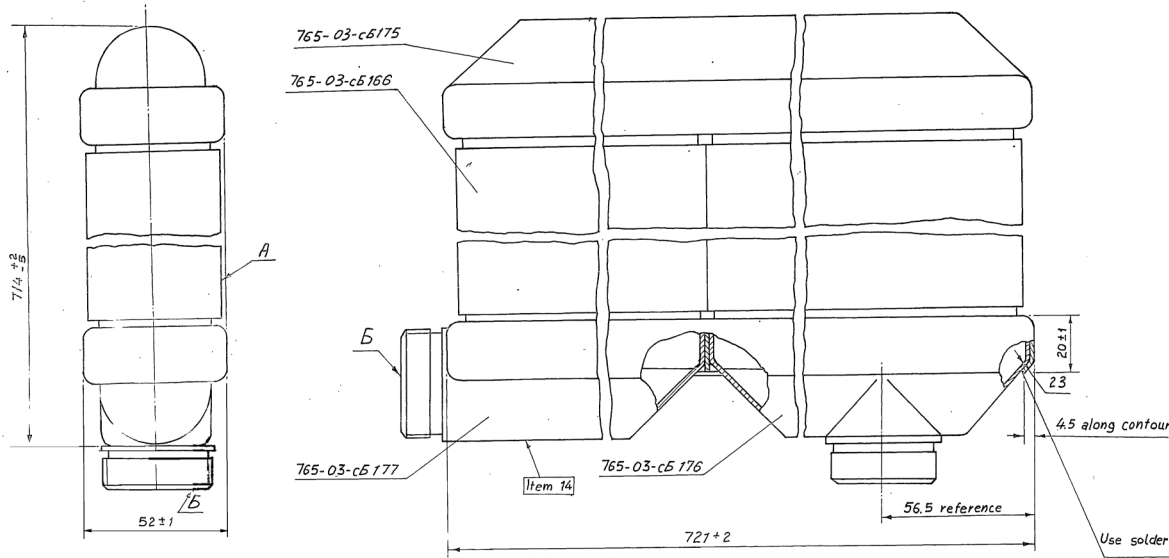


TECHNICAL CONDITIONS

1. AFTER SOLDERING, CARRY OUT NEUTRALIZATION OF THE INNER SURFACE.
2. TEST WITH WATER AT A TEMPERATURE OF 75° TO 85°C AND A PRESSURE OF 8kg/cm². FOR ATLEAST 0.5 MINUTES. LEAKAGE IS NOT ALLOWED.
3. IN CASE OF LEAKAGE, IT IS PERMITTED TO PERFORM BACK-UP SOLDERING FOLLOWED BY TESTING.
4. TEST THE OIL COOLER BY SHAKING IT ON VIBRATING FIXTURE WHICH PROVIDES THE HEIGHT OF OIL COOLER AND TABLE FREE FALL OF 50mm (ON TIMBER WITH FELT OR RUBBER GASKET UNDER TIMBER) WITH FREQUENCY EQUAL TO 80±10 VIBRATIONS PER MINUTE, OIL COOLER SHOULD BE PLACED HORIZONTALLY AND FILLED WITH WATER AT A PRESSURE OF 1 Kg/cm² DURATION OF TESTING SHOULD BE ATLEAST 2 MINUTES. NO LEAKAGE IS ALLOWED. SUBJECT ONE OIL COOLER FROM BATCH OR ONE OIL COOLER OUT OF TWENTY TO TEST BY SHAKING CHECK THE WHOLE BATCH IF LEAKAGE IS DETECTED.
5. TEST FOR LEAK PROOFNESS WITH AIR IN WATER BATH AT A PRESSURE OF 1 Kg/cm² FOR ATLEAST 0.5 min. AFTER TESTING BY SHAKING FORMATION OF AIR BUBBLES IS NOT PERMITTED.
6. PASSIVATE AFTER TESTING.
7. DRY THE OIL COOLER FROM INSIDE AND OUTSIDE. MOISTURE IS NOT ALLOWED.
8. NON FLATNESS OF SURFACE A SHOULD NOT EXCEED 2 mm.
9. APPLY PRIMER ϕ A -03 X GOST 9109-76 ON THE EXTERNAL SURFACE EXCEPT THREADS, TUBES & PLATES AND PAINT WITH ENAMEL ПЭ-223, BROWN, GOST 14923-78.
10. DRYING MAY BE CARRIED OUT WITH OIL MT-16n GOST 6360-58 AT A TEMPERATURE OF 100° TO 110°C.
11. PRESENCE OF FREE SOLDER IS NOT ALLOWED INSIDE THE HEADERS. THIS REQUIREMENT IS PROVIDED TECHNOLOGICALLY BY SHAKING ON STAND AND CIRCULATION OF OIL.
12. NON SQUARENESS OF SURFACES B TO SURFACE A SHOULD NOT EXCEED 1.5 mm. OVER THE LENGTH OF 36 mm.
13. INSERT PLUGS, AFTER FINAL ACCEPTANCE, IN TO THE HOLES, SECURE THEM WITH WIRE AND SEAL.
14. MARK THE MANUFACTURE'S MARK, No. OF ASSEMBLY UNIT, AND SERIAL No. WITH RUBBER SEAL.
15. HEADERS MAY BE SOLDERED WITH STACK USING SOLDER noc-40, GOST 21931-76
16. CHECK THREADING OF FLANGES AFTER SOLDERING.
17. SOLDERED JOINT OF FLANGE 765-03-153 WITH TUBE BOARD 765-03-128 SHOULD BE STRENGTHENED BY COVERING THE WHOLE THICKNESS OF FLANGE BEAD, SOLDER MAY FLOW INTO GROOVE.



