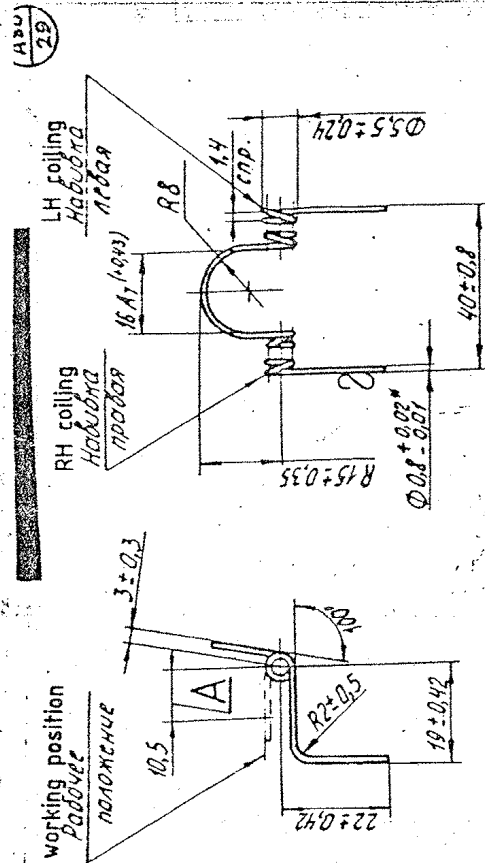


DRAWING NUMBER
A 74-009

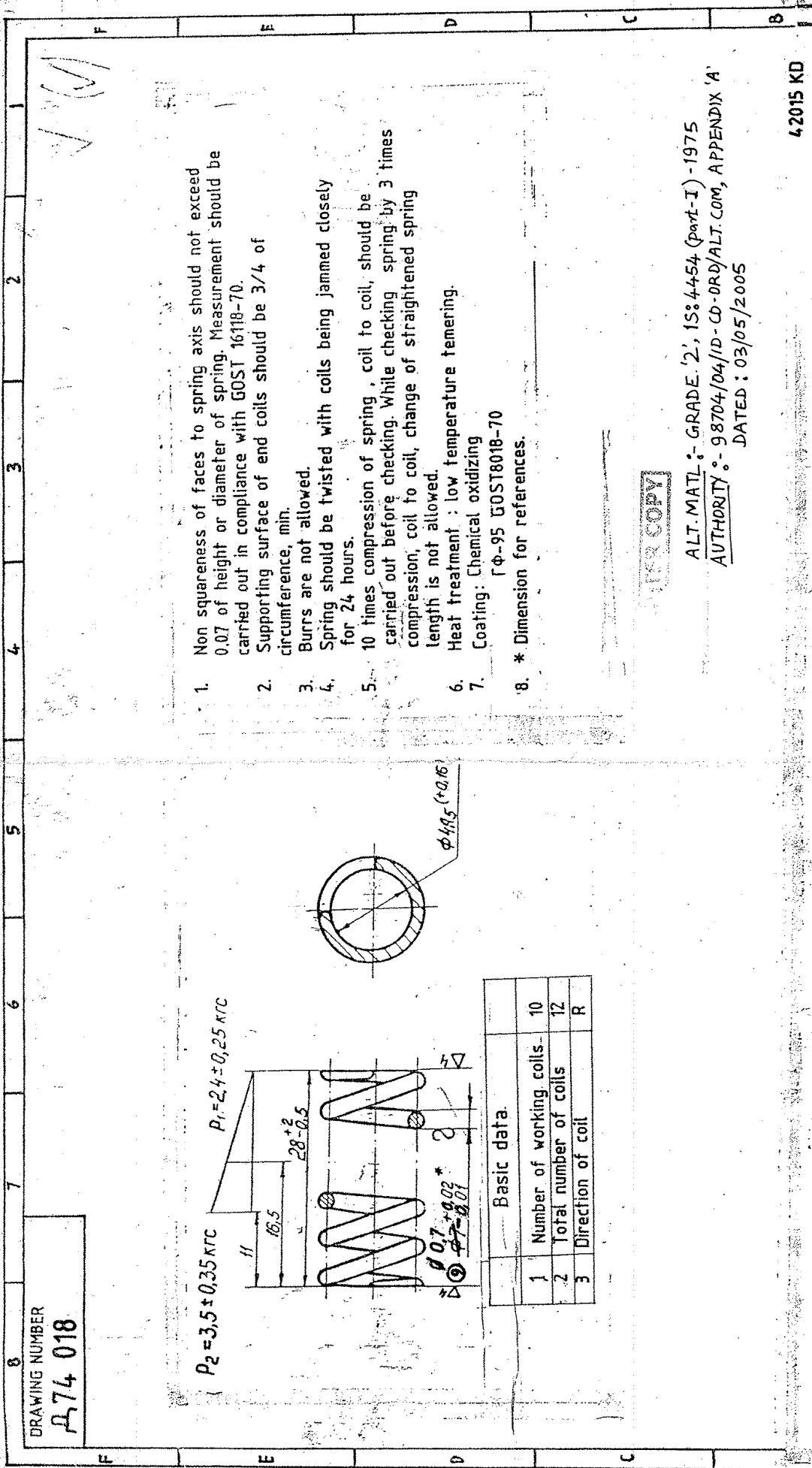


1. Total number of turns in working position is equal to 16, arranged symmetrically.
2. Heat treatment low temperature tempering.
3. In the working position effort of spring is equal to 0.8 ± 0.03 kgf on shoulder A.
4. Coating: chemical oxidizing
ГФ-95 ГОСТ 8018-70
5. Angle 100° may be changed depending upon the material.
6. * Dimensions for references.

