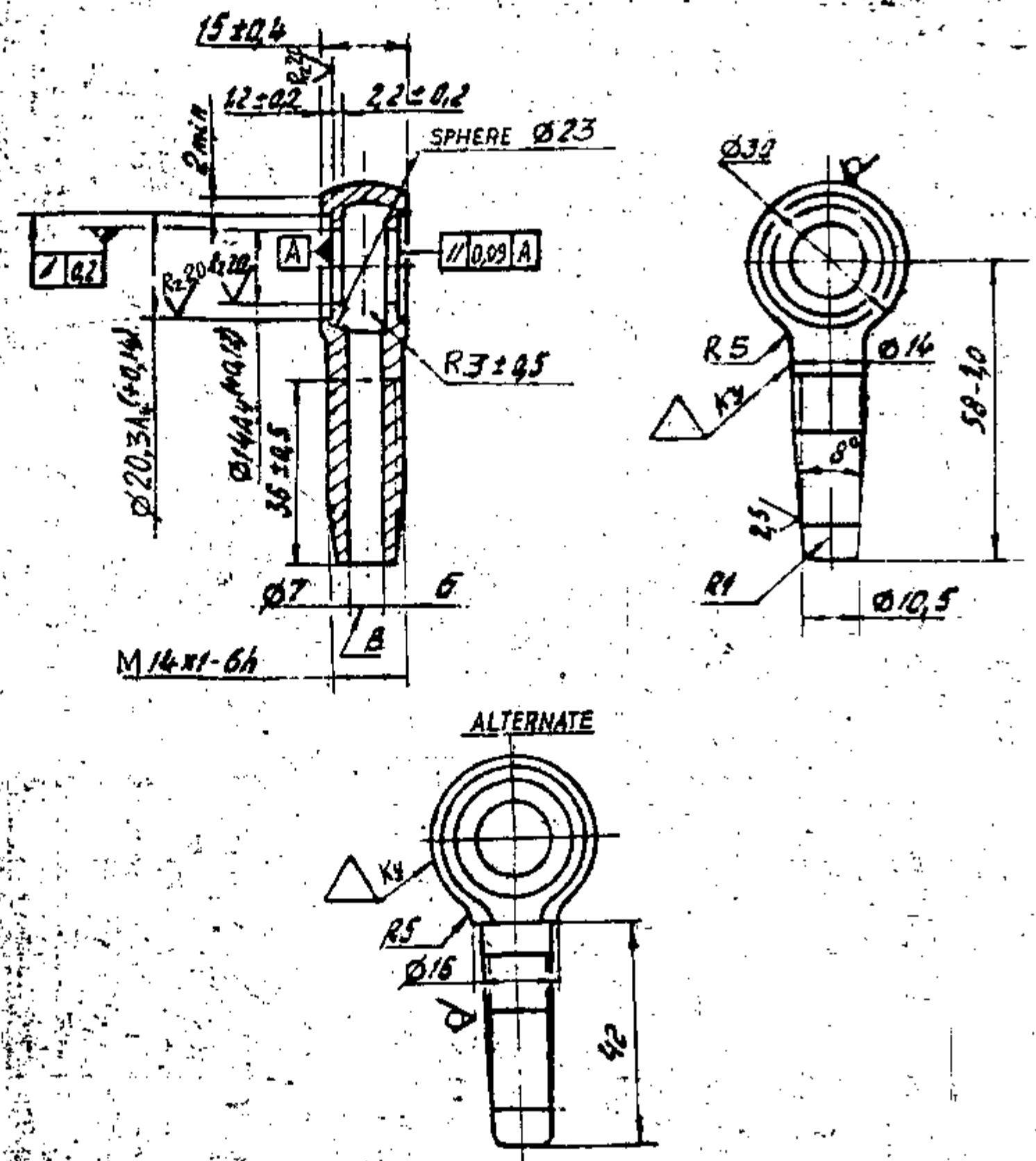


DRAWING NUMBER  
20-35-80

Rz40/ (✓)



