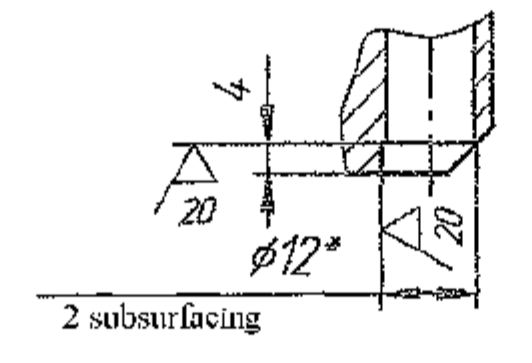
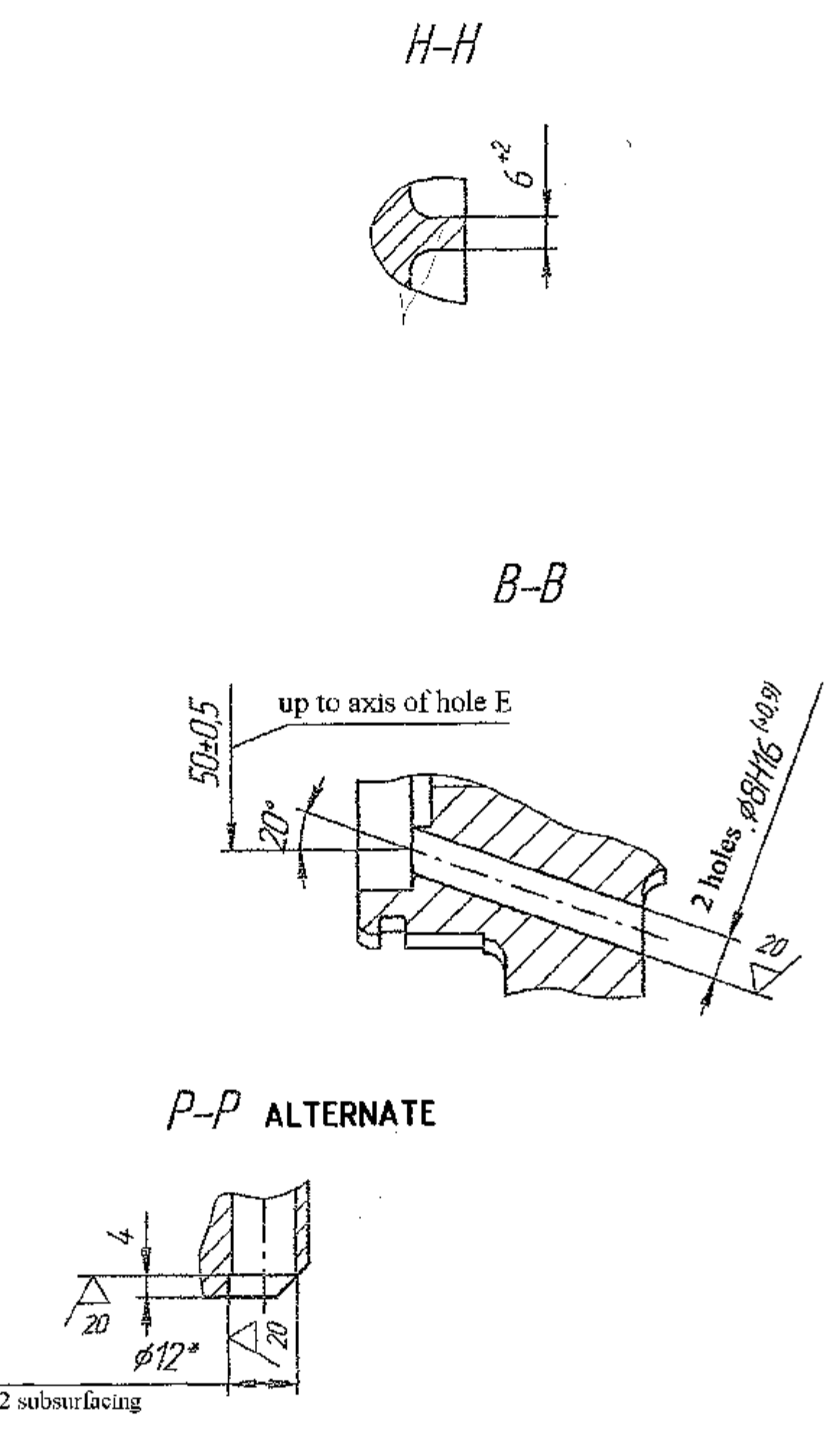
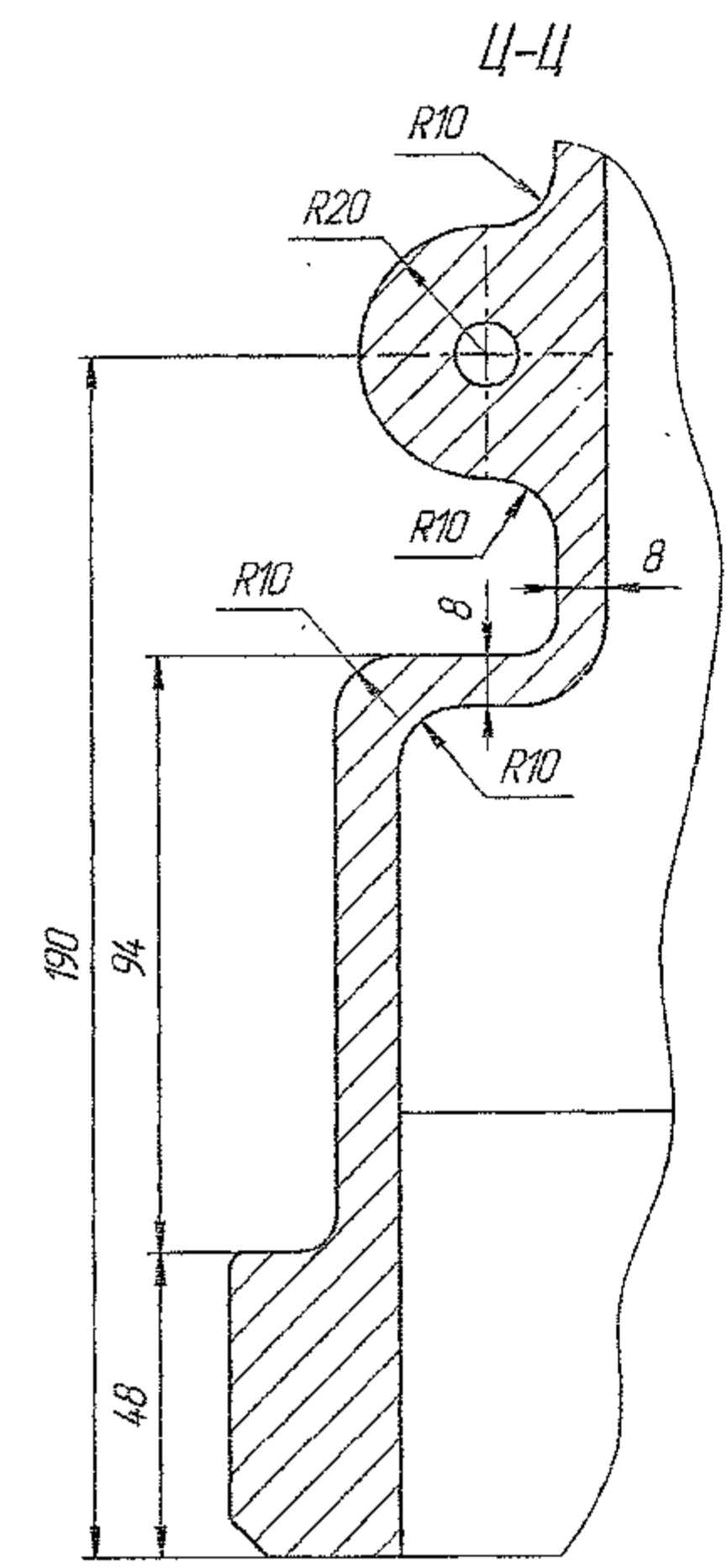
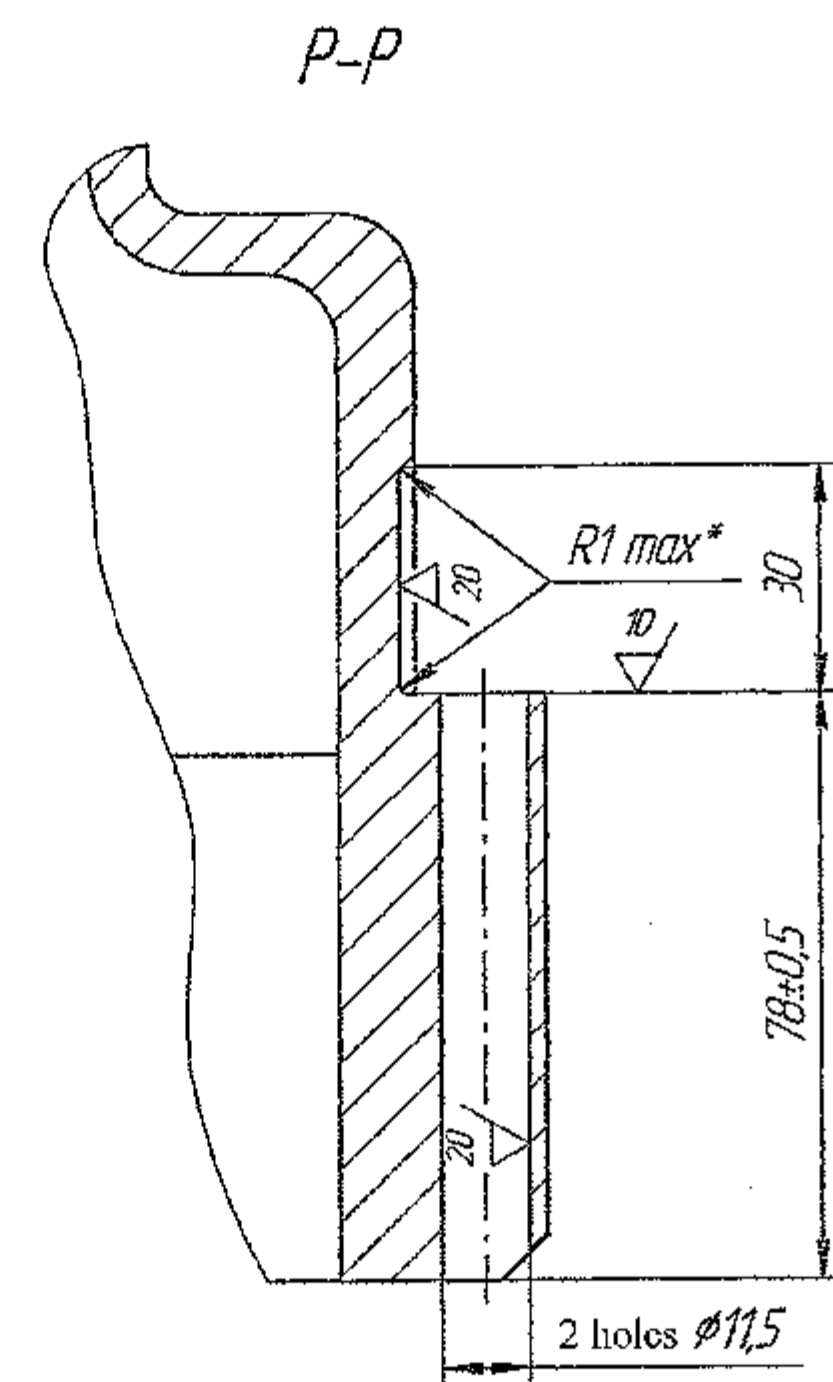
