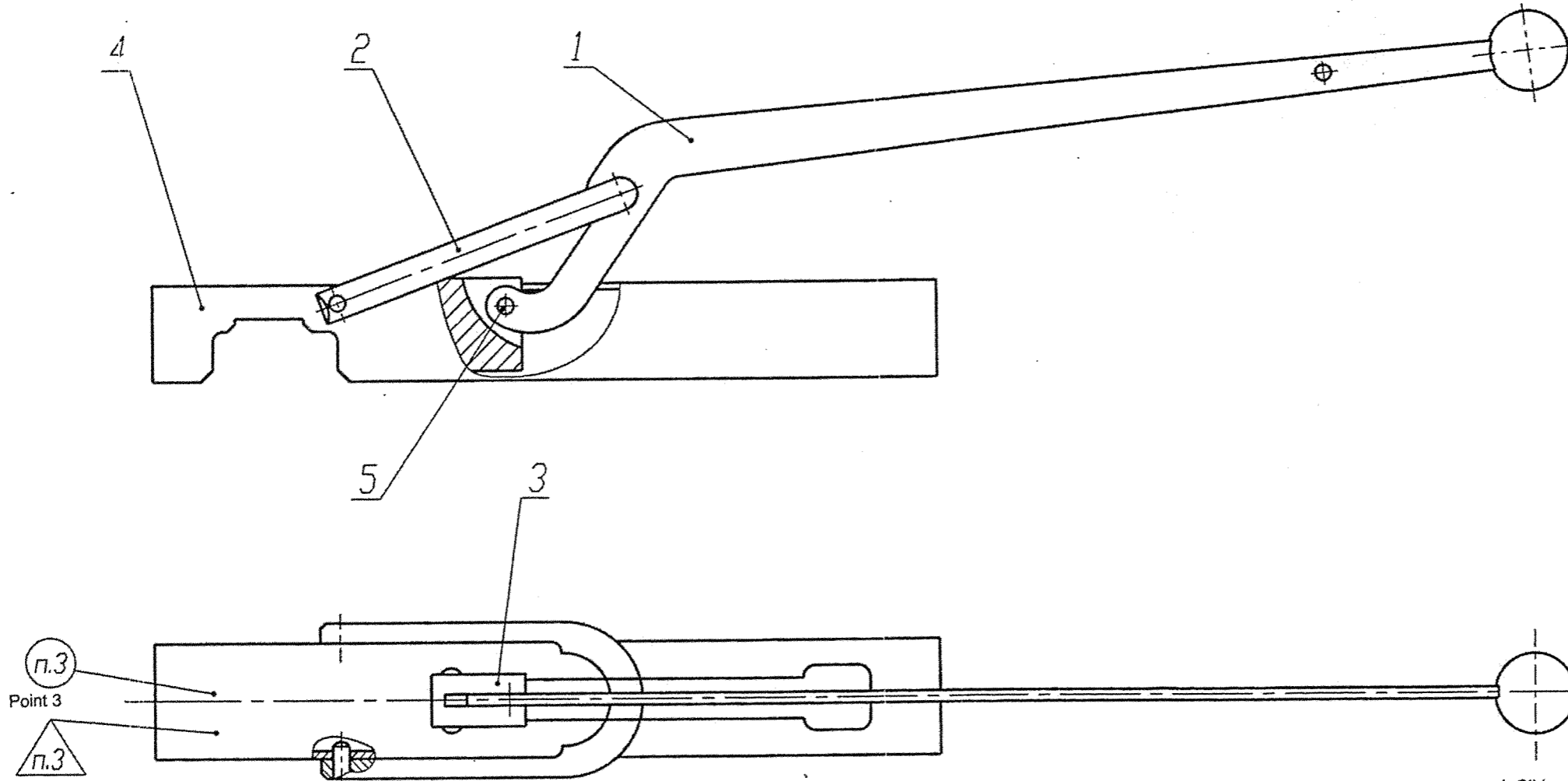


First use		Format	Zone	Pos.	Designation			Nomenclature			Qty.	Remarks
								Documents				
Reference No.	A2				AK-630-Yu Sb 8 SB			Assembly drawing				
								<u>Assembly units</u>				
	A4	1			AK-630-Yu Sb 8-2			Handle			1	
	A4	2			AK-630-Yu Sb 8-4			Clevis			1	
								<u>Components</u>				
	A3	3			AK-630-Yu 8-2			Slide			1	
	A2	4			AK-630-Yu 8-8			Base plate			1	
								<u>Standard articles</u>				
		5						Pin 8 Pr2 2ax36.40Kh			1	
								K38.5..45.5 HRC Chem.phos.Oil.				
								OST 3-2234-93				
Sign and Date												
Dupl. Inv. No.												
Alternate Inv. No.												
Sign and Date					AK-630-Yu Sb 8							
Orig. Inv. No.		Amend.	Sheet	Doc. No.	Sign	Date	Fixture for joining the band			Type	Sheet	Sheets
		Developed by								A		1
		Checked by										
		Head of Q.C.D										
		Approved by										



1. Slider position 3 should move freely, without jamming.
2. Lubricate all rubbing surfaces with grease MS-70 GOST 9762-76.
3. Mark Ч and stamp K as per AK-630, AK-630M TU I.

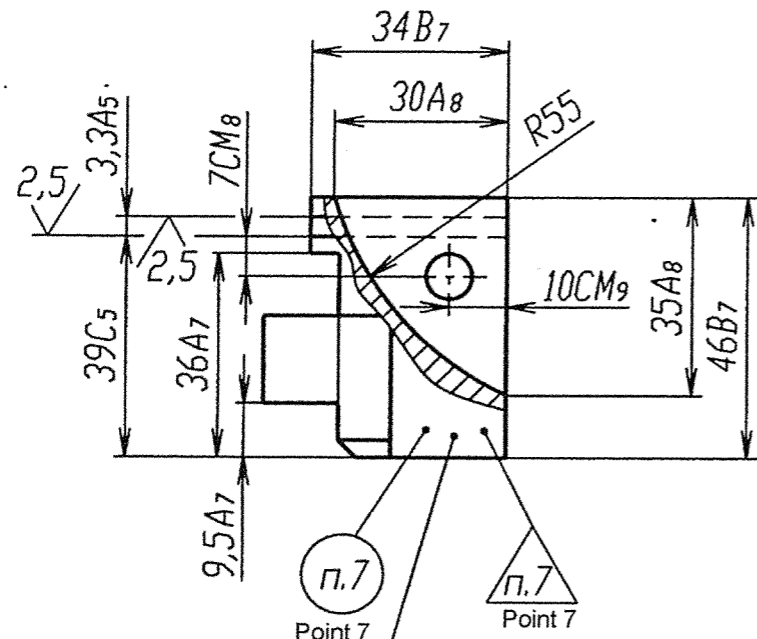
1. Ползун поз.3 должен двигаться свободно, без заеданий.
2. Все трущиеся поверхности смазать смазкой MS-70 ГОСТ 9762-76.
3. Маркировать Ч и клеить К по АК-630, АК-630М ТУ I.

