

**EXPLANATORY NOTE**

8 REFERENCE MATERIAL QUOTED :-  
 BRIGHTSTEEL HEX BAR, CLASS OF ACCURACY 5(A/F 17) TO GOST 8560-78  
 AND MATERIAL SPECN GOST 1050-74 GRADE 40

9 ALTERNATE MATERIAL QUOTED :-  
 STEEL 40,50 GOST 1050 -74

a) **CHEMICAL COMPOSITION :**

GRADE OF STEEL	CONTENT OF ELEMENTS %							REMARKS
	C	SI	Mn	Cr	Ni	S	P	
40	0.37 - 0.45	0.50 - 0.80	0.50 - 0.80	0.25	0.25	0.04	0.035	ALT-MATERIAL
45	0.42 - 0.50	0.17 - 0.37	0.50 - 0.80	0.25	0.25	0.04	0.035	—
50	0.47 - 0.55	0.17 - 0.037	0.50 - 0.080	0.25	0.25	0.04	0.035	ALT-MATERIAL

b) **MECHANICAL PROPERTIES**

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm <sup>2</sup>	ELONGATION	REDUCTION OF AREA %	IMPACT STRENGTH Kgm/Cm <sup>2</sup>	HARDNESS B H N (MAX)	REMARKS
40	62	6	35	6	241	ALT-MATERIAL
45	65	6	30	5	241	—
50	67	14	40	4	241	ALT-MATERIAL

Ⓐ **EQUIVALENT MATERIAL STEEL**  
 45C8 TO IS:1570

1 **UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS :-**

FOR HOLES - AS PER A7,  
 SHAFTS - AS PER B7,  
 OTHERS - AS PER CM7.

2 **WHEN FACING BUTT ENDS B (AND T), SINGLE-POINT TOOL MAY CUT ALONG THE CYLINDRICAL SURFACE TO A DEPTH OF NOT MORE THAN 0.2 mm.**

3 **CRACKS, BURRS, NOTCHES AND OTHER MECHANICAL DAMAGES ARE NOT PERMITTED.**

4 **THREAD SHOULD BE CLEAN AND FREE FROM BURRS, STRIPING AND DENTS.**

5 **COATING - CADMIUM-PLATED - 9 MICRONS THICK, OILED. INTERNAL SURFACES MAY HAVE NO COATING.**

6 **ARRANGEMENTS OF HOLES K WITH RESPECT TO THE HEXAGON IS ARBITRARY.**

7 **ALTERNATE MATERIAL IS STEEL 40 : 50 GOST 1050-74.**

\* 17-5 GOST 8560-78  
 \* 45 GOST 1050-74

KVD NO 634/18

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

EST. MASS	0,034 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS #
ISSUE DATE	13.8.10, 4 <sup>th</sup> Alt. Comm. Meeting Minutes Point No.11 Dt:26-10-09	LETTERS:
DRN	SCALE - 2:1	MATERIAL - SEE ABOVE
CHD	DIMENSIONS IN mm	USED ON - CB 20-27-00-4
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION ( HEAVY VEHICLES ) AVADI
APPD	DATE 6/3/97	TITLE - CONNECTOR
	ALL THREADS CONFORM TO	D S CAT NUMBER
		DRAWING NUMBER 20-27-342



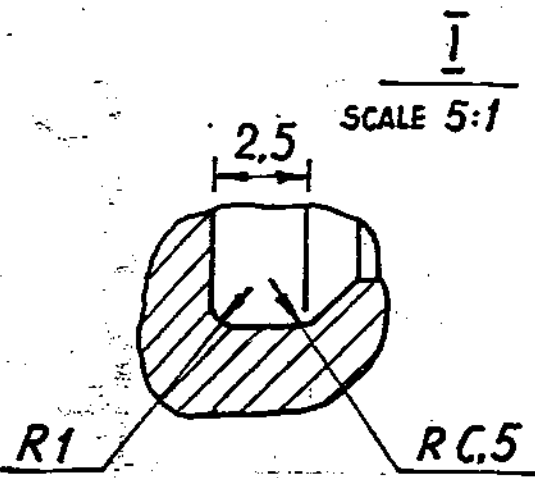
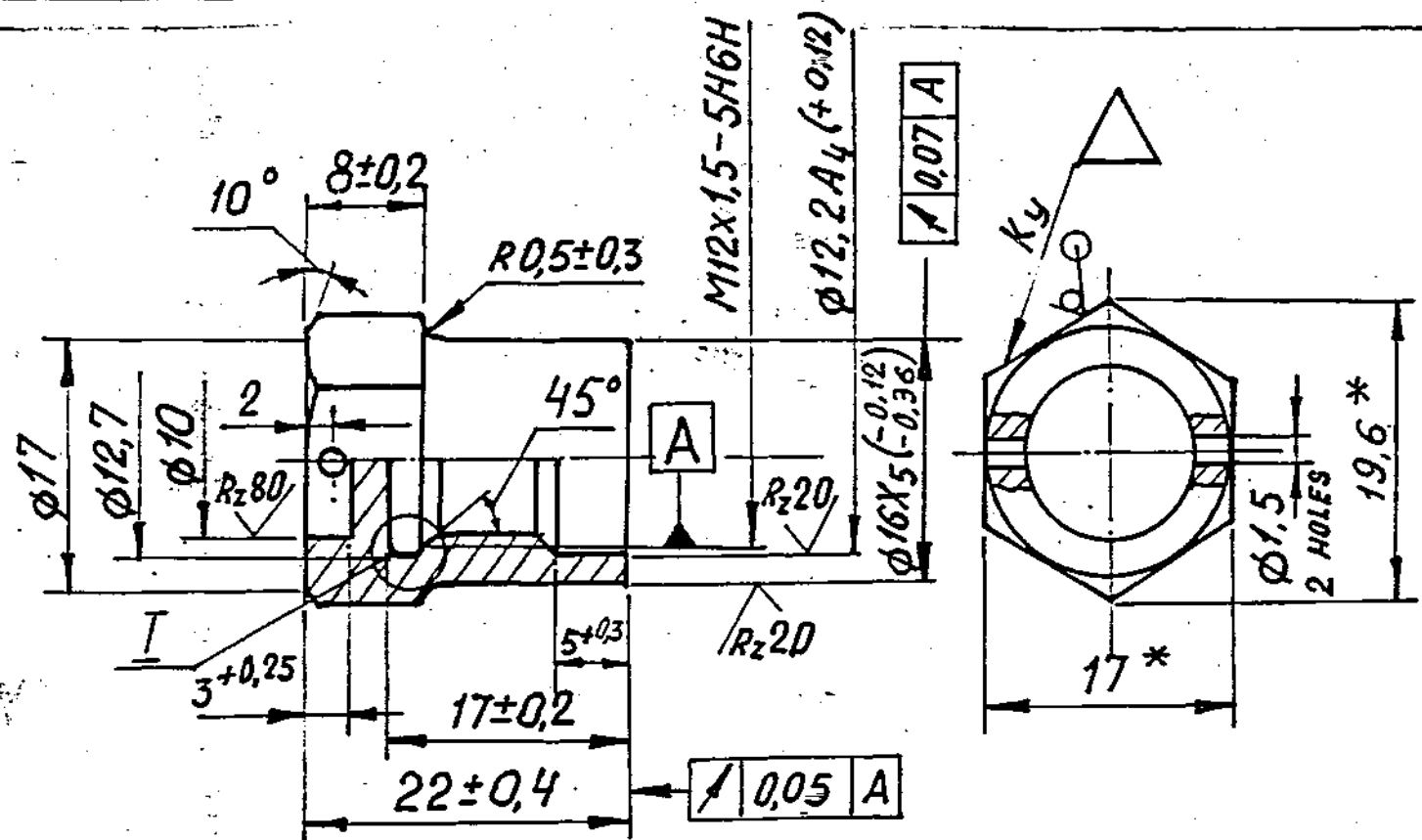




DRAWING NUMBER

20-29-21-1

Rz 40 ✓/✓



1. Alt Matl IS STEEL 40, 50 GOST 1050-74.
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS :  
 FOR HOLES - AS PER A7  
 FOR SHAFTS - AS PER B7  
 FOR OTHERS - AS PER CM7
3. ROUNDING OF FACES UP TO  $\phi$  19mm IS PERMITTED.
4. COATING : CADMIUM-PLATED 9 MICRONS THICK OILED  
 ABSENCE OF THE COATING ON THE INTERNAL SURFACES IS PERMITTED.
5. \* DIMENSIONS ARE GIVEN FOR REFERENCE.

