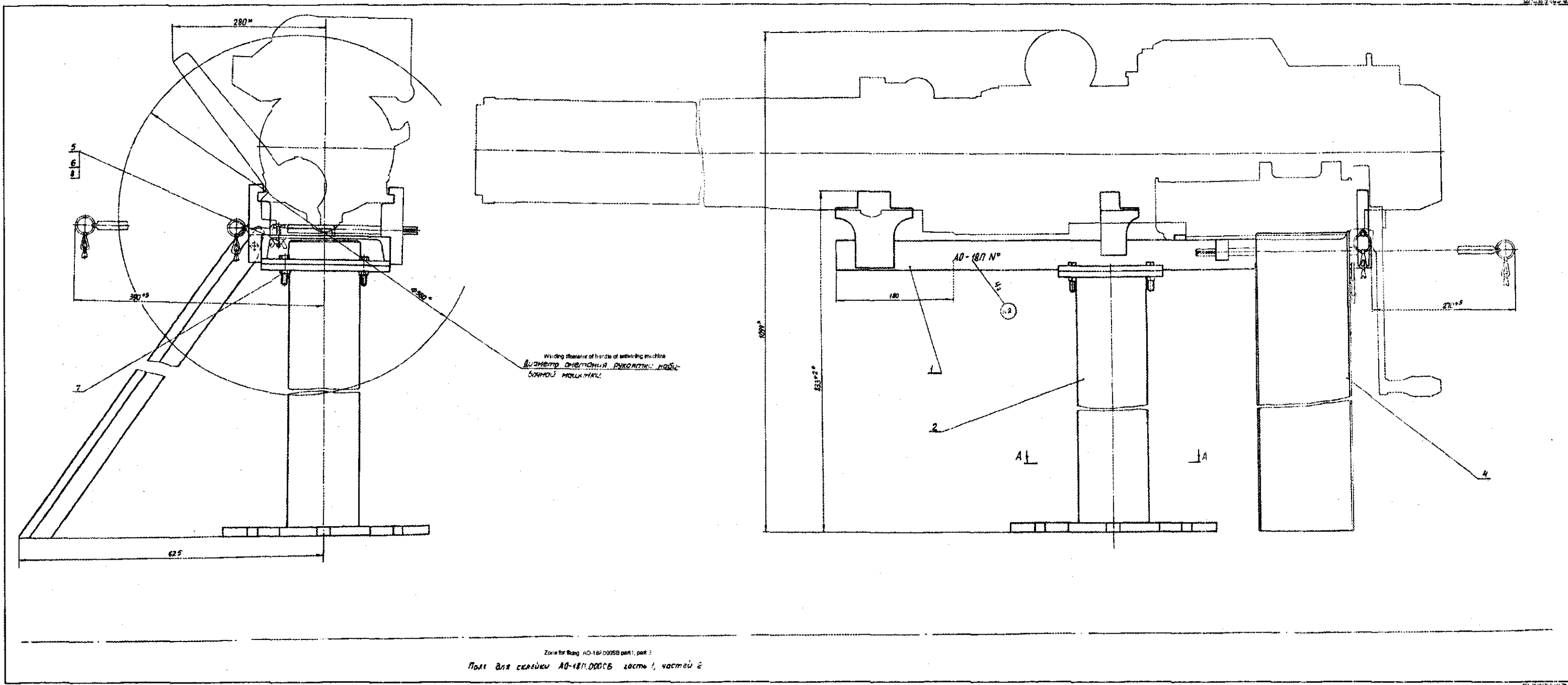


GUN & SHELL FACTORY COSSIPORE KOLKATA-700 002

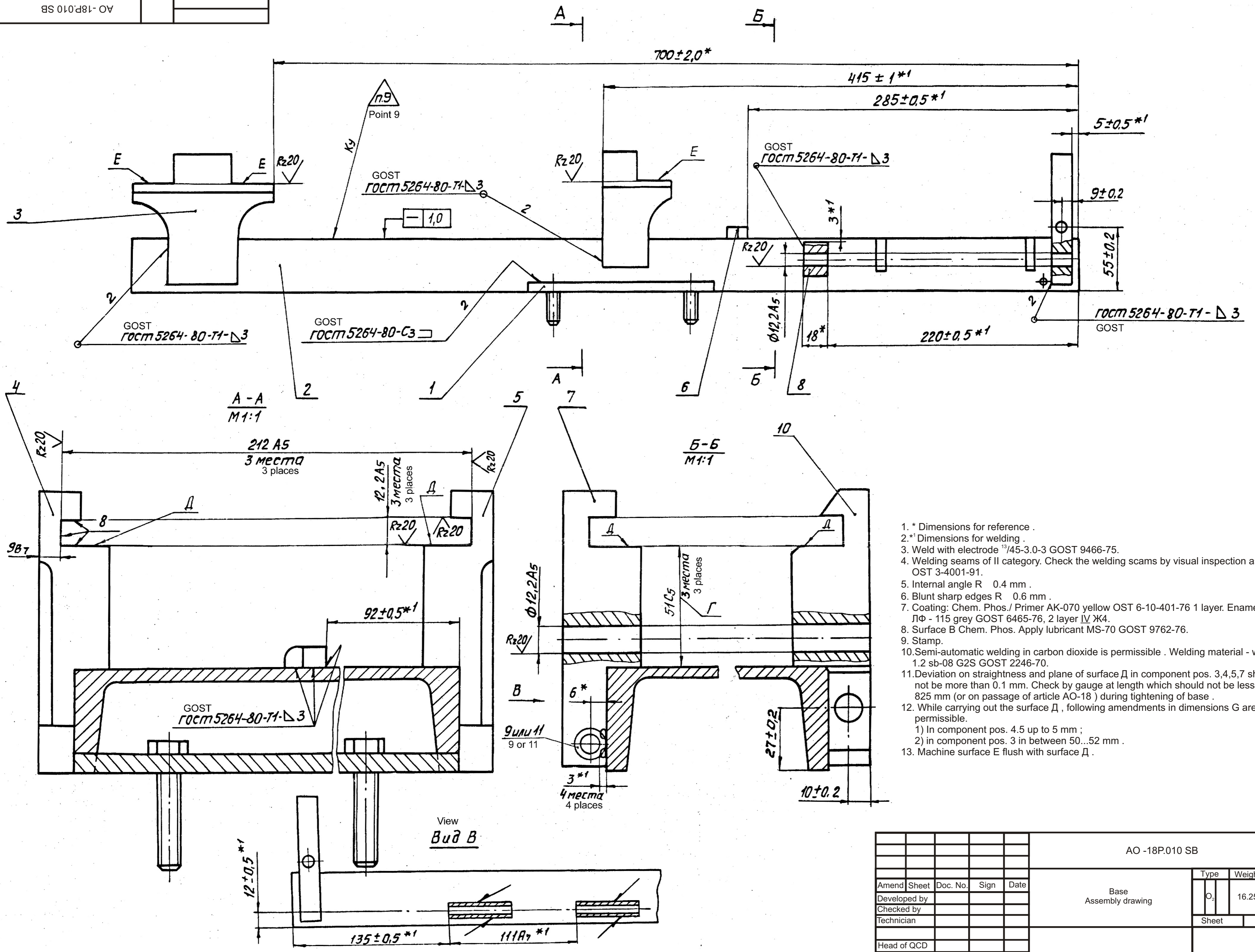


First use		Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks	
		<u>Documents</u>							
		A1			AO-18P.000 SB	Assembly drawing	10/0		
		<u>Assembly units</u>							
		A4	1		AO-18P.010	Base plate	5/1	1	
		A4	2		AO-18P.030	Support	5/1	1	
		A4	3		AO-18P.040	Locator with chain	5/1	1	
		A4	4		AO-18P.050	Tray	5/1	1	
		<u>Standard articles</u>							
			5			Screw M6-8gx35.109.40Kh.029			
			6			GOST 17475-80			
						Nut M6-6G.8.35.05			
			7			GOST 3032-76			
						Nut M10-6G.25.05			
			8			GOST 3032-76			
						Washer 6.65G.026			
						GOST 6402-70.			
		<u>Set of packing materials</u>							
		A4			AO-18PYa.000	Transportation box	5/1	1	
		AO-18P.000							
		Amend.	Sheet	Doc. No.	Sign	Date			
		Developed by							
		Checked by							
		Head of Q.C.D							
		Approved by							
		Fixture					Type	Sheet	Sheets

Orig. Inv. No. Sign and Date Alternate Inv. No. Dupl. Inv. No. Sign and Date



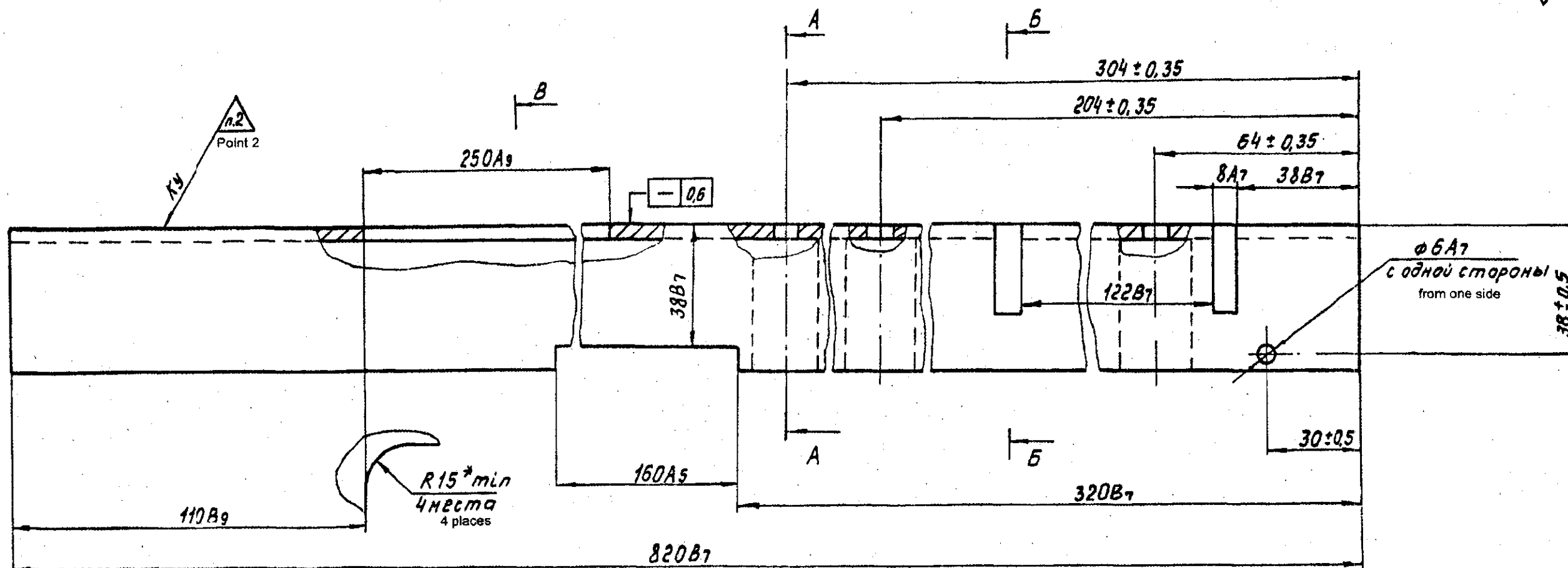
First use		Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks	
						<u>Documents</u>			
		A2			AO-18P.010 SB	Assembly drawing 162-10/9			
Reference No.						<u>Assembly units</u>			
		A4	1		AO-18P.020	Flange	1		
						<u>Components</u>			
		A2	2		AO-18P.001	Base plate 10/9	1		
		A3	3		AO-18P.002	Front support 7/4	2		
		A3	4		AO-18P.003	Right middle support 7/4	1		
		A3	5		AO-18P.004	Left middle support	1		
		A4	6		AO-18P.005	Stop	1		
		A4	7		AO-18P.006	Rear support	1		
		A4	8		AO-18P.007	Lug 5/1	1		
		WD	9		AO-18P.022	Loop	1	2 nos.	
						Pipe 12x2.5		repl. with	
						GOST 8734-75/V20		pos.11	
						GOST 8733-74			
						L = 55 mm			
		A4	10		AO-18P.006-01	Rear support	1		
		AO-18P.010							
		Amend.	Sheet	Doc. No.	Sign	Date			
		Developed by					Type	Sheet	Sheets
		Checked by					02	1	2
		Head of Q.C.D							
		Approved by							
Orig. Inv. No.		Base plate							
Sign and Date									
Alternate Inv. No.									
Dupl. Inv. No.									
Sign and Date									



- 1. * Dimensions for reference .
- 2.*1 Dimensions for welding .
- 3. Weld with electrode 19/45-3.0-3 GOST 9466-75.
- 4. Welding seams of II category. Check the welding seams by visual inspection as per OST 3-4001-91.
- 5. Internal angle R 0.4 mm .
- 6. Blunt sharp edges R 0.6 mm .
- 7. Coating: Chem. Phos./ Primer AK-070 yellow OST 6-10-401-76 1 layer. Enamel ЛФ - 115 grey GOST 6465-76, 2 layer IV Ж4.
- 8. Surface B Chem. Phos. Apply lubricant MS-70 GOST 9762-76.
- 9. Stamp.
- 10. Semi-automatic welding in carbon dioxide is permissible . Welding material - wire 1.2 sb-08 G2S GOST 2246-70.
- 11. Deviation on straightness and plane of surface Д in component pos. 3,4,5,7 should not be more than 0.1 mm. Check by gauge at length which should not be less than 825 mm (or on passage of article AO-18) during tightening of base .
- 12. While carrying out the surface Д , following amendments in dimensions G are permissible.
 - 1) In component pos. 4.5 up to 5 mm ;
 - 2) in component pos. 3 in between 50...52 mm .
- 13. Machine surface E flush with surface Д .

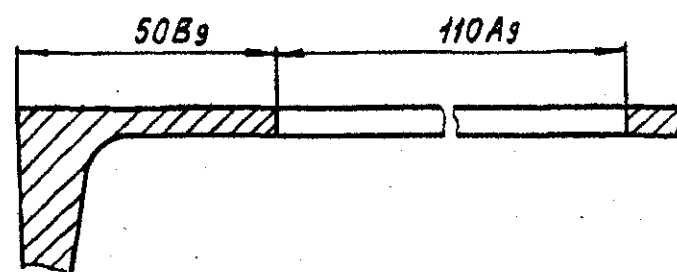
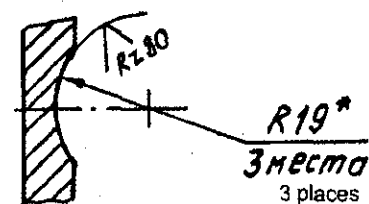
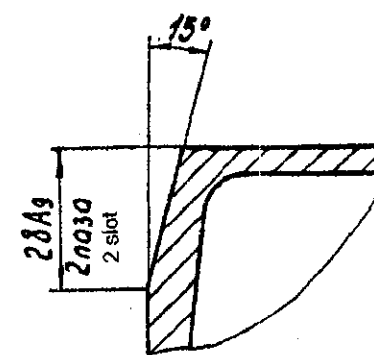
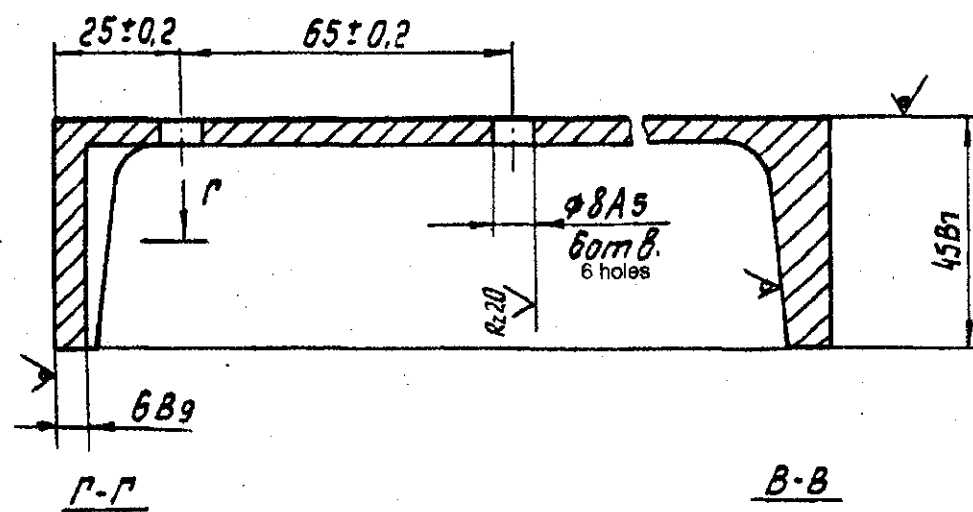
First remarks
 Refer. No.
 Duplicate Inv. No / Sign and Date
 Sign and Date
 Inv. No.

					AO -18P.010 SB			
Amend	Sheet	Doc. No.	Sign	Date	Base Assembly drawing	Type	Weight	Scale
Developed by	Checked by	Technician	Head of QCD	Approved by		O ₂	16.25	1:2
						Sheet	Sheets 1	



A-A

B-B



1.*Dimensions are ensured by tool.
2. Stamp.

First remarks
Refer. No.
Duplicate Inv. No. Sign and Date
Sign and Date
Inv. No.

					AO-18P.001			
Amend	Sheet	Doc. No.	Sign	Date	Base	Type	Weight	Scale
Developed by	Checked by	Technician				O ₂	11.0	1:1
					Channel	20 GOST 8240-72 B Sm3ps-2-1 GOST 1535-79		
					Sheet	Sheets 1		
					Format A2			

AO- 18 P.002

First use

Reference No.

