

III

1. Неуказанные предельные отклонения размеров отверстий - по 7, валов - по B7, остальных - по CM7.
2. Отклонение от соосности осей отверстий E от диаметра в этой плоскости резьбы D не более 0,15 мм (пуск зависимый).
3. Отклонение от соосности диаметрально противоположных отверстий E проверить калибром Ф 1,8 мм.
4. Покрытие: Ц. с последующим удалением водородной хрупкости. Допускается нарушение покрытия на резьбовых поверхностях, торцах Г и В.
5. Заменитель материала - сталь 40,50 ГОСТ 1050-74.

- III.
1. Unindicated limit deviations of dimensions: holes by A7, shafts by B7, the rest - by CM7.
  2. Deviation from axle concentricity of holes E from diametrical plane K is 0.15 mm maximum (dependent tolerance).
  3. Deviation from concentricity of diametrically opposite holes E should be checked by gauge  $\phi$  1.8 mm.
  4. Coating: Ц 3.хр. with following removal of hydrogen embrittlement.
  5. Failure of the coating on threaded surfaces, end faces Г and В is allowable.
  6. Substitute of material is steel 40,50 GOST 1050-74.

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

EST. WT. 0.100 Kg.	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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	

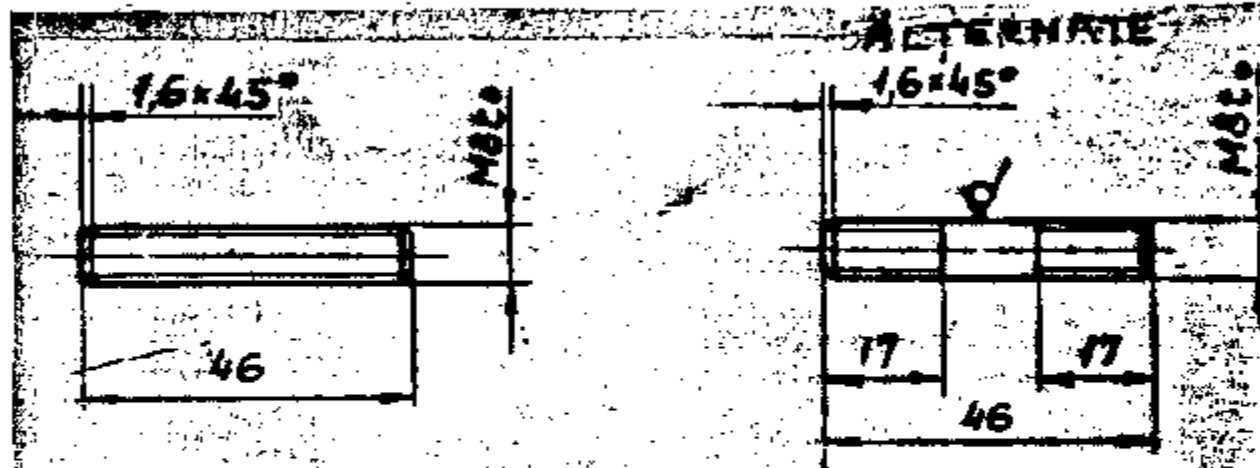
DRN	APPROVED	MATERIAL :-	USED ON :-
CHD	APPROVED	40-5 GOST 7417-75	СБ 20-15-601-7
TCO	APPROVED	45 GOST 1050-74	
APPD	APPROVED	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	16-2-93	A V A D I	
SCALE	1:1		
DIMENSIONS IN mm			
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69		TITLE SLEEVE	
ALL THREADS TO CONFORM TO		D. S. CAT NUMBER	DRAWING NUMBER 20-15-642-3
ISSUE	DATE	NATURE OF AMENDMENTS	

DRG INTRODUCED BASED ON NO. 767-84-3  
 DRG INDIA NISED BASED ON RUS ORIGINAL ISSUE-1 (767-84)



DRAWING NUMBER  
550-105

Rz80 (✓)



