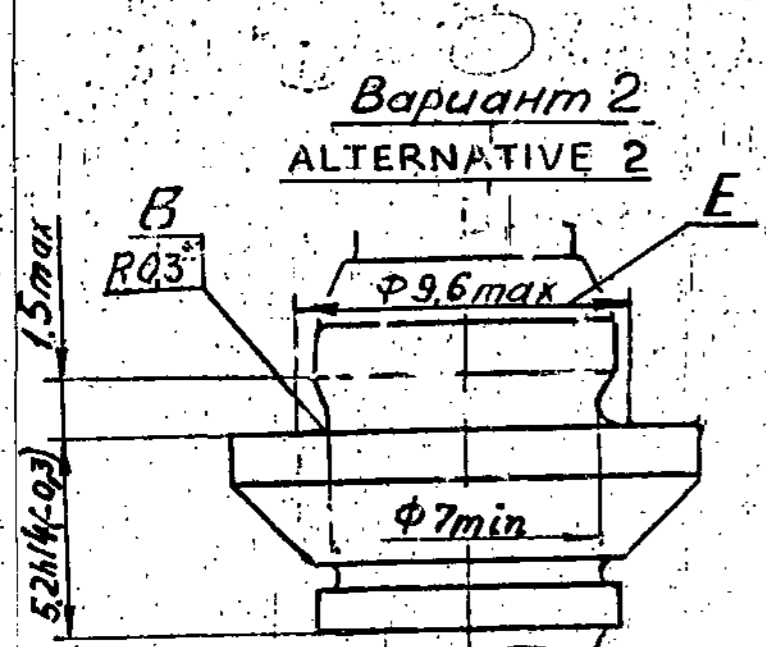
