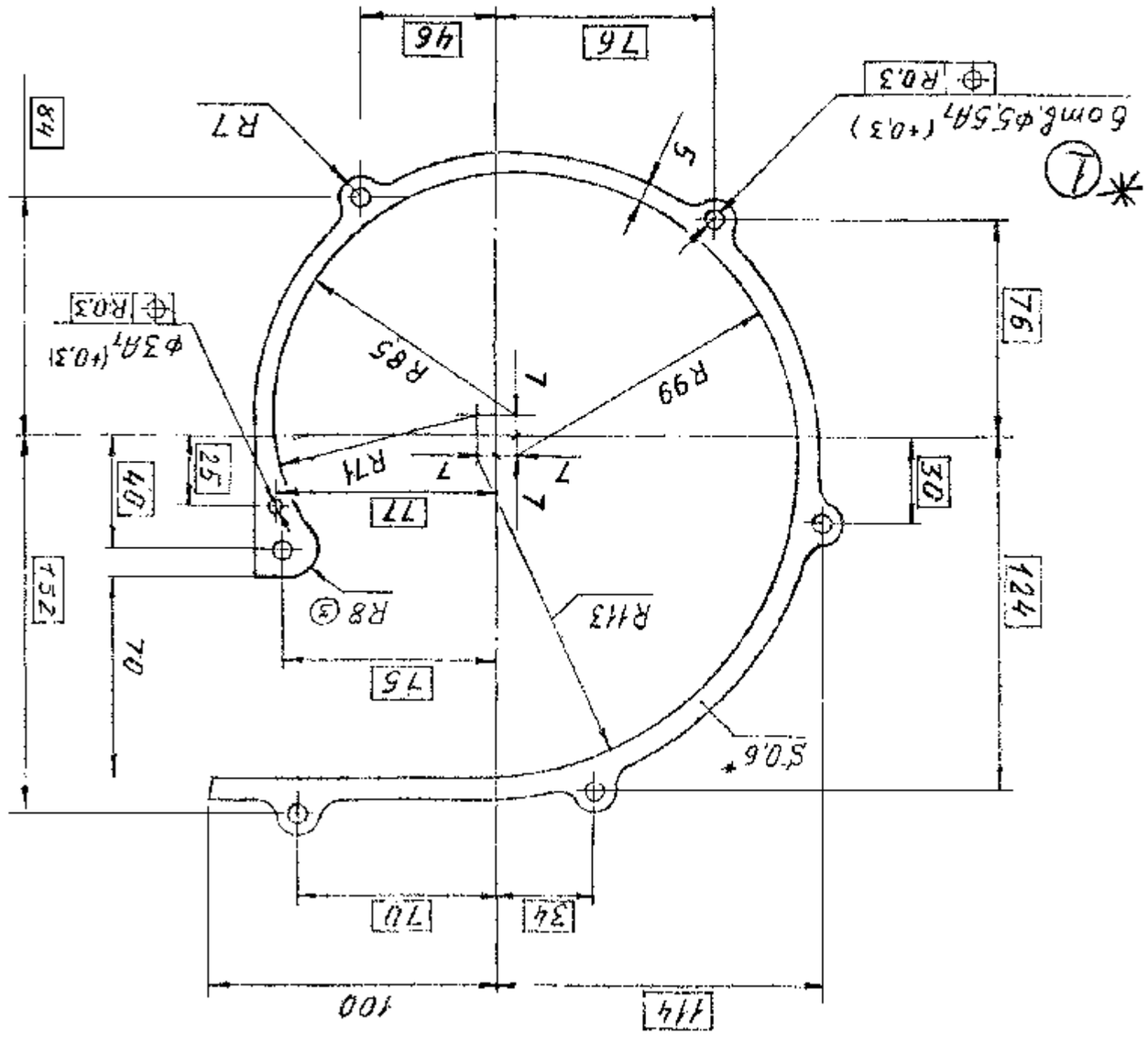
A2

APPROVED		CONTROLLERATE OF QUALITY ASSURANCE (ICV)	
CHECKED			
	WEIGHT	SCALE	
	0.005	1:2	
SHT 1 SHTS 1			

SEALING GASKET

675-71-291

Paronite ПОН-0.6
Gost 4-81-80

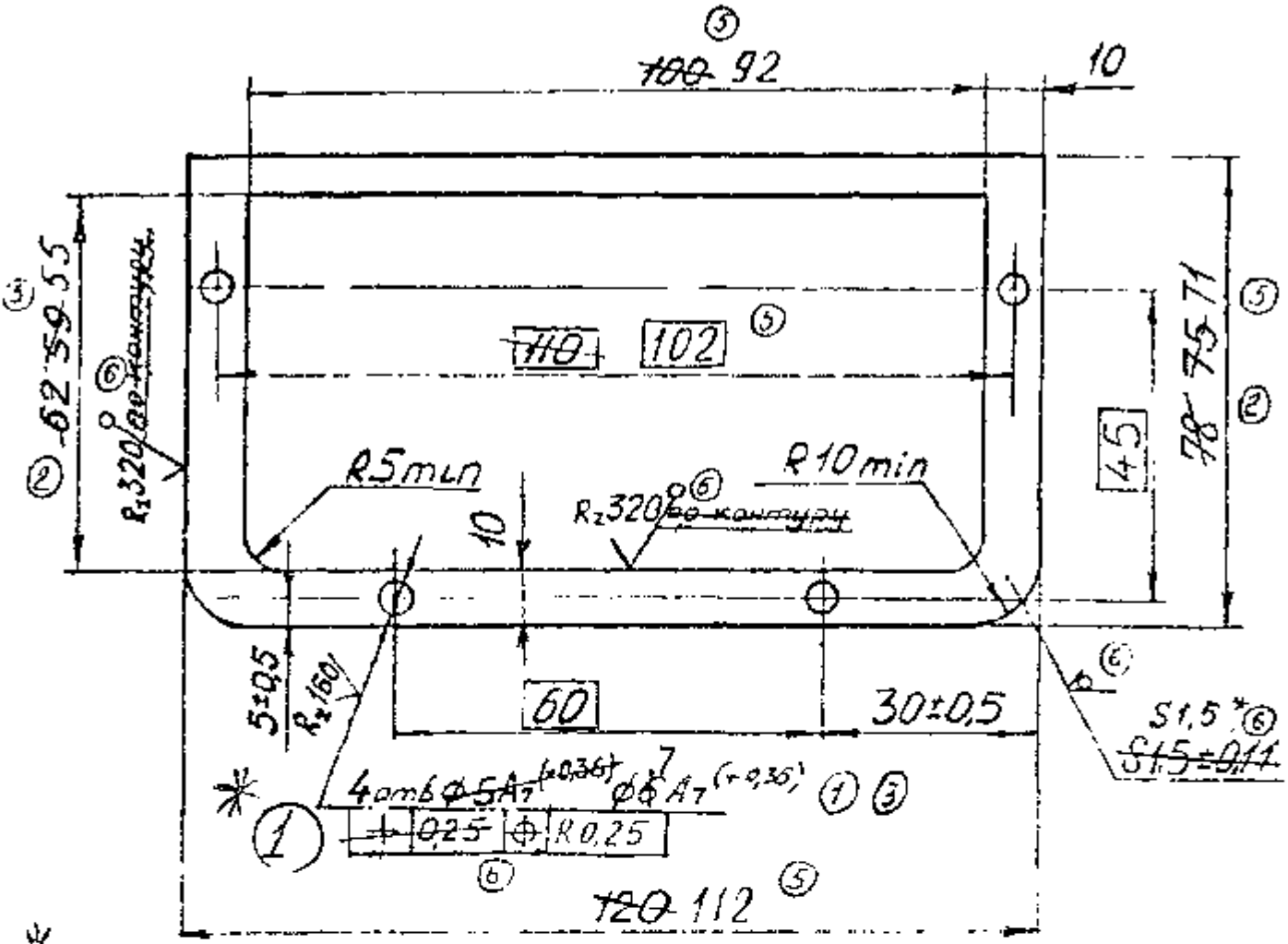


TECHNICAL CONDITIONS

*(1) Six holes

*(2) 1. Unspecified limit deviations of sizes - ±0,5 mm.
2. Unspecified radii - 6 mm, maximum.
3. "Size is given for reference.

675-71-292



TECHNICAL CONDITIONS

*(1) Four holes

*(2) 1. Substitute for material - steels 08кп, 10кп ГОСТ 1050-74.

2. Unspecified limit deviations of sizes - ±1 mm.

3. Coating: hot-dip metal coat 4 ПОСЦу30-2 ГОСТ 21930-76.

4. "Size is given for reference.

APPROVED		675-71-292	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		COVER PLATE	WEIGHT 0.0228 / SCALE 1:1
		Sheet A-ПУ-О-1,5 Gost 19904-74 5-II-Г-10 Gost 16523-70	SHT 1 SHTS 1

A4

675-71-293

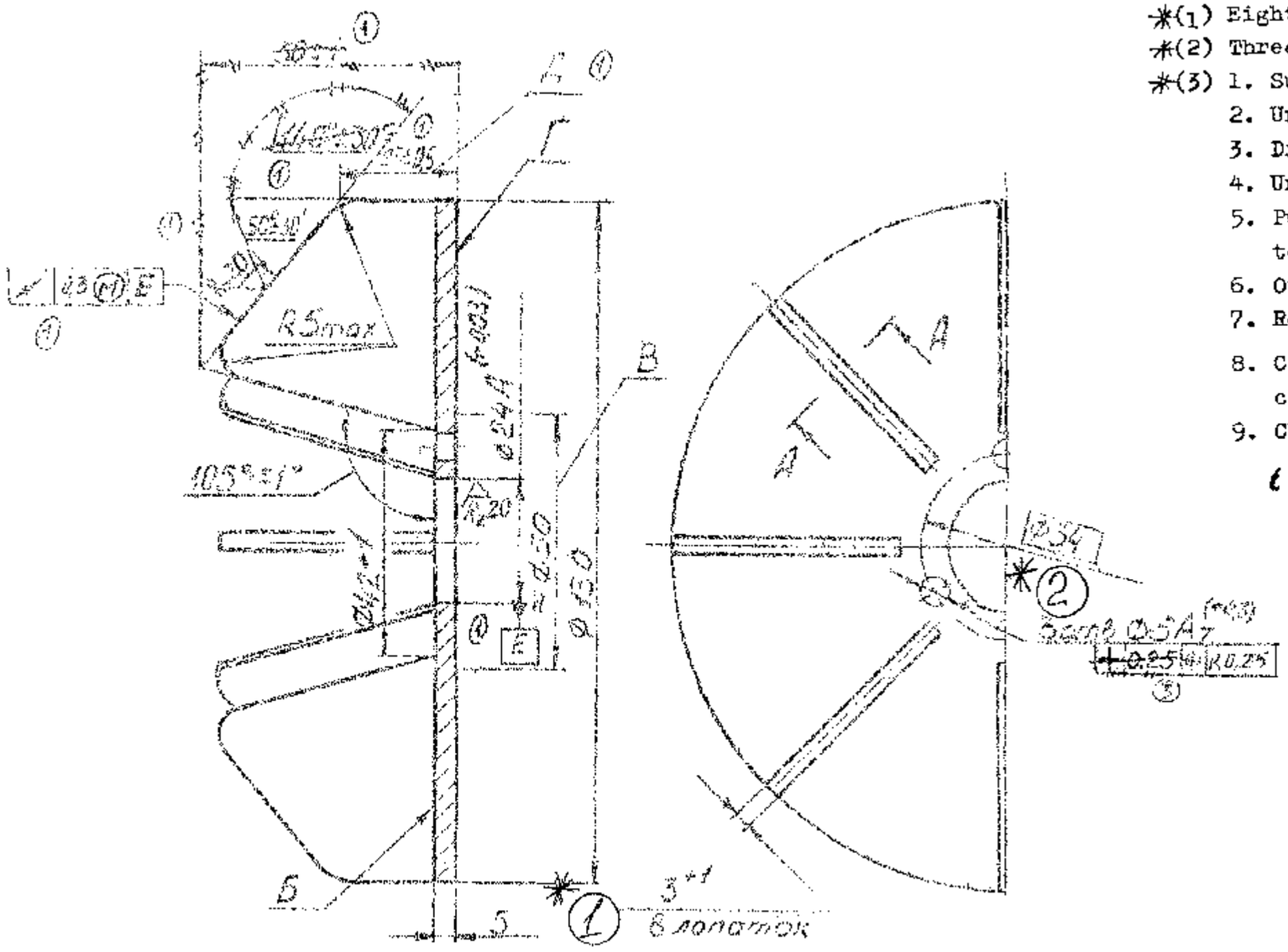
$R_z 40$ ▽ (▽)

TECH. CONDITIONS

*(1) Eight vanes

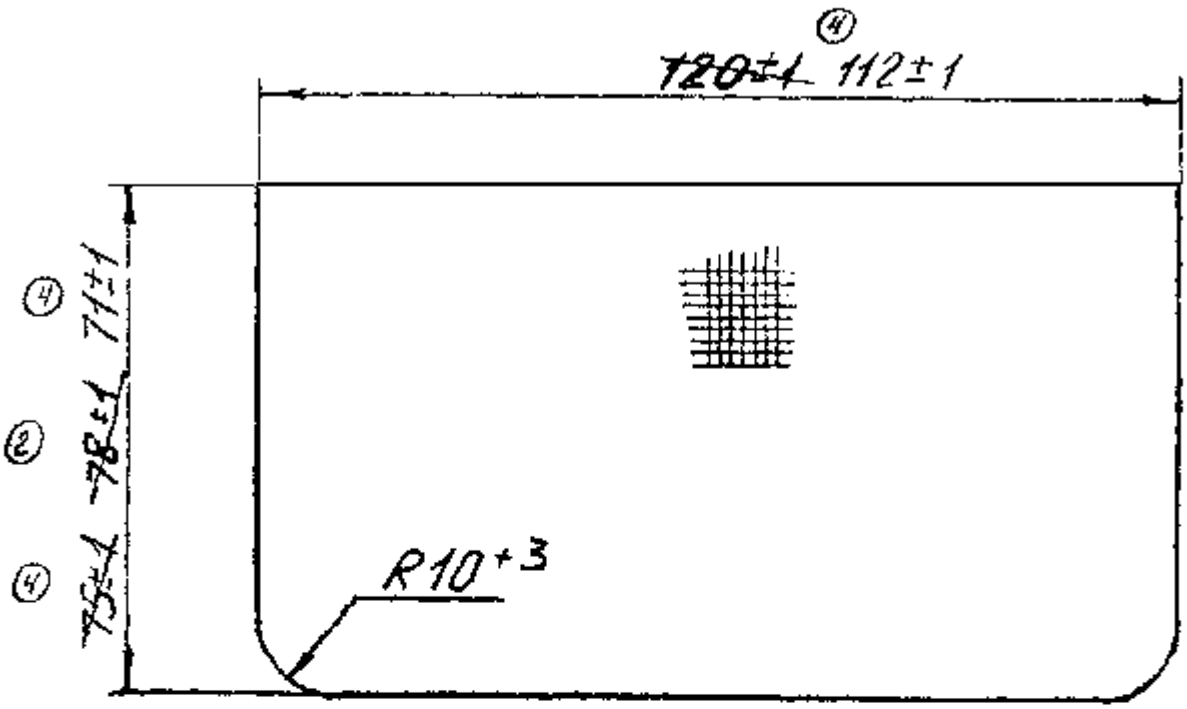
*(2) Three holes

*(3) 1. Substitute for material - АЛ9 ГОСТ 2685-75.
2. Unspecified casting radii - 2 mm, maximum.
3. Drafts - 2°, maximum.
4. Unspecified limit deviations of sizes - ±0.5 mm.
5. Pusher traces not in excess of 0.5 mm on surface Б are tolerable.
6. Other requirements to casting - according to ТТАЛ-370.
7. Roughness of surface Г on section В is R_z 20 ▽.
8. Coating: anodic oxidation with subsequent sealing in bichromate.
9. Check size Д from surface of section В.



APPROVED		675-71-293	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	IMPELLER	WEIGHT 0.21	SCALE 1:1
		SHT 1	SHTS 1
	АЛ2 Gost 2685-75.		

