

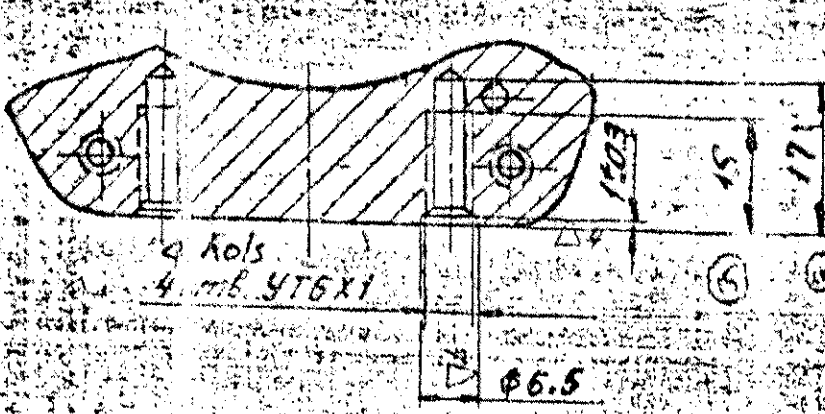
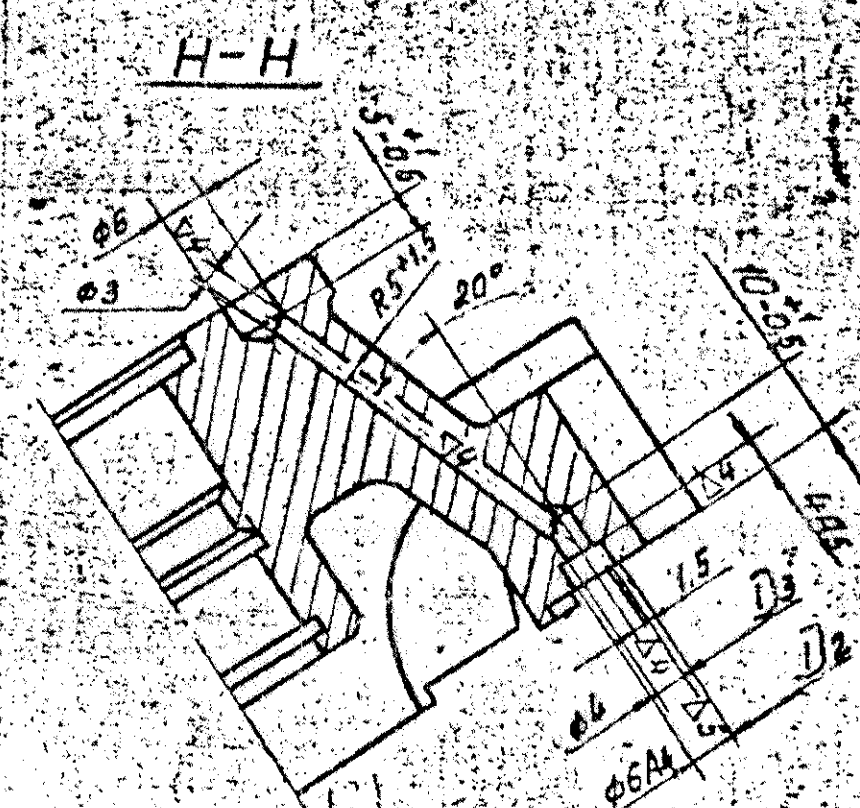
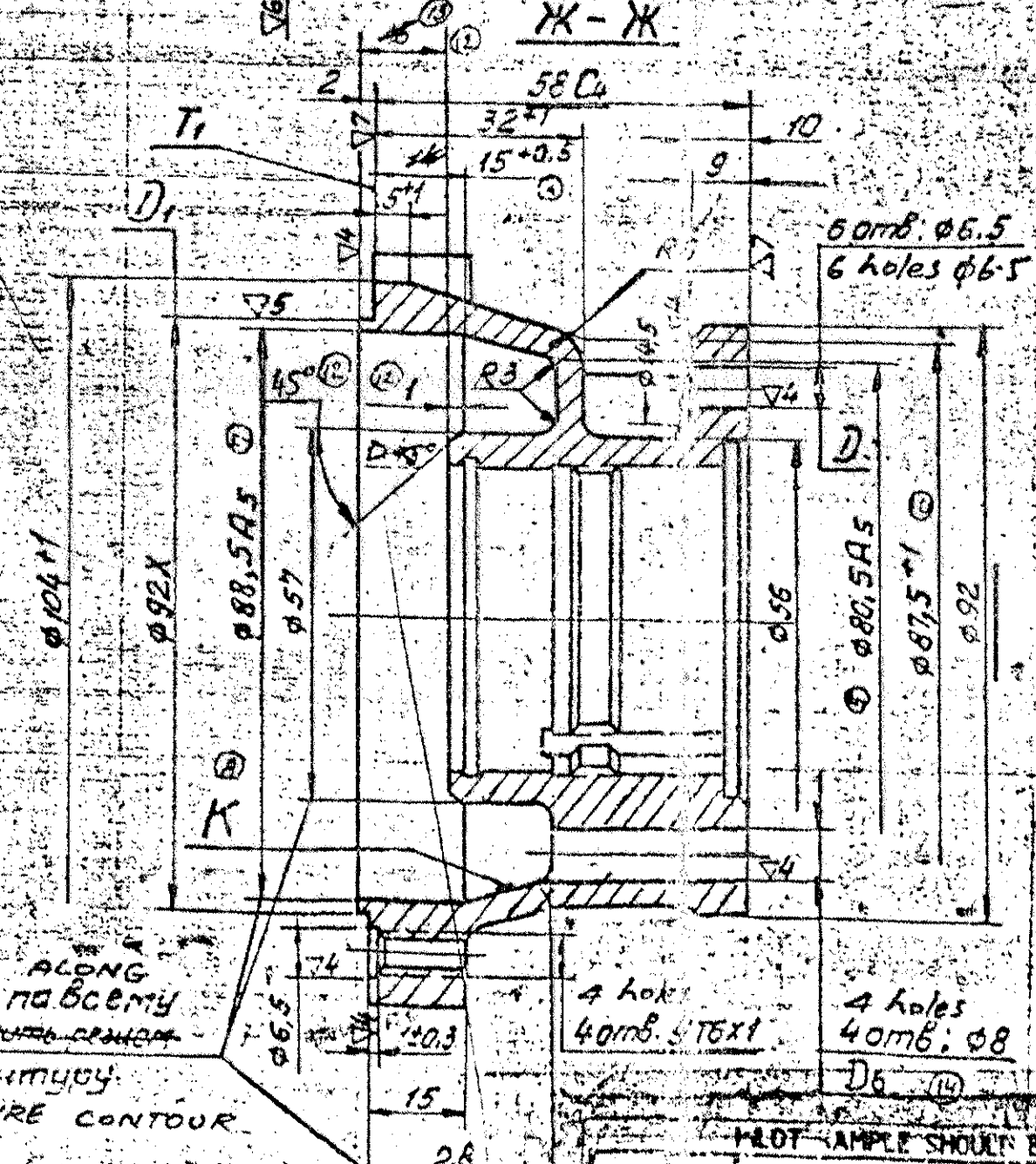
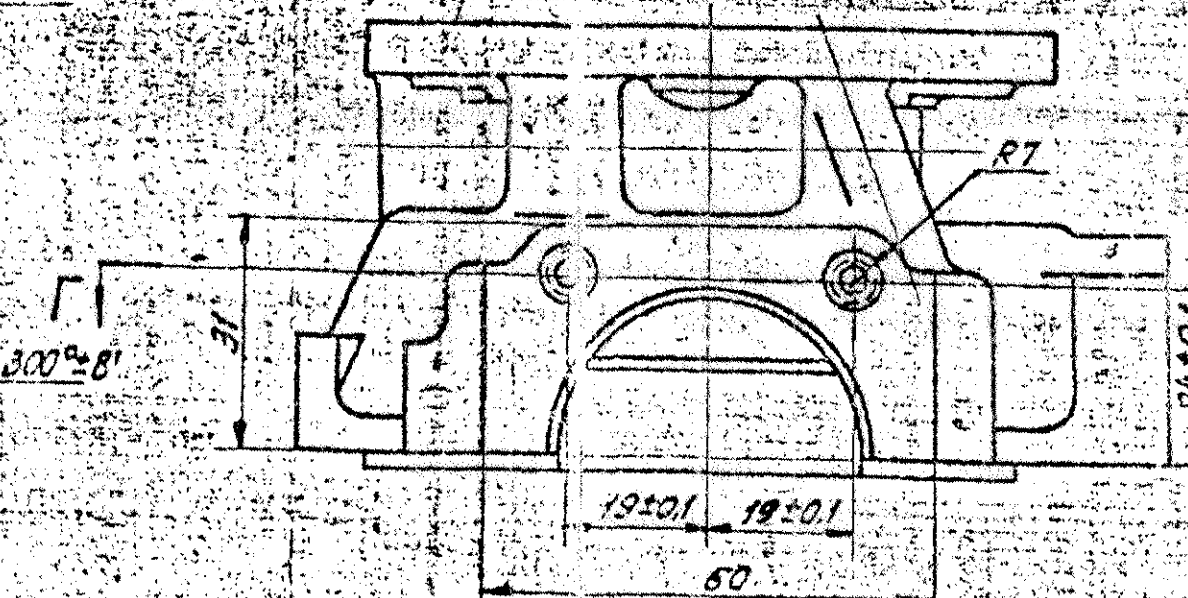
