

GUN & SHELL FACTORY COSSIPORE KOLKATA-700 002



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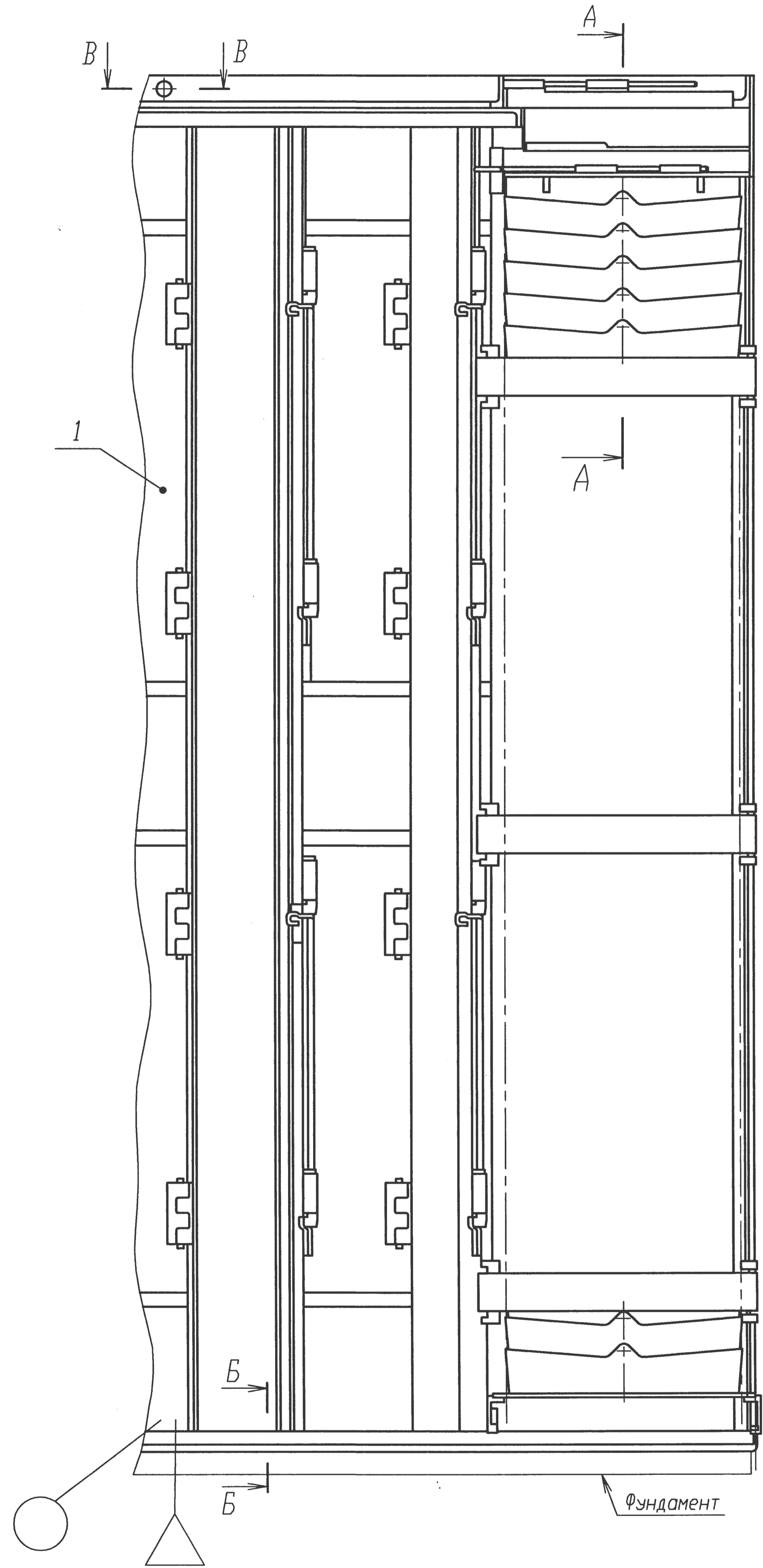
◆ THE CD SHOULD BE RETURNED TO THE GENERAL MANAGER GUN AND SHELL FACTORY AFTER USE

BIN

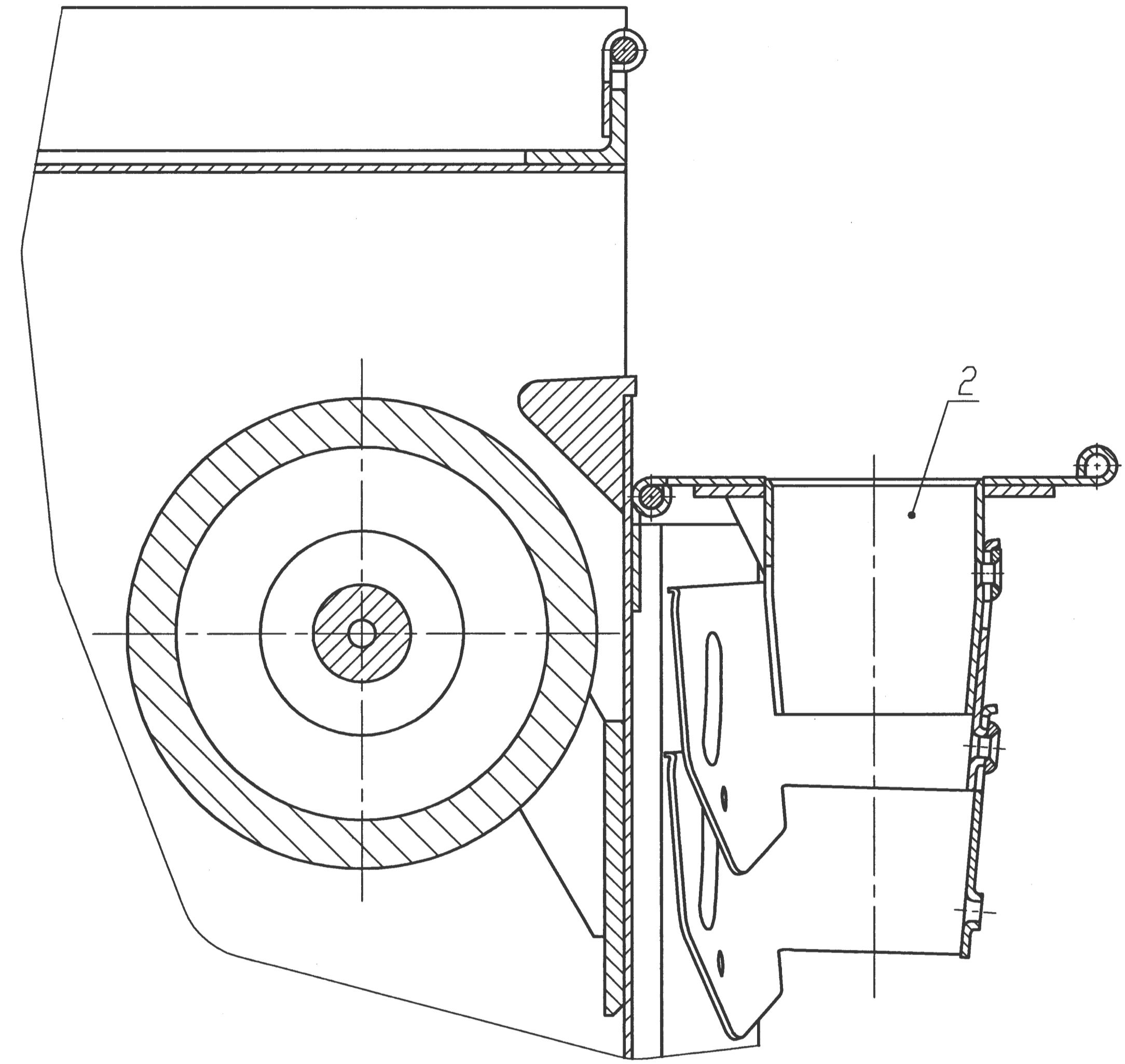
AK630Msb 03

First use		Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks	
Reference No.						<u>Documents</u>			
		A1			AK-630 Sb 03 SB	Assembly drawing			
						<u>Assembly units</u>			
		A4	1		AK-630M Sb 03-1	Feed bin	1		
		A4	2		AK-630M Sb 03-2	Hose	1		
						<u>Standard articles</u>			
Sign and Date				7		Bolt 2M12-8gx45.109.40X.029	11	31...40.5 HRC _E	
						GOST 7805-70			
Duplicate Inv. No.				8		Bolt	26	31...40.5 HRC _E	
						2M12-8gx80.109.40X.029			
Alternate Inv no.						GOST 7805-70			
				9		Nut M12-6G.10.40X.029	37	31...39.5 HRC _E	
Sign and Date						GOST 5919-73			
				10		Washer A12.25.29	74		
Orig. Inv. No.						GOST 11371-78			
		AK-630M. Sb 03							
		Amend.	Sheet	Doc. No.	Sign	Date			
		Developed by					Type	Sheet	Sheets
		Checked by					A	1	2
		Head of Q.C.D					Feed bin		
		Approved by							

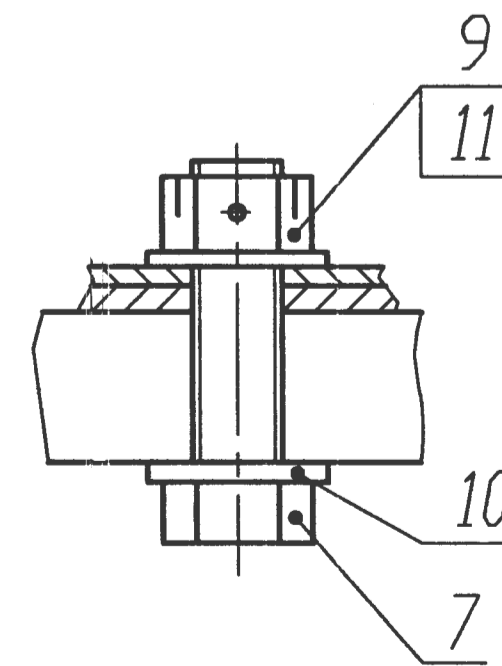
Orig. Inv. No.	Sign and Date	Alternate Inv no.	Duplicate Inv. No	Sign and Date	Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
							11		Cotter pin 3.2x32.029	37	
									GOST 397-79		
					AK-630M. Sb 03					Sheet	
					Amend.	Sheet	Doc. No.	Sign	Date	2	



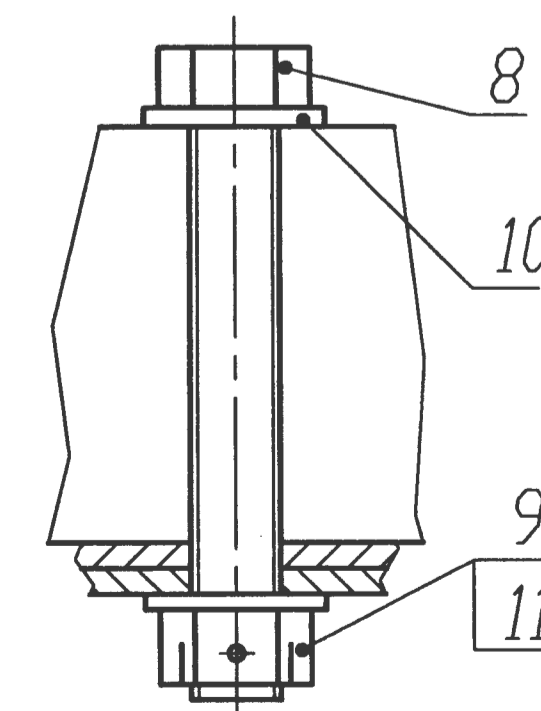
A-A (1:1)



Б-Б (1:1)



Б-Б (1:1)



Mark Ш, Ч, H, Ha and stamp K as per AK-630, AK-630M Tu1
Ha - Technological unit number of assembly .

					AK-630M SB 03 SB		
Amend	Sheet	Doc. No.	Sign	Date	Type	Weight	Scale
Developed by Checked by Technician					A	106.0	1:4
					Sheet	Sheets 1	
Head of bureau Head of Q.C.D Approved by							

First remarks
Refer No.
Duplicate Inv. No. / Sign. & Date
Alternate Inv. No.
Sign. & Date
Inv. No.

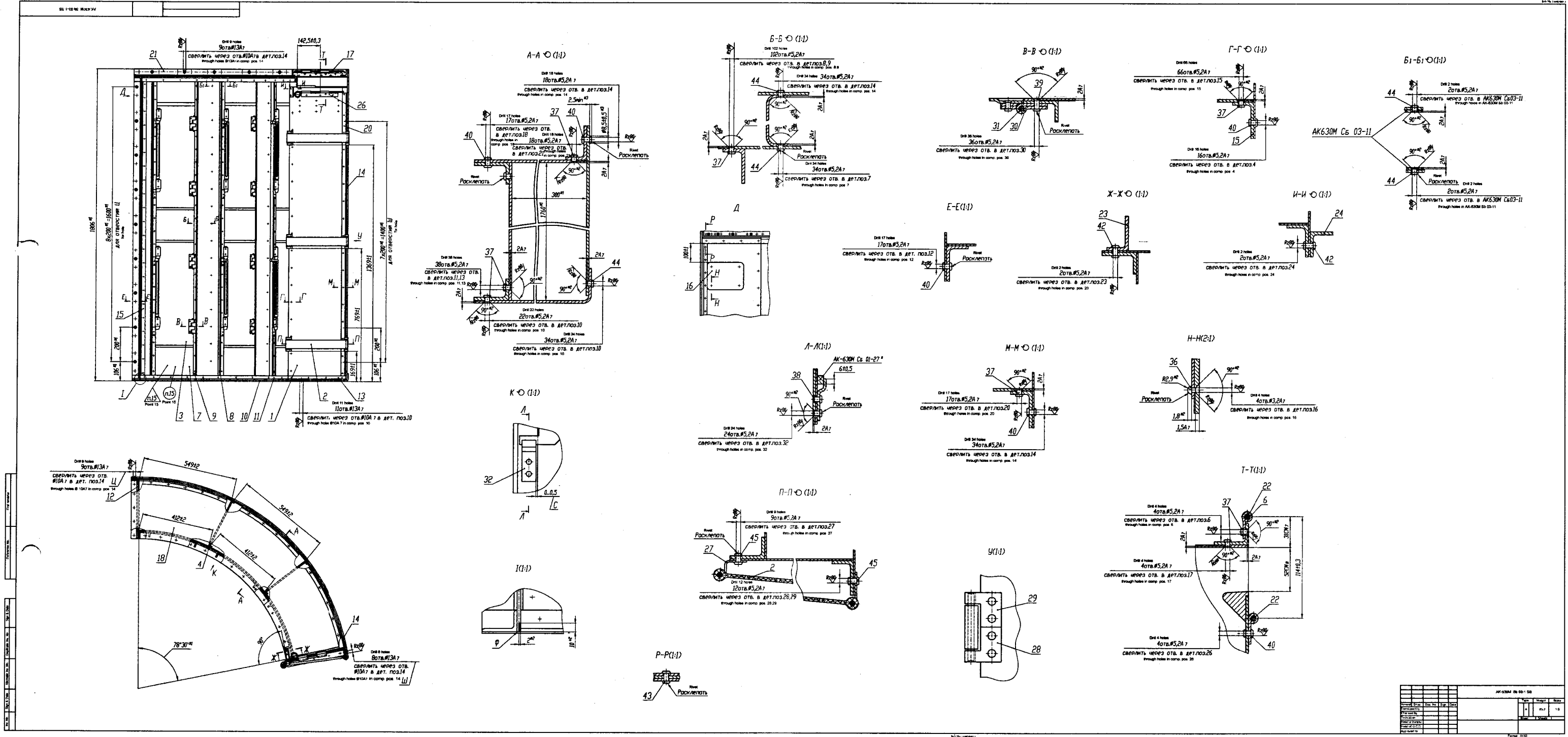
First use		Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks	
						<u>Documents</u>			
Reference No.		*)	✓		AK-630 Sb 03-1 SB	Assembly drawing		*)A1x3	
						<u>Assembly units</u>			
	A4		✓	1	AK-630M Sb 03-3	Front plate	1		
	A4		✓	2	AK-630M Sb 03-4	Tightening device	3		
	A4		✓	3	AK-630M Sb 03-5	Door	6		
	A4		✓	4	AK-630M Sb 03-11	Partition	2		
						<u>Components</u>			
Sign and Date		*)	✓	6	AK-630M 03-1	Loop	1	*)A4x3	
Duplicate Inv. No.		*)	✓	7	AK-630M 03-2	Internal plate	1	*)A4x3	
		A3	✓	8	AK-630M 03-3	Post	3		
		A3	✓	9	AK-630M 03-4	Post	3		
		A2	✓	10	AK-630M 03-5	Bottom	1		
Alternate Inv no.		*)	✓	11	AK-630M 03-6	Angle	2	*)A4x3	
		*)	✓	12	AK-630M 03-7	Rear plate	1	*)A4x3	
		*)	✓	13	AK-630M 03-8	Angle	3		
Sign and Date		AK-630M. Sb 03-1							
Orig. Inv. No.		Amend.	Sheet	Doc. No.	Sign	Date			
		Developed by					Type	Sheet	Sheets
		Checked by					A	1	3
		Head of Q.C.D					Feed bin		
		Approved by							

Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
A2	✓	14	AK-630M 03-9	External plate	1	
A3	✓	15	AK-630M 03-10	Post	3	
*)	✓	16	AK-630M 03-11	Plate	1	*)A4x3
A3	✓	17	AK-630M 03-12	Angle	1	
A2	✓	18	AK-630M 03-13	Cover	1	
A3	✓	20	AK-630M 03-15	Post	1	
*)	✓	21	AK-630M 03-16	Angle	1	*)A4x3
A4	✓	22	AK-630M 03-17	Axle	2	
A4	✓	23	AK-630M 03-18	Angle	1	
A4	✓	24	AK-630M 03-19	Stop	1	
A3	✓	26	AK-630M 03-21	Loop	1	
A4	✓	27	AK-630M 03-22	Loop	3	
A3	✓	28	AK-630M 03-23	Loop	3	
A3	✓	29	AK-630M 03-24	Loop	3	
A4	✓	30	AK-630 110-4	Loop	12	
A4	✓	31	AK-630 110-5	Axle	12	
A3	✓	32	AK-630 110-6	Cover plate	12	
				Standard articles		
		36		Rivet 3x8.37.10	4	
				GOST 10300-80		
		37		Rivet 5x14.31.10	270	
				GOST 10300-80		
		38		Rivet 5x20.31.10	24	
				GOST 10300-80		
Orig. Inv. No.						Sheet
						2
Amend.	Sheet	Doc. No.	Sign	Date		

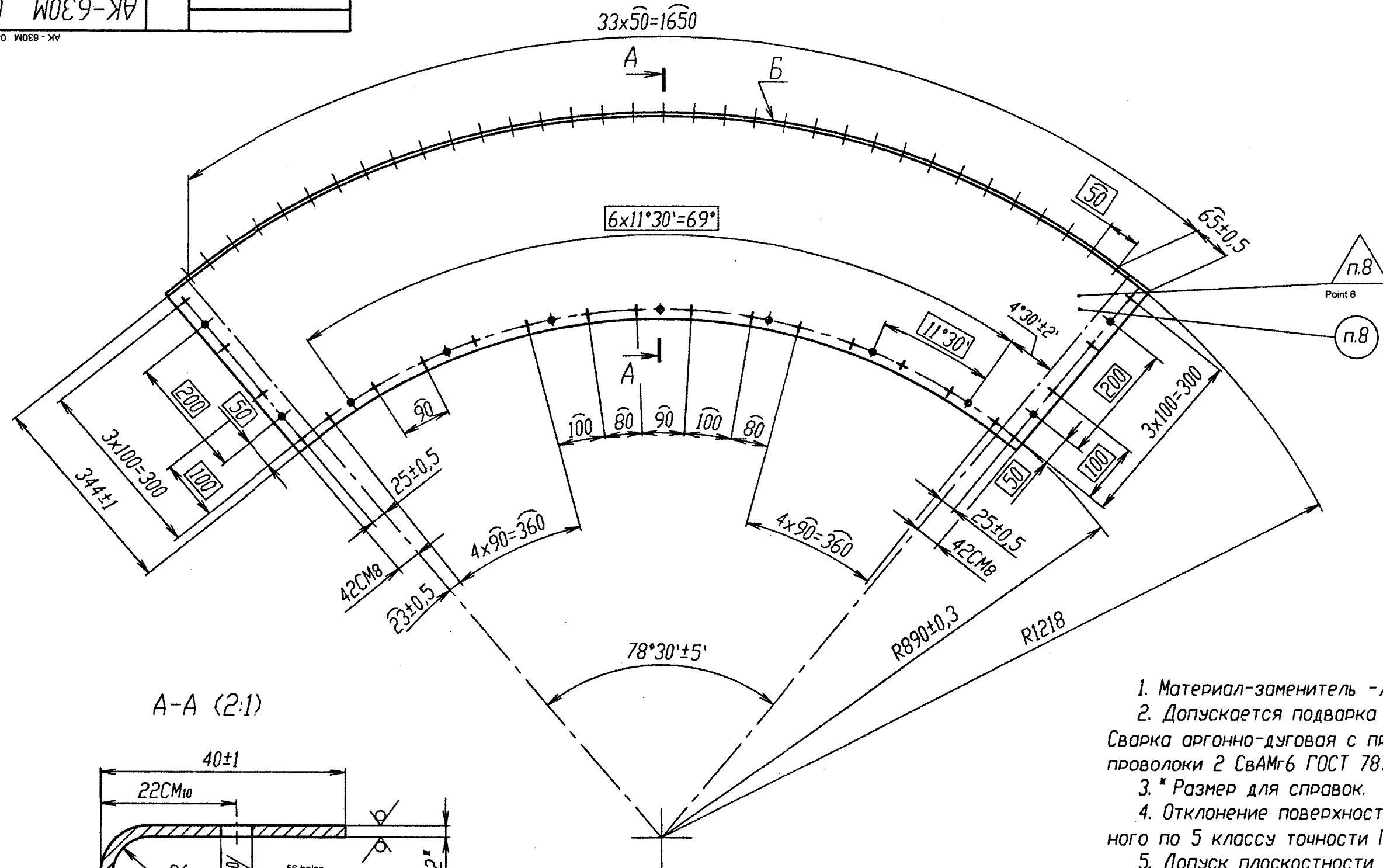
AK-630M. Sb 03-1

Sheet

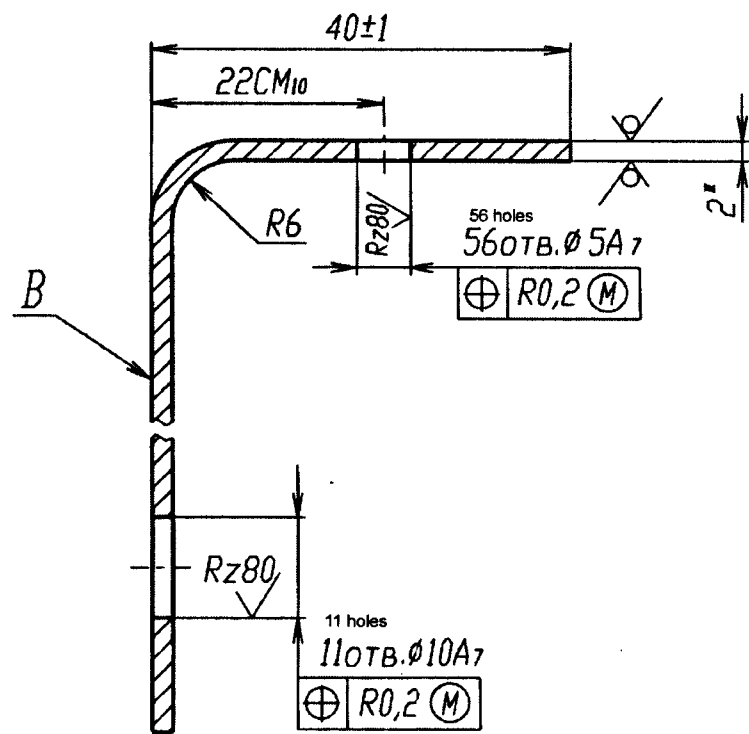
2



АК630М Сб 03-11	
№	Изм.
1	Исход.
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A-A (2:1)



1. Материал-заменитель - Лист АМг6 М-2 ГОСТ 21631-76.
2. Допускается подварка трещин после гибки.
- Сварка аргоно-дуговая с применением присадочной проволоки 2 СвАМг6 ГОСТ 7871-75.
3. * Размер для справок.
4. Отклонение поверхности В от шаблона, изготовленного по 5 классу точности ГОСТ 2689-54, не более 2 мм.
5. Допуск плоскостности поверхности В не более 2 мм.
6. Острые ребра притупить ~ 0,4 мм.
7. Покрытие Ан. Окс. хр.
8. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ I.

1. Material substitute - Sheet AMg6 M - 2 GOST 21631-76.
2. After the bending, the welding of cracks is permitted. Argon-arc welding with the use of filler electrode 2Sv. AMg6 GOST 7871-75.
3. * - Dimension for reference.
4. The deviation of surface B from the template, manufactured as per 5 class of accuracy GOST 2689-54, is not more than 2 mm.
5. Tolerance of flatness of surface B is not more than 2 mm.
6. Blunt the sharp edges ~ 0.4 mm.
7. Coating An. Ox. chrome.
8. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

AK - 630M 03-5

			AK-630M 03-5		
			AK-630M	03-5	
			Type	Mass	Scale
			Bottom	ДНО	
			Лит.	3,100	1:5
			Лист	Листов 1	
			Sheet	Total Sheets	
			Лист АМг6 М-2 ГОСТ 21631-76		
			Лист АМг6 М-2 ГОСТ 21631-76		

Формат А2

Перед. лист

Средн. л.

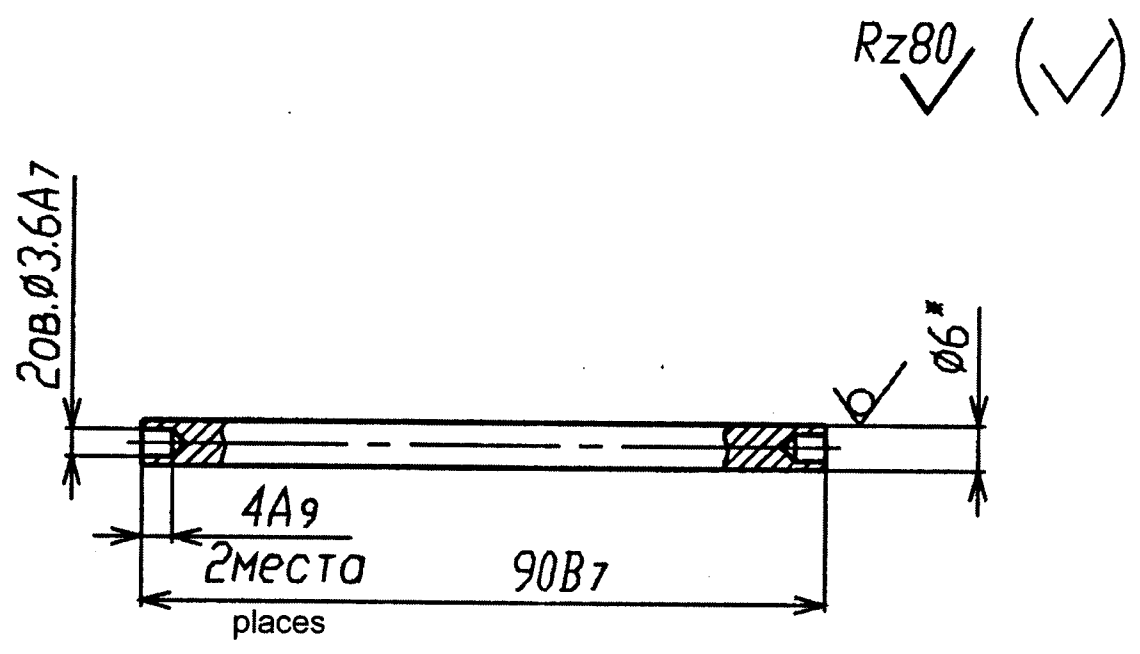
Послед. л.

Имя. л.

Имя. л.

AK-630 110-5

Approved OGMet	Approved TOSb	Approved KTONI	Approved by shop	First use
Orig. Inv. No.	Alternate Inv. No.	Sign and Date	Reference No.	



- 1.* Reference dimension.
- 2.Blunt sharp edges ~0.4 mm.
- 3. Material should be in annealed condition.
- 4. Coating Cd.12 Phos.Oil.
- 5. Mark Ш, Ч and stamp K on tag.

AK-630 110-5

Amend.	Sheet	Doc. No.	Sign	Date	Type	Weight	Scale
					Pin	A	0.023 1:1
						Sheet	Sheets 1
					Wheel	6-5 GOST 7417-75 25V GOST 1051-73	

Copied by Format A4

First use

Reference No.

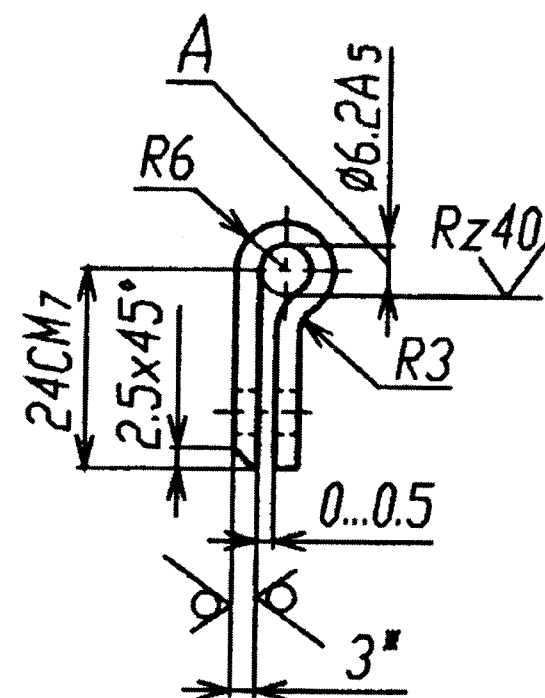
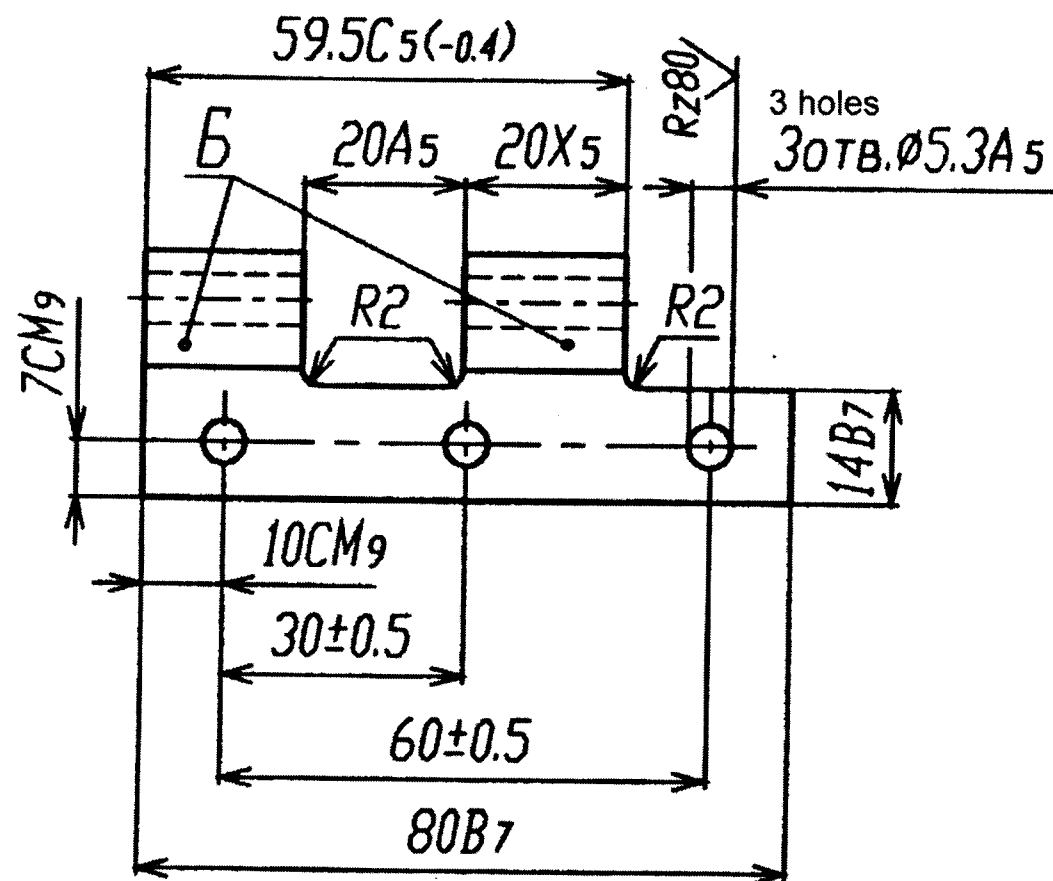
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz160 (✓)

1. Substitute material: Sheet AMg6 MZ GOST 21631-76.
- 2.* Reference dimensions.
3. While making dimension A, thickness of wall should not be less than 2.5 mm.
4. After bending on surfaces B, flaking of surface layer of metal as per test specimen is permissible.
5. Inner angles R~0.4 mm.
6. Blunt sharp edges ~0.4 mm.
7. Coating Anodic Oxid.Cr.
8. Mark Ш, Ч and stamp K on batch tag.

					AK-630 110-4			
Amend.	Sheet	Doc.No.	Sign	Date	Loop	Type	Weight	Scale
Developed by						A	0.030	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D						Sheet AMg6 BMZ GOST 21631-76		
Approved by								

AK-630 110-6

First use

Reference No.

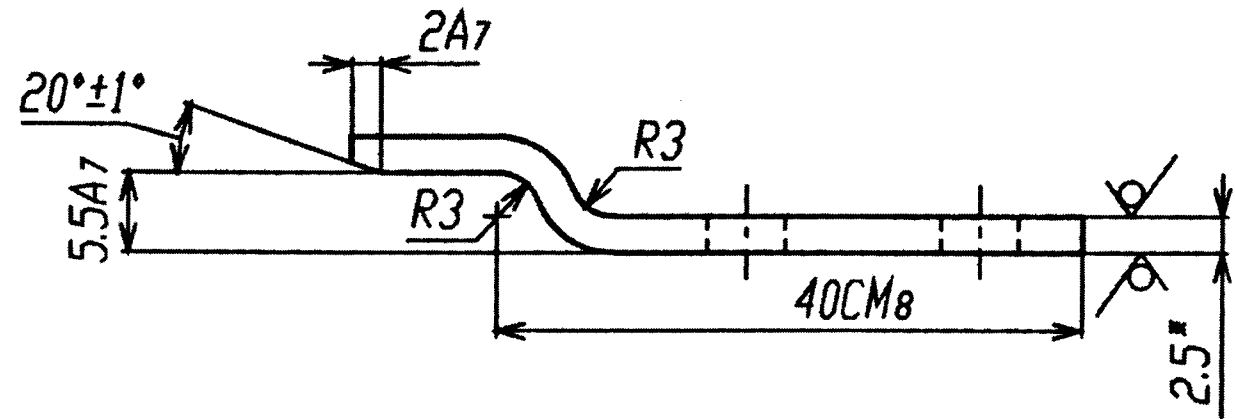
Sign and Date

Duplicate Inv. No

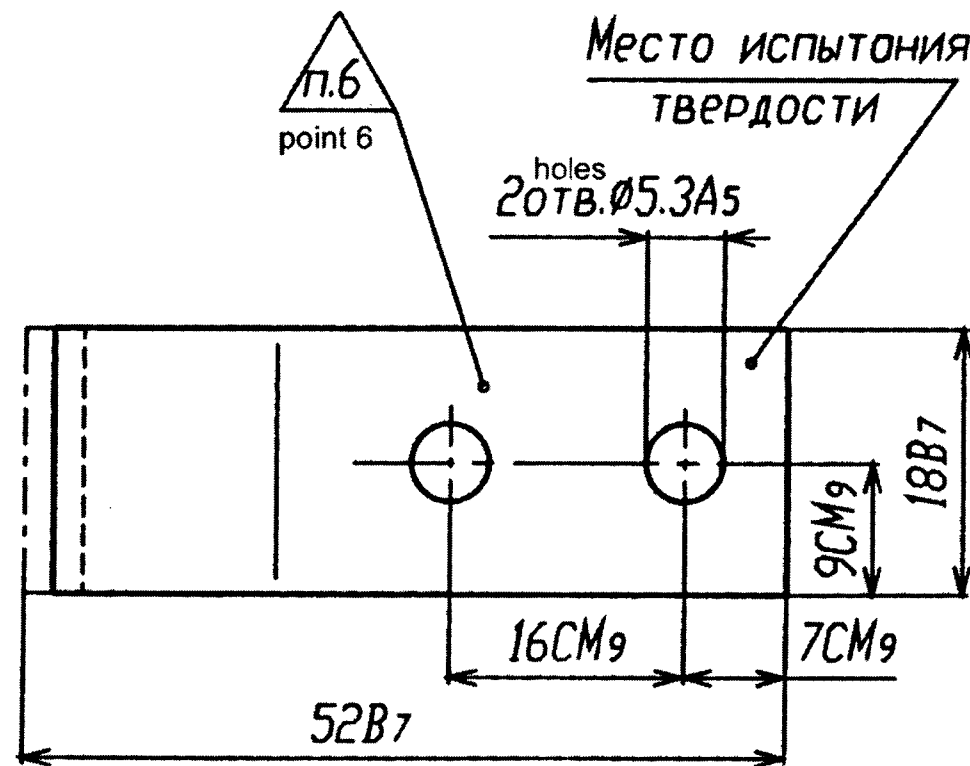
Alternate Inv. No

Sign and Date

Orig. inv. no.



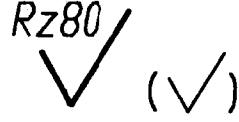
Rz160 (✓)



Place for checking hardness

1. 34...39.5 HRC_E. Check hardness on 3-5% but not less than 3 nos. from the batch.
2. * Reference dimension.
3. Blunt sharp edges ~0.4 mm.
4. Coating Cd 12 Phos. Oil.
5. Mark Ч, Ш on tag.
6. Stamp K, И as per AK-630, AK-630M TU I.

					AK-630 110-6			
Amend.	Sheet	Doc.No.	Sign	Date	Cover plate	Type	Weight	Scale
Developed by						A	0.014	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D						Sheet $\frac{B - PN - 02.5GOST19903 - 74}{K490V4 - III - 40GOST16523 - 97}$		
Approved by								

Rz80


First use

Reference No.

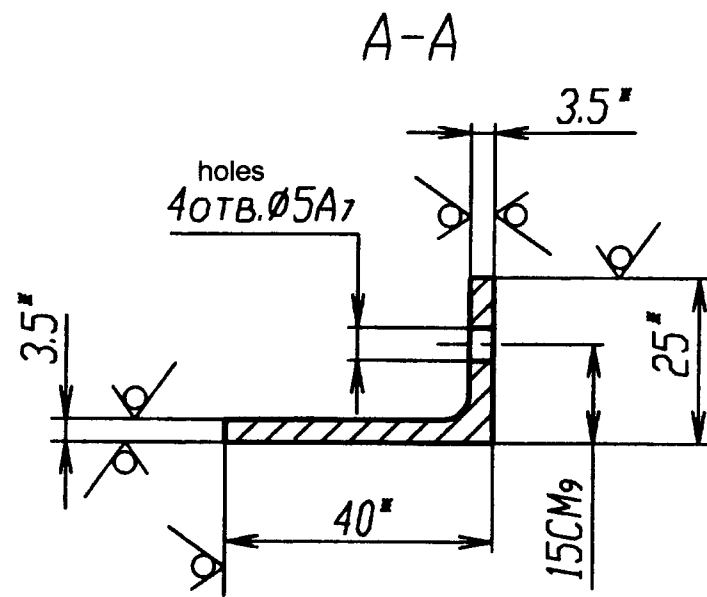
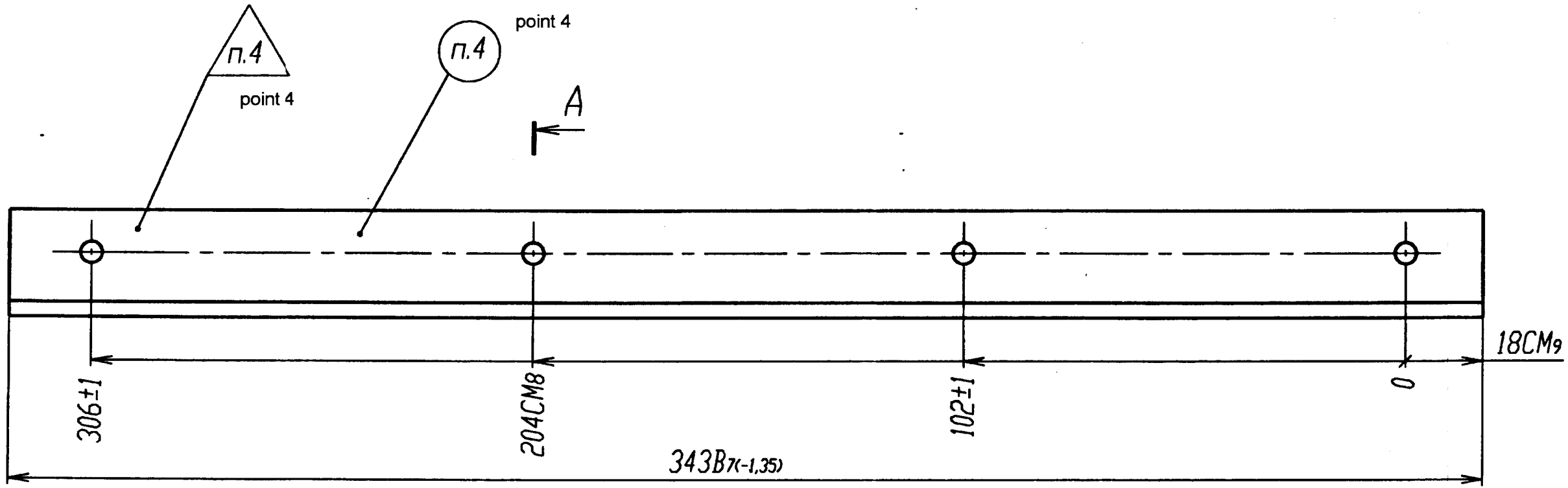
Sign and Date

Duplicate Inv. No

Alternate No

Sign and Date

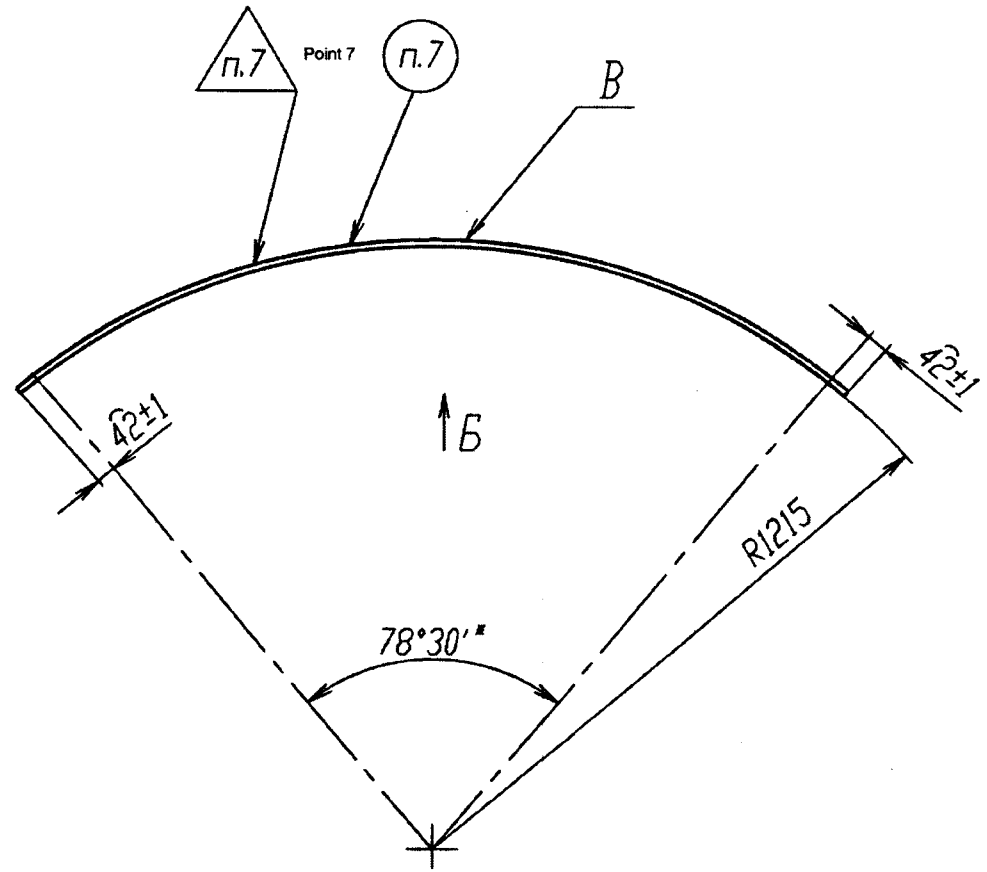
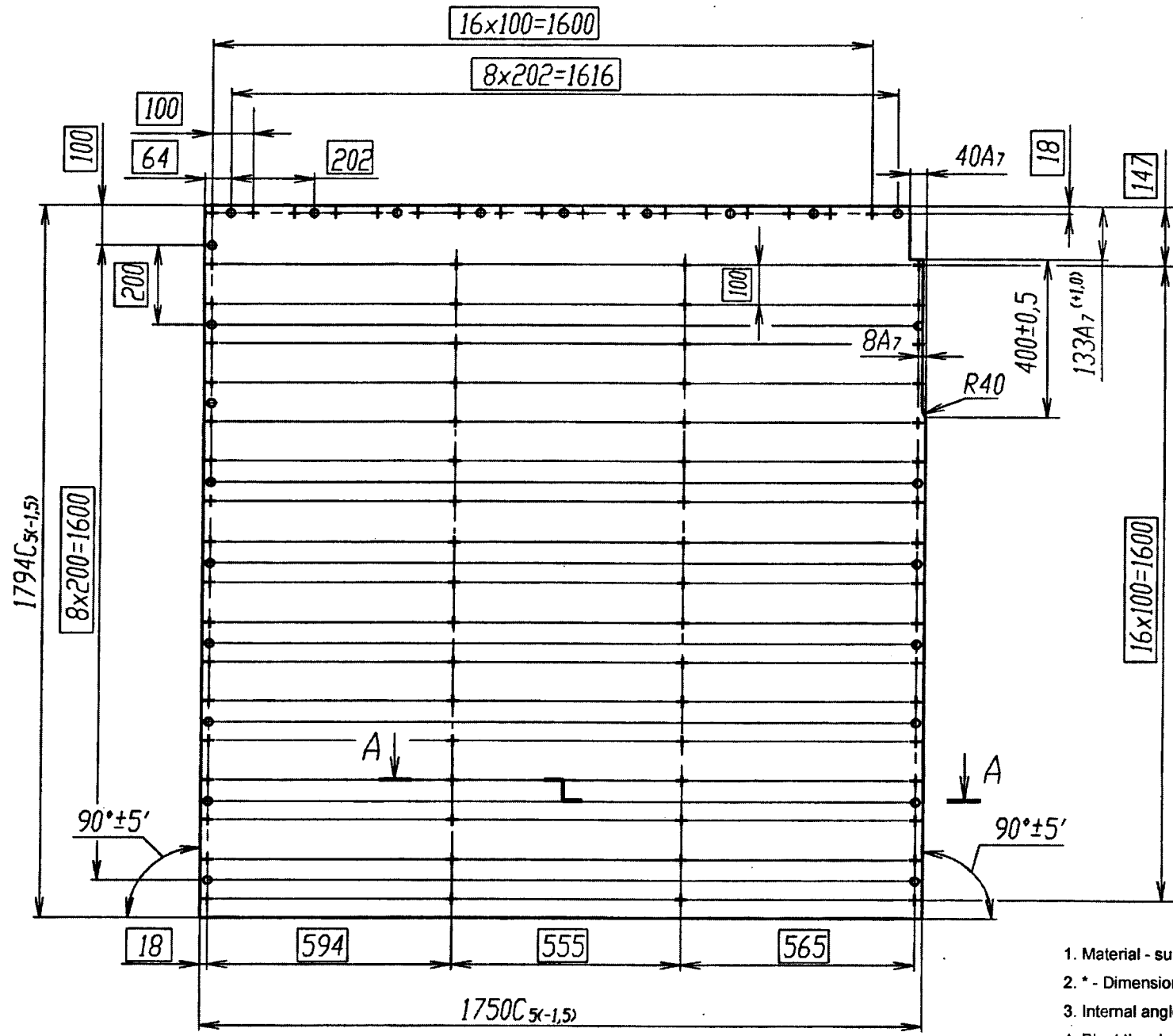
Orig. inv. no.



- 1.* Reference dimension.
- 2. Blunt sharp edges ~0.4 mm.
- 3. Coating Anodic Oxid.Cr.
- 4. Mark Ш,Ч on tag and stamp K as per AK-630, AK-630M TU I.

