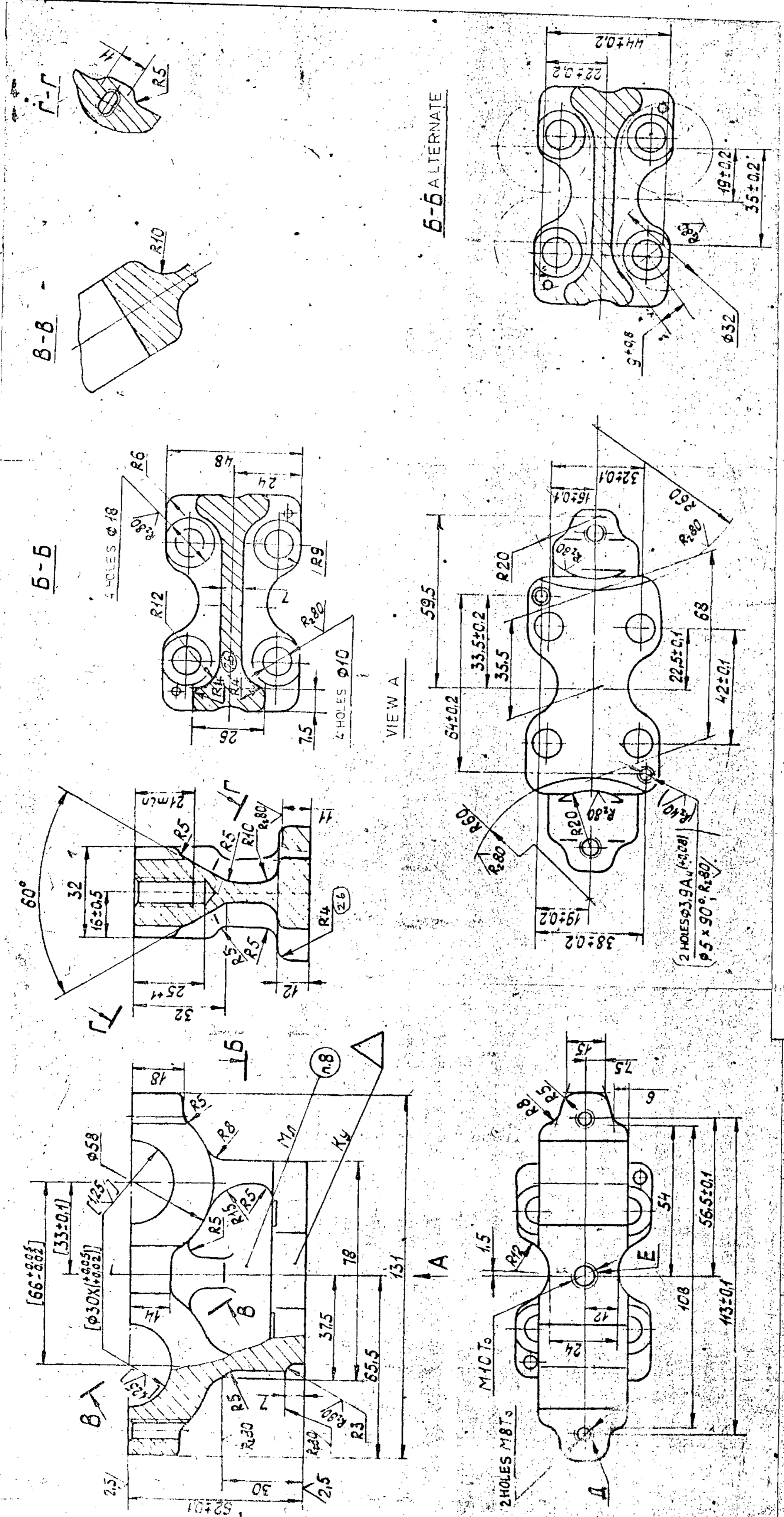


DRAWING NUMBER
20-06-40



1. INSPECTION GROUP IV AS PER TECHNICAL REQUIREMENTS 11-11, HB 790.
2. ACCEPT THE PARTS AFTER FINAL HEAT-TREATMENT AS PER TECHNICAL REQUIREMENTS 11-20-10.
3. LIMIT DEVIATIONS OF STAMPING DIMENSIONS - SHOULD COMPLY WITH STANDARD 82050-17. DRAFTS AND RADII UNSPECIFIED IN THE DRAWING SHOULD BE 6: R3.
4. MAKE THREADS AS PER STANDARD 82020-12, ISSUE 7, AND E AS PER STANDARD 82020-12, ISSUE 7.
5. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:
 FOR HOLES - AS PER A7,
 SHAFTS - AS PER B7,
 OTHERS - AS PER CM8.
6. PERFORM MACHINING AS PER DIMENSIONS GIVEN IN SQUARE BRACKETS TOGETHER WITH PART-20-06-41.
7. GIVEN IN BRACKETS ARE DIMENSIONS AND SURFACE ROUGHNESS AFTER ASSEMBLY.
8. MARK MATERIAL GRADE AS PER GOST 2171-79, BY USING TYPE 170-10, GOST 2930-62. IT IS ALLOWED TO APPLY MARKING WITH HAMMER BY USING TYPE no-5, GOST 2930-62.

EXPLANATORY NOTE

9) MATERIAL QUOTED - A.1 GOST 4784-74.
 A.1 = GROUP OF ALUMINIUM ALLOY.

a) CHEMICAL COMPOSITION: %
 BASIC CONSTITUENT = ALUMINIUM
 COPPER = 3.8 - 4.8
 MAGNESIUM = 0.4 - 0.8
 MANGANESE = 0.4 - 0.8

b) IMPURITIES: = (MAX)
 IRON = 0.7
 SILICON = 0.7
 NICKEL = 0.1
 ZINC = 0.3
 TITANIUM = 0.1
 OTHER IMPURITIES EACH INDIVIDUALLY = 0.05
 TOTAL = 0.1