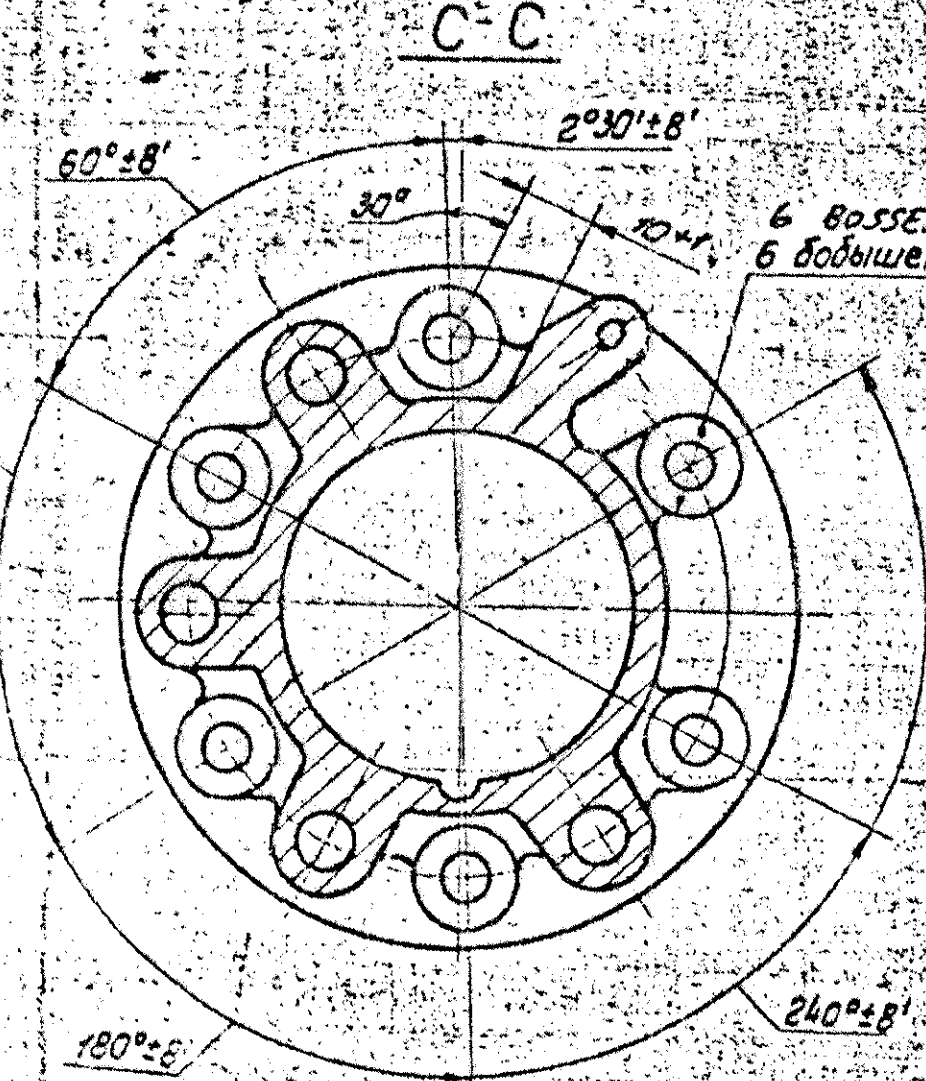
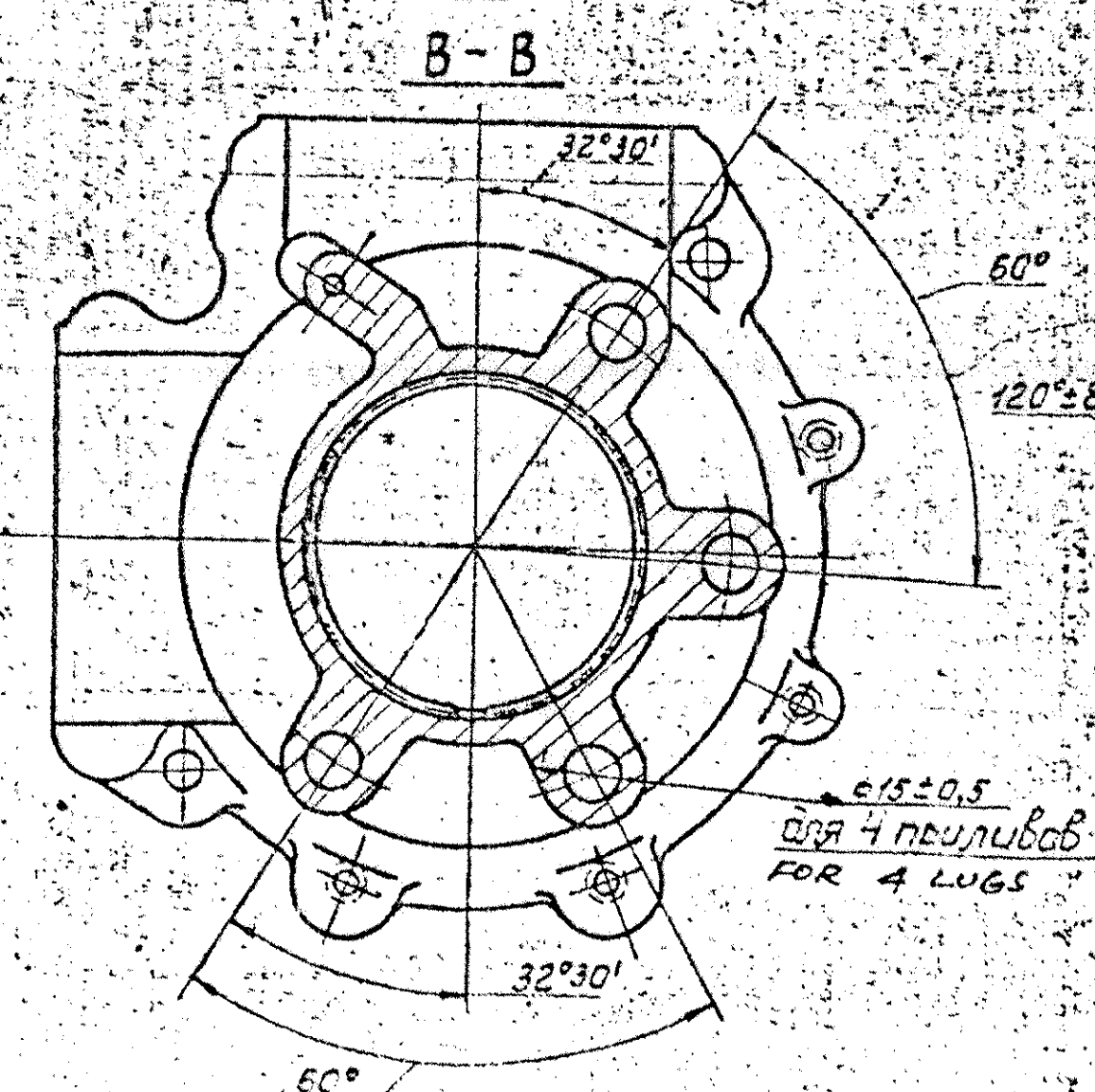
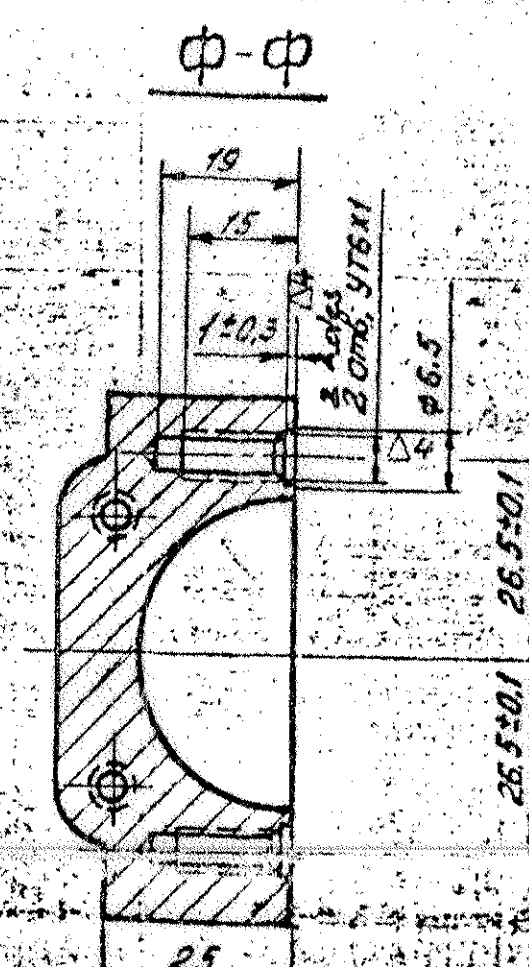