1. ALTERNATE MATERIAL IS STEEL 30.40.45 GOST 1050-74.
2. IT MAY BE MADE <sup>BY</sup> USING PRECISION INVESTMENT, CASTING FROM STEEL 40A, 45A, GOST 977-75. REQUIREMENTS PLACED UPON CASTING ARE AS PER TECHNICAL REQUIREMENTS TT 320-1/55.
3. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:  
FOR HOLES - AS PER A7,  
SHAFTS - AS PER B7,  
OTHERS - AS PER C7.
4. TOTAL TOLERANCE FOR ALIGNMENT AND INTERSECTION OF THE SHANK AXIS, RESPECT TO THE AXIS OF SURFACE A IS R 0.5 MM ON THE SHANK LENGTH.
5. WALL THICKNESS DIFFERENCE  $\delta$  SHOULD NOT EXCEED 0.5 MM.
6. CRACKS, BURRS, NOTCHES, DENTS AND OTHER MECHANICAL DAMAGES ARE NOT PERMITTED.
7. COATING: CADMIUM-PLATED, 9 MICRONS THICK, OILED. ABSENCE OF THE COATING ON THE INTERNAL SURFACES IS PERMITTED. THE THREAD MAY BE CHECKED BEFORE COATING.
8. THREAD MAKING BY ROLLING IS PERMITTED WITH A DIAMETER OF UNTHREAD PORTION WITHIN THE LIMITS OF THE ANGLE DIAMETER OF THE THREAD.
9. THREAD B MAY BE MADE BY CASTING WITHOUT SUBSEQUENT MACHINING.
10. FINAL ACCEPTANCE STAMPING AND MARKING MAY BE MADE ON THE TAG (PART-540-551) FOR BATCH OF PARTS WITH FUTHER SEALING.

Originally prepared on 2.4.86.

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

EST. WT. 0.061 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 OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

