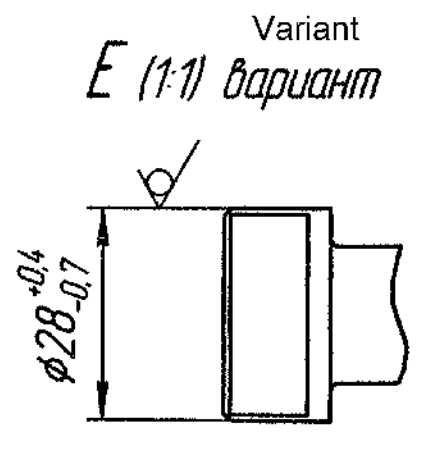
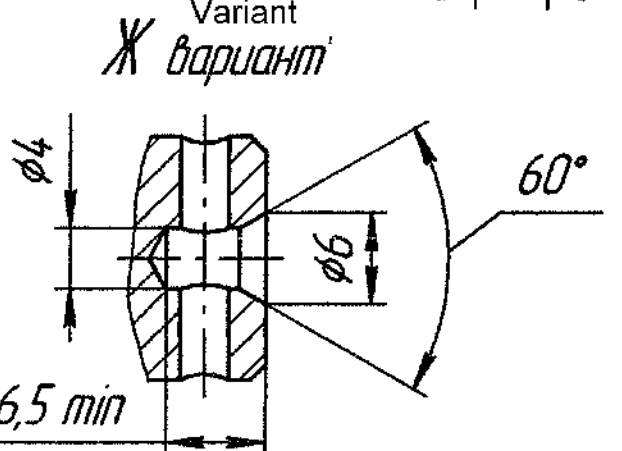
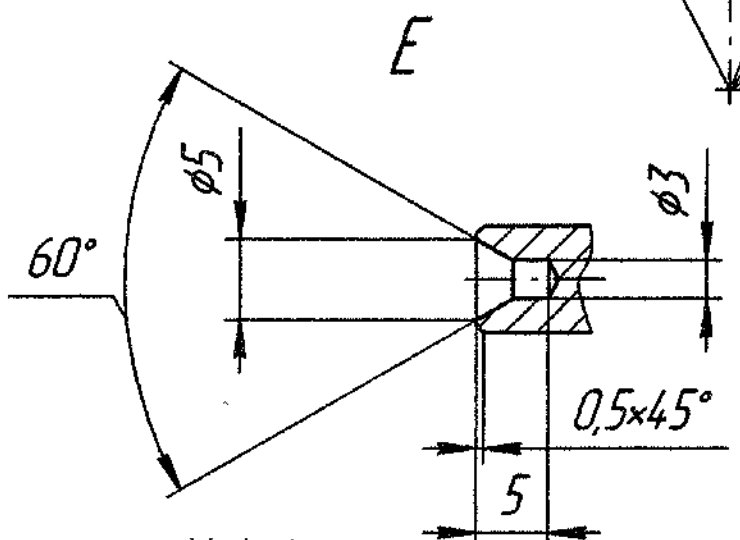
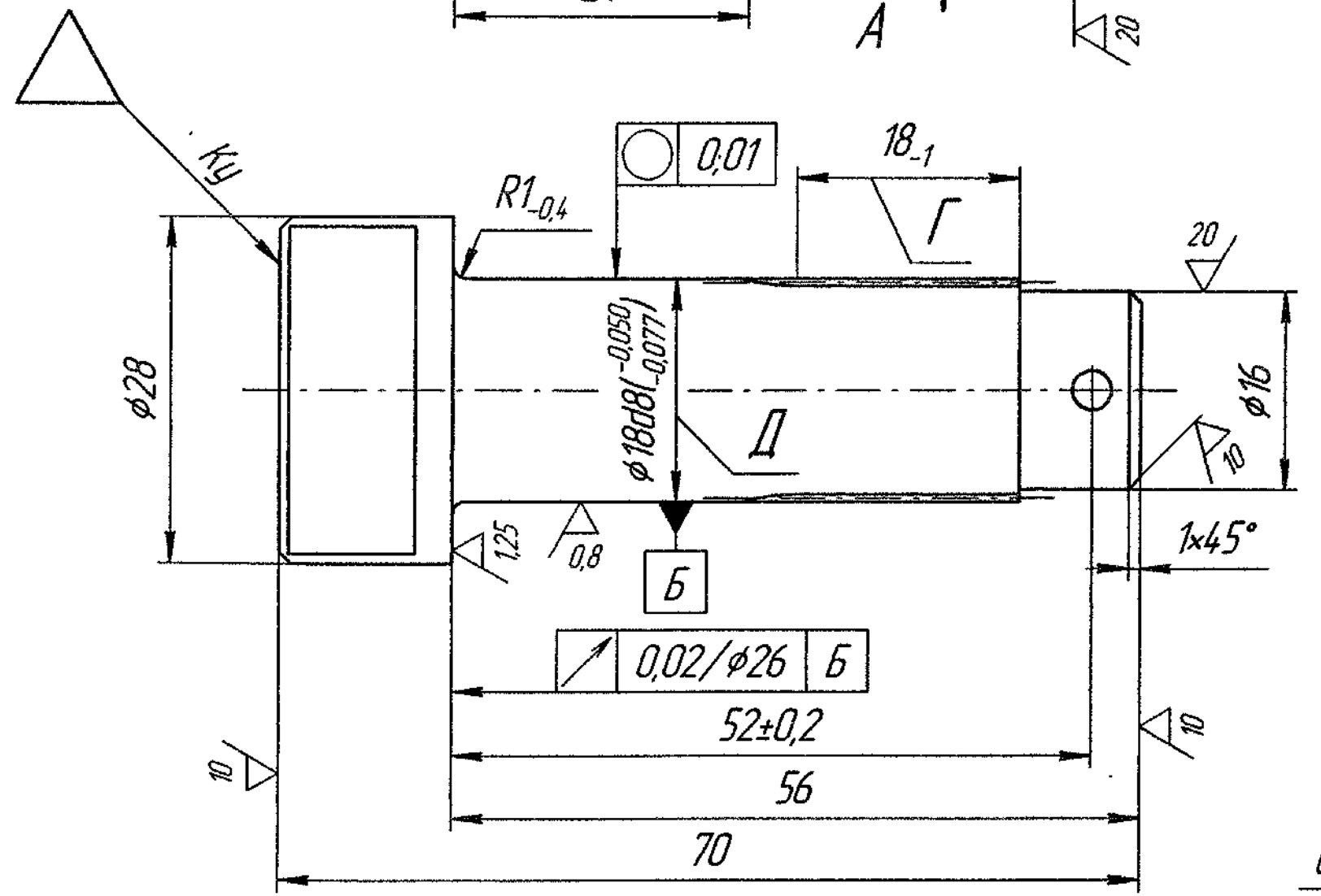
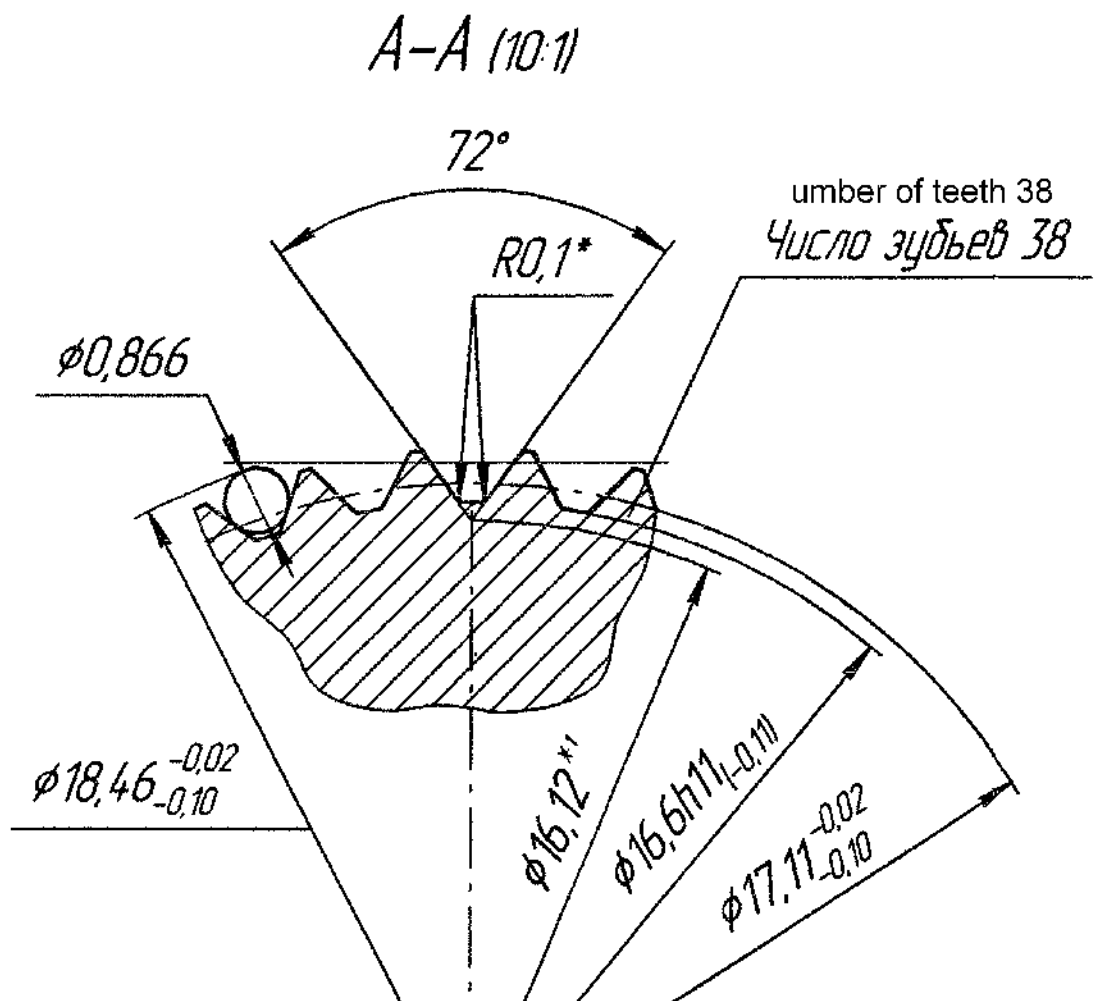
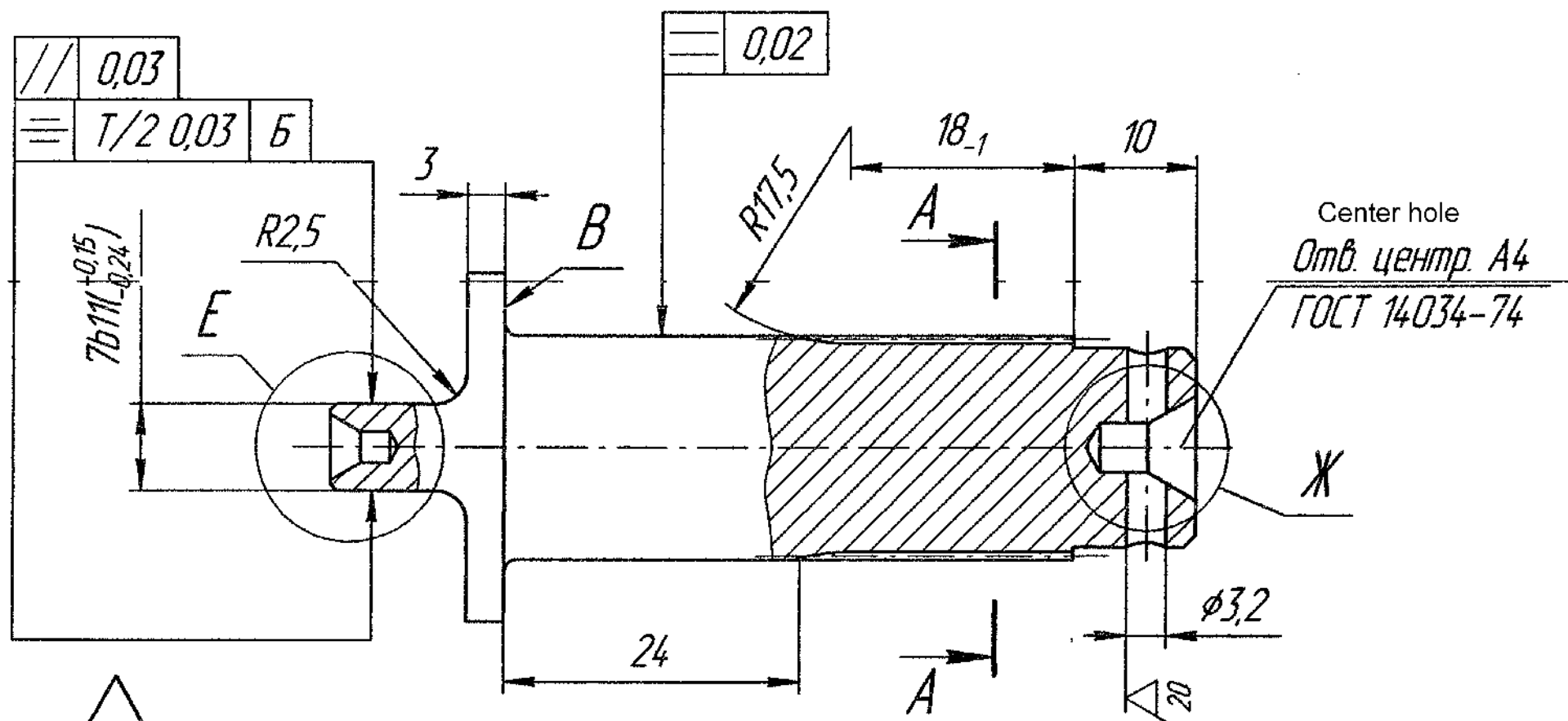


