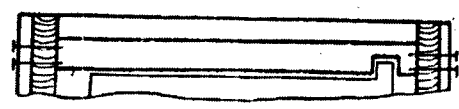
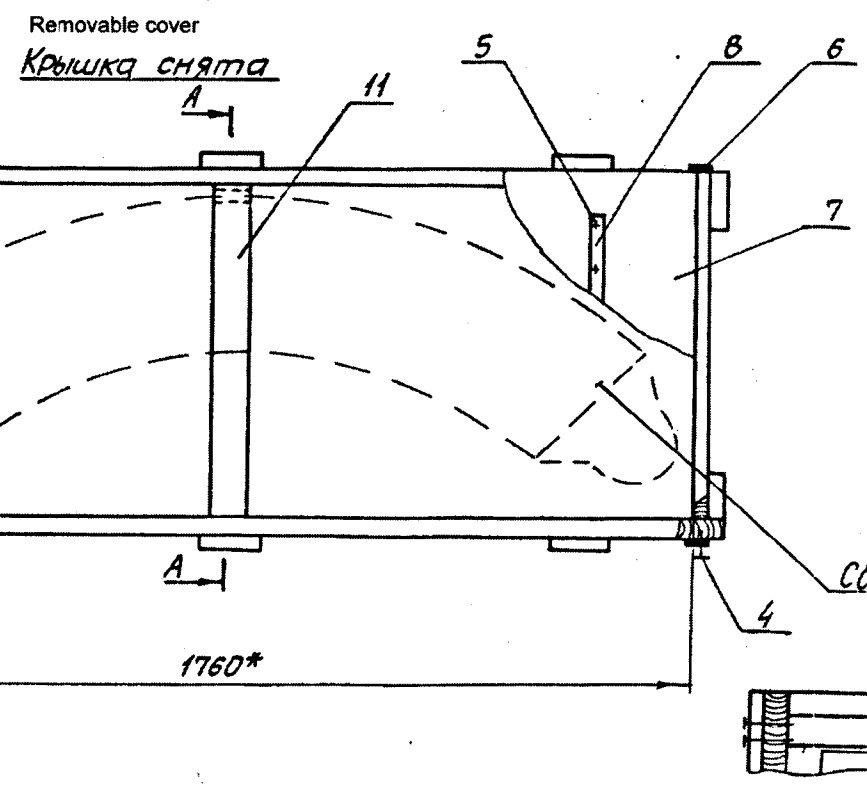