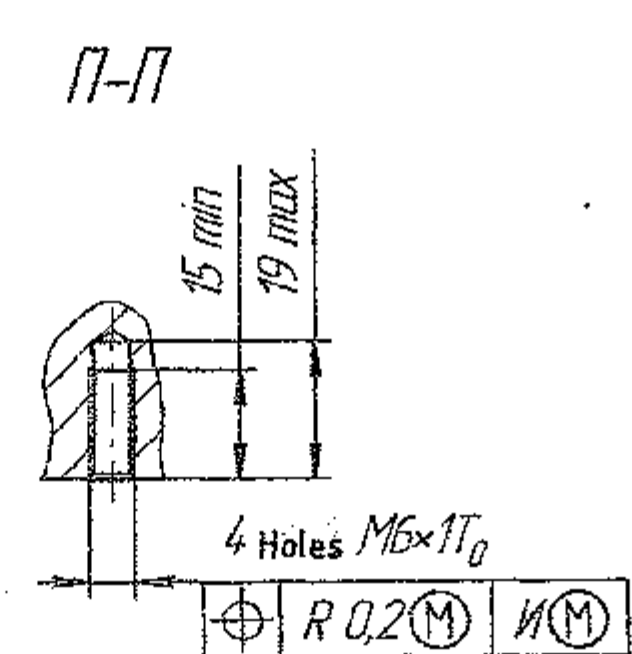
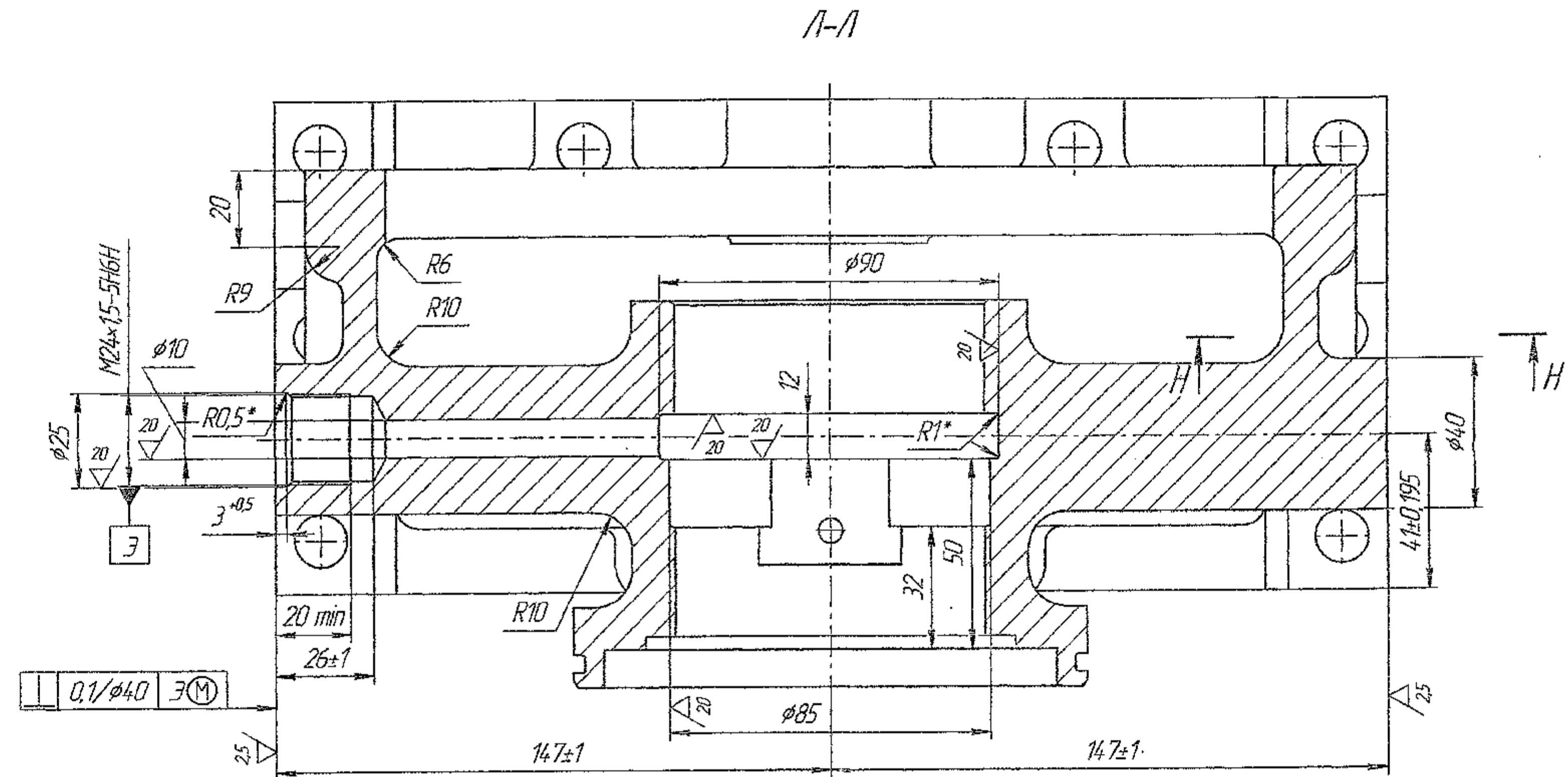
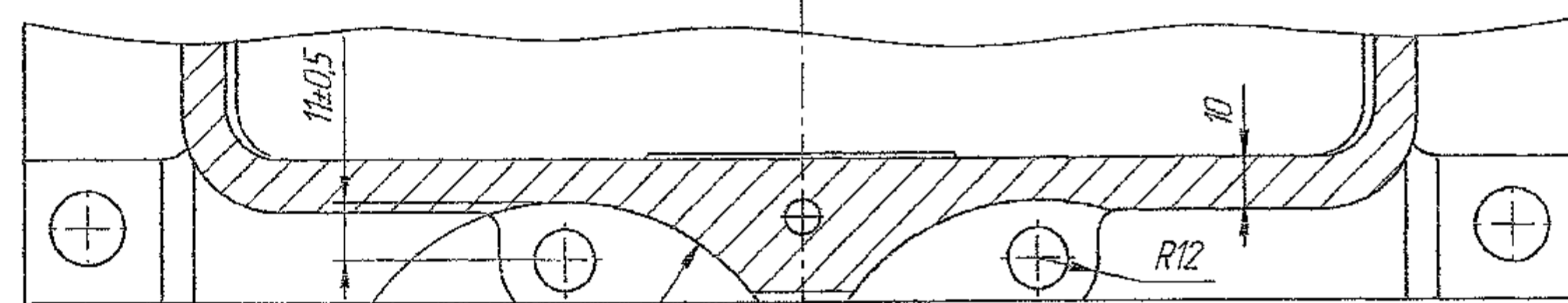
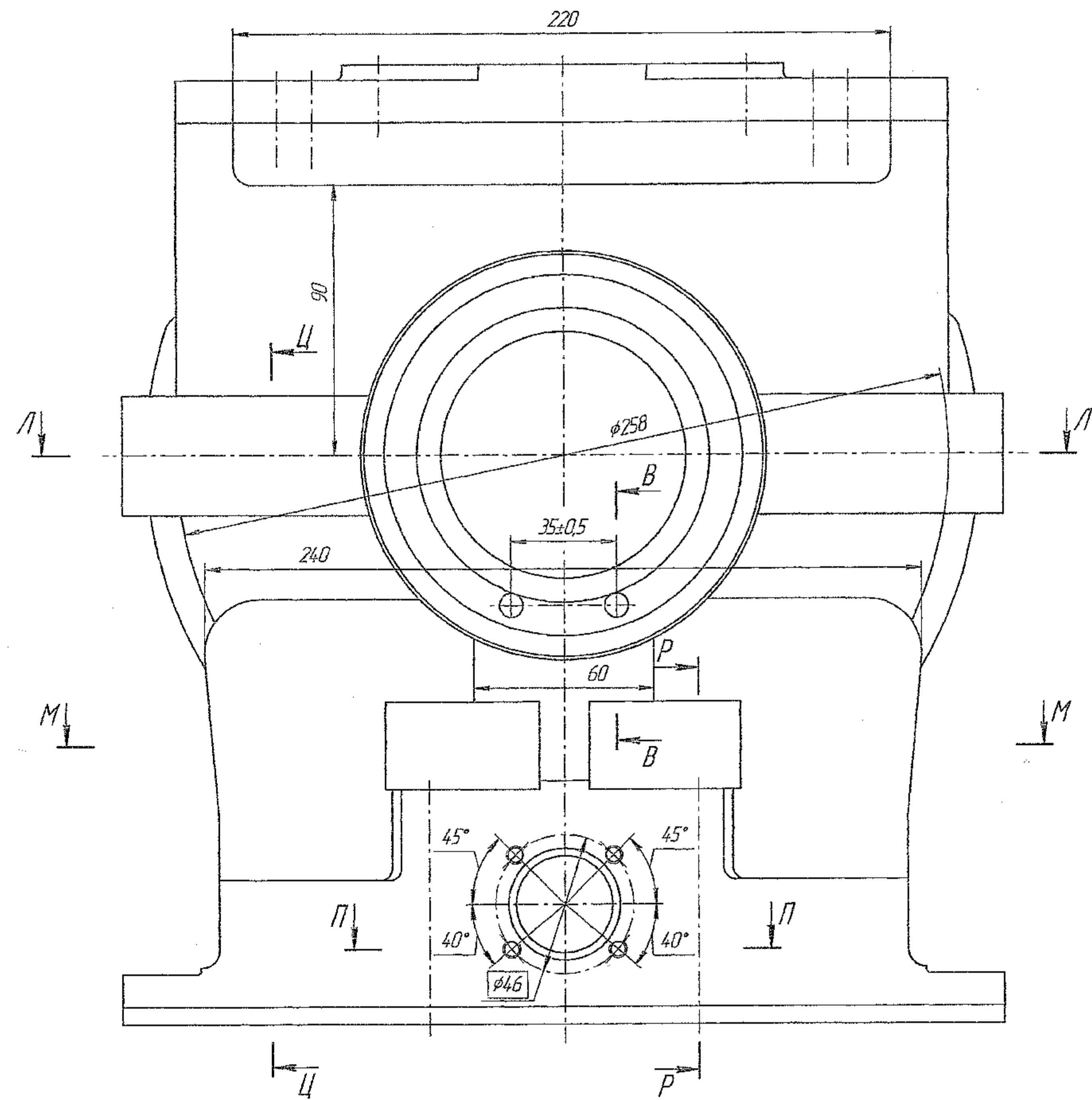


