

1. IN THE ASSEMBLY, SECURE THE ROLLER (PART 7D8.300.017) ON BOTH SIDES WITH THICK PRIMER AK-070 OCT-6-10-401-76.
2. POSITION OF LEVER (PART No.3) SHOULD BE IN SYMMETRY PLANE OF THE VALVE. ADMISSIBLE PLANE DEVIATION IS $\pm 15^\circ$.
3. SECURE THE SCREW (PART No.4) WITH THICK PRIMER AK-070.
4. BEFORE ASSEMBLY OF ELECTRIC SYSTEM Cb.2 WIPE THREAD OF BODY (7D7.772.009) WITH SUEDE SOAKED SQUEEZED IN LUBRICANT U.UATUM-221 OCT 3.801180-80.
5. CHECK ASSEMBLED VALVES IN JOINT BETWEEN INLET CONNECTION AND BODY FOR AIR-TIGHTNESS IN THE FOLLOWING SEQUENCE.
 - a) ELECTRIC PNEUMATIC VALVE IS CONNECTED WITH THE PNEUMATIC SYSTEM BY INLET CONNECTION. THE TECHNOLOGICAL STOPPER IS SCREWED ON TO THE OUTLET CONNECTION.
 - b) VESSEL WITH TRANSPARENT WALLS AND REFLECTOR IS FILLED WITH FUEL TC-1 UPTO THE CLOSURE OF INLET CONNECTION BY 5-10 mm.
 - c) INSPECTION - VISUALLY AIRTIGHTNESS SHOULD BE FULL.
 - d) AT PRESSURE OF 90 ATMOSPHERES, CHECKING TIME IS TO BE 1 MINUTE. BEFORE INSTALLATION OF SOCKET WIPE THREAD M20x1k1.2a OF THE STOPPER AND THREAD M16x1k1.3n OF OUTLET CONNECTION 3-4 WITH SUEDE SOAKED IS LUBRICANT U.UATUM-221 OCT 3801180-80 AND SQUEEZED.
6. DURING INSTALLATION OF ARTICLE ЭК-48 IN THE MATED UNIT TIGHTENING TORQUE OF THE NUT SHOULD NOT EXCEED 1,0 Kgm.
7. ENSURE THE REQUIRED CLEARANCE "A" NOT MORE THAN 1,5mm BETWEEN CASE 7D7.712.012 AND STOPPER 2-4.
8. PRIMER AK-070 OCT 6-10-401-76 THICK PIGMENTED WITH GREEN DYE TECHNICAL SPECIFICATIONS Ty 6-09-4278-76.
9. ASSEMBLY AND PRODUCTION OF ARTICLES WITH UNITS Cb 1- OR II VERSIONS ARE ALLOWED.
10. WRENCH TRACE IS ALLOWED ON PARTS 7D7.772.012, 2-4, 7D7.772.009, Cb1-2 OR 7D8.652.018. COAT THE WRENCH TRACE USING PRIMER AK-070, OCT 6-10-401-76.

R.NO.	DESIGNATION	DESCRIPTION	Q.TY.	REMARKS
1	Cb1- Version II	Pneumatic valve	1	
2	cb.2	Electric system	1	
3	910,920	Socket	1	
4	7D8.300.017	Roller	1,01	
5	2	Magnet (spring)	1	
6	Lv2 cv 2540-003066 3	Lever Release	1	REF. Doc 00995-1cv
7	Lv2 cv 5305-018917 4	Screw Gurb	2,02	REF. Doc 00995-1cv
8		Primer AK-070 OCT 6-10-401-76.		
9	7D8632028	Stopper	2	
10	7D8.126.030	Holder	1	

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

EST. WT. 0.47 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.	

DRN	-sd-	MATERIAL:-	USED ON:-
CHD	-sd-		155 38 127 Cb
APPD	-sd-	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
DATE	20.11.2008		
SCALE:-	2:1		
DIMENSIONS IN mm		TITLE:-	
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 2102-69		ELECTRIC PNEUMATIC VALVE	
ALL THREADS TO CONFORM TO IS: 4218 Pt.IV		D S CAT NUMBER	DRAWING NUMBER
ISSUE	DATE	NATURE OF AMENDMENTS	Cb

9/27/2008
 (G. THIRUGANAM)
 JTO (D)
 12 DEC 2008

COMPARED WITH ORIGINAL DRG.

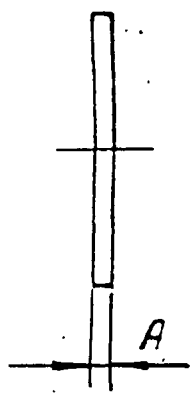
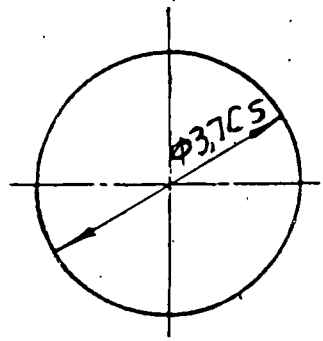
DRG RE-INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NIL

7/12/1

SIZE A1

Sl. No.	FORMAT.	DESIGNATION.	DESCRIPTION.	Incorporated in		Total Qty	Remarks
				DESIGNATION.	Qty		
			<u>Material</u>				
			✓ Black phenolic plastic 03-010-02				
			GOST 5689-79			4.5g.	
			✓ Wire n 2 n - 0,4				
			GOST 2773-78			70g	
			✓ <i>АВММ</i>				
			Varnished cloth-105				
			0.12 GOST 2214-78			0.7M	
			silk threads.				
			✓ N13 GOST 22665-77			1M	
			Rubber stock TC98-1				
			TY38 005 1166 - 73				
			Rubber stock TCB14-1				
			TY38 005 1166 - 73				
			✓ Primer AK-070				
			OCT-6-10-401-76				
			Pigmented with green colour				
			TY6-09-4278-76				
			Lubricant QUATUM-				
			221 c OCT3.801180-80.				

ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS
DRN		<i>Г. В. ...</i>	USED ON		—
CHD		<i>С. ...</i>	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
TCO		<i>Г. ...</i>	TITLE ELECTRIC PNEUMATIC VALVE		
APPD		<i>...</i>	D S CAT NUMBER		ITEM LIST FOR
DATE 30.7.86.	SHT No. 11 OFF 11		ЭК-48-015-Сп		



A	P
0,1	0,00001
0,3	0,00003
0,4	0,00004
0,5	0,00005

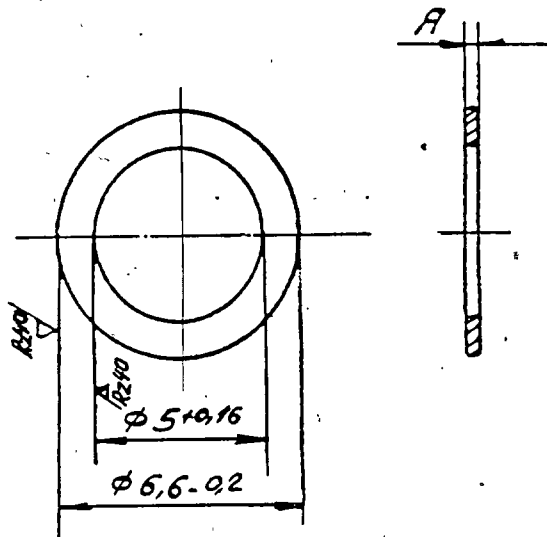
159
I-1224

Passivative

2 - ЭК - 015

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS LETTERS!
		P (SEE TABLE)	
		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 - 10 : 1	MATERIAL :- BAND АПМТ H.A. 63 GOST 2708-75
CHD		DIMENSIONS IN mm.	USED ON :- C6 1
TCO		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADL
APPD		ALL THREADS CONFORM TO	TITLE :- SHIM
DATE			D S CAT NUMBER
			DRAWING NUMBER 1 - 3

7-1



A	P
0,1	0,00001
0,3	0,00003

140
I-1224

Passivate.

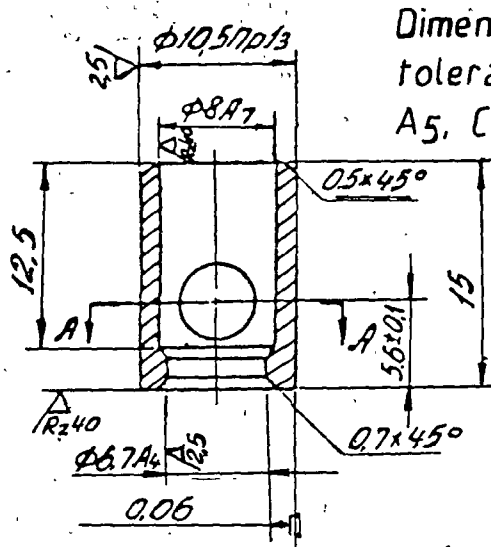
E.K.C
48

Material: Band Δ П ПТ see table $H \Delta, \Delta 63$ GOST-2208-75.

2-3K-015

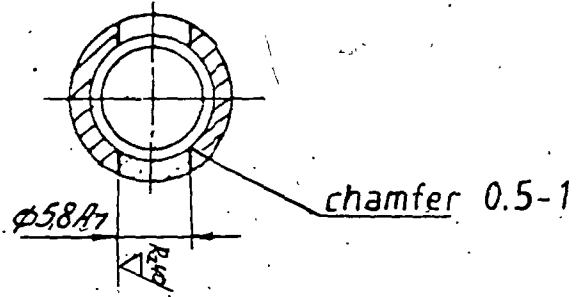
		EST. MASS	TO BE STAMPED OR MARKED WHERE	
		P (SEE TABLE)	INDICATED THIS Φ LETTERS)	
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL:-	USED ON:-
DRN		SCALE - 5 : 1	SEE ABOVE	C6 1
CHD		DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE:- SHIM	
APPO		ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
DATE	29 - 07 - 86			1 - 4

8.F



Dimensions without tolerances are as per A5, C5.

Section A-A



Tolerances on free dimensions for chamfers and radii are as per 722AT.

Blunt the sharp edges to R0.1- 0.3

I.1224

Coating: Cadmium, 3 micron thickness, chromated

2-3K-015

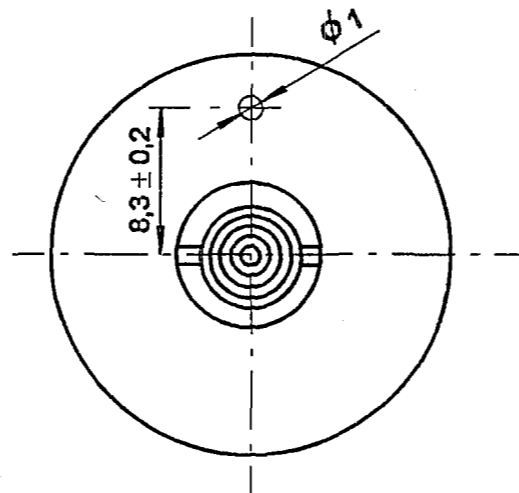
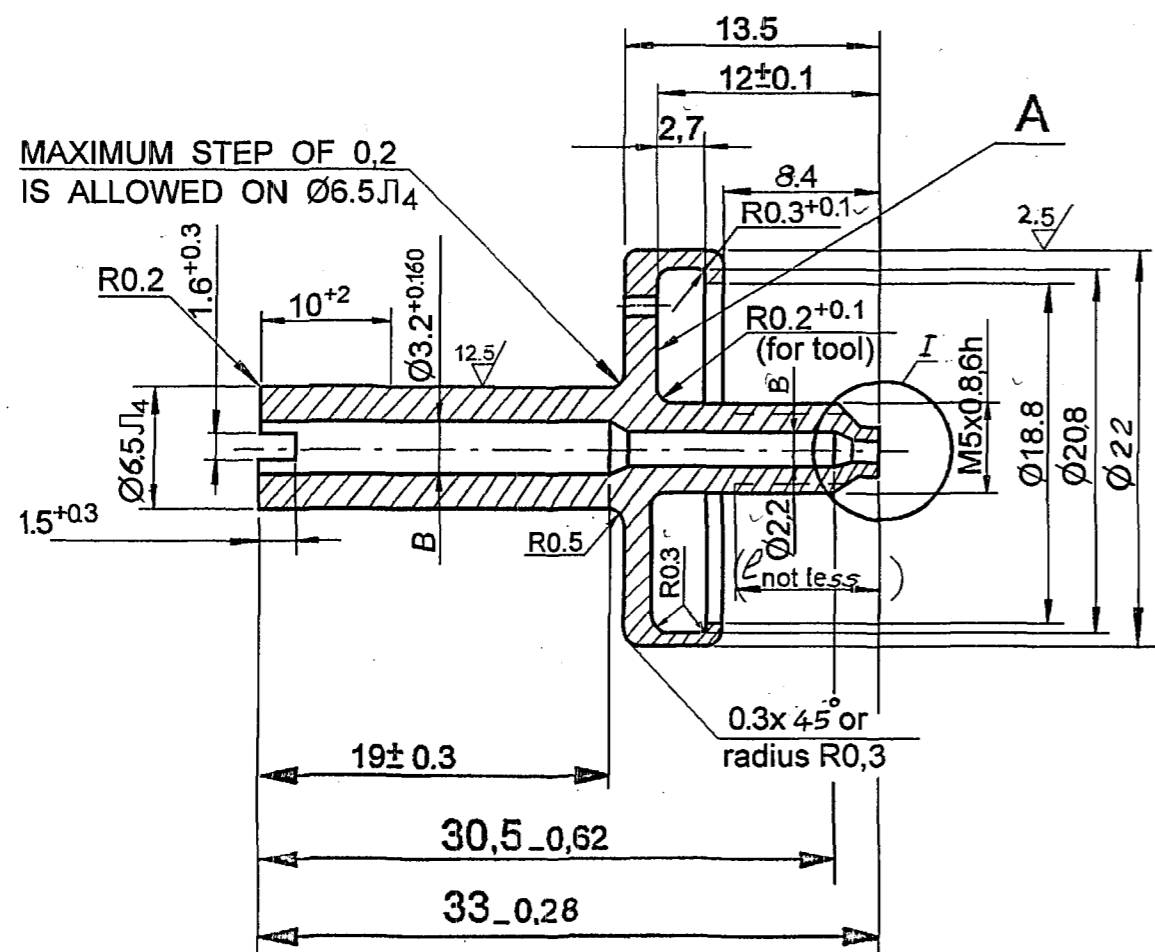
		EST. MASS 0.0039 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS * LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL:- STEEL 45-B GOST 1051-73	USED ON:- Cb 1-2
DRN	SCALE - 2 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
HD	DIMENSIONS IN mm.	TITLE:- INSERT	
CD	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
APD	ALL THREADS CONFORM TO	DRAWING NUMBER 1-8	
ATE	29-7-86		

DRAWING NUMBER

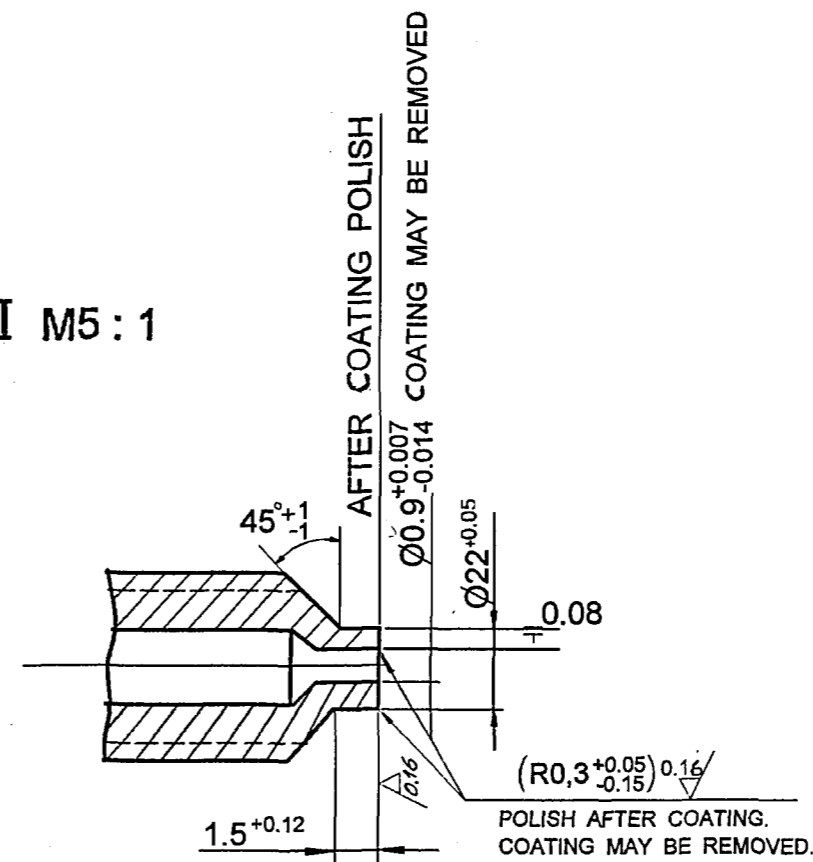
1-9

Rz20 (✓) (✓)

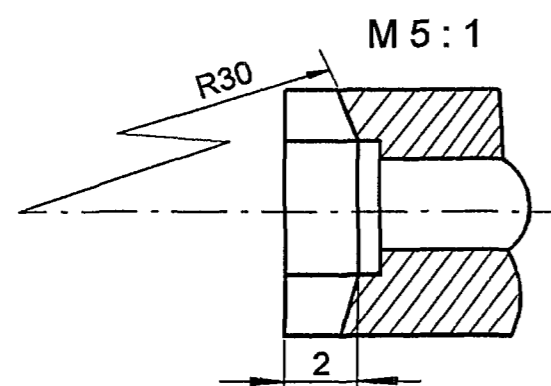
DIMENSIONS WITHOUT TOLERANCES ARE AS PER A5C5



I M5:1



ALTERNATE TO PERFORM THE SLOT



*DIMENSION FOR THE TOOL

BLUNT THE SHARP EDGES TO 0,1-0,3.

COMPLETE PROFILE OF THE THREAD M5x0.8.6h IS MAINTAINED AT A LENGTH NOT LESS THAN I = 7.2mm.

PLAY OF MEAN DIAMETER OF THE THREAD M5x0.8.6h AND SURFACE Ø2.2^{+0.05} WITH RESPECT TO Ø6.5J14 SHOULD NOT EXCEED 0.1 mm.

BUTT END PLAY "A" WITH RESPECT TO Ø6.5J14 SHOULD NOT EXCEED 0,05mm.

IN INTERNAL PORTS THICKNESS OF COATING MAY BE REDUCED TO 6 AND AFTER COATING HOLE Ø0.9±0.007 MAY BE CALIBRATED.

POSITION OF THE SLOT WITH RESPECT TO HOLES IS ARBITRARY.

TOLERANCE ON FREE DIMENSIONS FOR CHAMFERS AND RADII ARE AS PER 722AT.

DISPLACEMENT OF HOLES 5, B RELATIVE TO THAT OF THE THREAD M5x0.8.6h SHOULD NOT EXCEED 0.5 mm.

COATING WITH CADMIUM, 9 MICRON THICKNESS, CHROMATIZED IS ALLOWED.

TOOL TRACE ON THE FACE Ø22 FROM THE SIDE OF Ø6.5J14 IS ALLOWED.

COATING : CADMIUM 9 MICRON THICKNESS OXIDIZED PERKARIZED.

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

EST. WT. 0.0090 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.

DRN	Sd/=	MATERIAL:- STEEL 45-B GOST 1051-73.	USED ON:- Cb 1-3
CHD	Sd/=		
TCD	Sd/=	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
APPD	Sd/=		
DATE	26.07.86	TITLE:- INLET VALVE	
SCALE:-	2.5:1		
DIMENSIONS IN mm		D S CAT NUMBER	DRAWING NUMBER 1-9
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69			
ALL THREADS TO CONFORM TO			
ISSUE	DATE	NATURE OF AMENDMENTS	

G. THIRUGANAM
JTO (DI)
12 DEC 2008

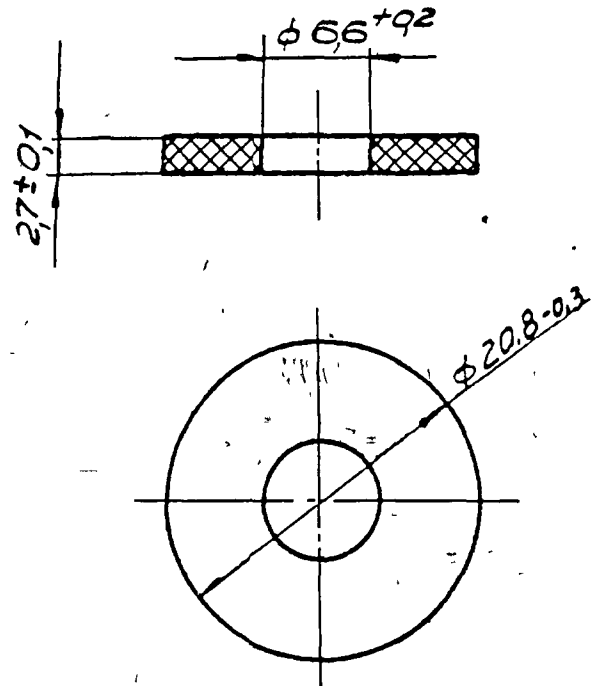
COMPARED WITH MAGATIVE

DRG. RE-INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE-NIL.

SIZE A2

01-1

Rz20



Trim the fin.

146
I. 1224

Material: Rubber stock TC-B14-1
Ty38 005 1166-73

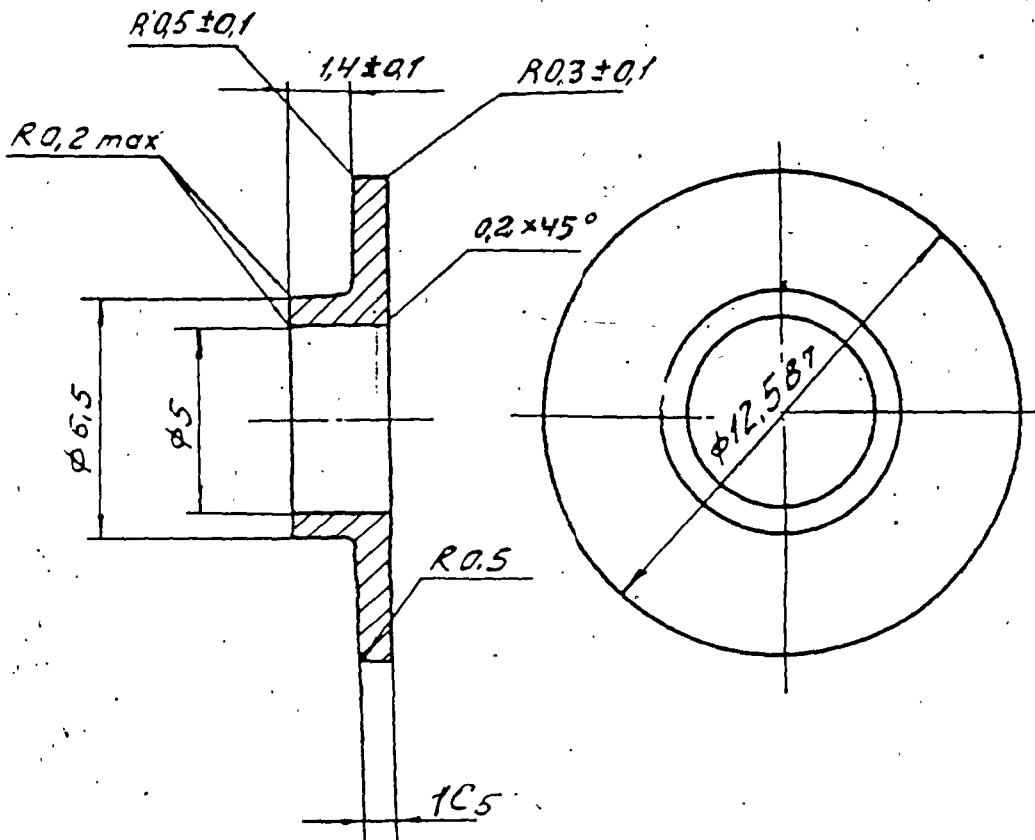
(A) ALT. MATL: RUBBER GRADE N3 TO SPECN CQA(HVI)/NBR. 2-3K-015.

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS \oplus
		0,0011 Kg	(LETTERS)
A	13.10.77	Lt.No.81312/CQA(HVI)/DB-III/	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	ALT.MATL Dt 12.10.00	
DESIGN	SCALE - 2 : 1	MATERIAL:- SEE ABOVE	USED ON:- Cb.1-3
CHKD	DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD	
TCO	TOLERANCE ON DIMNS, UNLESS OTHERWISE STATED	\oplus TITLE:-	SEAL OF THE VALVE
APPRO	ALL THREADS CONFORM	D S CAT NUMBER	DRAWING NUMBER
DATE	26-7-06		1-10

11-1

Rz20

Dimensions without tolerances are as per AS5.



