













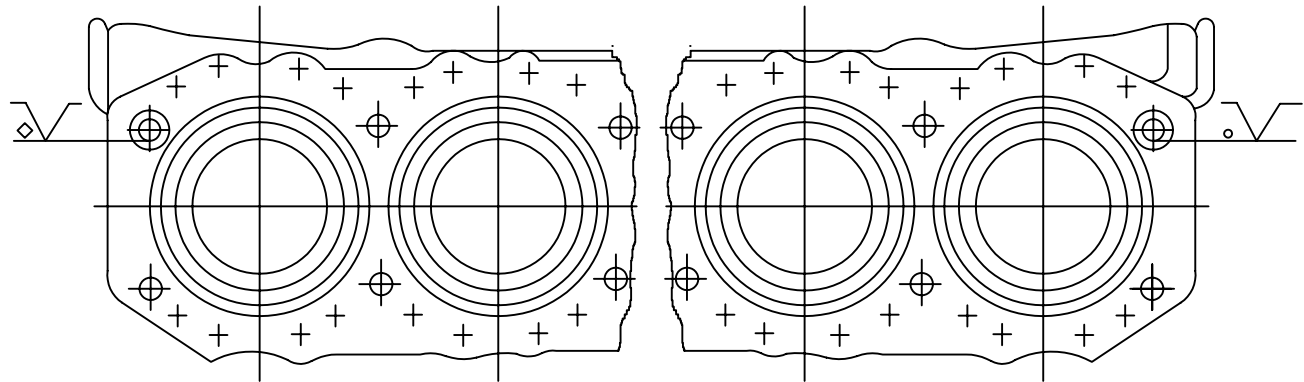
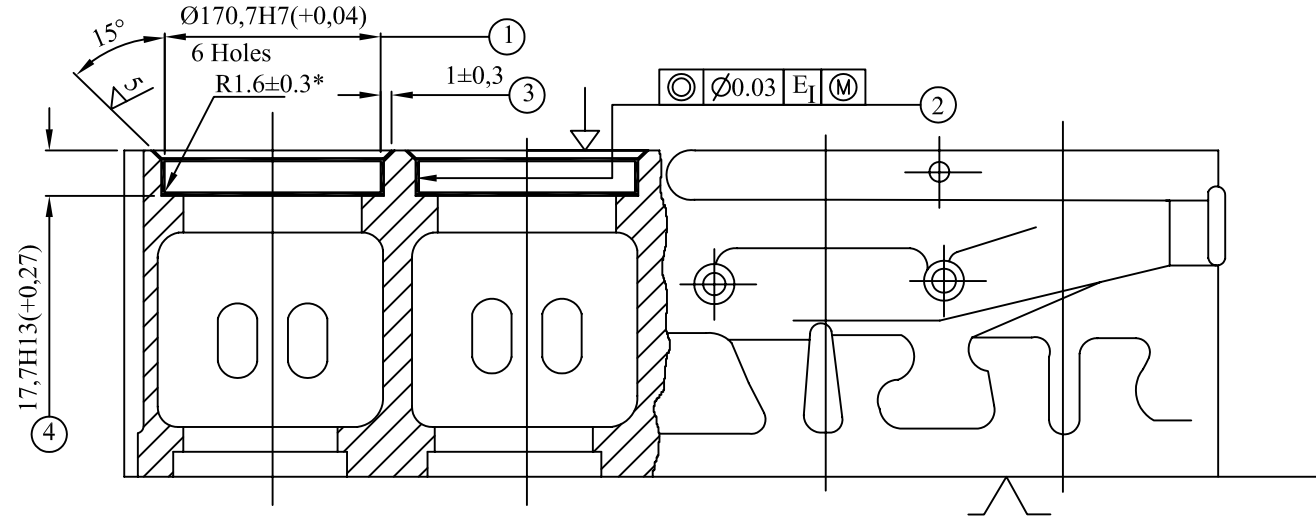


																				2
																				085
p										ПИ	Д or B	L	t	l	S	n	U			
1																TB	To			
2	T									Tool	BK8									
3																				
4	T9532-4184									Gauge										
5																				
6	T9553-3586									Plate 170,7H7										
7																				
8	T9563-14385									Template 1 ± 0,3 X 150°										
9																				
10	T9564-21593									Template 17,7H13										
11											172.7	19	0.5	6	40	200	108.5			
12																				
13	3. Checking - 20%															0.3				
14																				
15										Goggles 024 ГОСТ P 12.4.013-97										
16																				
17										Wire brush										
18																	F - 90			
OK	Opeartion chart of mechanical process																	95 / 176		

sb 303-06-24, sb 303-05-9  
sb303-03-16, sb303-02-23

4

025



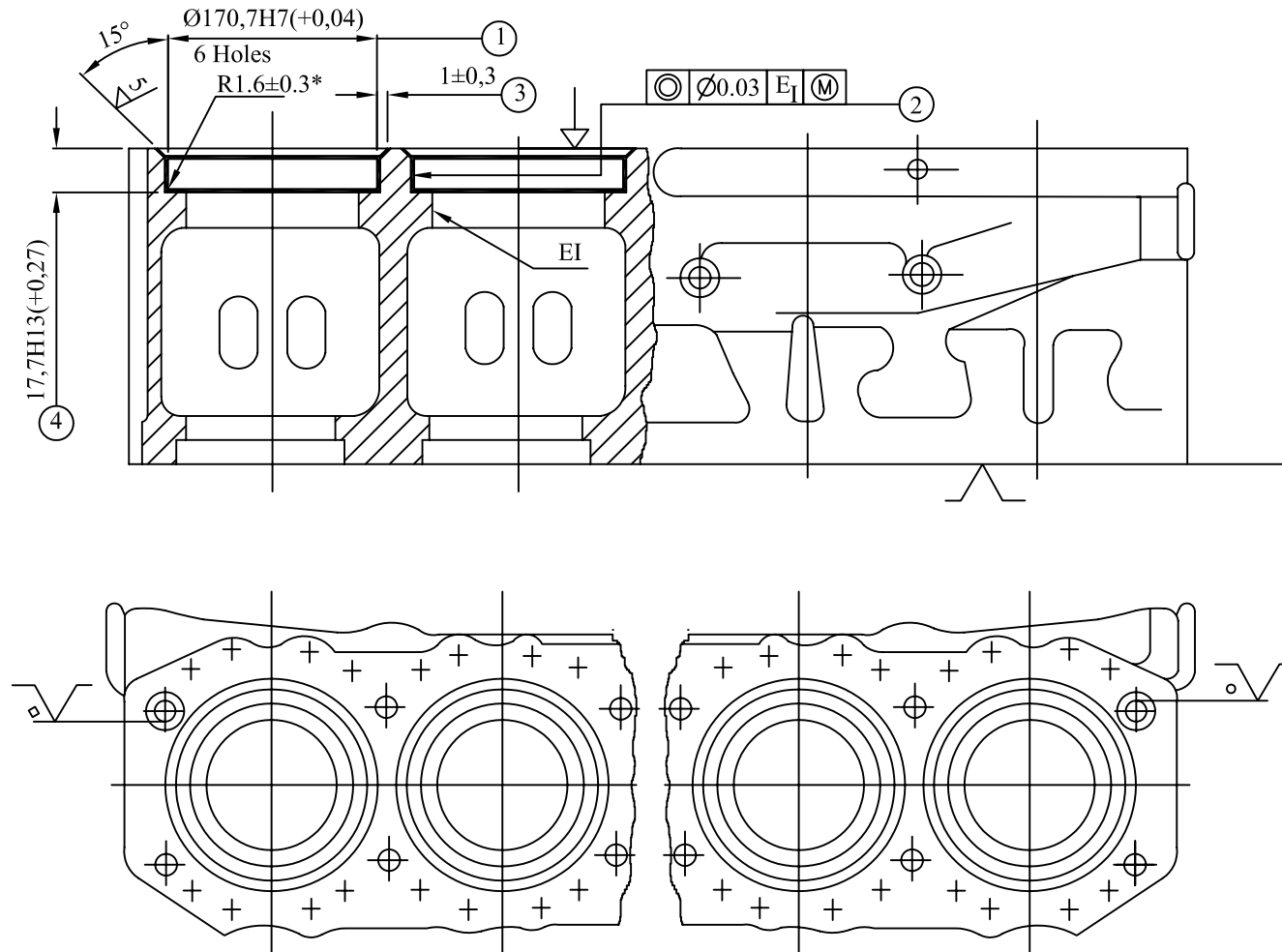




sb 303-06-24, sb 303-05-9  
sb303-03-16, sb303-02-23

3

085-1



								2		1		
				cb.303-06-24,cb.303-05-9 cb.303-03-16,cb.303-02-23								
				Cylinder jacket						090		
01	Code, nomenclature of operation			Marking of document					МИ			
	Fitting			ИОТ No 173								
02				Code, nomenclature of equipment				ТВ	То			
				Bench				1,6	1.76			
KM	Nomenclature of parts, and assembly units or material			Code, Marking		ОПП	ЕВ	ЕН	КИ	Нрасх		
P												
03									ТВ	То		
04	1. Clean burrs and clean sharp edges in all 6 cylinders (1)											
05									1,5			
06												
07	T9497-4241			Mandrel								
08												
09	T9314-729			Tool BK8								
10												
11	T2820-0038			File 400 No 3								
12												
13	Goggles 024 ГОСТ P 12.4.013-97			Wire brush								
14												
15	2. Inspection- 10%									0.1		
								F-90				
OK	Operation chart										100/176	



