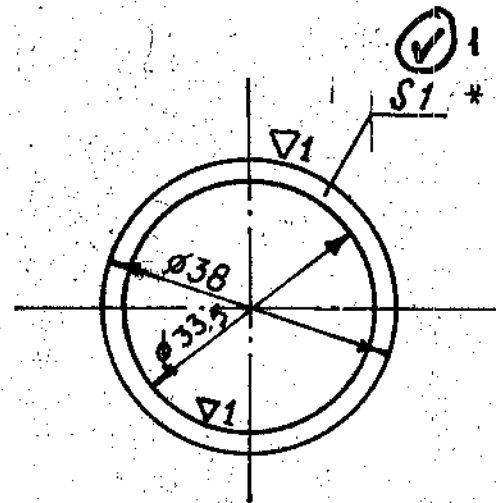


DRAWING NUMBER

310-21

2 (▽)



**EXPLANATORY NOTE**

5. REFERENCE MATERIAL QUOTED: ALUMINIUM ALLOY SHEET GRADE AA1, ANNEALED 'M', 1mm THICK, AND REFERENCE NOTE 'B' ON ALTERNATE MATERIAL ALUMINIUM ALLOY GRADE AA0, ANNEALED 'M', 1mm THICK, MANUFACTURED IN ACCORDANCE WITH ALUMINIUM ALLOY TO GOST 4784-74.

a) CHEMICAL COMPOSITION AS PER GOST 4784-74

GRADE OF ALLOY	ALLOYING CONSTITUENTS %	IMPURITIES MAXIMUM							OTHER IMPURITIES EACH INDIVIDUALLY
		Fe	Si	Cu	Mn	Zn	Ti	Mg	
AA1	99.3 MIN	0.30	0.30	0.05	0.025	0.1	0.1	0.05	0.02
AA0	99.5 MIN	0.30	0.30	0.02	0.025	0.1	0.1	0.05	0.02

b) MECHANICAL PROPERTIES UNDER ANNEALED CONDITION AS PER GOST 21631-76.

GRADE OF ALLOY	TENSILE STRENGTH Kgf/mm <sup>2</sup>	ELONGATION %
AA1 AA0	6.0	28

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

1. REQUIREMENTS FOR STAMPED COMPONENT SHOULD BE AS PER STANDARD 82050-16.
2. TO BE ANNEALED AFTER STAMPING.
3. \* DIMENSION FOR REFERENCE.
4. ALTERNATE MATERIAL: SHEET 1 AA0M GOST 21631-76

6. REPAIR SIZE DIMENSIONS ARE ADDED, BASED ON LETTER NO: 82847/0H/QAS/ED DT. 21 MAR 85 WHERE INDICATED THUS (✓) AS FOLLOWS

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

EST WT 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	CHD	TCD	APPD	DATE	SCALE	DIMENSIONS IN mm TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	MATERIAL SHEET 1 AA1M GOST-21631-76	USED ON Cb 310-30A Cb
				04-4-86	1:1		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
							TITLE GASKET	
							D S CAT NUMBER	DRAWING NUMBER 310-21
ISSUE	DATE	NATURE OF AMENDMENTS						

45

SIZE A3

RZ80/11

1. ALTERNATE MATERIAL IS STEEL 10 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. TOLERANCE ON NON-PARALLELITY OF PLANES A SHOULD BE 0.1mm.
4. TOTAL TOLERANCE ON ALIGNMENT AND INTERSECTION OF AXIS OF SURFACE I WITH RESPECT TO AXIS OF PLANES A SHOULD BE R0.3mm OVER THE LENGTH OF THE CYLINDRICAL PORTION.
5. WALL THICKNESS DIFFERENCE B IS 0.1mm, max.
6. THICKNESS OF WALL B MAY BE 1.6mm, MINIMUM.
7. COATING : ZINC-PLATED 9 MICRONS THICK, OILED.
8. USED FOR TROPICAL VERSION IS COATING : CADMIUM PLATED, 9 MICRONS THICK, OILED WITH REMOVAL OF HYDROGEN EMBRITTLEMENT.
9. INTERNAL SURFACES MAY HAVE NO COATING.

**EXPLANATORY NOTE :-**

MATERIAL QUOTED : 35 GOST 1050-74.

Alt Matl Quoted : 10 GOST 1050-74.

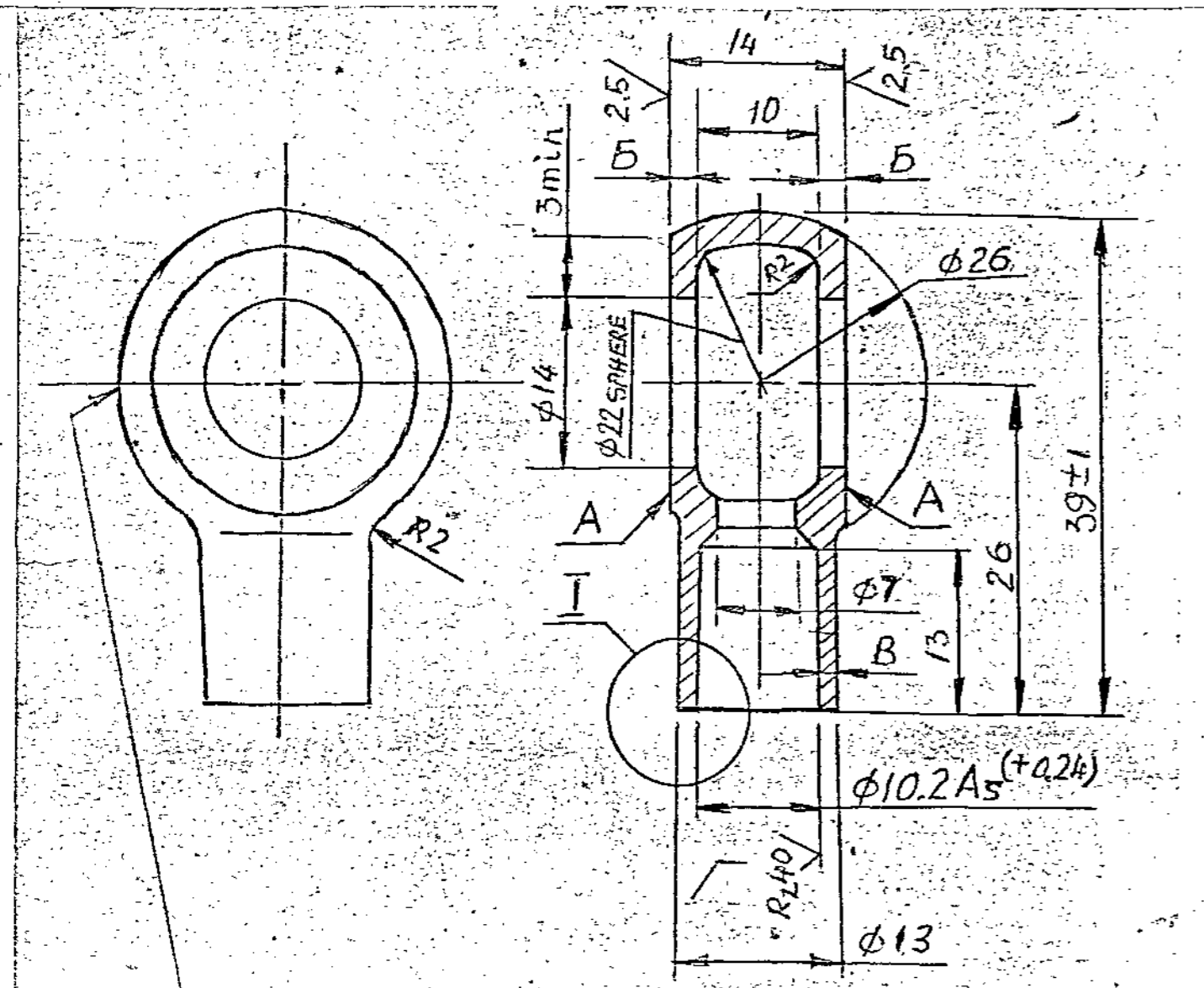
10, 35 = GRADE OF STEEL.

a) CHEMICAL COMPOSITION : %

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C	Si	Mn	Cr	S	P	Cu	Ni
10	0.07-0.14	0.17-0.37	0.35-0.65	0.15	0.040	0.035	0.25	0.25
35	0.32-0.40	0.17-0.37	0.50-0.80	0.25	0.040	0.035	0.25	0.25

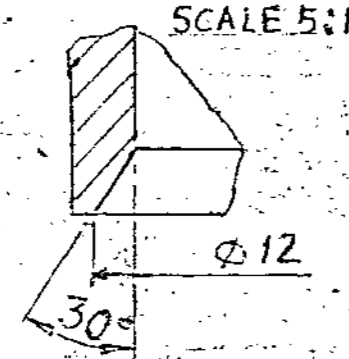
b) MECHANICAL PROPERTIES :

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm <sup>2</sup> ( min )	YIELD POINT Kgf/mm <sup>2</sup> ( min )	% ELONGATION ( min )	REDUCTION OF AREA % (min)	IMPACT STRENGTH Kgf/cm <sup>2</sup> ( min )
10	34	21	31	55	-
35	54	32	20	45	7



ROUGH (✓) CYLINDRICAL SURFACE FROM BOTH SIDES, 4MM MAXIMUM, IN WIDTH IS PERMITTED

I ALTERNATE SCALE 5:1



CB 310-00-7  
 CB 310-32  
 CB 20-22-00-7  
 CB 20-22-12-1

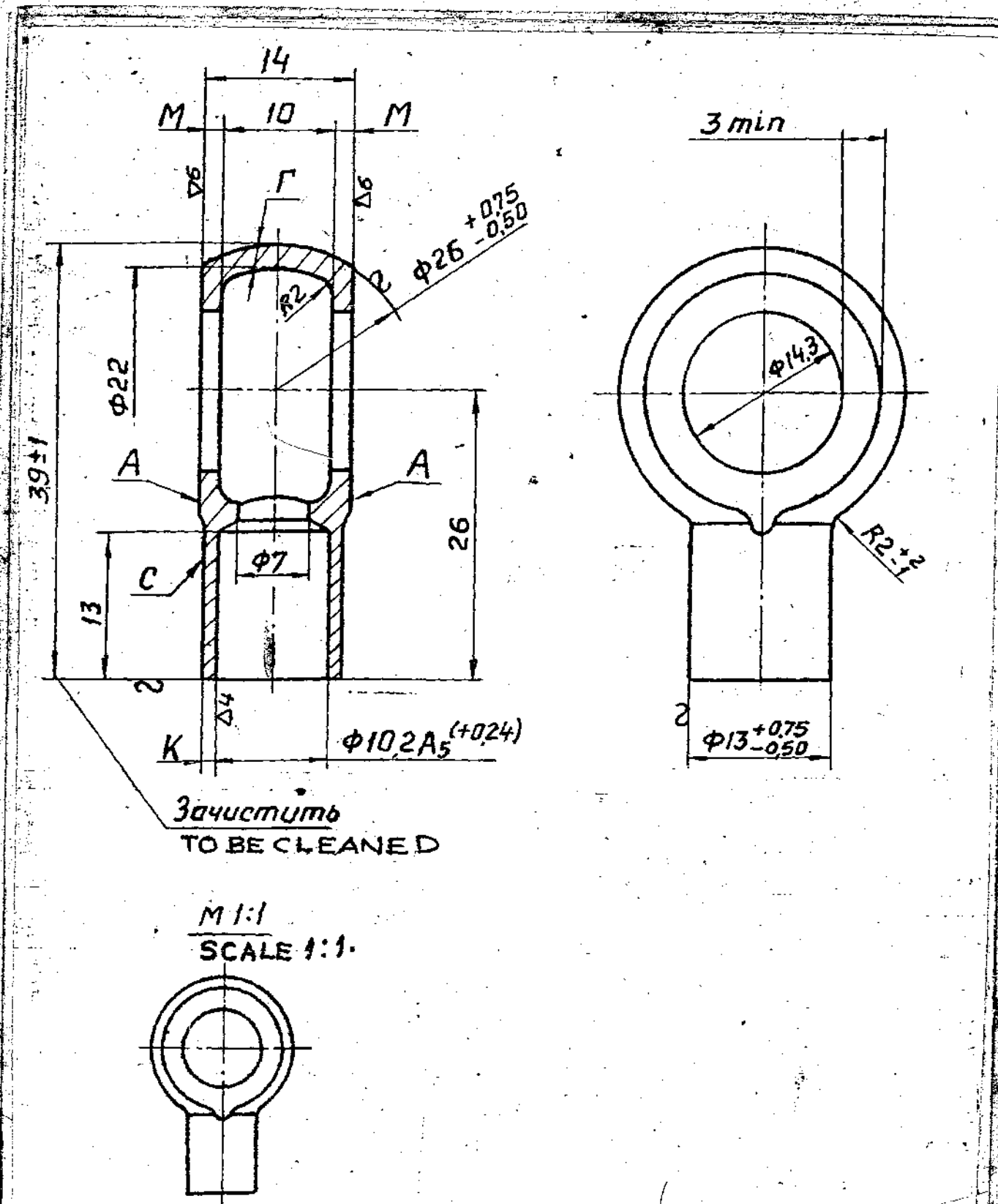
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. WT. 0.027 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 OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	TCO	APPD	DATE	SCALE	DIMENSIONS	TOLERANCE	ISSUE	DATE	NATURE OF AMENDMENTS	
				22-12-89	2:1	IN mm	UNLESS OTHERWISE STATED IS 2102-69				
MATERIAL :- 35 GOST 1050-74								USED ON :- ** SEE ABOVE			
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)								A V A D I			
TITLE								DRAWING NUMBER			
SWIVEL ELBOW								310-25			
D S CAT NUMBER											

DRAWING NUMBER  
310 25A

▽3(▽)



2. REQUIREMENTS FOR THE STAMPED COMPONENTS SHOULD BE IN ACCORDANCE WITH GOST 7605-74.
5. COATING: cd 9, CHROMATIZING AS PER ИЦА-104,
6. INNER SURFACE MAY NOT BE COATED.
7. UNSPECIFIED TOLERANCES FOR THE DIMENSIONS OF THE COMPONENTS:  
FEMALE-AS PER A7, MALE-AS PER B7 AND OTHER  $\pm 1/2$  OF THE TOLERANCES.
8. NON PARALLELISM OF SURFACES A SHOULD NOT EXCEED 0.1mm
9. WALL THICKNESS:  
K - 1mm MINIMUM  
Г - 1.5mm MINIMUM  
M - 1.6mm MINIMUM
10. SURFACE C SHOULD NOT PROJECT BEYOND SURFACE A
11. ALTERNATE MATERIAL: STEEL GRADE 10 GOST 1050-74

**EXPLANATORY NOTE:**

12. REFERENCE MATERIAL QUOTED:

HOT ROLLED CARBON STRUCTURAL FORGED STEEL GRADE 35, REFERENCE NOTE 11, ON ALTERNATE MATERIAL GRADE 10 TO GOST 1050-74.

a) CHEMICAL COMPOSITION:

GRADE OF STEEL	CONTENT OF ELEMENTS %						REMARKS
	C	Si	Mn	Cr	S	P	
35	0.32-- 0.40	0.17 - 0.37	0.50 - 0.80	0.25	0.040	0.035	Ref.Matl.
10	0.07 - 0.14	0.17 - 0.37	0.35 - 0.65	0.15	0.040	0.035	Alt.Matl.

b) MECHANICAL PROPERTIES UNDER NORMALISED CONDITION:

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kg/mm <sup>2</sup>	YIELD POINT Kg/mm <sup>2</sup>	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH Kgfm/cm <sup>2</sup>	HARDNESS B H N M A X	REMARKS
35	54	32	20	45	7	207	Ref.Matl.
10	34	21	31	55	-	143	Alt.Matl.

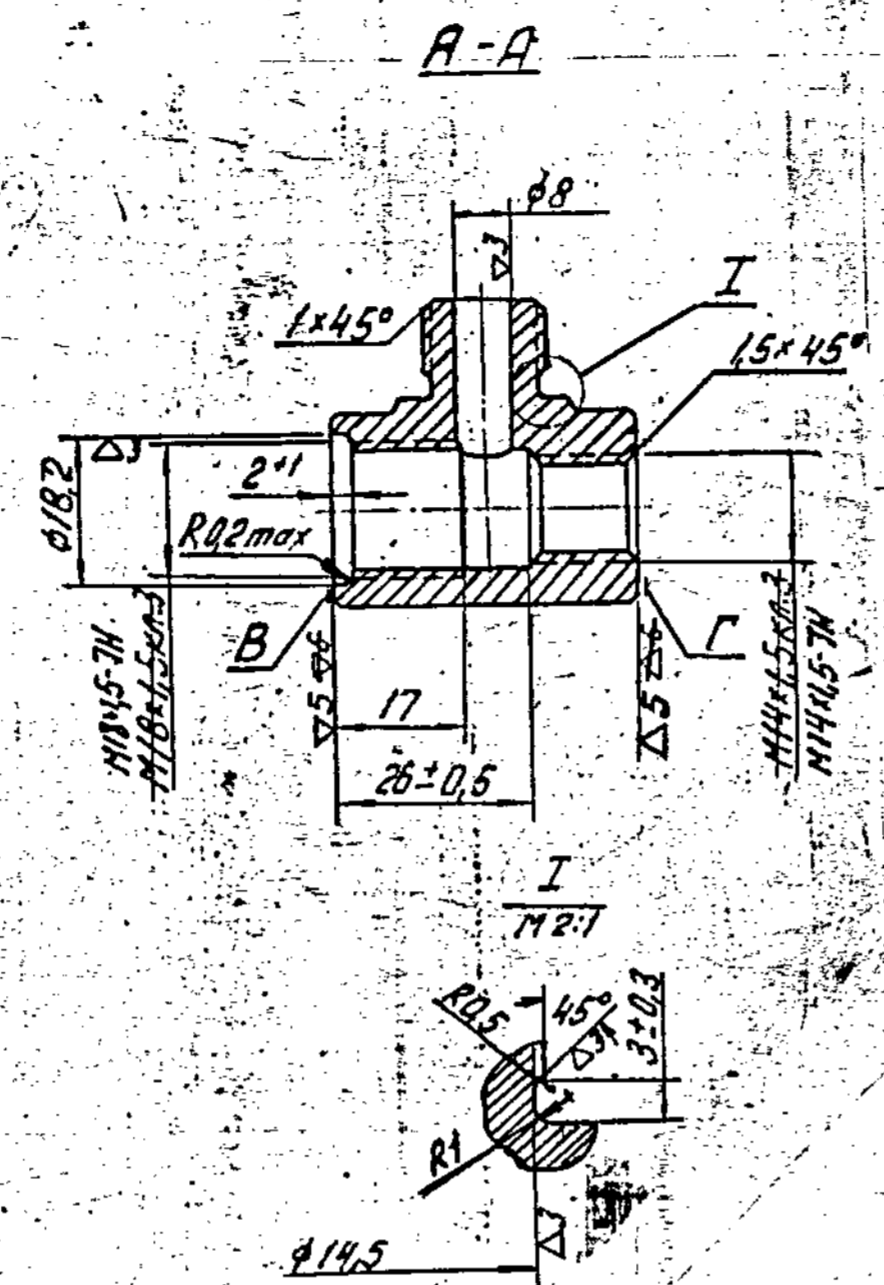
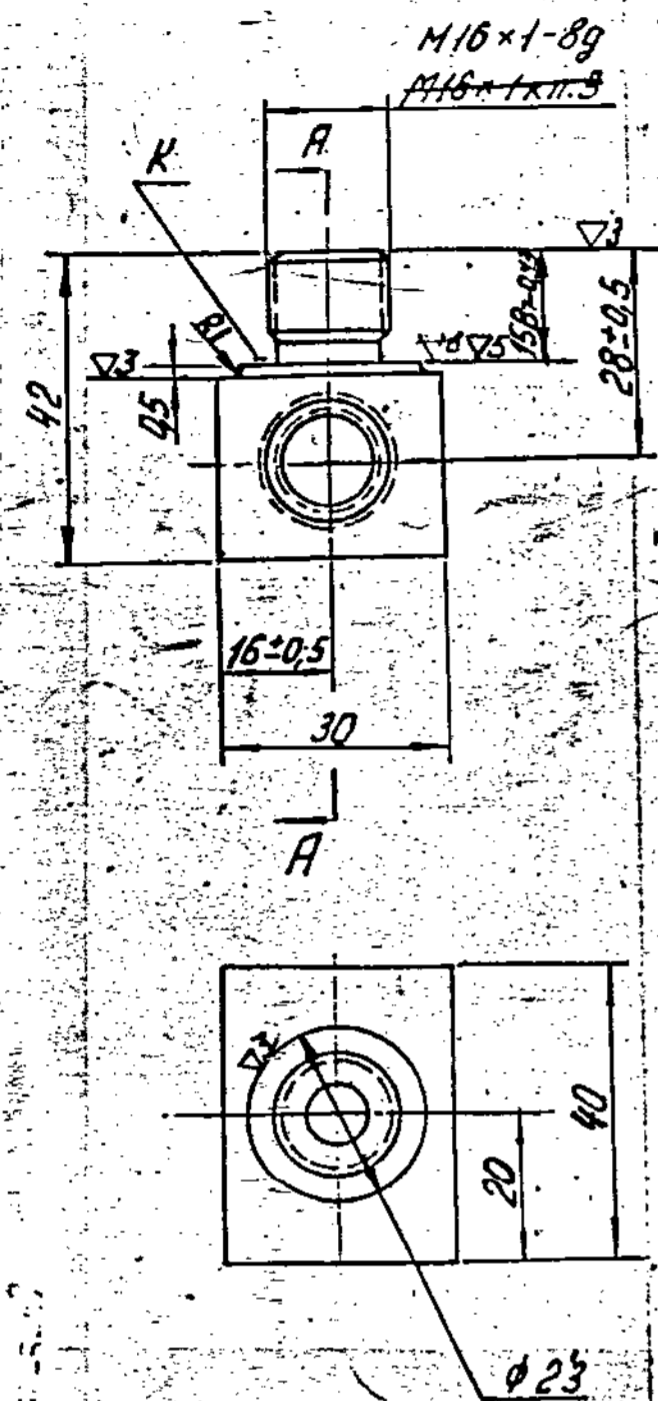
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