Use solder noc-30-2 GOST 21931-76

Before soldering clearance between the beading of tube board partition and header contour should not exceed 0.5 mm.
 Tube board may be fitted in this case, clearance in corners at partition should not exceed 1.6 mm

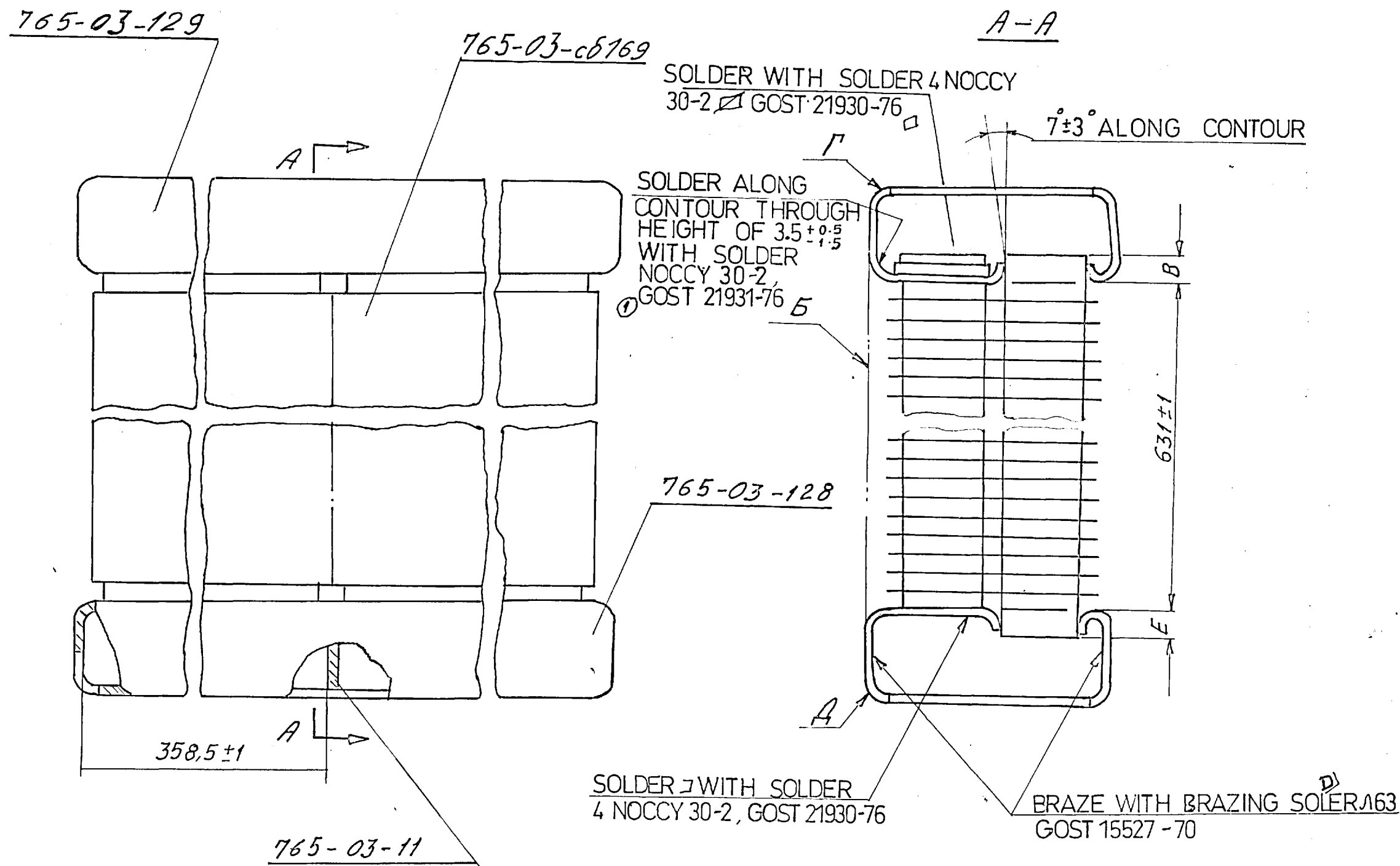
Sl.No	DESIGNATION	DESCRIPTION	QTY	REMARKS
1	765-03-c5166	STACK OF TUBES	1	
2	765-03-c5175	HEADER	1	
3	765-03-c5176	HEADER	1	
4	765-03-c5177	HEADER	1	

