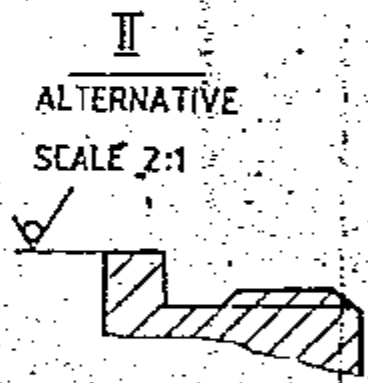
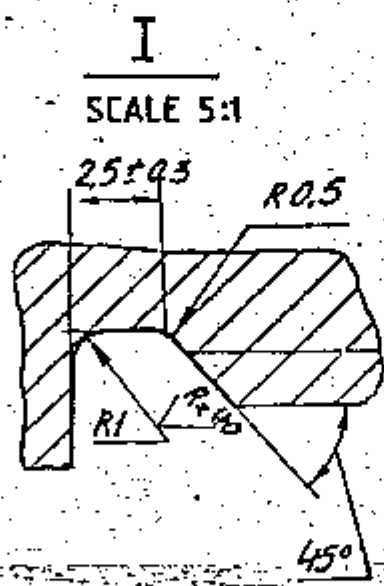
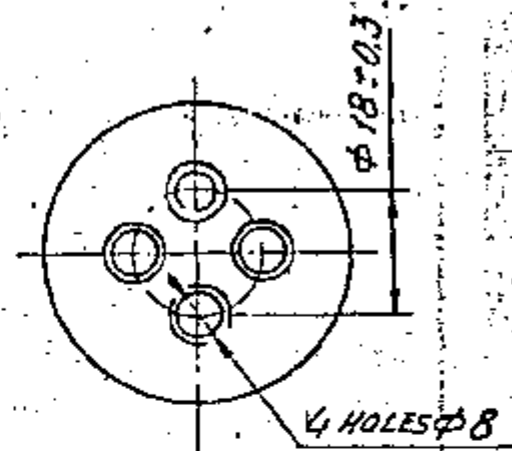
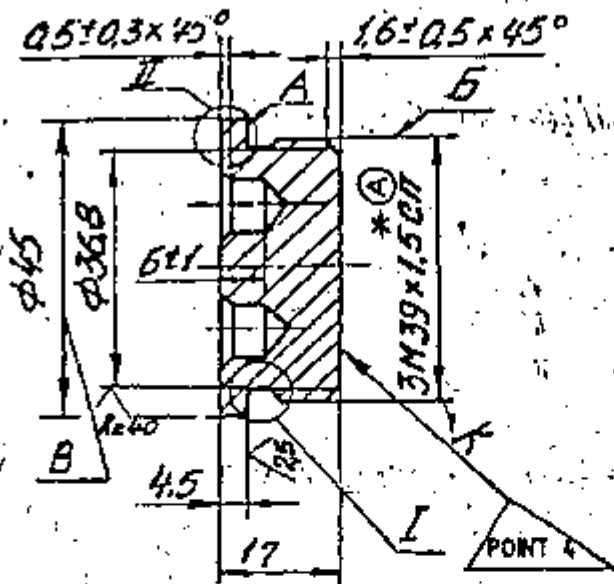


DRAWING NUMBER

303-13-4



1. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS: FOR HOLES AS PER A7, FOR SHAFTS AS PER B7. Rz80 (✓)
2. TECHNICAL REQUIREMENTS FOR THREAD - AS PER STANDARD 82021-00.
3. END PLAY OF SURFACE 'A' RELATIVE TO SURFACE 'B' ALONG ϕB SHOULD NOT EXCEED 0.1mm.
4. TO BE MARKED BY PUNCHING.
5. DIAMETER 'B' MAY BE OBTAINED WITH TOLERANCE h 16 (-1,6), ON THE SURFACE OF DIAMETER 'B' ROUGH SPOTS ARE PERMISSIBLE.

6. EXPLANATORY NOTE:

MATERIAL QUOTED: БАРЕПАЖ 9-4 GOST 1628-78
 БАЖ 9-4 = GRADE OF MATERIAL
 CHEMICAL COMPOSITION% (AS PER GOST 18175-78)
 BASIC COMPONENT
 ALUMINIUM = 8.0-10.0; IRON = 2.0-4.0; COPPER = REST
 IMPURITIES (MAX)
 TIN = 0.1; SI = 0.1; Pb = 0.01; P = 0.01;
 Zn = 1.0; Mn = 0.5; TOTAL IMPURITIES = 1.7
 MECHANICAL PROPERTIES (AS PER GOST 1628-78)
 ULTIMATE TENSILE STRENGTH $Kgf/mm^2 = 55$ (min)
 RELATIVE ELONGATION% = 15 (min)
 BRINELL HARDNESS (HB) = 110-180

Ⓐ 7. * REPAIR SIZE DIMENSION, R1=3M42X1.5 ADDED BASED ON LETTER No. 82847/0H/QAD/ED DT-26 DEC 94.