sheet 1



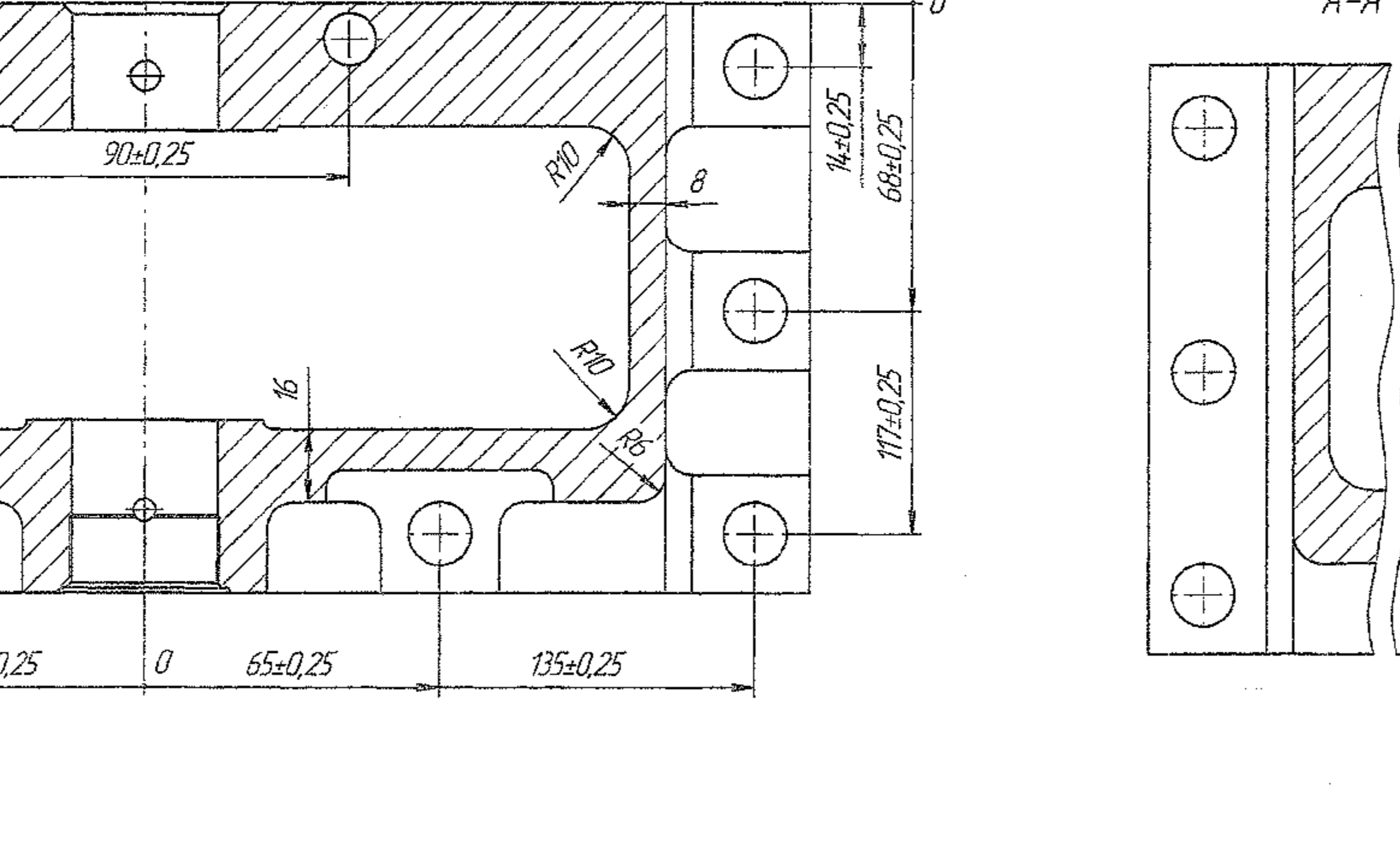
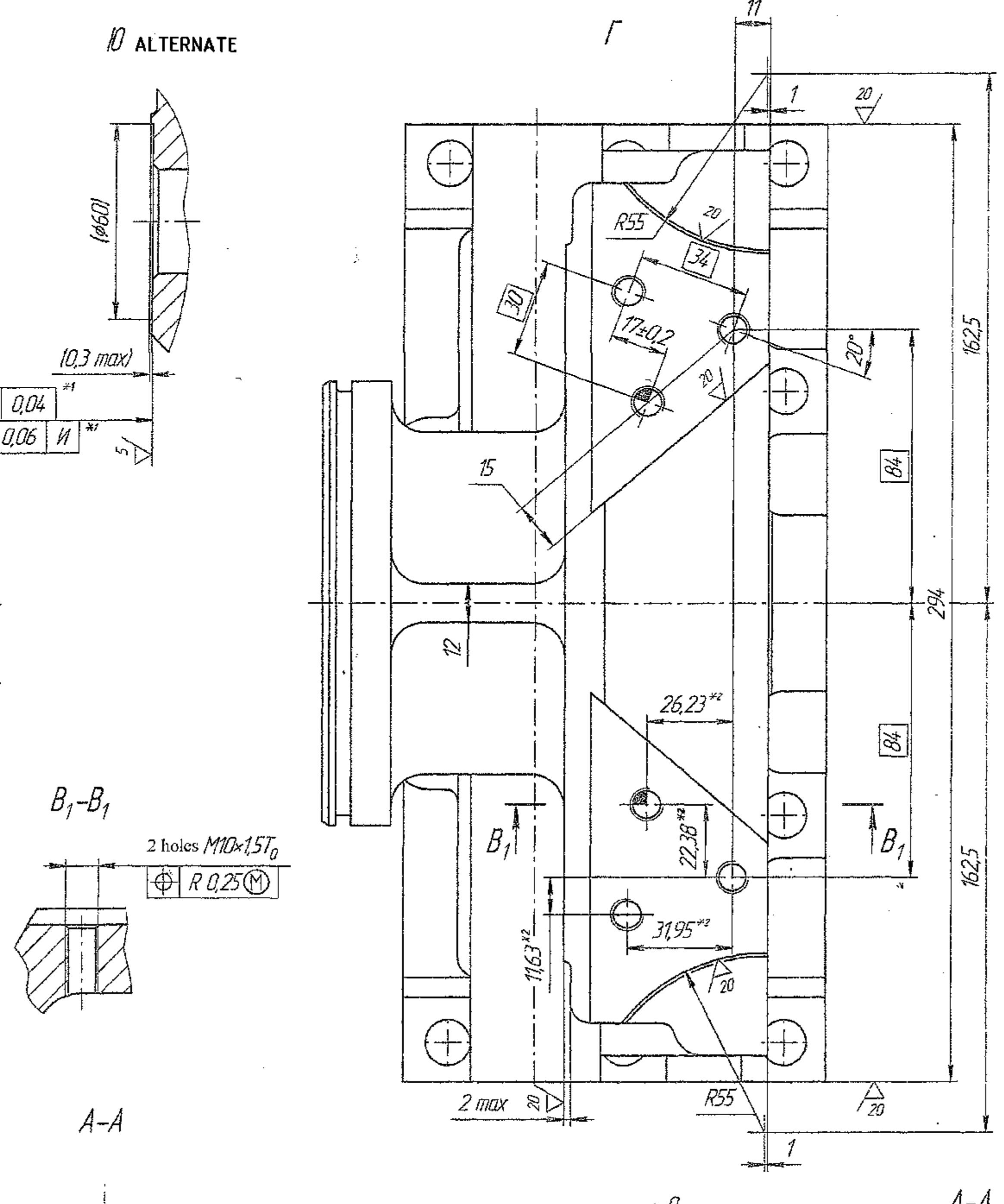
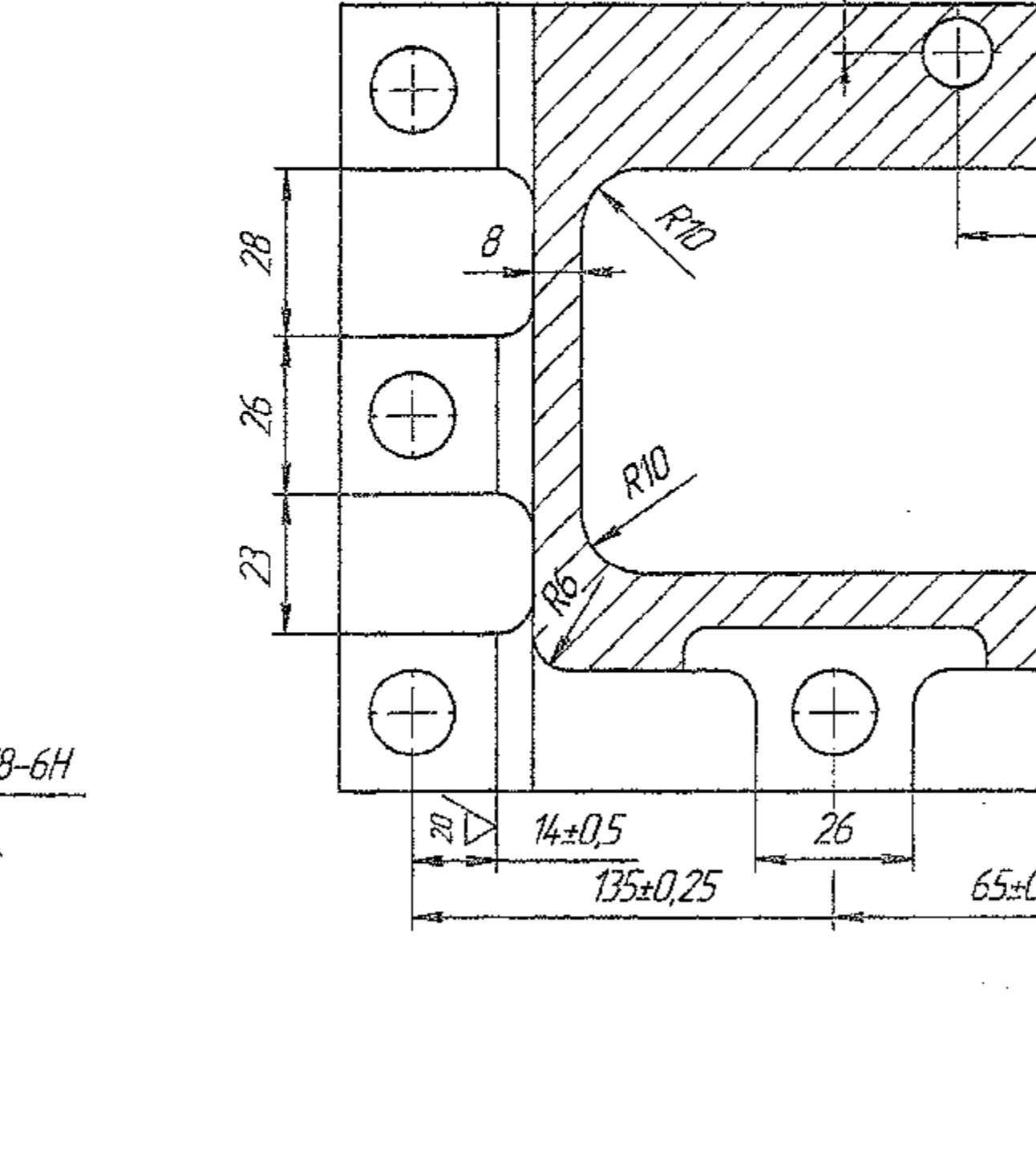
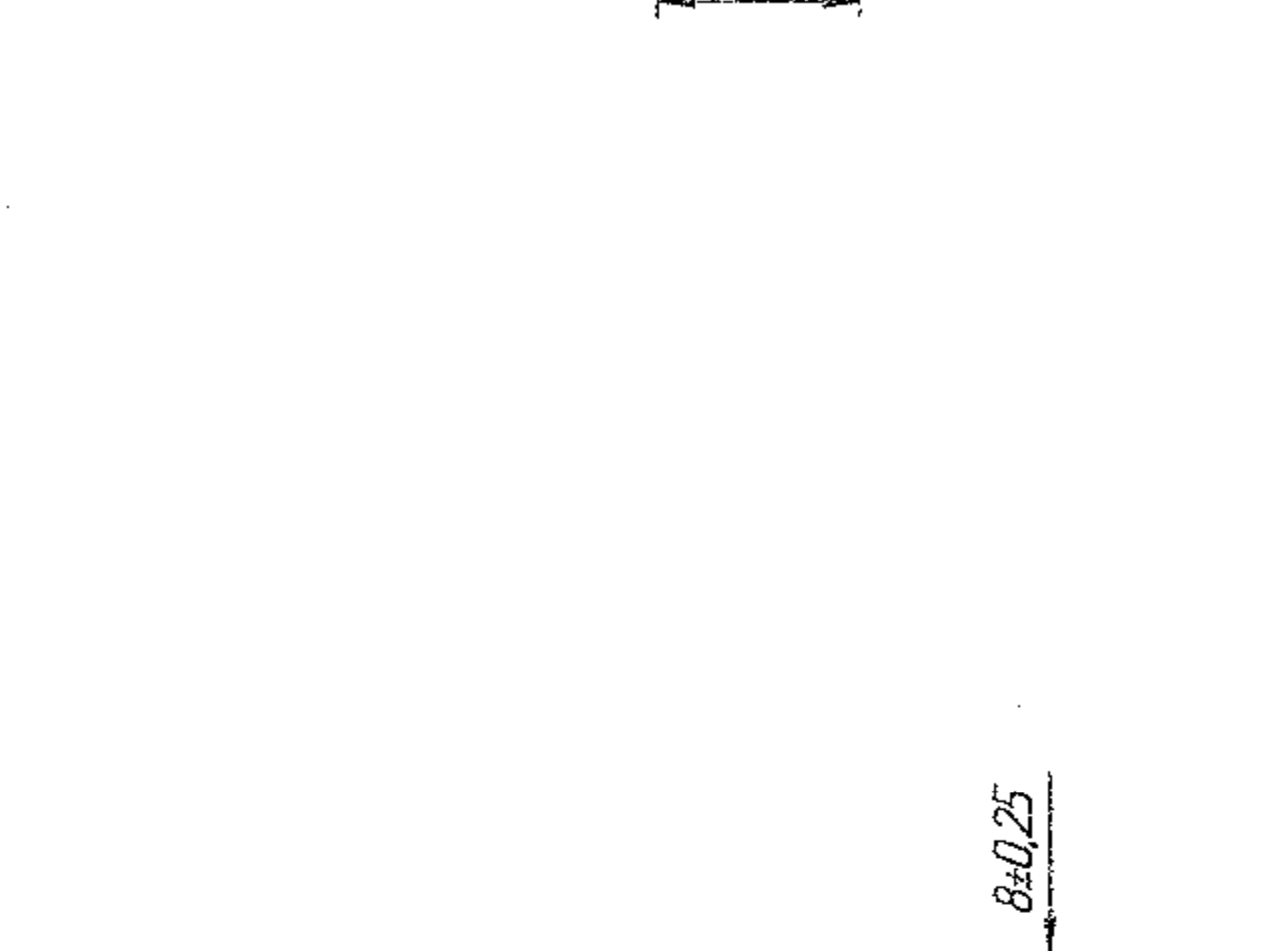
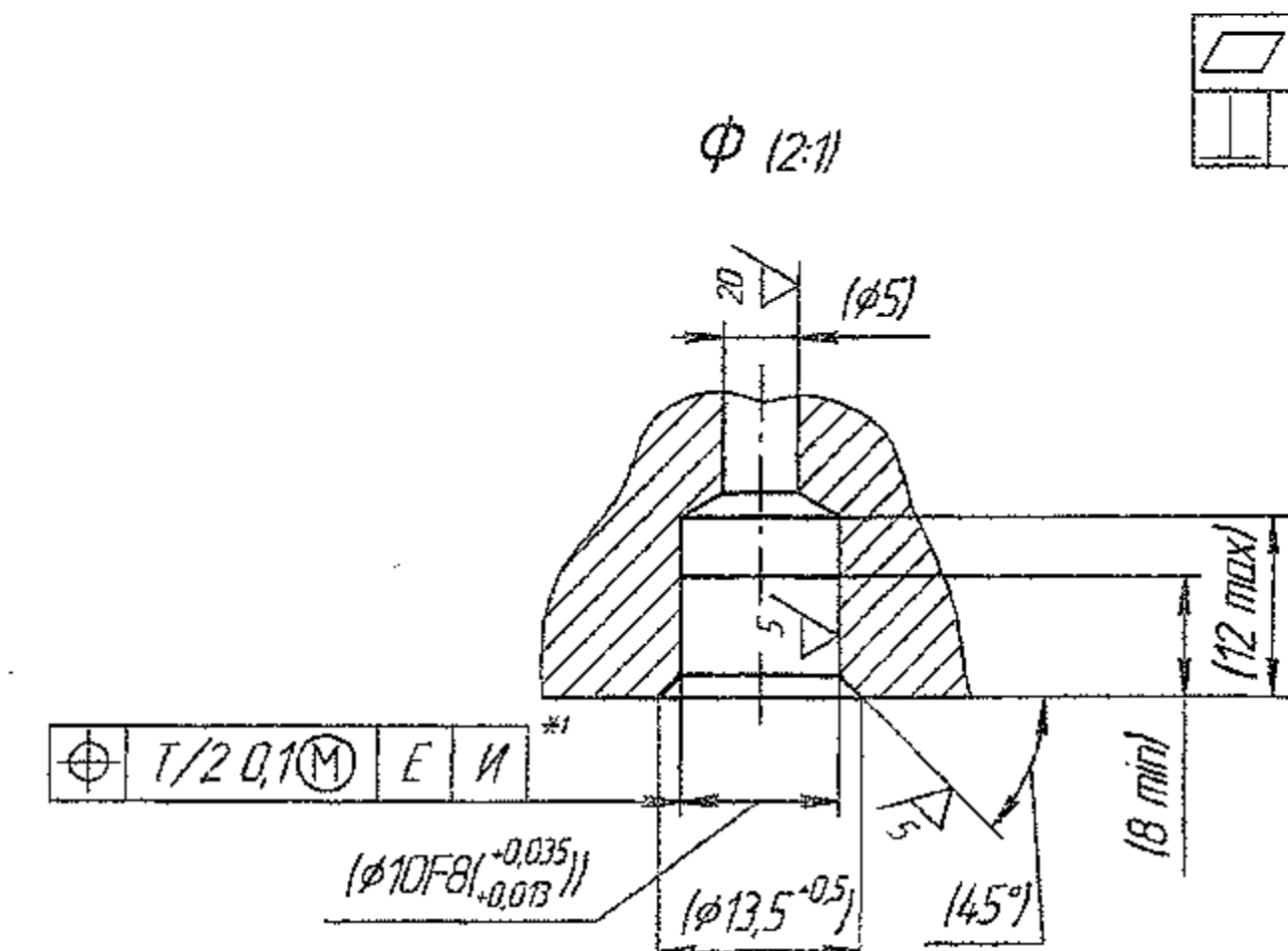
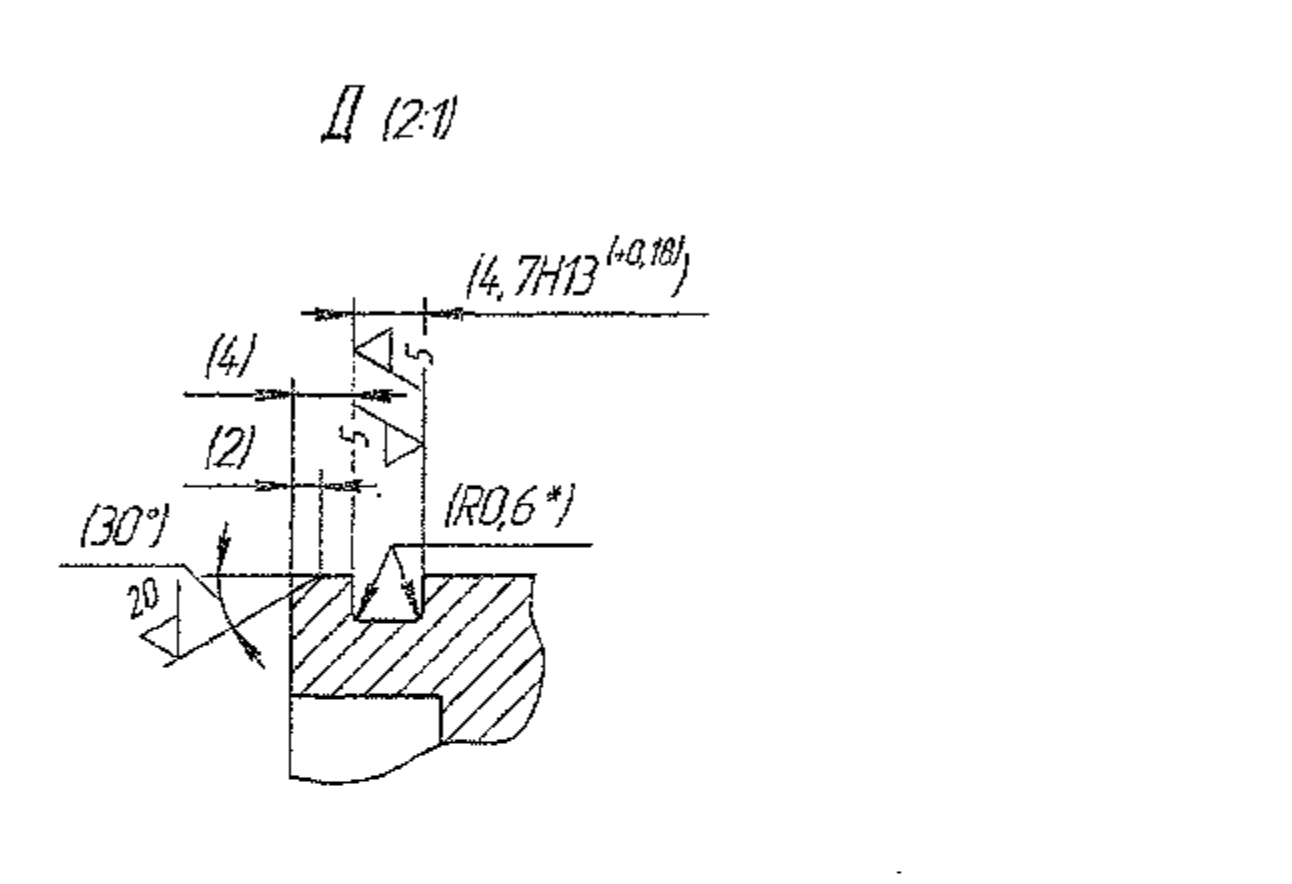
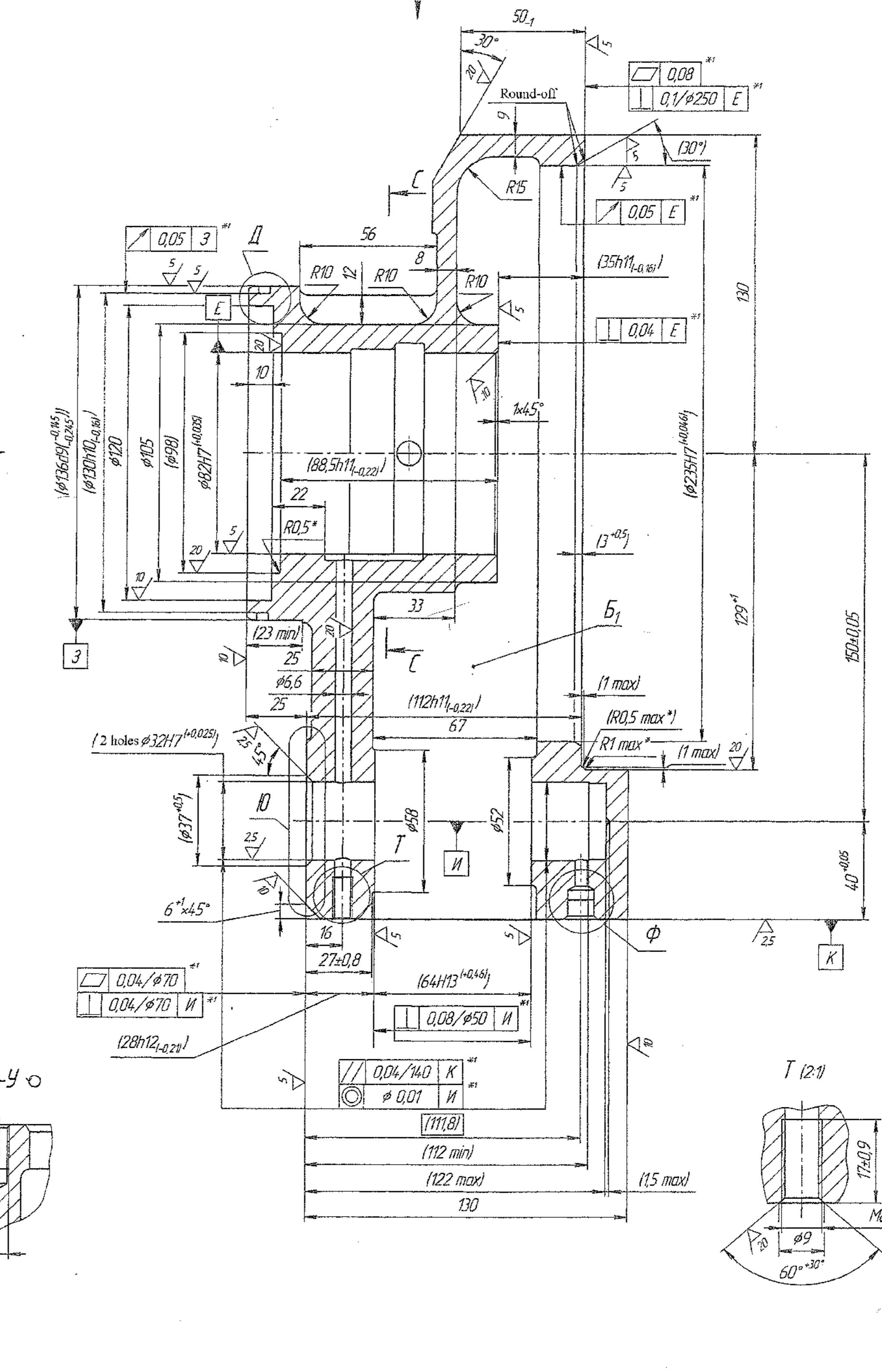
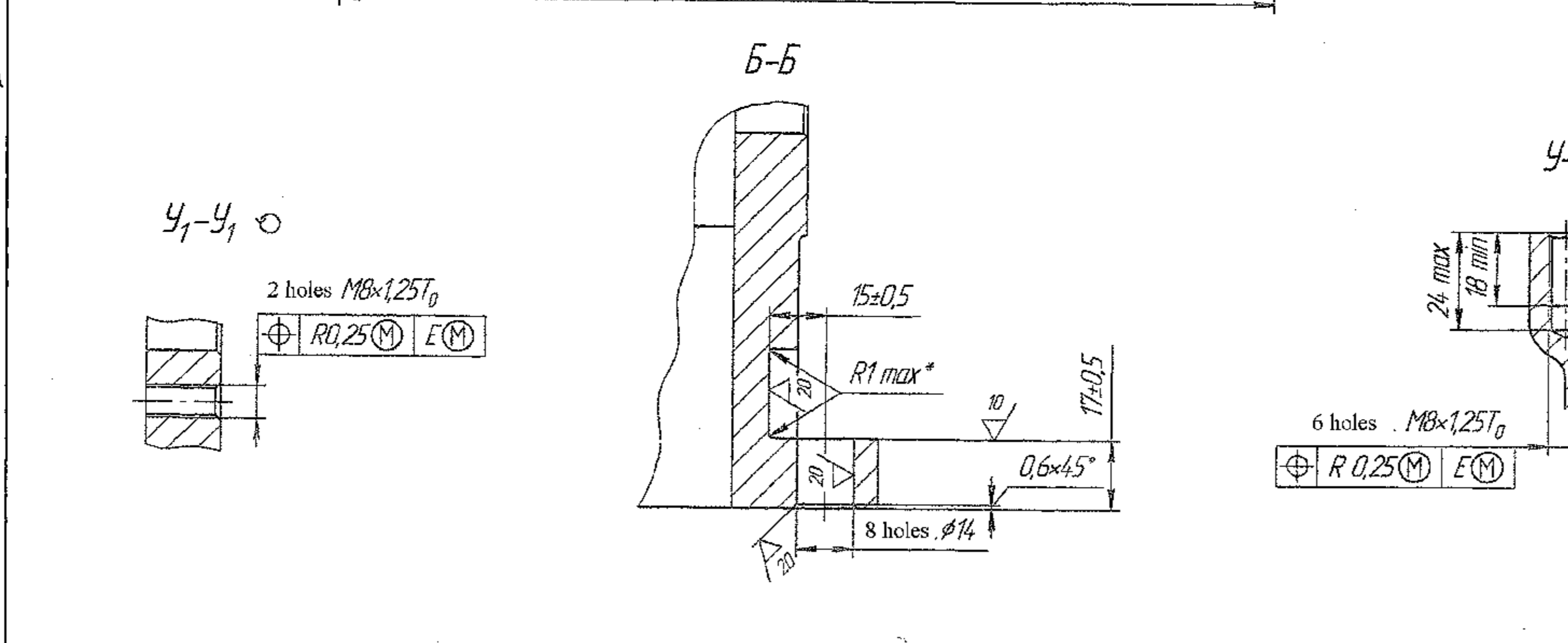
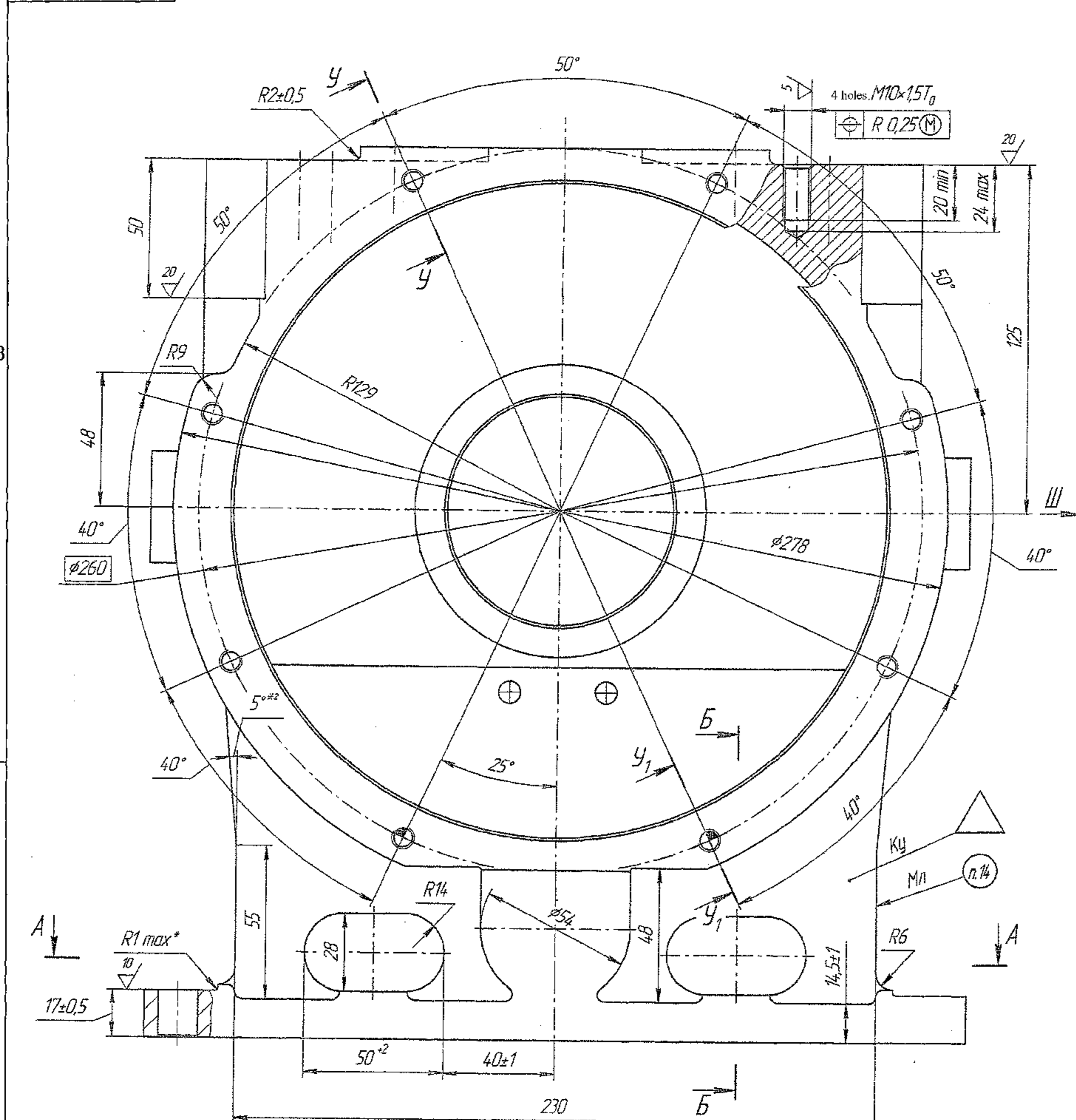
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. WT. (G) 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	AK 74	MATERIAL	GOST AK 74(A/19)1583-93	USED ON	Cb.3308-04-24
CHD		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)		AVADI	
APPD		TITLE		FUEL PUMP DRIVE HOUSING	
DATE	03-2-09	D S CAT NUMBER		DRAWING NUMBER 308-30-25 SHEET 2 OF 2	
SCALE		DIMENSIONS IN mm		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69	
ALL THREADS TO CONFORM TO		ISSUE		DATE	
NATURE OF AMENDMENTS					