ORCL MATERIAL		ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF. DRG. NOT TO BE SCALED		ALL THREADS TO CONFORM TO SPECIFICATION.	STAMP OR ETCH, PART NO, MANUFACTURER'S NAME & YEAR OF MFR.
SCALE:- 1:1	DATE :- 30-01-03	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:- 765-03-K6
DRN. [Signature]	WT.-(Kg) 20.3	765-03-cb161	
TCD. [Signature]		OIL COOLER	
CHD. [Signature]		CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)	
AFD. [Signature]			

99180-03-03-59L

TECHNICAL CONDITIONS

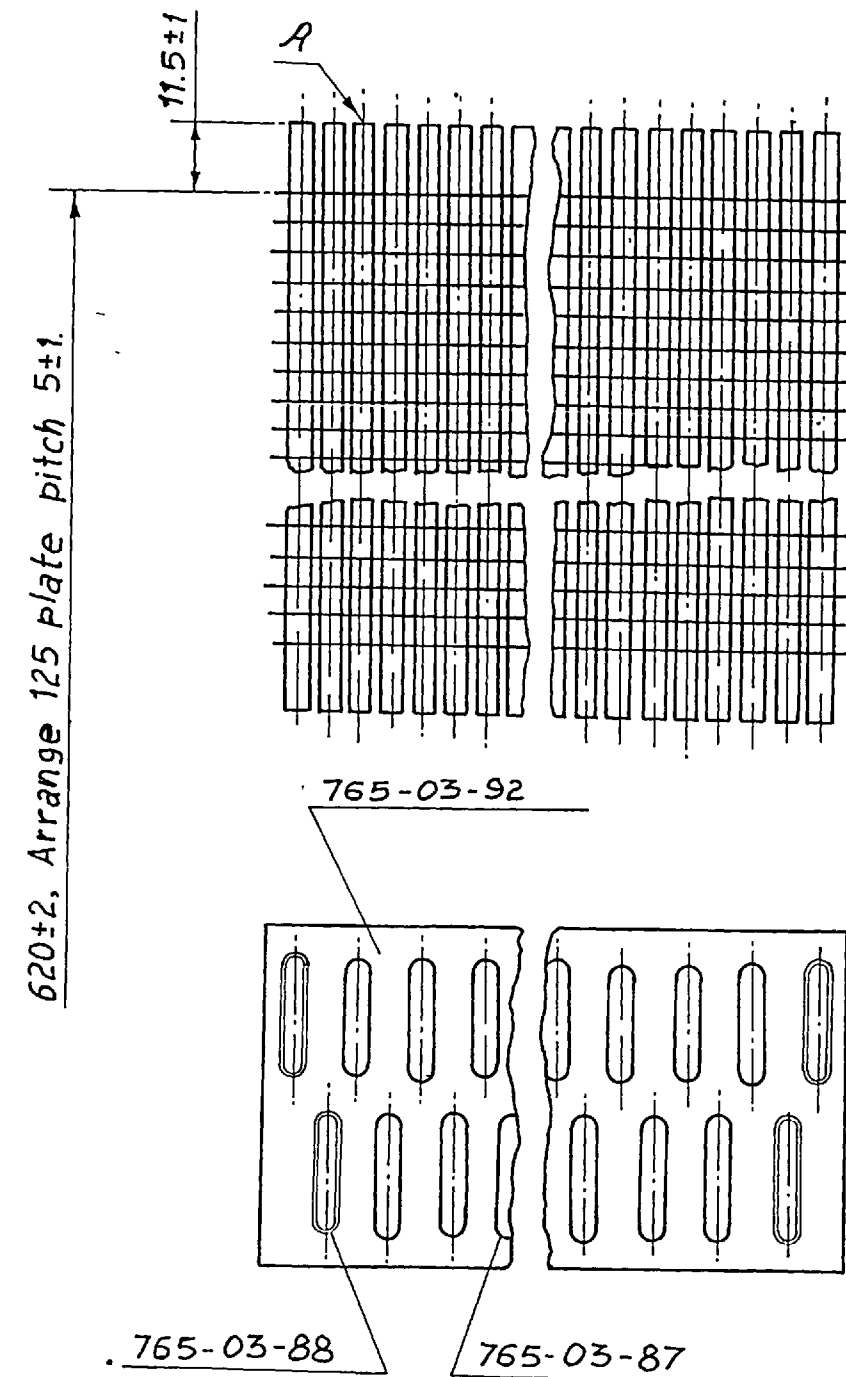
1. NON-SQUARENESS OF TUBES AND TUBE BOARDS SHOULD NOT EXCEED 3mm OVER THE LENGTH OF TUBES.
2. DIFFERENCE IN DIMENSIONS 'B' AND 'E' SHOULD NOT EXCEED 2mm.
3. EXCESS METAL AND DENTS ON SURFACE OF TUBES AND FINNS, BENDINGS OF FINNS AND REDUCTION OF SECTION OF TUBES BY MORE THAN 30% ARE NOT ALLOWED. SOLDER BULGING NOT EXCEEDING 0.25 OF THE FIN PERIMETER IS ALLOWED ON NOT MORE THAN THREE FINNS, LOCATED NEAR TUBE BOARDS.
