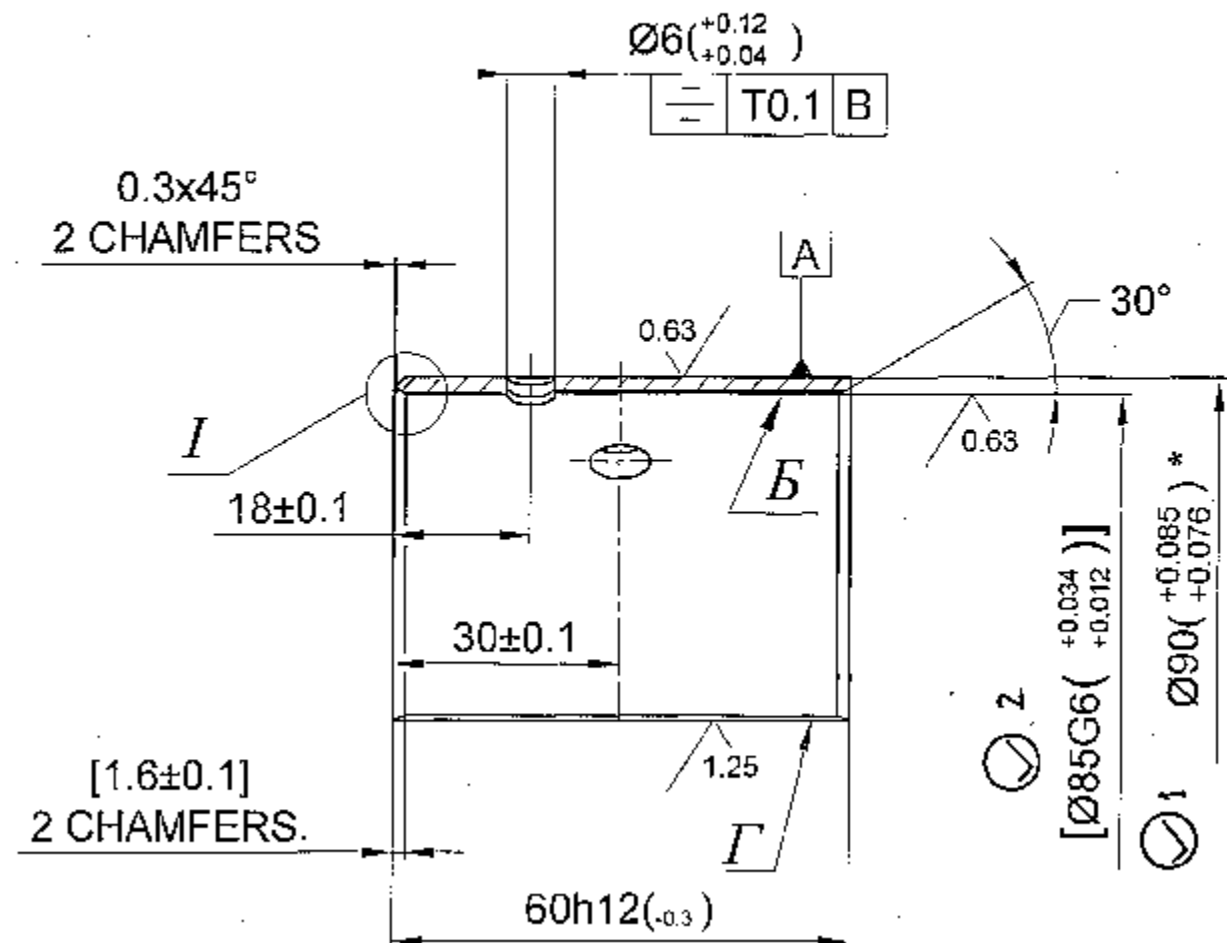
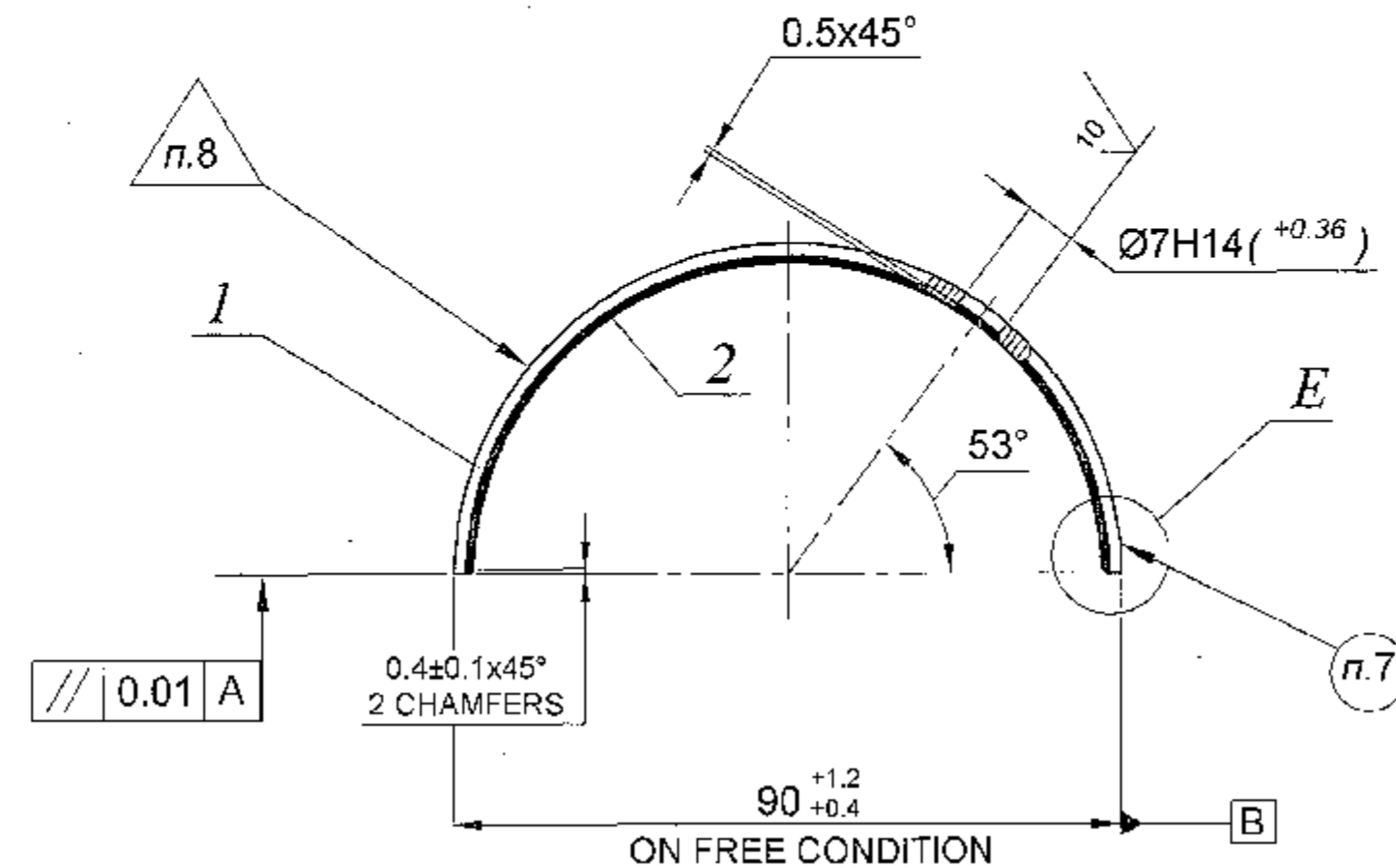