1. Группа контроля III по ТТ-11.
2. Твердость ≥ 100 HB.
3. Неуказанные предельные отклонения размеров: H14, h14, ±IT14/2.
4. Технические требования на резьбу по нормам 82021-00.
5. Поверхности Ж, К проверить "на краску", изготовленную и нанесенную по инструкции ИЛ-613-85. Распределение краски должно быть равномерным и составлять 80% поверхности, не менее.
6. Номера цилиндров выдуть на расстоянии 3^{+1.0} мм от поверхности Т. Шрифт 3-Пр3 ГОСТ 26.008-85.
7. *Размеры обеспечить инструментом.
8. Заменитель материала АК4-1 ГОСТ 4784-74.
9. Допускается на поверхности М поднятие металла в местах маркировки до 0,2 мм max и уступ высотой 0,07 мм max.

1. Inspection group III as per technical requirement TT-11.
2. Hardness > and equal to 100 HB.
3. Unspecified limit deviation of dimensions: H14, h14, ±IT14/2.
4. Technical requirement on thread as per standard 82021-00.
5. Check the surfaces Ж, К "by paint", manufactured and put as per instruction IL-613-85. Distribution of paint should be uniform and prepare 80% surfaces minimum.
6. Drive out the number of cylinder at distance 3+1.0 mm from surface T. Letter size 3-Pr3 GOST 26.008-85.
7. *Dimensions are ensured by tool.
8. Substitute material AK4-1 GOST 4784-74.
9. Raising of metal to marking place up to 0.2 mm maximum and projection with height 0.07 mm maximum on the surface M are permitted.

| | | | | | |
|---------------------------------------|--|---------------------------------------|--|----------------|--|
| 49-07 | | Distributor body of air | | 310-06-7 | |
| Trans. & Ckd. By: M/s Swyaz | | Letter Weight Scale | | 0, 11 11 | |
| Authenticated By: | | Лист | | Листов 1 | |
| Approved By: Engine Factory, Adavi | | Алюминиевый сплав АК4 ГОСТ 4784-97 | | Sheet F-158 | |
| | | GOST 4784-97 | | Drawn 11 | |

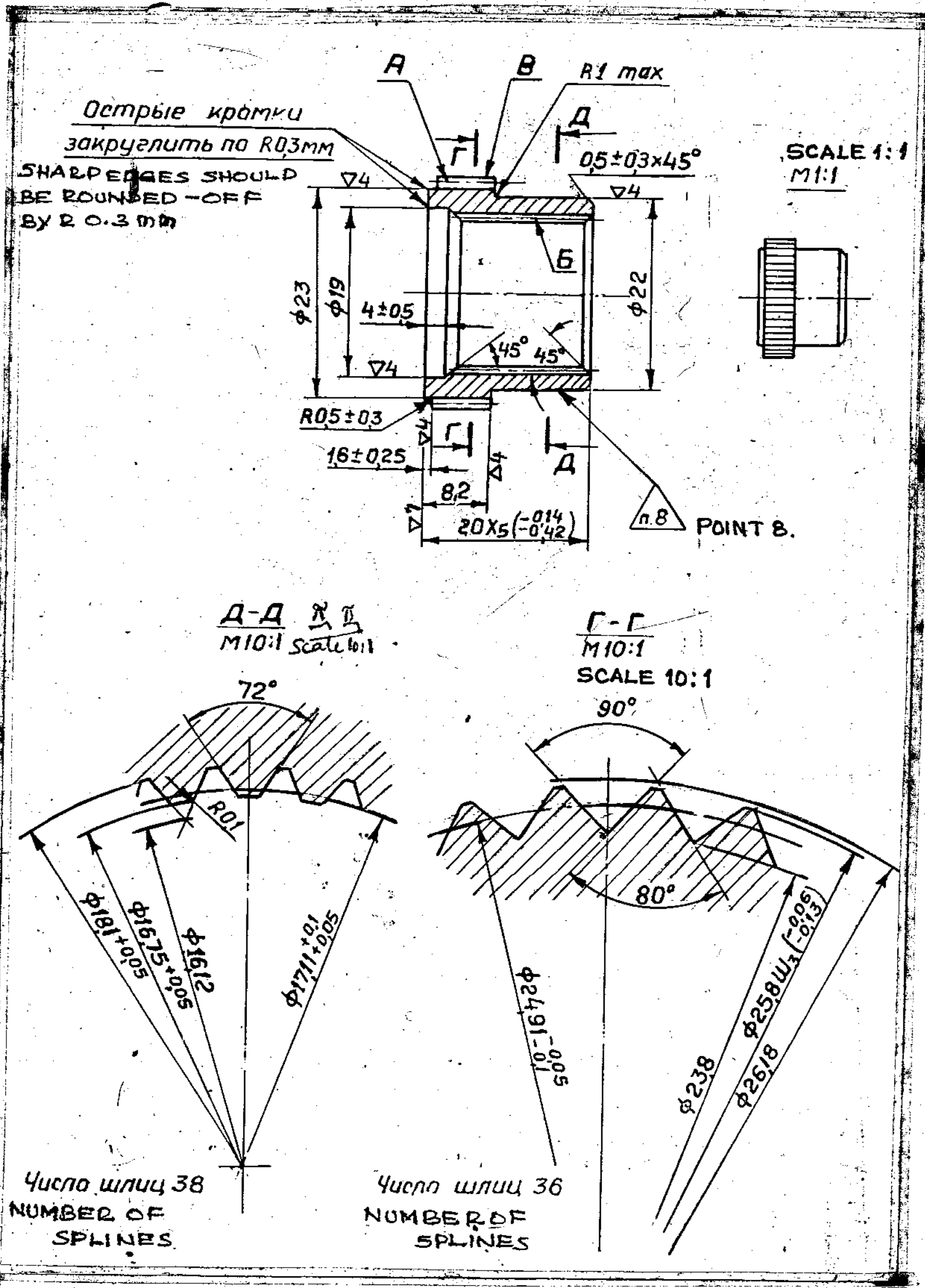


1. Группа контроля III по ТТ-11.
2. 32...39 HRC₃
3. Неуказанные предельные отклонения размеров: H14; h14; IT14 ± 2.
4. Допускается на длине Г размер Д $\phi 18d11(-0.05, -0.16)$ мм.
5. Отклонение от плоскостности поверхности В проверить на "краску", приготовленную и нанесенную по инструкции ИЛ-613-85. Распределение краски должно быть равномерным по всей длине.
6. Покрытие Хим. Окс. прм по ИЛ-681-87.
7. *Размер обеспечить инструментом.
8. *1 Размер для справок.

1. Inspection group III as per TR-11.
2. 32...39 HRC₃.
3. Unspecified limit deviation of dimensions are: H14, h14, ±IT14/2.
4. On length Г, dimension Д dia. 18d11(from -0.16 to -0.05) mm is permitted.
5. Check deviation from the flatness of surface В by "bluing", prepared and applied as per instruction ИЛ -613-85. The blue imprint should be uniform throughout the length.
6. Coating : Chemically oxidised, oiled as per ИЛ-681-87.
- 7.* Dimension is ensured by tool.
8. *1 Dimension is given for reference

Изд. № 44286
Подп. и дата
Взам. инв. № инв. № докл.
Подп. и дата

| | | | |
|---------------------------------|------|--------|------------|
| 310-07-4 Letter weight scale | | | |
| 5 | - | 99-260 | |
| Изм | Лист | № док | Подп. Дата |
| Trans & Ckd. by: M/S SWYAZ | | | |
| Authenticated by: | | | |
| Approved by: | | | |
| Engine Factory, Avadi | | | |
| DRIVE SHAFT Валик привода | | Лист | Масса |
| Steel 45X GOST 4543-71 | | 0,1 | 0,13 |
| Сталь 45X ГОСТ 4543-71 | | Листов | Листов |
| | | 3 | 1 |
| | | Sheet | 162 |
| Формат А4×3 | | | |



EXPLANATORY NOTE

▽5 (▽)

9. REFERENCE MATERIAL QUOTED:
STRUCTURAL ALLOY STEEL MANUFACTURED IN ACCORDANCE WITH CHROMIUM STEEL GRADE 45X TO GOST 4543-71

a. CHEMICAL COMPOSITION.

| GRADE OF STEEL | CONTENT OF ELEMENTS % | | | | | | | |
|----------------|-----------------------|------|------|------|-------|-------|------|------|
| | C | Si | Mn | Cr | P | S | Cu | N |
| 45X | 0.41 | 0.17 | 0.50 | 0.80 | 0.035 | 0.035 | 0.30 | 0.30 |
| | 0.49 | 0.37 | 0.80 | 1.10 | | | | |

b) MECHANICAL PROPERTIES UNDER HARDENED AND TEMPERED CONDITION

| GRADE OF STEEL | ULTIMATE TENSILE STRENGTH Kgf/mm ² | YIELD POINT Kgf/mm ² | ELONGATION % | REDUCTION IN AREA % | IMPACT STRENGTH KJm/cm ² | HARDNESS BHN MAX |
|----------------|---|---------------------------------|--------------|---------------------|-------------------------------------|------------------|
| 45X | 105 | 85 | 9 | 45 | 5 | 229 |

10. REFERENCE NOTE '1' ON INSPECTION GROUP III TT-11 : SUBJECT TO 100% CHECKING OF HARDNESS WITHOUT BEING TESTED FOR MECHANICAL PROPERTIES SURFACE WHICH ARE SUBJECTED TO HEAT TREATMENT TO DIFFERENT GRADES OF HARDNESS. RANDOM CHECKING OF SURFACES WITH LOWER HARDNESS IS ALLOWED BESIDES CHECKING OF MECHANICAL PROPERTIES AND HARDNESS DEPENDING UPON THE INSPECTION GROUP. PERIODIC CHECKS OF MICROSTRUCTURE ARE CARRIED OUT DIRECTION OF GRAIN FLOW IN STAMPINGS SHOULD SATISFY THE REQUIREMENTS OF THE STANDARD.

IN THE FRACTURE OF FINISHED ITEMS OR IN MICROSTRUCTURE THERE SHOULD BE NO SHRINKAGE, CAVITIES, POROSITY, BUBBLES, EXFOLIATIONS, CRACKS, NONMETALLIC INCLUSIONS AND FLAKES VISIBLE TO THE NAKED EYE.

11. REFERENCE NOTE 3. ON COATING: OXIDIZED COPPER FINISH TO IS: 1378-79 AND OILFINISH

- INSPECTION GROUP III TT-11
- HRC 33-37
- COATING: CHEMICAL OXIDIZING OIL FINISHING
- UNSPECIFIED TOLERANCES FOR THE FEMALE DIMENSIONS ARE AS PER A7, THOSE FOR MALE ONES ARE AS PER B7
- RUN OUT OF SPLINES 'A' (ON PITCH DIAMETER) RELATIVE TO THE AXIS OF SPLINES SHOULD NOT EXCEED 0.1mm
- RUN OUT SURFACE B RELATIVE TO THE AXIS OF SPLINES SHOULD NOT EXCEED 0.08mm
- THE SPLINES SHOULD BE ACCEPTED AS PER INSTRUCTIONS UB-19
- TO BE MARKED BY ELECTRICAL ETCHING.