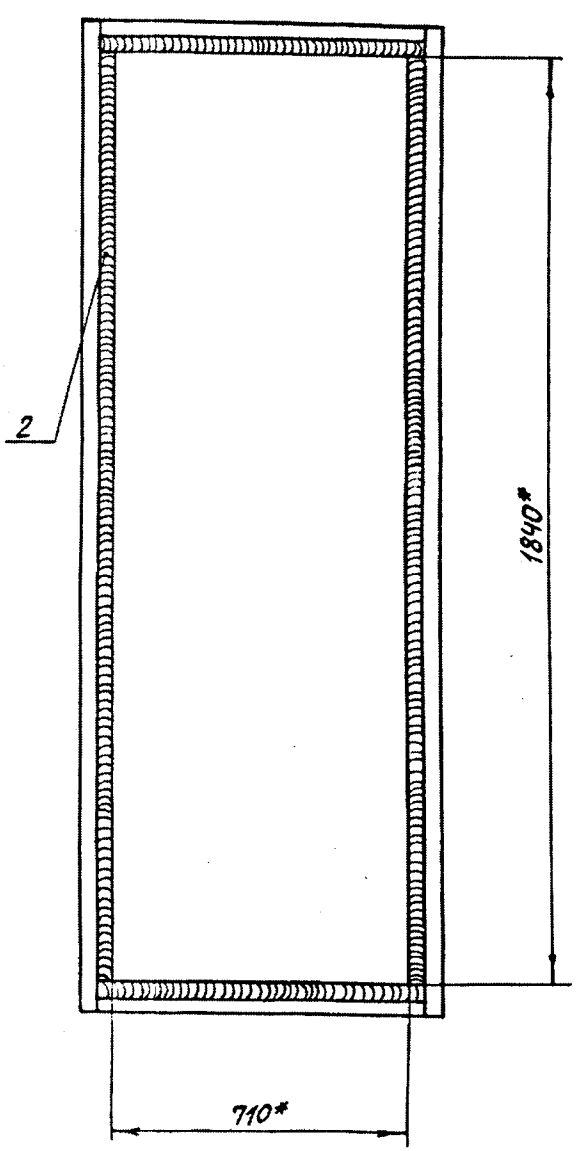
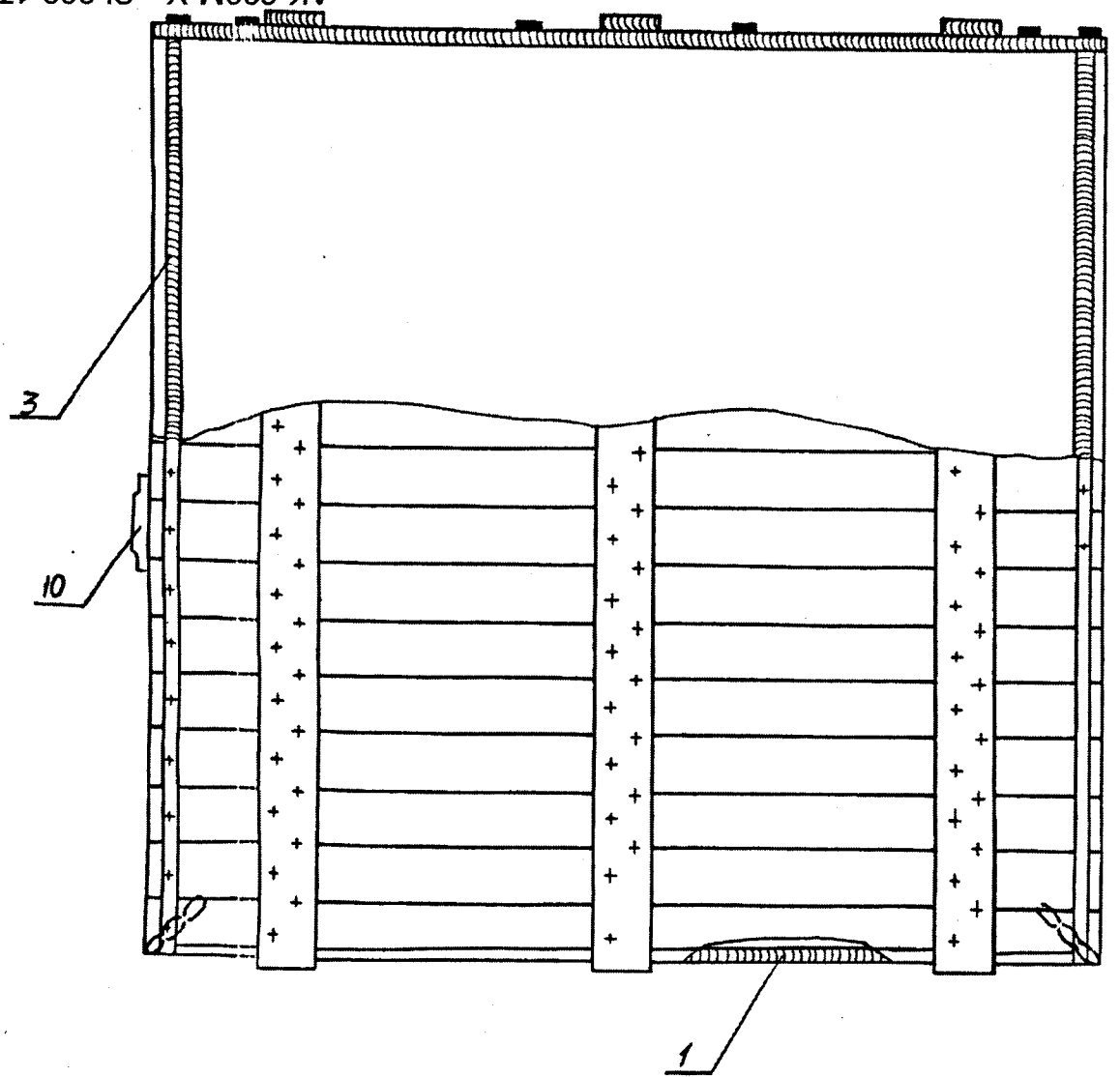


