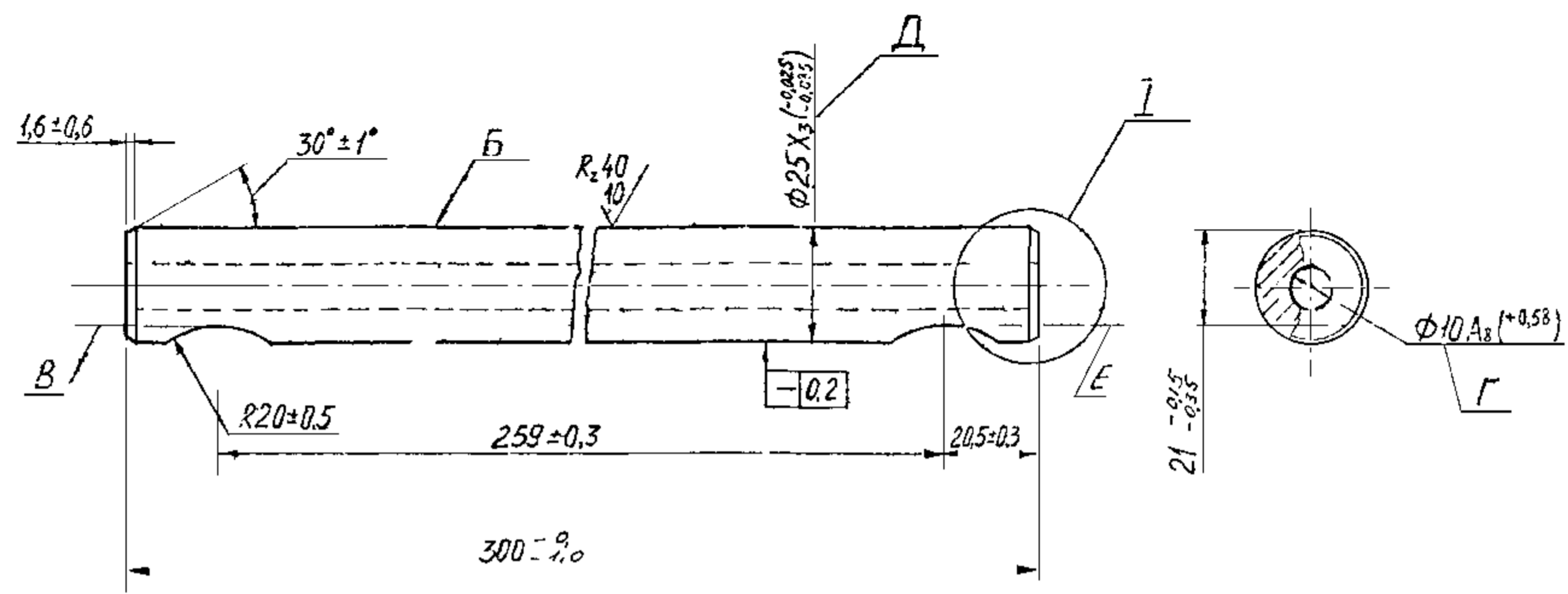


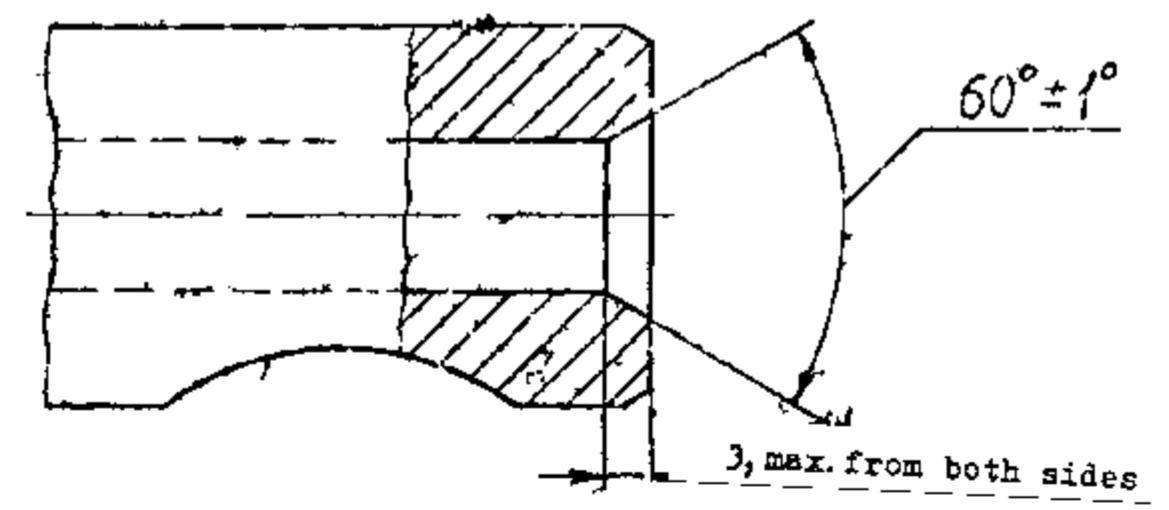
1280 / (✓)

TECHNICAL CONDITIONS

1. HB 387 to 477 ( $\phi$  of indent 3.1 to 2.8). Heat-treat the surface isothermally according to TTM-29-75. To check hardness, flats are permissible on one or both faces to a depth of 0.3 mm maximum, occupying not more than a half of the face.
2. When making the part of a pipe, do not machine the hole. In this case, the diameter should be equal to  $10^{+0.5}_{-1.0}$ , difference of walls at faces - not more than 1 mm. For other requirements see Specifications IV 14-3-642-77.
3. Faces of hole F may have traces of centres.
4. Surface B may have traces of clamping appliance elements, not more than 0.05 mm deep and 50 mm long from the pin face.
5. It is allowed to drill hole F from both sides. In this case, check misalignment and skewness of holes with the aid of a gauge, 8.5 mm dia, with a length equal to the part length. Variation in wall thickness at the faces should not exceed 0.5 mm.
6. Check sizes before heat treatment, except size II.
7. After heat treatment permissible loosening of size II should not exceed 0.03 mm, and permissible increase should not exceed 0.025 mm above the tolerance over the entire length.
8. Mutual angular misalignment of surfaces B and E should not exceed 0.1 mm over the flat width.
9. For other requirements, see Appendix No. 3 of Specifications IV 10542-77.



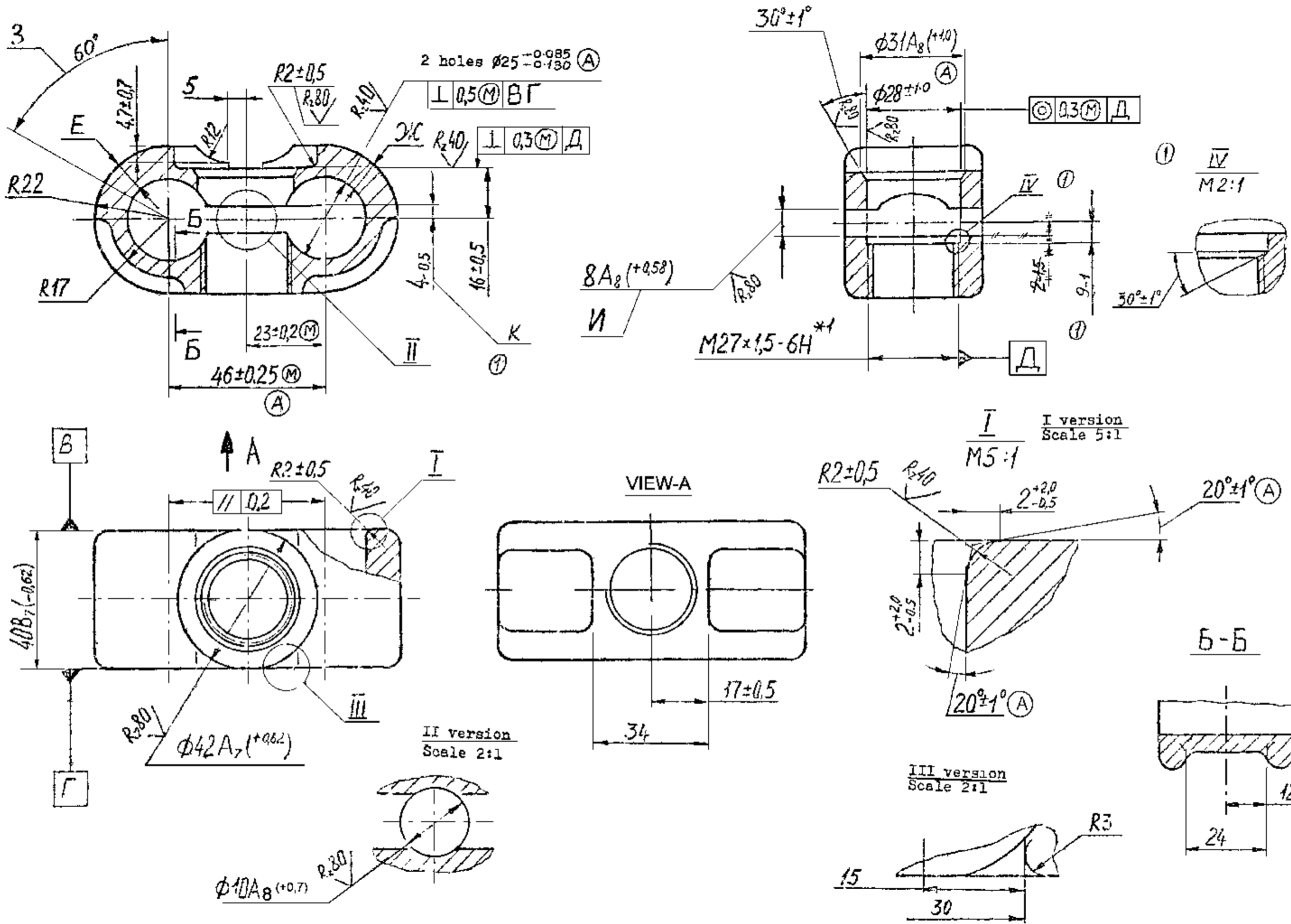
I Version  
Scale 2:1



APPROVED	675-35-13		
CHECKED	PIN	WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		0.945	1:1
	STEEL 38xC, GOST 4543-71	SHT	SHTS

TECHNICAL CONDITIONS

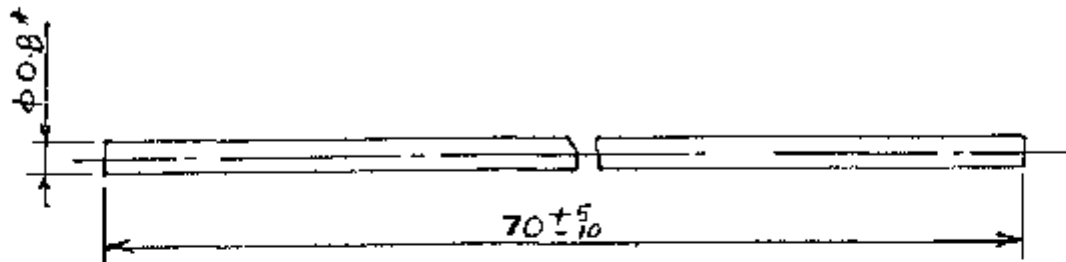
- (1) 1. HB 387 to 477 ( $\phi$  of indent 3.1 to 2.8). Heat-treat the surface isothermally according to TTM 29-75.
2. Unspecified stamping radii should not exceed 4 mm.
3. Unmachined surfaces may have local recesses which should not exceed 1 mm.
4. Requirements for forging conform to class II, GOCT 7505-74.
5. Surfaces B and F may have black spots occupying 40% of the area.
6. Difference of sizes E and K should not exceed 2 mm. Check it on arc 3.
7. Surfaces of slot M may have a shoulder of 0.5 mm, maximum.
8. Check sizes prior to cutting of slot M.
9. Check sizes before heat treatment.
10. When machining surfaces B and F, partial cutting of surfaces of stamping radii is permissible.
11. After heat treatment, subject external surfaces of the part to cold-working by shot-blasting with steel or cast iron shot No. 1 to 2, GOCT 11964-66. Cold-working of other surfaces is permissible. Working shot may have up to 30% (according to its mass) of fragments.
12. Check shot-blast working operation for quality by visual inspection. External surfaces should be completely and evenly covered with shot marks. Unworked sections on external surfaces are not permissible.
13. After repair and long-time intervals in operation of shot-blasting machine, and at least once a quarter check shot-working for quality additionally by maximum deflection of testing plates. Plate deflection should be at least 0.75 mm. Testing plates should have dimensions: 1.3 x .8 x 76 mm, made of steel 65F, GOCT 14959-79; and heat-treated to hardness HRC 44 to 52.
14. Size 4<sub>-1.5</sub> may be substituted for size K.