KVO NO. 78974

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

EST. WT. 0.17 kg. TO BE STAMPED OR MARKED WHERE INDICATED THUS #1 LETTERS)

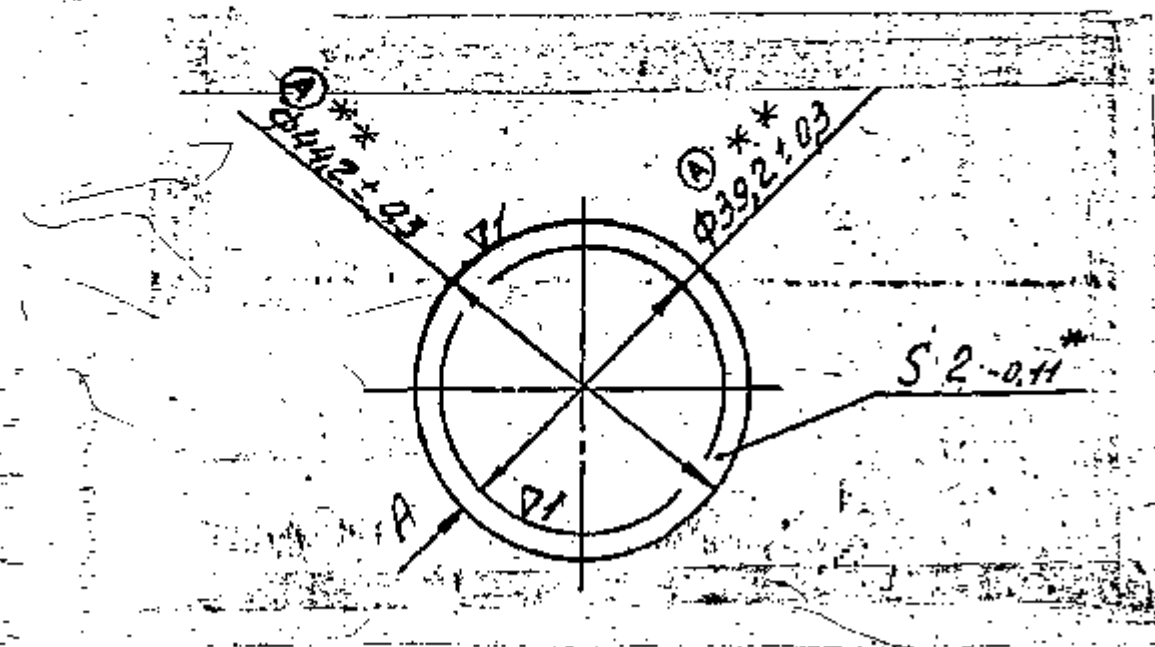
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	TCB	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69.	ALL THREADS TO CONFORM TO IS: 2210 Pt IV
				20-8-96	1:1			
MATERIAL: BAR				USED ON		D S CAT NUMBER		
BP A * 9-4				CE 303-02-7		DRAWING NUMBER		
GOST 1628-78				CE 303-03-7		303-13-4		
CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES)				AVADL				
TITLE				PLUG				
ISSUE				DATE				
A				20-1-99 REPAIR SIZES ADDED				
NATURE OF AMENDMENTS								

DRAWING NUMBER

303-40

20(7)



1. MATERIAL-STRIP АПРММ 2.0H M3 GOST 1173-77
2. VARIATION THICKNESS ON DIMENSION A SHOULD NOT EXCEED 0.3 mm.
3. TO BE ANNEALED
4. * DIMENSION FOR REFERENCE.

Ⓐ 6. ** FOR REPAIR SIZE R₁ DIMENSIONS FOR $\phi/D = 47.2 \pm 0.3$ } ADDED
 $\phi/D = 42.2 \pm 0.3$ }

BASED ON LETTER NO. 82847/0H/QAD/ED, DT. 26. DEC. 94.

EXPLANATORY NOTE:-

MATERIAL QUOTED:

STRIP АПРММ 2.0 H А M3 GOST 1173-77

A ≡ COLD ROLLED; TP = RECTANGULAR SECTION;

H = NORMAL ACCURACY; M=SOFT; 2.0 = THICKNESS;

M3= COPPER GRADE AS PER GOST 859-78.

CHEMICAL COMPOSITION: % (AS PER GOST 859-78)

BASIC CONSTITUENT Cu+Ag (MIN) = 99.5

IMPURITIES

Bi = 0.003 ; Fe = 0.05 ; Ni = 0.2 ; Pb = 0.05 ;

Sn = 0.05 ; S = 0.01 ; O₂ = 0.05 ;

ANTIMONY = 0.05 ; ARSENIC = 0.01

MECHANICAL PROPERTIES: (AS PER GOST 1173-77)

TENSILE STRENGTH kgf/mm² (MIN) = 20

% ELONGATION (MIN) = 30

EXPLANATORY NOTE ADDED ON 4-9-91

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

EST. WT.
0.005 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 R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN

CHD

TCD

APPD

DATE

SCALE:- 1:1

DIMENSIONS IN mm

TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69.

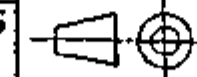
ALL THREADS TO CONFORM TO

MATERIAL:-

SEE NOTE No. 1.

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.