675-71-294



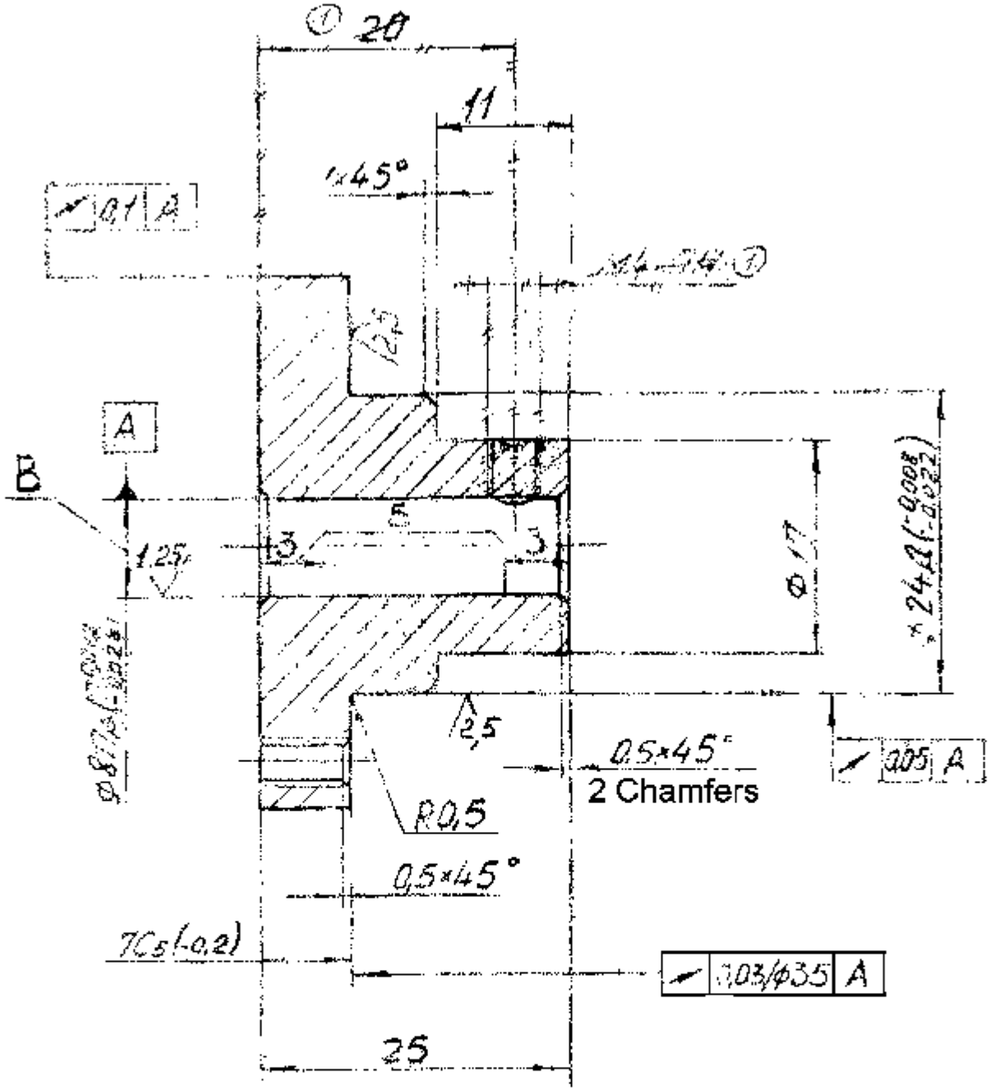
Fall out of wires and distortion of cells are tolerable.

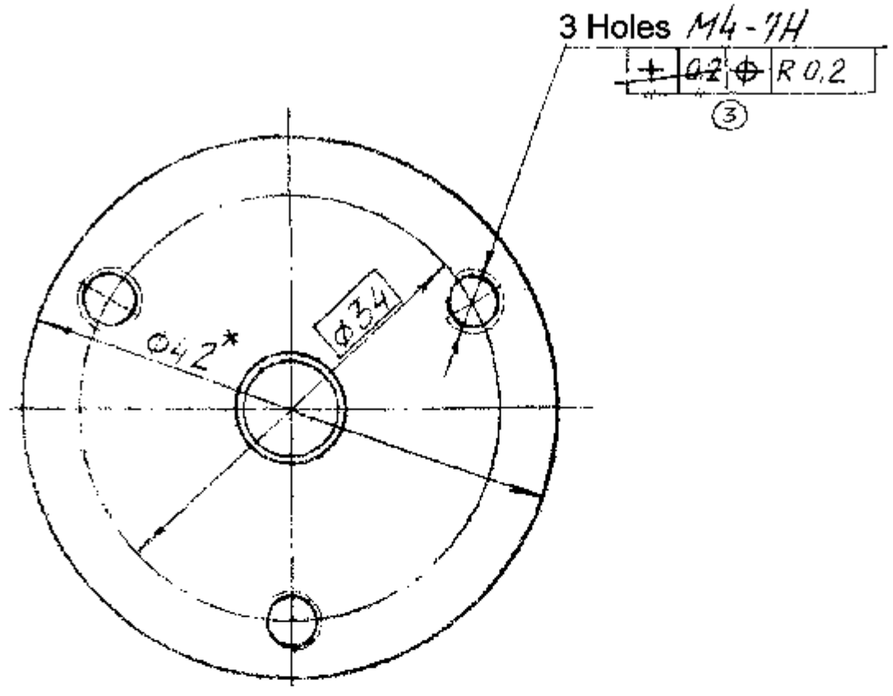
APPROVED		675-71-294	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		GAUZE	WEIGHT: 0.007 / SCALE: 1:1 / SHT 1 SHTS 1
		Gauze 8-1, 6Hy Gost 3826-82	

A4

675-71-295

Rz 80





'3) 1. Substitute for material - steel 40 ГОСТ 1050-74.
2. Coating: chemically oxidized oiled.
3. Unspecified limit deviations of sizes: for holes - according to A_7, for shafts - according to B_7, others - according to CM_8.
4. Slackening of size B on sections 5 to $8A_3$ mm is tolerable.
5. Circular marks not in excess of three on surface of hole B are tolerable.
6. *Size is given for reference.

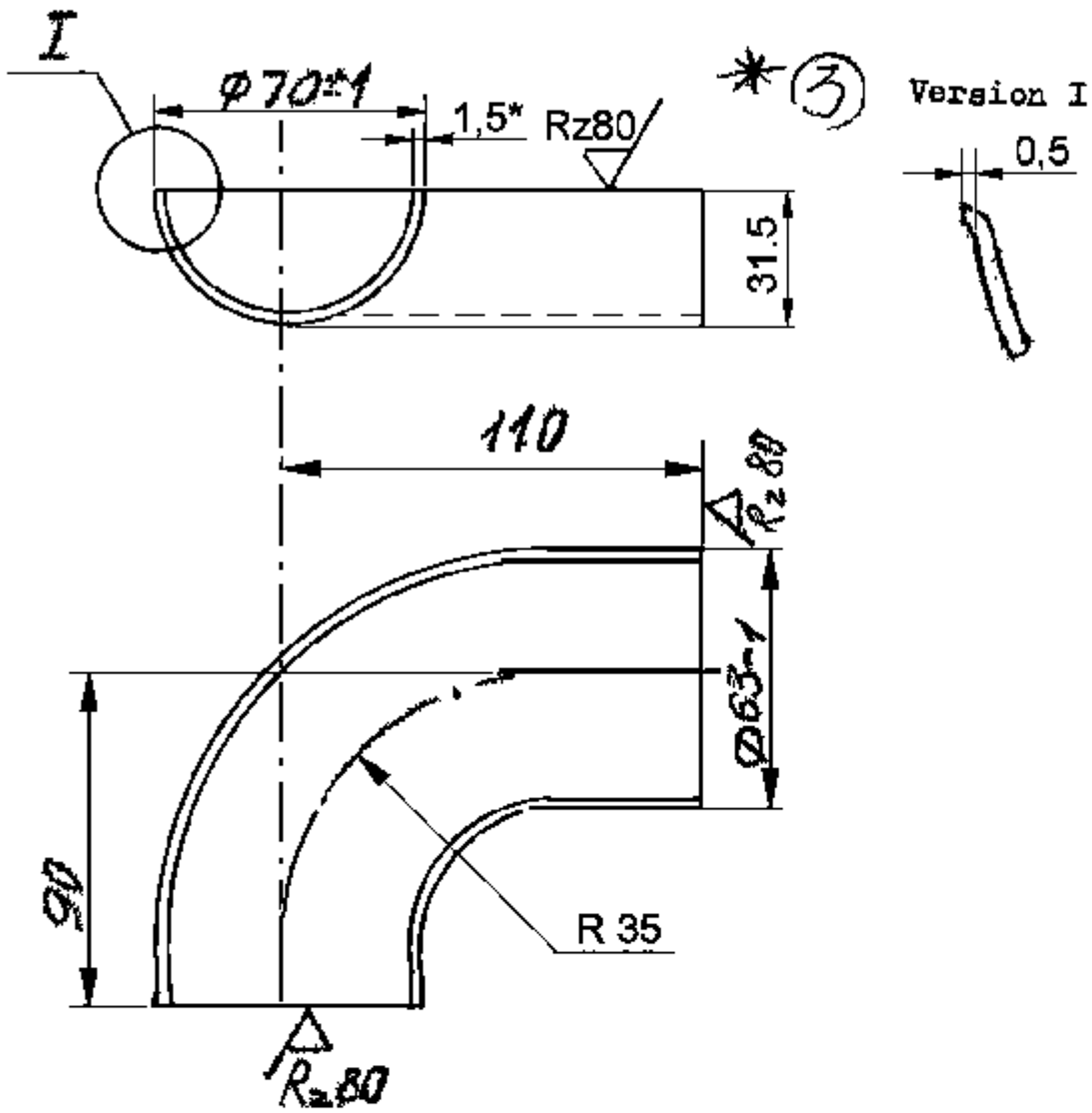
APPROVED		675-71-295	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	HUB	WEIGHT 0.109	SCALE 2:1
	Round bar 42-5 Gost 7417-75 45-H-5-B Gost 1050-74	SHT 1	SHTS 1

A3

675-71-297

(1)* 675-71-297 Shown here

*(2) 675-71-297-01 Mirror reflection



Unspecified limit deviations of sizes = ±0.5 mm.

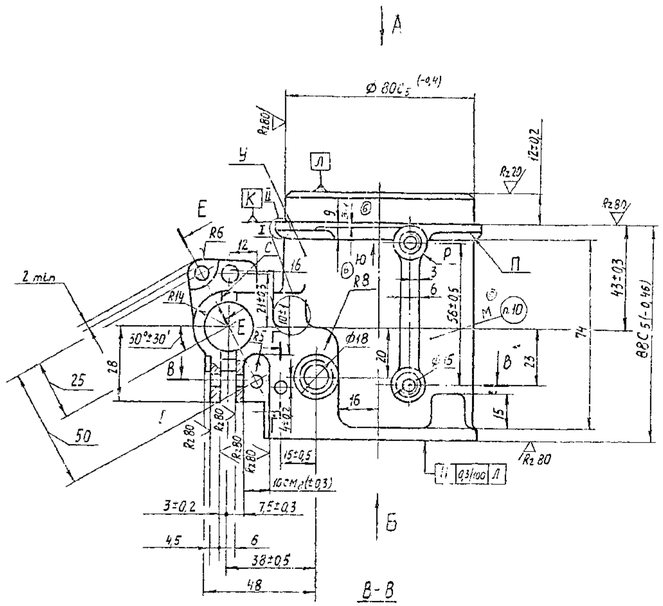
Tears with subsequent welding and dressing flush are tolerable.

*Size is given for reference.

APPROVED		675-71-297	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	BRANCH PIPE HALF	WEIGHT 0.08	SCALE 1:2
	Sheet AM4M-1,5 Gost 21631-76	SHT	SHTS

A4

675-71-300



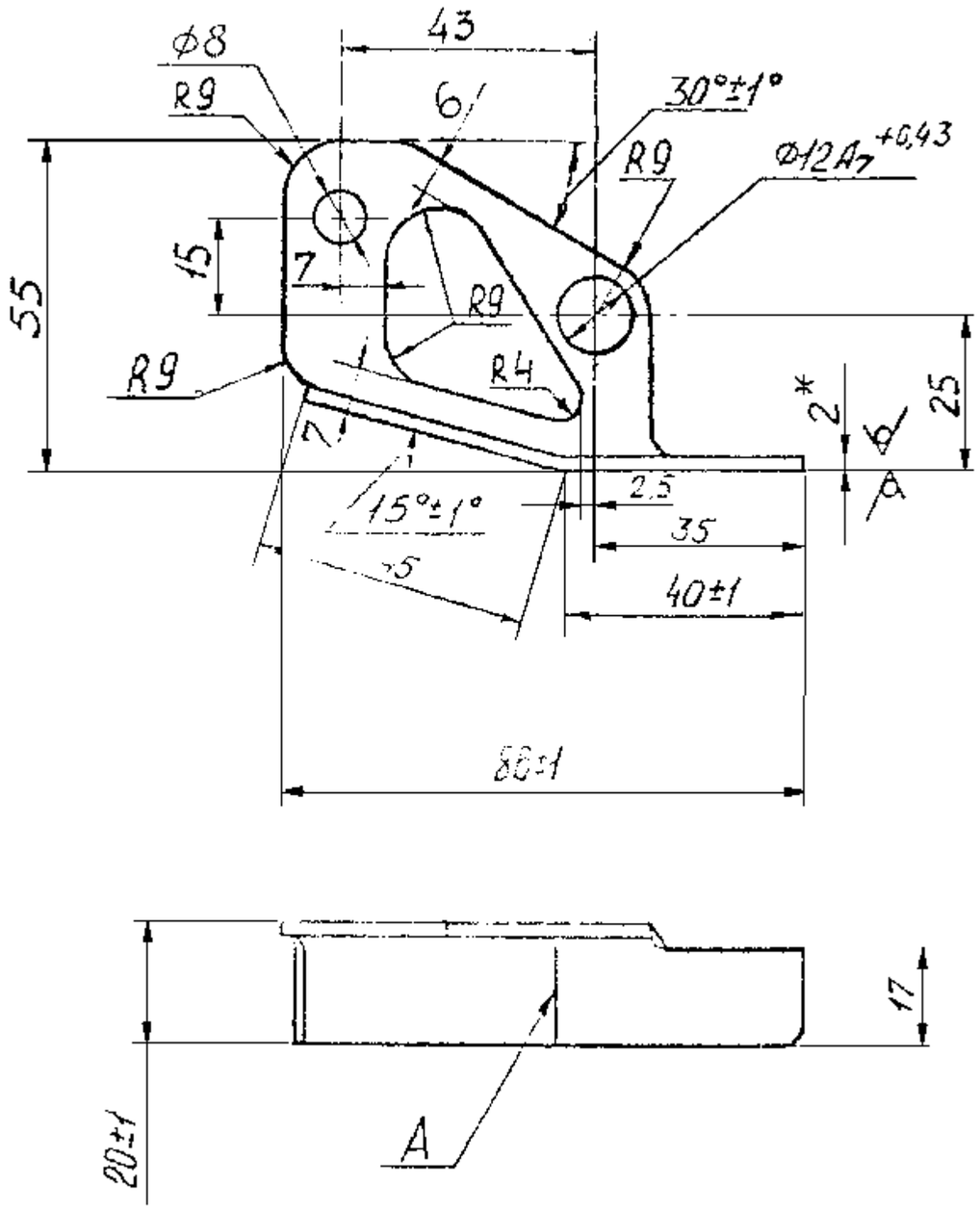
(15) TECHNICAL CONDITIONS

(1) Г – Г
Scale 2:1
(2) Two holes
(3) View Б
(4) View В
(5) by tools
(6) Two holes
(7) View А
(8) by tools
(9) Two holes
(10a) Four holes
(10) Four holes
(11) I
revolved
(12) II version
(13) 1. Substitute for material – АЛ4 ГОСТ 2685-75.
2. Drafts – 2°, maximum, in excess of tolerance limit.
3. Unspecified casting radii – 5 mm, maximum. Thickness of walls of casting – 5 mm.
4. Unspecified limit deviations of sizes after removal of layer of metal: for holes – according to A_2, for shafts – according to B_2, others – according to CM_3; for those without removal of layer of metal – $^{+1.5}_{-1.0}$ mm.
5. Displacement of axes of holes from nominal position – 0.2 mm, maximum.
6. Tool marks not in excess of 0.5 mm on surface М are tolerable.
7. Black spots of any size on surface Н are tolerable.
8. During machining of surface П incision into surface Р not in excess of 2 mm is tolerable.
9. Cut not in excess of 1 mm on surfaces С, Т and У is tolerable.
10. Mark with lettering 5 ГОСТ 2930-62.
11. Other requirements to casting – according to ТТИЛ-408.
12. When machining bosses Ш, incision into flange Щ on section Ч on size Х is tolerable.
13. *Size is given for reference.

