

DRAWING NUMBER
413-33-2

Rz 20/ (✓)

EXPLANATORY NOTE:

REFERENCE MATERIAL QUOTED:

6. CARBON STRUCTURAL, HOT ROLLED STEEL, GRADE 15 AND REFERENCE NOTE 1 ON ALTERNATE MATERIAL STEEL GRADE 20 TO GOST 1050-74.

a) CHEMICAL COMPOSITION:

GRADE OF STEEL	CONTENT OF ELEMENTS %						REMARKS
	C	Si	Mn	Cr	S	P	
15	0.12	0.17	0.35	0.25	0.040	0.035	REF. MATL
	0.19	0.37	0.65				
20	0.17	0.17	0.35	0.25	0.040	0.035	ALT. MATL
	0.24	0.37	0.65				

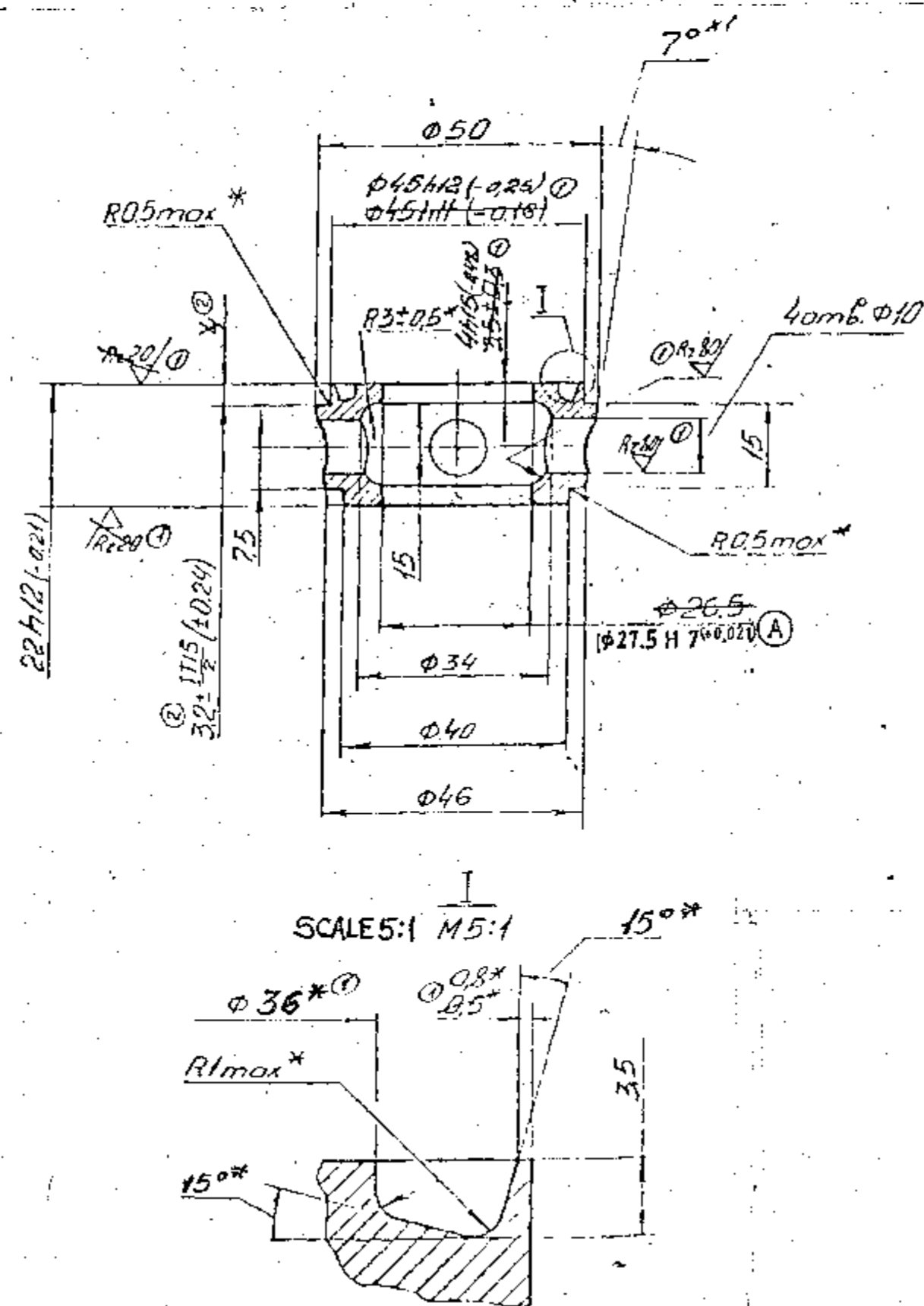
RESIDUAL CONTENTS OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH.

