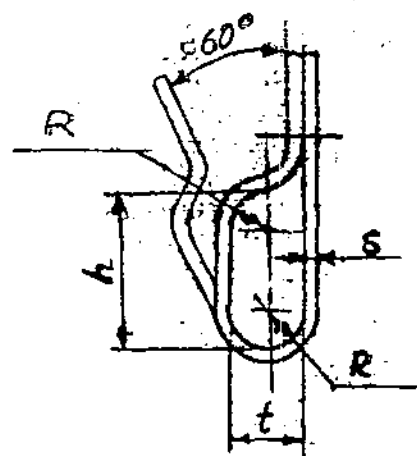


Conventional designation of clamp height — h
for tubes with external radius R : $xnm-Rxh$

Std 231-72
I-1455
SH. 3 of 18

DESCRIPTION OF CLAMP

Conventional designation	765					For tube external - d	R	h	t		d _i	H		a		B		S	2	Weight of one piece in kg
									Std	Div		Std	Div	Std	Div	Std	Div			
XPM-4 x 16						8	3,75	16	7,5		7	40								0.013
												±1	8	±1	20	±1	0.8±0.08	2		
										-0,5										
XPM-5 x 20						10	4,75	20	9,5			40								0.014
XPM-5 x 30								30				50								0.015

1. Deviations in free dimensions are $\pm 0,5$
2. Seams are not allowed.
3. Making along the dotted line is allowed
4. Material: Steel 10 GOST 1050-74 Steels of 08 kg and 10 kg GOST 1050-74 grades are allowed as alternate material
5. Coating: Zinc plated 9 micron thick, chromitized, remove hydrogen embrittlement

Ⓐ EQ. MATERIAL:- Gde 'D' TO IS: 513-94.

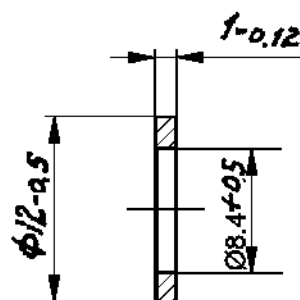
21025.10V	Ⓐ	EQ. MATERIAL ADDED
24 OCT 1978	ISSUE	AMENDMENTS

112/113

APPROVED	M. VASU	standard 231-72	
CHECKED			
CONTROLLERATE OF INSPECTION (ICV)		MULTIPURPOSE CLAMP	
		WEIGHT	SCALE
		SHT	SHTS
		169	78

624214-K

2



TECHNICAL CONDITIONS

1. Blunt sharp edges
2. Alternate material is 1168 1162 and 11M4 58-2
GOST 15527-70.

Ⓑ EQ. MATERIAL:- BRASS SHEET Gde CuZn-37 TO IS: 410

01005-ICV <i>Logan</i> 24-10-05	Ⓑ	EQ. MATERIAL ADDED.
00991-ICV <i>Logan</i> 25-02-05	Ⓐ	DS ACT No. ADDED AND NOMENCLATURE WAS 'WASHER'
DC(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED

H N VASU

CHECKED

H N SLAWE

624214-K

DS CAT PAT No.
LV2/ICVS 5310-023 387

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

Ⓐ
WASHER FLAT

WEIGHT SCALE

0.0005 2:1

SHT 1 SHTS 1

sheet 1163M GOST 15527-70

FORMAT	ZONE	REF. NO.	DESIGNATION	DESCRIPTION	QTY.	REMARKS
				Technical papers		
			625300M-Kcδ	Valve cock		
				Assembly drawing		
			N-50-B	Instructions on marking		
				and certification of units		
				and parts of items		
				Assembly units		
12	1	672-78-cδ104 LV2/ICVS 2540-002843	Handle Lever Release	1	REF DC(E) 00991-ICV	
12	2	765-78-cδ712 LV2/ICVS 5340-135148	Retainer Retainer Air Lock	1	REF DC(I) 01023-ICV	
				Parts		
12	3	625307M-K2	Cover		1 Piece may	
					be replaced	
					by Ref No 6	
12	4	625301M-K	Body	1		
12	5	625303M-K LV2/ICV 4820-004250	Slide-valve VALVE HEAD	1	REF DC(I) 00992-ICV	
12	6	625307M-K	Cover		1 Piece may	
					be replaced	
					by Ref No 3	
12	7	625329-K	Piston Barrel	1		
12	8	625332-K	Spring	1		
11	9	625333-K	Axle	1		

APPROVED	MTVASU	625 300M-K	DS CAT PART No. ② LVT/ICV 4820-004249	
CHECKED	N M Shaikh		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		② VALVE COCK	SHT 1 SHTS 3	

FORMAT	ZONE	REF. NO.	DESIGNATION	DESCRIPTION	QTY.	REMARKS
11		10	625334-K	Pin.	1	
11		11	625335-K	SET screw	2	
11		12	624214-K LV2/ICV 5310-023387	Washer Flat	1	REF. DCC(I) 00991-ICV
11		13	672-78-14 LV2/ICV 5306-012481	Rod threaded End	1	REF. DCC(I) 00992-ICV
11		14	672-78-99	Strap	1	
11		15	672-78-100	PACKING	1	
11		16	672-78-101	Bushing	1	
11		17	672-78-102	Spring	1	
11		18	700-38-1680	Spring	1	
11		20	701-119-11 LV2/ICV 5355-001939	Lever-head knob	1	REF. DCC(I) 00992-ICV
11		21	770-72-152-K (A)	Ring	1	
				Standard items		
		22		Ring 008-012-25-2-2		
				GOST 9833-73.	2	
		24		Screw B1.14-8h6hx14.48.		
				016 GOST 17473-80.	1	
		25		Nut M5.6.016		
				GOST 5932-73.	1	
		26		Washer 4.01.019 or	1	
				4.02.019 GOST 11371-78	1	
		27		Cotter-pin 1x12.019		
				GOST 397-79.	1	

APPROVED	IS VASH	525 300M-K			DS CAT PART NO. (B) LV2/ICV 4820-004249		
CHECKED	H. M. SL - 12						
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		(B) VALVE COCK				WEIGHT	SCALE
					SHT 2 SHTS 3		

[illegible]

NO	QTY	DESIGNATION	DESCRIPTION	QTY	REMARKS
			Technical papers.		
13		625300M-K1C5	Valve.		
			Assembly drawing.		
		M-50-6	Instructions on marking		
			and certification of units		
			and parts of items.		
			Assembly units.		
12	1	672-78-c8105	Handle.	1	
			Parts		
12	2	625-307M-K2	Cover		1 Piece may be
					replaced by
					Ref.No.5
12	3	625301M-K	Body	1	
12	4	625303M-K LV2/ICV 4820-004250	Slide valve VALVE HEAD	1	REF. DC(I) 00992-ICV
12	5	625307M-K	Cover		1 Piece may
					be replaced
					by Ref.No.2.
12	6	625329-K	Piston Barrel	1	
12	7	625332-K	Spring	1	
11	8	625333-K	Axle	1	
11	9	625334-K	Pin	1	
11	10	625335-K	SET screw	2	
11	11	624214-K LV2/ICVS 5310-023387	Washer, Flat	1	REF. DC (F)

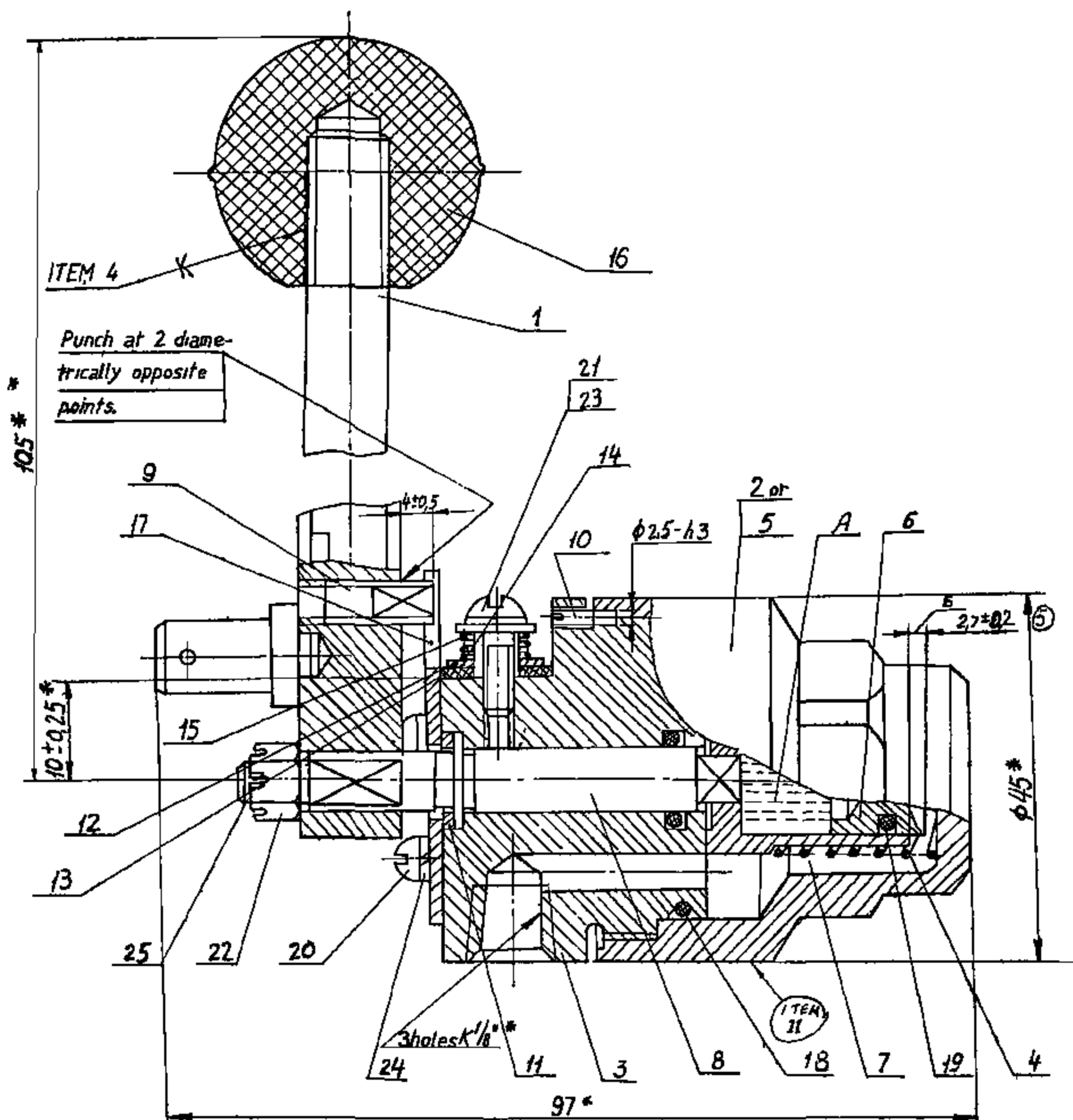
APPROVED	M. VASU	625 300M-K1			
CHECKED	M. A. Shaifan	VALVE		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)					
			SHT 1 SHTS 3		

	ZONE	NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
11		12	672-78-99	Strip	1	
11		13	672-78-100	PACKING	1	
11		14	672-78-101	Bushing	1	
11		15	672-78-102	Spring	1	
11		16	701-119-11 LV2/ICV55355-001939	Lever head KNOB	1	REF. DC00 00992-ICV
11		17	765-78-1457	Retainer	1	
11		18	770-72-152-K	Ring	1	
				Standard items.		
		19		Ring 008-012-25-2-2		
				GOST 9833-73	2	
		20		Screw B1M4-8h6hx8.48.		
				016.		
				GOST 17473-80 or		
				B1M4-8h6hx8.66.016		
				GOST 1491-80.	4	
		21		Screw B1M4-8h6hx14.48.		
				016		
				GOST 17473-80	1	

APPROVED		625 300-M-K1			
CHECKED	H.M. Shchepa				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		VALVE		WEIGHT	SCALE
			SHT 2	SHTS 3	

--	--

APPROVED	<i>M VASU</i>
CHECKED	<i>H.M. St. C. Rf</i>
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	

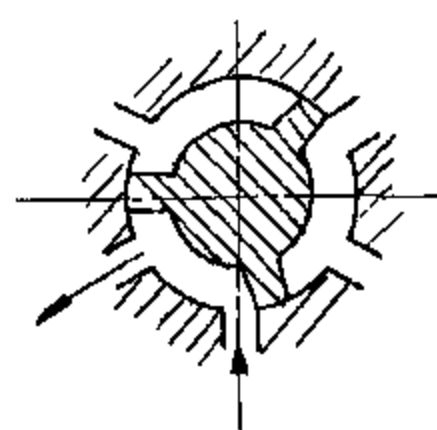


TECHNICAL CONDITIONS

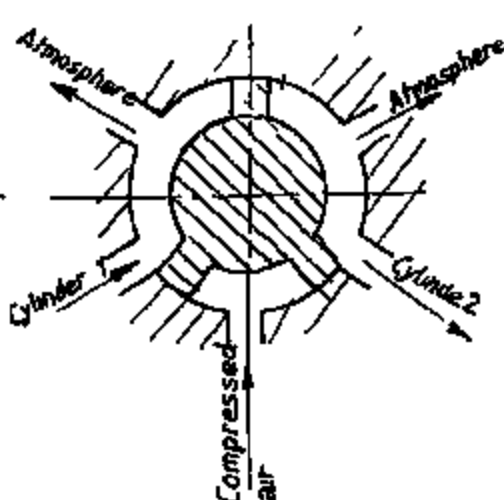
- 1 During assembly fill cavity A with oil TC3П-8 Technical specifications 101313-77 when position of plunger Ref No 6, to dimension B.
- 2 Lubricate the sliding surfaces of part, Ref No 11 and Ref.No.8 with lubricant ЦИАТИМ 201 'GOST 6267-74.
- 3 Marking of marks on parts, Ref.No.8 and Ref.No.17 should correspond to neutral position
4. Adhesive
- 5 Lubricate threaded connection with benzine base lubricant GOST 7171-78 or with lubricant ЦИАТИМ 201 GOST 6267-74.
- 6 Tight the cover, Ref.No.5 fill it rests against the body
- 7 Lubricate parts, Ref No 18 and 19 before assembling, with oil MT-16П GOST 6360-58 or MT-16П Technical specifications TY 38-00 111 7-73
8. Check the working diagram of valve at air pressure of 15^{+5} kg/cm² Carryout switching at least 3 times with intervals of 2 to 3 seconds
9. Test the valve for airtightness by feeding air at a pressure of 15^{+5} kg/cm² and 80^{+10} kg/cm² for 3 minutes for every pressure. Leakage of air is not allowed. Ascertain the air tightness by immersing the valve in water containing potassium bichromate. Water in drainage holes is not allowed. Check leakage under slide valve through tube inserted in drainage hole After testing plug threaded holes with plug 672-78-81
- 10 Carryout sealing of drainage holes after testing for air tightness
- 11 Carryout marking as per instructions N-50-B pin 2,5. Marking on parts Ref.No.2 & 5 is allowed.
- 12 Punch screws, Ref.No.10 at 2 places in slot.
13. Seal screws, Ref.No.10 and slots of 2 bottom screws, Ref.No.20 with red varnish HM-62 OST 6-10-391-74.

Working diagram of valve

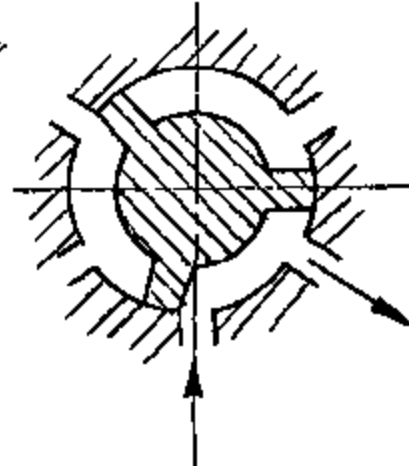
I Operation



Neutral position



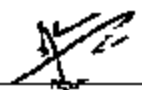
II Operation.

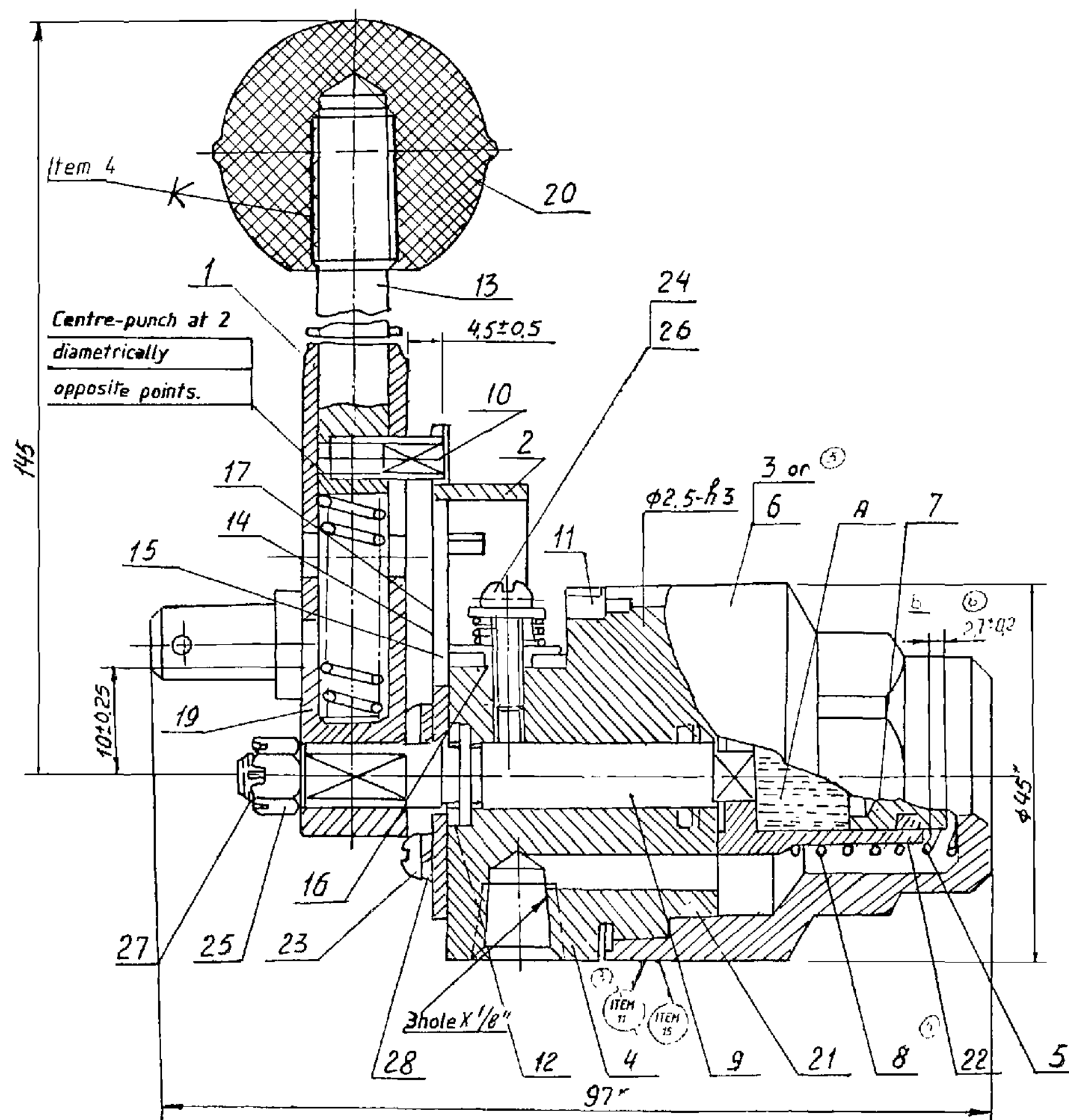


Independent supply of valve is carried-out according to Technical specifications TY 625300M-K/K1.

THE ABBRIVATIONS AND SYMBOLS ARE BASED ON RUSSIAN SPECIFICATIONS.

ALL DIMENSIONS ARE IN mm.

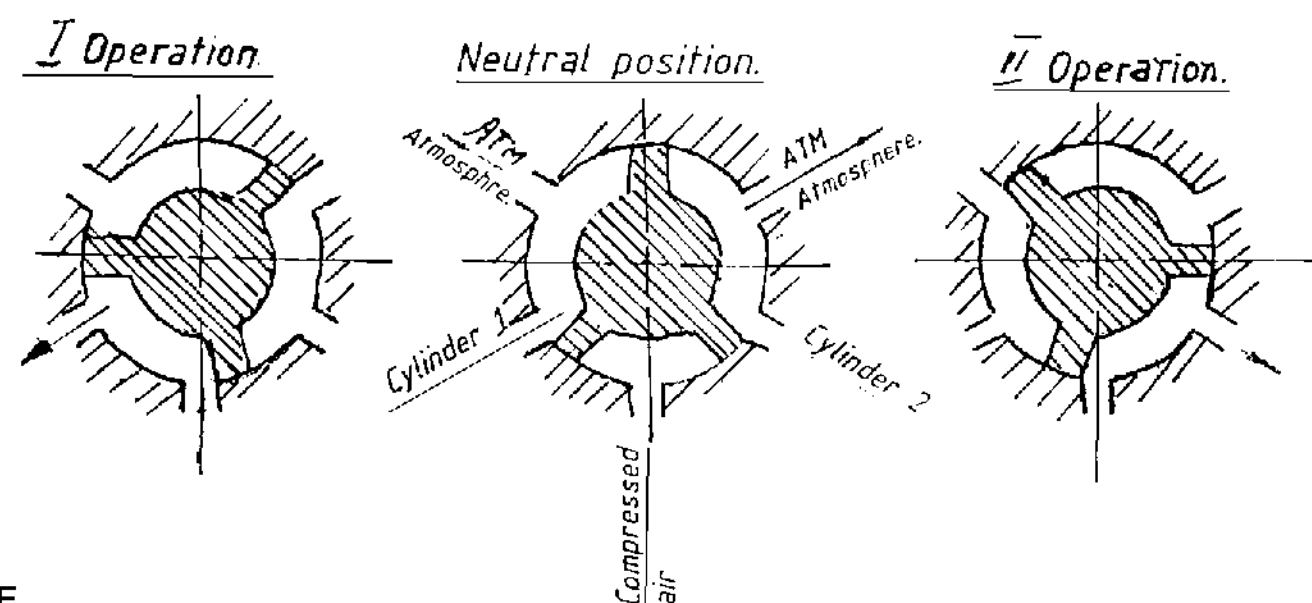
APPROVED		625 300M-K1Sb			
CHECKED	<i>J. m. Shaitan</i>	VALVE (ASSEMBLY DRAWING)		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				0.45	2:1
			SHT 1 SHTS 1		



TECHNICAL CONDITIONS

1. During assembly fill cavity A with oil TC3Π-8. Technical specifications TY 38-101313-77 while the position of piston Ref.No.7, is adjusted to dimension 6.
2. Lubricate sliding surfaces of washers, Ref.No.12, axle, Ref.No.9 and rod, Ref.No.13 with lubricant ЦИАТИМ 201 GOST 6267-73.
3. Coincidence of marks on parts. Ref.No.2 and 9 means the neutral position.
4. Adhesive.
5. Lubricate threaded connections with Benzene-based lubricant GOST 7171-78 or with lubricant ЦИАТИМ 201 GOST 6267-74.
6. Tight cover, Ref.No.4 till it rests against the body.
7. Before assembly lubricate parts Ref.No.21 and 22 with oil MT-16Π GOST 6360-58 or with MT-16Π Technical specifications TY 38-001117-73.
8. Rod, Ref.No.13 should return to rap position under the spring action.
9. Check the operation diagram of valve. under pressure of $15 \cdot 10^5$ kg/cm². Carry-out testing at least for 3 times switching with an interval of 2 to 3 seconds.
10. Check the Valve for air tightness by feeding air under pressure of $15 \cdot 10^5$ and $80 \cdot 10^5$ kg/cm² for 3 minutes for each pressure. Leakage of air is not allowed. Air tightness test is to be performed by immersing the valve in water containing chrome-nickel. Entering of water in drainage holes is not allowed. Leakage under slide valve is checked through tubes, set in drainage holes. After checking, plug the threaded holes with stopper plug 672-78-81.
11. Sealing of drainage holes is carried out after testing airtightness.
12. Centre-punch screws, Ref.No.11 at 2 points in slots.
13. Fill screws, Ref.Nos.11 and slots of 2 bottom screws Ref.No.23 with red varnish HL-62, OST 6-10-391-74.
14. *Dimensions are given for reference.
15. Mark as per instructions N-50-6. with type 2.5. Marking on parts. Ref.Nos.3 and 6 is allowed.

