

1. Inspection group III, TT-11.
2. To be carburized. Depth of case-hardened layer on surfaces A and B should be 0.8 mm; min, on the rest of the surfaces  $\leq 1.6$  mm. Hardness HRC  $\geq 56$ ; on surface B  $\geq$  HRC 40. HRC  $\geq 57$  HRC  $\geq 41$
3. Dimensions with unspecified deviations should be obtained as per accuracy class 7 OST 1010.
4. Run-out of surface 'A' relative to surface 'B' should not exceed 0.1 mm. at dia. 100 mm.
5. Run-out of face B relative to surface 'B' should not exceed 0.05 mm. at dia. 55 mm.
6. Face 'A' is to be checked with tool makers straight-edge., clearance of not more than 0.2 mm is allowed at dia. 10mm
7. Sharp edges are not allowed.
8. Non-straightness of surface A should not exceed 0.007 mm. To be checked on working strip 15 mm wide in 4 places along the circumference.
9. Coating:- Chemical, oxidizing, except surface A.
10. To be marked by electric-etching.
11. Surface roughness 0.63 is allowed on section.

(A6)

\*\* CB 20-15-664-1

		EST. MASS	TO BE STAMPED OR MARKED WHERE
		0.520 Kg	INDICATED THUS # LETTERS)
A 23.11.87 AUTHY BK 62-394		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 20 x GOST 4543-71	USED ON:- ** CB 315-644-2
DRN	SCALE - 1:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD	DIMENSIONS IN mm.	TITLE:- STOP DISC	
TCD	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	DRAWING NUMBER 315-613-3	
APPO	ALL THREADS CONFORM TO	D S CAT NUMBER	
DATE 09-5-84			



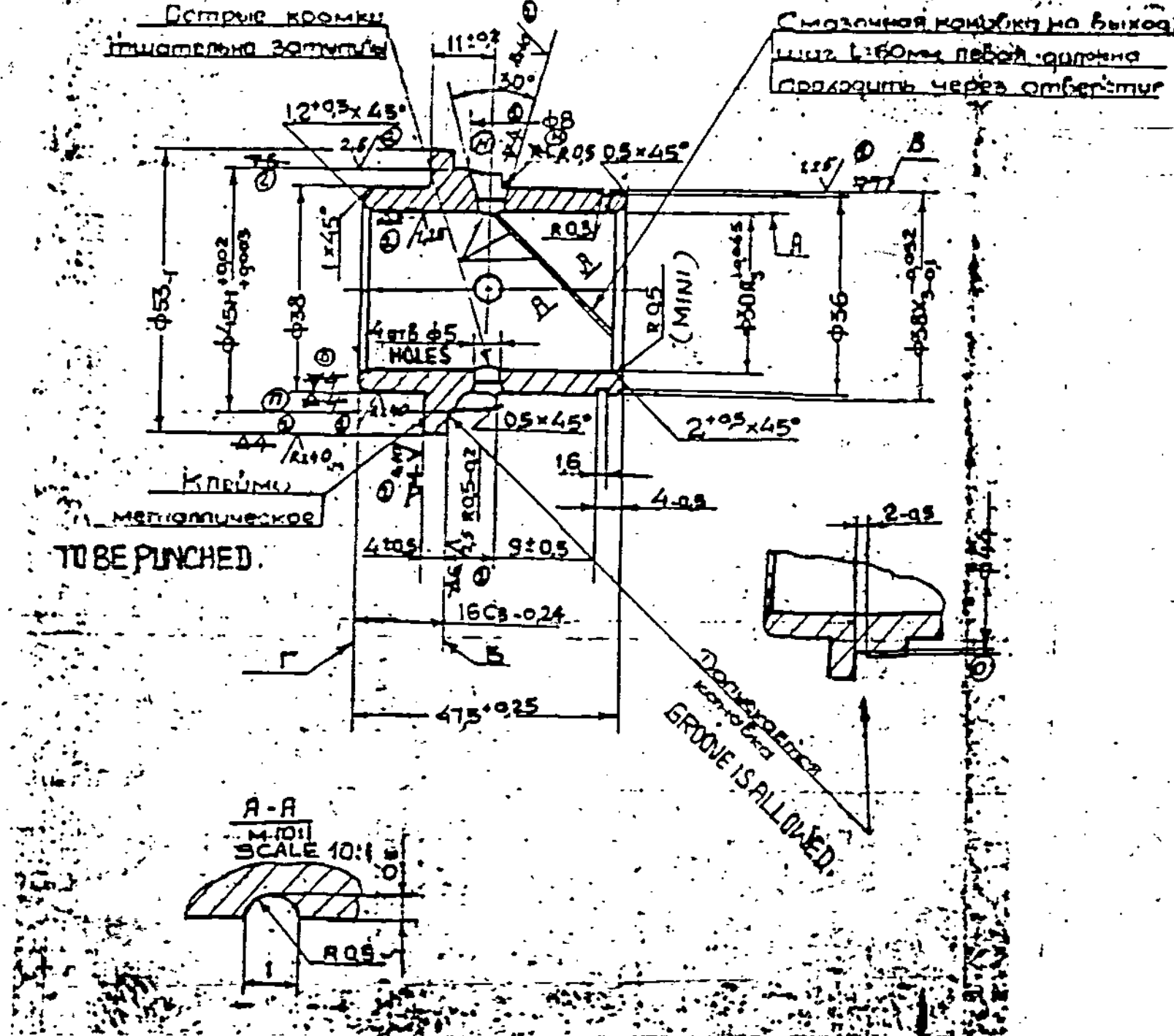




DRAWING NUMBER  
315-616-4

SHARP EDGES SHOULD BE  
THROUGHLY BLUNTED.