First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A2	✓		AK-630M-Ya Sb 300-1TR SB	Assembly drawing			
					<u>Assembly units</u>			
	A4	✓	1	AK-630-Ya Sb 300-1-1TR	Cover-bottom	2		
	A4	✓	2	AK-630-Ya Sb 300-1-2TR	Face wall	2		
	A4	✓	3	AK-630-Ya Sb 300-1-3TR	Side wall	2		
					<u>Components</u>			
	WD	✓	11	AK-630-Ya 300-10-3TR	Board-2Khv -40 x 125 GOST 8486-86 BxHxL = 40 ± 2x 50 ± 2x 710± 5	1		
					<u>Standard articles</u>			
	Dupl. Inv. No.			4		Nails K 3x 70 GOST 4028-63	184	
			5		Nails 2 x 25 GOST 4029-63	380		
			10		Pocket 1 GOST 24634-81	1		
Sign and Date	AK-630M-Ya Sb 300-1 TR							
	Amend.	Sheet	Doc. No.	Sign	Date			
	Developed by					Type	Sheet	Sheets
	Checked by					A	1	2
	Head of Q.C.D							
Orig. Inv. No.	Approved by					Transportation box No. 6 TRM		

AK-630M-Я СБ300-1TRCB

AK-630M-Я SB300-1TRSB



1. *Размеры для справок.
2. Гвозди располагать от кромок на расстоянии 1/4 ширины доски.
3. Углы ящика обить стальной лентой поз. 6.
4. Внутренние стенки и дно ящика обить пергамином кровельным П-350 ГОСТ 2697-83 или бумагой ДБ ГОСТ 8828-89 с креплением ее дранью размером 3,5+5,0x25 поз.8 и гвоздями поз.5.
5. Наружную поверхность крышки ящика обить в 2 слоя рубероидом РКК-350 ГОСТ 10923-93 с креплением ее дранью размером 3,5+5,0x25 поз.8 и гвоздями поз.5.
6. Манипуляционные знаки №11 (↑↑) с размерами для ярлыка №4 по ГОСТ 14192-96.
7. Надписи и знаки выполнять эмалью ПФ-115 черная ГОСТ 6465-76 Шрифт ПО-24 ГОСТ 2930-62 располагать симметрично. Транспортную маркировку нанести краской на передней стенке в соответствии с ГОСТ 14192-96 и договора.
8. Остальные технические требования по ГОСТ В 6454-75.
9. После укупорки ящик опломбировать с использованием проволоки КО 0,5 ГОСТ 792 - 67 и 4х пломб 1-6x10-АД1М ГОСТ 18677-73 в 2х местах крепления ленты в замок.
10. Допускается местная непростройка каждой стороны площадью не более 20% глубиной до 1мм и чистотой обработки Rz1200
11. Изделие закрепить сверху одним брусом поз. 11, сделав в нем паз по месту и прибить гвоздями поз. 4 к стенкам ящика.

