

Таблица 1
Таблица 1

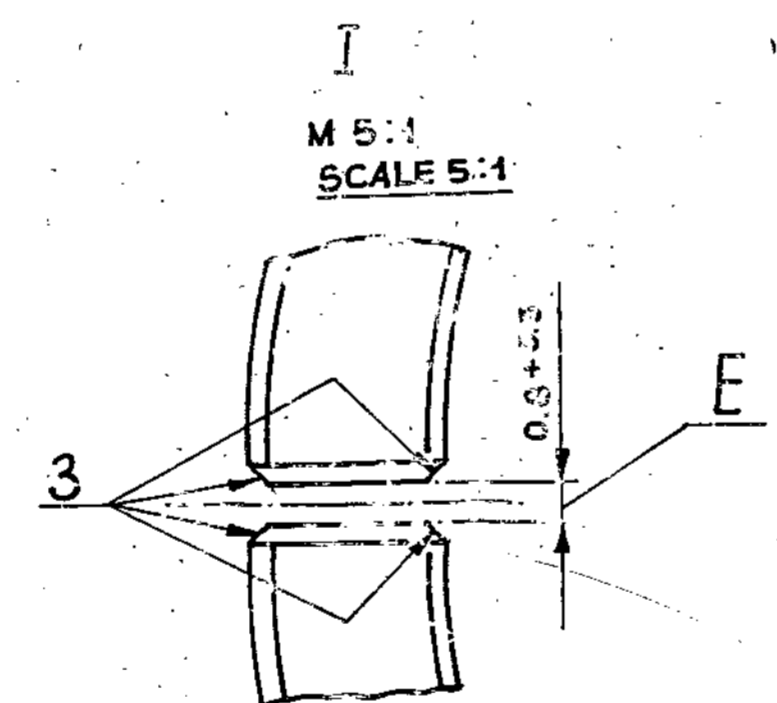
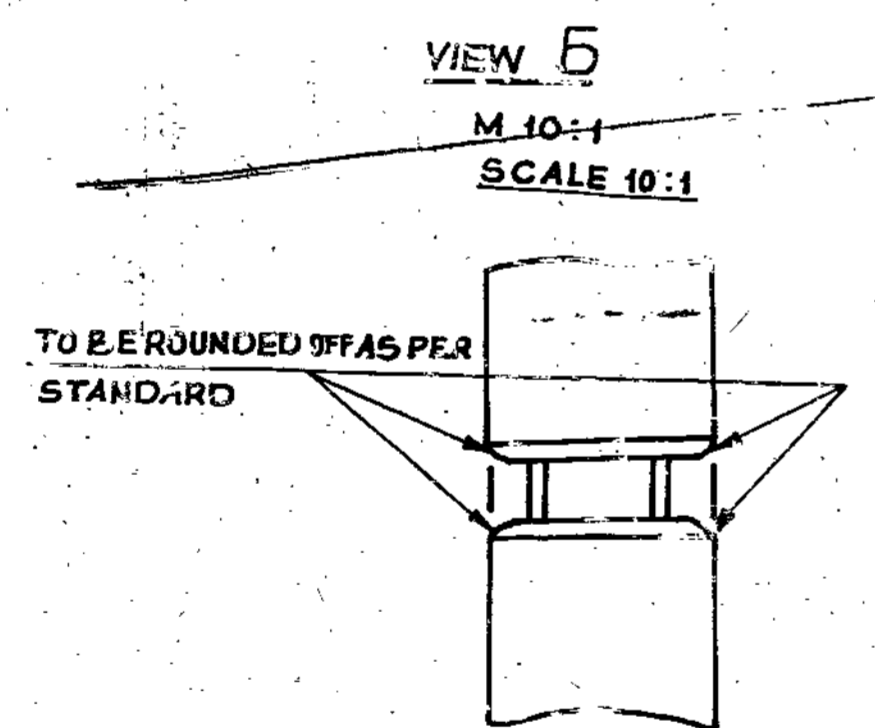
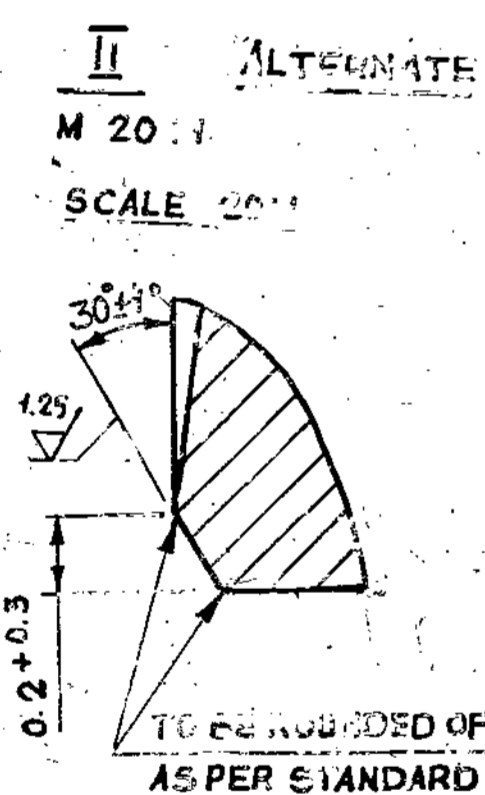
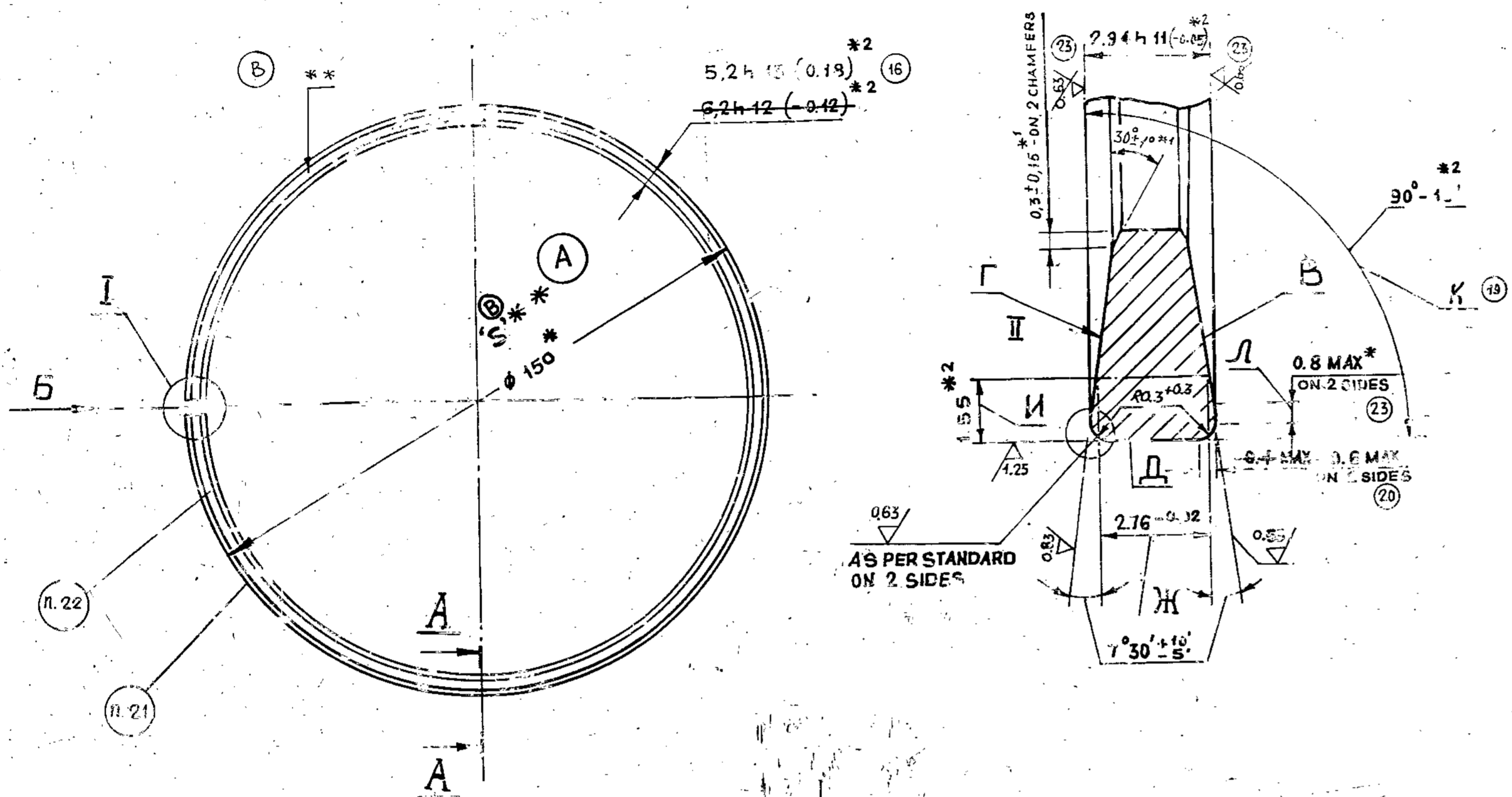
D ₀	Δ, мм			
	А ₁	Б ₁		
0	180	360	0,0000	0,0000
5	175	355	0,0006	0,0023
10	170	350	0,0023	0,0090
15	165	345	0,0050	0,0201
20	160	340	0,0088	0,0351
25	155	335	0,0134	0,0536
30	150	330	0,0188	0,0750
35	145	325	0,0247	0,0987
40	140	320	0,0310	0,1239
45	135	315	0,0375	0,1500
50	130	310	0,0440	0,1760
55	125	305	0,0503	0,2013
60	120	300	0,0563	0,2250
65	115	295	0,0616	0,2464
70	110	290	0,0662	0,2649
75	105	285	0,0700	0,2799
80	100	280	0,0727	0,2909
85	95	275	0,0744	0,2977
90	270	0,0750	0,3000	