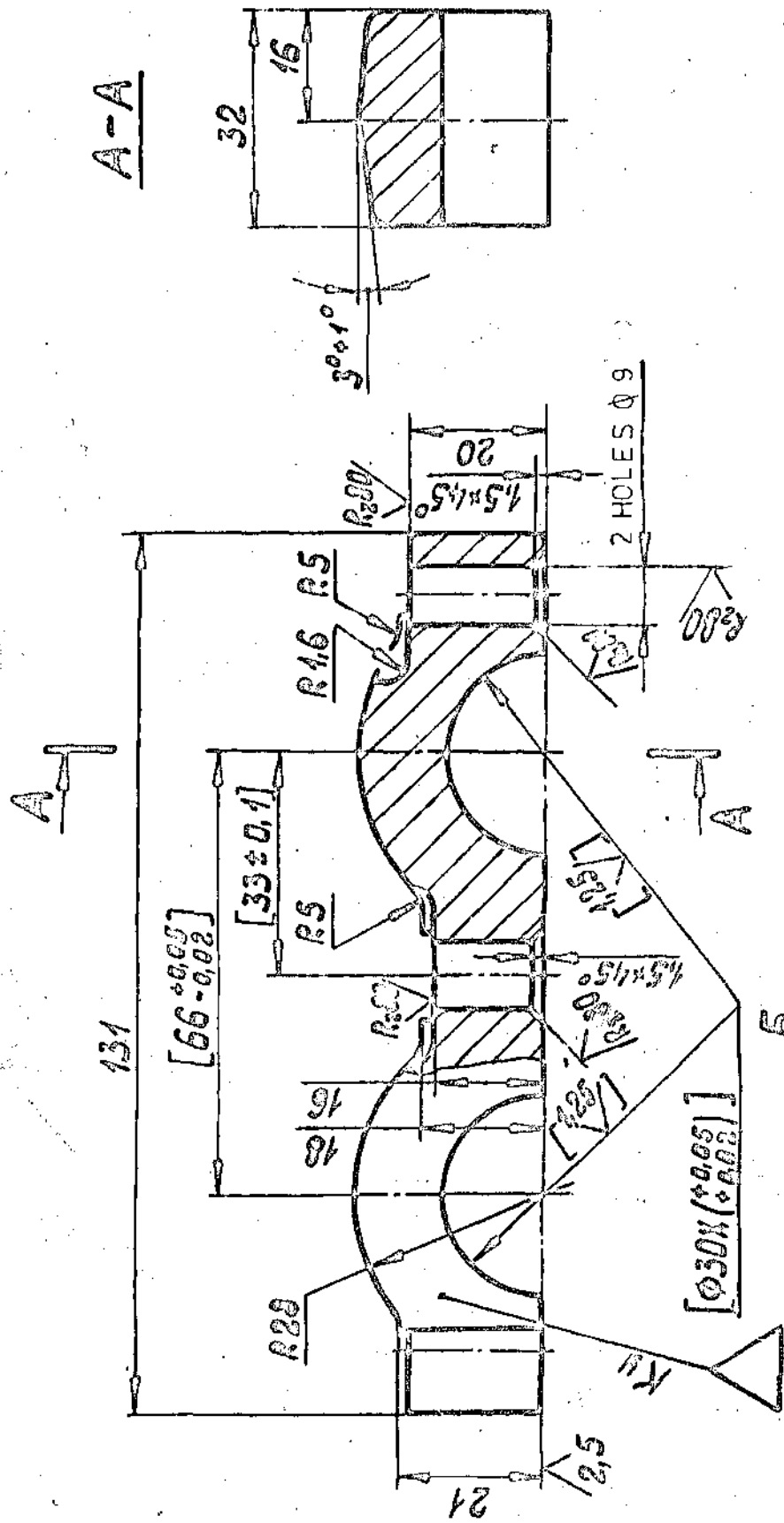
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. MASS TO BE STAMPED OR MARKED WHERE INDICATED THIS # 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.

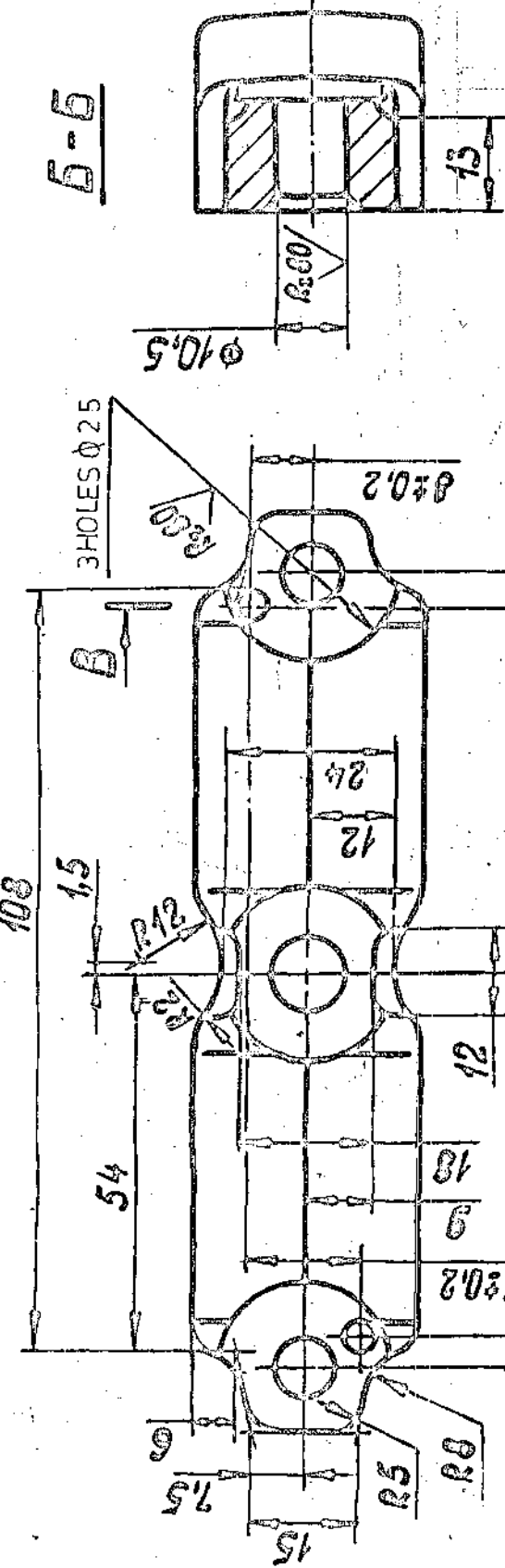
DRN	APPROVED	MATERIAL	USED ON
ECO	ISSUED	A.1 GOST 4784-74	CG 20-06-04
TCD	ISSUED	CONTROL RATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	A V A O I
APPO	DATE	TITLE	
SCALE	1:1	CAM SHAFT BEARING BASE	
DIMENSIONS IN mm			
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69			
ALL THREADS TO CONFORM TO			
ISSUE	DATE	D S CAT NUMBER	DRAWING NUMBER
2.6	13-7-84	20-06-40	20-06-40
Nomen No 9.31-8.4			
NATURE OF AMENDMENTS			

