

1. ALTERNATE MATERIAL IS STEEL 40, 30, GOST 1050-74.
2. COATING: ZINC PLATED, 3 MICRONS THICK, OILED.
3. OTHER TECHNICAL REQUIREMENTS ARE AS PER GOST 1759-70.
4. THREAD MAY BE MADE BY ROLLING WITH DIAMETER OF THE UNTHREADED PORTION BEING WITH IN THE LIMITS OF THE MEAN DIAMETER OF THE THREAD.
5. DIMENSION IS GIVEN FOR REFERENCE.

6. MATERIAL QUOTED : 10-5 GOST 8560-78
45 GOST 1050-74
BRIGHT STEEL HEXAGONAL GRADE 45 STEEL, WITH WIDTH ACCROSS FLATS
10mm. OF ACCURACY CLASS 5.

ALTERNATE MATERIAL — TO 40, 30 GOST 1050-74.

Reference No: 1)

a) CHEMICAL COMPOSITION :-

ELEMENT %	Gde 30	Gde 40	Gde 45
CARBON	0.27 - 0.35	0.37 - 0.45	0.42 - 0.50
SILICON	0.17 - 0.37	0.17 - 0.37	0.17 - 0.37
MANGANESE	0.50 - 0.80	0.50 - 0.80	0.50 - 0.80
CHROMIUM	0.25 - max	0.25 - max	0.25 - max
SULPHUR	0.04 - max	0.04 - max	0.04 - max
PHOSPHORUS	0.035 max	0.035 max	0.035 max

b) MECHANICAL PROPERTIES :-

STEEL GRADES	30	40	45
YIELD POINT Kgf/mm ² (min)	30	34	36
ULTIMATE TENSILE STRENGTH Kgf/mm ² (min)	50	58	61
% ELONGATION (min)	21	19	16
% REDUCTION OF AREA (min)	50	45	40
IMPACT STRENGTH KJm/cm ² (min)	8	6	5

(A) EQUIVALENT MATERIAL STEEL
45C8 TO IS:1570

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

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

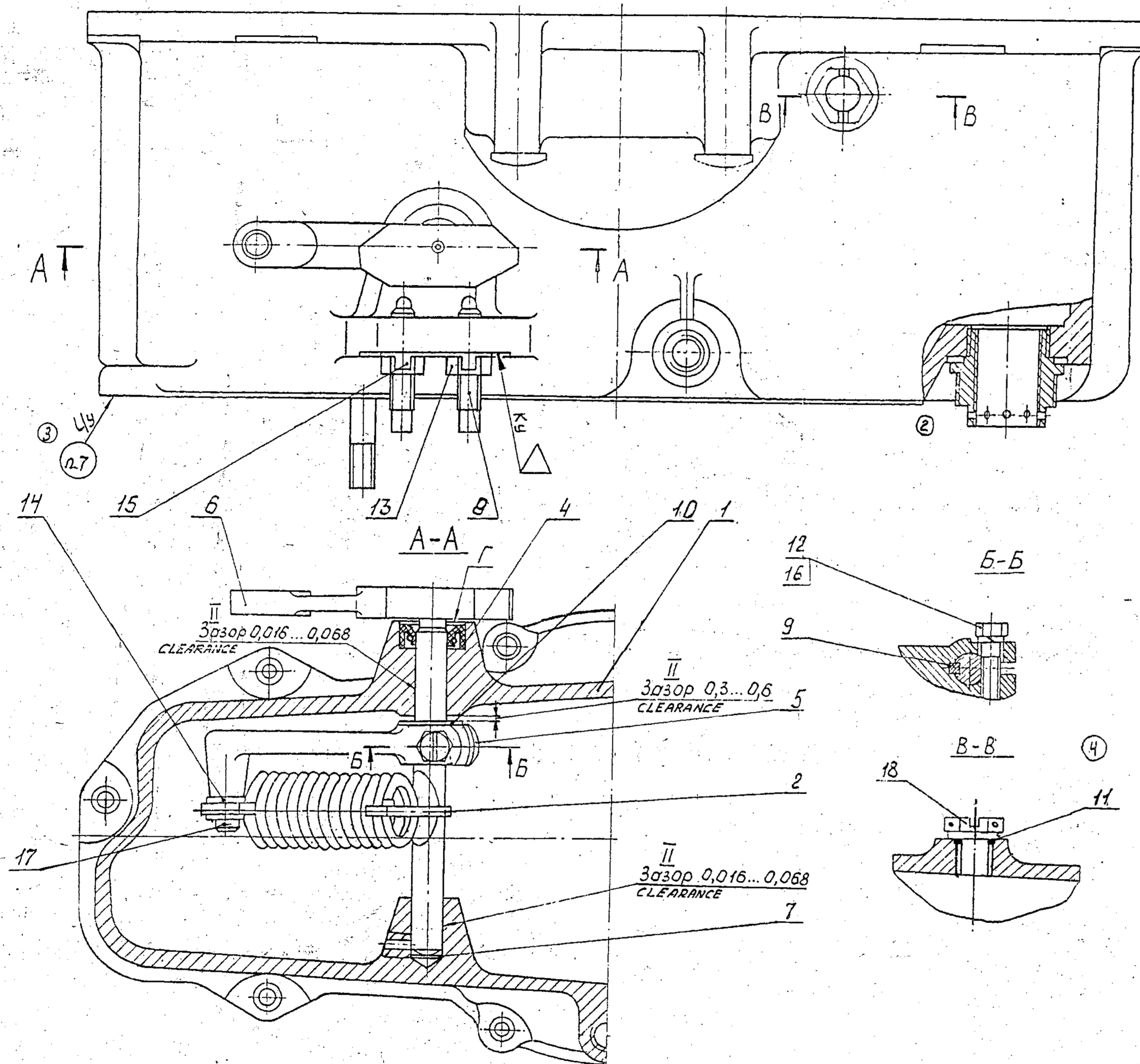
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

DRN	18/05/87	MATERIAL	10-5 GOST 8560-78	USED ON	CB 411-00-48
CHKD	18/05/87		45 GOST 1050-74		CB 20-27-00-4
TRD	Norani				CB 20-15-663-4
APPR		CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES)			
DATE	107-05-87	AVAD			
SCALE		TITLE			
DIMENSIONS IN mm		BOLT M6x20			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS:2102-69		D S CAT NUMBER			
ALL THREADS TO CONFORM TO		DRAWING NUMBER			
A 12-8-10 4 th Alt. Comm. Meeting Minutes		356-84			
Point No.11 Dt: 26-10-09					
ISSUE DATE	NATURE OF AMENDMENTS				

