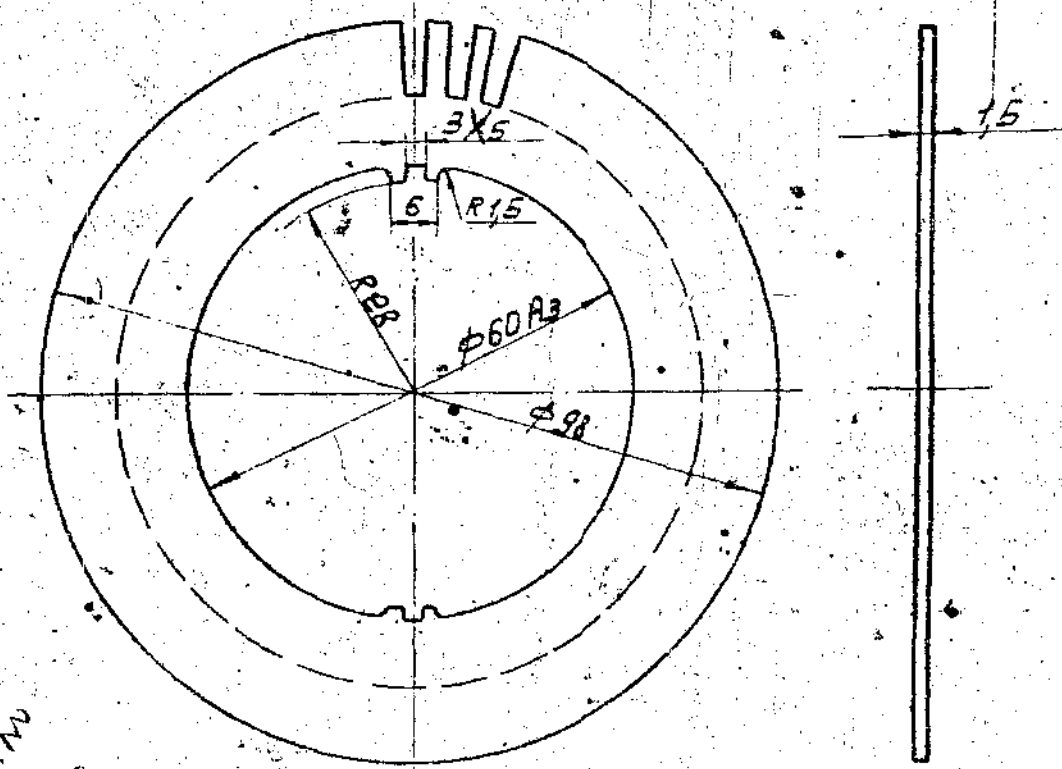


506 200 H

1. Tolerances for free dimensions are as per 22 AT 52
2. Die of middle plate of armature may be used. Drawing 506.201.
3. Alternate material is Glass Textolite CT3Φ-1 GOST 12652-74, Glass Textolite CT3Φ GOST 12652-74.



ANDI. NOTN. No. 250-78

*Handwritten:* D-250  
*Handwritten:* 1/14/78  
*Handwritten:* 1/14/78

**GLASS TEXTOLITE OF GRADE CT -1  
 GOST 12652 -74**

**96**

PILOT SAMPLE SHOULD BE APPROVED BY AHS/P BEFORE BULK PRODUCTION

EST. MASS <b>0.006 Kg</b>	TO BE STAMPED OR INDICATED THIS W/
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNER TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENTS
DRN <i>[Signature]</i>	SCALE:- 1:1
CHD <i>[Signature]</i>	DIMENSIONS IN mm
TCO <i>[Signature]</i>	TOLERANCE ON DIMS UNLESS OTHERWISE STATED
APPO <i>[Signature]</i>	ALL THREADS TO CONFORM TO
DATE 9-9-87	CONFORM TO
MATERIAL:- <b>* SEE ABOVE</b>	USED ON:- 505 117 H
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TITLE: <b>ARMATURE EDGE PLATE</b>	
D S CAT NUMBER	DRAWING NUMBER <b>506 200 H</b>

506 201H

Tolerances for free dimensions are as per accuracy Class 4, OST 1014 (A4 : C4),

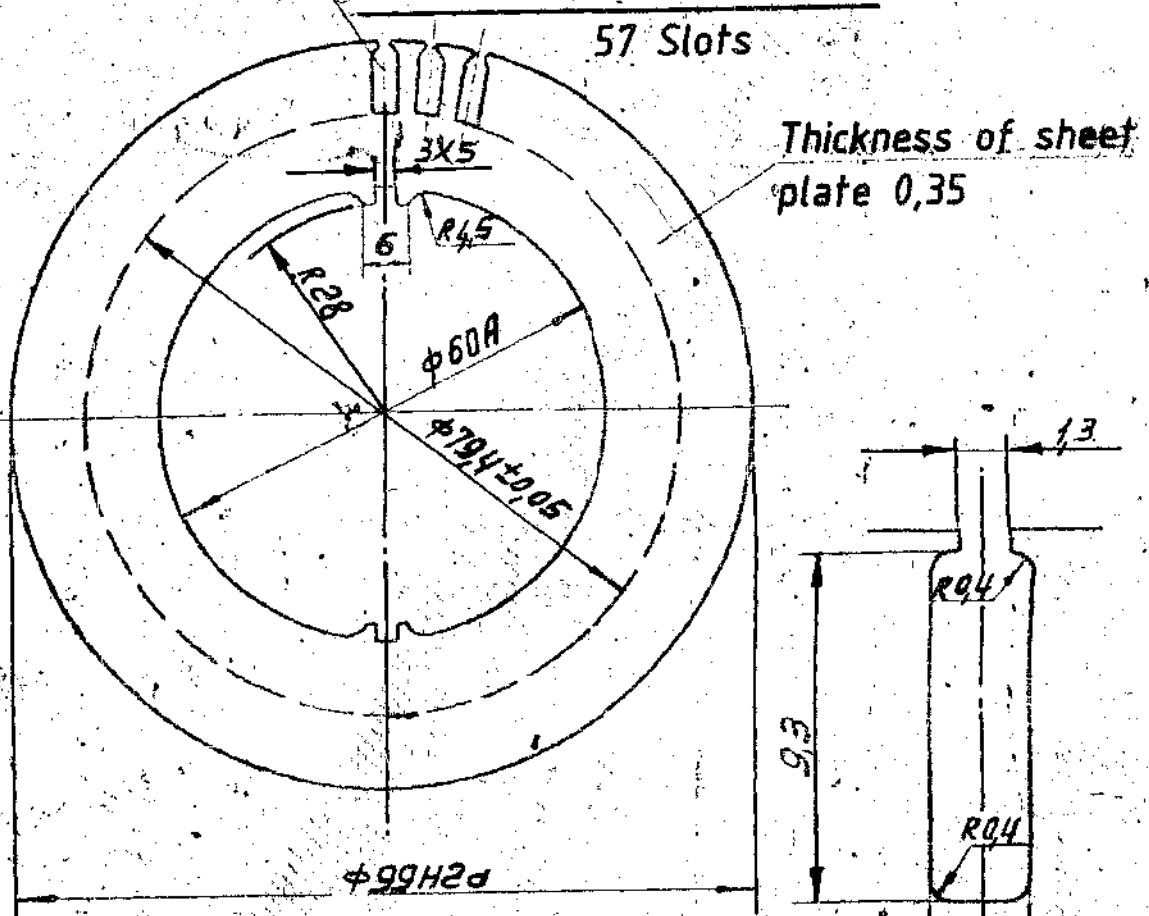
Anneal iron in hydrogen medium as per TU 2-20.

Use compound die.

Apply varnish coating on 100 % of the sheets from one side or on 50% of the sheets from two sides with varnish KΦ-965 TU 1-92.

Maintain dimension  $\phi 99H2a$  in armature unit.

Dimension R 1,5 mm may be absent.



\* STEEL 1311  
TY 14-1-2528

PROT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

D83

ISSUE	DATE	NATURE OF AMENDMENTS	EST. MASS 0,02 Kg	TO BE STAMPED OR RELOCATED THIS
DRW		SCALE:- 1:1		
CHK		DIMENSIONS IN mm		
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	MATERIAL: * SEE ABOVE	USED: 505 117 H
APPO		ALL THREADS TO CONFORM TO	CONTROL POINT OF INSPECTION (HEAVY VEHICLES) AVADI	
DATE	9-9-87		SYMBOLS:	
			MIDDLE ARMATURE PLATE	
			DRAWING NUMBER 506-201 H	

97

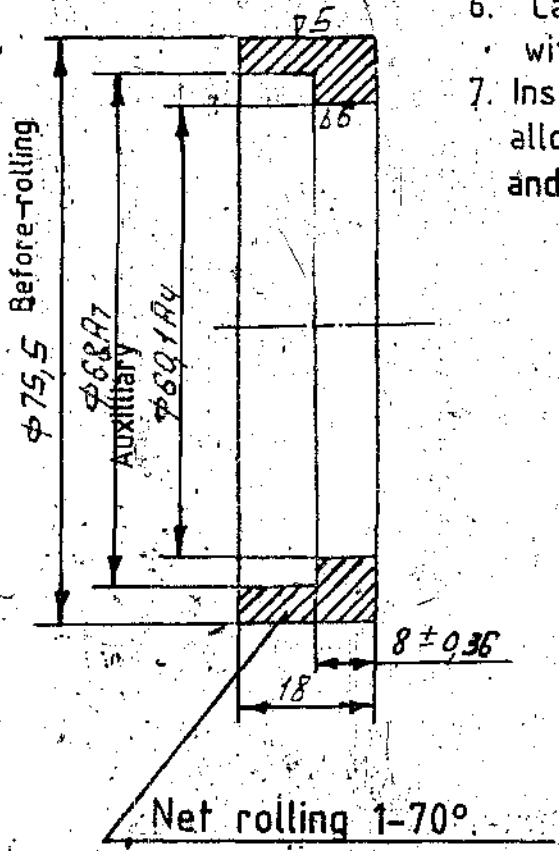
508 024 H

IND

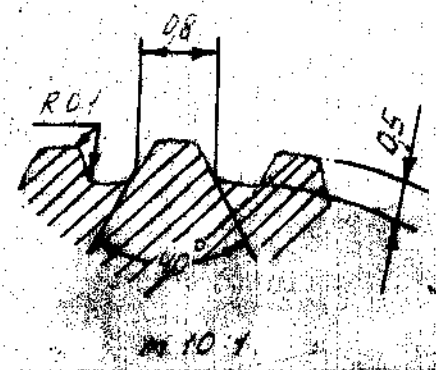
Unless otherwise specified

141  
86

1. Tolerance for casting and allowances for machining are as per class 5 of standards 56-15 and 56-16.
2. Pattern taper should be 2°.
3. Casting radius should be R 1.5 to 2mm.
4. Carry-out heat treatment as per condition T5 GOST 2685-75.
5. Technical requirements for casting are as per OST 190021-71 group-3.
6. Casting is allowed by centrifugal method without heat treatment.
7. Instead of net rolling Straight rolling is allowed in casting with dimensions 0.5x0.8x40° and pitch 1.6 mm.



Profile of casting teeth pitch 1.6 mm



093  
Line

Aluminium alloy  
AA-9 GOST 2685-79

PILOT SAMPLE SHOULD BE APPROVED BY ANSP BEFORE MILK PRODUCTION

			EST. MASS <b>0.039 Kg</b>	TO BE STAINED OR INDICATED THIS BY: I (LETTERS)	<b>98</b>
				ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MATCHED COPPER TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	SCALE: <b>1:1</b>	USED ON: <b>508-025 H</b>	
DRN			CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
CHD			TOLERANCE ON DIMS. UNLESS OTHERWISE STATED	TITLE: <b>WINDING SUPPORT</b>	
ICD			ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER <b>508 024 H</b>
APPO					
DATE	<b>9-9-87</b>				

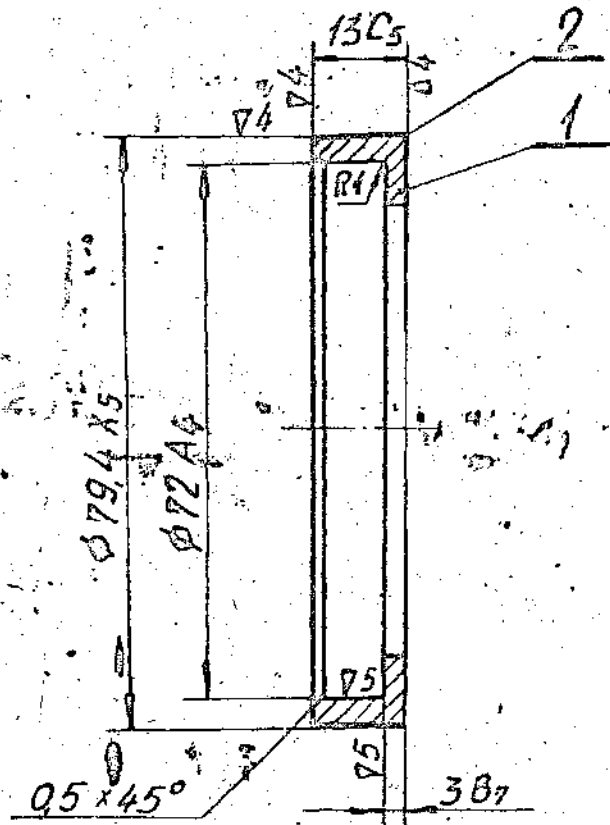
508 025 H

Unless otherwise specified,

Alternate material is 508-025 H-1

Moulding material is AL-4 GOST 20437-75

~~14~~



8390 59901 23.08.82

3577

D-03

QTY	DESIGNATION	DESCRIPTION	MATERIAL	QTY	REMARKS
2	508.025H-1	Glass fabric			
		TB93-2 TY16-503.509-75		1	
1	508.024H ✓	WINDING SUPPORT		1	

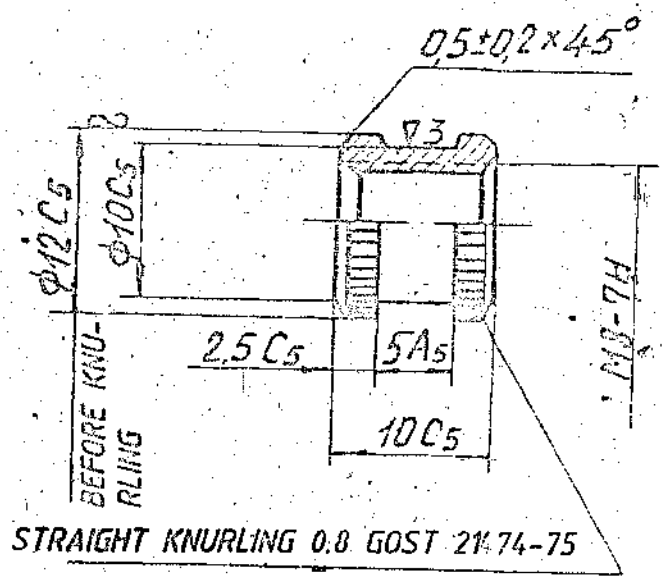
PHOT SAMPLE SHOULD BE APPROVED BY AMSY BEFORE BULK PRODUCTION

EST. MASS 0.04 kg	TO BE STAMPED (INDICATED BY...)	<b>29</b>
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MATCHED CORNER TO HAVE R OUTSIDE OF BENCH EQUIPMENT PARTS ARE PERMISSIBLE.		
ISSUE DATE	NATURE OF ATTACHMENTS	MATERIAL: — USED ON: 505-117 H
DRN	SCALE: 1:1	CONTROLLED BY INSPECTION (BY VEHICLE) AVADI
ECO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: <b>WINDING SUPPORT-ASSY</b>
APPD	ALL THREADS TO COMPLY TO	D'S LAB NUMBER
DATE: 9-9-87		WINDING SUPPORT <b>508-025 H</b>

206 275H

75 Unless otherwise specified

1. CHAMFERS OF THREAD SHOULD BE AS PER GOST 10549-80.
2. MAKE THREAD M18-7H IN PANEL UNIT.



AMDT. NOTN. No. 0109-80

\* BAR A KPHT 12.0H A6PKM3-1  
GOST 1620-78

0-83

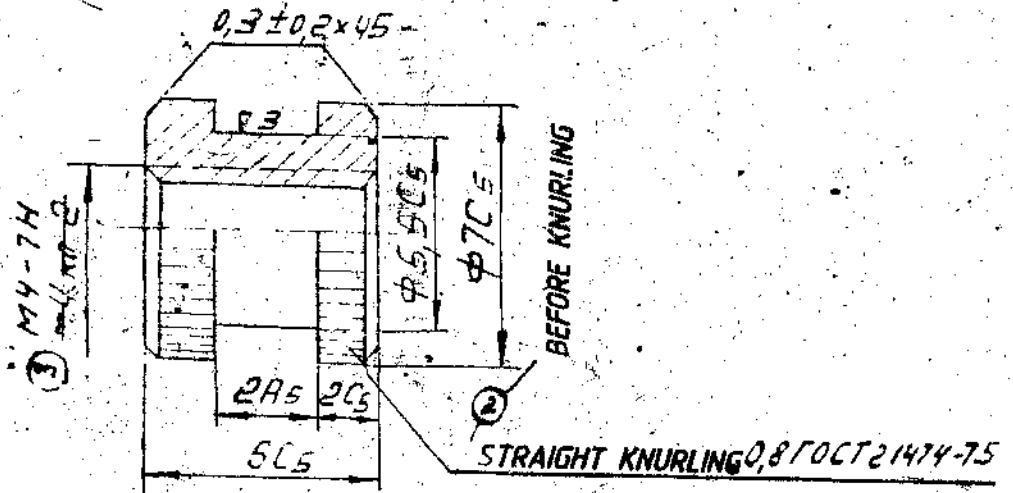
PLOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

			EST. MASS 0.005 Kg	TO BE STAMPED OR INDICATED THIS W/
				(LETTERS)
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNER TO HAVE R OUTSIDE IF INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL * SEE ABOVE	USED ON 160-525 H
DRM		SCALE:- 2:1	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHO		DIMENSIONS $\phi$ mm		TITLE: BUSH
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	DRAWING NUMBER 206 275 H
APPO		ALL THREADS TO CONFORM TO		
DATE	9-9-87			

206 301H

75 UNLESS OTHERWISE SPECIFIED

1. MAKE THREAD M4-7H IN PANEL UNIT.
2. CHAMFERS OF THREAD ARE AS PER GOST 10549-63.



BARAKPHT 8-0 HAbp KMU 3-1  
GOST 1628 -78

0-83

PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

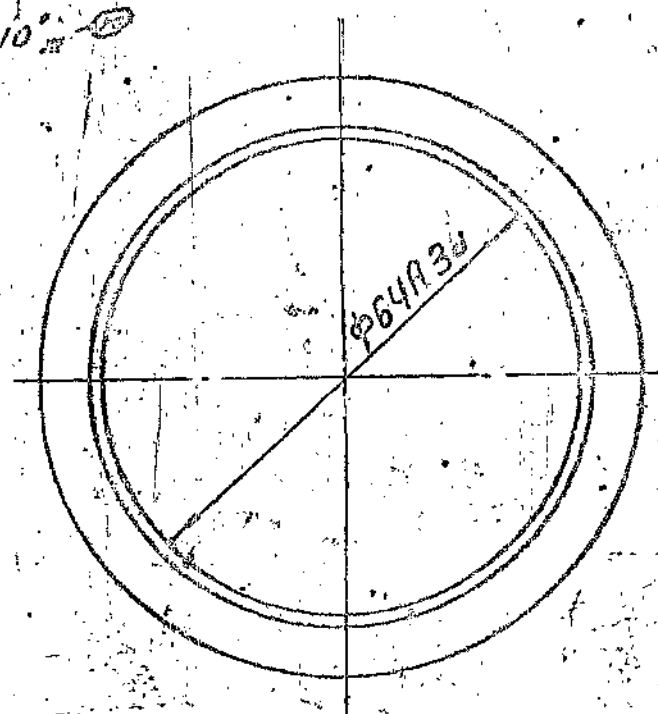
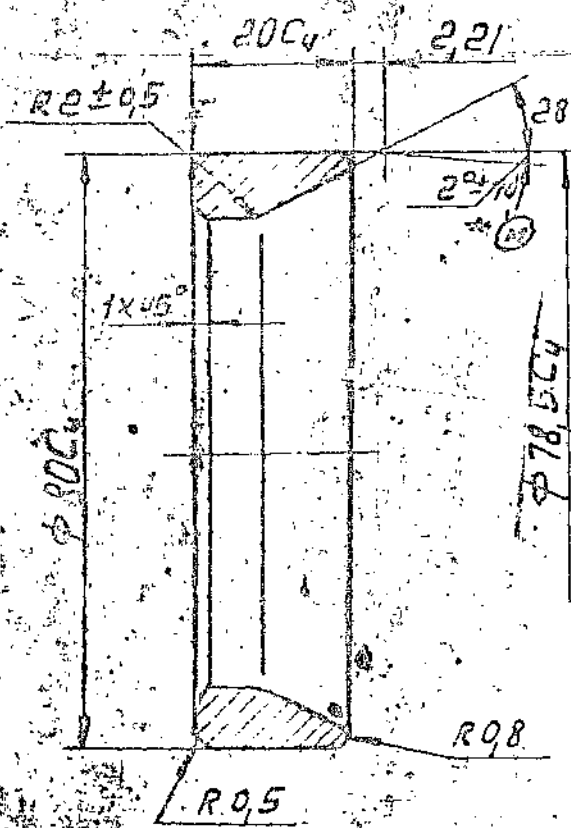
			EST. MASS	TO BE STAMPED OR INDICATED THIS WAY	(129)
				LETTERS: -	
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNER TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE		
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL: * SEE ABOVE	USED ON: 160 525 H	
DRN		SCALE: 5:1	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI		
CND		DIMENSIONS IN mm	⊕ □ TITLE: BUSH		
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	⊕ □ TITLE: BUSH		
APPO		ALL THREADS TO CONFORM TO	D'S CAT NUMBER	DRAWING NUMBER	
DATE	9-9-87			206 301 H	

218.203H

Principal  
Symptoms

CARRY-OUT HEAT TREATMENT. HRC 34 TO 38.  
\*DIMENSIONS ARE GIVEN FOR TOOL.  
TOLERANCES FOR FREE DIMENSIONS ARE AS PER 22 AT 52.

