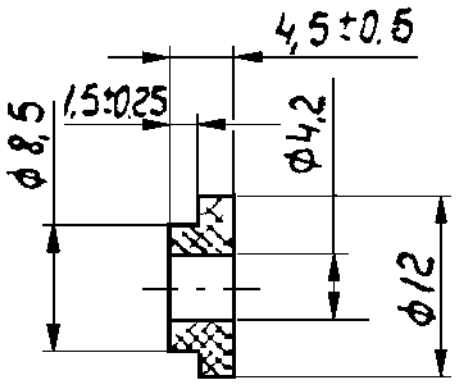
272-26-669

Rz80



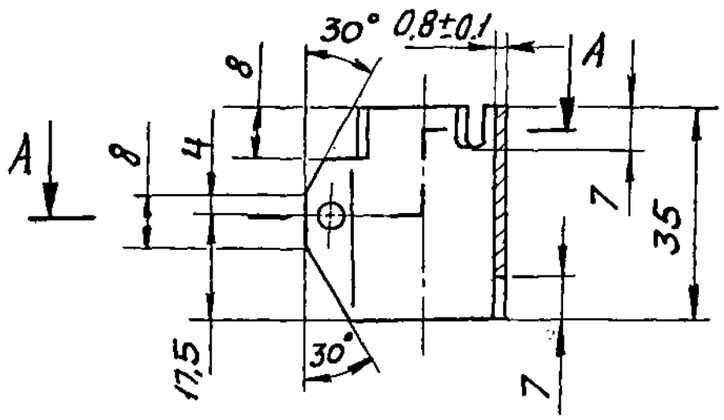
TECHNICAL CONDITIONS

1. Alternate material is textolite 6-4,5 GOST 2910-74.
2. Unspecified limit deviations of dimensions are for holes-as per A7 and for shafts-as per B7.

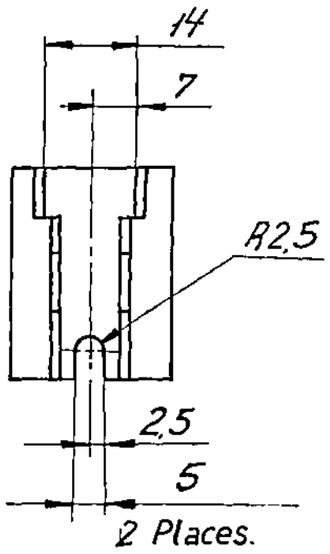
APPROVED	R VASU	272-26-669		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		BUSHING	WEIGHT: 0,0023	SCALE: 2:1
			SHT	SHTS
		TEXTOLITE BAR GOST 5385-74		

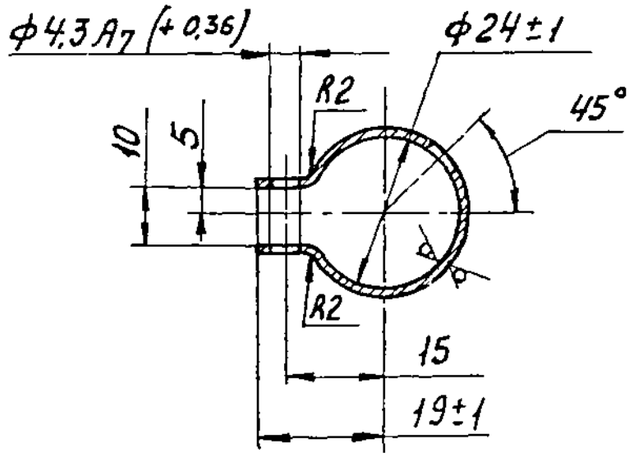
272-26-671

Rz320 (V)



A-A





TECHNICAL CONDITIONS

1). Alternate material is 12x18H10T GOST 5632-72.

2). Unspecified limit deviations of dimensions are ±0.5mm

3). It is permitted to manufacture casing from material with thickness 0.5 ±0.07

Ⓐ EQ. MATERIAL :- IS:6911-72 Gde.04 Cr 18 Ni 10 Ti 20

00677-ICV 05 FEB 99	Ⓐ	IS:6911-72 Gde.04 Cr 18 Ni 10 Ti 20 ADDED AS EQ MATERIAL
DC(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED	M VASU	272-26-671		
CHECKED	H.M.Shanker			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		CASING	WEIGHT	SCALE
			0.017	1:1
			SHT	SHTS
		STEEL 12X18H9T GOST 5632-72		

272-26-672

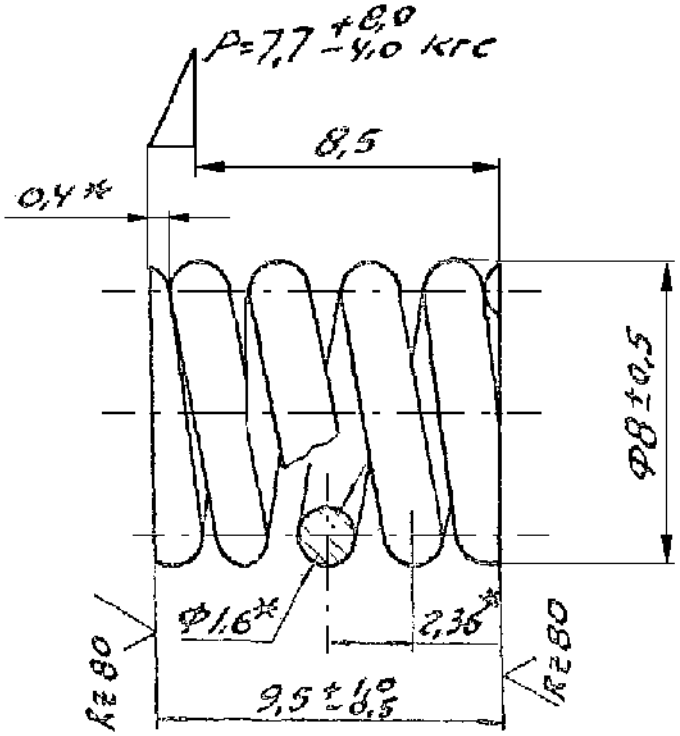
TECHNICAL CONDITIONS

1) Alternate material is flexible micainite cast iron ГФС GOST 6120-75.

2) * Dimensions are given for reference.

APPROVED	M VASU	272-26-672		
CHECKED	H.M.S Laiku			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		GASKET	WEIGHT: 0.002	SCALE: 1:1
			SHT	SHTS
		FLEXBLE MICANITE - CAST IRON ГМС 0,15 GOST 6120-75		

700-38-1711



1. Shear modulus is $G^*=8000$ Kgf/mm^2
2. Tangential (Torsional) stress (Maximum) is $T_3^*=47$ Kgf/mm^2
3. Total length of the wire spring $L^*=110$mm
4. Number of working coils is $n=3$
5. Total number of coils is $n_1=5 \pm 0.25$.
6. Direction of coiling is Left-hand
7. Non-squareness of axis of spring to butt-ends should not exceed 1mm.
8. Machined surface of butt-ends should not be less than 3/4 of coil.
9. * Dimensions are given for reference.
10. Coating: Zinc-plated, 9 microns thick, chromatized. Remove hydrogen embrittlement.

Ⓐ EQ. MATERIAL:- GR.2 TO IS: 4454-81

DC(I)No. & DATE	ISSUE	AMENDMENTS
00674-ICV 13 JAN 99	Ⓐ	GR.2 TO IS:4454-81 ADDED AS EQ. MATERIAL

APPROVED	H VASU	700-38-1711
CHECKED	V.P. Reddy	

CONTROLLERATE OF QUALITY ASSURANCE (ICV)

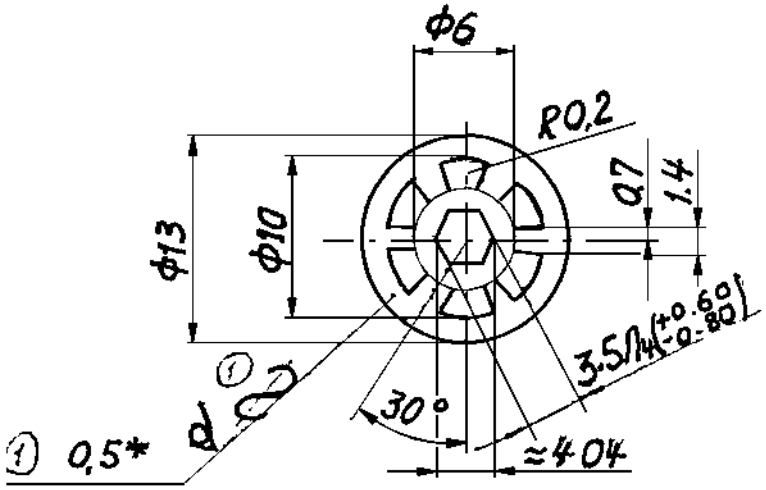
SPRING

WIRE II - 1.6, GOST 9389-75

	WEIGHT	SCALE
	0.002	5:1
SHT	SHTS	

A4

701-23-41



1. Unspecified limit deviations of dimensions are ±0,3mm.

2. * Dimension is given for reference.

Ⓐ EQ.MATERIAL:-Gde.CUZN 37 TO IS:410-77.

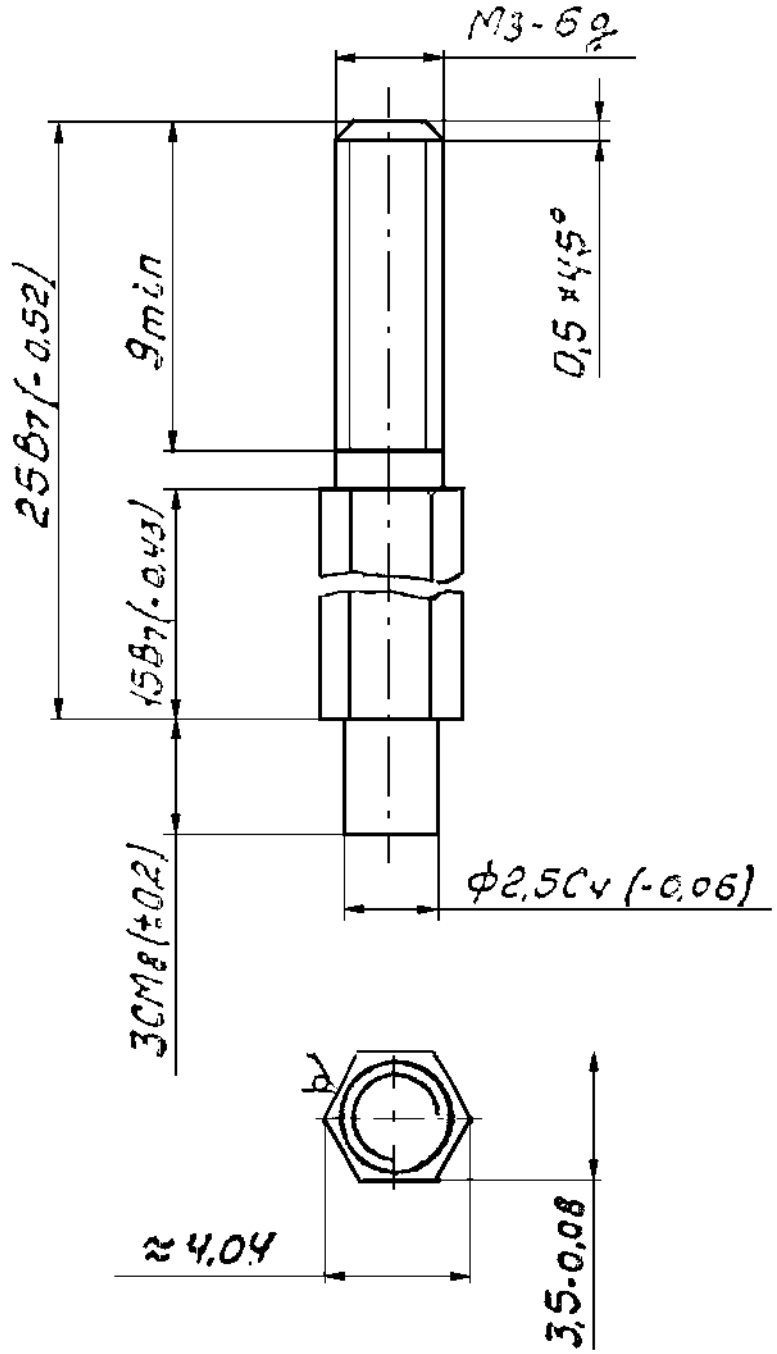
DC(I)No. & DATE	ISSUE	AMENDMENTS
00677-ICV 05 FEB 99	Ⓐ	Gde CUZN 37 TO IS:410-77 ADDED AS EQ.MATERIAL