EST WT 0.02 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	

DRM	leg	MATERIAL: STEEL 35,	USED ON:
CHD	Равно	GOST 1050-74, STAMPING	CB 310 32/1
TCD	Норм. пуд.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES AVADI)	
APPD	Равно		
DATE	04-4-86		
SCALE: 2 : 1		TITLE: SWIVEL ELBOW	
DIMENSIONS IN mm			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED		D S CAT NUMBER	
ALL THREADS TO CONFORM TO		DRAWING NUMBER 310 25A	
ISSUE	DATE	NATURE OF AMENDMENTS	

(A-5)  
SIZE A2

DRAWING NUMBER  
310-3.4



**EXPLANATORY NOTE:-**

MATERIAL QUOTED: STRIP 30x45 GOST 103-76  
45 GOST 1050-74

30 = THICKNESS  
45 = WIDTH  
45 = GRADE OF MATERIAL

**CHEMICAL COMPOSITION %**  
 CARBON = 0.42-0.50  
 SILICON = 0.17-0.37  
 MANGANESE = 0.50-0.80  
 CHROMIUM = 0.25  
 PHOSPHORUS = 0.040  
 SULPHUR = 0.035  
 COPPER = 0.25  
 NICKEL = 0.25  
 } MAXIMUM

**MECHANICAL PROPERTIES:**  
 ULTIMATE TENSILE STRENGTH  $\text{kgf/mm}^2 = 61$  (MIN)  
 YIELD POINT  $\text{kgf/mm}^2 = 36$  (MIN)  
 ELONGATION = 16 (MIN)  
 REDUCTION IN AREA % = 40 (MIN)  
 IMPACT STRENGTH  $\text{kgm/cm}^2 = 5$  (MIN)

2. DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE ACCORDING TO ACCURACY CLASS 7 OST 1010.
3. TECHNICAL REQUIREMENTS FOR THE THREAD SHOULD BE IN ACCORDANCE WITH STANDARD 82021-00.
4. NON SQUARENESS OF SURFACES B, C AND K RELATIVE TO THE AXIS OF THE CORRESPONDING THREAD SHOULD NOT EXCEED 0.10mm.
5. SHARP EDGES SHOULD BE BLUNTED.
6. COATING SHOULD BE CHROMATIZING. TO BE COATED IN ASSEMBLY WITH SUBSEQUENT REMOVAL OF HYDROGEN BRIGHTNESS.
7. DIMENSIONS SHOULD BE CHECKED BEFORE COATING.
8. MAY BE MANUFACTURED BY PRECISION CASTING FROM STEEL 45A GOST 977-75.
9. ALTERNATE MATERIAL: STEEL 45 GOST 1050-74.

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

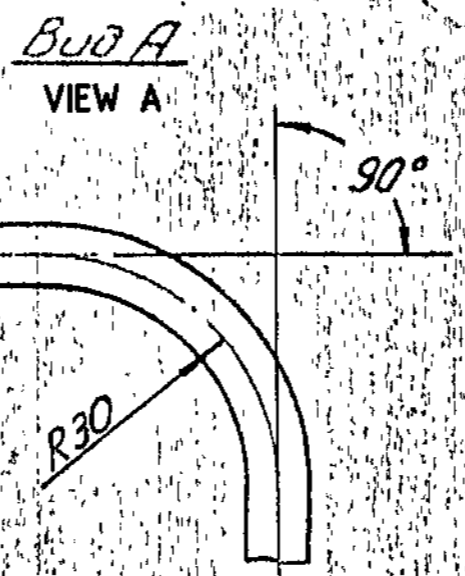
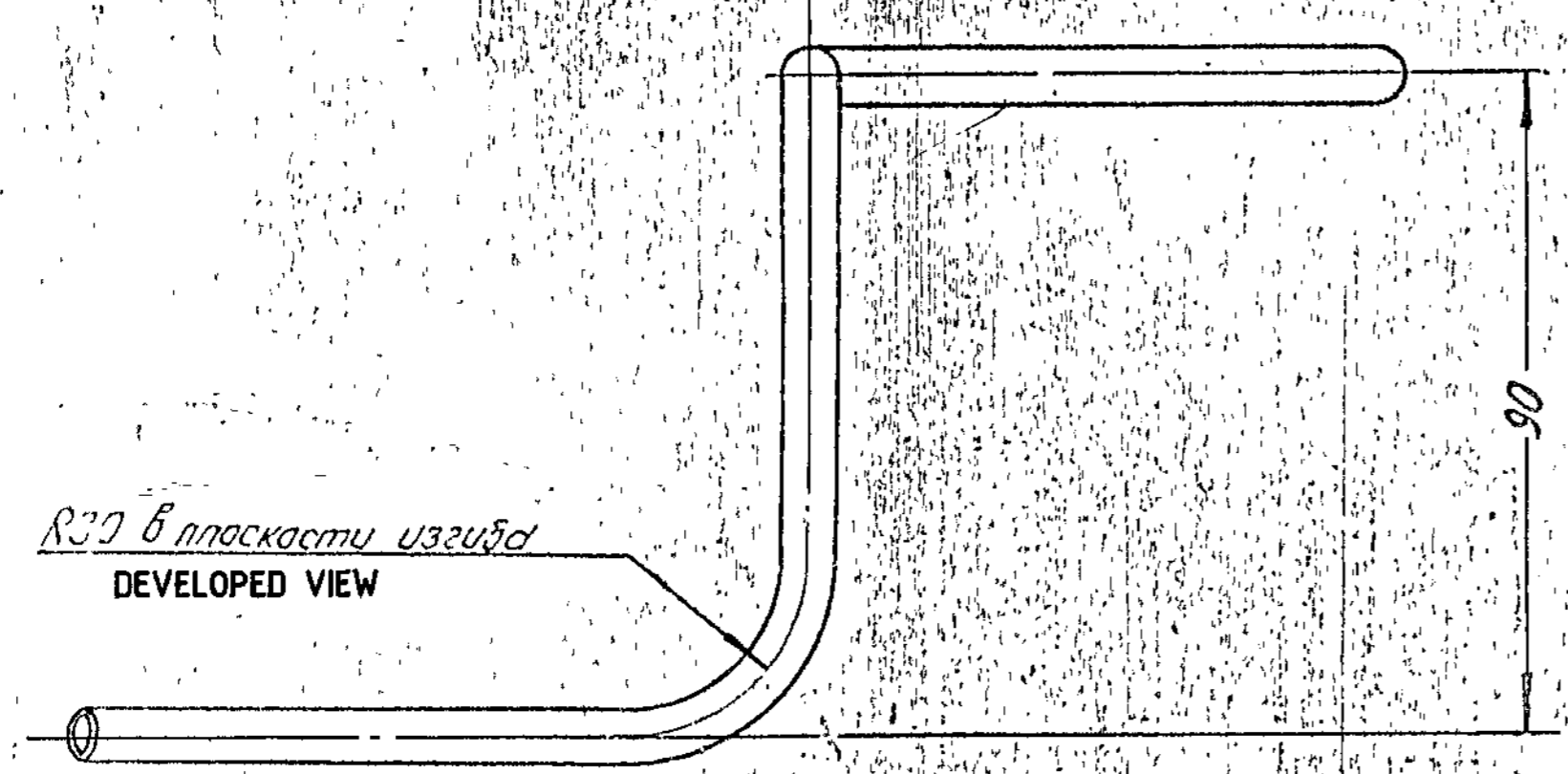
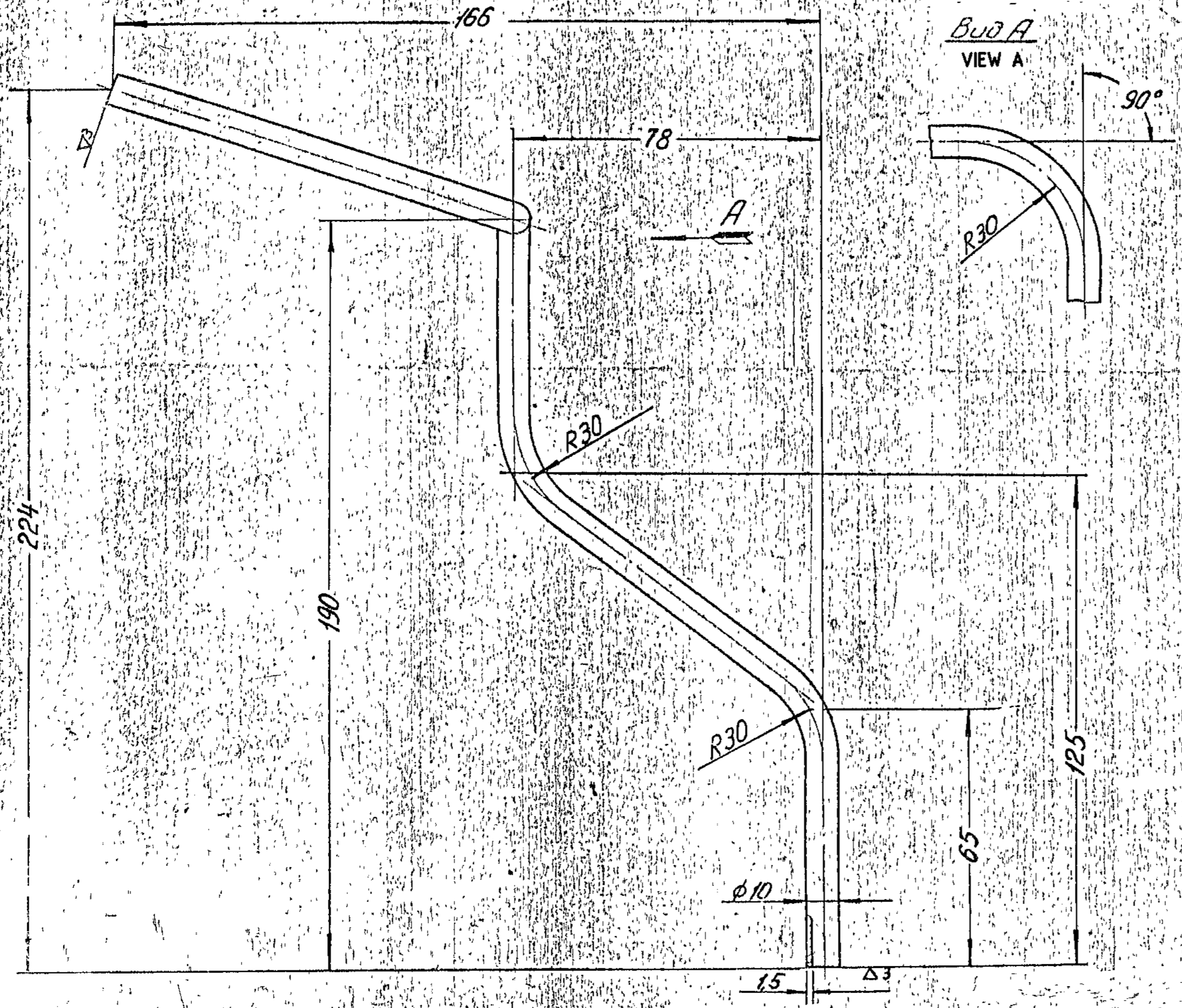
EST. WT. 0.230 kg. TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)

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	APPD	DATE	SCALE	DIMENSIONS IN mm.	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	ALL THREADS TO CONFORM TO
				17-2-88	1:1			
MATERIAL :- STRIP 30x45 GOST 103-76 45 GOST 1050-74					USED ON :- CS 310-33-2			
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)					A V A D I			
TITLE					BODY			
D'S CAT NUMBER					DRAWING NUMBER 310-34			
ISSUE	DATE	NATURE OF AMENDMENTS						

EXPLANATORY NOTE ADDED CNB-12-91



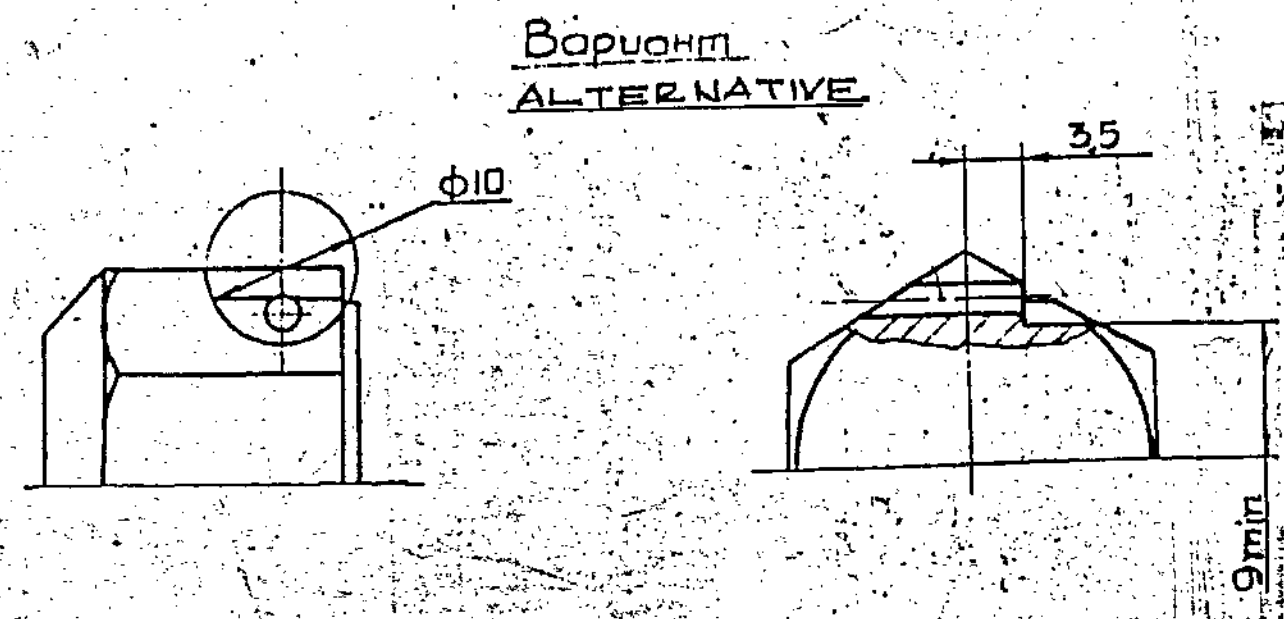
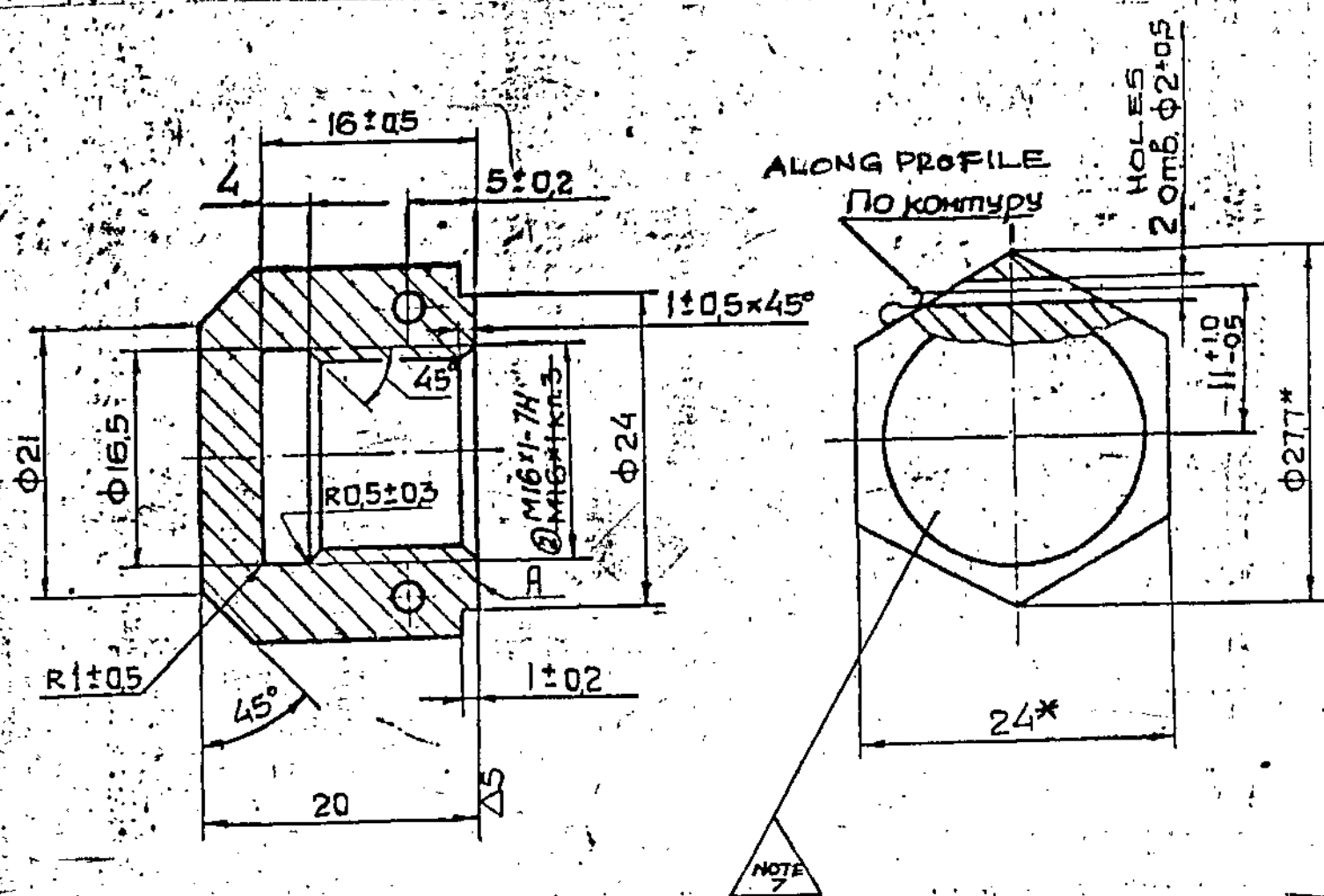


1. Группа контроля V-3
2. Ovalность трубы в местах изгиба в пределах 1,5мм.
3. Острые крошки затупить.
4. Развернутая длина  $L \approx 376$ мм.
5. Трубку принимать по макету в узле.
6. Залусены на торцах трубки, трещины, вмятины, забоины и другие дефекты не допускаются.
7. Допускается изготовлять из трубы 10x16 ГОСТ 8734-75
8. Технические требования на трубу по ГОСТ 8733-66.
9. Заменитель материала трубы: 10x16 ГОСТ 8734-75

2. OVALITY OF THE TUBE AT BENT PLACES SHOULD BE WITHIN 1.5mm.
3. SHARP EDGES SHOULD BLUNTED.
4. LENGTH OF DEVELOPED COMPONENT IS  $L \approx 376$ mm
5. TUBE ASSEMBLY SHOULD BE ACCEPTED AS PER THE PATTERN.
6. BURRS ON THE FACES OF THE TUBE, CRACKS, TOOL MARKS NICKS AND OTHER DEFECTS ARE NOT PERMISSIBLE
7. ALTERNATE MATERIAL: TUBE 10X16 GOST 8734-75

\* PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

		EST. MASS 0,125 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS IN LETTERS
		ALL SHARP EDGES AND CORNERS TO BE BLUNTED UNLESS OTHERWISE NOTED FACED CORNERS TO HAVE R OUTSIDE R IN:OR EQUIVALENT CHARACTERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL: 10X16 GOST 8734-75 USED ON: C6 310-32
DRAWN		SCALE: 1:1	TUBE: B-20, GOST 8733-76
CHKD		DIMENSIONS IN mm	CONTROL POINT OF QUALITY ASSURANCE (HEAVY WEIGHTS) A V A U I
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE TUBE
APPROVED			
DATE: 7-2-87		ALL THREADS TO CONFORM TO	D.S. CAT NUMBER DRAWING NUMBER 310-36



2. TECHNICAL REQUIREMENTS FOR THE THREAD SHOULD BE AS PER STANDARD 82021-00.
3. UNSPECIFIED TOLERANCES FOR THE DIMENSIONS OF COMPONENTS: FEMALE-AS PER A7, MALE-AS PER B7 AND OTHER - AS PER CMB
4. FACE OUT OF SURFACE A RELATIVE TO THE PITCH DIAMETER OF THE THREAD SHOULD NOT EXCEED 0.1mm.
5. COATING: Zn 3; CHROMATIZING AS PER IJT - 483-82.
6. INTERNAL SURFACES MAY NOT BE COATED.
7. TO BE MARKED BY PUNCHING.
8. DIMENSIONS FOR REFERENCE.
9. IN TROPICALIZED MAKE THE COATING IS Cd, Cr AS PER U.S. 569-84 WITH SUBSEQUENT REMOVAL OF HYDROGEN EMBRITTLEMENT.