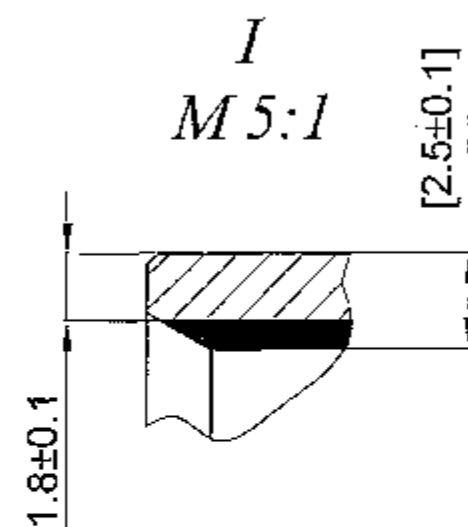
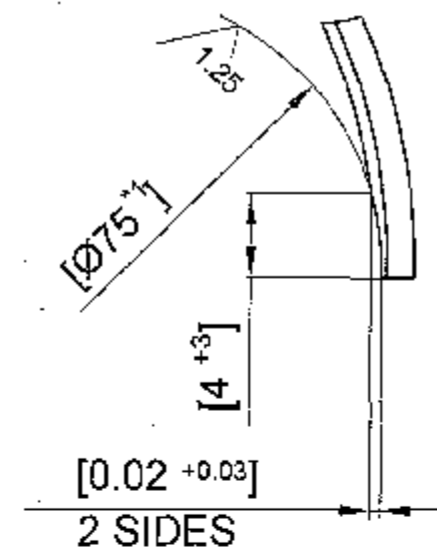
DRAWING NUMBER  
Cb 3304-25

