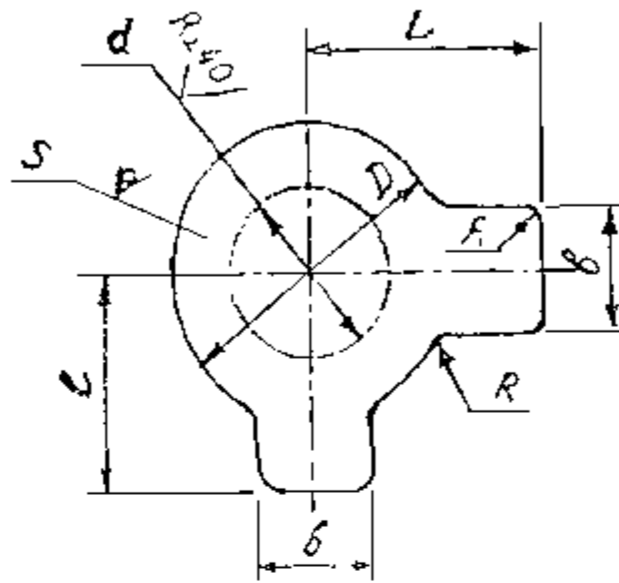


672-31-71

R2320



TECHNICAL CONDITIONS

1. Alternate material is steel 08k11 10kn, GOST 1050-74.
2. Unspecified limit deviations are ± 0.5 mm
3. Misalignment of circumference D with respect to hole d and asymmetry of tabs with respect to axis of hole d should be 1mm.
4. Coating: Zinc-plated, 9 microns thick, chromated
Remove hydrogen embrittlement.

- Ⓐ ALTERNATE MATERIAL - STEEL Gde Fe 330 TO IS: 1079-88
- Ⓑ EQ. MATERIAL - COLD ROLLED STEEL SHEET GRADE D/D TO IS: 4030-74
- Ⓒ EQ. MATERIAL - STEEL GRADE - 'D' TO IS 513-86 FOR 672-31-71-02 AND 672-31-71-03.

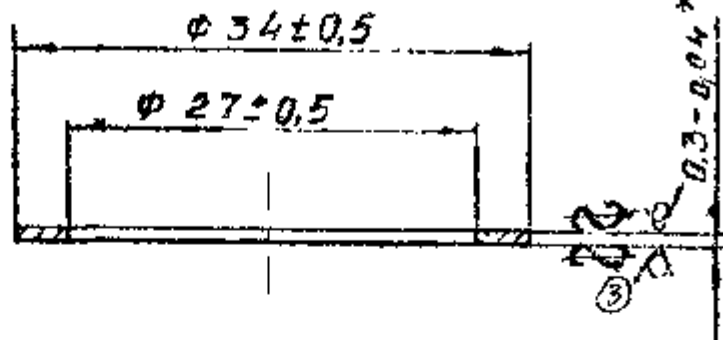
Designation	d, MM	D, MM	L, MM	I, MM	B, MM	S, MM	R, MM	Mass in Kg
672-31-71	6.4 ^{+0.36}	14	15	10	6	1	2	0.002
-01	8.4 ^{+0.36}		18	12	7			0.002
-02	10.5 ^{+0.43}	18	20	14	8	1.5	2	0.002
-03	13 ^{+0.43}	22	25	20	10			0.005

		00862-ICV 31 MAY 01	Ⓒ	EQ. MATERIAL ADDED.
GOLD ROLLED STEEL SHEET Gde 'D' TO SPEC. IS:4030-75		00769-ICV 7 MAR 2000	Ⓑ	EQ. MATERIAL ADDED.
NEAREST EQ. MATERIAL		00561-ICV 14 MAY 95	Ⓐ	ALTERNATE MATERIAL ADDED. (1/96 N OF A)
STEEL 10 GOST 1050-74		DC(I)No. & DATE	ISSUE	AMENDMENTS
ORGL MATERIAL:-				
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART No. MANUFACTURER'S NAME & YEAR OF MFR.		
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:		
SCALE: -	DATE: 09 MAR 90			
DRN.	WT :- (Kg)	672-31-71 TAB WASHER		
TCD.	SEE TABLE			
CHD APPD				
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				

THE ABBRIVATIONS AND SYMBOLS ARE BASED ON RUSSIAN SPECIFICATIONS.

ALL DIMENSIONS ARE IN mm.

675-64-306



1. Coating: Chemically phosphate-plating, accelerated chrome-plating with subsequent oiling.
2. Reference size

③ 3. EQUIVALENT MATERIAL IS DD TO IS:1079.

00381 - ICV <i>Amberg</i> 7 JUL 92	③ 10 in 92M	NOTE FOR EQUIVALENT MATERIAL ADDED
DCU) No. & DATE	ISSUE	NATURE
AMENDMENTS		

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

675-64-306

WASHER

TAPE 10-M-0.3 OCT 503-81

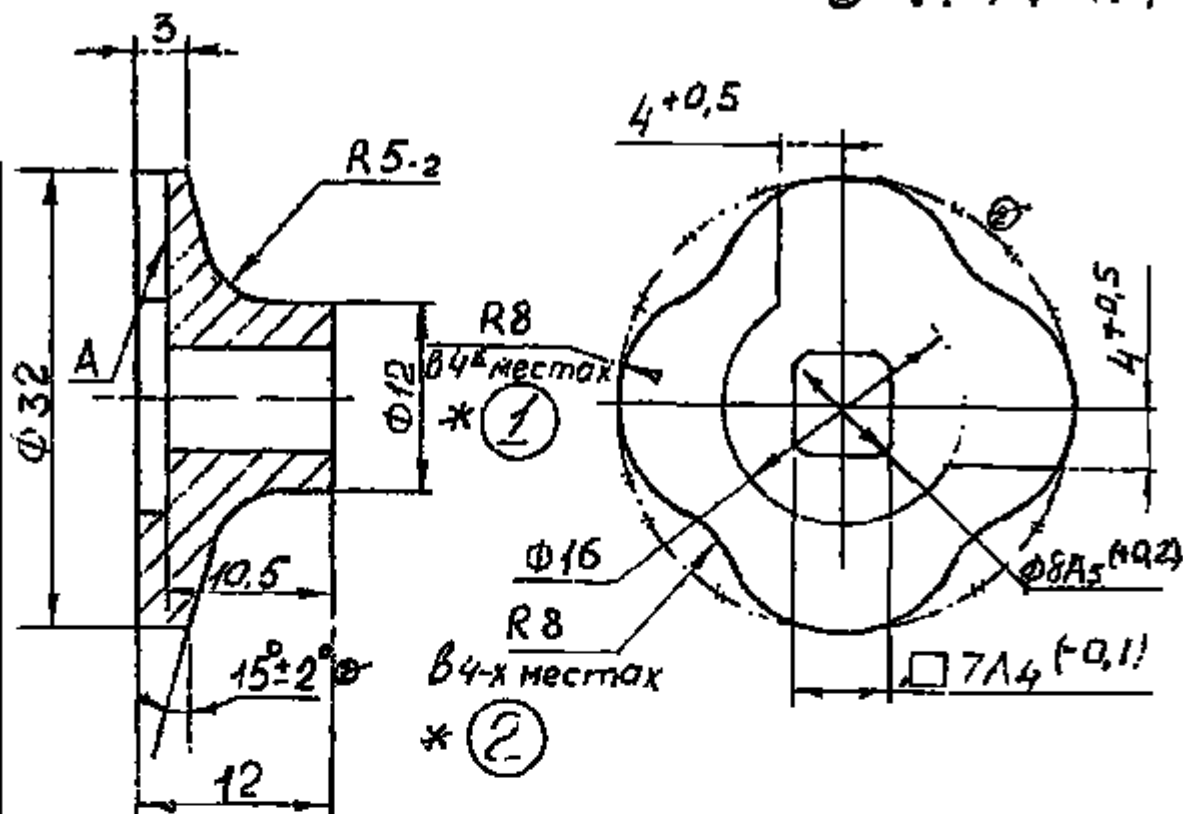
WEIGHT SCALE

0.00078 2:1

SHT 1 SHTS 1

② R_{7.80} ✓(✓) ✓(✓)