APPROVED	M.VASU	701-23-41	
CHECKED	K.M.Shanker		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		END PLATE	WEIGHT: 0.0005; SCALE: 2:1; SHT SHTS
		SHEET Л ПРХМ-0.5 Л63М GOST 931-78	

A4

701-23-42

Rz 80 (V)



1. Alternate material is Л 63 GOST 15527-70.
2. Incomplete thread is not allowed.
Ⓐ EQ. MATERIAL CuZn37 IS:4413-81

00676-ICV 04 FEB 99	Ⓐ	EQ. MATERIAL ADDED. IN THE DRAWING
DC(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED	M. VASU	701-23-42
CHECKED	N.M.Shaikh	

CONTROLLERATE OF QUALITY ASSURANCE (ICV)

COVER ROD

WIRE W-T 3·5-4ЛС-59-1 GOST 1066-75

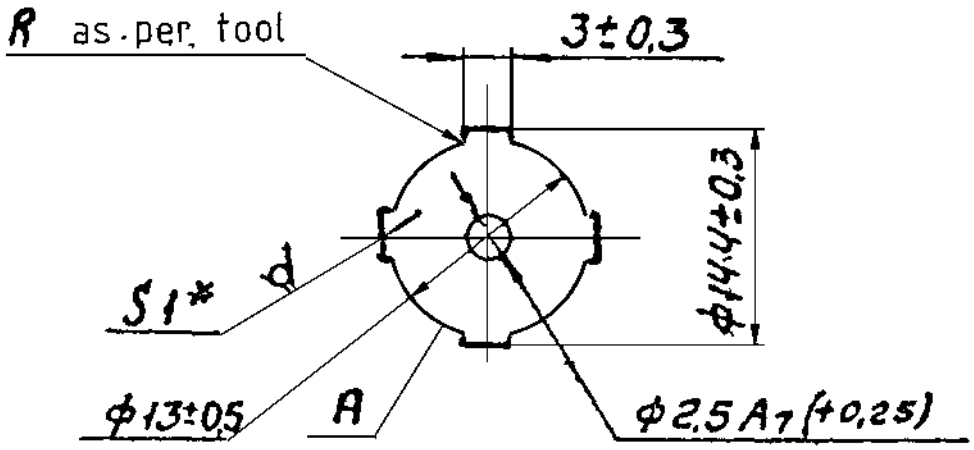
WEIGHT	SCALE
0.0025	5:1

SHT SHTS

A4

701-23-43

Rz320 (V)



1. Displacement of axis of hole with respect to the axis of surface A should not exceed 0,25mm.
2. * Dimension is for reference.

Ⓐ EQ. MATERIAL:- Gde. CUZN 37 TO IS: 410-77

DC(I)No. & DATE	ISSUE	AMENDMENTS
00677-ICV 05 FEB 99	Ⓐ	Gde. CUZN 37 TO IS: 410-77 ADDED AS EQ. MATERIAL

APPROVED	M VASU
CHECKED	H-M Shaikh

701-23-43

CONTROLLERATE OF QUALITY ASSURANCE (ICV)

FILTER COVER

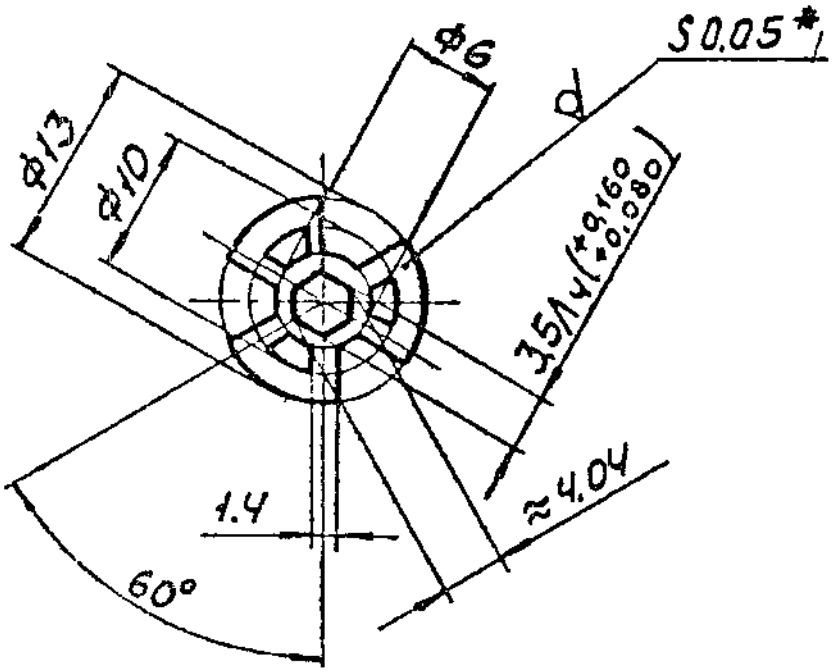
	WEIGHT	SCALE
	0.001	2:1

SHT SHTS

SHEET Апрхм-1.0 Л163М
GOST 931-78

A4

701-23-44



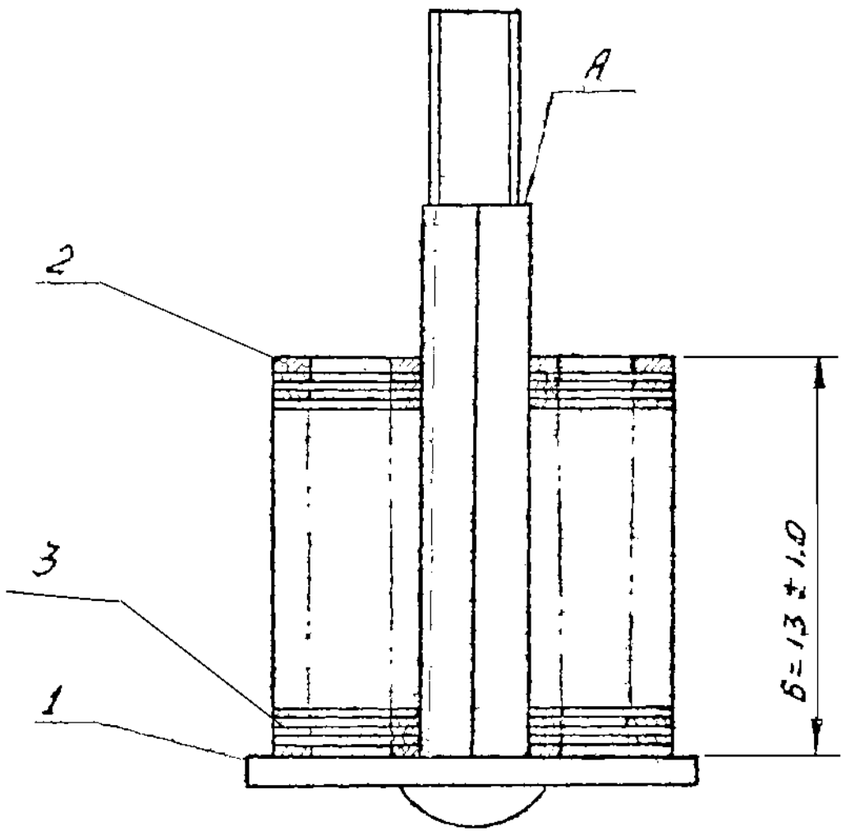
1. Unspecified limit deviations of dimensions are ±0,3mm.
2. * Dimension is for reference.

APPROVED	M VASU	701-23-44	
CHECKED	H·M·Shaikh		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		FILTER PLATE	WEIGHT: 0.0002; SCALE: 2:1; SHT; SHTS
		BAND N63T-0.05 GOST 2208-75	

Format	Ref No.		Designation	Description	Qty	Remarks
				Technical papers		
12			701-23-cb107CB	Assembly drawing		
				Assembly units		
	1		701-23-cb112	Cover	1	
				Parts		
11	2		701-23-41	End plate	1	
11	3		701-23-44	Filter plate	335 Max	Qty

APPROVED	M.VASU	701-23-Sb107	
CHECKED	PRASH		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		FILTER	WEIGHT / SCALE / SHT / SHTS

701-23-Sb107Sb



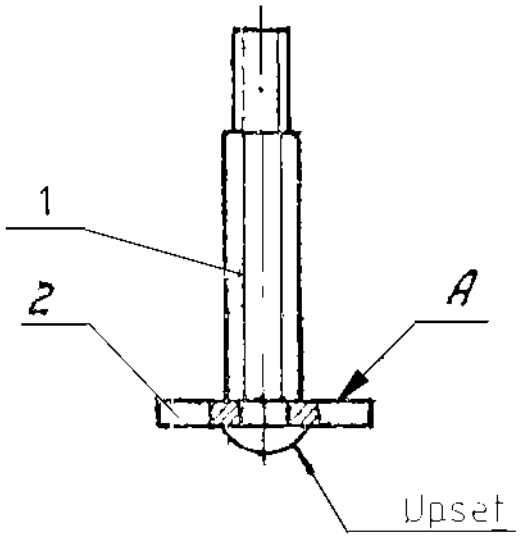
TECHNICAL CONDITIONS

1. The filter sheets should be assembled in such a way that, the sector of each following sheet overlaps the openings of the preceeding sheet.
2. Check dimension Б when the sheets are lightly pressed against the cover. In this case, the number of sheets should not be less than 230.
3. Compress butt-end A, after which the final sheet Ref.No.2, should be kept from falling out of the rod with the aid of burr which is formed while compressing.

APPROVED	M.Vasu	701-23-Sb107Sb	
CHECKED	PRASAD		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		FILTER (ASSEMBLY DRAWING)	WEIGHT 0.1 / SCALE 5:1
			SHT 1 SHTS 1

A3

701-23-Sb112

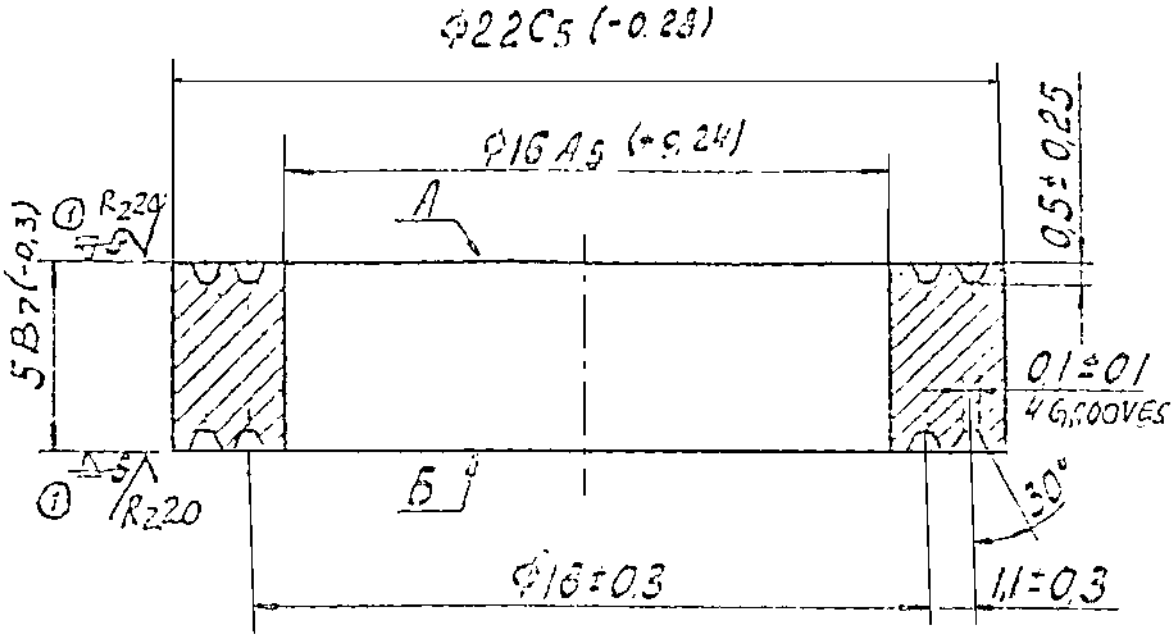


1. Non squareness of surface A, with respect to the axis of rod should not exceed 0,2mm, over length 13mm

Forma	Zone	Ref.No.	Designation	Description	Qty	Remarks
				Parts		
11		1	701-23-42	Cover Rod	1	
11		2	701-23-43	Filter cover	1	

APPROVED		701-23-Sb112	
CHECKED	PRASAD		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	COVER	WEIGHT: 0.003	SCALE: 2:1
		SHT	SHTS

