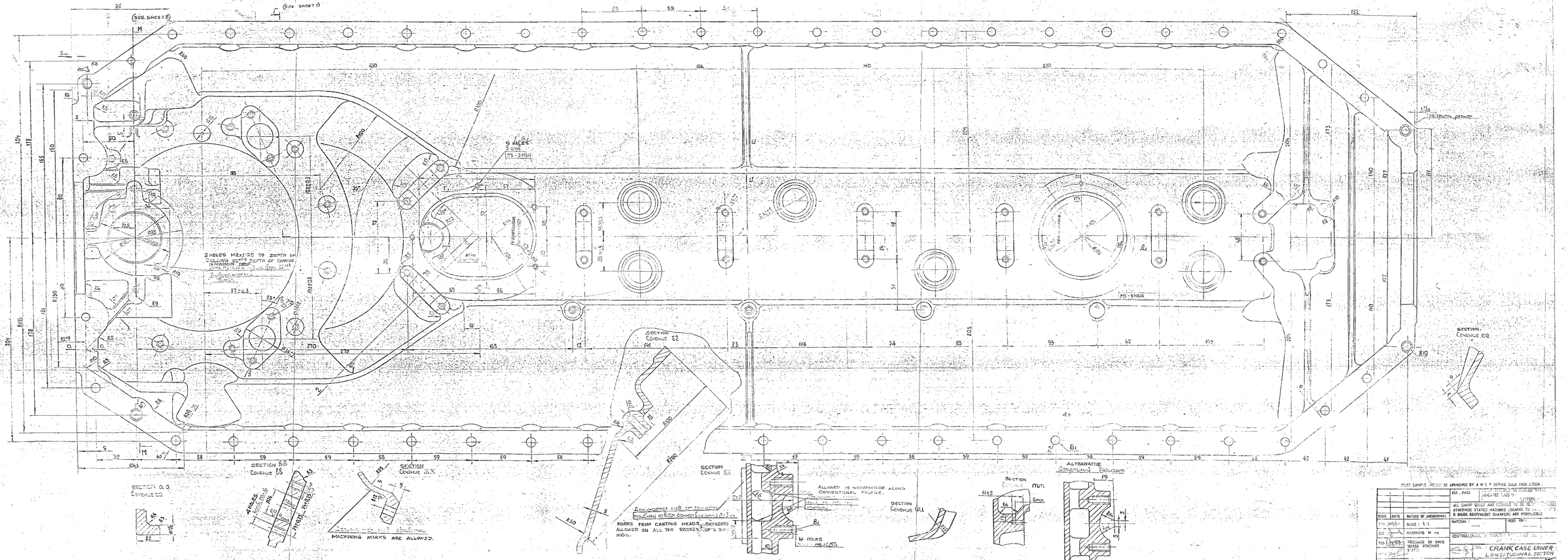
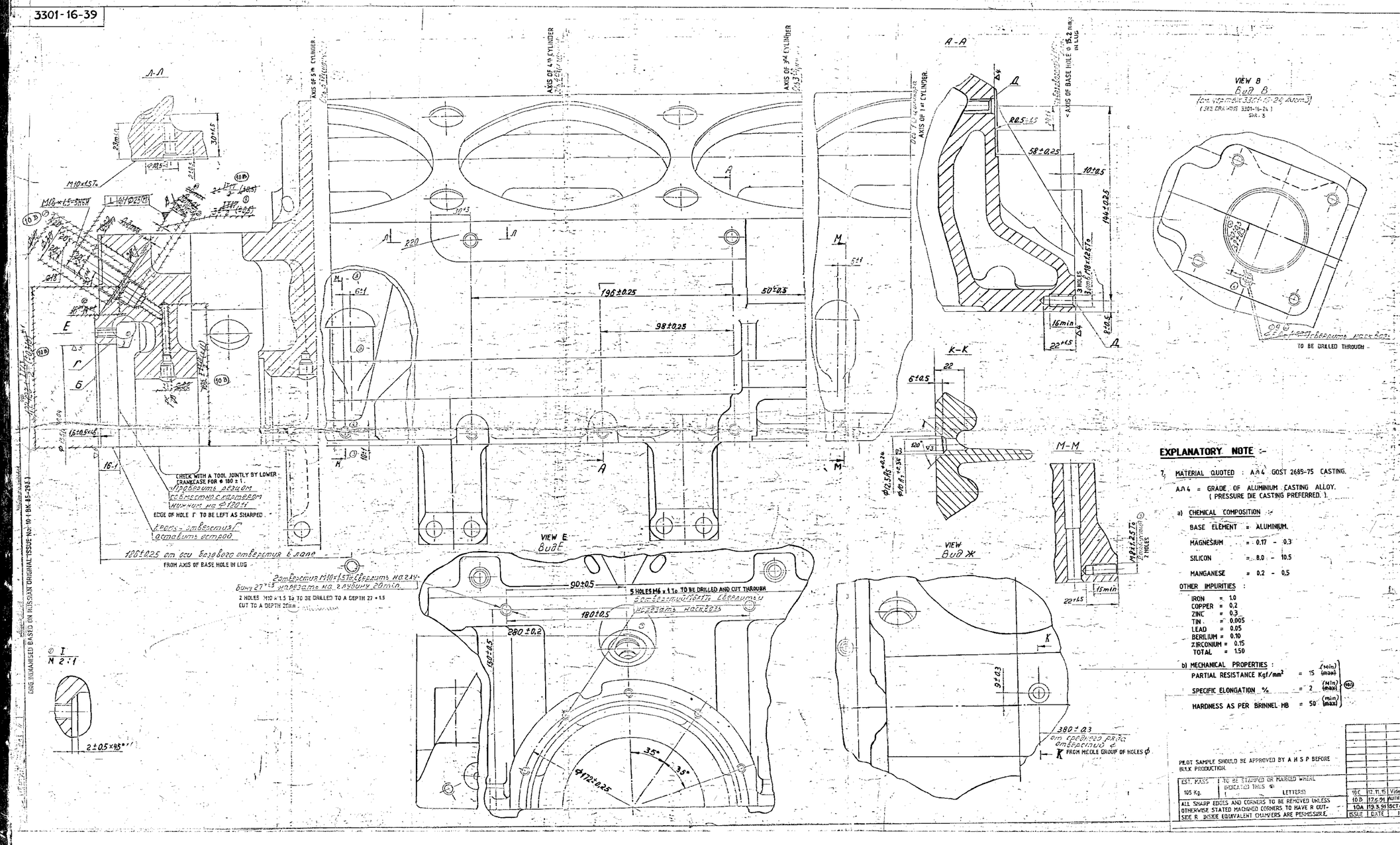
402-06-3 SH2


