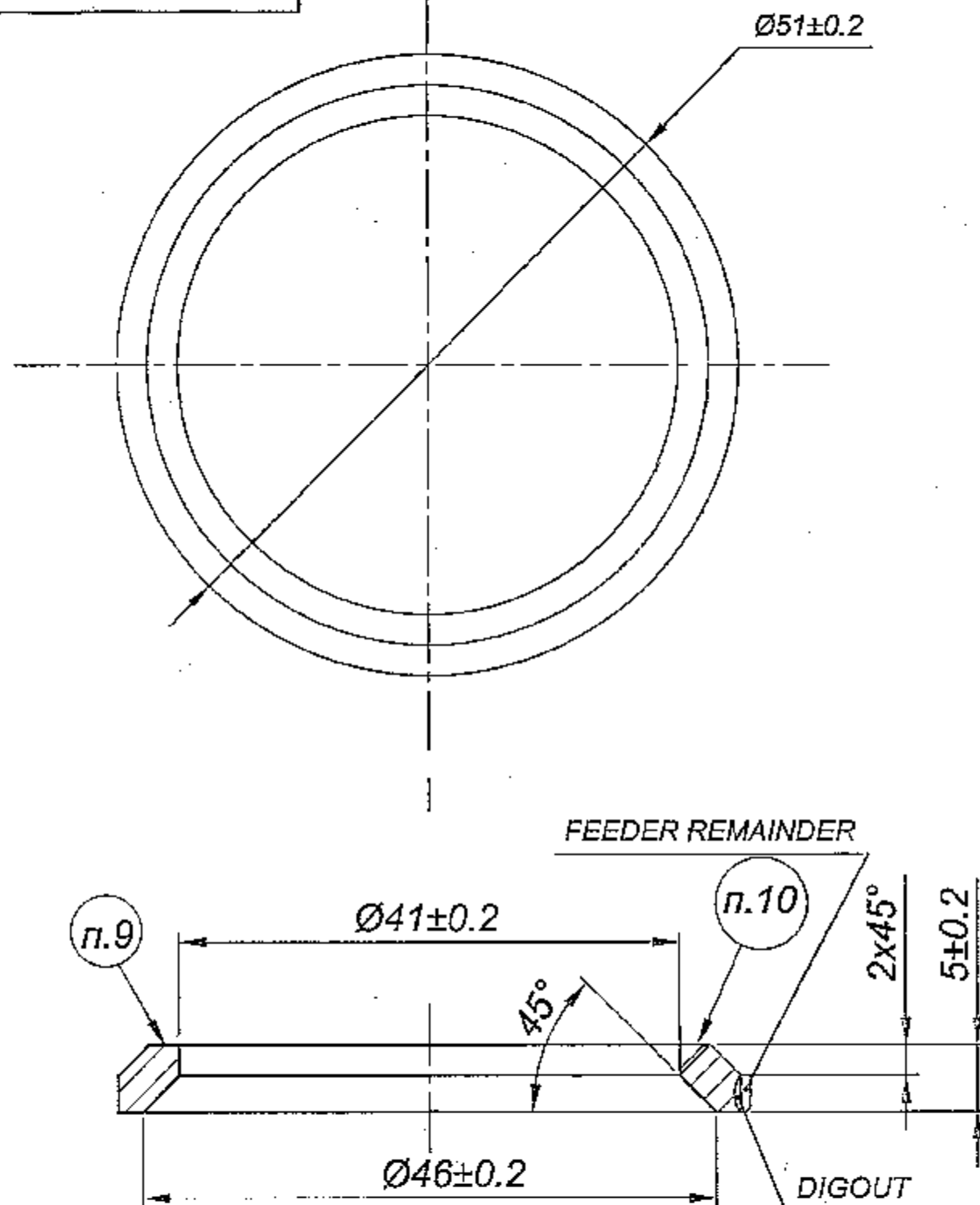


DRAWING NUMBER

306-52

SHEET No. 1 OF 1



1. Casting as per pattern.
2. 43...51 HRC₃.
3. Unspecified casting radii upto 0.5 mm.
4. Unspecified casting draft upto 1°.
5. Casting accuracy 5T-5-8-5 GOST 26645-85.
6. The following are permitted:
 - a). Cutting -out of the body of casting in the place of runner with depth not exceeding 0.3 mm is allowed, remaining undressed runner should not be bigger than 0.5 mm.
 - b). Short-run of edges on $\varnothing 51$ should not exceed 0.5 mm.
 - c). Clean sandy cavities occupying not more than 10% of a total surface of casting.
 - c). Separate clean cavities in quantity of 5 pieces not bigger than $\varnothing 1$ mm and up to a depth of 0.5 mm maximum, distributed over a distance of 10 mm minimum from each other.
7. The following are not allowed:
 - a). Metal overflow and Burrs on the diameter 41 mm.
 - b). Deep cracks, non-homogenous body.
8. Surface of casting should be cleaned from the reminders of ceramics by sand blasting.
9. Stamp letter K on the tag with Letter type 3-Пp GOST 26.008-85.
10. Mark the seat number with Letter type 3-Пp GOST 26.008-85.
11. Remaining requirment are as per TY-7591-008-08629387-2000.

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

EST. WT. (Kg) 0.022 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.

