Format

Формат	Зона	Поз.	Item Code Обозначение	Name Наименование	Qty. Кол.	Remark Примечание
A2	Zone 4	6	3318-08-7 Flange	Фланец	2	
A2		7	3318-08-8 Flange	Фланец	4	
A2		8	418-11-1 Flange	Фланец	1	
*1		9	418-23-4 Pipe	Труба	1	*1 A4x4
A2		10	418-55-4 Flange	Фланец	1	
A3		11	418-85-5 Bush	Втулка	1	
A4		12	418-86 Ring	Кольцо	1	
*1		13	418-90-5 Left shielding pipe	Труба защитная левая	1	*1 A4x3
*1		14	418-91-5 Left shielding pipe	Труба защитная левая	1	*1 A4x3
A4		15	418-101 Half ring	Полукольцо	3	

Подп. и дата | Инв. № дубл. | Взам. инв. № | Подп. и дата | Инв. № подл.

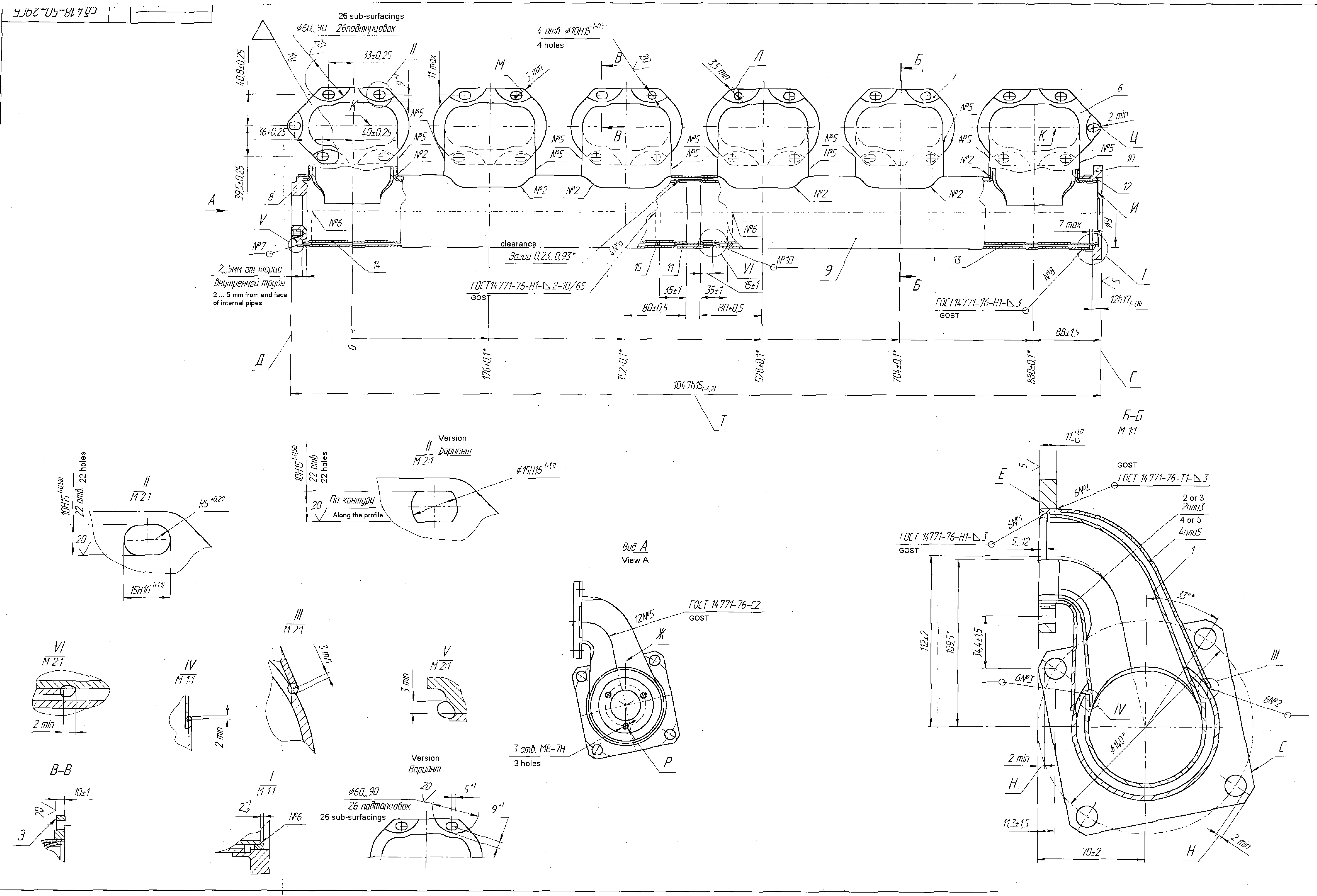
Tekla A. Ckd by:
Mik SWYA7
An Authenticated by:
Approved by:
Из Original history: Архив

Sign	Date
Подп.	Дата

сб.418-50-29 Ф-153 40/74

Sheet Лист 2

Формат А4



22. При отправке в запчасти поверхности Г,Д и Е фланцев поз.6,7,8 и 10 покрыть тонким равномерным слоем эмали КО-813 по ИЛ-619-86, неровности и потеки эмали не допускаются, местное неприлегание фланцев Е к плите не более 0,2мм до покрытия.

23. * Размеры для справок.

24. * Размеры для приспособления.

25. Допускается местная развальцовка бурта фланца дет поз.10 напротив сварного шва, соединяющего половинки патрубков с последующей подгибкой развальцованной части и наплавкой наружной поверхности бурта на длине 30мм, не менее, высотой 2мм, не менее на участке развальцовки.

1. Сварные швы № 2,3,10, выполнять в среде защитных газов.

2. Сварной шов № 7 выполнять ручной электродуговой сваркой.

3. Несовпадение контуров патрубков поз.2 или 3 и поз.4 или 5 не более 1мм.

4. В местах сварки частей патрубков поз.2 или 3 и поз.4 или 5 с трубой поз.9 и фланцами поз.6 и 7 допускается зазор до 2мм и нахлестка до 4мм

5. В местах сварки экранов поз.1 с защитными трубами поз.13 и 14 допускается на отдельных участках зазор до 1мм.

6. Допускаются оплавления до 0,2мм. Оплавления от 0,2мм до 0,5мм и непровары допускаются к исправлению подваркой.

7. По требованию ОТК не реже одного раза в месяц или от 150 штук один коллектор направляется в лабораторию для проверки качества сварки, отсутствия внутренних дефектов сварного соединения и толщины наплавленного металла по отбортовке или по стыку, которая должна быть не менее 2мм для ручной электродуговой сварки и 1,8мм для полуавтоматической сварки в среде углекислого газа проволокой Св-08Г2С.

8. Овальность трубы поз.9 после сварки не более 6мм, проверять выборочно по требованию ОТК.

9 Коллектор нормализовать при температуре (930^{+10}_{-20})°С с охлаждением коллектора, закрепленного в приспособлении.

10. Окончательно обработать плоскости Е фланцев после сварки и правки коллектора. Неплоскостность поверхности Е не более 0,2мм.

11. Правильность расположения отверстий для крепления фланцев поз.6 и 7 проверить на приспособлении со штифтами для круглых отверстий ∅9±0,05мм, для овальных отверстий 9±0,05×14±0,05мм.

Допускается подварка проушин фланцев поз.6 и 7 до размеров Л=3,5мм, М=3мм, Н=2мм, Ц=2мм.

Допускается на 3-ем и 4-ом фланцах поз.7 все отверстия выполнять $∅10H15^{(+0,58)}$мм.

12. Непараллельность поверхностей 3 подторцовок под гайки к поверхности фланцев Е не более 0,2мм на участке не менее 18×13мм, концентричном отверстию. На остальном участке допускается штамповочный завал.

13. Неперпендикулярность поверхностей Г и Д, замеренная по крайним точкам относительно плоскостей Е и оси крайних фланцев К, не более 1,5мм.

14. Неплоскостность поверхности Д и поверхности Г от ∅У до ∅125мм не более 0,2мм.

15. На поверхности коллектора допускаются вмятины с плавным переходом.

16. Допускается смещение оси отверстий Р относительно оси Ж коллектора не более 2°.

17. Допускается выступание и западание торца трубы поз.9 за поверхность Д фланца поз.8 до 4*мм в пределах размера Т.

18. Допускается срез выступающей части фланца С за поверхность Е.

19. Не допускается выступание торца И трубы поз. 13 над поверхностью Г.

20. Коллектор испытать на герметичность в водяной ванне воздухом под давлением (200^{+100})кПа $[(2^{+1})$кгс/см$^2]$. Пропуск воздуха не допускается. В местах пропуска воздуха разрешается подварка с последующей зачисткой и гидропробой.

21. Покрытие наружных поверхностей коллектора, кроме поверхностей Г,Д,Е фланцев поз.6,7,8 и 10 эмалью КО-813 по инструкции ИЛ-619-86, неровности и потеки эмали не допускаются.