b) MECHANICAL PROPERTIES AS PER NORMALISED CONDITION.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	YIELD POINT Kg/mm ²	ELONGATION %	REDUCTION IN AREA %	HARDNESS B H N	REMARKS
15	38	23	27	55	149	Ref, Matl
20	42	25	25	55	163	Alt, Matl

1. Заменитель материала сталь 20 ГОСТ 1050-74.
 2. Неуказанные предельные отклонения размеров отверстий по H14, валов по h14, остальных по IT14.
 3. Клеить окончательную приемку на бирке для партии деталей.
 4. * Размеры обеспечиваются инструментом.
 5. * Размер для справок.

1. ALTERNATE MATERIAL: STEEL 20 GOST 1050-74.
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS OF HOLES AS PER H14, OF SHAFTS AS PER h14, OF THE REST OF DIMENSION $\pm IT 14$.
3. MARK OF FINAL ACCEPTANCE SHOULD BE PUT ON TAG FOR BATCH OF COMPONENTS.
4. * DIMENSIONS ARE TO BE ENSURED BY TOOL.
5. *1 DIMENSION FOR REFERENCE.
6. * DIMENSION PUT IN BRACKETS AFTER ASSEMBLY.



SCALE 5:1 M5:1

ORG. (UN)ANISED BASED ON RUSSIAN ORIGINAL ISSUE - 3

A 6
SIZE A2

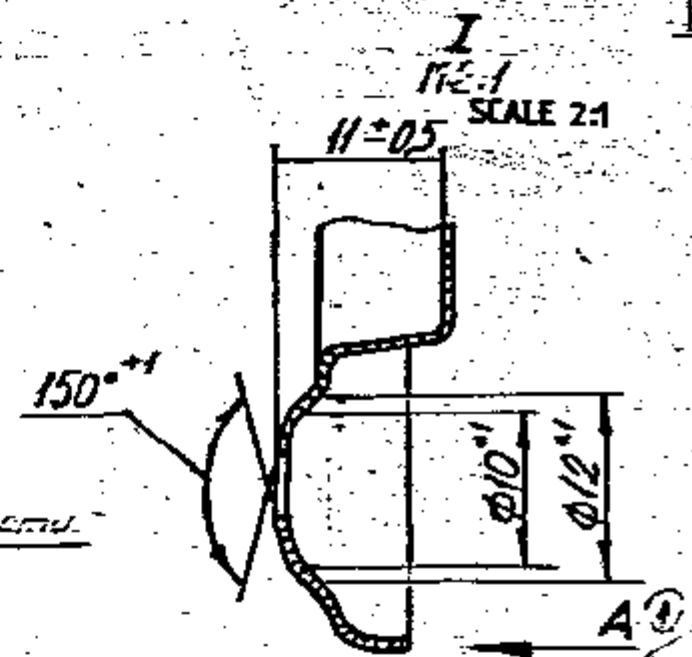
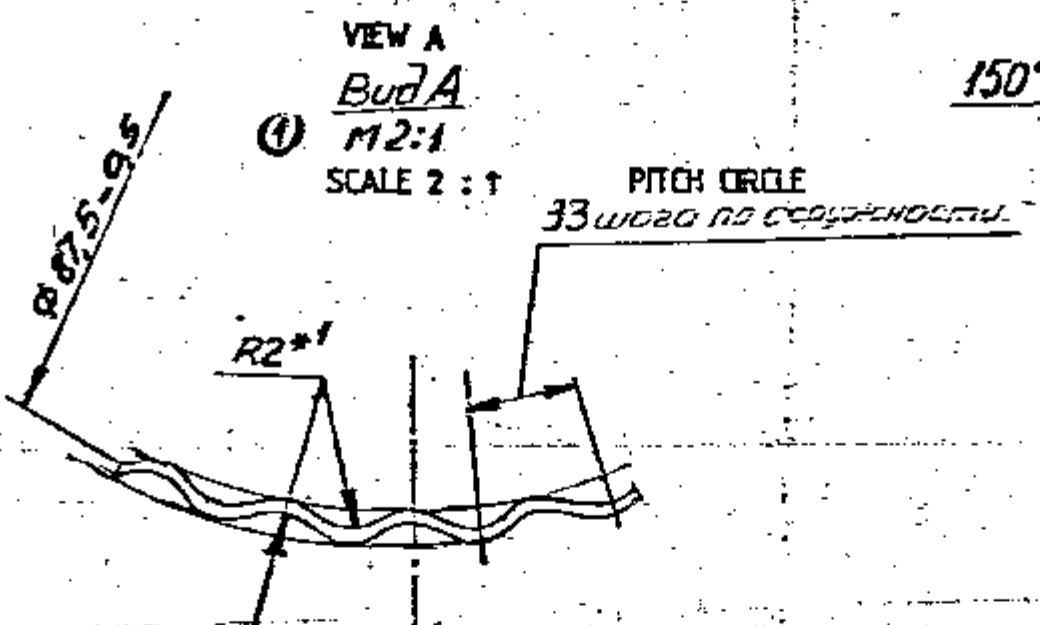
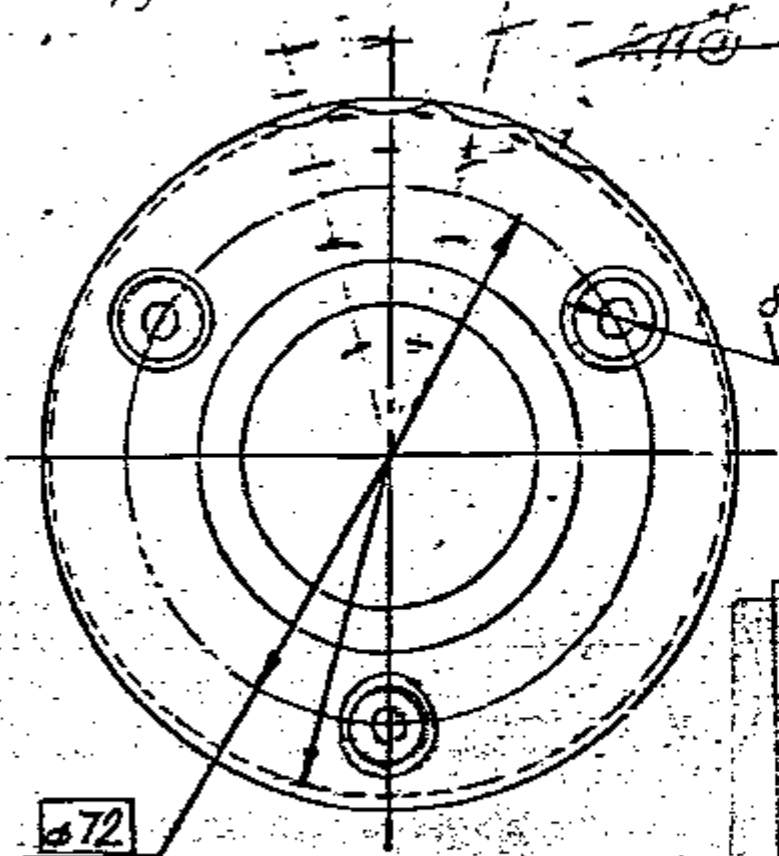
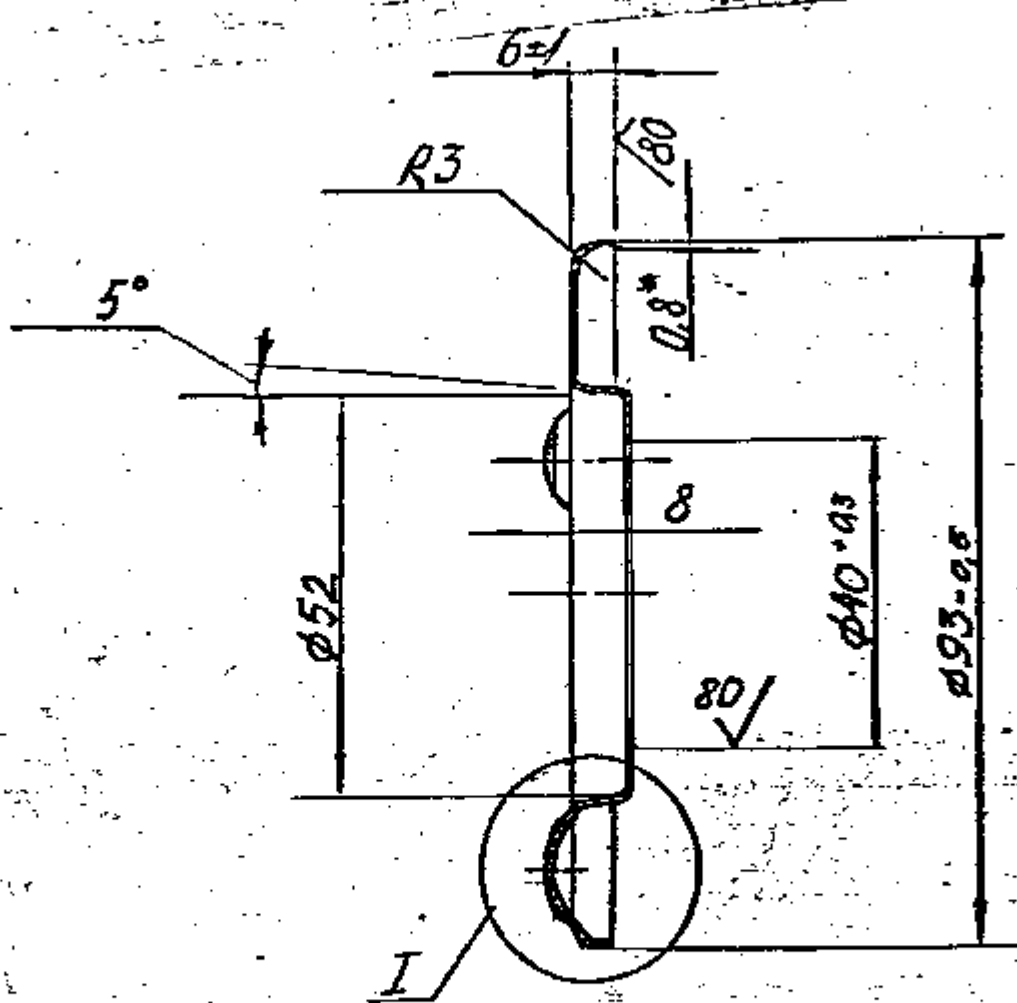
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. MASS 0.14 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 - 1:1	MATERIAL -	USED ON -
				19-5-86		STEEL 15 GOST 1050-74	CG 413-8-1 CG 413-11-1 CG 413-12-1
DIMENSIONS IN mm.						CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.						TITLE -	
ALL THREADS CONFORM TO						SEALING BUSH	
A 20.9.89 AUTHY. BK 84-802.						D S CAT NUMBER	
ISSUE DATE NATURE OF AMENDMENTS						DRAWING NUMBER	
						413-33-2	





