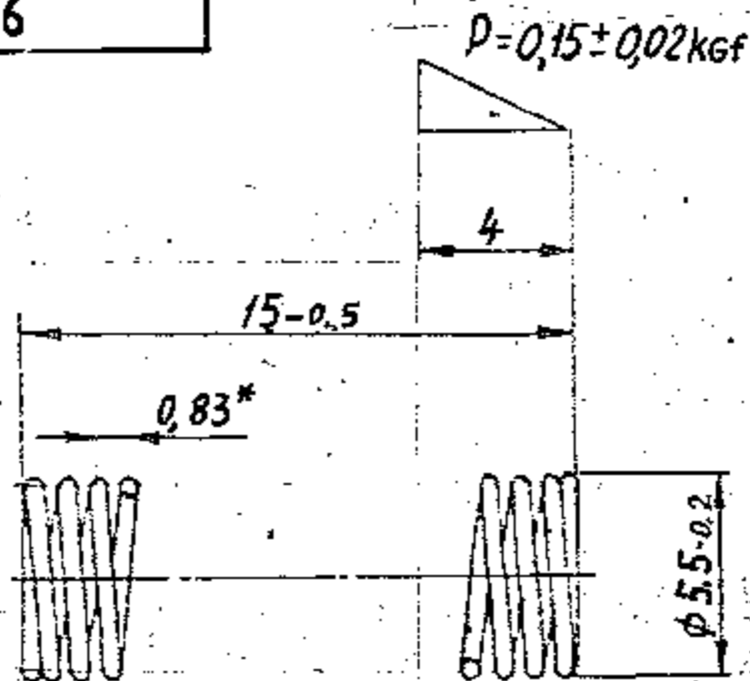




DRAWING NUMBER
1227-76



1. TOTAL SPRING LENGTH L IS APPROXIMATELY 270 mm.
2. NO. OF WORKING COILS - 15.
3. TOTAL NUMBER OF COILS - 17.5.
4. COILING DIRECTION IS ARBITRARY.
5. RESIDUAL DEFORMATION IS NOT ALLOWED, AFTER THE SPRING IS COMPRESSED TO BRING THE COILS IN FULL CONTACT WITH ONE ANOTHER.
6. EXTERNAL DIAMETER OF BEARING COILS MAY BE INCREASED UP TO 5.7 mm.
7. WIRE LAMINATION IS NOT ACCEPTABLE WHEN THE MANUFACTURED PART IS TESTED FOR TWISTING.
8. COATING: CHEMICALLY OXIDIZED, OILED.
- 9.* DIMENSION IS GIVEN FOR REFERENCE.

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

EST. WT. 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 INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

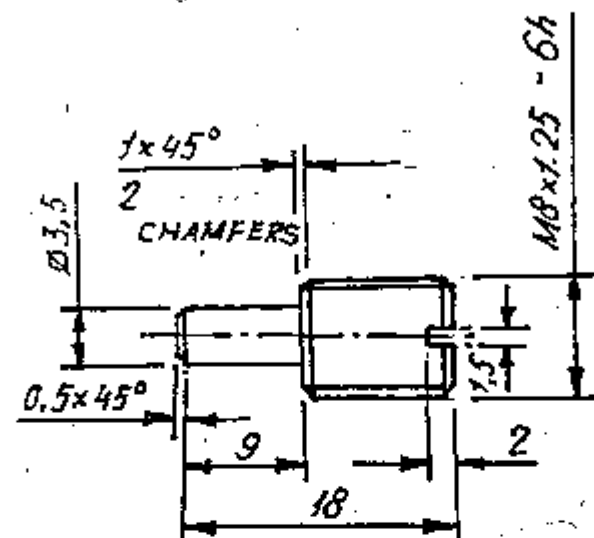
DRN	<i>[Signature]</i>	MATERIAL:- WIRE II -0.5	USED ON
CHT	<i>[Signature]</i>	GOST 9389-75.	CB 20-29-59
TCB	<i>[Signature]</i>	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES) AVADI	
APPD	<i>[Signature]</i>		
DATE	30-12-87	TITLE	
SCALE:-	5:1	SPRING	
DIMENSIONS IN mm		D S CAT NUMBER	DRAWING NUMBER
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS:2102-69			
ALL TREATMENTS TO CONFORM TO		1227-76	
ISSUE DATE	NATURE OF AMENDMENTS		





