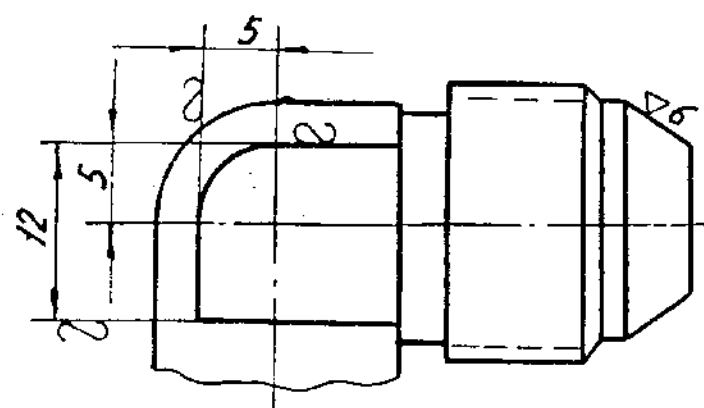
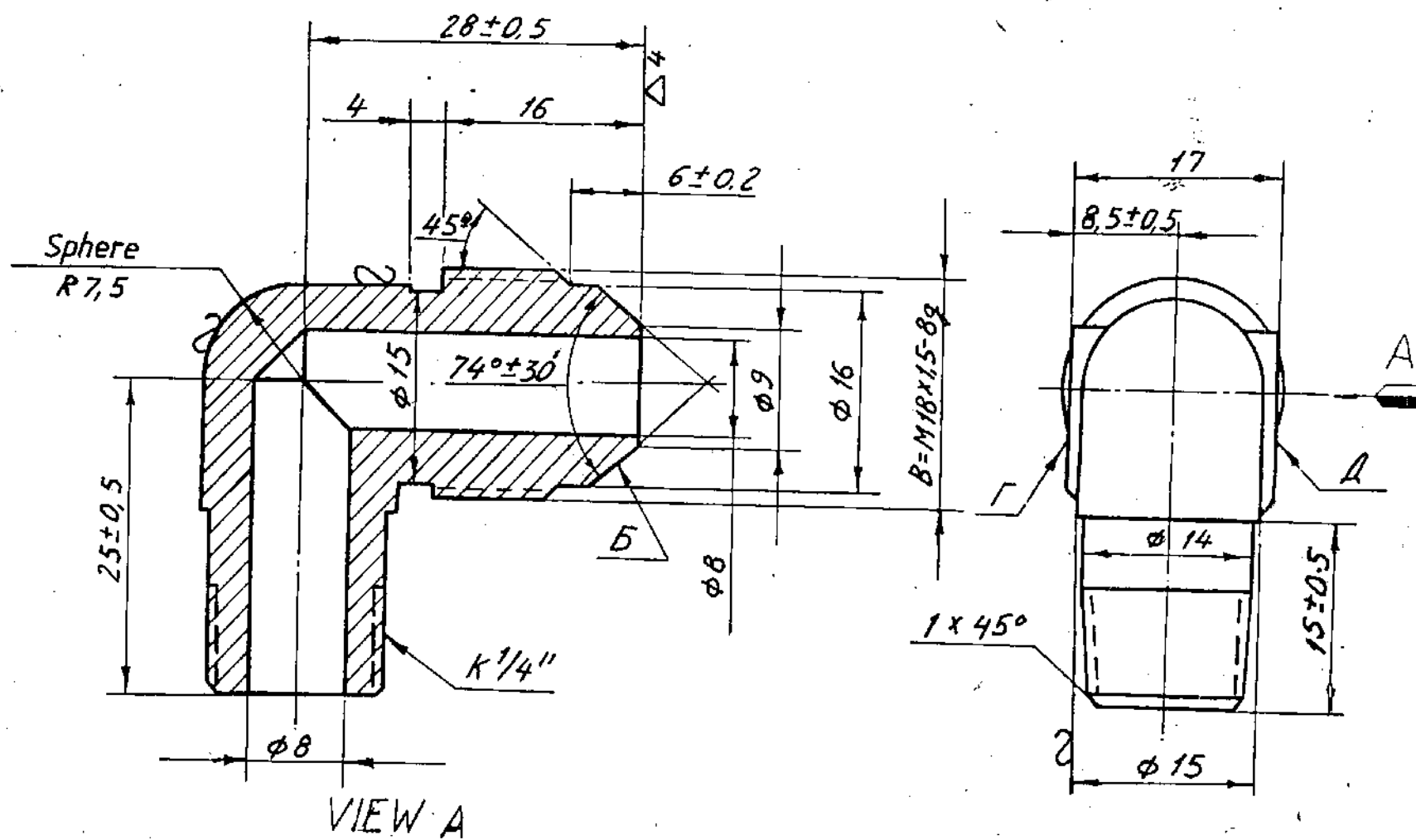


▽3 Unless otherwise specified



- 1) Blunt sharp edges.
- 2) Unspecified limit deviations of dimensions of surfaces to be machined are as follows:
For shafts as per B₇, Holes as per A₇,
Others as per CM₇, other requirements for forging are as per accuracy class II GOST 7505-74.
- 3) Run-out of surface B with respect to the angle diameter of thread B should not exceed 0,08 mm.
- 4) Coating : Zinc plated, 9 microns thick, chromitized, check dimensions before coating. Internal surfaces may be free of zinc coating.
- 5) Remove hydrogen embrittlement.
- 6) Local recesses not exceeding 0.5 mm are allowed on unmachined surfaces.
- 7) Dents to depth not exceeding 0,3 mm are allowed on surfaces Γ and Δ.

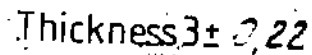
Ⓐ EQUIVALENT MATERIAL: Steel 45C8, IS: 2004-78, Class-4.

Ⓑ C 45, C 50 OR 40 C₇ 1 TO IS: 5517-69.

00806-ICV	Ⓑ	EQUIVALENT MATERIAL ADDED.
NH 14.9.2000	Am	
00625-ICV	Ⓐ	MATERIAL STEEL 45C8, IS: 2004-78, CLASS-4 ADDED AS EQUIVALENT MATERIAL (1/98 Not A)
30 MAR 98	Am	
DECS NO	ISSUE	NATURE
8 DATE		AMENDMENT

APPROVED	H VASU	765-84-59	
CHECKED	Sharma	PIPE UNION	
CONTROLLERATE OF INSPECTION (ICV)		WEIGHT	SCALE
		0.045	2:1
		SHT	SHTS
		45 GOST 1050-74	84

c. All over

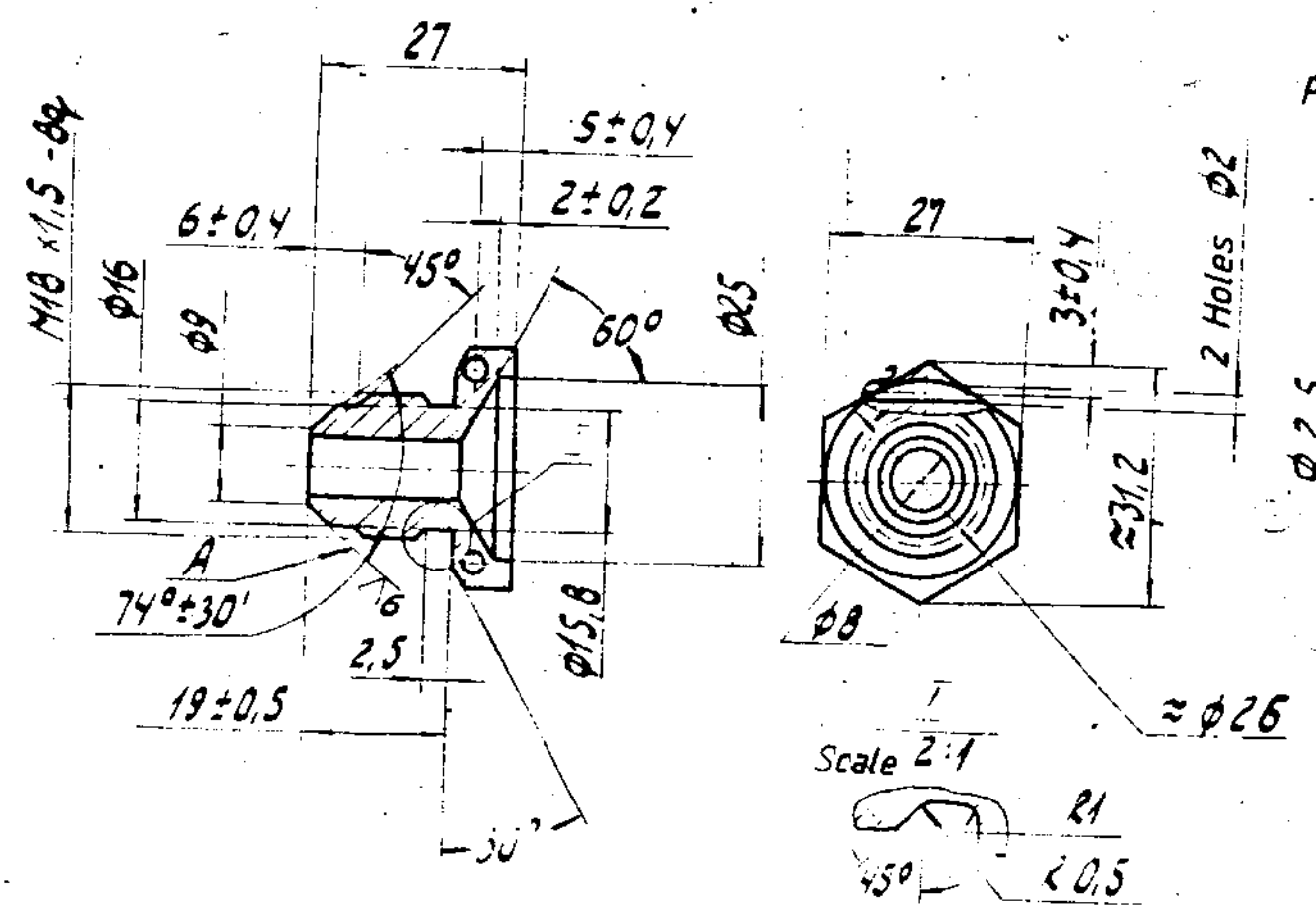


- (A) 5. EQ. MATERIAL :- ST 34 TO IS: 1079-73
 (B) EQ. MATERIAL (i) STEEL PLATE ST 34 TO IS: 1079-73.
 (ii) GRADE D TO IS: 4030-73.
 (C) ALT. MATERIAL :- C-14 TO IS: 1570-61.

84

19-78-69L

Unless otherwise specified



- 1) Blunt sharp edges.
 - 2) Run out of surface A with respect to the angle diameter of thread should not exceed 0,1 mm (qualified tolerance).
 - 3) Provide dimensions without deviations as per accuracy class 7.
- Ⓐ EQUIVALENT MATERIAL: STEEL 45 C8 Gr4, IS: 9550-80
 Ⓑ EQUIVALENT MATERIAL: STEEL BAR C45 TO IS: 2073-70
 Ⓒ C 50 TO IS: 1570-61.

00806-ICV	Ⓑ	EQUIVALENT MATERIAL ADDED.
14.9.2000	Am	
00625-ICV	Ⓐ	STEEL 45 C8 Gr4, IS: 9550-80
30 MAR 98	Am	ADDED AS EQUIVALENT MATERIAL
DCCU NO	ISSUE	NATURE
DATE		AMENDMENTS

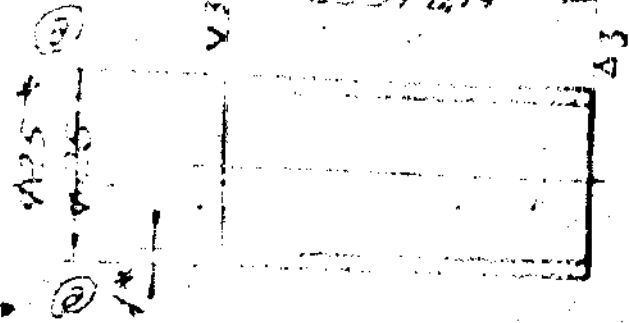
Имя, И. Ф. подп. в дата
 95-2500-1000
 95-1300

APPROVED	H VASU	765-84-61	
CHECKED	Enkmax		
CONTROLLERATE OF INSPECTION (ICV)		UNION	WEIGHT SCALE
			0.045 1:1
			SHT SHTS
		1-5 GOST 1050-74	84 48 OF 173

765-84-62

Unless otherwise specified.

5587-274



- ⑥ EQUIVALENT MATERIAL:- SEAMLESS STEEL TUBES GRADE CDS-2, OR CDS-3 TO IS:3074.
- 1. Blunt sharp edges.
 - 2. * Dimensions with (*) are given for reference.
 - 3. Alternate material is pipe 25x1 GOST 8734-75

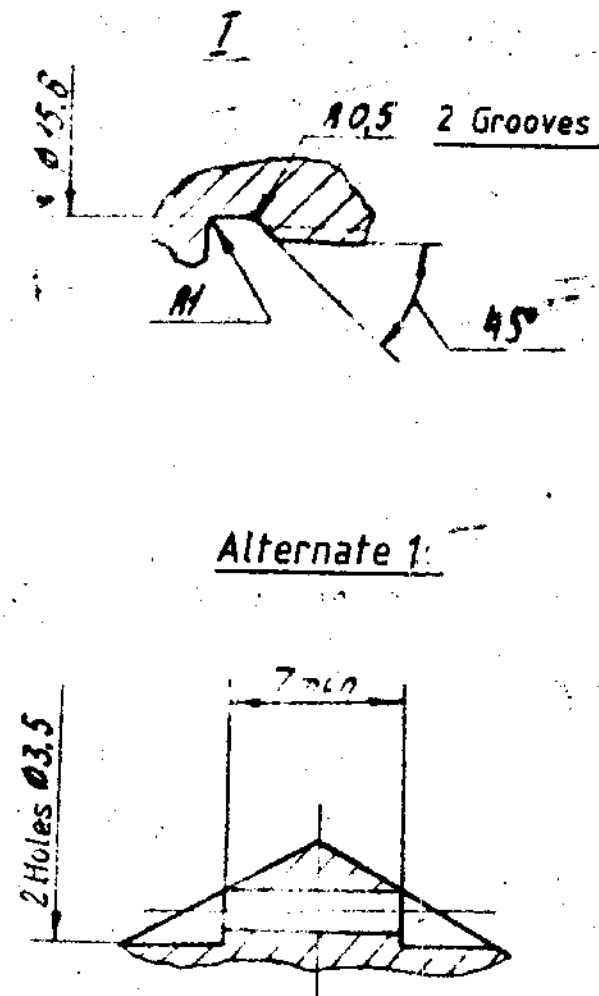
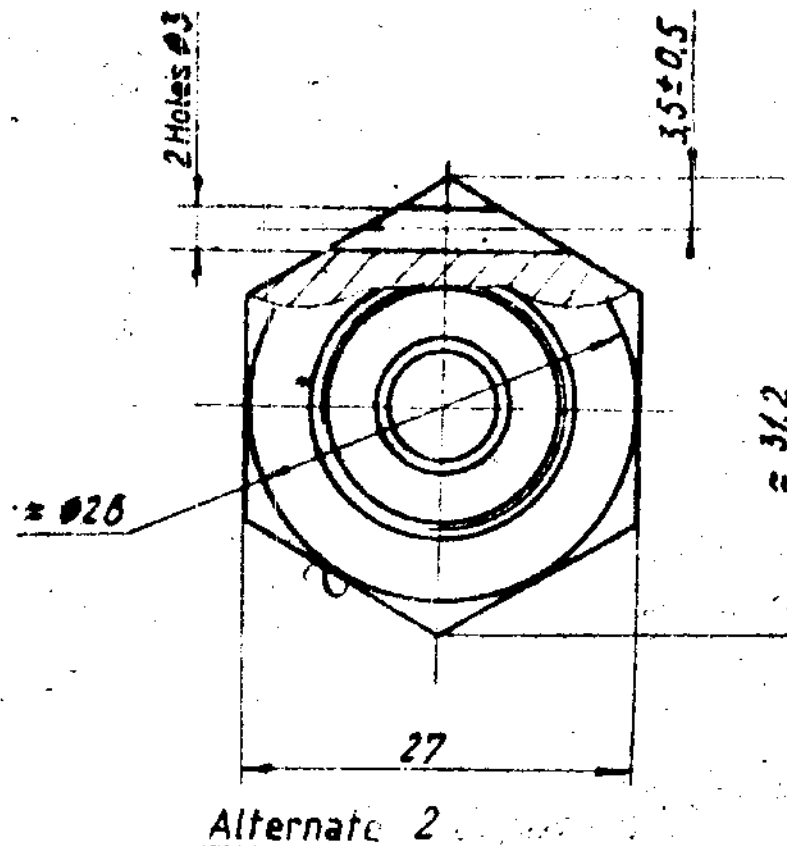
B20 GOST 8733-74.

① EQ. MATERIAL: PIPE CDS-200 TO IS:3601-84 ①

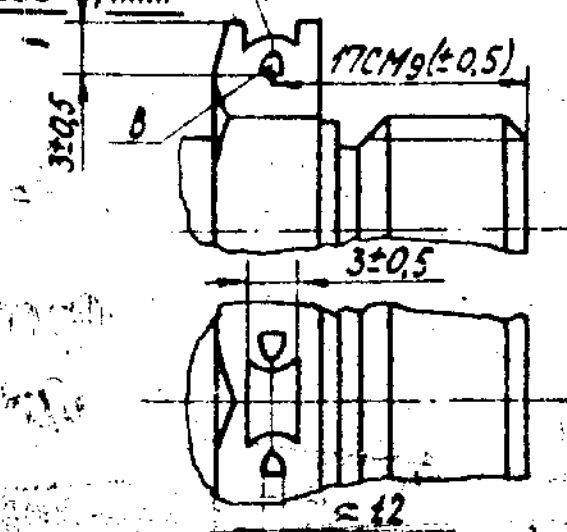
00806-ICV N ^o 2 14.9.2000	⑥	EQ. MATERIAL ADDED.
V. Ramas DC(1) 00640 -ICV 19.6.98	⑥	EQ. MATERIAL ADDED.
DC(1) NO. 8 DATE	①	ISSUE
		NATURE
AMENDMENT		

X183
43

APPROVED	M VASU	765-84-62	
CHECKED	S. Kumar	PIPE	
CONTROLLERATE OF INSPECTION (ICV)		PIPE	25x1 GOST 8734-75 B10 GOST 8733-74
		WEIGHT	SCALE
		0.036	1:1
		SHT	SHTS
		49	OF 173

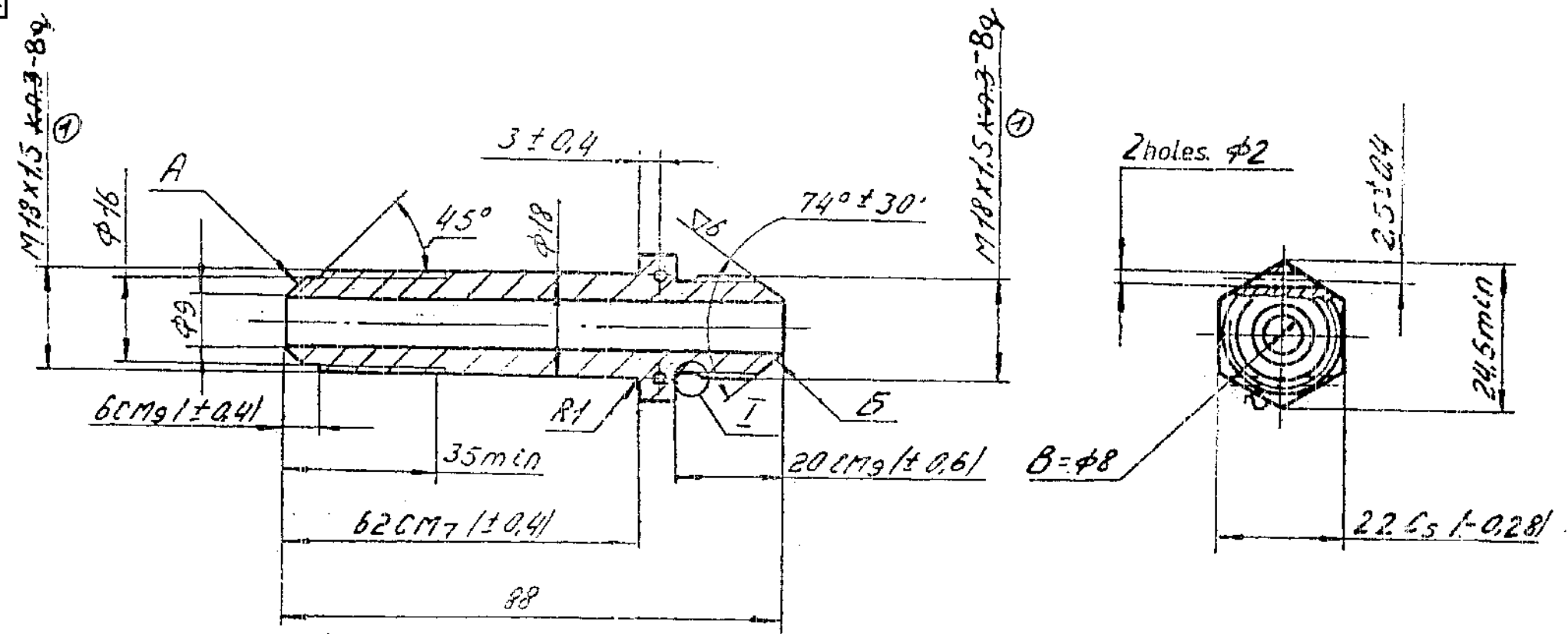


- Lock punch Clearance in joint
should not exceed 0.1mm

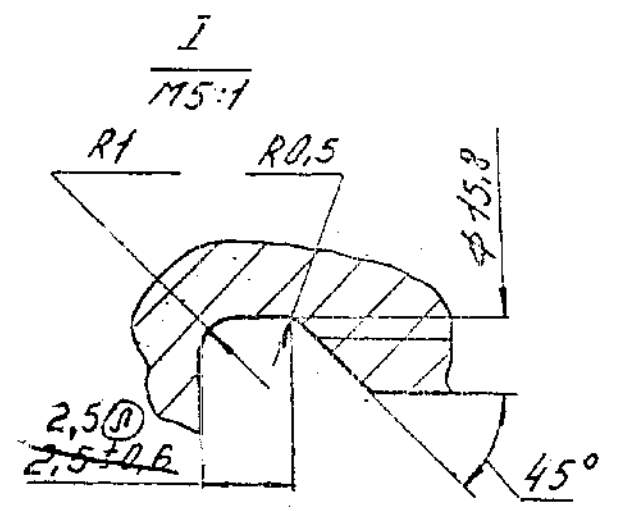


00806 -ICV NICKEL 14 3-2000	(B)	EQUIVALENT MATERIAL ADDED
00625- -ICV -K 30 MAR 98 DEC 00	(A)	STEEL 45 C8 GRA. 15-9950 80 ADDED AS EQUIVALENT MATERIAL (1/98 NO. 9A)
DATE	ISSUE	NATURE
DATE		AMENDMENT

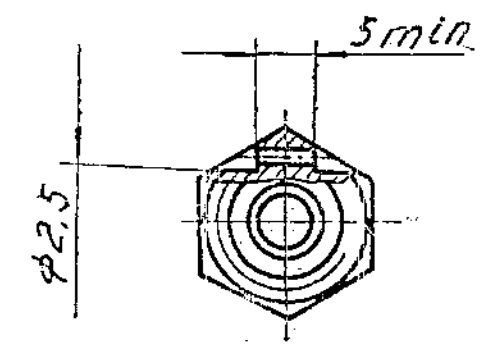
APPROVED	M VASU	765-84-75	
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF INSPECTION (ICV)	PIPE UNION	WEIGHT	SCALE
		0.059	2:1
		SHT	SHTS
	45 GOST 1050-74	52 OF 173	



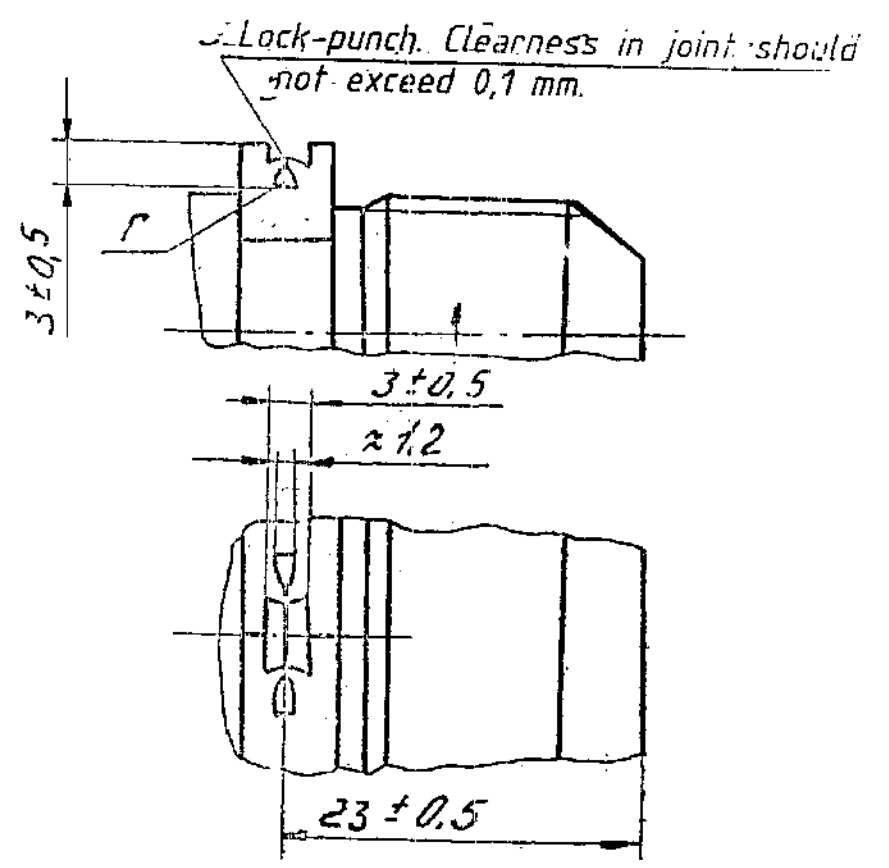
1. Alternate material is steel 45, GOST 1050-74.
 2. Unspecified limit deviations of dimensions are as follows: For holes - as per A₇; For shafts - as per B₇.
 3. Radial run-out of surfaces A and B with respect to the angle diameter of corresponding threads should not exceeding 0,1mm (qualifid tolerance).
 4. A step in hole B not exceeding 0,5mm is allowed.
 5. Coating: Zinc-plated, 9 microns thick, chromatized. Remove hydrogen embrittlement. Do not check coating in hole.
 6. Rod with diameter of at least φ1mm, should pass through hole F.
- Ⓐ EQUIVALENT MATERIAL: STEEL 20 C 8, Gr. 1, IS: 9550-80.
- Ⓑ EQ. MATERIAL: A. STEEL AS IS: 72 B 4-74 (MATERIAL AS PER IS: 226-75)
B. STEEL AS 20 C 8 TO IS: 9550-80
- Ⓒ EQ. MATERIAL: STEEL BAR C 20 OR C 25 Mn 75 TO IS: 2073-70
- Ⓓ ALT. MATERIAL: STEEL BAR C 45 TO IS: 2073-70



Alternate 1



Alternate 2
172:1



00806-ICV NEW 14-9-2000	Ⓒ	EQ. MATERIAL AND ALTERNATE MATERIAL ADDED
00635-ICV 14-9-98	Ⓑ	STEEL AS IS: 72 B 4-74 (MATERIAL AS PER IS: 226-75) STEEL AS 20 C 8 TO IS: 9550-80 ADDED
00625-ICV 30 MAR 98	Ⓐ	STEEL 20 C 8, Gr. 1, IS: 9550-80 ADDED AS EQUIVALENT MATERIAL (1/98 No. A)
DATE	ISSUE	NATURE AMENDMENT

APPROVED		765-84-77	
CHECKED		PIPE UNION	
CONTROLLERATE OF INSPECTION (ICV)		WEIGHT	SCALE
		0.095	1:1
		SHT	SHTS
		20 OCT 1050-74	

10-48-502

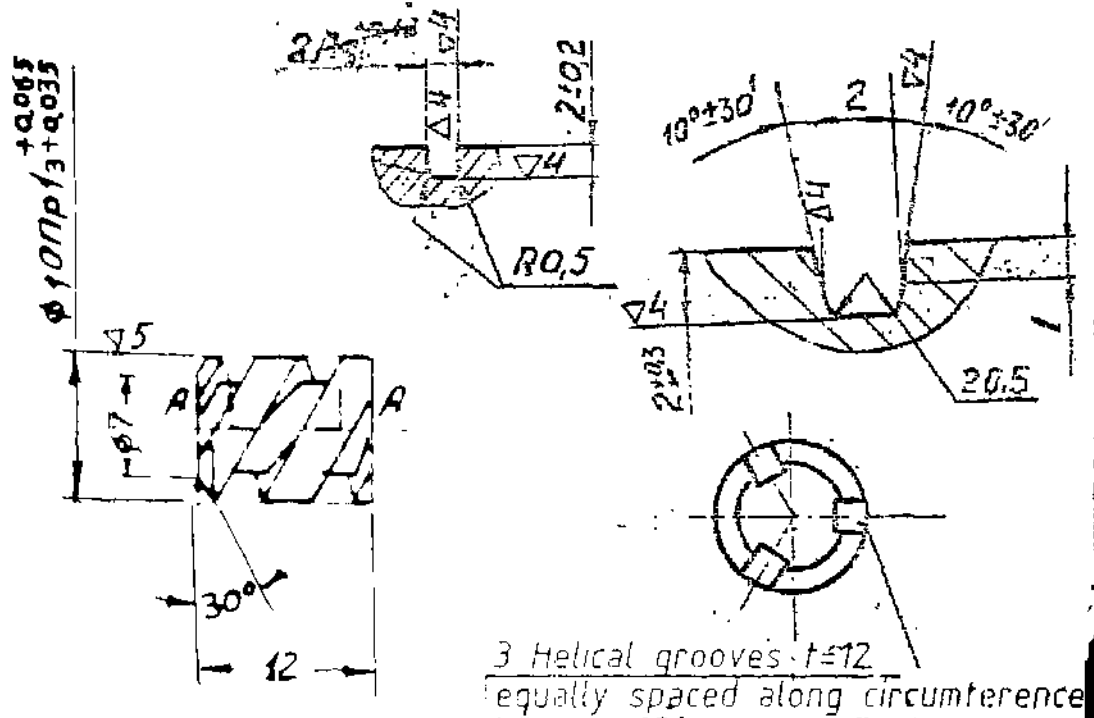
A-A

Unless otherwise specified

A-A

Alternate

M5.7



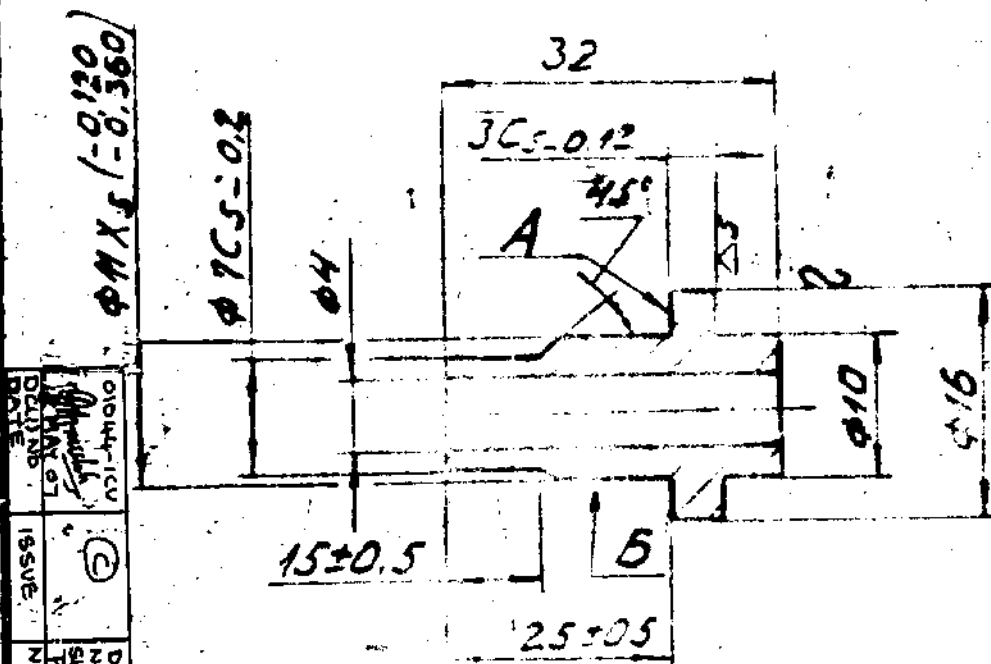
- 1) Blunt sharp edges (A) EQUIVALENT MATERIAL STEEL 04Cr18Ni10 IS: 6603-72 (B) EQ MATERIAL: STAINLESS STEEL BAR 04Cr 18Ni 10T; 20 TO IS 1570 (PART-V)-72
- 2) Provide dimensions without deviations as per accuracy class 7, OST 1010
- 3) Alternate material is 20x23H18 and 12x18H10T GOST 5632-72

00806 N 11 4.2000	(B)	EQUIVALENT MATERIAL ADDED
00625-1CV 9.20	(A)	STEEL 04Cr18Ni10 ADDED AS EQUIVALENT MATERIAL (1/98 NOFA)
30 MAR 98	Qm	
DEC. NO	ISSUE	NATURE
DATE		AMENDMENT

APPROVED	M VASU	765-84-81		
CHECKED	S. Kumar		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ILV)		SWIRLER	0.007	2:1
			SHT	SHTS
		12X18 HST GOST 5632-72		

765-84-83

▽3 Unless otherwise specified.



EQ. MATERIAL ADDED.	EQ. MATERIAL ADDED.
00806-ICV (B)	00806-ICV (B)
149.2000	00625-ICV
30 MAR 88	30 MAR 88
DATE	DATE
ISSUE	ISSUE
NATURE	NATURE
AMENDMENT	AMENDMENT

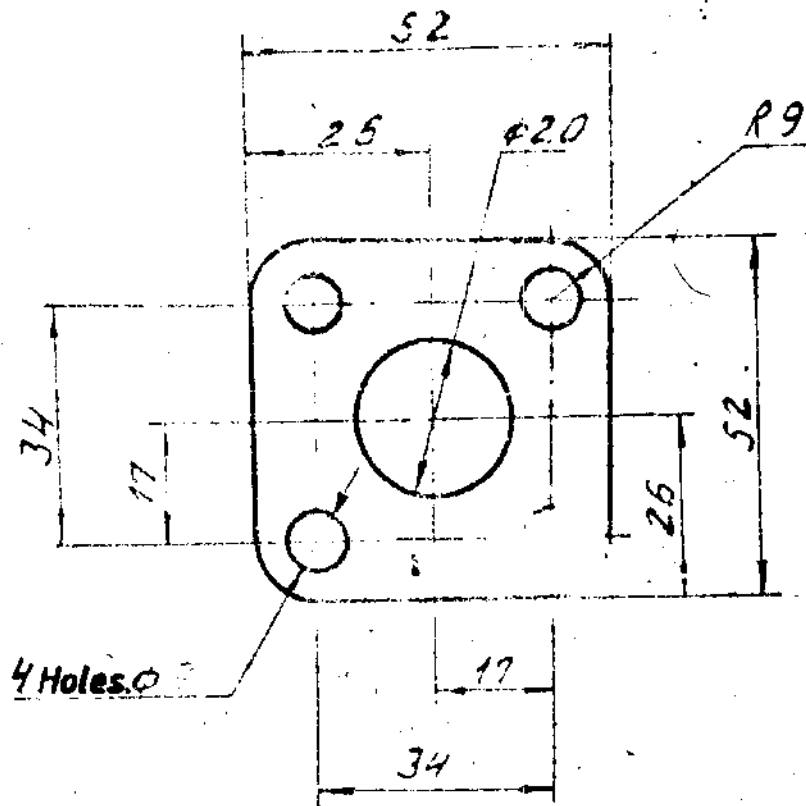
1. Blunt sharp edges.
2. Provide dimensions without deviations as per accuracy class 7, OST 1010.
3. Non-squareness of surface A with respect to surface B should not exceed 0.1 mm over a length of 25 mm.

① EQUIVALENT MATERIAL: STEEL 20 C8 Gr1, IS: 9550-80

② EQUIVALENT MATERIAL: STEEL BAR C20 OR C25 Mn75 TO IS: 2073-70

APPROVED	M VASU	DS CAT NO: LV2/10VS 5365-145357
CHECKED	Schuman	765-84-83 ©
CONTROLLERATE OF INSPECTION (ICV)	SPECER SLEEVE END PIECE ©	WEIGHT SCALE
		0.012 2:1
	20 GOST 1050-74	SHT SHTS

06-48-99L

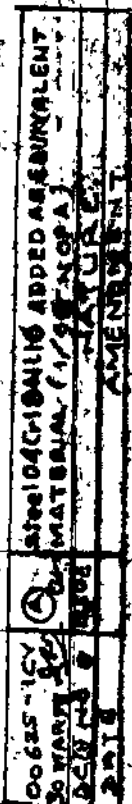


1. Provide dimensions without deviations with an accuracy of ± 0.5 .
2. Displacement of axes of holes from true position should not exceed 0.25 mm.

X 183
52

APPROVED	PI VASU	765-84-90	
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF INSPECTION (ICV)		GASKET	
		WEIGHT	SCALE
		0.003	1:1
		SHT	SHTS
		ASBESTOS STEEL SHEET JA-1.175 GOST 12856-75	
		560F173	

73 Unless otherwise specified.



- line.
 (B) EQUIVALENT MATERIAL - STAINLESS STEEL TUBE BAR 04-C-18N; 10T; 2D
 TO IS: 1570 (PART V) - 72

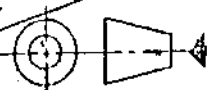
1. BLUNT SHARP EDGES.
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS OF SURFACES TO BE MACHINED ARE AS FOLLOWS: FOR SHAFTS-AS PER B7, HOLES-AS PER A7, OTHERS-AS PER CM7. OTHER REQUIREMENT FOR FORGING ARE AS PER ACCURACY CLASS II GOST 7505-74.
3. RUN-OUT OF SURFACE **B** WITH RESPECT TO THE ANGLE DIAMETER OF THREAD **T** SHOULD NOT EXCEED 0.15MM (QUALIFIED TOLERANCE).
4. LOCAL RECESSES NOT EXCEEDING 1MM ARE ALLOWED ON UNMACHINED SURFACES.
5. RUN-OUT OF SURFACE **B** WITH RESPECT TO THE ANGLE DIAMETER OF THREAD **A** SHOULD NOT EXCEED 0.1MM (QUALIFIED TOLERANCE).
6. DENTS WITH DEPTH NOT EXCEEDING 0.3MM ARE ALLOWED ON SURFACES **D** AND **E**.
7. COATING ZINC-PLATED, 9 MICRONS THICK CHROMATIZED. CHECK THE DIMENSIONS BEFORE COATING. ABSENCE OF COATING IN HOLES IS ALLOWED.
8. ALTERNATE MATERIAL IS STEEL 35 AND 40, GOST 1050-74.
9. A CUT NOT EXCEEDING 0.5MM IS ALLOWED ON SURFACE **K**.
10. THE BODY MAY BE MADE AS PER CONVENTIONAL DOTTED LINE.
11. THE BODY MAY BE MADE BY PRECISION INVESTMENT CASTING IN THIS CASE.

CASTING IN THIS CASE.

- A) UNSPECIFIED RADIIT SHOULD NOT EXCEED R1.
- B) PATTERN DRAFTS SHOULD NOT EXCEED 1°
- C) ROUGHNESS OF SURFACES NOT TO BE MACHINED IS Rz $\checkmark_{40}$
GOST 2789-75
- D) OTHER REQUIREMENTS ARE AS PER OST 3-4365-79.
- E) CASTING DEFECTS ARE NOT ALLOWED ON SURFACES K AND
M ON SECTIONS L AND M AND ON SURFACE B.
- F) MATERIAL IS CASTING I-OST 3-4365-79. ALTERNATE MATERIAL
45H-GOST 977-75

IS CASTING FROM STEEL 40L, 40X, L, GOST 977-75

① EQUIVALENT MATERIAL: Steel 45 C8.15:2004-78 Class 4
② ALTERNATE MATERIAL:- (i) C45, C50 OR 40 C71 TO IS: 5517-69

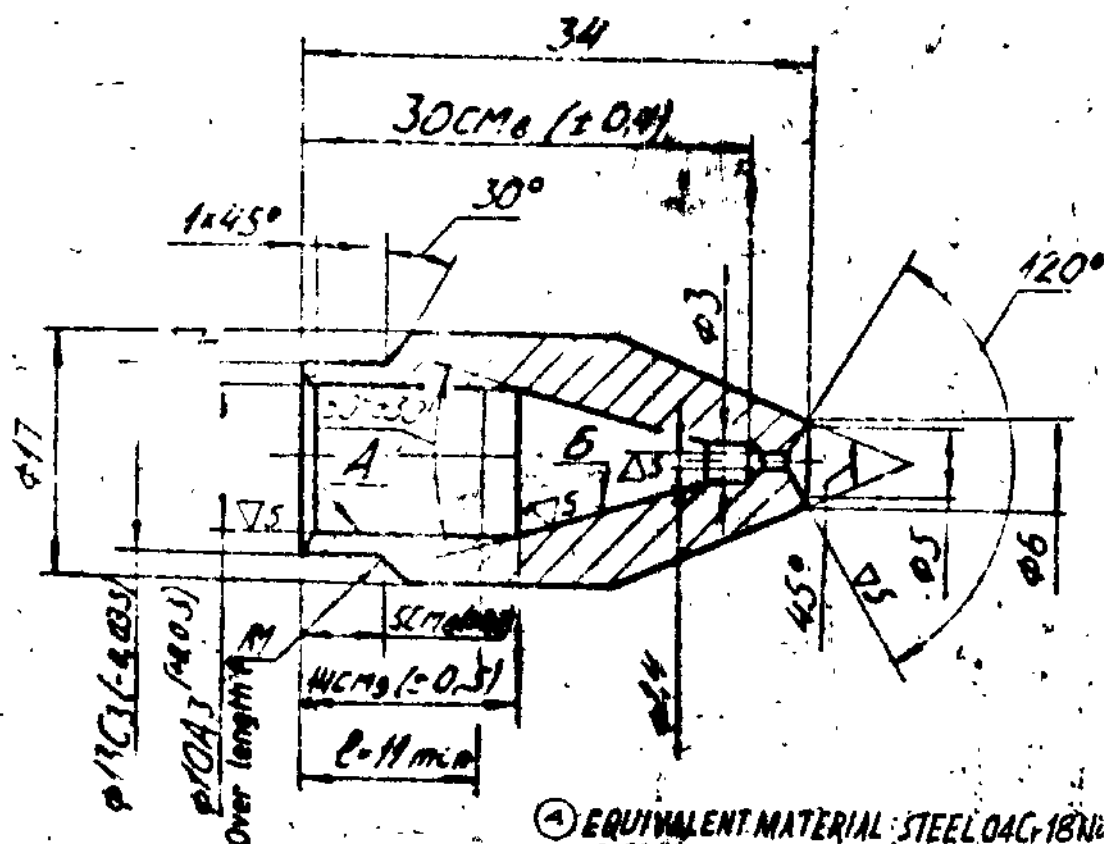
45 GOST 1050-74		00818 -ICV N4 11-10-2000 00625 -ICV 30 MAR 90 DECISION & DATE	② ① ② ③ ④ ⑤ ⑥ ⑦ ⑧ ⑨ ⑩ ⑪ ⑫ ⑬ ⑭ ⑮ ⑯ ⑰ ⑱ ⑲ ⑳ ㉑ ㉒ ㉓ ㉔ ㉕ ㉖ ㉗ ㉘ ㉙ ㉚ ㉛ ㉜ ㉝ ㉞ ㉟ ㊱ ㊲ ㊳ ㊴ ㊵ ㊶ ㊷ ㊸ ㊹ ㊺ ㊻ ㊼ ㊽ ㊾ ㊿	ALTERNATE MATERIAL ADDED.
MATERIAL		ISSUE	AMENDMENTS	
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.		ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON:-
SCALE:- 1:1				765-84-CD 181
DATE :- 2/1-1-92				
DRN. 800000 WT.:- (Kg)				
TCD 800000 0.14				
CHD 800000				
APD. 800000				
		BODY		
		765-84-131		
CONTROLLERATE OF QUALITY ASSURANCE				
58 OF 173 (INFANTRY COMBAT VEHICLES)				

THE ABERMATIONS AND SYMBOLS ARE
BASED ON RUSSIAN SPECIFICATIONS
ALL DIMENSIONS ARE IN MM

765-84-184

▽3/▽1

STEEL 04C18N10 ADDED AS EQUIVALENT MATERIAL. (1/98 Note)		NATURE AMENDMENT
00625-1CV	30 MAR 98	ISSUE
DATE	ISSUE	DATE



① EQUIVALENT MATERIAL: STEEL 04C18N10
15:6603-72

1. Alternate material is 20x23H9T and 12x18H10T, GOST 5632-72.
2. Unspecified limit deviations of dimensions for holes are as per - A₇, for shafts+ as per B₇.
3. Misalignment of surface B with respect to surface A should not exceed 0.2 mm
4. Individual tool marks on surface A are allowed.