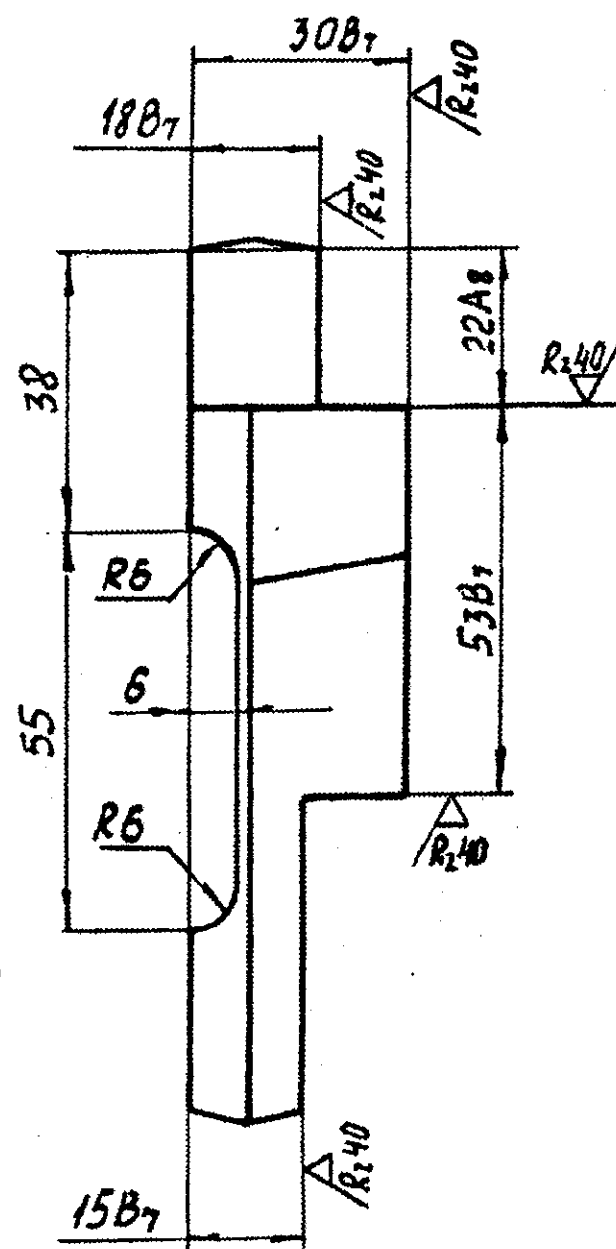
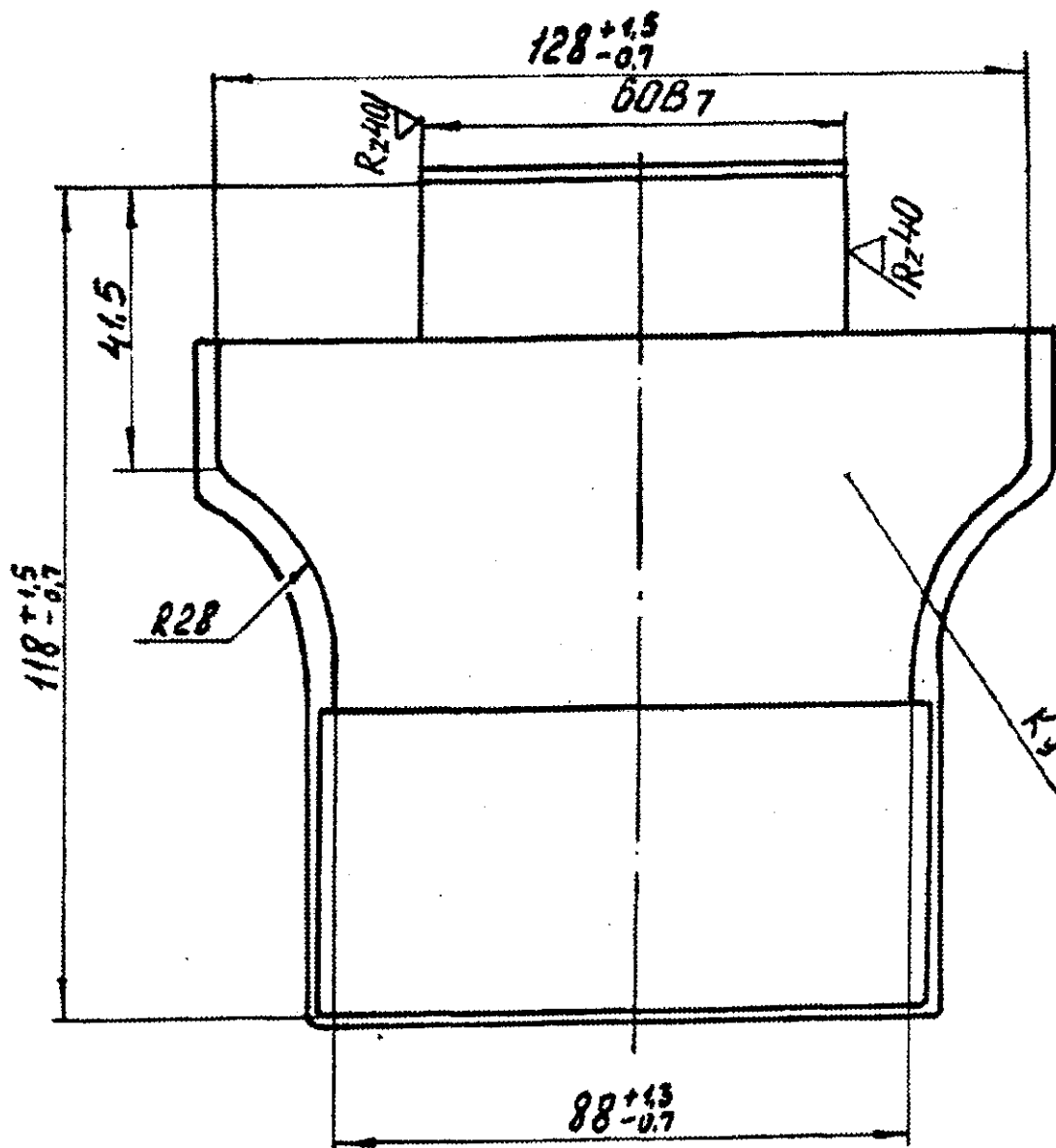
Sign and Date

Alternate Inv. No

Replaced inv no.

Sign and Date

Orig. Inv. No.



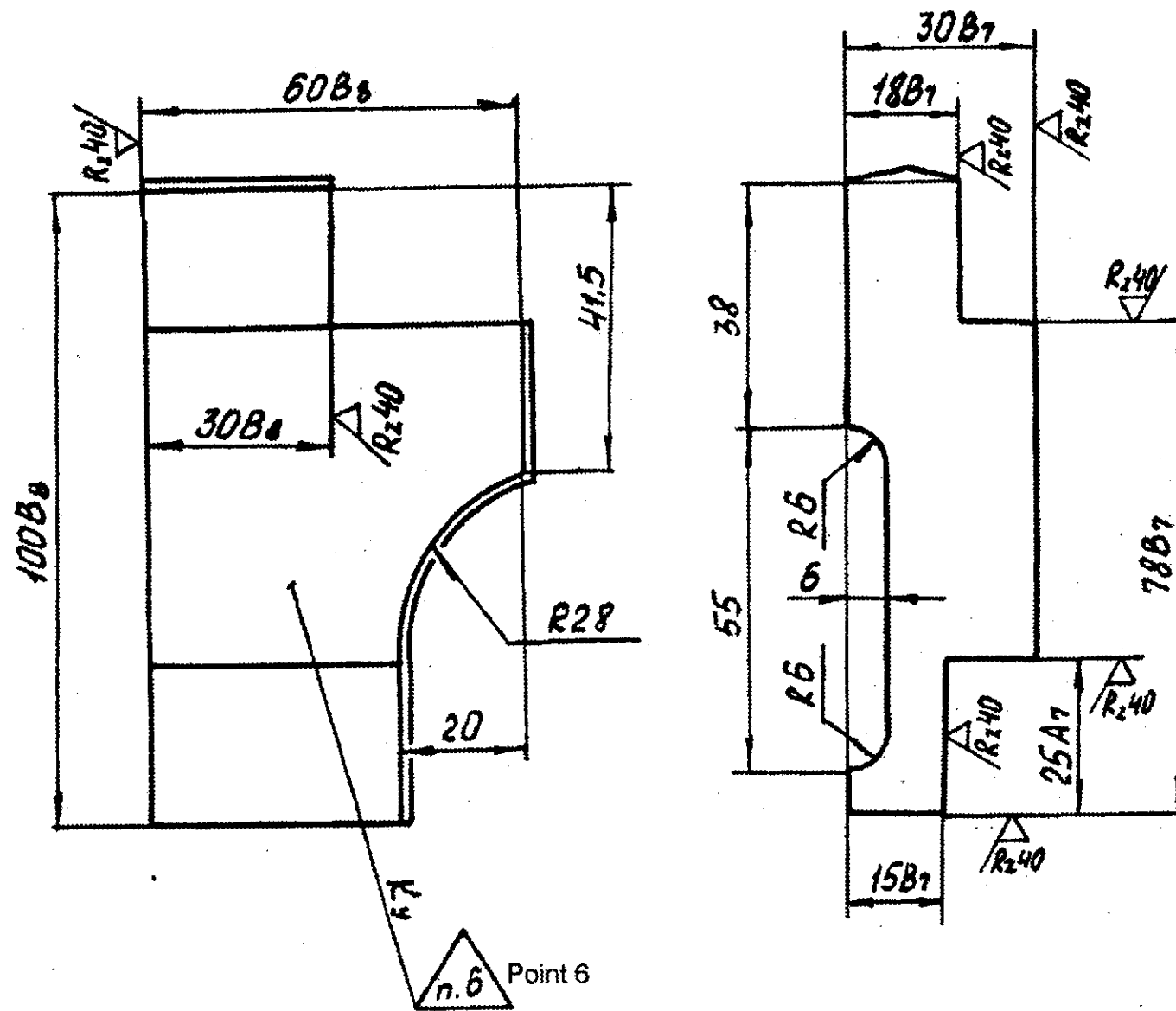
✓(✓)

1. Forging gradients-7°.
2. Accuracy grade of forging T5 as per GOST 7505-89. Forging Gr I GOST 8479-70.
3. Radii R~2 mm .Unless otherwise specified.
4. Inner angles R ≈ 0.4 mm.
5. Blunt edges R ≈ 0.6 mm.
6. Stamp

					AO- 18P .002			
Amend.	Sheet	Doc. No.	Sign	Date	Front support	Type	Weight	Scale
							O ₂	1.5
Developed by								
Checked by								
Head of bureau					Sheet			
Head of Q.C.D					Sheets 1			
Approved by					Steel 25 GOST 1050-74			

Format A3

Orig. Inv. No.	Sign and Date	Replaced inv no.	Alternate Inv. No	Sign and Date	Reference No.	First use
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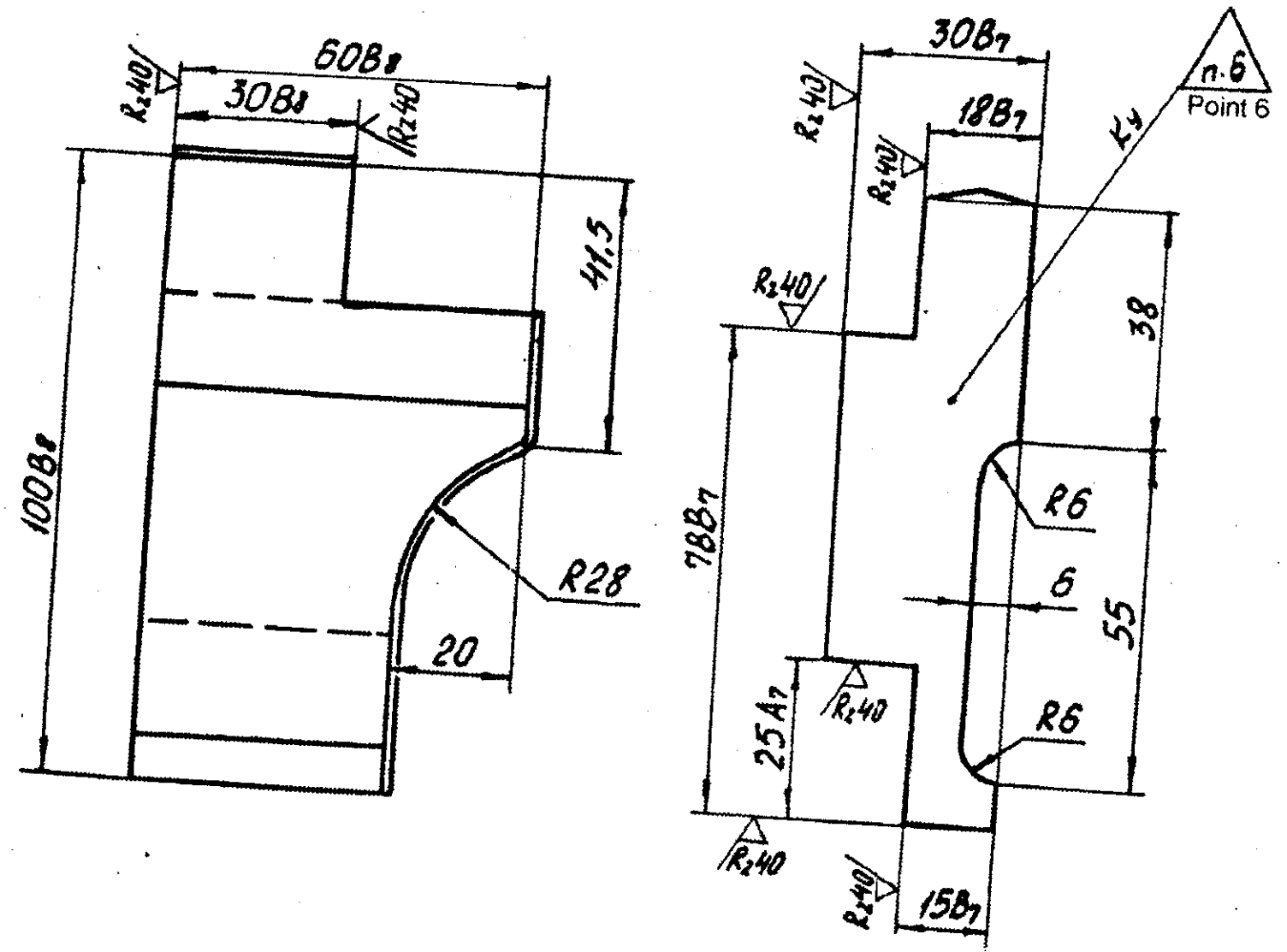


✓(✓)

1. Forging gradients-7°.
2. Accuracy grade of forging T5 as per GOST 7505-89. Forging Gr I GOST 8479-70.
3. Radii R~2 mm ; unless otherwise specified.
4. Inner angles R ≈ 0.4 mm.
5. Blunt edges R ≈ 0.6 mm.
6. Stamp.

					AO- 18P .003			
Amend.	Sheet	Doc. No.	Sign	Date	Right middle support	Type	Weight	Scale
Developed by						O ₂	0.8	1:1
Checked by						Sheet	Sheets 1	
Head of bureau					Steel 25 GOST 1050-74			
Head of Q.C.D								
Approved by								

✓(✓)



1. Forging gradients-7°
2. Accuracy grade of forging T5 as per GOST 7505-89. Forging Gr I GOST 8479-70.
3. Radii R~2 mm ; unless otherwise specified.
4. Inner angles R ≈ 0.4 mm.
5. Blunt edges R ≈ 0.6 mm.
6. Stamp.

					AO- 18P .004			
Amend.	Sheet	Doc. No.	Sign	Date	Left middle support	Type	Weight	Scale
Developed by						O ₂	0.8	1:1
Checked by Head of bureau						Sheet	Sheets 1	
Head of Q.C.D					Steel 25 GOST 1050-74			
Approved by								

Orig. Inv. No.	Sign and Date	Replaced inv no.	Alternate Inv. No	Sign and Date	Reference No.	First use

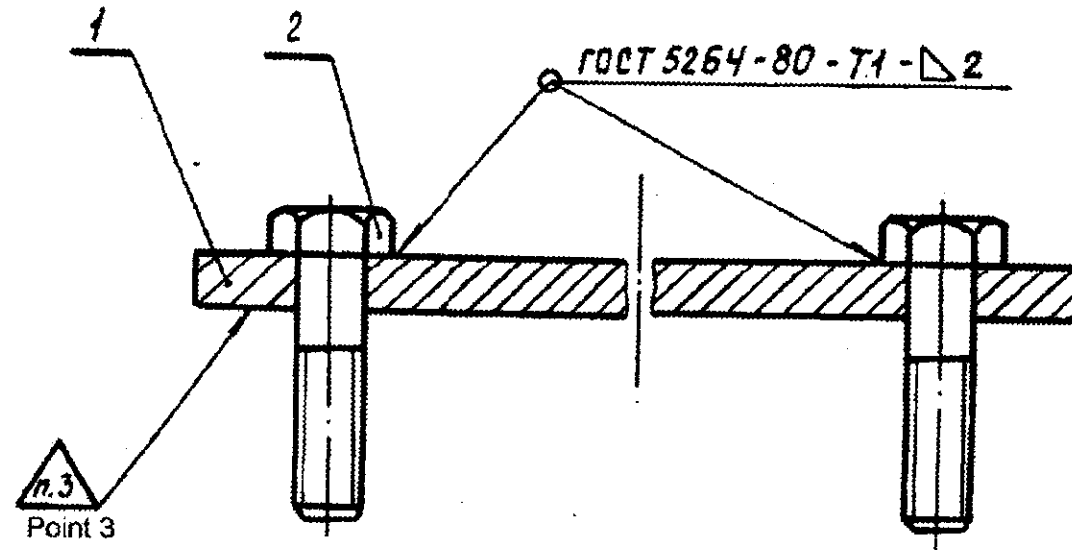
AO-18P.006											
Approved OGMet	Approved by shop										
Approved KTONI	Reference No.										
Approved TOSb	Sign and Date										
Alternate Inv. No.	Dupl. Inv. No.										
		<table border="1" style="margin: auto;"> <tr> <th>Designation</th> <th>Fig.</th> </tr> <tr> <td>AO-18P.006</td> <td>1</td> </tr> <tr> <td>-01</td> <td>2</td> </tr> </table>		Designation	Fig.	AO-18P.006	1	-01	2		
Designation	Fig.										
AO-18P.006	1										
-01	2										
		<p>1. Inner angles R~0.4 mm. 2. Blunt edges R~0.6 mm. 3. Stamp.</p>									
Approved OGMet	Sign and Date	AO-18P.006									
Orig. Inv. No.	Amend.	Sheet	Doc. No.	Sign	Date						
	Rear support		Type	Weight	Scale						
			O ₂	0.425	1:2						
			Sheet	Sheets 1							
	Steel 25 GOST 1050-74										

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Format A4

First use		Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks	
Reference No.		A4			AO-18P.020 SB	Assembly drawing 5/1			
						<u>Documents</u>			
						<u>Components</u>			
		A4	1		AO-18P.008	Flange 5/1	1		
						<u>Standard articles</u>			
			2			Bolt M10-8gx40.109.40Kh.029 GOST 7798-70	4		
Sign and Date									
Dupl. Inv. No.									
Alternate Inv. No.									
Sign and Date									
Orig. Inv. No.									
		Amend.	Sheet	Doc. No.	Sign	Date	AO-18P.020		
		Developed by					Type	Sheet	Sheets
		Checked by					02		1
		Head of Q.C.D.					Flange		
		Approved by							

AO-18P.020 SB



1. Weld with electrodes UONIИ 13/45-3.0-3 GOST 9466-75.
2. Welding joints –category II.
Check welding joints visually for compliance to OST 3-4001-91.
3. Stamp K_U.
4. Semi automatic welding permissible in carbon dioxide medium.
Filler material- wire 1.2 sv-08G2S GOST 2246-70.

