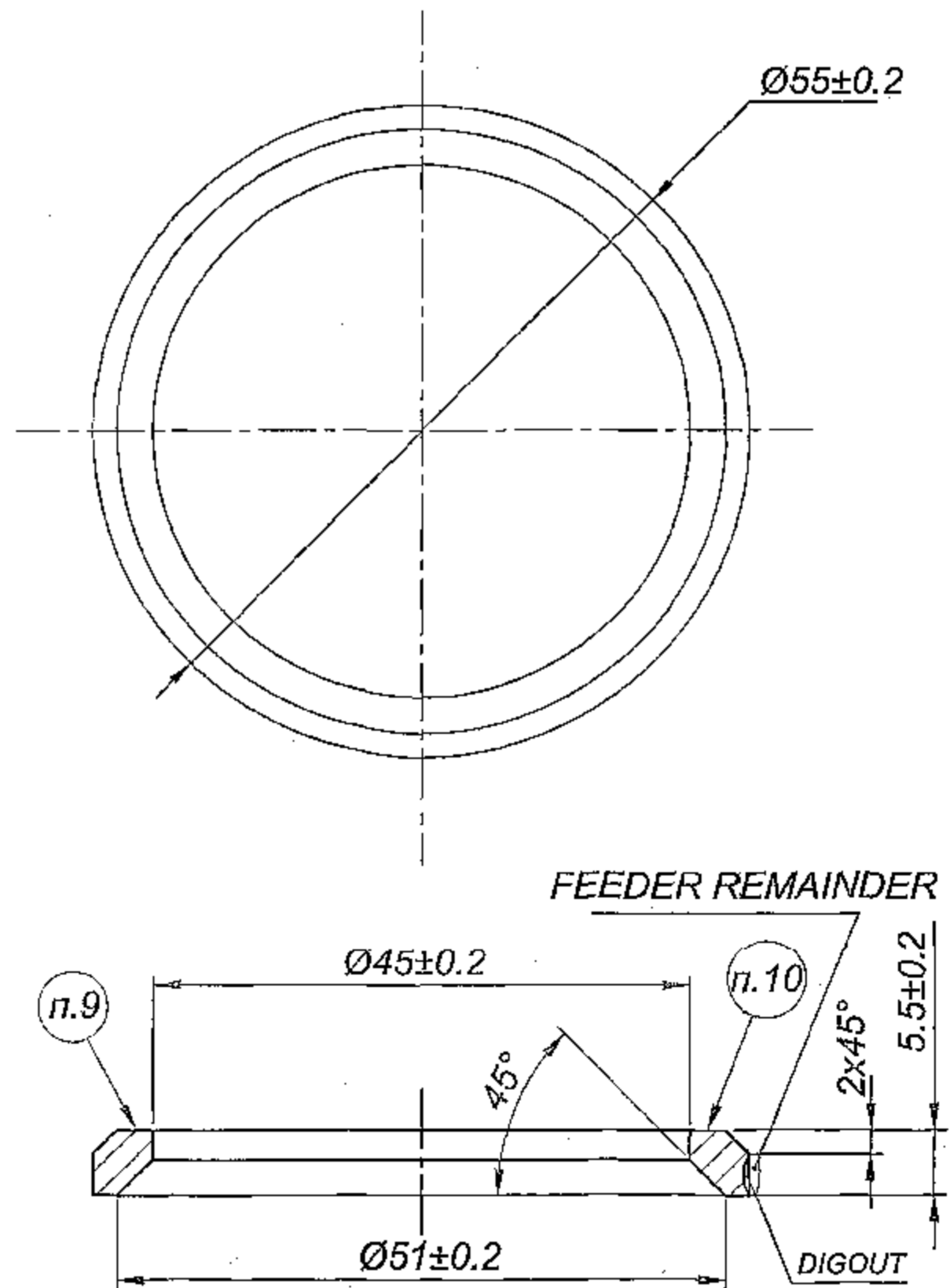


DRAWING NUMBER
306-49

SHEET No. 1 OF 1



1. Casting as per pattern.
2. 43...51 HRC₃.
3. Unspecified casting radii upto 0.5 mm.
4. Unspecified casting draft upto 1°.
5. Casting accuracy 5T-5-8-5 GOST 26645-85.
6. The following are permitted:
 - a). Cutting -out of the body of casting in the place of runner with depth not exceeding 0.3 mm is allowed, remaining undressed runner should not be bigger than 0.5 mm.