Operation diagram of valve

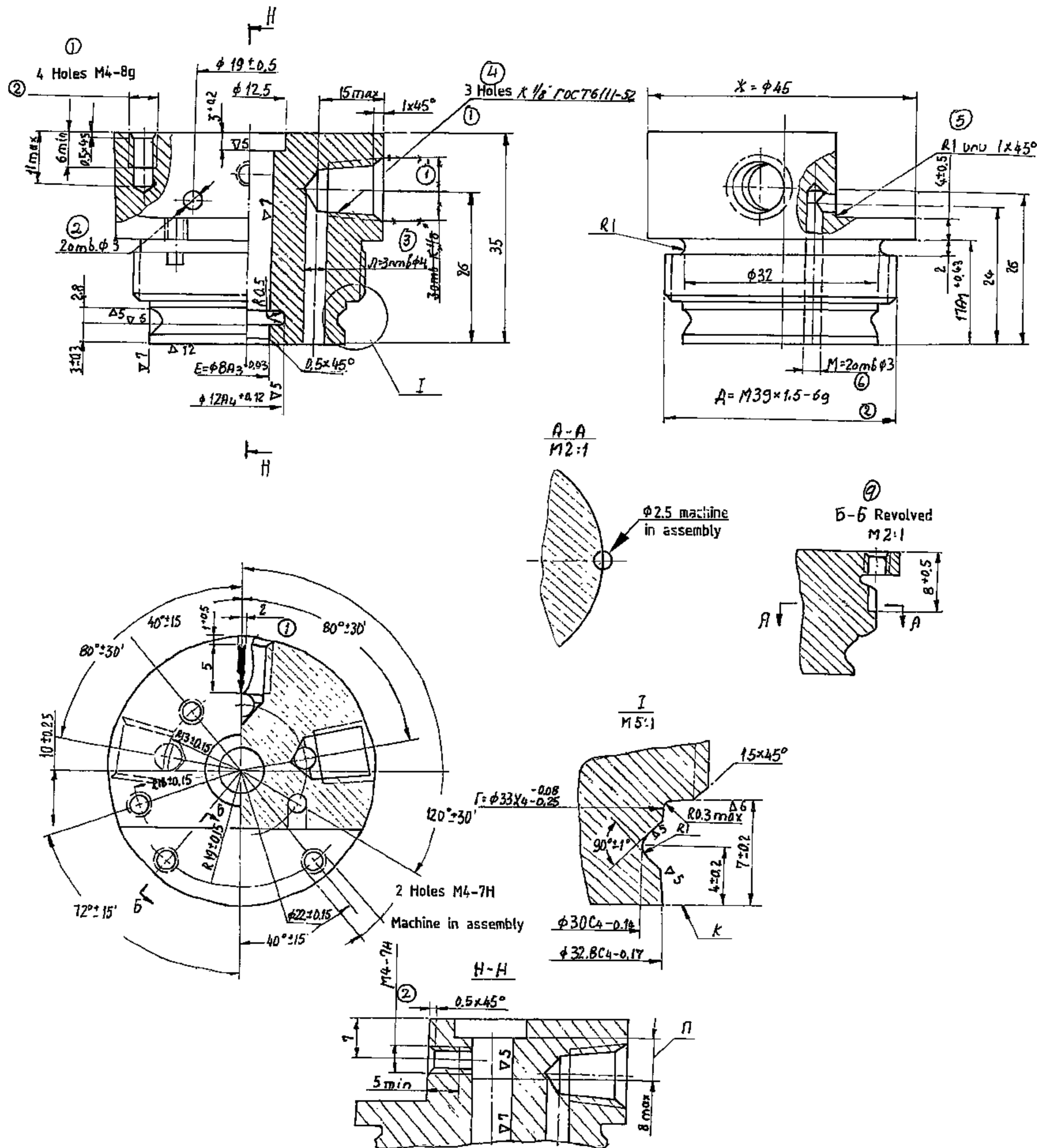


THE ABBRIVATIONS AND SYMBOLS ARE BASED ON RUSSIAN SPECIFICATIONS.

ALL DIMENSIONS ARE IN mm.

00992-ICV	A	DS CAT PART No. ADDED AND NOMENCLATURE VALVE AMENDED AS COCK
30 Mar 05	ISSUE	AMENDMENTS
DC/No.		
DATE		

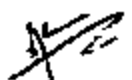
APPROVED	<i>[Signature]</i>	625 300M-K Sb	DS CAT PART No. A
CHECKED	<i>[Signature]</i>	VALVE COCK	LV2/ICVs 4820-004249
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		ASSEMBLY DRAWING	WEIGHT SCALE
			0.57 2:1
			SHT 1 SHTS 1

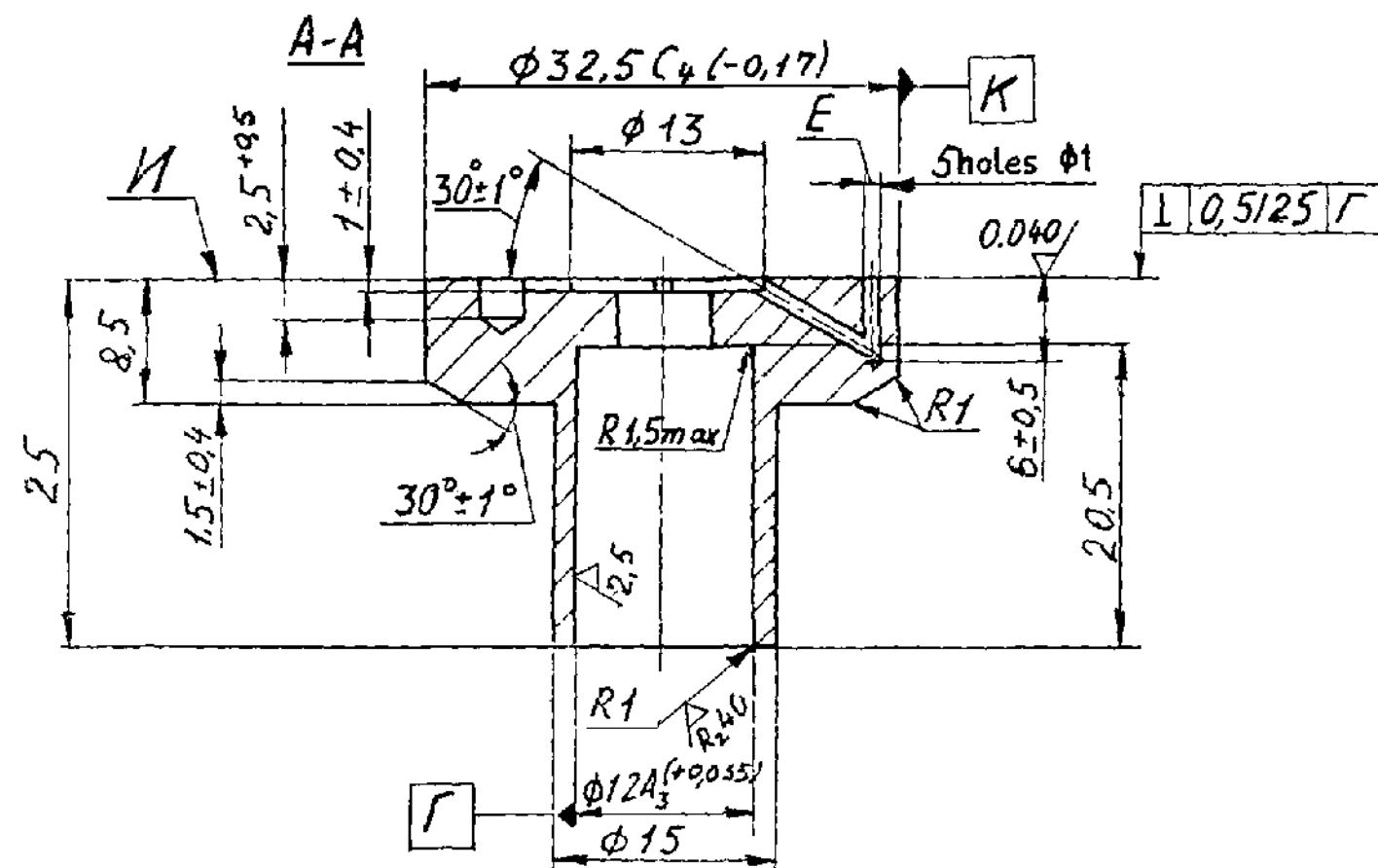


TECHNICAL CONDITIONS

1. Blunt sharp edges, except for edges on surface K. Rounding-off of sharp edges should not exceed $R=0.2\text{mm}$ on surface K.
 2. Dimensions without deviations should conform to accuracy of class 7, OST 1010.
 3. Eccentricity of surface F and angle diameter of thread should not exceed 0.03mm (qualified tolerance).
 4. Check diameter E after coating.
 5. Play of butt end K with respect to surface axis E should not exceed 0.1mm .
 6. Lap surface K on plate. Non-flatness should be 0.003mm .
 7. Carburize surface K to depth 0.8 to 1.4mm and harden to $HRC > 56$.
 8. Coating: Cadmium plated 9 to 15 micron thickness, except for surface K, thread A, groove of element I and surface E. Do not check coating on internal surfaces.
 9. Alternate material is 12XH4A GOST 4543-71.
 10. Depression of arrow should not exceed 0.5mm .
 11. Eccentricity of hole E and angle diameter of thread A should not exceed 0.05mm .
 12. The displacement of hole axes A and M from true position may be checked with combination gauge with pins $\phi 2.8$ and $\phi 3.8$, pin height aligning along hole E should be at least 20mm .
 13. Loosening of diameter may be up to $\phi 8A_6^{(0.1)}$ on section A.
- EQ. MATERIAL: GRADE: ALLOY STEEL 13Ni 3Cr 80 TO 19:4432

00838-ICV	EQ. MATERIAL ADDED
20-11-2000	AMENDMENTS
DC(No. DATE	ISSUE

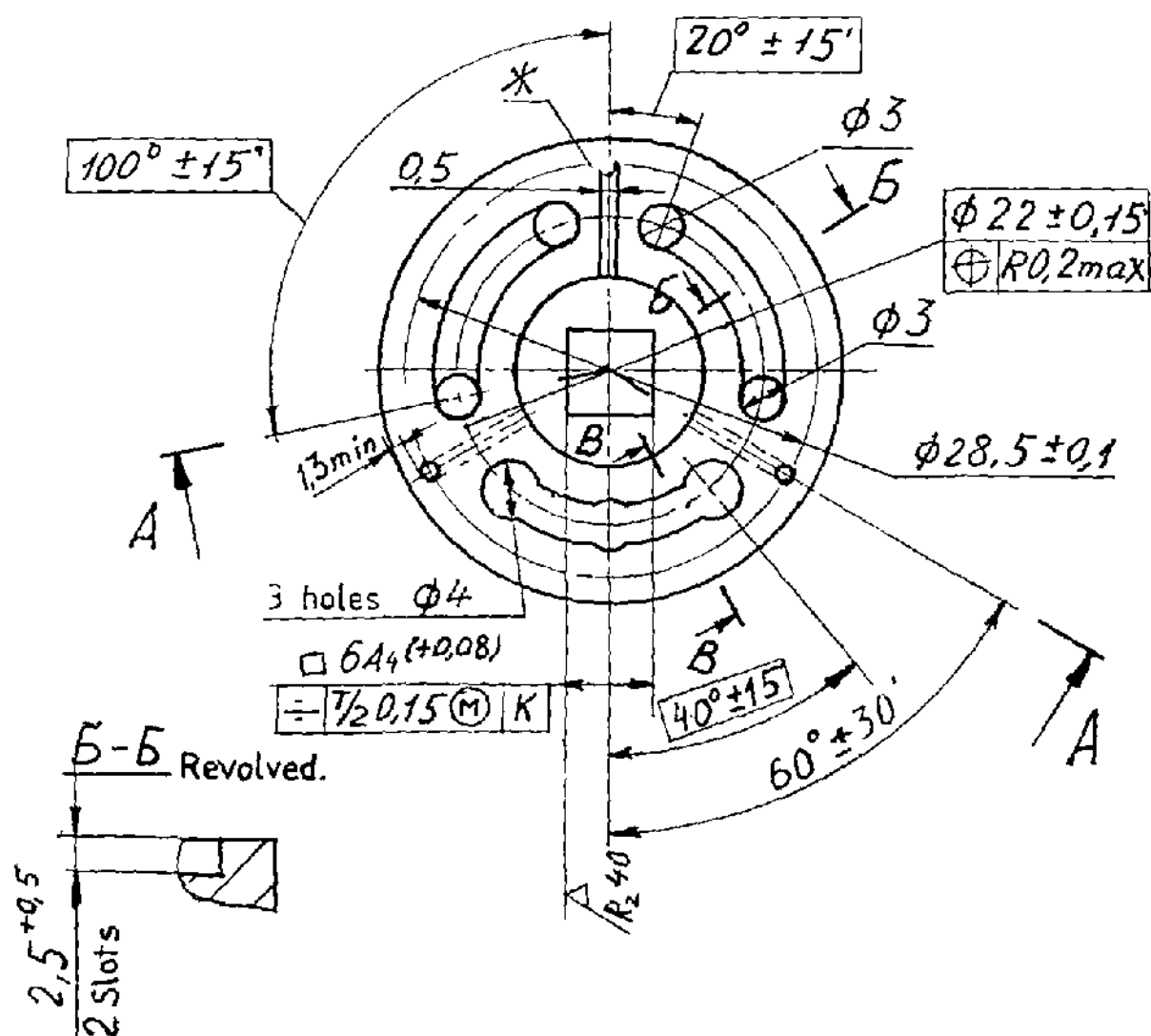
APPROVED		625 301M-K			
CHECKED		BODY		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)			0.250	2:1	
	SHT 1 SHTS 1				
		12XH5A GOST 4543-71			



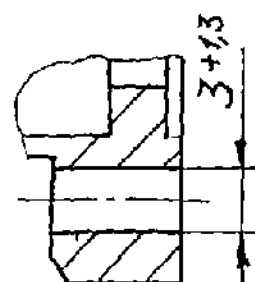
TECHNICAL CONDITIONS

1. Unspecified limit deviations of dimensions are as follows
For holes - as per A₇,
For shafts - as per B₇,
For others - as per CM₇
2. Lap surface *N* on plate concavity should not exceed 0.003mm, (Curvature trace should be lapped against the internal band)
3. Check dimension of hole E before making slot X.
4. Passivate

Ⓑ EQ. MATERIAL: Gde LG4 TO BS:1400-65



B-B Revolved.



01005-ICV	Ⓑ	EQ. MATERIAL ADDED
24 OCT 05		
00992-ICV	Ⓐ	DS CAT PART NO. ADDED AND NOMENCLATURE SLIDE VALVE AMENDED AS VALVE HEAD.
30 MAR 05		
DC(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED

M. V. C.

CHECKED

H. M. S. & K.

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

625 303M-K

VALVE HEAD

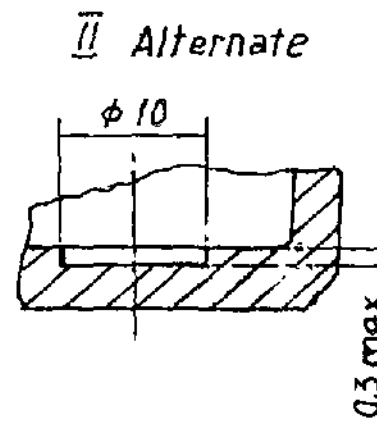
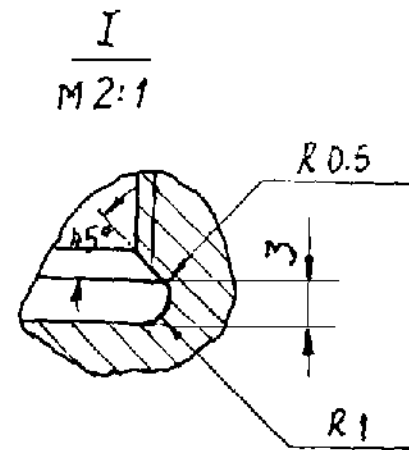
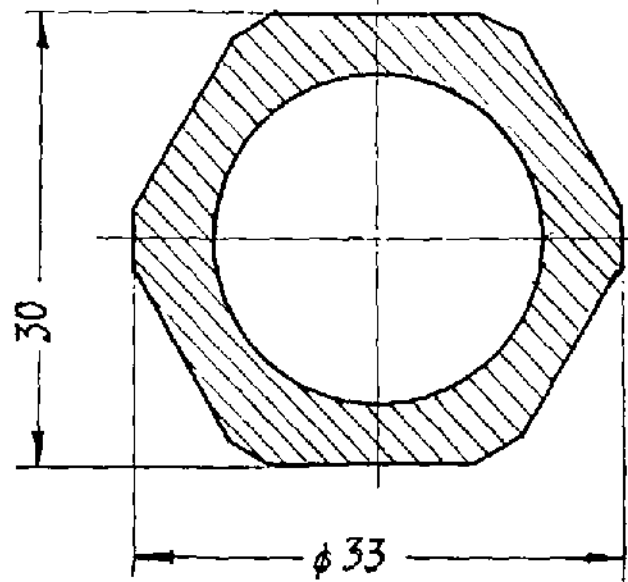
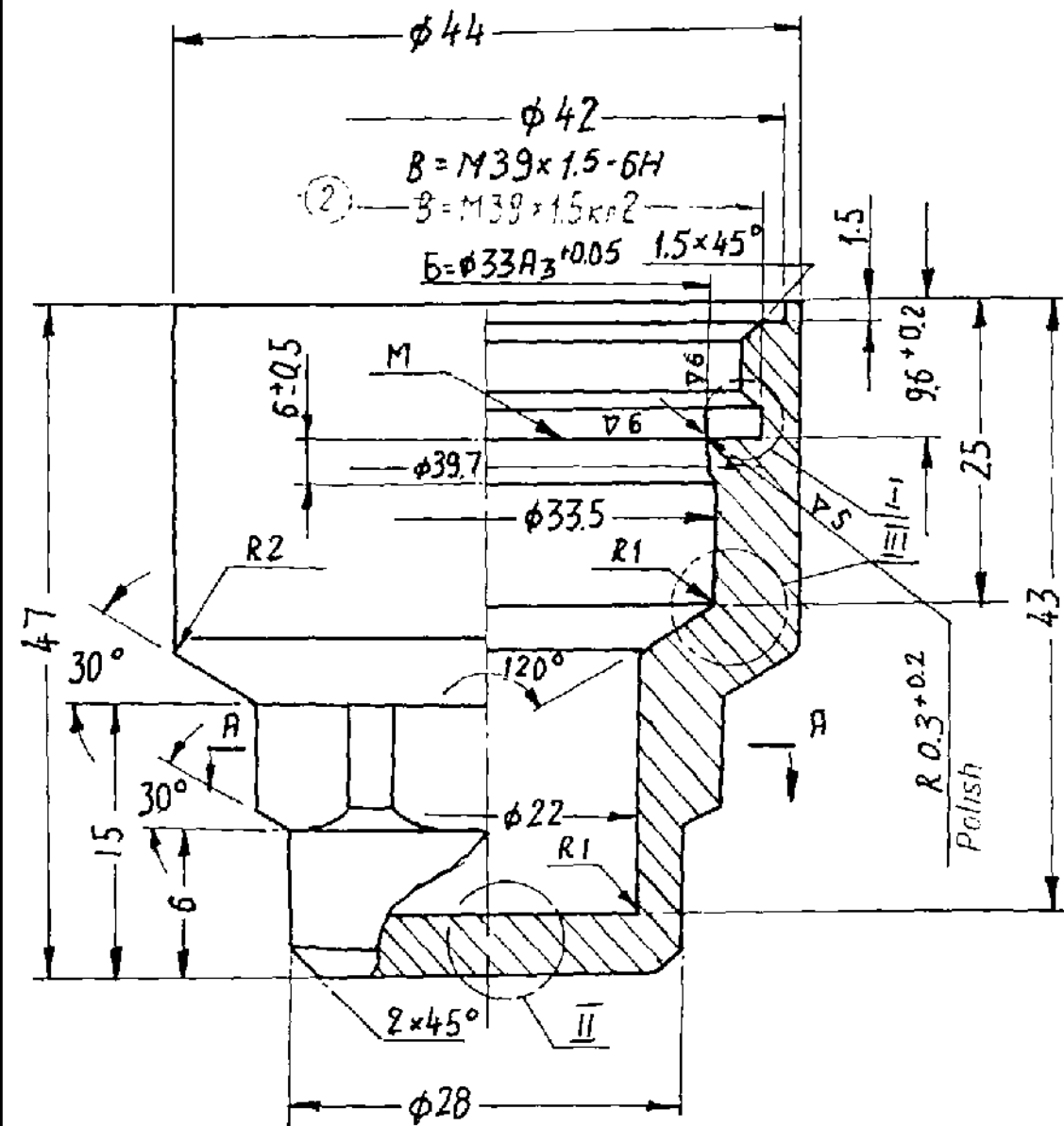
5 P C-305C TECHNICAL
SPECIFICATIONS TY-CM1-65

DS CAT Pt No. ④
LV2/ICVS 4820-004 250

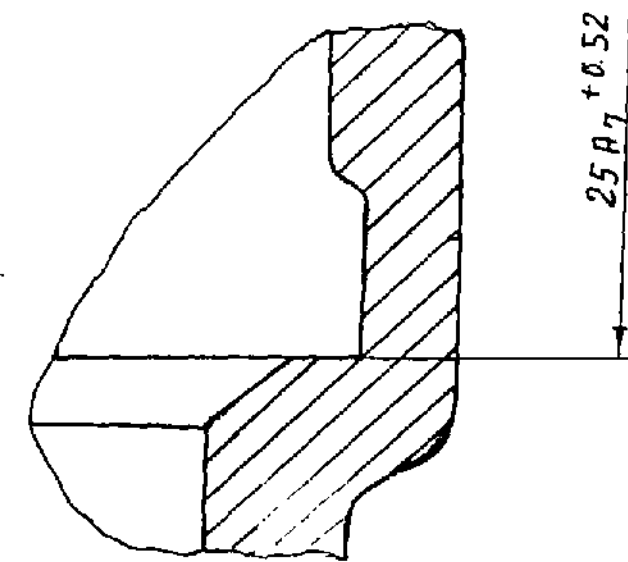
WEIGHT SCALE

0.04 2:1

SHT 1 SHTS 1



III Alternate
M 5:1



TECHNICAL CONDITIONS

1. Blunt sharp edges.
2. Run-out of angle diameter of thread with respect to surface $\phi 6$ should not exceed 0.03mm (qualified tolerance).
3. Play of butt end M with respect to axis $\phi 5$ should not exceed 0.05mm.
4. Coating: anodic oxidation, chromated.
5. Alternate coating is chemically parkerized, blue.
6. Dimensions, without deviations should conform to accuracy of class 7, OST 1010.

④ EQ. MATERIAL:- Gde 24534 TO IS:734-75.