01013-ICV	(B)	DS CAT NO ADDED AND DESCRIPTION "CLAMP RIM CLINCHING" WAS "CLAMP"
19-01-06		
00021-ICV		1-DIMENSION $\phi 25 \pm 0.085$ FOR 2 HOLES IN ELEVATION WAS $\phi 25A_3(+0.045)^*$ 2-BOTH THE ANGLES $20^\circ \pm 1'$ IN VERSION-I WERE $10^\circ \pm 1'$ 3- IN END VIEW, DIMENSION $\phi 28 \pm 1.0$ WAS $\phi 28A_8(+0.04)$ 4- IN ELEVATION, DIMENSION $46 \pm 0.25$ WAS $46 \pm 0.2$ 5-MINOR CORRECTIONS TO THE TYPOGRAPHICAL ERRORS INCORPORATED IN THE TECH. CONDITIONS.
13-1-89	(A)	
DC(I) No & DATE	ISSUE	NATURE
AMENDMENT		

APPROVED	675-35-14	DS CAT PART No (B)	
CHECKED		LV2/ICVs 5340-017085	
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	(B) CLAMP	WEIGHT	SCALE
		0.5	1:1
		SHT	SHTS
STEEL 38 XC, GOST 4543-71			





### TECHNICAL CONDITIONS

1. ALTERNATE MATERIAL IS WIRE I-0.8 GOST 9389-75.
2. CRUMPLING OF BUTT-ENDS IS ALLOWED.
3. \* DIMENSION IS GIVEN FOR REFERENCE.

#### NOTE -

- 1 ALL DIMENSIONS IN mm
- 2 THE ABBRIVIATION AND SYMBOLS ARE BASED ON RUSSIAN SPECIFICATIONS

WIRE II-0-8, GOST 9389-75

00229-  
ICV

5 MAR 91

DCUR & DATE ISSUE

NEW DRG. PREPARED  
BASED ON NEW DRG  
INTRODUCED BY THE COLLABO-  
RATORS (D-935/ICV)

AMENDMENTS

ALL SHARP EDGES & COR-  
NERS TO BE ROUNDED OFF

ALL THREADS TO CONFORM  
TO SPECIFICATION.

STAMP OR ETCH, PART  
NO. MANUFACTURER'S  
NAME & YEAR OF MFR.

DRG. NOT TO BE SCALED

SCALE:- 5:1

TOLERANCE ON DIMENSIO-  
NS UNLESS OTHERWISE  
SPECIFIED

USED ON:-

DATE :- 05-03-91

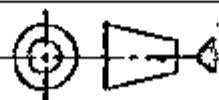
675-35-Sb125

DRN KHARILAL WT :- (Kg)

## CONTACT NEEDLE

TCD KHARILAL 0.0003

CHD




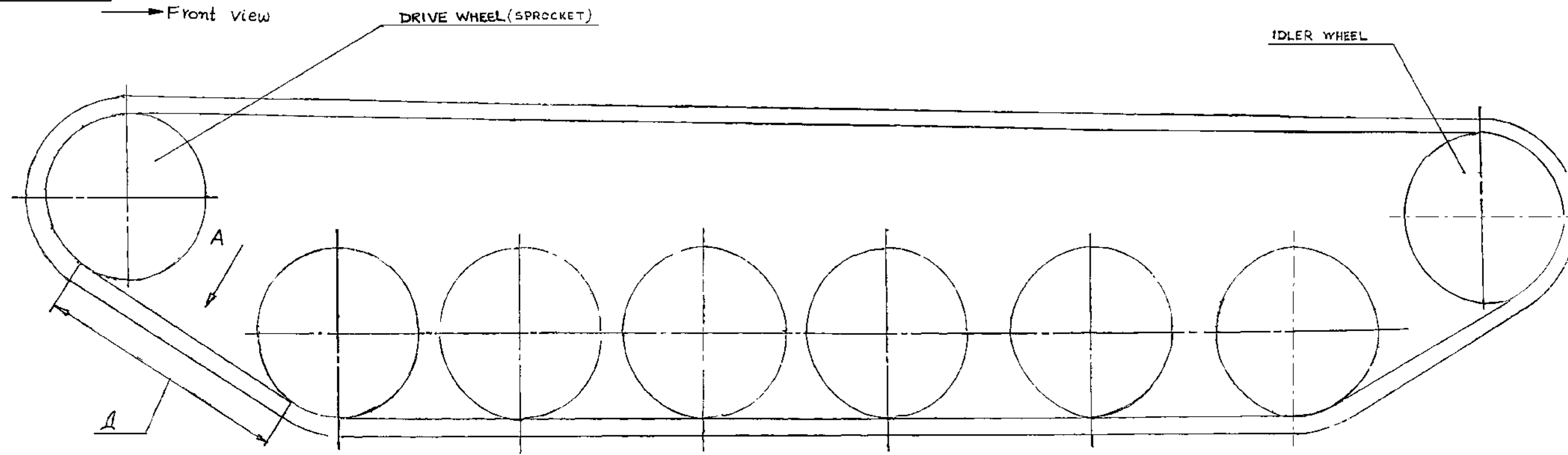
## 675-35-18

APD

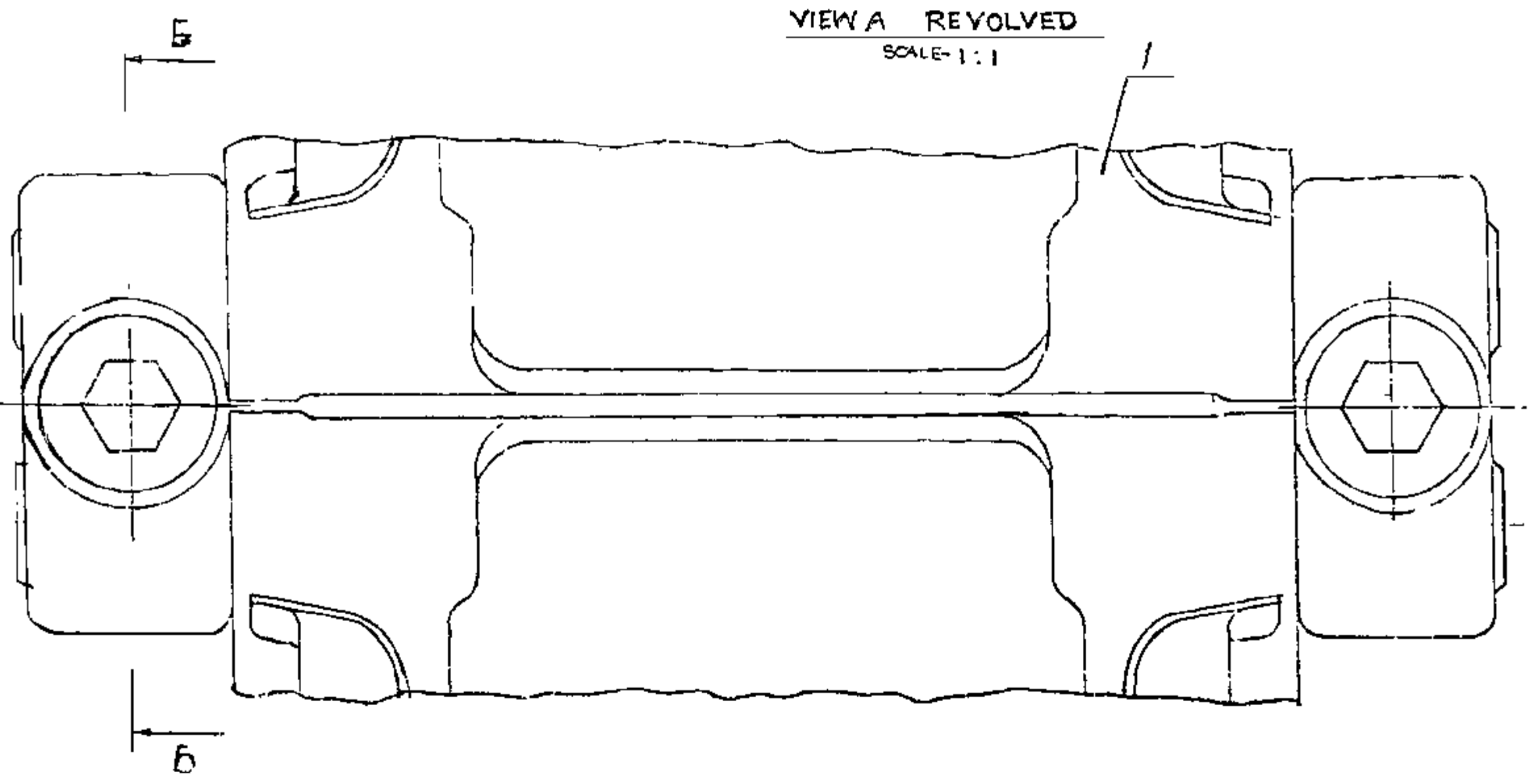
**CONTROLLERATE OF QUALITY ASSURANCE  
(INFANTRY COMBAT VEHICLES)**

NO.	DESIGNATION	DESCRIPTION	QTY	REMARKS
		TECHNICAL DOCUMENTS		
	675-35-C6 9 C6	ASSEMBLY DRAWING		
		ASSEMBLY UNITS		
1	675-35-C6 123	TRACK	2	

		00229/ /ICV  5 MAR 91		NEW DRG. PREPARED BASED ON NEW DRG. INTRODUCED BY THE COLLABORATORS. IN PLACE OF 675-35-C6 7. (D-335/ICV)		
DC(D) NO. DATE	ISSUE	NATURE OF AMENDMENTS	DC(D) NO. DATE	ISSUE	NATURE OF AMENDMENTS	
DRN.	K.HARILAL	<b>675-35-Sb9</b>  <b>TRACK</b>			WEIGHT	SCALE
TCD.	K.HARILAL					
CHD.	<i>MAJ</i>				SHEET:	SHEETS:
APD.	<i>sd/</i>				OF	
<b>CONTROLLERATE OF QUALITY ASSURANCE</b> <b>(INFANTRY COMBAT VEHICLES)</b>						