14  
41



NOT IN NO. 0186-80

PIPE JOINTER GOST 8732-78  
TY 14-3-675-78

PILOT SAMPLE SHOULD BE APPROVED BY A.I.R.P. BEFORE WORK PROCEEDS

D 85

EST. MASS	TO BE STAMPED ON DRAWING WHERE INDICATED THIS	<b>(55)</b>
0,21 Kg	LETTERS	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED EDGES TO HAVE R OUTSIDE R BEHIND EQUIPMENT CHAMFERS ARE PERMISSIBLE		
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL USED ON
DRN CPT	SCALE - 1:1	** SEE ABOVE 520 097H
CRO	DIMENSIONS IN mm	CONTROL RATE OF INSPECTION (BY VEHICLES) AVADH
TEO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE
APPO	ALL THREADS CONFORM TO	V - RING
DATE 9-9-87		DRAWING NUMBER 218-203 H

218.211H

IND

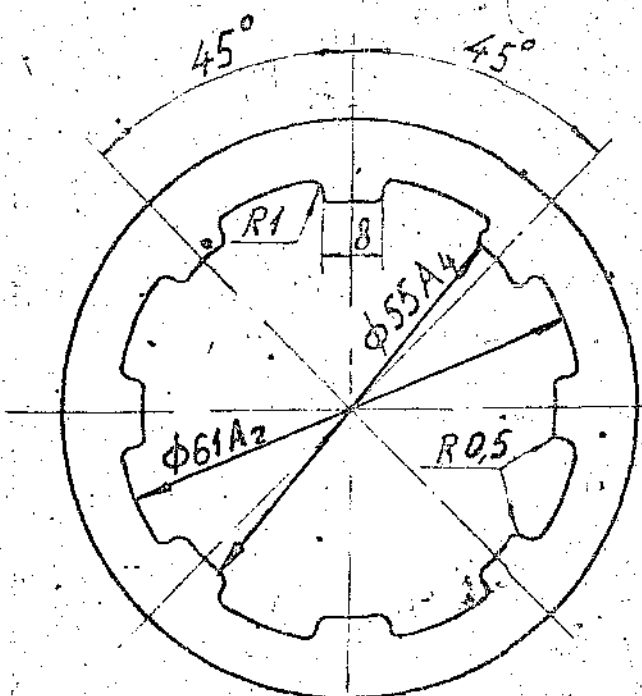
1. TOLERANCES FOR FREE DIMENSIONS ARE AS PER 22 AT 52.
2. SHINING ZINC-PLATING, 12 TO 20 MICRONS THICK, PASSIVATE.

Восстановленный подлинник № 1

Первичный образец

5

42



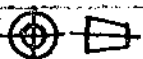
\* PLATE 5 - GOST 19904 -74  
 II-F 10 GOST 16523 -70

56

PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

D83

ISSUE	DATE	NATURE OF AMENDMENTS	EST. MASS 0.04 Kg	TO BE STAMPED OR RELOCATED THIS W/
DRN		SCALE:- 1:1		(LETTERS)
CHD		DIMENSIONS IN mm	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED FACED CORNER TO HAVE R OUTSIDE	
TCD		TOLERANCE ON DRSS UNLESS OTHERWISE STATED	MATERIAL - *SEE ABOVE	USED ON:- 505 117 H.
APPO		ALL THREADS TO CONFORM TO	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI	
DATE	9-9-07		D S CAT NUMBER	DRAWING NUMBER 218 211 H



V-RING

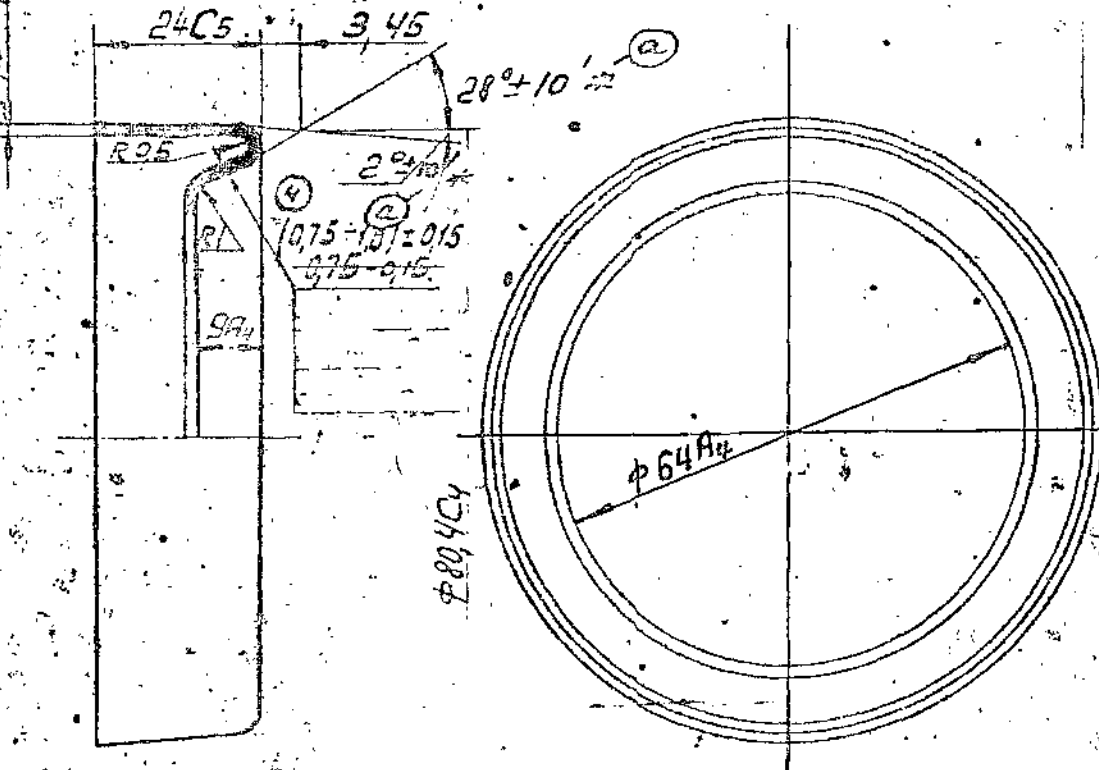
219-024H

\* Dimensions are given for tool.

Thickness of one cone at various points may vary by  $\pm 0.15\text{mm}$  tolerance value for working part  $\pm 0.2\text{mm}$  for non-working part.

~~XIV~~  
43

1075-101302  
075-015



MICANITES  $\Phi$ МГА  
ГОСТ 6122-75

~~XIV~~  
43

PILOT SAMPLE SHOULD BE APPROVED BY VOP BEFORE USE FROM TOOL

57

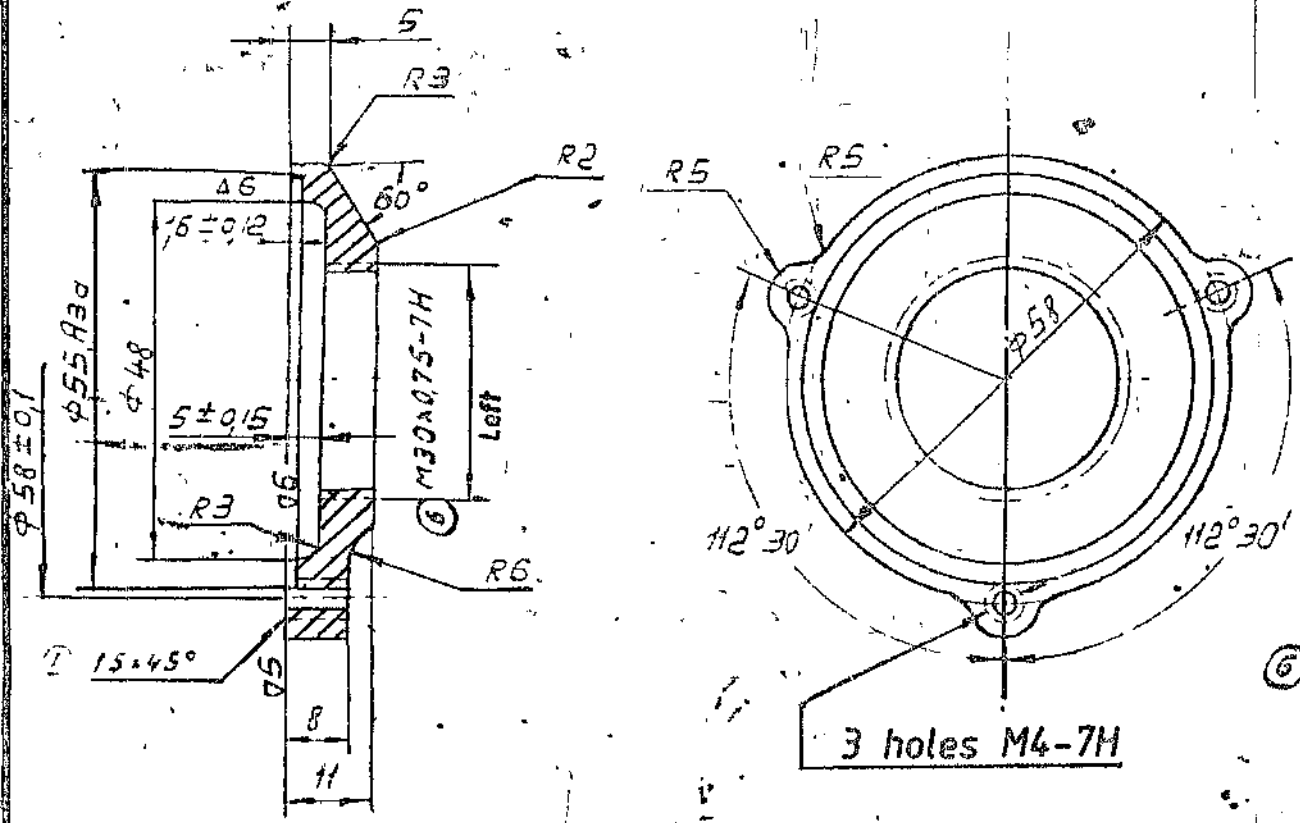
783

ISSUE DATE	NATURE OF AMENDMENTS	WEIGHT	0,018 Kg
DRAWN <i>CPA</i>	SCALE: 1:1	ALL SHARP EDGES AND CORNERS TO BE ROUNDED UNLESS OTHERWISE STATED SACRIFICING TO AVOID HAZARD OR TO BE EQUIVALENT CHARACTERISTICS WHERE PERMISSIBLE	USED ON: 520 09TH
CHKD <i>CPA</i>	DIMENSIONS IN mm	MATERIAL: ** SEE ABOVE	CONTROLLER RATE OF INSPECTION (HEAVY VEHICLES) AVADI
TED <i>CPA</i>	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: INSULATION CONE	DRAWING NUMBER
APPD <i>CPA</i>	ALL THREADS TO CONFORM TO	O/S CAT NUMBER	219-024 H

232 142 H

Unless otherwise specified

- 1 Tolerance for free dimensions are as per 22 AT 52 and Class 7.
- 2 Tolerances for casting and allowances for machining are as per accuracy class 5 of standards 56-15 and 56-16 MAF.
- 3 Pattern taper should be 2°.
- 4 Casting radii should be 1,5 mm.
- 5 Coating:- Anodic-oxidization, chromatiation.
- 6 Technical requirements for casting are as per OST 190021-71, group 3.



\* Aluminium alloy AA9  
GOST 2685 -75

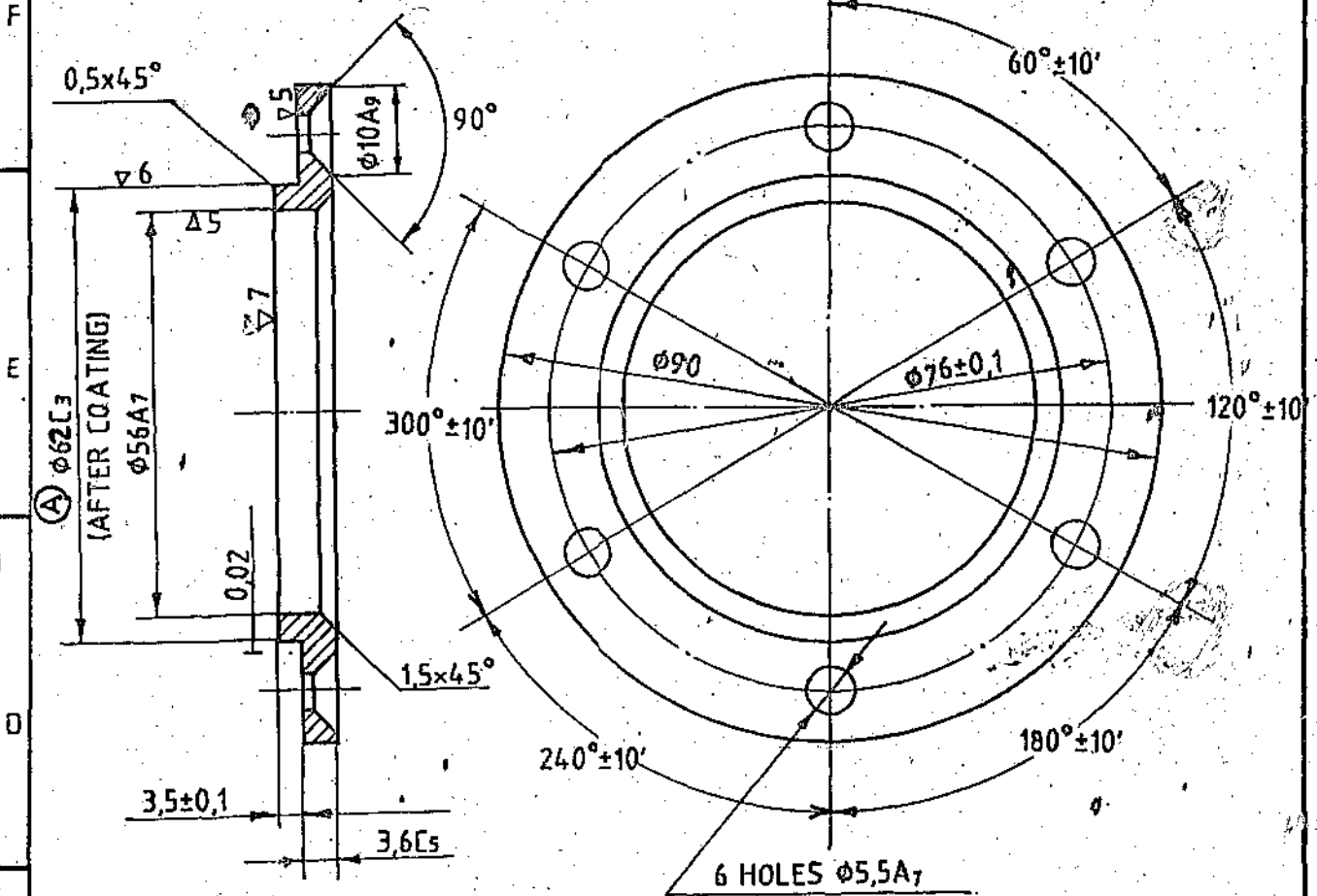
D-83

PHOT SAIZLE SHOULD BE APPROVED BY A N S P BEFORE CORK PRODUCTION

		EST. MASS <b>0.001 Kg</b>	TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTERS)
		(58)	
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R UNLESS EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISS JO	DATE	NATURE OF AMENDMENTS	MATERIAL
DRW		SCALE - 1:1	* SEE ABOVE
CHD		DIMENSIONS IN mm	USED ON - 500 155 H
TCD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPD		ALL THREADS CONFORM TO	TITLE <b>FLANGE</b>
DATE 9-9-07			D S CAT NUMBER
			DRAWING NUMBER <b>232 142 H</b>

DRAWING NUMBER  
232-220 H

▽ 4--UNLESS STATED OTHERWISE



- 1) TOLERANCE FOR FREE DIMENSIONS ARE AS PER 22 AT - 52 AND CLASS 7.
- 3) COATING: ZINC-PLATING, 21 MICRONS THICK, CHROMATIZATION.

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

AMDT No: 0020-79

0  
03

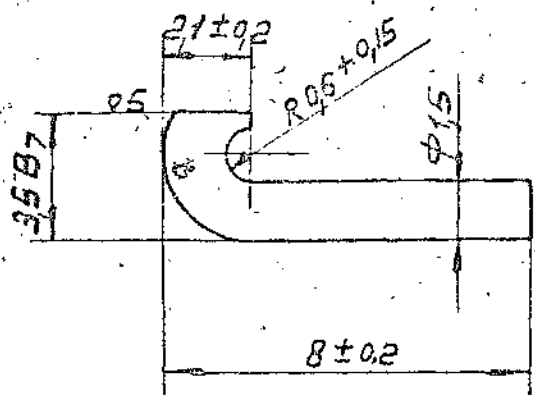
		EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THUS ( LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
A 11-12-58 AUTHY. LT. No. 93833 / IND-III / 415		MATERIAL: STEEL 45 GOST 1050-74	USED ON: 002-145 H
ISSUE DATE	NATURE OF AMENDMENTS	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
DRN	SCALE - 1:1		
CHD	DIMENSIONS IN mm	TITLE:- FLANGE	
TCD	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED.		
APPD	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
DATE			232-220 H
SIZE A4			

59

242 032 H

Утвержден.

Unless otherwise specified,



AMDT. NOTN. No: 0057-82  
0057-82  
0024-79

\* WIRE 15-10 GOST 5663-79

60

D-83

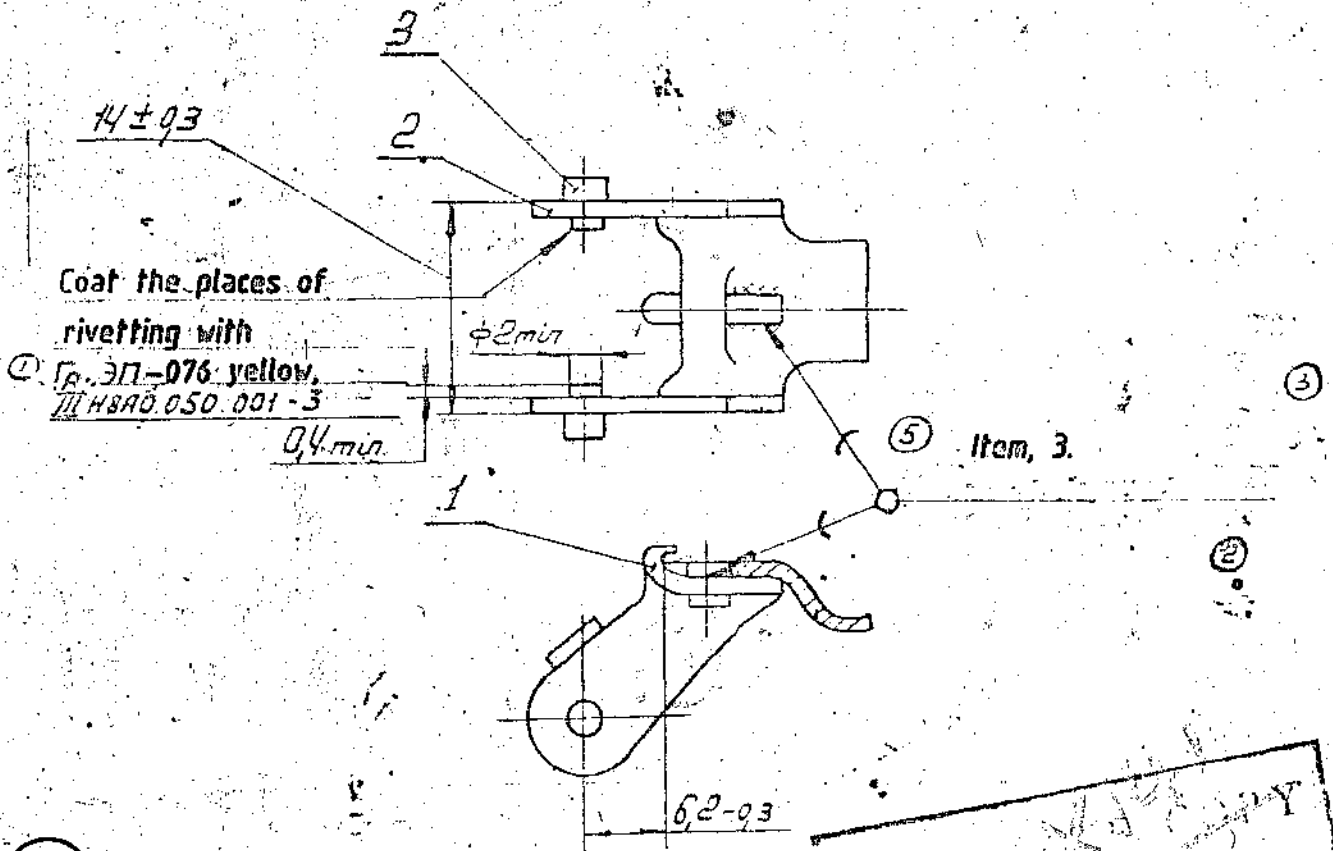
PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

		EST. MASS <b>0,00015 Kg</b>	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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL SEE ABOVE	USED ON: <b>255 026 H</b>
DRN	SCALE: <b>5:1</b>	CONTROL RATE OF INSPECTION (HEAVY VEHICLES:) AVADI	
END	DIMENSIONS IN mm	TITLE: <b>HOLDER</b>	
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	
APPO	ALL THREADS CONFORM TO	DRAWING NUMBER <b>242 032 H</b>	
DATE <b>9-9-87</b>			

255 026H

УТВЕРЖЕН

- 1 Displacement of axes of pins should not exceed 0,15 mm
- 2 Coating:- zinc-plated, 21 microns thick, chromated, except for pins, ref,no,3.
- 3 Braze with brass Л63 GOST 1066-75.