01005-ICV <i>[Signature]</i> 24 OCT 05	Ⓐ	EQ. MATERIAL ADDED
DC(I)No. & DATE	ISSUE	AMENDMENTS

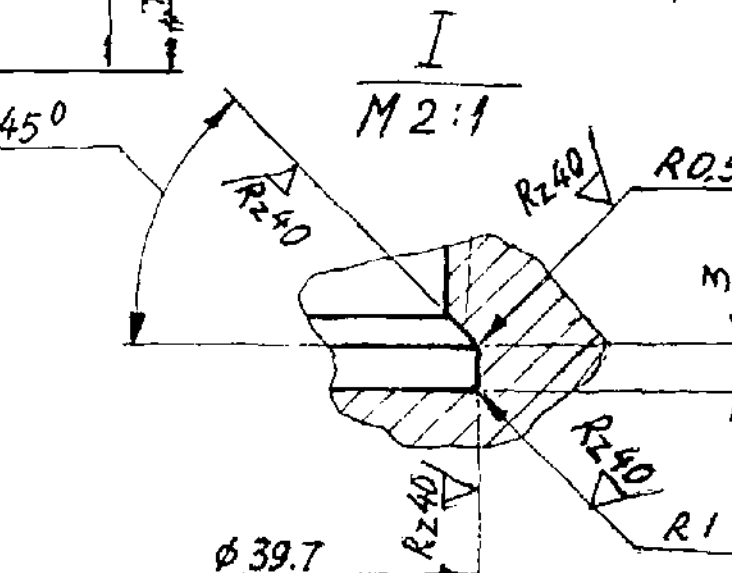
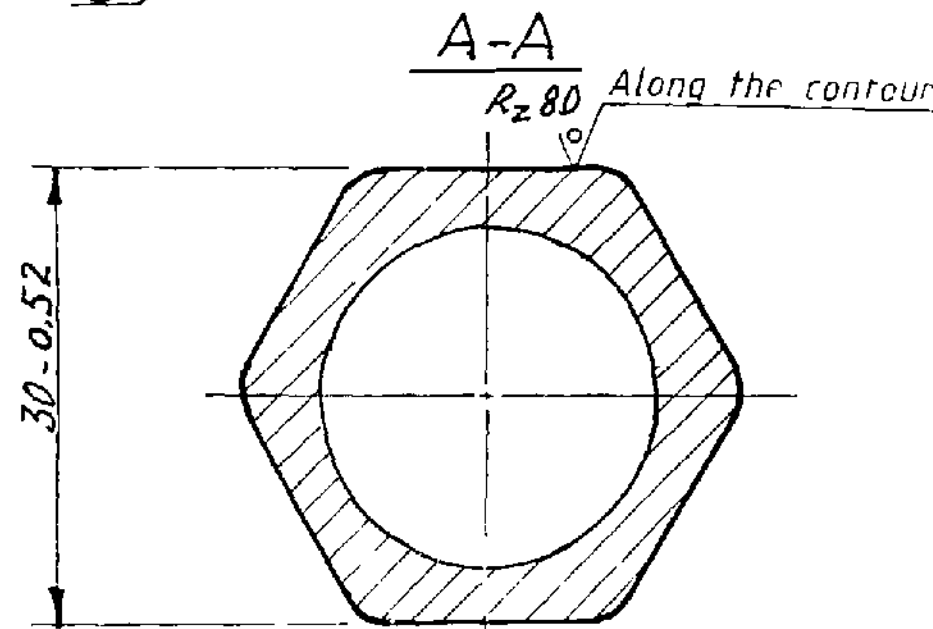
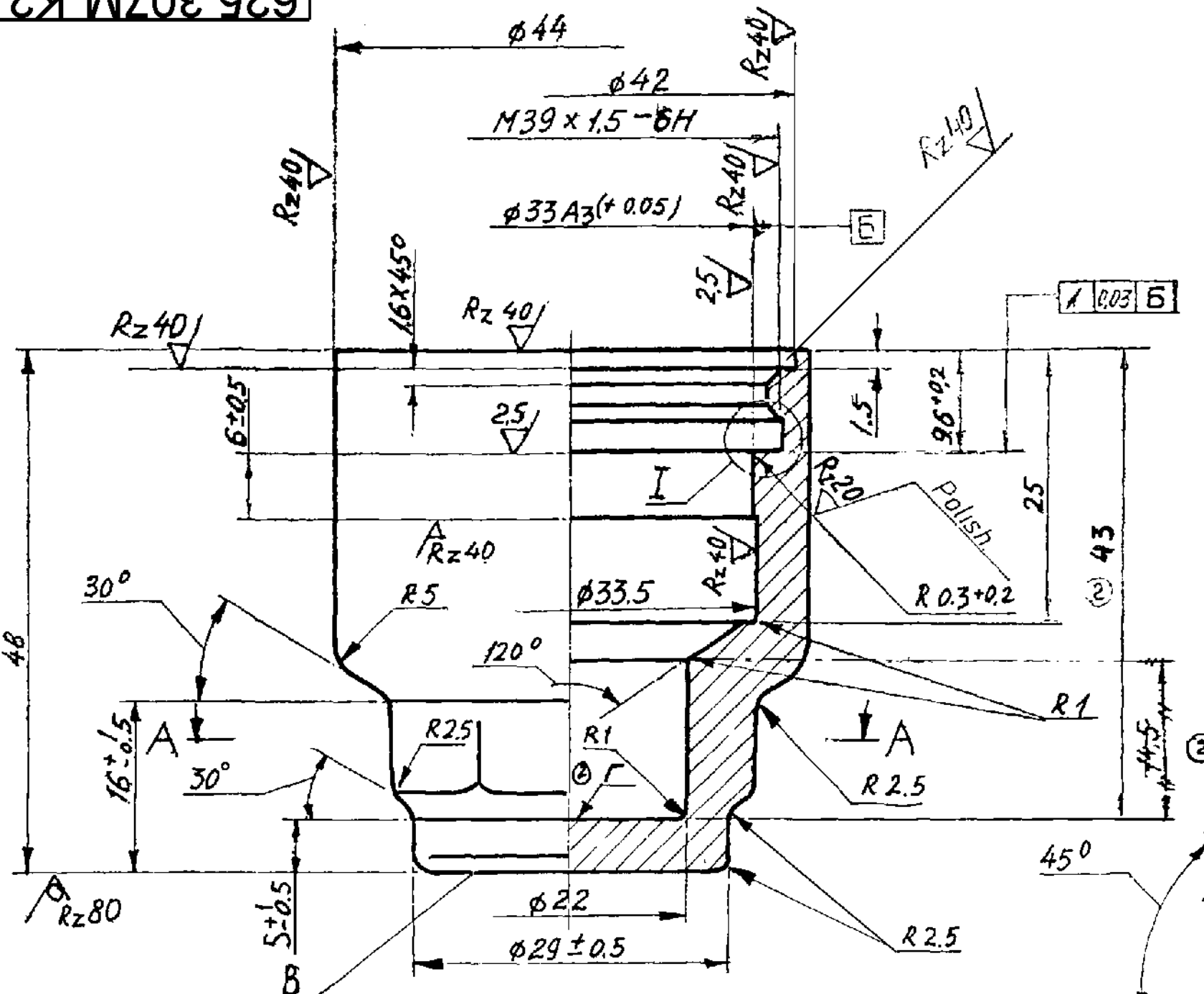
APPROVED		625 307M-K			
CHECKED		COVER		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				0.062	2:1
			SHT 1 SHTS 1		
		D 16T, GOST 4784-74			

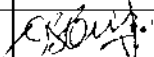
625 307M-K2

TECHNICAL CONDITIONS

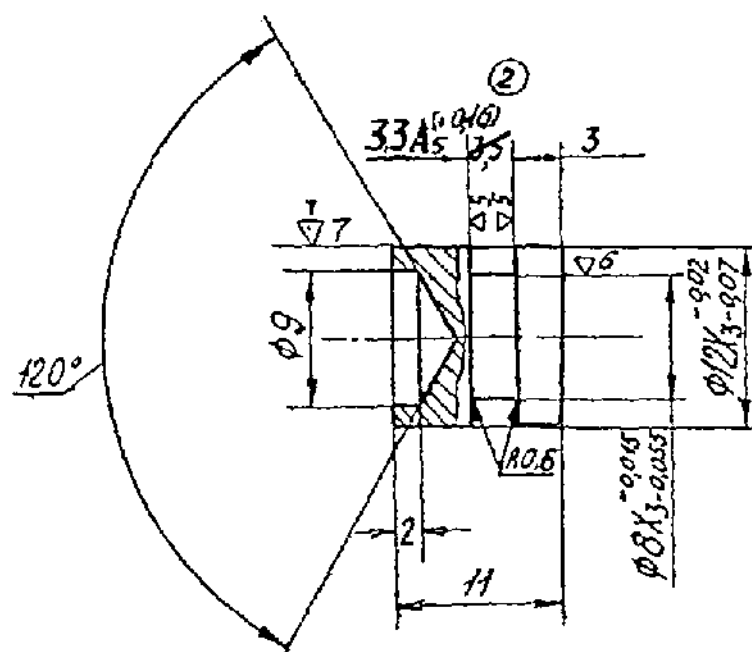
Kz80/ (✓)

- To be heat treated till achieving condition T
- Coating anodic oxidation, chromarized
Alternate coating is chemically parkerized, blue
- Run-out of angle diameter of thread with respect to surface B should not exceed 0,03mm (qualified tolerance)
- Surface should not exceed 2°
- Traces of gate of Ø20mm to depth or height not exceeding 1,5mm is allowed on surface B
- Test the part for air tightness by feeding air ... water bath under a pressure 80^{+10} kg/cm² for 1 minute
Air leakage is not allowed. Testing may be done in assembly
- Tool trace to depth not exceeding 0,3mm Ø10 is allowed on surface F
- Unspecified limit deviations of dimensions are as follows:-
For holes - as per A₇
For shafts - as per B₇
For others - as per CM₈
For angles - as per 10 degree of accuracy as per GOST 8908-58.



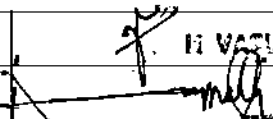
APPROVED	 M. VASO	625 307M-K2			
CHECKED	 Z. S. K. V. A. I. K.				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		COVER		WEIGHT	SCALE
				0.065	2:1
		16 GOST 4784-74		SHT 1 SHTS 1	

▽3 Unless otherwise specified



1. Blunt sharp edges.
 2. Dimensions without deviations should conform to accuracy of class 7, OST 1010.
 3. Alternate material is 30X13 GOST 5632-72.
- Ⓐ EQ. MATERIAL:- AISI 431. (ASTM).

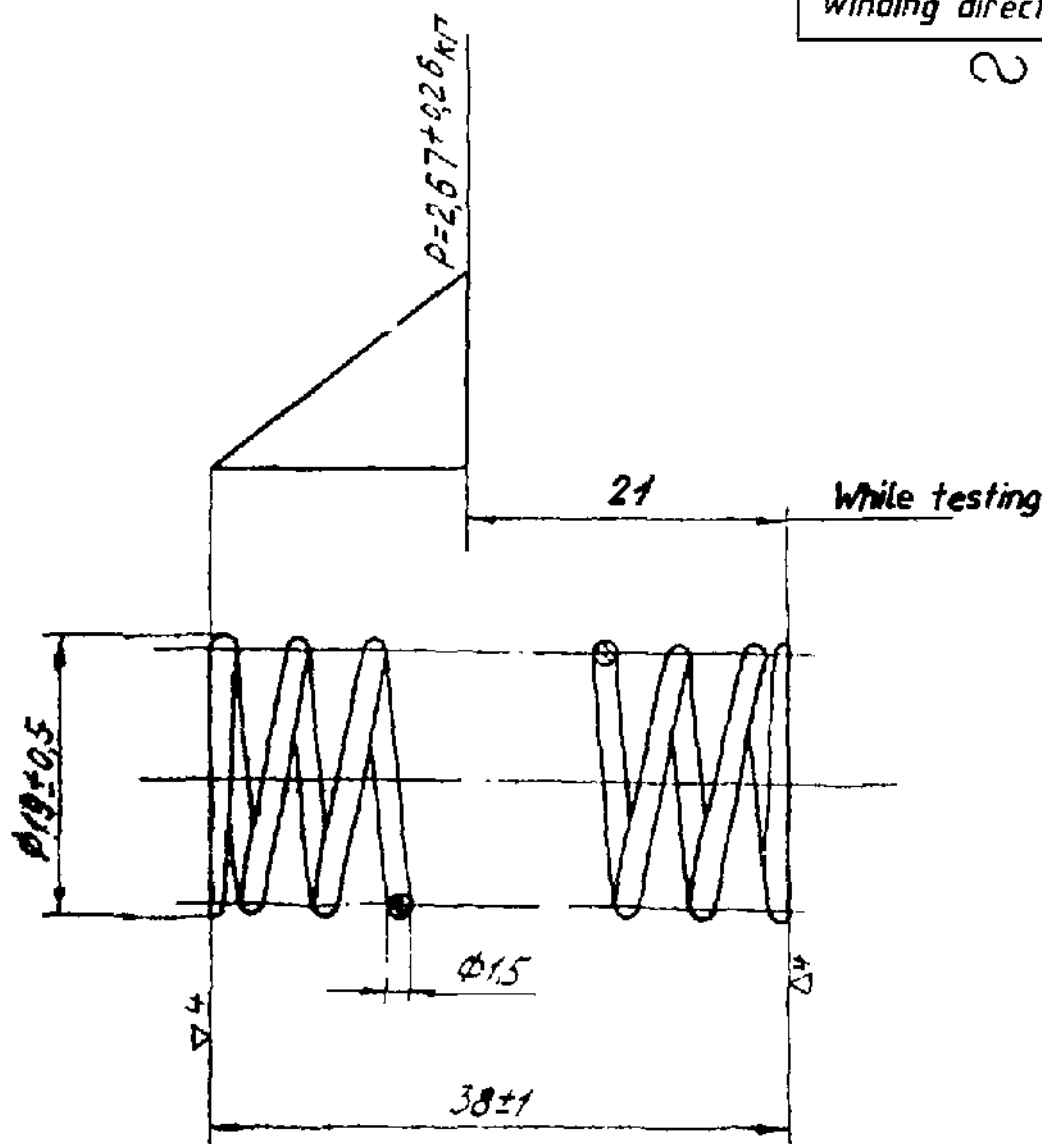
01005-ICV <i>Legislat</i> 24 OCT 05	A	EQ. MATERIAL ADDED.
DC(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED		625 329-K		
CHECKED		PISTON BARREL		WEIGHT
CONTROLLERATE OF QUALITY ASSURANCE (ICV)			0.007	2:1
	SHT 1 SHTS 1			
	20X13 GOST 5632-72			

K-232 929

Total number of turns	8 ± 0.5
Number of working turns	6
Winding direction	Arbitrary

∞ Unless otherwise specified.



TECHNICAL CONDITIONS

1. Blunt sharp edges
2. Coating: Cadmium-plated 9 to 13 micron thickness.

APPROVED

CHECKED

625 332-K

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

SPRING

STEEL 45, GOST 1050-74

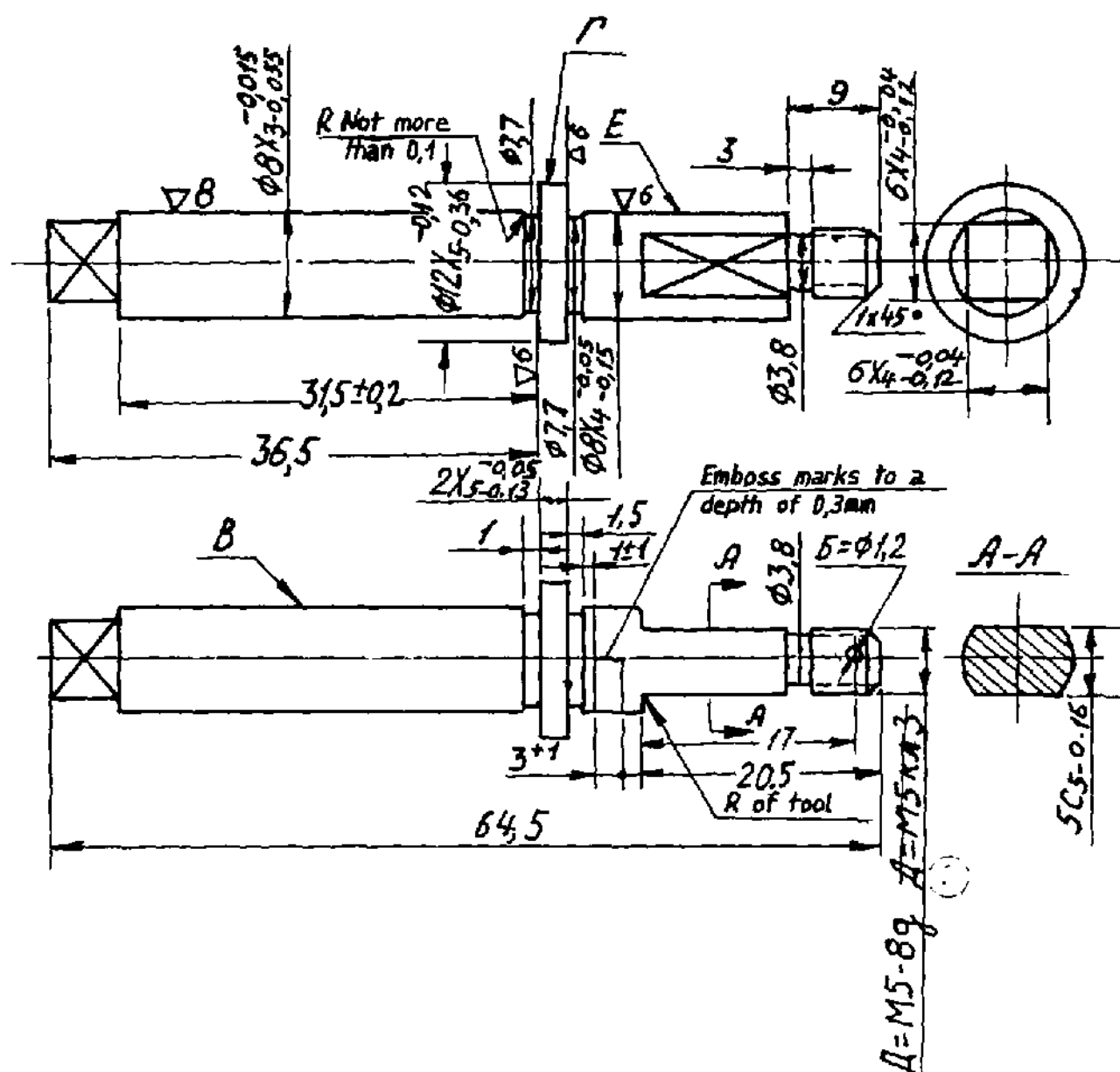
WEIGHT

SCALE

0.006

2:1

SHT 1 SHTS 1



TECHNICAL CONDITIONS

1. Blunt sharp edges.
2. Dimensions without deviations as per accuracy of class 7, OST 1010.
3. HB 285 ... 341.
4. Run out of surface Γ with respect to surface B should not exceed 0,25mm.
5. Displacement of symmetry axis of square, with respect to axis of surface B, should not exceed 0,15mm.
6. Displacement of flats with respect to axis of surface E should not exceed 0,15mm.
7. Lay out of hole B is arbitrary.
8. Non-parallelity and displacement of planes of flats with respect to planes of square, 0,3mm should be within dimensions of part.
9. Step not exceeding 0,5mm is allowed while milling the square.
10. Flats due to milling cutter are allowed on thread A.
12. Displacement of marks from true position should not exceed 5°

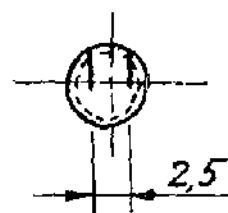
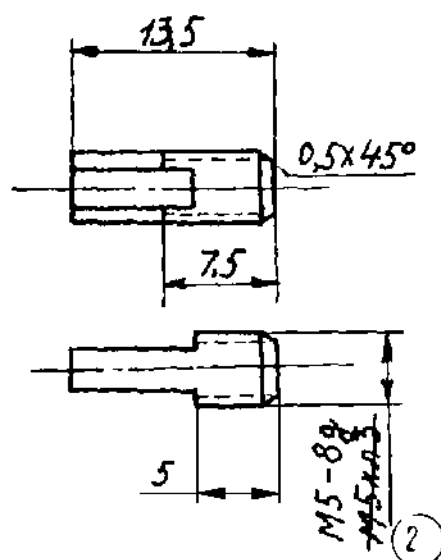
① EQ. MATERIAL:- AISI 431. (ASTM).

01005-ICV  24-10-05	Ⓐ	EQ. MATERIAL ADDED
DC(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED		625 333-K			
CHECKED	M M SL - 10.2	AXLE		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)					2:1
			SHT 1 SHTS 1		
		30X13 GOST 5632-72			

625 334-K

- (A) EQ. MATERIAL: Gde EN8 (080M40) TO BS:970-83 WITH S&P
RESTRICT TO 0.040 & 0.035 MAX. RESPECTIVELY.



1. Blunt sharp edges.
2. Dimensions without deviations should conform to accuracy of class 7, OST 1010.
3. Coating: Zinc-plated, 6micron thickness, chromitized. Remove hydrogen embrittlement.
4. Alternate material is 40 GOST 1050-74.
5. Perform heat treatment to HRC =22 to 30.
6. Displacement of symmetry axis of flats with respect to thread axis should not exceed 0,2mm.
7. Thread may be made by rolling, in this case diameter of unthreaded part should be equal to the angle diameter of thread.
Excess of metal is allowed on milled surface along thread.

01005-ICV	(A)	EQ. MATERIAL ADDED.
Signature 24-10-05		
DC(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED

CHECKED

625 334-K

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

PIN

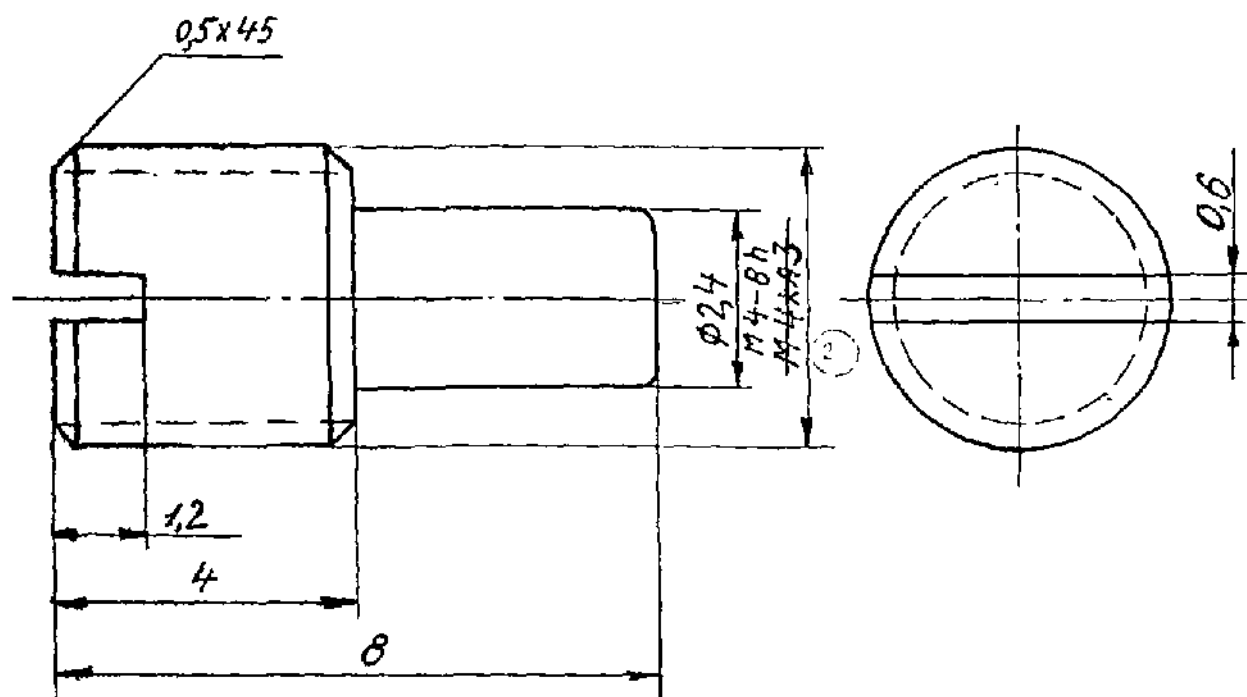
STEEL 45, GOST 1050-74

WEIGHT SCALE

0.001 2:1

SHT 1 SHTS 1

625 335-K



TECHNICAL CONDITIONS

1. Blunt sharp edges.
2. Dimensions without deviations should conform to accurac^y of class 7, OST 1010.
3. To be heat treated to HRC = 22 to 30
4. Cating: Cadmium plated 3to 6.
5. Alternate material is 40 GOST 1050-74.
6. Check dimensions before heat treatment.
7. Displacement of slot axis, with respect to thread axis should not exceed 0,2mm.

(A) EQ MATERIAL :- Gde EN8 (080M40) TO BS:970-85 WITH S & P
RESTRICT TO 0.035 MAX

01005-ICV

24-10-05

DC(I)No.

& DATE

(A)

EQ. MATERIAL ADDED.

ISSUE

AMENDMENTS

APPROVED

CHECKED

625 335-K

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

SET SCREW

STEEL 45, GOST 1050-74

WEIGHT

SCALE

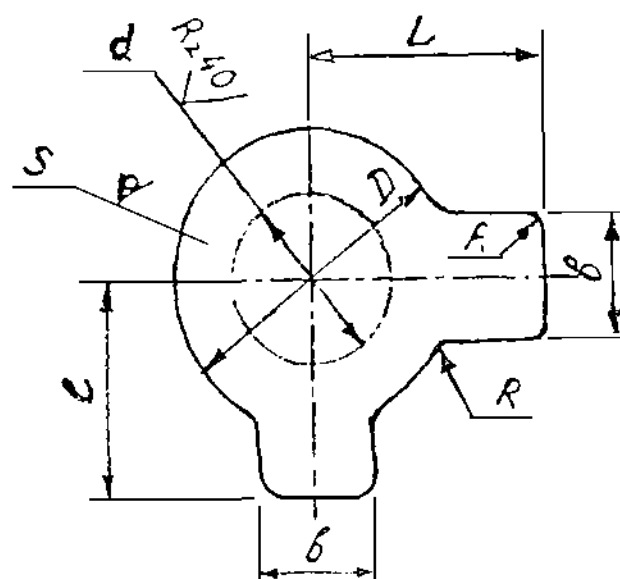
0.0002

10:1

SHT 1 SHTS 1

672-31-71

R2 320



1. Alternate material is steel 08kn 10kn, GOST 1050-74.
2. Unspecified limit deviations are ± 0.5 mm
3. Misalignment of circumference D with respect to hole d and asymmetry of tabs with respect to axis of hole d should be 1mm.
4. Coating: Zinc-plated, 9 microns thick, chromitized
Remove hydrogen embrittlement.

- (A) ALTERNATE MATERIAL - STEEL Gd2 Fe 330 TO IS: 1079-88
- (B) EQ.MATERIAL - COLD ROLLED STEEL SHEET GRADE D/DD TO IS: 4030-74
- (C) EQ.MATERIAL - STEEL GRADE - 'D' TO IS 513-86 FOR 672-31-71-02 AND 672-31-71-03.

