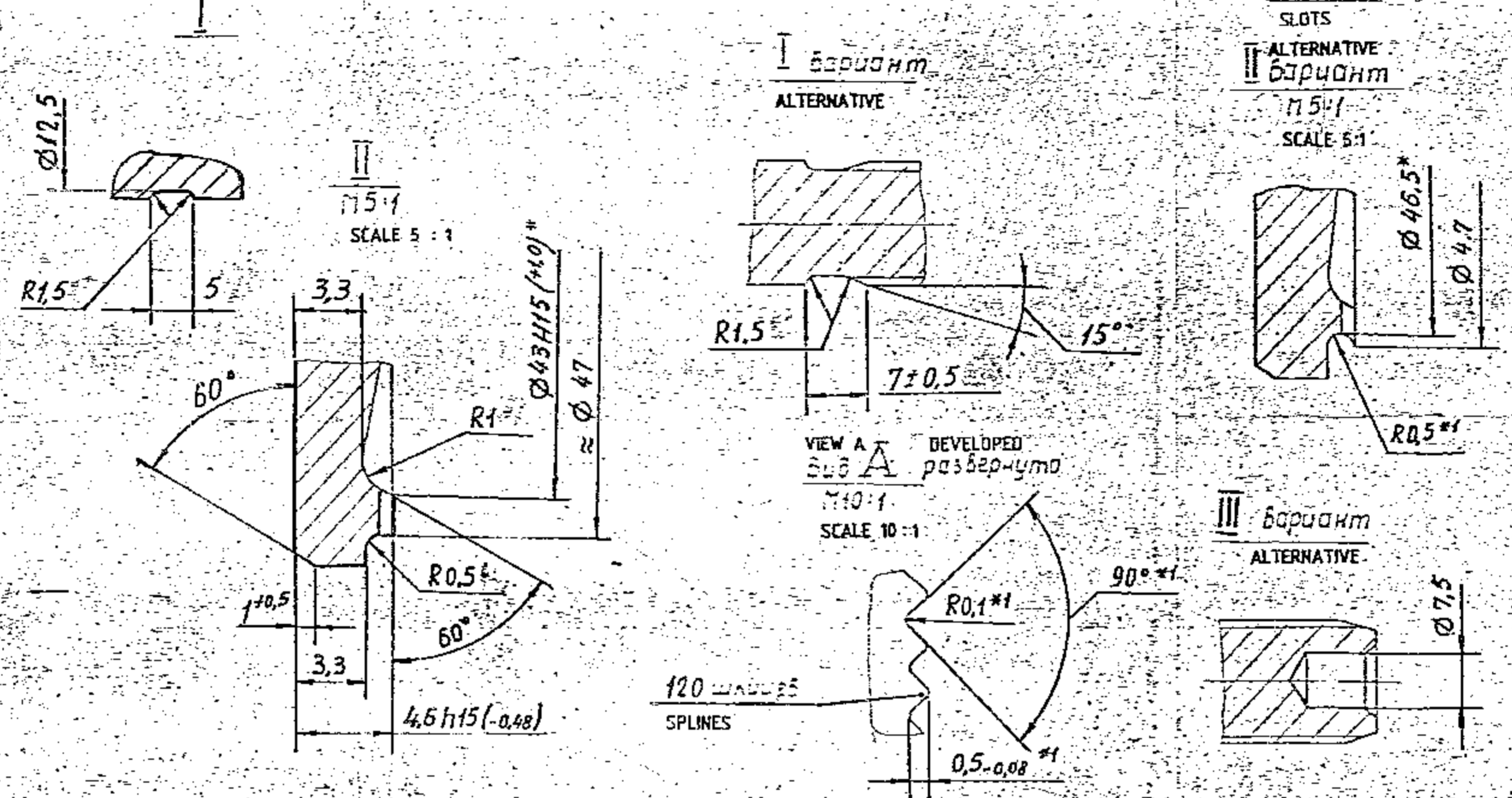


1. Группа контроля III по ТТ-11.
2. HRC, 26...42, кроме места, обозначенного 0205.
3. Неуказанные предельные отклонения, размеров: отверстий по H14; валов по h14; остальных $\pm \frac{IT14}{2}$.
4. Технические требования на резьбу по нормам 82021-00.
5. Торцовые шлицы и расположение их относительно оси поверхности Б проверять специальным калибром в 3^х положениях через 120°. Прилегание должно быть плотным без ощутимой качки. Принимать по контрольному образцу.
6. Допуск торцового биения поверхности В относительно оси среднего диаметра резьбы не более 0,04 мм на диаметре Д.
7. Допуск радиального биения поверхности Б относительно оси среднего диаметра 0,03 мм, не более.
8. Допускается подкачка остальной поверхности.
9. Допускается при накатке резьбы закругление гребешков $R=0,17$ мм, не более.
10. Допускается цементация поверхности Г $h=1,2$ мм, не более.
11. Допускается отсутствие центрального отверстия.
12. На дне канавки выхода резьбы риски не допускаются.
13. Деталь проверить на магнитном дефектоскопе. Технические требования и правила приемки согласно ТТ 143-17.
14. Диаметр клейма 5 мм, не более.
- 15.* Размеры контролировать до накатки торцовых шлицев.
- 15.* Размеры обеспечить инструментом.
17. Покрытие хим. окс. прм.

- 1) INSPECTION GROUP III AS PER TT-11.
- 2) HRC 26...42 UNLESS OTHERWISE SPECIFIED.
- 3) UNSPECIFIED LIMIT DEVIATION OF DIMENSIONS OF HOLES AS PER H14, SHAFT PER h14 AND OTHER DIMENSIONS $\pm \frac{IT14}{2}$.