**EXPLANATORY NOTE :-**

Ref. Matl. Quoted : BRIGHT STEEL HEX BAR CLASS OF ACCURACY 5 (A/F 17) TO GOST 8560-78 AND MATERIAL SPECN GOST 1050-74 GRADE 45.

ALT Matl Quoted : STEEL GRADE 40, 50, GOST 1050-74.

(a) CHEMICAL COMPOSITION :

GRADE OF STEEL	CONTENT OF ELEMENTS %							REMARKS
	C	Si	Mn	Cr	Ni	S	P	
40	0.37,0.45	0.17,0.37	0.50,0.80	0.25	0.25	0.04	0.035	Alt Matl
45	0.42,0.50	0.17,0.37	0.50,0.80	0.25	0.25	0.04	0.035	---
50	0.47,0.55	0.17,0.37	0.50,0.80	0.25	0.25	0.04	0.035	Alt Matl

(b) MECHANICAL PROPERTIES :

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/cm <sup>2</sup>	% ELONGATION	REDUCTION OF AREA %	IMPACT STRENGTH Kgm/cm <sup>2</sup>	HARDNESS B H N ( MAX )	REMARKS
40	58	19	45	6	241	Alt Matl
45	61	16	40	5	241	---
50	64	14	40	4	255	Alt Matl

Ⓐ EQUIVALENT MATERIAL STEEL :  
45C8 TO IS:1570

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

EST. WT. 0.019 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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

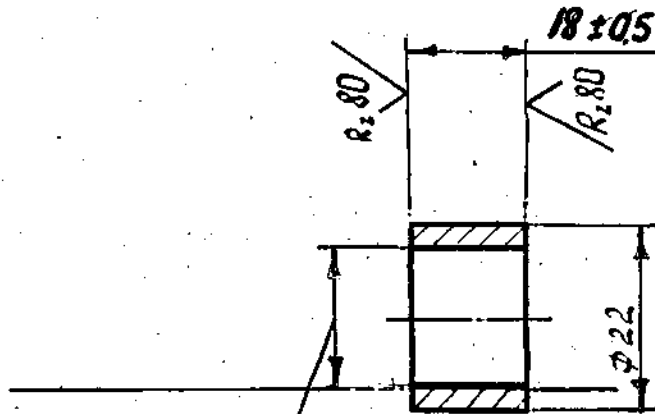
DRN	CHD	TCD	APPO	DATE	SCALE	DIMENSIONS IN mm.	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	MATERIAL :- 17-5 GOST 8560-78 45 GOST 1050-74	USED ON :- C6 20-29-00-8 C6 20-27-00-4
				11-10-89	2:1			CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A D I	
								TITLE NUT M12	
								D S CAT NUMBER	DRAWING NUMBER 20-29-21-1
ISSUE	DATE	NATURE OF AMENDMENTS							

KVD No: 63356

SIZE-A2



141-04-02



Сверлить до  $\phi 18.5$   
DRILL TO 18.5 DIA.

138. N 1437-78

1. COATING OF MAKE. y. 3Ц9. xp.
2. COATING OF MAKE T : K@9. xp. WITH NEXT ELIMINATION OF HYDROGEN EMBRITTLEMENT.
3. IT IS ALLOWED MAKING FROM PIPE ACCORDING TO GOST 10704-76.
4. COATING ABSENCE IS ALLOWED ON INNER SURFACE.

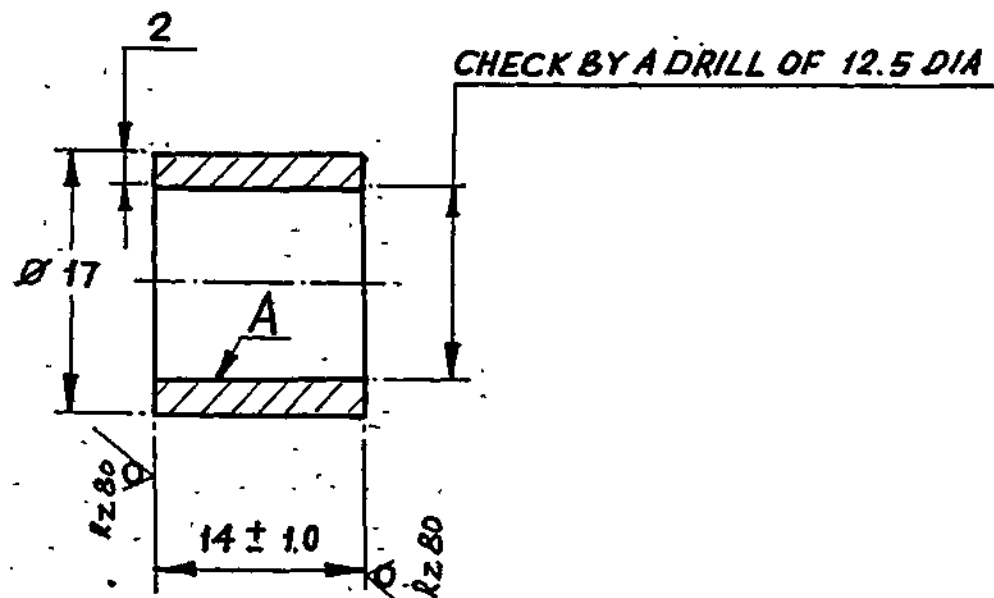
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

\* 22 X 2 GOST 8734-75  
20 GOST 8733-74

			EST. MASS 0.010 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.
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL * SEE ABOVE	USED ON:- 1. CB 20-29-00-7 2. CB 20-27-00-6
DRN		SCALE - 1 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD		DIMENSIONS IN mm.	TITLE - PROTECTION SLEEVE	
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	
APPD		ALL THREADS CONFORM TO	DRAWING NUMBER 20 - 40 - 141	
DATE	29.9.86			



DRAWING NUMBER  
20-40-142



EXPLANATORY NOTE:

MATERIAL QUOTED:  $\frac{17 \times 2 \text{ GOST } 8734-75}{10 \text{ GOST } 8733-74}$

17 = OUTER DIAMETER ; 2 = THICKNESS ;  
10 = GRADE OF MATERIAL AS PER GOST 1050-74 ( SEAMLESS STEEL TUBE COLD AND DEFORMED)

CHEMICAL COMPOSITION %:

CARBON = 0.7-0.14  
SILICON = 0.17-0.37  
MANGANESE = 0.35-0.65  
CHROMIUM = 0.15  
COPPER = 0.25  
NICKEL = 0.25  
SULPHUR = 0.040  
PHOSPHORUS = 0.035

} MAXIMUM

MECHANICAL PROPERTIES (AS PER GOST 8733-74)

ULTIMATE TENSILE STRENGTH  $\text{Kgf/mm}^2 = 35 \text{ (MIN)}$   
YIELD POINT  $\text{Kgf/mm}^2 = 21 \text{ (MIN)}$   
ELONGATION % = 24 (MIN)

1. COATING OF MAKE Y. 3. 4. 9. XP
2. COATING OF MAKE T: K 29 xp WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
3. SCALE IS NOT ALLOWED ON 'A' SURFACE.
4. IT IS ALLOWED TO MANUFACTURE FROM BAR.
5. IT IS ALLOWED TO MANUFACTURE FROM PIPE OF 18 mm DIA, ACCORDING TO GOST 10704-76
6. COATING ABSENCE IS ALLOWED ON THE INNER SURFACE.