SHEET No. OF



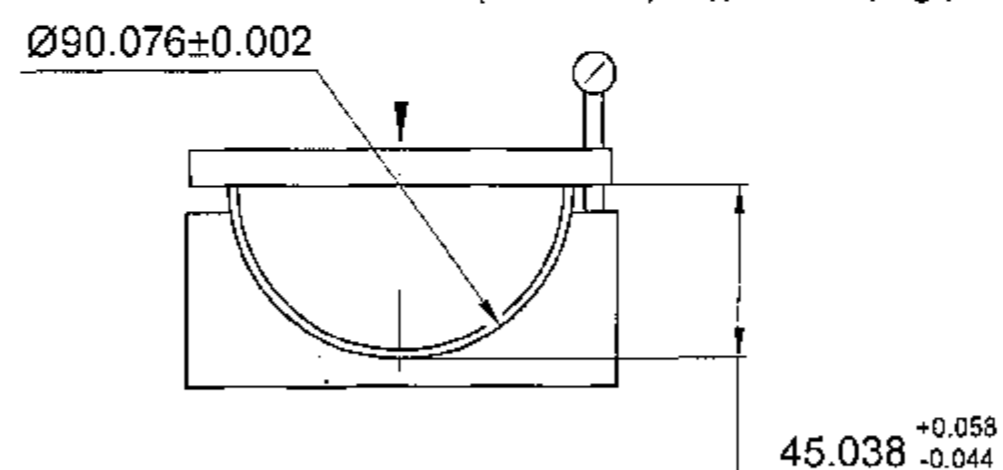
SL.NO	R1	REMARKS
1	+0.085 90 +0.076	1. FINISH SURFACE 'E' WHEN ASSEMBLED WITH Cb 3304-02-4
2	+0.07 83.5	2. ALL OTHER SIZES, ROUGHNESS OF SURFACE, TECH. REQUIREMENTS AND MATERIAL ARE ACCORDING TO DRAWING Cb 3304-25 3. REPAIR SIZE CATEGORY TO BE MARKED AS R1 BY ELECTRIC ETCHING.

E  
M 2:1



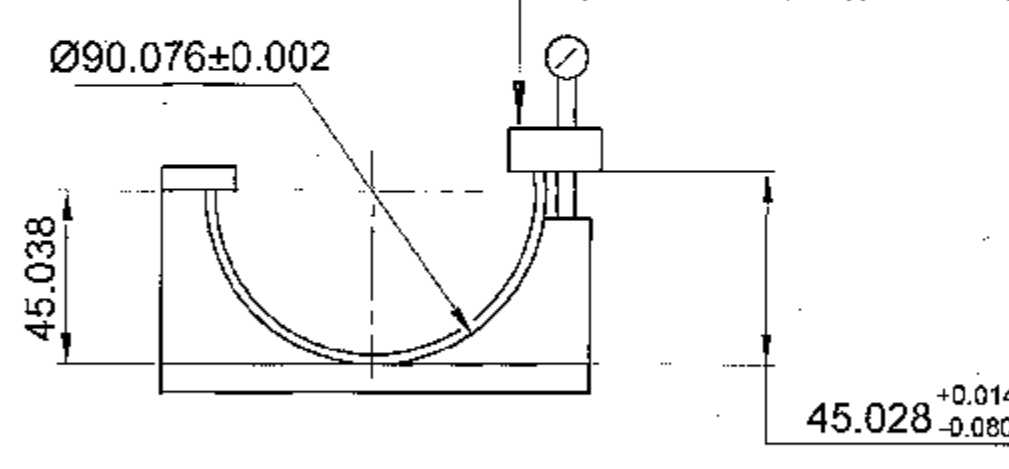
SKETCH I  
M 1:2

P(3626±98)N ((370±10)Kgf)



SKETCH 2  
M 1:2

P(8820±245)N ((900±25)Kgf)



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

EST. WT. (kg) 0.165 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.