- 4) TECHNICAL REQUIREMENTS FOR THE THREAD ARE AS PER STANDARD 82021-00.
- 5) THE FACE SPLINES AND THEIR POSITION RELATIVE TO THE AXIS OF SURFACE B BE CHECKED WITH A SPECIAL GAUGE. THE CHECK SHOULD BE CARRIED OUT AT 3 POINTS EVERY 120°. THE ENGAGEMENT SHOULD BE FULL WITHOUT PLAY AND ACCEPTED ON TEST SPECIMEN.
- 6) THE RUNOUT OF SURFACE B RELATIVE TO THE AXIS OF THE DIAMETER OF THE THREAD SHOULD NOT EXCEED 0.04mm ON DIAMETER A.
- 7) THE RADIAL RUNOUT OF SURFACE B RELATIVE TO THE PITCH DIAMETER OF THE THREAD SHOULD NOT EXCEED 0.03mm.
- 8) THE REPEATED CARBURIZATION OF THE REMAINING SURFACE IS ALLOWED.
- 9) WHEN ROLLING THE THREAD THE CRESTS MAY BE BLUNTED TO A RADIUS NOT EXCEEDING 0.17mm.
- 10) SURFACE G MAY BE CARBURIZED THE DEPTH OF CARBURIZATION SHOULD NOT EXCEED 1.2mm.
- 11) CENTRE HOLE MAY BE DRILLED.
- 12) MARKS ARE NOT ALLOWED ON THE BOTTOM OF GROOVE TO WHICH THE THREAD COMES.
- 13) THE COMPONENT SHOULD BE CHECKED FOR DEFECTS ON MAGNETIC FIELD FLAW DETECTOR. TECHNICAL REQUIREMENTS AND ACCEPTANCE RULES ARE IN ACCORDANCE WITH TECHNICAL REQUIREMENTS 143-17.
- 14) MARKING DIAMETER SHOULD NOT EXCEED 5mm.
- 15) DIMENSIONS SHOULD BE CHECKED BEFORE FORMING THE FACE SPLINES. MARKING DIAMETER SHOULD NOT EXCEED 5mm.
- 16) DIMENSIONS TO BE ENSURED BY TOOL.
- 17) COATING: CHEMICAL OXIDIZING OIL FINISHING.



(A) ALT. MATERIAL: BS: 970. STEEL GRADE: En36B.

