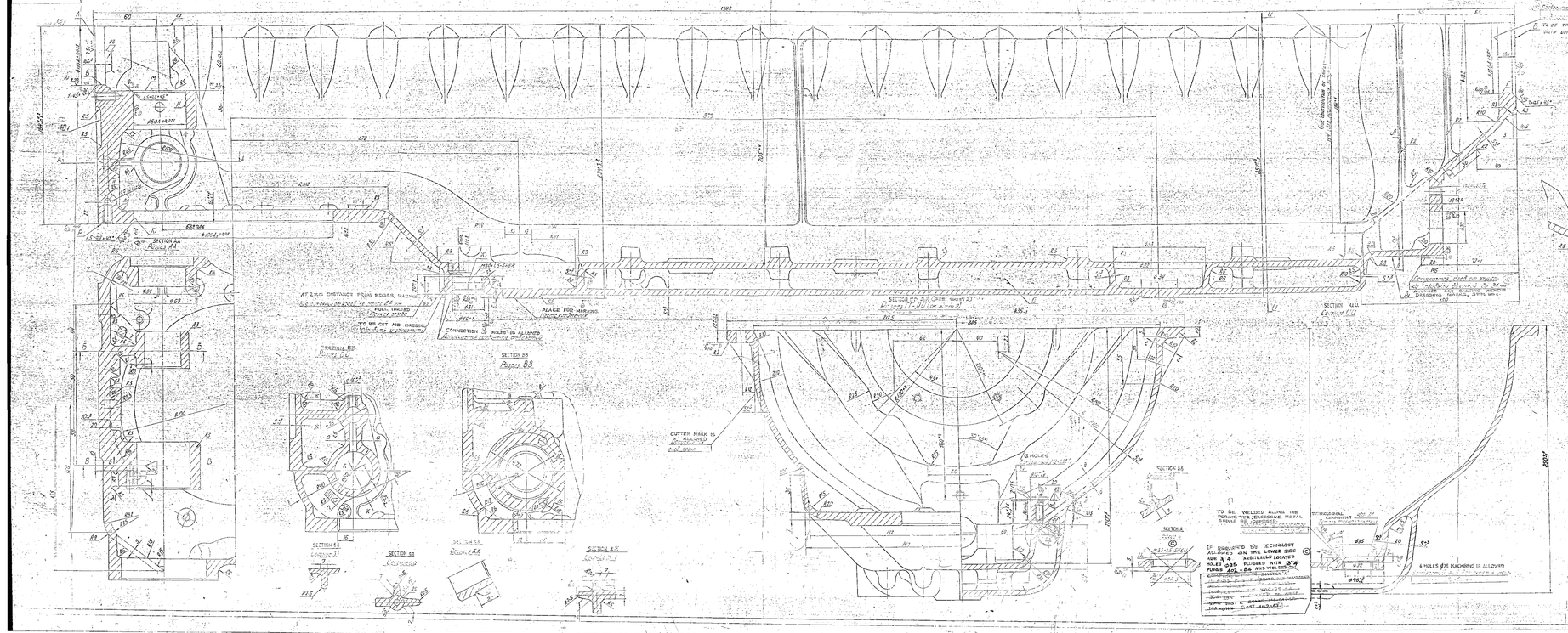
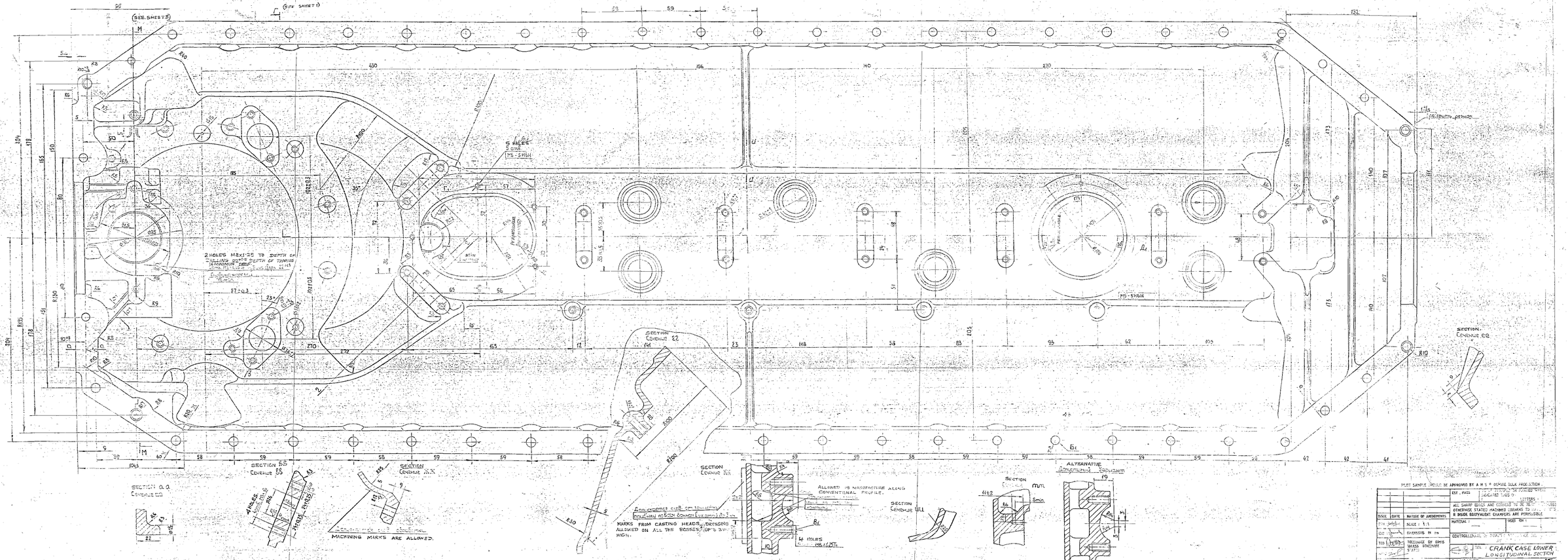