0031 - ICV <i>Handy</i> 11 FEB. 92	ISSUE	NATURE
		AMENDMENTS
DCU NUMBER		



TECHNICAL CONDITIONS

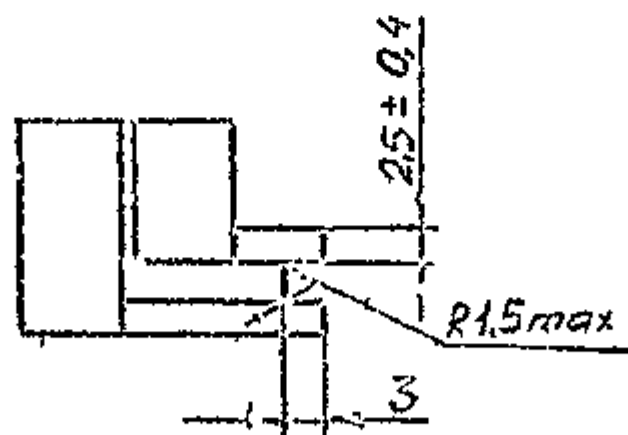
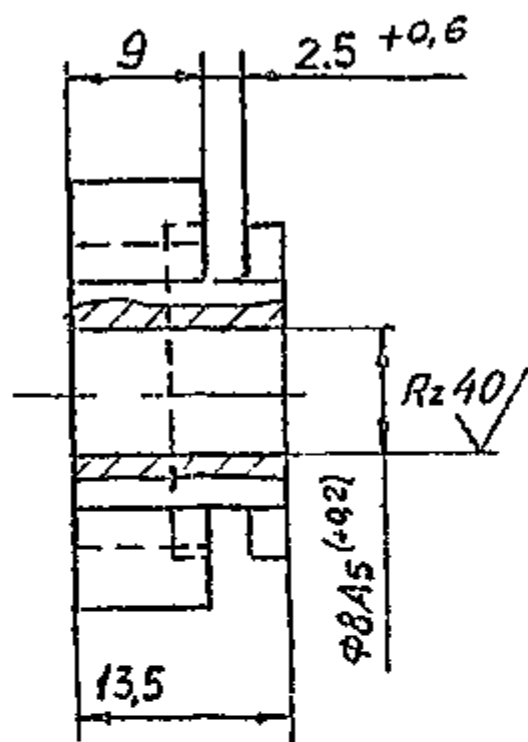
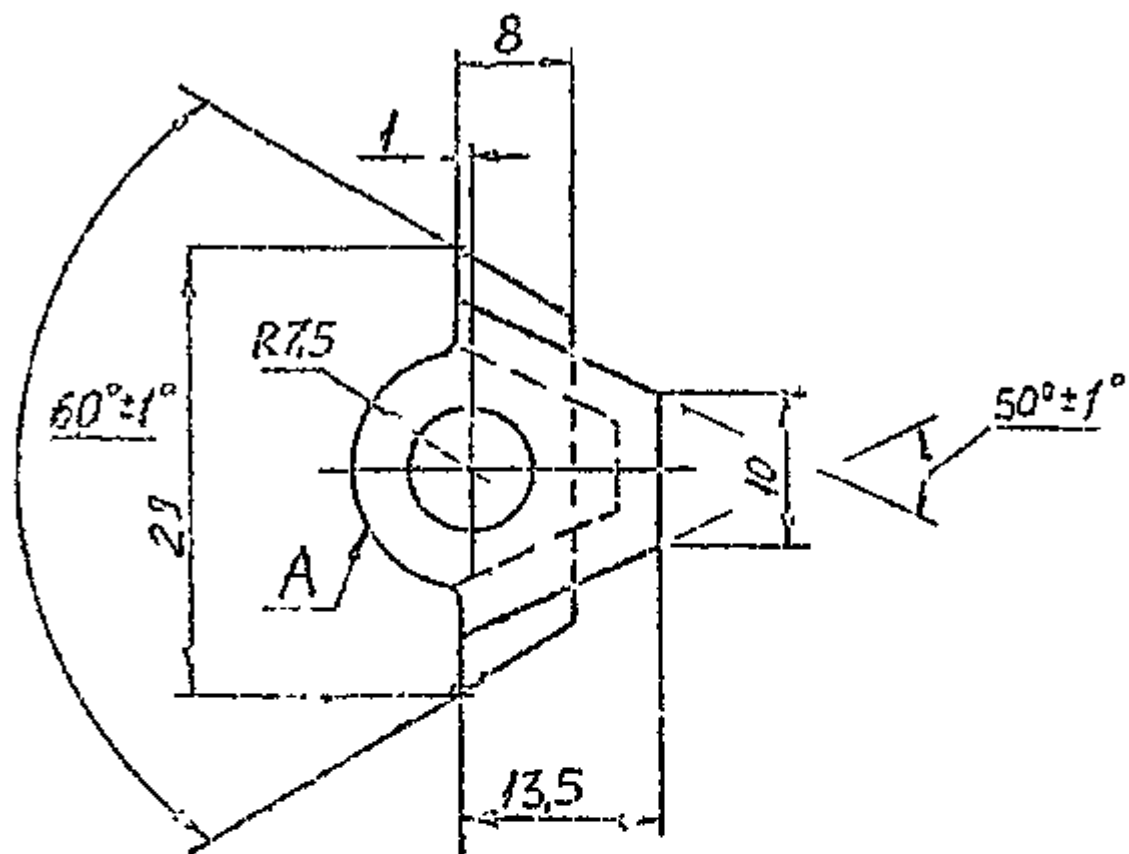
1. Unspecified limit deviations of sizes are as follows: shafts according to B₇, holes according to A₇, other values according to CM₈.
2. Coating: Zink plating 9micron thick with subsequent chromate treatment.
Remove hydrogea embrittlement.

* ① at 4 points

* ② at 4 points

③ 3. ALTERNATIVE METHOD OF MANUFACTURING FROM BAR TO 40Cr4 Mo3 TO IS:5517.

APPROVED <i>[Signature]</i>	675-64-640		
CHECKED <i>[Signature]</i>			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	HANDLE	WEIGHT	SCALE
		0.02	2:1
		SHT	SHTS
	ЖГр 0.5-6.5 TY 3-624-76		



TECHNICAL CONDITIONS

1. HRC 27 to 35. Test group 3 according to OCT 3-4704-80. It may be tested against reference casting.
2. Substitute material is steel 40XL, TOCT 977-75.
3. Drafts should not exceed 2°.
4. Casting radii should not exceed 2 mm unless otherwise specified.
5. Unspecified limit deviations of sizes obtained after casting are according to accuracy class 2, TOCT 2009-55.
6. Imprint and traces of pattern poor soldering 0,3 mm deep are tolerable.
7. Gate projection of not more than 0,5 mm on surface A is tolerable.
8. The rest of the requirements for the casting are according to OCT 3-4365-79.
9. Coating: zinc plating followed by chromate treatment, zinc coat 24 microns thick. Eliminate hydrogen brittleness.
10. *Casting 35XTCR-I, OCT 3-4365-79.