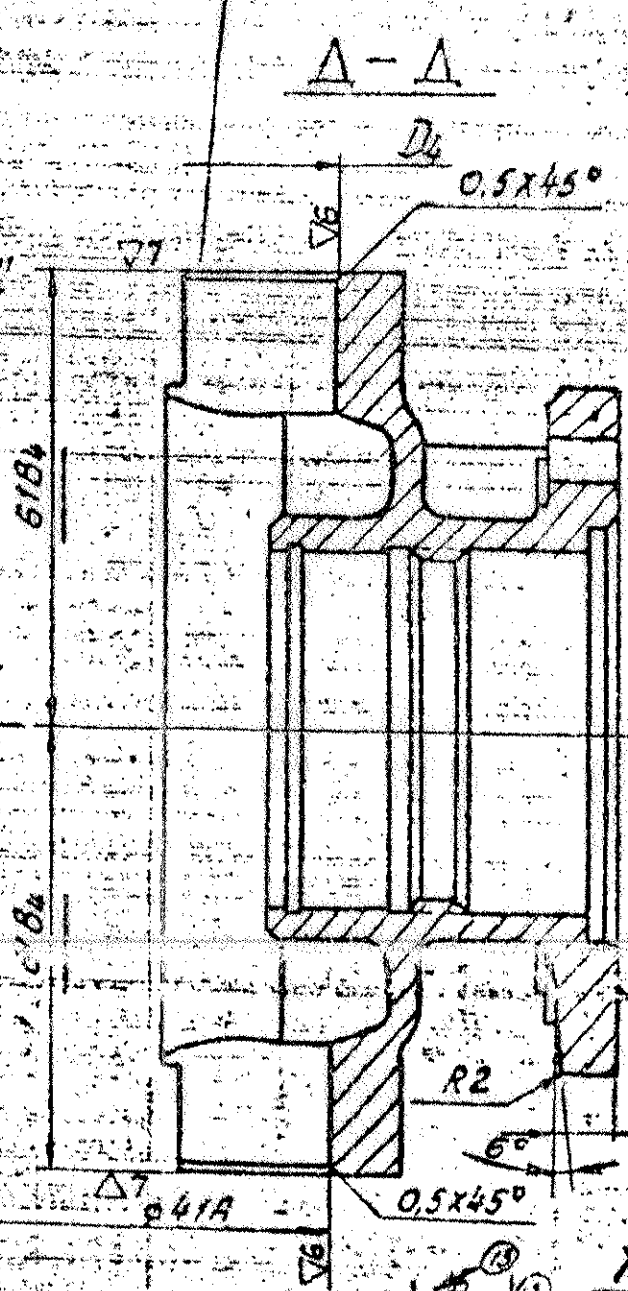
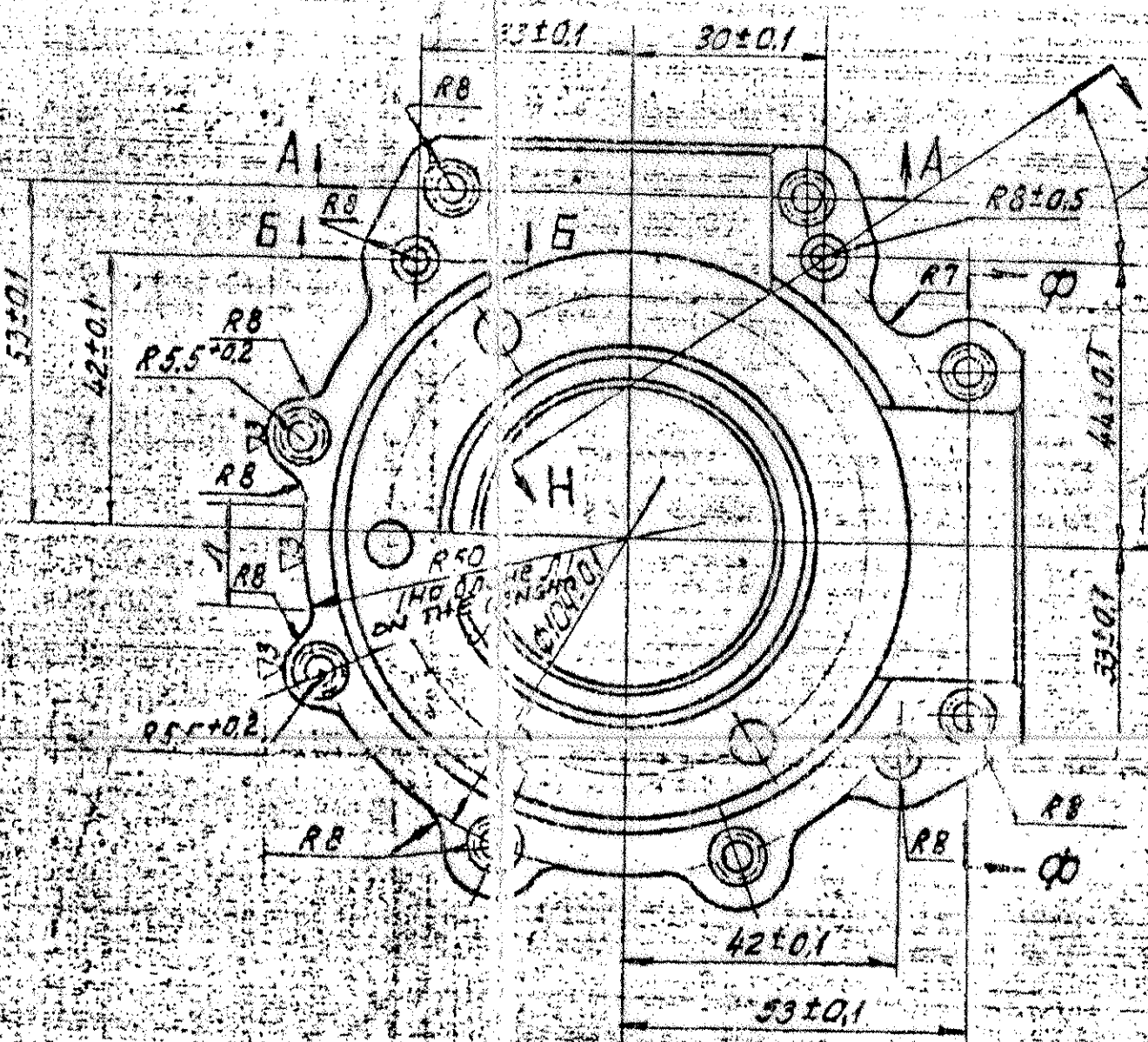
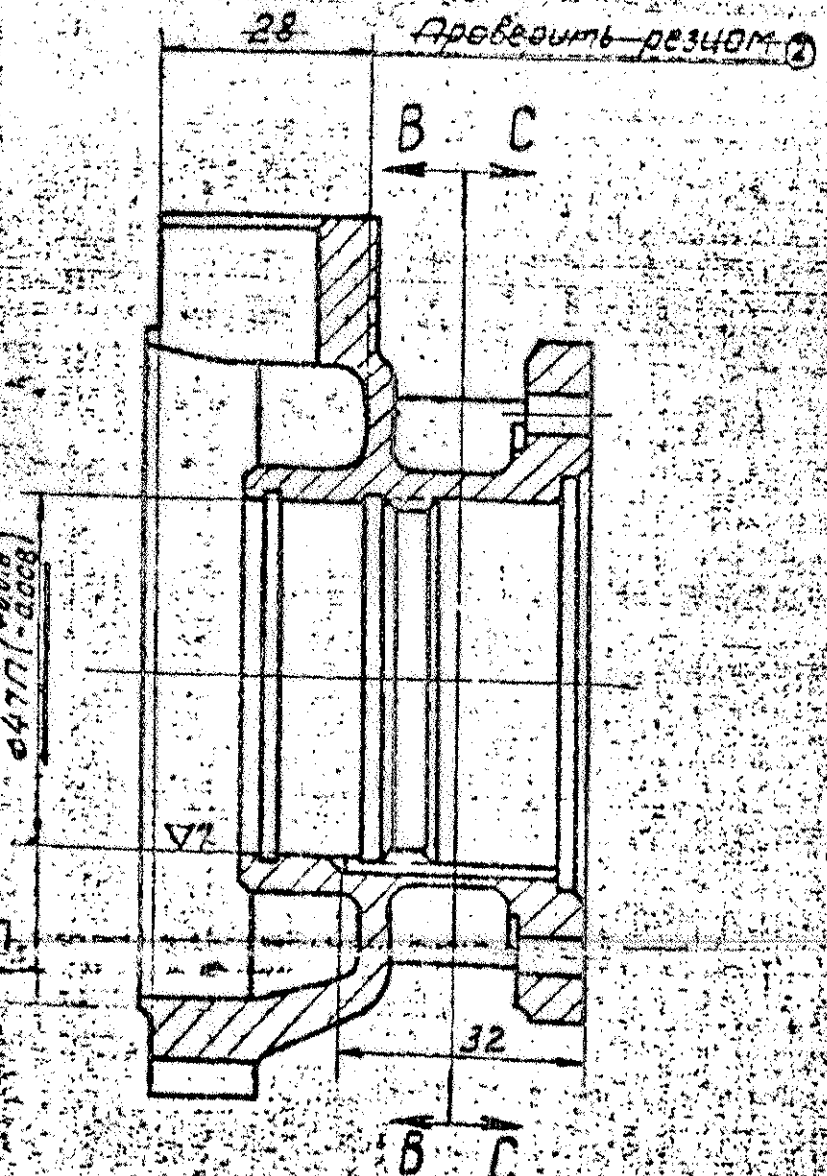
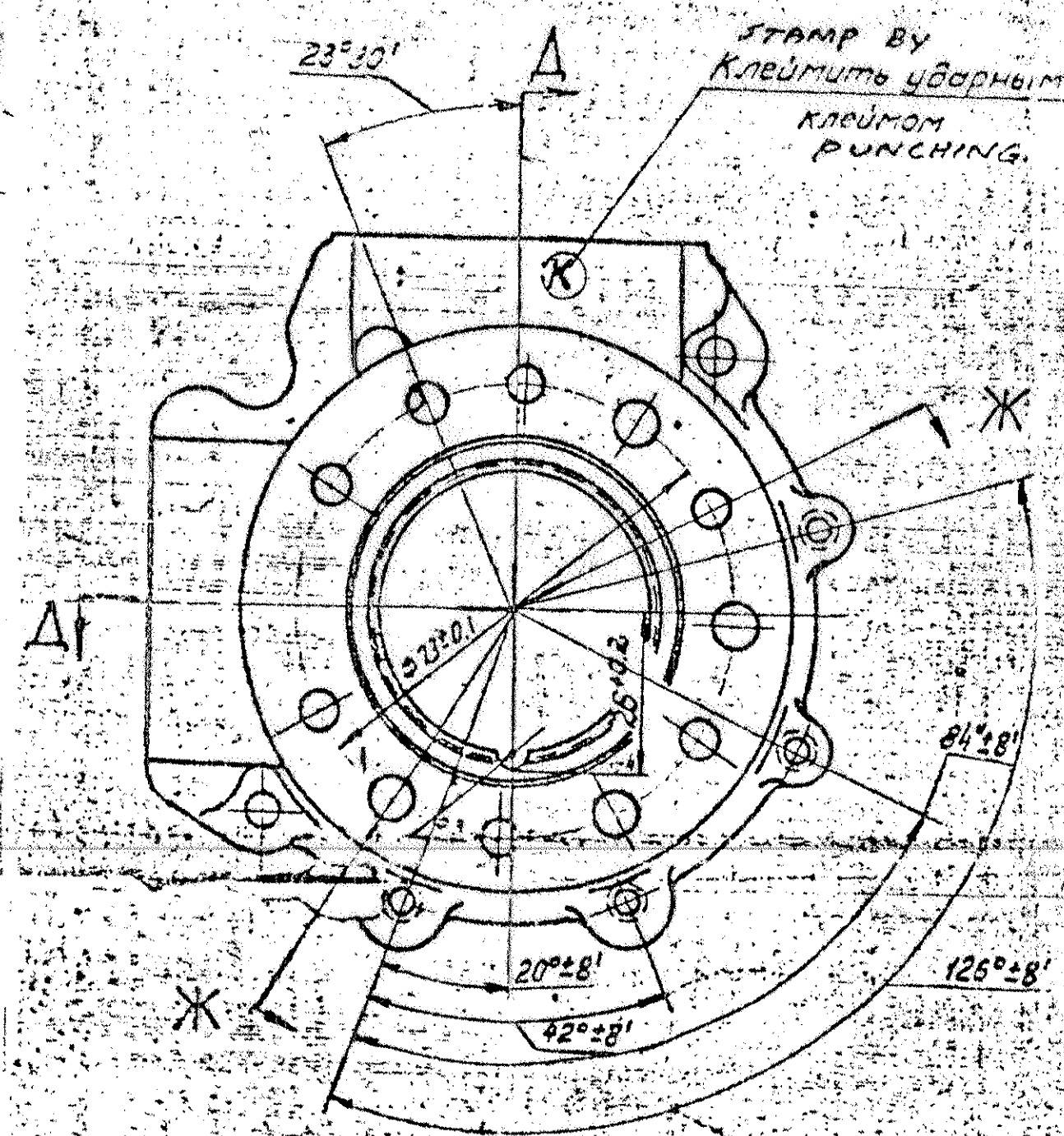