1.27
I.1224

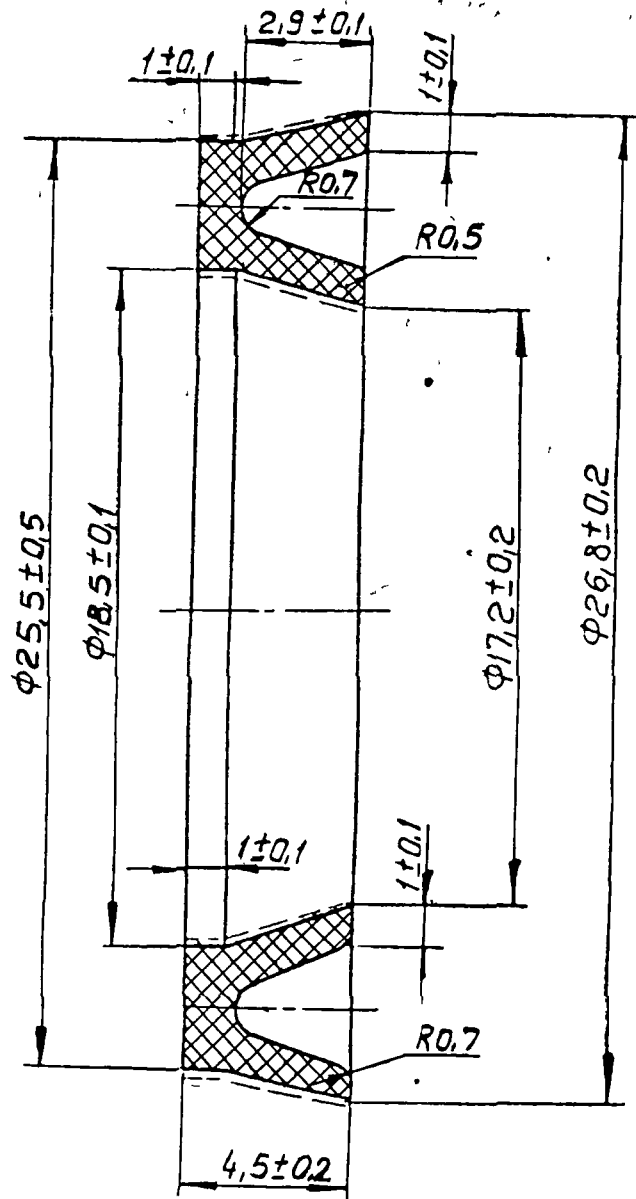
Play of butt-ends $\phi 12.5B_7$ and $\phi 6.5$ with respect to the axis should not exceed 0.05

Blunt the sharp edges to R 0.3

Material: Aluminium alloy 16T GOST 21488-76

2-3K-015

			EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS #
			0,0003 Kg	LETTERS)
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
SUE	DATE	NATURE OF AMENDMENTS	MATERIAL:- SEE ABOVE	USED ON:- Cb.1-3
IN		SCALE - 5 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TO		DIMENSIONS IN mm.	TITLE:- BUSH	
PO		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
TE		ALL THREADS CONFORM TO	DRAWING NUMBER 1-11	
	26-7-86			



1. Surface enclosed within dashed line should be smooth and should not have burrs, marks & other defects & conform to the standard

4. Surface finish in places of trimming of the fin $R_z 20$

2. Shore hardness 55--65.

Material: Rubber TC98-1
Ty38-005.1166-73.

Dimensions $\phi 17,2 \pm 0,2$, $\phi 18,5 \pm 0,1$ are given for the tool

2-3K-015

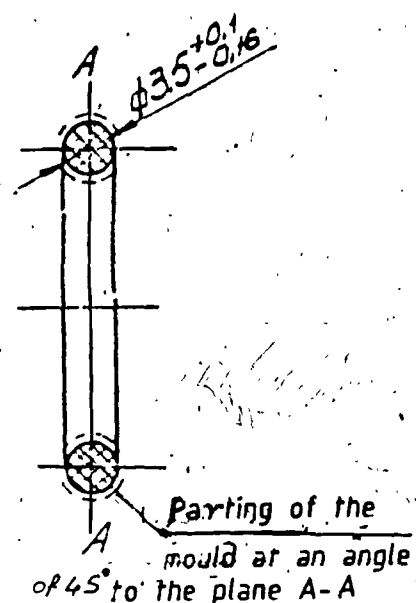
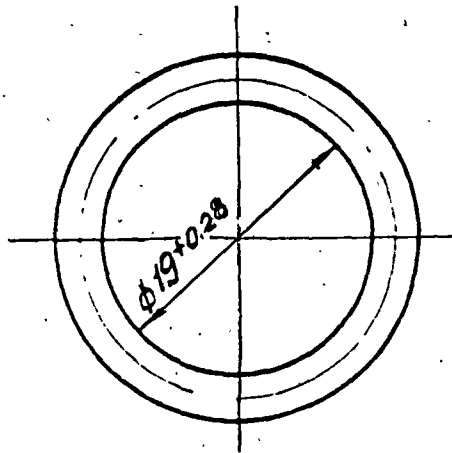
(A) ALT. MATL: RUBBER GRADE N1 TO SPECN [CA(HV)]/NBR

2K-48

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED-THUS #
		0,00098 Kg	LETTERS)
A	13.1.07	Lt No 81312 (CA(HV)/DB-III/ ALT MATL Dt. 12.10.06	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:- Cb 1-4
DRN	SCALE - 5 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
HD	DIMENSIONS IN mm.	TITLE:- SEALING RING	
CD g Jant	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
APP	ALL THREADS CONFORM TO	DRAWING NUMBER 1-14	
DATE	26-7-86		

91-t

151
I-1224



1. $\phi 19^{+0.28}$ is given for the tool
2. Surface finish in places of fin trimming is $Rz \frac{20}{\surd}$
3. External appearance as per Ty38-005-838-70.
4. Surface within dashed line should be smooth and should not have burrs, marks and other defects.

Material: Rubber stock TC B-14-1
Ty38005 1166-73.

2-3K-015

48

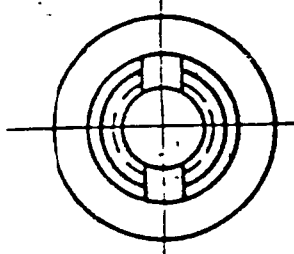
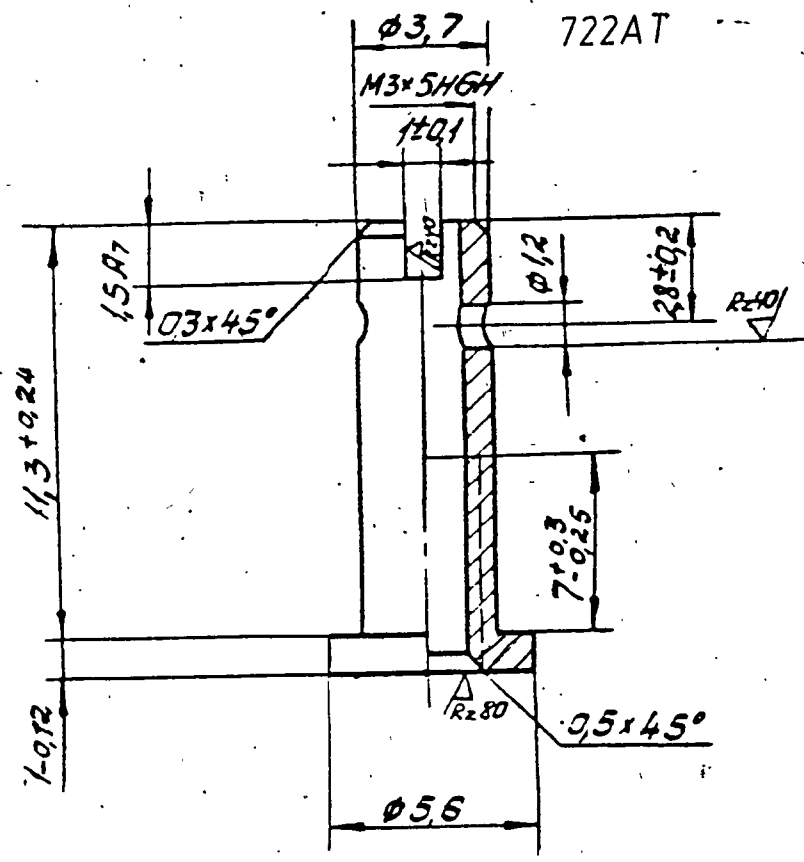
(A) ALT. MATL: RUBBER GRADE N3 TO SPECN CQA(HV)/NBR.

			EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS
			0,0008 Kg	(LETTERS)
A	13.1.07	Lf. No. 81312 (CQA(HV)/DB-III/ ALT. MATL Dt. 12.70.86	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:- Cb 1-5
IN		SCALE - 2 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
NO		DIMENSIONS IN mm.	TITLE:- RING	
CD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
PPD		ALL THREADS CONFORM TO	DRAWING NUMBER	
ATE	26-7-86		1-16	

41-1

Rz20 (✓)

Dimensions without tolerances are as per 722AT



152
I. 1224

After coating, thread may be calibrated by partial removal of coating on the thread.

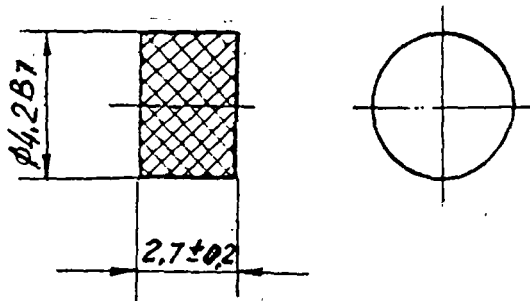
Coating: Silver 3 micron thickness.

Material: Bar АКРНПХНД Бр. АМц9-2
GOST 1628-78. 2-3K-015

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS LETTERS)	
		0.00046 Kg		
		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 - 5 : 1	MATERIAL:-	USED ON:-
			SEE ABOVE	Cb 1-5
CHD		DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCO		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	TITLE:- BUSH	
APPO		ALL THREADS CONFORM TO IS: 4218. Pt IV	D S CAT NUMBER	DRAWING NUMBER
DATE	26-7-86			1-17

81-1

I-1224



Parts should have even and smooth surface without burrs, holes, crack, marks, and traces of fallout of mechanical inclusions.

Shore hardness should not be less than 86.

2-3K-015

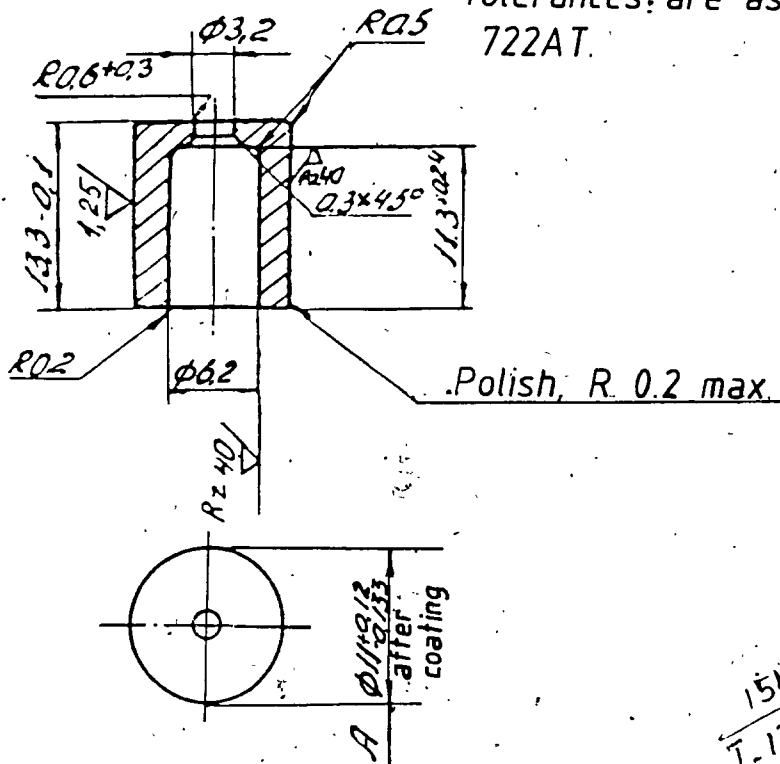
(A) ALT. MATL: RUBBER GRADE N4 TO SPECN CQA(HV)/NBR.

			EST. MASS 0,00005 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS # LETTERS)
A	13.1.07	Lt. No. 81312/CQA(HV)/DB-III/ ALT. MATL Dt. 12.10.06	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:- RUBBER STOCK 14K-22 Ty 38 005 1166-73.	USED ON:- Cb 1-5
DN S. Suresh		SCALE - 5 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
HD S. Suresh		DIMENSIONS IN mm.	TITLE:- PACKING OF THE SERVO VALVE	
CD S. Suresh		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
PPD S. Suresh		ALL THREADS CONFORM TO	DRAWING NUMBER 1-18	
ATE 26-7-86				

01-F

Rz 20 / (✓)

Dimensions without tolerances are as per 722AT.



154
I-1224

Dimensions 13,3_{-0.1} is given considering the coating.

Carryout heat treatment as per instructions УТ-11-63.

All surfaces, except ϕA may be free from chromium.

Coating: Chemically nickel coating 9 micron thickness, chrome plated 1 micron thickness.

Appearance is as per standard.

Tool trace is allowed on the butt-end from the side of hole; $\phi 6,2$.

Material: Steel 20895-B GOST 11036-75 (A) ~~GOST 11035-75~~

2-3K-015

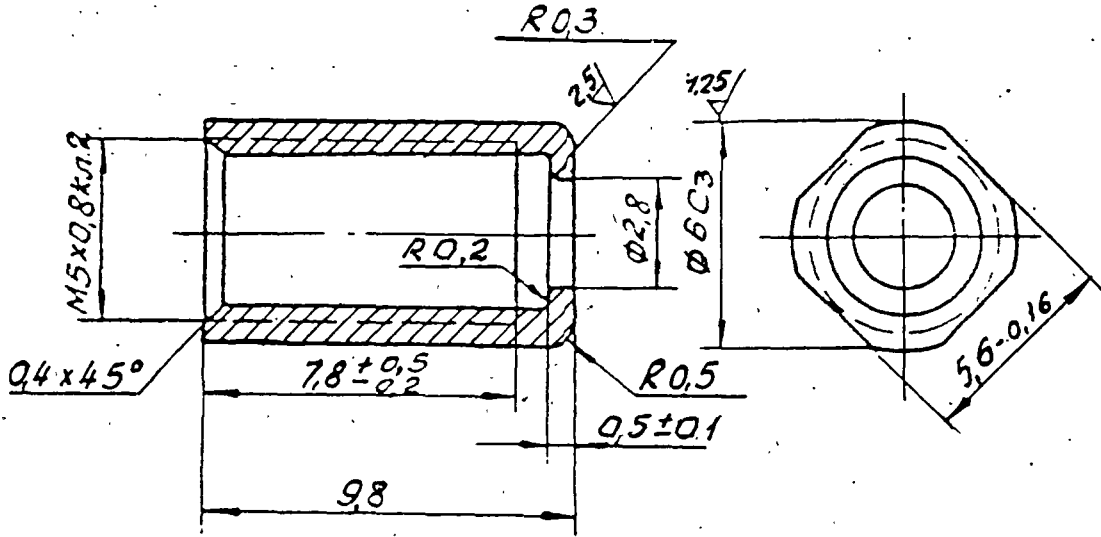
			EST. MASS 0,0068 Kg	TO BE STAMPED OR MARKED AS INDICATED THUS * LETTERS
A	28.7.89	NO CORRECTION	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL:- SEE ABOVE	USED ON:- Cb 1-5
DRN		SCALE - 2 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
HD		DIMENSIONS IN mm.	TITLE:- ARMATURE	
CD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	D-S CAT NUMBER	
PPD		ALL THREADS CONFORM TO	DRAWING NUMBER 1-19	
ATE	26-7-86			

DRG. CREATED BASED ON RUSSIAN ORIGINALS ISSUE-NIL

1-20

200 (✓)

Dimensions without tolerances are as per A5 C5



1224

Tool traces of size 5,6-0,16 ... are allowed.


Play of Ø6C₃ with respect to angle diameter of the thread should not exceed 0,1

Play of Ø 2,8 with respect to angle diameter of the thread should not exceed 0,2

The part may be made from material bar АКРПХ НДБР АМЦ 9-2 Gost 1628 - 78.

Coating :- Chemically Passivated

2-3K-015.

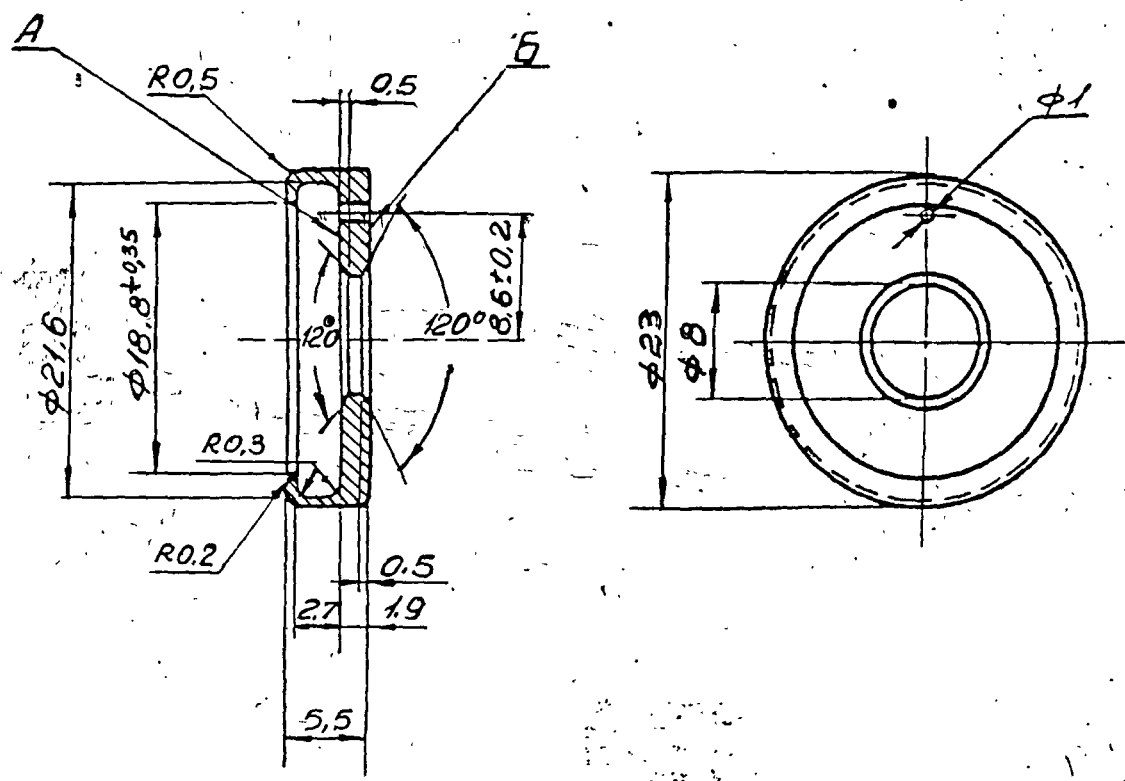
		EST. MASS 0,0007 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS  LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE - 5 : 1	MATERIAL :- BAR/AC59-1 GOST 2060-73
HD		DIMENSIONS IN mm.	USED ON: CB1-5
CD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
PROJ		ALL THREADS CONFORM TO IS: 4218 Pt IV	TITLE:- BUSH
ATE	26-7-86		D S CAT NUMBER DRAWING NUMBER 1-20

48

1-21

Rz20

Dimensions without tolerances are as per A5 C5



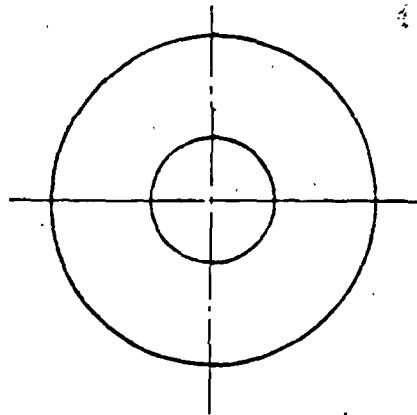
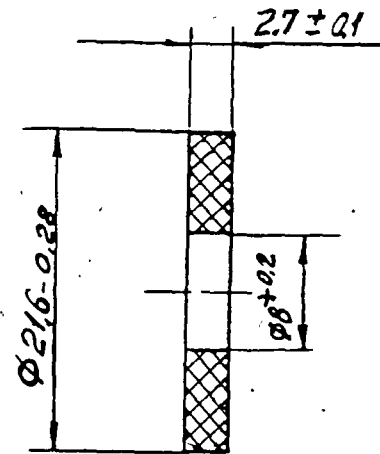
I-1224

1. Round off the sharp edges to R 0.2
2. Non-perpendicularity of planes A and B should not exceed 0.05

2-3K-015

Anodic oxidation, chromating

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS * (LETTERS)
		0.0023 Kg	
		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: ALUMINIUM ALLOY	USED ON:-
DRN	SCALE 2:1	A 16T GOST 21488-76	Cb 1-6
CHD	DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD	TOLERANCE ON DRMS UNLESS OTHERWISE STATED.	TITLE:-	VALVE
APPI	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
DATE 29-7-86			1-21



(A) ALT. MATL: RUBBER GRADE N3 TO SPECN. CQA(HV)/NBR.

2-9K-015

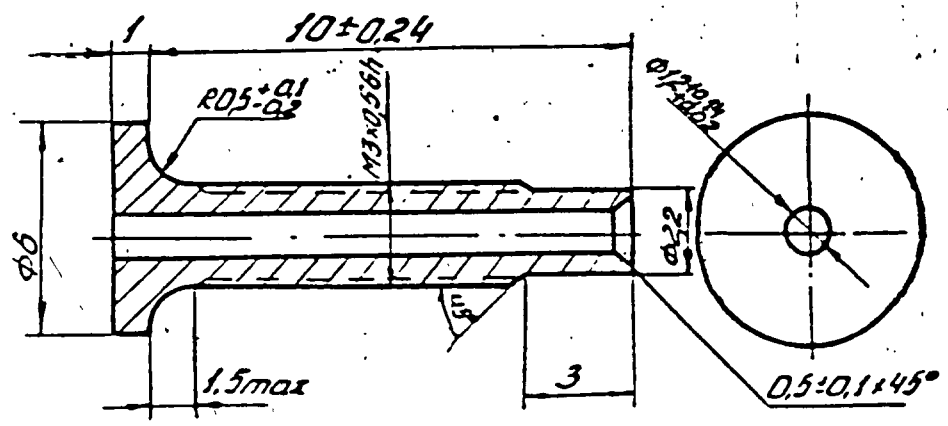
		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS # LETTERS)	
		0.0012 Kg		
- A	13.1.07	Lt. No. 81312 (CQA(HV)/DB-III) ALT. MATL Dt: 12.10.06	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R. INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE	DATE	NATURE OF AMENDMENTS		
DRN		SCALE - 2 : 1	MATERIAL:- RUBBER STOCK	USED ON:-
CHO		DIMENSIONS IN mm.	TC B-14-1 Ty 38 005 1166-73	Cb 1-6
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APPD		ALL THREADS CONFORM TO	TITLE:- SEAL OF THE VALVE	
DATE	29-7-86		D S CAT NUMBER	DRAWING NUMBER
				1-22

48

h2-f

R220

Dimension without tolerances
as per A5 C5



160
I-1224

1. Dimension 1 is given considering the coating.
2. Tool trace on $\phi 2,2$ is allowed.
3. Blunt the sharp edges to 0.1 to 0.3.
4. Surface $\phi 1.2$ may be free of coating.
5. Tolerances on free dimensions for chamfers, angles radii are as per 722AT.
6. Galvanizing may be done in the nut, Assy.1-7, zinc-plated 6 micron thickness, chromating

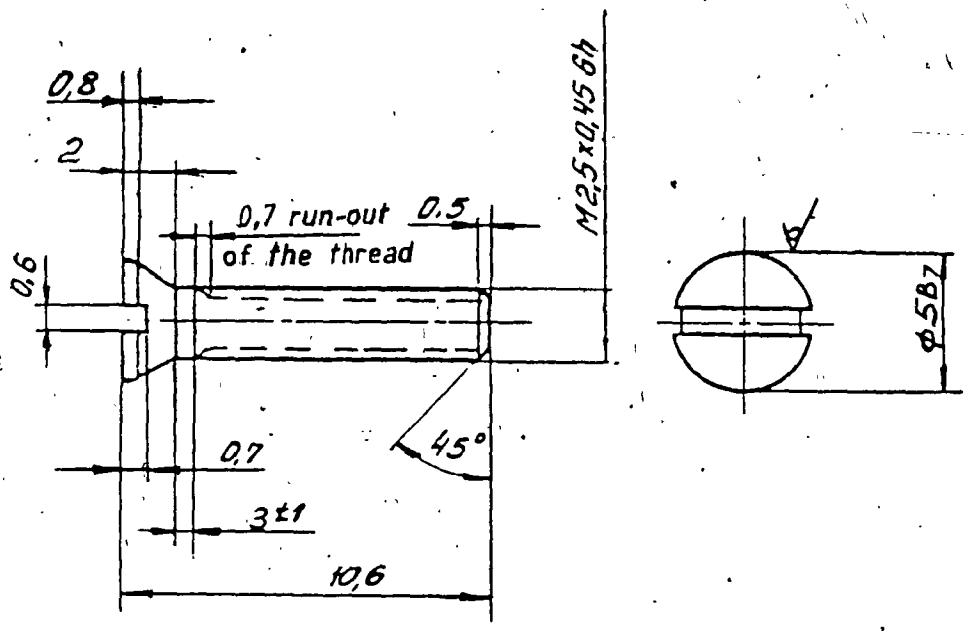
2-3K-015.

zinc plated, 3micron thickness chromating

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS *
		0.0007 Kg	LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
SUE DATE	NATURE OF AMENDMENTS	MATERIAL:- CALIBRATED STEEL	USED ON:-
3N Jansen	SCALE - 5 : 1	A 12 GOST 1414-75	Cb 1-7
ID Dank	DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CD Jansen	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE:- BUSH	
PPD Jansen	ALL THREADS CONFORM TO IS: 4218 Pt IV	D S CAT NUMBER	DRAWING NUMBER
ATE 26-7-86			1-24

2-18

Rz20 (✓)



Perform dimensions without tolerances as per 722AT.

