



1. BEFORE MOUNTING OF SUPERCHARGER, THE QUALITY OF SURFACES B AND Γ OF CRANKCASE AND SUPERCHARGER IS TO BE CHECKED. DENTS AND DEEP MARKS ARE NOT ALLOWED.
2. THE SUPERCHARGER IS TO BE FITTED ON THE PAD B OF CRANKCASE WITHOUT CLEARANCE BY USING OF BOLTS, ITEM 22 AND THE BOLTS ARE TO BE TIGHTENED WITH A TORQUE OF 20 Nm (1.2 Kgf/m) MAX. FITTING OF BODY TO THE CRANKCASE IS TO BE CHECKED AT THE EDGE POINTS AFTER FINALLY TIGHTENING NUTS, ITEM 5 AND ITEM 13 WITH A FEELER-GAUGE. FEELER 0.03 mm SHOULD NOT PASS THROUGH. AFTER FINAL TIGHTENING OF NUTS, ITEM 5 AND ITEM 13, THE BOLTS ARE TO BE TIGHTENED WITH A TORQUE OF (20.5) Nm ((1.2 - 0.5) Kgf/m) AND LOCKED. DURING MOUNTING THE BOLTS SHOULD BE EASILY SCREWED IN TO THREADED HOLES A OF CRANKCASE THROUGH THE HOLES OF SUPERCHARGER BODY. SEPARATION OF SURFACE Γ OF SUPERCHARGER BODY FROM THE CRANKCASE IS NOT ALLOWED.
3. SUPERCHARGER FASTENING NUTS TO THE CRANKCASE ARE TO BE TIGHTENED BY TWO STEPS IN THE FOLLOWING SEQUENCE: TWO MIDDLE REAR, TWO MIDDLE FRONT AND THEN THE REST OF NUTS. TO BE TIGHTENED. NUTS, ITEM 13 (TO A POSITION ENSURING THE PROPER LOCKING) WITH A TORQUE OF (90 ± 3) Nm ((1.9 ± 0.1) Kgf/m). NUTS, ITEM 5 WITH A TORQUE OF (35 ± 5) Nm ((1.35 ± 0.5) Kgf/m).
4. TEETH ENGAGEMENT OF SUPERCHARGER CLUSTER GEAR SHOULD BE CHECKED WITH THE CRANKSHAFT GEAR OF ENGINE AS BELOW:
 - a) CIRCUMFERENTIAL BACKLASH BETWEEN THE TEETH SHOULD BE WITH IN D.T. ± 0.4 mm. DIFFERENCE IN MEASUREMENT OF CLEARANCE SHOULD NOT EXCEED 0.08 mm.
 - b) THE BLUE IMPRINT ON THE GEAR TEETH SHOULD COVER NOT LESS THAN 65% OF TOOTH LENGTH AND NOT LESS THAN 90% OF TOOTH HEIGHT. THE IMPRINT SHOULD BE IN COMPLIANCE WITH THE INSTRUCTIONS M.B. - 89 - 3, a.
5. INSTEAD OF CHECKING THE TEETH ENGAGEMENT OF SUPERCHARGER CLUSTER GEAR WITH THE CRANKSHAFT GEAR OF ENGINE, IT IS ALLOWED TO CHECK THE ENGAGEMENT WITH THE GEAR OF SPECIAL DUMMY IN COMPLIANCE WITH THE POINT 4. OF TECHNICAL REQUIREMENTS FOR QUALITY OF ENGAGEMENT DURING MOUNTING OF SUPERCHARGER ON THE ENGINE.
6. AFTER THE PERFORMANCE OPERATION OF ACCEPTANCE TEST OF ENGINE, TIGHTENING OF NUTS, ITEM 5 WITH A TORQUE OF (35 ± 5) Nm ((1.35 ± 0.5) Kgf/m) AND TIGHTENING OF NUTS, ITEM 12 FASTENING INLET PIPELINE T-PIECE IS TO BE CHECKED.
7. FOR ASSEMBLY UNIT IN TROPICALIZED MAKE, THE COMPONENTS AND ASSEMBLY UNIT, SHOWN WITH THE CONVENTIONAL DESIGNATION "T" IN THE PARTS LIST OF GIVEN DRAWING IN "REMARKS" COLUMN, SHOULD HAVE TROPICALIZED MAKE, AS SPECIFIED IN THE DRAWINGS FOR COMPONENTS AND ASSEMBLY UNIT.

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

EST. MASS TO BE STAMPED ON MARKED WHERE INDICATED THIS B (LETTERS)

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

CON	U.S.A.	MATERIAL	USED ON
END	IN		V 46-6
APP	BY	CONTROL	CONTROL OF QUALITY ASSURANCE BY VENUES
DATE	OF	SCALE	1:1
DIMENSIONS IN MM		TOLERANCE ON DIMS	
UNLESS OTHERWISE		STATED IN TOLERANCE	
ALL THREADED TO		D 5 LAY NUMBER	
CONFORM TO		C63338-00-16C6	
ISSUE	DATE	NATURE OF AMENDMENT	

TITLE
SETTING OF SUPERCHARGER ASSY



USED ON

V46-6

(A)

(A)

(A)

ITEM	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	No. OFF.	REMARKS
	C63338-00-16C6 & ITEM LIST		MOUNTING OF SUPER CHARGER ASSY		
1	C63338-401-10 & ITEM LIST		SUPER CHARGER H-46-6 ASSY	1	TI
4	3338-460-1		T-PIECE WASHER	1	TI
5	3338-482		NUT M10 X 1	2	TI
8	3301-193-1		GASKET	1	

A 10-4-95 AUTHY NOTN. No BK 86-190 BK 85-521

ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS
DRN			CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.		
CHD			TITLE: MOUNTING OF SUPER CHARGER ASSY		
TCD					
APPD			D S CAT NUMBER	ITEM LIST FOR	
DATE	16-4-95	SHT. No. 1 OF 2		C63338-00-16	

A 10-2-95 AUTHY NOTN. No BK 86-190 BK 85-521