EXPLANATORY NOTE ADDED ON 18-6-92

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

EST. WT. 0.015 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.

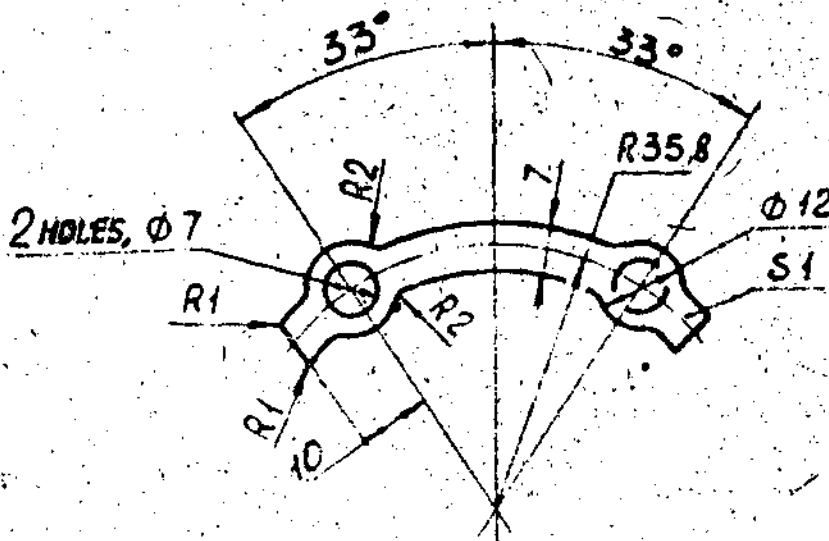
DRN		MATERIAL:-	USED ON
CHD		17 X 2 GOST 8734-75	CS 20-29-00-7
TCD		10 GOST 8733-74	CS 20-27-00-4
APPD		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	25-9-86	AVADI.	
SCALE:-	2:1	TITLE	
DIMENSIONS IN mm		PROTECTION SLEEVE	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69.		D S CAT NUMBER	
ALL THREADS TO CONFORM TO		DRAWING NUMBER	
		20-40-142	
ISSUE	DATE	NATURE OF AMENDMENTS	



SIZE A3



20-53-10



1. ALTERNATE MATERIAL IS STEEL 08kn, GOST 1050-74.
2. COATING : ZINC-PLATED, 6 MICRONS THICK, OILED.
3. REQUIREMENTS PLACED UPON STAMPING ARE AS PER STANDARD 82050-16.

Ⓐ EQUIVALENT MATERIAL  
Gr. O IS: 513-1994

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

A		10.03.10	4 <sup>th</sup> Alt. Comm. Meet. Minutes Point No.1 Dt:26-10-09.	EST. MASS 0.004 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS (LETTERS)
ISSUE	DATE	NATURE OF AMENDMENTS		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
DRN	DATE	SCALE :- 1 : 1		MATERIAL :- 08kn GOST 1050-74	USED ON :- СБ 20-27-00-4
CHKD	DATE	DIMENSIONS IN mm		CONTROLLERATE OF INSPECTION ( HEAVY VEHICLES ) AVADI	
TCO	DATE	TOLERANCE ON DIMMS UNLESS OTHERWISE STATED		TIME :- LOCK WASHER-6	
APPD	DATE	ALL THREADS CONFORM TO		D S CAT NUMBER	DRAWING NUMBER 20-53-10

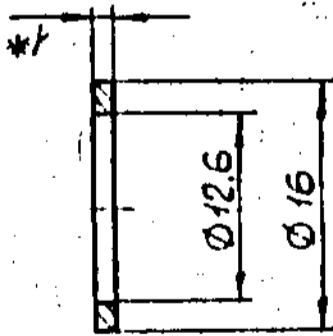
ДСССТАНОВЛЕНО С ПОДЛУЧНОКО  
 верно № 417827 / 08.03.10

M.N.I.U.N.B. N° 246 Подпись, В.В.М.



DRAWING NUMBER

20-55-066



1. Alt. Matl. IS STRIP OF A A.I.M-1, GOST 13726-78.
2. REQUIREMENTS PLACED UPON STAMPING ARE AS PER STANDARD 82050-16.
3. MINUTE DENTS AND STAMPING TOOLS TRACES ARE ALLOWED, IF THEY DO NOT EXCEED 1/2 OF THE PERMISSIBLE DEVIATIONS OF DIMENSIONS.
4. \* DIMENSION IS GIVEN FOR REFERENCE.

\*\*  
 C6 20-06-002  
 C6 20-20-0010  
 C6 20-27-004  
 C6 20-29-007

Ⓐ ALTERNATE MATERIAL: 19000 TO IS 737

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

EST. WT. 0.00044 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS  $\#$  1 LETTERS)

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

DRN	APPR	DATE	SCALE	DIMENSIONS IN MM TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 0.02-0.5	ALL THREADS TO CONFORM TO	ISSUE DATE	NATURE OF AMENDMENTS
CHK	DATE	SCALE	DIMENSIONS IN MM TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 0.02-0.5	ALL THREADS TO CONFORM TO	ISSUE DATE	NATURE OF AMENDMENTS	
TCR	DATE	SCALE	DIMENSIONS IN MM TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 0.02-0.5	ALL THREADS TO CONFORM TO	ISSUE DATE	NATURE OF AMENDMENTS	
APPR	DATE	SCALE	DIMENSIONS IN MM TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 0.02-0.5	ALL THREADS TO CONFORM TO	ISSUE DATE	NATURE OF AMENDMENTS	
DATE	SCALE	DIMENSIONS IN MM TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 0.02-0.5	ALL THREADS TO CONFORM TO	ISSUE DATE	NATURE OF AMENDMENTS		
SCALE	DIMENSIONS IN MM TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 0.02-0.5	ALL THREADS TO CONFORM TO	ISSUE DATE	NATURE OF AMENDMENTS			
DIMENSIONS IN MM TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 0.02-0.5	ALL THREADS TO CONFORM TO	ISSUE DATE	NATURE OF AMENDMENTS				
ALL THREADS TO CONFORM TO	ISSUE DATE	NATURE OF AMENDMENTS					
ISSUE DATE	NATURE OF AMENDMENTS						
NATURE OF AMENDMENTS							

MATERIAL: A.I.M-1 GOST 21631-76

USED ON \*\* SEE ABOVE

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVAC

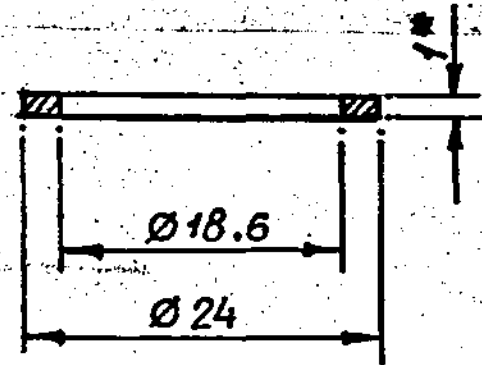
TITLE SEALING RING

D S CAT NUMBER

DRAWING NUMBER

20-55-066

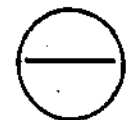
DRAWING NUMBER  
20-55-085



- 1 Alternate material is strip A A1M-1, GOST 13726-78.
- 2 Requirements placed upon stamping are as per standard 82050-16.
- 3 Minute dents and stamping tools traces are allowed, if they do not exceed 1/2 of the permissible deviations of dimensions.
- 4 \* Dimension is given for reference.