APPROVED	675-71-300		
CHECKED	BODY	WEIGHT 0.38	SCALE 1:1
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	АЛ 9 Gost 2685-75	SHT	SHTS

675-71-303

$R_z 160$ (V)



(1) 1. HRC 22 to 30.
2. Unspecified limit deviations of sizes - ±0.5 mm.
3. Unspecified radii - 3 mm, maximum.
4. Incomplete cut on bending A with subsequent welding and dressing of weld is tolerable.
5. *Size is given for reference.
6. Substitute for material - sheet of steel 35 ГОСТ 1050-74.

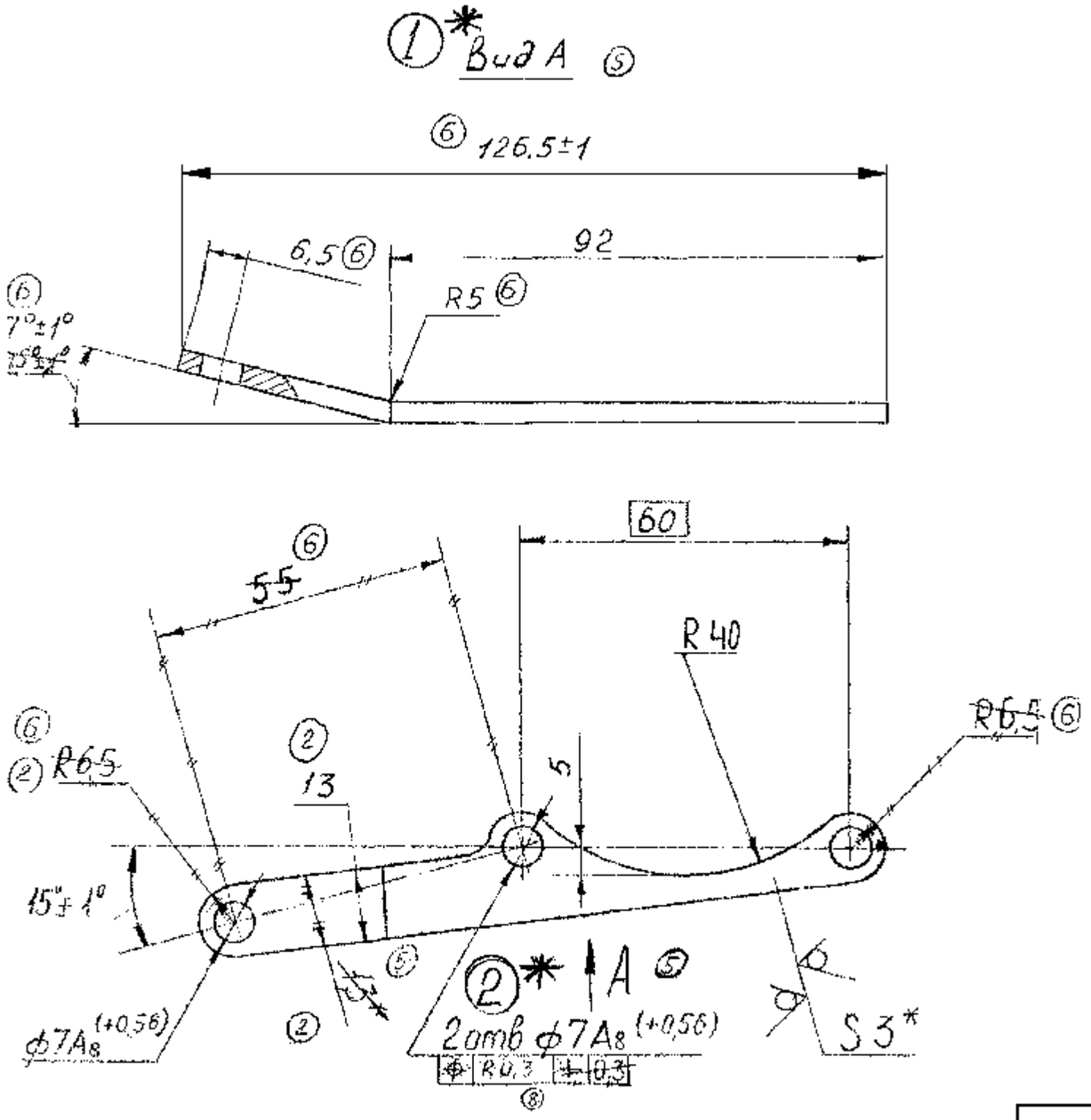
① Материал: Лист А-ПУ-О-2 ГОСТ 19904-74 / 30ХГСА-Й ГОСТ 1542-71

APPROVED		675-71-303	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	LEVER	WEIGHT 0.045	SCALE 1:1
	Sheet A-ПУ-О-2 Gost 19904-74 30ХГСА-Й Gost 1542-71	SHT	SHTS

A3

675-71-304

V (V)



✳③ TECHNICAL CONDITIONS

✳(1) View A

✳(2) Two holes

✳(3) 1. Unspecified limit deviations of sizes - ±0.5 mm.

2. Coating:

⑦ Primer ФЛ-03К ГОСТ 9109-81.

Enamel ПФ-223, white 1, ГОСТ 14923-78.

⑥ 3. *Sizes are given for reference.

4. Unspecified radii - 6.5 mm.

5. Substitute for material - sheets of steels 08кп, 10кп, 20 ГОСТ 1050-74.

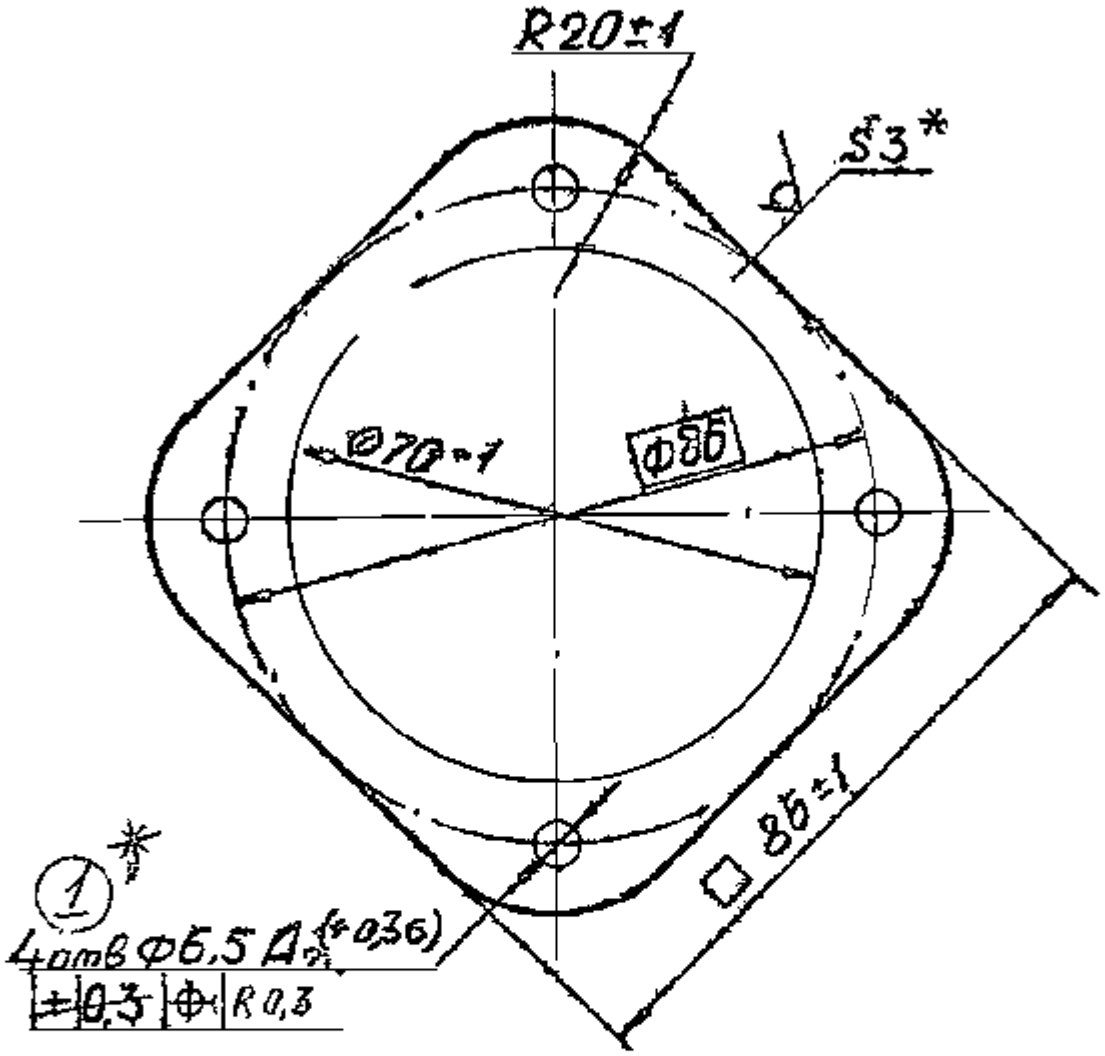
⑧ Материал: Лист $\frac{\text{Б-ПУ-О-3 ГОСТ 19903-74}}{\text{Б-III-Г-10 ГОСТ 16523-70}}$

APPROVED		675-71-304	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	BRACKET	WEIGHT 0.045	SCALE 1:1
	Sheet Б-ПУ-О-3 Gost 19903-74 Б-III-Г-10 Gost 16523-70	SHT	SHTS

A3

675-71-306

$R_z 320$ (V)



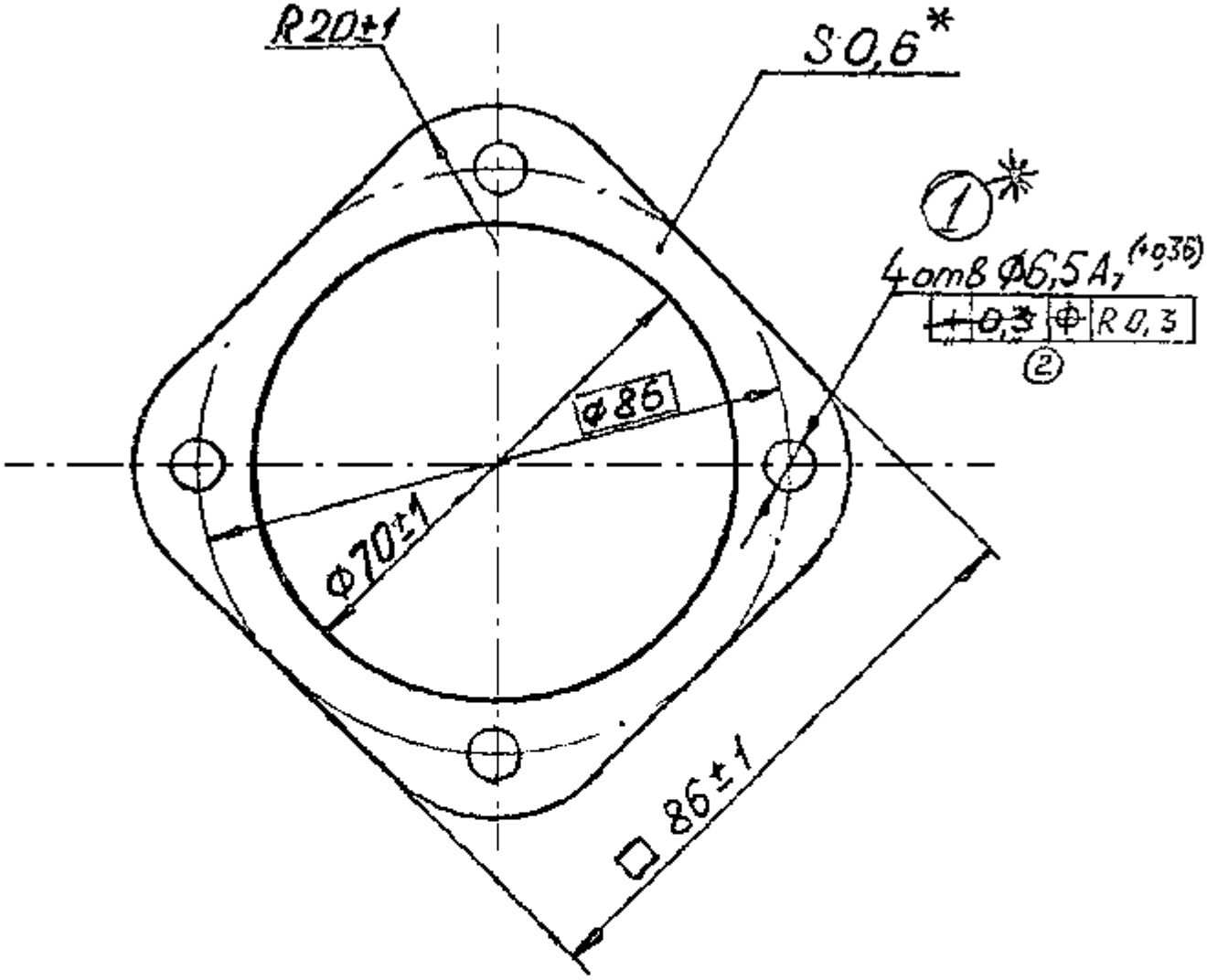
(1) Four holes

(2) 1. Substitute for material - sheet AMr5M-3 ГОСТ 21631-76.
2. *Size is given for reference.

APPROVED		675-71-306	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		FLANGE	WEIGHT 0.025 / SCALE 1:1
		Sheet AMr 65M-3 Gost 21631-76	SHT 1 SHTS 1

A4

675-71-307



*(1) Four holes
(2) *Size is given for reference.

APPROVED		675-71-307	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	GASKET	WEIGHT 0.006	SCALE 1:1
	Paronite ПОН-0,6 Gost 481-80	SHT 1	SHTS 1

A4

675-71-342

APPROVED		675-71-342	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	HOSE	LENGTH: L=0.52 mm	WEIGHT: 0.35
		SCALE: 1:2	
		SHT 1 SHTS 1	
	Billet. Hose Ø 63 mm Ty 005-6016-80.		