MASTER COPY

ALT. MATL. - Gde. 2, IS: 4454 - 75 (payt I)
 AUTHORITY - C&A (HV) LETTER NO. 98704/04/D - CO - ORD /ALT
 COM, APPENDIX 'A' DATED 03/05/2005

	DRN V. P. [Signature]	MATERIAL:- WIRE 1-0-8 TY14-4-92577 #20-000C5	USED ON: #20-000C5
	CHD [Signature]	CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI	
	TCD [Signature]	TITLE: SPRING	
	APPD [Signature]		
	DATE 12-2-1987	D S CAT NUMBER DRAWING NUMBER A 74-009	
	SCALE - 1:1		
DIMENSIONS IN mm			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED			
ALL THREADS CONFORM TO			
ISSUE	DATE	NATURE OF AMENDMENTS	
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION. 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.			



Basic data	
1	Number of working coils 10
2	Total number of coils 12
3	Direction of coil R

1. Non squareness of faces to spring axis should not exceed 0.07 of height or diameter of spring. Measurement should be carried out in compliance with GOST 16118-70.
2. Supporting surface of end coils should be 3/4 of circumference, min.
3. Burrs are not allowed.
4. Spring should be twisted with coils being jammed closely for 24 hours.
5. 10 times compression of spring, coil to coil, should be carried out before checking. While checking spring by 3 times compression, coil to coil, change of straightened spring length is not allowed.
6. Heat treatment: low temperature tempering.
7. Coating: Chemical oxidizing
Γφ-95 GOST8018-70
8. * Dimension for references.

WORK COPY

ALT. MATL: GRADE: 2; IS: 4454 (part-I) - 1975
 AUTHORITY: - 98704/04/ID - CD-ORD/ALT.COM, APPENDIX 'A'
 DATED: 03/05/2005

42015 KD

DRAWING NUMBER P.74 018		MATERIAL:- WIRE 1-0.7 TY-4-823-77		USED ON: P.20 010 C6
DRN	V. Romanov	CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI		
CHO	Bludovskiy	TITLE: SPRING		
TCD	Shchegolev	D S CAT NUMBER P.74 018		
APPD	15.2.1987	D S CAT NUMBER		
DATE	15.2.1987	D S CAT NUMBER		
SCALE	5:1	D S CAT NUMBER		
DIMENSIONS IN mm				
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.				
ALL THREADS CONFORM TO				
9	9-8-90	CORRECTION BY SCT		
ISSUE	DATE	NATURE OF AMENDMENTS		

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

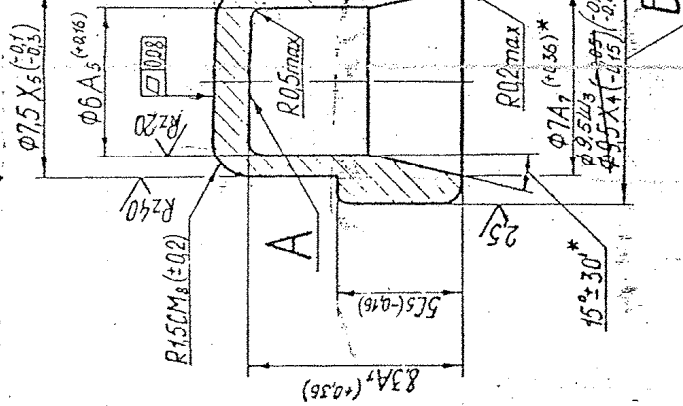
EST. MASS. TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

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

DRAWING NUMBER
A 74 019



Rz 80 (✓)



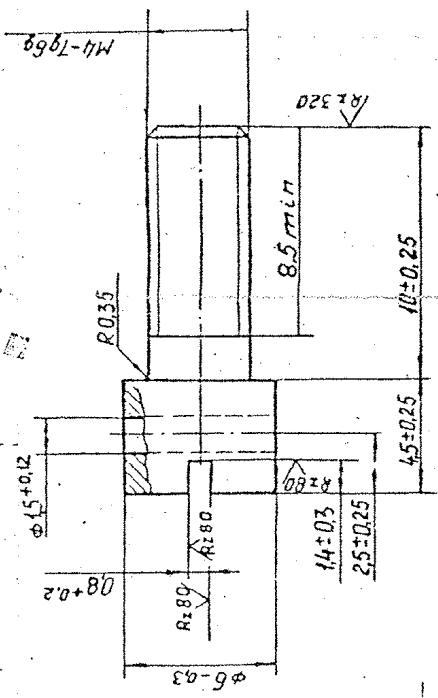
MASTER COPY

ALT. MALT :- STEEL 40, IS:1570
 AUTHORITY :- 98704/04/D-CO-ORD/ALT.COM, APPENDIX 'A'
 DATED 3/5/2005

1. HRC 32, 42.
2. * Dimensions should be ensured by tools.
3. Dimension b after coating.
4. Tool marks 2mm in diameter, max and 0.3 mm deep, max, are allowed on surface A.
5. Coating : Cd.9, Chromatizing.

