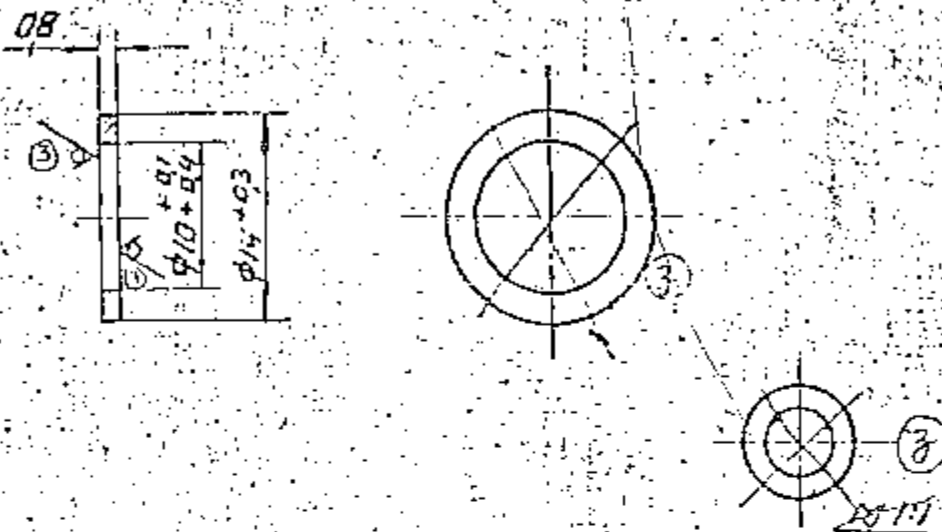


327-94-1

KVD No. 63525

DRG. INDIANISED BASED ON RUSSIAN - ORIGINAL
ISSUE 3 (BK03-11)

1	15-2-83	15-2-83	15-2-83	15-2-83	15-2-83
2	15-2-83	15-2-83	15-2-83	15-2-83	15-2-83
3	15-2-83	15-2-83	15-2-83	15-2-83	15-2-83
4	15-2-83	15-2-83	15-2-83	15-2-83	15-2-83
5	15-2-83	15-2-83	15-2-83	15-2-83	15-2-83
6	15-2-83	15-2-83	15-2-83	15-2-83	15-2-83
7	15-2-83	15-2-83	15-2-83	15-2-83	15-2-83
8	15-2-83	15-2-83	15-2-83	15-2-83	15-2-83
9	15-2-83	15-2-83	15-2-83	15-2-83	15-2-83
10	15-2-83	15-2-83	15-2-83	15-2-83	15-2-83



- 1) Группа контроля IV по ТТ-11
- 2) Твердость HRC = 73-75
- 3) Требования, предъявляемые к штамповке, по нормам 82050-16.
- 4) После штамповки править.
- 5) Острые края затупить.
- 6) Оксидировать. Покрытие Хим. Окс. прм.
- 7) Неплоскостность не более 0,1мм.
- 8) Зависцы и острые крошки не допускаются.

- 1) INSPECTION GROUP IV AS PER TECHNICAL REQUIREMENTS TT-11
- 2) HRA 73 ... 75
- 3) REQUIREMENTS FOR BLANKING AS PER STANDARD 82050-16.
- 4) COATING : CHEMICAL OXIDIZING , OIL FINISHING.
- 5) NON-FLATNESS SHOULD NOT EXCEED 0.1mm.
- 6) BURRS AND SHARP EDGES ARE NOT ALLOWED.

EXPLANATORY NOTE

5. MATERIAL QUOTED : STRIP 65Г-0.8
GOST 2283-79

COLD DRAWN TOOL AND SPRING STEEL SHEETS.
65Г = GRADE OF STEEL AS PER GOST 1050-74
0.8 = THICKNESS OF STRIP

(a) CHEMICAL COMPOSITION : [AS PER GOST 1050-74] %
C = 0.62 - 0.70 , Si = 0.17 - 0.37 , Mn = 0.90 - 1.20
Cr = 0.25 [max] , P = 0.035 [max] , S = 0.040 [max]
Cu = 0.25 [max] , Ni = 0.25 [max]

(b) MECHANICAL PROPERTIES : [AS PER GOST 2283-79]
ULTIMATE TENSILE STRENGTH Kgf/mm^2 (min)
= 75 TO 120

% ELONGATION (MIN) = 15

(A) EQUIVALENT MATERIAL
75 C6 TO IS: 2507/EN 42 J BS: 970

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

EST. WT. TO BE STAMPED OR MARKED WHERE INDICATED THIS \neq (LETTERS)

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

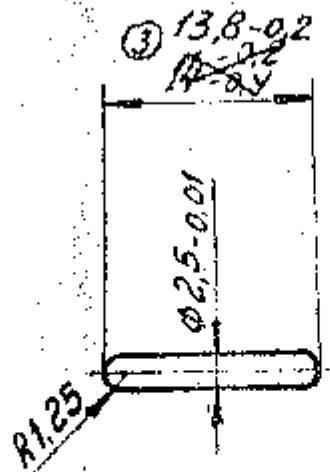
DRN		MATERIAL:- STRIP 65Г-0.8	USED ON cb 20-34-07
CHD	<i>[Signature]</i>	GOST 2283-79.	CB 327-15-5
TCO	<i>[Signature]</i>	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
APPB	<i>[Signature]</i>	AVADI	
DATE	15-2-83		
SCALE	2 : 1		
DIMENSIONS IN mm		TITLE	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69		TAPPET WASHER	
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
			327-94-1
ISSUE	DATE	NATURE OF AMENDMENTS	
A	16-08-10	4 th Alt. Comm. Meeting Minufes Point No.12 Dt: 26-10-09	

A-8
64

SIZE A3



DRAWING INDIANISED BASED ON ISSUE 1



① Допускается поставлять ролики с шероховатости по ГОСТ 6870-72 с разномерностью по диаметру 0,003 мм.