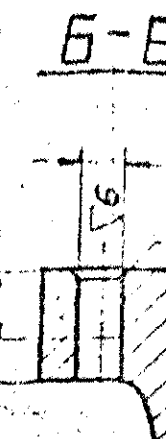
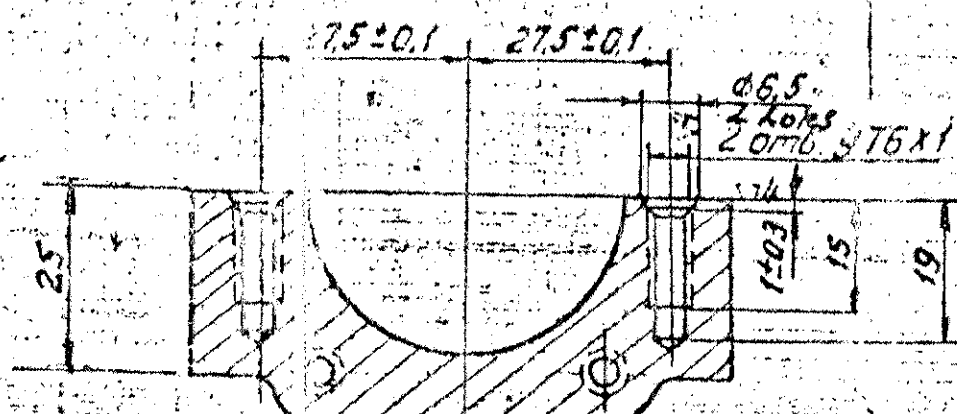
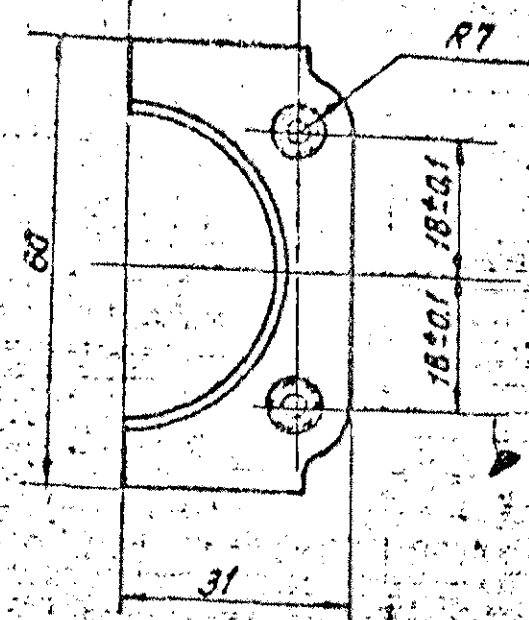
UNLESS OTHERWISE
SPECIFIED.
ОСТАЛЬНОЕ