D-03

ХИЩА  
10

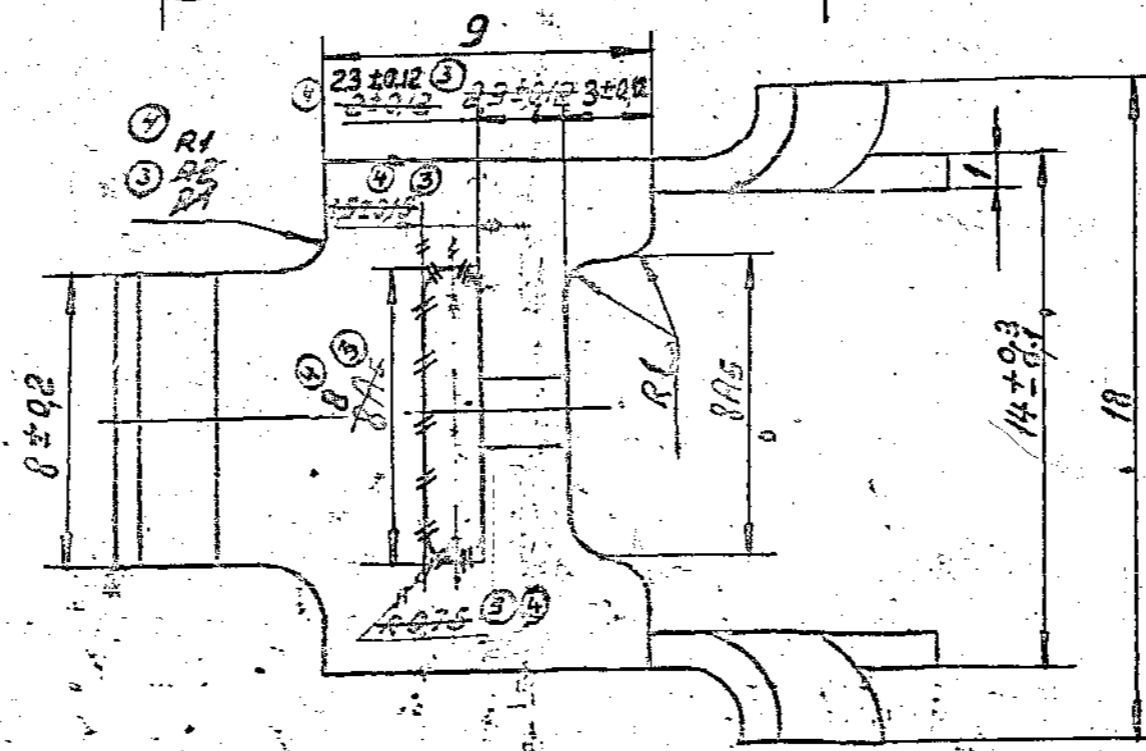
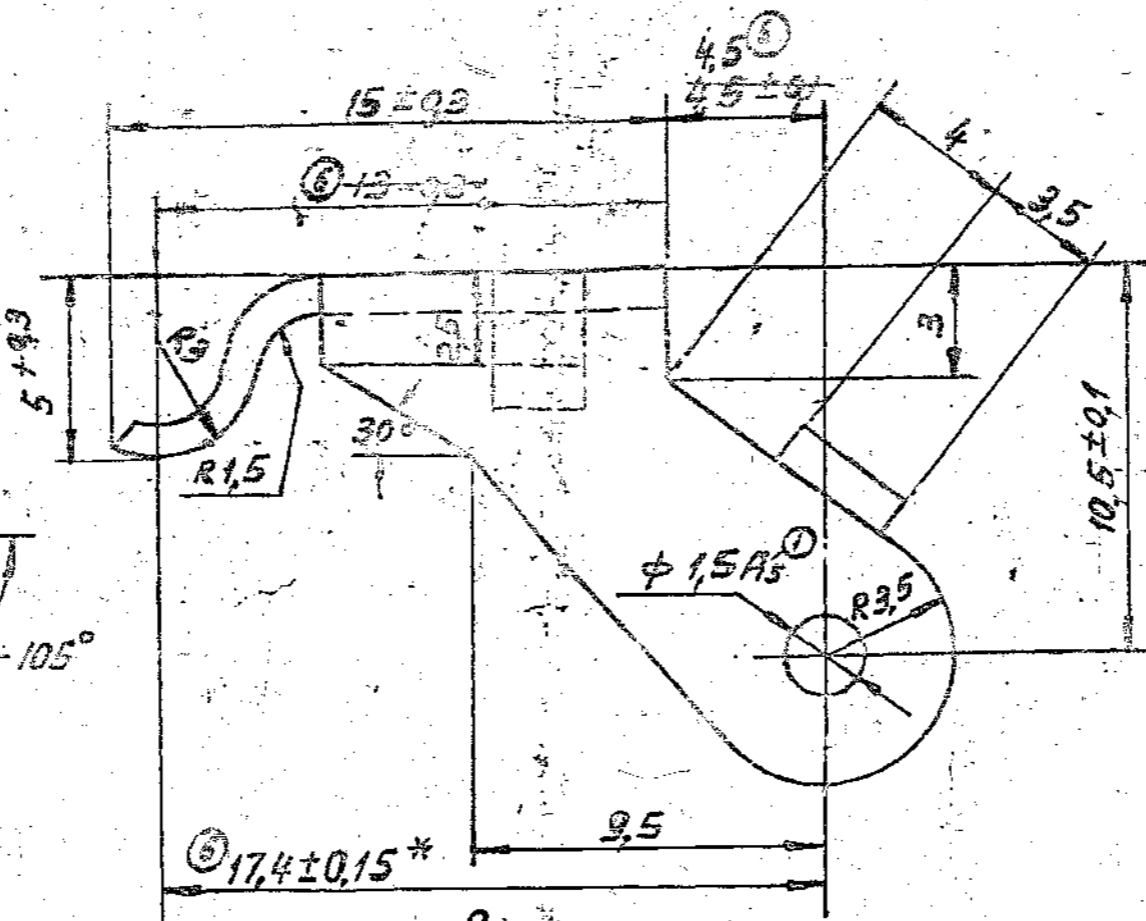
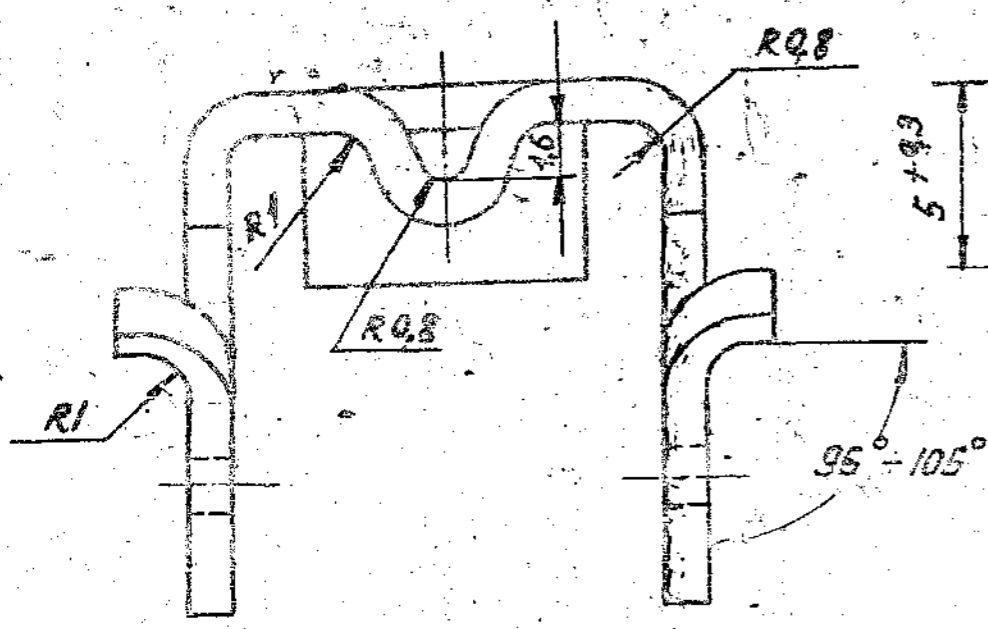
3	491. 220H	✓	Pin	2
2	256. 030H	✓	Lever	1
1	242. 032H	✓	Holder	1

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

25

ISSUE DATE	NATURE OF AMENDMENTS	EST. MASS 0.004 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS BY (LETTERS)
DRN	SCALE:- 2:1	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
CHD	DIMENSIONS IN MILL	MATERIAL:-	USED ON:- 550 044 H
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI	
APPO	ALL THREADS CONFORM TO	TITL: LEVER	
DATE 9-9-07		D S CAT NUMBER	DRAWING NUMBER 255 026 H

ИДЕНТИФИКАЦИОННЫЙ № 957



Tolerances for free dimensions are as per accuracy class 7, OST 1010.

\* Provide dimension with tool

\* PLATE 5-GOST 18904-74  
II - Г 10 GOST 13523-70

PROT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

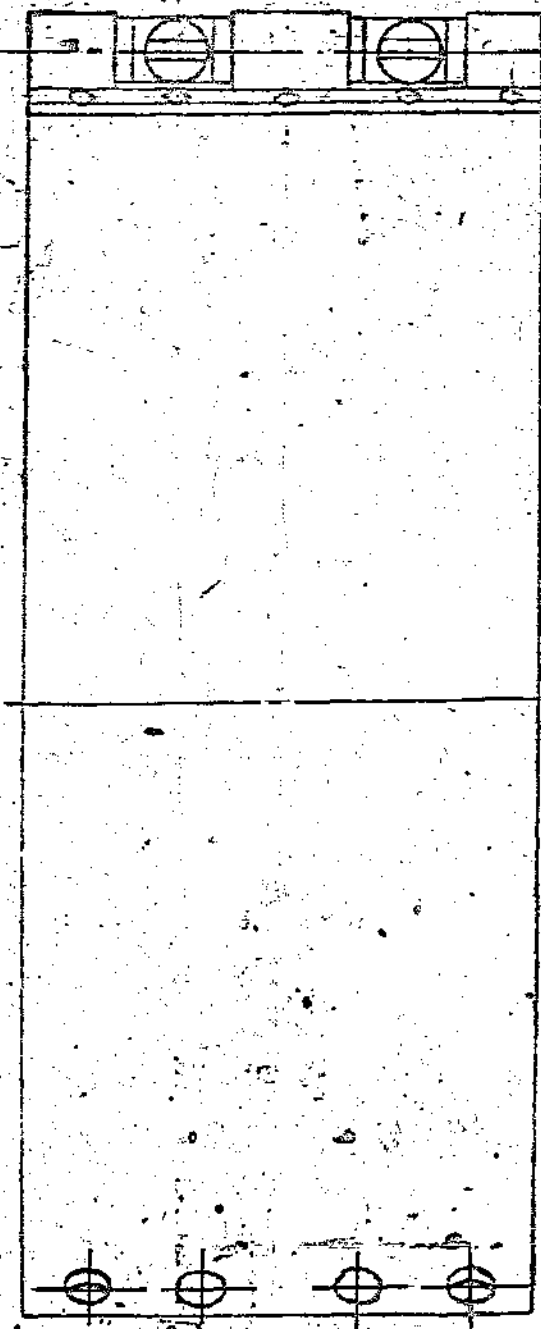
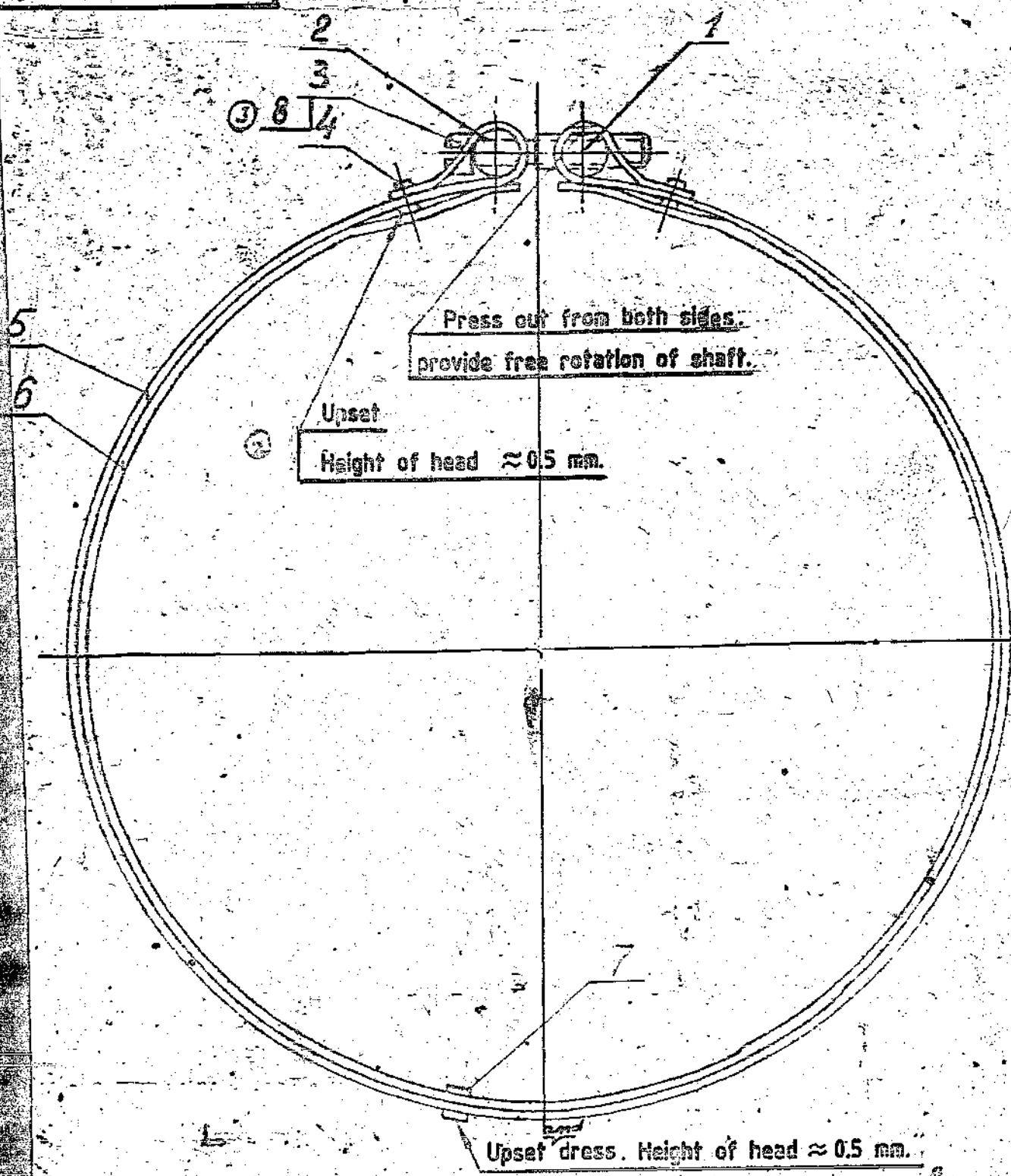
61

ISSUE	DATE	NATURE OF AMENDMENTS	EST. MASS 0,003 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS )
ORN		SCALE: 5:1	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MAXIMUM CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT (CHAMFERS ARE PERMISSIBLE)	
CHD.		DIMENSIONS IN mm	MATERIAL SEE ABOVE	USED ON: 255 026H
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADH	
APPD.		ALL THREADS CONFORM TO	TITLE: LEVER	DRAWING NUMBER 256-030 H
DATE	9-9-87		D S CAT NUMBER	

503

ИДЕНТИФИКАЦИОННЫЙ № 957

270.034H



1. Coat the heads of the rivets and places of their upsetting with Гр.ЭП - 076, Yellow III H8A0.050.001-3. It may be coated with one continuous strip of primer.
2. Screws, reference no:3 may be replaced by screws, reference no:8.

S.NO.	DESIGNATION	DESCRIPTION	QTY.	REMARKS
8.	7B8. 916. 002	SCREW	2	
7.	488. 109 H	RIVET	2	
6.	893 252 H	INSULATING GASKET	1	
5.	272. 040H	BAND	1	
4.	3521 A-2,5-3-K3	RIVET	10	STANDARD
3.	462. 701 H	SCREW	2	
2.	183. 037 H	SHAFT	1	
1.	183. 030 H	ROLLER	1	

PLOT SAMPLE SHOULD BE APPROVED BY A.M.S.P. BEFORE BULK PRODUCTION

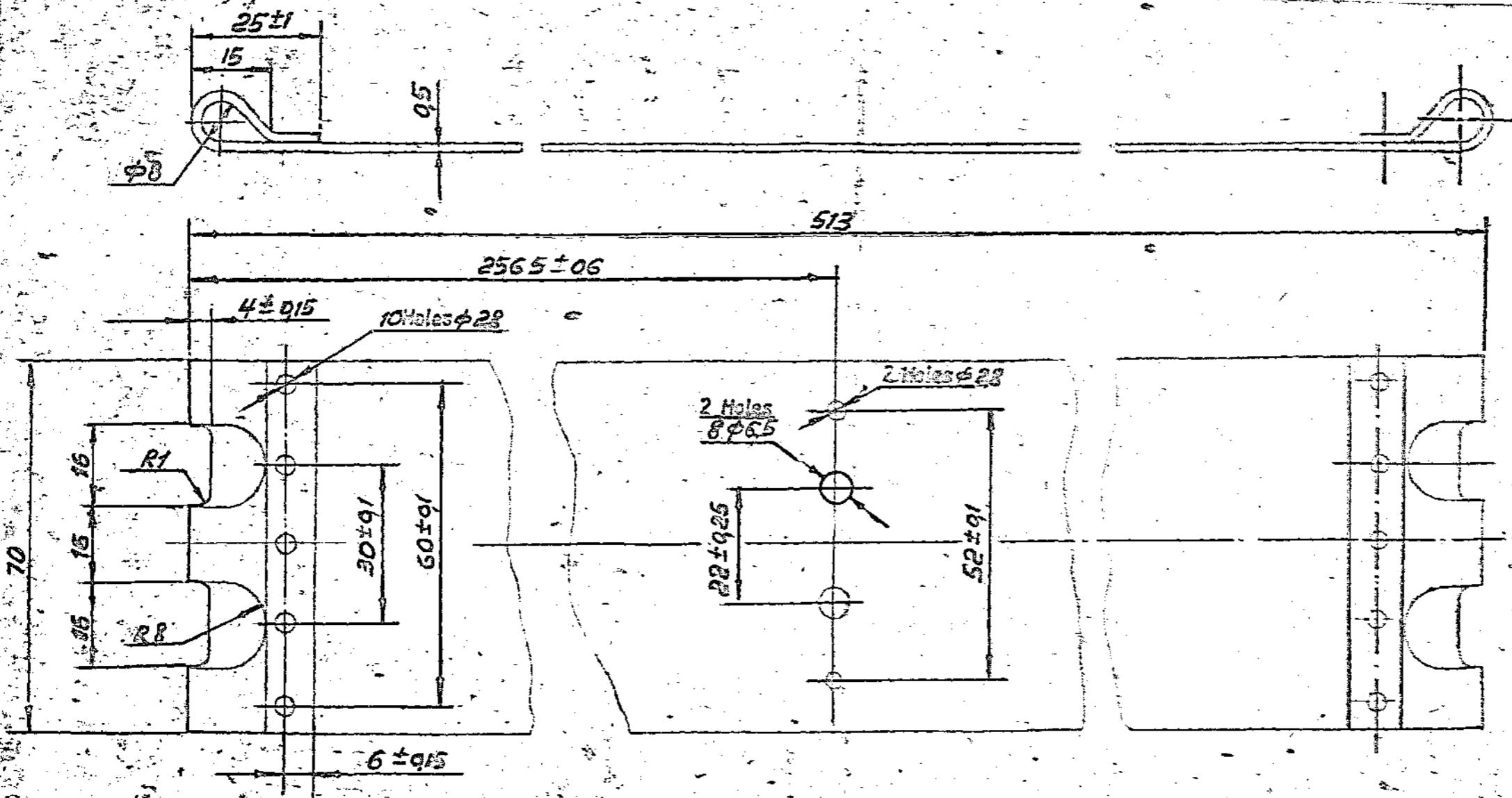
EST. MASS	TO BE STAMPED OR MARKED WHERE LOCATED THIS IS	(26)
0.255 Kg	LETTERS I	
ISSUE DATE	NATURE OF AMENDMENTS	
ORN	SCALE: 1:1	
CAD	DEVIATIONS IN mm	
ICD	TO EMPLOY DIMENSIONS UNLESS OTHERWISE STATED	
APPD	ALL THREADS CONFORM TO	
DATE 9-9-87		
MATERIAL	USED ON	002 145 H
CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI		
D.S. (A) NUMBER	DRAWING NUMBER	270.034 H

272040H

IND

Tolerances for size dimensions are as per accuracy class 7, GOST 1010.

