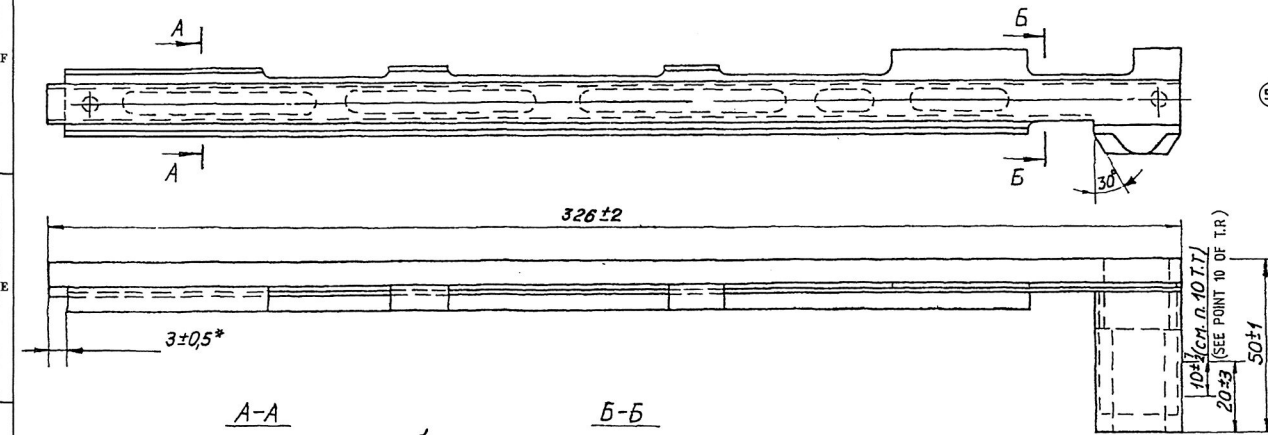
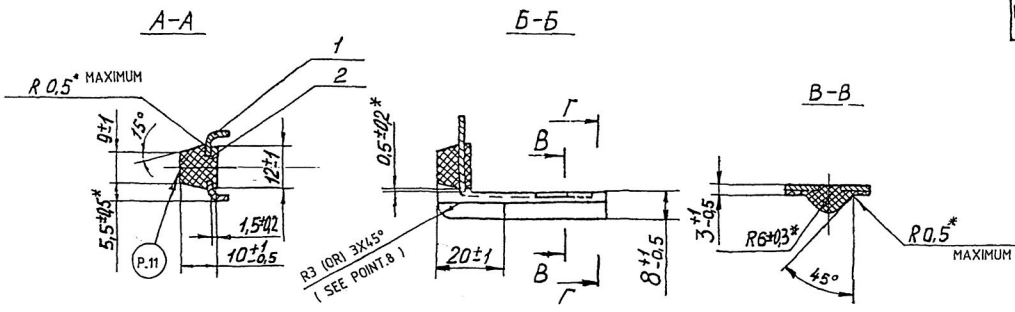


19 JAYATELULI, 10001
FEB 07

COMMON TC T-9C & BLT
DRAWING RE-INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE -5



1. COMPONENT 2 SHOULD BE MANUFACTURED FROM RUBBER HO-68-1 TY-005216-75. **NBR + CR (BNC Grade of CQA(HV))**
2. ON UN-RUBBERIZED SURFACES EXCEPT END FACES OF FLANGES, A THIN FILM OF RUBBER IS ALLOWED.
3. SKEWNESS OF AXIS OF DIE SHOULD NOT EXCEED 1mm.
4. ON RUBBERISED SURFACES, LOCAL CAVITIES WITH A DIAMETER UPTO 4mm DEPTH UPTO 1mm IN QUANTITY NOT MORE THAN 4 IS ALLOWED.
5. TECHNICAL REQUIREMENTS FOR ACCEPTANCE OF COMPONENT SHOULD BE IN ACCORDANCE WITH **NBR + CR (BNC Grade of CQA(HV))** TY-005216-75 CODE 263161+. (SE)
6. ROUNDING-OFF OF CORNERS WITH A RADIUS UPTO 1mm ALLOWED.
7. DIMENSIONS WITHOUT SPECIFY TOLERANCES ARE GIVEN TO PROVIDE MANUFACTURE OF DIE.
8. RADIUS R3 OR 3x45 (SEE SEC. 5-B) SHOULD BE GRINDED IN THE TIME OF MOUNTING ON ROOF.
9. GASKET IS TO BE PASTED USING HOT VULCANIZATION WITH PASTE (LEIKONAT) TY 6-14-95-75.
10. BOTH ON THE FACES OF COMPONENT STEAM AND SURFACES IN WIDTH WIDTH OF 1.5 MIN ON BOTH SIDES AND LENGTH OF $10 \pm \frac{7}{2}$ THE PRESENCE OF RUBBER IS NOT ALLOWED. WHEN MOUNTING ON ROOF THE DRESSING OF RUBBER IS ALLOWED.
11. TO BE MARKED NOTATIONS OF MANUFACTURING FACTORY AND COMPONENT NUMBER BY RAISED TYPE AS PER 3 GOST 2930-62.
12. *DIMENSIONS ARE ENSURED BY THE TOOLS.