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1. Welded seam No. 2, 3, 10, should be made in gas shielded medium.
2. Welded seam No. 7 should be made by manual electric arc welding.
3. Misalignment of contours of branch pipes item 2 or 3 and items 4 or 5 should not exceed 1 mm.
4. In the places of welding, portion of branch pipes item 2 or 3 and item 4 or 5 with pipes item 9 and flanges item 6 and 7, clearance up to 2mm and overlapping up to 4 mm is permitted.
5. In the places of welding screens item 1 with protective pipes item 13 and 14, clearance up to 1mm is permitted on separate sections.
6. Flashes up to 0.2mm are permitted. Flashes from 0.2mm to 0.5mm and poor penetration are permitted to be rectified by welding.
7. As per requirement of QC, one manifold out of 150 pieces or once in a month is sent to laboratory for checking the quality of welding, for the absence of internal defects of welded seams and thickness of build up metal on flanging or on butt joint. The thickness should be 2.0mm minimum for manual electric arc welding and 1.8mm minimum for semi automatic Co2 shielded arc welding with wire CB-08Г2C.
8. Ovality of pipe Item.9 not to exceed 6 mm after welding and to be checked at random as per the requirement of QC.
9. Manifold should be normalized at a temperature of [930(-20 to +10)] °C with cooling of manifold fastened in the fixture.
10. Finally machine the plane "E" of flange after welding and straightening of manifold. Non-flatness of surface "E" should not be more than 0.2mm.
11. Correctness of location of holes for fastening of flanges item 6 and 7 should be checked on a fixture with pins for circular holes Φ 9±0.05mm, for oval holes 9 ± 0.05 x 14±0.05mm.
Additional welding of lugs of flanges Item. 6 and Item.7 to obtain dimension Л=3.5mm, M=3mm, H=2mm, Ц=2mm is permitted.
It is permitted to make the all holes Φ 10H15 (+0.28) mm on 3 and 4 flanges Item.7.
12. Non parallelism of surface 3 of spot facings under nuts to surface of flanges "E" is not more than 0.2 mm on section not less than 18 x13mm concentric to hole. Inward camber is permitted on the rest of section after stamping.
13. Non-perpendicularity of surfaces Г and Д is measured at extreme points, relative to surfaces E and axis of end flanges k should not exceed 1.5mm.
14. Non-flatness of surface Д and surface Г from ΦY up to Φ 125 mm should not exceed 0.2mm.
15. Dents with smooth transitions are permitted on the surface of manifold.
16. Shift of axis of hole P in relation to the axis Ж of manifold should not exceed 2°.
17. Sinking and projection of end face of pipe Item. 9 beyond surface Д of flange Item. 8 up to 4mm within the limits of dimension T is permitted.
18. Shearing of projected portion of flange C beyond the surface E is permitted.
19. Projection of end face И of pipe Item.13 beyond surface Г is not permitted.
20. Manifold should be subjected to air tightness test in the water bath with air at pressure of [200+100)] KPa [(2(+1)) Kgf/cm2). Leakage of air is not permitted. In the places of air leakage, welding with subsequent dressing and pressure testing in water bath is permitted.
21. Coating of external surface of manifold, except surface Г, Д, E of flanges item 6, 7, 8 and 10 with enamel K0-813 as per instructions ИЛ-619-86, unevenness and overflows of enamel is not permitted.
22. In case, the component is meant as spares surfaces Г, Д and E of flanges Item. 6, 7, 8 and 10 should be coated with thin uniform layer of enamel K0-813 as per instructions ИЛ-619-86, un-evenness and overflow of enamel are not permitted. Local non adjoining of flanges E to plate should not exceed 0.2mm before coating.
23. *Dimensions are for reference.
24. *Dimensions are for fixture.
25. Flaring at places of collar of flange of part item 10 opposite to welding joints; joining the half of branch pipes followed with bending of flared portion and back up welding of outside surface of collar to length of minimum 30mm with a height of minimum 2mm. In the expanded portion is permitted.

					LEFT EXHAUST MANIFOLD			
		Doc. No.			сб.418-50-29СБ	Letter	Weight	Scale
22	Sheet	89-462	Sign.	Date		Лит.	Масса	Масштаб
Изм.	Лист	№ докум.	Подп	Дата	Коллектор выпускной левый Сборочный чертеж	А	18	1:2
Trans. & Ckd. by : M/s SWYAZ						Лист	Листов 1	
Authenticated by :					Assembly drawing	Sheet	Sheets	
Approved by :								
Engine Factory, Avadi								

Am

Format Формат	Zone Зона	Item Поз.	Code Обозначение	Name Наименование	Qty. Кол.	Remark Приме-чание
				Documents		
				Документация		
				Assembly drawing		
*1			сб.418-51-29СБ	Сборочный чертеж		*1А2х3
				Assembly units		
				Сборочные единицы		
				Screen of branch pipe		
А4		1	сб.318-22-5	Экран патрубка	6	
				Parts		
				Детали		
А2		2	3318-06-1	Часть патрубка	6 pcs is permitted to replace by item 3	6 шт.
			Lower part of branch pipe	нижняя		допускается
						замена на поз. 3
А2		3	3318-06-4	Часть патрубка	6 pcs is permitted to replace by item 2	6 шт.
			Lower part of branch pipe	нижняя		допускается
						замена на поз. 2
А2		4	3318-07-1	Часть патрубка	6 pcs is permitted to replace by item 5	6 шт.
			Upper part of branch pipe	верхняя		допускается
						замена на поз.5
А2		5	3318-07-4	Часть патрубка	6 pcs is permitted to replace by item 4	6 шт.
			Upper part of branch pipe	верхняя		допускается
						замена на поз. 4

Подп. и дата | Инв. № дубл. | Взам. инв. № | Подп. и дата | Инв. № подл. 45081

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Amd Изм.	Sheet Лист	Doc. No. 85-793 № докум.	Sign. Подп.	Date Дата
	2			

сб.418-51-29

Trans. & Ckd. by : M/s SWYAZ

Authenticated by :

Approved by :

Engine Factory, Avadi

LEFT EXHAUST MANIFOLD - Коллектор выпускной правый

Letter Лит.	Sheet Лист	Sheets Листов
	1	2

Формат А4

Format Формат	Zone Зона	Поз.	Item	Code Обозначение		Name Наименование	Qty. Кол.	Remark Приме-чание
A2		6	3318-08-7	Flange		Фланец	2	
A2		7	3318-08-8	Flange		Фланец	4	
A2		8	418-11-1	Flange		Фланец	1	
*1		9	418-23-4	Pipe		Труба	1	*1A4x4
A2		10	418-55-4	Flange		Фланец	1	
A3		11	418-85-5	Bush		Втулка	1	
A4		12	418-86	Ring		Кольцо	1	
*1		13	418-90-7	Right shielding pipe		Труба защитная правая	1	*1A4x3
*1		14	418-91-7	Right shielding pipe		Труба защитная правая	1	*1A4x3
A4		15	418-101	Half ring		Полукольцо	3	

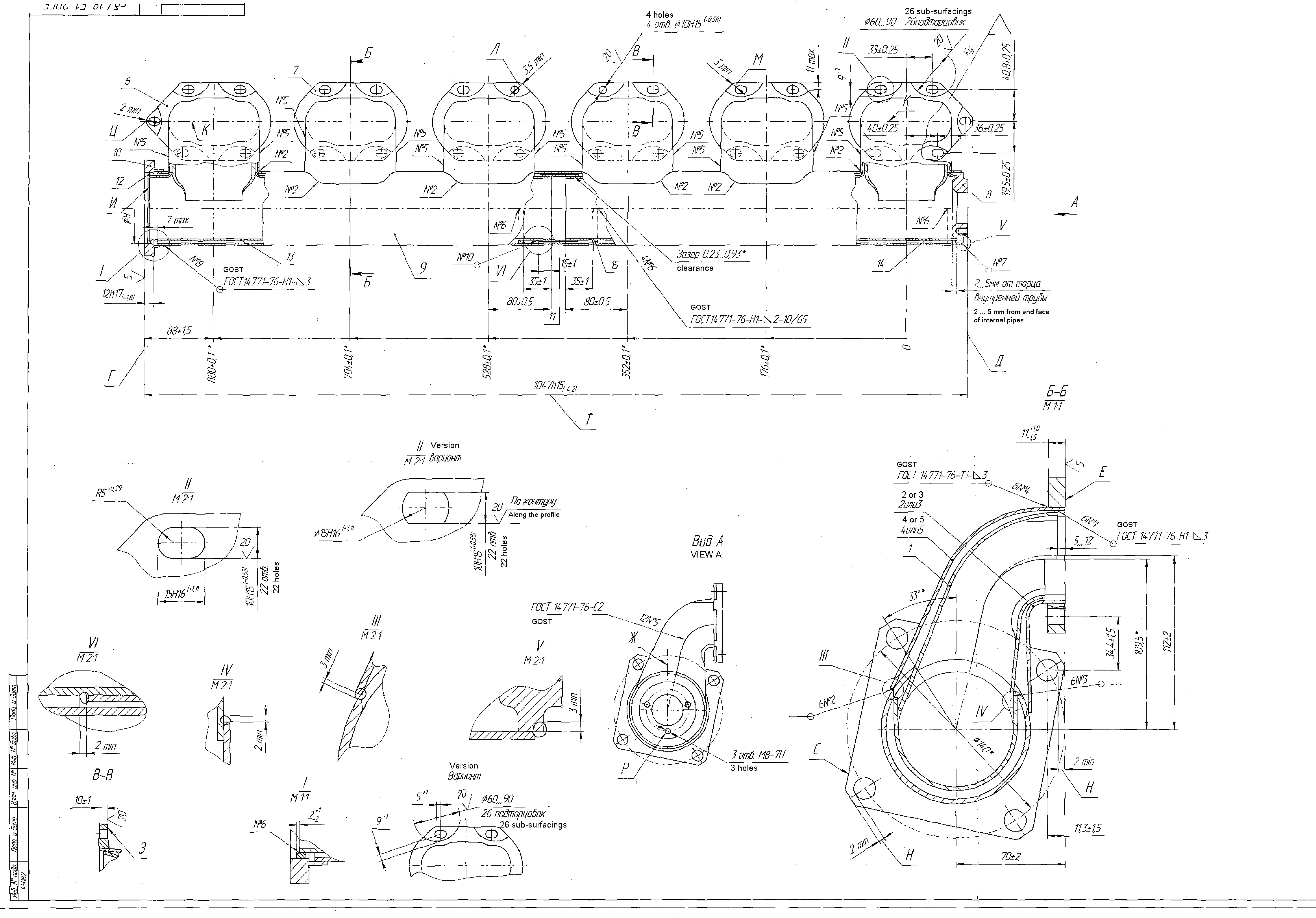
Подп. и дата | Инв. № дубл. | Взам. инв. № | Подп. и дата | Инв. № подл.

Amd. Изм	Sheet Лист	Doc. No. № докум.	Sign Подп.	Date Дата

сб.418-51-29 P-158 43/94

Sheet Лист 2

Формат А4



1 Сварные швы № 2,3,10, выполнять в среде защитных газов.

2 Сварной шов № 7 выполнять ручной электродуговой сваркой.

3 Несовпадение контуров патрубков поз.2 или 3 и поз.4 или 5 не более 1мм.

4. В местах сварки частей патрубков поз.2 или 3 и поз.4 или 5 с трубой поз.9 и фланцами поз.6 и 7 допускается зазор до 2мм и нахлестка до 4мм

5 В местах сварки экранов поз.1 с защитными трубами поз.13 и 14 допускается на отдельных участках зазор до 1мм.

6. Допускаются оплавления до 0,2мм. Оплавления от 0,2мм до 0,5мм и непровары допускаются к исправлению подваркой.

7 По требованию ОТК не реже одного раза в месяц или от 150 штук один коллектор направляется в лабораторию для проверки качества сварки, отсутствия внутренних дефектов сварного соединения и толщины наплавленного металла по отбортовке или по стыку, которая должна быть не менее 2мм для ручной электродуговой сварки и 1,8мм для полуавтоматической сварки в среде углекислого газа проволокой СВ-08Г2С.

8. Овальность трубы поз.9 после сварки не более 6мм, проверять выборочно по требованию ОТК.

9 Коллектор нормализовать при температуре (930^{+10}_{-20})°С с охлаждением коллектора, закрепленного в приспособлении.

10. Окончательно обработать плоскости Е фланцев после сварки и правки коллектора. Неплоскостность поверхности Е не более 0,2мм.

11. Правильность расположения отверстий для крепления фланцев поз.6 и 7 проверить на приспособлении со штифтами для круглых отверстий ϕ9±0,05мм, для овальных отверстий 9±0,05×14±0,05мм.

