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Instructions for marking and

certification of item assembly units and
parts

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Instructions for marking
and certification of item assembly
units and parts

Highly important assembly units and parts used for assembling units and vehicle at factories and also assembly units and parts sent as spare parts are subjected to marking.

Marking of the assembly units, and parts is performed as per instructions specified below: irrespective of the fact for which vehicles these assembly units and parts are used borrowed.

Complete number as the drawing, conventional designation as the manufacturing factory, month and year of manufacturing and serial number in compliance with the order set by the factory and approved by the customer are applied on highly important units.

The list as highly important assembly units is given in the appendix.

Highly important parts used for assembling units and vehicles are marked as per indications specified in the appendix.

During this, the marking on machined surfaces is applied in blanking shops it is transferred to the part after machining or the parts are marked by serial number (specific number) which determines the smelt number.

In addition to the technical requirements specified in the appendix highly important assembly units and parts sent as spare parts are marked by Conventional Designation as manufacturing factory and number of the part as per the drawing. Also a certificate as per drawing Y-01-2593 is made for them.

It is permitted to apply conventional number instead as complete part number, on track 765-35-2.

All the other assembly units and parts delivered as spare parts are marked by conventional designation as manufacturing factory and number of the part in convenient pieces.

Performs marking as follows:

Cast parts - Y casting;

Forged parts by die-forging;

Parts made as sheets and all types of ~~metal~~ stock by hammering. (unmachined surfaces), and by hammering or electrography or machined ~~surfaces~~ surfaces.

REMARKS:-

- 1) Never mark or apply acid stamps.
- 2) It is permitted to mark all types of blanks by hammering.
- 3) If unmachine surface is marked by hammering, electrolytic or chemical method, clean the place for marking.
- 4. If due to the design as assembly units or parts it is not possible to apply mark on them (for example absence of non-working surfaces, surfaces painted to prevent corrosion, inadequate space to mark, etc.,) the marking is applied on tag.
- Tag are made as follows:
- 1. For articles in cardboard packages (devices, electric lamps or SPTA for vehicle) the tag is made on the package.
- 2. Tie the tags with wire to units part or to a batch as parts of one nomenclature.
- 9. Separate highly important assembly units and parts, specified in the appendices should have a certificate which contains its basic technical requirements.
- 10. Place for marking the parts and assembly units is specified in the drawings.
- 11. Non-standard assembly units and parts which are used for training purposes (upon agreement with customer representative) are marked with letters "g4" height 20 to 40mm with paint which is different from the basic ~~of different colors~~ Colour of the article (black or white).
- Apply the marking where it can be seen. It is permitted to mark in 2 to 3 places.

LIST OF HIGHLY
IMPORTANT ASSEMBLY UNITS AND PARTS AS ITEM
675 SUBJECTED TO MARKING AND
CERTIFICATION.

Designation	Description	Remarks
765-117	Transmitter	
765-15-130	Right final reduction gear	Mark the designation sections as per item 3, instructions 50-6 and make a certificate -ce.
765-15-131	Left final reduction gear.	
765-12-142	Synchronizer	Mark serial No as the unit in assem- bly section and make a certificate indicating melting number for part 765-12-194.
765-12-187	Right steering gear	Mark "RH" and serial No as the crackcase and make a certifi- -cate.
765-12-188	Left steering gear	Mark "LH" and serial No as the crackcase at assembly section and make a certifica- -ce.
765-22-112	Servocontrol	Make a certificate at assembly section with serial number 765-22-114 trans- ferred on to the body.
765-22-114	Piston	Serial number is applied in mechanical shop and a certifica- -ce dimensions as is -ce.
765-22-186	Oil pump	
765-22-188	Pump	At assembly section a certificate is made with serial number 765-22-192.
765-22-189	Body	A certificate for dimension K-50A is made with serial No 765-22-192.
765-22-217	Valve rods	
765-22-227	Slide valve box	Certificate is made assembly section with serial number corres- -ponding to the body.
765-22-192	Drawing as combined machining of pump	Mark serial number as the machine shop.