AK-630-Yu Sb 8 SB

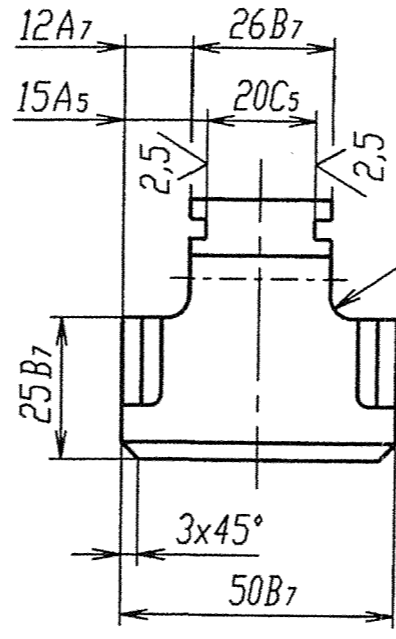
AK-630-Ю СБ8СБ

				Type	Mass	Scale
Изм/Лист	№ докум.	Подп.	Дата	Лит.	Масса	Масштаб
Разраб.				A	1,050	1:2
Пров.						
Т.контр.				Лист	Листов 1	
Нач.вр.				Sheet	Total Sheets 1	
Н.контр.				Fixture for connecting strip		
Утв.				Assembly Drawing		

Инв.№ подл/Подп. и дата
 Взам.инв.№ Инв.№ дубл.
 Подп. и дата
 Слов.№
 Лев. примен.



п.7 Point 7
 Место испытания
 ТВЕРДОСТИ
 Place for checking hardness



A(2:1) Rz40 ✓(✓)