A4

Designation	Description	Parent unit		Total qnty	Remarks
		designation	qnty		
675-71-c64	Exhaust ventilation system			1	
675-71-c6167	Valve	675-71-c6230	1	1	
675-71-c6205	Cable	675-71-c64	1	1	
675-71-c6226	Gauze	675-71-c64	1	1	
675-71-c6227	Fan	675-71-c64	1	1	
675-71-c6228	Lever	675-71-c6230	1	1	
675-71-c6229	Body	675-71-c6230	1	1	
675-71-c6230	Box	675-71-c6227	1	1	
675-71-c6241	Fan	675-71-c6227	1	1	
675-71-c6224	Pipe	675-71-c6241	1	1	
675-71-c6225	Rotor	675-71-c6241	1	1	
672-54-c62-13	Universal clamp	675-71-c64	2	2	
765-08-c6211	Roller assembly	675-71-c64	1	1	
765-96-c6143	Cover	765-96-c6166 or 765-96-c6178-01	1	1	
765-96-c6162	Body	765-96-c6166	1	1	
765-96-c6166 or 765-96-c6178-01	Pressure-type limit switch	675-71-c6230	1	1	
765-96-c6177	Body	765-96-c6178-01	1	1	
2РМ14Б4Ш1В1	Plug	765-96-c6143	1	1	w/out drg. Vendor item.
	~~РБ0.364.127 ТУ~~ Microswitch Д 703.НО.360 011	765-96-c6143	1	1	W/OUT DRG. VENDOR ITEM.
	Relay РМ6-1С РМ6-1С.000ТУ	675-71-c6230	1	1	VENDOR ITEM
	Electric motor МБП-3Н	675-95-c6179	1	1	W/OUT DRG. VENDOR ITEM.
675-95-c6179	Fan electric motor	675-71-c6241	1	1	

APPROVED		675-71-cn4		
CHECKED		EXHAUST VENTILATION SYSTEM	WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)			SHT 1	SHTS 13

Designation	Description	Parent unit designation	Parent unit qnty	Total qnty	Remarks
	Terminal block МРТ20П33М7 ТЕО.364.108 ТУ	675-95-c6179	1	1	VENDOR ITEM
675-71-263	Gasket	675-71-c6227	1	1	
675-71-144	Gasket	675-71-c64	1	1	
675-71-148	Shaft	675-71-c6230	1	1	
675-71-155	Sheath	675-71-c6205			
675-71-157	Bushing	675-71-c6229	1	1	
675-71-160	Boss	675-71-c6228	1	1	
~~675-71-164~~	~~Flange~~	~~675-71-c6165~~	~~1~~	~~1~~	(A)
675-71-167	Gasket	675-71-c6167	1	1	
675-71-168	Valve	675-71-c6167	1	1	
675-71-172	Branch pipe half	675-71-c6224	1	1	
675-71-172-01	Branch pipe half	675-71-c6224	1	1	
675-71-289	Volute	675-71-c6241	1	1	
675-71-290	Wall	675-71-c6241	1	1	
675-71-291	Sealing gasket	675-71-c6241	4	4	Max. qnty
675-71-292	Cover plate	675-71-c6226	2	2	
675-71-293	Impeller	675-71-c6225	1	1	
675-71-294	Gauze	675-71-c6226	1	1	
675-71-295	Hub	675-71-c6225	1	1	
675-71-297	Branch pipe half	675-71-c6224	1	1	
675-71-297-01	Branch pipe half	675-71-c6224	1	1	
675-71-300	Body	675-71-c6229	1	1	
675-71-303	Lever	675-71-c6228	1	1	
675-71-304	Bracket	675-71-c6227	1	1	
675-71-306	Flange	675-71-c6224	1	1	
675-71-342	Hose	675-71-c64	1	1	
675-71-307	Gasket	675-71-c6241	1	1	
672-35-1	Screw	675-71-c6225	3	3	
672-31-11	Washer	675-71-c6241	2	2	

No	ISSUE	DATE
74	A	11-2-87

AMENDMENTS

APPROVED	
CHECKED	
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	

675-71-cn4

EXHAUST VENTILATION SYSTEM

	WEIGHT	SCALE

SHT 2 SHTS 13

Designation	Description	designation	qnty	Total qnty	Remarks
672-30-8	Nut	675-71-c6241	2	2	
672-54-5	Frame	672-54-c62-13	1	2	
672-54-6-13	Tape	672-54-c62-13	1	2	
765-08-363	Roller	765-08-c6211	1	1	
765-10-428	Handle	675-71-c64	1	1	
765-10-445	Limiter	675-71-c64	1	1	
765-56-57	End-piece	675-71-c6205	1	1	
765-64-499	Collar	765-96-c6166 or 765-96-c6178-01	1	1	
765-71-364	Flange	675-71-c6230	1	1	
765-71-391	Bushing	675-71-c6228	1	1	
765-71-812 or 765-71-1773	Retainer	675-71-c6230	1	1	
765-71-813	Clamp	675-71-c6230	1	1	
765-71-814	Lever	675-71-c6230	1	1	
765-71-815	Pusher	675-71-c6230	1	1	
765-71-819-01	Bushing	675-71-c6229	1	1	
765-71-1120	Clip	675-71-c64	1	1	
765-96-15	Gasket	765-95-c6143	1	1	
765-96-16	Gasket	765-96-c6166	1	1	
765-96-73 or 765-96-143	Cover	765-96-c6143	1	1	
REF DC COND 0042H-ICV LV21RCV-5330-cn9541 765-96-74	Gasket	765-96-c6166 or 765-96-c6178-01	4 3	4 3	Max.qnty Max.qnty
765-96-119	Rod	765-96-c6166 or 765-96-c6178-01	1	1	

APPROVED	[signature]	675-71-cn4		
CHECKED	[signature]		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		EXHAUST VENTILATION SYSTEM		
			SHT 3	SHTS 13

Designation	Description	Parent unit		Total qnty	Remarks
		designation	qnty		
765-96-121	Gasket	765-96-c6166	6	6	Max.qnty
		or			
		765-96-c6178-01	5	5	Max.qnty
765-96-151	Plate	765-96-c6166	1	1	
		or			
		765-96-c6178-01			
765-96-152	Plate	765-96-c6166	1	1	
		or			
		765-96-c6178-01			
765-96-161	Bushing	765-96-c6162	1	1	
765-96-165	Body	765-96-c6162	1	1	
765-96-168	Retainer	765-96-c6178-01	1	1	
or					
765-96-176					
765-96-195	Gasket	765-96-c6178-01	1	1	
765-96-202	Body	765-96-c6177	1	1	
765-96-350	Screw	765-96-c6178-01	1	1	
765-96-351	Bushing	765-96-c6177	1	1	
700-30-455	Nut	765-96-c6166 or	1	1	
		765-96-c6178-01			
700-35-368	Screw	765-96-c6166	1	1	
700-35-408	Screw	765-96-c6166 or	1	1	
		765-96-c6178-01			
700-38-1123	Spring	675-71-c6230	1	1	
700-38-1495	Spring	765-96-c6166 or	1	1	
		765-96-c6178-01			
700-38-1577	Spring	675-71-c6230	1	1	
700-40-153	Gasket	765-96-c6166 or	1	1	
		765-96-c6178-01			
700-28-478	Bolt	675-71-c64	1	1	
700-31-267	Washer	675-71-c64	2	2	

APPROVED		675-71-cn4		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		EXHAUST VENTILATION SYSTEM	WEIGHT	SCALE
			SHT 4	SHTS 13

Designation	Description	Parent unit		Total qnty	Remarks
		designation	qnty		
672-32-11	Cotter pin	672-54-c62-13	1	2	
672-47-5-01	Axle	675-71-c6230	1	1	
672-35-3-02	Screw	675-71-c6241	6	6	
672-31-71	Tab washer	675-71-c6227	4	4	
672-54-9-02	Clamp	675-71-c64	1	1	
	Bolt M6x14.46.019	675-71-c64	6	6	
	ГОСТ 7798-70	675-71-c6241	4	4	
	Bolt M6x20.46.019	675-71-c64	4	4	
	ГОСТ 7798-70				
	Screw	765-96-c6166	2	2	
	A1.M2-6gx5.48.016	or			
	ГОСТ 17473-80 or				
	A.M2-6gx5.66.016	765-96-c6178-01			
	ГОСТ 1491-80				
	Screw	765-96-c6143	2	2	
	A1.M2-6gx18.48.016				
	ГОСТ 17473-80 or				
	A.M2-6gx18.66.016				
	ГОСТ 1491-80				
	Screw	765-96-c6166	4	4	
	B1.M3-8h6hx8.48.016	or			
	ГОСТ 17473-80 or	765-96-c6178-01	7	7	
	B.M3-8h6hx8.66.016	765-96-c6143	4	4	
	ГОСТ 1491-80				
	Screw	675-71-c64	2	2	
	B1.M4-8h6hx10.48.016				
	ГОСТ 17473-80				
4368-0610	Boss M6x12x10	675-71-c6154	5	5	
	ОСТ 3-1496-72				
	Screw	675-71-c6230	2	2	
	B.M4-8h6hx70.66.016				
	ГОСТ 1491-80				

APPROVED

CHECKED

CONTROLLERATE OF QUALITY ASSURANCE (ICV)

675-71-cn4

EXHAUST VENTILATION SYSTEM

	WEIGHT	SCALE

SHT 5 SHTS 13

Designation	Description	Parent unit		Total qnty	Remarks
		designation	qnty		
GRUB SCREW E-M 6x20 TO IS:2389-6-6. PITCH 1mm AS PER IS:4218(PT-III)76 ZINC PLATED 9μ THICK.	Screw M6x20.66.05	675-71-c64	2	2	(REF. DCL NO. 00360-ICV
	ГОСТ 1478-75				
	Nut M6.6.019	675-71-c64	1	1	
	ГОСТ 5927-70	675-71-c6227	4	4	
		675-71-c6230	2	2	
	Nut M4.6.016	675-71-c6230	2	2	
	ГОСТ 5927-70				
	Nut M5.6.016	675-71-c6230	1	1	
	ГОСТ 5932-73				
	Rivet 2x10-32	675-71-c6230	1	1	
	ГОСТ 10299-80				
	Bearing 6-80029	765-08-c6211	1	1	Vendor
	ГОСТ 7242-70 and				item
	ETV 500				
	Washer 2x1.001	765-96-c6143	2	2	
	ГОСТ 11371-78				
	Washer 4.01.019	675-71-c6230	2	2	
	or 4.02.019				
	ГОСТ 11371-78				
	Washer 5.01.019	675-71-c6230	1	1	
	or 5.02.019				
	ГОСТ 11371-78				
	Washer 4.01.019	675-71-c64	2	2	
	or 4.02.019				
	ГОСТ 11371-78				
	Washer 2T65Г05	765-96-c6166	2	2	
	ГОСТ 6402-70	or			
		765-96-c6178-01			
		765-96-c6143	2	2	
	Washer 3T65Г05	765-96-c6143	4	4	
	ГОСТ 6402-70	765-96-c6166 or	4	4	
		765-96-c6178-01	7	7	

APPROVED

CHECKED

CONTROLLERATE OF QUALITY ASSURANCE (ICV)

675-71-cn4

EXHAUST VENTILATION SYSTEM

WEIGHT | SCALE

SHT 6 SHTS 13

Designation	Description	Parent unit		Total Qnty	Remarks
		designation	Qnty		
EQ.MAT.C-30 TO IS:1570-79	Washer 6x1.01.019	675-71-c64	8	8	Ref.DC(D)00957 -ICV
	or 6x1.02.019	675-71-c6230	2	2	
	ГОСТ 11371-78	675-71-c6241	4	4	
	Washer 24x1,5,35	675-71-c6230	3	3	Max.qnty
	ГОСТ 11371-78				
	Washer 4Т65Г05	675-71-c64	2	2	
	ГОСТ 6402-70	675-71-c6230	2	2	
	Washer 6Т65Г06	675-71-c64	10	10	
	ГОСТ 6402-70	675-71-c6230	2	2	
		765-96-c6166	1	1	
		or			
		765-96-c6178-01			
		675-71-c6241	4	4	
	Washer 8Т65Г06	675-71-c64	1	1	
	ГОСТ 6402-70	765-96-c6166	1	1	
		or			
		765-96-c6178-01			
	Cotter pin	675-71-c6230	1	1	
	1x12.019				
	ГОСТ 397-79				
	Cotter pin	675-71-c6230	1	1	
	1,6x10.019				
	ГОСТ 397-79				
	Pin	675-71-c6230	2	2	Without break-down into groups
	M6-6gx32.66.019				
	ГОСТ 22038-76				

APPROVED		675-71-cn4		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		EXHAUST VENTILATION SYSTEM	WEIGHT	SCALE
			SHT 7	SHTS 13

Designation	Description	Parent unit		Total qnty	Remarks
		designation	qnty		
	Stud M6 x $\frac{T_i 2}{6g}$ x16.66.019 ГОСТ 22036-76	675-71-сб230	2	2	Without break-down into groups Replace-ment with 29363 is allowed. Coating: zinc 9 Cr.
	Stud M6 x $\frac{T_i 2}{6g}$ x20.66.019 ГОСТ 22034-76	675-71-сб230	2	2	Without break-down into groups
	Pin ОСТ 3-2234-80 2Пр2₂ах12 or 700-32-315-01	675-71-сб241	2	2	HB 255 to 207 (Ø3.8 to 4.2)
	2Пр2₂ах14 or 700-32-315	675-71-сб230	1	1	
	3Пр2₂ах12	675-71-сб230	1	1	
	5Пр2₂ах28	675-71-сб230	1	1	
	Ball Б6-200 ГОСТ 3722-81 and ETУ 500	765-96-сб166 or 765-96-сб178-01	1	1	Vendor item
	Hose Ø63 ~~МРТУ 38-5-6105-68~~ 7У005-6016-80 (blank for 675-71-342)	675-71-сб4	0.52m	0.52	
	Wire К01 ГОСТ 792-67	675-71-сб225	0.2m	0.2	
		675-71-сб241	1.2m	1.2	
	Rope 1.8 ГОСТ 2172-71	675-71-сб205	1.45m	1.45m	

APPROVED		675-71-сп4		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		EXHAUST VENTILATION SYSTEM	WEIGHT	SCALE
			SHT 8	SHTS 13

Designation	Description	Parent unit		Total qnty	Remarks
		designation	qnty		
	Pipe III-TB-50-355-2,5, unpainted ГОСТ 19034-73	765-96-сб143	0.2 m	0.9 m	
	Pipe III-TB-50-355-3,5, unpainted ГОСТ 19034-73	765-96-сб143	0.08m	0.32m	
	Pipe III-TB-50-355-4,5, unpainted ГОСТ 19034-73	675-71-сб230 675-95-сб179	.06m 0.02m	0.06m 0.02m	
	Wire K00,5 ГОСТ 792-67	675-95-сб179	0.54m	0.54m	
	Primer ФЛ-03Ж ГОСТ 9109-81	675-71-сб224 675-71-сб229 765-71-сб266 765-96-сб162 or 765-96-сб177			
	Cement 88-НП ТУ 38-105540-73	675-71-сб167			
	Phenol-formaldehy- de lacquer ГОСТ 901-78	675-71-289 675-71-290 765-96-сб143			
	Wire МГШВ-0,35 mm^2 ТУ 16-505-437-73	765-96-сб143	0.16m	0.16m	
	Solder 4ПОССу30-2 ГОСТ 21930-76	675-71-155 675-71-292			
	Solder ПОС-40 ГОСТ 21931-76	765-96-сб143			

APPROVED	675-71-сп4		
CHECKED	EXHAUST VENTILATION SYSTEM	WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		SHT 9	SHTS 13

Designation	Description	Parent unit		Total qty	Remarks
		designation	qty		
	Solder ПОС-61 ГОСТ 21931-76	765-96-сб143			
	Solder ПОССу30-2 ГОСТ 21931-76	675-71-сб205			
	Lubricant Литол-2 ГОСТ 21150-75	675-71-сб230			
	Iron minium ГОСТ 8866-76	675-71-сб4 675-71-сб230			
	Enamel ПФ-223, white 1, ГОСТ 14923-78	675-71-сб224 675-71-сб229 765-71-сб266 675-71-304			
	Red enamel ПФ-223 ГОСТ 14923-78	765-96-сб166 or 765-96-сб178-01			
	Enamel ПФ-223, dark grey, ГОСТ 14923-78	765-96-сб162			
	Primer ФЛ-03К ГОСТ 9109-81	675-71-304			
	Enamel МЛ-165, silver, ГОСТ 12034-77	765-96-сб177			
	Enamel МЛ-12, grey, ГОСТ 9754-76	765-96-сб177			
765-96-ТТ101	Technical requirements for installation and checking of limit switches				

APPROVED		675-71-сп4		
CHECKED		EXHAUST VENTILATION SYSTEM	WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)			SHT 10 SHTS 13	

Designation	Description	Parent unit		Total qnty	Remarks
		designation	qnty		
~~MUL-48~~	~~Instructions on phosphatising of parts~~				
765-c64 TU2	Specifications for manufacture, testing and commissioning of assemblies and parts of main production items				
~~TTM-1-78~~	~~Technical requirements for blanks made of hot-die powder-steels~~				
TU 22-3708-76	Specifications. Metal sheathes				
TU 0005216-75	Rubber parts, plates and compositions for special vehicles and their engines				
PM6-1C.000 TU	Relay PM6-1C. Specifications				
TU 3-624-76	Blanks for critical parts made of iron-based materials by powder metallurgy. Specifications				
053.25273.000.10	Instructions for bakelizing parts				

APPROVED		675-71-cn4		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		EXHAUST VENTILATION SYSTEM	WEIGHT	SCALE
			SHT 11	SHTS 13