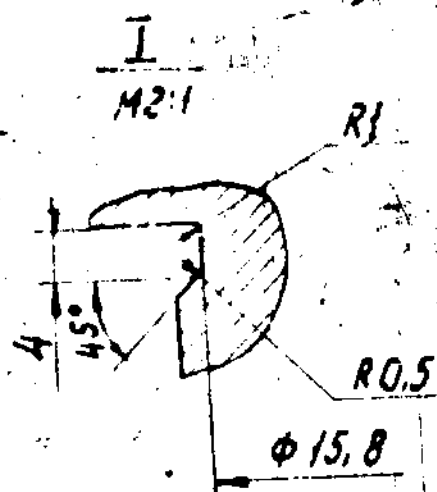
② EQ. MATERIAL: STAINLESS STEEL BAR 04CY18N10Ti 20:10:15:15Ti (PART V) T2

00818-1CV	③	EQUIVALENT MATERIAL ADDED
11-10-2000	Amr	
DC(1) NO DATE	ISSUE	NATURE OF AMENDMENTS.

APPROVED	R R PARWATKAR
CHECKED	Sharma
CONTROLLERATE OF INSPECTION (ICV)	

765-84-184	
INJECTOR	
12X18H9T GOST 5632-72	
WEIGHT	SCALE
0.03	2:1
SHT	SHTS

▽3 (▽)

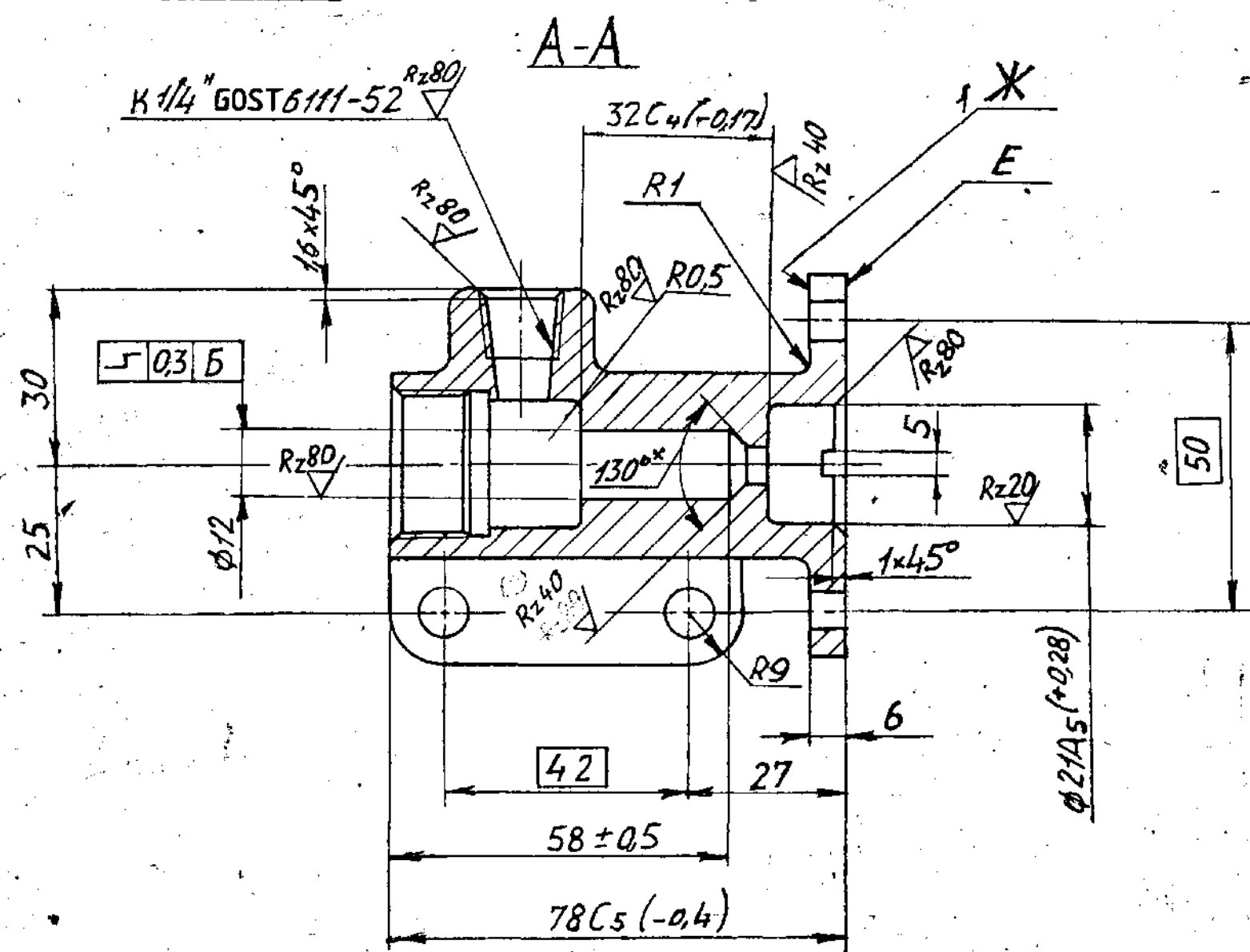
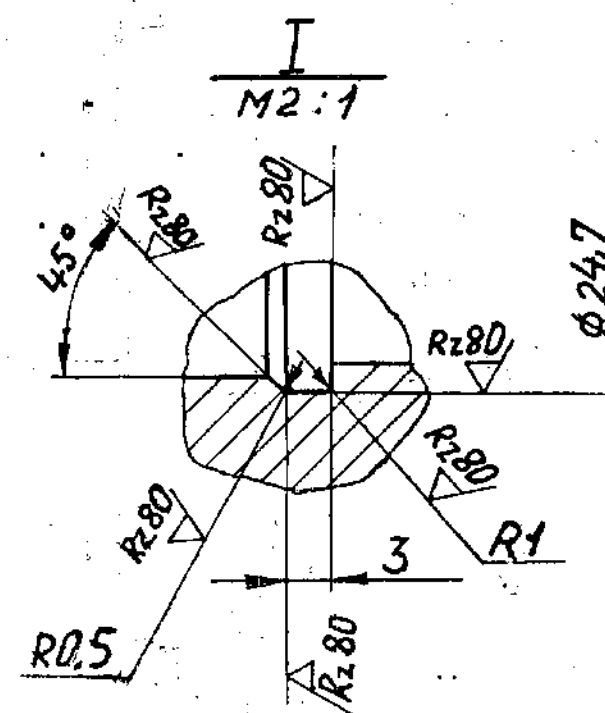
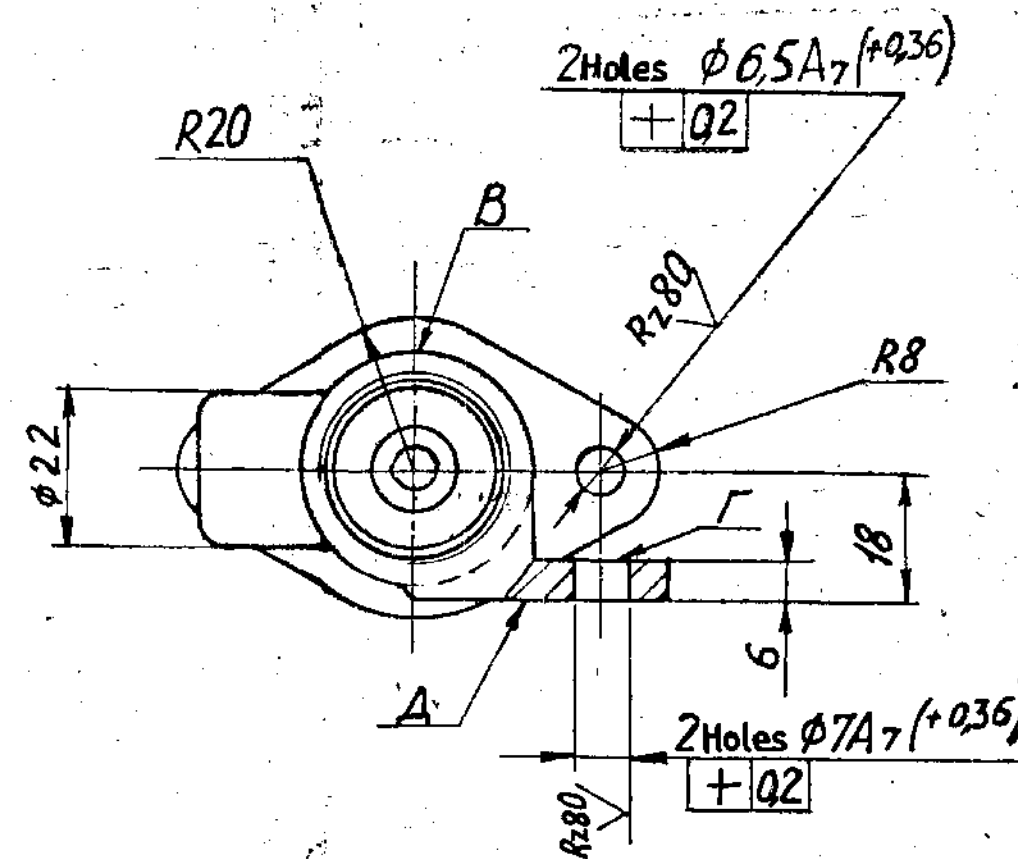
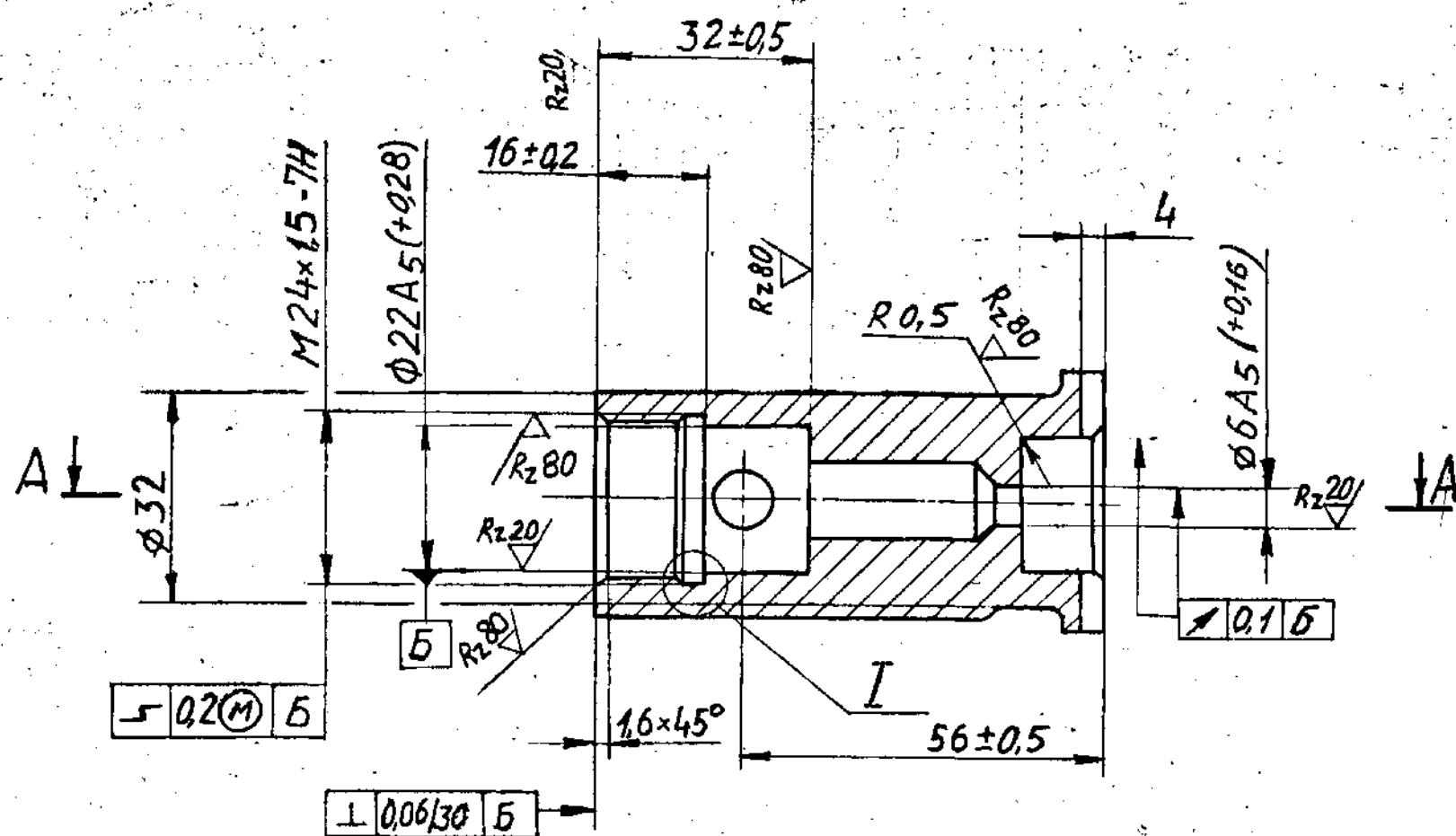


000818 1-16 N-152 11/1/50	② Crim	EQ. MATERIAL ADDED.
00625-16 1-16 30m ad 98	③ Crim	MATERIAL STEEL 20C8G1 IS: 9550-80 ADDED AS EQUIVALENT MATERIAL.
DCU NO	ISSUE	NATURE
DATE		AMENDMENT

1. Unspecified limit deviations of dimensions are as follows. For holes - as per A7, Shafts - as per B7.
 2. Run-out of surfaces B and B with respect to the angle diameter of the corresponding threads should not exceed 0.1 mm (Qualified tolerance)
- ④ EQUIVALENT MATERIAL: STEEL 20CrGr 1.15: 9550-80
- ⑧ EQUIVALENT MATERIAL: STEEL BAR C20 OR C25 Mn75 TO IS: 2073-70

X18

APPROVED	2 M VASU	765-84-191	
CHECKED	<i>Sumay</i>	ADAPTER	WEIGHT
			0-11
CONTROLLERATE OF INSPECTION (ICV)		20 GOST 1050-74	SHT
			SHTS
			60 OF 173



1. Unspecified casting radii should not exceed 2 mm.
2. Pattern drafts should not exceed 2°. On surface Ж pattern drafts should not exceed 3°. Drafts are not allowed on surfaces Г, А, Е.
3. Provide unspecified limit deviations of dimensions for casting with an accuracy of ± 0.5 mm.
4. Pusher traces to a depth not exceeding 0.5 mm may be present on surfaces of В, Г and А.
5. Other requirements for casting are as per Technical Requirements TTA-436.
6. Unspecified limit deviations of dimensions obtained by removing a layer of metal are as follows:
for holes - as per А₇, for others - as per CM₇.
7. Coating: Anodically oxidized, chromated.
8. After machining inner cavities are checked for tightness with kerosene under a pressure of 1 kg/cm² for 5 minutes. Leakage and sweating are not allowed.
9. * Dimension is given for reference.
10. Inner cavity after machining may be checked for tightness in unit 765-84-cd210, in compliance with item 2 of Technical Requirements TT 2.

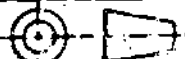
⑧ EQ. MATERIAL :- GRADE 4450 TO IS- 617-75.

① EQ. MATERIAL: Gdr 4450 TO IS:617 'M' CONDITION OR
GRADE LM 25 'M' CONDITION TO BS:1490-88

00806-11V MAY 2 1968 (A) 9.8000	(B) Cyan	EQ MATERIAL ADDED.
1 Ramo DC(I) 00640-11V 19. 6. 9.8	Cyan (A)	EQ. MATERIAL ADDED.
DC(I) NO 8 DATE	ISSUE	NATURE
AMENDMENT		

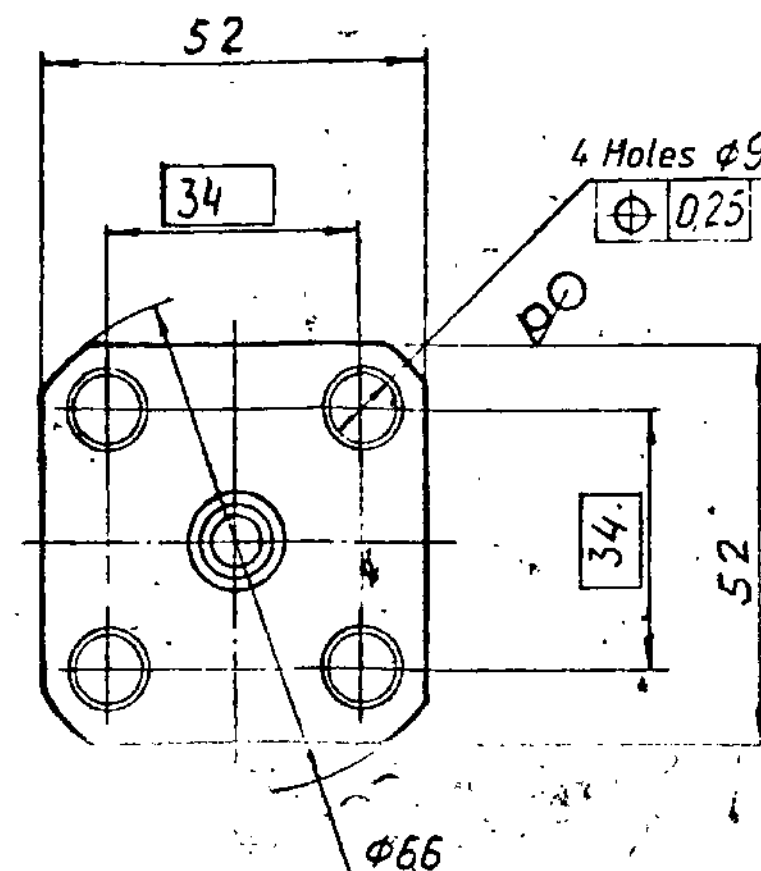
MATERIAL -- A99 G05T 2685-75		ALL SHARP EDGES & CORNERS TO BE BOUNDED OFF		ALL THREADS TO CONFORM TO SPECIFICATION		STAMP OR ETCH. PART NO. MANUFACTURERS NAME & YEAR OF MFR.	
PROC. NOT TO BE SCALED		SCALE :- 1:1		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON:-	
DATE :- 77.95.		DRN. <i>[Signature]</i>		BODY		765-84-210	
TC. <i>[Signature]</i>		WT - INCH 0.16					
RD. <i>[Signature]</i>		① →					
APD <i>[Signature]</i>							
CONTROLLERATE OF QUALITY ASSURANCE							
(INFANTRY COMBAT VEHICLES)							

- | | | |
|-----------|------------|--------------|
| SCC) | <i>Gen</i> | ED. MATERIAL |
| 00640-KV | (A) | ADDED. |
| DOJ NO. 2 | ISSUE | NATURE |
| DATE | AMENDMENT | |

MATERIAL: CASTING		OCT 3-4365-79/35A GOST 977-75	
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF		ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH PART NO. MANUFACTURERS NAME & YEAR OF MFR.
LARG. NET TO BE SCALED		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:
SCALE: 2:1		PIPE UNION	
DATE: 7.7.95			
DRN. <i>M. G. G. G.</i>	WT: 1 kg	765-84-211	
TCD <i>M. G. G. G.</i>	0.045		
CHD <i>M. G. G. G.</i>			
APP. <i>B. G.</i>			

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

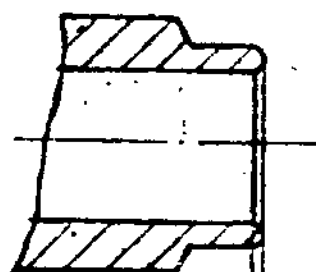
R280 ✓ (✓)



- 1) Alternate material is steel 12x18H9T GOST 5632-72.
- 2) Unspecified limit deviations of dimensions of machined surfaces are as follows , For holes as per A₇, Shafts as per B₇.
- 3) Surface defects on surfaces to be machined should not exceed 1,0 mm.
- 4) Other requirements for forging are as per accuracy class II GOST 7505-74.

⑧ EQ. MATERIAL: - ROUND BAR 04 Cr 18 Ni 10 Ti 20 TO IS: 1570 (PART-V) -72.

I
Scale 2:1



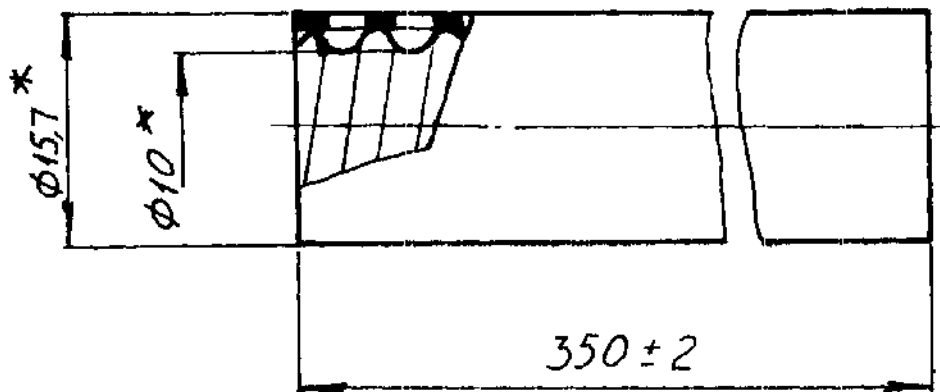
0.5x45°
2 Chamfers

✓ Remove	Gr in	EX. MATERIAL ADDED.
DCU. 00640-1CV 19-6-69	(A)	
DCU NO. & DATE	ISSUE	NATURE
AMENDMENT		

APPROVED	M VASU	765-84-216		DS CAT No. LV2/ICV 4730-067716
CHECKED	<i>Schuman</i>	FLANGE PIPE	WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)		© FLANGE	0.2	1:1
		ROUND B40 GOST 2530-71 BAR 12x18 GOST 5632-72	SHT	SHTS

01013-1CV <i>1388</i>	00806 -1CV	(C)	DS CAT NO. ADDED & NOMENCLATURE WAS "CHANGE"
19-01-06		(B)	EQ. MATERIAL ADDED.
DEC/1/NO	14-8-2000	<i>Un</i>	NATURE OF AMENDMENTS

765-84-217



1. Alternate material is air-tight loss, PFC 8A 0,449.118-10.
2. Other requirements are as per 8A 0449.117TY.
3. * Dimensions with (*) are given for reference.

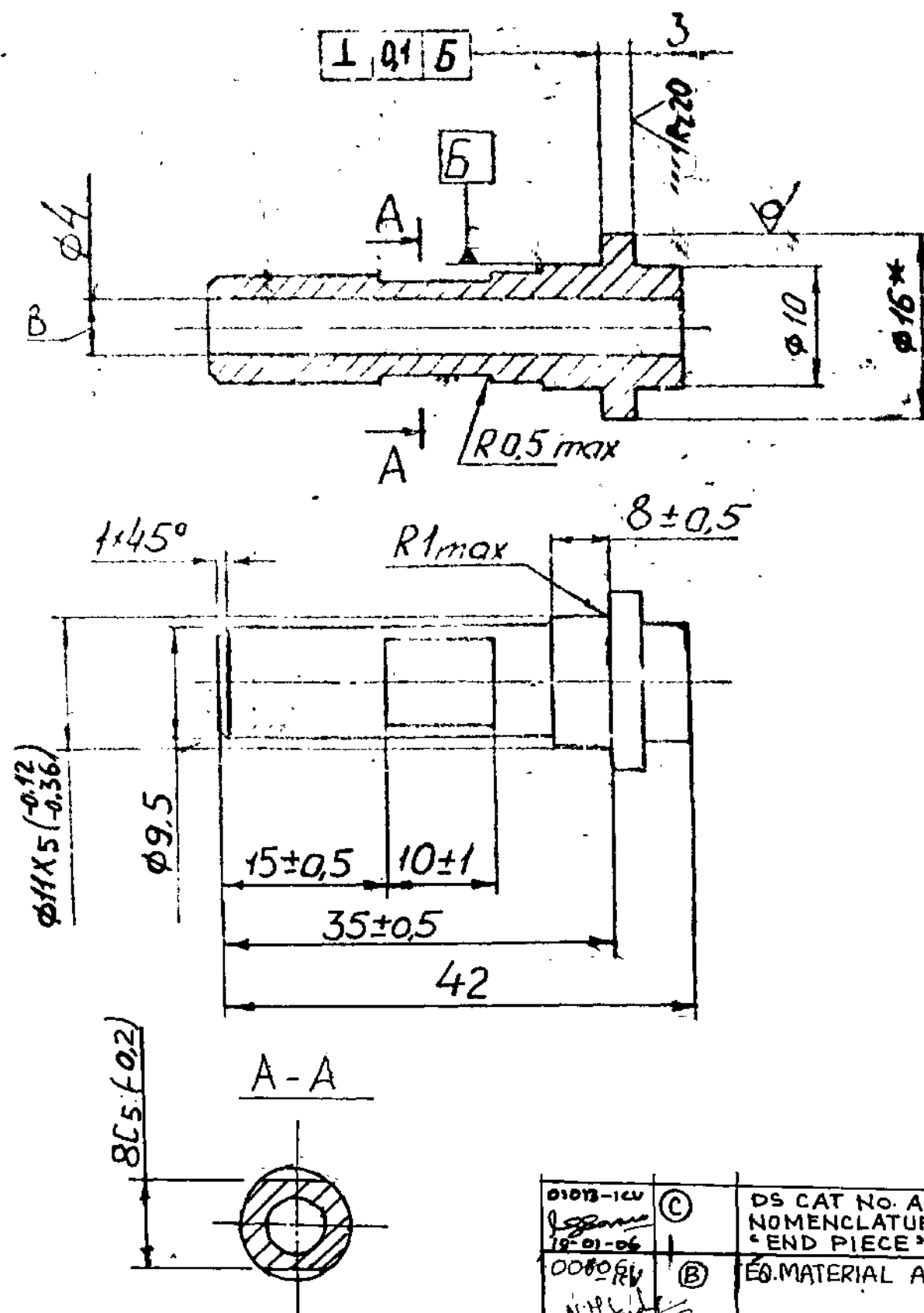
01013-ICV 19-01-06 DC (1) NO. & DATE	(A)	DS CAT NO. ADDED
ISSUE		AMENDMENTS

MATERIAL - METALLIC HOSE 8A 0.449.117-02		
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
ORG. NOT TO BE SCALED		
SCALE :- 2:1	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-
DATE :- 10.7.95		
DRN. <i>Shukla</i>	WT :- (Kg) 0.12	HOSE
CD. <i>Shukla</i>		
HD <i>Shukla</i>	DS CAT No. LV2/ICV5 4720-009994 (A)	765-84-217
APD <i>Bm</i>		

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

765-84-218

R280
✓(✓)



1. Unspecified limit deviations of dimensions are as follows
for holes-as per A7, for shafts-as per B7.
2. Step not exceeding 0.5mm is allowed on dimension B.
3. * Dimension with (*) is given for reference.

4. **EQ. MATERIAL:- STEEL 20 C8 TO IS: 9550-80 Gr1.**
EQ. MATERIAL:- STEELBAR C 20, C 25 Mn75 TO IS: 2073-70

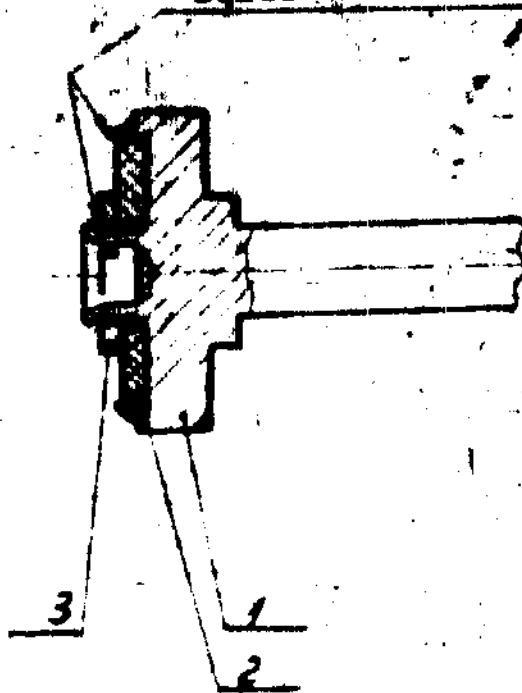
01013-12V 19-01-06	(C)	DS CAT NO. ADDED & NOMENCLATURE WAS 'END PIECE'
00608V N.H. 14.9.2000	(B)	EQ. MATERIAL ADDED.
00635-1V V. R. 01-6-98	(A)	STEEL 20 C8 TO IS: 9550-80 Gr1. ADDED AS EQ. MATERIAL
02(1) No DATE	ISSUE	NATURE AMENDMENT

MATERIAL :- ROUND BAR - 16-5 GOST 7417-75 / 20-B GOST 1051-73.		
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED	SCALE :- 2:1	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED
DATE :- 10.7.95.	WT :- (Kg) 0.02	BUSHING SLEEVE SPECIAL (C) END PIECE
DRN: <i>Dr. K. S. S.</i>	ICV: <i>ICV</i>	DS CAT NO. LV2/ICVS 3120-101774
CHD: <i>Chd</i>	APD: <i>Apd</i>	765-84-218 (C)

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

765-84-c5132

Squeeze



Do not check washer for turning.

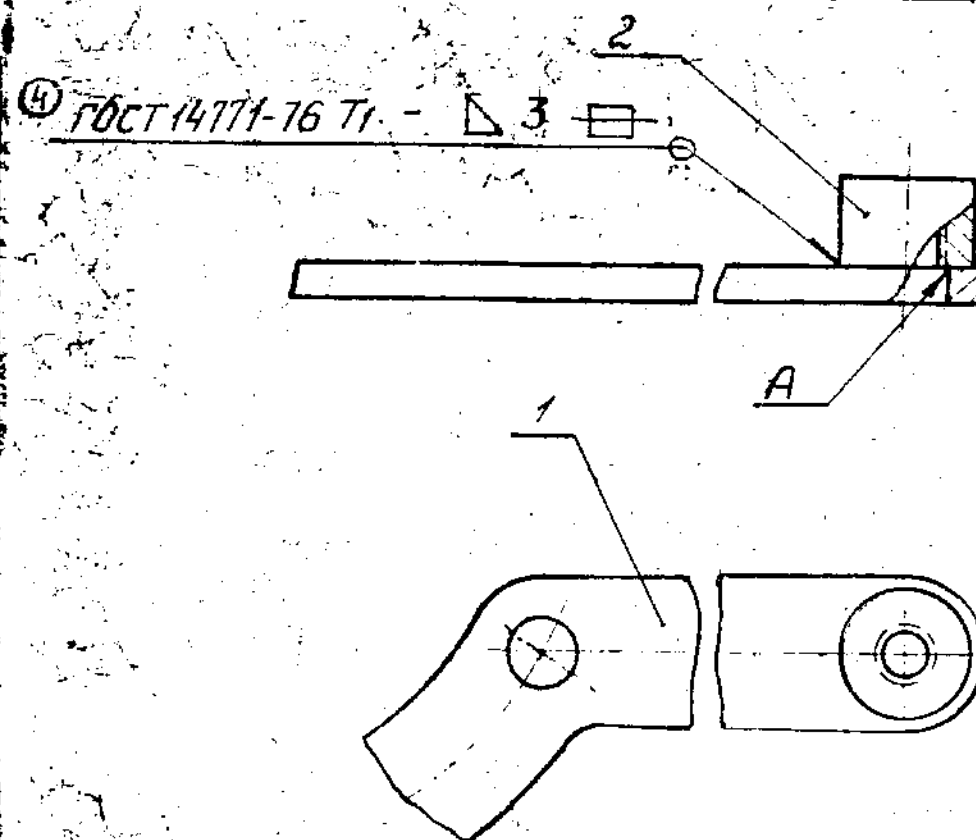
X183
3

765-84-c5132

S.No.	Designation	Description	Qty	Remarks
3	700-31-602	Washer	1	
2	765-84-54	Ring	1	
1	765-84-53	Plunger	1	

APPROVED	R R PARVATKAR	765-84-c5132		
CHECKED	<i>Sn h mar</i>	PLUNGER	WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (IEV)			0.04	2:1
			SHT	SHTS

765-84-60



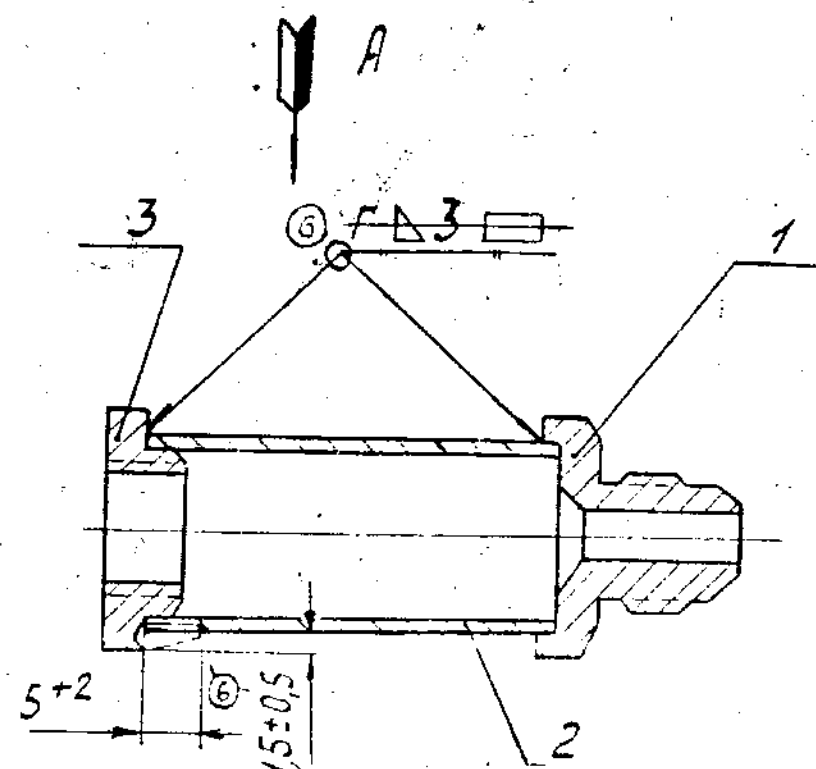
00823-ICV	(B)	EQ. MATERIAL ADDED FOR REF. NO:2.
24.10.2000	Cur	
00069-ICV	(A)	SPECN. No. 053.252 89.00002 ADDED IN PLACE OF SPECN. No. 041-1626 IN NOTE No. 3.
9-3-89	ISSUE	NATURE
DC(1) No. & DATE	AMENDMENT	

- 1) Dress after welding.
- 2) Displacement of axis of hole of surface A with respect to axis of thread should not exceed 0,5 mm.
- 3) Coating : Chemically parkerized, accelerated chromitized, oiled with preserving oil K-17 GOST 10877-76 as per
 - (A) Spec. 053.252-89.00002 or with varnish K0-815 GOST 11066-74.
 - (B) EQ. MATERIAL: C-20 81C-25 Mn75 TO IS: 2073-70

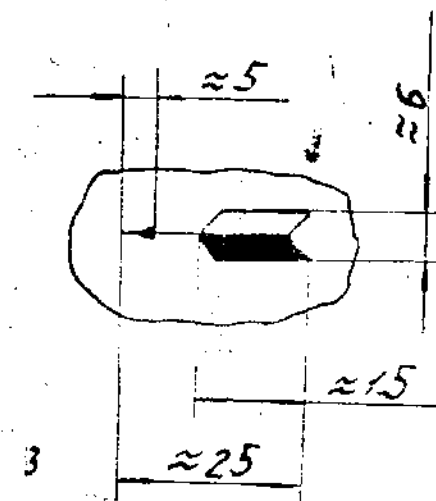
Ref. No.	Designation	Description	Qty	Remarks
1	765-84-60	Bracket	1	
2	4368-0812 (B)	m8x16x12 Boss OST 3-1496 -72 varnish K0-815 or lubricant K-17.	1	

APPROVED	M VASU	765-84-c6133	
CHECKED	<i>Shkumar</i>	BRACKET	WEIGHT
CONTROLLERATE OF INSPECTION (ICV)			0.08
		SHT	SHTS
		84	24 OF 173

765-84-59L



VIEW A



Ref.No.	Designation	Description	Qty.	Remarks
1	765-84-61	Union	1	
2	765-84-62	Pipe	1	
3	700-30-406 NUT SLOTTED HEXAGONAL		1	Ref. DC 13 NO 010 23 -165V
		Bakelite varnish grade ЛБс-1, red enamel nφ-223.		

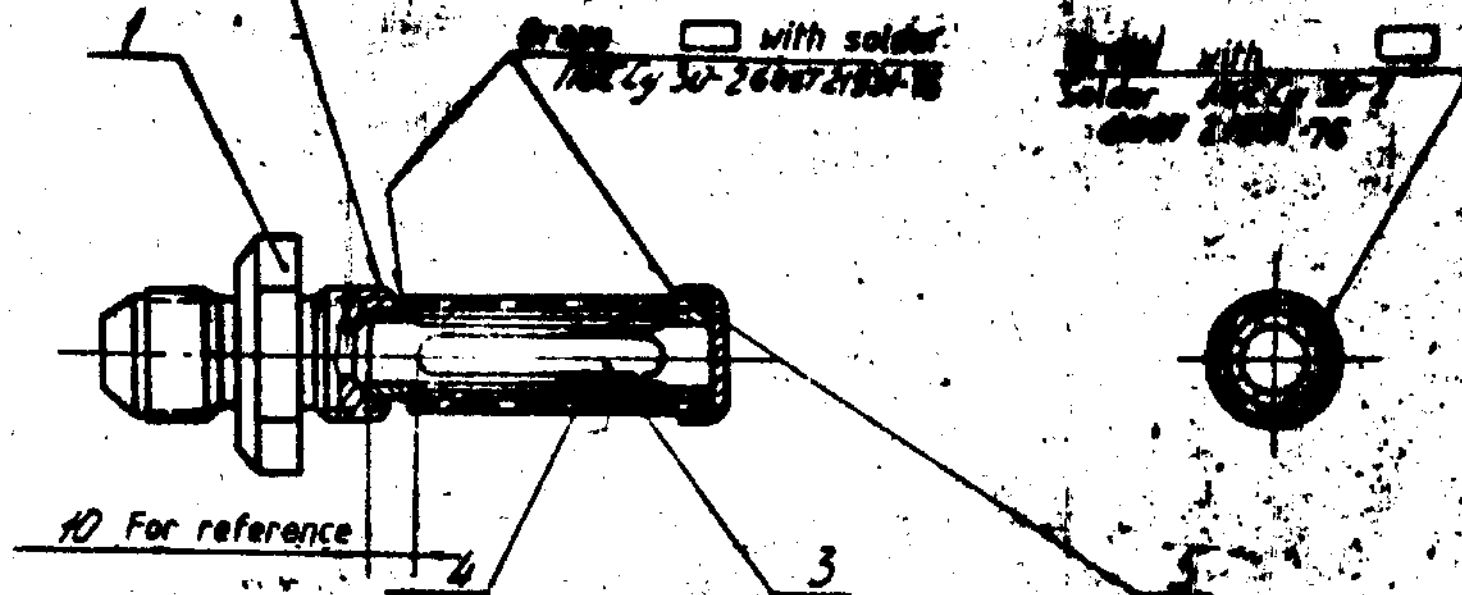
- 1) Use hydrostatic test with summer oil Л-0,5 or winter oil 3-0,5 GOST 305-73 at pressure of 15 kgf/cm² for one minute.
- 2) Leakage and sweating are not allowed at the places of joints.
- 3) Coating: zinc-plated, 9 microns thick, chromatised.
- 3) Inner surfaces may be free from coating.
- 4) Check thread after welding.
- 5) Apply bakelite coat on inner surface of casing in two layers with bakelite varnish of grade ЛБс-1, GOST 901-78 as per instruction 05325273.000.10...
- 6) On surface of pipe Ref. No. 2, apply arrow with red enamel nφ-223 GOST 14923.

- 7) Test for air tightness at pressure of 15 kgf/cm² in water bath for 0,5 minute.
Leakage is not allowed.
- 8) Rolls and splashes due to welding are not allowed on The outer surface of hexagonal section.
- 9) Use gas welding. Alternate to gas welding is gas shielded electric arc welding

MATERIAL		
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON
SCALE - 1:1		
DATE - 10.7.95		
DRN. [Signature]	WT - 1kg	
TCD. [Signature]	0.093	
CHD. [Signature]		
APD. [Signature]		
		CASING
		765-84-c5146
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)		

765-84-c8 147

Soldering ☐ A-63
GOST 15527-70



1. Distortion of coating is allowed at places of brazing.
Neutralize acid, wash thoroughly and check thread.

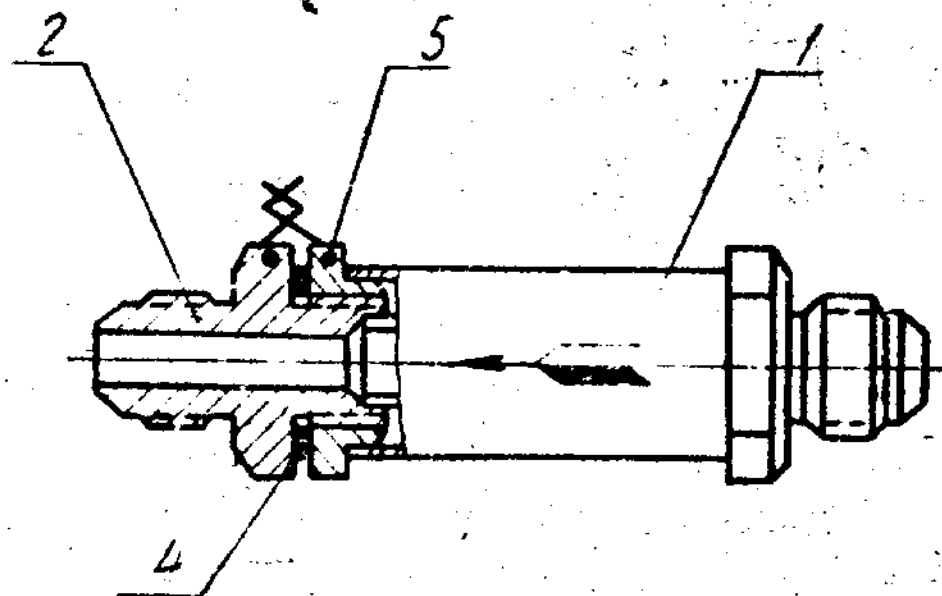
- (A) EQ. MATERIAL FOR SOLDER A-63 :- GRADE BA CU Zn4-15: 2927-75
(ii) EQ. MATERIAL FOR SOLDER IToccy 30-2: GRADE Sn 30 Sb-15: 193-82.