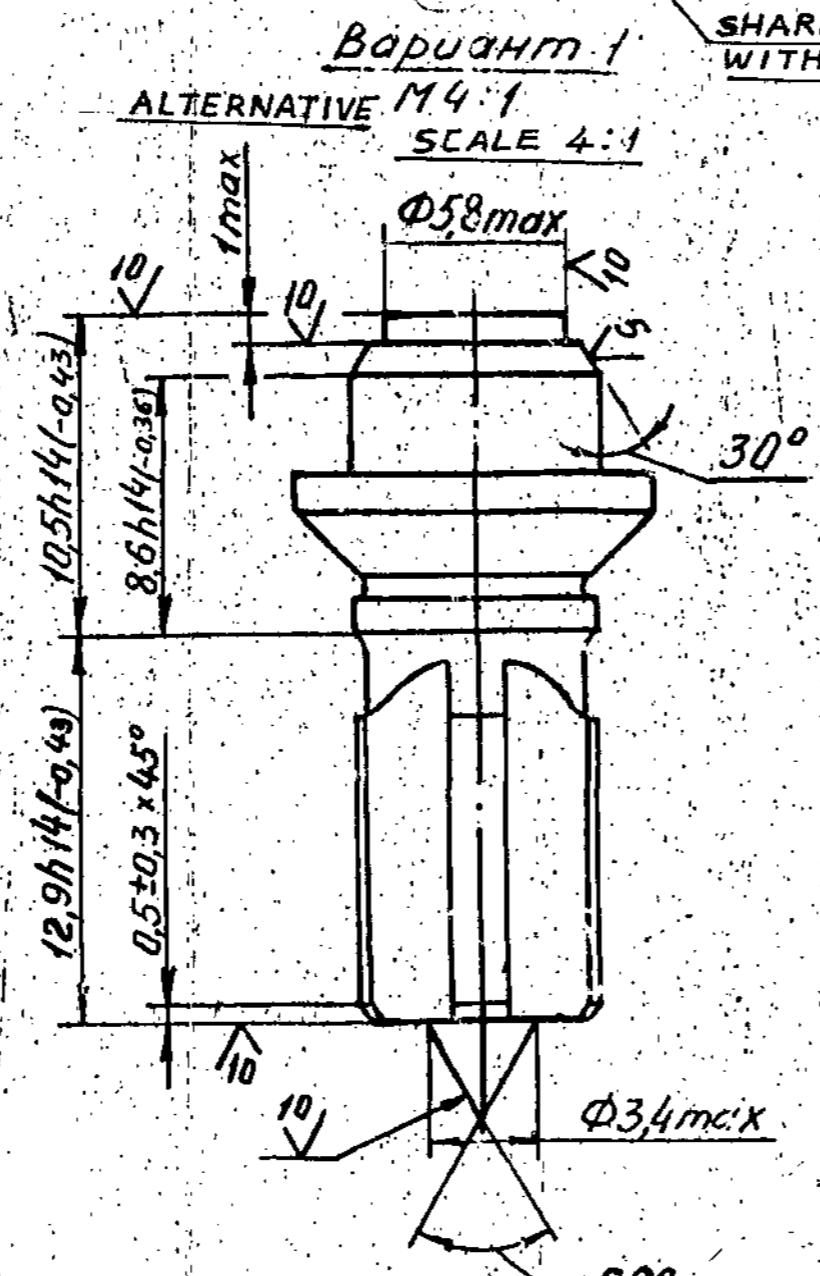
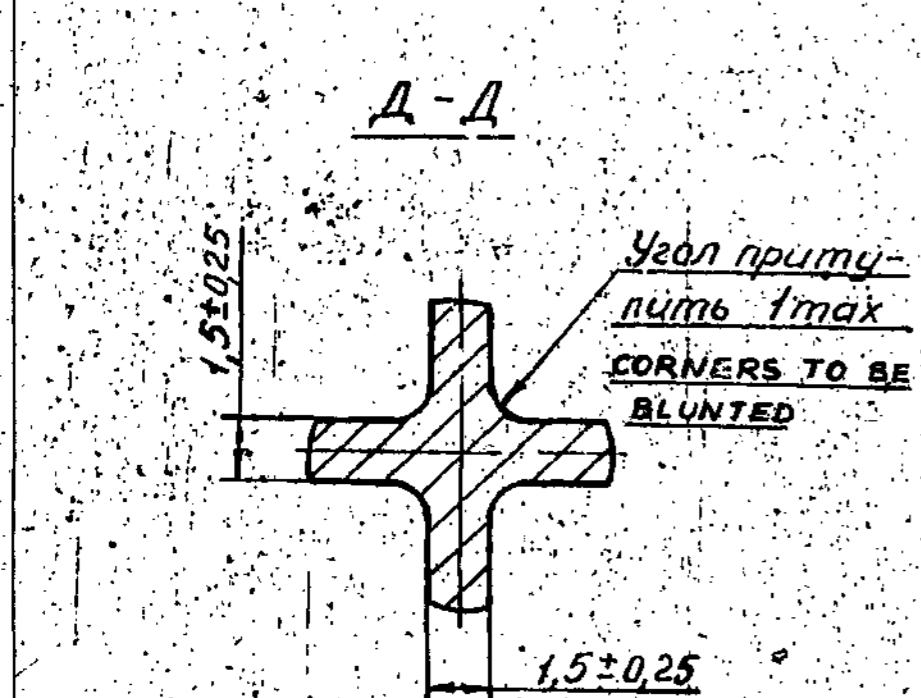