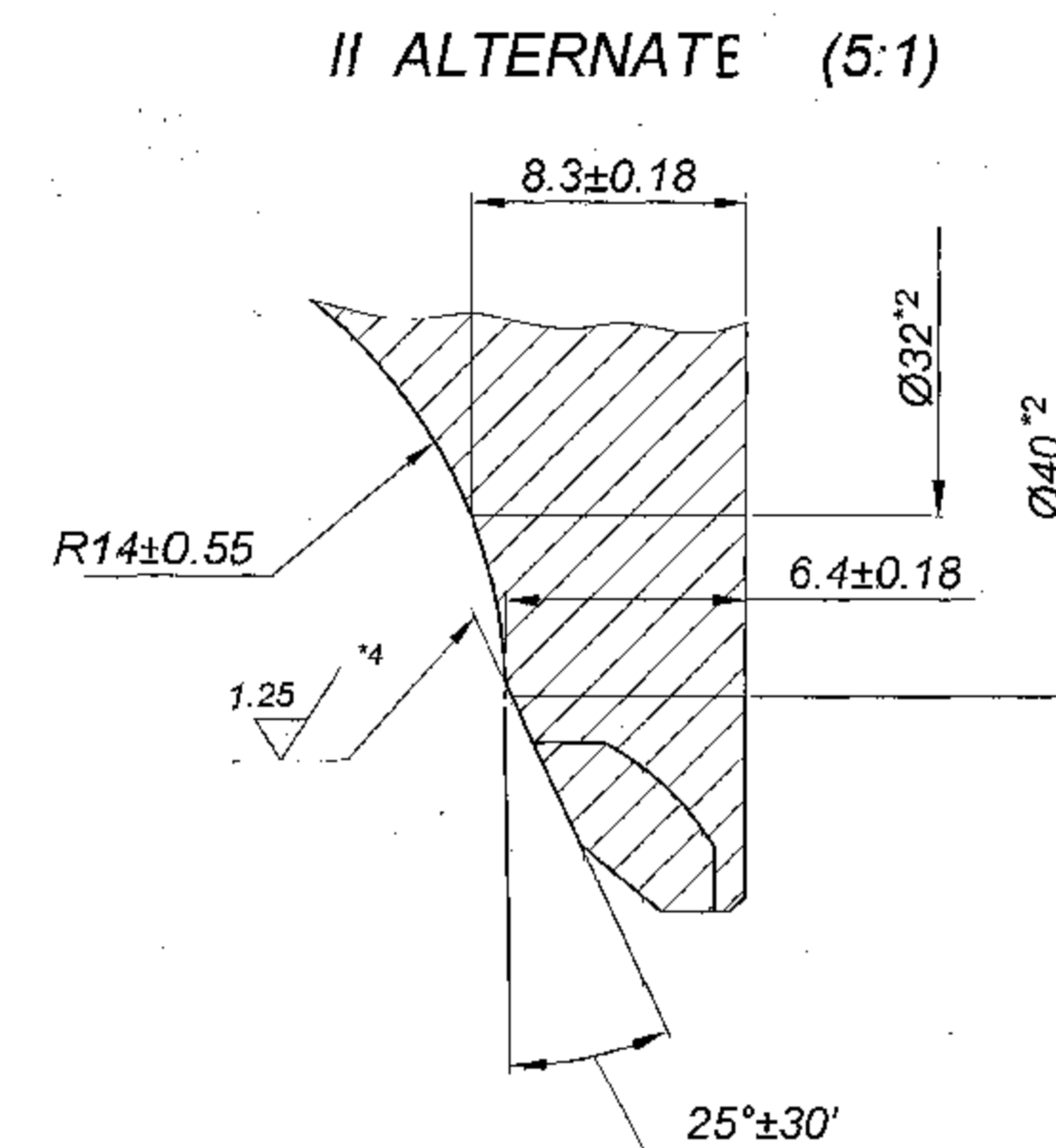
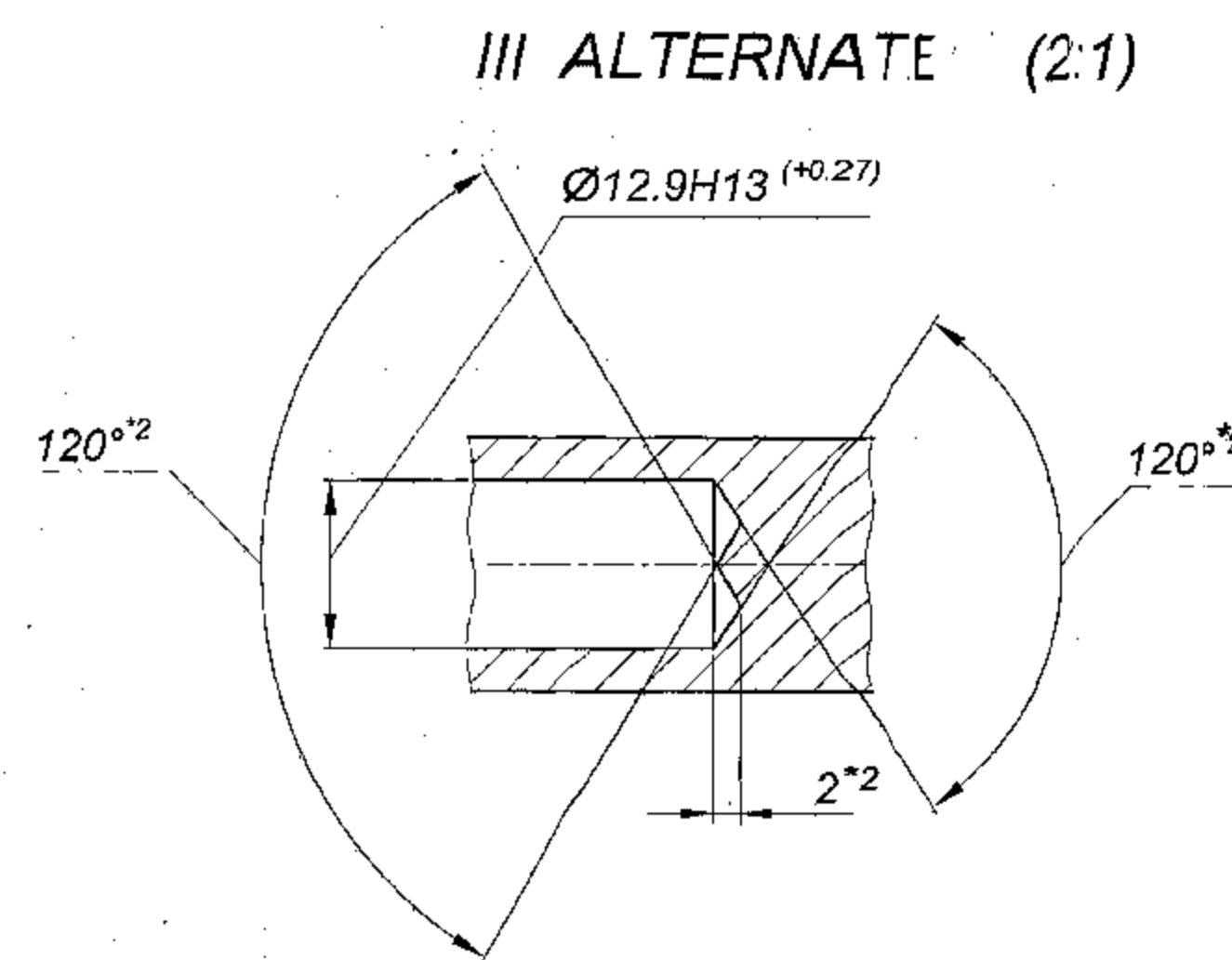
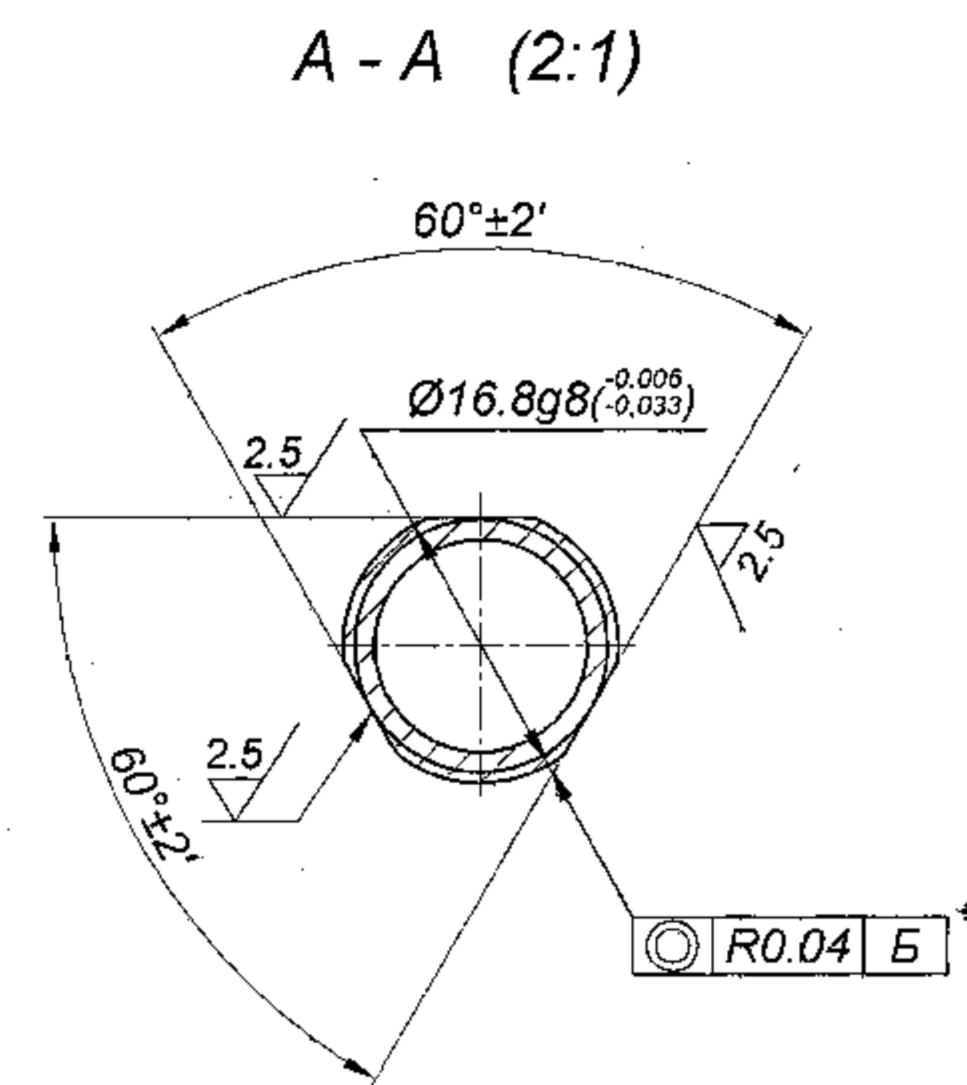