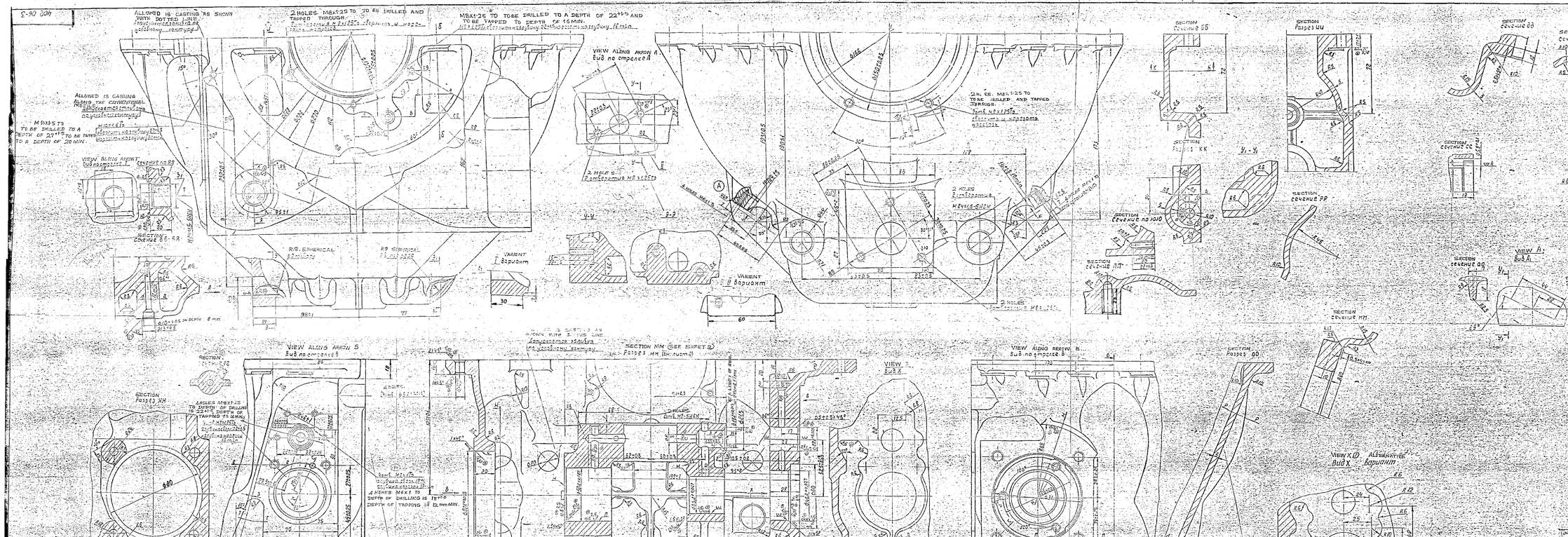
402-06-3