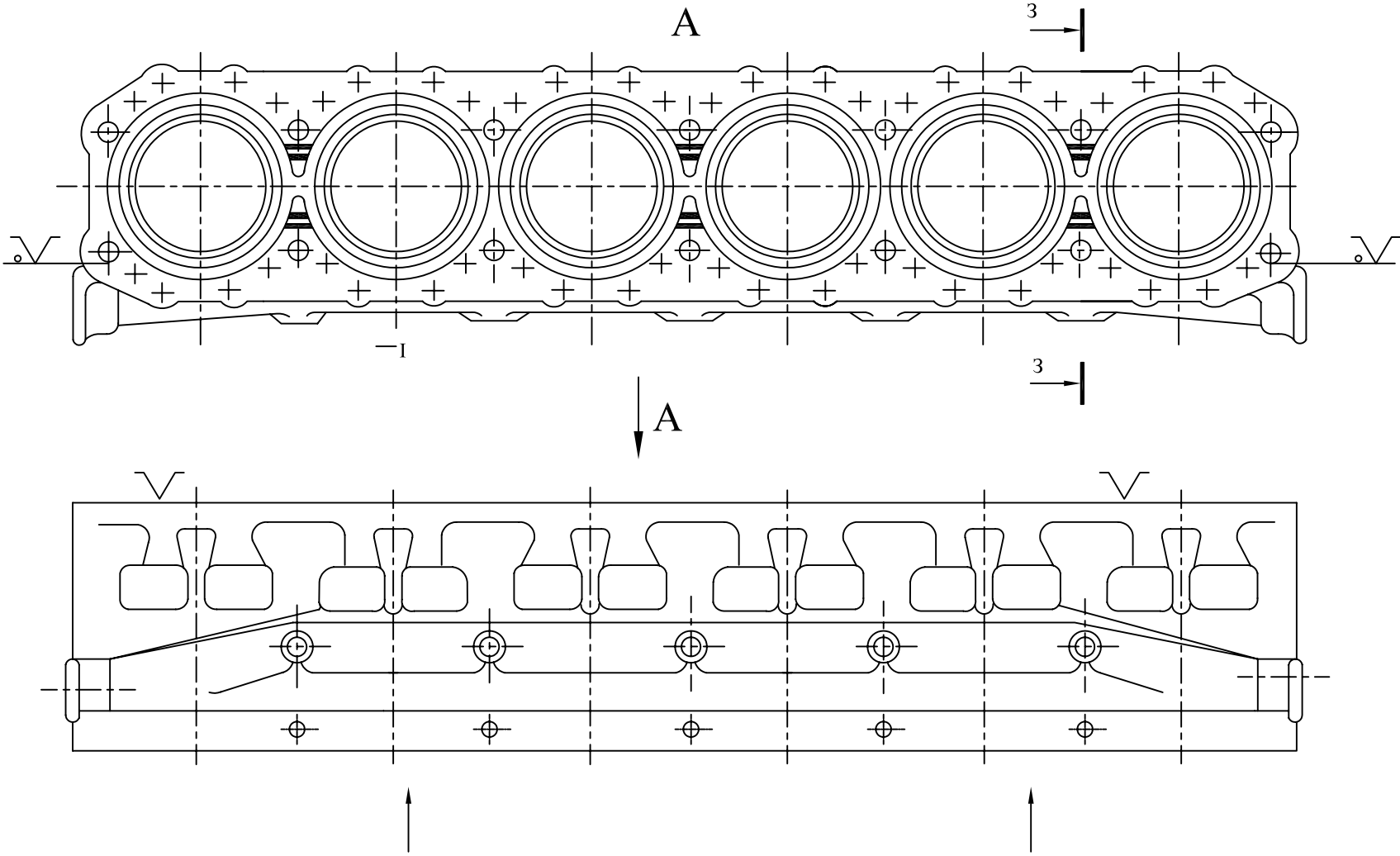




sb 303-06-24, sb 303-05-9  
sb303-03-16, sb303-02-23

3

095

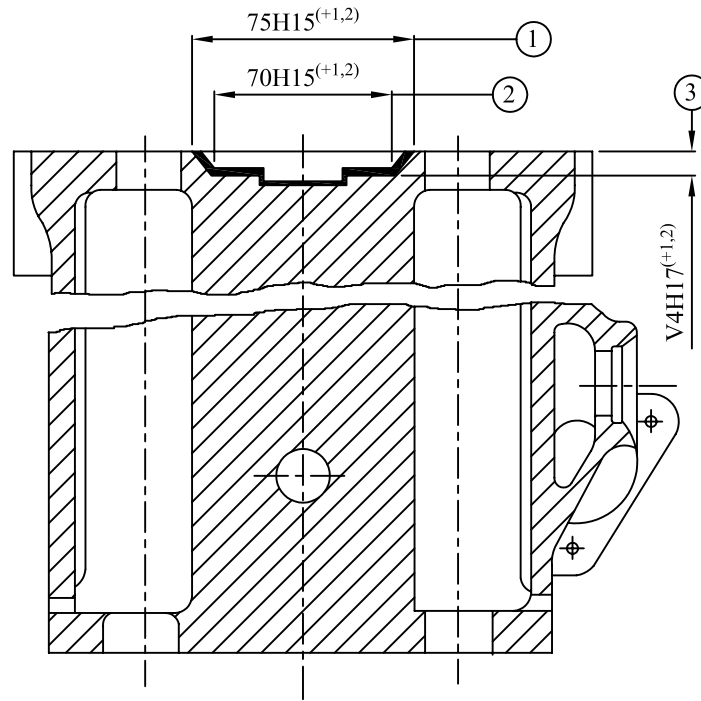


sb 303-06-24, sb 303-05-9  
sb303-03-16, sb303-02-23

4

095

### 3 - 3



\*Dimension 1 and 2 are ensured by checked Tool







														2								
														cb.303-06-24,cb.303-05-9 cb.303-03-16,cb.303-02-23				105				
p											ПИ		Д or В		L	t	l	S	n	U		
1																			TB	To		
2	6100-0146										Insert Гост 13598-85 (step. 6)											
3																						
4	6100-0142										Insert Гост 13598-85 (step.6)											
5																						
6	T9342-3122										Drill 7,8 (step.6)											
7													7.8	18			4	0.224	1600	39		
8																						
9																						
10	3. Ream 4 holes (1) by hand, maintain the co-axial tolerance																				1,0	
11																						
12											Brace (step.7)											
13																						
14	T9353-1026										Reamer 8 Д 9											
15																						
16	8133-0918										Plug 8 Д 9 Гост 14810-69											
17																				<b>F-90</b>		
18											Vernier caliper ШЦ-I- 125-0,1-2 Гост 166-89											
OK		Opeartion chart of mechanical process															<b>109/176</b>					