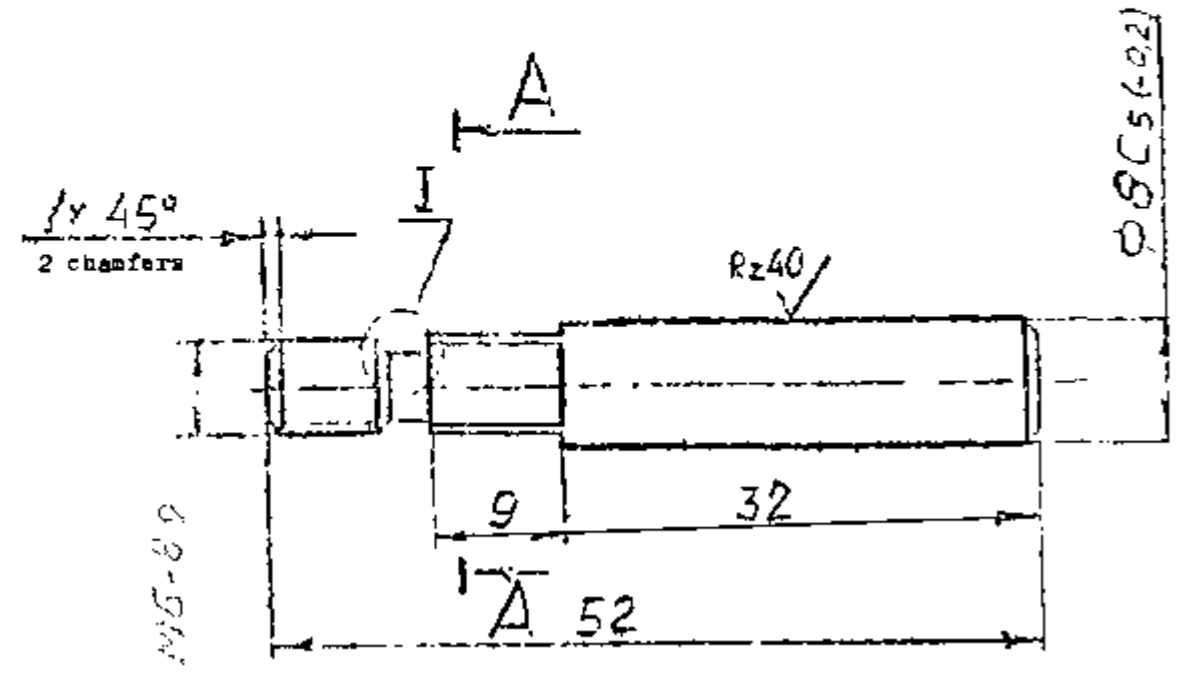
APPROVED		675-64-691	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		WEIGHT	SCALE
		0.023	2:1
CASTING*		SHT 1	SHTS 1

675-64-692

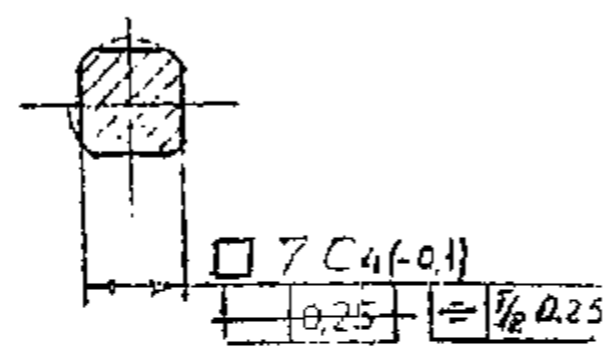
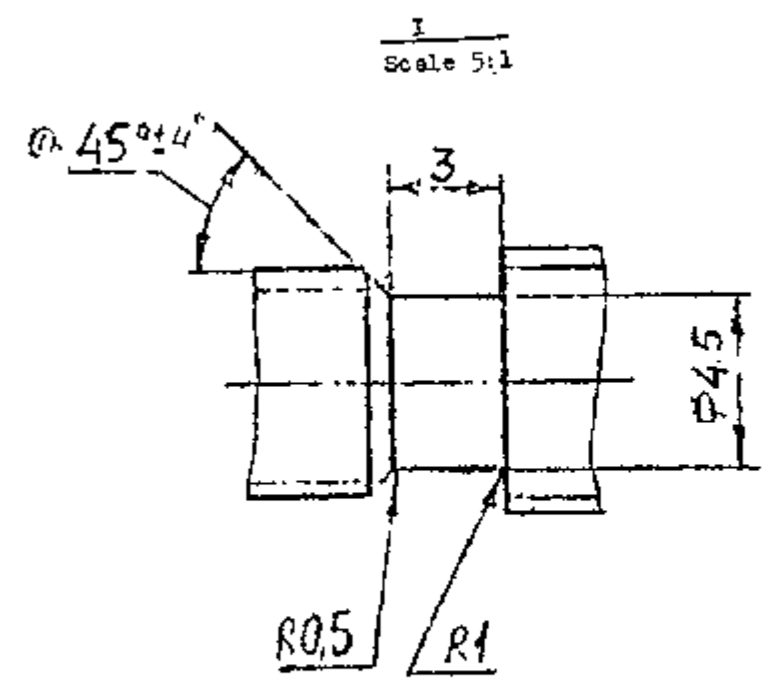
TECHNICAL CONDITIONS

Rz80
✓(✓)

1. HB 255 to 302 (dis 5.8 to 3.5) or HRC 22 to 29.5. Test group 3 according to OCT 3-1163-72.
2. Substitute material is steel 40X, TOCT 4543-71.
3. Unspecified limit deviations of sizes are as follows: holes according to A₇, shafts according to B₇, other values according to CM₃.
4. Coating: zinc plating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness.



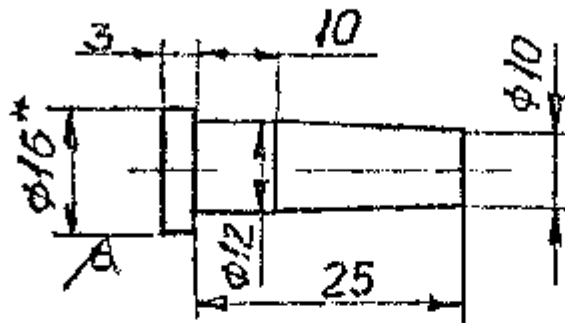
A-A



APPROVED	<i>[Signature]</i>	675-64-692	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	STEEL 45X, TOCT 4543-71	WEIGHT	SCALE
		0.02	2:1
		SHT 1	SHTS 1

675-64-693

Rz 40
✓(✓)



1. Unspecified limit deviations for sizes are as follows: shafts according to D_7 , other values according to CM_{10} .
2. * Size for reference.