Ⓐ EQUIVALENT MATERIAL STEEL 709M40 (EN19) BS:970/40Cr4Mo3 IS:1570

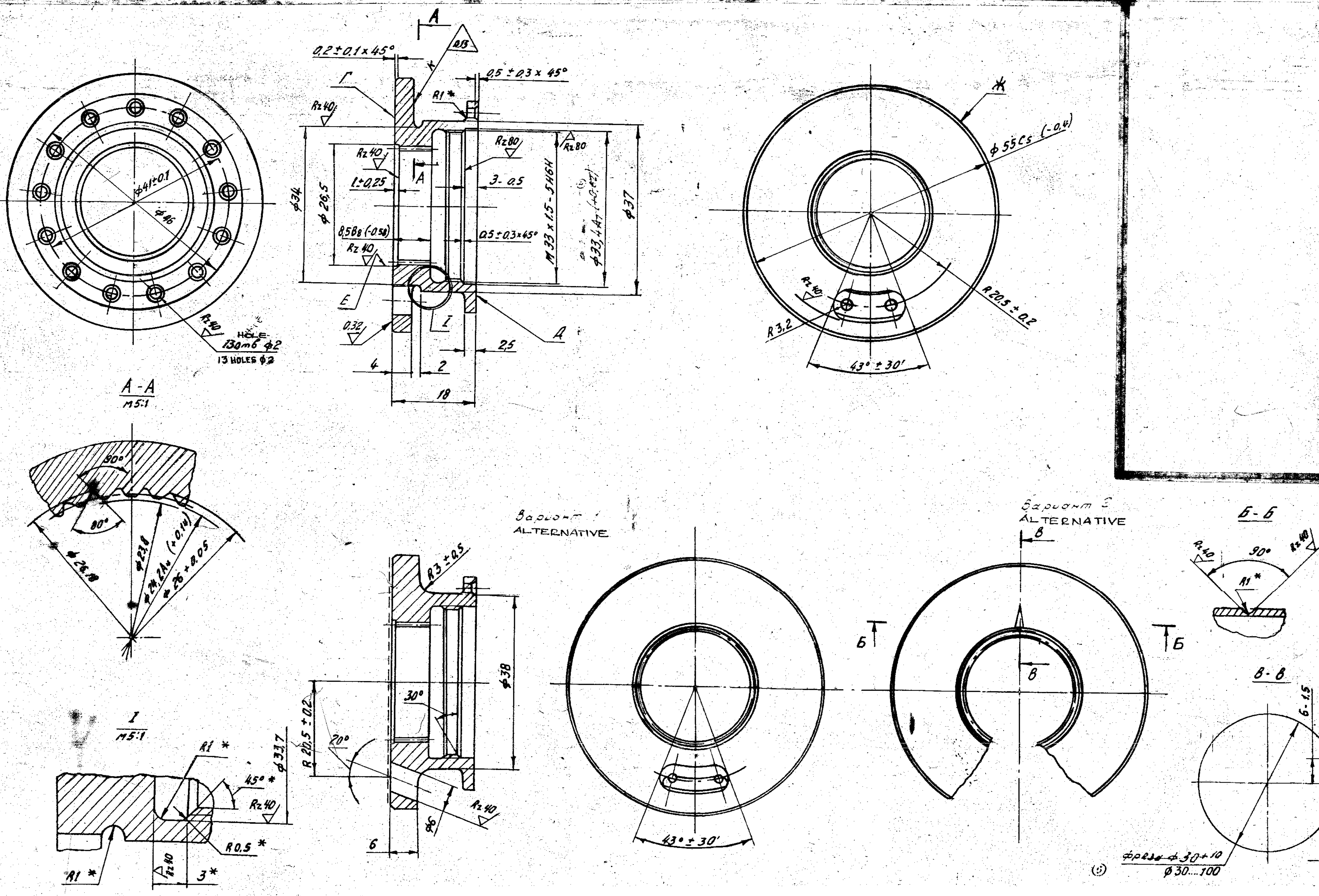
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

EST WT 0.032 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 OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

| | | | | | | | | | |
|--|-----|-----|------|---------|-------|---|--|------------------------|---------------|
| DRN | CHD | TCD | APPD | DATE | SCALE | DIMENSIONS IN mm | TOLERANCE ON DIMNS UNLESS OTHERWISE STATED | MATERIAL | USED ON |
| | | | | 04-4-86 | 2:1 | | | STEEL 45X GOST 4543-71 | CB 310-30A C6 |
| CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI | | | | | | | | TITLE | |
| | | | | | | | | COUPLING SHAFT | |
| ISSUE DATE | | | | | | NATURE OF AMENDMENTS | | DRAWING NUMBER | |
| 12-8-10 | | | | | | 4 th Alt. Comm. Meeting Minutes Point No.11 Dt: 26-10-09 | | 310-08 | |

SIZE A2



EXPLANATORY NOTE

14. REFERENCE MATERIAL QUOTED: ALLOY STEEL BAR, HOT ROLLED, HIGH QUALITY GRADE 12XH3A TO Ty 14-1-381-72 AND MANUFACTURED IN ACCORDANCE WITH GRADE 12XH3A TO GOST 4543-71.

a) CHEMICAL COMPOSITION AS PER GOST 4543-71 (CHROME NICKEL STEEL)

| GRADE OF STEEL | CONTENT OF ELEMENTS % | | | | | MAXIMUM | | |
|----------------|-----------------------|-----------|-----------|-----------|-----------|---------|-------|------|
| | C | Si | Mn | Cr | Ni | P | S | Cu |
| 12XH3A | 0.09-0.16 | 0.17-0.37 | 0.30-0.60 | 0.60-0.90 | 2.75-3.15 | 0.025 | 0.025 | 0.30 |

b) MECHANICAL PROPERTIES AS PER GOST 4543-71

| GRADE OF STEEL | TENSILE STRENGTH Kgf/mm ² | YIELD POINT Kgf/mm ² | ELONGATION % | REDUCTION IN AREA % | IMPACT STRENGTH KJm/cm ² | HARDNESS B.H.N. (MAX) |
|----------------|---|------------------------------------|-----------------|------------------------|--|----------------------------|
| 12XH3A | 95 | 70 | 11 | 55 | 9 | 217 |

15. REFERENCE NOTE '1' ON INSPECTION GROUP III TT-11
SUBJECTED TO 100% CHECKING OF HARDNESS WITHOUT BEING TESTED FOR MECHANICAL PROPERTIES, SURFACES WHICH ARE SUBJECTED TO HEAT TREATMENT TO DIFFERENT GRADES OF HARDNESS, RANDOM CHECKING OF SURFACES WITH LOWER HARDNESS IS ALLOWED.
BESIDES CHECKING OF MECHANICAL PROPERTIES AND HARDNESS DEPENDING UPON THE INSPECTION GROUP, PERIODIC CHECKS OF MICROSTRUCTURE ARE CARRIED OUT. DIRECTION OF GRAIN FLOW IN STAMPINGS SHOULD SATISFY THE REQUIREMENTS OF THE STANDARD.
IN THE FRACTURE OF FINISHED ITEMS OR MICROSTRUCTURE, THERE SHOULD BE NO SHRINKAGE, CAVITIES, POROSITY, BUBBLES, EXFOLIATIONS, CRACKS, NON-METALLIC INCLUSIONS AND FLAKES VISIBLE TO THE NAKED EYE.

16. REFERENCE NOTE '10' ON PROTECTIVE FINISH :
OXIDIZED-COPPER FINISH TO IS : 1378-79 AND OIL FINISH.

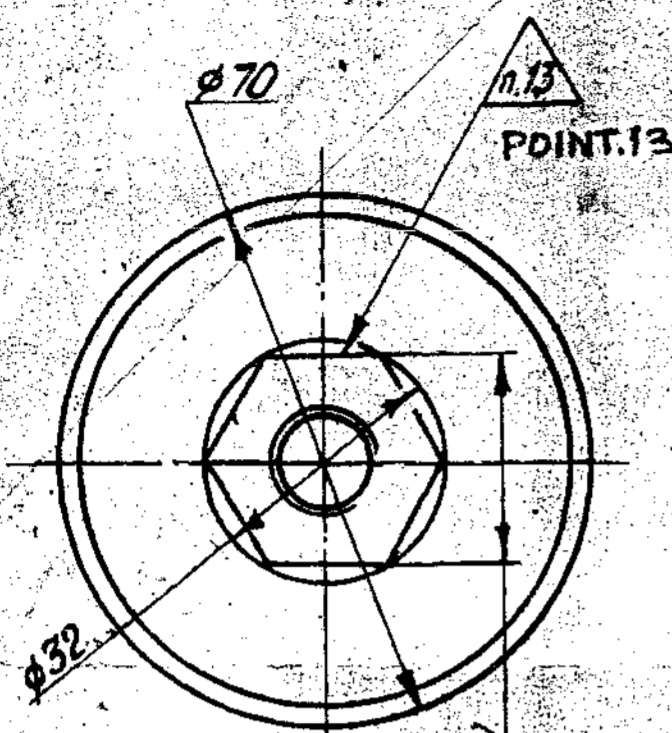
| SPLINE DATA | |
|--------------------|--------------------------------|
| NUMBER OF TEETH | z = 36 |
| PIN DIAMETER | d _p = 16.41 |
| DIMENSION OVER PIN | M _d = φ22.49 ± 0.05 |
| REFERENCE CIRCLE | S _d |
| DIAMETER | d _s = 26.91 ± 0.05 |

- INSPECTION GROUP III TT-11.
- SURFACE 'Y' SHOULD BE CARBURIZED: H 0.5-0.9 HRC (≥ 5.9 A)
- UNCARBURIZED SURFACES HRC 26-40.
- SURFACES 'Y' AND 'E' MAY BE CARBURIZED.
- UNSPECIFIED TOLERANCES SHOULD BE MAINTAINED AS PER ACCURACY CLASS 7 OST 1010.
- THE THREAD SURFACE SHOULD BE CLEAN WITHOUT SCORES, BURNS, BURRS AND THREADS, NICKS, CORROSION MARKS AND OTHER SURFACE DEFECTS.
- NON-SQUARENESS OF SURFACE 'I' RELATIVE TO THE AXIS OF THREAD SHOULD NOT EXCEED 0.1mm.
- FACE OUT OF SURFACE 'Y' ON φ52mm RELATIVE TO THE AXIS OF SPLINES SHOULD NOT EXCEED 0.05mm.
- SURFACE 'I' TO BE CHECKED BY BLUEING, THE IMPRINT SHOULD BE CONSISTENT ALONG THE ENTIRE FACE.
- COATING WITH OXIDIZING OIL FINISHING.
- SURFACE 'I' MAY NOT BE OXIDIZED.
- * DIMENSIONS SHOULD BE ENSURED BY TOOL.
- TO BE PUNCHES.