SECTION AA
SECTION BB
SECTION CC
SECTION DD
SECTION EE
SECTION FF
SECTION GG
SECTION HH
SECTION KK
SECTION LL
SECTION MM
SECTION NN
SECTION PP
SECTION QQ
SECTION RR
SECTION SS
SECTION TT
SECTION UU
SECTION VV
SECTION WW
SECTION XX
SECTION YY
SECTION ZZ

402-06-3 SH2


(SEE SHEET 1)
(SEE SHEET 3)
2 HOLES M8x1.25 TO DEPTH OF
5 HOLES
M5-5H6H
SECTION BB
SECTION AA
SECTION
SECTION
SECTION
SECTION
SECTION
ALTERNATIVE
MACHINING MARKS ARE ALLOWED.
MARKS FROM CASTING HEADS, DRESSING ALLOWED ON ALL THE BOSSES (UP TO 3mm HIGH).
ALLOWED TO MANUFACTURE ALONG CONVENTIONAL PROFILE.
4 HOLES
M8x1.25H
SECTION
SECTION
SECTION
PLOT SAMPLE WOULD BE APPROVED BY A.H.S. & DEMUS SULK FRICTION.
ALL SHARP EDGES AND CORNERS TO BE
OTHERWISE STATED MACHINED CORNERS TO
& INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE
SCALE : 1:1
DIMENSIONS IN mm
CONTROLLEVEL
CRANK CASE LOWER
LONGITUDINAL SECTION
402.06.3



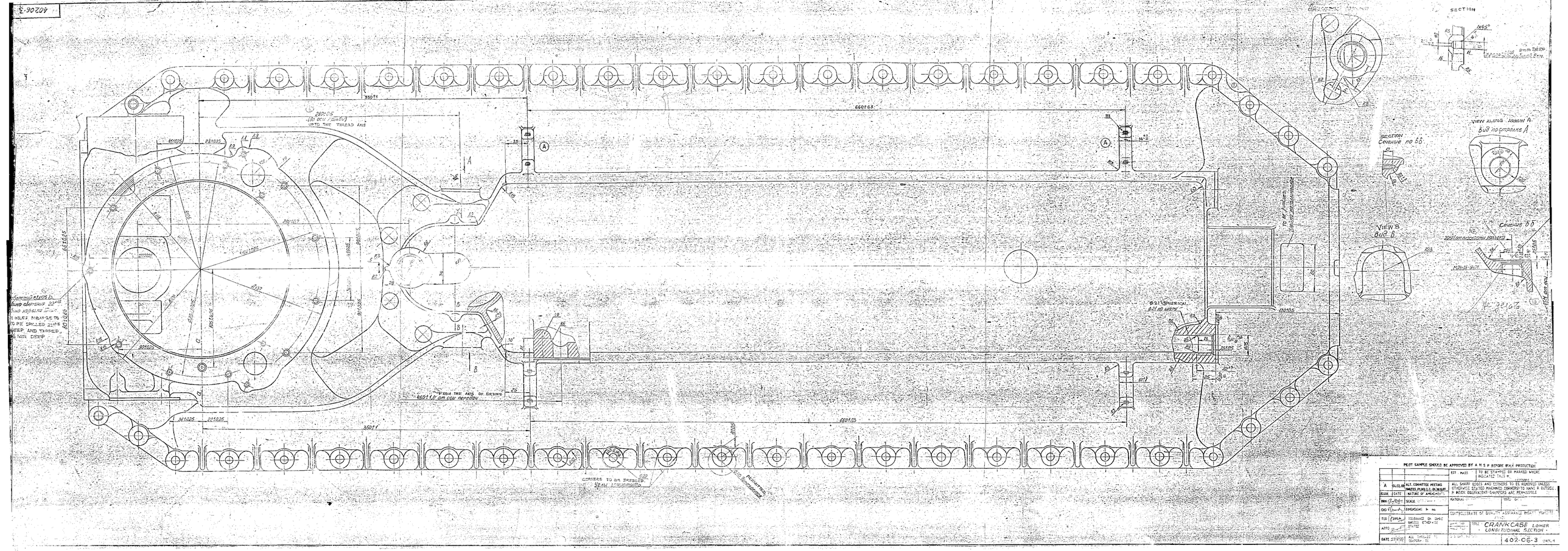
PILOT SAMPLE SHOULD BE APPROVED BY A K S P BEFORE BULK PRODUCTION

				EST. MASS	TO BE STAMPED OR MARKED WITH INDICATED TMK ®
A	21.12.06	ALT. COMMITTEE MEETING MINUTES PL.NR.3.2.ST.18-12.07			LETTERS

