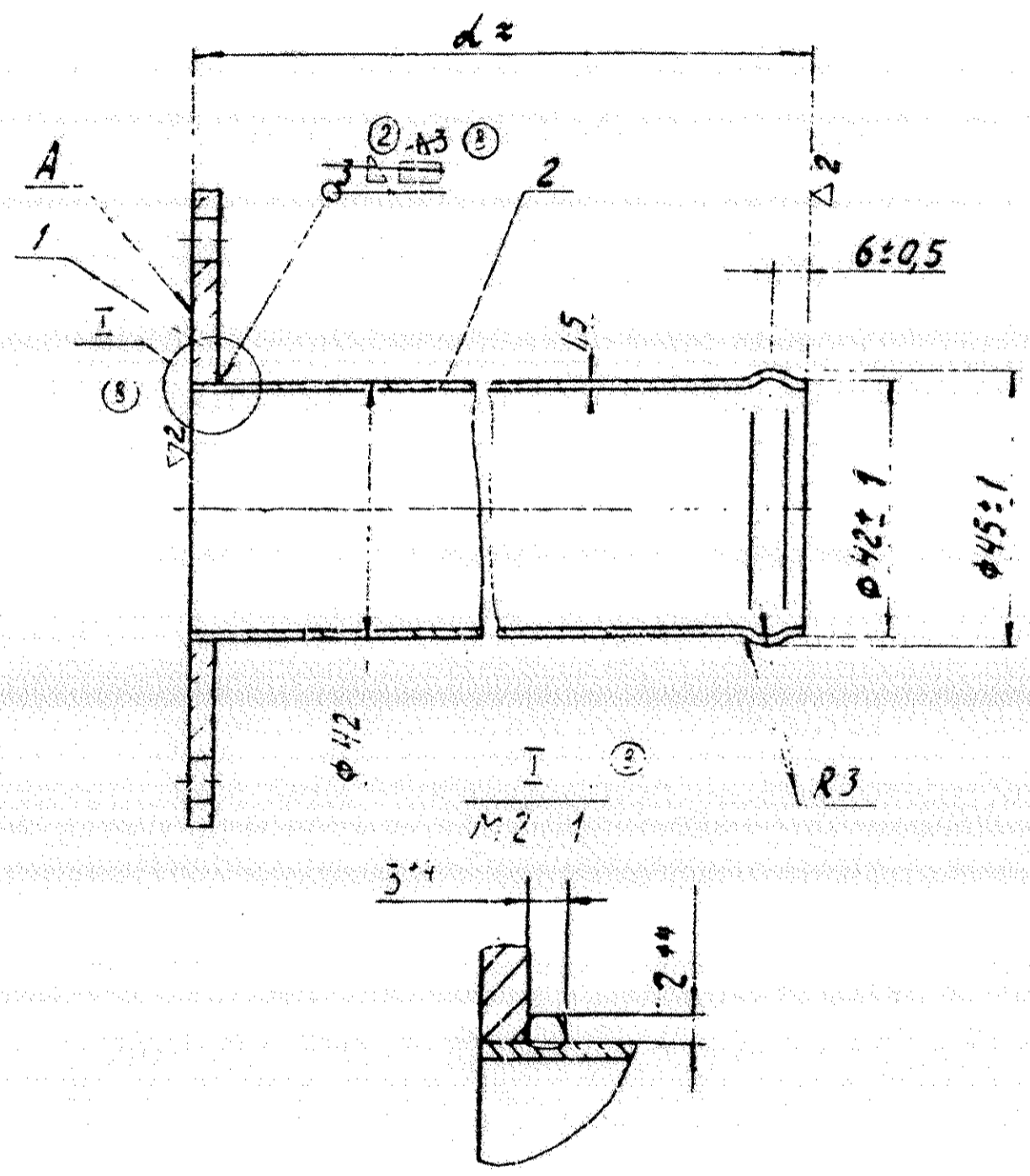


765-38-8174/176

~ (▽)