SIZE: A3



DRAWING NUMBER
 СБ 20.15.663-4



- I
1. Выступание сальника (поз.4) выше поверхности Г не допускается
 2. Зазор 0,3...0,6 обеспечить подбором детали 20-15-649 (поз.7)
 3. При постановке пружины регулятора (поз.2) крайний полувиток пружины на ее неприсоединенном конце должен находиться со стороны рычага пружины (поз.5)
 4. При монтаже под шплинт (поз.17) допускается постановка дополнительной шайбы поз.14 для выборки излишнего зазора.
 5. Допускается установка шпонки сегментной 3x5 ГОСТ 24071-80 (поз.9)
 6. На сопрягающийся торец гильзы (поз.7) и прилегающие к нему 2-4 нитки резьбы нанести лак 33W по инструкции И240-280/75.
 7. Маркировать шрифтом по 5 ГОСТ 2930-62 при отправке в запчасти.

- I.
1. Projection of a gland (pos. 4) above surface Г is not allowed.
 2. Provide clearance 0.3...0.6 with the help of selection of part No. 20-15-649 (pos.7).
 3. When the governor spring is secured (pos.2) an edge half-turn of the spring should be on its unconnected end and on the spring lever side (pos.5).
 4. It is allowed the securing of an additional washer, pos.14 during mounting under the split pin (pos.17) to remove the excess of clearance.
 5. It is allowed to secure semi-circular key 3x5 GOST 24071-80 (pos.9).
 7. Mark by type IIO 5 GOST 2930-62 when delivering as spare parts.

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

EST. MASS 3.47 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	MATERIAL	USED ON	CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES)	TITLE	D S CAT NUMBER	DRAWING NUMBER
										СБ 20-27-00-4	AVADI	GOVERNOR BODY		СБ 20.15.663-4

THE UNIVERSITY OF CHICAGO

PHYSICS DEPARTMENT

PHYSICS 350

LECTURE 1

1

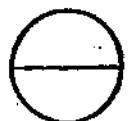
USED ON
CS 20-27-00-4

CREATED BASED ON RUSSIAN ORIGINAL ISSUE - 4 NOTN. NO. 1677-853

ITEM	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	No. OFF	
	C8 20-15-663-4		ASSY. GOVERNOR BODY		
	& ITEM LIST				
1	C8 20-15-601-7		GOVERNOR BODY	1	
	& ITEM LIST				
2	C8 20-15-603-5		GOVERNOR SPRING ASSY	1	
	& ITEM LIST				
4	C8 315-668		COLLAR SEALING RING ASSY	1	
5	20-15-630-2		SPRING LEVER	1	
6	20-15-640-1		SHAFT WITH LEVER	1	
7	20-15-649		SUPPORT	1	
8	315-49		LIMITER SCREW	2	
9	315-64		SEMI-CIRCULAR KEY	1	
10	315-639-1		WASHER	1	WHEN NECESSARY THE INSTALLATION OF 2 AND 3 PIECES AVAILABLE

ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENT
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DRN	<i>Alaska</i>	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) / AD			
CHD	<i>SP</i>	TITLE:			
TED	<i>Runovs</i>	GOVERNOR BODY			
APPD	<i>fo</i>	D S CAT NUMBER	ITEM LIST FOR		
DATE	16-2-93	SHT. No. 1 OF 2	C8 20-15-663-4		



...the elderly are not only more likely to be employed than in the past, but also more likely to be employed in a variety of occupations. The elderly are also more likely to be employed in a variety of occupations. The elderly are also more likely to be employed in a variety of occupations.

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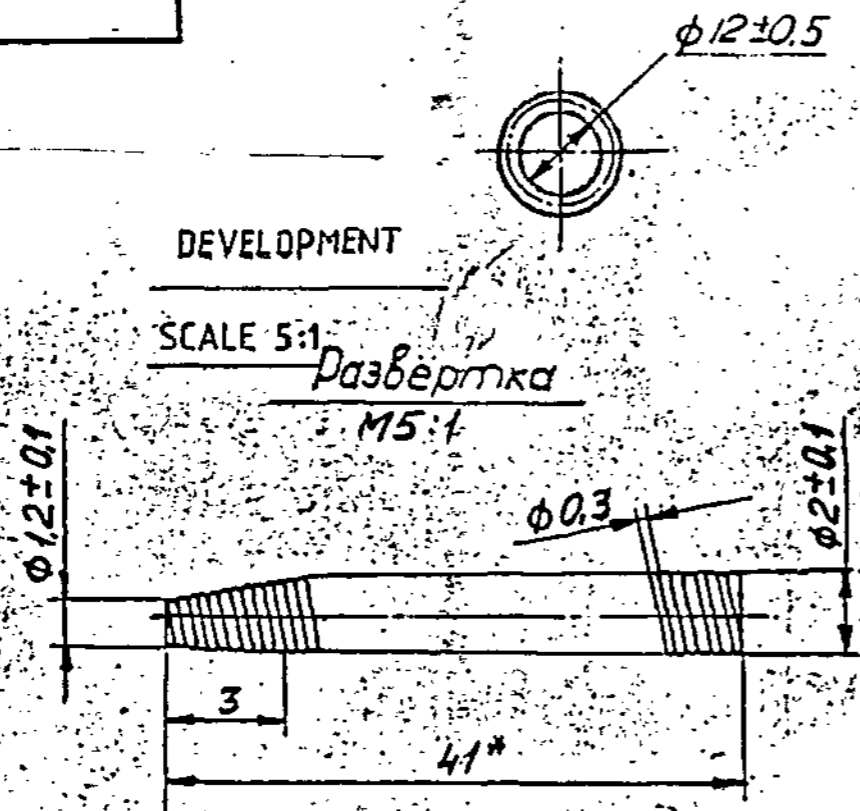
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DRAWING NUMBER
315-669



EXPLANATORY NOTE:

MATERIAL QUOTED: WIRE II 0.3 GOST 9389-75
 CARBON STEEL COLD DRAWN WIRE USED FOR FABRICATING SPRINGS. CATEGORY-SECOND (II). WIRE DIA = 0.3.
 WIRE SHOULD BE FABRICATED FROM CARBON STEEL GRADES KT-2 OR SK-7.