Допускается подварка проушин фланцев поз.6 и 7 до размеров Л=3,5мм, М=3мм, Н=2мм, Ц=2мм.

Допускается на $3^{ем}$ и $4^{ом}$ фланцах поз.7 все отверстия выполнять $\phi 10H15^{(+0,58)}$мм.

12. Непараллельность поверхностей 3 подторцовок под гайки к поверхности фланцев Е не более 0,2мм на участке не менее 18×13мм, концентричном отверстию. На остальном участке допускается штамповочный завал.

13. Неперпендикулярность поверхностей Г и Д, замеренная по крайним точкам относительно плоскостей Е и оси крайних фланцев К, не более 1,5мм.

14. Неплоскостность поверхности Д и поверхности Г от ϕУ до ϕ125мм не более 0,2мм.

15. На поверхности коллектора допускаются вмятины с плавным переходом.

16. Допускается смещение оси отверстий Р относительно оси Ж коллектора не более 2°.

17. Допускается выступание и западание торца трубы поз.9 за поверхность Д фланца поз.8 до 4мм в пределах размера Т.

18. Допускается срез выступающей части фланца С за поверхность Е.

19. Не допускается выступание торца И трубы поз. 13 над поверхностью Г.

20. Коллектор испытать на герметичность в водяной ванне воздухом под давлением (200^{+100})кПа $[(2^{+1})$кгс/см$^2]$. Пропуск воздуха не допускается. В местах пропуска воздуха разрешается подварка с последующей зачисткой и гидропробой.

21. Покрытие наружных поверхностей коллектора, кроме поверхностей Г,Д,Е фланцев поз.6,7,8 и 10 эмалью КО-813 по инструкции ИЛ-619-86, неровности и потеки эмали не допускаются.

22. При отправке в запчасти поверхности Г,Д и Е фланцев поз.6,7,8 и 10 покрыть тонким равномерным слоем эмали КО-813 по ИЛ-619-86, неровности и потеки эмали не допускаются, местное неприлегание фланцев Е к плите не более 0,2мм до покрытия.

23. * Размеры для справок.

24. *[1] Размеры для приспособления.

25. Допускается местная развальцовка бурта фланца дет. поз.10 напротив сварного шва, соединяющего половинки патрубков с последующей подгибкой развальцованной части и наплавкой наружной поверхности бурта на длине 30мм, не менее, высотой 2мм, не менее на участке развальцовки.

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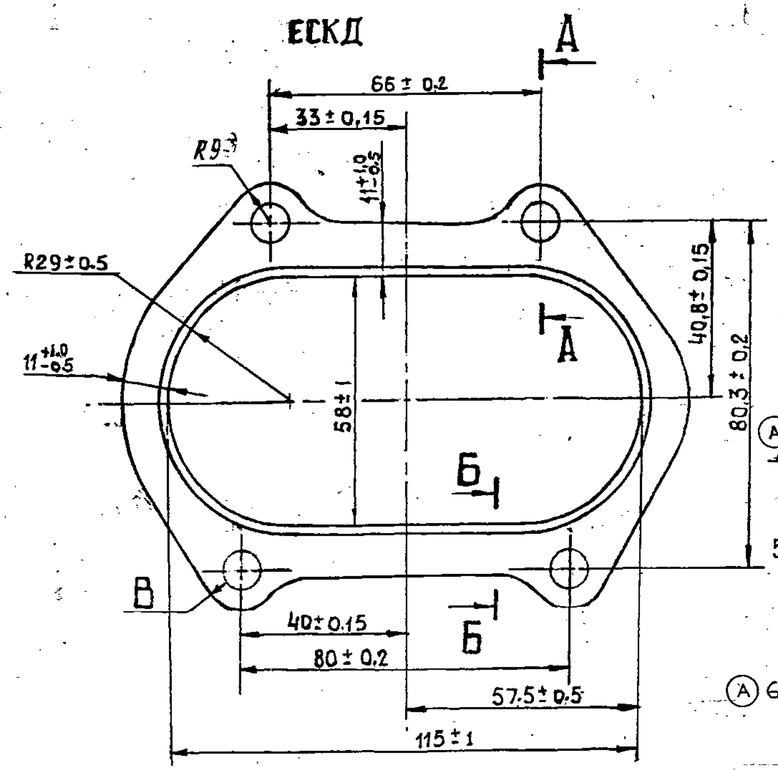
1. Welded seam No. 2, 3, 10, should be made in gas shielded medium.
2. Welded seam No. 7 should be made by manual electric arc welding.
3. Misalignment of contours of branch pipes item 2 or 3 and items 4 or 5 should not exceed 1 mm.
4. In the places of welding, portion of branch pipes item 2 or 3 and item 4 or 5 with pipes item 9 and flanges item 6 and 7, clearance up to 2mm and overlapping up to 4 mm is permitted.
5. In the places of welding screens item 1 with protective pipes item 13 and 14, clearance up to 1mm is permitted on separate sections.
6. Flashes up to 0.2mm are permitted. Flashes from 0.2mm to 0.5mm and poor penetration are permitted to be rectified by welding.
7. As per requirement of QC, one manifold out of 150 pieces or once in a month is sent to laboratory for checking the quality of welding, for the absence of internal defects of welded seams and thickness of build up metal on flanging or on butt joint. The thickness should be 2.0mm minimum for manual electric arc welding and 1.8mm minimum for semi automatic Co2 shielded arc welding with wire CB-08Г2C.
8. Ovality of pipe Item.9 not to exceed 6 mm after welding and to be checked at random as per the requirement of QC.
9. Manifold should be normalized at a temperature of [930(-20 to +10)] °C with cooling of manifold fastened in the fixture.
10. Finally machine the plane "E" of flange after welding and straightening of manifold. Non-flatness of surface "E" should not be more than 0.2mm.
11. Correctness of location of holes for fastening of flanges item 6 and 7 should be checked on a fixture with pins for circular holes Φ 9±0.05mm, for oval holes 9 ± 0.05 x 14±0.05mm.
Additional welding of lugs of flanges Item. 6 and Item.7 to obtain dimension Л=3.5mm, M=3mm, H=2mm, Ц=2mm is permitted.
It is permitted to make the all holes Φ 10H15 (+0.28) mm on 3 and 4 flanges Item.7.
12. Non parallelism of surface 3 of spot facings under nuts to surface of flanges "E" is not more than 0.2 mm on section not less than 18 x13mm concentric to hole. Inward camber is permitted on the rest of section after stamping.
13. Non-perpendicularity of surfaces Г and Д is measured at extreme points, relative to surfaces E and axis of end flanges k should not exceed 1.5mm.
14. Non-flatness of surface Д and surface Г from ΦY up to Φ 125 mm should not exceed 0.2mm.
15. Dents with smooth transitions are permitted on the surface of manifold.
16. Shift of axis of hole P in relation to the axis Ж of manifold should not exceed 2°.
17. Sinking and projection of end face of pipe Item. 9 beyond surface Д of flange Item. 8 up to 4mm within the limits of dimension T is permitted.
18. Shearing of projected portion of flange C beyond the surface E is permitted.
19. Projection of end face И of pipe Item.13 beyond surface Г is not permitted.
20. Manifold should be subjected to air tightness test in the water bath with air at pressure of [200+100)] KPa [(2(+1)) Kgf/cm2). Leakage of air is not permitted. In the places of air leakage, welding with subsequent dressing and pressure testing in water bath is permitted.
21. Coating of external surface of manifold, except surface Г, Д, E of flanges item 6, 7, 8 and 10 with enamel K0-813 as per instructions ИЛ-619-86, unevenness and overflows of enamel is not permitted.
22. In case, the component is meant as spares surfaces Г, Д and E of flanges Item. 6, 7, 8 and 10 should be coated with thin uniform layer of enamel K0-813 as per instructions ИЛ-619-86, un-evenness and overflow of enamel are not permitted. Local non adjoining of flanges E to plate should not exceed 0.2mm before coating.
23. *Dimensions are for reference.
24. *1 Dimensions are for fixture.
25. Flaring at places of collar of flange of part item 10 opposite to welding joints; joining the half of branch pipes followed with bending of flared portion and back up welding of outside surface of collar to length of minimum 30mm with a height of minimum 2mm. In the expanded portion is permitted.

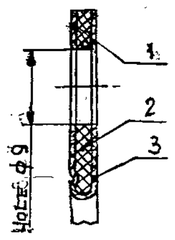
RIGHT EXHAUST MANIFOLD					
сб.418-51-29СБ					
Am	22 Sheet Изм. Лист	Doc. No. 89-462 № докум.	Sign. Подп.	Date Дата	
Trans. & Ckd. by: M/s SWYAZ	Коллектор выпускной правый Сборочный чертеж	Letter Лит.	Weight Масса	Scale Масштаб	
Authenticated by:		A	18	1:2	
Approved by:	Assembly drawing	Sheet Лист	Sheets Листов 1		
Engine Factory. Avadi					

Формат А2×3

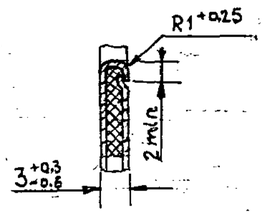
DRAWING NUMBER
СБ 3306-15СБ



A-A
SCALE 2:1



Б-Б
SCALE M2:1



1. Ruptures, cracks, burrs and bulging are not permissible on the external surface and at the flared places.
2. Asbestos sheet should be on one level with the edges of copper cover plate or project beyond them by 0.5 mm, max. Its edges should not be torn.
3. Flared edges of the copper sheet should be in one plane with the side surface of the gasket. The projection not exceeding the thickness of the sheet is permissible.
4. ~~The gaskets should be selected as a set of 12 Pcs with a variation in thickness not exceeding 0.2 mm.~~ (A)
5. Cover plate 3 may be flared up on the outer profile of the gasket to the contact with cover plate 1 and in holes B to a height upto 1 mm
6. (A) Gaskets should be selected as a set of 6 pcs, namely,

СБ 3306-15	4 Pcs
СБ 3306 - 15_2	1 Pc
СБ 3306 - 15-3	1 Pc

7. (A) Difference in thickness of gaskets in a set should not exceed 0.2 mm.