TITLE



D S CAT NUMBER

USED ON

C6 303-03-7 II

RING

DRAWING NUMBER

303-40

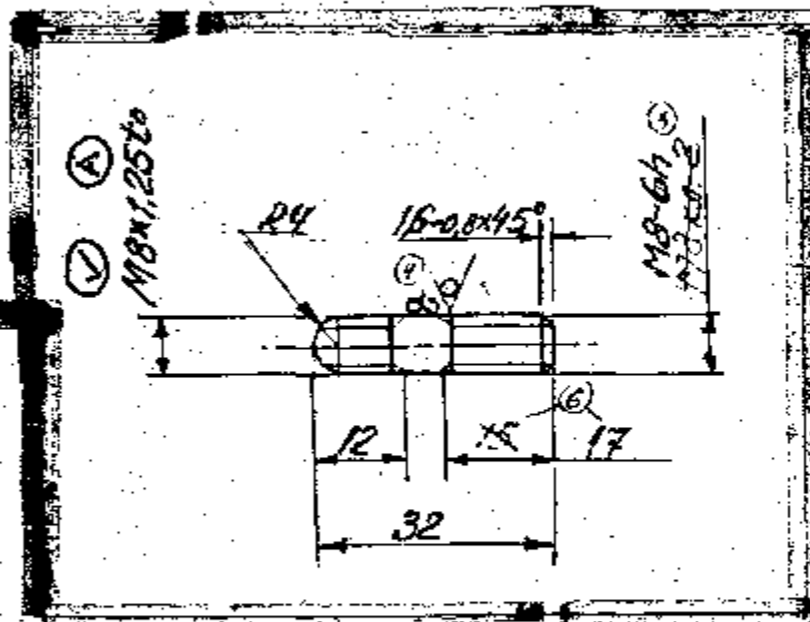
ISSUE	DATE	NATURE OF AMENDMENTS
A	20-1-95	REPAIR SIZES ADDED

SIZE A3

DRAWING NUMBER
350 123

EXPLANATORY NOTE

Rz80



1. TECHNICAL REQUIREMENTS FOR THREADS AS PER STANDARD 02021-00.
2. DIMENSIONS WITH UNSPECIFIED TOLERANCES AND THE REST OF THE TECHNICAL REQUIREMENTS AS PER STANDARD 02052-00.
3. COATING: CADMIUM 3, CHROMATIZING AS PER 42.1-104 WITH SUBSEQUENT ELIMINATION OF HYDROGEN EMBRITTLEMENT.
4. THE THREAD MAY BE MADE BY ROLLING WITH THE DIAMETER OF UN-THREADED PORTION WITHIN THE PITCH DIAMETER OF THREAD.
5. ALTERNATE MATERIAL: STEEL 40, 50, GOST 1050-74.
7. REPAIR SIZE DIMENSIONS ARE ADDED WHERE INDICATED THUS (A), BASED ON OVERHAUL SPECIFICATIONS PART III REPAIR DRAWINGS. **
- (B) 8. HARDNESS - 27-32 HRC.

REFERENCE MATERIAL QUOTED:

COLD DRAWN SIZED STEEL ROUND BAR ϕ 8mm TO GOST 7417-75 STEEL OF GRADE 45 TO 1051-73 AND MANUFACTURED IN ACCORDANCE WITH QUALITY CARBON STRUCTURAL STEEL GRADE 45 AND REFERENCE NOTE 5, OR ALTERNATE MATERIAL STEEL GRADES 40 & 50 TO GOST 1050-74.

a) CHEMICAL COMPOSITION AS PER GRADES 45, 40 & 50 TO GOST 1050-74.

GRADE OF STEEL	CONTENT OF ELEMENTS %						REMARKS
	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	Ref,Matl
40	0.37-0.45	0.17-0.37	0.50-0.80	0.25	0.040	0.035	Alt,Matl
50	0.47-0.55	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 UNDER NORMALISED CONDITION:

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 MAX	RE-MAR-KS
45	61	36	16	40	5	229	Ref,Matl
40	58	34	19	45	6	217	Alt,Matl
50	64	38	14	40	6	241	Alt,Matl

(B) * MATERIAL:-

STEEL 709 M40 (EN-10275) TO BS-970 Pt.-1-1983.

SL. NO.	REMARKS
1	M10 X 1.5 to
2	PCD 9.026 + 0.152 + 0.082

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

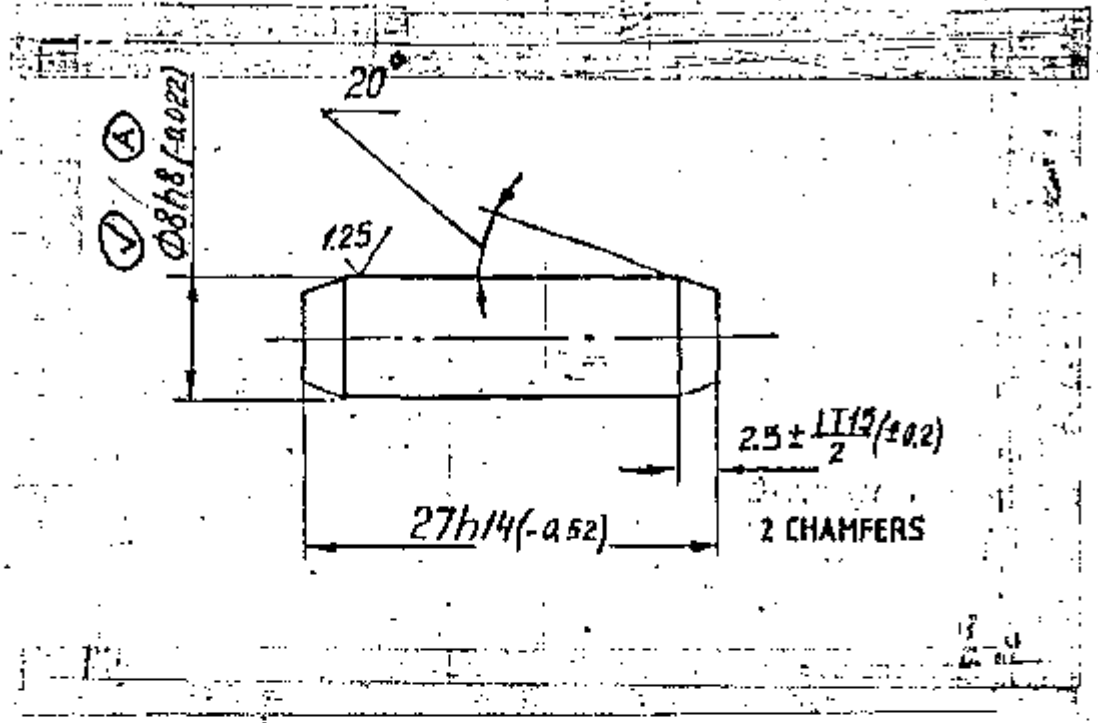
DRN	CHD	TCD	APPD	DATE	SCALE: 1:1	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69	ALL THREADS TO CONFORM TO
20-5-09	13-01-08	10-11-95					
Authy: Third Alt. Comm. Minutes Point 5 Dated 27-02-2009.				Authy-MIN. OF ALT. COM. MEET. POINT-NO.-2.12 Dt.- 07-02-07			
REPAIR SIZE DIMNS ADDED							
ISSUE	DATE	NATURE OF AMENDMENTS		D'S CAT NUMBER		DRAWING NUMBER	
						350 123	