20-06-41

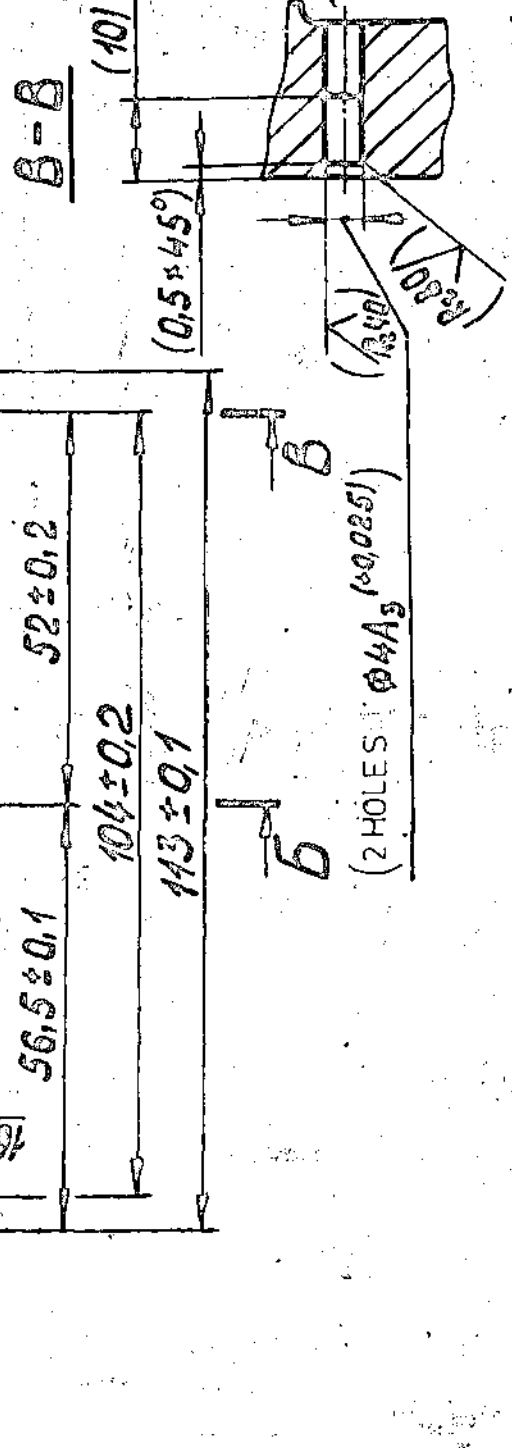
✓ (✓)



A-A



B-B



B-B

1. INSPECTION GROUP IV AS PER TECHNICAL REQUIREMENTS TT-11. HB ≥ 90 .
2. ACCEPT THE PARTS AFTER FINAL HEAT-TREATMENT AS PER TT-20-10.
3. LIMIT DEVIATIONS OF STAMPING DIMENSIONS SHOULD COMPLY WITH STANDARD 82050-17. DRAFTS AND RADII UNSPECIFIED IN THE DRAWING SHOULD BE $6^\circ, R3$.
4. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:
 FOR HOLES - AS PER A7;
 SHAFTS - AS PER B7,
 OTHERS - AS PER CM7.
5. PERFORM MACHINING AS PER DIMENSIONS GIVEN IN SQUARE BRACKETS TOGETHER WITH PART 20-06-40.
6. GIVEN IN PARENTHESES ARE DIMENSIONS AND SURFACE AFTER ASSEMBLY.

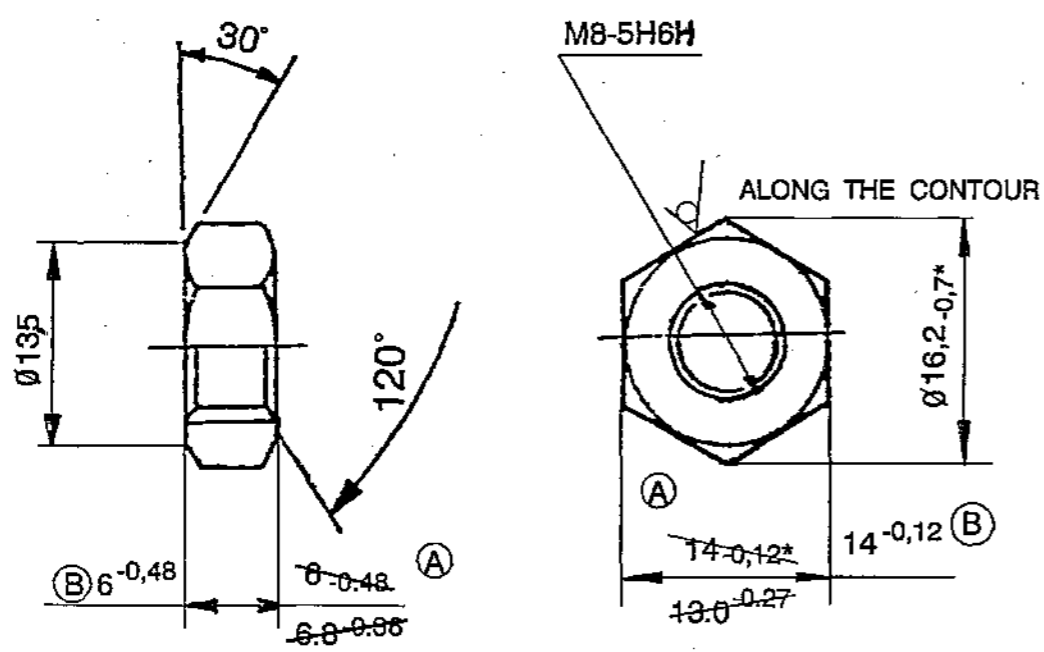
PILLOT SAMPLE SHOULD BE APPROVED BY A.I.S.P. BEFORE BULK PRODUCTION		EST. NO. 0,14 Kg	
TO BE STAMPED ON MARKED WHERE INDICATED) THUS (A)		LETTERS)	
NATURE OF AMENDMENTS		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED FACED CORNERS TO HAVE R OUTSIDE R RISKY EQUIVALENT CHANGERS ARE PERMISSIBLE	
SCALE: 1:1		MATERIAL: 41 GOST 4784-74 USED ON: C6 20-06-04	
DIMENSIONS IN BRACKETED TOLERANCE ON DIMS UNLESS OTHERWISE STATED		CONTROL PLAN OF INSPECTION: HEAVY VEHICLES / AVADI	
DATE 26-11-87		DRAWING NUMBER: CAMSHAFT BEARING CAP	
ALL THREADS CONFORM TO		DRAWING NUMBER: 20-06-41	

60821 / AMDT. NO. 1386+81

COMMON TO V-9252 & UTD-20 ENGINES
 DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE -NIL
 (B. JAYAVELU)
 JTO (D)

DRAWING NUMBER
351 - 02

Rz40 (✓)



EXPLANATORY NOTE :

7. MATERIAL QUOTED :- HEXAGON BAR 14-4 GOST 8560-78
45-5 GOST 1051-73

BRIGHT STEEL OF HEXAGONAL CROSS SECTION 14mm ACROSS FLAT, ACCURACY CLASS - 4 TO GOST 8560-78. AND MANUFACTURED FROM COLD DRAWN SIZED STEEL OF GROUP 5 SURFACE QUALITY TO GOST 1051-73.
ALTERNATE MATERIAL QUOTED :- STEEL GRADE 40 & 50 TO GOST 1050-74.