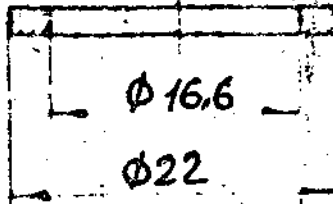
Ⓐ ALTERNATE MATERIAL : 19000 TO IS 737

PLOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION		DRN	<i>S. N. S.</i>	MATERIAL:- <b>AA1M-1</b>	USED ON	<b>CS 20-01-02-9</b>
EST. WT. <b>0.00128 kg.</b> TO BE STAMPED OR MARKED WHERE INDICATED THIS ≡ ( LETTERS)		CHD	<i>Ly.</i>	<b>GOST 21631-76</b>	<b>CS 20-27-00-4</b>	<b>CS 20-29-00-7</b>
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE		TEC	<i>Pravilnyy</i>	SCALE:- <b>2:1</b>	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES) AVAD!	
TITLE <b>SEALING RING</b>		APPD	<i>S.S.</i>	DIMENSIONS IN mm	D S CAT NUMBER	
A		DATE	<b>21-3-90</b>	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS:2102-69	DRAWING NUMBER	
A		ISSUE DATE	<b>9-6-09</b>	ALL THREADS TO CONFORM TO	<b>20-55-085</b>	
		NATURE OF AMENDMENTS	<b>3<sup>rd</sup> ALTN: COMM. MINUTES POINT 7 DATE 27-2-09</b>			



SIZE A3

20-55-116



- 1 Alternate material is strip АД 1М-1, GOST 13726-78.
- 2 Requirements placed upon stamping are as per standard 82050-16.
- 3 Minute dents and stamping tools traces are allowed, if they do not exceed 1/2 of the permissible deviations of dimensions.
- 4 \* Dimensions are given for reference.

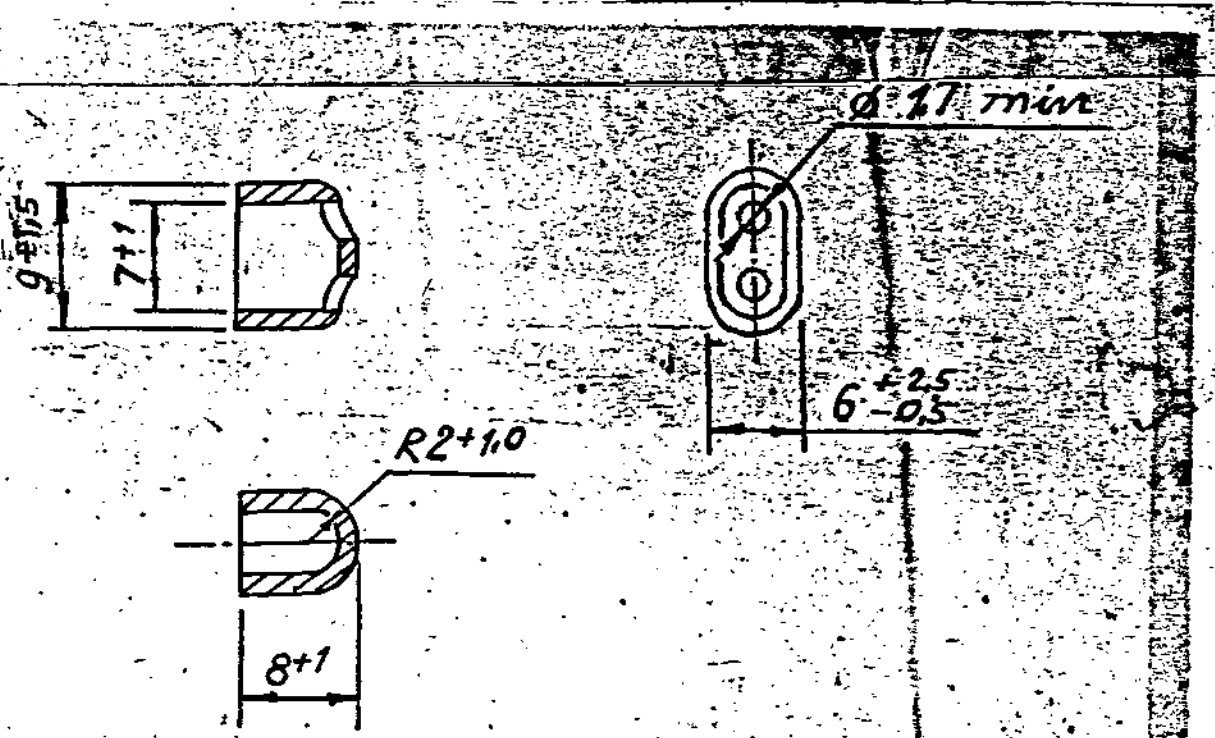
\* АД1М-1 GOST 21631-76

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

		FST. MASS 0.00084 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	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE :- 2 : 1	MATERIAL :- * SEE ABOVE
CHD		DIMENSIONS IN mm	USED ON :- CB 20-27-00-4
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	CONTROLLER OF INSPECTION (HEAVY VEHICLES) AVADI
APPD		ALL THREADS CONF. TO	TITLE :- SEALING RING
DATE	25-04-87		U S CAT NUMBER
			DRAWING NUMBER 20-55-116



DRAWING NUMBER  
315-141



**EXPLANATORY NOTE:**

**MATERIAL QUOTED:**

A A1 M-1 GOST 21631-76

A A1 = GRADE OF ALUMINIUM SHEET

M = ANNEALED

t = THICKNESS

**CHEMICAL COMPOSITION% (AS PER GOST 4784-74)**

BASIC CONSTITUENT ALUMINIUM = 99.50

**IMPURITIES (MAX)**

Fe = 0.30 ; Si = 0.30 ; Cu = 0.02 ;

Mn = 0.025 ; Zn = 0.1 ; TITANIUM = 0.1 ;

Mg = 0.05 ; TOTAL = 0.50 ; OTHER IMPURITIES INDIVIDUALLY = 0.02

**MECHANICAL PROPERTIES (AS PER GOST 21631-76)**

TENSILE STRENGTH  $\text{kgf/mm}^2$  (MIN) = 6.0

% ELONGATION (MIN) = 28

1. REQUIREMENTS PLACED UPON STAMPING ARE AS PER STANDARDS -RD 82050-16.
2. HOLES 1.7mm IN DIAMETER MAY HAVE BURRS.
3. ALTERNATE MATERIAL IS M2, GOST 859-78.

REVISION NOTE ADDED ON 26-10-91

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

EST. WT. 0.004 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.