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

3301-16-39



INTRODUCE TABLE

DESIGNATION	UPPER CRANK CASE
3301-16-39	3301-16-24
3301-16-39-01	3301-16-24-01

1. Непараллельность поверхностей Д на длине 25мм не более 0,05мм.
2. Поверхности Г и Б обрабатывать совместно с картером нижним.
3. Остальные виды, размеры, обработка и технические требования по чертежу 3301-16-24.
4. Одно нижнее отверстие M8x1.25T (см. лист 2 разрез Н-Н) допускается не обрабатывать.
5. Отверстие M8x1.25T (см. лист 1, сечение М-М) допускается не обрабатывать.
6. * Размер обеспечивается инструментом.

TECHNICAL REQUIREMENTS

1. NONPARALLELISM OF SURFACES Д OVER A LENGTH OF 25 MM SHOULD BE 0.05 mm MAXIMUM.
2. SURFACES Г AND Б TO BE MACHINED JOINTLY WITH CRANKCASE LOWER.
3. OTHER VIEWS, DIMENSIONS, MACHINING AND TECHNICAL REQUIREMENTS AS PER DRAWINGS 3301-16-24, 3301-16-24-01.
4. ONE LOWER HOLE M8 x 1.25 To MAY BE MACHINED (SEE SHEET 2 CROSS SECTION H-H)
5. HOLE M8 x 1.25 To (SEE SHEET 1, SECTION M-M) MAY NOT BE MACHINED.
6. * DIMENSION TO BE ENSURED WITH A TOOL.

EXPLANATORY NOTE :-

7. MATERIAL QUOTED : AЛ4 GOST 2685-75 CASTING.

AЛ4 = GRADE OF ALUMINUM CASTING ALLOY. (PRESSURE DIE CASTING PREFERRED.)

a) CHEMICAL COMPOSITION :

BASE ELEMENT	=	ALUMINUM.
MAGNESIUM	=	0.17 - 0.3
SILICON	=	8.0 - 10.5
MANGANESE	=	0.2 - 0.5

OTHER IMPURITIES :

IRON	=	1.0
COPPER	=	0.2
ZINC	=	0.3
TIN	=	0.005
LEAD	=	0.05
BERILIUM	=	0.10
ZIRCONIUM	=	0.15
TOTAL	=	1.50

b) MECHANICAL PROPERTIES :

PARTIAL RESISTANCE Kgf/mm² = 15 (min/max)

SPECIFIC ELONGATION % = 2 (min/max)

HARDNESS AS PER BRINNEL HB = 50 (min/max)

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

EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS ⊕ LETTERS
105 Kg.	