Таблица 2
Таблица 2

B ₁	δ, мм
130	0,2830
125	0,2660
120	0,2490
115	0,2320
110	0,2150
105	0,1980
100	0,1810
95	0,1640
90	0,1470
85	0,1300
80	0,1130
75	0,0975
70	0,0820
65	0,0675
60	0,0530
55	0,0390
50	0,0250
45	0,0110
40	0,0075
35	0,0030
30	0,0055
25	0,0080
20	0,0110
15	0,0150
10	0,0190
5	0,0236
0	0,0290

- Inspection groups II as per OCT 190073-85.
- Hardness ≥ 107 HB.
- Blank - forging.
- Acceptance of casting is to be done as per TY 1-801-351-84.
- Inclusion of silicon is allowed on machined surfaces except surfaces of grooves И₁ (as per checked specimen)
- Unspecified limit deviations of dimensions are: H14, h14, $\pm \frac{IT14}{2}$.
- Dimension E₁ to be checked relative to surface Л.
- * Dimensions are ensured with tool.
- ** Dimensions are given for reference.
- Dimensions Э and Ж₁ are given in plane Б-Б.
- Loosening of dimension Я is allowed by 0.01mm over arc 'Ю'.
- Checking of oval - concavity of profile is to be carried out along 9 points. Estimation of points (on diameter) as follows:
 - 1 and 3,4 and 6,7 and 9 with respect to 2,5,8-0.120.0190mm at difference measurements between points 1 and 3,4 and 6,7 and 9 not exceeding 0.050mm.
 - 1,2,3 with respect to 4,5,6-0.045...0.088 MM;
 - 7,8,9 with respect to 4,5,6-0.000...0.052 MM.
- Tolerance of ovality, taper and concavity of surface C should not exceed 0.005mm (semi difference of diameters).
- Mass of piston is 3060 \pm 20 gm.
- For adjusting weight of the component, remove metal up to dimension Ш.
- Modification of curvature of surface 'K' should be smooth.
- Burrs are not allowed on surface M, C and groove И₁.
- Resetting of instrument is allowed on surface 'C' (as per checked specimen).
- Surface Л should be checked with template made to nominal dimensions, in this case the clearance between template and profile should not be more than 0.1mm.
- Burrs are not allowed.
- Coating of radii M₁ over a height M₁ chemical 03 should be carried out as per instruction ИЛ 79991. It is allowed to do coating on surfaces Л, Н, П, Р, С, У, Ф, Ч and at a height of Д₁.
- Profile of radii K₁ and Л₁ should be smooth cutting is not allowed.
- Circular markings are not allowed in hole 'Т'.
- Smooth transition of oval - barrel shaped profile should be on section Г₁.
- Table 1 and 2 are given for manufacturing of template.
- To be marked 05-10.
- To be marked technological piston number.
- To be marked weight (Three last digits).
- When stamping and marking letter type 5-Пр3 GOST 26.008-85 should be used.

406-06	406-06	Dr.23-09-08	304-05-10
81-03	81-03		
2000-62	2000-62		
Им. Лист № док. Подп. Дата	Им. Лист № док. Подп. Дата		
Проб.	Проб.		
Г. код	Г. код		
И. код	И. код		
С. код	С. код		
Поршень			Лит. Масса Массовая
AK12D T5 1-809-674-84			01 С.п.14 1:1
			Лист Листов 7
			Ф 3/45
			Формат А2:3