1. * - Dimensions for reference.
2. Put the nails at a distance of 1/4 th width of board from the edge.
3. Cover the angles of box with steel strip position 6.
4. Cover the internal walls and the bottom of box with roof tracing paper P 350 GOST 2697-83 or by the paper DB GOST 8828-89 by roofing it with thick woolen cloth having dimension of 3.5 to 5.0x25 position 8 and with nails position 5.
5. Cover the external surface of the cover of box in 2 layers with roofing material RKK-350 GOST 10923-93 by fastening it with thick woolen cloth having dimension of 3.5 to 5.0x25 position 8 and with nails position 5.
6. Manipulated markings No. 11 (↑↑) with dimensions for label No. 4 as per GOST 14192-96.
7. Make the inscriptions and markings with enamel PF-115 black GOST 6465-76 arrange the font PO-24 GOST 2390-62 symmetrically. Make transportation marking with paint on the front wall in conformity with GOST 14192-96 and in conformity with agreement.
8. Remaining technical requirements as per GOST V 6454-75.
9. After corking, seal the box with wire KO 0.5 GOST 792-67 and 4 seals 1-6x10-AD1M GOST 18677-73 at two places for fastening of strip for lock.
10. Local shaving of each side with area not more than 20 % of the depth up to 1 mm and the finishing of Rz1200 is permitted.
11. Fasten the article with one arm position 11 upward, after having made the place wise groove on it and fasten with nails position 4 to the walls of box.

AK - 630M-Я Sb 300-1 TR SB

Справ. №
Перв. примен.

Инд. № подл.
Инд. № инв.
Инд. № дубл.
Инд. № подл. и дата
Инд. № инв. и дата

				AK-630M-Я СБ300-1TR СБ		
				Type	Mass	Scale
Изм.	Лист	№ док.	Подп.	Лист	Масса	Масштаб
Разраб.				A	430	1:10
Проб.				Лист	Листов 1	
Т.контр.				Sheet	Total Sheets 1	
Н.контр.				Transportation Box No. 6 TRM		
Чиб.				Assembly Drawing		

Формат А2

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
Reference No.					<u>Documents</u>		
	A3			AK-630M-Ya Sb 300-1TR SB	Assembly drawing		
					<u>Components</u>		
	WD	1		AK-630-Ya 300-1TR	Board-2 Khv-25 x 100 GOST 8486-86 L = 1860 ± 5	6	
	WD	2		AK-630-Ya 300-2TR	Board-2 Khv-25 x 150 GOST 8486-86 L = 1860 ± 5	1	
	WD	3		AK-630-Ya 300-3TR	Board-2 Khv-25 x 100 GOST 8486-86 L = 760 ± 5	3	
					<u>Standard article</u>		
			4		Nails K 2.5 x 60 GOST 4028-63	48	
Sign and Dr							
Dupl. Inv. No.							
Alternate Inv. No.							
Sign an State							
Orig. Inv. No.							

AK-630M-Ya Sb 300-1-TR

Amend. Sheet Doc. No. Sign Date

Developed by

Checked by

Head of Q.C.D

Approved by

Cover-bottom

Type Sheet Sheets

A

1

AK-630M-Ya Sb300-1-1 TR SB

First use

Reference No.