**EXPLANATORY NOTE:-**

MATERIAL QUOTED: HEX. BAR 24-4 GOST 8560-78  
 45 GOST 1051-73  
 BRIGHT STEEL HEX. BAR ACROSS FLATS 24 mm.  
 CLASS OF ACCURACY 4  
 45 - GRADE OF MATERIAL

CHEMICAL COMPOSITION % (AS PER GOST 1050-74)

CARBON	= 0.42-0.50	} MAXIMUM
SILICON	= 0.17-0.37	
MANGANESE	= 0.50-0.80	
SULPHUR	= 0.035	
PHOSPHORUS	= 0.040	
CHROMIUM	= 0.25	
NICKEL	= 0.25	
COPPER	= 0.25	} MINIMUM

MECHANICAL PROPERTIES: (AS PER GOST 1050-74)

TENSILE STRENGTH	Kgf/mm <sup>2</sup> = 61	} MINIMUM
YIELD POINT	Kgf/mm <sup>2</sup> = 36	
ELONGATION %	= 16	
REDUCTION IN AREA %	= 40	
IMPACT STRENGTH	Kgf.m/cm <sup>2</sup> = 5	

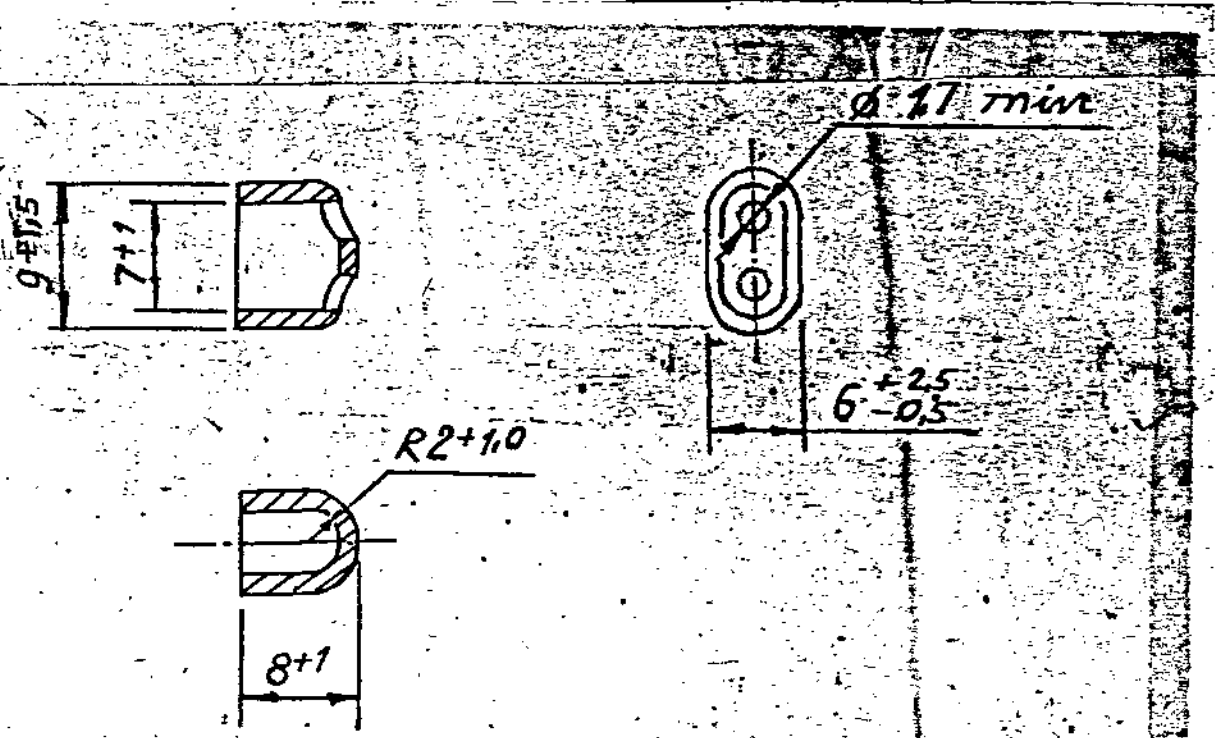
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. WT. 0.032 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. OUT - SIDE R. INSIDE. EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

DRN	CHD	TCD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL - HEX. BAR 24-4 GOST 8560-78 45 GOST 1051-74	USED ON CS 310-00-7	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A D I	TITLE: CAP NUT	D S CAT NUMBER	DRAWING NUMBER 310-37
				17-2-88	2:1			25.12.96	AUTHY Notn No. BK 86-41						

EXPLANATORY NOTE ADDED ON 21-1-92

DRAWING NUMBER  
315-141



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

**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

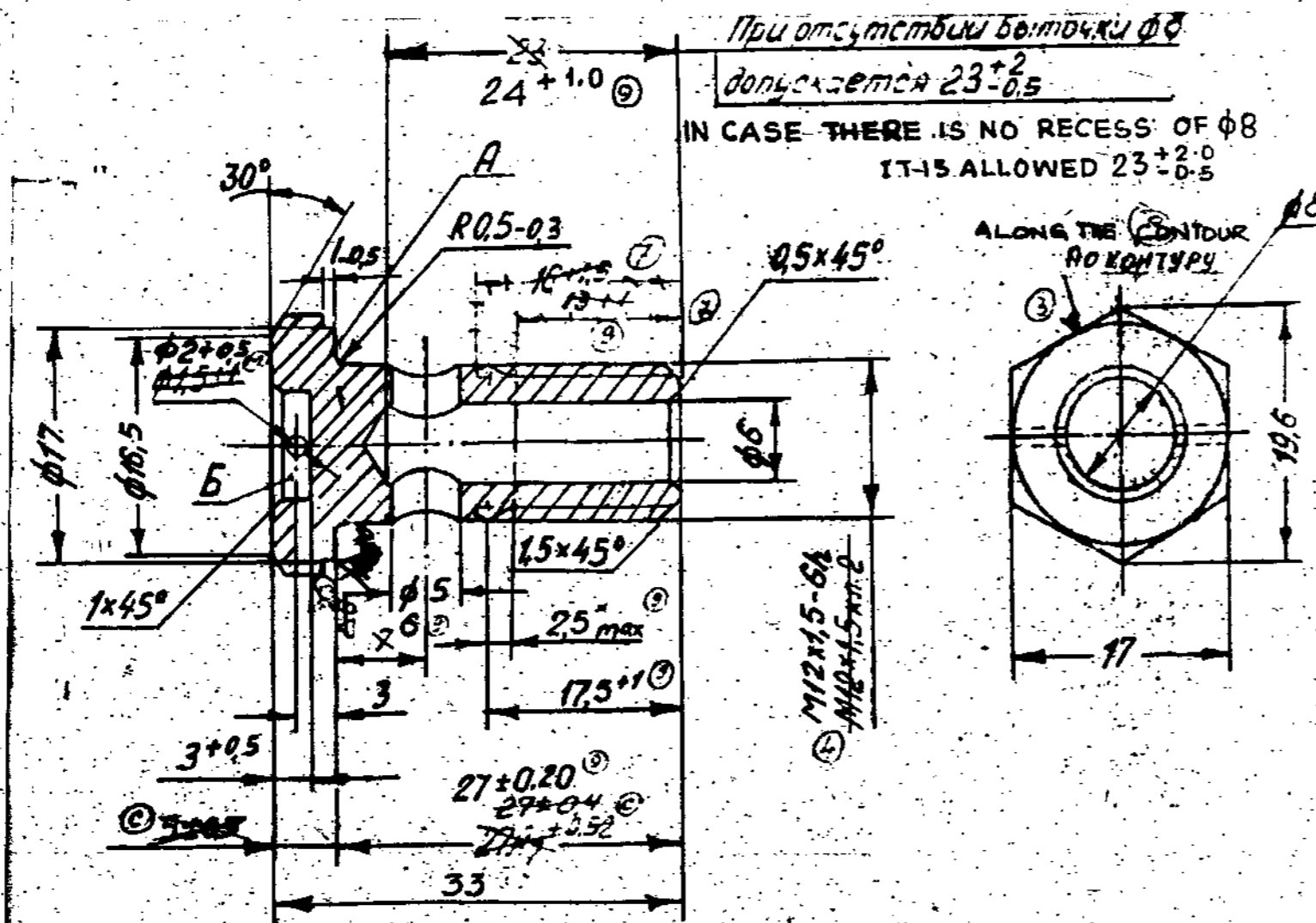
REVISIONS NOTE ADDED ON 26-10-91

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)

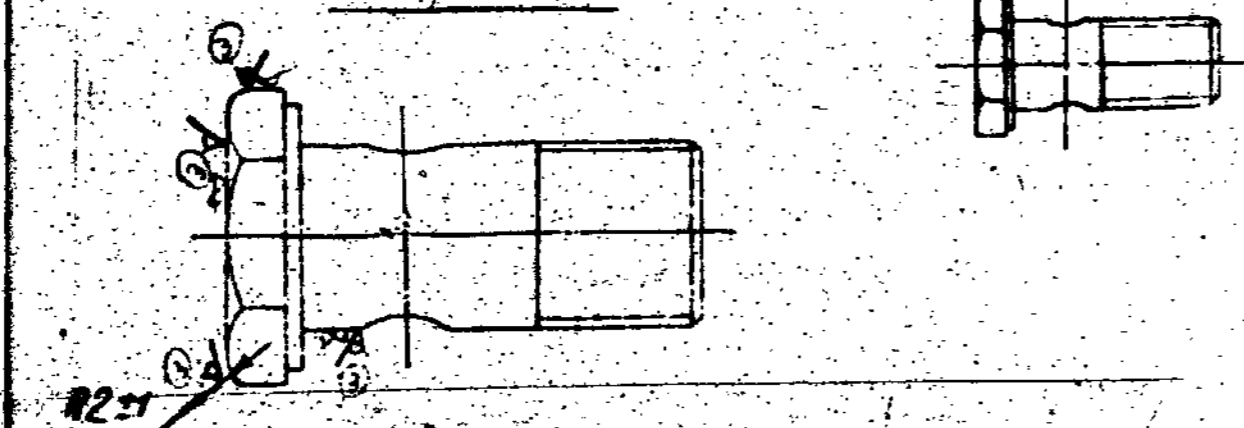
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN		MATERIAL - A A1 M-1	USED ON
CHD	<i>Sh</i>	GOST 21631-76	C6 330-221-3A
TEC	<i>W. K. L.</i>		
APPD	<i>M.</i>		
DATE	4-4-86	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.	
SCALE	2:1		
DIMENSIONS IN mm			TITLE
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69.			SEAL
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
			315-141
ISSUE	DATE	NATURE OF AMENDMENTS	



ALTERNATIVE  
Вариант А

M1:1  
SCALE 1:1



1. DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE MAINTAINED AS PER ACCURACY CLASS 7 OST 1010.
2. TECHNICAL REQUIREMENTS FOR THREAD AS PER STANDARD 82021-00.
3. NON-SQUARENESS OF FACE SURFACE 'A' AT DIMENSION  $\phi 17$ , RELATIVE TO THE AXIS OF THREAD SHOULD NOT EXCEED 0.1mm, MEASURED WITHIN OVERALL DIMENSIONS OF COMPONENT
4. SHIFT OF HEAD AXIS RELATIVE TO THE AXIS OF THREAD SHOULD NOT EXCEED 0.5 mm. RECESS 'B' IS OPTIONAL. 'C' WHILE 'FACING SURFACE 'A'', CUTTING-IN AND SHOULDER UP TO 0.3 mm, ARE PERMISSIBLE ON CYLINDRICAL SURFACE.
5. SHARP EDGES SHOULD BE BLUNTED.
6. DIMENSIONS SHOULD BE CHECKED BEFORE COATING.
7. COATING: Cd 9, CHROMATIZING AS PER U4, A -104 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT. THERE MAY BE NO COATING ON INNER SURFACES.
8. THE COMPONENT MAY MANUFACTURED BY HEADING FROM ROUND BAR 12.5 GOST 7417-75 AS PER ALTERNATIVE 'A'.
9. HEXAGON FACETS MAY BE TURNED TO  $\phi 19$  B.-0.52.
10. ALTERNATE MATERIAL : STEEL, GRADES 40 AND 50, GOST 1050-74.

**EXPLANATORY NOTE :**

12. REFERENCE MATERIAL QUOTED :  
GAUGED HEXAGONAL STEEL BAR 17mm A/F CLASS OF ACCURACY 5 (-0.34) TO GOST 8560-78, HIGH GRADE SIZED STEEL TO GOST 1051-73 AND MANUFACTURED IN ACCORDANCE WITH QUALITY CARBON STEEL GRADE 45 AND REFERENCE NOTE 11, ON ALTERNATE MATERIAL GRADES 40 & 50 TO GOST 1050-74.

**CHEMICAL COMPOSITION :-**

GRADE OF STEEL	CONTENT OF ELEMENTS %						REMARKS
	C	Si	Mn	Cr	S	P	
45	0.42-0.50	0.17-0.37	0.50-0.80	0.25	0.040	0.035	Ref. MATL.
40	0.37-0.45	0.17-0.37	0.50-0.80	0.25	0.040	0.035	Alt. MATL.
50	0.47-0.55	0.17-0.37	0.50-0.80	0.25	0.040	0.035	Alt. MATL.

RESIDUEL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH

**MECHANICAL PROPERTIES UNDER NORMALISED CONDITION:-**

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH kgf/mm <sup>2</sup>	YIELD POINT kgf/mm <sup>2</sup>	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH kgf/cm <sup>2</sup>	HARDNESS BHN (MAX)	REM
45	61	36	16	40	5	229	Ref. MATL.
40	58	34	19	45	6	217	Alt. MATL.
50	64	38	14	40	4	241	Alt. MATL.

\* DIMENSIONS SHOULD BE ENSURED WITH TOOL

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

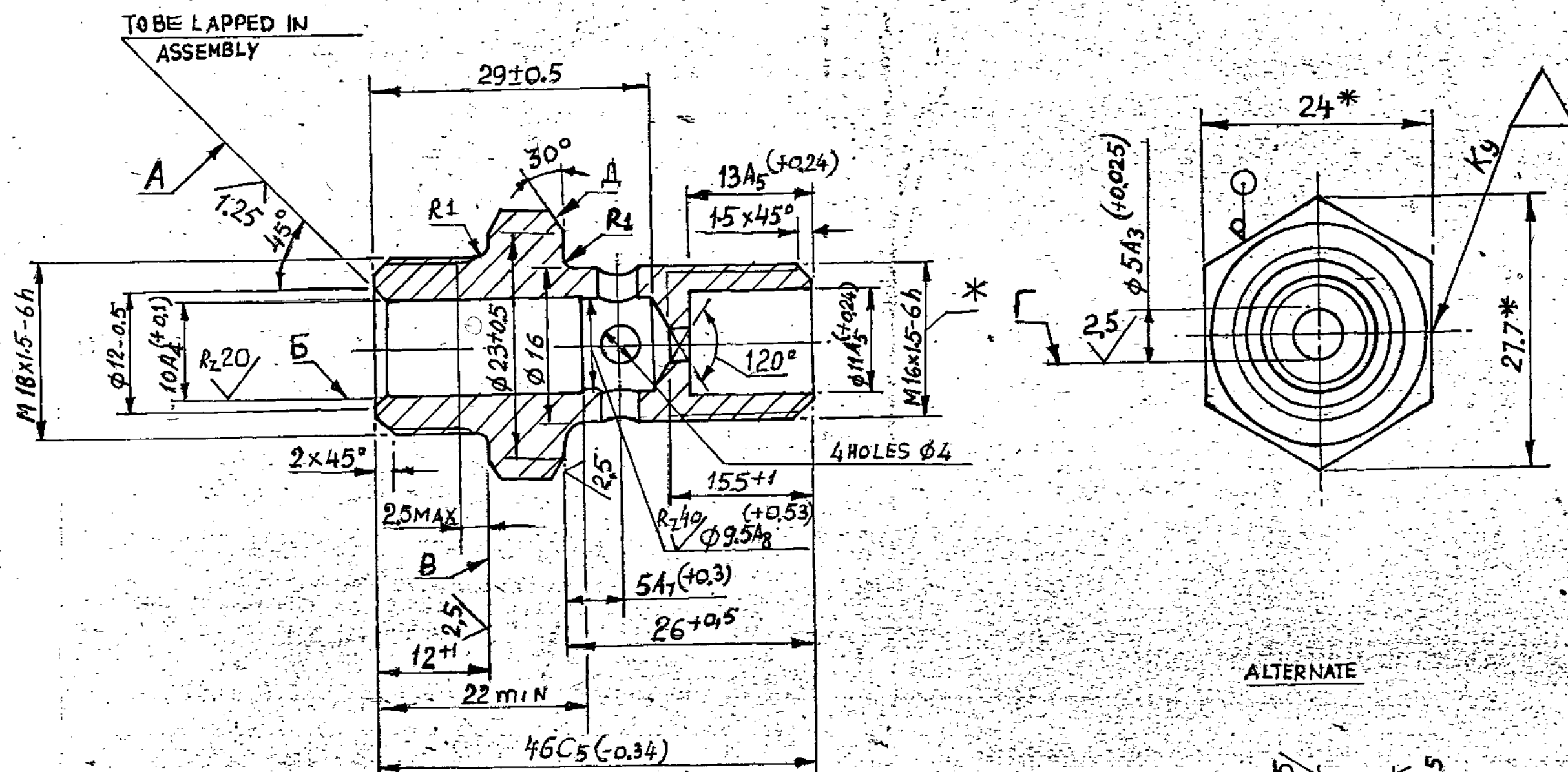
EST. WT. 0.023kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)

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	ICD	APPO	DATE	SCALE - 2:1	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69	MATERIAL :- 17.5 GOST 8560-78 HEXAGONAL BAR 45 GOST 1051-73	USED ON 62310-30A C5 C5 327-00-45
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)								AVADI	
TITLE								STARTING VALVE CAP	
D S CAT NUMBER								DRAWING NUMBER 320-37	
ISSUE	DATE	NATURE OF AMENDMENTS							

C5 20-23-00-10  
C5 20-10-00-4





**EXPLANATORY NOTE :**

MATERIAL QUOTED : 24-5 GOST 8560-78  
45 GOST 1050-74

BRIGHT STEEL HEXAGONAL BAR ACROSS FLATS 24 mm.  
CLASS OF ACCURACY 5 TO GOST 8560-78.

45 = GRADE OF STEEL.

(a) CHEMICAL COMPOSITION : (AS PER GOST 1050-74)

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

(b) MECHANICAL PROPERTIES :

GRADE OF STEEL	YIELD POINT Kg/mm <sup>2</sup> (min)	ULTIMATE TENSILE STRENGTH Kg/mm <sup>2</sup> (min)	ELONGATION % (min)	REDUCTION IN AREA % (min)	IMPACT STRENGTH Kg.m/cm <sup>2</sup> (min)
45	36	61	16	40	5

- INSPECTION GROUP III AS PER TECHNICAL REQUIREMENTS TT-11 HB 241 TO 207 (d = 3.9 TO 4.2). DIMENSIONS
- UNSPECIFIED LIMIT DEVIATIONS OF MACHINING ARE AS FOLLOWS :  
FOR HOLE - AS PER A7.  
FOR SHAFTS - AS PER B7.  
FOR OTHERS - AS PER C7.
- MACHINE SURFACES B AND Γ WITH COMBINATION TOOL.
- TOLERANCE FOR END PLAY OF SURFACE B WITH RESPECT TO THE ANGLE DIAMETER AXIS OF THREAD SHOULD BE 0.05 mm.
- TOLERANCE FOR RADIAL RUN-OUT OF CHAMFER A WITH RESPECT TO SURFACE B AXIS SHOULD BE 0.02mm.
- TOLERANCE FOR END PLAY OF SURFACE 'A' WITH RESPECT TO THE ANGLE DIAMETER AXIS OF THREAD 'K' SHOULD BE 0.1mm.
- WHEN BUTT-ENDS B AND 'A' ARE FACED, THE SINGLE POINT TOOL MAY CUT ALONG THE CYLINDRICAL SURFACE TO A DEPTH OF NOT EXCEEDING 0.3mm.
- THREAD 'U' MAY BE MADE BY ROLLING WITH THE DIAMETER OF THE UNTHREADED PORTION FROM BUTT-END 'B' BEING WITHIN THE LIMITS OF THE MEAN DIAMETER OF THREAD OVER THE LENGTH NOT EXCEEDING 2.5mm.

- \* DIMENSION ARE GIVEN FOR REFERENCE.
- COATING : ZINC-PLATED, 6 MICRONS THICK OILED.
- USED FOR TROPICAL VERSION IS COATING CADMIUM-PLATED 9 MICRONS THICK, OILED WITH REMOVAL OF HYDROGEN BRITTLENESS.
- INTERNAL SURFACES MAY HAVE NO COATING.