 - 6). Short-run of edges on Ø55 should not exceed 0.5 mm.
 - b). Clean sandy cavities occupying not more than 10% of a total surface of casting.
 - c). Separate clean cavities in quantity of 5 pieces not bigger than Ø1 mm and up to a depth of 0.5 mm maximum, distributed over a distance of 10 mm minimum from each other.
7. The following are not allowed:
 - a). Metal overflow and Burrs on the diameter 45 mm.
 - 6). Deep cracks, non-homogenous body.
8. Surface of casting should be cleaned from the reminders of ceramics by sand blasting.
9. Stamp letter K on the tag with Letter type 3-Пп GOST 26.008-85.
10. Mark the seat number with Letter type 3-Пп GOST 26.008-85.
11. Remaining requirement are as per TY-4591-008-08629387-2000.

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 6

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

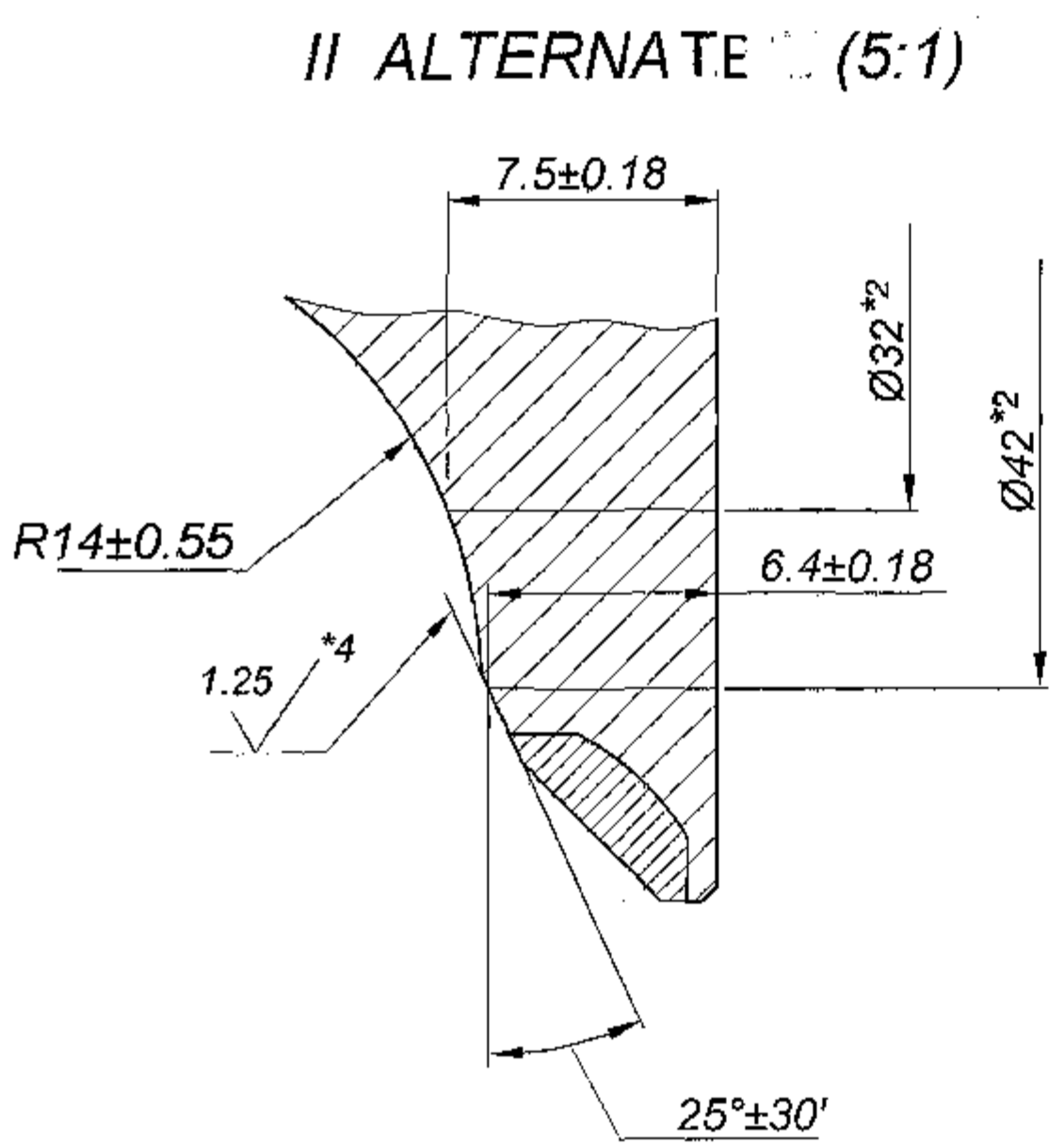
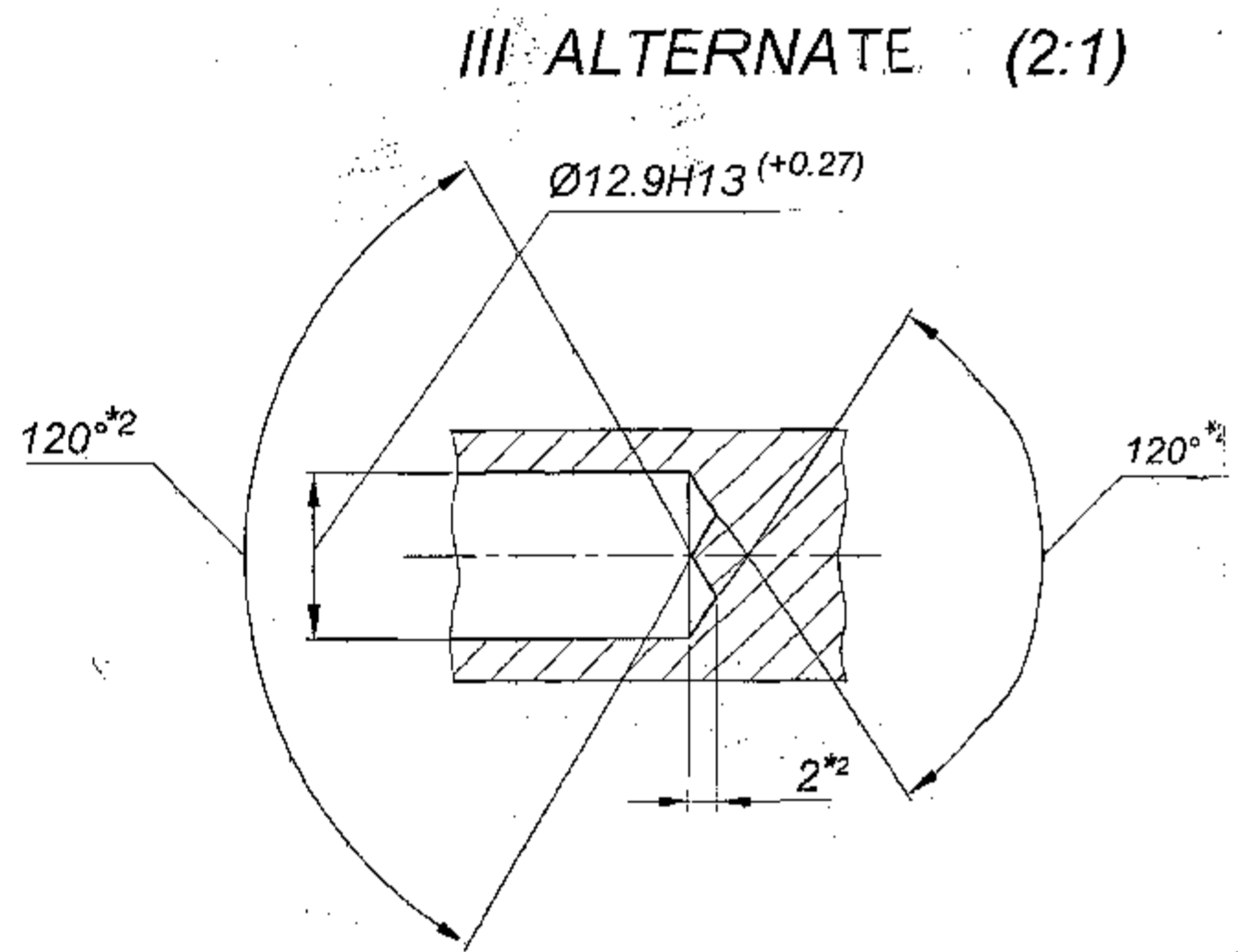
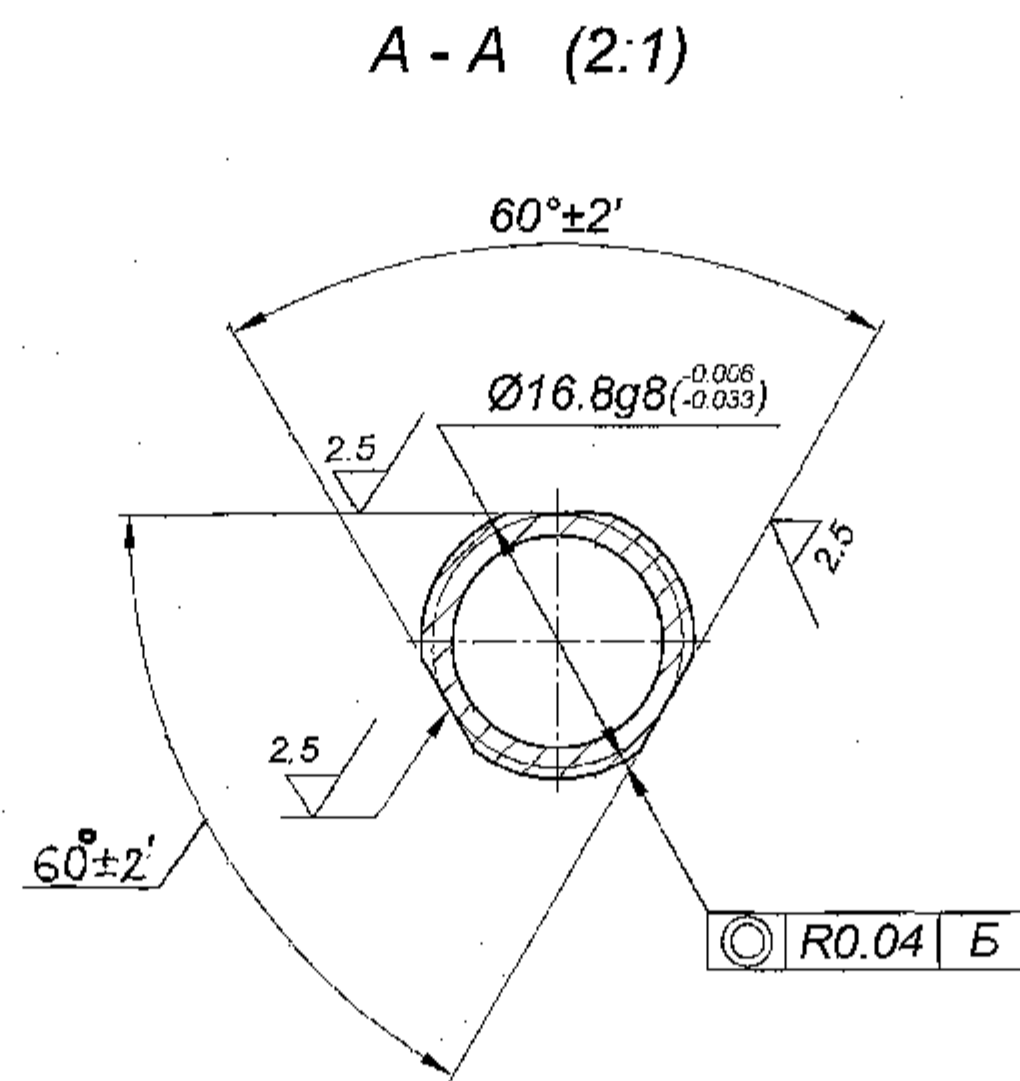
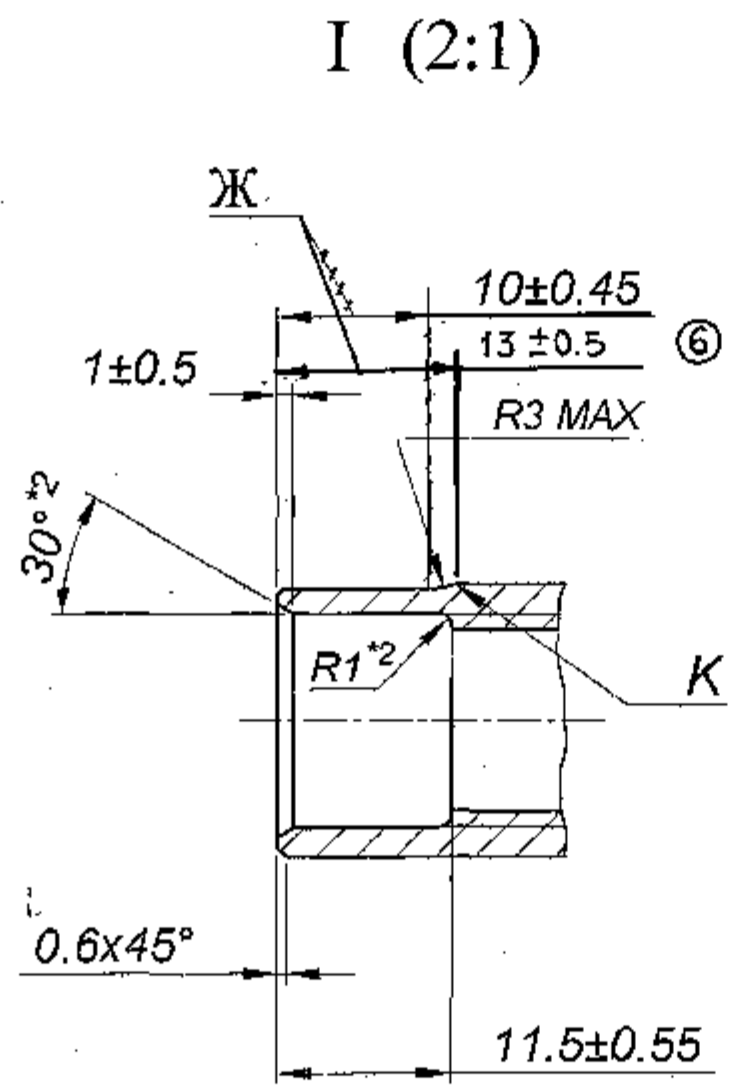
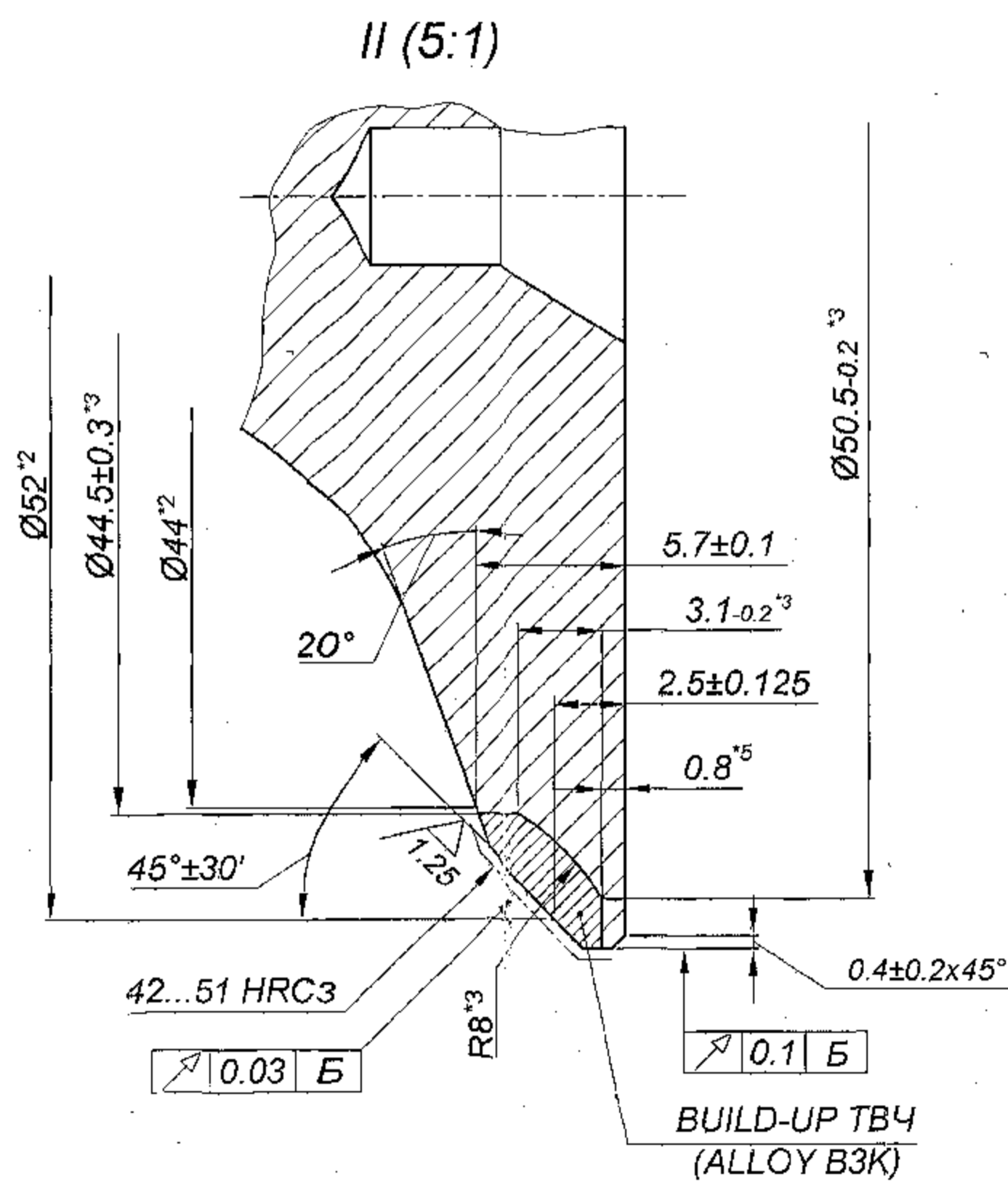
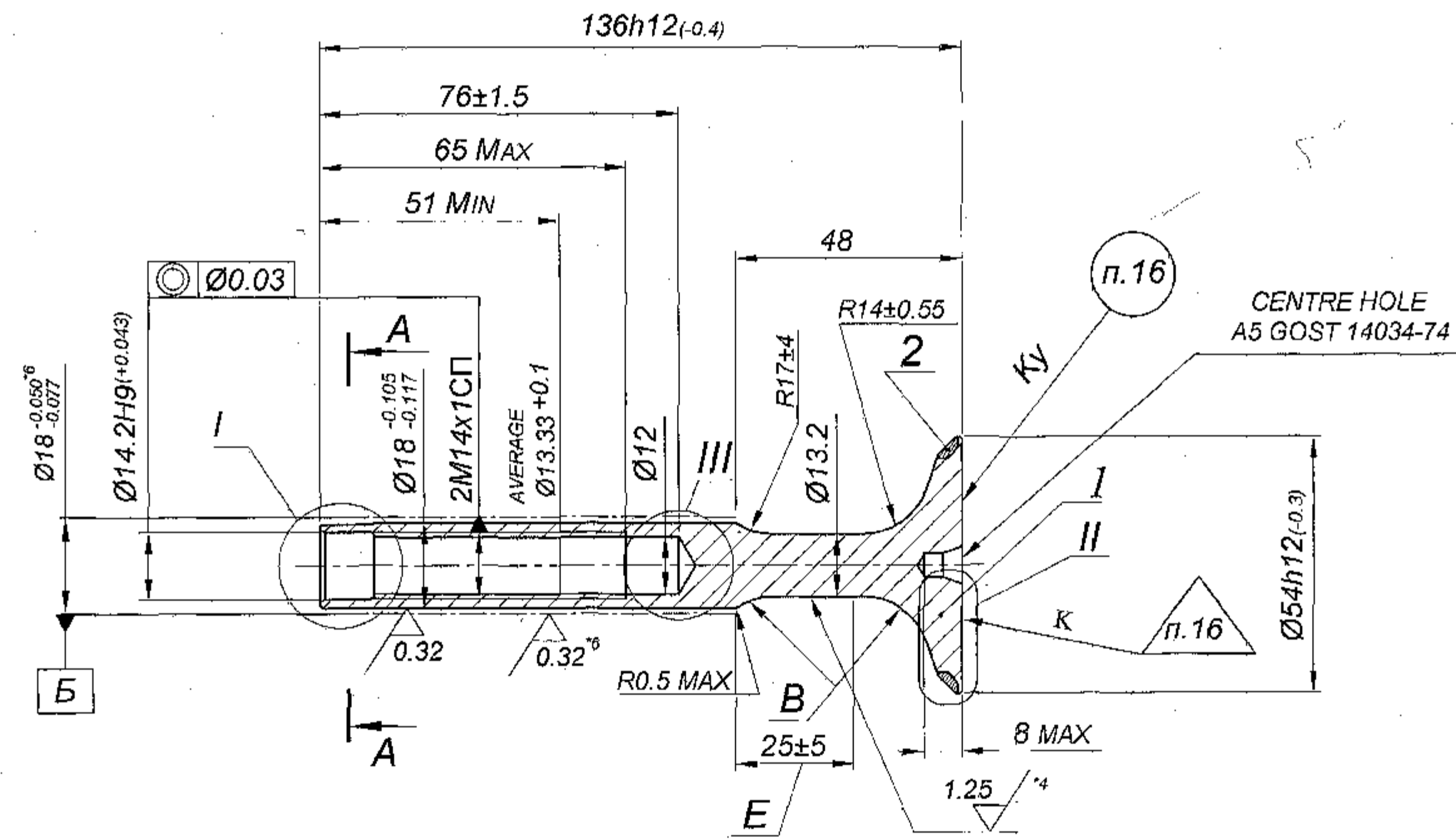
EST. WT. (Kg) 0.025	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
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ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	APPD	DATE	SCALE: 2:1	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102 - 69	ALL THREADS TO CONFORM TO	DRN	CHD	APPD	DATE	MATERIAL:- ALLOY B3K TY 4591-008-08629387-2000	USED ON :- Cb 306-45-01