CHEMICAL COMPOSITION	MECHANICAL PROPERTIES
C = 0.12 TO 0.18	ULTIMATE TENSILE STRENGTH — 102 kg/mm ² (min)
Si = 0.10 TO 0.35	ELONGATION % — 13 (min)
Mn = 0.30 TO 0.60	IZOD IMPACT — 4.8 kgm/cm ² (min)
Cr = 0.60 TO 1.10	
Ni = 3.0 TO 3.75	
P = 0.05 (Max)	
S = 0.05 (Max)	

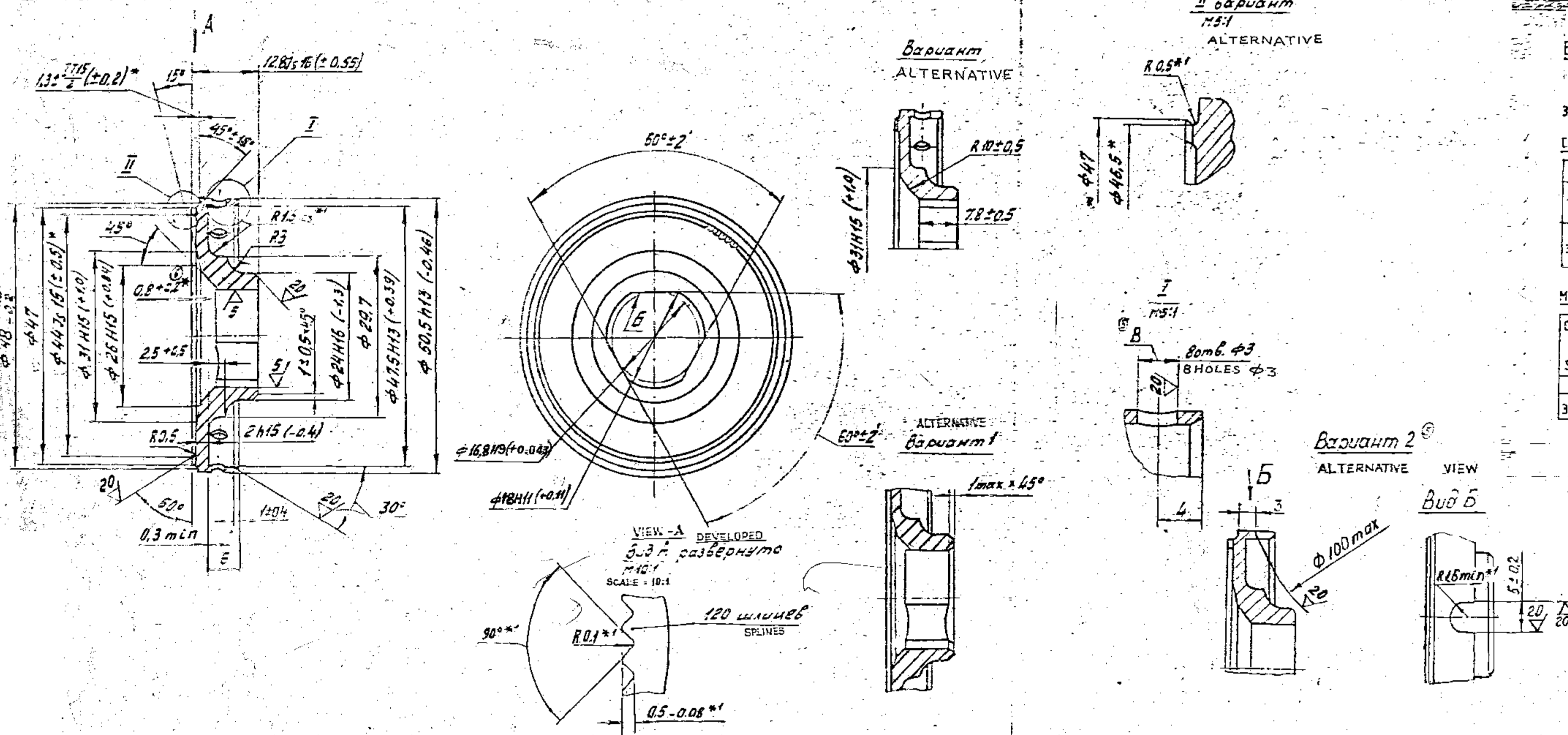
(B) EQUIVALENT MATERIAL
EN 36B TO BS: 970/
13 Ni13 Cr 3 TO 15: 4432-1988

