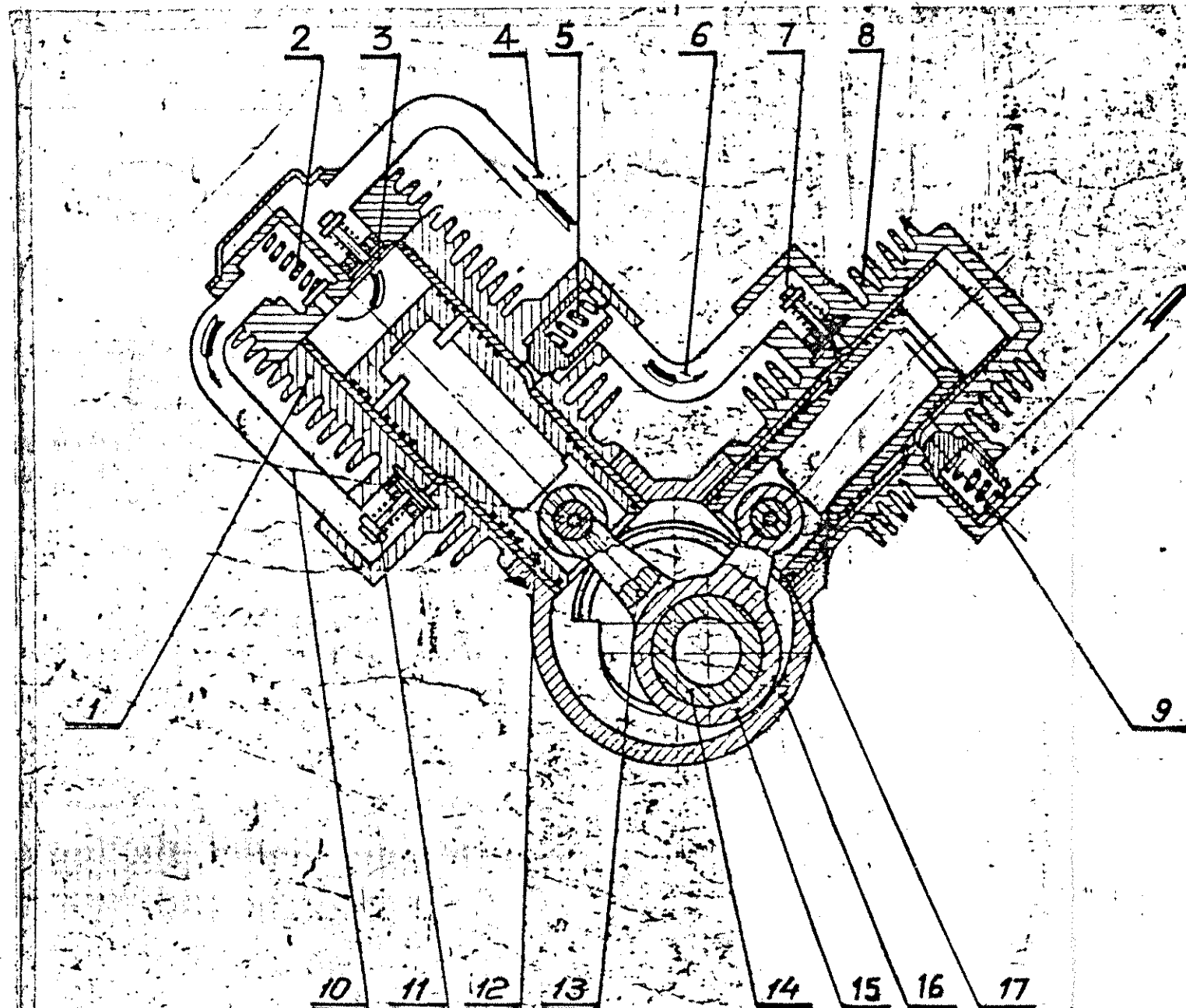


DRAWING NUMBER

AK 150M CX



17	PISTON 3rd STAGE	
16	CASE	
15	INSIDE CONNECTING ROD	
14	ECCENTRIC	
13	MASTER CONNECTING ROD	
12	PISTON, 1st AND 2nd STAGE	
11	SUCTION VALVE, 2nd STAGE	
10	PIPE	
9	DELIVERY VALVE, 3rd STAGE	
8	CYLINDER, 3rd STAGE	
7	SUCTION VALVE 3rd STAGE	
6	PIPE	
5	DELIVERY, VALVE 2nd STAGE	
4	SWIVEL ELBOW	
3	SUCTION VALVE 1st STAGE	
2	DELIVERY VALVE 1st STAGE	
1	CYLINDER, 1st AND 2nd STAGE	
REF. NO.	DESCRIPTION	REMARK

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

EST. MASS.

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.

DRN

CHD

TCD

APPD

DATE

SCALE

DIMENSIONS IN mm

TOLERANCE ON DIMNS

UNLESS OTHERWISE

STATED.

ALL THREADS

CONFORM TO

MATERIAL:-

USED ON:-

AK 150C - 01C5

CONTROLLERATE OF INSPECTION(HEAVY VEHICLES)
AVADI

TITLE: AVIATION COMPRESSOR
AK 150C WORKING
DIAGRAM

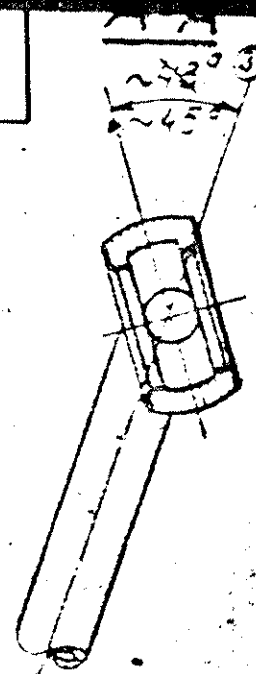
D S CAT. NUMBER

DRAWING NUMBER

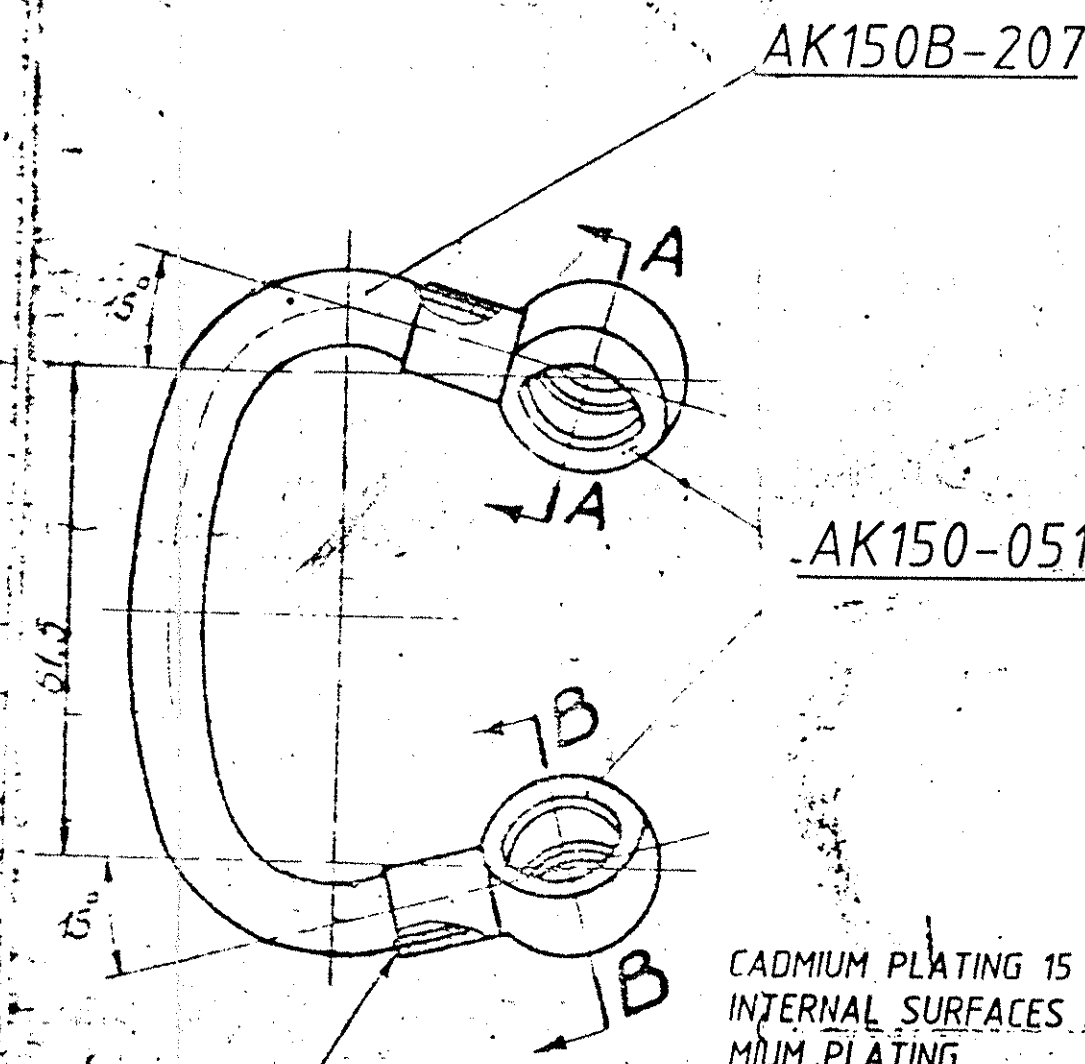
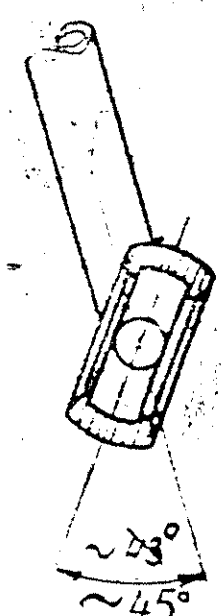
AK 150M CX

ISSUE	DATE	NATURE OF AMENDMENTS
8		
7		
6		

TOLERANCE ON FREE DIMENSIONS ARE AS PER
22-A-52 CLASS 7.



B-B



ADJUST CLEARANCE 0.05 TO
0.025 BEFORE USING SILVER
SOLDER.

CADMIUM PLATING 15 TO 21 MICRONS THICK
INTERNAL SURFACES MAY BE FREE OF CAD-
MIUM PLATING.

BRAZE ALL JOINTS WITH ncp 45 OR BRASS 762 OVER ENTIRE SURFACE
OF JOINT.

CARRYOUT PRESSURE TEST OF INTERNAL SURFACE WITH WATER AT
PRESSURE 45kg/cm². FOR 3 MINUTES.

CHECK AIR-TIGHTNESS OF SURFACE WITH AIR AT PRESSURE 30kg/cm²
SCALE AND OTHER FOREIGN BODIES ARE NOT ALLOWED ON INTERNAL
SURFACE.

MATCH POSITION OF UNION SURFACES AS PER MOCK-UP.

OVALITY AT BENDING RADII NOT EXCEEDING 15% IS ALLOWED DURING
ADJUSTEMENT IN ASSEMBLY.

KVD 74777

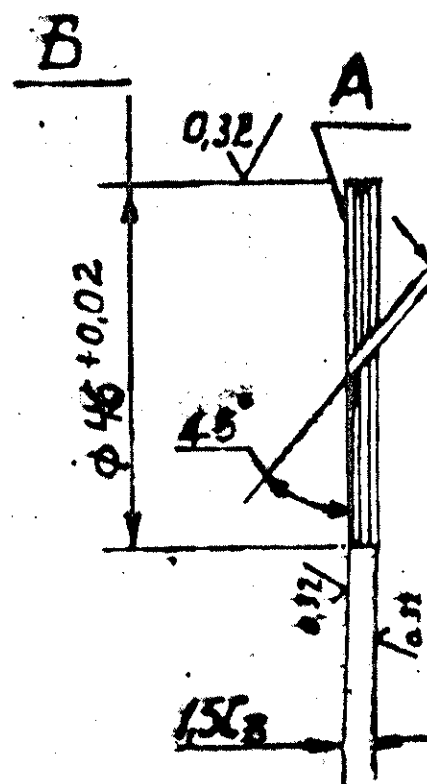
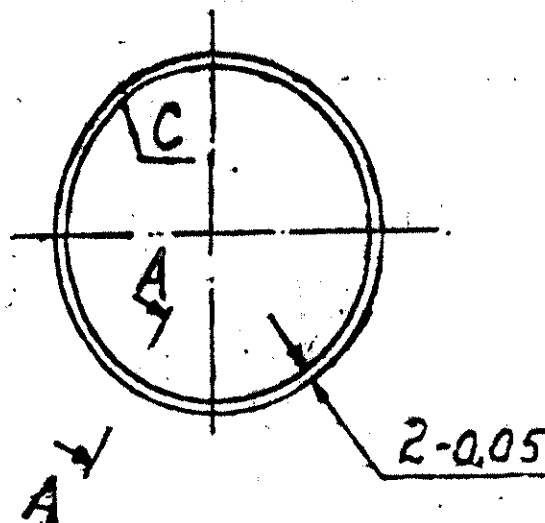
PILOT-SAMPLE SHOULD BE APPROVED BY A H S BEFORE BULK PRODUCTION

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS *
		66	(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	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL:-	USED ON:-
DRN CRR	SCALE - 1 : 1	—	AK 150C - 01C5
CHD [Signature]	DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD [Signature]	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE: PIPE ASSY.	
APPD [Signature]	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER AK150B - 59C5
DATE 22.7.86			

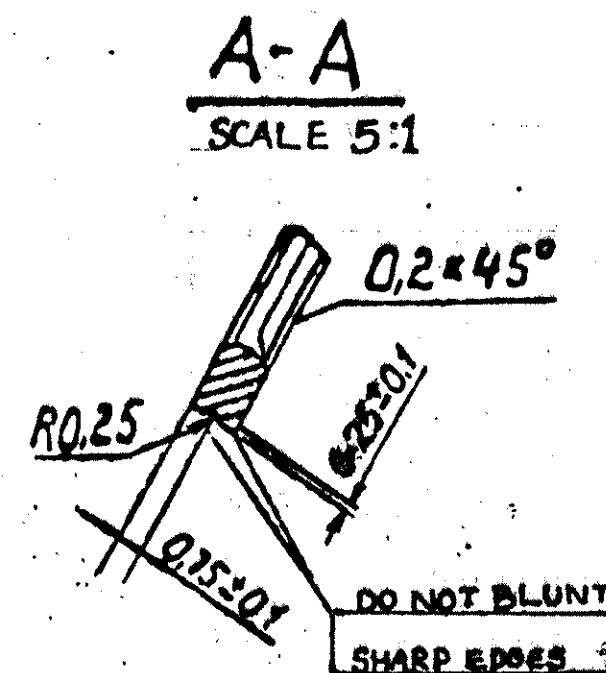
ah

SIZE A3

AK 150-017



CLEARANCE IN THE MACHINING
CONDITION 0.05 TO 0.12 IS
CHECKED IN RING GAUGE ϕB .
CLEARANCE IN FREE CONDITION,
MEASURED IN THE PLANE
PERPENDICULAR TO THE CUT
-4.4 TO 5.3.