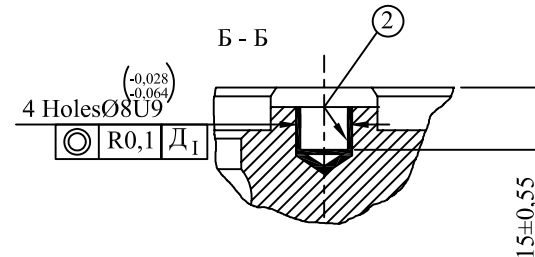
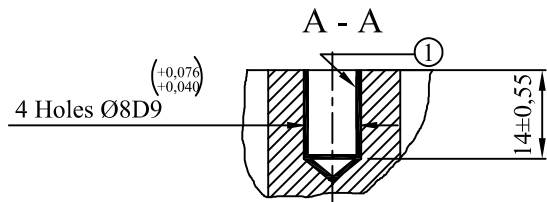
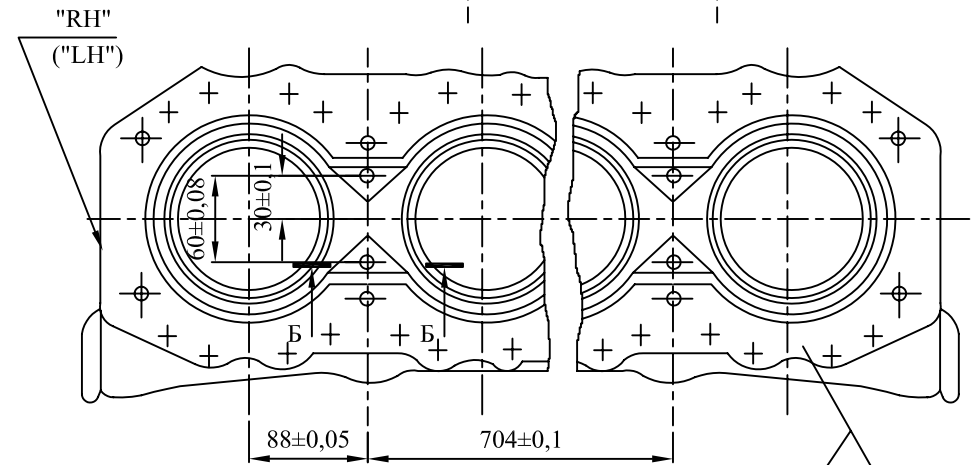
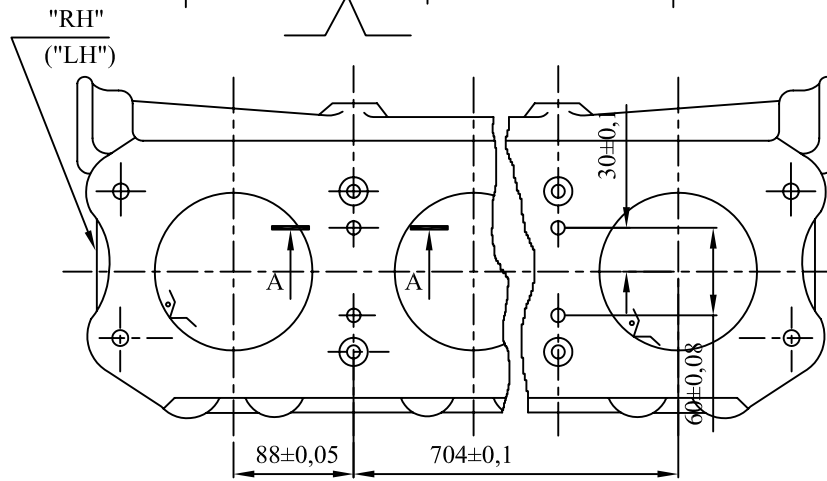
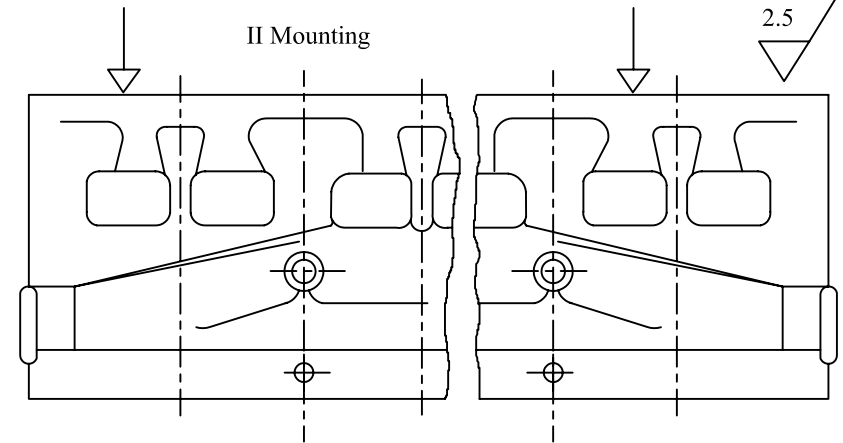
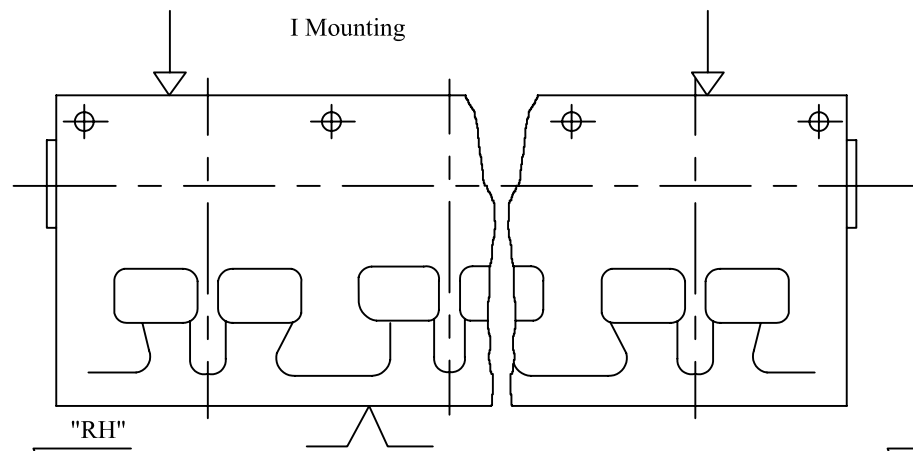
																		3				
																		cb.303-06-24,cb.303-05-9 cb.303-03-16,cb.303-02-23		105		
p								ПИ	Д or В	L	t	l	S	n	U							
01																			TB	To		
02																						
03																						
04	4. Reinstall the part.																					
05																						
06	5. Drill 4 holes (2)																		0.7	0.17		
07																						
08																						
09								From step 3														
10																						
11									7.8	15			4	0.224	1600				39,0			
12																						
13	6. Ream 4 holes (2) by hand, maintain the co-axial tolerance																		0.8			
14																						
15	From step 4																					
16																						
17								T9353-1027	Reamer 8 U 9													
18																				<b>F-90</b>		
OK	Opeartion chart of mechanical process																		<b>110/173</b>			

												4	
								cb.303-06-24,cb.303-05-9 cb.303-03-16,cb.303-02-23				105	
p				ПИ	Д or B	L	t	l	S	n	U		
1										TB	To		
2	8133-0918			Plug 8 U 9 Гост 14810-69									
3													
4													
5													
6	7. Check - 30%									0.15			
7													
8	8. Mark the stamp on part									0.06			
9													
10	T9817-151			Metallic stamp									
11													
12	7850-0102			Hammer 0.4 Гост 2310-77									
13													
14	Goggles 024 Гост Р 12.4.013-97												
15													
16	Wire brush												
17													
18	Napkin Гост 14253-83												F-90
OK	Opeartion chart of mechanical process											111/176	

sb 303-06-24, sb 303-05-9  
sb303-03-16, sb303-02-23

5

105



F - 90  $\frac{112}{176}$


																	6		
cb303-06-24, cb303-05-9 cb303-03-16, cb303-02-23																	105		

1. Displacement of holes axis ① ② in longitudinal and cross directions not more than 0.1 mm. Check one part -out of 100 pieces.
  
2. Arrangement of holes ① ② to be checked in one part, out of 200 pieces.

		F - 90
KЭ	Diagram chart	113 / 176

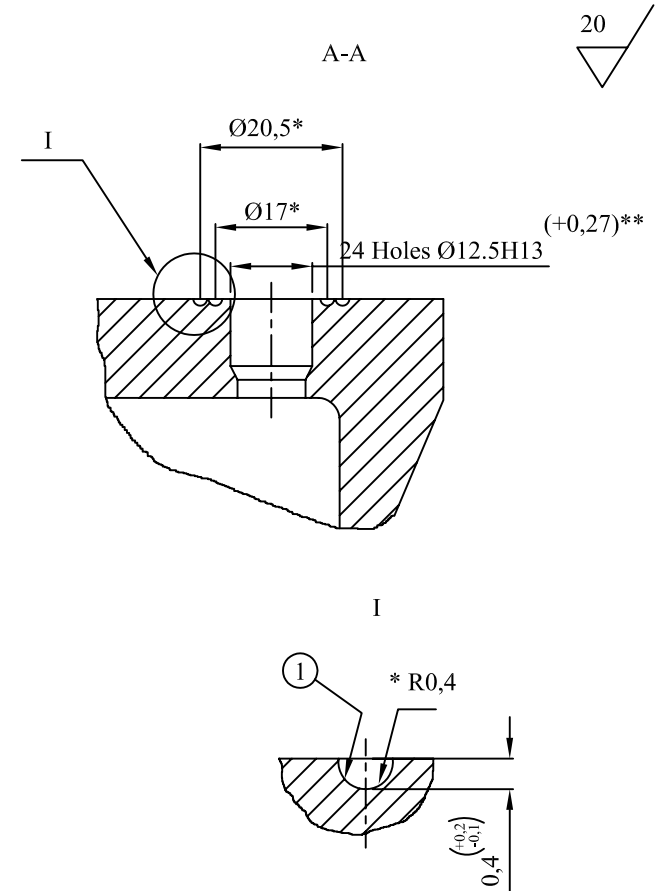
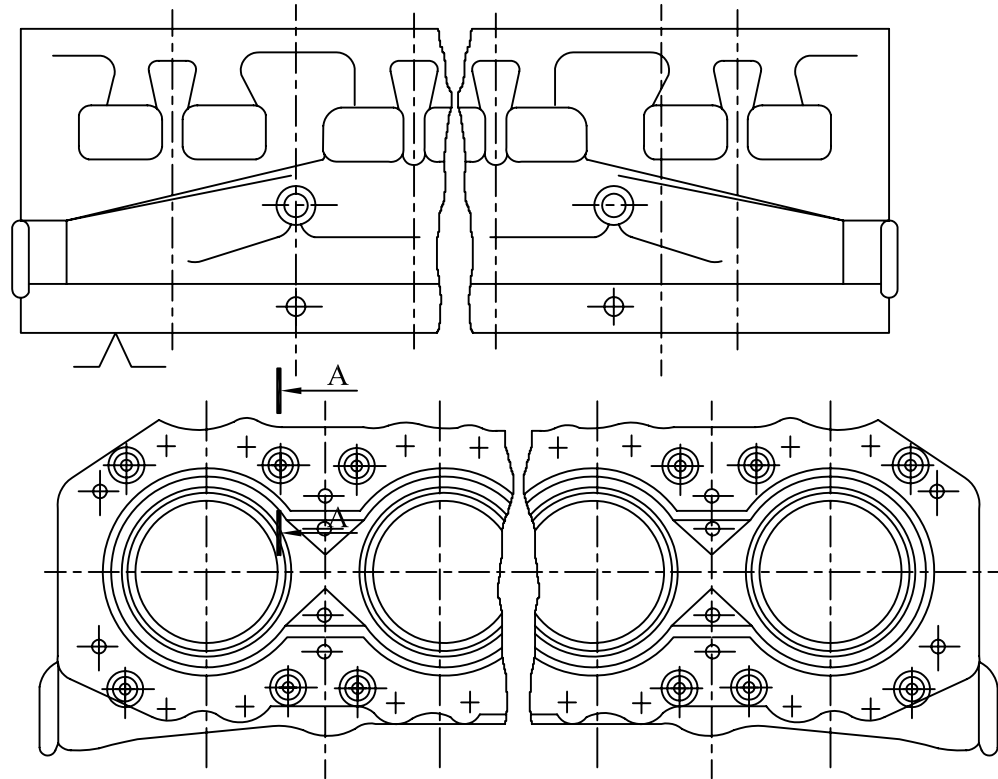


									2		
								cb.303-06-24,cb.303-05-9 cb.303-03-16,cb.303-02-23			
								110			
p				ПИ	Д or В	L	t	l	S	n	U
1										TB	To
2					21	1.5	0.8	24	0.1	630	41.5
3											
4	3. Check - 10%									0.5	
5											
6	Goggles 024 Гост Р 12.4.013-97										
7											
8	Wire brush										
9											
10	Napkin Гост 14253-83										
11											
12											
13											
14											
15											
16											
17											
18											F-90
OK	Opeartion chart of mechanical process										115/176

sb 303-06-24, sb 303-05-9  
sb303-03-16, sb303-02-23

3

110



\* Dimension Provided by Tool.

\*\* Dimension is given for reference.