DRN		MATERIAL - A A1 M-1	USED ON CB 20-01-00-8
CHD	<i>SV</i>	GOST 21631-76	CB 330-221-34
TCD	<i>W. K. L.</i>		CQA(HV) 5.06.001E (A)
APPD	<i>M.</i>		
DATE	4-4-86	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE	2:1	AVAOL	
DIMENSIONS IN mm		TITLE	SEAL
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69.			
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
A 18-03-15 Pl. 11 of 7th All. Comm. Meeting Dt. 11-4-12			315-141
ISSUE DATE NATURE OF AMENDMENTS			

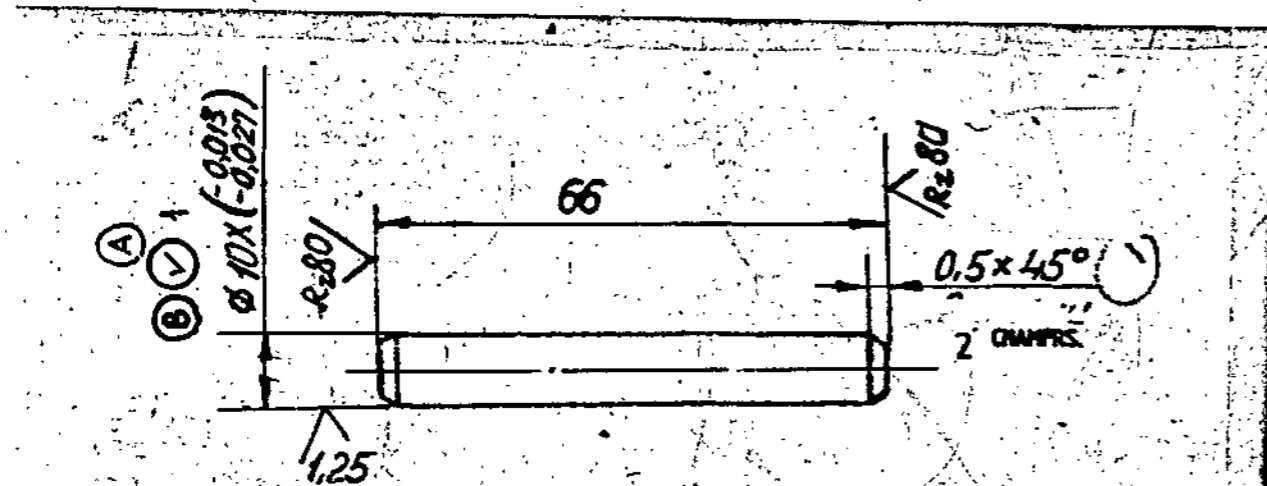


DRAWING NUMBER

315-618A

EXPLANATORY NOTE :

Rz40 ✓



6. MATERIAL QUOTED : 45X GOST 4543-71.

ALTERNATE MATERIAL QUOTED : 38XC GOST 4543-71.

CHEMICAL COMPOSITION :

GRADE OF STEEL	C O N T E N T O F E L E M E N T S %							
	C	Si	Mn	Cr	P	S	Cu	Ni
	M A X I M U M							
45X	0.41-0.49	0.17-0.37	0.50-0.80	0.80-1.10	0.035	0.035	0.30	0.30
38XC	0.34-0.42	1.00-1.40	0.30-0.60	1.30-1.60	0.035	0.035	0.30	0.30

1. INSPECTION GROUP III AS PER TECHNICAL REQUIREMENTS TT-11.

2. HRC ~~44 TO 52~~ HRC <sub>3</sub> 45 ..... 53

3. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS PER B7

4. COATING: CHEMICALLY OXIDIZED, OILED.

5. ALTERNATE MATERIAL IS 38XC GOST 4543-71.

MECHANICAL PROPERTIES :

GRADE OF STEEL	YIELD POINT Kg/mm <sup>2</sup> (min)	ULTIMATE TENSILE STRENGTH Kg/mm <sup>2</sup> (min)	RELATIVE ELONGATION % (min)	RELATIVE REDUCTION ALONG CROSS SECTION % (min)	IMPACT STRENGTH Kgfm/cm (min)
45X	85	105	9	45	5
38XC	75	95	12	50	7

7. REPAIR SIZE DIMENSIONS ARE ADDED BASED ON LETTER NO: 82847/OW/ QAS/ED DT: 27 MAR '85 AS FOLLOWS:

REPAIR SIZE DIMENSIONS ARE ADDED WHERE INDICATED THUS ✓

S/NO	R	REMARKS
1	0.015 0.027	ALL OTHER CONDITION AS PER STD DRG. MARK REPAIR SIZE

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

EST. WT. 0.04 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 INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

DRN: *[Signature]*  
 CHD: *[Signature]*  
 TCD: *[Signature]*  
 APPD: *[Signature]*  
 DATE: 25-04-87  
 MATERIAL:- STEEL 45X GOST 4543-71  
 USED ON: CB 327.00 45 CB 20-27-00-4

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVAD!

SCALE: - 1 : 1  
 DIMENSIONS IN mm - TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69