REPAIR SIZES - DIMENSION

DRAWING No.	W
3304-06-9 R1	150.2
3304-06-9 R2	150.5

REPAIR SIZE - DIMENSION

CATEGORY	DIMENSION'S
3304-06-9 R1	150.10
3304-06-9 R2	150.20

- IN SECTION GROUP III AS PER TECHNICAL REQUIREMENT TT-1.
- NRC 42-58.
- THE RING SHOULD BE SUBJECTED TO HEAT-TREATMENT IN A TEMPERATURE MANDREL.
- BUCKLING OF SURFACES 'B' AND 'C' SHOULD NOT EXCEED 0.05 mm.
- RING SHOULD NOT HAVE ANY SURFACE MARKS, CRACKS AND METALLURGICAL DEFECTS.
- THE RING SHOULD BE CHECKED FOR DEFECTS BY MAGNETIC FIELD FLAW DETECTOR AND DEMAGNETIZED BEFORE BEING COATED WITH CHROMIUM MOLYBDENUM ALLOY. EVERY BATCH SHOULD BE SUBJECTED TO 100% CHECKING ON THE DEMAND OF QID.
- SURFACE 'A' IN COMPRESSED STATE SHOULD BE PROVIDED WITH COATING OF 10-15 μm AS THICK AS 100-160 MICRONS AS PER UA-212-76. DEPTH OF SPONGY LAYER 30-60 μm, SEPARATE SPINDLES HAVING DEPTH 30 μm MIN. ARE PERMITTED.
- BY 800 TO 1100 OF CHROMIUM MOLYBDENUM BEFORE FORMATION OF SPONGY LAYER TO BE CHECKED AS PER UA-212-76.
- DEVIATION IN TOTAL THICKNESS OF CHROMIUM MOLYBDENUM LAYER FOR A SINGLE RING SHOULD NOT EXCEED 0.04 mm.
- ROUGHNESS OF SURFACE 'A' BEFORE FORMATION OF SPONGY LAYER 0.32 μm.
- SPALLING OF CHROMIUM MOLYBDENUM ALLOY IS NOT PERMITTED.
- COATING 'M' AFTER FORMATION OF SPONGY LAYER AS PER UA-570-84. TIN LAYER ON SURFACE 'A' MAY NOT BE DONE.
- PLACES 'B' ARE TO BE BLUNTED ON TWO SIDES TO RADIUS IN DRAWING Q3 TO 0.6 mm TO BE PROVIDED AS PER STANDARD.
- DIMENSION 'E' FOR NOMINAL DIAMETER.
- RADIAL CLEARANCE BETWEEN THE RING AND THE CALIBRATED WASHER 150 ± 0.05 mm WHEN THE TOLERANCE FOR QUALITY OF CALIBRATED WASHER IS 0.0075 mm MAX. (SEMI-DIAMETER) MAY BE 0.02 mm OVER AND NOT MORE THAN 35° TO ONE PLICE OR AT TWO PLICES WITH 1.5 mm ARC IN 45°, LOCATED NOT NEARER THAN 30° FROM THE LOCK BAR. SOME CLEARANCE IS NOT PERMITTED.
- FLATNESS OF SURFACE 'B' AND 'C' SHOULD BE CHECKED BY FITTING IN GAUGE WHICH CORRESPONDS TO THE NOMINAL DIAMETER WITH SPHERICAL TAPER PLUG WITH WEIGHT 25 kg. THE IMPRINT SHOULD BE IN THE FORM OF UNINTERRUPTED BAND WITH A WIDTH OF 15 mm OVER THE ENTIRE RING.
- BUCKLING OF RING SHOULD BE CHECKED AFTER FINISHING BY PASSING IT THROUGH THE SLIT FIT BY THE RING SHOULD FREELY PASS THROUGH THE SLIT IN THE PLUG BY ITS OWN WEIGHT IN ONE DIRECTION. NO BURNED TRACES LEFTOUT BY THE SURGING TOOL ON SURFACES 'B' AND 'C' ARE ALLOWED.
- LOCK BAR IN FREE POSITION IS 22 mm.
- RETURN RING ELASTICITY 2200 MPa BY BAND DEVICE IN CASE DIMENSION 'E' IS PROVIDED.
- DIMENSION 'A' IS GIVEN FOR CHECKING DIMENSION 'W'.
- THREE LAST DIGITS OF COMPONENT NUMBER SHOULD BE MARKED.
- TO BE MARKED 'TOP'.
- MARKING SHOULD BE DONE WITH SOLUTION No. 5 AS PER UA-16-73 TYPE No. 3 GOST 9030-62.
- * DIMENSION FOR REFERENCE.
- NO DIMENSIONS ARE TO BE ENSURED BY TOOL.
- NO DIMENSIONS AFTER CHROMIUM MOLYBDENUM COATING.
- VARIATION IN RADIAL THICKNESS OF RING SHOULD NOT EXCEED 0.1 mm.
- DIMENSION 'W' SHOULD BE CHECKED IN FREE CONDITION OF RING.
- BAND 'M' UNIFORM ALONG PERIMETER IS ALLOWED.