												6		1			
				с6.303-06-24,сo.303-05-9 с6.303-03-16,с6.303-02-23													
				Cylinder jacket										115			
Nomenclature of operation				Material				Hardness		EB	МД	Profile and dimension				M3	КОИ
Drilling																	
Equipment CNC machine				Marking of program				To	Tв	T п.3	T шт	СОЖ					
2H55 Radial drilling								0.29	2.07	0.24	2.6	Solution No 3 as per ИЛ -352-78					
p					ПИ	Д or B		L	t	i	n	n	V				
1	ИОТ No 161 , ИОТ No 250											Tв	To				
2																	
3	1. Install the part and fasten it.											1,0					
4																	
5	T9698-23447				Stand												
6																	
7	T9640-7025				Jig												
8																	
9	2. Core the drill groove (1) ,and maintain positional											0.3	0.16				
10	tolerance																
11	6251-0182				Chuck Гост 14077-83 (step.5)												
12																	
13	6100-0146				Insert Гост 13598-85 (step.5)								F-90				
OK														Operation chart of mechanical process		117/176	



																		2				
																		cb.303-06-24,cb.303-05-9 cb.303-03-16,cb.303-02-23				
																		115				
p										ПИ	Д or В	L	t	l	S	n	U					
1																TB	To					
2	From step 2																					
3																						
4	2301-0055									Drill 16,25 Гост 10903-77												
5																						
6	8133-0942									Plug 16H14 Гост 14810-69												
7											16.25	18	1.2	1	0.224	630	32					
8																						
9	6. Check - 10%														0.08							
10																						
11										Goggles 024 Гост Р 12.4.013-97												
12																						
13	Wire brush																					
14																						
15																						
16																						
17																						
18																		F-90				
OK	Opeartion chart of mechanical process																	119/176				

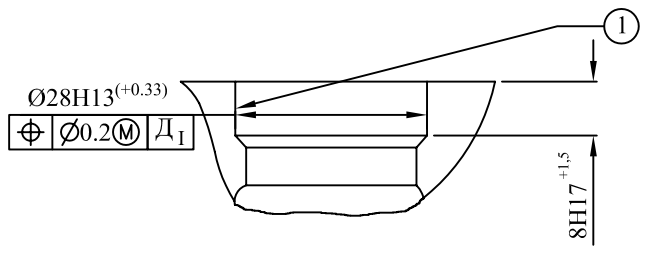
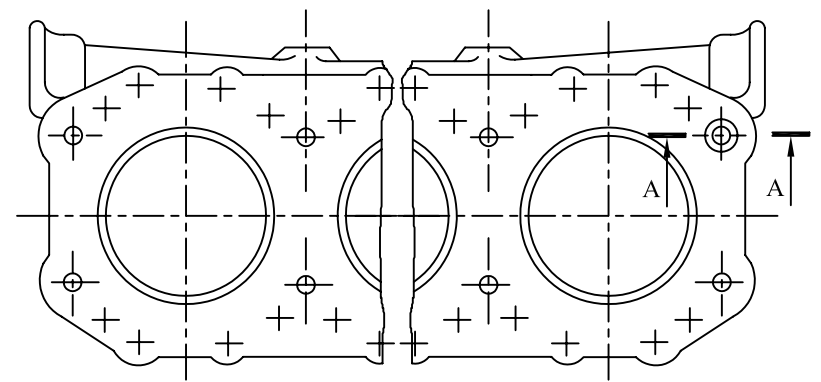
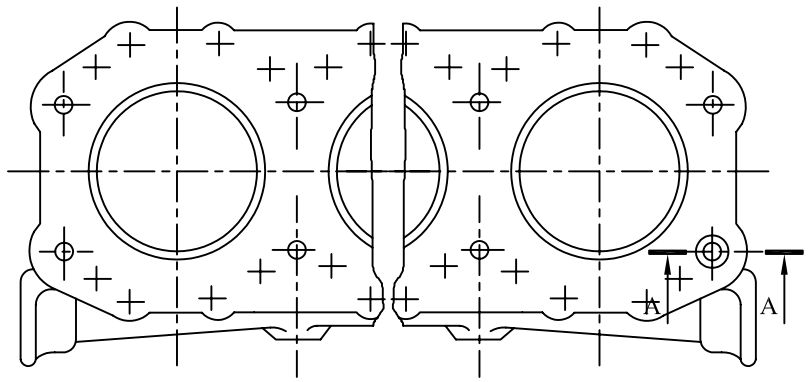
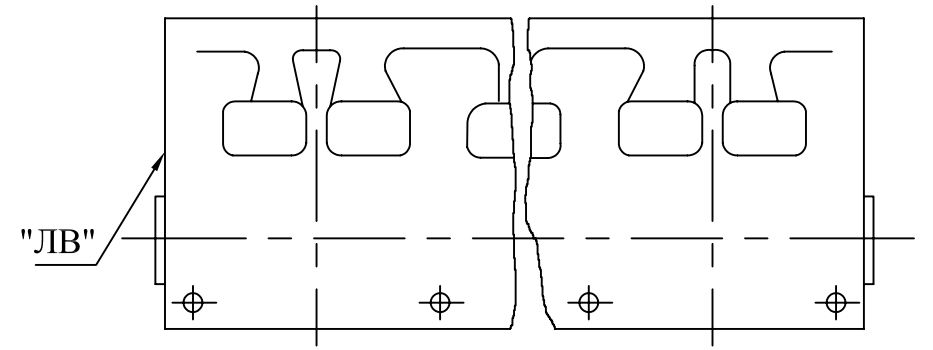
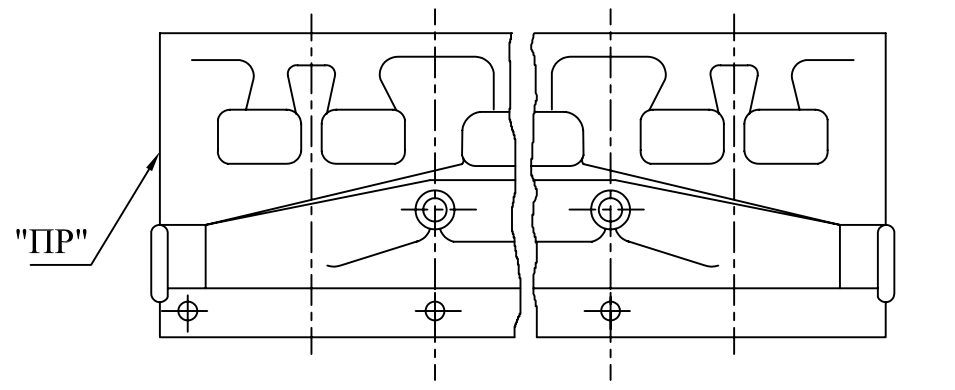
sb 303-06-24, sb 303-05-9  
 sb303-03-16, sb303-02-23

4  
 115

Parts - sb.303-05-24 , sb.303-02-16

Parts - sb.303-05-9 , sb.303-02-23

20



sb 303-06-24, sb 303-05-9  
sb303-03-16, sb303-02-23

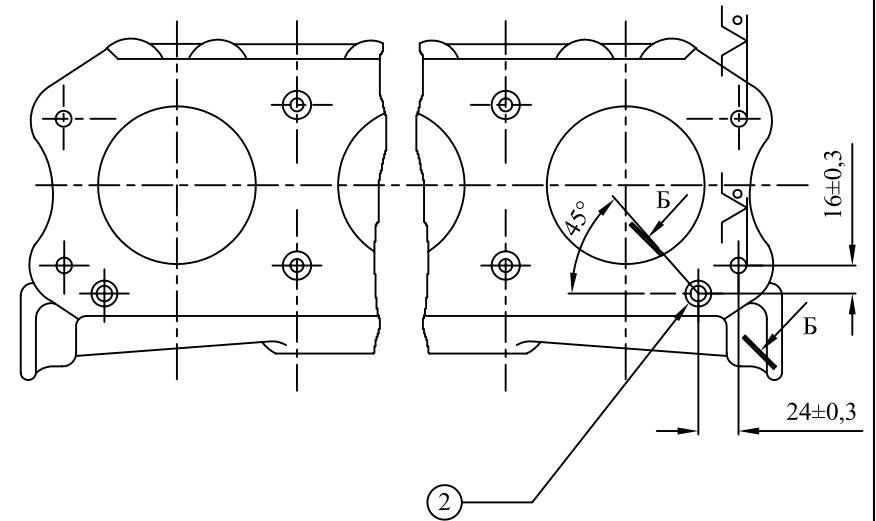
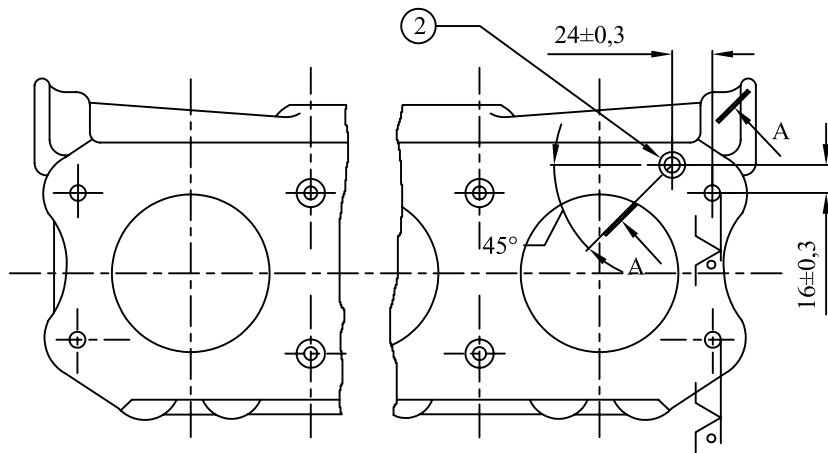
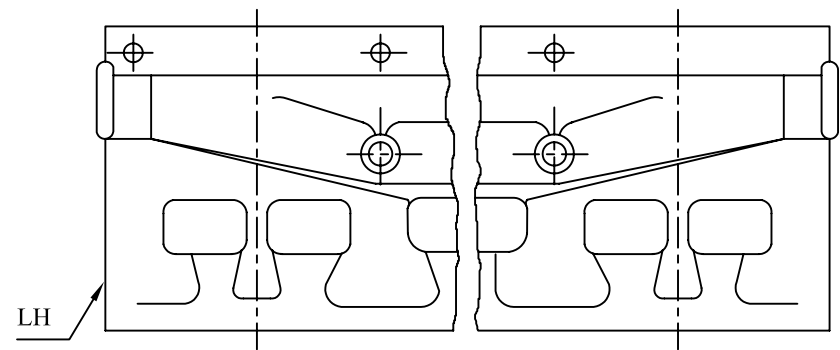
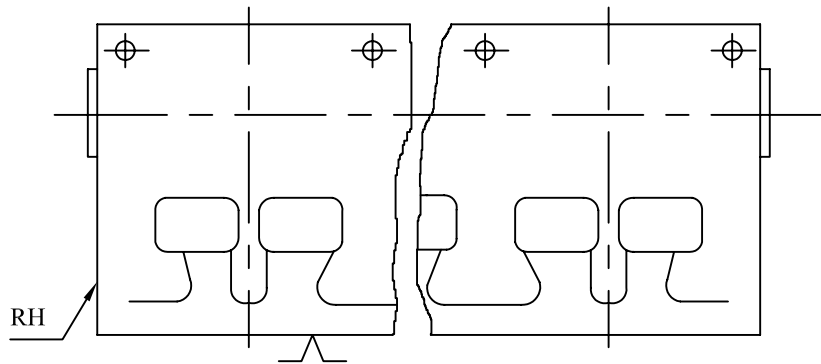
5