- 11. CHECK THE CONTACT OF EXTERNAL CYLINDRICAL SURFACE OF INSERT PIECE TO SURFACE SOCKET OF INSPECTION FIXTURE WITH APPLICATION OF BLUE AS PER IJT-613-85 IS CARRIED OUT AT LOAD (8820±245)N, (900±25kgf). TRACES OF BLUE ON INSERT PIECE SHOULD BE EVEN AND COVER NOT LESS THAN 85% OF SURFACE. NON COATED SECTION OF INSERT PIECE HAS ARBITRARY FORM OF PLANE NOT MORE THAN 0.8 Cm<sup>2</sup>(80 mm<sup>2</sup>), EACH SHOULD BE LOCATED AT DISTANCE NOT MORE THAN 20mm FROM EACH OTHER.
- 12. \*1 DIMENSION TO BE ENSURED BY TOOL.

- 1. Requirement for material and the quality of plating should be as per TTM-43-87.
- 2. Carry out the machining as per dimension in square brackets, to be done together with c6.3304-26, as per c6.3304-02 or c6.3304-02-4. Parts to be used together.
- 3. Pairing of shells is carried out by the selection as per actual dimension of heights. In measurement as per the sketch I, the sum of heights of the halves make up 90.076...90.090 mm, in measurement as per sketch II the sum of the heights of the halves make up 89.976...90.004 mm (Algebraic sum of deviations of the heights of the paired halves should be in the limits of 0.032...0.060mm).
- 4. Coating of boron 1 micron, silicon 9 microns to be done on the surface as per instruction ИП -702-87.
- 5. Lead overflow is not allowed on the surface 'A' and 'Г'.
- 6. On surface A dents up to depth of 0.2mm and diameter 1.5 mm in quantity of maximum 3 numbers.
- 7. Mark by electrical etching method the pair number of the shells
- 8. Stamp by electrical etching method.
- 9. \*Dimensions are given for reference.
- 10. Alternative material: EpC30 GOST 493-79 for Item No.2
- 11. Matching of shell should be checked in the inspection fixture by "Bluing" under the load (8820±245)N, ((900±25)Kgf) as per ИП -613-85. Bluing should cover uniformly minimum 85% of shell surface.
- 12. \*1 Dimension to be ensured by tool.

2.5 ✓(✓)

DRN	CHD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69	ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
			05.01.08	1:1					Cb 3304-25
MATERIAL:-				USED ON:- Cb 3304-02-4					
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI				TITLE:- CONNECTING ROD UPPER INSERT					
NOTN NO: 396-06 (F-158)				REPAIR SIZE DIMENSIONS ADDED, AUTHY:- LIA. MEET. MINUTES POINT No.- 2.5 Dt.- 18.12.07					
A				NATURE OF AMENDMENTS					

DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 21 DRG. REPLACES Cb 3304-25 ISSUE-9 VIDE NOTN. NO: 2000-46 COMMON TO V-9252 ENGINE