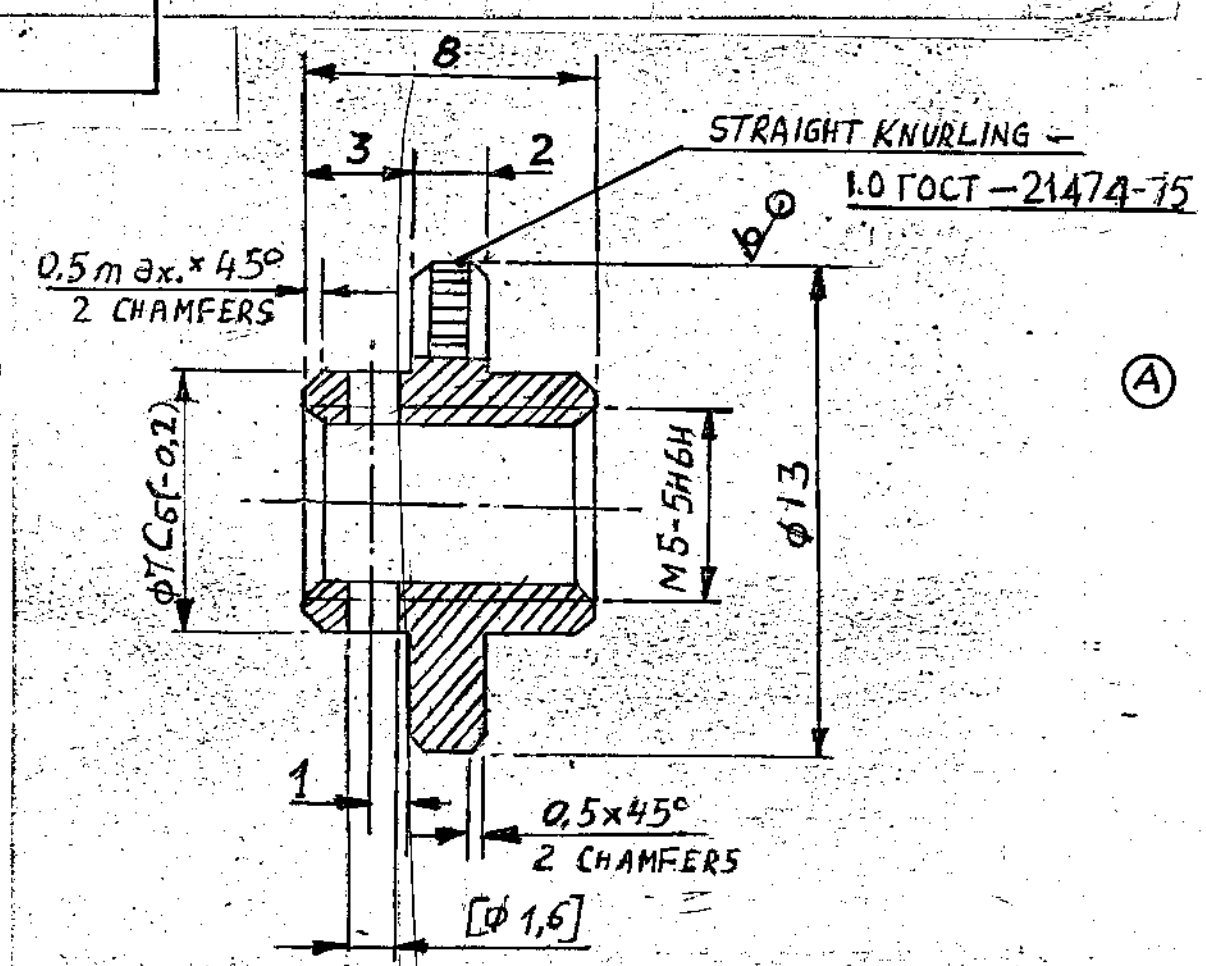
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. WT. 0.06 kg.	TO BE STAMPED OR MARKED WHERE INDICATED THUS # ( LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MATCHED CORNERS TO HAVE R OUTSIDE R. INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

DRN	14/11/78	MATERIAL :-	24-5 GOST-8560-78	USED ON :-	CB 322-13-3
CHD	14/11/78		45 GOST 1050-74		CB 310-31
TCO	14/11/78	CONTROLLEDATE OF QUALITY ASSURANCE (HEAVY VEHICLES)			
APPD		A V A O I			
DATE	2-1-80	TITLE			
SCALE	2:1	STARTING VALVE BODY			
DIMENSIONS IN mm		TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2002-69			
ISSUE		DATE		D S CAT NUMBER	
MATURE OF AMENDMENTS				DRAWING NUMBER	
				322-33-2	



DRAWING NUMBER  
**322-35**



**EXPLANATORY NOTE:-** Rz40/ (✓)

**MATERIAL QUOTED:-** 13-5 GOST-7417-75  
45 GOST 1050-74

**ALTERNATE MATERIAL QUOTED:-** 40, 50, GOST 1050-74

SIZED, COLD ROLLED OR COLD DRAWN STEEL WITH 13 mm EXTERNAL DIA, CLASS OF ACCURACY -5 AS PER GOST 7417-75, MANUFACTURED FROM STEEL GRADES 40, 45 & 50 GOST 1050-74.

**CHEMICAL COMPOSITION:-** % (AS PER GOST 1050-74)

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

**MECHANICAL PROPERTIES:-** (AS PER GOST 1050-74)

GRADE OF STEEL	TENSILE STRENGTH Kgf/mm <sup>2</sup>	YIELD POINT Kgf/mm <sup>2</sup>	% ELONGATION	% REDUCTION IN AREA	IMPACT STRENGTH Kgf.m/cm <sup>2</sup>
40	58	34	19	45	6
45	61	36	16	40	5
50	64	38	14	40	4

- ALTERNATE MATERIAL IS STEEL 40, 50, GOST 1050-74.
- UNSPECIFIED LIMIT DEVIATIONS OF MACHINING DIMENSIONS ARE AS FOLLOWS FOR HOLES - AS PER A<sub>7</sub>, SHAFTS - AS PER B<sub>7</sub>, OTHERS - AS PER C<sub>7</sub>.
- CARRY-OUT MACHINING AS PER DIMENSION GIVEN IN SQUARE BRACKETS IN THE ASSEMBLY.
- COATING: CHEMICALLY OXIDIZED OILED.

Material: STEEL 709M40 (EN-19) TO BS-970 Pt-I-1983

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

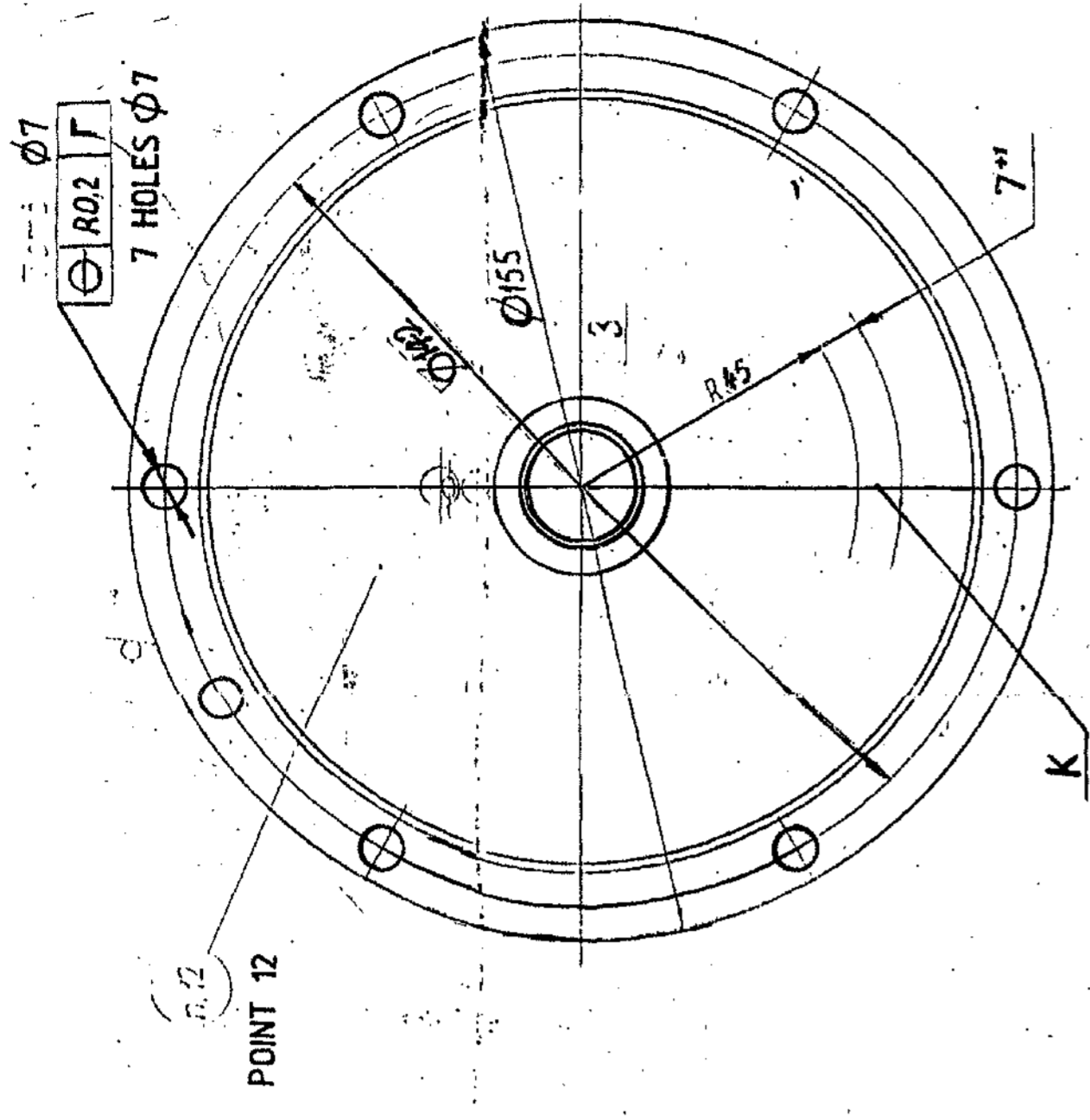
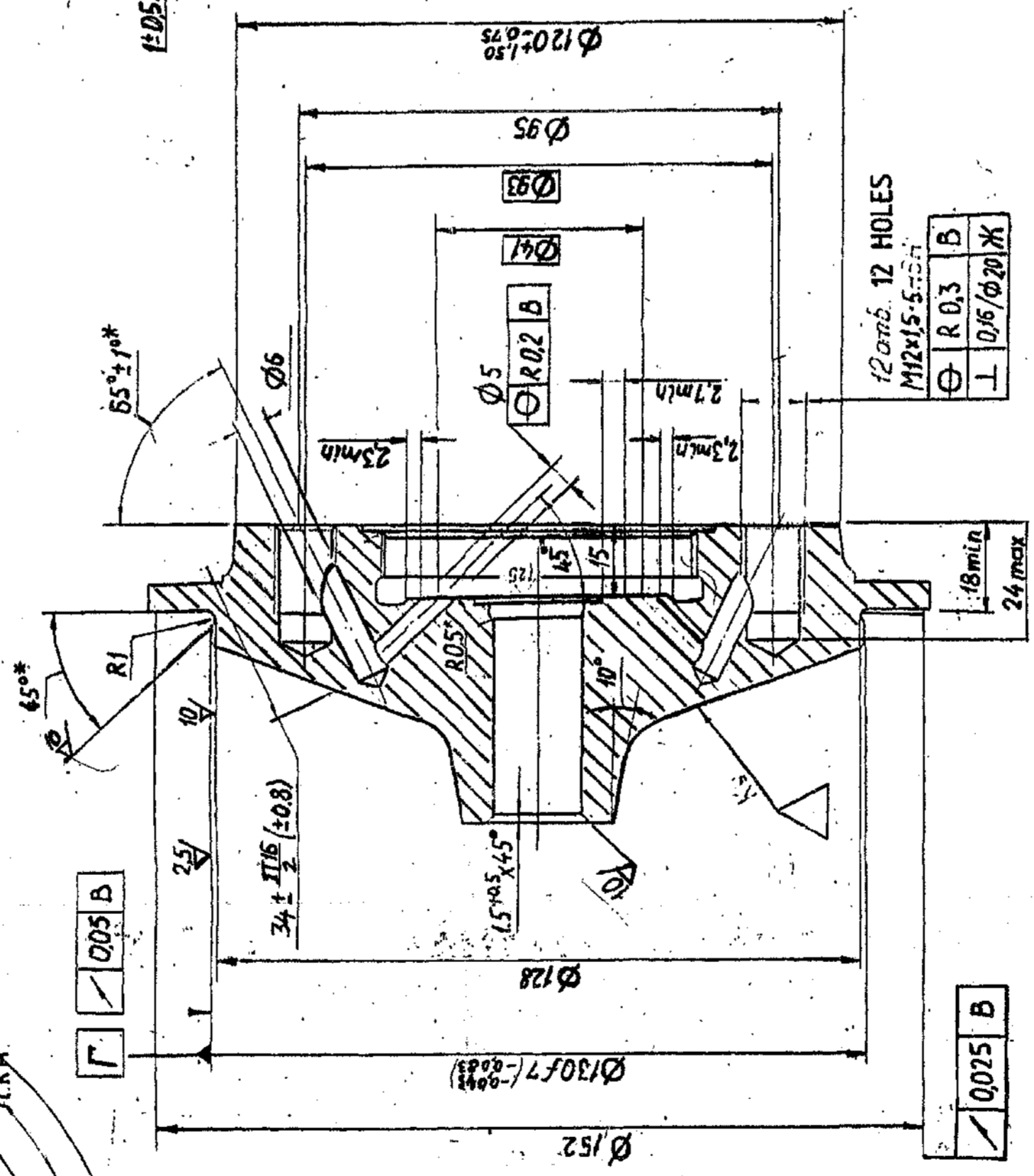
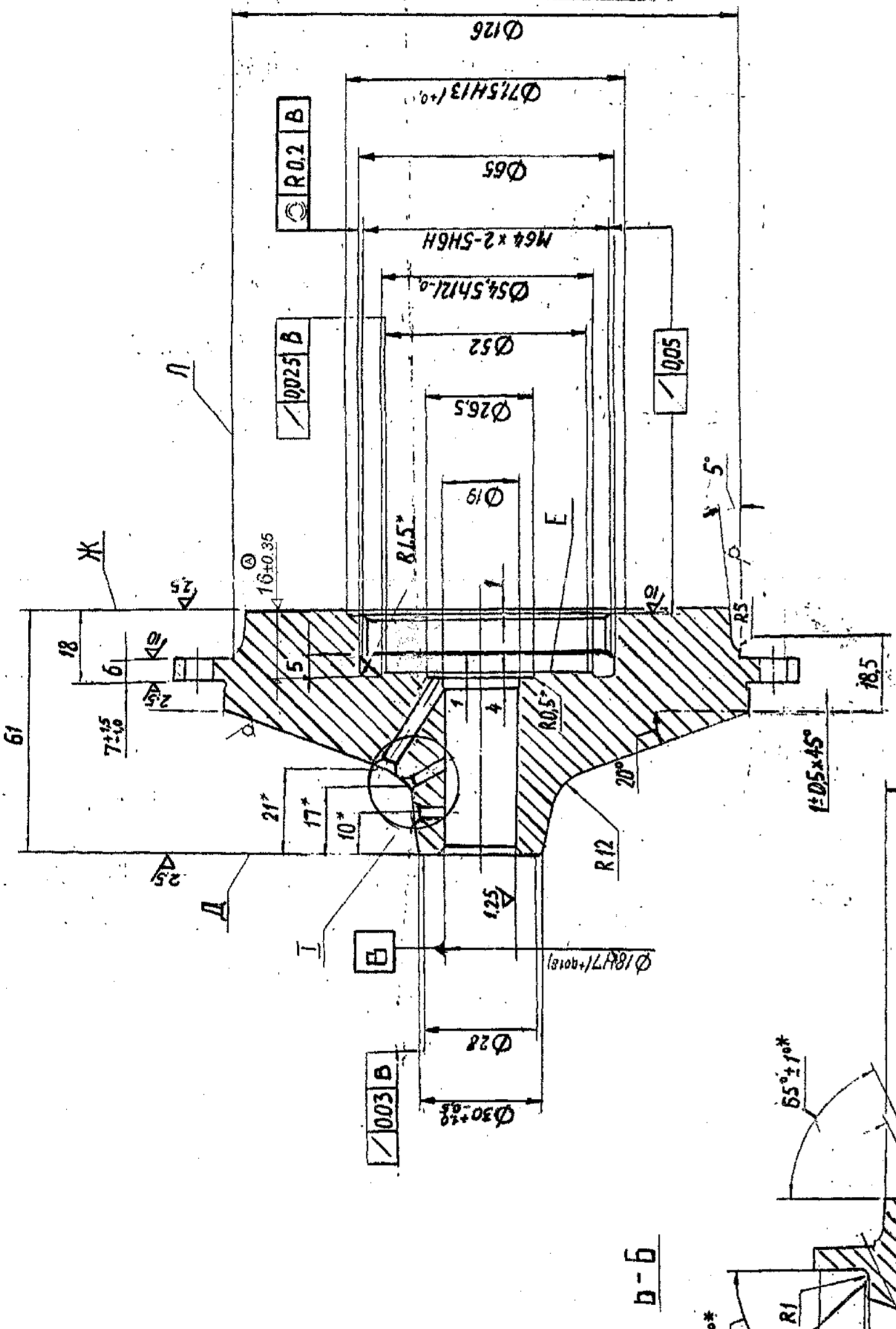
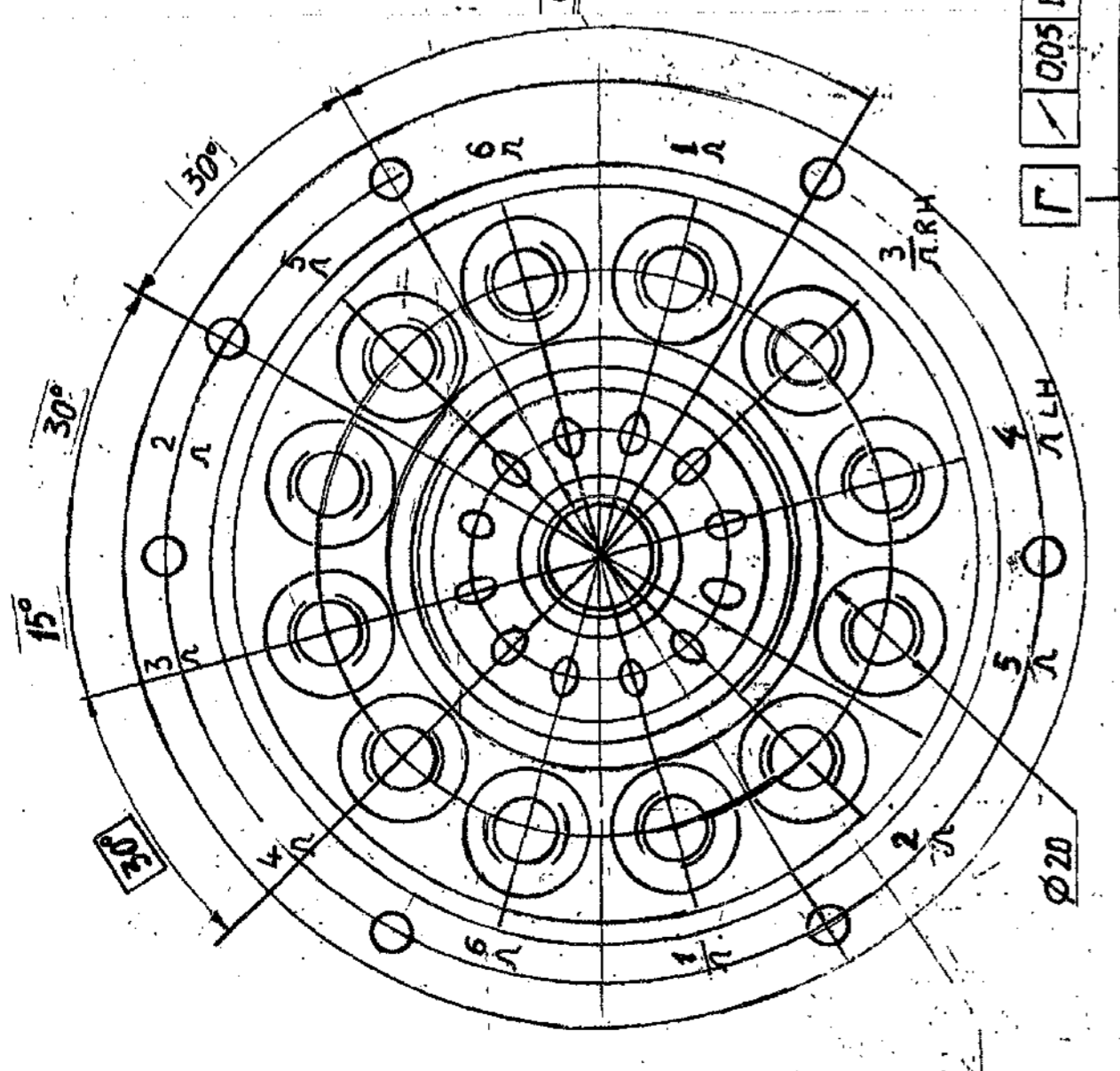
EST. WT: 0.003kg TO BE STAMPED OR MARKED WHERE INDICATED THIS ( LETTERS)

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

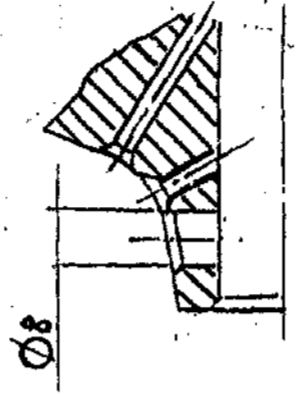
DRN	APPROVED	MATERIAL: 13-5 GOST 7417-75	USED ON
ED		(A) 45 GOST 1050-74	SS 322-13-4
TED		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
APPD		AVAD	
DATE	9-1-90		
SCALE	5:1		
DIMENSIONS IN mm		TITLE	
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 2102-69		STARTING VALVE	
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
A 18.5.09 Authy: Third Alt. Comm. Minutes Point: 5 Dated 27-02-2009.			322-35
ISSUE DATE	NATURE OF AMENDMENTS		



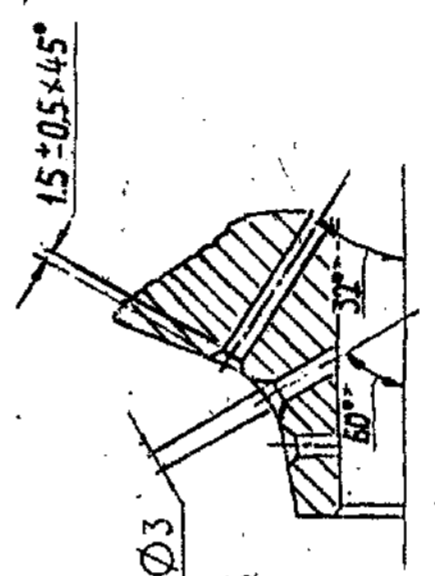
ELK/D  
6-1 A



Альтернатива  
ALTERNATE



3mm Ø3  
3 HOLES



- 1) INSPECTION GROUP III AS PER TT-11.
- 2) HB ≥ 100
- 3) UNSPECIFIED TOLERANCES OF DIMENSIONS: HOLES AS PER H14, SHAFTS-AS PER H14, OTHERS ± IT14
- 4) TECH REQUIREMENTS ON THREAD SHOULD BE AS PER NORMAL 82021-00.
- 5) DIAMETER 3 IS TO BE CHECKED BY TOOL
- 6) SURFACES A, B AND E SHOULD BE CHECKED BY BLUING. IMPRINT SHOULD BE UNIFORM AND COVERED ON MINIMUM 80% OF SURFACE
- 7) NUMBER OF CYLINDERS SHOULD BE STAMPED AT A DISTANCE OF 15mm AWAY FROM SURFACE A BY USING TYPE 410-3 GOST 2930-82
- 8) 12 FACINGS OF M15 ALLOWED WITH A DEPTH OF 0.3mm MAX WITH SURFACE ROUGHNESS Ra
- 9) SURFACE ROUGHNESS OF SURFACE A MAY BE Ra WITH PRESENCE OF 12 FACINGS OF M15
- 10) NUMBER OF COMPONENTS MAY BE STAMPED IN PLACE OF K WITH 3mm PROJECTION OF FIGURE OVER THE SURFACE OF COMPONENT.
- 11) AFTER FINAL HEAT TREATMENT COMPONENT SHOULD BE ACCEPTED AS PER TT-09.

