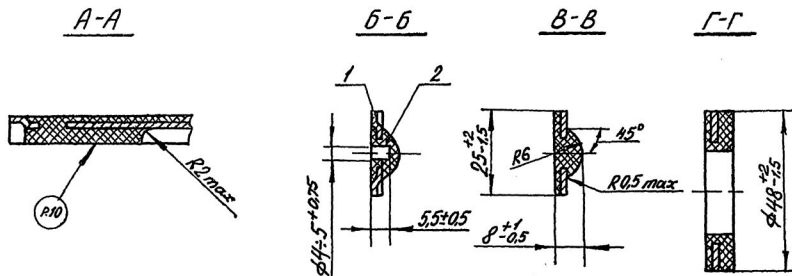
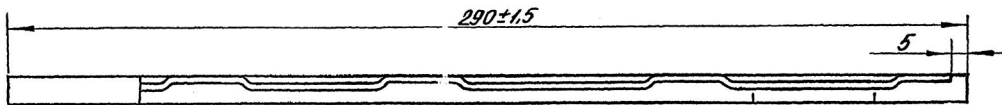
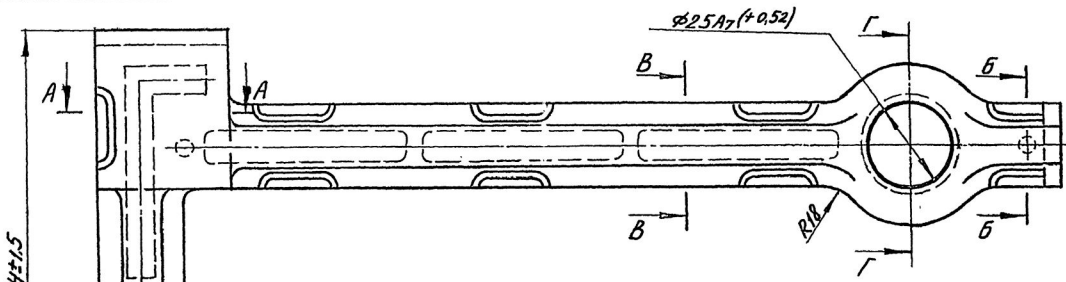


DRAWING NUMBER
175.02.035cb-1Cb

SHEET No. 1 OF 1



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

EST. WT.
0.12Kg.

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.

- NBR + CR (BNC Grade of CQA(HV))
- 100 1. COMPONENT 2 IS TO BE MANUFACTURED FROM RUBBER HO-68-1 TY-005216-75.
 2. RUBBER FILM IS ALLOWED ON - NON RUBBERIZED SURFACES.
 3. MISALIGNMENT (SKEWNESS) OF AXES OF THE MOULD SHOULD NOT EXCEED 1mm.
 4. ON THE SURFACES OF STAMPED RECESSES ON BOTH SIDES AS WELL AS ON THE EDGES OF STAMPED RECESSES AT A LENGTH AND WIDTH OF NOT LESS THAN 10mm AND 1.5mm, RESPECTIVELY, RUBBER IS NOT ALLOWED. DRESSING IS PERMITTED.
 5. ON RUBBERIZED SURFACES, UPTO 4 LOCAL CAVITIES WITH DIAMETER UPTO 4mm AND A DEPTH NOT EXCEEDING 1mm ARE ALLOWED.
 - 100 6. TECHNICAL REQUIREMENTS ON ACCEPTANCE OF THE COMPONENT IN ACCORDANCE WITH TY-005216-75, CODE 253161. NBR + CR (BNC Grade of CQA(HV))
 7. IT IS ALLOWED TO ROUND OFF THE CORNERS, RADIUS 1mm, MAX.
 8. GASKET IS TO BE GLUED BY HOT GLUEING PROCESS (VULCANIZING METHOD) WITH GLUE "LEIKONAT" TY6-14-95-75.
 9. PEELING OF RUBBER TO A DEPTH UPTO 4mm IS ALLOWED IN THE AREA OF STAMPED RECESSES.
 10. MANUFACTURING FACTORY DESIGNATION AND COMPONENT NUMBER ARE TO BE MARKED IN RAISED CHARACTERS TYPE ПО-3 GOST-2930-62.
- EXPLANATORY NOTE:-**
- 100 11. REFERENCE NOTE 1 ON MATERIAL FOR ITEM 2, RUBBER GRADE HO-68-1 TY 005-216-75.