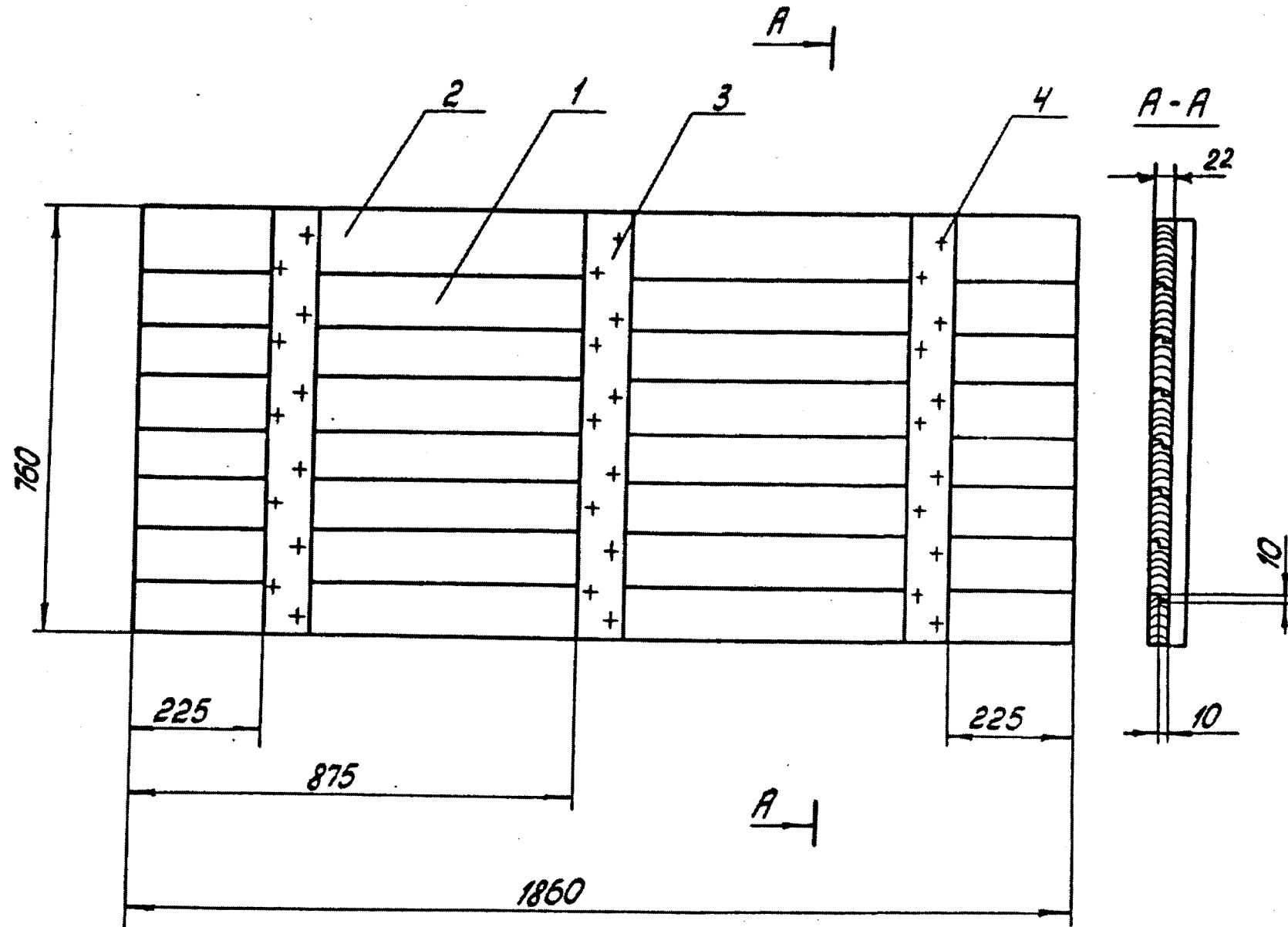
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



R_z500/√(√)

1. Maximum deviation of dimensions as per standard accuracy class GOST 6449-5-82.
2. Joining of boards in ¼ without through gaps.
3. For special supply the boards should be made from edged board, without wanes, dressed, holes due to knots not permissible.
4. It is permissible to make size 760 from boards 2 Khv-25 of different width if they are not less than 70 mm.

					AK-630M-Ya Sb300-1-1 TR SB			
Amend.	Sheet	Doc.No.	Sign	Date	Cover-bottom Assembly drawing	Type	Weight	Scale
Developed by						A	16.5	1:10
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by								

AK-630M-Ya Sb300-1-2 TR SB

First use

Reference No.