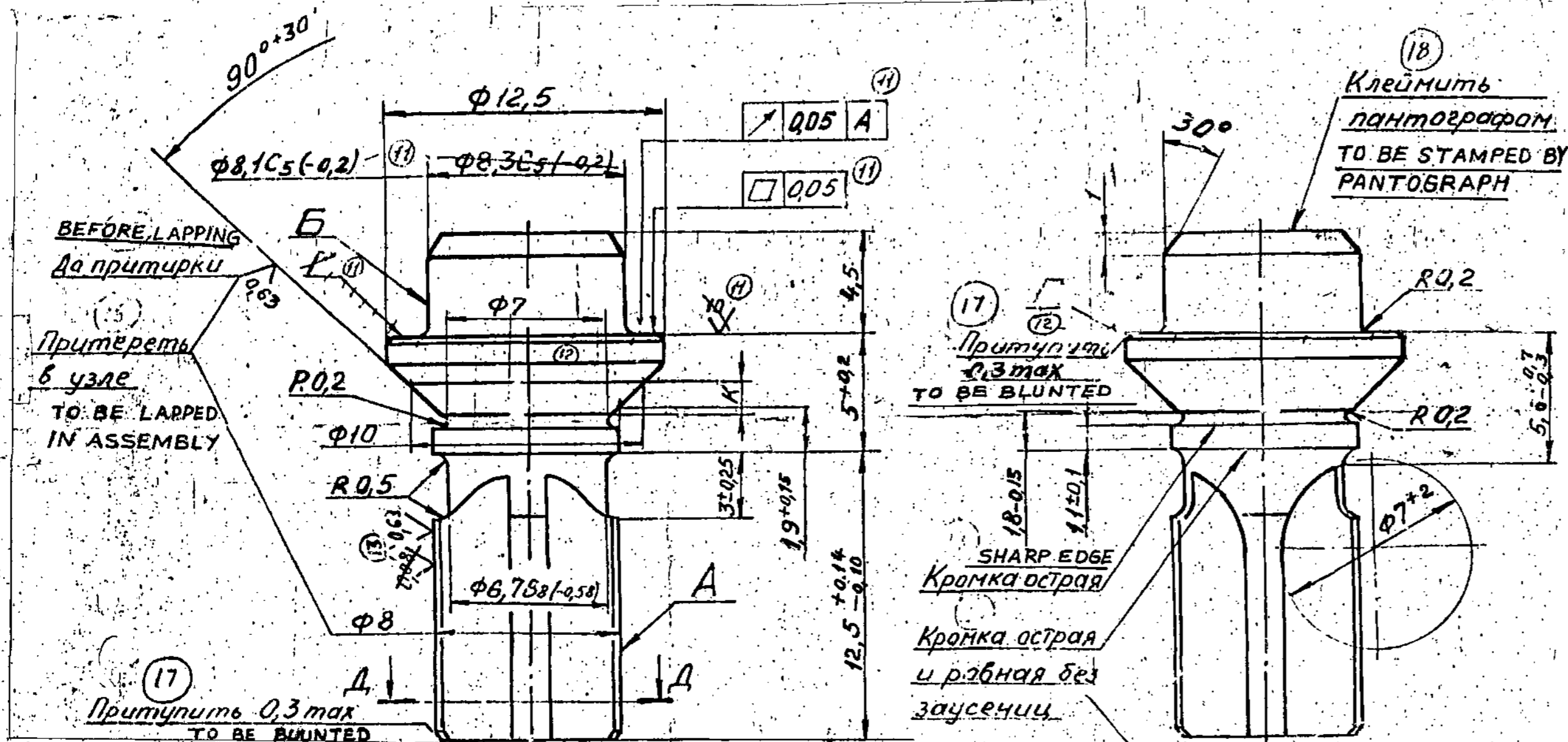