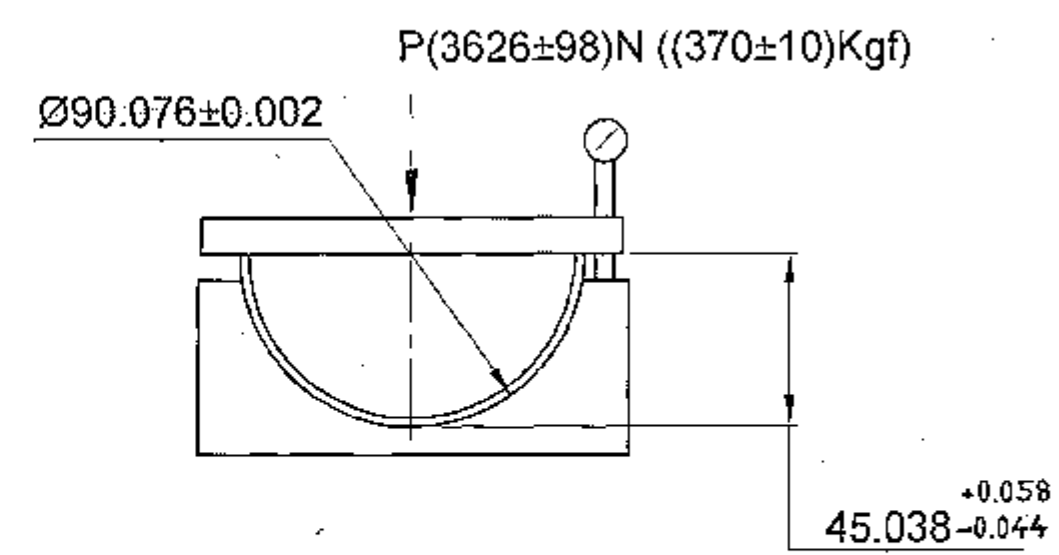
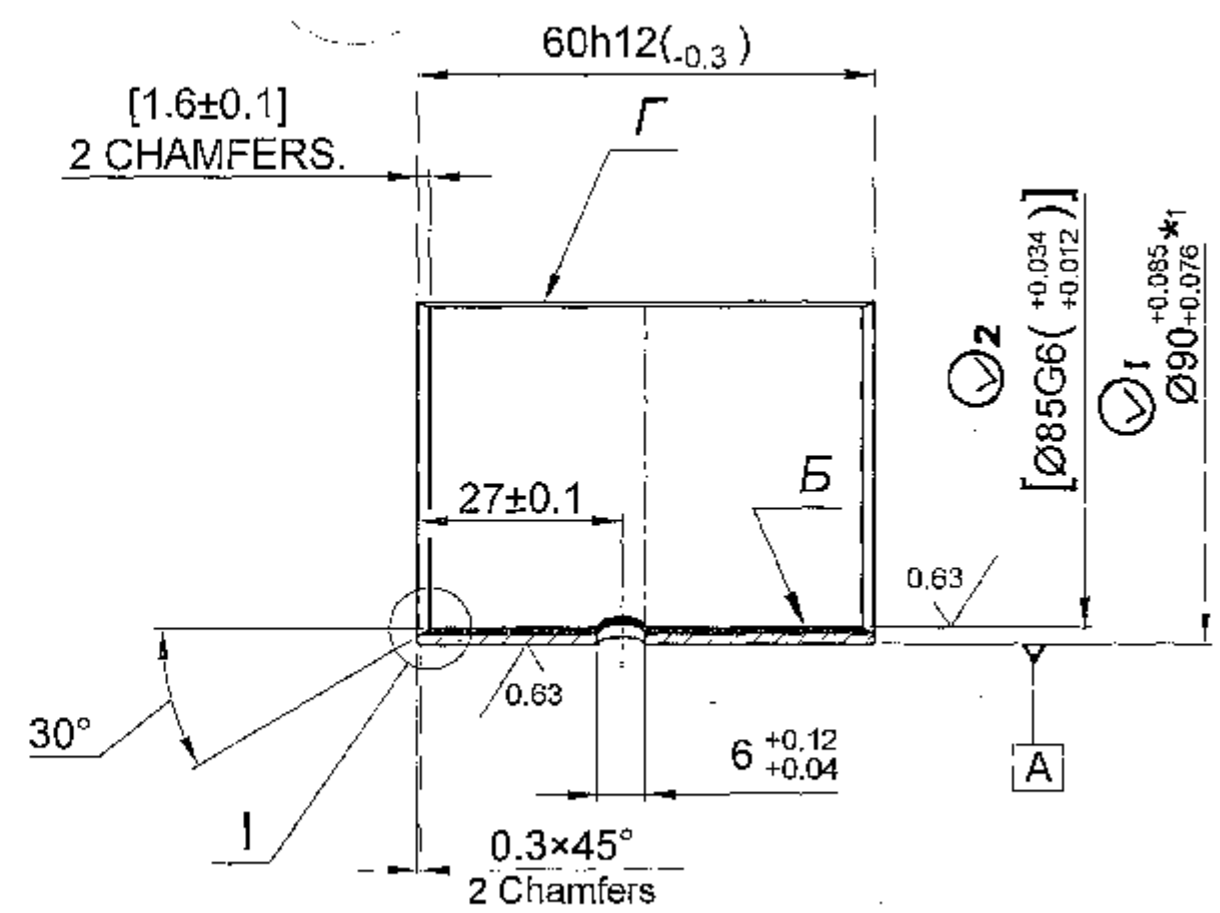
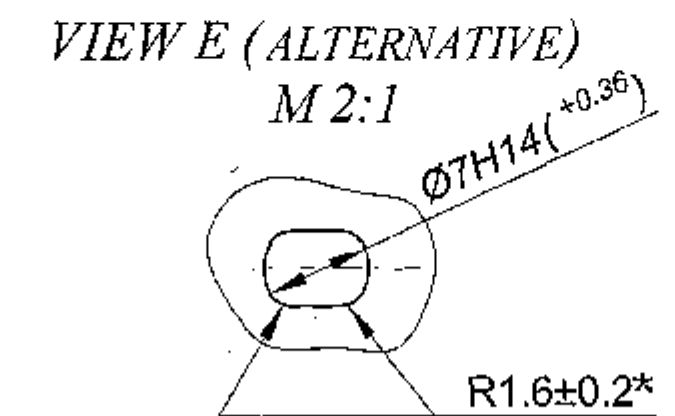