CHEMICAL COMPOSITION: %

	KT-2	SK-7
CARBON	0.86 - 0.91	0.68 - 0.76
MANGANESE	0.20 - 0.40	0.50 - 0.80
SILICON	0.17 - 0.37	0.17 - 0.37
SULPHUR	0.020 (max)	0.030 (max)
CHROMIUM	0.05 (max)	0.05 (max)
PHOSPHORUS	0.020 (max)	0.020 (max)
NICKEL	0.05 (max)	0.05 (max)
COPPER	0.10 (max)	0.04 (max)

MECHANICAL PROPERTIES

TENSILE STRENGTH Kgf / mm² = 200-240

COILING DIRECTION IS RIGHT HAND.

THE LOCK TIP SHOULD ENTER THE HOLE OF THE OPPOSITE SPRING END EASILY WITHOUT SEIZING.

CHECK STRENGTH OF LOCK OF SPRING COILED INTO RING BY INSTALLING IT ONTO A MANDREL, 15mm IN DIAMETER. IN THIS CASE THE SPRING ENDS SHOULD BE KEPT IN THE SCREWED IN POSITION.

COATING: CHEMICALLY OXIDIZED, OILED.

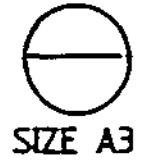
* GIVEN IS DESIGN DIMENSION.

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

EST. WT. 0.0002 Kg TO BE STAMPED OR MARKED WHERE INDICATED THIS # 1 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

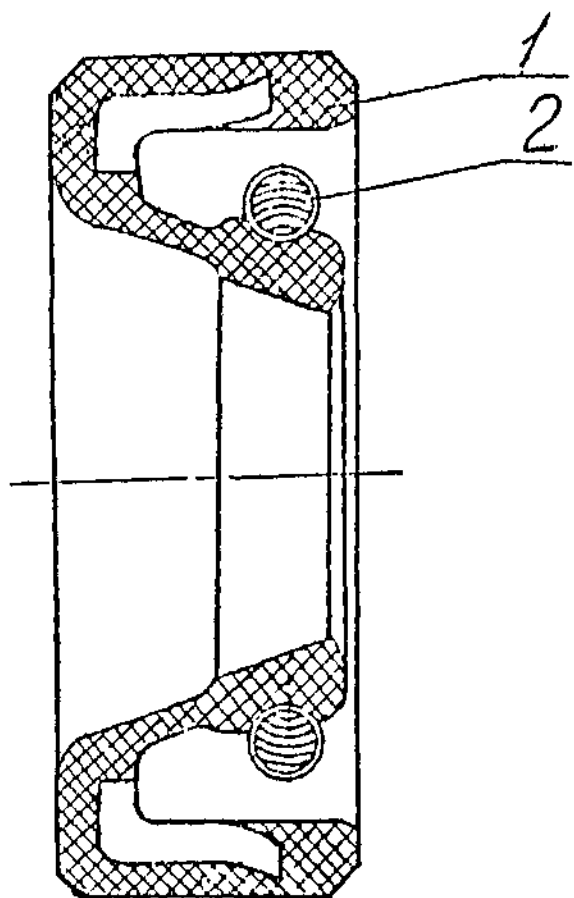
DRN	<i>Prendy</i>	MATERIAL:- WIRE II -0.3	USED ON
CHK	<i>Prendy</i>	GOST 9389-75	CS 315-668
TCD	<i>Prendy</i>	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES)	
APPO	<i>Prendy</i>	AVADL	
DATE	4-8-89	TITLE	
SCALE:-	1:1	CUP SPRING	
DIMENSIONS IN mm		D S CAT NUMBER	
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS:2102-69		DRAWING NUMBER	
ALL THREADS TO CONFORM TO		315-669	
ISSUE DATE	NATURE OF AMENDMENTS		



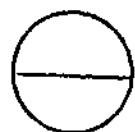
SIZE A3



DRAWING NUMBER
CB 315-668



KVD NO 63410



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

EST. WT.
 0,0047Kg

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.

MATERIAL :-

USED ON
 CB 315-663-21
 CB 20-15-663-4

ISSUE	DATE	NATURE OF AMENDMENTS
DRN	llj	SCALE:- 5:1
CHD		DIMENSIONS IN mm
TCD		TOLERANCE ON DIMENSIONS
APPD		UNLESS OTHERWISE
DATE	4-5-87	STATED IS 2102 -69
SIZE	A4	ALL THREADS
		CONFORM TO

SCALE:- 5:1
 DIMENSIONS IN mm

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)
 AVADI.