ALL SHARP EDGES AND CORNERS TO BE ROUNDED UNLESS OTHERWISE STATED INCLUDED CORNERS TO HAVE R 0.75 SIDE R MORE EQUIVALENT CHAMFERS ARE PERMISSIBLE

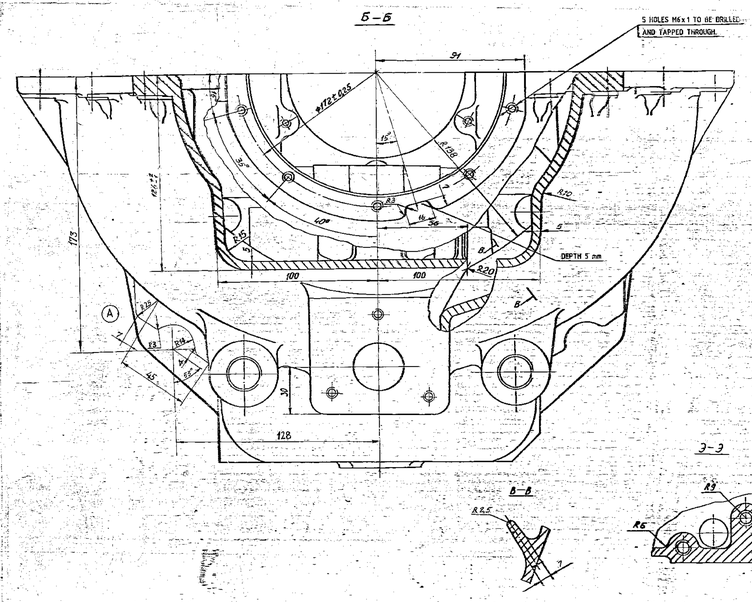
DRW			MATERIAL	WEIGHT
DES			CERTIFICATE OF QUALITY	SHEET NO.
TCD			AVIA	
APPD			CRANKCASE Lower	
DATE			402-06-3 SHT 2	