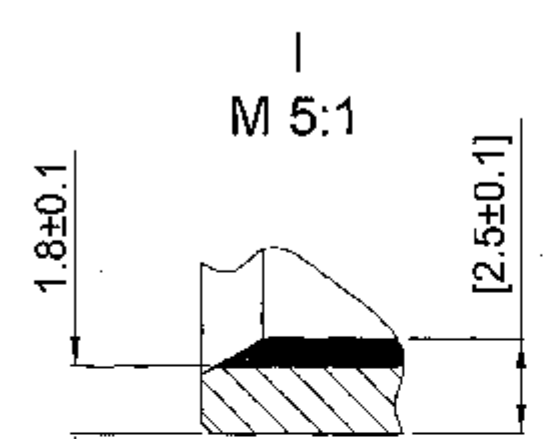
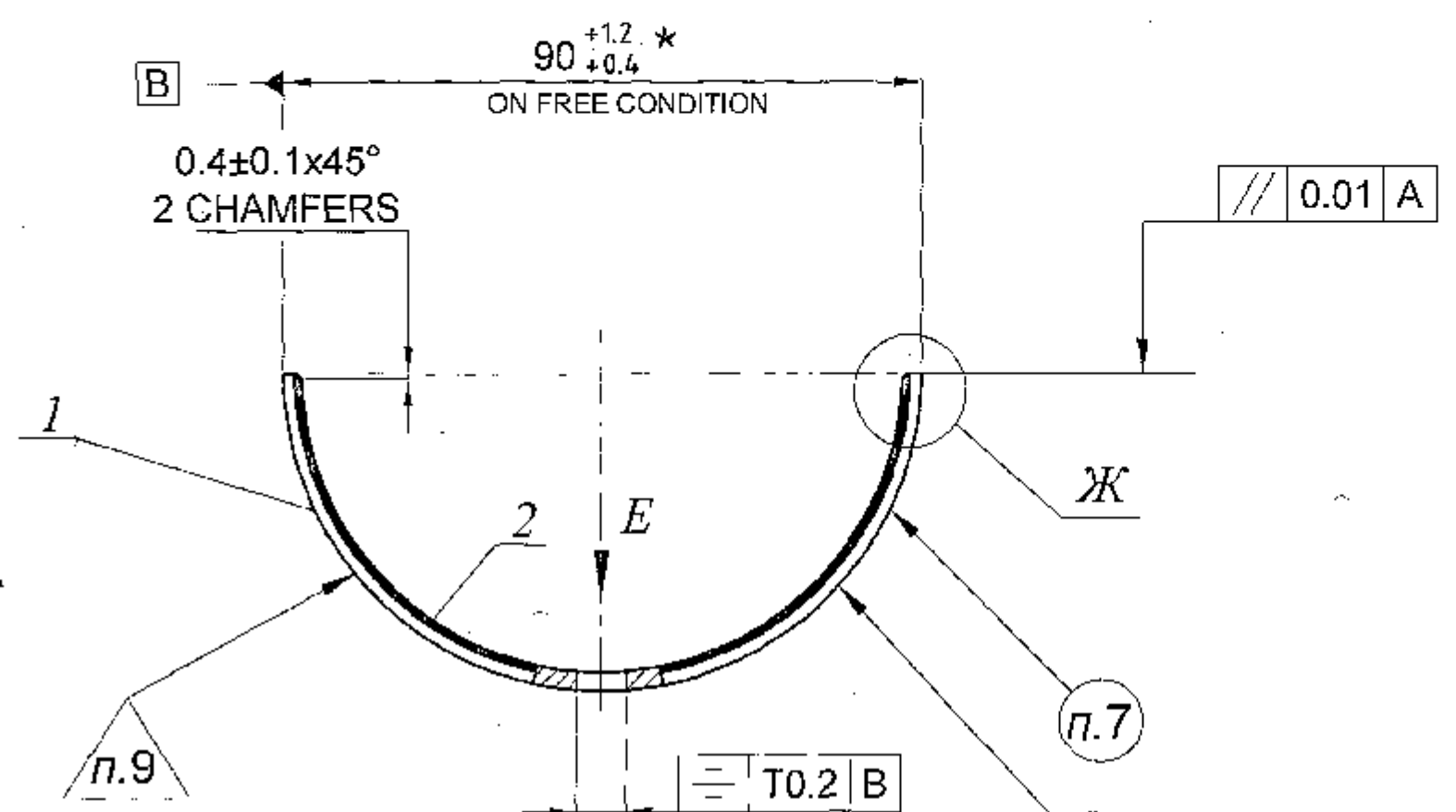
F-154  
37  
59  
SIZE A4x4