MATERIAL: ROUND BAR - GOST 7417-75 45 GOST 1051-73
USED ON: 331-20-10
331-20-6
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI

TITLE: STUD M8x32

DRAWING NUMBER
352-18-1

READ ✓ (✓)



EXPLANATORY NOTE

MATERIAL QUOTED:-ROUND GOST 7417-75
45GOST 1051-74

45 = GRADE OF STEEL

CHEMICAL COMPOSITION % (AS PER GOST 1050-74)

- CARBON = 0.42-0.50
 - SILICON = 0.17-0.37
 - MANGANESE = 0.50-0.80
 - CHROMIUM = 0.25
 - PHOSPHORUS = 0.035
 - SULPHUR = 0.040
 - COPPER = 0.25
 - NICKEL = 0.25
- } MAXIMUM

MECHANICAL PROPERTIES (AS PER GOST/1050-74)

- TENSILE STRENGTH kgf/mm^2 (min) = 61
- YIELD POINT kgf/mm^2 (min) = 36
- RELATIVE ELONGATION % (min) = 16
- REDUCTION IN AREA % (min) = 40
- IMPACT STRENGTH kgf/cm^2 (min) = 5

1. ALTERNATE MATERIAL: STEEL OF GRADES 40 AND 50, GOST 1050-74
 2. COATING: CHEMICAL OXIDATION AND OIL-FINISHING.
 3. REPAIR SIZE DIMENSIONS ARE ADDED WHERE INDICATED
- (A) THUS (✓) BASED ON OVERHAUL SPECIFICATION PART III REPAIR DRAWINGS. **

S.No	R ₁	R ₂	REMARKS
1	∅ 8.5 - 0.022	∅ 9 - 0.022	ALL OTHER CONDITIONS AS PER STD DRG.

(B) EQUIVALENT MATERIAL
STEEL 080 M40 (EN8) TO BS 970 OR
45 CB TO IS 1570

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

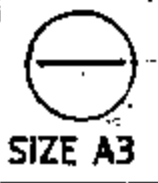
EST. WT. TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)

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	CHD	TCD	APPO	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69.	MATERIAL- ROUND GOST 7417-75 45GOST 1051-74	USED ON CB 303-03-II
				30-09-88	2:1			CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.	
								TITLE PIN 8 x 27	
								D S CAT NUMBER	
								DRAWING NUMBER 352-18-1	
ISSUE	DATE	NATURE OF AMENDMENTS							
B	10-7-10	4th ALT. COMM. MTD. MINUTES POINT No 7 DT. 26-10-09			ALL THREADS TO CONFORM TO				
A	11.1.96	REPAIR SIZE DIMNS ADDED							

EXPLANATORY NOTE ADDED ON 18-9-91

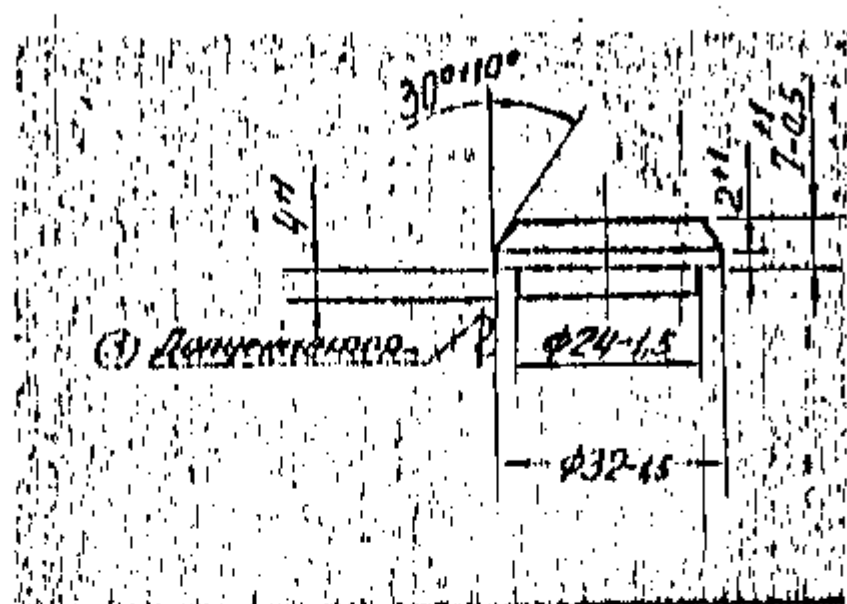
Issue 1 - BK 83-683



SIZE A3

DRAWING NUMBER
402-84

Rx80



ALTERNATE MATERIAL : ДАК Д1Т КР 32А, ГОСТ 21408,
UNMACHINED OVER EXTERNAL DIAMETER.