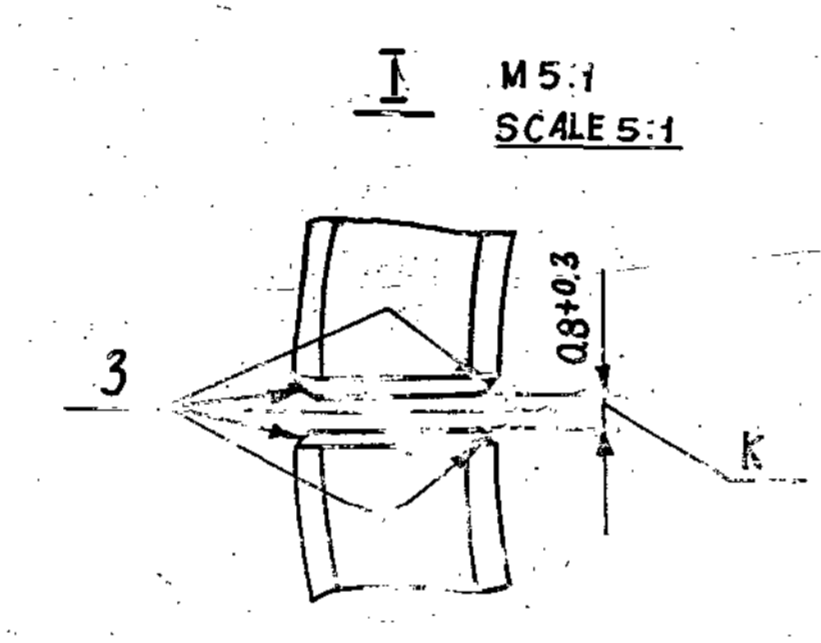
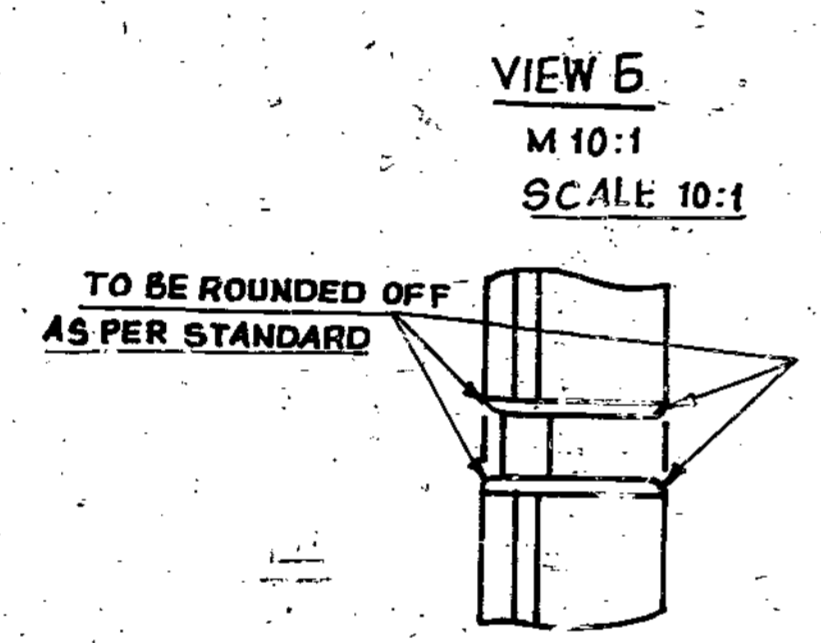
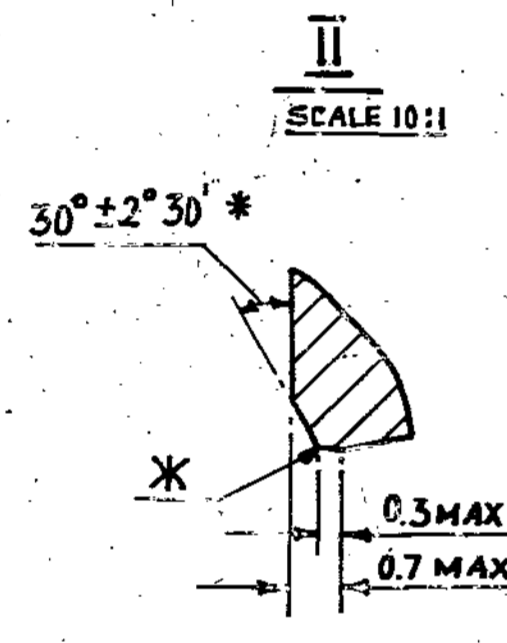
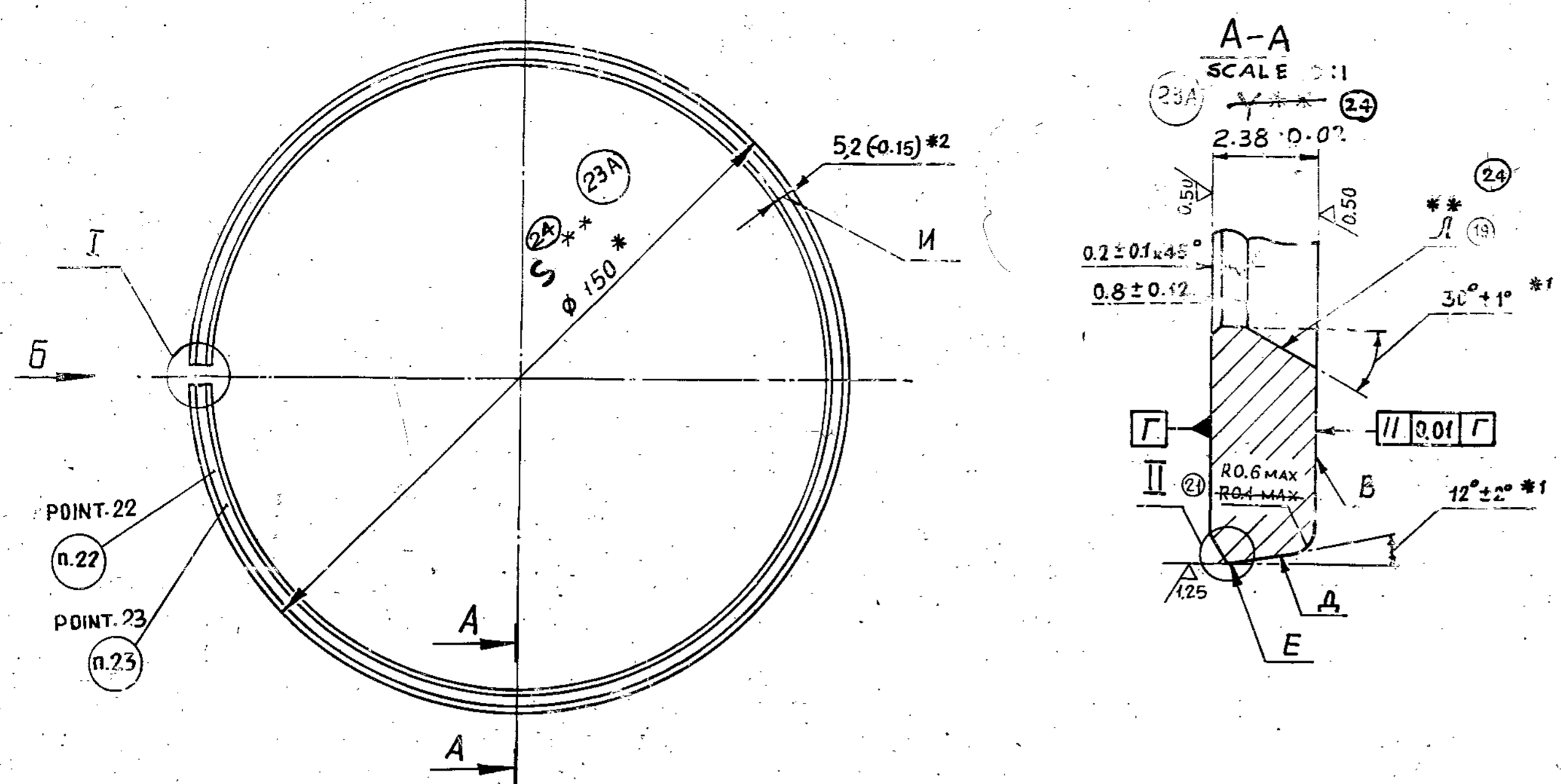
- A ** 29A. CHECK SIZE 'E' USING A SIZED WASHER WITH A DIAMETER OF 150.10 ± 0.05 mm FOR RING 3304-06-9 R1 AND THAT HAVING A DIAMETER OF 150.20 ± 0.03 mm FOR RING 3304-06-9 R2.
- B ** 29B. MARKS R1 OR R2 TO BE APPLIED USING SOLUTION No. 5 PREPARED ACCORDING TO H 16-73. LETTERING 10.5, GOST 2930-62.

Album - 3 KVD No 78076

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

EST. MASS 0.045 kg. TO BE STAMPED AND MARKED WHERE INDICATED THROUGH LETTERS. ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MARKING TO HAVE EQUIVALENT MARKING ON INSIDE EQUIVALENT SURFACES ARE PERMITTED.

DRN	DATE	MATERIAL	USED ON
129-3-87	12-9-87	STEEL EN 8-10-11 GOST 5950-73	C5 3304-01-8C6
SCALE	1:1	CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DIMENSIONS IN mm		TITLE	
TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS 12/10-69		PACKING RING PISTON	
B	8.12.94	AUTHORITY: No. 83353/CQA (CVD) IND 32 at 6-12-94	D.S. NO.
A	19-3-92	VIDE ANTH / L 5710 83233 V46-51 IND Vd 31-1-72	DRAWING NUMBER
ISSUE	PAGE	CONFORM TO	3304-06-9



23A ** REPAIR SIZE DIMENSIONS

DRAWING No.	X	Y
3304-08-9 R1	DIA 150	2.68 ± 0.02
3304-08-9 R2	DIA 150.2	2.38 ± 0.02
3304-08-9 R3	DIA 150.2	2.68 ± 0.02

24 ** REPAIR SIZE DIMENSION

CATEGORY	DIMENSION 'S'
3304-08-09-R1	150.10
3304-08-09-R2	150.20

EXPLANATORY NOTE

23A MATERIAL QUOTED : WIRE 3.1x7.5 TY 14-4-229-72
 SQUARE GAUGE STEEL WIRE, WITH SIDES 3.1mm AND 7.5mm.
 WIRE MATERIAL : GRADE 65 G AS PER GOST 1058-76.

a) CHEMICAL COMPOSITION - AS PER GOST 1058-76.

GRADE	CONTENT OF ELEMENTS %								
	C	SI	Mn	Cr	Ni	Cu	S	P	
65 G	0.62-0.70	0.17-0.37	0.90-1.20	0.25	0.25	0.25	0.040	0.035	

b) MECHANICAL PROPERTIES
 ULTIMATE TENSILE STRENGTH : 90 - 120 Kgf/mm²

NUMBER OF BENDS : 3 (min) WHILE TESTING ON ROLLERS WITH A DIAMETER OF 20mm.