Comment [55]:

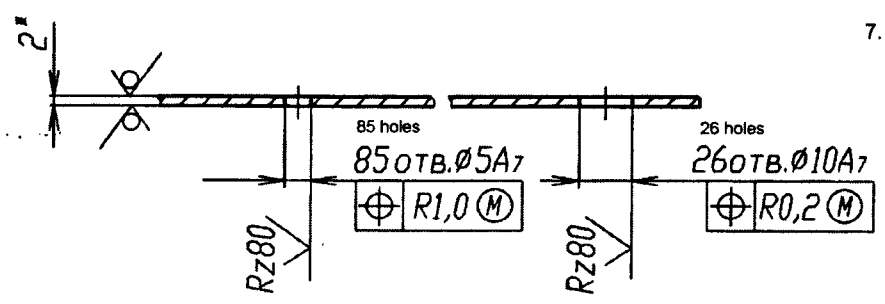
					AK-630M 03-8			
Amend	Sheet	Doc.No.	Sign	Date	Angle piece	Type	Weight	Scale
Developed by						A	0.190	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Profile AMg6 410808 $\frac{GOST8617 - 81}{GOST13738 - 91}$			
Approved by								



1. Material - substitute - Sheet AMg6 M-2 GOST 21631-76.
2. * - Dimensions for reference.
3. Internal angles $R \sim 0.4$ mm.
4. Blunt the sharp edges ~ 0.4 mm.
5. The deviation of surface B from the template, manufactured as per 5 class of accuracy GOST 2689-54, is not more than 2 mm.
6. Coating: An. Ox. chrome.
An. Ox. is permitted.
7. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

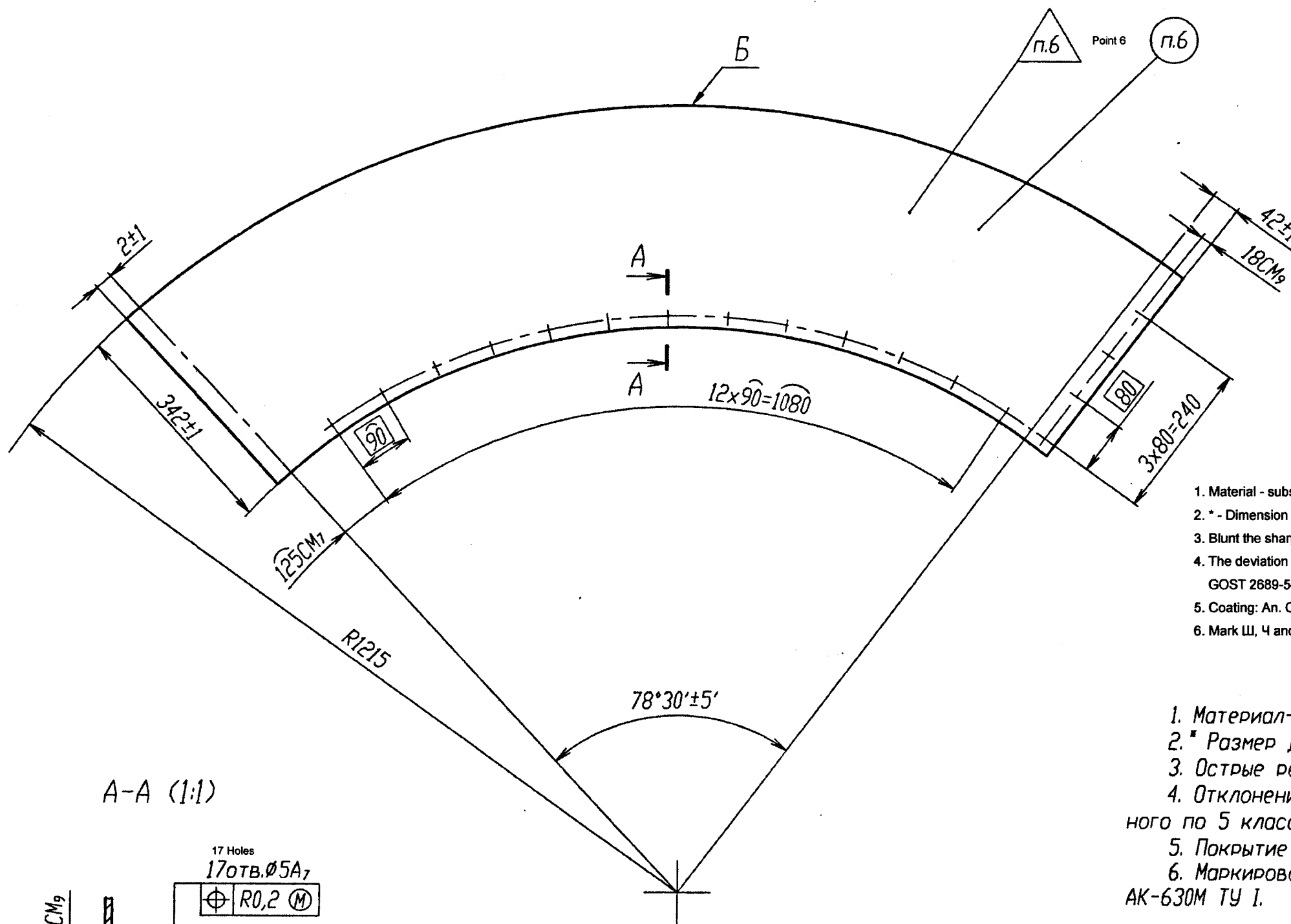
1. Материал-заменитель - Лист АМг6 М-2 ГОСТ 21631-76.
2. * Размеры для справок.
3. Внутренние углы $R \sim 0,4$ мм.
4. Острые ребра притупить $\sim 0,4$ мм.
5. Отклонение поверхности В от шаблона, изготовленного по 5 классу точности ГОСТ 2689-54, не более 2 мм.
6. Покрытие: Ан. Окс. хр. Допускается Ан. Окс.
7. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ I.

A-A(1:1)



Исполн. Подл. и дата
 Проверен. Инв. и дата
 Согласован
 Пред. проекта

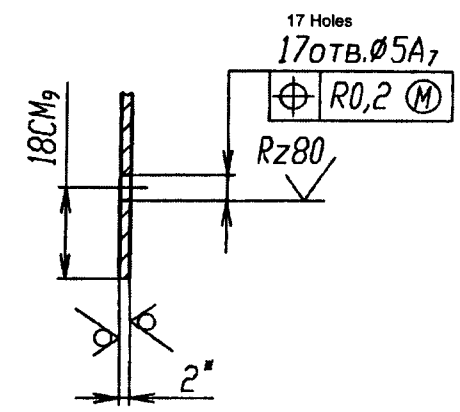
AK-630M 03-9				Type	Mass	Scale
AK-630M 03-9				Лит.	Масса	Масштаб
Изм/лист	№ докум.	Подп.	Дата	Стенка	A	22,50
Разроб.				наружная		1:10
Проб.				Лист		Листов 1
Т.контр.				Sheet		Total Sheets
Н.контр.				Лист АМг6 ВМ-2 ГОСТ 21631-76		
Утв.						



1. Material - substitute - sheet AMg6 M-2 GOST 21631-76.
2. * - Dimension for reference.
3. Blunt the sharp edges ~ 0.4 mm.
4. The deviation of surface Б from template, manufactured as per 5 class of accuracy GOST 2689-54, is not more than 2 mm.
5. Coating: An. Ox. chrome.
6. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

1. Материал-заменитель - лист АМг6 М-2 ГОСТ 21631-76.
2. * Размер для справок.
3. Острые ребра притупить ~ 0,4 мм.
4. Отклонение поверхности Б от шаблона, изготовленного по 5 классу точности ГОСТ 2689-54, не более 2 мм.
5. Покрытие Ан. Окс. хр.
6. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ I.

A-A (1:1)

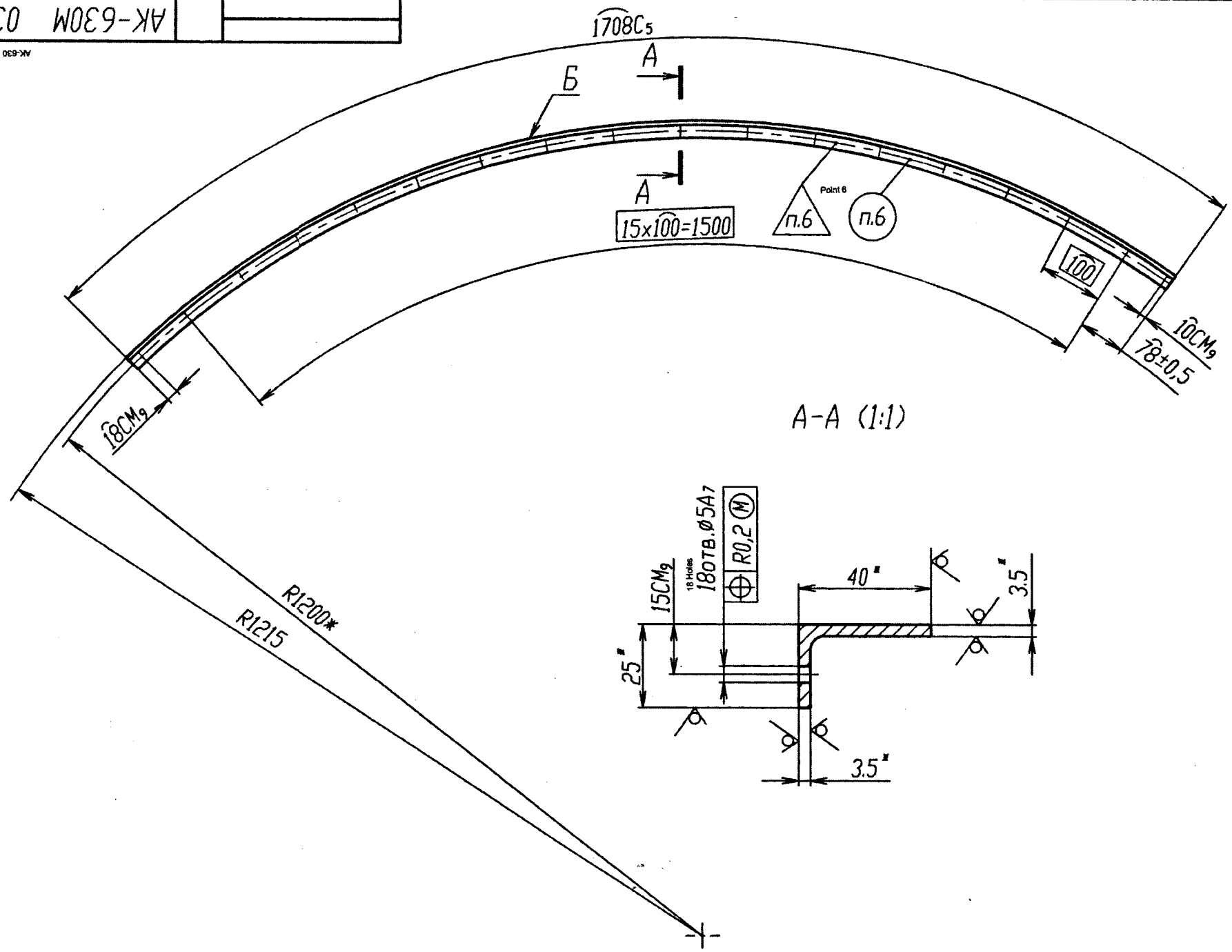


AK-630M 03-13				Type	Mass	Scale
AK-630M 03-13				Лит.	Масса	Масштаб
Изм/Лист	№ докум.	Подп.	Дата	А	3,200	1:5
Разраб.				Cover		
Проб.				КРЫШКА		
Т.контр.				Sheet AMg6 BM-2 GOST 21631-76		
И.контр.				Лист АМг6 ВМ-2		
Утв.				ГОСТ 21631-76		
				Лист	Листов 1	
				Sheet	Total Sheets	

Перв. подмеч. / Стр. 03.01 / Подп. и дата / Взам. инв. / Инв. № / Подп. и дата / И-в.Н. подл.

91-Э0 W0C9-XV AK-630M 03-16

Rz80 ✓ (✓)

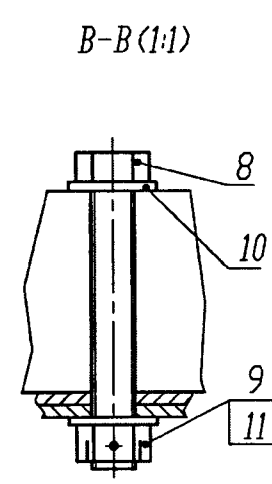
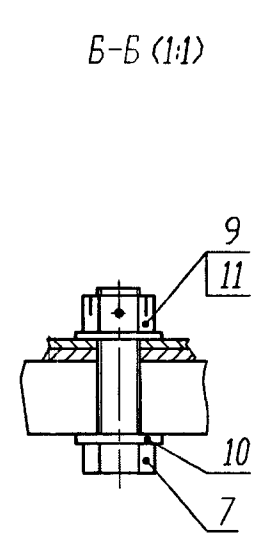
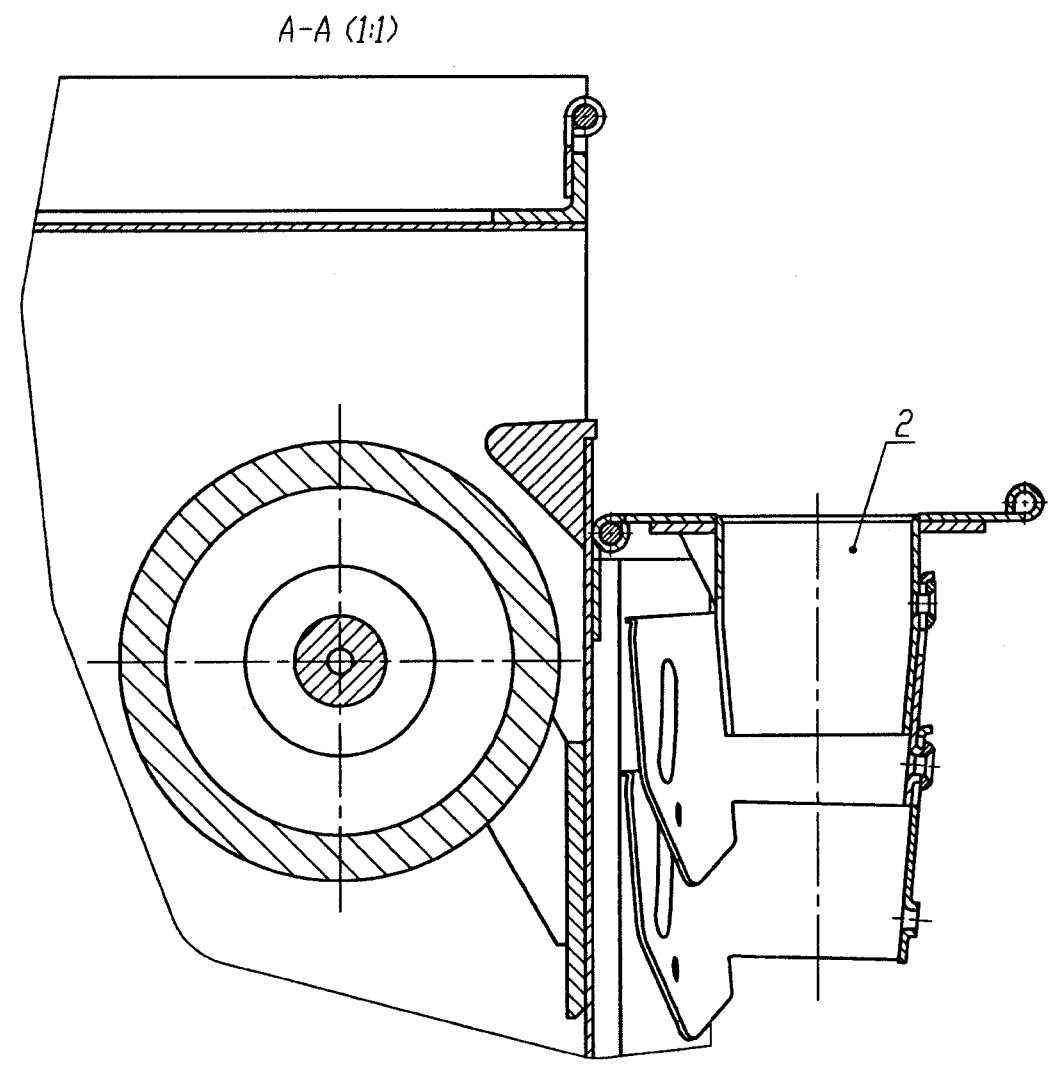
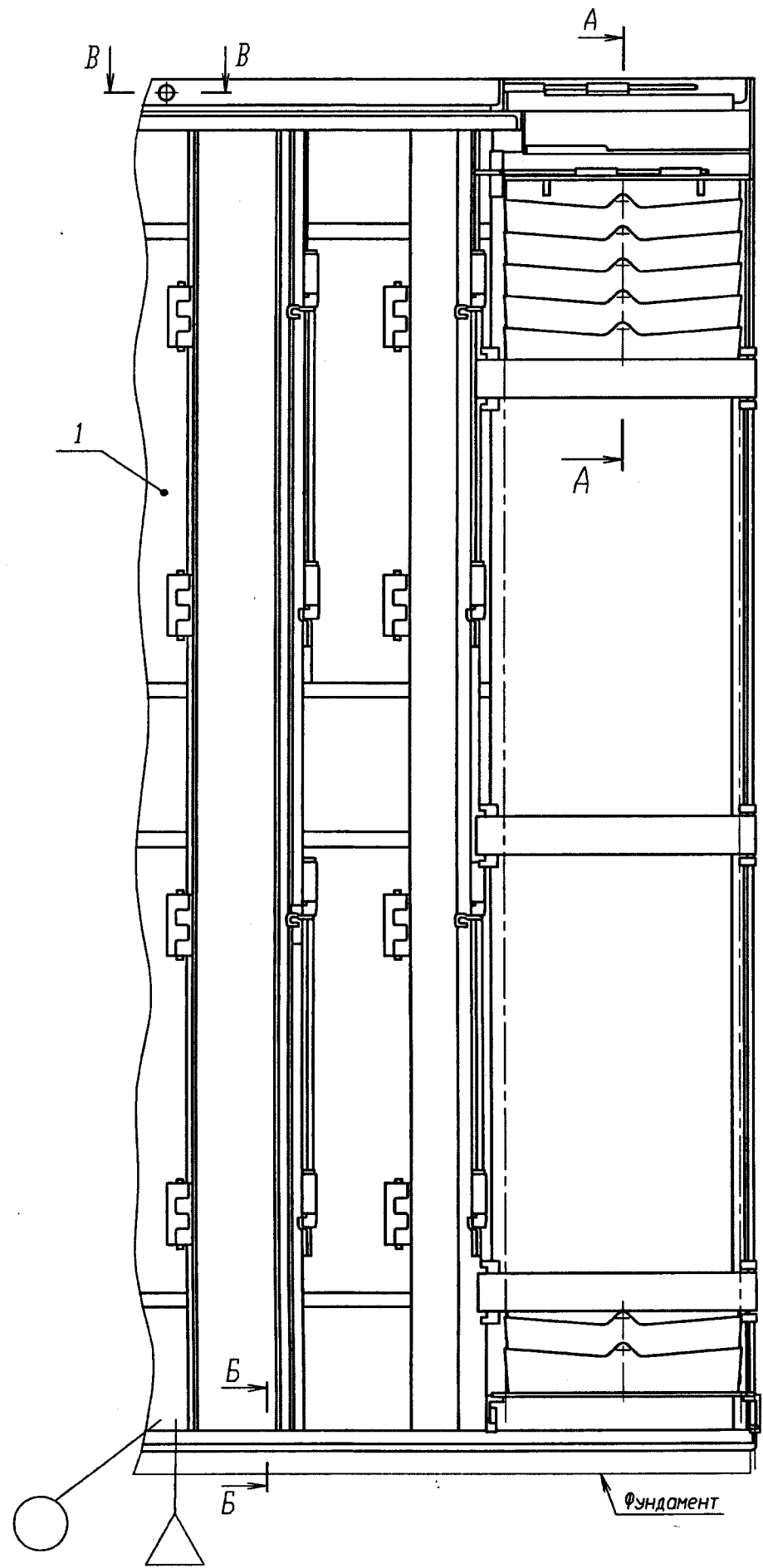


1. * - Dimensions for reference.
2. Deviation of surface B from the template, manufactured as per 5th class of accuracy GOST 2689-54, is not more than 2 mm.
3. Corrugations due to bending are permitted as per test specimen.
4. Blunt the sharp edges ~ 0.4 mm.
5. Coating: An. Ox. Chrome.
6. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

1. * Размеры для справок.
2. Отклонение поверхности Б от шаблона, изготовленного по 5 классу точности ГОСТ 2689-54, не более 2 мм.
3. Допускаются гофры от гибки по контрольному образцу.
4. Острые ребра притупить ~ 0,4 мм.
5. Покрытие: Ан. Окс. хр.
6. Маркировать Ш, Ч, и клеить К по АК-630, АК-630М ТУ I.

Инв.№ Подл. и дата
 Изм.№ Подл. и дата
 Взам.инв.№ Инв.№ Подл. и дата
 Ссыл. Подл. и дата
 Справ. №

AK-630 M 03-16				AK-630M 03-16		
Type				Type	Mass	Scale
Angle bar				Лит.	Масса	Масштаб
Уголок				A	0,900	1:5
GOST 8617-81				Лист 1		
Profile AMg6 410808				Sheet Total Sheets		
Профиль AM-6 410808				ГОСТ 8617-81		
ГОСТ 17738-91				ГОСТ 17738-91		
ГОСТ 17738-91				Формат А4х3		

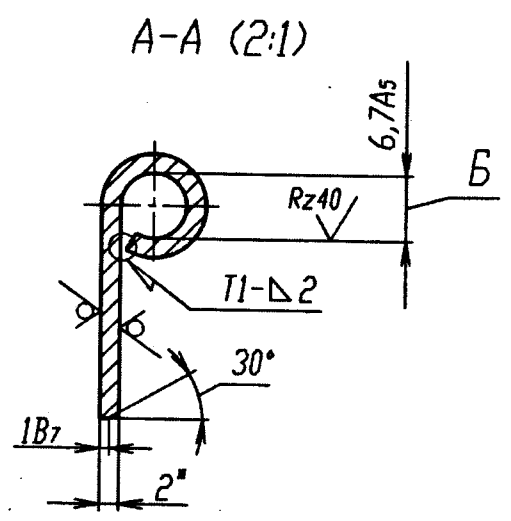
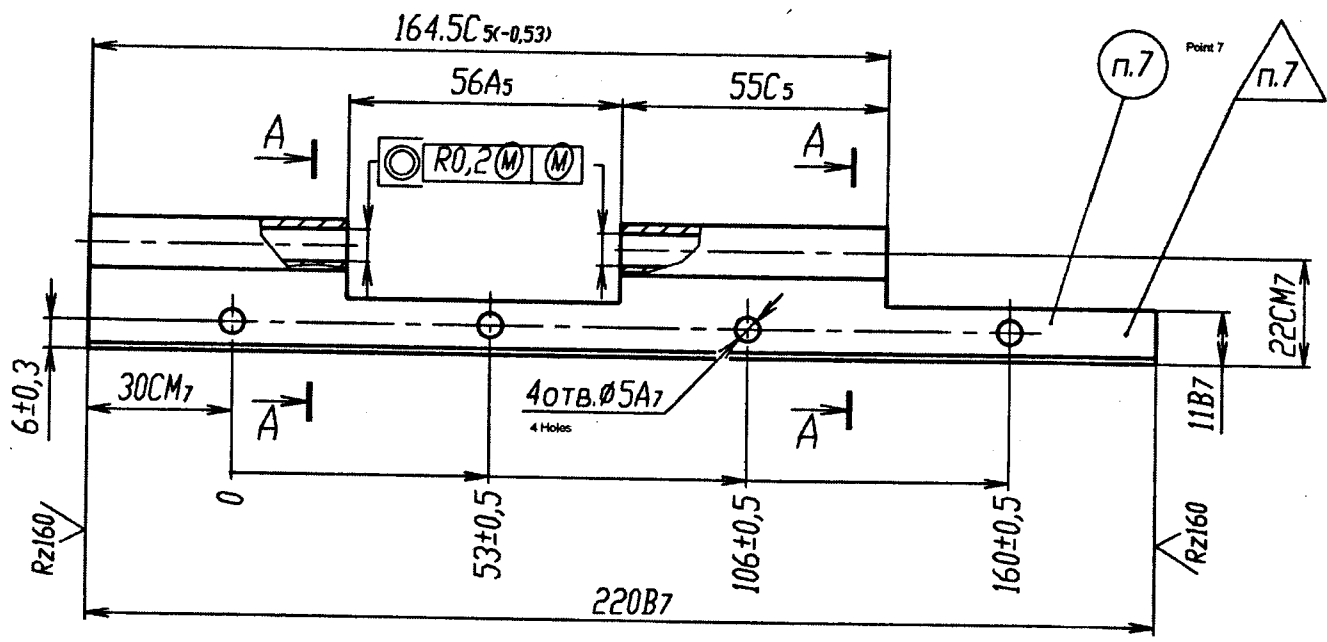


Mark Ш, Ч, Н, Ha and stamp K as per AK-630, AK-630M Tu1
Ha - Technological unit number of assembly.

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

				AK-630M SB 03 SB			
Amend	Sheet	Doc. No.	Sign	Date	Type	Weight	Scale
Developed by					A	106.0	1:4
					Sheet		Sheets 1
Checked by							
Technician							
Head of bureau							
Head of Q.C.D.							
Approved by							

AK-630M 03-1



Rz80 (✓)

1. Make the welded joints as per GOST 14771-76-UP with the use of filler electrode 1.25V-08 G2S GOST 2246-70. Welded joints of II category as per OST 3-4001-91. Carry out 100% inspection by way of external (visual) inspection. It is permitted to make the welded joints as per GOST 5264-80 by using filler electrodes УОНИИ - 13/45-2.0-2 GOST 9466-75.
2. * - Dimension for reference.
3. While make the dimension B, the thickness of wall is not less than 1.5 mm.
4. Internal angles R ~ 0.4 mm.
5. Blunt the sharp edges ~ 0.4 mm.
6. Coating: Kad 12, фос.
7. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

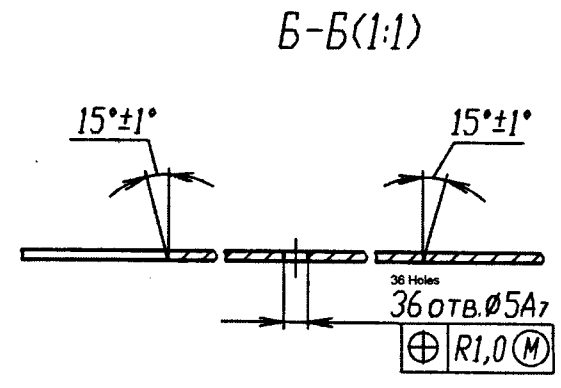
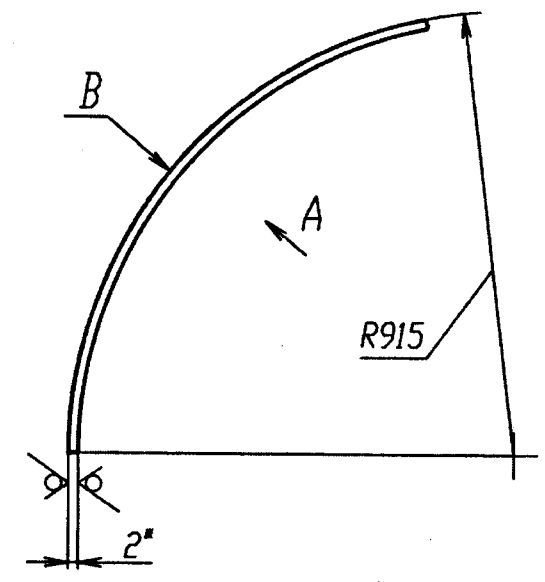
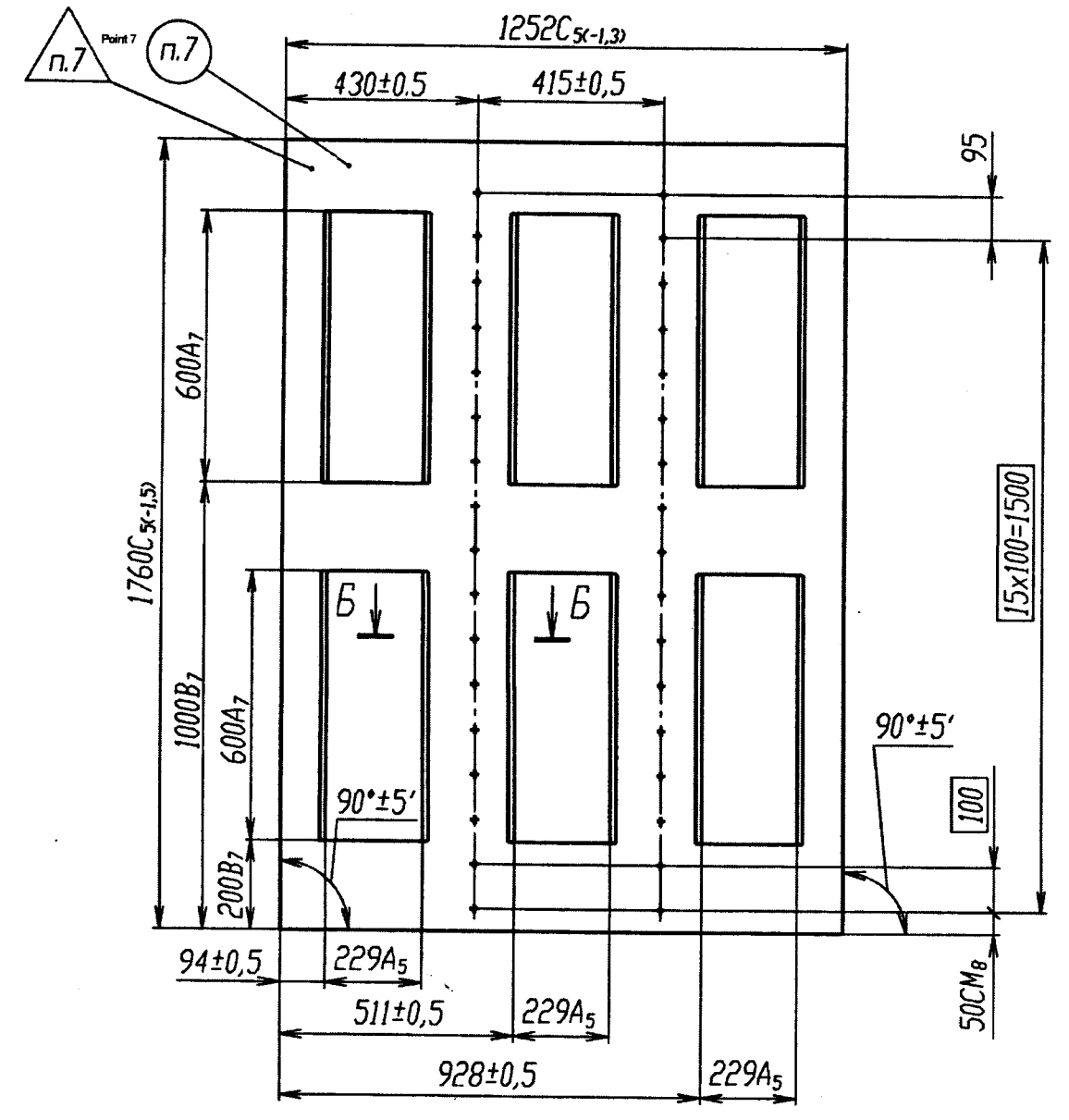
1. Сварные швы выполнять по ГОСТ 14771-76-УП с применением присадочной проволоки 1,2 Св-08 Г2С ГОСТ 2246-70. Сварные швы II категории по OST 3-4001-91. Контролировать 100% внешним осмотром. Допускается выполнять сварные швы по ГОСТ 5264-80 с применением электродов УОНИИ 13/45-2,0-2 ГОСТ 9466-75.
2. * Размер для справок.
3. При выполнении размера B толщина стенки не менее 1,5 мм.
4. Внутренние углы R ~ 0,4 мм.
5. Острые ребра притупить ~ 0,4 мм.
6. Покрытие Кд12, фос.
7. Маркировать Ш,Ч и клеймить К по АК-630, АК-630М ТУ I.

Перед. лист
 Справ.
 Подп. и дата
 Измен. и вкл.
 Взам. инв.
 Подп. и дата
 Измен. и вкл.
 Взам. инв.
 Подп. и дата

AK-630 M 03-1		AK-630M 03-1		
		Type Mass Scale		
Loop		Лит.	Масса	Масштаб
Петля		A	0,180	1:1
BT-PN-02 GOST 19904-90		Лист / листов 1		
Sheet BT-PN-0 2 GOST 19904-90		Sheet Total Sheets		
Лист КЗ90В 4-III-25 GOST 16523-97				

2-Э0 АК-630М 03-2

Rz80



1. Material - substitute: Sheet AMg6 M 2 GOST 21631-76.
2. * - Dimension for reference.
3. Internal angles R ~ 0.6 mm.
4. Blunt the sharp edges ~ 0.4 mm.
5. Deviation of surface B from the template, manufactured as per 5th class of accuracy GOST 2689-54, is not more than 2 mm.
6. Coating: An. Ox. chrome. An. Ox. is permitted.
7. Mark Ш, Ч and stamp К as per АК-630, АК-630М ТУ I.

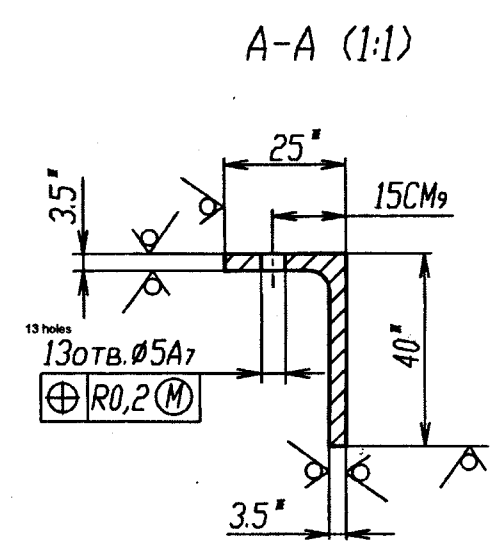
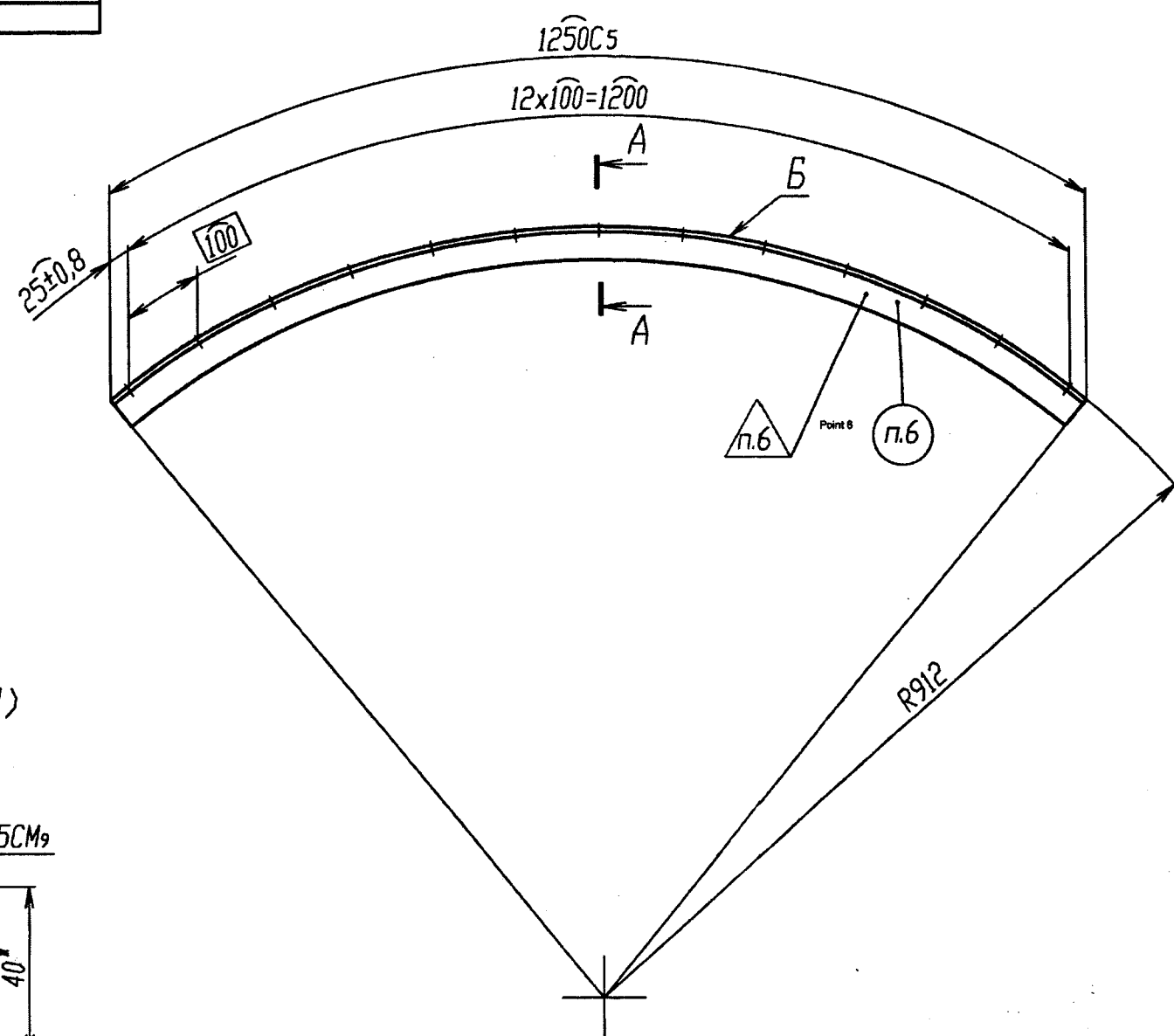
1. Материал-заменитель: Лист АМг6 М-2 ГОСТ 21631-
2. * Размер для справок.
3. Внутренние углы R ~ 0,6 мм.
4. Острые ребра притупить ~ 0,4 мм.
5. Отклонение поверхности В от шаблона, изготовленного по 5 классу точности ГОСТ 2689-54 не более 2 мм.
6. Покрытие Ан. Окс. хр. Допускается Ан. Окс.
7. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ I.

Пред. проект. Спроект. Измен. и авто. Возмичив. Измен. и авто. Подп. и авто. Измен. подл.

				AK-630 M 03-2			
				AK-630M 03-2			
Изм./Лист	№ докум.	Подп.	Дата	Internal Wall	Type	Mass	Scale
Разрб.				Стенка	А	11,0	1:
Пров.				внутренняя			
Т.контр.				Sheet AMg6 BM-2	Лист	Листов	
И.контр.				Лист АМг6 БМ-2	Sheet	Total Sheets	
Утв.				ГОСТ 21631-76			
				ФОРМАТ А4х3			

9-03 АК-630М 03-6

Rz80
✓ (✓)



1. * - Dimensions for reference.
2. Blur the sharp edges ~ 0.4 mm.
3. Deviation of surface B from the template, manufactured as per 5th class of accuracy GOST 2689-54, is not more than 2 mm.
4. Corrugations due to bending are permitted as per the standard.
5. Coating: An. Ox. Chrome.
6. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

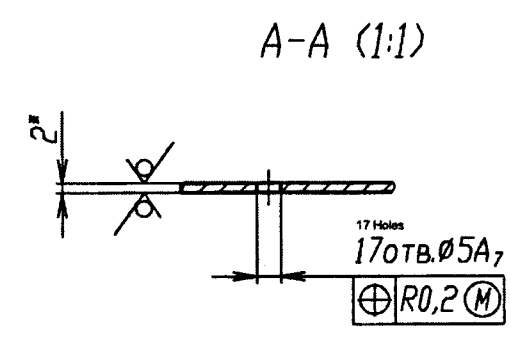
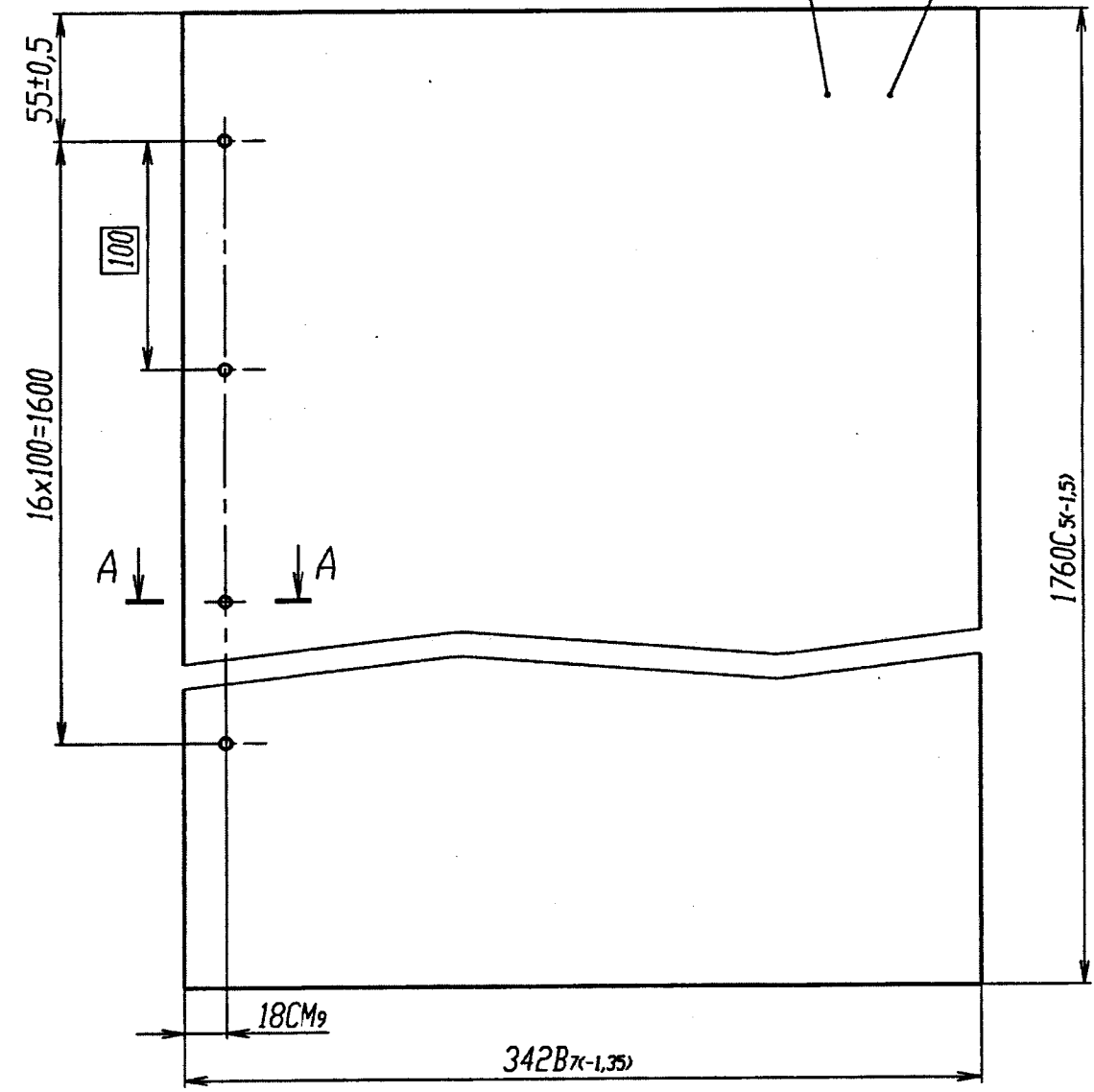
1. * Размеры для справок.
2. Острые ребра притупить ~ 0,4 мм.
3. Отклонение поверхности Б от шаблона, изготовленного по 5 классу точности ГОСТ 2689-54, не более 2 мм.
4. Допускаются гофры от гибки по эталону.
5. Покрытие Ан. Окс. хр.
6. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ I.

Лев. элемент
 Сред. элемент
 Прав. элемент
 Изм. и дата
 Подп. и дата
 Проверка
 Изм. и дата
 Проверка

				АК-630М 03-6		
				Уголок		
				Ангибар		
Изм./Лист	№ докум.	Подп.	Дата	Лит.	Масса	Шкала
Разраб.				А	0,900	1:5
Проб.				Лист / Листов I		
Т.контр.				Sheet / Total Sheets		
И.контр.				Profile AMg6 410808		
Утв.				ГОСТ 8617-81 ГОСТ 17738-91		
				ГОСТ 17738-91		
				Формат А4х3		

AK-630M 03-7

Rz80 (✓)



1. Material - substitute : Sheet AMg6 M 2 GOST 21631-76.
2. * - Dimension for reference.
3. Blur the sharp edges - 0.4 mm.
4. Coating: An. Ox. chrome.
5. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

1. Материал-заменитель - Лист АМг6 М-2 ГОСТ 21631-76.
2. * Размер для справок.
3. Острые ребра притупить ≈ 0,4 мм.
4. Покрытие Ан. Окс. хр.
5. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ I.

Изм. Подл. и дата
 Взам. Инв.
 Подл. и дата
 Слово И
 Прев. пр. Инв.

AK-630M 03-7				AK-630M 03-7		
				Type	Mass	Scale
Rear Wall				Лит.	Масса	Масштаб
Стенка задняя				A	4,570	1:2
Sheet AMg6 M-2				Лист / Листов 1		
Лист АМг6 М-2 ГОСТ 21631-76				Sheet / Total Sheets		
GOST 21631-76				Формат А4х3		

AK-630M 03-11

11-00 W 0059-2N

Левый край

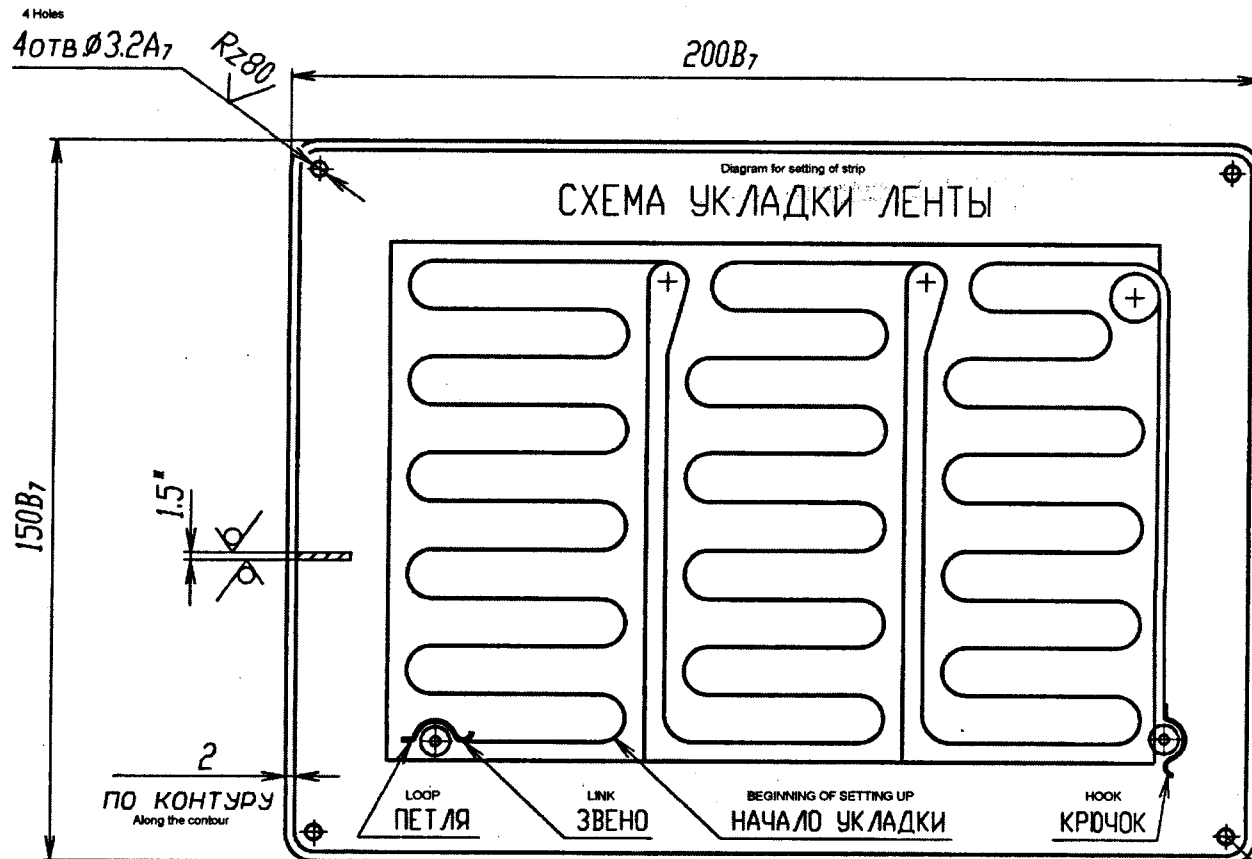
Сторона

Подп. и дата

Взам. инв. №

Подп. и дата

Инв. № подл.



1. Material - substitute : Sheet D1AM-P-1.0 GOST 21631-76.
or Sheet AD1-P-1.5 GOST 21631-76.
2. "-" - Dimension for reference.
3. Make the markings, inscriptions, centers of holes of the plate as per the scale of given drawing by photochemical method with deep etching.
4. Depth of etching is not less than 0.3 mm.
5. Make the inscriptions with font PO-5 GOST 2930-62.
6. Blur the sharp edges - 0.4 mm.
7. Change of one of the overall dimensions within the limits of ± 5 mm is permitted.
8. Coating: An. Ox. chrome.
9. Marking and letters - Enamel EP-51, black GOST 9640-85, (2), IV, OM2.
9. Mark Ш, Ч and stamp К on the tag.
10. Background of facing surface is the metal colour.
- Inscriptions and lines - in black colour. External view of surface as per test specimen.