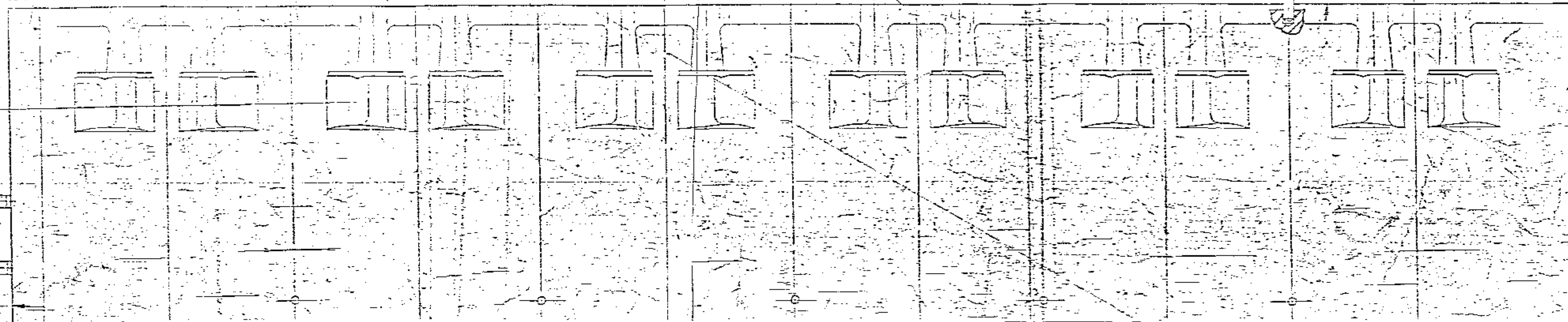
A3
34

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

		EST. WT. 0.016 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.	
		MATERIAL:- ДЛ 9 ГОСТ 2605-75 CASTING.	USED ON СБ 303-03-7 СБ 3301-15-30 СБ 303-02-7
ISSUE DATE	NATURE OF AMENDMENTS	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) АВАДИ.	
DRN	SCALE:- 1:1 DIMENSIONS IN mm	TITLE END CAP	
CHD	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS 2102-69	D S CAT NUMBER	
TCO	ALL THREADS CONFORM TO	DRAWING NUMBER 402-84	
APPO			
DATE 24-3-83			

SIZE A4

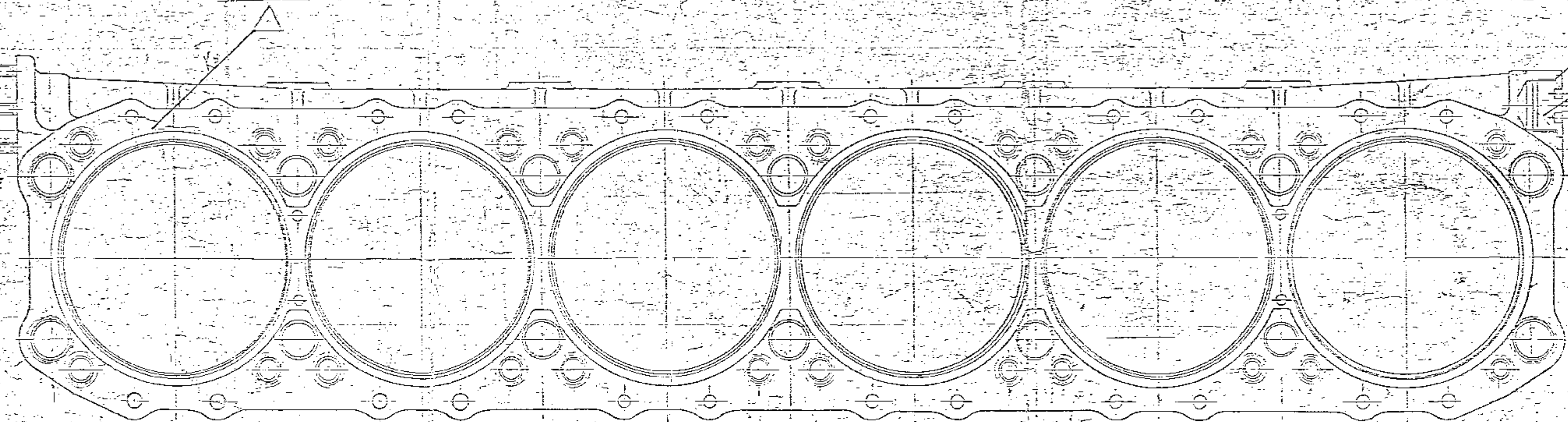
ORIGINAL (PUSH) ON RUSSIAN ORIGINAL ISSUE No. 111 (D.K. 03-0023)



1. Определить воду под давлением 0,25 МПа (2,5 кг/см²) ... 0,30 МПа (3 кг/см²) при температуре 60...70 °С в течение 3 мин.
 Разрешается прогревать до постановки шпилек и штифтов.

1. TO BE SUBJECTED TO HYDROSTATIC TEST PRESSURE 0,25 Mpa (2,5 Kg/Cm²) — 0,30 Mpa (3 Kg/Cm²) AT A TEMPERATURE 60° - 70°C FOR 3 Mins.
2. HYDROSTATIC TEST IS ALLOWED BEFORE THE SETTING OF STUDS AND PINS.

DRIVE SIDE
 33000
 33090



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

EST. MASS 28,36 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.