EXPLANATORY NOTE

RUBBER HO-68-1 TY 005216-75 (SE)

CHEMISTRY	PHYSICAL PROPERTIES AND HARDNESS
NOT APPLICABLE	WORKING MEDIUM : AIR, OILS, LUBRICANTS
	WORKING TEMPERATURE : - 50-70 + 100°C
	TENSILE STRENGTH : 90 Kgf/cm ² (min)
	ELONGATION : 250 % (min)
	HARDNESS (TIA P) DEVICE : 55 - 70
	DENSITY : 1.24 g/cm ³ ± 0.05
	DURING USE IT SHOULD WITHSTAND A PRESSURE UPTO 100 Kgf/cm ²
	TYPE OF RAW RUBBER : CKH-18
	RESIDUAL ELONGATION: 12 % Max.

PASTE (LEIKONAT) TY 6-14-95-75.

CHEMISTRY	PHYSICAL PROPERTIES AND HARDNESS
CONTENT OF 4, 4', 4" TRITANETRISOCYANATE : 20 ± 1% CONTENT OF INSOLUBLE INCLUSIONS IN DICHLOROETHANE = 0.1 % (max)	STRENGTH OF BOND BETWEEN RUBBER AND STEEL } = 4.0 Kgf/cm ² (min)
	DRYINGOUT TIME : 40 minutes (max)

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

EST. WT. (Kg)	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
0.146	

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

EQUIVALENT MATERIAL: (SE)

NBR + CR (BNC Grade of CQA(HV))

DRN	Sd=	MATERIAL:-	USED ON:- 172.02.079cb-8Cb
CHD	Sd=		188.02.079cbCb (SE) PV572.0718.0160
APPD	Sd=	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	04-02-87	AVADI	
SCALE:-	1 : 1		
DIMENSIONS IN mm		TITLE:- (SE) GASKET	
TOLERANCE ON DIMENS UNLESS OTHERWISE STATED IS: 2102-69			
5E	30.09.19	83291/TECH GEN/EO MATL/HVF dt. 25.09.19	
5D	01.07.19	83291/Tech Gen/EQ Mat/HVF dt. 02.04.19	
5C	03.09.11	55150/CQA(HV)/DB/BLT 1-77 DT. 19.07.11	
5B	22-5-09	AS PER KIT LIST No. CQA(HV)/SET/0047 (KIT No.1)	
5A	04.08.03	N of A No. CQA(HV) / T90 / 001.	
ISSUE	DATE	NATURE OF AMENDMENTS	
D S CAT NUMBER		DRAWING NUMBER	
DCAN: 53303814.02		172.02.146cb-A Cb	





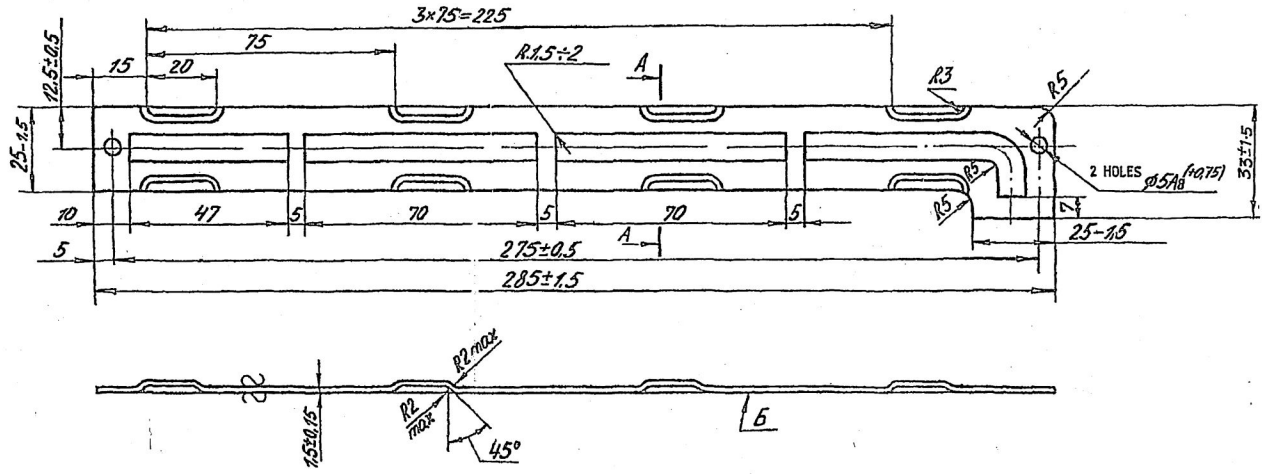




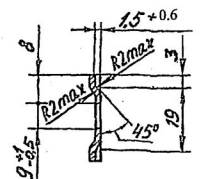
DRAWING NUMBER
172 02 540

SHEET No. 1 OF 1

▽1(▽)



A-A



EXPLANATORY NOTE

DEEP DRAWN STEEL 10KN GOST : 16523-70

CHEMISTRY	PHYSICAL PROPERTIES AND HARDNESS
C : 0.07 - 0.14	TENSIL STRENGTH : 28 - 40 Kgf/mm ²
Si : 0.07 (max)	RELATIVE ELONGATION : 25 %
Mn : 0.25 - 0.50	BEND TEST : SHOULD WITHSTAND 180° BEND WITHOUT CRACK .
Cr : 0.10 (max)	CUPPING TEST : 11.2 mm SPHERICAL INDENTATION TO BE MADE BEFORE CRACKING .
S : 0.040 (max)	
P : 0.025 (max)	

