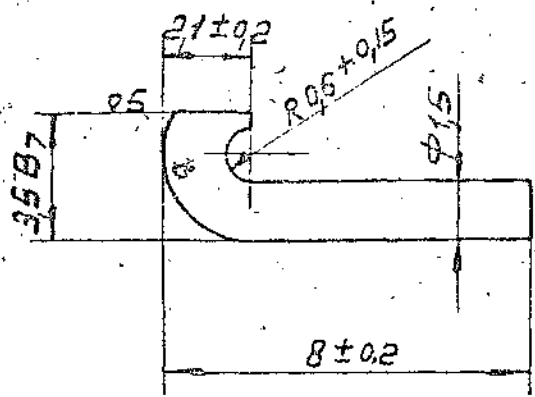


242 032 H

Утвержден.

Unless otherwise specified,



AMDT. NOTN. No: 0057-82  
0057-82  
0024-79

\* WIRE 15-10 GOST 5663-79

60

D-83

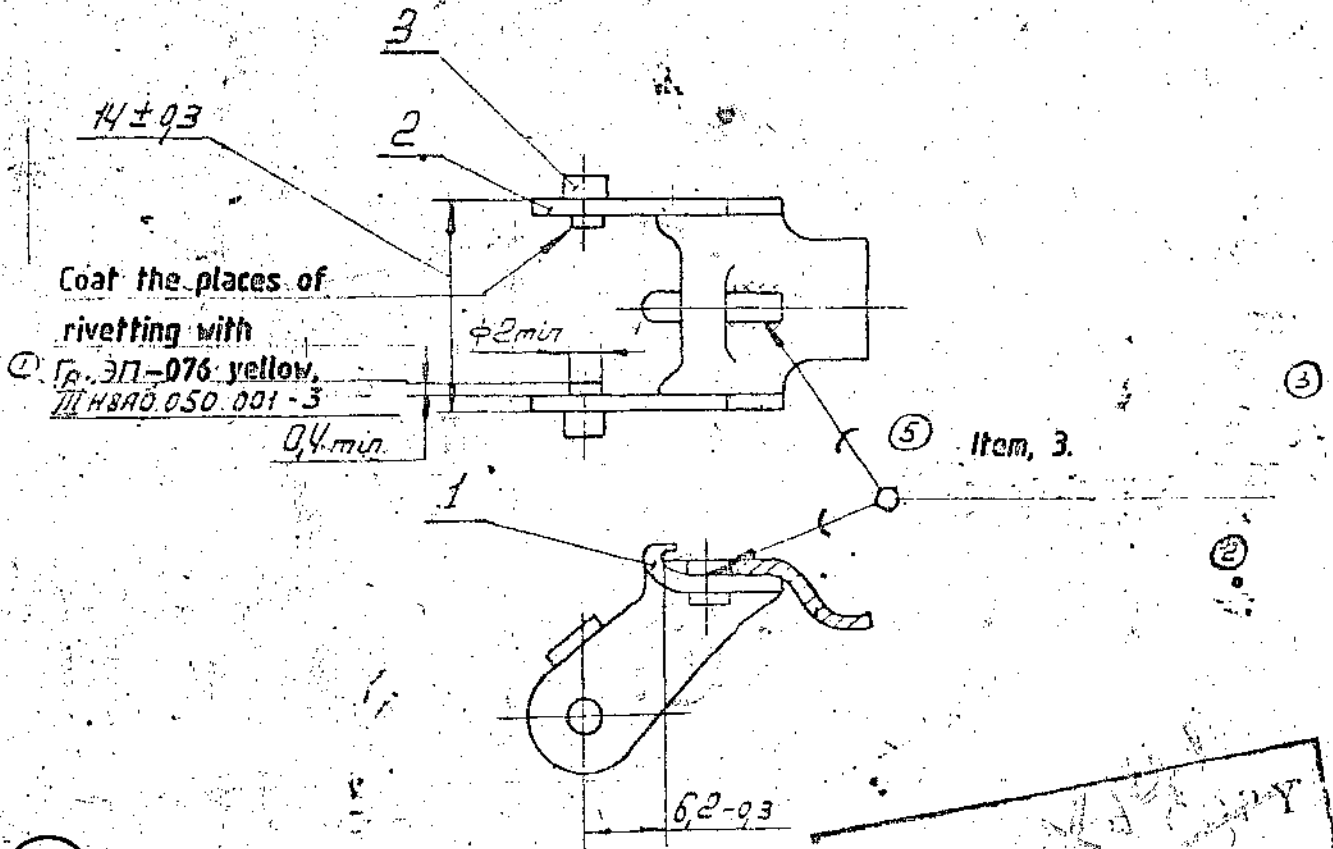
PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