Approved OGMet	Approved by shop	Approved KTONI	Approved T Osb	Approved Inv. No.	Dupl. Inv. No.	Sign and Date	Sign and Date	Sign and Date	Reference No.	First use
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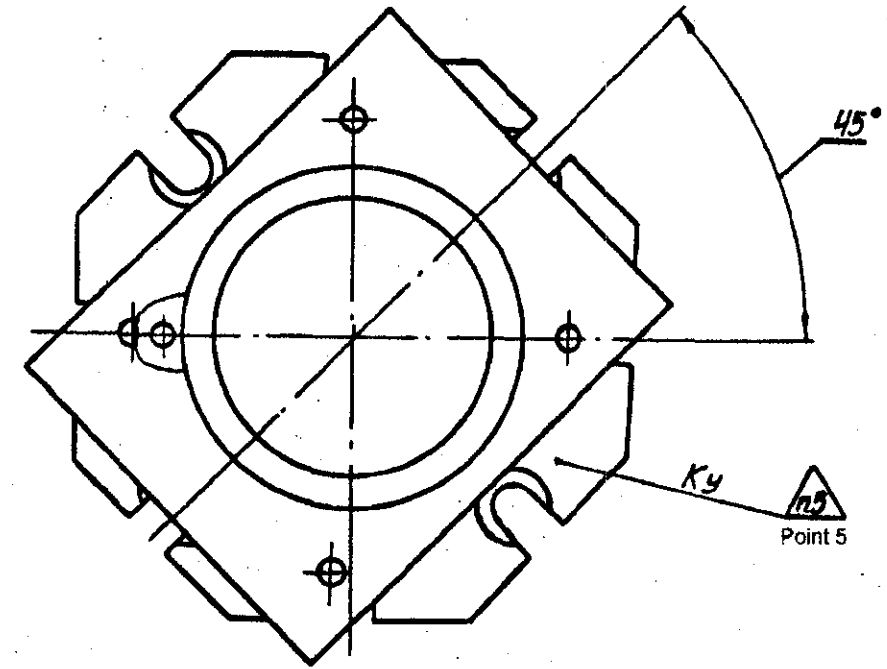
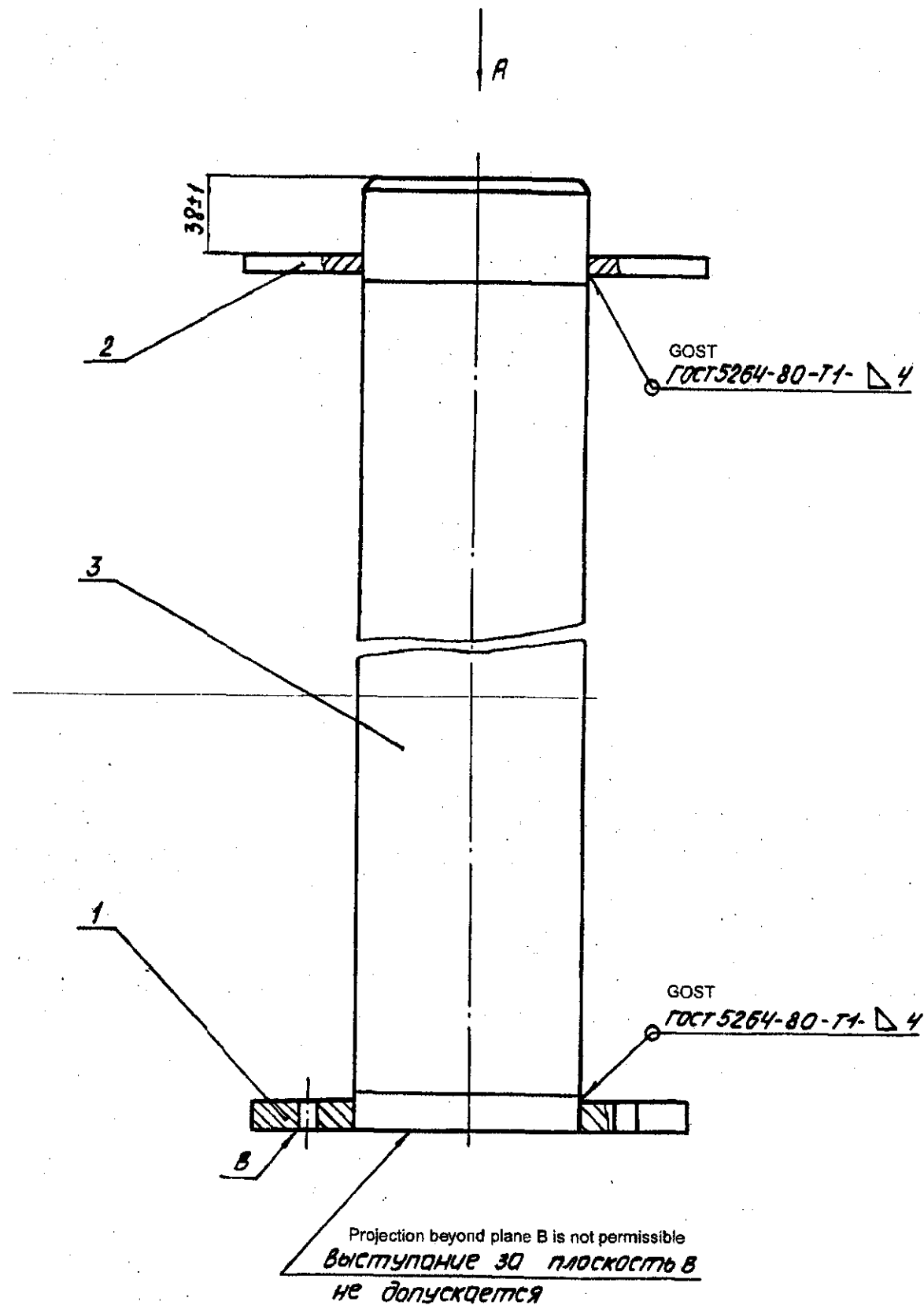
Amend.	Sheet	Doc. No.	Sign	Date

AO-18P.020 SB			
Flange Assembly drawing	Type	Weight	Scale
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Sheet		Sheets 1	

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Format A4

BUDA
View A

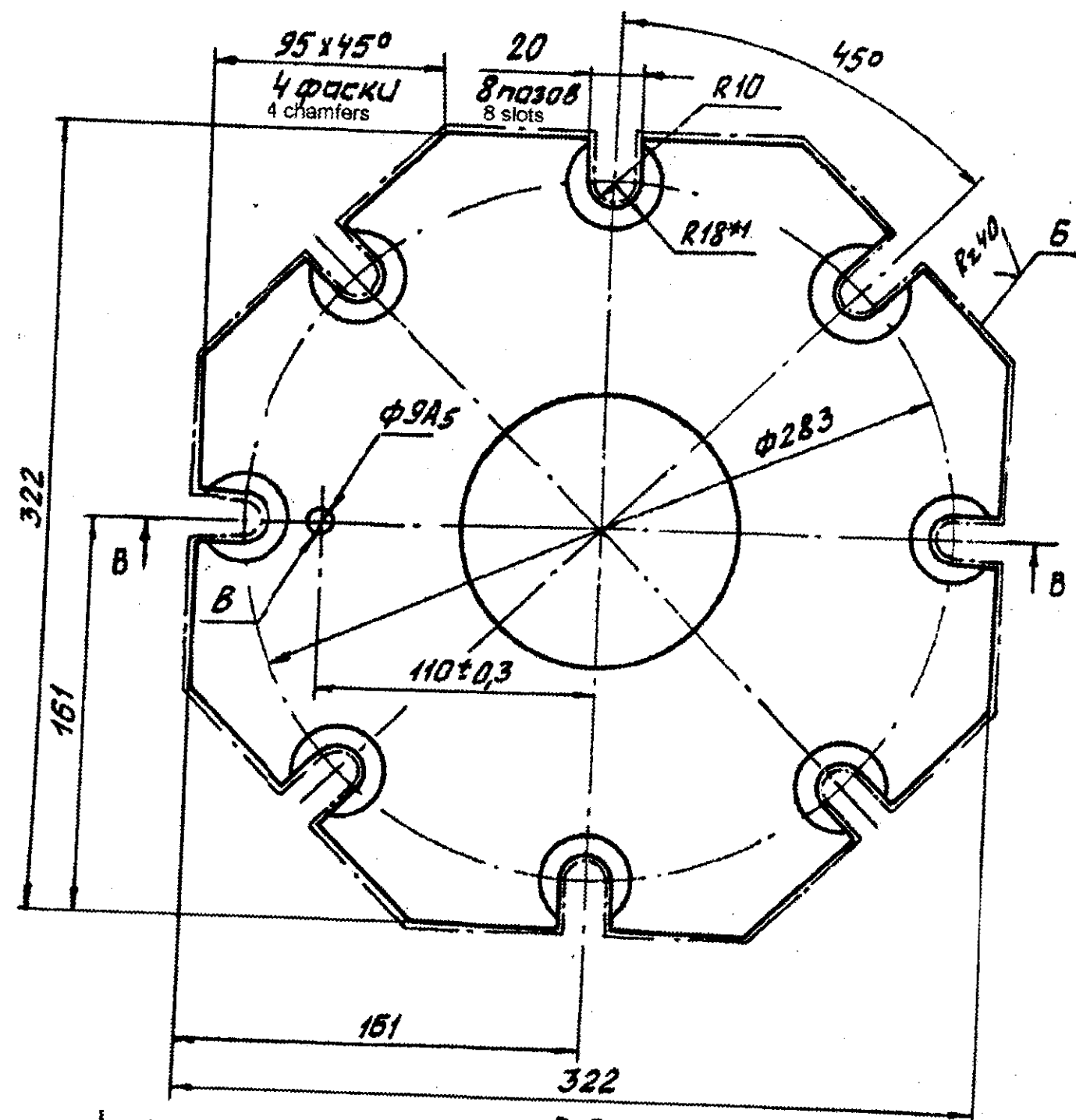


1. Weld with electrode 13/45-4.0-3 GOST 9466-75. Rectification of Pos. 3 is permissible.
2. Welding seams of category II. Check the welding seams by visual inspection as per OST 3-4001-91.
3. Coating: Cham. Phos. / Primer AK-630 yellow OST 6-10-401-76 1 layer.
4. Semiautomatic welding in carbon dioxide gas is permissible. Welding material - wire 1.2 SB -08G2S.
5. Stamp.

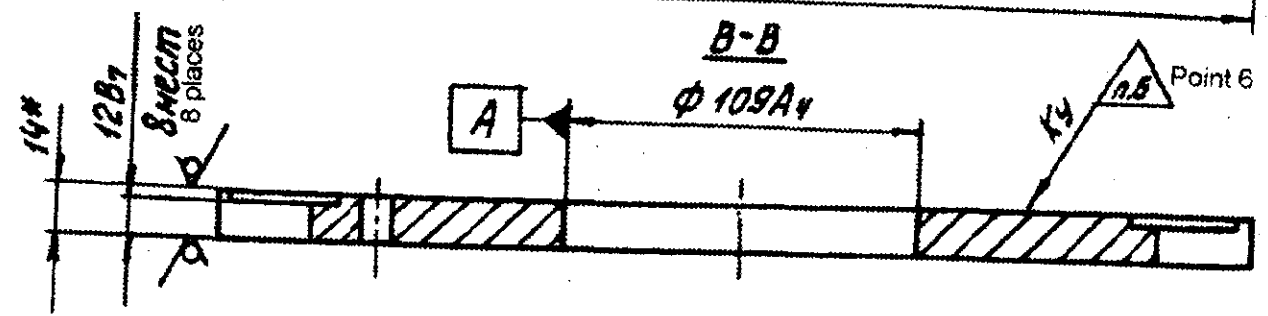
Inv. No.	Sign and Date	Alternate Inv. No.	Duplicate Inv. No.	Sign and Date	Refer. No.	First remarks

					AO - 18P.030 SB			
Amend	Sheet	Doc No.	Sign	Date	Post Assembly drawing	Type	Weight	Scale
Developed by						O ₂	10.50	1:2
Checked by						Sheet	Sheets 1	
Technician								
Head of bureau								
Head of QCD								
Approved by								

Rz 20
√(√)



1. *Reference dimension.
2. *1 Dimensions ensured by tool.
3. Blunt edges R~0.6 mm.
4. Inner angles R ≈ 0.4 mm.
5. Tolerance of contour B with respect to axis of surface A and hole B -0.6 mm.
6. Stamp.
7. substitute material: Sheet $\frac{14GOST19903-74}{20GOST1577-81}$



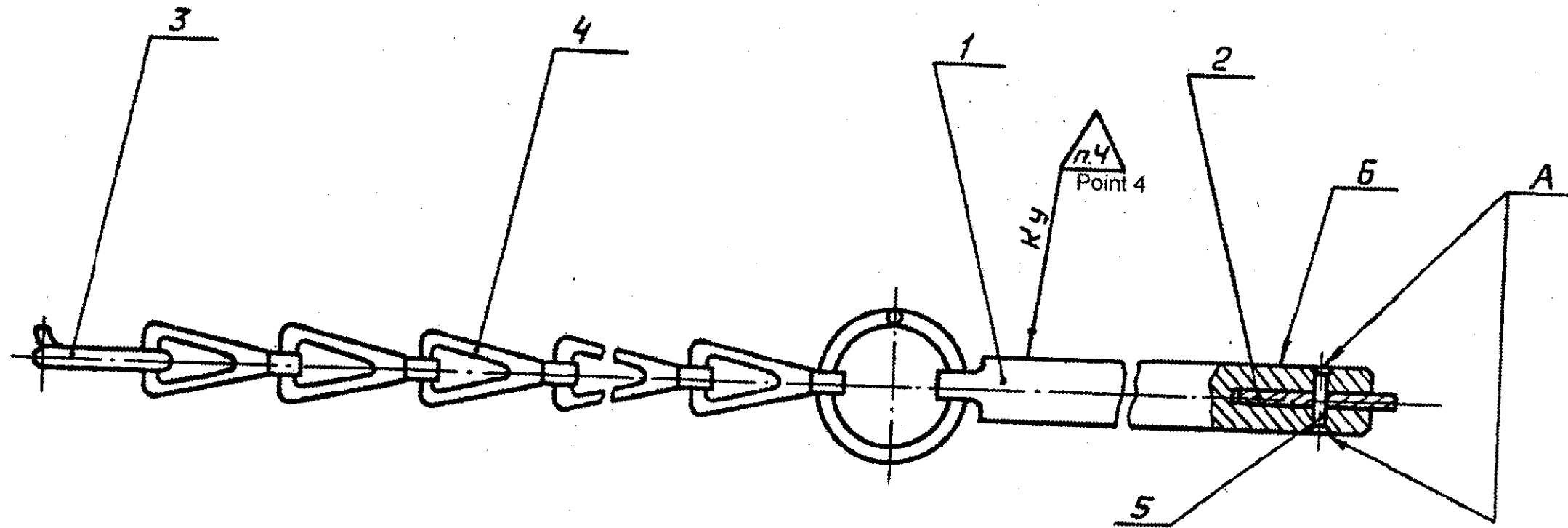
					AO-18P .011			
Amend.	Sheet	Doc. No.	Sign	Date	Plate	Type	Weight	Scale
Developed by						O ₂	7.9	1:2
Checked by Head of bureau						Sheet	Sheets 1	
Head of Q.C.D					Sheet	$\frac{14GOST19903-74}{25GOST1577-81}$		
Approved by								

Orig. Inv. No. Sign and Date Replaced inv no. Alternate Inv. No. Sign and Date Reference No. First use

AO-18P.012		✓ (✓)																																													
Approved by shop	Reference No.																																														
Approved KTONI	Sign and Date																																														
Approved Tosb	Dupl. Inv. No.																																														
Alternate Inv. No.	Sign and Date																																														
Approved OGMet	Orig. Inv. No.	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td colspan="5" style="text-align: center;">AO-18P.012</td> </tr> <tr> <td style="width: 10%;"></td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> </tr> <tr> <td style="text-align: center;">Amend.</td> <td style="text-align: center;">Sheet</td> <td style="text-align: center;">Doc. No.</td> <td style="text-align: center;">Sign</td> <td style="text-align: center;">Date</td> </tr> <tr> <td colspan="5" style="text-align: center;">Developed by</td> </tr> <tr> <td colspan="5" style="text-align: center;">Checked by</td> </tr> <tr> <td colspan="5" style="text-align: center;">Head of Q.C.D</td> </tr> <tr> <td colspan="5" style="text-align: center;">Design bureau chief</td> </tr> <tr> <td colspan="5" style="text-align: center;">Head of Q.C.D</td> </tr> <tr> <td colspan="5" style="text-align: center;">Approved by</td> </tr> </table>	AO-18P.012										Amend.	Sheet	Doc. No.	Sign	Date	Developed by					Checked by					Head of Q.C.D					Design bureau chief					Head of Q.C.D					Approved by				
AO-18P.012																																															
Amend.	Sheet		Doc. No.	Sign	Date																																										
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Head of Q.C.D																																															
Design bureau chief																																															
Head of Q.C.D																																															
Approved by																																															
<p>1.* Reference dimension. 2. Blunt edges R~0.6 mm. 2. Stamp.</p>																																															
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td colspan="3" style="text-align: center;">AO-18P.012</td> </tr> <tr> <td style="width: 10%;"></td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> </tr> <tr> <td style="text-align: center;">Type</td> <td style="text-align: center;">Weight</td> <td style="text-align: center;">Scale</td> </tr> <tr> <td style="text-align: center;">Plate</td> <td style="text-align: center;">O₂ 1.42</td> <td style="text-align: center;">1:2</td> </tr> <tr> <td colspan="2" style="text-align: center;">Sheet</td> <td style="text-align: center;">Sheets 1</td> </tr> </table>		AO-18P.012						Type	Weight	Scale	Plate	O ₂ 1.42	1:2	Sheet		Sheets 1																															
AO-18P.012																																															
Type	Weight	Scale																																													
Plate	O ₂ 1.42	1:2																																													
Sheet		Sheets 1																																													
<p>Sheet <i>B - PN - 8GOST19903 - 74</i> <i>25 - 2GOST1577 - 81</i></p>																																															