4. IN CASE OF TUBE LEAKAGE, SOLDER IT FROM TWO BUTTENDS WITH SOLDER NOCCY 30-2, GOST 21931-76. NUMBER OF SOLDERED TUBES IN THE ENTRY SHOULD NOT EXCEED THREE PIECES.
5. CARRY OUT SQUEEZING OF TUBE BOARDS AT POINTS 'Г' AND 'Б' IN ASSEMBLY.
6. TEST THE STACK OF TUBES FOR LEAK PROOFNESS BY SUPPLYING AIR IN WATER BATH AT A PRESSURE OF 1kg/Cm² FOR 0.5 MIN. AIR LEAKAGE IS NOT ALLOWED.
7. IT IS ALLOWED TO SOLDER SECTION WITH TUBE BOARDS USING SOLDER NOC-40, GOST 21931-76.



REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
		BRAZING SOLDER 163		
	765-03-129	TUBE BOARD	1	
	765-03-128	TUBE BOARD	1	
	765-03-11	PARTITION	1	
	765-03-c8169	SECTION	2	

NEAREST EQVT MATERIAL			
ORGL MATERIAL	ISSUE	AMENDMENTS	
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.	ALL THREADS TO CONFORM TO SPECIFICATION.	STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR FR.	
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-	
SCALE:- 1:1	DATE :- 27-01-03		
DRN. TCD. CHD. APD.	WT: (kg) 17.12	STACK OF TUBES	
		765-03-Sb166	
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)			