Rz320
✓ (✓)

1. Материал-заменитель - лист Д1АМ-П-1,0 ГОСТ 21631-76 или лист АД1-П-1,5 ГОСТ 21631-76.
 2. " - Размер для справок.
 3. Рисунок, надписи, центры отверстий пластины выполнять по масштабам данного чертежа фотохимическим способом с глубоким травлением.
 4. Глубина травления не менее 0,3 мм.
 5. Надписи выполнять шрифтом ПО-5 ГОСТ 2930-62.
 6. Острые ребра притупить $\approx 0,4$ мм.
 7. Допускается изменение одного из габаритных размеров в пределах ± 5 мм.
 8. Покрытие Ан. Окс. хр.
 9. Рисунок и буквы - эмаль ЭП-51, черная ГОСТ 9640-85, (2), IV, OM2.
 9. Маркировать Ш, Ч и клеймить К на бирке.
 10. Фон лицевой поверхности цвета металла. Надписи и линии - черного цвета.
- Внешний вид поверхности по контрольному образцу.

R6
4 радиуса

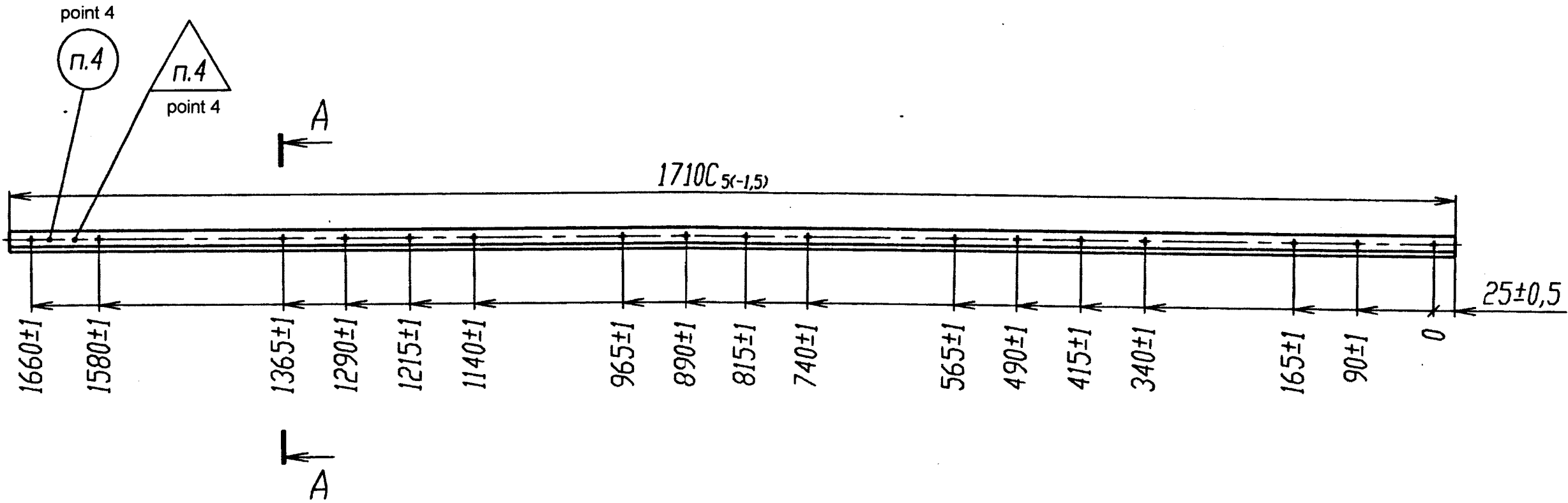
AK-630M 03-11

AK-630M 03-11				AK-630M 03-11		
				Type	Mass	Scale
Изм/Лист	№ докум.	Подп.	Дата	Лит.	Масса	Масштаб
Разраб.				А	0,170	1:1
Проб.				Лист	Листов 1	
Т.контр.				Sheet	Total Sheets	
Н.контр.				Лист AMg6 BM-1,5 ГОСТ 21631-76		
Утв.				Sheet Total Sheets		

Формат А4х3

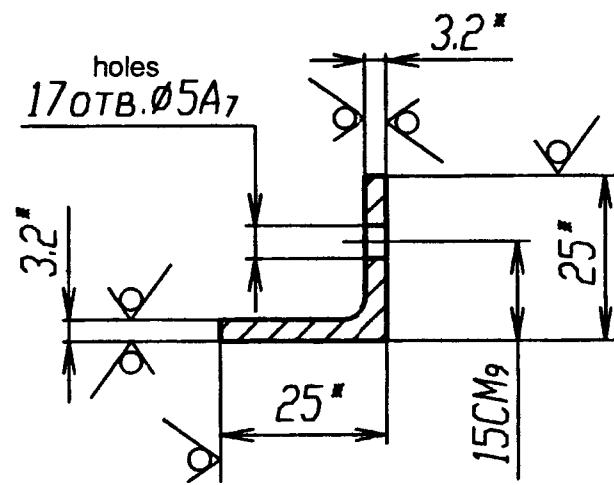
29

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



- 1.* Reference dimension.
- 2. Blunt sharp edges ~ 0.4 mm.
- 3.Coating Anodic Oxi.Cr.
- 4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

A-A (1:1)



Comment [53]:

					AK-630M 03-3			
Amend	Sheet	Doc.No.	Sign	Date	Support	Type	Weight	Scale
Developed by						A	0.675	1:5
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Profile AMg6 410062 $\frac{GOST8617 - 81}{GOST13737 - 90}$			
Approved by								

Rz80

First use

Reference No.

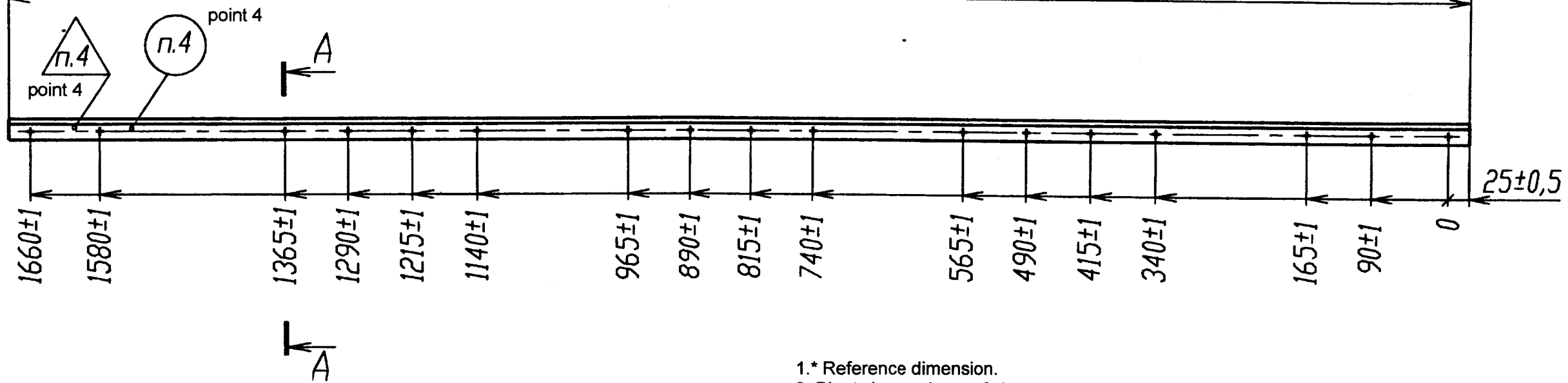
Duplicate Inv. No | Sign and Date

Alternate No

Sign and Date

Orig. inv. no.

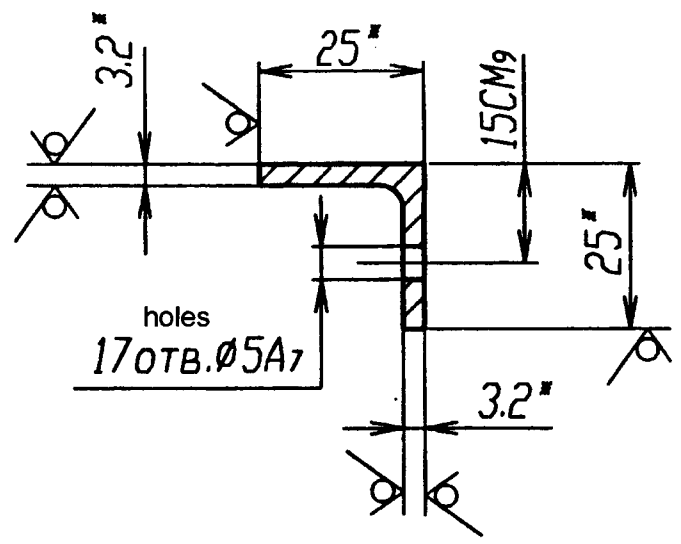
1710C_{5(-1,5)}



- 1.* Reference dimension.
2. Blunt sharp edges ~ 0.4 mm.
- 3.Coating Anodic Oxi.Cr.
4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

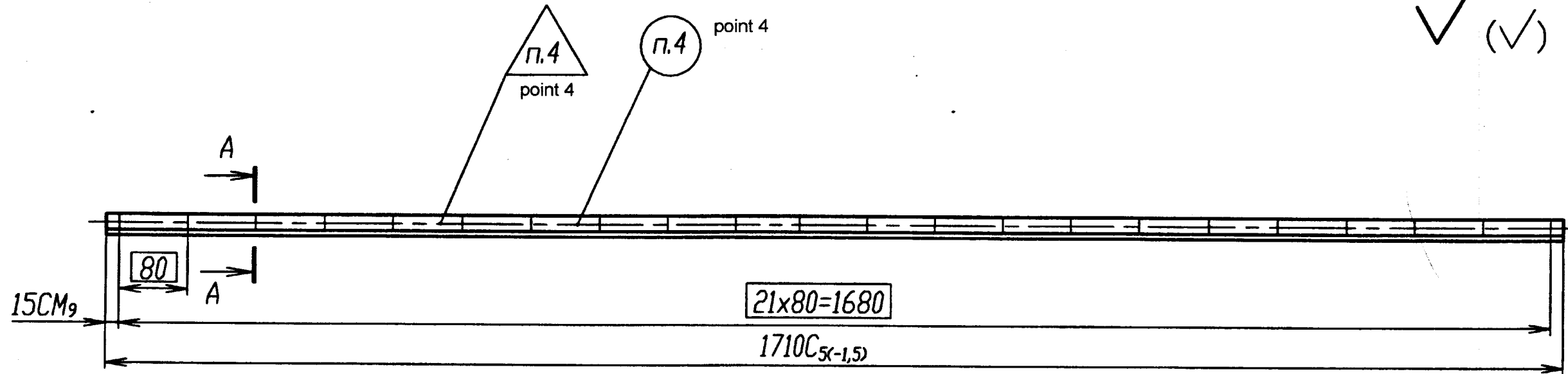
Comment [54]:

A-A (1:1)



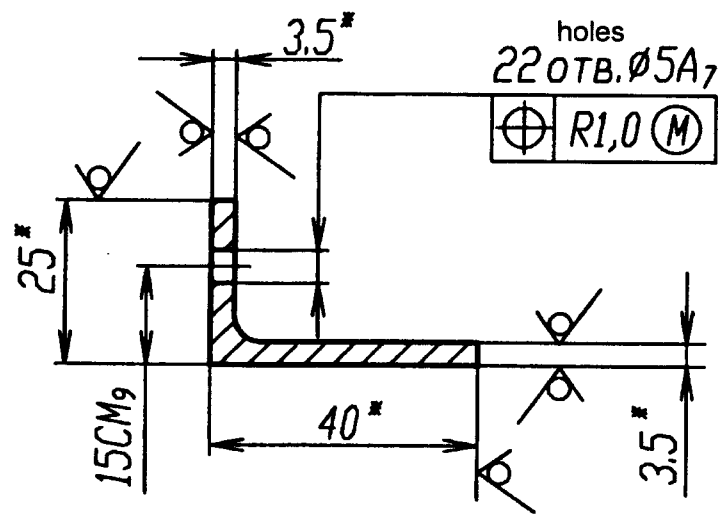
					AK-630M 03-4			
Amend	Sheet	Doc.No.	Sign	Date	Support	Type	Weight	Scale
Developed by						A	0.695	1:5
Checked by						Sheet	Sheets	1
Head of Q.C.D					Profile AMg6 410062			
Approved by								

Rz80 (✓)



- 1.* Reference dimension.
- 2. Blunt sharp edges ~0.4 mm.
- 3. Coating Anodic Oxid.Cr.
- 4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

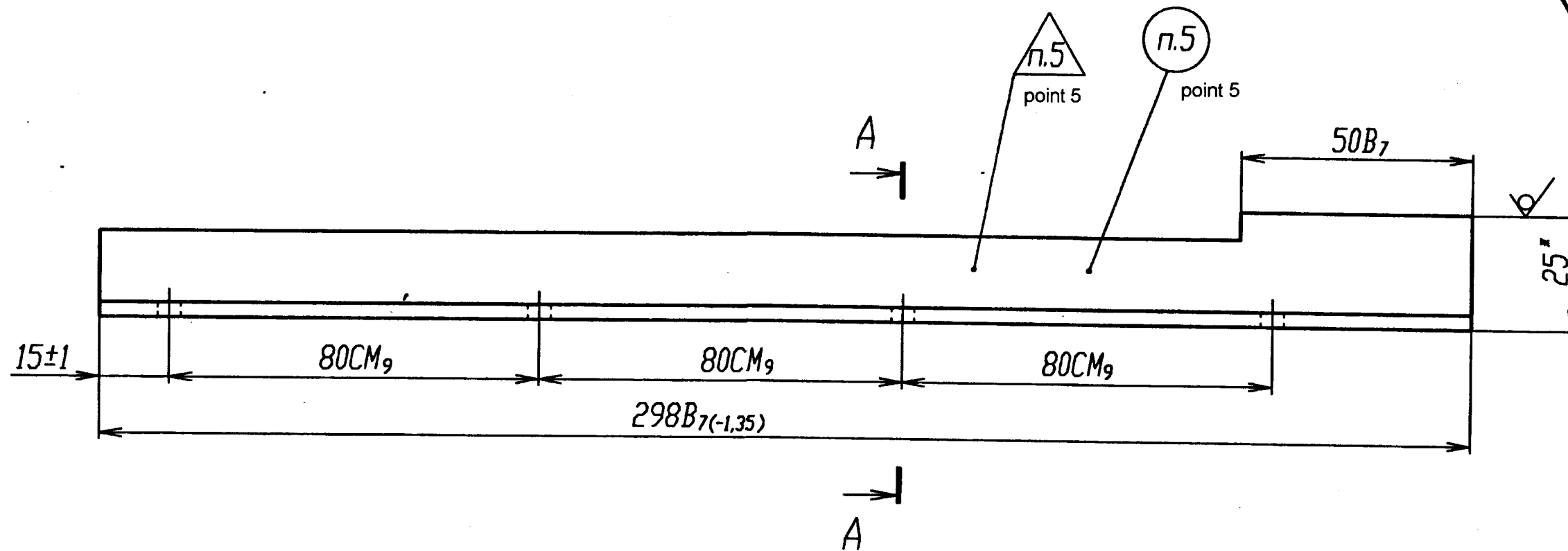
A-A (1:1)



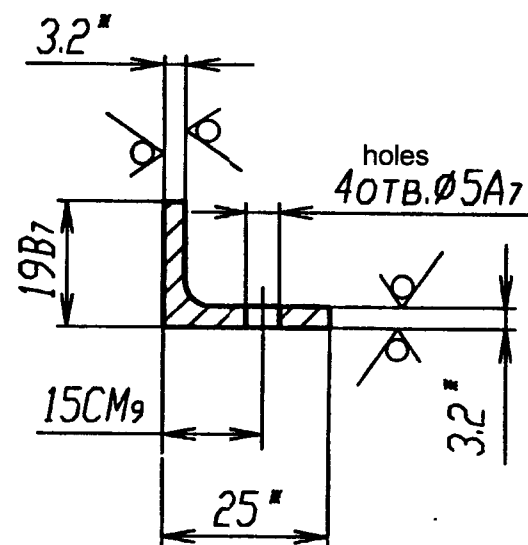
Comment [56]:

					AK-630M 03-10			
Amend	Sheet	Doc.No.	Sign	Date	Support	Type	Weight	Scale
Developed by						A	0.680	1:5
Checked by						Sheet	Sheets	1
Head of Q.C.D					Profile AMg6 410808	GOST8617 - 81		
Approved by						GOST13738 - 91		

Rz80 (✓)



A-A



1. * Reference dimensions.
2. Inner angles R~0.4 mm.
3. Blunt sharp edges ~0.4 mm.
4. Coating Anodic Oxid.Cr.
5. Mark Ш,Ч and stamp K as per AK-630, AK-630M TU I.

Comment [57]:

					AK-630M 03-12				
Amend	Sheet	Doc.No.	Sign	Date	Angle piece	Type	Weight	Scale	
Developed by						A	0.110	1:1	
Checked by						Sheet	Sheets 1		
Head of Q.C.D					Angle AMg6 410062 $\frac{GOST8617 - 81}{GOST13738 - 91}$				
Approved by									

First use

Reference No.

Sign and Date

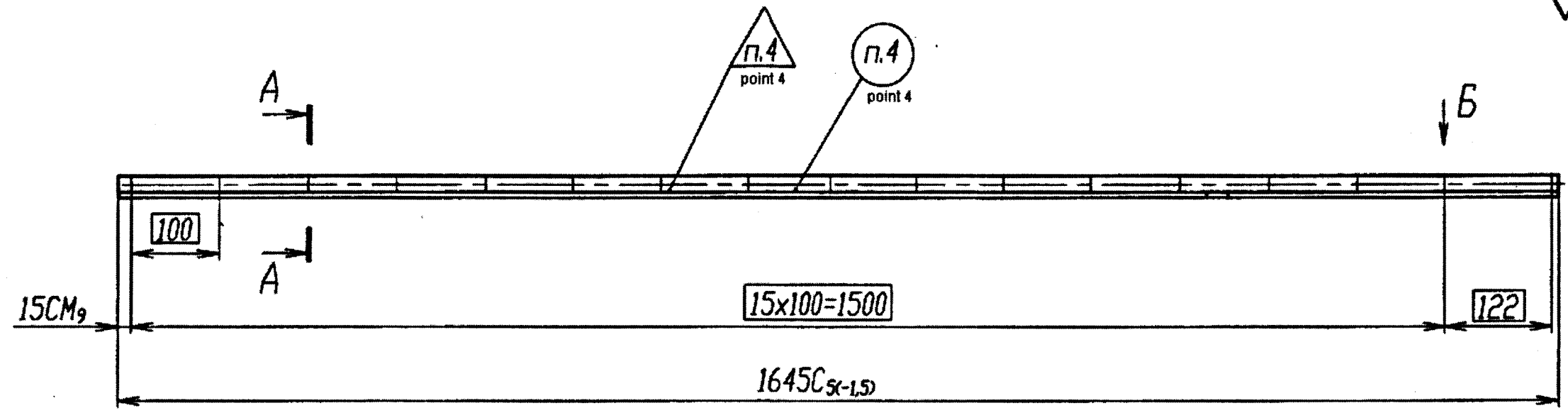
Duplicate Inv. No

Alternate No

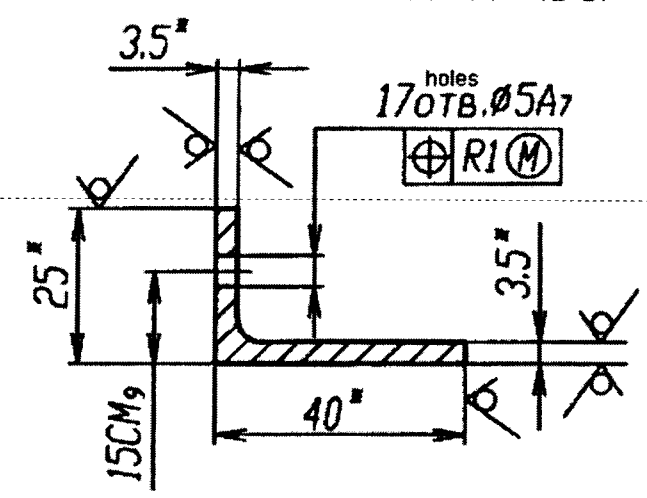
Sign and Date

Orig. inv. no.

Rz80 ✓ (✓)

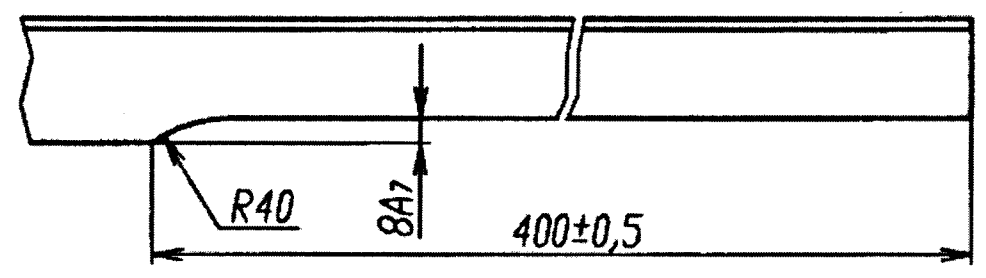


A-A (1:1)



- 1.* Reference dimensions.
2. Blunt sharp edges ~0.4 mm.
3. Coating Anodic Oxid.Cr.
4. Mark Ш,Ч and stamp K as per AK-630, AK-630M TU I.

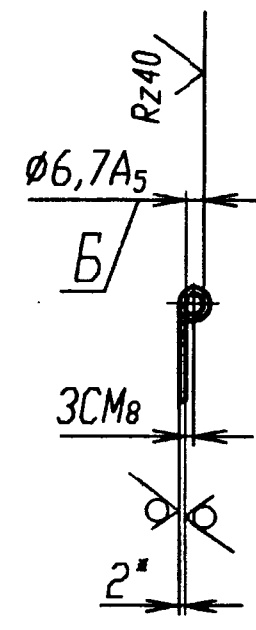
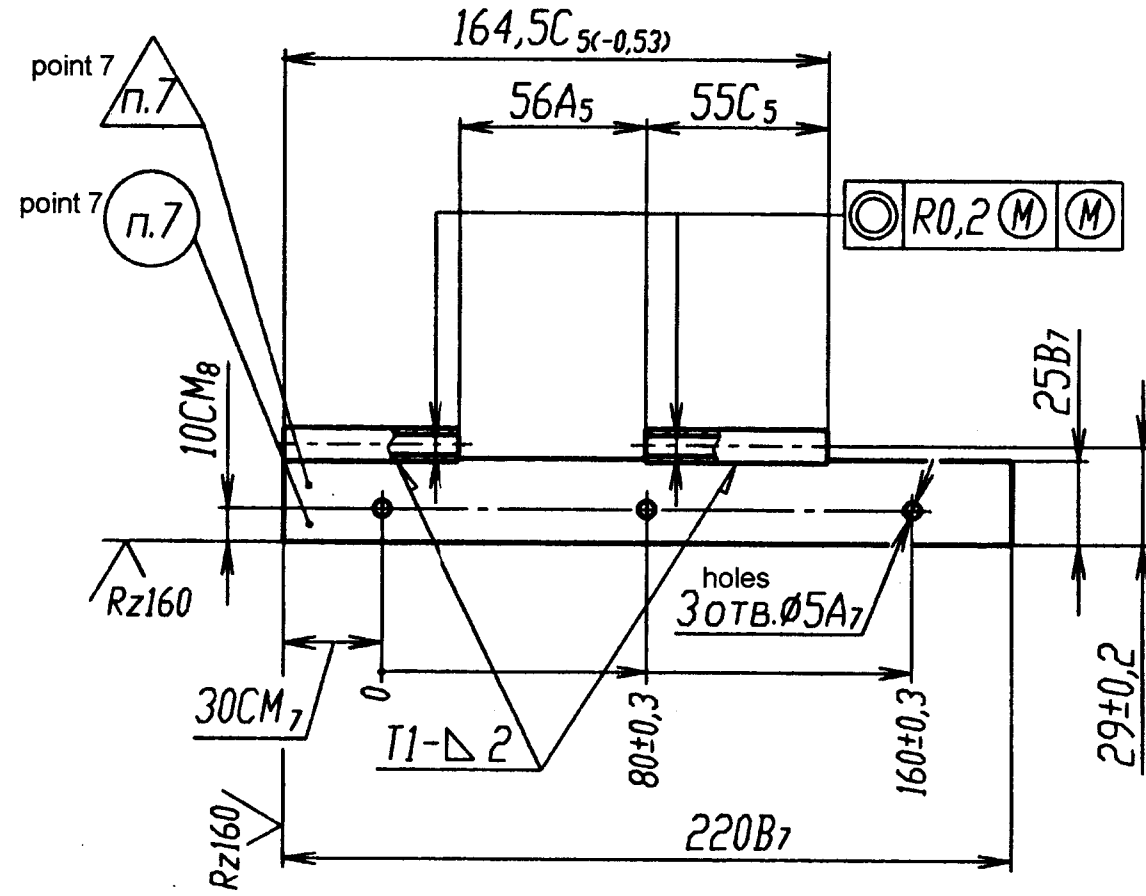
Б (1:2)



Comment [58]:

					AK-630M 03-15			
Amend	Sheet	Doc.No.	Sign	Date	Support	Type	Weight	Scale
Developed by						A	0.915	1:5
Checked by						Sheet	Sheets	1
Head of Q.C.D					Profile AMg6 410808	GOST8617 - 81		
Approved by						GOST13738 - 91		

Rz80
✓ (✓)



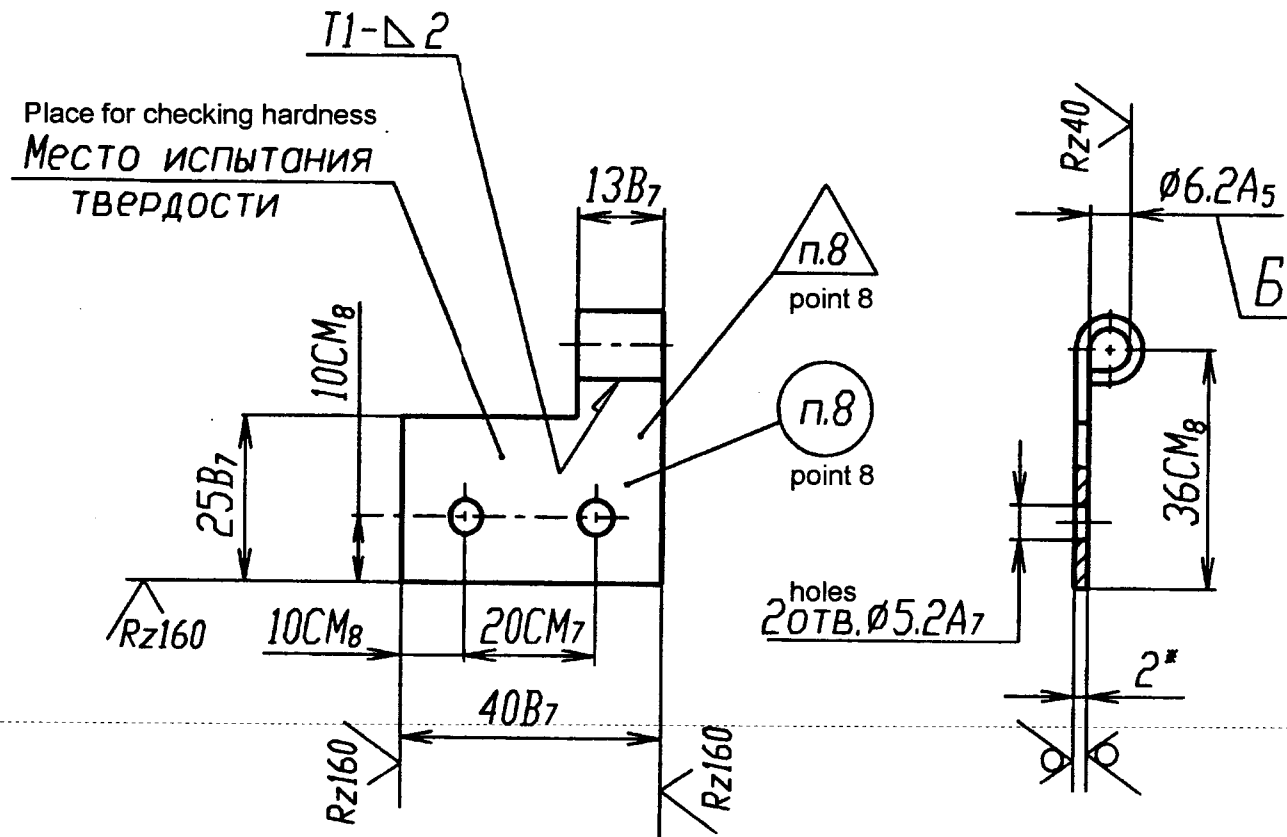
1. Make welding joints as per GOST 14771-76-UP by using filler wire 1.2 Sv – 08G2S GOST 2246-70. Welding seam category II as per OST 3-4001-91. Check 100% visually. It is permissible to make welding seams as per GOST 5264-80 by using welding rod UONI 13/45-2.0 GOST 5264-80 GOST 9466-75.
2. * Reference dimension.
3. Wall thickness not less than 1.5 mm while making dimension B.
4. Inner angles R~0.4 mm.
5. Blunt sharp edges ~0.4 mm.
6. Coating: Cd12.phos.
7. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

Comment [S9]:

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

					AK-630M 03-21			
Amend.	Sheet	Doc.No.	Sign	Date	Loop	Type	Weight	Scale
Developed by						A	0.195	1:2
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Sheet <i>BT - PN - 0 - 2GOST19904 - 90</i> <i>K390V4 - III - 25GOST16523 - 97</i>			
Approved by								

Rz80
 ✓ (✓)



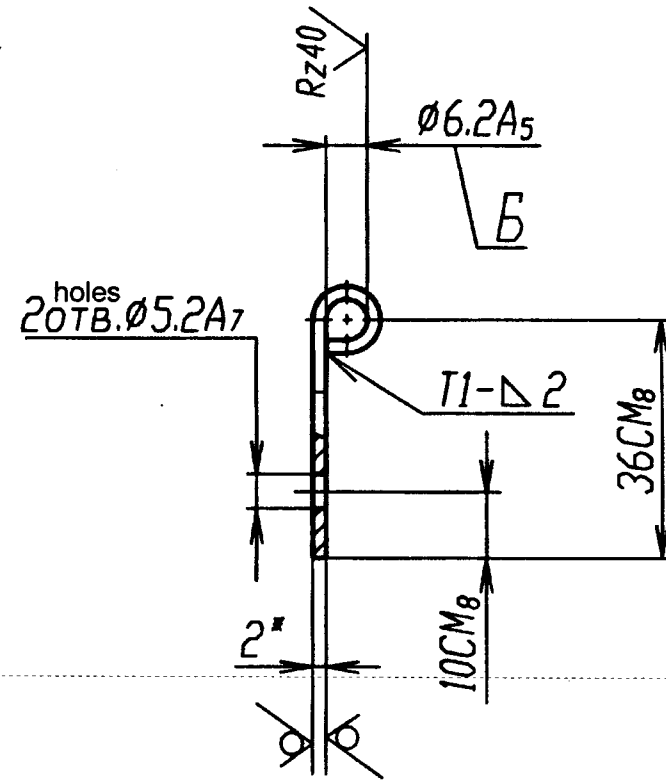
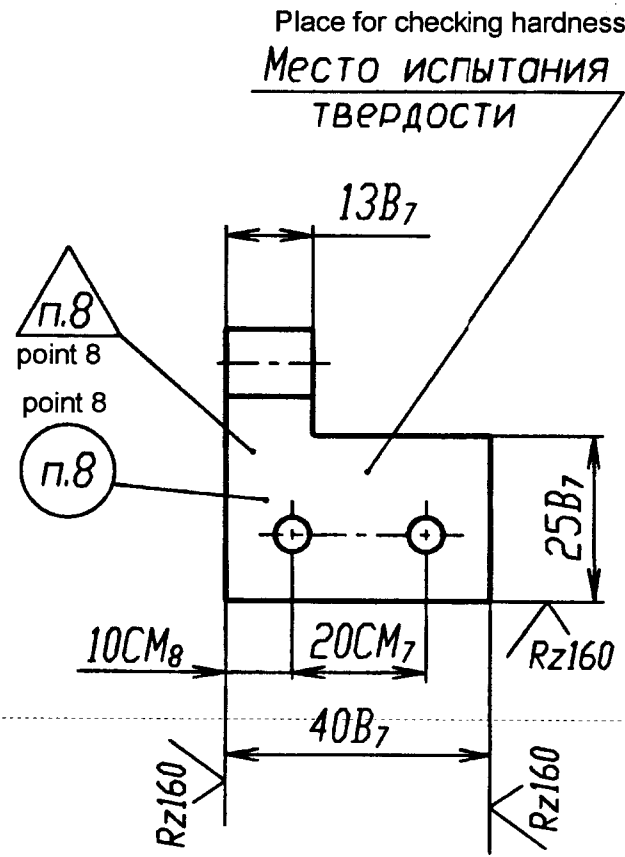
1. Make welding joints as per GOST 14771-76-UP by using filler wire 1.2 Sv -08G2S GOST 2246-70. Welding seam category II as per OST 3-4001-91. Check 100% visually. It is permissible to make welding seams as per GOST 5264-80 by using welding rod UONII 13/45-2.0 GOST 5264-80 GOST 9466-75.
2. 34...39.5 HRC_E.
- 3.* Reference dimension.
4. Wall thickness not less than 1.5 mm while making dimension B.
5. Inner angles R~0.4 mm.
6. Blunt sharp edges ~0.4 mm.
7. Coating: Cd12.phos.
8. Mark Ш, Ч and stamp K, И as per AK-630, AK-630M TU I.

Comment [S10]:

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

					AK-630M 03-23			
Amend.	Sheet	Doc.No.	Sign	Date	Loop	Type	Weight	Scale
Developed by						A	0.035	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Sheet <i>BT - PN - 0 - 2GOST19904 - 90</i> <i>K490V4 - III - 35GOST16523 - 97</i>			
Approved by								

Rz80
✓(✓)

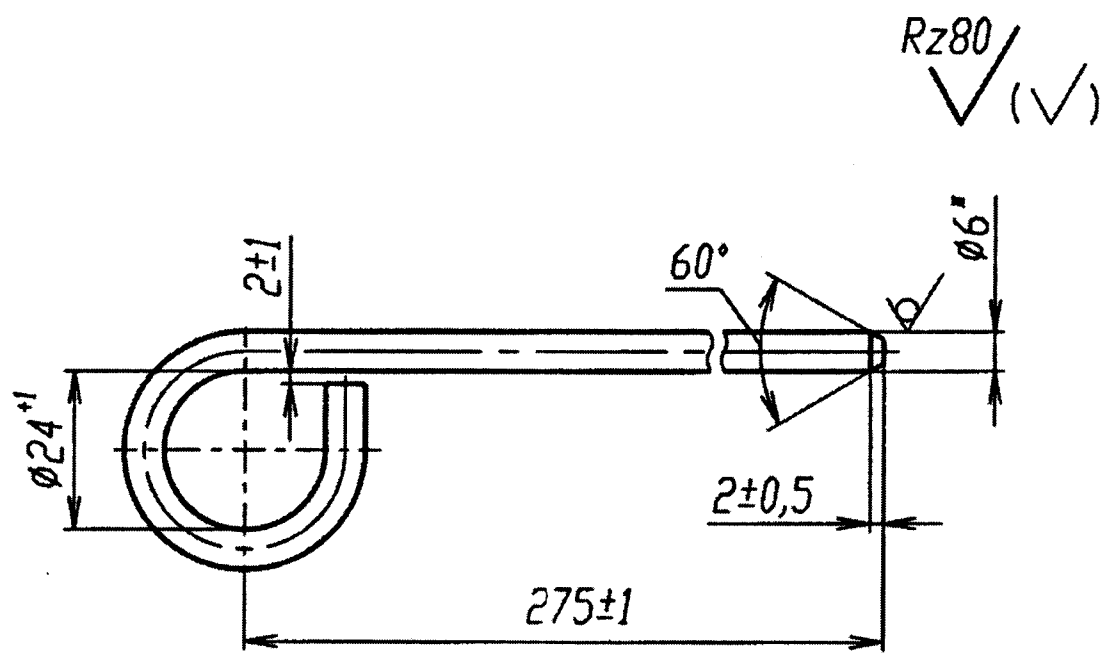


1. Make welding joints as per GOST 14771-76-UP by using filler wire 1.2 Sv -08G2S GOST 2246-70. Welding seam category II as per OST 3-4001-91. Check 100% visually. It is permissible to make welding seams as per GOST 5264-80 by using welding rod UONII 13/45-2.0 GOST 9466-75.
2. 34...39.5 HRC_E.
3. * Reference dimension.
4. Wall thickness not less than 1.5 mm while making dimension Б.
5. Inner angles R~0.4 mm.
6. Blunt sharp edges ~0.4 mm.
7. Coating: Cd12.phos.
8. Mark Ш, Ч and stamp К, И as per AK-630, AK-630M TU I.

Comment [S11]:

					AK-630M 03-24			
Amend.	Sheet	Doc.No.	Sign	Date	Loop	Type	Weight	Scale
Developed by						A	0.035	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Sheet $\frac{BT - PN - 0 - 2GOST19904 - 90}{K 490V 4 - III - 35GOST16523 - 97}$			
Approved by								

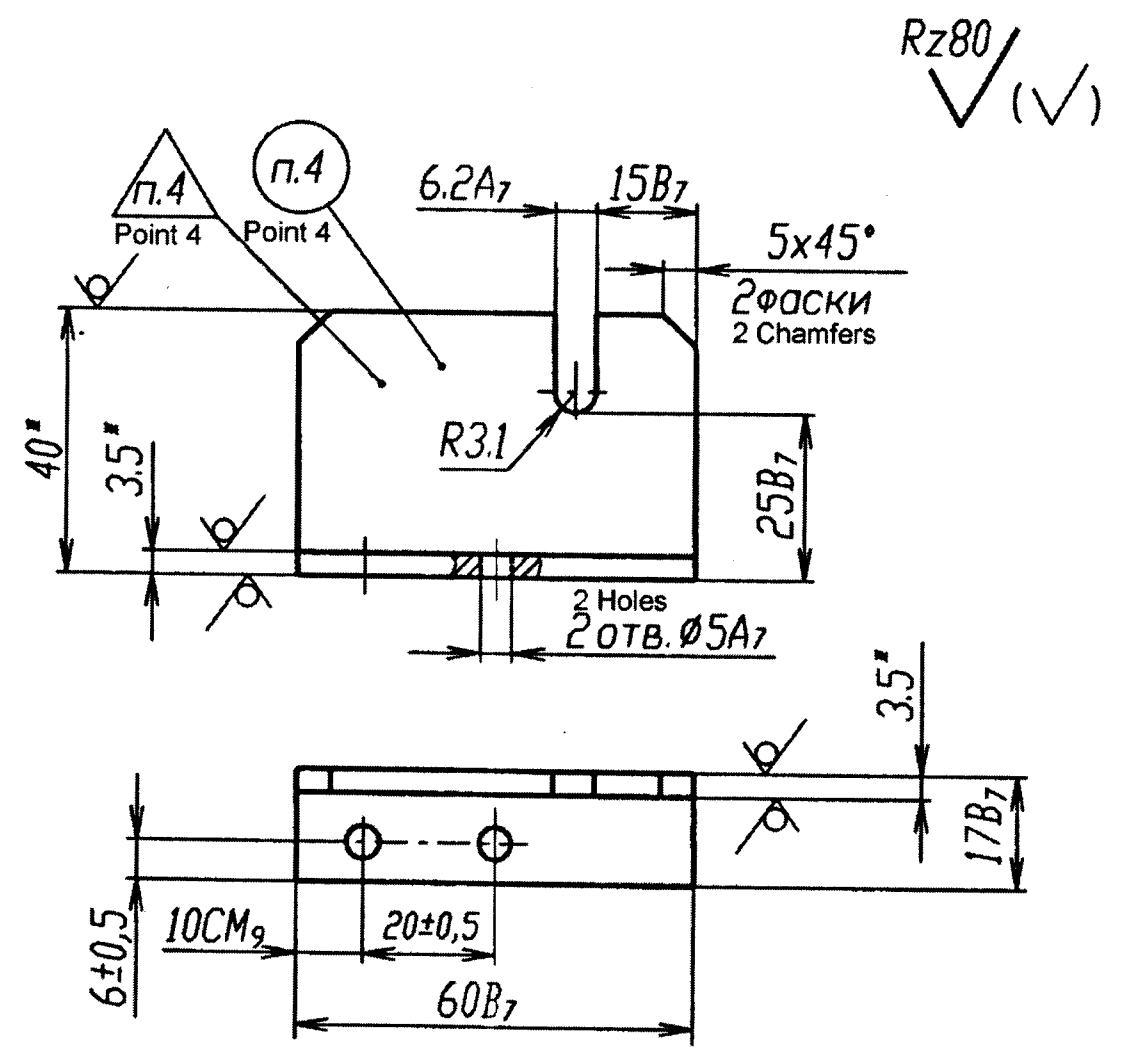
AK-630M 03-17					
Approved OGMet	Approved TOsb	Approved KTONI	Approved by shop	First use	
Orig. Inv. No.	Alternate Inv. No.	Sign and Date	Dupl. Inv. No.	Sign and Date	Reference No.
		AK-630M 03-17			
Amend.	Sheet	Doc. No.	Sign	Date	
Developed by					
Checked by					
Head of Q.C.D					
Design chief					
Head of Q.C.D					
Approved by					
		Pin		Type A	Weight 0.065
				Scale 1:1	
				Sheet	Sheets 1
		Round bar $\frac{6-h11GOST7417-75}{40-T-8GOST1051-73}$			



1. 34..39.5 HRC_E .Check on specimen.
- 2..* Reference dimension .
- 3.Blunt sharp edges ≈ 0.4 mm.
- 4.Coating Cd12.phos.Oil.
- 5.Mark Ш, Ч and stamp K, И on tag.

AK-630M 03-18

Approved OGMet	Sign and Date	Approved TOSb	Approved KTONI	Approved by shop	First use
Orig. Inv. No.	Sign and Date	Alternate Inv. No.	Sign and Date	Reference No.	

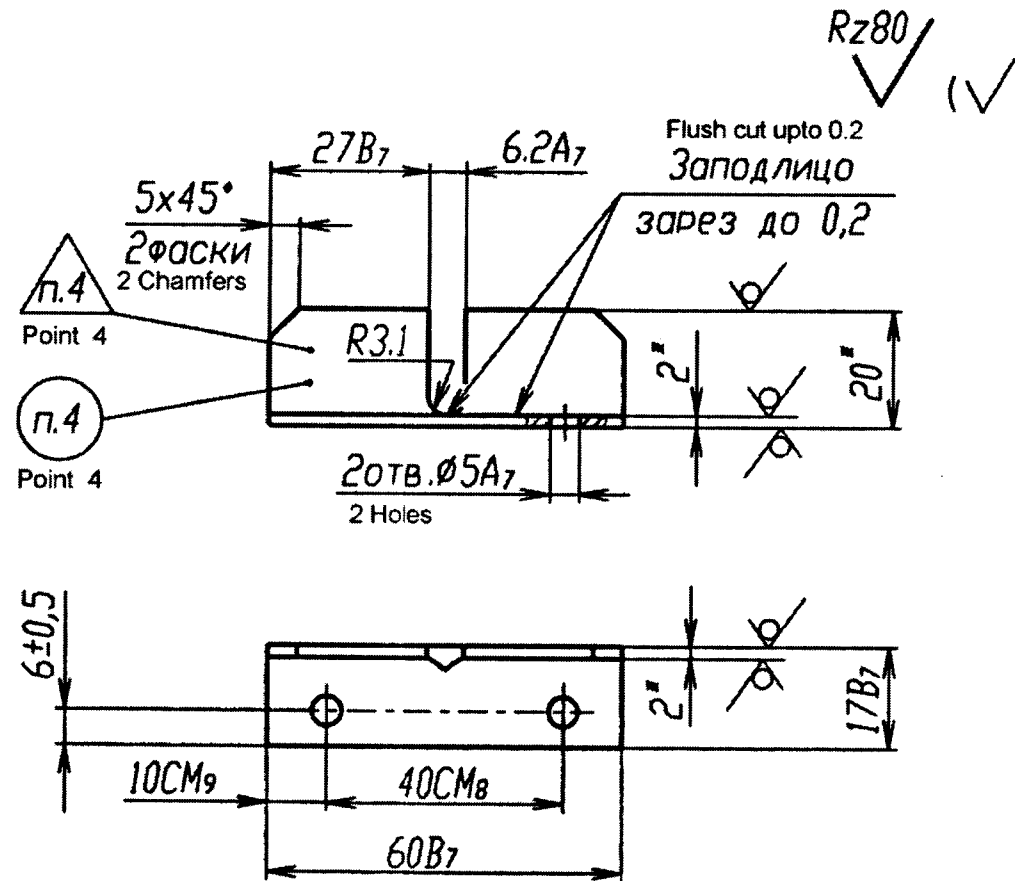


- 1.* Reference dimensions.
- 2.Blunt sharp edges ≈ 0.4 mm.
- 3.Coating Anodic Oxi.Cr.
- 4.Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630M 03-18			
Amend.	Sheet	Doc. No.	Sign	Date	Elbow	Type	Weight	Scale
Developed by						A	0.035	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D						Profile AMg6 410808 $\frac{GOST8617-81}{GOST17738-91}$		
Head of Q.C.D								
Approved by								

AK-630M 03-19

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.