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

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

DRN	CHK	APPD	DATE	SCALE	TOLERANCE ON DIMS	INCESS OTHERWISE	STATS IS 2102-69	TITLE	VALVE DISC
			23-3-88	2:1					
MATERIAL - STEEL 12XH3A					USED ON - C6 306-06-35 C6				
TY 14-1-301-72					C6 306-07-3A				
CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLE)					A V A D I				
ISSUE					DATE				
NATURE OF AMENDMENTS									





EXPLANATORY NOTE

MATERIAL QUOTE: STEEL 38 X C
 COST 4543-71
 38 X C CHROMIUM SILICON QUALITY STEEL

CHEMICAL COMPOSITION:

GRADE OF STEEL	CONTENT OF ELEMENTS %						
	C	Si	Mn	Cr	P	S	NI
38 X C	MAXIMUM						
	1.2-1.4	0.1-0.3	0.3-0.6	1.3-1.6	0.035	0.035	0.30

MECHANICAL PROPERTIES

GRADE OF STEEL	YIELD POINT PCN	ULTIMATE TENSILE STRENGTH Kgf/mm ²	RELATIVE ELONGATION %	RELATIVE REDUCTION ALONG CROSS SECTION	IMPACT STRENGTH Kgf/cm ²
38 X C	75	95	12	58	7

1. INSPECTION GROUP III AS PER TT-11.
2. HRC 28 — 32.
3. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS HOLES AS PER H 14, SHAFTS AS PER h 14, OTHERS ± IT 14.
4. THE FACE SPLINES SHOULD BE CHECKED WITH A SPECIAL GAUGE IN 3 POSITIONS THROUGH 120° ON A MANDREL WHICH IS MADE TO SUIT MAXIMUM DIMENSION ON THE MATING COMPONENT.
5. ENGAGEMENT OF SPLINES SHOULD BE ACCEPTED AS PER TEST SPECIMEN.
6. RELATIVE POSITION OF SURFACE B IS TO BE CHECKED BY SPECIAL GAUGE MANUFACTURED AS PER MAXIMUM DIMENSIONS OF MATING COMPONENTS.
7. COATING, CHEMICAL OXIDIZING OIL FINISHING.
8. TO BE MARKED ON TAG FOR THE BATCH OF COMPONENTS WITH SEALING.
9. * DIMENSIONS TO BE CHECKED BEFORE ROLLING FACE SPLINES.
10. * 1 DIMENSIONS TO BE ENSURED WITH TOOL.
11. HARDNESS MAY BE CHECKED ON BLANK ON EACH HEAT TREATED BAR BHN 255 — 265.
12. SLOT MAY BE MADE AS PER ALTERNATIVE 2 INSTEAD OF ONE FROM HOLE B.