105

Parts sb.303-06-24 , sb.303-03-16

Parts sb.303-05-9 , sb.303-03-23

20







												2	
								cb.303-06-24,cb.303-05-9 cb.303-03-16,cb.303-02-23				120	
p				ПИ	Д or B		L	t	l	S	n	U	
1											TB	To	
2	2. Core the drill sequentially 14 holes (1)												
3	(in case of presence of moulding influx)										1.2	0.57	
4													
5	6251-0182			Chuck Гост 14077-83									
6													
7	6100-0146			Bush Гост 13598-83									
8													
9	6120-0355			Bush Гост13409-83									
10													
11	83482-51			Core drill									
12					28	218		5	1.2	1600	140.7		
13													
14	3. Check - 10%										0.3		
15													
16				Goggles 024 P 12.4.013-97									
17													
18				Wire brush								F - 90	
OK		Opeartion chart of mechanical process										124/176	

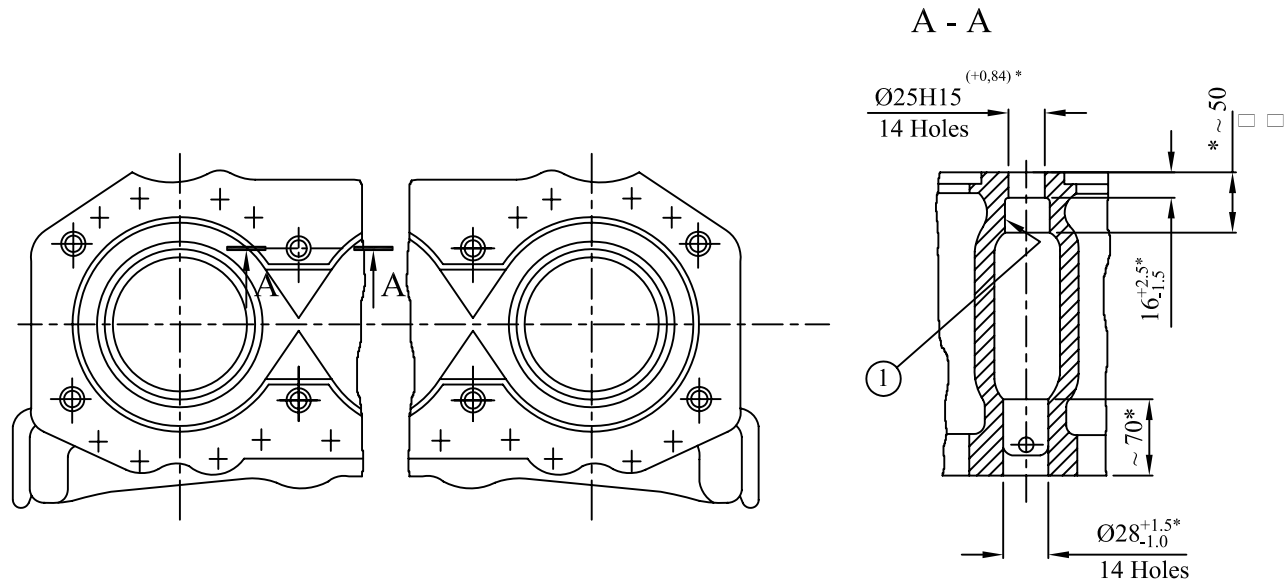


sb 303-06-24, sb 303-05-9  
sb303-03-16, sb303-02-23

3

120

2.0  
▽



\*Dimension are given for references

																3					
													cb.303-06-24,cb.303-05-9 cb.303-03-16,cb.303-02-23								
													Cylinder jacket			125					
Nomenclature of operation					Material					Hardness		EB		МД		Profile and dimension			M3		
Drilling																					
Equipment CNC machine					Marking of program					То		ТВ		Т п.з		Т шт		СОЖ			
Drilling machine												1.2		0.16		1.36					
p						ПИ		Д or B		L		t		i		S		n		V	
1	ИОТ No 161 , ИОТ No 250, ИОТ No 173																	ТВ		То	
2																					
3	1. Install the part and fasten it.																				
4						Bench															
5	T9640-4355					Jig												0.80			
6																					
7	2. Drill holes in (1) and in 3rd or 4th cylinder																	0.15		0.20	
8																					
9	2300-1075					Drill 4,1 Гост 19544-74															
10																					
11	8133-0906					Plug 4H14 Гост 14810-69															
12																					
13																					
																				F - 90	
OK		Operation chart of mechanical process																		126 / 176	

										2	
								cb.303-06-24,cb.303-05-9 cb.303-03-16,cb.303-02-23		125	
p				ПИ	Д or B	L	t	l	S	n	U
1										TB	To
2	3. Inspection - 10%									0.05	
3											
4	Goggles 024 Гост Р 12.4.013-97										
5											
6	Wire brush										
7											
8											
9											
10											
11											
12											
13											
14											
15											
16											
17											
18											F-90
OK	Opeartion chart of mechanical process										127/176

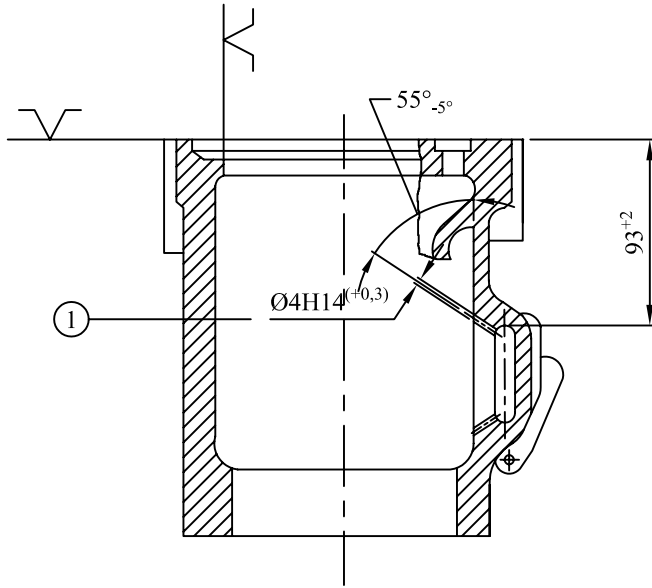
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sb 303-06-24, sb 303-05-9  
sb303-03-16, sb303-02-23


3  
125

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Co - Ordinates of holes (1) to be provided by Fixture