		EST. MASS <b>0,00015 Kg</b>	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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL SEE ABOVE	USED ON: <b>255 026 H</b>
DRN	SCALE: <b>5:1</b>	CONTROL RATE OF INSPECTION (HEAVY VEHICLES:) AVADI	
END	DIMENSIONS IN mm	TITLE: <b>HOLDER</b>	
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	
APPO	ALL THREADS CONFORM TO	DRAWING NUMBER <b>242 032 H</b>	
DATE <b>9-9-87</b>			

255 026H

УТВЕРЖЕН

- 1 Displacement of axes of pins should not exceed 0,15 mm
- 2 Coating:- zinc-plated, 21 microns thick, chromated, except for pins, ref,no,3.
- 3 Braze with brass Л63 GOST 1066-75.



0-03

ХИТРА  
 10

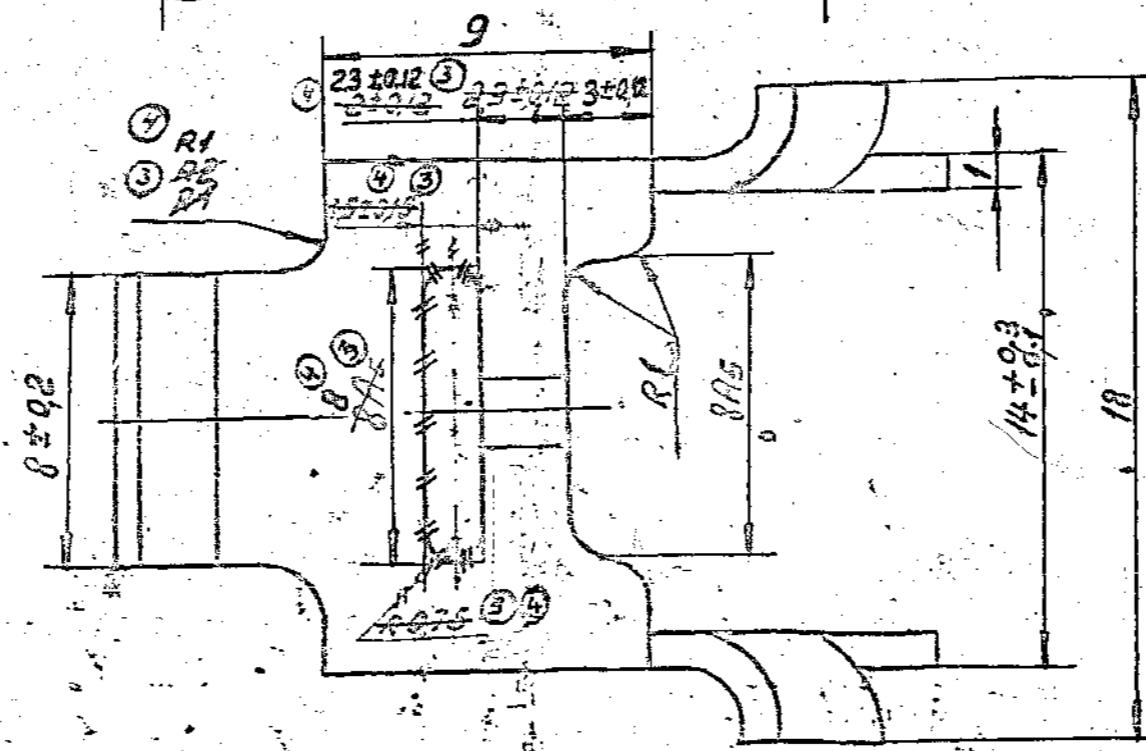
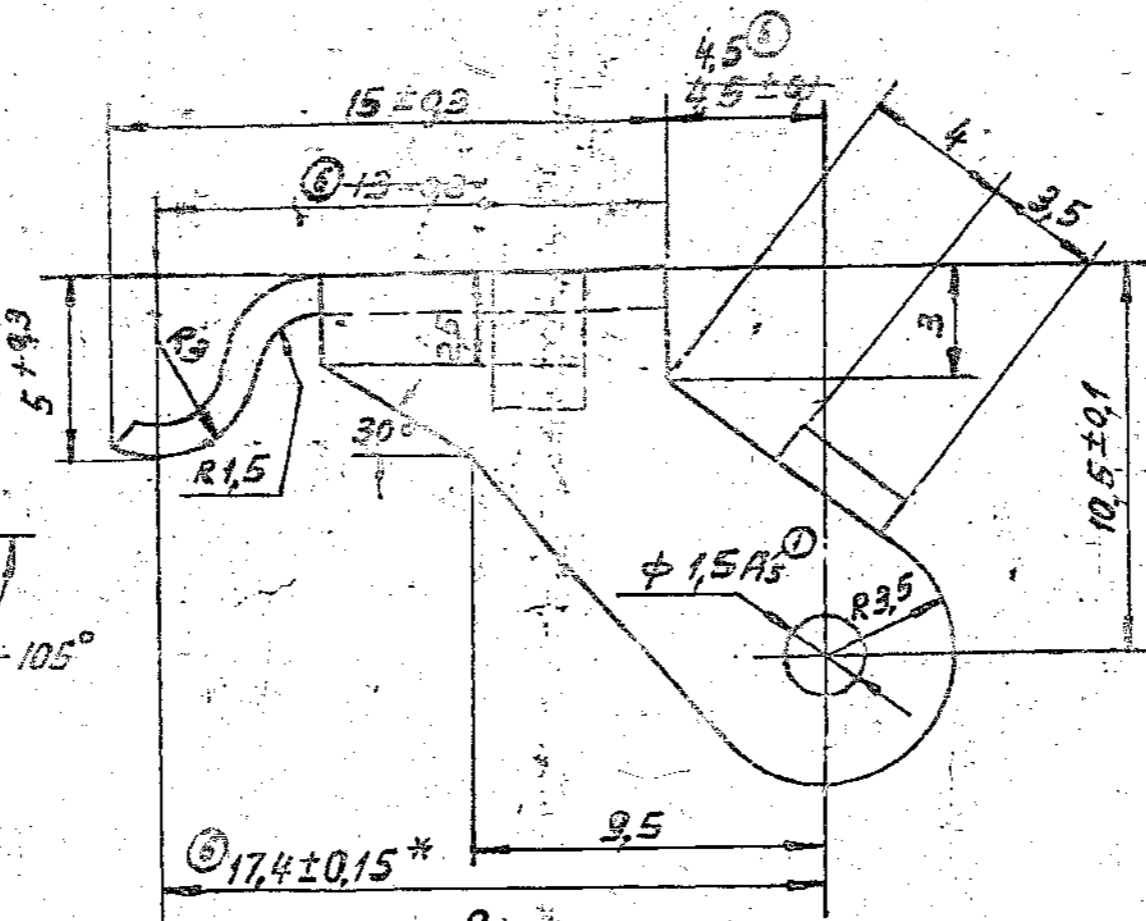
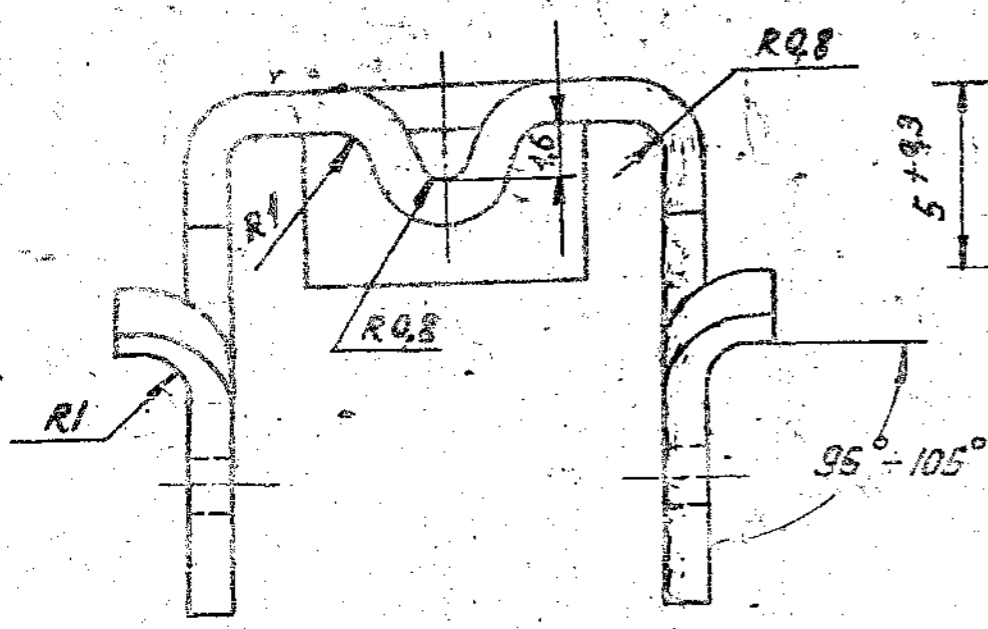
3	491. 220H	✓	Pin	2
2	256. 030H	✓	Lever	1
1	242. 032H	✓	Holder	1