12) MATERIAL GRADE SHOULD BE STAMPED AS PER GOST 2071-79, WITH TYPE IT10-10 GOST 2930-82

13) \* DIMENSIONS ARE TO BE ENSURED BY TOOL

1. Проверка качества изготовления  
2. HB ≥ 100  
3. Неопределенные допуски размеров: отверстия по H14, валы по H14, остальные ± IT14  
4. Технические требования на резьбу должны быть по нормам 82021-00.  
5. Диаметр 3 проверить инструментом  
6. Поверхности Д, Е и В проверить по методу окраски в синий цвет равномерным и полным покрытием 80% поверхности  
7. Число цилиндров должно быть нанесено на расстоянии 15 мм от поверхности А с помощью штампа И 410-3 по ГОСТ 2930-82  
8. Допускается 12 фасок в месте К глубиной 0,3 мм  
9. Допускается шероховатость поверхности по Ra  
10. При наличии 12 фасок К шероховатость поверхности в месте К должна быть Ra  
11. Поверхность детали после окончательной мехобработки должна быть обработана по IT10-10  
12. После обработки поверхность должна быть обработана по ГОСТ 2071-79  
13. После обработки детали должны быть приняты.

12.08

SRN	END	ICD	APPR	DATE	SCALE	TITLE
					1:1	AIR DISTRIBUTION VALVE BODY
DIMENSIONS IN mm						A V A O I
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 202-89						
ALL THREADS TO CONFORM TO						
ISSUE	DATE	NATURE OF AMENDMENTS				
A	49-07	DI:23-09-08				

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

EST. MASS 1.00 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 OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE



EXPLANATORY NOTE

9. REFERENCE MATERIAL QUOTED:  
STRUCTURAL ALLOY STEEL MANUFACTURED IN ACCORDANCE WITH  
ENHONIUM STEEL GRADE 45X TO GOST 4543-71

a. CHEMICAL COMPOSITION:

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C	Si	Mn	Cr	P	S	Cu	N
45X	0.41	0.17	0.50	0.80	0.035	0.035	0.30	0.30
	0.49	0.37	0.80	1.10				

b) MECHANICAL PROPERTIES UNDER HARDENED AND TEMPERED CONDITION

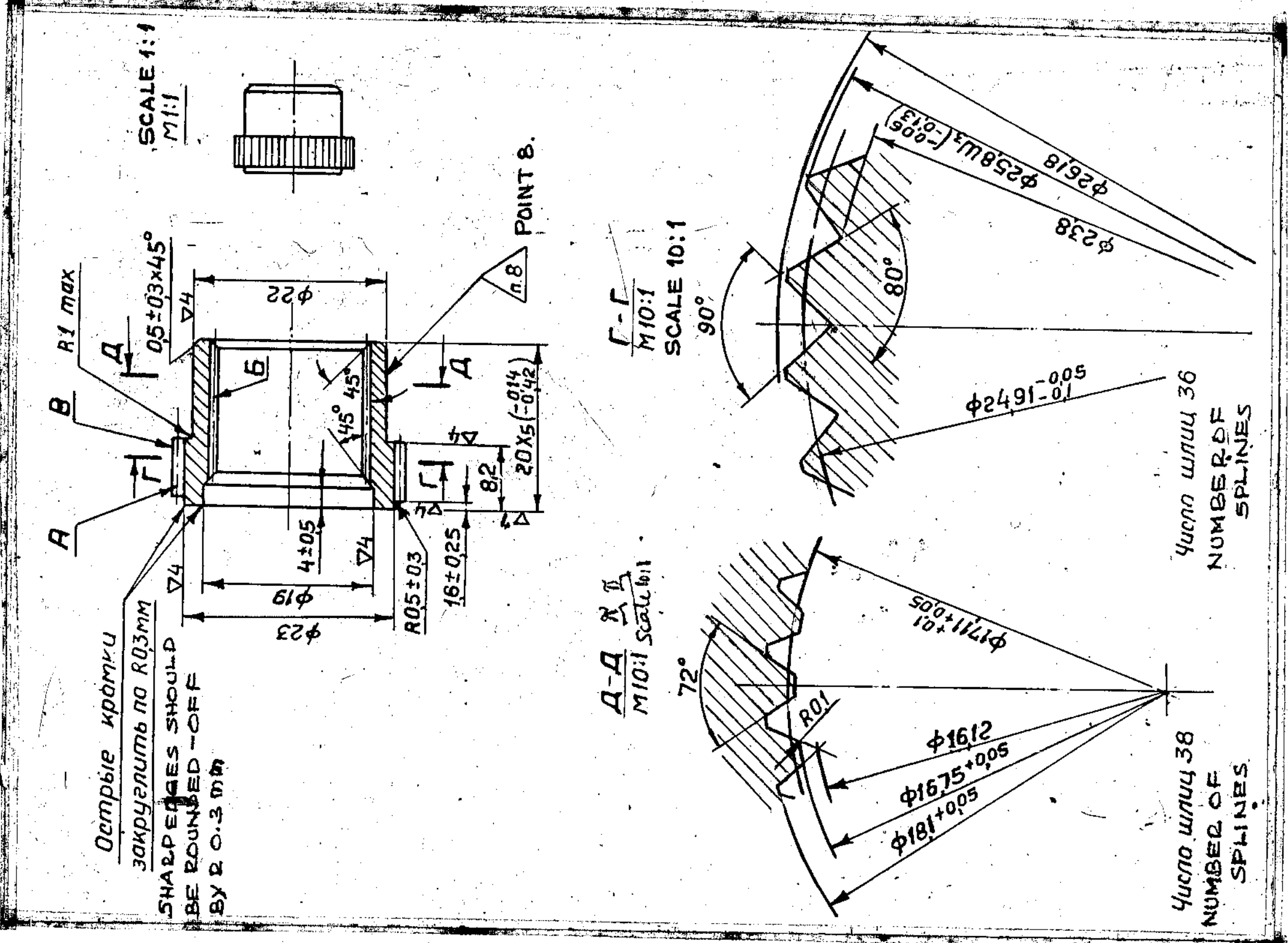
GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm <sup>2</sup>	YIELD POINT Kgf/mm <sup>2</sup>	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH KJ/m <sup>2</sup> CM <sup>2</sup>	HARDNESS BHN MAX
45X	105	85	9	45	5	229

10. REFERENCE NOTE '1' ON INSPECTION GROUP III TT-11 : SUBJECT TO 100% CHECKING OF HARDNESS WITHOUT BEING TESTED FOR MECHANICAL PROPERTIES SURFACE WHICH ARE SUBJECTED TO HEAT TREATMENT TO DIFFERENT GRADES OF HARDNESS, RANDOM CHECKING OF SURFACES WITH LOWER HARDNESS IS ALLOWED BEYOND CHECKING OF MECHANICAL PROPERTIES AND HARDNESS DEPENDING UPON THE INSPECTION GROUP PERIODIC CHECKS OF MICROSTRUCTURE ARE CARRIED OUT DIRECTION OF GRAIN FLOW IN STAMPINGS SHOULD SATISFY THE REQUIREMENTS OF THE STANDARD.

11. REFERENCE NOTE 3. ON COATING: OXIDIZED COPPER FINISH TO IS: 1378-79 AND OILFINISH IN THE FRACTURE OF FINISHED ITEMS OR IN MICROSTRUCTURE THERE SHOULD BE NO SHRINKAGE, CAVITIES, POROSITY, BUBBLES, EXFOLIATIONS, CRACKS, NONMETALLIC INCLUSIONS AND FLAKES VISIBLE TO THE NAKED EYE.

Ⓐ EQUIVALENT MATERIAL STEEL 709M40  
(EN19) BS:970/40Cr4Mo3 IS:1570

DRN	ISSUED ON	MATERIAL
CHD	4543-71	STEEL 45X GOST 4543-71
TOD		
APPD		
DATE	04-4-86	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)
SCALE	2:1	
DIMENSIONS IN mm		
TOLERANCE ON DIMS UNLESS OTHERWISE STATED		
TITLE		
COUPLING SHAFT		
ISSUE DATE	12-8-10	D S CAT NUMBER
	4 <sup>th</sup> Alt. Comm. Meeting Minutes Point No. 11 Dt: 26-10-09	DRAWING NUMBER
	NATURE OF AMENDMENTS	310-08



- INSPECTION GROUP III TT-11
- HRC 33-37
- COATING: CHEMICAL OXIDIZING OIL FINISHING
- UNSPECIFIED TOLERANCES FOR THE FEMALE DIMENSIONS ARE AS PER A7, THOSE FOR MALE ONES ARE AS PER B7
- RUN OUT OF SPLINES 'A' (ON PITCH DIAMETER) RELATIVE TO THE AXIS OF SPLINES SHOULD NOT EXCEED 0.1mm
- RUN OUT SURFACE B RELATIVE TO THE AXIS OF SPLINES SHOULD NOT EXCEED 0.08mm
- THE SPLINES SHOULD BE ACCEPTED AS PER INSTRUCTIONS UB-19
- TO BE MARKED BY ELECTRICAL ETCHING.

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

EST WT 0.032 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

**EXPLANATORY NOTE**

14. REFERENCE MATERIAL QUOTED: ALLOY STEEL BAR, HOT ROLLED, HIGH QUALITY GRADE 12XH3A TO Ty 14-1-381-72 AND MANUFACTURED IN ACCORDANCE WITH GRADE 12XH3A TO GOST 4543-71.  
a) CHEMICAL COMPOSITION AS PER GOST 4543-71 ( CHROME NICKEL STEEL )

GRADE OF STEEL	CONTENT OF ELEMENTS %									
	C	Si	Mn	Cr	Ni	P	S	Cu	MAXIMUM	
12XH3A	0.09-0.16	0.17-0.37	0.30-0.60	0.60-0.90	2.75-3.15	0.025	0.025	0.025	0.025	0.30