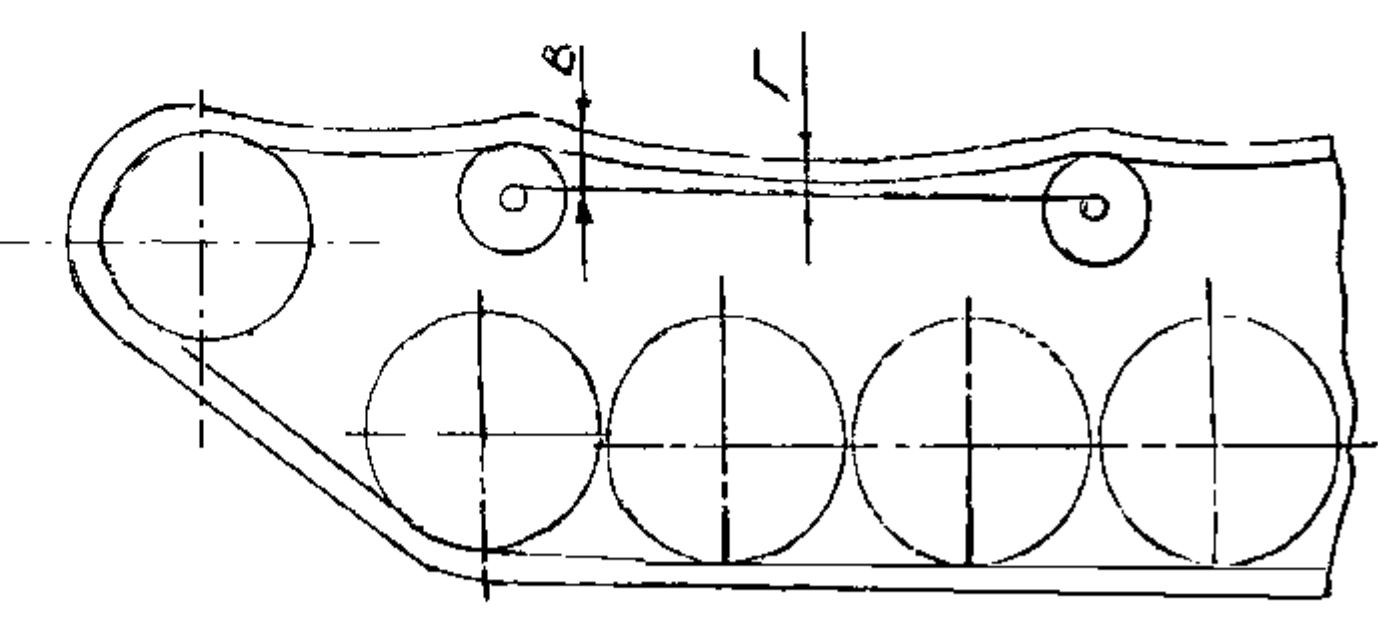
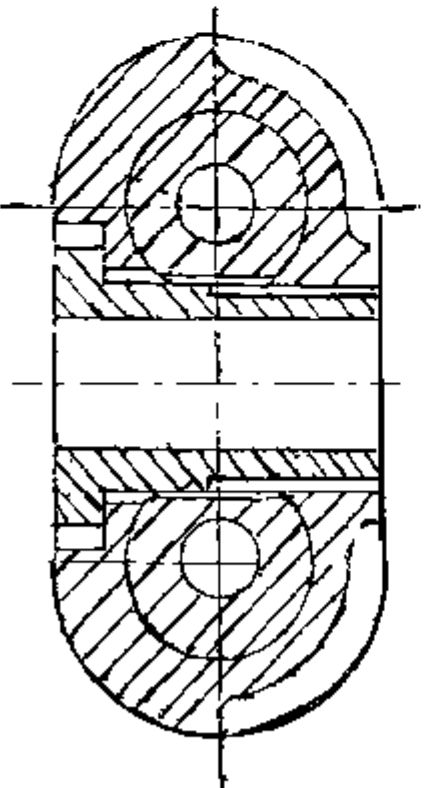
1. SET THE IDLER WHEEL IN FRONT END POSITION
2. CONNECT TRACK ON SECTION A SO THAT EACH TRACK IS ROTATED WITH RESPECT TO CLAMPS TO  $7^{\circ} \pm 1^{\circ}$  AND ANGLE BETWEEN TRACKS IS  $166^{\circ}$ , BY SETTING CLAMPS ON PIN OF CONNECTING TRACKS UP TO STOP IN TRACK BY SETTING BOLTS IN CLAMPS AND TIGHTEN THEM.
3. BEFORE MOUNTING, LUBRICATE THE THREAD AND BASE SURFACE OF HEADREST BOLTS WITH LUBRICANT MC-70GOST 9762-76 OR LITHOL-24 GOST 21150-75 OR LUBRICANT ZIMOL TY 38YCCP 20 1285-82.
4. TIGHTENING OF BOLTS IS CARRIED OUT WITH MOMENTUM  $(392 \pm 78) \text{ N.M}$  ( $40 \pm 8 \text{ Kg.f.m}$ )
5. CARRYOUT TIGHTENING OF TRACKS WITH THE HELP OF TIGHTENING MECHANISM.
6. VALUE OF TENSION IS CHECKED IN THE FOLLOWING ORDER MOUNT THE VEHICLE ON UNIFORM SECTION, TIGHTEN THREAD ON FILLING PLUGS OF FIRST AND SECOND SUPPORTING ROLLERS. IN THIS CASE SAG OF THREAD IS NOT ALLOWED. MEASURE THE DISTANCE B FROM TIGHTENED THREAD TO TRACKS BED LYING ON THE FIRST SUPPORTING ROLLER AND DISTANCE 'r' FROM THREAD TO TRACK BED LYING IN BETWEEN THE FIRST AND SECOND SUPPORTING ROLLERS DIFFERENCE OF MEASUREMENT SHOULD BE EQUAL TO 6 TO 8 MM.
7. IN THE ABSENCE OF IMPELLERS IN COMPLIANCE WITH KA ON VEHICLE, VALUE OF TENSION IS CHECKED IN THE FOLLOWING ORDER SET 2 PINS IN HOLES OF TRACK PINS LYING ON FIRST AND SECOND SUPPORTING ROLLERS PEACES THIRD PIN IN TRACK HOLES LOCATED BETWEEN FIRST AND SECOND SUPPORTING ROLLERS TIGHTEN THREAD ON END PINS IN THIS CASE SAG OF THREAD IS NOT ALLOWED MEASURE THE DISTANCE BETWEEN CENTER PIN AND THREAD VALUE OF SAG SHOULD BE EQUAL TO 6 TO 8 MM.
8. ADJUSTING OF TENSION OF TRACKS IS CARRIED-OUT ONLY DURING THE POSITION OF AXIS OF IDLER WHEEL ON UPPER PART OF ARC OF CIRCUMFERENCE, DESCRIBED BY CRANKSHAFT.
9. T SHAPED GROUERS IN THE LOWER BRANCH OF TRACKS SHOULD BE DIRECTED TOWARDS THE VEHICLE FRONT.
10. CRAWLER TRACK WITH 84 TRACKS MAY BE MOUNTED WHEN REQUIRED (ASPER THE COINCIDENCE OF TOLERANCE)



VIEW A REVOLVED  
SCALE: 1:1

B-B  
SCALE: 1:1

DIAGRAM OF CHECKING TENSION OF TRACKS





$B-f = 6 \dots 8 \text{ mm}$

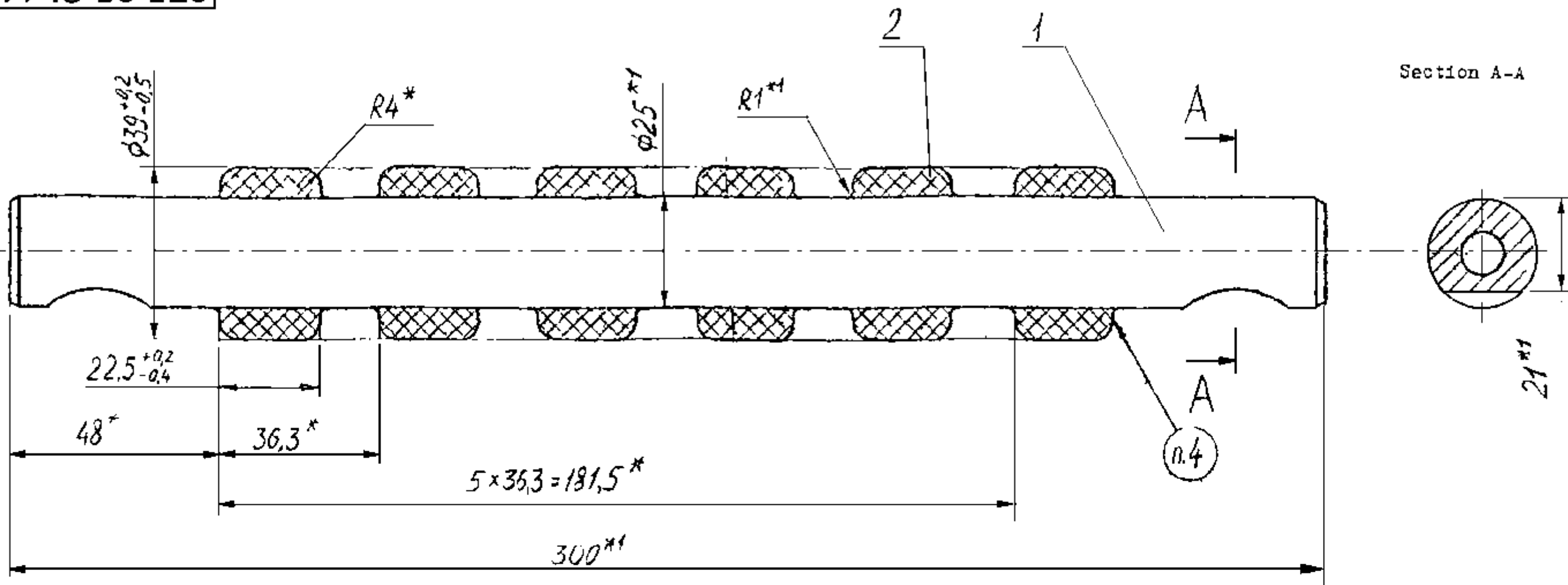
1. ALL DIMENSIONS IN mm  
2. THE ABBREVIATION AND SYMBOLS ARE BASED ON RUSSIAN SPECIFICATIONS.

00370-1CV		(A)	WEIGHT WAS 1323.68.
00220-1CV		Smirni	NEW DRG PREPARED BASED ON NEW DRG INTRODUCED BY COLLABORATORS IN PLACE OF 675-35-Sb9Sb D-935/1CV
NEAREST EQ. MATERIAL		DCI(No. & DATE)	ISSUE
ORGL MATERIAL:-		AMENDMENTS	
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	DRG. NOT TO BE SCALED	ALL THREADS TO CONFORM TO SPECIFICATION	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED
SCALE: 1:10	DATE: 05-03-91	STAMP OR ETCH, PART No. MANUFACTURER'S NAME & YEAR OF MFR. USED ON:	
DRN.	WT:-(Kg) 1385.5 (A)	<b>675-35-Sb9Sb</b>	
TCD.			
CHD		TRACKS DS CAT No.	
APPD		<b>CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)</b>	

No.	Designation	Description	Qty	Remark
1	675-35-13	<u>List of Documents</u> Assembly drawing  <u>Parts</u> Pin  <u>Materials</u> Rubber MPN-1393-B	1	0.145 kg

APPROVED 	<b>675-35-Sb119</b>		
CHECKED 			
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>			
	SHT	SHTS	

675-35-Sb119Sb



TECHNICAL CONDITIONS

1. <sup>n</sup>Sizes are ensured by tooling
2. <sup>n1</sup>Dimensions for reference.
3. Corrosion in the pin hole is permissible.
4. Mark according to Specifications TV 10542-77.
5. For other requirements, see Specifications TV 10542-77.

APPROVED	<b>675-35-Sb119Sb</b>		
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	RUBBER BUSHED PIN	WEIGHT	SCALE
		1.09	1:1
		SHT	SHTS

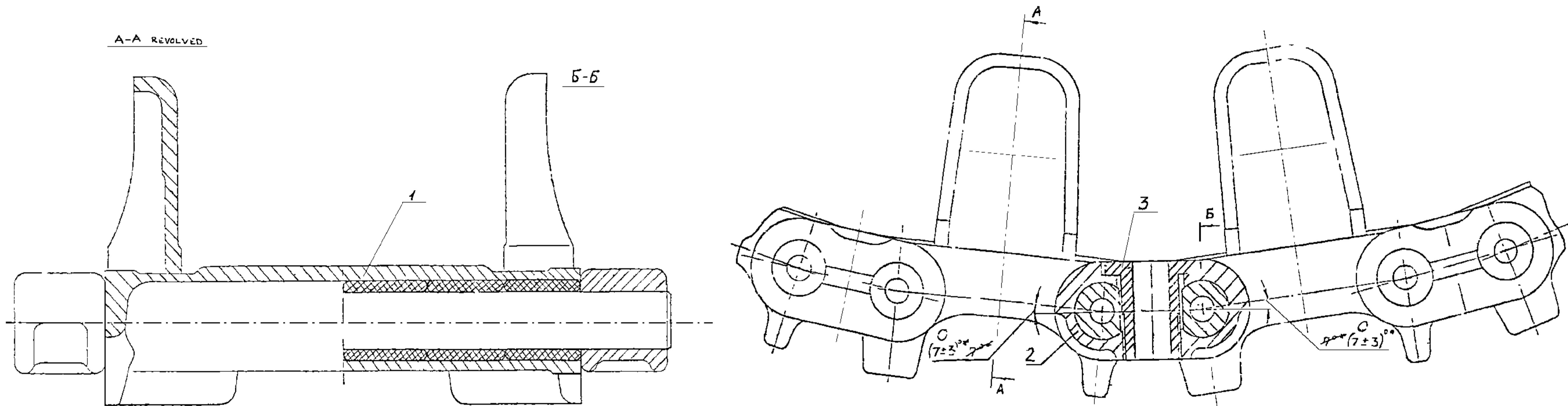
NO.	DESIGNATION	DESCRIPTION	QTY	REMARKS
		TECHNICAL DOCUMENTS		
	675-35-CB 12 3 CB	ASSEMBLY DRAWING		
		ASSEMBLY UNITS		
1	675-35-CB 124	TRACK WITH RUBBER METAL PINS	85	
		PARTS		
2.	<del>EV2/ICVS 5346-017085</del> 675-35-14	<del>CLAMP</del> CLAMP RIM CLUNCHING	170	Ref Doc No 01013-1CV
3	<del>EV2/ICVS 5306-013148</del> 675-35-15	<del>BOLT</del> BOLT INTERNALLY RECEIVED BODY	170	Ref Doc No 01013-1CV

			no 229/ 1CV		NEW DRG PREPARED BASED ON NEW DRG. INTRODUCED BY THE COLLABORATORS. IN PLACE OF 675-35-CB117 (p-935/1CV)
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DC(D) NO. DATE	ISSUE	NATURE OF AMENDMENTS	DC(D) NO. DATE	ISSUE	NATURE OF AMENDMENTS

DRN.	K.HARILAL	<b>675-35-Sb123</b>  <b>TRACK</b>	WEIGHT	SCALE
TCD.	K.HARILAL			
CHD.	<i>MD</i>		SHEET: 1	SHEETS: 1
APD.	<i>SD</i>			

**CONTROLLERATE OF QUALITY ASSURANCE  
(INFANTRY COMBAT VEHICLES)**



TECHNICAL CONDITIONS

- 1) MOUNT CLAMP AND TIGHTEN BOLTS IN POSITION, WHEN THE ANGLE BETWEEN TRACKS IS  $(166 \pm 2)$ . TIGHTENING IS CARRIED OUT WITH MOMENTUM  $(392 \pm 70)$  Nm  $(40 \pm 8)$  KGF-M.
- 2) PRESS CLAMPS UP TO STOP IN TRACK, CLEARANCE BETWEEN CLAMP AND TRACK WITHOUT ELIMINATION OF PRESS FIT SHOULD NOT EXCEED 2mm.
- 3) BEFORE MOUNTING, LUBRICATE BOLTS ALONG THREAD AND BASE SURFACE OF HEADRECT WITH LUBRICANT MC-70 GOST 9762-76 OR LITHOL-24 GOST 21150-75 OR LUBRICANT ZIMOL TY 38 YCCP 201285-82.
- 4) IT IS PROHIBITED TO BEND TRACK IN EACH HINGE TO AN ANGLE MORE THAN  $15^\circ$  IN ANYSIDE FROM NOMINAL POSITION.
- 5) \*ENSURE DIMENSIONS WITH TOOL.
- 6) DURING ASSEMBLY OF CATERPILLAR TRACKS, ARRANGE T-SHAPED GROUSERS OF THE TRACK SHOES IN ONE DIRECTION.
- 7) WHEN MOUNTING, BOLT REF NO. 3 SHOULD MOVE FREELY BETWEEN FLATS OF PINS.