EXPLANATORY NOTE:-

MATERIAL QUOTED: SHEET A 0.8 GOST 19904-74
II BF 08KII GOST 9045-80

- A = HIGH ACCURACY
- 0.8 = THICKNESS OF SHEET
- II = SURFACE FINISH (HIGH FINISH)
- BF = EXTREMELY DEEP DRAWING.
- 08KII = grade of steel as per Gost 1050-74

Chemical composition% (as per Gost 1050-74)

- Carbon = 0.05 - 0.11 ; Silicon = 0.037 (max)
 - Manganese = 0.25 - 0.50.
 - Chromium = 0.10
 - Phosphorus = 0.035
 - Sulphur = 0.040
 - Nickel = 0.25
 - Copper = 0.25
- } MAXIMUM

Mechanical properties as per Gost 9045-80

- ultimate tensile strength kgf/mm^2 = 26-37
- relative elongation = 30 (min)

TECHNICAL REQUIREMENTS - TRANSLATED

1. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS $\pm 0.3\text{mm}$.
2. UNSPECIFIED RADII $R1 \pm 0.5\text{mm}$.
3. * DIMENSIONS FOR REFERENCE.
4. *¹ DIMENSIONS TO BE ENSURED WITH TOOL.

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

EST. WT. 0.047 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.

DRM		MATERIAL - SHEET	USED ON -
DND		A 08 GOST 19904-74	CS 413-12-1
ITD		08 KII GOST 9045-80	
APPD		CONTROLLERATE OF QUALITY ASSURANCE HEAVY VEHICLES	
DATE	16 MAR 89	A V A D I	
SCALE	1:1		
DIMENSIONS IN mm.		TITLE	
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2162-69.		BOTTOM OF THIRD SECTION CUP	
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
ISSUE	DATE		413-44-1
NATURE OF AMENDMENTS			

PHOTO REPRODUCED FROM ORIGINAL ISSUE #1 (OR 82-135A)