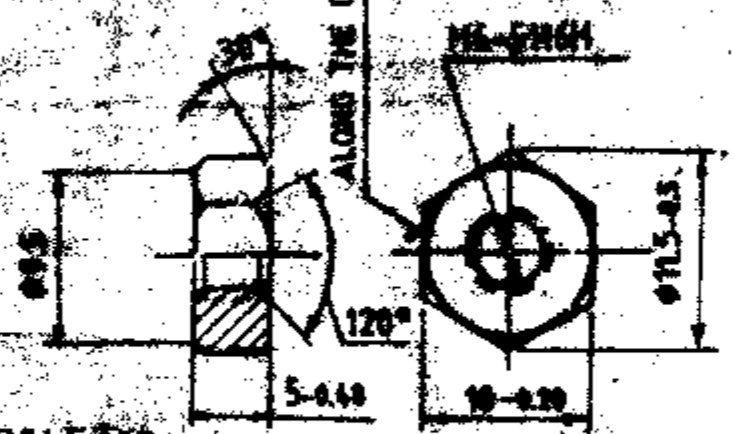
IT IS ALLOWED TO SUPPLY ROLLERS CLASSIFIED IN ACCORDANCE WITH GOST 6870-72 WITH VARIATION OF DIAMETER MEASUREMENTS 0.003 MM.

(A-8)

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS #
		0.0005 Kg.	LETTERS)
A	24-10-88	AUTHY BK02-313	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE - 2 : 1	MATERIAL: - USED ON:- CB 327 15-5 CB 315 662 3
CHO		DIMENSIONS IN mm.	CONTROLLER OF INSPECTION (HEAVY VEHICLES) AVADI
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE:- ROLLER 2.5 x 13.8A3 (A)
APPD		ALL THREADS CONFORM TO	D S CAT NUMBER
DATE	11-5-86		DRAWING NUMBER 327 95



DRG. INDIA NISED. BASED ON RUSSIAN ORIGINAL ISSUE. NIL
 COMMON TO V-9202 & UTD - 20 ENGINES
 AND No. 75016



DELETED

THE THREAD MAY BE CHECKED BEFORE COATING.

DELETED

COATING: CAP. CHROMATIZING, AS PER ULLJ-104 WITH ELIMINATION OF HYDROGEN BRITTLING.

THE REST OF THE TECHNICAL REQUIREMENTS AS PER STANDARD 1052-76

REFERENCE MATERIAL: STEEL GRADES 40 AND 50 GOST 1050-76. BILLED STOCK OF GROUP B CLASS 4, GOST 1051-73 MAY BE USED.

TO ENSURE HIGH QUALITY OF COATING IT IS ALLOWED TO ELIMINATE SURFACE DEFECTS OF BILLED STOCK WITH DECREASE OF DIMENSION AS PER ACCURACY CLASS 5.

MATERIAL: STEEL 709 M40 (EN19)
 TO BS: 970 PL-I-1983

CB 20-01-00-5, CB 20-06-12-6, CB 20-06-13-6, CB 20-09-07, CB 20-11-01-9, CB 20-12-01-13
 CB 20-10-07, CB 20-23-33-6, CB 20-23-34-6, CB 20-32-00-4, CB 20-08-00-7

CB 308-00-17, CB 320-00-33, CB 407-7, CB 401-10

CB 308-15-2, CB 310-00-14, CB 3320-00-43, CB 315-606-12
 CB 327-00-73, CB 315-777-2, CB 3334-00-47, CB 3335-00-9,
 CB 337-100

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

EST WT 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

ISSUE	DATE	NATURE OF AMENDMENTS
A	15-7-15	PL 11 of 17th Alt. Comm. Meeting Dt. 11-4-12
C	9-6-09	ALTN. COMM. MINUTES POINT 5 DATE 27-2-09
B	25.8.08	USED ON NUMBER ADDED
A	5-9-92	3 PA LT. 07263/ENG/P DO/395-4 dt 27-8-92

REFERENCE MATERIAL QUOTED:
 BRIGHT STEEL HEXAGON BAR 10mm A/F CLASS OF ACCURACY 4, (+0,000) TO GOST 1050-76, FROM HIGH GRADE SIZED STEEL 45, SURFACE QUALITY B TO GOST 1051-73 AND MANUFACTURED IN ACCORDANCE WITH QUALITY CARBON STRUCTURAL STEEL GRADE 45 AND REFERENCE NOTE 4, ON ALTERNATE MATERIALS STEEL GRADES 40 AND 50 TO GOST 1050-76.

a) CHEMICAL COMPOSITION AS PER GRADES 45, 40 & 50 TO GOST 1050-76.