730-26-268



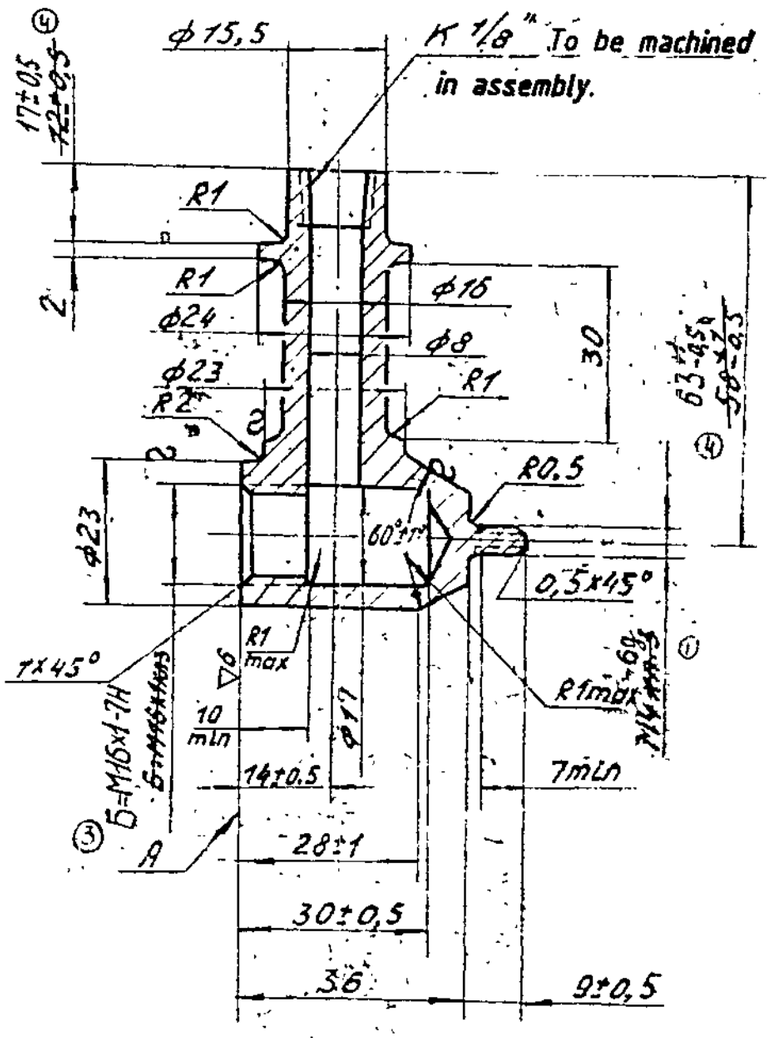
1. Anneal -
2. Non-parallelism of planes A and Б at extreme points should be 0,1mm over a length of 22mm.

(A) EQ. MATERIAL 15:2501-72 Gr. DHP

DC(I)No. & DATE	ISSUE	AMENDMENTS
00676-ICV 04 FEB 99	(A)	EQ. MATERIAL ADDED. IN THE DRAWING

APPROVED		730-26-268	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	GASKET	WEIGHT 0.01	SCALE 5:1
		SHT	SHTS
	M2T GOST 859-78		

765-06-477



▽ 3 Unless other wise specified.

1. Burrs are not allowed.
2. Perform dimensions of machined surfaces specified without deviations as per accuracy class 7 OST 1010.
3. Other requirements for forging are as per class II GOST 7505-74.
4. Non-squareness of surface A to the axis of thread 6 should not exceed 0.16, over the length of 2.0 (qualified tolerance)
5. On unmachined surfaces dents and nicks should not exceed 0.7 mm in depth. Other surface defects and their dressing to a depth of no more than 1mm are allowed.
6. Alternate material is 12x 18H 10T ∅GOST 5632-72.

Ⓐ EQ. MATERIAL IS: 6911-72 Gde.04 Cr 18 Ni 10 Ti 20

08677-ICV 25-02-05	Ⓐ	EQUIVALENT MATERIAL ADDED IN THE DRAWING
DC(I) NO & DATE	ISSUE.	NATURE AMENDMENT

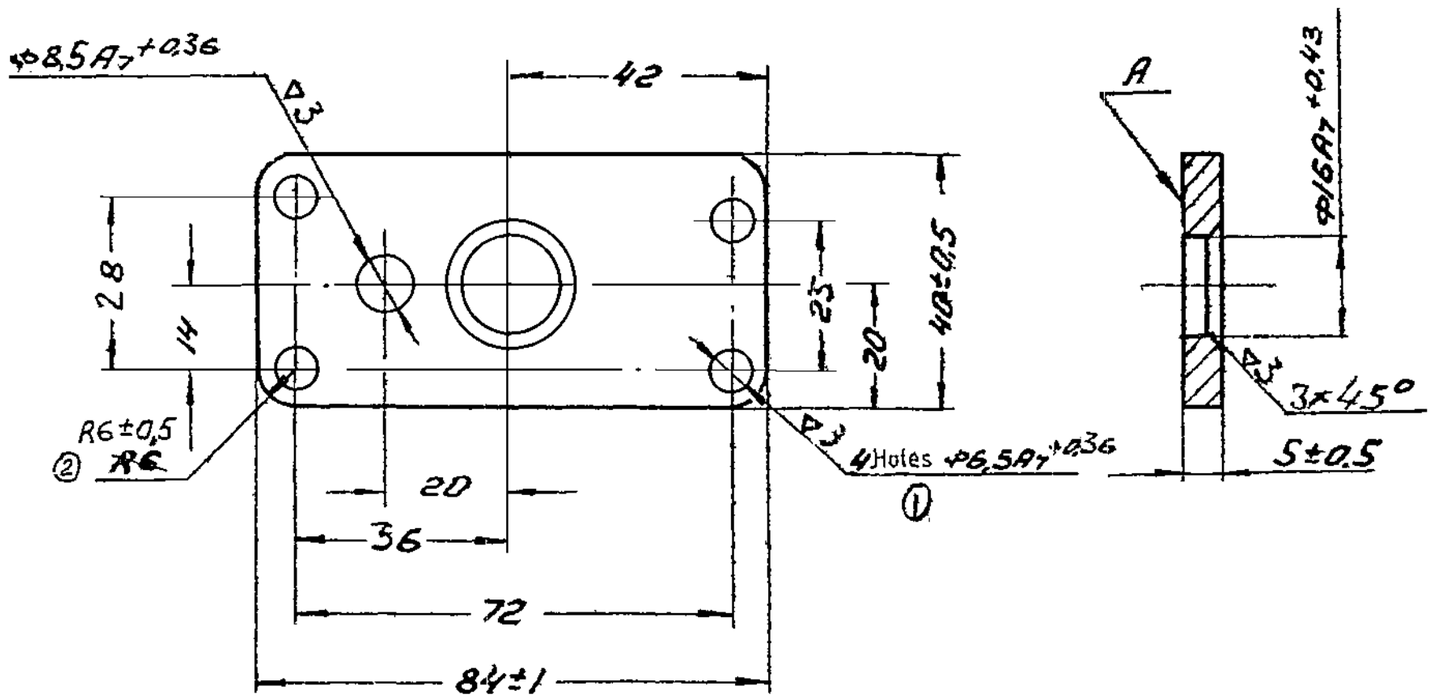
APPROVED	N VASU	765-06-477	
CHECKED	H.M.Sharma		
CONTROLLERATE OF INSPECTION (ICV)		BODY	WEIGHT 0.013 / SCALE 1:1
		12X18H9T GOST 5632-72	SHT SHTS 207 OF

06

Перв. примен. | Инв.№ дубл. | Взам. инв.№ | Подп. и дата | Инв.№ подл. 9г-4012

765-90-SGL

2 unless otherwise
(2) specified



1. Blunt sharp edges
2. Displacement of axes of holes from true position should not exceed 0,25mm
3. Nonflatness of surface A, should not exceed 0,3mm, straightening is allowed
4. Alternate material is steel cm3cn GOST 380-71, 10, 15 25, GOST 1050-74 and 15Γand 20ΓGOST 4543-71
5. Stamping draft should not exceed 0,5mm

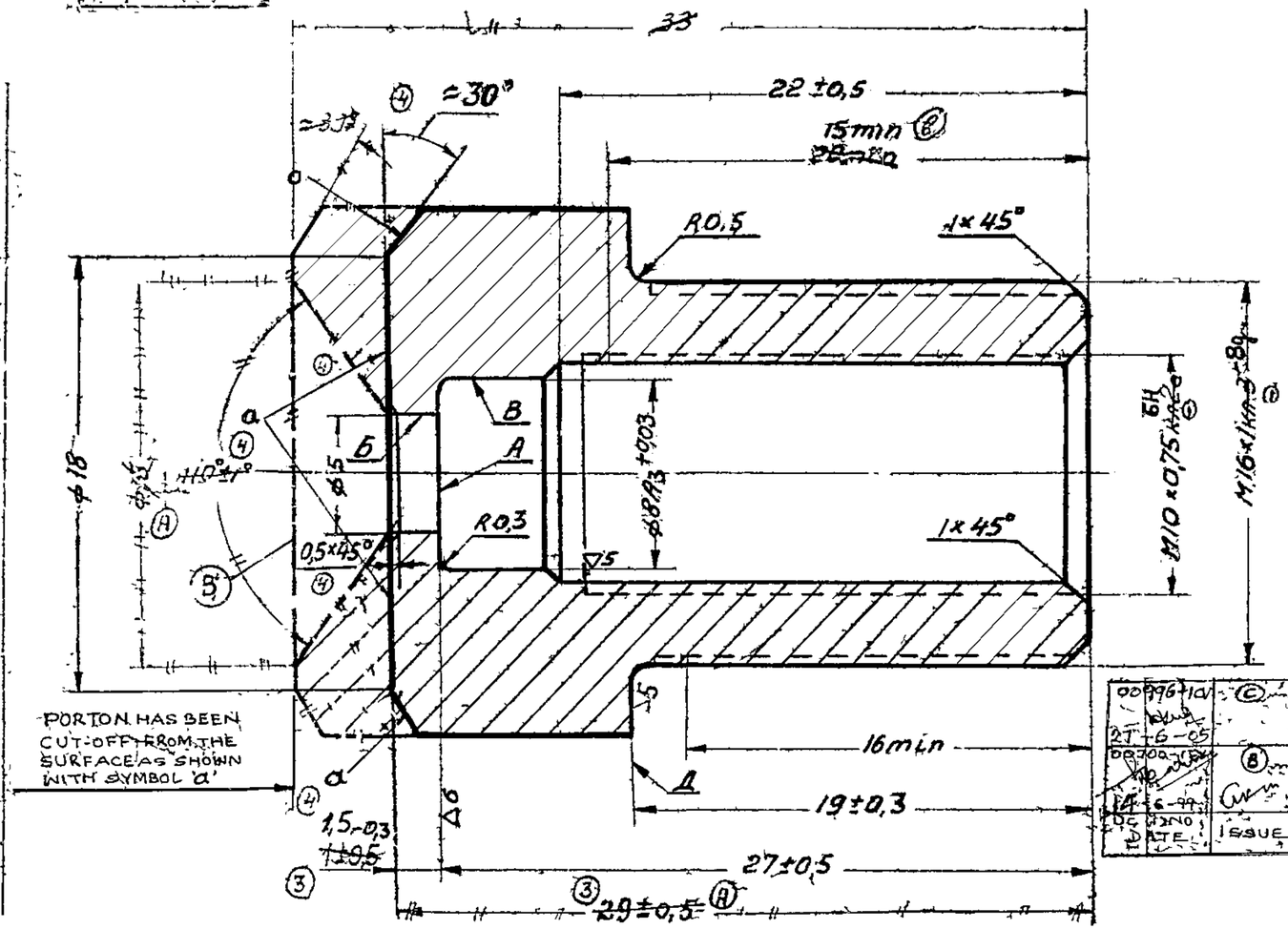
(A) EQ. MATERIAL:- GY.St 34 0R Fe330 TO IS: 1079-73

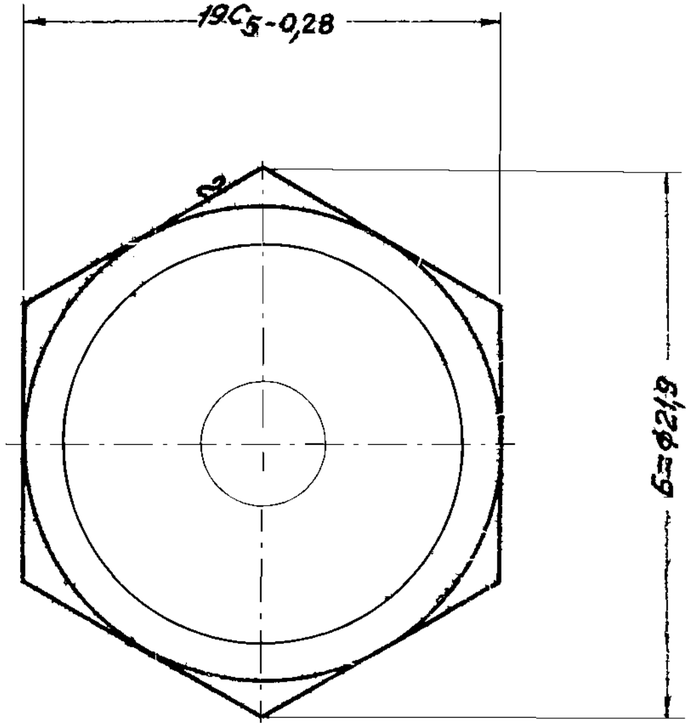
00662 ICV 10-11-98	(A)	GY.St 340R Fe 330 TO IS:1079-73 ADDED AS EQ. MATERIAL
DC(I) No DATE	ISSUE	NATURE / AMENDMENT