- 1.* Reference dimension.
- 2. Blunt sharp edges ≈ 0.4 mm.
- 3. Coating Anodic Oxid. Cr.
- 4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

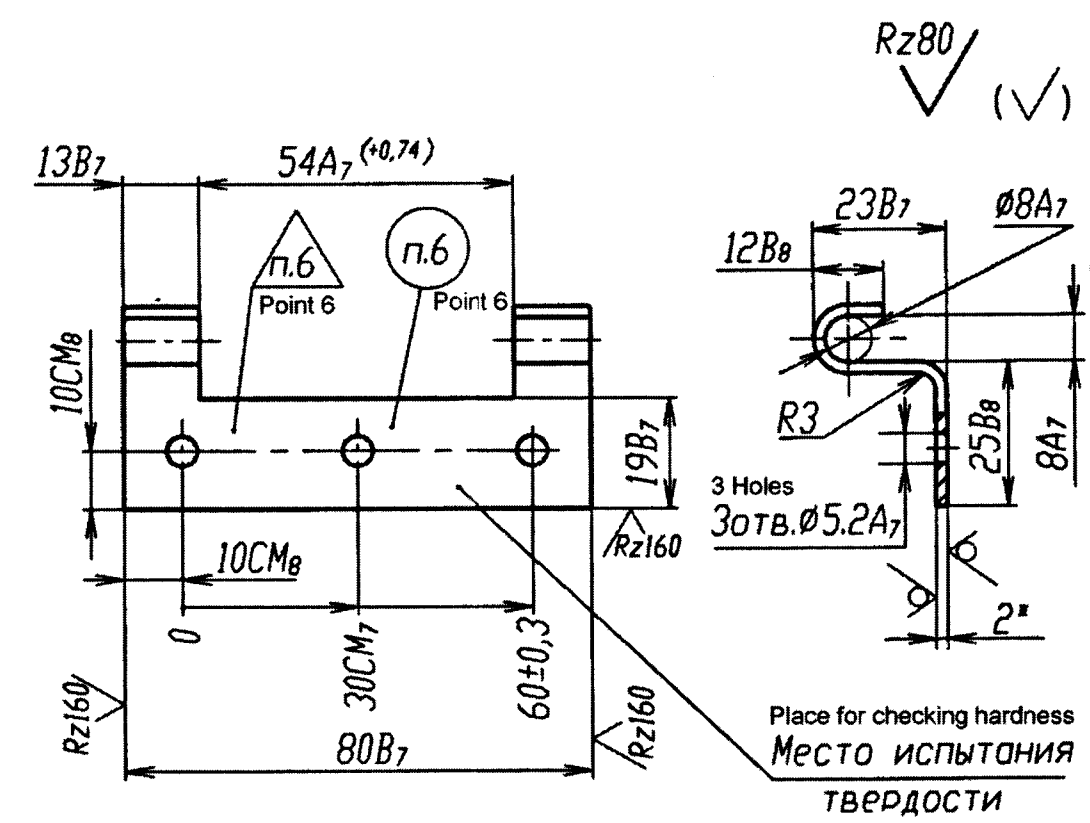
Amend.	Sheet	Doc. No.	Sign	Date

AK-630M 03-19

Stop

Type	Weight	Scale
A	0.01	1:1
Sheet		Sheets 1

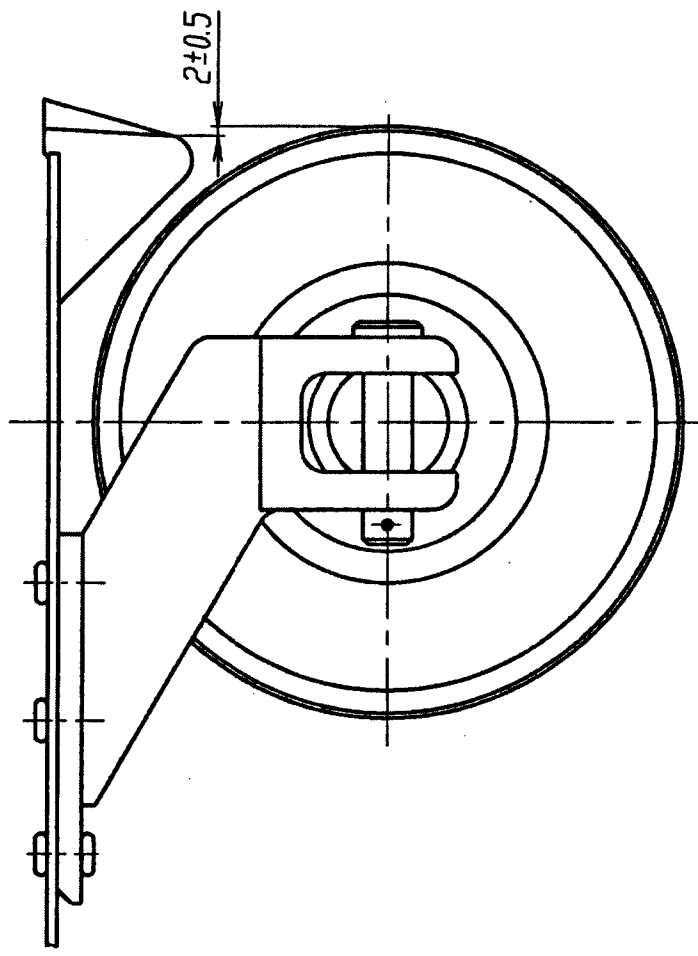
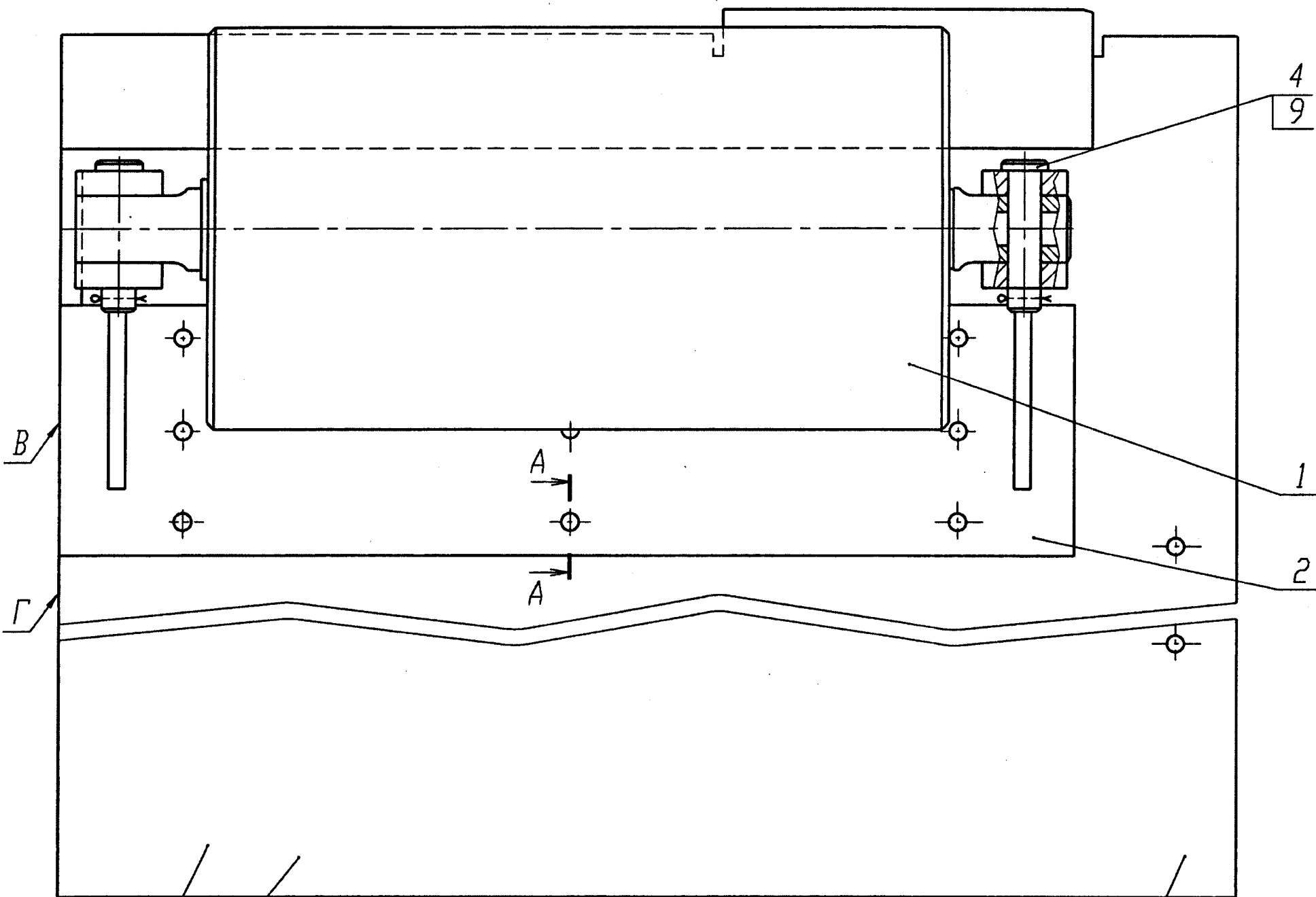
Profile AMg6 410040 $\frac{GOST8617 - 81}{GOST13737 - 90}$

AK-630M 03-22		Approved by shop Reference No.	First use
 <p style="text-align: center;">Place for checking hardness Место испытания ТВЕРДОСТИ</p>			
<p>1. 34..39.5 HRC_E .</p> <p>2..* Reference dimension .</p> <p>3.Inner angles R ≈ 0.4 mm.</p> <p>4.Blunt sharp edges ≈ 0.4 mm.</p> <p>5. Coating Cd 12.Phos.</p> <p>6.Mark Ш, Ч and stamp K, И as per AK-630, AK-630M TU I.</p>			
AK-630M 03-22			
		Type	Weight
		A	0.06
		Scale	1:1
		Sheet	Sheets 1
Sheet <u>BT - PN - 02 GOST19904 - 90</u> <u>K490V 4 - III - 35 GOST16523 - 97</u>			

Copied by

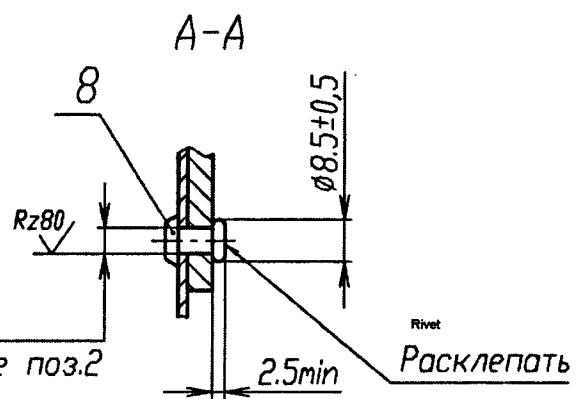
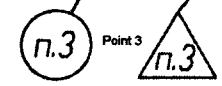
Format A4

First use	Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A2			AK-630M Sb 03-3 SB	Assembly drawing			
					<u>Assembly units</u>			
	A4		1	AK-630M Sb 03-6	Hose	1		
	A4		2	AK-630M Sb 03-9	Bracket	1		
	A4		3	AK-630M Sb 03-14	Partition	1		
					<u>Components</u>			
	A4		4	AK-630M 03-36	Collar pin	2		
					<u>Standard articles</u>			
			8		Rivet 8 x 18.31.10	9		
Sign and Date					GOST 10303-80			
			9		Cotter pin 2x16.029	2		
					GOST 397-79			
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date					AK-630M Sb 03-3			
	Amend.	Sheet	Doc. No.	Sign	Date			
Orig. Inv. No.	Developed by					Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D					Front wall		
	Approved by							



1. Dimensions are to be ensured by tool.
 2. Non-coincidence of planes B and Г is not more than 0.3 mm.
 3. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU 1.

1. Размеры обеспеч. INSTR.
 2. Несовпадение плоскостей В и Г не более 0,3 мм.
 3. Маркировать Ш, Ч, и клеймить К по АК-630, АК-630М ТУ 1.



9 Holes
 9 отв. Ø5,2A7
 Сверлить через отв. в кронштейне поз.2
 Drill through the hole on bracket pos. 2.

AK-630M СБ03-ЗСБ

			Type	Mass	Scale
Изм/Лист	№ докум.	Подп.	Дата	Лист	Масса
Разроб.				A	9,820
Пров.					1:1
Т.контр.				Лист	Листов 1
Н.контр.				Sheet	Total Sheets
Утв.					

Front wall
 Assembly drawing.

AK-630M 03-36					
Approved by shop	Reference No.				
Approved KTONI	Sign and Date				
Approved TOsb	Dupl. Inv. No.	<p>Place for checking hardness Место испытания твердости</p> <p>1. 31..40.5 HRC_E. 2. * Reference dimension . 3. Inner angles R ≈ 0.4 mm. 4. Coating: Cd9.phos.Oil. 5. Mark Ш, Ч and stamp K , И on tag.</p>			
Alternate Inv. No.	Sign and Date				
Approved OGMet	Orig. Inv. No.	AK-630M 03-36		Pin	
Amend. Sheet Doc. No. Sign Date		Type Weight Scale		A 0.028 1:1	
Developed by		Sheet		Sheets 1	
Checked by		Round bar $\frac{14 - V GOST 2590 - 88}{40Kh - 3 - T GOST 4543 - 71}$			
Head of Q.C.D					
Design chief					
Head of Q.C.D					
Approved by					

Copied by

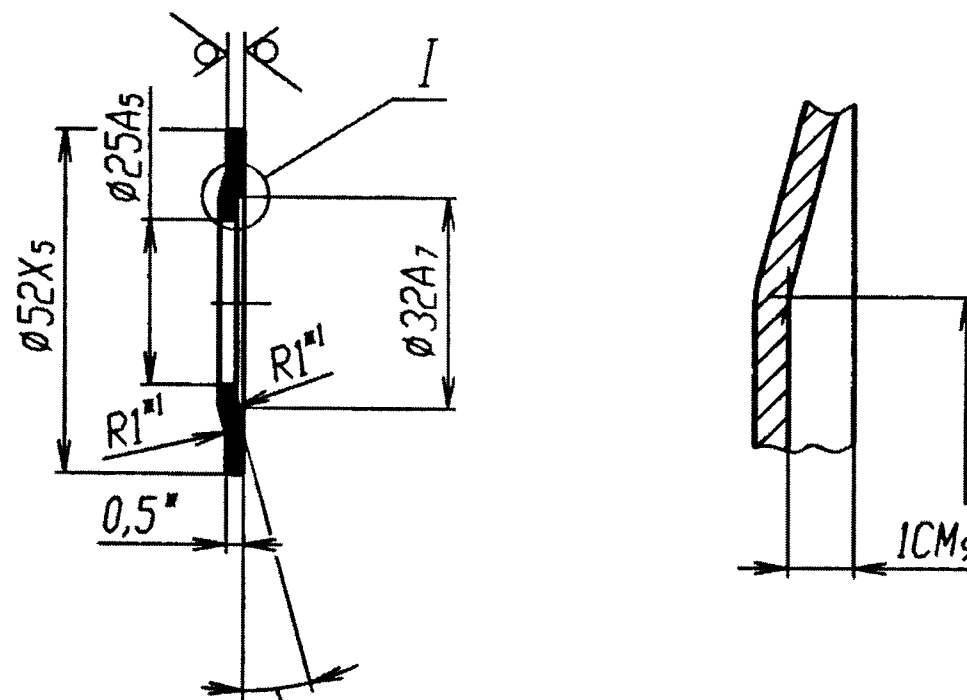
Format A4

AK-630M 03-38

Approved OGMet Orig. Inv. No.	Sign and Date	Approved TOsb Alternate Inv. No.	Dupl. Inv. No.	Sign and Date	Approved KTONI	Reference No.	Approved by shop	First use										
Amend.	Sheet	Doc. No.	Sign	Date	<p style="text-align: center;">AK-630M 03-38</p> <table border="1"> <tr> <td rowspan="3" style="text-align: center;">Washer</td> <td>Type</td> <td>Weight</td> <td>Scale</td> </tr> <tr> <td>A</td> <td>0.010</td> <td>1:1</td> </tr> <tr> <td>Sheet</td> <td colspan="2">Sheets 1</td> </tr> </table> <p>Sheet <u>BT - PN - 00.5 GOST 19904 - 90</u> <u>K 490V 4 - III - 35 GOST 16523 - 97</u></p>				Washer	Type	Weight	Scale	A	0.010	1:1	Sheet	Sheets 1	
Washer	Type	Weight	Scale															
	A	0.010	1:1															
	Sheet	Sheets 1																
Developed by																		
Checked by																		
Head of Q.C.D																		
Design chief																		
Head of Q.C.D																		
Approved by																		

Rz80
✓(✓)

I (10:1)



1. 73..76 HR_{N15}. Check on specimen.
- 2..* Reference dimension .
- 3.*1 Dimensions ensured by tool
4. Coating Cd9.phos.Oil.
5. Mark Ш, Ч and stamp K, И on tag.

Copied by

Format A4

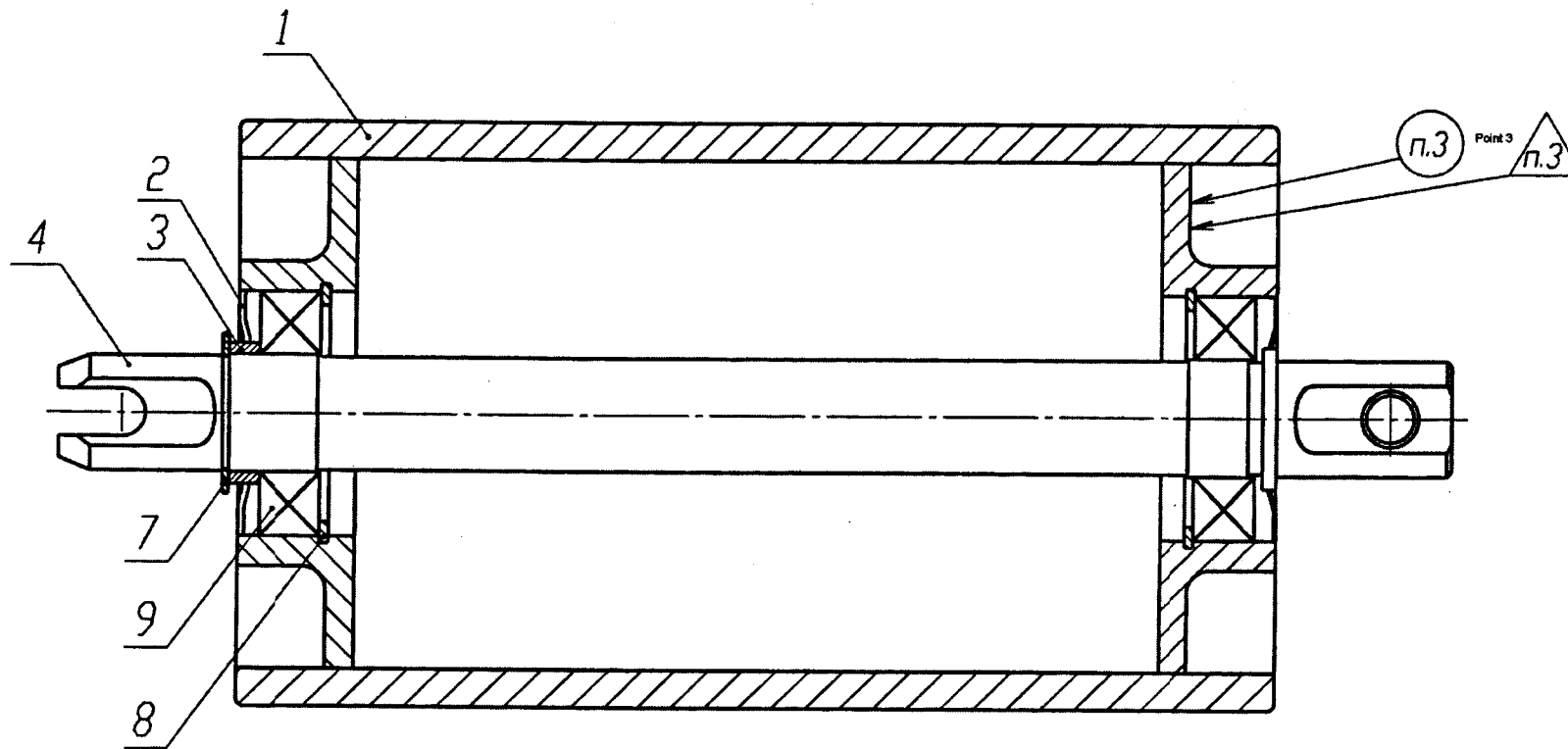
AK-630M 03-39																			
Approved by shop	Reference No.																		
Approved KTONI	Sign and Date																		
Approved TOsb	Dupl. Inv. No.	<p>1.* Reference dimension. 2.Coating Cd9.phos.Oil. 3.Mark Ш, Ч and stamp K on tag.</p>																	
Alternate Inv. No.	Sign and Date																		
Approved OGMet	Orig. Inv. No.	AK-630M 03-39																	
Amend.	Sheet	Doc. No.	Sign	Date	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td colspan="2" rowspan="2" style="text-align: center;">Ring</td> <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;">A</td> <td style="text-align: center;">0.004</td> <td style="text-align: center;">1:1</td> </tr> <tr> <td colspan="2"></td> <td style="text-align: center;">Sheet</td> <td colspan="2" style="text-align: center;">Sheets 1</td> </tr> </table>		Ring		Type	Weight	Scale	A	0.004	1:1			Sheet	Sheets 1	
Ring		Type	Weight	Scale															
		A	0.004	1:1															
		Sheet	Sheets 1																
Developed by																			
Checked by																			
Head of Q.C.D																			
Design chief																			
Head of Q.C.D					Pipe $\frac{30 \times 5 \text{ GOST } 8734 - 75}{V20 \text{ GOST } 8733 - 74}$														
Approved by																			

Copied by

Format A4

AK-630M СБ03-6СБ

AK - 630M Sb 03-6 SB



1. Roller pos. 1 should freely rotate on the axle pos. 4.
2. Fill the bearings pos. 9 with grease MS-70 GOST 9762-76.
3. Mark Ш, Ч and stamp К as per AK-630, AK-630M TU 1.

1. Ролик поз. 1 должен вращаться на оси поз. 4 свободно.
2. Подшипники поз. 9 заполнить смазкой МС-70 ГОСТ 9762-76.
3. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ 1.

AK - 630M Sb 03-6 SB

				AK-630M СБ03-6СБ		
				Ролик		
				Сборочный чертёж		
				Assembly drawing		
				Лист		
				Листов 1		
				Sheet		
				Total Sheets		
				Формат А4х3		

Перв. примен.

Спробов.

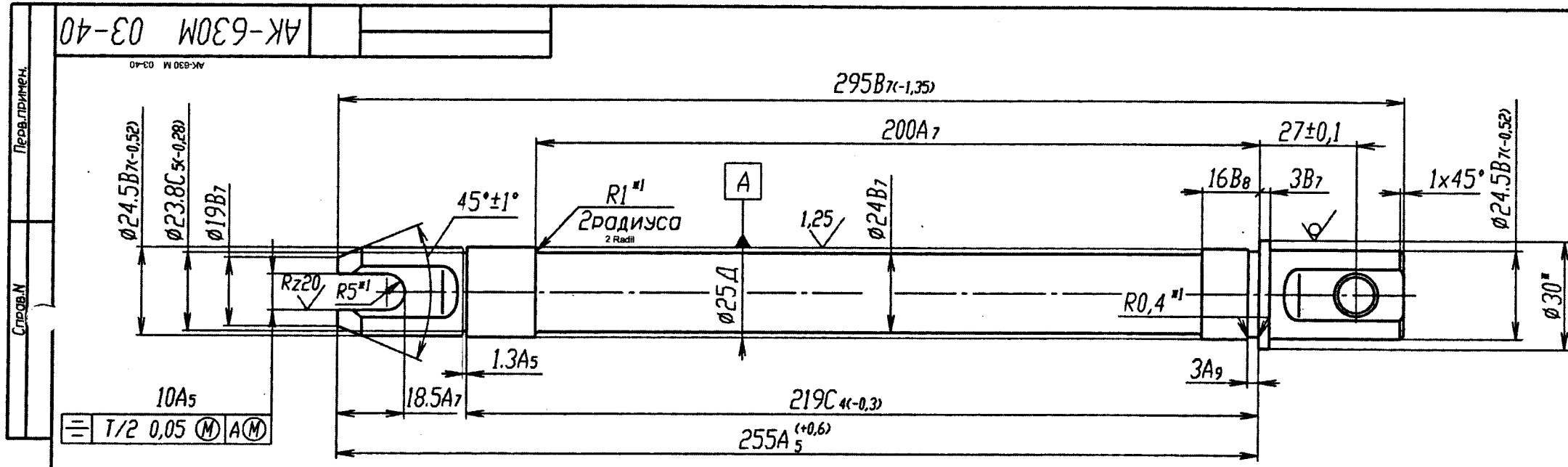
Подп. и дата

Изм. №

Возм. №

Подп. и дата

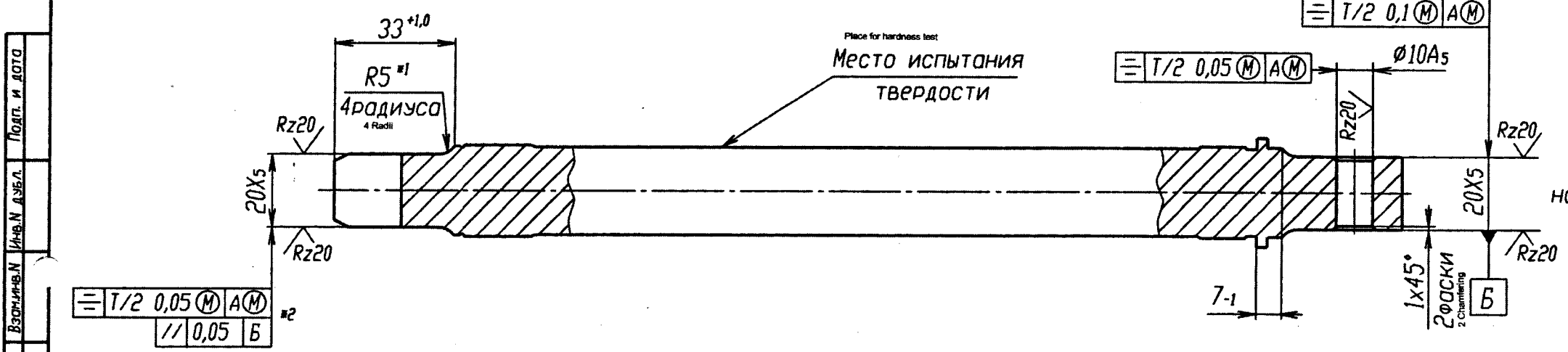
Изм. №



Rz40
 ✓ (✓)

1. Material - substitute - Steel 40 Kh GOST 4543-71.
2. 34...39,5 HRC₃.
3. * - Dimension for reference.
4. *1 - Dimension is ensured by tool.
5. *2 - Tolerance of symmetry is given only in transversal direction.
6. Internal angles R ~ 0,2 mm.
7. Coating Cad 9, phos. followed by oil treatment.
8. Mark Ш, Ч and stamp К, И on the tag.

1. Материал-заменитель - Сталь 40Х ГОСТ 4543-71.
2. 34...39,5 HRC₃.
3. * Размер для справок.
4. *1 Размер обеспечивается инструментом.
5. *2 Допуск симметричности задан только в поперечном направлении.
6. Внутренние углы R ~ 0,2 мм.
7. Покрытие Кд9, фос. прм.
8. Маркировать Ш, Ч и клеймить К, И на бирке.



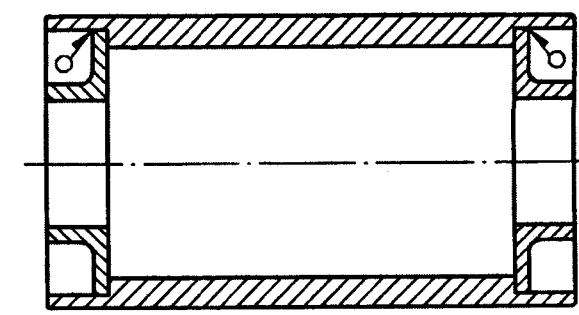
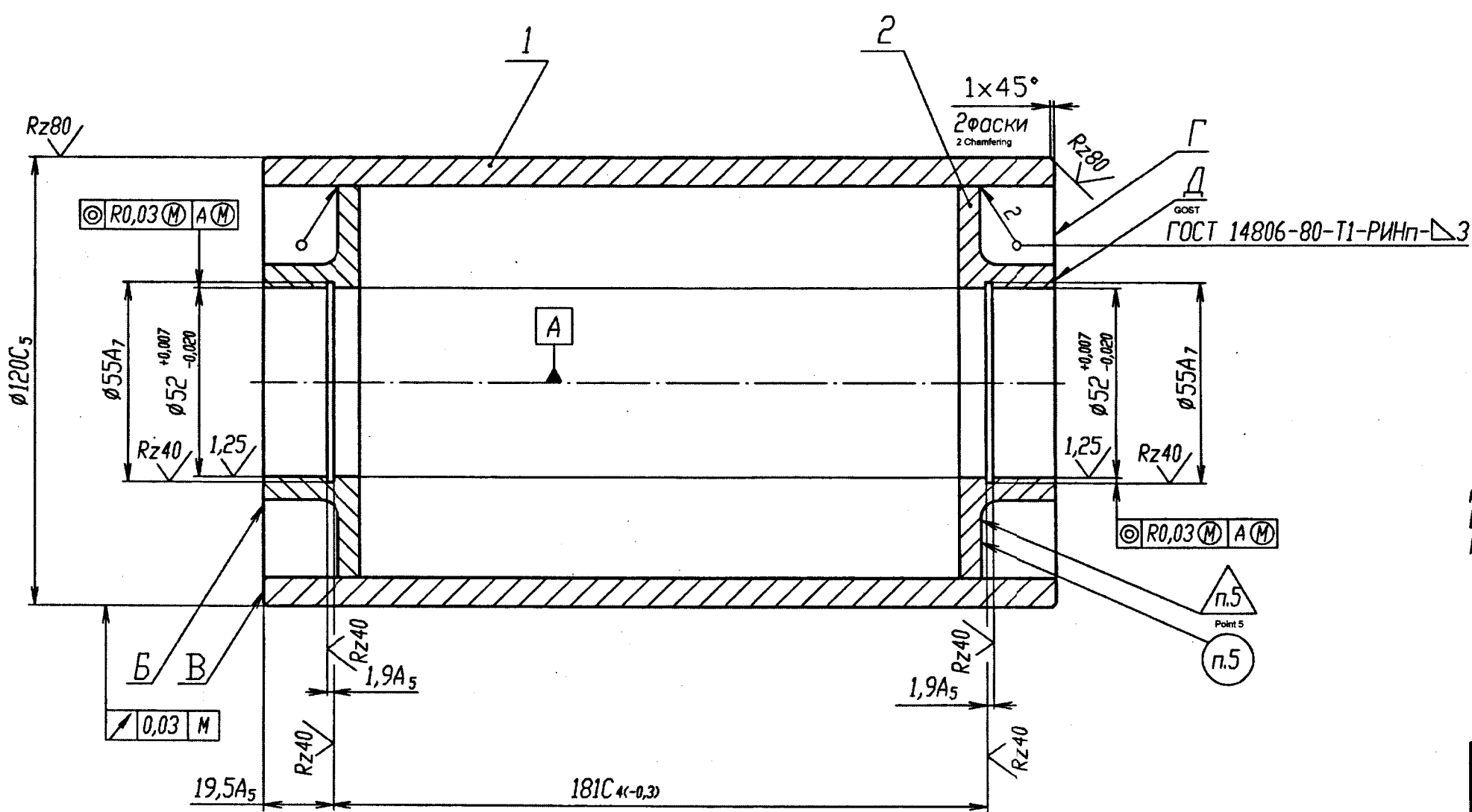
Инв.№ подл. Подп. и дата Изм.№ Инв.№ дубл. Подп. и дата

		AK-630M 03-40		Type	Mass	Scale
Изм./Лист	№ докум.	Подп.	Дата	Лит.	Масса	Масштаб
Разраб.				A	1,200	1:1
Проб.				Лист / Листов 1		
Т.контр.				Sheet / Total Sheets		
И.контр.				Round bar 30-B GOST 2590-88		
УТВ.				Круг 40X-3-T GOST 4543-71		

40 Kh-3-T GOST 4543-71

AK-630M СБ03-13СБ

Вариант изготовления из трубы
М 1:2



1. Argon arc welding with the use of filler electrode 3.15 Sv AMg 6 GOST 7871-75. Joints of II category - as per OST 3-4001-91. Carry out the visual inspection.
2. Internal angles R ~ 0.2 mm.
3. Non-coinciding of planes Б and В, Г and Д is not more than 0.5 mm.
4. Coating: Hard An. Ox.
5. Mark Ш, Ч and stamp К as per AK-630, AK-630M TU I.

1. Сварка аргоно-дуговая с применением присадочной проволоки 3,15 СвАМг6 ГОСТ 7871-75. Шов II категории по ОСТ 3-4001-91. Контролировать внешним осмотром.
2. Внутренние углы R ~ 0,2 мм.
3. Несовпадение плоскостей Б и В, Г и Д не более 0,5 мм.
4. Покрытие Ан. Окс. тв.
5. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ I.

Подп. и дата
 Изм. подл.
 Т.контр.
 Чтв.
 Подп. и дата
 Проверка
 Подп. и дата
 Проверка
 Подп. и дата
 Проверка

AK-630M Sb 03-13 SB

				AK-630M СБ03-13СБ		
				Ролик		
				Сборочный чертёж		
				Ассемблинг		
				Лист 1 из 1		
				Sheet 1 of 1		
				Format A4x3		

First use

Reference No.

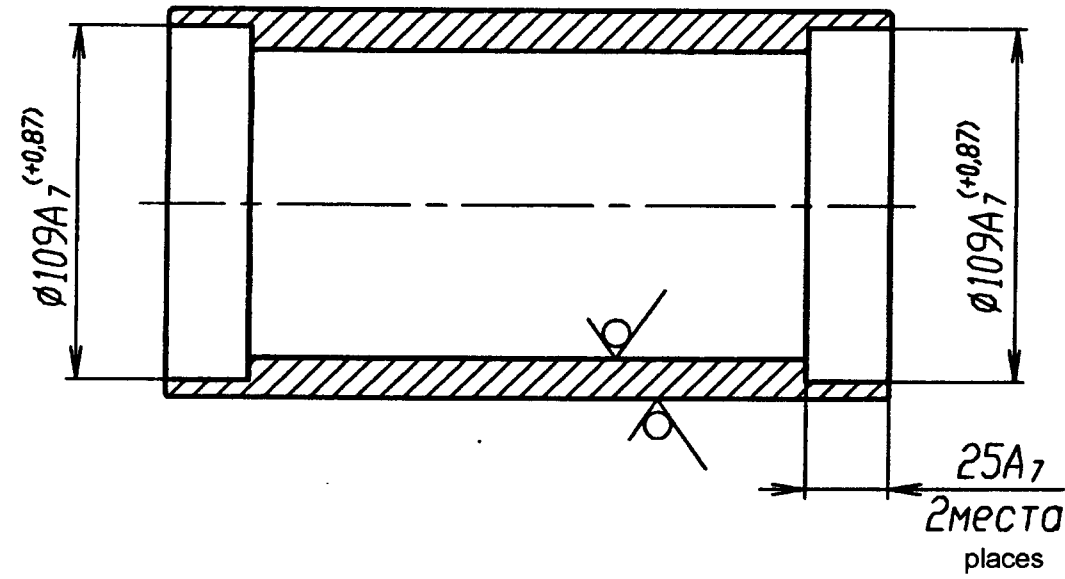
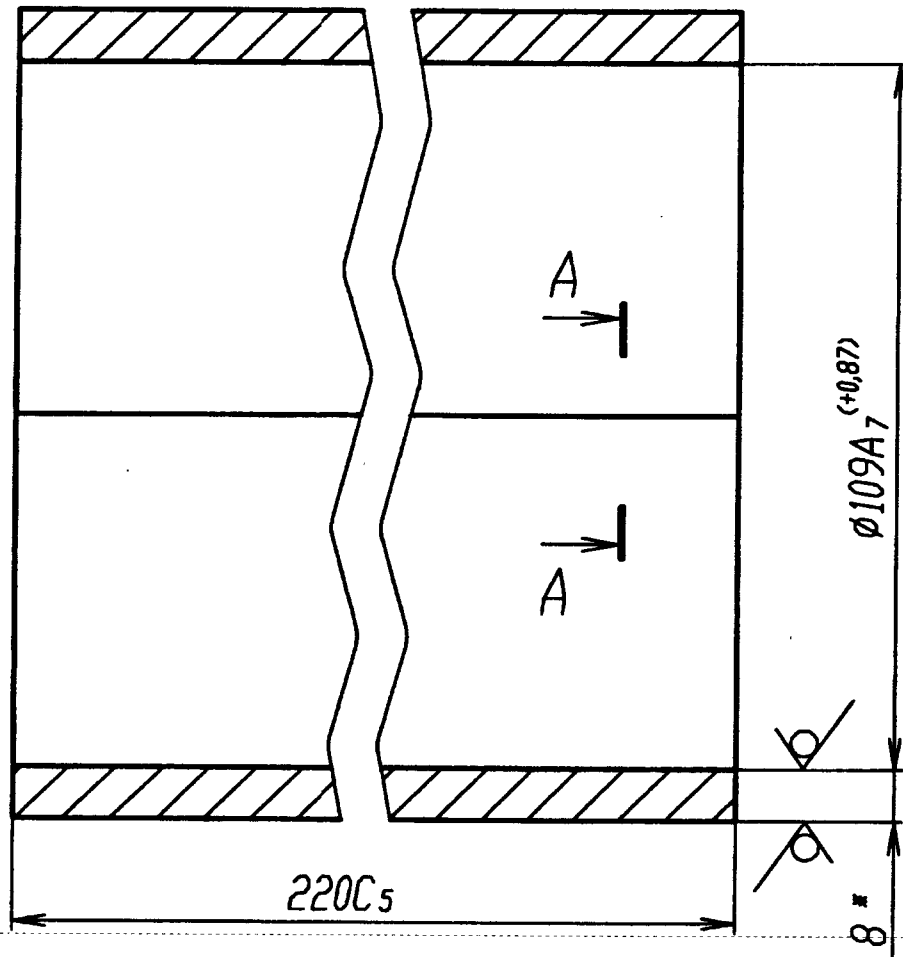
Sign and Date

Duplicate Inv. No

Altern. Inv. No

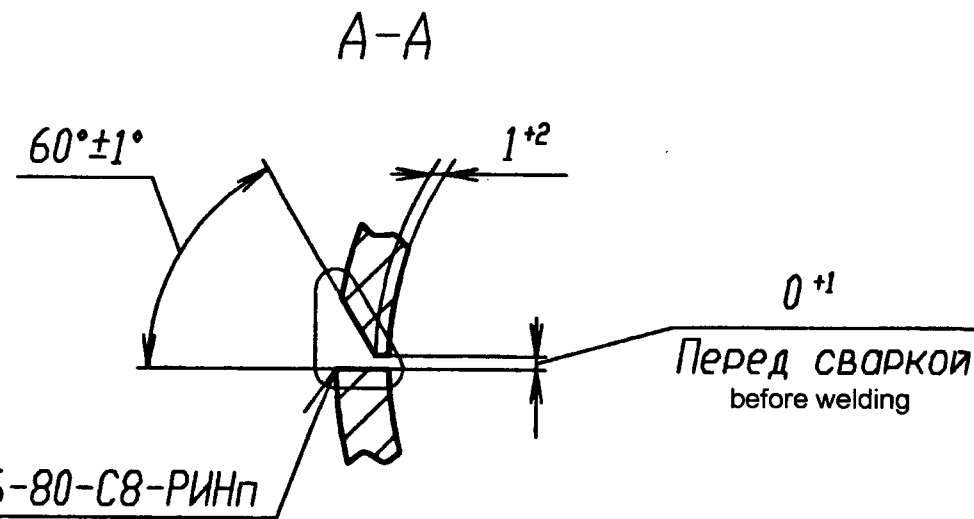
Sign and Date

Orig. inv. no.



1. It is permissible to make components from tube 125x12.5 AMg6 M GOST 18482-79.
2. Argon-arc welding with filling wire 3 Sv-AMg6 GOST 7871-75, seam category II as per OST 3-4001-91. Check visually.
- 3.* Reference dimension.
4. Mark Ш, Ч and stamp K on tag.

Comment [S15]:



GOST
 ГОСТ14806-80-С8-РИНп

					AK-630M 03-41			
Amend.	Sheet	Doc.No.	Sign	Date	Pipe	Type	Weight	Scale
Developed by						A	1.770	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Sheet AMg6 M-8			
Approved by					GOST 21631-76			

AK-630M 03-42

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.	
<p>1.*Dimensions ensured by tool. 2.Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.</p>					
AK-630M 03-42					
					Type
					Weight
					Scale
Hub					A
					0.350
					1:1
					Sheet
					Sheets 1
					Alloy AMg6 GOST 4784-97

Copied by

Format A4

AK-630M Cb 03-9CB

AK 630M Sb 03-9 SB

Лев. примеч.

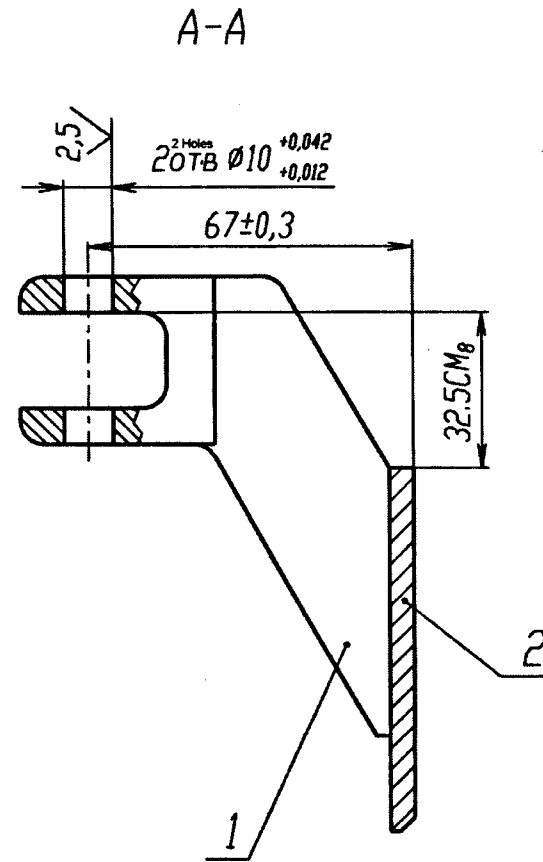
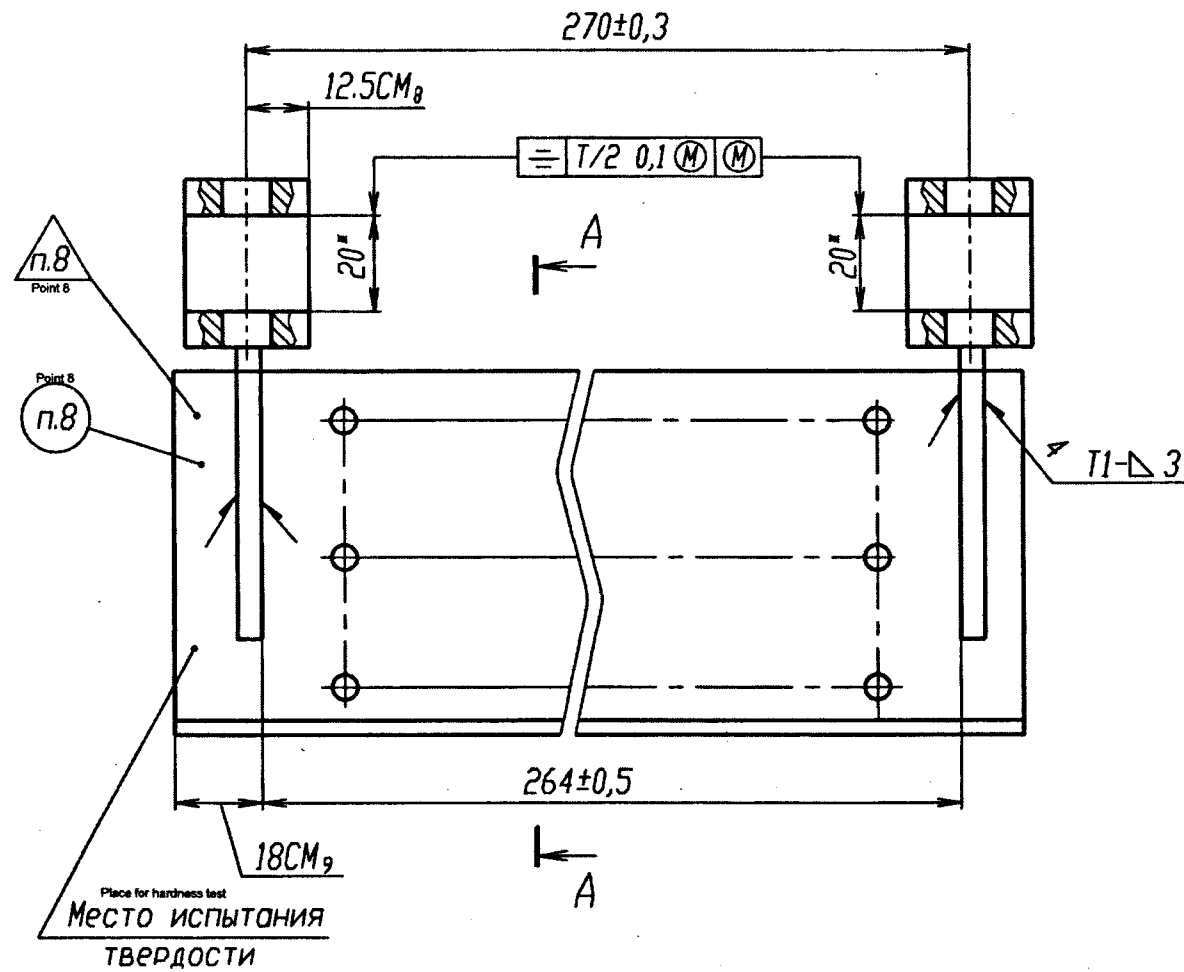
Слов. примеч.

Табл. и дата

Взр. и дата

Подп. и дата

Изм. и дата



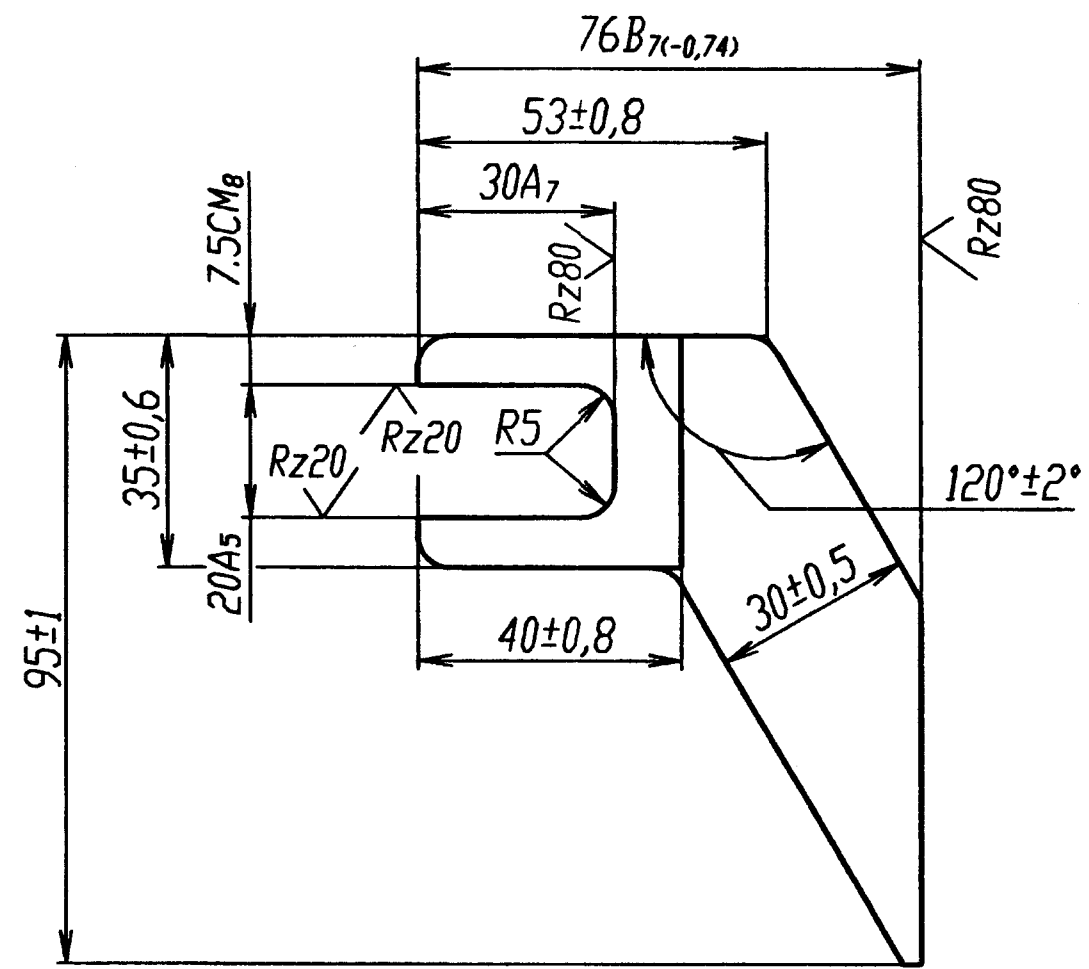
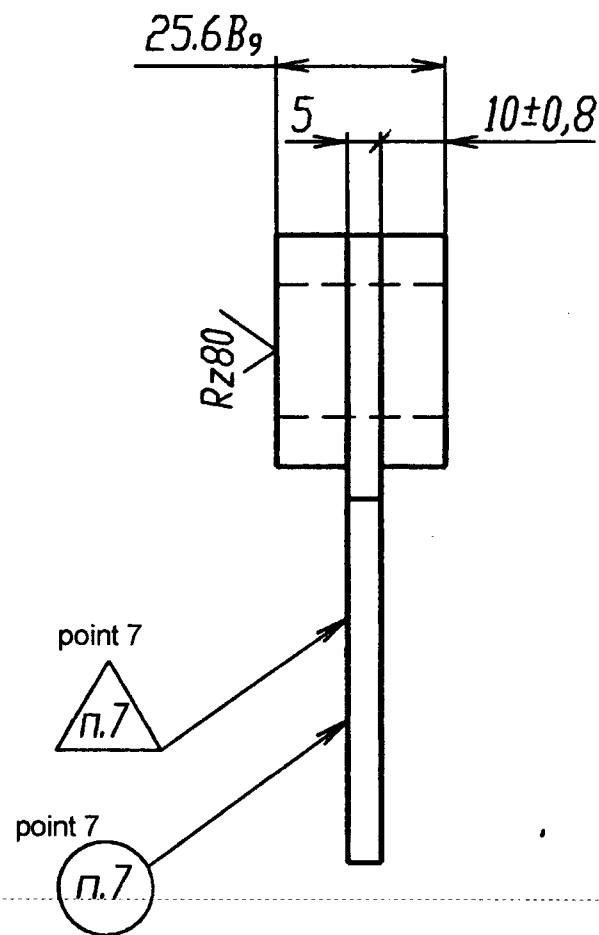
1. Make the welding joints as per GOST 14771-76-UP with the use of filler electrode 1.25v-08.G2S GOST 2246-70. Welded joints of II category as per OST 3-4001-91. Carry out 100% inspection by way of external inspection. It is permitted to make the welded joints as per GOST 5264-80 with the use of filler electrodes UONI - 1355-3.0-2 GOST 9466-75. NIAT-5-2.0 GOST 9466-75 followed by low tempering, is permitted.
2. Cutting down of defects, which are detected on defectoscope after the hardening, welding with electrode E - 11x15N25M6AG2- NIAT-5-2.0 GOST 9466-75 followed by low tempering, is permitted.
3. 34...39,5 HRC E.
4. * - Dimension for reference.
5. Internal angles R 0.4 mm.
6. Blunt the sharp edges - 0.4 mm.
7. Coating Cad. 12. phos followed by oil treatment.
8. Mark Ш, Ч and stamp К, И as per AK-630, AK-630M TU I.

1. Сварные швы выполнять по ГОСТ 14771-76-УП с применением присадочной проволоки 1,2 Св-08Г2С ГОСТ 2246-70. Сварные швы II категории по OST 3-4001-91. Контролировать 100% внешним осмотром. Допускается выполнять сварные швы по ГОСТ 5264-80 с применением электродов УОНИ 13/45-3,0-2 ГОСТ 9466-75.
2. Допускается вырубка дефектов, обнаруженных на дефектоскопе после закалки, заварка электродом Э-11Х15Н25М6АГ2-НИАТ-5-2,0 ГОСТ 9466-75, с последующим проведением низкого отпуска.
3. 34...39,5 HRC_E.
- 4.* Размер для справок.
5. Внутренние углы R ≈ 0,4 мм.
6. Острые ребра притупить ≈ 0,4 мм.
7. Покрытие Кд12. фос. прм.
8. Маркировать Ш, Ч и клеймить К, И по АК-630, АК-630М ТУ I.

AK - 630M Sb 03-9 SB

				AK-630M Cb 03-9CB		
				Type	Mass	Scale
Изм/лист	№ докум.	Подп.	Дата	Лит.	Масса	Масштаб
Разроб.				A	1,260	1:1
Проб.				Лист / Листов I		
Т.контр.				Sheet / Total Sheets		
И.контр.						
Утв.						