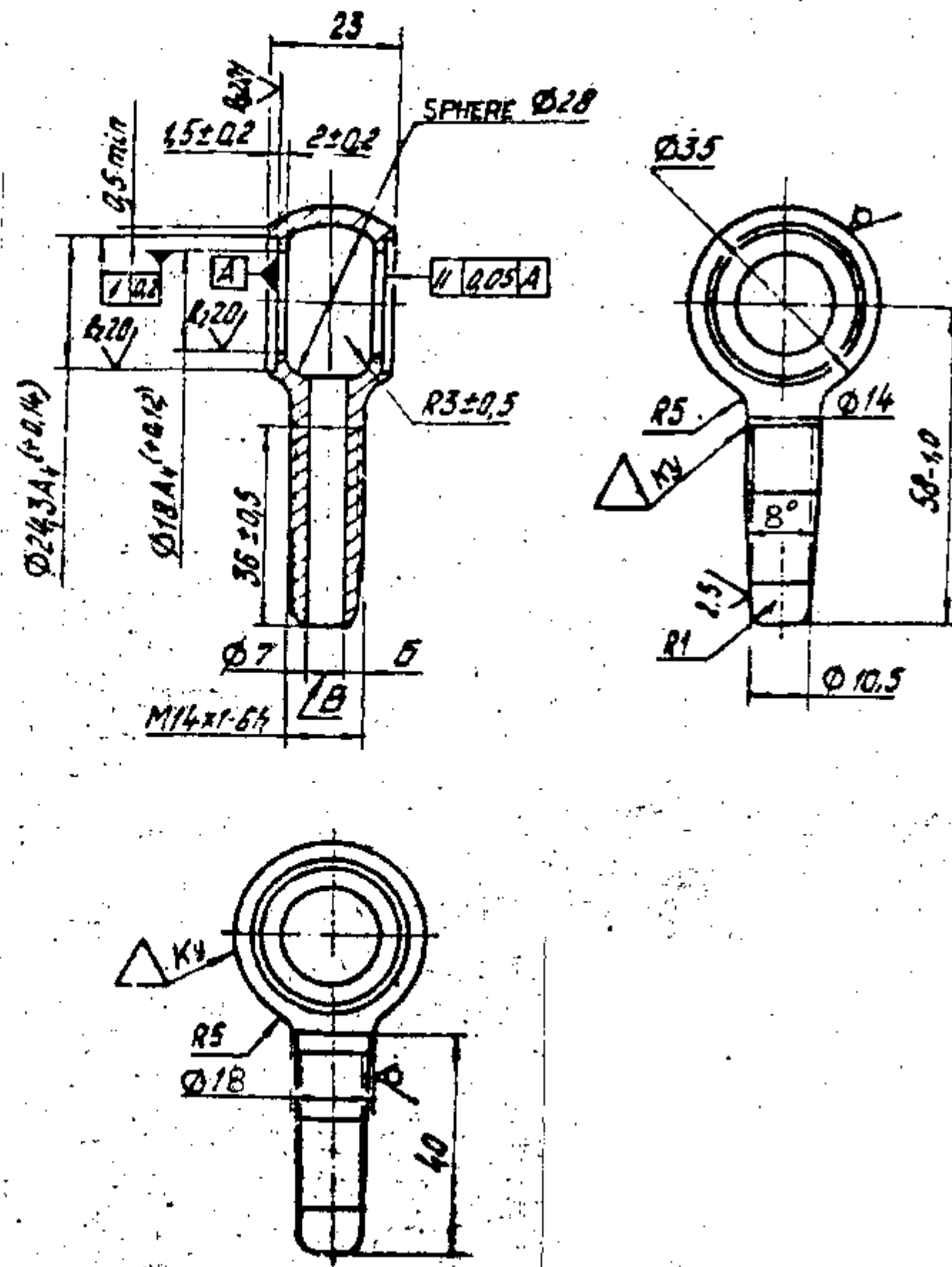
ORN	CHD	TCO	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	ALL THREADS TO CONFORM TO
MATERIAL :- 35 GOST 1050-74						USED ON :- C6 20-35-09-4		
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A D I						TITLE : ROTATABLE ANGLE		
ISSUE						D S CAT NUMBER		DRAWING NUMBER
DATE								20-35-80
NATURE OF AMENOMENTS								

SIZE A2



DRAWING NUMBER  
20-35-81

Rz 40 (✓)



1. ALTERNATE MATERIAL IS STEEL 30, 40, 45, GOST 1050-74.
2. IT MAY BE MADE BY USING PRECISION-INVESTMENT CASTING FROM STEEL 40A, 45A, GOST 977-75. REQUIREMENTS PLACED UPON CASTING ARE AS PER TECHNICAL REQUIREMENTS TT 326-1/55.
3. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:  
FOR HOLES - AS PER A;  
SHAFTS - AS PER B;  
OTHERS - AS PER C.
4. TOTAL TOLERANCE FOR ALIGNMENT AND INTERSECTION OF SHANK AXIS WITH RESPECT TO THE AXIS OF SURFACE A IS R 0.5 MM ON THE SHANK LENGTH.
5. WALL THICKNESS DIFFERENCE B, SHOULD NOT EXCEED 0.5 MM.
6. CRACKS, BURRS, NOTCHES, DENTS AND OTHER MECHANICAL DAMAGE ARE NOT ALLOWED.
7. COATING: CADMIUM-PLATED, 9 MICRONS THICK, OILED. ABSENCE OF THE COATING ON THE INTERNAL SURFACES IS PERMITTED. THE THREAD MAY BE CHECKED BEFORE COATING.
8. THREAD MAKING BY ROLLING IS PERMITTED WITH A DIAMETER OF UNTHREADED PORTION WITHIN THE LIMITS OF MEAN DIAMETER OF THE THREAD.
9. THREAD B MAY BE MADE BY CASTING WITHOUT SUBSEQUENT MACHINING.