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

675-64-693

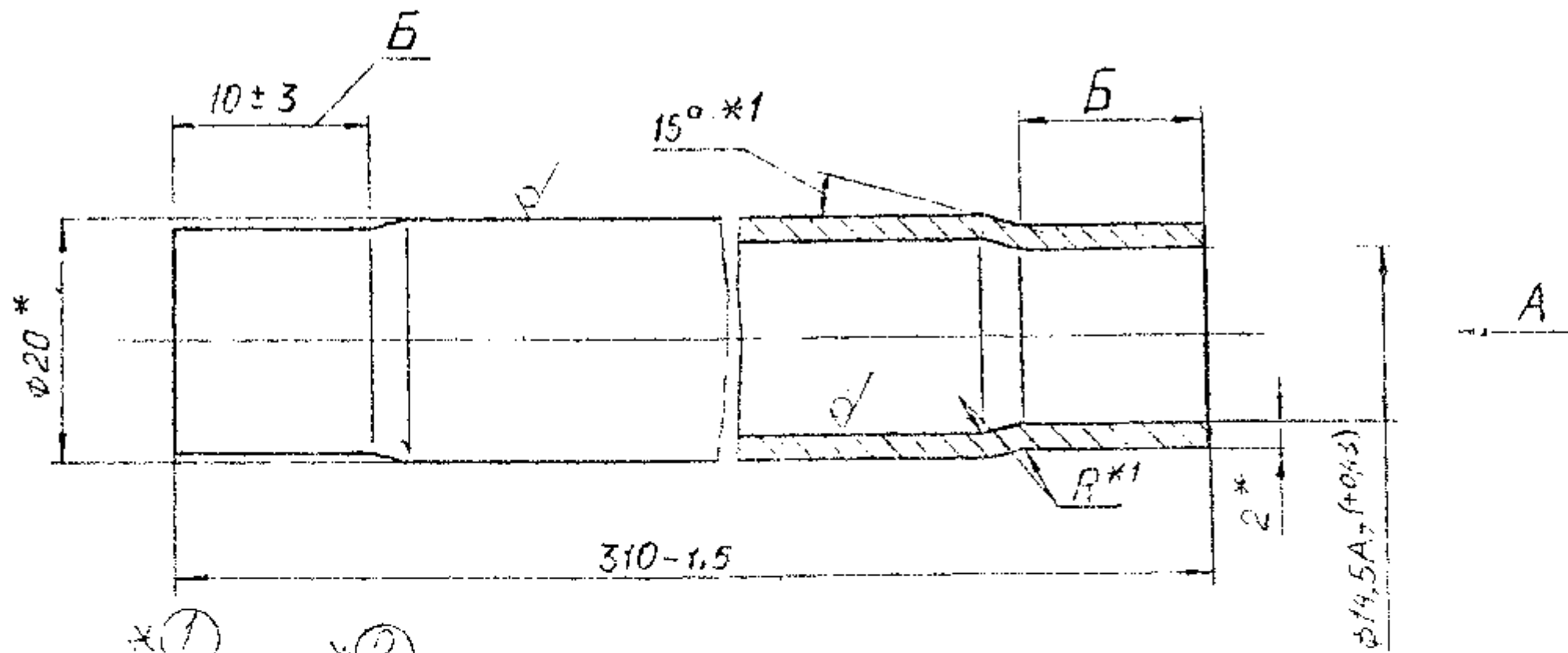
PINTLE

ROUND BAR $\frac{16-5, \text{ГОСТ } 7417-75}{20-Б, \text{ГОСТ } 1051-73}$

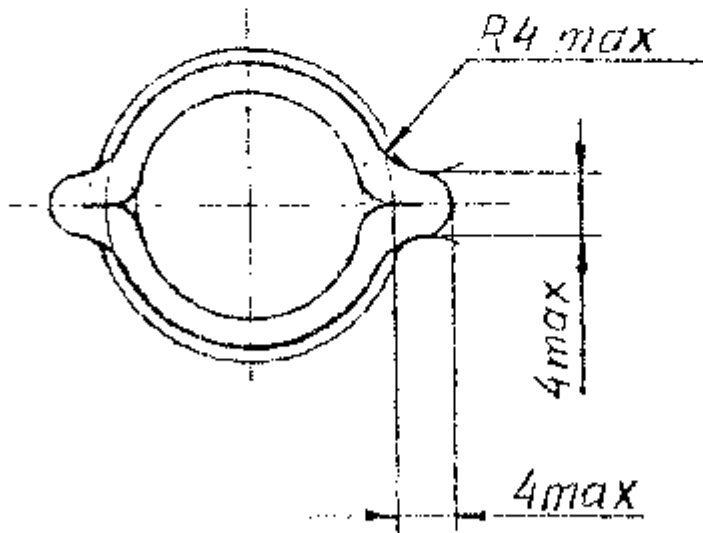
WEIGHT SCALE

0.037 1:1

SHT 1 SHTS 1



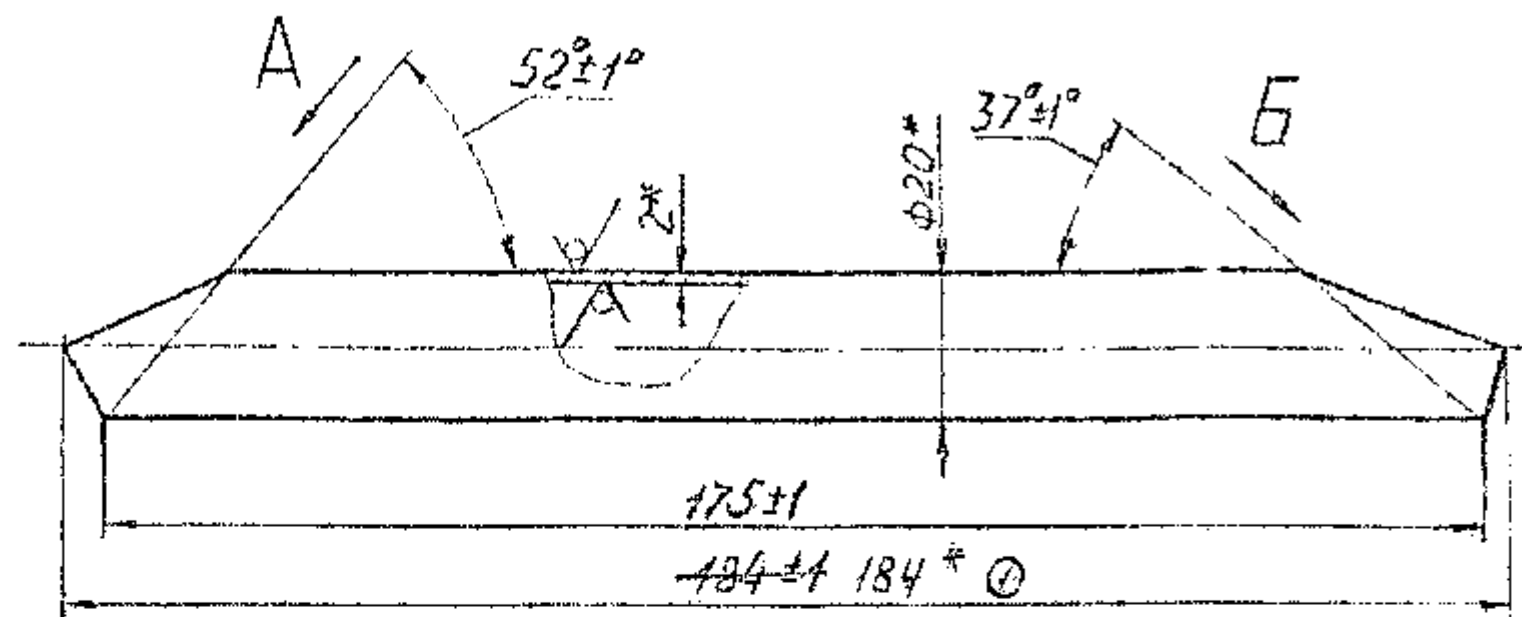
*① Вид А
*② вариант



- * (1) View A
- * (2) Version
 1. Substitute material: tube 20x2, ГОСТ 8734-75
B20, ГОСТ 8733-74
 2. * Sizes for reference.
 3. Squeeze the tube at section E.
 4. * Size for the tools.

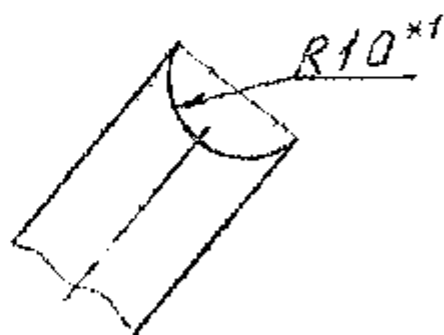
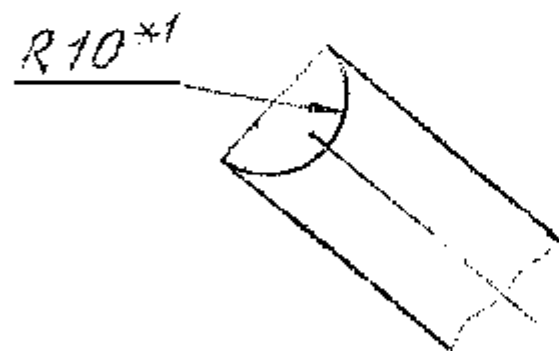
APPROVED		675-64-694	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		TUBE	
		WEIGHT SCALE	
		0.19 2:1	
TUBE 20x2, ГОСТ 8734-75 B10, ГОСТ 8733-74		SHT 1	SHTS 1

RESPI (M)