Designation	d, MM	D, MM	L, MM	I, MM	B, MM	S, MM	R, MM	Mass in Kg
672-31-71	6.4 $^{+0.36}$	14	15	10	6	1	2	0.002
-01	8.4 $^{+0.36}$		18	12	7			0.002
-02	10.5 $^{+0.43}$	18	20	14	8	1.5		0.002
-03	13 $^{+0.43}$	22	25	20	10			0.005

00882-100	(C)	EQ.MATERIAL ADDED.
00769-100	(B)	EQ.MATERIAL ADDED
00561-100	(A)	ALTERNATE MATERIAL ADDED (1/96 NCH A)
00561-100		ADDITIONS
00561-100		TEMP. OR ETC. PERS. NO. MANUFACTURE PPS HAND & TEST CERT.
00561-100		PROD. ORG.
GOLD ROLLED STEEL SHEET Gd2 D' TO SPEC. IS: 4030-75.		
NEAREST EQVT MATERIAL		
STEEL 10 GOST 1050-74		
ORGL MATERIAL		
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF. NO SPECIFICATION		
DRG. NOT TO BE SCALED		
SCALE:-		
DATE :- 9-8-80		
TOLERANCE ON DIMENSION IS UNLESS OTHERWISE SPECIFIED		
DRG. NO. 672-31-71	WE: (Kg)	672-31-71
TCD	SEE TABLE	TAB WASHER
Ch. 100		
APD. 100		
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLE)		

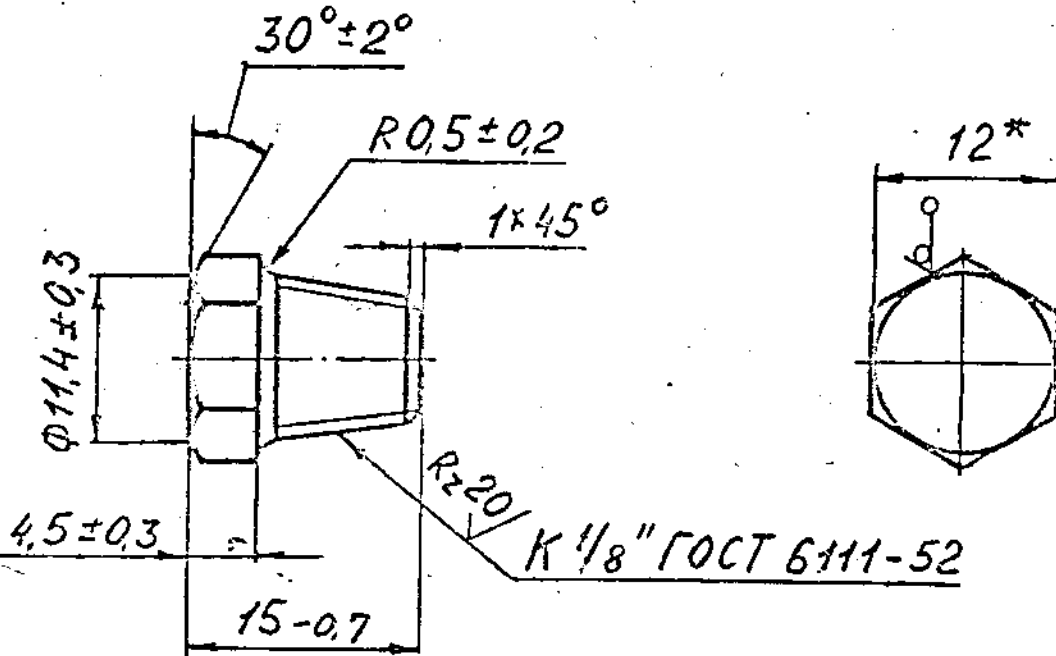
NOTE:-

1. ALL DIMENSIONS IN mm
2. PILOT SAMPLE SHOULD BE GOT APPROVED FROM AHSP
3. ASSY DRG. NEAREST EQVT. MATERIAL GIVEN IN RESPECTIVE COMPONENT DRGS.
4. OTHER TECH. CONDITIONS AS PER ORIGINAL DRG.

KVD NO. 103679

672-37-13

R.40 (✓)



1. Substitute for material - steels 25, 30, 35, 40, 45
ГОСТ 1050-74.
2. Coating: Copper plating 9 microns thick.
3. *Sizes are given for reference.

00981-ICV
25.02.05
DC(I) No.
& DATE

(A)
Issue

DS CAT No. ADDED &
NOMENCLATURE WAS
'PLUG'
NATURE OF AMENDMENTS

APPROVED

C/S

CHECKED

W/S

CONTROLLERATE
OF
INSPECTION
(ICV)

(A)

672-37-13

152 OF 492

(A)

PLUG PIPE

WEIGHT SCALE

0.0050 2:1

SH 1 818 1

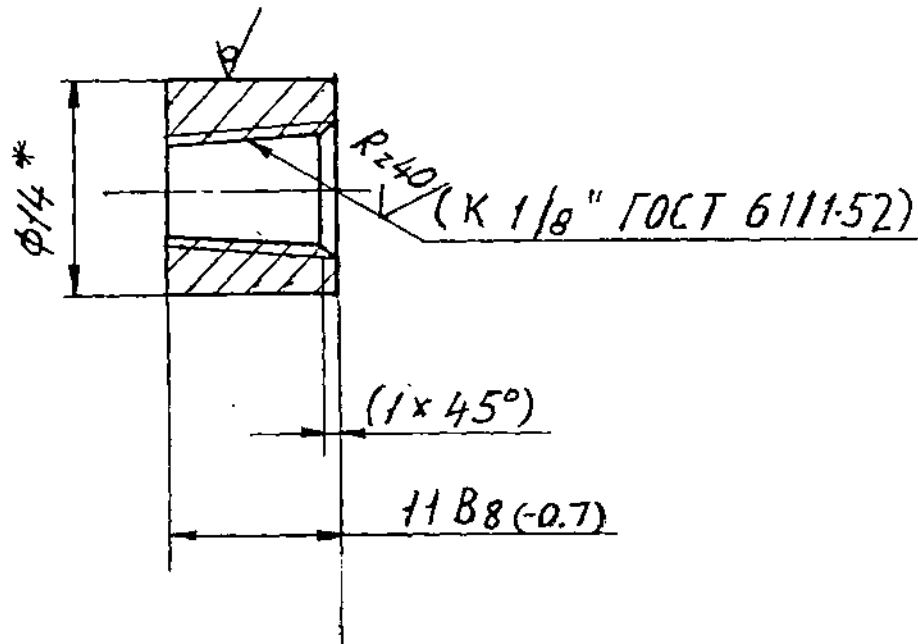
Hexahedron 12-5 GOST 6560-74
20-H-B GOST 1050-74

152 OF 154

672-51-40

Rz 80/ (✓)

DOTTO-ICV	(A)	EQ. MATERIAL ADDED
V. Ramo		
44-2000		
DATE	ISSUE	NATURE
		AMENDMENT

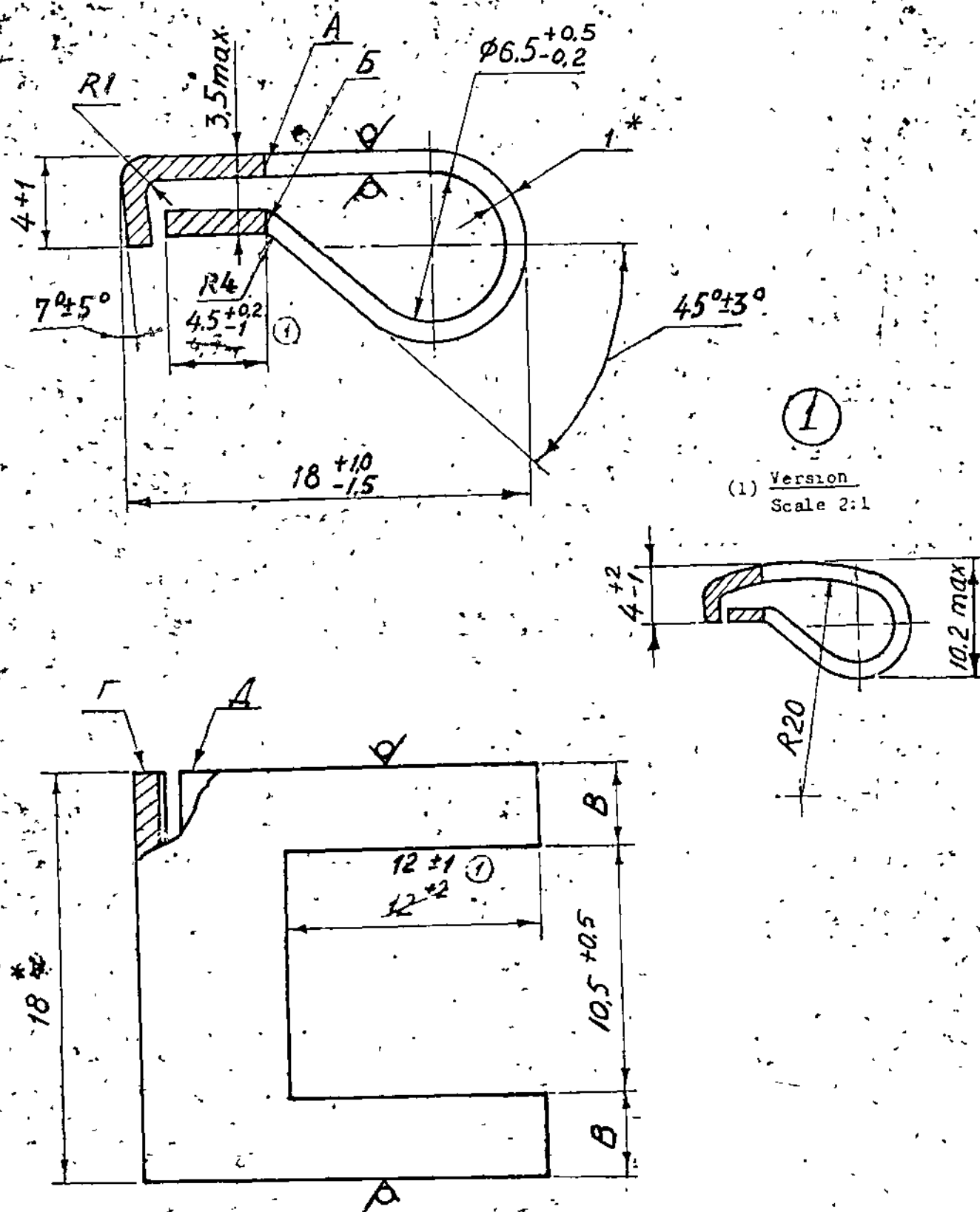


1. Alternate material is steel 15,25, GOST 1050-74.
 2. Dimensions given in brackets are after assembly.
 3. * Dimension is given for reference.
- (A) EQ. MATERIAL:- (A) - ROUND BAR. C-20 TO IS: 2073-70

APPROVED	M. VASU	672-51-40	
CHECKED	Dr. S. S. KUMAR		
CONTROLLERATE OF INSPECTION (ICV)	BOSS	WEIGHT	SCALE
		0.007	2:1
		SHT	SHTS
	round bar 14-5 ГОСТ 7417-75 20-B ГОСТ 1051-73	138 of 413	10

672-54-5

Rz 320 (✓)



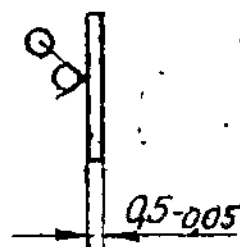
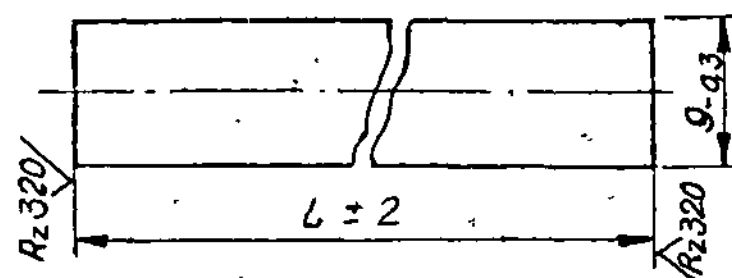
- (2) 1. Substitute material: steel 08kn, 10kn, ГОСТ 1050-74.
 2. Limit deviations of sizes are ± 0.5 mm unless otherwise specified.
 3. Displacement of surface A relative to surface B should not exceed 1.8 mm.
 4. Displacement of surface F relative to surface H should not exceed 0.7 mm.
 5. The difference 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 'O' 1/4 HARD TO IS: 513-86.
 ⑩. EQUIVALENT MATERIAL: COLD ROLLED STEEL STRIP GRADE 'D' TO IS: 4030-74.

00818-KV	⑩	EQ. MATERIAL ADDED.
N.Y. 10 2000	Cur	
00497-ICV	⑨	NOTE NO 9 FOR EQUIVALENT MATERIAL ADDED.
16-1-95	ICV	
DATE	ISSUE	NATURE
AMENDMENT		

APPROVED	672-54-5
CHECKED	
CONTROLLERATE OF INSPECTION (ICV)	
Band 10-M-2-A-1x18 ГОСТ 503-81	
FRAME	WEIGHT SCALE
	0.004 11
SHT	SHTS
	248

9-75-029



(1)

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			

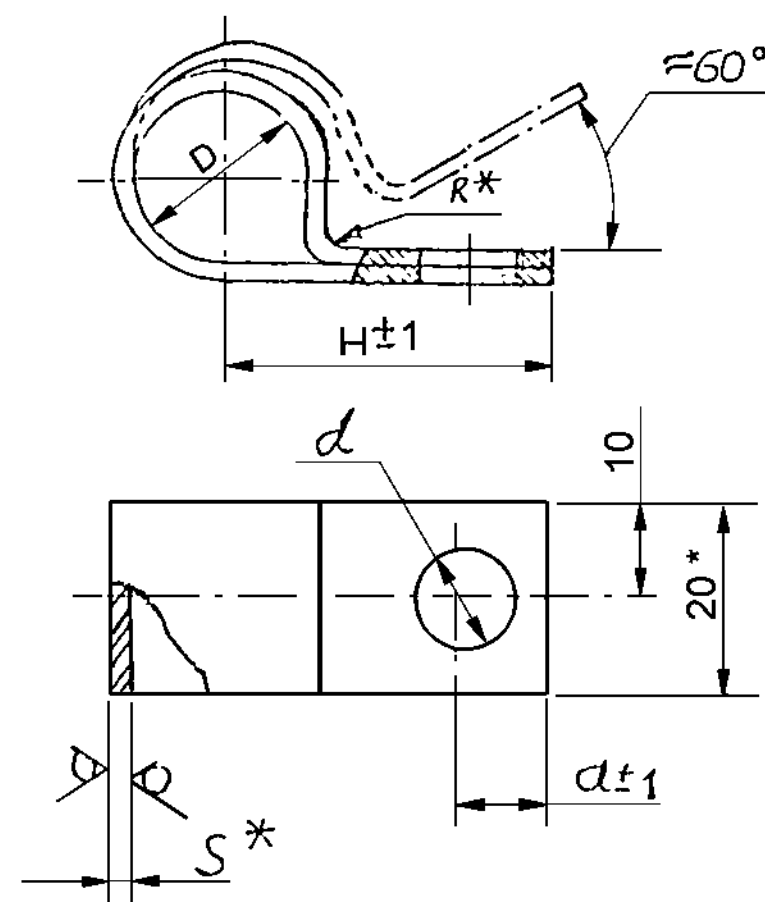
- (2) 1. Substitute material: steel 08kn, 10kn, ГОСТ 1050-74.
 2. Coating: zinc plating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness.
 3. The rest of the technical requirements are according to ГОСТ 503-81.
 (A) 4. EQUIVALENT MATERIAL: COLD ROLLED CARBON STEEL 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-ICV 03-10-2000	(B)	EQ MATERIAL ADDED
00 497-ICV 15-1-95	(A)	NOTE NO 4 FOR EQUIVALENT MATERIAL ADDED
DEC 11 NO 8 DATE	ISSUE	NATURE
AMENDMENT		

APPROVED		672-54-6	
CHECKED		BAND	
CONTROLLERATE OF INSPECTION (ICV)		WEIGHT SCALE	
		SEE TABLE	2:1
		SHT	SHTS
		BAND 10-M-2-A-0.5x9 ГОСТ 503-81	
		140 d 413	

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						0,5		0,003
-04			9					
© (E) -05			7			0,8		0,008
-06	8	7,5	9					
-07			7					
-08			9	25	8	0,5		0,005
-09			7			0,8		0,008
-10	10	9,5	9			0,5	2	0,005
-11			7			0,8		0,009
-12			9			0,5		0,007
-13	12	11,5	7					
-14			9			0,8		0,016
© -15			7					
DS CAT PART No. LV2/ICVs5340-017034 -16	15	14	9	41	11	0,8		0,014
-17			13			1,5		0,026
-18			7					0,010
-19	18	17	9					
-20				30				0,011
-21	20	19						0,013
-22	24	23				0,8		
DS CAT PART No. LV2/ICVs5340-017033 -23	27	26			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.
- Ⓑ EQ. MATERIAL:- Cold rolled steel strip Gr 'D' or 'DD' To IS: 4030-74.
- Ⓒ EQ. MATERIAL:- Cold rolled steel strip Grade 'D' killed steel To IS:- 4030-73 For 672-54-9-05 and 672-54-9-15.
- Ⓔ EQ. MATERIAL:- Gde 'D' To IS: 513-94 (For 672-54-9-05).

01005-121	Ⓔ	EQ. MATERIAL ADDED.
24-10-85	Ⓓ	DS CAT PART No. ADDED.
01002121	Ⓒ	EQ. MATERIAL ADDED.
06-08-85	Ⓒ	EQ. MATERIAL ADDED.
00818	Ⓒ	EQ. MATERIAL ADDED.
11-10-2000	Ⓒ	EQ. MATERIAL ADDED.
00717-15	Ⓒ	EQ. MATERIAL ADDED.
12-9-99	Ⓒ	EQ. MATERIAL ADDED.
0063-15	Ⓒ	EQ. MATERIAL ADDED.
01-6-30	Ⓒ	EQ. MATERIAL ADDED.
DC(1)No. & DATE	ISSUE	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.

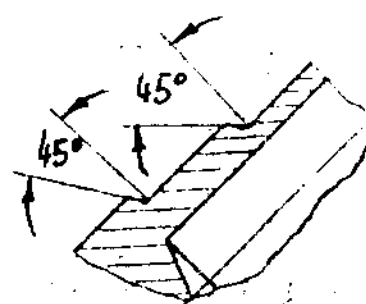
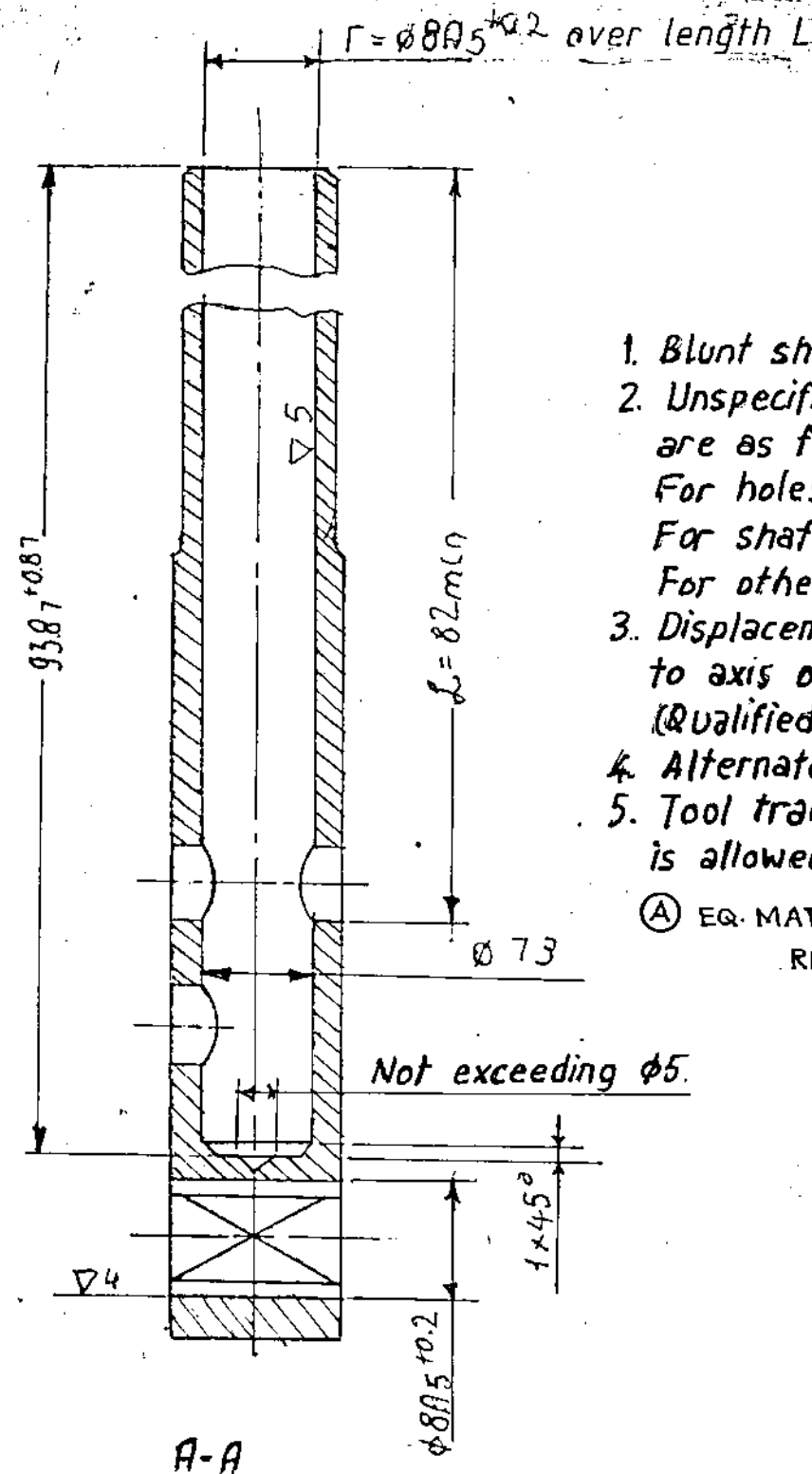
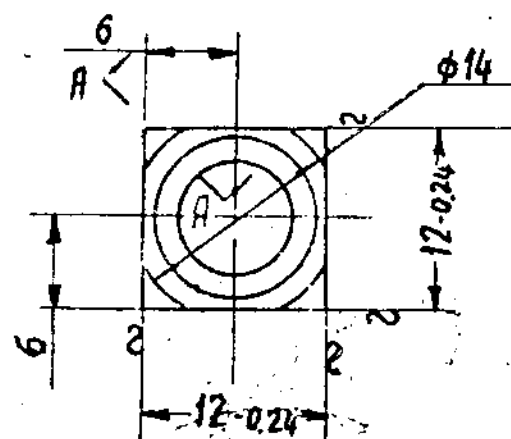
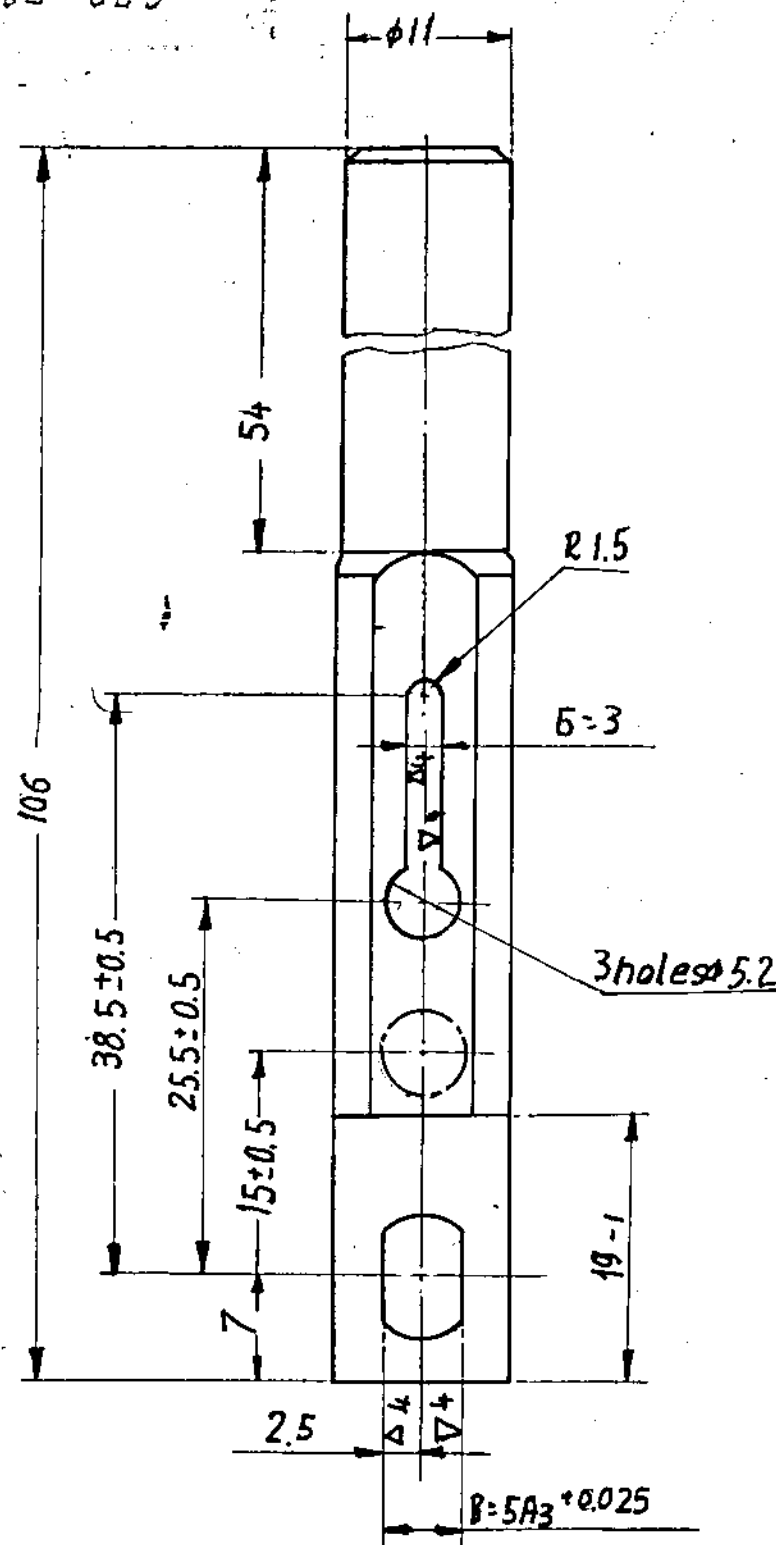
USED ON:
675-05-Sb2

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.