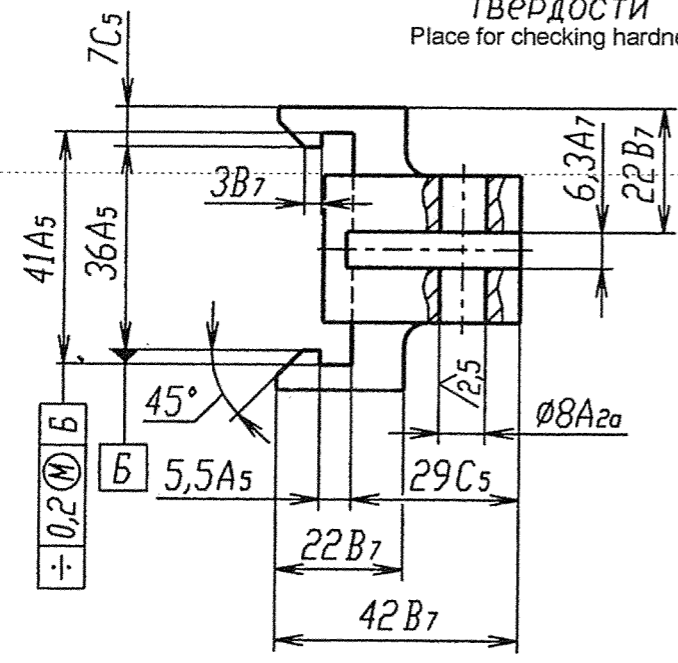
R3,5*
 4 радиуса
 4 radii

R4
 4 радиуса
 4 radii

2x45°
 2 ФАСКИ
 2 chamfers

2x45°
 2 ФАСКИ
 2 chamfers

2x45°
 2 ФАСКИ
 2 chamfers

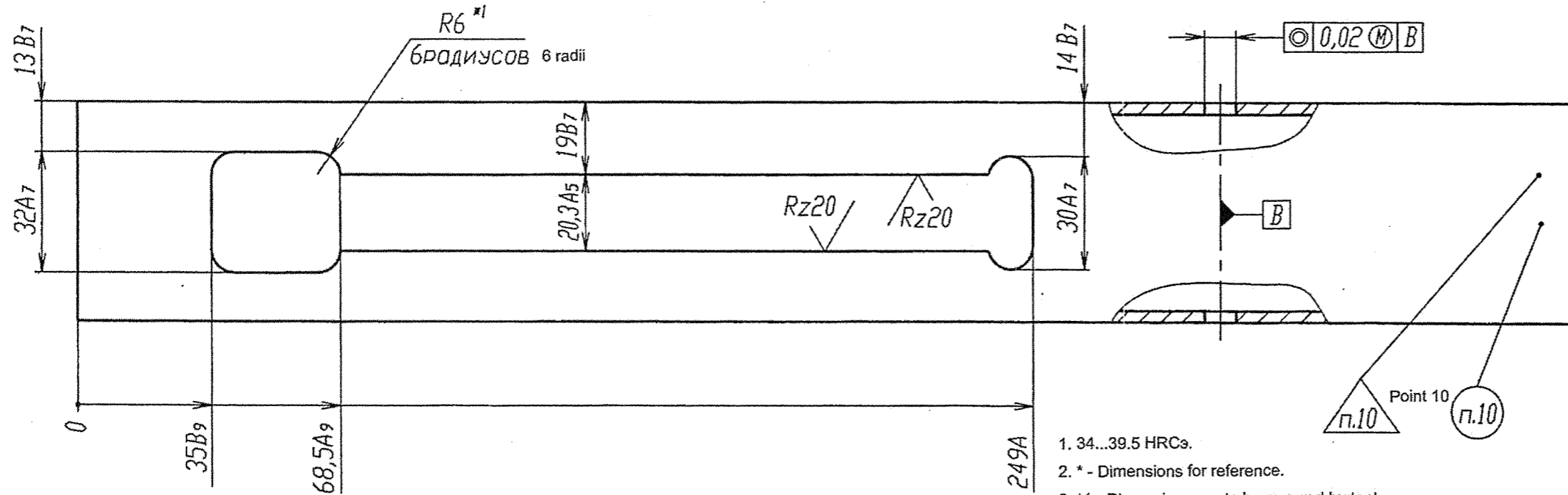
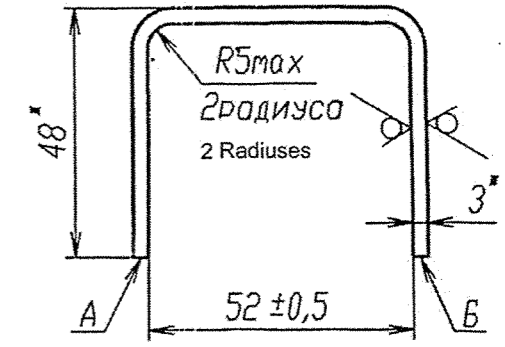
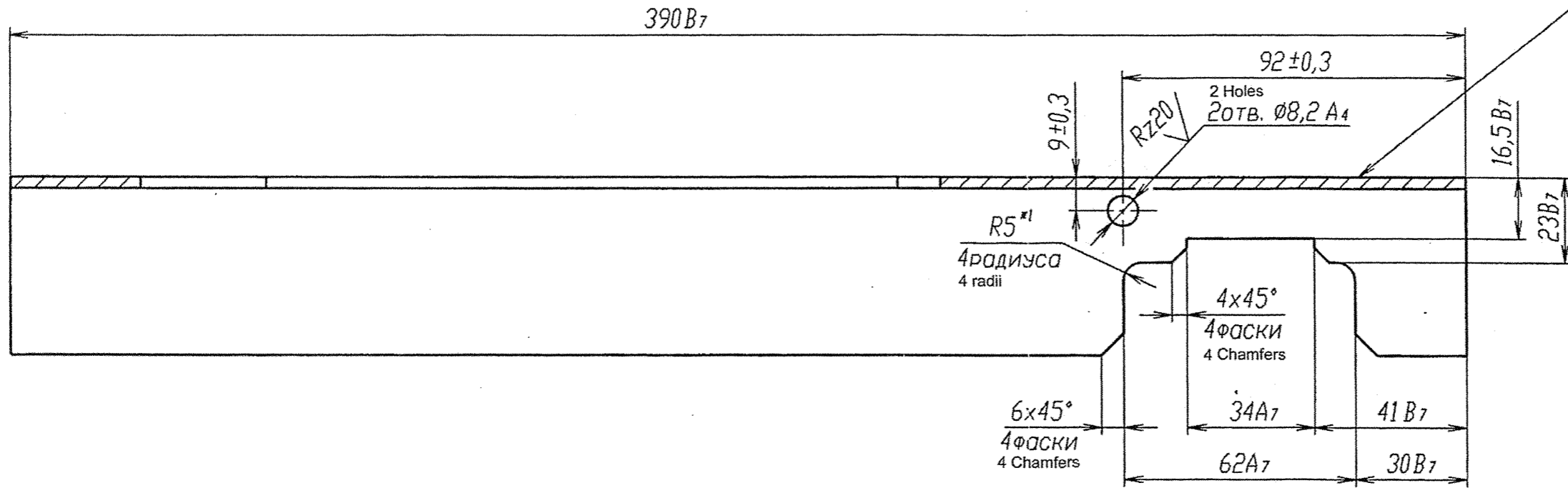


1. Substitute material- Steel 30 KhGSA GOST 4543-71.
2. 34..39..5 HRC_E.
- 3.* Dimensions ensured by tool.
4. Inner angles R~0.4 mm.
5. Blunt sharp edges ~0.4 mm.
6. Coating: Cd12.phos./ Lacquer BF-4 with Nigrosine, single coat. made as per OST 3-4123-78, V, OM2.
7. Mark Ш, Ч and stamp К, И as per AK-630, AK-630M TU I.

					AK-630 - Yu 8-2			
Amend.	Sheet	Doc.No.	Sign	Date	Slider	Type	Weight	Scale
Developed by						A	0.290	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Steel 50 GOST 1050-88			
Approved by								

Orig. inv. no.	Sign and Date	Alternate Inv. No	Duplicate Inv. No	Sign and Date	Reference No.	First use
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Place for hardness test
Место испытания
ТВЕРДОСТИ



1. 34...39,5 HRCз.
- 2.* Размеры для справок.
- 3.*1 Размеры обеспеч. инстр.
4. Развернутая длина детали 144 B7.
5. Разновысотность поверхностей А и Б не более 1,5 мм.
6. Внутренние углы R ≈ 0,4 мм.
7. Острые ребра притупить ≈ 0,6 мм.
8. Допускается в месте испытания твердости производить зачистку глубиной до 0,5 мм.
9. Покрытие: Кд12. фос./Лак БФ-4 с нигрозином, 1 слой. Изготовление по ОСТ 3-4123-78, IV, OM2.
10. Маркировать Ш, Ч и клеить К, И по АК-630, АК-630М ТУ I.

1. 34...39.5 HRCз.
- 2.* - Dimensions for reference.
- 3.*1 - Dimensions are to be ensured by tool.
4. Expanded length of component 144 B7.
5. Height difference of surfaces A and B is not more than 1.5 mm.
6. Internal angles R ~ 0.4 mm.
7. Blunt the sharp edges ~ 0.6 mm.
8. At the place of hardness test, it is permitted to carry out the finishing with depth up to 0.5 mm.
9. Coating: Cad 12. phos. / varnish BF-4 with nigrogin, 1 layer, preparation is as per OST 3-4123-78, IV, OM2.
10. Mark Ш, Ч and stamp К, И as per АК-630, АК-630М ТУ I.