CHEMICAL COMPOSITION :

STEEL GRADE	C O N T E N T O F E L E M E N T S %							
	C	Si	Mn	Cr(max)	S	P	Ni	Cu
40	0.37-0.45	0.17-0.37	0.50-0.80	0.25	0.040	0.035	0.10	0.15
45	0.42-0.50	0.17-0.37	0.50-0.80	0.25	0.040	0.035	0.10	0.15
50	0.47-0.55	0.17-0.37	0.50-0.80	0.25	0.040	0.035	0.10	0.15

MECHANICAL PROPERTIES :

STEEL GRADE	YIELD POINT Kgf/mm ² (min)	ULTIMATE TENSILE STRENGTH Kgf/mm ² (min)	PERCENTAGE ELONGATION (min)	REDUCTION OF AREA % (min)	IMPACT STRENGTH Kgf/m ² (min)
40	34	58	19	45	6
45	36	61	16	40	5
50	38	64	14	40	4

1. ROLLED STOCK OF GROUP B CLASS 4 GOST 1051-73 MAY BE USED TO ENSURE HIGH QUALITY OF COATING, IT IS ALLOWED TO ELIMINATE SURFACE DEFECTS OF ROLLED STOCK WITH DECREASE OF DIMENSIONS AS PER ACCURACY CLASS 5.
2. ~~ALTERNATE MATERIAL - STEEL GRADES 40 AND 50 GOST 1050-74~~
3. THE REST OF THE TECHNICAL REQUIREMENTS AS PER STANDARD 82052 - 00.
5. COATING :- Cd3, CHROMATIZING AS PER UUL-104 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
6. *DIMENSIONS FOR REFERENCE.

Material: STEEL 709M40 (EN-19) TO BS-970 Pt-1-1983

USED ON:-
 Eb 20-01-00-8, Cb 20-06-12-6, Cb 20-06-13-6, Cb 20-09-07,
 Cb 20-19-00-1, Cb 20-11-00-6, Cb 20-12-00-13, Cb 20-13-01-8,
 Cb 20-20-00-10, Cb 20-22-00-7, Cb 20-08-00-7, Cb 3301-00-37,
 Cb 306-01-20, Cb 306-02-20, Cb 306-03-3, Cb 306-04-2, Cb 321-04-4, Cb 447-01-1,
 Cb 421-04-3, Cb 421-18-1, Cb 3301-00-44, Cb 3301-15-44, Cb 306-01-36,
 Cb 306-02-36, Cb 3308-15-2, Cb 3312-90-14, Cb 419-00-20, Cb 3320-00-43,
 Cb 315-663-33, Cb 3334-02-10, Cb 3336-00-11, Cb 337-100, Cb 3342-00-21.

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

EST. WT. 0,0055 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.

ISSUE	DATE	NATURE OF AMENDMENTS
D	18.5.09	Authy: Third Alt. Comm. Minutes Point: 5 Dated 27-02-2009.
C	25.8.08	USED ON NUMBER ADDED
B	24-12-07	ALT. COMMITTEE MEETING MINUTES. POINT No. 2.18 Dt. 18-12-2007.
A	15-03-04	AUTHY. Lt. No.110094/IND-III /577, Dt. 19-02-04.

DRN Sd/=
 CHD Sd/=
 TCD Sd/=
 APPD Sd/=
 DATE 08-05-86

MATERIAL :-
 14-4 GOST 8560-78
 45-5 GOST 1051-73

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)
 AVADI

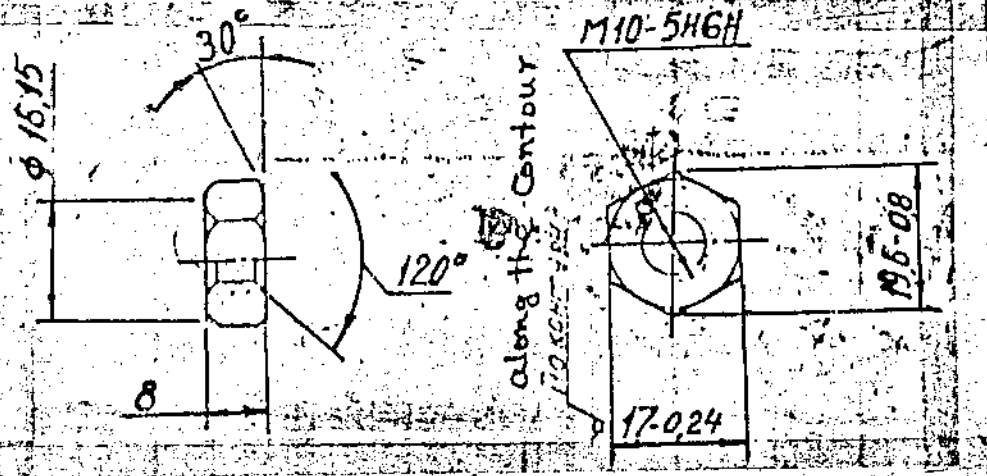
SCALE:- 2 : 1
 DIMENSIONS IN mm
 TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69

TITLE :-
NUT M8

D S CAT NUMBER
 DRAWING NUMBER
351 - 02

DRAWING NUMBER

351-50



1. CHAMFER 120° SHOULD BE MADE UPTO THE MAJOR DIAMETER OF THREAD.
2. THE THREAD MAY BE CHECKED BEFORE COATING.
3. COATING : CADMIUM 9, CHROMATIZING AS PER 349-104 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
4. THE REST OF THE TECHNICAL REQUIREMENTS - AS PER STANDARD 82052-00.
5. ALTERNATE MATERIAL : STEEL, GRADES 40 AND 50 GOST 1050-74.
6. ROLLED STOCK OF GROUP 'B' CLASS 4 GOST 1051-73-MAY BE USED. TO ENSURE HIGH QUALITY OF COATING, IT IS ALLOWED TO ELIMINATE SURFACE DEFECTS OF ROLLED STOCK WITH DECREASE OF DIMENSION AS PER ACCURACY CLASS 5.

(B) Material: STEEL 709M40 (EN-19) TO BS-970 Pt-1-1983

EXPLANATORY NOTE:

HEXAGONAL BAR: 17-4 GOST 8560-78 (B)
 45 GOST 1051-73
 ALTERNATE MATERIAL QUOTED: 40 & 50, GOST 1050-74
 BRIGHT, STEEL HEXAGONAL BAR 17mm ACROSS FLATS,
 CLASS OF ACCURACY-4, TO GOST 8560-78, GRADE 45, GOST 1051-73
 B = WITH SURFACE QUALITY

Rz40/ (1)

(a) CHEMICAL COMPOSITION:

GRADE OF STEEL	CONTENTS OF ELEMENTS %							
	C	Si	Mn	Cr	P	S	Cu	Ni
	MAXIMUM							
40	0.37 - 0.45	0.17 - 0.37	0.50 - 0.80	0.25	0.035	0.040	0.25	0.25
45	0.42 - 0.50	0.17 - 0.37	0.50 - 0.80	0.25	0.035	0.040	0.25	0.25
50	0.47 - 0.55	0.17 - 0.37	0.50 - 0.80	0.25	0.035	0.040	0.25	0.25

(b) MECHANICAL PROPERTIES

GRADE OF STEEL	TENSILE STRENGTH Kgf/mm ² (min)	YIELD POINT Kgf/mm ² (min)	ELONGATION % (min)	REDUCTION IN AREA % (min)	IMPACT STRENGTH Kgf/cm ² (min)
40	58	34	19	45	6
45	61	36	16	40	5
50	64	38	14	40	4

(A) CB 3335-00-9, CB 3336-00-11, CB 3301-15-30, CB 3320-00-33, CB 3301-00-44, CB 3342-00-21, CB 3301-15-44, CB 3320-00-43, CB 329-75-1

MATERIAL: (B) 17-4 GOST 8560-78
 HEXAGON BAR 45-5 GOST 1051-73
 USED ON: CB 20-35-00-5, CB 20-06-01-5, CB 306-04-2, CB 20-06-02-5, CB 20-06-04