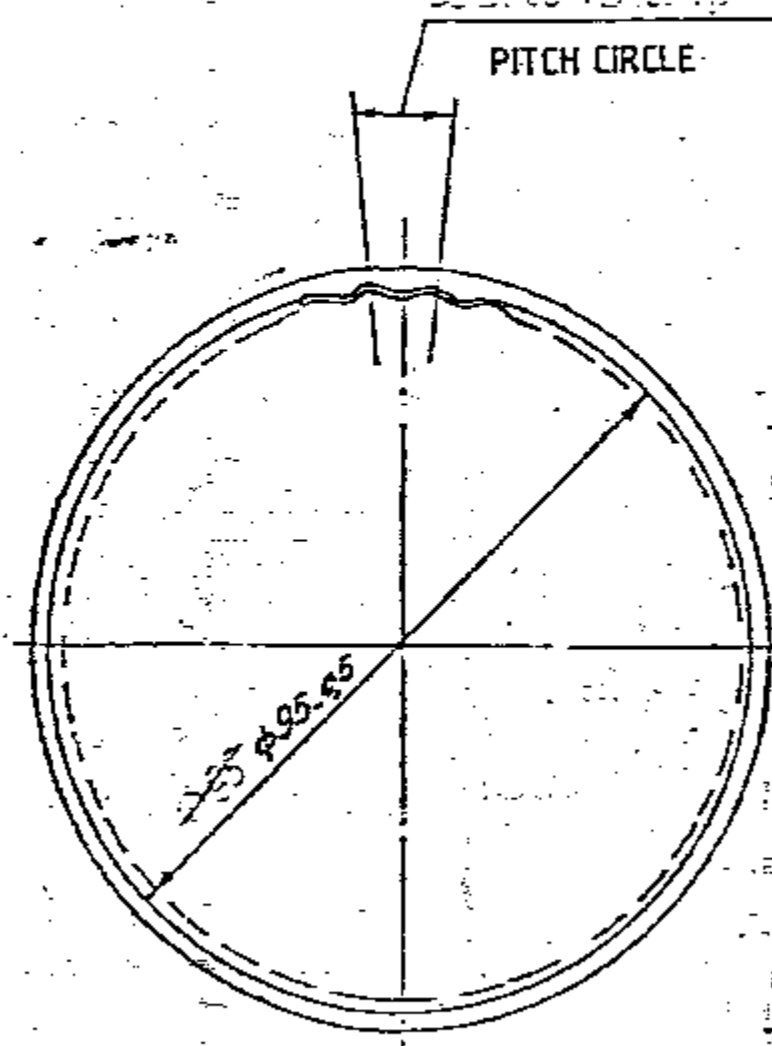
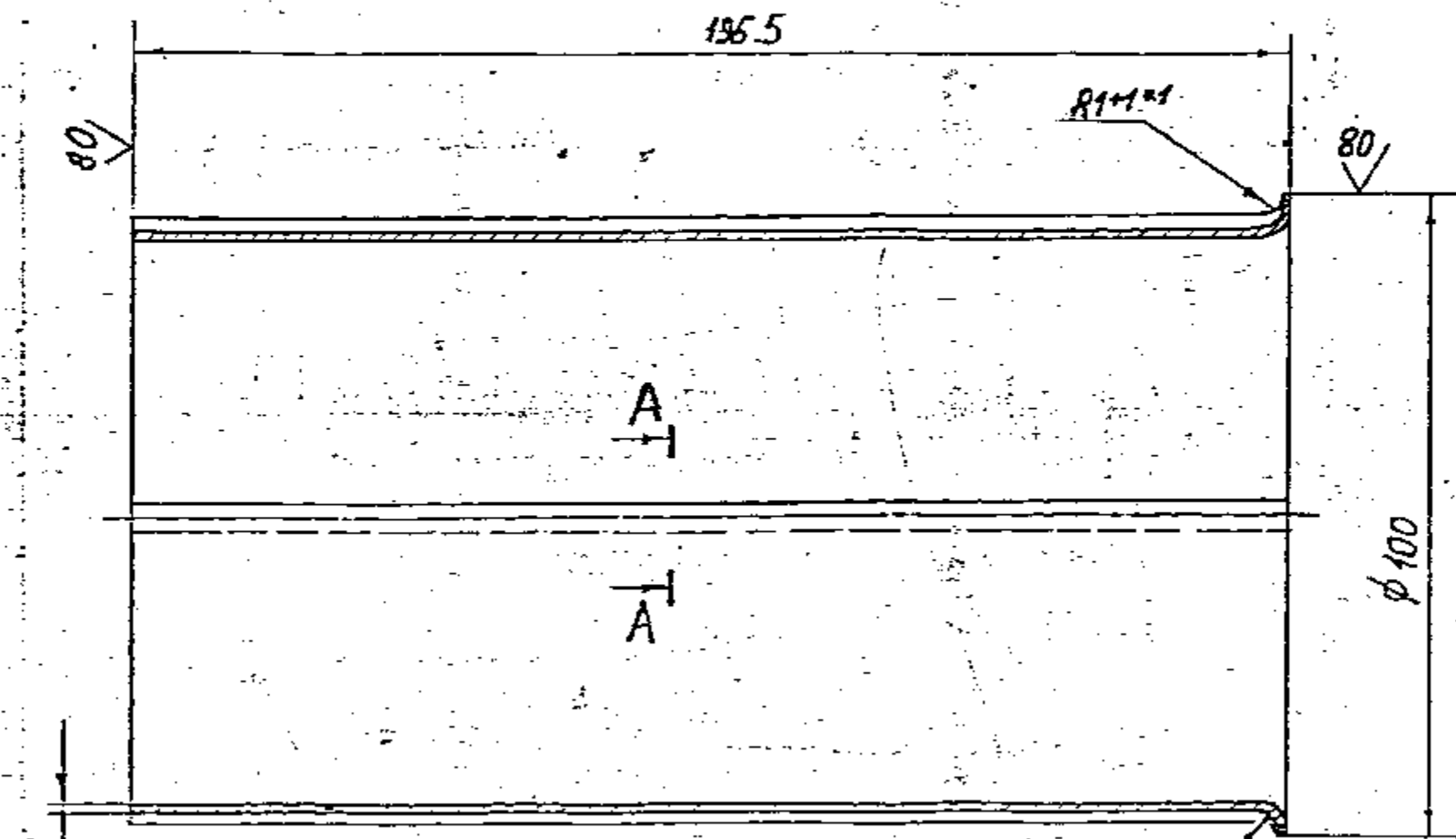
EXPLANATORY NOTE ADDED ON 20-9-81



DRAWING NUMBER

413-47-1

✓ (✓)



EXPLANATORY NOTE:-

MATERIAL QUOTED: SHEET A 0.8 GOST 19904-74
II BГ 08кп GOST 9045-80

A = HIGH ACCURACY
0.8 = THICKNESS OF SHEET
II = SURFACE FINISH (HIGH FINISH)
BГ = EXTREMELY DEEP DRAWING.
08кп = grade of steel as per Gost 1050-74

Chemical composition (as per Gost 1050-74)