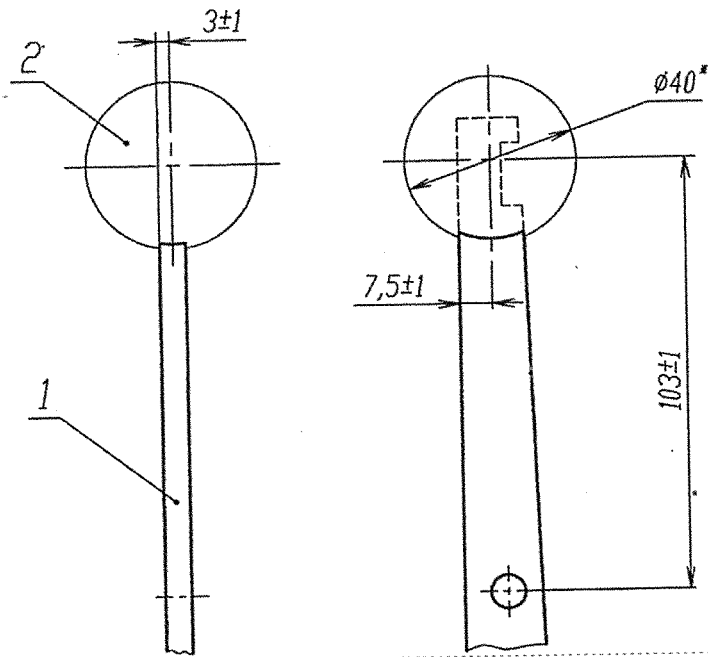
Перв. примен.
Справк.
Изм. и дата
Изм. и дата
Изм. и дата

AK-630-Yu 8-8

AK-630-Ю 8-8

				Type	Mass	Scale
				Лит.	Масса	Масштаб
Base				А	0,830	1:1
Основание				Лист	Листов 1	
ВТ-ПН-03 GOST 19904-90				Sheet	Total Sheets 1	
К490В 4-III-40 ГОСТ 16523-97				Лист		

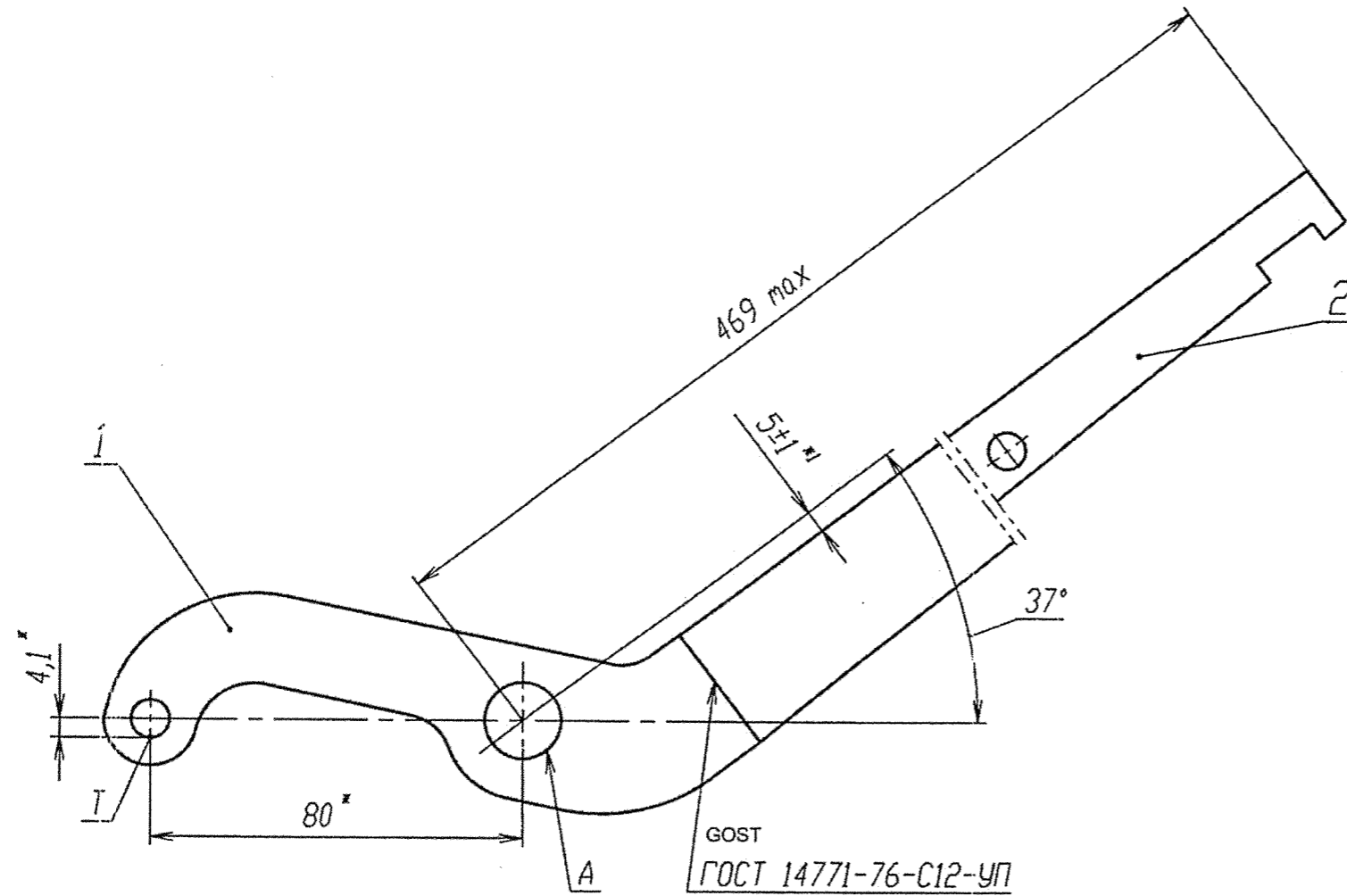
First use						Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks		
Reference No.														
						A3			AK-630-Yu Sb 8-2 SB	Assembly drawing				
										<u>Documents</u>				
										<u>Assembly units</u>				
						A4	1		AK-630-Yu Sb 8-7	Handle	1			
										<u>Materials</u>				
							2			Phenol plastic 0.-010-02 TV	0.07	kg.		
										Black				
										TU 2253-063-05015227-2001				
Sign and Date														
Dupl. Inv. No.														
Alternate Inv. No														
Sign and Date												AK-630-Yu Sb 8-2		
Amend.		Sheet		Doc. No.		Sign		Date						
Developed by														
Checked by														
Head of Q.C.D														
Approved by														
Orig. Inv. No.						Handle				Type	Sheet	Sheets		
										A		1		



- 1.* Dimensions ensured by tool.
2. Technical requirements for component pos.2 as per OST V 84-1602-88.
3. Mark Ш and stamp K on tag.