1. MAY BE MANUFACTURED FROM OPEN HEARTH STEEL 10Kn-5 III GOST 16523-70.
2. NONFLATNESS OF SURFACE "B" SHOULD NOT BE MORE THAN 1.5mm
3. DEVIATIONS ON DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE ± 1.0 mm.
4. SHRINKAGE OF EDGES IN STAMPED RECESS PLACES NOT TO BE CHECKED.
5. CORRUGATION AND TOOL MARKS ARE ALLOWED ON COMPONENT SURFACE.
6. THE REST OF REQUIREMENTS ACCORDING TO TY 005216-75 (APPENDIX 1)

Ⓐ ALTERNATE MATERIAL
CRCA SHEET GRADE 'D'
IS: 513-B6.

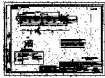
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. WT. 0.08 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	Sd/=	MATERIAL:- OPEN HEARTH STEEL 10Kn-5 III GOST 16523-70	USED ON:- 172 02 148 Cb
CHD	Sd/=	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
APPD	Sd/=	TITLE:- FRAME	
DATE	4. 2. 87	D S CAT NUMBER	
SCALE:- 1 : 1		DRAWING NUMBER 172 02 540	
DIMENSIONS IN mm			
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS : 2102-69			
ALL THREADS TO CONFORM TO			
6A	11-12-91	N OF A COA(HV)/02/001	
ISSUE	DATE	NATURE OF AMENDMENTS	

COMMON TO T-90 " & BLT
DRG. RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 6
B. JAYAVELU, JTDID
15-04-88

F-15
32
SIZE A2



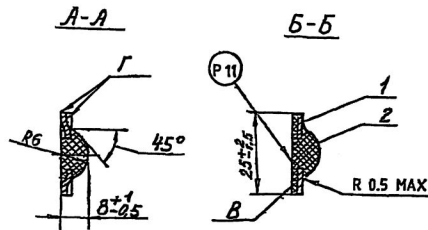
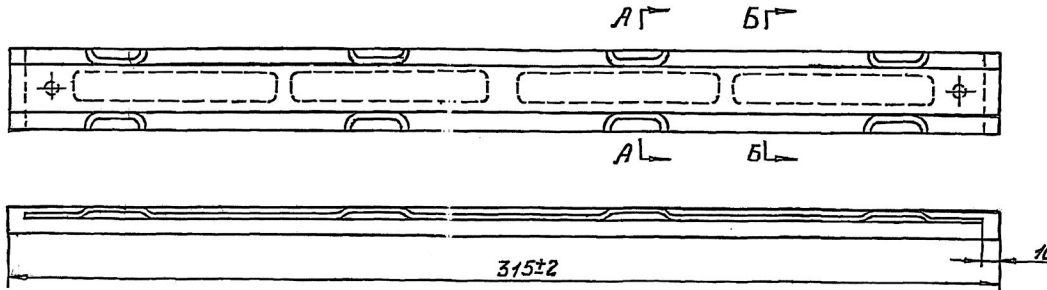


DRAWING NUMBER
172.02.151cbCb

SHEET No. 1 OF 1

(BJAYAVELUJ)TODI
15.04.08

COMMON TO T - 90 " & BLT
DRG.RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 11



1. COMPONENT ITEM NO 2 IS TO BE MANUFACTURED FROM RUBBER HO-68-1 TY-005216-75- NBR + CR (BNC Grade of CQA(HV))
2. ON NON RUBBERISED SURFACES FILM OF RUBBER IS ALLOWED.
3. ON SURFACE "B" A PILOT HOLE OF $\phi 4$ to 5mm IS UP TO DEPTH OF 6mm IS ALLOWED.
4. SKEWNESS (SHIFT) OF AXIS OF DIE NOT TO EXCEED 1mm
5. ON THE BOTH SIDES OF SURFACES "D" OF STAMPINGS AT THE LENGTH NOT LESS THAN 10mm AND WIDTH NOT LESS THEN 1.5mm PRESENCE OF RUBBER IS NOT ALLOWED, DRESSING IS ALLOWED.
6. ON RUBBERISED SURFACE LOCAL CAVITIES WITH DIAMETER UP TO 4mm & DEPTH UP TO 1mm TOTALLY IN QUANTITY NOT MORE THEN 4 IS ALLOWED.
7. TECHNICAL REQUIREMENTS FOR ACCEPTANCE OF COMPONENTS SHOULD BE AS PER TY-005216-75 CODE 253164. NBR + CR (BNC Grade of CQA(HV))
8. ROUNDING OFF OF ANGLES UPTO 1mm RADIUS IS ALLOWED.
9. GASKET IS TO BE GLUED WITH HOT PROCESS (VULCANISING METHOD) WITH GLUE "LEUKONAT" TY 6-14 95-75.
10. PEELING OF RUBBER UPTO A DEPTH OF 4mm IN STAMPING AREA IS ALLOWED.
11. BOTH NOTATION OF MANUFACTURING PLANT AND NUMBER OF COMPONENT SHOULD BE MARKED WITH RAISED TYPE AS PER 3 GOST-2930-62.