Originally prepared on 2-4-86

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

EST. WT. 0.074 Kg  
TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

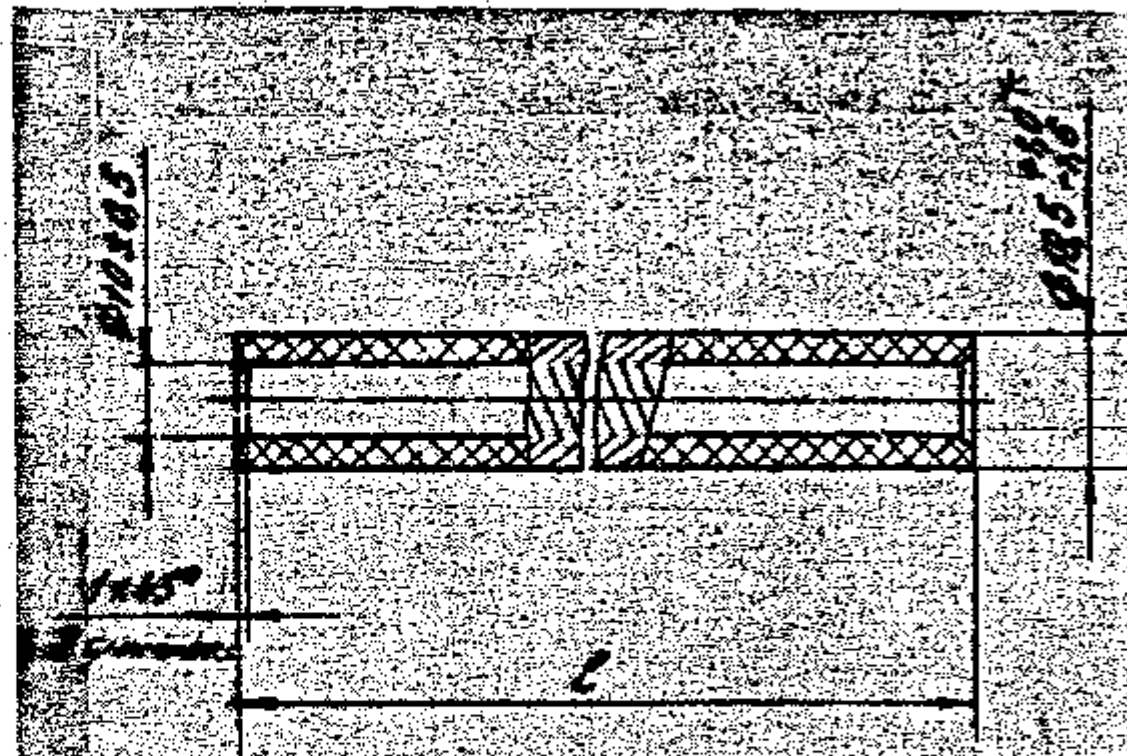
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT - SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRM	<i>[Signature]</i>	MATERIAL :-	35 GOST 1050 - 74	USED ON :- C6 20.35.70-4 C6 20.35.09-4 C6 20.35.70-5
CHD	<i>[Signature]</i>	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A D I		
TCD	<i>[Signature]</i>			
APPD	<i>[Signature]</i>	TITLE : <b>ROTATABLE ANGLE</b>		
DATE	6-5-02			
SCALE	1:1	D S CAT NUMBER		
DIMENSIONS IN mm				
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102 - 69		DRAWING NUMBER <b>20-35-81</b>		
ALL THREADS TO CONFORM TO				
ISSUE	DATE	NATURE OF AMENDMENTS		

SIZE A2



DRAWING NUMBER  
535-61 to 61-09



1. TECHNICAL REQUIREMENTS AND ACCEPTANCE ARE AS PER TECHNICAL SPECIFICATIONS TY 005-280-76

2. DIMENSIONS ARE GIVEN FOR REFERENCE

HOSE NO	L (mm)	MASS/KG	USED ON
535-61	125	0.035	
-01	245	0.070	C&20-35-70-4 (A)
-02	270	0.075	
-03	320	0.090	
-04	438	0.122	
-05	760	0.215	
-06	940	0.265	
-07	1080	0.292	
-08	3.75	0.11	C&20-35-70-5 (B)
-09	2.25	0.06	C&20-35-09-4