TOLERANCE ON DIMENSIONS
 UNLESS OTHERWISE
 STATED IS 2102 -69



TITLE
SEALING RING ASSY

ALL THREADS
 CONFORM TO

D S CAT NUMBER

DRAWING NUMBER

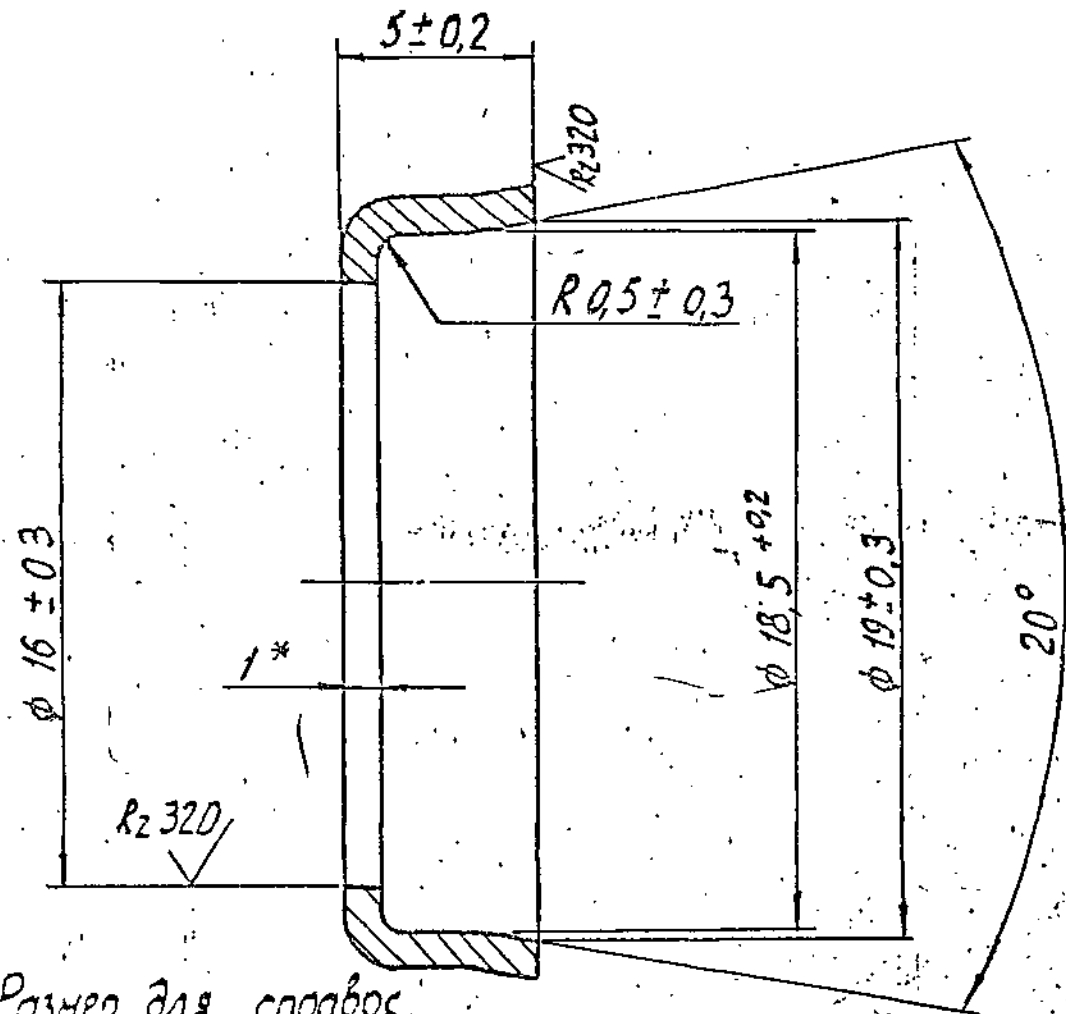
CB 315-668





315-667

✓(✓)



- 1) * DIMENSION FOR REFERENCE.
- 2) ALTERNATE MATERIAL : STEEL 10 GOST 1050-74.
- 4) ON THE EXTERNAL SURFACE STRIP UP TO 0,25 mm DEEP AND UP TO 2mm WIDE IS ALLOWED FROM DIE LAP.
- 5) THE REST OF THE REQUIREMENTS AS PER Ty-005216-75 (APPENDIX - 1)
- 6) COMPONENT IS TO BE MACHINED WITH SHOT TESTACK 0,5 545 GOST 11964-81 OR BY SAND BLAST.
- 7) PRESERVATION IS TO BE CARRIED OUT AS PER GOST 9.014-78 PROTECTIVE ALTERNATIVE β3 - 14 ZINCIBEROL PAPER yHI 22 - 80 .

1. * Размер для справок.
 2. Заменитель материала сталь 10, ГОСТ 1050-74.
 3. ~~Острые кромки затушевать радиусом не менее 0,3 мм.~~
 4. Допускается на наружной поверхности пояска глубиной до 0,25 мм и шириной до 2 мм от зажима штампа.
 5. Дрелиль обработать дрелью ДСК-0,5 545 ГОСТ 11964-81 или песком.
 6. Консервацию производить по ГОСТ 9.014-78; вариант защиты 83-14, бумага лакированная ЧНН 22-80.
 7. Остальные требования по ТУ 005216-75 (приложение 1).

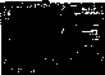
4	2	Б84-561	Худож.	12/10/88
3	1	Б878-46	Худож.	21.10.16
2		76-426		
13M	Лист	№ Докум	Подп	Дат

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE 4 (BK84-561)

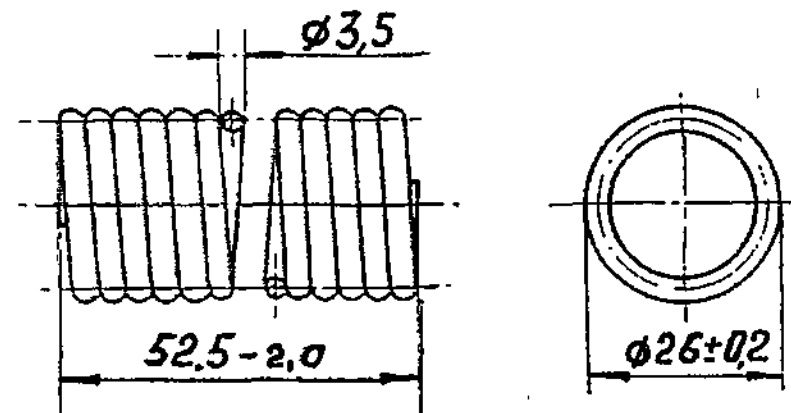
PLOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION		DRN	9.12.88	MATERIAL	A1 GOST 19904-74	USED ON	CB 315-666
EST. WT. 0,0023 Kg		CHD	8.12.88	SHEET	5-11-10 GOST 16523-70	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES) AVADI	
TO BE STAMPED OR MARKED WHERE INDICATED THUS $\frac{1}{1}$ LETTERS)		TCD	M. M. M. M.	APPD		TITLE STIFFENING RING	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		DATE	3-3-88	SCALE:-	5:1	D. S. CAT NUMBER	
SIZE A3		DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS:2102-69	ALL THREADS TO CONFORM TO		DRAWING NUMBER 315-667	
8		ISSUE DATE		NATURE OF AMENDMENTS		6	

A-6





DRAWING NUMBER
20-15-623-1



1. INSPECTION GROUP IV AS PER TECHNICAL REQUIREMENTS TT-11.
2. HRC 40 TO 47, CHECK HARDNESS ON THE WORKING COILS OF REFERENCE PARTS FROM THE BATCH.
3. TOTAL LENGTH OF SPRING IS APPROXIMATELY 1000mm.
4. FULL NUMBER OF COILS $n_1 = 14$.
5. DIRECTION OF COILING IS RIGHT HAND.
6. COIL THE SPRING WITHOUT PRILIMINARY TENSION.
7. CHECK THE SPRING IN ACCORDANCE WITH DRAWING ASSY 20-15-503-5.
8. MATCH THE LENGTH OF THE SPRING IN THE ASSEMBLY.
9. COATING: CHEMICALLY OXIDIZED, OILED (ALLOWED IN ASSY).
10. PERMISSIBLE COATING: CHEMICALLY PARKERIZED.

EXPLANATORY NOTE

MATERIAL QUOTED: WIRE 51X0A-A-II-XH-3.5 GOST 14963-78

ALLOY STEEL SPRING WIRE } = 51X0A GOST 14959-79.
MADE FROM GRADE

A = SPECIAL SURFACE FINISH. GROUP A POLISHED.