23A ** 27A. CHECK SIZE 'K' USING THE FOLLOWING SIZED WASHERS:
 - WITH A DIAMETER OF 150.10 ± 0.03 mm FOR RING 3304-08-9 R1;
 - WITH A DIAMETER OF 150.20 ± 0.03 mm FOR RINGS 3304-08-9 R2, R3

24 ** 27B. MARKS R1, R2, R3 TO BE APPLIED WITH RESPECT TO THE REPAIR.

24 SIZE CATEGORY USING SOLUTION NO.5 PREPARED ACCORDING TO
 ИЛ-16-73. LETTERING И0-3, GOST 2930-62

TECHNICAL REQUIREMENTS - TRANSLATED

- INSPECTION GROUP AS PER IT-11.
- HRC₂ 21 TO 29 WITH HRC₃ ≤ 22 MEASUREMENTS ARE TO BE TAKEN ON SCALE B, IN THIS CASE HRB ≥ 96.
- REQUIREMENTS FOR BLANK AS PER TY 14-4-229-72.
- VARIATION IN WIDTH OF DIMENSION U SHOULD NOT EXCEED 0.1 mm.
- ROUGHNESS OF SURFACE E AFTER CHROMIUM MOLYBDENUM COATING IS 0.32.
- CRACKS, ROUGH SPOTS, DENTS AND METALLURGICAL DEFECTS ARE NOT PERMISSIBLE ON THE SURFACE OF SLINGER.
- COATING OF SURFACE A AND E Cr.Mo AS THICK AS 60-120 MICRONS AS PER UA-212-76 COATING IS TO BE APPLIED (WITH SLINGER) IN COMPRESSED STATE.
- TO BE COATED WITH OI AFTER CHROMIUM MOLYBDENUM ALLOY COATING IS APPLIED AS PER UA-570-84.
- HV 550 TO 800 FOR SURFACES A AND E AFTER CHROMIUM MOLYBDENUM ALLOY COATING, TO BE CHECKED AS PER UA-212-76.
- THE DEVIATION IN TOTAL THICKNESS OF CHROMIUM MOLYBDENUM ALLOY FOR ONE SLINGER SHOULD NOT EXCEED 0.04 mm.
- CHIPPING OF CHROMIUM MOLYBDENUM ALLOY IS NOT ALLOWED.
- SHARP EDGES SHOULD BE PROVIDED ALONG THE ENTIRE PERIMETER ON PLACE * ON FINISHED SLINGER. BURRS ARE NOT ALLOWED.
- BEFORE COATING WITH CHROMIUM MOLYBDENUM ALLOY THE SLINGER SHOULD BE CHECKED FOR DEFECTS BY MAGNETIC-FIELD FLAW DETECTOR AND DEMAGNETIZED.
- AFTER GRINDING, CYLINDRICAL BAND E UP TO 0.5 mm WIDE IS PERMISSIBLE AT A DISTANCE OF 12 mm FROM THE EDGE OF THE LOCK GAP.
- PLACES S ARE TO BE BLUNTED ON 2 SIDES TO RADIUS OR CHAMFER 0.3 TO 0.6 mm TO BE ACCEPTED AS PER STANDARD.
- LOCK GAP IN FREE POSITION IS 23 mm.
- SLINGER ELASTICITY ON BAND DEVICE IS 2000 TO 2700 gr, PROVIDED DIMENSION K IS ENSURED.
- DIMENSION K FOR NOMINAL DIAMETER.
- RADIAL CLEARANCE BETWEEN THE SLINGER AND CALIBRATED WASHER Ø150 mm WITH THE TOLERANCE FOR QUALITY OF CALIBRATED WASHER 0.0025 mm MAX. (SEMI DIFFERENCE DIAMETER) MAY BE 0.02 mm OVER AN ARC OF 45° AT ONE PLACE OR AT 2 PLACES WITH TOTAL ARC UP TO 45° WITH SUBSEQUENT SMOOTH MEMENT TO BOTH SIDES TO ZERO, TO BE ACCEPTED AS PER STANDARD.
- NON FLATNESS OF SURFACES B AND G IS TO BE CHECKED BY PAINTING BETWEEN TWO PLATES. THE WEIGHT OF TOP PLATE IS 17kg. THE IMPRINT SHOULD UNIFORMLY COVER 75% MINIMUM OF SLINGER FACE SURFACE. IN THIS CASE THE IMPRINT SHOULD BE 2mm WIDE AND UNINTERRUPTED ALONG THE ENTIRE CIRCUMFERENCE TO BE SUBJECTED TO SPOT CHECKING ON THE DEMAND OF BID, BUT NOT LESS THAN 10%.
- BUCKLING OF SLINGER IS TO BE CHECKED AFTER TANNING BY PASSING IT THROUGH THE SLIT FIXTURE. THE SLINGER SHOULD FREELY PASS THROUGH THE SLIT IN THE FIXTURE BY ITS OWN WEIGHT. DIMENSION OF SLIT IS 2.44 ± 0.01 mm. TRACES LEFT OUT BY MEASURING TOOL (SLIT) ON SURFACES B AND G ARE ALLOWED.
- TOP IS TO BE MARKED WITH PAINT AS PER UA-16-73 TYPE И0-25 GOST 2930-62.
- THE LAST THREE DIGITS OF COMPONENT NUMBER ARE TO BE MARKED WITH PAINT AS PER UA-16-73, TYPE И0-25 GOST 2930-62.
- ** DIMENSIONS FOR REFERENCE.
- *1 DIMENSIONS ARE TO BE ENSURED BY TOOL.
- *2 DIMENSION AFTER CHROMIUM MOLYBDENUM COATING.
- MARKING WITH A DEPTH NOT MORE THAN 0.05 mm ON SURFACE J IS ALLOWED TO BE ACCEPTED AS PER STANDARD.