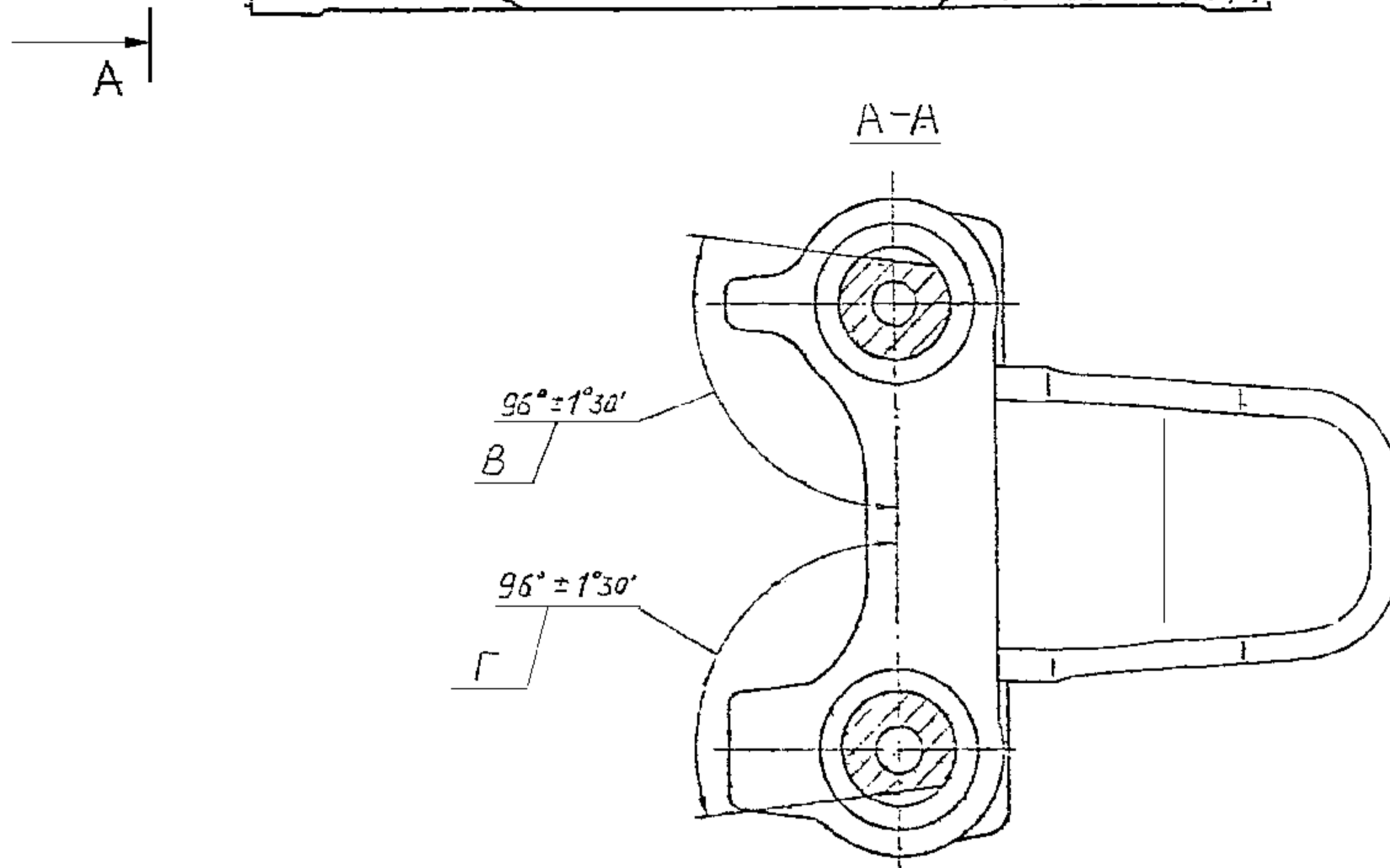
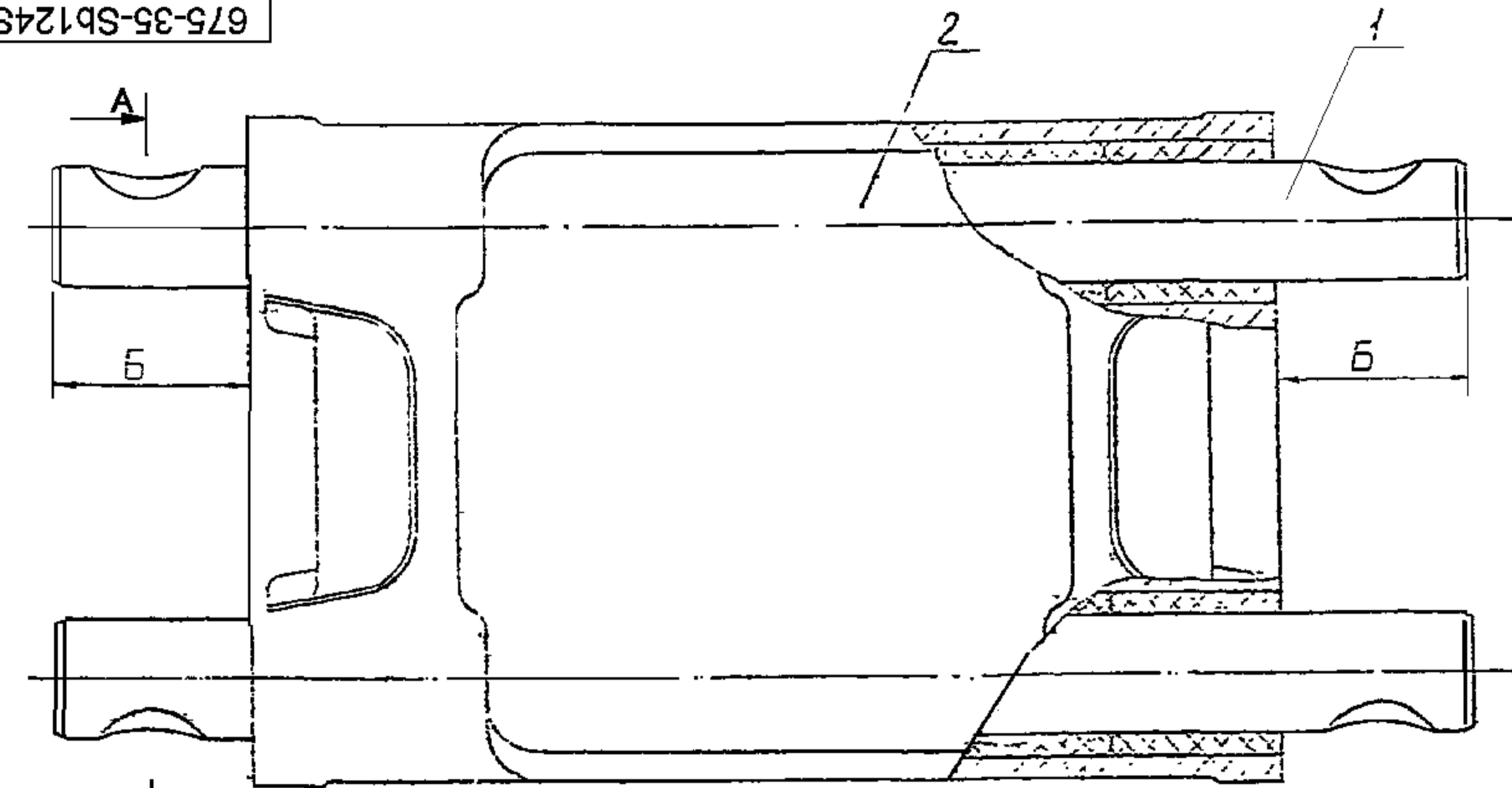
1 ALL DIMENSIONS IN mm  
 2 THE ABBREVIATION AND SYMBOL ARE BASED ON RUSSIAN SPECIFICATION

00370 -ICV 05-03-91	(A) ICV CPH	WEIGHT WAS 661-84
NEAREST EQ. MATERIAL		NEW DRG PREPARED BASED ON NEW DRG. INTRODUCED BY THE MANUFACTURERS IN PLACE OF 675-35-Sb123Sb AMENDMENTS
ORGL MATERIAL:-	ISSUE	
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART No. MANUFACTURER'S NAME & YEAR OF MFR. USED ON:
DRG. NOT TO BE SCALED	SCALE: 1:1	675-35-Sb9
DATE: 05-03-91	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	
DRN.	WT. :- (Kg)	675-35-Sb123Sb
TCD	692.75	
CHD		TRACK (ASSY. DRG.)
APPD		DS CAT No.
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)		

NO.	DESIGNATION	DESCRIPTION	QTY	REMARKS
		<u>TECHNICAL DOCUMENTS</u>		
	675-35-CB 124 CB	ASSEMBLY DRAWING <u>ASSEMBLY UNITS</u>		
1.	675-35-CB 125	RUBBER METAL PIN	2	
2.	765-35-CB 10+	TRACK WITH GUIDES	1	

01086- 1CV A	(A)	DS CAT NO: LV2/ICVS 2530-018048 ADDED AND NOMENCLATURE "TRACK WITH RUBBER METAL PINS" AMENDED AS "TRACK SHOE ASSY"	00229/ 1CV 5 MAR 91	NEW DRG. PREPARED BASED ON NEW DRG., INTRODUCED BY THE COLLABORATORS. IN PLACE OF 675-35-CB 118 (D-935/1CV)	
DC(1) NO. DATE	ISSUE	NATURE OF AMENDMENTS	DC(1) NO. DATE	ISSUE	NATURE OF AMENDMENTS
DRN	K.HARILAL	(A) DS CAT NO: LV2/ICVS 2530-018048			WEIGHT SCALE
TCO.	K.HARILAL	<b>675-35-Sb124</b>			
CHD.	sd/	(A) TRACK SHOE ASSY.			SHEET:   SHEETS.
APD.	sd/	<b>TRACK WITH RUBBER METAL PINS</b>			OF

**CONTROLLERATE OF QUALITY ASSURANCE  
(INFANTRY COMBAT VEHICLES)**



**TECHNICAL CONDITIONS**

1. SURFACES OF TRACK SHOE HOLES FOR PRESS FITTING OF PINS SHOULD BE CLEAN, CORROSION AND SCALES ARE NOT ALLOWED.
2. PRESS-FITTING OF PINS IS CARRIED OUT BY DIRECTOR CONE, IN THIS CASE FIRST TWO RINGS (AS PER PRESS-FITTING), HOLES OF TRACK SHOE FROM SIDE OF PRESS-FITTING TO LENGTH OF ATLEAST 30 MM AND SURFACE OF DIRECTOR CONE IS LUBRICATED WITH THIN LAYER OF LUBRICANT COMPOSITION OF LUBRICANT AS PER VOLUME 30% OF CASTER OIL GOST 6990-75 AND 70% OF TECHNICAL RECTIFIED ETHYL ALCOHOL GOST 18300-87 ETHYL ALCOHOL GOST 5962-67 OR GOST 17249-78 AND CASTOR OIL GOST 6757-73 OR GOST 18102-72 MAY BE USED.
3. DURING PRESS-FITTING MOVE PINS OF NOMINAL POSITION AND BY REVERSE PRESSING. ENSURE THE REQUIRED NOMINAL POSITION OF PINS
4. DURING PRESS-FITTING OF PINS CHECK ANGLES B AND Γ FROM ONE SIDE OF TRACK SHOE.
5. RUBBER PROJECTION NOT EXCEEDING 1.5 MM BEYOND THE ENDS OF TRACK SHOE ARE ALLOWED.
6. DIFFERENCE OF DIMENSIONS B SHOULD NOT EXCEED 2 MM. CHECK WITHOUT TAKING IN TO CONSIDERATION RUBBER FROM THE END OF TRACK.
7. TRACKS WITH PRESSED PINS ARE ASSEMBLED IN TRACK BELTS WITHIN 24 HOURS AFTER PRESSING.