II = HIGHER ACCURACY.

XH = COLD COILING SPRING.

3.5 = DIAMETER OF WIRE.

a) CHEMICAL COMPOSITION AS PER GOST 14959-79.

C O N T E N T O F E L E M E N T S %						
C	Si	Mn	Cr	VENADIUM	S	P
					M A X I M U M	
0.47-0.55	0.15-0.30	0.30-0.60	0.75-1.10	0.15-0.25	0.025	0.025

b) MECHANICAL PROPERTIES AS PER GOST 14963-78.

ULTIMATE RUPTURE STRENGTH = 105 KgF/mm² (max)

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

EST. WT. 0.07 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 OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

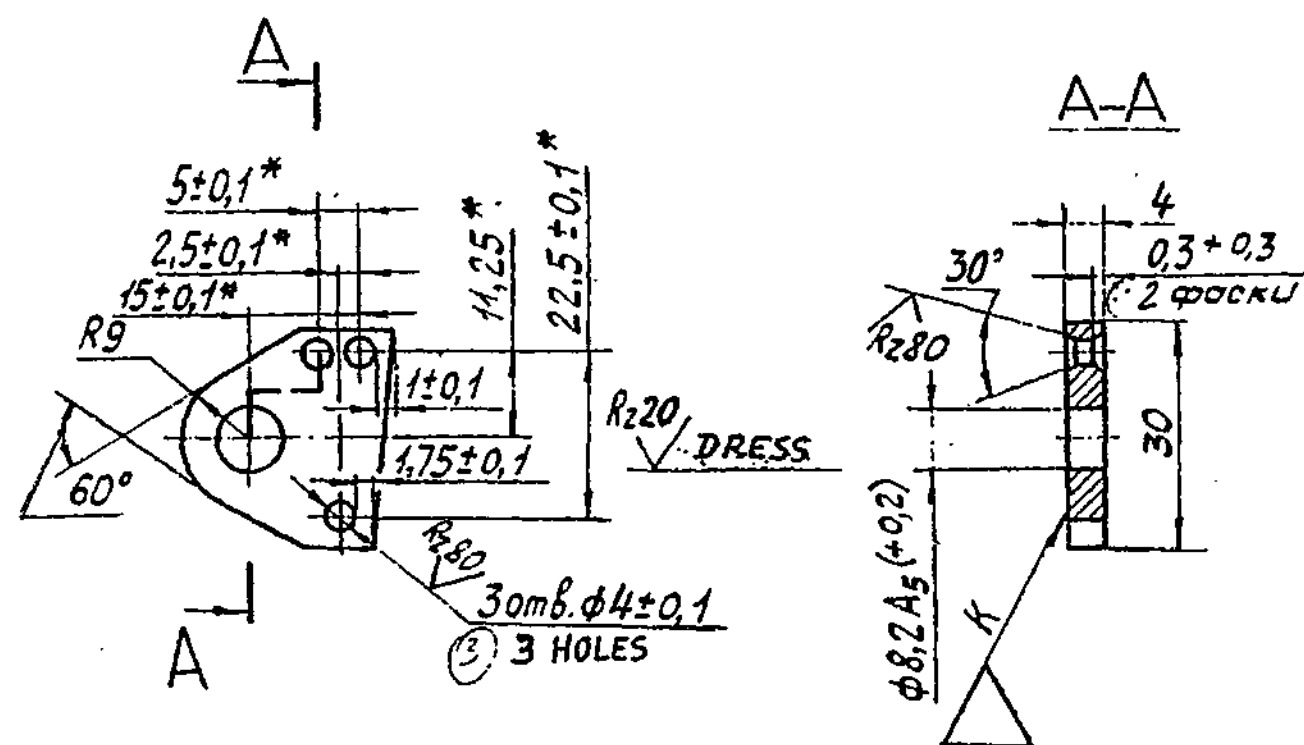
DRN	W. J. [Signature]	MATERIAL	WIRE 51X0A-A-II-XH-3.5 GOST 14963-78	USED ON	CB 20-15-603-5
ED	[Signature]	APPRO	[Signature]	CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	4-5-89	SCALE	1:1	A.V.A.O.I.	
DIMENSIONS IN mm			TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69	TITLE	
ALL THREADS TO CONFORM TO			GOVERNOR SPRING		
ISSUE	DATE	NATURE OF AMENDMENTS	D S CAT NUMBER	DRAWING NUMBER	
				20-15-623-1	

SIZE A2



DRAWING NUMBER
20-15-626-4

✓ (✓)



EXPLANATORY NOTE :

7. MATERIAL QUOTED : 4 GOST 19903-74
65Г GOST 14959-79.

HOT ROLLED SHEET STEEL

4 = THICKNESS. in mm

65Г (65G) = GRADE OF STEEL.

CHEMICAL COMPOSITION : % as per GOST 14959-79

- C = 0.62 - 0.70
- Si = 0.17 - 0.37
- Mn = 0.90 - 1.20
- Cr = 0.25 (max)
- P = 0.035 (max)
- S = 0.035 (max)
- Cu = 0.20 (max)
- Ni = 0.25 (max)

MECHANICAL PROPERTIES :

- HARDENING TEMPERATURE °C = 830
- HARDENING MEDIUM = OIL
- TEMPERING TEMPERATURE °C = 470
- YIELD POINT Kgf/mm² (min) = 80
- ULTIMATE STRENGTH Kgf/mm² (min) = 100
- RELATIVE ELONGATION % = 8
- RELATIVE REDUCTION % = 30

1. INSPECTION GROUP IV AS PER TECHNICAL REQUIREMENTS IT - 11.
2. H R C 43 TO 48.
3. REQUIREMENTS PLACED UPON STAMPING ARE AS PER STANDARD 82050-16.
4. AFTER STAMPING STRAIGHTEN AND DRESS BURRS WASHED.
5. COATING CHEMICALLY OXIDIZED OILED (TO BE ALLOWED IN ASSEMBLY).
6. * TOLERANCE ON DIMENSIONS IS DEPENDENT.