APPROVED	(I YASU)	765-06-478	
CHECKED	H·M·Shaik		
CONTROLLERATE OF INSPECTION (ICV)		COVER	WEIGHT 0,115 / SCALE 1:1
		10 GOST 1050-74	SHT SHTS 209 OF 379

765-06-533

V3 unless otherwise specified





00996-ICV 2T-6-05	©	DS CAT PART ADDED AND DESCRIPTION ADAPTOR BUSHING WAS EJECTOR BODY
00700-ICV 14-6-99	B	PORTION FROM SURFACES (AS MARKED WITH SYMBOL 2) HAS BEEN REMOVED/CUT OFF AT FAR WITH COLLABORATOR PRINT NR & AMENDED PICTORIALLY
DCU No DATE	ISSUE	NATURE AMENDMENT

1. Blunt sharp edges on external surfaces.
2. Perform dimensions without deviations as per accuracy class 7, OST 1010.
3. Run-out of surface A with respect to surface B should not exceed 0,1mm.
4. Eccentricity of surfaces 6 and B should not exceed 0,3mm.
5. Runout of surface A with respect to the axis of external thread should not exceed 0,1mm.
6. It is allowed to machine diameter E upto Φ21, min.
7. Coating chemically oxidized, oiled.
8. Alternate material is steel cm6, GOST 380-71 steel 35.40.50, GOST 1050-74, and steel 40F GOST 4543-71
9. While facing face A, tool incision to depth not exceeding 0,5mm and width not exceeding 2mm is allowed on the cylindrical surface.

(A) EQ. MATERIAL:- CLASS 4, 45C8 TO IS: 2004-78

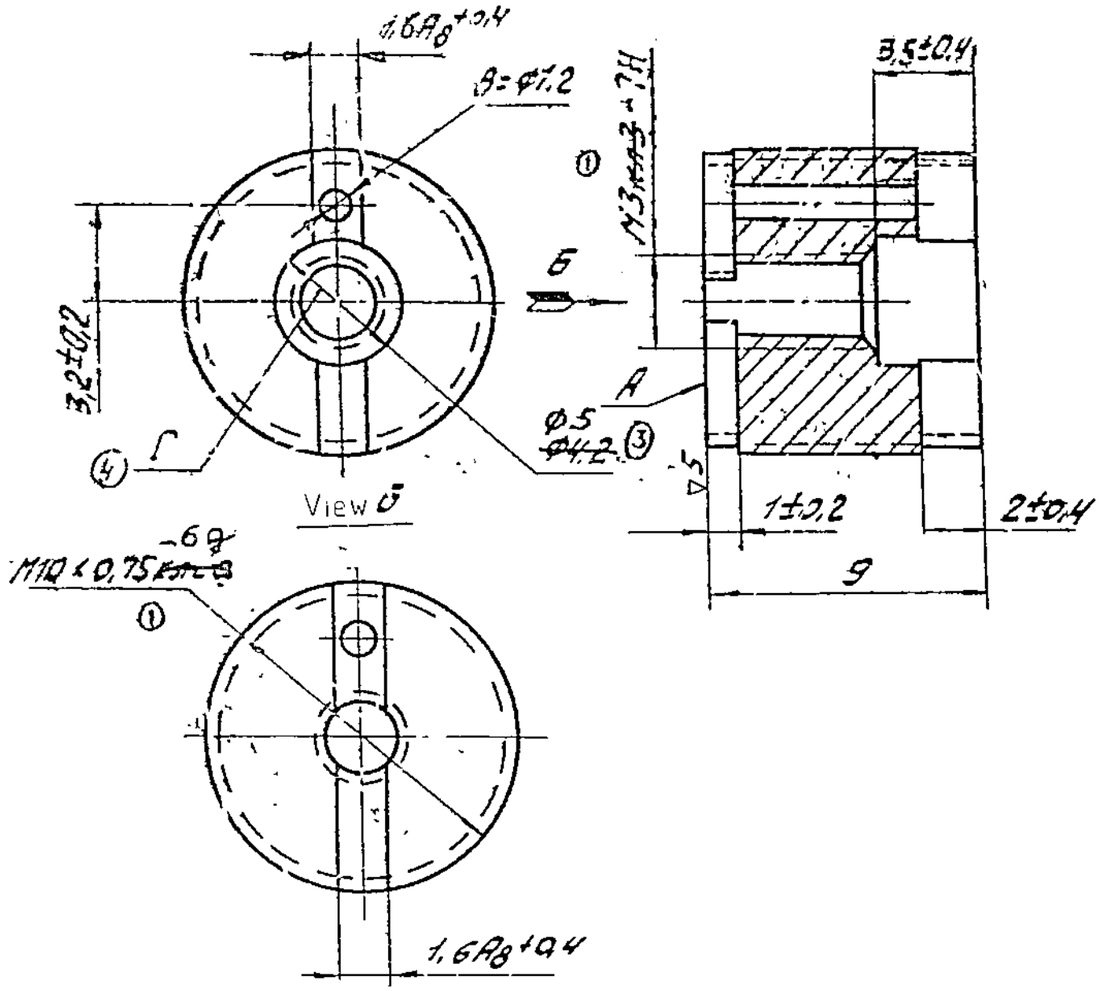
00651-ICV V.Ramesh 29-10-98	(A) Gr	CLASS 4, 45C8 TO IS: 2004-78 ADDED AS EQ. MATERIAL
DCU No DATE	ISSUE	NATURE AMENDMENT

APPROVED	M VASU	765-06-533 © DS CAT No: LV2/ICVS 4730-00741-3	
CHECKED		ADAPTOR BUSHING © ~~INJECTOR BODY~~	WEIGHT 0,04 / SCALE 5:1
CONTROLLERATE OF INSPECTION (ICV)		45 GOST 1050-74	SHT 371 OF 379

06

765-30-534

▽3. unless otherwise specified



1 Blunt external sharp edges
2 Perform dimensions without deviations as per accuracy class 7, OST 1010
3 Runout of surface A with respect to axis of external thread should not exceed 0,1mm on Ø8
4 Coating Chemically oxidized, oiled
5 Alternate material is steel CT6, GOST 380-71, steel 35,40,50, GOST 1050-74 and steel 40Г, GOST 4543-71
6 Displacement of axis of hole B with respect to axis of slot should not exceed 0,3mm (qualified tolerance)
7. Incision of hole B in hole Г is allowed, in this case, do not check the incision

(A) EQ. MATERIAL:- CLASS 4, 45 C8 TO IS: 2004-78.

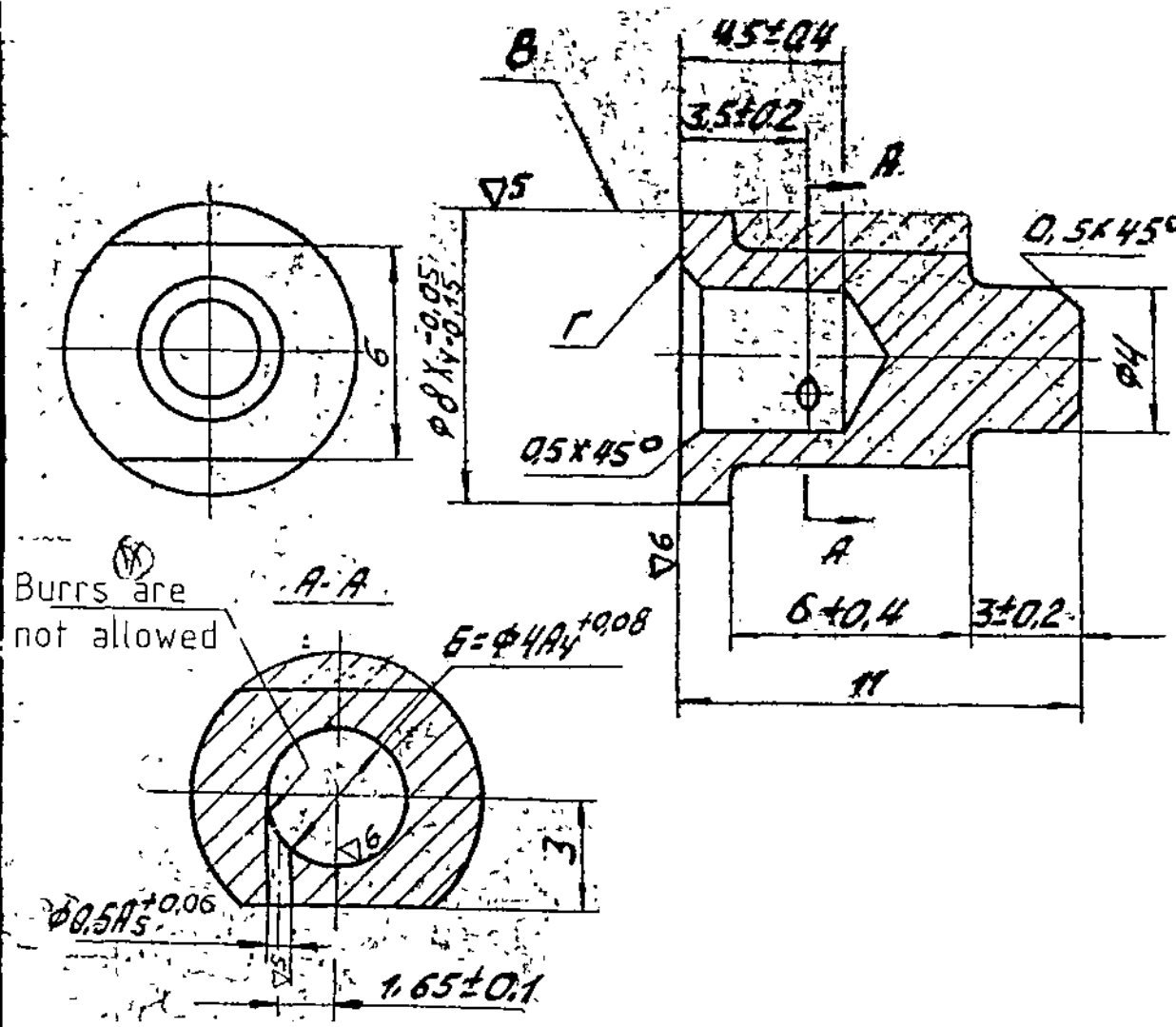
00651-ICV V.Ramana 29-10-98	(A)	CLASS 4 45 C8 TO IS: 2004-78 ADDED AS EQ. MATERIAL
DCN No DATE	ISSUE	NATURE AMENDMENT

APPROVED	M VASU	765-06-534	
CHECKED	H.M.Shaikh	SCREW	WEIGHT 0.004 / SCALE 5:1
CONTROLLERATE OF INSPECTION (ICV)		45 GOST 1050-74	SHT / SHTS; 372 OF 379

06

565-90-591

▽3 Unless other-
(8) wise specified



EQUIVALENT MATERIAL ADDED IN THE DRAWING | NATURE OF AMENDMENT
(A) | ISSUE
00676-ICV | DC(I) NO & DATE
4-02-99

(A) EQ. MATERIAL IS:531-81 GDE CuZn 39 Pb2.

1. Blunt sharp edges.
2. Perform dimensions without deviations as per accuracy class 7, OST 1010.
3. Runout of surfaces Г and b with respect to surface B should not exceed 0,08mm
4. Unspecified radii of rounding-off should not exceed0,5mm
5. Part may be manufactured as per conventional dotted line.