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F - 90  $\frac{128}{176}$





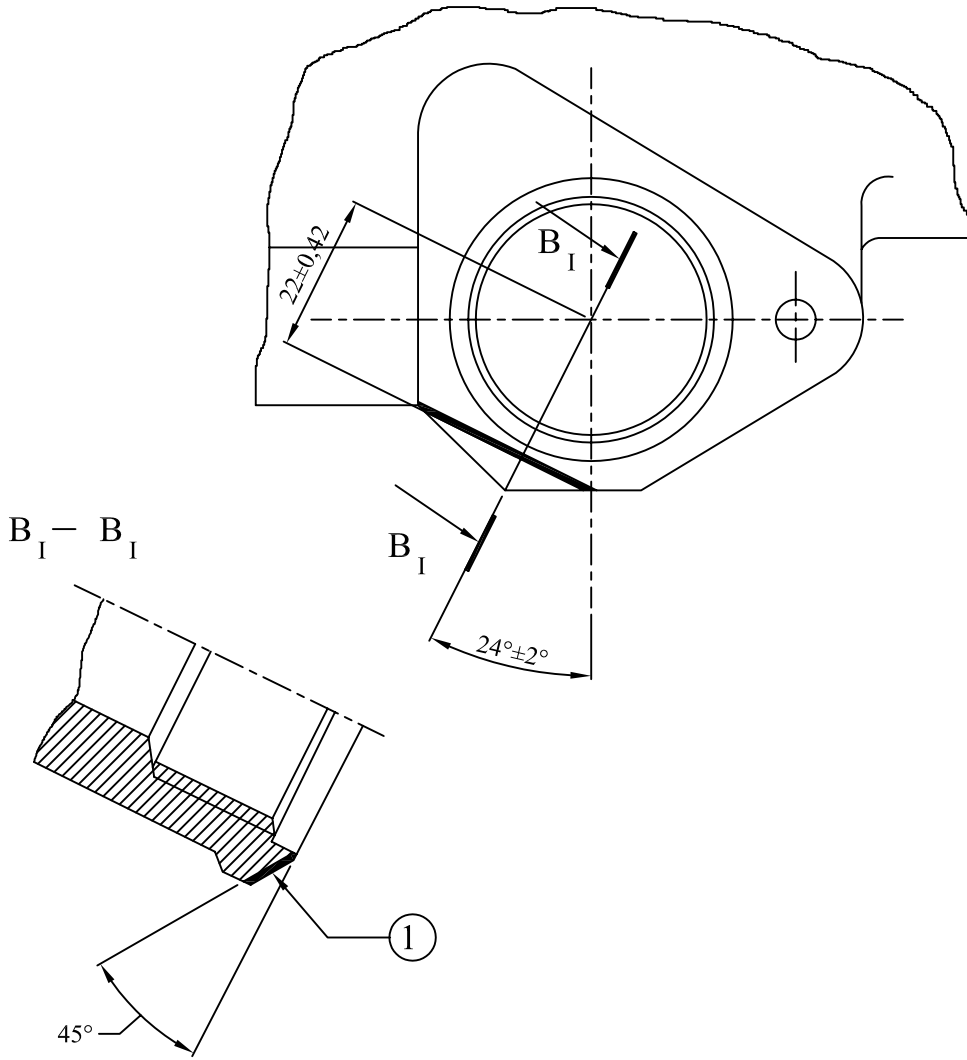
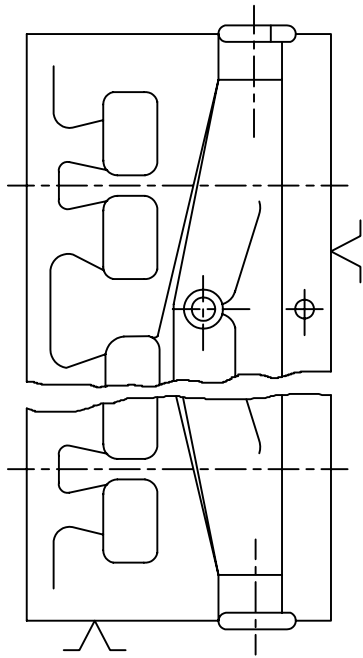



sb 303-06-24, sb 303-05-9  
sb303-03-16, sb303-02-23

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130

20  
▽





												2							
								Cb.303-06-24 ,cb.303-05-9 cb.303-02-23,cb.303-03-16				135							
K/M	Nomenclature of parts, assembly unit or material							Code, Marking							onn	EB	EH	KH	Нрарх.
P																			
1																			
2								Installing fixture in machine											
3																			
4	3.Wash the part as per ИЛ 692-87 for the period of 5 min.																	5,0	0,02
5																			
6	4. Blow the part with dry compressed air.																		(0,3)
7																			
8	3-001-01							Air gun											
9																			
10								Goggles 024 Гoct P 12.4.013-97											
11																			
12	5. Checked by visual inspection cleanness, after washing the part and																		
13	blowing with air																		(0,2)
14																			
15																			
16																			
17																			
												F-90							
OK	Operation Chart														133/176				



										5	1		
					cb.303-06-24 ,cb.303-05-9 cb.303-02-23,cb.303-03-16								
					Cylinder jacket								140
01	Code, nomenclature of operation											МИ	
	Assembly				ИОТ No 173								
02					Code, nomenclature of equipment					TB	ТО		
					T9954-328					3.05	3.4		
K/M P	Nomenclature of parts, assembly unit or material				Code, marking			ОПП	ЕВ	ЕН	КИ	Нрцх	
03	Ring				303-40						1		
04	Plug				303-13-4						1		
05	1. Install the part											0,8	
06	T9698-16328				For assembly								
07													
08	2. Calibrate the thread (1)											0.4	
09													
10	6910-0063				Tap wrench								
11													
12	2620-2085 2				Marker M39x 1.5 ГОСТ 3266-81								
13													
14	8221-3133				Plug M39x1,5-5H ГОСТ 17758-72								
15													
											<b>F-90</b>		
OK	Operation chart										<b>135/176</b>		







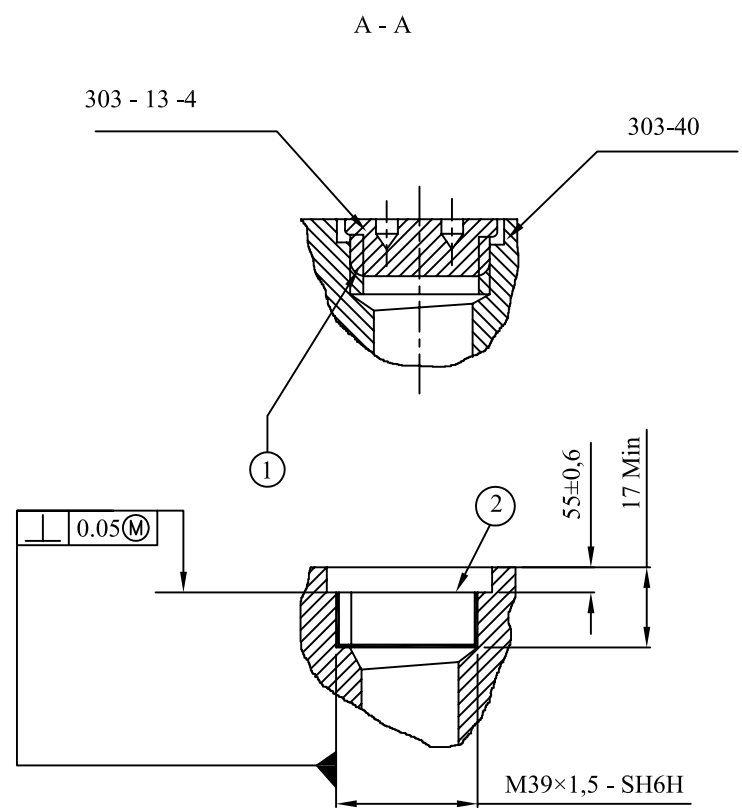
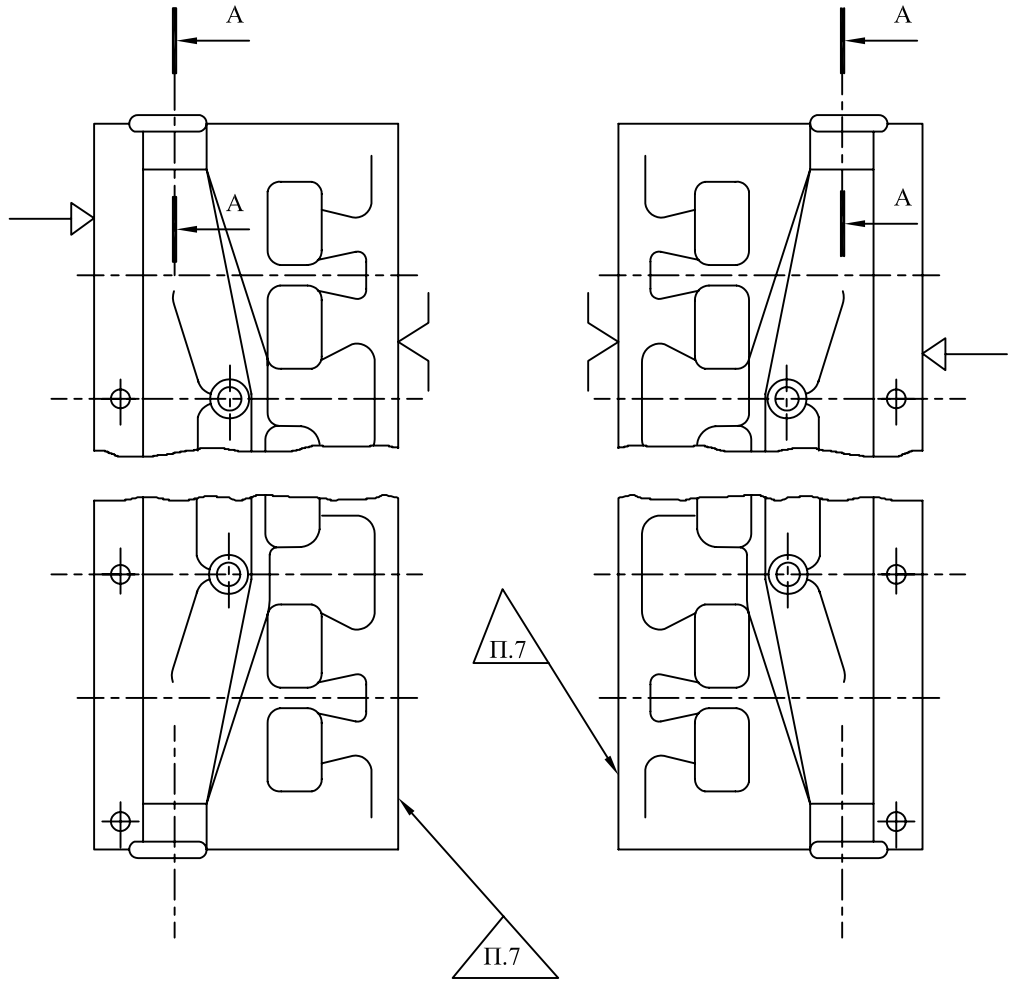
sb 303-06-24, sb 303-05-9  
sb303-03-16, sb303-02-23