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

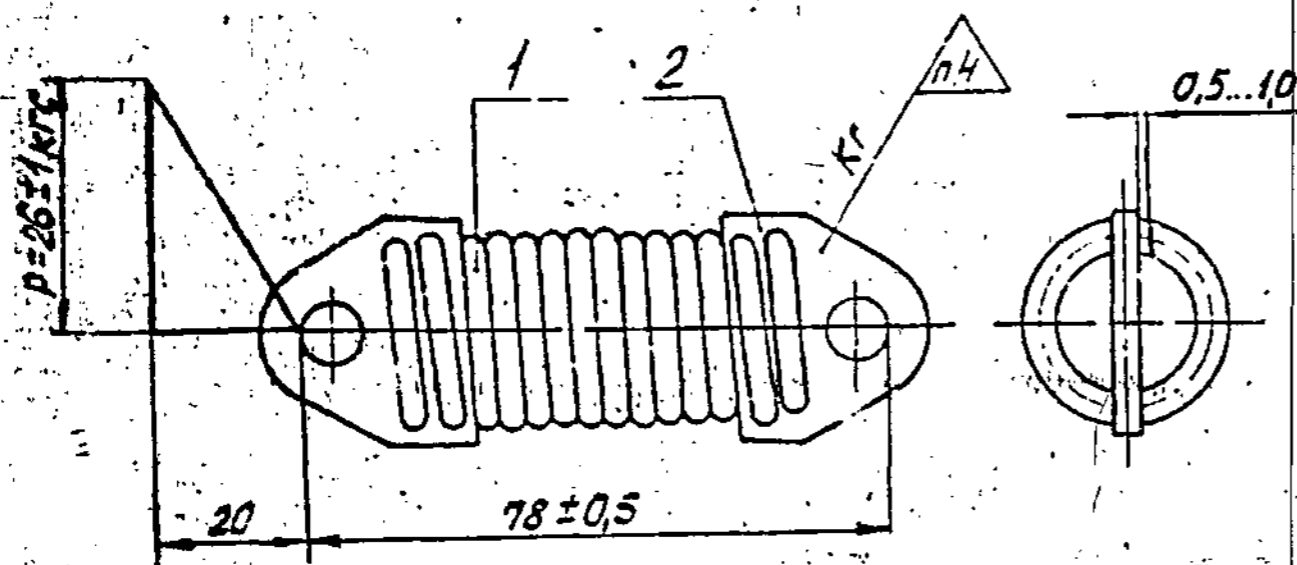
EST. WT. 0.013 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS ± LETTERS
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

DRN	DRN	MATERIAL :-	USED ON :-
CD	CD	4 GOST 19903-74	CG 20-15-603-5
TED	TED	65 Г GOST 14959-79	
APPO	APPO	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	DATE	A V A D I	
SCALE	SCALE	TITLE	
SCALE :- 1:1	SCALE :- 1:1	SPRING SHACKLE	
DIMENSIONS IN mm	DIMENSIONS IN mm	D S CAT NUMBER	
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69	DRAWING NUMBER	
ALL THREADS TO CONFORM TO	ALL THREADS TO CONFORM TO	20-15-626-4	
ISSUE	DATE	NATURE OF AMENDMENTS	

SIZE A2



DRAWING NUMBER
CB 20-15-603-5



1. Number of working turns is 10,5 .
2. Springshackles (Ref, No. 2.) should be in the same plane. The clearance between the butt-ends of extreme turns and the springshackles planes should be within the limits of 0,5 to 1,0 mm,.
3. Springshackles should freely rotate on non-working turns of the spring,
4. Stamp the value of weight on SHACKLE.
5. The number of turns may be varied to provide for the present load characteristic.

KVD NO 63404

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

EST. WT. 0.096 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 OUT SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

DRN	<i>Swamy</i>	MATERIAL:-	USED ON CB 20-15-663-4
CHKD	<i>S. S. Sankar</i>		
TCO	<i>Develly</i>		
APPO	<i>201</i>		
DATE	4-8-89	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES) AVADI	
SCALE:-	1:1		
DIMENSIONS IN mm TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS:2102-69			TITLE GOVERNOR SPRING ASSY
ALL THREADS TO CONFORM TO			D S CAT NUMBER
ISSUE DATE	NATURE OF AMENDMENTS		