		Solder A-63 GOST 15527-70		
5	765-05-75	Bottom	1	
4	765-05-74	wire net	1	
3	765-05-73	Bushing sleeve Standard fastener	1	REF. D. 1025-12V
2				X183
				6
1	765-84-75	Pipe Union	1	
REF. NO.	DESIGNATION	DESCRIPTION	QTY	REMARKS

000-KV W41 10-2000	(A)	EQ. MATERIAL ADDED
DESIGN No. DATE	ISSUE	NATURE OF AMENDMENTS

APPROVED	K VASU	765-84-c8 147	
CHECKED	Sukumar		
CONTROLLERATE OF INSPECTION (ICV)		FILTER	WEIGHT SCALE 0.06 1:1
			SHT SHTS 26 OF 173

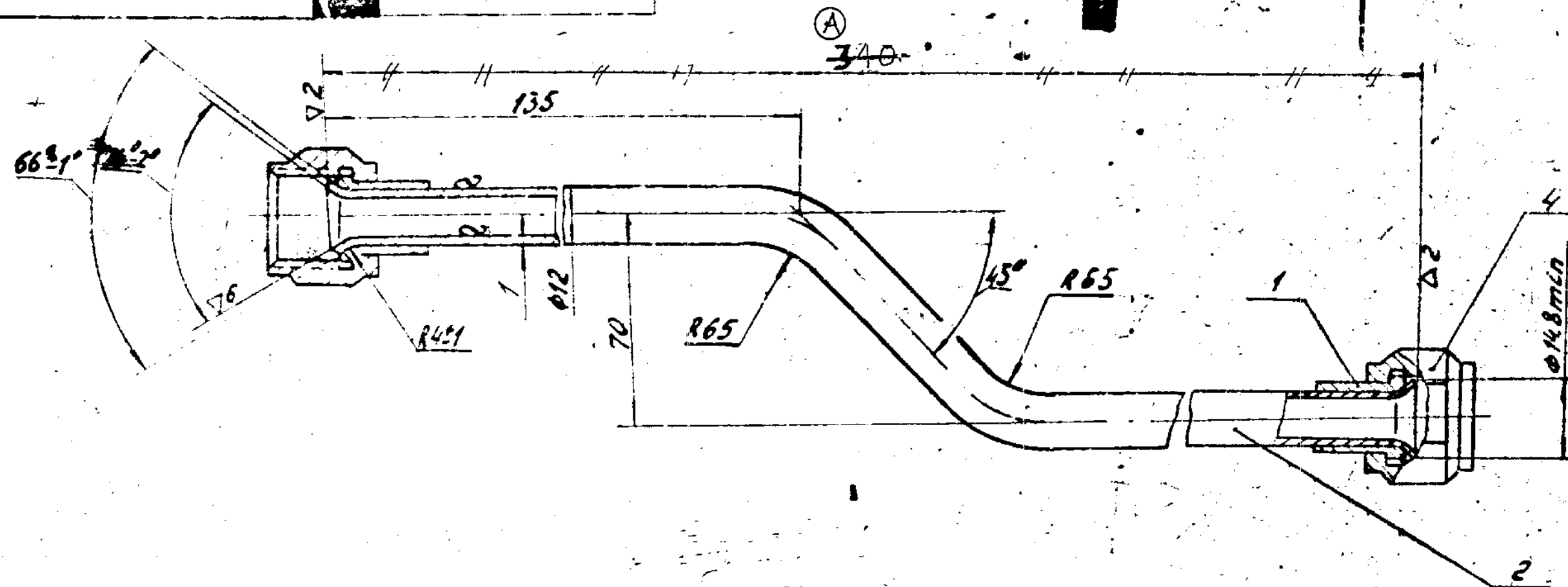
84/90-48-59L



- 1). Wash filter after assembly with summer oil $\Pi-0.5$ or winter oil $\Pi-0.5$ GOST 305-73 and blow off air.
- 2). Testing is allowed with air pressure 15kg/cm^2 in water bath for 0.5 minutes. Leakage is not allowed.
- 3). Pressure test with summer oil $\Pi-0.5$ or winter oil $\Pi-0.5$ GOST 305-73 at pressure 15kg/cm^2 for one minute. Leakage at places of joints is not allowed.
- 4). After assembly wash filter in benzine-solvent GOST 3134-78 or in benzine GOST 8505-80, used for industrial purposes on special stand and blow-off air.

REF. NO.	Designation	Description	Qty	Remarks
5	Wire	K01 GOST 792-67 l=100	1	
4	700-40-197	Gasket	1	
3				
2	765-84-cb147	Filter	1	
1	765-84-cb146	Casing	1	

APPROVED	IN VISA	765-84-cb 148		
CHECKED	<i>Sulman</i>			
CONTROLLERATE OF INSPECTION (ICV)		FILTER	WEIGHT	SCALE
			0.2	1.5
			SHT	SHTS
			27 OF 173	



1. Part, Ref. No. 2 should be made of pipe $\frac{12 \times 1 \text{ GOST } 8734 - 75}{\text{B10 GOST } 8733 - 74}$

Weight should be 0,092 in this: Ovality and corrugation at places of bending should not exceed 12mm.

2. Perform dimensions without deviation with accuracy of ± 1 to 100 and ± 2 above 100.
 3. Coat inner surface of pipe with varnish ГФ-95 GOST - 8018-10 as per instruction HA-09-73.
 4. It is allowed to bend pipe and to make dimensions more precise as per standard made in situ.
 5. Wash pipe in benzine. Immediately after washing, ends of pipe should be stopped with the purpose of preservation of inner surfaces from impurities during transportation and storage.
 6. Test for air-tightness at pressure 15 kg./cm^2 in water bath for 0,5 minutes.
 7. Appearance of air bubbles is not allowed.
 8. Test for air tightness with summer oil А-0,5 or winter oil Б-0,5 GOST 305-73 at a pressure 15 kg/cm^2 for 2 minutes is allowed.
- Leakage and sweating are not allowed.

- 9 Prime externally, except locating surface and nipples, surfaces under nipples, threads with primer $\phi 1 - 03 + \text{K}$ GOST 9109-81 and paint with yellow enamel $n\phi - 223$ GOST 14923-78.
10. Presence of paint on nipples and under nipples is permissible.

- (A) 11. Length of the pipe Ref. No. 2 in bending condition should be ≈ 325 mm.

should be ≈ 325 mm.
 (B) EQUIVALENT MATERIAL: CDS-240, IS: 3601-84 (For Ref No 2)

00625-1CV 88A	(B)	EQUIVALENT MATERIAL CDS-240.15:3601-84 ADDED FOR 765-84-213 (K98 NQFA)
30 MAR 92	Cur	
00077-1CV	(A)	DIMENSION 340 DELETED NOTE NO. 11 ADDED. W/D ADDED IN REMARKS COLUMN.
7 -89		
DC(T) NO & DATE	ISSUE	NATURE
AMENDMENT		

		Bakelite varnish		
		Enamel nφ -223 yellow		
		Primer φλ -03-		
	LV2/ICV5 5510-181923			
4	700-33-4 ✓	Trion Nut Nut Slotted Hexagonal	2	REF. DC(I) 01023-1CV
3				
3	765-84-213 ✓	Pipe	1	X183 w/d (A)
1	765-84-6 ✓	Nipple	2	
		Description	Qty	Remarks

APPROVED	M VASU	765-84-c5161	
CHECKED	<i>S. Kumar</i>		WEIGHT SCALE
CONTROLLERATE OF INSPECTION (ICV)			0-185 17.1
		SHT	SMTS
		28 OF 173	

A technical drawing of a mechanical assembly in cross-section. The drawing shows a central vertical shaft (1) passing through a housing. At the top, there is a cap screw (7) securing a cover plate (5). A pin (6) is shown passing through the cover plate and the housing. A spring (9) is located inside the housing, pushing against a plunger (4). The plunger is connected to a lever arm (10) which is pivoted on a pin (11). The lever arm has a rectangular block (8) attached to its end. The housing is shown in cross-section with diagonal hatching.

- 1) Press valve seat with ball so that continuous band along whole circumference of seat edge is obtained.
- 2) Adjust valve for separation of ball at a pressure of 1,0 to 1,2 kgf/cm² by changing quantity of washers Ref. No. 9.
- 3) Lock plug, Ref. No. 7, after adjustment.
- 4) Subject to hydrostatic test with summer oil π -0,5 or winter oil 3-0,5 GOST 305-73 at pressure of 15 kgf/cm² (A) for one minute (supply oil from the side of outlet union). Leakage at places of joints is not allowed.
- 5) Test "T" joint with ball for leakage by pouring summer oil π -0,5 or winter oil 3-0,5 GOST 305-73, for 3 minutes. Leakage from under the ball is not allowed.

EQ. MATERIAL: i) GRADE 10 C4 TO IS: 1570-79, REF-NO: 9
ii) GRADE 15 C4 TO IS: 1570-79,

⑧ EQ. MATERIAL:- MILD STEEL WIRE, GALVANIZED SOFT DRAWN OF 1/4 HARD TO IS: 280-78 WITH U.T.S. 37 kg/mm² min (REF. 10).

EQ. MATERIAL: C-30 TO 15:1570-79

Ref No	Designation	Description	Qty	Remarks
1	765-84-131	Body	1	
2				
3				
4	700-38-7	Spring	1	
5				
6	700-40-237	Gasket	1	
7	730-84-78 LVA/ICV 5365-010770	Plug screwed	1	REF. Doc(1) NO. 00993-ICV
8				
9	Washer 6x1-01-019 or 6x1-02-019 GOST 11371-78			Max 5
10	Wire K01-GOST 792-67 l:200		1	
11	Ball 5V 11 MMH GOST 3722-60 and ETY 500-		1	Commercial

(A)

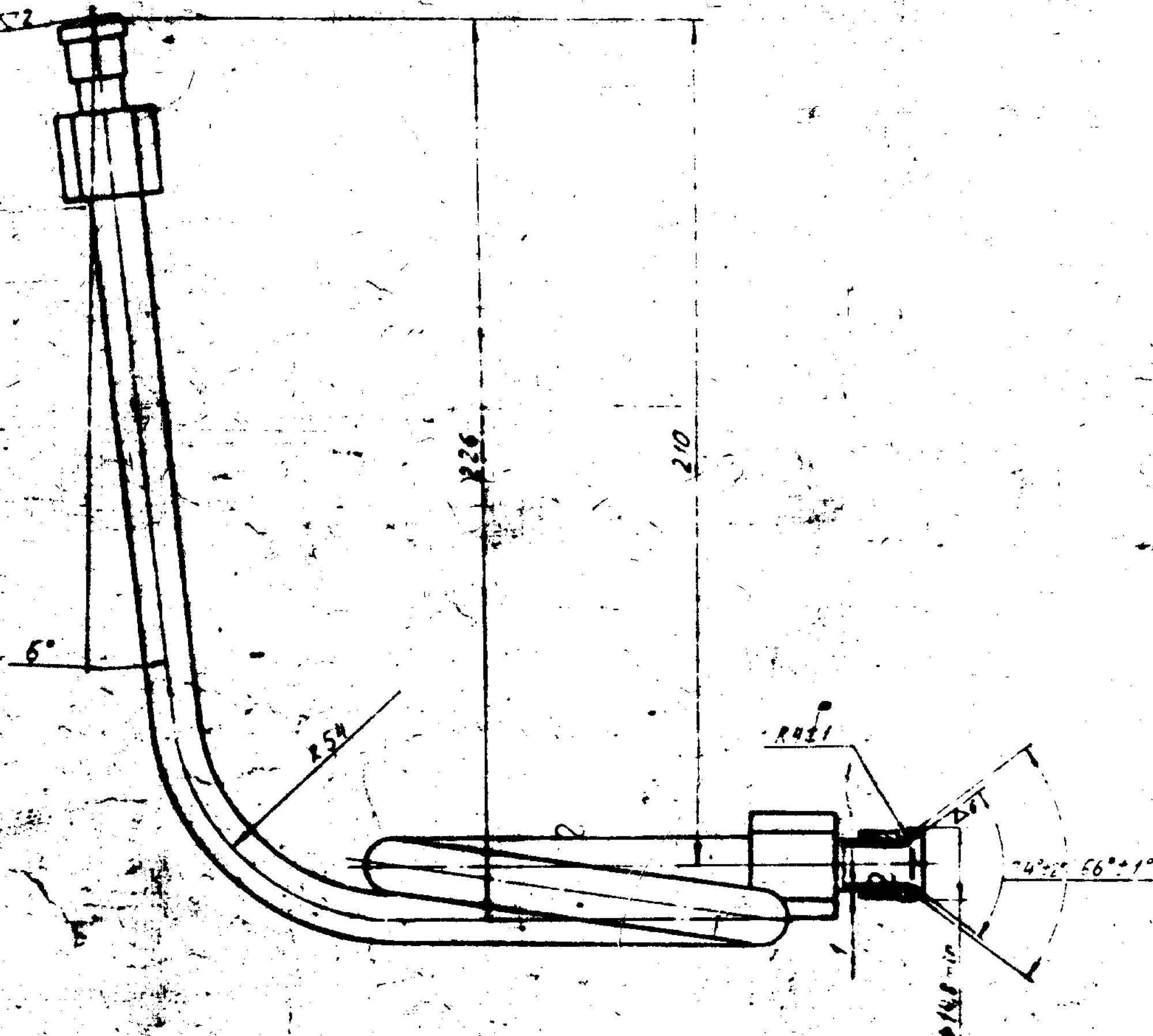
Ref. No.	Designation	Description	Qty.	Remarks
1	765-84-131	Body	1	
2	700-38-7	Spring	1	
3	730-84-78	Plug	1	
4	700-40-237	Gasket	1	
5	Wire K01, GOST 792-67, $\varnothing = 200$ Washer 6x1,01,019 or 6x1,02,019 GOST 11371-78.		1	max. 5
6	Ball 6 $\varnothing$ 11 MMH, GOST 3722-60 and ETY 500-65.		1	Commercial

009571 10/1/1964	(C)	EQ. MATERIAL ADDED
80-6-03 00839-16	(B)	EQ. MATERIAL ADDED FOR REF NO: 9 & 10.
not by 80-12-2000	Curran	NATURE OF AMENDMENTS
DCONO 12911F		

82/5	A	11-5-8
No	ISSUE	DATE
AMENDMENTS		

~~183~~

APPROVED	M VASU	765-84-c6 181	
CHECKED	<i>Enhuman</i>		
CONTROLLERATE OF INSPECTION (ICV)	VALVE	WEIGHT	SCALE
		0-23	(2)
		SHT	SHTS
		29 OF 173	

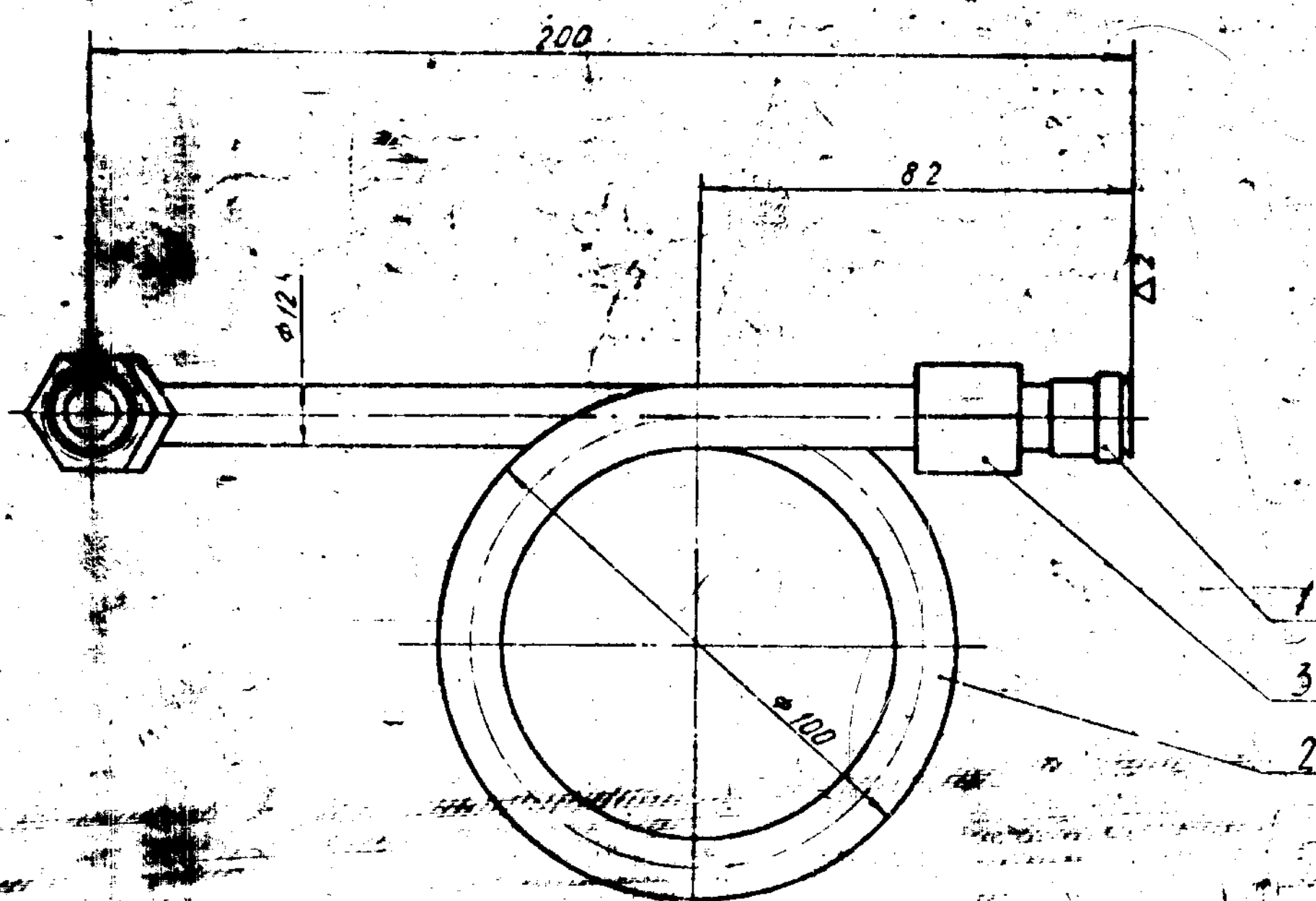


1. Provide dimensions without deviation with ± 1 accuracy at a length of upto 100 and ± 2 beyond 100.
2. Coat external surfaces, except mating surfaces thread nipples and surfaces under nipples with yellow primer $\Phi J-03$ Ж GOST 9109-80, and paint them with yellow enamel $\Phi J-223$, GOST 14923-78, no paint is allowed on nipples and under nipples.
3. It is allowed to bend pipe, dimensions should be accurately checked by a standard made in situ.
4. Wash pipe in benzine GOST 8505-80, for industrial purposes. Immediately after washing, ends of pipe should be plugged or to protect internal surfaces from dirt during transportation and storage.
5. Test for tightness under an air pressure of 15 kg/cm^2 in a water bath for 0.5 minute. Air bubbles is not allowed.

Test for tightness with summer oil, $J-05$ or winter oil, $J-0.5$ GOST 305-73 under a pressure of 15 kg/cm^2 for 2 minutes. Leakage and sweating are not allowed.
6. Part, Ref.2, is made of pipe $\frac{12 \times 1 \text{ GOST } 8734-75}{B-10 \text{ GOST } 8733-74}$. Weight 0.141. In this case:
 - a). Ovality and corrugation at places of bending should not exceed 1.5 mm.
 - b). Traces caused by bending tool are allowed.

Test for tightness with summer oil, 1-05 or winter oil, 3-05 GOST 305-73 under a pressure of 15 kg/cm² for 2 minutes. Leakage and sweating are not allowed.

6. Part, Ref.2, is made of pipe: 12x1 GOST 8734-75
B-10 GOST 8733-74.
Weight 0.141. In this case:
a) Ovality and corrugation at places of bending should not exceed 1.5 mm.
b) Traces caused by bending tool are allowed.
7. Coat inside surface of pipe with varnish ГФ -95,
GOST 8018-70, as per instruction МЛ -09-73.
- (A) EQUIVALENT MATERIAL: CDS-240.15:3601-04 (For Ref.2)
(B) EQUIVALENT MATERIAL: STEEL TUBE CDS-2 OR CDS-10 IS: 3074-79
FOR DRG.No.365-04-214.

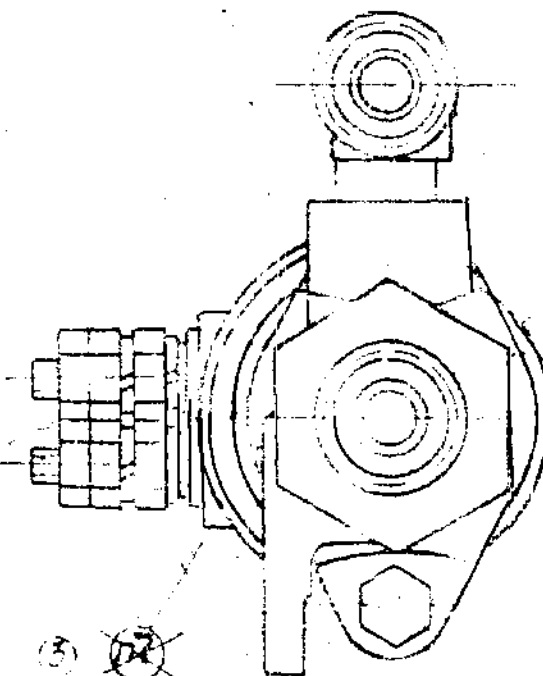
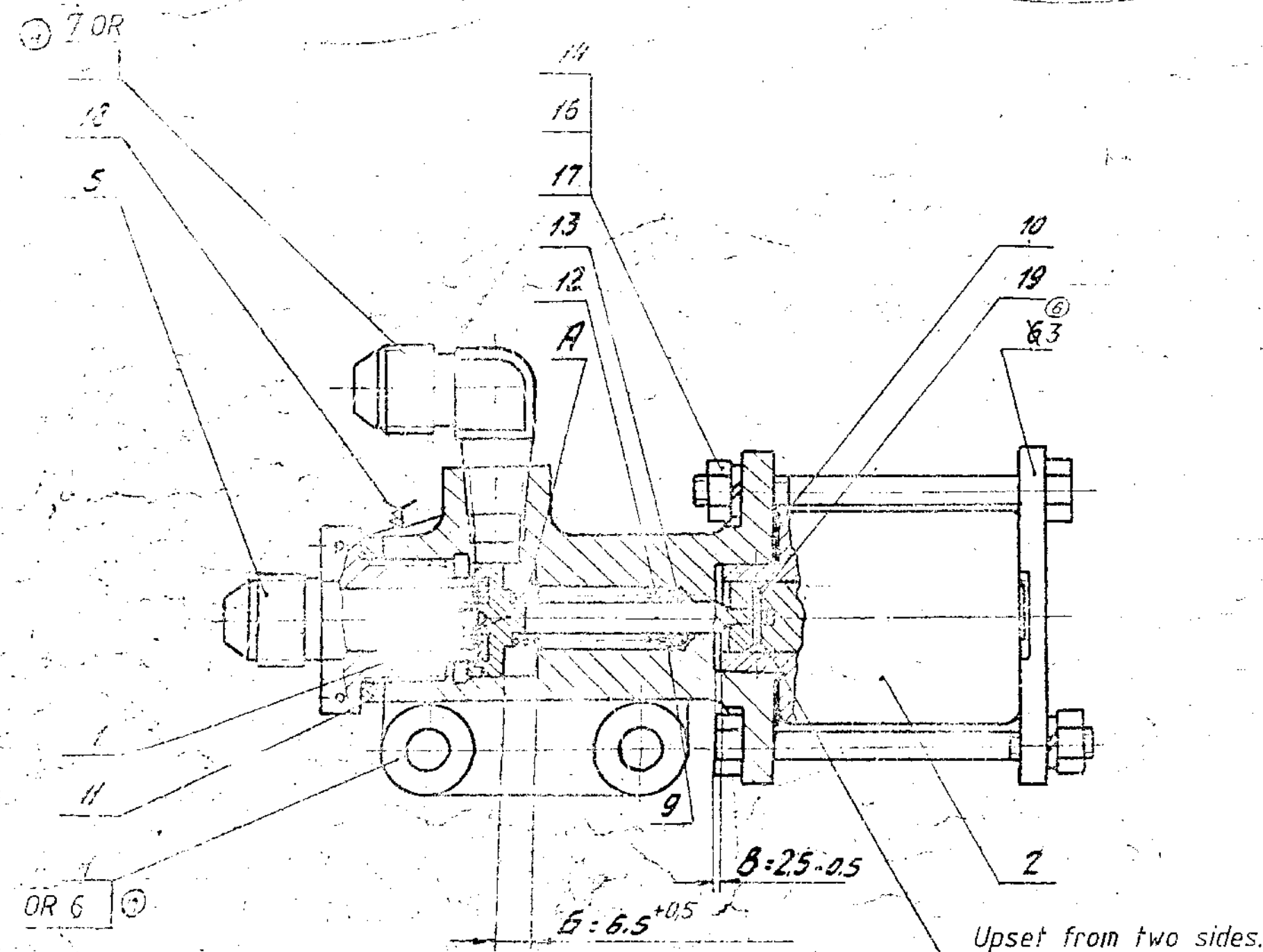


00818-11V	(B)	EQUIVALENT MATERIAL ADDET REF ID: A62
- N/A 11-10-2000	CN	
00625-1CY	(A)	EQUIVALENT MATERIAL REF ID: A62 3601-BA 165-84-MK (1708 NOT)
30MAY98	CN	
DECL NOT	10SUB	NATURE AMENDMENT

			Bakelite varnish	
			Enamel 700-800	
			Primer 6/1-2-X	183
3	700-33-4	LWZ/ICV9 5310-1B1923	Union	5310-1B1923
2	765-84-216		Pine	
1	765-84-5		Maple	
N/A	DESIGNATION		DESCRIPTION	

APPROVED	HI VASU	765-84-c6 182	
CHECKED	<i>Sakuma</i>		WEIGHT SCALE
☐ CONTROLLERATE ☐ OF ☐ INSPECTION ☐ (ICV)		PIPE	0-241 1:1
			SHT CHTS
			30 OF 173

01797-40-50



- 1). After assembly, plunger should slide freely without jamming, under the action of relay at a voltage of 24 ± 0.5 volts and spring Ref.12. Requirements for quality of electric power of stand are as per 765-c64 TY2.
- 2). Test valve for tightness with summer oil $\Lambda-0.5$ or winter oil $\Lambda-0.5$, GOST 305-73, under pressure of 0.3 kg/cm^2 . Supplied to union, Ref.No.3, for 3 minutes. Increase of oil into cavity A is not allowed. Test cavity A for tightness under a pressure of 1.5 kg/cm^2 for three minutes with union Ref.5, plugged (supply oil to union Ref.7) while testing jerk plunger rod 5 to 10 times. Leakage through joints is not allowed. Polishing of plunger rubber ring is allowed.
- 3). Adjust gap B with gaskets, Ref.No.10.
- 4). Adjust gap b by trimming ring Ref.11.
- 5). Place union, Ref.7 and 5, on iron minimum, GOST 8866-76.
- 6). During storage and transportation union should be plugged to exclude the ingress of dirt into internal cavities.

EQ. MATERIAL: (i) GRADE 25 CB - IS: 1570-79. } Ref.No:16
 (ii) GRADE 4-OCB - IS: 1570-79. }
 (iii) MILD STEEL WIRE, GALVANIZED SOFT DRAWN OR 1/4 HARD TO IS: 280-78 WITH UTS 37 kg/mm^2 (min). [Ref.No.18,19]

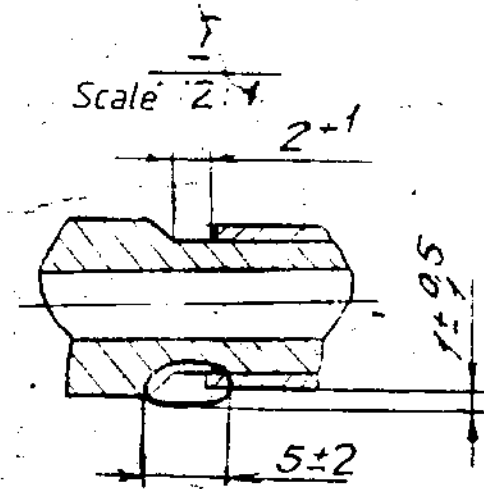
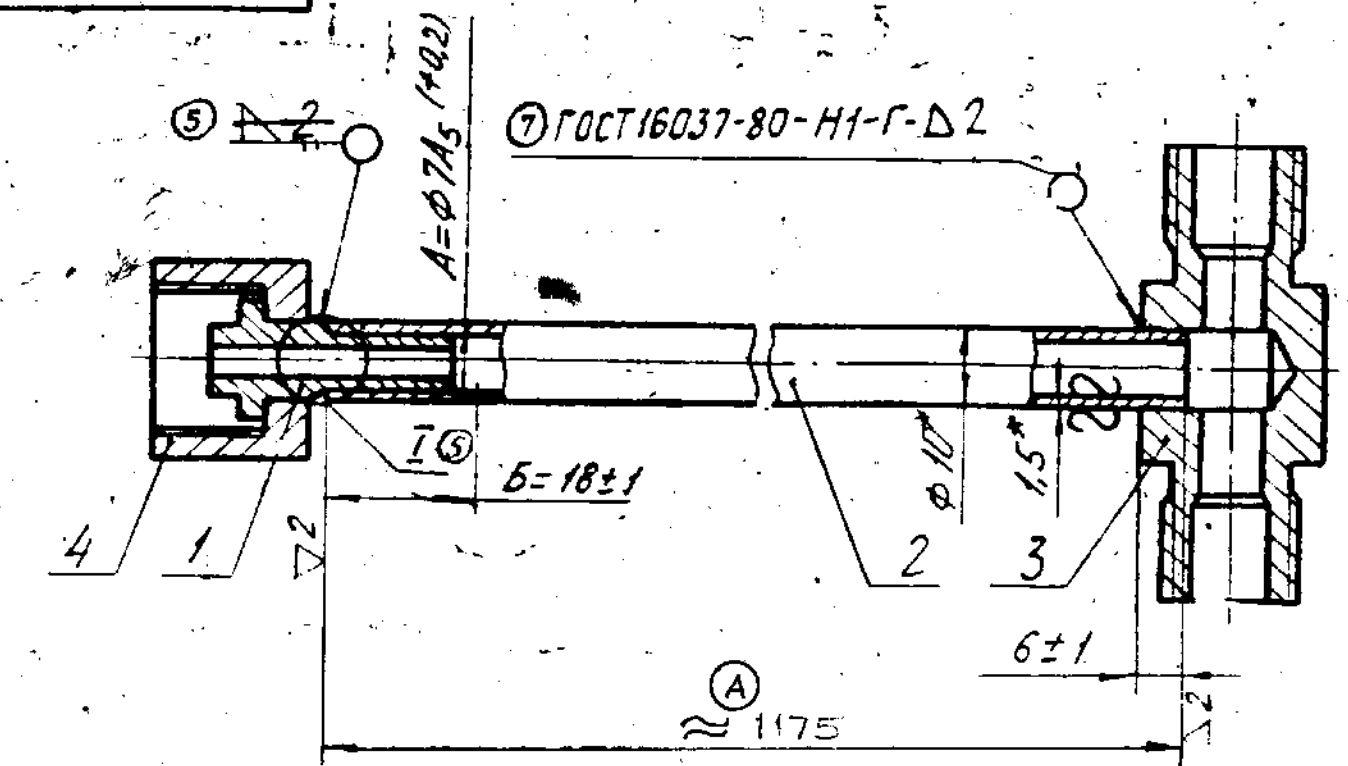
PP883	(B)	EQ MATERIAL ADDED FOR REF.NO: 16, 18, 19.
00548	(A)	DS CAT No ADDED AT REF 10
29-296		NATURE
ISSUE		AMENDMENT

2		Realy, PM6-1c 000Ty	1	
17	Washer, 5T65G, 06	GOST 6402-70	2	
16	Nut, M6.6.019	GOST 5927-70	2	
19	Wire, K02,	GOST 792-67 l=15	1	
18	Wire, K01,	GOST 792-67 l=200	1	
14	272-16-28	Bolt	2	
13	770-72-149	Sealing ring	1	
12	701-24-20	Spring	1	
11	700-42-153	Ring	1	
10	700-40-61 (A)	Gasket.		6 Maximum.
9	700-31-602	Washer	1	
8	765-84-211	Union		1 Piece may be replaced by Ref.No.7
7	765-84-59	Union	1	1 Piece may be replaced by Ref.No.8
6	765-84-210	Body	1	May be replaced by Ref.No.4
5	765-84-51	Union	1	
4	765-84-50	Body	1	May be replaced by Ref.No.6
3	765-71-364-01	Flange	1	
1	765-84-c6132	Plunger	1	
REF. NO.	DESIGNATION	DESCRIPTION	QTY	REMARKS.
ALL SHARP EDGES & CORNERS TO BE BOUNDED OFF		ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFG.	
DRC. NOT TO BE SCALED		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:	
SCALE: 1:1				
DATE: 7.7.95				
DRN: [Signature]			VALVE	
TOL: [Signature]			765-84c6210	
CHD: [Signature]				
APP: [Signature]				
CONTROLLER OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				

$\frac{8^3}{x} \cdot x$

APPROVED	M VASU	765-84-cb238		
CHECKED	<i>Su Kumar</i>	PIPE	WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)			SHT	SHTS
		84	32 OF 173	

765-84-0238C5



- 1) Made part, Ref. no. 2, from pipe 10x1,5 GOST 8734-75 B 20 GOST 8733-74. of mass 0,24 kg, in this case,
- a) Bend pipe and make dimensions more precise using standard made in situ. Radii of bend should be atleast R 25 mm along the axis of pipe,
- b) Ovality and corrugations at points of bending should not exceed 1,0 mm.
- c) Provide compensatory loop of $\phi \approx 50$ mm on the pipe along its axis.
- d) Scale is not allowed on the internal surfaces. For checking, pipes ^{from each batch} 1 to 2 may be cut in two.
- 2) Adjust the mutual position of parts as per standard made in situ.
- 3) Check dimension A over length B when necessary.
- 4) On the section between bead of tip, Ref. No. 1, and butt end of pipe Ref. No. 2, the joint should be dressed to flush with the external diameter of tip.
- 5) Use gas welding.
- 6) Perform hydrostatic test with summer-grade fuel Π -05 or winter grade fuel 3 - 05, GOST 305-73 at a pressure of 15 kgf/cm² for 2 minutes. Leakage at places of joint is not allowed.
- 7) Coat the external surfaces, except threads with enamel K0-813 containing vanish K0-815 GOST 11066-74 with the addition of 6 to 10 % of aluminium powder nAn - 1 or nAn-2 GOST 5494-71.
- 8) Wash the pipe with benzene after welding. Immediately after washing, the pipe ends should be stopped for protecting the internal surfaces from contamination during transportation and storage.

- 9) * Dimensions are given for reference.
- 10) Test for air-tightness may be carried out with air at a pressure of 15 kgf/cm² in water bath for 0,5 minutes. Appearance of air bubbles is not allowed.
- 12) Gas welding may be substituted by gas shielded electric arc welding.
- Ⓑ EQUIVALENT MATERIAL: CDS-240, IS: 3601-84 (For Ref no 2)
- Ⓒ EQUIVALENT MATERIAL: STEEL TUBE CDS-2 OR CDS-3 TO IS 3601-84.

00818-ICV	Ⓒ	EQ. MATERIAL ADDED FOR REF. NO. 2.
11.10.2000	Am	
00625-ICV	Ⓑ	EQUIVALENT MATERIAL- CDS-240, IS: 3601-84 ADDED FOR 765-84-190 (1/98 NOFA)
30 MAR 98	Am	
00078-ICV	Ⓐ	DIMENSION ≈ 1175 WAS $\approx .750$
-89		
DC(I) No & DATE	ISSUE	NATURE
AMENDMENT		

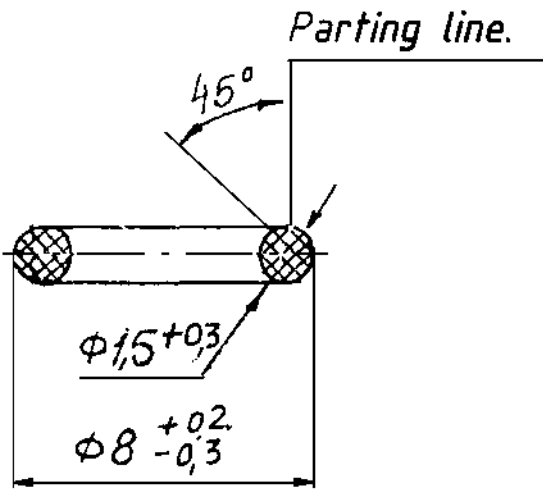
APPROVED	765-84-0238C5
CHECKED	
CONTROLLERATE OF INSPECTION (ICV)	PIPE (Assembly drawing)
	WEIGHT SCALE
	0.52 1:1
	SHT SHTS
	33 OF 173

cb, sh

APPROVED	<i>[Signature]</i> M VASU	765-84-c5253	
CHECKED	<i>[Signature]</i>	INJECTOR	WEIGHT
CONTROLLERATE OF INSPECTION (ICV)			SCALE
		SHT	SHTS

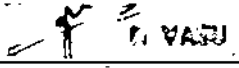
- 1) Solder should be ncp 40 or ncp 25 GOST 19738-74.
- 2) Use the gas shielded electric arc welding
- 3) Carry out test for air tightness in water bath by air at a pressure of 15 kgf / cm² for atleast 0.5 minutes. Air leakage is not allowed.
- 4) Check the injector for proper spray at a pressure of 3 to 4 kgf/cm² for 5 to 10 seconds. Fuel from the nozzle of the injector should come out in the form of cone of continous spray during the complete test period.
- 5) Before mounting, tin plate the ends of hose and parts , Ref No. 1, 3, with solder ncp 40 or ncp 25 GOST 19738-74 over a length of 6 to 8 mm.
- 6) Coat the external surfaces with enamel K0-813 containing varnish K0-815 GOST 11066-74 with the the addition of, 6 to 10% of aluminium powder nAn-1 or nAn-2 GOST 5494-74 except surface A.
- 7) Use welding wire 1 cb. 08x20H9Г7T GOST 2246-70.
- 8) Wash the injector with benzene GOST 3134-78 on special stand. Immediately after washing of pipe ends, they should be closed for protecting the internal surfaces from contamination during transportation and storage.

APPROVED	DI MASU	765-84-c6253C5	
CHECKED	<i>Suhmas</i>		
CONTROLLERATE OF INSPECTION (ICV)	INJECTOR	WEIGHT	SCALE
		0.5	1:1
		SHT	SHTS



1. Mark on tag
 2. Other requirements are as per Ty 005216-75 for items 253111H n.
- (A) EQUIVALENT MATERIAL:- RUBBER BA-70 TO BS:2751-82

00818-ICV 11 OCT 2000 DC(I)No. & DATE	(A) Guru	EQ. MATERIAL ADDED.
ISSUE	AMENDMENTS	

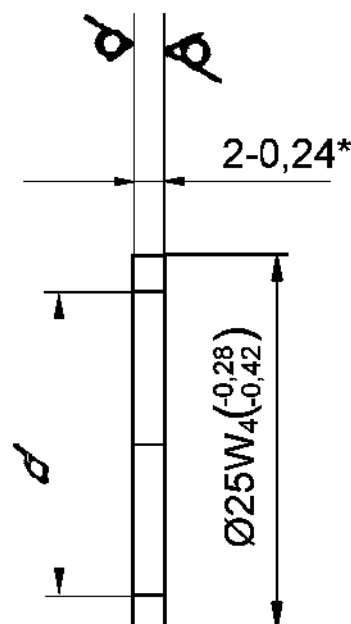
APPROVED		770-72-149		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		SEALING RING	WEIGHT	SCALE
			0.00004	5:1
		RUBBER B 14 TY 005216-75	SHT	SHTS

700-40-237

Rz320

✓(✓)

010902 ICV 28/05/11	010902 ICV 28/05/11
DC(I)No & DATE	DC(I)No & DATE
ISSUE	ISSUE
AMENDMENTS	AMENDMENTS



1. Wall thickness difference in the ring width should not exceed δ mm.
2. * Dimension is given for reference.

EQ. MATERIAL: Gde 19000 OR GDE 19500 TO IS: 737-74 (A)

(B) EQ. MATERIAL: AL ALLOY SHEET GRADE 19500 TO IS: 737-74

DESIGNATION	"d" mm	" δ " mm	MASS, Kg.
700-40-237	$\phi 20^{+0,5}$	0,2	0,001
(B) 4V2/RCV 5330-387942-01	$\phi 17A_7 (+0,43)$	0,3	0,0015

00818-ICV

(B)

11 oct 2000

ICV

EQ. MATERIAL ADDED.

00640-ICV

(A)

19 JUN 98

ICV

EQ. MATERIAL ADDED.