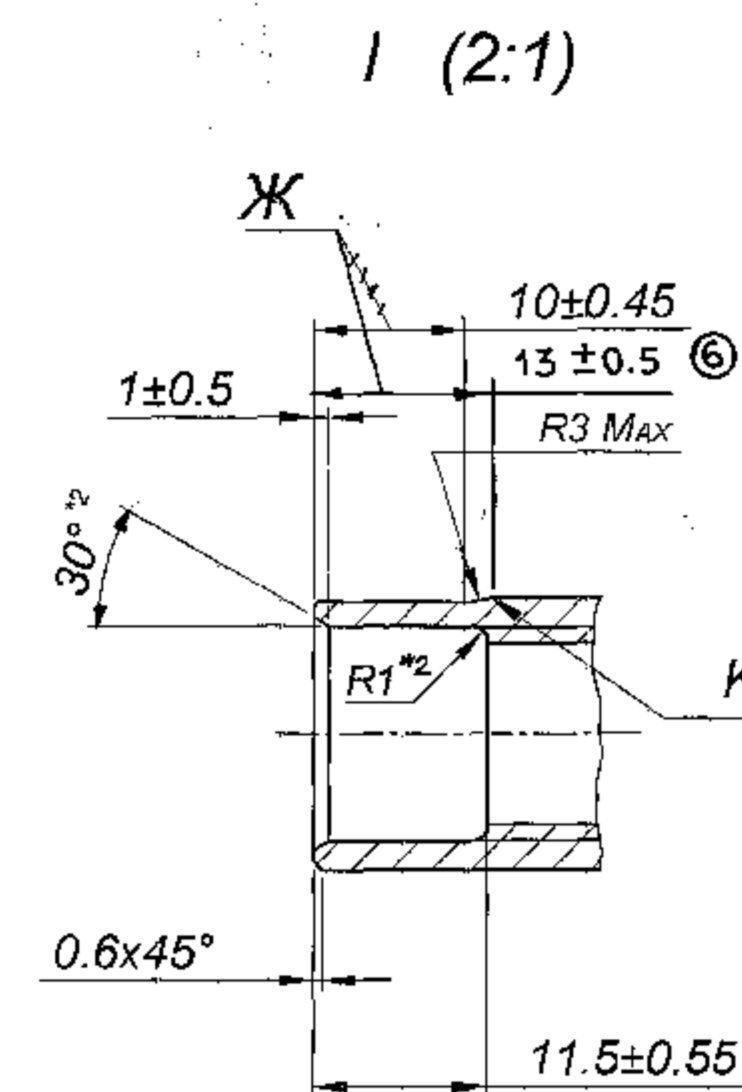
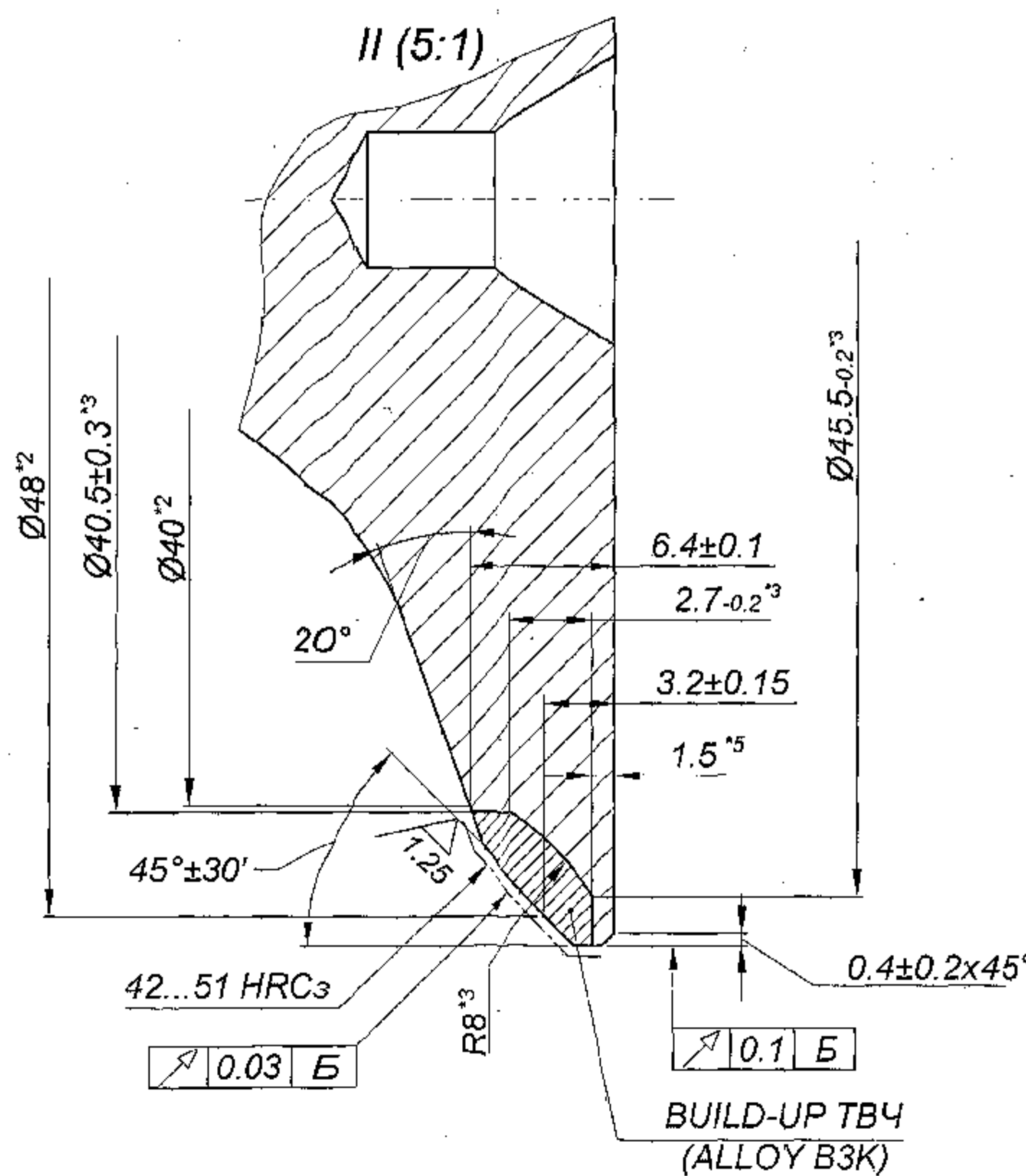
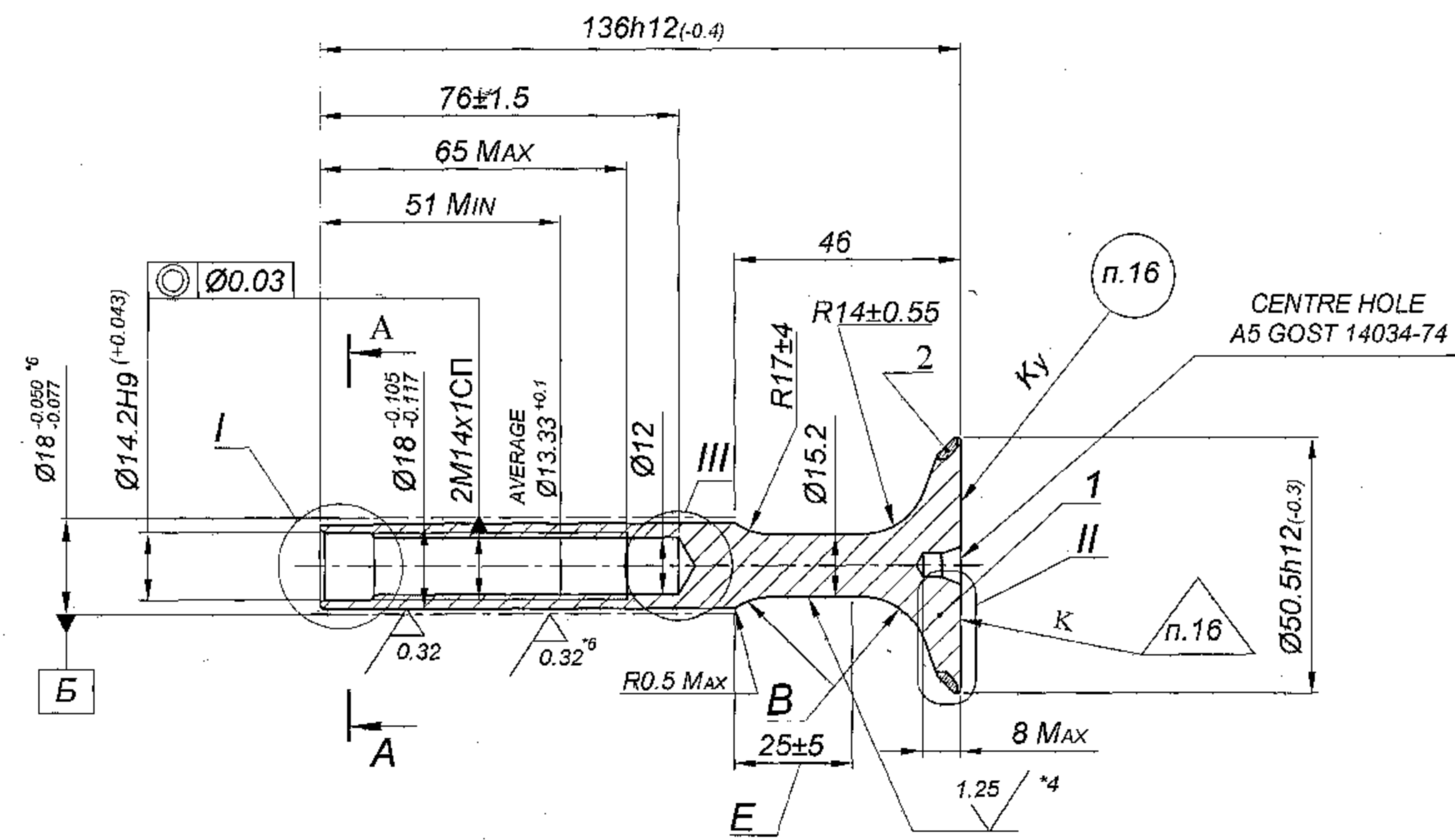
DRN		MATERIAL:-	USED ON:-
CHD		ALLOY B3K	CB 306-51-01
APPD		TY 4591-008-08629387-2000	
DATE	02/2/09	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE:-	2:1	AVADI	
DIMENSIONS IN mm		TITLE:-	ADDITIONAL RING
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69			
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
			306-52