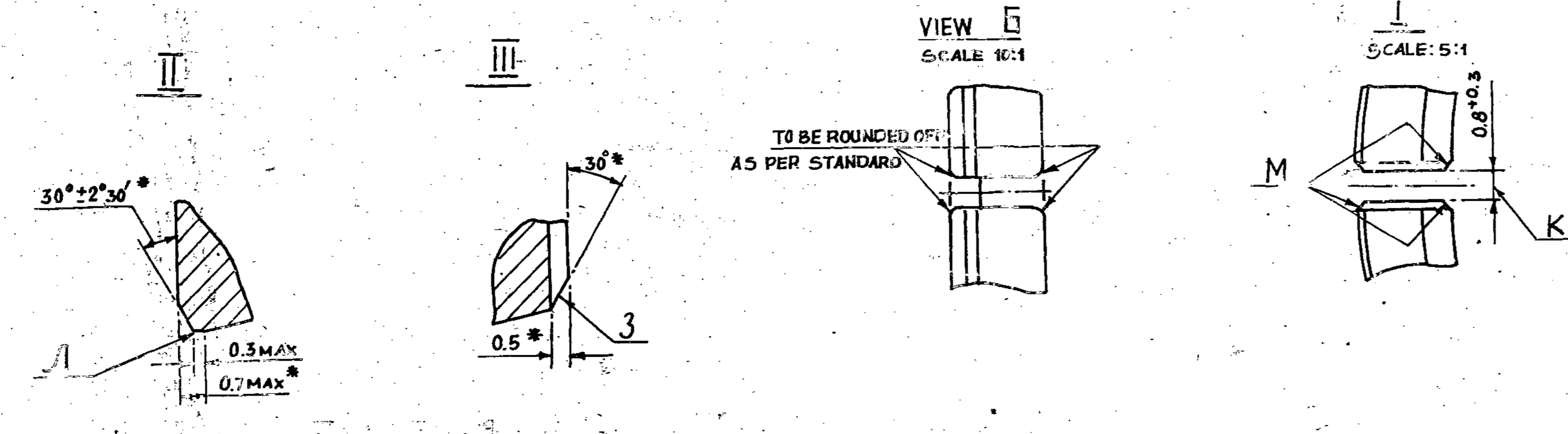
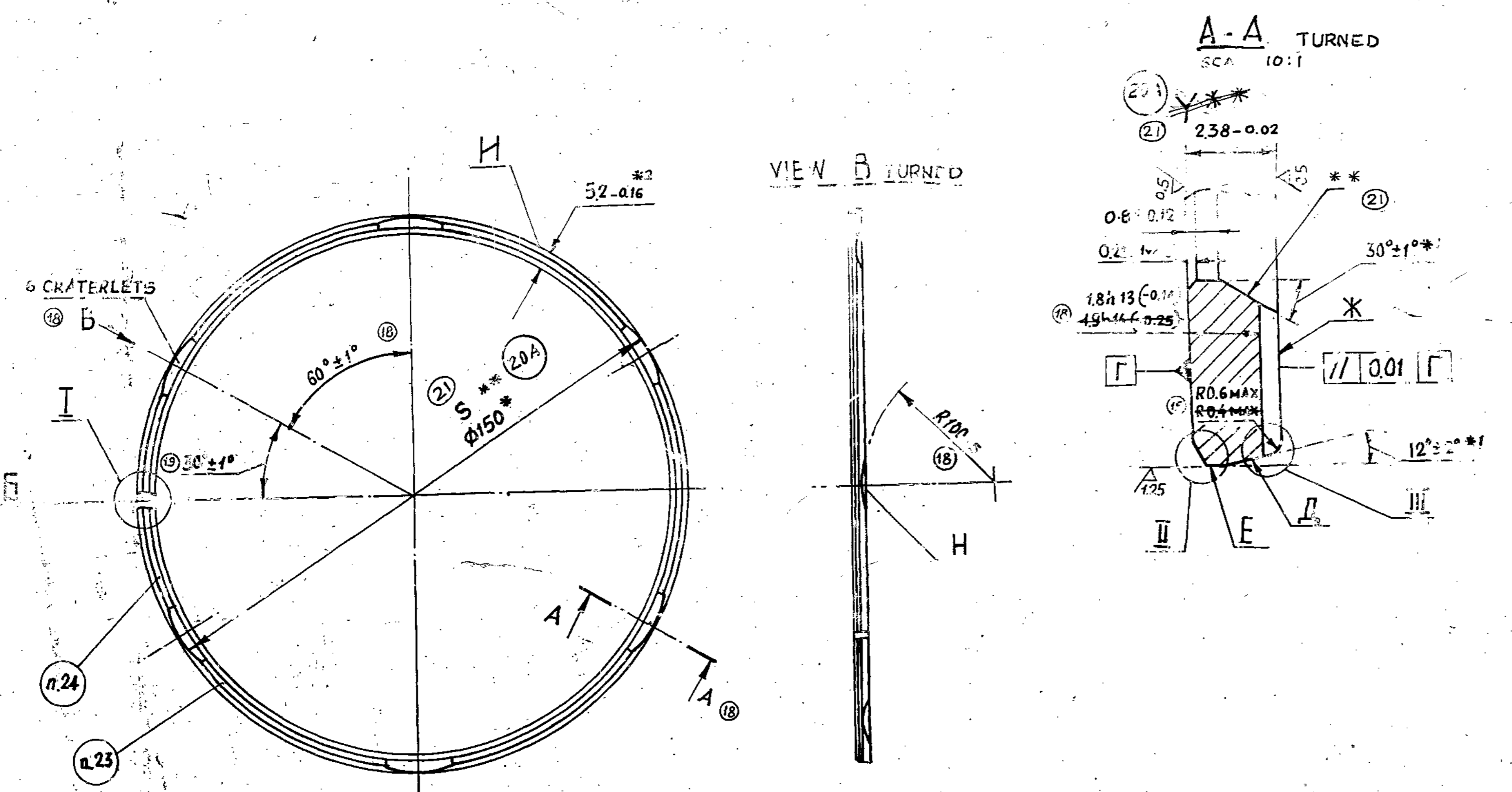
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

EST. MASS TO BE STAMPED OR MARKED WHERE INDICATED IN THIS DRAWING

0.04 kg.

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

DRN	EHD	TCC	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IN 2102-69	TITLE	D S CAT NUMBER	DRAWING NUMBER
				23.8.87	4:1			OIL SLINGER RING PISTON		3304-08-9
MATERIAL : WIRE 3.1x7.5 TY 14-4-229-72						USED ON : C6 3304-01-Bc6		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI		
AUTHY LT No. 83353/CQA(CVE)/IND IV dt 6-12-94						V46-6/IND IV dt 31-1-92		NATURE OF AMENDMENTS		
24	10-12-94									
23A	19-3-92									
ISSUE	DATE									