DC(I)No.
& DATE

ISSUE

AMENDMENTS

APPROVED

H. VASH

CHECKED

S. Kumar

700-40-237

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

GASKET

WEIGHT

SCALE

SEE
TABLE

1:1

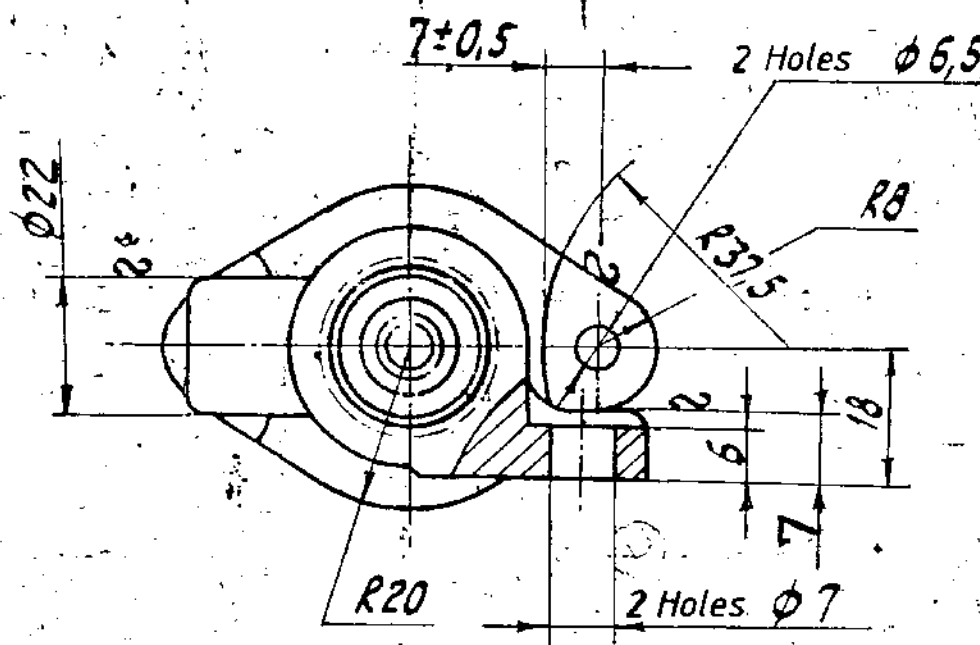
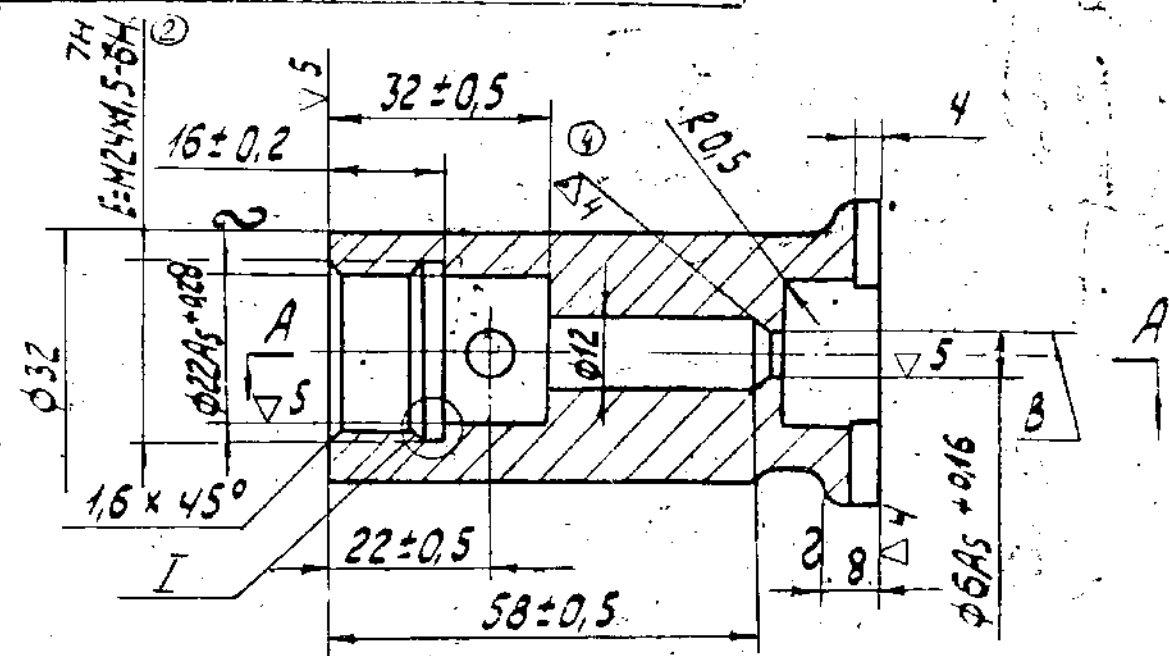
SHT

SHTS

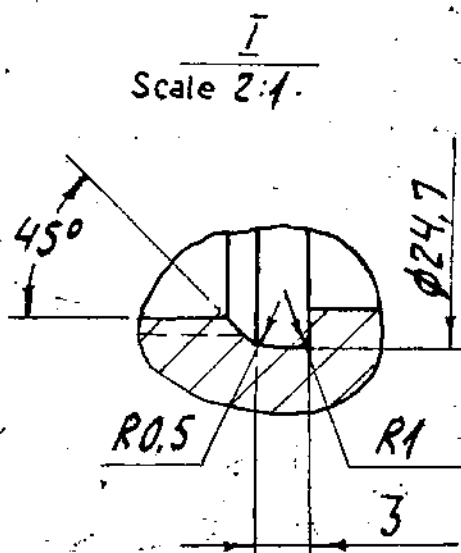
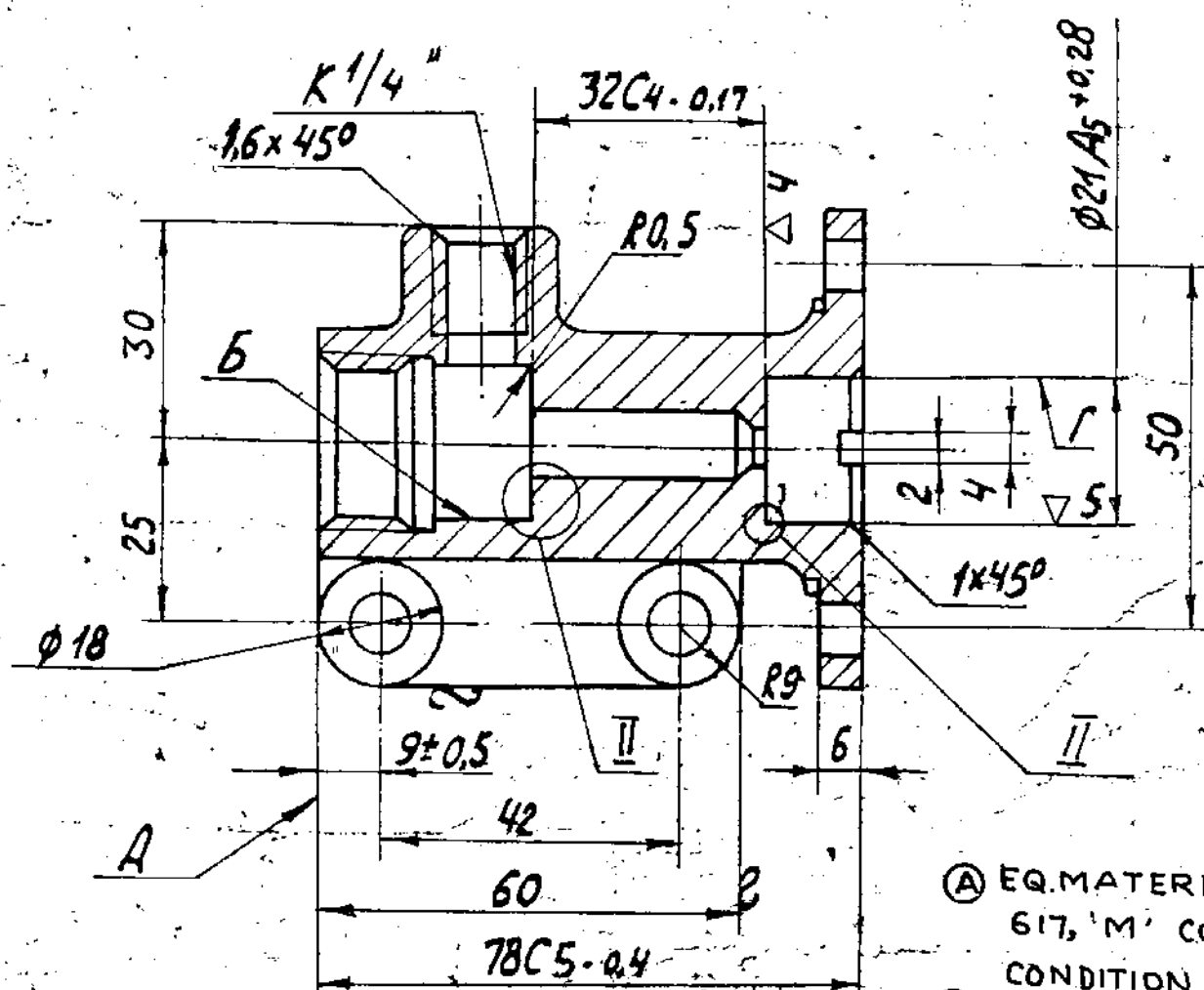
SHEET A41M2 GOST 21631-76

09-18-59L

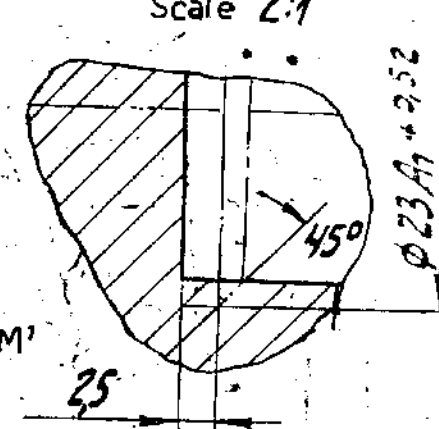
Unless otherwise specified.



A-A



II in two places
Scale 2:1



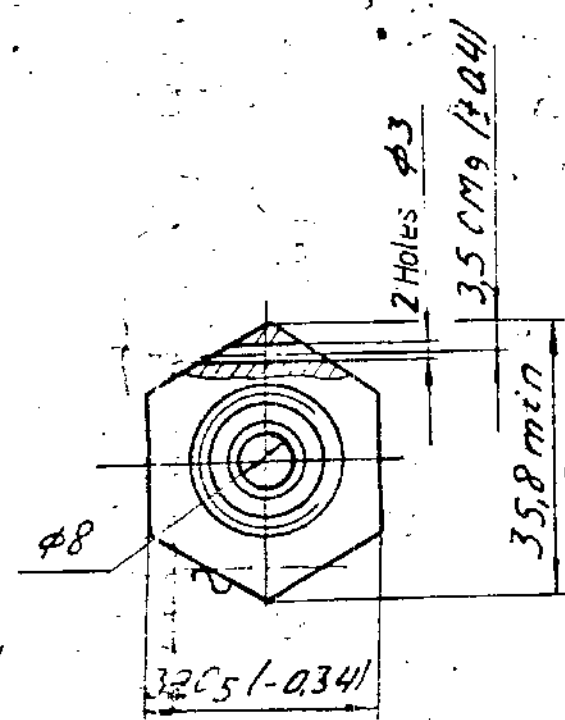
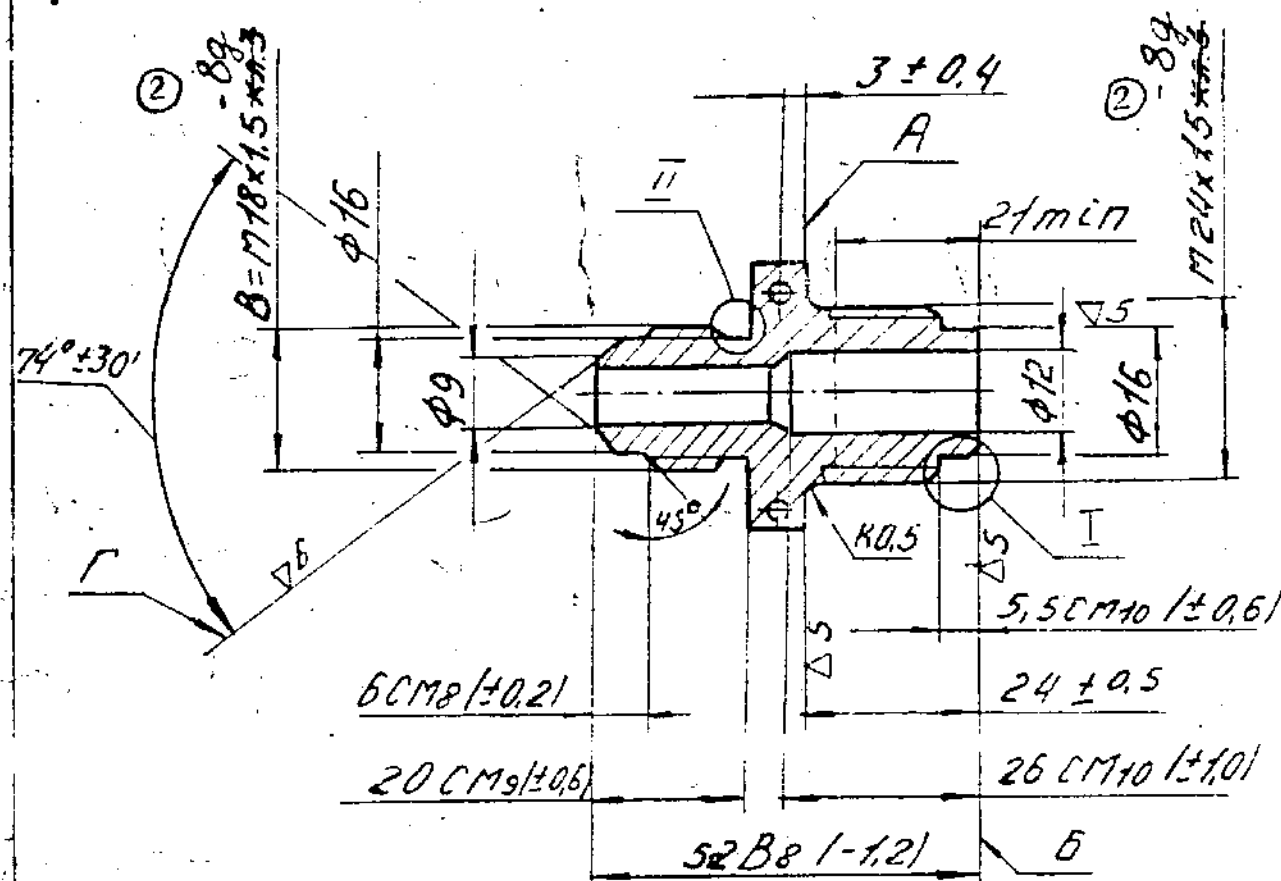
- ① EQ. MATERIAL: Gde 4450 TO IS: 617, 'M' CONDITION OR GRADE LM 25 'M' CONDITION TO BS: 1490-88.
- ② EQ. MATERIAL: GRADE 4450 TO IS: 617-75
- ③ ALT. MATERIAL: GRADE 4535 TO IS: 202-81

00806-ICV	②	EQ. MATERIAL AND ALTERNATE MATERIAL ADDED.
14.9.2000	②	
00640-ICV	①	EQ. MATERIAL ADDED.
DC(I) NO. 8	①	
DATE	ISSUE	NATURE
AMENDMENT		

- 1) Blunt sharp edges.
- 2) Pattern drafts should not exceed 2° max.
- 3) Unspecified casting radii are R 5.
- 4) Provide dimensions of surfaces to be machined without deviations as follows : diameter as per accuracy class 7, length as per accuracy class 8, OCT 1010. Dimensions for casting are ± 1.5 ± 1.0 .
- 5) Other requirements for casting are as per technical requirements TTU 408.
- 6) Displacement of axes of holes from their true positions should not exceed 0,2 mm.
- 7) Run-out of surfaces B, F and angle diameter of thread E with respect to the surface B should not exceed 0,1 mm.
- 8) Non-squareness of surface D in respect to the axis of surface B should not exceed 0,06 over a length of 30.
- 9) Alternate material is A 14, GOST 2685-75.
- 10) Coating : Anodic oxidation, chromatised.
- 11) After machining check the internal cavity for tightness with kerosene under a pressure of 1 kg / cm² for 5 minutes. Leakage and sweating are not allowed.
- 12) Body may be made along conventional dotted line.

APPROVED	M VASU	765-84-50	
CHECKED	Sharma	BODY	
CONTROLLERATE OF INSPECTION (ICV)		A 19 GOST 2685-75	
		HEIGHT	SCALE
		0-16	(1)
		SHT	SHTS
		4	75

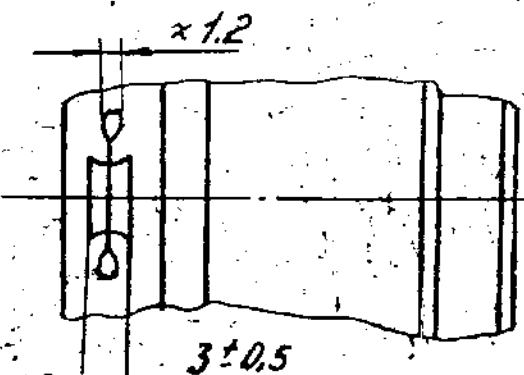
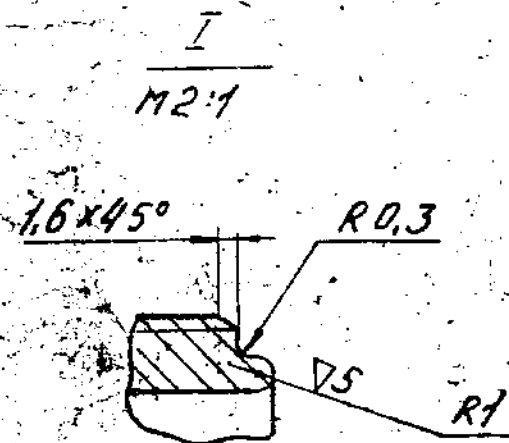
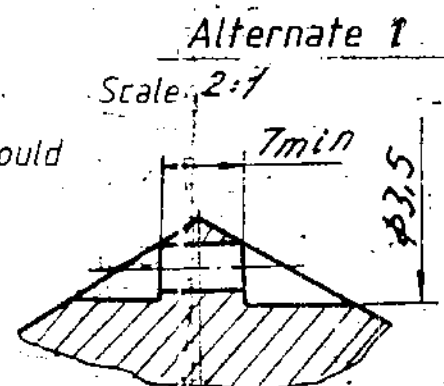
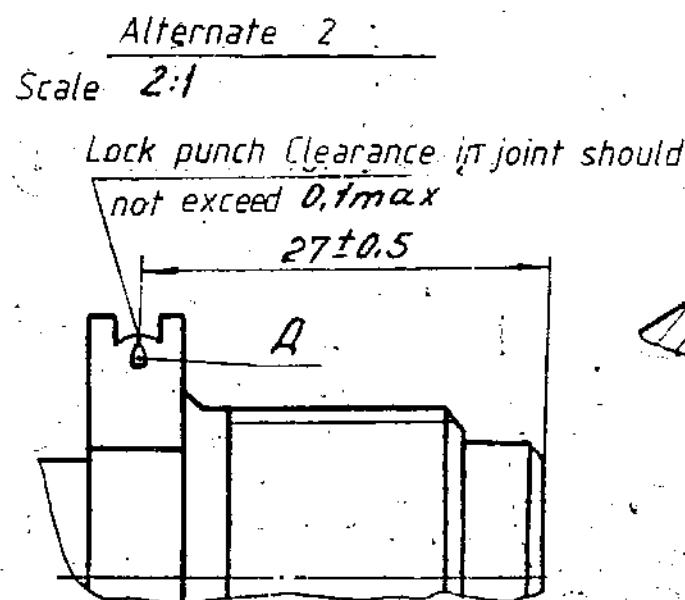
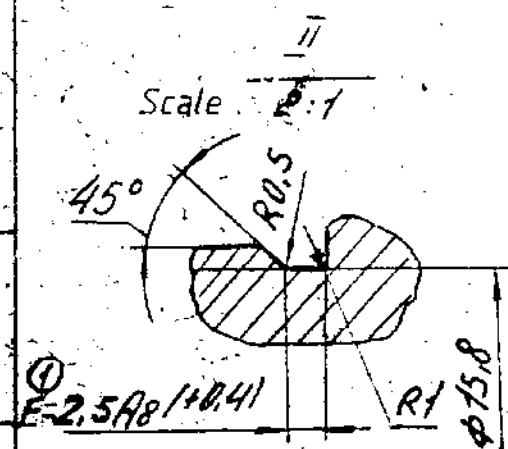
765-84-51



- ⑧ ALT. MATERIAL: C55 Mn75 TO IS: 2073-70
- ⑨ EQUIVALENT MATERIAL: STEEL BAR C 50 TO IS: 1570-61. STEEL BAR C 45 TO IS: 2073-70.
- 1) Alternate material is 35, 40, 50 GOST 1550-74 and 40 Г GOST 4543-71.
 - 2) Unspecified limit deviations of dimensions are as follows : for holes as per A₇ , Shafts as per B₇.
 - 3) Non-squareness of surfaces A and B with respect to the axis of thread should not exceed 0,06 mm over a length of 20 (qualified tolerance).
 - 4) Run-out of surface i with respect to the angle diameter of thread θ should not exceed 0,1 mm (qualified tolerance).
 - 5) Rod of atleast φ 1,0 mm should pass through hole D.
 - 6) Coating : Zinc-plated, 9 microns thick, chromated. Remove hydrogen embrittlement. Do not check coating in holes.

7) Groove may be made with dimension E = 4

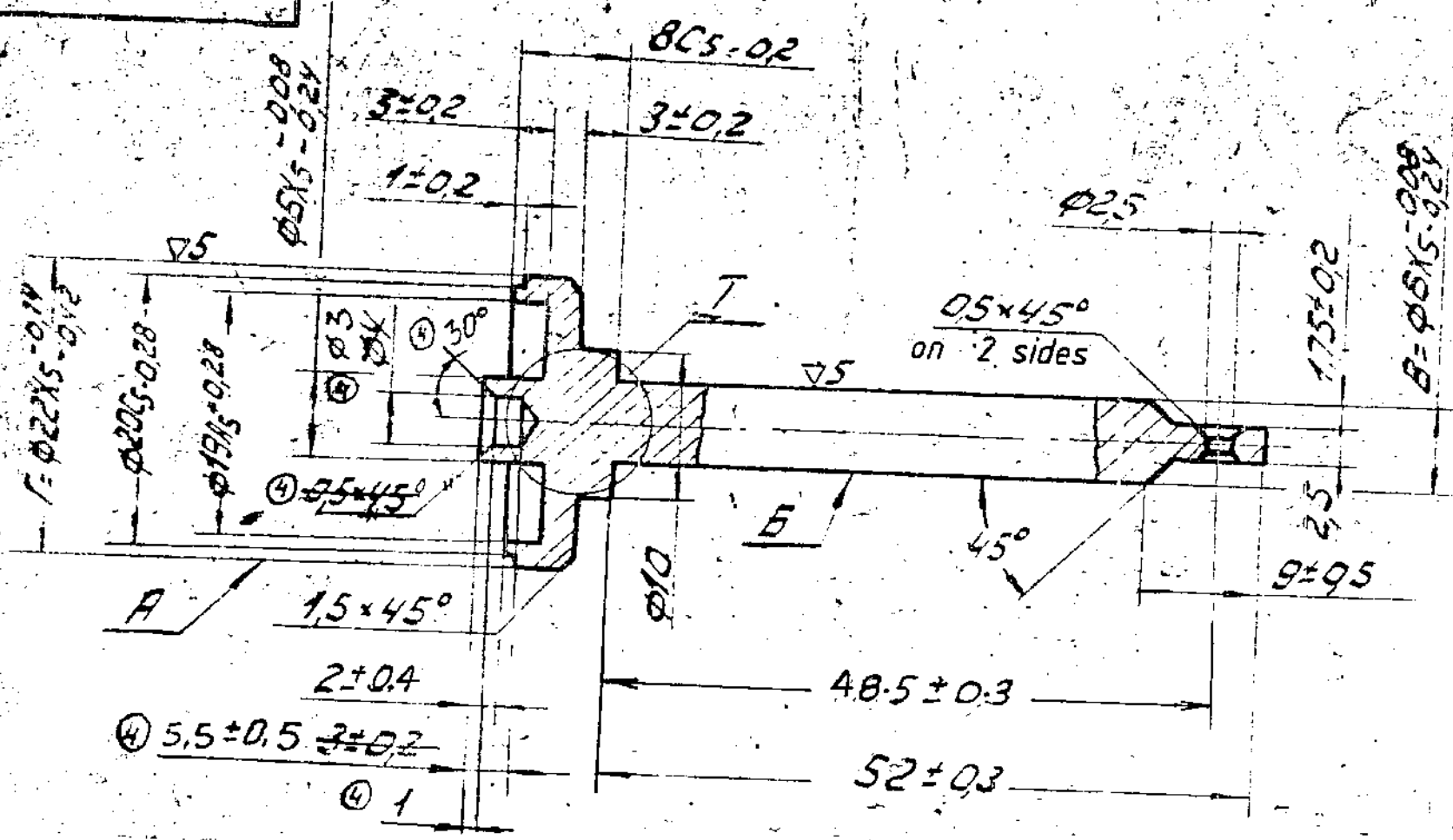
⑩ EQUIVALENT MATERIAL: 45 C 8 Gr 4, IS: 9550-80



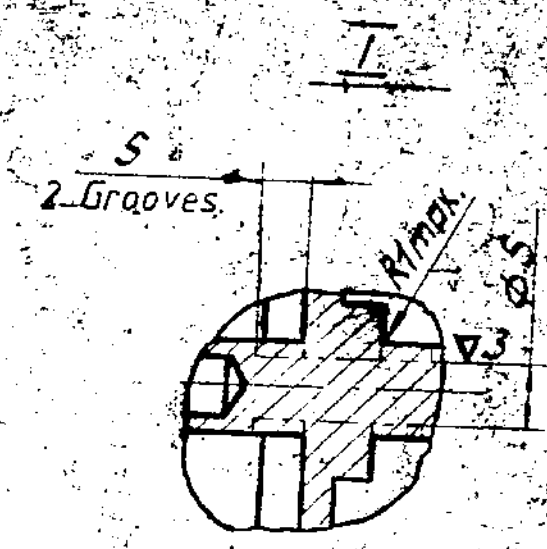
00806-1CV	⑧	EQ. MATERIAL ADDED.
14.9.2000	Gen	
00625-1CV	⑨	STEEL 45 C 8 Gr 4, IS: 9550-80
30 MAR 98	Gen	ADDED AS EQUIVALENT
DATE	ISSUE	NATURE
		AMENDMENTS

APPROVED	M VASU	765-84-51	WEIGHT	SCALE
CHECKED	Enhman		0-105	1:1
CONTROLLERATE		UNION	SHT	SHTS
OF				
INSPECTION				
(ICV)		45 GOST 1050-74		

765-84-53



Unless otherwise specified



- 1) Blunt sharp edges.
- 2) Unspecified radii should not exceed R0,5 mm.
- 3) Provide dimensions without deviations as follows :
Diameters as per accuracy class 7, lengths as per class 8, OST 1010.
- 4) Run-out of surface A with respect to the axis of surface B should not exceed 0,06 mm.
- 5) Coating :Hard chrome plated, 18microns thick, impregnated with preservation oil K-17 GOST 10877-76 as per instruction 053.25289.00002 or with varnish K0-815 GOST 11066-74. Check dimensions B and Γ after coating. Check the thickness of coating on surfaces A and B.
Check the dimensions before coating, except dimensions B and Γ. Do not check holes for the presence of chrome.

6) Plunger may be made as per conventional dotted line.

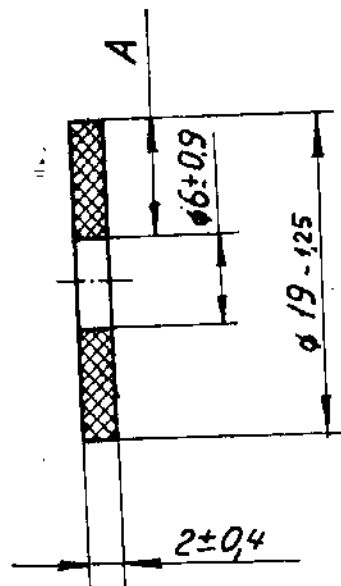
00806-ICV	14.9.2000	EQ. MATERIAL ADDED.
00625-ICV	30 MAR 98	EQUIVALENT MATERIAL
DCO No 8	ISSUE	STEEL 45 C8 Gr 4, 15:9550-80
DATE		ADDED IN THE DRG. (1/98 NO 8)
		NATURE
		AMENDMENTS

APPROVED	M VASU	765-84-53	
CHECKED	Enh...	PLUNGER	
CONTROLLERATE OF INSPECTION (ICV)		WEIGHT	SCALE
		0-024	2-1
		SHT	SHTS
		45 GOST 1050-74	

① EQUIVALENT MATERIAL: STEEL 45 C8 Gr 4, 15:9550-80.
② EQUIVALENT MATERIAL: STEEL BAR C45 TO IS: 2073-70.
③ STEEL BAR C50 TO IS: 1570-61.

33-32/9

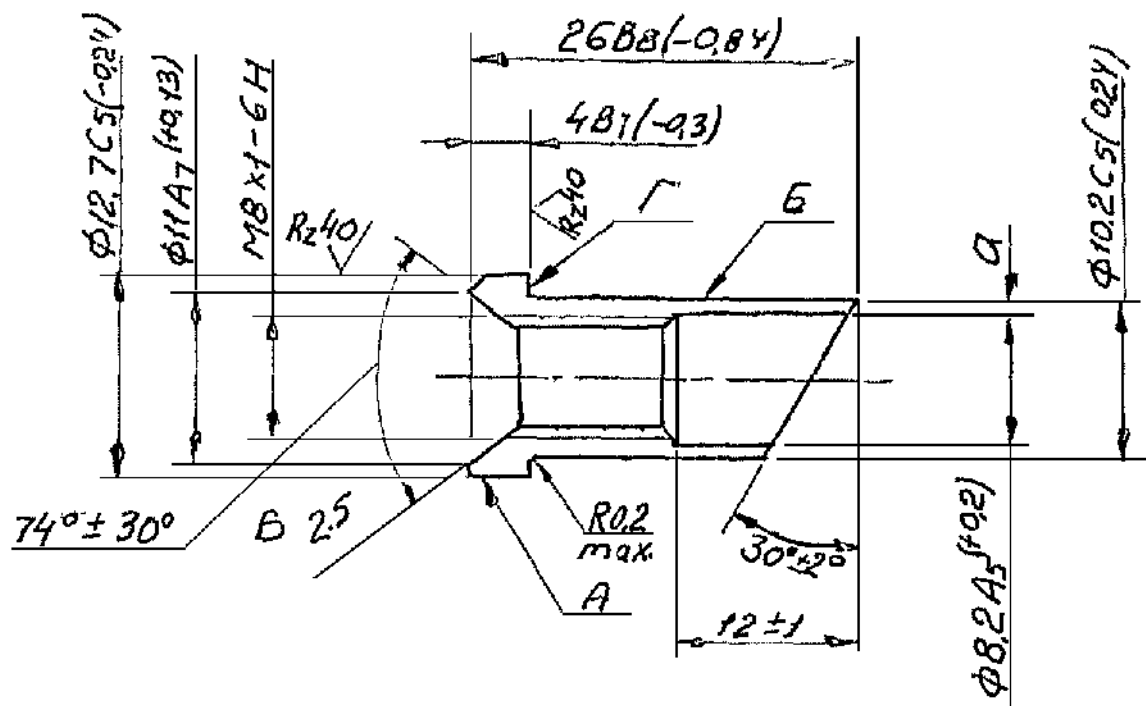
765-84-54



1. Alternate material is rubber 632TY 005216-75.
2. Other requirements are as per Technical specification TY005216-75 for articles of code 254311.
3. Difference in thickness over dimension A should not exceed 0.5mm.

38

APPROVED	M VASU	765-84-54	
CHECKED	<i>Suhman</i>	RING	WEIGHT
CONTROLLERATE OF INSPECTION (ICV)			0.001
		SCALE	2:1
		SHT	SHTS
		PLATE 254311-2	
		RUBBER 637 TY005216-75	



DECISION DATE	ISSUE	NATURE AMENDMENT
00635- V. 10.2000 01.10.2000	(A)	STEEL TO IS: 7283-74 (MATERIAL AS PER IS: 226-75) STEEL TO IS: 7283-74 (MATERIAL AS PER IS: 226-75) STEEL TO IS: 7283-74 (MATERIAL AS PER IS: 226-75)

1. Alternate material is steel 15,20,25 GOST 1050-74 and 15Г,20Г GOST 4543-71.
2. The following are allowed with respect to surfaces A and B machined from one setting:
 - a) radial run out of surface B should not exceed 0,15mm.
 - b) end play of surface Г should not exceed 0,06mm.
3. Difference in measurements of dimension "a" should, not exceed 0,2mm.

- (A) 4. EQ. MATERIAL: STEEL TO IS: 7283-74 (MATERIAL AS PER IS: 226-75)
II, MATERIAL 10 C4 to IS: 9550-80Gr I
- (B) EQ. MATERIAL - STEEL BAR C14 TO IS: 2073-70
ALT. MATERIAL - (i) STEEL BAR C15 Mн75, C20 TO IS: 2073-70
(ii) STEEL BAR C15 Mн75, C30 TO IS: 2073-70.

APPROVED

M. VASU

CHECKED

H. M. Shekhar

700-57-404

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

NIPPLE

STEEL 10 GOST 1050-74

WEIGHT

SCALE

0.007

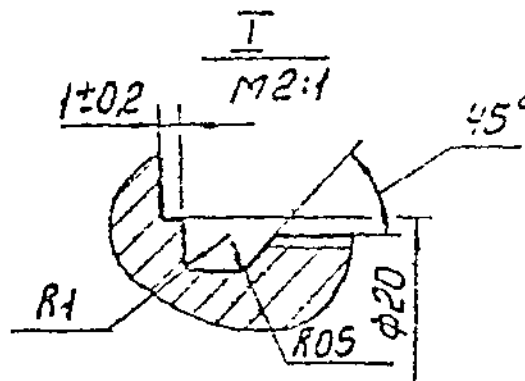
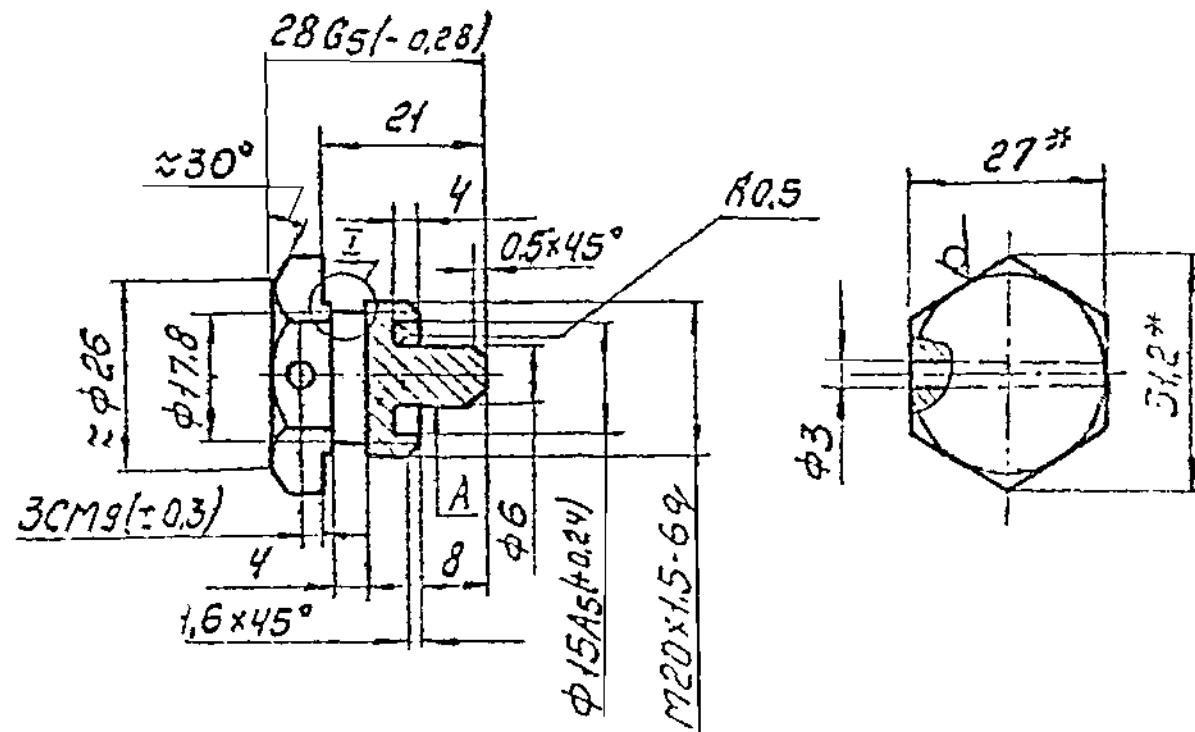
2:1

SHT

SHTS

730-84-78

R280 (V)

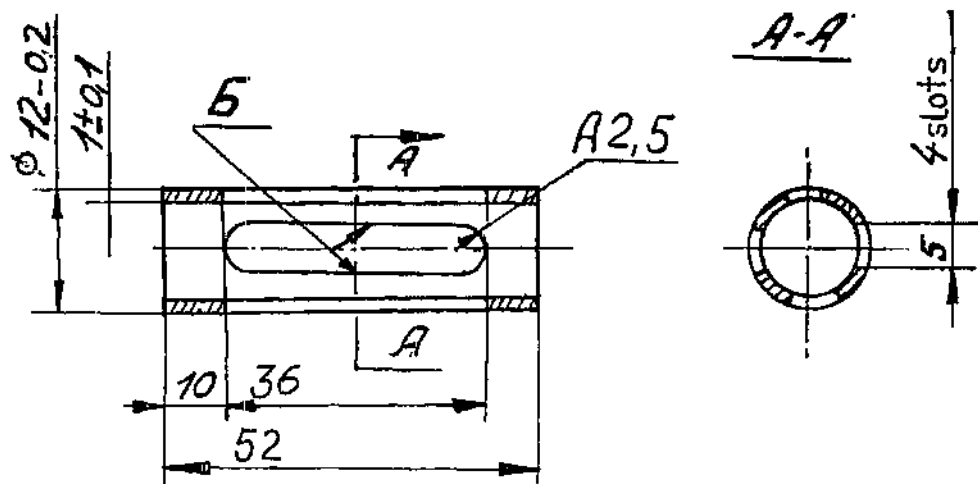


1. Alternate material is steel CT6 GOST 380-71 and steels 35,40,50 GOST 1050-74 and 30Г, 40Г GOST 4543-71.
2. Radial run-out of surface A with respect to threaded surface should not exceed 0,2mm(qualified tolerance).
3. Unspecified limit deviations of dimensions: for holes- as per A7, for shafts B7 and others as per CM8.
4. Coating: Zinc-plated, 9 microns thick, chromitized. Remove hydrogen embrittlement.
5. * Dimensions are given for reference.
- ⑥ EQ. MATERIAL: STEEL 45 C8 TO IS:9550-80, Gr II, TYPE 'O'
- ⑦ EQ. MATERIAL :-CARBON STEEL BAR C50, C40, C30 TO IS:1570-61.
- ⑧ ALTERNATE MATERIAL :-EN-5, EN-8, EN-9 TO BS970.

00993-ICV 12 APR 05	③	DS CAT PART No ADDED. AND NOMENCLATURE WAS "PLUG"
00818-ICV 11 OCT 2000	②	EQ. MATERIAL AND ALTERNATE MATERIAL ADDED.
00635-ICV 01 JUN 98	①	STEEL 45 C8 TO IS : 9550-80 Gr II, TYPE 'O' ADDED. AS EQ. MATERIAL.
DC(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED	M VASU	③ 730-84-78	DS CAT PART NO: LV2/ICVS 5365-010770
CHECKED	Sharma	③ PLUG	WEIGHT SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		PLUG SCREWED	0.08 1:1
		HEXAHEDRAL BAR	SHT 1 SHTS 1
		27-5 GOST 8560-78 45-B GOST 1051-71	

765-05-73



- 1 Blunt sharp edges
- 2 Perform dimensions without deviations with accuracy $\pm 0,5$.
3. Step should not exceed 0,5mm on surface B.
- 4 It is allowed to Manufacture the pipe of sheet Δ npx
MH Δ 63 GOST 931-78 in this case , S 1-0,12, $\phi 12-0,5$

Ⓑ EQ.MATERIAL :- BRASS TUBE Cu Zn 37 TO IS: 407-81.
(ALT. MATERIAL :- BRASS SHEET Cu Zn 37 TO IS: 410-77.

Ⓐ EQ.MATERIAL: CU Zn 37 '0' gde TO IS: 407 'HD'

USED ON. 765-84-C8147

01025-ICV <i>Isam</i> 26-06-06	Ⓒ	DS CAT No. ADDED & NOMENCLATURE WAS 'CASING'
00806-ICV <i>MM</i> 00640-ICV 00640-ICV <i>v. Roman</i> 19-06-98	<i>Cur</i> Ⓐ	EQ.MATERIAL AND ALTERNATE MATERIAL ADDED
DC(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED *H VASH*
CHECKED *Schmar*
CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

765-05-73

Ⓒ
BUSHING SLEEVE
STANDARD

PIPE Δ x P Δ 12 x 1 H Δ
63 GOST 494-76

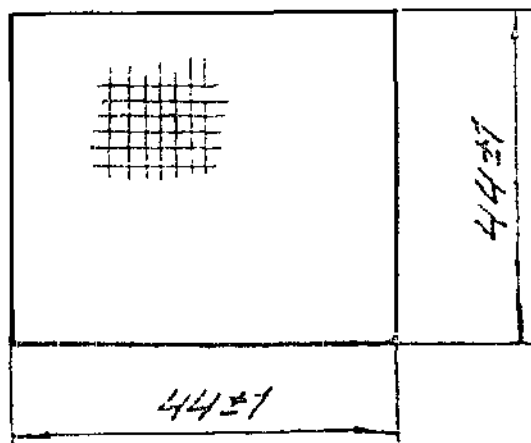
DS CAT No. LV2/ICVS
3120-101869 Ⓒ

WEIGHT SCALE

0.009 1:1

SHT 1 SHTS 1

765-05-74



Ⓐ EQUIVALENT MATERIAL:- PHOSPHORUS BRONZE OR STAINLESS STEEL OR BRASS (C70)
Zn 30) WIRE

USED ON. 765-84-C0147

00818-KV N.Y. 11/1/10 N-10.2000	Ⓐ Anm	EQ MATERIAL ADDED.
DCI/NO DATE	ISSUE	NATURE OF AMENDMENTS

APPROVED
CHECKED

M VASU

[Signature]

765-05-74

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

WIRE NET

LOW BRASS WIRE NET
0355 GOST 6613-73

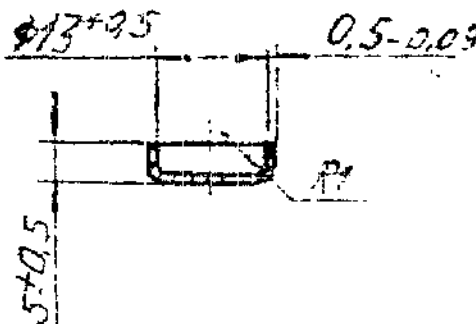
WEIGHT SCALE

0.001 1:1

SHT SHTS

765-05-59L

All around



1. Blunt sharp edges

- ① EQ. MATERIAL: CU Zn 37 TO IS: 410 'O' GRADE.
 ② EQ. MATERIAL: BRASS SHEET CU Zn 37 TO IS: 410-77.

00806-ICV N. Vasu 14.9.2000	② Cur	EQ. MATERIAL ADDED
V. Ramaswamy DCG 00640-ICV 19.6.98	Cur ①	EQ. MATERIAL ADDED.
DCG NO. 67 DATE	ISSUE	NATURE
AMENDMENT		

USED ON 765-84-C5147

Material

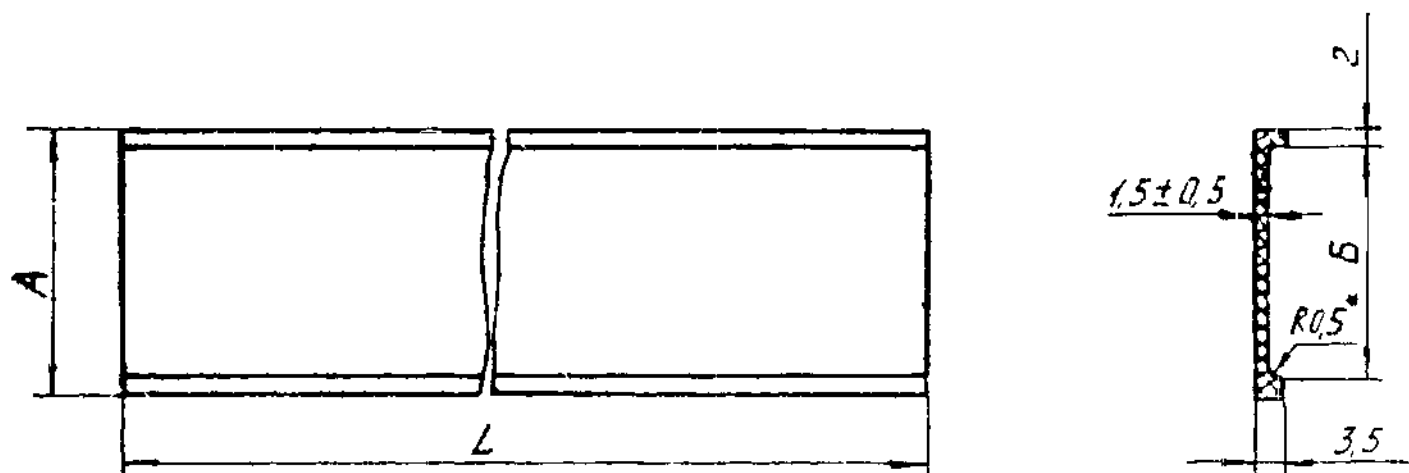
Sheet

APPROX 0.5 kg 765-05-75 931-78

APPROVED	M VASU	765-05-75	
CHECKED		BOTTOM	WEIGHT
CONTROLLERATE OF INSPECTION (ICV)			0.002
		SHT	SHTS
AS ABOVE		66 OF 173	

84

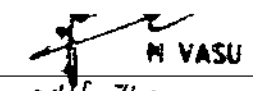
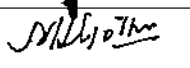
765-06-455 / 461



DESIGNATION	A*	B	L	WEIGHT
765-06-455 (A)	25	21±1	30±1	0,002
(B) 765-06-456 (A)	25	21±1	45±1	0,003
765-06-457 (A)	25	21±1	60±1	0,004
765-06-458 (A)	25	21±1	95±2	0,006
765-06-459	25	21±1	120±2	0,007
765-06-460	25	31±1	170±2	0,014
765-06-461	25	21±1	80±2	0,005

- *PROVIDE DIMENSIONS WITH TOOL.
 - ALTERNATE MATERIAL IS RUBBER 649 TY 005216-75.
 - THE PART IS DELIVERED BY SECTIONS OF ANY LENGTH BUT NOT LESS THAN 1000 mm.
 - MARK ON TAG.
 - OTHER REQUIREMENTS ARE AS PER TY 005216-75 FOR ITEMS 254112.
- (A) EQ. MATERIAL: -CHLOROPENE RUBBER C-60 TO BS:2752-82
- (B) EQ. MATERIAL: - GRADE-BA70 TO BS:2751-82.
FOR 765-06-456

00905-1CV N.V. 25-9-01	(B)	EQ. MATERIAL ADDED.
00848-1CV N.V. 11-12-01	(A)	EQ. MATERIAL ADDED
DC/NO DATE	ISSUE	NATURE OF AMENDMENTS.