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

EST. WT. 0.012 Kg TO BE STAMPED OR MARKED WHERE INDICATED THIS # LETTERS

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

DRM	APPO	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 2102-69	ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
		15-7-89	1:1					351-50
B	18.5.09	Authy: Third Alt. Comm. Minutes Point: 5 Dated 27-02-2009.						
A	25.8.08	USED ON NUMBER ADDED						
ISSUE DATE		NATURE OF AMENDMENTS						

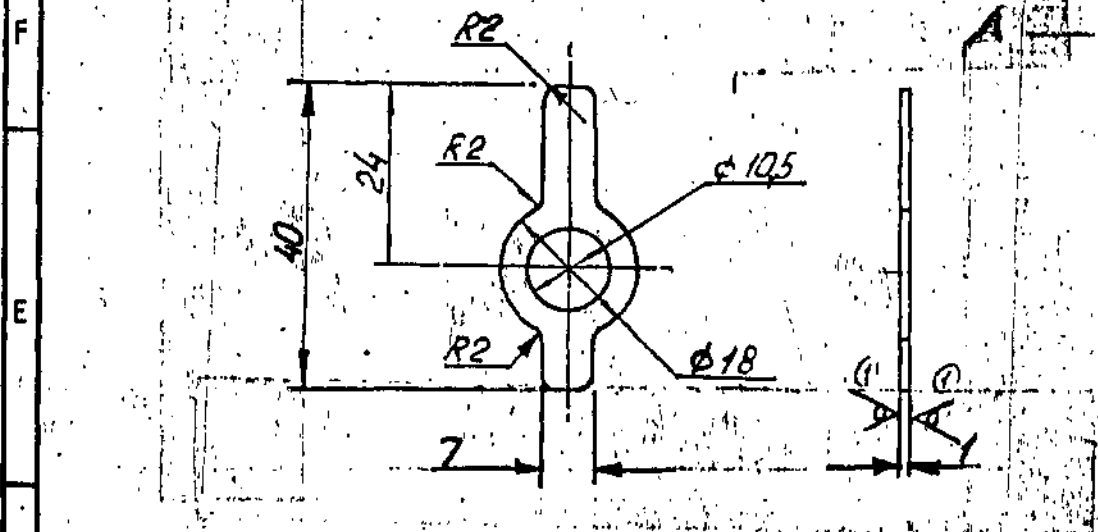
COMMON TO V-92S2 & UTD-20 ENGINES

A-11
42
SIZE A3

DRAWING NUMBER

353-19

Rz80 / (✓) 08



2. REQUIREMENTS FOR STAMPING AS PER STANDARD 82050-16.
3. THE COMPONENT SHOULD BE STRAIGHTENED AFTER STAMPING.
4. BURRS ARE NOT ALLOWED.
6. COATING : Cd 9, CHROMATIZING AS PER UUA-104 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
7. REQUIRED FINISHING OF SURFACES BEING STAMPED SHOULD BE ENSURED BY TOOL.

(A) EQUIVALENT MATERIAL.
Gr. 0 IS: 513-1994.

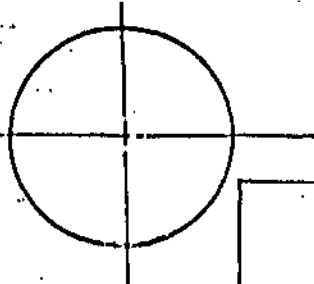
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

KVP - 63630

A-11
67

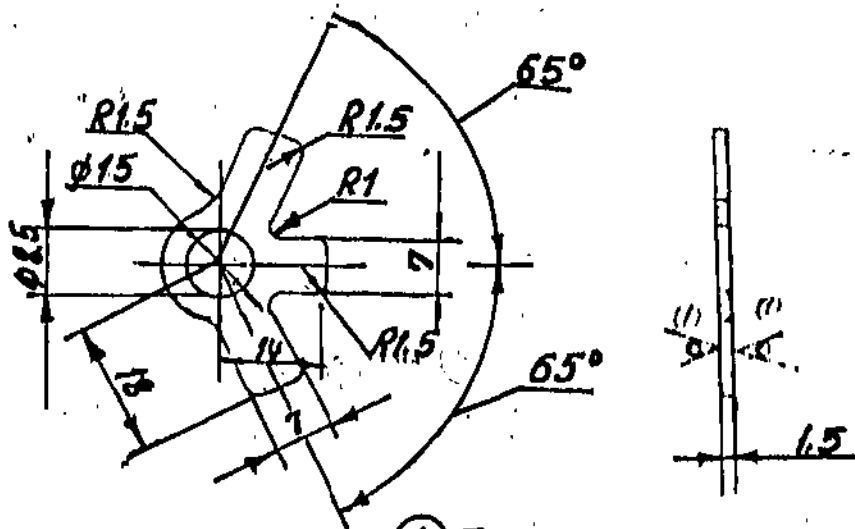
		EST. WT. 0.0025 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS ≡ (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
A	17.3.10	4 th Alt. Comm. Meet. Minutes Point No.1. Dt:26-10-09.	MATERIAL:- STRIP 08nc-M-2-1, GOST 903-71.
ISSUE DATE		NATURE OF AMENDMENTS	USED ON CB20-06-04 CB 20-35-00-5 CB 306-04-2.
DRN	Scale	SCALE:- 1:1 DIMENSIONS IN mm	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.
CHD	TCD	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS 2102 -69	TITLE LOCK WASHER-10
APPD	DATE	ALL THREADS CONFORM TO	D'S CAT NUMBER
DATE	27/7/88		DRAWING NUMBER 353-19
SIZE A4			





DRAWING NUMBER
353-32

Rz 80 ✓(✓)



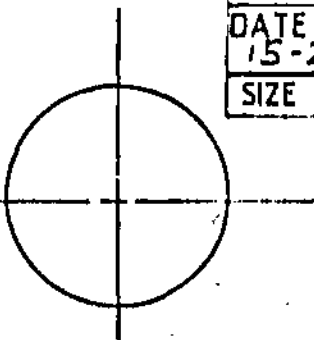
Ⓐ EQUIVALENT MATERIAL
Gr. O IS: 513-1994

2. Requirements for stamping - as per standard B2050-16.
3. The component should be straightened after stamping.
4. Burrs are not allowed.
6. Coating :- Cd q, Chromating as per user - 10H with elimination of Hydrogen embrittlement.
7. Required finishing of surfaces being stamped should be ensured by tool.