1. Requirement, present to casting as per TTM 65-78.
 2. Hardness ≥ 80 HB.
 3. Unspecified limit deviations of casting dimensions:
 - up to 50 mm ± 0.15 mm
 - from 50 mm to 250 mm ± 0.2 mm
 - from 250 to 500 mm ± 0.3 mm
 - thickness of wall ± 0.2 mm
 - radius up to 10 mm ± 0.15 mm, from 10 mm to 30 mm ± 0.2 mm, from 30 mm to 80 mm ± 0.3 mm, above 80 mm ± 0.5 mm.
 4. Unspecified casting radii 3...5 mm.
 5. Unspecified casting inclines up to 3°.
 6. Unspecified limit deviation of dimensions of machining: H14, h14, $\pm \frac{IT14}{2}$.
 7. Dimensions, given in bracket - after assembly.
 8. Check the deviation from planeness of surface K "by paint", preparation and putting as per instruction ИИ-613-85. Adjoining should be even and occupy not below 70% of surface, check selectively not below 10% of parts.
 9. Technical requirement on thread is carried out as per standard 82021-00.
 10. It is permitted to carry out element Φ in part 308-30-25.
 11. Check the cavity B1 for airtightness by air in water with pressure 0.1...0.2 MPa (1...2 kg/cm²) for two minutes minimum. Passing of air is not permitted. It is permitted to carry out checking for airtightness by water at temperature 60...80 °C with pressure 0.3...0.05 MPa (3...0.5 kg/cm²) for five minutes minimum. Leakage of water is not permitted.
 12. Check oil pipe for airtightness by air in water with pressure 0.2...0.1 MPa (2...1.0 kg/cm²) for two minutes minimum. Passing of air is not permitted.
 13. Coating of non-machined surfaces by bakelite varnish as per ИИ-665-86. Absence of coating during manufacturing in metallic form is permitted.
 14. Mark the grade of material of casting as per GOST 2171-90 having letter size 10-Ип3 as per GOST 26.008-85. Marking by impact method is permitted.
 15. * Dimensions are ensured by tool.
 16. * Ensure after assembly.
 17. * Dimensions for references.

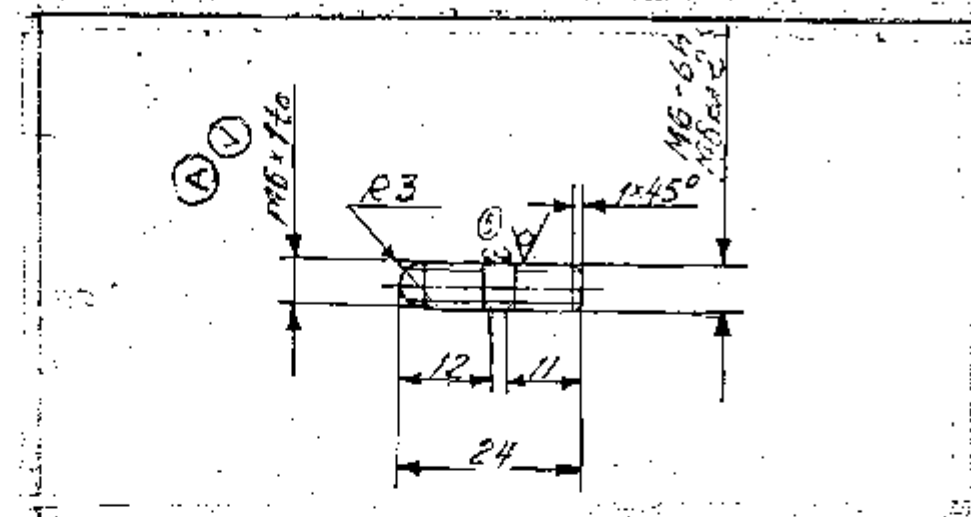
DRN	308-30-25	MATERIAL	AK7, A/99 GOST 1531-93	USED ON	Ch. 3308-04-24
СНД	10011000	CONTROL	AVADI	CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES)	AVADI
АТР	10011000	DATE	10.2.2009	SCALE	1:1
EST. WT.	640	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: ±0.10-0.09		
7.238	TO BE STAMPED OR 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.	D S CAT NUMBER		
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.		ISSUE DATE NATURE OF AMENDMENTS			

FUEL PUMP DRIVE HOUSING

DRAWING NUMBER: 308-30-25
SHEET 1 OF 2



DRAWING NUMBER
350 03



D EQUIVALENT MATERIAL STEEL
45C8 TO IS:1570

1. DELETED.
2. TECHNICAL REQUIREMENTS FOR THREADS AS PER STANDARD 82021-00.
3. DIMENSIONS WITH UNSPECIFIED TOLERANCES AND THE REST OF THE TECHNICAL REQUIREMENTS AS PER STANDARD 82052-00.
4. COATING: CADMIUM 3, CHROMATIZING AS PER ULYN-104 WITH SUBSEQUENT ELIMINATION OF HYDROGEN EMBRITTLEMENT.
5. THE THREAD MAY BE MADE BY ROLLING WITH DIAMETER OF UN-THREADED PORTION WITH IN THE PITCH DIAMETER OF THREAD.
6. MECHANICAL DAMAGES OF THE CADMIUM COATING SUCH AS SCRATCHES, NICKS AND DENTS ARE ALLOWED ON ASSEMBLY UNITS, PROVIDED THE STEEL IS NOT EXPOSED.
7. ALTERNATE MATERIAL: STEEL GRADES 40 & 50 GOST 1050-74.
8. HARDNESS:- 27-32 HRC.

* ALT MATERIAL:-
STEEL 709 M40 (EN-19) TO
BS:- 970 PT.-1- 1983

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

EXPLANATORY NOTE:

8. REFERENCE MATERIAL QUOTED:
COLD DRAWN SIZED ROUND BAR, 6.0 (-0.025)mm DIA TO GOST 7417-75 FROM HIGH GRADE SIZED STEEL NORMAL SURFACE QUALITY TO GOST 1051-73 AND MANUFACTURED IN ACCORDANCE WITH QUALITY CARBON STRUCTURAL STEEL GRADE 45 TO GOST 1050-74.
REFERENCE NOTE '7' ON ALTERNATE MATERIAL: QUALITY CARBON STRUCTURAL STEEL GRADE 40 AND 50 TO GOST 1050-74.
a) CHEMICAL COMPOSITION: AS PER GOST 1050-74.

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

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

b) MECHANICAL PROPERTIES: 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 Kgf/cm ²	HARDNESS B H N M A X	REMARKS
45	61	36	16	40	5	207	Ref,Matl
40	58	34	19	45	6	197	Alt,Matl
50	64	38	14	40	4	217	Alt,Matl

A 9. REPAIR SIZE DIMENSIONS ARE ADDED WHERE INDICATED THUS **⊕** BASED ON OVERHAUL SPECIFICATIONS PART III REPAIR DRAWINGS.