APPROVED		765-06-455 / 461		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		GASKET (TABLE DRAWING)		
		(A) RUBBER 637 TY 005216-75	WEIGHT SEE TABLE	SCALE 1:1
			SHT	SHTS

765-10-2359

3 (V)

00625-ICV

(A)

EQUIVALENT MATERIAL
CDS:240 IS:3601-84
ADDED.
(1/98 NOFA)

30 MAR 98

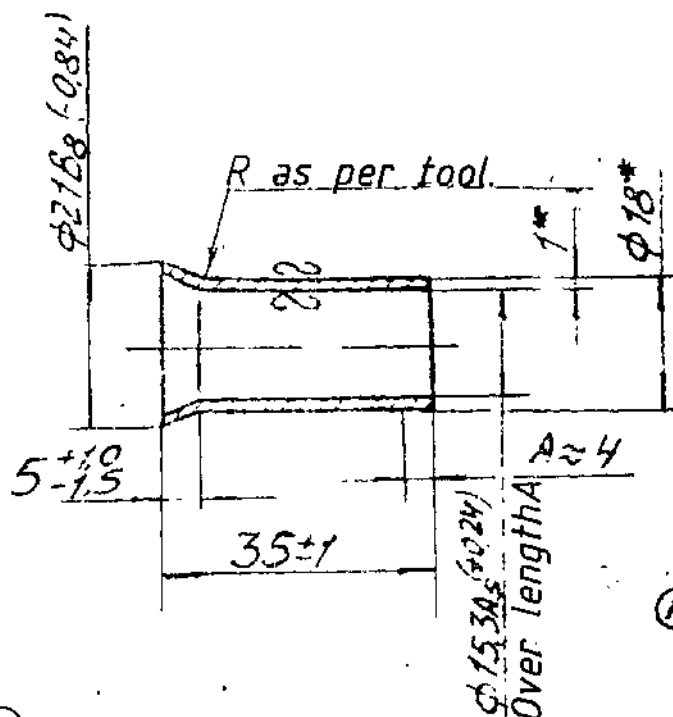
Cur

DC (S) NO
& DATE

ISSUE

NATURE
AMENDMENT

EQ. MATERIAL ADDED.	EQ. MATERIAL ADDED	NATURE AMENDMENT
(C) Cur	(B) Cur	ISSUE
00818-ICV N. K. S. K.	00780-ICV N. K. S. K.	DATE
11-10-2006	26-4-2008	



(A) EQUIVALENT MATERIAL:
CDS-240 IS:3601-84

(B) EQ. MATERIAL:- CDS TUBE 4 TO IS:3074-65

1). * Dimensions are given for reference.

(C) EQ. MATERIAL:- STEEL TUBE GRADE CDS-2 OR CDS-3 TO IS: 3074-79.

2). Sleeve may be reduced on section A to diameter which provides clearance not exceeding 0.6 mm with part 765-10-1496/2117.

3). Alternate material is pipe 18x1 GOST 8734-75
B10 GOST 8733-74.

Material: Pipe 18x1 GOST 8734-75
B20 GOST 8733-74.

APPROVED

M. V. S.

CHECKED

SK

D. S. KUMAR

765-10-2359

CONTROLLERATE
OF
INSPECTION
(ICV)

SLEEVE

PIPE 18x1 GOST 8734-75
B20 GOST 8733-74

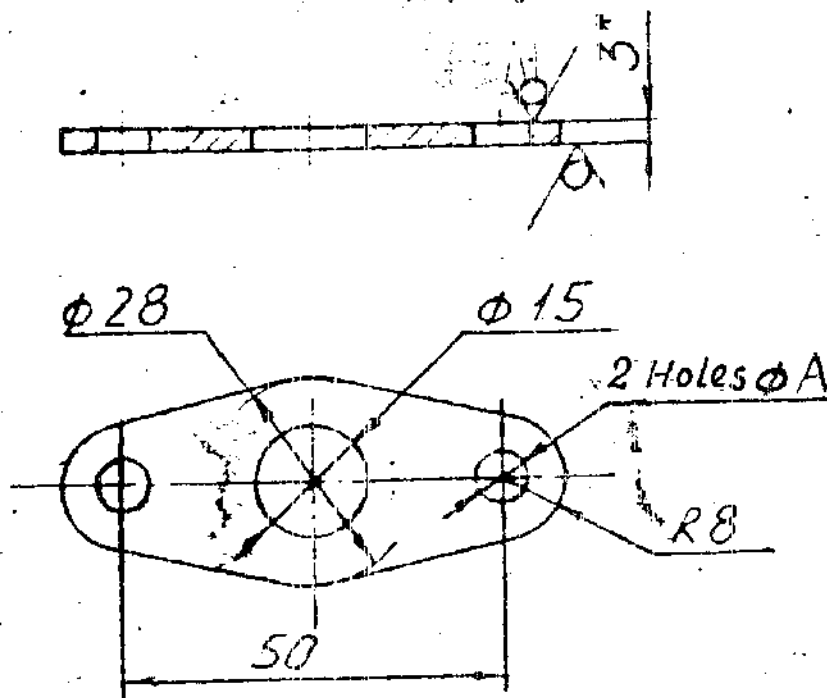
WEIGHT SCALE

0.010 11

SHT SPTS

765-71-364

Rz160



①	DCAT No: ADDED FOR 765-71-364-01	ISSUE	AMENDMENT
②	EQUIVALENT MATERIAL ADDED FOR 765-364-01.	DATE	
③	St 34 TO IS:1079-73		
	ADDED AS EQ. MATERIAL FOR 765-71-364-01		

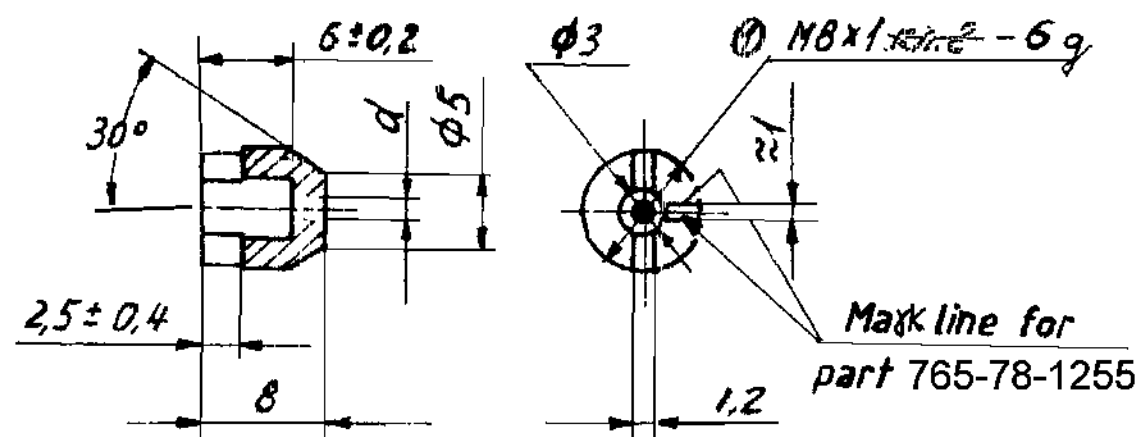
Designation	ϕ A, mm	Weight kg.	EQ. MATERIAL
765 - 71 - 364	5	0,010	—
- 01	8	0,010	St 34 TO IS:1079-73

③ EQUIVALENT MATERIAL: COLD ROLLED STEEL STRIP GRADE 01015: 4030-73

- 1) Unspecified limit deviations of dimensions are $\pm 0,5$ mm.
- 2) Coating : Zinc-plated 9 microns thick, chromatized.
- 3) Dimension with (*) is given for reference.
- 4) Alternate material is 45, GOST 1050-74.

APPROVED	<i>[Signature]</i> H VASU	765-71-364	
CHECKED	<i>[Signature]</i>	FLANGE	
CONTROLLERATE OF INSPECTION (ICV)		WEIGHT	SCALE
		SHT	SHTS
PLATE: E-n H-O-3 GOST 19903-74		3-11-Cm. 3cn GOST 16523-70	

765-78-1254/1258



TECHNICAL CONDITIONS

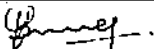
- 1) Blunt sharp edges.
- 2) Make mark lines to a depth of approximately 0.5 mm on the butt-end in compliance with table arrangement of mark lines with respect to the slot is arbitrary.
- 3) Provide dimensions without deviations as per accuracy class 7, GOST 1010.
- 4) Displacement of slot with respect to the axis should not exceed 0.4 mm.
- 5) Alternate material is 5p A7S MU -10-3-15, GOST 18175-78.

Ⓐ EQ. MATERIAL: Gde I, HB-CONDITION TO IS: 319-81.

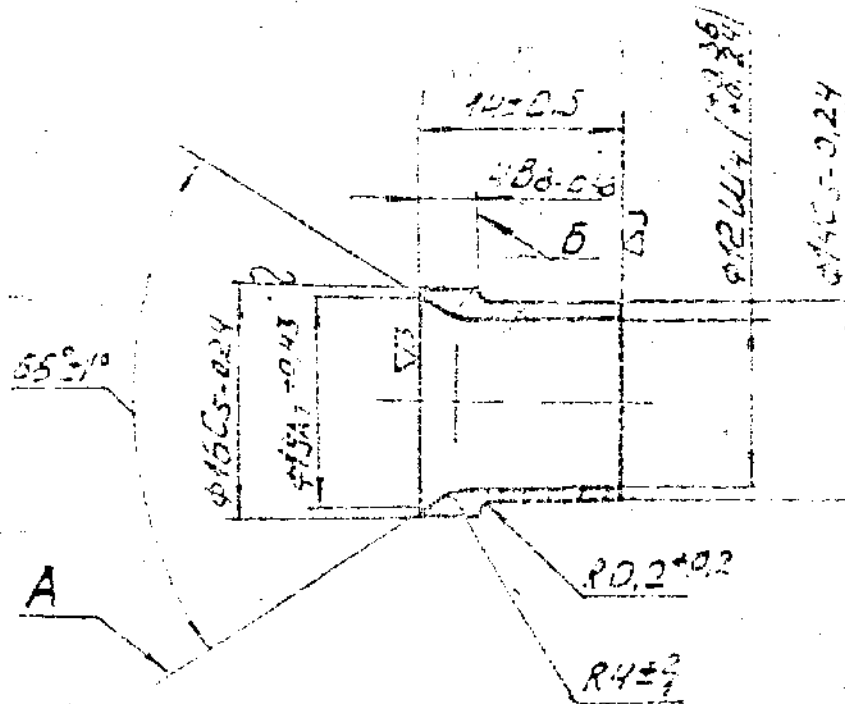
Ⓑ EQ MATERIAL:-BRASS BARS OF CU ZN 39 PB2 TO IS: 531-81.

DESIGNATION	d(A5)		Number of notches
	Nominal	Deviation	
765-78-1254	0.4		1
765-78-1255	1.5	+0.12	2
765-78-1256	2.2	+0.12	3
765-78-1257	1	+0.12	4
765-78-1258	0.6	+0.06	5

00818-11V N 4/11 11.10.2008 V. Ramaswami BCL 00640 -12V 19.6.71 BCL No. 6	Ⓑ Am	EQ. MATERIAL ADDED FC 765-78-1257.
	Ⓐ Am	EQ. MATERIAL ADDED.
	ISSUE	NATURE
	AMENDMENT	

APPROVED		 M VASU		765-78-1254/1258				
CHECKED				JET (TABLE DRAWING)			WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)			0.002			2:1		
		SHT 1 SHTS 1						
				ЖС59-1, GOST 15527-70				

▽4 Unless otherwise specified



00780-1C1 V. Rana 26. 4-2000	(B)	EQ. MATERIAL ADDED
00625-1C1 26. 4-2000	(A)	STEEL 45C8Gr4, 15:9550-80 ADDED AS EQUIVALENT MATERIAL (1/98 N of A)
30 MAR 98 OCC/NOB	ISSUE	NATURE AMENDMENT
00806 NAT/ICK 14.9.2000	(C)	EQ. MATERIAL AND ALTERN -ATE MATERIAL ADDED.

- (C) EQUIVALENT MATERIAL:- STEEL BAR C 50 TO IS: 1570-61
 (D) STEEL BAR C 45 TO IS: 2073-70
 (C) ALL MATERIAL:- STEEL BAR C 40 TO IS: 1570-61
 (B) EQ. MATERIAL:- STEEL BAR C-45 TO IS: 2073-70

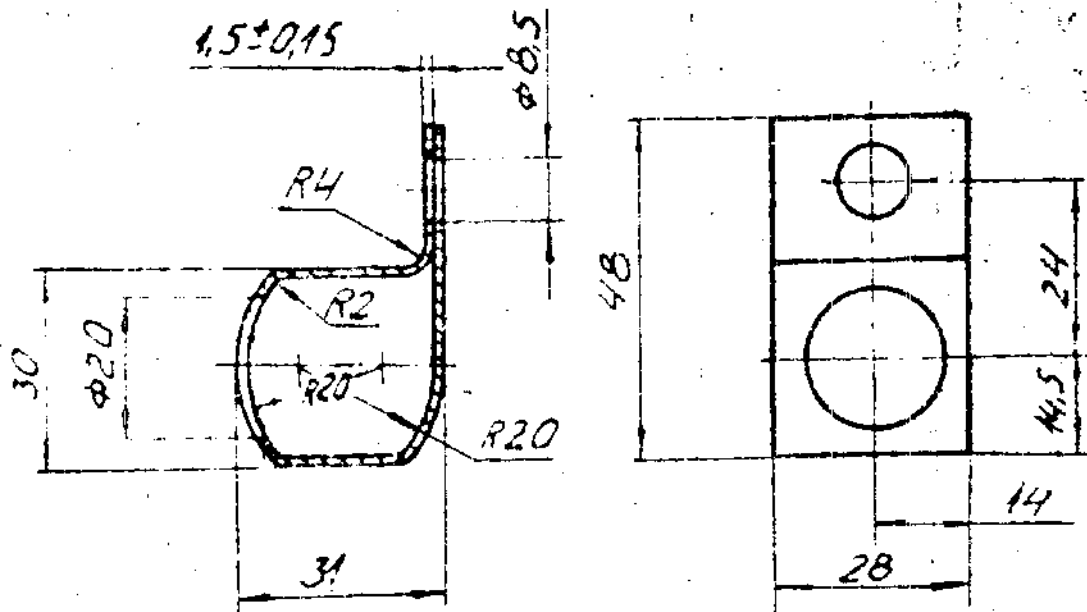
1. Blunt sharp edges.
2. Run-out of surface A with respect to surface B should not exceed 0,05mm.
3. Alternate material is steel 40, GOST 1050-74.
4. Coating: Chemically parkerized, accelerated, chromitized impregnated with preservation, oil K-17, GOST 10877-76 as per Instructions 053.25289.00002 or with varnish KO-815 GOST 11066-74.

- ② EQUIVALENT MATERIAL: STEEL 45 C 8 Gr. 4.15: 9550-80

APPROVED	<i>[Signature]</i> (11 VAS)	765-84-6	
CHECKED	<i>[Signature]</i>	NIPPLE	WEIGHT 0.008
CONTROLLERATE OF INSPECTION (ICV)			SCALE 2:1
		45 OCT 1050-60-74	SMT SHTS 63 OF 74

765-84-43

All over



1. Blunt sharp edges.
2. Provide dimensions without deviations with accuracy of ± 0.5 .
3. Coating: Zinc-plated, 9 microns thick, chromitized. Remove hydrogen embrittlement.
4. Alternate material is 08K π and 10K π GOST 1050-74.

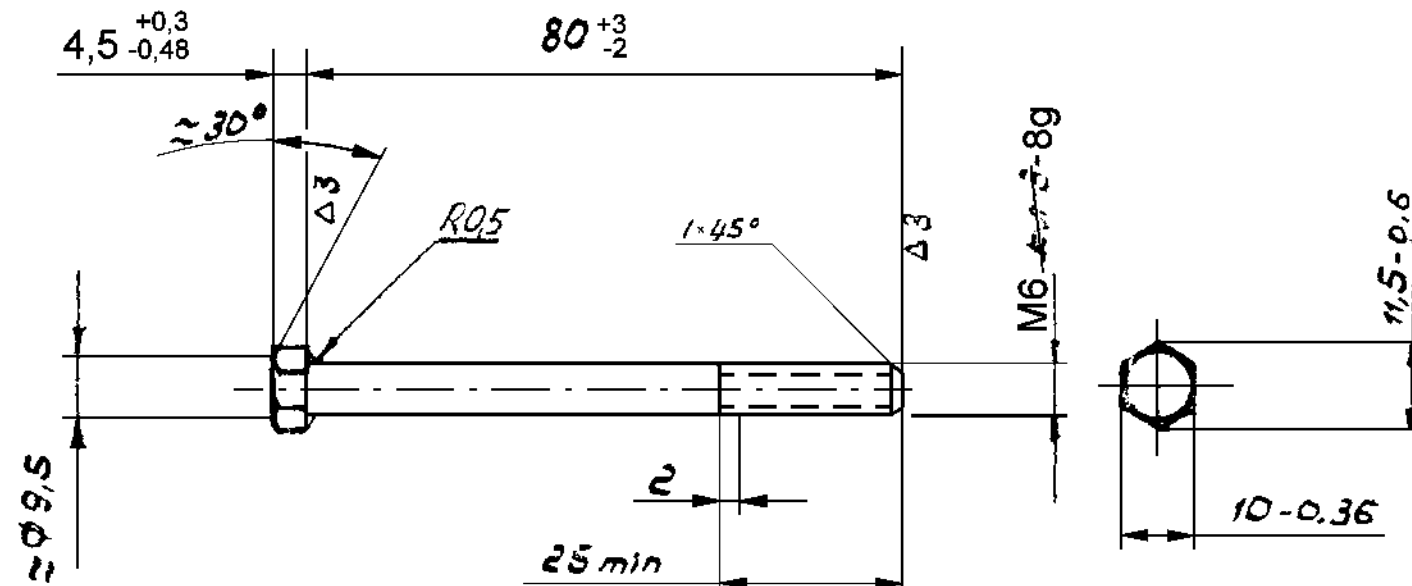
- (A) 5. EQUIVALENT MATERIAL: COLD ROLLED CARBON STEEL STRIP
GRADE 'D' QUARTER HARD TO IS: 513-86
- (B) EQUIVALENT MATERIAL: SHEET GRADE 'D' TO IS: 4030-73

00369-1CV 19 AUG 93	(A) MD COM	TECHNICAL NOTE NO 5 NEWLY ADDED (D 1143)
DC(1) No. 4 DATE	ISSUE	NATURE
AMENDMENTS		

APPROVED	M VASU	765-84-43	
CHECKED	S. Kumar	CLAMP	WEIGHT
CONTROLLERATE OF INSPECTION (IC V)			0.045
		SCALE	1:1
		SHT	SHTS
		10 GOST 1050-60-74	41 OF 173

82-91-222

Unless otherwise specified



TECHNICAL CONDITIONS

- Displacement of head with respect to the axis of rod should not exceed 0.5
- When threads are made by rolling, the following is permitted
 - Thinning of non-threaded parts of the rod upto the thread angle diameter.
 - Chamfer on the rod end may not be made
- Coating Zinc-plated, 9 microns thick, chromitized. Remove hydrogen embrittlement. Check dimensions before coating
- Alternate material is cm5cn GOST 380-71 and 30, 35 and 40, GOST 1050-74

(A) 5 Suitable centre hole provision at threaded and is allowed as per type 'A' to IS 2473-75 if required for manufacture

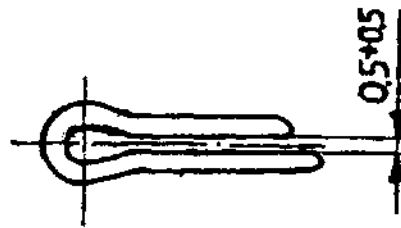
(C) EQ. MATERIAL:- C45 TO IS: 2073-70

(B) 6. EQ. MATERIAL :- STEEL 45 C8 CDE4 TO IS: 9550-80

00839-ICV N. 12.2000	(C)	EQ. MATERIAL ADDED.
00543-ICV 13-2-96	(B)	NOTE NO. 6 ADDED FOR EQ. MATERIAL. (2/95. N OF A)
00153-ICV. 25-5-96	(A)	NOTE No 5 ADDED. (D- 826)
DCW NO. 4000	ISSUE	NATURE
AMENDMENTS		

APPROVED	 H VASU	272-16-28				
CHECKED		BOLT			WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)					0.021	1:1
				SHT SHTS		
		45 GOST 1050-74				

11-23-279



(B)

EQ. MATERIAL :-

LOW CARBON STEEL (0.2 % MAX.)

COATING :- FeZn12 TO IS:1573-70

(A)

EQUIVALENT: SPLIT PIN 6.3x20-15:549-74

ZINC PLATED 9 MICRONS THICK WITH CHROMATIZING

00533-1CV <i>Amur</i> 14-11-95	(B) <i>8</i>	DRG. AMENDED BASED ON APPROVAL OF 4/94 N OF A
00452-1CV <i>Bub</i> 23 AUG 94	(A) <i>9</i>	IS: EQUIVALENT SPECN. ADDED.
DC(I) No & DATE	ISSUE	NATURE
AMENDMENTS		

MATERIAL:- BLANK COTTER PIN 6.3x20-019, GOST 397-79

ALL SHARP EDGES & CORNERS TO BE
ROUNDED OF
DRG. NOT TO BE SCALED

ALL THREADS TO CONFORM
TO SPECIFICATION

STAMP OR ETCH, PART NO. MANUFACTURERS
NAME & YEAR OF MFR.

SCALE: 1:1

TOLERANCE ON DIMENSIONS UNLESS
OTHERWISE SPECIFIED

USED ON:

DATE:- 26-10-95

765-38-Sb164

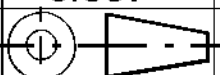
DRN. *Amur*

WEIGHT: (Kg.)

TCD. *14*

0.007

CHD. *Amur*
APD. *Amur*



672-32-11

COTTER PIN

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

672-54-5

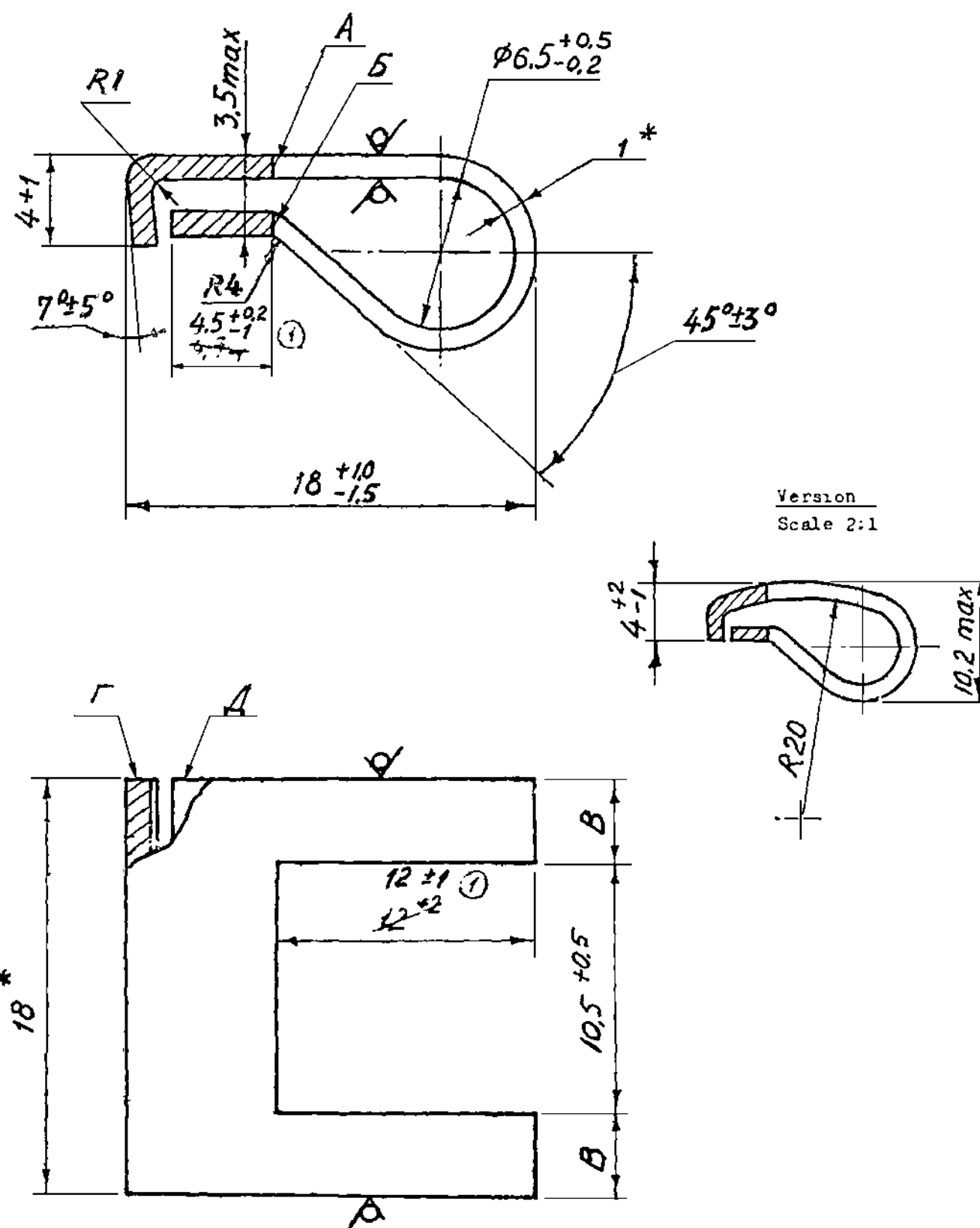
K2320 (✓)

TECHNICAL CONDITIONS

1. Substitute material: steel 08kn, 10kn, ГОСТ 1050-74.
2. Limit deviations of sizes are ± 0.5 mm unless otherwise specified.
3. Displacement of surface A relative to surface B should not exceed 1.8 mm.
4. Displacement of surface F relative to surface H should not exceed 0.7 mm.
5. The difference of sizes B should not exceed 0.8 mm.
6. Cracks are intolerable.
7. Coating: zinc coating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness.
8. *Sizes for reference.

⑨. EQUIVALENT MATERIAL: COLD ROLLED CARBON STEEL STRIP GRADE 'D' 1/4 HARD TO IS: 513-86.

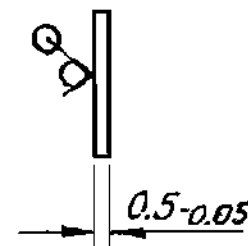
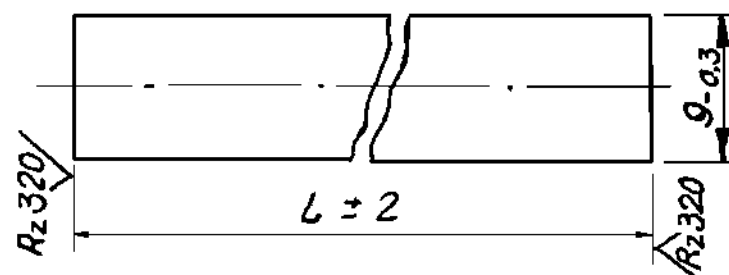
⑩. EQUIVALENT MATERIAL: COLD ROLLED STEEL STRIP GRADE 'D' TO IS: 4030-74.



01089-ICV	①	DS CAT NO' LV2/ICVs 4730-078657 ADDED AND NOMENCLATURE AMENDED AS 'SPIKE MAST BASE'
19/05/2011		
00818-ICV	②	EQ. MATERIAL ADDED.
14/05/2000		
00497-ICV	③	NOTE NO 9 FOR EQUIVALENT MATERIAL ADDED
16-1-95		
DATE	ISSUE	NATURE
AMENDMENT		

APPROVED	CR	672-54-5		DS CAT PART No LV2/ICVs 4730-078657	
CHECKED	BW				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		FRAME SPIKE MAST BASE		WEIGHT	SCALE
				0.004	1:1
		BAND 10-M-A-1x18 GOST 503-81		SHT 1	SHTS 1

672-54-6



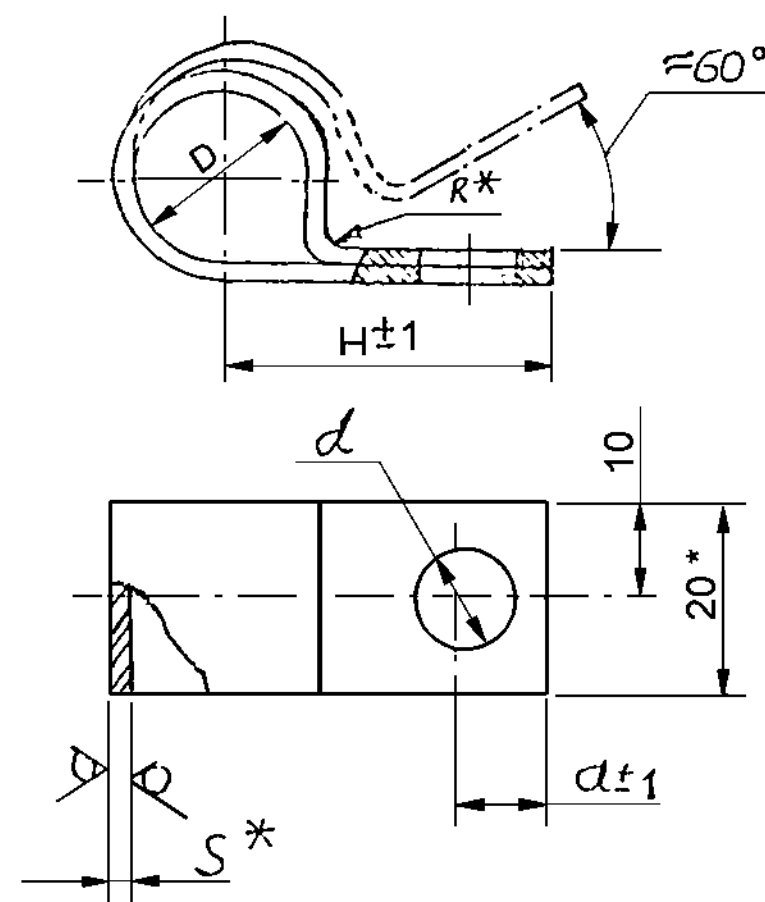
Designation	L, mm	Mass, kg	Designation	L, mm	Mass, kg
672-54-6	200	0.007	672-54-6-21	1700	0.060
-01	225	0.008	-22	2350	0.063
-02	250	0.009			
-03	275	0.01			
-04 (B)	300	0.011			
-05	325	0.012			
-06	350	0.012			
-07	375	0.013			
-08	400	0.014			
-09 (B)	425	0.015			
-10	450	0.016			
-11	475	0.017			
-12	500	0.018			
-13 (B)	525	0.019			
-14	600	0.022			
-15	625	0.022			
-16	650	0.023			
-17	725	0.026			
-18	800	0.028			
-19	920	0.033			
-20	980	0.035			

- (2) 1. Substitute material: steel 08kn, 10kn, IOCT 1050-74.
2. Coating: zinc plating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness.
3. The rest of the technical requirements are according to IOCT 503-81.
(A) 4. EQUIVALENT MATERIAL: COLD ROLLED CARBON STEEL STRIP GRADE 'D' 1/4 HARD TO IS: 513-86.
(B) EQ MATERIAL:- COLD ROLLED STEEL STRIP GRADE 'D', DD OR 'EDD' KILLED STEEL TO IS: 4030-73

00 814-1CV 15-1-2000	(B)	EQ MATERIAL ADDED
00 497-1CV 15-1-95	(A)	NOTE NO 4 FOR EQUIVALENT MATERIAL ADDED
DC(I) No. & DATE	ISSUE	AMENDMENTS

APPROVED	<u>Plan</u>	672-54-6			
CHECKED	<u>Briney</u>	BAND		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				SEE TABLE	2:1
			SHT 1 SHTS 1		
		BAND 10-M-2-A-0.5x9 GOST 503-81			

672-54-9



DESIGNATION	WIRE DIA mm	D, mm	d, mm	H, mm	α , mm	S, * mm	R, mm	MASS, Kgs.
672-54-9	4	3,5	7			0,5		0,0074
-01			9					
-02	6	5,5	7			0,8		0,008
-03								
-04			9			0,5		0,003
© (E) -05			7					
-06	8	7,5	9			0,8		0,008
-07			7					
-08			9	25	8	0,5		0,005
-09			7					
-10	10	9,5	9			0,8		0,008
-11			7			0,5	2	0,005
-12			7			0,8		0,009
-13	12	11,5	9					
-14			7			0,5		0,007
© -15			7					
DS CAT PART No. LV2/ICVs5340-017034 -16	15	14	9	41	11	0,8		0,016
-17			13					0,014
-18						1,5		0,026
-19	18	17	7					0,010
-20			9					
-21	20	19		30				0,011
-22	24	23						0,013
DS CAT PART No. LV2/ICVs5340-017033 -23	27	26			8	0,8		0,015
DS CAT PART No. LV2/ICVs5340-017032 -24	30	29	7	35				0,017
-25	32	31		40			4	0,018
-26	36	35						0,019
-27	42	41		45				0,023

TECHNICAL CONDITIONS

1. Substitute for material- steel 08kn, 10kn, 10, GOST 1050-74
2. Unspecified limit deviations of sizes +_ 0.5 mm.
3. *Sizes are given for reference.
4. Coating: Zinc plated 9 microns thick chromotized.
Remove hydrogen embrittlement.
- ⑤ EQ. MATERIAL:- Gde 'D' To IS: 513-86.
- ⑥ EQ. MATERIAL:- Cold rolled steel strip Gr 'D' or 'DD' To IS: 4030-74.
- ⑦ EQ. MATERIAL:- Cold rolled steel strip Grade 'D' killed steel To IS:- 4030-73 For 672-54-9-05 and 672-54-9-15.
- ⑧ EQ. MATERIAL:- Gde 'D' To IS: 513-94 (For 672-54-9-05).

01005-121	⑤	EQ. MATERIAL ADDED.
24-10-85	⑥	DS CAT PART No. ADDED.
01002-121	⑦	EQ. MATERIAL ADDED.
00818	⑧	EQ. MATERIAL ADDED.
00717-121	⑨	EQ. MATERIAL ADDED.
0063-121	⑩	Gde 'D' TO IS: 513-86 ADDED AS EQ. MATERIAL.
016-30	⑪	AMENDMENTS

NEAREST EQ. MATERIAL

BAND 10-M-HT-2-S, GOST 503-81

ORGL MATERIAL:-

ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF

DRG. NOT TO BE SCALED

SCALE:

DATE: 27-2-91

DRN.

TCD.

CHD

APPD

WT :- (Kg)

SEE TABLE

ALL THREADS TO CONFORM TO SPECIFICATION

TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED

STAMP OR ETCH, PART No. MANUFACTURER'S NAME & YEAR OF MFR.

USED ON:
675-05-Sb2

672-54-9

CLAMP

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)THE ABBRIVATIONS AND SYMBOLS ARE
BASED ON RUSSIAN SPECIFICATIONS.

ALL DIMENSIONS ARE IN mm.

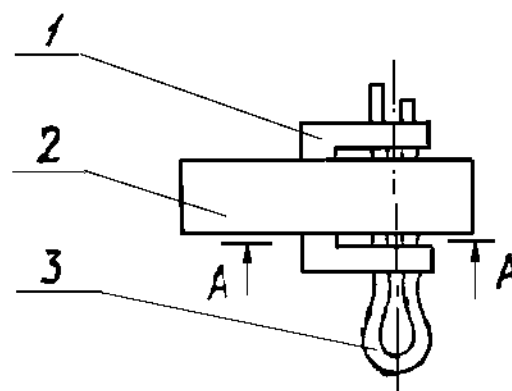
Ref. No.	Designation	Description	Qty	Remarks
A 3	672-54-c62 CB	<u>List of Documents</u> Assembly drawing		
	672-54-5	<u>Parts</u> Frame	1	
	672-32-11	Standard Items A Cotter pin 6.3x20.019 FOCT 397-79	1	
		<u>Variable Data for Versions</u> 672-54-c62		
	672-54-6	<u>Parts</u> Band	1	
	672-54-6-01	<u>Parts</u> Band	1	
	672-54-6-02	<u>Parts</u> Band	1	
	672-54-6-03	<u>Parts</u> Band	1	
	672-54-6-04	<u>Parts</u> Band	1	
	672-54-6-05	<u>Parts</u> Band	1	
	672-54-6-06	<u>Parts</u> Band	1	
	672-54-6-07	<u>Parts</u> Band	1	
	672-54-6-08	<u>Parts</u> Band	1	
	672-54-6-09	<u>Parts</u> Band	1	
		0529-ICV 10 OCT 95 DCC NO. & DATE	A	REF. NO. 3 :- DESIGNATION 672-32-11 ADDED. DESCRIPTION COLUMN :- HEADING, STANDARD ITEMS DELETED.
		NATURE OF AMENDMENTS		

APPROVED	672-54-Sb2 MULTIPURPOSE CLAMP		
CHECKED		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		SHT 1	SHTS 2

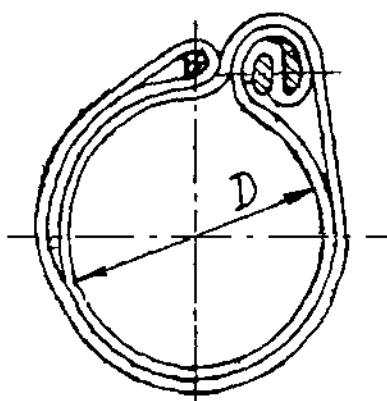
Ref. No.	Designation	Description	Qty	Remarks
2	672-54-6-10	672-54-c62-10 <u>Parts</u> Band	1	
2	672-54-6-11	672-54-c62-11 <u>Parts</u> Band	1	
2	672-54-6-12	672-54-c62-12 <u>Parts</u> Band	1	
2	672-54-6-13	672-54-c62-13 <u>Parts</u> Band	1	
2	672-54-6-14	672-54-c62-14 <u>Parts</u> Band	1	
2	672-54-6-15	672-54-c62-15 <u>Parts</u> Band	1	
2	672-54-6-16	672-54-c62-16 <u>Parts</u> Band	1	
2	672-54-6-17	672-54-c62-17 <u>Parts</u> Band	1	
2	672-54-6-18	672-54-c62-18 <u>Parts</u> Band	1	
2	672-54-6-19	672-54-c62-19 <u>Parts</u> Band	1	
2	672-54-6-20	672-54-c62-20 <u>Parts</u> Band	1	
2	672-54-6-21	672-54-c62-21 <u>Parts</u> Band	1	
2	672-54-6-22	672-54-c62-22 <u>Parts</u> Band	1	

APPROVED		672-54-Sb2			
CHECKED		MULTIPURPOSE CLAMP		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)					
			SHT 2	SHTS 2	

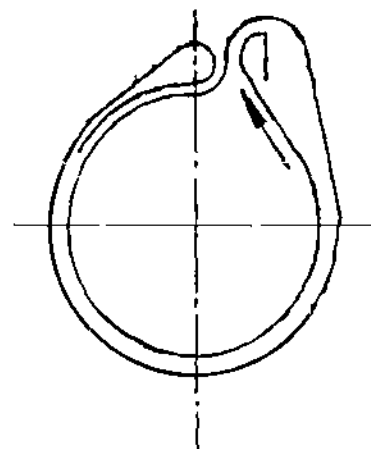
672-54-Sb2Sb



A - A



Band winding diagram



DESIGNATION	HOSE OUTER DIA, mm	MASS kg	DESIGNATION	HOSE OUTER DIA, mm	MASS kg
672-54-cd 2	13 - 16	0.019	672-54-cd 2-18	97 - 103	0.04
Ⓐ DS CAT.No.LV2/ICVS 4730 071487	17 - 20	0.019	-19	113 - 120	0.044
-02	21 - 24	0.021	-20	121 - 130	0.046
-03	25 - 28	0.022	-21	230 - 235	0.072
Ⓐ LV2/ICVS. 4730 071488	29 - 32	0.022	-22	310 - 318	0.095
-04	33 - 35	0.023			
-05	37 - 40	0.024			
Ⓐ LV2/ICVS. 4730 071488	41 - 44	0.025			
-06	45 - 48	0.026			
Ⓐ LV2/ICVS 4730 071485	49 - 52	0.026			
-07	53 - 56	0.027			
-08	57 - 60	0.028			
Ⓐ LV2/ICVS 4730 071483	61 - 64	0.029			
-09	65 - 68	0.03			
-10	77 - 80	0.033			
Ⓐ LV2/ICVS 4730 071484	81 - 84	0.033			
-11	85 - 88	0.034			
-12	93 - 96	0.037			
-13					
-14					
-15					
-16					
-17					

- 13) when the clamp is tightened, one end of band 2 should have at least two turns on cotter pin 3 and its second end should be unbent at approximately $1/4$ of the hose circumference length.

01047-ICV
198
18-07-07

Ⓐ

DS CAT PART No. ADDED AND
NOMENCLATURE WAS
"CLAMP HOSE".DC(I)No.
& DATE

ISSUE

AMENDMENTS

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

672-54-Sb2Sb

MULTIPURPOSE CLAMP

WEIGHT

SCALE

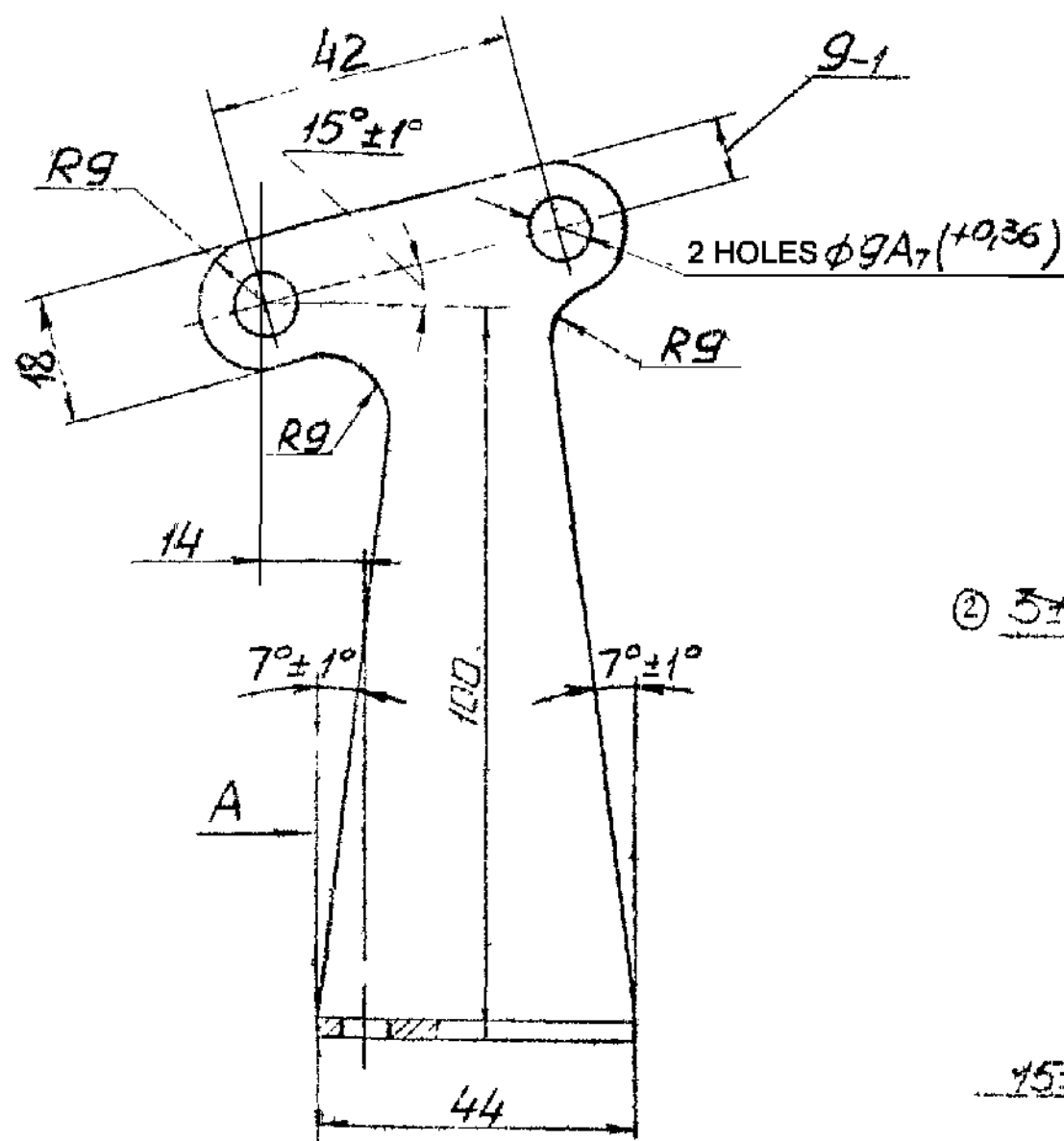
SEE
TABLESEE
TABLE

SHT 1

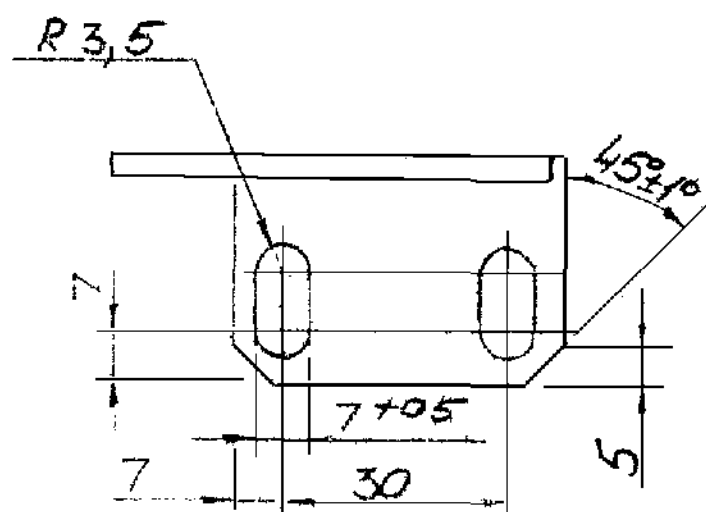
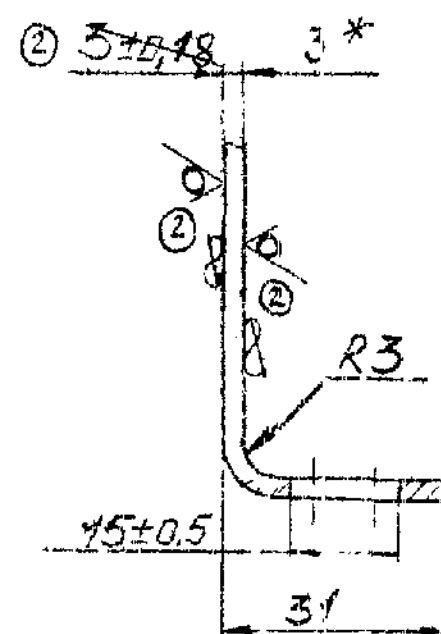
SHTS 1

675-84-15

R₂ 160
✓(✓) ②



VIEW-A



TECHNICAL CONDITIONS

1. Substitute for material - steels cr.3cn, cr.3nc ГОСТ 380-71 and steels 08nc, 10nc ГОСТ 1050-74.
2. Ensure sizes without deviation accurate to ±1 mm.
3. Displacement of hole axes from rated position - 0.5 mm, maximum.
4. ^{II}Size is given for reference.