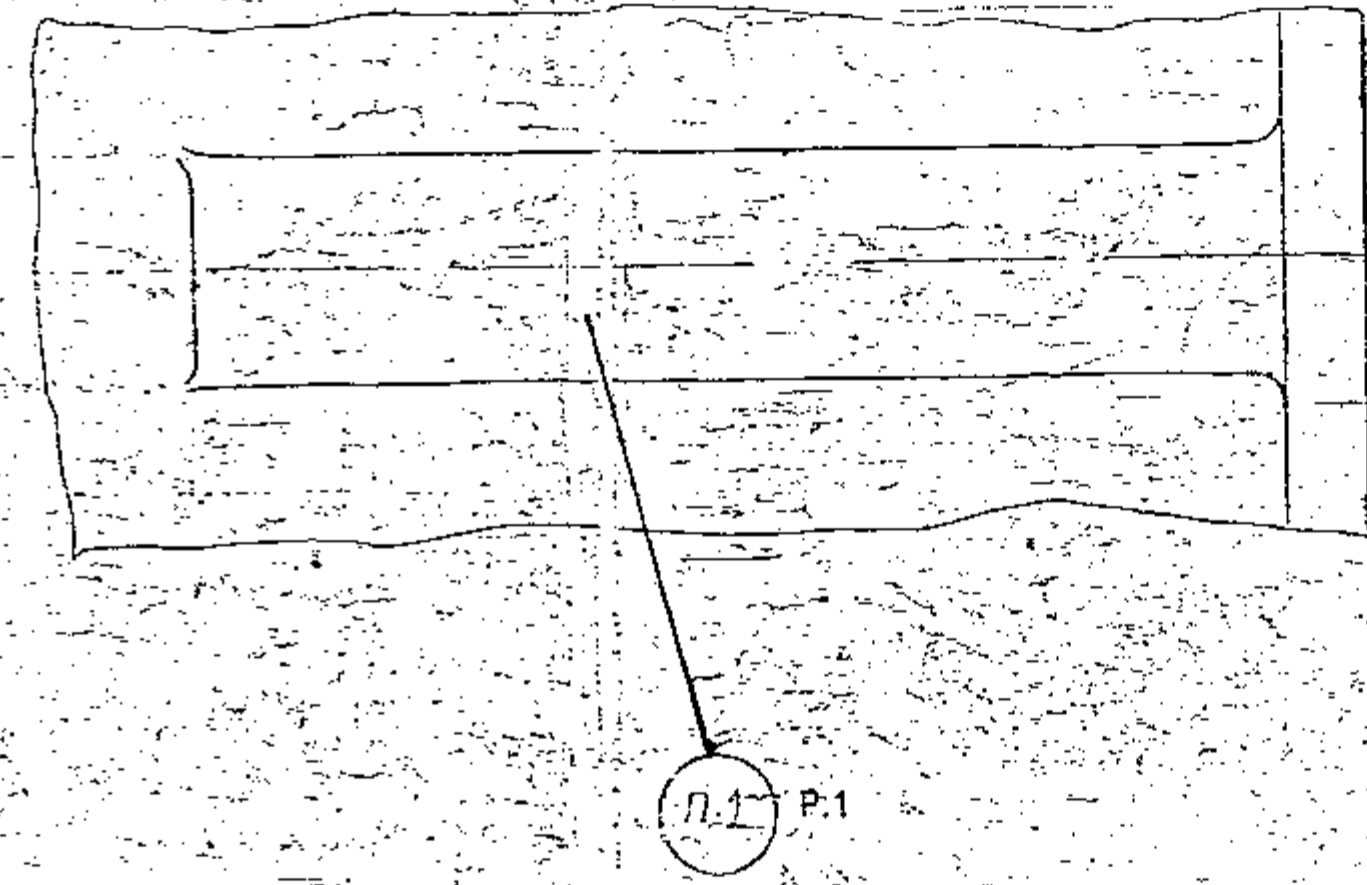
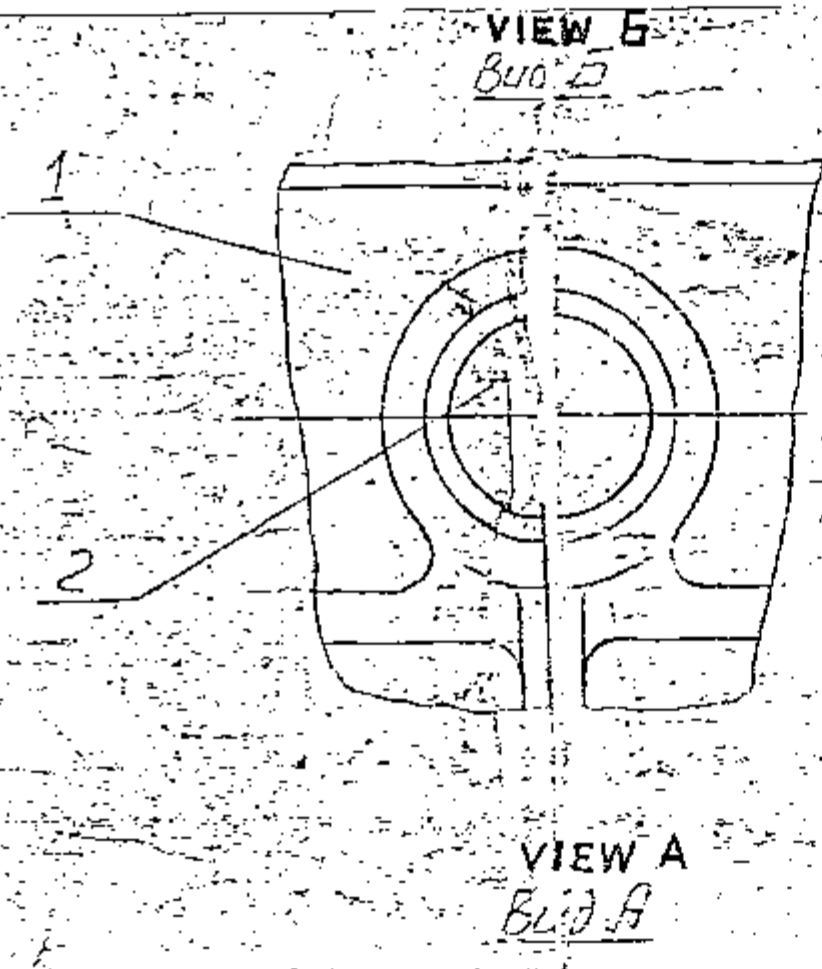
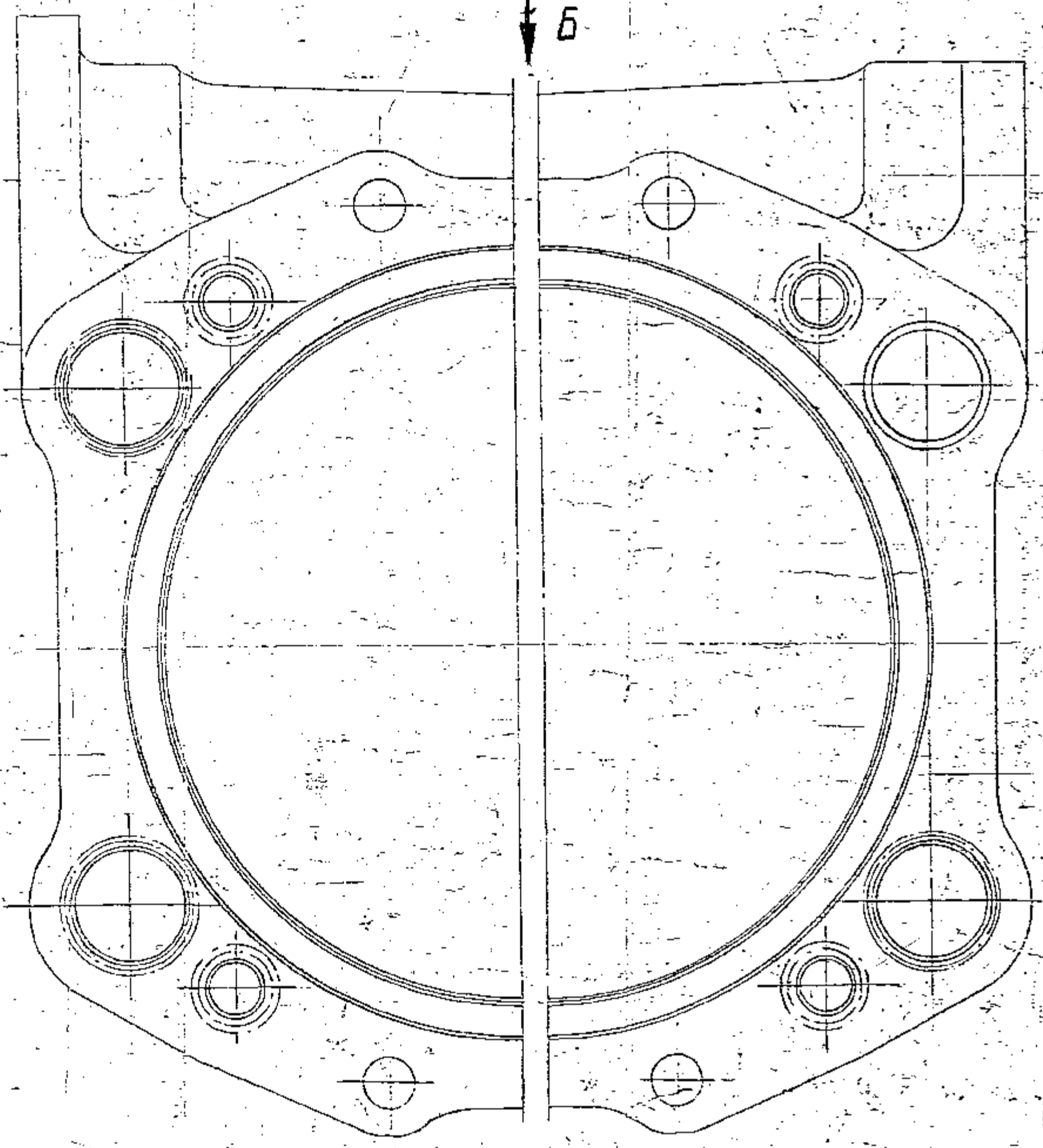
DRW	—	MATERIAL	USED ON:- СБ 303-01-16сБ
DES	—	CONTROL	CONTROLLERATE OF QUALITY ASSURANCE HEAVY VEHICLES AVAGI
APPD	—	DATE	30-09-88
SCALE	1:2	CONFORMS BY	—
TOLERANCE OR DIMS UNLESS OTHERWISE STATED	—	TITLE	CYLINDER JACKET L.H. ASSY
ALL THREADS CONFORM TO	—	D S CAT NUMBER	—
ISSUE	DATE	NATURE OF AMENDMENTS	FORMING NUMBER СБ 303-02-16сБ