TITLE VARIABLE SPEED GOVERNOR LEVER AXLE

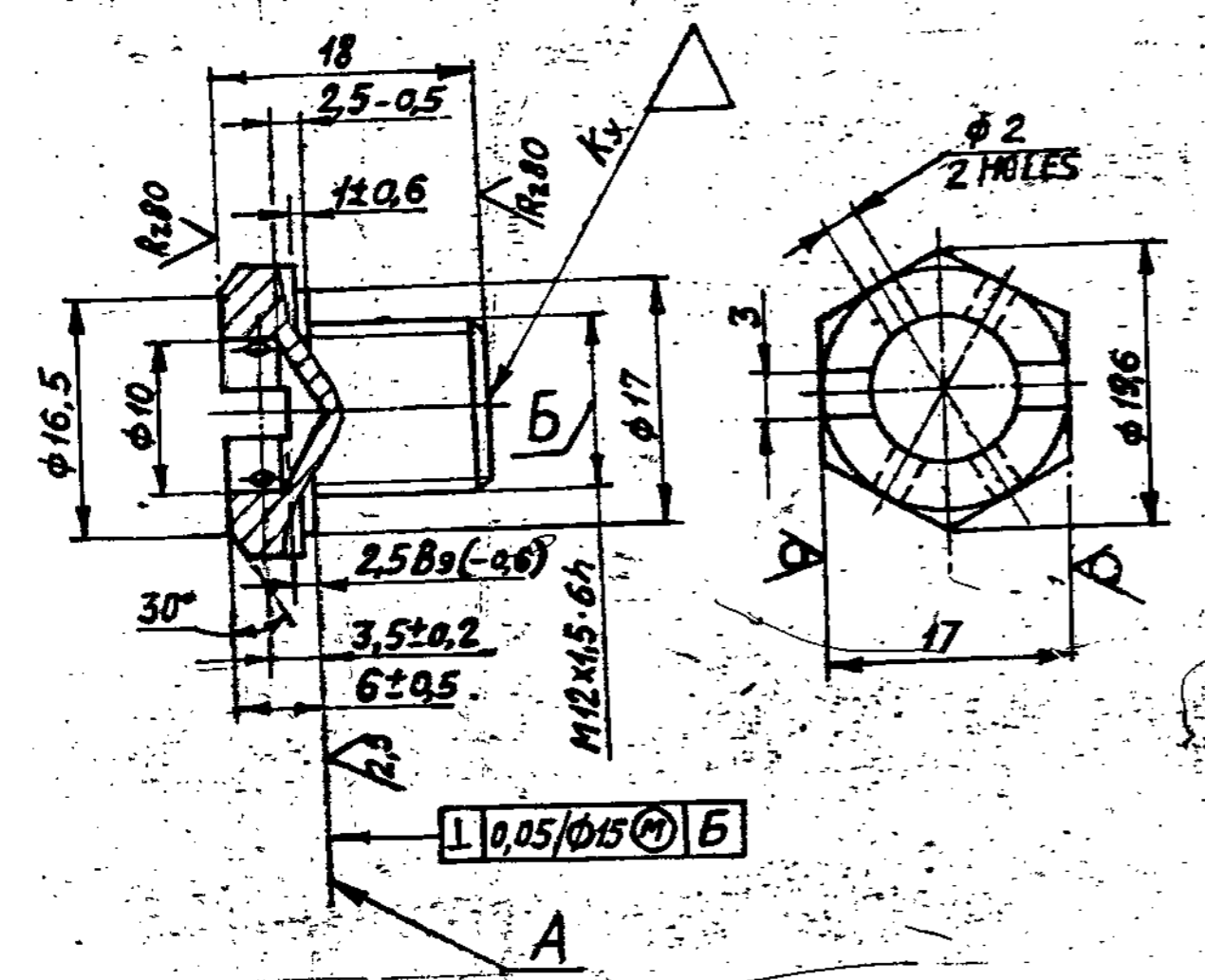
D S CAT NUMBER DRAWING NUMBER 315-618A

ISSUE DATE NATURE OF AMENDMENTS  
 B 20-5-95 REPAIR SIZES ADDED  
 A 20-6-87 AUTHY. B.K 82-394

DRG. INDIANISED BASED ON ISSUE-3

A-6  
 SIZE A3





1. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:-  
FOR HOLES - AS PER A7,  
SHAFTS - AS PER B7.
2. UNTHREADED SECTION OF PART SHOULD NOT EXCEED 3 MM.
3. THE HEXAHEDRON MAY BE MACHINED TO DIAMETER φ 19 MM.
4. WHILE CUTTING BUTT-END A THE SINGLE-POINTED TOOL MAY CUT CYLINDRICAL SURFACE UPTO 0.3 MM.
5. SLOT BASE OF R ≥ 35 IS ALLOWED.
6. COATING: CADMIUM -PLATED, 9 MICRONS THICK, OILED. IT IS PERMITTED NOT TO APPLY COATING ON INTERNAL SURFACES AND THREADS.
7. ALTERNATE MATERIAL IS STEEL GRADES 40, 50, GOST 1050-74

**EXPLANATORY NOTE :**

8. MATERIAL QUOTED : 17-5 GOST 8560-78  
45 GOST 1050-74  
BRIGHT STEEL OF HEXAGONAL CROSS - SECTION, 17mm A/F ACCURACY CLASS 5 TO GOST 8560-78 AND STEEL GRADE 45 TO GOST 1050-74.  
ALTERNATE MATERIAL QUOTED : GRADES 40 & 50 OF GOST 1050-74.

a) CHEMICAL COMPOSITION :

STEEL GRADE	CONTENT OF ELEMENTS - %							
	C	Si	Mn	Cr	S	P	Cu	Ni
40	0.37 - 0.45	0.17 - 0.37	0.50 - 0.80	0.25	0.040	0.035	0.25	0.25
45	0.42 - 0.50	0.17 - 0.37	0.50 - 0.80	0.25	0.040	0.035	0.25	0.25
50	0.47 - 0.55	0.17 - 0.37	0.50 - 0.80	0.25	0.040	0.035	0.25	0.25

b) MECHANICAL PROPERTIES :

STEEL GRADE	YIELD POINT Kgf/mm <sup>2</sup> (min)	ULTIMATE TENSILE STRENGTH Kgf/mm <sup>2</sup> (min)	PERCENTAGE ELONGATION % (min)	REDUCTION OF AREA % (min)	IMPACT STRENGTH Kgf/cm <sup>2</sup> (min)	HARDNESS B H N (without heat treatment) (min)
40	34	58	19	45	6	217
45	36	61	16	40	5	229
50	38	64	14	40	4	241

(A) EQUIVALENT MATERIAL  
STEEL 080M40(EN8) TO BS: 970 OR  
45 CB TO IS: 1570

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

EST. WT 0.015 Kg	TO BE CHECKED OR MARKED WHERE INDICATED BY THESE LETTERS
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MACHINED EDGES TO HAVE R. CUT-EDGE R. UNLESS OTHERWISE STATED. DIMENSIONS ARE PERMISSIBLE.	

DRN CHD TCD APPD DATE SCALE	<i>[Signature]</i> <i>[Signature]</i> <i>[Signature]</i> 07-05-87 2 : 1	MATERIAL :- 17.5 GOST 8560-78 45 GOST 1050-74	USED ON :- CQA (HV) 5.06.001E CB 20-27-00-4 CB 20-29-00-8
DIMENSIONS IN mm		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A D I	
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2002-88		TITLE <b>PLUG</b>	
B A	18-03-15 10-7-10	Pl. 11 of 17th All. Comm. Meeting Dt. 11-4-12 4 1/2 ALT. COMM. M.T. MINUTES POINT No 7 DT. 26-10-09	D S CAT NUMBER DRAWING NUMBER 315-648
ISSUE	DATE	NATURE OF AMENDMENTS	





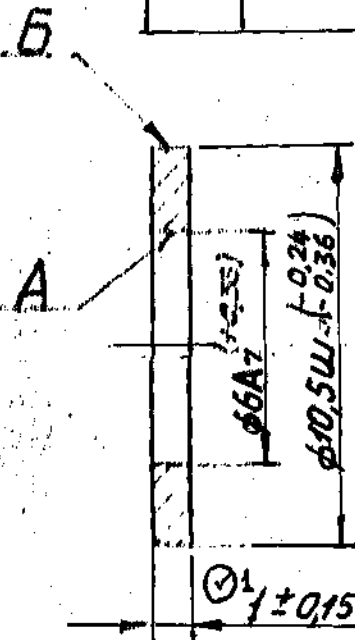






[The main body of the page contains several lines of text that are extremely faint and illegible due to the low resolution of the scan. The text appears to be organized into paragraphs, but no specific words or sentences can be discerned.]

Sl.No.	R <sub>1</sub>	R <sub>2</sub>	REMARKS.
① 1	±0.15 1.5	±0.15 2.0	1. ALL OTHER CONDITIONS AS PER STD. DRG. 2. MARK REPAIR SIZE.



4. REPAIR SIZE DIMENSION ADDED BASED ON LT.No. 82847/0H/QAS/ED DT 27 MAR 95 AS PER TABLE -1.  
REPAIR SIZE DIMENSION ADDED WHERE INDICATED THUS ①.

1. Радиальное отверстие отбортовки А должно быть сделано на поверхности и не более 0,4мм  
2. Детали должны соответствовать утверждённому стандарту.  
3. Остальные требования по ТУ 81-04-305 75.