EXPLANATORY NOTE: (1)

12. 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 MIN
ELONGATION OF RUPTURE	250% MIN
RESIDUAL ELONGATION	12 % MAX
HARDNESS IN CONVENTIONAL UNITS	55 TO 70 (OF TMAP)
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: (11)

NBR + CR (BNC Grade of CQA(HV))

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

EST. WT. 0.092 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	Sd/=	MATERIAL:-	USED ON:- 188.02.002cbCb 172.02.002cb-2Cb
CHD	Sd/=		(11A)
APPD	Sd/=		
DATE	01.07.19	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
SCALE:-	1:1		
DIMENSIONS IN mm			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69		TITLE:- GASKET	
11C 30.09.19 83201/Tech Gen/EQ.MATL/HVF dt. 25.09.19		D S CAT NUMBER	
11B 01.07.19 83201/Tech Gen/EQ. Mat/HVF dt. 02.04.19		DRAWING NUMBER 172.02.151cbCb	
11A 4.8.03 N OF A No. CQA(HV)/T90/02/001.			
LI 24-4-81 EXPLANATORY NOTE ADDED			
ISSUE DATE NATURE OF AMENDMENTS			

F-12
16

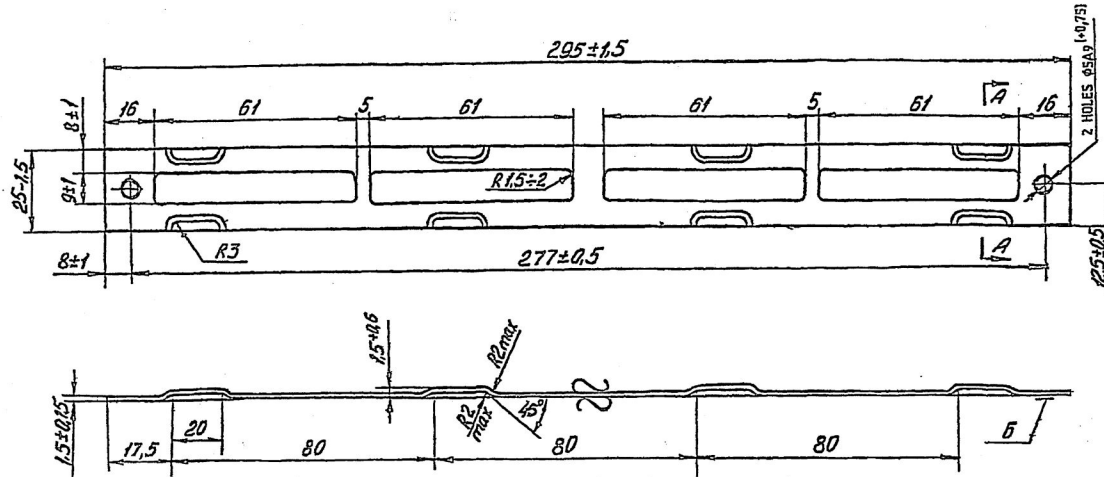
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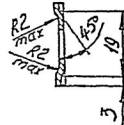
DRAWING NUMBER
172.02.546

SHEET No. 1 OF 1

▽1(▽)



A-A



1. MAY BE MANUFACTURED FROM OPEN-HEARTH STEEL 10 K Π -5 -III Г GOST 16523-70.
2. BUCKLING OF PLANE, 'E' UP TO 1,5mm.
3. DEVIATIONS ON DIMENSIONS WITH UNSPECIFIED TOLERANCES ± 1 mm.
4. SHRINKAGE OF EDGES IN STAMPED RECESS PLACES IS NOT ALLOWED.
5. CORRUGATION AND TOOL MARKS ARE ALLOWED ON COMPONENT SURFACE.
6. THE REST OF REQUIREMENTS IN ACCORDANCE WITH TY 005216-75 (APPENDIX N1).

EXPLANATORY NOTE: (1)

- 7 a) REFERENCE MATERIAL QUOTED:-
QUALITY CARBON STEEL OF CATEGORY 5, HIGH FINISH ON QUALITY OF SURFACE FINISH DEEP DRAWN TO GRADE 10 K Π GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH STEEL GRADE 10 K Π TO GOST 1050-74 OPEN HEARTH
- b) REFERENCE NOTE 1 ON ALTERNATIVE MATERIAL:
QUALITY CARBON STEEL OF CATEGORY 5, SUPERIOR FINISH ON QUALITY OF SURFACE FINISH, DEEP DRAWN, TO GRADE 10 K Π GOST 16523-70 & MANUFACTURED IN ACCORDANCE WITH STEEL GRADE 10K Π TO GOST 1050-74 OPEN HEARTH
8. a) CHEMICAL COMPOSITION: AS PER STEEL GRADE 10 K Π GOST 1050-74 OPEN HEARTH.

CONTENT OF ELEMENTS %					
C	Si	Mn	Cr	S	P
MAX					
0.07-0.14	0.07-MAX	0.25-0.50	0.15	0.040	0.035

RESIDUAL CONTENT OF COPPER & NICKEL SHOULD NOT EXCEED 0.25% EACH.