Допуски на литые по
56-15 (АН1026-55)
TOLERANCES ON FREE DIMENSIONS
Допуски на свободные
AS PER
размеры по 22AT52 кл. 7

2 holes
20mm, M
0.3 x 450

ДИМENSION M. РАЗМЕР M	GROUP Группа	NOTE ПРИМЕЧАН.
Ф 6 (-0,035)	I	Допускается вернуться к старому размеру
Ф 6,1 (-0,035)	II	
Ф 6,2 (-0,035)	III	

DIMENSION D ₀ COMPONENT	
Passive D ₀	N ₀ G ₀ M ₀
Q ₀ A	AK 150B-001-C



1. THE INSPECTION GROUP OF CASTING - SECOND.
2. GRILL CASTING. ACCURACY CLASS ΔT_4 .
3. UNSPECIFIED RADIUS TRANSITIONS IN CASTING SHOULD BE R3.
4. ENSURE THE UNDERLINED DIMENSIONS IN UNIT 1508-02 C/B.
5. MACHINE HOLE M TOGETHER WITH COMPONENT AK 1508-001-C/B.
6. CHAMFERS SHOULD BE MADE TO A THREAD DEPTH AT AN ANGLE OF 90
7. RUN OUT OF SURFACE D5 RELATIVE TO SURFACE "K" SHOULD NOT EXCEED 0.1.
8. TO BE ANODIZED, EXCEPT FOR PLACES TO BE MACHINED IN UNIT AK 1508-02.
9. ANODE COATING MAY BE REMOVED FROM SURFACES D,D1, D2, D3, T1 AND D6.