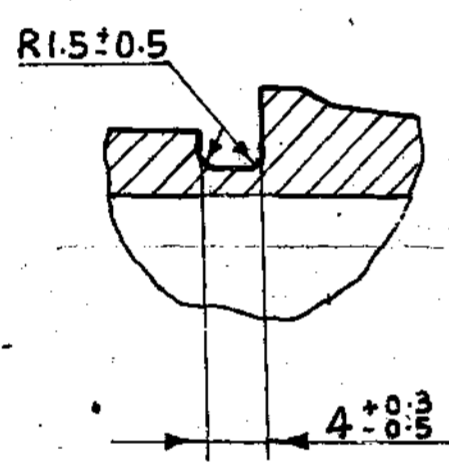
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

| | | | | | | | | | | | | | | |
|---|---|--|------------------|----------------------|-----|-----|------|------|-------|--|--|--|--|--|
| EST WT 0.816g | TO BE STAMPED OR MARKED WHERE INDICATED THIS BY LETTERS | 07-4-87 HARDNESS FIGURE WAS 25-48 DRAWING ADVANCED TO ISSUE AUTHORITY LETTER NO. 83307 / CMV (P) / 0.0 / V 46 / IND IV | DATE 01 APR 1987 | NATURE OF AMENDMENTS | | | | | | | | | | |
| ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE | | <table border="1"> <tr> <td>DRW</td> <td>TCB</td> <td>APRD</td> <td>DATE</td> <td>SCALE</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table> | | | DRW | TCB | APRD | DATE | SCALE | | | | | |
| DRW | TCB | APRD | DATE | SCALE | | | | | | | | | | |
| | | | | | | | | | | | | | | |
| MATERIAL: STEEL 12XH3A Ty 14-1-381-72 | | USED ON: CB 310-38A 05 | | | | | | | | | | | | |
| CONTROLLERATE OF INSPECTION (HEAVY VEHICLES AVADI) | | TITLE: DISC DISTRIBUTOR | | | | | | | | | | | | |
| D S CAT NUMBER | | DRAWING NUMBER: 310-09-1 | | | | | | | | | | | | |

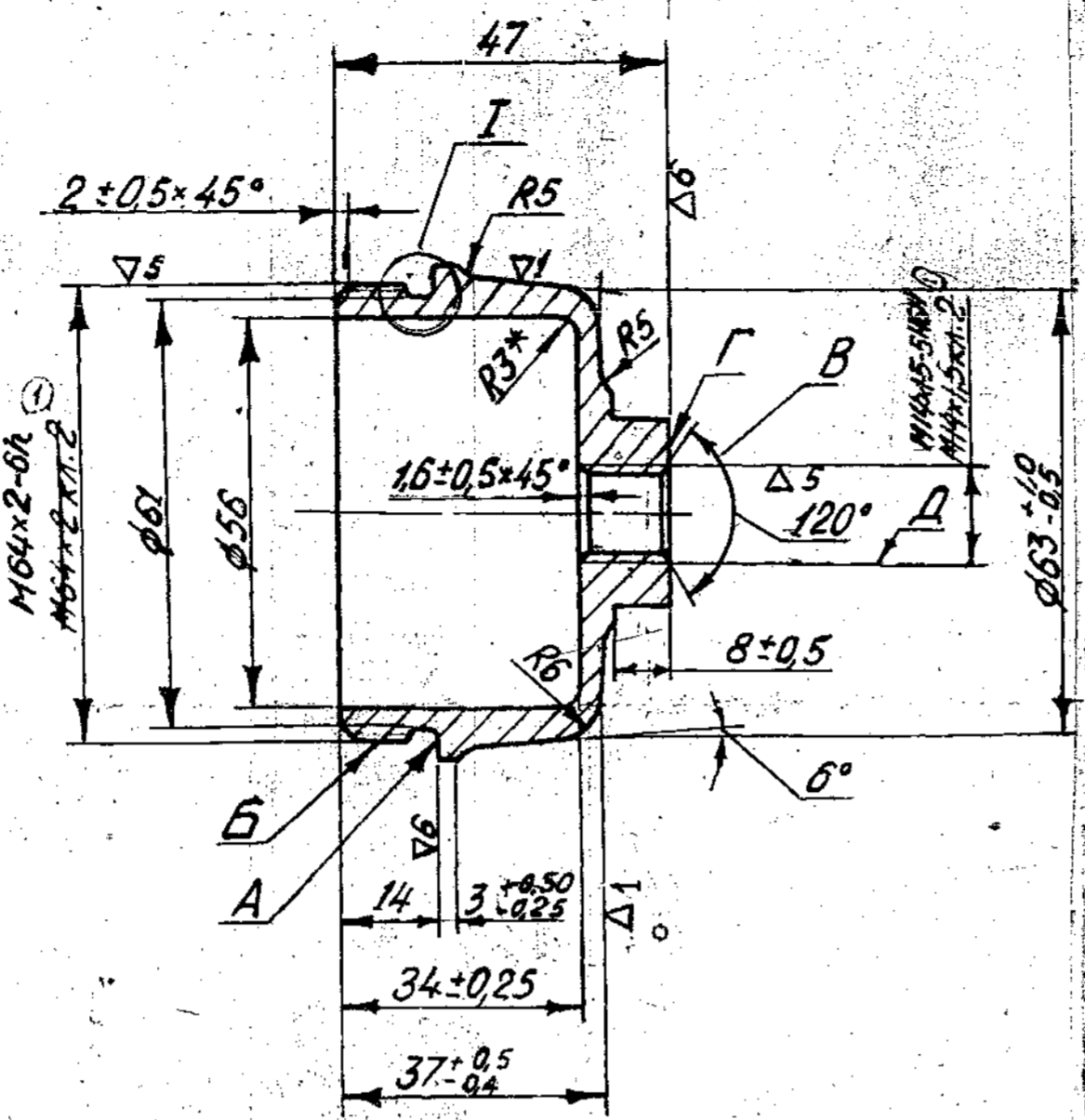
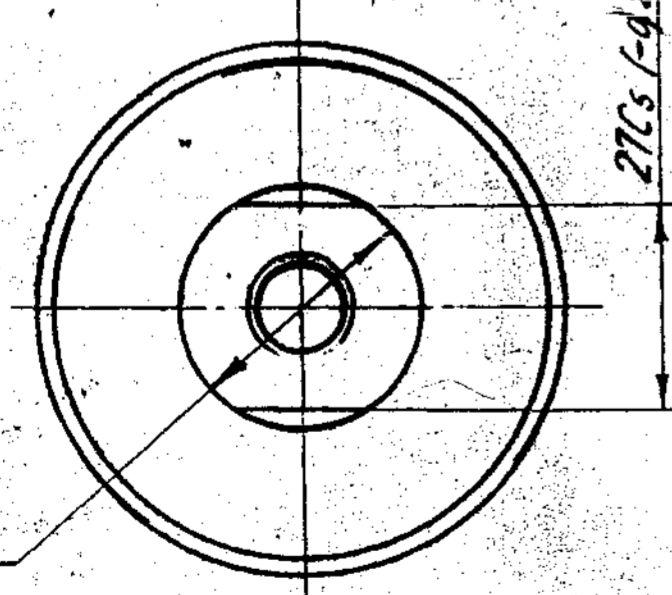
DRAWING NUMBER
310 10



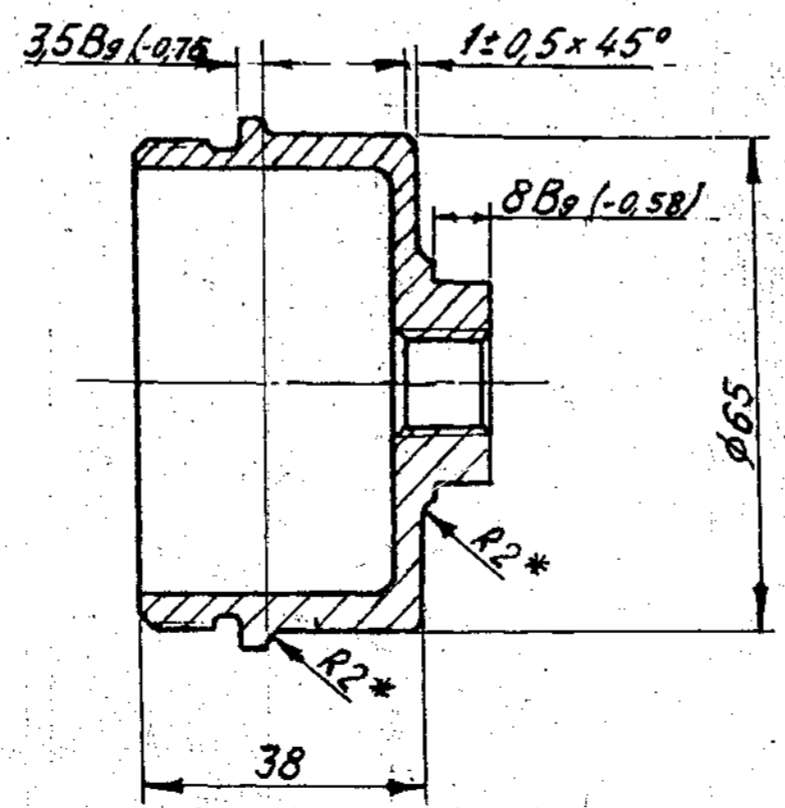
SCALE 2:1



ALTERNATIVE
Варуаһт



ALTERNATIVE
Варуаһт



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

EST WT 0.3 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

1. INSPECTION GROUP III TT-11.
2. HRC 26 - 33.
3. REQUIREMENTS FOR STAMPING ARE IN ACCORDANCE WITH GOST 7506-74 (A)
4. UNSPECIFIED TOLERANCES FOR DIMENSION SHOULD BE AS PER ACCURACY CLASS 7 GOST 1010.
5. FACE OUT OF SURFACE 'A' SHOULD NOT EXCEED 0.1mm RELATIVE TO THE AXIS OF THREAD 'B'.
6. NON SQUARENESS OF SURFACE 'Г' MEASURED WITHIN THE COMPONENT DIMENSIONS SHOULD NOT EXCEED 0.1mm RELATIVE TO THE AXIS OF THREAD (A)
7. CHAMFER 'B' SHOULD MADE UP TO THE MAJOR DIAMETER OF THE THREAD.
8. THREAD SURFACE SHOULD BE CLEAN WITHOUT SCORES, BURNS, STOPPED THREADS, NICKS, CORROSION MARKS AND OTHER SURFACE DEFECTS.
9. DELETED.
10. COATING - Cf 9, CHEMIZING AS PER GOST 9004 WITH REMOVAL OF HYDROGEN BRITTLENESS. UH.569-84 (B)
11. DELETED.
12. ON THREADS B AND A AREAS WITHOUT COATING ARE ALLOWED.
13. TO BE PUNCH MARKED.
14. * DIMENSIONS ARE FOR REFERENCE.

EXPLANATORY NOTE:

15. REFERENCE MATERIAL QUOTED:
STRUCTURAL ALLOY STEEL MANUFACTURED IN ACCORDANCE WITH CHROMIUM STEEL GRADE 45X TO GOST 4543-71.

a) CHEMICAL COMPOSITION:

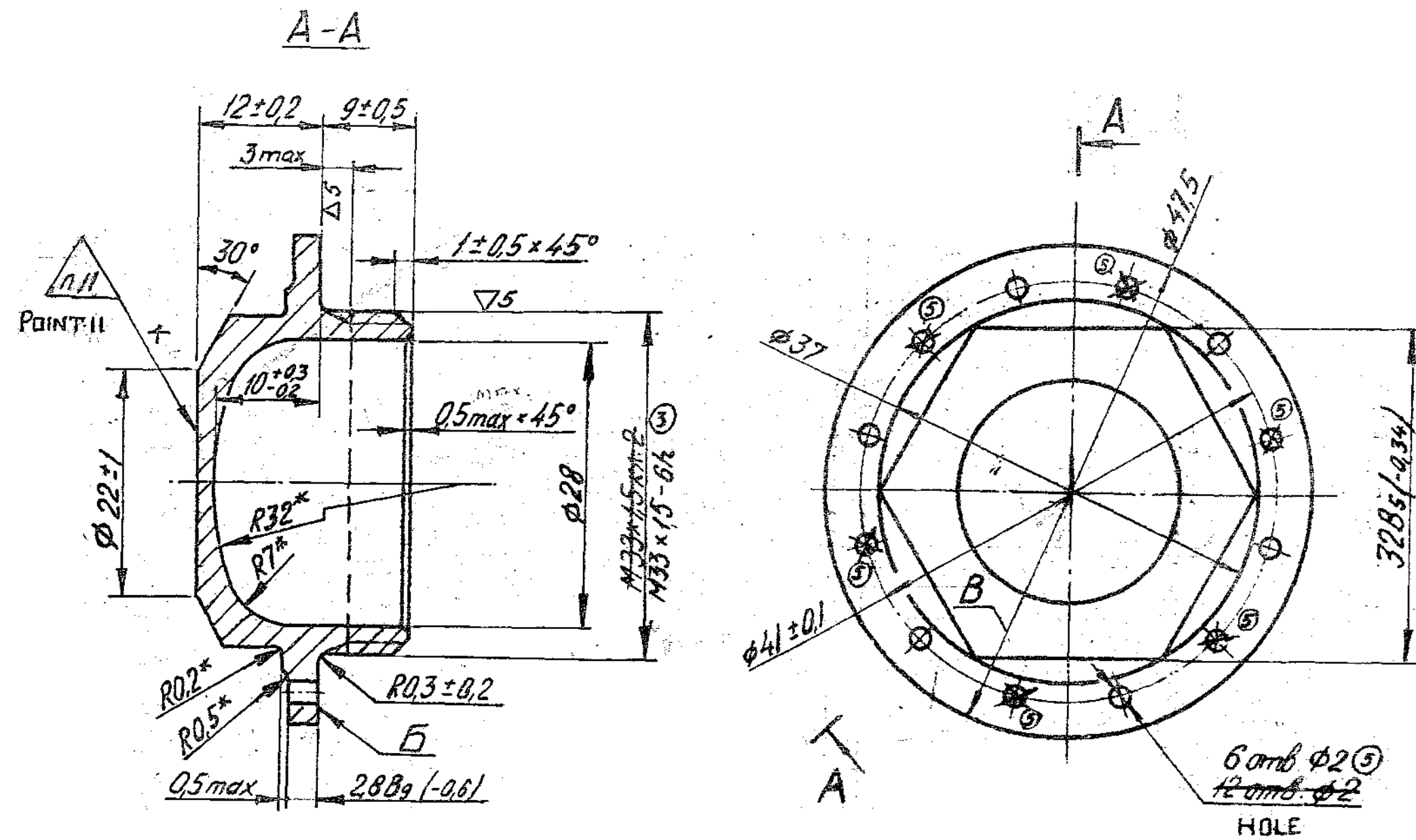
| GRADE OF STEEL | CONTENT OF ELEMENTS % | | | | | | | |
|----------------|-----------------------|-----------|-----------|-----------|-------|-------|------|------|
| | C | Si | Mn | Cr | P | S | Cu | Ni |
| 45X | 0.41-0.49 | 0.17-0.37 | 0.50-0.80 | 0.80-1.10 | 0.035 | 0.035 | 0.30 | 0.30 |