Формат А4х3

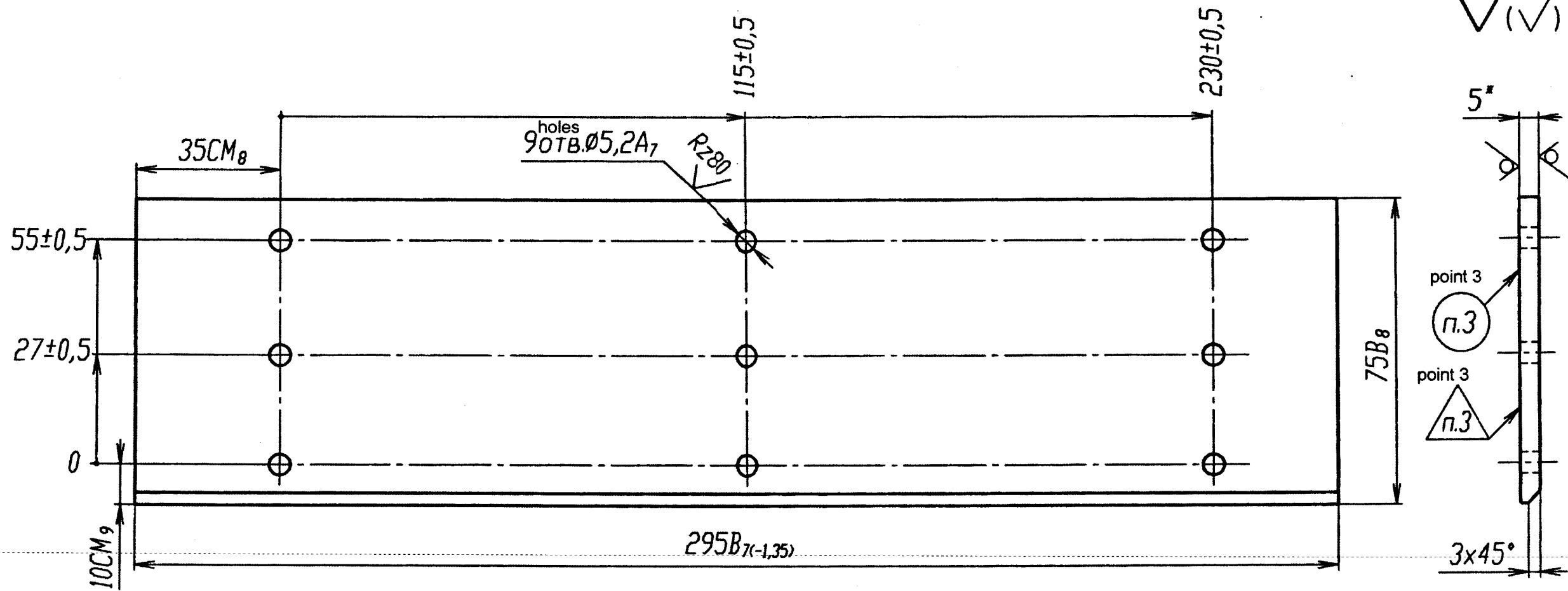


Rz160 (✓)

1. Accuracy of casting 8-0-0-7 GOST 26645-85.
2. Displacement of parting planes up to 0.3 mm.
3. Marks of follower not larger than 0.5 mm is permissible.
4. Casting radii R 5 mm unless otherwise specified.
5. Pattern drafts as per GOST 3212-92 toward increasing dimension.
6. Surface finish of casting surface as per test specimen.
7. Mark Ш, Ч, П and stamp K as per AK-630, AK-630M TU I.

Comment [S16]:

					AK-630M 03-46			
Amend.	Sheet	Doc.No.	Sign	Date	Bracket	Type	Weight	Scale
Developed by						A	0.220	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Casting	$\frac{K25 - IIOST3 - 4365 - 79}{35LGOST977 - 88}$		
Approved by								



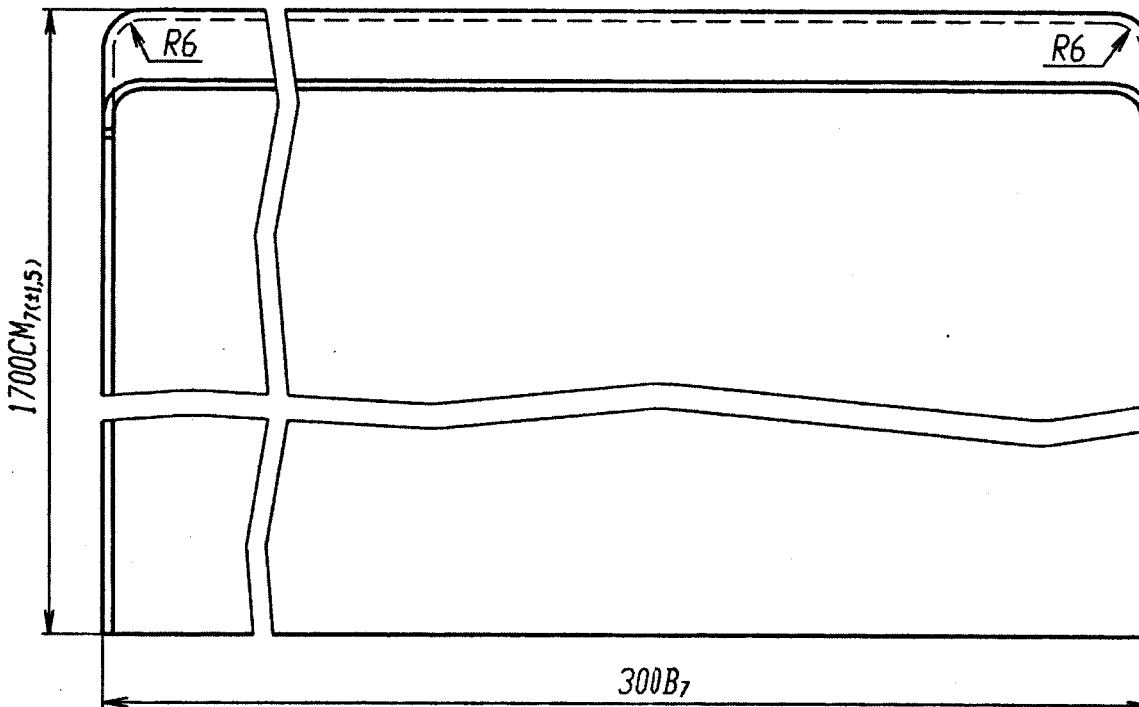
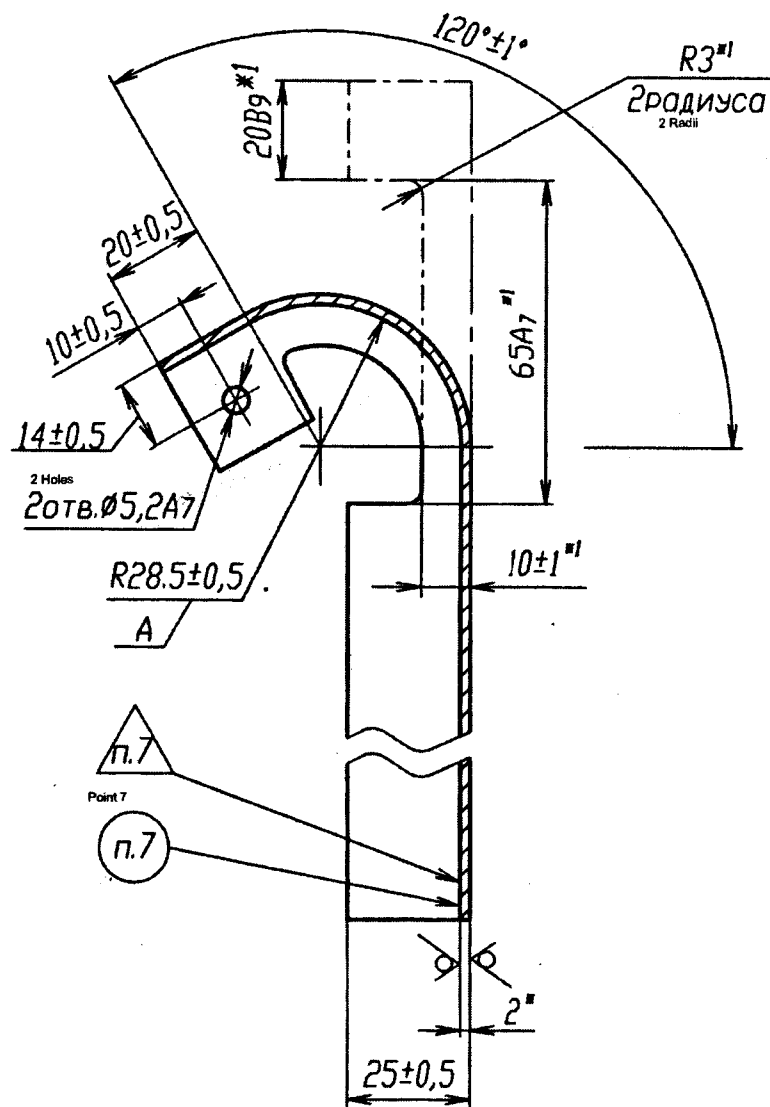
Comment [S17]:

- 1.* Reference dimensions.
- 2. Blunt sharp edges ~0.4 mm.
- 3. Mark Ш,Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630M 03-47			
Amend.	Sheet	Doc.No.	Sign	Date	Plate	Type	Weight	Scale
Developed by						A	0.800	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by					Sheet $\frac{B - PN - 5GOST19903 - 74}{35GOST1577 - 93}$			

AK-630M 03-14

Rz160
✓ (✓)



1. Material - substitute - Sheet AMg6 M-2 GOST 21631-76.
2. While bending along the radius A, the welding of cracks on flanging is permitted with filler electrode V. Sv AMg6. N 2.00xBT GOST 7871-75. From the external side, finish the joint with Rz 80 abraded with base metal.
3. * - Dimension for reference.
4. #1 - Dimensions for reaming.
5. Blunt the sharp edges ~ 0.4 mm.
6. Coating An. Ox. Chrome.
7. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

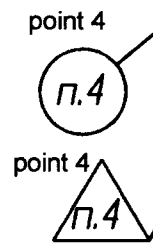
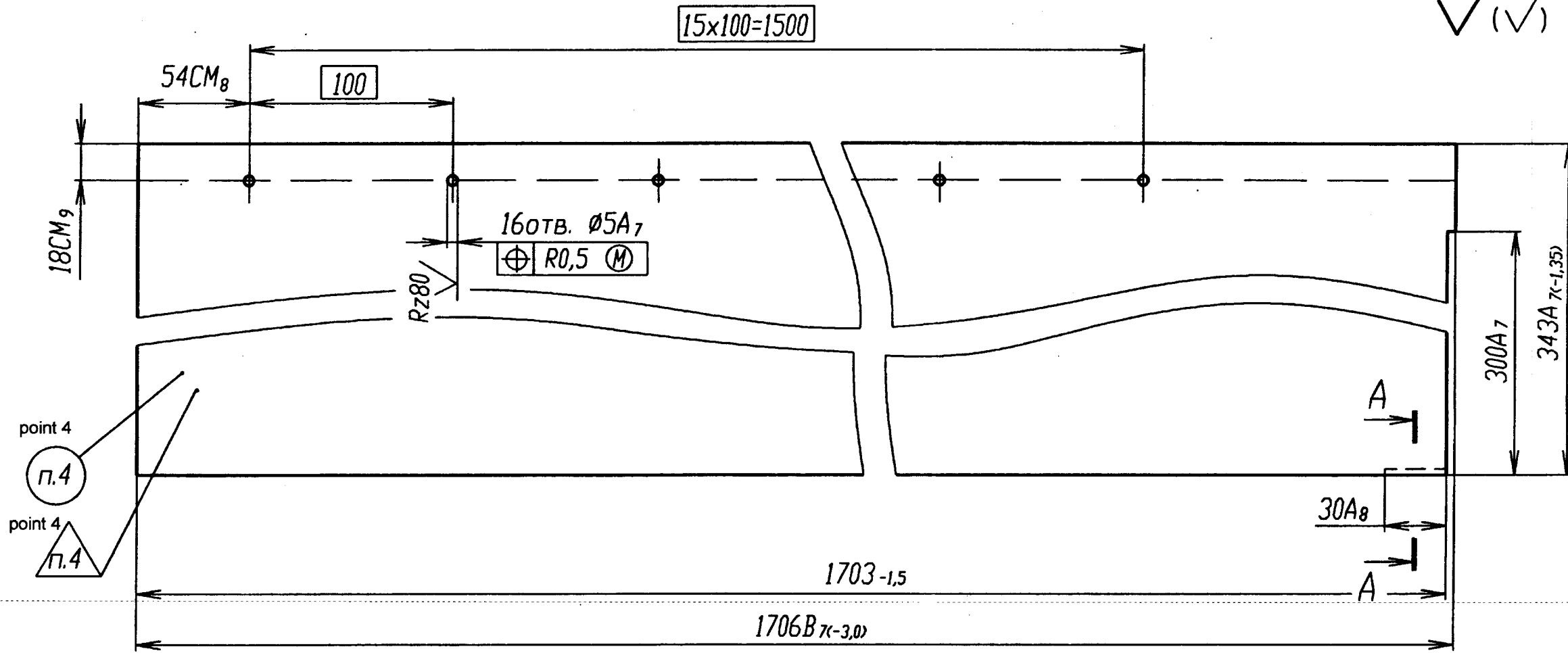
1. Материал-заменитель - лист AMг6 М-2 ГОСТ 21631-76.
2. При гибке по радиусу А допускается подварка трещин на отбортовке с применением присадочной проволоки В.Св AMг6. Н 2,00хБТ ГОСТ7871-75. С наружной стороны усиление шва зачистить Rz80 зашлифовать заподлицо с основным металлом.
3. * Размер для справок.
4. #1 Размеры для развертки.
5. Острые ребра притупить ~ 0,4 мм.
6. Покрытие Ан. Окс. хр.
7. Маркировать Ш,Ч и клеймить К по АК-630, АК-630М ТУ I.

AK-630 M 03-14

		AK-630M 03-14		Type	Mass	Scale
		Перегородка		Лит.	Масса	Масштаб
Изм./Лист	№ докум.	Подп.	Дата	А	3,600	1:1
Разраб.				Лист AMg6 BM-2		
Пров.				Лист	Листов 1	
Т.контр.				Лист AMg6 BM-2		
И.контр.				Лист AMг6 BM-2		
Утв.				ГОСТ 21631-76		
				Type	Total Sheets	

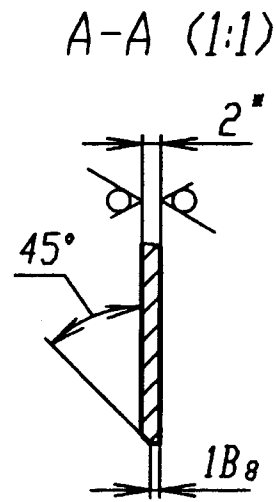
Формат А4х3

Rz160
✓(✓)



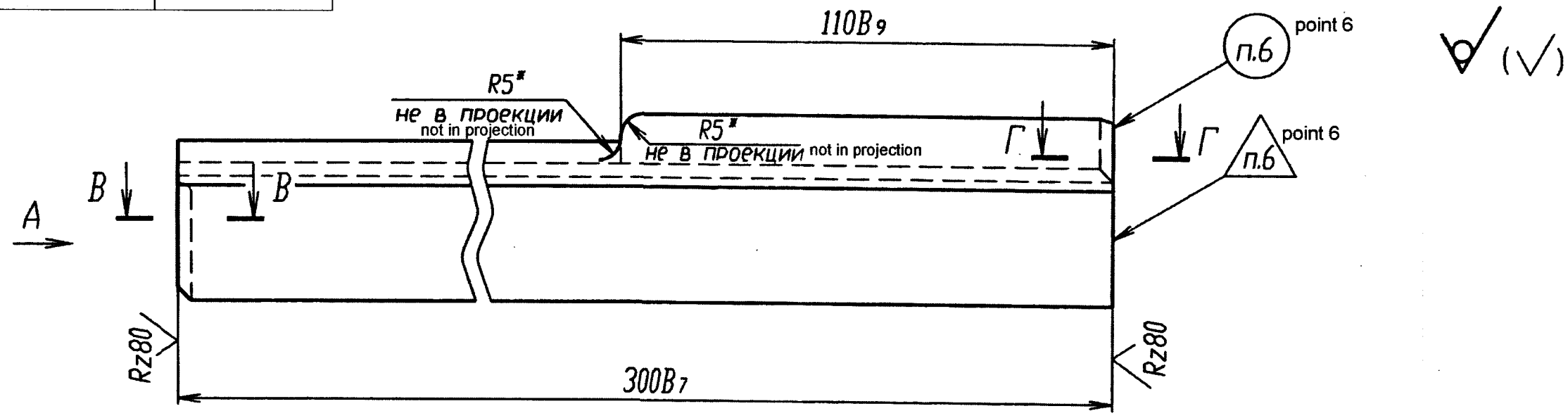
Comment [S14]:

1. Substitute material- sheet AMg6 M-2 GOST 21631-76.
- 2.* Reference dimension.
3. Inner angles $R \sim 0.4 \text{ mm}$.
4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I

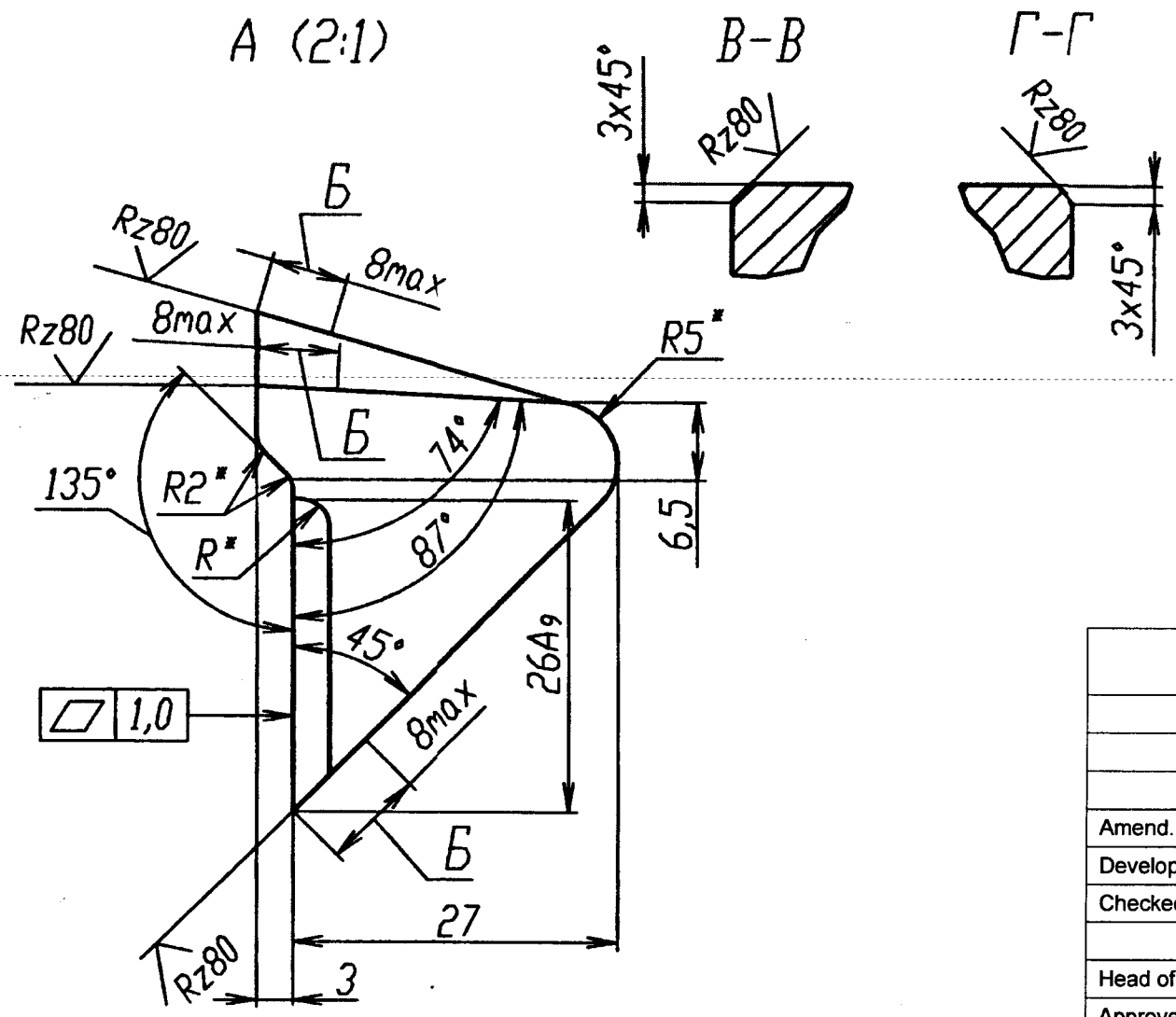


					AK-630M 03-32			
Amend.	Sheet	Doc. No.	Sign	Date	Bracket	Type	Weight	Scale
Developed by						A	5.040	1:2
Checked by						Sheet	Sheets	1
Head of Q.C.D					Sheet AMg6 BM-2			
Approved by					GOST 21631-76			

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



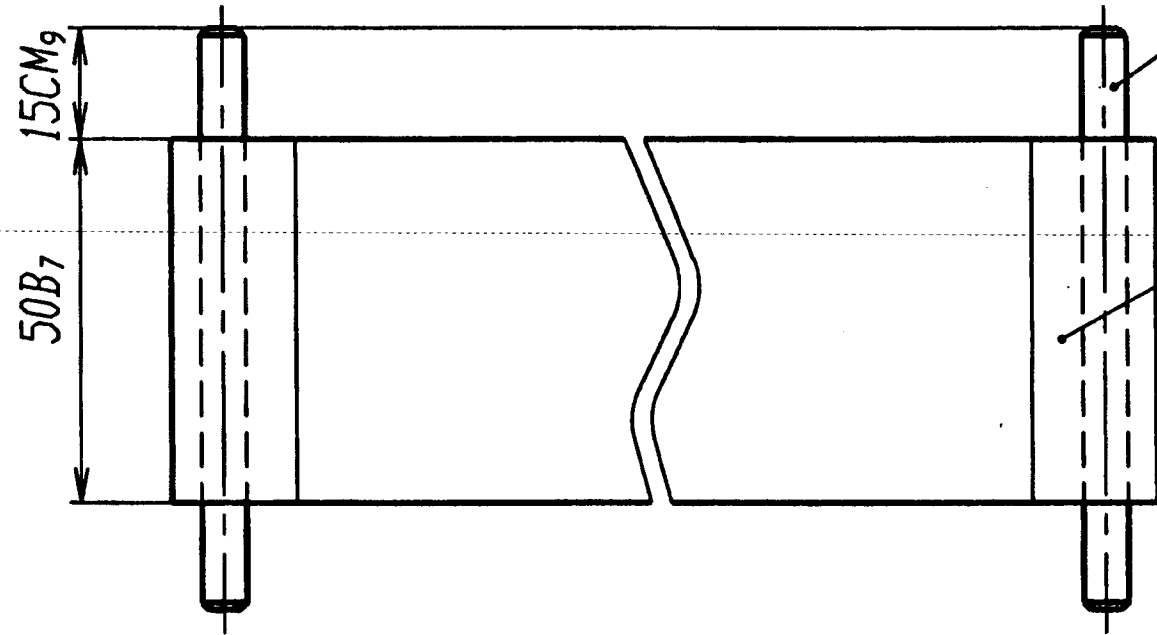
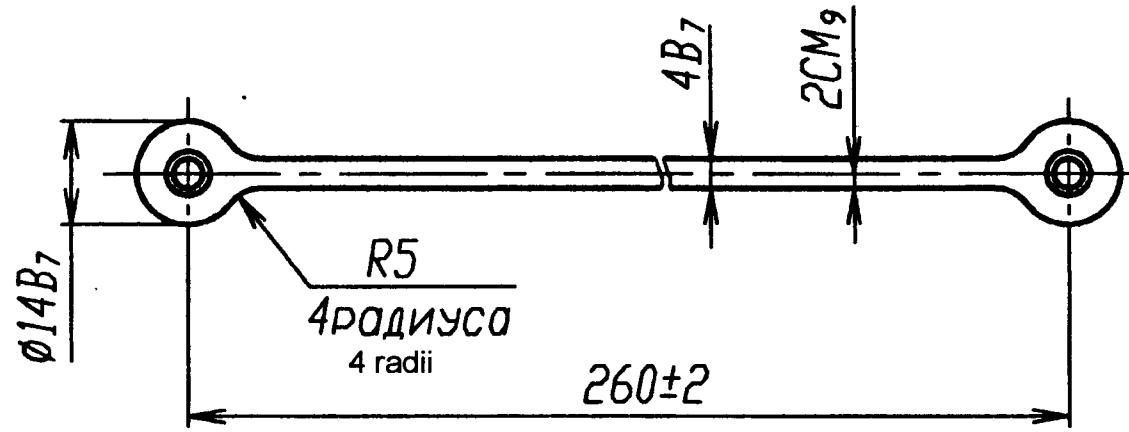
✓ (✓)



1. Allowances and deviations for forging dimensions as per 6th accuracy grade OST 1.41187-78.
2. Depth of external defects not more than 0.3 mm.
3. Forging radii ~3 mm unless otherwise specified.
4. Machine fins in zones Б flush with base metal. Depression not more than 0.5 mm is permissible.
- 5.* Dimensions ensured by tool.
6. Mark Ш,Ч and stamp К as per AK-630, AK-630M TU I.
7. Carry out inspection of forged blanks as per ZD group of inspection OST 92-1008-77 by checking hardness of 10% but not less than one piece.

Comment [S18]:

					AK-630M 03-49			
Amend.	Sheet	Doc.No.	Sign	Date	Strap	Type	Weight	Scale
Developed by						A	0.490	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Alloy AMg6 GOST 4784-97			
Approved by								



1. Dimensions ensured by tool.
2. Surface finish of shape forming surfaces of press mould $0.32\sqrt{}$.
3. Mark Ш, Ч and stamp K on tag.
4. Technical requirements for quality of surfaces as per II group TU 38.105.1959-90.

Comment [S1]:

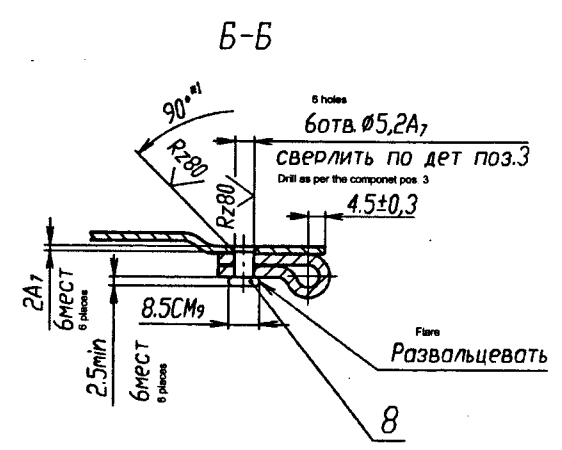
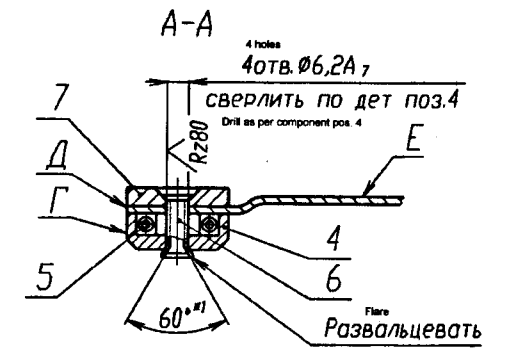
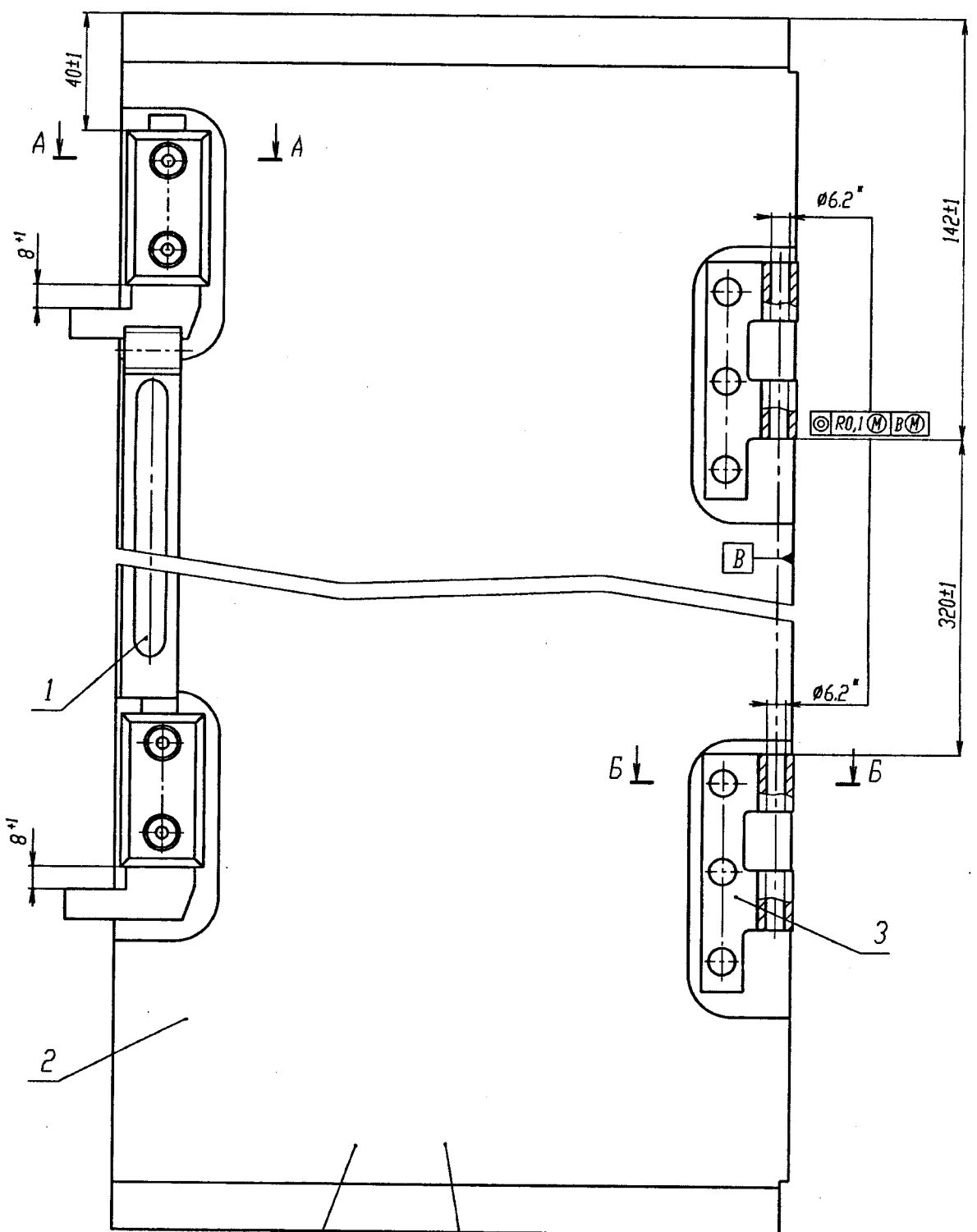
					AK-630M Sb 03-4 SB			
Amend.	Sheet	Doc.No.	Sign	Date	Tie Assembly drawing	Type	Weight	Scale
Developed by						A	0.098	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by								

AK-630M 03-35																	
Approved by shop	Reference No.																
Approved KTONI	Sign and Date																
Approved TOsb	Dupl. Inv. No.	<p>1. 34..39.5 HRC_E . Check on specimen. 2..* Reference dimension . 3.Blunt sharp edges ≈ 0.4 mm. 5. Coating Cd 12.Phos. 6.Mark Ш, Ч and stamp K, И on tag.</p>															
Alternate Inv. No.	Sign and Date																
Approved OGMet	Orig. Inv. No.	Sign and Date		<p>AK-630M 03-35</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%;"></td> <td style="width: 10%;">Type</td> <td style="width: 10%;">Weight</td> <td style="width: 10%;">Scale</td> </tr> <tr> <td style="text-align: center;">Pin</td> <td style="text-align: center;">A</td> <td style="text-align: center;">0.040</td> <td style="text-align: center;">1:1</td> </tr> <tr> <td colspan="2">Sheet</td> <td colspan="2">Sheets 1</td> </tr> </table>			Type	Weight	Scale	Pin	A	0.040	1:1	Sheet		Sheets 1	
	Type	Weight	Scale														
Pin	A	0.040	1:1														
Sheet		Sheets 1															
Developed by		Checked by		<p>Round bar $\frac{6 - h11 GOST7417 - 75}{40 - T - V GOST1051 - 73}$</p>													
Head of Q.C.D		Design chief															
Head of Q.C.D		Approved by															
Amend.		Sheet	Doc. No.	Sign	Date												

Copied by

Format A4

First use		Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks	
		<u>Documents</u>							
	A1	/			AK-630M Sb 03-5 SB	Assembly drawing			
Reference No.									
		<u>Assembly units</u>							
	A4	/	1		AK-630M Sb 01-27	Catch	1		
		<u>Components</u>							
	A1	/	2		AK-630M 03-37	Door	1		
	A3	/	3		AK-630 110-4	Loop	2		
	A3	/	4		AK-630 110-87	Catch body	2		
	A3	/	5		AK-630 110-88	Spring	4		
	A3	/	6		AK-630 110-90	Screw	4		
	A4	/	7		AK-630 110-91	Cover plate	2		
		<u>Standard articles</u>							
			8			Rivet 5 x 18 31.10	6		
						GOST 10300-80			
Sign and Date									
Dupl. Inv. No.									
Alternate Inv. No.									
Sign and Date									
Orig. Inv. No.									
		AK-630M Sb 03-5							
		Amend.	Sheet	Doc. No.	Sign	Date			
		Developed by					Type	Sheet	Sheets
		Checked by					A		1
		Head of Q.C.D					Door		
		Approved by							



- 1. * - Dimensions for reference.
- 2. *1 - Dimensions are ensured by tool.
- 3. Set the planes Д and Г abutted. Recess of plane Г beyond the plane Д - for not more than 0.5 mm is permitted.
- 4. Non-cylindricalness of surface E after the riveting of loop pos. 3 is not more than 2 mm. Straightening is permitted.
- 5. Latch pos. 1 should forcibly return to initial position under the effect of springs pos. 5.
- 6. Rolling (pitching) of the body of latch pos. 4 is permitted, during this the feeler gauge 0.5 mm should not enter between the body and door pos. 2.
- 7. After the flaring, not more than three cracks are permitted at the ends of screws pos. 6.
- 8. Lubricate the rubbing surfaces with grease MS-70 GOST 9762-76.
- 9. Mark Ш, Ч and stamp К as per AK-630, AK-630M TU I.

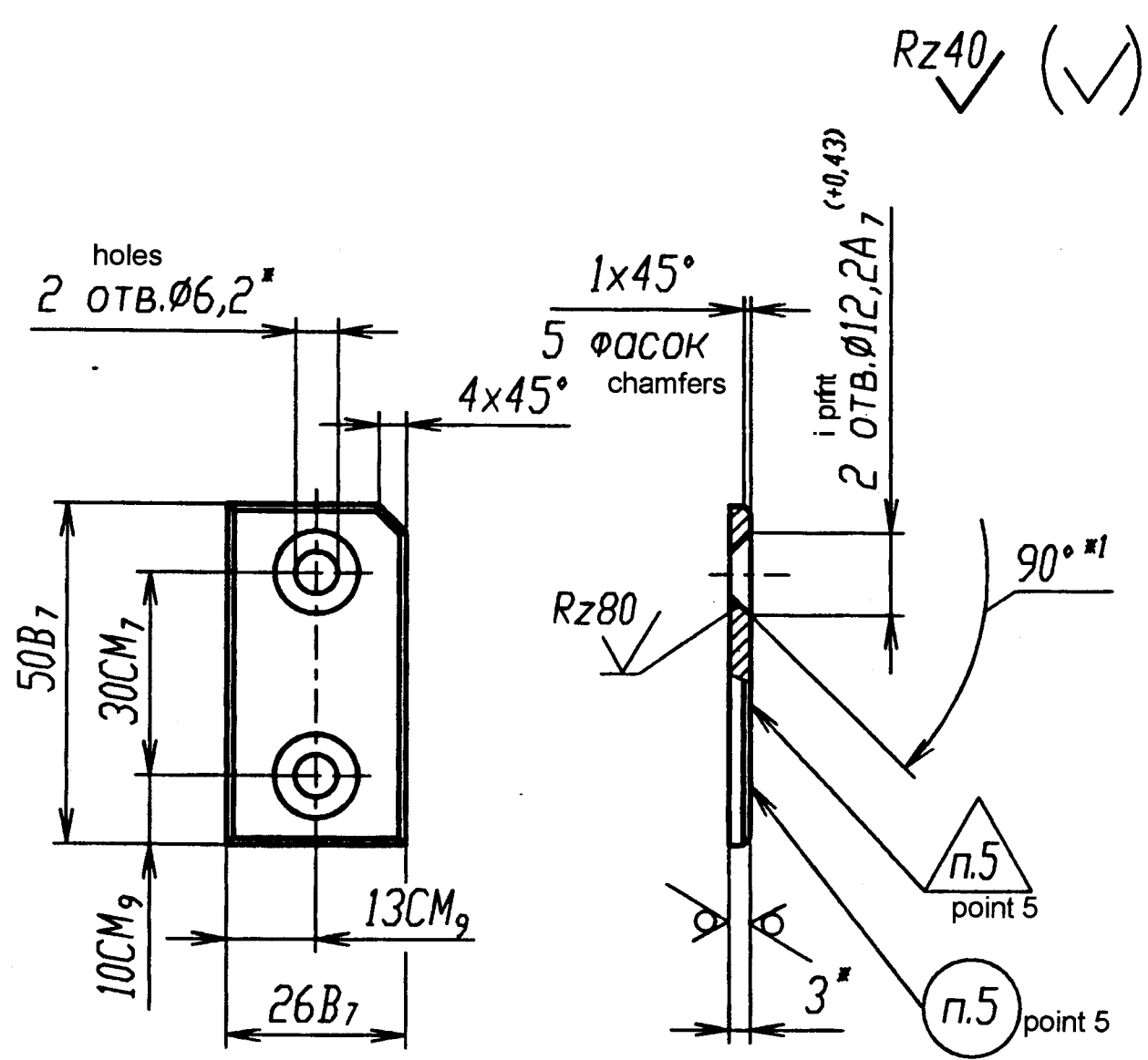
- 1. * Размеры для справок.
- 2. *1 Размеры обеспечиваются инструментом.
- 3. Плоскости Д и Г установить заподлицо. Допускается утопание плоскости Г за плоскость Д не более 0,5 мм.
- 4. Нецилиндричность поверхности E после приклейки петель поз. 3 не более 2 мм. Допускается правка.
- 5. Зашелка поз. 1 под действием пружин поз. 5 должна энергично возвращаться в исходное положение.
- 6. Допускается качка корпуса защелки поз. 4, при этом щуп 0,5 мм не должен проходить между корпусом и дверкой поз.2.
- 7. После развальцевания на торцах винтов поз. 6 допускается не более трех трещин.
- 8. Трущиеся поверхности смазать смазкой MS-70 ГОСТ 9762-76.
- 9. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ I.

ДИЗАЙН ПОДРАЗДЕЛЕНИЯ И АВТО ВНЕШНЕГО ВИДА И КОМПЛЕКТАЦИИ И АВТО ТЕХНИЧЕСКОГО РЕДАКТИРОВАНИЯ И АВТО

AK - 630 ББ 03 - 5 СБ		AK-630M СБ03-5СБ	
ИЗМ/ЛИСТ	№ ДОКУМ.	ПОДП.	ДАТА
РАЗРАБ.			
ПРОВ.			
ТЕХНОЛ.			
ИСПОЛ.			
УТВ.			
Дверка		Лист	Масштаб
Сборочный чертеж		A	1,700 1:1
Door		Листов	Листов
Assembly drawing		Sheet	Total Sheets

AK-630 110-91

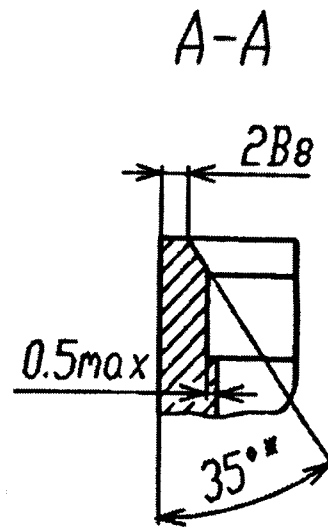
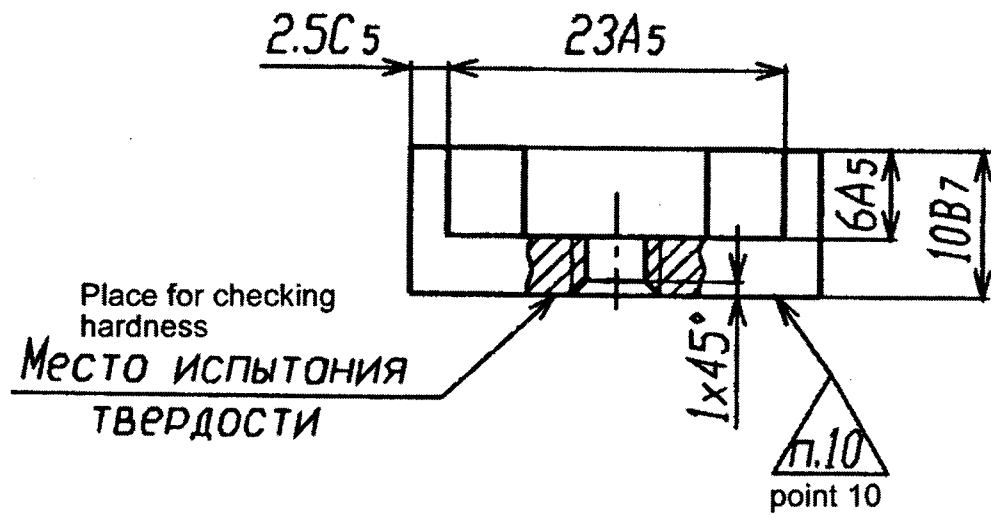
Approved OGMet	Orig. Inv. No.	Sign and Date	AK-630 110-91		
	Approved OGSb	Alternate Inv. No.			
Approved KTON	Dupl. Inv. No.	Sign and Date	AK-630 110-91		
Approved by shop	Reference No.	First use			



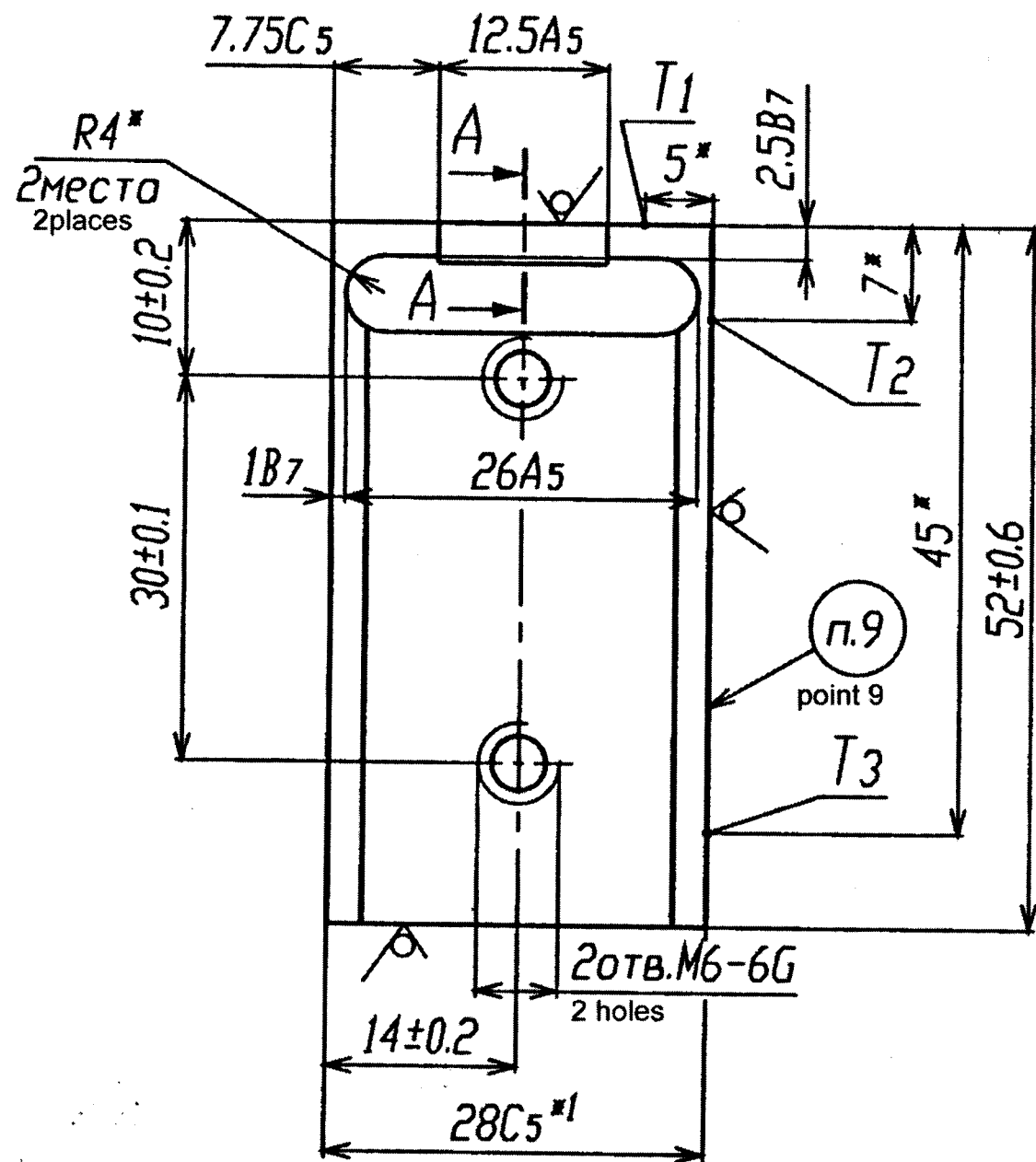
- 1.* Reference dimension.
- 2.*1Dimensions ensured by tool.
3. Blunt sharp edges ~0.4 mm.
4. Coating Cd 12.phos.Oil.
- 5.Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

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				

AK-630 110-91			
Cover plate	Type	Weight	Scale
	A	0.030	1:1
	Sheet	Sheets 1	
Sheet $\frac{B - PN - 03 GOST19903 - 74}{K490V 4 - III - 35 GOST16523 - 97}$			



Rz40 (✓)



1. Casting accuracy 8-0-0-8 as per GOST 26645-85.
2. Displacement along plane of joint up to 0.3 mm.
3. Casting radii R = 2 mm unless otherwise specified.
4. Marks from pusher not larger than 0.5 mm are permissible.
5. 34...39.5 HRC_E.
6. * Dimensions ensured by tool.
- 7.*1 Dimension given with respect to points T₁, T₂ and T₃.
8. Coating: Cd. 12. Phos. oil.
9. Mark П as per AK-630, AK-630 M TU I.
10. Stamp К, И as per AK-630, AK-630 M TU I.
11. Mark Ш, Ч on tag.

					AK-630 110-87			
Amend.	Sheet	Doc.No.	Sign	Date	Catch body	Type	Weight	Scale
Developed by						A	0.300	2:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Casting	IOST3 - 4365 - 79 50L - GOST977 - 88		
Approved by								

First use

Reference No.

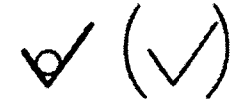
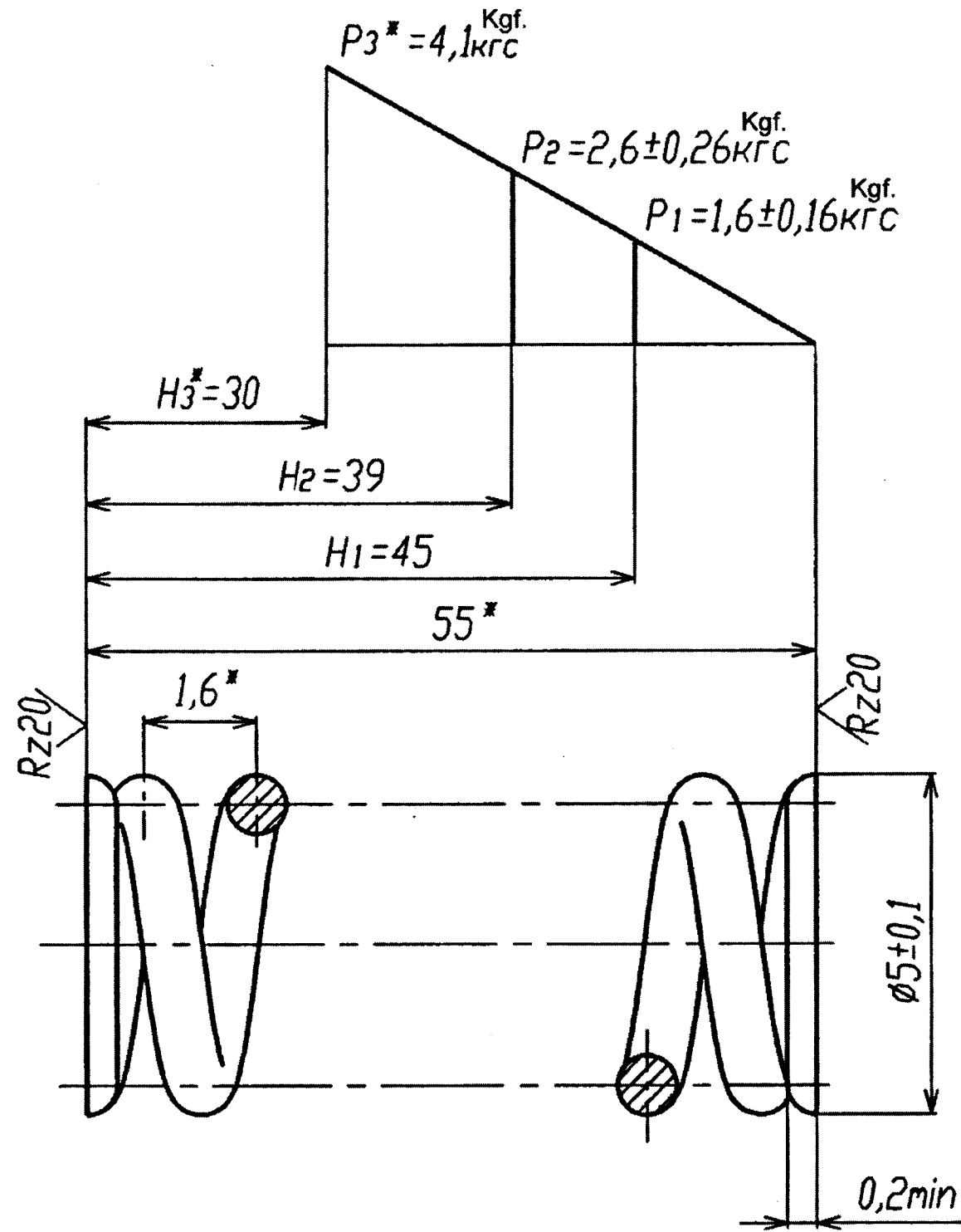
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



- 1.* Dimensions as parameters for reference
2. Group I.
3. $G^* = 8000 \text{ kgf/mm}^2$. $\tau_3^* = 107 \text{ kgf/mm}^2$.
4. Unrolled length $L^* = 500 \text{ mm}$.
5. Coiling direction- right.
6. $n = 34$.
7. $n_1 = 36 \pm 0.5$.
8. Heat treatment- tempering $240-260^\circ\text{C}$.
9. $D_g = 5.5A_5$
10. Pre deformation time (at H_2) –24 hours.
11. Coating Chem.phos. accel./ Lacquer BF-4 with nogrozene, 2 coats, made as per OST 3-4123-78, IV, OM2.
12. Mark Ш, Ч and stamp K, И on tag.
13. Other technical requirements as per GOST 16118-70.