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

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

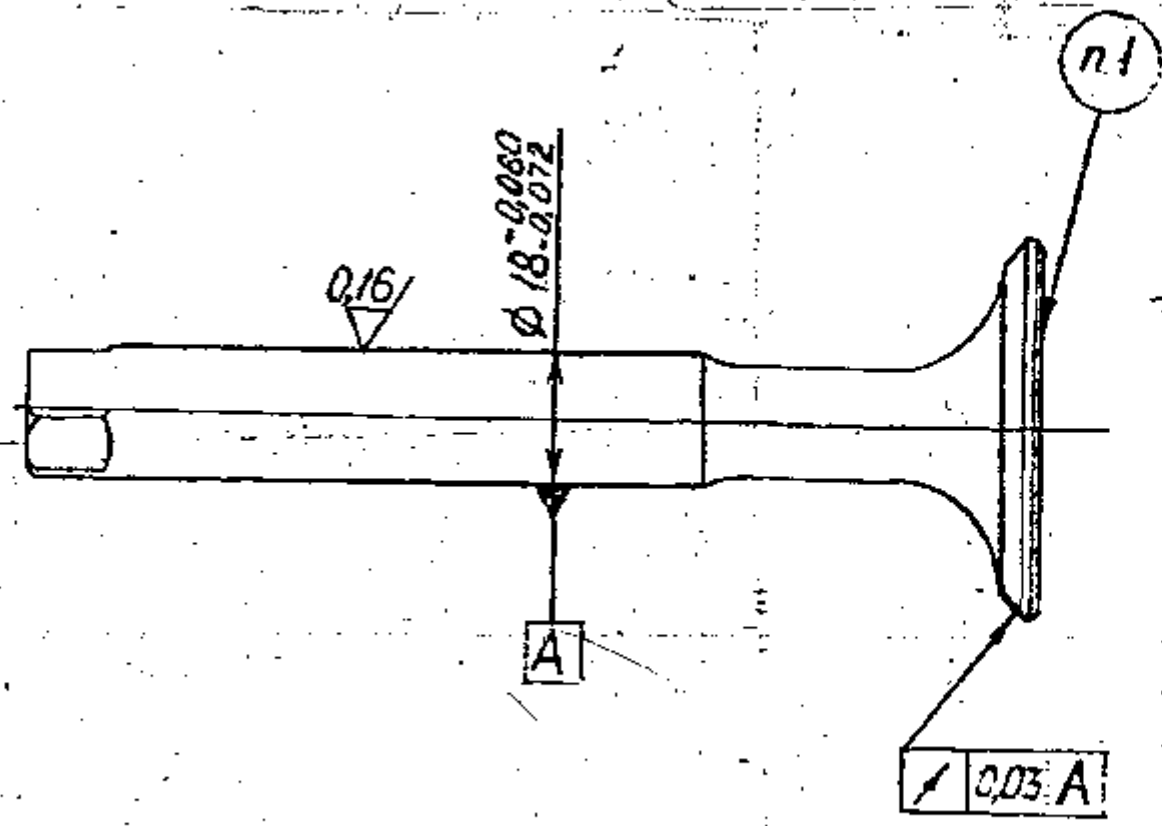
EST. MASS TO BE STAMPED OR MARKED WHERE INDICATED THIS * LETTERS
 0.05 Kg
 ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

DESIGN	MATERIAL	USED ON
ENR	STEEL 38XC COST 4543-71	108 405 16-2
DATE	CONTROLERATE OF QUALITY ASSURANCE HEAVY VEHICLES	108 406 17-2
SCALE	AYAD1	
TITLE	VALVE DISC LOCK	
ISSUE	DATE	NATURE OF AMENDMENTS
18.5.09	Authy: Third Alt. Comm. Minutes Point: 2	Dated 27-02-2009.
		ALL THREADS TO CONFORM TO
		DRAWING NUMBER
		306-48-7



DRAWING NUMBER
306-50-5A

KVD No: 78407
Ref. Drg. No: 306-50-5



1. Маркировать букву "С" (суперфинишированный) ударным способом на расстоянии от края не менее 10мм. Допускается маркировать электрохимическим способом по инструкции РМ-32 или электроискровым способом.

1) LETTER 'C' IS TO BE MARKED (SUPERFINISHED) BY PUNCHING AT A DISTANCE OF NOT LESS THAN 10mm FROM THE EDGE. MAY BE MARKED BY ELECTROCHEMICAL METHOD AS PER INSTRUCTIONS PM-32 OR BY ELECTRIC SPARK METHOD.

ORG INDANISED BASED ON RUSSIAN ORIGINAL ISSUE NO. 2 (83-75)

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

EST. WT. 0,255 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

DRN	9/24/88	MATERIAL	BLANK 306-50-5	USED ON	CB 306-07-3A
CHD	9/24/88	APPRO		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
TCD	9/24/88	DATE	23-3-88	AVADI	
SCALE			1:1		
DIMENSIONS IN mm			TITLE		
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 2102-63			EXHAUST VALVE		
ALL THREADS TO CONFORM TO			D S CAT NUMBER	DRAWING NUMBER	
				306-50-5A	
ISSUE DATE	NATURE OF AMENDMENTS				

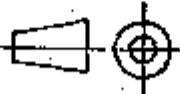
A5
5
SIZE A3



DRAWING NUMBER
 CB 306 07 3A

KVD NO 78104

VALVE SHOULD BE ADDITIONALLY MARKED WITH
 LETTER 'C' (SUPER FINISHED)
 DIMENSIONS, SPECIFICATIONS AND SKETCHES ARE
 AS PER DRAWING CB 306 07 3.