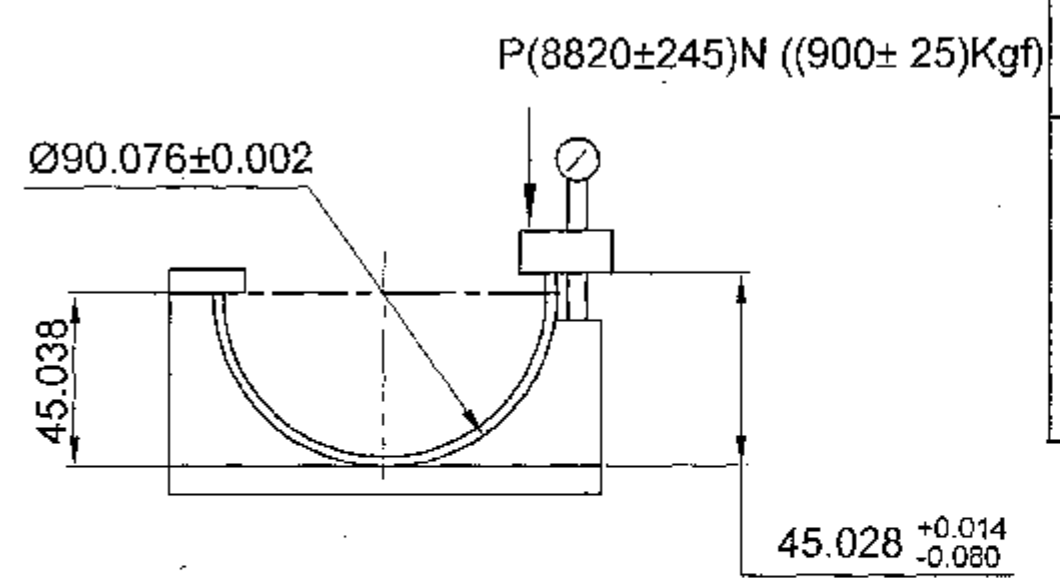
2.5 ✓(✓)