ISSUE	DATE	NATURE OF AMENDMENTS

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 6

F-3
98
166

SIZE A3



1. Inspection group II as per TT-11.
2. 255-302 HB except the places specified separately
3. Direction of grains in longitudinal section should correspond with external contour of forging with out loop and breaks as per set standard, breaks of grains is permitted in the zone metal building.
4. Metal building is carried out as per instruction VI-YITM3-126-91.
5. Chromium plating of surface B X Hardness: 21 as per VII-154-75. After plating tempering is carried out.
6. Unspecified limit deviation of dimensions in machining: $H14, h14, \pm \frac{IT14}{2}$
7. Technical requirement for thread are taken as per standard 82021-00.
8. On the surface of chamfer- pores, cavity, cracks and Non-metallic inclusions are not allowed.
9. Check the following dimensions with set gauges:
Diameter of flattened spots - 16.853 mm.
Diameter of hole - 17.962 mm.
Angle between flats - $60^\circ \pm 2$.
10. Polish the surface 'B'. On edges burrs and chromium splashes are not allowed.
11. Edge 'K' to be dressed, polished as per standards.
12. Acceptance of part after final Heat-treatment to be carried out as per TTM 56-78.
13. Chromium -plating is permitted on the length 'E'. Remaining surface of valve head section K and internal surface are to be protected.
14. Check the part on magnetic defectoscope. Technical requirement and acceptance rules are as per TT IB-17.
15. Roller burnish the surface 'B' before Chromium-plating by roller $\phi 30 \dots 35$ mm, radius at the top of the roller is $R=4 \dots 1$ mm, load on the roller should be $80 \dots 130$ kg feed 100 mm per minute. Polishing is permitted.
16. Stamp by Electro-chemical method as per instruction PM-32 or Electro-sparking method, and mark 'X'.
17. ^{*2} Dimension to be ensured by tool.
18. ^{*3} Dimension to be ensured before building up.
19. ^{*4} Accept as per inspection specimen.
20. ^{*5} Dimension is given for reference.
21. ^{*6} Dimension and roughness after plating.

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

EST. WT. (kg) 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 OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

DRN	APD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69	ALL THREADS TO CONFORM TO	TITLE	D S CAT NUMBER	DRAWING NUMBER
CHD	APD	02/03/02	1:1				EXHAUST VALVE ASSY		Cb.306-51-01
MATERIAL	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI								
USED ON:-	C6 306-07-12								
ISSUE	DATE	NATURE OF AMENDMENTS							
6	20.11.08	NOTN. NO. 2002-379 (F-158)							



USED ON

ITEM No.

DRAWING NUMBER

D S CAT NUMBER

DESCRIPTION

QTY

REMARKS

Cb.306-51-01

EXHAUST VALVE ASSY

ITEM LIST

1

306-50-10

EXHAUST VALVE

N.D

STEEL 40X10C2M

TY 14-1-3092-81

1

2

306-52

ADDITIONAL RING ✓

1

NOT CREATED BASED ON RUSSIAN ORIGINAL ISSUE - 4

Cb. 306-07-12

ISSUE

DATE

NATURE OF AMENDMENTS

ISSUE

DATE

NATURE OF AMENDMENTS

F - 3

90/166

DRN

Sub

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.

CHD

R. B. ...

TITLE :

EXHAUST VALVE ASSY

APPD

...

DATE

14.5.07

SHT. NO. 1 OF 1

D S CAT NUMBER

ITEM LIST FOR
Cb.306-51-01