Eccentricity of the slot to the axis of the screw should not exceed 0.2.

178
I-1224

Coating: Cadmium, 3 micron thickness, chromating. 2-3K-015

Material: Disc 5-4 GOST 7417-75
45-B GOST 1051-73

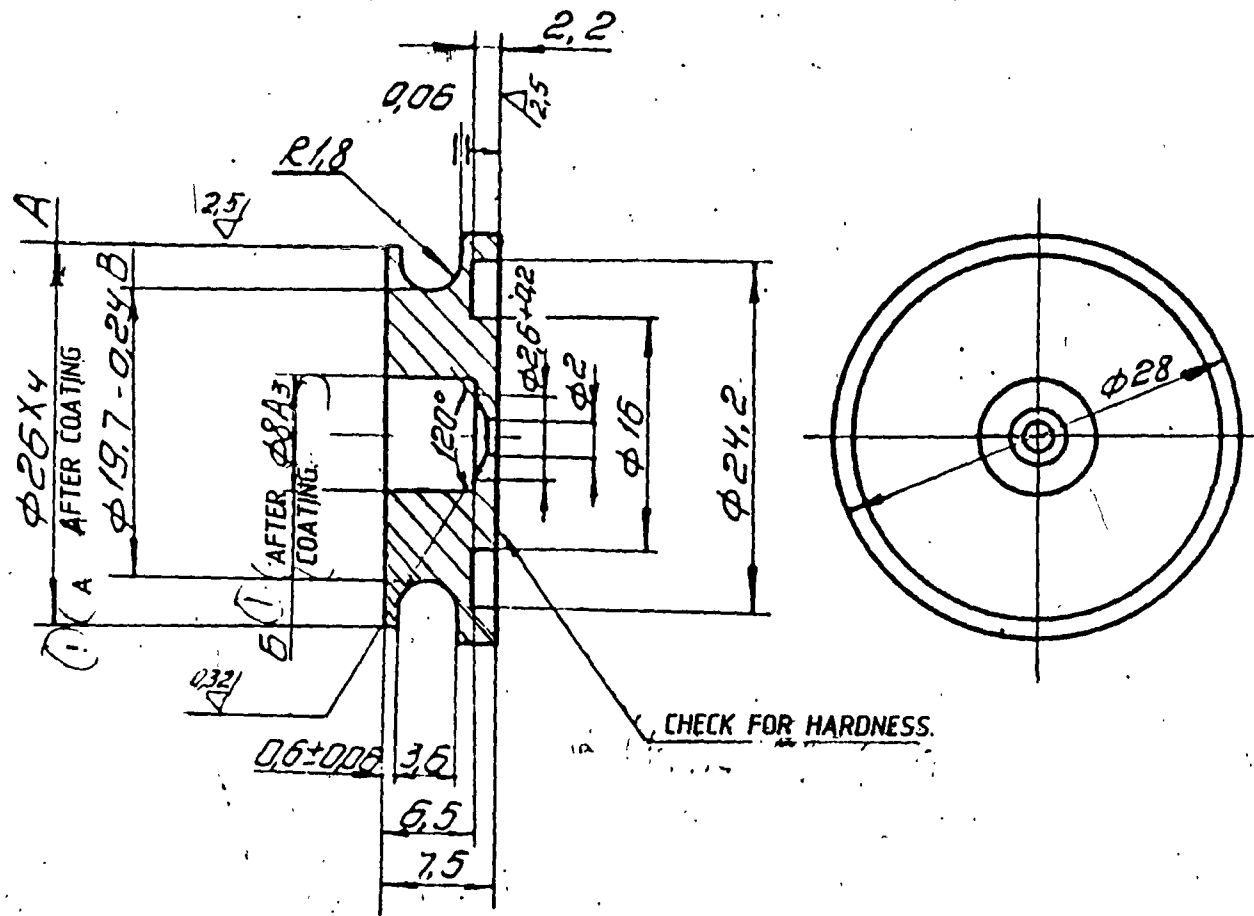
Порытие - 27-Exp

		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:-	
DRN <i>[Signature]</i>	SCALE -	SEE ABOVE	Cb 2-1	
CHD <i>[Signature]</i>	DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
TCD <i>[Signature]</i>	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE:-	SCREW	
APD <i>[Signature]</i>	ALL THREADS CONFORM TO IS: 4218 Pt IV	D S CAT NUMBER	DRAWING NUMBER	
DATE 26-7-86			2-18	

1-23

Rz 20 (✓)

Dimensions without tolerances are as per A5C5.



ON the diameter B coating may be partially absent in places of contact of the part with fixture and subsequently these parts are coated with liquid, type 132-25, GOST 10957-74.

Displacement of the axis, $\phi 2,0$ and taper 120° with respect to axis $\phi 8A3$ not exceeding $0,03$ mm is to be provided technologically.

Blunt the sharp edges to $0,1 - 0,3$.

Galvanizing may be done in the unit Assy. 1-7 zinc, 6 micron thickness, chromated.

Tolerances on free dimensions for chamfers and radii are as per 722AT.

Carryout heat treatment HRC = 22-30.
Zinc coating, 6 microns, thickness, chromated.

Radial run-out of the surface B should not exceed $0,06$ mm (qualified tolerance).

Check the external appearance of diameter B as per the standard.

2-3K-015

474270
3K-48
030704
474270
253292
2070
2070

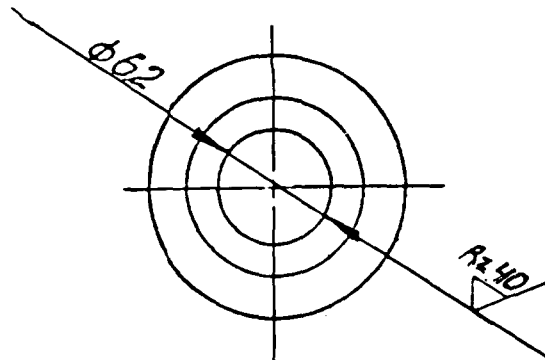
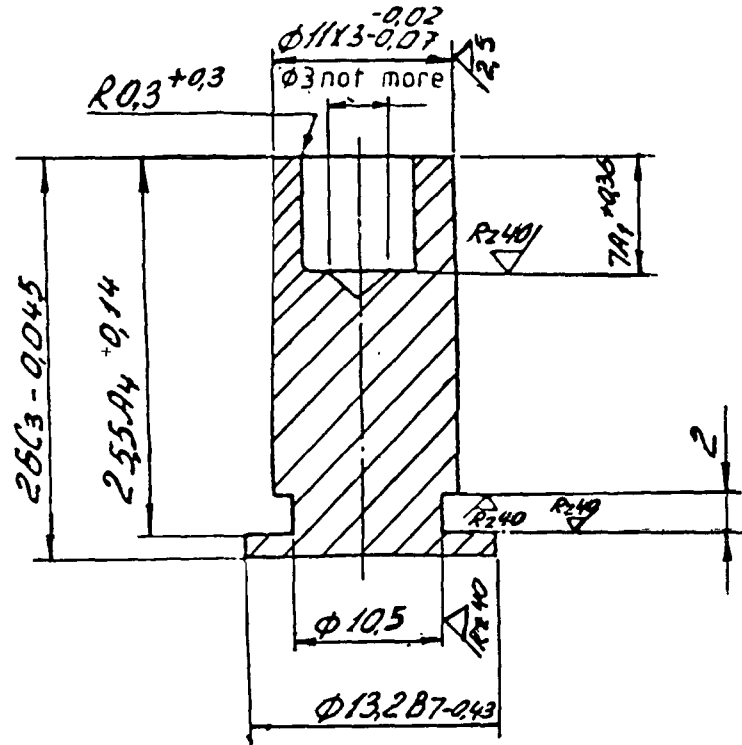
158, 159
I.1224

			EST. MASS 0,01971 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:- STEEL 45-B GOST 1051-73.	USED ON:- Cb1-7
DRN		SCALE - 2 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD		DIMENSIONS IN mm.	TITLE:- SLEEVE	
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
APRO		ALL THREADS CONFORM TO	DRAWING NUMBER 1-23	
DATE	26-7-86			

5-2

R120

Tolerances on free dimensions are as per 722 AT.



The hole may be coated at places of contact with the fixture as per the standard.

Coating Cadmium 9 micron thickness parkerized.

Coating Cadmium 9 micron thickness chromatizing

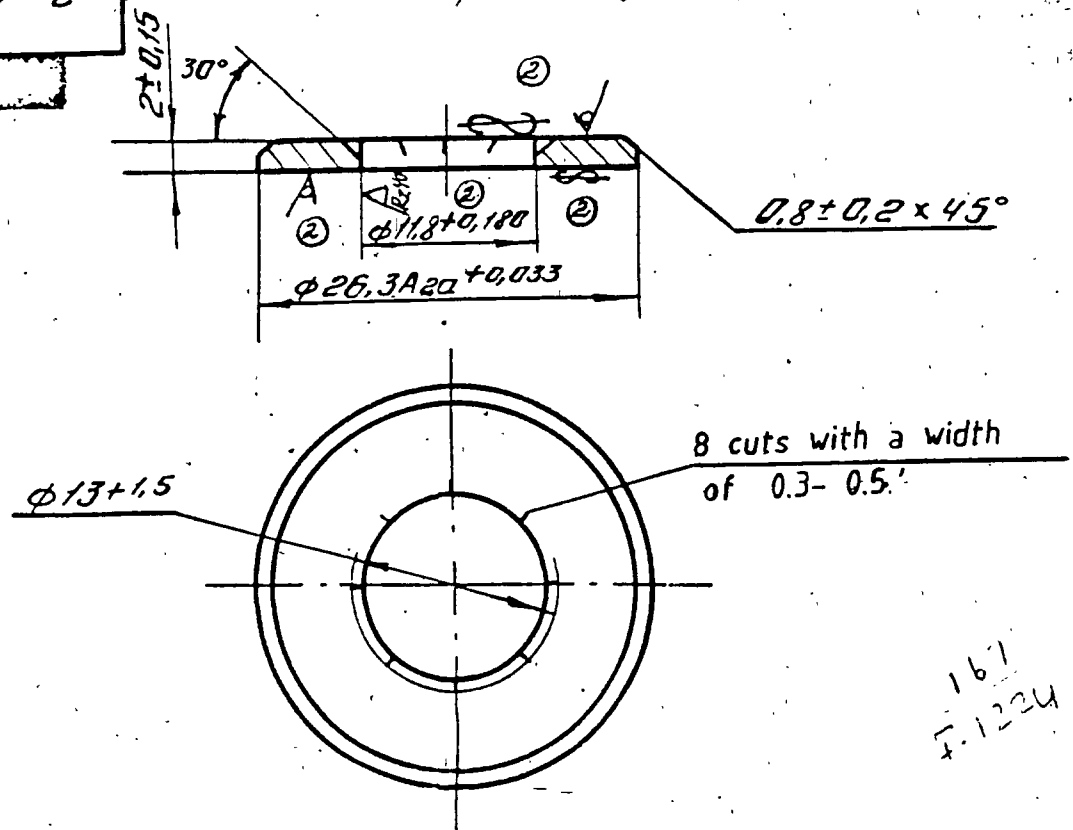
Carryout heat treatment as per the instructions UT-11-63

2-3K-015.

			EST. MASS 0,01728 Kg.	TO BE STAMPED OR MARKED WHERE INDICATED THIS # LETTERS)
A	5.7.07	D.O. CORRECTION.	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R. INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
DRN	SCALE - 2 : 1	MATERIAL :- STEEL 20895-B GOST 11036-75 GOST 11035-75 (A)	USED ON:- Cb 2-1	
CHD	DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
TCD	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE:- STOP		
APRO	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER 2-5	
DATE	26-7-86			

9-2

R220/ 750666666666



Carryout heat treatment as per the instructions UT-11-63.
 Play of the surface $\phi 26.3^{+0.033}$ with respect to that of the surface $\phi 11.8$ should not exceed 0.05.

Check (control) using complex gauge.

Tolerance on free dimensions for chamfers are as per 722 AT.

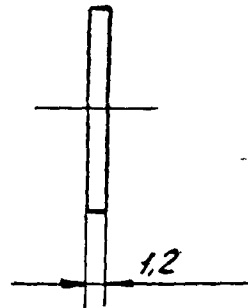
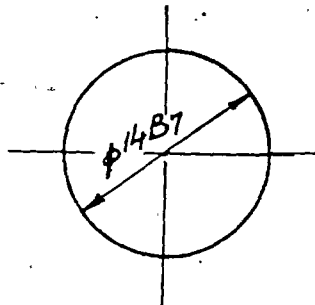
Dimension $\phi 26.3^{+0.033}$ is given after coating.

On $\phi 11.8^{+0.180}$ tearouts are allowed as per standard.

Cadmium, 9 micron thickness, chromating.
 2-3K-015

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)
		0,0068 Kg	
		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	
JRN		SCALE - 2 : 1	MATERIAL 6-ПН-0-2ГОСТ 19904-74 USED ON:- Cb 2-5
CHD		DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
TCO		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE:- WASHER
APPO		ALL THREADS CONFORM TO	D S CAT NUMBER
DATE	28-7-86		DRAWING NUMBER 2-6

2-7



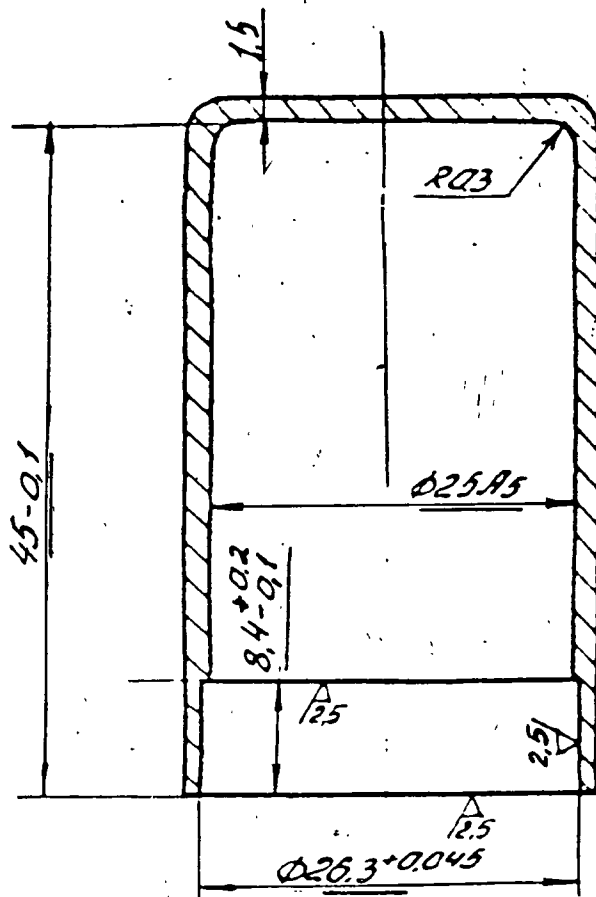
I-1224

2-3K-015

			EST. MASS 0,0003 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 _i INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE DATE	NATURE OF AMENDMENTS		MATERIAL:- TEXTOLITE A-10 GOST 2910-74.	USED ON:- Cb 2-1
DRN <i>V. V. V.</i>	SCALE - 2 : 1		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD <i>Bambid</i>	DIMENSIONS IN mm.		TITLE:-	GASKET
TCD <i>Y. J.</i>	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED		D S CAT NUMBER	DRAWING NUMBER 2-7
APPO <i>Y. J.</i>	ALL THREADS CONFORM TO			
DATE 26-7-86				

8-2

✓ (✓)



1. Underlined dimensions-after coating
2. Underlined dimensions may be performed in the unit Assy2-2. Permissible ovality $\text{Ø}26,3 \pm 0,045$ should not exceed 0.14mm.
3. Blunt the sharp edges to $\approx R0,3$.
4. The part is coated with cadmium 6 micron thickness chromating, in the unit Assy 2-2.
6. Increase of $\text{Ø}25A5$ to $\text{Ø}25^{+0,4}$ to a length not exceeding 5mm from the base is allowed.

Tolerance on free dimensions are as per 722AT.

2-3K-015

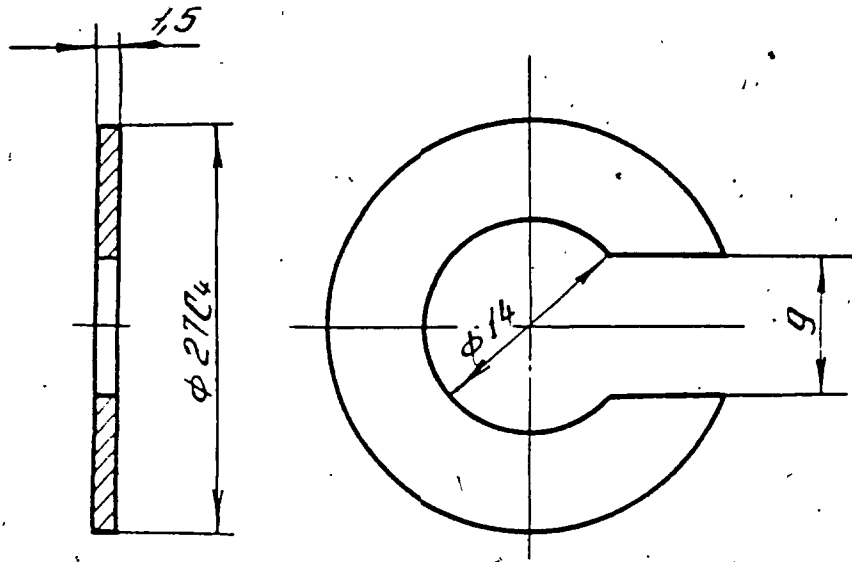
			EST. MASS 0,0432 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS # LETTERS)
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL:- - PLATE 6-TH-0-15 GOST 19904-74 20895 GOST 3836-73	USED ON:- Eb 2-2
JRM		SCALE 2 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD		DIMENSIONS IN mm.	TITLE:- BODY	
TCO		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	D S' CAT NUMBER	
APPD		ALL THREADS CONFORM TO	DRAWING NUMBER 2-8	
DATE	28-7-86			

6-2

CS

2

Dimensions without tolerances are as per A5 C5



Carryout heat treatment as per the instructions
UT-11-63

17
I.1224

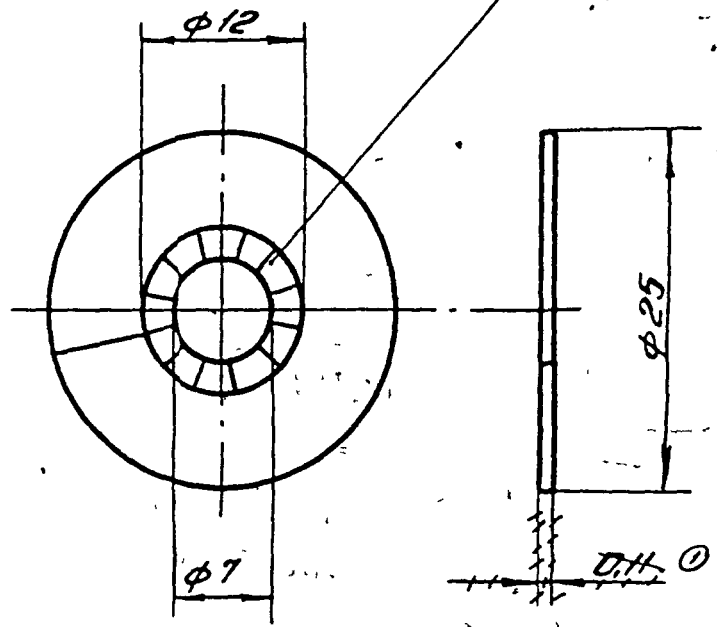
2-3K-015

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS	
		0,00443 Kg	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	USED ON:-
CHD		DIMENSIONS IN mm.	PLATE 6-114-0-15 GOST 1994-74 20895 GOST 3036-73	Cb 2-2
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APPD		ALL THREADS CONFORM TO	TITLE:-	CLAMP
DATE	28-7-86		D S CAT NUMBER	DRAWING NUMBER
				2-9

01-2

Dimensions without tolerances - as per A7 B7

Make uniformity .10-12
cuttings located along the circumference



171
I-1224

The washer may made of varnished cloth ЖKM-105 0 12
GOST 2214-78

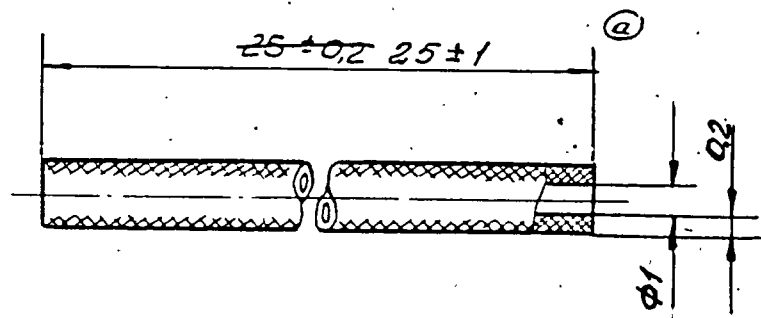
Material Varnished glass cloth
ЖСК-155/180-0.12
GOST 10156-78 2-3K-015

UNBORG
ЖК-48

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS #
		0.00009 Kg	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:- SEE ABOVE
CHD		DIMENSIONS IN mm.	USED ON:- Cb 2-3
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPR		ALL THREADS CONFORM TO	TITLE:- INSULATING WASHER
DATE	28-7-86		D S CAT NUMBER
			DRAWING NUMBER 2-10

0
0
0
0
0
0

11-2

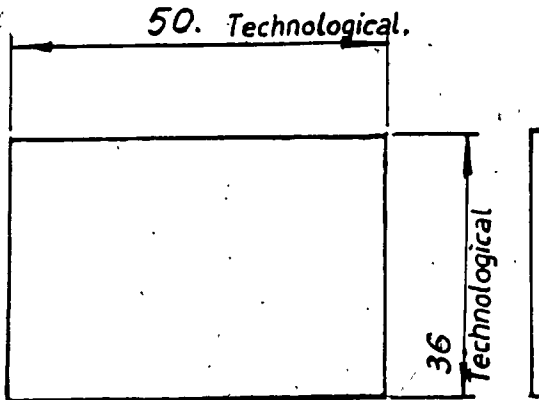


17-
I-1224

2-3K-015

48


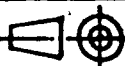
			EST. MASS 0.000056 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS * LETTERS)
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE	DATE	NATURE OF AMENDMENTS		
DRN <i>W. S. ...</i>		SCALE - 5:1	MATERIAL:- TUBE $\phi 4.4 \pm 1.0$ GRADE 1 WHITE GOST 22056-76	USED ON:- Cb 2-3
CHK <i>Santhosh</i>		DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD <i>[Signature]</i>		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.		TITLE:- INSULATION
APPD <i>[Signature]</i>		ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER 2-11
DATE 28-7-86				



1173
I-1224

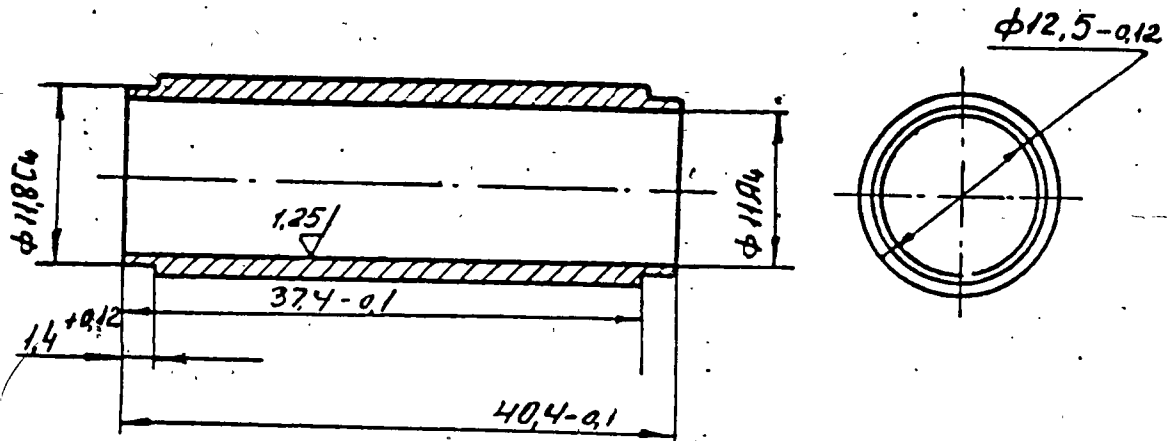
Gasket may be made of varnished cloth / KC with a thickness of 0.12mm.