b) MECHANICAL PROPERTIES UNDER HARDENED AND TEMPERED CONDITION AS PER GOST 4543-71

| GRADE OF STEEL | ULTIMATE TENSILE STRENGTH Kgf/mm ² | YIELD POINT Kgf/mm ² | ELONGATION % | REDUCTION IN AREA % | IMPACT STRENGTH Kgm/cm ² | HARDNESS B H N. M A X |
|----------------|---|---------------------------------|--------------|---------------------|-------------------------------------|-----------------------|
| 45X | 105 | 85 | 9 | 45 | 5 | 229 |

| | | | | | | | |
|--|---------|-----|------|---------|-------|--|------------------------|
| DRN | CHD | TCD | APPD | DATE | SCALE | MATERIAL: STEEL 45X GOST 4543-71 | USED ON: CB 310 30A CB |
| 1.2.97 | 07.4.87 | | | 06.7.86 | 1:1 | CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI | TITLE: DISTRIBUTOR CAP |
| AUTHY NOTN. No. BK 86-41 | | | | | | | |
| SPECN. NO. WAS GOST 7506-74 DRAWING ADVANCED TO ISSUE 'A' AUTHY. LETTER No. 83321 / CMV (P) / GD / V 46 / IND IV | | | | | | D S CAT NUMBER | DRAWING NUMBER 310 10 |
| DATE 01 APR 1987 | | | | | | | |
| NAME OF AMENDMENTS | | | | | | | |

A-5
SIZE A2



2. UNSPECIFIED TOLERANCES OF DIMENSIONS SHOULD AS PER ACCURACY CLASS 7 OST 1010
3. THREADED SURFACE SHOULD BE CLEAN WITH-OUT SCORES, BURRS, STRIPPED THREAD, NICKS, CORROSION MARKS AND OTHER SURFACE DEFECTS.
4. NON SQUARENESS OF SURFACE B RELATIVE TO THE THREAD AXIS SHOULD NOT EXCEED 0.1mm WHEN MEASURED WITHIN THE COMPONENT DIMENSIONS.
5. THE TOOL DIGGING INTO CYLINDRICAL SURFACE TO A DEPTH NOT EXCEEDING 0.3mm IS ALLOWED WHILE FACING SURFACE
6. MAY BE MANUFACTURED BY PRECISION CASTING FROM STEEL 45 GOST 977-75
7. MAY BE MANUFACTURED FROM ROUND BAR 46-5 GOST 7417-75 WITHOUT MACHINING ON DIMENSION B, 45 GOST 1051-73
9. COATING: cd 3, CHROMATIZING ACCORDING TO ULL 104 WITH SUBSEQUENT REMOVAL OF HYDROGEN BRITTLNESS
10. THREAD MAY NOT BE COATED.
11. TO BE PUNCH MARKED.
12. DIMENSIONS SHOULD BE ENSURED BY TOOL.

EXPLANATORY NOTE :

13. REFERENCE MATERIAL QUOTED: QUALITY CARBON STRUCTURAL STEEL GRADE 45 AND REFERENCE NOTE 7 ON ALTERNATE MATERIAL, COLD ROLLED SIZED STEEL ROUND $\phi 60$ mm, CLASS OF ACCURACY 'S1'-0,3401 TO GOST 7417-75, NORMAL SURFACE QUALITY TO GOST 1051-73 AND MANUFACTURED IN ACCORDANCE WITH STEEL GRADE 45 TO GOST 1050-74.

a) CHEMICAL COMPOSITION AS PER GOST 1050-74

| GRADE OF STEEL | CONTENT OF ELEMENTS % | | | | | |
|----------------|-----------------------|-----------|-----------|------|-------|-------|
| | C | Si | Mn | Cr | S | P |
| 45 | 0.42-0.50 | 0.17-0.37 | 0.50-0.80 | 0.25 | 0.040 | 0.035 |

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

b) MECHANICAL PROPERTIES UNDER NORMALISED CONDITION AS PER GOST 1050-74.

| GRADE OF STEEL | ULTIMATE TENSILE STRENGTH Kgf/mm ² | YIELD POINT Kgf/mm ² | ELONGATION % | REDUCTION IN AREA % | | IMPACT STRENGTH KJm/cm ² | HARDNESS BHN max |
|----------------|---|---------------------------------|--------------|---------------------|-----|-------------------------------------|------------------|
| | | | | % | GTH | | |
| 45 | 61 | 36 | 16 | 40 | 5 | 229 | |

14. REFERENCE NOTE '6' ON ALTERNATE MATERIAL, CASTING OF UNALLOYED STRUCTURAL STEEL GRADE 45A TO GOST 977-75.

a) CHEMICAL COMPOSITION

| GRADE OF STEEL | CONTENT OF ELEMENTS % | | | | | | | | |
|----------------|-----------------------|-----------|-----------|-------|------|------|------|------|---------|
| | C | Mn | Si | P | S | Cr | Ni | Cu | MAXIMUM |
| 45A | 0.42-0.50 | 0.40-0.90 | 0.20-0.52 | 0.045 | 0.04 | 0.30 | 0.30 | 0.30 | |

b) MECHANICAL PROPERTIES UNDER NORMALIZING CONDITION:

| GRADE OF STEEL | ULTIMATE TENSILE STRENGTH Kgf/mm ² | YIELD POINT Kgf/mm ² | ELONGATION % | REDUCTION IN AREA % | | IMPACT STRENGTH KJm/cm ² |
|----------------|---|---------------------------------|--------------|---------------------|-----|-------------------------------------|
| | | | | % | GTH | |
| 45A | 55 | 32 | 12 | 20 | 3.0 | |

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

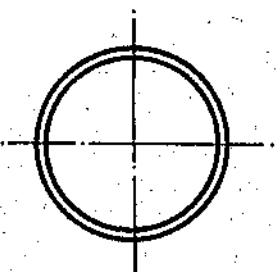
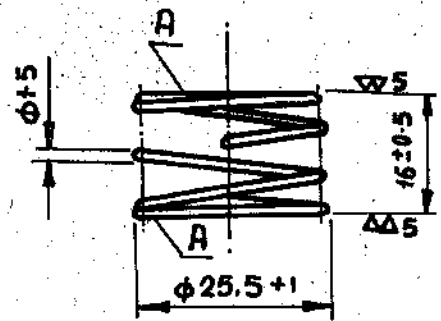
EST WT 0.060 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

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

| | | | | | | | | | | |
|-----------------------|-----|-----|---------------|---------|-------|--|--|---------------------------|------------|----------------------|
| DRN | CHD | TCD | APPD | DATE | SCALE | DIMENSIONS IN mm | TOLERANCE ON DIMNS UNLESS OTHERWISE STATED | ALL THREADS TO CONFORM TO | ISSUE DATE | NATURE OF AMENDMENTS |
| | | | | 04-4-88 | 2:1 | | | | | |
| MATERIAL | | | USED ON | | | CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI | | | | |
| STEEL 45 GOST 1050-74 | | | C5 310-30A C5 | | | | | | | |
| TITLE | | | | | | COVER DISTRIBUTOR DISC | | | | |
| D S CAT NUMBER | | | | | | DRAWING NUMBER | | | | |
| | | | | | | 310-11 | | | | |

DRAWING NUMBER
310 12

~ W5



EXPLANATORY NOTE:

7. REFERENCE MATERIAL QUOTED:

CARBON STEEL SPRING WIRE OF CATEGORY II, NORMAL ACCURACY $\phi 1.5\text{mm}$
 NORMAL ACCURACY (± 0.03) TO GOST 9389-75 AND MANUFACTURED IN
 ACCORDANCE WITH CARBON STRUCTURAL STEEL TO GOST 1050-74.
 a) MECHANICAL PROPERTIES AS PER 9389-75.

| CATEGORY | ULTIMATE TENSILE STRENGTH Kgf/mm ² | NUMBER OF BENDS. | NUMBER OF TWISTS |
|----------|---|------------------|------------------|
| II | 190 - 225 | 15 | 17 |

- NON SQUARENESS OF SURFACES 'A' RELATIVE TO THE AXIS SHOULD NOT EXCEED 1.0mm (ON SQUARE) ON LENGTH OF THE SPRING
- THE INCREASE OF OUTER DIAMETER OF THE RESTING COILS MAY BE UPTO 27mm.
- THE GAP UPTO 0.25mm IS ALLOWED BETWEEN THE COMPRESSED COILS.
- THE GAP BETWEEN THE SURFACE PLATE AND GROUND SURFACE OF COIL SHOULD NOT EXCEED 0.3mm ON LENGTH OF 1/8 OF THE CIRCUMFERENCE.
- BURRS ARE NOT PERMISSIBLE.
- COATING: Zn12, CHROMATIZING AS PER VJT -483.82.

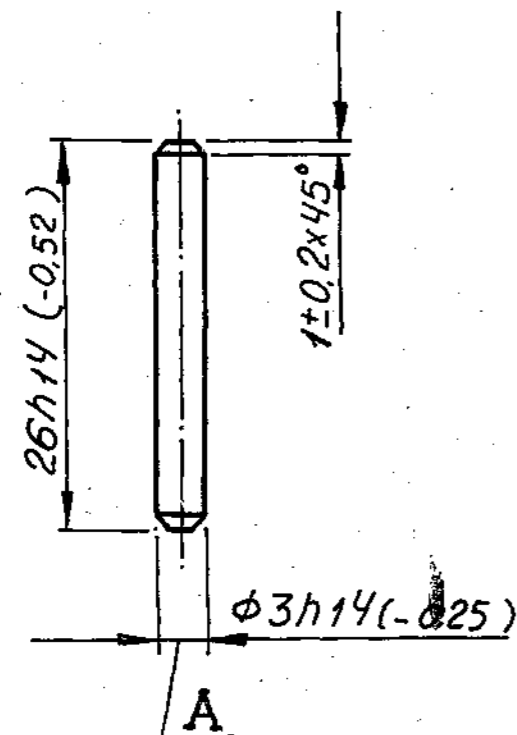
| | |
|-------------------------|-------|
| NUMBER OF WORKING COILS | 3.5 |
| TOTAL NUMBER OF COILS | 6-0.5 |
| LENGTH OF DEVELOPMENT | 453 |
| DIRECTION OF COILING | R H |

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

EST. WT 0.0056 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 OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

| | | | |
|--|---------------------------|--|---------------|
| DRN | <i>ks</i> | MATERIAL: WIRE II 1.5 | USED ON: |
| CHD | <i>Parthiv Kumar</i> | GOST 9389-75 | CS 310 30A CS |
| TCD | <i>Aravind Kumar</i> | CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI | |
| APPD | <i>Ranjan</i> | TITLE: SPRING COUPLING | |
| DATE | 04-4-86 | D S CAT NUMBER | |
| SCALE: 1 : 1 | DIMENSION IN mm | DRAWING NUMBER | |
| TOLERANCE ON DIMNS UNLESS OTHERWISE STATED | ALL THREADS TO CONFORM TO | 310 12 | |
| ISSUE | DATE | NATURE OF AMENDMENTS | |

(A-5)
SIZE A3



1. COATING : CHEMICAL OXIDIZING OIL FINISHING.
2. ALTERNATE MATERIALS STEEL Y7,Y7A,Y8 GOST 1435-74.
3. MAY BE MANUFACTURED FROM ROUND BAR $\frac{3-4}{45-B}$ GOST 7417-75
OR WIRE II-3 GOST 9389-60 WITHOUT MACHINING ON DIMENSION 'A'.