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Format A4

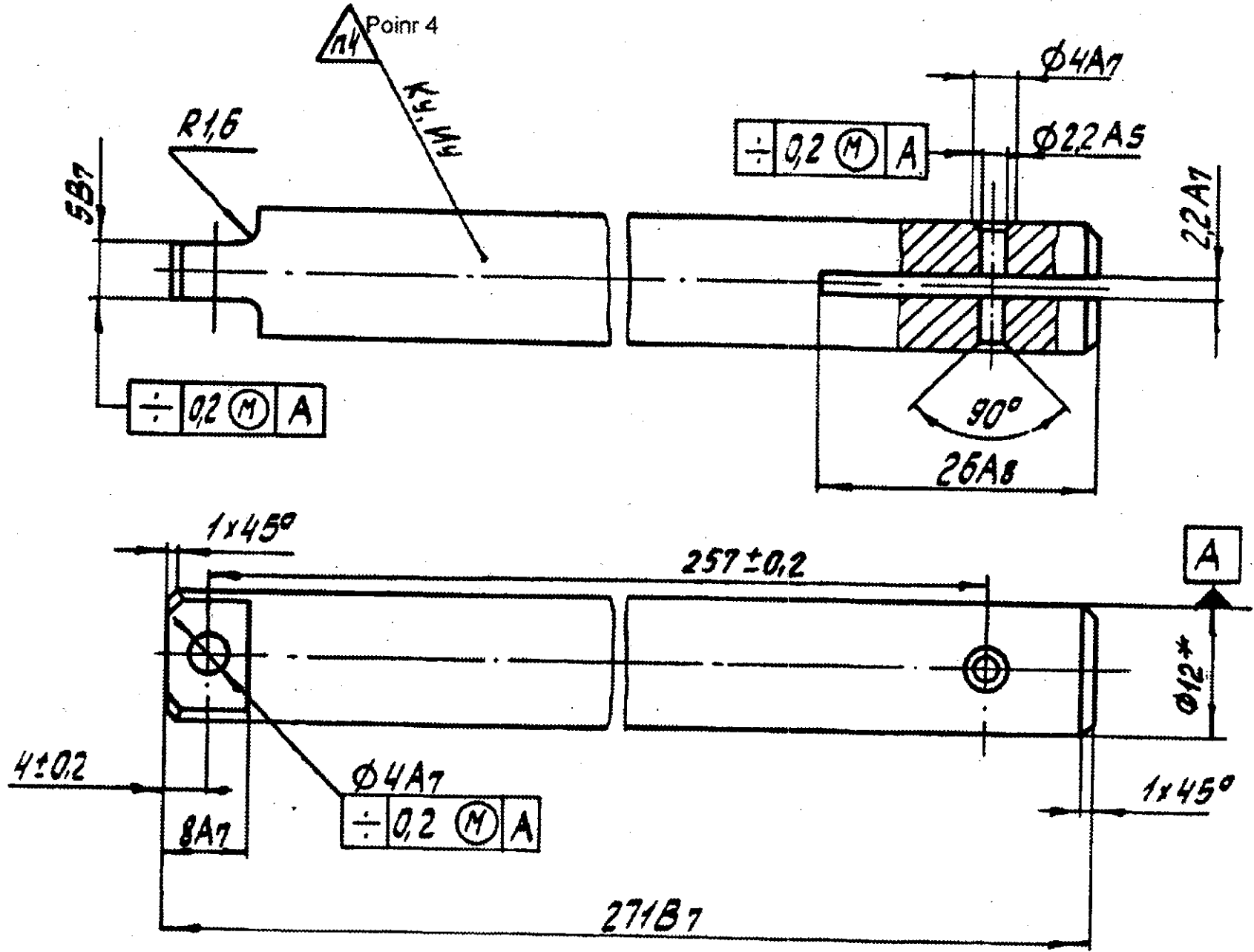


1. For joining pos.1 and 4, first de compress pos.3 and after joining press.
2. Rivet surface A pos.3 and polish flush with surface B pos.1. Ensure at this free rotation of pos.2.
3. Coating: Chem.Phos./impregnation with lacquer BT-987 black, GOST 6244-70, single coating, VK4.
4. Stamp

Orig. Inv. No.	Sign and Date	Replaced inv no.	Alternate Inv. No	Sign and Date	Reference No.	First use
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					AO- 18P .040 SB			
Amend.	Sheet	Doc. No.	Sign	Date	Locator with chain Assembly drawing	Type	Weight	Scale
Developed by						O ₂	0.25	1:1
Checked by								
Head of bureau								
Head of Q.C.D								
Approved by								
						Sheet		Sheets 1

First use	
Reference No.	
Sign and Date	
Alternate Inv. No.	
Replaced inv no.	
Sign and Date	
Orig. Inv. No.	



Rz 40/ (✓)

1. HRC_E 34...40.5. Check hardness on 2% of the batch, but not less than 3 nos.
2. Blunt edges R~0.6 mm.
3. Coating: Chemical Oxidation.
4. Stamp.
5. *Reference dimension.

					AO- 18P .014			
Amend.	Sheet	Doc. No.	Sign	Date	Locator	Type	Weight	Scale
Developed by						O ₂	0.22	2:1
Checked by						Sheet	Sheets 1	
Head of bureau					Wheel	12GOST1417 - 75 50GOST1051 - 73		
Head of Q.C.D								
Approved by								

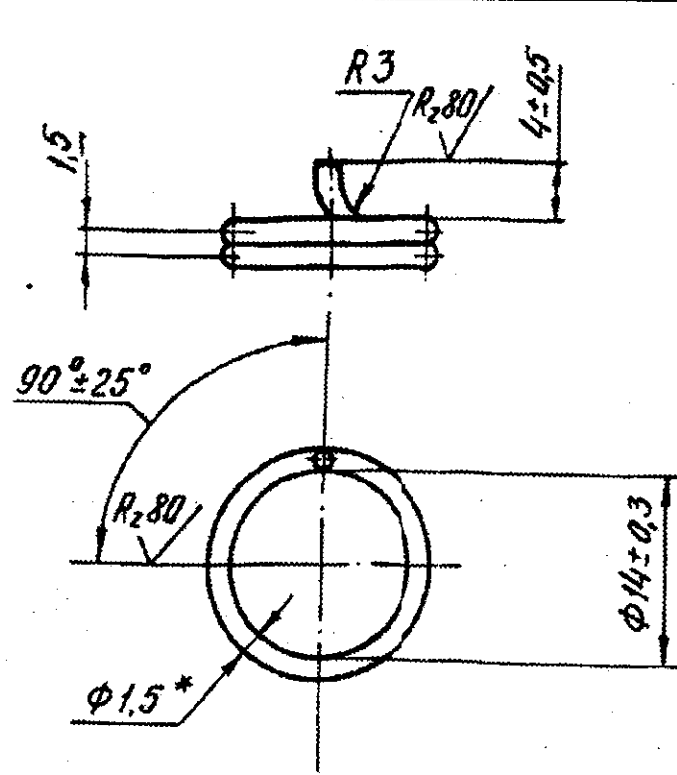
AO-18P.015		Rz40/ (✓)		
Approved by shop Reference No.				
Approved KTONI Sign and Date				
Approved TOsb Alternate Inv. No.	Dupl. Inv. No.	<p>1.* Reference dimension. 2. Blunt edges R~0.6 mm. 3. Stamp.</p>		
Sign and Date				
Approved OGMet Orig. Inv. No.	Sign and Date	AO-18P.015		
Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				
Indicator		Type	Weight	Scale
		O ₂	0.002	2:1
Sheet			Sheets 1	
Sheet $B - PN - 0 - 2GOST19903 - 74$ $4 - III - 50GOST16523 - 70$				

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Format A4

AO-18P.021					
Approved OGMet	Approved TOsb	Approved KTONI	Approved by shop	First use	
Orig. Inv. No.	Alternate Inv. No.	Dupl. Inv. No.	Sign and Date	Reference No.	
AO-18P.021			Ring		
Amend.	Sheet	Doc. No.	Sign	Date	
Developed by					Type
Checked by					O ₂
Head of Q.C.D					Weight
Design bureau chief					0.0012
Head of Q.C.D					Scale
Approved by					2:1
					Sheet
					Sheets 1
Wire V-1-1.5 GOST 9389-75					

AO-18P.021



1. Rolled out length L = 90 mm.
2. * Reference dimension.
3. Right coiling.
4. No. of turns n = 1.75.
5. Round off sharp ends R~0.4 mm.
6. Heat treatment: tempering 240°C-260°C.
7. Coating: Chem. phos. accel. Cr./impregnation with lacquer BT-987 black, single layer VЖ₄. Lacquer BT-987 GOST 6244-70.
8. Stamp K on batch tag.

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Format A4

First use

Reference No.

Sign and Date

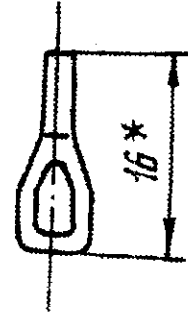
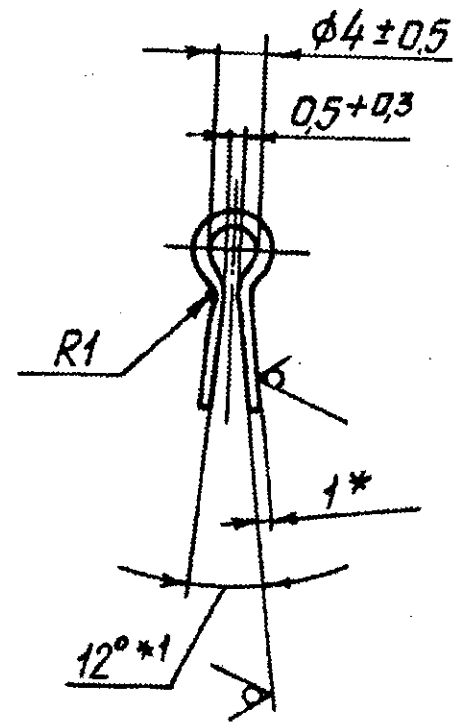
Alternate Inv. No.

Replaced inv no.

Sign and Date

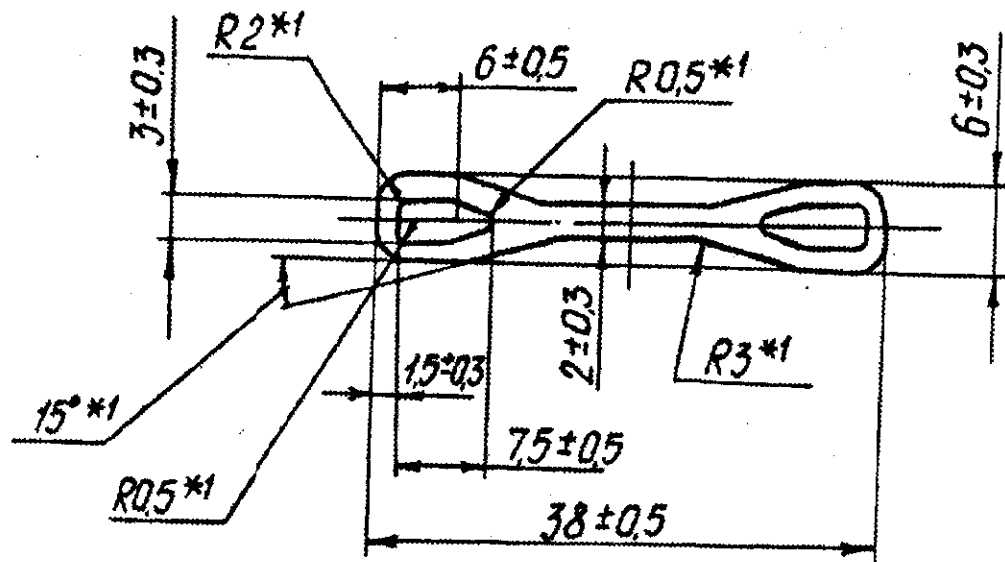
Orig. Inv. No.

Rz 80/ (✓)



1. *Reference dimension.
2. *1 Dimensions ensured by tool.
3. Blunt sharp edges.
4. Mark 4 on batch tag.
5. Stamp K on batch tag.

Reaming
Развертка



					AO-18P.019			
Amend.	Sheet	Doc. No.	Sign	Date	Link	Type	Weight	Scale
Developed by						O ₂	0.009	2:1
Checked by						Sheet	Sheets 1	
Head of bureau					Sheet	B-1.0GOST19904-74 12Kh18NTGOST5582-75		
Head of Q.C.D								
Approved by								

First use

Reference No.

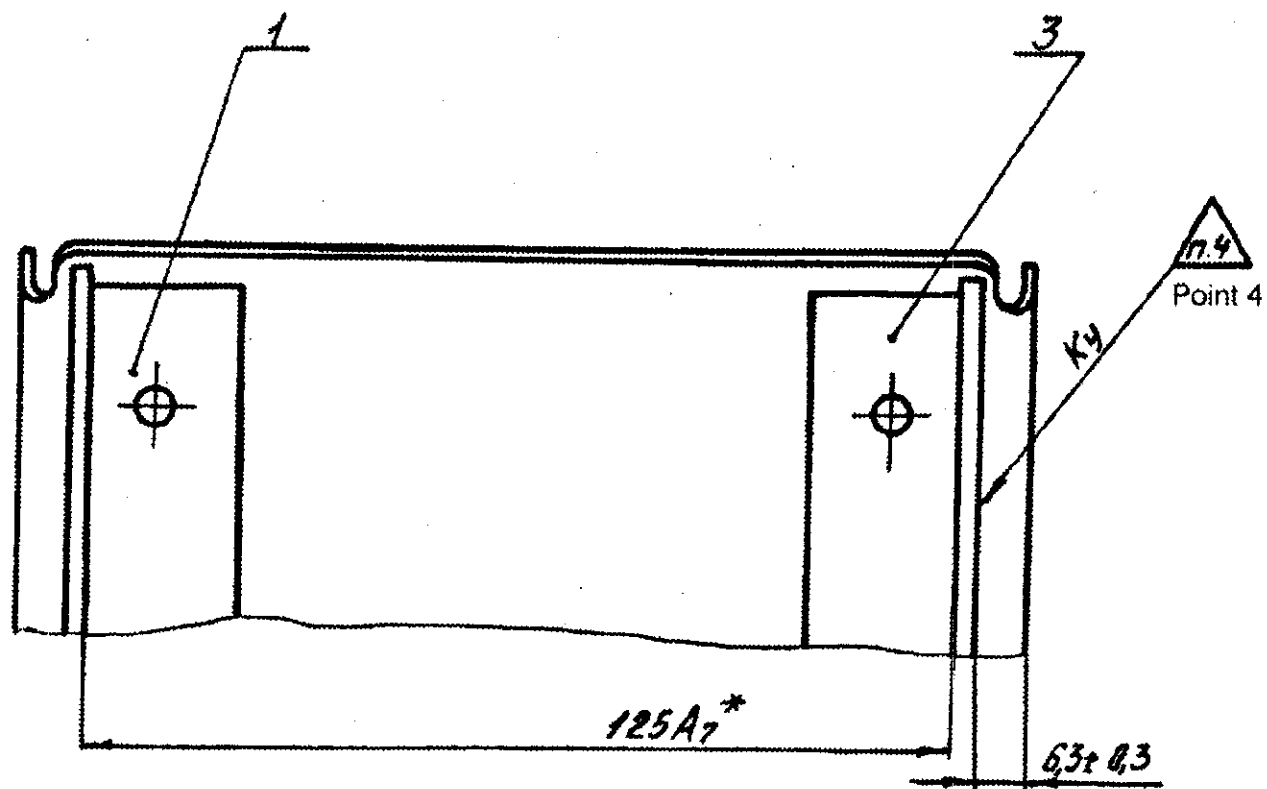
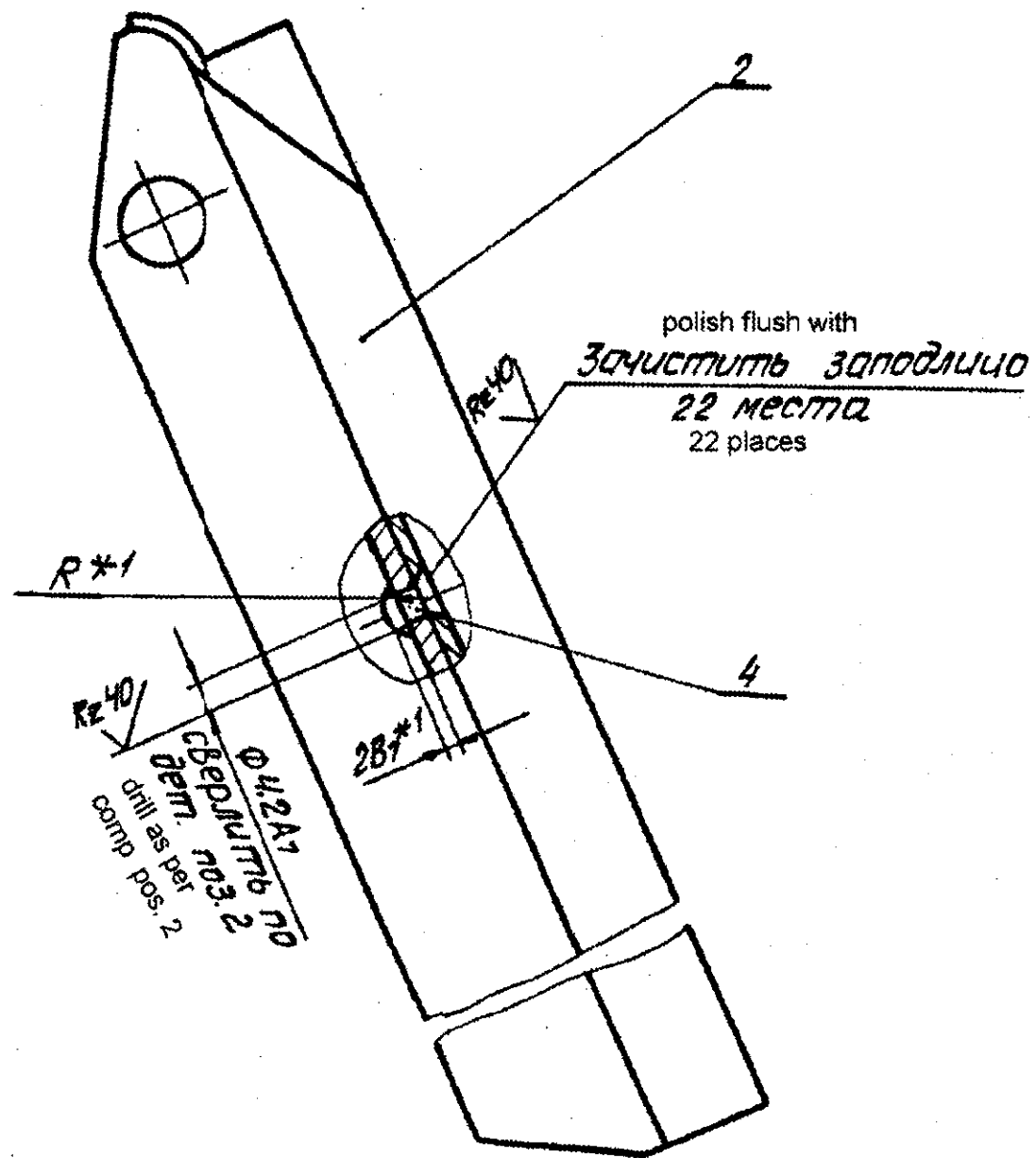
Sign and Date

Alternate Inv. No

Replaced inv no.

