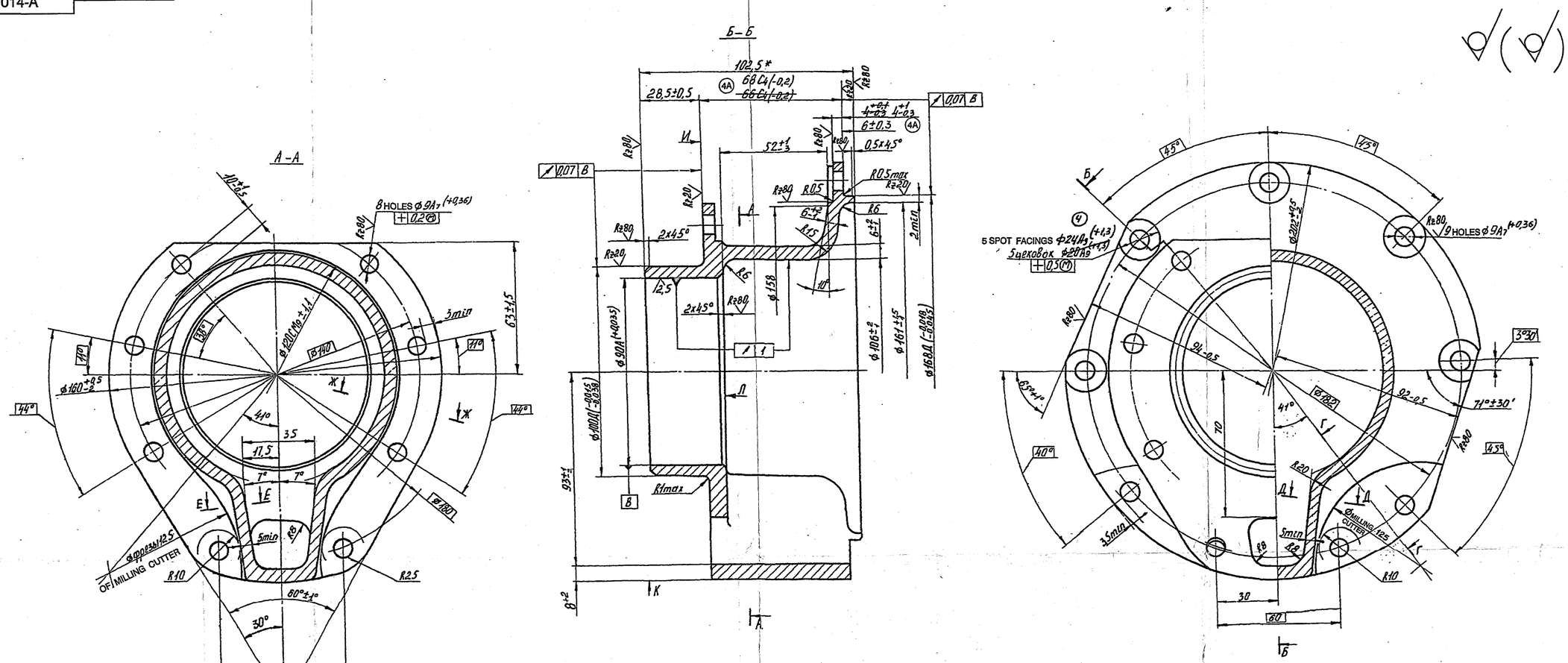
DRAWING NUMBER 175.47.014-A

SHEET No. 1 OF 1



1. MAY BE MANUFACTURED FROM STEEL 45Л-I AND 40ХЛ GOST 977-75.
2. COMPONENT SHOULD MEET THE REQUIREMENTS STIPULATED IN SPECIFICATIONS FOR STEEL COMPONENTS 172.TY 10 MADE BY INVESTMENT CASTING.
3. TOLERANCE FOR FREE DIMENSIONS ACCORDING TO ACCURACY CLASS III GOST 2009-55.
4. UNDER CUT RUNNER UPTO 1.5 mm HIGH IS ALLOWED ON SURFACE "K".
5. GROOVES UPTO 0.3 mm DEEP AND UPTO 3 mm WIDE ARE ALLOWED ON SURFACE Ø100Д, Ø168Д AS WELL AS ON END-FACE "Ц" FOR COMING OUT OF GRINDING WHEEL.
6. RUN OUT OF Ø100Д AND END PLAY OF ADJACENT END FACE AS WELL AS Ø90A RELATIVE TO Ø168Д AND ADJACENT FLANGE FACE MAY BE CHECKED. IN THIS CASE RUN OUT OF INDICATED SURFACES SHOULD NOT EXCEED 0.07 mm.
7. INTERNAL SPACE BOUNDED BY Ø106 AND END FACE Ø90A IS TO BE CHECKED BY LEAK PROOFNESS WITH DIESEL FUEL, AIR AND WATER AT A PRESSURE OF 3^{+1} Kg/cm² FOR THREE MINUTES, LEAKAGE IS NOT ALLOWED.
8. COATING: CHEMICAL OXIDIZING, PHOSPHATING, OIL FINISHING.
9. * DIMENSION FOR REFERENCE.
10. CUTTINGS FROM TOOL ARE ALLOWED ON SURFACE Ø160$^{+0.5}_{-2}$ WITHIN TOLERANCE ON DIAMETER WHEN MAKING SPOT-FACINGS OF Ø24A9.
11. FOR REPARING OF BLOW HOLES IF ANY, SUITABLE WELDING PERMITTED.
12. FOR PRESSURE TESTING PROCEDURE CONTACT M.T.P.F.

(4C) ALT. MATL. :- GRADE 1 TO IS : 4896-76

(4B) 188.45.001cb-3Cb

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

EST. WT. (Kg)	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
3.02	

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
4C	07.07.06	AUTHY.LLNo.80001/CQA(HV)/GEN/06.15.10.05
4B	25.10.04	N OF A No. CQA(HV)/T90/45/001
4A	3.4.2K	D.O. ERROR OBSERVED

DRN	Sd/=
CHD	Sd/=
APPD	Sd/=
DATE	22-02-88
SCALE:- 1:1	
DIMENSIONS IN mm	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69	
ALL THREADS TO CONFORM TO	

MATERIAL:- STEEL 40Л-I GOST 977-75

USED ON:- 172.45.060cbCb 175 45 Cb

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI

TITLE:- BODY

D.S CAT NUMBER

DRAWING NUMBER 175.47.014-A

" COMMON TO T-90 "

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 4

(B.JAYAVELU), JTO(D) 10-08-06

F-88 23

SIZE A1