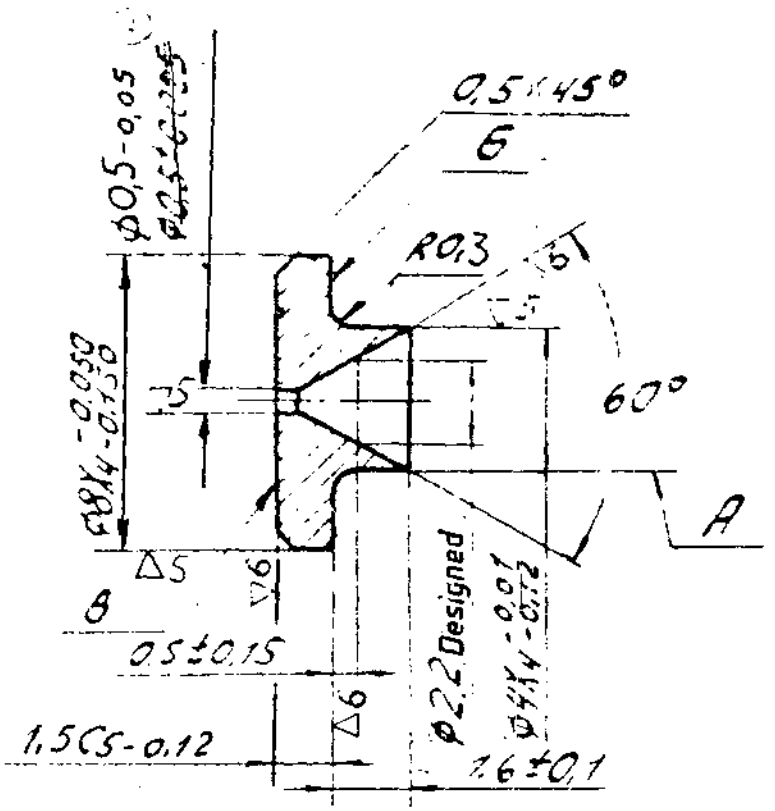
Подп. и дата | Инв. № дубл. | Взам. инв. №

APPROVED	M VASU	765-06-535	
CHECKED			
CONTROLLERATE OF INSPECTION (ICV)		AUTOMIZER BODY	WEIGHT 0.002 / SCALE 5:1
			SHT / SHTS
		NC-59-1 GOST-15527-70	218 OF 379

06

019-90-59L

▽3 Unless otherwise specified



1. Runout of surface 6 should not exceed 0.08 mm with respect to surface A.

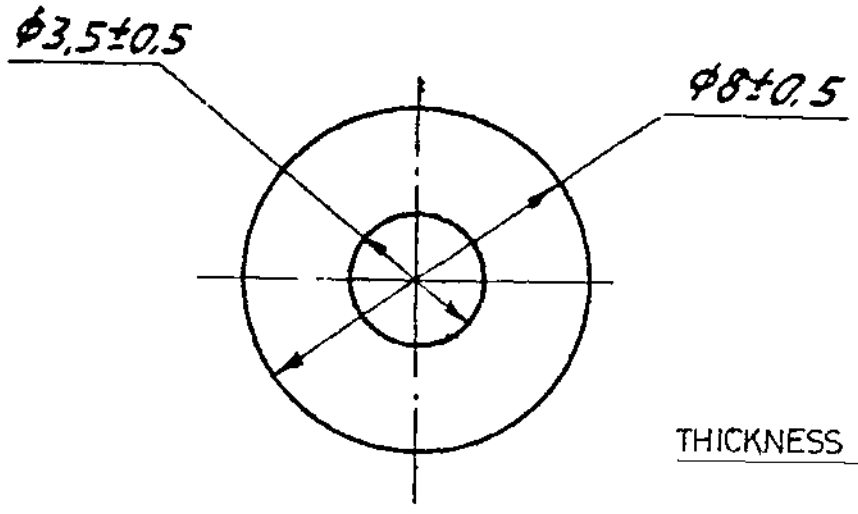
2 Non-parallelity of surface 6 and B should not exceed 0.08 mm.

3 Blunting of edges is allowed at place of change from tapered to cylindrical surface.

APPROVED	M VASU	765-06-610	
CHECKED			
CONTROLLERATE OF INSPECTION (ICV)		AUTOMIZER	WEIGHT: 0,001 SCALE: 5:1
			SHT SHTS
		IT C59-1 GOST 15527-70	247 OF 379

06

259-90-591



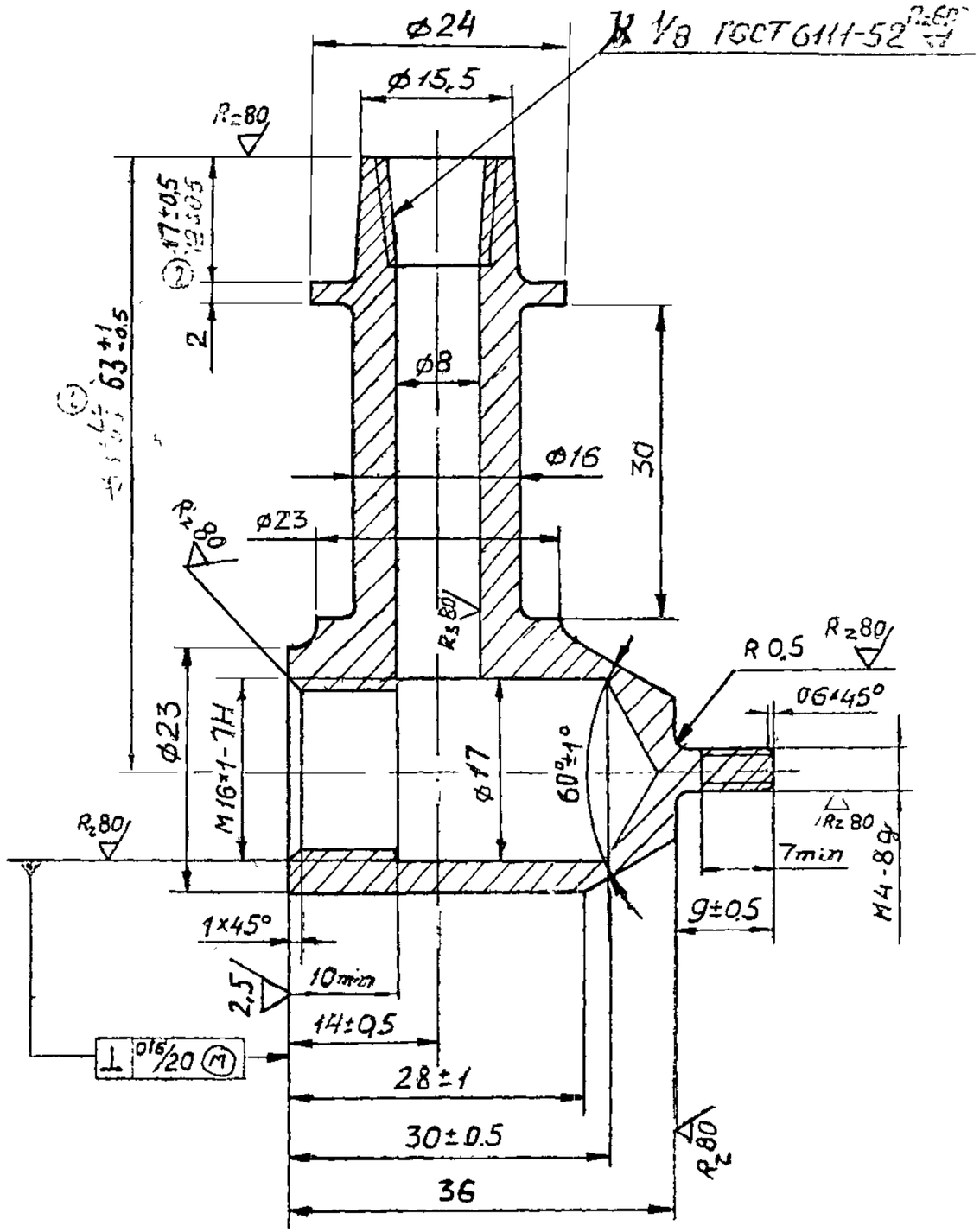
THICKNESS 1±0·3

1. ALTERNATE MATERIAL IS RUBBER 637 OR 632 TY 005216-75.
2. OTHER REQUIREMENTS AS PER TY 005216-75 FOR ARTICLE OF COAD 254311.

MATERIAL: PLATE 254311-1 / RUBBER 1638 TY 005216-75.

APPROVED	H VASU	765-06-652	
CHECKED			
CONTROLLERATE OF INSPECTION (ICV)		GASKET	WEIGHT 0,0001 / SCALE 5:1
			SHT - SHTS
			250 OF 379

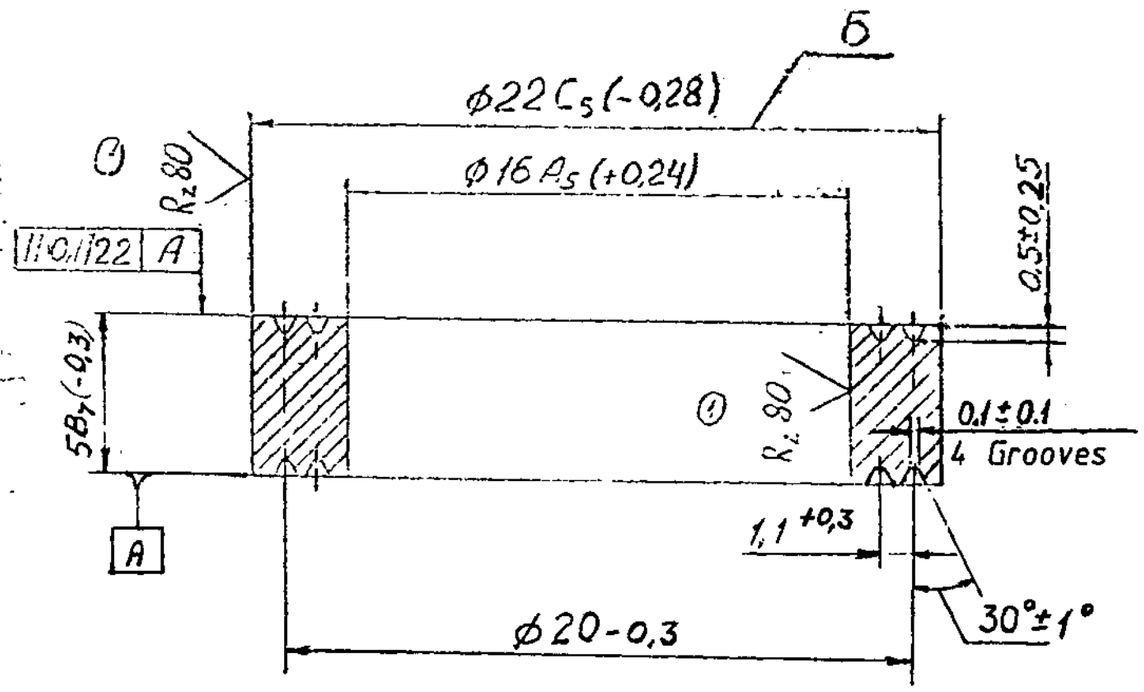
06



1 Alternate material is casting 15x23H18 Л-I GOST2176-77
2 Unspecified pattern radii should not exceed 2mm
3 Pattern drafts should not exceed 2°
5 Unspecified limit deviations of dimensions for surfaces to be machined are as follows
for holes as per A7, for shafts as per B7, for othersCM7,
6 Dimension given in brackets are after assembly
7 Pusher traces should not exceed 0,5mm
8 Displacement along the line of joint may be upto 0,3mm
9 Check for air tightness by coating with chalk from the external side and apply moistening with kerosene GOST 4753-68 from the internal side Kerosene traces should not appear on surface, coated with chalk, check 15 minutes after moistening
4 Other requirements placed upon casting are as per OST 3-4365-79

APPROVED	M VASII	765-06-1005	
CHECKED	M Shankar		
CONTROLLERATE OF INSPECTION (ICV)		BODY	WEIGHT 0,013 / SCALE 2:1
		CASTING 12X18H9T Л-I GOST 2176-77	SHT SHTS 208 OF 379

765-06-1017



1. **Density of sintered copper should be at least 8.0 g/cm^3**

2. **Check mechanical properties by diametral deformation of** dimension 6 upto dimension 10 mm, In this case:
   a) P=80 to 100 Kg.
   b) Bending places should be free from cracks.

3. Acceptance of parts is carried out by TID in accordance with requirements of drawing.

4. Parts are submitted for acceptance in batches
   The batch includes the parts made of same single mix

5. 2% of parts from each batch, are subjected to checking and testing as per item 1 and item 2.