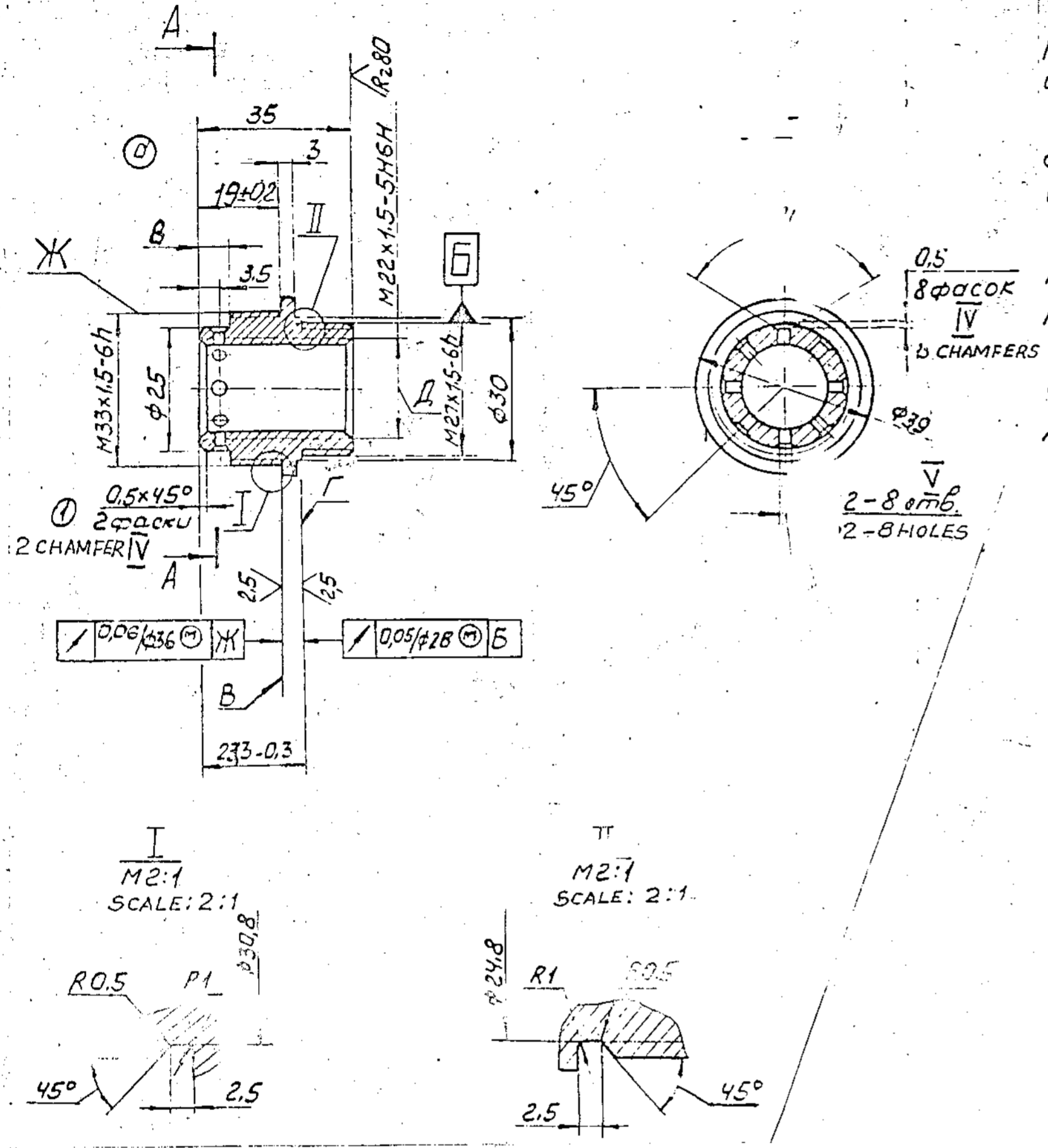


SIZE A3



DRAWING NUMBER
20-15-642-3

Rz40 (✓)



III

1. Неуказанные предельные отклонения размеров отверстий - по A_7 , валов - по B_7 , остальных - по CM_7 .
2. Отклонение от точности осей отверстий E от диаметра, в этой плоскости резьбы D не более 0,15 мм (пуск зависимый).
3. Отклонение от точности диаметрально противоположных отверстий E проверять калибром $\phi 1.8$.
4. Покрытие: Ц. с последующим удалением водородной хрупкости. Допускается нарушение покрытия на резьбовых поверхностях, торцах Г и В.
5. Заменитель материала - сталь 40,50 ГОСТ 1050-74.

III.

1. Unindicated limit deviations of dimensions: holes by A_7 , shafts by B_7 , the rest - by CM_7 .
2. Deviation from axle concentricity of holes E from diametrical plane II is 0.15 mm maximum (dependent tolerance).
3. Deviation from concentricity of diametrically opposite holes E should be checked by gauge $\phi 1.8$ mm.
4. Coating: Ц 3.xp. with following removal of hydrogen embrittlement.
Failure of the coating on threaded surfaces, end faces I and B is allowable.
5. Substitute of material is steel 40,50 GOST 1050-74.

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

EST. WT. 0.100 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

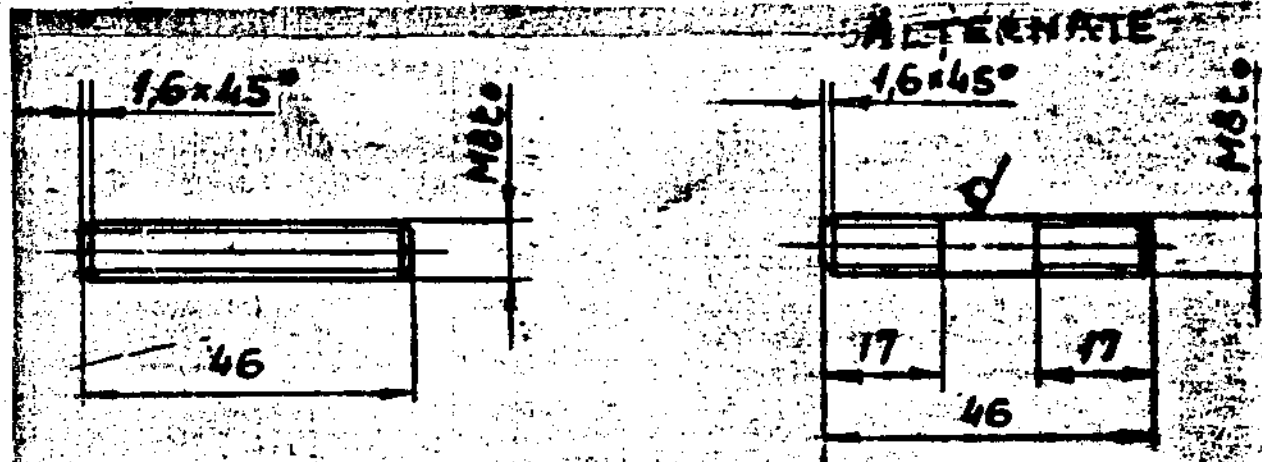
DRM	И.И.И.	MATERIAL :-	USED ON :-
CHD	И.И.И.	40-5 GOST 7417-75	СБ 20-15-601-7
TCO	И.И.И.	45 GOST 1050-74	
APPD	И.И.И.	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	16-2-93	A V A D I	
SCALE :-	1:1		
DIMENSIONS IN mm		TITLE	
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69		SLEEVE	
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
ISSUE	DATE	NATURE OF AMENDMENTS	20-15-642-3

DRG INTRODUCED BASED ON NOTN: 767-84-3 ORIGINAL ISSUE-1 (767-84)

SIZE A2

DRAWING NUMBER
550-105

Rz80 (✓)



1. INSPECTION GROUP IV AS PER TECHNICAL REQUIREMENTS TT - 11. HRC 26 TO 33.
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:
FOR SHAFTS - AS PER B₇,
OTHERS - AS PER CM₇
3. MAKE THREAD AS PER STANDARD 82020-12, ISSUE 7.
4. TECHNICAL REQUIREMENTS ARE AS PER GOST 1759-70.
5. COATING: CADMIUM-PLATED, 3 MICRONS THICK, OILED, WITH REMOVAL OF HYDROGEN EMBRITTLEMENT.
6. UNTHREADED PORTION OF THE ROD MAY BE MADE WITH IN THE LIMITS OF THE ANGLE DIAMETER OF THREAD.
7. IN THE ASSEMBLY UNITS MECHANICAL DAMAGE TO THE COATINGS SUCH AS SCRATCHES NOTCHES AND DENTS WHICH DO NOT EXPOSE STEEL ARE PERMITTED.