THROUGH LUBRICATING GROOVE L.H. PITCH  
t = 60MM, PASSING THROUGH THE HOLE.



**EXPLANATORY NOTE:**

Material quoted: Bronze bar БРАЖ 9.4 GOST 1628-78.  
Alternate material Quoted: Bronze grade БРОС 10-10, ТУ 23-108-49-75.  
 БРАЖ 9.4 : grade of bronze = БРА ЗН.9.4 AS per standard SEV 377-76  
 Extruded round bar grade = СУА19 Fe4.  
Chemical composition: (as per gost 18175-78)  
 Aluminium = 8.0 - 10.0  
 Iron = 2.0 - 4.0  
 Copper = rest  
parts of impurities (by weight): maximum.  
 Tin = 0.1 ; Lead = 0.01 ; Manganese = 0.5 ; Phosphorus = 0.01 ;  
 Silicon = 0.1 ; Zinc = 1.0 ; Total = 1.7  
 By mutual agreement between manufactures and customer content of impurities of arsenic and antimony may be standardized. Nickel up to 0.5% (part by weight) without considering it in total impurities.  
Properties: high mechanical properties excellent anti-friction properties; corrosion-resistant.  
Mechanical properties: (as per gost 1628-78)  
 ultimate tensile strength  $kgf/mm^2$  = 55 (min)  
 Relative elongation % = 15 (min)  
 Brinell hardness HB = 110-180.

1. Dimensions with unspecified tolerances should be obtained as per accuracy class 7 GOST 1010.
2. run-out of surface B relative to the axis of surface A should not exceed 0.03 mm at dia 50 mm.
3. run-out of face B relative to the axis of surface A- should not exceed 0.05 mm.
4. non squareness of face Г with the axis of surface A should not exceed 0.1 mm at dia 35 mm.
5. Sharp edges should be blunted.
6. Alternate material: Bronze grade БРОС 10-10, ТУ 23-108-49-75.

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

EST. WT. 0.210 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.	

DRN	DRN	MATERIAL :- BRONZE BAR	USED ON :-
CHD	CHD	БРАЖ 9.4 GOST 1628-78	СБ 315-616-4-2
TOD	TOD	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
APPD	APPD	A V A D I	
DATE	DATE	TITLE	
SCALE :- 1:1	SCALE :- 1:1	BUSH	
DIMENSIONS IN MM		D S CAT NUMBER	
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69		DRAWING NUMBER	
ALL THREADS TO CONFORM TO		315-616-4	
ISSUE	DATE	NATURE OF AMENDMENTS	



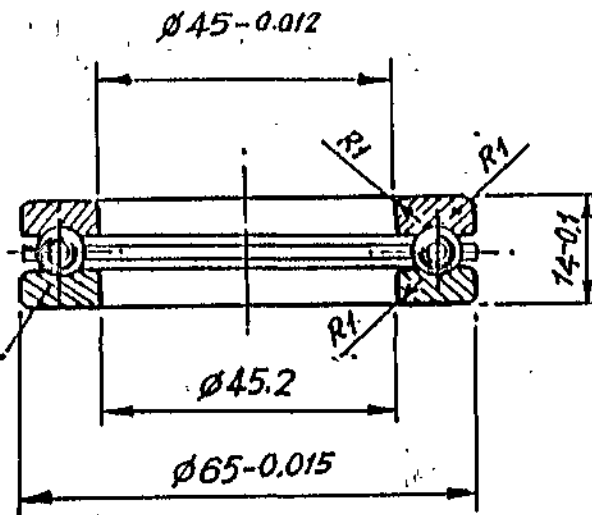




DRAWING NUMBER

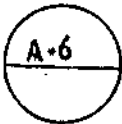
315-646-1

IT IS PERMITTED TO SUPPLY BEARINGS WITHOUT ONE RING WITH INTERNAL DIAMETER 45.2-NO 300109 AS PER GOST 6874-75 AND ETY 500-65(A)



DRAWING INDIANISED  
BASED ON ISSUE 1

KVD NO 63493



EXPLANATORY NOTE:

MATERIAL QUOTED: NO 8109 GOST 6874-75 AND ETY 500

SINGLE DIRECTION THRUST BALL BEARING TO Specn. ETY 500

8109 = CODE OF BEARING .

INDIAN EQUIVALENT:

FAG }  
SKF } 51109

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

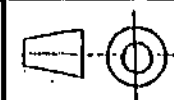
EST. WT. (0.095 WITH 1 YOKE) 0.15 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS = (      LETTERS)
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ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

MATERIAL:-  
NO 8109 GOST 6874-75 &  
ETY 500-65(A)

USED ON  
CB 315.664.2

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)  
AVADI.