GRADE OF STEEL	CONTENT OF ELEMENTS %						REMARKS
	C	Si	Mn	Cr	S	P	
45	0.42-0.50	0.17-0.37	0.50-0.80	0.25	0.040	0.035	Ref, Matl
40	0.37-0.45	0.17-0.37	0.50-0.80	0.25	0.040	0.035	Alt, Matl
50	0.47-0.55	0.17-0.37	0.50-0.80	0.25	0.040	0.035	Alt, Matl

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH

b) MECHANICAL PROPERTIES UNDER NORMALISED CONDITION:

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	YIELD POINT Kgf/mm ²	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH Kgm/cm ²	HARDNESS BHN MAX	RE-MARKS
45	61	36	16	40	5	223	Ref Matl
40	58	34	18	45	6	217	Alt Matl
50	64	38	14	40	4	241	Alt Matl

CB 20-27-00-4, CB 3335-00-16, CB 3335-401-10
 CB 447-00-1, CB 3335-00-7, CB 3335-00-30

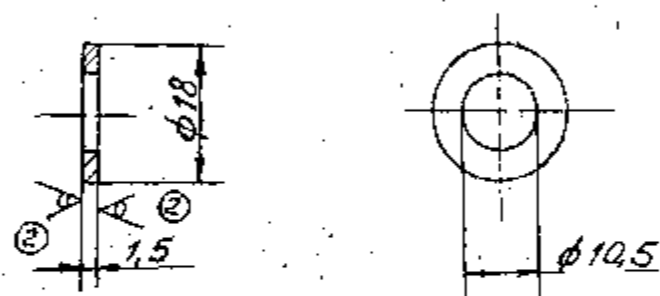
DRN	CHO	TCD	APPO	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	MATERIAL: HEXAGON BAR GOST 1050-76	USED ON: CB 332-100-3 CB 327-00-73 CB 327-00-45 CB 402-33-1
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI								TITLE: NUT M6	
D S CAT NUMBER								DRAWING NUMBER: 351 06	



DRAWING NUMBER

353.07.1

02/00 ✓



2. Dimensions with unspecified tolerances - as per standard 82050-16.
3. The component should be straightened after stamping. Burre are not allowed.
6. Coating: Cd9, Chromating as per 2412-104 with elimination of Hydrogen embrittlement.
7. Alternate material: - Steel, grades 15, GOST 1050-74.
8. Required finishing of surfaces being stamped should be ensured by tool.

(A) EQUIVALENT MATERIAL
Gr: 0 IS:513-1994

EXPLANATORY NOTE:

1. REFERENCE MATERIAL QUOTED :

COLD ROLLED LOW CARBON STEEL STRIP HIGHLY COLD WORK 'B H' SURFACE
QUALITY GROUP '2' WITH TRIMMED EDGES NORMAL MANUFACTURING ACCURACY
1.5 (-0.11)mm THICK TO GOST 503-71 AND MANUFACTURED IN ACCORDANCE WITH
QUALITY CARBON STRUCTURAL STEEL GRADE 10 TO GOST 1050-74 AND REFERENCE
NOTE 7 ON ALTERNATE MATERIAL QUALITY CARBON STRUCTURAL STEEL STRIP/STEEL
GRADE 15 TO GOST 1050-74.

a) CHEMICAL COMPOSITION AS PER GOST 1050-74.

GRADE OF STEEL	CONTENT OF ELEMENTS %						REMARKS
	C	Si	Mn	Cr	S	P	
10	0.07 - 0.14	0.17 - 0.37	0.35 - 0.65	0.15	0.040	0.035	Ref. Matl.
15	0.12 - 0.19	0.17 - 0.37	0.35 - 0.65	0.25	0.040	0.035	Alt. Matl.

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH.

b) MECHANICAL PROPERTIES : FOR 'BH' CONDITION AS PER GOST 503-71.

ULTIMATE TENSILE STRENGTH - - - - - 55. Kgf/mm² (Min)

i) MECHANICAL PROPERTIES AS PER GOST 1050-74.

CONDITION OF MATERIAL	GRADE OF STEEL	U T S Kgf/mm ²	YIELD POINT Kgf/mm ²	ELONGATION %	REDUCTION IN AREA %	REMARKS
NORMALIZED	15	38	23	27	55	Alt. Matl.

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

EST WT TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)
0002 Kg

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

DRN	<i>Handwritten</i>	MATERIAL	USED ON
CHD	<i>Handwritten</i>	GOST 503-71	30
TCD	<i>Handwritten</i>	STRIP 10-BH-2-15	05/335 00 24
APPD	<i>Handwritten</i>	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
DATE	05-10-86		
SCALE	1:1		
DIMENSIONS IN mm		TITLE	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69		BRIGHT WASHER 10	
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
			353.07.1

ISSUE DATE NATURE OF AMENDMENTS

KVD No.-78675

SIZE A3

A-11



DRW NUMBER

353-11

5. REFERENCE MATERIAL QUOTED :

Rz80

EXPLANATORY NOTE :

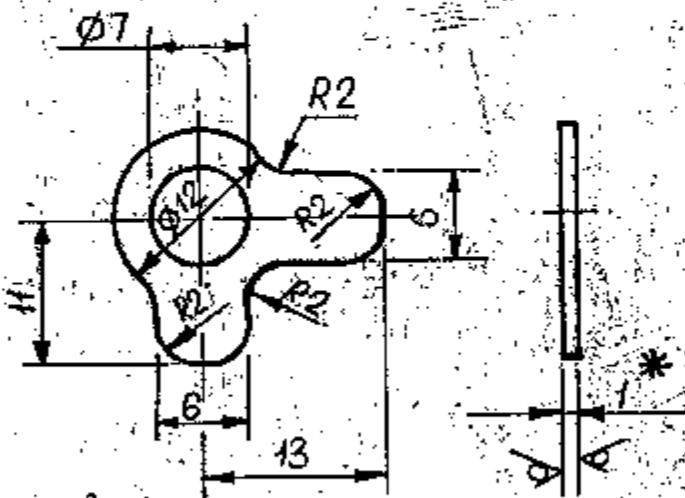
a) COLD ROLLED LOW CARBON STEEL TAPE OF STEEL GRADE - 08 ΠC (SEMI-KILLED), CONDITION OF MATERIAL - SOFT (M), WITH 2nd GROUP OF APPEARANCE AND SURFACE QUALITY (ROUGHNESS PARAMETER - $R_a \leq 1.25$ MICRON) AND THICKNESS 1mm.

b) CHEMICAL COMPOSITION OF STEEL 08ΠC TO GOST 1050-74.