GRIND PLANE 'A' AND SURFACE ϕB
DEVIATION FROM PARALLELITY OF PLANES SHOULD NOT EXCEED 0.01MM
ELASTICITY OF RING WHEN CHECKING CONCENTRATED LOAD, ON SUPPORT
AT ONE POINT, SHOULD CONFORM TO FORCE 1.5 TO 2.2 KG WHEN COMPRESSED
UPTO LOCK IN WORKING CONDITION.
CLEARANCE ALONG THE EXTERNAL DIAMETER SHOULD NOT EXCEED 0.01MM
ON TOTAL SECTOR 4.5°
OXIDISED FILM FROM HEAT TREATMENT IS ALLOWED ON SURFACE 'C'
FOR COMPRESSORS AK 150MB; 150MKB, MAB, MA2B, BB CHECK
THE RING ON PLANE IN SLOTTED GAUGE WIDTH OF SLOT - 15 ± 0.013
DEPTH ATLEAST 0.75 MM OF RING DIAMETER.
RING SHOULD PASS THROUGH GAUGE BY GRAVITY.

HB 241...285, CHECKING IS CARRIED OUT IN RING POTS AS PER INSTRUCTION NO. 8-53.

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

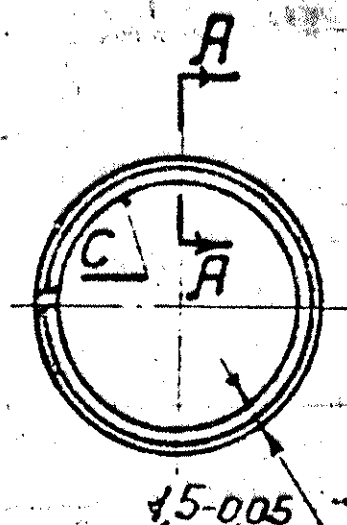
3

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.

			DRN	M. B. D.	MATERIAL:- CAST IRON	USED ON
			CHD	Chandee	XHB TO OST190106-73	AK150C-45C6
			TCD	T. B. D.		
			APPO	R. N. S.		
			DATE	18-12-92	CONTROLLERATE OF QUALITY ASSURANCE HEAVY VEHICLES	
			SCALE:-	1:1		AAVI.
			DIMENSIONS IN MM			
			TOLERANCE ON DRWS			
			UNLESS OTHERWISE			
			STATED IS :	2102-19		
			ALL THREADS TO			
			CONFORM TO			
A	10-12-92	D.O.CORRECT ON			D S CAT NUMBER	DRAWING NUMBER
ISSUE	DATE	NATURE OF AMENDMENTS				AK150-017

▽6 UNLESS OTHERWISE SPECIFIED.

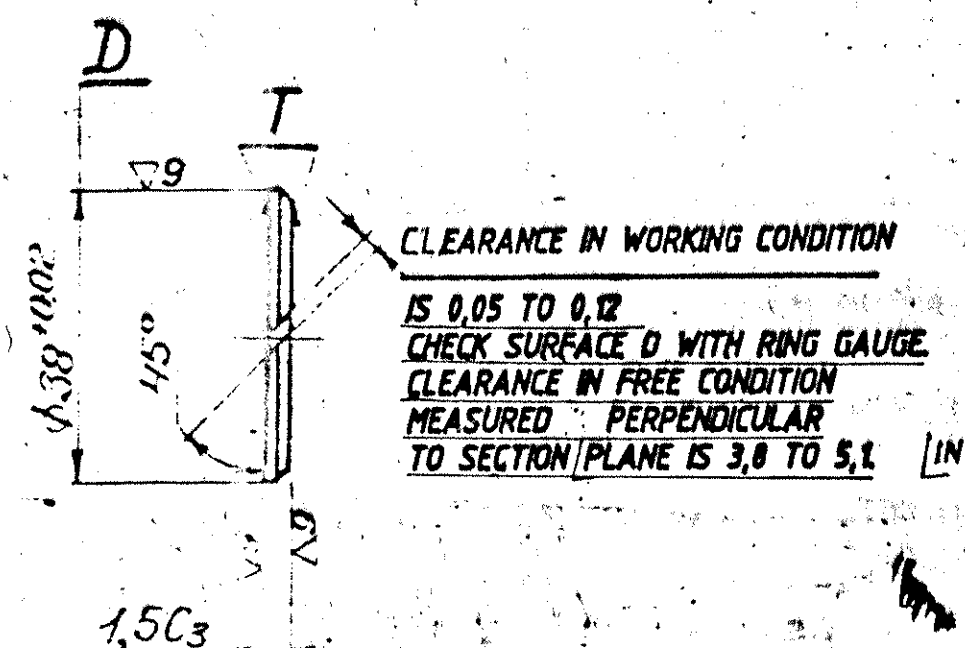


LAP SURFACES D AND T.
DEVIATION FROM PARALLELISM OF SURFACES SHOULD NOT EXCEED 0,01mm.
ELASTICITY OF RING WHILE CHECKING WITH CONCENTRATED LOAD
ON SUPPORT AT ONE POINT SHOULD CORRESPOND TO A FORCE OF
0,8 TO 1,3 kg. WHEN PRESSED TO THE JOINT IN WORKING CONDITION
CLEARANCE ALONG EXTERNAL DIA. SHOULD NOT EXCEED 0,01mm
ON TOTAL SECTOR OF 45°.

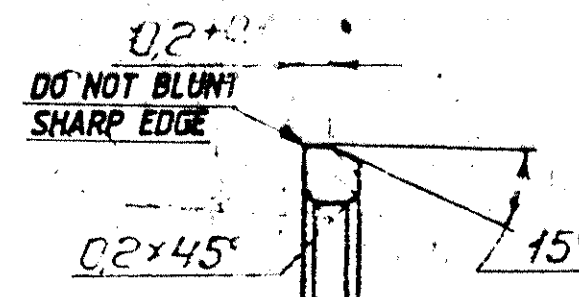
OXIDATION FILM CAUSED BY HEAT TREATMENT IS ALLOWED ON SURFACE C

CHECK THE RING FOR FLATNESS IN SLOTTED GAUGE :
WIDTH OF SLOT IS 1,5 $\begin{smallmatrix} +0,020 \\ -0,05 \end{smallmatrix}$ mm AND DEPTH IS NOT LESS THAN
0,75 OF RING DIAMETER.

RING SHOULD GO THROUGH GAUGE UNDER GRAVITY.



A-A
SCALE 5:1



HARDNESS HB 241 TO 285.
PERFORM CHECK IN RING POTS AS
PER INSTRUCTIONS No. 8-53.

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

EST. MASS. 1.7	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.	

			DRN	CPI	MATERIAL:- CAST IRON XHB	USED ON:
			CHD	Challachoy	OCT 190106-73	AK 150C-45 CB
			TCD	V. R. R.		AK 150H-32 CB
			APPD		CONTROLLERATE OF INSPECTION(HEAVY VEHICLES)	
			DATE	22.7.86	AVADI	
			SCALE	- 1:1		
			DIMENSIONS IN mm			
			TOLERANCE ON DIMS			
			UNLESS OTHERWISE			
			STATED.			
			ALL THREADS			
			CONFORM TO			
					D S CAT NUMBER	DRAWING NUMBER
						AK150-022
ISSUE	DATE	NATURE OF AMENDMENTS				

DRAWING NUMBER
AK 150 - 071

▽6 UNLESS SPECIFIED OTHERWISE



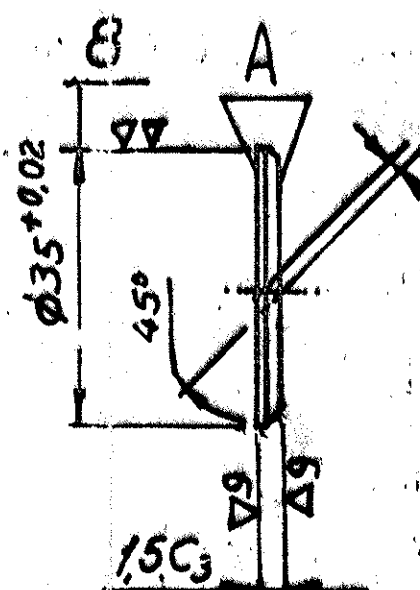
LAP PLANE A AND SURFACE ϕ B. DEVIATIONS OF PLANES FROM PARALLELISM SHOULD NOT EXCEED 0.01.
ELASTICITY OF RING, WHILE CHECKING WITH A CONCENTRATED LOAD, ON SUPPORT AT ONE POINT, SHOULD CORRESPOND TO A FORCE OF 1 TO 1.5 kg WHEN IT IS PRESSED AGAINST LOCK IN WORKING CONDITION.

CLEARANCE OVER EXTERNAL DIAMETER SHOULD NOT EXCEED 0.01 AT A TOTAL SECTOR OF 45°.

OXIDE FILM IS ALLOWED ON SURFACE C, DUE TO HEAT TREATMENT. CHECK RING FOR PLANENESS IN SLOTTED GAUGE.

WIDTH OF SLOT IS $15^{+0.020}_{+0.015}$. DEPTH IS NOT LESS THAN 0.75 OF RING DIAMETER.

RING SHOULD GO THROUGH GAUGE UNDER ITS WEIGHT.



CLEARANCE IN WORKING CONDITION 0.05 TO 0.12
CHECK IN RING GAUGE ϕ B CLEARANCE IN FREE STATE, MEASURED IN PLANE PERPENDICULAR TO CUT IS 3.5 TO 4.9.

A-1
SCALE 5:1

DO NOT
BLUNT SHARP
EDGE

92 x 45°

72 ± 0.1

15°

HARDNESS HB IS 241 TO 285. CARRY-OUT CHECKING IN RING POTS AS PER INSTRUCTION No. 8-53.