Sign and Date

Orig. Inv. No.



1. *Dimension for inspection.
2. *1 Dimension ensured by tool.
3. Coating: primer AK-070 yellow OST6-10-401-76, single layer. Enamel PF-1'5 gray GOST 6465-76, two layers .IV . Ж₄
4. Stamp

					AO- 18P .050 SB			
Amend.	Sheet	Doc. No.	Sign	Date	Tray Assembly drawing	Type	Weight	Scale
							O ₂	1.63
Developed by						Sheet		
Checked by						Sheets 1		
Head of bureau								
Head of Q.C.D								
Approved by								

AO-18 P.016

First use

Reference No.

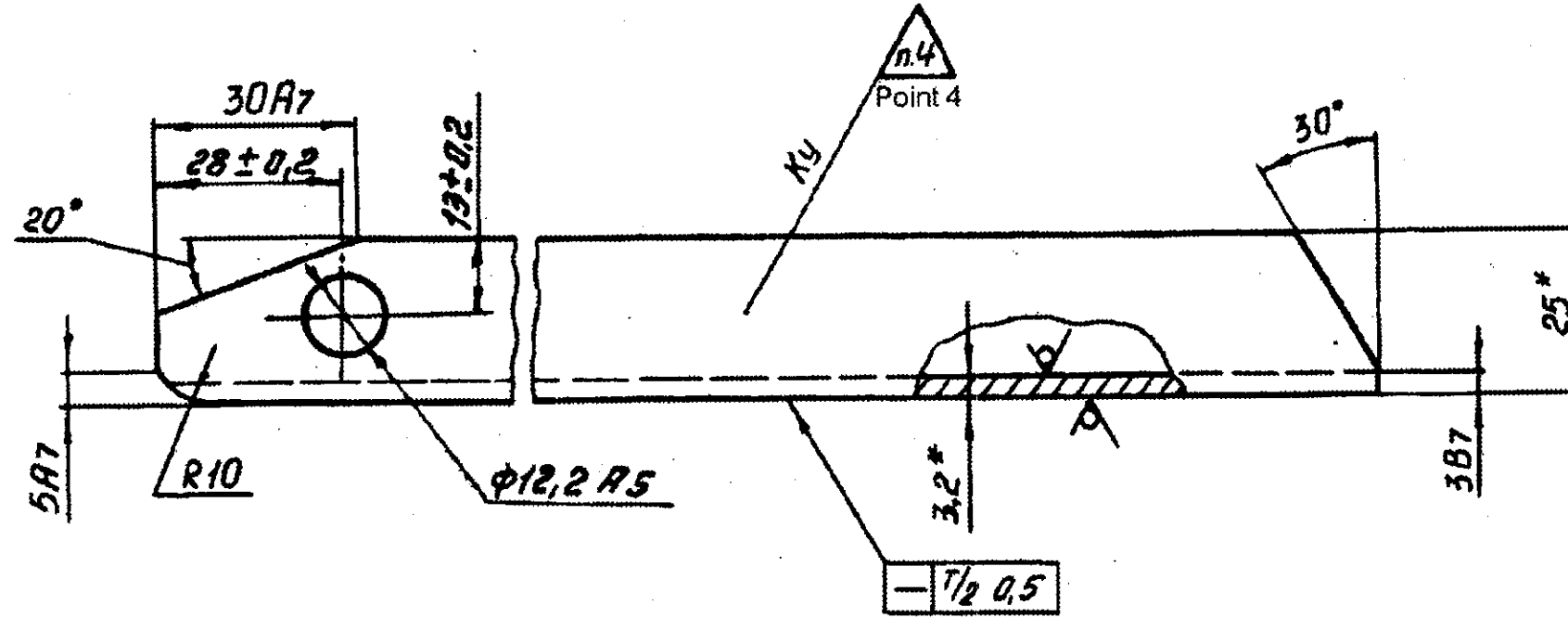
Sign and Date

Alternate Inv. No

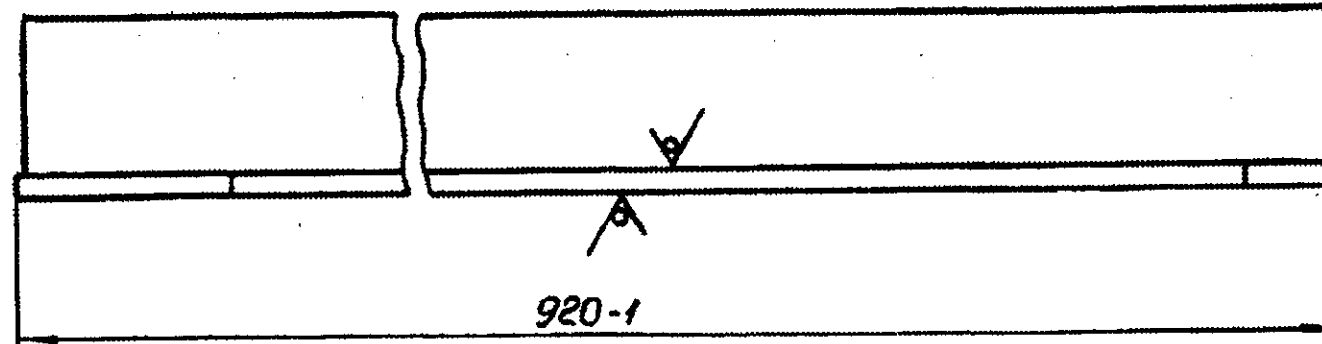
Replaced inv no.

Sign and Date

Orig. Inv. No.



Rz 80 (✓)



1. *Reference dimensions.
2. Blunt edges R~0.6 mm.
3. Coating: Anodic.Oxi.Cr. F = 8.5 dm².
4. Stamp.

Material substitute Profile AMg6 410062 GOST8617-81/GOST 13737-90

					AO-18P .016			
Amend.	Sheet	Doc. No.	Sign	Date	Angle piece	Type	Weight	Scale
							O ₂	0.385
Developed by					Sheet	Sheets 1		
Checked by								
Head of bureau					Profile D16 410062 $\frac{GOST8617 - 81}{GOST13737 - 90}$			
Head of Q.C.D								
Approved by								

Format A3

First use

Reference No.

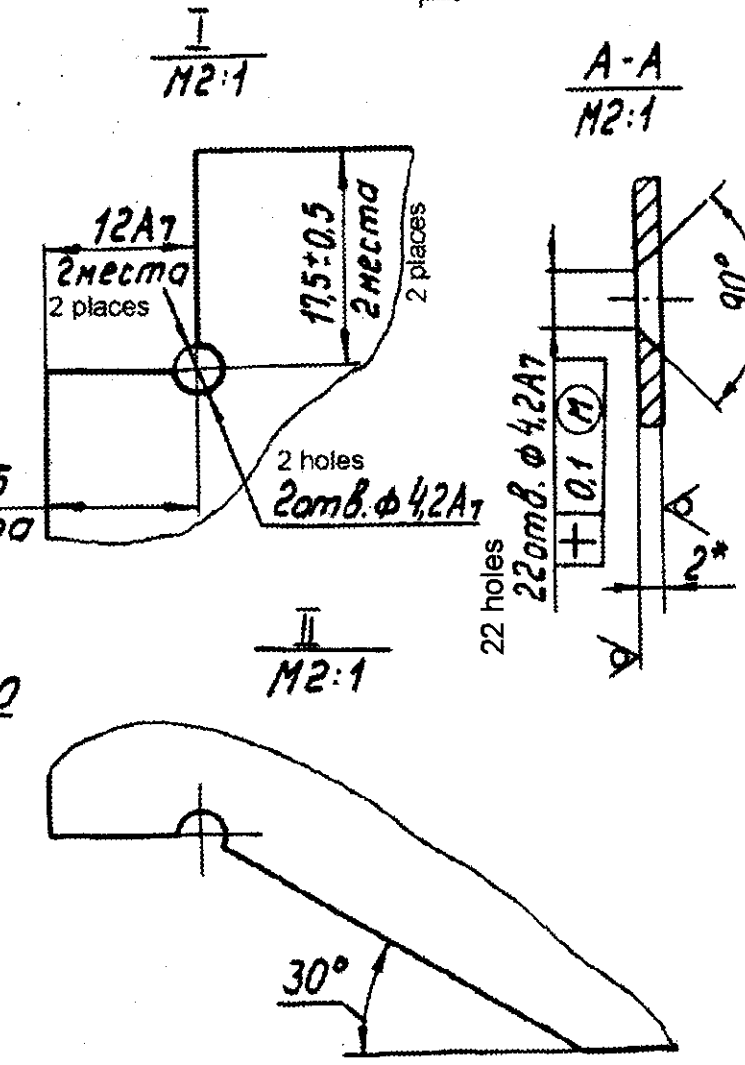
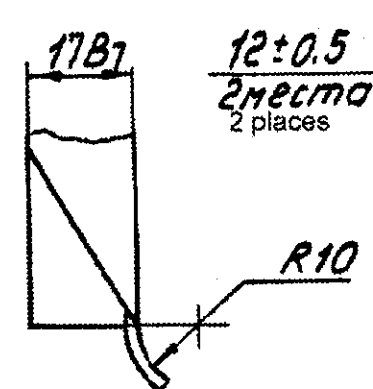
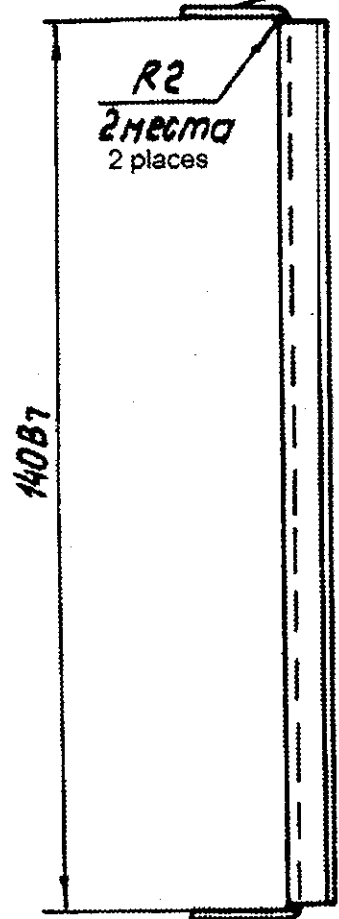
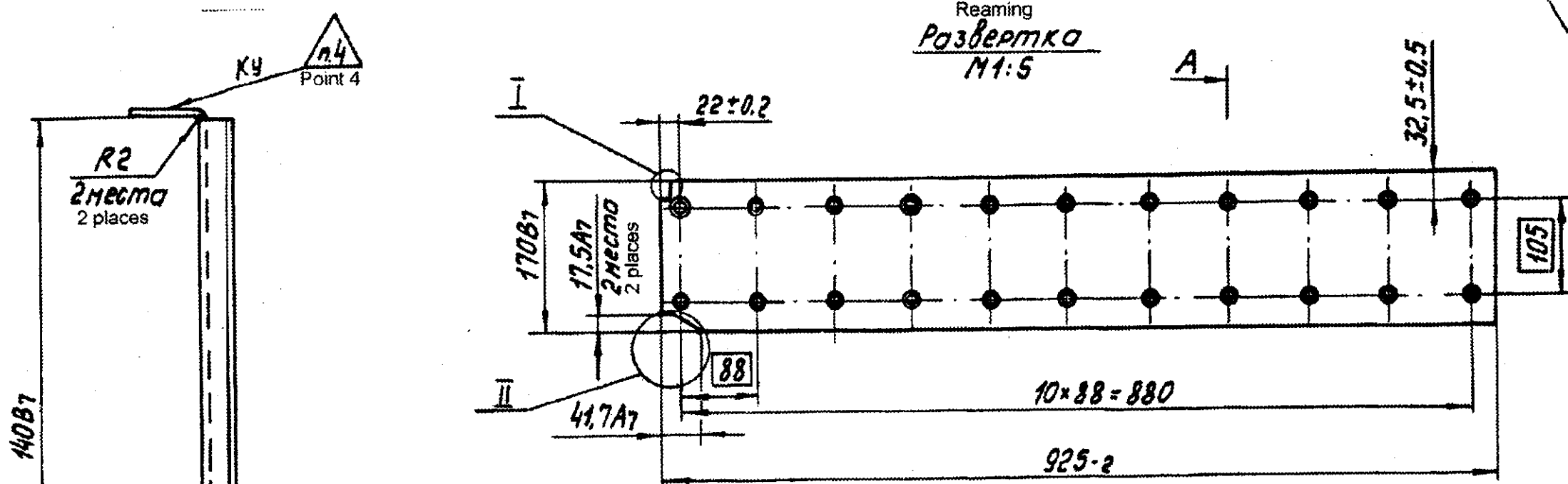
Sign and Date

Alternate Inv. No

Replaced inv no.

Sign and Date

Orig. Inv. No.



1. *Reference dimension.
2. Blunt edges R~0.6 mm.
3. Coating: Anodic Oxi.Cr. F = 30 dm².
4. Stamp.

					AO- 18P .017			
Amend.	Sheet	Doc. No.	Sign	Date	Slide	Type	Weight	Scale
Developed by						O ₂	0.78	1:1
Checked by						Sheet	Sheets 1	
Head of bureau								
Head of Q.C.D					Sheet AMg6.M2 GOST 21631-76			
Approved by								

AO- 18 P.018

First use

Reference No.

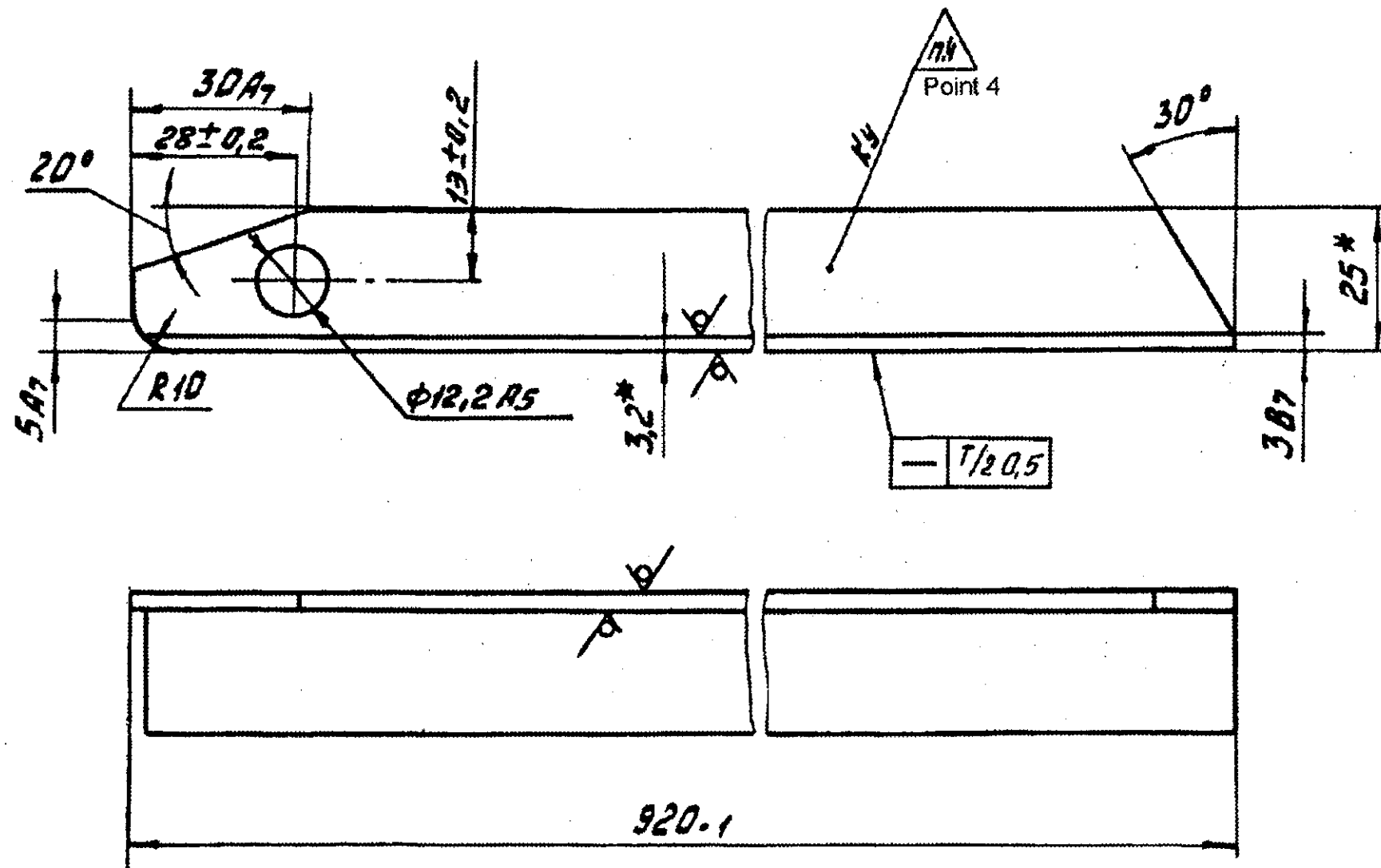
Sign and Date

Alternate Inv. No

Replaced inv no.