CARBON %	SILICON %	MANGANESE (MAX) %	CHROMIUM (max)	SULPHUR (max)	PHOSPHORUS (max)	COPPER (max)	NICKEL (max)
0.05-0.11	0.05-0.17	0.35-0.65	0.70	0.040	0.035	0.25	0.25

c) PHYSICAL PROPERTIES :-

- (i) ULTIMATE TENSILE STRENGTH - 32-45 Kgf/mm²
- (ii) RELATIVE ELONGATION - 17 % (min)



1. REQUIREMENTS PLACED UPON STAMPING ARE AS PER STANDARD 82050-16.
2. STRAIGHTEN AFTER STAMPING.
3. COATING: ZINC-PLATED 9 MICRONS THICK, OILED, WITH REMOVAL OF HYDROGEN EMBRITTLEMENT.
4. * DIMENSION IS GIVEN FOR REFERENCE.

(B) EQUIVALENT MATERIAL
Gr. 0 IS: 513-1994

**
(A) Cb 20-05-47-4, Cb 20-09-07
Cb 20-11-01-9, Cb 20-12-01-13,
Cb 3301-00-44, Cb 401-01,
Cb 315-662-16, Cb 315-777-2,
Cb 3301-00-37

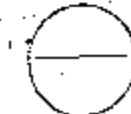
COMMON TO V-92S2 & JTD-20 ENGINES

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

EST. WT. 0.0011 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTERS)

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

DRN	CHD	TCD	APPD	DATE	SCALE	MATERIAL:- STRIP 08nc - M - 2 - 1 GOST 503-21	USED ON: C6 3338-401-10 C6 20-27-00-4 **
				24-4-1987	2:1	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES) AVADI	
					DIMENSIONS IN mm TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS:2102-69	TITLE LOCK WASHER 7	
					ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER 353-11
				ISSUE DATE	NATURE OF AMENDMENTS		

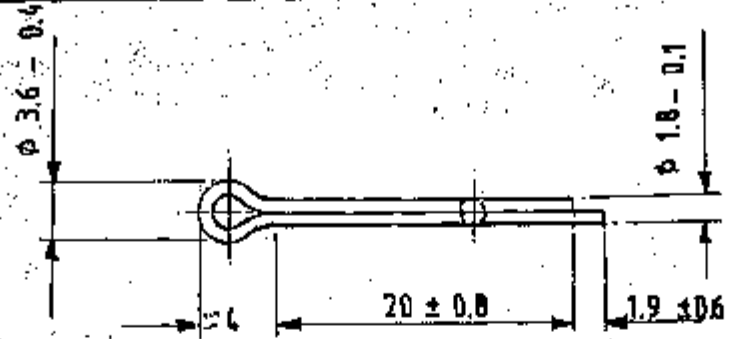


SIZE A3



DRAWING NUMBER
354-12 SHT 1 OF 2

F
E
D
C



SCALE 1:1

1. TO BE ANNEALED.
2. COATING CADMIUM 3. CHROMATIZING AS PER *Udel-104* WITH ELIMINATION OF HYDROGEN ENBRITTELEMENT.

Ⓐ EQUIVALENT MATERIAL
IS: 549

**
Cb 20-01-00-8
Cb 20-15-663-4
Cb 20-27-00-4
Cb 20-34-12
CQA (HV) 5.06.001E Ⓑ

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

		EST WT 1000 PIECES 0.479 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	
B	18-03-15	Pl. 11 of 7th Alt. Comm. Meeting Dt. 11-4-12	MATERIAL — USED ON Cb 334-73-1 Cb 315-662-3 Cb 315-663-21 ** SEE ABOVE
A	8-7-10	4th ALT. COMM. Mtg. MINUTES POINT No.3 DT. 26-10-09	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN	SCALE 2 : 1		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
CHD <i>Parikh</i>	DIMENSION IN mm		
TCD <i>Parikh</i>	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED		TITLE COTTER PIN 2 X 20
APPD <i>Parikh</i>	ALL THREADS TO CONFORM TO		D S CAT NUMBER
DATE	1-5-88		DRAWING NUMBER 354-12 SHT 1 OF 2

SIZE A4



DRAWING NUMBER

354-12 SHT 2 OF 2

ADDITIONAL REQUIREMENTS FOR COMPONENT NUMBERS:- 354-09, 354-09A, 354-12, 354-14, 354-15, 354-17, 354-18, 354-19, 354-20

1. SPLIT PIN MUST BE MANUFACTURED FROM LOW CARBON STEEL WITH MAXIMUM CARBON CONTENT 0.20% ON GOST 1050-74
2. BURRS, CRACKS, RUST ARE NOT ALLOWED ON THE SURFACE OF THE PIN & SHARP CUT ON THE BENDED HEAD ARE ALSO NOT ALLOWED.
3. PINS OF DIAMETER UPTO 5mm MUST WITHSTAND 3 BENDS WITHOUT ANY SIGN OF BREAKING.