DRAWING NUMBER

3314-65



1. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS: FOR HOLES - AS PER A7
SHAFTS - AS PER B7,
OTHERS - AS PER C7

2. COATING: CHEMICALLY OXIDIZED/OILED.

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

EST. WT. TO BE STAMPED OR MARKED WHERE INDICATED THIS \equiv 1 LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE & INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

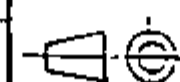
DRN *R. S. S. S.*
CHK *Y. S. S. S.*
TIC *R. S. S. S.*
APPR *R. S. S. S.*
DATE 17-3-90
SCALE - 2:1

MATERIAL:-
45 GOST 1050-74

USED ON
SE. 20-29-59

CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES)
AVAJI

DIMENSIONS IN mm
TOLERANCE ON DIMS
UNLESS OTHERWISE
STATED IS: 2102-69



TITLE

SCREW

ALL THREADS TO
CONFORM TO

D S CAT NUMBER

DRAWING NUMBER

3314-65

ISSUE DATE | NATURE OF AMENDMENTS

SIZE A3



DRAWING NUMBER
CB 20-29-59

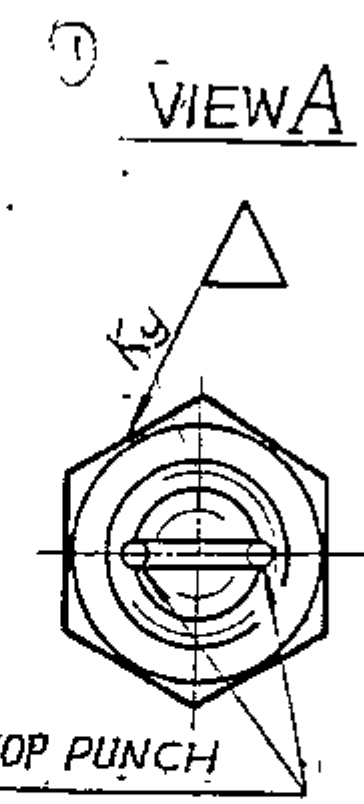
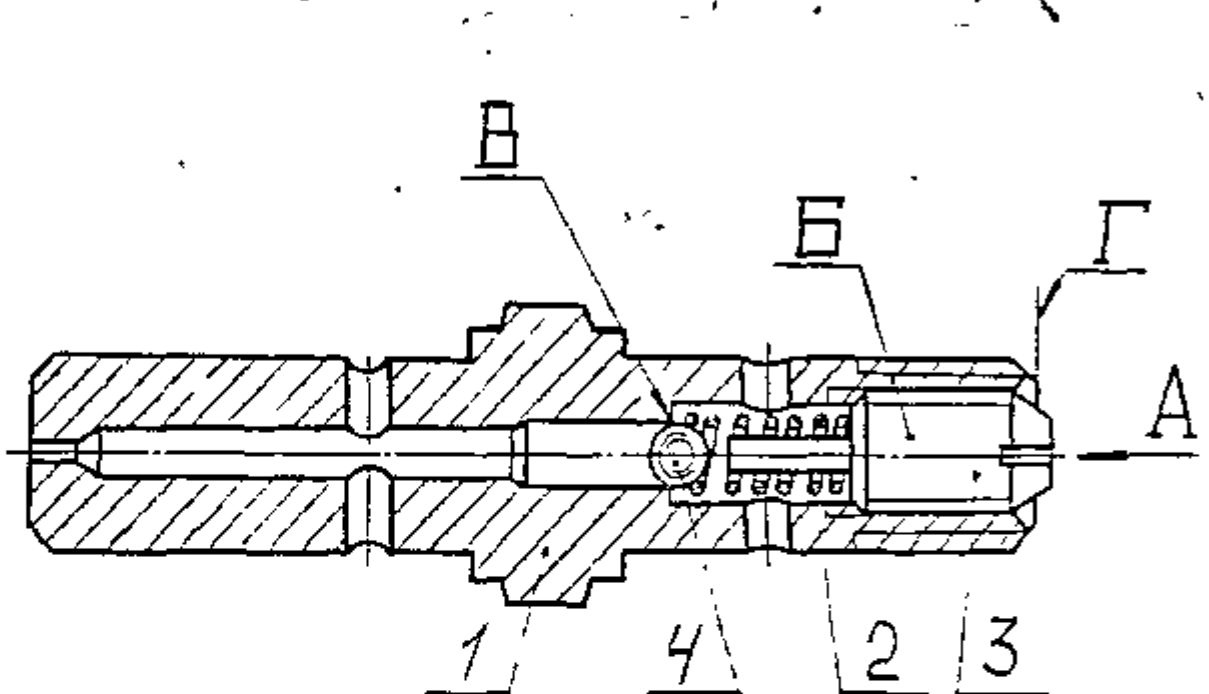
EXPLANATORY NOTE : FOR ITEM No: 4

