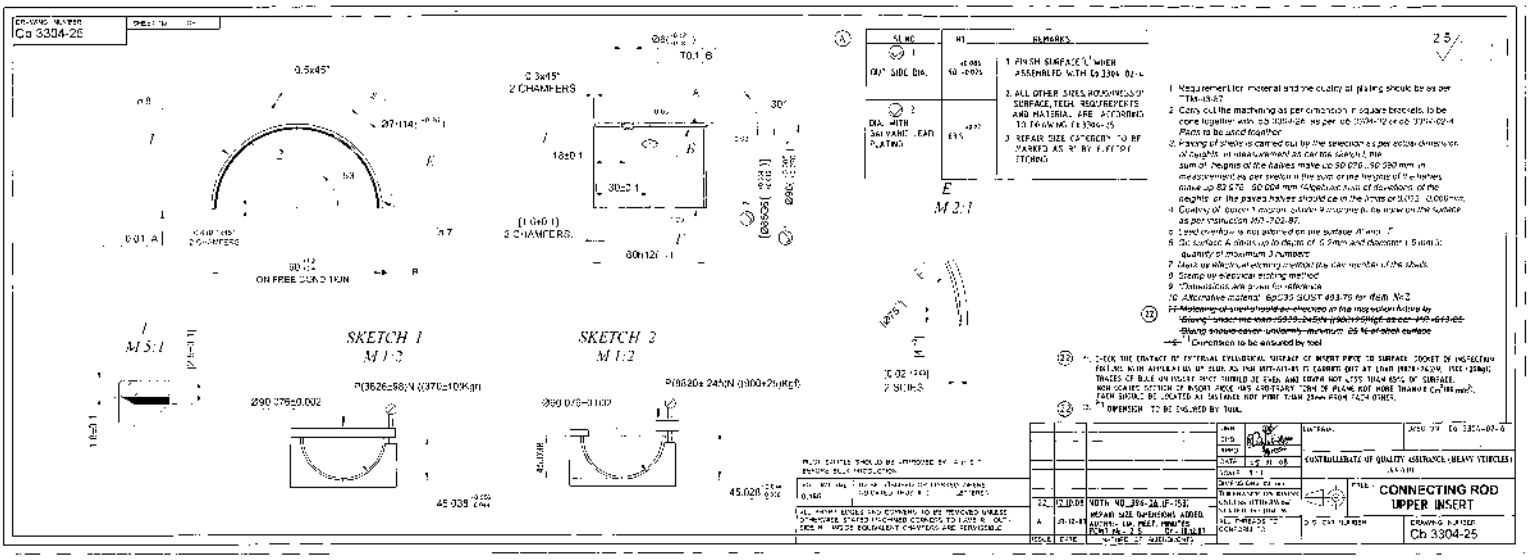
DRAWING NUMBER
Cb 3304-25

SHEET NO. 1



UNWANTED INCORPORATED BASED ON PRINTING ORIGINAL SIZE
USING REPLACES Cb 3304-25 ISSUE-8 VIDE MCTM NO: 2010-16
LUPMOM TO 4-3252 EACHE

DRAWING NUMBER
Cb 3304-26

SHEET No. 19

2.5

(1.0×0.1)
2 CHAMFERS

90°±2°
CONTROL CONDITION

0.4±0.1×45°
2 CHAMFERS

0.01 A

27×0.1

0.2×45°
2 Chamfers

SKETCH I

SKETCH II

M 5:1

VIEW E
M 2:1

VIEW F (ELEVATION)
M 2:1

M 2:1

P(8620–8620N (870–100Kgf)

Ø90.07/+0.002

P(8620–2450N (900±25)Kgf)