Coating : Zinc-plating, 30 microns thick, chromatisation.



BAND YGHC - H-0.5x70  
GOST 2283-69

62

PROOF SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

EST. MASS	0.142 Kg	TO BE STAMPED OR MARKED WHERE LOCATED THUS ( LETTERS )
ISSUE DATE	NATURE OF AMENDMENTS	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED FORM TO HAVE R OUTSIDE R EQUIVALENT CHAMFERS AS FOLLOWS
SCALE	1:1	MATERIAL - SEE ABOVE USED ON 270-034 H
CONTROLLER OF INSPECTION (HEAVY VEHICLES) AVADI		
DATE 9-9-87		TITLE: BAND
		D/S PART NUMBER
		DRAWING NUMBER 272.040 H



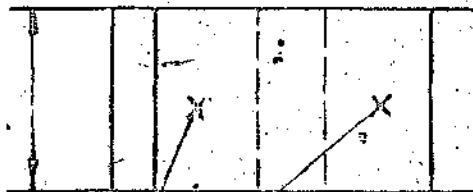
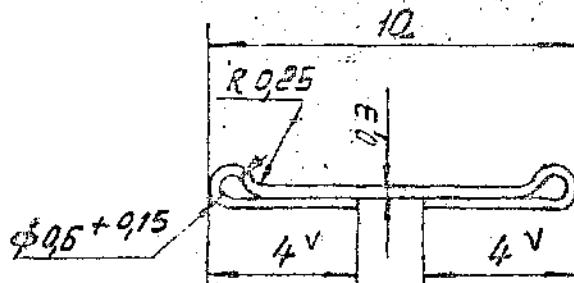
0 H962 91E

IND

Form 93

TRIPKOTM.

- 1 Tolerance for free dimensions are as per 22AT52.
- 2 Apply silver plating, 2 to 4 microns thick.  
With 3 to 5 microns thick Copper sub layer.



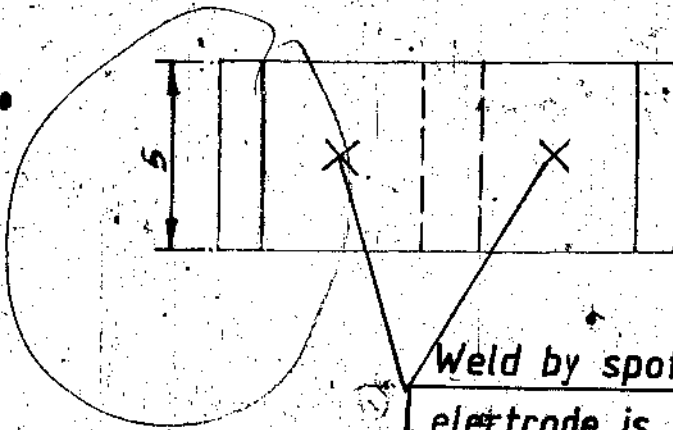
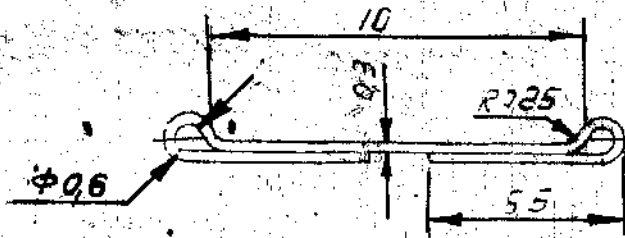
Weld at two points by electric spot welding. Diameter of electrode is φ 2 mm.

PLOT SAMPLE SHOULD BE APPROVED BY A SHOP BEFORE THE PRODUCTION.

		EST. MASS 0-00023 Kg	TO BE KEPT ON GATED LMS OF (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MATERIAL FORMER TO HAVE A OUTSIDE R BEING EQUIVALENT TO THREES ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL: <b>STEEL 10</b> <b>GOST 503-71</b>
DRW		SCALE: 5 : 1	USED ON: <b>500 155 H</b>
CHD		DIMENSIONS IN mm	CONTROLLEAF OF INSPECTION (HEAVY VEHICLES) AVADI
TCO		TOLEANCE OF DIMS UNLESS OTHERWISE STATED	<b>CLAMP</b>
APPD		ALL THREADS TO CONFORM TO	DRAWING NUMBER <b>316 296 H</b>
DATE	<b>9-9-07</b>		

203

- 1 Provide dimensions without deviations as per 22 AT 52.
- 2 Apply silver coating, 2 to 4 microns thick, with 3 to 5 microns thick copper sub layer.



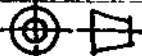
Weld by spot welding. Diameter of electrode is 3 mm.

AMDT, NOTN, No: 250-76

D-03

127

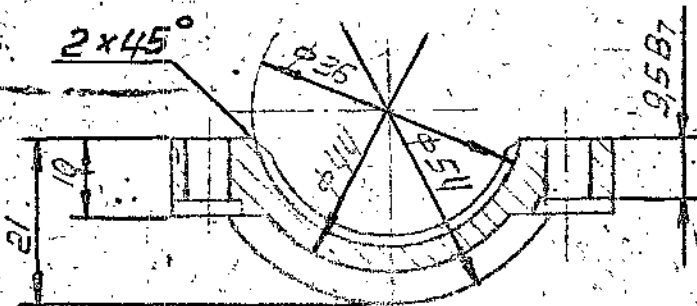
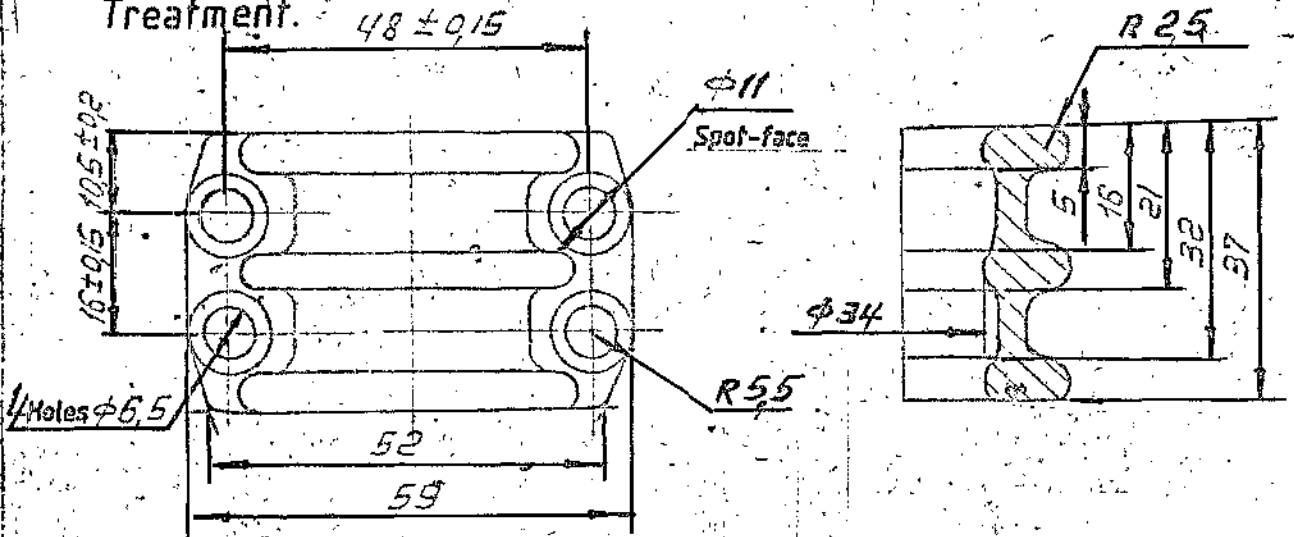
PILOT SAMPLE SHOULD BE APPROVED BY A H.S.P. BEFORE BULK PRODUCTION

			EST. MASS <b>0.00028.Kg</b>	TO BE STAMPED OR MARKED WHERE INDICATED THUS $\Phi$ .
				LETTERS I
			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		MATERIAL -- <b>STEEL 10 GOST 503 -71</b>	USED ON -- <b>500 155 H</b>
DRN	SCALE:-- 5 : 1		CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI	
CHD	DIMENSIONS IN mm			TITLE: <b>CLAMP</b>
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED		D*S CAT NUMBER	DRAWING NUMBER <b>316 516 H</b>
APPD	ALL THREADS CONFORM TO			
DATE 5-9-87				

319-012 H

2

1. Tolerances for casting as per Class 5 of standards 56-15
2. Carryout machining as per condition T-5 GOST 2685-75.
3. Pattern taper should be 2°.
4. Unspecified casting radii should be R 1,5 mm.
6. Technical requirements for casting areas per OST 190021-71 group-3.
7. Coat external surface with "Hammered" grey enamel as per instruction TM 3-47 except for spot-facings.
8. Part may be made by pressure die casting without Heat-Treatment.



ALLUMINUM ALLOY AS19  
GOST 2685-75

Coating - Anodic oxidation, chromatization.

D-83

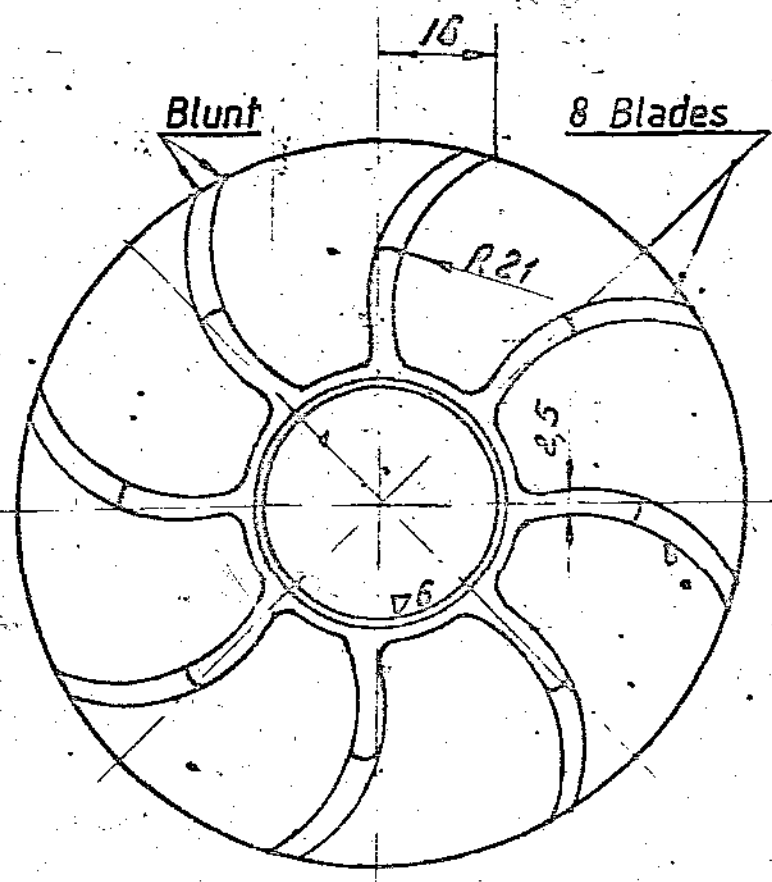
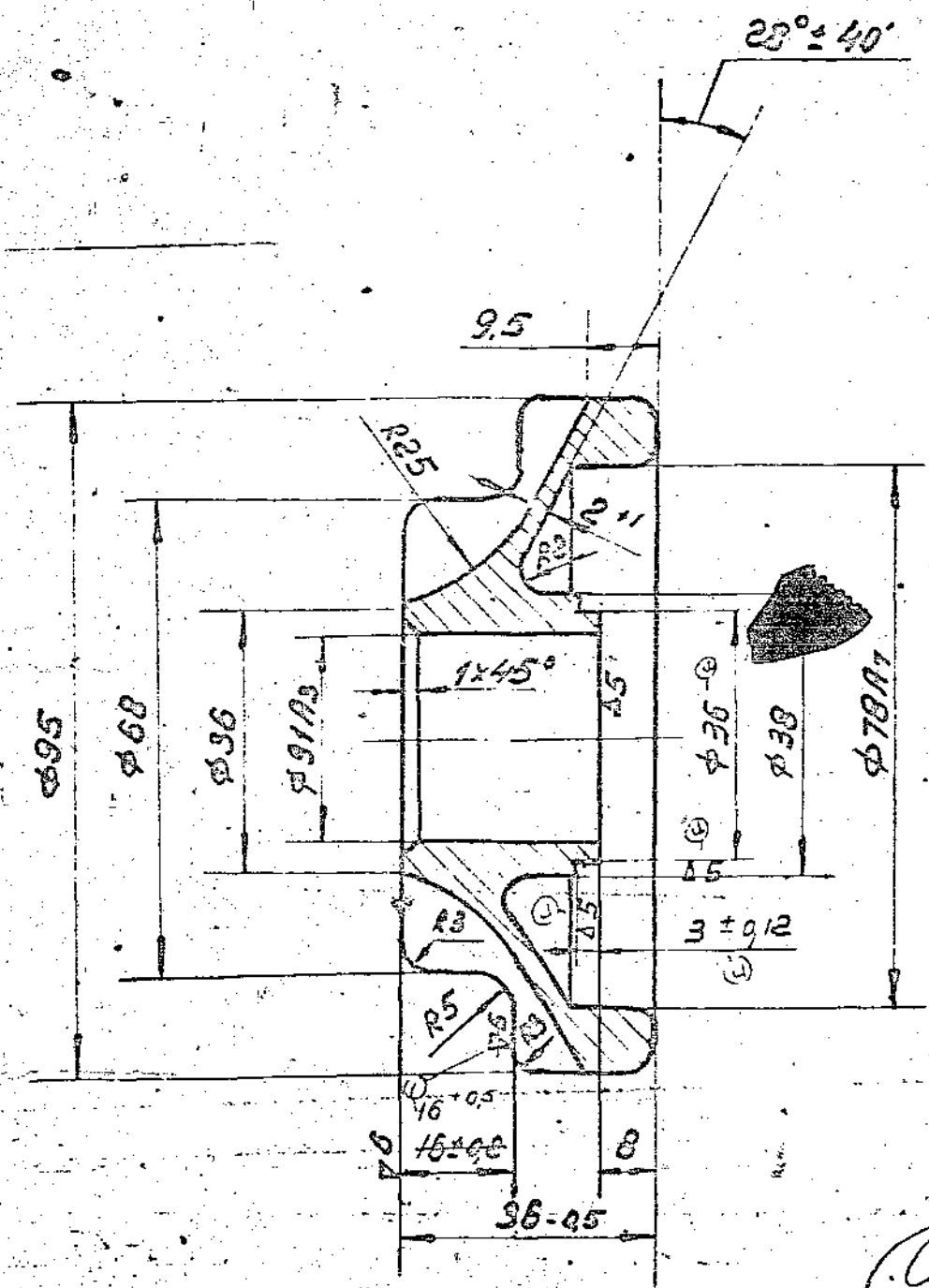
PILOT SAMPLE SHOULD BE APPROVED BY ANBP BEFORE BULK PRODUCTION

		EST. MASS 0.045 Kg	TO BE STAMPED OR INDICATED THUS  LETTERS )	65
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNER TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE		
ISSUE	DATE	NATURE OF AMENDMENTS		
DRN	SCALE:- 1:1		MATERIAL - SEE ABOVE	USED ON - 002 145H
DD	DIMENSIONS IN mm		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED		TITLE: CLAMP	
APPD	ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER 319 012 H
DATE	9-9-87			

HA70.18E

IND  
 Революция №:  
 47609500

Unless otherwise specified



- 1) Provide dimensions without deviations as per 22A7 52 class 7.
- 2) Tolerances for casting and allowances for machining are as per accuracy class 5, of standards 56-15 and 56-16 MA7.
- 3) Pattern taper should be 2°.
- 4) Casting radii should be R 2.0 mm.
- 5) Carry-out heat treatment as per condition T5 GOST 2685-75.
- 6) Anodize the part with painting in red colour as per TV 4-8.
- 7) Technical requirements for casting are as per OST 190021-71, group 3.
- 8) Casting may be made by centrifugal method.
- 9) Part may be made by pressure - die casting without heat treatment.

9 N.W.H.

ALUMINIUM ALLOY AN-9  
 GOST 2685-75

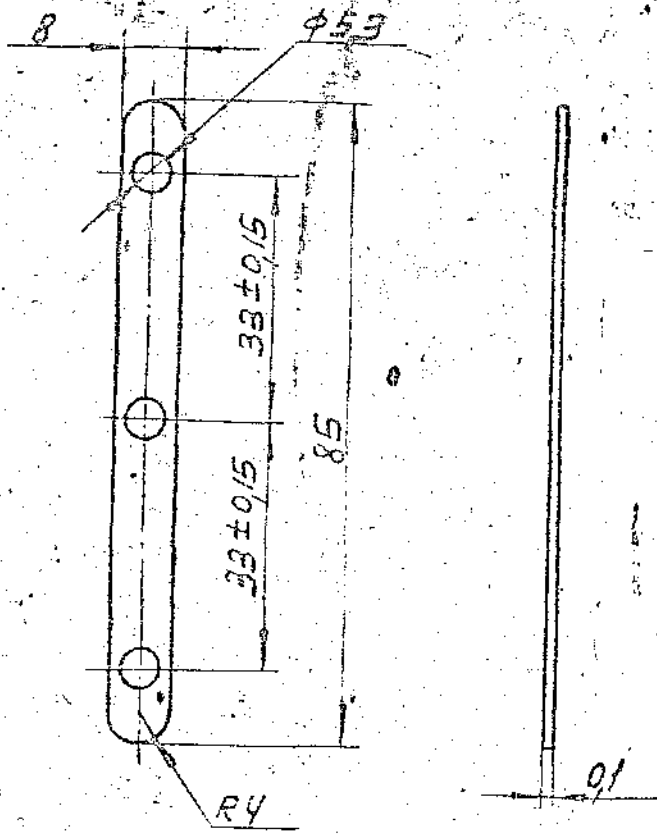
PILOT SAMPLE SHOULD BE APPROVED BY A.H.S.P. BEFORE BULK PRODUCTION

EST. MASS 0.15 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.			
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL SEE ABOVE	USED ON 500 155 H
DRAWN	SCALE: 1:1	CONTROLLER RATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHKD	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	
APPD	DATE 9-9-87	D S CAT NUMBER	
ALL THREADS CONFORM TO		DRAWING NUMBER 381-044 H	

66

388 413 H

2



100 256 H

AMDT, NOTN, No: 0026-79

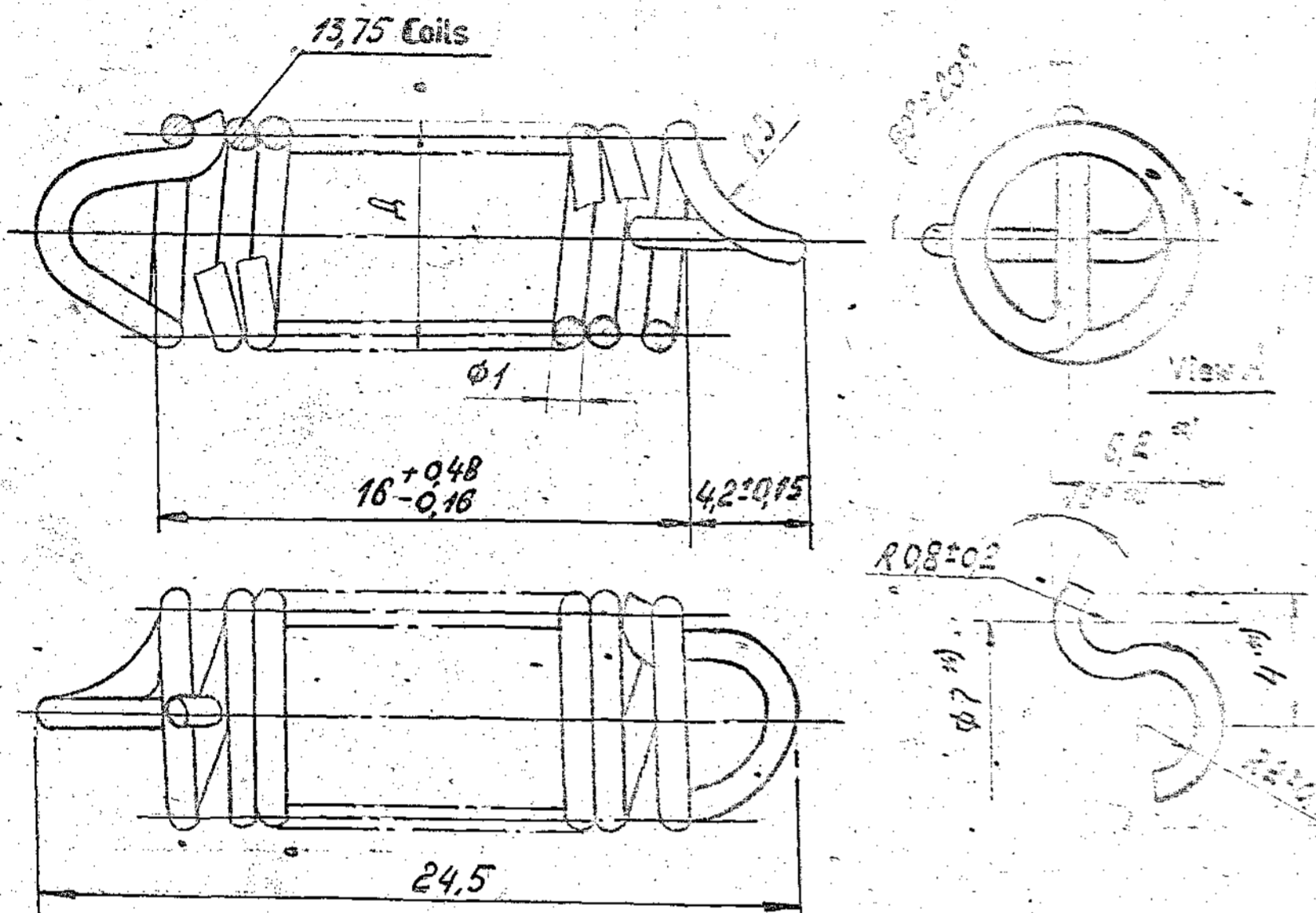
Tolerance for free dimensions are as per accuracy Class 5 (OST 1015 A<sub>5</sub>, C<sub>5</sub>) Gasket may be made from Brass  $\mathcal{N} 63$  GOST 2208-75.