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

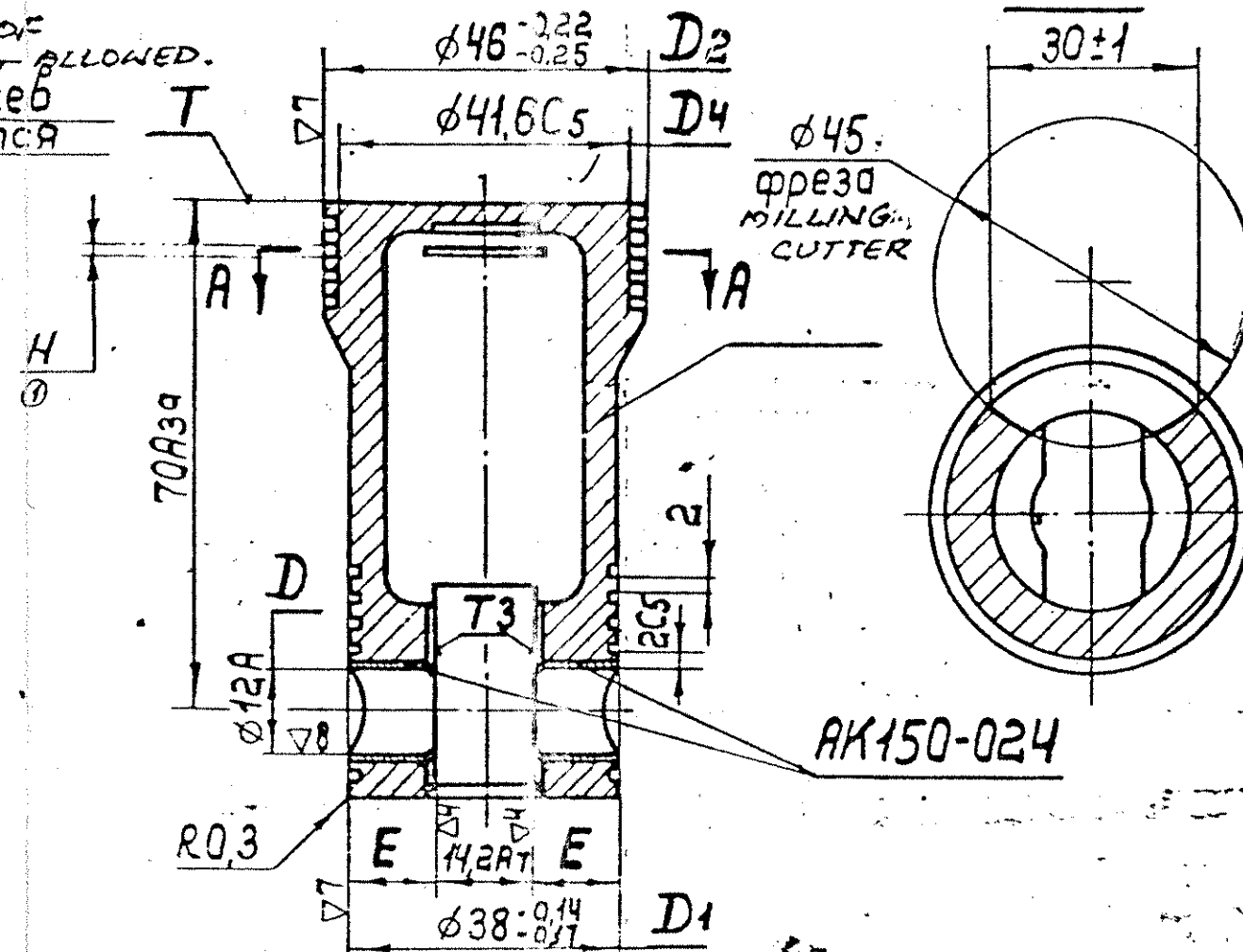
EST. MASS.	1.5	TO BE STAMPED OR MARKED WITH INDICATED THUS *	LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.			
MATERIAL:- CAST IRON X HBAM DST 1 90106 -73		USED ON:- AK 150H 32 CE	
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI			
TITLE: OIL CONTROL RING		D S C/T NUMBER	
DATE 22/7/86		DRAWING NUMBER AK 150 - 071	

[illegible]

CUTTING IN OF
FACES IS NOT ALLOWED.
Зарез торцев Т
не допускается

РД, не более
для всех FOR ALL
канавок GROOVES

DIMENSIONS AS PER 22 AT 52



AK150-024

1. DURING UNIT ASSEMBLY, SELECT COMPONENTS AK150-024 AND AK 150C-104 OF THE SAME GROUP.
2. CHECK SURFACE K BY BLUEING WITH THE HELP OF GAUGE. THE IMPRINT SHOULD COVER ATLEAST 75% OF SURFACE K.
3. GROOVE 1mm, MAX. WIDE AND TO 0.1mm DEEP IS ALLOWED ON SURFACE D1 NEAR THE CONE.
4. DIFFERENCE IN DIMENSIONS E SHOULD NOT EXCEED 0.1.
5. DIMENSION A IS ACTUAL FOR ALL CIRCULAR GROOVES.
6. VARIATION IN WALL THICKNESS OF BUSHING AK150-024 SHOULD NOT EXCEED 0.3.
7. RUN OUT OF SURFACE D1 RELATIVE TO D2 SHOULD NOT EXCEED 0.02.
8. RUN OUT OF SURFACE D1 RELATIVE TO D2 AND SURFACE D3 RELATIVE TO D1 SHOULD NOT EXCEED 0.03.
9. RUN OUT OF SURFACE T RELATIVE TO SURFACE D2 SHOULD NOT EXCEED 0.05.
10. NON SQUARENESS OF SURFACE T3 RELATIVE TO D SHOULD NOT EXCEED 0.1.
11. NON SQUARENESS OF SURFACE D TO D1 SHOULD NOT EXCEED 0.03 ON A LENGTH OF 40.
12. NON FLATNESS OF SURFACE T SHOULD NOT EXCEED 0.03.
13. MISALIGNMENT OF AXIS ϕD RELATIVE TO AXIS $\phi D1$ SHOULD NOT EXCEED 0.05.
14. NON SQUARENESS OF SURFACES T1 AND T2 RELATIVE TO D1 AND D2 SHOULD NOT EXCEED 0.03 ON A LENGTH OF 20.
15. DO NOT BLUNT SHARP EDGES IN GROOVES ALONG THE OUTER SURFACES. WIDTH OF GROOVE "H" MAY BE INCREASED BY 0.01mm.
16. SURFACE D1 MAY BE GRAPHITIZED ALONG THE LENGTH 1 AND 2 ACCORDING TO THE FACTORY TECHNOLOGY.

104

%

EST. MASS		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		OUTSIDE R	
ISSUE DATE		NATURE OF AMENDMENTS	
DRN	CPR	SCALE - 1:1	MATERIAL:-
		USED ON:- AK150C-45CB	
(CMT) <i>attach</i>		DIMENSIONS IN mm.	
TOL		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	
TITLE:-		PISTON WITH BUSH ASSY	
D S CAT NUMBER		DRAWING NUMBER	
7.5		AK150C-100-C5	

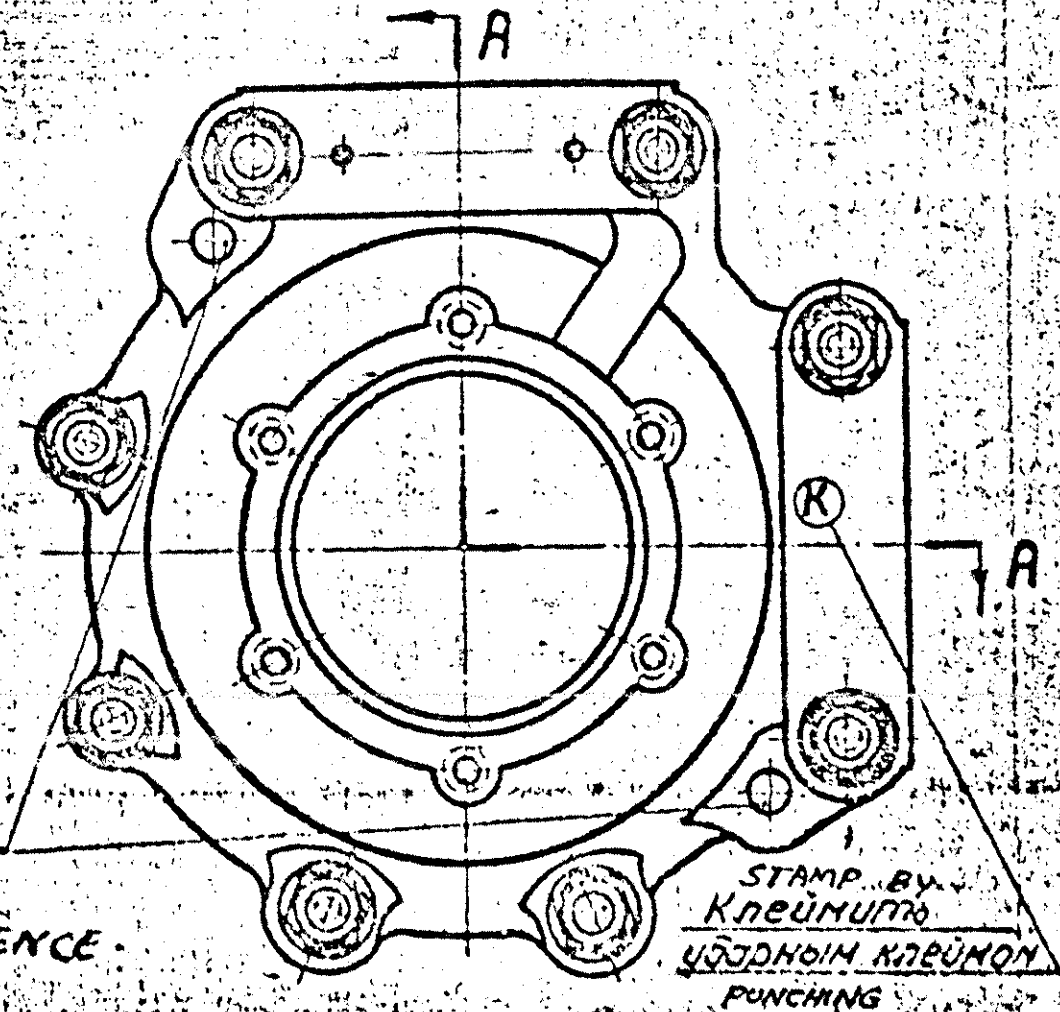
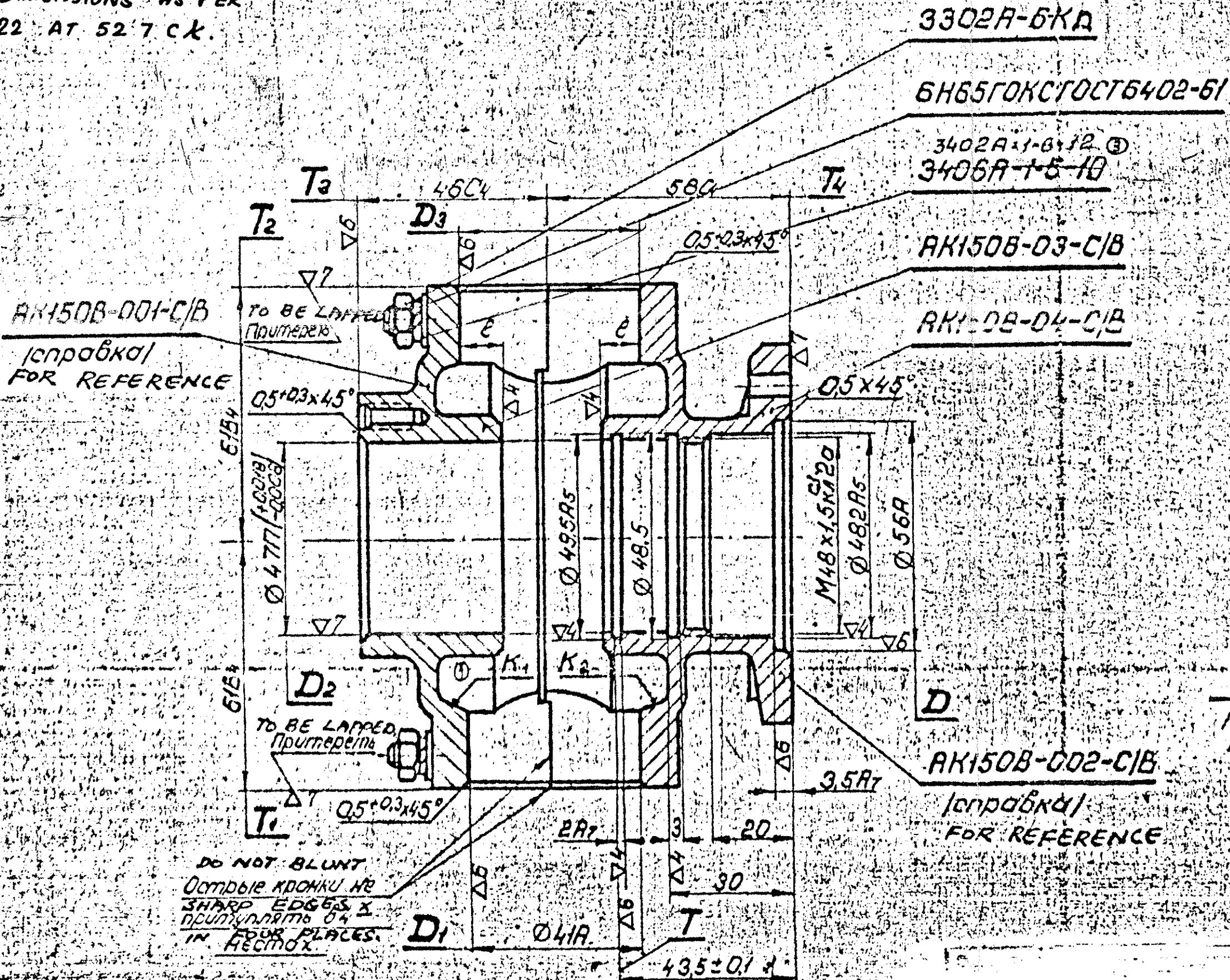
3

DRAWING NUMBER
AK 150 B-02-C/B C5

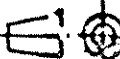
A-A

DIMENSION	DIMENSION	UNIT NO.	INCORPORATED UNITS	INCORPORATED COMPONENTS
Ø41A	8 +0.2 -0.1	AK150B-02-C	AK150B-03-C AK150B-04-C	AK150B-001-C AK150B-002-C

TOLERANCES ON FREE
DIMENSIONS AS PER
22 AT 52.7 Ck.