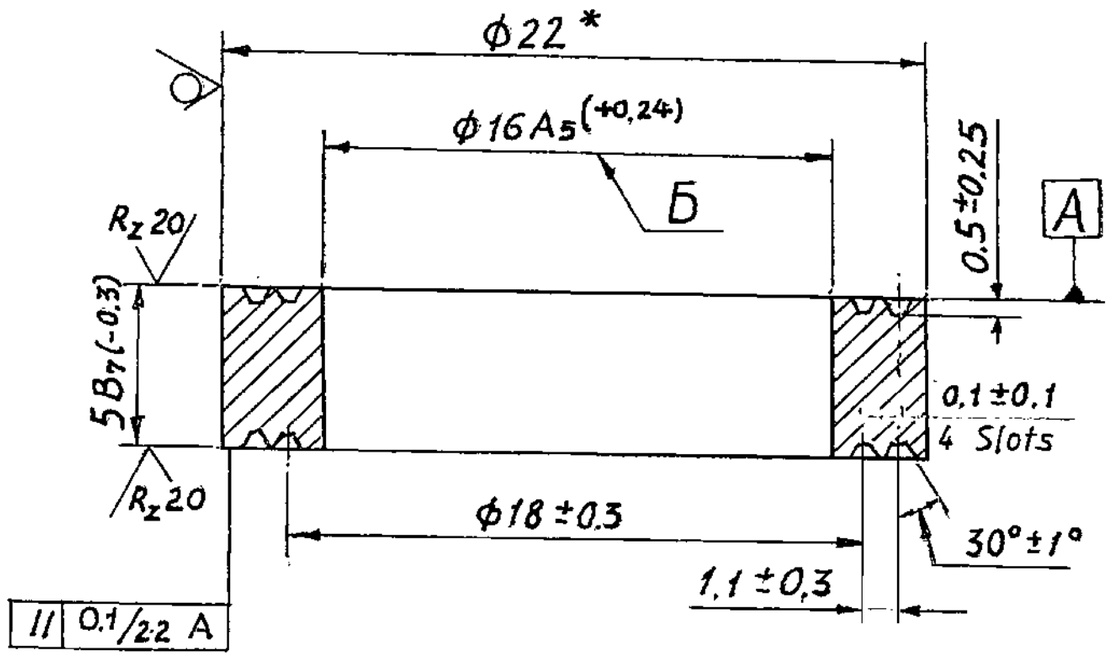
6. While obtaining, if the test results are non-satisfactory as per any parameter, re-testing is carried out as per this parameter on doubled number of parts. In case the results of retests are non-satisfactory, results of the batch is rejected.
   100% checking of the rejected batch of parts, illumination of faults and submittance of the parts, as a new batch. are allowed.

7. Each batch of parts, accepted by TID should have a tag indicating the number, quantity of parts per batch and TID stamp.

APPROVED	M.V.G.	765-06-1017	
CHECKED	H.M.S.		
CONTROLLERATE OF INSPECTION (ICV)		GASKET	WEIGHT 0,01 / SCALE 5:1
			SHT / SHTS
		ПМС-1 GOST 4960-75	341 OF 379

765-06-1018

R_z 80 (V)



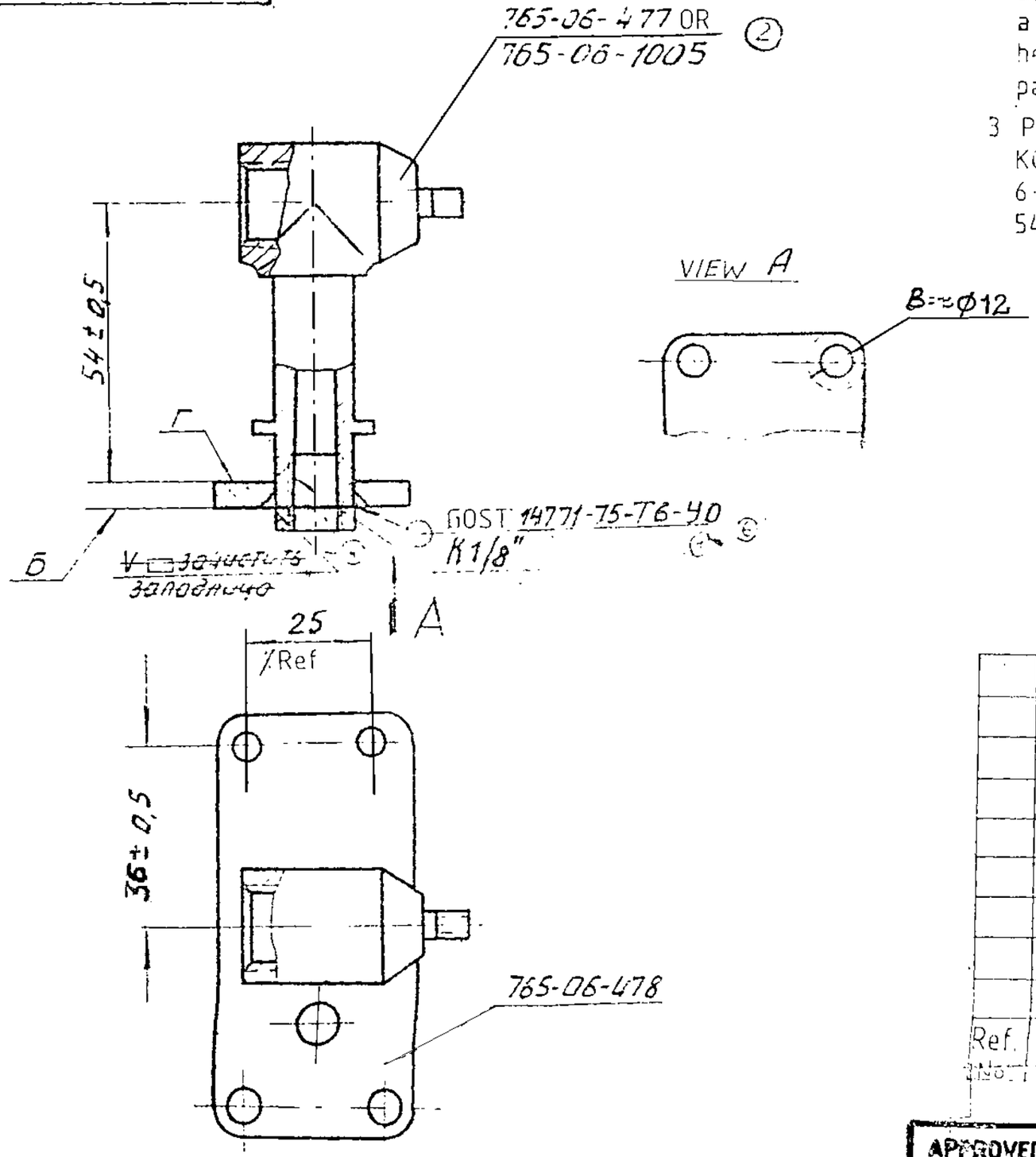
1. Gasket may be made from pipe M3M 22x3, GOST 617-72. In this case, dimension 6 may be performed of $16^{+0.5}$ mm dia.
2. * Dimension is given for reference.

Ⓐ EQ. MATERIAL Gr. DHP TO IS:2501-72

006[illegible]-ICV 25-02-99	Ⓐ	EQUIVALENT MATERIAL ADDED IN THE DRAWING.
DC(I) No. DATE	ISSUE	NATURE AMENDMENT

APPROVED		765-06-1018	
CHECKED			
CONTROLLERATE OF INSPECTION (ICV)	GASKET	WEIGHT 0.01	SCALE 5:1
	PIPE M3M 22X4 GOST 617-72	SHT	SHTS
		342 OF 379	

765-06-0247

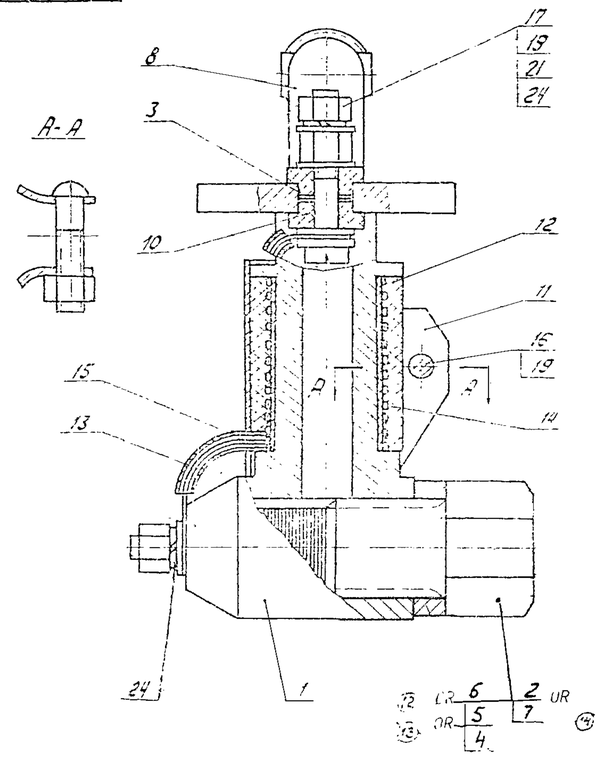


1. Nonflatness of surface Г should not exceed 0,15mm. Straightnening or machining is allowed, in this case, a shoulder with diameter of no more than 20mm and height of no more than 3,5mm is allowed at the part joints.
3. Paint surface Б by silicon heat-resistant varnish КО-815 (former ОГ-9) GOST 11066-74 with addition of 6 to 12% of aluminium powder пАп 1 or пАп-2 GOST 5494-71 as per ОП23-74.

Ref. No.	Designation		QTY	REMARKS
		Aluminium powder		
		nAn-1 or nAn-2		
		Varnish KO-815		
		Electrode ∋10x20H9Г6С		
		GOST 10052-75		
	765-06-1005	Body		1 piece may be replaced with 765-06-477
	765-06-478	Cover	1	
	765-06-477	Body		1 piece may be replaced with 765-06-1005

APPROVED	M VASU	765-06-0247	
CHECKED			
CONTROLLERATE OF INSPECTION (ICV)		INJECTOR BODY	WEIGHT 0,25 / SCALE 1:1
		06	SHT 54 OF 379

765-06-cб248



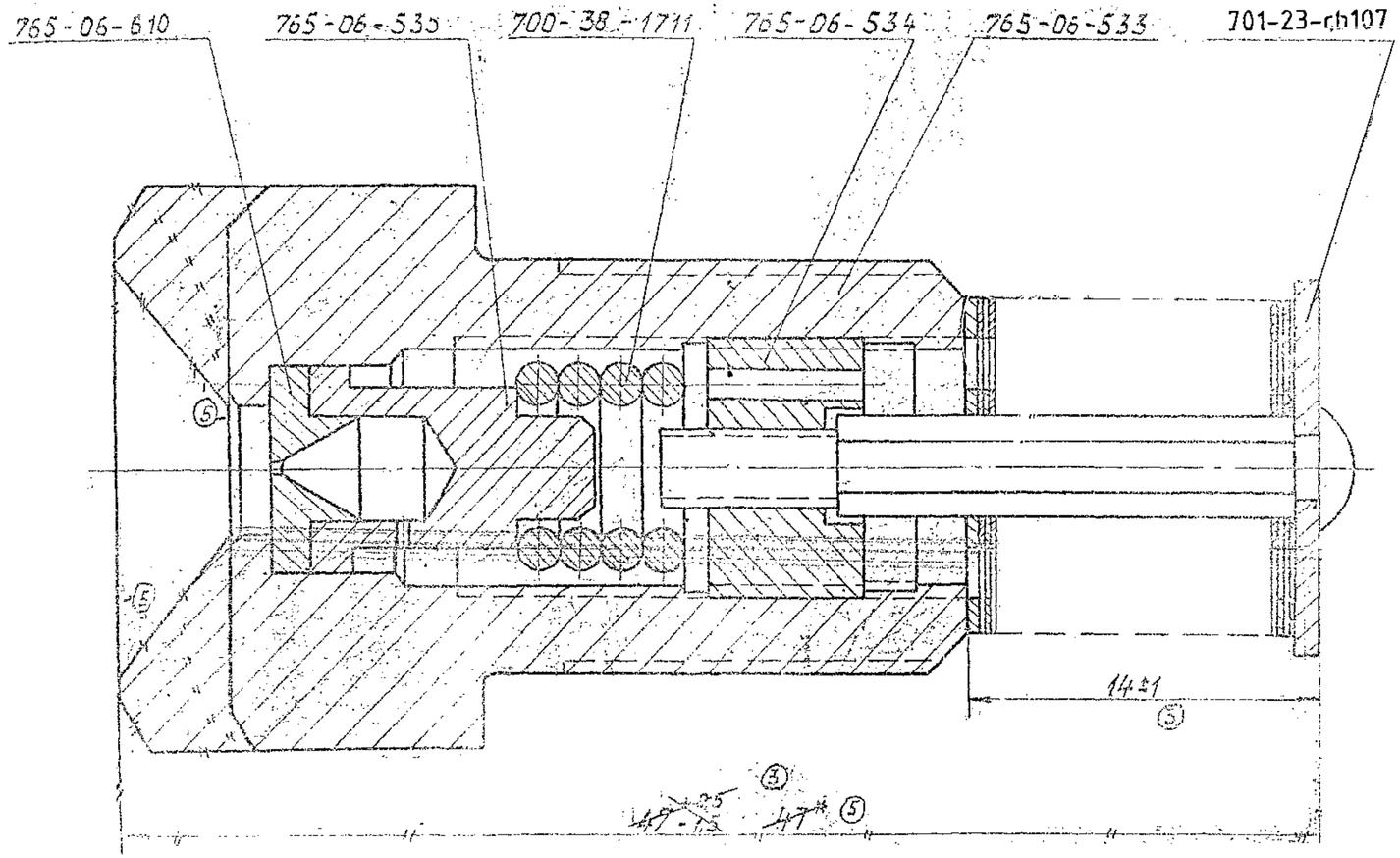
1. Install injector ref.no.2 with stamp/765"
2. Install gasket ref.no.3 on bakelite varnish grade А Бс-1 GOST 901-78. Use as many parts ref.no.3 as it is necessary to ensure a clearance of 0.5 to 1 mm between the bend of part ref.no.10 and the body. In this case, one of the parts ref.no.10 should close fit the body of injector compress the part ref.no.10 by hand.
3. Check the gaskets ref.no.6 or ref.no.5 or ref.no.4 and the elbow for tightness using filtered fuel summer grade А-0.5 or winter grade З-0.5 , GOST 305-73, at a pressure 7 kg/cm^2. Fuel leakage is not allowed. Testing time is 2 minutes, during leakage test filter fuel through a low-brass gauge, 0.05 to 0.07, GOST 6613-73 .
4. To check for insulation breakdown apply an AC voltag of 220В, 50Hz to the body and spiral ref.no.13, which should be disconnected from body. Test time is 1 minute. Insulation breakdown is not allowed. Insulation breakedowns test may be performed with a DC voltage of 500В for 1 minute.
5. Strength of current consumed by spiral at 24v should be 5±0.5 A