2-3K-015

			EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS 
			0.0004 Kg	(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:- VARNISHED CLOTH	USED ON:-
DRN		SCALE - 2:1	AWMC-105 0.12 GOST 2214-78	Cb 2-3
CHD		DIMENSIONS	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED		TITLE:- GASKET
APRO		ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
DATE	28-7-86			2-13

71-2

Rz20 (✓)



174
I-1224

Coating: Chemically passivated.

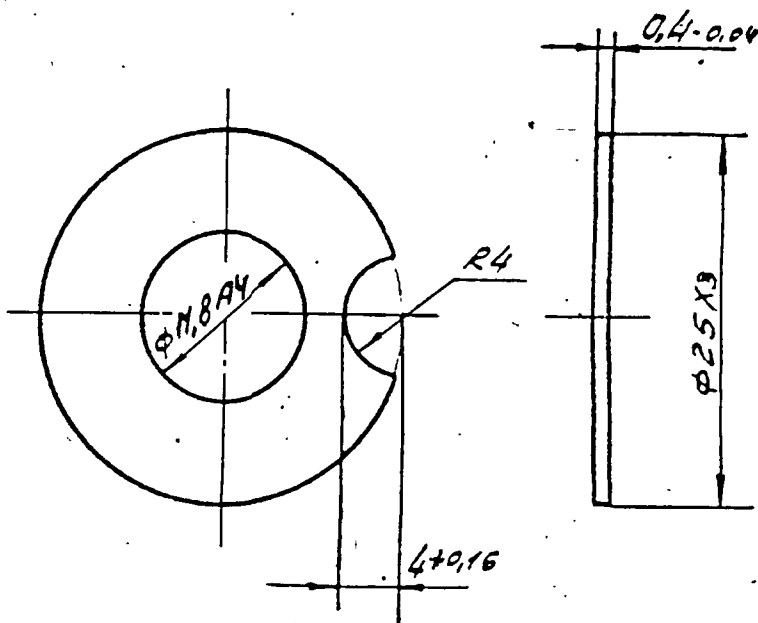
Material: Tube ДКрН 14x2 №63
GOST 494-76.

2-3K-015.

DECL 48

			EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS #	
			0,008 Kg	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:-	USED ON:-	
CHD		DIMENSIONS IN mm.	SEE ABOVE	Cb 2-5	
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
APPD		ALL THREADS CONFORM TO	TITLE:-	BUSH	
DATE	28-7-86		D S CAT NUMBER	DRAWING NUMBER	
				2-14	

2-15



Tolerances on free dimensions are as per 722 AT.

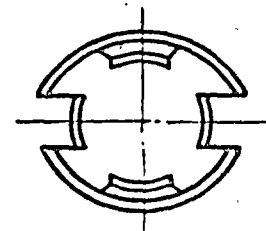
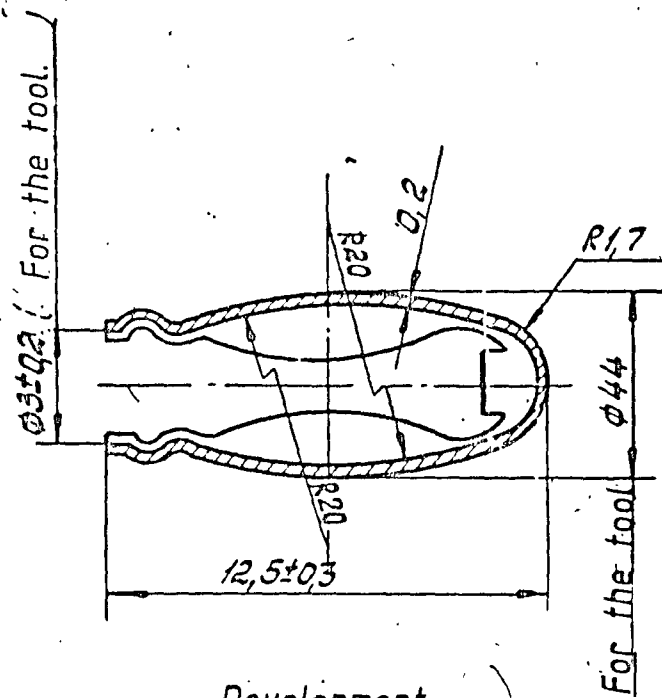
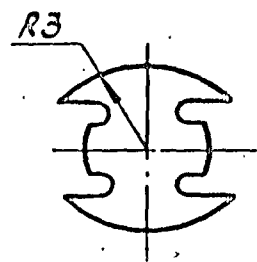
175

Coating: Chemically passivated. ✓

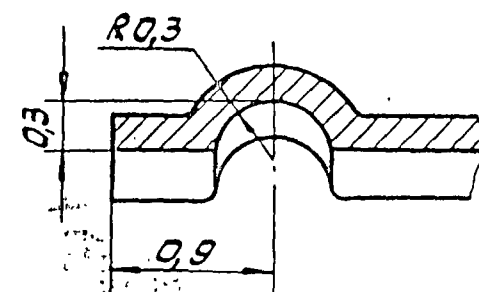
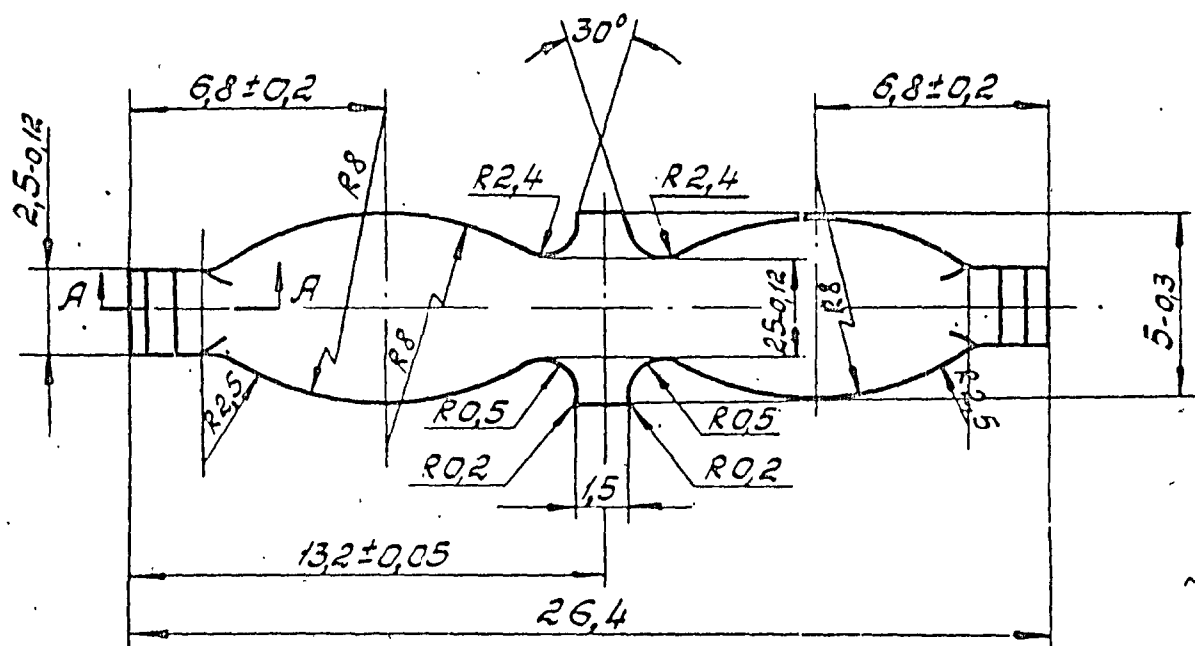
Material: Band ДПРHT 0.4 Бр 0 φ6.5-0.15
GOST 1761-79. 2-3K-015

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS LETTERS	
		0,0012 Kg		
		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	USED ON:- Cb 2-5
CHKD		DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI.	
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE:- SPECIAL WASHER	
APPD		ALL THREADS CONFORM	D S CAT NUMBER	DRAWING NUMBER
DATE	28-7-86	TO		2-15

2-16



Scale $\frac{A-A}{25:1}$



176
I-1224

Coating: Silver 9 micron thickness

2-3K-015

Blunt the sharp edges to R 0,3 mm.

Tolerances on free dimensions are as per 722AT.

Dimensions 26.4 and R3, R20, R1,7 are given for the tool.

УНБ КС 3K-48	
ВЗРМЕН УНБ № ПОДЛ.	
УНБ № ПОДЛ. 253309	
Дат	Подп.
29.12. 74г	(подп.)

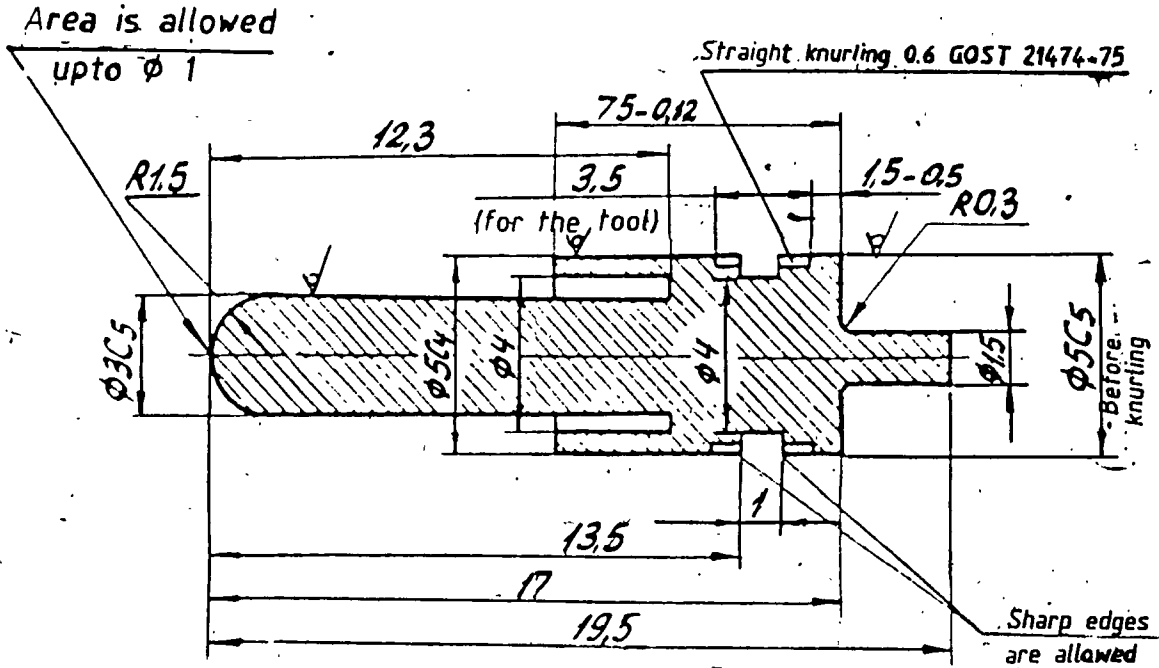
		EST. MASS 0,00016 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS *
			LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE - 5 : 1	MATERIAL :- BANDAPHT-0.2 USED ON:- Бр.-0 φ6,5-0,15 GOST 1761-79 Cb 2-6
CHD		DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
TCD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	TITLE :- SPRING OF THE PLUG
APD		ALL THREADS CONFORM TO	D S CAT NUMBER
DATE	26.12-86		DRAWING NUMBER 2-16

24-2

Rz20

68

Dimensions without tolerances are as per A5 C5.



Depression may be partially free of coating.

Tool trace on $\phi 30,5$ is allowed.

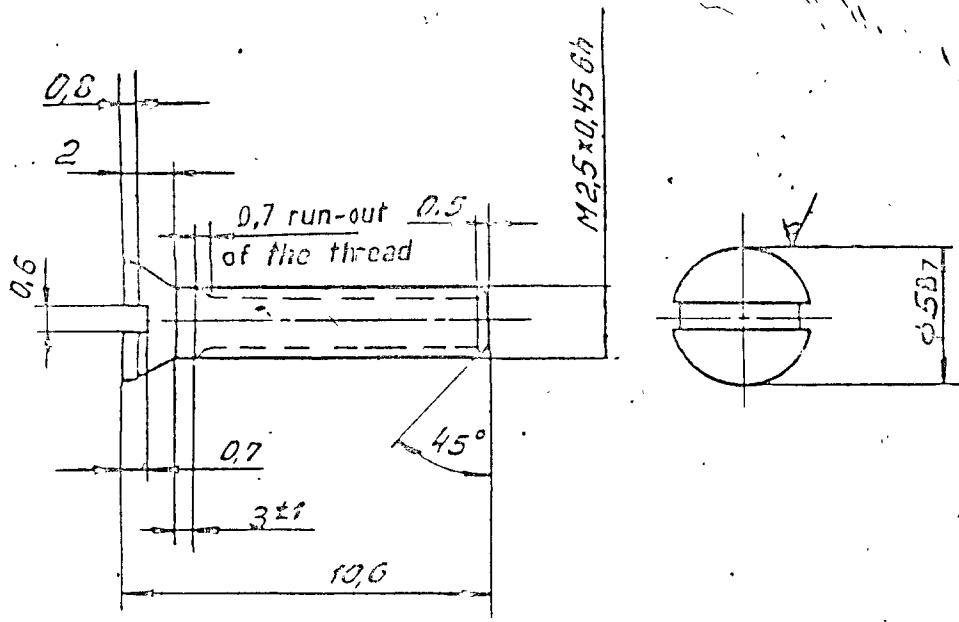
Tolerances on free dimensions for chamfers and radii are as per 722AT.

Coating: silver 3 microns thickness, 2-3K-015

48

		EST. MASS 0,0016 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 INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN S. Venkatesh		SCALE - 5 : 1	MATERIAL :- BRASS /C 59-1T ПТ GOST 2060-73
CHKD S. Venkatesh		DIMENSIONS IN mm.	USED ON :- Cb 2-6
TCD S. Venkatesh		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	CONTROLLÉRATE OF INSPECTION (HEAVY VEHICLES) AVADI
APRD S. Venkatesh		ALL THREADS CONFORM TO	TITLE :- BAR OF THE PLUG
DATE 26-7-86			D S CAT NUMBER
			DRAWING NUMBER 2-17

Rz20 (✓)



Perform dimensions without tolerances as per 722AT.
 Eccentricity of the slot to the axis of the screw should not exceed 0.2.

178
I-1224

Coating: Cadmium, 3 micron thickness, chromating. 2-3K-015

Material: Disc 5-4GOST7417-75
 45-B GOST 1051-73

Норматив: КР 3-р

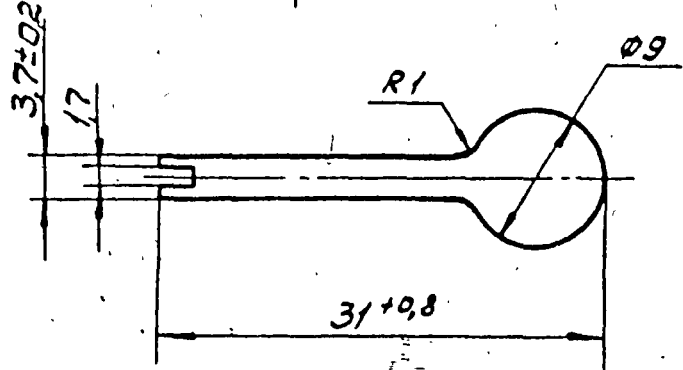
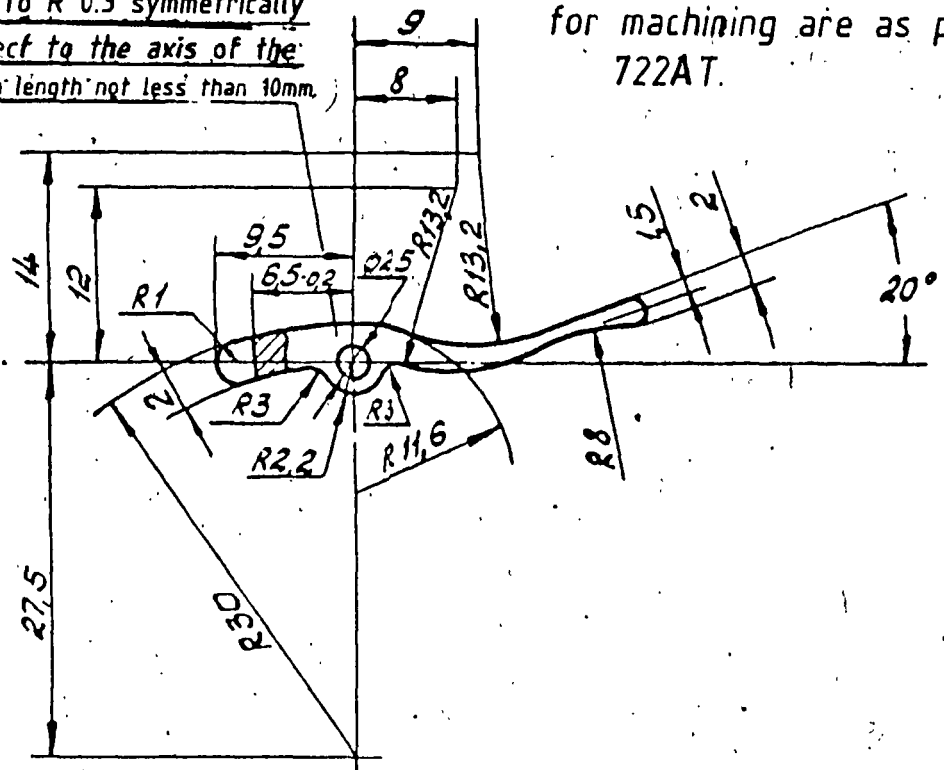
		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS (LETTERS)
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE IF INSIDE EQUIVALENT CHANGES ARE PERMISSIBLE
ISSUE	DATE	NATURE OF AMENDMENTS	
DESIGN		SCALE -	MATERIAL:- SEE ABOVE
CHKD		DIMENSIONS IN mm.	USED ON:- Cb 2-1
TCD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLER OF INSPECTION (BEAVY VEHICLES) AVAD
APPR		ALL THREADS CONFORM TO JS: 4210 Pt IV	TITLE:- SCREW
DATE	26-7-06		D S CAT NUMBER DRAWING NUMBER 2-10

E

Rz 10

Round off to R 0.3 symmetrically with respect to the axis of the hole, over a length not less than 10mm.

Tolerances on free dimensions for machining are as per 722AT.



Precision casting may be made from steel 35Xrc1 OCT1.90093-73 or steel 35Л GOST 977-75 hole Ø2.5 and slot-R_z 40

134
I. 1224

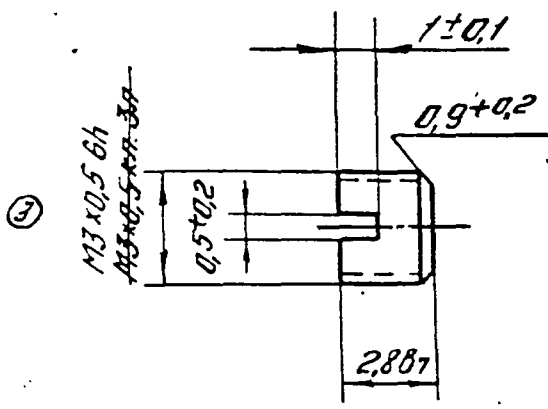
Cadmium 15 micron thickness chromated.

2 - 3K - 015

		EST. MASS 0,00198 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:- STEEL 25 GOST 1050-74	USED ON:- C6
DRN P. V. V. V.	SCALE - 2 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD D. S. R. M. S.	DIMENSIONS IN, mm.	TITLE:- LEVER	
TCD S. R. M. S.	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	D S CAT NUMBER	DRAWING NUMBER 3
ARPD M. M. M.	ALL THREADS CONFORM TO		
DATE 29-07-86			

h

R220 (✓)
5 OCT 1986



Eccentricity of the slot to the axis of the screw should not exceed 0.3mm.

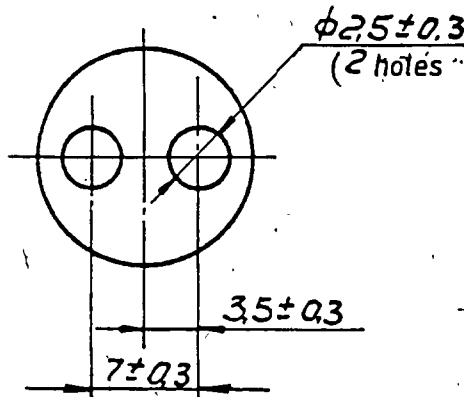
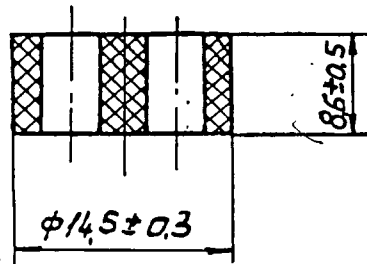
Tolerances on free dimensions are as per 722AT

E-1224

Cadmium 6 microns thickness chromated

2 - 3K - 015

		EST. MASS 0,0001 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.	
SSJE	DATE	NATURE OF AMENDMENTS	
JRN V...		SCALE - 5 : 1	MATERIAL :- CALIBRATED STEEL A 12 GOST 1414-75
HD P...		DIMENSIONS IN mm	USED ON :- C6
CD ...		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APD ...		ALL THREADS CONFORM TO IS : 4218, Pf IV	TITLE :- SCREW
ATE 29-07-86			D S CAT NUMBER
			DRAWING NUMBER 4



Surface finish in places of fin trimming is $R_z \frac{20}{\sqrt{}}$

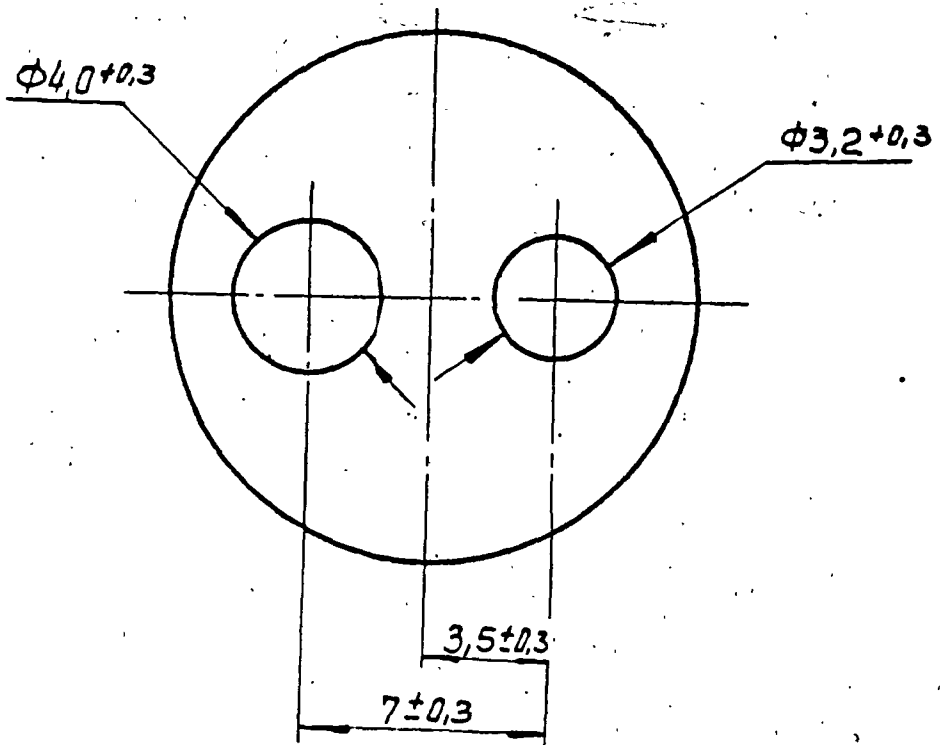
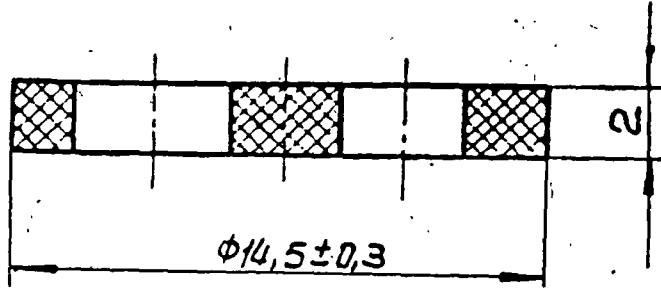
181

Material: Rubber stock TC98-1
 Ty38 005 1166-73
 2-3K-015

(A) ALT. MATL: RUBBER GRADE NI TO SPECN EQA(HV)/NBR

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)	
		0.00175 Kg		
A	13.1.07	Lt. No 81312/CA(HV)/DB-III/ ALT. MATL DT 12.10.06	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
SUE	DATE	NATURE OF AMENDMENTS	MATERIAL:-	USED ON:-
		SCALE - 2 : 1	SEE ABOVE	910.920
		DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI.	
		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE:- PACKING	
		ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
				4-4

S-7



182
I-1224

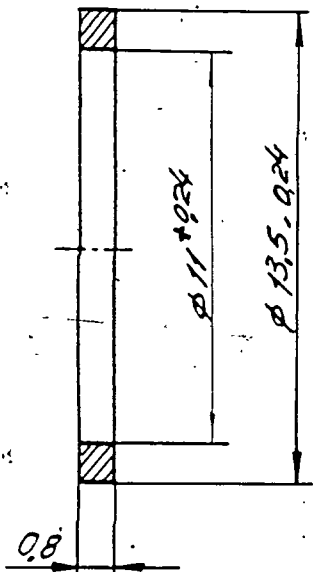
Tolerances on free dimensions are as per 722AT.