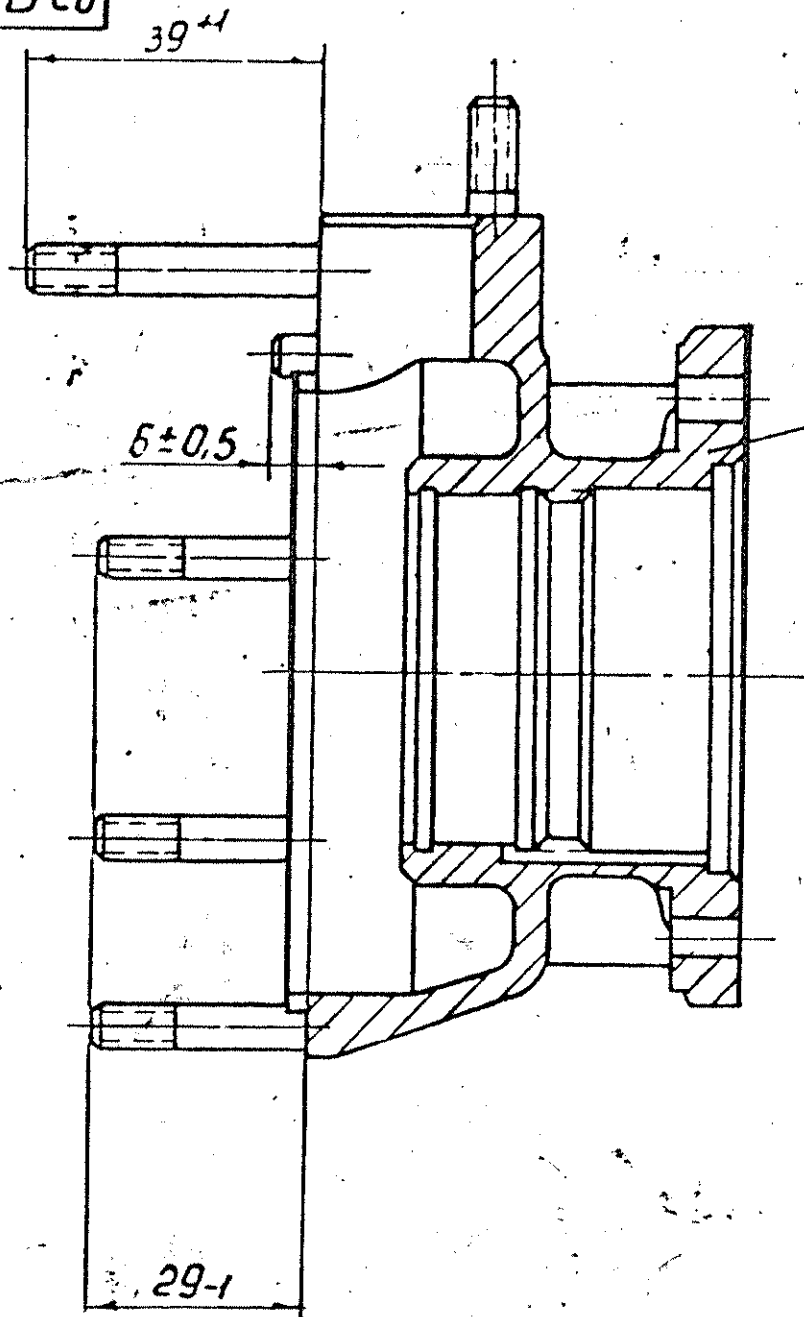


1. RUN OUT OF SURFACE T RELATIVE TO D₂ SHOULD NOT EXCEED 0.08.
2. RUN OUT OF SURFACES T₅, T₄ AND D RELATIVE TO D₂ SHOULD NOT EXCEED 0.03.
3. NON SQUARENESS OF SURFACES T₁ AND T₂ RELATIVE TO D₁ AND D₂ SHOULD NOT EXCEED 0.05 ON A LENGTH OF 50.
4. MISALIGNMENT OF THE AXIS OF HOLES D₁ AND D₃ RELATIVE TO THE AXIS OF HOLE D₂ SHOULD NOT EXCEED 0.2
5. OVALITY AND TAPER OF SURFACE D₂ SHOULD NOT EXCEED 0.013.
6. NON SQUARENESS OF SURFACES T₁ AND T₂ RELATIVE TO SURFACE D₂ SHOULD NOT EXCEED 0.05 ON A LENGTH OF 50.
7. CHECK NON FLATNESS OF SURFACES T₁ AND T₂ BY BLUEING ON PLATE. IMPRINT SHOULD COVER ATLEAST 75% OF THE SURFACE.
8. ASSEMBLE UNIT WITH COMPONENTS AK150B-001-C/B; AK 150B-002 C/B AND ϕ H5 - 038 OF THE SAME GROUP.
9. RUN OUT OF THE CRANKCASE FRONT AND REAR PARTS RELATIVE TO CORRESPONDING TAPER SURFACES K1 AND K2 SHOULD NOT EXCEED 0.15 (TO BE ENSURED TECHNOLOGICALLY)

PLOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.			
		EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THUS *
		958	1 LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE DATE	NATURE OF AMENDMENTS		
DRN <i>Am</i>	SCALE:- 1:1		MATERIAL:-
CRD <i>Chattack</i>	DIMENSIONS IN mm		USED ON:-
TCD <i>Be...</i>	TOLERANCE ON DIMS UNLESS OTHERWISE STATED		AK 150 B - 01 C6
APPD <i>ps</i>	ALL THREADS CONFORM TO		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVA
DATE	22.7.96		 TITLE: CRANK CASE ASSY [UNIT OF MACHINING OF BOTH PARTS TOGETHER]
		D S LAT NUMBER	DRAWING NUMBER
			AK150B-02-C/B C6

DRAWING NUMBER
AK150B-04-C/B C6

K4146



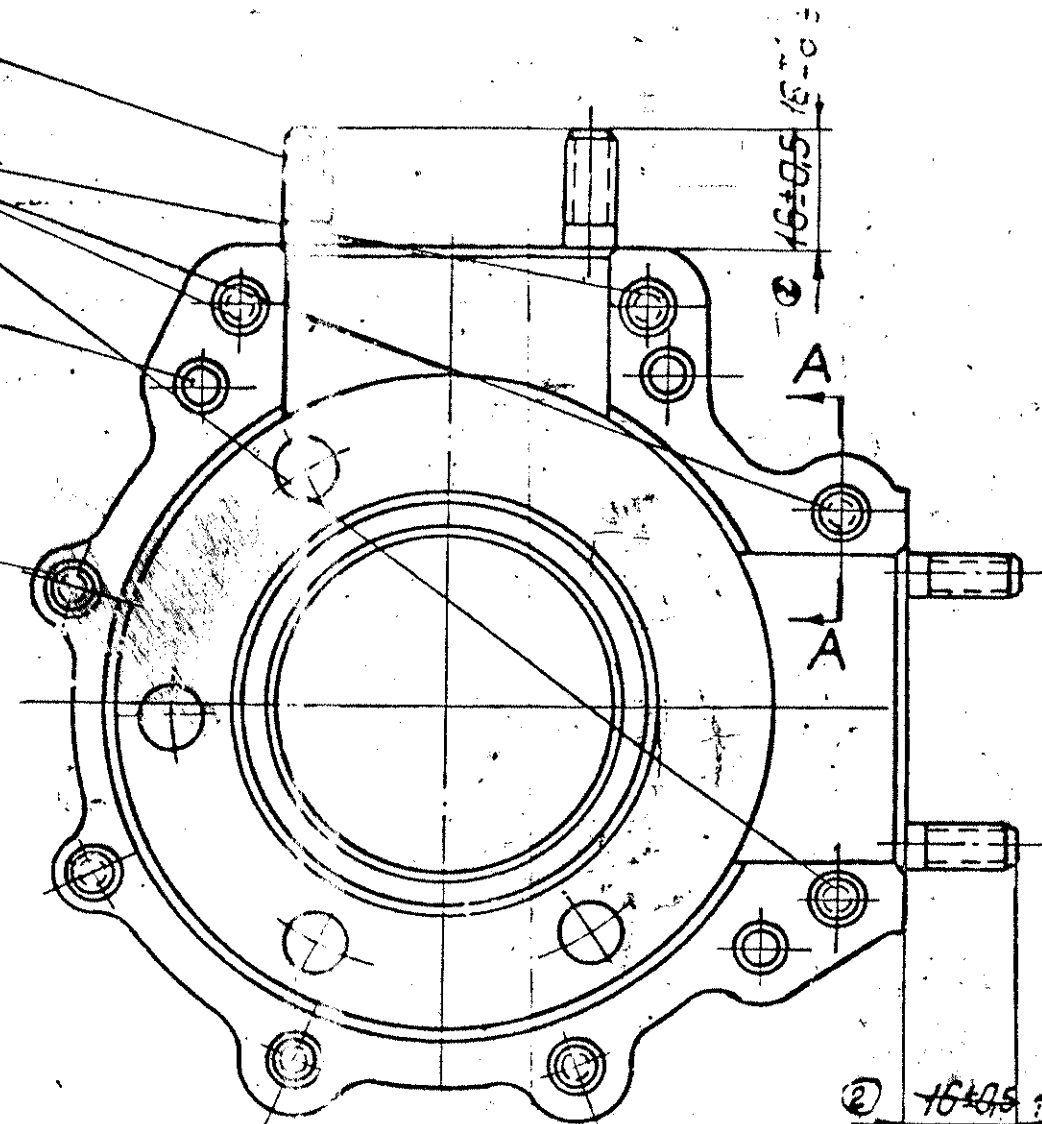
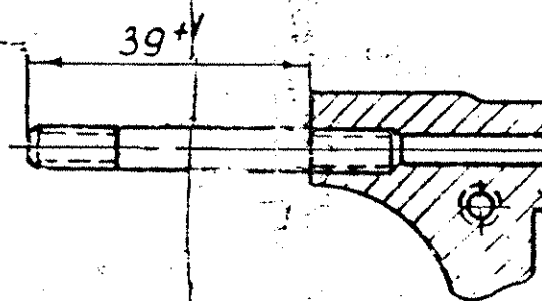
3251A-6-52

PH5-038

AK150B-002-C/B

3251A-6-42

A-A



* CRANK CASE [rear part]

COMPONENT N детали NUMBER	Входим в узел ASSEMBLY
AK150B-002-C	AK150B-04-C

Детали 3251A-6-42 и 3251A-6-52 являются в узле
AK150B-002-C/B на карбюраторном двигателе.
При сборке детали AK150B-002-C/B и PH5-038
подбирать одной группы.
During assembly, select components AK150B-002-C/B
and PH5-038 of the same group.

PILOT SAMPLE SHOULD BE APPROVED BY A.H.S.P. BEFORE BULK PRODUCTION	
EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS (LETTERS)
540	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENT
DRN	SCALE - 1:1
END	DIMENSIONS IN MM
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED
APPL	ALL DIMENSIONS IN MM
DATE	
22-7-96	
CONTROL RATE OF INSPECTION HEAVY VEHICLE SI AVAIL	
CRANK CASE ASSY [REAR PART]	
DRAWING NUMBER	
AK150B-04-C/B C6	