DRAWING NUMBER
СБ 303-05-6 СБ

1. Маркировать зубирным способом
 2. Остальное - см. СБ 303-06-18 СБ

1. TO BE MARKED BY PUNCHING.
 2. FOR OTHER REQUIREMENTS, SEE СБ 303-06-18 СБ.

DRIVE SIDE
 Сторона
 передачи
 A →



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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

DRN	CHD	TCD	APPE	DATE	SCALE	DIMENSIONS IN mm.	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	ALL THREADS TO CONFORM TO
				30-09-88	1:1			
				MATERIAL :-		USED ON :-		
						C6 303-02-16		
				CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)		A V A D I		
				TITLE		CYLINDER JACKET L.H		
				D S CAT NUMBER		DRAWING NUMBER		
						C6 303-05-6 СБ		
ISSUE	DATE	NATURE OF AMENDMENTS						

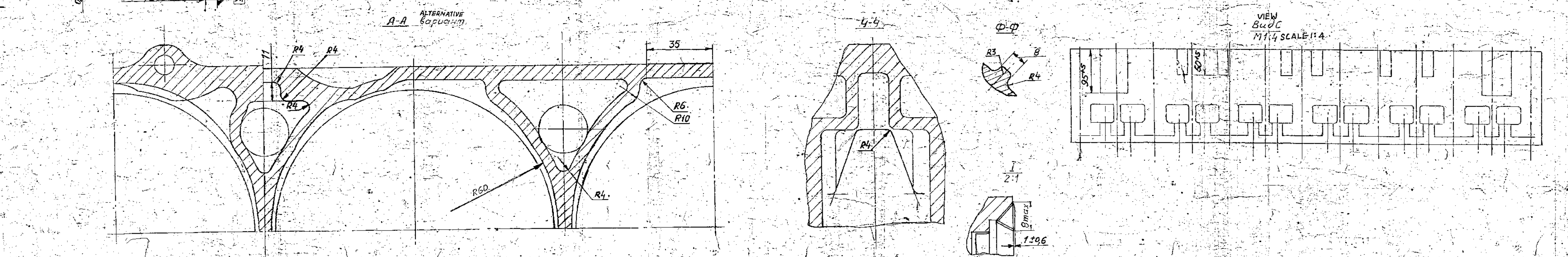
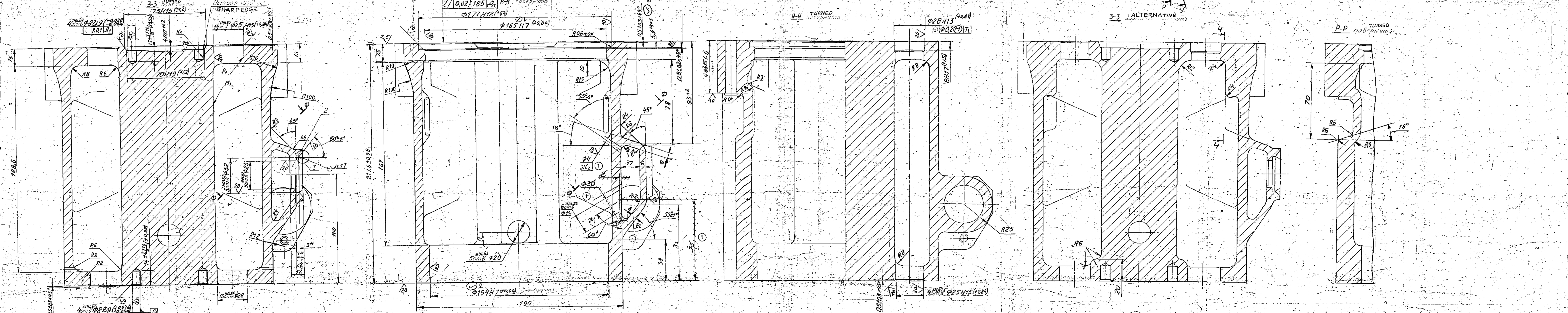
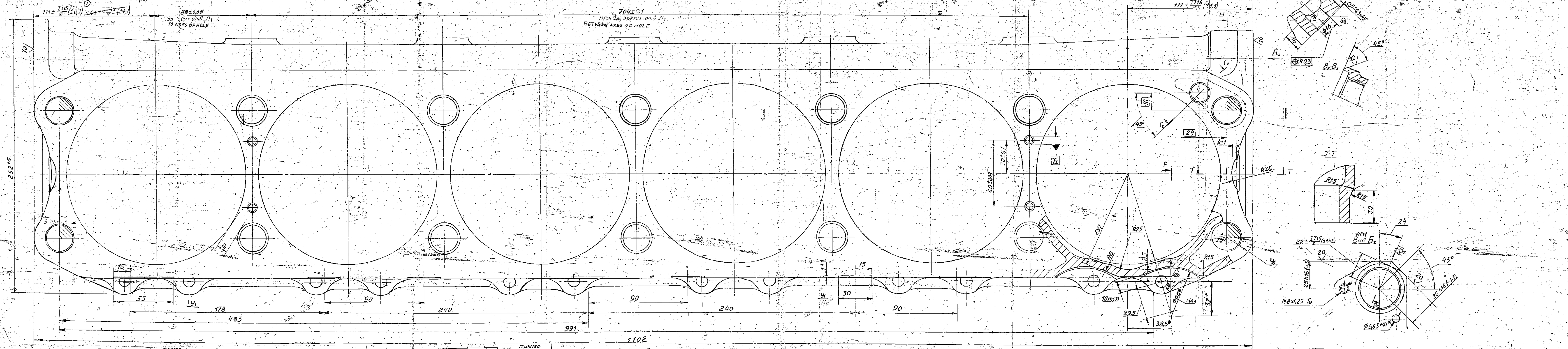


TABLE 1
Technical 1

SHEET	Item	Назначение	Обозначение
1	MAIN VIEW	2-2	C ₁
1	UPPER VIEW	3-3	A ₁ B ₁ F ₁ D ₁ U ₁
1	B-B	4-4	3, M ₂ K ₂
1	VIEW	5-5	C U ₁ 10 A
1	VIEW	6-6	U ₂ V ₂ K ₂
1	VIEW	7-7	10 ₂
1	VIEW	8-8	U ₂
2	LOWER VIEW	9-9	U ₁ U ₂ V ₂ T ₂
2	3-3	10-10	K ₁ M ₂ P ₂
2	K-K	11-11	3, U ₂ E ₂ K ₂

TABLE 2
Technical 2

CYLINDER NUMBER	DIMENSION	DIMENSION
1	24	73
2	21	71
3	18	69
4	17	67
5	20	65
6	12	63

EST. MASS 27.6 kg TO BE STAMPED OR MARKED WHERE INDICATED THIS IS LETTERS!

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MALCHINED CORNERS TO HAVE R. OUT. SIDE R. RESE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN: [Signature] MATERIAL: [Blank] USED ON: CB 303-03-1

APPROVED: [Signature] CONTROLLERATE OF QUALITY ASSURANCE/HEAVY VEHIC A V A D I

DATE: 1978 SCALE: 1:1

TITLE: CYLINDER JACKET R.M. ASSY.

D 5 CAT NUMBER: [Blank] DRAWING NUMBER: 577-2

ISSUE: [Blank] DATE: [Blank] NATURE OF AMENDMENTS: [Blank]

7-28-78 (NOTN. No. C41-24 (F-15)) ALL THREADS TO CONFORM TO

CB 303-06-10 CB