1 ALL DIMENSIONS IN m.m.  
 2 THE ABBREVIATIONS AND SYMBOLS ARE BASED ON RUSSIAN SPECIFICATION.



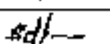
01086-10/01/2011  
 DC(1) No. 50229-1CV  
 DC(1) No. 50229-1CV  
 DC(1) No. 50229-1CV  
 DC(1) No. 50229-1CV

DS CAT No. LV2/ICVS 2530-018048  
 ADDED AND NOMENCLATURE "TRACK WITH RUBBER METAL PINS" AMENDED AS "TRACK SHOE ASSY"

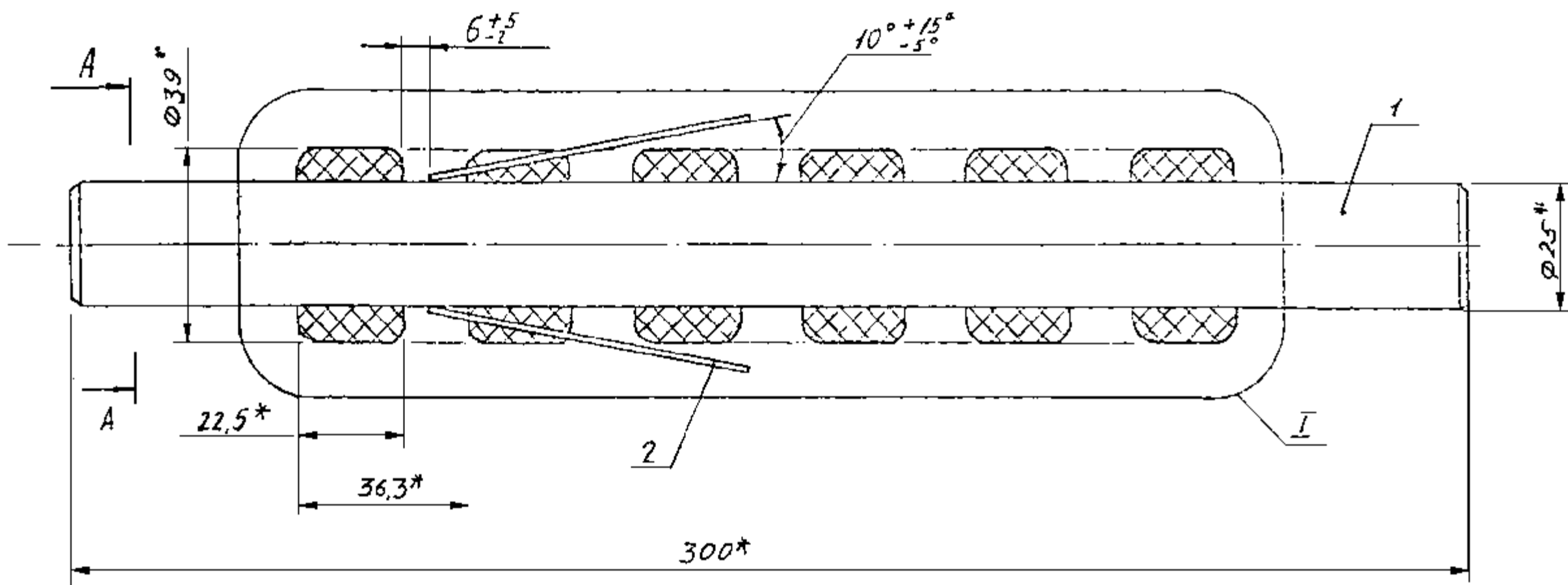
NEW DRG. PREPARED BASED ON NEW DRG. INTRODUCED BY THE COLLABORATORS IN PLACE OF 67535-Sb124Sb-935/1CV

NEAREST EQ. MATERIAL		AMENDMENTS	
ORGL MATERIAL:-		AMENDMENTS	
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF		STAMP OR ETCH, PART No. MANUFACTURER'S NAME & YEAR OF MFR.	
DRG. NOT TO BE SCALED		USED ON: 675-35-Sb123	
SCALE: 1:1		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	
DATE: 05-03-91		ISSUE	
DRN.	WT: (Kg)	TRACK WITH RUBBER METAL PINS	
TCD.	6.92	DS CAT No. LV2/ICVS 2530-018048	
CHD.		675-35-Sb124Sb	
APPD.		CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)	

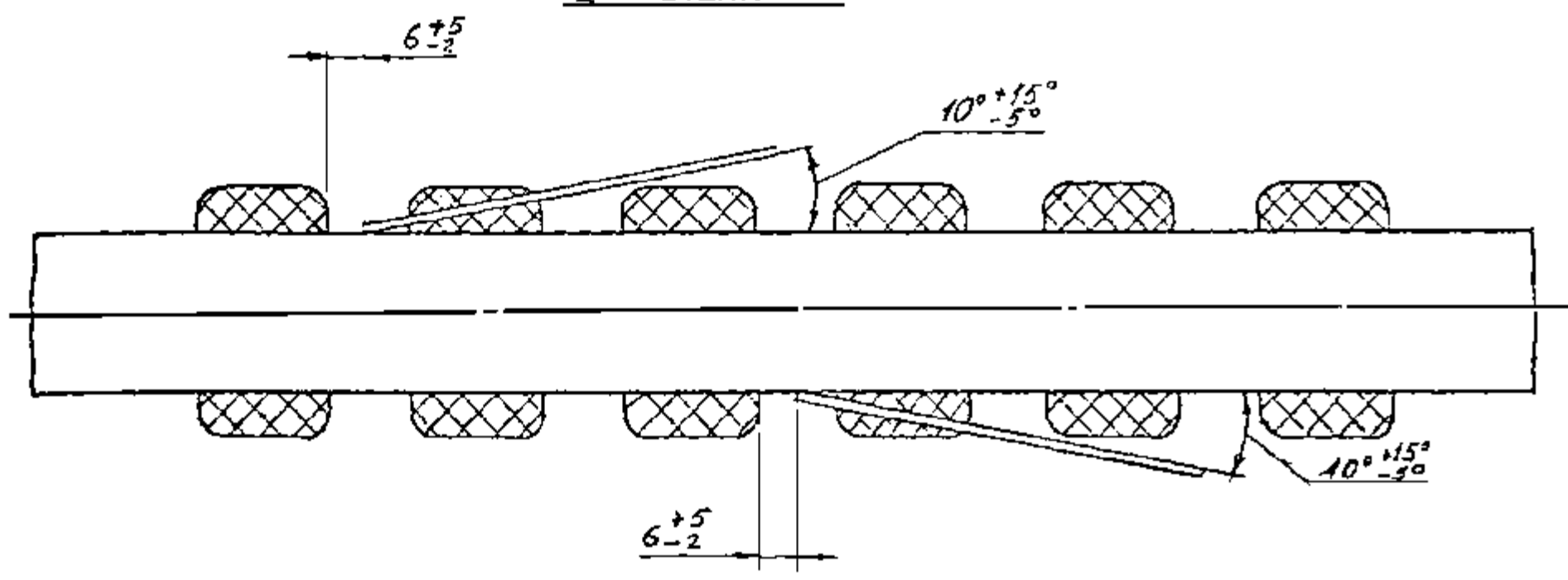
NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
		TECHNICAL DOCUMENTS		
	675-35-CE 125 CE	ASSEMBLY DRAWING		
		ASSEMBLY UNITS		
1	675-35-CE 119	RUBBER METAL PIN	1	
		PARTS		
2	675-35-18	CONTACT NEEDLE	2	

				DC(D) NO DATE 00229/ 1CV  5 MAR 91		NEW DRG PREPARED BASED ON NEW DRG INTRODUCED BY THE COLLABORATORS (D-935-1VC)	
DC(D) NO DATE	ISSUE	NATURE OF AMENDMENTS	DC(D) NO DATE	ISSUE	NATURE OF AMENDMENTS		
DRN.	K HARILAL	<b>675-35-Sb125</b>  <b>PIN</b>				WEIGHT	SCALE
TCD	K HARILAL					SHEET	SHEETS
CHD.						OF	
APD.							

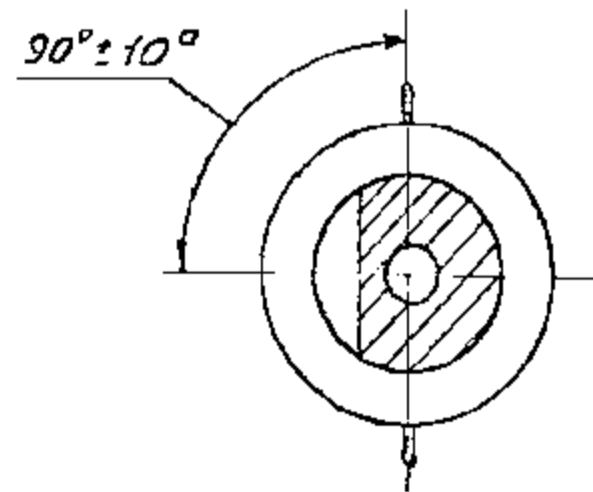
**CONTROLLERATE OF QUALITY ASSURANCE  
(INFANTRY COMBAT VEHICLES)**



I ALTERNATE



A-A

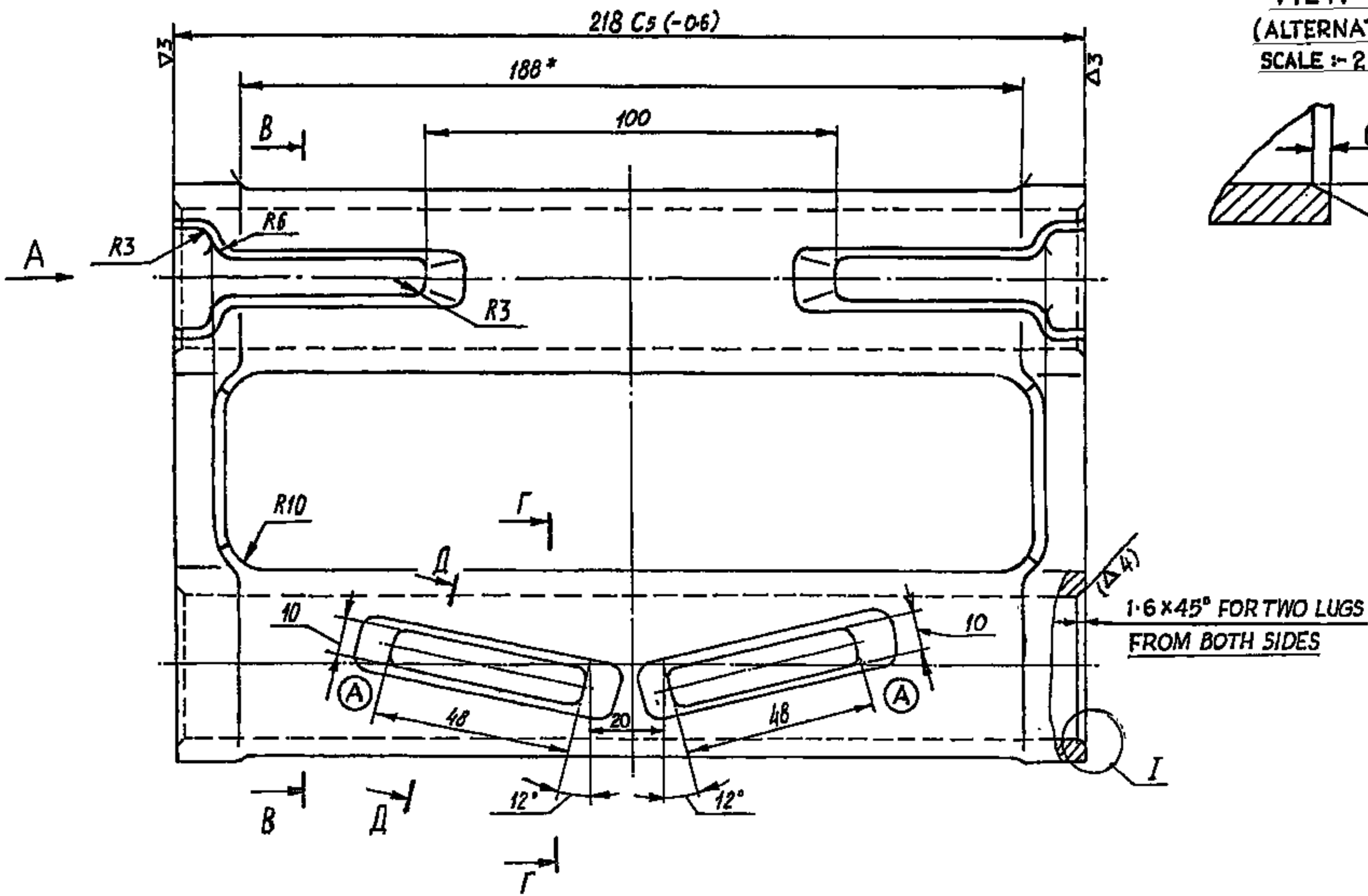


NOTE:-  
 1. ALL DIMENSIONS IN mm  
 2. THE ABBREVIATION AND SYMBOLS ARE BASED ON RUSSIAN SPECIFICATIONS.