- b) MECHANICAL PROPERTIES: AS PER STEEL GRADE 10 K Π GOST 16523-70 OF CATEGORY 5, DEEP DRAWN.

TENSILE STRENGTH Kgf/mm ²	ELONGATION %	CUPPING TEST DEPTH OF SPHERICAL HOLE MIN	BEND TEST 180°
28-40	25	11.2	CLOSE

"COMMON TO T-90" & BLT
DRG. RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 5

F-15
33
SIZE A2

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

EST. WT. 0.061 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	Sc/=	MATERIAL:- OPEN HEARTH STEEL 10K Π -5-III Г GOST 16523-70	USED ON:- 172 02 151 Cb
CHD	Sc/=		
APPD	Sc/=		
DATE	21-1-87	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
SCALE:-	1:1	TITLE:- FRAME	
DIMENSIONS IN mm			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69			
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER 172.02.546
L1	24-6-88	EXPLANATORY NOTE ADDED	
ISSUE	DATE	NATURE OF AMENDMENTS	

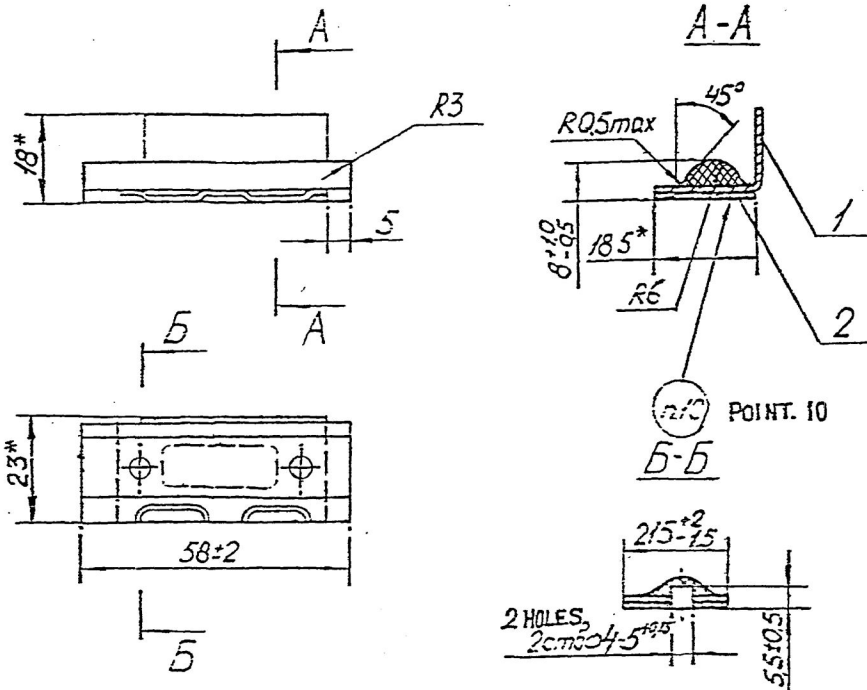




"COMMON TO T-90" & BLT
DRG RE-INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NIL
09-05-08
(G. THIRUGANAM), JTO(D)

DRAWING NUMBER
172.02.224cbCb

SHEET No 1 OF 1



1. COMPONENT 2 TO BE MANUFACTURED FROM THE RUBBER
HO-68-1-Ty 005216-75.
2. ALL DIMENSIONS TO BE ENSURED BY TOOL.
3. * DIMENSIONS FOR REFERENCE.
4. ON UNRUBBERED SURFACES THE RUBBER FILM IS ALLOWED.
5. RUBBER IS NOT ALLOWED ON THE STAMP SURFACES TO A MINIMUM LENGTH 10 mm AND WIDTH 1.5 mm, AND ALSO ON THE EDGES, ON LENGTH OF STAMPS. IT MAY BE DRESSED.
6. CAVITIES WITH A DIAMETER UPTO 4 mm AND LENGTH UPTO 1 mm IN NUMBER NOT MORE THAN 2 IS ALLOWED.
7. UNSPECIFIED ROUNDING-OFF OF ANGLES UPTO R1 mm.
8. RUBBER OPERATION TO A DEPTH 4 mm IS ALLOWED IN THE STAMPING AREA.
9. RUBBER IS TO ATTACHED TO THE METAL WITH A GLUE
"LEYKANAT" Ty-6-14-95-75.
10. DESIGNATION OF MANUFACTURING PLANT AND COMPONENT NUMBER TO BE MARKED BY RAISING TYPE П0-3 GOST 2930-62.
11. OTHER REQUIREMENTS ACCORDING TO Ty 005216-75. CODE 253161.