VIEW-A

VIEW-B

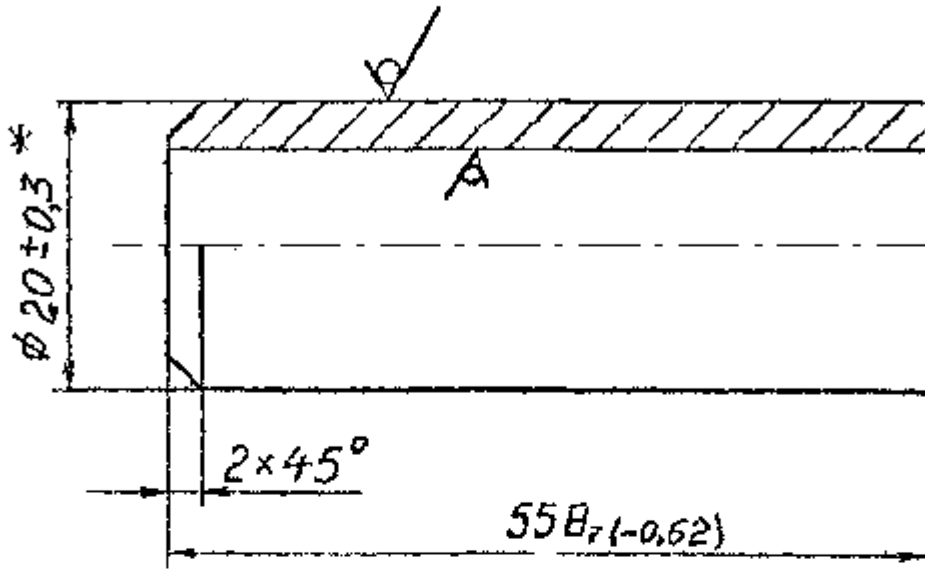


1. Substitute material: tube 20x2, POCT 8734-75
20, POCT 8733-74
2. Limit deviations of sizes are ±0.5 mm unless otherwise specified.
3. *Sizes for reference.
4. *1 Ensure the sizes with the help of tools.

APPROVED		675-64-695	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		JIB	WEIGHT SCALE
			0.1 1:1
		TUBE 20x2, POCT 8734-75 810, POCT 8733-74	SHT 1 SHTS 1

675-64-696

Rz 100
✓ (V)



1. Substitute material: tube 20x4,0, ГОСТ 8734-75
B10, ГОСТ 8733-74
2. *Size for reference.

APPROVED

CHECKED

675-64-696

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

SUPPORT

WEIGHT SCALE

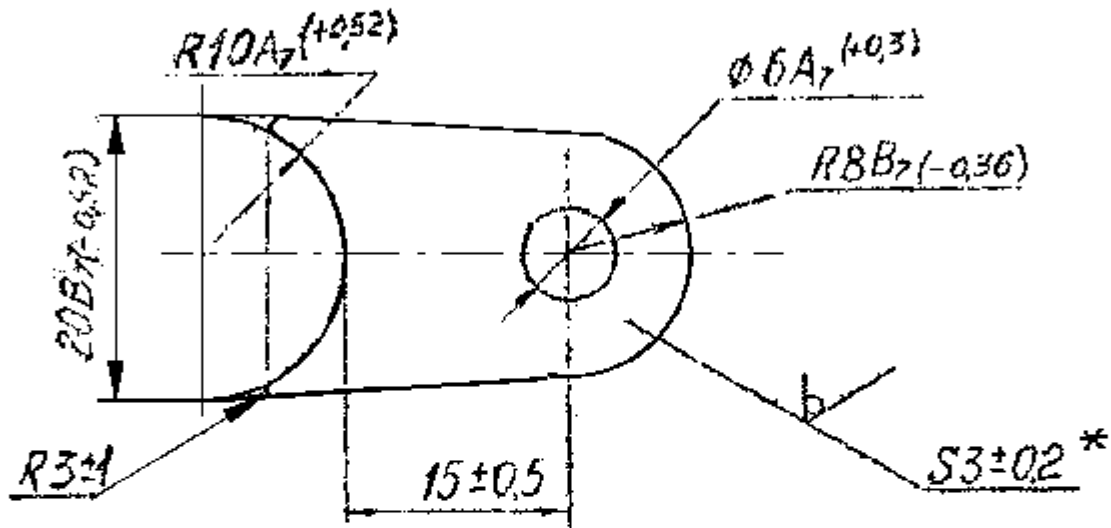
0.063 2:1

SHT 1 SHTS 1

TUBE 20x4,0,ГОСТ 8734-75
B20, ГОСТ 8733-74

675-64-697

Rz 320/
 ✓ (✓)



1. Substitute material: steel sheet E-IV-0-3.0, ГОСТ 19903-74
4-IX-10, ГОСТ 16523-70
2. *Size for reference.

APPROVED

CHECKED

CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

675-64-697

LUG

WEIGHT SCALE

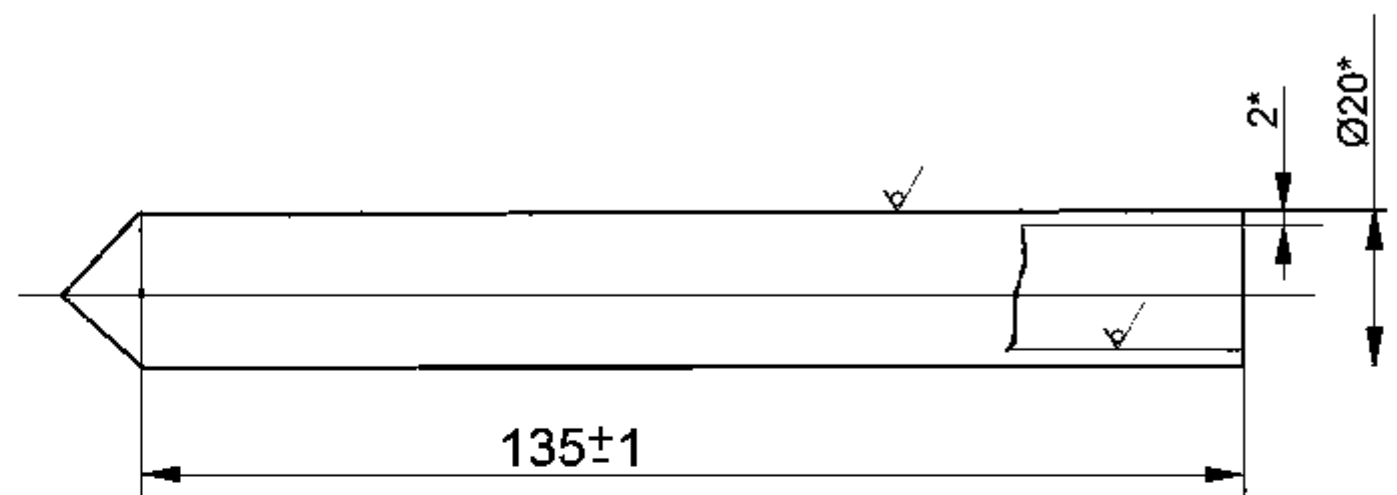
0.005 2:1

SHT 1 SHTS 1

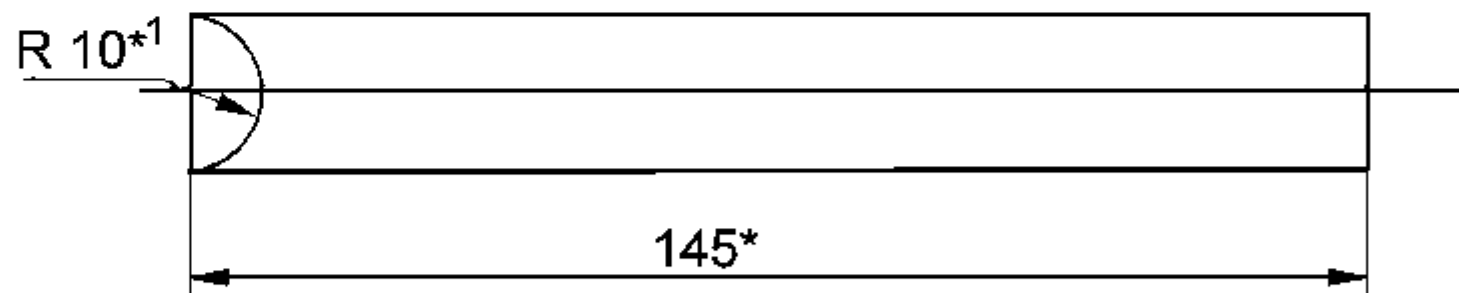
STEEL SHEET E-IV-0-3.0, ГОСТ 19903-74
4-IX-10, ГОСТ 16523-70