1. RIM OUT OF HOLE 'A' RELATIVE TO THE AXIS OF SURFACE B SHOULD NOT EXCEED 0.4 MM.

2. THE COMPONENTS SHOULD BE IN COMPLIANCE WITH APPROVED STANDARD.

3. THE REST OF THE REQUIREMENTS IN ACCORDANCE

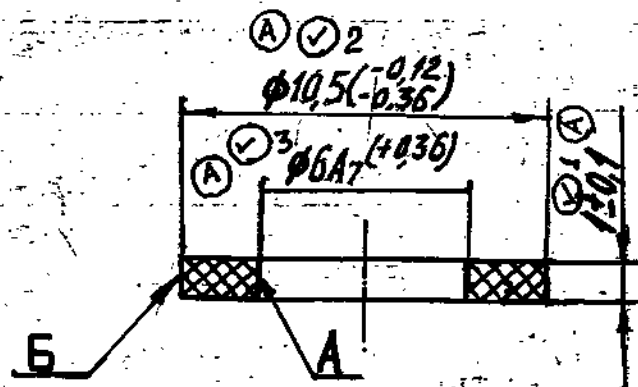
(A-B)

KVJ.No. 78275

		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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE - 5:1	MATERIAL:- FIBRE φ T1 USED ON:- CB 20-27-00-4 GOST 14613-69 CB 327-00-45 CB 3334-00-27
CHD		DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
TED		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE:- GASKET
APPO		ALL THREADS CONFORM TO	D S CAT NUMBER
DATE	02.5.86		DRAWING NUMBER 327 86



DRAWING NUMBER  
327-86A



1. Деталь термобработана по инструкции U-150-131/68.
2. Радиус выточки поверхности А относительно оси поверхности Б не более 0,4мм.
3. Принимать по эталону.
4. Картировать знак окончательной приемки и указать дату изготовления партии деталей на бирке.
5. Дополнительные технические требования и проверка по OCT 4.10.005.051.

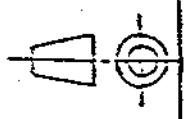
- 1) THE COMPONENT SHOULD BE HEAT - TREATED IN ACCORDANCE WITH INSTRUCTION U-150-131/68.
- 2) RUN - OUT OF SURFACE 'A' RELATIVE TO THE AXIS OF SURFACE 'B' SHOULD NOT EXCEED 0.4MM
- 3) TO BE ACCEPTED AS PER STANDARD.
- 4) FINAL ACCEPTANCE MARK AND DATE OF COMPONENT BATCH MANUFACTURING SHOULD BE MARKED ON TAG

5) OTHER TECHNICAL REQUIREMENTS AND ACCEPTANCE AS PER OCT 4.10.005.051

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

EST. WT. 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 OUT SIDE INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

DRN	G. Narayan	MATERIAL:- POLYAMIDE A6-210 / 311 OCT 6-06-69-76	USED ON CB 20-27-00-4
CHN			CB 327-00-45
TED	Narayan Date	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES) AVADI	
APPD			
DATE	15-02-88		
SCALE	- 5 : 1		
DIMENSIONS IN mm		TITLE  GASKET	
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS-2102-69			
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
A 15-9-85 REPAIR SIZE ADDED			327-86A
ISSUE DATE	NATURE OF AMENDMENTS		

### EXPLANATORY NOTE :-

6. MATERIAL QUOTED : POLYAMIDE A6 - 210/311 OCT 6-06-69-76.

A6 - 210/311 = GRADE OF POLYAMIDE.

1) APPEARANCE AND COLOUR: CRUMB (GRANULE) FROM WHITE TO LIGHT YELLOW COLOUR OR COLOURED SPOT INCLUSIONS OF OXIDE PARTICLES ARE ALLOWED NOT MORE THAN 18 FOR 100g OF POLYAMIDE.

2) SIZE OF CRUMB (GRANULE) IN mm.  
DIAMETER = 2.0 - 4.0  
LENGTH = 1.0 - 5.0

3) MOISTURE CONTENT % NOT MORE THAN = 0.2

4) RELATIVE VISCOSITY IN THE RANGES OF MINIMUM = 2.4

5) CONTENT OF EXTRACTABLE SUBSTANCES % NOT MORE THAN = 1.5

6) CONTENT OF UN-CHOPPED CRUMB (GRANULES) FOR A LENGTH UPTO 20mm, % NOT MORE THAN } = 0.5

7) MELTING TEMPERATURE °C NOT LESS THAN = 215

7. REPAIR SIZE DIMENSIONS ARE ADDED BASED ON LT. No. 82847/OH/QAS /ED DT 27 MAR 95 AS FOLLOWS.

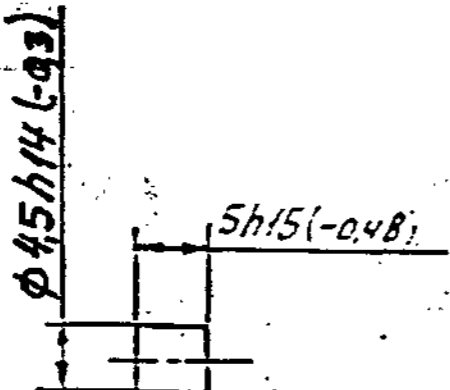
REPAIR SIZE DIMENSIONS ARE ADDED WHERE INDICATED THUS (A)

Sl.No.	R	REMARKS.
(A) 1	T = 1.5 <sup>+0.15</sup>	1. ALL OTHER CONDITIONS AS PER STD. DRG.
(A) 2	OD = 10.5 <sup>-0.24</sup> <sub>-0.36</sub>	
(A) 3	ID = 6 <sup>+0.38</sup>	2. MARK REPAIR SIZE.

KVD No: 70275



DRAWING NUMBER  
327-87-1



1. Заменители материала: А0 ГОСТ 11069-74,  
НВ 18...25 и С2 ГОСТ 3778-77.  
2. Допускается скругление одного  
торца.  
3. Допускается литейный уклон 2°

1. ALTERNATE MATERIAL - A0 GOST 11069-74 BHN(HB) 18.....25  
AND C2 GOST 3778-77.

2. IT IS ALLOWED TO ROUND OFF ONE FACE.

3. DRAFT 2° IS ALLOWED.

4. EXPLANATORY NOTE :-

MATERIAL QUOTED :-

LEAD TO GRADE C2 (OR) C3 GOST 3778-77 OR ALUMINIUM TO GRADE A0 GOST 11069-74

CHEMICAL COMPOSITION

	CONTENT OF ELEMENTS %	
	GRADE C3 GOST 3778-77	GRADE C2 GOST 3778-77
LEAD	99.9 (min)	99.95 (min)
COPPER	0.002 (max)	0.001 (max)
SILVER	0.0015 (max)	0.0015 (max)
ZINC	0.005 (max)	0.001 (max)
BISMUTH	0.06 (max)	0.03 (max)
ARSENIC	0.005 (max)	0.002 (max)
TIN	0.002 (max)	0.002 (max)
ANTIMONY	0.005 (max)	0.005 (max)
IRON	0.005 (max)	0.002 (max)

AS PER GRADE A0 GOST 11069-74 (%)

ALUMINIUM	= 99.0
IRON	= 0.50
SILICON	= 0.5
COPPER	= 0.02
ZINC	= 0.08
TIN	= 0.03
MANGANESE	= 0.01 (max)
MAGNESIUM	= 0.02 (max)
ARSENIC	= 0.015 (max)

KVD No 78492

KVD No 78492

DRN	S. Sanyal	MATERIAL:-	USED ON
CHD	Sharma	C3 GOST 3778-77	CB 20-2700-4
TCD	Amidate		CB 327-00-45
APPD		CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES)	
DATE	15 - 01 - 88	AVADI	
SCALE:-	2 : 1	TITLE	SEAL
DIMENSIONS IN mm			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS:2102-69			
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
ISSUE DATE			327-87-1
NATURE OF AMENDMENTS			

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

EST. WT. TO BE STAMPED OR MARKED WHERE INDICATED THUS # 1 LETTERS)  
0.0009 Kg.