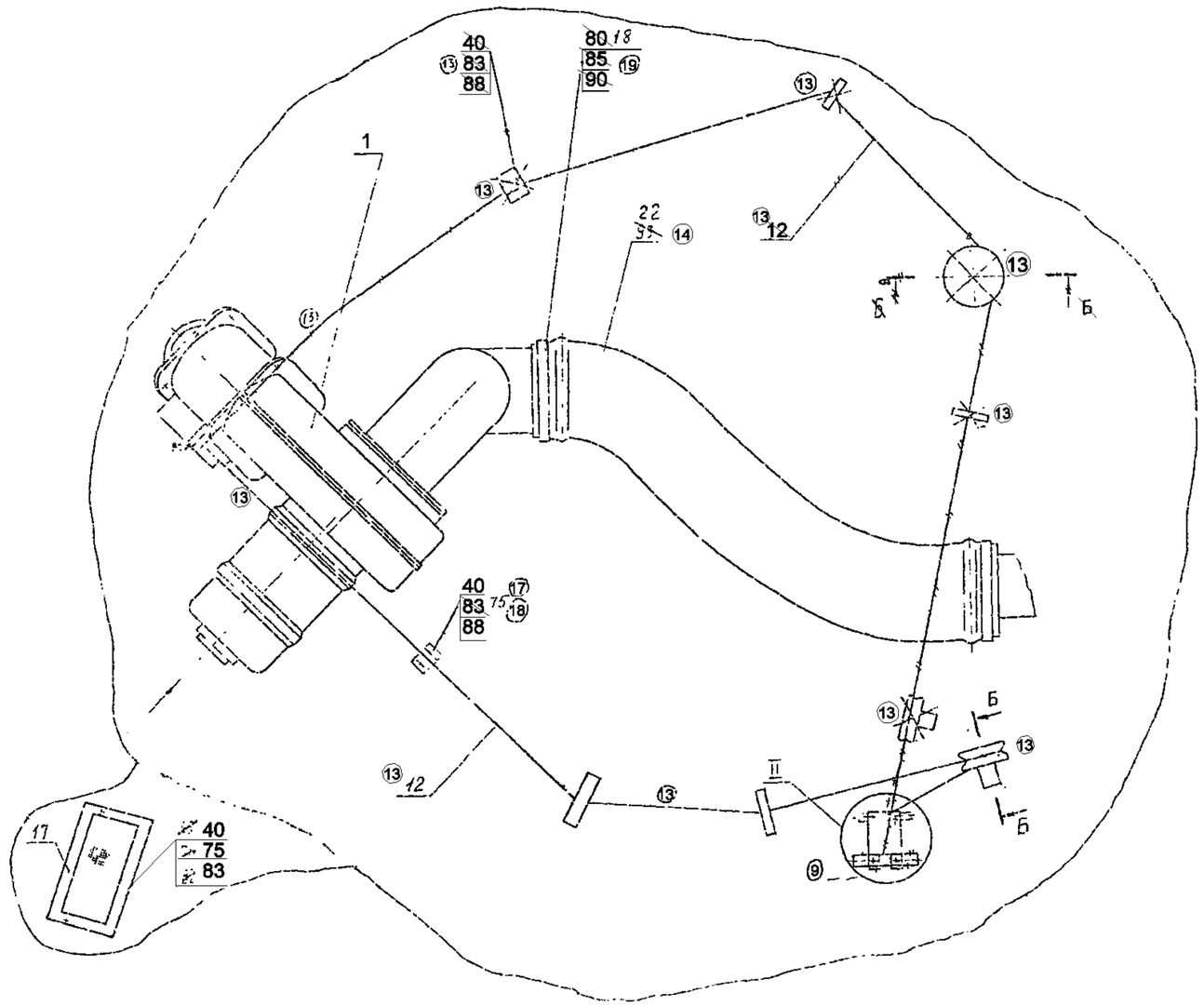
Designation	Description	Parent unit		Total qnty	Remarks
		designation	qnty		
700-88-TT2	Technical requirements for manufacture and installation of electric wires and cable assemblies				
TY 16-505437-73	Specifications for hook-up wires with film or fibrous and polychloride insulation				
TY 16.505.911-76	Wires with PVC insulating material in varnish-coated sheathing for vehicle electrical system				
I-50-6	Instructions for marking and certifying assemblies and parts				
TTHI-408	Technical requirements for acceptance of castings made of aluminium and bronze alloys				
TY 38-105540-73	Specifications for cement 88-HH				
TY 38-105817-7581	Specifications for sponge plate with two films				

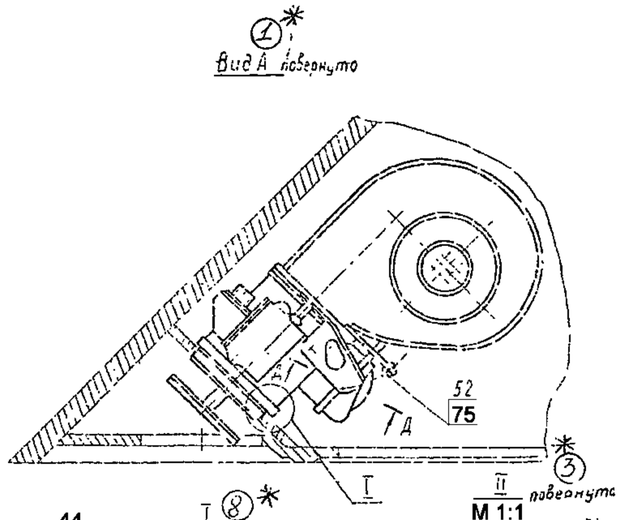
APPROVED		675-71-cn4		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		EXHAUST VENTILATION SYSTEM	WEIGHT	SCALE
			SHT 12	SHTS 13

Designation	Description	Parent unit		Total qnty	Remarks
		designation	qnty		
~~MPTV 38-5-6105-68~~ TY005-6016-80 053.25289.00001	Specifications for vehicle heater parts Impregnation of felt parts and asbestos cord with graphite lubricant Instructions				

APPROVED		675-71-cn4		
CHECKED		EXHAUST VENTILATION SYSTEM	WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)			SHT 13 SHTS 13	

675-71-Sb 4 Sb





TECHNICAL CONDITIONS

*(1) View A revolved

*(2) 1. Fully tighten up all bolts and screws and lock them, where required.

2. Drive in screw Ref. No. 48 and bolt Ref. No. 40 so as to ensure reliable attachment of cable at force of (392.4±49) or (40±5) kgf at handle Ref. No. 32.

3. Stop lever and check operation of suction fan which should operate smoothly without seizing.

4. When installing assembly Ref. No. 1, it is allowed to remove pressure-type limit switch with its subsequent installation in situ.

5. Install bolts Ref. No. 40 on iron minium ГООТ 8866-76.

6. At maximum angle of elevation, pinch of hose Ref. No. 93 by link ejection chute of system 6П7 is tolerable.

*(3) II revolved
Scale 1:1

*(4) Projection of cable end is not tolerable

*(5) Б - Б revolved
Scale 1:1

*(6) Д - Д
Scale 1:1

*(7) Г - Г
Scale 1:1

*(8) I
Scale 1:2

APPROVED		675-71-Sb 4 Sb	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	EXHAUST VENTILATION SYSTEM	WEIGHT 9.03	SCALE 1:1
		SHT 1	SHTS 1

Ref. No.	Designation	Description	Qnty	Remarks
		Documents		
	675-71-c6167CB	Assembly drawing		
		Parts		
1	675-71-167	Gasket	1	
2	675-71-168	Valve	1	

APPROVED
CHECKED

675-71-Sb167

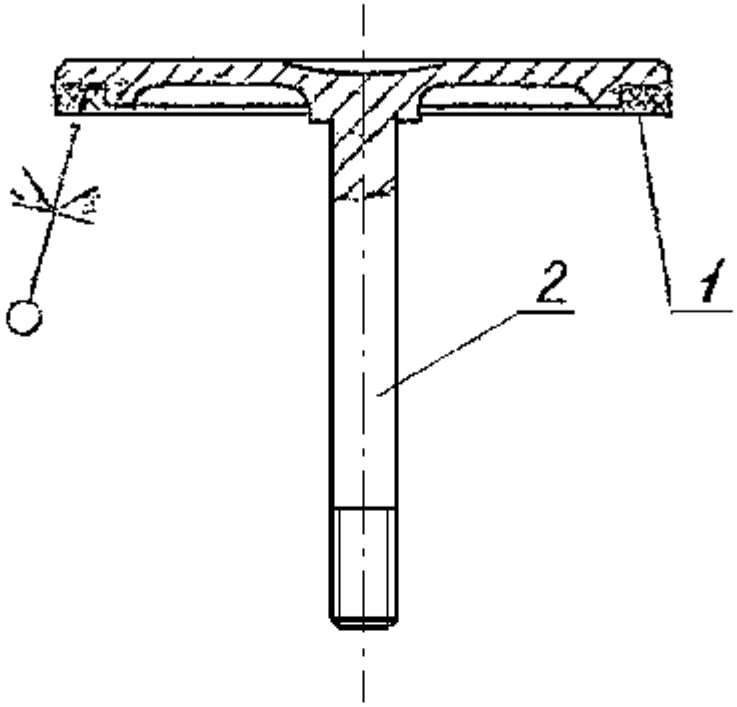
CONTROLLERATE OF QUALITY ASSURANCE (ICV)

VALVE

	WEIGHT	SCALE

SHT SHTS

675-71-Sb167Sb



Cement 88-НП ТУ 38-105540-73.

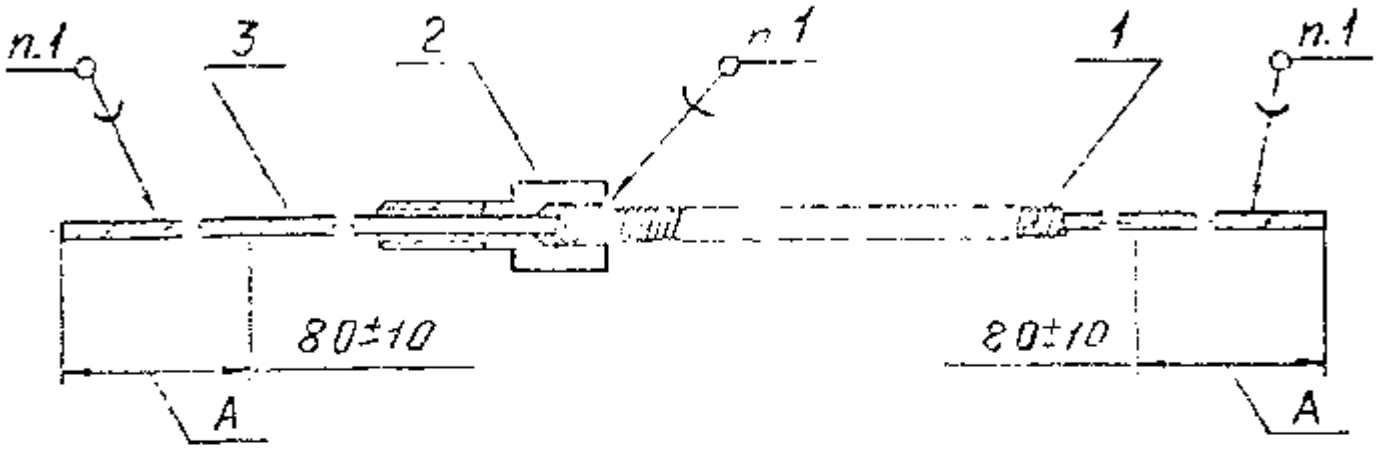
APPROVED		675-71-Sb167Sb	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		VALVE	WEIGHT: 0.181 SCALE: 1:1 SHT SHTS

A4

Ref. No.	Designation	Description	Qnty	Remarks
		Documents		
	675-71-c6205CB	Assembly drawing		
		Parts		
1	675-71-155	Sheath	1	
2	765-56-57	End-piece	1	
		Materials		
3		Rope 1,8 ГОСТ 2172-7280 L = 1.45 m	1	

APPROVED CHECKED		675-71-Sb205		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		CABLE	WEIGHT / SCALE	
			SHT SHTS	

675-71-Sb205Sb



1. Solder ПОССу30-2 ГОСТ 21931-76 or ПОССу18-2 ГОСТ 21931-76.
2. Solder ends of cable Ref. No. 3 along length A.
3. Lubricate soldered points with oil К-17 ГОСТ 10877-76.

APPROVED	675-71-Sb205Sb	
CHECKED		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	CABLE	WEIGHT 0.137 SCALE 1:1
		SHT 1 SHTS 1

A4

Ref. No.	Designation	Description	Qnty	Remarks
		Documents		
	675-71-c6224CE	Assembly drawing		
		Parts		
1	675-71-172	Branch pipe half	1	
2	675-71-172-01	Branch pipe half	1	
3	675-71-297	Branch pipe half	1	
4	675-71-297-01	Branch pipe half	1	
6	675-71-306	Flange	1	

APPROVED
CHECKED

675-71-Sb224

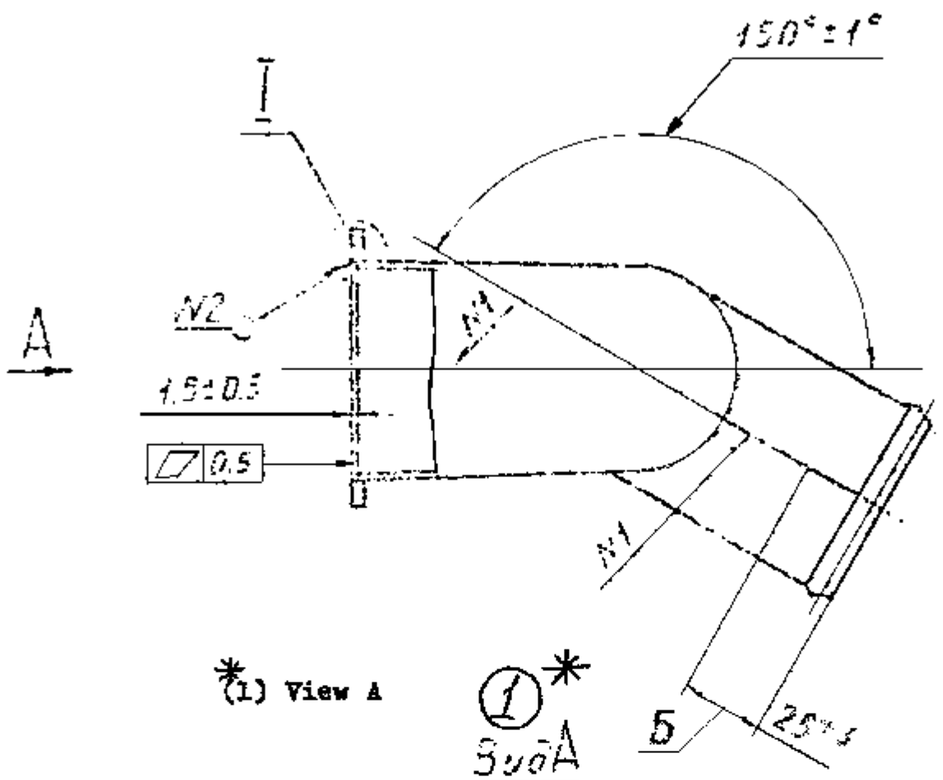
CONTROLLERATE OF QUALITY ASSURANCE (ICV)

PIPE

	WEIGHT	SCALE

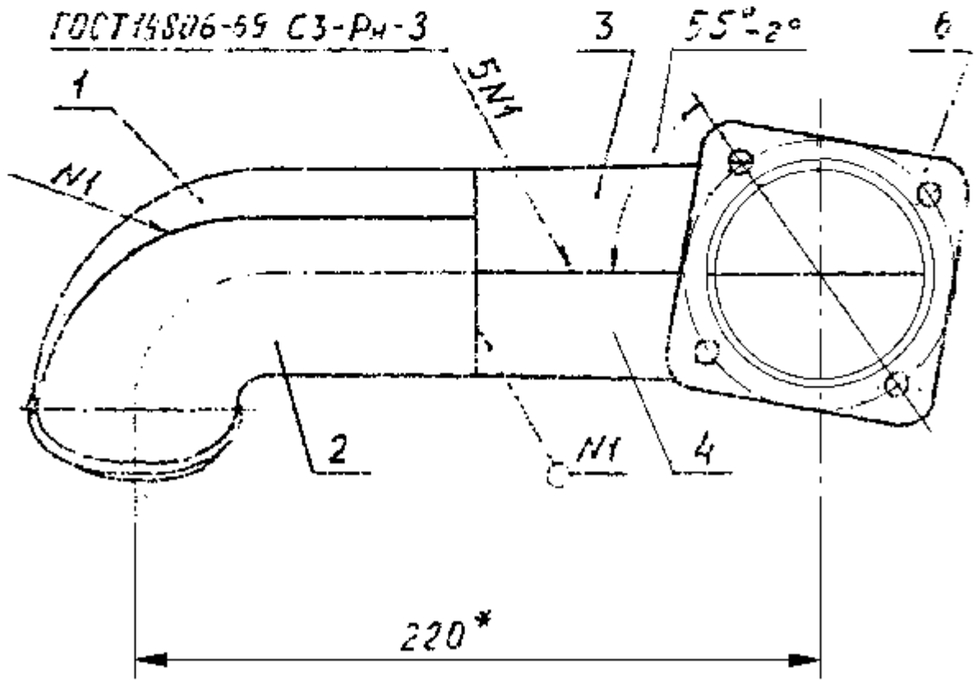
SHT SHTS

675-71-Sb224Sb



*(1) View A

*(3) Scale 2:1



1. Weld No. 2 - argon-arc welding.
2. At section Б displacement of welded part edges - 0.7 mm, maximum.
3. Dress welds at section Б and surface В flush.
4. Other requirements for quality of welds - according to ОСТ 3-4001-77 for off-design welded joints.
5. Coating of outer surfaces, except for surface В:
   primer ФЛ-03К ГОСТ 9109-81;
   enamel ПФ-223, white 1, ГОСТ 14923-78.
6. *Size is given for reference.