DRAWING NUMBER
3327-59-1A

5/ (✓)

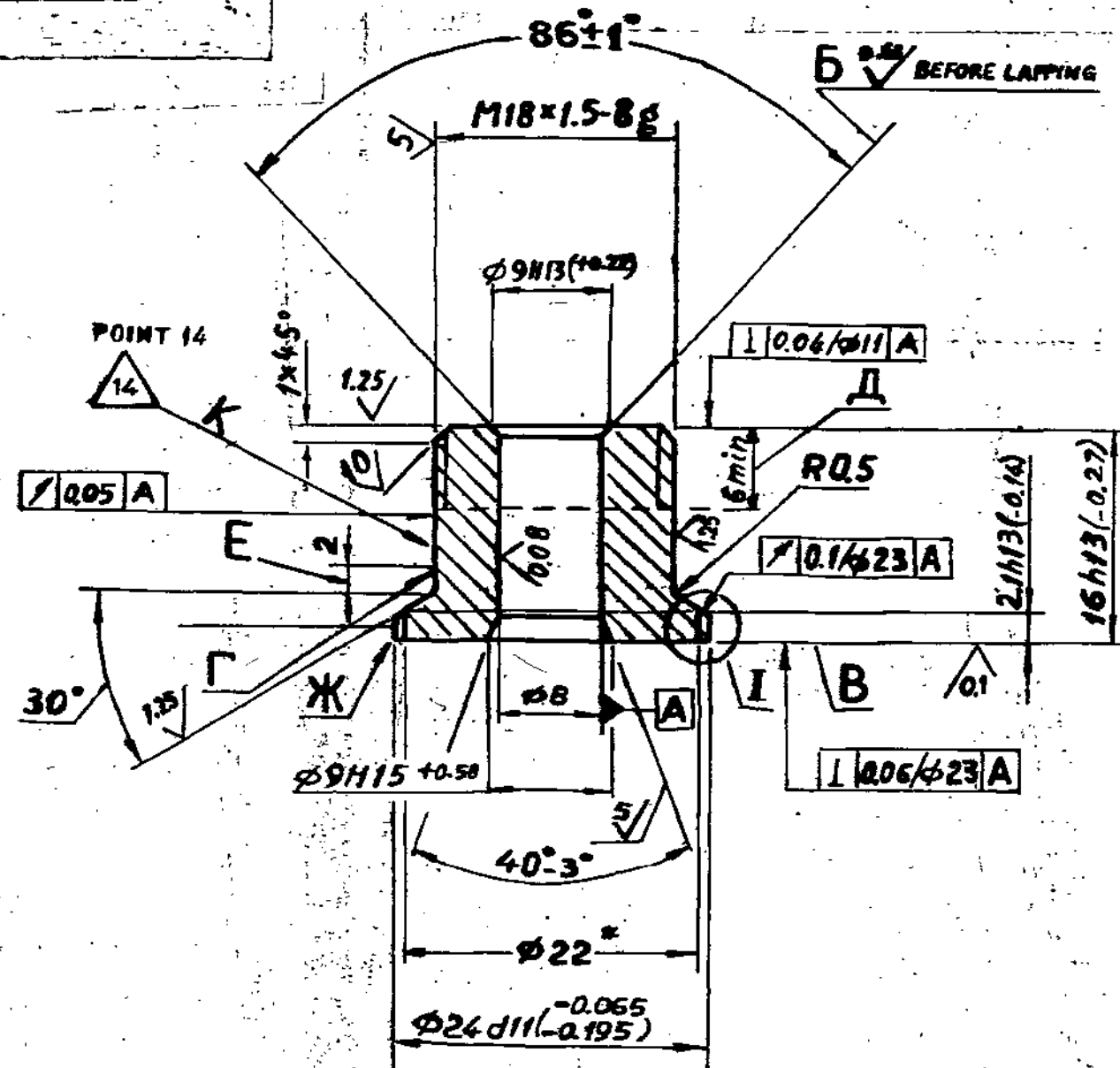
- CONTROL GROUP III ACCORDING TO TT-11.
- HRC₂ ≥ 60; HRC₃ ≥ 57 IS ALLOWED ON THE UPPER AND LOWER FACES AFTER FINAL GRINDING. THE HARDNESS CAN ALSO BE CHECKED BY A TEST FILE WITH RANDOM INSPECTION ACCORDING TO ROCK WELL.
- MAINTAIN THE DIMENSIONS ACCORDING TO 7th CLASS OF ACCURACY OST-1010.
- ENSURE TAPER OF THE SURFACE 'A' WITHIN THE LIMITS 0.007... 0.012 mm WITH LARGE DIAMETER FROM THE SIDE OF THE CONE 90°+30'.
- RUN-OUT OF THE SURFACE 'E' RELATIVE TO THE SURFACE 'A' NOT MORE THAN 0.15 mm.
- DO NOT BLUNT THE EDGE 'Г'. BURRS ARE NOT ALLOWED.
- TRACES OF GRINDING ARE NOT ALLOWED ON THE LAPPED SURFACE 'A'; COMPARE WITH THE STANDARD.
- MAINTAIN THE ANGLE 90°+30' AND ROUGHNESS OF THE SURFACE OF THE CONE 90°+30' ON THE SECTION 'K'.
- SHARP EDGES, EXCEPT THOSE INDICATED ON THE DRAWING ARE NOT ALLOWED.
- COATING, CHEMICAL OXIDIZING WITH OIL FINISH, EXCEPT THE SURFACE 'A' AND THE CONE. LOCAL DAMAGES OF THE COATING ARE ALLOWED DURING MACHINING.
- RADIUS 'B' SHOULD NOT GO BEYOND THE LIMITS φ E.
- * DIMENSION IS TO BE ENSURED BY TOOL.



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

EST. WT. 0.006 kg
TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R-OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHC	TCD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-67	MATERIAL - STEEL	USED ON -
				30 JUN 97	5:1			W X IS GOST 801-7E	CS 3327-08-1A
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A D I							TITLE: DELIVERY VALVE		
ISSU	DATE	NATURE OF AMENDMENTS	ALL THREADS TO CONFORM TO:		D S CAT NUMBER		DRAWING NUMBER 3327-59-1A		