EXPLANATORY NOTE

4. REFERENCE MATERIAL QUOTED: HIGH GRADE SIZED STEEL ROUND TO GOST 1051-73 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL GRADE 45 TO GOST 1050-74.
- a) CHEMICAL COMPOSITION AS PER GOST 1050-74

| GRADE OF STEEL | CONTENT OF ELEMENTS % | | | | | |
|----------------|-----------------------|-----------|-----------|------|-------|-------|
| | C | Si | Mn | Cr | S | P |
| 45 | 0.42-0.50 | 0.17-0.37 | 0.50-0.80 | 0.25 | 0.040 | 0.035 |

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

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

EST WT 0.001 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

- b) MECHANICAL PROPERTIES UNDER NORMALISED CONDITION AS PER GOST 1050-74

| GRADE OF STEEL | ULTIMATE TENSILE STRENGTH Kgf/mm ² | YIELD POINT Kgf/mm ² | ELONGATION % | REDUCTION IN AREA % | IMPACT STRENGTH Kgf/cm ² | HARDNESS BHN |
|----------------|---|---------------------------------|--------------|---------------------|-------------------------------------|--------------|
| 45 | 61 | 36 | 16 | 40 | 5 | 229 |

5. REFERENCE NOTE '2' ON ALTERNATE MATERIAL: HOT ROLLED SIZED CARBON TOOL STEEL ROUND, AND MANUFACTURED TO GROUP OF QUALITY STEEL GRADE Y7 AND Y8, GROUP OF VERY QUALITY STEEL GRADE Y7A TO GOST 1435-74

CHEMICAL COMPOSITION AS PER GOST 1435-74.

| Gde. OF STEEL | CONTENT OF ELEMENTS % | | | | | | | |
|---------------|-----------------------|-----------|-----------|-------|-------|------|------|------|
| | C | Mn | Si | S | P | Cr | Ni | Cu |
| Y7 | 0.65-0.74 | 0.20-0.40 | 0.15-0.35 | 0.030 | 0.035 | 0.20 | 0.25 | 0.25 |
| Y8 | 0.75-0.84 | 0.20-0.40 | 0.15-0.35 | 0.030 | 0.035 | 0.20 | 0.25 | 0.25 |
| Y7A | 0.65-0.74 | 0.15-0.30 | 0.15-0.35 | 0.020 | 0.030 | 0.15 | 0.20 | 0.20 |

6. A. REFERENCE NOTE '3' ON ALTERNATE MATERIAL: COLD ROLLED SIZED STEEL ROUND BAR $\phi 3(-0.060)$ mm CLASS OF ACCURACY TO GOST 7417-75, HIGH GRADE SIZED STEEL ROUND GROUP OF SURFACE QUALITY 'B' TO GOST 1051-73 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL Gde 45 TO GOST 1050-74
- a) CHEMICAL COMPOSITION AS PER GOST 1050-74

| GRADE OF STEEL | CONTENT OF ELEMENTS % | | | | | |
|----------------|-----------------------|-----------|-----------|------|-------|-------|
| | C | Si | Mn | Cr | S | P |
| 45 | 0.42-0.50 | 0.17-0.37 | 0.50-0.80 | 0.25 | 0.040 | 0.035 |

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

b) MECHANICAL PROPERTIES UNDER NORMALISED CONDITION AS PER GOST 1050-74

| Gde. OF STEEL | ULTIMATE TENSILE STRENGTH Kgf/mm ² | YIELD POINT Kgf/mm ² | ELONGATION % | REDUCTION IN AREA % | IMPACT STRENGTH Kgf/mm ² | HARDNESS BHN |
|---------------|---|---------------------------------|--------------|---------------------|-------------------------------------|--------------|
| 45 | 61 | 36 | 16 | 40 | 5 | 229 |

- B. CARBON STEEL SPRING WIRE CATEGORY II, $\phi 3.0$ mm NORMAL ACCURACY ± 0.03 TO GOST 9389-75 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL TO GOST 1050-74
- MECHANICAL PROPERTIES AS PER GOST 9389-75

| CATEGORY | ULTIMATE TENSILE STRENGTH Kgf/mm ² | No. OF BENDS MIN | No. OF TWISTS MIN |
|----------|---|------------------|-------------------|
| II | 165-190 | 5 | 13 |

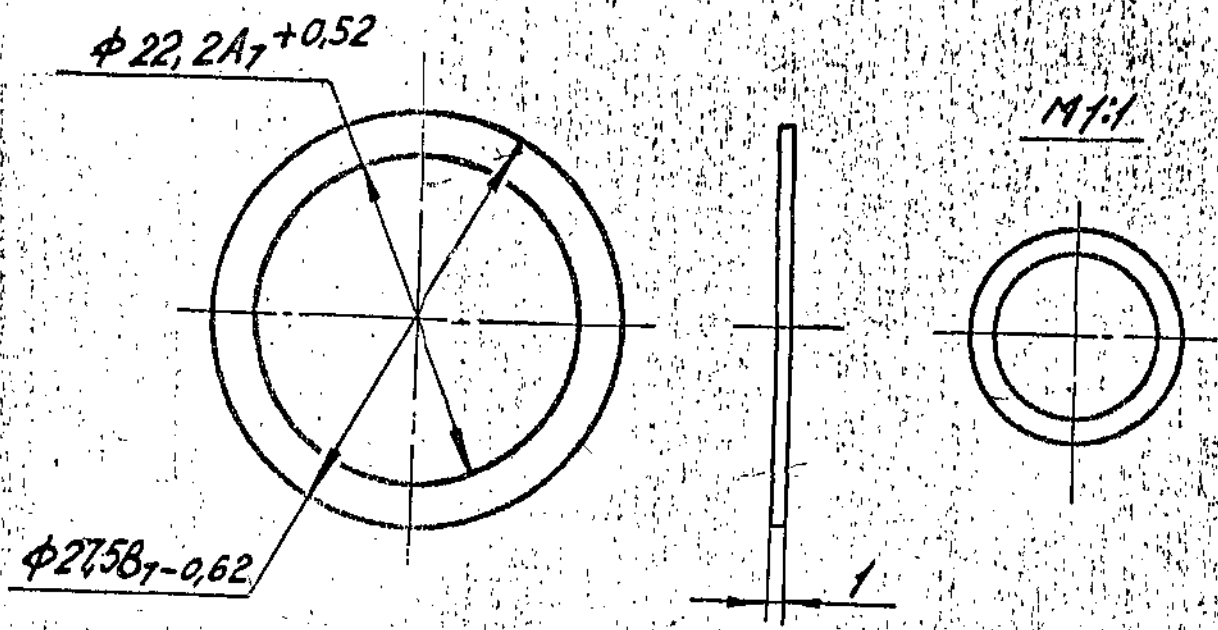
7. REFERENCE NOTE 1, ON PROTECTIVE FINISH: OXIDIZED - COPPER FINISH TO IS : 1378-79 AND OIL FINISH.

| | | | | | | | | | | | |
|--|-----|-----|------|------|-------|-----------------------|---|---------------------------|-------|------|----------------------|
| DRN | CHD | TCD | APPD | DATE | SCALE | DIMENSIONS IN mm | TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69 | ALL THREADS TO CONFORM TO | ISSUE | DATE | NATURE OF AMENDMENTS |
| | | | | | 2:1 | | | | | | |
| MATERIAL | | | | | | STEEL 45 GOST 1051-73 | | USED ON | | | |
| | | | | | | | | CS 310-30A CS | | | |
| CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) | | | | | | | | AVADI | | | |
| TITLE | | | | | | | | PIN DOWEL | | | |
| D S CAT NUMBER | | | | | | DRAWING NUMBER | | | | | |
| | | | | | | 310-13 | | | | | |

310-17-1

2

DRAWING INDIANISED BASED ON ISSUE 4



1. Требования, предъявляемые к штамповке, по нормам 82050-16.
 2. Острые кромки затупить. $R_{2,5}$ по ИЛ-104
 3. Покрытие Ц.б. хр. по ИЛ-483-82
 4. Заменитель материала сталь марок 10КП, 15КП. ГОСТ 1050-74 и лист 1 ГОСТ 19904-74
 II-10 ГОСТ 16523-70

1. REQUIREMENTS FOR STAMPED COMPONENT SHOULD BE AS PER STANDARD 82050-16
2. SHARP EDGES SHOULD BE BLUNTED.
3. COATING: Zn6, CHROMATIZING AS PER ИЛ - 483-82
4. ALTERNATE MATERIAL: STEEL GRADES 10KP, 15KP, GOST 1050-74 OR SHEET 1 GOST 19904-74 II-10 GOST 16523-70

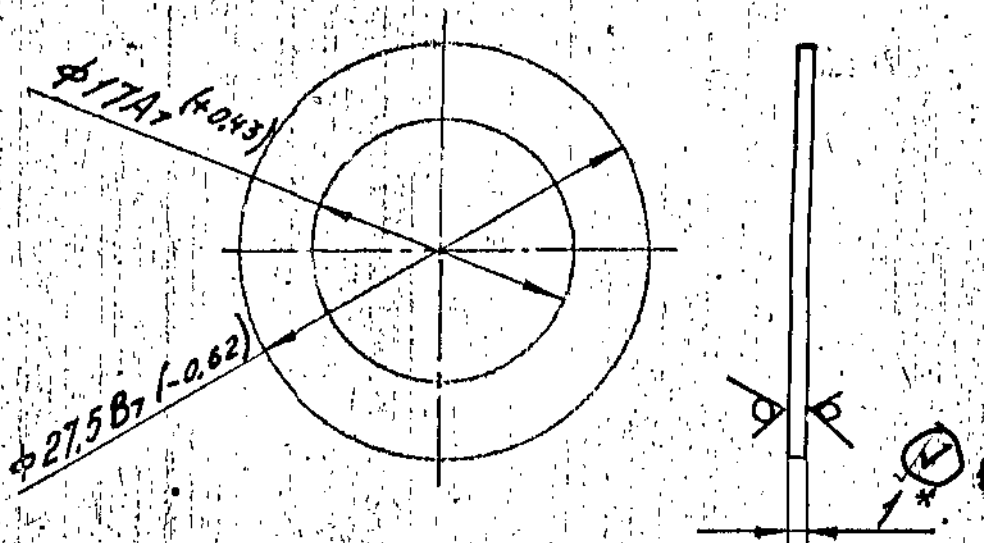
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

| | | | | |
|-------------------------|--|---|---|------------|
| | | EST MASS 0.0015 kg | TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS) | A 5 114 |
| | | ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE | | |
| ISSUE DATE | NATURE OF AMENDMENTS | | | |
| DRN / | SCALE:- 2 : 1 | MATERIAL:- STRIP 10-8H- 2-1 GOST 503-81 | USED ON:- C8 310-30A | |
| CPD <i>[Signature]</i> | DIMENSIONS IN mm | | | |
| TCD <i>[Signature]</i> | TOLERANCE ON DIMNS UNLESS OTHERWISE STATED | CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI | | |
| APPD <i>[Signature]</i> | | TITLE:- WASHER | | |
| DATE 19.12.87 | ALL THREADS CONFORM TO | D S CAT NUMBER | DRAWING NUMBER 310-17-1 | |

310-18-1

ЕЛКА

DRAWING INDIANISED BASED ON ISSUE 3



6. REPAIR SIZE DIMENSIONS ARE ADDED BASED ON LT NO: 82847/06/015/50 DT: 27 MAR 98 WHERE INDICATED THUS (4) AS FOLLOWS:

- 1. ~~Справка контроля~~ по ~~ТТ~~
- 2. Покрытие Ц.б. хр. по ~~ТТ~~
- 3. В троллическом исполнении Покрытие КД 9. хр по ЦЦЛ-104
- 4. * Размер для справок.
- 5. Заменитель материала сталь марок 10КП, 15КП, ГОСТ 1050-74 и лист 1 ГОСТ 19904-74 II-10 ГОСТ 16523-70.