APPROVED		675-71-Sb224Sb	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		PIPE	WEIGHT 0.32 SCALE 1:2
			SHT 1 SHTS 1

Ref. No.	Designation	Description	Qnty	Remarks
		Documents		
	675-71-c6225CB	Assembly drawing		
		Parts		
1	675-71-293	Impeller	1	
2	675-71-295	Hub	1	
3	672-35-1	Screw	3	
		Materials		
5		Wire KO-1 ГОСТ 792-67 L = 0,2 m	1	

APPROVED

CHECKED

675-71-Sb225

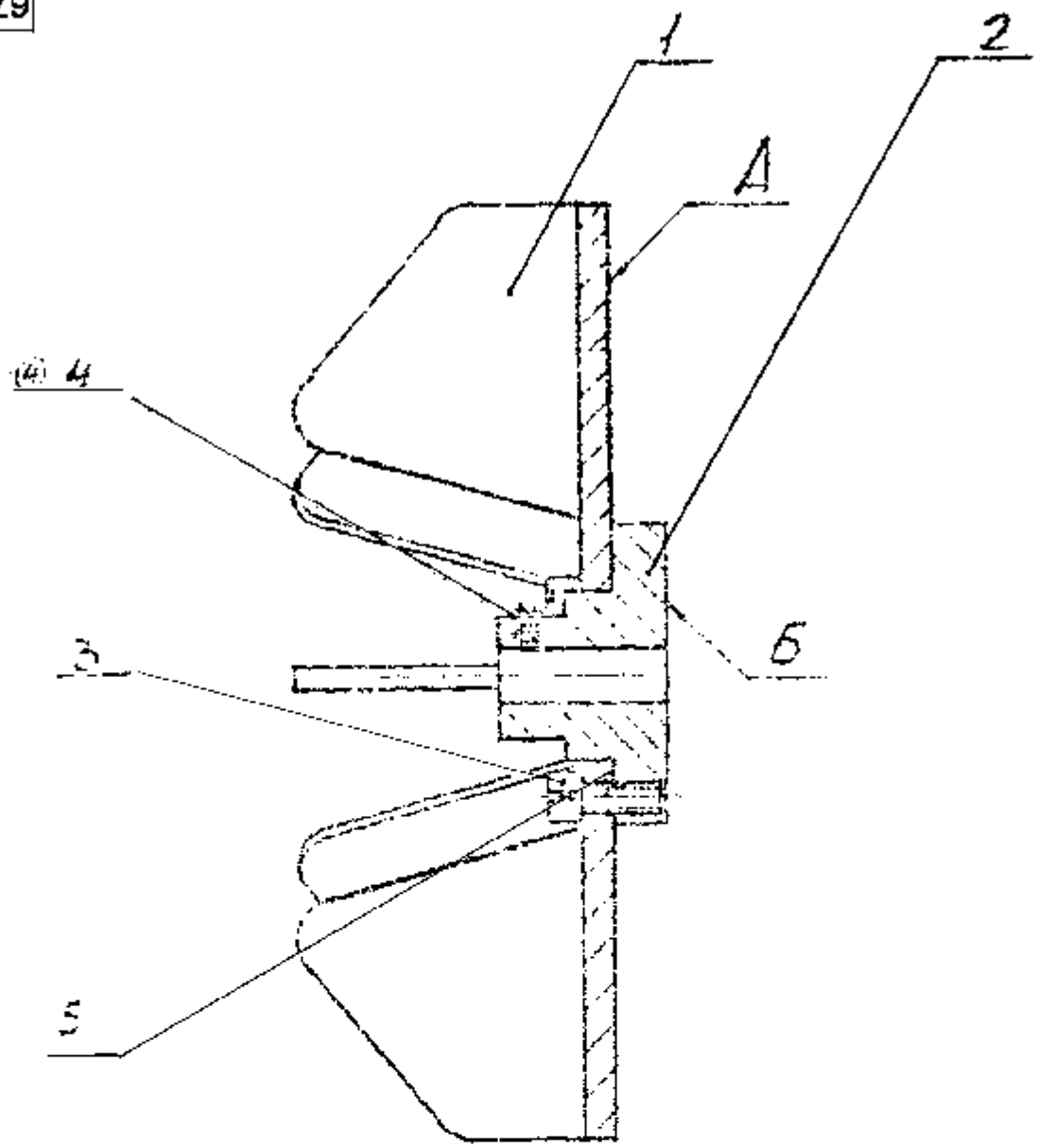
CONTROLLERATE OF QUALITY ASSURANCE (ICV)

ROTOR

	WEIGHT	SCALE

SHT SHTS

675-71-Sb225Sb



Subject rotor to static balancing. At arm of 65 mm static unbalance - 0.5 g, maximum.
During balancing it is tolerable to drill holes Ø 5 mm up to 1 mm deep at radius of 35 mm, maximum, on surface A and on surface B, holes Ø 5 mm, maximum, up to 4 mm deep. In this case, projection of balancing holes beyond contour of part Ref. No. 2 or cutting in thread is not tolerable.

APPROVED		675-71-Sb225Sb
CHECKED		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	ROTOR	WEIGHT 0.325 SCALE 1:1 SHT 1 SHTS 1

A4

Ref. No.	Designation	Description	Qnty	Remarks
		Documents		
	675-71-c6226CB	Assembly drawing		
		Parts		
1	675-71-292	Cover plate	2	
2	675-71-294	Gauze	1	

APPROVED
CHECKED

675-71-Sb226

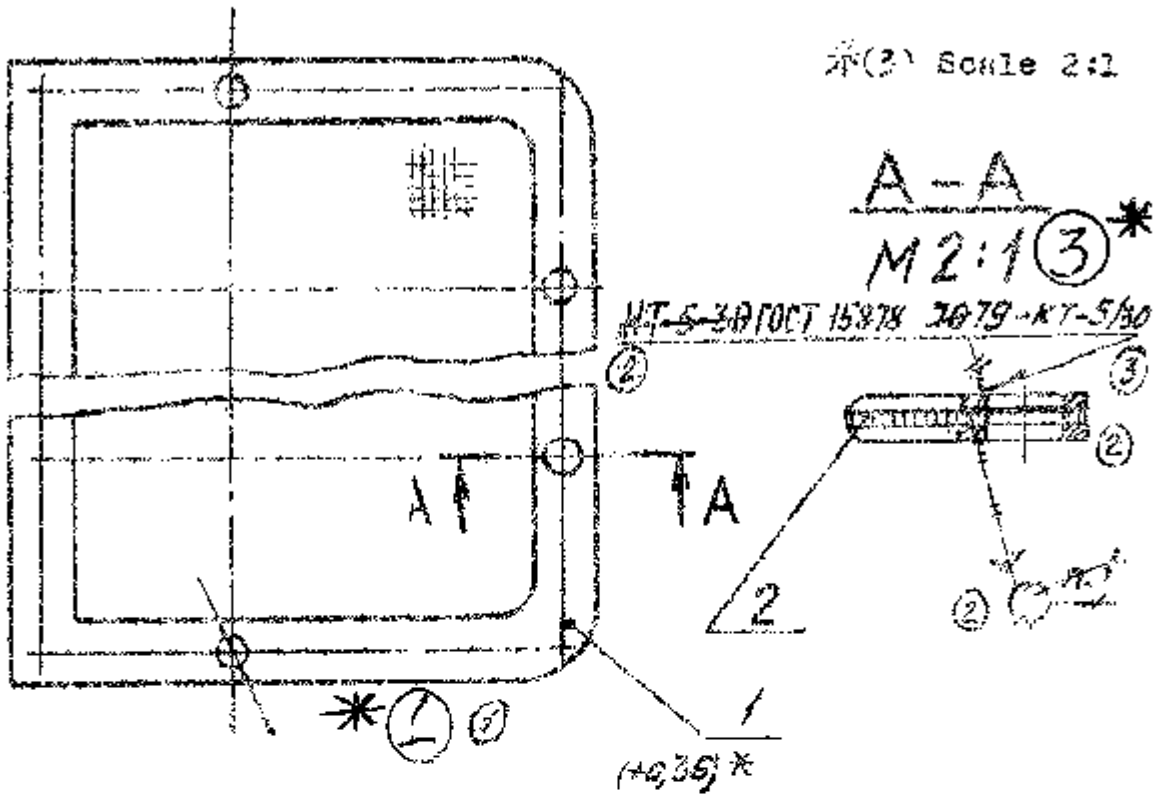
CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

GAUZE

	WEIGHT	SCALE

SHT SHTS

675-71-Sb226Sb



(1) **Four holes**

(3) Finish according to part Ref. No. 1.

APPROVED		675-71-Sb226Sb
CHECKED		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	GAUZE ASSY DRG.	WEIGHT: 0.03 SCALE: 1:1 SHT SHTS

Ref. No.	Designation	Description	Qnty	Remarks
		Documents		
	675-71-c6227C5	Assembly drawing		
		Assembly Units		
1	675-71-c6241	Fan	1	
2	675-71-c6230	Box	1	
		Parts		
3	675-71-263	Gasket	1	
4	675-71-304	Bracket	1	
6	672-31-71	Tab washer	4	
		Standard Items		
5		Nut M6.6.019 FOCT 5927-70	4	

APPROVED
CHECKED

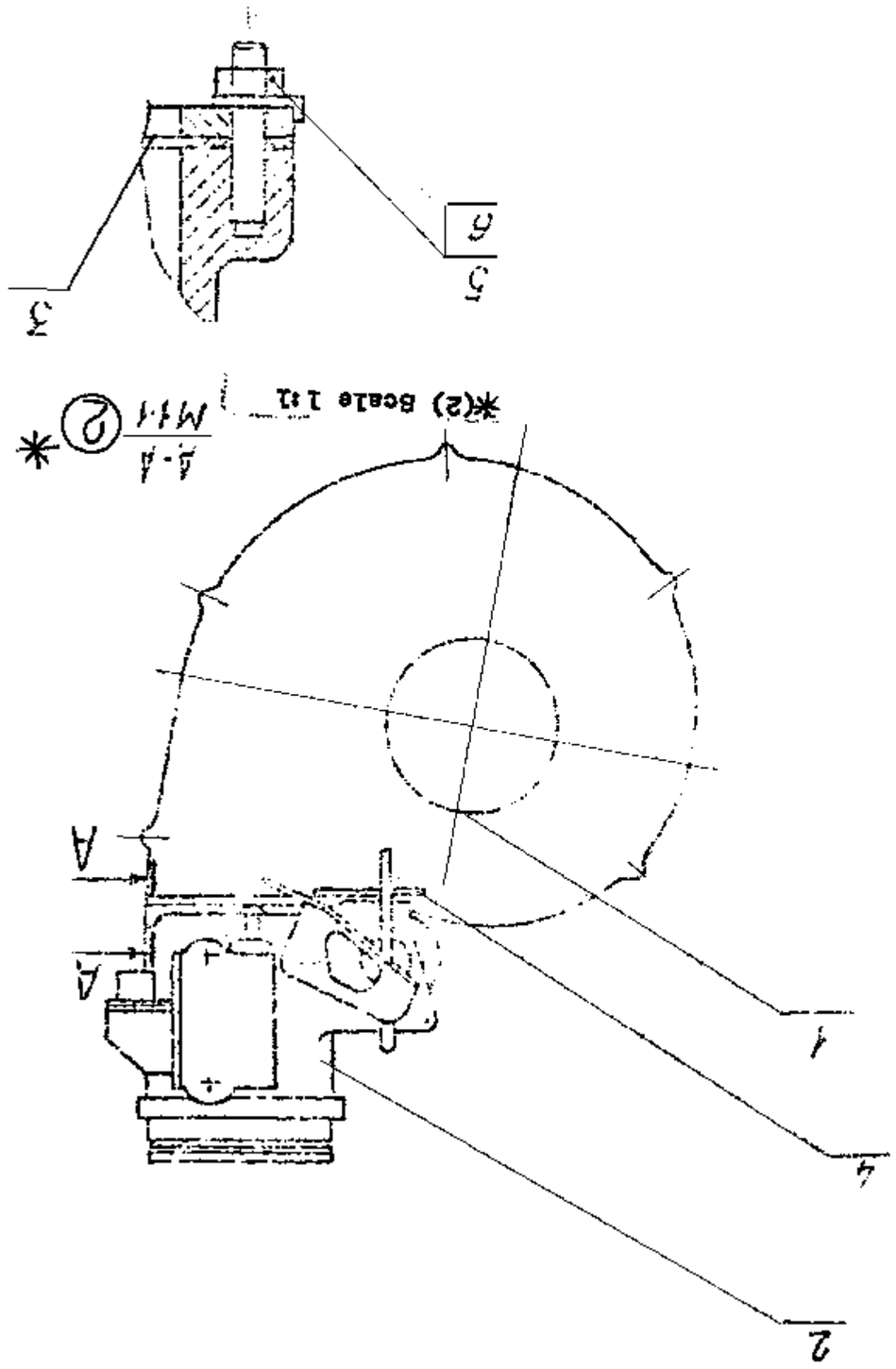
675-71-Sb227

CONTROLLERATE OF QUALITY ASSURANCE (ICV)

FAN

	WEIGHT	SCALE

SHT SHTS



Pull7 tighten up and lock all nuts

APPROVED		675-71-Sb227Sb	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		FAN ASSY DRG.	
	WEIGHT	6.52	1:2.5
		SHT	SHTS

675-71-Sb227Sb

Ref. No.	Designation	Description	Qnty	Remarks
		Documents		
	675-71-c622805	Assembly drawing		
		Parts		
1	675-71-160	Boss	1	
2	675-71-303	Lever	1	
3	765-71-391	Bushing	1	

APPROVED
CHECKED

675-71-Sb228

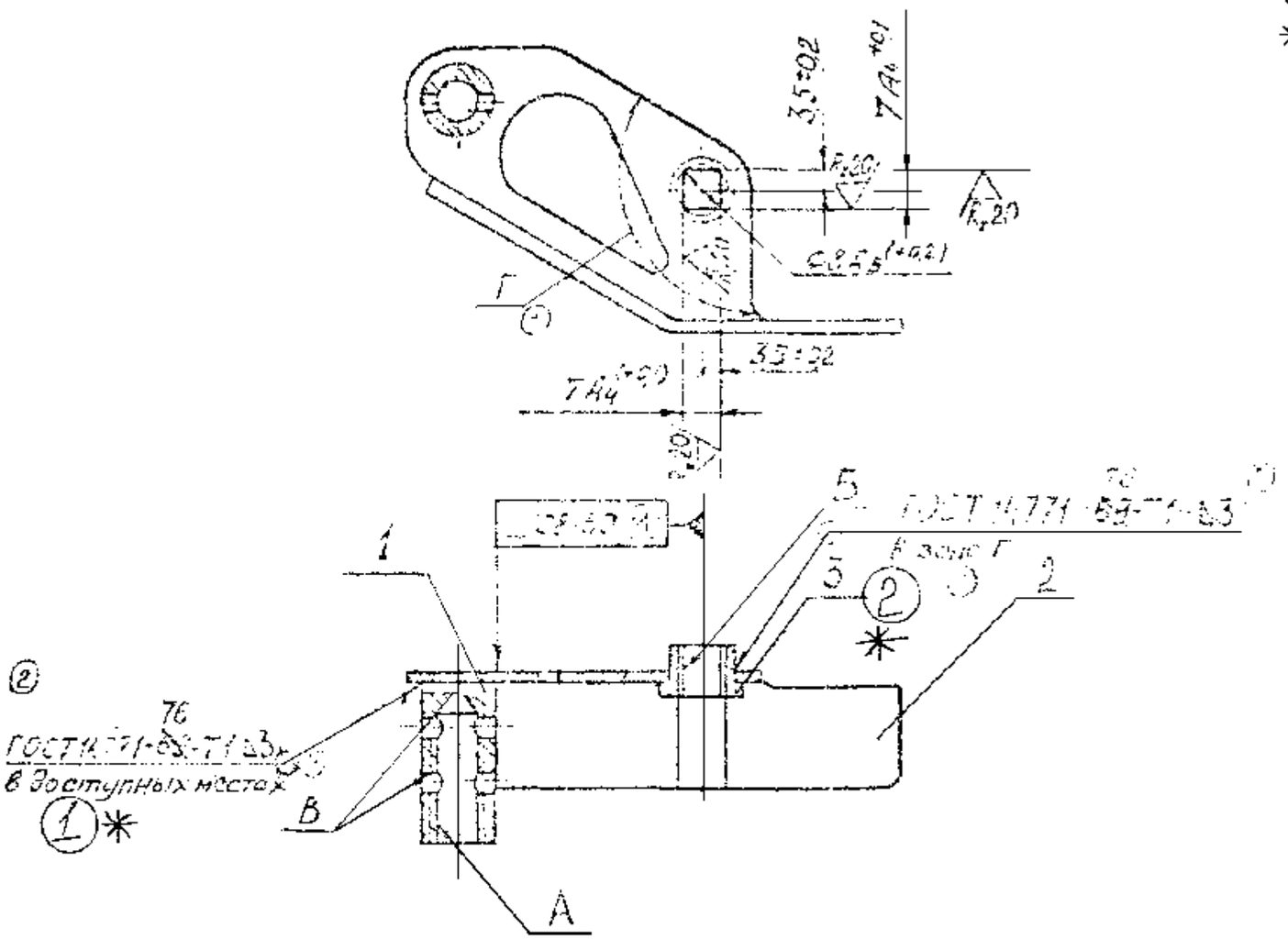
CONTROLLERATE OF QUALITY ASSURANCE (ICV)

LEVER

	WEIGHT	SCALE

SHT SHTS

675-71-Sb228Sb



*(1) in accessible places

*(2) in zone Г

1. Coating: zinc 9 Cr.
   Absence of coating in holes A, Б, B is tolerable.
2. After welding check thread.
3. Welding according to ГОСТ 5264-80 is tolerable.