PHYSICAL AND MECHANICAL PARAMETERS	
TYPE OF RAW RUBBER	CKH-18
RUPTURE STRENGTH	90 Kgf/cm ²
ELONGATION OF RUPTURE	250% MIN
RESIDUAL ELONGATION	12% MAX
HARDNESS IN CONVENTIONAL UNITS	55 TO 70 (OF T1P)
DENSITY	1.24 ± 0.05 g/cm ³
WORKING TEMPERATURE	-50°C TO + 100°C
WORKING MEDIUM	AIR, OILS, LUBRICANTS
DURING USE IT SHOULD WITHSTAND A PRESSURE UPTO 100 Kgf/cm ²	

EQUIVALENT MATERIAL:- 100
NBR + CR (BNC Grade of CQA(HV))

DRN	Sd / =	MATERIAL:-	USED ON:- PV572.0718.0140
CHD	Sd / =		172.02.079 Cb-6 (10A) (10B)
APPD	Sd / =		188.02.079cbCb
DATE	04-02-87	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE:-	1:1	AVADI	
DIMENSIONS IN mm		TITLE:-	GASKET
TOLERANCE ON DIMENS UNLESS OTHERWISE STATED IS: 2102-69		D S CAT NUMBER	DRAWING NUMBER
100 30.09.19 83281/TECH GEN/EO MATL/HVF dt. 25.09.19		DCAN: 5330381615	175.02.035cb-1Cb
10C 01.07.19 83201/Tech Gen/EO MATL/HVF dt. 02.06.19			
10B 03.09.11 55150/CQA(HV)/DB/BL1-72 dt. 19.07.11			
10A 4.8.03 N OF A No. CQA(HV)/T90/02/001.			
ISSUE DATE	NATURE OF AMENDMENTS		