Sign and Date

Orig. Inv. No.



- 1.*Reference dimensions.
- 2.Blunt edges R~0.6 mm.
- 3.Coating: Anodic.Oxi.Cr. F = 8.5 dm².
- 4.Stamp.

Material substitute Profile AMg6 410062 GOST8617-81/GOST 13737-90

					AO- 18P .018			
Amend.	Sheet	Doc. No.	Sign	Date	Angle piece	Type	Weight	Scale
							O ₂	0.385
Developed by					Sheet		Sheets 1	
Checked by					Profile D16 410062 $\frac{GOST8617-81}{GOST13737-90}$			
Head of bureau								
Head of Q.C.D								
Approved by								

Format A3

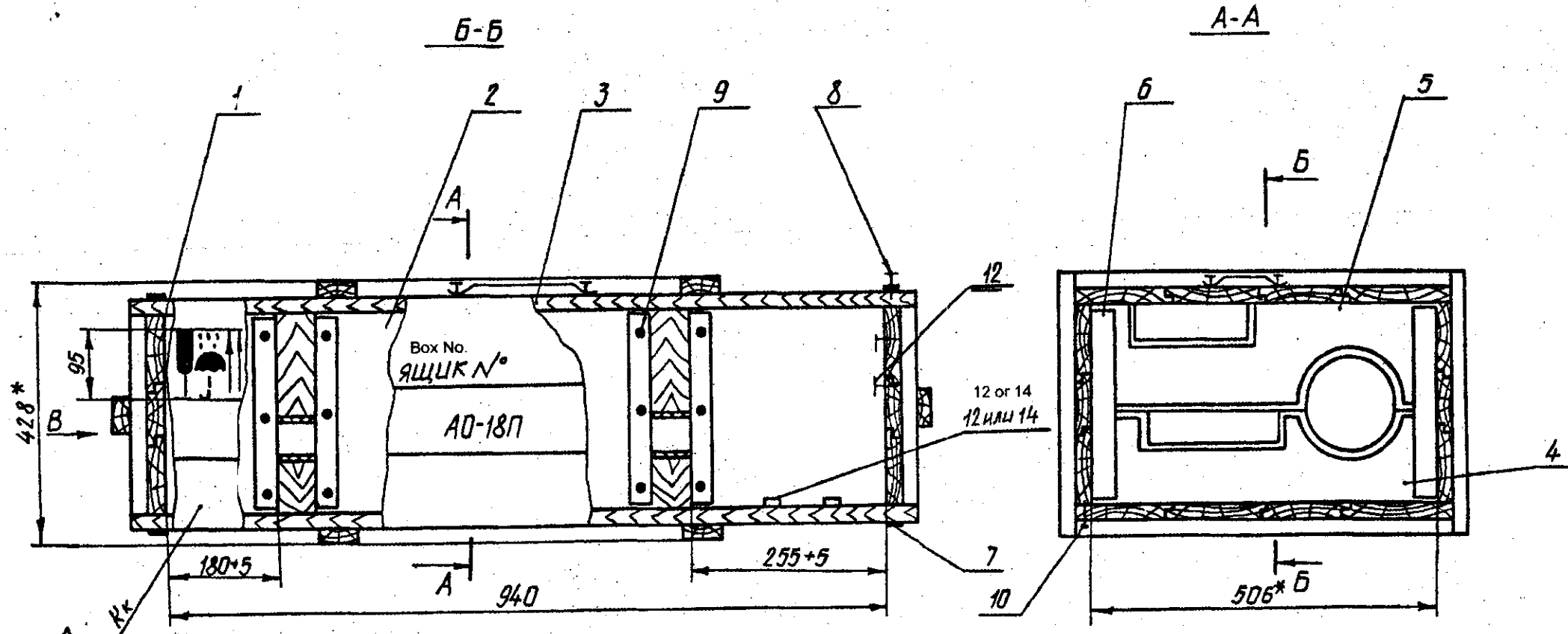
First use		Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks	
						<u>Documents</u>			
		*			AO-18PYa.000SB	Assembly drawing 5/1.10/11		*A2,2A4	
Reference No.						<u>Assembly units</u>			
	A4		1		AO-18PYa.010	Face plate	2		
	A4		2		AO-18PYa.020	Side plate	2		
	A4		3		AO-18PYa.030	Cover	2		
	A4		4		AO-18PYa.040	Lower pyramid	2		
	A4		5		AO-18PYa.050	Upper pyramid	2		
						<u>Components</u>			
	A4		6		AO-18PYa.001	Strap 5/1	8		
	W/D		7		AO-18PYa.002	Band PN 04x20 GOST 3560-73 L = 1900 mm	2		
	A3		11		AK-630-Ya 200-1-32 TR	Pocket for packing list 1TR 5/17	1		
Sign and Date						<u>Standard articles</u>			
Dupl. Inv. No.			8			Nails 2x25 GOST 4029-63	76		
			9			Nails K 2x40 GOST 4028-63	24		
			10			Nails K 3x70 GOST 4028-63	60		
Alternate Inv. No.									
Sign and Date									
Orig. Inv. No.									
		Amend.	Sheet	Doc. No.	Sign	Date	AO-18PYa.000		
		Developed by					Type	Sheet	Sheets
		Checked by					02	1	2
		Head of Q.C.D					Transportation Box		
		Approved by							

First use	Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A3			AO-18PYa.010SB	Assembly drawing 7/4			
					<u>Components</u>			
	W/D	1	AO-18PYa.003	Board. Lumber of		2		
					coniferous type, grade 2			
					GOST 8486-86			
					22x50x340			
	W/D	2	AO-18PYa.004	Board. Lumber of		1		
					coniferous type, grade 2			
					GOST 8486-86			
				22x50x506				
Sign and Date	W/D	3	AO-18PYa.005	Board. Lumber of		1		
				coniferous type, grade 2				
				GOST 8486-86				
				22x100x506				
Dupl. Inv. No.	W/D	4	AO-18PYa.005	Board. Lumber of		2		
				coniferous type, grade 2				
				GOST 8486-86				
				22x130x506				
Sign and Date					AO-18PYa.010			
	Amend.	Sheet	Doc. No.	Sign	Date			
Orig. Inv. No.	Developed by				Face plate	Type	Sheet	Sheets
	Checked by					02	1	2
	Head of Q.C.D							
	Approved by							

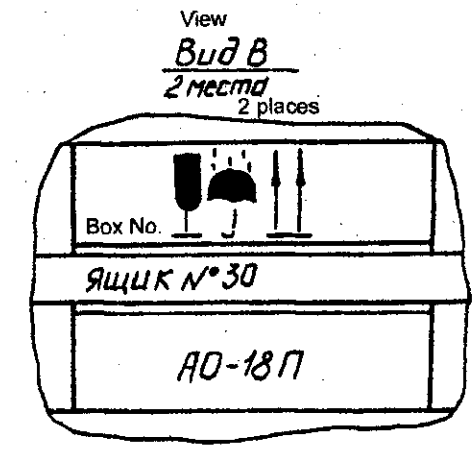
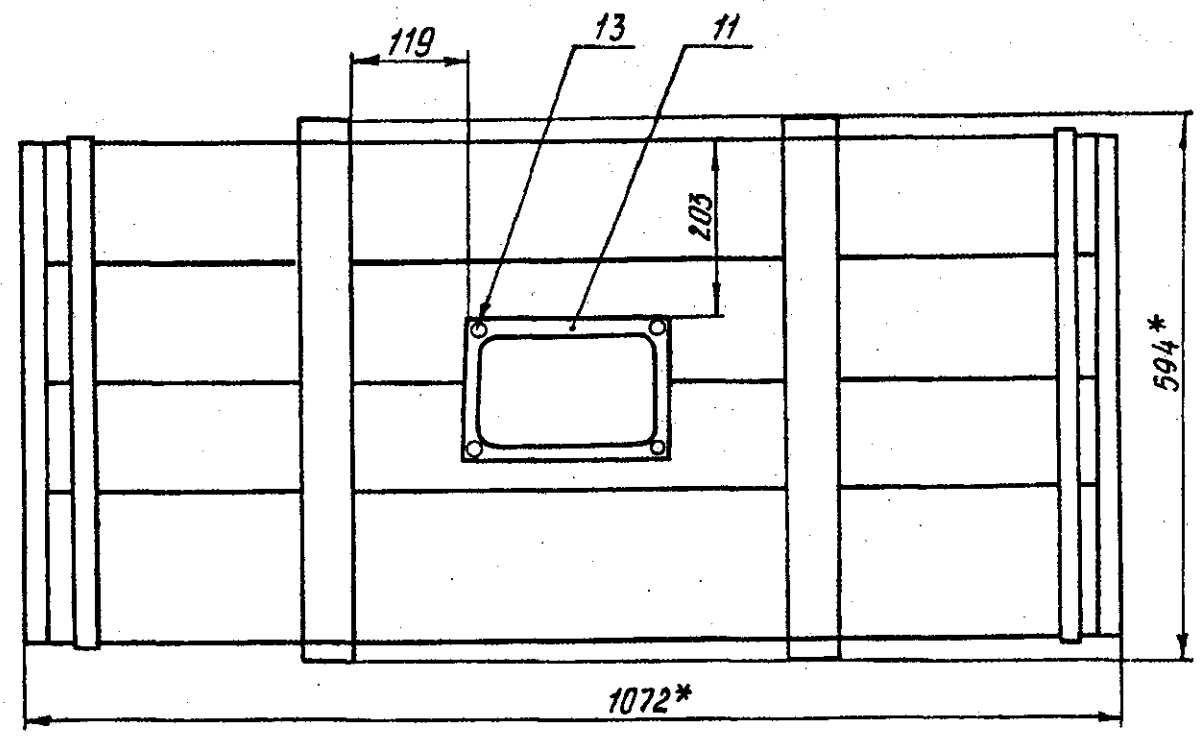
First use	Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks	
						<u>Documents</u>		
	A3			AO-18PYa.030SB	Assembly drawing 7/9			
Reference No.					<u>Components</u>			
	W/D	1		AO-18PYa.011	Board. Lumber of coniferous type, grade 2 GOST 8486-86 22x150x1028	3		
	W/D	2		AO-18PYa.012	Board. Lumber of coniferous type, grade 2 GOST 8486-86 22x130x1028	1		
	W/D	3		AO-18PYa.013	Board. Lumber of coniferous type, grade 2 GOST 8486-86 22x60x550	2		
Sign and Date					<u>Standard articles</u>			
			4		Nails K 2.5x60 GOST 4028-63	15		
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date					AO-18PYa.030			
	Amend.	Sheet	Doc. No.	Sign	Date			
Orig. Inv. No.	Developed by					Type	Sheet	Sheets
	Checked by					02		1
Head of Q.C.D								
Approved by								
Cover								

First use		Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks		
Reference No.		A3			AO-18PYa.040SB	Assembly drawing 7/4	1			
		<u>Documents</u>								
Sign and Date										
		<u>Components</u>								
			1	AO-18PYa.015			Lower pyramid 7/4	1		
		W/D	2	AO-18PYa.016			Felt gasket PprA5 GOST 6308-71-GOST 15159-76 680x30	1		
Dupl. Inv. No.		<u>Standard articles</u>								
			3				Nails 2x20 GOST 4029-63	4 nos. repl.with pos.4		
Alternate Inv. No.		<u>Other articles</u>								
			4				Clamp type III 11x0.9 TU 13-317-76	3nos. repl.with pos.3		
Sign and Date		AO-18PYa.040								
		Amend.	Sheet	Doc. No.	Sign	Date				
Orig. Inv. No.		Developed by					Type	Sheet	Sheets	
		Checked by					02		1	
		Head of Q.C.D					Lower pyramid			
		Approved by								

First use		Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks	
Reference No.		<u>Documents</u>							
		A3			AO-18PYa.050SB	Assembly drawing 5/1	1		
Sign and Date		<u>Components</u>							
		A3	1		AO-18PYa.017	Upper pyramid 7/4	1		
		W/D	2		AO-18PYa.018	Felt gasket PprA5	1		
						GOST 6308-71-GOST 15159-76			
						285x30			
			3		AO-18PYa.019	Felt gasket PprA5_GOST 6308-71			
						GOST 15159-76, 555x30			
						<u>Standard articles</u>			
			4			Nails 2x20 GOST 4029-63			10 nos. repl.with pos.5
		Dupl. Inv. No.		<u>Other articles</u>					
	5					Clamp type III 11x0.9		7nos.	
						TU 13-317-76		repl.with pos.4	
Alternate Inv. No.									
Orig. Inv. No.		AO-18PYa.050							
		Amend.	Sheet	Doc. No.	Sign	Date			
		Developed by					Type	Sheet	Sheets
		Checked by					oz		1
		Head of Q.C.D					Upper pyramid		
Approved by									



Point 9



Refer sheet 2.3 for specifications.

First remarks
Refer. No.
Sign and Date
Alternate Inv. No. Duplicate Inv. No. Sign and Date
Inv. No.

					AO - 18PYa.000 SB			
Amend	Sheet	Doc. No.	Sign	Date	Transport box Assembly drawing	Type	Weight	Scale
Developed by						O ₁	33.60	1:5
Checked by						Sheet 1	Sheets 3	
Technician								
Head of bureau								
Head of QCD								
Approved by								

Technical requirements

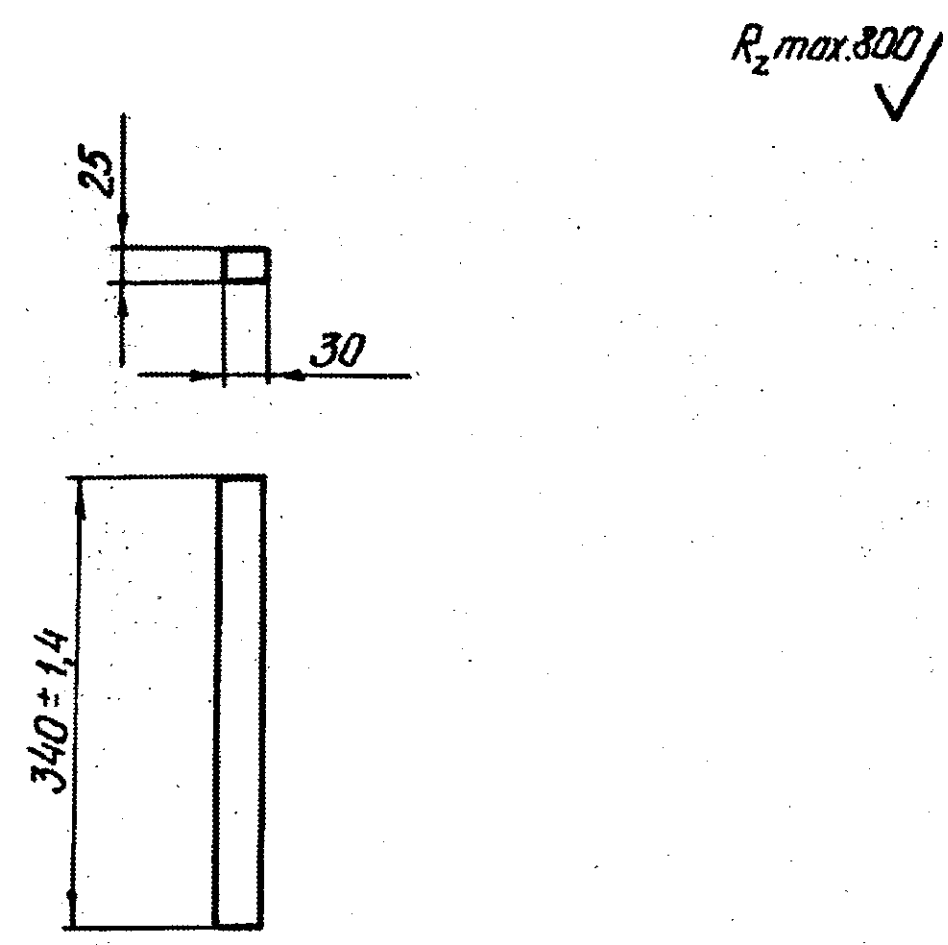
1. *Reference dimensions.
2. Line inner surface of the box with paper DB GOST 8828-89. Fix the paper using nails pos.12 or clamps pos.14. Carry out lining after coating.
- 3.Nail components pos.6 to assembly pos.2 with components pos.9 while lining inner surface of the box with paper.
4. Coating: Enamel KhV-124, gray GOST 10144-89, external surface- 2 coats, inner surface- 1 coat.
5. Put pyramids pos.4 and pos.5 between straps pos.6
- 6.Mark handling instructions, box no., index of article AO-18P on side and two face plates
Box.No in dimensions for tag No.2 from table No.1, 3, 11 annexure 4 GOST 14192-96.
7. All inscriptions should be made with black enamel and should be placed in symmetry.
EP-51 black, GOST 9640-85. Mark in letter size 15 as per GOST 14192-96 .
8. Additional requirements for boxes.
 - 8.1 Blue stains are not permissible on wooden parts of the box.
 - 8.2 Blunt wane and decrease in surface finish of component surfaces are not permissible.
 - 9.3 Nails for making box and fastening other parts should have phosphate coating.