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

EST. WT. (Kg) TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
0.013

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

				DRN	Sd/=	MATERIAL:-	USED ON:- IN BULK (B) PV572.0718.0060 (C) 188-02.096cbcb (A)
				CHD	Sd/=		
				APPD	Sd/=		
				DATE	30-06-88	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
				SCALE:- 1 : 1			
				DIMENSIONS IN mm		TITLE:- GASKET ASSY	
				TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69			
				ALL THREADS TO CONFORM TO IS: 4218 Pt. IV		D S CAT NUMBER	DRAWING NUMBER 172.02.224cbCb
				ISSUE	DATE	NATURE OF AMENDMENTS	

F-2B
19

SIZE A3

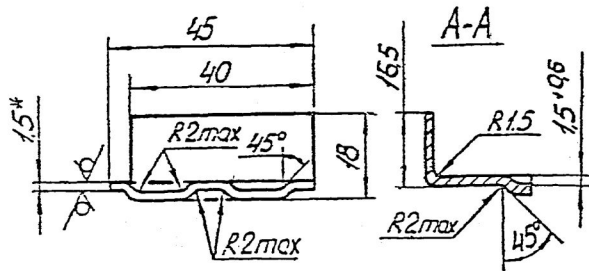


"COMMON TO T-90" & BLT
 DRG RE - INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NIL
 G. THIRUGANAM JT(01D)
 27-02-08

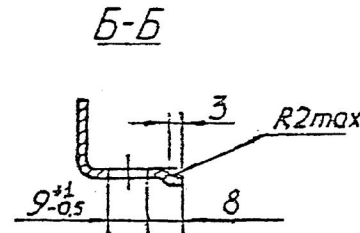
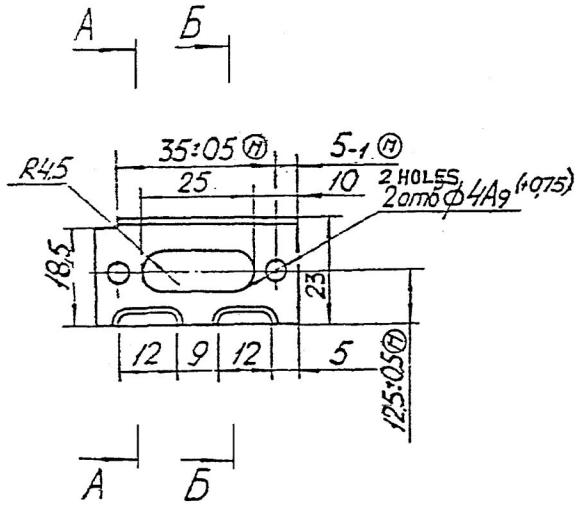
DRAWING NUMBER
172.02.853

SHEET No 1 OF 1

Rz 630
✓(✓)



1. ALTERNATE MATERIAL : SHEET $\frac{1.5 \text{ GOST } 19904 - 74}{4 - II - 15 \text{ GOST } 16523 - 70}$
2. * DIMENSIONS FOR REFERENCE.
3. UNSPECIFIED TOLERANCES FOR LINEAR DIMENSIONS $\pm 1 \text{ mm}$.
4. OTHER REQUIREMENTS ACCORDING TO 520 Ty 1 AND Ty 005216 - 75 (APPENDIX N1).



PILOT SAMPLE SHOULD BE APPROVED BY AASP BEFORE BULK PRODUCTION.

EST. WT. (Kg) TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
0.009

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

			DRN	Sd/=	MATERIAL:-	USED ON:-
			CHD	Sd/=	1.5 GOST 19904 - 74	172.02.224cbCb (A)
			APPD	Sd/=	5-II-Γ -10 Kn GOST 16523-70	
			DATE	30-06-88	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
			SCALE:- 1 : 1			
			DIMENSIONS IN mm		TITLE:-	
			TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69		FRAME	
			ALL THREADS TO CONFORM TO IS : 4218 Pt. IV		D S CAT NUMBER	DRAWING NUMBER
			A	14.12.04	N OF A No. CQA(HV)/T90/92/001.	172.02.853
			ISSUE	DATE	NATURE OF AMENDMENTS	