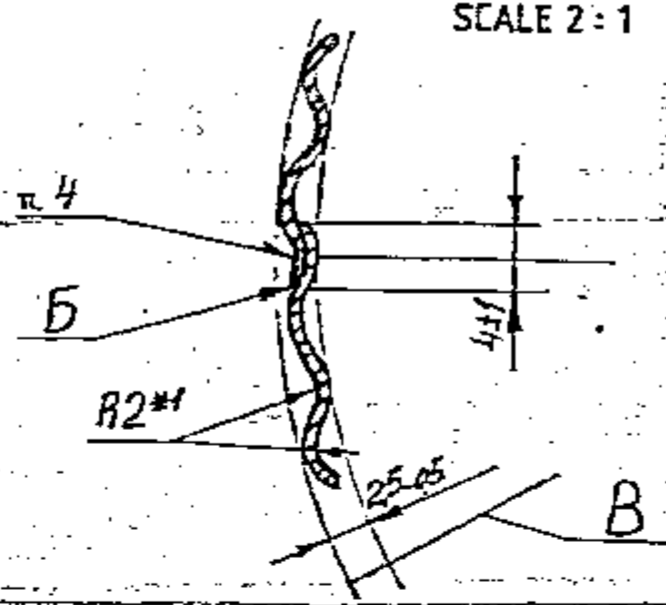
Carbon = 0.05-0.11 ; silican = 0.037 (max)
Mangonese = 0.25-0.50.
Chromium = 0.10
Phosphorus = 0.035
Sulphur = 0.040
Nickel = 0.25
Copper = 0.25

MAXIMUM

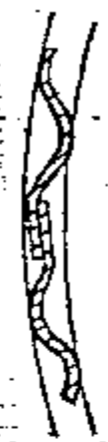
Mechanical properties as per Gost 9045-80

ultimate tensile strength kgf/mm^2 = 26-37
Relative elongation = 30 (min)

A-A
SCALE 2:1



ALTERNATIVE
A-A *topuchm*
SCALE 2:1



TECHNICAL REQUIREMENTS TRANSLATED

1. ALTERNATE MATERIAL : STEEL 08nc , 10 , 10 kn GOST 1050-74.
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ± 0.5 mm.
3. SURFACES OF COMPONENTS SHOULD BE CLEAN & EVEN. EDGES SHOULD BE FREE OF SCABS , CRACKS.
4. RESISTANCE WELDING.
5. PROJECTION OF EDGES B' BEYOND DIAMETER B IS NOT ALLOWED.
6. * DIMENSION FOR REFERENCE.
7. *1 DIMENSIONS TO BE ENSURED BY TOOL.

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

EST. WT. 0.39 Kg. TO BE STAMPED OR MARKED WHERE INDICATED THIS # LETTERS)