ALTERNATIVE M5:1



1. CONTROL GROUP III ACCORDING TO TT-11.
2. HRC₃ = 62 ... 64.
3. UNINDICATED LIMIT DEVIATIONS OF DIMENSIONS H14, ±IT14/2.
4. SURFACES A AND B ARE LAPPED IN THE ASSEMBLY UNIT.
5. TRACES OF GRINDING ARE NOT ALLOWED ON THE LAPPED SURFACES A AND B, THE PRESENCE OF INSIGNIFICANT, HARDLY VISIBLE MARKS ARE ONLY ALLOWED. COMPARE WITH THE STANDARD.
6. GRIND THE SCREW THREAD AND SURFACE Γ UPTO $\phi 17f9(-0.018/-0.059)$ mm $\phi 17d11(-0.05/-0.16)$ mm ALLOWED ALONG THE LENGTH OF THE THREAD Δ.
7. CHECK THE STRAIGHTNESS OF THE FACE B BY A TOOLMAKERS STRAIGHT EDGE OF THE CLASS OF ACCURACY 0, GOST 8026-75; CLEARANCE NOT ALLOWED.
8. SCUFFING FROM THE FRICTION OF THE FACE AGAINST THE MANDREL IS ALLOWED ON FACE B.
9. ENSURE THE TAPER OF THE SURFACE A WITHIN THE LIMITS 0.001 ... 0.003 mm AGAINST THE LARGE DIAMETER FROM THE SIDE OF THE FACE A.
10. COMING OUT OF THE SCREW THREAD ON THE SECTION E IS NOT ALLOWED.
11. BLUNT THE EDGE X BY THE RADIUS OR CHAMFER NOT MORE THAN 0.5 mm.
12. COATING OF CHEMICAL OXIDIZING WITH OIL FINISHING EXCEPT ON SURFACES A, B. LOCAL DAMAGE OF THE COATING IS ALLOWED DURING MACHINING.

13. SPOTS OF BLACK TRACES FROM A PRECEDING OPERATION ARE ALLOWED ON THE SCREW THREAD.
14. STAMPING BY PUNCHING.
15. * DIMENSIONS FOR REFERENCE.

EXPLANATORY NOTE

THE COMPONENT SHOULD BE MANUFACTURED FROM HOT ROLLED CALIBERATED ROUND WITH SPECIAL SURFACE FINISH BALL BEARING STEEL GRADE WX15 TO GOST 801-78.
 CHEMICAL COMPOSITION % :- AS PER GOST 801-78.

STEEL GRADE	C	Si	Mn	Cr	S	P	Ni	Cu	Ni+Cu
WX15	0.95-1.05	0.17-0.37	0.20-0.40	1.30-1.65	0.02	0.027	0.30	0.25	0.5

HARDNESS :- HB 179 TO 207 INDENTATION
 DIAMETER 4.5 TO 4.2mm

DRO INTRODUCED VISE NOTN NO. 0X 05 - 014

AB

3	12	10023-12	10023-12
7	17	10023-17	10023-17
5	13	10023-13	10023-13
2	12	10023-12	10023-12
1	12	10023-12	10023-12

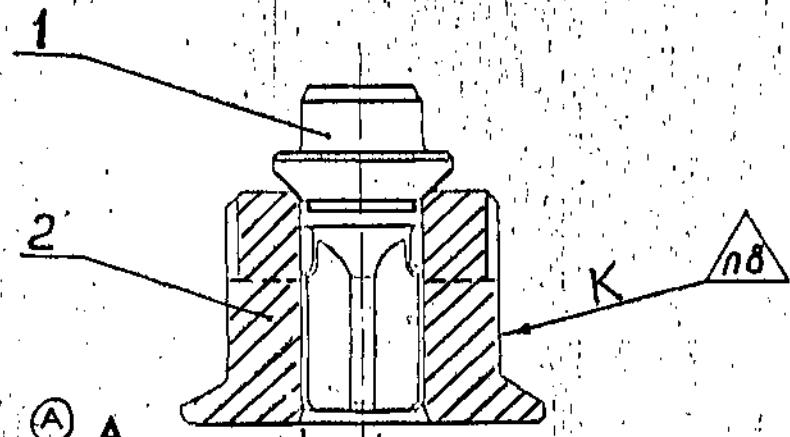
PLAT SAMPLE SHOULD BE APPROVED BY A H.S.P. BEFORE BULK PRODUCTION

ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL	STEEL WX15 USED PER GOST 801-78	CF-327-00-1A
SCALE	2:1				
TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED					
ALL THREADS TO CONFORM TO					

DELIVERY VALVE SEAT

ЕСКД

(A) 1. ROUGHNESS OF SURFACE A OF ITEM 1 SHOULD BE 0.32 AFTER LAPPING.