						AK-630 -Yu Sb 8-2 SB			
							Type	Weight	Scale
Amend.	Sheet	Doc.No.	Sign	Date	Handle Assembly drawing		A	0.650	1:1
Developed by									
Checked by									
Head of Q.C.D							Sheet	Sheets	1
Approved by									

First use	Format	Zone	Pos.	Designation			Nomenclature			Qty.	Remarks
Reference No.	A2			AK-630-Yu Sb 8-4 SB			Assembly drawing				
							<u>Documents</u>				
							<u>Components</u>				
	A3	1		AK-630-Yu 8-1			Lever			1	
	A3	2		AK-630-Yu 8-30			Plate			1	
Sign and Date											
Dupl. Inv. No.											
Alternate Inv. No											
Sign and Date							AK-630-Yu Sb 8-7				
	Amend.	Sheet	Doc. No.	Sign	Date						
	Developed by										
Orig. Inv. No.	Checked by						Type	Sheet	Sheets		
							A		1		
	Head of Q.C.D						Handle				
	Approved by										



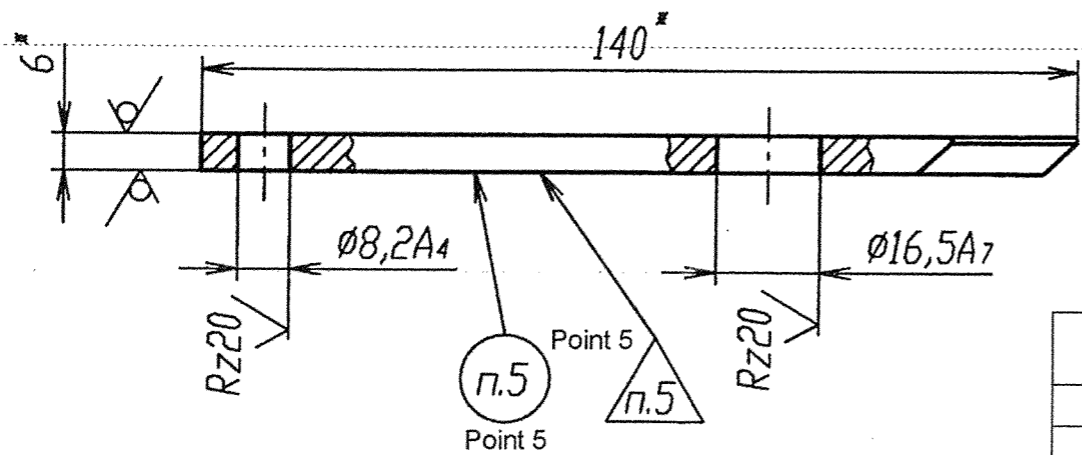
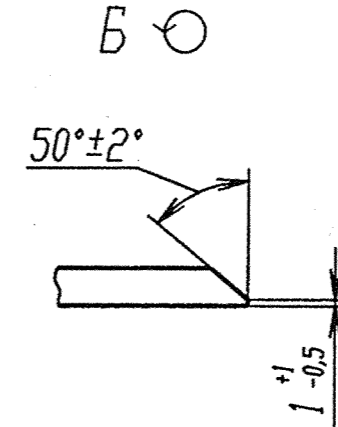
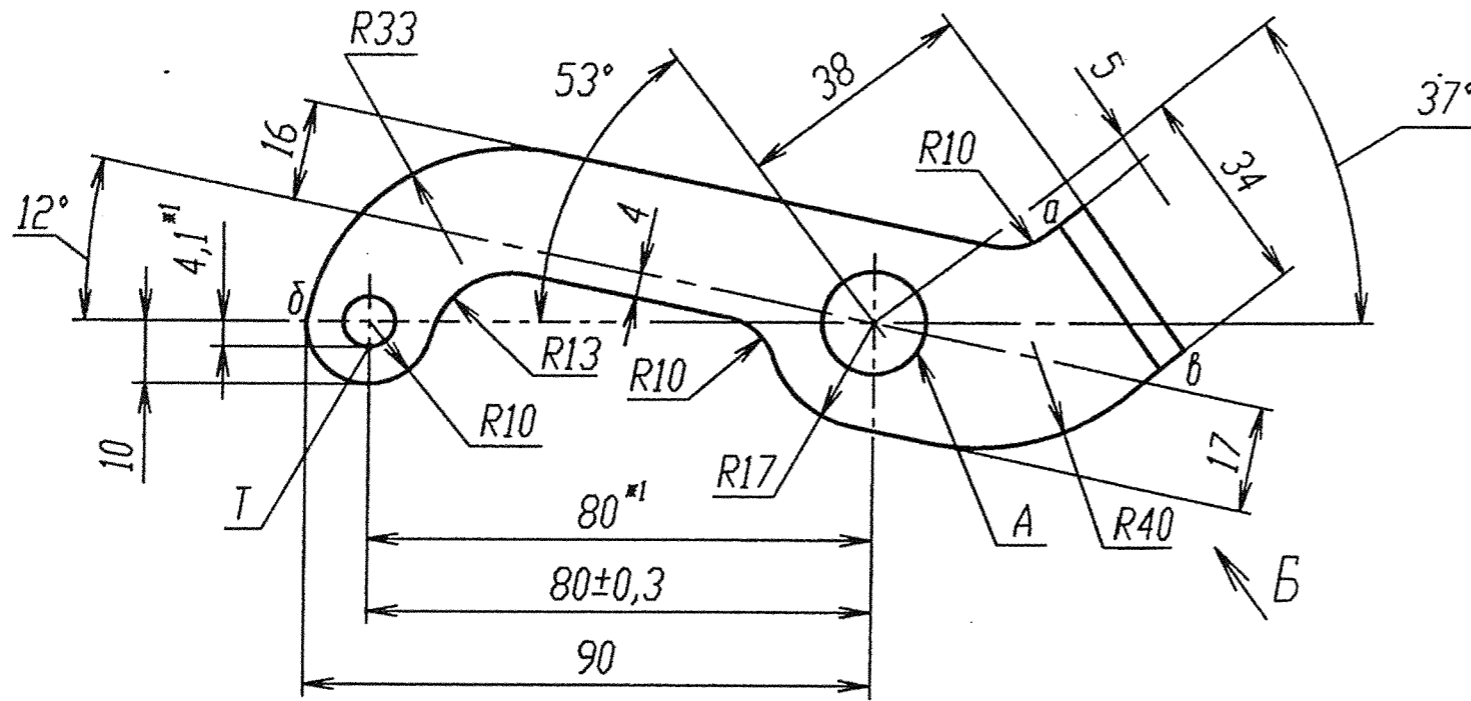
1. Argon - arc welding.
Welding rod 2.0 Sv-18KhMA GOST 2246-70.
2. 34...39.5 HRCэ.
3. * - Dimension is to be ensured by tool.
4. *1 - Dimension is given in respect of hole A and point T.
5. Straightening is permitted.
6. At the place for hardness test, it is permitted to carry out the finishing with depth up to 0.5 mm.
7. Coating: Cad 12. phos. / Varnish BF-4 with nigrogin, 1 layer. Preparation is as per OST 3-4123-78, IV, OM2.
8. Mark Ш, Ч and stamp K, И as per AK-630, AK-630M TU I.