675-64-698

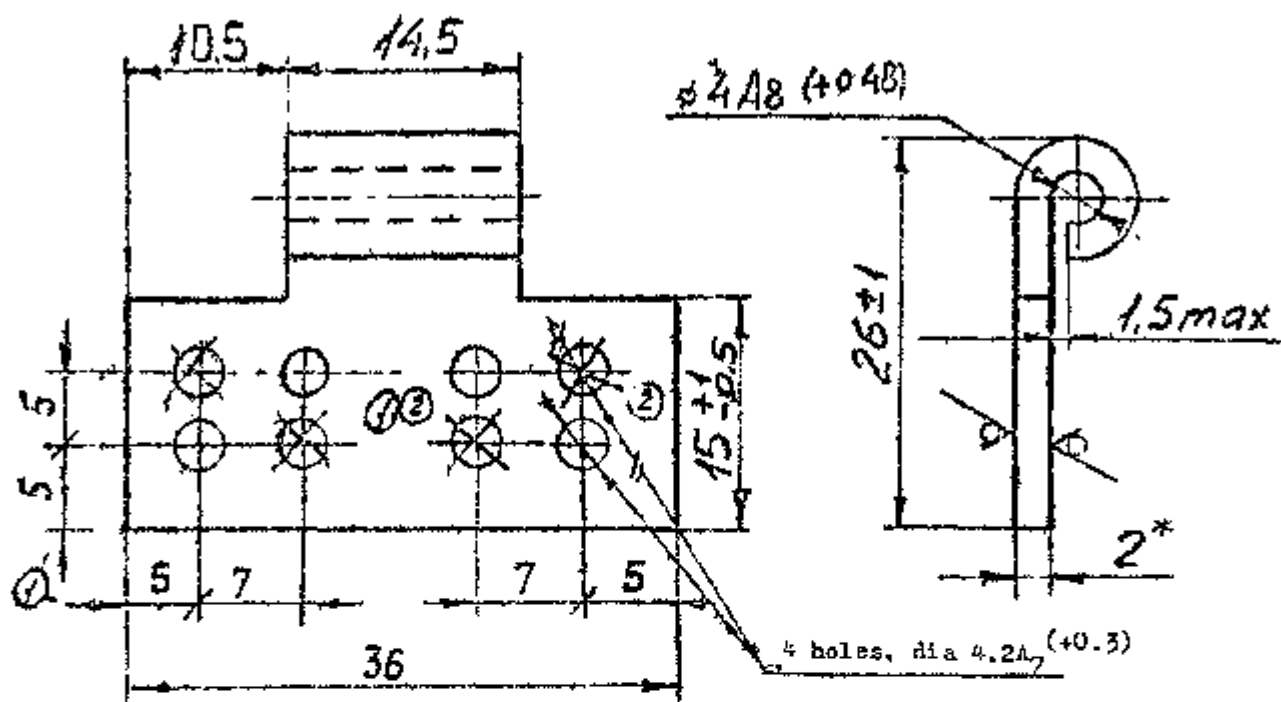
Rz320 ✓ (✓)



1. Substitute material: tube 20x2, POCT 8734-75
B20, POCT 8733-74
2. *Sizes for reference.
3. *¹Ensure the sizes with the help of tools.



APPROVED		675-64-698	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		PILLAR	
		TUBE <u>20x2, POCT 8734-75</u> B10, POCT 8733-74	WEIGHT 0.1
		SHT 1	SHTS 1



1. Substitute material: steel sheet Б-ПВ-0-2, ГОСТ 19903-74
4-И-08КН, ГОСТ 16523-70
2. Limit deviations of sizes are ± 0.5 mm unless otherwise specified.
3. *Size for reference.

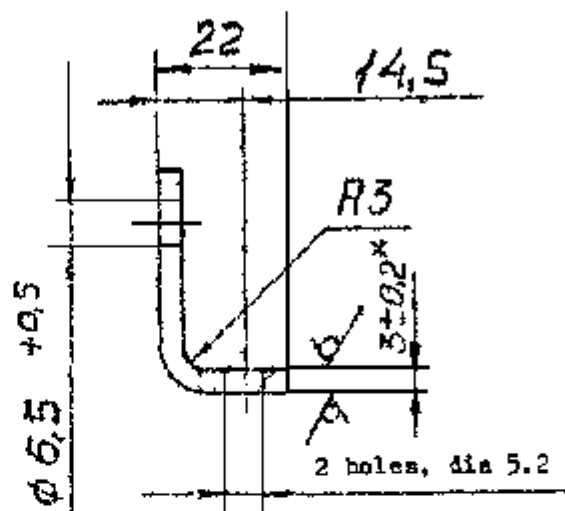
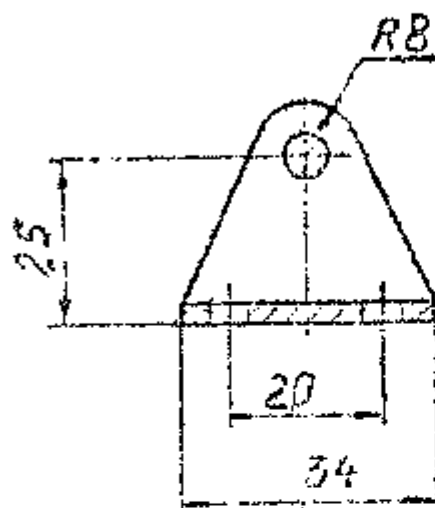
APPROVED
CHECKED
CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

675-64-699

LOWER HINGE

WEIGHT	SCALE
0.018	2:1
SHT 1	SHTS 1

STEEL SHEET Б-ПВ-0-2, ГОСТ 19903-74
4-И-10, ГОСТ 16523-70



1. Substitute material: steel sheets E-IV-0-3.0, ГОСТ 19903-74
E-IV-0-3.0, ГОСТ 19903-74 4-II-15, ГОСТ 16523-70
4-II-25, ГОСТ 16523-70
2. Limit deviations of sizes are ± 0.5 mm unless otherwise specified.
3. *Size for reference.