Orig. Inv. No. | Sign and Date | Alternate Inv. No. | Sign and Date | Dupl. Inv. No. | Sign and Date

					AO-18PYa.000 SB	Sheet
Amend.	Sheet	Doc. No.	Sign	Date		2

Copied by

Format A4

AO-18PYa.001					
Approved OGMet	Sign and Date	Approved TOSb	Approved KTONI	Approved by shop	First use
Orig. Inv. No.	Alternate Inv. No.	Dupl. Inv. No.	Sign and Date	Reference No.	
					
Free dimensions as per js16 GOST 6449.1-82.					
		AO-18PZ.001			
		Strap		Type	Weight
				O ₂	0.013
				Scale	1:5
				Sheet	Sheets 1
		Lumber board of coniferous type of wood grade GOST 8486-86			

Copied by

Format A4

First use

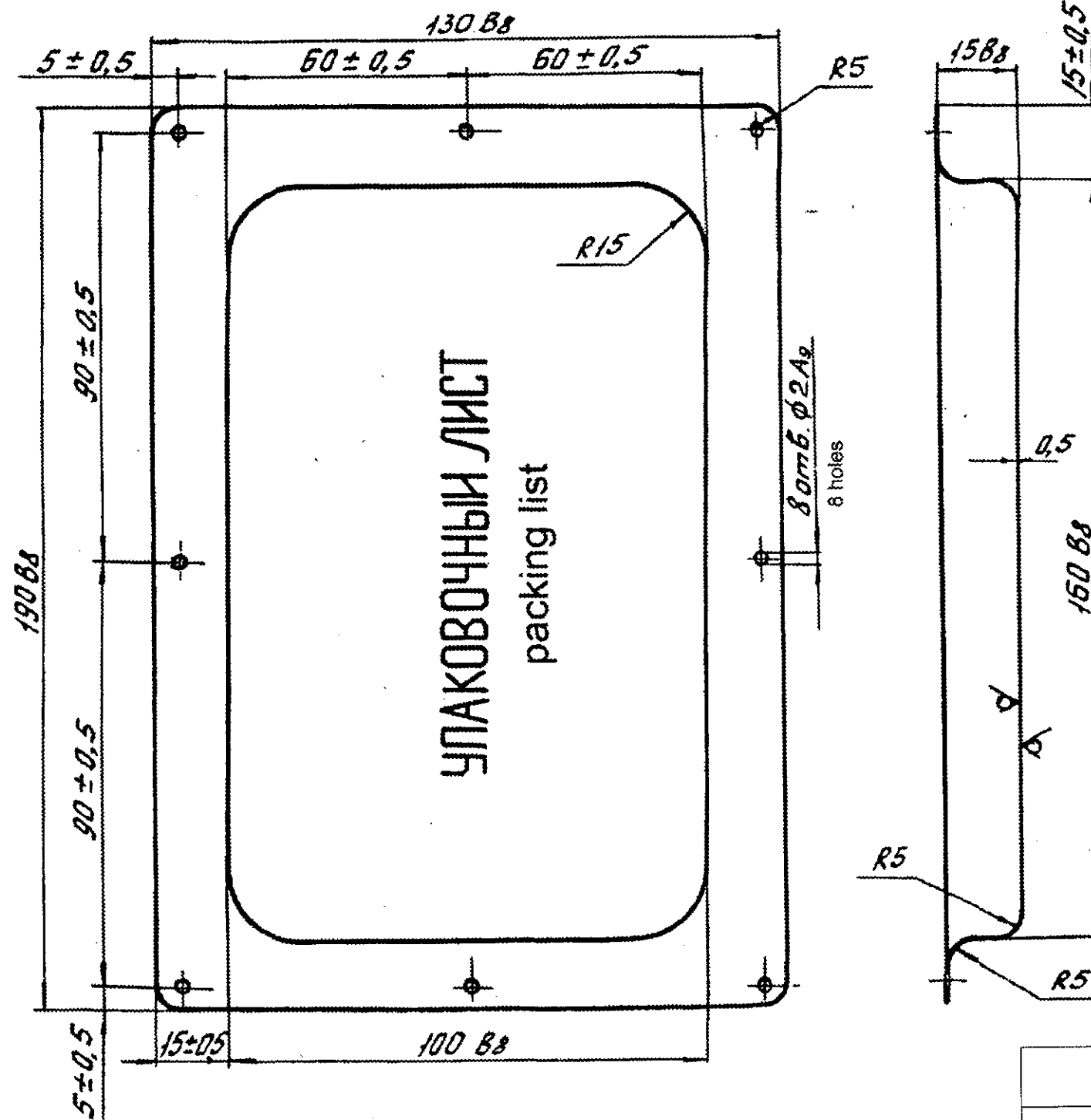
Reference No.

Duplicate Inv. No. Sign and Date

Alternate Inv. No.

Sign and Date

Orig. inv. no.



Rz 80 / (V)

1. Blunt sharp edges ~0.4 mm.
2. Coating: Cd12.Phos.
3. Apply inscriptions with enamel PF-115, white GOST 6465-76. Letter size PO-10 GOST 2930-62.
4. Inscriptions in English PACKING LIST.
5. Mark Ч, Ш and stamp K on tag.

					AK-630-Ya 200-1-32 TR			
Amend.	Sheet	Doc. No.	Sign	Date	Pocket for packing list 1TR	Type	Weight	Scale
Developed by						A		1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Sheet $\frac{B - PN - 0.5 \times 1000 \times 2000 \text{ GOST } 19904 - 74}{II - sh - VG - 08KPGOST9045 - 80}$			
Approved by								

AO- 18 PYa.010 SB

First use

Reference No.

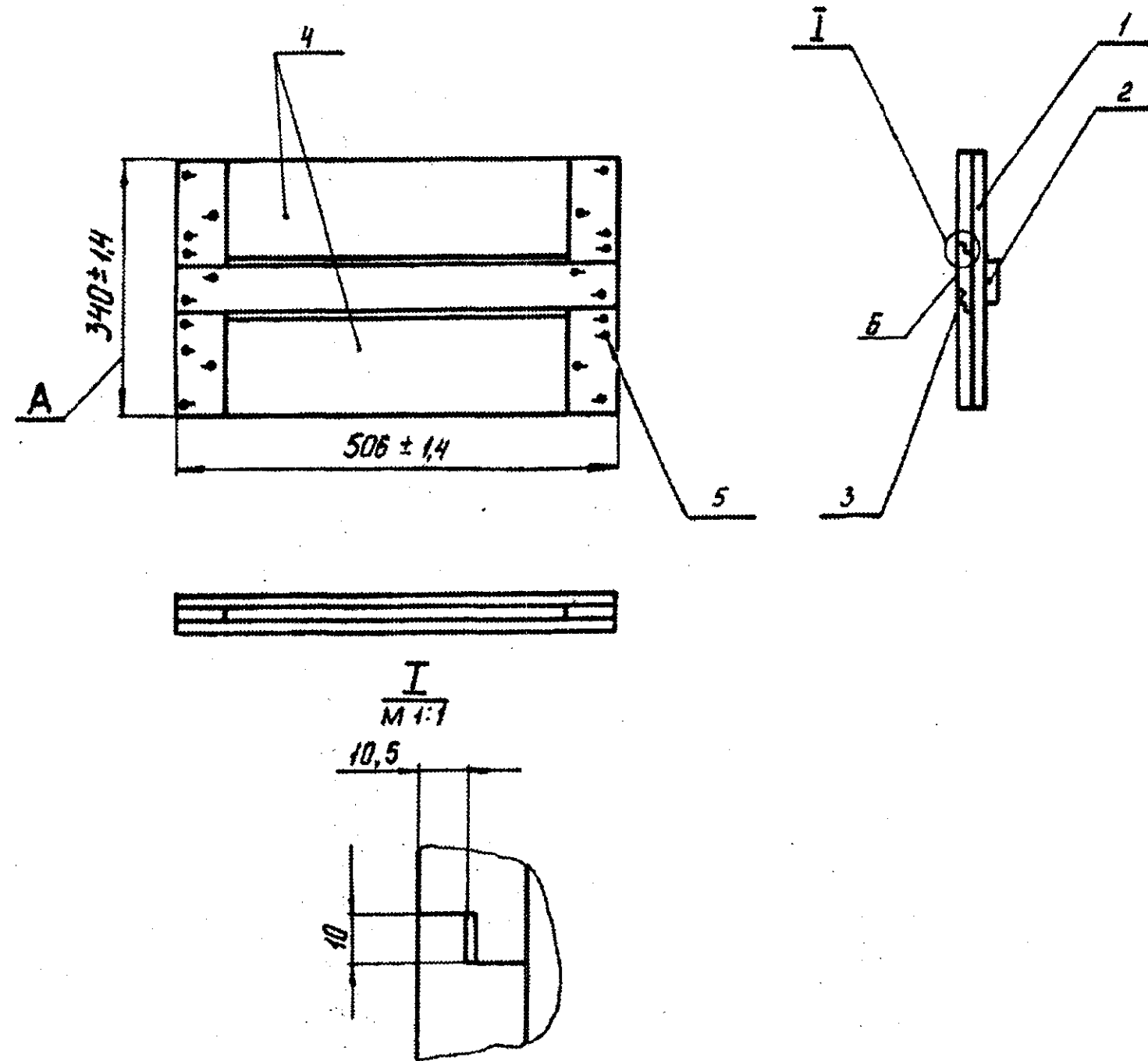
Sign and Date

Alternate Inv. No

Replaced inv no.

Sign and Date

Orig. Inv. No.



1. It is permissible to assemble dimension A from boards of different width not less than 80 mm.
2. Join the boards in quarter without through cavities.
3. Free dimensions as per js 16 GOST 6449-1-82.
4. It is permissible to avoid planing of surface B on area not exceeding 40% of depth up to 2 mm.

					AO- 18PYa .010 SB			
Amend.	Sheet	Doc. No.	Sign	Date	Face plate Assembly drawing	Type	Weight	Scale
							O ₂	2.600
Developed by								
Checked by								
Head of bureau					Sheet			
Head of Q.C.D					Sheets 1			
Approved by								

Format A3

First use

Reference No.

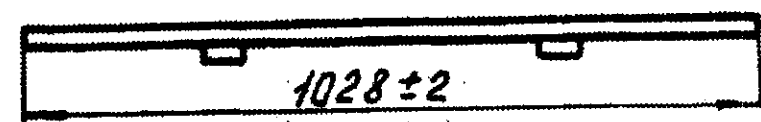
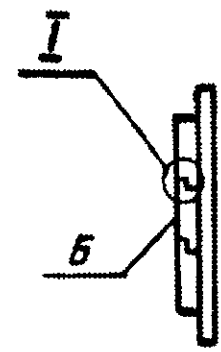
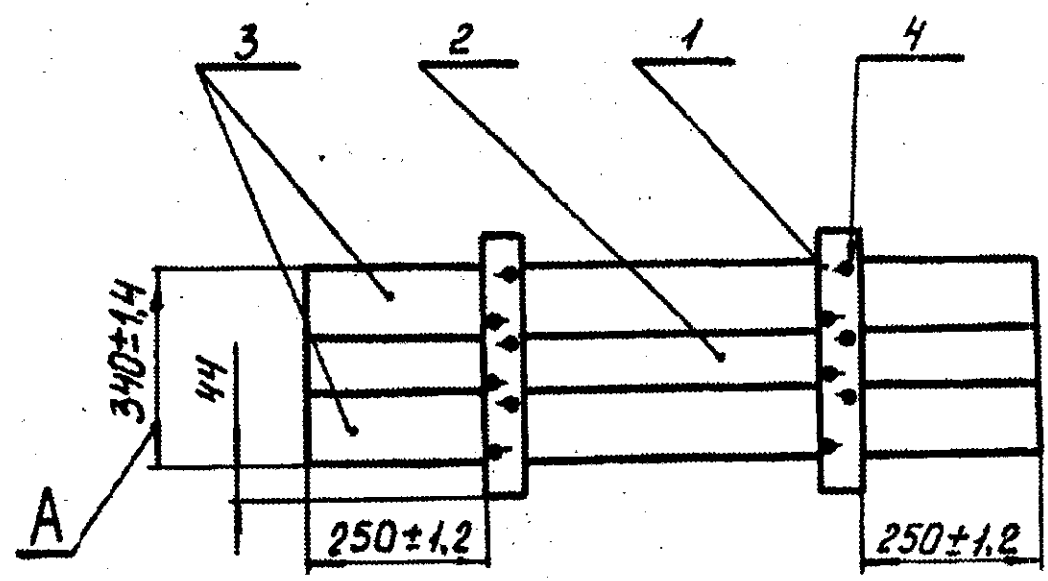
Sign and Date

Alternate Inv. No

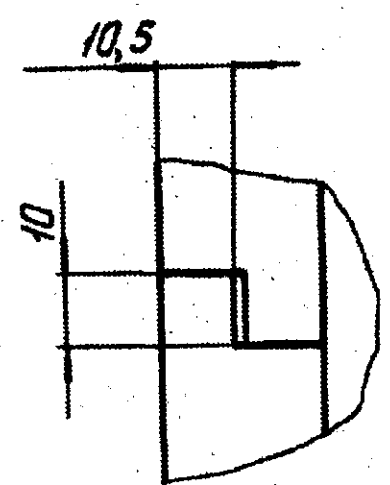
Replaced inv no.

Sign and Date

Orig. Inv. No.



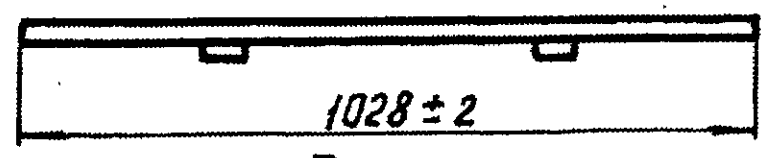
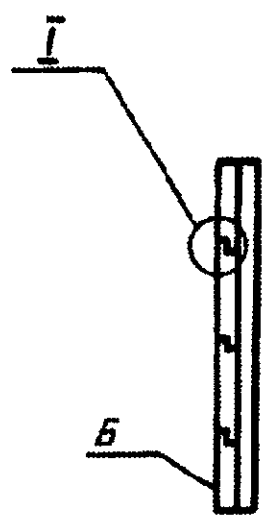
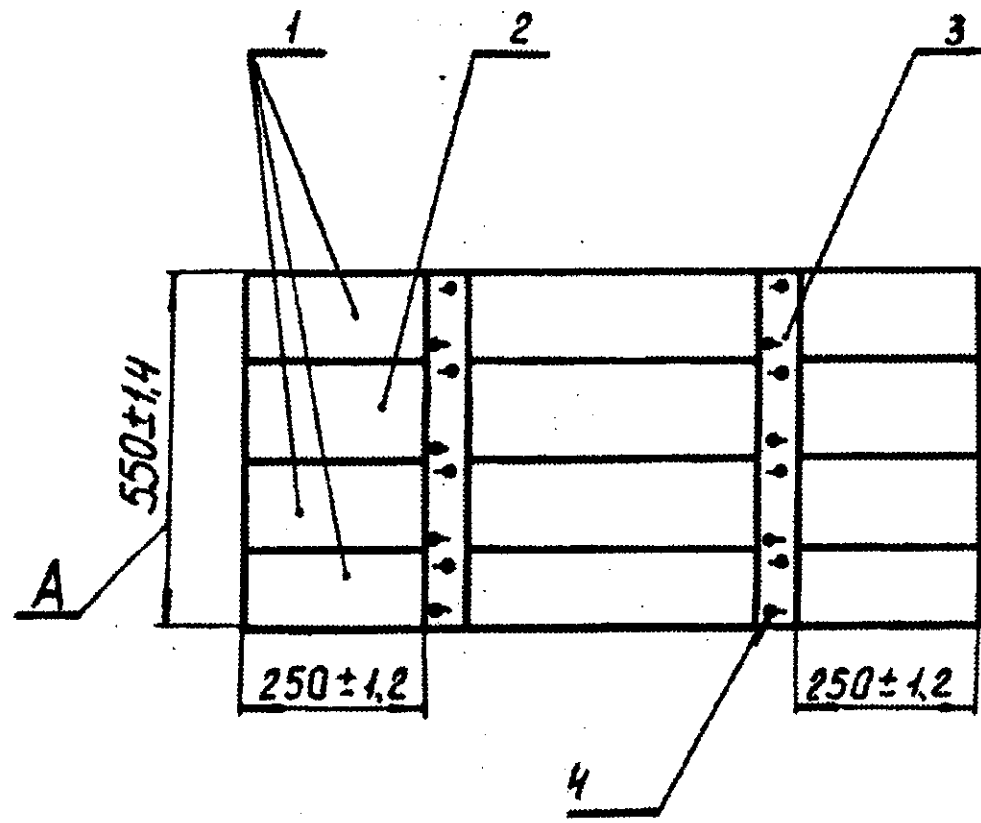
I
M 1:1



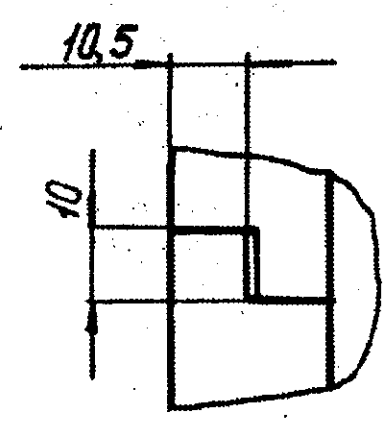
1. It is permissible to assemble dimension A from boards of different width not less than 80 mm.
2. Join the boards in quarter without through cavities.
3. Free dimensions as per js 16 GOST 6449-1-82.
4. It is permissible to avoid planing of surface B on area not exceeding 40% of depth up to 2 mm.