A-11
75

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

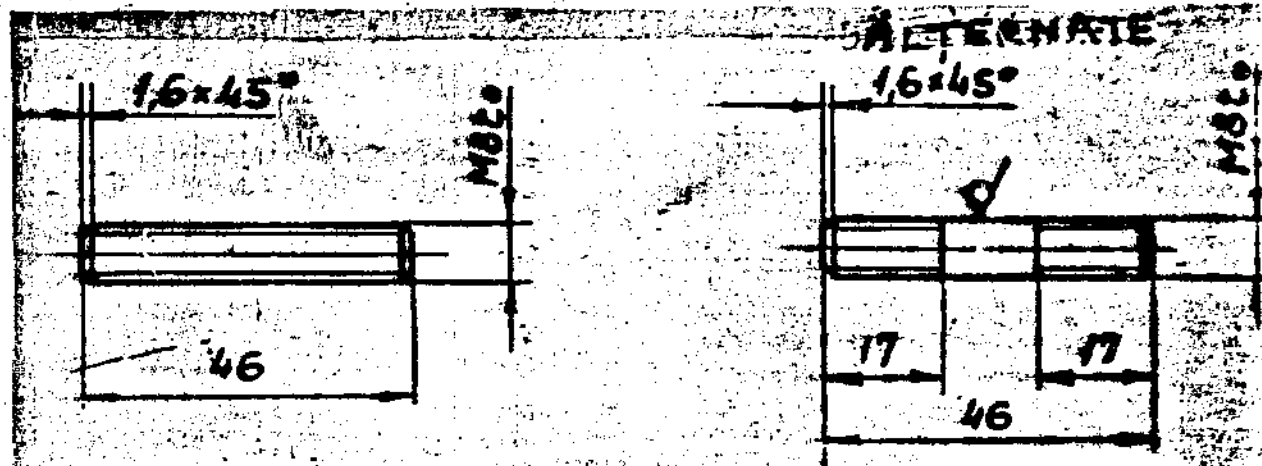
EST. WT. 0.0022 kg		TO BE STAMPED OR MARKED WHERE INDICATED THUS = (LETTERS)	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.			
MATERIAL:- STRIP 08NC-M-2-1.5 080T 003-71.		USED ON CB 306-04-2 CB 20-06-04	
ISSUE	DATE	NATURE OF AMENDMENTS	
ORN	15-2-89	SCALE:-1:1 DIMENSIONS IN mm	
CHD		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS 2102 -69	
TCD		ALL THREADS CONFORM TO	
APPD		D S CAT NUMBER	
DATE	15-2-89	DRAWING NUMBER	
SIZE	A4	353-32	





DRAWING NUMBER
550-105

Rz80 (✓)



1. INSPECTION GROUP IV AS PER TECHNICAL REQUIREMENTS TT - 11, HRC 26 TO 33.
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:
FOR SHAFTS - AS PER B7,
OTHERS - AS PER CM7
3. MAKE THREAD AS PER STANDARD 82020-12, ISSUE 7.
4. TECHNICAL REQUIREMENTS ARE AS PER GOST 1759-70.
5. COATING: CADMIUM-PLATED, 3 MICRONS THICK, OILED, WITH REMOVAL OF HYDRGEN EMBRITTLEMENT.
6. UNTHREADED PORTION OF THE ROD MAY BE MADE WITH IN THE LIMITS OF THE ANGLE DIAMETER OF THREAD.
7. IN THE ASSEMBLY UNITS MECHANICAL DAMAGE TO THE COATINGS SUCH AS SCRATCHES NOTCHES AND DENTS WHICH DO NOT EXPOSE STEEL ARE PERMITTED.

EXPLANATORY NOTE :

8. REFERENCE MATERIAL QUOTED :
HIGH QUALITY (A) CHROMIUM STEEL TO GRADE 38XA.
 - a) CHEMICAL COMPOSITION :

CARBON	-	0.35	-	0.42	%
SILICON	-	0.17	-	0.37	%
MANGANESE	-	0.50	-	0.80	%
CHROMIUM	-	0.80	-	1.10	%
SULPHUR	-	0.025	(max)	%	
PHOSPHORUS	-	0.025	(max)	%	
COPPER	-	0.30	(max)	%	
NICKEL	-	0.30	(max)	%	
 - b) PHYSICAL PROPERTIES :

YIELD POINT	-	80	Kgf/mm ²	(min)
U T-S	-	95	Kgf/mm ²	(min)
ELONGATION %	-	12	(min)	
REDUCTION IN AREA%	-	50	(min)	
IMPACT STRENGTH	-	9	Kgfm/cm ²	(min)

(A) Alt. Material: STEEL 709M40 (EN-19) TO BS-970 Pt-1-1983

CB 20-11-02-9
CB-20-13-02-11

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

EST. WT. TO BE STAMPED OR MARKED WHERE INDICATED THUS \equiv (LETTERS)

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

DRN		MATERIAL:-	USED ON
CHD		38XA GOST 4543-71	CB 20-15-601-5
TCD			
APPD			
DATE	24-4-1987	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE:-	1:1	AVADI	
DIMENSIONS IN mm		TITLE	STUD M8X46
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS:2102-69			
ALL THREADS TO CONFORM TO		D. S. CAT NUMBER	DRAWING NUMBER
			550-105
ISSUE DATE	18.5.09	NATURE OF AMENDMENTS	
		Auth: Third Alt. Comm. Minutes Point - 2 Dated 27-02-2009.	

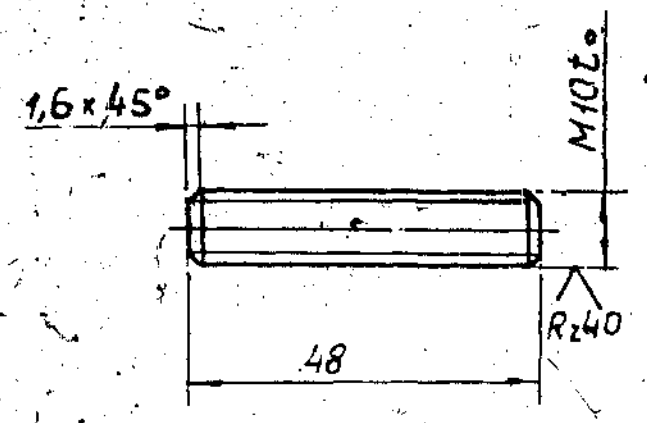


SIZE A3

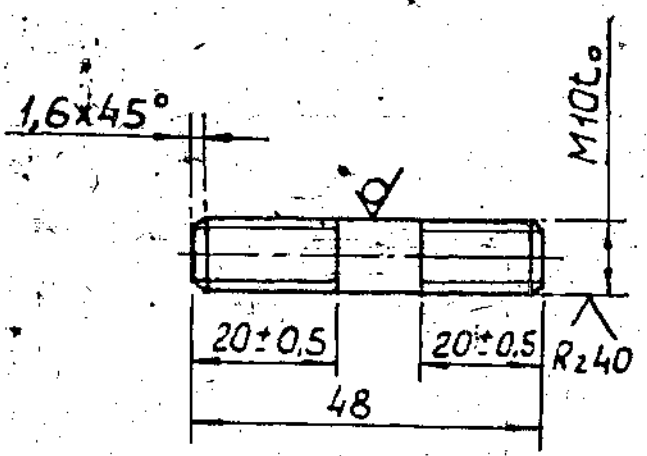
550-118

R_{1.80} ✓

Восстановлено с позначки Верно



ALTERNATE



1. INSPECTION GROP IV AS PER TECHNICAL REQUIREMENTS TT-11. HRC 26 TO 33.
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS: FOR SHAFTS - AS PER B₇, OTHERS - AS PER CM₇.
3. MAKE THREAD AS PER STANDARD 82020-12, ISSUE 7.
4. COATING: CADMIUM - PLATED, 3 MICRONS THICK OILED WITH REMOVAL OF HYDROGEN EMBRITTLMENT.
5. UNTHREADED PORTION OF THE ROD MAY BE MADE WITH IN THE LIMITS OF THE ANGLE DIAMETER OF THE THREAD.
6. MECHANICAL DAMAGE TO COATINGS SUCH AS SCRATCHES NOTCHES AND DENTS, WHICH DO NOT EXPOSE STEEL IN ASSEMBLY UNITS ARE PERMITTED.