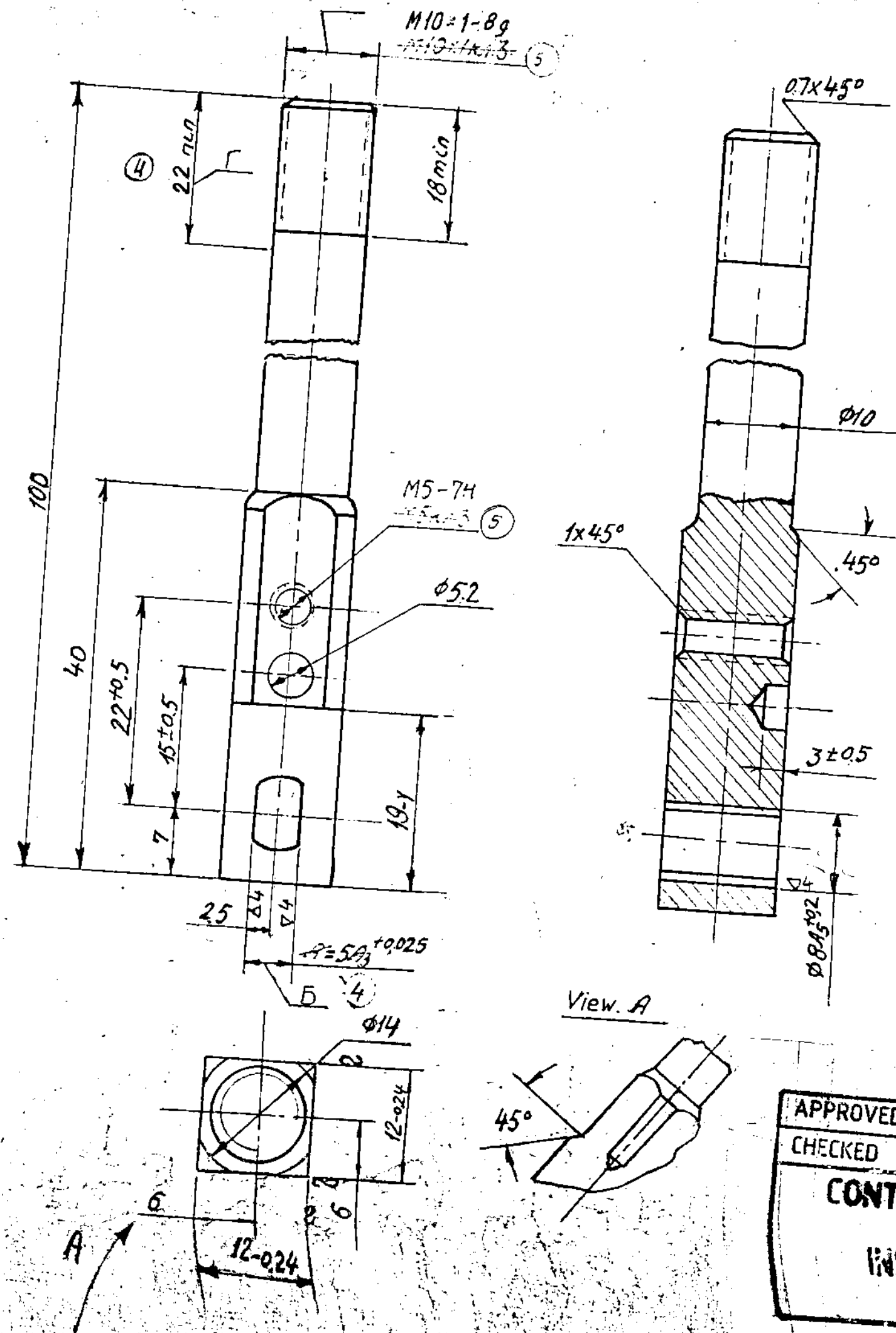
1. Blunt sharp edges.
2. Unspecified limit deviations of dimensions are as follows:
For holes - as per A₇;
For shafts - as per B₇;
For others - ±1/2 of tolerance, class 8.
3. Displacement of symmetry axis of slot B with respect to axis of hole Γ should not exceed 0.2mm. (Qualified tolerance).
4. Alternate material is 35, 40 GOST 1050-74.
5. Tool trace not exceeding 0.3mm along axis is allowed on planes of hole B.

Ⓐ EQ. MATERIAL:- Gde EN8 (080M40) TO BS:970-83 WITH S & P
RESTRICT TO 0.040 & 0.035 MAX. RESPECTIVELY.

01005 ICV 24 OCT 05 DC (I) NO. & DATE	Ⓐ	EQ. MATERIAL ADDED
	ISSUE	AMENDMENTS

66/11

APPROVED	M. VASU	672-78-16	
CHECKED	L. Skumar	HANDLE	
CONTROLLERATE OF INSPECTION (ICV)		WEIGHT	SCALE
		0.15	2:1
Squatche		SHT	SHTS
12.5 TOCT 8559-75 45-B TOCT 1051-73		156	70



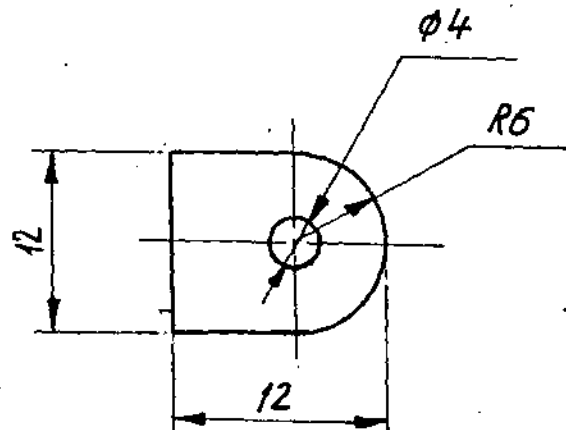
▽3 Unless otherwise specified.

1. Blunt sharp edges.
 2. Unspecified limit deviations of dimensions are as follows:
For holes - as per A₇;
For shafts - as per B₇;
For others - $\pm 1/2$ tolerance, class 8.
 3. Alternate material is 35, 40 GOST 1050-74.
 4. Tool traces not exceeding 0.3mm are allowed on planes of holes B, along axis.
 5. Thread B may be made by rolling, in this case diameter of unthreaded part on dimension f should be equal to mean diameter of thread.
- Ⓐ EQ. MATERIAL:- Gde EN8 (080M40) TO BS:970-83 WITH S & P RESTRICT TO 0.040 & 0.035 MAX. RESPECTIVELY.

01005 10X	Ⓐ	EQ. MATERIAL ADDED
29 SET OF	ISSUE	AMENDMENTS
DC (1) No		
& DATE		

APPROVED	M. VASU	672-78-17		67/1
CHECKED	Z. S. K. V. M.			
CONTROLLERATE OF INSPECTION (ICV)		HANDLE		
Square		12.5 GOST 8559-75	WEIGHT	SCALE
		45 B GOST 1051-73	0.170	2:1
			SHT	SHTS
			157	78

81-94-219

Thickness 2.5 ± 0.17 .

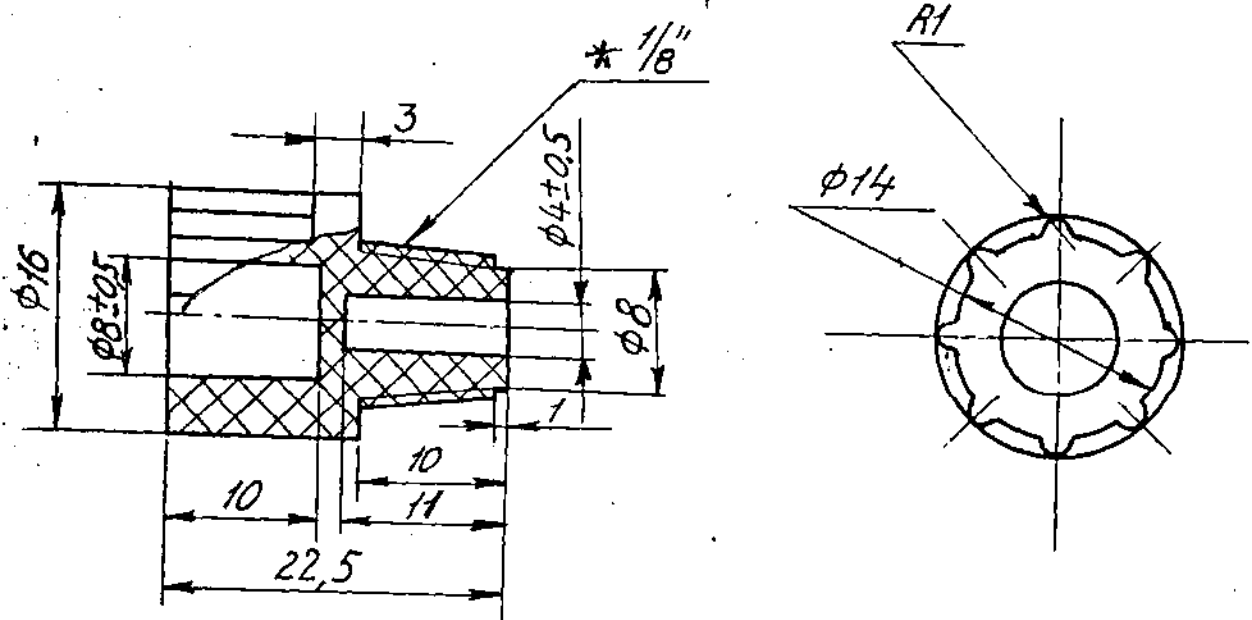
1. Blunt sharp edges.
 2. Dimensions without deviations should conform to accuracy of ± 0.5 .
 3. Alternate material is steel 3 cn GOST 380-71.
- (A) EQ. MATERIAL:- Gde 'D' TO IS: 513-94.

01005 ICV <i>[Signature]</i> 24 OCT 08 DC (I) NO. & DATE	(A)	EQ. MATERIAL ADDED
ISSUE		AMENDMENTS

APPROVED	<i>H. VASU</i>	672-78-18		68/	
CHECKED	<i>H. M. S. L. M.</i>	LUG		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)		10 GOST 1050-74		0.0025	2:1
				SHT	SHTS
				173	78

18-84-749

75

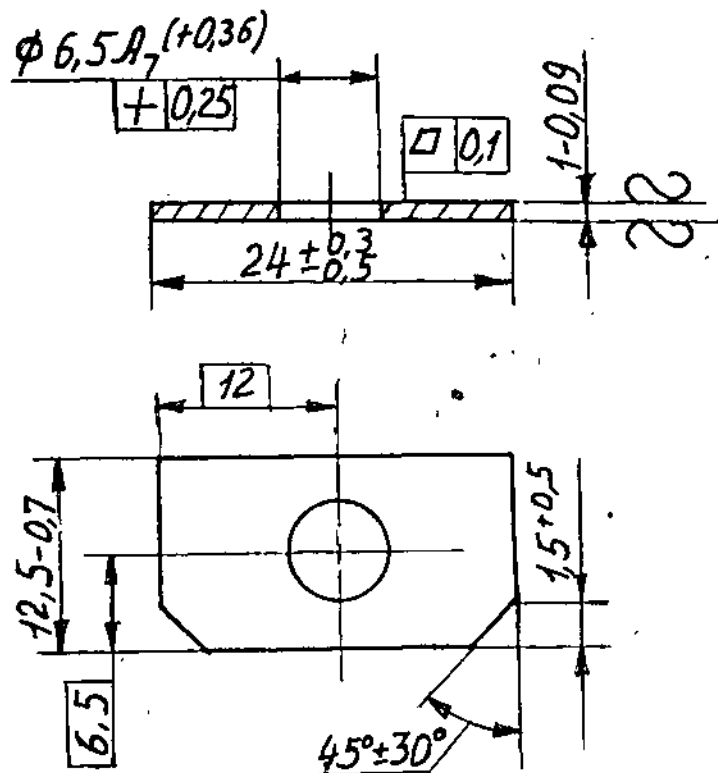


1. Shrinkage cavities, cavities, cold joint and short runs are not allowed.
2. Unspecified limit deviations of dimensions are as follows:
For holes - as per A₇; For shafts - as per B₇;
For others - $\pm 1/2$ of tolerance, class 8.
3. Unspecified radii should not exceed 2mm.
4. Drafts should not exceed 2°.
5. Fin along the parting lines of mould should not exceed 0,3 mm
6. Plug may be made from polyethylene of different colours, grades and secondary polyethylene.
7. Foreign inclusions and hue are allowed.
8. Dimensions except for specified tolerance and threads K 1/8" -are for tool.

APPROVED	M VASU	672-78-81	
CHECKED	<i>Shwagender</i>		
CONTROLLERATE OF INSPECTION (ICV)		PLUG	
		POLYTHYLENE 21006-075 GRADE I GOCT 16338-77	
		WEIGHT 0.003	SCALE 2:1
		SHT	SHTS

672-78-99

(Δ) A



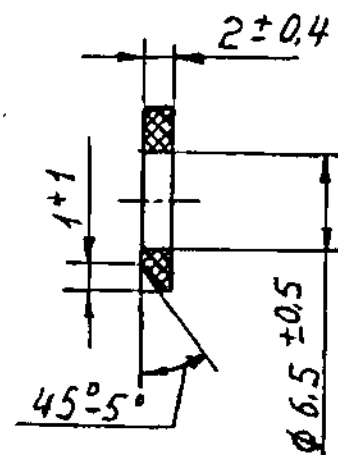
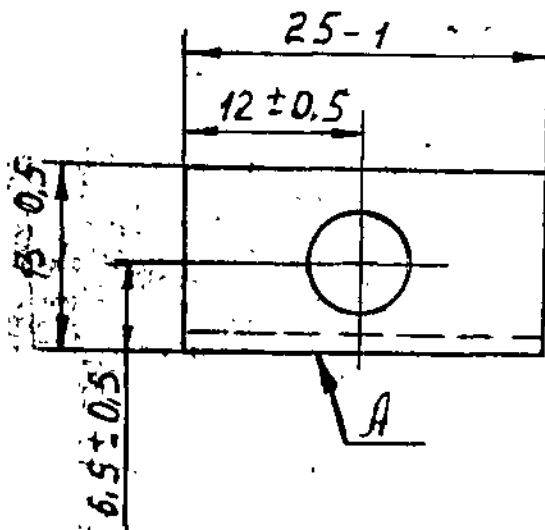
01005 ICV	EQ. MATERIAL ADDED	AMENDMENTS
188mm	(A)	ISSUE
24 OCT 05		
DCU NO. & DATE		

1. Alternate material is steel 08KП ГОСТ 1050-74.
2. Coating: Zinc-plated, 15 micron thickness, chromitized.

(A) EQ. MATERIAL :- Gde 'D' TO IS: 513-94.

APPROVED	<i>M VASU</i>	672-78-99	
CHECKED	<i>S. N. Gendun</i>		
CONTROLLERATE OF INSPECTION (ICV)		STRIP	
		STEEL 10	
		ГОСТ 1050-74	
		WEIGHT	SCALE
		0.002	2:1
		SHT 1	SHTS 1
		167	

001 - 81 - 219

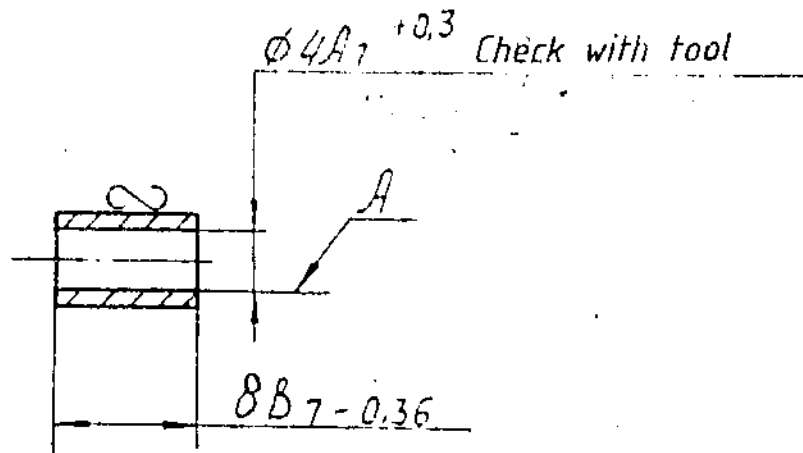


1. Cuts are not allowed.
2. Other requirements are as per Technical specifications TY 005216-75 for articles. code 254311.
3. Sharp edge is allowed on surface A.

APPROVED	M VASU	672 - 78 - 100	
CHECKED	B. N. Gendru		
CONTROLLERATE OF INSPECTION (ICV)		PACKING	
		PLATE 254311-2 TECHNICAL RUBBER 1847 SPECIFICATIONS: Y005216-75	
		WEIGHT	SCALE
		0.0008	2:1
		SHT	SHTS

672-78-101

▽3 (▽)

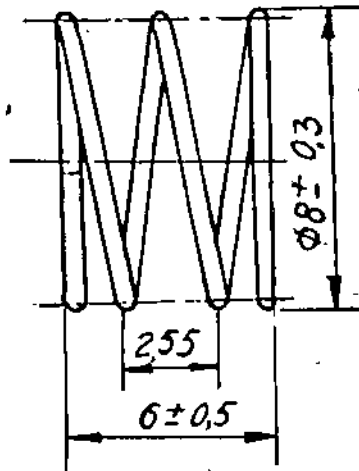


1. Alternate material is steel 15, 20, 25, ГОСТ 1050-74.
2. Coating: Zinc-plated, 15 micron thickness, chromated.
3. Dark spots are allowed on surface A.

APPROVED	M. VASU	672-78-101	
CHECKED	<i>Per Vagendran</i>		
CONTROLLERATE OF INSPECTION (IC V)		BUSHING	
		PIPE 6X1 ГОСТ 8734-75 B10 ГОСТ 8733-74	
		WEIGHT	SCALE
		0.001	2:1
		SHT	SHTS

672-78-102

9 (7)



1. Coating: Chemically parkerized, accelerated, chromated, oiled with preservative oil K17 GOST 10877-76 as per instructions 053.25289.00002.
2. Winding direction is arbitrary.
3. Total length of the spring is 100mm
4. Number of working turns - 2
5. Total number of turns 4 ± 0.5 .
6. *Dimension is given for reference

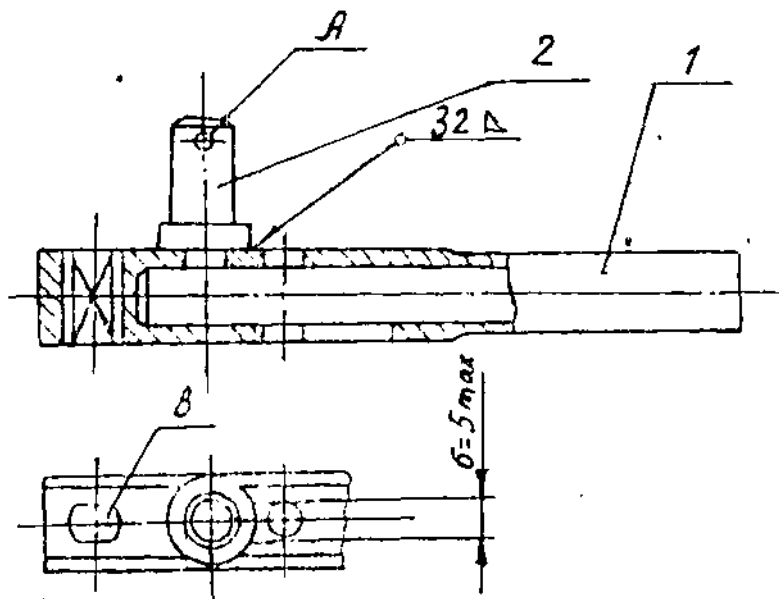
(A) EQ. MATERIAL: SPRING STEEL Gde 3 TO IS: 4454-81.

01005 ICN 19 OCT 85 DC(1) NO. & DATE	(A)	EQ. MATERIAL ADDED
ISSUE		AMENDMENTS

APPROVED	<i>[Signature]</i> H VASU	672-78-102	
CHECKED	<i>[Signature]</i>	SPRING	
CONTROLLERATE OF INSPECTION (IC V)		WIRE II - 0 4 ГОСТ 9389-75	159

-78-

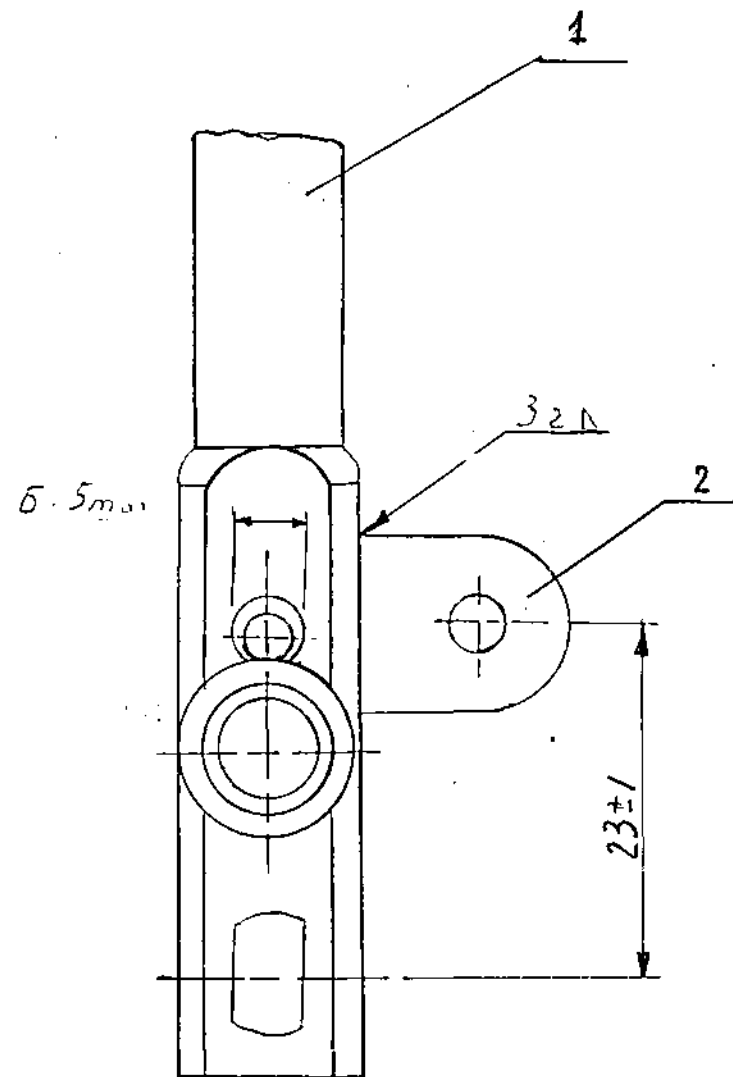
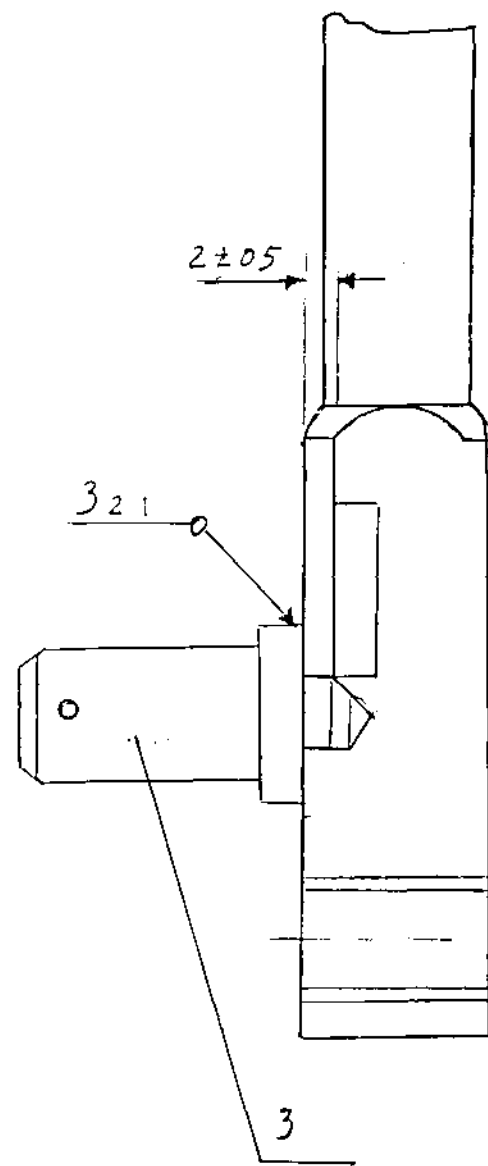
7



1. Do not weld on section B.
2. Coating : Zinc-plated, 24 micron thickness.chromatized
Remove hydrogen embrittlement. Internal surfaces and
welds may not be coated
3. Lay out of hole A is arbitrary.
4. Presence of welding splashes in hole B is not allowed
5. Non-squareness of axis of part Ref.No.2 with respect
to locating surface should not exceed 1mm over length 20mm
6. Check the hole B with plug gauge for dimensions $\phi 7.93 \times 5.00$.