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

25

ISSUE DATE	NATURE OF AMENDMENTS	EST. MASS 0.004 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS IS (LETTERS)
DRN	SCALE:- 2:1	MATERIAL:-	USED ON:- 550 044 H
CHD	DIMENSIONS IN P.S.L.	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI	TITL: LEVER
APPO	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER 255 026 H
DATE 9-9-07			

ИДЕНТИФИКАЦИОННЫЙ № 957



Tolerances for free dimensions are as per accuracy class 7, OST 1010.

Привести \* Dimension with tool

\* PLATE 5-GOST 18904-74  
II - Г 10 GOST 13523-70

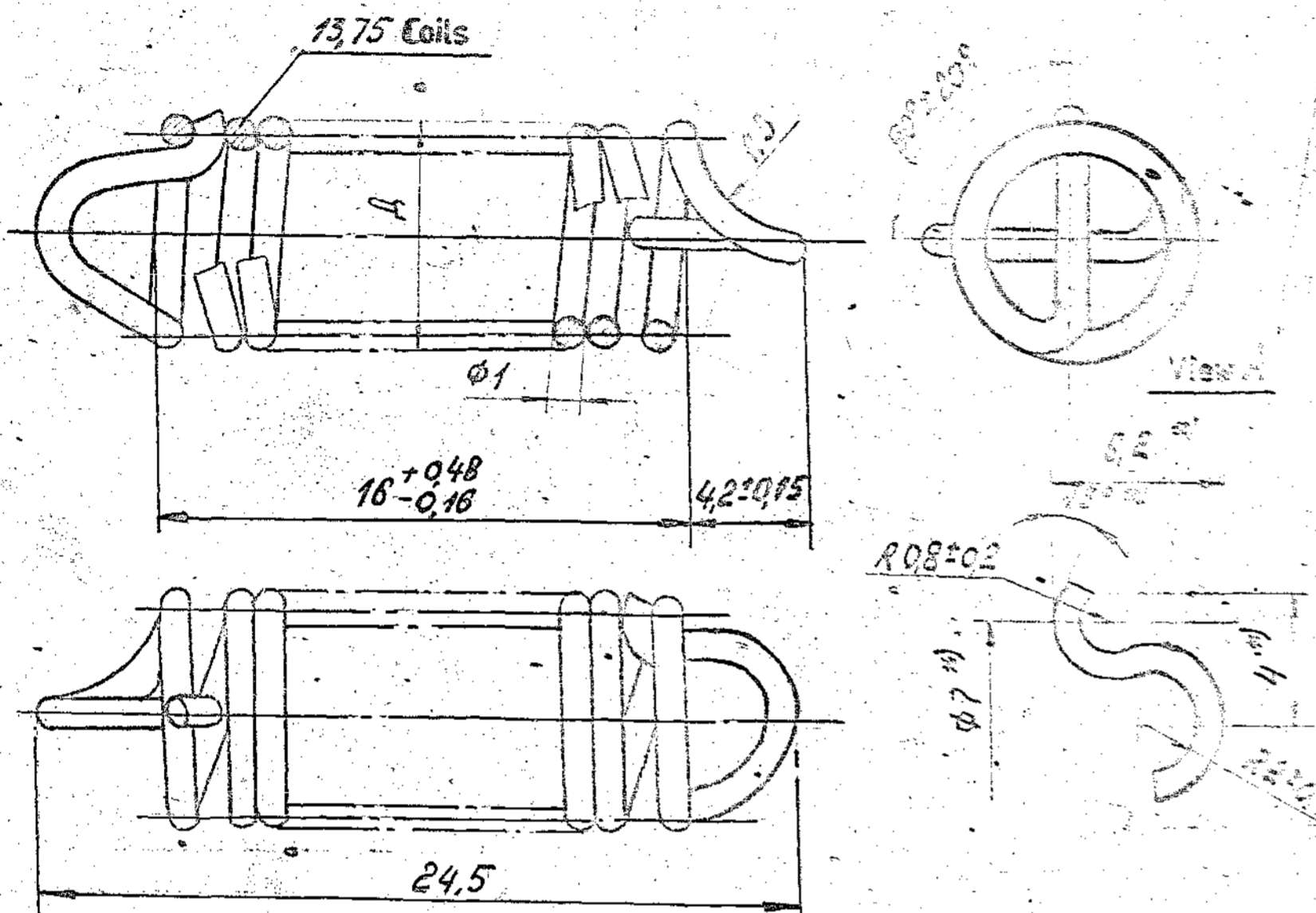
PROT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

61

ISSUE	DATE	NATURE OF AMENDMENTS	EST. MASS 0,003 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS )
ORN		SCALE: 5:1	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MAXIMUM CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT (CHAMFERS ARE PERMISSIBLE)	
CHD.		DIMENSIONS IN mm	MATERIAL SEE ABOVE	USED ON: 255 026H
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADH	
APPD.		ALL THREADS CONFORM TO	TITLE: LEVER	DRAWING NUMBER 256-030 H
DATE	9-9-87		D S CAT NUMBER	

