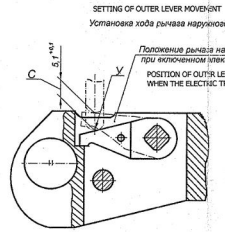
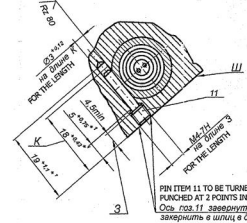
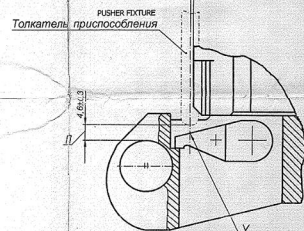
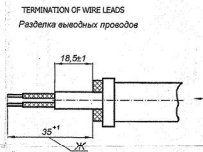
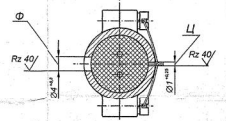
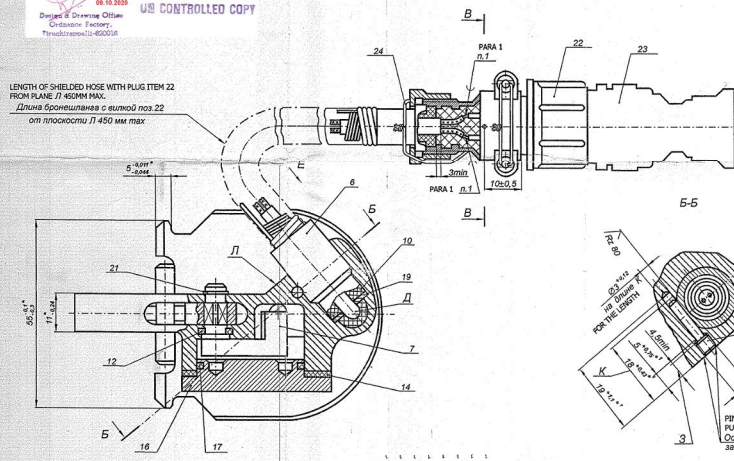


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AT THIS DATE: 09.10.2009

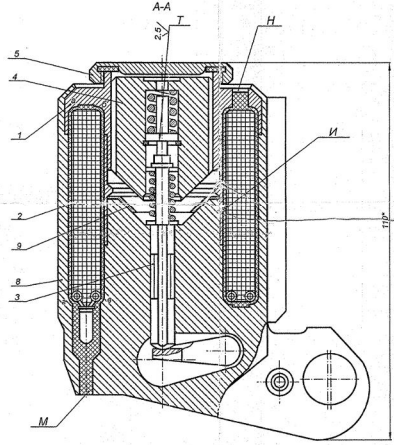
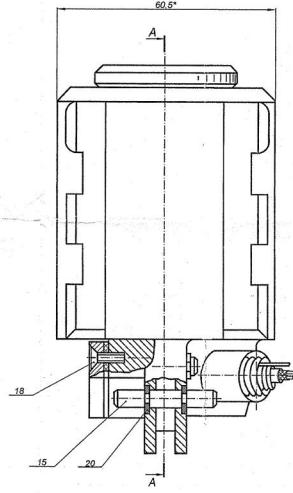
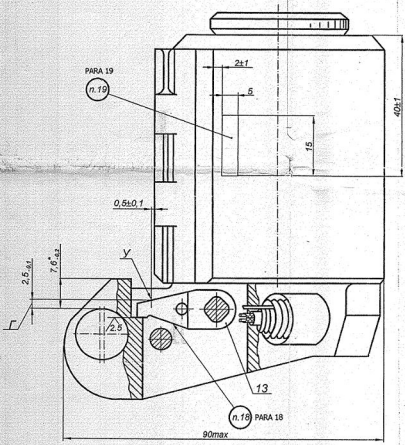
Design & Drawings Office
Cordoba Factory,
Togliatti-400018