					AK-630 110-88			
Amend.	Sheet	Doc.No.	Sign	Date	Spring	Type	Weight	Scale
Developed by						A	0.0025	10:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Wire V-1-0.8			
Approved by					GOST 9389-75			

AK-630 110-90

First use

Reference No.

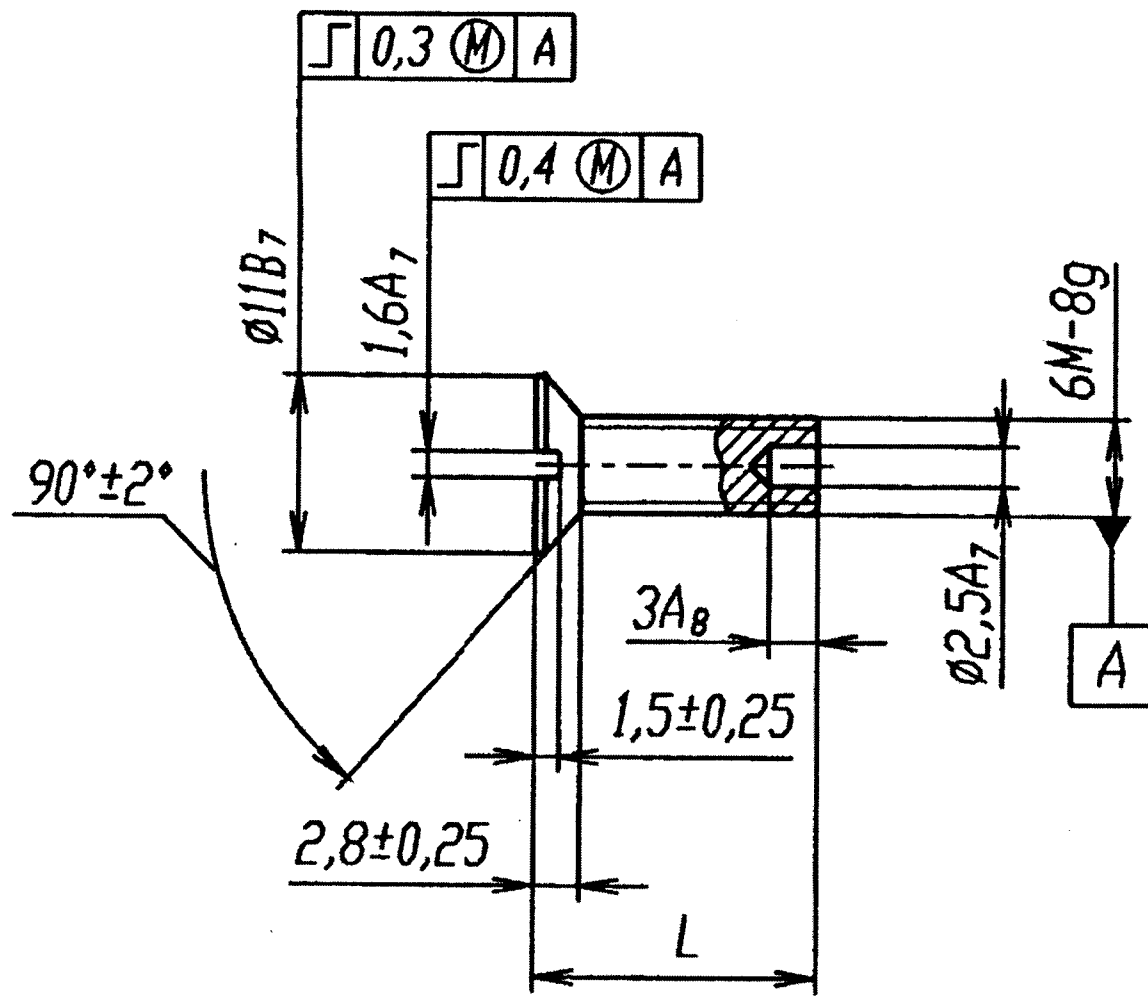
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

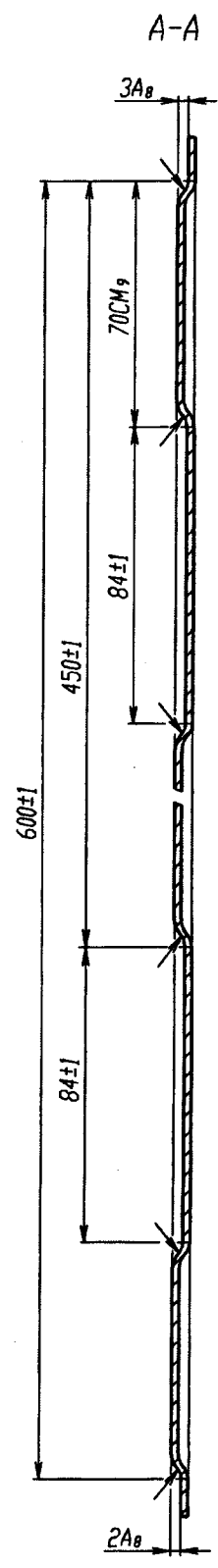
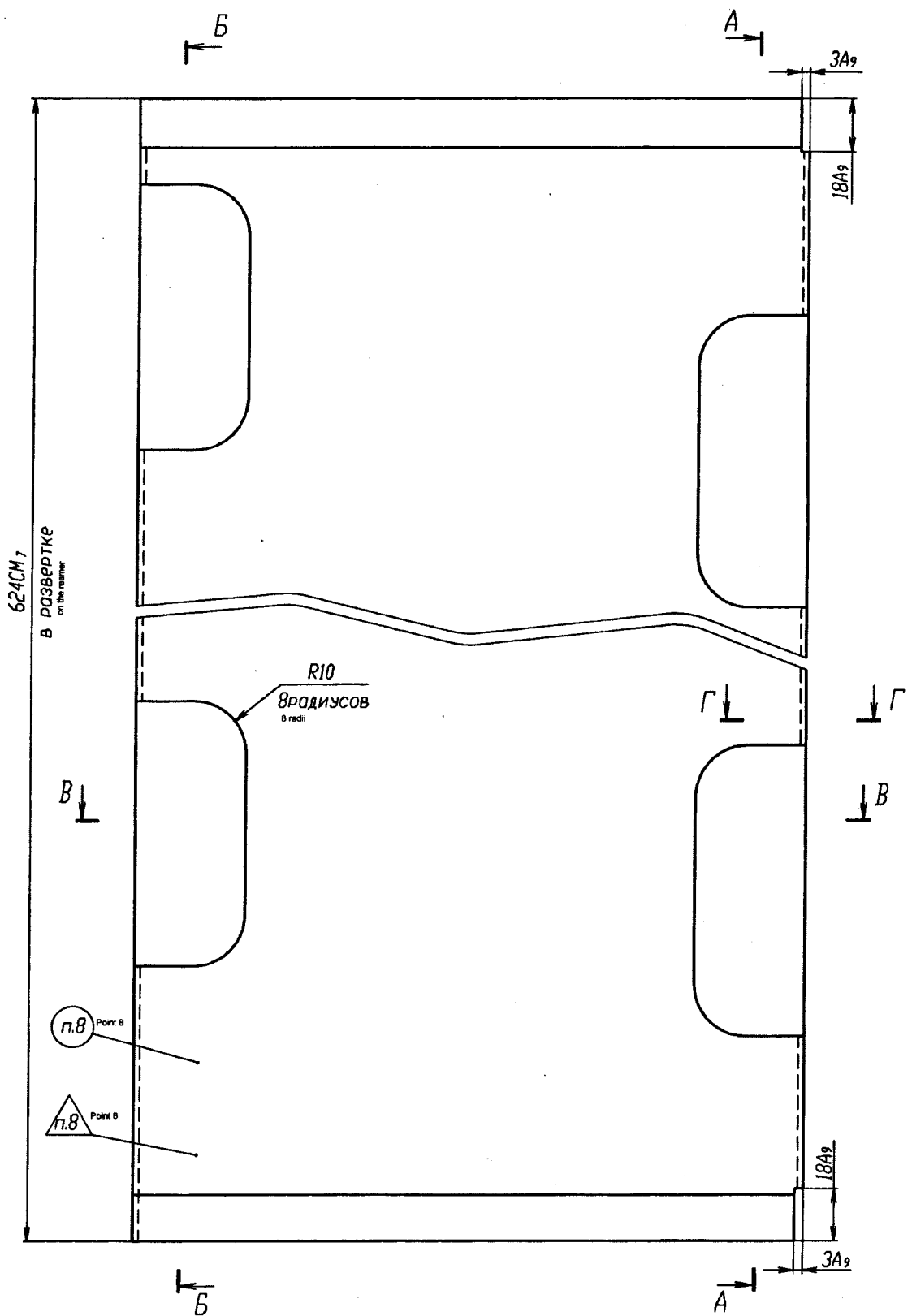
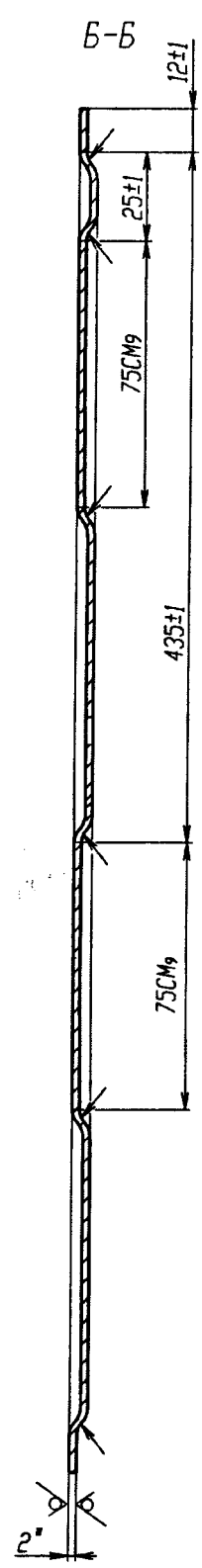
Orig. inv. no.



1. $HRC_E 31 \dots 40.5$.
Check hardness of 2% from the batch but not less than 3 nos.
2. Inner angles $R \sim 0.4$ mm.
3. Blunt sharp edges ~ 0.4 mm.
4. Coating Cd 9.Cr.
5. Mark III, Ч and stamp K on tag.

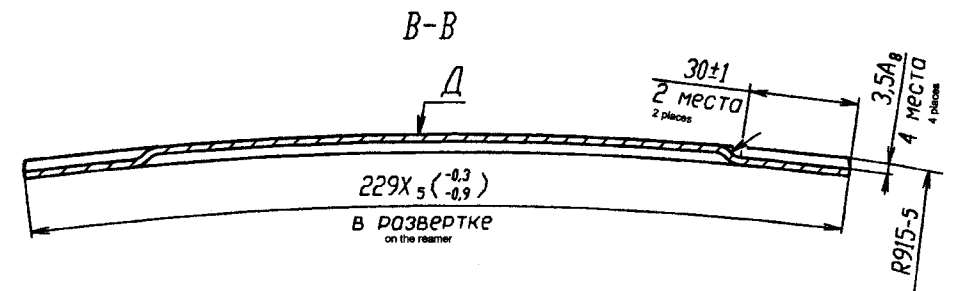
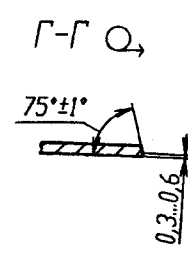
Designation	L, mm	Weight, kg
AK-630 110-90	17.5 B ₇	0.005

					AK-630 110-90			
Amend.	Sheet	Doc.No.	Sign	Date	Screw	Type	Weight	Scale
							A	Refer table
Developed by						Sheet	Sheets	1
Checked by								
Head of Q.C.D								
Approved by								
					Wheel	$\frac{12 - 5GOST7417 - 75}{40Kh - T - VGOST1051 - 73}$		



1. Material substitute - Sheet AMg6 M - 2 GOST 21631-76.
2. * - Dimension for reference.
3. Internal angles R ~ 0.4 mm.
4. Blunt the sharp edges ~ 0.4 mm.
5. Unspecified radii ~ 3 mm.
6. Tolerance of cylindricalness of surface Д is not more than 2 mm.
7. Coating An. Ox. chrome.
8. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU 1.

1. Материал-заменитель лист АМг6 М-2 ГОСТ 21631-76.
- 2.* Размер для справок.
3. Внутренние углы R ~ 0,4 мм.
4. Острые ребра притупить ~ 0,4 мм.
5. Неуказанные радиусы ~ 3 мм.
6. Допуск на цилиндричность поверхности Д не более 2 мм.
7. Покрытие Ан. Окс. хр.
8. Маркировать Ш, Ч и клеить К по АК-630, АК-630М ТУ 1.



АК-630М 03-37
 Дверка
 ГОСТ 21631-76
 Лист 1 из 1

AK-630M 03-37		AK-630M 03-37	
Изм/Лист	№ докум.	Дата	Масштаб
Разраб.	Провер.	Лист	Масса
Лист	Листов	Лист	Листов
Door Дверка		1,150 1:1	
Sheet AMg6 BM-2 GOST 21631-76		Лист Листов	
Лист АМг6 М-2 ГОСТ 21631-76		Sheet Total Sheets	

First use

Reference No.

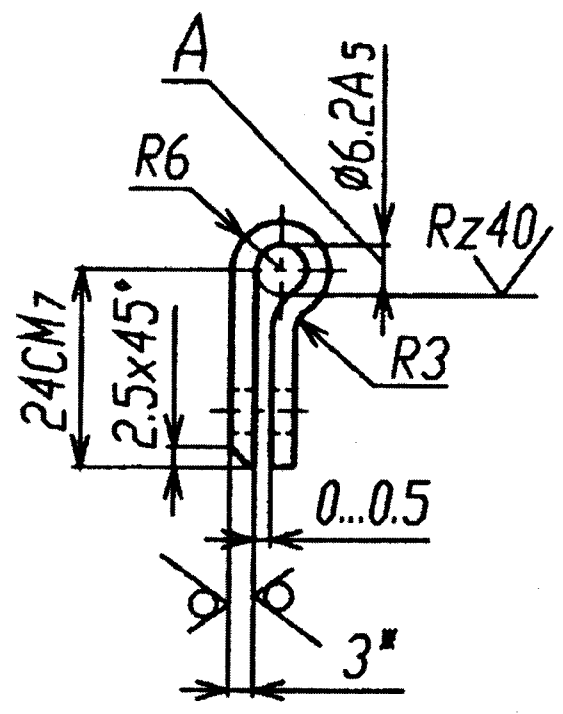
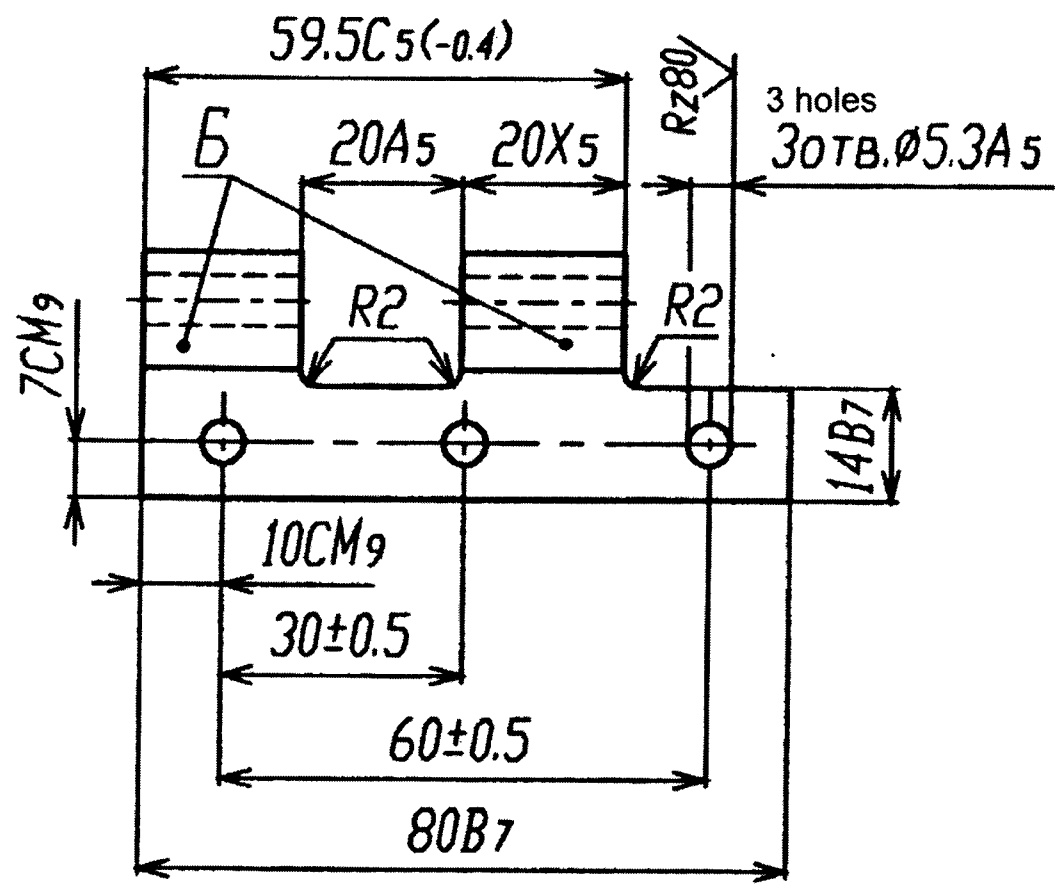
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz160 (✓)

1. Substitute material: Sheet AMg6 MZ GOST 21631-76.
- 2.* Reference dimensions.
3. While making dimension A, thickness of wall should not be less than 2.5 mm.
4. After bending on surfaces B, flaking of surface layer of metal as per test specimen is permissible.
5. Inner angles R~0.4 mm.
6. Blunt sharp edges ~0.4 mm.
7. Coating Anodic Oxid.Cr.
8. Mark Ш, Ч and stamp K on batch tag.

					AK-630 110-4			
Amend.	Sheet	Doc.No.	Sign	Date	Loop	Type	Weight	Scale
Developed by						A	0.030	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D						Sheet AMg6 BMZ GOST 21631-76		
Approved by								

AK-630M CБ01-27СБ

AK-630M Sb 01-27 SB

Прев.принен.

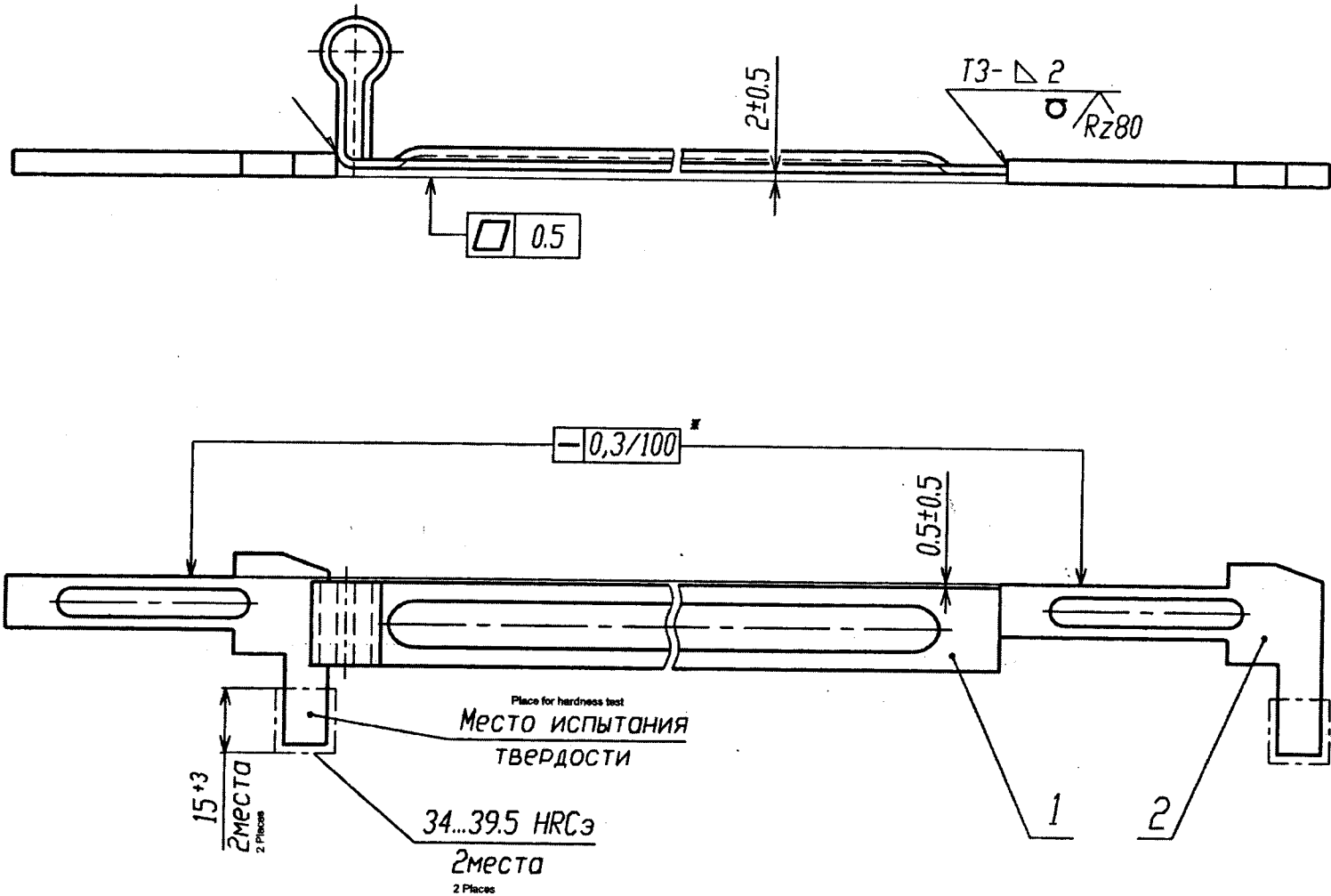
Слов.И

Подп. и дата

Инв.И

Подп. и дата

Инв.И



- Welded joints as per GOST 14771-76-UP with the use of filler electrode 1.2Св.-08Г2С GOST 2246-70. Welded joints of II category as per OST 3-4001-91. Carry out 100% inspection by way of external (Visual) inspection. It is permitted to make the welded joints as per GOST 5264-80 with the use of filler electrodes УОНИ - 13/45-2.0-2 GOST 9466-75.
- After the welding, carry out the standardization.
- After the welding, the straightening is permitted.
- * - Dimension is ensured by tool.
- Coating Cad. 12. phos. followed by oil treatment. Non-cadmium plating of the internal surface of component pos. 1 is permitted.
- Mark Ш, Ч and stamp К, И on the tag.

- Сварные швы по ГОСТ 14771-76-УП с применением присадочной проволоки 1,2Св.-08Г2С ГОСТ 2246-70. Сварные швы II категории по OST 3-4001-91. Контролировать 100% внешним осмотром. Допускается выполнять сварные швы по ГОСТ 5264-80 с применением электродов УОНИИ 13/45-2,0-2 ГОСТ 9466-75.
 - После сварки нормализовать.
 - Допускается правка после сварки.
 - * Размер обеспеч. INSTR.
 - Покрытие Кд. 12. фос. прм.
- Допускается непрокадмирование внутренней поверхности дет. поз. 1.
6. Маркировать Ш, Ч и клеить К, И на бирке.

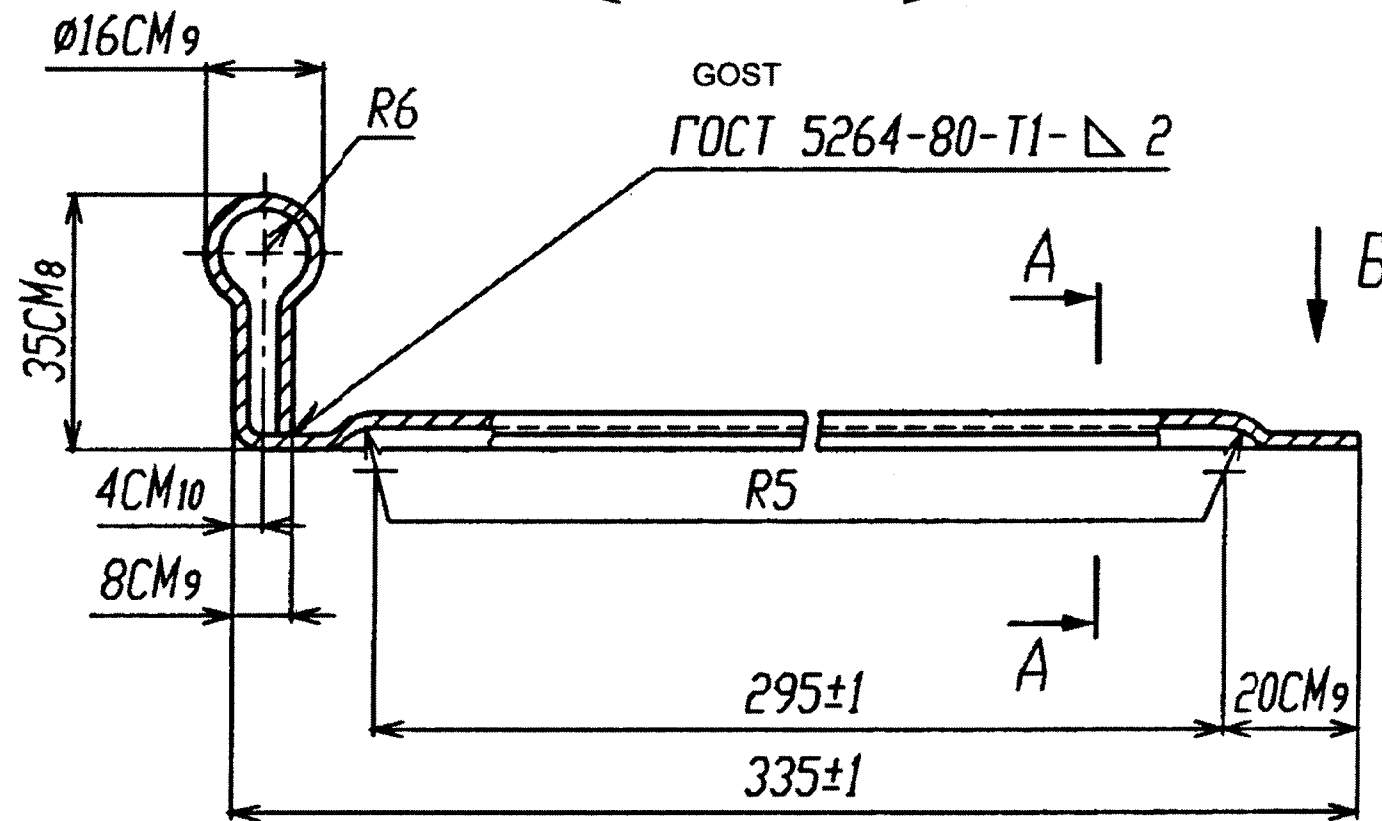
AK-630M Sb 01-27 SB

AK-630M CБ01-27СБ				Type	Mass	Scale
Изм/Лист	И докум.	Подп.	Дата	Лит.	Масса	Масштаб
Разраб.				A	0.350	1:1
Пров.				Лист	Листов 1	
Т.контр.				Sheet Total Sheets		
И.контр.				Assembly drawing		
Утв.				Sheet Total Sheets		

Формат А4х3

Rz60 (✓)

Направление проката
rolling direction

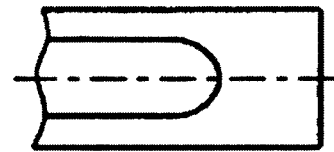
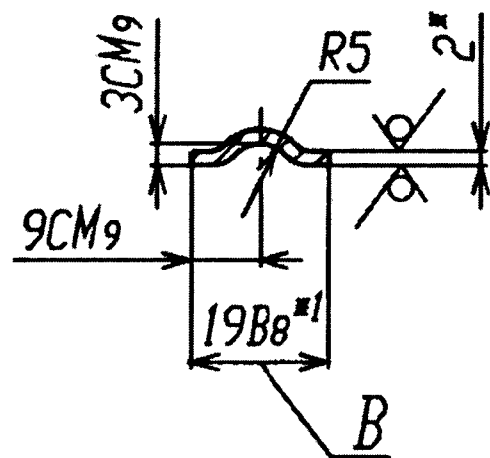


GOST
ГОСТ 5264-80-T1-Δ 2

1. Welding rod UONII 13/45-2.0 GOST 9466-75
2. * Reference dimension.
3. *1 Dimension B in blank.
4. Semi automatic welding in CO₂ medium is permissible by using filler wire 1.2 Sv 08G2S GOST 2246-70.
5. Radii 2 mm unless otherwise specified.
6. Blunt sharp edges ~0.6 mm.
7. Mark Ш, Ч and stamp K on tag.

A-A

Б



					AK-630 110-116			
Amend.	Sheet	Doc.No.	Sign	Date	Tie	Type	Weight	Scale
Developed by						A	0.110	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Sheet	BT - PN - 02GOST19904 - 90		
Approved by						K490V4 - III - 35GOST16523 - 97		

First use

Reference No.

Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

First use

Reference No.

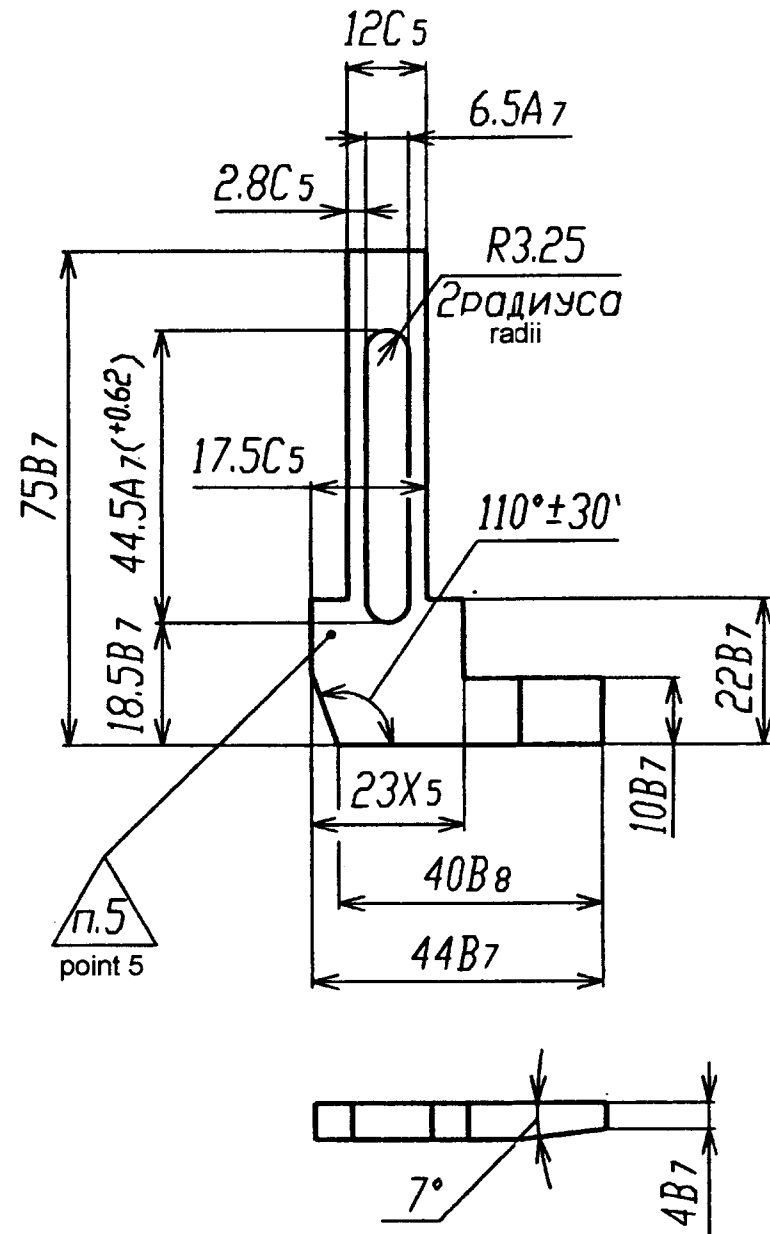
Sign and Date

Duplicate Inv. No

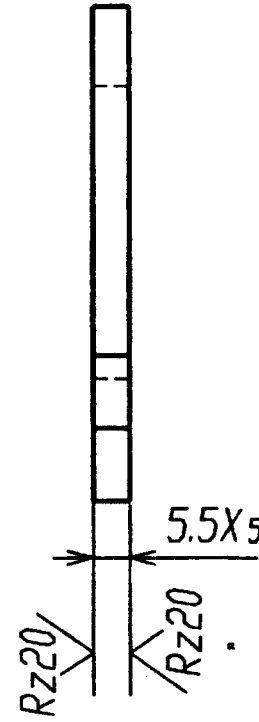
Inv. No

Sign and Date

Orig. inv. no.



Rz40 (✓)



1. Substitute material Sheet $\frac{B - PN - 8x1500x5000GOST19903 - 74}{35 - 2 - TGOST1577 - 93}$
2. Inner angles R~0.4 mm.
3. Blunt sharp edges ~0.4 mm.
4. Mark Ш, Ч on tag.
5. Stamp K as per AK-630, AK-630M TU I.

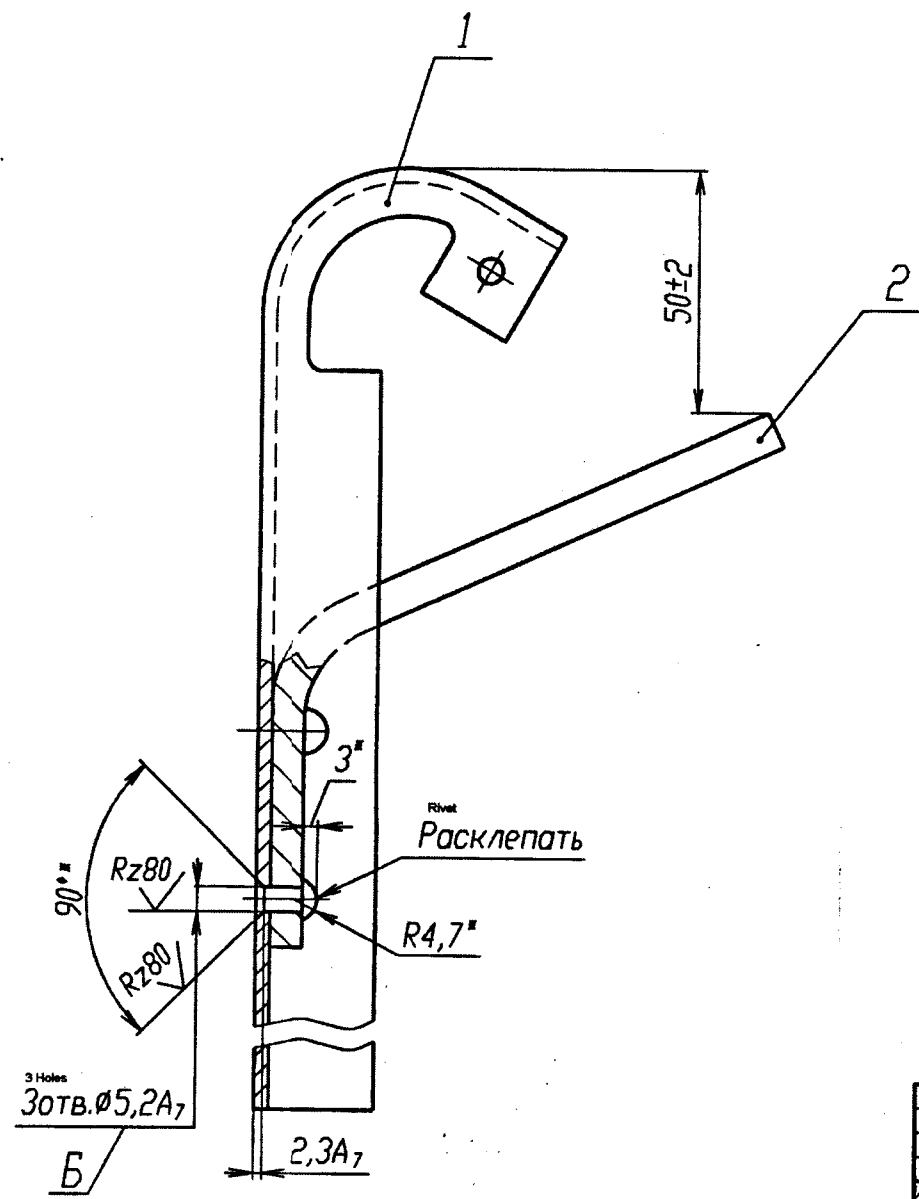
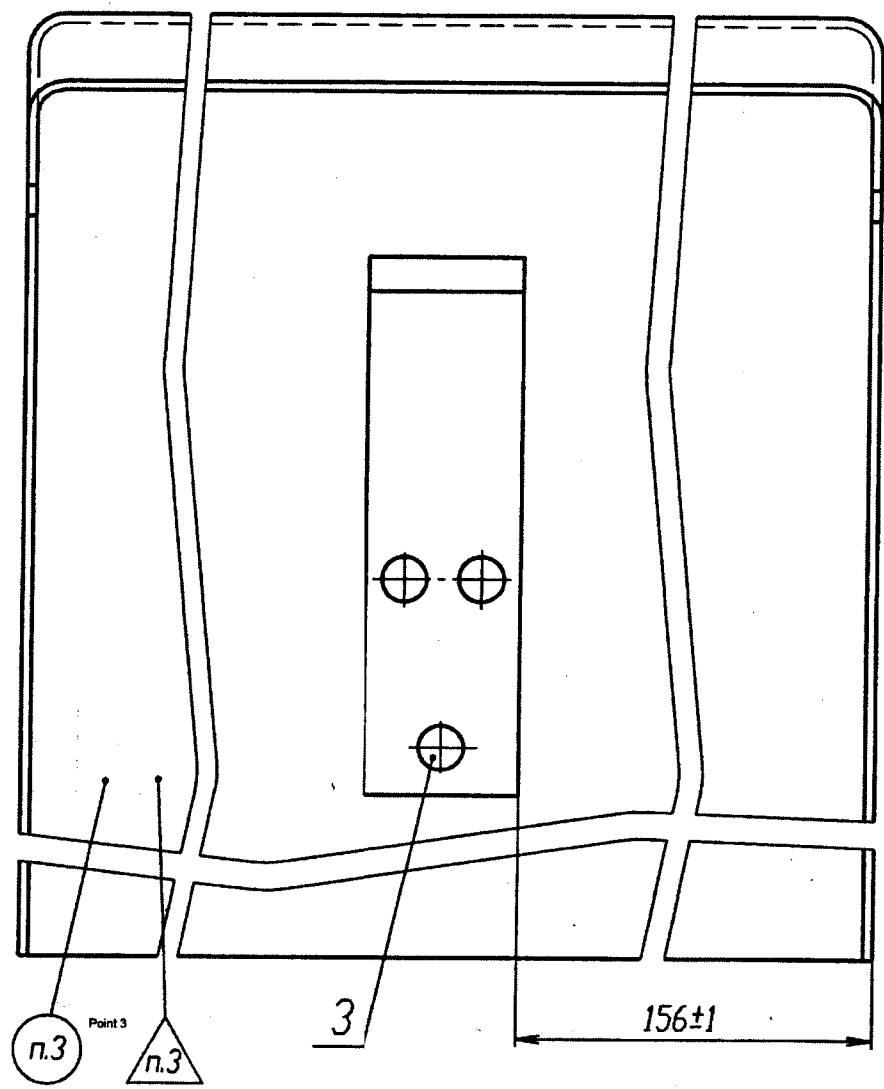
					AK-630M 01-190		
					Catch		
					Type	Weight	Scale
					A	0.065	1:1
					Sheet	Sheets 1	
					Sheet $\frac{B - PN - 6GOST19903 - 74}{35 - 2GOST1577 - 93}$		
Amend.	Sheet	Doc.No.	Sign	Date			
Developed by							
Checked by							
Head of Q.C.D							
Approved by							

Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks	
First use							
				<u>Documents</u>			
*)	/		AK-630M Sb 03-11 SB	Assembly drawing		*) A4 x 3	
Reference No.							
				<u>Components</u>			
*)	/	1	AK-630M 03-14	Partition	1	*) A4 x 3	
A3	/	2	AK-630M 03-50	Bracket	1		
				<u>Standard articles</u>			
		3		Rivet 5 x 18.03.15.029	3		
				GOST 10300-80			
Sign and Date							
Dupl. Inv. No.							
Alternate Inv. No.							
Sign and Date							
AK-630M Sb 03-11							
Amend.	Sheet	Doc. No.	Sign	Date			
Developed by					Type	Sheet	Sheets
Checked by					A		1
Head of Q.C.D					Partition		
Approved by							

AK-630M СБ03-11СБ

AK-630M Sb 03-11 SB

Пров. Голубинен.
Степанов
Полп. и Лото
Возм. Ив. Н. А. Св. Л.
Полп. и Лото
Ив. Н. Подп.



1. * - Dimensions are ensured by tool.
2. Drill hole B through hole B of component pos. 2.
3. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU 1.

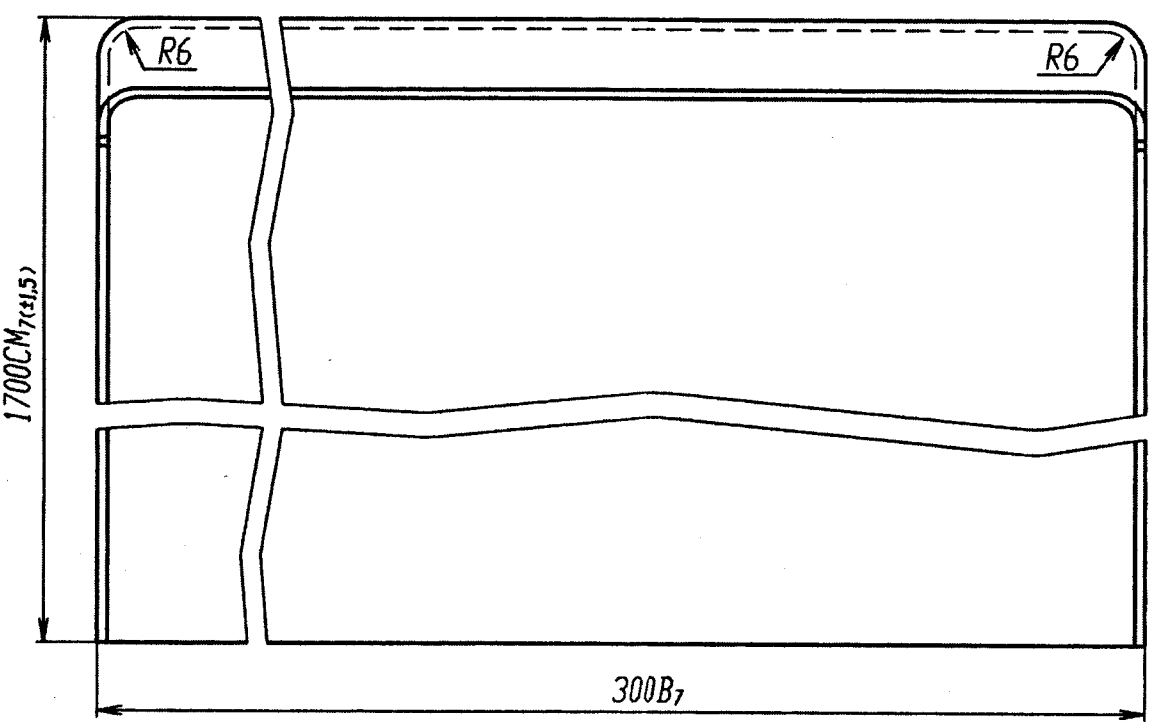
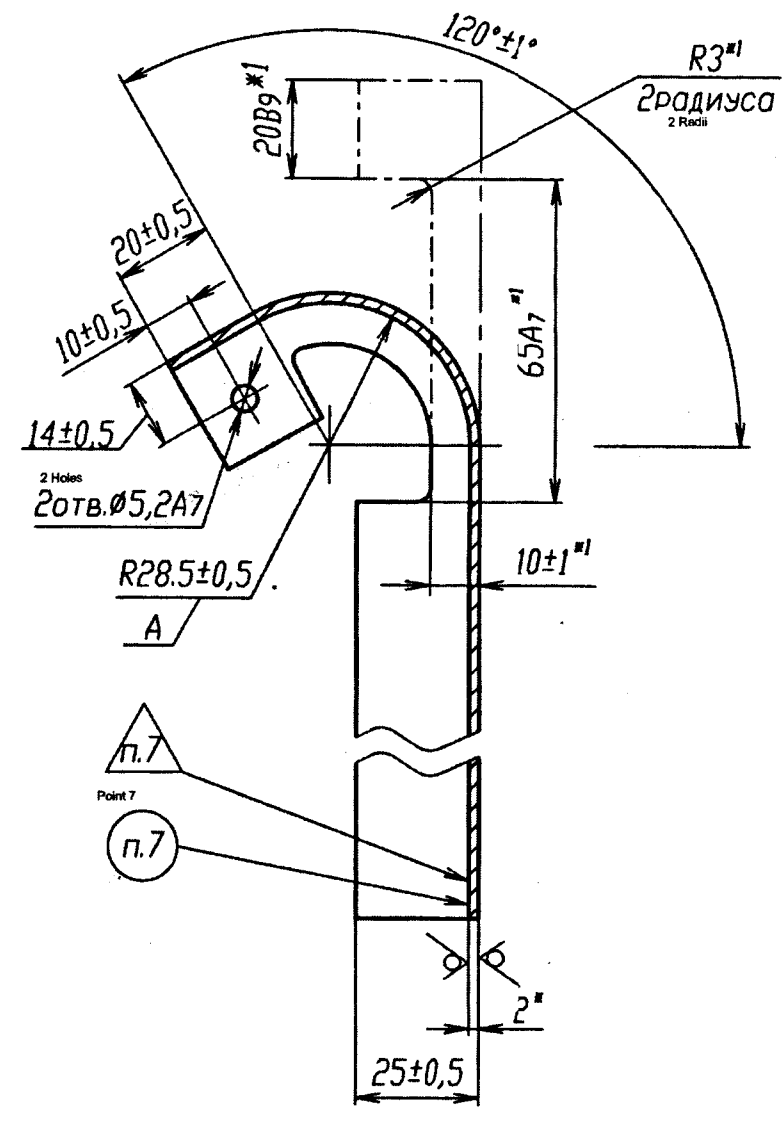
1. * Размеры обеспечиваются инструментом.
2. Отв. Б сверлить через отв. в дет. поз. 2.
3. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ 1.

				AK-630M Sb 03-11 SB		
				AK-630M СБ03-11СБ		
				Type	Mass	Scale
				Лит.	Масса	Масштаб
Изм./Лист	№ докум.	Подп.	Дата	Partition Перегородка Сборочный чертеж Assembly drawing		
Разраб.						
Пров.						
Т.контр.						
И.контр.						
Утв.				Лист	Листов	1
				Sheet	Total Sheets	

Формат А4х3

AK-630M 03-14

Rz160 ✓ (✓)



1. Material - substitute - Sheet AMg6 M-2 GOST 21631-76.
2. While bending along the radius A, the welding of cracks on flanging is permitted with filler electrode V. Sv AMg6. N 2.00xBT GOST 7871-75. From the external side, finish the joint with Rz 80 abraded with base metal.
3. * - Dimension for reference.
4. *1 - Dimensions for reaming.
5. Blunt the sharp edges ~ 0.4 mm.
6. Coating An. Ox. Chrome.
7. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

1. Материал-заменитель - лист АМг6 М-2 ГОСТ 21631-76.
2. При гибке по радиусу А допускается подварка трещин на отбортовке с применением присадочной проволоки В.Св АМг6. Н 2,00хБТ ГОСТ7871-75. С наружной стороны усиление шва зачистить Rz80 заодно с основным металлом.
3. * Размер для справок.
4. *1 Размеры для развертки.
5. Острые ребра притупить ~ 0,4 мм.
6. Покрытие Ан. Окс. хр.
7. Маркировать Ш,Ч и клеймить К по АК-630, АК-630М ТУ I.