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

675-64-700

LUG

WEIGHT SCALE

0.022 1:1

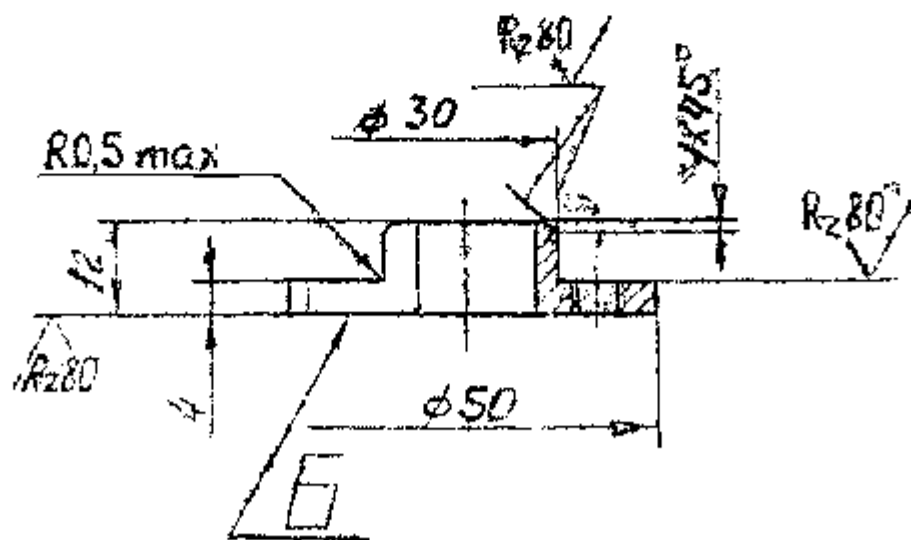
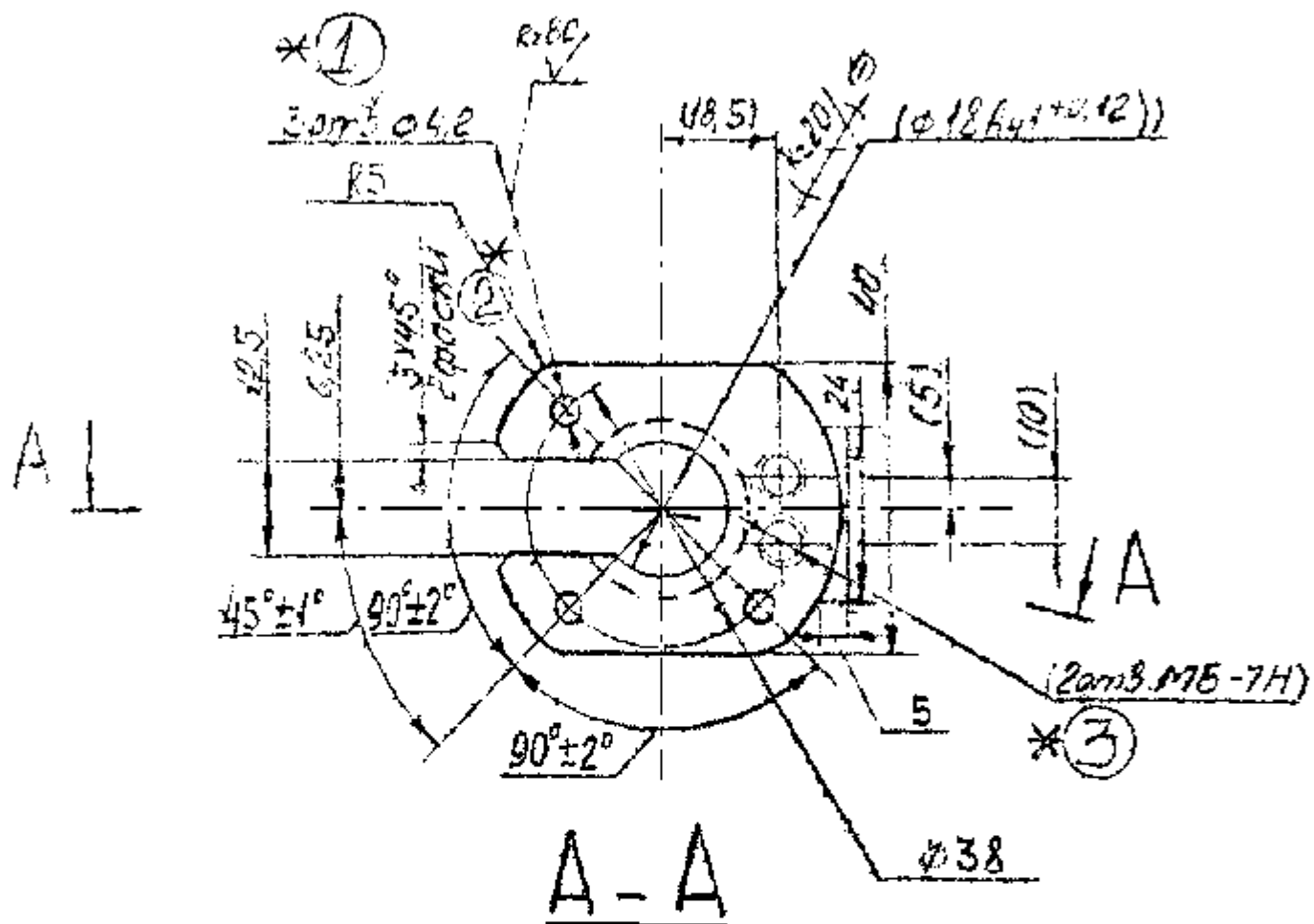
SHT 1 SHTS 1