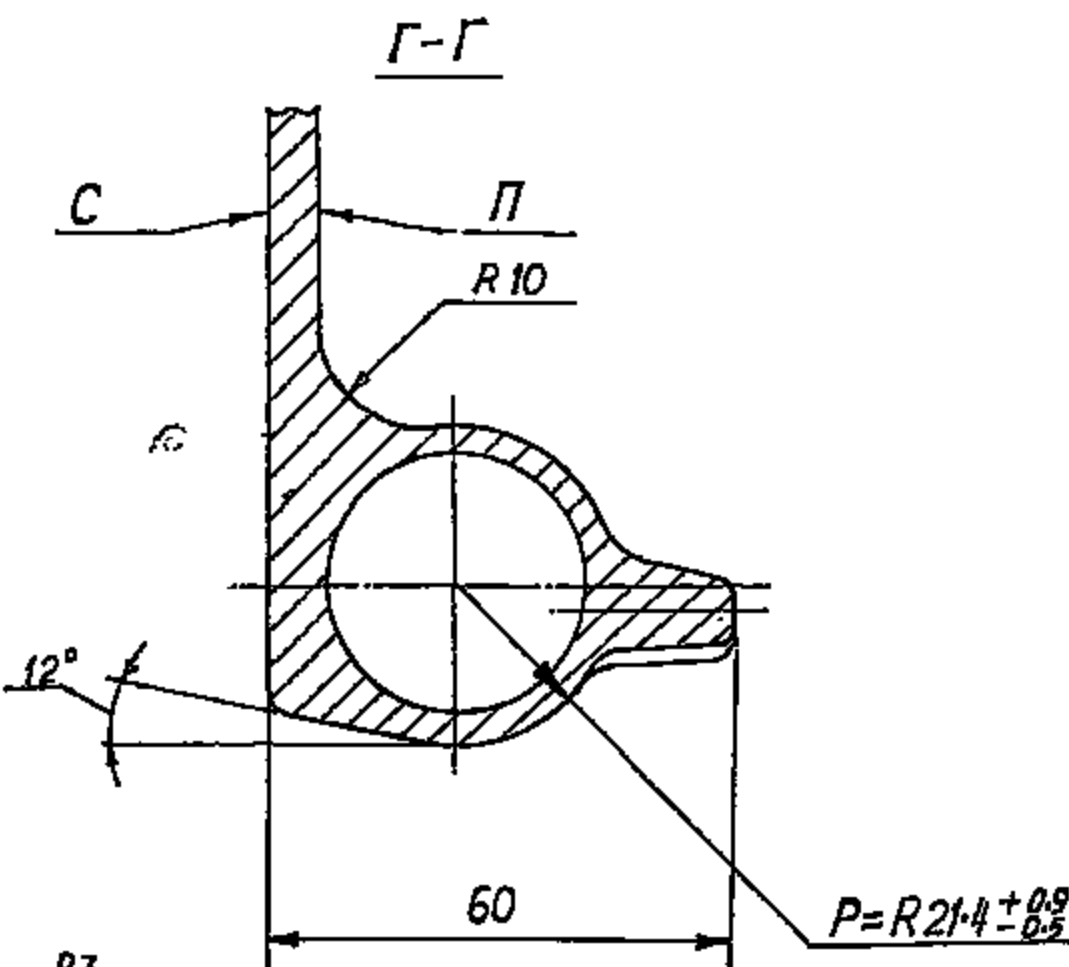
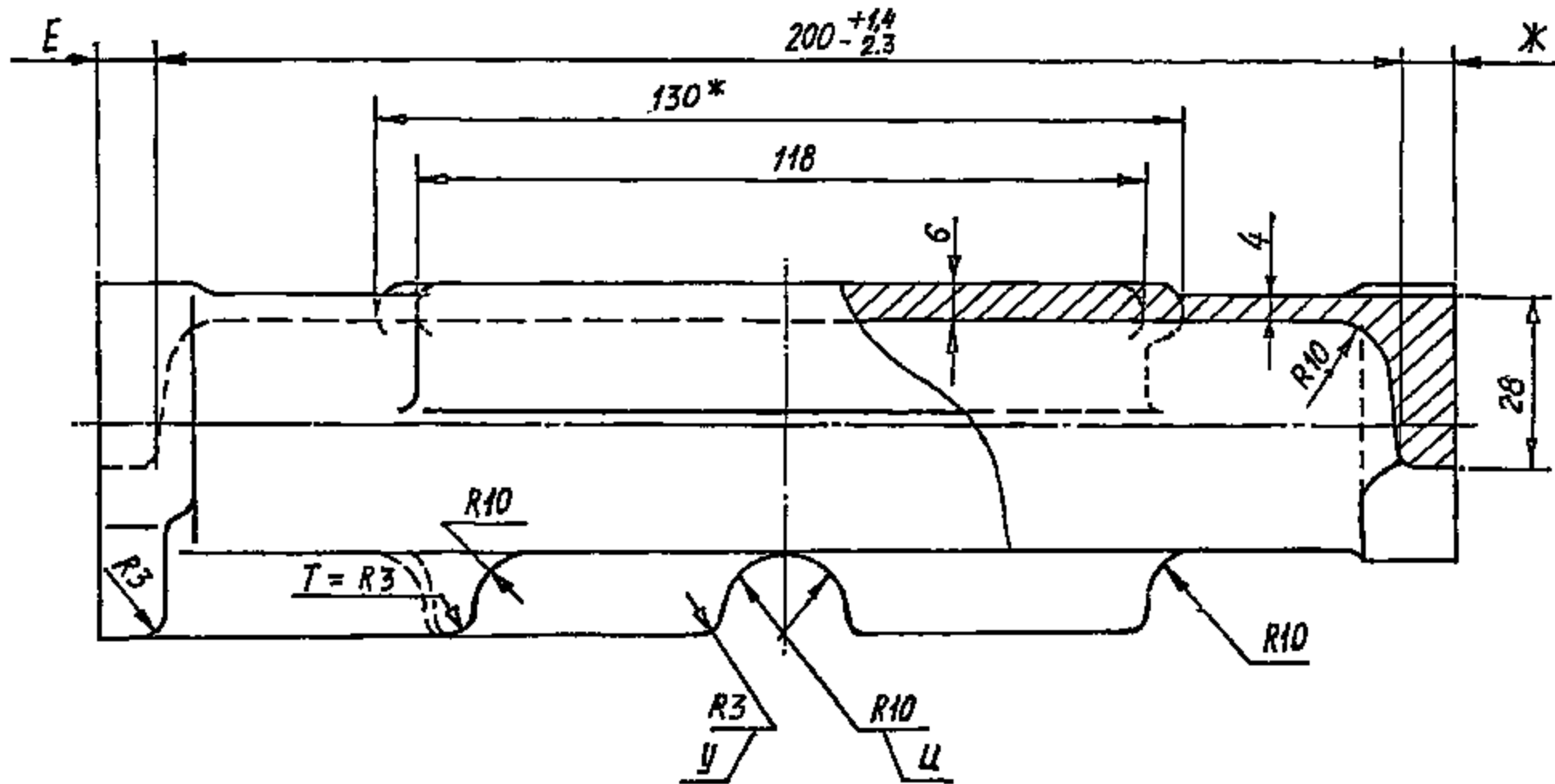
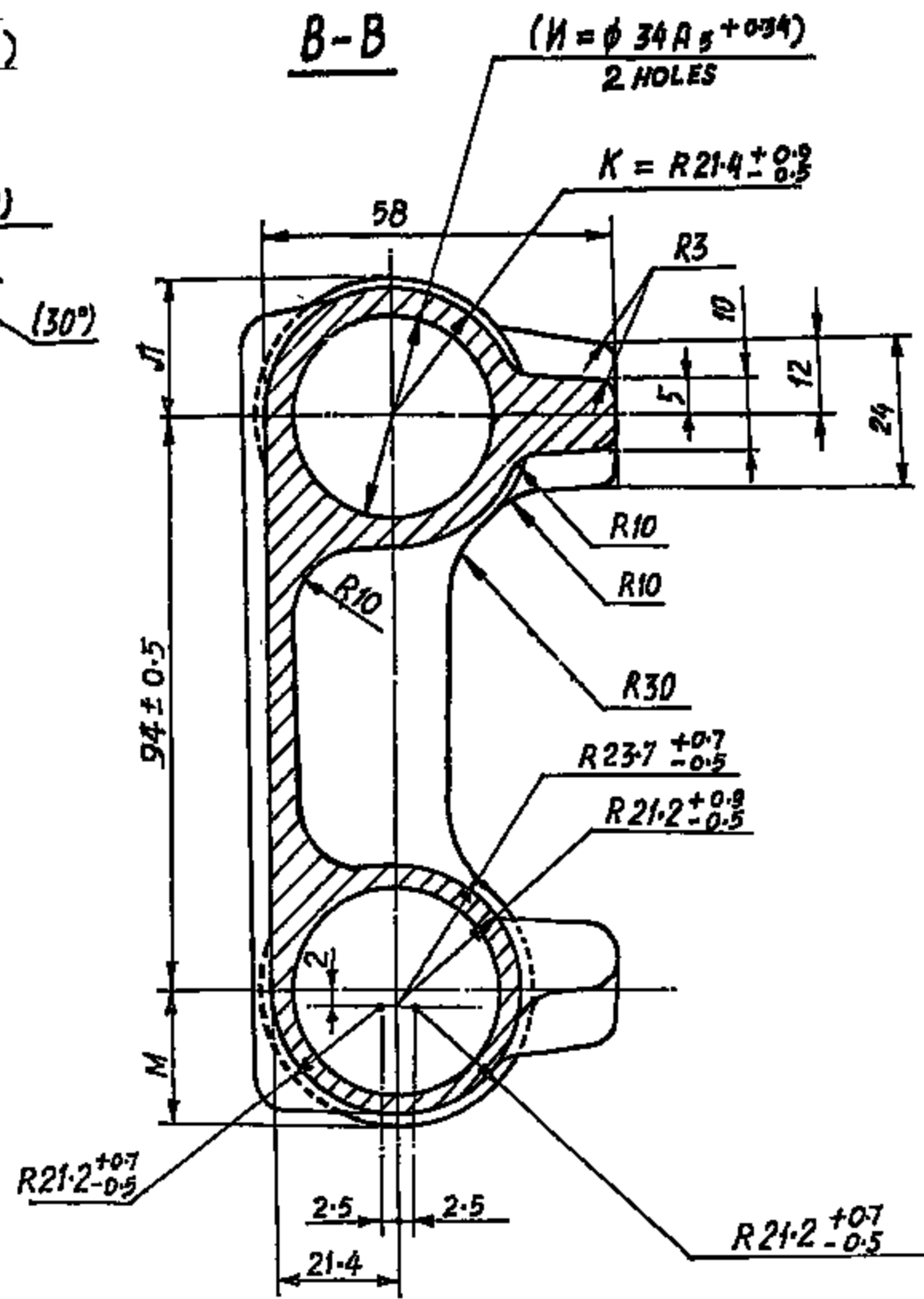
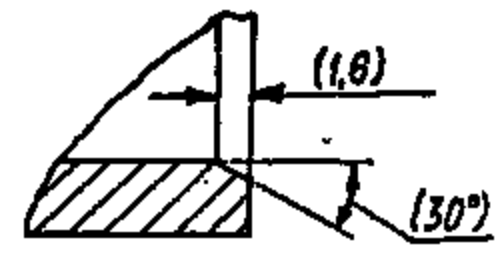
TECHNICAL CONDITIONS

1. THERE SHOULD BE ELECTRICAL CONTACT AT THE POINT OF CONTACT OF NEEDLE AND PIN. CHECKING MAY BE CARRIED OUT IN ASSEMBLY 675-35-CB 124 CB BY CHECKING ELECTRICAL CONTACT BETWEEN PIN AND TRACK.
2. RECTILINEARITY OF NEEDLES AFTER PRESS FIT IS NOT CHECKED.
3. \* DIMENSIONS ARE GIVEN FOR REFERENCE.