503

ИДЕНТИФИКАЦИОННЫЙ № 957



1. Tolerance for free dimensions to be as per IS 2 AT
2. Carry-out heat treatment as per IS 2-13. Hardness should be 42 to 80.
3. Pitch between the two ends of eye may be obtained by their stretching.
4. Diameter of end coils may be as per tables 1 and 2.1.
5. Dimensions marked as \* are given for the construction of drawing.
6. Permissible displacement of eye with respect to the spring axis should not exceed 0.2 mm.
7. Permissible displacement of eyes with respect to the spring axis should not exceed 0.4 mm.
8. Undercutting and mechanical damage are not allowed at eye bands over R 3mm.
9. Force by load of 3.5 Kg for 24 hours.
10. Spring length may be increased by 0.5 mm after forcing by load.
11. Spring dimensions are given without considering the coating.
12. To obtain the given strength characteristic the external spring diameter A may be increased upto 0.2 mm for the values specified in tables.
13. Carry-out heat treatment after cadmium coating for two hours and at  $t = 180^{\circ}$  to  $200^{\circ}$ c
14. Springs should be made from the wire having the depth of surface decarburization not exceeding 0.01 mm (for each side).

TABLE NO-1

Wire Dia.	Spring Dia, A
0.99	7.87 -0.1
1	8.0 -0.1
1.01	8.07 -0.1
1.02	8.17 -0.1
1.03	8.28 -0.1

TABLE NO-2

Wire Dia.	Spring Dia, A

WIRE 51\*4A  
TYAEX 266-76

141  
56

Spring designation	Developed strength of spring when it is stretched upto the dimension 3/4 mm(Kgf).	Coating	Dependence of spring diameter A on wire diameter (Considering tolerance).	Remarks
443 353H-1	1.85 — 2.1	Chemical oxidation. Coat with varnish KP- 965 GOCT 15030-70	Table no:1	

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

EST. MASS 0,002 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS: (LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MAUNDED CORNERS TO HAVE R 0.05 ± 0.02	
ISSUE DATE	NATURE OF AMENDMENTS
DRW	SCALE: 1 : 1
CHKD	DIMENSIONS IN mm
YCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED
APPOZ	ALL THREADS CONFORM TO
DATE 9-9-87	
MATERIAL: * SEE ABOVE	
USED ON: 550 044 H	
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TITLE: SPRING	
D S CAT NUMBER	DRAWING NUMBER 443-353 H

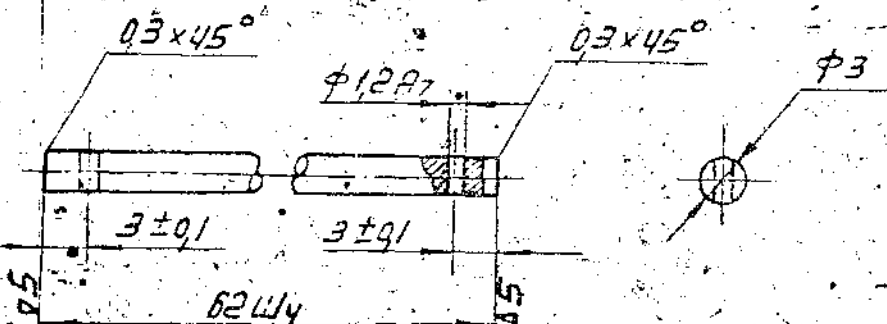
69

H800 16h

Unless otherwise Specified

Dehydrogenate

141  
80



Coating : Zinc-plated, 9 microns thick, chromated

D-83

PLOT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

		EST. MASS 0.0005 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS IS (LETTERS)	(92)
		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	MATERIAL :- WIRE 3-10 GOST 5663 -79	USED ON :-	550 044 H
DRN	SCALE:- 2:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
CHD	DIMENSIONS IN mm	⊕ □	TITLE	PIN
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	DRAWING NUMBER	
APPO	ALL THREADS CONFORM TO	491 008 H		
DATE 9-9-87				