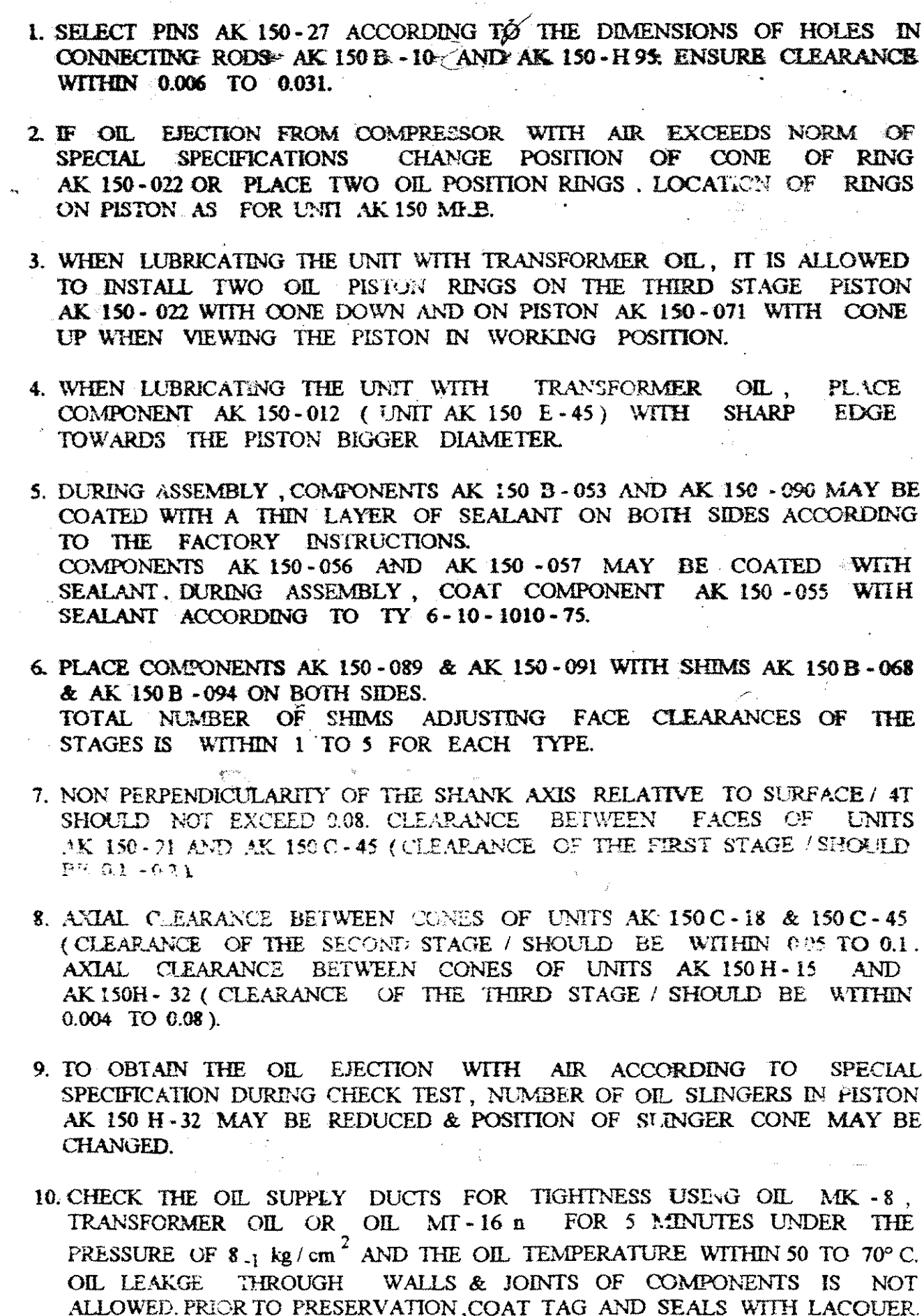
ALONG
① ВСЕГДА
ПРОДОЛЖАЮТ
КОММУНУ.
ENTIRE CONTINUE

NOT AMPLE SHOULD BE

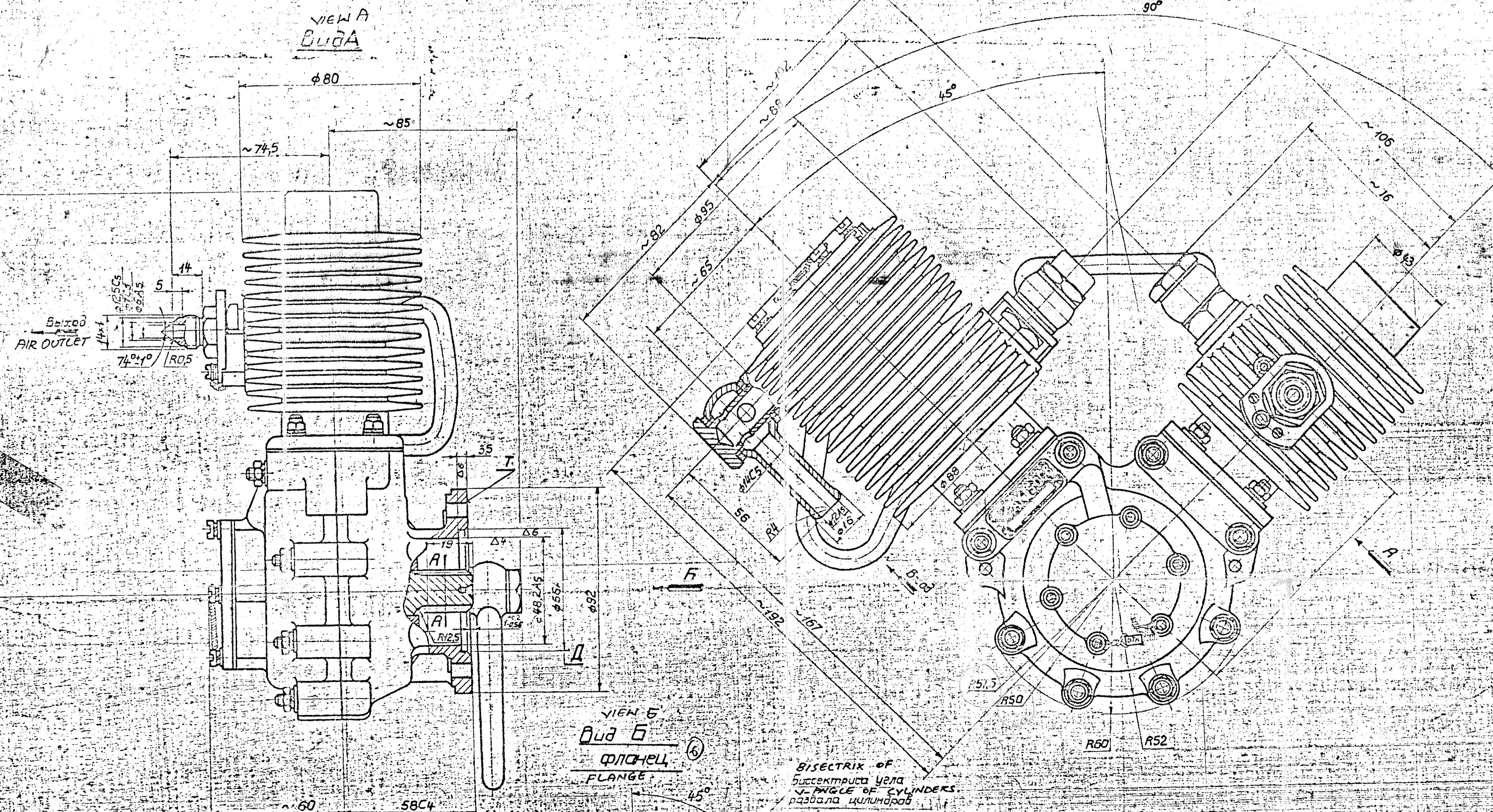
BE APPROPRIATELY LABELED BEFORE MILK PRODUCTION
EST. MASS. TO BE STAMPED OR MARKED WHERE
417 INDICATED. THUS:

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MACHINED CORNERS TO INHERE OUTSIDE R. INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.
MATERIAL: ALUMINUM ALLOY
QST 90021-72
USE: 44-AR150B-044-AC
CONTROL DATE OF INSPECTION: 10-1-72
TITLE: CRANK CASE (HEAD PART)

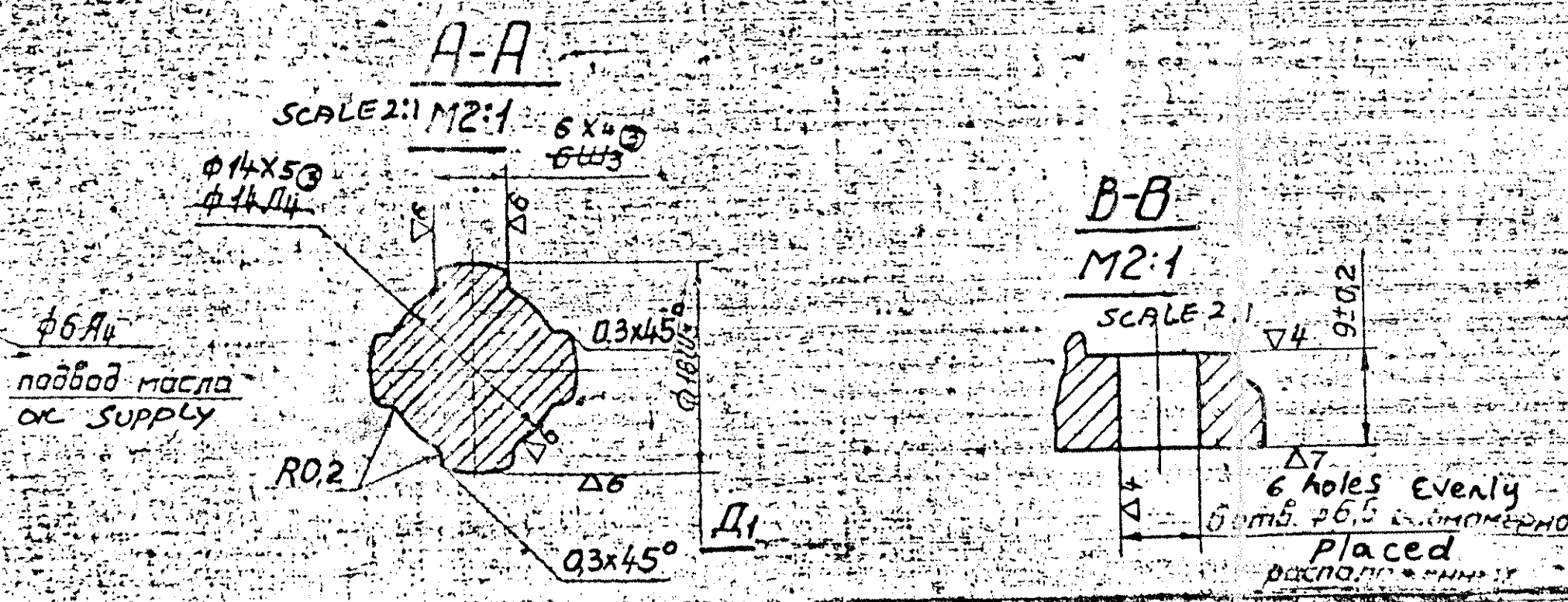
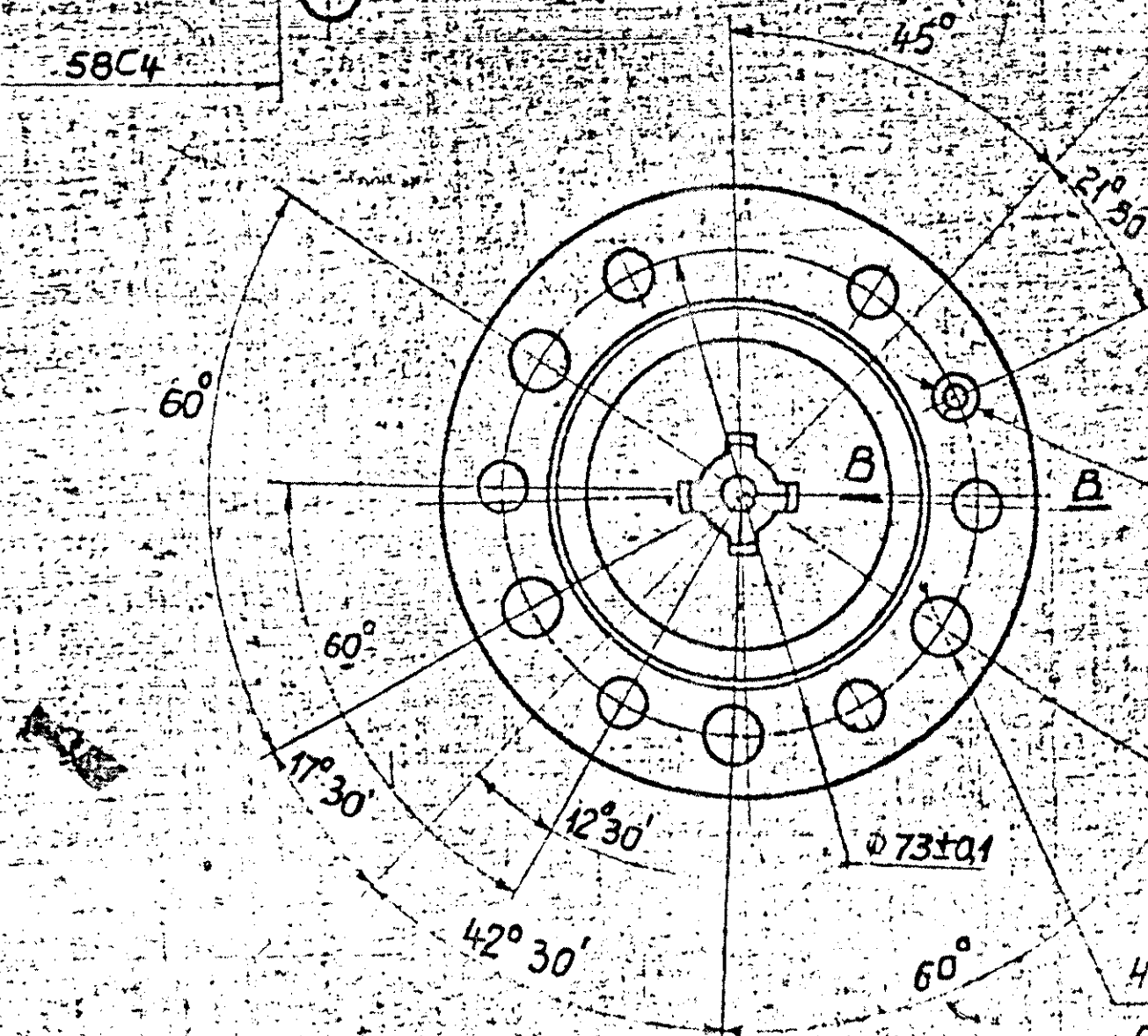
15 CAT NUMBER	1503-002-C
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PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION:		CRN CHD TED APFD DATE 12/24/2000 FILE # 101		MATERIAL -- USED ON -- 172 45 060605	
EST. WT. TO BE STAMPED OR MARKED WHERE INDICATED THUS 46 LETTERS		DIMENSIONS IN MM TOLERANCE 0.01MM UNLESS OTHER STATED IS 210" - 67		CONTROL RATE OF QUALITY ASSURANCE HEAVY VEHICLES A V A I	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MACHINED CORNERS TO HAVE R. OUTSIDE CORNER EDGES TO HAVE R. ARE PERMISSIBLE.		ALL THREADS TO CONFIN TO		TITLE: AVIATION COMPRESSOR AK-150C-AS-111814	
DATE OF INSPECTION: 12/24/2000 NAME OF INSPECTOR: [Signature]		DATE OF APPROVAL: 12/24/2000 NAME OF APPROVER: [Signature]		D S CAT NUMBER DRAWING NUMBER AK 150C-0105	