F - 2B
42

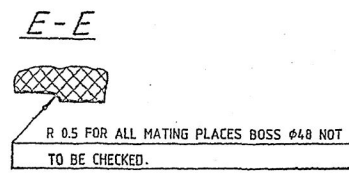
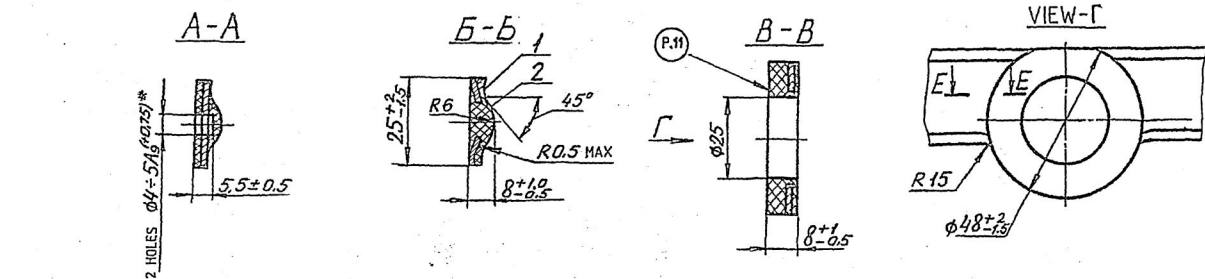
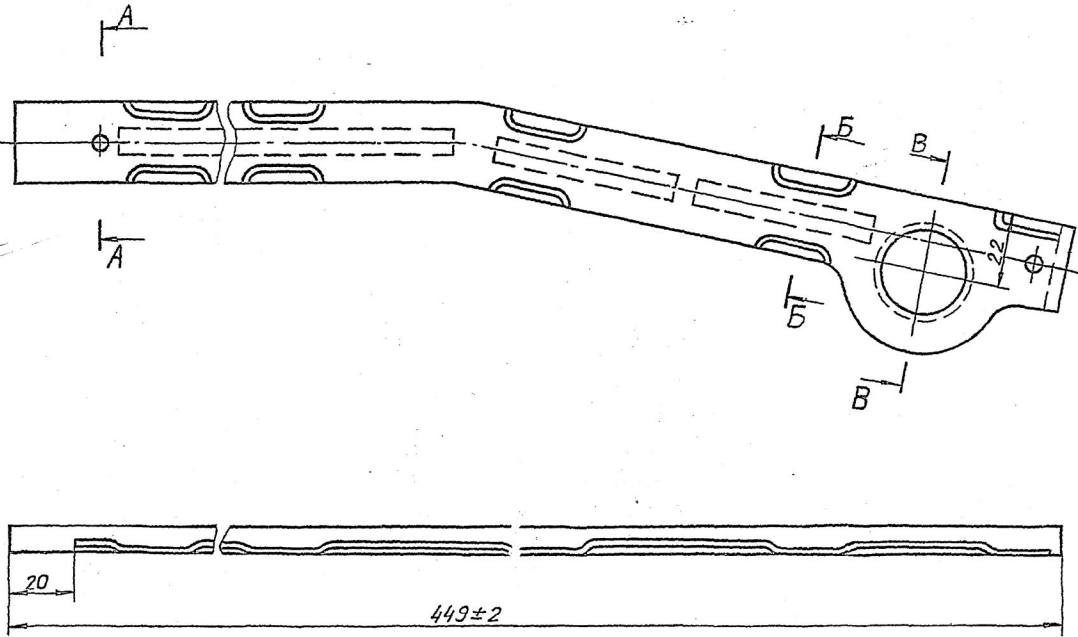
SIZE A3





DRAWING NUMBER
172.2M.02.014cbCb

SHEET No. 1 OF 1



1. COMPONENT (2) IS TO BE MANUFACTURED FROM RUBBER HO - 68 - 1 TY 005216 - 75.
2. RUBBER FILM IS ALLOWED ON NON RUBBERISED SURFACES.
3. MISMATCH SHIFT OF THE PRESS MOULD AXES NOT TO BE MORE THAN 1mm.
4. SURFACES OF STAMPED RECESSES ON BOTH SIDES OF THE COMPONENT OVER A LENGTH OF 10mm AND WIDTH 3mm, AS WELL AS ON THE EDGES OF PRESSINGS STAMPED RECESSES SHOULD BE FREE FROM RUBBER. DRESSING IS PERMITTED
5. ON THE SURFACES OF RUBBER LOCAL CAVITIES OF 4mm IN DIAMETER AND 1mm MAXIMUM IN DEPTH IN A QUANTITY OF NOT MORE THAN 4 PIECES ARE ALLOWED.
6. TECHNICAL REQUIREMENTS FOR ACCEPTANCE OF COMPONENT ARE IN ACCORDANCE WITH TY 005216 - 75, CODE 253161.
7. ROUNDING OFF OF CORNERS WITH A RADIUS OF 1mm MAX IS ALLOWED.
8. GASKET IS TO BE GLUED BY HOT METHOD (VULCANISING) USING GLUE "LEIKONAT" TY6 - 14 - 95 - 75.
9. IN THE AREA OF STAMPED RECESSES PEELING OF RUBBER TO A DEPTH OF 4mm IS ALLOWED.
10. * DIMENSIONS FOR REFERENCE.
11. MARK THE MANUFACTURER'S SYMBOL AND No. OF THE COMPONENT IN RAISED LETTERS TYPE 110-3 GOST 2930 - 62.

15-04-08
 (B) JAYAVELU, JTOID

COMMON TO T-90 " & BLT
 DRG. RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NII

F-13
 1
 SIZE A2

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

EST. WT. 0.200Kg.	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	Sd/=	MATERIAL:-	USED ON:- 172 02 002 Cb - 2Cb 188.02.002cbCb (A)
CHD	Sd/=		
APPD	Sd/=		
DATE	4.2.87	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
SCALE:- 1 : 1			
DIMENSIONS IN mm			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69			
ALL THREADS TO CONFORM TO			
A	4.8.03	N OF A No. CQA(HV)/T90/02/001.	
ISSUE	DATE	NATURE OF AMENDMENTS	