DRAWING NUMBER

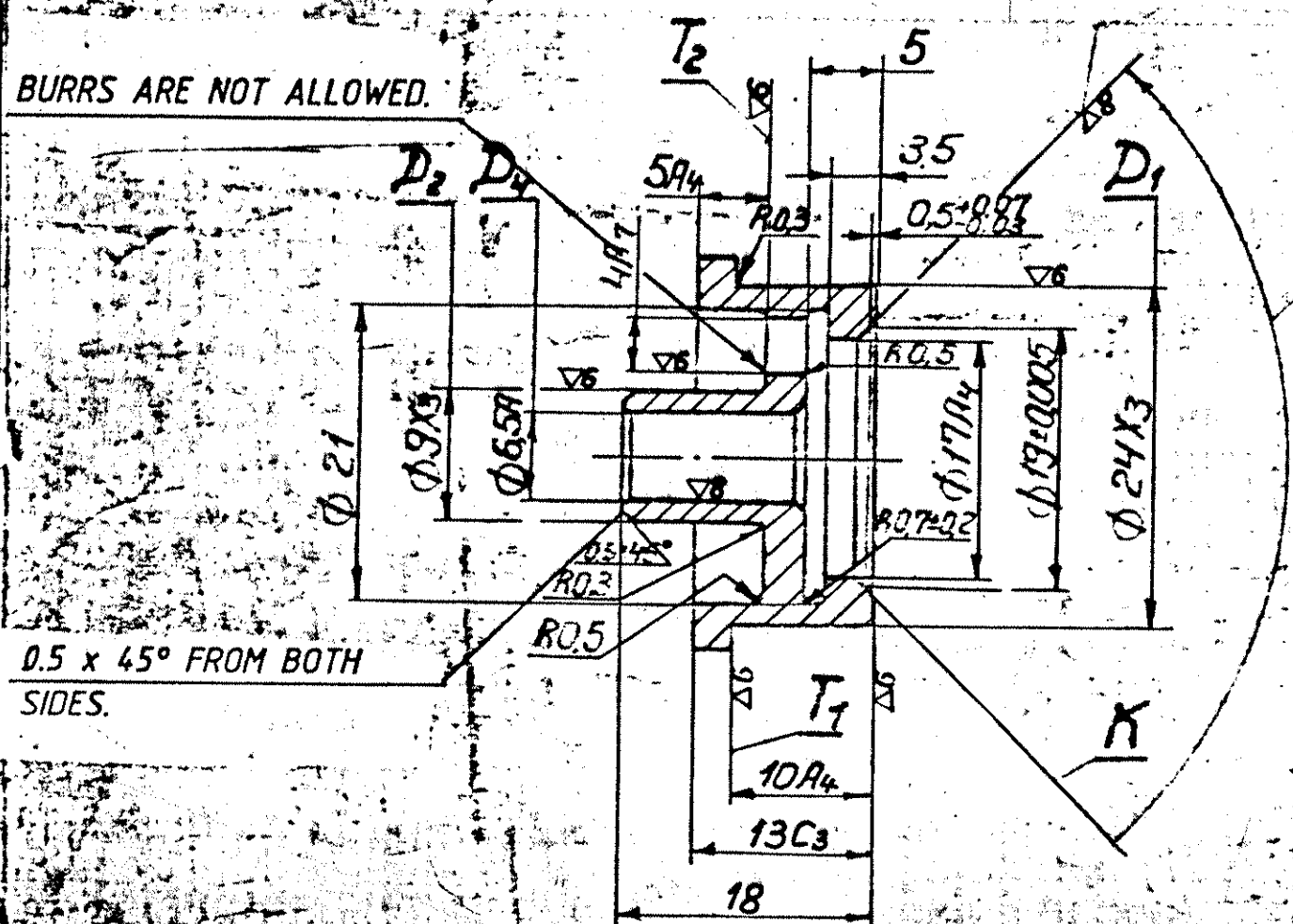
AK 150B -110

▽ 4 UNLESS OTHERWISE SPECIFIED

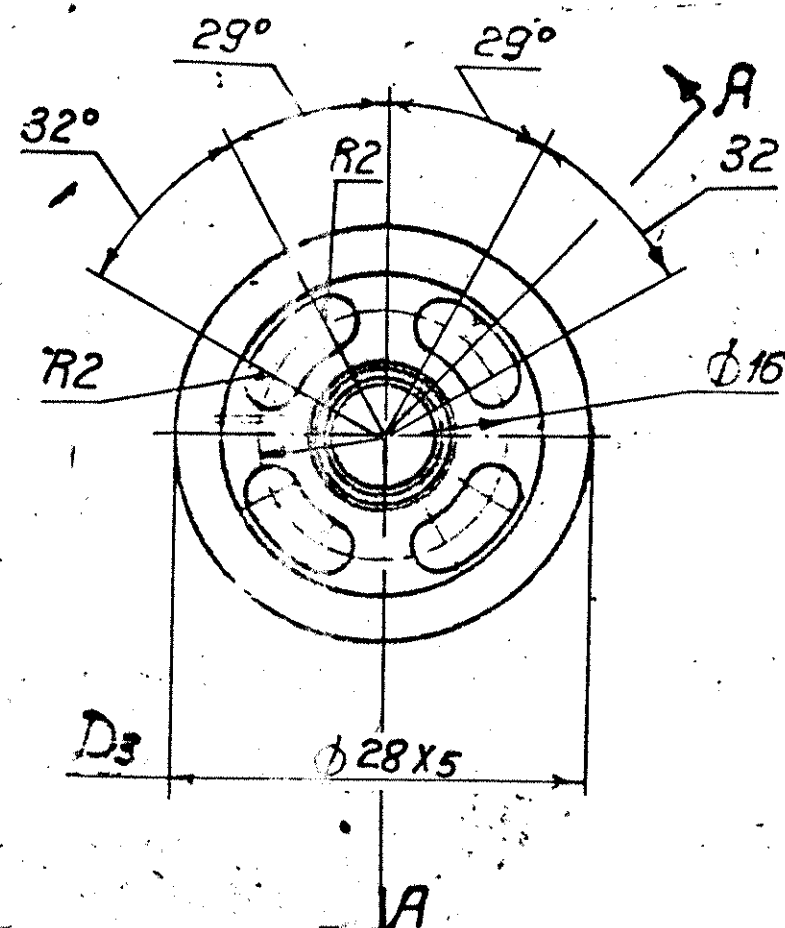
TOLERANCE ON FREE DIMENSIONS
ARE AS PER 22 AT 52-CL 7.A-A

LAP IN UNIT AK150B-21.

BURRS ARE NOT ALLOWED.



30°±30'



CHECK RUN-OUT OF SURFACE K WITH RESPECT TO SURFACE D₁ BY BLUEING: CLOSE FIT AS PER GAUGE SHOULD NOT BE LESS THAN 75% WITHOUT BREAK IN IMPRINT CIRCLE.

RUN-OUT OF SURFACE D₁, D₂, D₃, T₁ AND T₂ (T₂ UPTO Ø14) WITH RESPECT TO SURFACE D₁ SHOULD NOT EXCEED 0.1 MM.

BLUNT SHARP EDGES WITH R 0.1 MM.

MATCH SURFACE K TO SURFACE K OF VALVE AK 150B-213, SO THAT PROJECTION OF VALVE BEYOND BUTT-END OF SADDLE SHOULD NOT EXCEED 0.15 MM, AND DEPRESSION SHOULD NOT EXCEED 0.05 MM.

ALT. MATL.

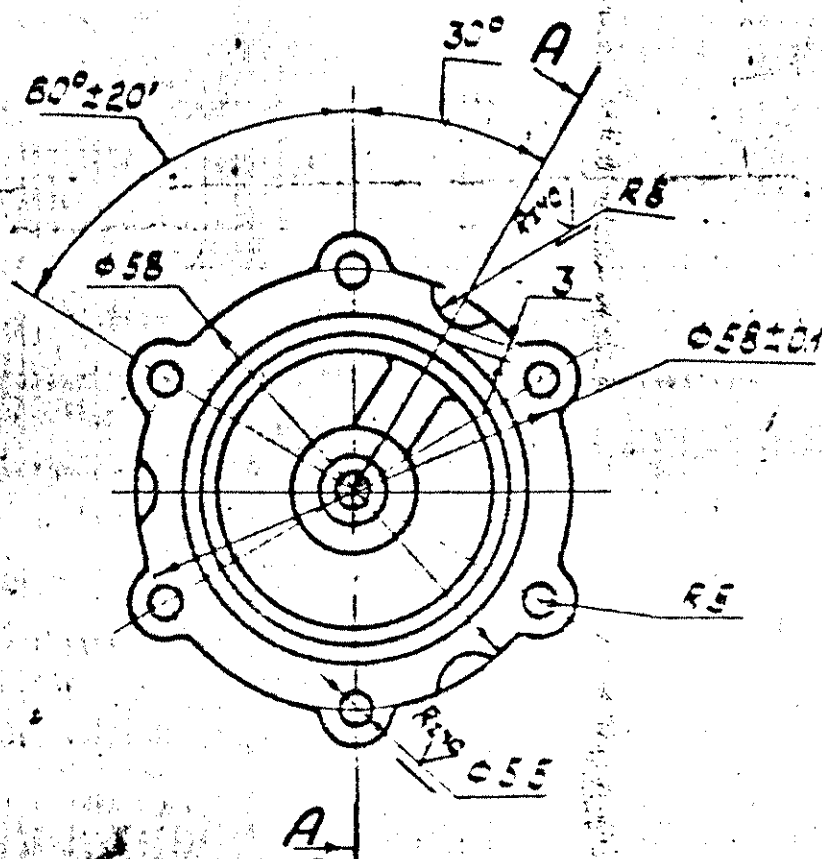
CU AND CU ALLOY GDE CA104
TO BS: 2874-86.

HARDNESS HB = 200 TO 240.

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

			EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THUS *	
			23	LETTERS)	
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL:-		USED ON:-
1	2.7.86	SCALE - 2:1	BRONZE 6PA * H10-4-4		AK 150B 060 65
2		DIMENSIONS IN mm	GOST 1628-72		
3		TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	CONTROLLER OF INSPECTION (HEAVY VEHICLES) AVADI		
4				TITLE:	SEAT
5		ALL THREADS CONFORM TO	D S CAT NUMBER		DRAWING NUMBER
6					AK 150B - 110

AK150B-003



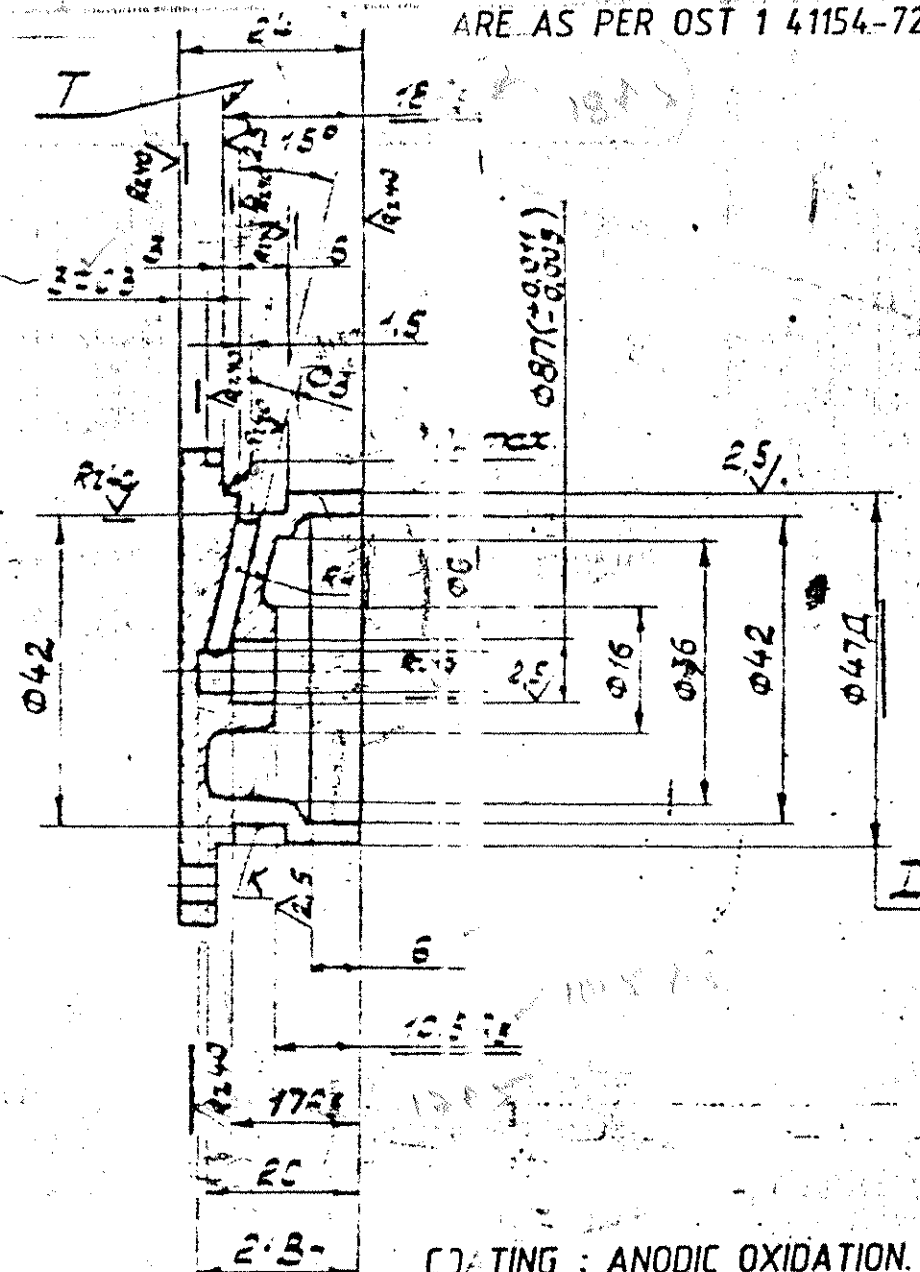
1. INSPECTION GROUP II IS USED FOR CHECKING CASTING.
2. PROVIDE DIMENSIONS WHICH ARE UNDERLINED IN UNIT AK150B-05.
3. RUN-OUT OF SURFACE T WITH RESPECT TO SURFACE D SHOULD NOT EXCEED 0.05 mm.
4. PROVIDE ALL UNSPECIFIED RADIUS CHANGES IN CASTING WITH R3.
5. PART MAY BE MADE OF ALUMINIUM ALLOY A19; OST.1 90021-79, BY PRESSURE-DIE CASTING, ACCURACY CLASS Am 2. IN THIS CASE, SURFACES, WHOSE SURFACE FINISH SYMBOLS ARE UNDERLINED, MAY BE MADE IN CASTING WITH SURFACE FINISH.

A-A

UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS PER 22 AT 52 CLASS 7.

✓ (✓)

LIMIT DEVIATIONS OF DIMENSIONS OF CASTING ARE AS PER OST 1 41154-72 AT-4.



CASTING : ANODIC OXIDATION. CHROMATIZED. ABSENCE OF COATING IS ALLOWED ON SURFACES, TO BE MACHINED IN UNIT AND IN GROOVE K.