Sl.No.	R	REMARKS
1	M6 x 1.25 to	ALL OTHER CONDITIONS AS PER STD. DRG.
2	PCD = 7.188 ± 0.152	

**
Cb 306-08-8, Cb 306-09-10,
Cb 401-03-6, Cb 3301-15-30,
Cb 306-08-13, Cb 306-09-13,
Cb 3308-04-26

DRN	CHD	TCD	APPO	DATE	SCALE	MATERIAL ROUND BAR	USED ON
				30-5-86	1:1	GOST 7417-75 45 GOST 1051-73	Cb 3301-15-44 Cb 3338-402-4 Cb 3329-01-11
ISSUE DATE					CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI		
NATURE OF AMENDMENTS					TITLE: STUD M6 x 24		
D S CAT NUMBER					DRAWING NUMBER 350 03		

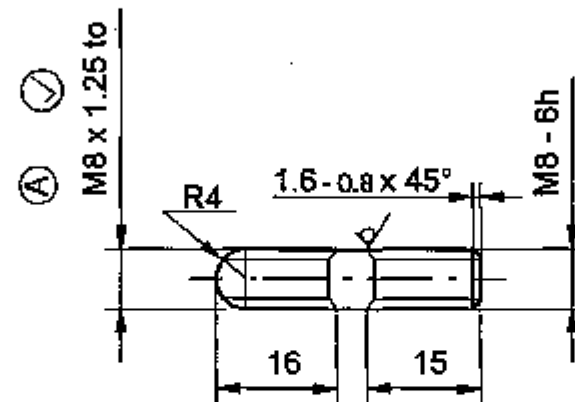
COMMON TO V-92S2 ENGINE

A-11
SIZE A3



DRAWING NUMBER
350 - 15

SHEET No. 1 OF 1



8. EXPLANATORY NOTE :-

MATERIAL QUOTED :- ROUND BAR GOST 7417-75
45 GOST 1051-73

ALTERNATE MATERIAL QUOTED :- 40, 50 GOST 1050-74
PERTAINS TO SIZED COLD ROLLED OR COLD DRAWN STEEL WITH ROUND SECTION

40, 45 AND 50 ARE GRADES OF STEEL GOST 1051-73

CHEMICAL COMPOSITION :

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

MECHANICAL PROPERTIES :

GRADE OF STEEL	TENSILE STRENGTH Kgf/mm ² (min)	YIELD POINT Kgf/mm ² (min)	ELONGATION % (min)	REDUCTION IN AREA % (min)	IMPACT STRENGTH Kgf/mm ² (min)
40	58	34	19	45	6
45	61	36	16	40	5
50	64	38	14	40	4

2. TECHNICAL REQUIREMENTS FOR THREADS AS PER STANDARD 82021-00.
3. DIMENSIONS WITH UNSPECIFIED TOLERANCES AND THE REST OF THE TECHNICAL REQUIREMENTS AS PER STANDARD 82052-00.
4. COATING : CADMIUM 3. CHROMATIZING AS PER IIIIJI-104 WITH ELIMINATION OF HYDROGEN EMBRITTELEMENT.
5. THE THREAD MAY BE MADE BY ROLLING WITH THE DIAMETER OF UNTHREADED PORTION WITHIN THE PITCH DIAMETER OF THREADS.
6. MECHANICAL DAMAGES OF THE CADMIUM COATING SUCH AS SCRATCHES, NICKS AND DENTS ARE ALLOWED ON ASSEMBLY UNITS, PROVIDED THE STEEL IS NOT EXPOSED.
7. ALTERNATE MATERIAL : STEEL, GRADES 40 AND 50 GOST 1050-74.
8. HARDNESS :- 27 - 32 HRC.

9. REPAIR SIZE DIMENSIONS ARE ADDED WHERE INDICATED THUS BASED ON OVER HAUL SPECIFICATION PART III REPAIR DRAWINGS.

SL.No.	R	REMARKS
1	M 10 x 1.5 to	ALL OTHER CONDITIONS AS PER STD. DRG.
2	PCD = 9.026 ^{+0.170} _{+0.095}	

* ALT. MATERIAL :- STEEL 709 M40 (EN-19) TO BS : 970 PT. - I-1983.

** Cb 306-01-36 Cb 306-01-20
Cb 306-02-36 Cb 306-02-20
Cb 3301-15-44 Cb 406-05-3
Cb 3308-04-24 Cb 3301-15-30
Cb 3321-14-1

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

EST. WT. (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	Sd/=	MATERIAL :- ROUND BAR	USED ON :-
CHD	Sd/=	GOST 7417-75 *	Cb 3338-402-4 **
APPD	Sd/=	45 GOST 1051-73	
DATE	02.05.87	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
SCALE:- 1 : 1		TITLE:-	
DIMENSIONS IN mm		STUD M8 x 35	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69		D S CAT NUMBER	
ALL THREADS TO CONFORM TO		DRAWING NUMBER	
ISSUE	DATE	350 - 15	

D	26-05-09	Authy: Third Alt. Comm. Minutes Point. 5 Dated 27-02-2009.
C	25.8.08	USED ON NUMBERS ADDED
B	11.01.08	AUTHY: MIN. OF ALT. COM. MEET POINT
A	06.9.95	No. - 2. 12 DL.07.02.07
		REPAIR SIZE DIMNS. ADDED.
		NATURE OF AMENDMENTS

DRG. RE-INDIANISED BASED ON 350-15 ISSUE 'B' COMMON TO V-92S2 ENGINE

F-11
SIZE A1

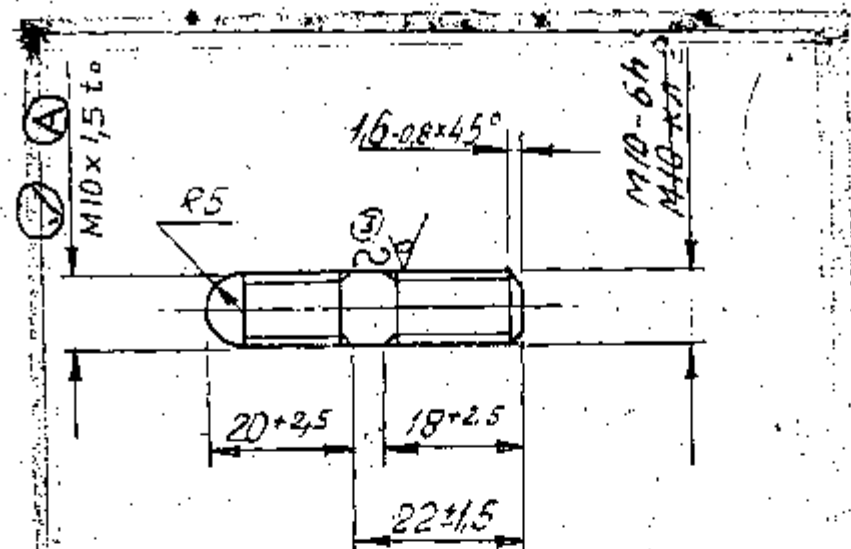


DRAWING NUMBER

350 94

RZ80/ (✓)

8. EXPLANATORY NOTE



1. INSPECTION GROUP IV TT-11
 2. HRC \Rightarrow 28 ----- 35
 3. TECHNICAL REQUIREMENTS FOR THREADS AS PER STANDARD 82021-00.
 4. COATING: CADMIUM 3, CHROMATIZING AS PER UUA-104 WITH SUBSEQUENT ELIMINATION OF HYDROGEN EMBRITTLEMENT.
 5. MECHANICAL DAMAGE OF CADMIUM COATING SUCH AS SCRATCHES, NICKS AND DENTS ARE ALLOWED ON ASSEMBLY UNITS, PROVIDED THE STEEL IS NOT EXPOSED.
 6. DIMENSIONS WITH UNSPECIFIED TOLERANCES AND THE REST OF THE TECHNICAL REQUIREMENTS AS PER STANDARD 82052-00.
 7. THE THREAD MAY BE MADE BY ROLLING WITH THE DIAMETER OF UN-THREADED PORTION WITHIN THE PITCH DIAMETER OF THREAD.
 9. REPAIR SIZE DIMENSIONS ARE ADDED WHERE INDICATED
- (A) THUS \odot BASED ON OVERHAUL SPECIFICATIONS PART III REPAIR DRAWINGS. **

8. REFERENCE MATERIAL QUOTED:

COLD ROLLED SIZED STEEL ROUND ϕ 10mm, CLASS OF ACCURACY 4 (-0.100)
TO GOST 7417-75 FROM HIGH GRADE STEEL 38XA GOST 1051-73 AND MANUFACTURED IN ACCORDANCE WITH CHROME ALLOY STEEL 38XA HIGH QUALITY A TO GOST 4543-71.

a) CHEMICAL COMPOSITION:

GRADE OF STEEL	CONTENT OF ELEMENTS %						
	C	Si	Mn	Cr	P	S	NI
38xA	0.35-0.42	0.17-0.37	0.50-0.80	0.80-1.10	0.025	0.025	0.30
	MAXIMUM						

b) MECHANICAL PROPERTIES

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	YIELD POINT Kgf/mm ²	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH NGT ² Kgm/cm ²	HARDNESS BHN MAX
38xA	95	80	12	50	9	207

(C) EQUIVALENT MATERIAL
STEEL 709M40 (EN19) TO BS:970
40Cr4Mo3 TO IS:1570

Sl. No	R	REMARKS	**
1	M 12 x 1.5 to	ALL OTHER CONDITIONS AS PER STD DRGS.	(B) Cb 3301-15-30 Cb 3301-15-44 Cb 3308-04-24 Cb 3321-14-1
2	PCD = 11.026 \pm 0.170 \pm 0.095		

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

EST WT 0.026 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.

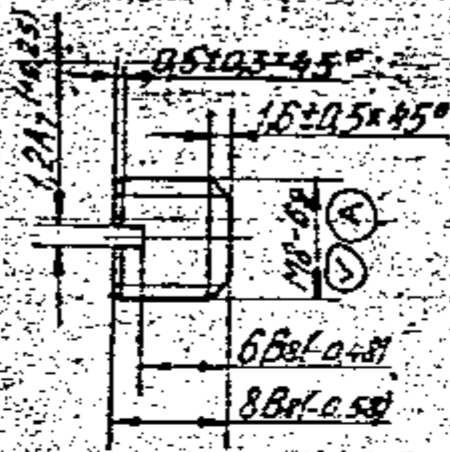
ORN	<i>[Signature]</i>	MATERIAL: ROUND BAR	USED ON: **
CHD	<i>[Signature]</i>	10-4 GOST 7417-75	Cb 3311-05-1
TCO	<i>[Signature]</i>	38xA GOST 1051-73	820-01-02-9
APPD	<i>[Signature]</i>	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)	
DATE	25-3-86	AVADI	
SCALE:	1:1	TITLE: STUD M10x42	
DIMENSIONS IN mm		D S CAT NUMBER	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69		DRAWING NUMBER	
		350 94	
C 15-7-10	4 1/2 ALT. COMM. Mfg. MINUTES		
B 25.8.08	USED ON NUMBER ADDED.		
A 2-11-95	REPAIR SIZE DIMNS ADDED.		
ISSUE	DATE	NATURE OF AMENDMENTS	

COMMON TO V-92S2 & UTD-20 ENGINES

(A-11)

E A3





6. EXPLANATORY NOTE:

Material quoted: Brass ρ c 59-1 GOST 15527-70
 ρ c 59-1 : Grade of brass, hard drawn.

Alternative material quoted: Bar A 16T GOST 21488-76
 A 16 : Grade of aluminium alloy
 T : Hardened and naturally aged.