1. Сварка аргоно-дуговая.
Сварная проволока 2,0 Св-18ХМА ГОСТ 2246-70.
2. 34...39,5 HRCэ.
3. * Размер обеспеч. инстр.
4. *1 Размер задан относительно отв.А и точки Т.
5. Допускается правка.
6. Допускается в месте испытания твердости производить зачистку глубиной до 0,5 мм.
7. Покрытие: Кд12. фос./Лак БФ-4 с нигрозином, 1 слой. Изготовление по ОСТ 3-4123-78, IV, OM2.
8. Маркировать Ш, Ч и клеймить К, И по АК-630, АК-630М ТУ I.

Инв.№ подл/Подп. и дата
 Возм.Инв.№ Инв.№ дьял. Подп. и дата
 Справ.И
 Перв. примен.

AK-630-Yu			Sb 8-7SB		
AK-630-Yu			СБ8-7СБ		
Handle			Type	Mass	Scale
Ручка			Лит.	Масса	Масштаб
Сборочный чертёж			A	0,610	1:1
Assembly Drawing			Лист	Листов 1	
			Sheet	Total Sheets 1	

Rz80
✓ (✓)

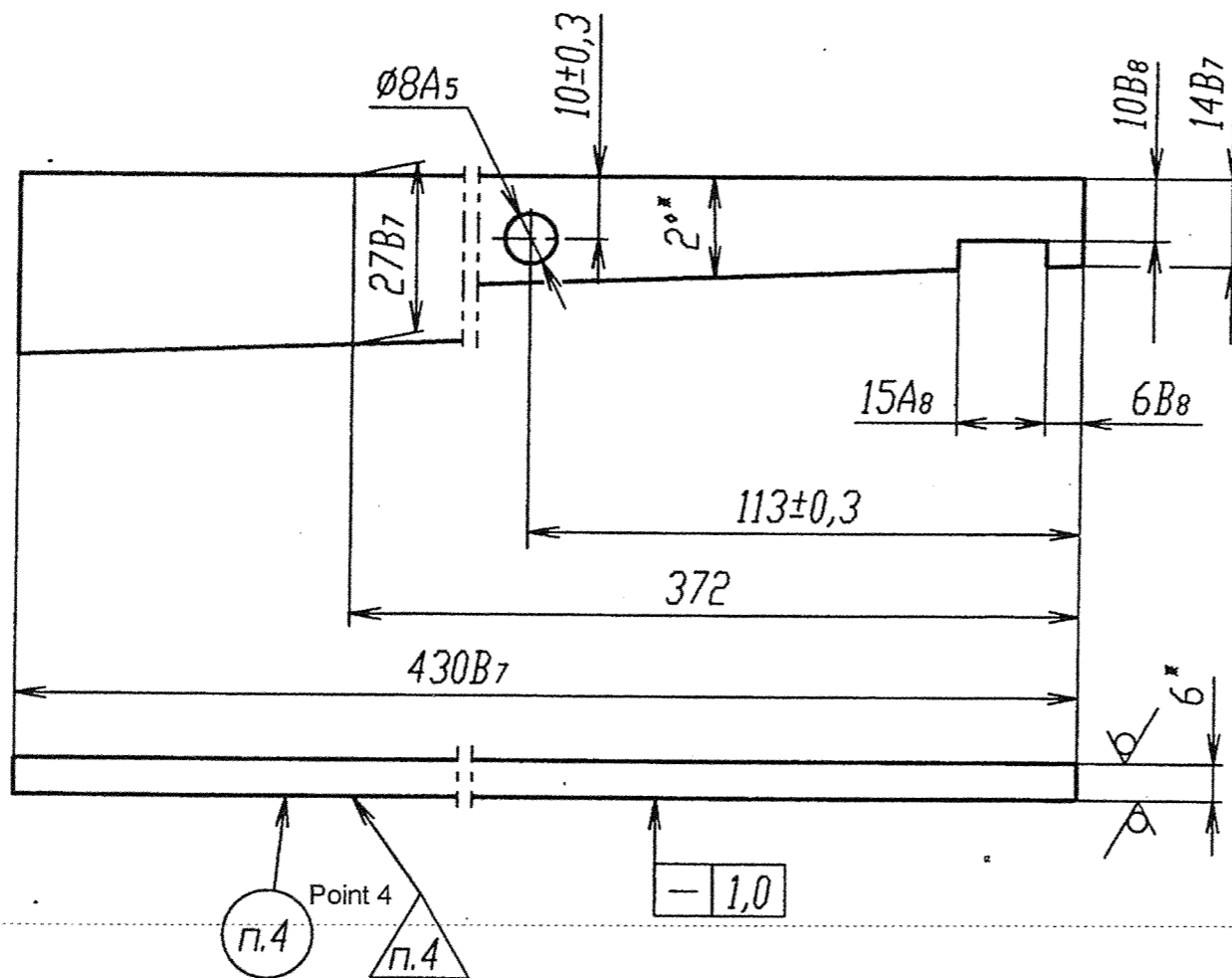


- 1.* Reference dimension.
- 2.*1Dimensions ensured by tool.
- 3.Blunt sharp edges ~0.6 mm.
4. Tolerance for contour "abva" with respect to surface "A" and point T is not more than 0.5 mm.
5. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

First use
 Reference No.
 Sign and Date
 Duplicate Inv. No
 Sign and Date
 Alternate Inv. No
 Sign and Date
 Orig. inv. no.