			0991-10V <i>[Signature]</i> 25.02.05	(A)	DS CAT NO. ADDED & NOMENCLATURE WAS “HANDLE”
			DC(I) No. & DATE	ISSUE	NATURE OF AMENDMENTS
2	700-47-288	SHAFT		1.	
1	672-78-16	Handle		1	
EFFECTIVE DATE	Description	Description			

APPRD	M. VASU	DS CAT No. LV2/ICVS 2540-002843		
CHECKED	H. M. Sherson	672-78-CD104		
CONTROLLERATE Or INSPECTION (ICV)		① LEVER RELEASE HANDLE	WEIGHT	SCALE
			0.165	1:1
			SHT SHTS	

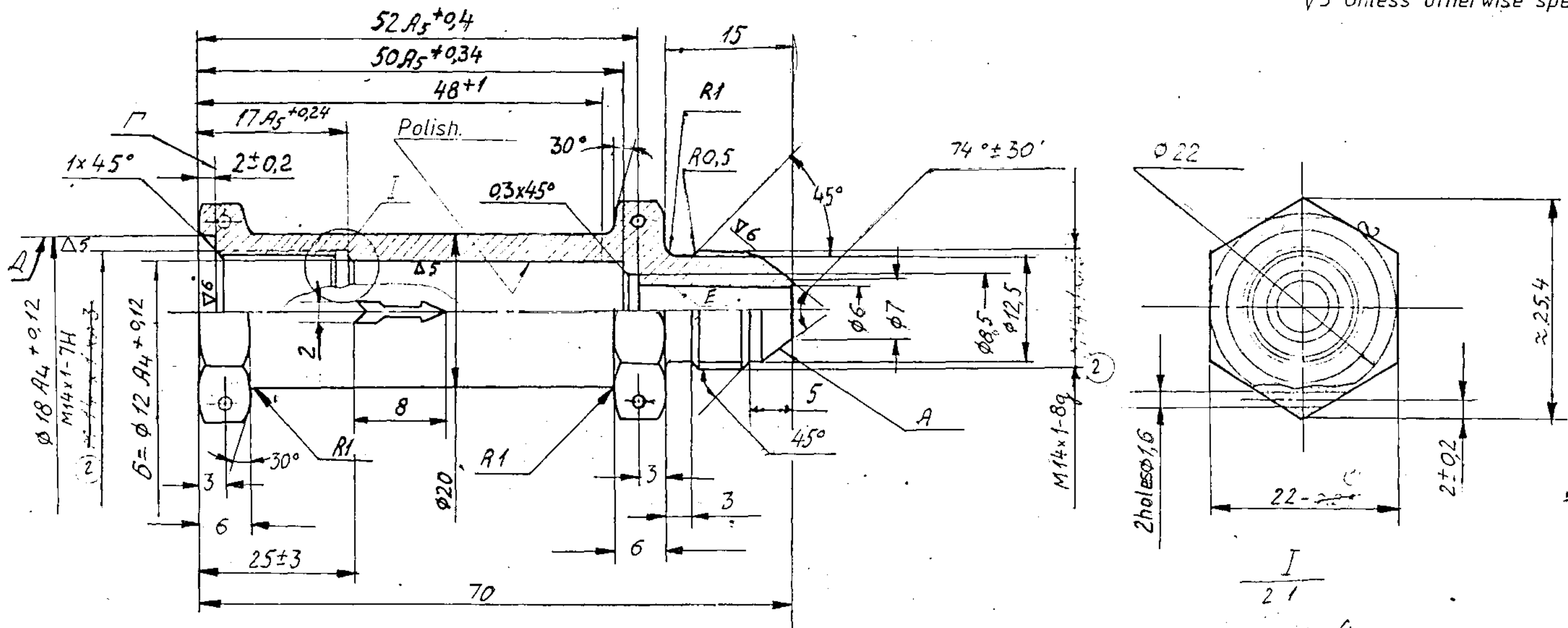


1. Do not weld on section B.
2. Coating Zinc-plated, 24 micron thickness chromadized. Remove hydrogen embrittlement. Internal surfaces and weld may not be coated.
3. Lay-out of hole A is arbitrary.
4. Presence of welding splashes in hole B and on thread is not allowed.
5. Non squareness of axis of part, Ref.No.3 and part, Ref.No.2 should not exceed 1mm with in over all dimensions of parts.
6. Check hole B with plug gauge for dimensions $\phi 7.98 \times 5.00 \text{mm}$.

3	700-47-288.	Shaft	1
2	672-78-18.	Lug	1
1	672-78-17.	Handle	1
REF NOS.	Designation	Descr	Qty

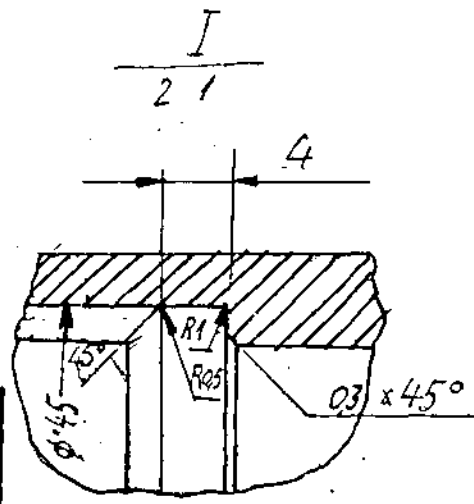
APPROVED	M. VASU	672 78 CB105		
CHECKED	H. A. J. - 100			
CONTROLLERATE OF INSPECTION (ICV)		HANDLE	WEIGHT	SCALE
			0.186	2:1
			SHT	SHTS

✓3 Unless otherwise specified



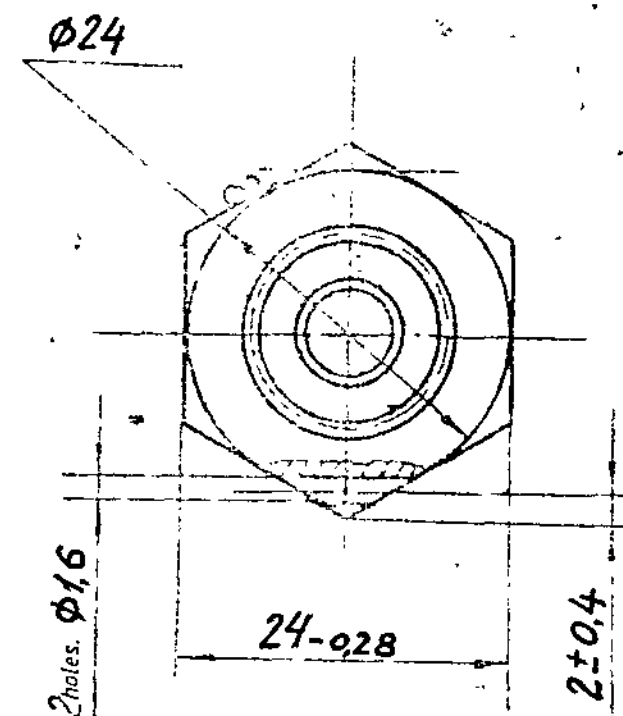
1. Eccentricity of internal thread with respect to $\phi 5$ should not exceed 0.02mm (qualified tolerance).
 2. Dimensions without deviations should conform to accuracy of class 7, OST 1010.
 3. Coating: Anodic oxidation chromatised
 4. Blunt sharp edges.
 5. Run out of surface A with respect to mean diameter of thread should not exceed 0.05mm. (qualified tolerance)
 6. Depression of arrow should not exceed 0.5mm.
 7. Hold dimension B over length 48⁺
 8. Play of butt end Γ and axis of surface Π with respect to angle diameter of thread should not exceed 0.05mm.
 9. Step not exceeding 0.3mm is allowed on surface E to distance of at least 5mm from butt-end from side of surface A, may be present on surface E.
- Ⓐ EQ.MATERIAL- ROUND BER GRADE-24534 TO IS: 733-83.

00836-120	Ⓐ	EQ.MATERIAL ADDED IN THE DRAWING.
10/11/2000	Cur	
DCI No.	ISSUE	NATURE OF AMENDMENTS
DATE		



DS CAT PART NO. ADDED, & NOMENCLATURE VALVE BODY BODY	NATURE OF AMENDMENT
Ⓑ	ISSUE
00992-10V	DATE
30 MAR 05	

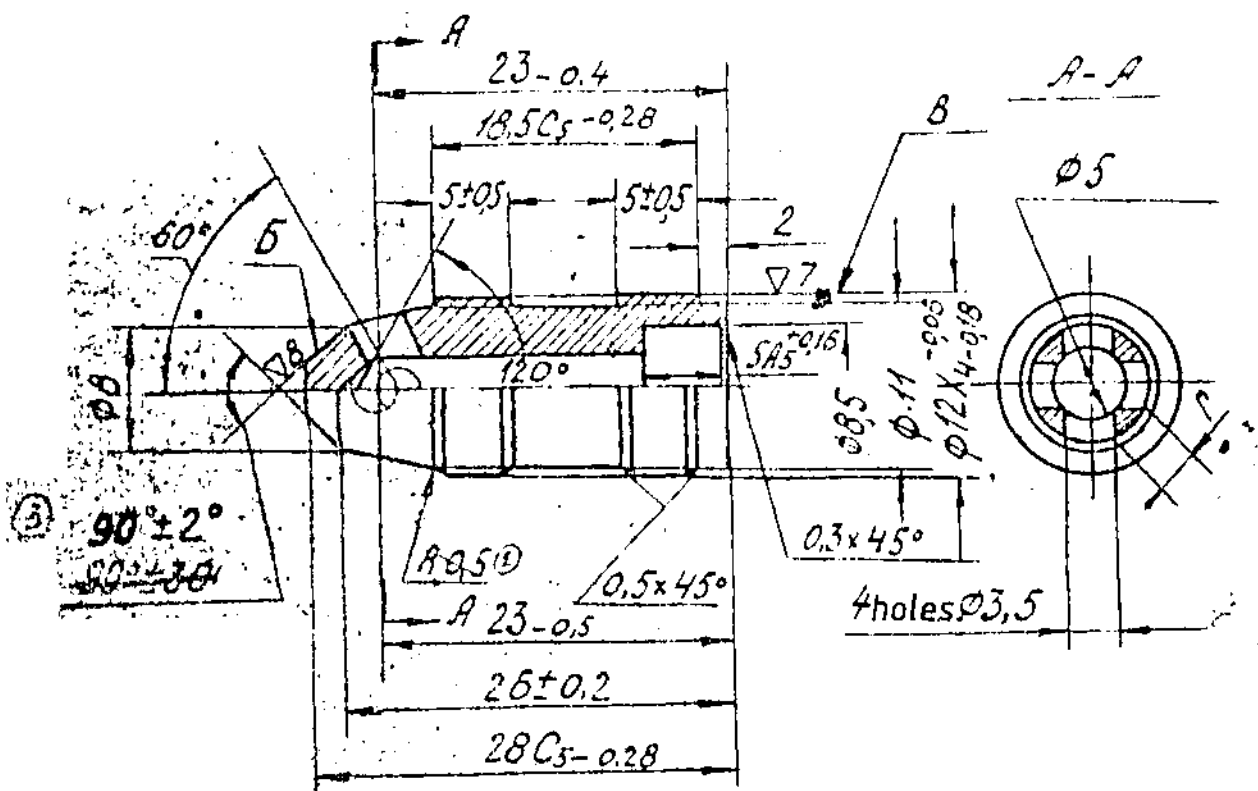
APPROVED	M.V.	674 601/B-K	DS CAT PART NO. Ⓑ
CHECKED	SKUMAR		LV2/ICVS2530-004830
CONTROLLERATE OF INSPECTION (ICV)	VALVE BODY	Ⓑ BODY	WEIGHT SCALE
			0.03 2:1
			SHT SHTS
			86 OF 154 78
		11T 11 22 11 Round 76Bar Ⓐ	
		ГОСТ 21488	



1. Blunt sharp edges except for edge A.
2. Perform surfaces $\Lambda, \Gamma, K, \Delta$, and thread B, in one setting (in this case run-out of surfaces Γ, K, Λ and Δ with respect to thread should not exceed 0,04mm).
3. Step not exceeding 0,3mm is allowed on surface E, outside of section B.
4. Dimensions, without deviations should conform to accuracy of class 7, OST 1010.
5. HB=137 to 196 ($\phi 5.1$ to 4,3).
6. Hold dimension K.
7. Run-out of surface X with respect to mean diameter of thread should not exceed 0,05mm.

APPROVED	M. VASU	674 602/B-K		87 OF 492	
CHECKED	D. S. KUMAR	UNION		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)				0.042	2:1
		20X13 OCT 5632-72		SHT	SHTS
				87 OF 154	78

▽. Unless
otherwise
specified.



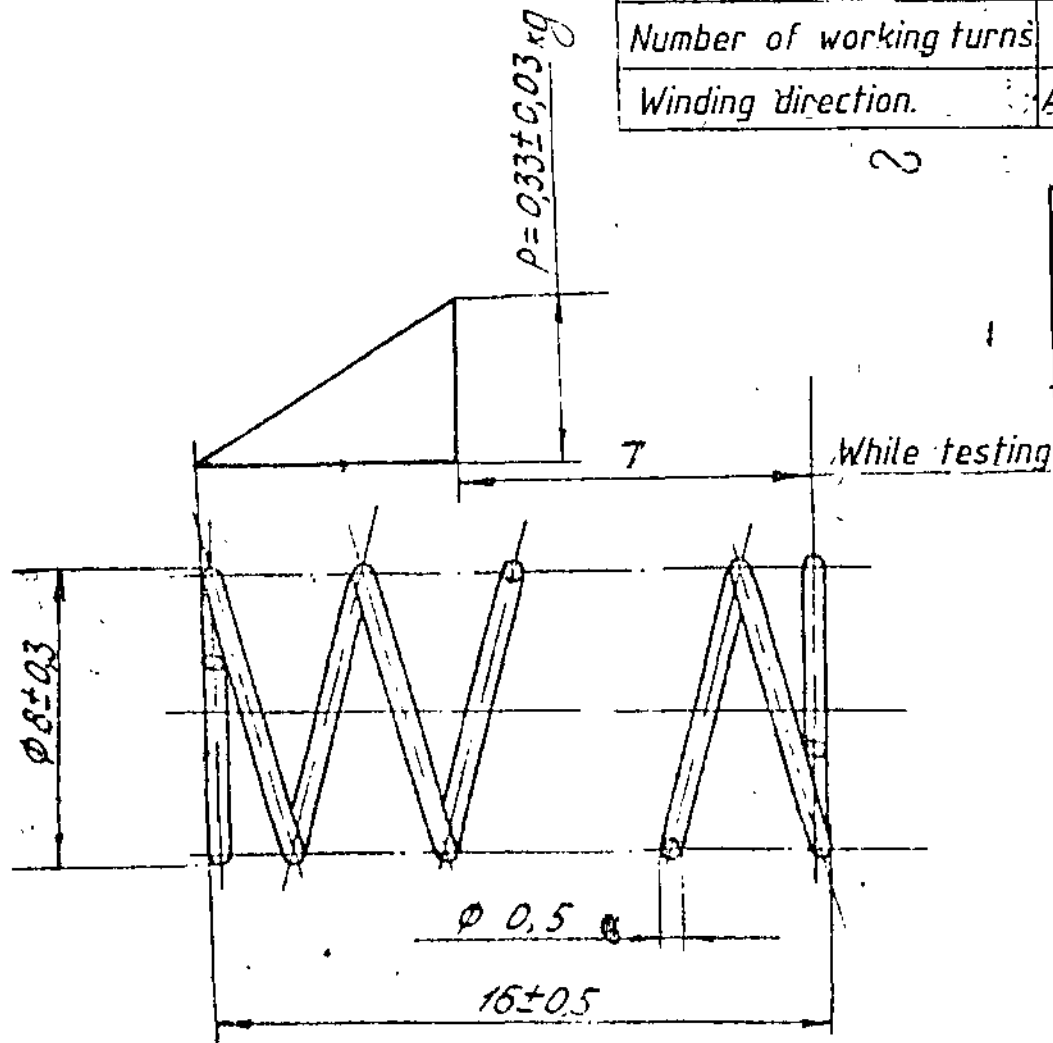
1. Blunt sharp edges.
2. Dimensions without deviations should conform to accuracy of class 7, OST 1010.
3. HRC 38 to 40.
4. Run-out of taper B, with respect to surface B should not exceed 0.005mm.
5. Difference in measurements of dimension F should not exceed 0.5mm.

00992-1CV 3.0mm 3.0mm DATE	DS CAT NO. ADDED & NOMENCLATURE "VALVE HEAD" WAS "VALVE"
ISSUE	NATURE OF AMENDMENT

APPROVED	M. V. A. E. U.	674603/Б-К		DS CAT PART NO. (A) LV2/ICV54820-004248	
CHECKED	20. SKUMAR	(A) VALVE HEAD		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)		30X13 ГОСТ 5632-72		0-0128	2:1
				SHT	SHTS
				88 OF 154	78

Y-9/4094L9

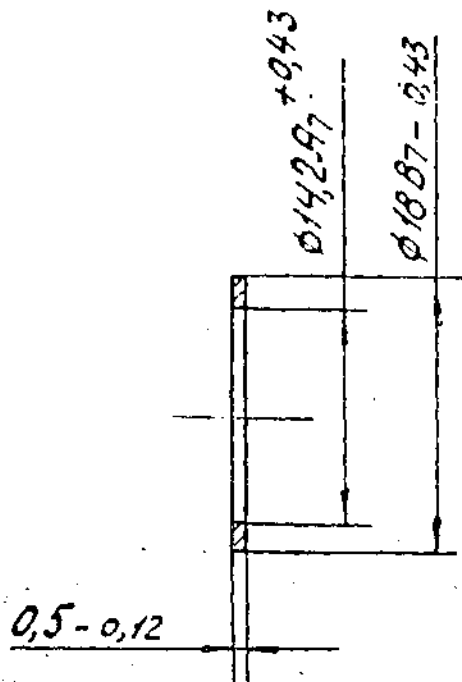
Total number of turns.	7±35
Number of working turns	4
Winding direction.	Arbitrary



STEEL WIRE GRADE 3 TO IS: 4454-75 (PART-I)	NATURE
ADDED AS EQ. MATERIAL	AMENDMENT
100802-15X	ISSUE
15-02-2000	DATE

1. Squeeze ends of non-working turns to adjacent working turns and grind throughly.
 2. Blunt sharp edges.
 3. Coating: Cadmium plated, 12 micron thickness.
- (A) EQ. MATERIAL :- STEEL WIRE GRADE 3 TO IS: 4454-75 (PART-I)

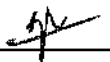
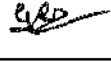
APPROVED	M VASU	674604/E-K 89 OF 492	
CHECKED	D.S. KUMAR	SPRING	
CONTROLLERATE OF INSPECTION (ICV)		WIRE II - 0.5	89 OF 154 78
		IS: 9389-75	
		WEIGHT	SCALE
		0.0003	5:1
		SHT	SHTS



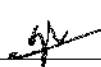
1. Blunt sharp edges.

APPROVED	M. VASU	674605/B-K	
CHECKED	<i>[Signature]</i> D. S. KUMAR		
CONTROLLERATE OF INSPECTION (IC V)		WASHER	
		Sheet AP 1M - 0.5 FOCT 21631-76	
		WEIGHT	SCALE
		0.0001	2:1
		SHT	SHTS

Designation	Description	Parent unit		Total qty	Remarks
		designation	qty		
675-78-c62	Interlock pneumatic drive				
675-78-c62 H4	Pneumatic connection diagram	675-78-c62			
675-78-c6103	Pipe	675-78-c62	1	1	
675-78-c6103-01	Pipe	675-78-c62	1	1	
672-78-c6104	Handle	625300M-K	1	1	
672-78-c6105	Handle	625300M-K1	1	1	DCU 00348/ICV
765-78-c6328	Pipe	675-78-c62	1	1	
765-78-c6329	Pipe	675-78-c62	1	1	
765-78-c6602	Pipe	675-78-c62	1	1	
675-78-c6103-02	Pipe	675-78-c62	1	1	
675-78-c6103-03	Pipe	675-78-c62	1	1	
765-78-c6615	Pipe	675-78-c62	1	1	
765-78-c6623	Pipe	675-78-c62	1	1	
765-78-c6648	Pipe	675-78-c62	1	1	
765-78-c6649	Pipe	675-78-c62	1	1	
765-78-c6668	Pipe	675-78-c62	1	1	
765-78-c6669	Pipe	675-78-c62	1	1	
765-78-c6712	Retainer	625300M-K	1	1	
765-78-c6717 or 765-78-c6717-K	{Clamp, PL No. LV2/RCV LOOP 5340-010316	675-78-c62	1	1	
765-78-c6718	DC(I) No 00358-ICV Rod	675-78-c62	1	1	
765-78-c6722 or 765-78-c6722-K	{Clamp, PL No. LV2/RCV LOOP 5340-009659	675-78-c62	1	1	
765-78-c6794	DC(I) No 00358-ICV Cylinder	675-78-c62	2	2	
765-78-c6795	Cylinder	765-78-c6794	1	2	
765-78-c6816	Pipe	675-78-c62	1	1	
765-78-c6816-01	Pipe	675-78-c62	1	1	

APPROVED		675-78-cn2			
CHECKED					
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		INTER LOCK PNEUMATIC DRIVE		WEIGHT	SCALE
				SHT 1	SHTS 13

Designation	Description	Parent unit		Total qty	Remarks
		designation	qty		
765-78-c6831-02	Pipe	675-78-c62	1	1	FOR DETAILS REFER ASSY. DRG. D C (1) No. 00555-1CV
765-78-c6831-03	Pipe	675-78-c62	1	1	
765-78-c6831-04	Pipe	675-78-c62	1	1	
765-78-c6831-05	Pipe	675-78-c62	1	1	
625300M-K1	Valve	675-78-c62	1	1	
{625300M-K LV2/ICV 4826-004249}	Valve cock	675-78-c62	1	1	REF DC(1) 00992-1CV
675-78-3	Pipe	675-78-c6103	1	1	54(w/out Drg.)
675-78-4	Pipe	675-78-c6103-01	1	1	54(w/out Drg.)
624-214-K	Washer	625300M-K	1	1	REF DC(1) 00992-1CV
625301M-K	Body	625300M-K1	1	1	
		625300M-K1	1	1	
{625303M-K LV2/ICV 4820-004250}	Slide valve VALVE HEAD	625300M-K	1	1	
		625300M-K1	1	1	
625307M-K or	Cover	625300M-K	1	1	54(w/out Drg.)
625307M-K2	Cover	625300M-K1	1	1	
625329-K	Piston body	625300M-K	1	1	
625332-K	Spring	625300M-K1	1	1	
		625300M-K	1	1	
625333-K	Axle	625300M-K1	1	1	54(w/out Drg.)
		625300M-K	1	1	
625334-K	Pin	625300M-K	1	1	
		625300M-K1	1	1	
625335-K	Set screw	625300M-K	2	2	
		625300M-K1	2	2	54(w/out Drg.)
675-78-9	Pipe	675-78-c6103-02	1	1	
675-78-10	Pipe	675-78-c6103-03	1	1	
{LV2/ICV 5306-012481}	Rod THREADED END	625300M-K	1	1	
672-78-14	Handle	672-78-c6104	1	1	
672-78-17	Handle	672-78-c6105	1	1	REF DC(1) 00992-1CV
672-78-18	Lug	672-78-c6105	1	1	