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

ISSUE	DATE	NATURE OF AMENDMENTS	EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THUS *
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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:- ALUMINIUM
ALLOY A19 OST 190021-79

USED ON:- AK150B 05 CB

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI

TITLE: COVER

D S CAT NUMBER

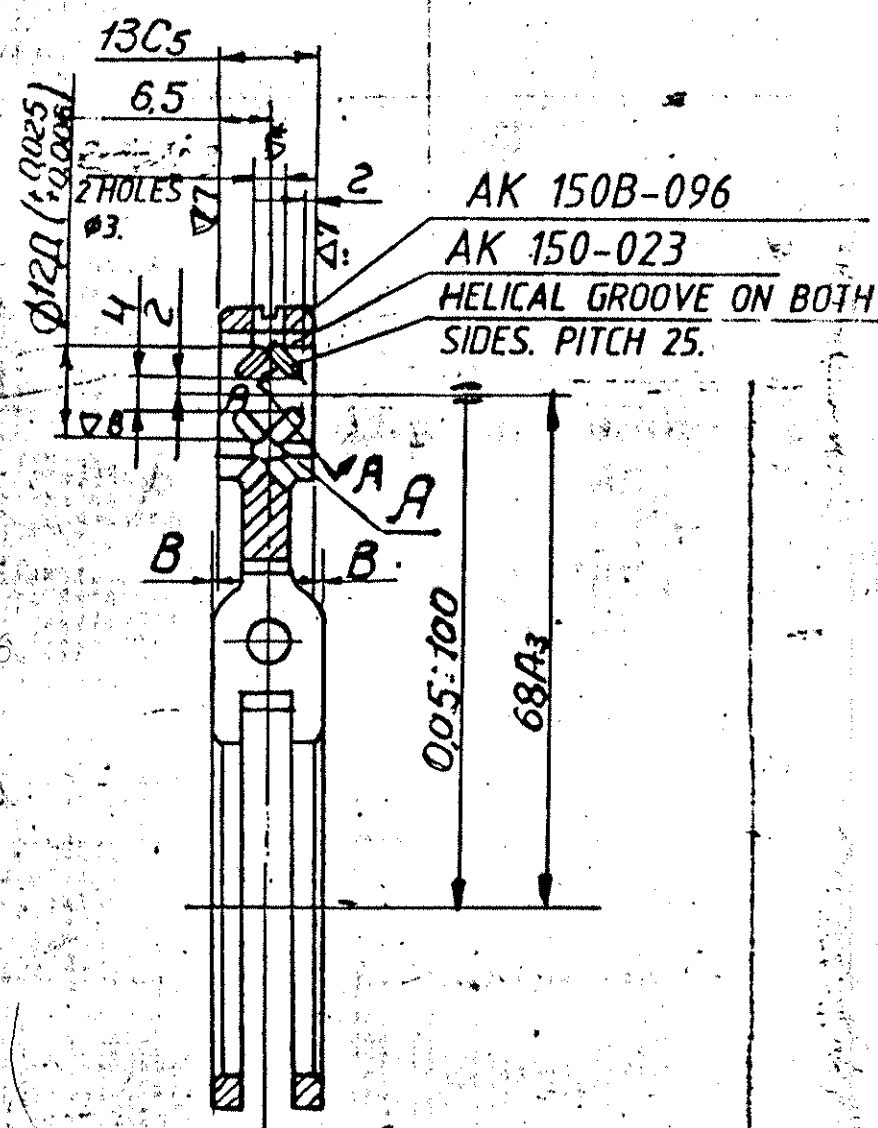
DRAWING NUMBER

AK150B-003

DRAWING NUMBER
AK 150B-10C6

▽ 4 UNLESS SPECIFIED OTHERWISE.

TOLERANCE ON FREE DIMENSIONS
ARE AS PER 22AT52 - CLASS 7.



A-A

SCALE 5:1

RQ5

Q4

1

Q5 Q2

ALIGN AXES OF OIL HOLES A DURING PRESS FITTING OF PART AK15
AK 150-023 INTO PART AK 150B-096.

DIFFERENCE OF DIMENSIONS B" SHOULD NOT EXCEED 0.1.

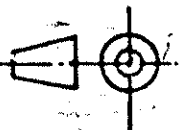
KVO. 74750

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

EST. MASS.
103

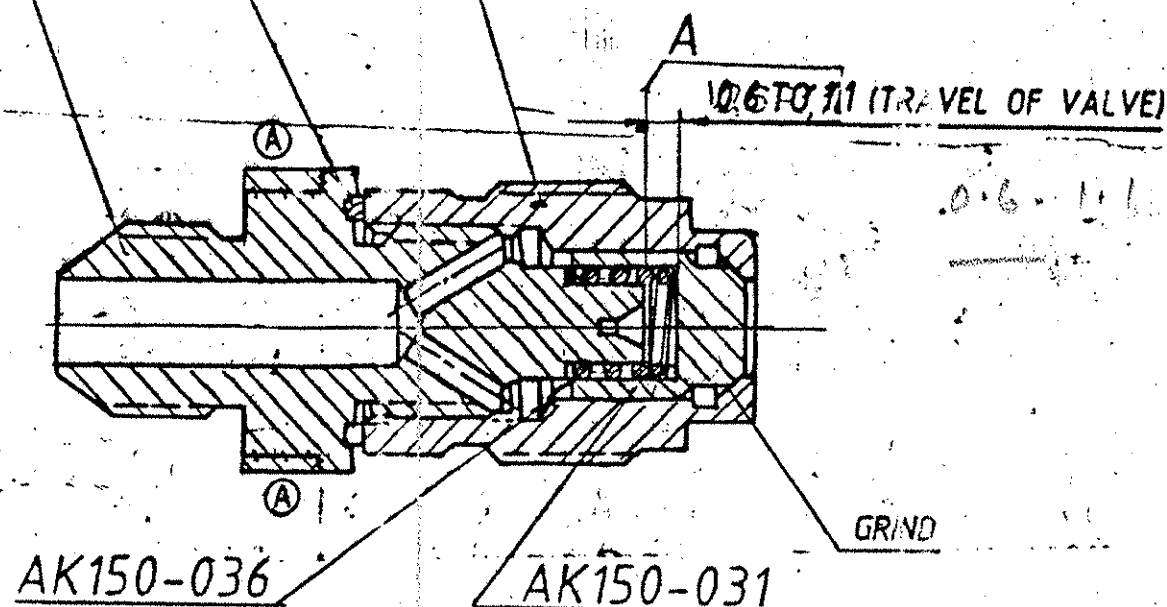
TO BE STAMPED OR MARKED WHERE
INDICATED THUS #
(LETTERS)

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

			DRN	CP	✓	MATERIAL:-	USED ON: AK 150H-38CB
			CHD	Bhattacharya			
			TCD	S. S. S. S.			
			APPD	K. M.			
			DATE	22.7.86.			
			SCALE - 1:1			CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI	
			DIMENSIONS IN mm				
			TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.				TITLE: MASTER CONNECTING ROD ASSY.
			ALL THREADS CONFORM TO				
ISSUE	DATE	NATURE OF AMENDMENTS				D S CAT NUMBER	DRAWING NUMBER AK 150B-10CB

+ 0.240

AK150B-130 AK150B-134 AK150B-135



FILLING OF PLANE A IS ALLOWED. CHECK AIR-TIGHTNESS OF VALVE FINALLY IN UNIT AK150B-35 AT AIR PRESSURE 10kg/cm².

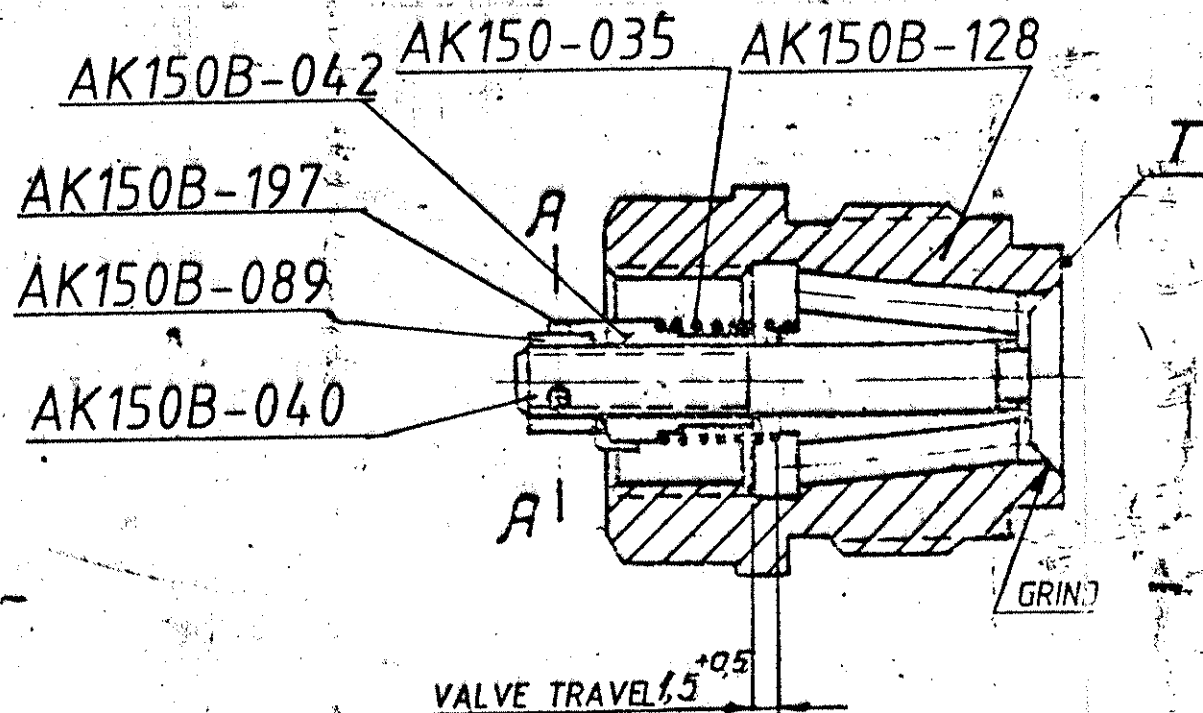
AIR LEAKAGE NOT EXCEEDING 80 BUBBLES PER MINUTE IS ALLOWED.

CHECK ONLY DURING ASSEMBLY.

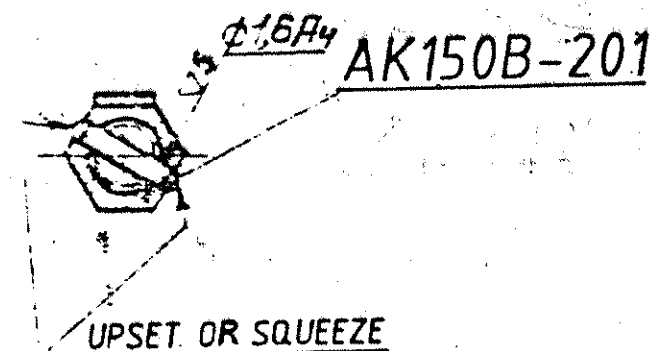
CHECKING OF AIR-TIGHTNESS MAY BE PERFORMED ON SPECIAL DEVICE AS PER STANDARD.

PILOT-SAMPLE SHOULD BE APPROVED BY A.H.S.P. BEFORE BULK PRODUCTION			
EST. MASS.		TO BE STAMPED OR MARKED WHERE INDICATED THUS *	
82.7		(LETTERS)	
A 22-1-2001 HOFAMC.COA(KV)/AS/006		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL:-	USED ON:-
JRN	SCALE:- 2:1		AK 150C-01-C6
CHD	DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAIL	
PCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: DELIVERY VALVE 3rd STAGE ASSY	
APPD	ALL THREADS CONFORM TO	DRAWING NUMBER	
JATE	22.7.96	D S CAT NUMBER	AK 150B-33C6

DRAWING NUMBER
AK150B-36 C5



A-A



CHECK VALVE FOR TIGHTNESS IN UNITS AK150H-15 AND AK150H-17 BY FEEDING AIR AT A PRESSURE OF 10 kg/cm². AIR LEAKAGE NOT EXCEEDING 60 BUBBLES PER MINUTE IS ALLOWED, CHECK DURING ASSEMBLY.

IT IS ALLOWED TO CHECK AIR TIGHTNESS WITH A SPECIAL DEVICE AS PER STANDARD.

PROJECTION OF VALVE BEYOND SURFACE T SHOULD NOT EXCEED 0.3 mm AND DEPRESSION SHOULD NOT EXCEED 0.05 mm.