20A ** REPAIR SIZE DIMENSIONS 21

DRAWING NUMBER	X	Y
3304-08-11 R1	DIA 150	2.68-0.02
3304-08-11 R2	DIA 150.2	2.38-0.02
3304-08-11 R3	DIA 150.2	2.68-0.02

21 ** REPAIR SIZE DIMENSIONS

CATEGORY	DIMENSION 'S'
3304-08-11-R1	150.10
3304-08-11-R2	150.20

- INSPECTION GROUP III AS PER TT-11.
- HRC₃ 21 TO 29. WITH HRC₃ ≤ 22 MEASUREMENTS ARE TO BE TAKEN ON SCALE 'B' IN THIS CASE HRB ≥ 96.
- REQUIREMENTS TO BLANK AS PER TY 14-4-229-72.
- DIFFERENCE IN DIMENSION 'U' SHOULD NOT EXCEED 0.1mm BEFORE CHROMIUM MOLYBDENUM COATING.
- ROUGHNESS OF SURFACE 'E' AFTER CHROMIUM MOLYBDENUM COATING IS TO BE PERMISSIBLE ON OIL SLINGER SURFACE.
- CRACKS, ROUGH SPOTS, DENTS AND METALLURGICAL DEFECTS ARE NOT PERMISSIBLE ON OIL SLINGER SURFACE.
- COATING OF SURFACES 'A' AND 'E', Cr. Mo. AS THICK AS 60-120 MICRONS AS PER 117-212-76. COATING IS TO BE APPLIED IN COMPRESSED STATE.
- TO BE COATED WITH Cr. Mo. AFTER CHROMIUM MOLYBDENUM ALLOY IS APPLIED TO AS PER 117-212-76.
- HV 550-800 FOR SURFACE 'A' AND 'E' AFTER CHROMIUM MOLYBDENUM ALLOY IS APPLIED, TO BE CHECKED AS PER 117-212-76.
- DIFFERENCE IN TOTAL THICKNESS OF CHROMIUM MOLYBDENUM LAYER FOR ONE SLINGER SHOULD NOT EXCEED 0.04 mm.
- SPALLING OF CHROMIUM MOLYBDENUM LAYER IS NOT ALLOWED.
- CHROMIUM MOLYBDENUM COATING MAY NOT BE APPLIED ON TO SURFACE '3'.
- SHARP EDGE IS TO BE PROVIDED ALONG THE ENTIRE PERIMETER OF THE FINISHED SLINGER AT PLACE 'J', BURRS ARE NOT ALLOWED.
- BEFORE COATING WITH CHROMIUM MOLYBDENUM ALLOY THE RING SHOULD BE CHECKED FOR DEFECTS BY MAGNETIC FIELD FLAW DETECTOR AND DEMAGNETIZED.
- CHIPPING OF CHROMIUM MOLYBDENUM COATING IS ALLOWED ON SURFACE 'A' AT PLACES 'H' UP TO 0.8 mm FROM SURFACE 'K' TO BE ACCEPTED AS PER STANDARD.
- PLACES 'M' ARE TO BE BLUNTED ON 2 SIDES TO RADIUS OR CHAMFER 0.3 TO 0.6 mm TO BE ACCEPTED AS PER STANDARD.
- RING GAP IS 18 TO 23 mm IN A FREE STATE.
- ELASTICITY OF RING ON A BAND DEVICE 18...25N (1.8...2.5 kgf) WITH DIMENSION K.
- DIMENSION K FOR NOMINAL DIAMETER.
- RADIAL CLEARANCE BETWEEN THE SLINGER AND CALIBRATED WASHER φ150^{+0.013} mm WITH TOLERANCE FOR OVALITY OF CALIBRATED WASHER NOT MORE THAN 0.0025 mm (SEMI-DIFFERENCE OF DIAMETER) MAY BE 0.02 mm OVER AN ARC OF 45° AT ONE PLACE OR AT 2 PLACES WITH TOTAL ARC UP TO 45° WITH SUBSEQUENT SMOOTH MERGING TO BOTH SIDES TO ZERO, CLEARANCE WITH 0.01 mm IS ALLOWED ON ONE OR 2 SIDES OF THE LOCK GAP OVER A LENGTH UP TO 8 mm GAP TO BE ACCEPTED AS PER STANDARD.
- DEVIATION FROM FLATNESS OF SURFACES 'Γ' AND 'K' TO BE CHECKED BY BLUEING BETWEEN TWO PLATES. THE WEIGHT OF TOP PLATE IS 1.7 kg, THE IMPRINT SHOULD BE UNIFORMLY SPREAD OVER AT LEAST 75% OF THE SLINGER FACE SURFACE. IN THIS CASE THE IMPRINT SHOULD BE 2 mm WIDE AND UNINTERRUPTED ALONG THE ENTIRE CIRCUMFERENCE. TO BE CHECKED AT RANDOM ON THE DEMAND OF QID BUT NOT LESS THAN 10%.
- 'TOP' IS TO BE MARKED.
- THE LAST THREE DIGITS OF COMPONENT NUMBER TO BE MARKED.
- DURING MARKING - SOLUTION N8 AS PER 117-581-85, TYPE J TO 2.5 GOST 2930-62.
- DIMENSIONS FOR REFERENCE.
- DIMENSIONS ARE TO BE ENSURED WITH TOOL.
- DIMENSIONS AFTER CHROMIUM MOLYBDENUM COATING.
- BUCKLING OF SLINGER IS TO BE CHECKED AFTER TIN PLATING, BY PASSING IT THROUGH THE SLOT FIXTURE, SLINGER SHOULD READILY PASS THROUGH THE SLOT IN THE FIXTURE BY GRAVITY, DIMENSION OF SLOT IS 2.44 ± 0.01 mm MARKS FROM MEASURING TOOL (SLOT) ARE ALLOWED ON SURFACES 'K' AND 'Γ'.

- ** 29A. CHECK SIZE 'K' USING THE FOLLOWING SIZED WASHERS:
- 21 - WITH A DIAMETER OF 150.10^{+0.013} mm FOR RING 3304-08-11 R1.
 - 21 - WITH A DIAMETER OF 150.20^{+0.013} mm FOR RINGS 3304-08-11 R2, R3.
- ** 29B. MARKS R1, R2, R3 TO BE APPLIED WITH RESPECT TO THE REPAIR SIZE CATEGORY USING SOLUTION NO. 5 PREPARED ACCORDING TO 117-16-73. LETTERING 110-3, GOST 2930-62.