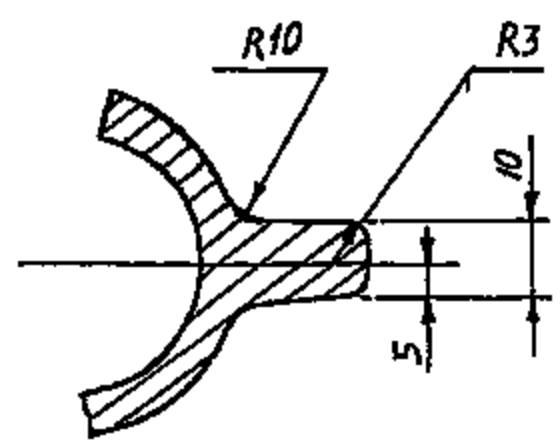
NEAREST EQ. MATERIAL		00229 /ICV 5 MAR 91 DC(I) No & DATE	ISSUE	NEW DRG. PREPARE BASED ON NEW DRG. INTRODUCED BY THE COLLABORATORS (D-335-1CV)
ORGL MATERIAL:-				AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF		ALL THREADS TO CONFORM TO SPECIFICATION		STAMP OR ETCH, PART No. MANUFACTURER'S NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON: 675-35-Sb9
SCALE: 1:1		DATE: 5-3-91		
DRN. KHARILAL	WT :- (Kg)	<b>675-35-Sb125Sb</b>		
TCD. KHARILAL	1.09			
CHD.		<b>PIN</b>		DS CAT No.
APPD.		<b>CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)</b>		



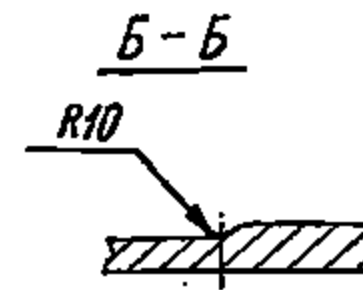
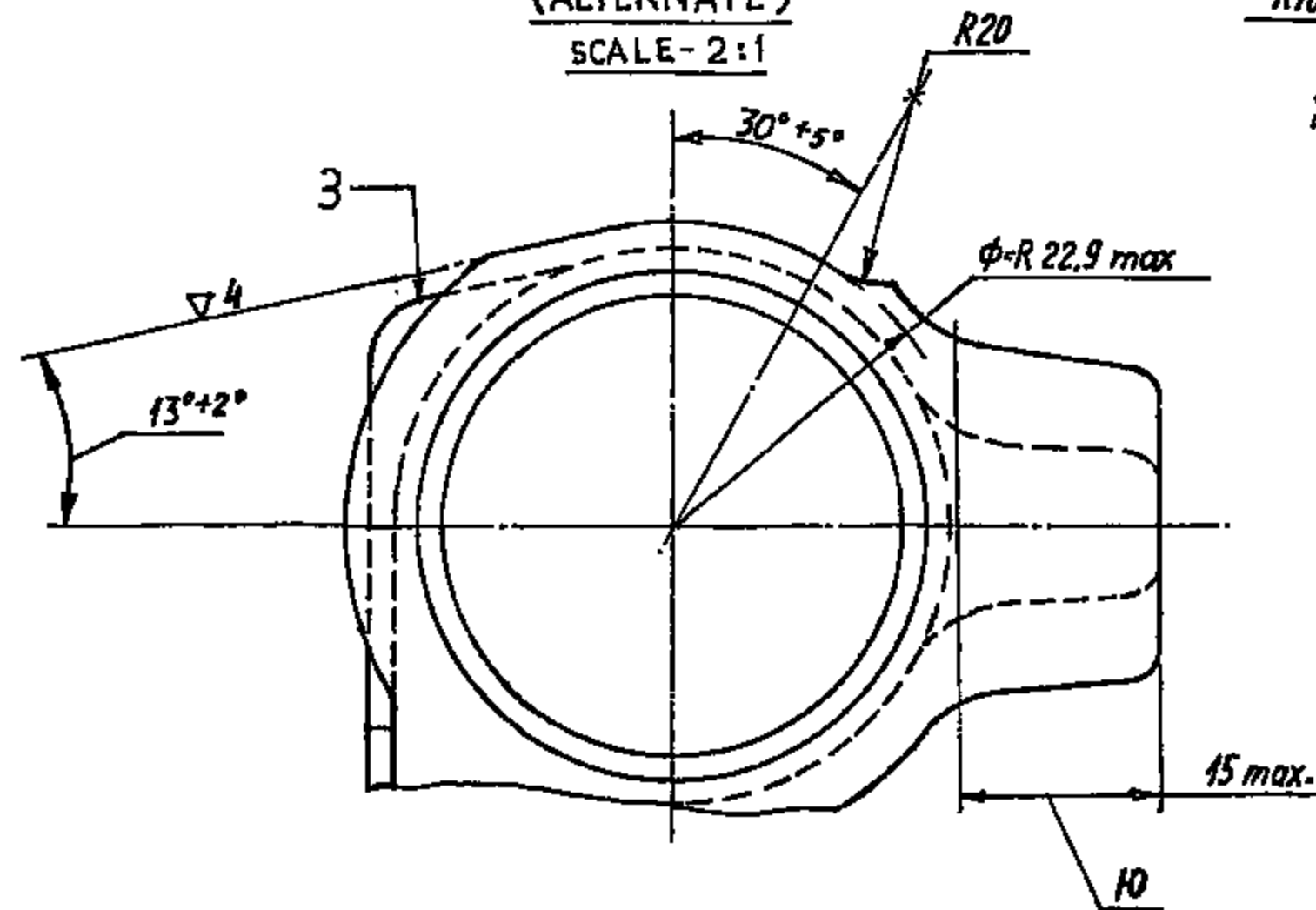
VIEW 'I'  
(ALTERNATE)  
SCALE - 2:1



U-U  
(REVOLVED)



VIEW 'A'  
(ALTERNATE)  
SCALE - 2:1



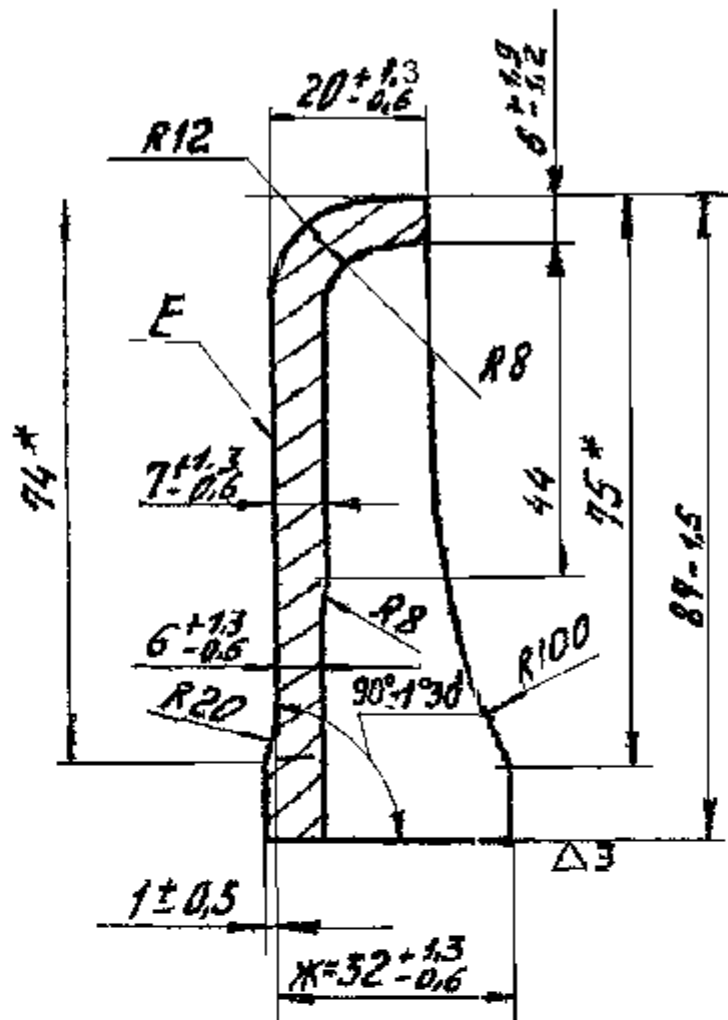
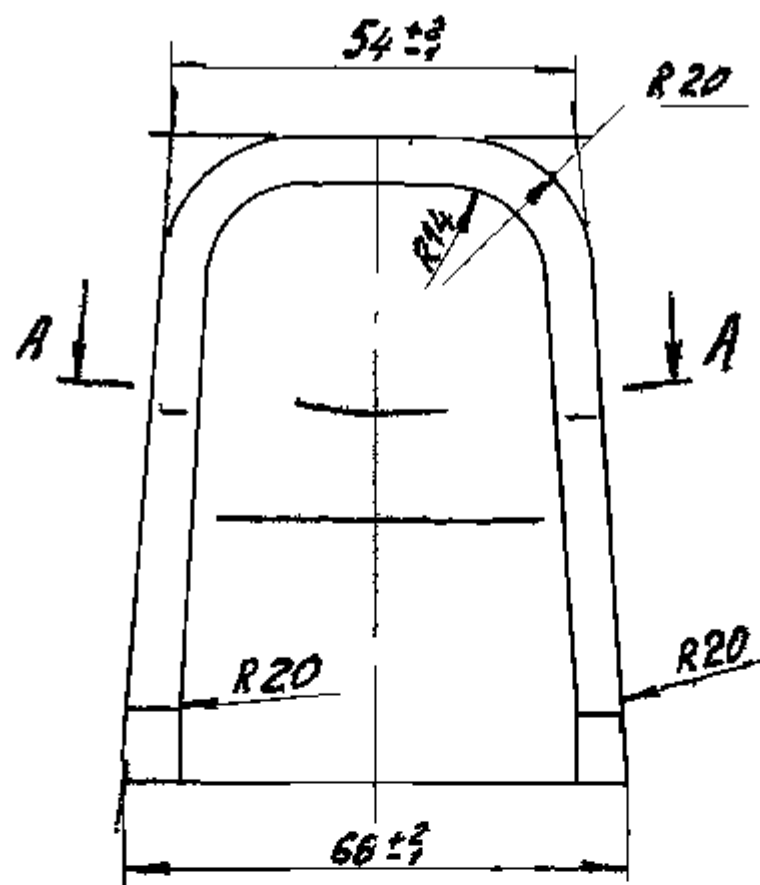
TECHNICAL CONDITIONS

- OTHER TECHNICAL REQUIREMENTS FOR FORGING ARE AS PER CLASS II ACCURACY, GOST 7505-74.
- UNSPECIFIED FORGING RADII 5MM.
- UNFILLED CORNERS OF GROUSERS UP TO R 8MM AND CORNERS T, Y AND U UP TO R 15MM ARE ALLOWED.
- ISOLATED DEPRESSIONS DUE TO CAVITIES, DENTS ETC. AND TRACES OF DRESSING OF SURFACES WITH A DEPTH NOT EXCEEDING THE DIMENSIONS BEYOND PERMISSIBLE LIMIT DEVIATIONS ARE ALLOWED.
- RESIDUAL FINS/PROJECTIONS NOT EXCEEDING 0.4MM AT PLACES ALONG DIMENSIONS 'K' AND 'P' ARE ALLOWED.
- DIFFERENCE IN DIMENSIONS 'E' AND 'M' SHOULD NOT EXCEED 1.5MM.
- INCREASE IN DEVIATION OF DIMENSIONS 'K' AND 'P' UP TO +1.7MM IS ALLOWED. IN THIS CASE THE DIMENSIONS 'M' -0.5 AND 'M' FROM AXIS OF HOLE 'M' UP TO THE COLLAR SHOULD NOT EXCEED 22.9MM. IT IS ALLOWED TO DRESS THE LUG AS PER ALTERNATE VIEW 'A' BY ENSURING THE DIMENSION φ ALONG THE COMPLETE LENGTH, IN THIS CASE TRACES OF CUTTING INSTRUMENT ON SURFACE 'B' WITHOUT FORMATION OF STEPS ARE ALLOWED.
- THE DIMENSIONS AND SURFACE FINISH GIVEN IN BRACKETS ARE AFTER ASSEMBLY.
- MARKING TO BE ENGRAVED AS PER INSTRUCTION M-50-6 WITH TYPE 8 TO GOST -2930-62. MARKING ON SURFACE 'H' WITH EMBOSSED LETTERS IS ALLOWED.
- OTHER REQUIREMENTS AS PER TT 429.
- NON FLATNESS OF SURFACE 'C' SHOULD NOT EXCEED 1.5MM AND ALONG THE AXIS OF LUG SHOULD NOT EXCEED 1 MM.
- \* DIMENSIONS ARE PROVIDED WITH TOOL.
- INCREASE IN DIMENSION 'U' UP TO MAXIMUM R 20MM IS ALLOWED WHILE DRESSING THE DEFECTS.
- TRACES OF EJECTOR WITH DIAMETER NOT EXCEEDING 20MM, UP TO HEIGHT NOT EXCEEDING 2MM OR DEPTH NOT EXCEEDING 1 MM ARE ALLOWED ON SURFACE 'H' AT TWO PLACES.
- PRESENCE OF DARK SPOTS IN ANY NUMBER ON THE LATERAL SURFACES OF GROUSERS AT SECTION 'U' IS ALLOWED.