					15		Electrical cord-sleeve, grade АСЭ 4 (Б)-3,5 fibre-glass, Ту17РСФСР 44-5873-77 l=850 mm.		Without drawing
17	Screw М4-8h-6gx25.48.016 GOST 17473-72								
	or М4-8h-6gx25.66.016 GOST 1491-72.	1			14	272-26-674	Asbestos cord ШАоН-2 GOST 1779-72		Without drawing
	or М4-8h-6gx18.66.016 GOST 1491-72.								
16	Screw М4-8h-6gx18.48.016 GOST 17473-72	1							
	Bakelite varnish.				13	272-26-673	Wire 0,5-п-х1СН60-Н GOST 12766.1-77 l=860		Without drawing
					12	272-26-672	Gasket.	1	
27					11	272-26-671	Casing	1	
26					10	272-26-669	Bushing	2	
25					9				
24	Washer 4Т 65Г 05 GOST 6402-70	2			8	765-78-65	Elbow.	1	
23					7	765-06-сб474	Injector		1 Piece may be replaced by ref.no.2
22					6	730-26-268	Gasket.	1	May be replaced by ref.no.3 and ref.no.4
21	Washer 4.01.019 or 4.02.019 GOST 11371-78	5			5	765-06-1017	Gasket	1	May be replaced by ref.6 and ref.4
20					4	765-06-1018	Gasket	1	May be replaced by ref.no.5 and ref.no.6
Ⓐ 19	Nut М4-6.016 GOST 5927-70 EQ.MAT.40 C8 TO IS:9550	4			3	765-06-652	Gasket		4 maximum
					2	765-06-сб243	Injector	1	1 Piece may be replaced by ref.no.1
18						765-06-сб248	INJECTOR BODY	1	
					POS.	NOMENCLATURE	DESCRIPTION	QTY	REMARKS

00962-10Y	Ⓐ	EQ. MATERIAL ADDED
10-11-03		
DCUD No.	ISSUE	NATURE OF AMENDMENT
DATE		

APPROVED	R VASU	765-06-сб 248	
CHECKED			WEIGHT 0,4 / SCALE 2:1
CONTROLLERATE OF INSPECTION (CV)		INJECTOR	SHT 06 / SHTS 55 OF 379

765-06-cб 263



1. Rinse parts before assembly in clean gasoline A-72 or A-76 GOST 2084-77 or in industrial gasoline, GOST 8505-80.
2. Test injector for automization using fuel of summer grade Л-0,5 or winter grade З-0,5 GOST 305-73 at a pressure of 4±0,5kg/cm^2.
   Automization should be fine in the slope of a fog cone with an angle of 50° as a minimum at a distance of 80mm from the butt end of injector. Fuel spraying by jets is not allowed. Fuel flow through injector should be 155 to 170 cm^3/min (6,95 to 8,75 kg/h). Check automization quality and cone against a standard injector. Drop formation is allowed on injector body.

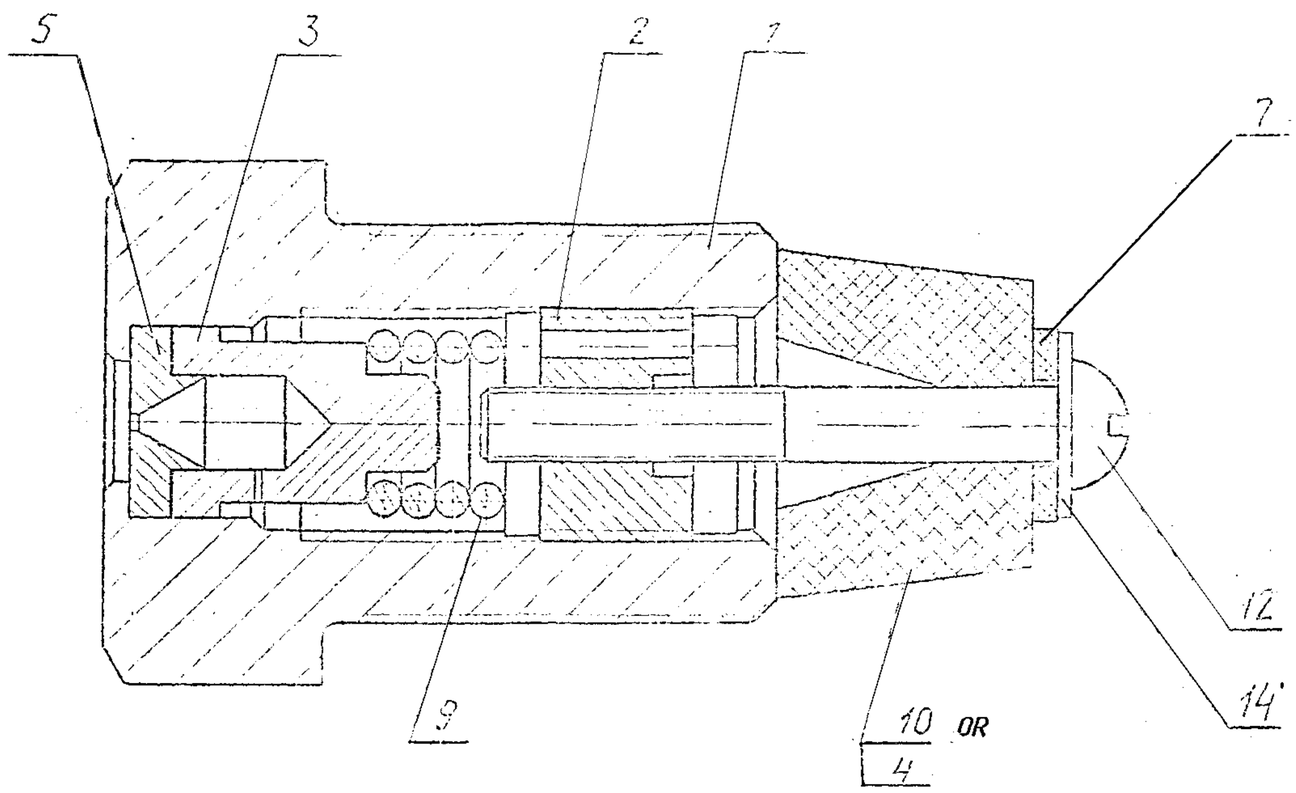
   Local thickening of the fog cone is allowed.
3. Turn screw 765-06-534 in as far as it would go.
4. Wrap accepted injector in parchment.
5. Stamp 765 on the face of hexaedron. Height of figures is 4.

Designation	Description	Qty	Remarks
700-38-1711	Spring	1	
765-06-610	Automizer	1	
765-06-535	Automizer body	1	
765-06-534	Screw	1	
765-06-533	ADAPTOR BUSHING Injector body	1	DCLN 00996-167
701-23-гр107	Filter	1	

APPROVED		765-06-cб 263	
CHECKED			
CONTROLLERATE OF INSPECTION (ICV)		INJECTOR	WEIGHT 0,06 SCALE 5:1
		06	SHTS 60 OF 379

FORMAT	ZONE	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
				Technical papers		
13			765-06-CB 474 C5	Assembly Drawing		
				Assembly units		
11		4	765-06-CB 485	Filter		1 piece may be replaced with part Ref. No. 10.
				Parts		
13		1	DS CAT PART-4730-00996423 765-06-533	Injector Body ADAPTOR BUSHING	1	Ref DCU No: 00996-ICV
12		2	765-06-534	Screw	1	
11		3	765-06-535	Automizer body	1	
11		5	765-06-610	Automizer.	1	
11		7	765-06-652	Gasket	1	
11		9	700-38-1711	Spring	1	
11		10	63-01-001	Filter		1 piece commercial may be replaced with part Ref No. 4.
				Standard Items		
		12		Screw M3.8hx25,48,016		
				GOST 17473-72	1	
		14	EQ. MAT. C-30 TO IS: 1570-79	Washer 3,01,019		(Ref. DCU) 00957-ICV
				GOST 11371-78	1	

APPROVED	M VASU	765-06-CB 474	
CHECKED	V.A Reddy		
CONTROLLERATE OF INSPECTION (ICV)	INJECTOR	WEIGHT	SCALE 5:1
	06	SHT	SHTS 61 OF 379



1) Test the injector for proper spraying by feeding diesel fuel, GOST 4749-73, at a pressure of 4±0,5 Kgf/cm².

When the fuel is sprayed, there should be form a light mist cone at an angle of at least 50° at a distance of 80 mm from the butt-end of injector.

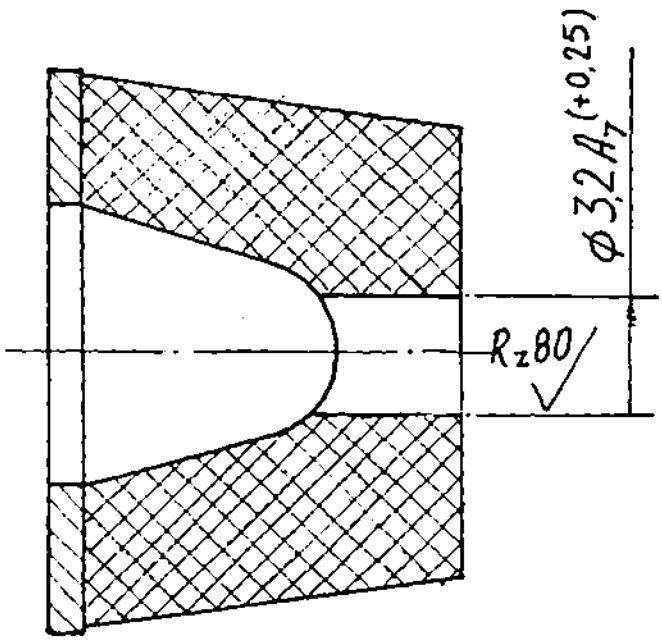
Jet spraying is not allowed.
Local thickening of mist cone is allowed.
Consumptions of fuel through injector should be 135 to 170 cm^3/minute. (6,95 to 8,75kg/per hour).
Check the spraying quality and cone as per standard injector. Drop formation on the body of injector is allowed.

2) Screw up the part Ref. No. 2, as far as it goes.

3) Protect the accepted injector from dust and dirt getting inside during transportation and storage.