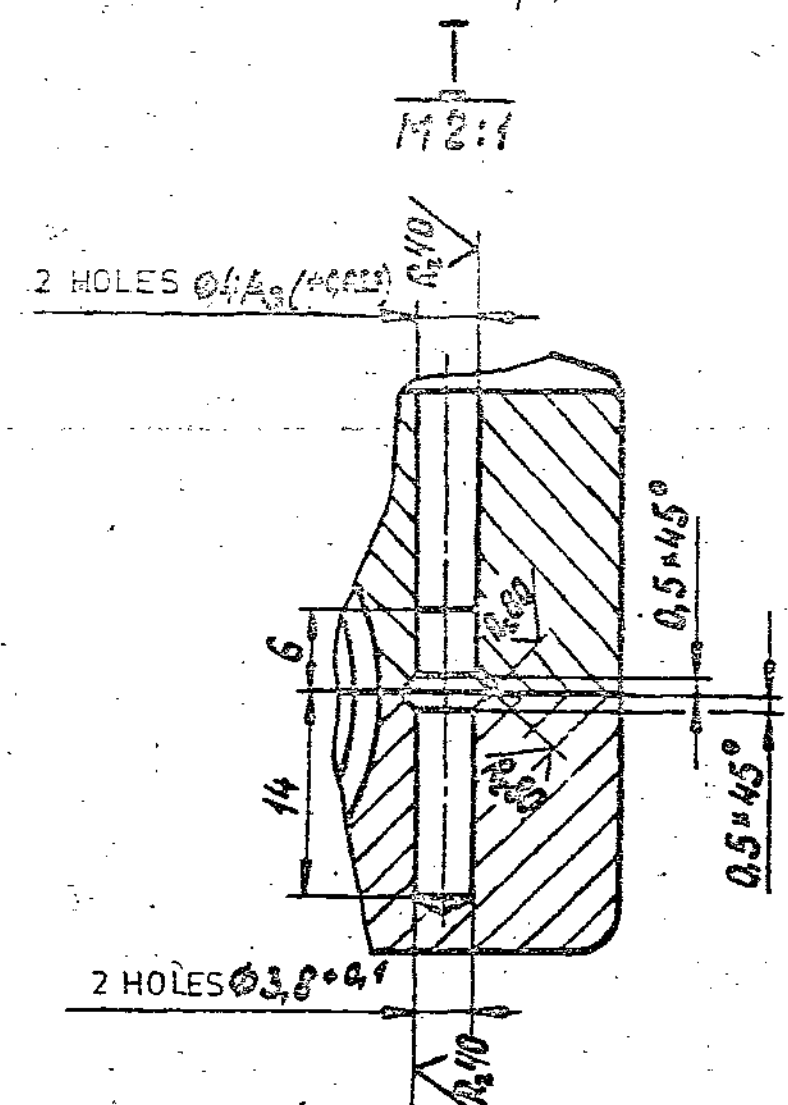
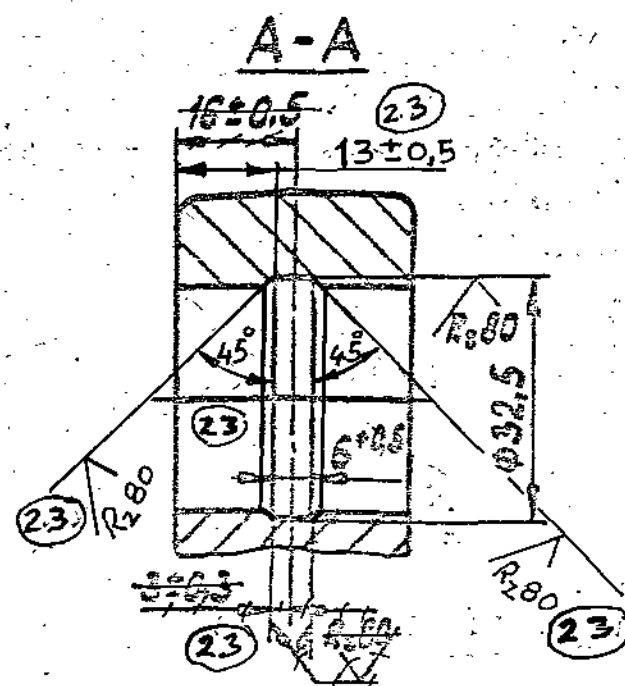
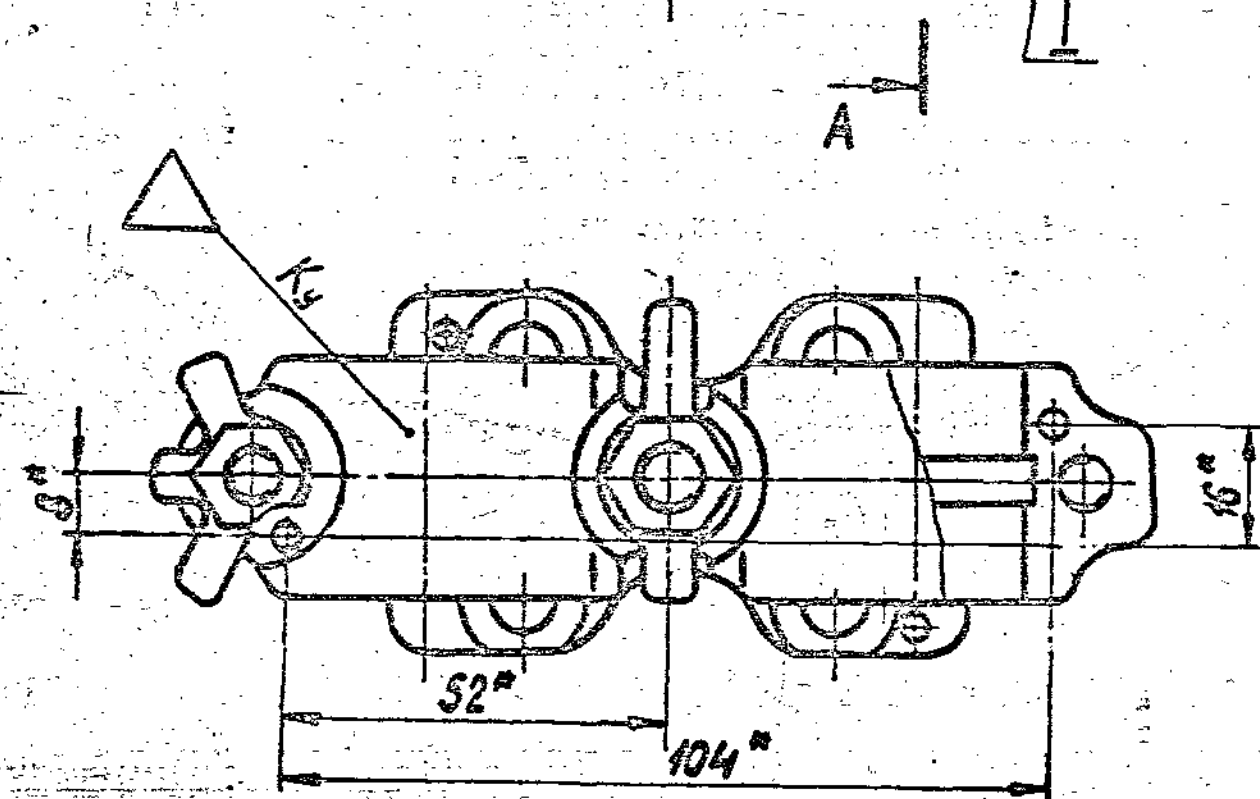
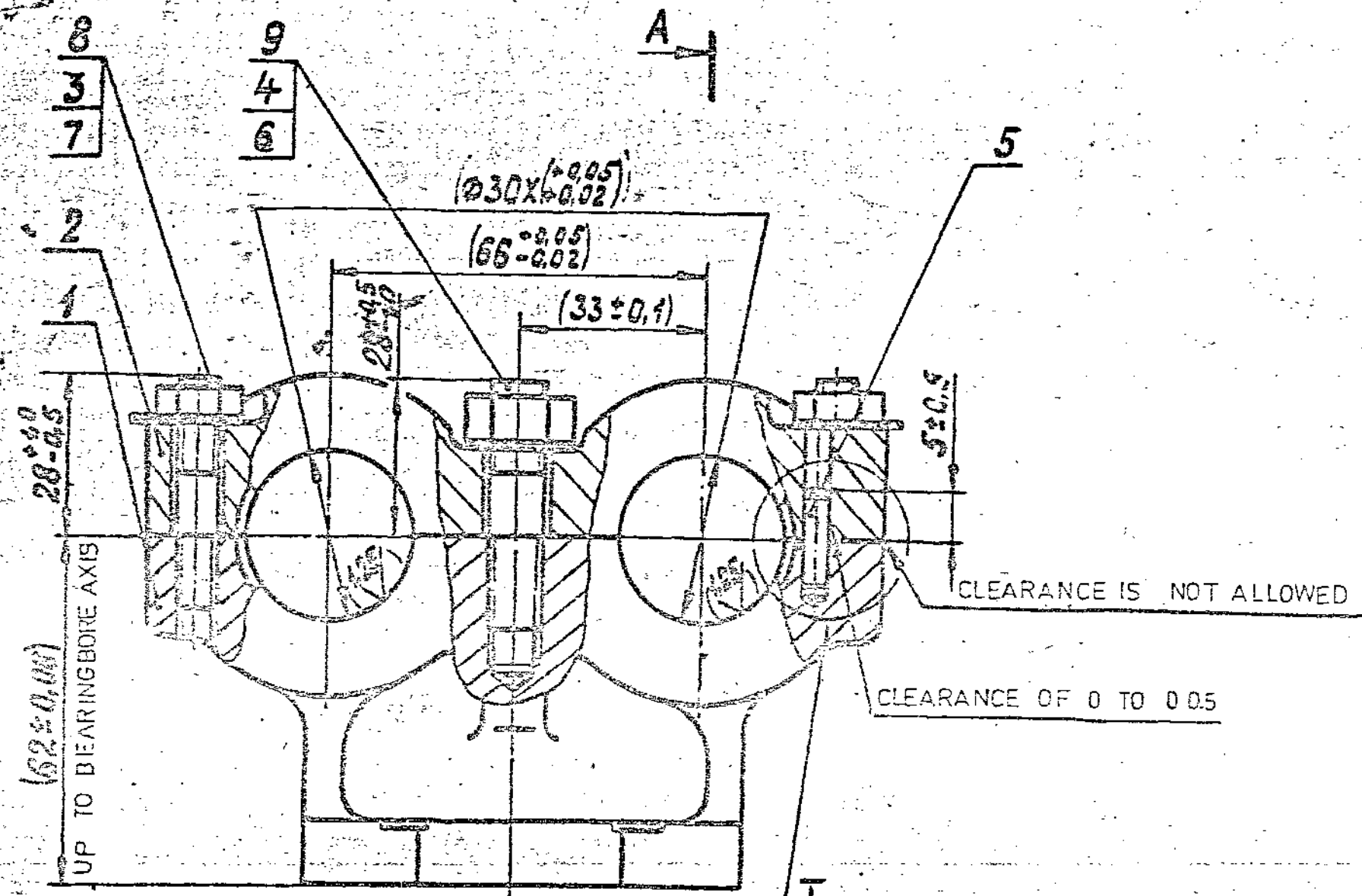
Alt. Material: STEEL 709M40 (EN-19) TO BS-970 Pt-1-1983