**EXPLANATORY NOTE :**

8. REFERENCE MATERIAL QUOTED :  
HIGH QUALITY (A) CHROMIUM STEEL TO GRADE 38XA.

a) CHEMICAL COMPOSITION :

CARBON	- 0.35 - 0.42	%
SILICON	- 0.17 - 0.37	%
MANGANESE	- 0.50 - 0.80	%
CHROMIUM	- 0.80 - 1.10	%
SULPHUR	- 0.025 (max)	%
PHOSPHORUS	- 0.025 (max)	%
COPPER	- 0.30 (max)	%
NICKEL	- 0.30 (max)	%

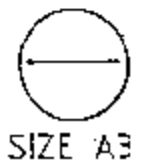
b) PHYSICAL PROPERTIES :

YIELD POINT	- 80 Kgf/mm <sup>2</sup>	(min)
U T-S	- 95 Kgf/mm <sup>2</sup>	(min)
ELONGATION %	- 12	(min)
REDUCTION IN AREA %	- 50	(min)
IMPACT STRENGTH	- 9 Kgf/cm <sup>2</sup>	(min)

1. INSPECTION GROUP IV AS PER TECHNICAL REQUIREMENTS TT - 11, HRC 26 TO 33.
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:  
FOR SHAFTS - AS PER B<sub>7</sub>,  
OTHERS - AS PER CM<sub>7</sub>
3. MAKE THREAD AS PER STANDARD 82020-12, ISSUE 7.
4. TECHNICAL REQUIREMENTS ARE AS PER GOST 1759-70.
5. COATING: CADMIUM-PLATED, 3 MICRONS THICK, OILED, WITH REMOVAL OF HYDROGEN EMBRITTLEMENT.
6. UNTHREADED PORTION OF THE ROD MAY BE MADE WITH IN THE LIMITS OF THE ANGLE DIAMETER OF THREAD.
7. IN THE ASSEMBLY UNITS MECHANICAL DAMAGE TO THE COATINGS SUCH AS SCRATCHES NOTCHES AND DENTS WHICH DO NOT EXPOSE STEEL ARE PERMITTED.

