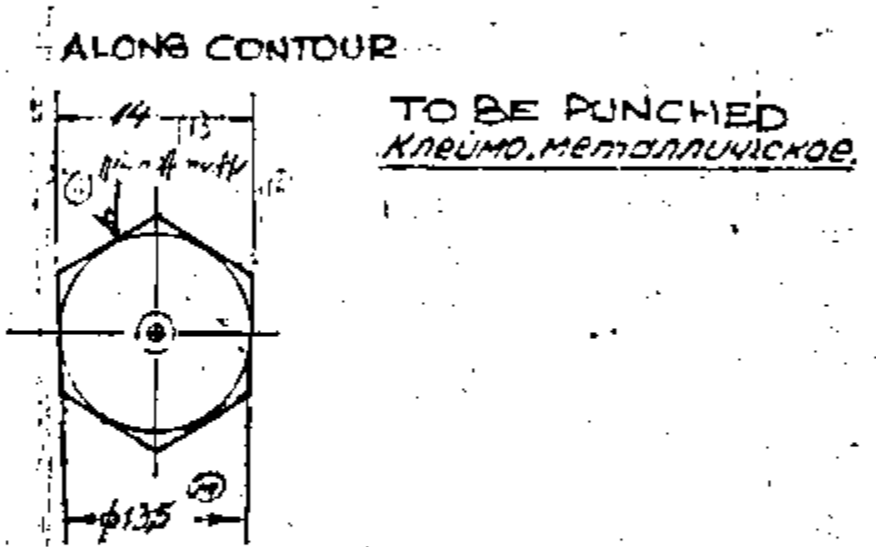
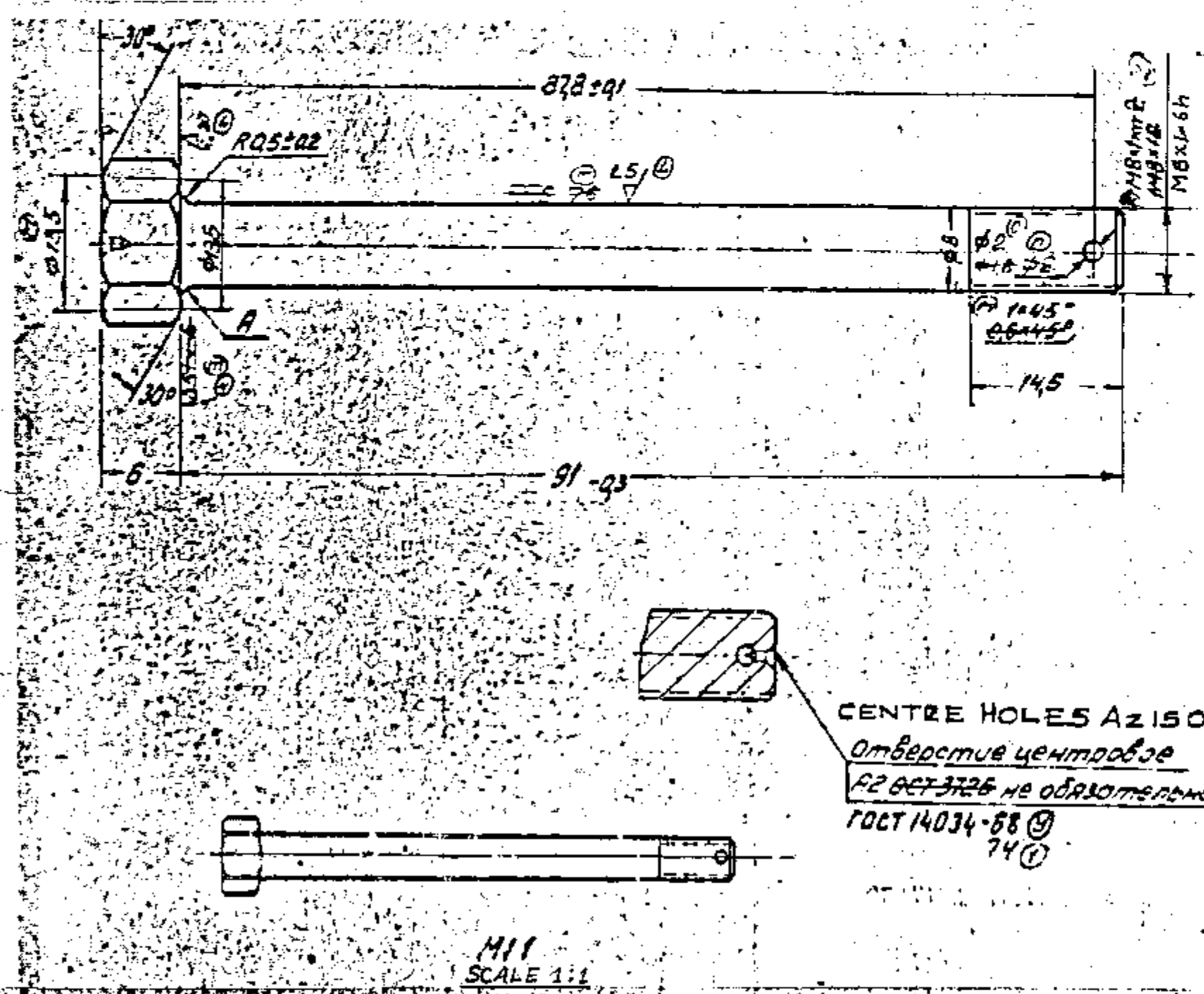