⑤ EQ.MATERIAL:-St 34 TO IS:1079-73

⑥ EQ.MATERIAL:-COLD ROLLED STEEL SHEET EDD/DD TO IS:4030-74

00806-IV NY 14.9.2000	⑥	EQ.MATERIAL ADDED
0063 - ICV V. Romanov 01.6.98	⑤	St 34 TO IS:1079-73 ADDED AS EQ.MATERIAL
DC(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

675-84-15

BRACKET

SHEET 5-Пy-0-3, GOST 19903-74
5-II-Г-10, GOST 16523-70

WEIGHT SCALE

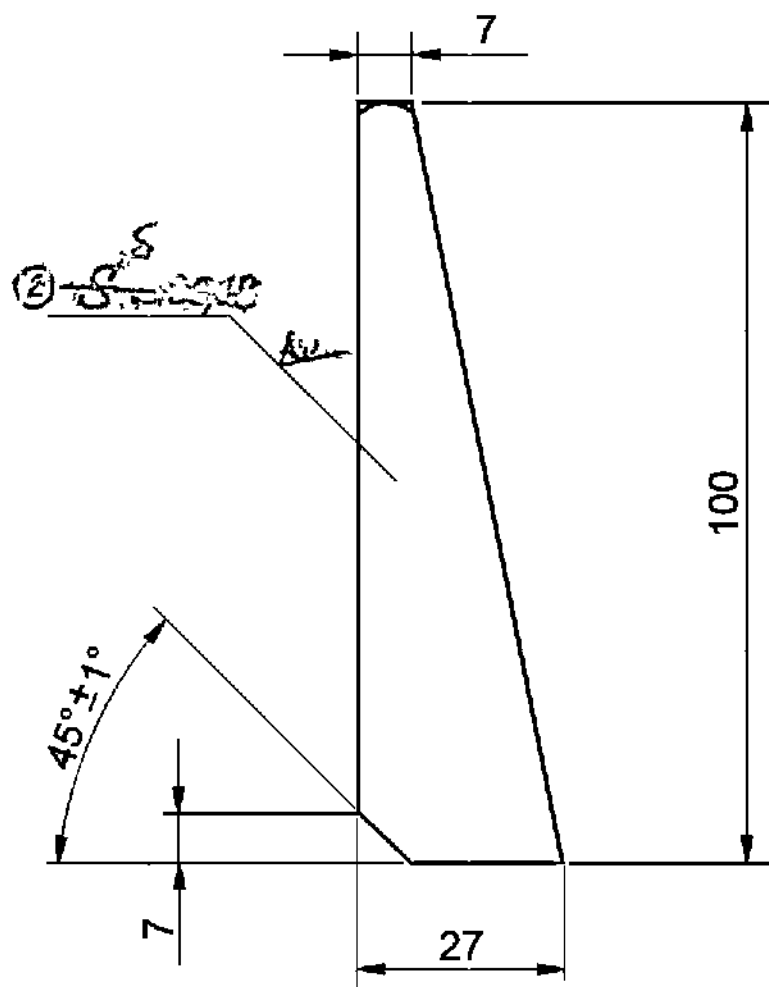
0.1 1:1

SHT 1 SHTS 1

675-84-16

R_z 160

V/M/②



TECHNICAL CONDITIONS

1. Substitute for material - steels cr.3cn, cr.3nc ГОСТ 380-71 and steels 08nc, 10nc ГОСТ 1050-74.
 2. Ensure sizes without deviation accurate to ± 1 mm.
 3. ¹²Size is given for reference.
- ① EQUIVALENT MATERIAL: COLD ROLLED STEEL SHEET EDD/DD TO IS: 4030-74

00806-ICV

14-9-2000

DC(I)No.
& DATE

①

ISSUE

EQ. MATERIAL ADDED.

AMENDMENTS

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

675-84-16

POST

WEIGHT

SCALE

0.04

1:1

SHT 1

SHTS 1

SHEET

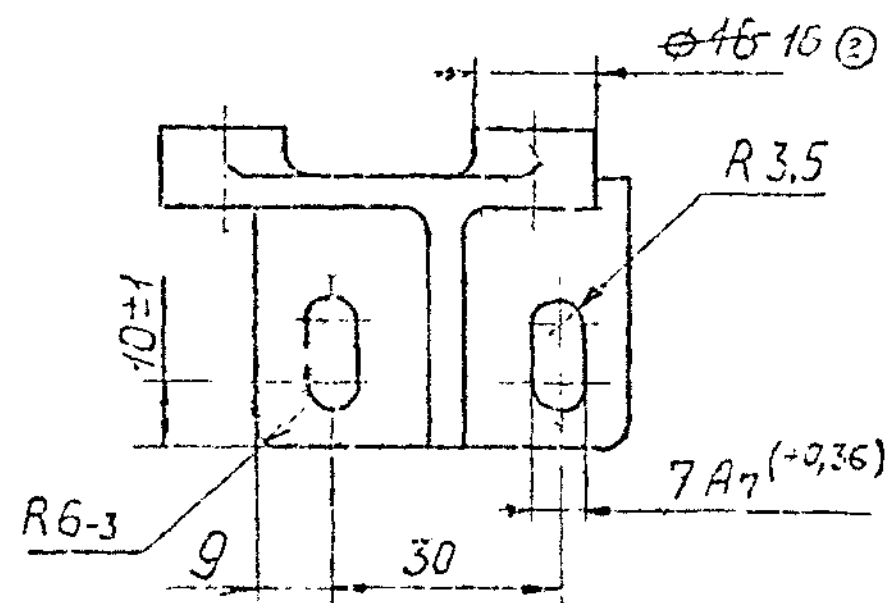
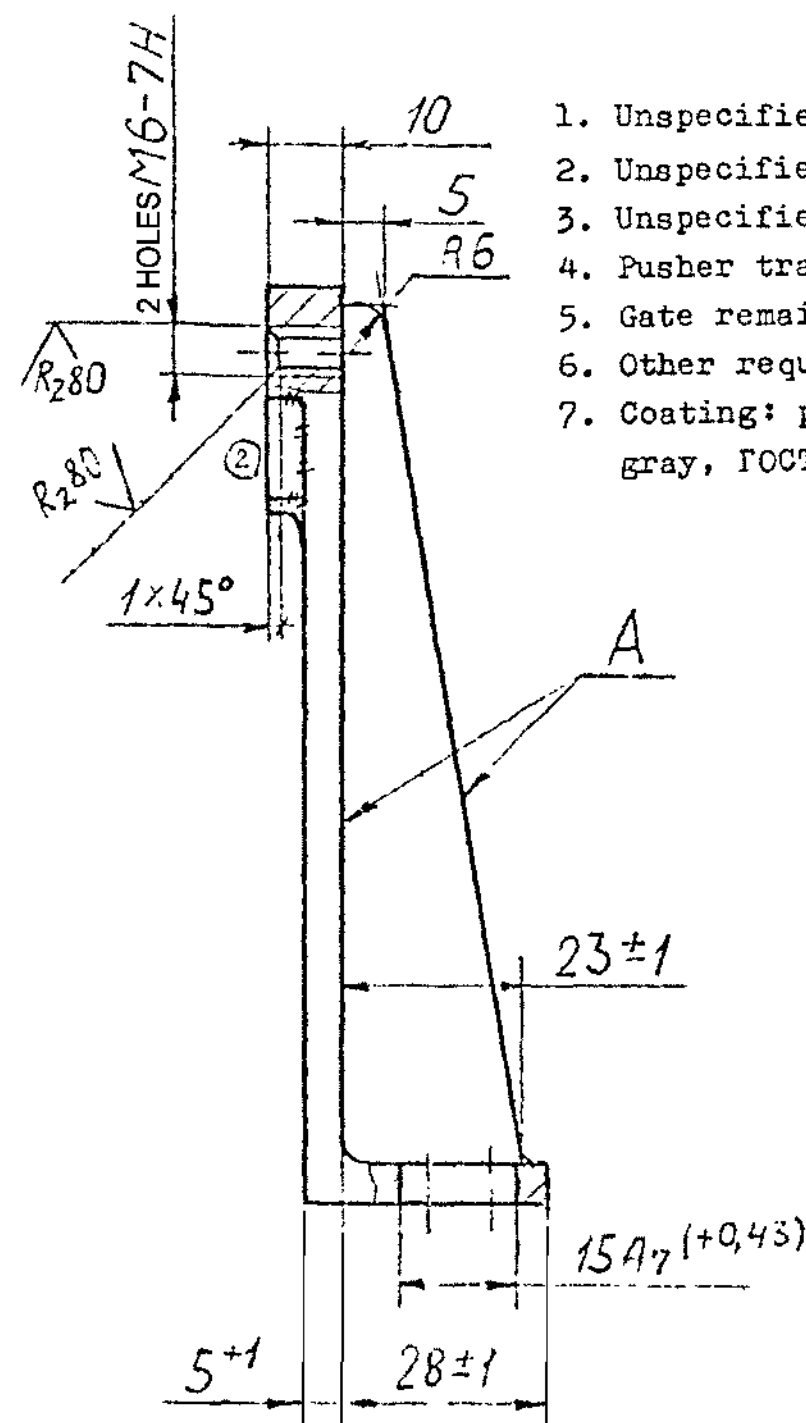
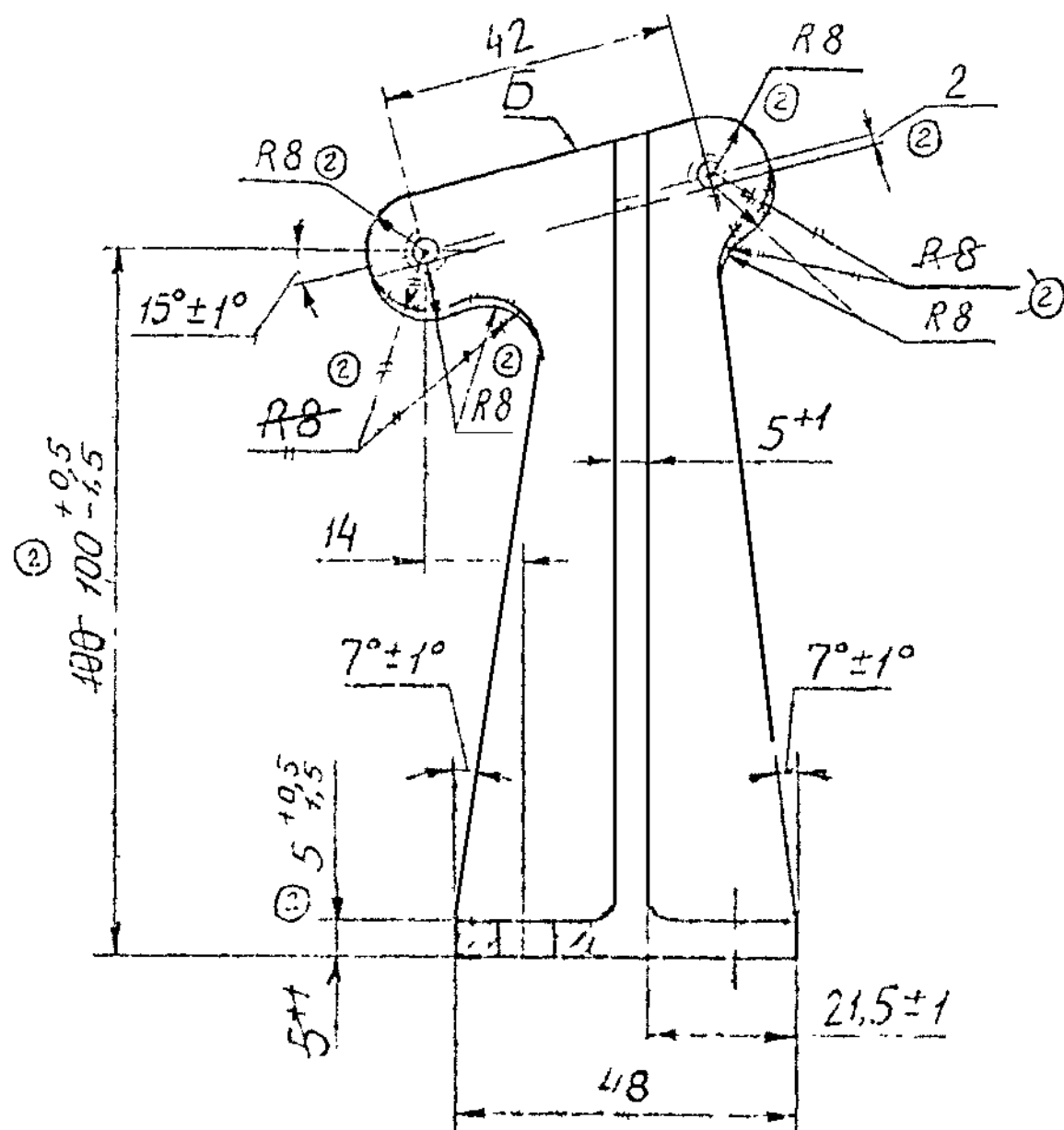
Б-Пы-0-3, GOST 19903-74

5-II-Г-10, GOST 16523-70

675-84-21

TECHNICAL CONDITIONS

1. Unspecified casting radii - 3 mm, maximum.
2. Unspecified drafts - 2° , maximum.
3. Unspecified limit deviations of sizes - ± 0.5 mm.
4. Pusher traces of up to 0.5 mm on surface A are tolerable.
5. Gate remainder up to 1 mm high on surface B is tolerable.
6. Other requirements to casting - according to ТТАЛ-436.
7. Coating: primer ФЛ-03Х ГОСТ 9109-81; enamel ПФ-223, dark gray, ГОСТ 1492-78 (except for thread and holes).



APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

675-84-21

BRACKET

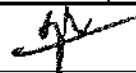
АЛ 9 АДН .167-82 ТУ

WEIGHT SCALE

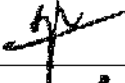
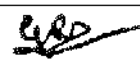
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SHT 1 SHTS 1

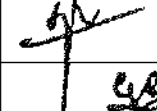
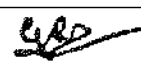
Designation	Description	Parent unit		Total qnty	Remarks
		designation	qnty		
675-84-c62	Smoke generating equipment				
675-84-c6109	Pipe	675-84-c62	1	1	
675-84-c6109-01	Pipe	675-84-c62	1	1	
675-84-c6109-02	Pipe	675-84-c62	1	1	
675-84-c6109-03	Pipe	675-84-c62	1	1	
675-84-c6109-04	Pipe	675-84-c62	1	1	
675-84-c6111	Pipe	675-84-c62	1	1	
675-84-c6112 or	Bracket	675-84-c62	1	1	
675-84-21	Bracket				
672-54-c62-03	Multipurpose clip	675-84-c62	2	2	
765-84-c6132	Plunger	765-84-c6210	1	1	
765-84-c6133	Bracket	675-84-c62	1	1	
765-84-c6146	Casing	765-84-c6148	1	2	
765-84-c6147	Filter	765-84-c6148	1	2	
765-84-c6148	Filter	675-84-c62	2	2	
765-84-c6161	Pipe	675-84-c62	1	1	
765-84-c6181	Valve	675-84-c62	1	1	
765-84-c6182	Pipe	675-84-c62	1	1	
765-84-c6210	Valve	675-84-c62	1	1	
	Relay PM6-1C	765-84-c6210	1	1	
	PM6-1C.000 TV				commercial
765-84-c6238	Pipe	675-84-c62	1	1	
765-84-c6253	Injector	675-84-c62	2	2	
675-84-12	Pipe	675-84-c6109	1	1	W/o Drawing
675-84-12-01	Pipe	675-84-c6109-01	1	1	W/o Drawing
675-84-12-02	Pipe	675-84-c6109-02	1	1	W/o Drawing
675-84-12-03	Pipe	675-84-c6109-03	1	1	W/o Drawing
675-84-12-04	Pipe	675-84-c6109-04	1	1	W/o Drawing
675-84-14	Pipe	675-84-c6111	1	1	W/o Drawing

APPROVED		675-84-cn2			
CHECKED					
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		SMOKE GENERATING EQUIPMENT		WEIGHT	SCALE
				SHT 1	SHTS 8

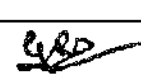
Designation	Description	Parent unit		Total qty	Remarks
		designation	qty		
675-84-15	Bracket	675-84-c6112	1	1	
675-84-16	Post	675-84-c6112	1	1	
672-54-5	Frame	672-54-c62-03	1	2	
672-54-6-03	Band	672-54-c62-03	1	2	
765-84-6	Nipple	675-84-c6109	2	2	
		675-84-c6109-01	2	2	
		675-84-c6109-02	2	2	
		675-84-c6109-03	2	2	
		675-84-c6109-04	2	2	
		765-84-c6161	2	2	
		765-84-c6182	2	2	
765-84-43	Clamp	675-84-c62	1	1	
765-84-51	Pipe Union	765-84-c6210	1	1	
765-84-53	Plunger	765-84-c6132	1	1	
765-84-54	Ring	765-84-c6132	1	1	
765-84-50 or	Body	765-84-c6210	1	1	
765-84-210	Body				
765-84-60	Bracket	765-84-c6133	1	1	
765-84-61	Pipe Union	765-84-c6146	1	2	
765-84-62	Pipe	765-84-c6146	1	2	
765-84-59 or	Pipe Union	765-84-c6210	1	1	
765-84-211					
765-84-75	Pipe Union	675-84-c6147	1	2	
765-84-77	Pipe Union	675-84-c62	1	1	
765-84-83	End-piece	765-84-c6238	1	1	
765-84-81	Swirler	765-84-c6253	1	2	
765-84-90	Gasket	675-84-c62	2	2	
765-84-106	Pipe	765-84-c6253	1	2	
765-84-131	Body	765-84-c6181	1	1	
765-84-184	Injector	765-84-c6253	1	2	
765-84-190	Pipe	765-84-c6238	1	1	
765-84-191	Adapter	765-84-c6238	1	1	

APPROVED		675-84-cn2			
CHECKED					
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		SMOKE GENERATING EQUIPMENT		WEIGHT	SCALE
				SHT 2	SHTS 8

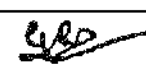
Designation	Description	Parent unit		Total qty	Remarks
		designation	qty		
765-84-213	Pipe	765-84-c6161	1	1	W/o Drawing
765-84-214	Pipe	765-84-c6182	1	1	W/o Drawing
765-84-216	Flange	765-84-c6253	1	2	
765-84-217	Hose	765-84-c6253	1	2	
765-84-218	End-piece	765-84-c6253	1	2	
765-05-73	Casing	765-84-c6147	1	2	
765-05-74	wire net	765-84-c6147	1	2	
765-05-75	Bottom	765-84-c6147	1	2	
765-06-455/461	Gasket	675-84-c62	2	2	
765-06-456	Gasket	675-84-c62	6	6	
765-71-364-01	Flange	765-84-c6210	1	1	
765-78-1257	Jet	675-84-c6111	1	1	
765-10-2359	Sleeve	765-84-c6253	2	4	
672-29-24	Stud	765-84-c6210	2	2	DC(1) 00414-ICV
700-30-241	Union nut	675-84-c6111	2	2	
700-30-406	Nut	765-84-c6146	1	2	
700-30-410	Nut	675-84-c62	1	1	
700-30-492	Nut	675-84-c62	8	8	
700-31-771	Washer	675-84-c62	8	8	
700-31-602	Washer	765-84-c6132	1	1	
		765-84-c6210	1	1	
700-33-4	Union nut	675-84-c6109	2	2	
		675-84-c6109-01	2	2	
		675-84-c6109-02	2	2	
		675-84-c6109-03	2	2	
		765-84-c6161	2	2	
		765-84-c6182	2	2	
700-33-90	Union nut	765-84-c6238	1	1	
		765-84-c6253	1	2	
700-38-7	Spring	765-84-c6181	1	1	
700-40-237	Gasket	765-84-c6181	1	1	
* { 700-40-61	Gasket	765-84-c6210	6	6	* DC(1) 00548-ICV Max. qty
LV2/RCV-5230-01A465					
700-42-153	Ring	765-84-c6210	1	1	
700-40 260-12	GASKET	675 84- c6 2	1	1	
272-16-28	BOLT	765 84- c6 210	2	2	} DC(1) 00414-ICV

APPROVED		675-84-cn2			
CHECKED					
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		SMOKE GENERATING EQUIPMENT		WEIGHT	SCALE
				SHT 3	SHTS 8

Designation	Description	Parent unit		Total qty	Remarks
		designation	qty		
700-56-225	T- Joints	675-84-c62	1	1	
700-57-403	Nipple	675-84-c6111	1	1	
700-57-404	Nipple	675-84-c6111	1	1	
701-24-20	Spring	765-84-c6210	1	1	
730-84-78	Plug	765-84-c6181	1	1	
770-72-149	Sealing ring	765-84-c6210	1	1	
700-54-185	Clamp	675-84-c62	1	1	
672-54-9-05	Clamp	675-84-c62	2	2	
672-54-9-15	Clamp	675-84-c62	5	5	
672-32-11	Cotter pin	672-54-c62-03	1	2	
700-40-196/203	Gasket	765-84-c6148	1	1	DC(1)00414-ICV
EQUIVALENT MATERIAL 20C8 TO IS 1570-79	Bolt M6x14.46.019	675-84-c62	9	9	
	FOCT 7798-70				
	Bolt M8x12.46.019	675-84-c62	1	1	
	FOCT 7808-70				
	Bolt M8x20.46.019	675-84-c62	1	1	
	FOCT 7796-70				
	Bolt M8x30.88	675-84-c62	8	8	
	38XC019				
	FOCT 7796-70				
	Bolt M6x12x12	675-84-c6112	2	2	
4368-0612	OCT 3-1496-72				DC(1)NO 00839-ICV
4368-0812	Boss M8x16x12	765-84-c6133	1	1	
	OCT 3-1496-72				
	Nut M6.6.019	765-84-c6210	4	4	
	FOCT 5927-70				
	Ring 10x16	675-84-c62	5	5	
	MH4152-62				
	Wire K01				
	FOCT 792-67				
	L = 200	675-84-c62	15	15	
		765-84-c6181	1	1	DC(1) 00500-ICV
		765-84-c6210	1	1	

APPROVED		675-84-cn2			
CHECKED					
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		SMOKE GENERATING EQUIPMENT		WEIGHT	SCALE
				SHT 4	SHTS 8

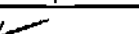
Designation	Description	Parent unit		Total qnty	Remarks
		designation	qnty		
INDIAN EQUIVALENT: MILD STEEL WIRE, GALVANISED, 2 MM DIA. 1/4 HARD TO IS:280-78. UTS 37 Kg/mm ² (MIN). EQ MATERIAL (GRADE 10 C4 TO IS 1570-79 (ii) GRADE 15 C4 TO IS 1570-79 EQ MAT C-30 TO IS 1570-79* (Ref DC(1) 00957-ICV) EQUIVALENT MATERIAL (i) GRADE 50 CY IV 23 TO IS 1570 (ii) EN-47 TO BS 970	L = 100	765-84-c6148	1	1	DC(1) 00500 -ICV
	Wire K02	765-84-c6210	1	1	
	FOCT 792-67				
	L = 15				
	40Y16-1,3(13)	675-84-c62	1	1	
	TY 005.6016-80				
	L = (100±2.5) mm				
	Washer 6x1.01.019	675-84-c62	2	2	DC(1) N000839 -ICV
	or 6x1.02.019				
	FOCT 11371-78*	765-84-c6181	5	5	Max.qnty
	Washer 18x1.01.05	675-84-c62	1	1	
	or 18x1.02.05				
	FOCT 11371-78				
	Washer 6T65T06	675-84-c62	9	9	DC(1) N000839 -ICV
	FOCT 6402-70	765-84-c6210	42	42	
	Washer 8T65T06	675-84-c62	2	2	DC(1) 00414-ICV
	FOCT 6402-70				
	Ball B711-1MM	765-84-c6181	1	1	
	FOCT 3722-81 and				
	ETV 500				
	Primer ФЛ-03K	675-84-c6111			
	FOCT 9109-81	675-84-c6112			
		700-54-185			
		675-84-c6109			
		675-84-c6109-01			
		675-84-c6109-02			
		675-84-c6109-03			
		675-84-c6109-04			
		675-84-21			
		765-84-c6161			
		765-84-c6182			

APPROVED		675-84-cn2			
CHECKED					
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		SMOKE GENERATING EQUIPMENT		WEIGHT	SCALE
				SHT 5	SHTS 8

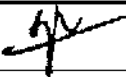
Designation	Description	Parent unit		Total qty	Remarks
		designation	qty		
	Graphite П, grade A or B ГОСТ 8295-73 Varnish ГФ-95 ГОСТ 8018-70 Phenol-formalde- hyde lacquer ЛБС-1 ГОСТ 901-78 Burning kerosene ГОСТ 4753-68 Lubricant ЛУБРОЛ-2- ГОСТ 21150-75 or MC-70 ГОСТ 9762-76 Varnish КО-815 ГОСТ 11066-74 Solder ПОССу 30-2 ГОСТ 21931-76 Solder Л-63 ГОСТ 15527-70 Gasoline-resistant grease ГОСТ 7171-78 or grease ЦИАТИМ-201 ГОСТ 6267-74	675-84-c62 675-84-c6111 675-84-c6109 675-84-c6109-01 675-84-c6109-02 675-84-c6109-03 675-84-c6109-04 765-84-c6146 765-84-c6161 765-84-50 765-84-210 675-84-c62 765-84-c6133 765-84-c6238 765-84-6 765-84-53 765-84-c6253 765-84-c6147 765-84-c6147 675-84-c62			

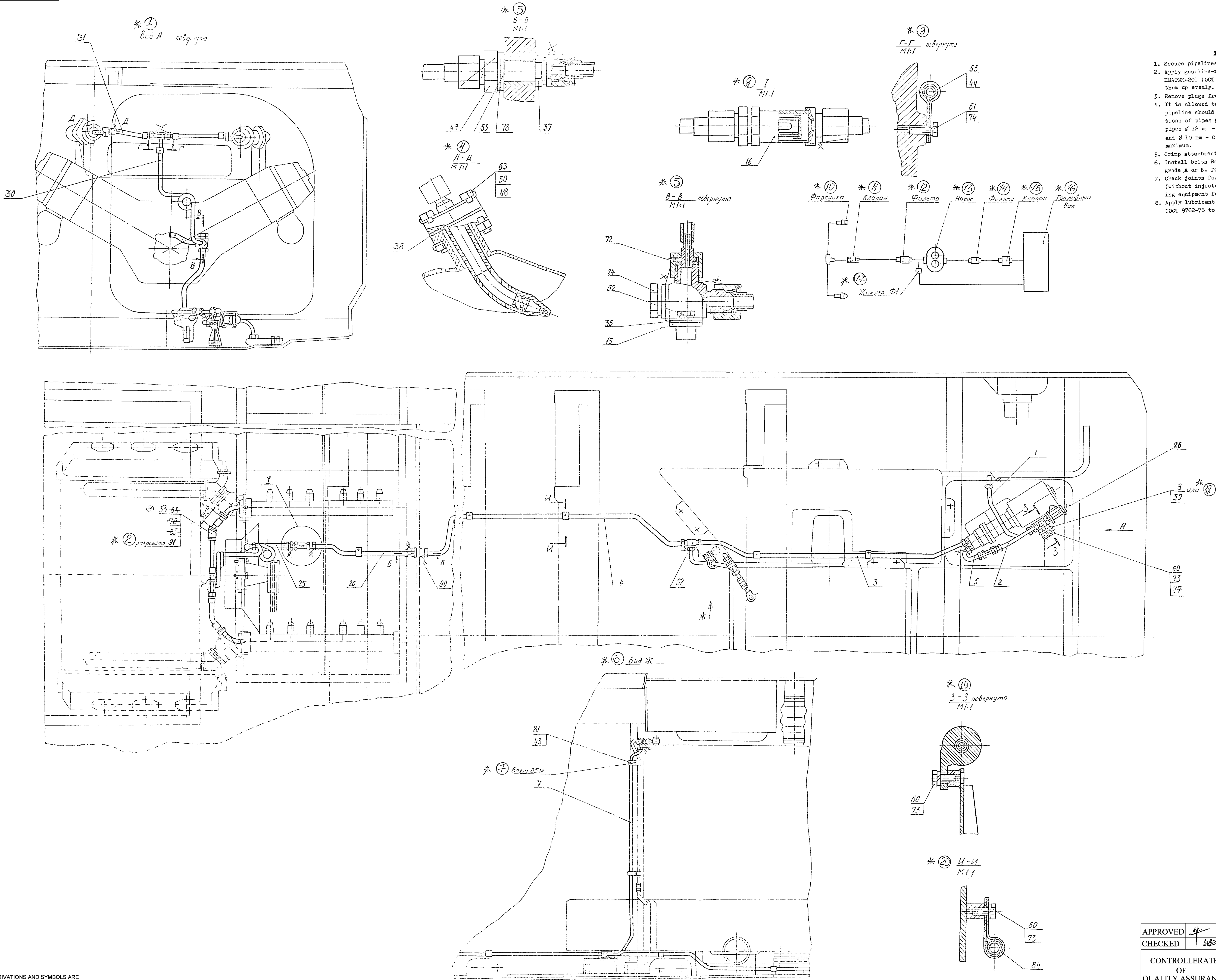
APPROVED		675-84-cn2			
CHECKED		SMOKE GENERATING EQUIPMENT		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)					
			SHT 6 SHTS 8		

Designation	Description	Parent unit		Total qty	Remarks
		designation	qty		
ИЛ09-73 053.25289.00002	Iron minium ГОСТ 8866-76	765-84-c6210			
	Aluminum powder ПАП-1 or ПАП-2	765-84-c6238			
	ГОСТ 5494-71	765-84-c6253			
	Solder Псп40 ГОСТ 19738-74	765-84-c6253			
	Enamel ПФ-223, yellow, ГОСТ 14923-78	675-84-c6109			
		675-84-c6109-01			
		675-84-c6109-02			
		675-84-c6109-03			
		675-84-c6109-04			
		675-84-c6111			
		700-54-185			
		765-84-c6161			
		765-84-c6182			
	Enamel ПФ-223, dark-grey, ГОСТ 14923-78	675-84-c6112			
		675-84-21			
	Enamel ПФ-223, red, ГОСТ 14923-78	765-84-c6146			
	Electrode 342 ГОСТ 9467-75	765-84-c6133			
	Wire лсв.08Х20Н9Г.7Т ГОСТ 2246-70	765-84-c6253			
	Instructions for coating parts with varnish ПФ-95				
	Instructions for impregnation of phosphatized and				

APPROVED		675-84-cn2			
CHECKED		SMOKE GENERATING EQUIPMENT		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)					
			SHT 7	SHTS 8	

Designation	Description	Parent unit		Total qnty	Remarks
		designation	qnty		
053.25273.000.10	chrome-plated parts with preservation oil K-17				
TY 005.6016-80	Instruction for bakelizing parts				
TY 005216-75	Specifications for gasket-type hoses and couplings				
TTLN-408	Rubber items, plates and rubber compositions for special vehicles and their engines				
TY 3-624-76	Technical requirements for acceptance of castings made of alluminum and bronze alloys				
TY 81-04-395-75	Blanks for manufacture of critical parts from metal-based materials by powder metallurgy. Specifications				
PM6-1C.000 TY	Fibre parts				
TT, AJ-436	Specifications for relay PMC-1C				
	Technical requirements for casting and acceptance of parts made of alloys AJ9, AJ32 by liquid stamping				

APPROVED		675-84-cn2			
CHECKED					
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		SMOKE GENERATING EQUIPMENT			WEIGHT
					SCALE
				SHT 8	SHTS 8



- TECHNICAL CONDITIONS
- Secure pipelines with clamps and tighten them up.
 - Apply gasoline-resistant grease GOCT 7171-75 or grease UNATM-201 GOCT 6267-74 to all threaded joints and tighten them up evenly.
 - Remove plugs from pipes just prior to assembly.
 - It is allowed to bend pipes during assembly. In this case, pipeline should be disconnected from assemblies. Corrugations of pipes $\varnothing$ 8 mm and $\varnothing$ 10 mm - 1 mm, maximum, and of pipes $\varnothing$ 12 mm - 1.5 mm, maximum. Ovality of pipes $\varnothing$ 8 mm and $\varnothing$ 10 mm - 0.5 mm maximum, and of pipes $\varnothing$ 12 mm - 1 mm, maximum.
 - Crimp attachment clamps in situ.
 - Install bolts Ref. No. 63 on intimate mixture of graphite II, grade A or B, GOCT 8295-73 with water.
 - Check joints for freedom fuel leakage and flush system (without injectors) by switching on pump of smoke generating equipment for 2 to 3 min. Leakage is not tolerable.
 - Apply lubricant Liton-24 GOCT 21150-75 or NG-70 GOCT 9762-76 to threaded joints on article bottom.

- * (1) View A revolved
* (2) Out 91
* (3) E - E
Scale 1:1
* (4) H - H
Scale 1:1
* (5) B - B
Scale 1:1
* (6) View H
* (7) Bolt, 0.5 gr
* (8) I
Scale 1:1
* (9) F - F revolved
Scale 1:1
* (10) Injector
* (11) Valve
* (12) Filter
* (13) Pump
* (14) Filter
* (15) Valve
* (16) Fuel tank
* (17) Jet
* (18) or
* (19) 3 - 3 revolved
Scale 1:1
* (20) M - M
Scale 1:1

APPROVED	4/	675-84-Sb2Sb	
CHECKED	1/	SMOKE GENERATING EQUIPMENT	
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		WEIGHT	SCALE
		5.837 (A)	1:5
		SHT	SHTS

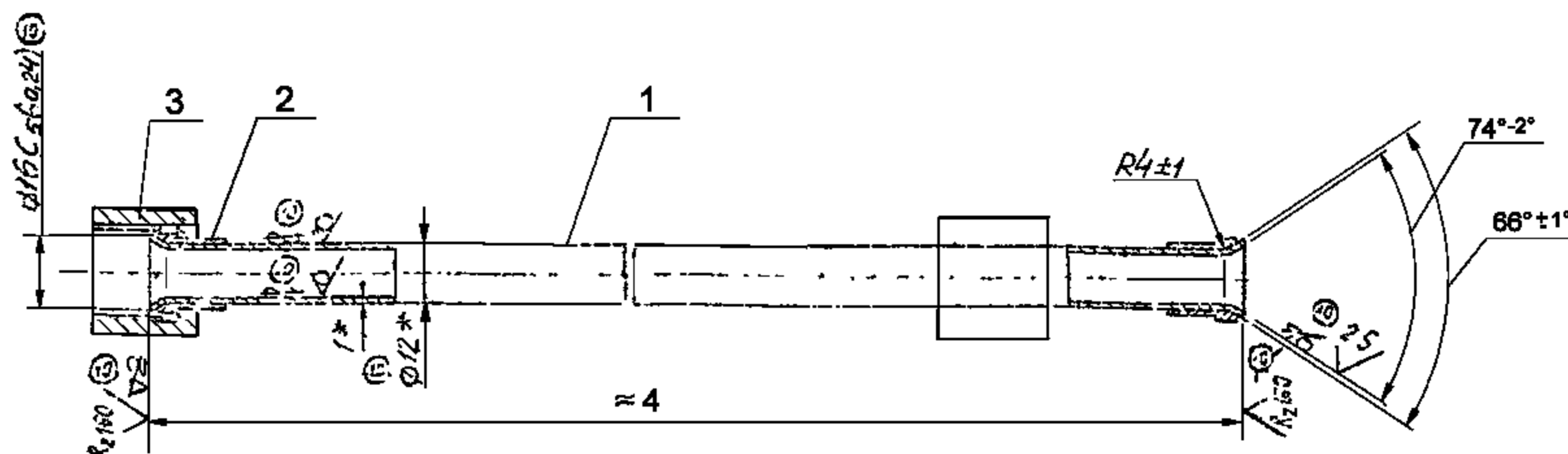
00130-ICV	IN WEIGHT COLUMN WEIGHT WAS 5.315 (D-469/ICV)
25/8-89	AMENDMENTS
DATE	ISSUE

Ref. No.	Designation	Description	Qty	Remarks																
	675-84-c6109CE	<u>Documents</u> Assembly drawing																		
		<u>Parts</u>																		
2	765-84-6	Nipple	2																	
3	700-33-4	Union nut	2																	
		<u>Variable Data for Manufacture</u>																		
		675-84-c6109																		
		<u>Parts</u>																		
② 1	675-84-12, w/D EQUIVALENT MATERIAL: Material Gde 64430, IS: 738-77, WP' Condition	Pipe Round pipe 12x1 AMr6M POCT 18475-73 L = 390 ①	1	0.02 kg																
③	EQUIVALENT MATERIAL: AL. ALLOY TUBE GRADE 54300 TO IS: 1285-75.	675-84-c6109-01																		
		<u>Parts</u>																		
② 1	675-84-12-01 w/D EQUIVALENT MATERIAL: Material Gde 64430, IS: 738-77, WP' Condition	Pipe Round pipe 12x1 AMr6M POCT 18475-73 L = 200 ①	1	0.01 kg																
③	EQUIVALENT MATERIAL: ALUMINIUM ALLOY TUBE GRADE 54300 TO IS: 1285-75	675-84-c6109-02																		
		<u>Parts</u>																		
② 1	675-84-12-02 w/D EQUIVALENT MATERIAL: MATERIAL Gde 64430, IS: 738-77, WP' Condition	Pipe Round pipe 12x1 AMr6M POCT 18475-73 L = 1190 ①	1	0.155 kg																
③	EQUIVALENT MATERIAL: ALUMINIUM ALLOY TUBE GRADE 54300 TO IS: 1285-75	675-84-c6109-03																		
		<table><tr><td>00075-ICV</td><td>①</td><td colspan="2">DIMENSIONS 390, 200 & 1190 WERE 200, 100 & 1600 RESPECTIVELY. W/D ADDED FOR AGAINST PART NOS. 675-84-12, 675-84-12-01 AND 675-84-12-02</td></tr><tr><td>-89</td><td></td><td colspan="2"></td></tr><tr><td>DC(I) NO. & DATE</td><td>ISSUE</td><td colspan="2">NATURE</td></tr><tr><td colspan="4">AMENDMENT</td></tr></table>			00075-ICV	①	DIMENSIONS 390, 200 & 1190 WERE 200, 100 & 1600 RESPECTIVELY. W/D ADDED FOR AGAINST PART NOS. 675-84-12, 675-84-12-01 AND 675-84-12-02		-89				DC(I) NO. & DATE	ISSUE	NATURE		AMENDMENT			
00075-ICV	①	DIMENSIONS 390, 200 & 1190 WERE 200, 100 & 1600 RESPECTIVELY. W/D ADDED FOR AGAINST PART NOS. 675-84-12, 675-84-12-01 AND 675-84-12-02																		
-89																				
DC(I) NO. & DATE	ISSUE	NATURE																		
AMENDMENT																				
APPROVED		675-84-Sb109																		
CHECKED																				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		PIPE																		
		<table><tr><td>WEIGHT</td><td>SCALE</td></tr><tr><td>SHT 1</td><td>SHTS 2</td></tr></table>			WEIGHT	SCALE	SHT 1	SHTS 2												
WEIGHT	SCALE																			
SHT 1	SHTS 2																			

Ref. No.	Designation	Description	Qty	Remarks
⑧ 1	675-84-12-03 w/d EQUIVALENT MATERIAL: Material Gde 64430, IS: 738-77, WP' CONDITION	<u>Parts</u> Pipe Round pipe 12x1 AMr6M ROCT 18475-73 L = 1660 675-84-c6109-04 (A)	1	0.097 kg
⑨ 1	675-84-12-04 w/d EQUIVALENT MATERIAL: MATERIAL Gde 64430, IS: 738-77, WP' CONDITION	<u>Parts</u> Pipe Round pipe 12x1 AMr6M ROCT 18475-73 L = 200 (A)	1	0.03 kg

00806-ICV N.H. S. S. S. 14.9.2000	③ Cura	EQUIVALENT MATERIAL ADDED. AT REF No:1
00625-ICV S.K.S. 30 MAR 98	③ Cura	EQUIVALENT MATERIAL Gde 64430, IS: 738-77, 'WP' CONDITION ADDED FOR REF. NO 1 (1/98 NORA)
00075-ICV J -89	③ A	DIMENSIONS 1660 & 200 WERE 1000 & 300 RESPECTIVELY. W/D ADDED FOR AGAINST PART NOS. 675-84-12-03 AND 675-84-12-04.
DC(1) No. & DATE	ISSUE	NATURE
AMENDMENT		

APPROVED		675-84-Sb109			
CHECKED		PIPE		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)					
			SHT 2 SHTS 2		



TECHNICAL CONDITIONS

- Part Ref. No. 1.
 - Bend pipe and redetermine length against standard made to location;
 - ovality and corrugation at bending points - 1 mm, maximum;
 - coating: anodic oxidation with subsequent sealing in bichromate or chemically phosphatized blue.
- Pipe inner taper part should pass into cylindrical part smoothly without forming lateral ring-shaped extension.
- Bakelize the pipe inner surface with phenol-formaldehyde lacquer ЖС ГОСТ 901-78 according to Instructions 053.25273.00010 in two layers.
- From outside, except for nipple wire surfaces, surfaces under nipples and threads, coat with primer 011-03Ж ГОСТ 9109-8176 and paint with enamel ЖС-223, yellow, ГОСТ 14923-78. Paint on nipples and under them is tolerable.
- Test for leakage in water bath at air pressure of (15 ± 0.5) kgf/cm² for at least 0.5 min. Air bubbles are not tolerable. It is allowed to test by means of summer Ж-0.5 fuel or winter fuel Ж-0.5 ГОСТ 305-73 for 2 min. Leakage and sweating are not tolerable.
- Clean pipe in benzine ГОСТ 3134-78 or aviation gasoline Б-70 ГОСТ 1012-72 on special stand. Just after cleaning, close pipe ends to protect inner surfaces from contamination during transportation and at storage.
- Absence of anodic coating on expanded section of pipe Ref. No. 1 is tolerable.
- *Sizes are given for reference.