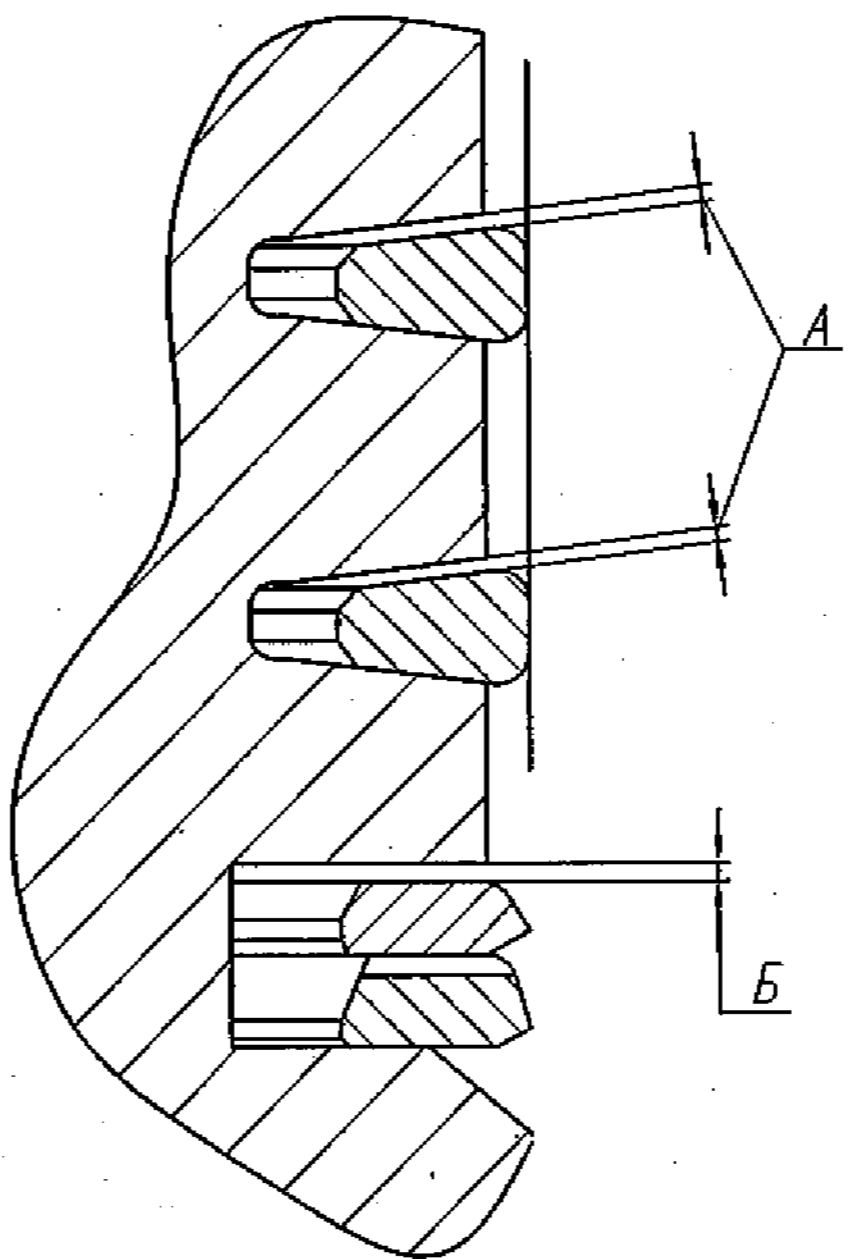
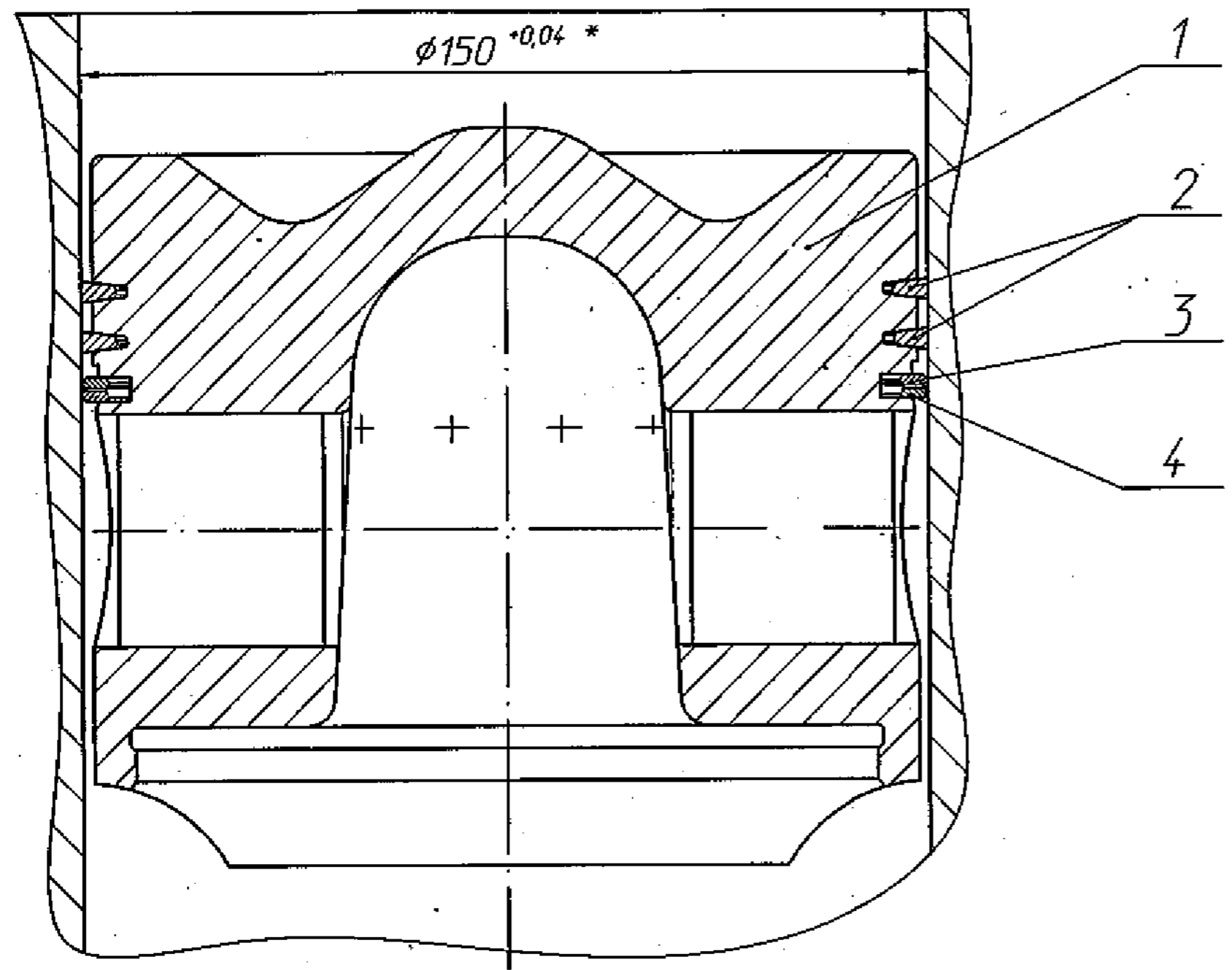
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

EST. MASS 0.037 kg TO BE STAMPED OR MARKED WHERE INDICATED THUS * (LETTERS)

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

DRN	MATERIAL	USED ON
CHD	WIRE 3.1 x 7.5	3304-01-8 05
TCD	TY 14-4-229-72	
APPD	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
DATE	29.8.87	
SCALE	1:1	
DIMENSIONS IN mm		
TOLERANCE ON DIMS UNLESS OTHERWISE STATED.		
21	10.12.84 AUTHY LT. No. 63353/COA (Cve)	
20A	19.3.92 vide Authy Let No 83353/ V46-6/IND 04 31-1-92	
ISSUE	DATE	NATURE OF AMENDMENTS
TITLE: OIL CONTROL RING, PISTON		
D S. CAT NUMBER		DRAWING NUMBER
		3304-08-11

INSPECTION
DIAGRAM
Схема контроля



1. При надевании колец на поршень пользоваться специальным приспособлением. Максимальный развод кольца в приспособлении не более 41 мм.
2. При надевании колец на поршень маркировка "Верх" должна быть обращена в сторону камеры сгорания.
3. После комплектовки поршневых колец на поршне произвести проверку на закусывание всех колец в канавках. Кольца при перемещении в канавках не должны заклиниваться.
4. Зазор А 0,13...0,07 мм в плоскости перпендикулярной оси поршневого пальца замерять в специальном приспособлении - гильзе с окнами. Замеры производить без колец в 3^й канавку поршня прижать к стороне гильзы, где производятся замеры.
5. Зазор Б 0,10 мм, не более, замерять на поршне.
6. * Размер для справок.

1. During putting-on ring on piston, special fixture is used. Maximum opening of ring in fixture should not be more than 41 mm.
2. During putting-on ring on piston, marking sign "Top" should be to the side of afterburner chamber.
3. After group setting of piston ring on piston, carry out checking of all rings for free rotation in grooves. During moving of rings in grooves, rings should not be locked.
4. Measure clearance A 0.13 ... 0.07 mm in the plane perpendicular to the axis of piston pin with special liner fixture with openings. Carry out measurements without rings in 3rd grooves of piston, press the piston to the side of liners, where measurements are taken.
5. Measure clearance B 0.10 mm maximum on piston.
6. * Dimension for reference.

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Изм.	Лист	№ докум.	Подп.	Дата
Trans. & Ckd. by: M/s SWYAZ				
Authenticated by:				
Approved by:				
Engine Factory, Avadi				

сб. 304-01-1 СБ		
Letter	weight	scale
Лит.	Масса	Мг
01	3,227	
PISTON WITH RINGS Поршень с кольцами Сборочный чертеж		
Assembly drawing		
Sheet	Sheets	
F-3	43	
Формат А4 х 3		