(A)

EQUIVALENT MATERIAL IS: 549

**

CB 20-01-00 8

CB 20-15-663-4

CB 20-27-00-4

CB 20-34-12

(B) CQA (HV) 5.06.001E

(A-11)

EST. WT

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

MATERIAL

USED ON ** SEE ABOVE
CB 315-663-3
CB 315-663-27
CB 334-73-1

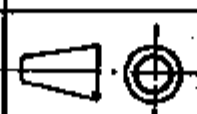
B	18-03-15	Pt. 11 of 71th Alt. Comm. Meeting Dt. 11-4-12
A	8-7-10	4 th ALT. COMM. Mtg. MINUTES POINT No 3 DT. 26-10-09

ISSUE DATE NATURE OF AMENDMENTS

DRN SCALE DIMENSIONS IN mm

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI

CHD TOLERANCE ON DIMNS UNLESS OTHERWISE STATED



TITLE

COTTER PIN 2x20

APPD ALL THREAD CONFORM TO

D.S CAT NUMBER

DRAWING NUMBER

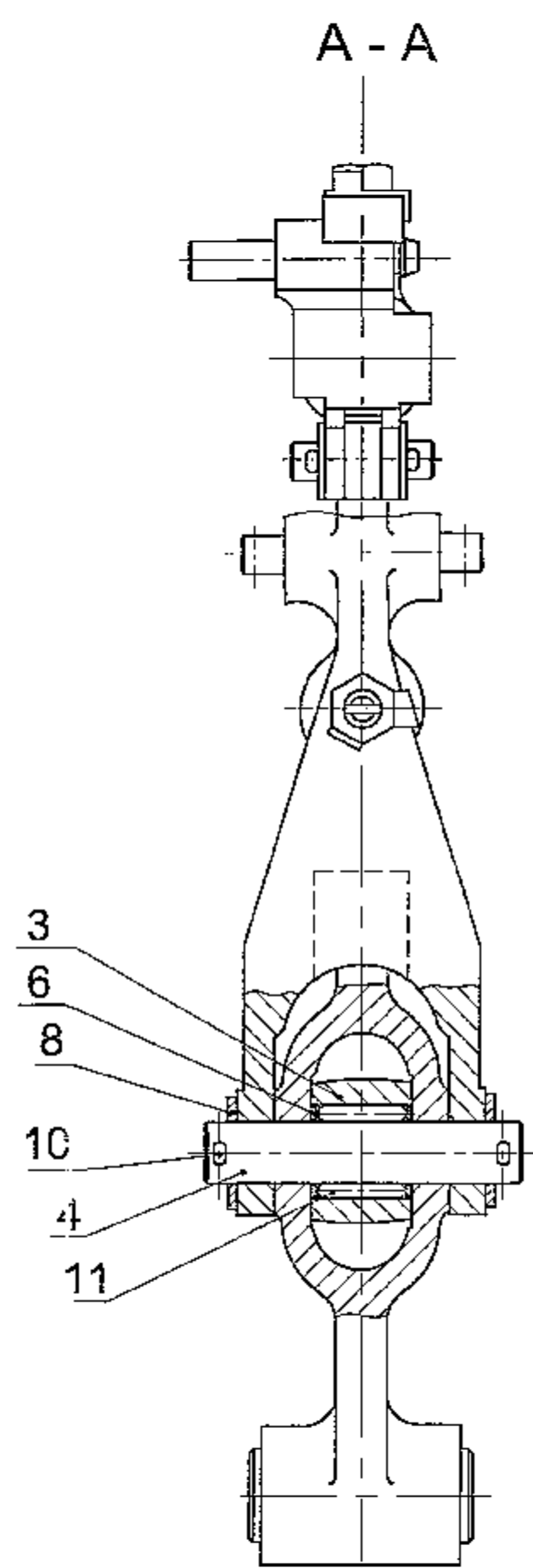
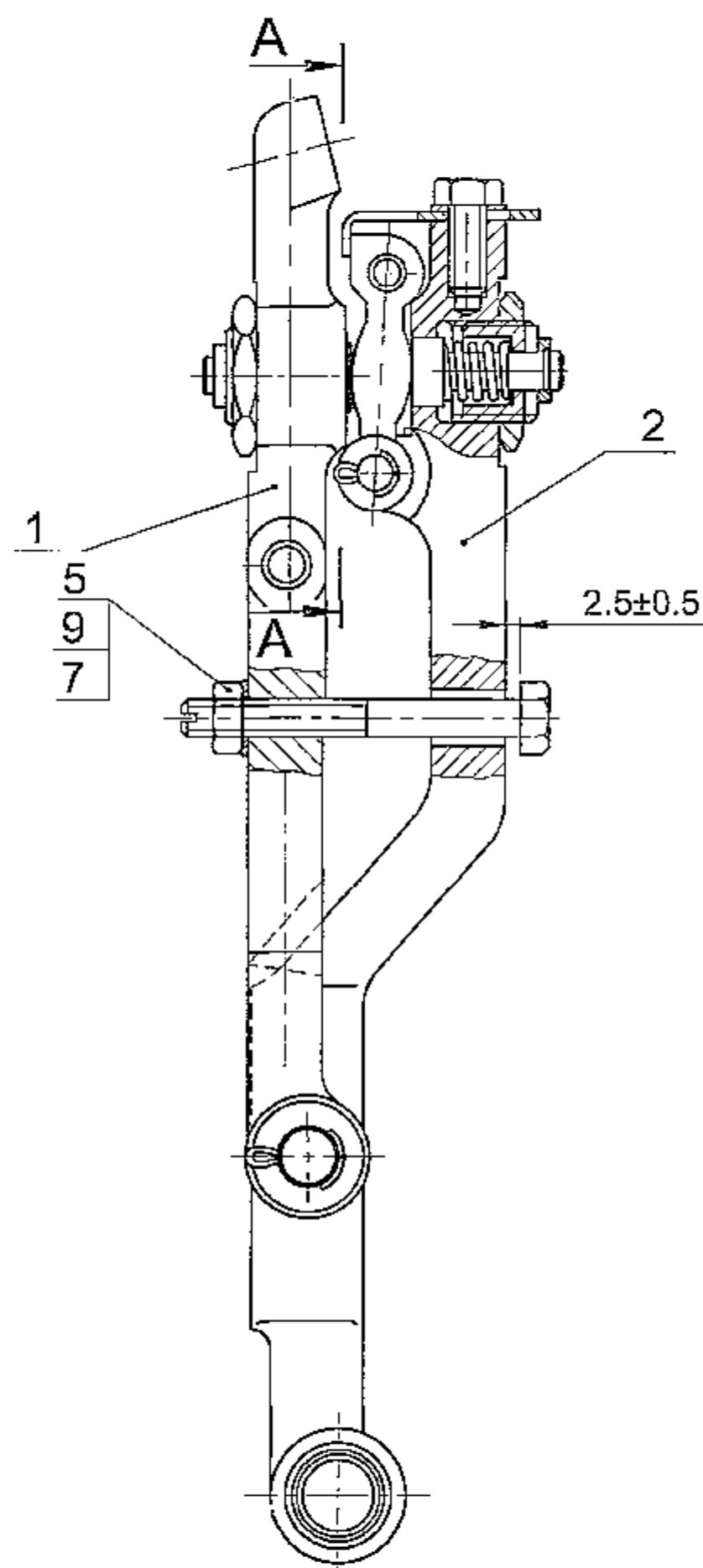
DATE 11-5-12