3. EXPLANATORY NOTE :-

MATERIAL QUOTED :- 3T 10-15  
TY 005-280-76

3T - SLEEVES WITH TWO THREAD BRAIDINGS AND WIRE SPIRAL BETWEEN BRAIDINGS

10 - INTERNAL DIAMETER

15 - OPERATING PRESSURE

THICKNESS OF INTERNAL RUBBER LAYER = 1.3 MM (MIN)

OPERATING PRESSURE = 15 Kgf/Cm<sup>2</sup> (MIN)

MINIMUM RADIUS OF BENDING = 100 mm

WEIGHT OF 1 Metre LENGTH OF HOSE = 0.270 Kg

RUBBER MATERIAL :-

WORKING MEDIUM = HYDRAULIC, FUEL, OIL & AIR

OPERATING TEMPERATURE = -55 to +100°C

GRADE :- SUITABLE RUBBER TO MEET ENDUSE REQUIREMENT CAN BE USED

SUGGEST TO USE H0-68-1 RUBBER GRADE AS PER TY 005-216-75

PROPERTIES :- HARDNESS = 55-70 ( TAP )

RUPTURE STRENGTH = 90 Kgf/Cm<sup>2</sup> (MIN)

ELONGATION AT RUPTURE = 250 %

DENSITY = 1.24 ± 0.05 g/Cm<sup>3</sup>

(A) ALT MATL.: RUBBER GRADE BNC TO SPECN. CQA(HV)/NBR+CR

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

EST. WT. TO BE STAMPED OR MARKED WHERE INDICATED THUS = LETTERS:

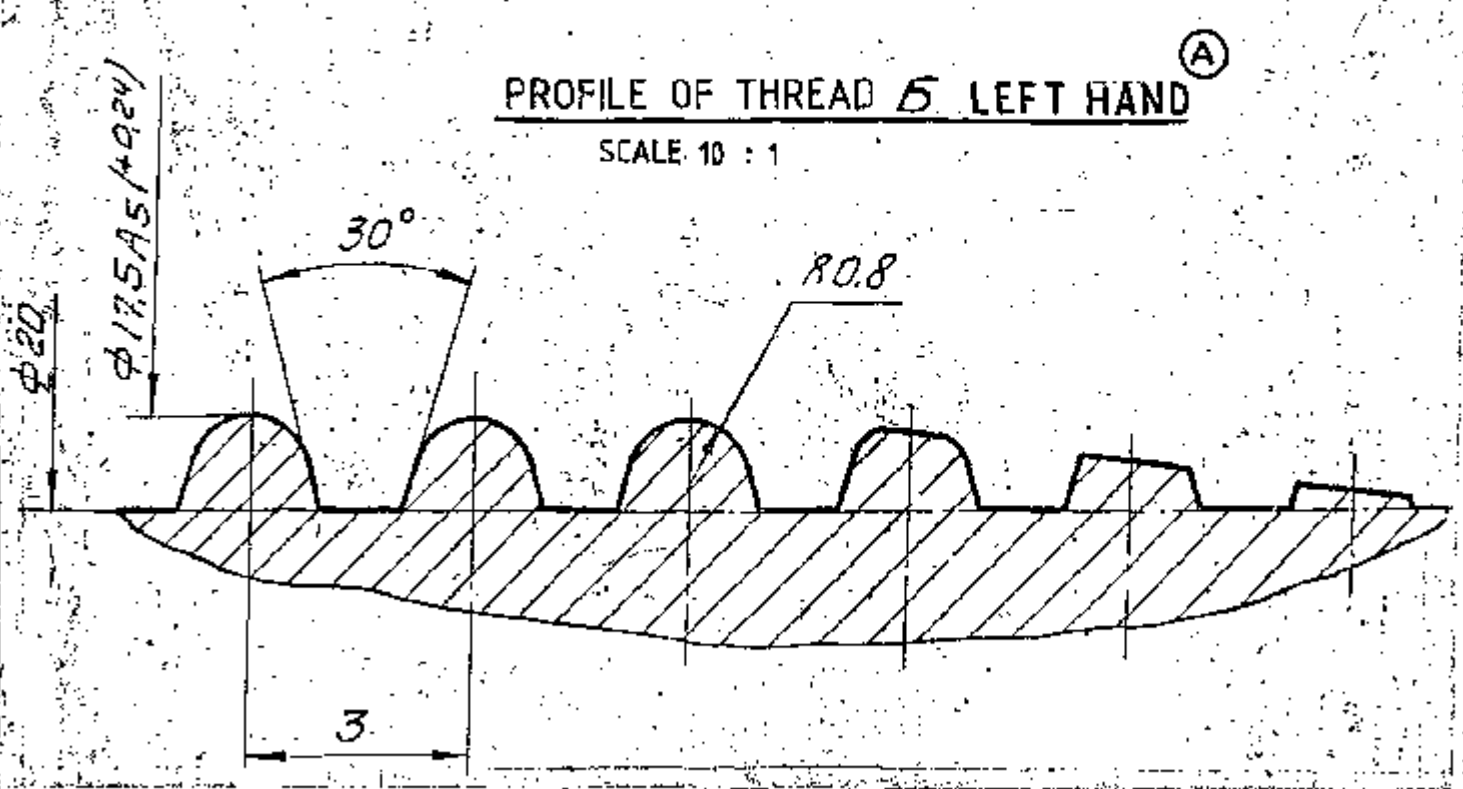
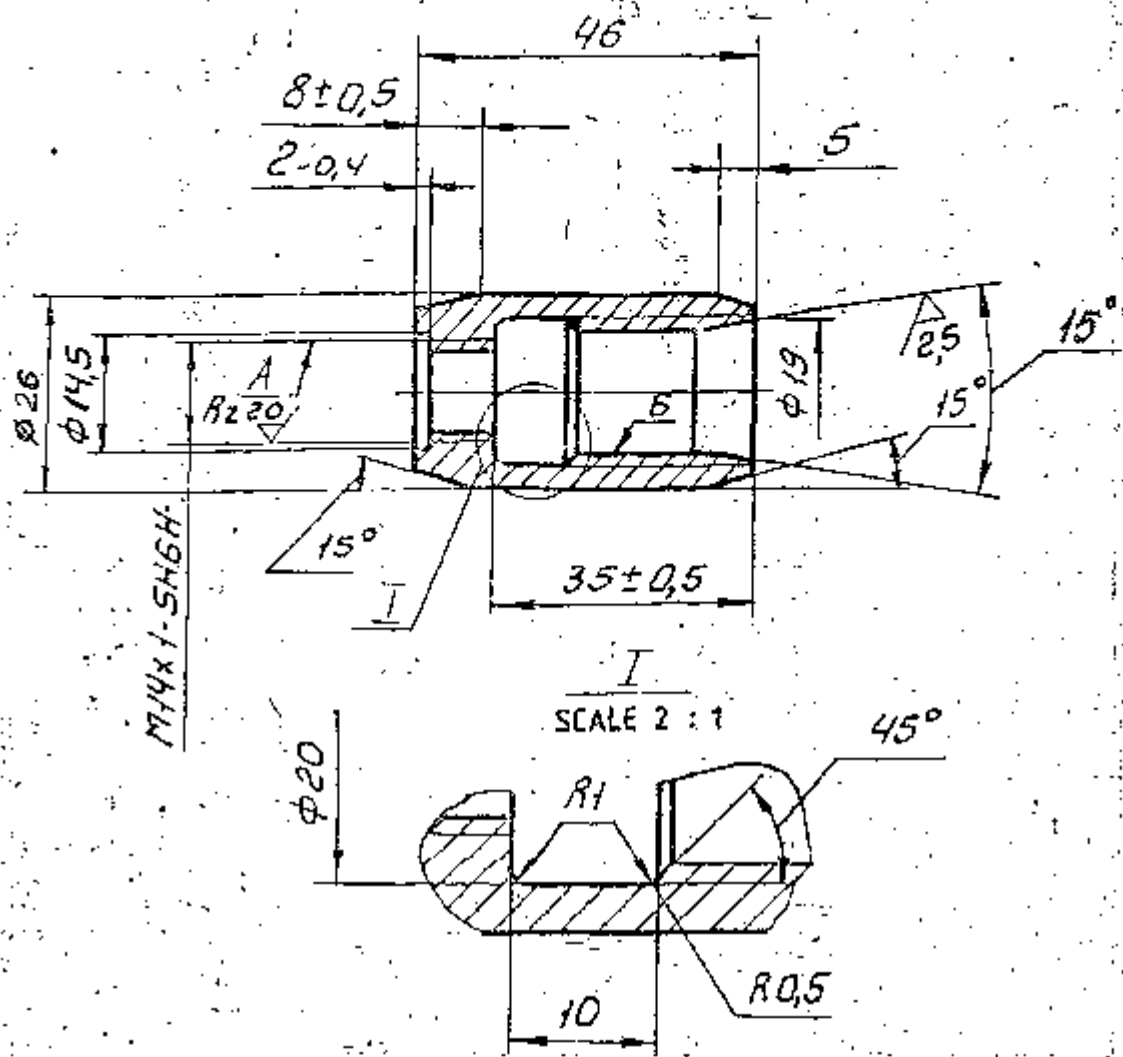
SEE TABLE ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	Checked	MATERIAL :-	3T 10-15	USED ON:-	SEE TABLE
ENG	Checked		TY 005-280-76		
APP	Checked	CONTROL RATE OF QUALITY ASSURANCE (HEAVY VEHICLES)			
DATE	25-04-87	A.V.A.D.I.			
SCALE	1:1	TITLE			
DIMENSIONS IN mm		HOSE			
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2:100-69		3-S CAT NUMBER			
B	27.05.08	Lt. No. TC/GEN/IND-III Dt. 02.04.08	ALL THREADS TO CONFORM TO		
A	18-6-93	Agency Ref. No 50228/ANSP/ENG/FDI dt 21-6-93	DRAWING NUMBER		
ISSUE	DATE	NATURE OF AMENDMENTS	535-61 to 61-09		