2-3K-015

			EST. MASS 0.00037 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:- TEXTOLITE A-20 GOST 2910-74	USED ON:- 910 920
DRN <i>[Signature]</i>		SCALE - 5 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
EHD <i>[Signature]</i>		DIMENSIONS IN mm.	TITLE:- GASKET	
TCD <i>[Signature]</i>		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
APD <i>[Signature]</i>		ALL THREADS CONFORM TO	DRAWING NUMBER 4-5	
DATE 28-7-86				

9-4

✓



I-1274

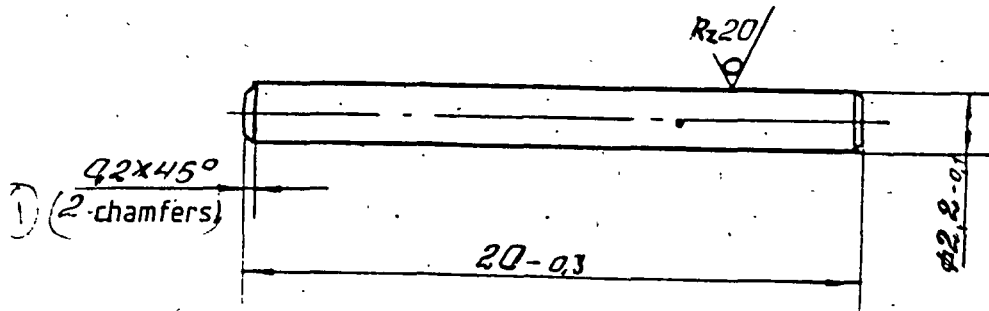
Coating Tin, 9 micron thickness.

2-3K-015

		EST. MASS 0,00027 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	
DRN S. J. ...		SCALE - 5 : 1	MATERIAL :- БАНДЛРHT 0.8163 GOST 2208-75
CHK S. J. ...		DIMENSIONS IN mm.	USED ON:- 910 920
TCD S. J. ...		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPD S. J. ...		ALL THREADS CONFORM TO	TITLE:- RING
DATE 28-7-86			D S CAT NUMBER DRAWING NUMBER 4-6

728 300 017

Rz40

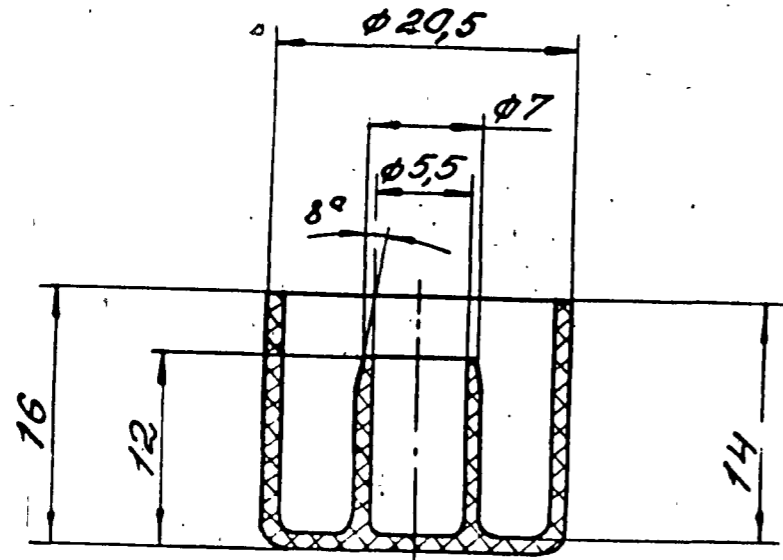


1. Dimensions without tolerances are as per 722AT.
2. Coating: Cadmium 6 microns thickness chromated.

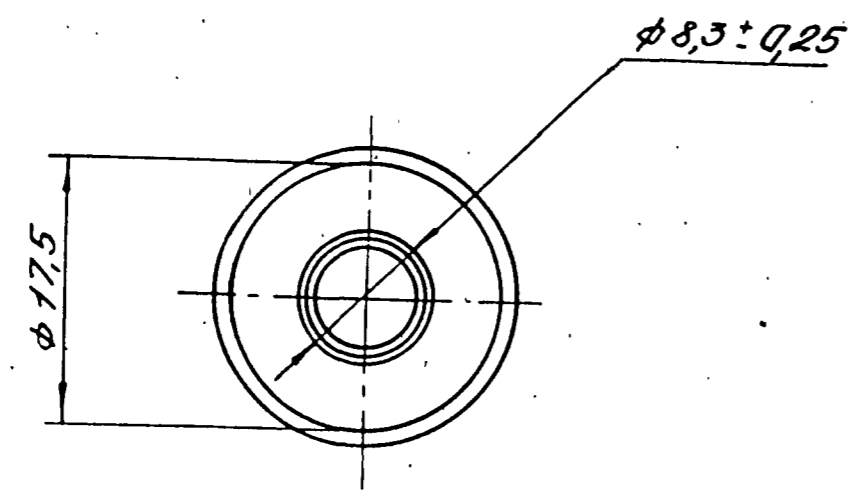
2-3K-015

I-1224

		EST. MASS 0,0006 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	
DRN <i>[Signature]</i>		SCALE - 4 : 1	MATERIAL :- WBE. 2,55 - 10 GOST 5163 - 79
CHD <i>[Signature]</i>		DIMENSIONS IN mm.	USED ON:- Cb
TCD <i>[Signature]</i>		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APRO <i>[Signature]</i>		ALL THREADS CONFORM TO	TITLE:- PIN
DATE 30.07.86		D S CAT NUMBER	DRAWING NUMBER. 728 300 017



1. Unspecified limit deviation of dimensions $\pm 0,3mm$.
2. Unspecified casting radii should not exceed R1.
3. Draft angles should not exceed 1° .
4. Technical specifications are as per OCT 100543-72.



2-3K-015

192
T-1224

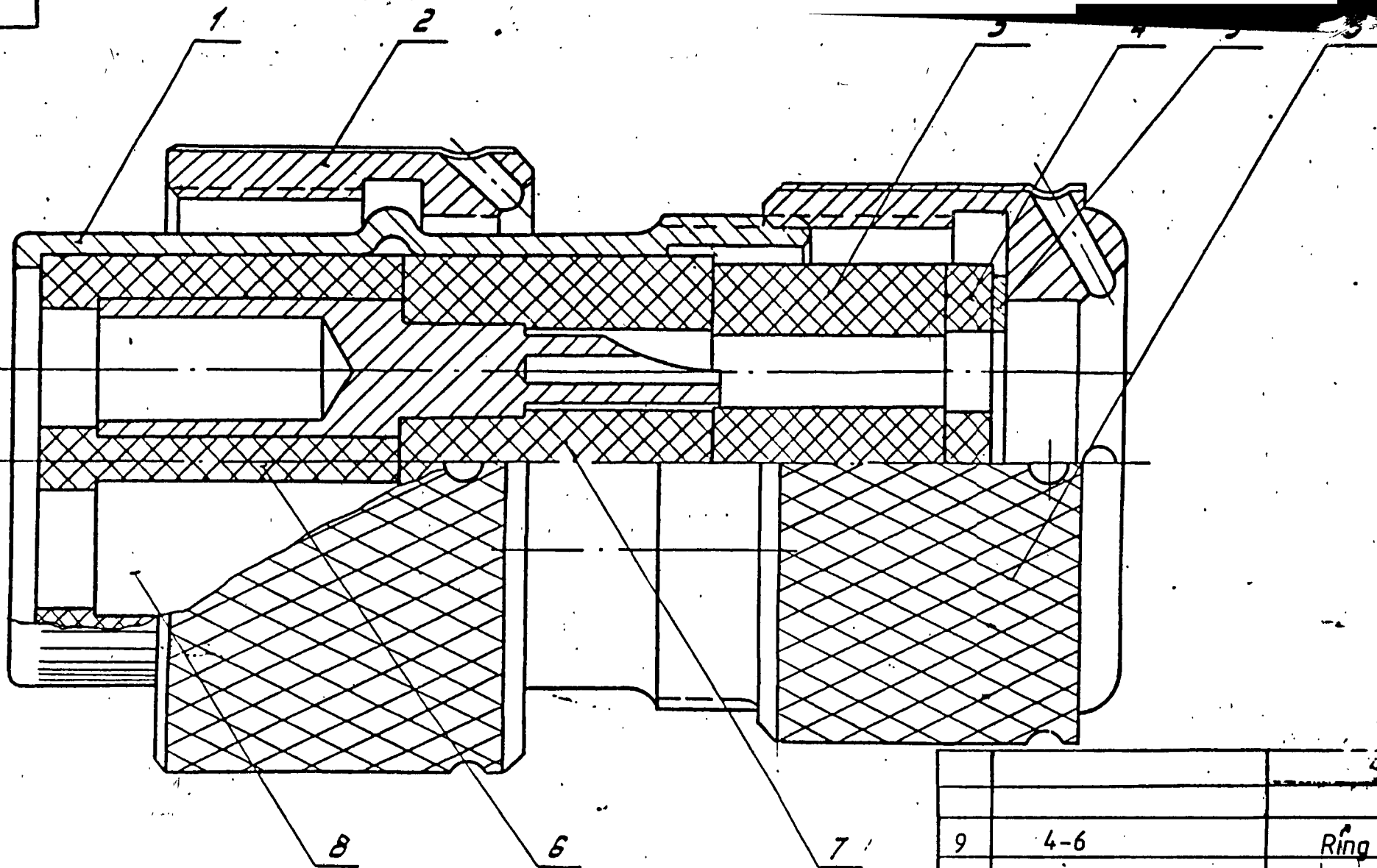
Справка N

Учб. и дата
30/4/81
Учб. и дата
10/11/81
Учб. и дата
Учб. и дата
Учб. и дата

		EST. MASS 0,001 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 :-POLYETHYLENE 15803-020 GRADE 2 GOST 16337-77	USED ON:- Cb
DRN S.K. 10/11/81	SCALE - 2 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHP S.K. 10/11/81	DIMENSIONS IN mm.	TITLE:- PLUG	
TCD S.K. 10/11/81	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
APP S.K. 10/11/81	ALL THREADS CONFORM TO	DRAWING NUMBER 7 Д 8 632 028	
DATE 30.07.86			

10/11/81

026 016



130
I-1224

2-3K-015

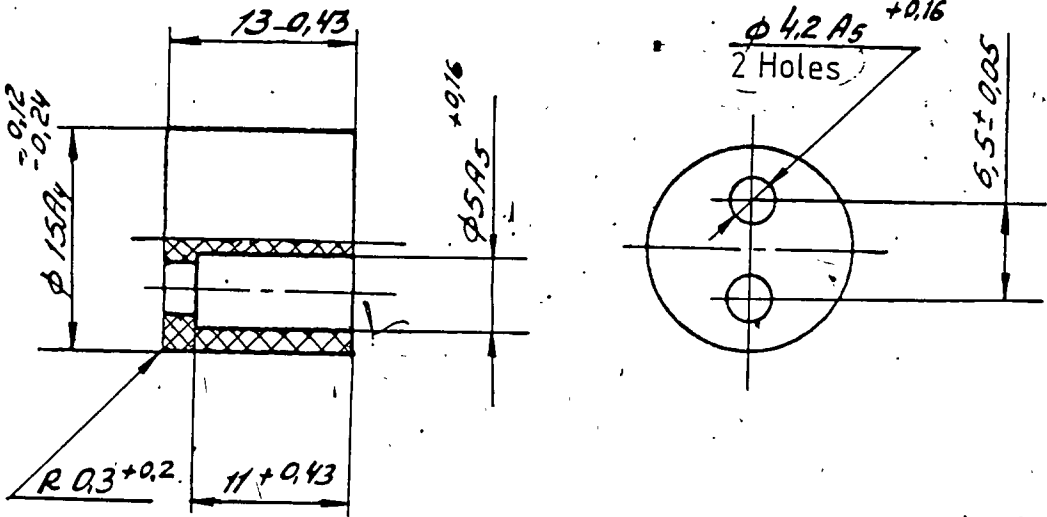
Before the assembly of the body 4-1 clean the thread with chamois impregnated with lubricant UATUM-221, OCT 3801180-80 and squeezed.

R.NO.	DESIGNATION	DESCRIPTION	QTY.	REMARKS
9	4-6	Ring	1	
8	910923	Socket	2	
7	910.922	Insulator	1	
6	910.921	Insulator	1	
5	4-7	Nut	1	
4	4-5	Gasket	1	
3	4-4	Packing	1	
2	4-3	Nut	1	
1	4-1	Body	1	

EST. MASS		TO BE STAMPED OR MARKED WHERE INDICATED THUS #	
20 g		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 - 5 : 1	MATERIAL :-
CHD		DIMENSIONS IN mm.	USED ON :-
TCO		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	cb
APD		ALL THREADS CONFORM TO	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
DATE	28-7-86	TO	TITLE :-
			SOCKET
		D.S. CAT NUMBER	DRAWING NUMBER
			910 920

3K-48
 УНБ. А. мод. 10.7.75
 270455
 УНБ. А. мод. 10.7.75
 270455
 УНБ. А. мод. 10.7.75
 270455

910 921



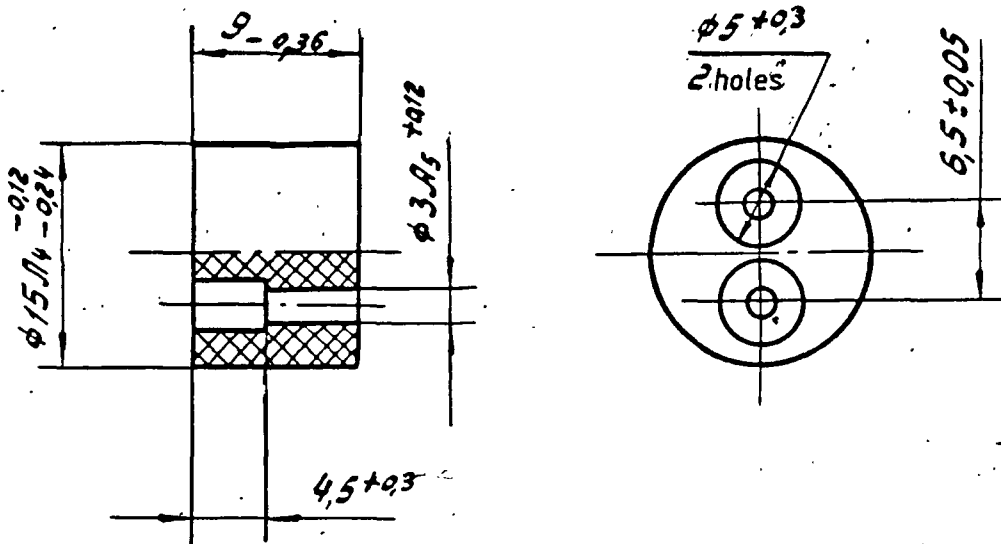
Moulding drafts 90° .

All dimensions are given for the tool.

185
I-1224

2-3K-015

			EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS #
			2.9g	LETTERS)
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R ^o OUTSIDE R ^o INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL:- AMINO PLAST M ϕ	USED ON:-
DRN		SCALE - 2:1	B1 GRADE 1 GREY GOST 9359-80	910 920
CHKD		DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE:- INSULATOR	
APPR		ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
DATE	28-7-86			910-921



Moulding drafts 90°

All dimensions are are given for the tool.

м.г. 83. У.У.Б.А. У.У.Б.А. У.У.Б.А. У.У.Б.А.

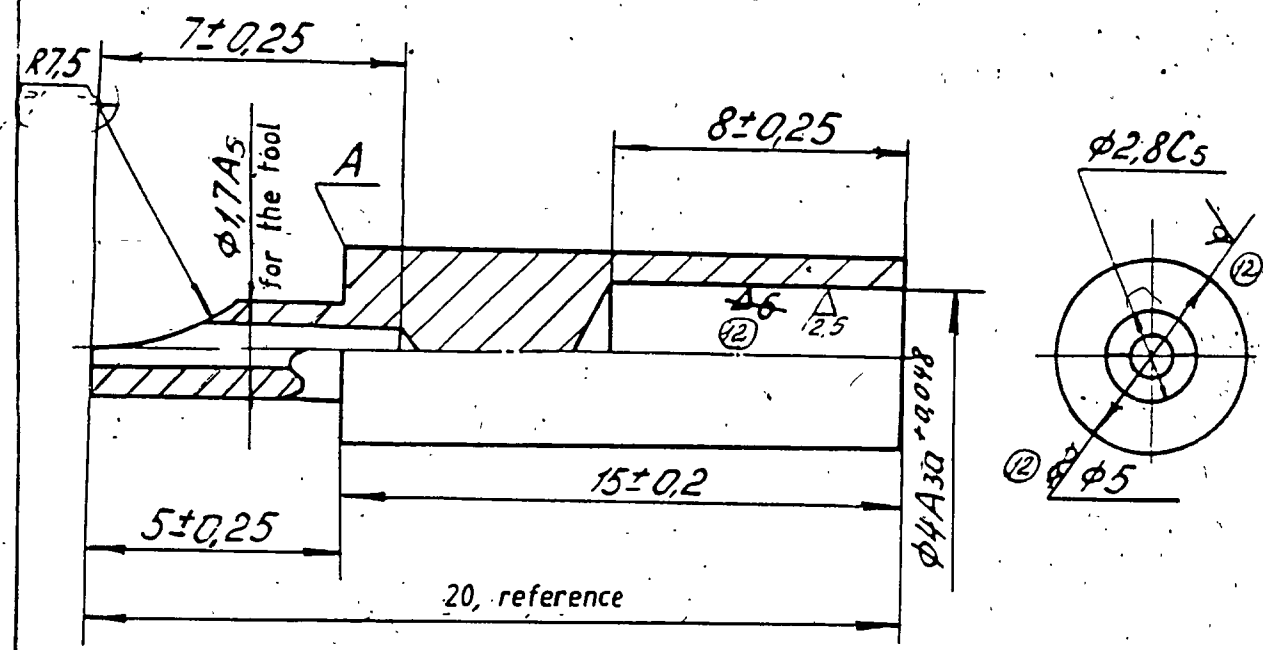
186
7 1224

2-3K-015
Material: Aminoplast МФВ1, grade 1,
grey GOST 9359-80

		EST. MASS	TO BE STAMPED OR MARKED WHERE
		2,2 g	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	
DRN		SCALE - 2 : 1	MATERIAL:- SEE ABOVE
CHD		DIMENSIONS IN mm.	USED ON:- 910 920
TCO		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPO		ALL THREADS CONFORM TO	TITLE:- INSULATOR
DATE			D S CAT NUMBER
			DRAWING NUMBER 910 922

910923

5 остальное
Rz20 (✓)



Cutting on the surface A is allowed during milling of the radius, R7.5.

External surface may be coated to a thickness not exceeding 15 microns.

Blind holes may be partially free of coating.

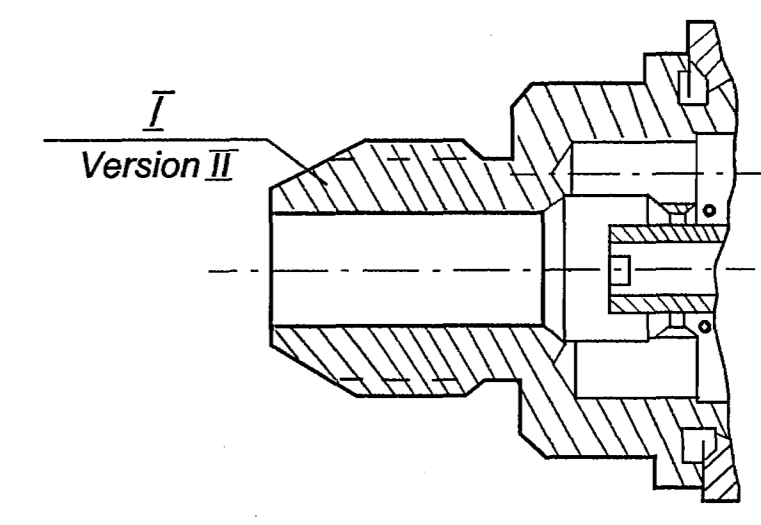
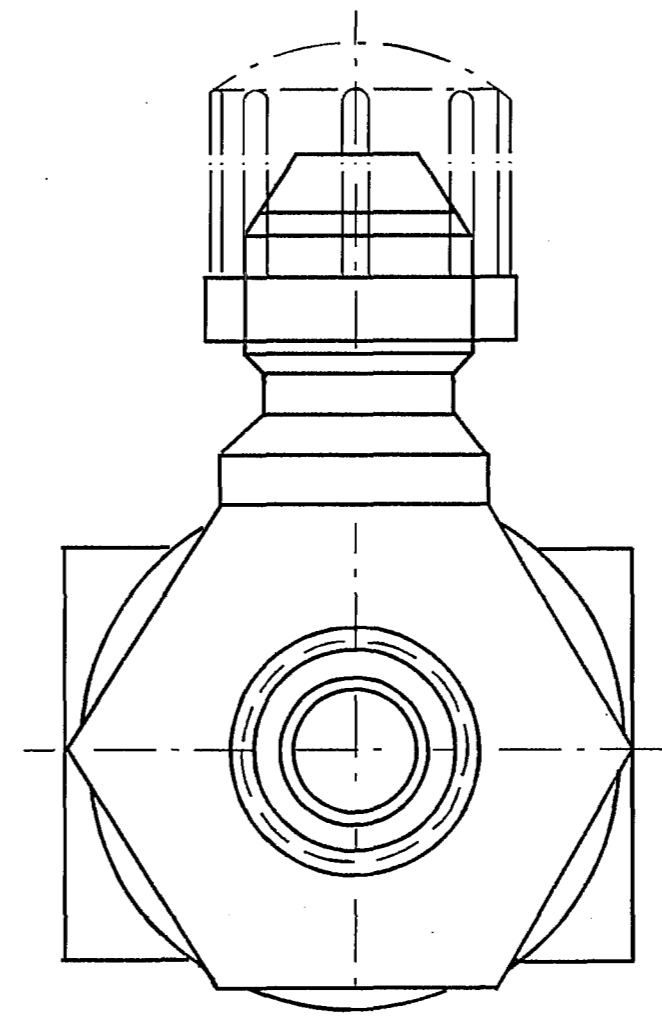
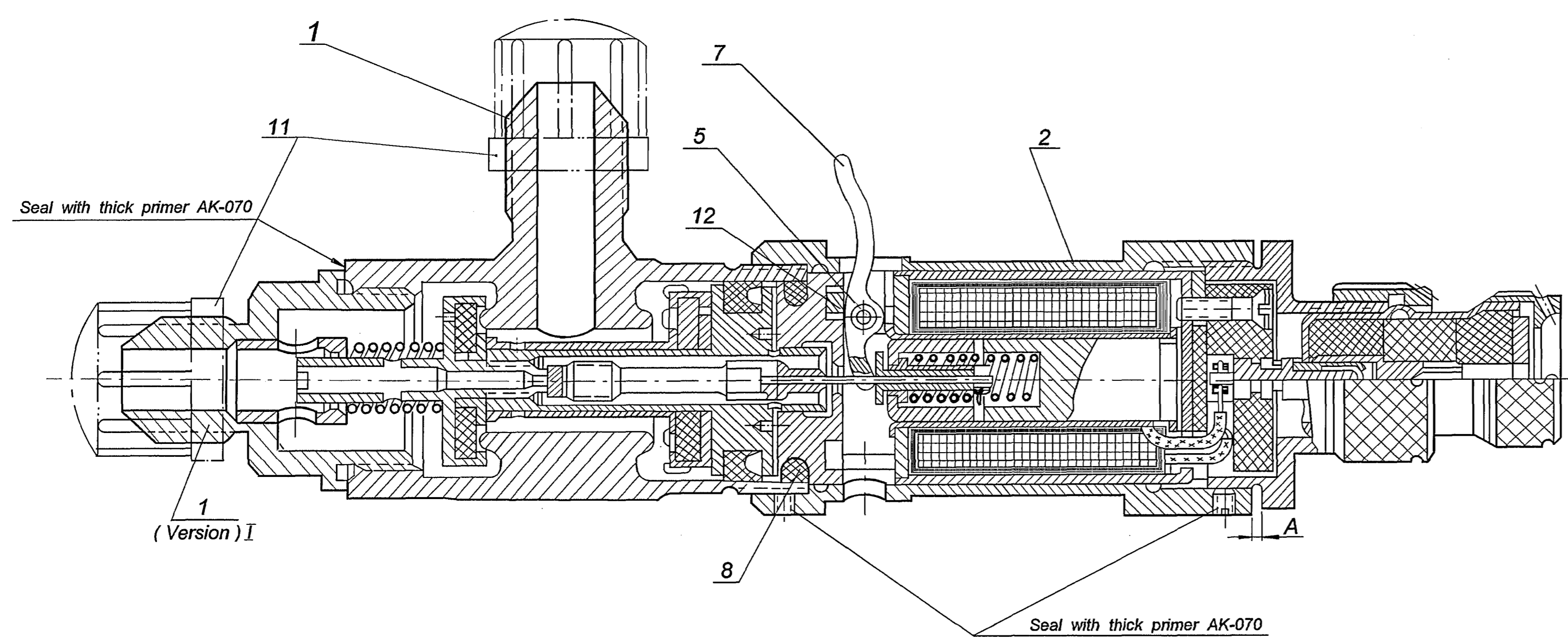
Silver 9 micron thickness.