354-12 SHT 2 OF 2

SIZE A4



DRAWING NUMBER
Cb.315-777-2



- 1. In assembled unit, (parts item 11) should have one sorted tolerance within the limits of 0.003mm
- 2. Roller (item 3) should rotate smoothly without jamming.
- ④ 3. Power lever item 1 should be moved in relation to main lever item 2 without jamming.

DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 3

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

EST WT 0.74 Kg	TO BE STAMPED ON: MARKED WHERE INDICATED THUS # (LETTERS)
-------------------	---

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

DRN	CHD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69	ALL THREADS TO CONFORM TO
			16/3/07	1:1			
				MATERIAL -		USED ON -	
						Cb 327-00-33	
				CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)			
				AVADI			
				TITLE -		DRAWING NUMBER	
				GOVERNER LEVERS ASSY.		Cb.315-777-2	
				D S CAT NUMBER			
4	10.11.08	NOTN NO- 2002-168 (F-158)					
ISSUE	DATE	NATURE OF AMENDMENTS					

F-5
45
283
SIZE A2



USED ON

Cb 327-00-73

I/L CREATED BASED ON RUSSIAN ORIGINAL ISSUE - 2

ZONE	ITEM NO	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	QTY	REMARKS
		Cb.315-777-2		GOVERNOR		
		ITEM LIST		LEVER ASSY.		
	1	Cb.315-659-2 & I/L		LOAD BEARING	1	
				LEVER ASSY.		
	2	Cb.315-662-16 & I/L		MAIN GOVERNOR	1	
				LEVER ASSY.		
	3	315-622-2		ROLLER	1	
	4	315-635-4		LEVER PIN	1	
	5	315-790		BOLT M6 x 55	1	
	6	327-94-1		TAPPET WASHER	2	
	7	351-06		NUT M6	1	
	8	353-07-1		BRIGHT WASHER 10	2	
	9	353-11		LOCK WASHER 6	1	

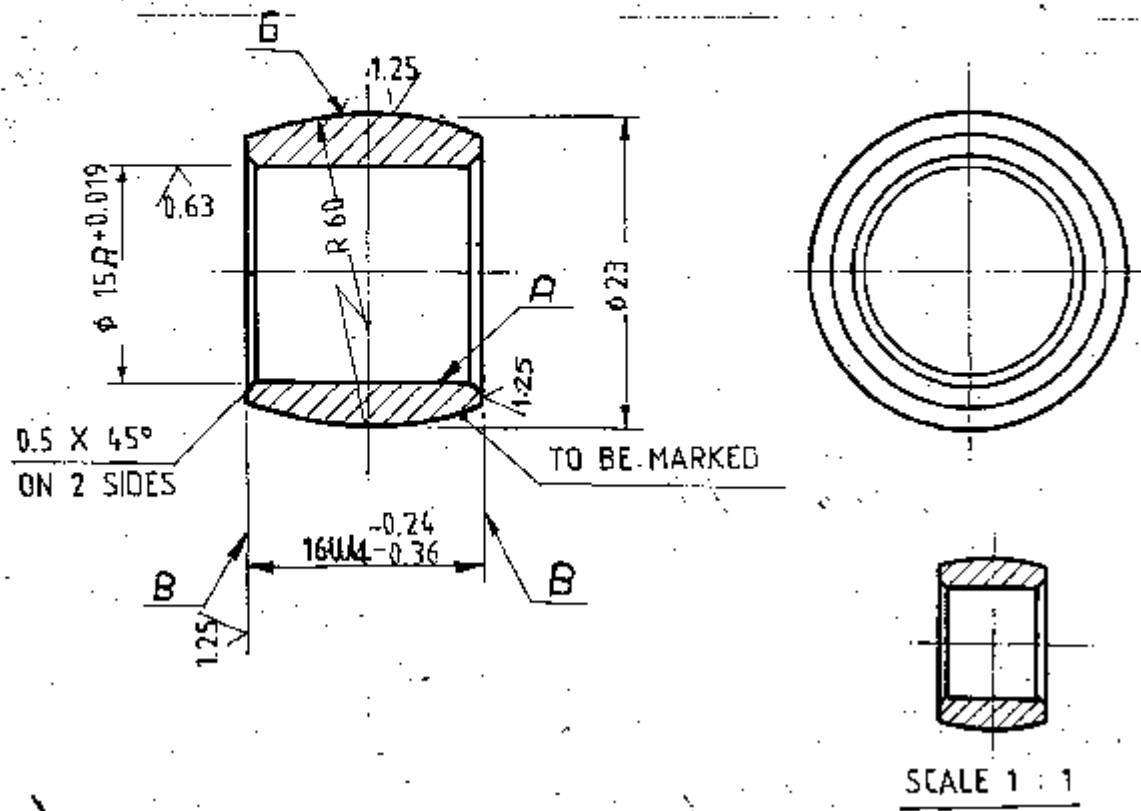
ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS
DRN			CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.		
CHD			TITLE :		
APPD			GOVERNOR LEVER ASSY.		
DATE	11. 5. 07	SHT. NO. 1 OF 2	D S CAT NUMBER	ITEM LIST FOR Cb.315-777-2	