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

EST. MASS 81 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

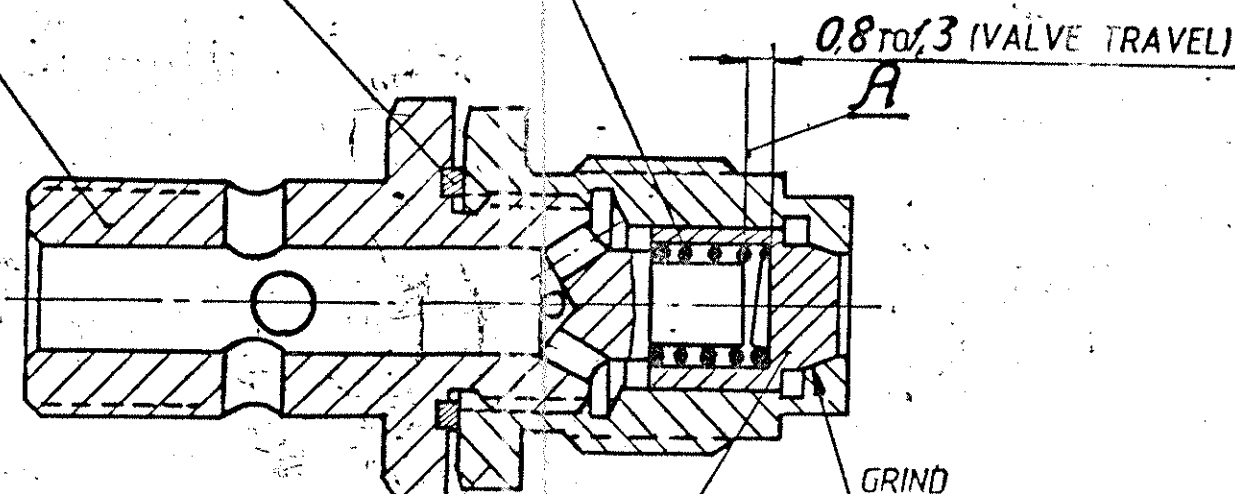
DRN	CPI	MATERIAL:-	USED ON:
CHD	Blotach		AK150C-01C5
TCD	V-Pan		
APPD	K. P. S.	CONTROLLERATE OF INSPECTION(HEAVY VEHICLES)	
DATE	22.7.86	AVADI	
SCALE	2:1	TITLE	SUCTION VALVE (A)
DIMENSIONS IN mm			2nd & 3rd STAGE ASSY
TOLERANCE ON DIMS UNLESS OTHERWISE STATED.			
ALL THREADS CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
			AK150B-36 C5
ISSUE	DATE	NATURE OF AMENDMENTS	
A	11-11-90	D.O CORRECTION	

DRG INDIVANISED BASED ON RUSSIAN ORIGINAL ISSUE MIL

85

DRAWING NUMBER
AK150B-38C6

AK150B-218 AK150B-134 AK150-036



AK150B-135

AK150-031

FILING OF PLANE 'A' IS ALLOWED.

FINALLY CHECK THE AIR TIGHTNESS OF VALVE IN UNIT AK150H-17
UNDER AN AIR PRESSURE OF 10kg/cm².

AIR LEAKAGE SHOULD NOT EXCEED 80 BUBBLES PER MINUTE.

CHECK ONLY IN ASSEMBLY.

IT IS ALLOWED TO CHECK THE AIR TIGHTNESS IN A SPECIAL
DEVICE AS PER STANDARD.

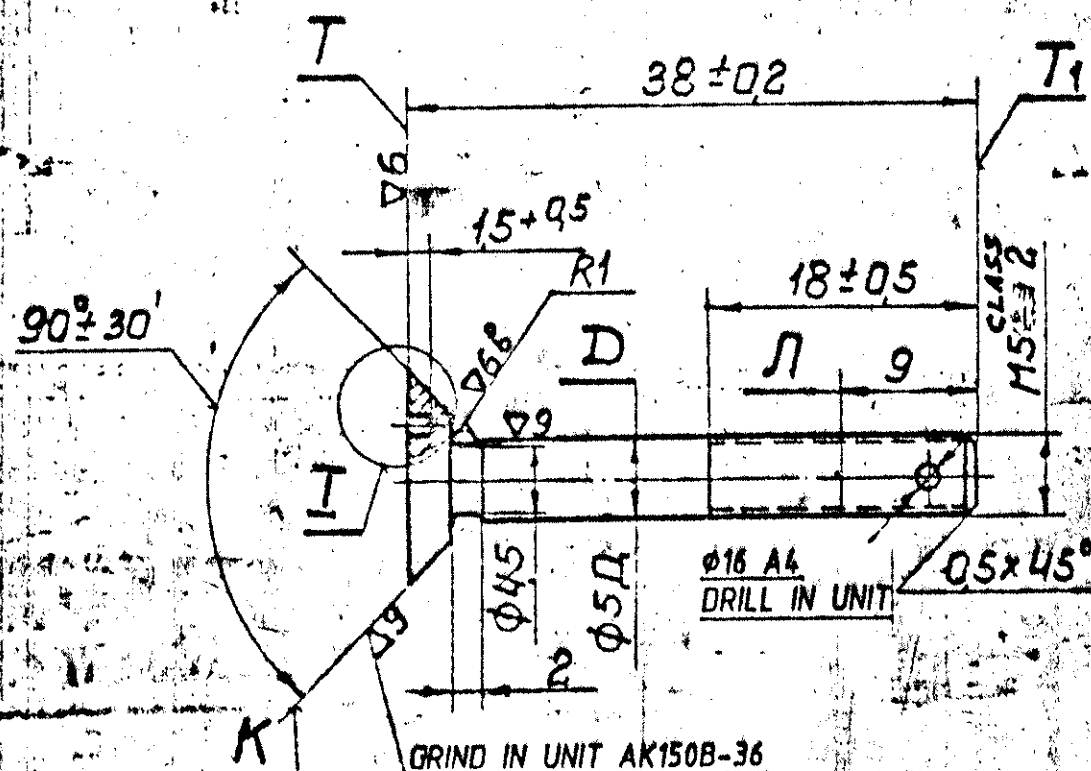
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

		EST. MASS.	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	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL:-	USED ON:-
DRN d. H. S. P.	SCALE - 2:1		AK 150 C - 01 C B
CHK d. H. S. P.	DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD	
TCD d. H. S. P.	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: DELIVERY VALVE - 2nd STAGE ASSY.	
APPR d. H. S. P.	ALL THREADS CONFORM TO	T. S. CAT NUMBER	DRAWING NUMBER AK150B-38C6
DATE 25/7/86			

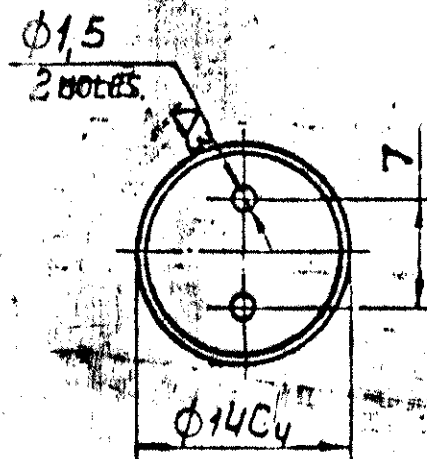
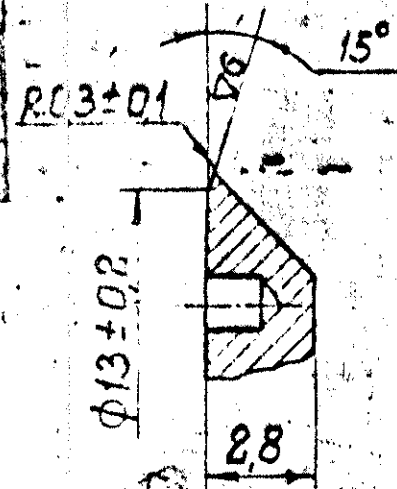
DRAWING NUMBER
AK150B-040

UNLESS STATED OTHERWISE

TOLERANCES ON FREE DIMENSIONS ARE
5 PER 22AT52 CLASS 7.



SCALE 5:1



CHECK RUN-OUT OF SURFACE K WITH RESPECT TO SURFACE D
WITH GAUGE BY BLUEING.

BREAKS IN IMPRINT CIRCLE ARE NOT ALLOWED.
CENTRE SEAT A0.7, OST 3725, IS ALLOWED ON FACE T.

DRILL MARK HAVING DIAMETER AND DEPTH OF UPTO 1.0mm IS
ALLOWED ON FACE T.

HARDNESS HRC 48 TO 52.
REDUCE HARDNESS OVER LENGTH η TO HRC 32.

CONVERSION ZONE OF HARDNESS IS UPTO THREAD END.

ALL MATL.
STEEL EN 36 TO BS 970
HRC 48-52

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

EST. MASS.
8

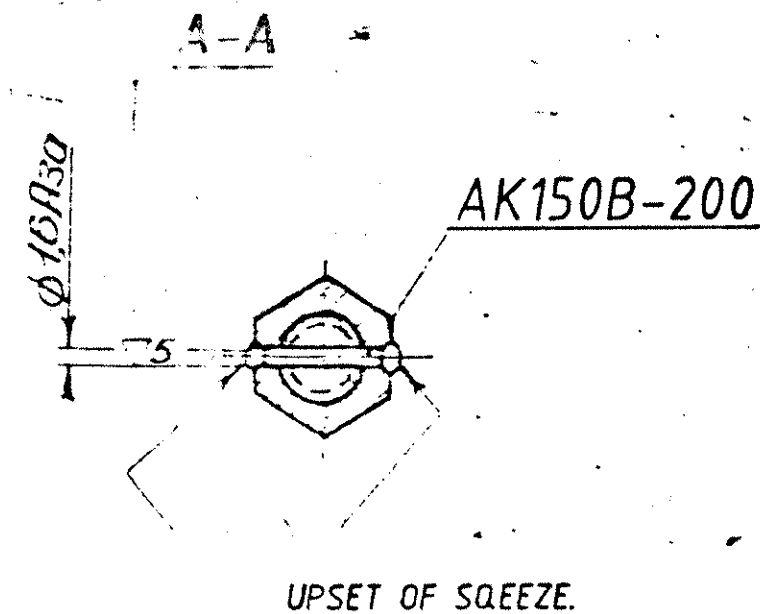
TO BE STAMPED OR MARKED WHERE
INDICATED THUS # (LETTERS)

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

DRN	CHO	TCO	APPD	DATE	SCALE	DIMENSIONS	TOLERANCE	ALL THREADS
				22.7.86	2:1	IN mm	ON DIMN	CONFORM TO
							UNLESS OTHERWISE	
							STATED.	
ISSUE	DATE	NATURE OF AMENDMENTS						

MATERIAL:- STEEL EN 36 TO BS 970	USED ON:
TY14-1-950-74	AK150B-36CB
CONTROLLER OF INSPECTION (HEAVY VEHICLES)	AVADI
TITLE:	VALVE SUCTION
DRAWING NUMBER	AK150B-040

AK150B-60CB

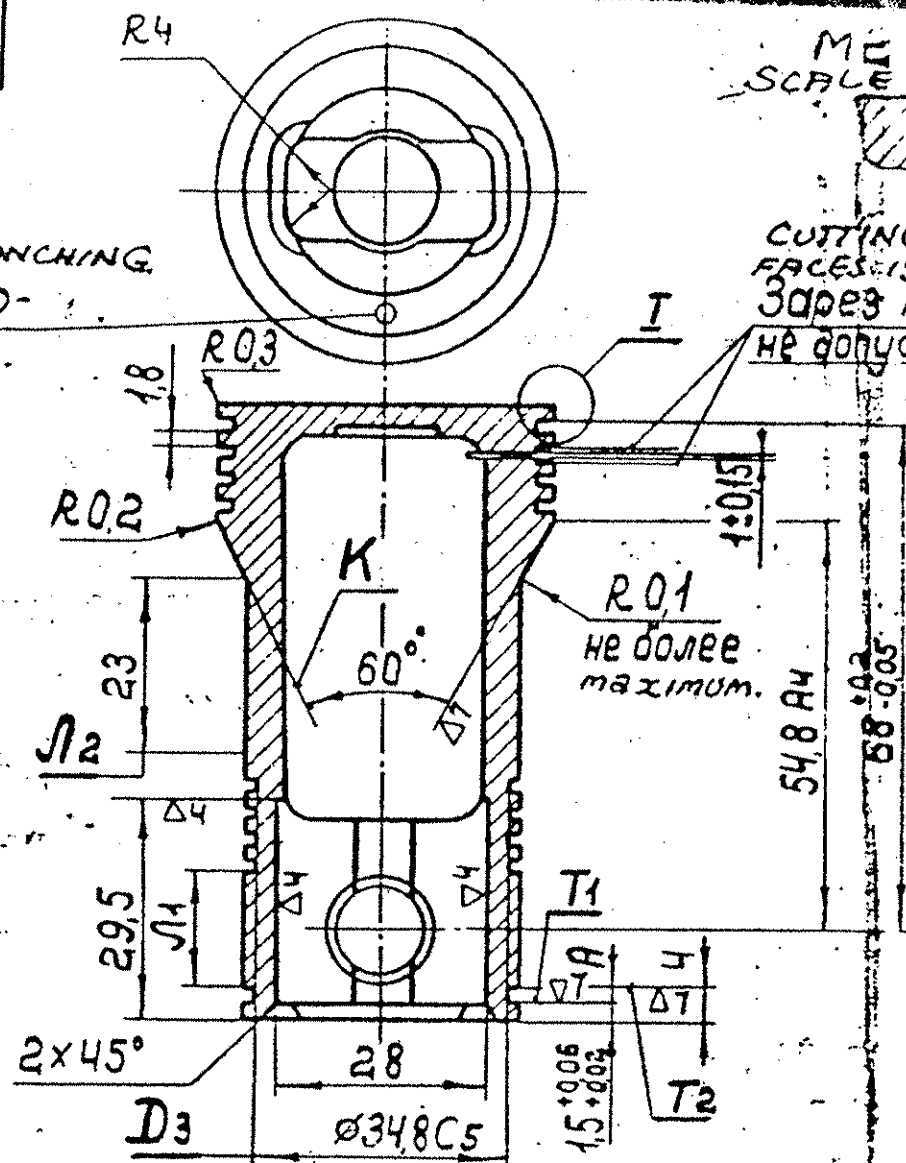


PROJECTION OF VALVE BEYOND BUTT END T SHOULD NOT EXCEED
0.15 mm ^{AND} SINKING SHOULD NOT EXCEED 0.05 mm.