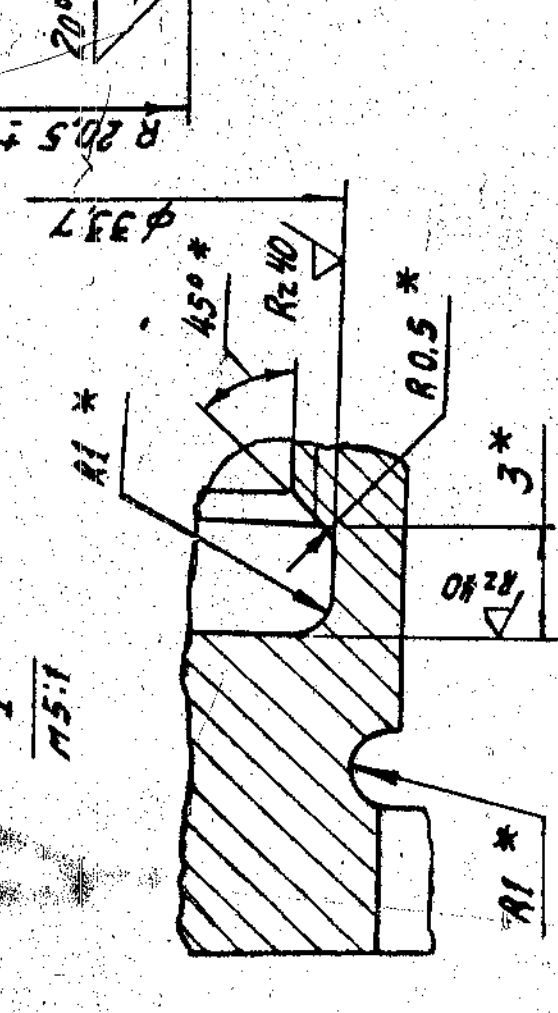
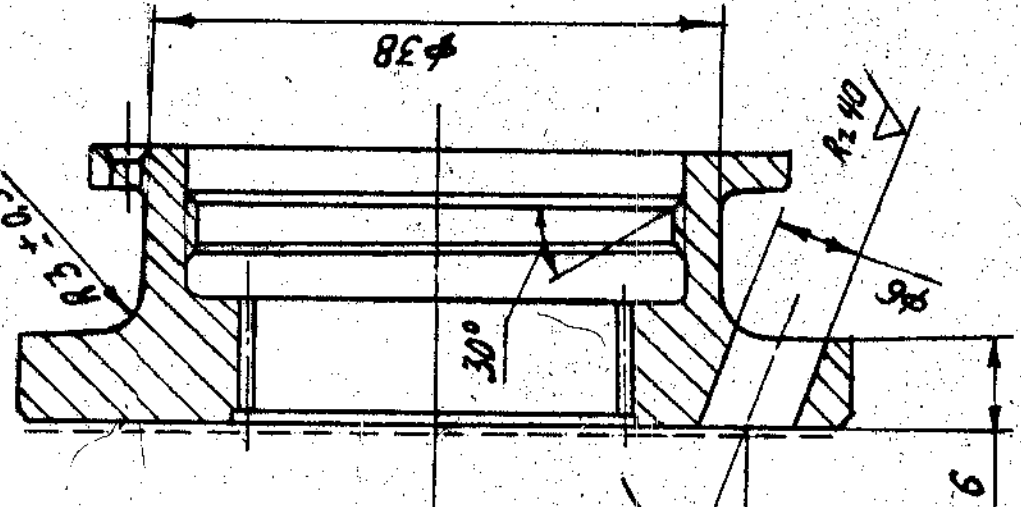
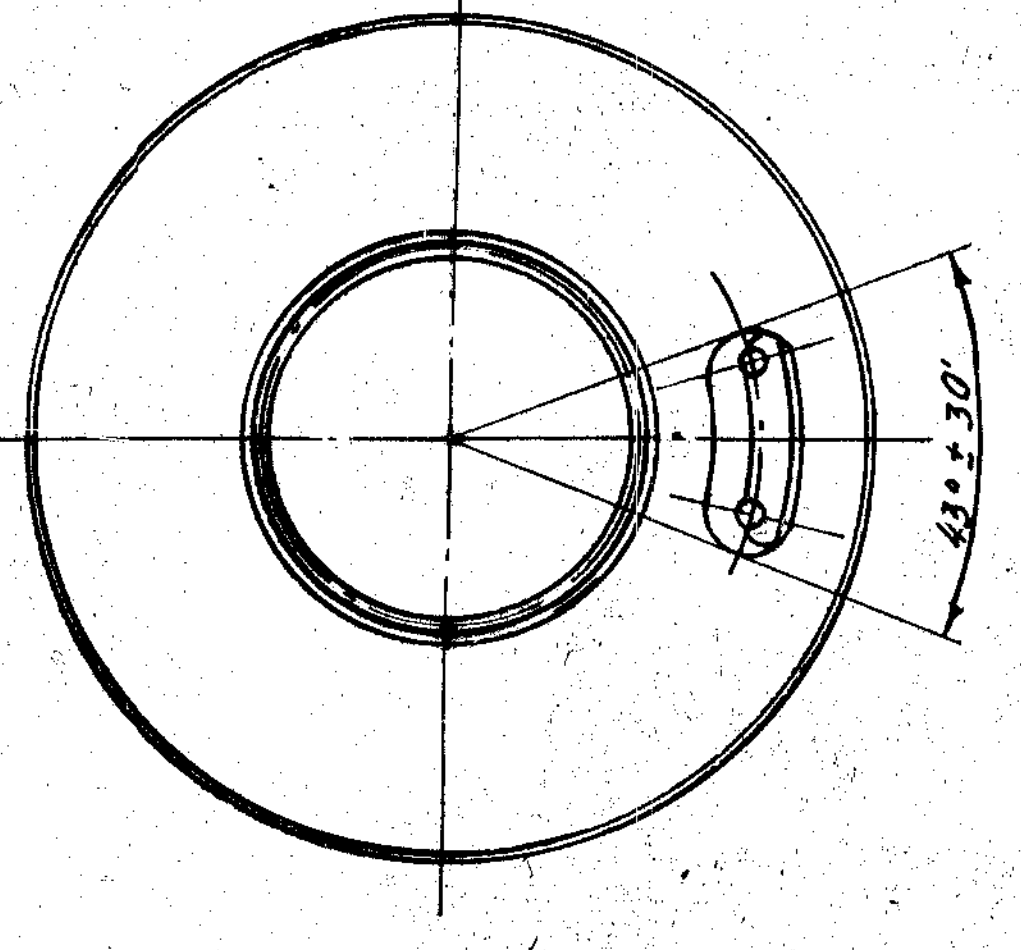
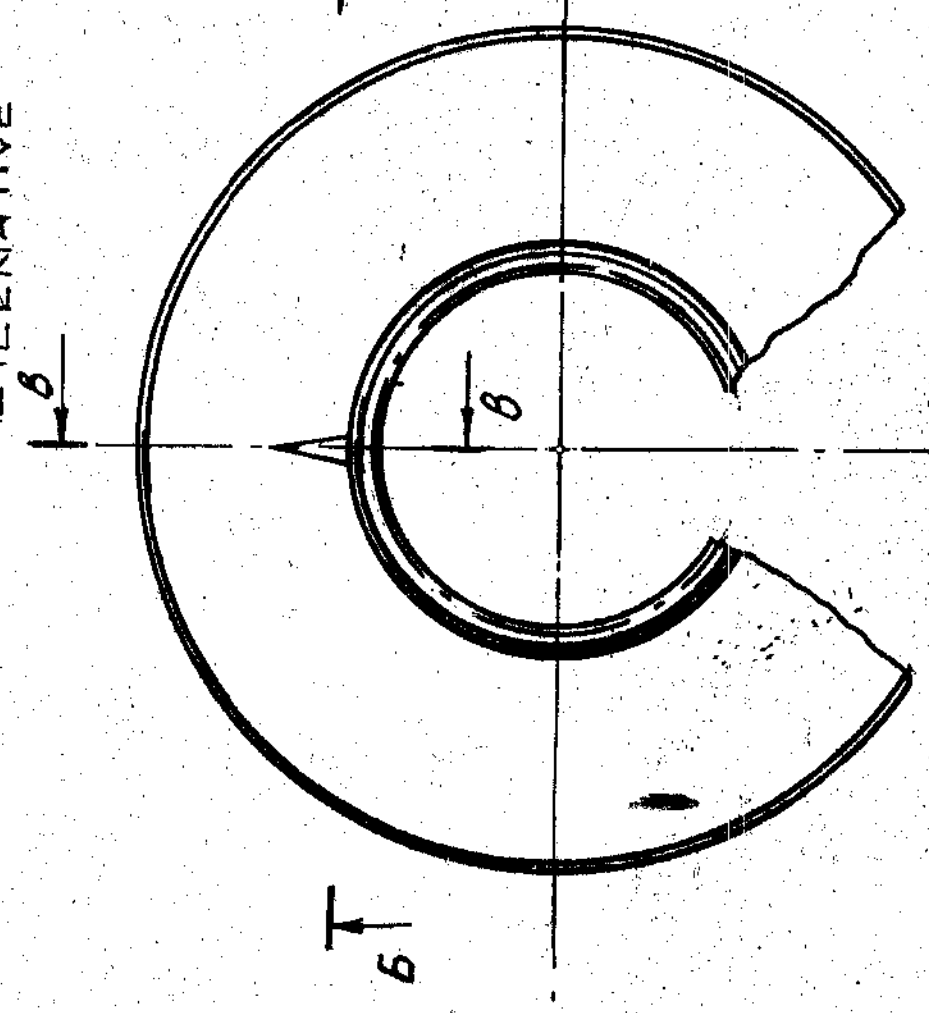
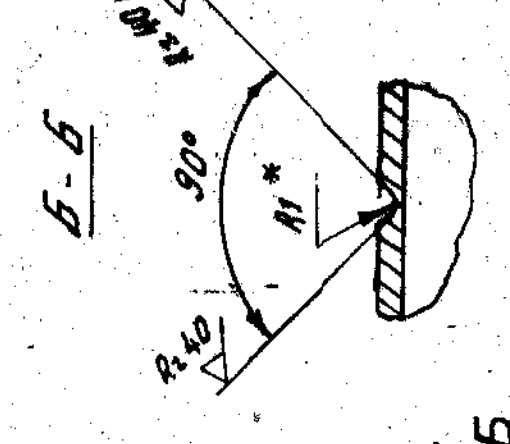
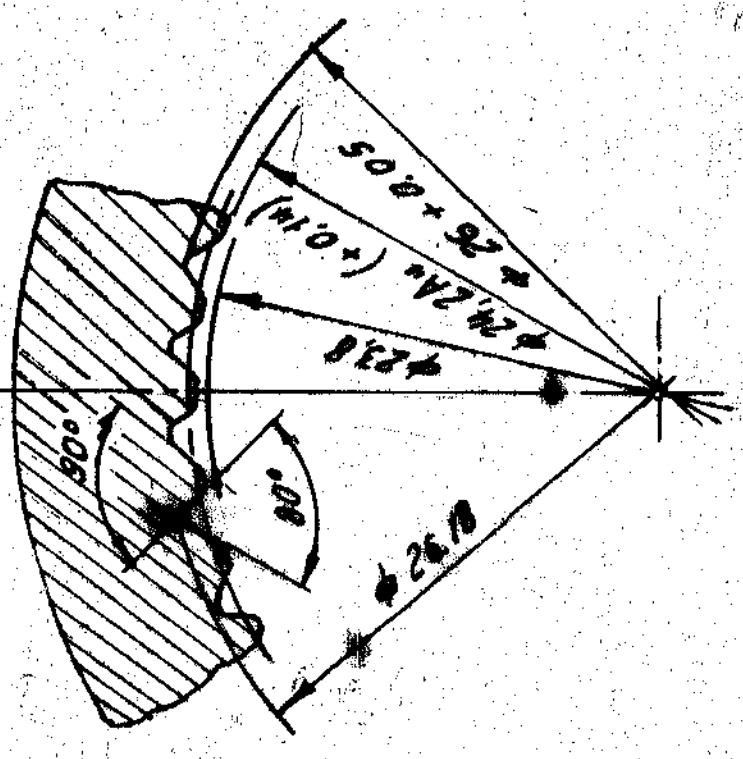
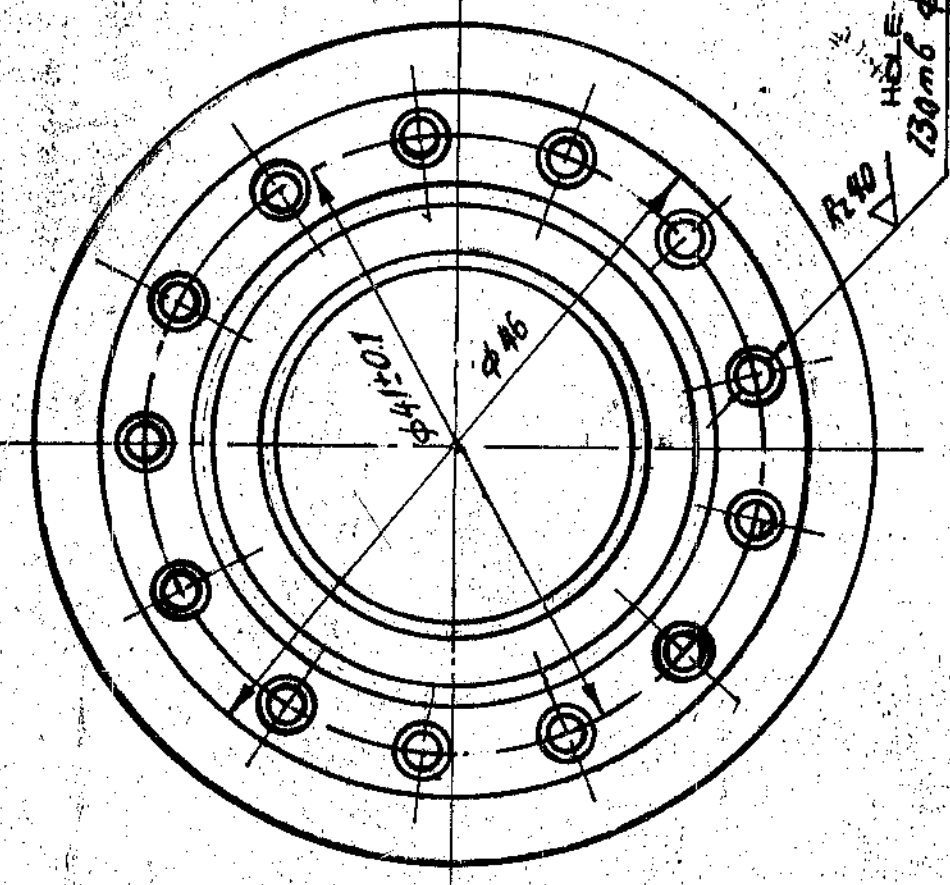
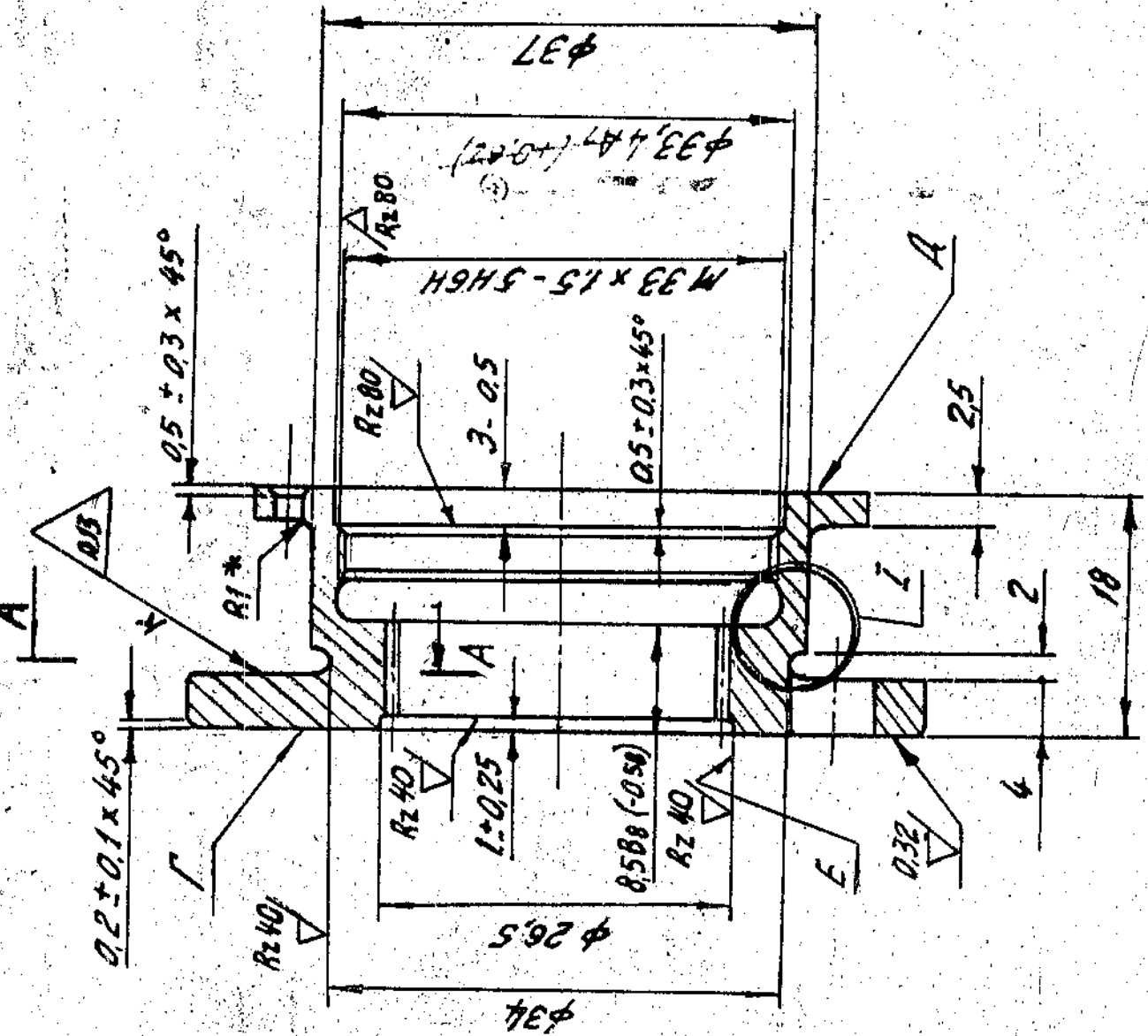
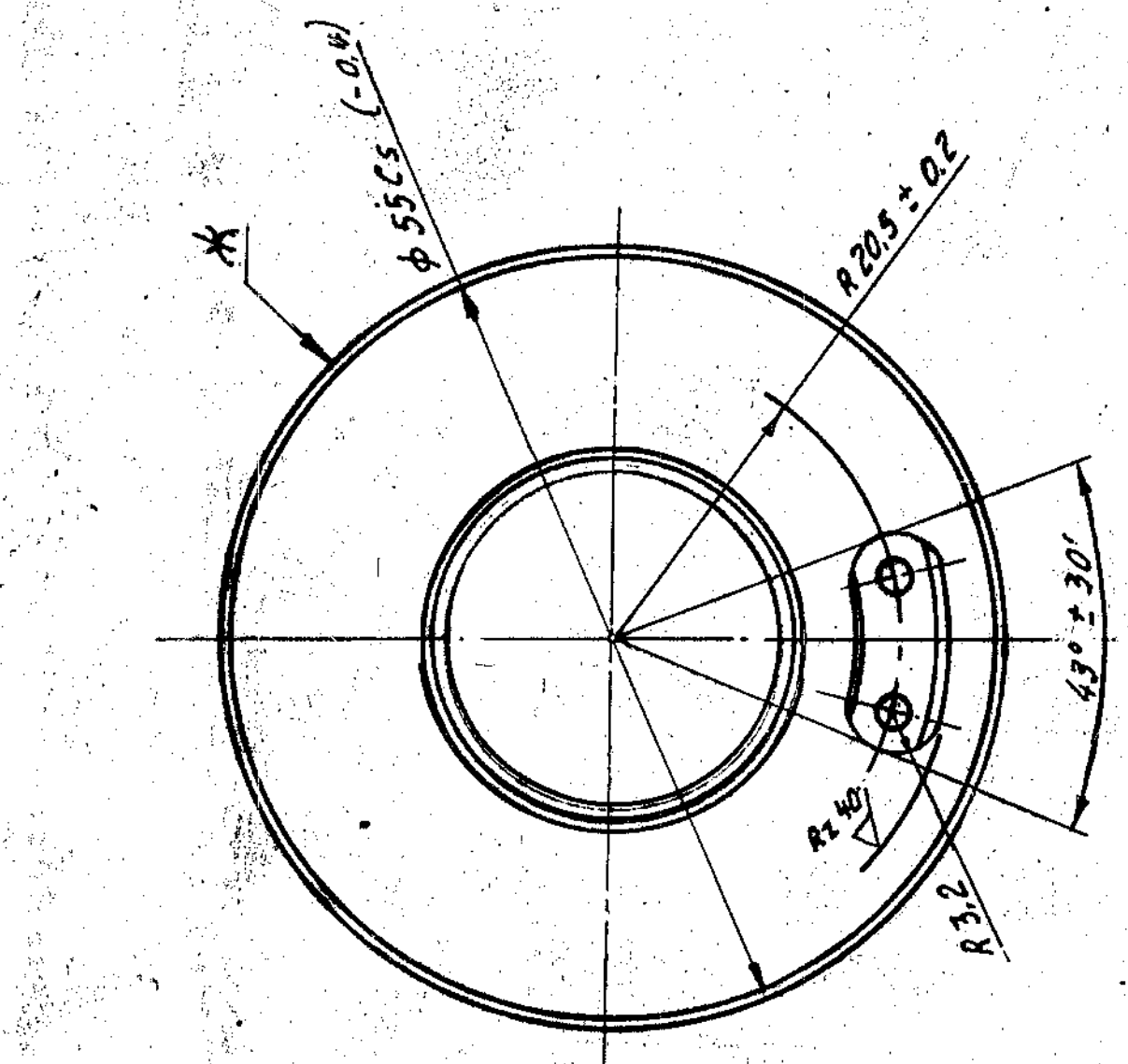
b) MECHANICAL PROPERTIES AS PER GOST 4543-71

GRADE OF STEEL	TENSILE STRENGTH Kgf/mm <sup>2</sup>	YIELD POINT Kgf/mm <sup>2</sup>	ELONGATION IN AREA %	REDUCTION IN AREA %	IMPACT HARDNESS B.H.N. ( MAX )	HARDNESS Kgf/mm <sup>2</sup> ( MAX )
12XH3A	95	70	11	55	9	217

15. REFERENCE NOTE: '1' ON INSPECTION GROUP III TT-11 SUBJECTED TO 100% CHECKING OF HARDNESS WITHOUT BEING TESTED FOR MECHANICAL PROPERTIES SURFACES WHICH ARE SUBJECTED TO HEAT TREATMENT TO DIFFERENT GRADES OF HARDNESS, RANDOM CHECKING OF SURFACES WITH LOWER HARDNESS IS ALLOWED.  
BESIDES CHECKING OF MECHANICAL PROPERTIES AND HARDNESS DEPENDING UPON THE INSPECTION GROUP,  
PERIODIC CHECKS OF MICROSTRUCTURE ARE CARRIED OUT. DIRECTION OF GRAIN FLOW IN STAMPINGS SHOULD SATISFY THE REQUIREMENTS OF THE STANDARD.  
IN THE FRACTURE OF FINISHED ITEMS OR MICROSTRUCTURE, THERE SHOULD BE NO SHRINKAGE CAVITIES, BUBBLES, EXPANSIONS, CRACKS, NON-METALLIC INCLUSIONS AND FLAKES VISIBLE TO THE NAKED EYE.  
16. REFERENCE NOTE '10' ON PROTECTIVE FINISH OXIDATION-COPPER FINISH TO IS 1378-79 AND OIL FINISH.

**SPLINE DATA**

NUMBER OF TEETH	Z	%
PIN DIAMETER	Ø1	14.1
DIAMETER OVER PIN	Ø2	Ø22.0K8
REFERENCE CIRCLE	S <sub>2</sub>	Ø22.0K8
DIAMETER	Ø3	Ø24.1K8



- INSPECTION GROUP III TT-11.
- SURFACE '1' SHOULD BE CARBURIZED: H 0.5-0.9 HRC (S 9.2).
- UNCARBURIZED SURFACES HRC 26-40.
- SURFACES '10' AND '11' MAY BE CARBURIZED.
- UNFINISHED TOLERANCES SHOULD BE MAINTAINED AS PER ACCURACY CLASS 7 GOST 1810.
- THE THREAD SURFACE SHOULD BE CLEAN WITHOUT SCORES, BURNS, STIFF AND THICK LAYERS, NICKS, CORROSION MARKS AND OTHER SURFACE DEFECTS.
- NON-SLUMMAGE OF SURFACE '10' RELATIVE TO THE AXIS OF THREAD SHOULD NOT EXCEED 0.1mm.
- FACE OUT OF SURFACE '10' ON Ø52mm RELATIVE TO THE AXIS OF SPLINE SURFACE SHOULD NOT EXCEED 0.05mm.
- SURFACE '10' SHOULD BE CHECKED BY BLUEING. THE IMPRINT SHOULD BE EMPLOYED ALONG THE ENTIRE FACE.
- GOING TO OIL OXIDIZING OIL FINISHING.
- SURFACE '10' NOT BE OXIDIZED.
- ALL SURFACES SHOULD BE ENSURED BY TOOL.
- TO BE PUNCHED.

DATE	1974-1-30-72	USED ON	CE 310-38A 05
APPROVED		CONTROLLED BY	INSPECTION (HEAVY VEHICLES)
SCALE	2:1	TITLE	DISC DISTRIBUTOR
DIMENSIONS IN mm		D S CAT NUMBER	310-09-1
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED		CONFORM TO	
NO. REVISED / ENV ID / 0.0 / V.14 / IND BY			
DATE OF REV. 001			
NATURE OF AMENDMENTS			
ISSUE			

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

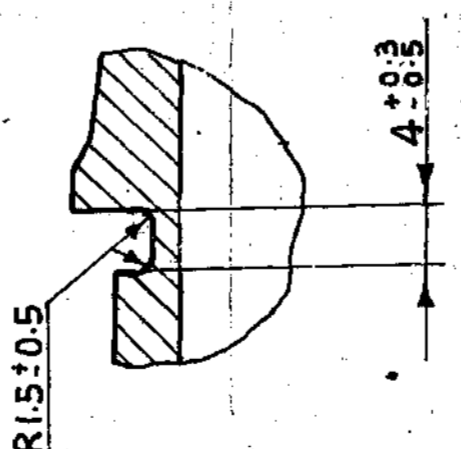
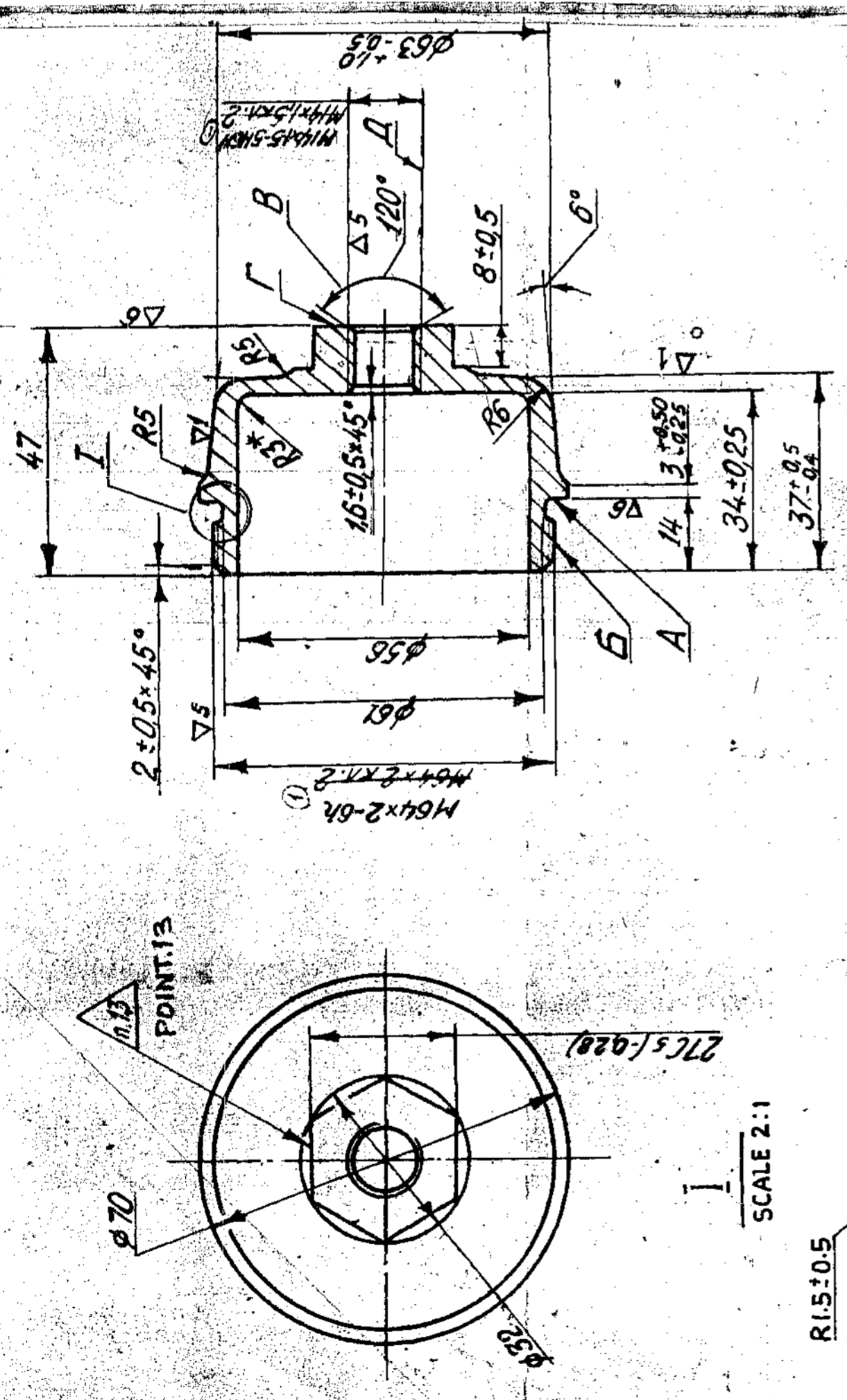
EST WT 0.4 KG