APPROVED		675-78-cn2				
CHECKED		INTER LOCK PNEUMATIC DRIVE			WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)						
				SHT 2	SHTS 13	

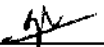
Designation	Description	designation	qnty	Total qnty	Remarks
700-30-241	Union nut	675-78-c6103	2	2	
		675-78-c6103-01	2	2	
		765-78-c6328	2	2	
		765-78-c6329	2	2	
		765-78-c6602	2	2	
		675-78-c6103-02	2	2	
		675-78-c6103-03	2	2	
		765-78-c6615	2	2	
		765-78-c6623	2	2	
		765-78-c6648	2	2	
		765-78-c6649	2	2	
		765-78-c6668	2	2	
		765-78-c6669	2	2	
		765-78-c6816	2	2	
		765-78-c6816-01	2	2	
		765-78-c6831-02	2	2	
		765-78-c6831-03	2	2	
		765-78-c6831-04	2	2	
		765-78-c6831-05	2	2	
700-31-576	Washer	765-78-c6794	1	2	
700-38-1679	Spring	675-78-c62	1	1	
700-38-1680	Spring	625300M-K	1	1	
700-40-260-10	Gasket	675-78-c62	4	4	
765-78-1722					
700-57-117	Pipe connection	675-78-c62	2	2	
701-119-11	Lever head	625300M-K	1	1	
		625300M-K1	1	1	
700-47-288	Shaft	672-78-c6104	1	1	
		672-78-c6105	1	1	
672-51-40	Boss	765-78-c6795	2	4	
700-56-206	T- joint	765-78-c6648	1	1	
		765-78-c6649	1	1	
700-57-403	NIPPLE	765-78-c6615	2	2	DCU00348/ICV

APPROVED		675-78-cn2			
CHECKED					
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		INTER LOCK PNEUMATIC DRIVE		WEIGHT	SCALE
			SHT	3	SHTS 13

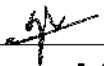
Designation	Description	Parent unit		Total qty	Remarks
		designation	qty		
700-57-403	Nipple	675-78-c6103	2	2	
		675-78-c6103-01	2	2	
		765-78-c6328	1	1	
		765-78-c6329	1	1	
		765-78-c6602	2	2	
		675-78-c6103-02	2	2	
		675-78-c6103-03	2	2	
		765-78-c6831-02	2	2	
		765-78-c6623	2	2	
		765-78-c6648	1	1	
		765-78-c6649	1	1	
		765-78-c6668	2	2	
		765-78-c6669	2	2	
		765-78-c6831-03	2	2	
		765-78-c6831-04	2	2	
		765-78-c6816	1	1	
		765-78-c6816-01	1	1	
		765-78-c6831-05	2	2	
700-57-404	Nipple	765-78-c6328	1	1	
		765-78-c6329	1	1	
		765-78-c6648	1	1	
		765-78-c6649	1	1	
		765-78-c6816	1	1	
		765-78-c6816-01	1	1	
		765-78-c6831-05	2	2	
765-08-253	Union	675-78-c62	2	2	DC(1) 00348/10
765-10-1086	Holder	765-78-c6794	1	2	
765-17-247	LUG	765-78-c6718	1	1	
765-78-65	ANGLE	675-78-c62	6	6	
765-78-66	oil seal	765-78-c6794	1	2	
765-78-67	oil seal	765-78-c6794	1	2	
765-78-69	Fork	765-78-c6794	1	2	
765-78-71-K1	Ring	765-78-c6794	2	4	

APPROVED		675-78-cn2			
CHECKED					
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		INTER LOCK PNEUMATIC DRIVE		WEIGHT	SCALE
				SHT 4	SHTS 13

Designation	Description	Parent unit	qnty	Total Qty	Remarks
		designation			
765-78-92	UNION	675-78-c62	2	2	
765-78-70-K	Ring	765-78-c6794	4	8	
765-78-572	T-Pipe	675-78-c62	2	2	
765-78-573	UNION	675-78-c62	2	2	
765-78-68 or	Nut	765-78-c6794	2	4	
765-78-1741					
765-78-751	TUBE	765-78-c6328	1	1	
765-78-752	TUBE	765-78-c6329	1	1	
765-78-1169	Ring	765-78-c6794	2	4	
765-78-1254	Jet	765-78-c6328	1	1	
		765-78-c6329	1	1	
		765-78-c6648	1	1	
		765-78-c6649	1	1	
		765-78-c6816	1	1	
		765-78-c6816-01	1	1	
765-78-1324	Pipe	765-78-c6602	1	1	54 (w/out Drg)
765-78-1337	Pipe	765-78-c6615	1	1	54 (w/out Drg)
765-78-1345	Pipe	675-78-c6623	1	1	54 (w/out Drg)
765-78-1362	Pipe	765-78-c6648	1	1	54 (w/out Drg)
765-78-1363	Pipe	765-78-c6648	1	1	54 (w/out Drg)
765-78-1364	Pipe	765-78-c6649	1	1	54 (w/out Drg)
765-78-1365	Pipe	765-78-c6649	1	1	54 (w/out Drg)
765-78-1375	Pipe	765-78-c6668	1	1	54 (w/out Drg)
765-78-1376	Pipe	765-78-c6669	1	1	54 (w/out Drg)
765-78-1628-02	Pipe	765-78-c6831-02	1	1	54 (w/out Drg)
765-78-1628-03	Pipe	765-78-c6831-03	1	1	54 (w/out Drg)
765-78-1628-04	Pipe	765-78-c6831-04	1	1	54 (w/out Drg)
765-78-1628-05	Pipe	765-78-c6831-05	1	1	54 (w/out Drg)
765-78-1408	EYE	675-78-c62	1	1	
765-78-1446	Lock	765-78-c6712	1	1	
765-78-1447	Stop	765-78-c6712	1	1	
765-78-1722	Pipe Connection	765-78-c62	2	2	873 No A ISSUE 12-3-67 DATE AMENDMENTS

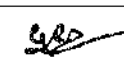
APPROVED		675-78-cn2			
CHECKED					
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		INTER LOCK PNEUMATIC DRIVE		WEIGHT	SCALE
				SHT 5	SHTS 13

Designation	Description	Parent unit		Total qnty	Remarks
		designation	qnty		
765-78-1448	Clamp	765-78-c6717	1	1	
		765-78-c6722	1	1	
765-78-1448-K	Clamp	765-78-c6717-K	1	1	When 765-78-c6717-K 765-78-c6722-K are used
		765-78-c6722-K	1	1	
765-78-1449	Catch	675-78-c62	1	1	
765-78-1454	Rod	765-78-c6718	1	1	
765-78-1457	Retainer	625300M-K1	1	1	
765-78-1512	INSTRUCTION PLATE	765-78-c6717	1	1	When 765-78-c6717-K is used
LV2/ICV 9905-009673 (REF.DCC() 01013-1CV)		765-78-c6717-K	1	1	
765-78-1513	INSTRUCTION PLATE	765-78-c6722	1	1	When 765-78-c6722-K is used
LV2/ICV 9905-009674 (REF.DCC() 01013-1CV)		765-78-c6722-K	1	1	
765-78-1570	Cover	765-78-c6794	1	2	
765-78-1571	Cylinder	765-78-c6795	1	2	
765-78-1597	Pipe	765-78-c6816	1	1	54 W/out Drg. 54 W/out Drg.
765-78-1598	Pipe	765-78-c6816-01	1	1	
765-78-1606	Rod	765-78-c6794	1	2	
775-78-62	UNION	675-78-c62	2	2	
770-72-152-K	Ring	625300M-K	1	1	
		625300M-K1	1	1	
700-47-359-02	Axle	675-78-c62	4	4	Standard 145-72
672-31-71-01	Tab washer	675-78-c62	4	4	
672-54-7-231-72	MULTIPURPOSE CLAMP	675-78-c62	14	14	
672-54-9-05	Clamp	675-78-c62	1	1	
	Bolt M6x14.46.019	675-78-c62	10	10	
	FOCT 7798-70				
	Bolt M8x30.46.019	675-78-c62	4	4	
	FOCT 7796-70				

APPROVED		675-78-cn2			
CHECKED					
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		INTER LOCK PNEUMATIC DRIVE		WEIGHT	SCALE
		SHT 6 SHTS 13			

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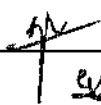
Designation	Description	Parent unit		Total qnty	Remarks
		designation	qnty		
EQ. MAT. C-30 TO IS:1570-79	Screw	625300M-K	1	1	DC(1)00348/ICV
	BIM4.8h6hx14.48.016	625300M-K1	1	1	
	ROCT 17473-80				
	screw BIM4.8h6hx8.48.016	625300M-K	4	4	
	GOST 17473-80 or				
	BIM4.8h6hx8.66.016	625300M-K1	4	4	
	ROCT 1491-80				
	Nut M6.6.019	675-78-c62	1	1	
	ROCT 5927-70				
	Nut M8x1.6.019	675-78-c62	1	1	DC(1)00348/ICV
	ROCT 5927-70				
	Nut M16x1.5.6.019	675-78-c62	4	4	
	ROCT 5929-70				
	Nut M16.6.019	765-78-c6794	1	2	
	ROCT 2526-70				
	Nut M5.6.016	625300M-K	1	1	
	ROCT 5932-62	625300M-K1	1	1	
	Washer 8.01.019 or 8.02.019	675-78-c62	8	8	(Ref. DC(1) 00857-ICV)
	ROCT 11371-78				
	Washer 6T65P06	675-78-c62	11	11	
	ROCT 6402-70				
	Washer 16.01.019 or 16.02.019	675-78-c62	4	4	
	ROCT 11371-78				
	Washer 4T65P05	625300M-K	1	1	DC(1)00348/ICV
	ROCT 6402-70	625300M-K1	1	1	
	Ring 008-012-25-2-2	625300M-K	2	2	
	ROCT 9833-73	625300M-K1	2	2	
	Cotter pin	625300M-K	1	1	
	1x12x019	625300M-K1	1	1	
	ROCT 397-79				
	WASHER 4.01.019 or 4.02.019, GOST 11371-78	625300M-K	1	1	DC(1)00348/ICV
		625300M-K	1	1	

APPROVED		675-78-cn2			
CHECKED					
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		INTER LOCK PNEUMATIC DRIVE		WEIGHT	SCALE
			SHT 8	SHTS 13	

Designation	Description	Parent unit		Total qty	Remarks
		designation	qty		
INDIAN EQUIVALENT: MS WIRE GALVANISED 1MM DIA, 1/4 HARD TO IS: 280-78, UTS 37- KgF/mm ² (MIN).	Cotter pin 2x16.019 FOCT 397-79	675-78-c62	4	4	DCLY00348/ICV DCL(1) 00500/ICV
	Cotter pin 3.2x18.019 FOCT 397-79	675-78-c62	2	2	
	Rivet 2x6-37 FOCT 10299-80	765-78-c6717	2	2	
	Wire K01 FOCT 792-67	765-78-c6722	2	2	
	Primer Φ11-03K FOCT 9109-81	675-78-c62	26m	26m	
		765-78-c6328			
		765-78-c6329			
		765-78-c6602			
		765-78-c6816			
		765-78-c6648			
		765-78-c6649			
		765-78-c6816-01			
		765-78-c6668			
		765-78-c6669			
		765-78-c6615			
		765-78-c6623			
		765-78-c6794			
		765-78-1448			
		765-78-1449			
		675-78-c6103			
		675-78-c6103-01			
		765-78-c6831-02			
		765-78-c6831-03			
		765-78-c6831-04			
		765-78-c6831-05			
	Enamel ПФ-223, blue, FOCT 14923-78	765-78-c6328			
		765-78-c6329			

APPROVED		675-78-cn2			
CHECKED		INTER LOCK PNEUMATIC DRIVE		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)					
			SHT 9 SHTS 13		

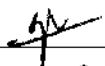
Designation	Description	Parent unit		Total qty	Remarks
		designation	qty		
	Enamel ПФ-223, blue, POCT 14923-78	765-78-c6602 765-78-c6615 765-78-c6623 765-78-c6648 765-78-c6649 765-78-c6668 765-78-c6669 765-78-c6831-02 765-78-c6831-03 765-78-c6816 765-78-c6816-01 675-78-c6103 675-78-c6103-01 765-78-c6831-04 765-78-c6831-05 765-78-c6794			
	Enamel ПФ-223, dark-gray, POCT 14923-78				
	Enamel ПФ-223, white-1, POCT 14923-78	765-78-1448 765-78-1449			
	Varnish KO-815 POCT 11066-74	700-38-1679 700-38-1680 765-78-92			
	Varnish ПФ-95 POCT 8018-70	675-78-c6103 675-78-c6103-01 765-78-c6602 765-78-c6648 765-78-c6649 765-78-c6328 765-78-c6329 765-78-c6668			

APPROVED		675-78-cn2			
CHECKED		INTER LOCK PNEUMATIC DRIVE		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)					
			SHT	10	SHTS

Designation	Description	Parent unit		Total qty	Remarks
		designation	qty		
	Varnish ГФ-95 ГОСТ 8018-70 Adhesive БФ-2 or БФ-4 ГОСТ 12172-74 Gasoline-resistant grease ГОСТ 7171-78 Grease ЦИАТИМ-201 ГОСТ 6267-74 Graphite lubricant СКа 2/6-г3 ГОСТ 3333-80 Red varnish НЦ-62 ОСТ 6-10-391-74 Clear varnish НЦ-62 ОСТ 6-10-391-74 Iron medium ГОСТ 8866-76 Transmission oil ТО3П-8 ТУ 38-101313-77 Electrode 3-50 ГОСТ 9467-75 Electrode 3-42 ГОСТ 9467-75	765-78-c6669 765-78-c6615 765-78-c6816 765-78-c6816-01 765-78-c6831-02 765-78-c6831-03 765-78-c6831-04 765-78-c6831-05 625300M-K 625300M-K1 625300M-K 625300M-K1 625300M-K 625300M-K1 765-78-c6794 625300M-K 625300M-K1 765-78-1512 765-78-1513 625300M-K 625300M-K1 625300M-K 625300M-K1 765-78-c6795 765-78-c6712 765-78-c6718			

APPROVED		675-78-cn2			
CHECKED		INTER LOCK PNEUMATIC DRIVE		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)					
			SHT	11	SHTS 13

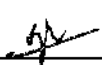
Designation	Description	Parent unit		Total qnty	Remarks
		designation	qnty		
WI-09-73	Lubricant Miron-24 ROCT 21150-75 or MC-70 ROCT 9762-76 Oil MT-16n ROCT 6360-58 or TY 38.001.117-73 Instructions for coating parts with varnish PΦ-95	675-78-c62 765-78-c6794			
WI-150-75	Instructions for use of iron minium and red lead for sealing of surfaces				
053.25289.00001	Instructions for impregnation of felt parts and as- bestos cord with graphite lubricant				
053.25289.00002	Instructions for impregnation of phosphatized and chrome-plated parts with preservation oil K-17.				
765-TT111	Technical require- ments to installa- tion and adjustment of water deflector				
765-78-101TT	Technical require- ments to production of pipes for pneu- matic system				

APPROVED		675-78-cn2				
CHECKED						
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		INTER LOCK PNEUMATIC DRIVE			WEIGHT	SCALE
				SHT 12 SHTS 13		

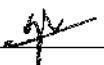
Designation	Description	Parent unit		Total qnty	Remarks
		designation	qnty		
TY 005216-75	Specifications for rubber items, plates and rubber compositions for special vehicles and their engines.				
TY 625300M-K/K1	Specifications for supply of air valves 625300M-K/K1				
TY 81-04-395-75	Specifications for fibre parts				
TY 14-3-480-76	Specifications for high-pressure seam less pipes made of steel 20A for diesel fuel equip-ment				

APPROVED		675-78-cn2				
CHECKED		INTER LOCK PNEUMATIC DRIVE			WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)						
				SHT 13 SHTS 13		

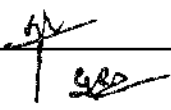
Ref. No.	Designation	Description	Qty	Remarks
		<u>Documents</u>		
	675-78-c62CB	Assembly drawing		
	675-78-c62Π4	Pneumatic connection diagram		
		<u>Assembly Units</u>		
1	675-78-c6103	Pipe	1	
2	675-78-c6103-01	Pipe	1	
3	675-78-c6103-02	Pipe	1	
4	675-78-c6103-03	Pipe	1	
6	765-78-c6328	Pipe	1	
7	765-78-c6329	Pipe	1	
9	765-78-c6602	Pipe	1	
12	765-78-c6615	Pipe	1	
13	765-78-c6623	Pipe	1	
14	765-78-c6648	Pipe	1	
15	765-78-c6649	Pipe	1	
16	765-78-c6668	Pipe	1	
17	765-78-c6669	Pipe	1	
18	765-78-c6717	Clamp, LOOP	1	Replace-
(B)	{ Pt No. LV2/RcV 5340-010316			ment with
19	765-78-c6717-X	Clamp	1	Ref.No.19
				is allowed
20	765-78-c6718	Rod	1	Replace-
21	765-78-c6722-201-72	Clamp, LOOP	1	ment with
(B)	{ Pt No. LV2/RcV 5340-009659			Ref.No.18
				is allowed

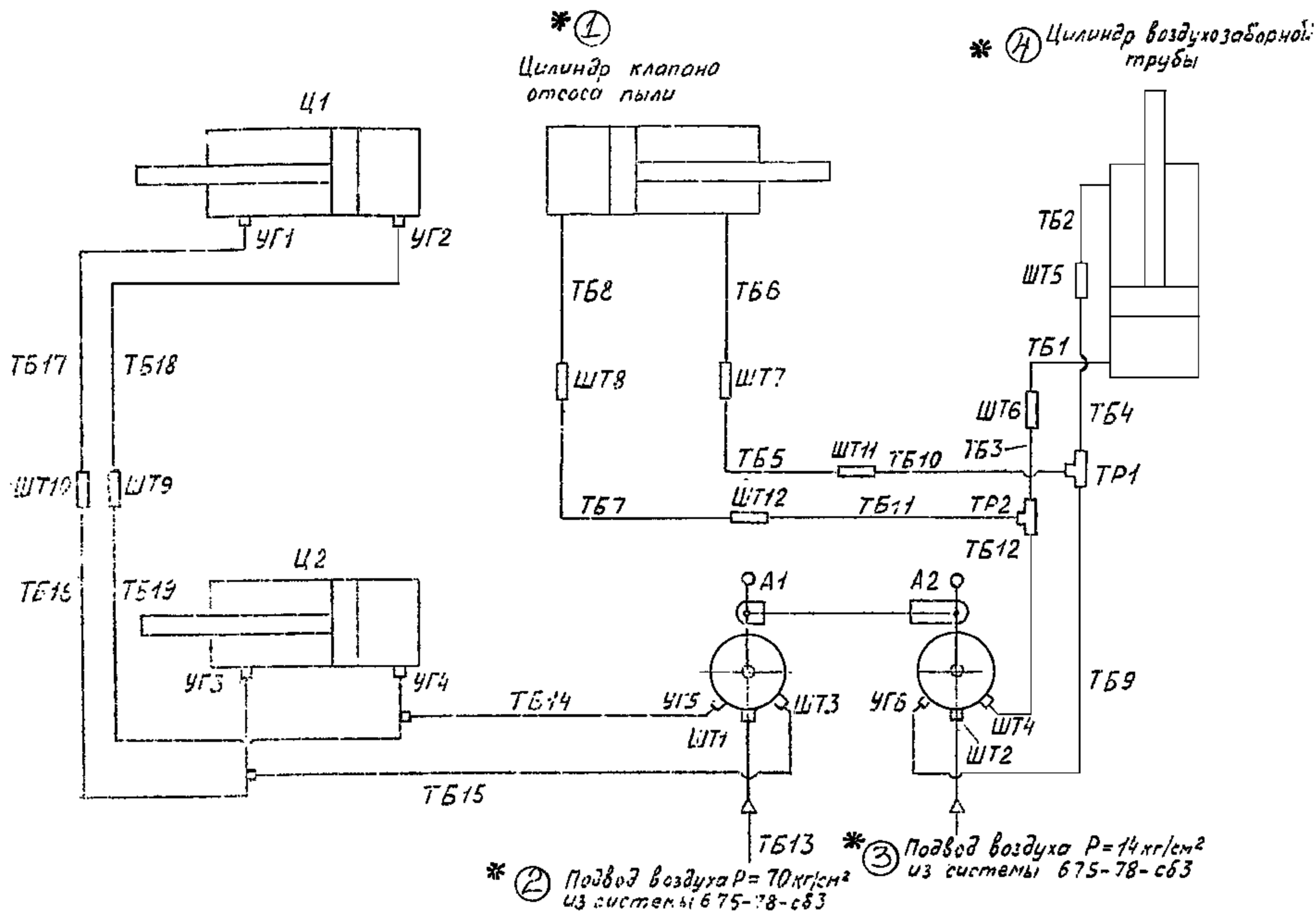
APPROVED		675-78-Sb2		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		INTERLOCK PNEUMATIC DRIVE	WEIGHT	SCALE
			SHT 1	SHTS 3

Ref. No.	Designation	Description	Qty	Remarks
22	765-78-c6722-K	Clamp	1	Replacement with Ref.No. 21 is allowed
23	765-78-c6794	Cylinder	2	REF DC(I) 00992-ICV
24	765-78-c6816	Pipe	1	
25	765-78-c6816-01	Pipe	1	
26	765-78-c6831-02	Pipe	1	
27	765-78-c6831-03	Pipe	1	
28	765-78-c6831-04	Pipe	1	
29	765-78-c6831-05	Pipe	1	
34	{625300M-K	Valve}	1	
	{LV2/ICV 4820-004249	cock}		
35	625300M-K1	Valve	1	
<u>Parts</u>				
38	672-31-71-01	Tab washer	4	
39	700-38-1679	Spring	1	
40	700-40-260-10	Gasket	4	
41	700-47-359-02	Axle	4	
42	765-08-253	UNION	2	
44	765-78-65	ANGLE	6	
45	765-78-92	UNION	2	
47	765-78-572	T-pipe	2	
48	765-78-573	Pipe UNION	① 2	
51	765-78-1408	EYE	1	
52	765-78-1449	Catch	1	
53	765-78-1722	Pipe UNION	2	
54	775-78-62	UNION	2	
70	672-54-7 231-72	MULTIPURPOSE CLAMP	14	
71	672-54-9-05	Clamp	1	
①	700-57-117	Pipe Connection	2	
<u>Standard Items</u>				
58		Bolt M6x14.46.019 ROCT 7798-70	10	

APPROVED		675-78-Sb2			
CHECKED					
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		INTERLOCK PNEUMATIC DRIVE		WEIGHT	SCALE
			SHT 2	SHTS 3	

Ref. No.	Designation	Description	Qty	Remarks
59	EQ. MAT. C-30 TO IS:1570-79	Bolt M8x30.46.019 FOCT 7796-70	4	(Ref. DCU) 0095 (ICV)
60		Nut M8x1.6.019 FOCT 5927-70	1	
61		Nut M16x1.5.6.019 FOCT 5929-70	4	
62		Washer 8.01.019 or 8.02.019 FOCT 11371-78	8	
63		Washer 16.01.019 or 16.02.019 FOCT 11371-78	4	
64		Washer 6T65FO6 FOCT 6402-70	11	
66		Cotter pin 2x16.019 FOCT 397-79	4	
67		Cotter pin 3,2x18.019 FOCT 397-79	2	
68		Nut M6.6.019 FOCT 5927-70	1	
		<u>Materials</u>		
75(C)	INDIAN EQUIVALENT: MS WIRE GALVANISED 1MM DIA. 1/4 HARD TO IS:280-78. UTS 37Kgf/ mm ² (MIN).	Wire K01, FOCT 792-67, L = 100 mm	26	
		00500/ICV A/C 17 FEB 95	(C) CDM	INDIAN EQUIVALENT ADDED FOR REF. NO. 75
		00358/ICV B/C JUL 93	(C) CDM	REF. NO. 18, DS. CAT PT NO. ADDED & NOMENCLATURE WAS - CLAMP FOR BOTH.
		00348/ICV C/D 11 FEB 93	(A)	ITEM/PT. NO. 700-57-117 DELETED ENTIRELY REF NO 48 QTY 2 WAS 4
		DC(I) NO. & DATE	ISSUE	NATURE
AMENDMENTS				