APPROVED		675-71-Sb228Sb	
CHECKED			WEIGHT: 0.074 SCALE: 1:1
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		LEVER ASSY DRG.	SHT SHTS

Ref. No.	Designation	Description	Qnty	Remarks
		Documents		
	675-71-c6229CB	Assembly drawing		
		Parts		
1	675-71-157	Bushing	1	
2	675-71-300	Body	1	
3	765-71-819-01	Bushing	1	

APPROVED	
CHECKED	

675-71-Sb229

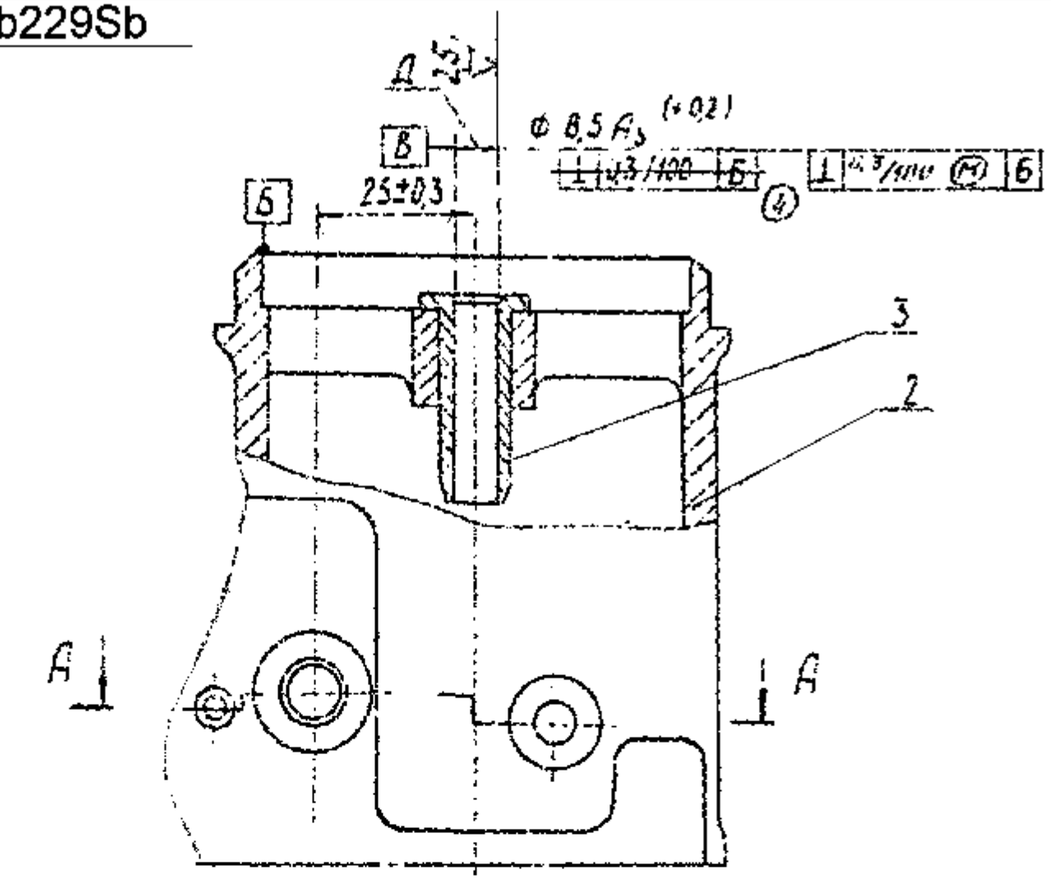
CONTROLLERATE OF QUALITY ASSURANCE (ICV)

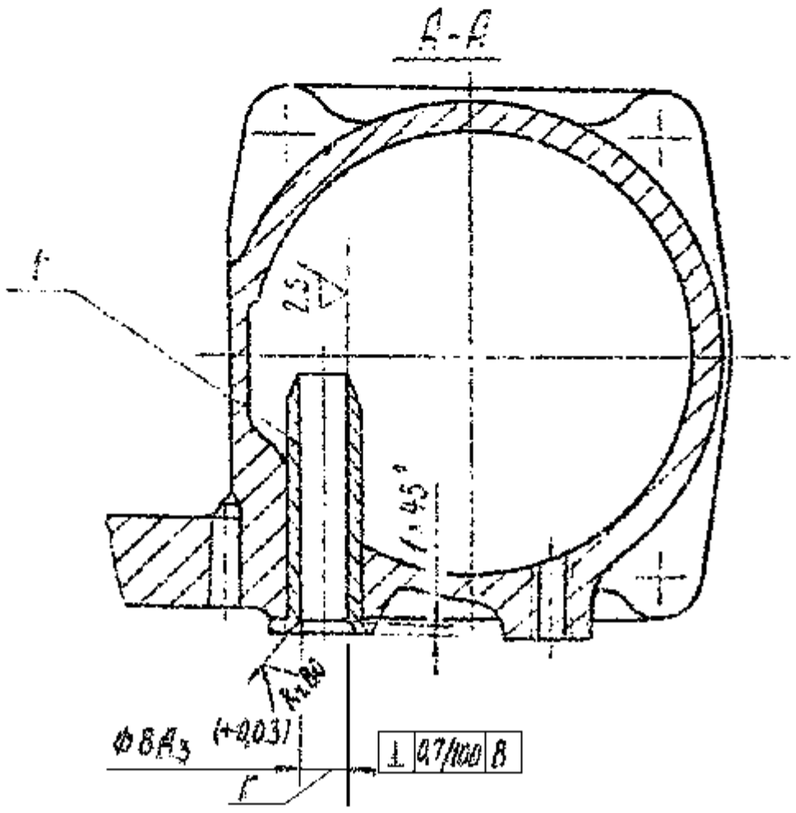
BODY

	WEIGHT	SCALE

SHT SHTS

675-71-Sb229Sb





(1 1. Coating of outer surfaces:
primer ФЛ-03К ГОСТ 9109-81;
enamel ПФ-223, white 1, ГОСТ 14923-78, except for mating faces.
2. Drilling of holes Г and Д in parts is tolerable.

APPROVED		675-71-Sb229Sb	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		BODY ASSY DRG.	WEIGHT 0.5 / SCALE 1:1
			SHT SHTS

A3

Ref. No.	Designation	Description	Qnty	Remarks
		Documents		
	675-71-c6230CB	Assembly drawing		
		Assembly Units		
1	675-71-c6167	Valve	1	
2	675-71-c6228	Lever	1	
3	675-71-c6229	Body	1	
4	765-96-c6178-01	Push-type limit switch	1	Replacement with Ref.No.7 is allowed
5		Relay PM6-1C PM6-1C.000 TY	1	Vendor item
7	765-96-c6166	Push-type limit switch	1	Replacement with Ref.No.4 is allowed
		Parts		
10	675-71-148	Shaft	1	
15	765-71-364	Flange	1	
17	765-71-812	Retainer	1	Replacement with Ref.No.26 is allowed
18	765-71-813	Clamp	2	
19	765-71-814	Lever	1	
20	765-71-815	Pusher	1	
23	700-38-1123	Spring	1	
24	700-38-1577	Spring	1	
25	672-47-5-01	Axle	1	
26	765-71-1773	Retainer	1	Replacement with Ref.No.17 is allowed

APPROVED
CHECKED

675-71-Sb230

CONTROLLERATE OF QUALITY ASSURANCE (ICV)

BOX

	WEIGHT	SCALE

SHT 1 SHTS 3

Ref. No.	Designation	Description	Qnty	Remarks
		Standard Items		
28		Screw B.M4-8h6hx70.66.016 ГОСТ 1491-80	2	
29		Nut M4.6.016 ГОСТ 5927-70	2	
31		Nut M6.6.019 ГОСТ 5927-70	2	
32		Nut M5.6.016 ГОСТ 5932-73	1	
33		Rivet 2x10.32 ГОСТ 10299-80	1	
		Washers ГОСТ 11371-78		
34		Washer 4.01.019 or 4.02.019	2	
35		Washer 5.01.019 or 5.02.019	1	
36		Washer 24x1.5-35	3	Max.qnty
37	EQ.MAT.C-30 TO IS:1570-79	Washer 6x1.01.019 or 6x1.02.019	2	(Ref.DCW/00857-ICV)
38		Washer 4Т65Г05 ГОСТ 6402-70	2	
39		Washer 6Т65Г06 ГОСТ 6402-70	2	
40		Cotter pin 1,6x10.019 ГОСТ 397-79	1	
41		Cotter pin 1x12.019 ГОСТ 397-79	1	
		Pins OCT 3-2234-80		HB 207 to 255 (Ø4.2 to 3.8)
42		Pin 3Пр2.2ax12	1	
43		Pin 2Пр2.2ax14 or 700-32-315	1	
44		Pin 5Пр2.2ax28	1	

APPROVED	
CHECKED	

675-71-Sb230

CONTROLLERATE OF QUALITY ASSURANCE (ICV)

BOX

	WEIGHT	SCALE

SHT 2 SHTS 3

Ref. No.	Designation	Description	Qnty	Remarks
45		Stud M6 x $\frac{T_1 2}{6g}$ x 16.66.019 ГОСТ 22036-76	2	Without break-down into groups. Replace-ment with 29363 is allowed. Coating: zinc 9 Cr
47		Stud M6 x $\frac{T_1 2}{6g}$ x 20.66.019 ГОСТ 22034-76	2	Without break-down into groups
49		Stud M6x6gx32.66.019 ГОСТ 22038-76	2	Without break-down into groups
		Materials		
52		Pipe III ТВ 50-355-4,5, unpainted, ГОСТ 19034-73 L = (14 ± 1) мм	1	

APPROVED
CHECKED

675-71-Sb230

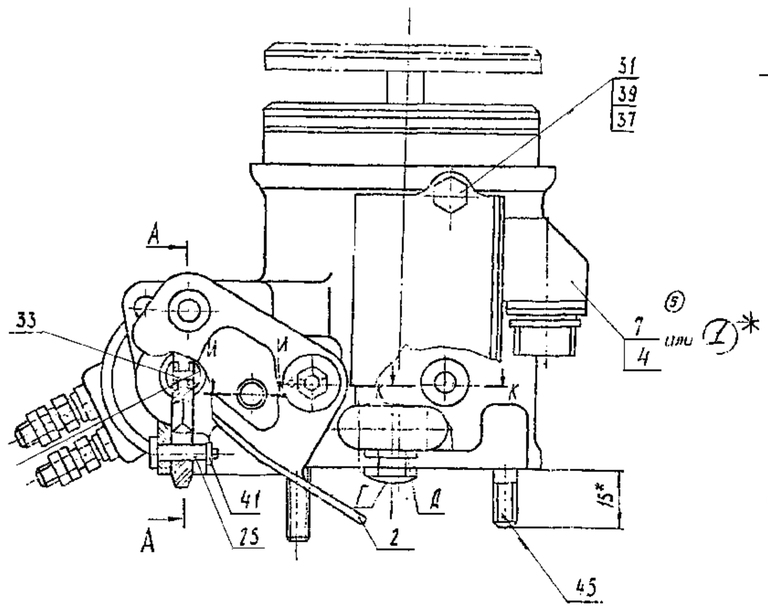
CONTROLLERATE OF QUALITY ASSURANCE (ICV)

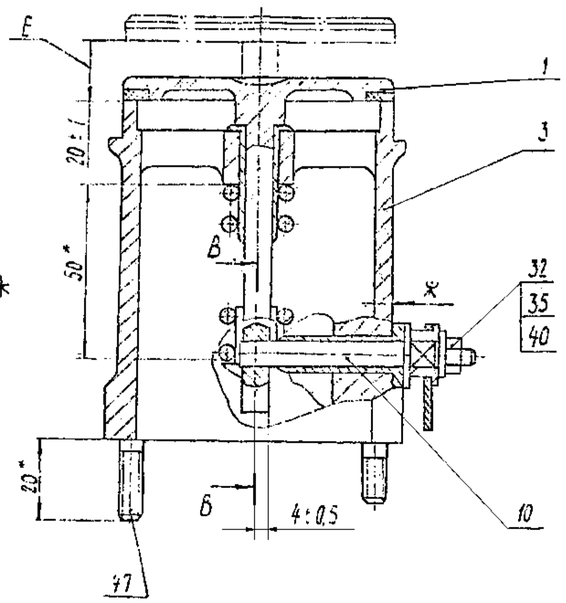
BOX

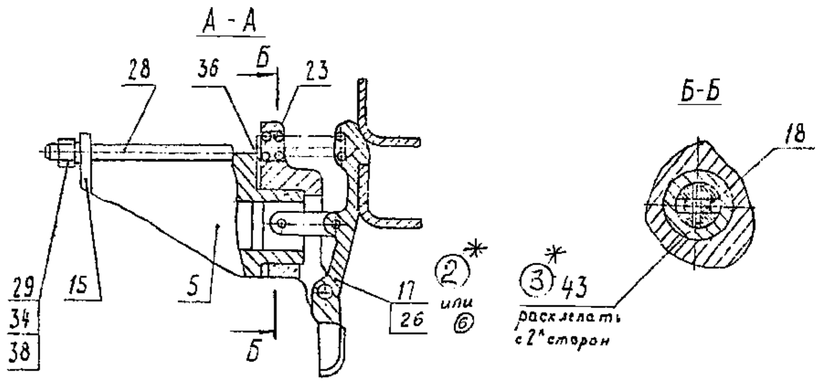
	WEIGHT	SCALE

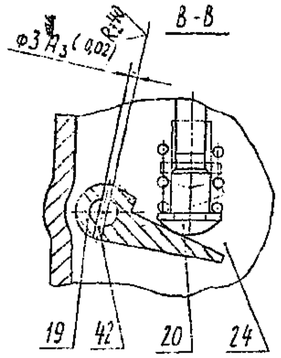
SHT 3 SHTS 3

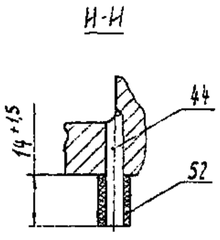
675-71-Sb230Sb

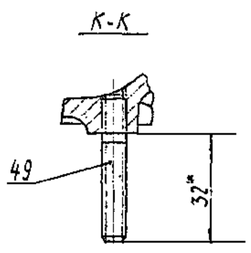












*(1) or
*(2) or
*(3) Rivet over from two sides

1. With adjusted size E along contour of valve Ref. No. 1, set lever Ref. No. 19 on shaft so as to stop lever Ref. No. 2 as shown for clarity in cross-section A - A; this done, drill and lock-pin lever on shaft. In this case, axial play Ж of shaft - 0.5 mm, maximum.
2. In closed position valve should tightly fit box along entire perimeter.
3. Check tight fitting of valve sealing by reference to chalk imprint. Chalk imprint should be along entire perimeter. Breaks of chalk imprint are not tolerable.
4. Crimp free end of rivet Ref. No. 33 so as to ensure free rotation of clamp Ref. No. 18.
5. Coat all friction surfaces of parts with lubricant Литол-24 ГОСТ 21150-75.
6. Adjust switch Ref. No. 7 by means of screw Г and locknut Д so that with lever Ref. No. 2 set on retainer switch rod is depressed by lever, contacts 3 and 4 are closed and contacts 1 and 2 are open. In this case, free travel of rod should be within 2 to 3 mm. With valve closed, rod should be released, contacts 1 and 2 should be closed, contacts 3 and 4 should be open.
7. Install studs on iron minium ГОСТ 8866-76.
8. In finally assembled unit, retainer should reliably retain valve in open position and under action of relay at voltage of 22 V it should positively release lever Ref. No. 2. If armature is pressed against relay body, it is allowed to install washers Ref. No. 38, 3 pcs, maximum.
9. *Sizes are given for reference.