			11-9-2007									CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
								TITLE :-		ADDITIONAL RING			
								D S CAT NUMBER		DRAWING NUMBER 306-49			
ISSUE	DATE	NATURE OF AMENDMENTS											

F-3
97
166
SIZE A2





1. Inspection group II as per TT-11.
2. 255-302 HB except the places specified separately
3. Direction of grains in longitudinal section should correspond with external contour of forging with out loop and breaks as per set standard. Breaks of grains is permitted in the zone metal building.
4. Metal building is carried out as per instruction И-УТТМ3-126-91.
5. Chromium plating of surface B X Hardness: 21 as per ИП-154-75. After plating tempering is carried out.
6. Unspecified limit deviation of dimensions in machining: $H14, h14, \pm \frac{IT14}{2}$
7. Technical requirement for thread are taken as per standard 82021-00.
8. On the surface of chamfer- pores, cavity, cracks and Non-metalic inclusions are not allowed.
- 9.* Check the following dimensions with set gauges:
Diameter of flattened spots - 16.853 mm.
Diameter of hole - 17.962 mm.
Angle between flats - $60^\circ \pm 2$.
10. Polish the surface 'B'. On edges burrs and chromium splashes are not allowed.
11. Edge 'K' to be dressed, polished as per standards.
12. Acceptance of part after final Heat-treatment to be carried out as per TTM 56-78.
13. Chromium -plating is permitted on the length 'E'. Remaining surface of valve head, section K and internal surface are to be protected.
14. Check the part on magnetic defectoscope. Technical requirement and acceptance rules are as per TT ИВ-17
15. Roller burnish the surface 'B' before Chromium-plating by roller $\phi 30 \dots 35$ mm, radius at the top of the roller is $R=4^{+1}$ mm, load on the roller should be 80...130kg. Feed 100mm per minute. Polishing is permitted.
16. Stamp by Electro-chemical method as per instruction PM-32 or Electro-sparking method, and mark 'X'.
17. *² Dimension to be ensured by tool.
18. *³ Dimension to be ensured before building up.
19. *⁴ Accept as per inspection specimen.
20. *⁵ Dimension is given for reference.
21. *⁶ Dimension and roughness after plating.

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

EST. WT. (kg) 0.250 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	APPD	DATE	SCALE: 1:1	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED AS: 202-69	ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
MATERIAL: Cb 306-06-12				CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI				TITLE: INTAKE VALVE ASSY	
ISSUE DATE: 20.11.09				NCTN. NO: 2002-379 (F-158)				DRAWING NUMBER: Cb.306-45-01	

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 5