Ø90.07/+0.002

46.028 +0.060

R3.25

R1.5±0.2

1. Requirement for material and the quality of plating should be as per TDV-43-87.
2. Carry out the map marking as per the section in square brackets, to be done together with Cb 3304-25 as per Cb 3304-52 or Cb 3304 024. Parts to be welded together.
3. Planing of shells is carried out by the sections as per actual dimension of heights in measurements as per the sketch I, the sum of heights of the halves make up 40.006 ...30.000 mm in measurements as per sketch II the sum of the heights of the halves make up 99.973 ...99.004 mm (alternative sum of heights of the weights of the same halves should be in the limits of 0.332 ...0.360 mm.
4. Dealing of bores I marked, shown on figure to be done on the surface as per H.D.-702-87.
5. Load overlaps is not allowed on the surface 'K' and 'F'.
6. On surface A there up to a depth of 0.2mm and diameter 1.5 mm in quantity of max. of 3 numbers is allowed.
7. Mark by electrical etching method the part number of the shell.
8. Mark the connecting rod number by electrical etching method.
9. Stamp by electrical etching of shell.
10. Dimension to be checked by TGK.
11. Dimensions are given for reference.
12. Alternative material: BaC40 GOST 403-70 for item 2.
13. ~~Marking of shell should be checked in the inspection notes by Gherkin on the rod (Ø40±0.46 (1000±25)Kgf) as per [illegible] 13.8.93 [illegible] uniformly in an off-shell surface.~~
14. [illegible] THE CONTACT OF EXTERNAL MECHANICAL SURFACE OF INSERT TOOL OR SURFACE SCREW OF ACCESSORY FIXTURE IN THE APPLICATION OF SEAL AS PRESENTED ABOVE IS CHANGED BUT AT LEAST HEADMARKS IN ORDER NOT TRACES OF BLUE ON INSERT PIECE SHOULD BE EVEN AND COVER NOT LESS THAN 80% OF SURFACE
NON CLAMPED SECTION OF INSERT TOOL ALTERNATE FORM OF PLANE NOT FURTHER THAN 0.5 mm [illegible] SHOULD BE LOCATED AT DISTANCE NO MORE THAN 30 mm FROM EACH OTHER.

SL No.	Pl	REMARKS
1	0.01 SEE DIA.	1. FINISH SURFACE 'E' WITH A VARIATION OF ... Cb 3304-25
2	DIA. WITH BALSAME LEAD PLATING	2. ALL OTHER MECHANICAL OF SURFACE TECHNICAL REQUIREMENT AND MATERIAL ARE ACCORDING TO DRG. No. Cb 3304-26 3. MARKING SIZE IS ACCORDING TO BE MARKED AS RI BY ELECTRIC ETCHING.

PILOT SAMPLE SHOULD BE APPROVED BY ... BEFORE MASS PRODUCTION

REV. No.	DATE	REMARKS
0.166		[illegible]
A	17.10.02	WIDTH 40: 35+0.16 (E-15)A
	24-12-97	REPAIR SIZE DIMENSIONS AROUND ALTERNATIVE MODEL NUMBERS PRINT No.: 2.3 UL-18.12.97

ALL SHARP EDGES ARE DEBURRED TO BE REMOVED UNLESS OTHERWISE STATED. MACHINED CORNERS TO HAVE R 0.01 GOST 8.1 INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

DRW.		Material
SCH.		
APPD.		
CHKD.		
SCALE 1:1		

USED ON: [illegible] 1-2 [illegible] 1-2

OVERSEAS NOTES
TOLERANCE UNLESS OTHERWISE STATED IS: [illegible]
MATERIAL IS: [illegible]
ALL THREADS TO COMPLY TO

UNITED SEAMLESS PIPE QUALITY ASSURANCE (HEAVY VEHICLES) AVADI

TITLE
CONNECTING ROD
LOWER INSERT

D.S. CAT NUMBER

DRAWING NUMBER
Cb 3304-26

DRAWING ARCHIVED BASED ON RUSSIAN ORIGINAL ISSUE - 19
OF 31 REPLACES Cb 3304-26, ISSUE-11 VIDE NO M NO. 7020-48
LUMINA 111 V-5212 ENGINE.

USED ON	ZONE	ITEM NO	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	QTY	REMARKS
			Cb.3304-25		**CONNECTING ROD**		
			ITEM LIST		**UPPER INSERT**		
Cb 3304-02-4							
		1	3304 - 25		CONNECTING ROD	1	NO DRG
					SHEEL (UPPER) .		
					STEEL 10 GOST 1050-88		
		2			Бр ОС1-22	0.05	Kg
					ОСТ 190054-72		
I/L CREATED BASED ON RUSSIAN ORIGINAL ISSUE – 3							

ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS

DRN		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.		
CHD		TITLE : **CONNECTING ROD UPPER INSERT**		
APPD				
DATE	05.01.08	SHT. NO. 1 OF 1	D S CAT NUMBER	ITEM LIST FOR **Cb.3304-25**

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USED ON

Cb 3304-02-4

I/L CREATED BASED ON RUSSIAN ORIGINAL ISSUE – 3

ZONE	ITEM NO	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	QTY	REMARKS
		Cb.3304-26		**CONNECTING ROD**		
		ITEM LIST		**LOWER INSERT**		
	1	3304 - 26		CONNECTING ROD	1	NO DRG
				SHEEL (LOWER)		
				STEEL 10 GOST 1050-88		
	2			Бр ОС1-22	0.05	Kg
				ОСТ 190054-72		

ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS

DRN		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.		
CHD		TITLE : **CONNECTING ROD LOWER INSERT**		
APPD				
DATE	05-01-08	SHT. NO. 1 OF 1	D S CAT NUMBER	ITEM LIST FOR **Cb.3304-26**

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