F-5

43/283

DRAWING NUMBER
315-622-2

✓(✓)



1. INSPECTION GROUP III, TT-11.
2. DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE OBTAINED AS PER A7 OR B7 GOST 1010.
HRC₃₆₁..... 64
3. ~~HRC = 60-63~~
4. RUN-OUT OF SURFACES "B" RELATIVE TO SURFACE "A" SHOULD NOT EXCEED AT DIA. 18mm.
5. RUN-OUT OF SURFACE "6" RELATIVE TO SURFACE "A" SHOULD NOT EXCEED 0.05mm.
6. SHIFT OF SPHERE CENTRE FROM THE AXIS OF SYMMETRY OF SURFACES "B" SHOULD NOT EXCEED 0.3mm.
7. SHARP EDGES SHOULD BE BLUNTED.
8. COATING :-CHEMICAL OXIDIZING, OIL FINISHING.

EXPLANATORY NOTE :

(B) MATERIAL QUOTED: STEEL УХ15 GOST 801-78.
BALL BEARING STEEL WITH CHROMIUM (X) CONTENT 1.5% BY WEIGHT.

a) CHEMICAL COMPOSITION :

CARBON	= 0.95 - 1.05	COPPER	= 0.25 (max)
SILICON	= 0.17 - 0.37	NICKEL & COPPER	= 0.50 (max)
MANGANESE	= 0.20 - 0.40		
CHROMIUM	= 1.30 - 1.65		
SULPHUR	= 0.02 (max)		
PHOSPHORUS	= 0.027 (max)		
NICKEL	= 0.30 (max)		

* ROUND BLANK 25.5-Г-А GOST 14955-77
УХ 15-0-ХВ GOST 801-78

(C) EQUIVALENT MATERIAL
STEEL 535A 99 (EN31) TO BS: 970/103
CR 2 TO IS 4399-72

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

EST WT 0.0267 Kg TO BE STAMPED OR MARKED WHERE INDICATED THIS # LETTERS)

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

DRN	CHO	TCD	APPD	DATE	MATERIAL	USED ON
				08-5-86	УХ 15 GOST 801-78	CG 315-662-3
SCALE 2 : 1					CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI	
DIMENSION IN mm					TITLE	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED					ROLLER	
ALL THREADS TO CONFORM TO					DRAWING NUMBER	
ISSUE DATE NATURE OF AMENDMENTS					315-622-2	

DRAWING INDIANISED BASED ON ISSUE 3

KVD NO 78288

(A 6)

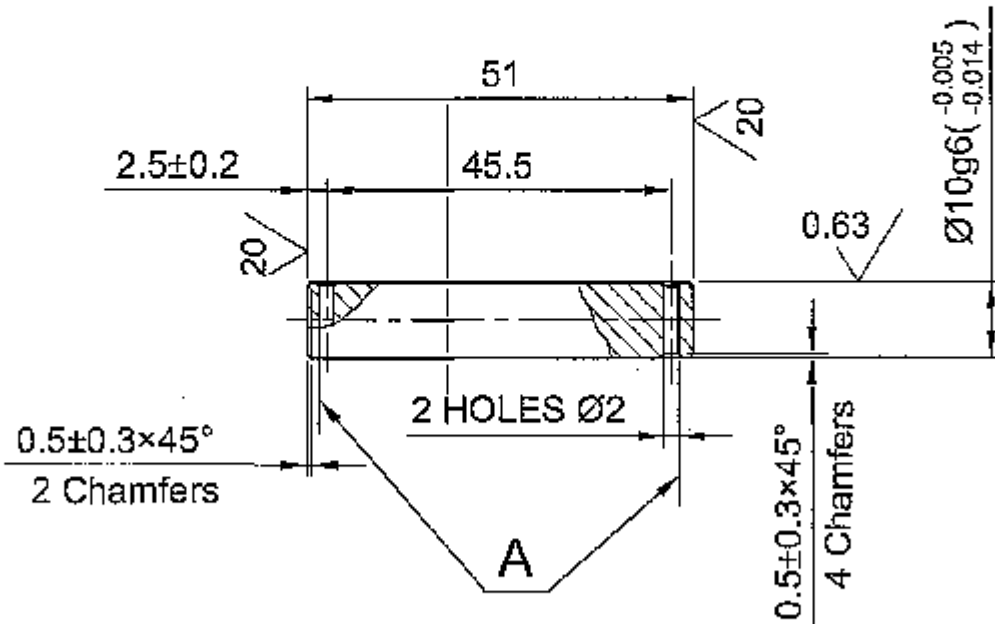
SIZE A3



DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 4

DRAWING NUMBER
315-635-4

10 ✓ (✓)