0-83

PILOT SAMPLE SHOULD BE APPROVED BY A IIS P BEFORE BULK PRODUCTION

67

			EST. MASS <b>0-00052 Kg</b>	TO BE STAMPED OR MARKED WHERE INDICATED THIS W/ (LETTERS)
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R RISKIE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL - <b>BRASS ПС 59-1 GOST 2200 -75</b>	USED ON - <b>100 256 H</b>
DRN		SCALE - <b>1:1</b>	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CLD		DIMENSIONS IN mm	TITLE: <b>GASKET</b>	
TCD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	
APPO		ALL THREADS CONFORM TO	DRAWING NUMBER <b>388 413 H</b>	
DATE	<b>9-9-07</b>			



1. Tolerance for free dimensions to be as per IS 2 AT
2. Carry-out heat treatment as per IS 2-13. Hardness should be 42 to 50.
3. Pitch between the two ends of the eye may be obtained by their stretching.
4. Diameter of end coils may be as per tables 1 and 2.1.
5. Dimensions marked as \* are given for the construction of drawing.
6. Permissible displacement of R 11.04 of the eye with respect to the spring axis should not exceed 0.2 mm.
7. Permissible displacement of eyes with respect to the spring axis should not exceed 0.4 mm.
8. Undercutting and mechanical damage are not allowed at eye bands over R 3mm.
9. Force by load of 3.5 Kg for 24 hours.
10. Spring length may be increased by 0.5 mm after forcing by load.
11. Spring dimensions are given without considering the coating.
12. To obtain the given strength characteristic the external spring diameter A may be increased upto 0.2 mm for the values specified in tables.
13. Carry-out heat treatment after cadmium coating for two hours and at  $t = 180^{\circ}$  to  $200^{\circ}$ c.
14. Springs should be made from the wire having the depth of surface decarburization not exceeding 0.01 mm (for each side).

TABLE NO-1

Wire Dia.	Spring Dia, A
0.99	7.87-0.1
1	8.0 -0.1
1.01	8.07-0.1
1.02	8.17-0.1
1.03	8.28-0.1

TABLE NO-2

Wire Dia.	Spring Dia, A

Spring designation	Developed strength of spring when it is stretched upto the dimension 3/4 mm(Kgf).	Coating	Dependence of spring diameter A on wire diameter (Considering tolerance).	Remarks
443-353H-1	1.85-2.1	Chemical oxidation. Coat with varnish KP-965 GOCT 15030-70	Table no:1	

WIRE 51\*4A  
TYAEX 266-76

141  
56

69

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

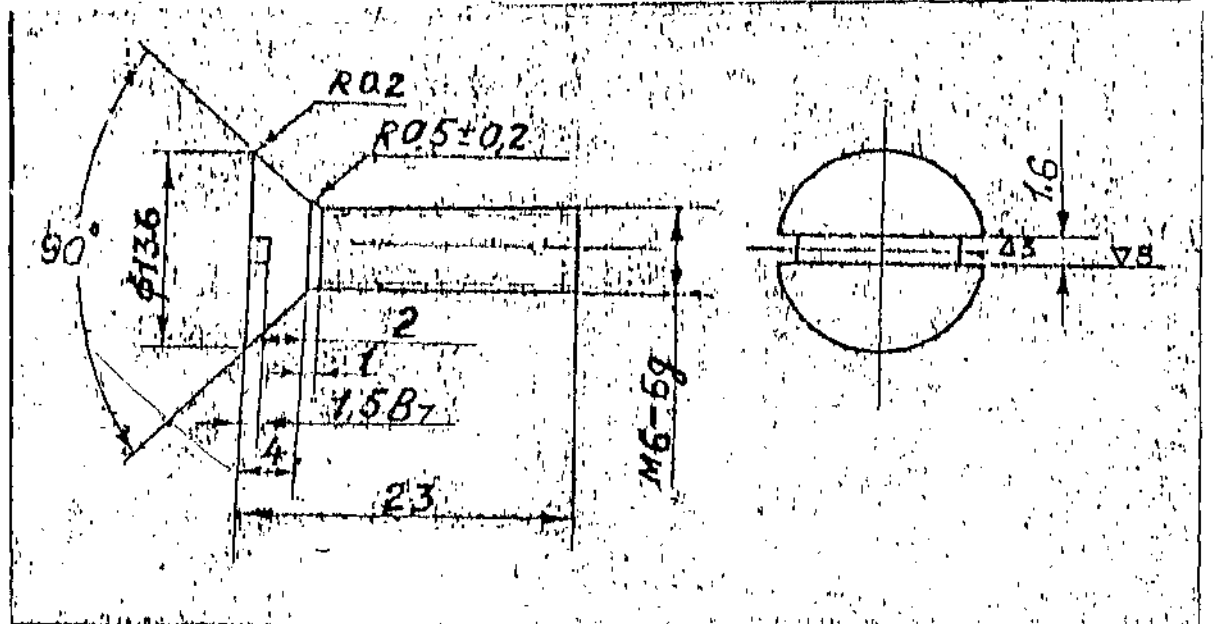
EST. MASS 0.002 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS: (LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MACHINED CORNERS TO HAVE R 0.05 ± 0.02	
ISSUE DATE	NATURE OF AMENDMENTS
DRW	SCALE: 1:1
CHKD	DIMENSIONS IN mm
YCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED
APPROV	ALL THREADS CONFORM TO
DATE 9-9-87	
MATERIAL: * SEE ABOVE	USED ON: 550 044 H
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	TITLE: SPRING
D S CAT NUMBER	DRAWING NUMBER 443-353 H



DRAWING NUMBER  
**462 328H**

UNLESS OTHERWISE SPECIFIED

DRAWING CREATED BASED ON RUSSIAN ORIGINAL ISSUE :- 5



1. PROVIDE DIMENSIONS WITHOUT DEVIATIONS AS PER ACCURACY CLASS 7, OST 1010.
2. MAKE SCREW BY HEADING METHOD WITH THREAD ROLLING.
3. CARRYOUT HEAT TREATMENT HRC 30 TO 34.
4. COATING : ZINC-PLATING 6 MICRONS THICK, CHROMATIZATION.
5. ALTERNATE MATERIAL IS STEEL 16 x CH TY 14-4-385-73.

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

EST. WT.  
0.006

TO BE STAMPED OR MARKED WHERE INDICATED THUS  $\neq$  ( 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:-  
WIRE 30XFEA  
TY 14-4-385-73


USED ON  
002-145H

ISSUE DATE NATURE OF AMENDMENTS

DRN *[Signature]* SCALE:- 2:1  
DIMENSIONS IN mm

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)  
AVADL

CHD *[Signature]*  
TCD *[Signature]*  
APPD *[Signature]*  
TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS 2102 -69

 TITLE  
**SCREW**

DATE 15 DEC 89  
CONFORM TO

D · S CAT NUMBER

DRAWING NUMBER  
**462 328H**

SIZE A4

H 4ES 297

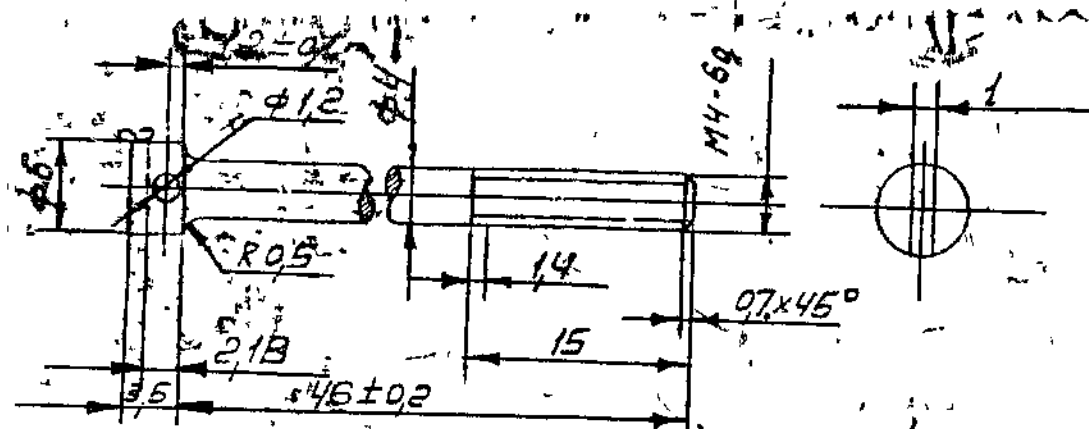
IND

Результат  
Утвержден

Лист 1 из 1  
Эскиз детали  
по ТЗ  
отв. инж. А.С.И.

√ 5 Unless otherwise specified

1. Provide dimensions without deviations as per accuracy class 7, OST 1010.
2. Make screw by heading method with thread rolling.
3. Coating : Zinc-plating 6 microns thick, chromatization



AMDT, NOTN, No: 0111-80

Q-83

002145H

\* STEEL 45 GOST 1051-73  
GOST -7417.-75

X-141

PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

73

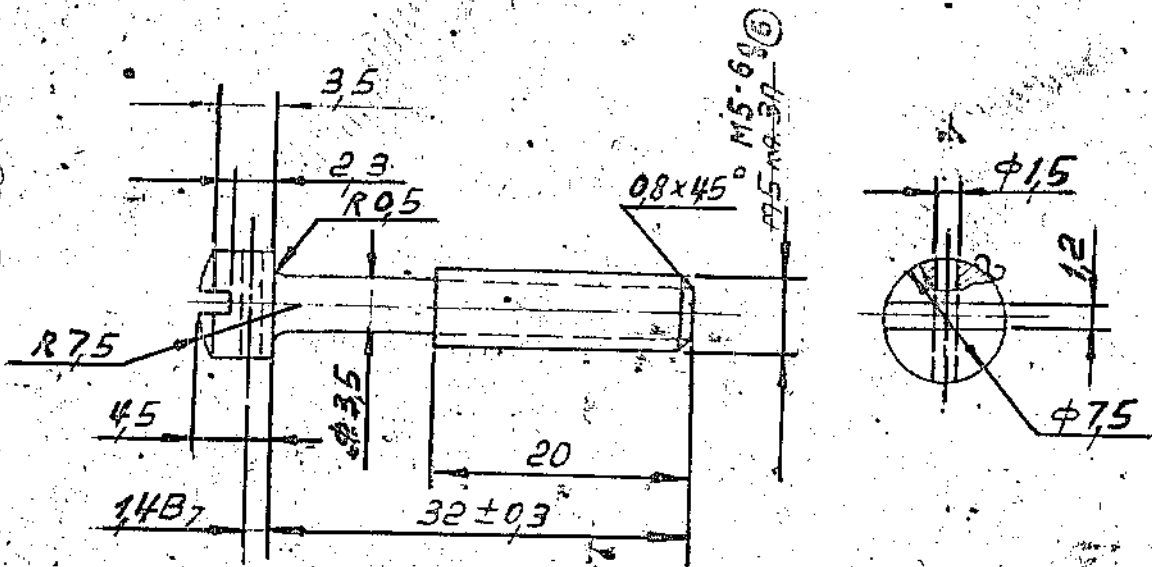
		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS
		0.005 Kg	LETTERS I
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE - 2:1	MATERIAL * SEE ABOVE
CHD		DIMENSIONS IN mm	USED ON - 002 145 H
TEC		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPD		ALL THREADS CONFORM TO	TITLE. SCREW
DATE 9-9-87			D S CAT NUMBER DRAWING NUMBER 462 534 H

H10L 797

▽5 - Unless otherwise specified.

- 1 Tolerances for free dimensions are as per accuracy Class 7.
- 3 Coating:- zinc-plating, 6 microns thick, chromiation.
- 5 Dehydrogenate.

0006 20



STEEL 45 GOST 1051-73  
GOST 7617-75

D-03

74

PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

		EST. MASS 0.005 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED RACHISED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL * SEE ABOVE	USED ON 270 034 H
DRH	SCALE:- 2:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
END	DIMENSIONS IN mm	⊕ □ TITLE: SCREW	DRAWING NUMBER 462.701 H
ICD	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	D S CAT NUMBER	
APPO	ALL THREADS CONFORM TO		
DATE 9-9-07			

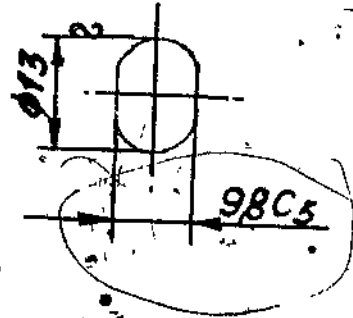
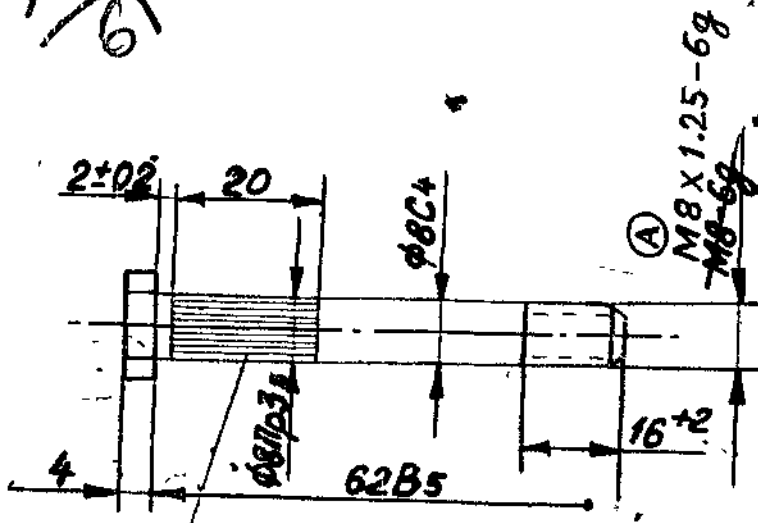
466-023H

▽5 - Unless otherwise specified,

1. Tolerance for free dimensions are as per accuracy Class 7, OST 1010.
2. Carry-out Heat Treatment. H R C 30 TO 34.
3. Knurling traces are allowed on  $\phi 8 C_4$ .
4. Coating:- Zinc-plating, 9 microns thick, chromatization. Dehydrogenate.
5. Elements of thread are as per GOST 10549-80.

NOT No. 0111-80

144/61



Straight knurling 0,8 GOST 21474-75

① Touch  
② mm no.

\* STEEL 30XA TY 14-1-950-74  
GOST 7417-75

75

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

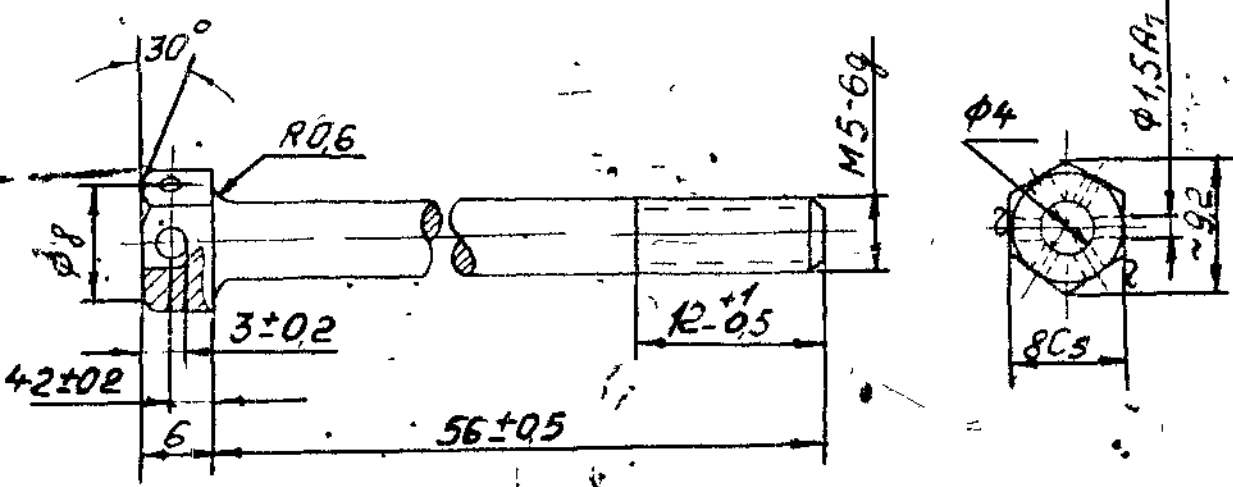
		EST. MASS 0.027 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS (IN LETTERS)
A	18.4.02	AUTHY Lt No 10023/ IND-III/506 dt 17.4.02	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE, R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL - SEE ABOVE * USED ON - 120.209 H
DRN	SCALE - 1.1		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
CHD	DIMENSIONS IN mm		
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED		TITLE BOLT
APPD	ALL THREADS CONFORM TO		D S CAT NUMBER
DATE	9-9-87		DRAWING NUMBER 466 023 H

H680-997

5 Unless otherwise specified

1. Tolerance for free dimensions are as per accuracy class 7, OST 100.
2. Carry-out heat treatment . HRC 30 to 34 .
3. Coating : Zinc-plating 9 microns thick, chromatization, Dehydrogenate,
4. Elements of thread are as per GOST 10519-80.
5. Alternate material is steel 40 x GOST 4543-71.

NOT No 0189-80



STEEL 30XA TY 14-1-950-74  
GOST 8560-78

PILOT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

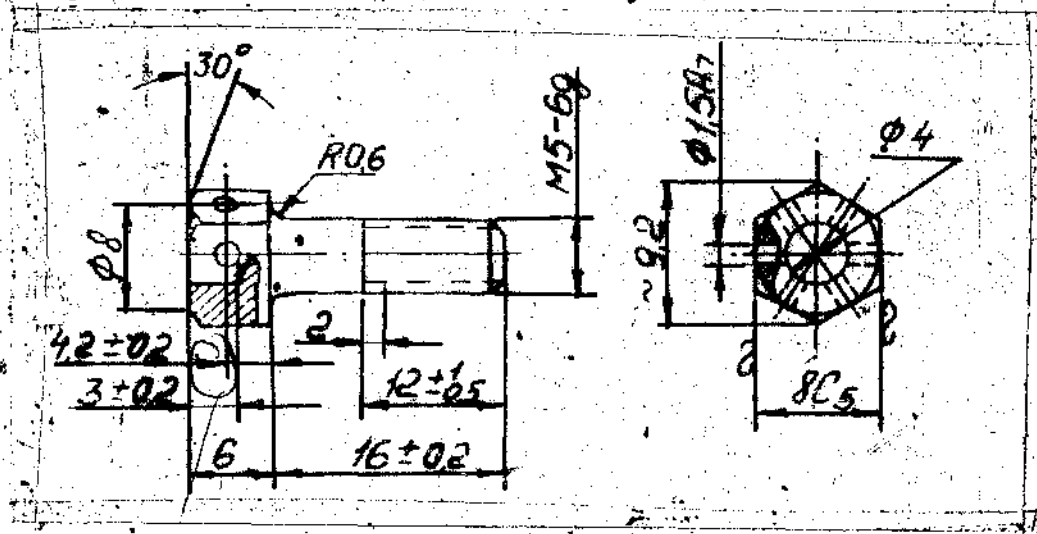
76

		EST. MASS 0-01 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 OUTSIDE. R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL - SEE ABOVE * USED ON - 002 145H
DRN		SCALE - 2:1	CONTROLLER OF INSPECTION (HEAVY VEHICLES) AVADI
CHD		DIMENSIONS IN mm	TITLE. BOLT
TCD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER
APPO		ALL THREADS CONFORM TO	DRAWING NUMBER 466.089 H
DATE	9-9-87		

DRAWING NUMBER

466-090 H

▽ 4 UNLESS OTHERWISE STATED



- 1) TOLERANCES FOR FREE DIMENSIONS ARE AS PER ACCURACY CLASS 7, OST 1010.
- 2) CARRY OUT HEAT TREATMENT H R C 30 TO 34.
- 3) COATING: ZINC PLATING, 6 MICRONS THICK, CHROMATIZATION, DEHYDROGENATE.
- 4) THREAD CHAMFER SHOULD BE AS PER GOST 10549-80.
- 5) ALTERNATE MATERIAL IS STEEL 40X, GOST 4543-71.

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83

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

EST. MASS.