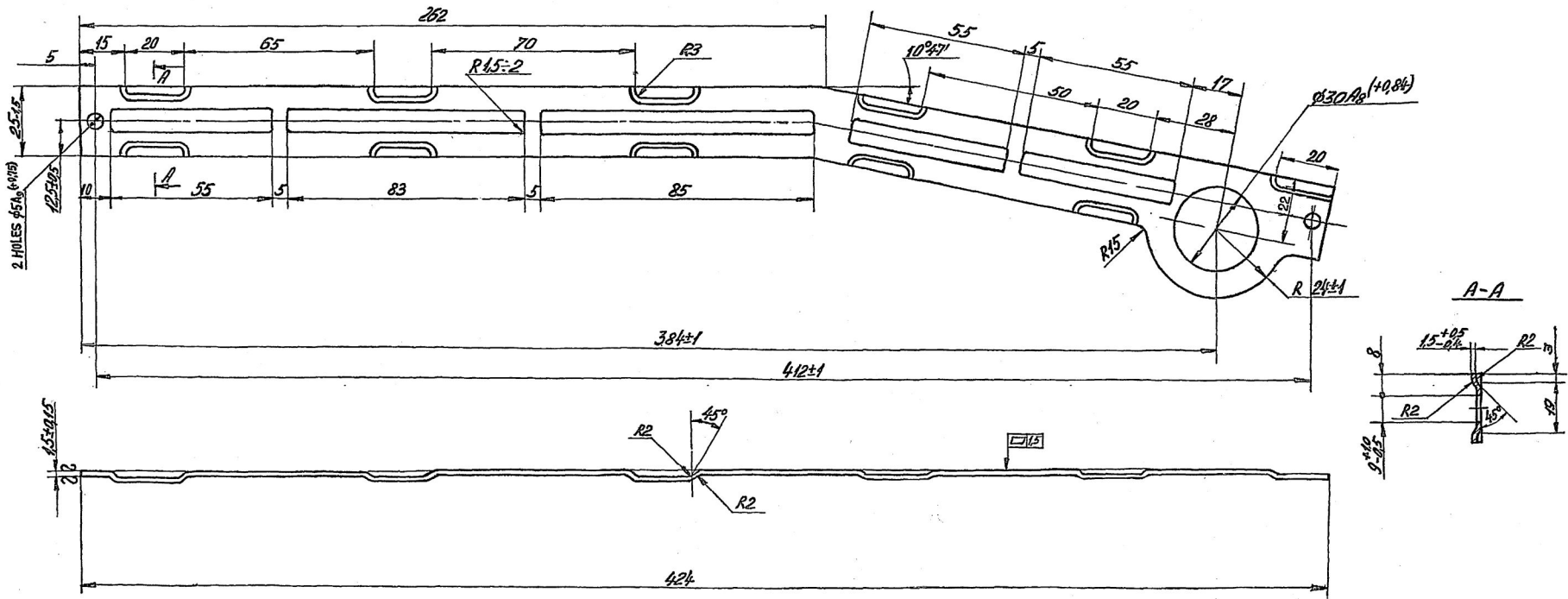
TITLE:- GASKET		D S CAT NUMBER	DRAWING NUMBER 172.2M.02.014cbCb
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DRAWING NUMBER
172.2M.02.029

SHEET No. 1 OF 1

UNLESS OTHERWISE SPECIFIED Rz320 ✓(✓)



EXPLANATORY NOTE:-

THE COMPONENT SHOULD BE PRODUCED FROM COLD ROLLED CARBON OPEN HEARTH STEEL SHEET OF STANDARD CHARACTERISTICS CATEGORY-'5', HIGH SURFACE FINISH-'II', DEEP DRAWN-'I' STEEL OF GRADE '10K1' (RIMMED) ALTERNATIVELY SUPERIOR FINISH-'III', DEEP DRAWN-'I' STEEL OF GRADE '10K1' TO GOST 16523-70.
CHEMICAL COMPOSITION :- % AS PER GOST 1050-74.

GRADE OF STEEL	C	Si(MAX)	Mn	Cr(MAX)
10K1	0.07-0.14	0.07	0.25-0.50	0.15

NOTE:-

a) CONTENTS OF SULPHUR 0.040% (MAX) & PHOSPHORUS 0.035% (MAX)
b) RESIDUAL CONTENTS OF COPPER & NICKEL SHOULD NOT EXCEED 0.25% EACH.
MECHANICAL PROPERTIES :- AS PER GOST 16523-70

GRADE OF STEEL	TENSILE STRENGTH Kgf/mm ²	RELATIVE ELONGATION NOT LESS THAN
10K1	28 - 40	25

1. MANUFACTURING FROM OPEN HEARTH STEEL 10 K115-III Γ GOST 16523-70 IS ALLOWED.
2. DEVIATIONS FOR DIMENSION WITH UNSPECIFIED TOLERANCES ±1.5mm.
3. SHRINKAGE OF EDGES ARE NOT TO BE CHECKED IN THE STAMPED PLACES.
4. CORRUGATION AND TOOL MARKS ARE ALLOWED ON THE COMPONENT SURFACE.
5. THE REST OF THE REQUIREMENTS ARE ACCORDING TO TY 005216-75 (APPENDIX 1).

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

EST. WT. 0.1002 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	Sd / =	MATERIAL:-	USED ON:-
CHD	Sd / =	OPEN HEARTH STEEL	172 2M 02 014 CbCb
APPD	Sd / =	10 K11-5-III GOST 16523-70	
DATE	4/2/87	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE:-	1 : 1	AVADI	
DIMENSIONS IN mm		TITLE:-	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69		FRAME	
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
ISSUE	DATE		172.2M.02.029
	NATURE OF AMENDMENTS		

COMMON TO T-90 & BLT
DRG. RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 5

F-16
40
SIZE A2