DRAWING RETRACED ON 29-01-03



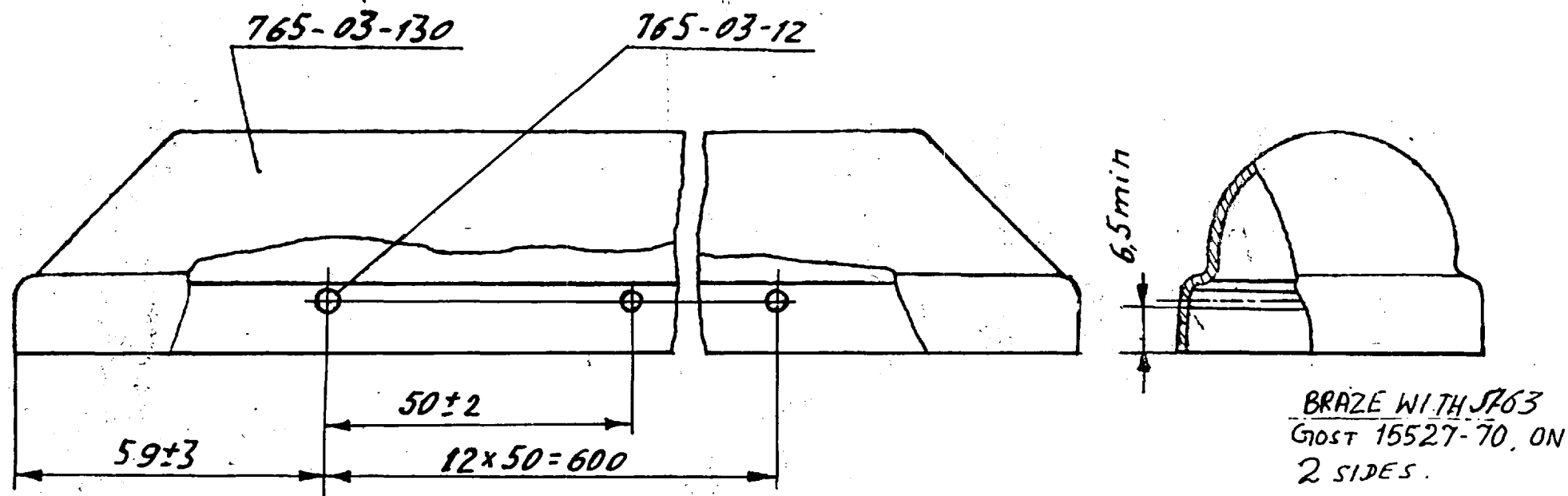
TECHNICAL CONDITIONS

1. ENDS OF TUBES A SHOULD BE IN ONE PLANE. DEVIATION FROM PLANE SHOULD NOT EXCEED 1mm.
2. DENTS ARE NOT ALLOWED ON TUBES AND PLATES.
3. NON-SQUARENESS OF TUBES AND PLATES SHOULD NOT EXCEED 3mm, OVER THE LENGTH OF TUBES.
4. SOLDER PLATES TO TUBES BY DIPPING THE SECTION INTO BATH WITH SOLDER 4 noccy 18-2, GOST 21930-76. EXCESS SOLDER ON TUBES AND PLATES IS NOT ALLOWED. POOR SOLDERING BETWEEN THE BEADED SURFACES OF HOLES IN PLATES AND TUBES IS NOT ALLOWED. LOCAL POOR SOLDERING OF TUBES WITH PLATES ALONG THE RADII IS ALLOWED. NUMBER OF POORLY SOLDER TUBES ALONG THE RADII SHOULD NOT EXCEED 10% OF VISIBLE SECTION SIDES.
5. CLEARANCE BETWEEN PLATE AND TUBE ALONG RADII BEFORE SOLDERING SHOULD NOT EXCEED 0.5mm.
6. DISPLACEMENT OF COOLING PLATES FROM COMMON PLANE OVER THE LONG SIDES SHOULD NOT EXCEED 1mm.
7. PLATES MAY BE SOLDERED TO TUBES WITH SOLDER 4noccy 30-2 GOST 21930-76 or 4 noc-40, GOST 21930-76.
8. BENDING OF EDGES ON PLATES IS ALLOWED ON LATERAL SIDE.

REF. No.	DESIGNATION	DESCRIPTION	QTY	REMARKS
	765-03-87	TUBE	79	
	765-03-88	TUBE	4	
	765-03-92	PLATE	125	

MATERIAL		DCI No. & DATE	ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF. DRG. NOT TO BE SCALED		ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
SCALE:- 1:1		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON:- 765-03-cb166
DATE :- 29-01-03				
DRN.	WT :-(Kg)	<p style="font-size: 2em; font-weight: bold;">765-03-cb169</p> <p style="font-size: 2em; font-weight: bold;">SECTION</p> <p style="font-weight: bold;">CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)</p>		
TCD.	8.0			
CHD.				
APD.				

765-03-6175



1. Warpage of walls should not exceed 2 mm.
2. Coating: FOP 4NOCCy 18-2 or FOP 4NOCCy 30-2, GOST 21930-76.

USED ON-765-03-C6161

REF NO.	Designation	Description.	qty	Remarks.
1	765-03-12 ✓	Spacer	13	
2	765-03-130 ✓	Header	1	
		Brazing solder SP63.		

APPROVED	<i>[Signature]</i> VASU	765-03-c6175	
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF INSPECTION (ICV)		HEADER	WEIGHT SCALE
			0.76 1:1
			ENT SHTS