- 3. COATING: Cd 9, CHROMATIZING AS PER ЦЦЛ -104
- 4. DIMENSION FOR REFERENCE.
- 5. ALTERNATE MATERIAL: STEEL GRADES 10KP, 15KP, GOST 1050-74 OR SHEET 1 GOST 19904-74 II-10 GOST 16523-70

| Sl. No | R1 | R2 | REMARKS |
|--------|-----|-----|--|
| (4) | 1.5 | 2.0 | ALL OTHER CONDITIONS AS PER STD DRG. MODEL REPAIR SIZE |

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

EST MASS
0.0025kg

TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)

A 5
115

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

ISSUE DATE NATURE OF AMENDMENTS.

DRN ✓ SCALE:- .2 : 1

CHD DIMENSIONS IN mm

TCD TOLERANCE ON DIMNS UNLESS OTHERWISE STATED

APPD ALL THREADS CONFORM TO

DATE 19/11/67

MATERIAL:- 10-8H-2-1
GOST 503-81

USED ON:- C6 310-30A

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI



TITLE:-

WASHER

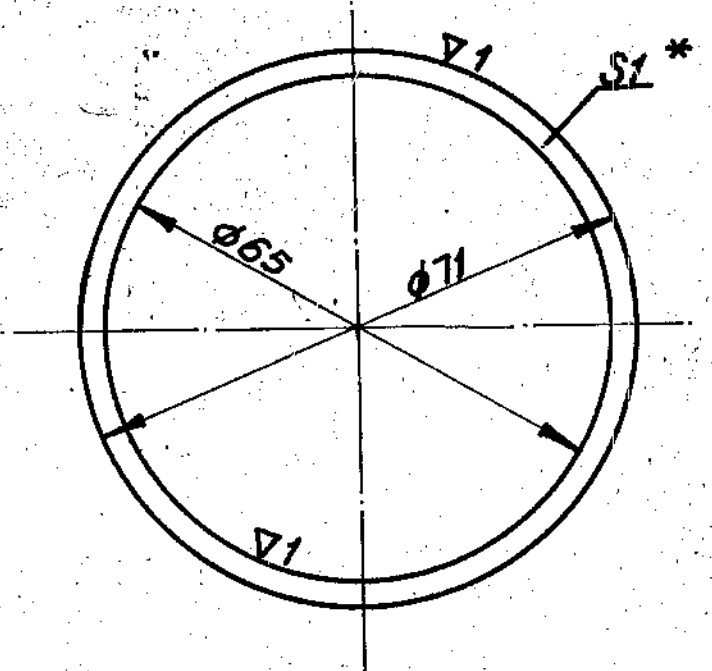
D S CAT NUMBER

DRAWING NUMBER

310-18-1

EXPLANATORY NOTE:

EU (D)



5. REFERENCE MATERIAL QUOTED:

ALUMINIUM ALLOY SHEET GRADE A11, ANNEALED 'M' 1mm THICK, AND REFERENCE NOTE 4, ON ALTERNATE MATERIAL ALUMINIUM ALLOY GRADE A10, ANNEALED 'M' 1mm THICK, MANUFACTURED IN ACCORDANCE WITH ALUMINIUM ALLOY TO GOST 4784-74.

a) CHEMICAL COMPOSITION AS PER GOST 4784-74.

| GRADE OF ALLOY | ALLOYING CONSTITUENTS % | IMPURITIES MAXIMUM | | | | | | | OTHER IMPURITIES EACH INDIVIDUALLY |
|----------------|-------------------------|--------------------|------|------|-------|-----|-----|------|------------------------------------|
| | | Fe | Si | Cu | Mn | Zn | Ti | Mg | |
| A11 | 99.3 min | 0.30 | 0.30 | 0.05 | 0.025 | 0.1 | 0.1 | 0.05 | 0.02 |
| A10 | 99.5 min | 0.30 | 0.30 | 0.02 | 0.025 | 0.1 | 0.1 | 0.05 | 0.02 |

b) MECHANICAL PROPERTIES UNDER ANNEALED CONDITION AS PER GOST 21631-76.

| GRADE OF ALLOY | TENSILE STRENGTH Kgf/mm ² | ELONGATION % |
|----------------|--------------------------------------|--------------|
| A11 A10 | 6.0 | 28 |

1. REQUIREMENTS FOR STAMPED COMPONENT SHOULD BE AS PER STANDARD B2050-16.
2. TO BE ANNEALED AFTER STAMPING.
3. * DIMENSION FOR REFERENCE.
4. ALTERNATE MATERIAL: SHEET 1 A10M GOST 21631-76.

USED ON:
Cb-20-01-00-8
Cb-20-10-00-4
CB 310-30A CB

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

EST WT 0.0016 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 OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

| | | | | | | | |
|-------|------|----------------------|------|------|---|--------------------------------------|--|
| DRN | CHD | TCD | APPD | DATE | SCALE: 1 : 1 | MATERIAL: SHEET TIA11M GOST 21631-76 | CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI |
| | | | | | DIMENSIONS IN mm | TITLE GASKET | |
| | | | | | TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69 | D S CAT NUMBER | DRAWING NUMBER 310 19 |
| | | | | | ALL THREADS TO CONFORM TO | | |
| ISSUE | DATE | NATURE OF AMENDMENTS | | | | | |

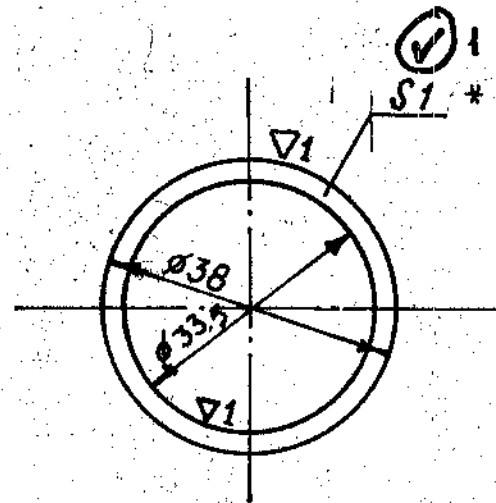
A-5

SIZE A3

DRAWING NUMBER

310-21

2 (▽)



EXPLANATORY NOTE

5. REFERENCE MATERIAL QUOTED: ALUMINIUM ALLOY SHEET GRADE AA1, ANNEALED 'M', 1mm THICK, AND REFERENCE NOTE 'B' ON ALTERNATE MATERIAL ALUMINIUM ALLOY GRADE AA0, ANNEALED 'M', 1mm THICK, MANUFACTURED IN ACCORDANCE WITH ALUMINIUM ALLOY TO GOST 4784-74.

a) CHEMICAL COMPOSITION AS PER GOST 4784-74

| GRADE OF ALLOY | ALLOYING CONSTITUENTS % | IMPURITIES MAXIMUM | | | | | | | OTHER IMPURITIES EACH INDIVIDUALLY |
|----------------|-------------------------|--------------------|------|------|-------|-----|-----|------|------------------------------------|
| | | Fe | Si | Cu | Mn | Zn | Ti | Mg | |
| AA1 | 99.3 MIN | 0.30 | 0.30 | 0.05 | 0.025 | 0.1 | 0.1 | 0.05 | 0.02 |
| AA0 | 99.5 MIN | 0.30 | 0.30 | 0.02 | 0.025 | 0.1 | 0.1 | 0.05 | 0.02 |

b) MECHANICAL PROPERTIES UNDER ANNEALED CONDITION AS PER GOST 21631-76.

| GRADE OF ALLOY | TENSILE STRENGTH Kgf/mm ² | ELONGATION % |
|----------------|--------------------------------------|--------------|
| AA1 AA0 | 6.0 | 28 |

| Sl.No | R ₁ | R ₂ | REMARKS |
|-------|----------------|----------------|---|
| 1 | 1.5 | 2.0 | ALL OTHER CONDITIONS AS PER STD DRG. MARK REPAIR SIZE |

1. REQUIREMENTS FOR STAMPED COMPONENT SHOULD BE AS PER STANDARD 82050-16.
2. TO BE ANNEALED AFTER STAMPING.
3. * DIMENSION FOR REFERENCE.
4. ALTERNATE MATERIAL: SHEET 1 AA0M GOST 21631-76

6. REPAIR SIZE DIMENSIONS ARE ADDED, BASED ON LETTER NO: 82847/OH/QAS/ED DT. 21 MAR 85 WHERE INDICATED THUS (1) AS FOLLOWS

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

EST WT TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

| | | | | | | | | |
|-------|------|----------------------|------|---------|-------|--|--|-----------------------|
| DRN | CHD | TCD | APPD | DATE | SCALE | DIMENSIONS IN mm TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69 | MATERIAL SHEET 1 AA1M GOST-21631-76 | USED ON Cb 310-30A Cb |
| | | | | 04-4-86 | 1:1 | | CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI | |
| | | | | | | | TITLE GASKET | |
| | | | | | | | D S CAT NUMBER | DRAWING NUMBER 310-21 |
| ISSUE | DATE | NATURE OF AMENDMENTS | | | | | | |

45

SIZE A3

| Format | | Формат | Зона | Поз. | Item | Code Обозначение | Nomenclature Наименование | Qty. | Кол. | Remarks Примечание |
|--------|----|--------|------|------|----------------|------------------------|--------------------------------------|------|------|-----------------------|
| | | | Zone | | | | Documentation | | | |
| | | | | | | | Документация | | | |
| | | | | | | | Assembly drawing | | | |
| | | * | | | сб.310-30-6 СБ | | Сборочный чертеж | | | *1А4х3 |
| | | | | | | | Parts | | | |
| | | | | | | | Детали | | | |
| | | * | | 1 | 310-06-7 | Air-distributor body | Корпус распределителя воздуха | | 1 | *1А3х3 |
| | | * | | 2 | 310-07-4 | Drive shaft | Валик привода | | 1 | *1А4х3 |
| | A3 | | | 3 | 310-08 | Coupling shaft | Муфта валика | | 1 | |
| | | * | | 4 | 310-09-1 | Distributor disc | Диск распределительный | | 1 | *1А3х3 |
| | A2 | | | 5 | 310-10 | Distributor cap | Колпак распределителя | | 1 | ТИ |
| | | * | | 6 | 310-11 | Distributor disc cover | Крышка распределитель- ного диска | | 1 | *1А4х3 |
| | A3 | | | 7 | 310-12 | Coupling spring | Пружина муфты | | 1 | |
| | A4 | | | 8 | 310-13 | Pin | Штифт | | 1 | |
| | A4 | | | 9 | 310-17-1 | Washer | Шайба | | 1 | |
| | A4 | | | 10 | 310-18-1 | Washer | Шайба | | 1 | ТИ |
| | A4 | | | 11 | 310-19 | Gasket | Прокладка | | 1 | |
| | A4 | | | 12 | 310-21 | Gasket | Прокладка | | 1 | |
| | A4 | | | 14 | 358.48.047-01 | Ring | Кольцо | | 2 | |