1. ENSURE FLEXIBLE CONNECTION OF THE SPLINE SHANK WITH THE DRIVE BUSHING USING SPRING OR COUPLING.
2. RUN OUT OF SURFACE Δ 1 RELATIVE TO SURFACE Δ , SHOULD NOT EXCEED 0.08.
3. NON PERPENDICULARITY OF THE SHANK AXIS RELATIVE TO SURFACE T SHOULD NOT EXCEED 0.08.
4. DURING INSTALLING, BISSETRIX OF THE V-ANGLE OF CYLINDERS MAY DEVIATE FROM VERTICAL POSITION:
 - a. TOWARDS THE HIGH PRESSURE CYLINDER 19°; max;
 - b. TOWARDS THE LOW PRESSURE CYLINDER 31°; max;



4 HOLES FOR OIL DRAIN AND
HOLES FOR AIR CRANK PUMP

BRATTING OF COMPRESSOR CRANK CASE

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

EST. MASS.	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	COK dd	MATERIAL	USED ON:
			CHD	Belladonna		AK 150 C-01 CE
			TCD	d. Mahern		
			APPD	[Signature]		
			DATE	23/7/86	CONTROLLERATE OF INSPECTION(HEAVY VEHICLES)	
			SCALE	1:1	AYADI	
			DIMENSIONS IN mm		TITLE	AVIATION COMPRESSOR
			TOLERANCE ON DIMMS UNLESS OTHERWISE STATED.			AK 150C - OUT LINE DRAWING
			ALL THREADS CONFORM TO		U.S. CAT NUMBER	DRAWING NUMBER
						AK150C-1
ISSUE	DATE	NATURE OF AMENDMENTS				

DRAWING NUMBER
AK150H-15-C6

TOLERANCES ON FREE DIMENSIONS ARE AS PER 22 AT 52-cl.7.

GROOVE HAVING WIDTH OF UPTO 1.0 mm DEPTH OF UPTO 0.1 mm -
OVER DIAMETER IS ALLOWED ON SURFACE D₂ NEAR TAPER.
HEAT PART AK150H-054 UPTO A TEMPERATURE OF 220°C BEFORE
PRESS FITTING PART AK150B-088.

BEFORE PRESSING, COAT SURFACE OF PART AK150B-088 WITH
UNIFORM LAYER OF BAKELITE VARNISH OR VARNISH K 965,
GOST 15030-69, AS PER TECHNOLOGICAL INSTRUCTIONS. CHECK
SURFACE K BY BLUEING. CLOSE-FIT AS PER GAUGE SHOULD BE
AT LEAST 75%.

DIFFERENCE OF ANGLES IN GAUGES USED FOR CHECKING TAPERS
OF PARTS AK150H-15 AND AK150B-30 SHOULD NOT EXCEED 20'.
RUN-OUT OF SURFACE D₃ AND D₂ WITH RESPECT TO CORRESPONDING
ANGLE DIAMETERS OF THREADS M₁ AND M₂ SHOULD NOT EXCEED 0.1mm.
RUN-OUT OF SURFACE D₁ WITH RESPECT TO SURFACE D₂ SHOULD
NOT EXCEED 0.02 mm.

DEVIATION FROM SQUARENESS OF SURFACE D₂ TO SURFACE T SHO-
ULD NOT EXCEED 0.03 mm.

DIFFERENCE IN WALL THICKNESS OF SLEEVE SHOULD NOT EXCEED
0.1 mm. OVALITY,

CONCAVITY AND CONVEXITY OF SURFACES D₁ AND D₂ SHOULD NOT
EXCEED 0.005 mm.