" COMMON TO T-90 " & BLT

DRG. RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE. 10

B. JAYAVELUJ, T. D. I
26 MAR 08

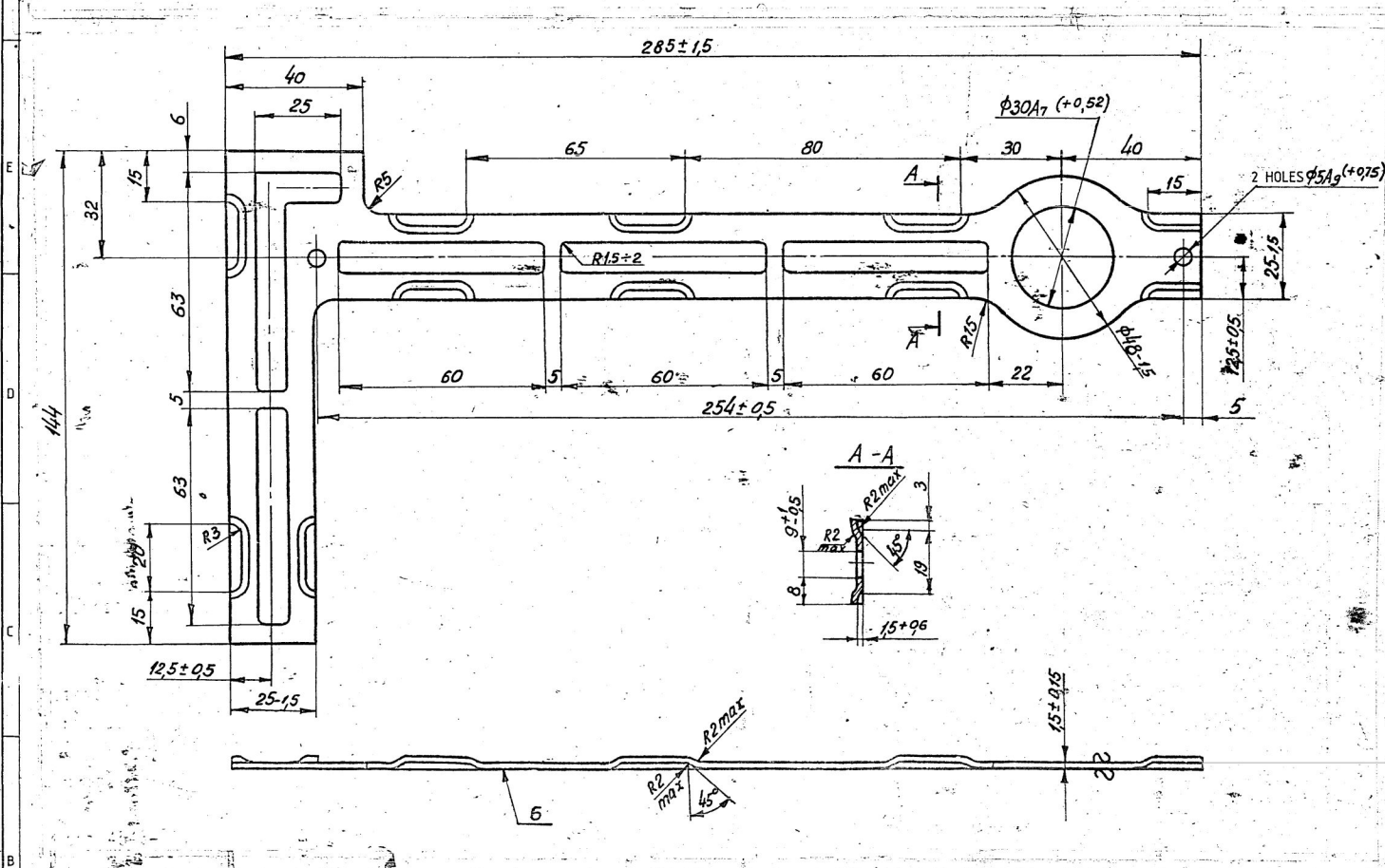
F-11
17

SIZE A2



DRAWING NUMBER
175 02 137-1

▽1 (▽)



1. MAY BE MANUFACTURED FROM OPEN HEARTH STEEL 10Kn-5-III Г GOST 16523-70.
2. NON FLATNESS OF SURFACE "6" NOT TO BE MORE THEN 1.5 mm.
3. DEVIATION FROM DIMENSIONS WITH UNSPECIFIED TOLERANCES ± 1 mm.
4. AT THE PLACES OF STAMPED RECESSES SHRINKAGE OF EDGES ARE NOT TO BE CHECKED.
5. FOLDED CORRUGATION AND TOOL MARKS ON THE SURFACE OF THE COMPONENT IS ALLOWED.
6. THE REST OF THE REQUIREMENTS IN ACCORDANCE WITH TY 005216-75 (SUPPLEMENT 1.)

COMMON TO BLT

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

EST WT 0.085 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	TCD	APPD	DATE	SCALE	DIMENSIONS IN MM	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69	ALL THREADS TO CONFORM TO	ISSUE	DATE	NATURE OF AMENDMENTS
MATERIAL		STEEL 10 Kn-5-II Г		GOST 16523-70 OPEN-HEARTH		USED ON:		175 02 035 C6-1			
CONTROLLER		RATE OF INSPECTION		HEAVY VEHICLES		AVADI					
TITLE		FRAME		D S CAT NUMBER		DRAWING NUMBER		175 02 137-1			

F-13
66

SIZE A2