0,004 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

MATERIAL:

STEEL 38XA  
TY 14-1-950-74  
GOST 8560-78

USED ON:

002-145.H

ISSUE DATE: NATURE OF AMENDMENTS

DRN SCALE: 2:1

CHD DIMENSIONS IN mm

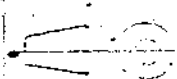
FOR THE USE OF DIMENSIONS UNLESS OTHERWISE

ALL DIMENSIONS TO BE TO DIMENSIONS

DATE: 9-9-87

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)

AYADI



BOLT

D S CAT

DRAWING NUMBER

466-090 H

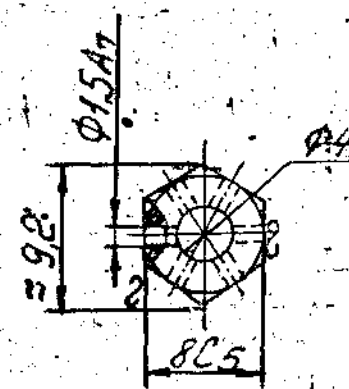
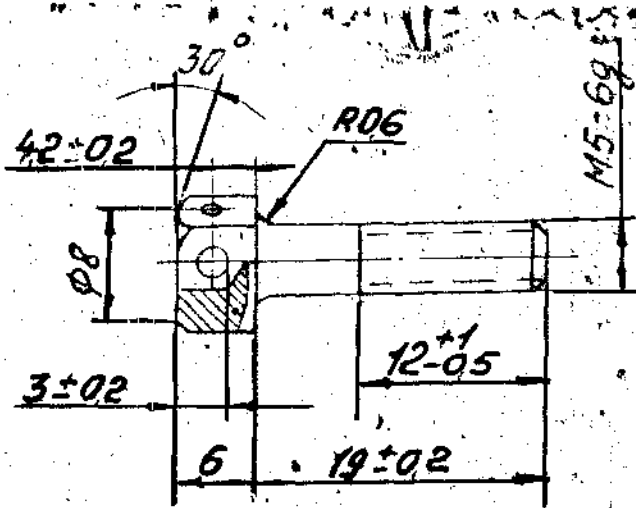
H160 994

▽5 UNLESS OTHERWISE SPECIFIED

1. TOLERANCE FOR FREE DIMENSIONS ARE AS PER ACCURACY CLASS 7, OST 1010.
  2. CARRY-OUT HEAT TREATMENT. HRC 30 TO 34.
  3. THREAD RUN-OUT SHOULD BE AS PER GOCT 10549-80.
  4. DEHYDROGENATE.
  5. THREAD CHAMFER SHOULD BE AS PER GOCT 10549-80.
  6. ALTERNATE MATERIAL IS STEEL 40X GOCT 4543-71.
- COATING: ZINC-PLATING, 6 MICRONS THICK, CHROMATIZATION.

NOT. No. 0189-80

X14.47  
64



Techn. No.

\* STEEL 30XA TY 14-1-950-74.  
GOST 8560-78

7.8

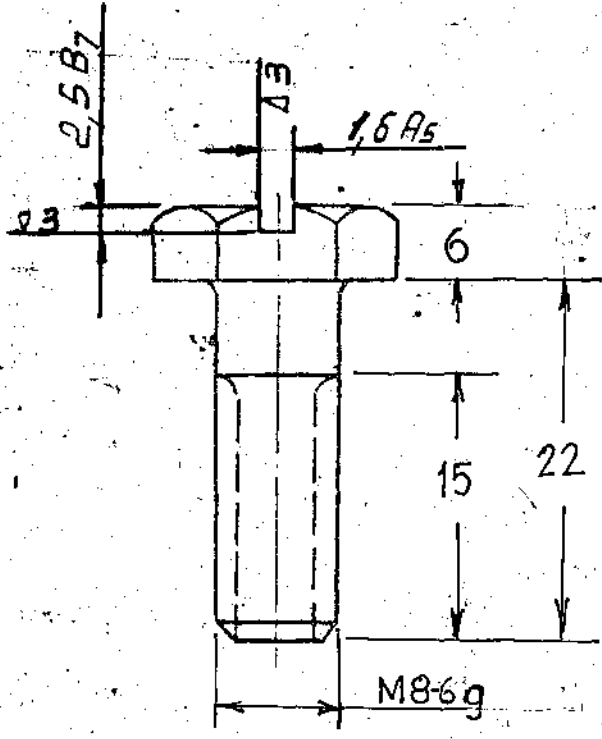
PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTERS)
0.005 Kg	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT. CHAMFERS ARE PERMISSIBLE	
DATE	NATURE OF AMENDMENTS
DATE	SCALE: - 2:1
DATE	DIMENSIONS IN mm
DATE	TOLERANCE ON DIMS UNLESS OTHERWISE STATED
DATE	ALL THREADS CONFORM TO
DATE	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI
DATE	BOLT
DATE	DRAWING NUMBER
DATE	466.091 H

466.284 H

IND

141  
65



Coating: Zinc-plating, 9 microns thick, chromatization.

Material: Steel Grade 45 to GOST 1050-74

0-83

PILOT SAMPLE SHOULD BE APPROVED BY AHSF BEFORE BULK PRODUCTION

		EST. MASS 0.015 Kg	TO BE STAMPED (AS INDICATED THIS IS LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNER TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	
DNN	18	SCALE: 2:1	MATERIAL: SEE TITLE USED ON: 002-145 H
CND	18	DIMENSIONS IN mm	CONTROLLER OF INSPECTION (HEAVY VEHICLES) AVADI
TCD	18	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: BOLT BLANK STANDARD 300 1A 8-22-5 TI (WITHOUT COATING)
APD	18	ALL THREADS TO CONFORM TO	D/S CAT NUMBER DRAWING NUMBER
DATE	9-9-87		466.284 H

467.005H

Ремонт №

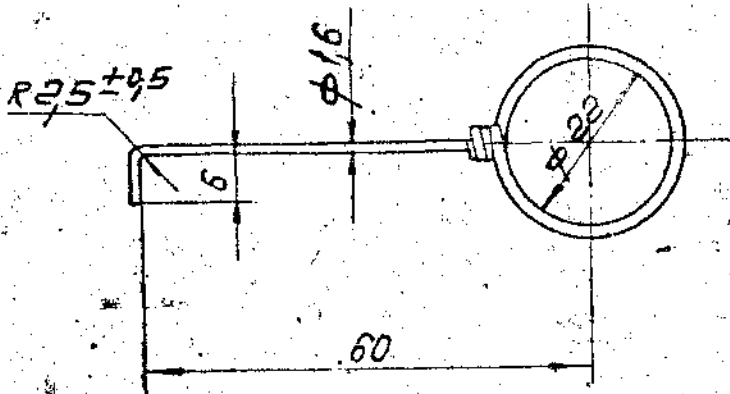
Устройства:

Исполнение:   
 по 1 кз. точности системы   
 ив. р. п. н. в. у. н. 100

1. TOLERANCES FOR FREE DIMENSIONS ARE AS PER ACCURACY CLASS 7, OST 1010.

2. APPLY SHINING ZINC-PLATING, 5 TO 8 MICRONS THICK.

141  
66



\*\* STEEL 20 GOST 1050-74

PILOT SAMPLE SHOULD BE APPROVED BY A HSP OFFICER BEFORE PRODUCTION

(131)

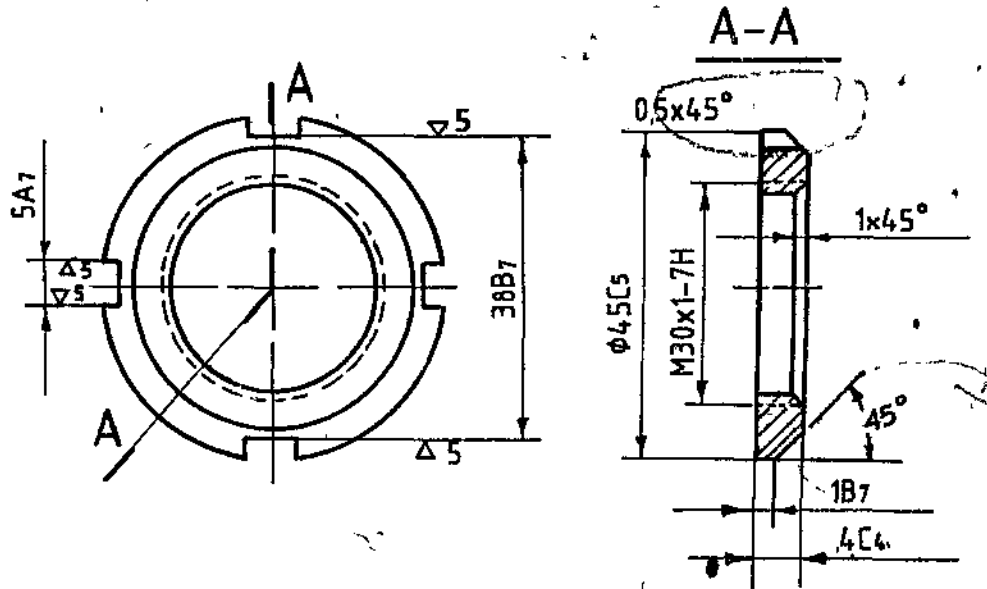
D83

ISSUE DATE	NATURE OF AMENDMENTS	EST. CLASS	TO BE SELECTED OR MARKED WHERE INDICATED THIS #
DRN <i>CPL</i>	SCALE: 1:1		SECTION 1
CHK <i>SP</i>	DIMENSIONS IN mm		ALL CHAMP EDGES AND CORNERS TO BE ROUNDED UNLESS OTHERWISE STATED. ROUNDED CORNERS TO HAVE R OUTSIDE UNLESS EQUIVALENT CHAMFERS ARE PREFERRED.
YCD <i>SP</i>	TOLERANCE ON DIMS UNLESS OTHERWISE STATED		USED ON
APPRO <i>SP</i>	ALL THREADS CONFORM TO	** SEE ABOVE	CONTROLLER (ATE OF INSPECTION HEAVY VEHICLES) AVADI
DATES 9.87	TO	D S CAT NUMBER	TITLE: HOOK
			DRAWING NUMBER: 467-005 H

DRAWING NUMBER

471-077 H

▽ 6 UNLESS OTHERWISE SPECIFIED



- 1) PERMISSIBLE END PLAY FROM CHAMFER SIDE WITH RESPECT TO THREAD SHOULD NOT EXCEED 0,08mm OVER  $\phi$  35mm
- 2) COATING. ZINC-PLATING, 6 MICRONS THICK CHROMATIZATION

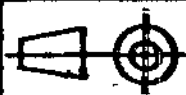
AMDT No 0111-80

D  
83

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

		EST. MASS 0,0304 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	
		MATERIAL: STEEL 45 GOST 1050-74	USED ON: 002-145 H
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE - 1 1	
CHD		DIMENSIONS IN mm	
TEC		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED.	
APPD		ALL THREADS CONFORM TO	
DATE	9-9-07		
SIZE A4		D S CAT NUMBER	DRAWING NUMBER 471-077 H

79



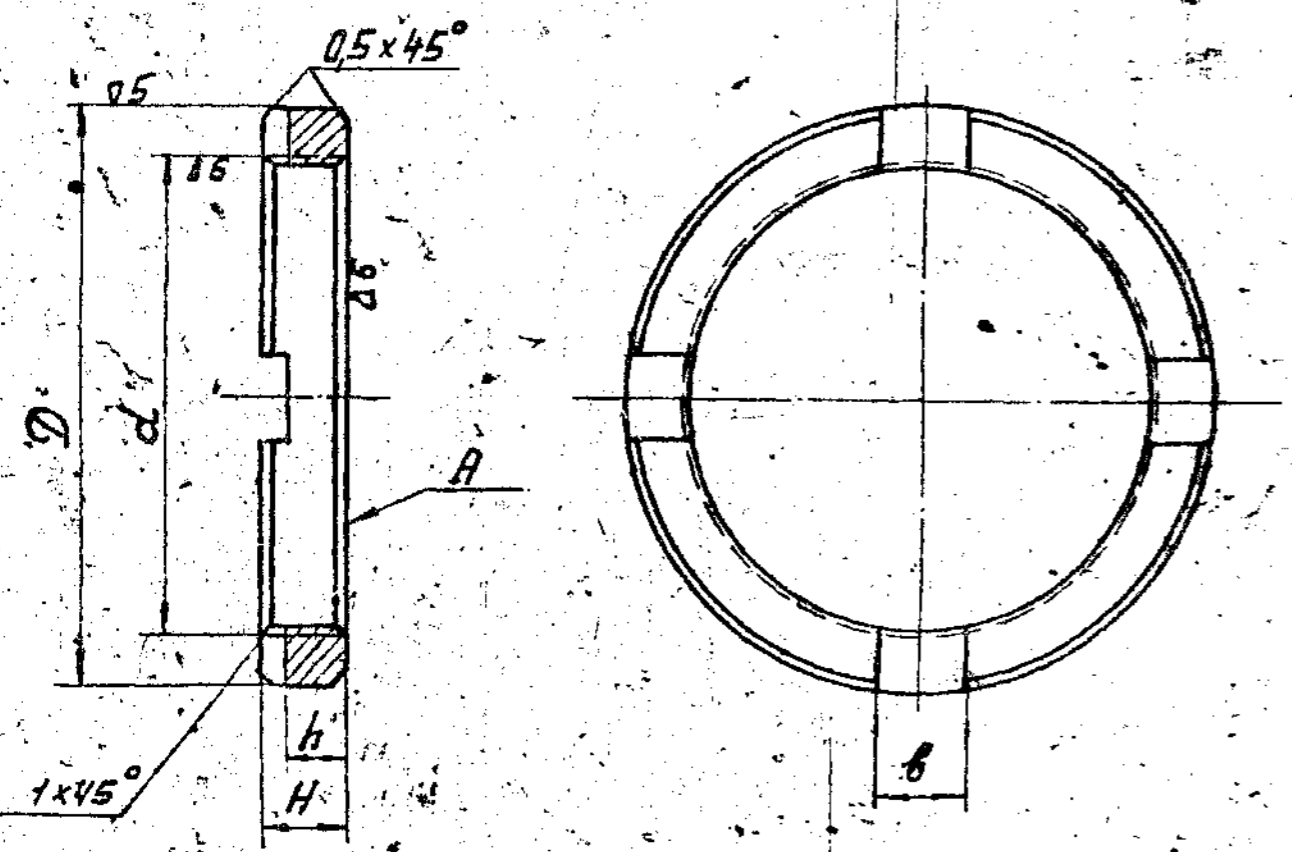
TITLE:-

ROUND NUT

HLB/14h

▽ 4 Unless otherwise specified

1. Tolerances for free dimensions are as per 722 AT.
2. Threaded chamfer is as per GOST 1049-63.
3. End play  $A^*$  with respect to thread not exceeding 0,08 mm is allowed. carry out hardening HRC 33 to 39.
4. Nuts marked with \* are allowed to be made with two splines.



No. of nut	d	D	H Permissible deviations as per C <sub>5</sub> is .	h Permissible deviations ±0,2	Mass	Remarks
471.137H-11	M64x15-7H	75	10	7	0,110	

(80)

PROT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE USE IN PRODUCTION

EST. MASS	TO BE STAMPED & MARKED WHERE INDICATED IN THIS DRAWING
ISSUE DATE	NATURE OF AMENDMENTS
SCALE: - 1:1	DIMENSIONS IN mm
TOLERANCE ON DIMS UNLESS OTHERWISE STATED	ALL THREADS CONFORM TO
DATE 9-9-87	
EST. MASS	TO BE STAMPED & MARKED WHERE INDICATED IN THIS DRAWING
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED	INDICATED EDGES TO HAVE R OUTSIDE R IF MORE EQUIVALENT FILLS ARE PERMISSIBLE
MATERIAL - STEEL 30XPCA TY 14-3-675-78	USED ON - 520 097 H
CONTROL (STATE OF INSPECTION HEAVY VEHICLES) AVADH	TITLE: ROUND NUT
D S CAT NUMBER	DRAWING NUMBER 471-137 H

H. 501-7L7

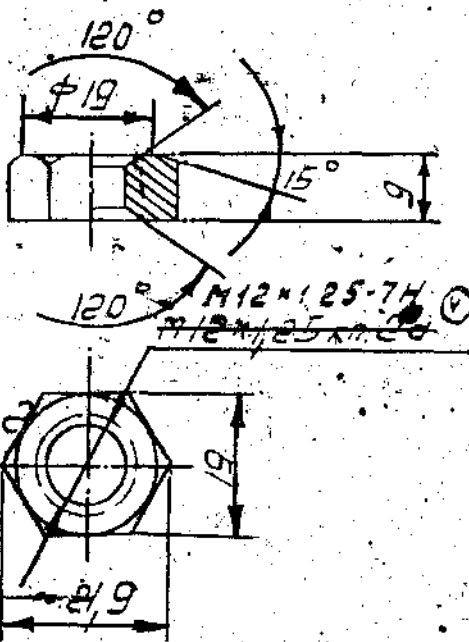
INDI

IND

▽4 UNLESS OTHERWISE SPECIFIED

1. TOLERANCES FOR FREE DIMENSIONS ARE AS PER ACCURACY CLASS 7, OST 1010.
2. MAKE CHAMFERS AT DEPTH OF THREAD.
3. FLAT END PLAY OF NUT WITH RESPECT TO THREAD SHOULD NOT EXCEED 0.08mm OVER  $\phi$  18mm.
4. COATING: ZINC-PLATING, 6 MICRONS THICK, CHROMATIZATION

7/4/1  
69



AMDT, NOTN, No: 0189-80

Amdt. Notn. No.

0-83

81

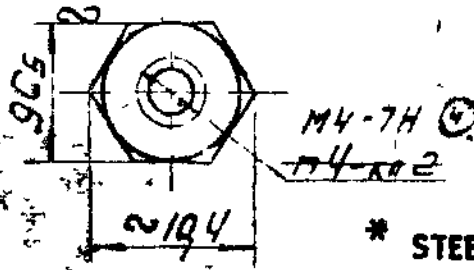
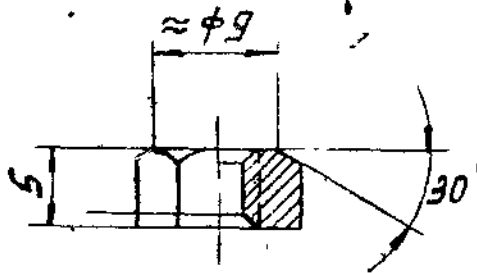
PILOT SAMPLE SHOULD BE APPROVED BY A.H.S.P. BEFORE BULK PRODUCTION

ISSUE DATE	NATURE OF AMENDMENTS	EST. MASS <b>0.015 Kg</b>	TO BE STAMPED OR MARKED WHERE INDICATED THUS: (LETTERS)
DRN	SCALE: 1:1	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
CHO	DIMENSIONS IN mm	MATERIAL <b>STEEL 45 GOST 8560 -78</b>	USED ON <b>500 155 H</b>
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI	<b>NUT</b>
APPD	ALL THREADS CONFORM TO	D.S. CAT NUMBER	DRAWING NUMBER <b>474 105 H</b>
DATE 9-9-87			

H901 HLH

UNLESS OTHERWISE SPECIFIED

1. TOLERANCES FOR FREE DIMENSIONS ARE AS PER ACCURACY CLASS 7 OST 1010.
2. COATING: ZINC-PLATING, 6 MICRONS THICK, CHROMATIZATION. DEHYDROGENATE.
3. THREAD CHAMFERS SHOULD BE AS PER GOST 10549-63.



100 256 H

\* STEEL 45 GOST 1560-78

AMDT, NOTN, No: 0189-80

0-83

PROT SAMPLE SHOULD BE APPROVED BY ANSP BEFORE BULK PRODUCTION

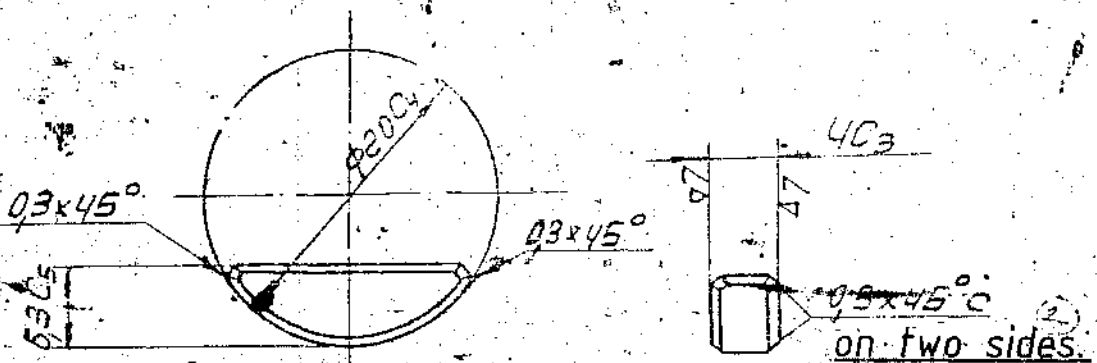
		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)	(82)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE		
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL	USED ON	100 256 H
DRAWN	SCALE	* SEE ABOVE	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHKD	DIMENSIONS IN mm	TITLE	NUT	
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	DRAWING NUMBER	
APPROV	ALL THREADS CONFORM TO		474 106 H	
DATE 9-9-87				

H.020-8L7

▽6 Unless otherwise specified.

Carry out heat treatment, HRC 30 to 34.

X141  
7/



\* STEEL 30X Γ CA GOST 7417 -75  
TY 14 -1 -950 -74

AMDT. NOTIN No: 002A-79

D-83

83

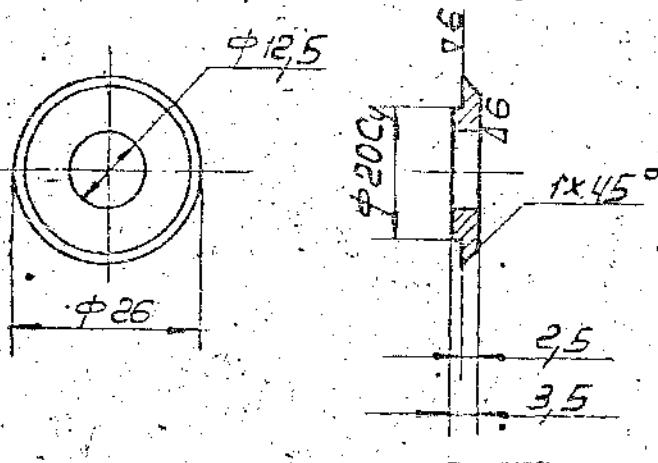
PROT SAMPLE SHOULD BE APPROVED BY A.H.S.P BEFORE BULK PRODUCTION

		NET MASS 0.003 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS (P (LETTERS))
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R GUIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL * SEE ABOVE	USED ON - 500 155 H
DRN	SCALE - 2:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD	DIMENSIONS IN mm	TITLE: KEY	
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D'S CAT NUMBER	DRAWING NUMBER 478 020 H
APPD	ALL THREADS CONFORM TO		
DATE 9-9-87			

H 817-187

▽ 4-Unless otherwise specified.