Designation	Ref. No. 1			Mass, kg	EQUIVALENT MATERIAL
	Designation	L, mm, approx.	Mass, kg		
675-84-c6109	675-84-12	390 (A)	0.02	0.106	Где 64430, 15 758-77 'WP' CONDITION. (A)
675-84-c6109-01	675-84-12-01	200 (A)	0.01	0.096	'D0' (A)
675-84-c6109-02	675-84-12-02	1190 (A)	0.155	0.24	'D0' (A)
675-84-c6109-03	675-84-12-03	1660 (A)	0.097	0.185	'D0' (A)
675-84-c6109-04	675-84-12-04	200 (A)	0.03	0.116	'D0' (A)

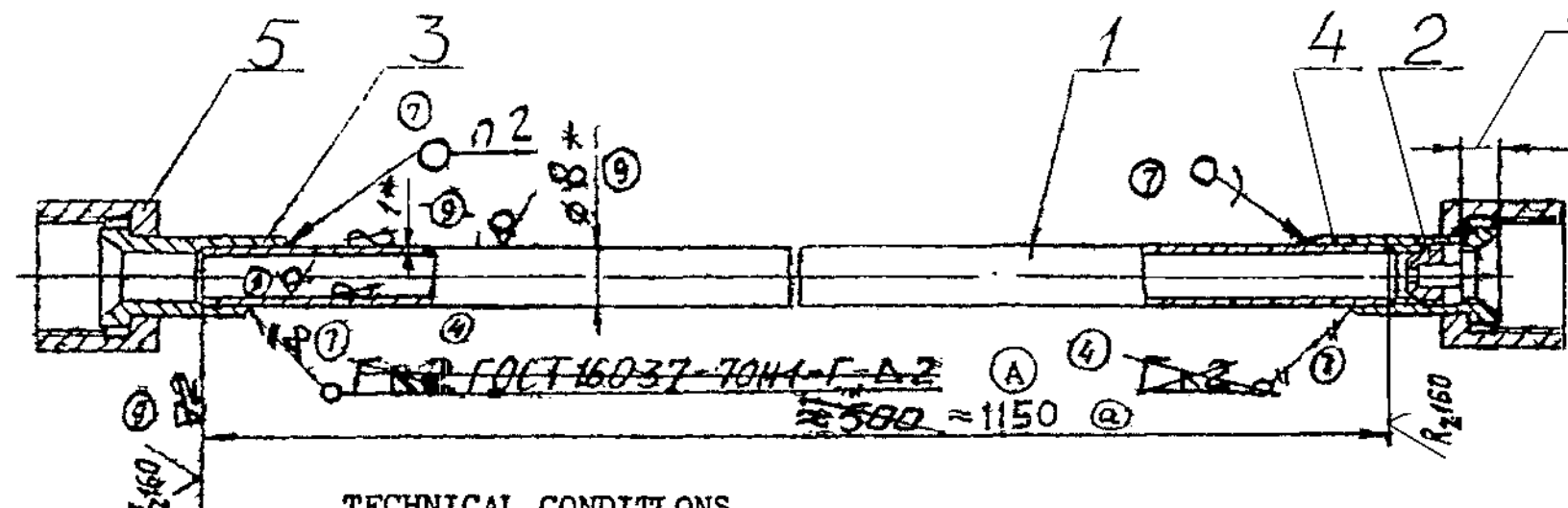
00225-1CV	(B)	EQUIVALENT MATERIAL Где 64430, 15 758-77 'WP' CONDITION ADDED FOR PIPES AT Ref. 1
30 MAR 98	(A)	
00075-1CV	(A)	DIMENSIONS 390, 200, 1190, 1660, 200 WERE 200, 100, 1600, 1000 AND 300 RESPECTIVELY IN COLUMN 'L' FOR LENGTH IN THE TABLE
DC(1) NO & DATE	ISSUE	NATURE
AMENDMENT		

APPROVED		675-84-Sb109Sb			
CHECKED		PIPE		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				SEE TABLE	1:1
			SHT 1 SHTS 1		

THE ABBRIVATIONS AND SYMBOLS ARE
BASED ON RUSSIAN SPECIFICATIONS.

ALL DIMENSIONS ARE IN mm.

Ref. No.	Designation	Description	Qty	Remarks												
	675-84-c6111CE	<u>Documents</u> Assembly drawing														
		<u>Parts</u>														
2	765-78-1257	Jet	1													
3	700-57-403	Nipple	1													
4	700-57-404	Nipple	1													
5	700-30-241	Union nut	2													
⑧ 1	675-84-14 w/D	Pipe														
	①	Pipe 8x1-20A TY 14-3-480-76	1	0.217 kg												
	EQUIVALENT MATERIAL-- 'CDS 2, 3 OR 4 TO IS 3074-79	L = 1150 mm ①														
		<table><tr><td>00806-ICV NY 14.9.2000</td><td>⑧</td><td>EQUIVALENT MATERIAL ADDED IN REF No 1</td></tr><tr><td>00076-ICV -89</td><td>①</td><td>DIMENSION 1150 WAS 1250. W/D ADDED AGAINST REF. No 1</td></tr><tr><td>DC(I) No & DATE</td><td>ISSUE</td><td>NATURE</td></tr><tr><td colspan="3">AMENDMENT</td></tr></table>	00806-ICV NY 14.9.2000	⑧	EQUIVALENT MATERIAL ADDED IN REF No 1	00076-ICV -89	①	DIMENSION 1150 WAS 1250. W/D ADDED AGAINST REF. No 1	DC(I) No & DATE	ISSUE	NATURE	AMENDMENT				
00806-ICV NY 14.9.2000	⑧	EQUIVALENT MATERIAL ADDED IN REF No 1														
00076-ICV -89	①	DIMENSION 1150 WAS 1250. W/D ADDED AGAINST REF. No 1														
DC(I) No & DATE	ISSUE	NATURE														
AMENDMENT																
APPROVED		675-84-Sb111														
CHECKED																
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		PIPE	WEIGHT	SCALE												
			SHT	SHTS												



$A=5$ meHee * (1) A = 5, minimum

TECHNICAL CONDITIONS

1. Part Ref. No. 1
 - (a) bend pipe and redetermine length against standard, made to location;
 - (b) burrs on pipe ends are not tolerable;
 - (c) ovality at bending points - 0.5 mm, maximum. Corrugations are not tolerable.

9. Screw jet Ref. No. 2 into nipple Ref. No. 4 ensuring size A. Close pipe ends to protect inner surfaces from contamination during transportation and at storage.

10. *Sizes are given for reference.

EQUIVALENT MATERIAL:- BA CU Zn4 IS:2927-75

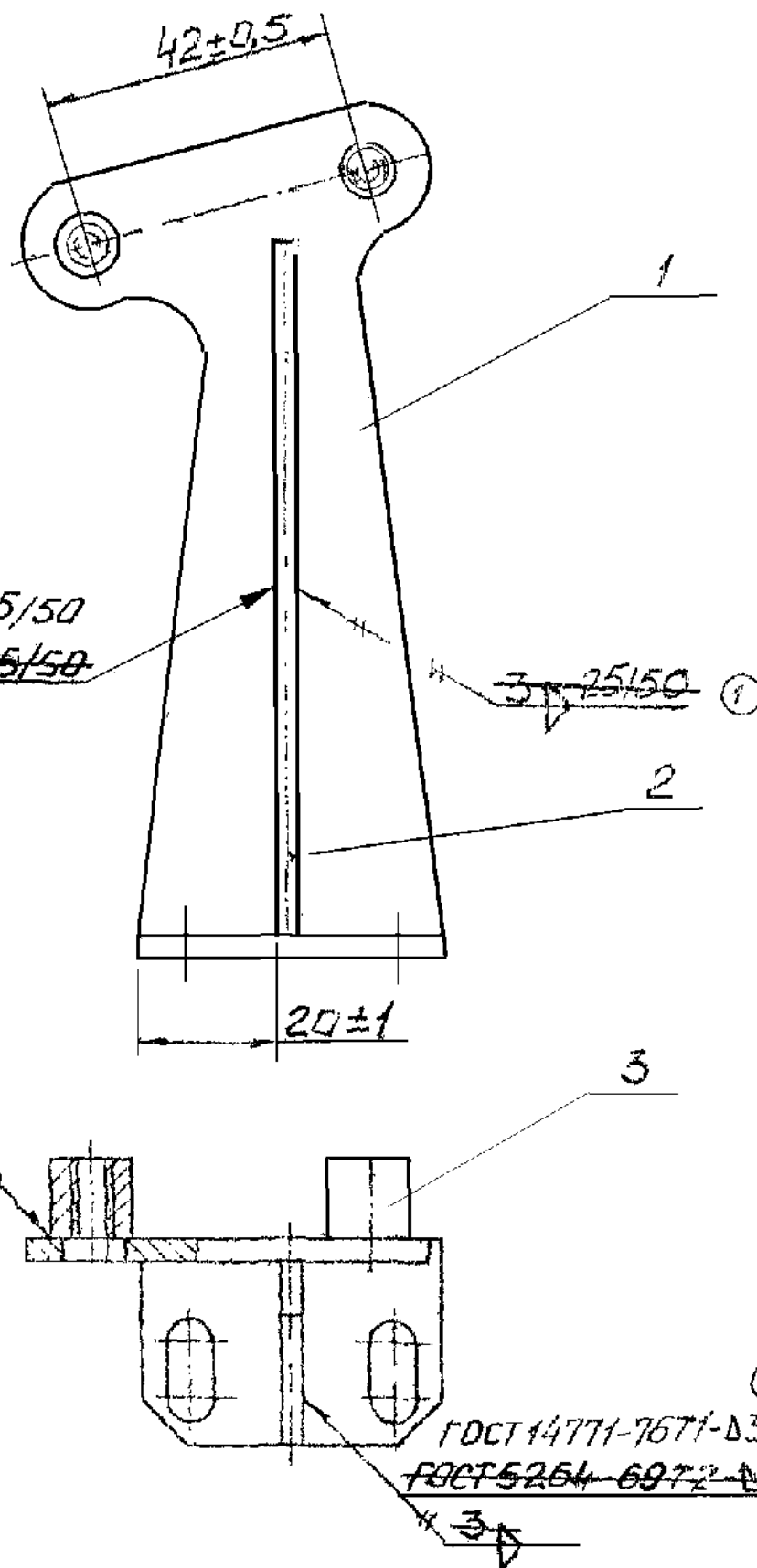
- (B) 2. Solder П-63 ГОСТ 15527-70. Lack of solder penetration in seam in lower part of joint - 50 %, maximum, of overlap. Group porosity and lack of solder penetration are not tolerable. Check quality of soldering, porosity and lack of solder penetration by random destruction of 1 % of pipes of entire lot but not less than one pipe per lot. Lot is number of parts received simultaneously.
3. Other requirements to soldering - according to OCT 3-3619-77.
4. Test for leakage in water bath at air pressure of $(15^{+0.5})$ kgf/cm² for 0.5 min, minimum. Air bubbles are not tolerable.
5. Coat inner surfaces with varnish П-95 ГОСТ 8018-70 according to Instructions ПЛ-09-73. Coat of varnish П-95 on threaded surfaces of union nuts, left after blowing of pipeline with compressed air, is tolerable.
6. Calibrate thread after soldering nipples and coating with varnish П-95.
7. Coat outer surfaces with primer ПЛ-03К ГОСТ 9109-81 and paint with enamel П-223, yellow, ГОСТ 14923-78. Paint-and-varnish coatings on threaded and taper surfaces are not tolerable.
8. Subject 5 % of pipes (not less than 2 pcs) of each lot to check cleaning in benzine ГОСТ 3134-78 through filtering or batiste cloth which should be free of traces of dirt visible with naked eye.

00806-ICV 14.9.2000	(B)	EQ.MATERIAL ADDED. FOR SOLDER.
00076-ICV -89	(A)	DIMENSION 1150 WAS 1250.
DC(I) No. & DATE	ISSUE	NATURE
AMENDMENT		

APPROVED	675-84-Sb111Sb		
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	PIPE		WEIGHT
			0.265
			SCALE
		SHT 1	SHTS 1

Ref. No.	Designation	Description	Qty	Remarks
	675-84-c6112CB	<u>Documents</u> Assembly drawing		
		<u>Parts</u>		
1	675-84-15	Bracket	1	
2	675-84-16	Post	1	
(A) 3	4368-0612	Boss M6x12x12	2	
(A)	EQ MATERIAL - C-20 87 C-25 Mn75 TO IS: 2073-70	OCT 3-1496-72		
00823 NAT 24702000 (A) EQ MATERIAL ADDED FOR REF NO: 3 Gila DC(I) NO DATE ISSUE NATURE OF AMENDMENTS				

APPROVED		675-84-Sb112			
CHECKED		BRACKET		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)					
			SHT 1	SHTS 1	

**TECHNICAL CONDITIONS**

1. Coat with primer $\Phi\text{M}-03\text{K}$ ГОСТ 9109-81 and paint with enamel $\text{H}\Phi-223$, dark-gray, ГОСТ 14923-78.
2. Requirements to quality of welds - according to OCT 3-4001-77 for off-design welded joints.

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

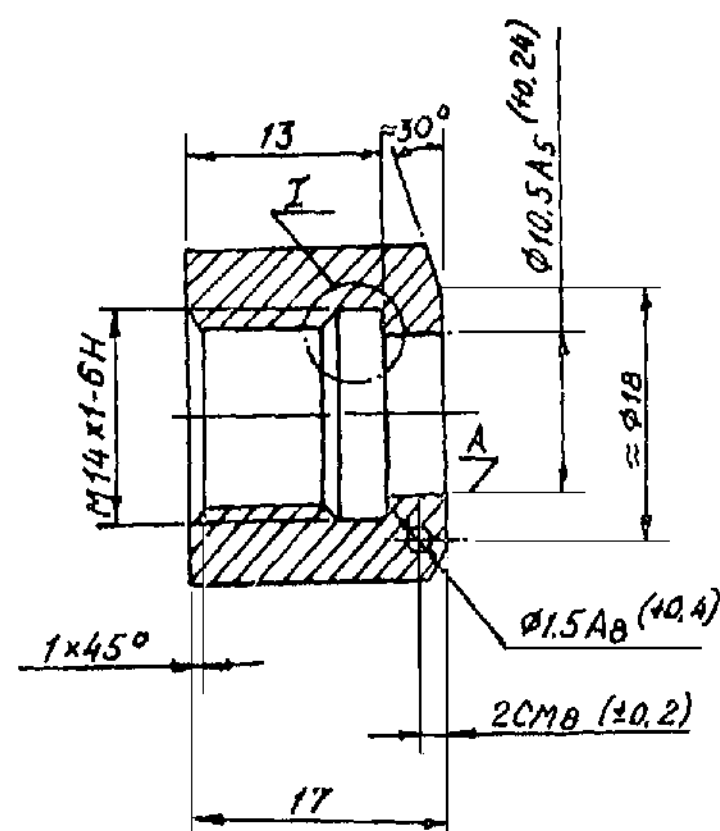
675-84-Sb112Sb

BRACKET

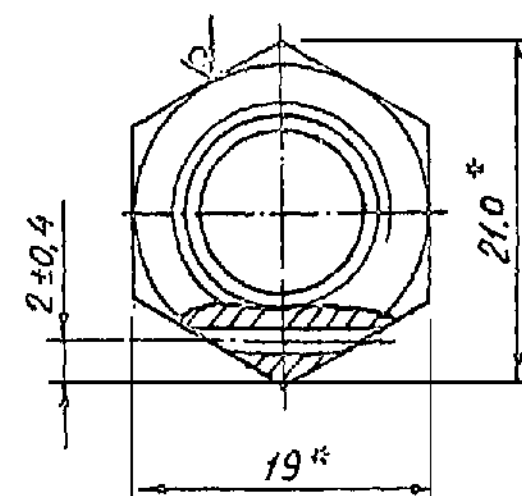
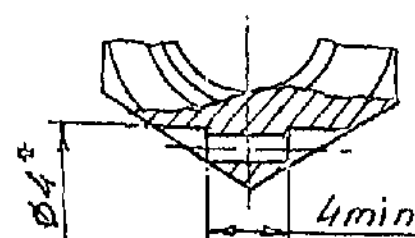
WEIGHT SCALE

0.19 1:1

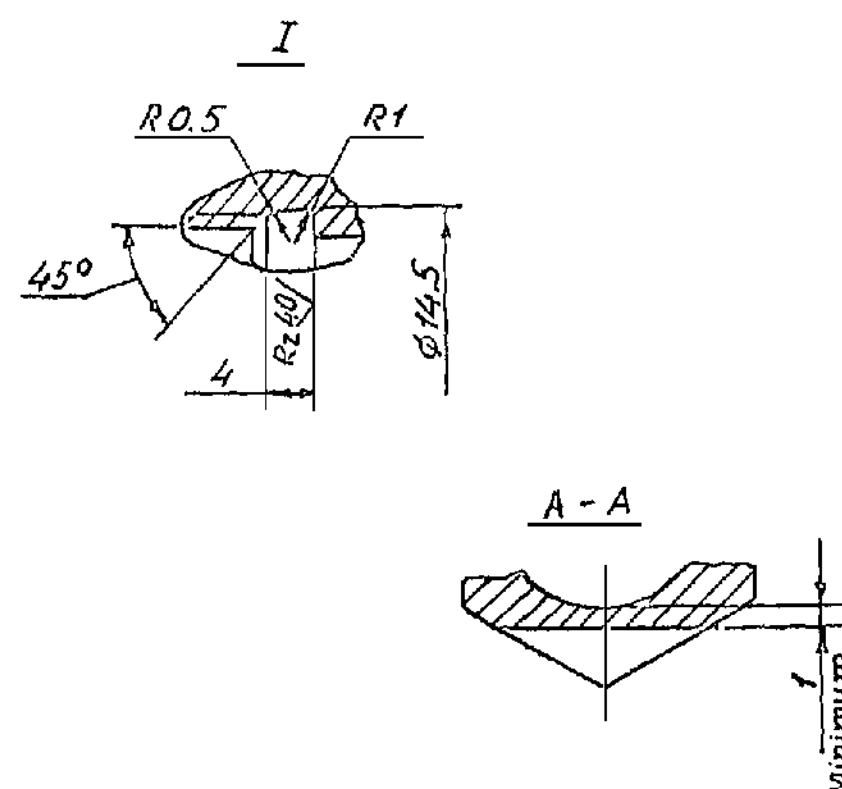
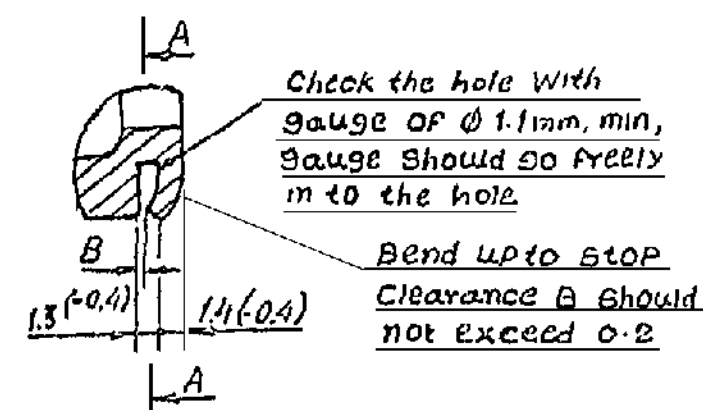
SHT 1 SHTS 1



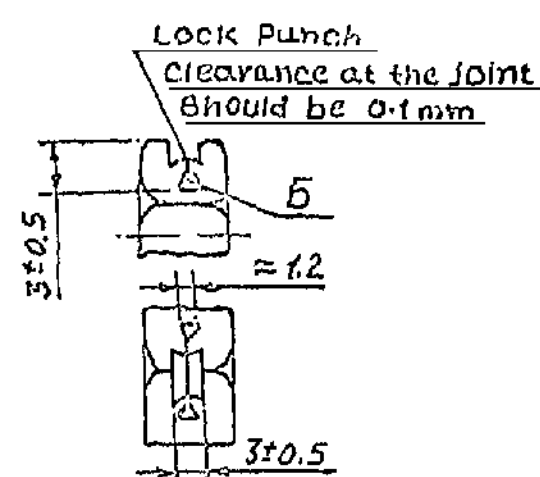
ALTERNATE-1



ALTERNATE-2



ALTERNATE-3



TECHNICAL CONDITIONS

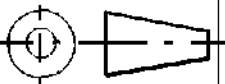
- 1 ALTERNATE MATERIAL IS STEEL 25, 30, 35 AND 40 GOST 1050 - 74
- 2 UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS :
FOR HOLES - AS PER A7, FOR SHAFT - AS PER B7 AND FOR THE REST
AS PER CM7
3. DISPLACEMENT OF SURFACE 'A' WITH RESPECT TO THREAD SHOULD
NOT EXCEED 0.2 MM.
4. * DIMENSIONS ARE GIVEN FOR REFERENCE.
- 5 COATING ZINC - PLATED, 9 MICRONS THICK CHROMATIZED, REMOVE
HYDROGEN EMBRITTLEMENT COATING ON INTERNAL SURFACE NEED
NOT BE CHECKED.
6. ROD WITH MINIMUM DIAMETER OF 1 MM SHOULD PASS THROUGH
HOLE 5

EQUIVALENT MATERIAL - IS 45 C8 Gr 2 to IS 9550 - 80

EQUIVALENT MATERIAL :- CLASS 4 TO IS . 2004 - 78

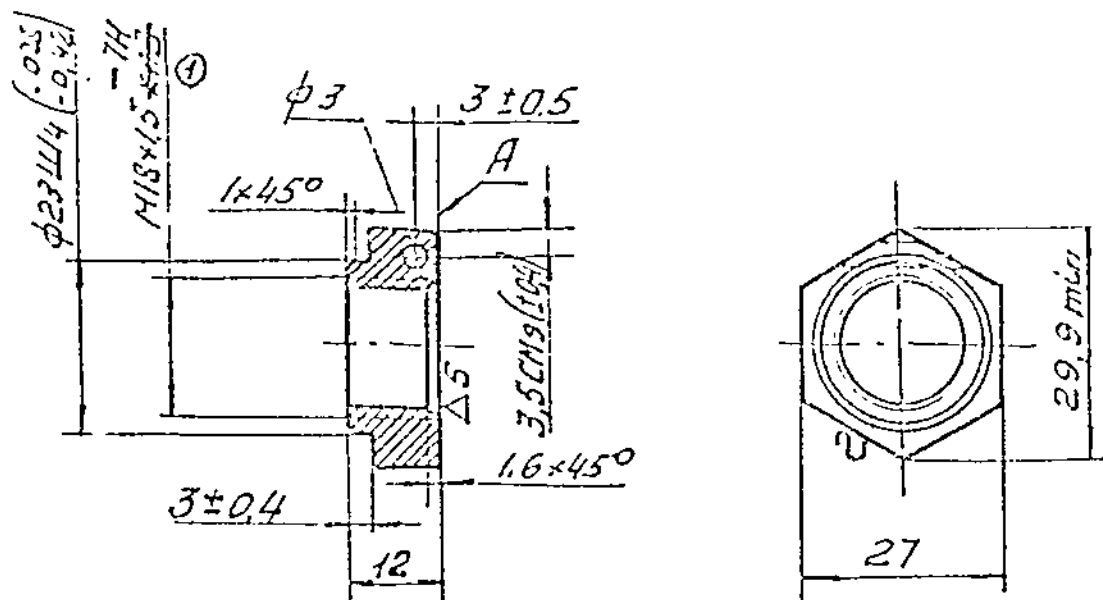
EQUIVALENT MATERIAL :- (a) STEEL BAR C 45 TO IS : 2073 - 70
OR EN 8 TO BS . 970 OR EN - 8 / EN 9.

EQUIVALENT MATERIAL :- CARBON STEEL C 50, C 40, C 30, C 25 TO
IS 1570 - 61

NEAREST EQ. MATERIAL		00951-ICV	 	DRAWING REVISED & RETRACED.
HEXAGON BAR 19.5, GOST 8560-78 45-B, GOST 1051-73		18-11-02 DC(I) No. & DATE		
ORGL MATERIAL:-		ISSUE	AMENDMENTS	
ALL SHARF EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION		STAMP OR ETCH. PART No. MANUFACTURER's NAME & YEAR OF MFR.	
DRG. NOT TO BE SCALED				
SCALE: 2:1	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON:	
DATE: 18-11-02				
DRN. MS hand	WT :- (Kg)	700-30-241		
TCD. MS hand	0.023			
CHD. [Handwritten]		UNION NUT		
APPD. [Handwritten]				
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				

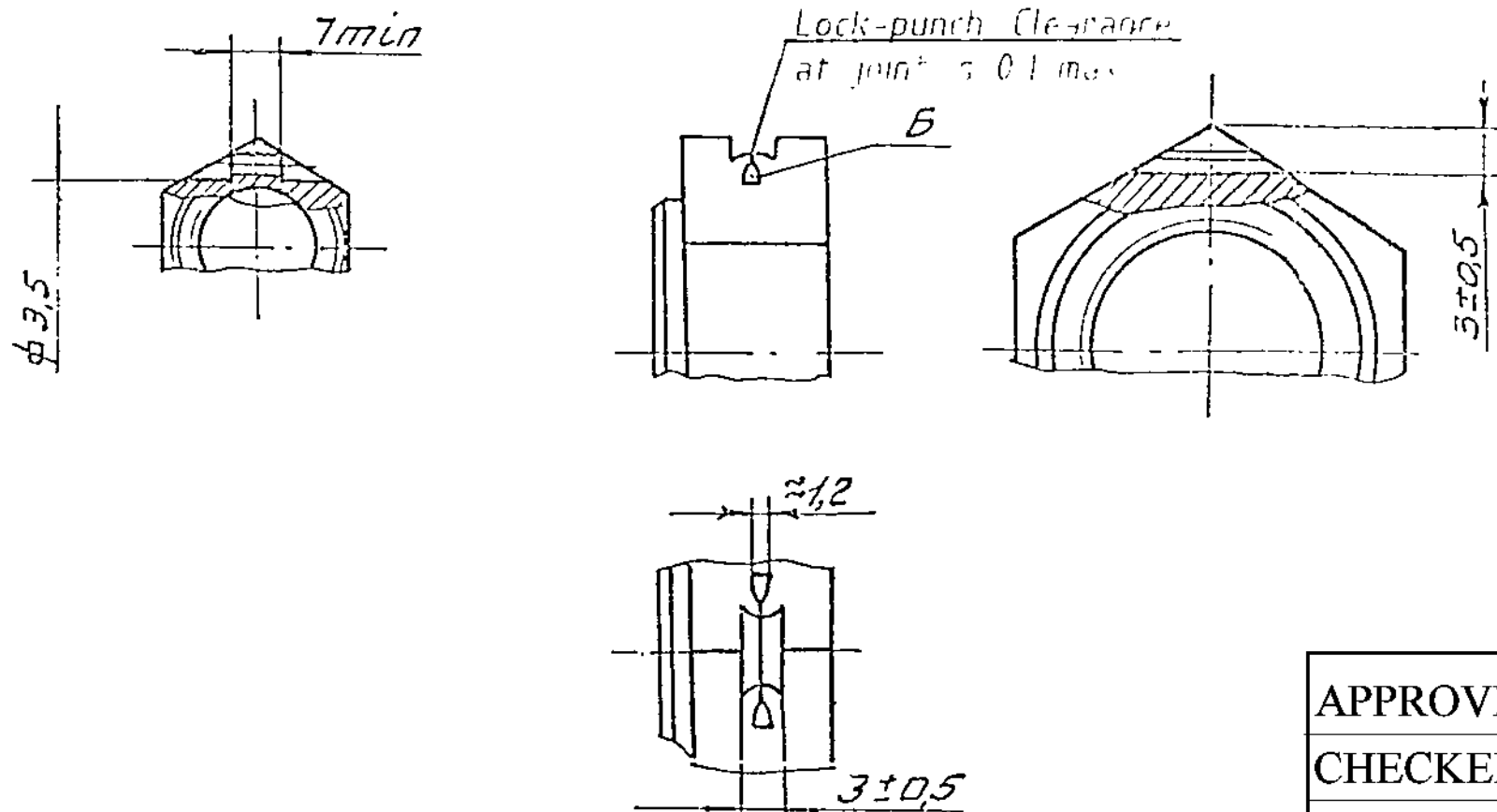
700-30-406

▽3 (▽)



1. Alternate material is Steel cm6 GOST 380-71 and 35, 40, 50, GOST 1050-74
2. Unspecified limit deviations of dimensions are for holes -as per A₇ and for shafts -as per B₇
3. End-play of surface A with respect to angle diameter of thread should not exceed 0.15 mm (Qualified tolerance).
4. Pin of atleast 1 mm in diameter should pass through hole 5.
- ⑤. EQ. MATERIAL:- STEEL 45 CB Gr 4 TO IS: 9550-80
 ⑥ EQ. MATERIAL :- STEEL BAR. C50 TO IS: 1570-61.
 .. STEEL BAR C45 TO IS: 2073-70
 ⑦ ALT. MATERIAL:- C 55 Mn 75 TO IS: 2073-70

Alternate 1

Alternate 2
M2 1

01023-ICV 26-06-06	③	DS CAT PART NO ADDED AND DESCRIPTION 'NUT SLOTTED HEXAGONAL' WAS 'NUT'
00818-ICV 11-10-2000	⑥	EQ. MATERIAL ADDED.
00625-ICV 20-05-1998	①	STEEL 45 CB Gr 4 TO IS: 9550-80 ADDED AS EQ. MATERIAL.
DC(I) No. & DATE	ISSUE	AMENDMENTS

APPROVED

CHECKED

 CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

700-30-406

 NUT SLOTTED
HEXAGON ③

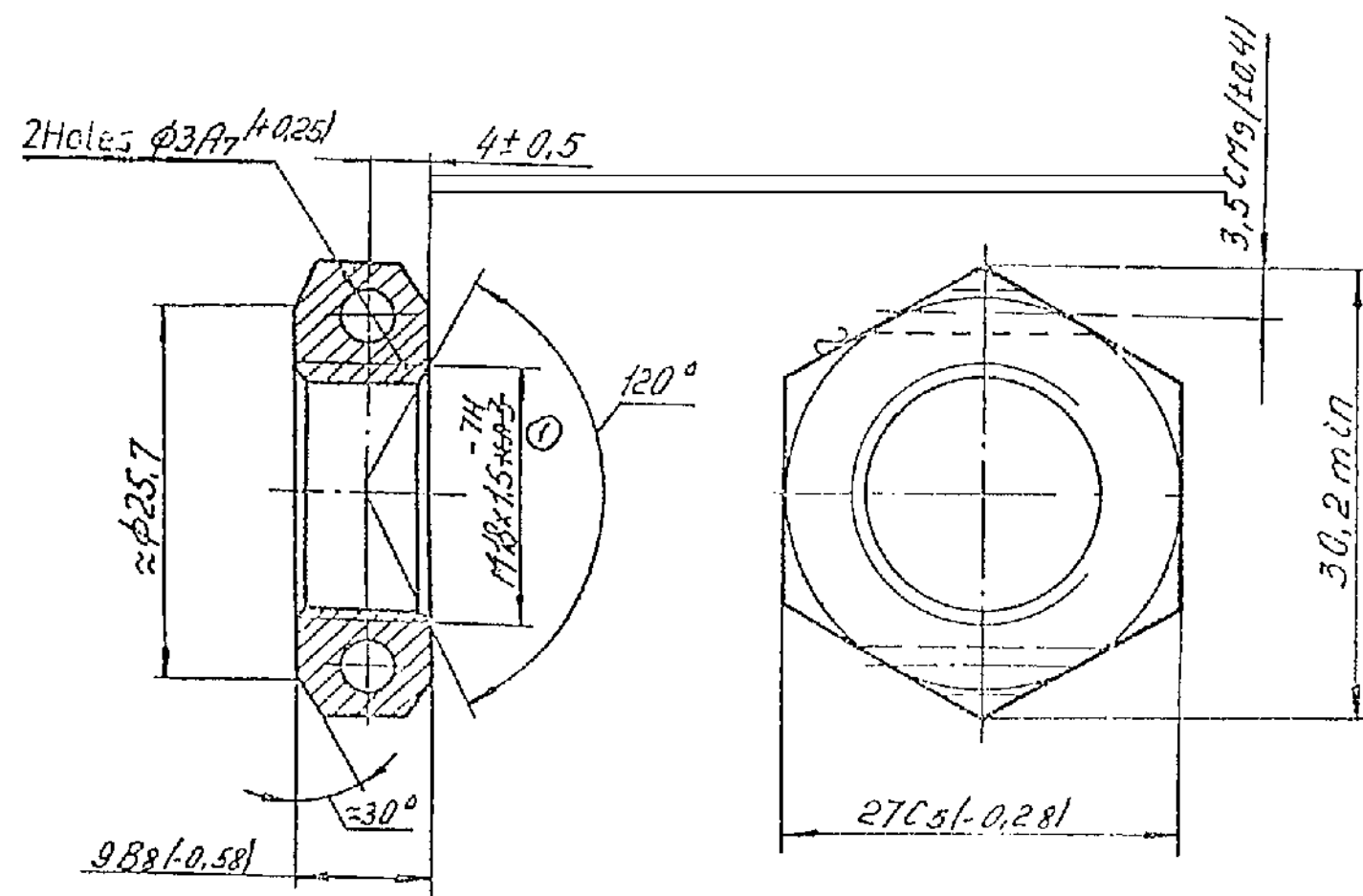
45 GOST 1050-74

WEIGHT SCALE

0.023 1:1

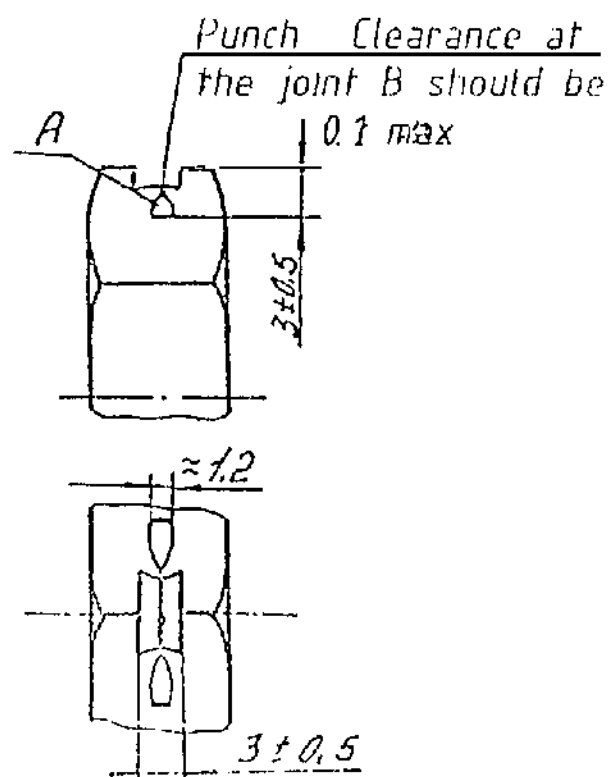
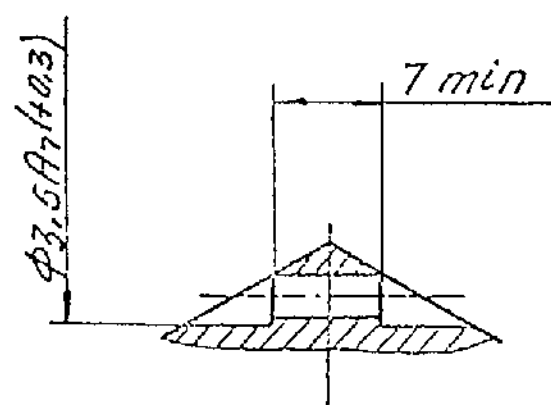
SHT 1 SHTS 1

 DS CAT PT No ③
LV2/ICVS 5310-181 922



Alternate 1

Alternate 2



1. Displacement of axis of threaded holes should not exceed 0.1 mm.
2. Use may be made of blank for nut M18x1.5.6 GOST 5929-70
- ~~2. Blank may be used for nut M18x1.5.6 GOST 5929-70~~
3. Type of coating: Zinc-plated, 9 microns thick, chromatisation. Remove hydrogen embrittlement. Coating inside the hole need not be checked.
4. Pin with $\phi 1$ mm max should pass through hole A

Ⓐ EQUIVALENT MATERIAL: STEEL 45 CB Gr4, IS: 9550-80.

Ⓑ EQUIVALENT MATERIAL: STEEL BAR C50 TO IS: 1570-61

Ⓒ STEEL BAR C45 TO IS: 2013-78

00818-ICV 1.10.2008	Ⓑ	EQ. MATERIAL ADDED.
00625-ICV 2.10.2008	Ⓐ	STEEL 45 CB Gr4, IS: 9550-80 ADDED AS EQUIVALENT MATERIAL
30 MAR 2009	DATE	NATURE AMENDMENTS

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

700-30-410

NUT

45 GOST 1050-74

WEIGHT SCALE

0.024 2:1

SHT SHTS

Fig - 1

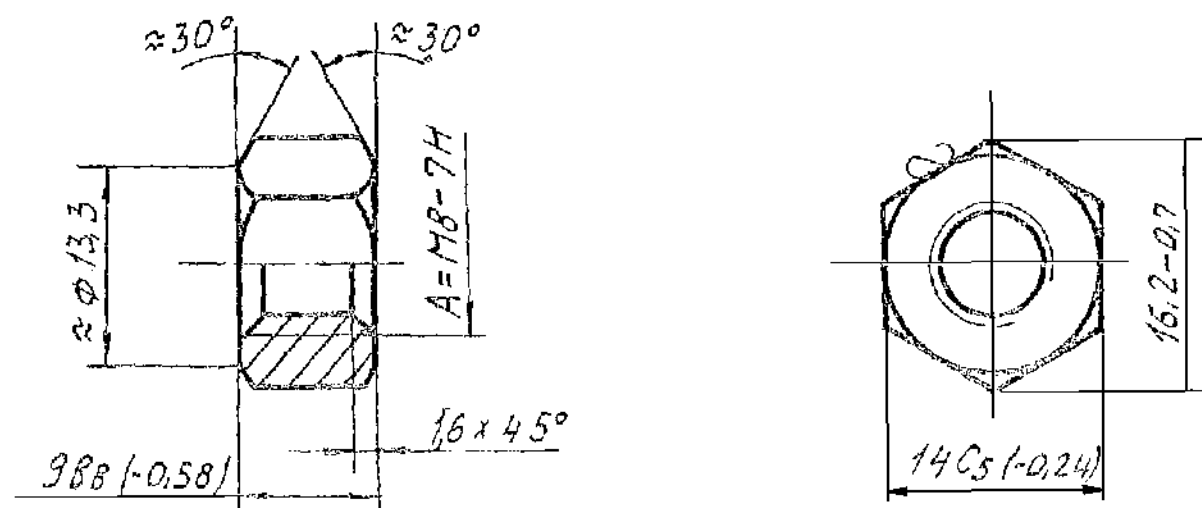
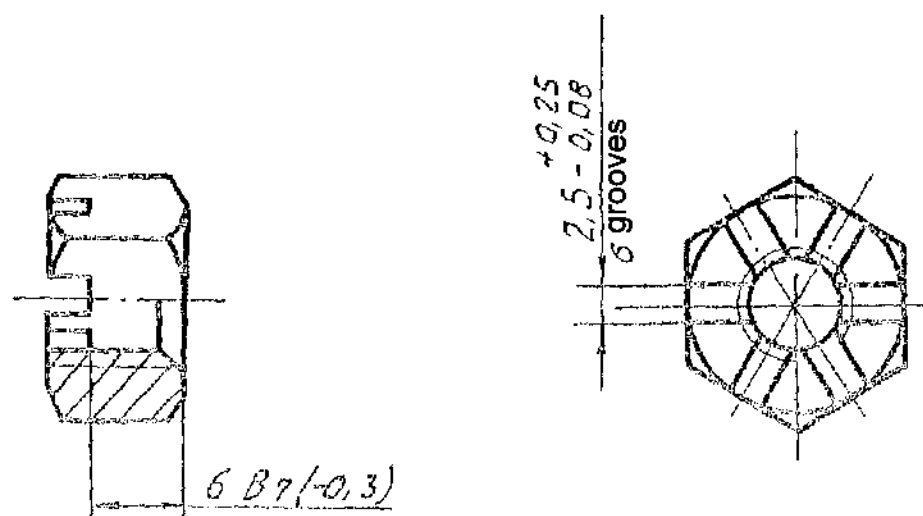


Fig - 2

Unless otherwise specified (see Fig.1)



Designation	Fig.
700-30-492	1
-01	2

© 5. UTS 72.5 kg/mm² (min), ELONGATION 20 % (min).

1. Alternate material is steel 12x18H 10T and 20x23H18 GOST 5632-72.
2. Displacement of axis of hole should not exceed 0.3mm.
3. Displacement of axis of groove with respect to axis of hole should not exceed 0.25mm (qualified tolerance).

© 4. Coating of thread A:- ~~M9~~; coating may be applied all over, separate blisters of negligible size are allowed.

© 6. COPPER COATING ON THREADS 3 TO 5 MICRONS THICK.

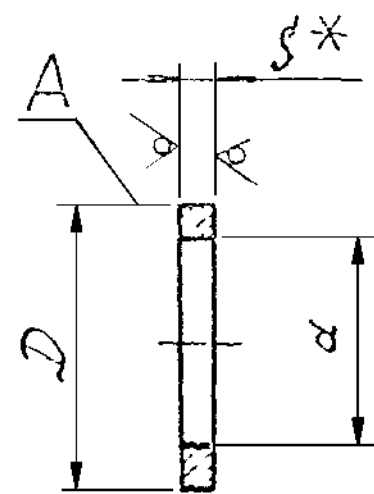
Ⓐ 5. EQUIVALENT MATERIAL: IS 04 Cr18 Ni10 Ti20 TO IS:66 03-72.

Ⓒ ALTERNATE MATERIAL :- 304 S15 TO BS: 970-83.

Ⓓ EQUIVALENT MATERIAL:- STAINLESS STEEL BAR 04Cr18Ni10Ti20 TO IS:1570(PART-V)-72.