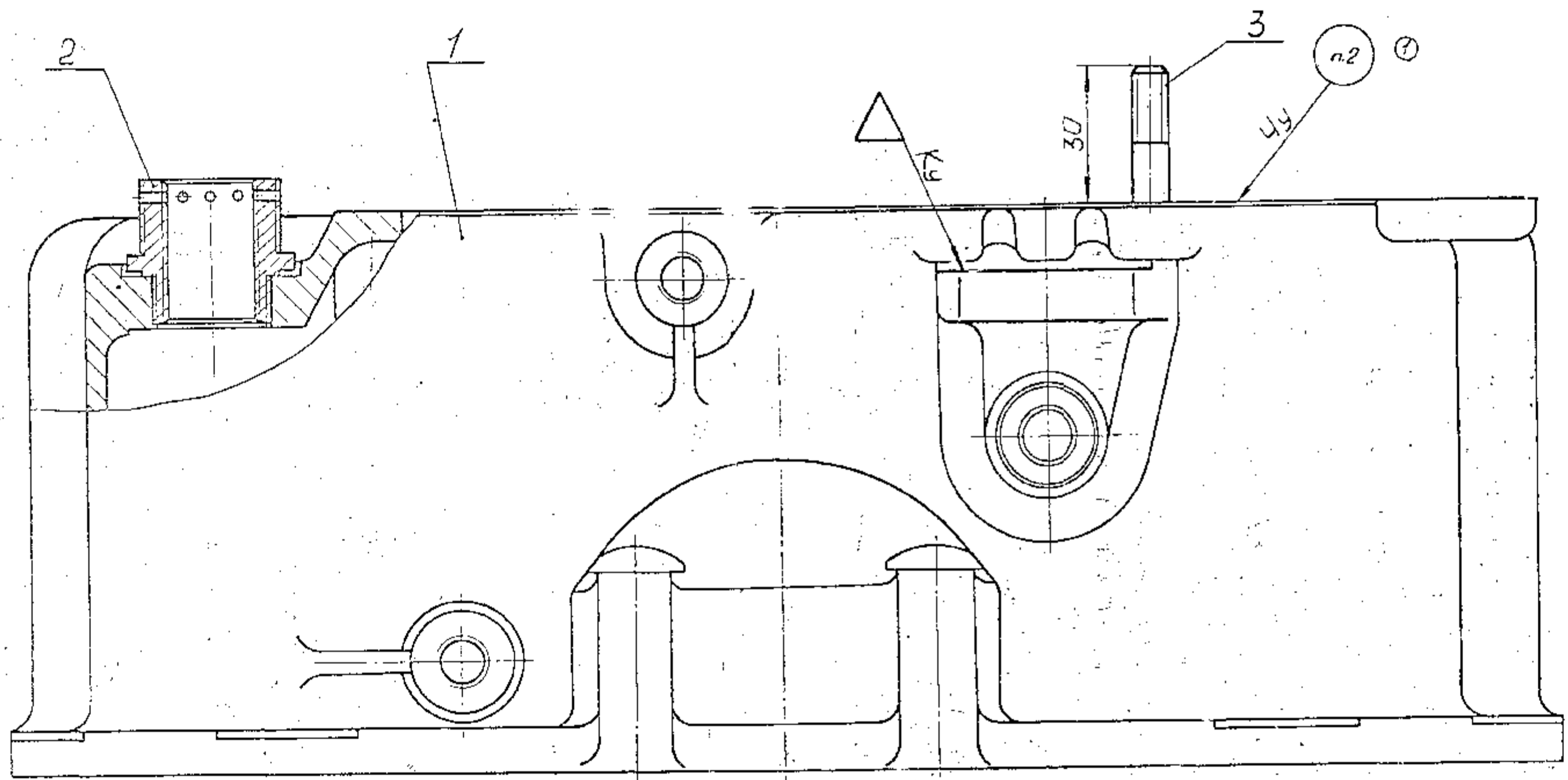
CB 20-11-02-9  
CB-20-13-02-11

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION		DRN		MATERIAL:-	USED ON
EST. WT.	TO BE STAMPED OR MARKED WHERE INDICATED THIS ( LETTERS)	CHD		38XA GOST 4543-71	CB 20-15-601-5
		TCO			
		APPC			
		DATE	24-4-1987	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES)	
		SCALE:-	1:1	AVADI	
		DIMENSIONS IN mm		TITLE	STUD M8X46
		TOLERANCE ON DIMNS			
		UNLESS OTHERWISE			
		STATED IS:2102-59			
		ALL THREADS TO		D S CAT NUMBER	DRAWING NUMBER
		CONFORM TO			550-105
		ISSUE DATE			
		NATURE OF AMENDMENTS			



SIZE A3





I

1. На сопрягающийся торец гильзы (поз. 2) и прилегающие к нему 2...4 нитки резьбы нанести лак 33Ш по инструкции И 240-280/75.

2. Маркировать шрифтом ПО 5 ГОСТ 2930-62 при отправке в запчасти.

- I.
1. Apply 33Ш varnish on mating barrel end face (pos.2) and 2...4 threads adjoining to it according to И 240-280/75 instruction.
  2. Mark by the ПО 5 GOST 2930-62 type when delivering as spare parts.

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

EST. WT. 3.1 Kg.	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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

DRM	А.А.А.А.	MATERIAL	USED ON
CHD	А.А.А.А.		Cb 20-15-663-4
TCD	А.А.А.А.	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLE)	
APPO	А.А.А.А.	A V A D I	
DATE	16-12-93	TITLE	
SCALE	1:1	GOVERNOR BODY	
DIMENSIONS IN mm		D S CAT NUMBER	DRAWING NUMBER
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69			Cb 20-15-601-7
ALL THREADS TO CONFORM TO			
ISSUE	DATE	NATURE OF AMENDMENTS	

DRG. INTRODUCED BASED ON NOTN. 767-84  
DRG. INDIAISED BASED ON RUSSIAN ORIGINAL ISSUE-1