1. Tolerances for free dimensions are as per accuracy class 7 OST 1010.
2. Carry-out heat treatment. HRC 30 to 36.



Coating: Zinc-plating, 9 microns thick, chromization.

\* STEEL 30X1 CA GOST 7417 -75  
TY 14 -1 -950 -74

AHTI NOSTIN No.0024-79

D-83

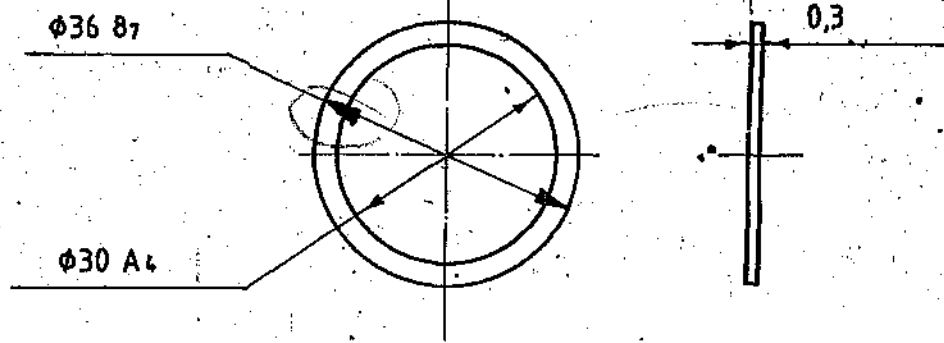
PROT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS ( LETTERS )
		0-008 Kg	
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED EDGERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT DIAMETERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE: 1:1	MATERIAL: * SEE ABOVE
CHD		DIMENSIONS IN mm	USED ON: 500 155 H
TCO		TOLERANCE ON DRNS UNLESS OTHERWISE STATED	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPD		ALL THREADS CONFORM TO	⊕ ⊞ TITLE: WASHER
DATE	9-9-87		D S CAT NUMBER: DRAWING NUMBER: 481 418 H

DRAWING NUMBER

481-430 H

2



DEHYDROGENATE

COATING: ZINC-PLATING, 9 MICRONS THICK,

CHROMATIZATION.

AMDT No 0057-82



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

EST. MASS.

0,0008 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.

MATERIAL:

STRIP C-H-0,3x40

GOST 2283-79

USED ON:

002-145 H

85

ISSUE DATE

NATURE OF AMENDMENTS

DRN

SCALE - 1 : 1

CHD

DIMENSIONS IN mm

TCD

TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED.

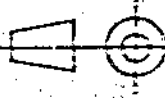
APPD

ALL THREADS CONFORM TO

DATE

9-9-87

SIZE A4



TITLE:

WASHER

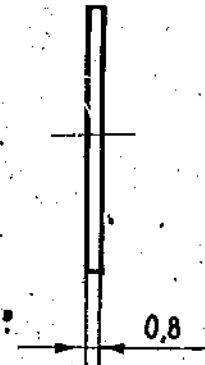
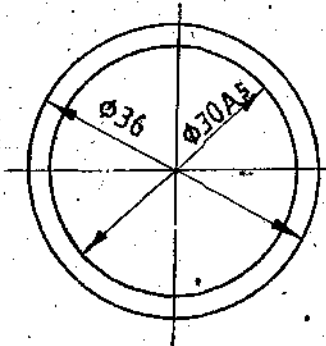
D S CAT. NUMBER

DRAWING NUMBER

481-430 H

DRAWING NUMBER

481-738 H

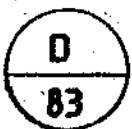


1) TOLERANCE FOR FREE DIMENSIONS ARE AS PER 22A T 52

2) DEHYDROGENATE.

COATING: ZINC-PLATING, 9 MICRONS THICK, CHROMATIZATION.

AMDT No 0020-79



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

EST. MASS.

0,0024 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.

MATERIAL:

SHEET 6 GOST 19904-74  
II - F 10 GOST 16523-70

USED ON:

002-145H

86

ISSUE DATE NATURE OF AMENDMENTS

DRN SCALE - 1:1

CHD DIMENSIONS IN mm

TED TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED.

APPD ALL THREADS CONFORM TO

DATE 9-9-87

SIZE A4

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI



TITLE:-

WASHER

D S CAT NUMBER

DRAWING NUMBER

481-738 H

483.008 H

IND

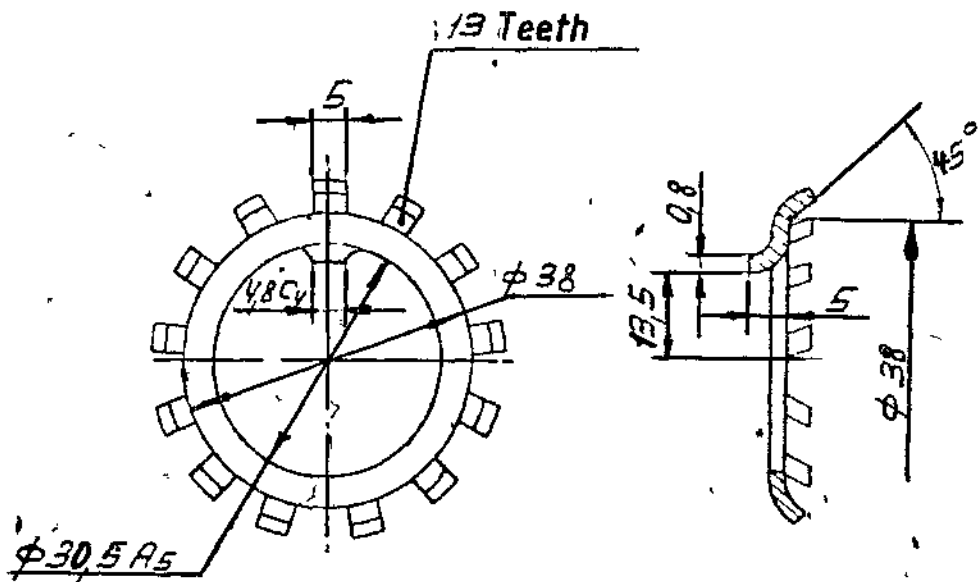
Period

Универс

He...  
...  
...  
...

124  
75

1. Tolerances for free dimensions are as per accuracy class 7, OST 1010.
2. Dehydrogenate
3. Diameter of reamer is  $\phi 49.4$  mm



Coating : Zinc-plated, 12 microns thick chromated.

SHEET 6 GOST 19904 -74  
II Г10 GOST 16523-70

NUT-NO 0040-79

124  
75

124  
75

87

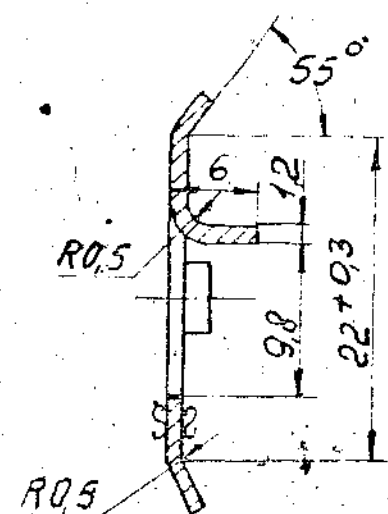
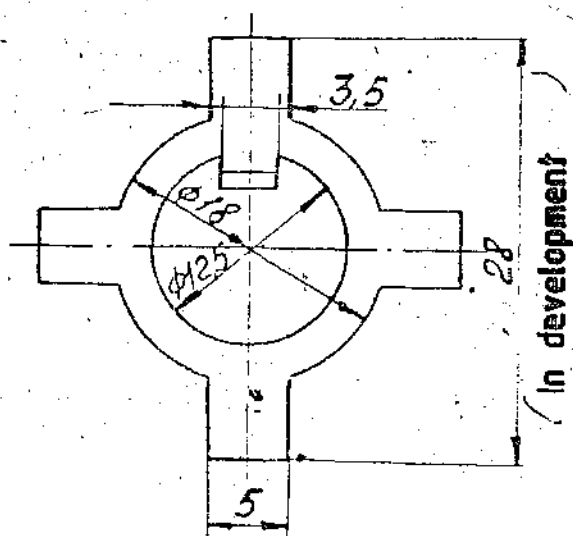
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

		EST. MASS 0.005 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS: (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED FACED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PREFERABLE	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL * SEE ABOVE	USED ON 002 145 H
DRN	SCALE - 1 1	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD	DIMENSIONS IN mm	TITLE LOCK WASHER	
TCO	TOLERANCE IN mm UNLESS OTHERWISE STATED	D S CAT NUMBER	DRAWING NUMBER 483.008 H
APPD	ALL THREADS CONFORM TO		
DATE 9-9-87	TO		

1. Tolerances for free dimensions are as per accuracy Class 7, OST 1010.
2. Dehydrogenate.

COATING: ZINC-PLATING, 9 MICRONS THICK, CHROMATZATION.

X/4-1  
7/3



AMDT. NOTN. No. 0020-79

553

D-83

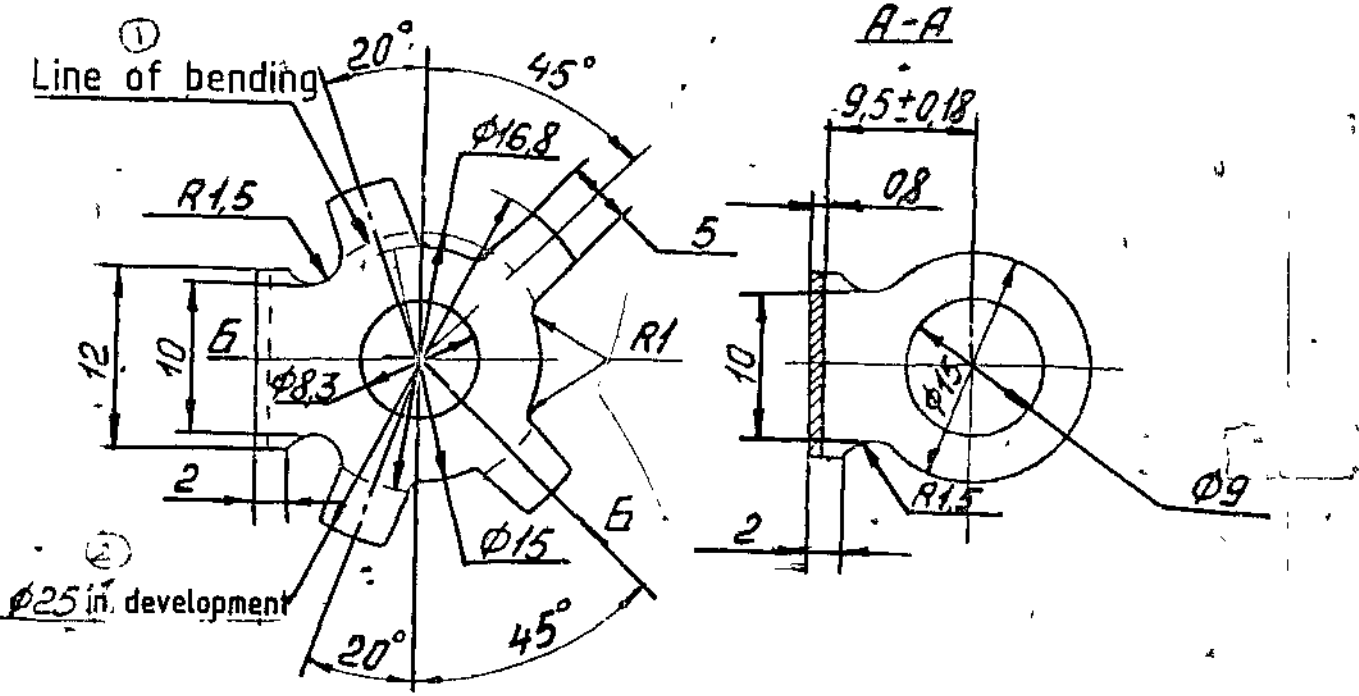
\* SHEET 6 GOST 19904 -74  
II T10 GOST -16523-70

PROT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

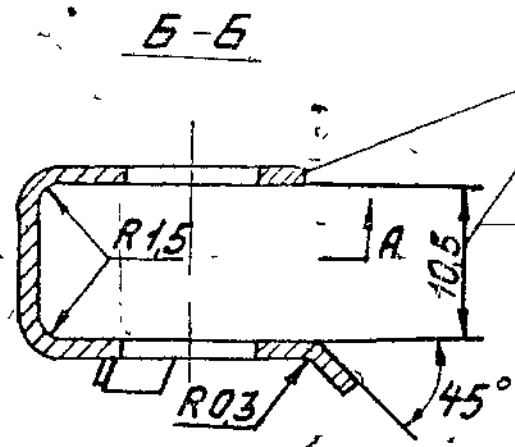
		EST. MASS <b>0.006 Kg</b>	TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL * SEE ABOVE	USED ON :- <b>500 155 H</b>
DRM	SCALE:- <b>2 : 1</b>	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES ) AVADI	
CHD	DIMENSIONS IN mm	TITLE: <b>LOCK WASHER</b>	
TCD	TOLERANCE ON DRIMS UNLESS OTHERWISE STATED	⊕ ⊖	DRAWING NUMBER <b>483 093 H</b>
APPO	ALL THREADS CONFORM TO	D S CAT NUMBER	
DATE 9-9-87			

114  
77

- 1) Tolerance for free dimensions are as per accuracy class 7, OST 1010
2. Coating: Zinc-plating, 9 microns thick chromatization
- 3 Dehydrogenate



AMDT, NPTN, No 0020-79



114  
\* SHEET 6704-74  
1-10-001 16523-70

D-83

90

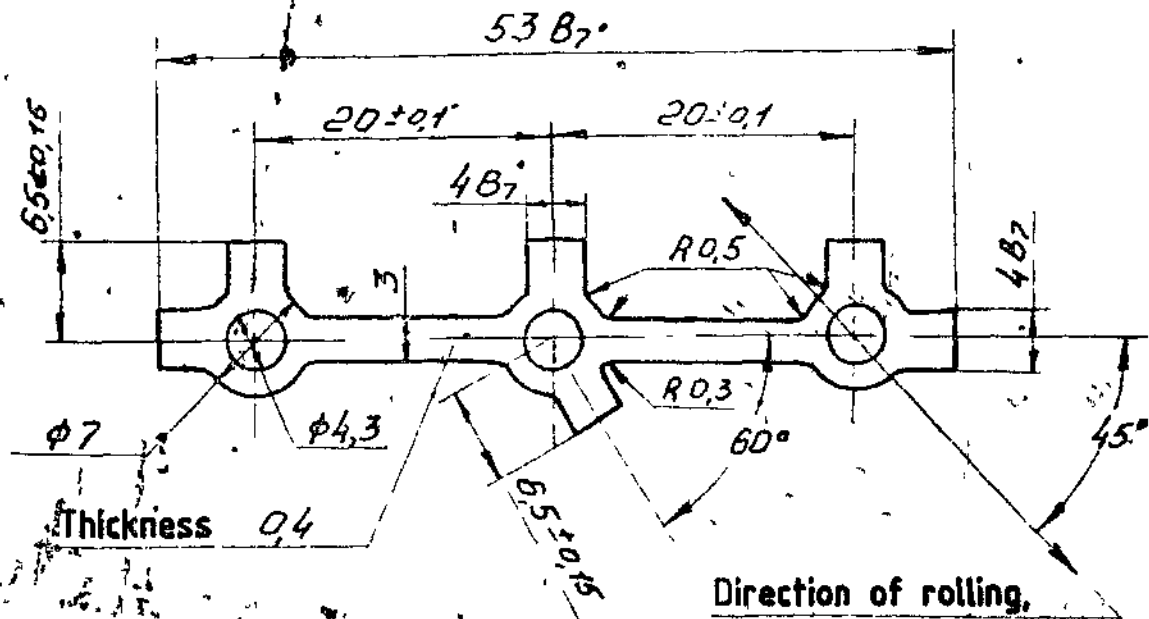
PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION!

			EST. MASS <b>0.004 Kg</b>	TO BE STAMPED OR MARKED WHERE INDICATED THUS 41- LETTERS )
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISS JE	DATE	NATURE OF AMENDMENTS	MATERIAL - <b>* SEE ABOVE</b>	USED ON - <b>002 145 H</b>
DRN		SCALE - <b>2:1</b>	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD		DIMENSIONS IN mm	TITLE. <b>LOCK WASHER</b>	
TCD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	
APPD		ALL THREADS CONFORM TO	DRAWING NUMBER <b>483.095 H</b>	
DATE	<b>9-9-87</b>			

483-157H

X14-1  
78

Tolerance for free dimensions are as per 22 AT 52



COATING: ZINC-PLATING 9 MICRONS THICK, CHROMATISATION  
DEHYDROGENATE

\*\* SOFT STEEL 10 GOST 503-71

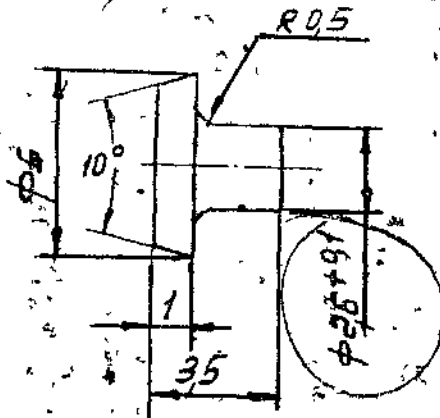
X14-1  
78

128

PROT SAMPLE SHOULD BE APPROVED BY A.I.P. BEFORE ANY FURTHER...

ISSUE	DATE	NATURE OF AMENDMENTS	EST HAS	TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTERS)
DRW	CPB	SCALE - 2.1		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED TO HAVE IT OUTSIDE. ALL LARGE EQUIVALENT SHARPERS ARE PERMISSIBLE.
(12)		DIMENSIONS IN mm	MATERIAL - ** SEE ABOVE	USED ON - 100 256H
TCO		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APPD		ALL THREADS TO CONFORM TO	LOCK WASHER	
DATE	9-9-87		DRAWING NUMBER	483-157 H

Tolerances for free dimensions are as per accuracy class 7,0ST 1010.



AMDT, NOTN, No: 0024-79

1. Coating: Chemically oxidization chromatization.

D-83

\* Aluminium alloy AM U  
GOST 14830-76

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

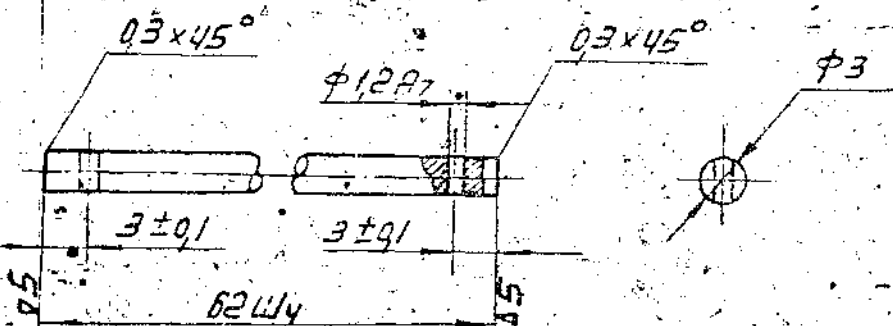
		EST. MASS <b>0-0005 Kg</b>	TO BE STAMPED OR MARKED WHERE INDICATED THIS BY LETTERS
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL - <b>* SEE ABOVE</b>	USED ON <b>270-034 H</b>
DRN <i>[Signature]</i>	SCALE - 5:1	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD <i>[Signature]</i>	DIMENSIONS BY GOST	RIVET	
TCD <i>[Signature]</i>	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	D S CAT NUMBER	
APPO <i>[Signature]</i>	ALL THREADS CONFORM TO	DRAWING NO. BULK <b>488.109 H</b>	
DATE 9-9-87			

H800 16h

Unless otherwise Specified

Dehydrogenate

141  
80



Coating : Zinc-plated, 9 microns thick, chromated

D-83

PLOT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

		EST. MASS 0.0005 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS # (92) 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	MATERIAL :- WIRE 3-10 GOST 5663 -79	USED ON :- 550 044 H
DRN	SCALE:- 2:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD	DIMENSIONS IN mm	⊕ □	TITLE: PIN
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	DRAWING NUMBER 491 008 H
APPO	ALL THREADS CONFORM TO		
DATE 9-9-87			

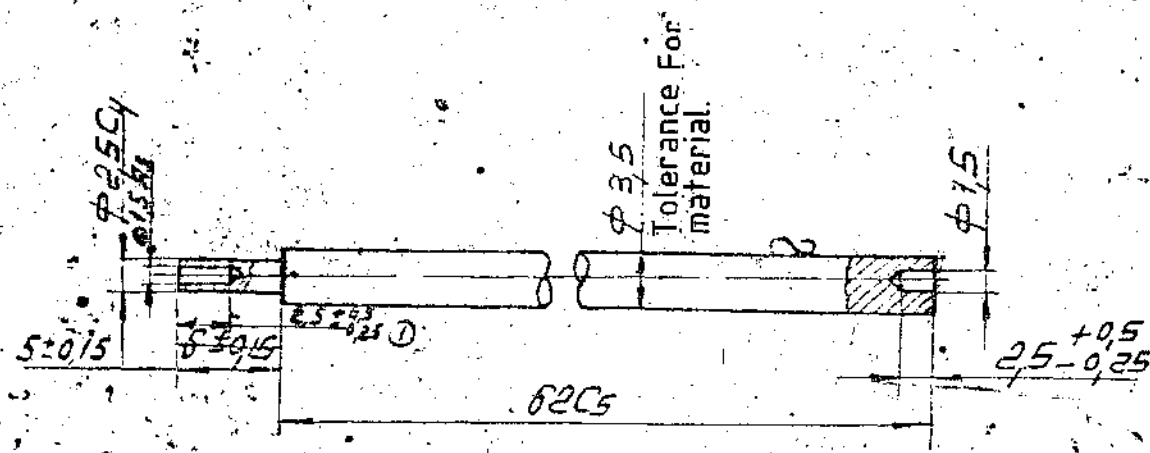
① M60016h

IND

95 - Unless otherwise specified.