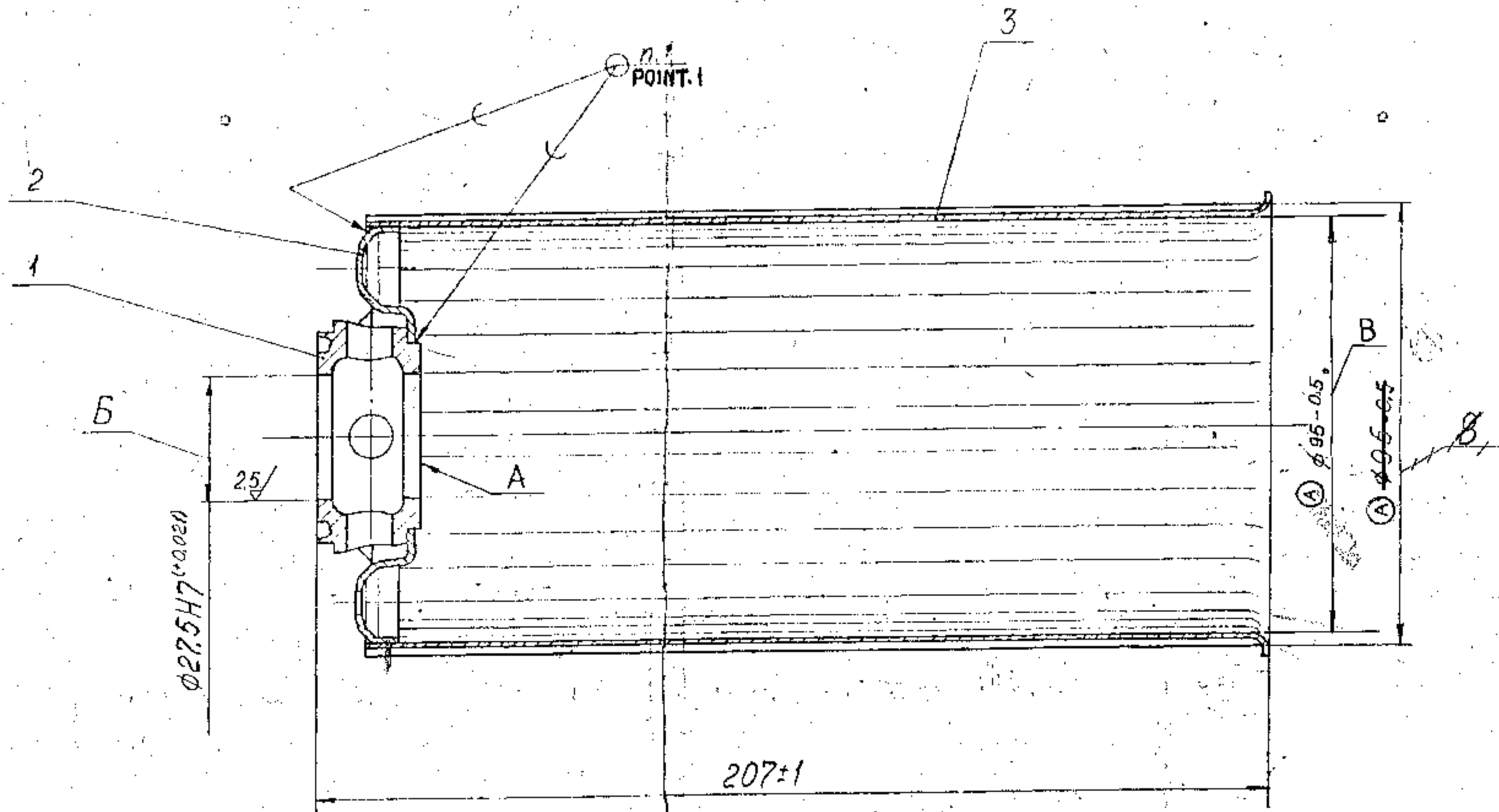
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRM		MATERIAL - SHEET	USED ON -
(HD)		A 08 Gost 19904-74	c8 413-16-1
TTD		II BГ 08 кп GOST 9045-80	
APPD		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	17 MAR 69	A V A D I	
SCALE	1:1		
DIMENSIONS IN mm			
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2002-69		TITLE BASE OF THIRD SECTION CUP	
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
ISSUE	DATE		413-47-1
NATURE OF AMENDMENTS			

EXPLANATORY NOTE ADDED ON 20.9.91



DRAWING NUMBER:
CB 413 12 1 CB



1. BRASS B63GOST 15527-70.
2. COATING: Zn 6, CHROMATIZING AS PER INSTRUCTIONS 22.483-82
3. TRACES FROM BRAZING DRESSING ARE ALLOWED ON SURFACE A'.
4. LOCAL ABSENCE OF COATING IS ALLOWED IN PLACES OF BRAZING AT BOTTOM AND-BODY-JOINTS IN THE DEPRESSIONS OF CUP BOTTOM (ON THE EXTERNAL AND INTERNAL SURFACES),
5. HOLE 6 IS TO BE FINALLY TAPPED AFTER COATING. THERE MAY BE NO COATING ON THE TAPPED SURFACE.
6. MISALIGNMENT OF HOLE 6 AND DIAMETER B SHOULD NOT EXCEED 0.2mm(MMC)

DRAWING INDIANISED BASED ON ISSUE 3

A 6
SIZE A2

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

EST. MASS 0.610 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	<i>[Signature]</i>	MATERIAL	USED ON:-
CHD	<i>[Signature]</i>		CB 413 06 1 CB
TCD	<i>[Signature]</i>		
APPD	<i>[Signature]</i>	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)	
DATE	19-5-86	AVADI	
SCALE - 1 : 1		TITLE:-	
DIMENSIONS IN mm.		SUB ASSEMBLY CUP THIRD	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.		SLOT TYPE FILTERING SECTION	
ALL THREADS CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
A	23.11.87		CB 413 12 1CB
ISSUE	DATE	NATURE OF AMENDMENTS	