					AK-630-Yu 8-1			
Amend.	Sheet	Doc.No.	Sign	Date	Lever	Type	Weight	Scale
Developed by						A	0.16	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Sheet $\frac{PN - 6x1400x5000 GOST 19903 - 74}{30KhGSA - 3 - a GOST 11269 - 76}$			
Approved by								

Rz80
✓ (✓)



- 1.* Reference dimension.
- 2. Inner angles R~0.4 mm.
- 3. Blunt sharp edges ~0.6 mm.
- 4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 - Yu 8-30			
Amend.	Sheet	Doc.No.	Sign	Date	Plate	Type	Weight	Scale
Developed by						A	0.430	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by					Sheet $\frac{PN - 6x1400x5000 GOST 19903 - 74}{30KhGSA - 3 - a GOST 11269 - 76}$			

First use
 Reference No.
 Sign and Date
 Duplicate Inv. No
 Alternate Inv. No
 Sign and Date
 Orig. inv. no.

	First use					Qty.	Remarks		
	Format	Zone	Pos.	Designation	Nomenclature				
					Documents				
Reference No.	A3		AK-630-Yu Sb 8-4 SB	Assembly drawing					
				<u>Components</u>					
	A3	1	AK-630-Yu 8-23	Clevis		1			
	A4	2	AK-630-Yu 8-25	Pin		2			
Sign and Date						AK-630-Yu Sb 8-4			
	Amend.	Sheet	Doc. No.	Sign	Date				
Orig. Inv. No.	Developed by				Clevis	Type	Sheet	Sheets	
	Checked by					A		1	
	Head of Q.C.D								
	Approved by								
Sign and Date									
Dupl. Inv. No.									
Sign and Date									
Alternate Inv. No.									

First use

Reference No.

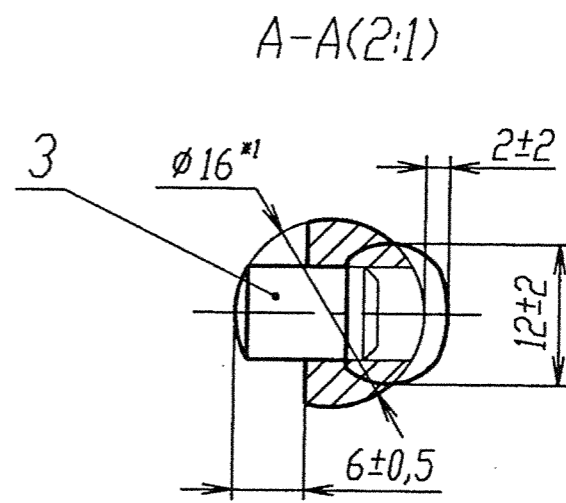
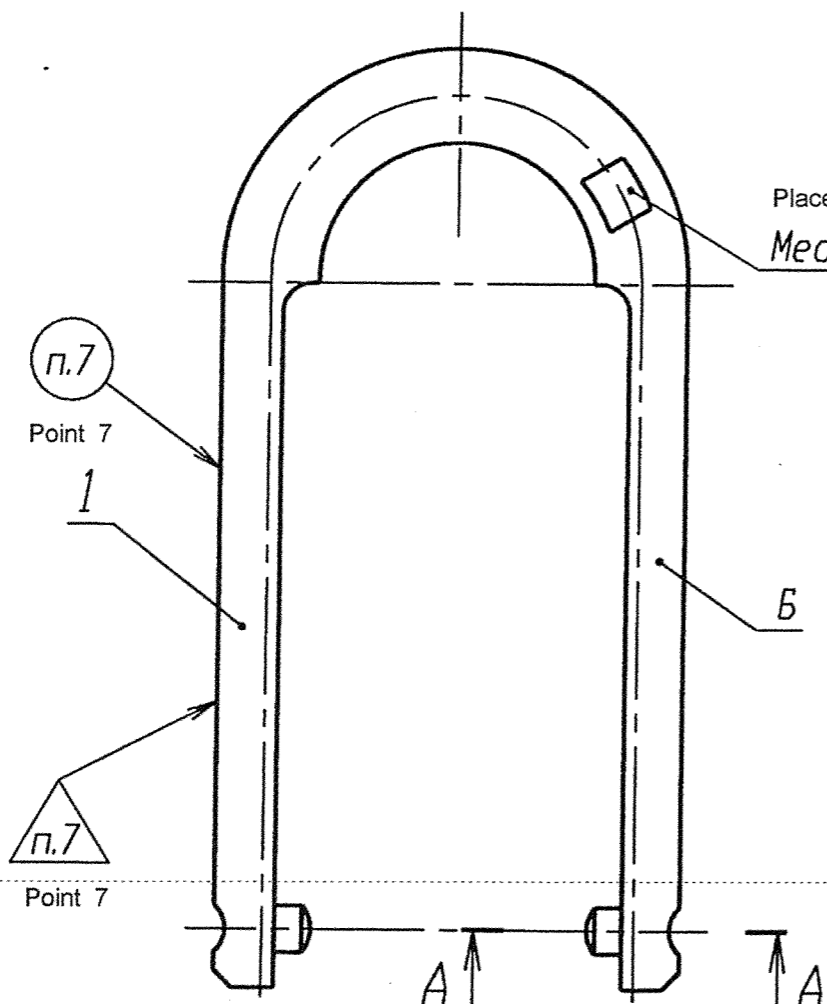
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