Designation	Description	Remarks
765-22- 212	Regulating valve	Serial number is applied in assembly section and a certificate regulating pressure is made,
765-12-121	Gear	Apply smelting number at the forge shop. In machine shops mark serial number as the part, month and year.
765-12-630	Gear	Complete smelt number, serial number as the part, month and year are entered in the certificate indicating the number as set conventional number as smelting is applied at the forge shop.
765-32- 116	Hydraulic shock absorber	Apply designation as per item 3, instructions 4-50-6 and make certificate at machine shop. Number as the unit as per drawing and manu a starting date may not be marked or units delivered for assembling the item.
54.83.78-	Pump	Apply serial number and make a certificate.
765-38- 192	Pump of smoke-generating equipment	Apply serial number and make a certificate.
765-38- 181	Pump	
765-08- 147	Preheater reduction gear.	
765-54- 138	Gun elevating mechanism	
765-55- 132	Traversing mechanism	
765-73- 171	Bracket	Apply serial number and make a certificate.
765-73- 172	Guide rail	
765-58- 202	Hatch	Make a certificate the assembly section.
765-64- 229	Elevating reduction gear	Apply serial number at the assembly section.
765-64- 258	Rammer	Apply serial number and make a certificate at the assembly section.
765-65- 209	Feed mechanism.	For spare parts apply complete number as per drawing, serial number at the assembly section and make a certificate

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Designation	Description	Remarks
765-12-255	Shaft	Conventional designation as marking number is applied as the part are applied in machine shops and a certificate is made.
765-12-282	Right spacer	Smelting number 021 is applied on unmachined surfaces in foundry shops.
765-12-289	Left spacer	
765-12-287	Right drum	
765-12-285	Left drum	
765-15-151	Cover	
765-22-246	Valve	Serial number as the marking body and code designation as marking hole are applied in the machine shop. Certificate for dimension is made.
765-22-262	Slice valve	Serial number as marking piston 765-22-114 is applied in machine shop. Certificate for dimension 222 is made.
765-22-325	Slide valve	Serial number as marking body is applied in machine shops. A certificate for dimensions 18 is made.
765-57-103	Upper turret race	Serial number and code is applied on parts present for assembly. Number as the drawing conventional designation-manufacture are applied on parts to be used spare parts. Heights 5mm, depth is 0.5 mm.
765-57-21	Lower turret race	
765-12-194	Cone	Conventional designation as smelt number is applied on the blank in machine shops conventional designation as the marking number is applied in machine shop.
765-22-220	Gear	Serial number of marking 765-22-189 is applied in machine section and a certificate for dimension 30 is made.
765-22-221	Gear	

Designation	Description	Remarks
765-78-533	Air pressure control unit with moisture and oil separator	A ply serial number and make a certificate.
765-78-281	Compressor with water drainage pump	
765-78-363	Blower rotor	
625300M-K	Valve	Apply serial number and make a certificate.
625300M-K1	Valve	
765-12-553	Driven drum	
765-12-283	Gear	Apply smelting number at the forge shop. Apply conventional serial number month and date of manufacturing in machine shop. Make an entry as the complete smelting number, serial number is the partm month and year of manufacturing, in the certificate. In case is the serial number is sheared off while machining conventional designation as the smelting may be applied.
765-12-103	Shaft	
765-12-115	Gear	
765-12-119	Gear	
765-12-123	Gear	
765-12-126	Gear	
765-12-127	Gear	
765-12-30	Gear	
765-12-193	Clamp	
765-12-196	Gear	
765-12-197	Gear	
765-12-198	Gear	
765-12-199	Gear	
765-12-200	Coupling	
765-12-201	Gear	
765-12-205	Gear	
765-12-225	Coupling	Apply conventional designation as the smelting
765-12-226	Coupling	REMARK:
765-12-284	Gear	In case if the place marking is complete smelting number is limited conventional smelting number in forge shops applied.
765-12-309	Carrier	
765-12-310	Support ring	
765-12-311	Satellite	
765-12-401	Right shaft	
765-12-402	Left shaft	
765-12-438	Coupling	
765-15-156	Carrier	
765-15-5	Satellite	
765-15-152	Drive shaft	
765-15-17	Coupling	
765-15-157	Body	
765-12-514	Lower half gear case	Smelting number is applied.
765-12-523	Upper half gear case	(1) Unmachined surfaces in foundry shops. Serial number of set 765-12-3 is applied in machine shops and certificate is made.