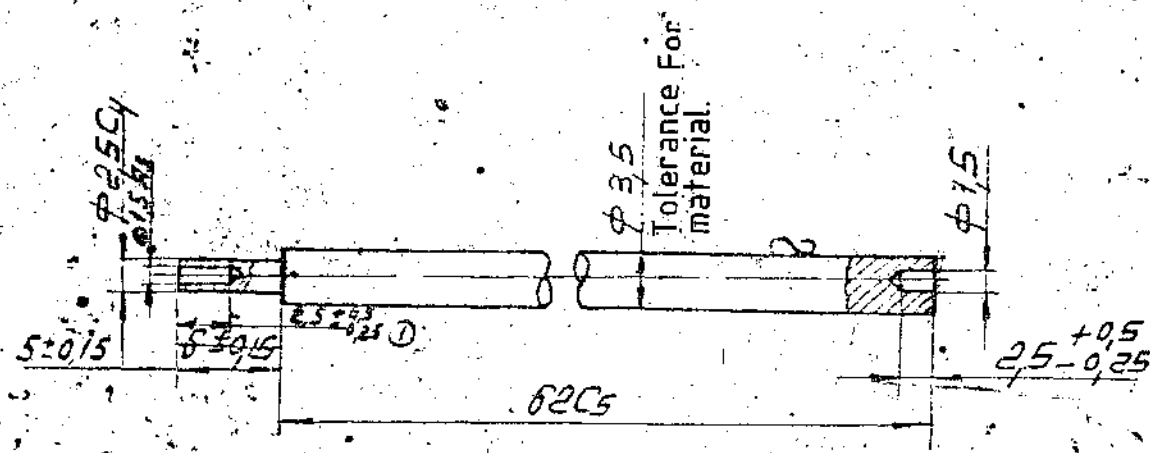
① M60016h

IND

95 - Unless otherwise specified.

- 1. Tolerances for free dimensions are as per accuracy class 7: OST 1010.
- 2. Dehydrogenate.

*Handwritten:* 1/4  
81



AMDT, NOTN, No 0057-02

Coating: Zinc - plated, 9microns thick chromated.

Q-83

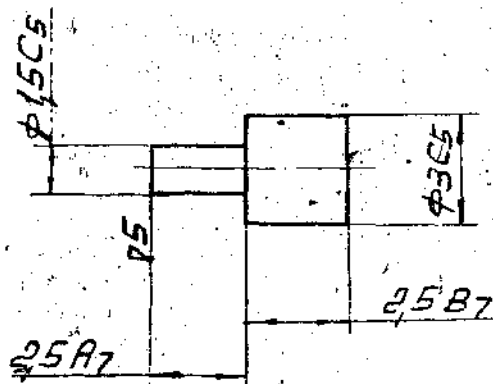
93

PROT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

		EST. MASS 0.006 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS IS (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	
DRN		SCALE:- 2:1	MATERIAL:- WIRE 3-5-10 GOST 5663-79
CRD		DIMENSIONS IN mm	USED ON:- 550 044 H
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPO		ALL THREADS CONFORM TO	TITLE: * PIN
DATE 9-9-87			D S CAT NUMBER DRAWING NUMBER 491 009 H

491.220H

Ø6 Unless otherwise specified



Coating: Chemical passivation

Alternate material is steel 2x 13 TY 14-1-378-72.