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

EST. WT. 0.030 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
A	8.3.07	AUTH:ALT No.2.2 MIN OF CQA DT.23-02-07

DRN	
CHD	
TCD	
APPD	
DATE	2-4-90
SCALE :- 1:1	
DIMENSIONS IN mm.	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	
ALL THREADS TO CONFORM TO	

MATERIAL :-

USED ON :- СБ 3300-00-27СХ

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI

TITLE GASKET ASSY

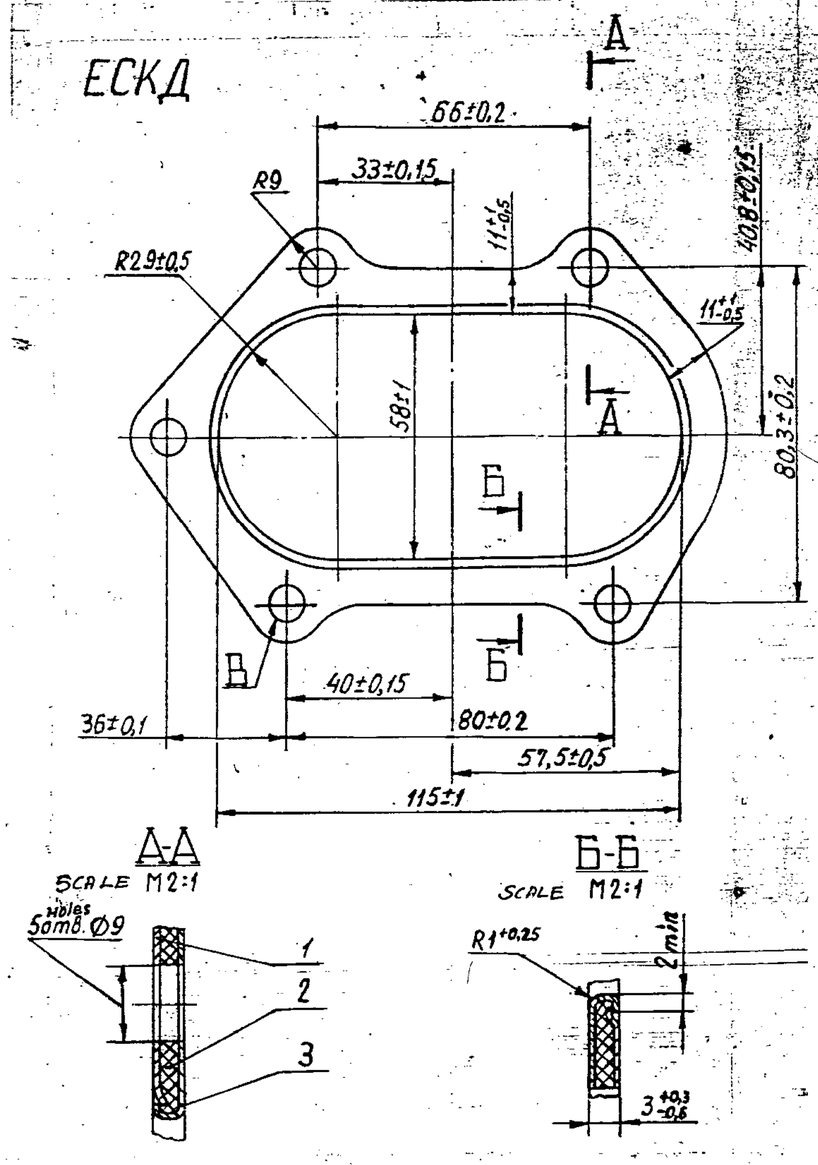
D S CAT NUMBER

DRAWING NUMBER СБ 3306-15 СБ

A4
66
A2

DRAWING NUMBER
СБ 3306-15-2СБ

ЕСКД



1. Ruptures cracks,burrs and bulgings are not permissible on the external surface of the gasket and at flared places.
2. Asbestos sheet should be on one level with the extreme edges of copper cover plate of project beyond it by 0.5 mm max, its edges should not be torn.
3. Flared edges of the copper sheet should be in one plane with the side surfaces of the gasket. The projection not exceeding the thickness of the sheet is permissible.
4. Gaskets should be selected as set of 6 Pcs,namely,
   - СБ 3306 - 1.5 - 4 PCs;
   - СБ 3306 - 15.2-1 PC;
   - СБ 3306-15-3 -1 PC,
5. Difference in thickness of gaskets in a set should not exceed 0.2 mm.
6. Cover plate,3 may be flared on the outer profile of the gasket to the contact with cover plate 1 and in holes B to be height upto 1 mm.

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

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

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	Енчев
CHD	
TCD	
APPD	
DATE	2-4-90
SCALE :- 2:1	
DIMENSIONS IN mm.	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	
ALL THREADS TO CONFORM TO	
D S CAT NUMBER	

MATERIAL :-

USED ON :-
СБ 3300-00-27СХ

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)
A V A D I

TITLE
GASKET ASSY

DRAWING NUMBER
СБ 3306-15-2 СБ

A4
6B
SIZE A2

USED ON

C5 3300-00-27 CX

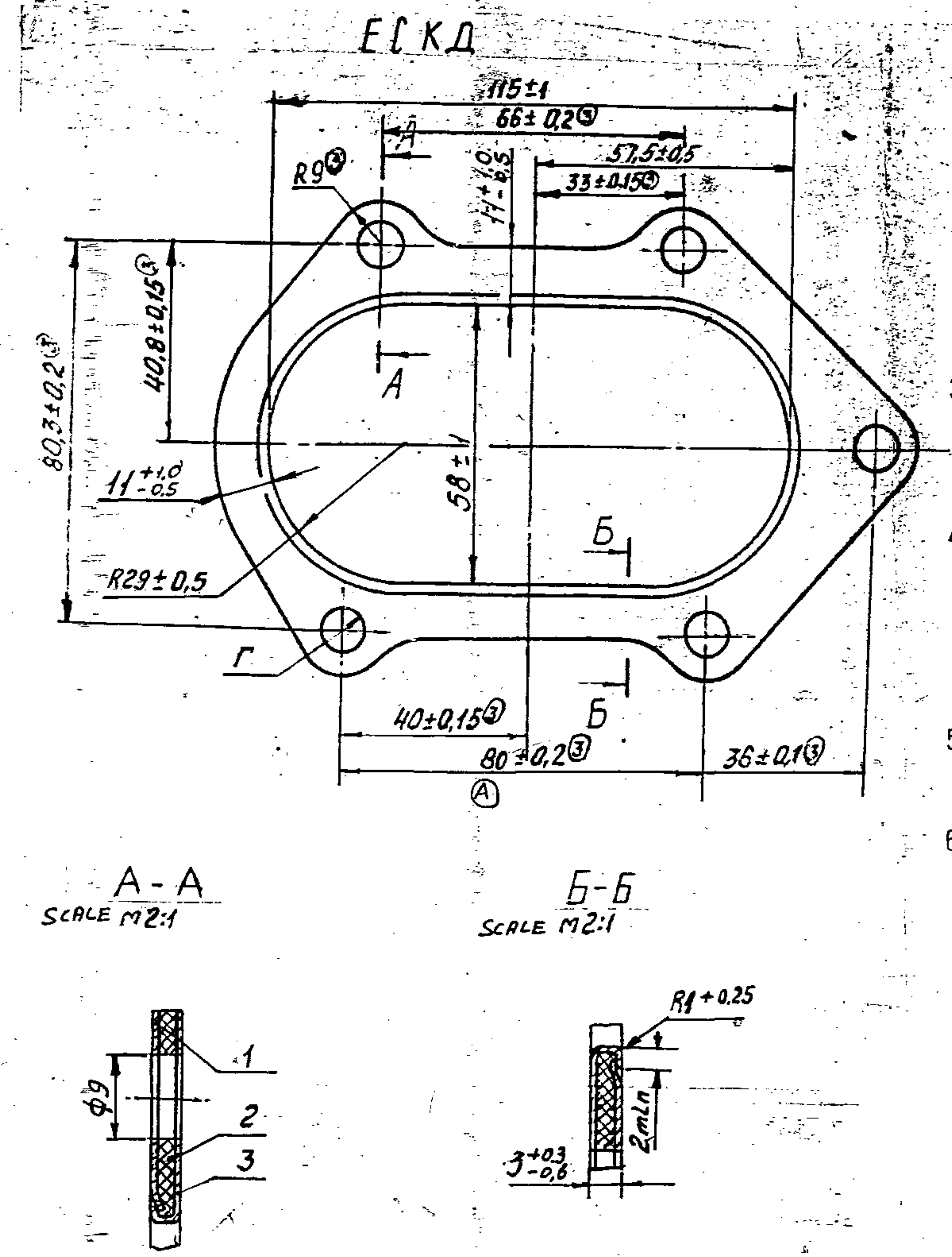
ITEM	DRAWING NUMBER	D S CAT. NUMBER	DESCRIPTION	No. OFF	REMARKS
	C5 3306-15-2 C5		GASKET ASSY.		
	& ITEM LIST				
1	3306-99-2		UPPER COVER PLATE	1	
2	3306-100-2		GASKET	1	
3	3306-101-2		LOWER COVER PLATE	1	

ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS

DRN	Ug	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
CHD		TITLE: GASKET ASSY.	
TCD.	Ug.		
APPD			
DATE	2 - 4 - 90	SHT. No. 1 OF 1	D S CAT NUMBER
			ITEM LIST FOR C5 3306-15-2 C5

A4
67

DRAWING NUMBER
СБ 3306-15-3СБ



1. Ruptures, cracks, burrs, bucklings and bulgings are not permissible on the outer surface of gaskets and at the flared places.
2. Asbestos sheet should be on one level with the edges of copper cover plate or project beyond them by 0.5 mm, max; its edges should not be torn.
3. Flared edges of the copper sheet should be in one plane with the side surface of the gasket. The projection not exceeding the thickness of the sheet is permissible.
4. Gaskets should be selected a set of 6 pcs namely:

   СБ 3306-15 4 Pcs

   СБ 3306 - 15.2 1 PC

   СБ 3306 - 15.3 1 Pc
5. Difference in thickness of gaskets in a set should not exceed 0.2 mm.
6. Cover plate 3 may be flared up along the outer profile of the gasket to the contact with cover plate 1 and in holes to height upto 1 mm

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

EST. WT. 0.036 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
A	23-6-93	AUTHY.LT.No.93026/CQA(CVB)/LP/ato dt 24.5.93

DRN	
CHD	
TCD	
APPD	
DATE	2-4-90
SCALE :- 1:1.	
DIMENSIONS IN mm.	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	
ALL THREADS TO CONFORM TO	

MATERIAL :- —

USED ON :- СБ 3300-00-27СХ

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI

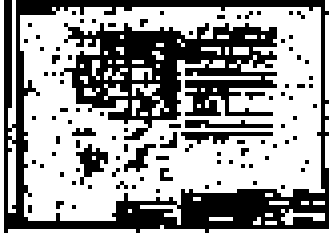
TITLE: GASKET ASSY

D S CAT NUMBER

DRAWING NUMBER СБ 3306-15-3СБ

A4 70

SIZE A2



USED ON

C6 3300-00-27CX

ITEM	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	No. OFF	REMARKS
	C63306-15-3C6		GASKET ASSY.		
	& ITEM LIST				
1	3306-99-2		UPPER COVER PLATE	1	
2	3306-100-2		GASKET	1	
3	3306-101-3		LOWER COVER PLATE	1	

ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS

DRN	
CHD	
TCD.	
APPD	
DATE	2 - 4 - 90

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.