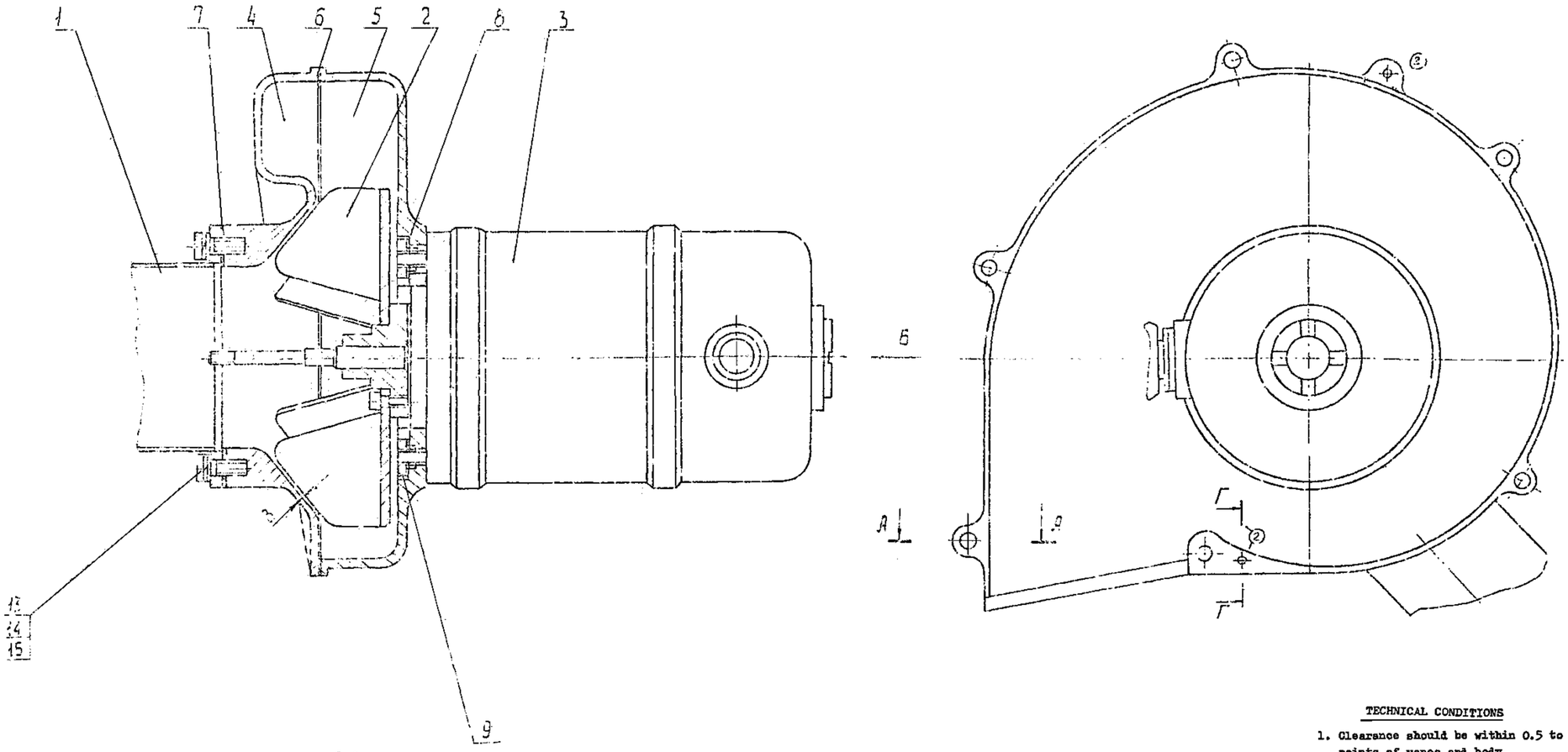
APPROVED		675-71-Sb230Sb	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	BOX ASSY DRG.	WEIGHT 1.685	SCALE 1:1
		SHT	SHTS

Ref. No.	Designation	Description	Qnty	Remarks
		Documents		
	675-71-c5241CB	Assembly drawing		
		Assembly Units		
1	675-71-c6224	Pipe	1	
2	675-71-c6225	Rotor	1	
3	675-95-c6179	Fan electric motor	1	
		Parts		
4	675-71-289	Volute	1	
5	675-71-290	Wall	1	
6	675-71-291	Gasket	4	Max.qnty
7	675-71-307	Gasket	1	
8	672-31-11	Locking washer	2	
9	672-30-8	Nut	2	
10	672-35-3-02	Screw	6	
		Standard Items		
13		Bolt M6x14.46.019 ГОСТ 7798-70	4	
14		Washer 6Т65Г06 ГОСТ 6402-70	4	
15	EQ.MAT:C-30 TO IS:1570-79	Washer 6x1.01.019 or 6x1.02.019 ГОСТ 11371-68	4	(Ref.DCD:00857-ICV)
16		Pin 2Пр2,2ax12 or 700-32-315-01 ОСТ 3-2234-80	2	
		Materials		
20		Wire КО-1 ГОСТ 792-67 L = 400 mm	3	

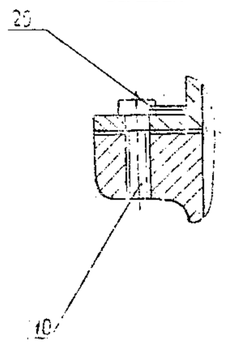
APPROVED		675-71-Sb241		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		FAN	WEIGHT	SCALE
			SHT 1	SHTS 1

675-71-Sb241Sb

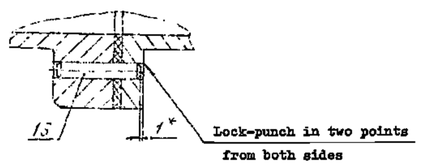
VIEW-Б



А-А
SCALE 2:1



Г-Г
SCALE 2:1



TECHNICAL CONDITIONS

1. Clearance should be within 0.5 to 1 mm between closest points of vanes and body.
   Adjust by means of gaskets Ref. No. 6.
2. All bolted joints should be tightened and locked in pairs.
3. Rotor should turn easily without seizing.
4. Test fan for 2 min at voltage of $(27^{+1.0}_{-1.0})$ V. Catching of rotor against fixed parts is not tolerable.
5. Requirements for quality of electric power of test rig - according to 765-064TV2.
6. *Size is given for reference.

THE ABBRIVATIONS AND SYMBOLS ARE BASED ON RUSSIAN SPECIFICATIONS.

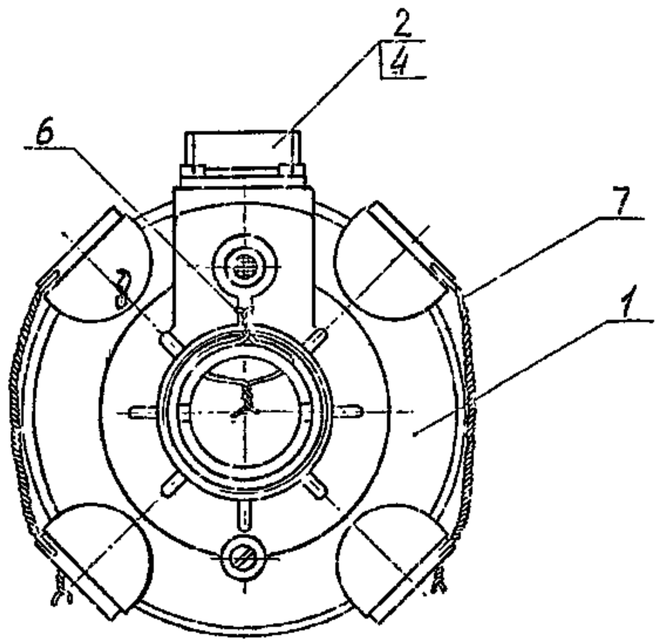
ALL DIMENSIONS ARE IN mm.

APPROVED		675-71-Sb241Sb	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	FAN ASSY DRG.	WEIGHT	SCALE
		5.2	1:1
		SHT	SHTS

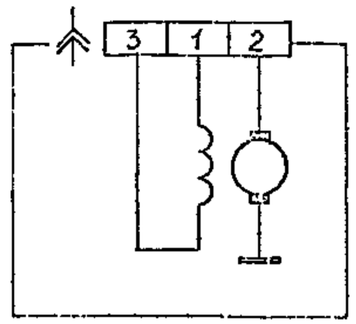
No.	Designation	Description	Qnty	Remark
		List of Documents		
	675-95-c6179 СБ	Assembly drawing		
		Miscellaneous Items		
1		Motor МБП-3Н	1	
2		Receptacle ШРТ20П33Ш7 ГЕО.364.108 ТУ	1	
		Materials		
4		Sleeve III ТВ-50-355-4,5, unpainted ГОСТ 19034-73 ℓ = 20 mm	3	
		Wire КО 0,5 ГОСТ 792-67:		
6		ℓ = 100 mm	1	
7		ℓ = 220 mm	2	

APPROVED		675-95-Sb179		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		BLOWER MOTOR	WEIGHT	SCALE
			SHT 1	SHTS 1

675-95-Sb179Sb



* (2) *(2) Soldering diagram



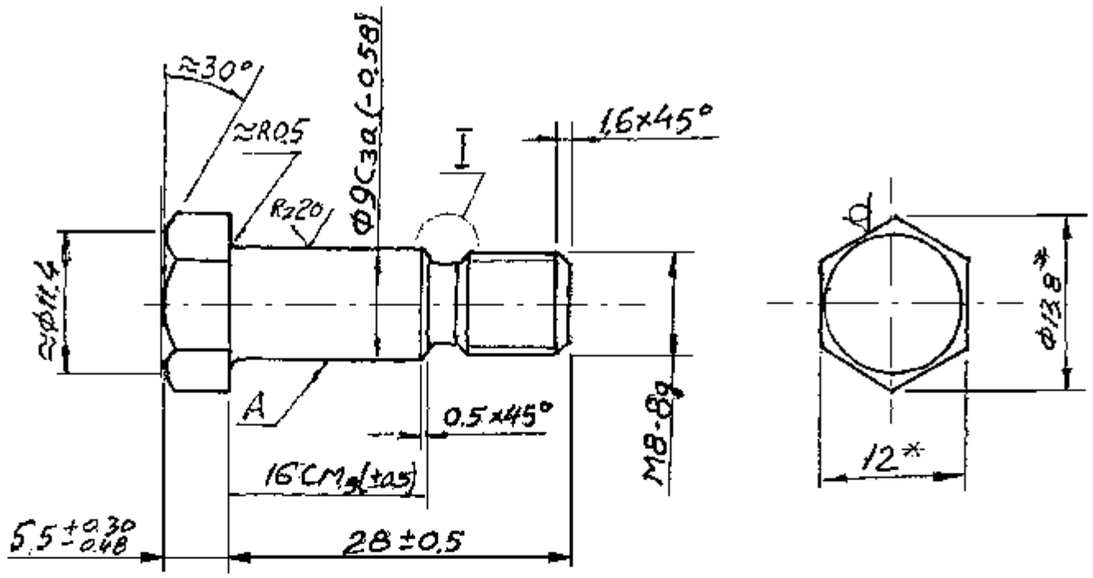
TECHNICAL CONDITIONS

1. Before improvement of the motor electric components, check it for proper functioning at the rated duty for 5 min. Load on shaft is $0.196^{\pm}0.02$ H·m ($2^{\pm}0.1$ kgf·m), power voltage is ($27^{\pm}\frac{2}{5}$) V; motor current is (11_{-2}) A; shaft revolutions are $7800^{\pm}400$ r/min; sense of rotation is right-hand as viewed from the side of the shaft protruding end.
2. Lay motor wires according to the soldering diagram, to do this, proceed as follows:
   (a) solder out and replace the motor plug connector by the connector, Ref. No. 2, not changing the wire terminations;
   (b) solder out the field winding wire from the brush holder, having preliminarily disassembled the motor, and solder the wire in contact 1 of the connector, Ref. No. 2.
3. Solder the wires with solder Пр.3 ПОС 61, ГОСТ 21931-76.
4. Burning of plastic insulation of brush holders, mechanical damage to wires, parts and motor units during assembly, disassembly and soldering are not permissible.
5. Check the electrically separated live parts of the motor for insulation resistance relative to each other and relative to the chassis with the use of a megohmmeter with a working voltage of 500 V. The insulation resistance should be at least 20 megohms.
6. Check the insulation of electrically separated live motor parts for electric strength relative to each other and to the chassis by a direct current of power of at least 0.5 kW, and a voltage of 500 V for one minute.
   Insulation rupture is not permissible.
7. Perform check described in Items 4 and 5 under normal climatic conditions.
   Remove minus brushes before check against Items 4 and 5.
8. The nut fastening the bearing to be removed during disassembly, should be tightened up and locked with a locking washer.
9. The bearing plug should be tightened as far as it will go and locked with the wire, Ref. No. 6.
10. Tighten up the brush holder plugs and lock them in pairs with the wire, Ref. No. 7.
11. After the motor improvement, perform its check according to Item 1. In this case, fit a jumper between connector contacts 2 and 3.
12. Check the motor under accelerated conditions for one minute. In this case, feed additionally ($+27^{\pm}\frac{2}{5}$) V through shunt 675-95-06159 to contact 2 of the connector. Preserve the jumper between contacts 2 and 3. Do not check the motor current and revolutions. Stop the motor by electro-dynamic braking

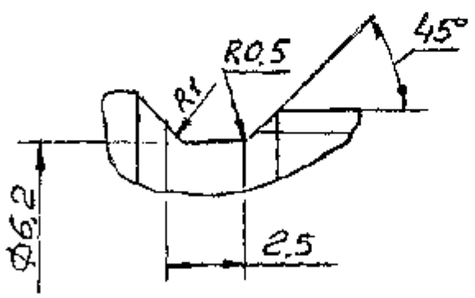
APPROVED		675-95-Sb179Sb	
CHECKED			WEIGHT: 3.75 SCALE: 1:1
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		BLOWER MOTOR ASSEMBLY DRAWING	SHT 1 SHTS 1

700-28-478

Rz 80 √(√)



I
M5:1



1. Alternate material is Steel cm5, GOST 380-71 and Steel 35, 40 and 50, GOST 1050-74

2. Unspecified limit deviations of dimensions are as follows:
   For holes –as per A_7 ,
   for shafts –as per B_7
   for others –as per CM_7

3. Radial run-out of surface A with respect to the angle diameter of the thread should not exceed 0.2mm (Qualified tolerance).

4. Displacement of the head with respect to the axis of the rod should not exceed 0.4mm.

5. * Dimensions are given for reference.

6. Coating: Chemical parkerizing, chromatizing oiling with preservation oil K-17 GOST 10877-76 as per Instructions 053.25289.00002 or with varnish KO-815 GOST 11066-74

7K. Other technical requirements are as per GOST 1759-70. Section 1.

Ⓐ EQ.MATERIAL:- CARBON STEEL BAR HEXAGONAL C45 Is: 2073 St.50 TO Is: 7270-74.

DC(I)No. & DATE	ISSUE	AMENDMENTS
00805-ICV 31 Aug 2000	Ⓐ	EQ. MATERIAL ADDED

APPROVED	H VASU	700-28-478
CHECKED	S M S PILLAY	
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		BOLT
		HEXAHEDRON 12-5, GOST 8560-78 / 45-B, GOST 1051-73

	WEIGHT	SCALE
	0.015	2:1
SHT 1	SHTS 1	

A3