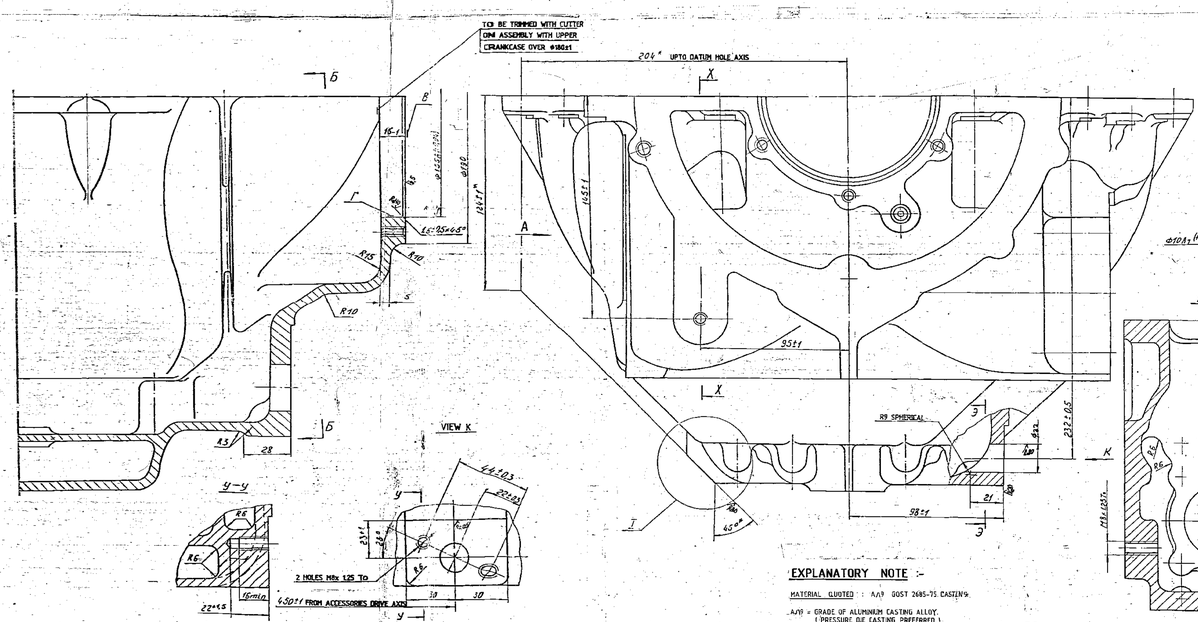
402-06-3

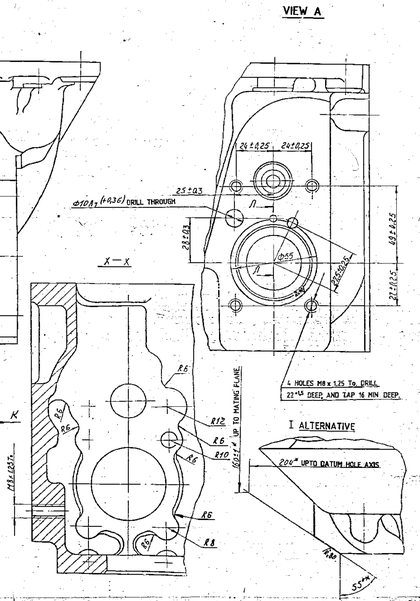

SECTION
VIEW ALONG ARROW A
SECTION Cerevue no bb.
VIEW B
Cerevue bb
CORNERS TO BE BREKEN
PLOT SAMPLE SHOULD BE APPROVED BY A.N.S.P. BEFORE MAX PRODUCTION
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MACHINED CORNERS TO HAVE A OUTSIDE R WITH EQUIVALENT CHAMFERS ARE PERMISSIBLE
CRANKCASE LOWER
LONGITUDINAL SECTION
402-06-3

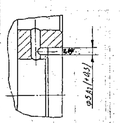
[redacted]

DRAWING NUMBER :
402 06 43









1. SURFACE 'A' AND 'B' ARE TO BE MACHINED IN ASSEMBLY WITH UPPER CRANK CASE.
2. HOLE M14x1.5 K/Б-2 NOT TO BE MADE (SEE SECTION Б-Б, SHEET 4, DRAWING 402 06 3)
3. HOLE M14x1.5, K/Б-2, FOR OIL DRAIN FROM TUBBO-COUPLING NOT TO BE MACHINED (SEE SECTION Д-Д, SHEET 3, DRAWING 402 06 3)
4. HOLE ⌀18 AND TWO THREADED HOLES M8x1.25, K NOT TO BE MADE (AS INDICATED BY ARROW A, SHEET 3 DRAWING 402 06 3)
5. OTHER DIMENSIONS, TECHNICAL REQUIREMENTS AND MACHINING AS PER DRAWING 402 06 3. (SHEET 1, 2, 3, 4)
6. * DIMENSIONS FOR REFERENCE.

EXPLANATORY NOTE :-

MATERIAL QUOTED : АЛ9 GOST 2685-75 CASTING.

АЛ9 = GRADE OF ALUMINUM CASTING ALLOY. (PRESSURE DIE CASTING PREFERRED).

a) CHEMICAL COMPOSITION : %

BASE ELEMENT	= ALUMINUM
MAGNESIUM	= 0.2 - 0.1
SILICON	= 9.0 - 8.0

OTHER IMPURITIES :

IRON	= 1.50
COPPER	= 0.1
MANGANESE	= 0.5
ZINC	= 0.2
TIN	= 0.01
LEAD	= 0.05
BERIUM	= 0.10
ZIRCONIUM	= 0.15
TOTAL	= 2.00

b) MECHANICAL PROPERTIES :-

PARTIAL RESISTANCE	= 17 (max)
SPECIFIC ELONGATION	= 1 (max)
HARDNESS AS PER BRINNEL HB	= 50 (max)

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

CST WT 22.1 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 R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

ISSUE	DATE	NATURE OF AMENDMENTS
A	06.07.84	ALT. COMMITTEE MEETING MINUTES POINT No. 3.2 01-06-12-07.

DRN		MATERIAL:- CASTING. АЛ9, GOST 2685-75.
CHD		USED ON:- Cb 3301-15-30, Cb 3301-15-44
TCD		
APPD		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
DATE	26 - 8 - 87	
SCALE:- 1 : 1		TITLE CRANKCASE, LOWER
DIMENSION IN mm		
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 7920-69		
ALL THREADS TO CONFORM TO IS: 4218 PT IV		D S CAT NUMBER :
		DRAWING NUMBER 402 06 43