					AO- 18PYa .020 SB			
Amend.	Sheet	Doc. No.	Sign	Date	Side plate Assembly drawing	Type	Weight	Scale
Developed by						O ₂	4.280	1:10
Checked by						Sheet	Sheets 1	
Head of bureau								
Head of Q.C.D								
Approved by								

First Use	AO- 18 PYa.030 SB			
Reference No.				
Sign and Date				
Alternate Inv. No.				
Replaced inv no.				
Sign and Date				
Orig. Inv. No.				



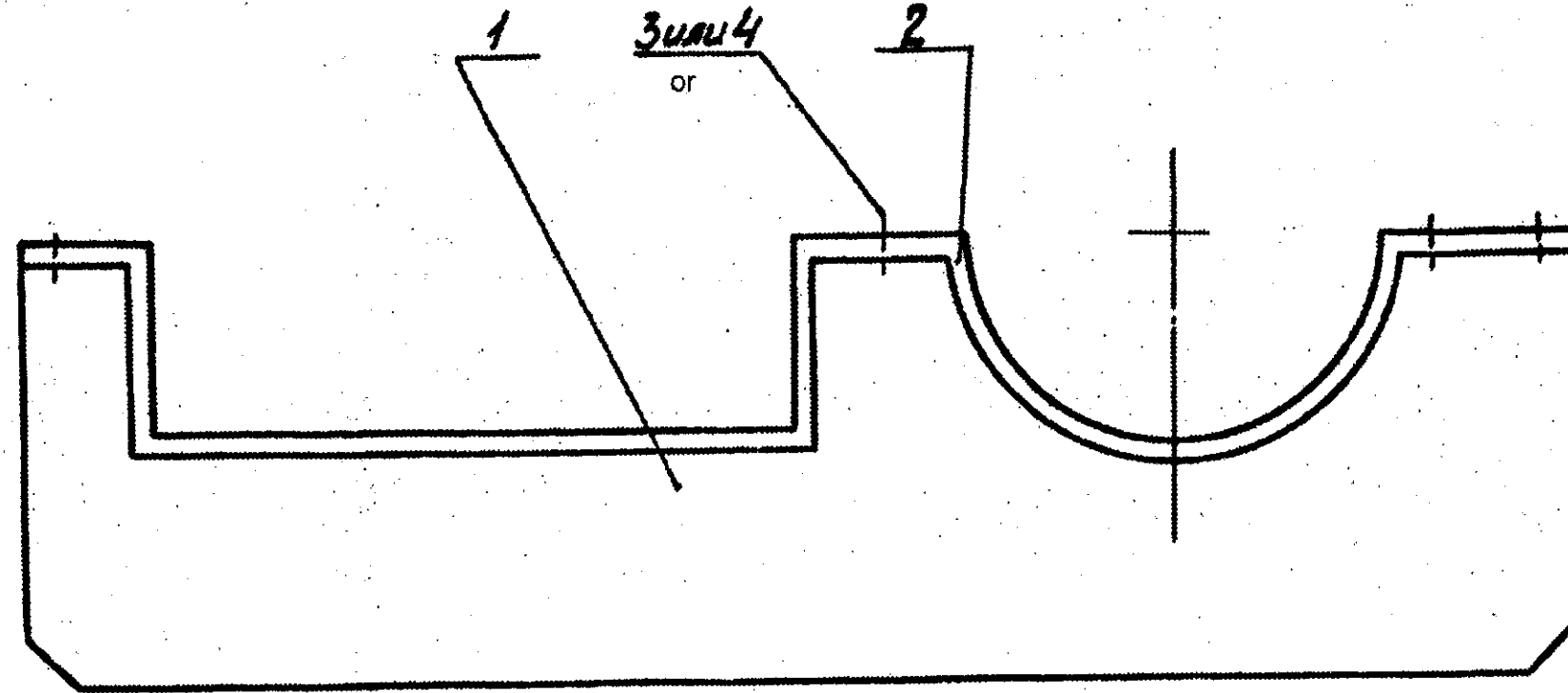
I
M 1:1



1. It is permissible to assemble dimension A from boards of different width not less than 80 mm.
2. Join the boards in quarter without through cavities.
3. Free dimensions as per js 16 GOST 6449-1-82.
4. It is permissible to avoid planing of surface B on area not exceeding 40% of depth up to 2 mm.

					AO- 18PYa .030 SB			
Amend.	Sheet	Doc. No.	Sign	Date	Cover Assembly drawing	Type	Weight	Scale
Developed by						O ₂	6.860	1:10
Checked by						Sheet	Sheets 1	
Head of bureau								
Head of Q.C.D								
Approved by								

AO- 18 PYa.040 SB



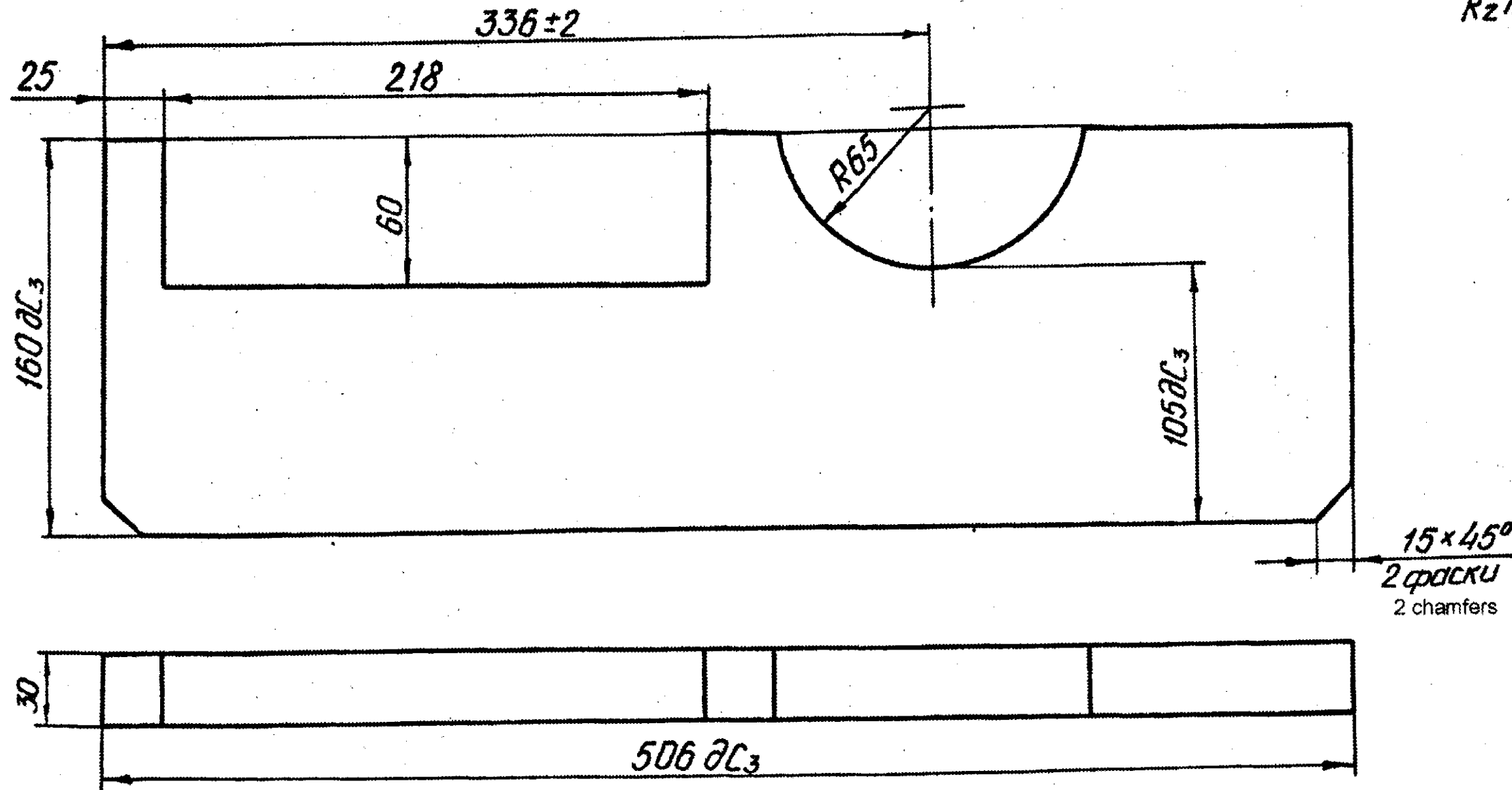
Glue component pos.2 to component pos.1 with nitro glue AK-20 TU6-10-1293-78.

First use
Reference No.
Sign and Date
Alternate Inv. No
Replaced inv no.
Sign and Date
Orig. Inv. No.

					AO- 18PYa .040 SB			
Amend.	Sheet	Doc. No.	Sign	Date	Lower pyramid Assembly drawing	Type	Weight	Scale
							O ₂	0.992
Developed by					Sheet		Sheets 1	
Checked by								
Head of bureau								
Head of Q.C.D								
Approved by								

Format A3

AO- 18 PYa.060



Rz max 800 ✓

15 x 45°
2 фидку
2 chamfers

Free dimensions as per js16 GOST 6449.1-82.

First use	
Reference No.	
Sign and Date	
Alternate Inv. No.	
Replaced inv no.	
Sign and Date	
Orig. Inv. No.	

					AO- 18PYa 060 .015			
Amend.	Sheet	Doc. No.	Sign	Date	Lower pyramid Assembly drawing	Type	Weight	Scale
Developed by						O ₂	0.939	1:2
Checked by						Sheet	Sheets 1	
Head of bureau								
Head of Q.C.D					Lumber of coniferous type, grade 2 GOST 8486-86			
Approved by								

Format A3

AO- 18 PYa.050 SB

First use

Reference No.

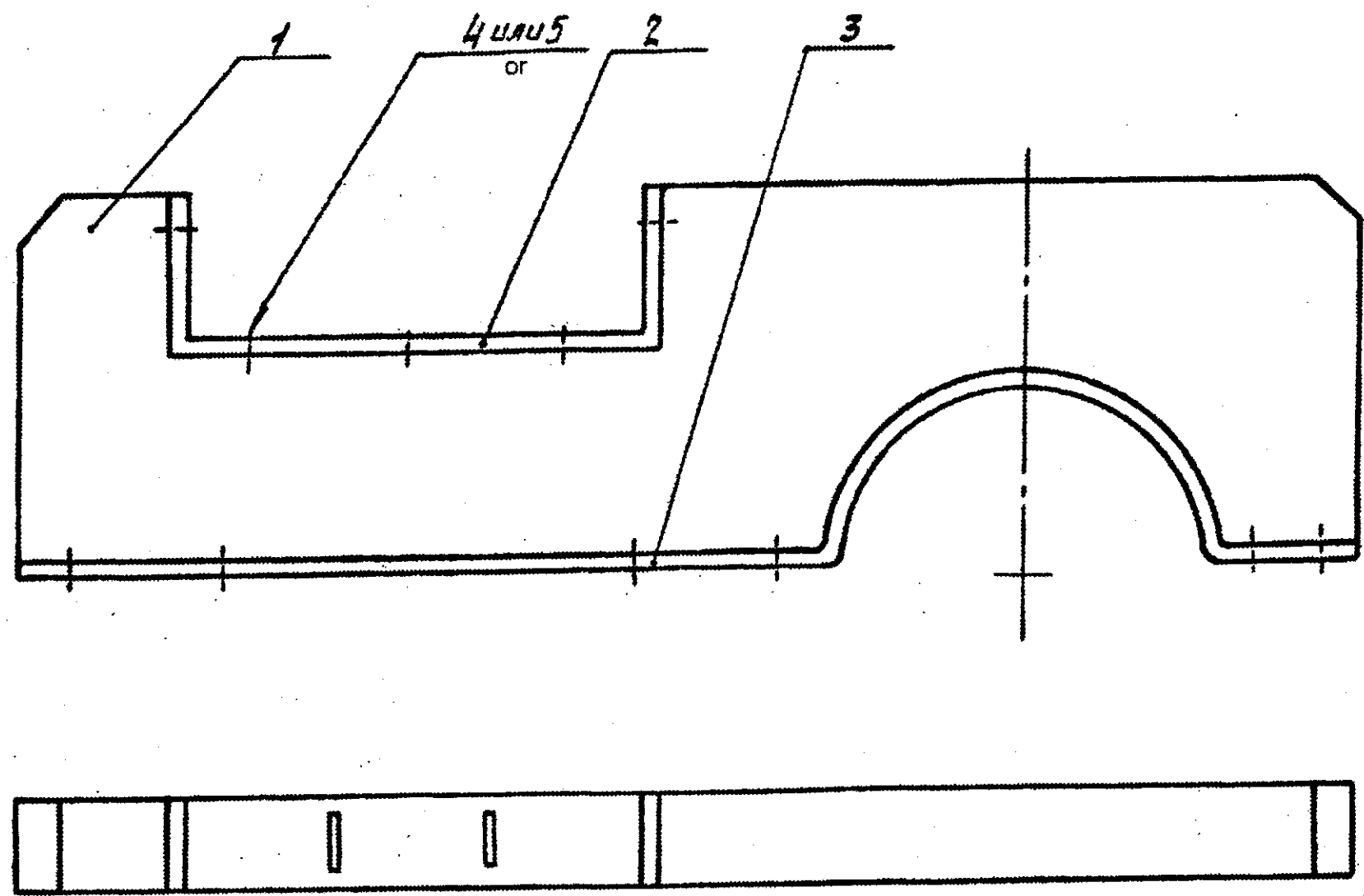
Sign and Date

Alternate Inv. No

Replaced inv no.

Sign and Date

Orig. Inv. No.



Glue component pos.2 and component pos.3 with nitro glue AK-20 TU6-10-1293-78.

					AO- 18PYa .050 SB			
Amend.	Sheet	Doc. No.	Sign	Date	Upper pyramid Assembly drawing	Type	Weight	Scale
Developed by						O ₂	1.07	1:2
Checked by						Sheet	Sheets 1	
Head of bureau								
Head of Q.C.D								
Approved by								

Format A3

AO- 18 PYa.017

First use

Reference No.

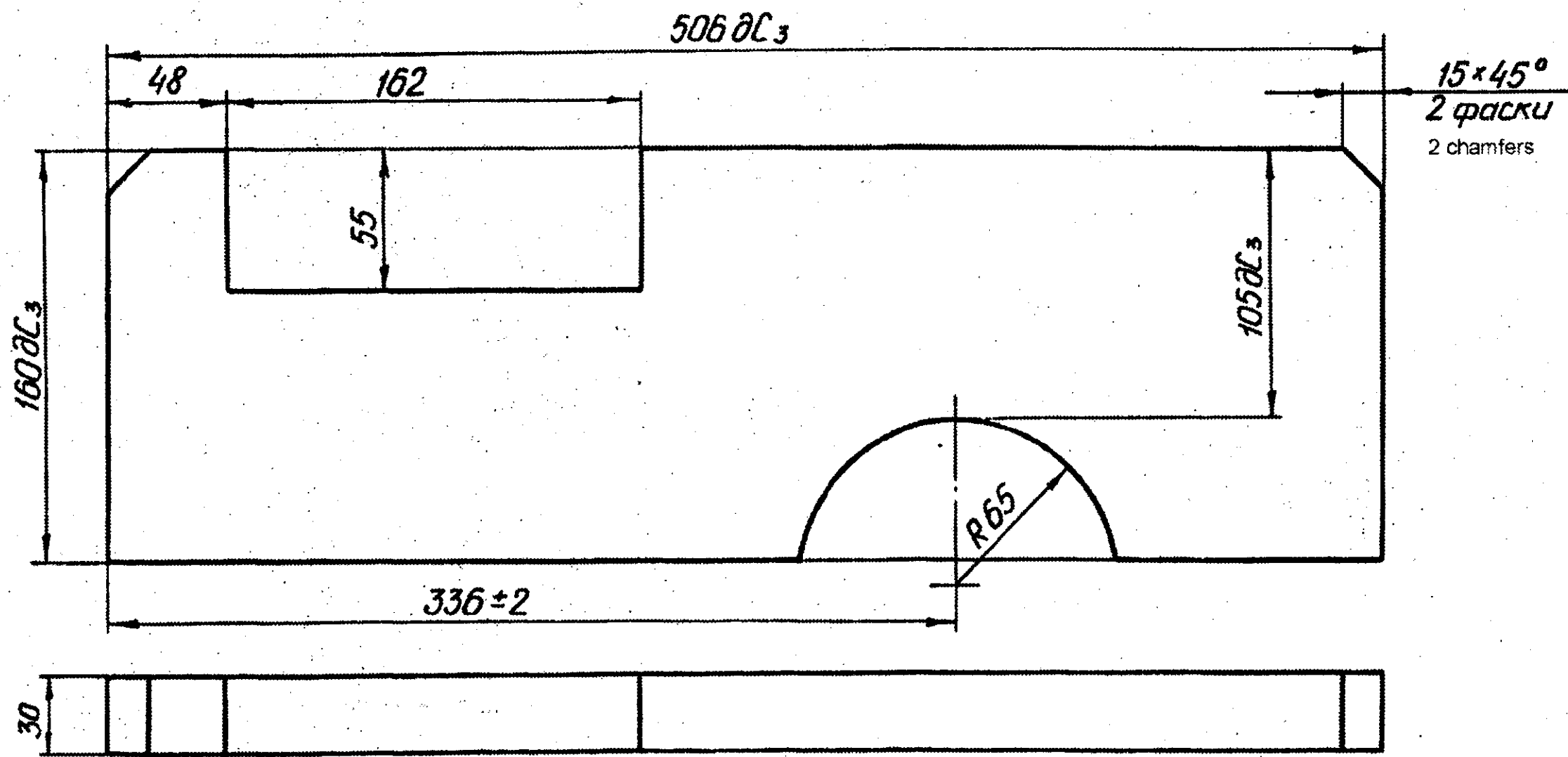
Sign and Date

Alternate Inv. No

Replaced inv no.

Sign and Date

Orig. Inv. No.



Free dimensions as per js16 GOST 6449.1-82.

					AO- 18PYa .017			
Amend.	Sheet	Doc. No.	Sign	Date	Upper pyramid	Type	Weight	Scale
Developed by						O ₂	1.00	1:2
Checked by						Sheet Sheets 1		
Head of bureau						Lumber of coniferous type, grade 2 GOST 8486-86		
Head of Q.C.D								
Approved by								

Format A3