Rz20



1. Inspection group III as per instructions TT 11
2. HRC 28 - 35
3. Dimensions without tolerances should be implemented as per accuracy class 7, OST 1010.
4. Technical requirements for thread should be as per standard 82021-00.
5. Metallurgical defects are not allowed.
6. Sharp edges should be blunted.
7. Coating - Chemical oxidizing, oil finishing.
8. Bolt may be manufactured from material 40 CX.
9. Thread may be made by rolling with a diameter of non-threaded part being within the pitch diameter of thread
10. Tool mark upto 2 mm wide with projection or depression not exceeding 0.15 mm and surface finish Rz20/1s allowed at place A.

CENTRE HOLES AS IS OPTIONAL  
 Отверстие центральное  
 по ГОСТ 3726 не обязательно.  
 ГОСТ 14034-68  
 74

M11  
 SCALE 1:1

**EXPLANATORY NOTE:-**

MATERIAL QUOTED: HEXAGON: 14-4 GOST 8560-78  
 38XA GOST 4543-71

14 = CROSS FLATS ; 4 = CLASS OF ACCURACY.

38XA = GRADE OF MATERIAL (HIGH QUALITY STEEL)

BRIGHT STEEL HEXAGONAL BAL

**CHEMICAL COMPOSITION %**

- CARBON = 0.35-0.42
- SILICON = 0.17-0.37
- MANGANESE = 0.50-0.80
- CHROMIUM = 0.80-1.10
- PHOSPHORUS = 0.025
- SULPHUR = 0.025
- COPPER = 0.30
- NICKEL = 0.30

MAXIMUM

**MECHANICAL PROPERTIES:**

- ULTIMATE STRENGTH kgf/mm<sup>2</sup> (MIN) = 95
- YIELD POINT kgf/mm<sup>2</sup> (MIN) = 80
- RELATIVE ELONGATION % (MIN) = 12
- RELATIVE REDUCTION ALONG CROSS SECTION % (MIN) = 50
- IMPACT STRENGTH kgfm./cm<sup>2</sup> (MIN) = 9

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

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

EST. WT. 0.040 kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS # LETTERS!
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R CUT-SEE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

DRN	19/11	MATERIAL - HEXAGON	USED ON
CHK	12/11	14-4 GOST 8560-78	CS 3305-03-15
APP	13/11	38XA GOST 4543-71	
DATE	24-2-85	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLE)	
SCALE	2:1	AVADI	
DIMENSIONS IN mm.		TITLE	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69		MAIN JOURNAL PLUG BOLT	
ISSUE	18.5.09	Authy: Third Alt. Comm. Minutes Point: 2 Dated 27-02-2009.	D S CAT NUMBER
DATE		NATURE OF AMENDMENTS	DRAWING NUMBER
			305-11

EXPLANATORY NOTE ADDED ON 22-12-91