Material: Brass AC59-1TnT
GOST 2060-73.

2-3K-015.

48

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS LETTERS	
		1.5g		
		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	MATERIAL:-	USED ON:-
DBN		SCALE - 5 : 1	SEE ABOVE	910-920
CHD		DIMENSIONS IN mm.	CONTROLLER OF INSPECTION (HEAVY VEHICLES) AVADL	
TCD		TOLERANCE ON DIMNS. UNLESS OTHERWISE STATED	TITLE:- SOCKET	
APPD		ALL THREADS CONFORM TO	D S EAT NUMBER	DRAWING NUMBER
DATE	20-7-06			910 923



1. IN THE ASSEMBLY, SECURE THE ROLLER (PART 7D8.300.017) ON BOTH SIDES WITH THICK PRIMER AK-070 OCT-6-10-401-76.
2. POSITION OF LEVER (PART No.3) SHOULD BE IN SYMMETRY PLANE OF THE VALVE. ADMISSIBLE PLANE DEVIATION IS $\pm 15'$.
3. SECURE THE SCREW (PART No.4) WITH THICK PRIMER AK-070.
4. BEFORE ASSEMBLY OF ELECTRIC SYSTEM Cb.2 WIPE THREAD OF BODY (7D7.772.009) WITH SUEDE SOAKED SQUEEZED IN LUBRICANT U.UATUM-221 OCT 3.801180-80.
5. CHECK ASSEMBLED VALVES IN JOINT BETWEEN INLET CONNECTION AND BODY FOR AIR-TIGHTNESS IN THE FOLLOWING SEQUENCE.
 - a) ELECTRIC PNEUMATIC VALVE IS CONNECTED WITH THE PNEUMATIC SYSTEM BY INLET CONNECTION. THE TECHNOLOGICAL STOPPER IS SCREWED ON TO THE OUTLET CONNECTION.
 - b) VESSEL WITH TRANSPARENT WALLS AND REFLECTOR IS FILLED WITH FUEL TC-1 UPTO THE CLOSURE OF INLET CONNECTION BY 5-10 mm.
 - c) INSPECTION - VISUALLY AIRTIGHTNESS SHOULD BE FULL.
 - d) AT PRESSURE OF 90 ATMOSPHERES, CHECKING TIME IS TO BE 1 MINUTE. BEFORE INSTALLATION OF SOCKET WIPE THREAD M20x1k1.2a OF THE STOPPER AND THREAD M16x1k1.3n OF OUTLET CONNECTION 3-4 WITH SUEDE SOAKED IS LUBRICANT U.UATUM-221 OCT 3801180-80 AND SQUEEZED.
6. DURING INSTALLATION OF ARTICLE 3K-48 IN THE MATED UNIT TIGHTENING TORQUE OF THE NUT SHOULD NOT EXCEED 1,0 Kgm.
7. ENSURE THE REQUIRED CLEARANCE "A" NOT MORE THAN 1,5mm BETWEEN CASE 7D7.712.012 AND STOPPER 2-4.
8. PRIMER AK-070 OCT 6-10-401-76 THICK PIGMENTED WITH GREEN DYE TECHNICAL SPECIFICATIONS Ty 6-09-4278-76.
9. ASSEMBLY AND PRODUCTION OF ARTICLES WITH UNITS Cb 1- OR II VERSIONS ARE ALLOWED.
10. WRENCH TRACE IS ALLOWED ON PARTS 7D7.772.012, 2-4, 7D7.772.009, Cb1-2 OR 7D8.652.018. COAT THE WRENCH TRACE USING PRIMER AK-070, OCT 6-10-401-76.

R.NO.	DESIGNATION	DESCRIPTION	Q.TY.	REMARKS
1	Cb1- Version II	Pneumatic valve	1	
2	cb.2	Electric system	1	
3	910,920	Socket	1	
4	7D8.300.017	Roller	1,01	
5	2	Magnet (spring)	1	
6	LV21cv 2540-003066 3	Lever Release	1	REF. DCU 00996-1cv
7	LV21cvs 5305-018917 4	Screw Gurb	2,02	REF. DCU 00996-1cv
8		Primer AK-070 OCT 6-10-401-76.		
9	7D8632028	Stopper	2	
10	7D8.126.030	Holder	1	

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

EST. WT. 0.47 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.

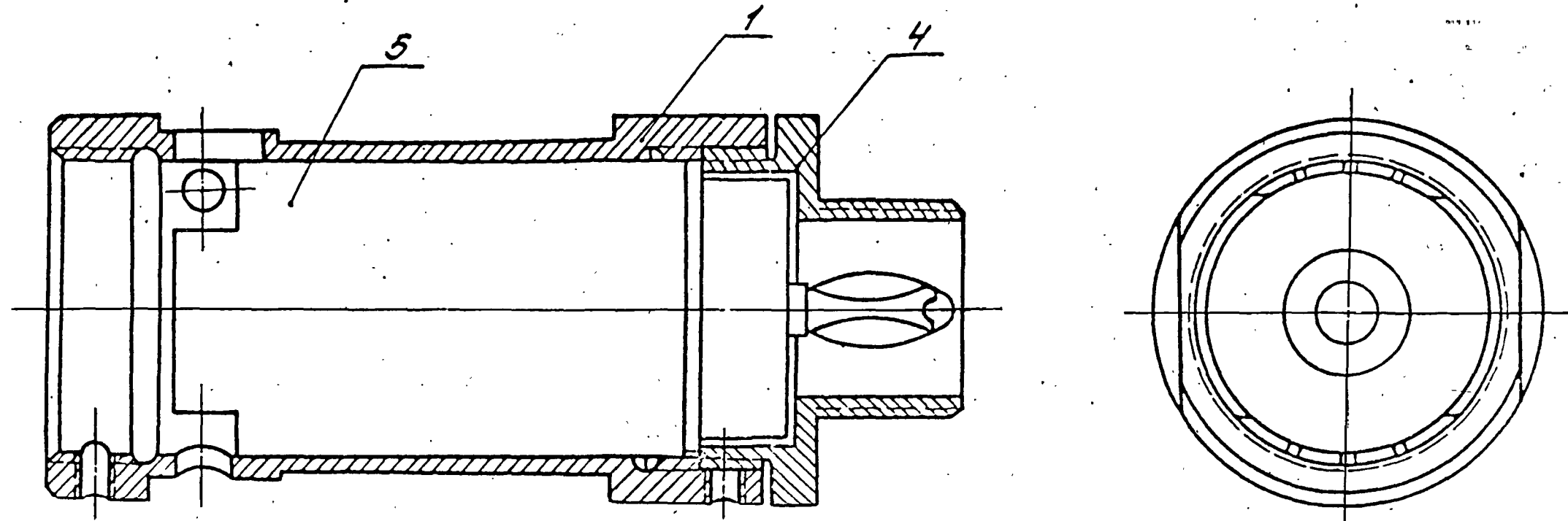
DRN	-sd-	MATERIAL:-	USED ON:-
CHD	-sd-		155 38 127 Cb
APPD	-sd-	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	20.11.2008	AVADI	
SCALE:-	2:1	TITLE:-	
DIMENSIONS IN mm		ELECTRIC PNEUMATIC VALVE	
TOLEANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69		D S CAT NUMBER	DRAWING NUMBER
ALL THREADS TO CONFORM TO IS : 4218 Pt. IV			Cb
ISSUE	DATE	NATURE OF AMENDMENTS	

Approved (G. THIRUGANATHI) 12 DEC. 2008

COMPARED WITH ORIGINAL DRG.

DRG RE - INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NIL

I-1224



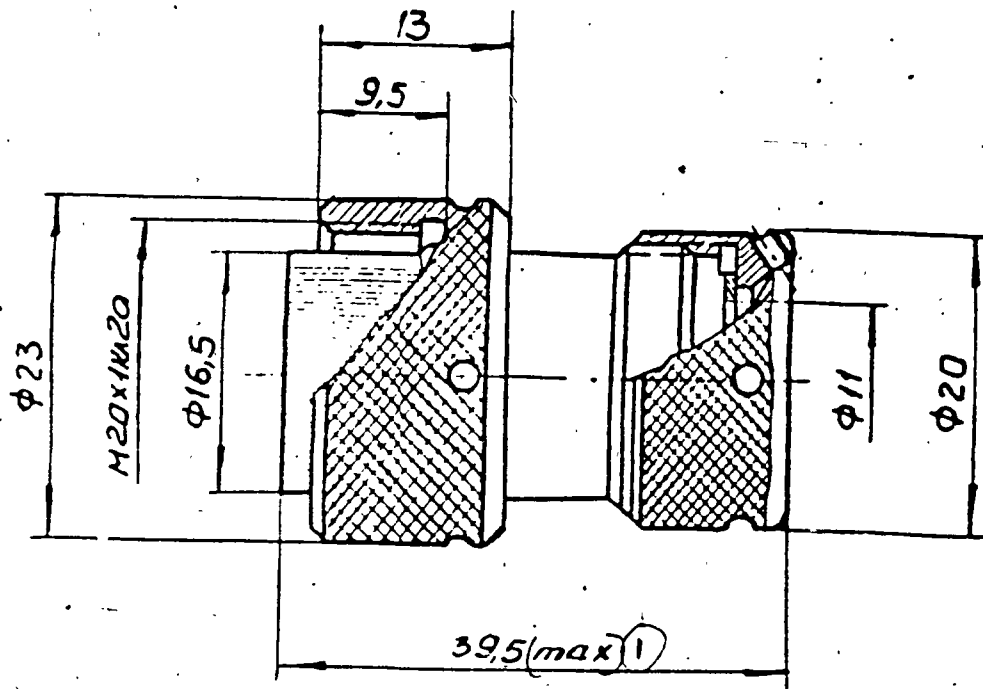
2-3K-015

Before setting up plug 2-4 clean the thread with chamois, impregnated with lubricant QUATUM-221 as per OCT 3801180-80 and squeezed.

Sl. No.	Designation	Description	Qty.	Remarks
5	cb.2-1	Electro magnet	1	
4	2-4	Plug	1	
3				
2				
1	2A7.772.012	Body	1	

EST. MASS 0,20086 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 INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.			
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL	USED ON:- Cb
DRN <i>W...</i>	SCALE 2:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD <i>P...</i>	DIMENSIONS IN mm	TITLE:- ELECTRIC SYSTEM	
TCD <i>J...</i>	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED	D S EAT NUMBER	DRAWING NUMBER Cb 2
APPD <i>M...</i>	ALL THREADS CONFORM TO		
DATE 26-7-84			

CS 47

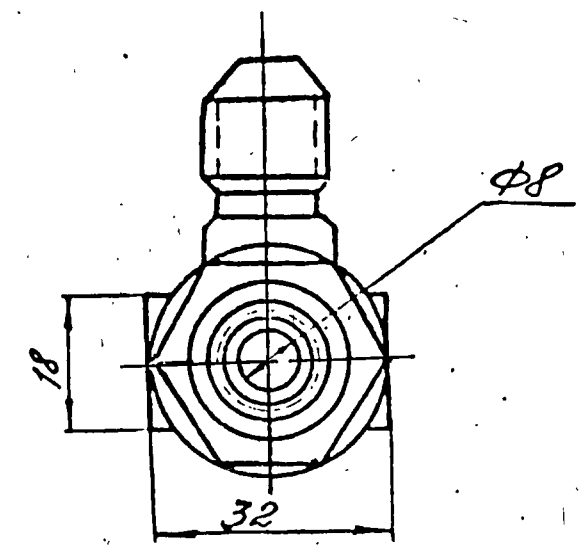
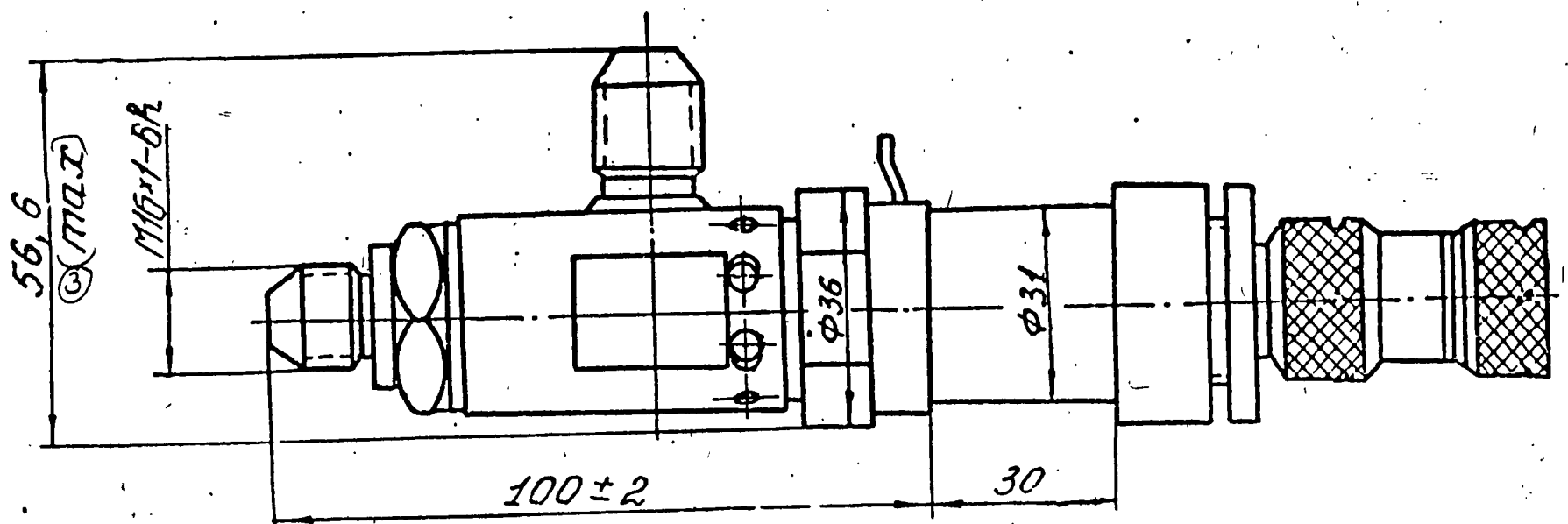


1) Dimensions without tolerances are given for reference.

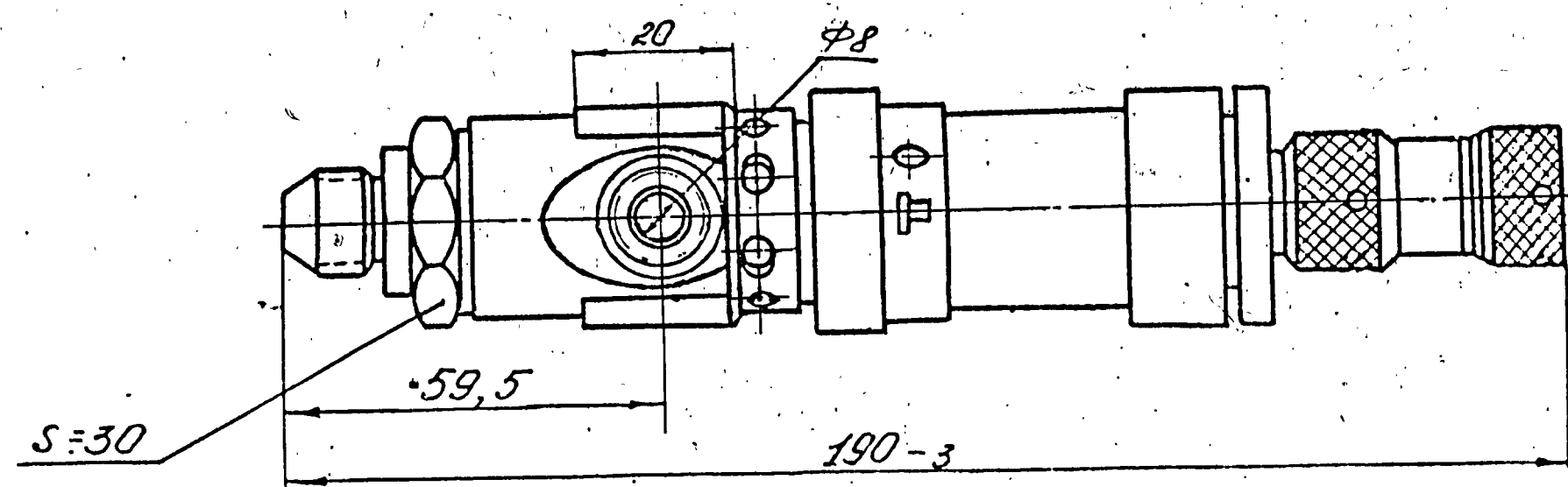
84
I-1224

2 - SK-015

			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:-
ORN S.K. Guntur		SCALE - 2 : 1		
CHD Sanku R.		DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD S.K. Guntur		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE:- SOCKET (OUT LINE DRG)	
APRD Sanku R.		ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
DATE 29-07-86				CS 47



Place of mounting of the valve.



63
I-1224

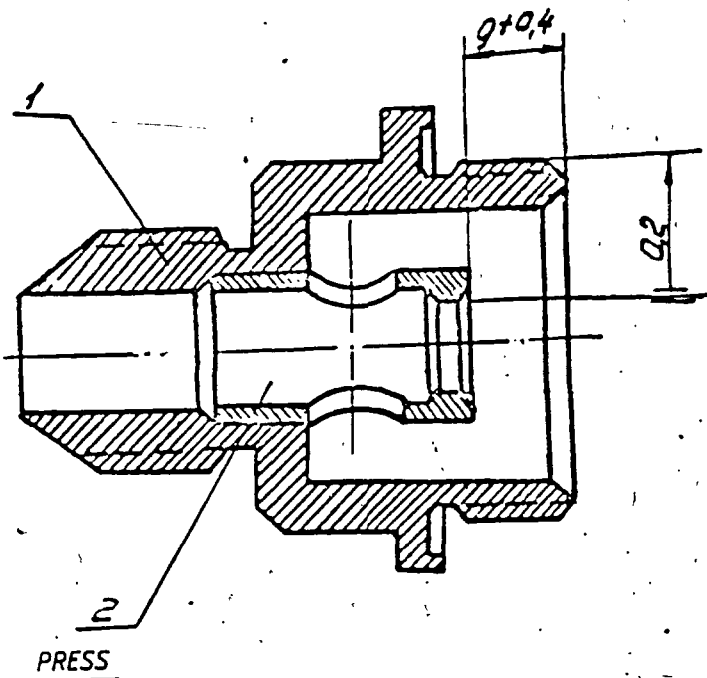
2-3K-015

Dimensions without tolerances are given for references.

		EST. MASS 470 g	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	
DRN		SCALE - 1:1	MATERIAL:-
CHD		DIMENSIONS IN mm.	USED ON:-
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPI		ALL THREADS CONFORM TO	TITLE:- ELECTRIC PNEUMATIC VALVE 3K-48 (OUT LINE DRG.)
DATE			D S CAT NUMBER
29-07-86			DRAWING NUMBER, C6 Г

3K-48
 К. С. В. П. П. Л. М. Е. Н.
 3K-48

CS 1-2



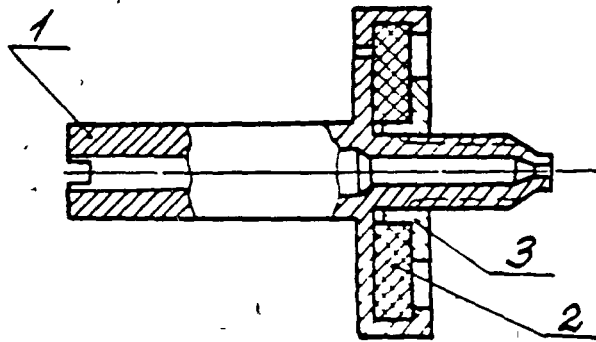
112
I 1224

R.NO.	DESIGNATION	DESCRIPTION	Q.TY.	REMARKS
1	1-7	Connection	1	
2	1-8	Insert	1	

2-3K-015

		EST. MASS 0.051 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 INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL:-	USED ON:- Cb.1
CHKD	SCALE - 2:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD	DIMENSIONS IN mm.	TITLE:- CONNECTION	
APPL	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	D S CAT NUMBER	
DATE	ALL THREADS CONFORM TO	DRAWING NUMBER Cb 1-2	
29-7-86			

CB-1-3



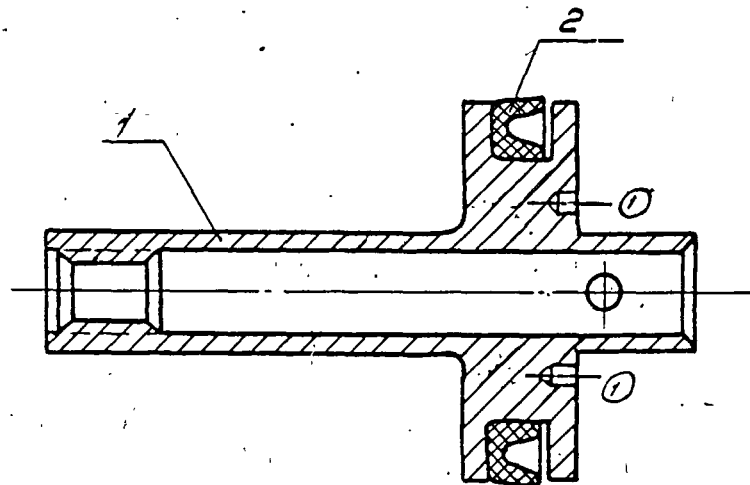
2-3K-015

3	1-11	Bush	1	
2	1-10	Seal of the valve	1	
1	1-9	Inlet valve	1	
Sl. No	Designation	Description	Qty	Remarks

HBRKC
 X-48

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS * LETTERS	
		0,01134 Kg		
		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:- Cb.1	
DRN S. Sankar	SCALE - 2 : 1.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
CHD S. Sankar	DIMENSIONS IN mm.	TITLE:- INLET VALVE		
TCD S. Sankar	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	D S CAT NUMBER		
APPD S. Sankar	ALL THREADS CONFORM TO	DRAWING NUMBER Cb 1-3		
DATE 28-7-86				

7-190



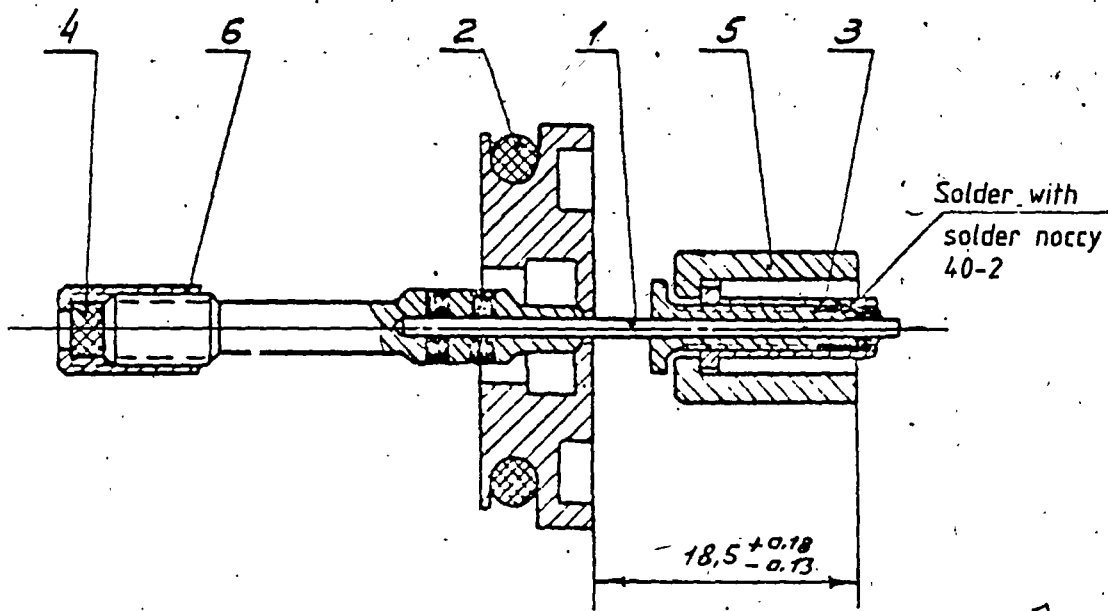
11
I-1224

2-3K-015

Sl. No.	Designation	Description	Qty	Remarks
2	1-14	Sealing Ring	1	
1	1-15	Special bush	1	

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS * LETTERS)	
		0.0210 Kg		
		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 IN:-
EHD		DIMENSIONS IN mm.	Cb. 1	
TCD		TOLERANCE ON DIMNS. UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADL	
ARPD		ALL THREADS CONFORM TO	TITLE:- PISTON	
DATE	26-7-86		D S EAT NUMBER	DRAWING NUMBER
				Cb 1-4

5-1-93



2-3K-015

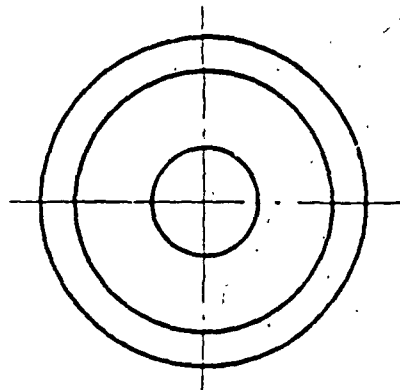
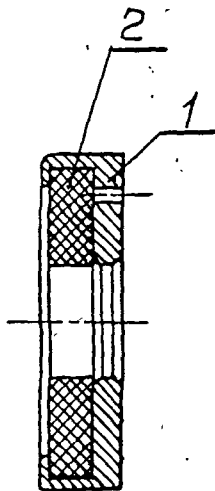
While assembling set backlash between the armature part 1-19 & bushings part 1-24 in the range of 0.04-0.06 It is allowed to reduce the backlash upto 0.03-0.06mm in the sector 120°.