DRAWING NUMBER  
3335 - 60

Rz40/ (✓)



1. UNSPECIFIED LIMIT DEVIATION OF DIMENSION AS PER ACCURACY CLASS 7 OST 1010-
2. MISALIGNMENT OF THREAD "B" RELATIVE TO THREAD "A" SHOULD NOT EXCEED 0,5mm.
3. SURFACE OF THREAD "B" SHOULD BE WITHOUT RUPTURES AND BURRS.
4. MAY BE MANUFACTURED FROM BAR A1T Kp 26 n GOST 21488-76 WITHOUT MACHINING ALONG THE EXTERNAL DIAMETER.

\*CB-20-27-30

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

EST WT 0,034 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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHN	TCN	APPD	DATE	MATERIAL :-	USED ON :-
				28-08-87	A1T GOST 4784-74	cb 420 51-2 *cb 3335-70 C220-35-70-5
SCALE :- 1:1					CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)	
DIMENSIONS IN MM					AVADI	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69					TITLE	
ALL THREADS TO CONFORM TO IS: 4218 Pt IV					COUPLING	
A	20.3.01	81240/DB/AMDT/ENG/	D S CAT NUMBER		DRAWING NUMBER	
ISSUE	DATE	NATURE OF AMENDMENTS			3335 - 60	