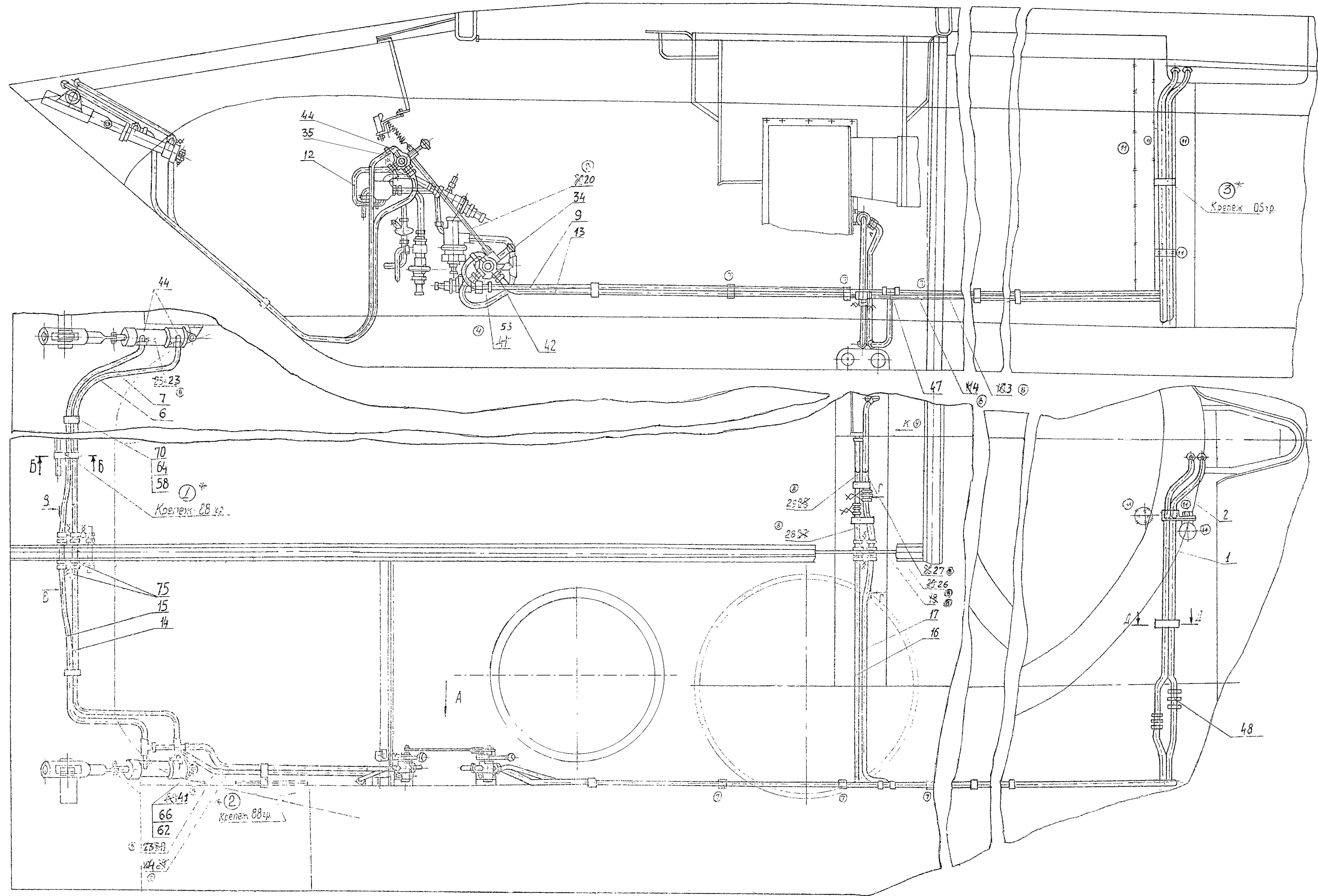
APPROVED		675-78-Sb2		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		INTERLOCK PNEUMATIC DRIVE	WEIGHT	SCALE
			SHT 3	SHTS 3



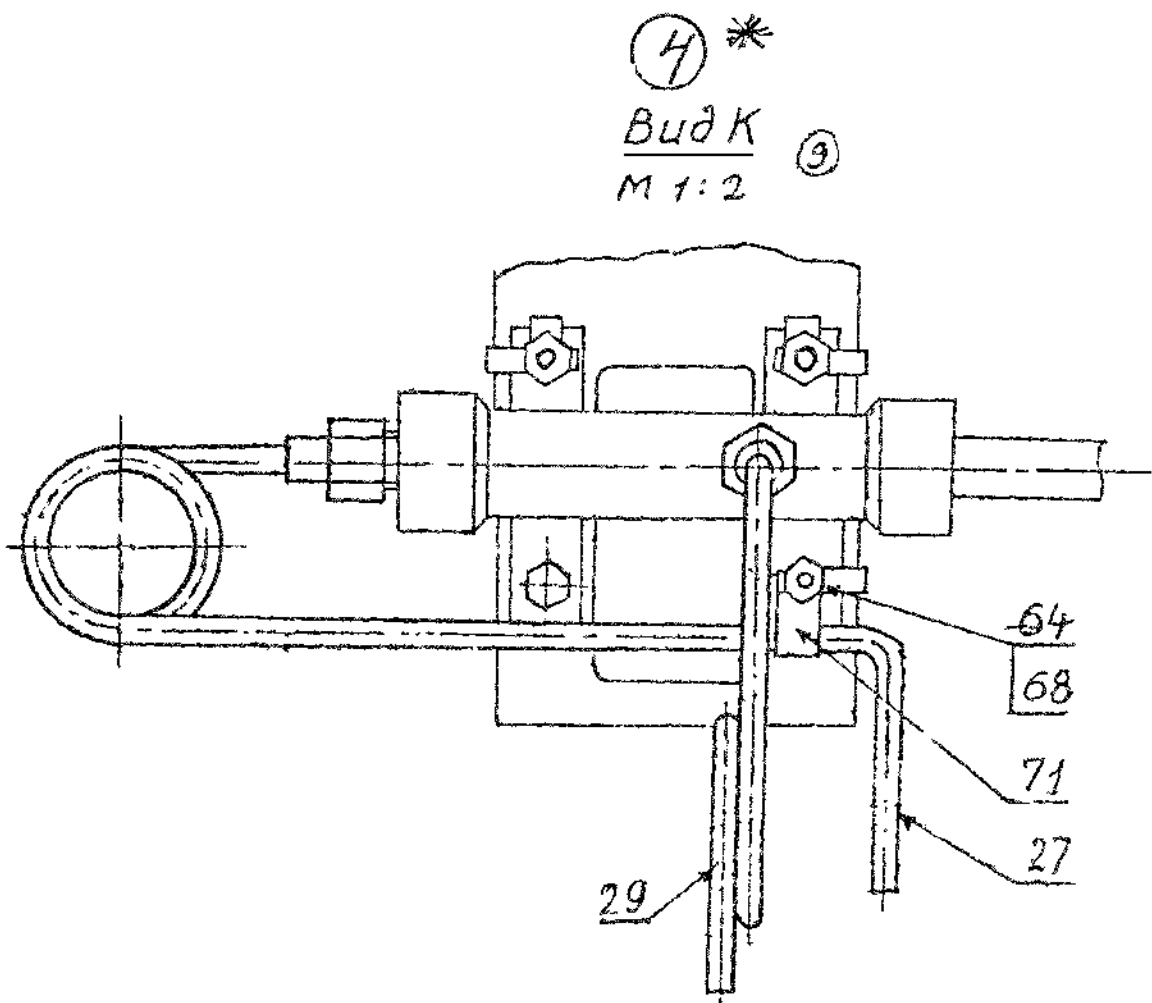
- * (1) Cylinder of dust suction valve
- * (2) Air supply at $P = 70 \text{ kg/cm}^2$ from system 675-78-сб3.
- * (3) Air supply at $P = 14 \text{ kg/cm}^2$ from system 675-78-сб3
- * (4) Cylinder of air intake pipe

Ref. No.	Description	Qty	Remarks
A1, A2	Valve 625300M-K	2	
Ц1, Ц2	Cylinder 765-78-сб794	2	
ТБ1	Pipe 675-78-сб103	1	
ТБ2	Pipe 675-78-сб103-01	1	
ТБ3	Pipe 675-78-сб103-02	1	
ТБ4	Pipe 675-78-сб103-03	1	
ТБ5	Pipe 765-78-сб831-02	1	
ТБ6	Pipe 765-78-сб831-03	1	
ТБ7	Pipe 765-78-сб831-04	1	
ТБ8	Pipe 765-78-сб831-05	1	
ТБ9	Pipe 765-78-сб602	1	
ТБ10	Pipe 765-78-сб669	1	
ТБ11	Pipe 765-78-сб668	1	
ТБ12	Pipe 765-78-сб623	1	
ТБ13	Pipe 765-78-сб615	1	
ТБ14	Pipe 765-78-сб816	1	
ТБ15	Pipe 765-78-сб816-01	1	
ТБ16	Pipe 765-78-сб649	1	
ТБ17	Pipe 765-78-сб329	1	
ТБ18	Pipe 765-78-сб328	1	
ТБ19	Pipe 765-78-сб648	1	
УГ1, УГ2, УГ3, УГ4, УГ5, УГ6	ANAL: 765-78-65	6	
ТР1, ТР2	T-pipe 765-78-572	2	
ШТ1, ШТ2	Pipe Union 765-78-1722	2	
ШТ3, ШТ4	Pipe Union 765-08-253	2	
ШТ5, ШТ6, ШТ7, ШТ8	Pipe Union 765-78-573	4	
ШТ9, ШТ10	Pipe Union 765-78-92/93	2	
ШТ11, ШТ12	Pipe Union 775-78-62	2	

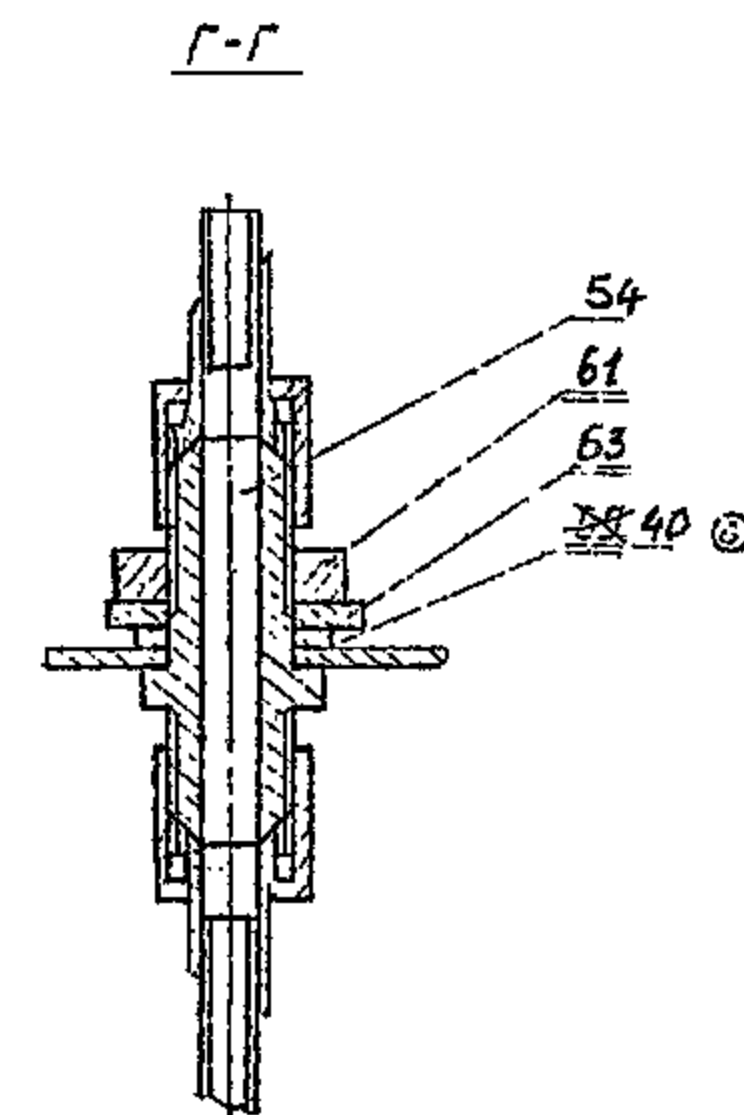
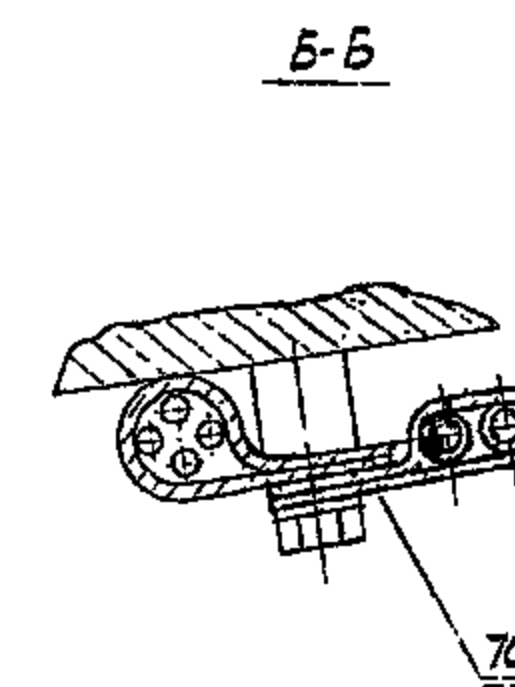
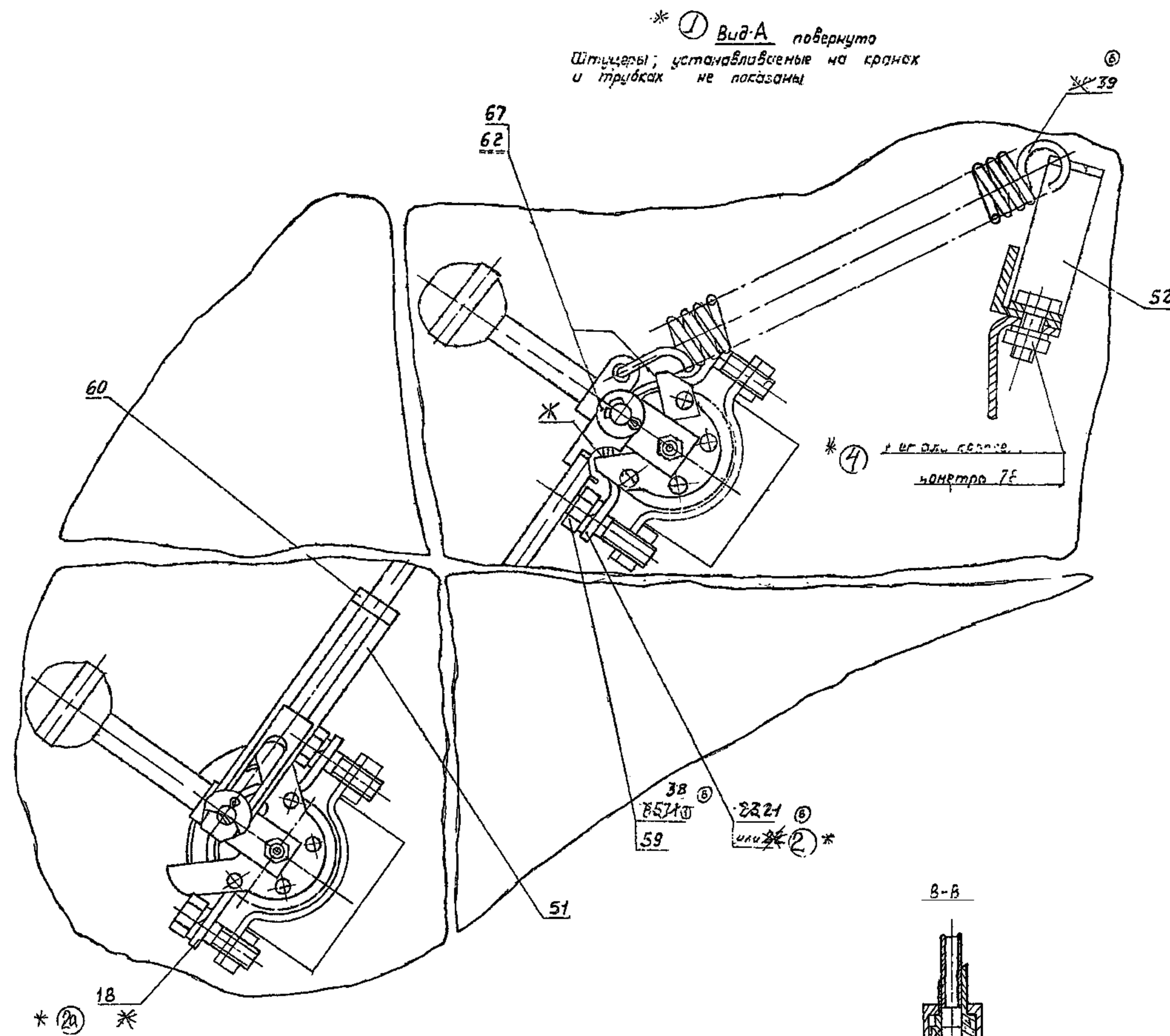
APPROVED		675-78-Sb279	
CHECKED			
CONTROLLER OF QUALITY ASSURANCE (ICV)		PNEUMATIC CONNECTION DIAGRAM	
		SHI	SHTS



- *(1) Fasteners, 88 gr.
*(2) Fasteners, 88 gr.
*(3) Fasteners, 05 gr.
*(4) View K
- Scale 1:2
- TECHNICAL CONDITIONS
1. Pressure test together with pneumatic equipment syst with compressed air valves being open (valve handle be. set to extreme positions) for at least 2 min. Leakage o. air through joints is not tolerable.
 2. When locking pipeline joints, tighten up wire so as to prevent unscrewing of nut.
 3. Install cylinders according to 765-TF111.
 4. It is allowed to bend pipes during installation, in this case, they should be disconnected from assemblies. Ovality - 1 mm, maximum.
 5. After actuation spring Ref. No. 40 should smoothly without seizure return valve handles to initial position. It is allowed to move handle of valve Ref. No. 35 to extreme upper position by hand.
 6. Remove plugs from pipes just prior to assembly.
 7. Adjust length of rod Ref. No. 21 to ensure clearances between retainers of upper valve handle and stops X and N, when lower valve handle is moved to extreme positions against stops. Difference in clearances for upper and lower positions - 1 mm, maximum.
 8. Clearance between seats of valves Ref. Nos 34, 35 are projections of clamps Ref. Nos 21, 23 is not tolerable. It is allowed to bend projections.
 9. It is allowed to install pipe connections Ref. No. 54 with hexahedron from power plant compartment side.
 10. When installing rod Ref. No. 21, place three washers Ref. No. 62 onto spacer shaft of valve Ref. No. 35. If the rod is misaligned, it is allowed to adjust it by means of washers on both sides of rod ear.
 11. During installation it is allowed to apply iron minium ROOT 8866-75 to taper thread of parts Ref. Nos 44 and 42, after they are tightened through two - three threads.
 12. Prior to installing cylinders, move rod from one extreme position to another and back to remove excessive oil with pipe connections being open.
 13. To ensure clearance between spring Ref. No. 40 and bracket of instrument board, it is allowed to bend bracket Ref. No. 52.
 14. Contact of spring Ref. No. 40 with retainer of valve Ref. No. 35 is tolerable.
 15. Install pipelines Ref. Nos 27 and 29 after cleaning and cooling unit is assembled.
 16. Apply lubricant Akron-24 ROOT 21150-75 or MG-70 ROOT 9762-75 to thread of fasteners.
 17. Ensure clearance of at least 5 mm between additional fuel tank and pipelines Ref. Nos 1 and 2.

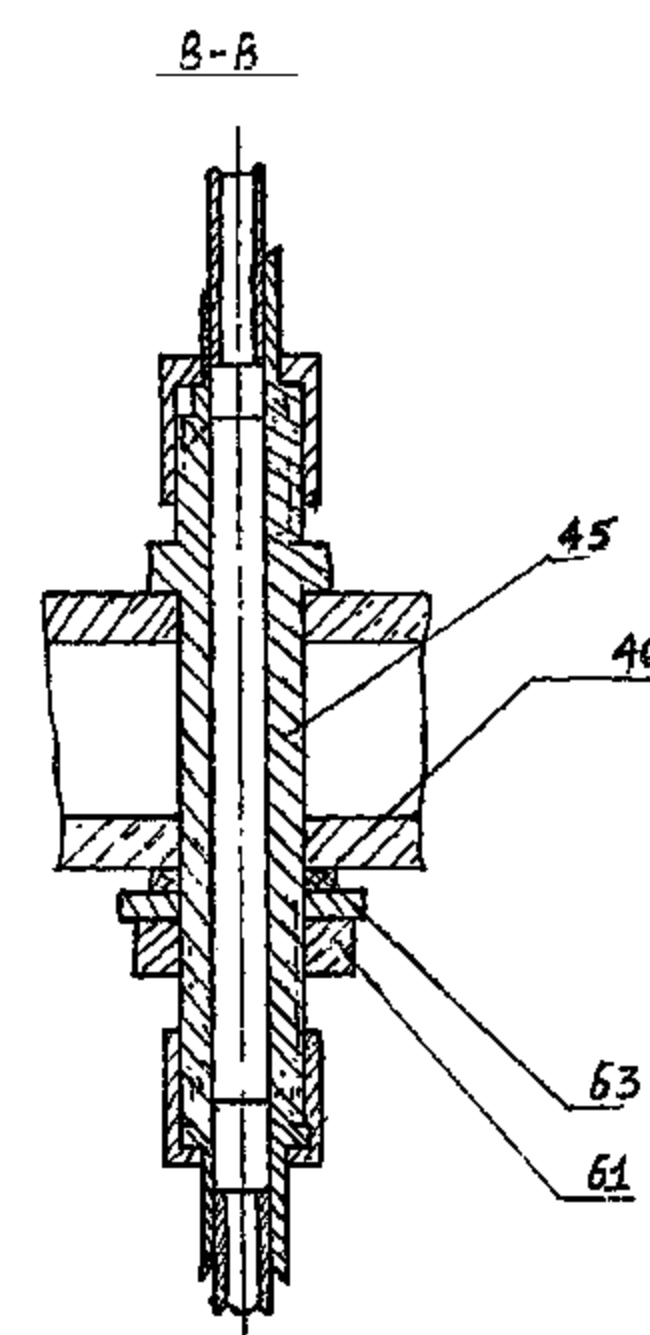
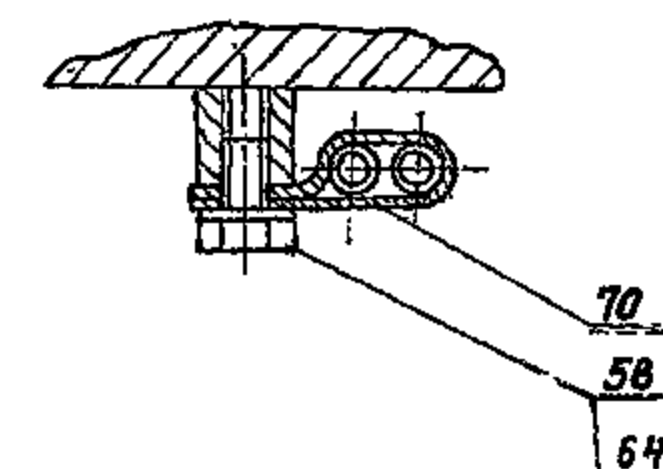


APPROVED		675-78-Sb2Sb			
CHECKED		INTERLOCK PNEUMATIC DRIVE	WEIGHT	SCALE	
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	9.4		1:5		
	SHT 1 SHTS 2				



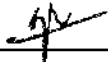
- * (1) View A
Pipe connections used on valves and pipes
are not shown
- * (2) 21 gr.
- * (2a) 18 gr.
- * (3) 18 - 18 revolved
- * (4) Pressure gauge fasteners, 78 gr.

* ③ 18



APPROVED		675-78-Sb2Sb			
CHECKED		INTERLOCK PNEUMATIC DRIVE			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		WEIGHT	SCALE	SHT 2	SHTS 2

Ref. No.	Designation	Description		
	675-78-c6103CB	<u>Documents</u> Assembly drawing		
		<u>Parts</u> 		
2	700-30-241	Union nut	2	
3	700-57-403	Nipple	2	
		<u>Variable Data for Manufacture</u> <u>675-78-c6103</u> <u>Parts</u>		
1	675-78-3	Pipe Pipe 8x1-20A TY 14-3-480-76 <u>675-78-c6103-01</u> <u>Parts</u>	1	0.365 kg
1	675-78-4	Pipe Pipe 8x1-20A TY 14-3-480-76 <u>675-78-103-02</u> <u>Parts</u>	1	0.383 kg
1	675-78-9	Pipe Pipe 8x1-20A TY 14-3-480-76 <u>675-78-c6103-03</u> <u>Parts</u>	1 1	0.414 kg
1	675-78-10	Pipe Pipe 8x1-20A TY 14-3-480-76	1	0.425 kg

APPROVED		675-78-Sb103		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		PIPE	WEIGHT	SCALE
			SHT	SHTS