ST. No.	Designation	Description	Qty	Remarks
8		Solder nocy 40-2 GOST 21931-76		
6	1-20	Bush	1	
5	1-19	Armature	1	
4	1-18	Packing of the servo valve	1,1	
3	1-17	Bush	1	
2	1-16	Ring	1	
1	Cb 1-7	Servo valve	1	

EST. MASS		TO BE STAMPED OR MARKED WHERE INDICATED THUS * (LETTERS)	
0,0300 Kg			
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	
ORN		SCALE - 2 : 1	MATERIAL:-
CHD		DIMENSIONS IN mm.	USED ON:- Cb.1
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPO		ALL THREADS CONFORM TO	TITLE:- SERVO VALVE
DATE	26-7-86		D S CAT NUMBER
			DRAWING NUMBER Cb 1-5

21

9-1 '87



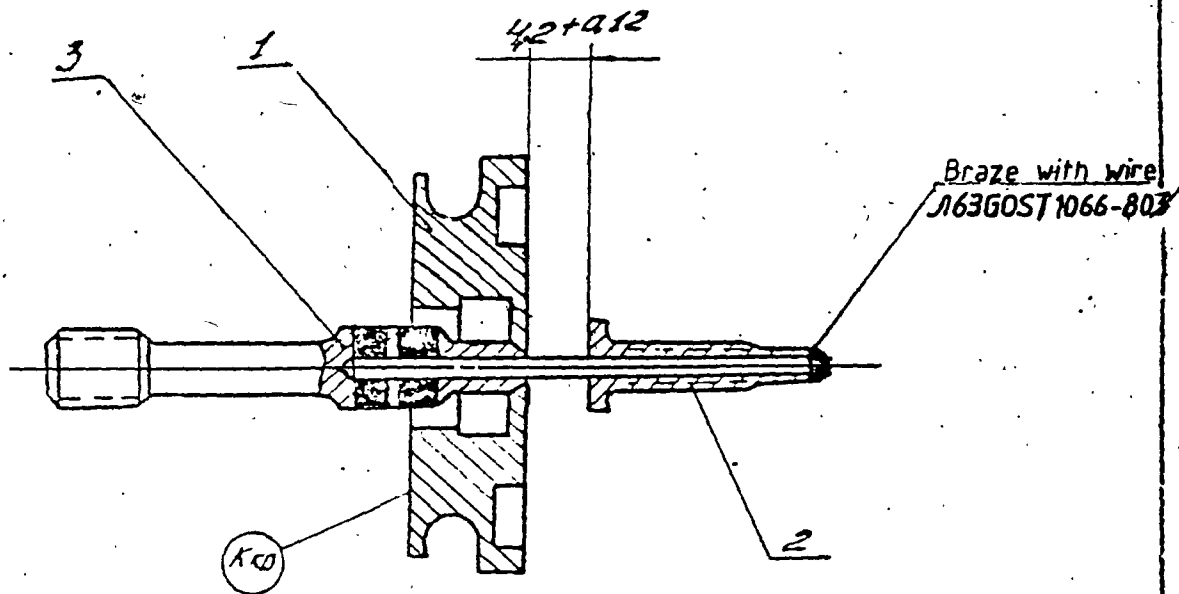
R.NO.	DESIGNATION	DESCRIPTION	QTY.	REMARKS
1	1-21	Valve	1	
2	1-22	Seal of the valve	1	

2-3K-015

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)	
		0.0035 Kg		
		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:-	
ORN	SCALE 2:1		Cb.1	
CHO	DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
TCD	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	TITLE:- DISCHARGE VALVE		
APRO	ALL THREADS CONFORM TO	D.S. CAT NUMBER	DRAWING NUMBER	
DATE			Cb 1-6	
29-7-86				

L-7 90

119
E-1224



Check the air tightness of the servo valve.

When the pressure is 20-70 Kg/cm² air release may be not exceeding 50 cm³ /second.

To obtain specific air tightness combined grinding of the sphere of of unit assy 1-8 and taper of the part 1-23 is allowed.

Dress the place of soldering to a length not exceeding 5 mm from face of the bush.

After coating callibration of thread is permissible.

Coating may be removed in places of dressing, callibration of thread and grinding.

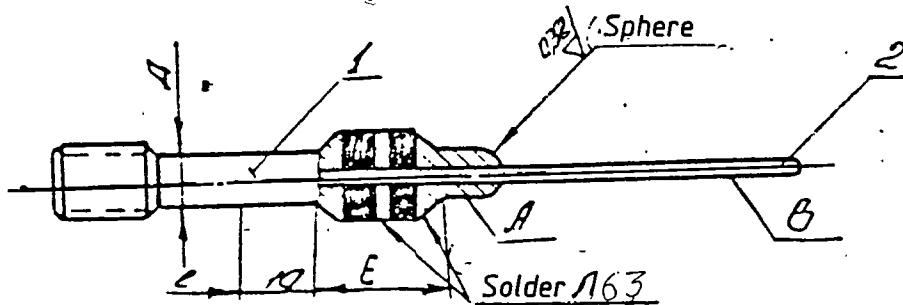
2-3K-015

3	Cb 1-8	Servo valve	1	
2	1-24	Bush	1	
1	1-23	Sleeve	1	
Sl. No.	Designation	Description	Qty.	Remarks

EST. MASS		TO BE STAMPED OR MARKED WHERE INDICATED THIS LETTERS)	
0,0210 Kg			
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 A. Venkatesh		SCALE - 2 : 1	MATERIAL :- USED ON :- Cb 1-5
CHKD R. Ramakrishna		DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
TCD S. Sankar		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE :- SERVO VALVE
APD S. Sankar		ALL THREADS CONFORM TO	D S CAT NUMBER DRAWING NUMBER Cb 1-7
DATE 26-7-86			

8-1-87

120
I-1224



After soldering in section E hardness may be increased upto HRC 52

External appearance of soldering places are as per the standard.

Before coating dress the welded place.

It is allowed to galvanize in the unit Assy 1-7

Zinc-coated, 6 micron thickness, chromitized

Play of surface "B" with respect to surface "A" should not exceed 0,15mm qualified tolerance.

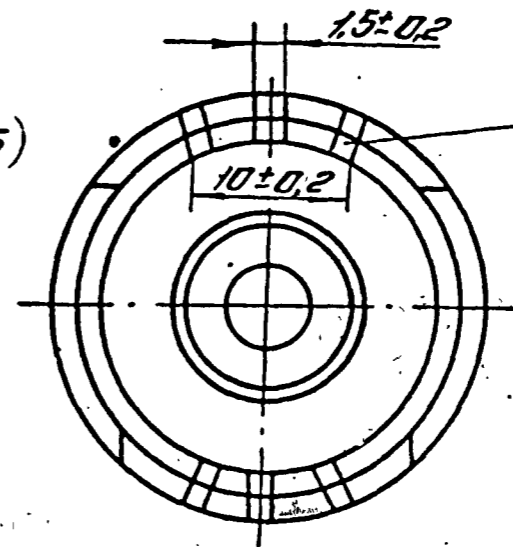
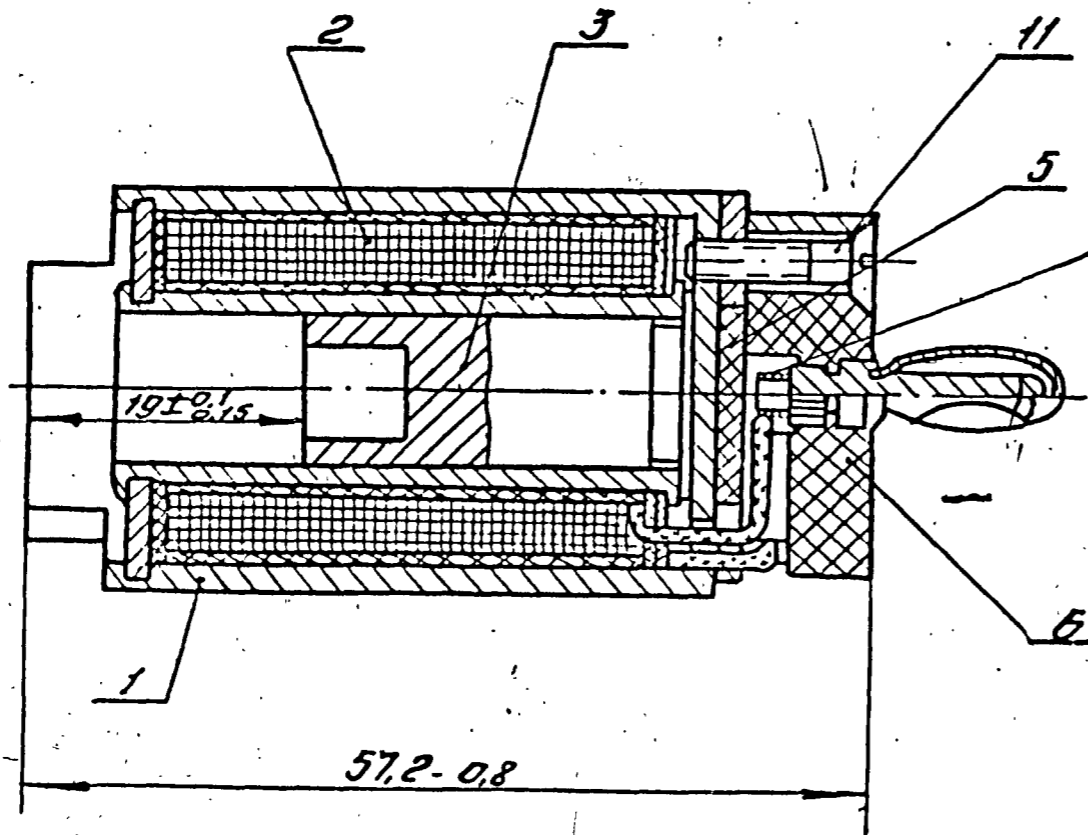
While trimming the fin, cutting in to ϕ is allowed upto 0.2mm and not more over length l .

2-3K-015

3		Wire 163 GOST 1066-80		
2	1-26	Needle	1	
1	1-25	Servo valve	1	
Sl. No	Designation	Description	Qty	Remarks

		EST. MASS 0.0035 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 INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL:-	USED ON:- Cb 1-7
DRN P. V. S.		SCALE - 2 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD P. V. S.		DIMENSIONS IN mm.	TITLE:- SERVO VALVE	
TCD P. V. S.		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
APPD P. V. S.		ALL THREADS CONFORM TO	DRAWING NUMBER Cb 1-8	
DATE	26-7-86			

1-2 82



122
1-1224

2-3K-015

Install part 2-18 using primer AK-070.

Install part 2-7 using glue БФ-2.

Coat the place of log punch with thick primer AK-070 pigmented with green colour Ty6-09-4278-76.

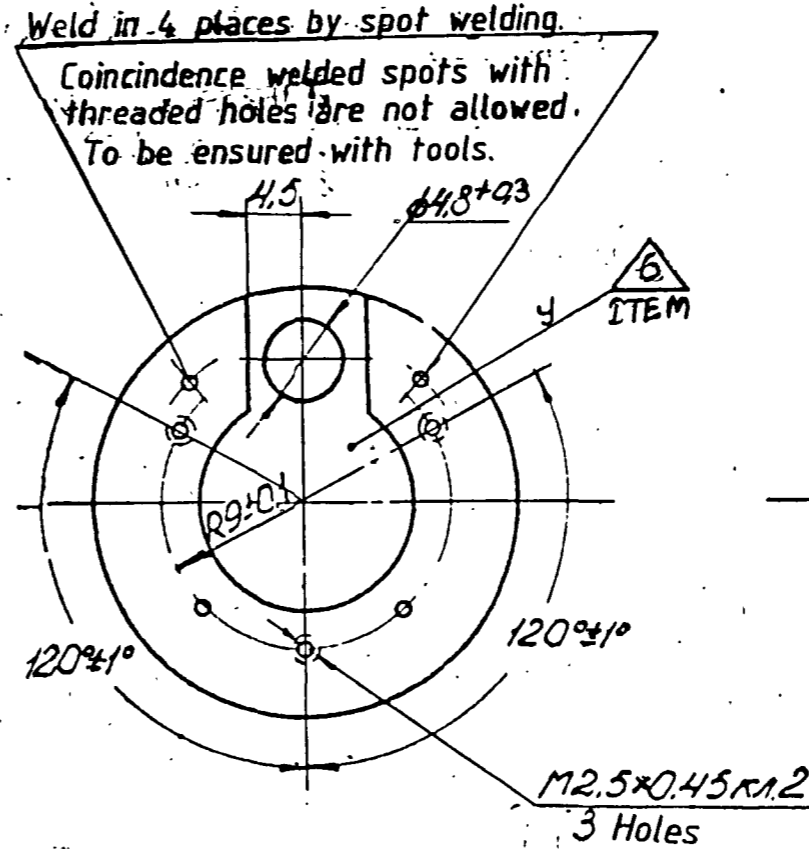
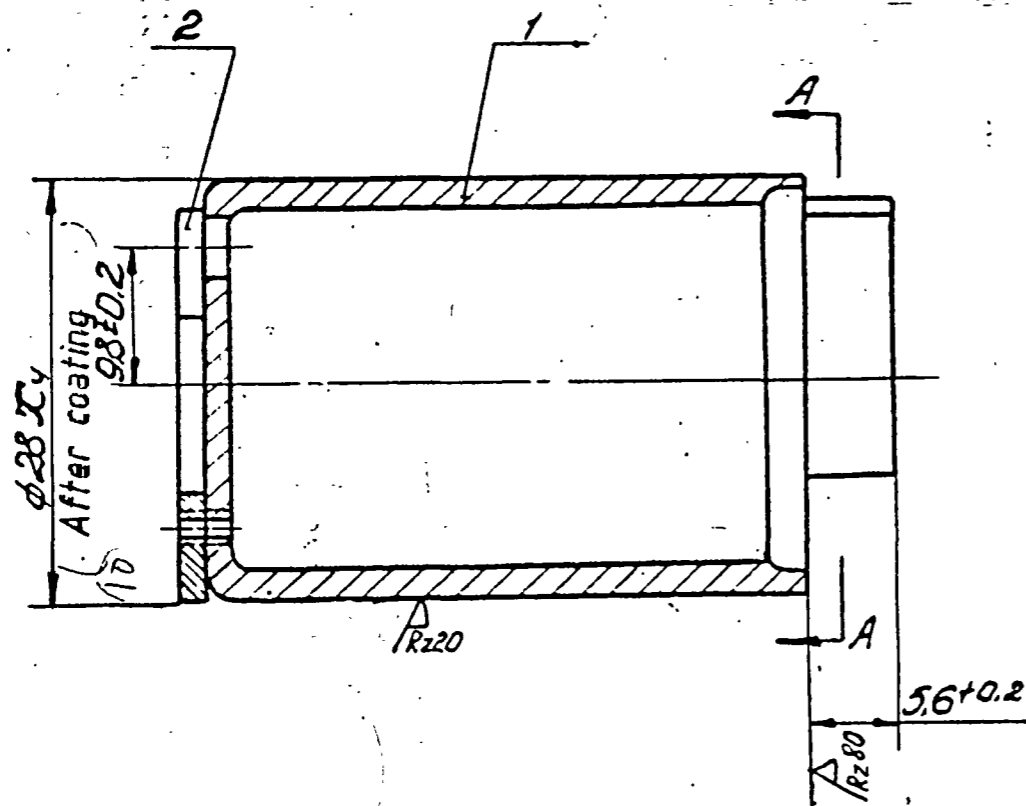
Underlying dimensions are for tool.

Coating on the surface $\phi 26.3^{+0.045}$ of the body 2-8 (Assy 2-2) may be partially removed.

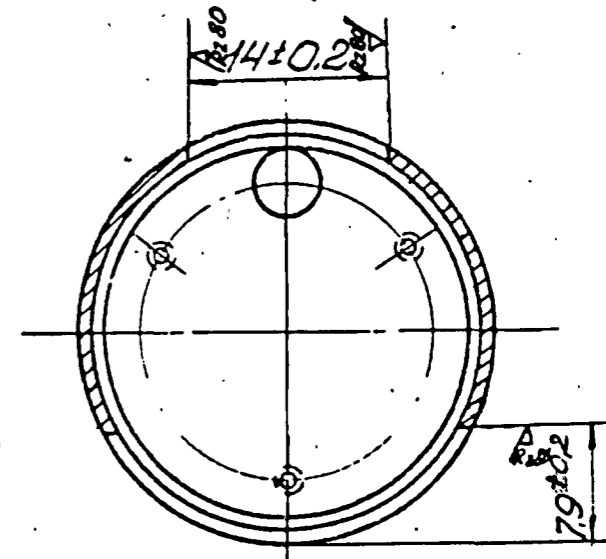
Sl. No.	Designation	Description	Qty	Remarks
12		Solder noccy61-0.5 GOST 21931-76		
11	2 - 18	Screw	3	
10		Primer AK-070 OCT6-10-401-76		
9		Glue БФ-2 GOST 12172-74		
7				
6	CB 2-4	Block	1	
5	2-7	Gasket	1	
3	2-5	Stop	1	
2	CB 2-3	Coil	1	
1	CB 2-2	Body electromagnet	1	

3157	УНБКС	ЖК-48
Взамен	УНБ.К.П.О.Д.	
УНБ.К.П.О.Д.		
Дата	Подп.	
14/97	(подп.)	

EST. MASS		TO BE STAMPED OR MARKED WHERE INDICATED THUS #	
0.155 Kg		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:-
DRN	SCALE - 2 : 1		Cb 2
CHD	DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	TITLE:- ELECTROMAGNET	
APD	ALL THREADS CONFORM TO IS 42-80	D S CAT NUMBER	DRAWING NUMBER
			Cb 2-1



Section Along A-A



- 1) Fill the gap between the body of part 2-8 and clamp of part 2-9 along the perimeter of the clamp with adhesive, БФ-2.
- 2) Tolerances on free dimensions are as per 722AT.
- 3) Threading die of the thread and chamfering upto outer diameter is allowed.
- 4) Looseness of dimensions $\phi 28 \times 4$ to $\phi 28 \times 5$ is allowed over a length of 24 mm from the base of the part.
- 5) Cadmium coating, 6 microns thickness, chromated.

6) Mark- as required by the standard 6175 C 57-3-U A.

Coating : Cadmium coating, 6 micron thickness, oxidized parkerized.

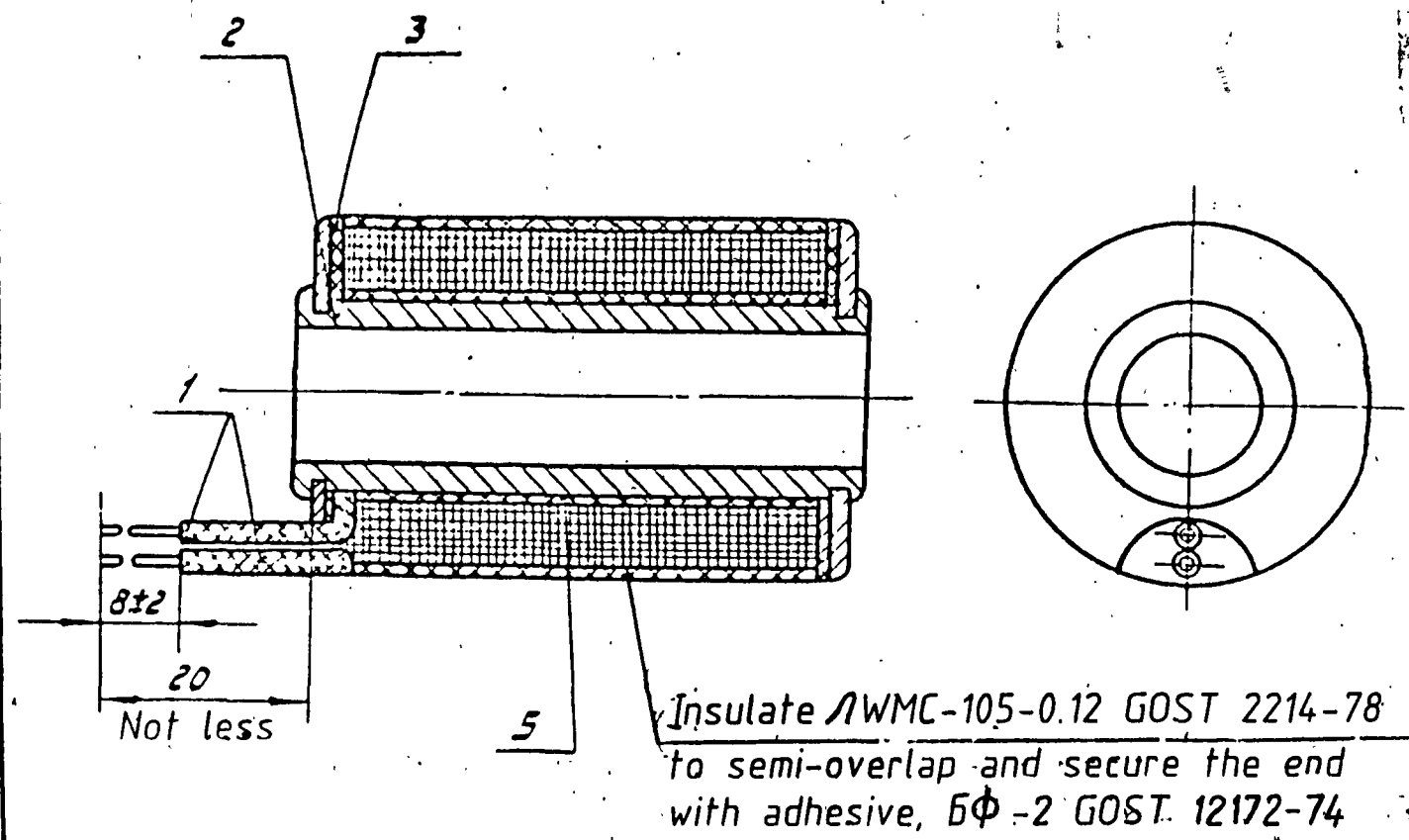
R.NO.	DESIGNATION	DESCRIPTION	Q.TY.	REMARKS.
1	2-8	Body (case)	1	
2	2-9	Clamp	1	
3		Glue БФ-2 GOST 12172-74		

2-3K-015

УМБСХ
 31-48
 ВЗАМЕН
 УМБ.Н.НОДЛ.
 УМБ.Н.НОДЛ.
 ЗАТ.Н.НОДЛ.