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LENGTH OF SHIELDED HOSE WITH PLUG ITEM 22
FROM PLANE П 450MM MAX.
Длина бронированной с вилкой поз 22
от плоскости П 450 мм макс



SETTING OF INITIAL POSITION OF OUTER LEVER
Установка исходного положения рычага наружного



SETTING OF PUSHER FIXTURE WHEN MEASURING
TRACTION FORCE OF ELECTRIC TRIGGER
Установка толкателя приспособления при измерении
тяговои усилия электрострелки

- Soldering should be carried out with solder Пвс КП1.5 ПОС-40 GOST 21931-76, with flux ФКсн GOST 470.033.200. It is allowed to use other grade as per GOST 21931-76.
- * Dimension for reference.
- * Dimensions from plane П.
- Before laying coil item 2, surface "a" of body item 5 and flange item 1 are to be degreased with naphras C 50/170 GOST 8505-80 and to be dried. Surface II of body and surface I of flange are to be lubricated with compound 35-2c GOST B 84-167-80. Lay the coil, while lightning wire leads, damage of tube Д is not allowed at the inner side of body.
- Flange item 1 is to be set in body item 5, placing the filling hole H at 180° ± 15° relative to hole M. Flare out the flange. Flay of flange is not allowed. Excess compound is to be removed.
- Heat the electric starter to temperature 313K ± 5K (40°C ± 5°C). Set it at an angle of 440° with hole on upward. Fill the compound 35-2c through hole H gently till the compound is visible in hole M, after which holes M and H are to be closed with technological plug. It is allowed to fill the electric starter before fitment of cover item 5.
- Lead wire should be inserted in to reinforced hose item 6 and fit the furd of shielded hose in to the body item 5. Drilling of hole for pin item 11 should be carried out when the electric trigger is in the position of pointer E maximum.
- Inner cavity of plug item 22 should be filled with sealant Viksin Y-1-18 TY38.303 04-04-90 through hole Ф till the sealant is visible through hole Л.
- To the length X termination of wires should be carried out when pressing along pointer P to the rope of shielded hose item 6. Residual wires after soldering plug to fork item 22 should be arranged to shielded hose.
- Sealing ring item 12 before setting lever item 7 is lubricated with thin layer of lubricant MC-70 GOST 9762-76.
- Dimension C is to be ensured by machining plane T of pusher item 3. To be checked in future П-0004.
- Before setting the cover of body item 16 gasket item 17 to be lubricated with thin layer of lubricant MC-70 GOST 9762-76. Presence of local tears and damage of gaskets are not allowed.
- Before setting cover item 5, threads of cover and flange are to be degreased with naphras C 50/170 GOST 8505-80 and to be dried. Threads of flange is to be lubricated with thin layer of compound 35-2c and rotate the cover by hand fully.
- screw item 18 should be locked by putty 3П-00-10 GOST 28378-89 along threaded parts and from the side of bolt head.
- Finally assembled electric trigger should be heat treated at a temperature 333K ± 10K (60 ± 10 °C) for 8 hours. After which cool it to normal climate conditions.
- Traction force of electric trigger measured in point Y at voltage 24V ± 10% on contacts of plug connector should be not less than 352.5N (38 Kgf). Checking should be carried out when setting the pusher of fixture П-0003 along dimension П. Value of shifting of weight need not to be checked.
- Continuous operating time of electric trigger when operating along Point 11,16 should not exceed 1 minute.
- Dimension T should be ensured by machining outer lever item 13. After machining mark serial no. of electric trigger by type 3-П3 GOST 28.008-85, by punching.
Coating of lever - Cr12, inner surface - Chemical, phosphating and accelerated oil finishing.
- Mark the serial no. of electric trigger by punching method by type 4-П3 GOST 28.008-85.
- Other technical requirement should be as per 6H15 TY.

		6H15 c6 C6		Shet. Code	Field. No	Sh. No
		U-05-14		14	12	
		ELECTRIC TRIGGER ASSEMBLY DRAWING		1.576	2:1	
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