TITLE: GASKET ASSY.

SHT. No. 1 OF 1

D S CAT NUMBER

ITEM LIST FOR C63306-15-3 C6

A4 69

USED ON

C63300-00-27EX

ITEM	DRAWING NUMBER	CAT NUMBER	DESCRIPTION	No. OFF	REMARKS
	C63306-15C6		GASKET ASSY.		
	& ITEM LIST				
1	3306-99		UPPER COVER PLATE	1	
2	3306-100		GASKET	1	
3	3306-101		LOWER COVER PLATE	1	

ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS

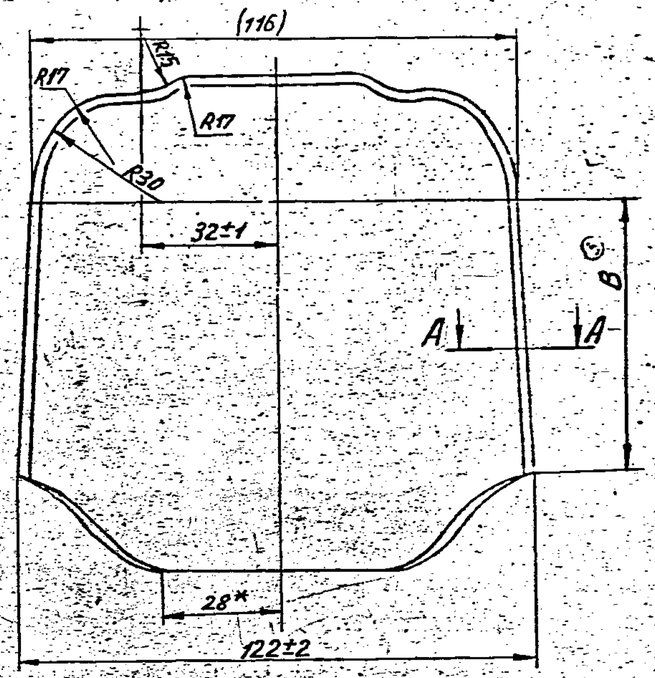
DRN	lfg	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.	
CHD		TITLE: GASKET ASSY.	
TCD.	lfg.		
APPD			
DATE	2-4-90	SHT. No. 1 OF 1	D S CAT NUMBER

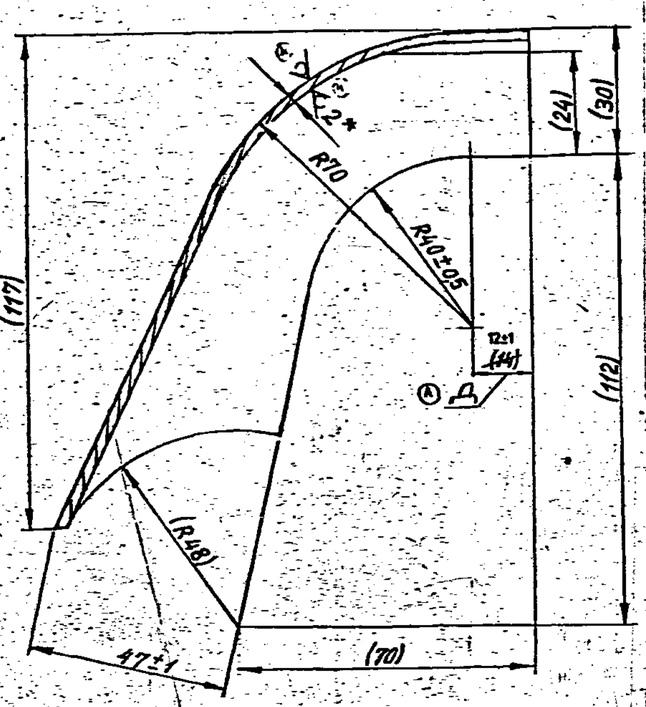
ITEM LIST FOR C63306-15C6

A4/65

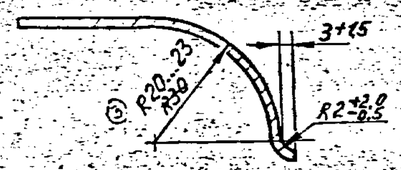
DRAWING NUMBER
3318-07-4

Rz320/ V(√)④

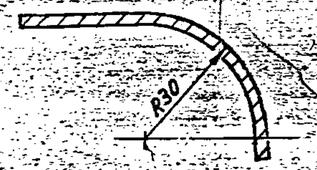




A-A ALTERNATIVE Вариант



A-A



9. ON SECTION 'A' BEAD SHOULD NOT BE MADE, WHEN (A) MANUFACTURING AS PER ALTERNATIVE.

EXPLANATORY NOTE:-

MATERIAL QUOTED: SHEET A 2 GOST 19904-74 / II-Г-10 GOST 16523-70

A = HIGH ACCURACY
2 = THICKNESS OF COLD ROLLED SHEET STEEL TO GOST 19904-74.
II = GROUP FOR QUALITY OF SURFACE FINISH.
Г = CAPABILITY TO DRAW - DEEP DRAWN.
10 = GRADE OF STEEL

CHEMICAL COMPOSITION % (AS PER GOST 1050-74)

CARBON = 0.07-0.14 ; SILICON = 0.17-0.37 ;
MANGANESE = 0.35-0.65 ;
CHROMIUM = 0.15 (MAX) ; SULPHUR = 0.040 (MAX) ;
PHOSPHORUS = 0.035 (MAX) ; COPPER = 0.25 (MAX) ;
NICKEL = 0.25 (MAX).

MECHANICAL PROPERTIES (AS PER GOST 16523-70)

ULTIMATE TENSILE STRENGTH Kgf/mm^2 = 30-42
% ELONGATION (MIN) = 25

2. DIMENSIONS WITH UNSPECIFIED TOLERANCES FOR COLD STAMPING SHOULD BE OBTAINED WITH TOLERANCE ±2mm.
3. MATERIAL THICKNESS IN THINNED PLACES SHOULD NOT BE LESS THAN 1.5 mm.
4. RUPTURE HOLES, LAMINATIONS, DENTS AND OTHER DEFECTS ARE NOT ALLOWED.
5. DIMENSIONS IN BRACKETS SHOULD BE OBTAINED WITH ACCURACY ±1mm.
6. BEFORE PUTTING INTO PRODUCTION, THE MATERIAL SHOULD BE CHECKED FOR WELDABILITY AS PER SPECIFICATIONS OF THE WELDING DEPARTMENT.
7. * DIMENSIONS FOR REFERENCE.
8. WHEN MANUFACTURING AS PER ALTERNATIVE SMOOTH TRANSITION OF R30 TO R20 TO 23 SHOULD BE ENSURED ON SECTION 'B'

ALTERNATIVE MATERIAL

(A) SHEET A-ПВ-0-2.0 GOST 19904-74 / II-ВГ 08ИС GOST 9045-80

(B) EQUIVALENT MATERIAL
Gr. D. IS: 513-1994

EXPLANATORY NOTE ADDED ON 18-2-92
DRG INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE NO 4.

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

EST. WT.	TO BE STAMPED OR MARKED WHERE INDICATED THUS #
0.428 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.

ISSUE	DATE	NATURE OF AMENDMENTS
B	18.03.10	4TH Alt. Comm. Mt. Minutes Pt. No. 1 Dt. 26.10.09
A	18.9.89	AUTHY. BK 84-773 & 85-788

DATE 7-4-88
DRN
CHD
TCD
APPD
SCALE :- 1:1
DIMENSIONS IN mm.
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69
ALL THREADS TO CONFORM TO

MATERIAL :- SHEET A 2 GOST 19904-74 / II-Г-10 GOST16523-70
USED ON :- CB 411-50-29 / CB 411-51-29
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI

TITLE
UPPER HALF OF BRANCH PIPE

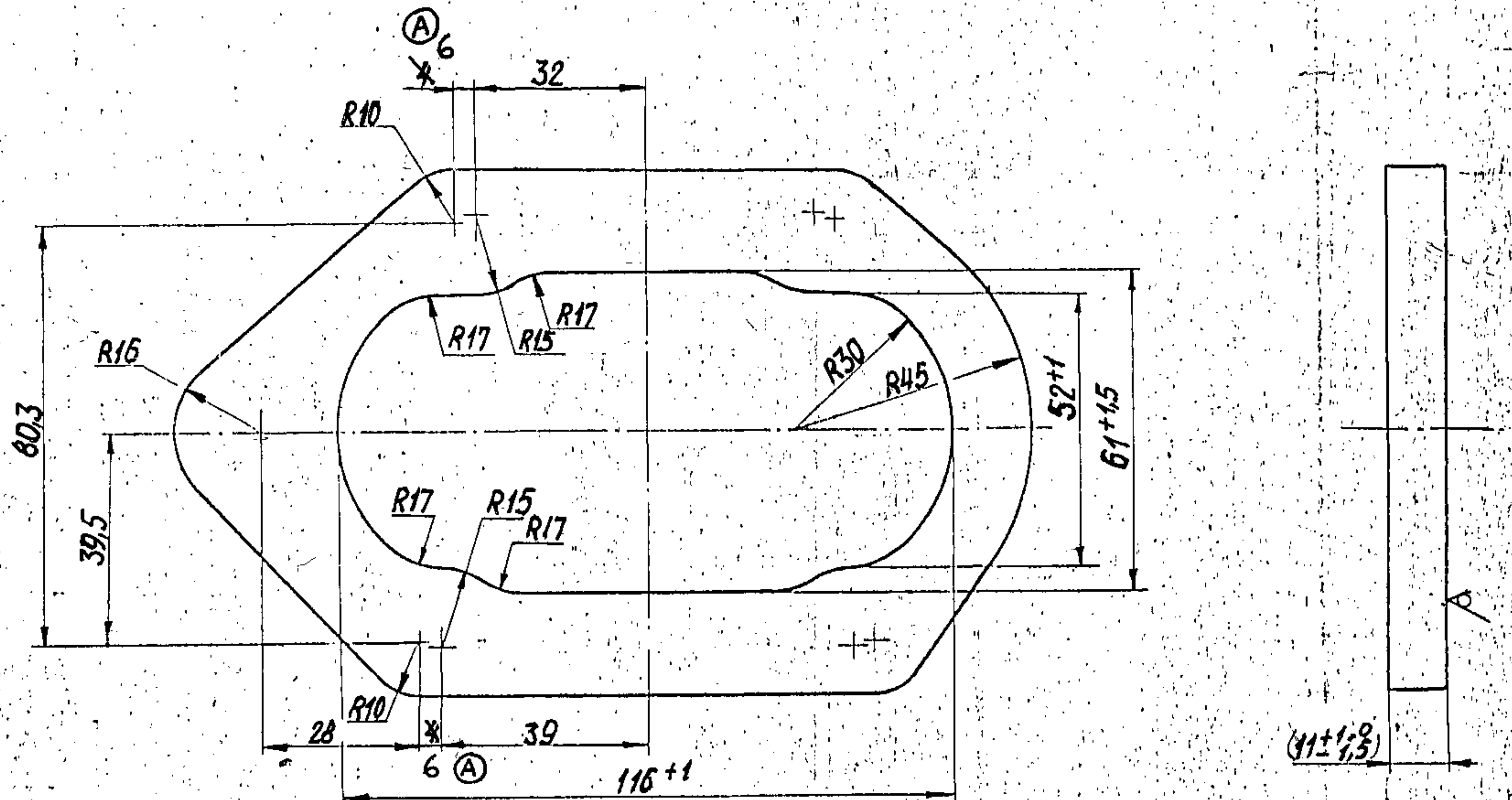
D S CAT NUMBER

DRAWING NUMBER
3318-07-4

A2

ЕСКД

DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE 7 (BK 81-31)
EXPLANATORY NOTE ADDED ON 19-2-92



TECHNICAL REQUIREMENTS IN RUSSIAN

1. Неуказанные предельные отклонения размеров ± 0,5 мм
2. Размер в скобках – после сборки.
3. Заменитель материала сталь 15,20 и 25 ГОСТ 1050-
4. Штамповочный скос 1,2 мм на сторону.