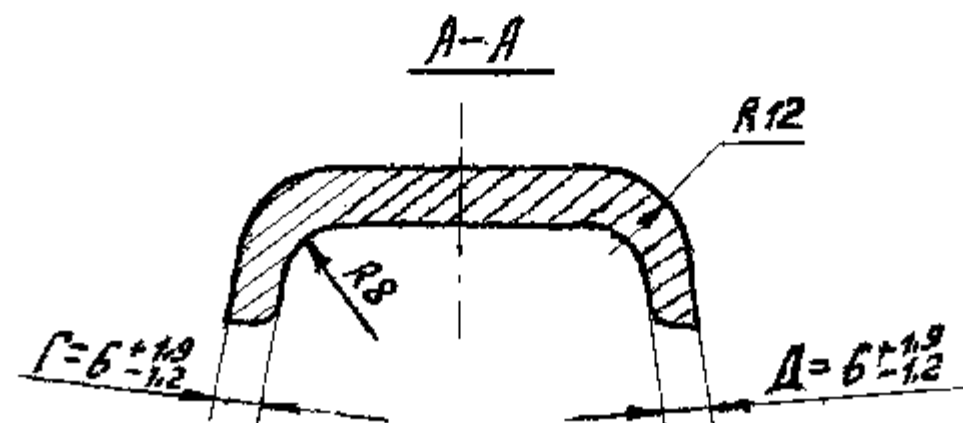
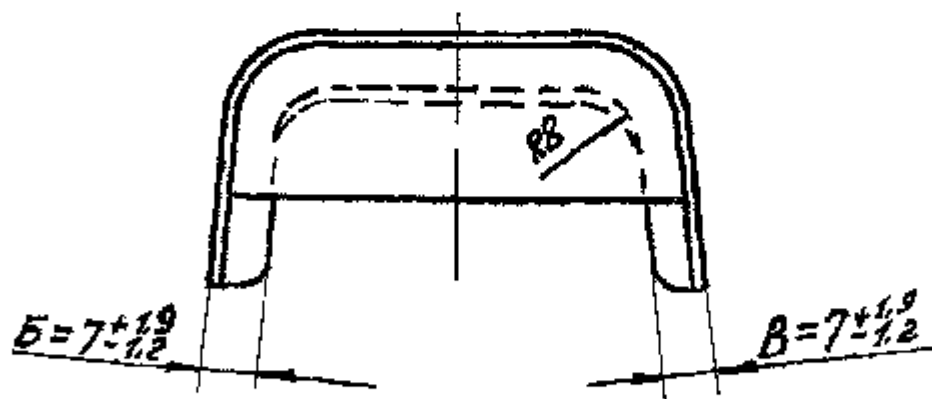
THE ABBREVIATIONS AND SYMBOLS ARE BASED ON RUSSIAN SPECIFICATIONS.  
ALL DIMENSIONS ARE IN mm.

00001-ICV  
19-7-88  
DC(No. & DATE) ISSUE  
DESIGN CHANGED IN ANTI SKID LUGS  
AMENDMENTS

APPROVED	<i>[Signature]</i>	765-35-2	
CHECKED	<i>[Signature]</i>	WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		3.576	1:1
		SHT	SHTS
		20 XГЧМ (ТВМ), ТУ 14-1-2320-78	



- 1 UNSPECIFIED STAMPING DRAFTS ARE 6°.
- 2 UNSPECIFIED STAMPING RADII ARE 3 mm.
- 3 SEPERATE DEPRESSIONS CAUSED BY SCALING, NICKS AND TRACES LEFT AFTER FLAT DRESSING OF SURFACE DEFECTS TO A DEPTH WHICH KEEPS THE DIMENSIONS WITHIN THE PERMISSIBLE LIMITS ARE ALLOWED.
- 4 DIFFERENCE IN MEASUREMENTS OF DIMENSIONS Б AND Б,Г AND Д SHOULD NOT EXCEED 1.2 mm.
- 5 RESIDUAL FLASH SHOULD NOT EXCEED 0.8 mm.
- 5 NON-FLATNESS OF SURFACE 'E' SHOULD NOT EXCEED 1 mm.
- 7\* DIMENSIONS ARE PROVIDED BY TOOL.
- 8 PART MAY BE MANUFACTURED WITH DIMENSION  $X = 30 \pm 1.3 - 0.6$




DCO) No. & DATE	ISSUE	AMENDMENTS

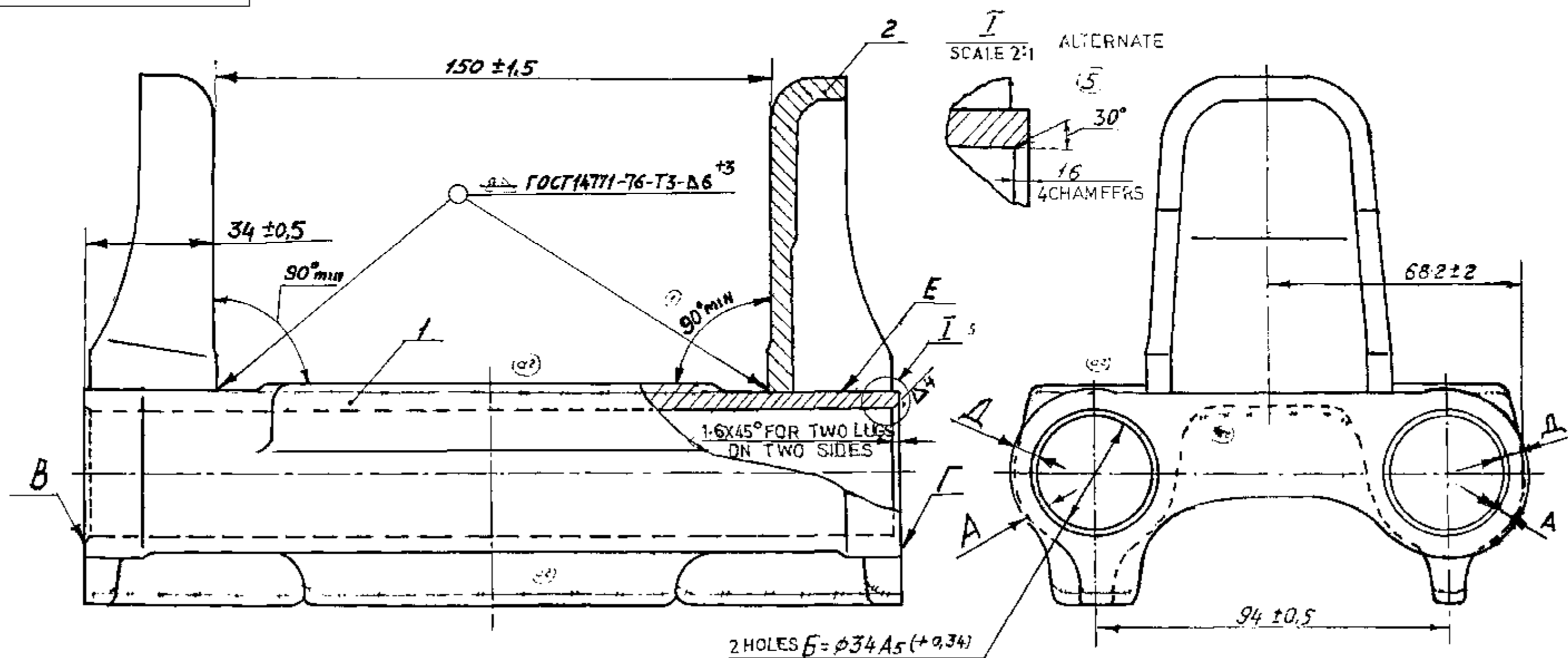
APPROVED *M VASU*  
 CHECKED *Kathak*  
 CONTROLLERATE OF QUALITY ASSURANCE (ICV)

**765-35-19**  
**TRACK GUIDE**  
 20 Г ЧММ (Т В М)  
 ТУ 14-1-2320-78

WEIGHT	SCALE
0.464	1:1
SHT	SHTS


QTY	ZONE	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
				<u>TECHNICAL PAPERS</u>		
13			765-35- C6104 C6	ASSY. DRAWING		
				<u>PARTS</u>		
24	1		765-35-2 (ISSUE 'A')	TRACK	1	
12	2		765-35-19	GUIDE	2	

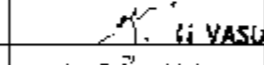
APPROVED	 H. VASU	<b>765-35-Sb104</b>		
CHECKED	V. D. PATHAK			
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>		<b>TRACK WITH GUIDE</b>	WEIGHT	SCALE
			SHT 1	SHTS 1



- 8. AFTER FINAL HEAT-TREATMENT SUBJECT TRACK WEBS AND THEIR FILLET SURFACES TO LUGS TO SURFACE HARDENING BY SHOT BLASTING WITH CAST STEEL SHOTS AS PER INSTRUCTIONS <sup>AM 130-74 OR 052.250.50.00007</sup> SURFACE HARDENING MAY BE DONE ON THE REST OF THE SURFACES EXCEPT SURFACES OF HOLES INCLUDING CHAMFERS.
- 9. TRACK SHOULD BE MATED WITH ANY OTHER TRACK (THROUGH PINS AND LINKS) AND SHOULD PROVIDE FOR RELATIVE TURNING TO AT LEAST 45° TOWARDS THE GROUSER AND TO AT LEAST 26° IN THE REVERSE DIRECTION. DRESSING IS PERMITTED.
- 10. OTHER REQUIREMENTS ARE AS PER TECHNICAL REQUIREMENTS TT 429.

- 1. HB 477 TO 388 (Ø 2.8 TO 3.1) MEASURE IT ON TRACK.
- 2. REMOVE SCALING FROM THE SURFACE OF HOLE 6 AFTER HEAT TREATMENT
- 3. CARRY OUT WELDING WITH WELDING WIRE CB 08 T2C GOST 2246-70 HAND WELDING Δ 8 AS PER GOST 5264-80 WITH ELECTRODE 950 A GOST 9467-75 IS ALLOWED AS A RESULT, LOCAL DECREASE OF THE LEG TO AT LEAST 75mm IS ALLOWED.
- 4. DRESS WELD ALONG THE GUIDE EDGES FLUSH WITH SURFACES B AND C. DO NOT CHECK THE REMAINING WELD DIMENSIONS.
- 5. WELDING DRIBBLES ARE ALLOWED ON INTERNAL SURFACE OF GUIDES AND TRACK SURFACE E LIMITED BY THE GUIDE WALLS
- 6. NON-PARALLELITY AND MISALIGNMENT OF AXIS OF HOLES 6 SHOULD NOT EXCEED 0.5mm OVER THE LENGTH OF PART
- 7. LOCAL THINNING OF WALLS A TO AT LEAST 3.3 mm, THAT OF BEEDS Δ, TO AT LEAST 4.6mm IS ALLOWED. DIMENSION A MAY NOT CHECKED ON THE INNER SIDE OF THE LUG

00031-ICV		SPECN.No.052.250.50.00007 ADDED AS ALTERNATIVE TO SPECN. AM 130-74 IN TECH. CONDITION No- 8.
 20 JAN 89	(A)	
DC(I) No & DATE	ISSUE	NATURE
AMENDMENT		

APPROVED		<b>765-35-Sb104Sb</b>		
CHECKED	V. D. PĀTHAK			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	TRACK WITH GUIDES(ASSY DRG)		WEIGHT	SCALE
			4.711	
		SHT 1	SHTS 1	