Designation	Description	Remarks
765-22-272	Slide valve	Serial number 39 the mating body and code number as the meter hole are applied in the machine shops. Actual dimension 188 is entered in certificate for the body.
765-22-329		
765-22-113	Body	Serial number as the part and code number as the hole is applied in the machine shops.
765-22-261	Body	Number of smelting is applied in the foundry shop.
765-15-2	Right cover	Number as smelting is applied in foundry shop for spare parts the number may be applied on the front surface with paint.
765-15-147	Left cover	
765-16-15	Driving sprocket-rim	Conventional designation as smelting is applied in the foundry shop.
765-16-4	Internal disc	Number of the part and number of smelting are applied in the foundry shop as conventional number as smelting may be applied.
765-16-8	External disc	
765-31-25	Internal disc	Conventional designation as smelting number is applied in the foundry shop.
765-31-26	External disc	
765-31-50	Crank	
765-33-43	Arm	
765-33-44	Arm	
765-32-83	piston	Conventional designation as smelting number is applied in the forge shop. After machining the conventional designation of smelting number is applied machine shop.
765-35-2	Track	Number as the part, smelting number, number as the forging batch and conventional designation of the manufacturing factory are applied in the forge shop. Conventional designation as smelting number and drawing number of the part - 765 may be applied.

Designation	Description	Remarks
765-33-42	Torsion bar	Smelting number is applied in the forge shop. After machine conventional designation of manufacturing factory and manufacturing date are applied in the machine shop. Conventional smelting number and conventional designation as the manufacturing factory may be applied.
765-35-20	Link	Conventional designation as the smelting number is applied in the forge shop
765-35-21	Wedge	
765-36-167	Body	Drawing number of the part and smelting number are applied on unmachined surfaces in foundary shops.
765-36-87	Gear	Serial number as the part is applied in the machine shops and a certificate is made.
765-36-184	Gear	
765-05-325	Tank	Designation in completion with item 3, instructions 1-50-6 is applied at assembly section and a certificate is made.
765-06-314	Oil tank	
765-10-300	Ejector	
765-10-692	Arcleaner	
765-10-2234	Clamp	Certificate indicating actual clearance, 0.1mm, and clearance 0.015 to 0.073 is made in the machine shop in compliance with the certifying data of completing machine parts.
765-10-2235	Ring	Certificates indicating actual dimension 66 are made in the machine shops.
765-10-2225	Hinge	Certificates indicating actual dimensions 80 are made in the machine shops.
765-10-2233	Hinge	

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Production	Description	Remark
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765-10- 573	Machgold	Certificates indicating clear pace 0.015 to 0.073 in the machine in machine stop in accordance with the certificate is as completed parts.
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765-1-2222	Clamp	Certificates indicating several clear items 00 and 188 in the machine and left space as in the certificate of view the same in the machine shop
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765-70-1070	Gear	Serial number in the machine is applied in machine stop and a certificate is in the machine
765-70-1051	Gear	
765-70-1092	Gear	

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LIST AS ASSEMBLY UNITS / SUBJECTED TO
CERTIFICATION WHEN SENT AS SPARE PARTS.

Designation Description Remarks

755-06-07513	Pre-heater boiler	
755-08-0147	Pie heater reduction gear	
755-10-015	Ejector	
755-10-0129	Air cleaner	
755-10-01502	Ejector	
755-10-0542	Valve box	
755-10-0543	Valve box	
755-10-0552	Cylinder	
755-10-0567	Ejector	
755-10-0117	Transformer	
755-12-01142	Synchronizer	
755-12-01157	Right steering gear	
755-12-01186	Left steering gear	
755-12-01130	Right final reduction gear	
755-15-01131	Left final reduction gear	
755-22-01185	Pump	
755-22-0217	Valve	
755-22-0227	Slide valve	
755-22-01185	Disengaging mechanism	
755-32-0116	Hydraulic shock absorber	
755-35-0114	Pump	
755-35-0162	Pump	
755-54-0133	Smoke-generating equipment	
755-54-0132	Elevating mechanism	
755-55-0132	Transverse mecha. dir.	
755-62-013	Round-feed mechanism	
755-64-0229	Elevating reduction gear	
755-64-0289	Rammer	
755-65-0209	Feeding mechanism	
755-71-0574	Plunger	
755-78-0281	Compressor with water drainage pump	
755-78-0283	Pump	
755-78-0533	Air pressure control unit with oil-end moisture-seperator	
755-78-0794	Cylinder	
755-78-0814	Pump	
755-17-0101	Steering column	
755-17-0306	Disengaging mechanism	
625-30CH-K	Valve	
325-30CH-K	Valve	
755-57-0103	Upper current race	
755-57-021	Lower current race.	

The certificates are filled and the assembling section was sent along with the assembly units.