TECHNICAL REQUIREMENTS - TRANSLATED

1. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ±0,5mm,
2. DIMENSIONS GIVEN IN BRACKETS ARE TO BE ENSURED AFTER ASSEMBLY.
3. ALTERNATIVE MATERIAL STEEL 15, 20, AND 25 GOST 1050-74.
4. DRAFT 1.2mm PER SIDE.

EXPLANATORY NOTE:-

MATERIAL QUOTED:- SHEET 12 GOST 19903-74 / 10 GOST 1577-81.

12 = THICKNESS OF THE SHEET
10 = GRADE OF OPENHEARTH STEEL AS PER GOST 1577-81.

CHEMICAL COMPOSITION % (AS PER GOST 1050-74.)

C = 0·07 – 0·14, Si = 0·17 – 0·37, Mn = 0·35 – 0·65.

Cr = 0·15
S = 0·040
P = 0·035
Cu = 0·25
Ni = 0·25
(MAX)

MECHANICAL PROPERTIES AS PER GOST 1577-81.

ULTIMATE TENSILE STRENGTH kgf/mm²	(MIN) =	34
% ELONGATION	(MIN) =	32
IMPACT STRENGTH kgcm/cm²	(MIN) =	3

Ⓑ EQUIVALENT MATERIAL
040 A 04 (EN 2A) BS:970

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

EST. MASS 0.6 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
B	1-7-10	4th ALT. COMM. Mtg. MINUTES POINT No 2 DT. 26-10-09
A	24.8.2K	NOTN. No. BK 86-455

DRN	
CHD	
TCD	V. MANIVANNAN
APPD	
DATE	29.1.88
SCALE - 1:1	
DIMENSIONS IN mm	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	
ALL THREADS CONFORM TO	

MATERIAL :- SHEET 12 GOST 19903-74 / 10 GOST 1577-81.

USED ON :- Cb 418-50-29, Cb 418-51-29

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI

TITLE :- **FLANGE**

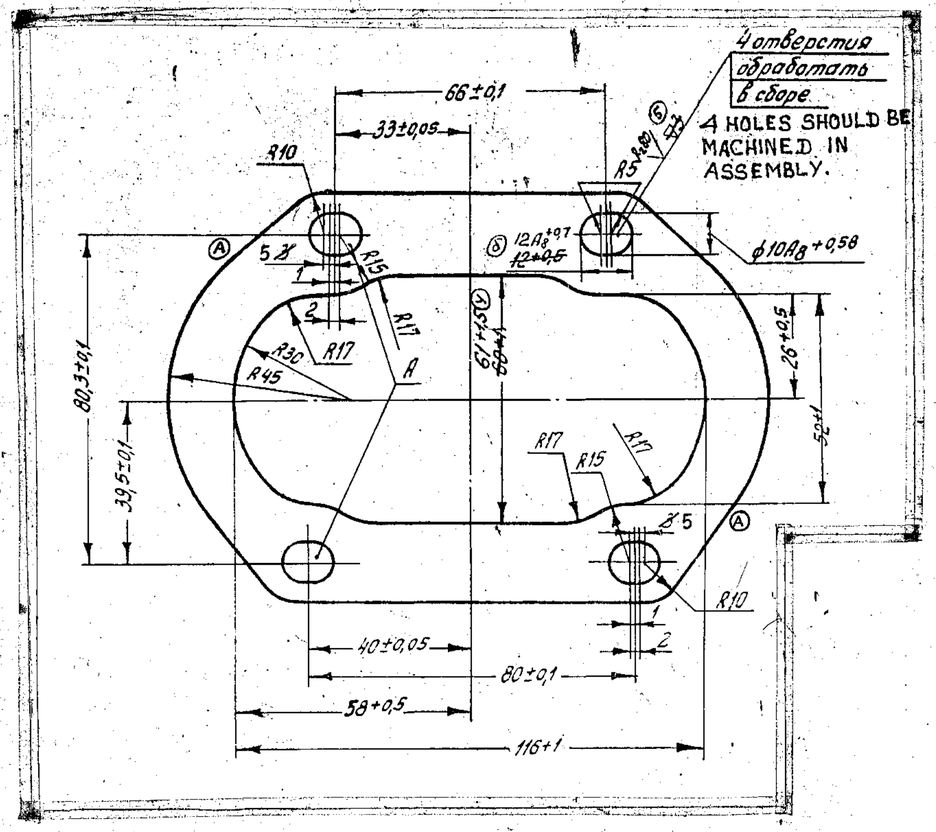
D S CAT NUMBER

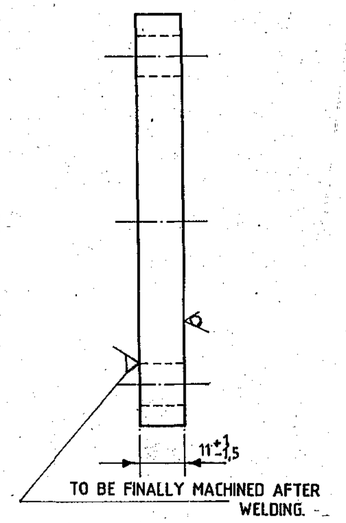
DRAWING NUMBER 3318-08-7

7		BK 81-31		
Изм	Лист	N докум.	Подп.	Дата

DRAWING NUMBER
3318-08-8

Rz320
V(V)





EXPLANATORY NOTE

6. REFERENCE MATERIAL QUOTED: HOT ROLLED STEEL SHEET OF NORMAL ACCURACY ON ROLLING (6) 12mm THICKNESS TO GOST 19903-74 OF STEEL Gde 10 OF GOST 1577-81 MANUFACTURED IN ACCORDANCE WITH NORMALISED CARBON STRUCTURAL STEEL Gde 10 AND REFERANCE NOTE 5 ON ALTERNATIVE MATERIALS MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL Gdes. 15,20 & 25 TO GOST 1050-74.

a) CHEMICAL COMPOSITION AS PER GOST 1050-74.

GRADE OF STEEL	CONTENT OF ELEMENTS %						REMARKS
	C	Si	Mn	Cr	S	P	
				MAXIMUM			
10	0.07 - 0.14	0.17 - 0.37	0.35 - 0.65	0.15	0.040	0.035	Ref. MATL
15	0.12 - 0.19	0.17 - 0.37	0.35 - 0.65	0.25	0.040	0.035	ALT. MATL
20	0.17 - 0.24	0.17 - 0.37	0.35 - 0.65	0.25	0.040	0.035	ALT. MATL
25	0.22 - 0.30	0.17 - 0.37	0.50 - 0.80	0.25	0.040	0.035	ALT. MATL

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

b) MECHANICAL PROPERTIES OF NORMALISED HOT ROLLED SHEET AS PER GOST 1577-81.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm²	ELONGATION %	IMPACT STRENGTH Kgfm/cm²	HARDNESS B.H.N.	REMARKS
	MINIMUM			MAX.	
10	34	32	3	-	Ref Matl.
15	38	30	3	-	Alt. Matl.
20	40	28	3	-	Alt. Matl.
25	45	25	-	170	Alt. Matl.

1. DIMENSIONS WITH UNSPECIFIED TOLERANCES FOR COLD STAMPING SHOULD BE OBTAINED WITH TOLERANCE ±0.5mm.
2. SHARP EDGES SHOULD BE BLUNTED.
3. STAMPING BEVEL UPTO 1.2mm PER SIDE IS ALLOWED.
4. NOTE: HOLES A FOR 3rd AND 4th FLANGES OF EVERY MANIFOLD SHOULD BE OBTAINED WITH DIA. 10A8+0.7 AS PER ASSEMBLY DRAWINGS OF MANIFOLDS.
5. ALTERNATE MATERIALS: STEEL GRADES 15,20 AND 25,GOST 1050-74

Ⓑ EQUIVALENT MATERIAL
040 A 04 (EN 2A) BS:970

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

EST WT	TO BE STAMPED OR MARKED WHERE INDICATED THUS #
0,55 Kg	(LETTERS)

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

ISSUE	DATE	NATURE OF AMENDMENTS
B	1-7-10	4-th ALT.COMM.Mtg.MINUTES POINT No.2. DT. 26-10-09
A	24.8.2K	NOTN.No. BK 86-455

DRN	
CHD	
TCD	Naravane Purdy
APPD	
DATE	19-2-86
SCALE: 1 : 1	
DIMENSIONS IN mm	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69	
ALL THREADS TO CONFORM TO	