0-63

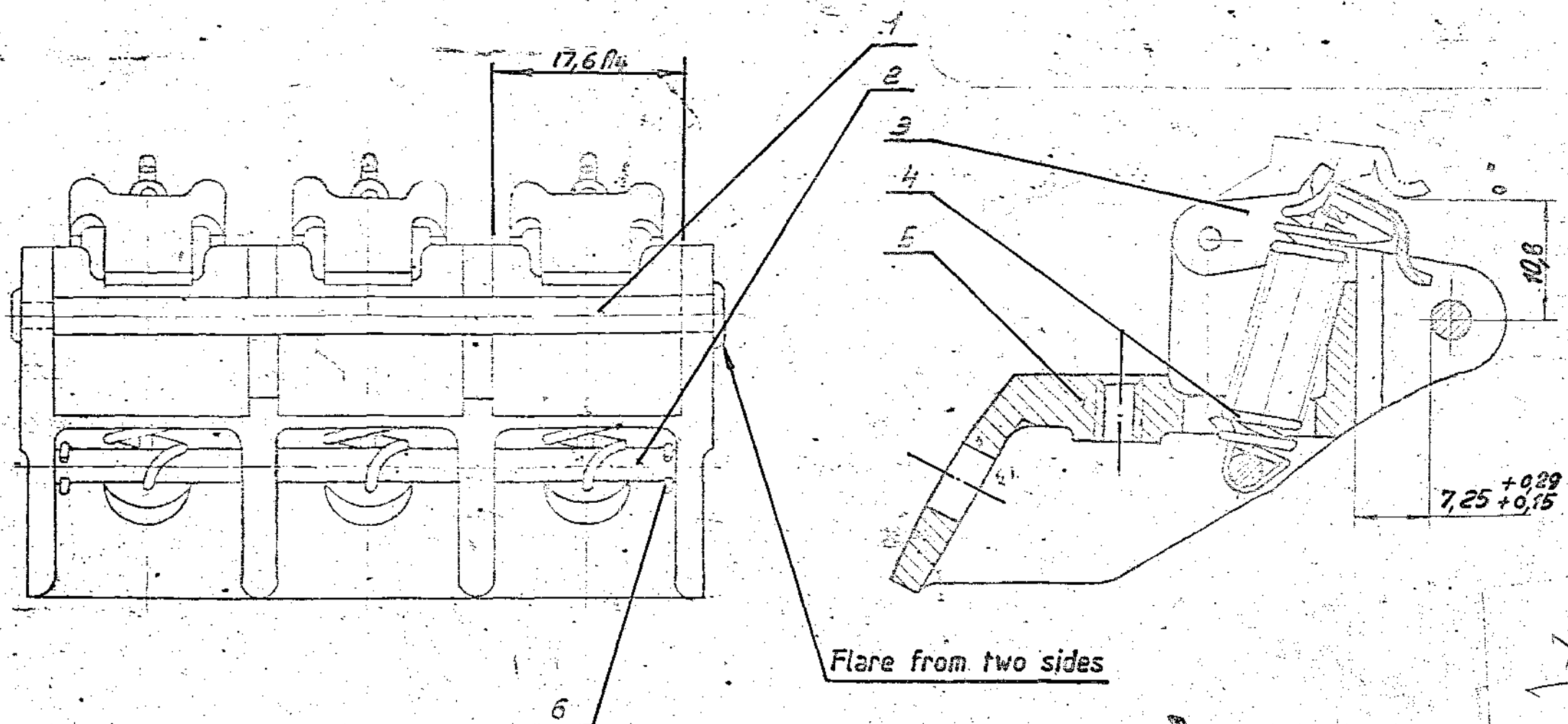
\* STEEL 1x13 TY 14-1-378-72

144

95

PROT SAMPLE SHOULD BE APPROVED BY A HSP 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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL	USED ON: 255 026H
DATE	SCALE: 5:1	* SEE ABOVE	
CHKD	DIMENSIONS IN MM	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAIA	
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	PIN	
APPD	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
DATE 9-87			491-220 H



1. Pressure on lever should be 575 to 700 gms for specified dimension 10,8 mm

S.No	DESIGNATION	DESCRIPTION	QTY.	REMARKS
6		Cotter pin 1x6,019 GOST 397-79	2	
5	551.015 H	Brush Holder	1	
4	443.353 H-1	Spring	3	
3	255.026 H	Lever <i>Asfy</i>	3	
2	491.008 H	Pin	1	
1	491.009 H	Pin	1	

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

		EST MASS 0,077Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS   (32)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHANGERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL: - USED ON: - 100-256 H
DRN		SCALE: - 2:1	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI
CHD		DIMENSIONS IN mm	TITLE: BRUSH HOLDER ASSY
YCD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER
APPD		ALL THREADS CONFORM TO	DRAWING NUMBER 550-044 H
DATE	9-9-07		