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 OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

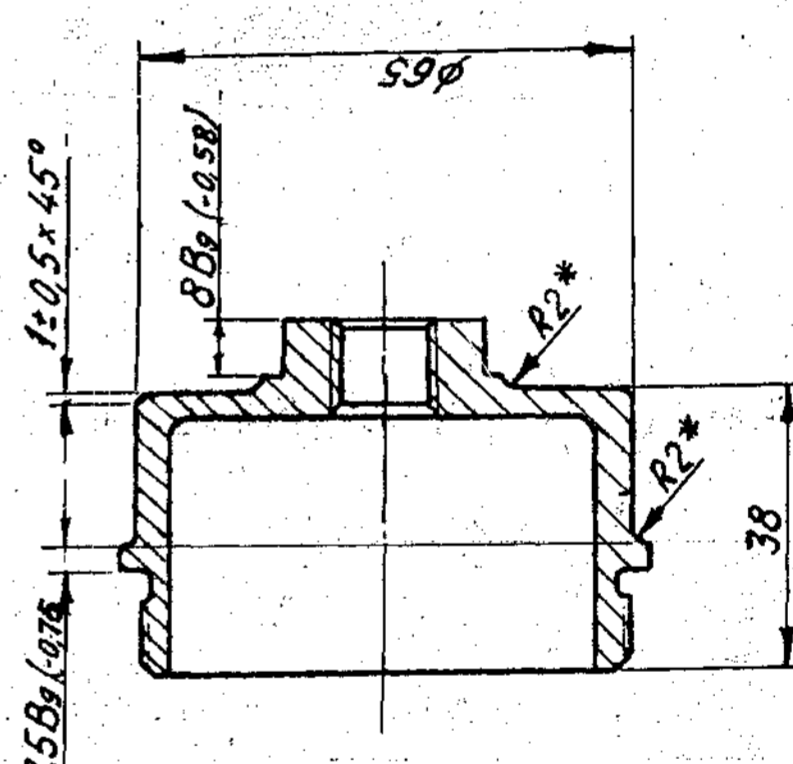
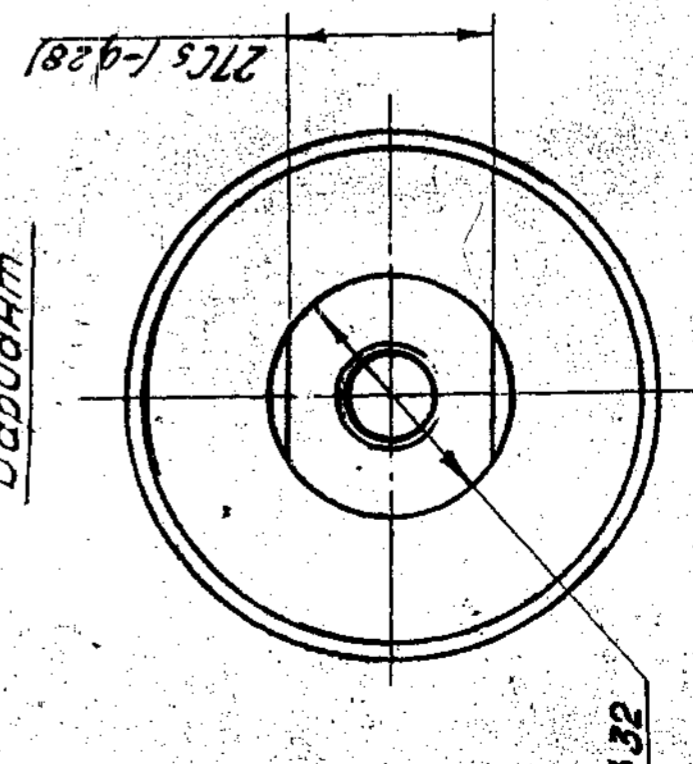
DRAWING NUMBER  
310 10

▽4 (▽)



ALTERNATIVE  
Baduham

ALTERNATIVE  
Baduham



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

1. INSPECTION GROUP III TT-11.
2. HRC 26 - 33.
3. REQUIREMENTS FOR STAMPING ARE IN ACCORDANCE WITH GOST 7503-74. (A)
4. UNSPECIFIED TOLERANCES FOR DIMENSION SHOULD BE AS PER ACCURACY CLASS 7 GOST 1818.
5. FACE OUT OF SURFACE 'A' SHOULD NOT EXCEED 0.1mm RELATIVE TO THE AXIS OF THREAD 'B'.
6. NON SQUARENESS OF SURFACE 'F' MEASURED WITHIN THE COMPONENT DIMENSIONS SHOULD NOT EXCEED 0.1mm RELATIVE TO THE AXIS OF THREAD 'A'.
7. CHAMFER 'B' SHOULD MADE UP TO THE MAJOR DIAMETER OF THE THREAD.
8. THREAD SURFACE SHOULD BE CLEAN WITHOUT SCORES, BURNS, STIPPED THREADS, NICKS, CORROSION MARKS AND OTHER SURFACE DEFECTS.
9. DELETED.
10. COATING : (A) 9. CHROMIATING AS PER GOST 569-84 (B) WITH REMOVAL OF HYDROGEN BRITTLENESS.
11. DELETED.
12. ON THREADS & AND AREAS WITHOUT COATING ARE ALLOWED.
13. TO BE PUNCH MARKED.
14. \* DIMENSIONS ARE FOR REFERENCE.

**EXPLANATORY NOTE:**

15. REFERENCE MATERIAL QUOTED:  
 STRUCTURAL ALLOY STEEL MANUFACTURED IN ACCORDANCE WITH  
 CHROMIUM STEEL GRADE 45X TO GOST 4543-71.  
 a) CHEMICAL COMPOSITION:

GRADE OF STEEL	CONTENT OF ELEMENTS %									
	C	Si	Mn	Cr	P	S	Cu	N	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		

b) MECHANICAL PROPERTIES UNDER HARDENED AND TEMPERED CONDITION AS PER GOST 4543-71

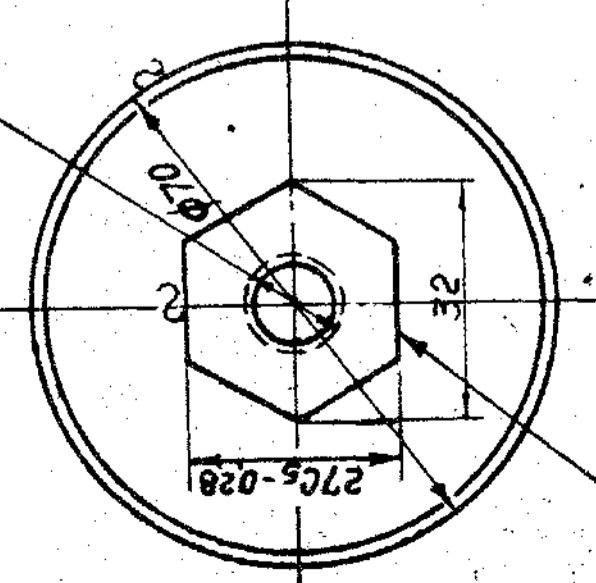
GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm <sup>2</sup>	YIELD POINT Kgf/mm <sup>2</sup>	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH Kgm/cm <sup>2</sup>	HARDNESS B H N. H A X
45X	105	85	9	45	5	229

BRN	CHD	TCD	APFD	DATE	SCALE	ISSUE	ISSUE
				04.12.85	1:1	1	1
DIMENSIONS IN mm		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED		TITLE:		D S CAT NUMBER	
1. 2. 97 AUTHY NOTN. NO. BK 8.6-41		SPECN. NO. WAS GOST 7506-74. DRAWING		CONTROLLER OF INSPECTION (HEAVY VEHICLES)		DRAWING NUMBER	
ADVANCED TO ISSUE A. AUTHY. LETTER		NO. 83371 / CHV #1 / 08 / V 46 / IND IV		MATERIAL: STEEL 45X GOST 4543-71		310 10	
DATE 01 APR 1985		NAME OF AMENDMENTS		USED ON: CB 310 30A CB		DISTRIBUTOR CAP	

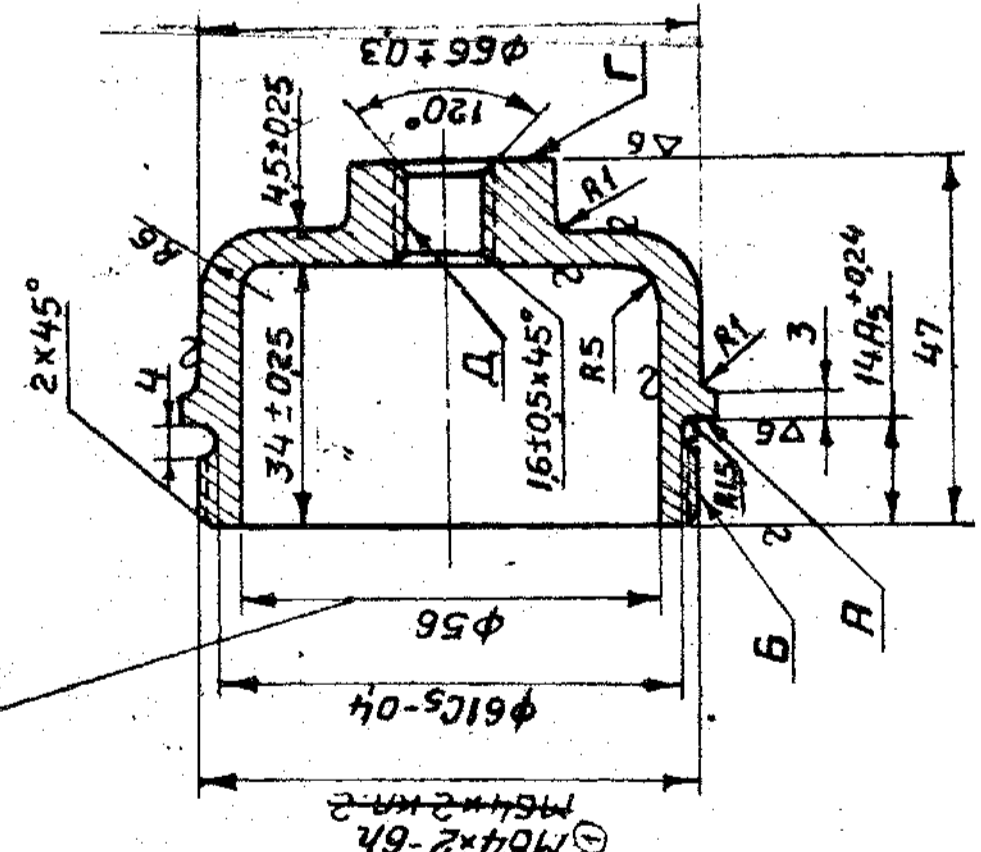
DRAWING NUMBER  
**310 10 A**

MAY BE MACHINED TO SURFACE  
FINISH  $\nabla 3$  ON LENGTH 9mm UPTO  $\phi 57$

Должность обработана с  
учетом  $\nabla 3$  на длине  
9 мм до  $\phi 57$   
M14x15-5H6H  
M14x15-M12-1



TO BE PUNCHED  
Клеимо металлургическое



- INSPECTION GROUP III IT-11
- HRC 26-30
- REQUIREMENTS FOR CASTING SHOULD BE ACCORDING TO TECHNICAL REQUIREMENTS
- TT320-1/55 (A)
- THE REMAINING REQUIREMENTS ACCORDING TO SPECIFICATION BY ITEMS (A)
- TECHNICAL REQUIREMENTS FOR THE THREADS SHOULD BE ACCORDING TO STANDARD 82021-00
- MACHINING DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE MAINTAINED AS PER A7 B7 OST 1010
- COATING IS  $\phi 9$ , CHROMATIZING ACCORDING TO ~~TT 1704~~ WITH REMOVAL OF HYDROGEN BRITTLENESS.
- AREAS HAVING NO COATING ARE ALLOWED ON THE INTERNAL AND EXTERNAL THREAD
- CHAMFER  $120^\circ$  SHOULD BE MADE UP TO THE MAJOR DIAMETER OF THE THREAD
- THE THREAD DIMENSIONS SHOULD BE CHECKED BEFORE COATING.
- NON SQUARENESS OF SURFACE  $\uparrow$  RELATIVE TO THE AXIS OF THREAD  $\Delta$  SHOULD NOT EXCEED 0.1mm WHEN MEASURED WITHIN THE COMPONENT DIMENSIONS.
- RUN OUT OF FACE A RELATIVE TO THE AXIS OF THREAD  $\Gamma$  SHOULD NOT EXCEED 0.1mm
- MACHINING OF CASTING SURFACES SHOULD BE AS PER THE STANDARD COMPONENT
- COMPONENT SHOULD BE PRESSURE TESTED WITH DIESEL FUEL UNDER PRESSURE OF 120-150kgf/cm<sup>2</sup> FOR 1 MINUTE. LEAKAGE AND SWEATING ARE NOT PERMITTED EXCEPT FOR THE JOINING PLACES.
- SHARP EDGES SHOULD BE BLUNTED
- ALTERNATE MATERIAL STEEL 40X $\Delta$  AND 50 $\Delta$  -I GOST 977-75

EXPLANATORY NOTE

18. REFERENCE MATERIAL QUOTED  
ALLOYED STEEL CASTING GRADE 40 $\Delta$  OR GRADE 45 $\Delta$  SPECIAL PURPOSE CASTING II TO GOST 977-75 AND REFERENCE NOTE 17 ON ALTERNATE MATERIAL STEEL GRADE 40X $\Delta$  AND GRADE 50 $\Delta$  TO GOST 977-75

21. CHEMICAL COMPOSITION AS PER GOST 977-75.

GRADE OF ALLOY	CONTENT OF ELEMENTS %										REMARKS	
	C	Mn	Si	P	S	Cr	Ni	Cu	MAXIMUM			
40 $\Delta$	0.37 0.45	0.44 0.98	0.28 0.52	0.04	0.045	0.30	0.30	0.30	0.30	0.30	0.30	Ref. Matl
45 $\Delta$	0.42 0.58	0.40 0.98	0.28 0.52	0.04	0.045	0.30	0.30	0.30	0.30	0.30	0.30	Ref. Matl
40X $\Delta$	0.35 0.45	0.40 0.98	0.28 0.40	0.04	0.045	0.30	0.30	0.30	0.30	0.30	0.30	Alt. Matl
50 $\Delta$	0.47 0.55	0.40 0.90	0.28 0.52	0.04	0.045	0.30	0.30	0.30	0.30	0.30	0.30	Alt. Matl

21. MECHANICAL PROPERTIES UNDER TENSILE AND TORSION AS PER GOST 977-75

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm <sup>2</sup>	YIELD POINT Kgf/mm <sup>2</sup>	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH 5TH KJ/cm <sup>2</sup>	REMARKS
40 $\Delta$	58	30	14	20	3.0	Ref. Matl
45 $\Delta$	60	40	10	20	3.5	Alt. Matl
40X $\Delta$	65	50	12	25	4.0	Alt. Matl
50 $\Delta$	75	60	14	20	3.0	Alt. Matl

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

EST WT  
0.374 Kg

TO BE STAMPED OR MARKED WHERE INDICATED THUS  $\uparrow$  LETTERS  $\uparrow$

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

DRW	DATE	SCALE	CONTROLLER OF INSPECTION	AVACH
CHK	06-01-75	1:1		
TCD				
APPO				
DATE				
DIMENSIONS IN mm		TITLE		
1.2.97 AUTHY NOTN. No. BK 86-41		CAP DISTRIBUTOR		
07-4-87 SPECN. No. WAS 320-1/55. IN NOTE No. 3 &		D S CAT NUMBER		
SPECN. No. WAS 8701. NOB. IN NOTE No. 4. DRG. ADVANCED TO ISSUE 'A'. AUTHY. LETTER No. 83321/CHV (P) 010/24/87 AND 101 01-5-87.		DRAWING NUMBER		
ISSUE		310 10 A		

$\nabla 4 (\sim \nabla 6)$

**EXPLANATORY NOTE :**

13. REFERENCE MATERIAL QUOTED: QUALITY CARBON STRUCTURAL STEEL GRADE 45 AND REFERENCE NOTE 7 ON ALTERNATE MATERIAL, COLD ROLLED SIZED STEEL ROUND  $\phi 40$ mm CLASS OF ACCURACY 5 (1-0,340) TO GOST 7417-75. NORMAL SURFACE QUALITY TO GOST 1051-73 AND MANUFACTURED IN ACCORDANCE WITH STEEL GRADE 45 TO GOST 1050-74.

a) CHEMICAL COMPOSITION AS PER GOST 1050-74

GRADE OF STEEL	CONTENT OF ELEMENTS %			
	C	Si	Mn	P
45	0.42-0.50	0.17-0.37	0.50-0.80	0.040
				0.035

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH.

b) MECHANICAL PROPERTIES UNDER NORMALISED CONDITION AS PER GOST 1050-74.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH $Kgf/mm^2$	YIELD POINT $Kgf/mm^2$	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH $GTH Kgm/cm^2$	HARDNESS BHN max
45	61	36	16	40	5	229

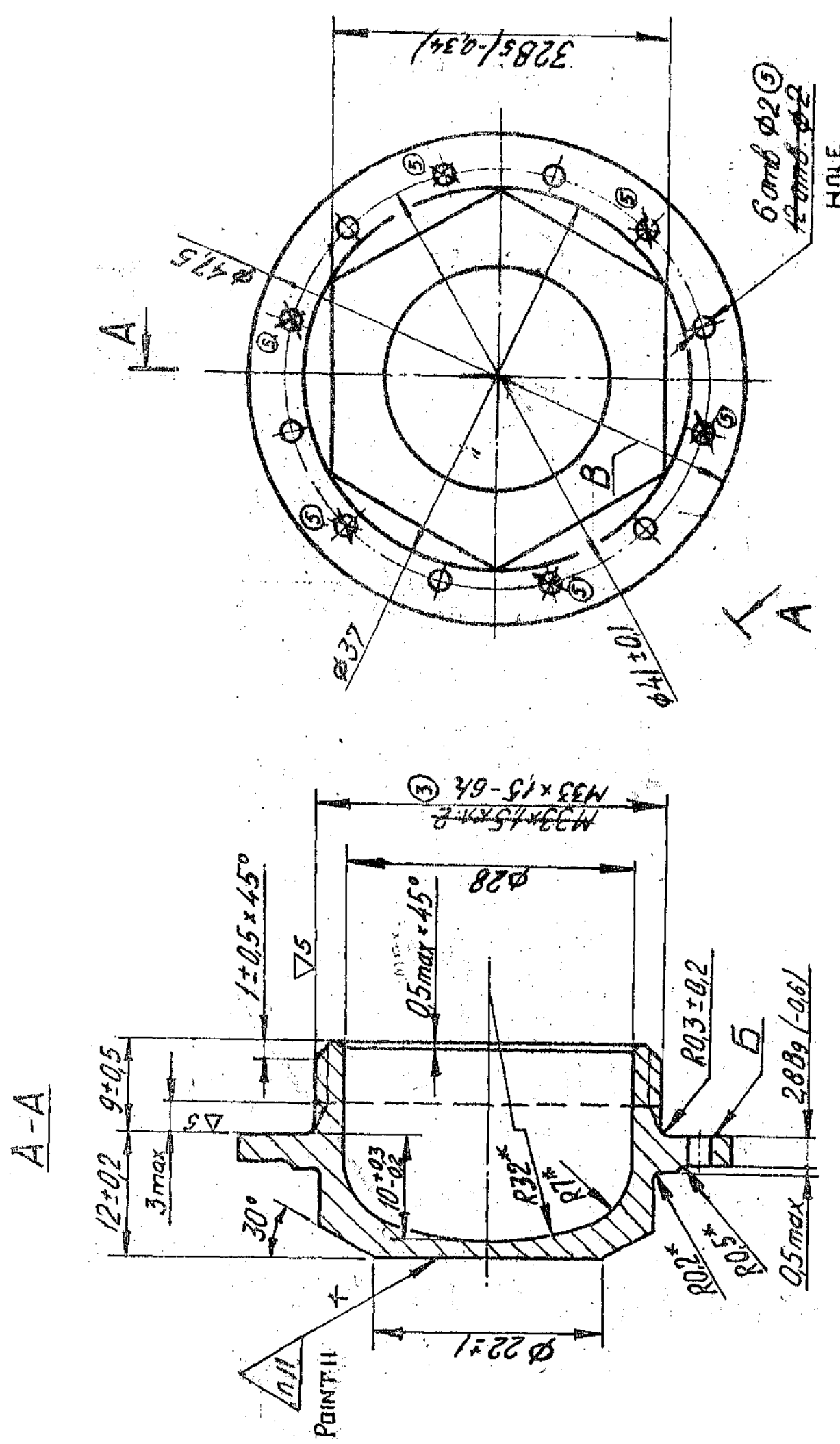
14. REFERENCE NOTE 6 ON ALTERNATE MATERIAL, CASTING OF UNALLOYED STRUCTURAL STEEL GRADE 45A TO GOST 977-75.

a) CHEMICAL COMPOSITION

GRADE OF STEEL	CONTENT OF ELEMENTS %						
	C	Mn	Si	P	S	Cr	Ni
45A	0.42-0.50	0.40-0.90	0.20-0.52	0.045	0.04	0.30	0.30

b) MECHANICAL PROPERTIES UNDER NORMALIZING CONDITION:

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH $Kgf/mm^2$	YIELD POINT $Kgf/mm^2$	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH $GTH Kgm/cm^2$
45A	55	32	12	20	3.0



2. UNSPECIFIED TOLERANCES OF DIMENSIONS SHOULD AS PER ACCURACY CLASS 7 OST 1010

3. THREADED SURFACE SHOULD BE CLEAN WITH-OUT SCORES, BURRS, STRIPPED THREAD NICKS, CORROSION MARKS AND OTHER SURFACE DEFECTS.