MATERIAL :
SHEET B 12 GOST 19903-74
10 GOST 1577-81

USED ON
CB 418-50-29
CB 418-51-29

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)
AVADI

TITLE: FLANGE, EXHAUST MANIFOLD

D S CAT NUMBER

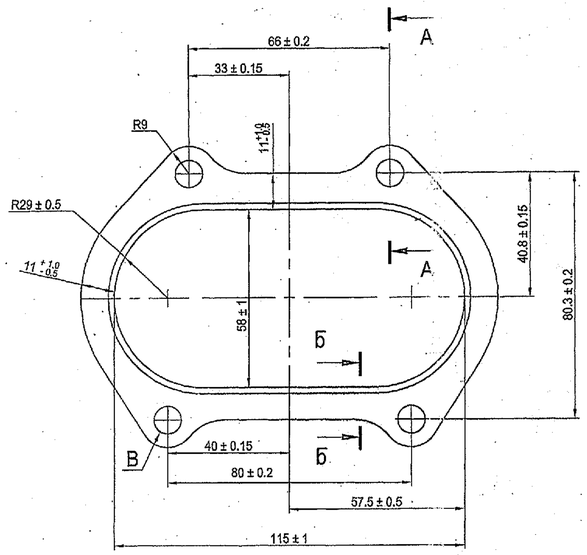
DRAWING NUMBER
3318-08-8

A6

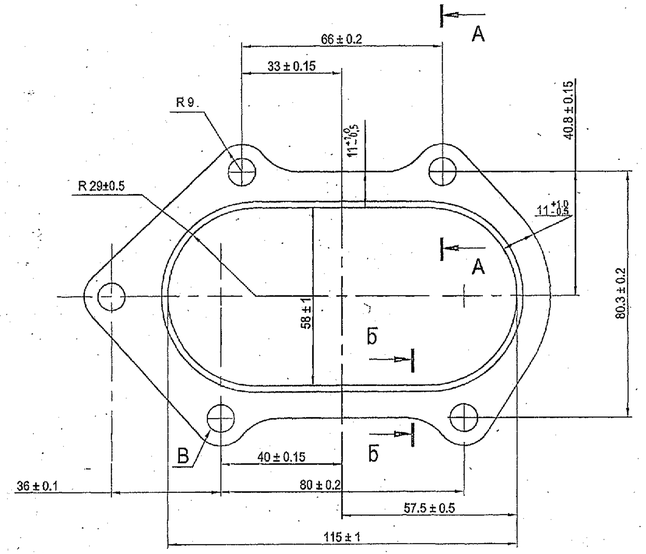
SIZE A2

DRAWING NUMBER
CQA(HV)/507500 E

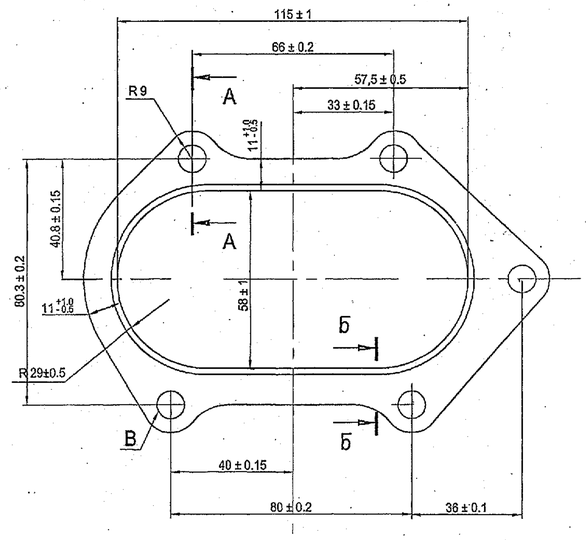
Ⓐ ITEM No. 3
Cb 3306 - 15



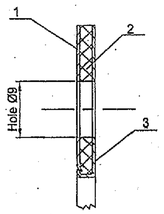
Ⓐ ITEM No. 4
Cb 3306 - 15 - 2



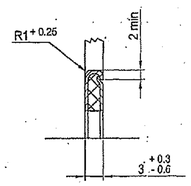
Ⓐ ITEM No. 5
Cb 3306 - 15 - 3



A - A
SCALE 2:1



Б - Б
SCALE 2:1



1. Ruptures, cracks, burrs, bucklings and bulgings are not permissible on the external surfaces of gaskets and at the flared places.
2. Asbestos sheet should be on one level with the edges of copper cover plate or project beyond them by 0.5 mm, max, its edges should not be torn.
3. Flared edges of the copper sheet should be in one plane with the side surfaces of the gasket. The projection not exceeding the thickness of the sheet is permissible.
4. Gaskets should be selected as a set of 6 pcs. namely;
   - Cb 3306 - 15 : 4 pc
   - Cb 3306 - 15 - 2 : 1 pc
   - Cb 3306 - 15 - 3 : 1 pc
5. Difference in thickness of gaskets in a set should not exceed 0.2 mm.
6. Cover plate 3 may be flared up along the outer profile of the gasket to the contact with cover plate 1 and in holes B to height upto 1 mm.

Ⓐ ITEM No	~~Sl. No.~~	DRAWING NUMBER	WEIGHT
3	1	Cb 3306 - 15 Cb	0.030 Kg
4	2	Cb 3306 - 15 - 2 Cb	0.036 Kg
5	3	Cb 3306 - 15 - 3 Cb	0.036 Kg

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

EST. WT. SEE TABLE

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.

ISSUE	DATE	NATURE OF AMENDMENTS
A	2.9.11	6th ALT. Comm. Meeting Minutes Point No. 2 Dt. 26.8.11

DRN
CHD
TCD —
APPD
DATE 10.12.07
SCALE: 1:1
DIMENSIONS IN mm
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102 - 69
ALL THREADS TO CONFORM TO

MATERIAL :- ——
USED ON :- Cb 418-00-6
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI
TITLE : EXHAUST MANIFOLD GASKET
D S CAT NUMBER
DRAWING NUMBER CQA(HV)/507500 E

DRG CREATED BASED ON CQA(HV) Lt. No. 81240 / CQA(HV) / DB / ENG dt 12 Dec 2007

SIZE A1

USED ON	ZONE	ITEM NO	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	QTY	REMARKS
			CQA(HV)/507500E		EXHAUST MANIFOLD		
			& ITEM LIST		GASKET		
			СБ 3306 -15		EXHAUST MANIFOLD		
					GASKET		
		1	3306 – 99		UPPER COVER PLATE	1	
		2	3306 – 100		GASKET	1	
		3	3306 – 101		LOWER COVER PLATE	1	
			СБ 3306 -15 - 2		EXHAUST MANIFOLD		
					GASKET		
		1	3306 – 99 - 2		UPPER COVER PLATE	1	
		2	3306 – 100 - 2		GASKET	1	
		3	3306 – 101 - 2		LOWER COVER PLATE	1	
			СБ 3306 -15 - 3		EXHAUST MANIFOLD		
					GASKET		
		1	3306 – 99 - 2		UPPER COVER PLATE	1	
		2	3306 – 100 - 2		GASKET	1	
		3	3306 – 101 - 3		LOWER COVER PLATE	1	

Сб 418-00-6

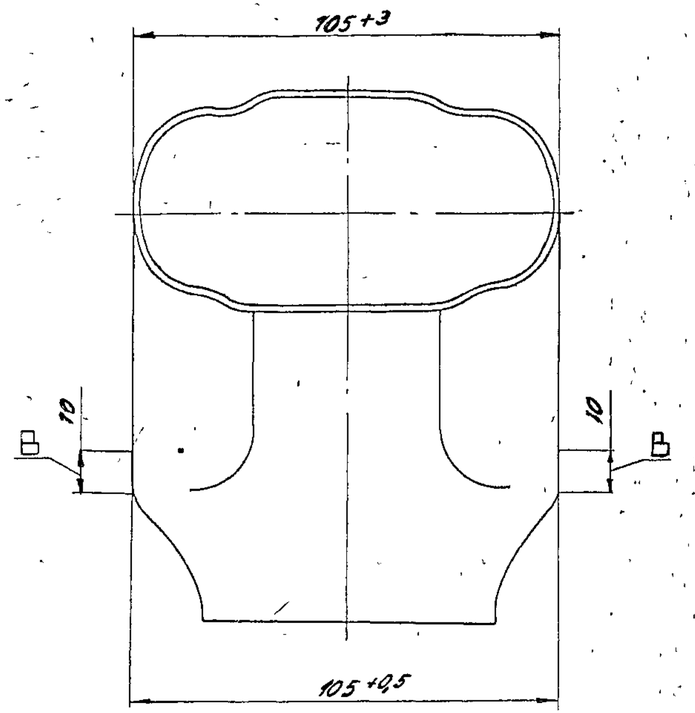
I/L CREATED BASED ON CQA(HV) LL,No. 81240/CQA(HV)/DB/ENG dt. 12 Dec 2007

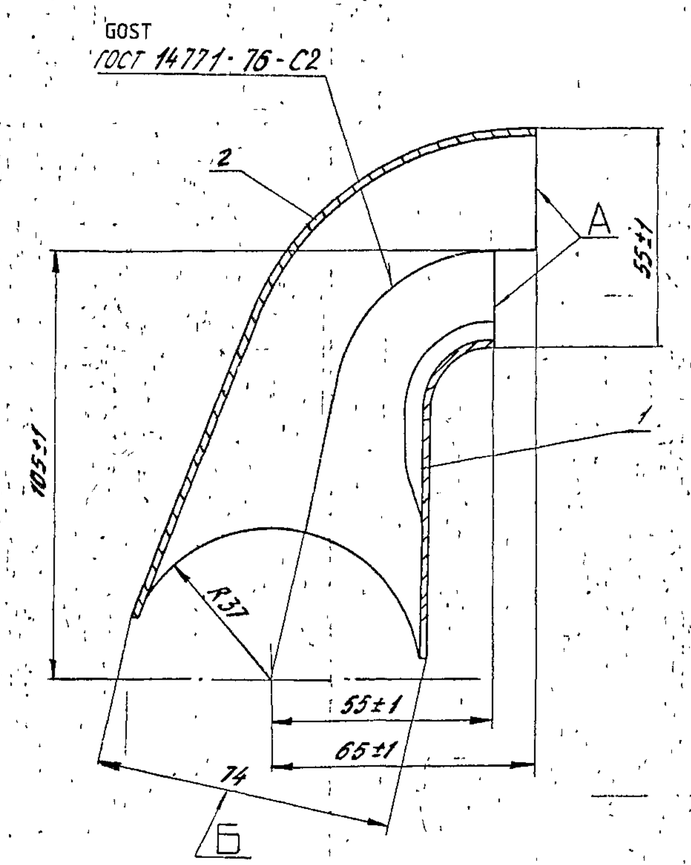
ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS

DRN		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.		
CHD		TITLE: EXHAUST MANIFOLD GASKET		
APPD				
DATE	10.12.07	SHT. NO. 1 OF 1	D S CAT NUMBER	ITEM LIST FOR CQA(HV) / 507500E

сб 318 - 22-5сб

ЕСКД





TECHNICAL REQUIREMENTS IN RUSSIAN

1. Контур А и размер Б подогнать по сопрягаемой детали перед приваркой в узле.
2. Сварные швы на участках В зачистить заподлицо.