			EST WT 0.37 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: _____	USED ON: CB 406 13 32 CB 406 12 21
ISSUE	DATE	NATURE OF AMENDMENTS	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
DRN		SCALE:	 TITLE: ASSY VALVE EXHAUST	
CHD		DIMENSIONS IN mm		
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	D S CAT NUMBER	DRAWING NUMBER
APRD		ALL THREADS TO CONFORM TO		CB 306 07 3A
DATE	29-3-86			

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OF THE
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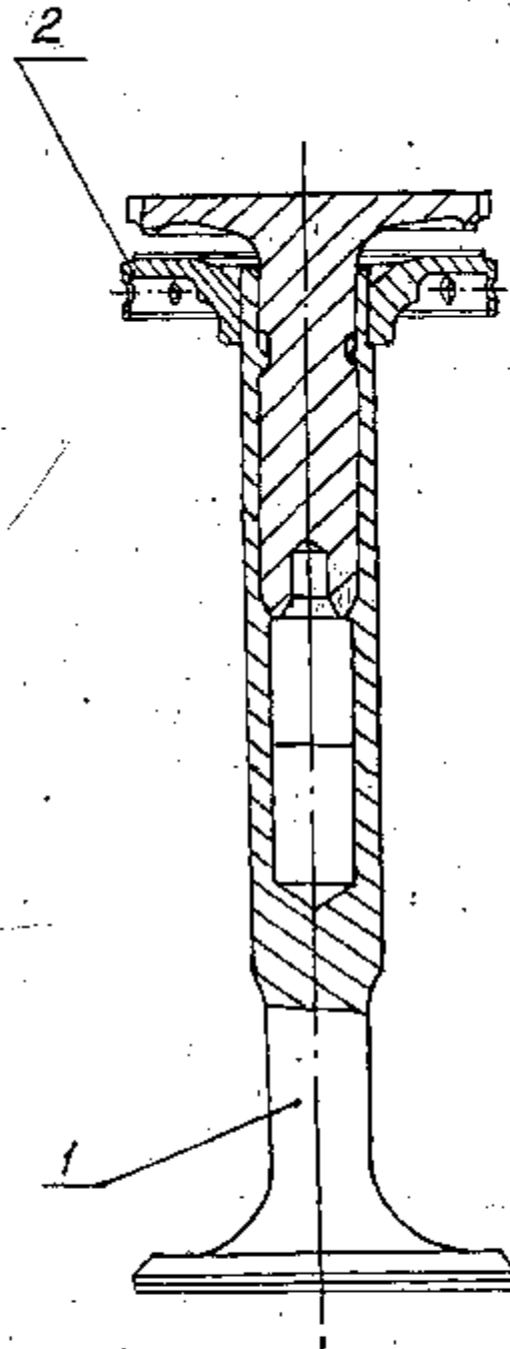
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DRAWING NUMBER
CQA(HV) 506.601E



(A) TECHNICAL REQUIREMENTS

1. Circumferential play of the Valve Disc Lock 306-48-7 (Item No.2) on flats of the Exhaust Valve stem 306-50-5A * should not exceed 0.3 on 50 Dia.
2. Valve Disc Lock 306-48-7 should match closely with Valve Disc 306-47-2 * by all their splines, 100 % checking is to be ensured.
3. Assy Valve Exhaust with Disc Lock is to be procured / replaced as a set.
4. The parts should be clean, free from dust, dirt and oiled to prevent rust.

* Part of item No.1

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

EST. WT. 0.420 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	APD	MATERIAL:-	USED ON
CHD	TCO		V46-6 ENGINE
APPD	DATE	CONTROLLERATE OF QUALITY ASSURANCE HEAVY VEHICLES	
	SCALE:-	AVADL	
	DIMENSIONS IN mm	TITLE ASSY: VALVE EXHAUST	
	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS : 2102-69.	WITH DISC LOCK	
A	10.4.02	ALL THREADS TO CONFORM TO	D S CAT NUMBER
ISSUE	DATE	NATURE OF AMENDMENTS	DRAWING NUMBER
			CQA(HV) 506 601E



SIZE A3