TITLE  
BEARING

D S CAT NUMBER

DRAWING NUMBER

315-646-1

A	7.12.87	AUTHY BK 83-297
ISSUE	DATE	NATURE OF AMENDMENTS
DRN	<i>[Signature]</i>	SCALE:- 1:1 DIMENSIONS IN mm
CHD	<i>[Signature]</i>	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS 2102-69
TCD	<i>[Signature]</i>	ALL THREADS CONFORM TO
APPD	<i>[Signature]</i>	
DATE	8-5-86	

SIZE A4

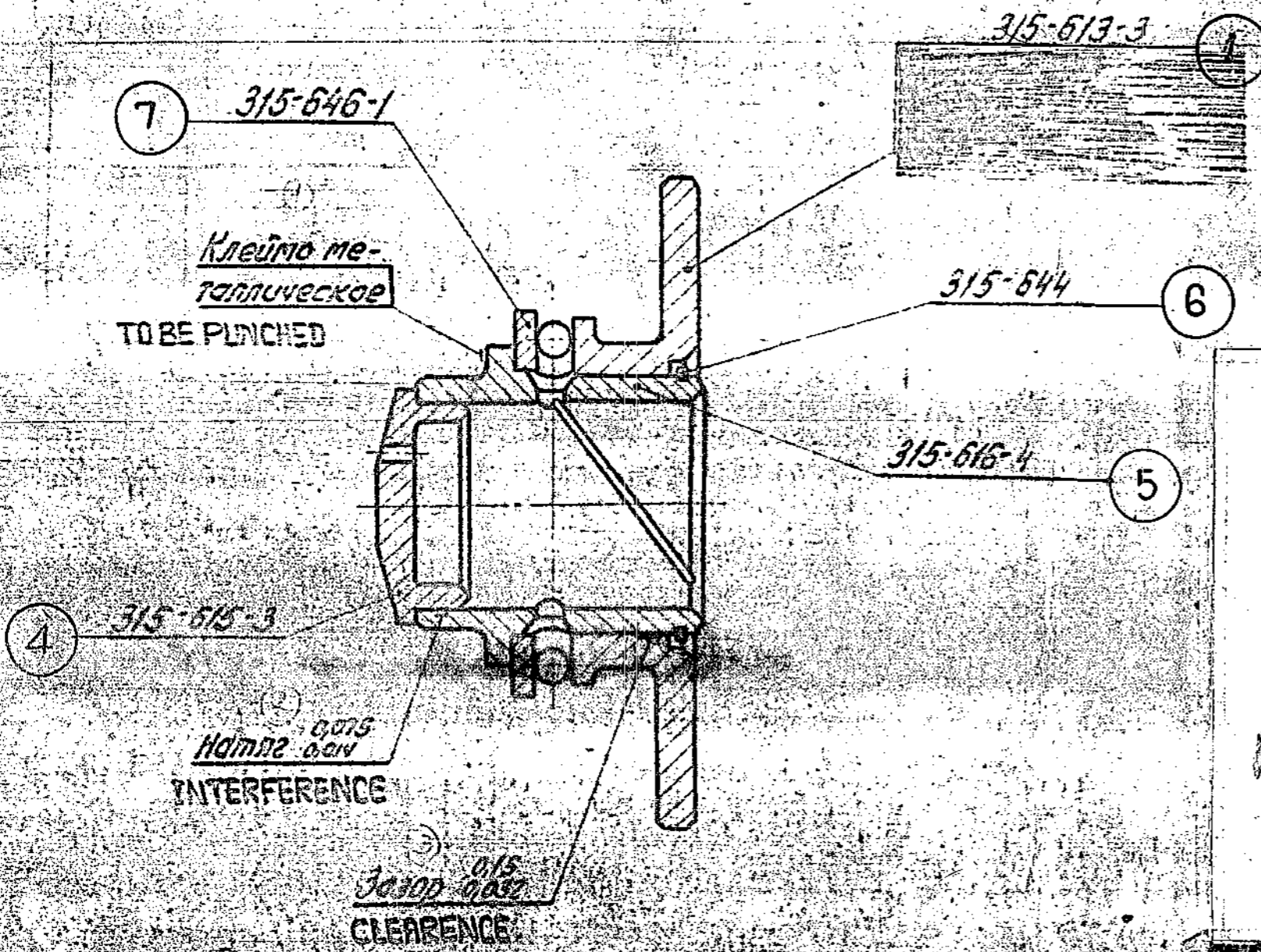


COMPRESSED AIR.

2. JAMMING OF BEARING IS NOT ALLOWED.

1. Узел промыть, продувить сжатым воздухом.  
2. Заедание & подшипника, не допускается.

*Ваня*



		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS #
		0044 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 - 1 : 1	-	CB 327-00-45
CHD <i>[Signature]</i>	DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD <i>[Signature]</i>	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE:- BUSH	
APPD <i>[Signature]</i>	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
DATE 09-5-1971			CB 315-664-2

A6