EST. MASS		TO BE STAMPED OR MARKED WHERE INDICATED THUS #	
0,0454 Kg		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:- Cb 2-1
DRN G. Jamb	SCALE - 2 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD B. L. Rao	DIMENSIONS IN mm.	TITLE:- BODY ELECTROMAGNET	
TCD G. Jamb	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	D S CAT NUMBER	DRAWING NUMBER
APD G. Jamb	ALL THREADS CONFORM TO IS: 4218 Pt IV		Cb 2-2
DATE 28-7-86			

8-233



1. Series winding. Non-series winding along the edges is allowed. External appearance of winding is as per the standard. Resistance of winding $R=7.3^{+0.2}_{-0.5}$ ohms at $+20^{\circ}\text{C}$.
 Number of turns of wire is 900 ± 20 .
 Fasten the end of winding using a silk filament (item 7).
 Secure gasket, part 2-13 and washers, part 2-10 using adhesive БФ-2.
 Diameter of the coil along the binding should not project beyond $\phi 25$ (check in mock-up body).
 If necessary single soldering of winding may be used for finishing winding of new spool of wire.
 In the place of soldering strip the wire over a length of 8-12mm twist it and solder with nocy61-0.5 GOST 21931-76. Insulate the place of soldering, with varnished glass cloth ЛСК-155 (180-0.12 (15±2x30±2) GOST 10156-78

2-3K-015

Sl No	Designation	Description	Qty	Remarks
7		Silk thread N13 GOST 22665-77		
6		Wire ПЭЛ10.4 GOST 2773-78	70g	
5	2-13	Gasket	1	
3	2-10	Insulating washer	4	
2	сб 2-5	Coil Form	1	
1	2-11	Insulation	2	

УМДК
3K-48

ВЗРАТ УМБ.
УМДК

УМБ КНОДН
253250

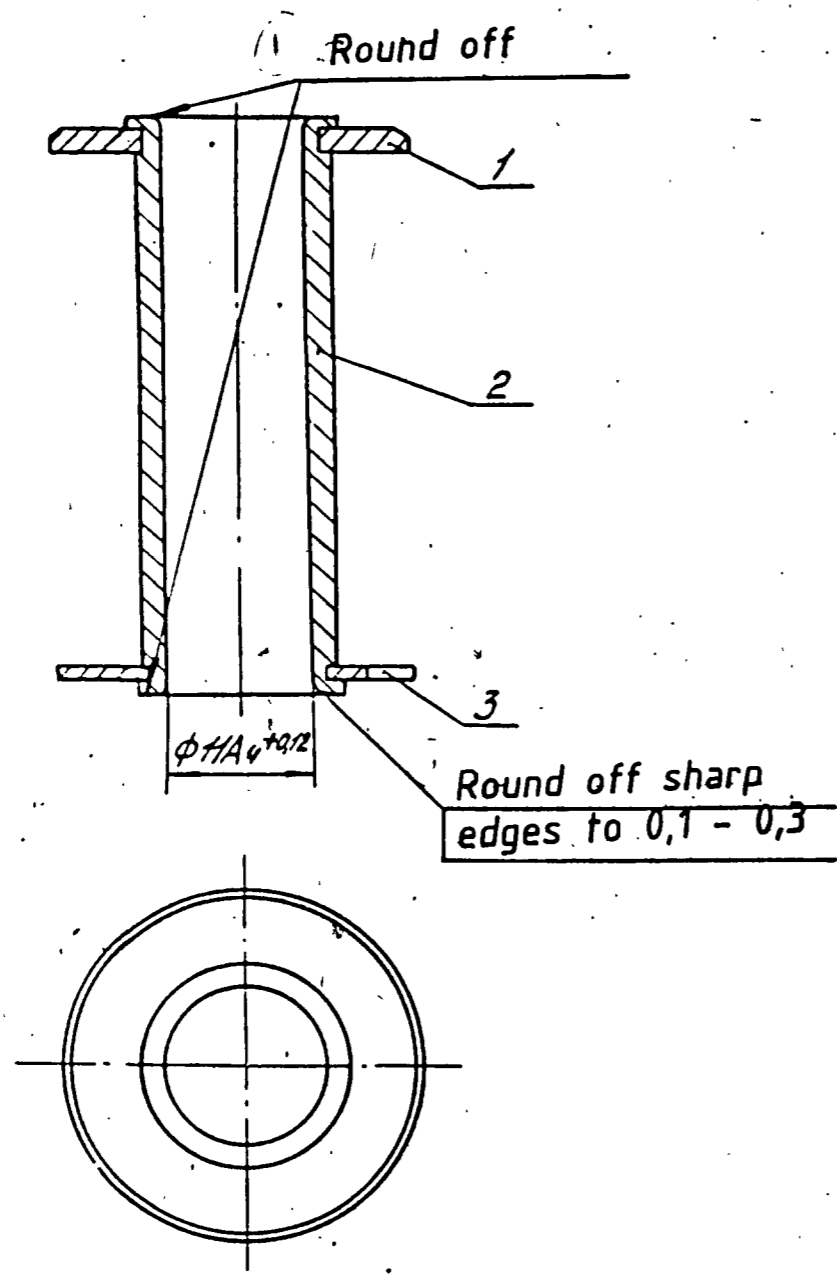
СЕРТ КНОДН

4/17 КНОДН

125 / 125
I.1224

EST. MASS 0.079 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:-	USED ON:- Cb, 2-1
DRN [Signature]	SCALE - 2:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD [Signature]	DIMENSIONS IN mm.	TITLE:- COIL	
TCD [Signature]	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
APP [Signature]	ALL THREADS CONFORM	DRAWING NUMBER Cb 2-3	
DATE 28-7-86	TO		

С-2 87



Circumferential play of washer 2-6 not exceeding 0,5mm is allowed.
 While rounding off coating may be partially removed.
 Partial absence of coating in holes $\phi 11A_4$ is allowed.
 At a distance not exceeding 26mm from the face, from the side of washer 2-15, machine finishing over $\phi 11A_4$ is Rz. 20/
 External appearance is as per the standard.

2-3K-015

NO.	Designatin.	Description.	Qty	Remarks
3	2-15	Special washer.	1	
2	2-14	Bush.	1	
1	2-6.	Washer.	1	

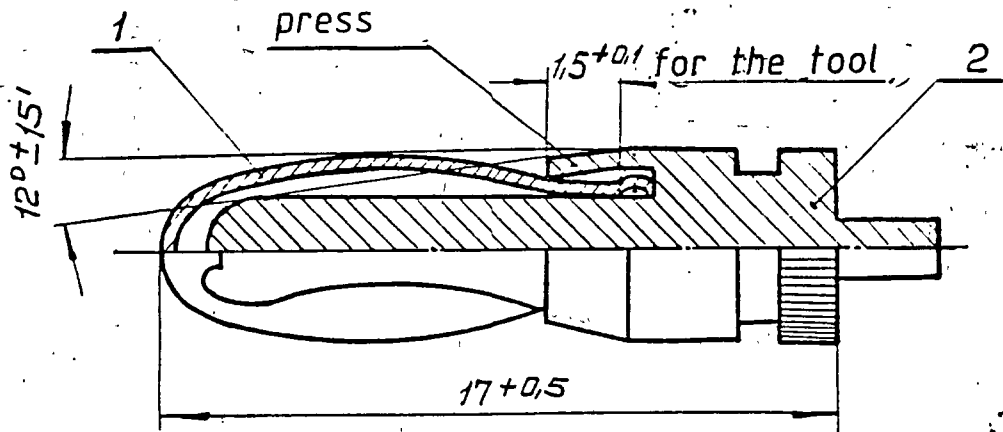
ИНДЕКС	ЗК-48
ВЗАМЕН ИЛИБ. НЕПОНЯТ.	
ИЛИБ. НЕПОНЯТ.	
253.252	
Дата Подп.	
24.12	
712	подп.

128
I-1224

EST. MASS		TO BE STAMPED OR MARKED WHERE INDICATED THUS *	
10.5 g		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:-
DRN. 9022222	SCALE 2:1		Cb 2-3
CHD. 20000	DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCO. f. 20000	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	TITLE:- COIL FORM	
APPO. 20000	ALL THREADS CONFORM	D. SEXT NUMBER	DRAWING NUMBER
DATE 20-7-86	TO		Cb 2-5

CB 2-6

12-9
E-1224



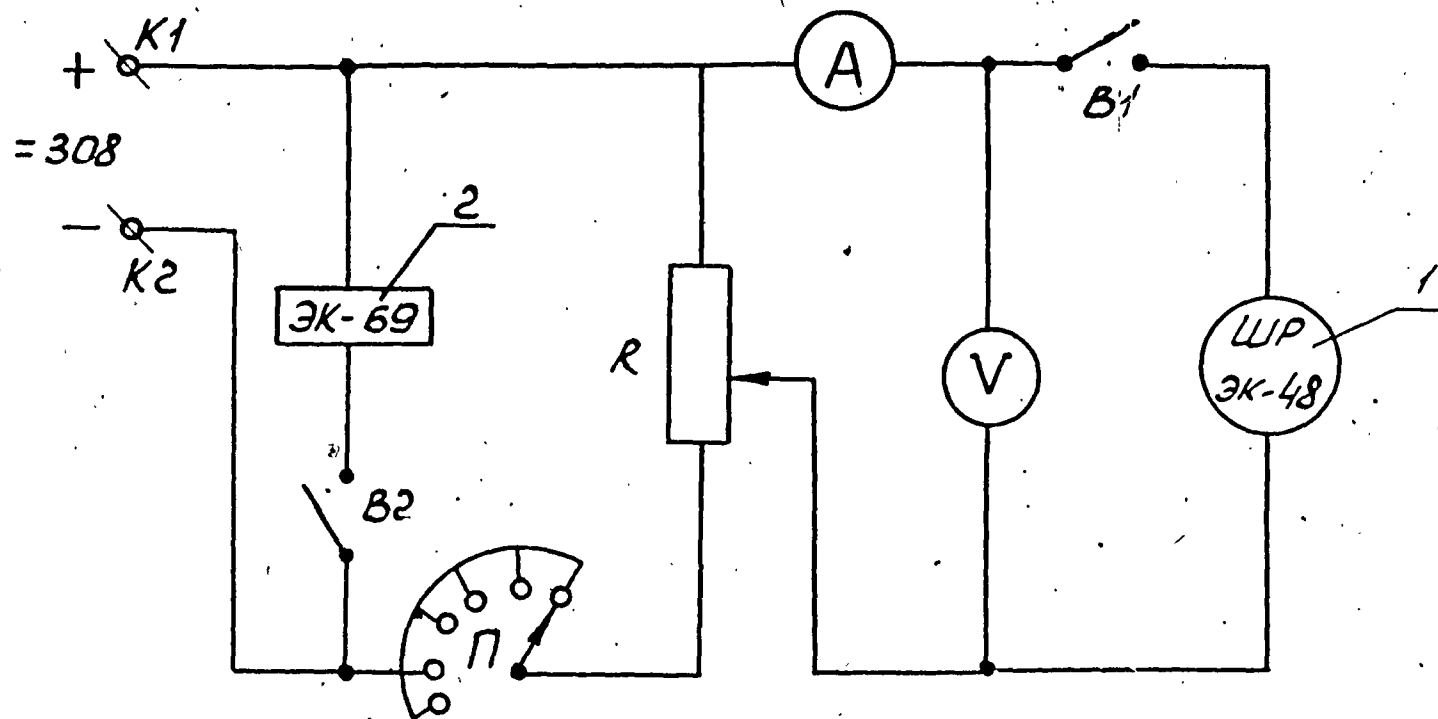
Angle $12^{\circ} \pm 15'$ is given for the tool.

2-3K-015

2	2-17	Bar of the Plug	1	
1	2-16	Spring of the Plug	1	
Sl. No.	Designation	Description	Qty	Remarks

2-48

EST. MASS		TO BE STAMPED ON PARTS WHEN INDICATED THIS LETTERS	
0.0017 Kg			
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:-
26-7-86	SCALE - 5 : 1		Cb 2-4
DIMENSIONS IN mm.		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED		TITLE:-	
ALL THREADS CONFORM TO		PLUG	
D S CAT NUMBER		DRAWING NUMBER	
		Cb 2-6	



B₁, B₂ :- Circuit breaker of type B-45.

R :- Reostat of type PCΠ-12.50hms. 5a.

A :- (Amm) meter of type.

V :- Voltmeter of type.

Π :- Breaker.

K₁, K₂ :- Terminal.

1 :- Plug for connection of the article.

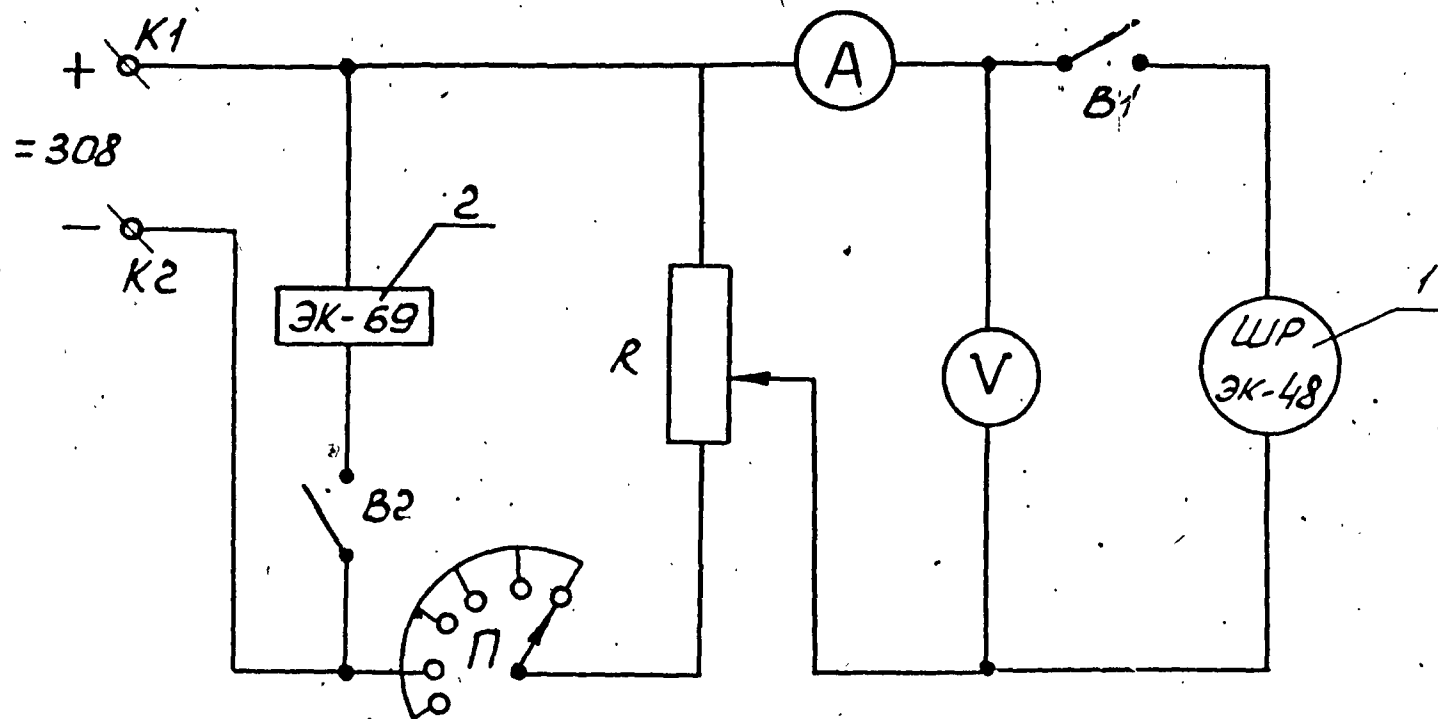
2 :- Electric pneumatic valve.

Уч.б. N241633 31/8 69г. (подпись)

2-3K-015

65

		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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL:-	USED ON:-
DRN				
CHD		DIMENSIONS IN mm.	CONTROLLER OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE:-	
APPD		ALL THREADS CONFORM TO	CIRCUIT DIAGRAM FOR TESTING 3K-48	
DATE			D S CAT NUMBER	DRAWING NUMBER
29.07.86				DIAGRAM No 1.



B₁, B₂ :- Circuit breaker of type B-45.

R :- Reostat of type PCП-12.50hms. 5a.

A :- (Amm) meter of type.

V :- Voltmeter of type.

П :- Breaker.

K₁, K₂ :- Terminal.

1 :- Plug for connection of the article.

2 :- Electric pneumatic valve.

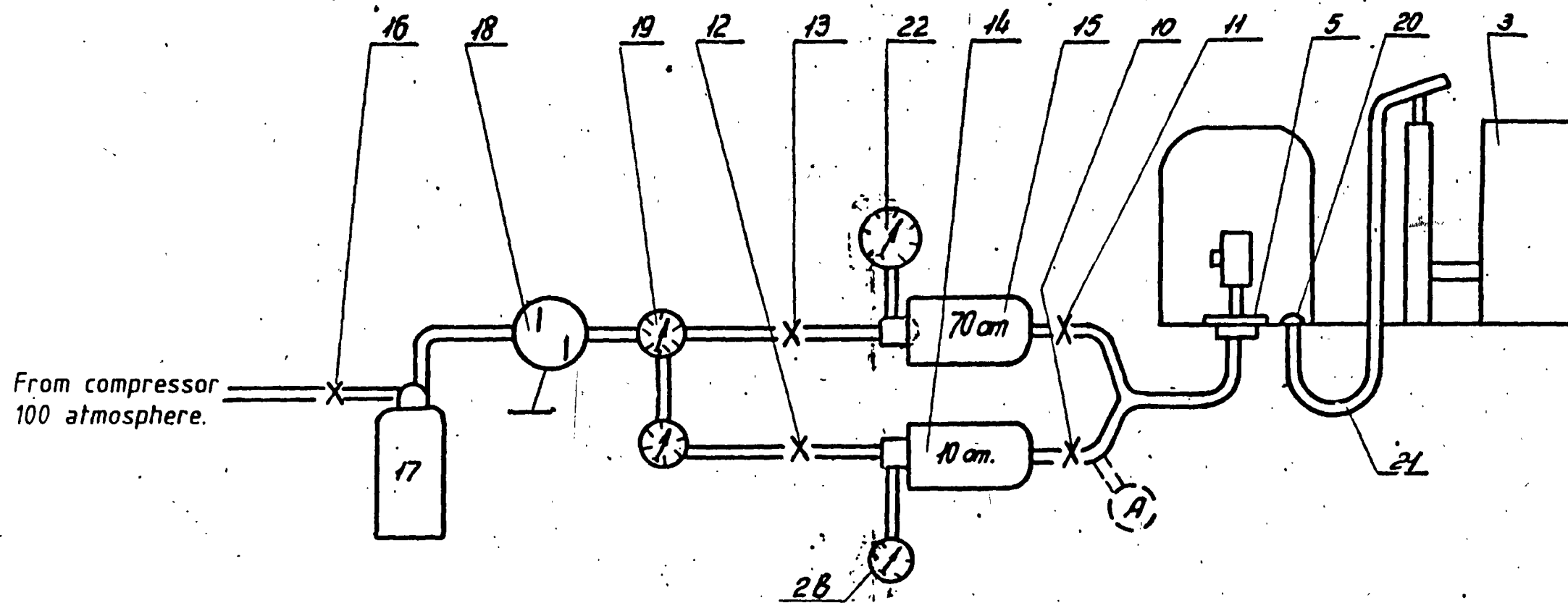
Уч. № 241633 31/8 69г. (подпись)

2-3K-015

65

		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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL:-	USED ON:-
DRN				
CHP		DIMENSIONS IN mm.	CONTROLLER OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE:-	
APPD		ALL THREADS CONFORM TO	CIRCUIT DIAGRAM FOR TESTING 3K-48	
DATE			D S CAT NUMBER	DRAWING NUMBER
29.07.86				DIAGRAM No 1.

Схема № 3



It is necessary to install cylinder having a capacity of 2 liters with manometer rating upto 15 atmospheres at "A" position, for checking the air release in off position from 0 to 10 atmospheres.

83
I-1224
Schematic drawing No. 3. 2 - ЭК-015

ИНДЕКС
ЭК-48
Взам. № подлин.
№ подлин.
Подпись

		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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL:-	USED ON:-
DRN <i>[Signature]</i>	SCALE -	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD <i>[Signature]</i>	DIMENSIONS IN mm.	TITLE:- PNEUMATIC CIRCUIT OF THE STAND FOR TESTING ЭК - 48	
TCO <i>[Signature]</i>	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
APRO <i>[Signature]</i>	ALL THREADS CONFORM TO	DRAWING NUMBER DIAGRAM No 3 (086 534)	
DATE 28-07-86			

FCR/M	DESIGNATION	DESCRIPTION	DESIGNATION	QT	TOT	REMARKS
		Documents				
11	TY	Technical specifications for the manufacture and acceptance of electric pneumatic valves 3K-48.				
22	CD	Electric pneumatic valve 3K-48 Assembly Drawing				
12	CD	Electric pneumatic valve 3K-48 Out-line drawing				
11	CD 4F	Socket out-line drawing				
12	Diagram No 1.	Circuit diagram for testing 3K-48.				

ELECTRIC PNEUMATIC VALVE

ITEM LIST FOR

FOR: 1A	DESIGNATION	DESCRIPTION	DESIGNATION	QTY	TOTAL No	REMARKS
		<u>Units</u>				
12	CB 1	Pneumatic valve			1	
11	CB 1-2	Connection	CB 1	1	1	
22	7A 8:652.018	Connection	CB 1	1	1	Alternate I
11	CB 1-3	Inlet valve	CB 1	1	1	Alternate II
11	CB 1-4	Piston	CB 1	1	1	
11	CB 1-5	Servo valve	CB 1	1	1	
11	CB 1-6	Discharge Valve	CB 1	1	1	
11	CB 1-7	Servo valve	CB 1-5	1	1	
11	CB 1-8	Servo valve	CB 1-7	1	1	
12	CB 2	Electric system	CB	1	1	No. P. 2
12	CB 2-1	Electro magnet	CB 2	1	1	
12	CB 2-2	Body electromagnet	CB 2-1	1	1	
12	CB 2-3	Coil	CB 2-1	1	1	

DATE		NATURE OF AMENDMENTS	
BY		CONTROLLER (OFFICE OF INSPECTION (HEAVY VEHICLES) AVAD)	
TITLE		ELECTRIC PNEUMATIC VALVE	
ITEM NUMBER		ITEM LIST FOR	
		3K-48-015-Ch	

FC:981	DESIGNATION	DESCRIPTION	DESIGNATION	QT	TOT	REMARKS
		Parts				
11	7A8.300.017	Pin	Cb		1	
11	2	Magnet spring	Cb		1	
11	3	Lever	Cb		1	
11	4	Screw	Cb		2	
11	1-1	Valve spring	Cb 1	1	1	
11	1-2	Distance sleeve	Cb 1	1	1	
11	1-3	Shim	Cb 1	1to3.	1to3.	
11	1-4	Shim	Cb 1	1to3.	1to3.	
22	1-7	Connection	Cb 1-2	1	1	version I
11	1-8	Insert	Cb 1-2	1	1	version I
22	1-9	Inlet valve	Cb 1-3	1	1	

FCH/MAT

DESIGNATION	DESCRIPTION	DESIGNATION	QT	TOT	REMARKS
11 1-10	Seal of the Valve	CB 1-3	1	1	
11 1-11	Bush	CB 1-3	1	1	
11 1-14	Sealing Ring	CB 1-4	1	1	
12 1-15	Special bush	CB 1-4	1	1	
11 1-16	Ring	CB 1-5	1	1	
11 1-17	Bush	CB 1-5	1	1	
11 1-18	Packing of servo-valve.	CB 1-5	1	1	
11 1-19	Armature	CB 1-5	1	1	
11 1-20	Bush	CB 1-5	1	1	
11 1-21	Valve	CB 1-6	1	1	
11 1-22	Seal of the Valve	CB 1-6	1	1	
11 1-23	Sleeve	CB 1-7	1	1	
11 1-24	Bush	CB 1-7	1	1	A4

ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS
DAN			USED ON		
END			CONTROLLERATE OF INSPECTION HEAVY VEHICLES (VAD)		
TED			TITLE ELECTRIC PNEUMATIC VALVE		
APPD			D S CAT NUMBER	ITEM LIST FOR	
				3K-48-015-C n	

FCRM	DESIGNATION	DESCRIPTION	DESIGNATION	QT	TOT	REMARKS
12	1-25	Servo valve	CB 1-8	1	1	
11	1-26	Needle	CB 1-8	1	1	
22	74, 7.772.012	Body	CB. 2	1	1	
11	2-4	Plug	CB. 2	1	1	
11	2-5	Stop	CB 2-1	1	1	
11	2-6	Washer	CB 2-5	1	1	
11	2-7	Gasket	CB 2-1	1	1	
11	2-8	Body	CB 2-2	1	1	
11	2-9	Clamp	CB 2-2	1	1	
11	2-10	Insulating washer	CB 2-3	4	4	
11	2-11	Insulation	CB 2-3	2	2	
11	2-13	Gasket	CB 2-3	1	1	
11	2-14	Bush	CB 2-5	1	1	
11	2-15	Special washer	CB 2-5	1	1	

ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS
DRN			USED ON		
CHD			CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
TCD			TITLE ELECTRIC PNEUMATIC VALVE		
APPD			D S CAT NUMBER		ITEM LIST FOR
DATE 30.7.86	SHT No. 9 OFF 11		3K-48-015-Cn		

21

SI No.	FORMAT	DESIGNATION.	DESCRIPTION.	Incorporated in.		Total Qty	Remarks
				DESIGNATION	Qty		
	12	2-16	Spring of the plug	cb-2-6	1	2	
	11	2-17	Bar of the plug	cb 2-6	1	2	
	11	2-18	Screw	cb 2-1	3	3	
	12	4-1	Body	910.920	1	1	
	11	4-3	Nut	910.920	1	1	
				910.920	1	1	2
	11	4-4	Packing	910.920	1	1	
	11	4-5	Gasket	910 920	1	1	
				910.920	1	1	
						2	
	11	4-6	Ring	910.920	1	1	
	11	4-7	Nut	910.920	1	1	
	11	910.921	Insulator	910.920	1	1	
	11	910.922	Insulator	910.920	1	1	
	11	910.923	Socket	910.920	2	2	
	22	7A 7.772.009	Valve body	cd 1	1	1	
	12	7A 8.126.030	Holder	cd		1	
	12	7A 8.632.028	Plug	cd	2	2	

ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS
DRN		<i>g. jankar</i>	USED ON		
CHD		<i>g. jankar</i>	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
TCD		<i>g. jankar</i>	TITLE ELECTRIC PNEUMATIC VALVE		
APPD		<i>g. jankar</i>	D S CAT NUMBER		ITEM LIST FOR
DATE 30.7.86		SHT No, 10 OFF 11		3K-48-015-Cn	