Chemical composition (as per GOST 15527-70)
 MAX.
 Copper = 57.0-60.0 Iron = 0.5 (max)
 Lead = 0.8-1.5 Antimony = 0.010 (max)
 Zinc = Remaining Bismuth = 0.003 (max)
 Phosphorus = 0.02 (max)
 Tin = 0.30 (max)
 Total = 0.75 (max)

Mechanical properties (as per GOST 2060-73)
 ultimate tensile strength kgf/mm^2 (min) = 50
 Relative elongation % (min) = 5

Chemical composition (as per GOST 4784-74)

Basic constituent = Aluminium
 Copper = 3.8-4.9
 Magnesium = 1.2-1.8
 Manganese = 0.3-0.8

Impurities (maximum)
 Iron = 0.5
 Silicon = 0.5
 Nickel = 0.1
 Zinc = 0.3
 Titanium = 0.1
 Other impurities = 0.05 each

Mechanical properties: (as per GOST 21488-76)

Tensile strength kgf/mm^2 = 40 (min)
 Yield Point kgf/mm^2 = 28 (min)
 elongation % = 10 (min)

1. Inspection group V TT-11.
 2. Radius from milling cutter R30mm, minimum is allowed to be left after cutting of slot for screw driver eccentricity of slot relative to the axis of plug should not exceed 0.25 mm.
 3. The rest of the Technical requirements - as per Standard 82052-00.
 4. The component may be manufactured from bar A16T GOST 21488-76.
 5. Sharp edges are permitted on the surfaces of slot
 7. REPAIR SIZE DIMENSIONS ARE ADDED WHERE INDICATED
- (A) THUS (V) BASED ON OVERHAUL SPECIFICATIONS PART III REPAIR DRAWINGS * *

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

EST. MASS	0.0027 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS +	LETTERS!
USED ON NUMBER ADDED	1-1-46	REPAIR SIZE DIMS ADDED	
DATE		NATURE OF AMENDMENTS	
SCALE	2:1		
DIMENSIONS IN mm			
TOLERANCE ON DIMS UNLESS OTHERWISE STATED			
ALL THREADS CONFORM TO			
MATERIAL	BRASS ρ c 59-1 GOST 15527-70	USED ON	CB 3338-402-4 (B)
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD		TITLE	PLUG
D'S CAT NUMBER		DRAWING NUMBER	356-63-3

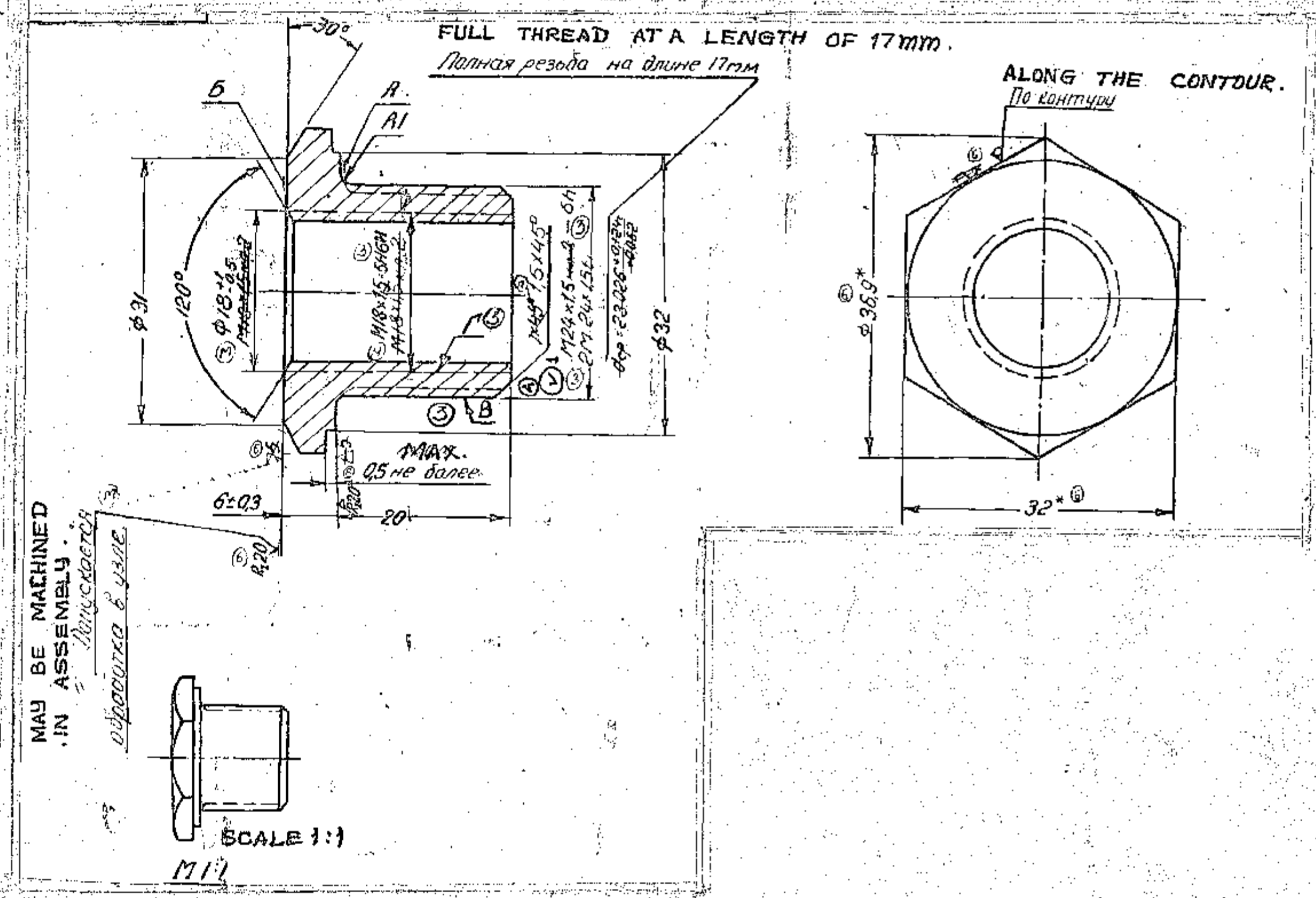
SL. No	R	REMARKS
1	M 10 - 6 g	ALL OTHER CONDITIONS AS PER STD DRG.

(B) Cb 3301-15-44, Cb 3308-04-24

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EXPLANATORY NOTE:

10. REFERENCE MATERIAL QUOTED: GAUGED HEXAGONAL STEEL BAR 32mm A/F, CLASS OF ACCURACY '5' (-0.340) TO GOST 8560-78, HIGH GRADE STEEL 45 NORMAL SURFACE QUALITY TO GOST 1051-73 AND REFERENCE NOTE '5' ON ALTERNATE MATERIALS STEEL GRADE 40 & 50, MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL GRADES 45, 40 & 50 TO GOST 1050-74.
 a) CHEMICAL COMPOSITION AS PER GOST 1050-74.

GRADE OF STEEL	CONTENT OF ELEMENTS %						REMARKS
	C	Si	Mn	Cr	S MAXIMUM	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.

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 STR. LENGTH Kg/cm ²	HARDNESS BHN MAX	REMARKS
45	61	36	16	40	5	207	Ref.Matl.
40	59	34	19	45	6	197	Alt.Matl.
50	64	38	14	40	4	217	Alt.Matl.

- DIMENSIONS WITH UNSPECIFIED TOLERANCES ARE TO BE OBTAINED AS PER ACCURACY CLASS 7 (OST 1010).
- NON-SQUARENESS OF SURFACE 'A' WITH THE AXIS OF THREAD 'B' AND OF SURFACE 'B' WITH AXIS OF THREAD 'A' SHOULD NOT EXCEED 0.1mm.
- SPECIFICATIONS FOR THREAD AS PER STANDARD 82021-00.
- SHARP EDGES SHOULD BE BLUNTED.
- ALTERNATE MATERIAL: STEEL, GRADE 40 & 50 GOST 1050-74.
- FACES MAY BE TURNED $\phi 35.5$.
- DURING FACING OF END FACE 'A' WITH A CUTTER (CUTTING-IN ON STEP 0.3mm, MAX IS ALLOWED ON CYLINDRICAL SURFACE, ABSENCE OF COATING ON INNER SURFACES OF THE COMPONENTS IS ALLOWED, THREAD CALIBRATION IS PERMITTED.
- COATING: Cd, CHROMATIZING AS PER 4.8-10% WITH HYDROGEN EMBRITTLEMENT ELIMINATED, THREAD MAY BE CALIBRATED.
- * DIMENSION FOR REFERENCE.
- REPAIR SIZE DIMENSIONS ARE ADDED BASED ON LT. NO. 82847/0H/0AS/ED DT. 27 MARGS AS FOLLOWS: REPAIR SIZE DIMENSIONS ARE ADDED WHERE INDICATED THIS \odot .

Sl.No.	R	REMARKS
1	2M27 x 1.5 ± 1 +0.124 -0.061 PCD 26.026	1. ALL OTHER CONDITIONS AS PER STD. DEG. 2. MARK REPAIR SIZE.