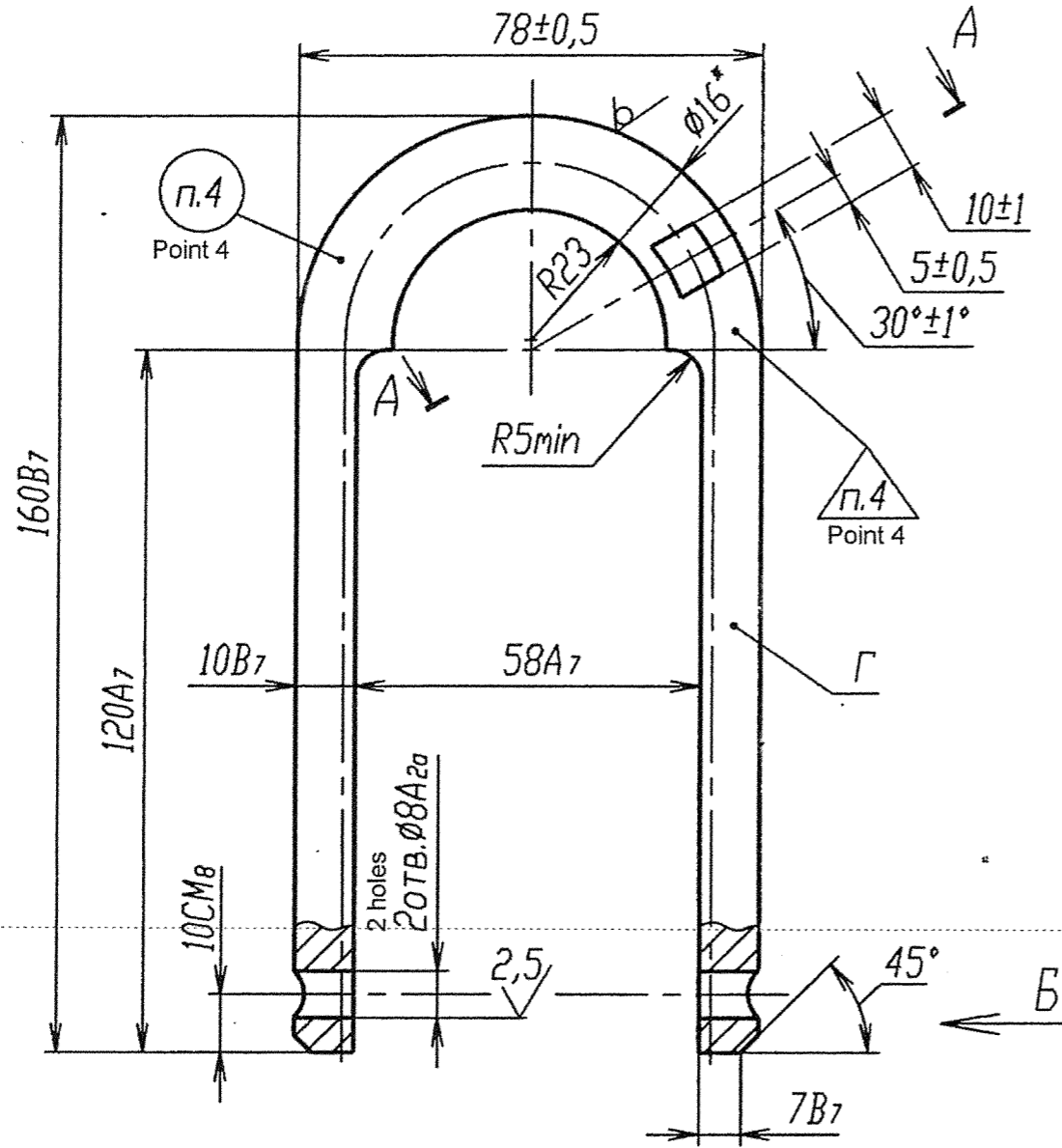
Orig. inv. no.



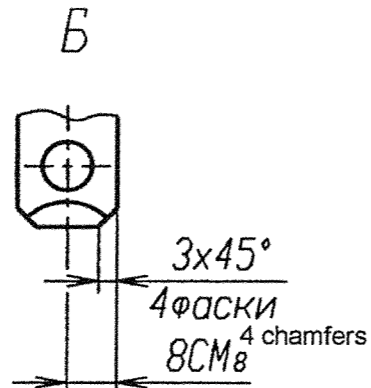
1. 34..39.5 HRC_E.
- 2.*1 Reference dimension.
3. Misalignment of plane B not more than 0.3 mm.
4. Argon-arc welding as per GOST 14771-76 Inp with wire 2 Sv-18KhMA GOST 2246-70. File the welds flush with dimension $\varnothing 16*1 R_z^{160\sqrt{}}$.
5. Hand electric-arc welding is permissible with welding rod UONII-13/55-3.0-2 GOST 9466-75.
6. Coating: Cd12.phos./ Lacquer BF-4 with Nigrosine, single coat. made as per OST 3-4123-78, IV, OM2.
7. Mark Ш, Ч and stamp К, И as per AK-630, AK-630M TU I.

					AK-630 -Yu Sb 8-4 SB			
Amend.	Sheet	Doc.No.	Sign	Date	Clevis Assembly drawing	Type	Weight	Scale
Developed by						A	0.400	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by								

Rz80
✓ (✓)



- 1.* Reference dimension.
2. Misalignment of surface "Г" is not more than 0.3 mm.
3. Blunt sharp edges ~0.4 mm.
4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.



					AK-630 -Yu 8-23			
Amend.	Sheet	Doc.No.	Sign	Date	Clevis	Type	Weight	Scale
Developed by						A	0.390	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Wheel $\frac{16-5GOST7417-75}{40Kh-V-NGOST1051-73}$			
Approved by								

First use

Reference No.

Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

AK-630-Yo 8-25

First use

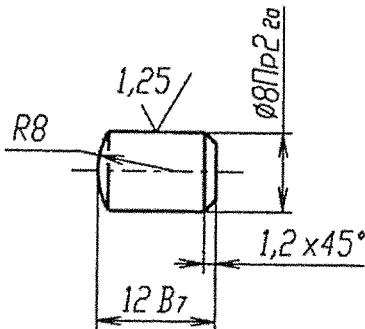
Approved by shop

Reference No.

Rz80 ✓ (✓)

Approved KTONI

Sign and Date



Approved TOSb

Dupl. Inv. No.

1. Blunt sharp edges ~0.4 mm.
2. Mark Ш, Ч and stamp K on batch tag.

Alternate Inv. No.

Sign and Date

AK-630-Yo 8-25

Approved OGMet
Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date

Type	Weight	Scale
Sheet		Sheets 1
Steel 40 GOST 1050-88		