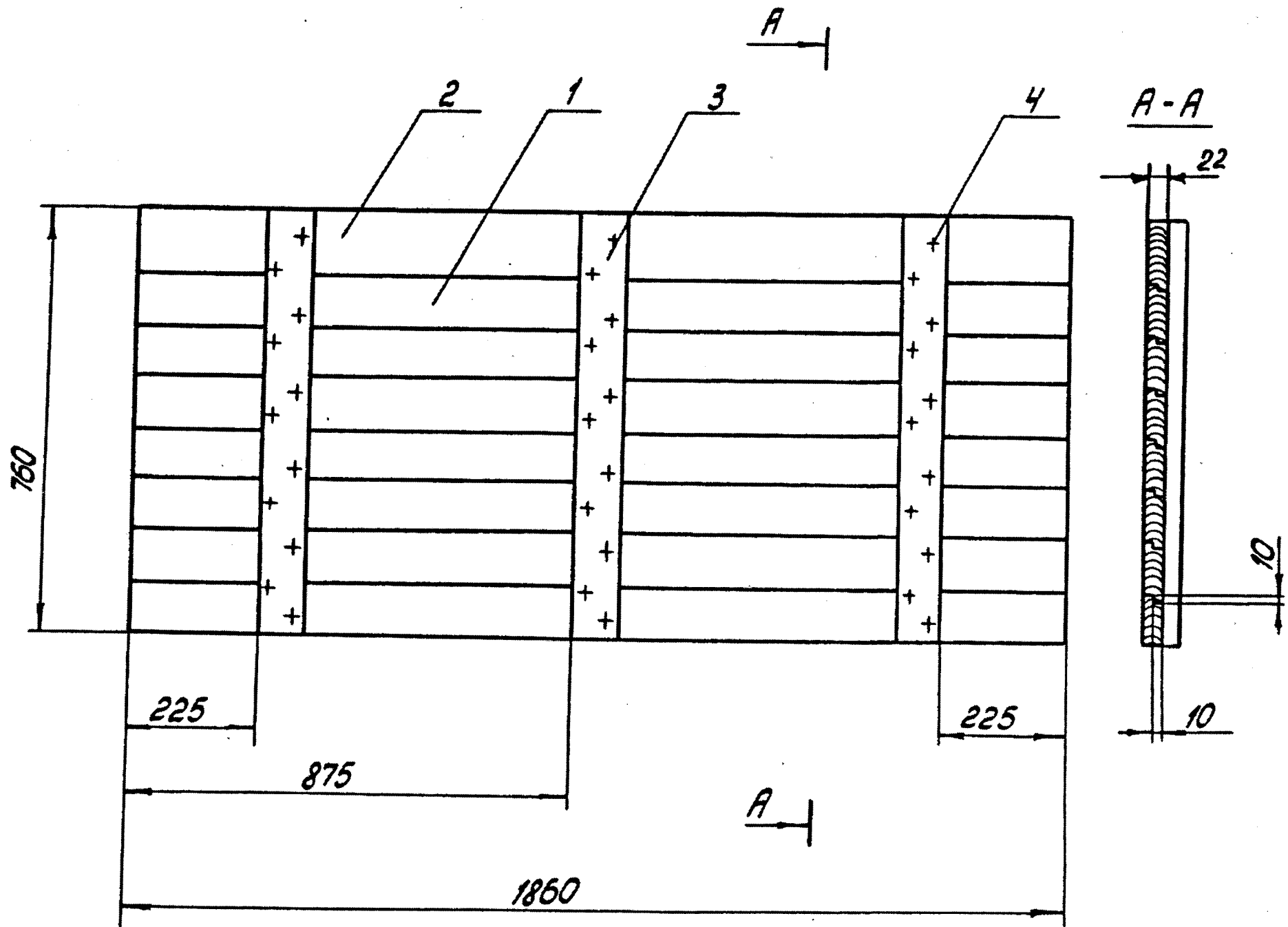
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz500/√(√)

1. Joining of boards in $\frac{1}{4}$ without through gaps.
2. Maximum deviation of dimensions as per standard accuracy class GOST 6449-5-82.
3. For special supply the boards should be made from edged board, without waness, dressed, holes due to knots not permissible.
4. It is permissible to make size 1840 from boards 2 Khv-25 of different width if they are not less than 70 mm.

Amend.	Sheet	Doc.No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

AK-630M-Ya Sb300-1-2 TR SB

Side wall
Assembly drawing

Type	Weight	Scale
A	105	1:10
Sheet	Sheets 1	