[illegible]

AK150B-60 СБ

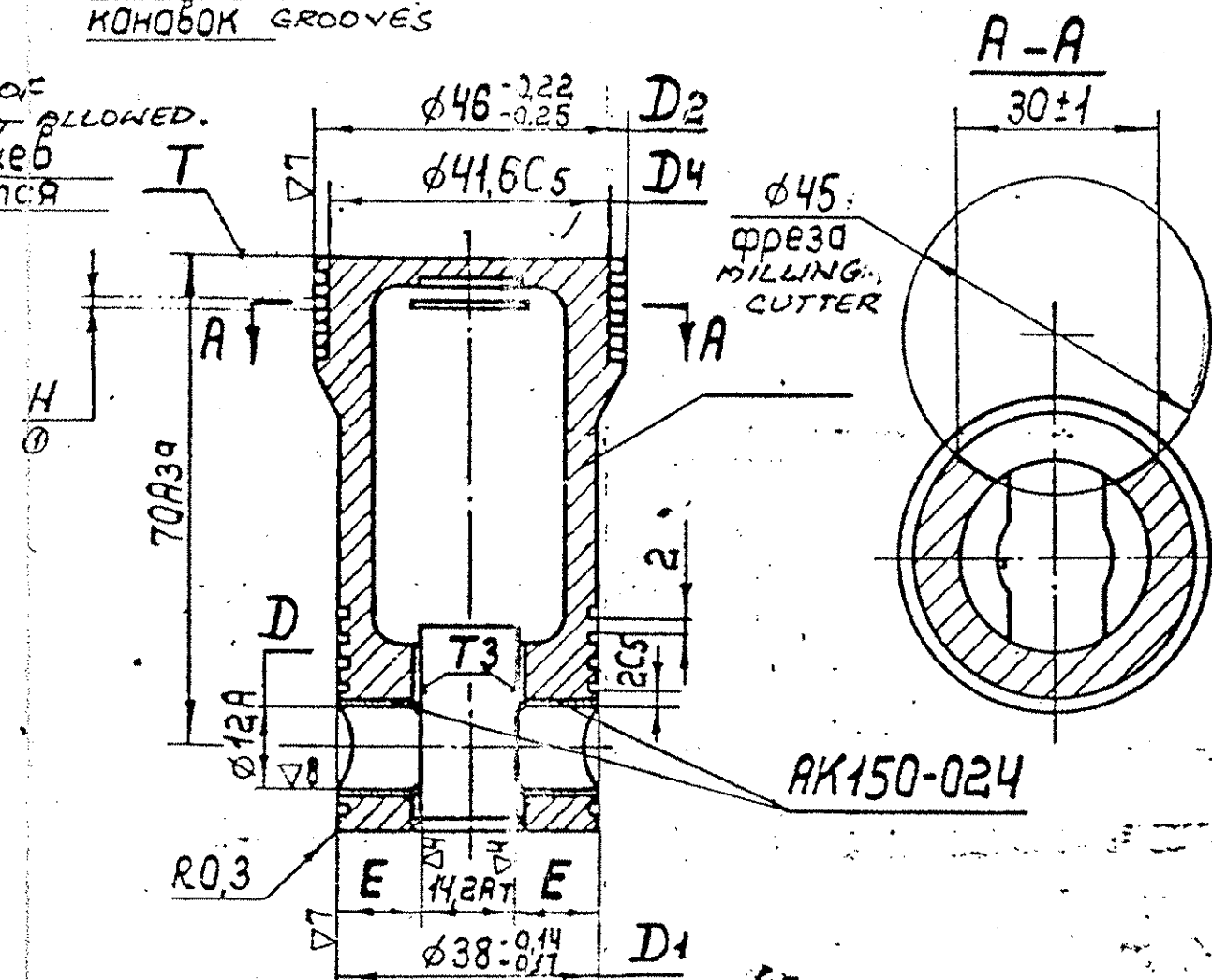
STAMP BY PUNCHING
Клеить удар-
ным клеймом



ME 1
SCALE 2:1

R0.1 НЕ БОЛЕЕ
ДЛЯ ВСЕХ FOR ALL
КОМОВОК GROOVES

DIMENSIONS AS PER 22 AT 52



A-A

30±1

φ45
фреза
MILLING
CUTTER

AK150-024

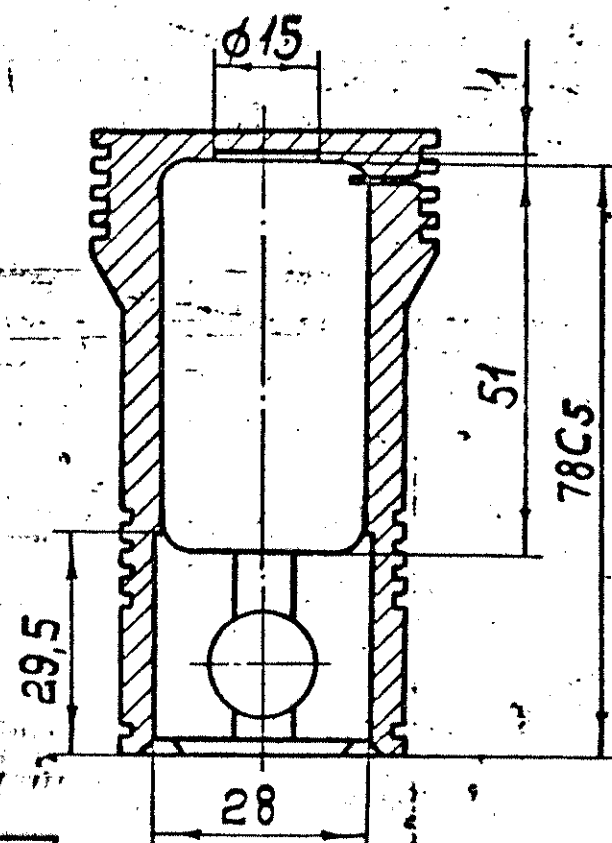
1. DURING UNIT ASSEMBLY, SELECT COMPONENTS AK150-024 AND AK 150C-104 OF THE SAME GROUP.
2. CHECK SURFACE K BY BLUEING WITH THE HELP OF GAUGE. THE IMPRINT SHOULD COVER ATLEAST 75% OF SURFACE K.
3. GROOVE 1mm, MAX. WIDE AND TO 0.1mm DEEP IS ALLOWED ON SURFACE D1 NEAR THE CONE.
4. DIFFERENCE IN DIMENSIONS E SHOULD NOT EXCEED 0.1.
5. DIMENSION A IS ACTUAL FOR ALL CIRCULAR GROOVES.
6. VARIATION IN WALL THICKNESS OF BUSHING AK150-024 SHOULD NOT EXCEED 0.3.
7. RUN OUT OF SURFACE D1 RELATIVE TO D2 SHOULD NOT EXCEED 0.02.
8. RUN OUT OF SURFACE D1 RELATIVE TO D2 AND SURFACE D3 RELATIVE TO D1 SHOULD NOT EXCEED 0.03.
9. RUN OUT OF SURFACE T RELATIVE TO SURFACE D2 SHOULD NOT EXCEED 0.05.
10. NON SQUARENESS OF SURFACE T3 RELATIVE TO D SHOULD NOT EXCEED 0.1.
11. NON SQUARENESS OF SURFACE D TO D1 SHOULD NOT EXCEED 0.03 ON A LENGTH OF 40.
12. NON FLATNESS OF SURFACE T SHOULD NOT EXCEED 0.03.
13. MISALIGNMENT OF AXIS φD RELATIVE TO AXIS φD1 SHOULD NOT EXCEED 0.05.
14. NON SQUARENESS OF SURFACES T1 AND T2 RELATIVE TO D1 AND D2 SHOULD NOT EXCEED 0.03 ON A LENGTH OF 20.
15. DO NOT BLUNT SHARP EDGES IN GROOVES ALONG THE OUTER SURFACES.
16. SURFACE D1 MAY BE GRAPHITIZED ALONG THE LENGTH 1 AND 2 ACCORDING TO THE FACTORY TECHNOLOGY.

104

%

EST. MASS		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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE			
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL	USED ON: AK150C-45C5
DRN CPH	SCALE - 1:1		
CM	DIMENSIONS IN mm	CONTROLLER OF INSPECTION (HEAVY VEHICLES) AVAIL	
TO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: PISTON WITH BUSH ASSY	
BY	ALL THREADS CONFORM TO	DRAWING NUMBER: AK150C-100-C5	
DATE			

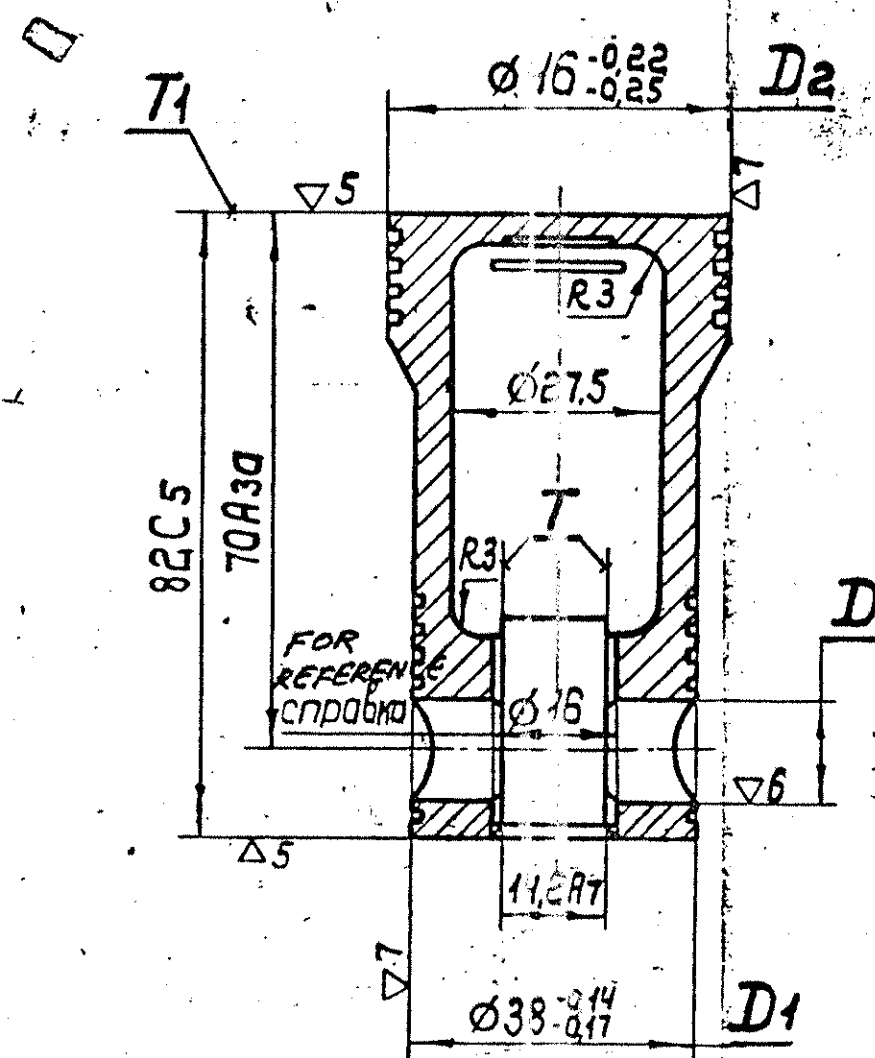
DRAWING NUMBER
AK 150C-104



DIMENSION РАЗМЕР D	GROUP Группа
Ø 14A	I
Ø 14,1A	II
Ø 14,2A	III

1. MACHINE SURFACES D1, D2 AND T IN UNIT AK 150C-100.
2. RUN OUT OF SURFACE T1 RELATIVE TO SURFACE D2 SHOULD NOT EXCEED 0.05.
3. RUN OUT OF SURFACE D1 RELATIVE TO SURFACE D2 SHOULD NOT EXCEED 0.02.
4. NON SQUARENESS OF SURFACE D RELATIVE TO SURFACE D1 SHOULD NOT EXCEED 0.03 ON A LENGTH OF 20.
5. MISALIGNMENT OF AXIS ØD RELATIVE TO AXIS OF ØD, SHOULD NOT EXCEED 0.05.
6. DO NOT BLUNT SHARP EDGES ON THE OUTER SURFACES.
7. HARDNESS HR 100.

размеры по 22AT52-7кл.
AS PER 22 AT52-7cl.



7. Твердость HB ≥ 100

PLOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE SOLE PRODUCTION		EST. MASS.	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			
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL:- ALLOY B 9571 GOST 21488-76	USED ON:- AK 150C-100.C5
DRN C.P.R.	SCALE - 1:1		
CHK B. K. K.	DIMENSIONS IN mm		
TOL V.P.	TOLERANCE ON DIMS UNLESS OTHERWISE STATED		
APD K.	ALL THREADS CONFORM TO		
DATE 2.7.80		D S CAT NUMBER	DRAWING NUMBER AK 150C-104

3