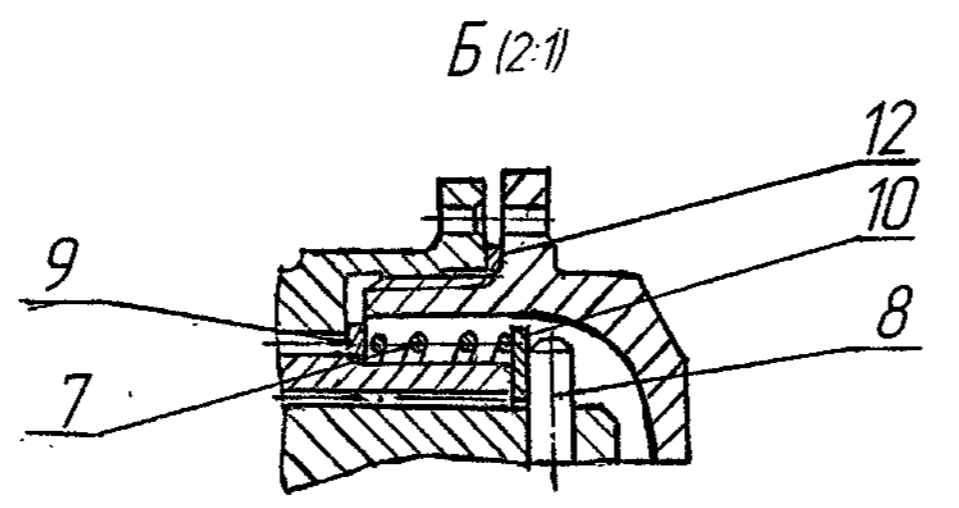
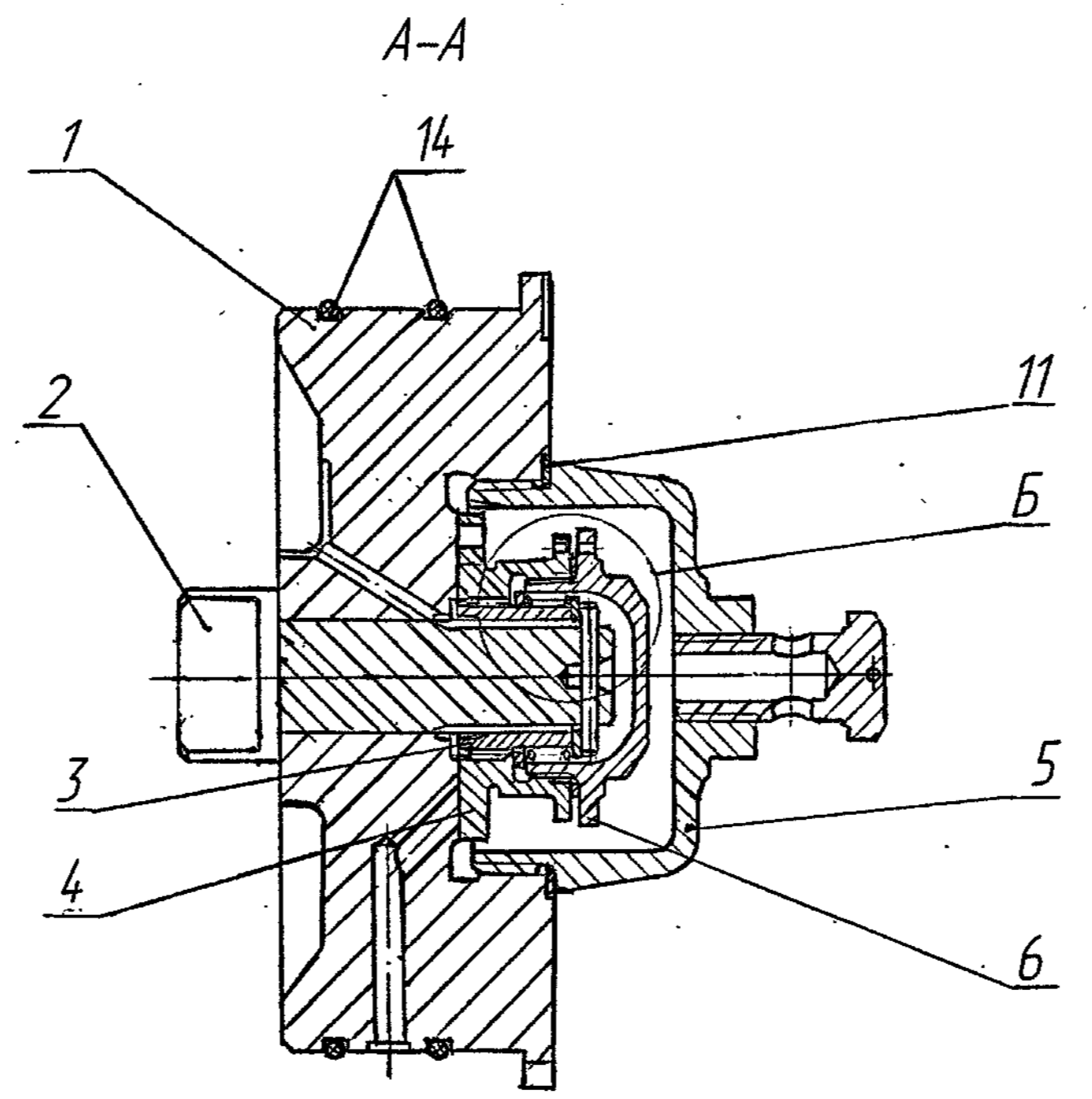
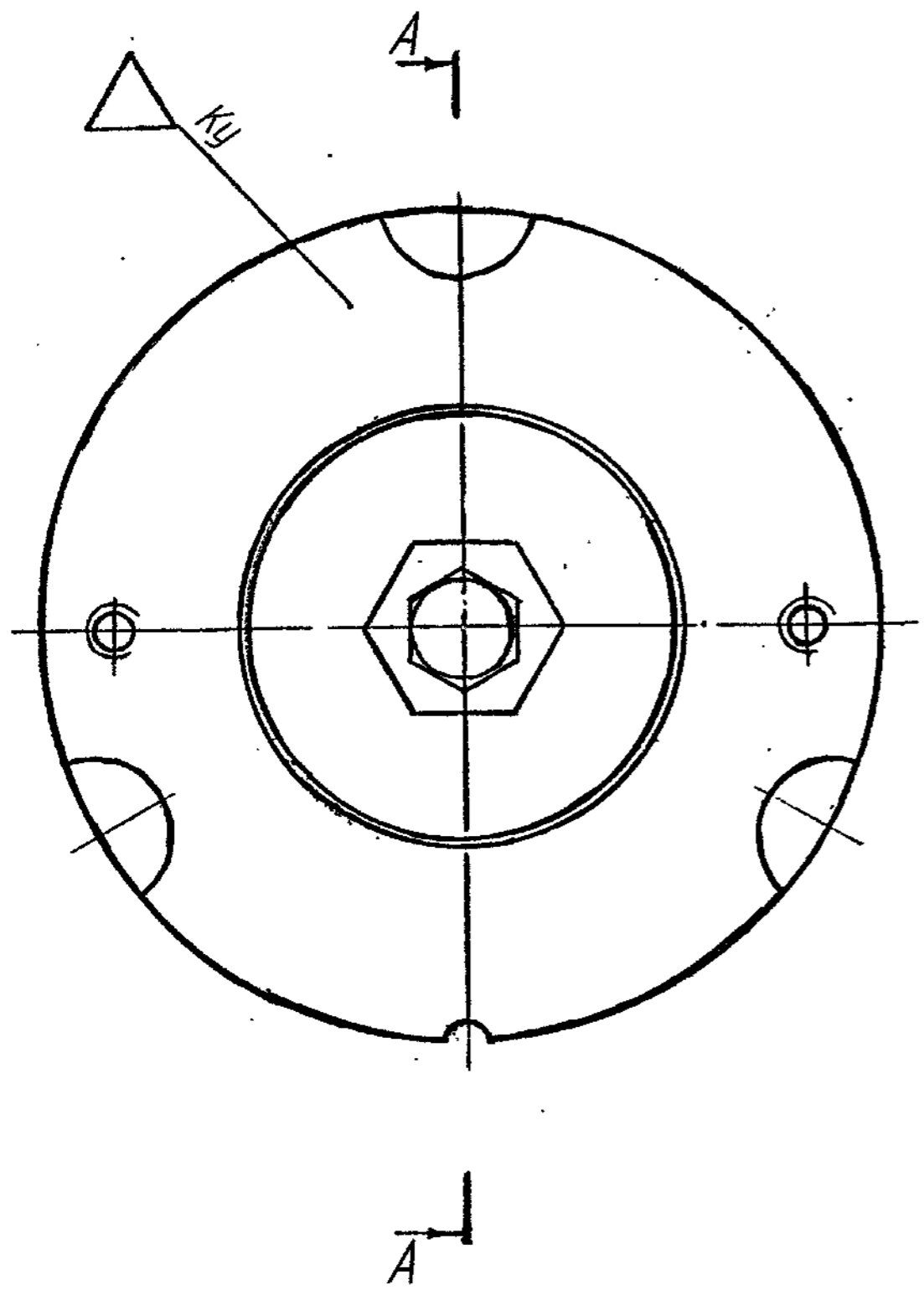
Подп. и дата

Взам. инв. №

Инв. №

Инв. № подл.

| | | | | | | | | | | |
|---------------------------------|--------|--------|-------|------|-----------------------|--|--|-------------------|-------|--------|
| 5 | 99-260 | | | | | | | | | |
| Изм. | Лист | № док. | Подп. | Дата | сб.310-30-6 | | | Letter | Sheet | Sheets |
| Trans. & Ckd. by : M/s SWYAZ | | | | | Воздухораспределитель | | | Лист | Лист | Листов |
| Authenticated by : | | | | | | | | 0,1 | 1 | |
| Approved by : | | | | | AIR-DISTRIBUTOR | | | F $\frac{3}{132}$ | | |
| Engine Factory, Avadi | | | | | | | | | | |



1. Детали перед постановкой на двигатель промыть, продуть и очистить от посторонних тел и грязи
 2. Осевое перемещение диска распределительного поз.4 по наружным шлицам муфты поз.3 должно быть свободным, без заклинивания и заедания.
 3. Рабочую поверхность диска распределительного поз.4 притереть по месту к корпусу распределителя воздуха поз.1, обеспечив равномерное прилегание по краске всей поверхности.

1. Before setting the parts on engine, wash and blow with air and clean to remove foreign particles and contamination.
 2. Axial movement / alignment of distributor disc item 4 along the external coupling spline item 3 should be free without wedging and jamming.
 3. Rub the working surface of distributor disc item 4 at the place for air distributor body item 1, ensuring the uniform mating of the entire surface by blue checking.

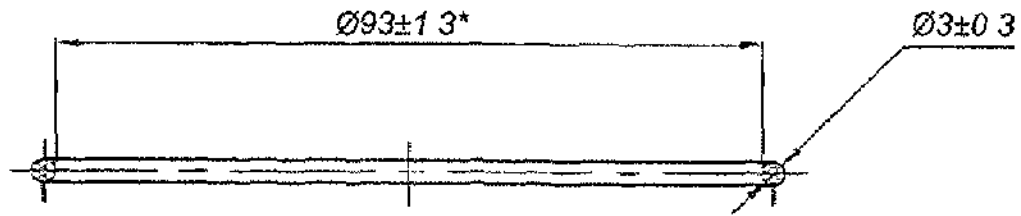
Изм. № 001 Подп. и дата
 Изм. № 002 Подп. и дата
 Изм. № 003 Подп. и дата
 Изм. № 004 Подп. и дата
 Изм. № 005 Подп. и дата
 Изм. № 006 Подп. и дата
 Изм. № 007 Подп. и дата
 Изм. № 008 Подп. и дата
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 Изм. № 100 Подп. и дата

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| сд.310-30-6СБ | | | | Letter weight scale | | |
| 5 | - | 99-260 | | Лист | Масса | Масштаб |
| Изм | Лист | № докум | Подп | 01 | 1,76 | 1:1 |
| Trans. & Ckd. by: M/s SWYAZ | | | | Листов 1 | | |
| Authenticated by: | | | | Sheet 3 | | |
| Approved by: | | | | F 153 | | |
| Engine Factory, Avadi | | | | 1 | | |
| Воздухораспределитель | | | | 1 | | |
| сборочный чертеж | | | | 1 | | |
| AIR-DISTRIBUTOR | | | | 1 | | |
| Assembly drawing | | | | 1 | | |
| | | | | Формат А4х3 | | |

DRAWING NUMBER

TRL - 358-48-047-01

SHEET No 1 OF 1



- 1 * Dimension to be ensured by the tool
- 2 On the surface of ring impression marks not exceeding 0.2 mm is permitted projection and depression marks from press moulding should not exceed 0.3 mm
- 3 To be marked on tag as per TY 005 216 75
- 4 Remaining requirement is as per TY 005 216 75 for article code 25 3111 HΠ

** MATERIAL : VITON RUBBER

With mechanical properties equivalent to Russian grade or better grade

5A

~~ALT MATL RUBBER GRADE FKM TO SPECN COLA(HV)/FKM~~

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

| | | | |
|-------|---------|--|--|
| | | EST WT (Kg) | TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS) |
| | | 0.0045 | |
| | | ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE | |
| | | MATERIAL | USED ON |
| | | RUBBER IPT 1287 | Cb 310 30 6 |
| | | TY 005 216-75 | |
| 5A | 13 6 08 | AUTHY LT. No IC/GEN/IND III DT. 02 04 08. | |
| ISSUE | DATE | NATURE OF AMENDMENTS | |
| DRN | | SCALE 1:1 | CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI |
| | | DIMENSIONS IN mm | |
| CHD | | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS 2102 69 | TITLE |
| APPD | | | RING |
| DALL | | ALL THREADS TO CONFORM TO | D S CAT NUMBER |
| | | | DRAWING NUMBER |
| | | | TRL - 358-48-047-01 |

DRG INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE 5