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

A/8

SIZE A3



DRAWING NUMBER  
327-107-1

**EXPLANATORY NOTE :-**

4. MATERIAL QUOTED : STRIP 08nc-M-2-0-1 GOST 503-71.

COLD ROLLED LOW CARBON STEEL STRIP

M = SOFT  
2 = SECOND GROUP - SURFACE QUALITY.  
1 = THICKNESS  
08nc = MATERIAL GRADE AS PER GOST 1050-74.

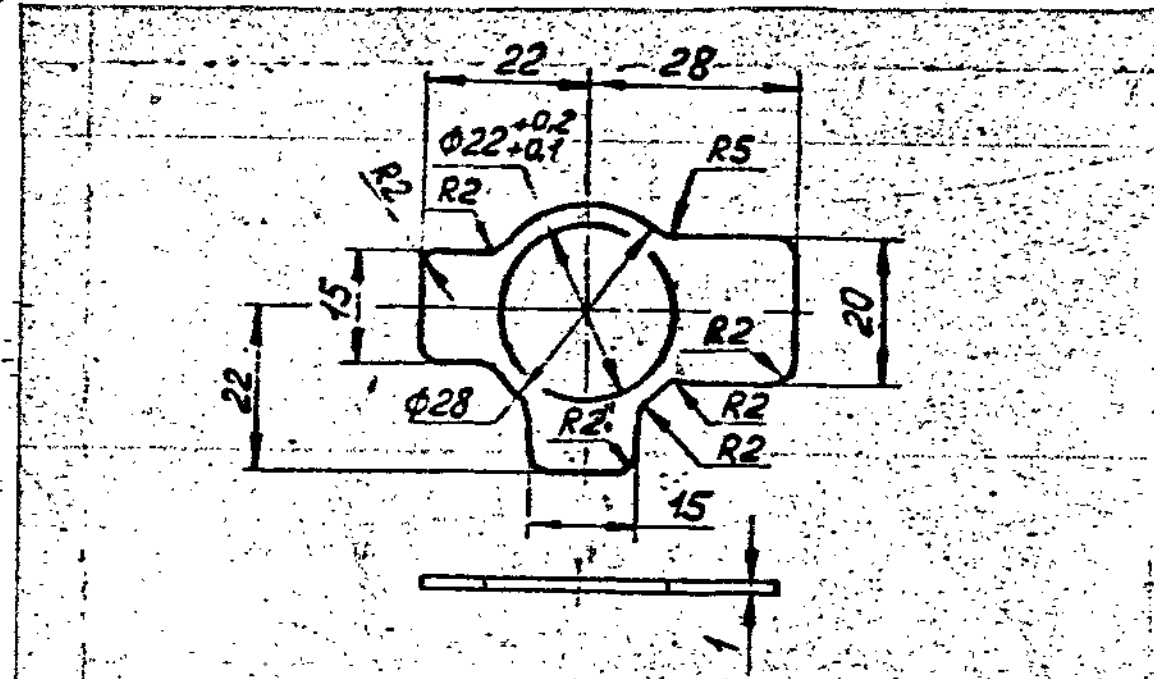
ALTERNATE MATERIAL QUOTED : 08 Kn GOST 1050-74.

a) CHEMICAL COMPOSITION :-

STEEL GRADE	CONTENT OF ELEMENTS %							
	C	Si	Mn	Cr	S	P	Cu	Ni
08nc	0.05-	0.05-	0.35-	0.10	0.040	0.035	0.25	0.25
	0.11	0.17	0.65					
08Kn	0.05-	0.03	0.25-	0.10	0.040	0.035	0.25	0.25
	0.11	max	0.50					

b) MECHANICAL PROPERTIES

STEEL GRADE	YIELD POINT Kgf/mm <sup>2</sup> (max)	ULTIMATE STRENGTH Kgf/mm <sup>2</sup> (max)	PERCENTAGE ELONGATION % (max)	REDUCTION OF AREA % (max)	B H N (max)
08nc	20	33	33	60	131
08Kn	20	33	33	60	131



- DIMENSIONS WITHOUT TOLERANCE SHOULD BE PROVIDED AS PER STANDARD 82050-16.
- COATING: <sup>CADMIUM</sup> CADMI-UM-PLATED, 9 MICRONS THICK, OILED, WITH REMOVAL OF HYDROGEN EMBRITTLEMENT.
- LOCK MAY BE MADE OF STEEL 08 Kn GOST 1050-74.

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

EST. WT. 0.003 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.

DRN	G. Nayak	MATERIAL:-	USED ON
CHKD	off	STRIP 08nc-M-2-0-1	CB 20-27-00-4
TCD	Navin	GOST 503-71	
APPD		CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES)	
DATE	24-04-87	AVADI	
SCALE:-	1 : 1		
DIMENSIONS IN mm		TITLE	PLATE TYPE LOCK
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS:2102-69			
ALL THREADS TO CONFORM TO		D S. CAT NUMBER	DRAWING NUMBER
			327-107-1
ISSUE DATE	NATURE OF AMENDMENTS		

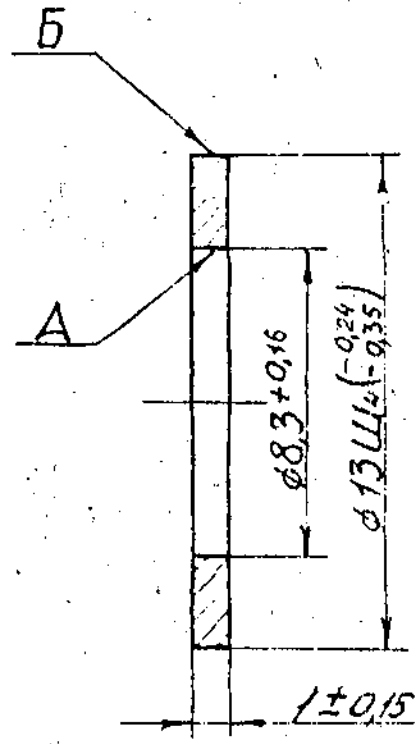


SIZE A3



327-126

ЕС.1Д



1. Радиальное бурение отверстия А относительно оси поверхности Б не более 0,4 мм.
2. Детали должны соответствовать утвержденному эталону.
3. Остальные требования по ТУ 81-04-395-75.

1. RUN-OUT OF HOLE A RELATIVE TO AXIS OF SURFACE B SHOULD NOT EXCEED 0.4 MM.
2. COMPONENTS SHOULD AGREE WITH APPROVED STANDARD.
3. THE REST OF THE REQUIREMENTS - IN ACCORDANCE WITH ТУ 81-04-395-75

(A) MATERIAL:- FIBRE Q T 1, 1<sup>st</sup> GRADE GOST 14613-83

		EST. MASS 0.0001 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS) (A-8)
A	15.2.88	AUTHY. NOTN. NO. BK 85-88	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.
ISSUE DATE	NATURE OF AMENDMENTS		MATERIAL:- FIBRE Q T 1 (A) USED ON: CB 327 10 52 SEE ABOVE GOST 14613-83 CB 327 00 45 CB 20-27-00-4
DRN	SCALE - 5 : 1		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
CHD	DIMENSIONS IN mm.		TITLE:- <b>GASKET (1.0 mm)</b>
TCD	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED		D S CAT NUMBER
APPD	ALL THREADS CONFORM TO		DRAWING NUMBER 327 126
DATE	08.15.88		