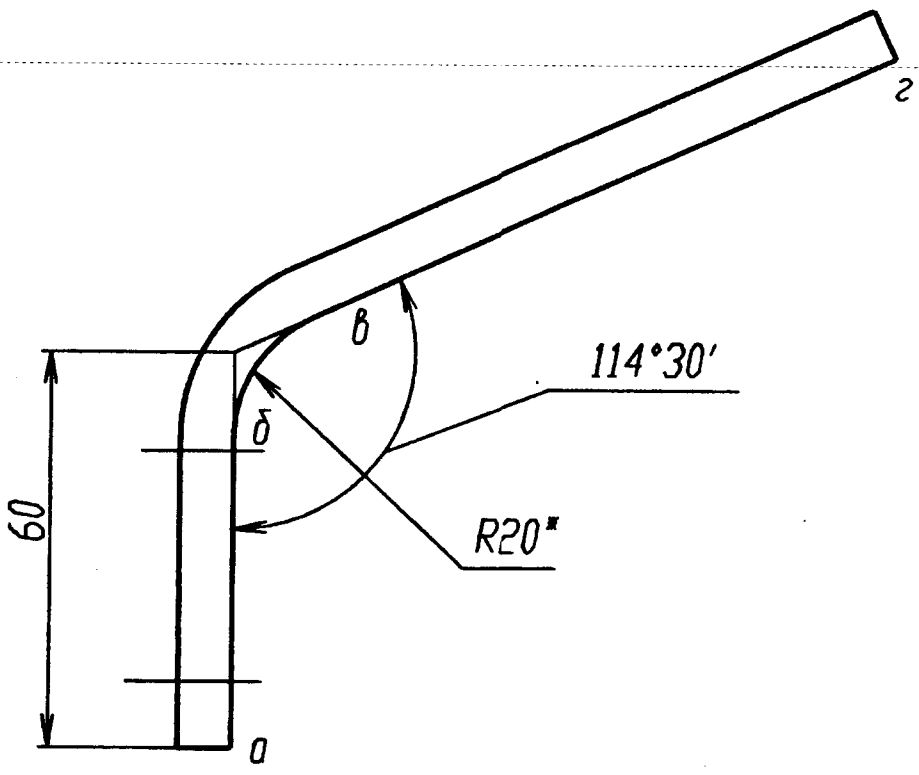
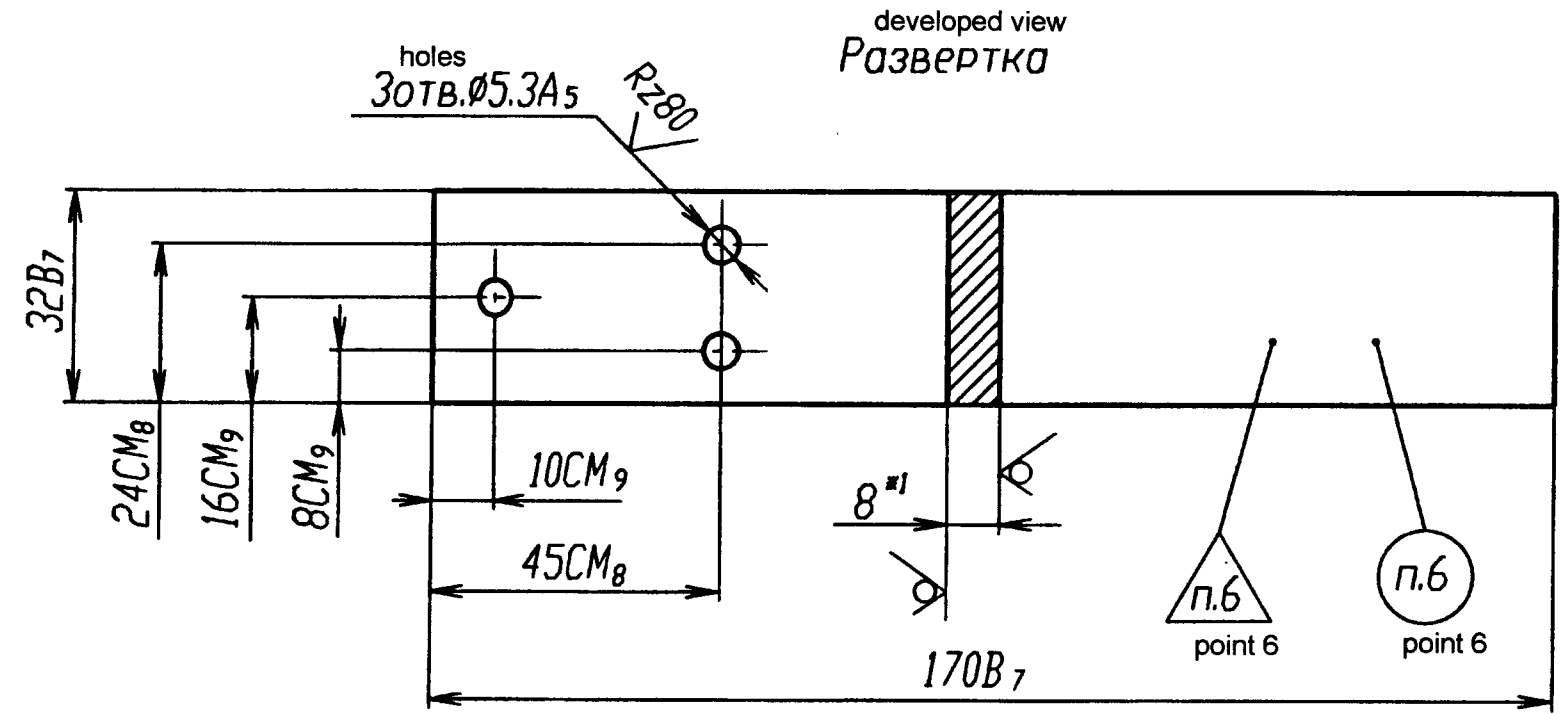
Перв. пометка
 Проверка
 Измен. дата
 Измен. дата
 Измен. дата
 Измен. дата

AK-630 M 03-14

				AK-630M 03-14		
				Type Mass Scale		
				Лит. Масса Масштаб		
				А 3,600 1:1		
				Лист Листов I		
				Type Total Sheets		
				Лист АМг6 М-2 ГОСТ 21631-76		
				Type Total Sheets		

Формат А4х3

Rz160 (✓)

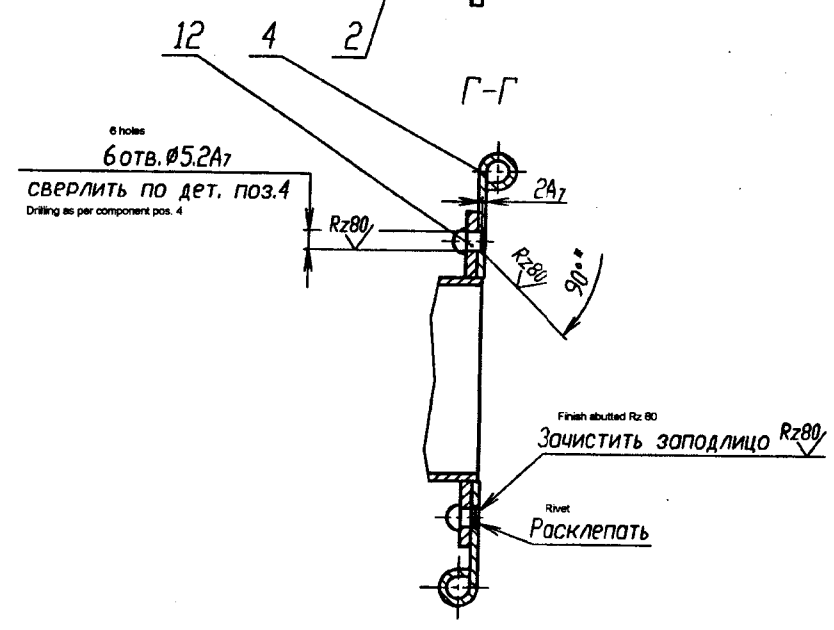
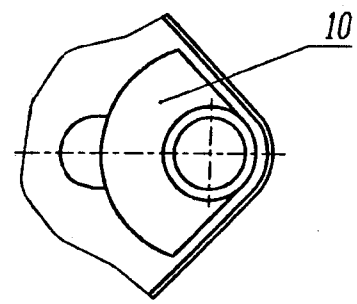
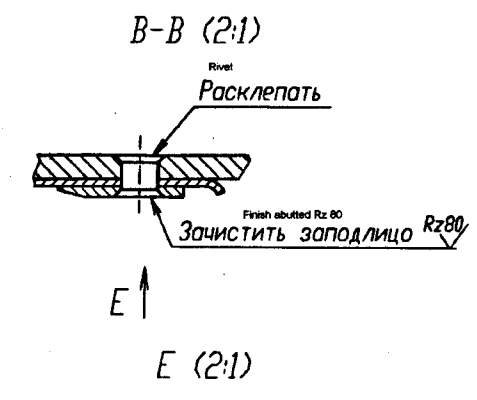
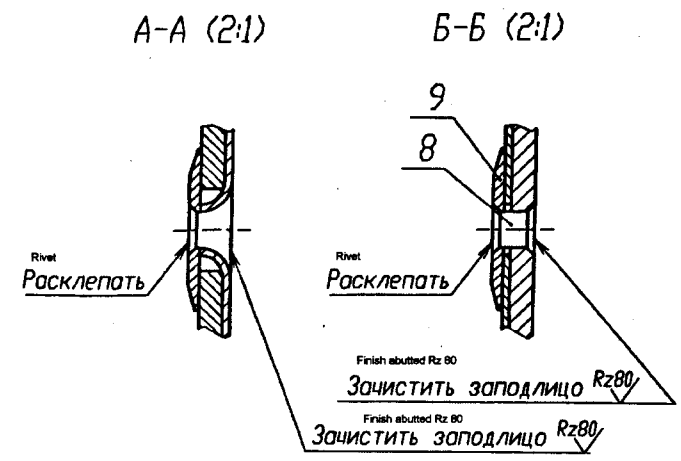
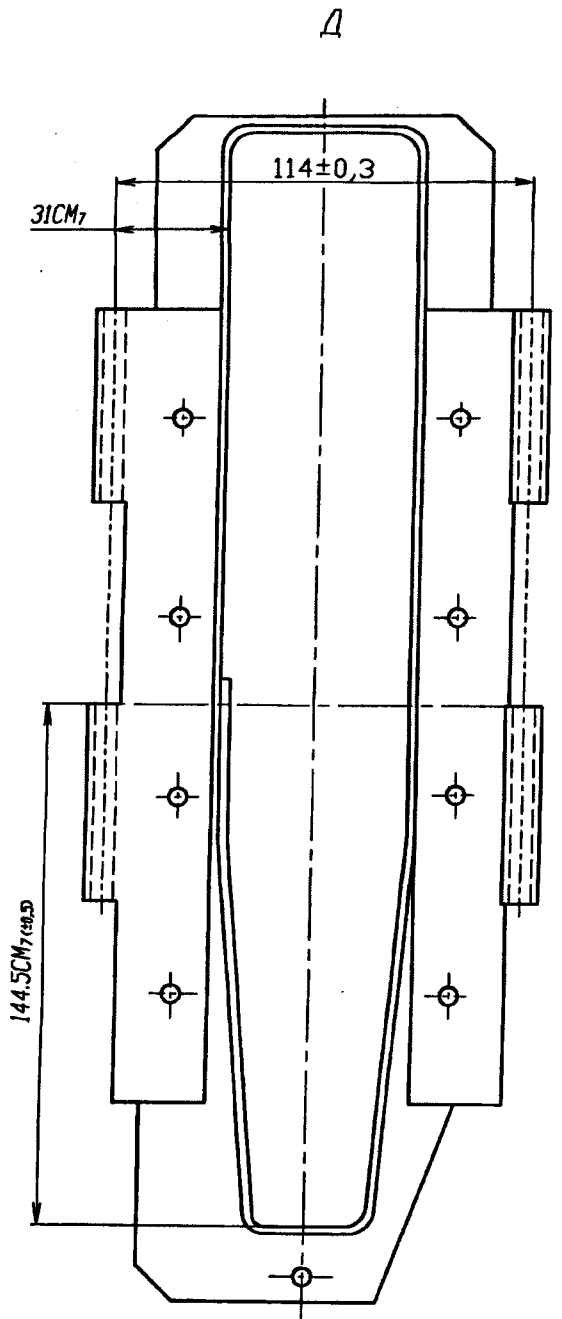
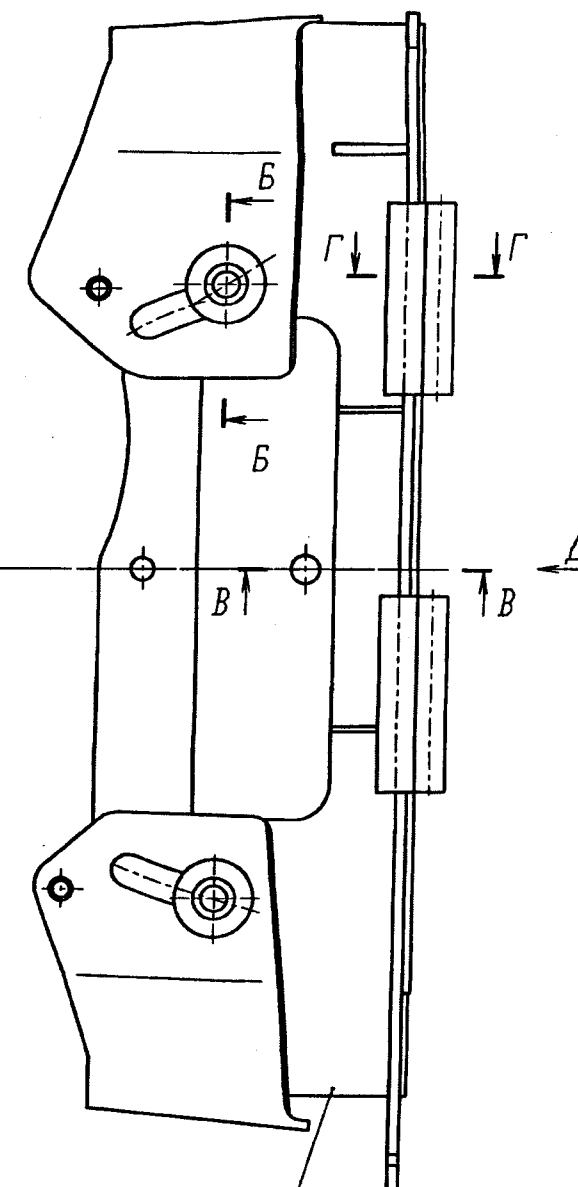
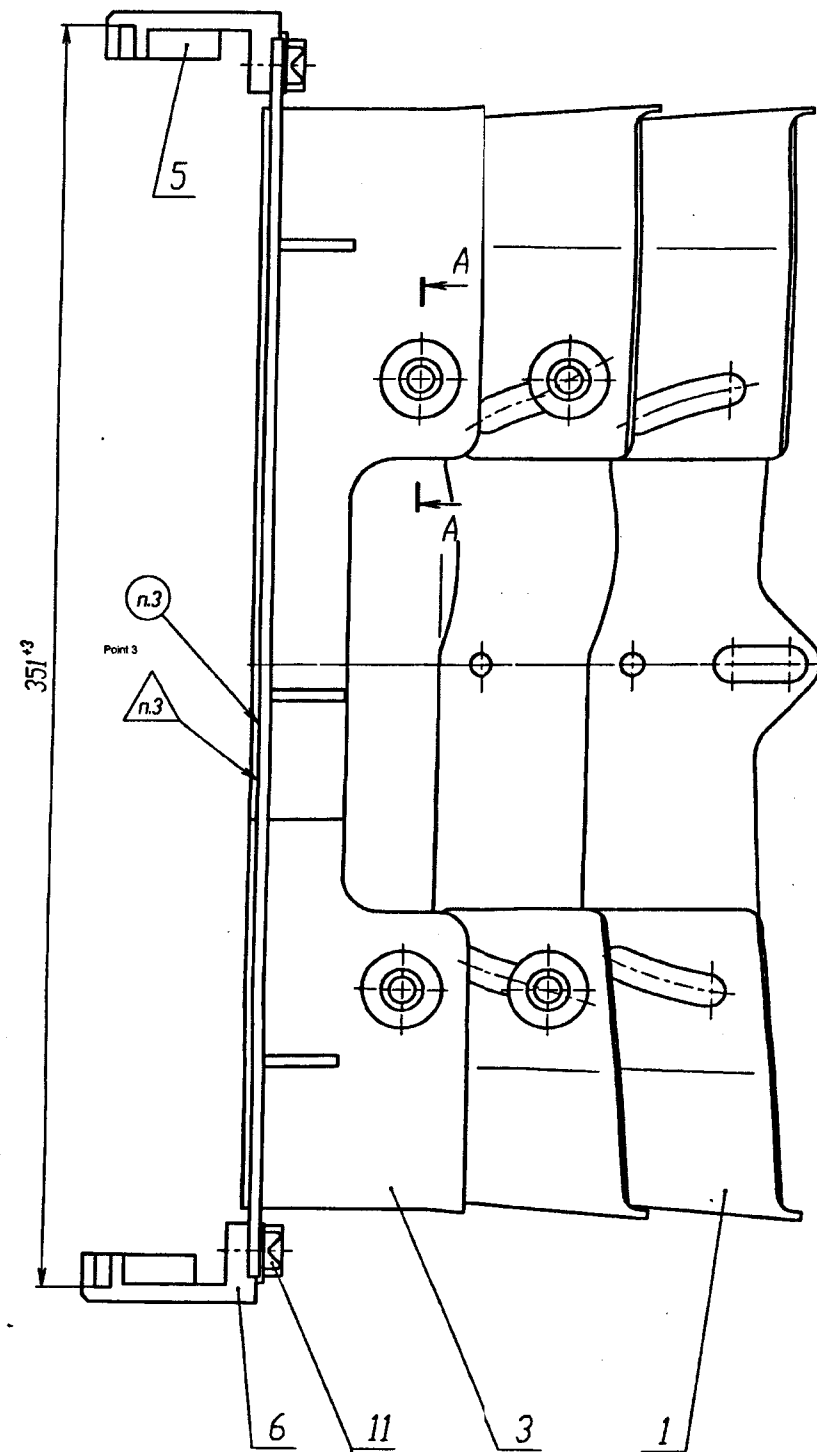


1. 28...37.5 HRC_E. Check hardness on 2% of the batch, but not less than 3 nos.
2. Tolerance of contour a6Br- 1 mm.
- 3.* Dimension ensured by tool.
- 4.*1 reference dimension.
5. Coating Cd.12.Cr.
6. Mark Ш,Ч and stamp K as per AK-630, AK-630M TU I.

Comment [S19]:

					AK-630M 03-50			
Amend.	Sheet	Doc.No.	Sign	Date	Bracket	Type	Weight	Scale
Developed by						A	0.260	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by					Sheet	B - PN - 8GOST19903 - 74 35 - TGOST1577 - 93		

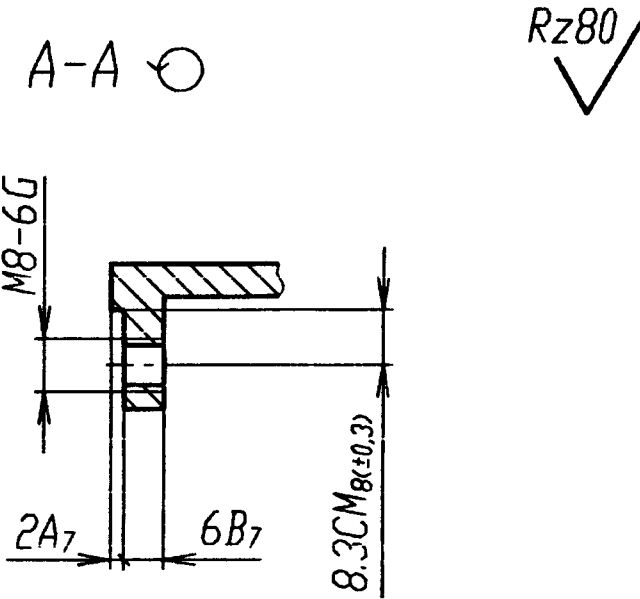
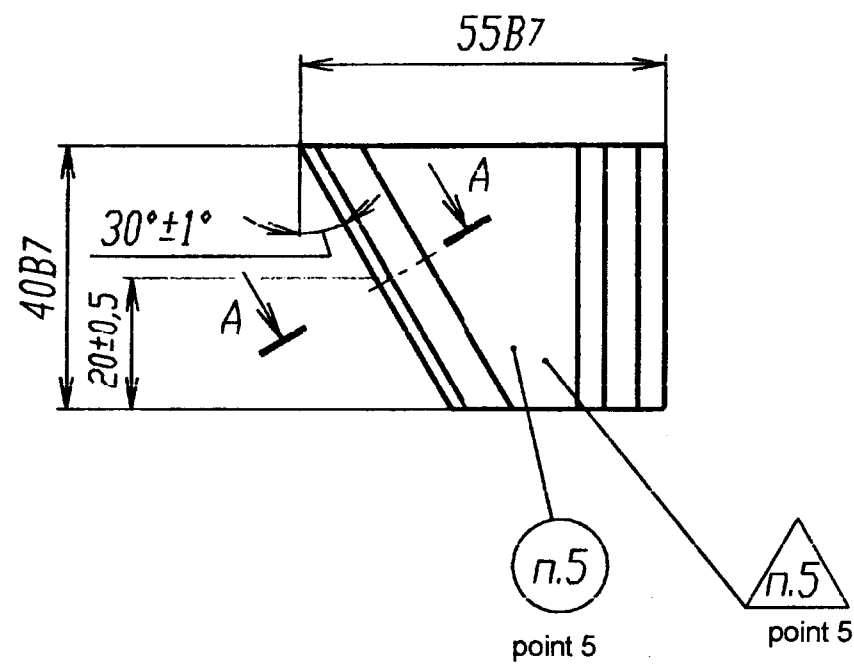
First use		Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks	
						<u>Documents</u>			
	A1	/			AK-630M Sb 03-2 SB	Assembly drawing			
Reference No.						<u>Assembly units</u>			
	A4	/		1	AK-630M Sb 03-7	Hose	1		
	A4	/		2	AK-630M Sb 03-12	Upper frame	1		
	A4	/		3	AK-630 Sb 107-9	Lower frame	1		
						<u>Components</u>			
	A3	/		4	AK-630M 03-21	Loop	2		
	A3	/		5	AK-630M 03-28	Bracket	1		
	A3	/		6	AK-630M 03-29	Bracket	1		
	A4	/		8	AK-630M 107-2-01	Rivet	6		
	A4	/		9	AK-630M 107-3	Washer	4		
	A4	/		10	AK-630M 107-4	Washer	1		
Sign and Date						<u>Standard articles</u>			
				11		Bolt M8-8gx12.109.40Kh.029	2	31-40.5	
						GOST 7798-70		HRC _E	
				12		Rivet 5 x 8.03.15.029	6		
						GOST 10299-80			
Dupl. Inv. No.									
Alternate Inv. No.									
Sign and Date						AK-630M Sb 03-2			
Orig. Inv. No.		Amend.	Sheet	Doc. No.	Sign	Date			
Sign and Date		Developed by					Type	Sheet	Sheets
Sign and Date		Checked by					A	1	2
Sign and Date		Head of Q.C.D					Hose		
Sign and Date		Approved by							



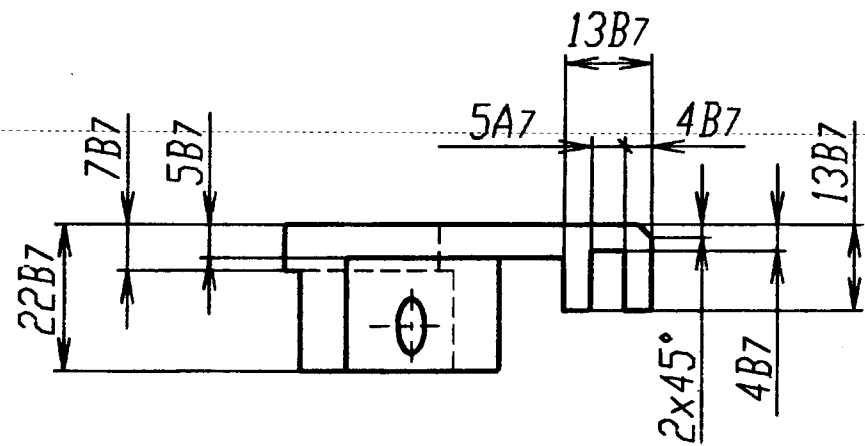
- 1. *1 - Dimension is ensured by tool.
- 2. Projection of rivet pos. 8 is not permitted.
- 3. Mark Ш, Ч and stamp К as per АК-630, АК-630М ТУ I.

- 1. *1 Размер обесп. инстр.
- 2. Выступание заклепок поз.8 не допускается.
- 3. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ I.

AK-630M SB 03-2 SB				AK-630M СБ03-2СБ		
Изм./Лист	№ док-м.	Подп.	Дата	Лит.	Масштаб	Масштаб
Разраб.				А	17,0	1:1
Проб.				Лист 1 из 1		
Контр.				Sheet 1 of 1		
Исполн.				Formet AI		
ВТВ.						



1. Substitute material- Steel 50A OST 3-98-80.
2. Inner angles R~0.4 mm.
3. Blunt sharp edges ~0.4 mm.
4. Coating Cd12.phos.
5. Mark Ш, Ч and stamp K, И as per AK-630, AK-630M TU I



Comment [S12]:

					AK-630M 03-28			
Amend.	Sheet	Doc.No.	Sign	Date	Bracket	Type	Weight	Scale
Developed by						A	0.115	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Steel 50 GOST 1050-88			
Approved by								

First use

Reference No.

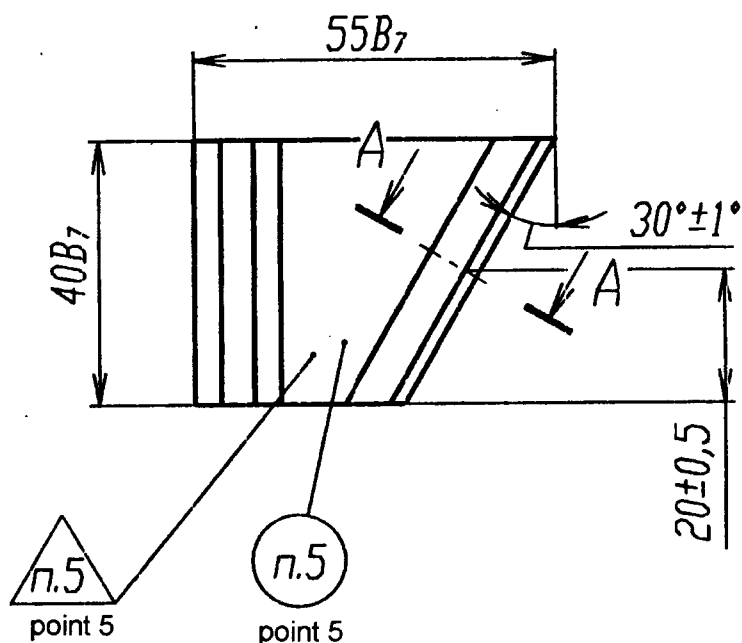
Sign and Date

Duplicate Inv. No

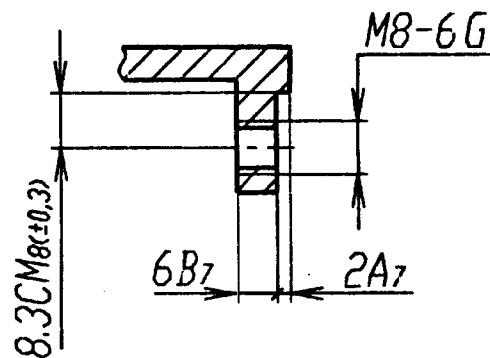
State Inv. No

Sign and Date

Orig. inv. no.

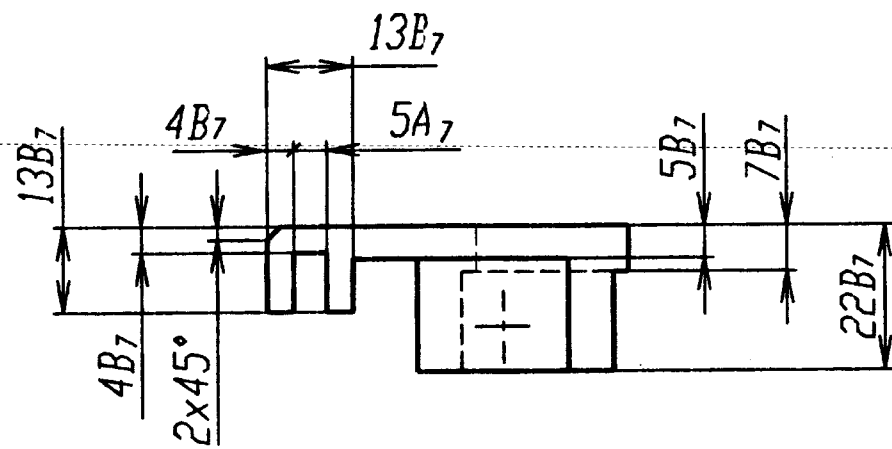


A-A



Rz80

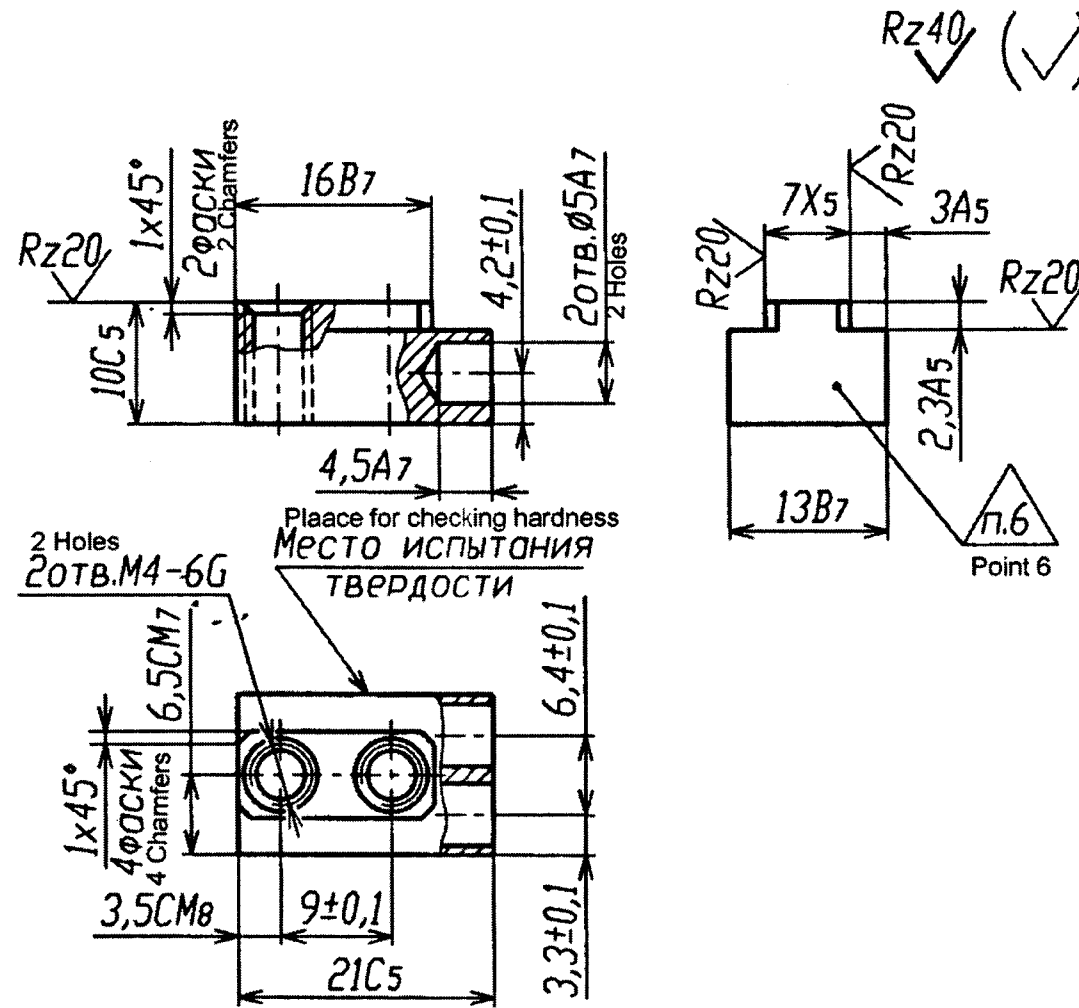
1. Substitute material- Steel 50A OST 3-98-80.
2. Inner angles R~0.4 mm.
3. Blunt sharp edges ~0.4 mm.
4. Coating Cd12.phos.
5. Mark Ш, Ч and stamp K, И as per AK-630, AK-630M TU I



Comment [S13]:

					AK-630M 03-29			
Amend.	Sheet	Doc.No.	Sign	Date	Bracket	Type	Weight	Scale
Developed by						A	0.115	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Steel 50			
Approved by					GOST 1050-88			

AK-630 103-21



1. 38.5...44.5 HRC_E.
2. Inner angles R ≈ 0.4 mm.
3. Blunt sharp edges ≈ 0.4 mm.
4. Coating Cd 6.phos.Oil. It is permissible to avoid cadmium plating of holes.
5. Mark Ш, Ч and stamp K on tag.
6. Stamp И as per AK-630, AK-630M TU I.

Approved by shop					Reference No.					First use																			
Approved KTONI					Sign and Date					Approved TOsb																			
Alternate Inv. No.					Dupl. Inv. No.					Sign and Date																			
Approved OGMet					Sign and Date					AK-630 103-21																			
Orig. Inv. No.					Amend.	Sheet	Doc. No.	Sign	Date	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 30%;"></td> <td style="width: 10%; text-align: center;">Type</td> <td style="width: 15%; text-align: center;">Weight</td> <td style="width: 45%; text-align: center;">Scale</td> </tr> <tr> <td style="text-align: center;">Stop</td> <td style="text-align: center;">A</td> <td style="text-align: center;">0.015</td> <td style="text-align: center;">2:1</td> </tr> <tr> <td colspan="2" style="text-align: center;">Sheet</td> <td colspan="2" style="text-align: center;">Sheets 1</td> </tr> <tr> <td colspan="4" style="text-align: center;">Steel 50 GOST 1050-88</td> </tr> </table>					Type	Weight	Scale	Stop	A	0.015	2:1	Sheet		Sheets 1		Steel 50 GOST 1050-88			
	Type	Weight	Scale																										
Stop	A	0.015	2:1																										
Sheet		Sheets 1																											
Steel 50 GOST 1050-88																													

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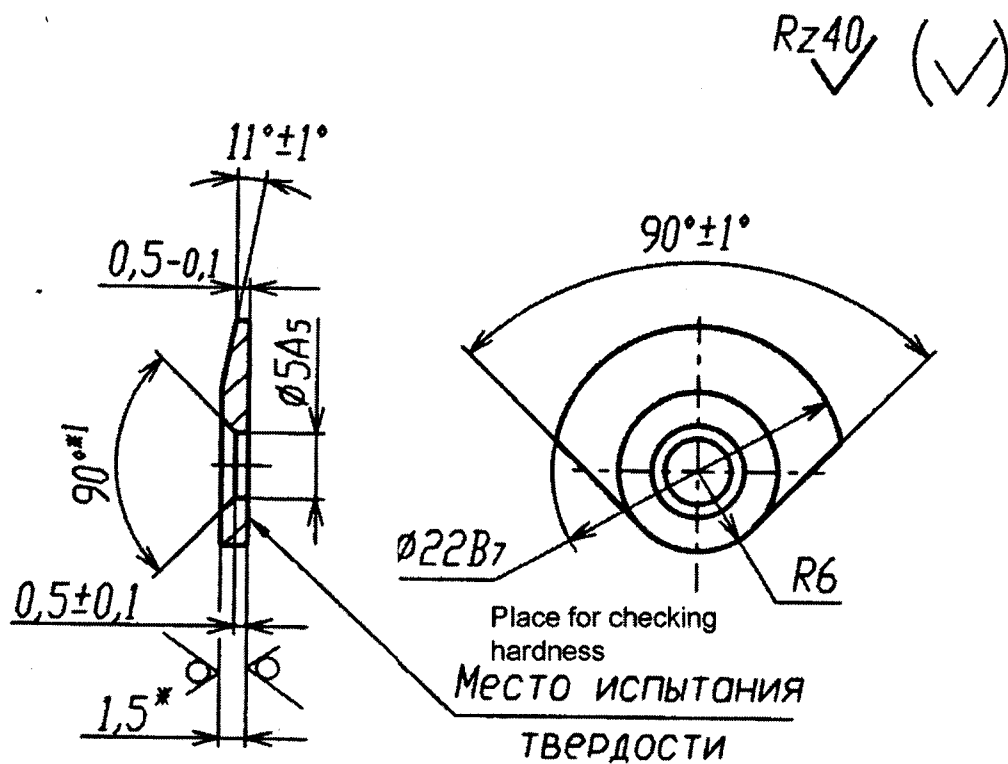
AK-630 107-3																	
Approved by shop	Reference No.																
Approved KTONI	Sign and Date																
Approved TOsb	Dupl. Inv. No.	<p>1. 29...35.0 HRC_E . Check hardness on 3..5% of the batch but not less than 3 nos. 2. * Reference dimension. 3. *1Dimensions ensured by tool. 4. Blunt sharp edges R~0.2 mm. 5. Coating Cd12.Cr. 6. Mark Ш, Ч and stamp K on tag. 7. It is permissible to make by cold extrusion from sheet</p> <p><u>BT - PN - 01.5 GOST 19904 - 90</u> <u>K 490V 4 - III - 40 GOST 16523 - 97</u></p>															
Alternate Inv. No.	Sign and Date																
Approved OGMet	Orig. Inv. No.			AK-630 107-3													
Amend.	Sheet	Doc. No.	Sign	Date	<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width: 30%;"></td> <td style="width: 10%;">Type</td> <td style="width: 10%;">Weight</td> <td style="width: 10%;">Scale</td> </tr> <tr> <td style="text-align: center;">Washer</td> <td style="text-align: center;">A</td> <td style="text-align: center;">0.005</td> <td style="text-align: center;">2:1</td> </tr> <tr> <td colspan="2">Sheet</td> <td colspan="2">Sheets 1</td> </tr> </table>		Type	Weight	Scale	Washer	A	0.005	2:1	Sheet		Sheets 1	
	Type	Weight	Scale														
Washer	A	0.005	2:1														
Sheet		Sheets 1															
Developed by																	
Checked by																	
Head of Q.C.D																	
Design bureau chief																	
Head of Q.C.D																	
Approved by																	
Sheet <u>BT - PN - 01.5 GOST 19904 - 90</u> <u>K 490V 4 - III - 40 GOST 16523 - 97</u>																	

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Format A4

AK-630 107-4

Approved by shop Reference No. First use
 Approved KTONI
 Approved TOSb Dupl. Inv. No. Sign and Date
 Approved OGMet Orig. Inv. No. Sign and Date



Rz40 (✓)

1. 29...35.0 HRC_E. Check hardness on 3..5% of the batch but not less than 3 nos.
2. * Reference dimension.
3. *1 Dimensions ensured by tool.
4. Blunt sharp edges R~0.2 mm.
5. Coating Cd12.Cr.
6. Mark Ш, Ч and stamp К, И on tag.

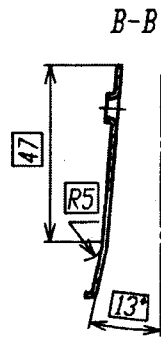
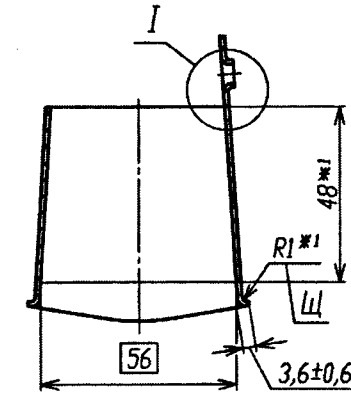
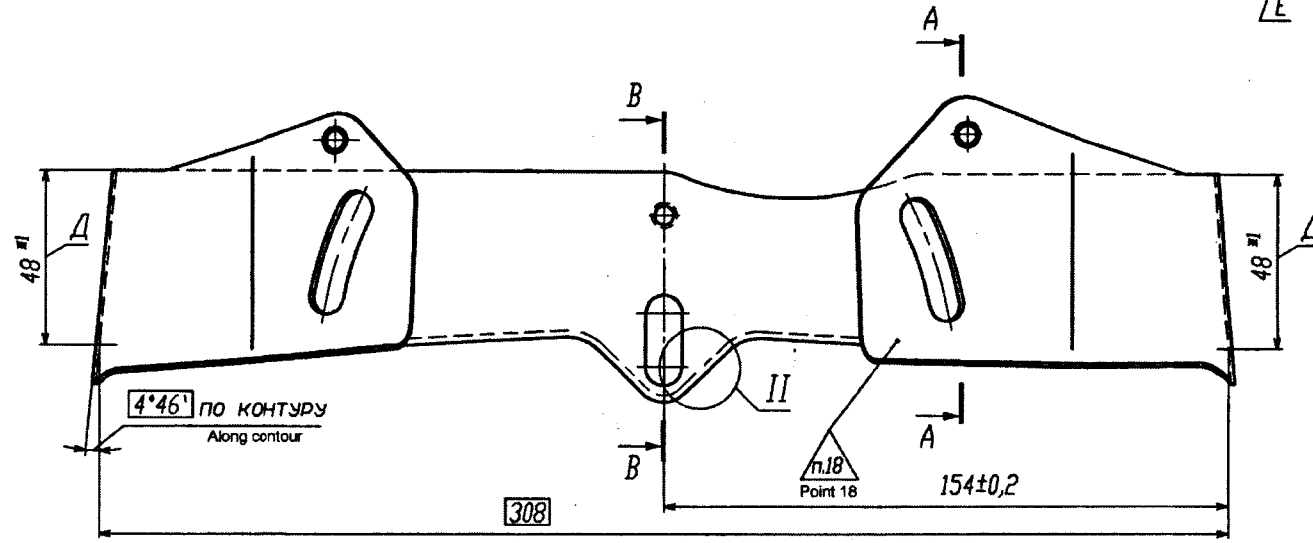
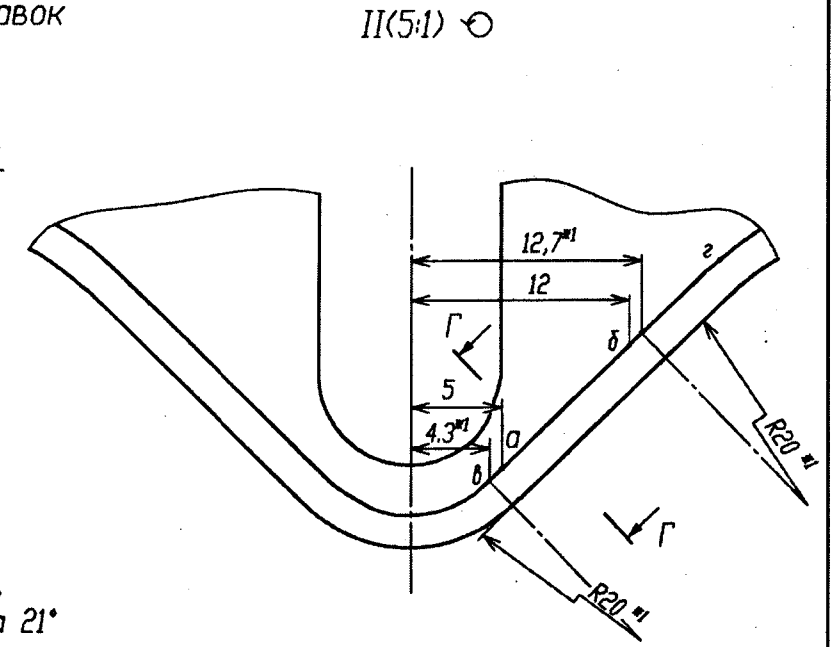
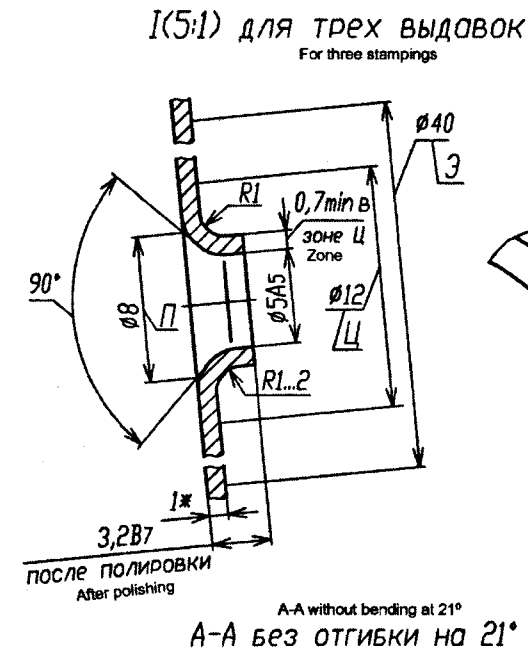
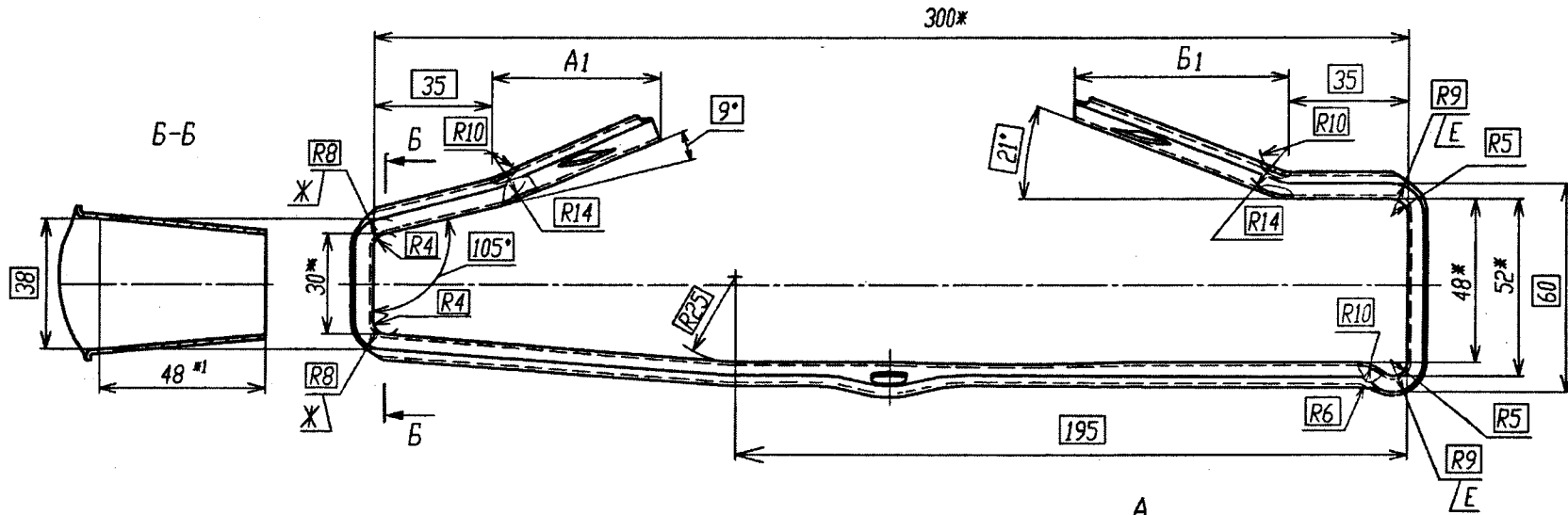
Amend.	Sheet	Doc. No.	Sign	Date

AK-630 107-4			
Type	Weight	Scale	
Washer	A	0.003	2:1
Sheet		Sheets 1	
Sheet $\frac{BT - PN - 01.5 GOST 19904 - 90}{K490V 4 - III - 40 GOST 16523 - 97}$			

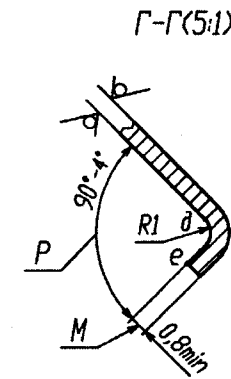
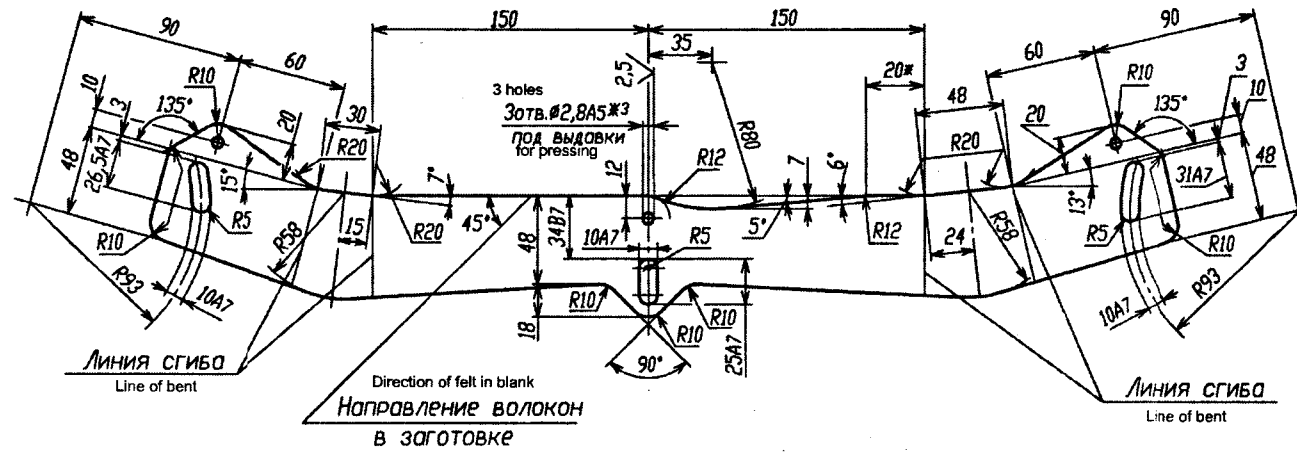
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Рис. 1
Draw. 1

Rz80 (✓) (✓)



Q, (1:2)

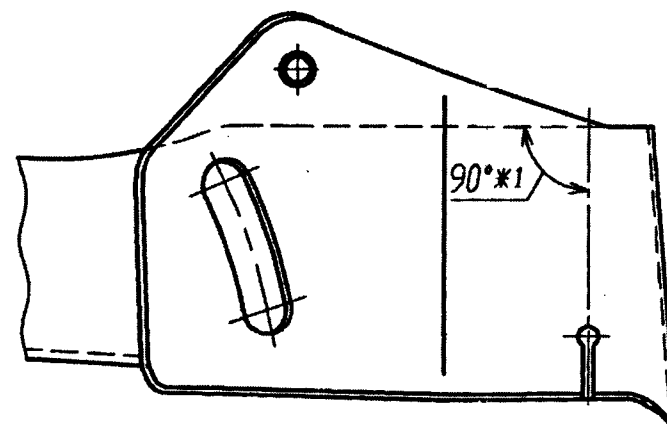
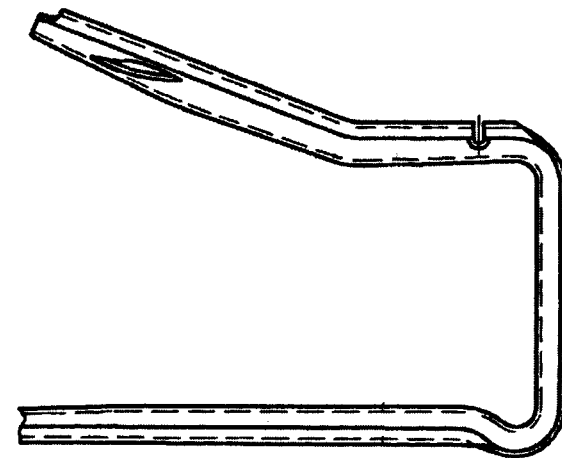


1. * Reference dimensions.
2. *Dimensions are ensured by tool.
3. *It is permissible to select technological dimension with conditions satisfying extrusion of dimensions (refer reference element I)
4. Frame should not have dents, nicks, cracks, burrs on surfaces.
5. Tolerance on contour blank 0.3 mm.
6. On dimension Д - radii E and ИЖ.
7. Angle P should be ensured by tool on section "ad".
8. Smooth transition on screen "ab" and "d2" should be as per standard.
9. Dimension M on section "de" should be not less than 0.8 mm.
10. Blunt sharp edge ≈ 0.2 mm.
11. Limit deviation on displacement of hole axis from minimum position should not be more than 0.3 mm (qualified).
12. Increase of dimension not more than Ø 8.5 mm is permissible.
13. Increase of dimension Л not more than R 2.5 mm at places of overbend is permissible.
14. Non flatness in zone 3 should not be more than 0.2 mm.
15. Component is shown in measuring position. Tolerance on draft of given □ surface T 0.8 mm. Increase of tolerance on draft of given □ surface up to T 2 mm on section A1, b1 is permissible. Check with slot type gauge. Insert gauge should be in conformity with inner contour of components, and should freely release up to surface base with force ≤ 490N (50 KgF) during checking.
16. Coating: Hard lubricant VN11NP-212 TU 38-101594-80 on inner surfaces. Falling of lubricant on outer surface is permissible.
17. Mark Ш, Ч and stamp K on tag.
18. Stamp Ик as per AK-630, AK-630M Tu1.