DRAWING NUMBER  
Cb 3304-26

SHEET No. OF



SKETCH II

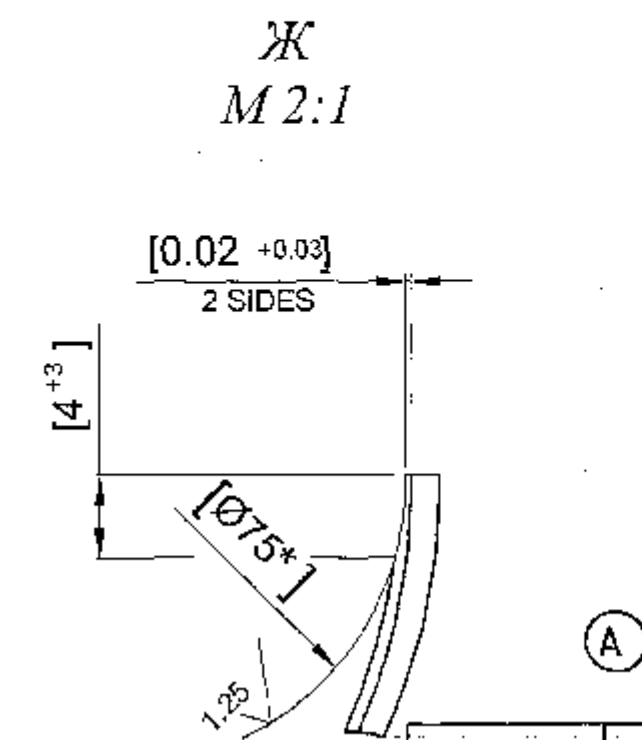


PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. WT. (kg) 0.166

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.



SL No.	R1	REMARKS
1		1. FINISH SURFACE 'E' WHEN ASSEMBLED WITH Cb 3304-02-4
2		2. ALL OTHER SIZES, ROUGHNESS OF SURFACE TECHNICAL REQUIREMENT AND MATERIAL ARE ACCORDING TO DRG. No. Cb 3304-26
		3. REPAIR SIZE CATEGORY TO BE MARKED AS R1 BY ELECTRIC ETCHING.

- Requirement for material and the quality of plating should be as per TTM-43-87.
- Carry out the machining as per dimension in square brackets, to be done together with Cb.3304-25, as per Cb.3304-02 or Cb.3304-02-4. Parts to be used together.
- Pairing of shells is carried out by the selection as per actual dimension of heights. In measurement as per the sketch I, the sum of heights of the halves make up 90.076...90.090 mm, in measurement as per sketch II the sum of the heights of the halves make up 89.976...90.004 mm (Algebraic sum of deviations of the heights of the paired halves should be in the limits of 0.032...0.060 mm).
- Coating of boron 1 micron, silicon 9 microns to be done on the surface as per ИЛ -702-87.
- Lead overflow is not allowed on the surface 'A' and 'Г'.
- On surface A dents up to depth of 0.2mm and diameter 1.5 mm in quantity of maximum 3 numbers is allowed.
- Mark by electrical etching method the pair number of the shells.
- Mark the connecting rod number by electrical etching method.
- Stamp by electrical etching method.
- Dimension to be ensured by Tool.
- \*1 Dimensions are given for reference.
- Alternative material: 5pC30 GOST 493-79 for Item 2.
- Matching of shell should be checked in the inspection fixture by "Bluing" under the load (8820±245)N ((900±25)Kgf) as per instruction ИЛ -613-85. Bluing should cover uniformly minimum 85% of shell surface.
- CHECK THE CONTACT OF EXTERNAL CYLINDRICAL SURFACE OF INSERT PIECE OF SURFACE SOCKET OF INSPECTION FIXTURE WITH APPLICATION OF BLUE AS PER ИЛ-613-85 IS CARRIED OUT AT LOAD (8820±245) N, (900±25 kgf). TRACES OF BLUE ON INSERT PIECE SHOULD BE EVEN AND COVER NOT LESS THAN 85% OF SURFACE.
- NON COATED SECTION OF INSERT PIECE HAS ARBITRARY FORM OF PLANE NOT MORE THAN 0.8 cm<sup>2</sup> (80mm<sup>2</sup>), EACH SHOULD BE LOCATED AT DISTANCE NOT MORE THAN 20 mm FROM EACH OTHER.

DRN	CHD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69	ALL THREADS TO CONFORM TO
			05-01-08	1:1	26	17.10.08	NOTN NO: 396-06 (F-158)
					A	31-12-07	REPAIR SIZE DIMENSIONS ADDED. AUTHY:- LIA. MEET. MINUTES POINT No.- 2.5 Dt.- 18.12.07
					ISSUE	DATE	NATURE OF AMENDMENTS
MATERIAL:-				USED ON:- Cb 3304-02-4			
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI				TITLE:- CONNECTING ROD LOWER INSERT			
D S CAT NUMBER				DRAWING NUMBER Cb 3304-26			

DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 25 DRG. REPLACES Cb 3304-26, ISSUE-11 VIDE NOTN No: 2000-46. COMMON TO V-92S2 ENGINE.

F-154  
33  
58  
SIZE A4 x 4