APPROVED		765-06-СБ474 СБ	
CHECKED			
CONTROLLERATE OF INSPECTION (ICV)	INJECTOR (ASSEMBLY DRAWING)	WEIGHT 0.055	SCALE 5:1
	06	SHT	SHTS 62 OF 379

98483-90 SOL



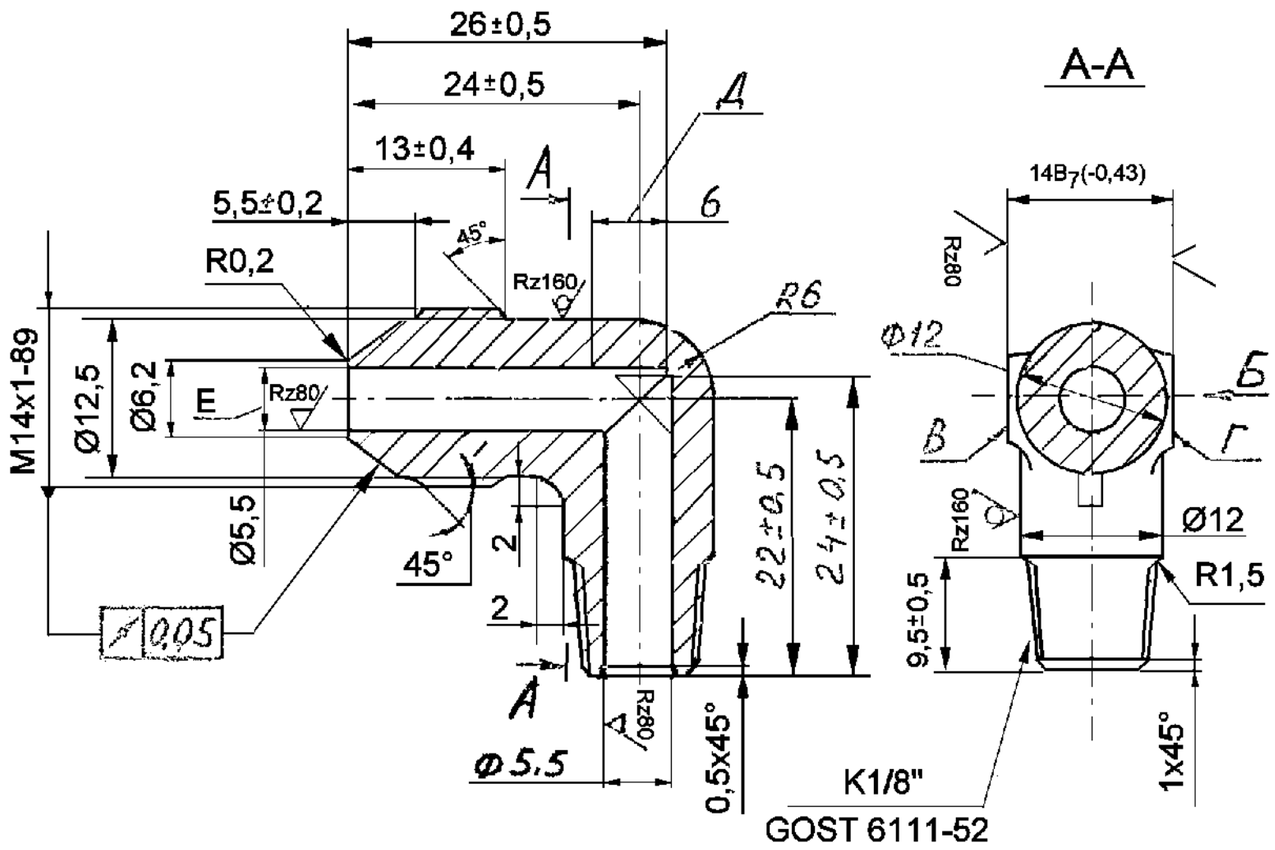
REF. NO.	DESIGNATION	DESCRIPTION	QTY	REMARKS
-	Ap 20-1112145	Filter of unit injector	1	Commercial
		Blank for 765-06-cδ485		

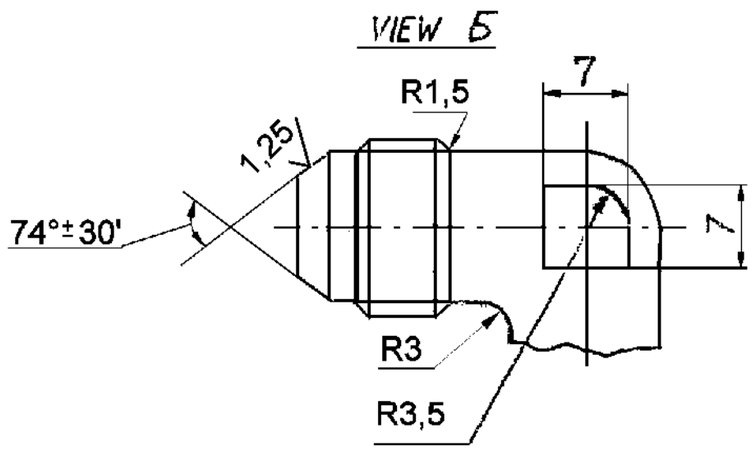
APPROVED	H VASU	765-06-cδ485		
CHECKED	H.M.Shinde			
CONTROLLERATE OF INSPECTION (ICV)		FILTER	WEIGHT	SCALE
			0,003	5:1
			SHT	SHTS
		BLANK AP 20-1112145		368 OF 379

06

765-78-65

R_z40





Ⓑ EQ. MATERIAL:- WROUGHT ALLOYED STEEL BILLET/BAR C45, C52 OR 40 C81 TO IS: 5517-69.

1) *Unspecified limit deviations of dimensions are as fallows:-*

for holes	:	*as per* A_7.
for shafts	:	*as per* B_7.
others	:	*as per* CM_7.
for angular dimensions		$\pm 1^0$

2) *Other requiremets placed upon forging are as per class II GOST 7505-74.*

3) *Coating: Zinc-plated, .9 microns thick, chromatized. Remove Hydrogen embrittlement. Internal surfaces may be free from coating.*

4) *Surface defects to a depth not exceeding 0.7 mm are allowed on unmachined surfaces.*

5) *Dents to a depth not exceeding 0.3 mm are allowed on unmachined surfaces B and Г.*

6) *It is allowed to make the angle as per thickened dash dotted line.*

7) *Dimension E may be decreased by not more than 0.3 mm above tolerence on dimension* Д1

Ⓐ EQ. MATERIAL:- CLASS 4,4SC8 TO IS:2004-78

DC(I)No. & DATE	ISSUE	AMENDMENTS
00837-ICV 4 OCT	Ⓑ	EQ. MATERIAL ADDED.
00651-ICV 29 OCT 98	Ⓐ	CLASS 4,4 SC8 TO IS:2004-78 ADDED AS EQ. MATERIAL

APPROVED	M.VASU
CHECKED	M.M SHARMA

CONTROLLERATE OF QUALITY ASSURANCE (ICV)

765-78-65

ANGLE

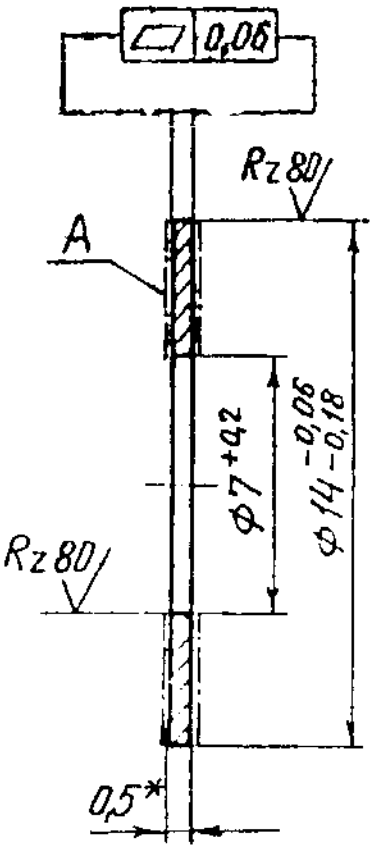
STEEL 45, GOST 1050-74

	WEIGHT	SCALE
	0.033	2:1

SHT 1 SHTS 1

A3

AP20-1112150



1. Dimensions with asterik marks are for references.

2. Coating of sruface A:co per 9 microns thick

3. Material: Steel 10, fqnd, thickness 0.5±0,05
Chemical composition of steel, %:
Carbon-0.07÷0.14
Silicon 0.07÷0.37
Manganese-0.25÷0.65
Chromium-not more than 0.15

MATERIAL		
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED		
SCALE :-	TOLERANCE ON DIMENSIONS UNLE -SS OTHERWISE SPECIFIED	USED ON:-
DATE :- 19-8-97		
DRN [illegible] WT :- (Kg) 0.429	AP20-1112150	
CHD [illegible]	FILTER WASHER	
APD [illegible]		
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)		3 OF 3

REF No.	DESIGNATION	DESCRIPTION	PARENT UNIT	QTY	REMARKS.
		TECHNICAL PAPERS			
	AP20-1112145 CB	4571617118 CB	FILTER ASSY DRG		
		PARTS			
1	AP20-1112150	4571617141	FILTER WASHER	1	
		MATERIALS			
2		POWDER BRONZE			
		REFER AP20-1112145CB			0.0049 KG

APPROVED	
CHECKED	

CONTROLLERATE OF QUALITY ASSURANCE (ICV)

4571617118 / Ap20-1112145

FILTER

SHT 1 SHTS 3

AP20-1112145C6

AP 20-1112145
sheet 3|4

1. Filter should be made by sintering in the forms (by free filling) of tin spherical-shaped powdered bronze, obtained by spraying the mixture of cathode copper melt, tin and copper-phospher alloy, with washer Ref.No 1.

   Powdered bronze diameter 0.28 to 0.40mm, chemical composition of powdered bronze: tin 7.5 to 9.5%, phosphher 0.2 to 0.4%, copper-remaining.

   Chemical composition of components, % (*) Delete the table from Ni enwards and substitute as given in amendment

	Cu	Bi	Sb	As	Fe	Ni	Pb	Sn	S	O	Zn	P
Tin	0.03	0,05	0.05	0.015	0.02	-	0.25	99.0	0.02	-	-	-
Phospher	remaining	0,005	0.10	-	-	-	-	565	-	-	-	6.0-9.5
Copper	99.99	0.0005	0.001	0.001	0.001	0.001	0.00	0.002	-0.001		0.001	

2. Surfaces of filter should be yellow or orange colour, dark orange and other colours are not allowed. Presence of seperate dark (oxide) bubbles is allowed, but not in the form of accumulations.

3. Protruding of seperate bubbles is allowed beyond general contour of filter at the sintering place of filter mass with washer; in this case the bubbles should not protrude beyong lateral surface of washer.

4. Presence of foreign particles, cracks and other defects is not allowed on entire volume of filter mass. (*) Read as "of"

5. Filter, collapsed, should not be broken or crumple under 1500kg load

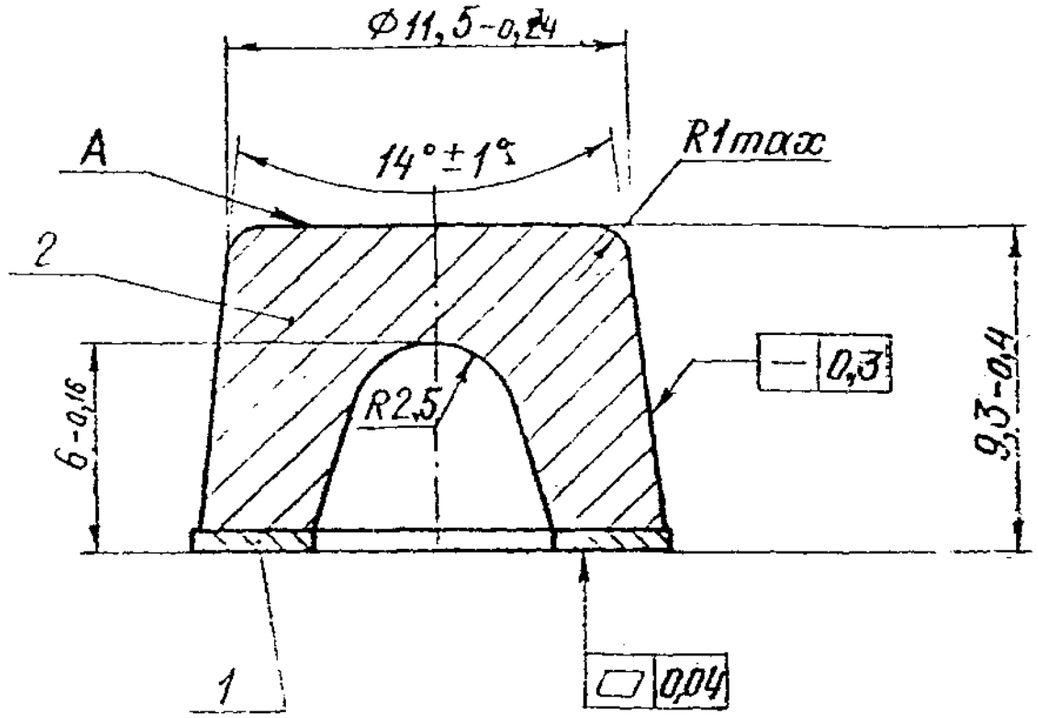
6. When rubbing the filters with each other manually, shots should not be extruded.

7. Sintering strength of washer with filter mass should be atleast 40kgf/cm2; local seperations of washer are not allowed.

8. 370 to 470cm3 of diesel fuel with viscosity 5.1 to 5.7 cst should be passed through filter for 60sec at a testing temperature at a pressure of fuel column with height 1000mm. (*) Read as 5.1

NOTES: For providing the specified viscosity, fuel may be thinned with kerosene or thickened with oil

9. Single shrinkage cavities not more than 0.5mm in depth and not more than 1mm2 area are allowed on surface A.



MATERIAL :-		
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG NOT TO BE SCALED		
SCALE :-	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-
DATE :- 19-8-97		
DRN WT :- (Kg)	AP20-1112145 C6	
TCD	FILTER ASSY. DRG	
CHD		
APD		

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)