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

EST WT: 0.056 Kg

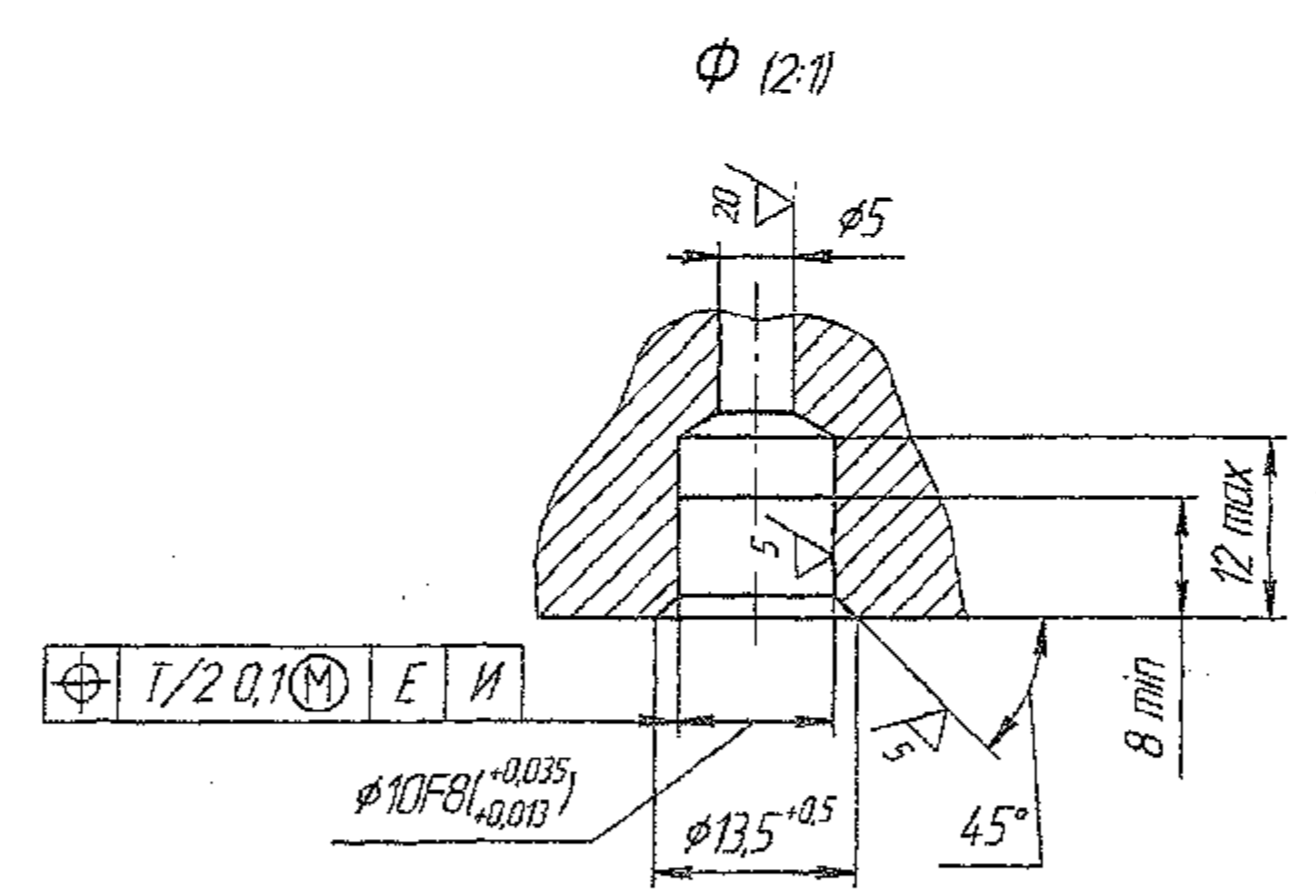
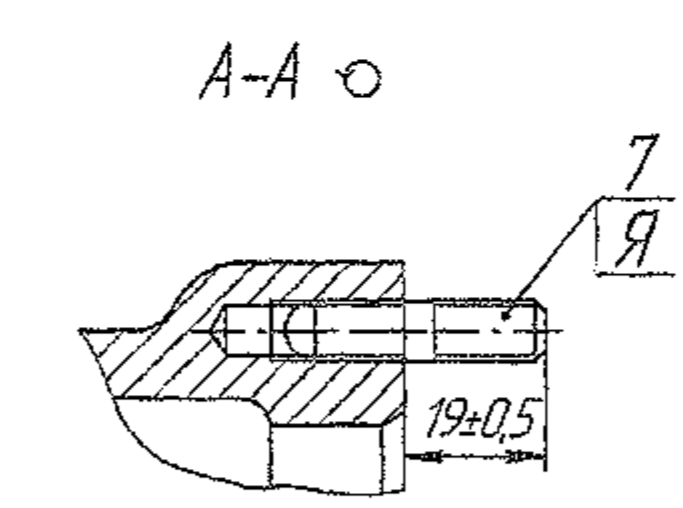
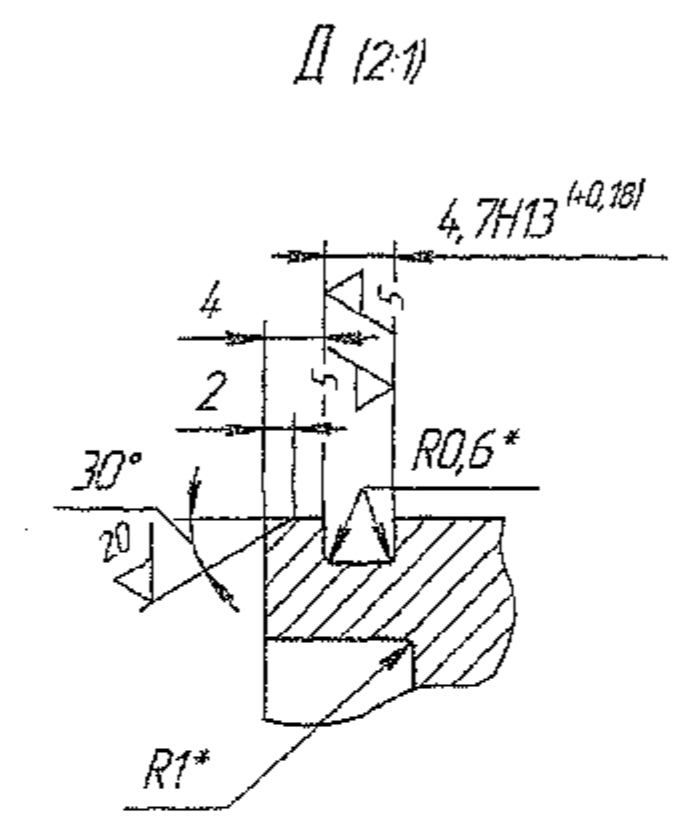
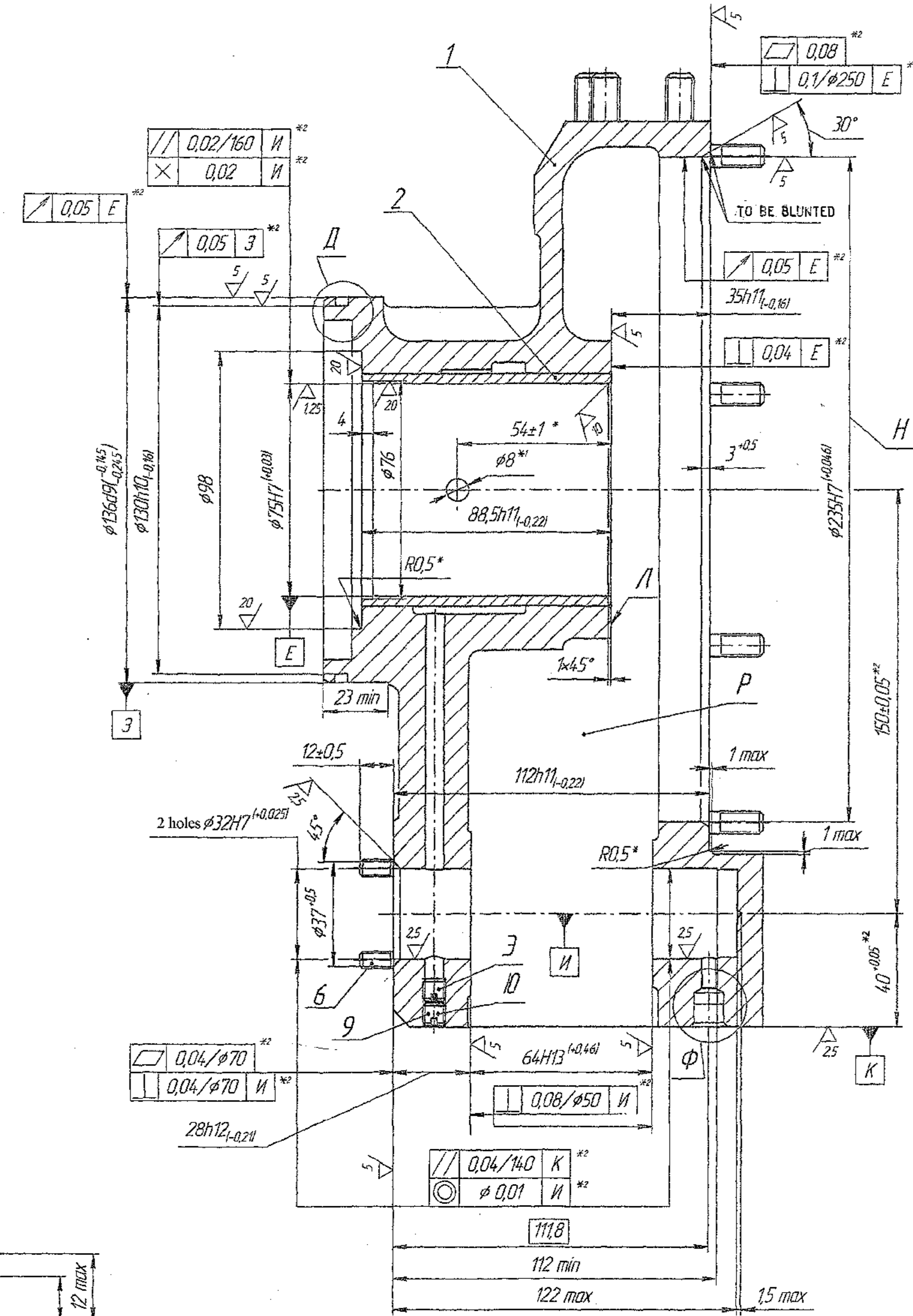
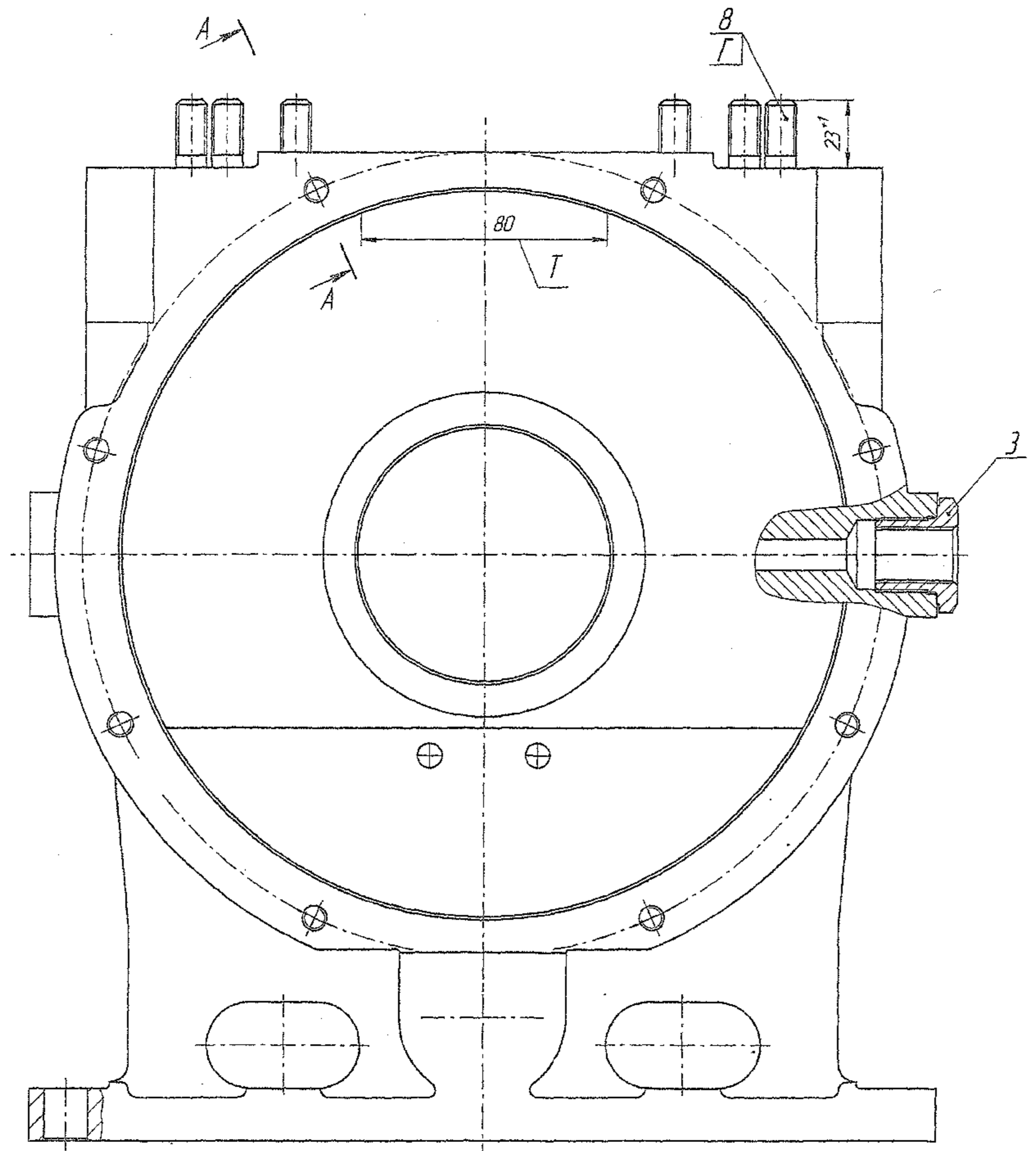
TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)

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

DRN	DRN	MATERIAL	HEXAGON	USED ON
CHD	CHD	32.5 GOST 8560-78	45 GOST 1051-73	CG 447-01-1
TCO	TCO	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)		
APPD	APPD	AVADI		
DATE	DATE	TITLE		
SCALE	SCALE	UNION PIPE		
DIMENSIONS IN mm	DIMENSIONS IN mm	D S EAT NUMBER		
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	DRAWING NUMBER		
ALL THREADS TO CONFORM TO	ALL THREADS TO CONFORM TO	402-28-1		
ISSUE	ISSUE	NATURE OF AMENDMENTS		
DATE	DATE	REPAIR SIZE ADDED		

SIZE A2





1. Cool the part item 2 in liquid nitrogen before press-fitting in part item 1. Set up to coincidence with end face Π , projection is not permitted.
2. Protect the oil pipe of part item 1 from falling of chips during boring of holes. Oil pipe should be clean.
3. Unspecified limit deviation of dimensions: $H14; h14; \pm 171\%$.
4. Check the deviation from planeness of surface K "by paint", prepared and put as per instruction ИЛ-613-85.
5. Dimension $H=235, 115$, maximum on section T is permitted.
6. Set bush item 3, stud Я and Г on sealing compound Аи-5МД ТУ6-01-1288-84 as per ИЛ-652-86.
7. Turn plug 3 up to support to runout of threads. Fill the space between end faces of plug 3 and 10 by epoxy glue No. 1 for cold consolidation as per ИЛ-745-88. Volume of glue between plugs should be with such order during turning of plug 10 would be outlet of glue through thread from outside. Projection of plug is not permitted.
8. Test for airtightness of oil pipe and cavity P by oil, used on engine for two minutes minimum, temperature of oil 80...100 °C. Oil pipe - with pressure (1.1±0.1) MPa ((1±1) kgf/cm²). Cavity P - with pressure (0.3±0.5) MPa, ((3±5) kgf/cm²). Leakage of oil is not permitted. Test the cavity P for airtightness by air in water. With pressure 0.1...0.2 MPa (1...2 kgf/cm²) for two minutes minimum. Passing of air is not permitted.
9. * Dimensions are ensured by tool.
10. *1 Dimension for references.
11. *2 Ensure before setting of pins item 6; item 7.

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.		DRN: CHD	MATERIAL: —	USED ON: Cb.3308-15-2
EST. WT. (kg): 8.85	TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)	APPD: [Signature]	DATE: 21-01-09	CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R. OUTSIDE R. INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		SCALE: 1:1	TITLE: FUEL PUMP DRIVE HOUSING ASSY	D S CAT NUMBER: Cb.3308-04-24
ISSUE DATE NATURE OF AMENDMENTS		CONFORM TO		

DRG. INDANISED BASED ON RUSSIAN ORIGINAL ISSUE-NIL. DRAWING REPLACES Cb.3308-04-24 ISSUE - L1/NOTN. No. 144-06



USED ON

Cb.3308-15-2

I/L CREATED BASED ON RUSSIAN ORIGINAL ISSUE - NIL
 I/L REPLACES VIDE ISSUE-NIL., NOTN.No. 144-06

ZONE	ITEM NO	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	QTY	REMARKS
		Cb.3308-04-24		FUEL PUMP DRIVE		
		ITEM LIST		HOUSING ASSY		
	1	308-30-25		FUEL PUMP DRIVE	1	
				HOUSING.		
	2	3308-68		BUSH	1	
	3	402-28-1		BUSH	1	
	6	350-03		STUD M6 x 24	4	
	7	350-15		STUD M8 x 35	8	
	8	350-94		STUD M10 x 42	6	
	9	356-63-3		PLUG	2	

ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS

DRN *B. Sand Bab* CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.

CHD *Praveen Devaraj* TITLE :

APPD *R. Lakshminarayana* **FUEL PUMP DRIVE HOUSING ASSY**

DATE 21-01-09 SHT. NO. 1 OF 1 D S CAT NUMBER ITEM LIST FOR Cb.3308-04-24

F-158