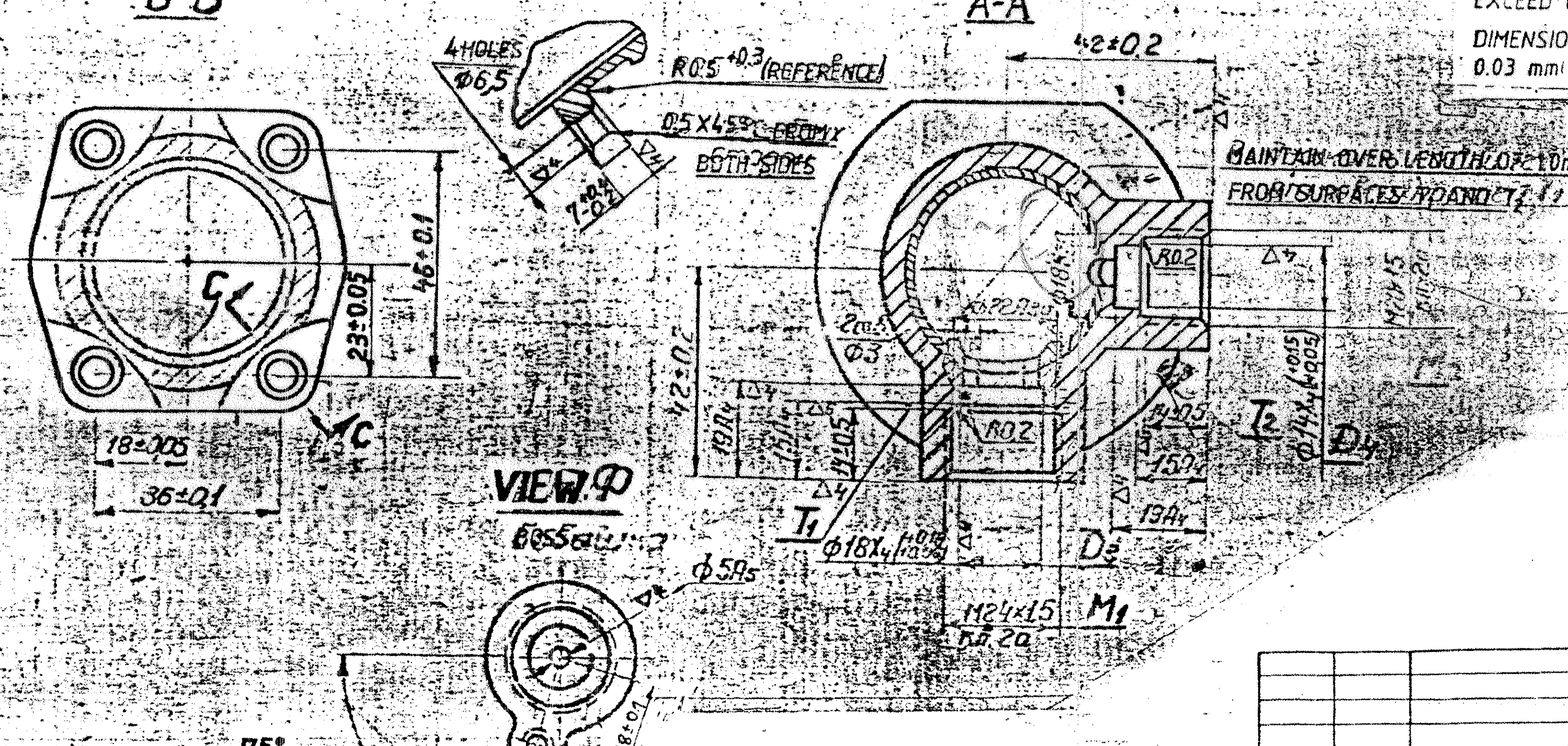
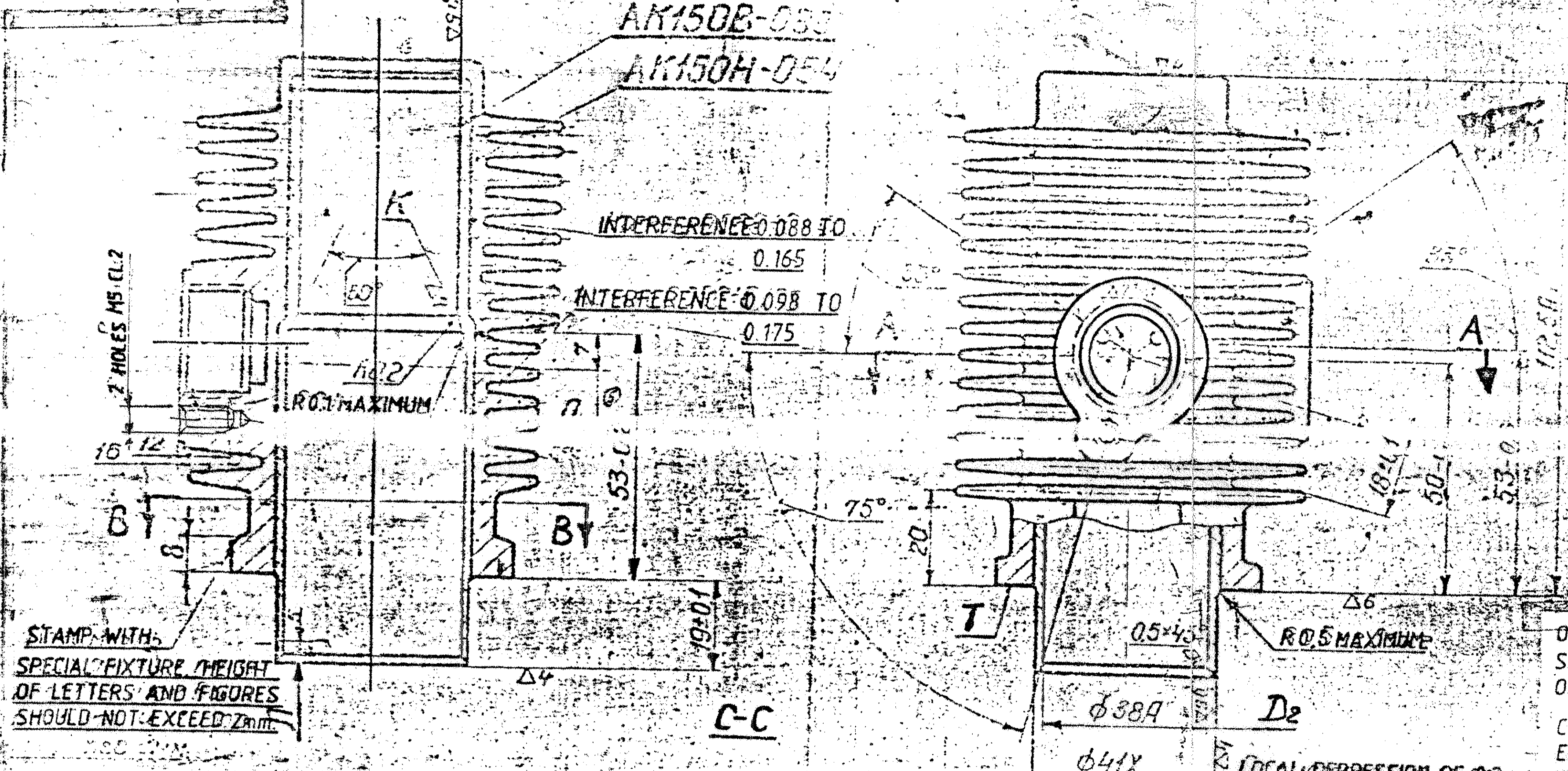
TAPER SHOULD NOT EXCEED 0.01 mm. LOBING IS NOT ALLOWED.

OVALITY AND TAPER NOT EXCEEDING 0.03 mm ARE ALLOWED ON
SECTION 2. MAKE CHAMFERS TO DEPTH OF THREAD AT AN ANGLE
OF 90°.

CHECK NON-FLATNESS OF SURFACE T WITH TOOL MAKER'S STRAIGHT
EDGE; CLEARANCE OF UPTO 0.03 mm IS ALLOWED. CHECK AIR TIGHT-
NESS BY AIR AT A PRESSURE OF 150 kg/cm². AIR LEAKAGE ALONG
GENEATRIXES OF SURFACES WITH MEDIUM DRIVE FIT SHOULD NOT
EXCEED 60 BUBBLES PER MINUTE.

DIMENSION OF SURFACE D₂ MAY BE REDUCED BY NOT MORE THAN
0.03 mm ON SECTION J.

AIR LEAKAGE THROUGH
CAST SURFACE IS NOT
ALLOWED. TOTAL



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

EST. MASS. 716 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	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
CHD	CHD	CHD	CHD	22.7.80	1:1					AK 150H-15-C6
CONTROLLERATE OF INSPECTION(HEAVY VEHICLES)									TITLE: CYLINDER III STAGE ASSY	
MAINTAIN OVER LENGTH OF 10mm FROM SURFACES TO ANCHORS									USED ON:- AK 150 C-01 C5	
PILLOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.									AVADI	
EST. MASS. 716 TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)									D S CAT NUMBER	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT- SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.									DRAWING NUMBER	
TOLERANCES ON FREE DIMENSIONS ARE AS PER 22 AT 52-cl.7.									AK 150H-15-C6	
GROOVE HAVING WIDTH OF UPTO 1.0 mm DEPTH OF UPTO 0.1 mm - OVER DIAMETER IS ALLOWED ON SURFACE D ₂ NEAR TAPER. HEAT PART AK150H-054 UPTO A TEMPERATURE OF 220°C BEFORE PRESS FITTING PART AK150B-088.									ISSUE DATE NATURE OF AMENDMENTS	