MATERIAL BALL 5 $\sqrt{5}$ mm
 P, GOST 3722-60.

CHEMICAL COMPOSITION : % AS PER GOST 801-78

Gde	C	Si	Mn	Cr	S	P	Ni	Cu	Ni&Cu
WXTS	0.95-1.05	0.17-0.37	0.20-0.40	1.30-1.65	M A X I M U M				
					0.20	0.027	0.30	0.25	0.50

ULTIMATE TENSILE STRENGTH Kgf/cm^2 60-73
 (GOST 4727-83)



1. BLUNT SHARP EDGE B USING A BALL UNTIL A CHAMFER IS OBTAINED.
2. TURN SCREW 2 TILL IT IS ALIGNED WITH PLANE Γ OF BODY 1, THEN BACK OUT THE SCREW THROUGH ONE REVOLUTION.
3. SUBJECT THE VALVE TO A PRESSURE TEST FROM THE SIDE OF THE SPRING, THE VALVE BEING IN THE HORIZONTAL POSITION FEEDING DIESEL FUEL UNDER A PRESSURE OF 0.05 TO 0.15 MPA (0.5 TO 1.15 KGF/CM^2) FOR TWO MINUTES.

4. STOP PUNCH AFTER CHECKING (SEE VIEW A)

KVD No-63504

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION		DATE	17-3-90	MATERIAL:-	USED ON	CB 20-29-00-8
EST. WT.	TO BE STAMPED OR MARKED WHERE INDICATED THIS \neq ! LETTERS!	SCALE	2:1	CONTROLLER OF QUALITY ASSURANCE-HEAVY VEHICLES		
0.045 kg.		DIMENSIONS IN mm		AVADI		
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SEE INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE		TOLERANCE ON DIMS	UNLESS OTHERWISE STATED IS: Z162-69	TITLE NON-RETURN VALVE ASSY.		
		ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER	
		6 - 1432-B1			CB 20-29-59	
		5 - 890-2B				
		ISSUE DATE	NATURE OF AMENDMENTS			

SIZE A3



USED ON
CB 20-
29-00-8

ITEM	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	No. OFF	REMARKS
	CB 20-29-59		NON-RETURN VALVE		
	8: ITEM LIST		ASSY		
			<u>DETAILS</u>		
1	20-29-64		NON-RETURN VALVE		
			BODY.	1	
2	1227-76		SPRING	1	
3	3314-65		SCREW	1	
			<u>STANDARD ITEMS</u>		
4.			BALL 5 X 5mm		For Matl. Details
			P QOST 3722-60	1	See Assy Drg.

ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS

DRN	<i>[Signature]</i>	CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI			
CHO	<i>[Signature]</i>	TITLE: NON-RETURN VALVE ASSY.			
TCD	<i>[Signature]</i>	D S CAT NUMBER		ITEM LIST FOR	
APPD	<i>[Signature]</i>	SHT. No. 1 OF 1		CB 20 29-59	
DATE	17-3-90				