- 1. Tolerances for free dimensions are as per accuracy class 7: OST 1010.
- 2. Dehydrogenate.

*Handwritten:* 1/4  
81



AMDT, NOTN, No 0057-02

Coating: Zinc - plated, 9microns thick chromated.

① 0-83

① 93

PROT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

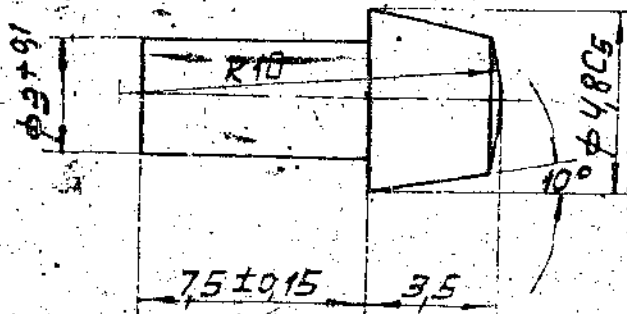
		EST. MASS 0.006 Kg	TO BE STAMPED OR MARKED WHERE DEDICATED THIS IS (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE: 2:1	MATERIAL: WIRE 3-5-10 GOST 5663-79 USED ON: 550 044 H
CHKD		DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: * PIN
APPD		ALL THREADS CONFORM TO	D S CAT NUMBER
DATE 9-9-87			DRAWING NUMBER 491 009 H

100 167

IND

05.

1. Tolerances for free dimensions are as per accuracy class 7 OST 1010.
2. Coating" Zinc-plated, 9 microns thick, chromatised.
3. Pin may be made from wire 3-10 GOCT 5663-79.



100: 256 H

\* STEEL 10  
 GOST 1051-73 GOST 7417-75

AMDT, NOTN, No: 0051-82

Q-83

PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

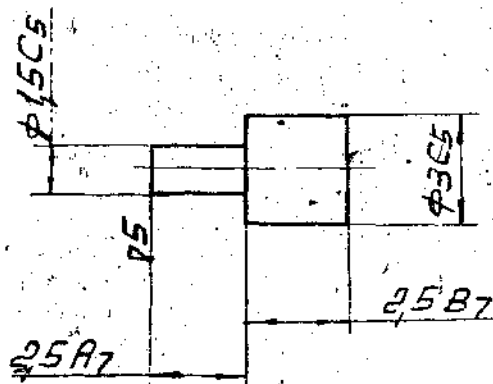
9.4

EST. MASS 0,001 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 OUTSIDE R HIGH EQUIVALENT CHAMFERS ARE PERMISSIBLE	
MATERIAL * SEE ABOVE	USED ON :- 100 256 H
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES ) AVADI	
TITLE: PIN	
D S CAT NUMBER	DRAWING NUMBER 491-087 H

ISSUE DATE	NATURE OF AMENDMENTS
DIRN	SCALE:- 5 : 1
END	DIMENSIONS IN mm
TCO	TOLERANCE ON DRHS UNLESS OTHERWISE STATED
APPO	ALL THREADS CONFORM TO
DATE 9-9-87	

491.220H

Ø6 Unless otherwise specified



Coating: Chemical passivation

Alternate material is steel 2x 13 TY 14-1-378-72.

0-63

\* STEEL 1x13 TY 14-1-378-72

144

95

PROT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

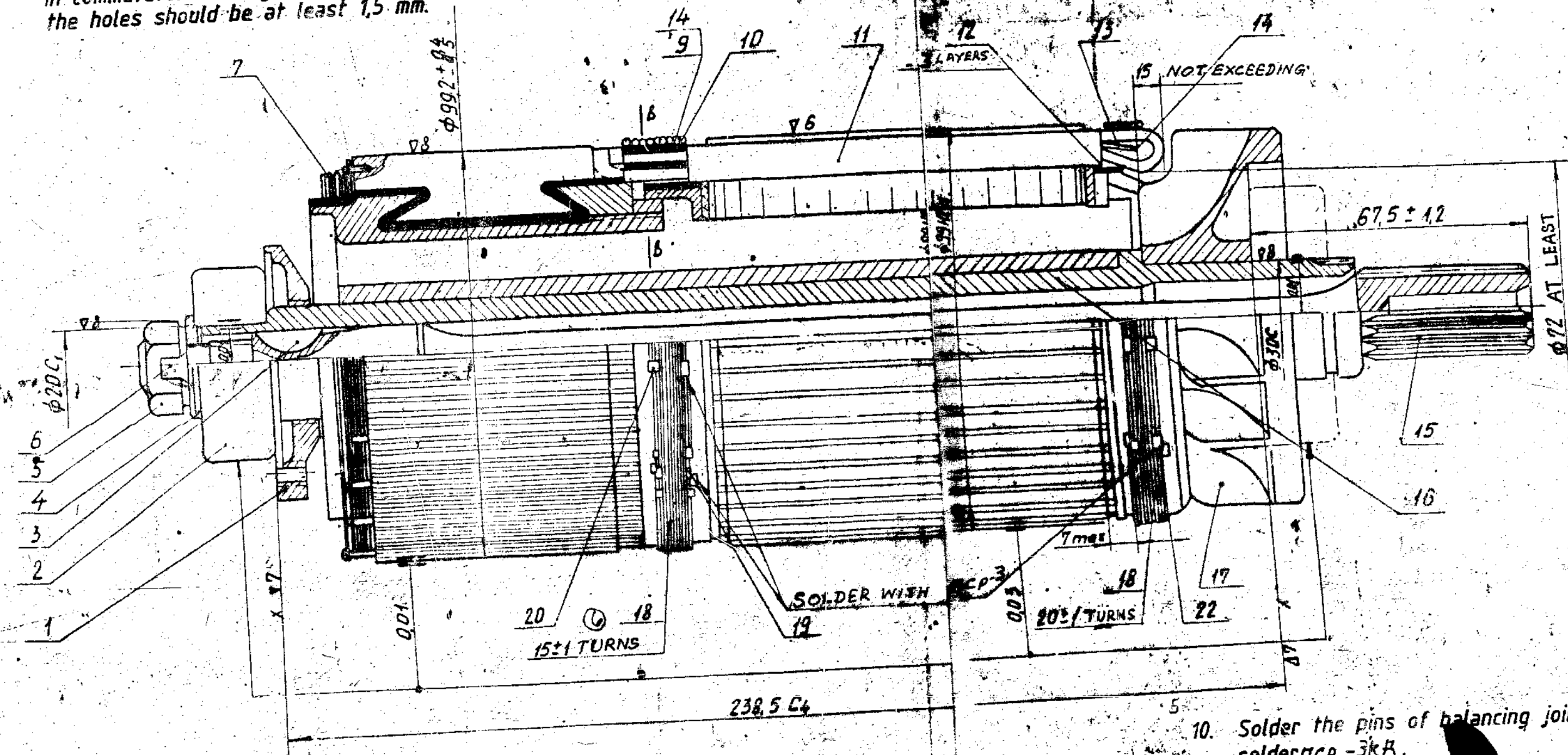
		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL	USED ON: 255 026H
DATE	SCALE: 5:1	* SEE ABOVE	
CHKD	DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAIA	
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	PIN	
APPD	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
DATE 9-87			491-220 H

H551-005

1. Weld the ends of sections to the commutator as per instructions TV 11-71.
2. Impregnate as per H8A 002 8005 by using third item of remarks.
3. Make groove on commutator insulation to depth of 1 mm. See remark "XX", depth of grooving of inter bar insulation should be at least 0.8mm when grooved repeatedly.
4. Balance the armature from fan side by milling the bead of fan or by drilling holes of  $\phi 5$ mm to depth not exceeding 9mm over  $\phi 87 \pm 0.5$ mm in fan, by drilling holes of  $\phi 5$  mm to depth not exceeding 7 mm over  $\phi 66 \pm 0.5$  mm in commutator bushing on commutator side, welds between the holes should be at least 1.5 mm.

5. Run-out of surface "X" with respect to axis should not exceed 0.04 mm.
6. Coat surface  $\phi 99$  H2a after machining as per instructions Tu3-62.
7. Serving should not project beyond the limits of armature iron from the fan side, permissible projection of serving from the commutator side over the armature iron level should not exceed 0.5 mm.
8. Unbalance of armature may be 1 gm, cm, when balanced on balancing machine and 2.5gm, cm while checking before placing in generator.
9. During the first final grooving of commutator use technologically, the upper half of tolerance zone.

16. Coat the holes drilled for balancing with primer 2D-076, yellow, III-H8AD. 050.001-3.
17. To make winding taper proper, it is allowed to wind glass band, REF.NO.23, under the serving.
18. Before mounting the ball-bearing, apply a thin layer of grease of the same grade which is used in the ball-bearing, onto locating place on shaft.
19. While winding the armature, the straight part of sections at the outlet from groove should be at least 2 mm.
20. Radial run-out of external diameter of splined end of shaft REF.NO.15, while rotating the armature on ball-bearings, should not exceed 0.55mm.
21. Milling cutter-traces over length of 1.5 mm are permitted while milling the inter bar insulation on the commutator.
22. Gasket REF.NO.21 may be shortened length wise as required providing close-fit to the commutator butt-ends and end insulation, sheet.
23. Partial mica chipping not exceeding 2.5 mm is allowed from the side of sections while removing the milling cutter.



10. Solder the pins of balancing joints to commutator with solderncp-3kA.
11. Bend the clamps, REF.NO.20, on serving by catching 3 to 4 turns.
12. Join the electric-grade card-board, REF.NO.9 from its external side with glass fabric, REF.NO.14, using adhesive Bp-2, GOST 12172-74.
13. Single-point tool mark, 1mm long, are allowed at the butt-ends for ball-bearings, diameter  $\phi 20$  and  $\phi 30$ .
14. While installing the fan, its rib should coincide with the rib of armature iron, tolerance is  $\pm 2$  mm.
15. Parts REF.NOS 13 AND 14, should be glued with adhesive Sp-2, GOST 12172-74.

"XX" AFTER GROOVING COMMUTATOR  
MAKE CHAMFERS AS PER SPECIFIED  
DIMENSIONS ON GROOVES.

S NO	DESIGNATION	DESCRIPTION	QTY	REMARKS	S NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
23	GLASS BAND 0.8x0.1 GOST 5937-81	AS PER R. EQUIPMENT	13	500.155H-4	GLASS MYCANITE				
22	316.516H/CLAMP		7		750-T-30-022 GOST 8124-78	2	WITH OUT DRAWING		
	SOLDERTIC-3K A GOST 19738-74		12	500.155H-3	GLASS MICHANITE F&C-T-20				
	SOLDERTIC-3 GOST 19738-74		11	810.079H/ SECTION	022.49x750 GOST 8124-78	1	WITH OUT DRAWING		
21	893.746H/ GASKET		228	10	500.155H-2	GLASS MYCANITE F&C-T-20			57
20	500.155H-6	BRASS 0.63 0.3X5X50 GOST 2208-75.	10	9	500.155H-1	ELECTRIC GRADE F&C-T-20			2
19	316.296H/ CLAMP		1		380 GOST 2024-75	2	WITH OUT DRAWING		
18	500.155H-5	BINDING STEEL WIRE GOST 9124-SP. GRADE "M"	0.5	7	750.171H/ CONTACT PLA.				
17	381.044H/ FAN		1	5	474.105H/ NUT				
16	505.117H/ ARMATURE WITHOUT WINDING		1	4	481.418H/ WASHER				
15	181.223H-1/ SHAFT (9.9x10)		1	3	478.020H/ KEY				
14	500.155H-7	FABRIC 3-3-100	2	2	7A180504ETC/ BALL-BEARING				
	GOST 19907-74		4	1	232.142H/ FLANGE				

EST. MASS 9.85 Kg TO BE STAMPED OR INDICATED THUS (27)

LETTERS

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

ISSUE DATE NATURE OF AMENDMENTS

DRN QTY SCALE: 1:1

TCO TOLERANCE ON DIMS UNLESS OTHERWISE STATED

APPO ALL THREADS TO CONFORM TO

DATE 9-9-87

CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVAO

TITLE: ARMATURE BF-7500 H

D S CAT NUMBER

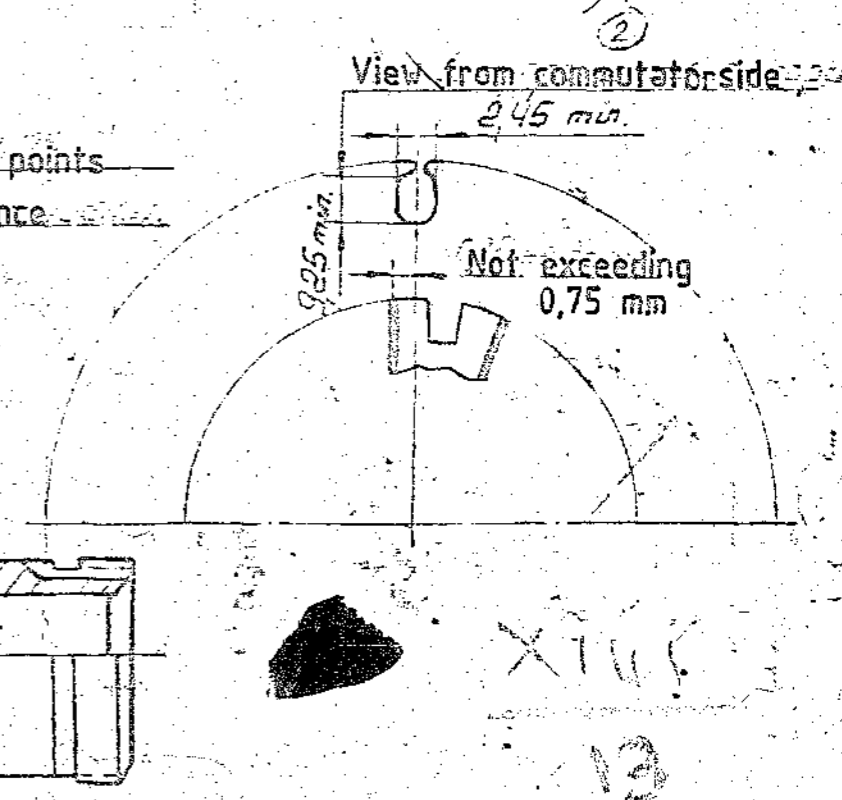
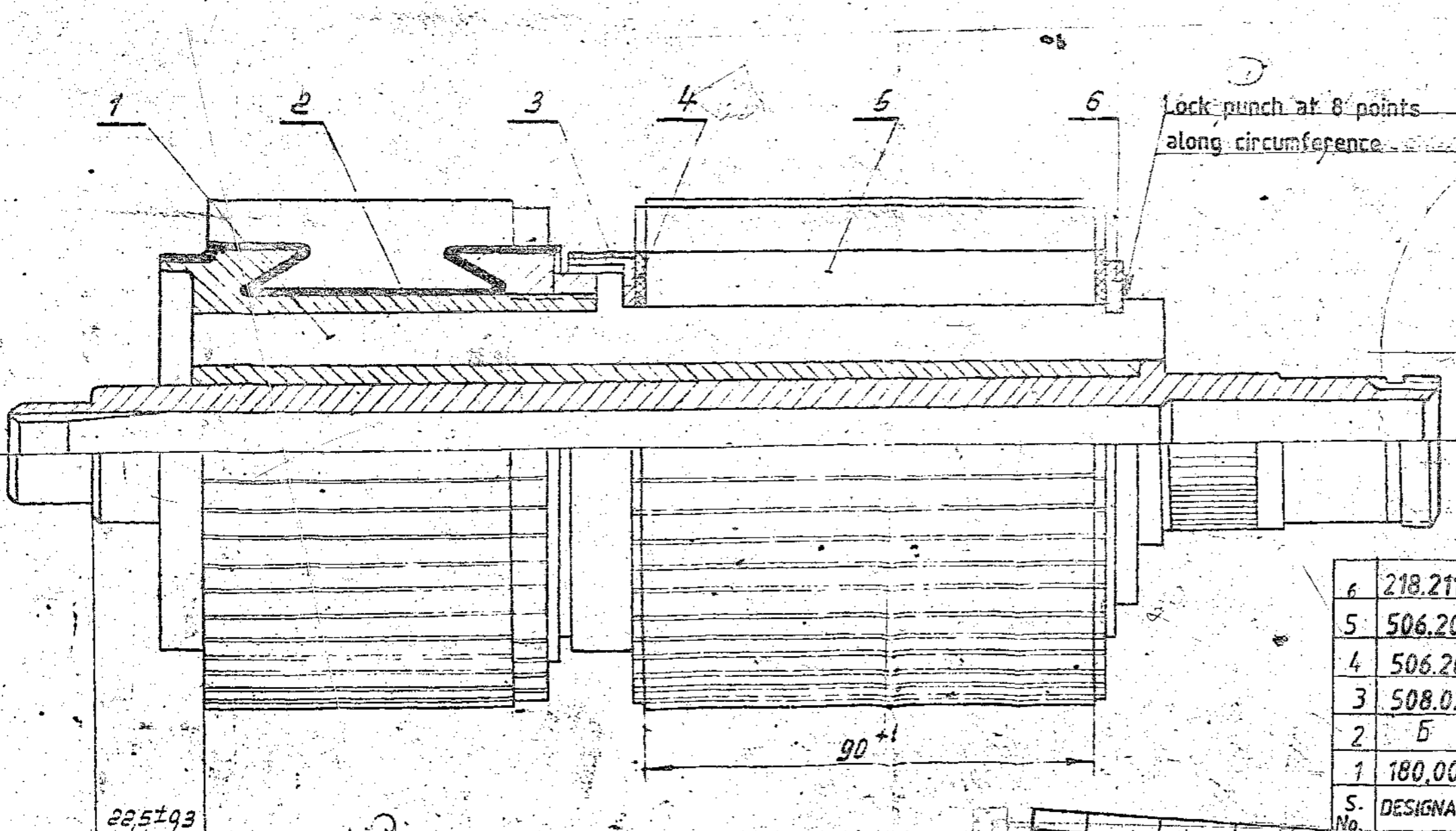
DRAWING NUMBER 500 155 H

002\*145/84

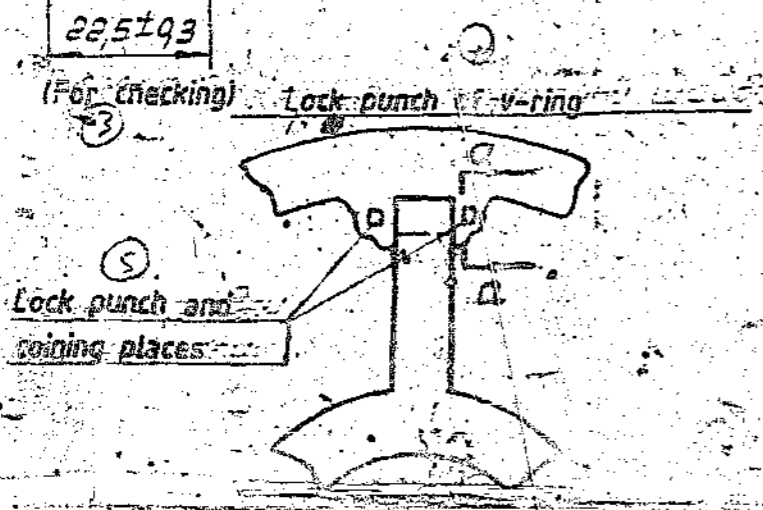
X/14/

12

Commutator packing is to be placed as follows:  
 Insulation of commutator bar should be opposite to centre of slot.  
 Slot axis, at maximum displacement should be aligned to the right of interlaminated insulation by 0,75 mm if viewed from the commutator side.  
 Weight of armature core with varnished plates and with allowance for grinding of 0,4 mm along the external diameter should be equal to 2415-70 gms. Non parallelity of commutator bars with respect to axis of shaft should not exceed 0,5 mm over commutator length.



6	218.211H ✓	V-Ring	1
5	506.201H ✓	Outer plate of Armature	257
4	506.200H ✓	Edge plate of Armature	2
3	508.025H ✓	Winding support	1
2	B	Commutator	1 See table
1	180.006H ✓	Shaft	1
S. No.	DESIGNATION	DESCRIPTION	QTY REMARKS



As per *Q-8*

Designation of alternate	Code of article	QTY
505.117H	BF-7507	520.05
-01	BF-7500B	520.05
	BF-7500A	520.05

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

EST. HASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS (P 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
DRN	SCALE:-
CHD	DIMENSIONS IN mm
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED
APPD	ALL THREADS CONFORM TO
DATE 9-9-07	
MATERIAL :-	
USED ON :- 500-155 H	
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TITLE: ARMATURE WITHOUT WINDING	
D S CAT NUMBER	DRAWING NUMBER 505 117 H