5

140

Part sb.303-02-23

Part sb.303-03-16



												3	1	
										cb.303-06-24 ,cb.303-05-9 cb.303-02-23,cb.303-03-16				
										Cylinder jacket				145
01	Code, nomenclature of operation					Marking document					МИ			
	Assembly					ИОТ No 116								
02						Code, nomenclature of equipment				ТВ	ТО			
						9628-053 Hydrallic support				6.36	7,0			
K/M	Nomenclature of parts, assembly unit or material					Code, marking			ОПП	ЕВ	ЕН	КИ	Нрарх	
P														
03														
04	1. Install pipe and plug the whole													
05														
06	T9698-17938					Device for pressing							0,5	
07														
08	Goggles 024 Гост Р 12.4.013-97													
09														
10	2. Water spaces of anchor stud holes to be tested for													
11	air tightness with water at temperature (80 <sup>+10</sup> )°C													
12	under pressure (0,3 <sup>+0,1</sup> ) (3 <sup>+1</sup> kgm/cm <sup>2</sup> ) for not less than 5 min													
13	Water leak is not Permitted. Testing with air under pressure													
14	of (0,2 <sup>+0,2</sup> ) (2 <sup>+2</sup> kgm/cm <sup>2</sup> ), in water tub is permitted, but													
15	air leak is not permitted.													
													F-90	
OK	Operation chart										140/176			













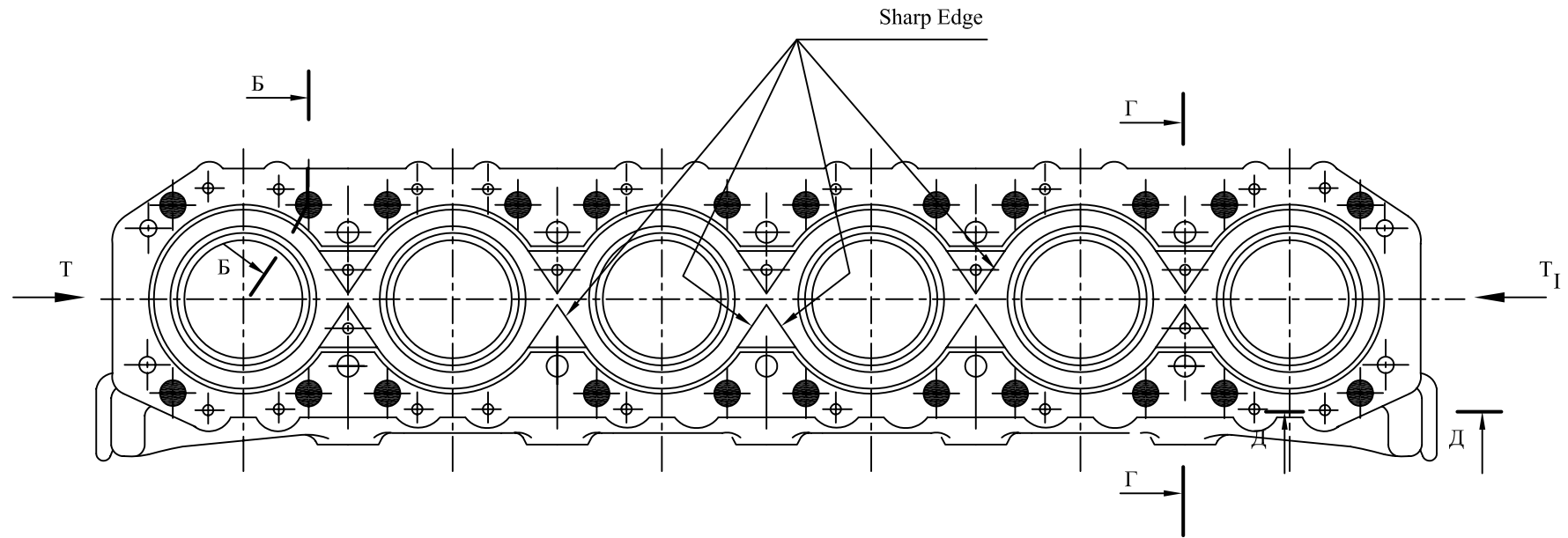


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sb 303-06-24, sb 303-05-9  
sb303-03-16, sb303-02-23