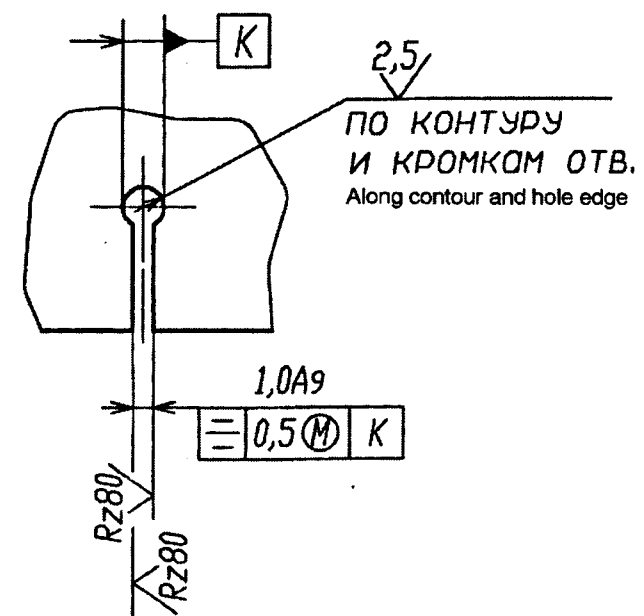
Designation	Draw
107-30	1
107-30-01	2

AK - 630 107 - 30				30-01		
Amend Sheet	Doc. No.	Sign	Date	Type	Weight	Scale
Developed by				Frame	A	0.240 1:1
Checked by				Sheet	Sheets 2	
Technician				Sheet BT-PN-1-GOST 19904-90		
Head of bureau				20Kh13N4G9-N1 GOST 5582-75		
Head of Q.C.D.						
Approved by						

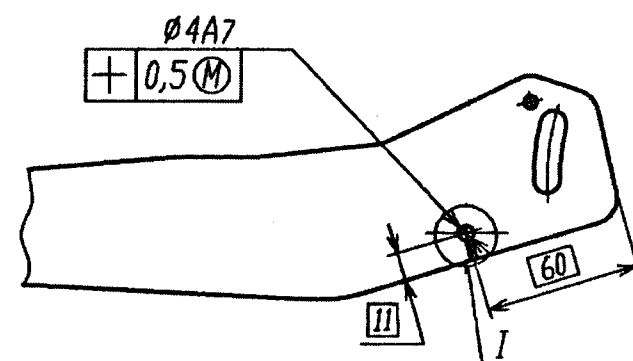
Рис. 2
 Drawing 2
 Остальное - см. Рис. 1 (лист 1)
 Remaining - refer rawing 1 (Sheet 1)



I(2:1)



Q, (1:2)



Inv. No.	Sign & Date	Alternate Inv. No.	Duplicate Inv. No.	Sign & Date	Reference No.	First rear

Amend	Sheet	Doc. No.	Sign	Date

AK-630 107-2

First use

Approved by shop
Reference No.

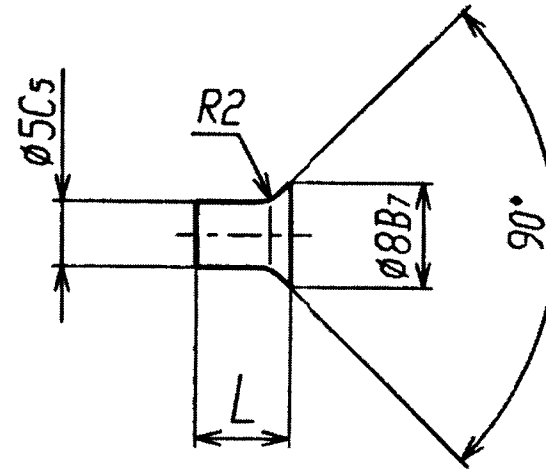
Approved KTONI
Sign and Date

Approved TOSb
Alternate Inv. No. Dupl. Inv. No.

Sign and Date

Approved OGMet
Orig. Inv. No.

Rz40 ✓



Designation	L, mm	Weight, kg
AK-630 107-2	5.7 C ₅ (-0.16)	0.001
-01	7 C ₅ (-0.2)	0.001
-02	12 C ₅	0.002
-03	16 C ₅	0.003

1. Substitute material –Steel 12Cr18Ni10Ti GOST 5632-72.
2. Blunt sharp edges R~0.2 mm.
3. Mark Ш, Ч and stamp K on tag.
4. Other technical requirements as per GOST 10304-80.

Amend.	Sheet	Doc. No.	Sign	Date

AK-630 107-2

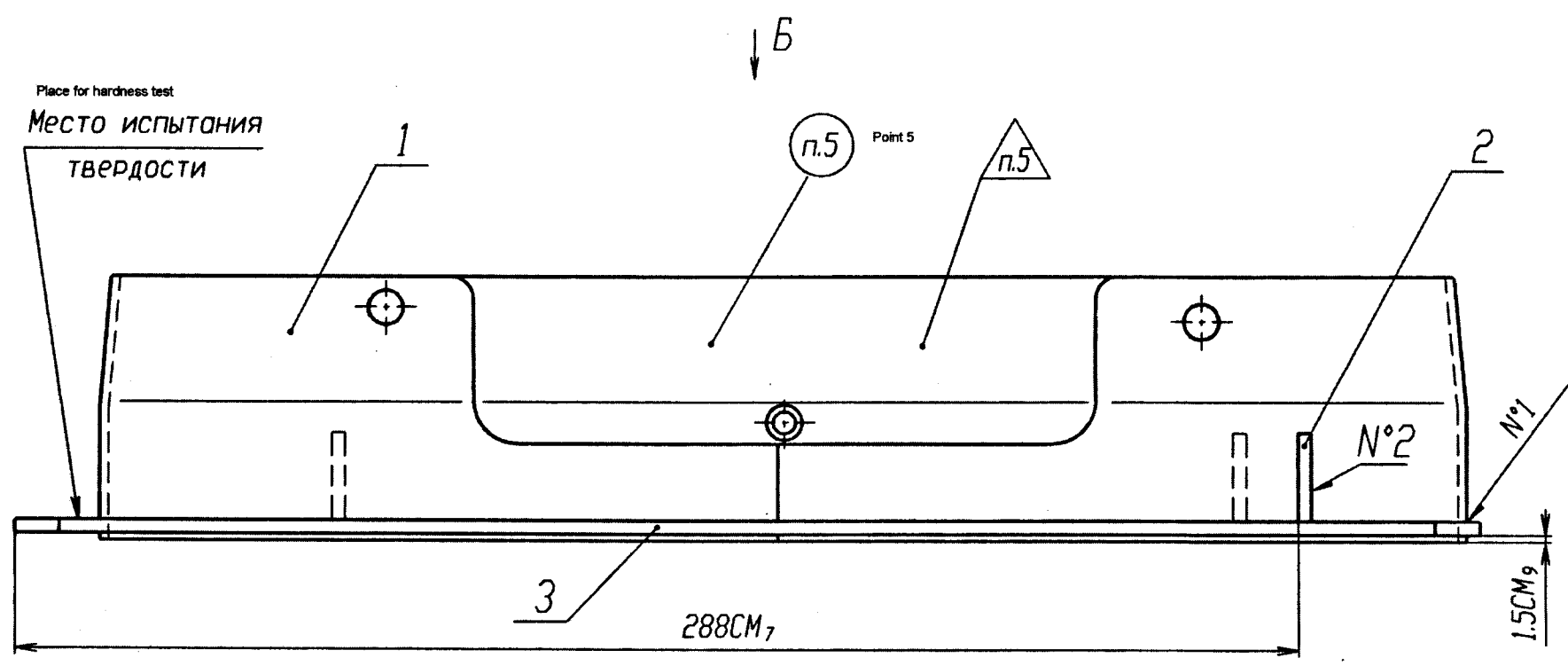
Rivet

Steel 12Cr18Ni9Ti
GOST 5632-72

Type	Weight	Scale
A		2:1
Sheet		Sheets 1

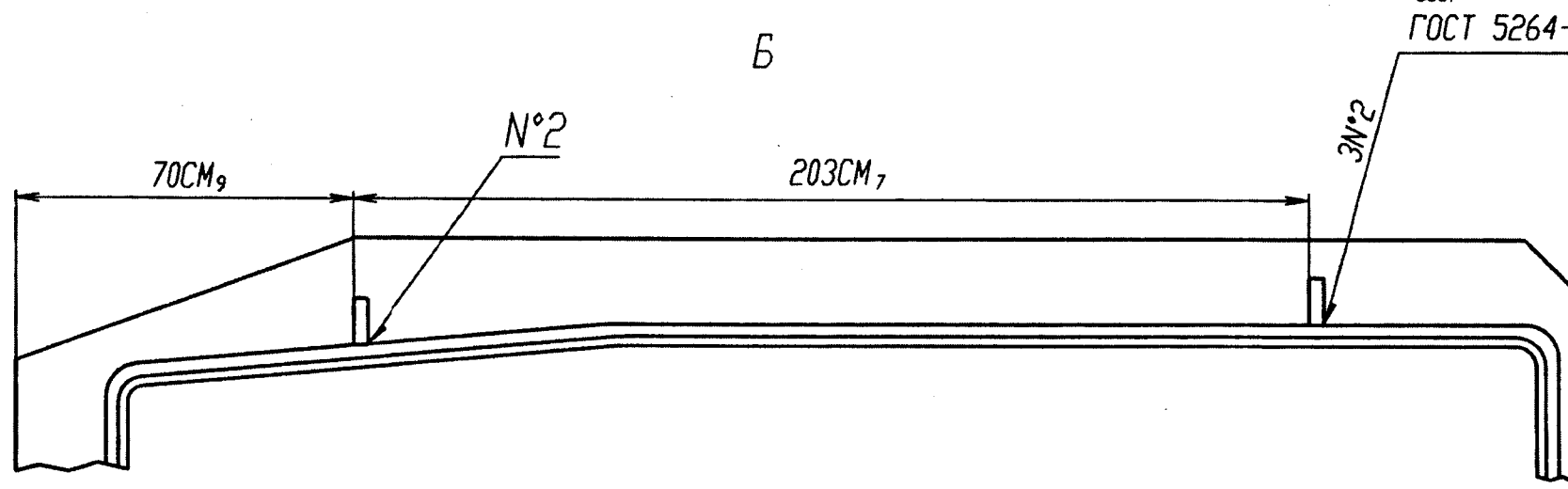
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ГОСТ 5264-80-T1-Δ 2

1. Electrode UONII - 13/45-2.0-3 GOST 9466-75.
Semi-automatic welding in the medium of carbonic acid gas with the use of filler electrode 1.2 Sv - 06 G 2S GOST 2246-70 is permitted.
2. 29...35.0 HRC ε. At the place for hardness test, the finishing up to 0.5 mm is permitted.
3. After the welding, normalize the assembly.
4. Coating: cad. 12 phos. followed by oil treatment.
Varnish BF-4 with nigrogine, 1 layer,
preparation as per OST 3-4123-78.IV.OM2.
5. Mark Ш, Ч and stamp К, И as per AK-630, AK-630M TU I.

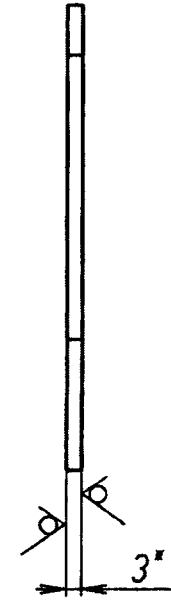
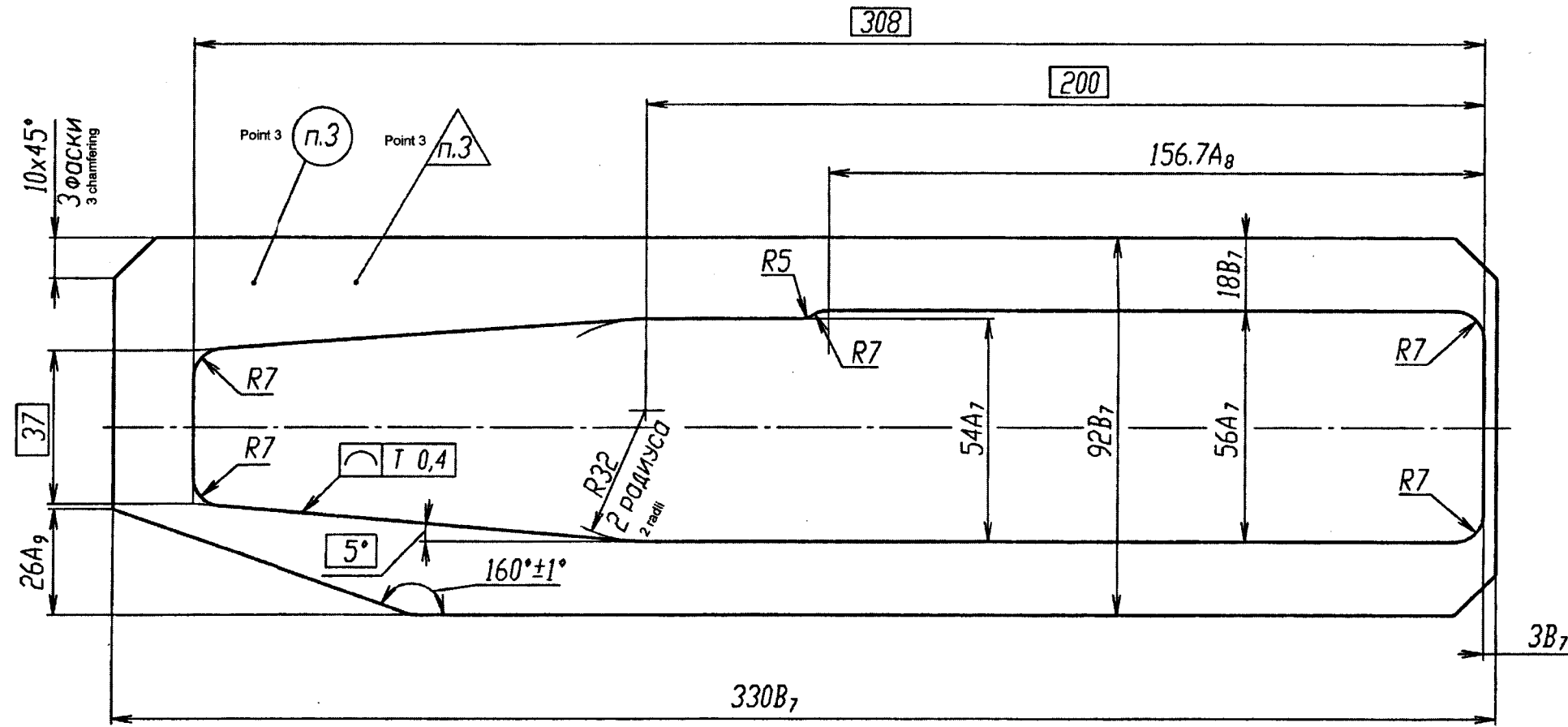


ГОСТ 5264-80-T1-Δ 2

1. Электрод УОНИИ 13/45-2.0-3 ГОСТ 9466-75.
Допускается полуавтоматическая сварка в среде углекислого газа с применением присадочной проволоки 1,2 Св-0 8Г2С ГОСТ 2246-70.
2. 29...35,0 HRC_ε. В месте замера твердости допускается зачистка до 0,5 мм.
3. После сварки сборку нормализовать.
4. Покрытие Кд12. фос. прп.
Лак БФ-4 с нигрозином, 1 слой,
приготовление по ОСТ 3-4123-78.IV.OM2.
5. Маркировать Ш, Ч и клеймить К, И по АК-630, АК-630М ТУ 1.

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Изм/Лист	№ докум.	Подп.	Дата	Лит.	Масса	Листов
Разраб.				А	0,630	1/1
Пров.						
Т.контр.						
И.контр.						
Утв.						
Lower Frame Assembly drawing				Лист	Листов 1	
				Sheet	Total Sheets	



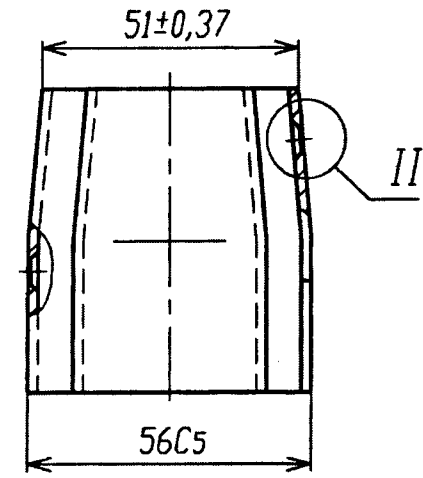
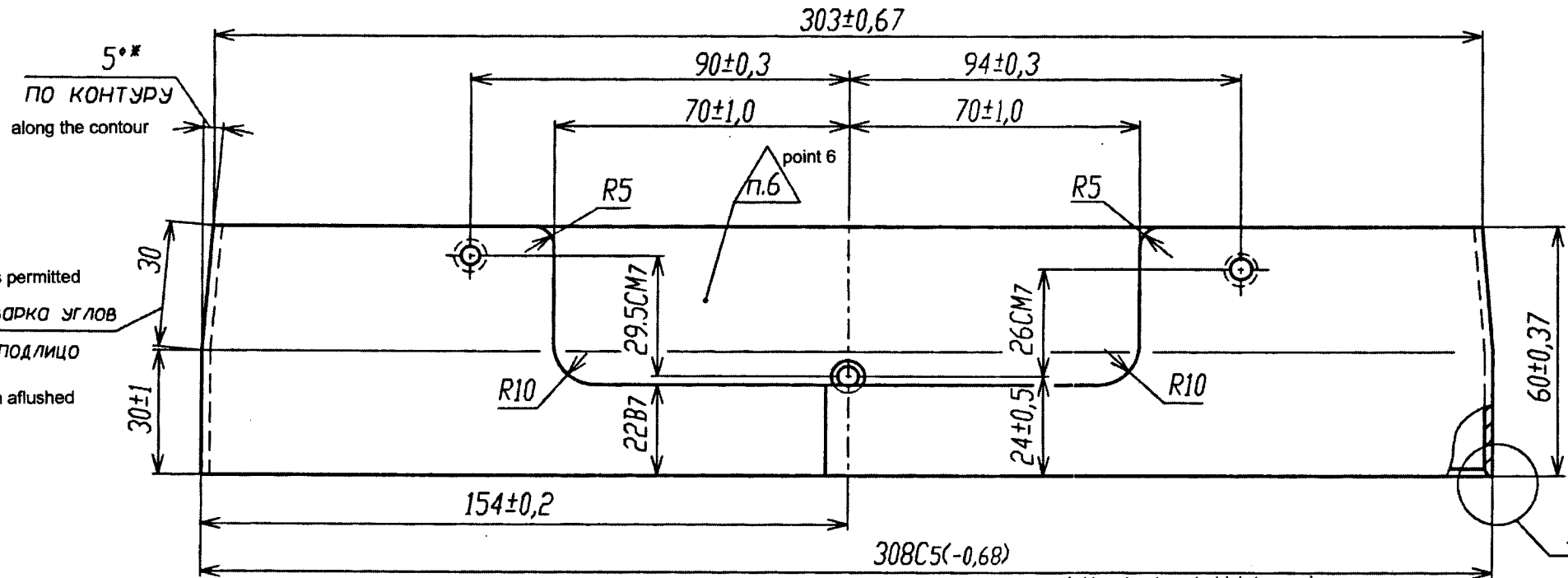
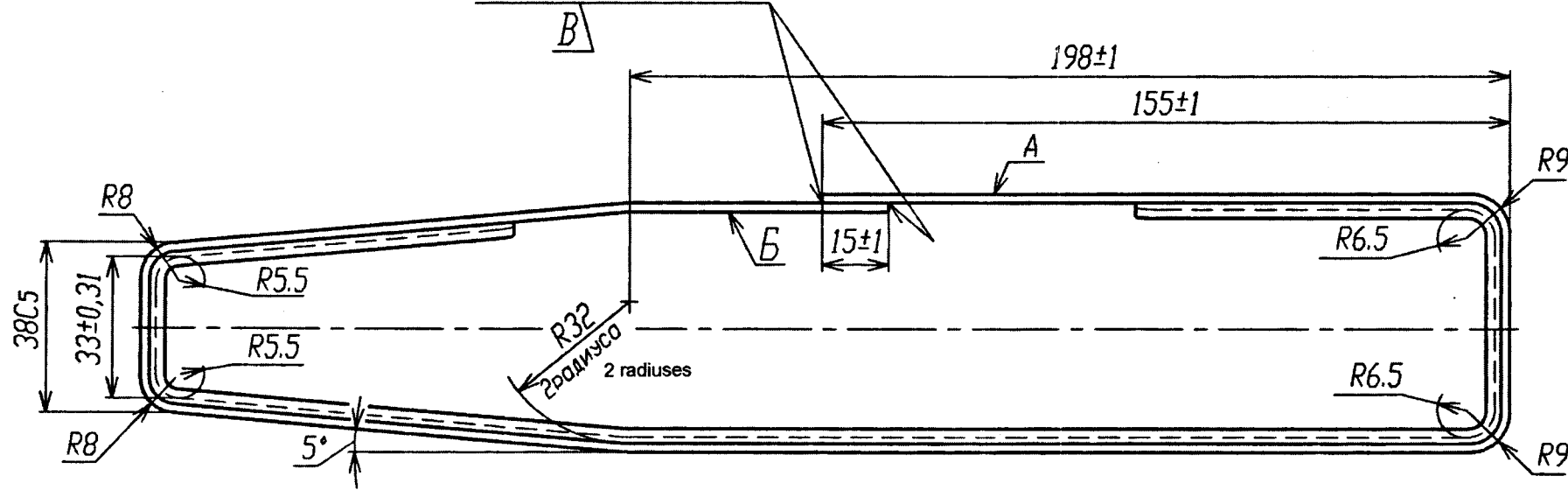
1. * - Dimension for reference.
2. Blunt the sharp edges ~0.6 mm.
3. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

1. * Размер для справок.
2. Острые ребра притупить ~ 0,6 мм.
3. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ I.

AK - 630 03 - 52

			AK-630M 03-52		
			Type	Mass	Scale
Изм/Лист	№ докум.	Подп.	Дата	Лит.	Масса
Разраб.				A	0,300
Проб.				Лист	Листов 1
Т.контр.				Sheet	Total Sheets
И.контр.				Лист	
Утв.				К490В 4-III-35 ГОСТ 16523-97	
			Frame	Рамка	
			B-PN-03 GOST 19903-74		
			Б-ПН-03 ГОСТ 19903-74		
			К490В 4-III-35 ГОСТ 16523-97		
			K 490V 4-III-35 GOST 16523-97		
			ФОРМАТ А2		

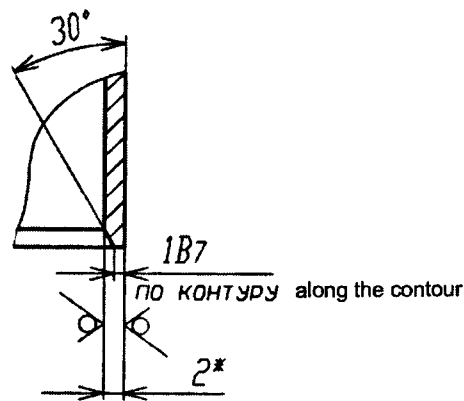
Изм. №, подп. и дата
 Разраб.
 Проб.
 Т.контр.
 И.контр.
 Утв.
 Взам.инв.№ (инв.зв.)
 Дата
 Слобод.Н
 Перв.подп.



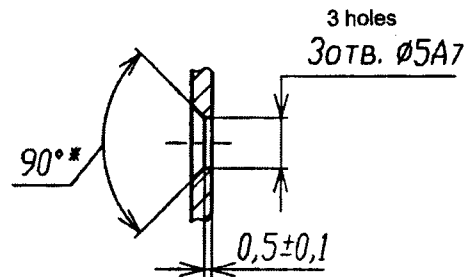
1. Heat treatment - high tempering.
2. Electrode УОНИИ 13/45-2,0-2 GOST 9466-75.
3. Welding as per GOST 14771-76-УП-Н1-2 is permitted with the electrode 1,2 СВ-0,8 Г2С GOST 2246-70.
4. Finish the welded joints B aflushed with planes A and Б.
5. * - Dimension for reference.
6. Mark Ш, Ч on the tag and stamp K as per AK-630, AK-630M TU 1.

1. Термообработка - высокий отпуск.
2. Электрод УОНИИ 13/45-2,0-2 ГОСТ 9466-75.
3. Допускается сварка по ГОСТ 14771-76-УП-Н1-Δ2 проволокой 1,2 СВ-0,8 Г2С ГОСТ 2246-70.
4. Сварные швы В зачистить заподлицо с плоскостями А и Б.
5. *Размер для справок.
6. Маркировать Ш, Ч на бирке и клеймить К по АК-630, АК-630М ТУ 1.

I(2:1)



II(2:1)



Лев. лист

Слов. N

Имя. N

Дата

Имя. N

AK-630 107-32		Lit	Wt.	Scale
Lower Frame		Лит.	Масса	Масштаб
Рамка нижняя		A	0,515	1:1
BT-PN-0 2 GOST 19904-90		Лист	Листов	
Sheet BT-PN-0 2 GOST 19904-90		Лист	Листов	
Лист		К490В 4-III-35 ГОСТ 16523-97		

AK-630 107-33					
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.	
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					

Rz80 (✓)

1.* Reference dimension.
 2. Blunt sharp edges R~0.6 mm.
 3. Chips as per specimen are permissible at the corners.
 4. Mark Ш, Ч and stamp K on tag.

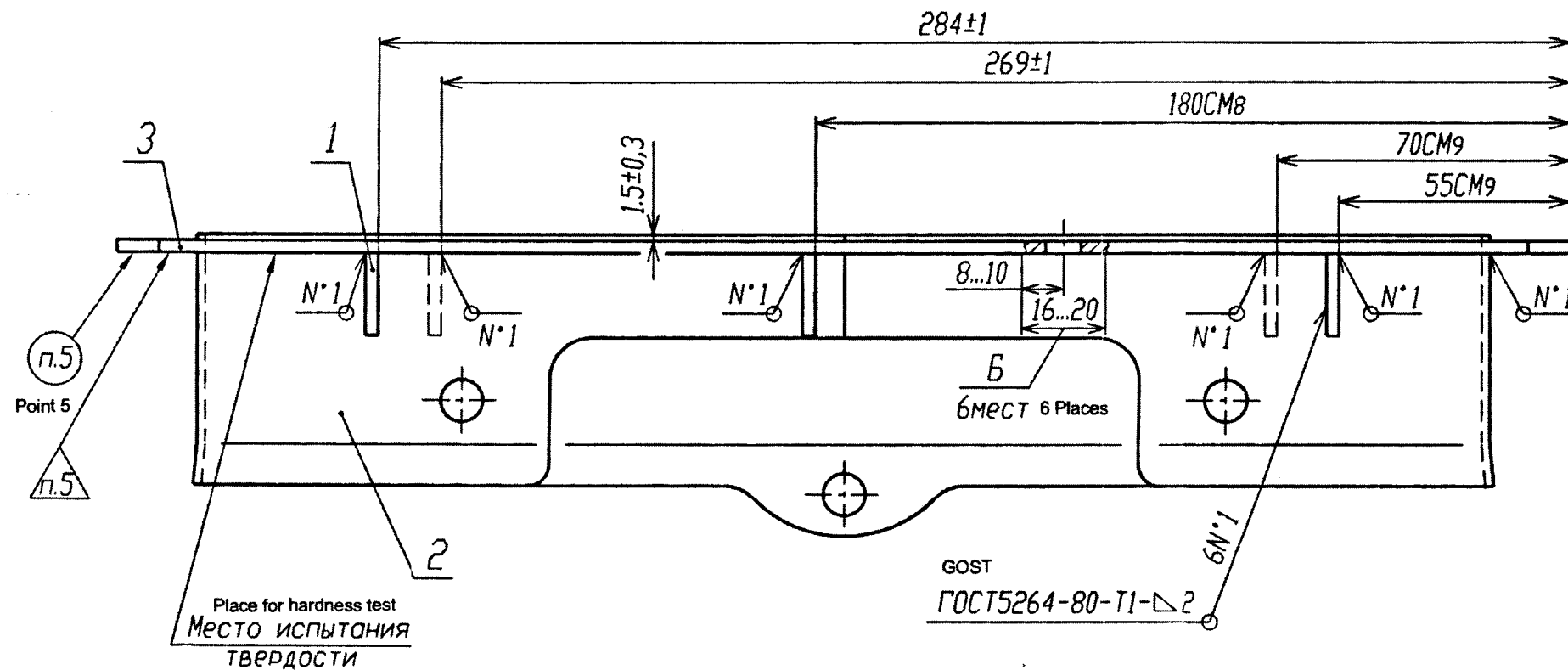
AK-630 107-33			
Rib	Type	Weight	Scale
	A	0.003	1:1
Sheet		Sheets 1	
Sheet <i>B - PN - 03 GOST 19903 - 74</i>			
<i>K 490V 4 - III - 35 GOST 16523 - 97</i>			

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Format A4

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
						<u>Documents</u>	
Reference No.	A3			AK-630 Sb 107-9 SB	Assembly drawing		
	A4	1		AK-630 107-33	Rib	5	
	A2	2		AK-630 107-36	Upper frame	1	
	A3	3		AK-630 107-54	Frame	1	
Sign and Date				AK-630 Sb 107-9			
	Amend.	Sheet	Doc. No.	Sign	Date		
Orig. Inv. No.	Developed by				Type	Sheet	Sheets
	Checked by				A		1
	Head of Q.C.D				Upper frame		
	Approved by						
Sign and Date							
Dupl. Inv. No.							
Alternate Inv. No.							

AK-630 SP107-9SB
 AK-630 SP107-9CB



1. Electrode UONI 13/45-2.0-2 GOST 9466-75.
2. Semi-automatic welding in the medium of carbonic acid gas with the use of electrode filler 1.2 Sv-08 G2S GOST 2246-70 is permitted.
3. 29...35.0 HRC_с. Finishing at the places for hardness test is permitted up to 0.5 mm.
4. Coating Cad. 12 Phos.
Varnish BF-4 with nigrogin, 1 layer, preparation as per OST 3-4123-78, IV, OM2.
5. Mark Ш, Ч and stamp К, И as per AK-630, AK-630M TU I.
6. In the zones Б - do not weld.

1. Электрод УОНИИ 13/45-2,0-2 ГОСТ 9466-75.
2. Допускается полуавтоматическая сварка в среде углекислого газа с применением присадочной проволоки 1,2 Св-08 Г2С ГОСТ 2246-70.
3. 29...35,0 HRC_с. В местах замера твердости допускается зачистка до 0,5 мм.
4. Покрытие Кд12. фос.
Лак БФ-4 с нигрозином, 1слой приготовления по ОСТ 3-4123-78, IV, ОМ2.
5. Маркировать Ш, Ч и клеймить К, И по АК-630, АК-630М ТУ I.
6. В зонах Б - не варить.

AK - 630 Sb107 - 9SB

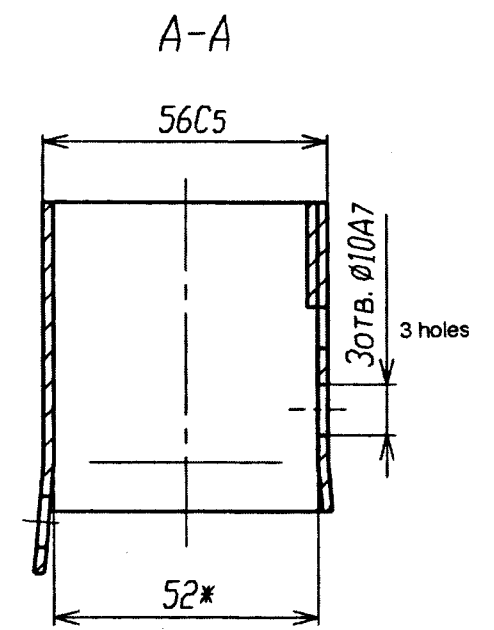
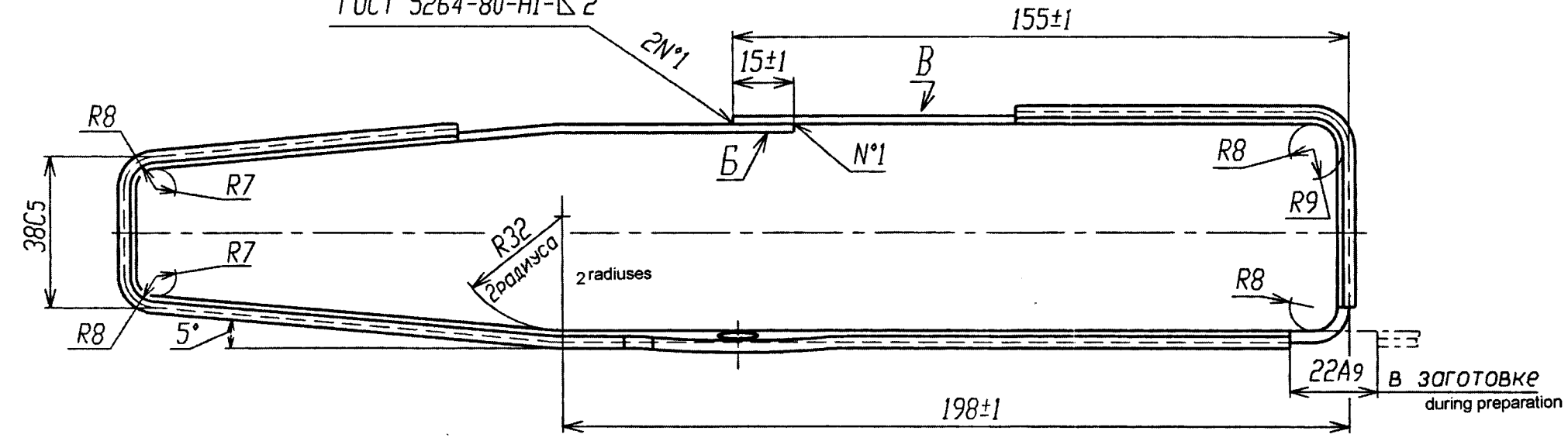
		AK-630 СБ107-9СБ		Type	Mass	Scale
		Upper Frame		Лит.	Масса	Масштаб
		Рамка верхняя		A	1,020	1:1
		Assembly Drawing				
		СБОРОЧНЫЙ ЧЕРТЕЖ		Лист	Листов	
				Sheet	Total Sheets 1	
Изм.	Лист	И докум.	Подп.	Дата		
Разр.						
Пров.						
Т.контр.						
И.контр.						
Утв.						

Bale 8 container 2

Формат А4х3

Пров. примен. СГ И Имя.Н. Фами. И. Дата Подп. и дата Имя.Н. Фами. И. Дата Подп. и дата Имя.Н. Фами. И. Дата Подп. и дата

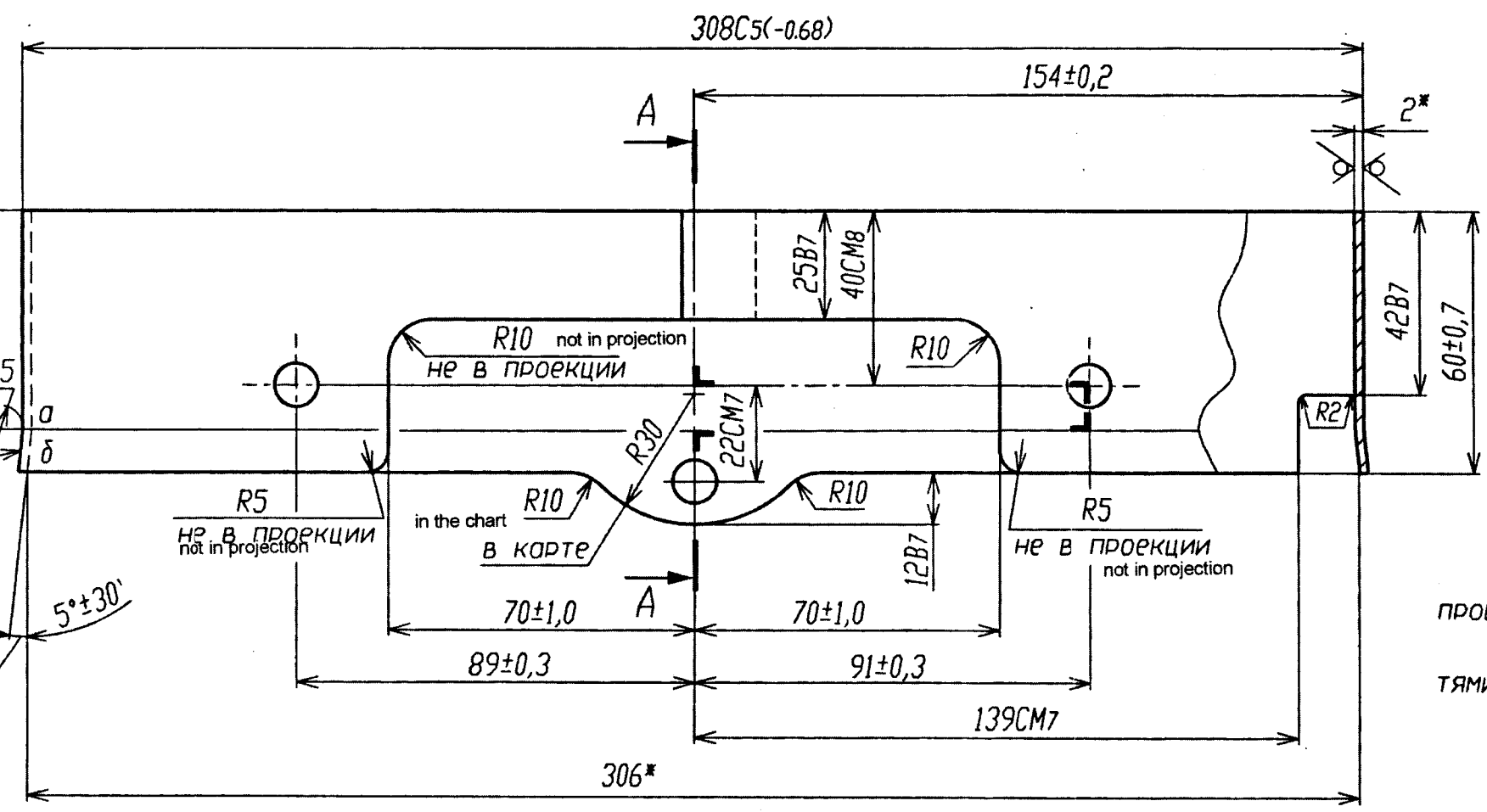
GOST
ГОСТ 5264-80-Н1-Δ 2



aб section of the smooth transition of radiuses.

"аб" участок плавного перехода радиусов

along the contour
По контуру



1. Heat treatment: high tempering.
2. Electrode UONI 13/45-3.0-3 GOST 9466-75.
3. welding as per GOST 14771-76-UP-N1-2 is permitted with electrode 1.2 SV-08 G2S GOST 2246-70.
4. Finish the welded joints afushed with planes B and B.
5. * - Dimensions for reference.
6. Mark Ш, Ч and stamp К, И on the tag.

1. Термообработка : высокий отпуск.
2. Электрод УОНИИ 13/45-3,0-3 ГОСТ 9466-75.
3. Допускается сварка по ГОСТ 14771-76-УП-Н1-Δ 2 проволокой 1,2 Св-08 ГС ГОСТ 2246-70.
4. Сварные швы зачистить заподлицо с плоскостями В и В.
5. *Размеры для справок.
6. Маркировать Ш, Ч и клеймить К, И на бирке.

Имя, Подп. и дата / Имя, Подп. и дата / Имя, Подп. и дата / Имя, Подп. и дата

Bale 8 container 2

				AK-630 107-36		
				Lit	Wt.	Scale
				Upper Frame	Лит.	Масса
				Рамка верхняя	A	0,515
				WT-PN-02 GOST 19904-90	Лист	Листов
				Sheet 61-ПН-0 2 GOST 19904-90	Sheet	Total Sheets
				К 1908 4-III-75 GOST 14523-97		

First use

Reference No.

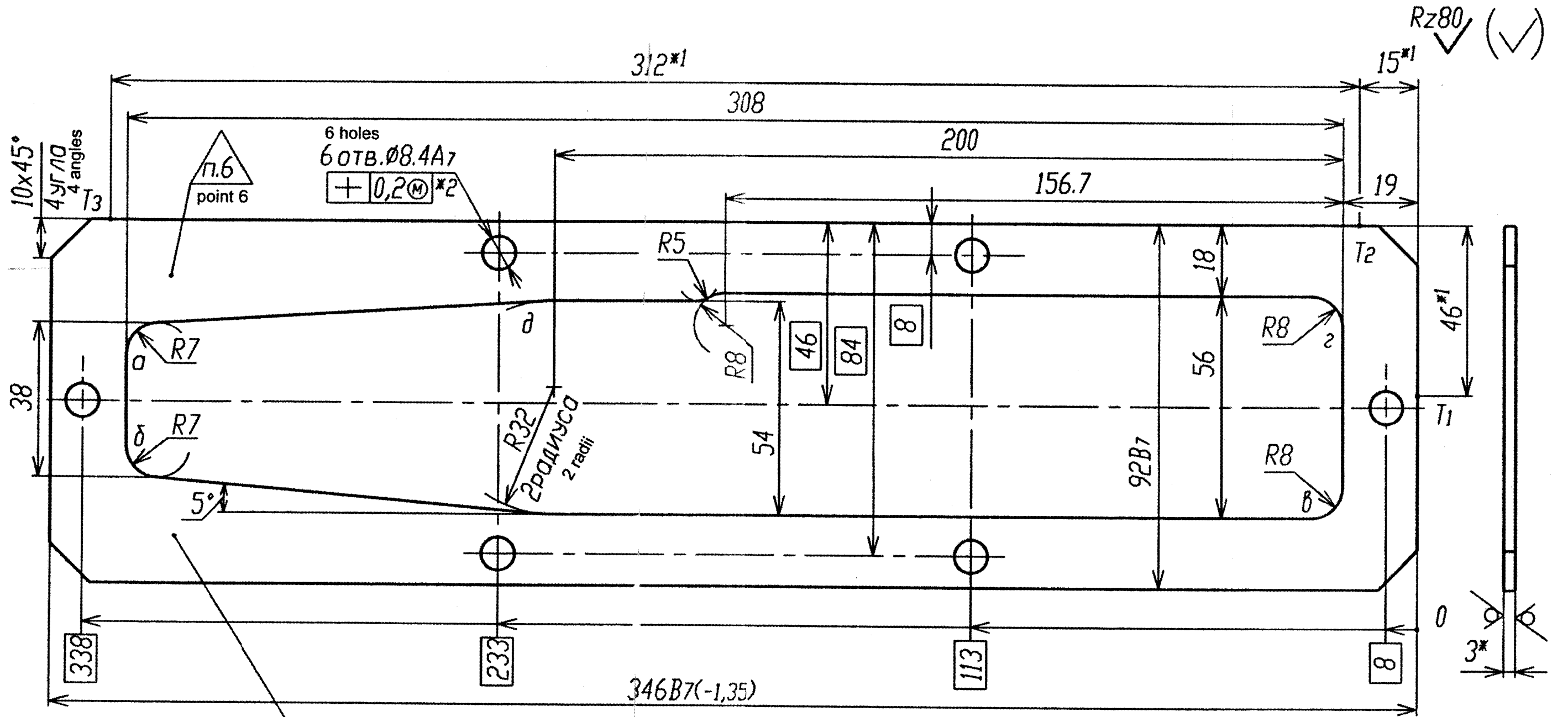
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



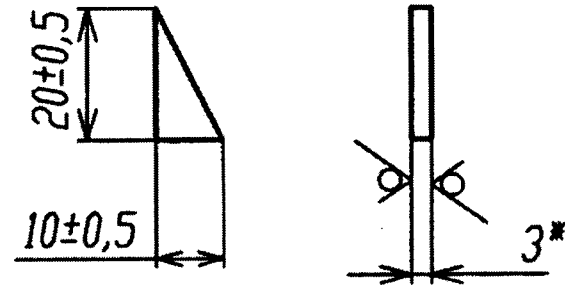
- 1.* Reference dimension.
- 2.*1 Dimensions ensured by tool.
- 3.*2 Deviation given with respect to points T₁, T₂, T₃.
- 4. Tolerance for contour абвгд- 0.3 mm with respect to datum points T₁, T₂, T₃.
- 5. Blunt sharp edges R~0.6 mm.
- 6. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

Amend.	Sheet	Doc.No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

AK-630 107-54		
Type	Weight	Scale
A	0.360	1:1
Sheet	Sheets 1	
Sheet <u>B - PN - 03GOST19903 - 74</u> <u>K490V4 - III - 35GOST16523 - 97</u>		

AK-630 107-33

Approved OGMet
 Orig. Inv. No.
 Sign and Date
 Approved Inv. No.
 Alternate Inv. No.
 Approved TOsb
 Dupl. Inv. No.
 Sign and Date
 Approved KTONI
 Sign and Date
 Approved by shop
 Reference No.
 First use



Rz80 (✓)

- 1.* Reference dimension.
- 2. Blunt sharp edges R~0.6 mm.
- 3. Chips as per specimen are permissible at the corners.
- 4. Mark Ш, Ч and stamp K on tag.

Amend.	Sheet	Doc. No.	Sign	Date

AK-630 107-33			
Type	Weight	Scale	
Rib	A	0.003	1:1
Sheet		Sheets 1	
Sheet $\frac{B - PN - 03 GOST 19903 - 74}{K490V 4 - III - 35 GOST 16523 - 97}$			

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