1. Inspection group is III as per IT-11.
2. Carryout Carburizing h 0.7...0.12 mm. HRC ≥ 59 . Protect surface A from carburizing.
3. Unspecified limit deviations of dimensions are: H14, h14, $\pm \frac{IT14}{2}$
4. It is allowed to execute hole $\varnothing 2^{+0.3}_{-0.1}$.
5. Chemically oxidised oiled coating is carried out as per instruction VJ-681-87.

F-5
71
283

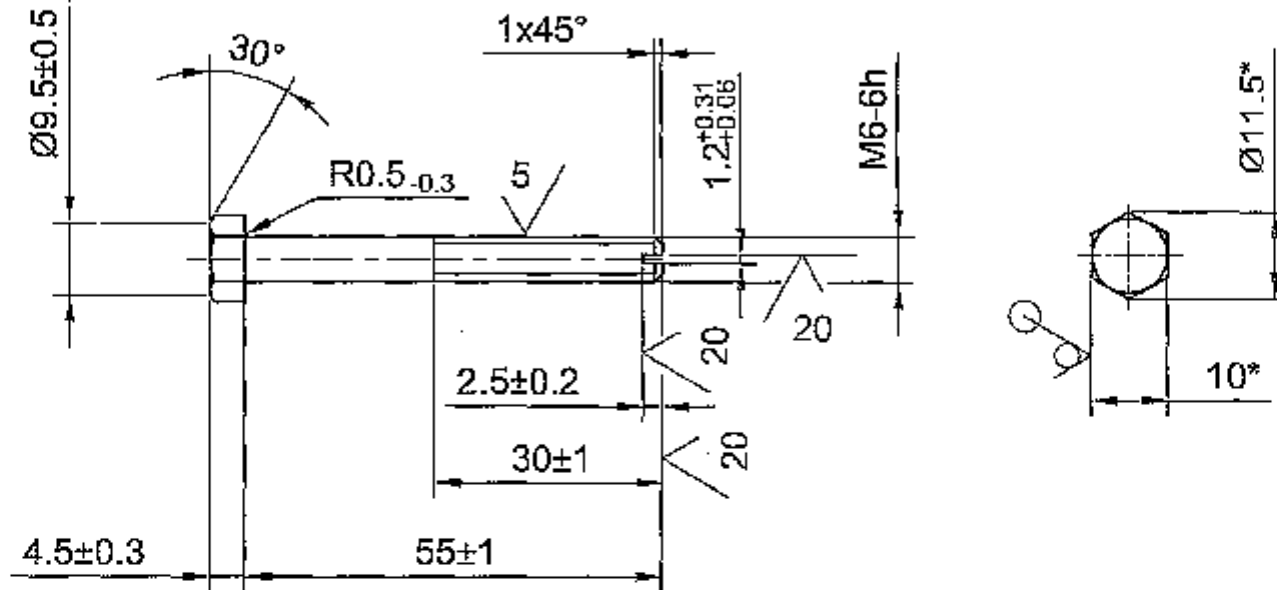
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

		EST. WT. (Kg) 0.03	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.	
		MATERIAL :- Round <u>11-h12 GOST 7417-75</u> 12XR3A-B-T TY 4-1-381-72	USED ON :- [5 315-777-2
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE :- 1:1	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI
CHD		DIMENSIONS IN mm	
APPD		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS : 2102 - 69	TITLE :- LEVER PIN
DATE		ALL THREADS TO CONFORM TO	D S CAT NUMBER
SIZE A4			DRAWING NUMBER 315-635-4

DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 4

DRAWING NUMBER
315-790

10
✓ (M)



1. Carryout technical requirements for thread as per standard 82021-00.
2. Coating is to be carriedout with a thickness of Zinc-3microns, chromium -1micron as per instructions ИИ-749-88 after removal of hydrogen embrittlement.
3. Coating for tropical use is to be carriedout with a thickness of Cadmium 9 microns, chromium-1micron as per instruction ИИ-569-84 after removal of hydrogen embrittlement.
4. Absence of coating is allowed on thread.
5. It is allowed to manufacture from: Round bar: $\frac{6-h11 \text{ Gost } 7417-75}{45-B-H \text{ Gost } 1051-73}$
6. It is allowed to manufacture thread by rolling so that the diameter of cut section is within the limits of mean diameter of thread.
7. Carryout other technical requirement as per standard. 82052-00.
8. It is allowed to increase the rod diameter for head by 0.2mm along the length of 10mm.
9. * Dimensions are given for reference.

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

EST. WT. **0.014** TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN		MATERIAL :- HEXAHEDRON	USED ON :-
CHD		10-h12 GOST 8560-78	CB 315-777-2
APPD		45-B-H GOST 1051-73	
DATE	16/3/07	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE:-	1:1	AVADI	
DIMENSIONS IN mm			TITLE :-
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69			BOLT
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
			315-790

4A	18-8-08	D. O. CORRECTION.
ISSUE	DATE	NATURE OF AMENDMENTS

F-5
82
283

SIZE: A3