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

ISSUE	DATE	NATURE OF AMENDMENTS	BY
10C	12.11.15	Vide Note No. 196-09	
10B	17.6.91	AUTHY. SFA EL-NO. 07326 ENG (FOR) 309-A	
10A	19.3.91	BCT CORRECTIONS AUTHY. L. NO. 07326	

DRN	
CHD	АЛ4 GOST 2685-75 CASTING
APPD	
DATE	30 - 09 - 88
SCALE	1:1
DIMENSIONS IN mm	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	ALL THREADS CONFORM TO

MATERIAL — CB 3301-16-39 (10C)

CONTROLLER ATE OF QUALITY ASSURANCE HEAVY VEH AVADI

TITLE — UPPER CRANKCASE

D S CAT NO.

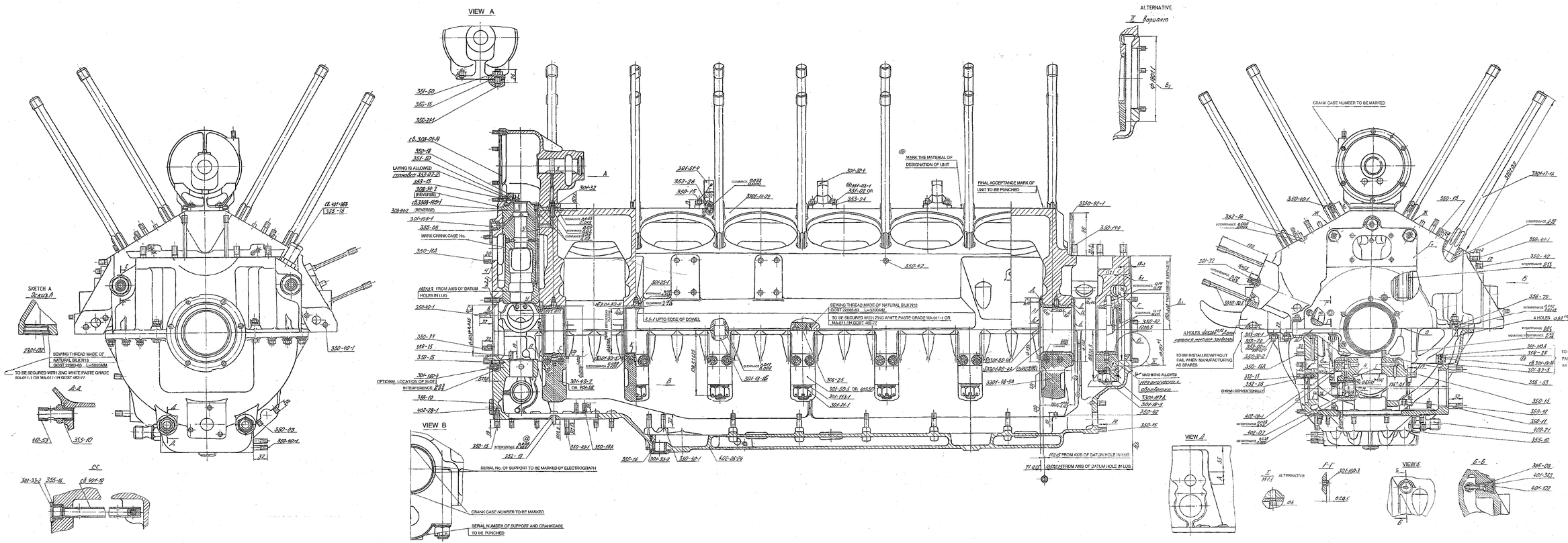
DRAWING NO. 3301-16-39

DWG NUMBERED BASED ON RUSSIAN ORIGINAL ISSUE No. 10-1 BK 85-2841

DRAWING NUMBER
Cb.3301-15-17

SHEET NO. 1 OF 2

DRG. INDIANIZED BASED ON RUSSIAN ORIGINAL SERIE: -9 AND
DRG REPLACES: ISSUE 8 VIDE 18th ISUE POINT No. 5



TILOT SAMPLE SHOULD BE APPROVED BY A.I.S.P BEFORE BULK PRODUCTION.

RST, WT, Rkg	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MACHINED CORNERS TO HAVE 3 - OCT-RDM. & FINISH EQUIVALENT GRAPHICS ARE PERMISSIBLE.	

MIN	
CHD	
APPD	
DATE	14-05-2012
SCALE: 1:2	
DIMENSION IN mm	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IN: IS:2102-69	
ALL THREADS TO CONFORM TO	

ISSUE	DATE	NATURE OF AMENDMENTS

MATERIAL : —

USED ON : Cb.3301-20-17

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI

TITLE:- CRANK CASE

N.S. CAT NUMBER

DRAWING NUMBER: SH 1 OF 2
Cb.3301-15-17

F.160

SIZE A1x3