DRAWING NUMBER A 74 019		MATERIAL :- STEEL 40, GOST 1050-74		USED ON: P.20 010 C6	
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION		DATE 18.2.1987		CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI	
EST. MASS. 3.5g		SCALE - 5:1		TITLE: BLOCK	
TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)		DIMENSIONS IN mm		D S CAT NUMBER	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R. INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		TOLERANCE ON DIMS UNLESS OTHERWISE STATED.		DRAWING NUMBER A 74 019	
		ALL THREADS CONFORM TO			
ISSUE		DATE		NATURE OF AMENDMENTS	

DRAWING NUMBER
X1-10-84



1. Alternate material steel 15 GOST 1050-74 and steel A12 GOST 1414-75
2. Limit deviation from alignment of head axis and slot relative to rod axis should be 0.15 mm.
4. Technical requirements as per GOST 1759-70.

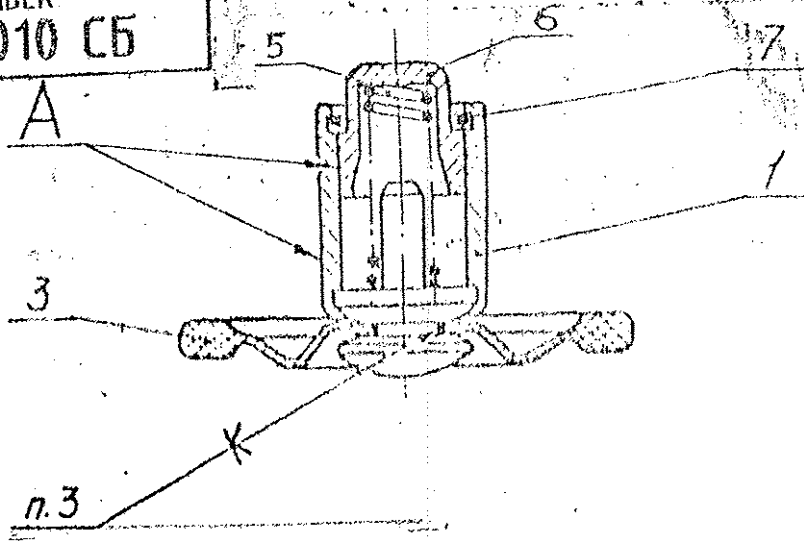
PART No.	COATING
X1-10-84	Zn6,Chromatizing

MASTER COPY

ALT. MATL: - C14, 1S: 2073-70
 AUTHORITY: CGA (HY) LETTER NO. 98704/04/D-CO-ORD/ALT.COM DATED 30-05-2005

DRN m. (Ones/Thousands) CHD <i>Blatkovskiy</i> TCD <i>4.0000</i> APPD <i>5.1</i> DATE 15.2.2008 SCALE - 5:1 DIMENSIONS IN mm TOLERANCE ON DIMS UNLESS OTHERWISE STATED. ALL THREADS CONFORM TO		MATERIAL:- STEEL 10 GOST 1050-74. A 20.000 C5 USED ON:
PART No. X1-10-84 COATING Zn6,Chromatizing		CONTROLLER OF INSPECTION (HEAVY VEHICLES) AYADI TITLE: SCREW
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.	EST. MASS. 1.7g TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)	U S CAT NUMBER DRAWING NUMBER X1-10-84
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R. INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE		

DRAWING NUMBER
Д 20 010 СБ



PILOT COPY

1. Surface A and place of flaring should be slightly lubricated with grease ЦИАТИМ-221 GOST 9433-60.
2. Block 6 should move freely with out jamming.
3. Glue 88H МРТУ-38-5-880-66.
4. Glue 88 НП Т 938-105.540-73.
5. Minimum effort at the beginning of block 6 movement should be 2.3 kgf.

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

		EST. MASS 0.013	TO BE STAMPED OR MARKED WHERE INDICATED THUS (4 LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
		MATERIAL :-	USED ON :- Д 20 000 СБ
SUE	DATE	NATURE OF AMENDMENTS	
IN		SCALE - 2:1	
ID		DIMENSIONS IN MM.	
PPD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	
ATE		ALL THREADS CONFORM TO	
		CONTROLLER/DATE OF INSPECTION (HEAVY VEHICLES) AVADI	TITLE :- ROD ASSY
		D S CAT NUMBER	DRAWING NUMBER Д 20 010 СБ

P. Roy

IZE A4.