150

20

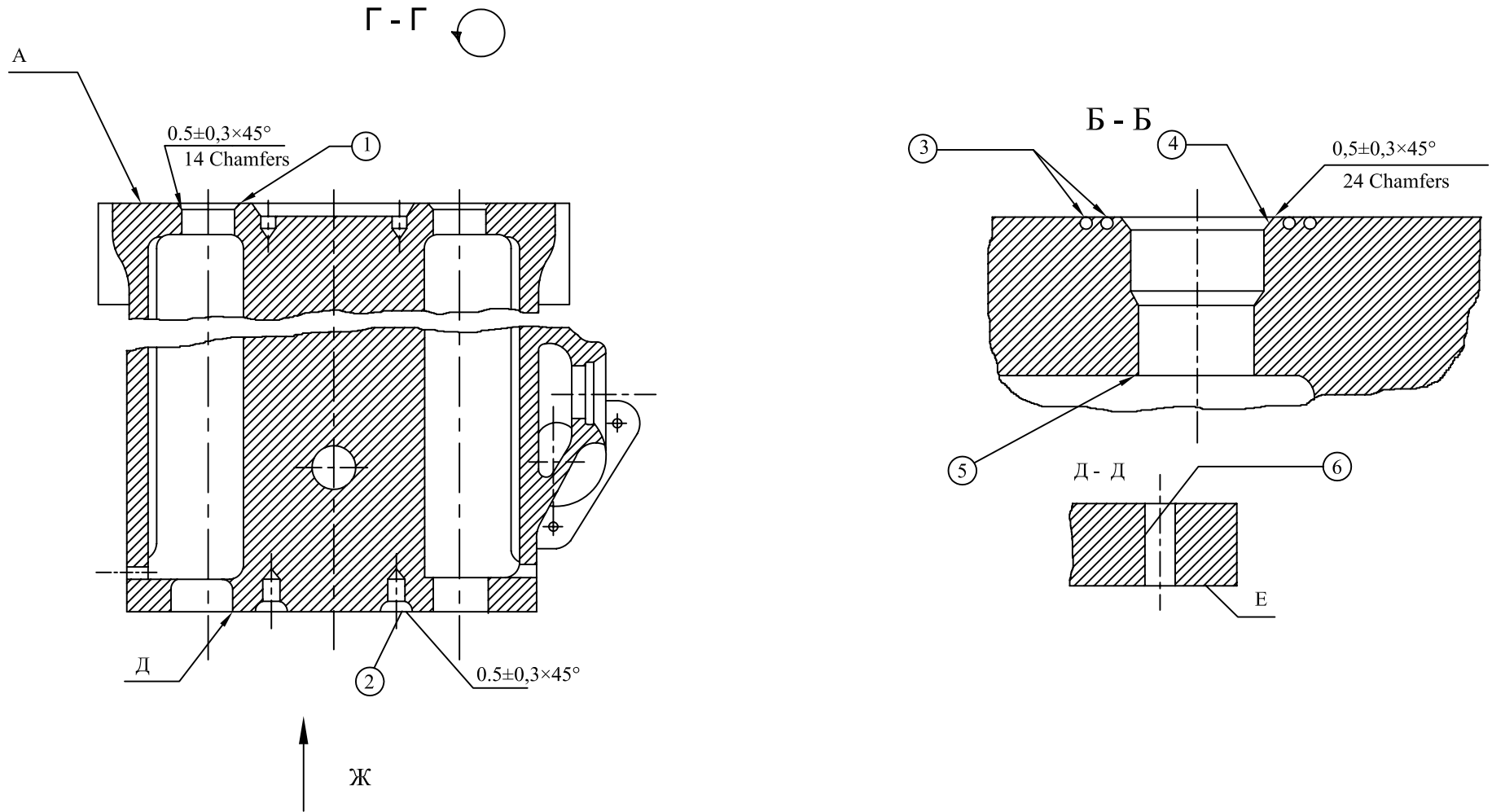


F - 90  $\frac{148}{176}$

sb 303-06-24, sb 303-05-9  
sb303-03-16, sb303-02-23

7

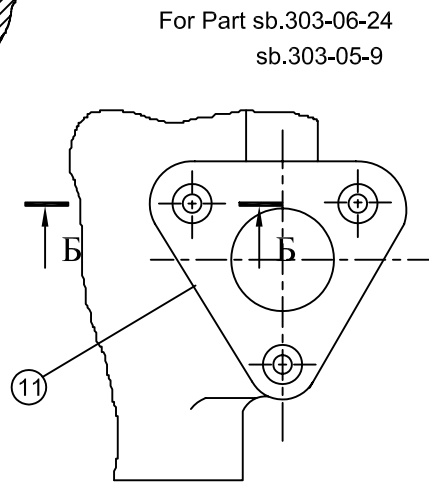
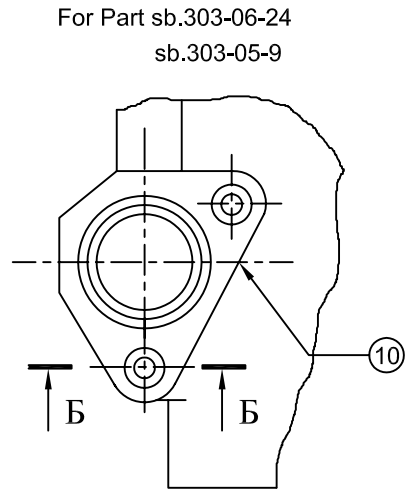
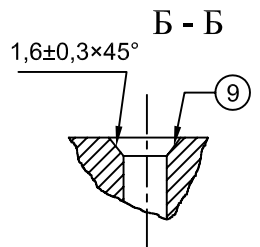
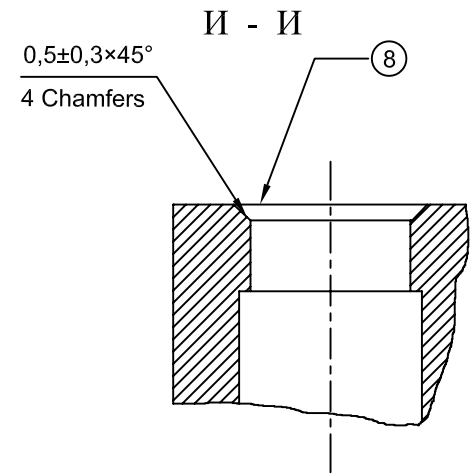
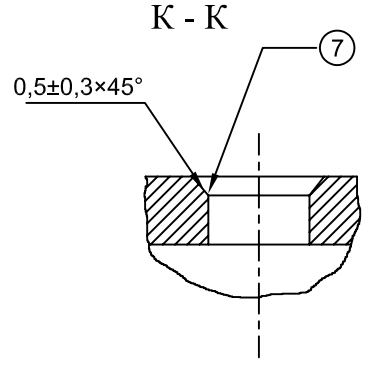
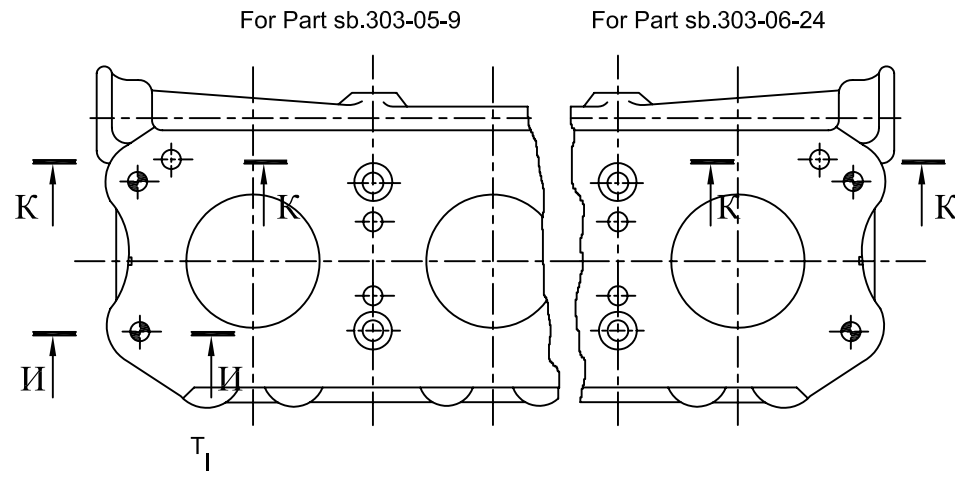
150



F - 90  $\frac{149}{176}$

sb 303-06-24, sb 303-05-9  
 sb303-03-16, sb303-02-23

8  
 150



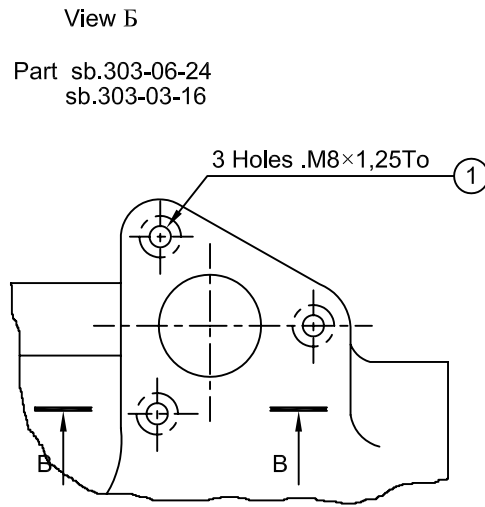
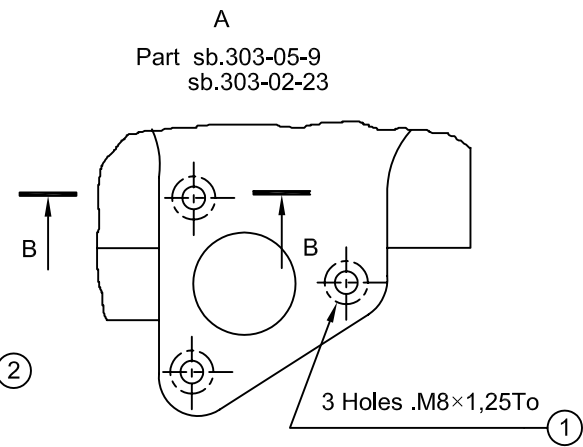
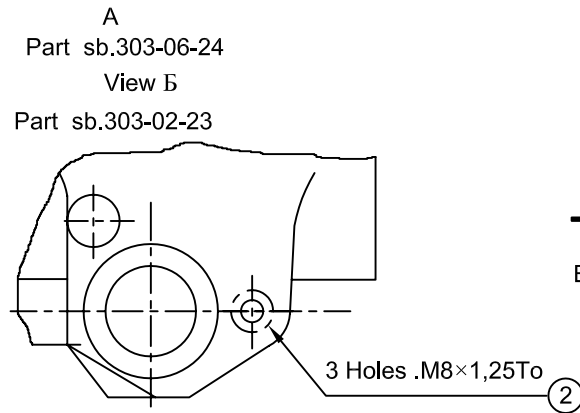
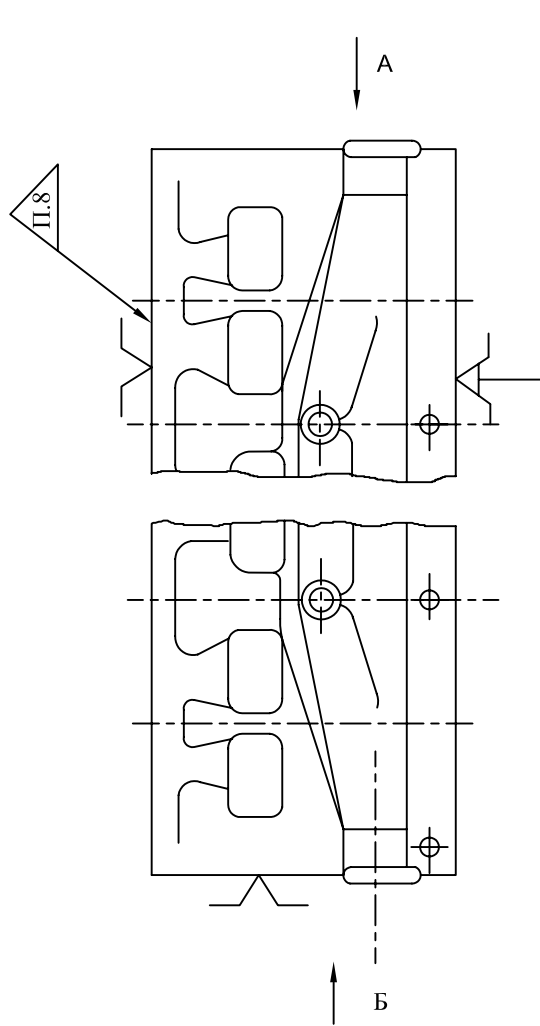
													6	1
										cb.303-06-24 ,cb.303-05-9 cb.303-02-23,cb.303-03-16				
										Cylinder jacket				155
01	Code, nomenclature of operation					Marking document					МИ			
	Fitting					ИОТ No 173								
02						Code, nomenclature of equipment					ТВ	ТО		
						Bench					2.74	3		
K/M	Nomenclature of parts, assembly unit or material					Code, marking			ОПП	ЕВ	ЕН	КИ	Нрарх	
P														
03														
04	1. Install the part and fasten.											0,7		
05														
06	T9698-16328					Fixture								
07														
08	2. Clean 3 holes, from dirt and scraps with													
09	dry compressed air.											0,38		
10														
11	3-001-01					Air gun (step.5)								
12														
13	T9698-23347					Screen (step.5)								
14														
15	3. Make thread in 3 holes and maintain the dimension												0,76	
													F-90	
OK	Operation chart											151/176		



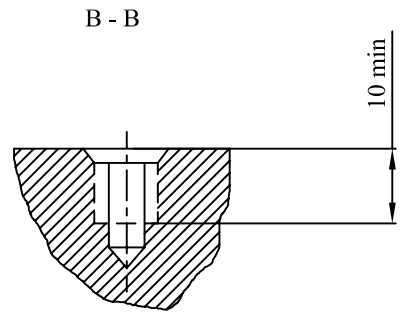


													4		
										cb.303-06-24 ,cb.303-05-9 cb.303-02-23,cb.303-03-16			155		
K/M	Nomenclature of parts, assembly unit or material					Code, Marking					ОПП	ЕВ	ЕН	КН	Ирарх.
P															
01															
02	Examiner to be check the thread holes														
03	during shift change.														
04															
05															
06															
07															
08															
09															
10															
11															
12															
13															
14															
15															
16															
17															
													F-90		
OK	Operation Chart													154/176	

										sb 303-06-24, sb 303-05-9		5
										sb303-03-16, sb303-02-23		155



															sb 303-06-24,sb 303-05-9			6	
															sb303-03-16,sb303-02-23			155	





															2
										C6.303-06-24 ,c6.303-05-9 c6.303-02-23,c6.303-03-16					160
K/M	Nomenclature of parts, assembly unit or material					Code, Marking					ОПП	ЕВ	ЕН	КН	Нрарх.
P															
01	3. Clean 3 holes (1) from dirt and scraps														
02	with dry compressed air.													0,18	
03															
04	T9698-23347					Screen									
05															
06	3-001-01					Air gun									
07															
08	4. Fasten 3 studs in the hole (1)													0,36	
09															
10	4-B9169-5					Stud fitting key									
11															
12	4-C1229-39					Socket wrench									
13														0,2	
14	5. Rotate the fixture														
15															
16	5. Clean one hole (2) from scraps														
17	with dry compressed air.													0,1	
															<b>F-90</b>
OK	Operation Chart													<b>158/176</b>	



											sb 303-06-24, sb 303-05-9 sb303-03-16, sb303-02-23					4	
																160	