00818-ICV 11-10-2000 M.V. Vasu	Ⓒ Am	EQ. MATERIAL ADDED
00606-ICV 02-05-97 S. Kumar	Ⓒ Cw	NOTE FOR UTS AND ALTERNATE MATERIAL ADDED. NOTE FOR COATING AMENDED. (1/97 N OF A)
00477-ICV 19-10-94 B. S. S.	Ⓑ B	SPECN. FOR EQ. MATERIAL WAS IS: 6911
00326-ICV 14-05-1992 S. Kumar	Ⓐ M. S. S.	NOTE FOR EQUIVALENT MATERIAL ADDED
DC(I) No. & DATE	ISSUE	AMENDMENTS

APPROVED	M. VASU	700-30-492		
CHECKED	S. Kumar			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		NUT		
		12X1BH 9T, GOST 5632-72		
		WEIGHT	SCALE	
		0.009	2:1	
		SHT 1	SHTS 1	



- ② 1. EQ.MATERIAL:- AL. ALLOY SHEET (CLADDED) TO GRADE 55000 TO IS: 737-74 FOR 700-31-602
2. Alternate material is sheet A16AT GOST 21631-76.
3. Displacement of axis of hole with respect to axis of surface A should not exceed 0,3mm.
4. * Reference dimension.
5. Coating: anodically oxidized chromatized,
- EQ.MATERIAL: Gde 54300 'O' TO IS: 5737 FOR DRG. NO. 700-31-602 (A)

Designation	d, MM	D, MM	S*, MM	Material	Mass,kg.
700-31-603	14 ^{+0,5}	20 _{-0,5}	2	Sheet A76AT-2 GOST 21631-76	0.0007
700-31-602	6 ^{+0,3}	9.5 _{-0,5}	1.5	Sheet AMI 66M-1.5 GOST 21631-76	0.0002

00818-1CV N.H. 11.10.2000	② Am	EQ.MATERIAL ADDED FOR DRG.NO. 700-31-602.
DC(I). 00640-1CV V. Romanov 19.6.98	Am ①	EQ. MATERIAL ADDED, FOR DRG. NO 700-31-602
DC(I) No. 8 DATE	ISSUE	NATURE

APPROVED

CHECKED *Shuhmar*

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

700-31-602/603

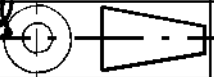
WASHER

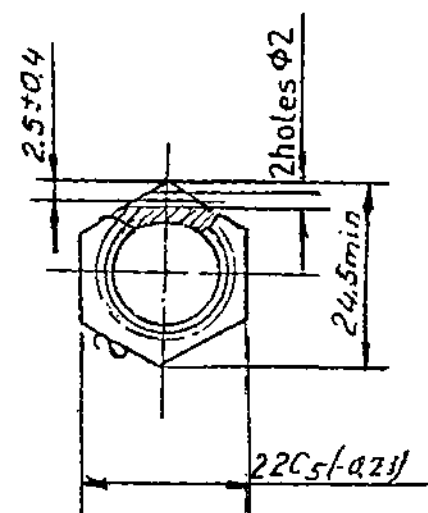
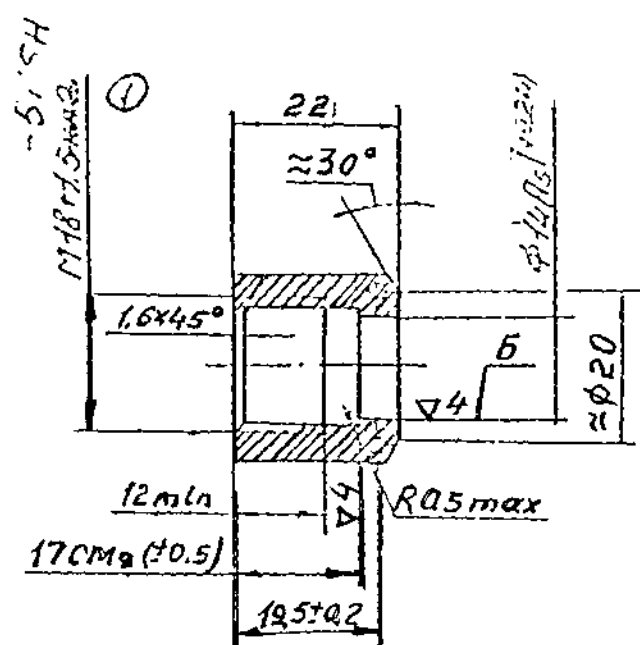
SEE TABLE

WEIGHT	SCALE
SEE TABLE	
SHT 1	SHTS 1

[illegible]

1. Alternate material is Steel cm3cn GOST 380-71 and Steel 08kn and 10 GOST 1050-74.
2. Unspecified limit deviations of dimensions are ± 0.5 mm.
3. Unspecified radii are $R=1.5$.
4. * Dimension is given for reference.
5. Coating: M9.
6. (A) EQ MATERIAL: St-34 TO IS: 1079-73
(B) EQ MATERIAL: COLD ROLLED CARBON STEEL GRADE TO IS: 4030-74.

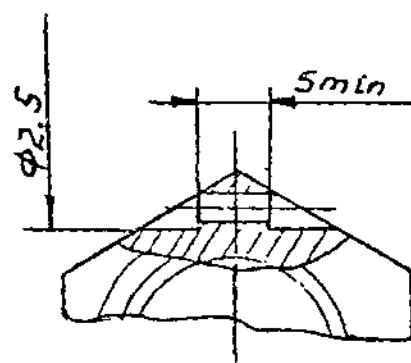
		00808-ICV 11-10-2000		EQ. MATERIAL ADDED.
NEAREST EQ. MATERIAL		00635-ICV 01-6-98	①	St-34 TO IS:1079-73 ADDED AS EQ. MATERIAL .
SHEET 1.0, GOST 19903-74 3III-Cm3kn, GOST 16523-70		DC(1)No. & DATE	ISSUE	
ORGL MATERIAL:-				
ALL SHARP EDGES & CORNERS TO BE ROUNDED OF		ALL THREADS TO CONFORM TO SPECIFICATION		STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON:
SCALE: 2:1		700-31-771		
DATE:- 7-7-95				
DRN.	WEIGHT: (Kg.)	WASHER		
TCD.	0.03			
CHD.				
APD.				
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				



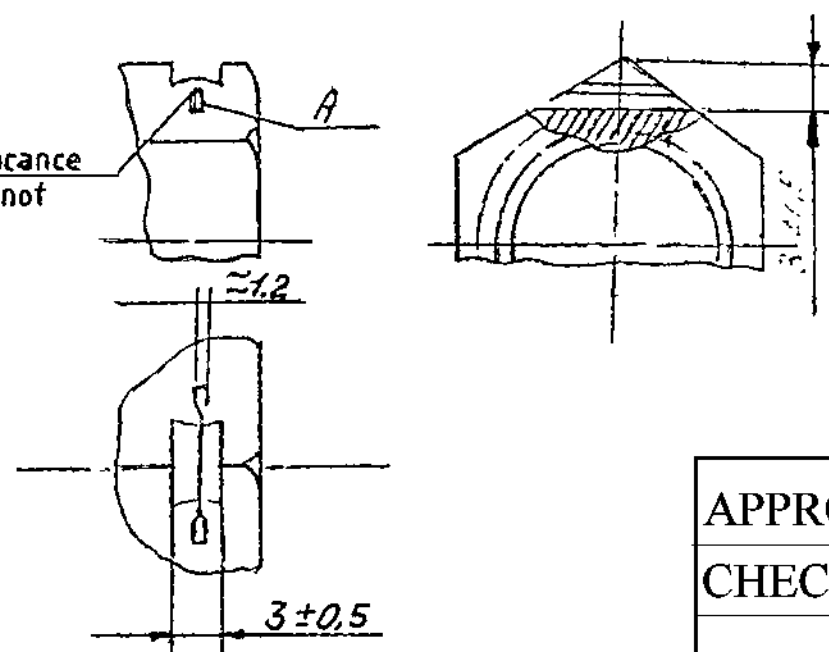
- Ⓐ EQUIVALENT MATERIAL: STEEL 45 C8 Gr4, IS: 9550-80
Ⓑ EQUIVALENT MATERIAL : STEEL BAR C45 TO IS: 2073-70
EN-9 TO BS: 970

1 Alternate
M2:1

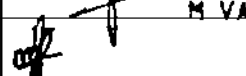
2 Alternate
m2:1

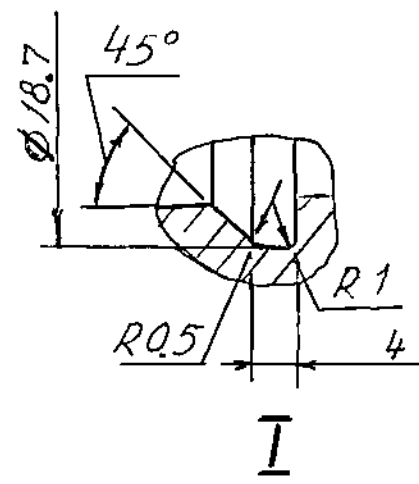


Lock-punch clearance
at joint should not
exceed 0.1mm

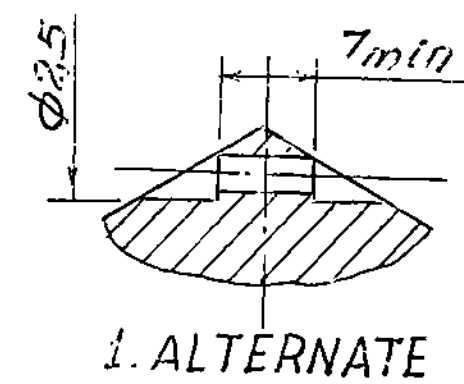
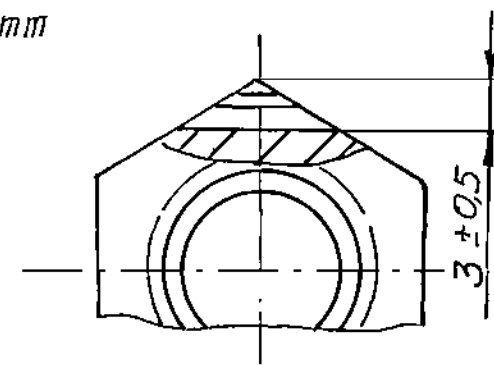


01023-1CV <i>[Signature]</i> 26-6-06- ③	DS CAT NO. ADDED AND NOMENCLATURE WAS 'UNION NUT'
00518-1CV <i>N.Y. [Signature]</i> 11-10-2000 ③	EQ. MATERIAL ADDED.
00625-1CV <i>[Signature]</i> 30 MAR 98 ③	STEEL 45C8 Gr4; 15:9550-80 ADDED AS EQUIVALENT MATERIAL (1/98 N of A)
DC(I) No 8	NATURE
DATE	AMENDMENTS

APPROVED	 M. VASU	700-33-4	DS CAT PART No. ③ LV2/ICVs 5310-181923		
CHECKED				UNION NUT ③ NUT SLOTTED HEXAGONAL	
CONTROLLERATE OF QUALITY ASSURANCE (ICV)					0.036
		SHT 1 SHTS 1			
		STEEL 45, GOST 1050-74			



A hand-drawn diagram of a shoulder joint. A line labeled 'A' points to the humeral head. Another line labeled 'SHOUL' points to the glenoid cavity of the scapula. The diagram shows the articulation between the two bones.



2. ALTERNATE

ALL DIMENSIONS ARE IN mm.

(A)

1 ~~UNION NUT SHALL BE MANUFACTURED FROM COLD DRAWN STEEL BRIGHT BAR TO EN 80 TO BS 970 OR STEEL HAVING CHEMICAL COMPOSITION OF C 45 TO IS 2073-70 AND MECHANICAL PROPERTIES ST 50 TO IS 7270-74 (COLD DRAWN).~~

2 TOLERANCES ON UNSPECIFIED DIMENSIONS SHALL BE AS PER IS:919-63 AS GIVEN BELOW :-

FOR HOLE ----- H14
" SHAFT ----- h14
" LINEAR DIMENSIONS----- js14

3 RADIAL RAN-OUT OF SURFACE „b" WITH RESPECT TO THE PITCH CIRCLE DIAMETER OF THE THREAD SHALL NOT EXCEED 0.1mm

4 THREAD M18x1.5-5H6H SHALL CONFORM TO IS:4218-78.

5 UNION NUT SHALL BE ZINC PLATED TO 9 MICRON THICKNESS CHROMATIZED, HYDROGEN EMBRITTLEMENT SHALL BE REMOVED BY HEATING THE PART TO 150-200°C FOR ATLEAST ONE HOUR.

6 DIMENSIONS SHALL BE CHECKED BEFORE ZINC PLATING. INTERNAL SURFACES NEED NOT BE PLATED.

7 A ROD NOT LESS THAN 1mm IN DIAMETER SHALL PASS THROUGH HOLE.

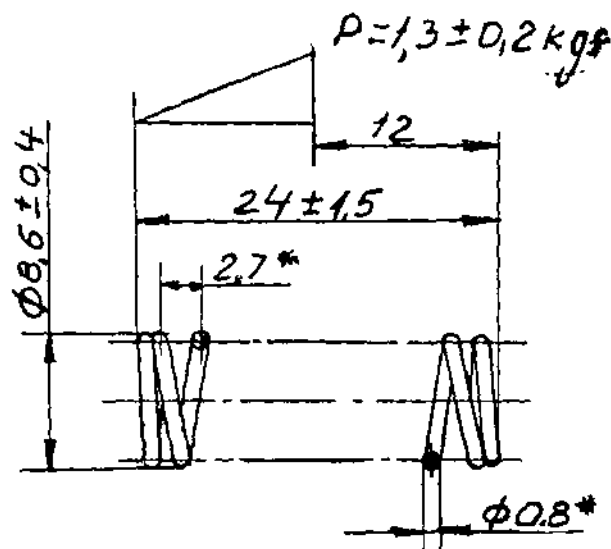
8 MARK PART NO. & MANUFACTURERS CODE OR SYMBOL ON THE LABEL

(B) EQ. MATERIAL:- STEEL BAR Gr 4 TO IS: 9550-80

(C) EQ. MATERIAL:- (i) STEEL BAR C 45 TO IS: 2073-70
(ii) EN-9 TO BS 970

HEX. BAR TYPE 'O' Gde-4, 45C8 TO IS: 9550-80. NEAREST EQ. MATERIAL 45 GOST 1050-74		00818 -1CV No. 12 11-12-2007 06717-1CV 12-8-99 00611- -1CV 26-6-97	© (B) (A)	EQUIVALENT MATERIAL ADDED EQ. MATERIAL ADDED EQ. MATERIAL ADDED. NOTE NO.1 DELETED. (3/97 N OF A)
ORGL MATERIAL:-		DC(I) No. & DATE	ISSUE	AMENDMENTS
ALL SHARP EDGES & COR- NERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART No. MANUFACTURER'S NAME & YEAR OF MFR.		
DRG. NOT TO BE SCALED				
SCALE: 2:1	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON: 765-05-Sb339, 765-05-Sb390, 765-78-Sb507		
DATE: 13-1-92				
DRN.	WT :- (Kg)	700-33-90		
TCD	0.034			
CHD		DS CAT No.		
APPD		UNION NUT		
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				

700-38-7



1. Shear modulus is $G^* = 8000 \text{ kgf/mm}^2$
2. Tangential twisting stress is $\tau^* = 58 \text{ kgf/mm}^2$,
3. Total length of spring is $L^* = 240 \text{ mm}$.
4. Number of working coils $n = 8$.
5. Total number of coils $n_1 = 10 \pm 0,5$.
6. Direction of winding-left-hand.
7. *Reference dimensions.
8. Coating: Chemically parkerized, acclerated, chromatized, oiled with varnish KO-815 GOST 11066-74.
- 8K. Coating: Chemically parkerized, acclerated, chromatized, impregnated with preservation oil K-17 GOST 10877-76 as per Instructions 053. 252 89.00002 or with varnish KO-815 GOST 11066-74.

- Ⓐ EQ. MATERIAL: WIRE Gde 3 TO IS:4454 (PT-1)
 Ⓑ EQ. MATERIAL: STEEL WIRE GRADE 3 TO IS:4454(PART1)-75

00818-ICV N.Y. L. L. L. 11 OCT 00	Ⓑ _{Curin}	EQ. MATERIAL ADDED.
00640-ICV V. Romanov 19 JUN 98	Ⓐ _{Curin}	EQ. MATERIAL ADDED.
DC(I) No. & DATE	ISSUE	AMENDMENTS

APPROVED
 CHECKED
 CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

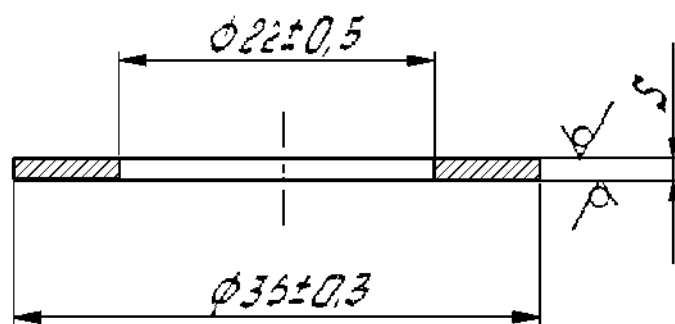
700-38-7

SPRING

WIRE II 0.8 GOST 9389-75

WEIGHT
 SCALE
 0.001 2:1
 SHT SHTS

700-40-60/62



Designation	S,MM	Mass,kg
700-40-60	1-0 09	0,0046
700-40-61	0,5-0 05	0,0023
700-40-62	0,2-0 03	0,0009

1) Alternate material is steel cm3, cm5, GOST 380-71 and steel 15, 20, 25, GOST 1050-74

2) Coating Zinc-plated, 9 microns thick, chromitized
Remove hydrozen embrittlements.

EQ MATERIAL:- Stb 34 TO IS: 1079-73

EQ MATERIAL -STEEL SHEET GRADE 'D' TO IS 4030-73

(A)

DSCAT(PART)NO FOR 700-40-61 : LV2/RCV-5330-014465

00018-ICV N.Y. 11.10.2000	(C)	EQ MATERIAL ADDED FOR 700-40-61
0053-ICV V.R. 01.6.98	(B)	Stb 34 TO IS: 1079-73 ADDED AS EQ.MATERIAL
00548-ICV 29.2.96	(A)	DSCAT(PART)NO FOR DRG NO 700-40-61 ADDED
DCU NO DT	ISSUE	NATURE
AMENDMENT		

APPROVED

CHECKED

700-40-60/62

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

GASKET

STEEL 10, GOST 1050-74

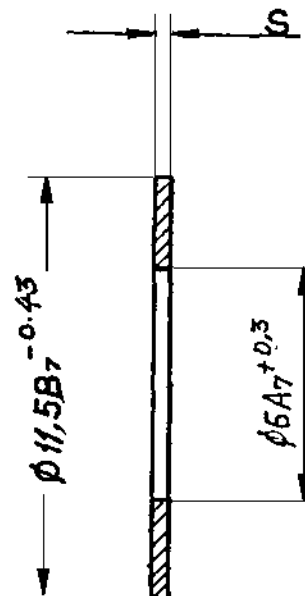
WEIGHT

SCALE

SEE
TABLE

SHT 1 SHTS 1

700-40-137/138



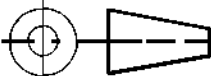
DESIGNATION	S		MATERIAL	WEIGHT
	NOMINAL	DEVIATIONS		
700-40-137	0.2	-0.03	10 GOST 1050-74	0.00016
700-40-138	0.5	±0.07	08K17 GOST-1050-74	0.0004

1. ALTERNATE MATERIAL IS 08nc AND 10Kn GOST-1050-74.
2. COATING CHEMICALLY, PARKERIZED, CHROMATIZED
ACCELERATED OILED.

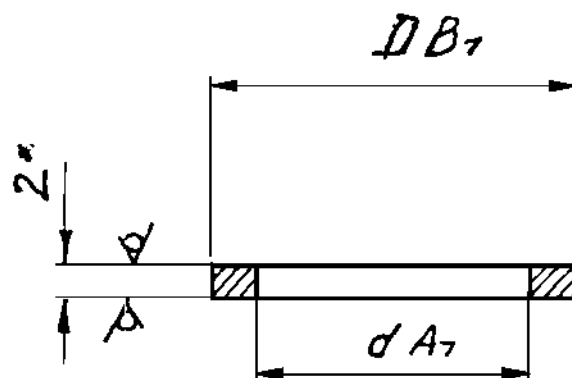
EQ.MATL: FOR 700-40-137: 10C4 IS:1570-61, EN2A, 2B:970

FOR: 700-40-138: C07 IS:1570-61.

Ⓐ EQ. MATERIAL - GRADE - 'O' TO IS:513

NEAREST EQ. MATERIAL		00753-ICV v. Revise 23 FEB 00	Ⓐ Givn	DRAWING REVISED AND RETRACED. EQ. MATERIAL ADDED.
MATERIAL:-		DC(I)No. & DATE	ISSUE	AMENDMENTS
ALL SHARF EDGES & COR- NERS TO BE ROUNDED OFF		ALL THREADS TO CONFORM TO SPECIFICATION		STAMP OR ETCH, PART No. MANUFACTURER's NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED				
SCALE: 5:1		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON: 765-18-Sb146, 675-51-Sb140
DATE : 23 FEB 2000				
DRN.	BBB	WT :- (Kg)	700-40-137/138	
TCD.		SEE TABLE		
CHD	Givn		GASKET	
APPD	V. Ramakrishna			
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				

ALL DIMENSIONS ARE IN mm.



- 1) Notches and nicks are not allowed, on faces
- 2) * Dimensions are given for reference
- 3) Equivalent material: Aluminium alloy sheet
 - (A) Grade 19500 condition O to IS 737-74.
 - (E) EQ. MATERIAL: GRADE-19800 TO IS: 737-74.

00898-ICV 21 AUG 01 w.r. 24.1 Gur	©	EQ. MATERIAL ADDED. FOR 700-40-196
00800-ICV 01 AUG 00 v. Ramo Gur	®	DS CAT NUMBER ADDED.
00455-ICV 24 AUG 94 Bm Jr	®	NOTE No.3 FOR EQUIVALENT MATERIAL ADDED.
DC(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED

M. VASU

CHECKED

A. RAO
DSKUMAR

700-40-196/203

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

GASKET

STEEL A4 1M
GOST 21631-76

WEIGHT

SCALE

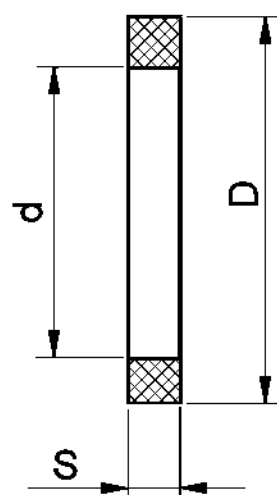
SEE
TABLE

1:1

SHT

SHTS

09Z-07-00Z



- 1) OTHER TECHNICAL REQUIREMENTS ARE AS PER
TECHNICAL SPECIFICATION TY 81-04-395-75.
- 2) PART SHOULD CORRESPOND TO APPROVED STANDARD.
DIMENSIONS MM.

DESIGNATION	d		D		S		MASS kg	D S CAT PART No.	
	NOMINAL	DEVIATION	NOMINAL	DEVIATION	NOMINAL	DEVIATION			
700-40-260	3	+0.5	15	0.6	1.5	±0.15	0.0003		
-01	5		10	0.5			0.0002		
-02	5		12	-0.6			0.0002		
-03	5		15				0.0002		
-04	6		12				0.0002		
-05	8		14				0.0002	LV2/RCV-5330-014023	
-06	10		16				0.0002	" -5330-014024	
-07	12	18	0.0002				" -5330-014025		
-08	13	22	+0.6				0.0004	" -5330-014026	
Ⓑ -09	14	24		0.0005			" -5330-014027		
Ⓑ -10	16	22		0.0003			" -5330-014028		
-11	16	27		0.0007			" -5330-014029		
Ⓑ -12	18	26		0.0005			" -5330-014030		
Ⓑ -13	20	25		2.0	±0.20	0.0004	" -5330-014031		
Ⓑ -14	20	30				0.0009			
-15	22	32	0.7			0.0010			
-16	24	32				0.0003			
Ⓑ -17	27	35				0.0009			
-18	30	36				0.0007			
-19	30	40				0.0013			
Ⓑ -20	33	+0.7		45		0.0017			
-21	37			46		0.0014			
-22	40		48	0.0013					

DESIGNATION	d		D		S		MASS kg	D S CAT PART No.
	NOMINAL	DEVIATION	NOMINAL	DEVIATION	NOMINAL	DEVIATION		
-23	42	+0.7	52	1.0	2.0	±0.20	0.0018	
-24	45		55				0.0018	
-25	45		66				0.0044	
-26	50		56				0.0012	
-27	50		60				0.0020	
-28	52	+1.0	62				0.0021	
-29	66		72				0.003	
-30	68		78				0.0027	
-31	76		85				0.0027	
-32	95		125				0.012	

- Ⓐ EQ. MATERIAL:- VULCANIZED FIBRE SHEET AS PER IS:4820-68
- Ⓑ FOR SHEET THICKNESS ABOVE 1.5 mm.
- Ⓒ IS:4819-68 FOR THICKNESS UP TO 1.4 mm

COMPRESSED ASBESTOS
FIBRE GDE. 0/1 TO IS:2712.

NEAREST EQ. MATERIAL
FIBRE BOARD GDE. K_r ϕ Ⓐ
GOST 14613-69.

ORGL MATERIAL:-

ALL SHARP EDGES & COR-
NERS TO BE ROUNDED OFF

DRG. NOT TO BE SCALED

SCALE: SEE TABLE

DATE: 17-4-97

DRN.

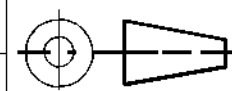
TCD.

CHD

APPD

WT :- (Kg)

SEE TABLE



ALL THREADS TO CONFORM
TO SPECIFICATION

TOLERANCE ON DIMENSIONS
UNLESS OTHERWISE
SPECIFIED

GASKET

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

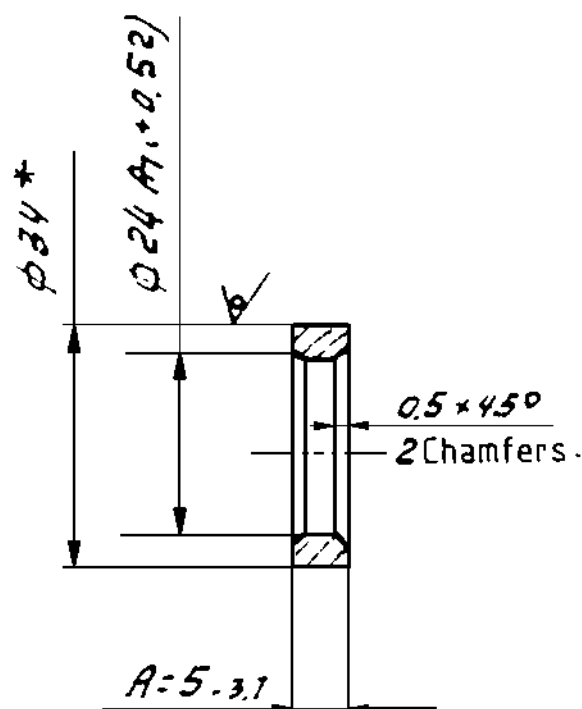
00867 17-10-2000 V-Road 4-4-2000 00605 17-4-97	Ⓒ	IS:4819-68 WAS IS:419-68
00820 -15-00 17-10-2000	Ⓑ	SHEET THICKNESS ABOVE 1.5 mm FOR IS:4820-68 & IS:419-68 FOR THICKNESS UP TO 1.4 mm
00770 -15-00 4-4-2000	Ⓐ	EQ. MATERIAL ADDED
00605 -15-00 21-4-97		DRAWING REVISED AND RETRACED. (2/97 N OF A)

DC(I)No. & DATE	ISSUE	AMENDMENTS
		STAMP OR ETCH, PART No. MANUFACTURER's NAME & YEAR OF MFR.
		USED ON:

700-40-260

DS CAT No.

700-42-153

Rz 80
✓(✓)

Ⓑ EQ.MATERIAL:- AL. ALLOY BAR GRADE 24534 TO IS: 733-83.

- 1 Carryout annealing
- 2 Perform dimension A as per requirement of assembly
- 3 * Dimension is given for reference

Ⓐ EQ.MATERIAL: Gde 24345 'W' TO IS: 733

00818-ICV 11 oct 2001 00640-ICV 19 jun 1998 DC(I)No. & DATE	Ⓑ Given	EQ. MATERIAL ADDED.
	Ⓐ Given	EQ. MATERIAL ADDED.
ISSUE	AMENDMENTS	

APPROVED M VASU

CHECKED Anil Kumar

700-42-153

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

RING

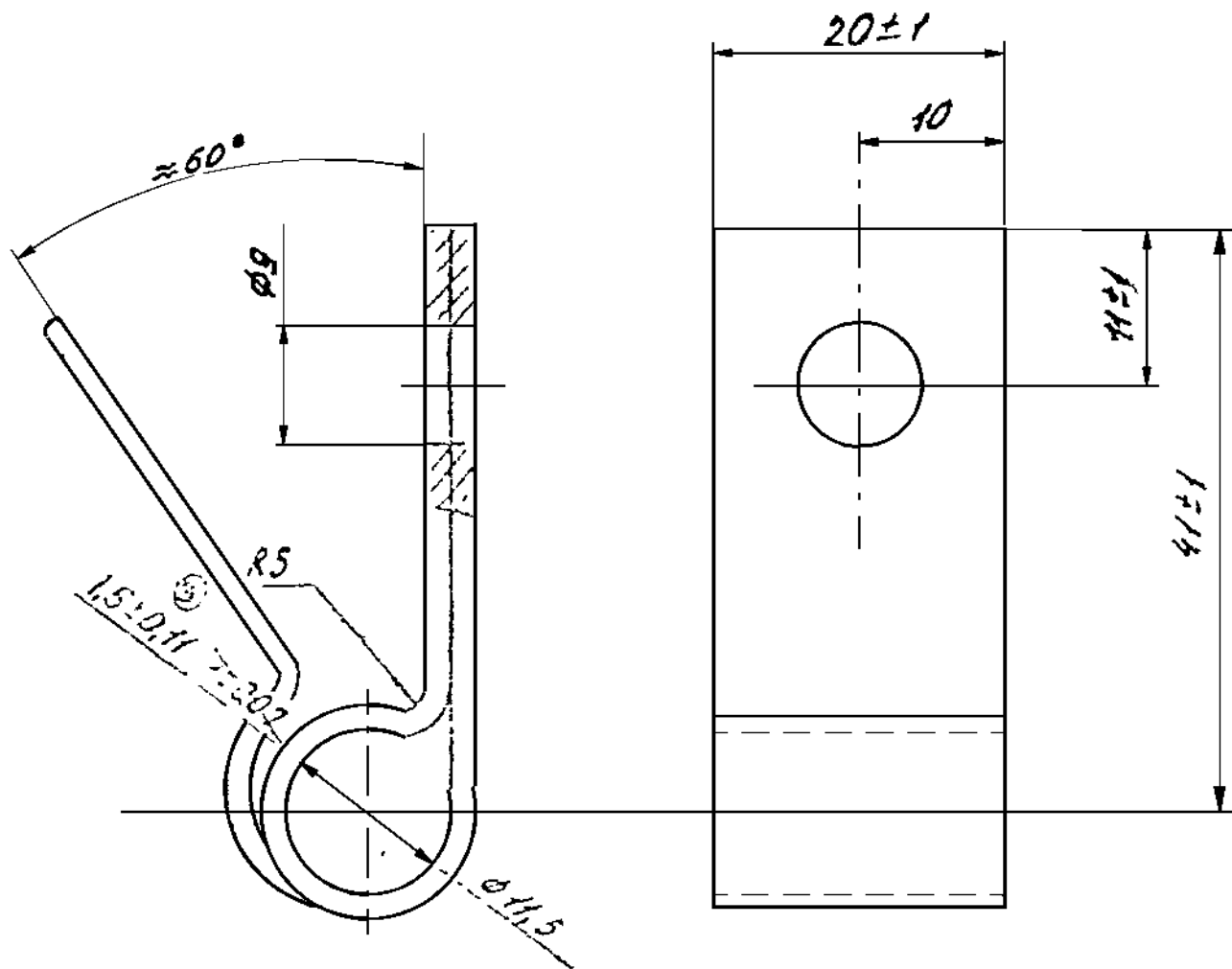
WEIGHT SCALE

0.002 1:1

SHT SHTS

BAR ALTP 34n
GOST 21488-76

700-54-185



- 1 Alternate material is 10 and 10kn, GOST 1050-74
- 2 Unspecified limit deviations of dimensions are ± 0.5 mm
3. Apply primer $\Phi/\text{I}-03\text{-K}$ GOST 9109-81 and paint with Enamel $\Pi\Phi\text{-223}$, Yellow, GOST 14923-78, all over
- 4 Part may be made as per conventional dotted line
- Ⓐ EQ MATERIAL:- STEEL SHEET GRADE 'D', 'DD' OR 'EDD' TO IS 4030-73

00518-ICV

Ⓐ

31 OCT 2000

Avn

EQ. MATERIAL ADDED.

DC(I) No.
& DATE

ISSUE

AMENDMENTS

APPROVED

R.R. PARWATKAR

CHECKED

Sinhumax

700-54-185

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

CLAMP

WEIGHT

SCALE

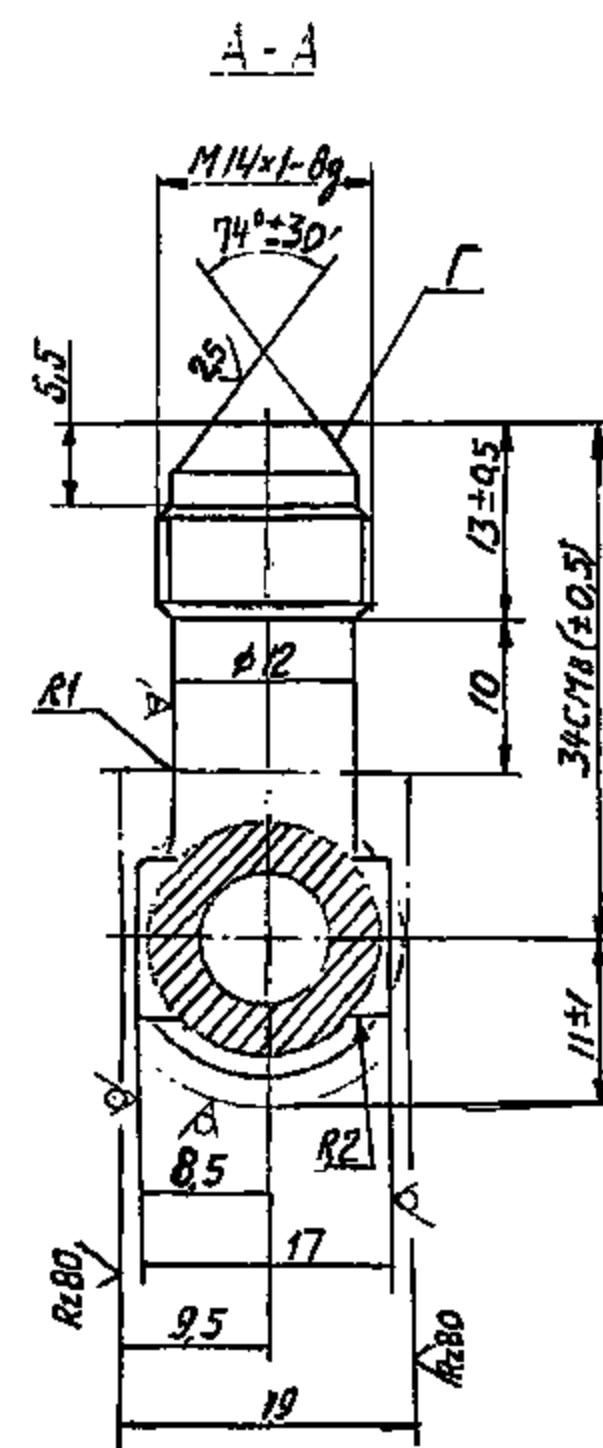
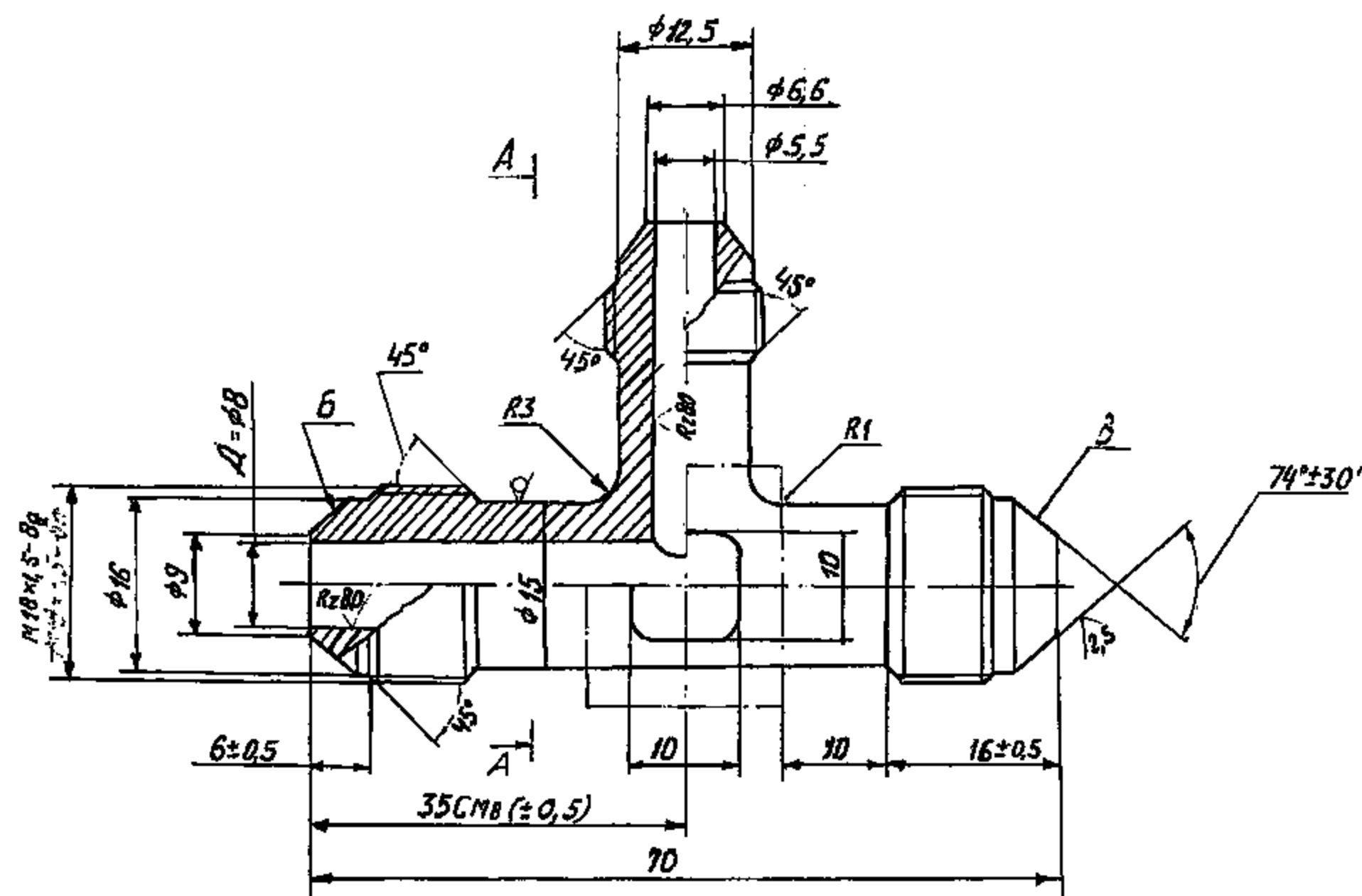
0.024

2:1

SHT

SHTS

STEEL 08kn GOST 1050-74



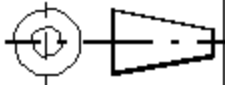
1. Alternate material is steel 40, GOST 1050-74.
2. Unspecified limit deviations of dimensions of surfaces to be machined are as follows: for holes-as per A7, shafts-as per B7, others-as per CM9. Other requirements for forging are as per class II, GOST 7505-74.
3. Local recesses of not more than 0,5mm are allowed on unmachined surfaces.
4. Run-out of surfaces B, B and Γ with respect to the corresponding angle diameters of threads should not exceed 0,06mm (qualified tolerance).
5. Shoulder of not more than 0,5mm is allowed in hole A.
6. Part may be made as per dash dott line.
7. Coating: Zinc-plated, .9 microns thick, chromitized. Remove hydrogen embrittlement. Absence of coating on the internal surfaces is allowed.

- ① EQUIVALENT MATERIAL: MATERIAL STEEL 20 C8 IS: 2004-78, CLASS-2
 ② EQUIVALENT MATERIAL: STEEL FORGING CLASS 2 (20C8) OR (25C8) TO IS: 2004-78.
 ③ ALTERNATE MATERIAL: 45 C8 TO IS: 2004-78.

THE ABBRIVATIONS AND SYMBOLS ARE
 BASED ON RUSSIAN SPECIFICATIONS.

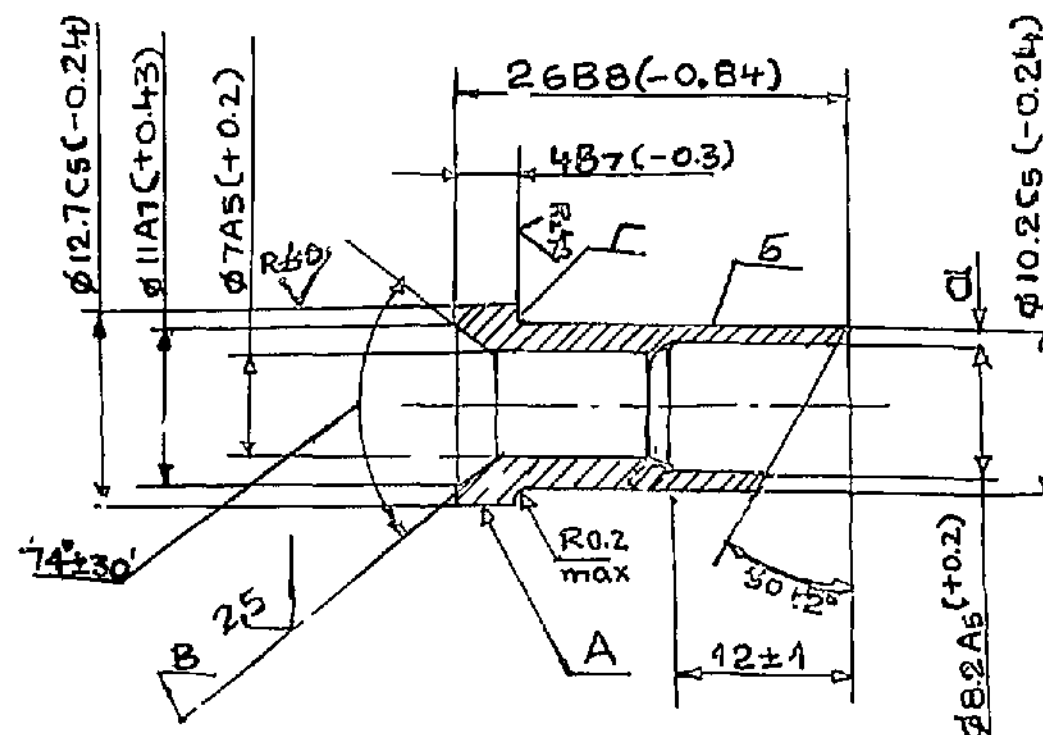
ALL DIMENSIONS ARE IN mm.

00818-ICV 11 OCT 2000 00625-ICV 30 MAR 98 DC(1) No. & DATE	(B) Gen. (A) Gen. (C) Gen.	EQ. MATERIAL AND ALTERNATE MATERIAL ADDED. MATERIAL STEEL 20 C8, IS: 2004-78, CLASS-2, ADDED. AS EQUIVALENT MATERIAL (1/98 N OF A)
---	----------------------------------	---

MATERIAL:- STEEL 20 GOST 1050-74		DCO)No. & DATE	ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF		ALL THREADS TO CONFORM TO SPECIFICATION		STAMP OR ETCH, PART No. MANUFACTURER's NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED				
SCALE: 2:1		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON:
DATE : 07 JUN 95				
DRN.		700-56-225		
TCD.				
CHD		T-JOINTS		
APPD				
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				

700-57-403

Rz80 (✓)



1. ALTERNATE MATERIAL IS STEEL 15, 20, 25 GOST 1050-74 AND 15Г, 20Г GOST 4543-71.
2. THE FOLLOWING ARE ALLOWED WITH RESPECT TO SURFACES A AND B MACHINED FROM ONE SETTING.
 - a). RADIAL RUN-OUT OF SURFACE B SHOULD NOT EXCEED 0.15 mm. (QUALIFIED TOLERANCE)
 - b). END-PLAY OF SURFACE 'Г' SHOULD NOT EXCEED 0.06 mm
3. DIFFERENCE IN MEASUREMENTS OF DIMENSIONS 'α' SHOULD NOT EXCEED 0.2 mm.

EQ. MATERIAL :-

- i) STEEL TO IS: 7283-74 (MATERIAL AS PER IS : 226-75)
- ii) MATERIAL 10 C4 TO IS: 9550-80 Gr I OR
- iii) CLASS I A GRADE 15 C8 TO IS, 2004-78 OR
- iv) STEEL BAR C10 OR C14 OR C15 Mn 75 OR C20 OR C25 Mn 75 OR C30 TO IS: 2073-70. OR
- v) STEEL BAR C14 TO IS: 2073-70. OR
- vi) STEEL BAR C15 Mn 75, C20 TO IS: 2073-70. OR
- vii) STEEL BAR C25 Mn 75, C30 TO IS: 2073-70

00883-ICV R. 9.20 01-06-2001		DRAWING REVISED AND RETRACED	
ORGL MATERIAL:- STEEL 10 GOST 1050-74		DC(I) No. & DATE	ISSUE
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF		ALL THREADS TO CONFORM TO SPECIFICATION	
DRG. NOT TO BE SCALED		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	
SCALE: 2:1		DATE: 01-06-2001	
WT :- (Kg) 0.007		NIPPLE	
700-57-403		DS CAT No.	
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)			

NOTE: ALL DIMENSIONS ARE IN mm