1. Make part, Ref. No. 2 from round pipe 42x1.5 AMr5M GOST 18475-73, in this case:
 - a) Bend pipe and adjust dimensions as per standard made in situ;
 - b) ovality and corrugations not exceeding 3 mm are allowed at bends;
 - c) alternate material is round pipe 42x1.5 AMr6M GOST 18475-73.
2. Argon arc welding.
3. Adjust mutual position of flange and pipe as per standard made in situ.
4. Non-flatness of surface A should not exceed 0.5 mm.
5. Sinking of pipe beyond surface A should not exceed 2 mm.
6. Apply primer $\phi\Omega-03-Ж$, GOST 9109-81 on the pipe external surfaces and paint with enamel.
7. Coating: Anodic oxidation, chromating, chemical parkerizing, blue
8. Apply two coats of bakelite varnish, grade $\Pi 6C-1$ GOST 901-78 inside the pipe as per instructions 053.25273.00010.
9. Carry-out test for air-tightness with air at a pressure of 0.5 kg/cm² in water bath. Air leakage is not allowed.
10. Leak proofness may be checked by applying chalk on weld and pouring kerosene. Tracers of kerosene are not allowed on the section where chalk has been applied, after three minutes.



Designation	Pipe		Mass kg	Enamel
	Designation	L=MM		
765-38-Cb174	765-38-250	320	0.162	$\Pi\phi-223$ WHITE 1 GOST 14923-78
765-38-Cb175	765-38-251	800	0.405	$\phi\Omega-223$ dark grey GOST 14923-78
765-38-Cb176				

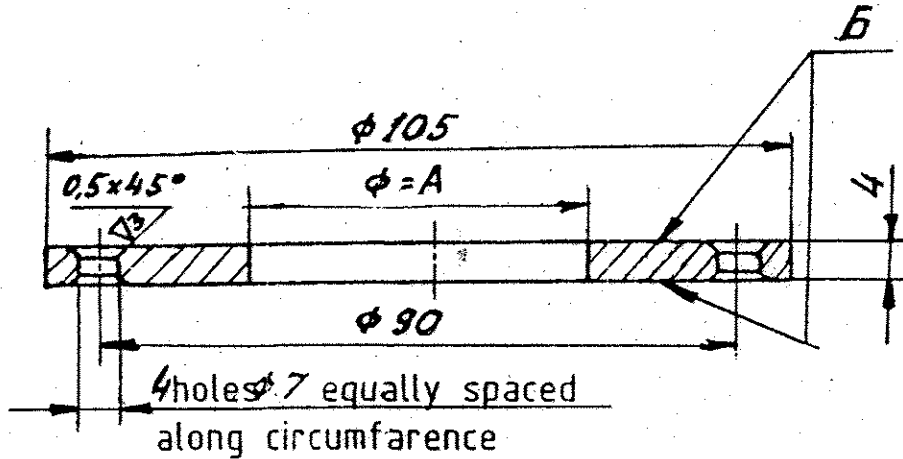
REF. NO.	Designation.	Description	Qty	Remarks.
1	765-38-156	Flange	1	
2	See the table.	Pipe	1	W/O Drawing
		Bakelite varnish enamel		
		$\Pi\phi-223$, dark grey.		
		Primer $\phi\Omega-03-Ж$.		

APPROVED		765-38-8174/176	49 OF 164
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF INSPECTION (IEV)		PIPE	WEIGHT SCALE
		(Table drawing)	See table 1:1
			SHT SHTS
			49 of 310

8	-	765 31-80	
7	-	765 636-80	
6	-	765 160-80	
10	-	765 43-82	
9	-	765 19-82	

765-38-155/156

(A) 2



1. Blunt sharp edges.
2. Provide dimensions without deviations as per accuracy class 7 OST-1010.
3. Deviations of centres of holes from their true position should not exceed 0,2mm.
4. Non-flatness of surfaces B should not exceed 0,5mm.
5. Stamping drafts should not exceed 0,4mm.
6. Alternate material is sheet AMГ5M, GOST 21631-76.
7. EQ. MATERIAL - ALUMINIUM SHEET G.de-55000 TO IS: 737-74.

00533- REV 14-11-95 DCC No & DATE	(A) 88	DRG. AMENDED BASED ON APPROVAL OF 4/94 N OFA	Designation	A	Weight
	ISSUE	NATURE	765-38-155	49	0,071
			765-38-156	43A7 ^{+0.62}	0,075
AMENDMENTS					

MATERIAL :- SHEET AMГ5M-4, GOST-21631-76.		
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:- 765-38-C6141 675-38-C6107
SCALE :- 1:1	DRN. <i>Latthal</i>	FLANGE
DATE :- 20-10-95	WT :- (Kg) SEE TABLE	
CHD. <i>JE</i>		765-38-155/156
APD. <i>Julw</i>		
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)		