4. NON SQUARENESS OF SURFACE  $\phi$  RELATIVE TO THE THREAD AXIS SHOULD NOT EXCEED 0.1mm WHEN MEASURED WITHIN THE COMPONENT DIMENSIONS.

5. THE TOOL DIGGING INTO CYLINDRICAL SURFACE TO A DEPTH NOT EXCEEDING 0.3mm IS ALLOWED WHILE FACING SURFACE

6. MAY BE MANUFACTURED BY PRECISION CASTING FROM STEEL 45  $\sqrt{}$  GOST 977-75

7. MAY BE MANUFACTURED FROM ROUND BAR 46-5 GOST 7417-75 WITHOUT MACHINING ON DIMENSION B.

9. COATING: Cd 3, CHROMATIZING ACCORDING TO ULL 104 WITH SUBSEQUENT REMOVAL OF HYDROGEN BRITTLINESS

10. THREAD MAY NOT BE COATED.

11. TO BE PUNCH MARKED.

12. DIMENSIONS SHOULD BE ENSURED BY TOOL.

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

EST WT 0.060 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.	

ISSUE DATE	NATURE OF AMENDMENTS	ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
				310-11

DATE	APPROVED	SCALE	TITLE
04-4-80		2:1	COVER DISTRIBUTOR DISC

ORIGIN	DESIGNED	DRAWN	CHECKED	APPROVED	DATE	SCALE	TITLE
					04-4-80	2:1	COVER DISTRIBUTOR DISC

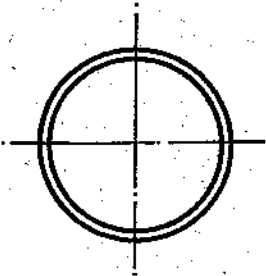
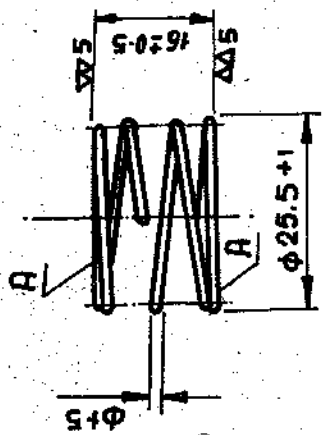
  

MATERIAL	USED ON
STEEL 45 GOST 1050-74	CS 310-30A C6

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
--

DRAWING NUMBER  
310 12



1. NON SQUARENESS OF SURFACES 'A' RELATIVE TO THE AXIS SHOULD NOT EXCEED 1.0mm (ON SQUARE) ON LENGTH OF THE SPRING
2. THE INCREASE OF OUTER DIAMETER OF THE RESTING COILS MAY BE UPTO 27mm.
3. THE GAP UPTO 0.25mm IS ALLOWED BETWEEN THE COMPRESSED COILS.
4. THE GAP BETWEEN THE SURFACE PLATE AND GROUND SURFACE OF COIL SHOULD NOT EXCEED 0.3mm ON LENGTH OF 1/8 OF THE CIRCUMFERENCE.
5. BURRS ARE NOT PERMISSIBLE.
6. COATING: Zn 12, CHROMATIZING AS PER V.I.T - 483.82.

NUMBER OF WORKING COILS	3.5
TOTAL NUMBER OF COILS	6-0.5
LENGTH OF DEVELOPMENT	453
DIRECTION OF COILING	R H

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

EST. WT 0.0056 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

### EXPLANATORY NOTE:

#### 7. REFERENCE MATERIAL QUOTED:

CARBON STEEL SPRING WIRE OF CATEGORY II, NORMAL ACCURACY  $\phi 1.5\text{mm}$   
 NORMAL ACCURACY ( $\pm 0.03$ ) TO GOST 9389-75 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL TO GOST 1050-74.  
 a) MECHANICAL PROPERTIES AS PER 9389-75.

CATEGORY	ULTIMATE TENSILE STRENGTH Kg/mm <sup>2</sup>	NUMBER OF BENDS.	NUMBER OF TWISTS
II	190 - 225	15	17

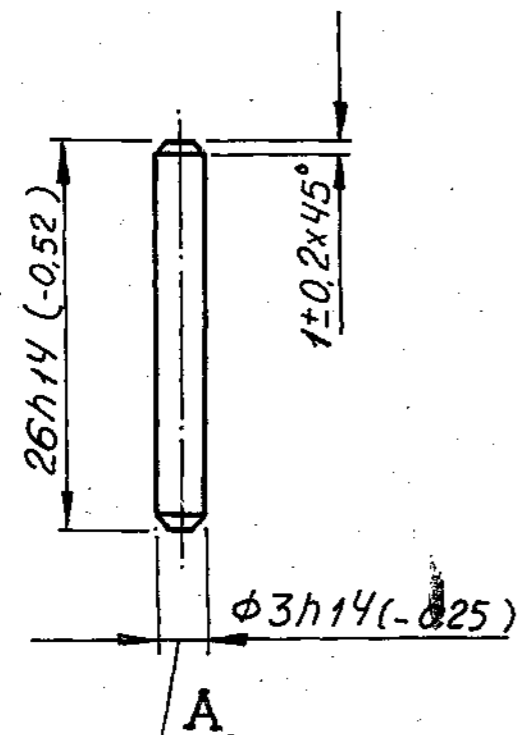
310 12

ORIGIN	CHD	TCD	APPO	DATE	SCALE: 1:1	ORIGIN	CHD	TCD	APPO	DATE	SCALE: 1:1
MATERIAL: WIRE II 1.5 GOST 9389-75						USED ON: CB 310 30A CB					
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI						TITLE: SPRING COUPLING					
DIMENSION IN mm TOLERANCE ON DIMNS UNLESS OTHERWISE STATED						D S CAT NUMBER 310 12					
ALL THREADS TO CONFORM TO						DRAWING NUMBER 310 12					

DRAWING NUMBER

310-13

Rz4.0



1. COATING : CHEMICAL OXIDIZING OIL FINISHING.
2. ALTERNATE MATERIALS STEEL Y7,Y7A,Y8 GOST 1435-74.
3. MAY BE MANUFACTURED FROM ROUND BAR  $\frac{3-4}{45-B}$  GOST 7417-75  
OR WIRE II-3 GOST 9389-60 WITHOUT MACHINING ON DIMENSION 'A'.

### EXPLANATORY NOTE

4. REFERENCE MATERIAL QUOTED: HIGH GRADE SIZED STEEL ROUND TO GOST 1051-73 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL GRADE 45 TO GOST 1050-74.
- a) CHEMICAL COMPOSITION AS PER GOST 1050-74

GRADE OF STEEL	CONTENT OF ELEMENTS %					
	C	Si	Mn	Cr	S	P
45	0.42-0.50	0.17-0.37	0.50-0.80	0.25	0.040	0.035

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH.

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

EST WT 0.001 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

- b) MECHANICAL PROPERTIES UNDER NORMALISED CONDITION AS PER GOST 1050-74

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kg/mm <sup>2</sup>	YIELD POINT Kg/mm <sup>2</sup>	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH Kgfm/cm <sup>2</sup>	HARDNESS BHN
45	61	36	16	40	5	229

5. REFERENCE NOTE '2' ON ALTERNATE MATERIAL: HOT ROLLED SIZED CARBON TOOL STEEL ROUND, AND MANUFACTURED TO GROUP OF QUALITY STEEL GRADE Y7 AND Y8, GROUP OF VERY QUALITY STEEL GRADE Y7A TO GOST 1435-74

CHEMICAL COMPOSITION AS PER GOST 1435-74.

Gde. OF STEEL	CONTENT OF ELEMENTS %							
	C	Mn	Si	S	P	Cr	Ni	Cu
Y7	0.65-0.74	0.20-0.40	0.15-0.35	0.030	0.035	0.20	0.25	0.25
Y8	0.75-0.84	0.20-0.40	0.15-0.35	0.030	0.035	0.20	0.25	0.25
Y7A	0.65-0.74	0.15-0.30	0.15-0.35	0.020	0.030	0.15	0.20	0.20

6. A. REFERENCE NOTE '3' ON ALTERNATE MATERIAL: COLD ROLLED SIZED STEEL ROUND BAR  $\phi 3(-0.060)$ mm CLASS OF ACCURACY TO GOST 7417-75, HIGH GRADE SIZED STEEL ROUND GROUP OF SURFACE QUALITY 'B' TO GOST 1051-73 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL Gde 45 TO GOST 1050-74

a) CHEMICAL COMPOSITION AS PER GOST 1050-74

GRADE OF STEEL	CONTENT OF ELEMENTS %					
	C	Si	Mn	Cr	S	P
45	0.42-0.50	0.17-0.37	0.50-0.80	0.25	0.040	0.035

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH.

b) MECHANICAL PROPERTIES UNDER NORMALISED CONDITION AS PER GOST 1050-74

Gde. OF STEEL	ULTIMATE TENSILE STRENGTH Kg/mm <sup>2</sup>	YIELD POINT Kg/mm <sup>2</sup>	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH Kgfm/mm <sup>2</sup>	HARDNESS BHN
45	61	36	16	40	5	229

- B. CARBON STEEL SPRING WIRE CATEGORY II,  $\phi 3.0$ mm NORMAL ACCURACY  $\pm 0.03$  TO GOST 9389-75 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL TO GOST 1050-74

MECHANICAL PROPERTIES AS PER GOST 9389-75

CATEGORY	ULTIMATE TENSILE STRENGTH Kg/mm <sup>2</sup>	No. OF BENDS MIN	No. OF TWISTS MIN
II	165-190	5	13

7. REFERENCE NOTE 1, ON PROTECTIVE FINISH: OXIDIZED - COPPER FINISH TO IS : 1378-79 AND OIL FINISH.

DRN	CHD	TCD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	ALL THREADS TO CONFORM TO	ISSUE	DATE	NATURE OF AMENDMENTS
					2:1						
MATERIAL						STEEL 45 GOST 1051-73		USED/ON			
								CS 310-30A CS			
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)								AVADI			
TITLE								PIN DOWEL			
D S CAT NUMBER						DRAWING NUMBER					
						310-13					

8

7

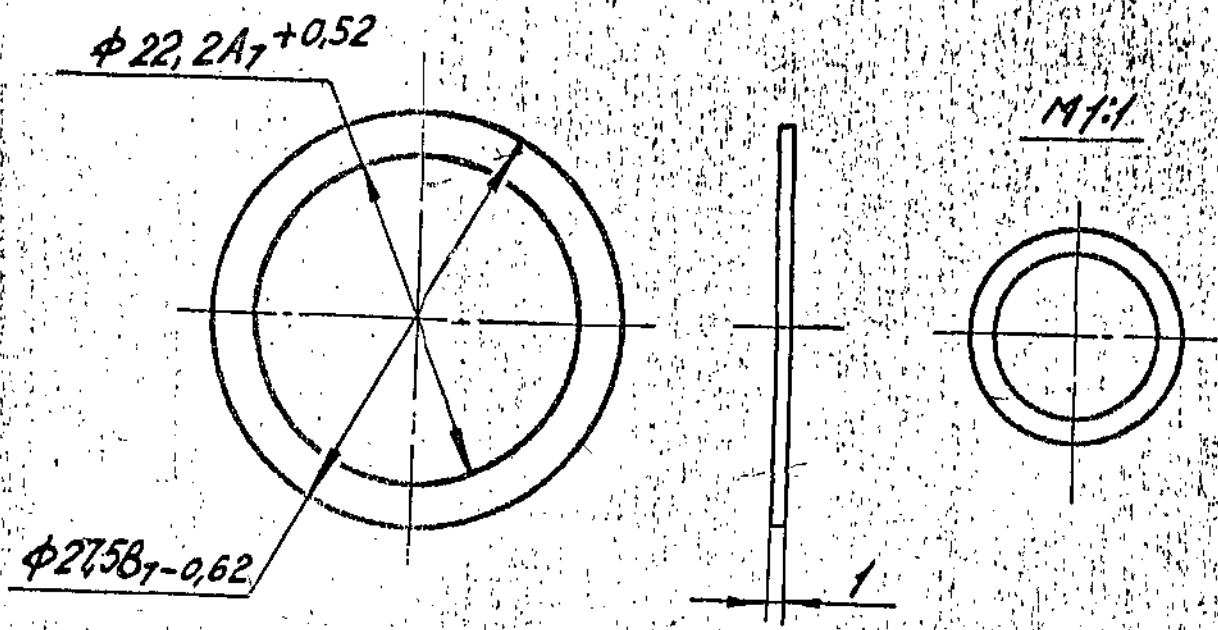
6

ZE A2

310-17-1

2

DRAWING INDIANISED BASED ON ISSUE 4



1. Требования, предъявляемые к штамповке, по нормам 82050-16.  
 2. Острые кромки затупить.  $R_{a 9}$  по ИЛ-104  
 3. Покрытие Цб-хр-по-ЦА-483-82  
 4. Заменитель материала сталь марок 10КП, 15КП, ГОСТ 1050-74 и лист 1 ГОСТ 19904-74 II-10 ГОСТ 16523-70

1. REQUIREMENTS FOR STAMPED COMPONENT SHOULD BE AS PER STANDARD 82050-16
2. SHARP EDGES SHOULD BE BLUNTED.
3. COATING: Zn6, CHROMATIZING AS PER ИЛ - 483-82
4. ALTERNATE MATERIAL: STEEL GRADES 10KP, 15KP, GOST 1050-74 OR SHEET 1 GOST 19904-74 II-10 GOST 16523-70

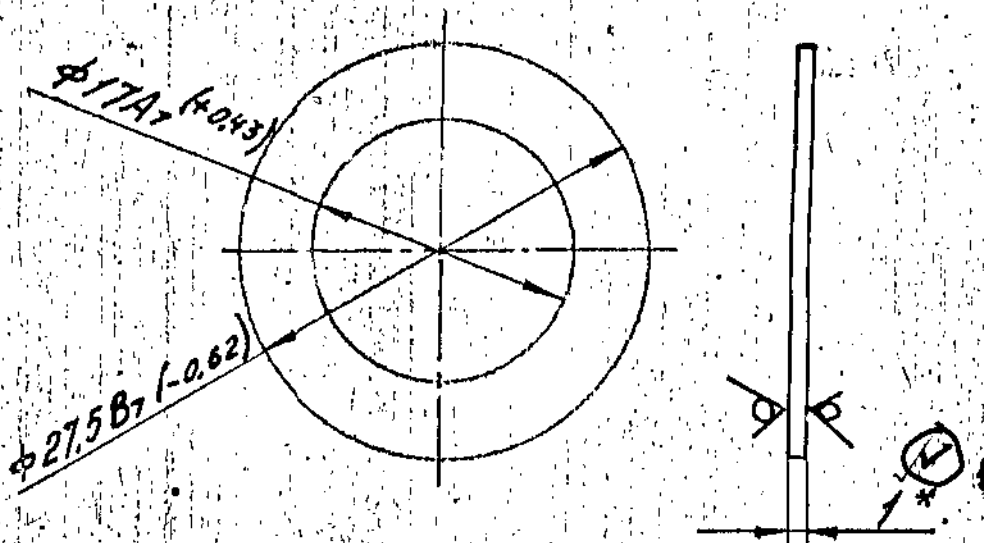
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

		EST MASS 0.0015 kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)	A 5 114
		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:- STRIP 10-8H- 2-1 GOST 503-81	USED ON:- C8 310-30A	
CPD <i>[Signature]</i>	DIMENSIONS IN mm			
TCD <i>[Signature]</i>	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
APPD <i>[Signature]</i>		TITLE:- <b>WASHER</b>		
DATE 19.12.87	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER <b>310-17-1</b>	

310-18-1

ЕЛКА

DRAWING INDIANISED BASED ON ISSUE 3



6. REPAIR SIZE DIMENSIONS ARE ADDED BASED ON LT NO: 82847/06/015/50 DT: 27 MAR 98 WHERE INDICATED THUS (4) AS FOLLOWS:

- 1. ~~Справка контроля~~ по ~~ТТ~~
- 2. Покрытие Ц.б. хр. по ~~ТТ~~
- 3. В троллическом исполнении Покрытие КД 9. хр по ЦЦЛ-104
- 4. \* Размер для справок.
- 5. Заменитель материала сталь марок 10КП, 15КП, ГОСТ 1050-74 и лист 1 ГОСТ 19904-74 II-10 ГОСТ 16523-70.

- 3. COATING: Cd 9, CHROMATIZING AS PER ЦЦЛ -104
- 4. DIMENSION FOR REFERENCE.
- 5. ALTERNATE MATERIAL: STEEL GRADES 10KP, 15KP, GOST 1050-74 OR SHEET 1 GOST 19904-74 II-10 GOST 16523-70

Sl No	R1	R2	REMARKS
(4)	1.5	2.0	ALL OTHER CONDITIONS AS PER STD DRG. MODEL REPAIR SIZE

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

EST MASS  
0.0025kg

TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)

A 5  
115

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

CHD DIMENSIONS IN mm

TCD TOLERANCE ON DIMNS UNLESS OTHERWISE STATED

APPD ALL THREADS CONFORM TO

DATE 19/11/67

MATERIAL:- 10-8H-2-1 GOST 503-81

USED ON:- C6 310-30A

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI



TITLE:-

WASHER

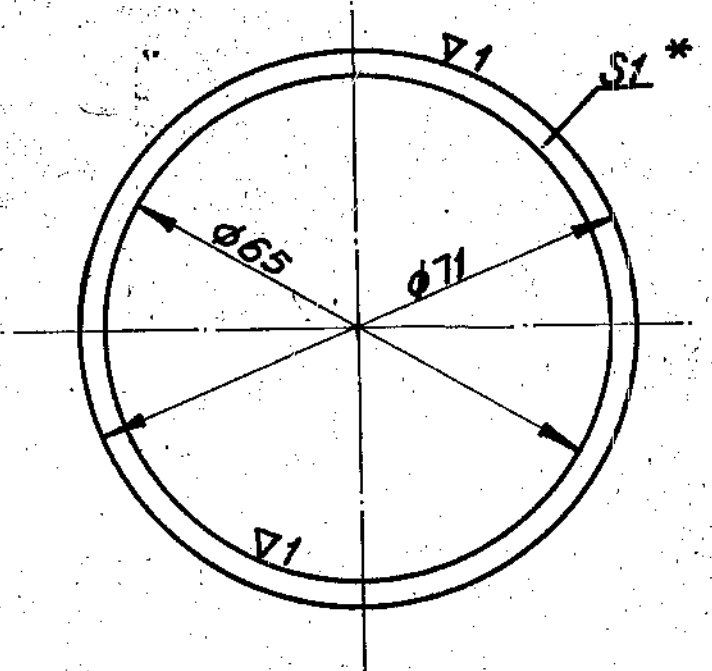
D S CAT NUMBER

DRAWING NUMBER

310-18-1

# EXPLANATORY NOTE:

EU (D)



## 5. REFERENCE MATERIAL QUOTED:

ALUMINIUM ALLOY SHEET GRADE A11, ANNEALED 'M' 1mm THICK, AND REFERENCE NOTE 4, ON ALTERNATE MATERIAL ALUMINIUM ALLOY GRADE A10, ANNEALED 'M' 1mm THICK, MANUFACTURED IN ACCORDANCE WITH ALUMINIUM ALLOY TO GOST 4784-74.

a) CHEMICAL COMPOSITION AS PER GOST 4784-74.

GRADE OF ALLOY	ALLOYING CONSTITUENTS %	IMPURITIES MAXIMUM							OTHER IMPURITIES EACH INDIVIDUALLY
		Fe	Si	Cu	Mn	Zn	Ti	Mg	
A11	99.3 min	0.30	0.30	0.05	0.025	0.1	0.1	0.05	0.02
A10	99.5 min	0.30	0.30	0.02	0.025	0.1	0.1	0.05	0.02

b) MECHANICAL PROPERTIES UNDER ANNEALED CONDITION AS PER GOST 21631-76.

GRADE OF ALLOY	TENSILE STRENGTH Kgf/mm <sup>2</sup>	ELONGATION %
A11 A10	6.0	28

1. REQUIREMENTS FOR STAMPED COMPONENT SHOULD BE AS PER STANDARD B2050-16.
2. TO BE ANNEALED AFTER STAMPING.
3. \* DIMENSION FOR REFERENCE.
4. ALTERNATE MATERIAL: SHEET 1 A10M GOST 21631-76.

USED ON:  
Cb-20-01-00-8  
Cb-20-10-00-4  
CB 310-30A CB

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

EST WT 0.0016 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	CHD	TCD	APPD	DATE	SCALE: 1 : 1	MATERIAL: SHEET TIA11M GOST 21631-76	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI
					DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69	TITLE GASKET
					ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER 310 19
ISSUE	DATE	NATURE OF AMENDMENTS					

A-5

SIZE A3