EXPLANATORY NOTE :

8. REFERENCE MATERIAL QUOTED :
HIGH QUALITY (A) CHROMIUM STEEL TO GRADE 38XA.
 - a) CHEMICAL COMPOSITION :

CARBON	-	0.35	-	0.42	%
SILICON	-	0.17	-	0.37	%
MANGANESE	-	0.50	-	0.80	%
CHROMIUM	-	0.80	-	1.10	%
SULPHUR	-	0.025	(max)	%	
PHOSPHORUS	-	0.025	(max)	%	
COPPER	-	0.30	(max)	%	
NICKEL	-	0.30	(max)	%	
 - b) PHYSICAL PROPERTIES :

YIELD POINT	-	80	Kgf/mm ²	(min)
UTS	-	95	Kgf/mm ²	(min)
ELONGATION %	-	12	(min)	
REDUCTION IN AREA%	-	50	(min)	
IMPACT STRENGTH	-	9	Kgfm/cm ²	(min)

(A) Alt. Material: STEEL 709M40 (EN-19) TO BS-970 Pt-1-1983

CB 20-11-02-9
CB-20-13-03-11

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

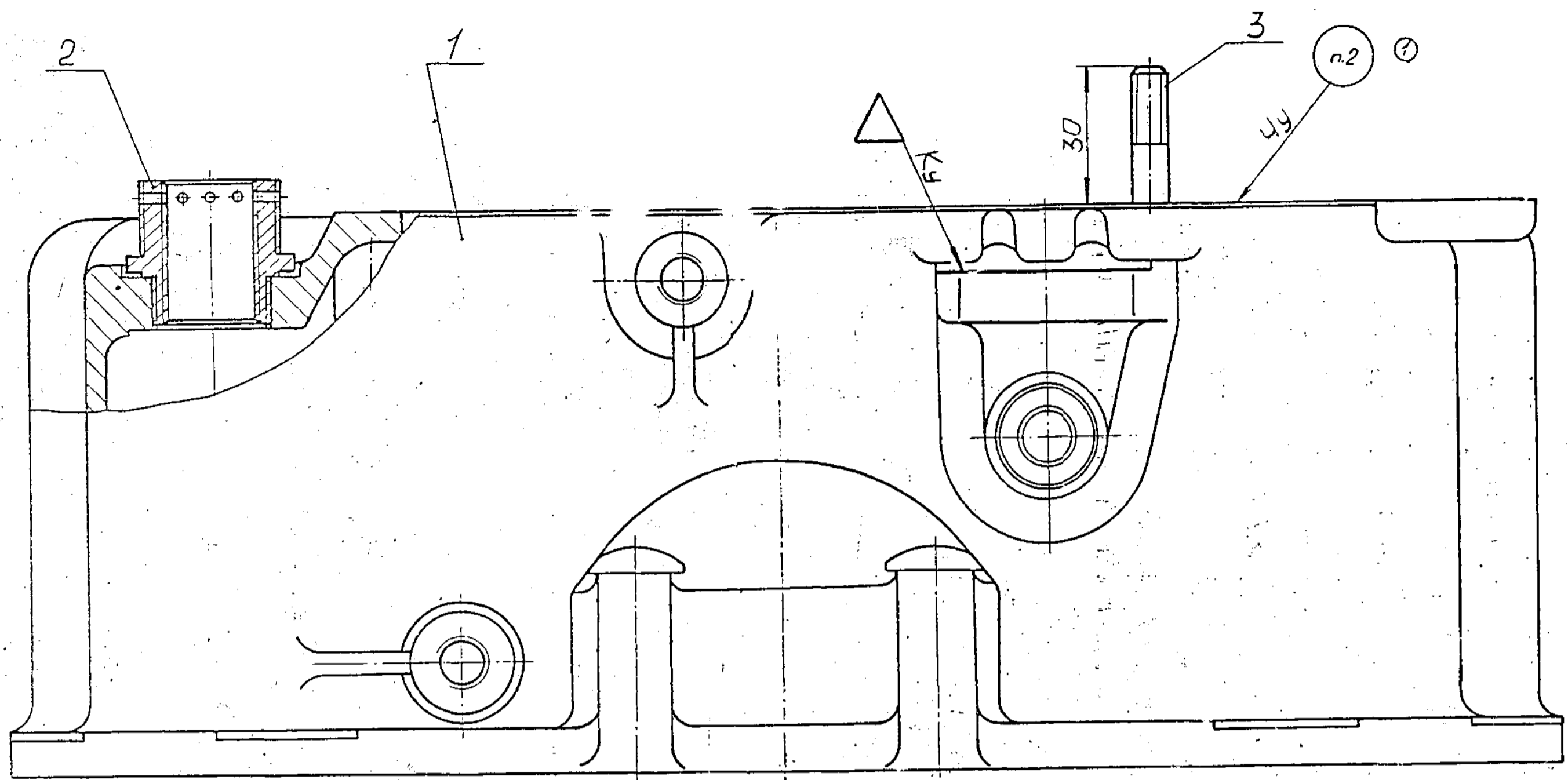
EST. WT. TO BE STAMPED OR MARKED WHERE INDICATED THUS \equiv (LETTERS)

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

DRN		MATERIAL:-	USED ON
CHK		38XA GOST 4543-71	CB 20-15-601-5
TCD			
APPD			
DATE	24-4-1987	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE:-	1:1	AVADI	
DIMENSIONS IN mm		TITLE	STUD M8X46
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS:2102-69			
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
A 18.5.09 Authy: Third Alt. Comm. Minutes Point: 2. Dated 27-02-2009.			550-105
ISSUE DATE	NATURE OF AMENDMENTS		



SIZE A3



I
 1. На сопрягающийся торец гильзы (поз. 2) и прилегающие к нему 2...4 нитки резьбы нанести лак 33Ш по инструкции И 240-280/75.
 2. Маркировать шрифтом ПО 5 ГОСТ 2930-62 при отправке в запчасти.

- I.
1. Apply 33 Ш varnish on mating barrel end face (pos.2) and 2...4 threads adjoining to it according to И 240-280/75 instruction.
 2. Mark by the ПГО 5 GOST 2930-62 type when delivering as spare parts.

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

EST. WT. / 3.1 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.	

DRM	APPROVED	MATERIAL :-	USED ON :- CB 20-15-663-4
EDD	APPROVED		
TED	APPROVED	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
APPO	APPROVED	A V A D I	
DATE	16-12-93	TITLE GOVERNOR BODY	
SCALE	1:1	D O S CAT NUMBER	
DIMENSIONS IN MM		DRAWING NUMBER CB 20-15-601-7	
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69			
ALL THREADS TO CONFORM TO			
ISSUE	DATE	NATURE OF AMENDMENTS	

DRG. INTRODUCED BASED ON NOTN. 767-84
 DRG. INDICATED BASED ON RUSSIAN ORIGINAL ISSUE-1