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

Сделано в ЦУМБ по чертежу, верно

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS #
		0,025 Kg	(LETTERS)
A	18.5.09	Authy: 3 rd Alt. Comm. Min. Pt. 2 Dated 27-02-09.	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 - 1 : 1	MATERIAL:-	USED ON:-
CHD	DIMENSIONS IN mm.	38 XA GOST 4-543-71	CB 20-06-04
TCD	TOLERANCE ON DIMNS - UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI.	
APPO	ALL THREADS CONFORM TO	TITLE:-	STUD M10X48
DATE 19/87		D S CAT NUMBER	DRAWING NUMBER
			550-118

40-90-07 90



1. GIVEN IN BRACKETS ARE DIMENSIONS AND SURFACE FINISH AFTER ASSEMBLY.
2. WASHERS 353-05-1 MAY BE INSTALLED PROVIDED THAT THEY ARE REPLACED WITH LOCK WASHERS 353-32 DURING FINAL ASSEMBLY OF HEAD.
3. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:

FOR HOLES — AS PER A7,
SHAFTS — AS PER B7,
OTHERS — AS PER CM 8.

4. MACHINE AS PER PART, REF No. 2.
5. BOTTOM PLANE MAY BE LAPPED, WITH ROUGHNESS Rz 20 BEING PROVIDED.

PISTON SAMPLE SHOULD BE APPROVED BY A.I.E.P BEFORE BULK PRODUCTION

EST. MASS	0.57 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS 4-	LETTERS 1
ISSUE DATE	23 137-89	NATURE OF AMENDMENTS	NoTn. No. 348-80 3
DRN	SCALE: 1:1	MATERIAL	USED ON: C6 20-06-01-5 C6 20-06-02-5
CHD	DIMENSIONS BY PART	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD	
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: CAMSHAFT BEARING ASSY	
APPD	ALL THREADS UNF/UNH	DRAWING NUMBER	SHEET 1 OF 2
DATE	26/11/87	DRAWING NUMBER SHEET 1 OF 2 C6 20-06-04	