TECHNICAL REQUIREMENTS - TRANSLATED

1 CONTOUR 'A' AND DIMENSION 'Б' SHOULD BE ADJUSTED TO SUIT MATING COMPONENT BEFORE WELDED TO ASSEMBLY.

2 WELDS ON SECTION 'B' SHOULD BE DRESSED FLASH

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

ISSUE	DATE	NATURE OF AMENDMENTS
2		ВК 81-31

DRN
CHD
TCD KUMAR
APPD
DATE 29 1 88

EST MASS 0.37

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

SCALE- 1 : 1

DIMENSIONS IN mm

TOLERANCE ON DIMNS UNLESS OTHERWISE STATED

ALL THREADS CONFORM TO

MATERIAL -

USED ON -
Сб 418- 50- 29
Сб 418- 51-29

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI

TITLE - BRANCH PIPE SCREEN

D S CAT NUMBER

DRAWING NUMBER
сб 318- 22- 5Сб

USED ON

Cb 418- 50- 29 Cb
Cb 418- 51- 29 Cb

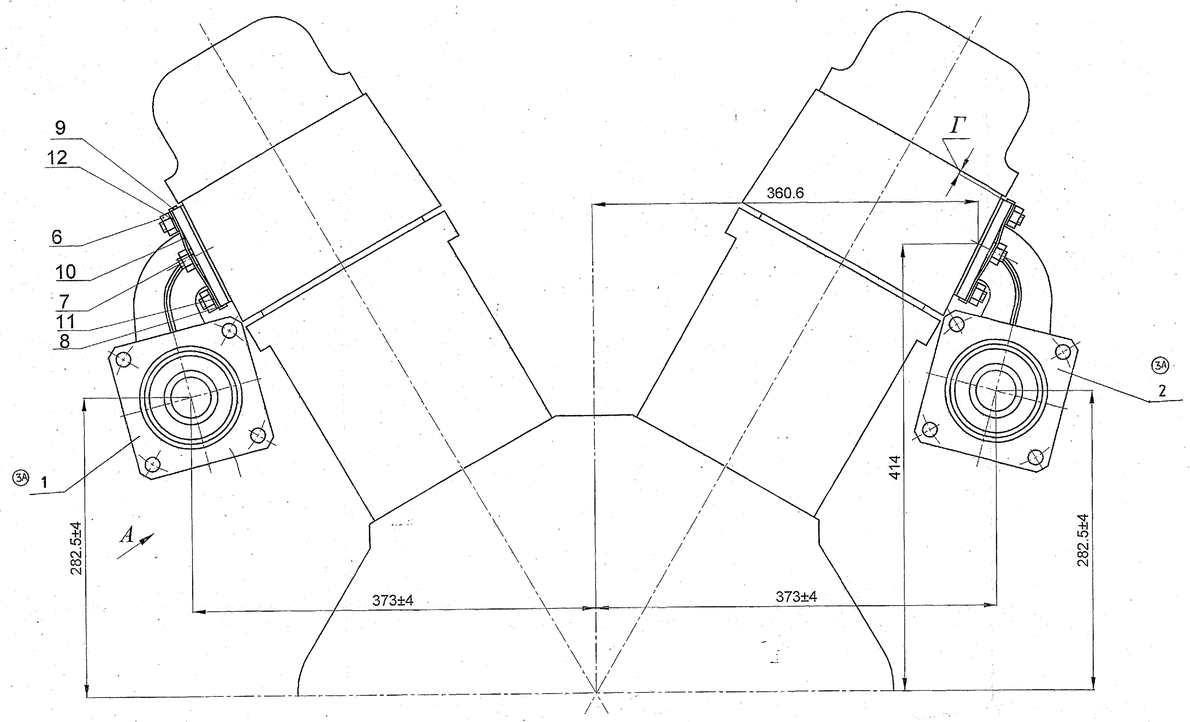
	Cb 318 22 5Cb		ASSY. BRANCH PIPE SCREEN		
	& ITEM LIST				
1	318-20-5		LOWER PART OF SCREEN	1	
2	318-21-5		UPPER PART OF SCREEN	1	

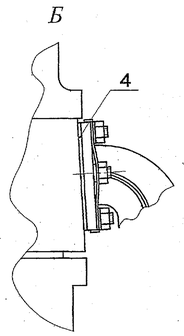
ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS

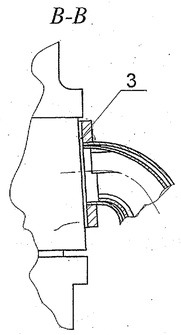
DRN		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD		TITLE:- ASSY. BRANCH PIPE SCREEN	
TCD			
APPD		SHEET 1 OF 1	D S CAT NUMBER
DATE	29.1.88		ITEM LIST FOR Cb 318 22 5Cb

I/L SEPERATELY CREATED BASED ON RUSSIAN ORIGINAL ISSUE 1 (BK 81-31)

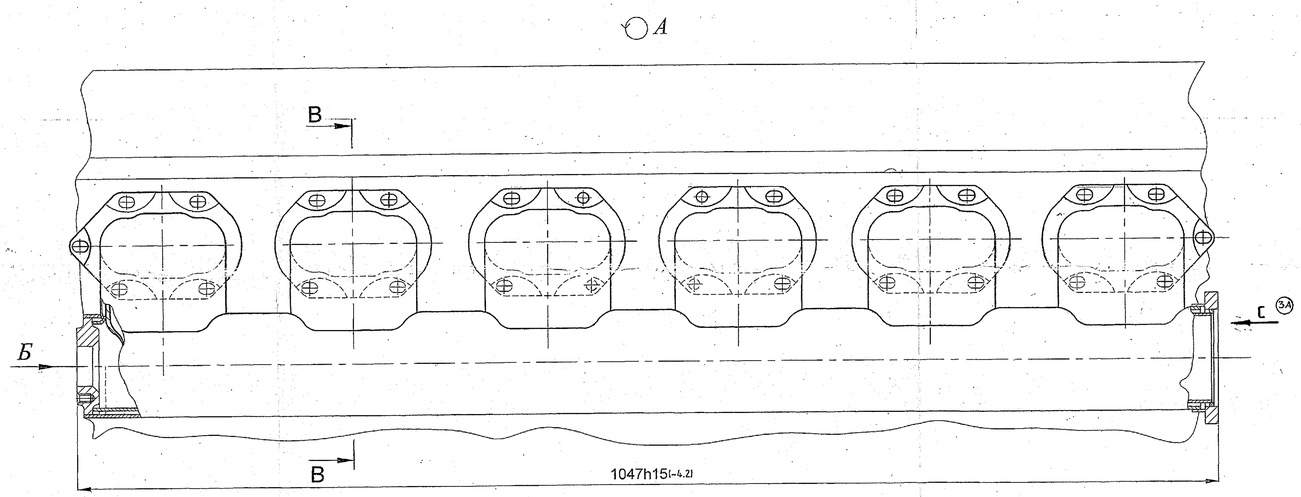
DRAWING NUMBER
Cb.418-00-6

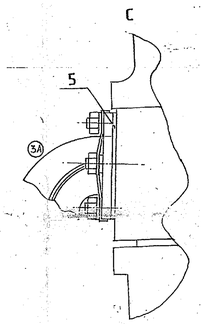






1. Check the presence of clearance " *Г*". *Fouling of exhaust manifold flange with the head cover is not allowed.*
2. *All the dimensions are given for reference and not for assembly inspection.*
3. *Main view is from transmission side.*





DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 3
DRG. REPLACES Sb 418-00-6 ISSUE-NIL, VIDE NOTIFICATION NO: 91-531

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.

ISSUE	DATE	NATURE OF AMENDMENTS
3A	2.9.11	CQA(HV)I.I. No. 81240 / CQA(HV) / DB, ENG dt. 12 Dec. 2007

DRN — MATERIAL :- ----
CHD — USED ON :- Sb 3300-00-27 CX
TCD —
APPD —
DATE 04-01-08 — CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI
SCALE- 1:2
DIMENSIONS IN mm
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69.
ALL THREADS TO CONFORM TO
D S CAT NUMBER

TITLE :- **EXHAUST MANIFOLD ASSY.**

DRAWING NUMBER **Cb.418-00-6**

I-153
38
74

SIZE A0

USED ON	ZONE	ITEM NO	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	QTY	REMARKS
			Cb.418-00-6		**EXHAUST**		
			ITEM LIST		**MANIFOLD ASSY.**		
		1	Cb.418-50-29		EXHAUST MANIFOLD	1	
					L.H		
		2	Cb.418-51-29		EXHAUST MANIFOLD	1	
					R.H		
Sb 3300-00-27 CX	(A)	~~3~~	~~Cb.3306-15~~		~~GASKET~~	~~8~~	
	(A)	~~4~~	~~Cb.3306-15-2~~		~~GASKET~~	~~2~~	
	(A)	~~5~~	~~Cb.3306-15-3~~		~~GASKET~~	~~2~~	
		6	351-025		NUT M8	52	
		7	353-03-3		BRIGHT WASHER 8	4	
		8	353-68		LOCK WASHER 9	8	
		9	353-69-5		WASHER	8	
		10	353-104		WASHER	4	
		11	353-105		WASHER	4	
		12	353-106		WASHER	4	
I/L CREATED BASED ON RUSSIAN ORIGINAL ISSUE – NIL VIDE NOTIFICATION NO: 91-531		3	CQA(HV) 507 500 E		EXHAUST MANIFOLD GASKET	2 SET	SUPPLIED AS SET ONLY
	(A)	4					
		5					

ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS
A	2.9.11	CQA(HV) Lt. No. 81240 / CQA(HV) / DB / ENG dt. 12 Dec 2007			

DRN		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.	
CHD		TITLE: **EXHAUST MANIFOLD ASSY.**	
APPD			
DATE	04.01.08	SHT. NO. 1 OF 1	D S CAT NUMBER
			ITEM LIST FOR **Cb.418-00-6**

F-153
37/74

Format Формат	Zone Зона	Item Поз.	Code Обозначение	Name Наименование	Qty. Кол.	Remark Приме-чание
				Documents		
				Документация		
				Assembly drawing		
*1			сб.418-50-29СБ	Сборочный чертеж		*1А2х3
				Assembly units		
				Сборочные единицы		
				Screen of branch pipe		
А4		1	сб.318-22-5	Экран патрубка	6	
				Parts Детали		
А2		2	3318-06-1	Часть патрубка нижняя Lower part of branch pipe	6 pcs is permitted to replace by item 3	6 шт. допускается замена на поз.3
А2		3	3318-06-4	Часть патрубка нижняя Lower part of branch pipe	6 pcs is permitted to replace by item 2	6 шт. допускается замена на поз.2
А2		4	3318-07-1	Часть патрубка верхняя Upper part of branch pipe	6 pcs is permitted to replace by item 5	6 шт. допускается замена на поз.5
А2		5	3318-07-4	Часть патрубка верхняя Upper part of branch pipe	6 pcs is permitted to replace by item 4	6 шт. допускается замена на поз. 4

Подп. и дата | Взам. инв. № | Инв. № дубл. | Подп. и дата | Инв. № подл. 45079

Am

Изм.	Лист	№ докум.	Подп.	Дата
	2 Shee	Doc. No. 85-793	Sign.	Date

Trans. & Ckd. by : M/s SWYAZ
Authenticatac by :
Approved by :
Engine Factory, Avadi

f-153 89/94

сб.418-50-29

Letter | Sheet | Sheets
Лит. | Лист 1 | Листов 2

LEFT EXHAUST MANIFOLD.
Коллектор выпускной левый

Формат А4