- 1) DIAMETER OF HOLE OF LAPPED VALVE SEAT SHOULD BE $0 \pm 0.05 \text{ mm}$.
- 2) LAPPED COMPONENTS VALVE AND VALVE SEAT MAKE UP A PAIR, IN WHICH REPLACEMENTS BY ANY COMPONENT FROM OTHER PAIR IS NOT ALLOWED.
- 3) ROUGHNESS OF LAPPED SURFACES SHOULD NOT BE WORSE THAN STANDARD.
- 4) VALVE MOVEMENT IN THE SEAT AS PER STANDARD.
- 5) THE PAIR SHOULD BE PRESURE-TESTED WITH AIR AT A PRESSURE OF 4 TO 7 Kgf/cm^2 PRESSURE TESTING AT A PRESSURE OF 4...5.5 Kgf/cm^2 SHOULD BE CARRIED OUT FOR 15 SECOND AND AT A PRESSURE OF 5.5...7 Kgf/cm^2 FOR 10 SECONDS.
- 6) CHECKING FOR TIGHTNESS AT CHAMFERS, SHOULD BE CARRIED OUT ON A SPECIAL FIXTURE WITH THE USE OF STANDARD PAIR IN ACCORDANCE WITH INSTRUCTIONS UB 47-1 BY A MIXTURE OF OIL AND DIESEL FUEL HAVING ANGLER VISCOSITY 1.9 ± 0.1 AT A TEMPERATURE OF 50°C .
 - a) BEFORE FILLING UP OF THE TANK THE MIXTURE SHOULD BE MIXED WELL.
 - b) BEFORE TEST THE PAIR SHOULD BE THOROUGHLY WASHED IN FILTERED DIESEL FUEL THERE SHOULD NOT REMAIN ANY PETROLATUM OR OTHER TYPES OF LUBRICANT ON THE VALVE AND SEAT SURFACES.
 - c) THE PAIR IS CONSIDERED FIT FOR SERVICE, IN CASE, THE TIME OF LOAD FALLING IS THE SAME AS THAT OF THE STANDARD PAIR LOAD.
- 7) PRESERVATION AND STORAGE OF PAIRS IN ACCORDANCE WITH INSTRUCTION И Ц С = 1251 DEPENDING ON THE TERM OF STORAGE.
- 8) TO BE MARKED WITH PANTOGRAPH.

1. Диаметр отверстия доведенного седла клапана $0 \pm 0.05 \text{ мм}$.
2. Притертые детали, клапан и седло клапана, составляют пару, в которой замена одной детали какой-либо деталью из другой пары не разрешается.
3. Шероховатость доведенных поверхностей не ниже эталона.
4. Движение клапана в седле по эталону.
5. Испытание на герметичность производить воздухом под давлением 0.4...0.7 МПа (4...7 кгс/см²). Испытание на герметичность производить под давлением 0.4...0.55 МПа (4...5.5 кгс/см²) в течение 15 с, под давлением 0.55...0.7 МПа (5.5...7 кгс/см²) - в течение 10 с.
6. Приемка на плотность по пояске производится на специальном приспособлении по эталонной паре согласно инструкции ЦВ-47-1 на смеси масла и дизельным топливом, имеющей вязкость 1.9 ± 0.1 по Энглеру при 50°C :
 - а) смесь перед заливкой в бак хорошо перемешать;
 - б) перед испытанием пару тщательно промыть в профильтрованном дизельном топливе. Не допускается наличие на поверхностях клапана и седла вазелина или других видов смазки;
 - в) пару считать годной по плотности в том случае, если падение груза произойдет за время не менее показаний эталона.
7. Консервация и хранение пар по инструкции ЦЦЛ-1251 в зависимости от срока хранения.
8. Клеймить электроискровым способом.

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE No. 2. BK 85-813

PILOT SAMPLE SHOULD BE APPROVED BY A IIS P BEFORE BULK PRODUCTION

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS #
		0.031 Kg.	(LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
A	3.2.97	AUTHORITY No. BK 85-367	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL
			USED ON - СБ 327-00-45
DIN		SCALE: 2 : 1	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A D I
CHN		DIMENSIONS IN mm	
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	TITLE: DISCHARGE VALVE ASSY
APPO			
DATE: 19-2-88		ALL THREADS TO CONFORM TO	D S CAT NUMBER
			DRAWING NUMBER СБ.3327-08-1А СБ