STEEL SHEET E-IV-0-3.0, ГОСТ 19903-74
4-II-20, ГОСТ 16523-70

R2100 ✓✓

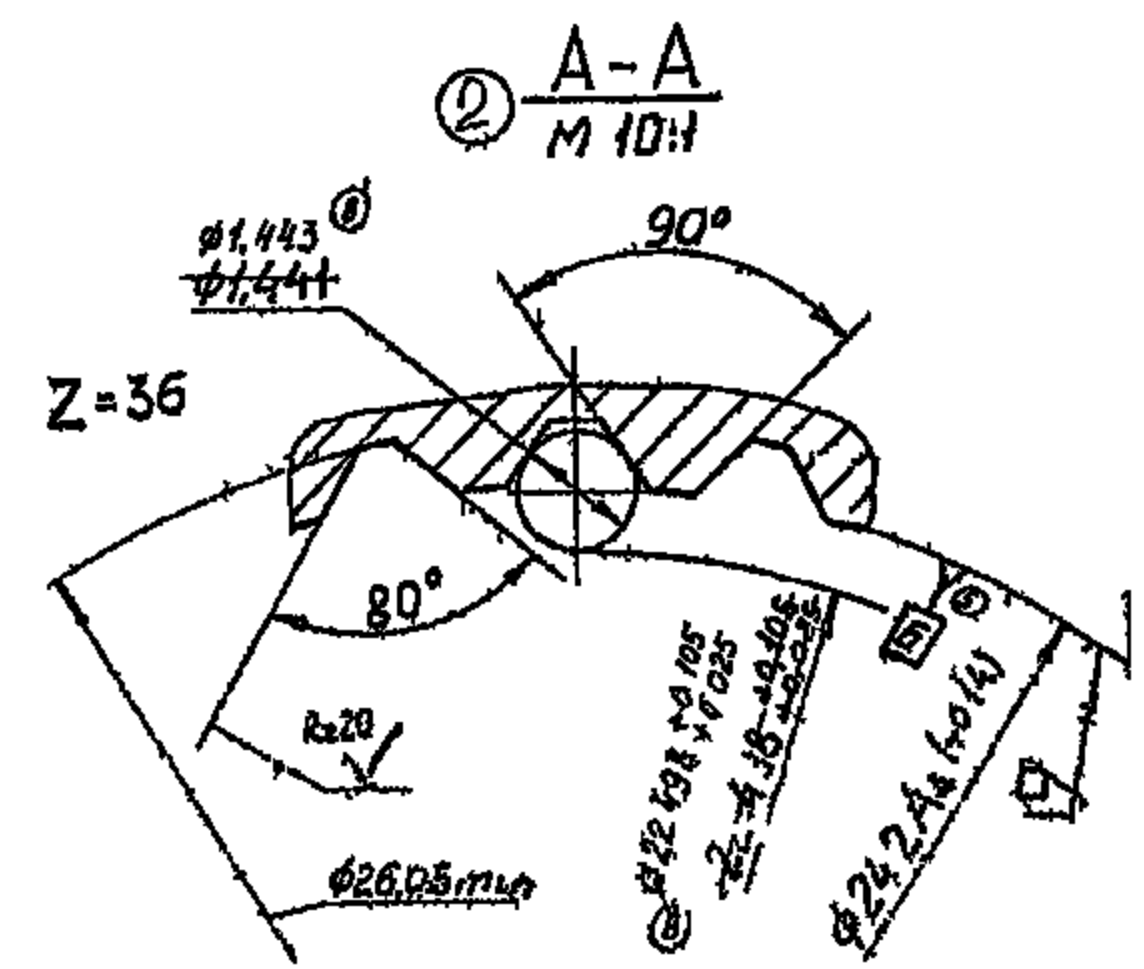
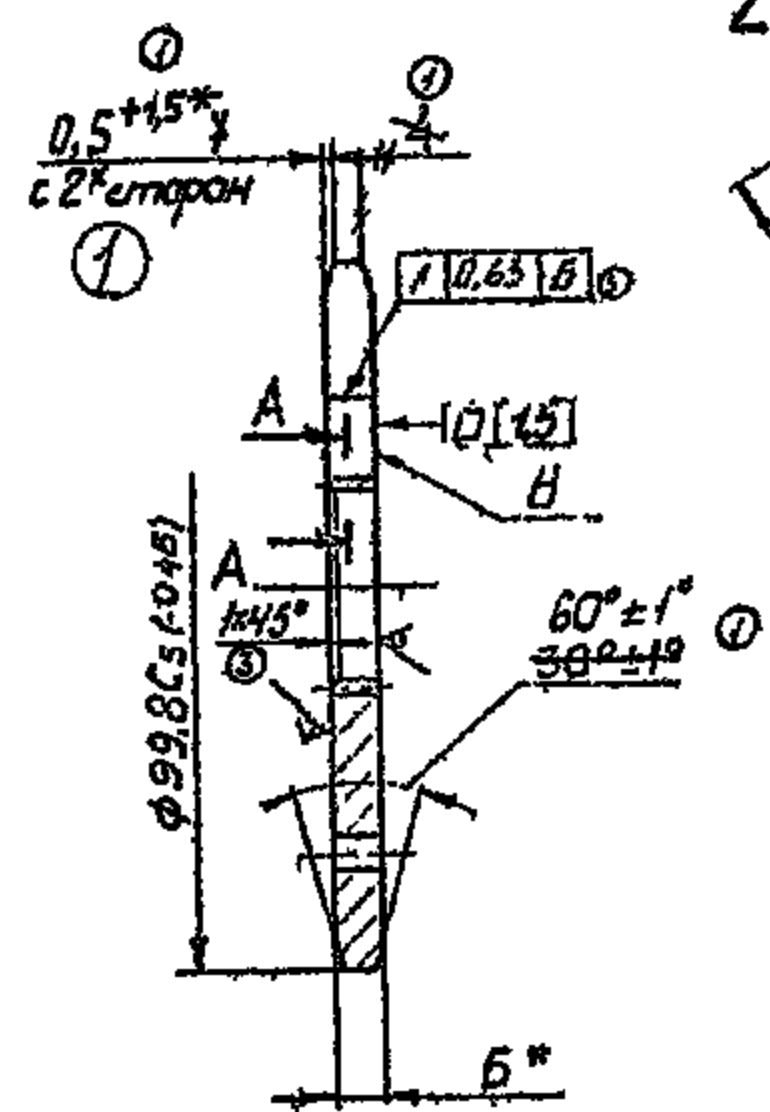
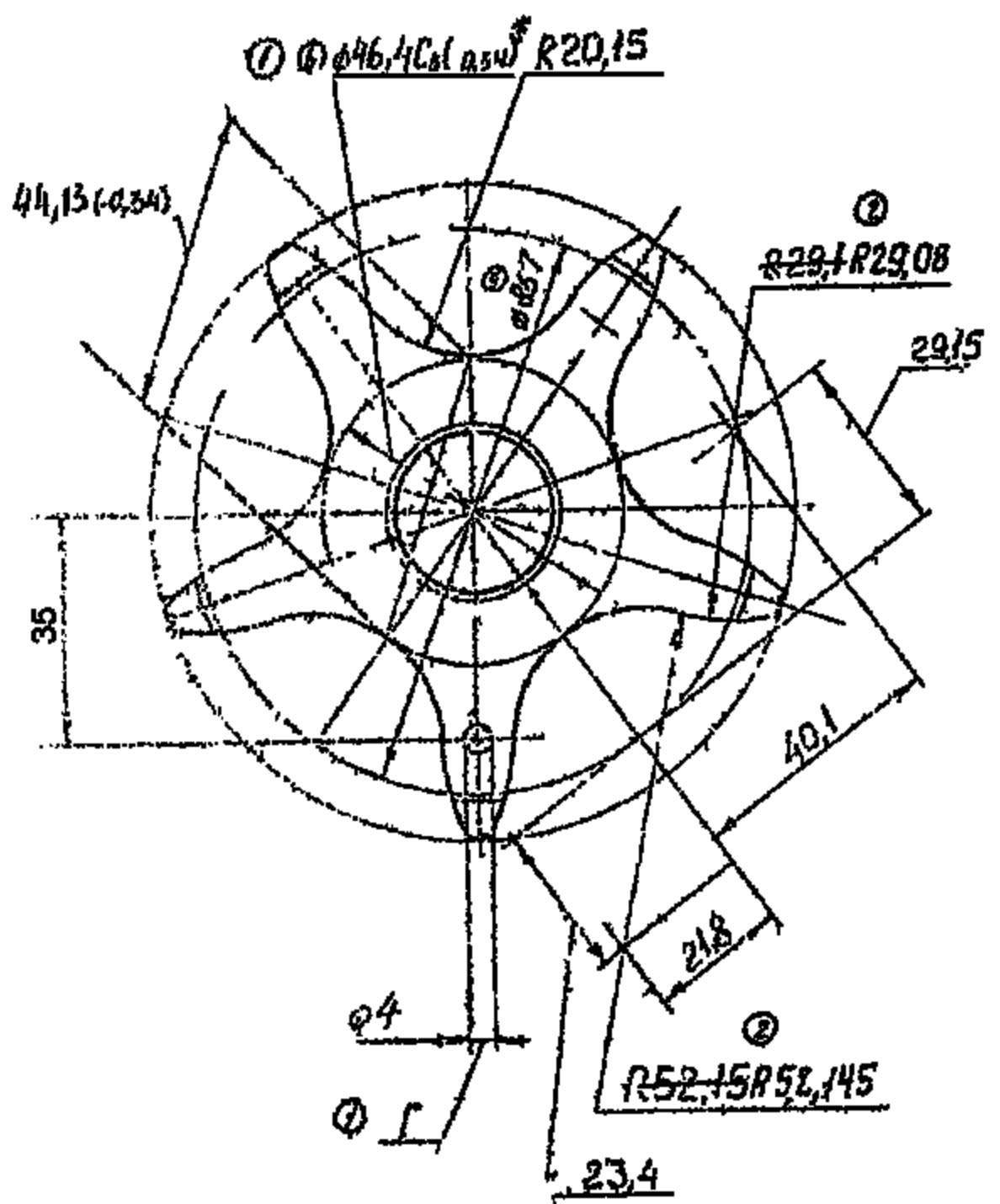
TECHNICAL CONDITIONS

1. Substitute material: steel 45XN, ГОСТ 977-75.
2. HB 225 to 341 (dia 3.8 to 3.4). Test group 3 according to OCT 3-4704-80. Surface E is a place for hardness test.
3. Drafts should not exceed 2° unless otherwise specified.
4. Casting radii should not exceed 2 mm unless otherwise specified.
5. Unspecified limit deviations of sizes obtained by removing a layer of metal are as follows: shafts according to E₇, other values according to G₇.
6. Contour displacement at the mould joint should not exceed 0.3 mm.
7. Imprint and traces of the poor pattern soldering of not more than 0.3 mm are tolerable.
8. The other requirements for casting are according to OCT 3-4365-79.
9. May be manufactured as showed by the thick pin-and-dot line.
10. The sizes given in brackets are the after-assembly sizes.
11. Coating: zinc plating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness.
12. *Casting 40XN-1 OCT 3-4365-79.

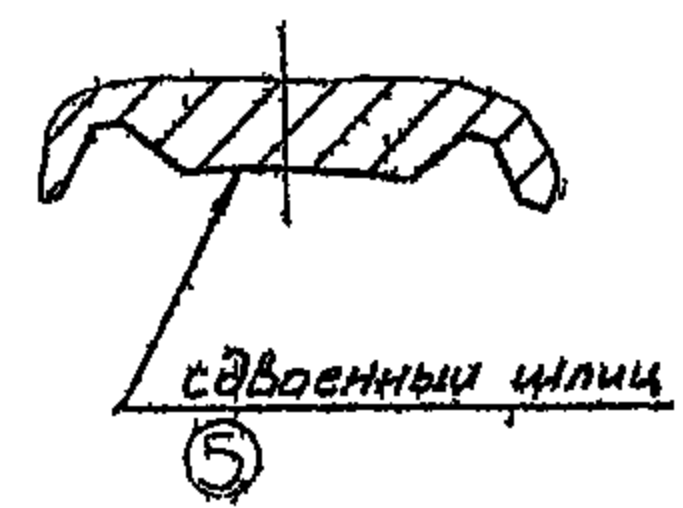


- * (1) 3 holes, dia 4.2
- * (2) 2 chamfers
- * (3) (2 holes M6-7B)

APPROVED		675-64-701	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		WEIGHT	SCALE
		0.049	1:1
CASTING*		SHT 1	SHTS 1



③ A-A M10:1
④ Вариант



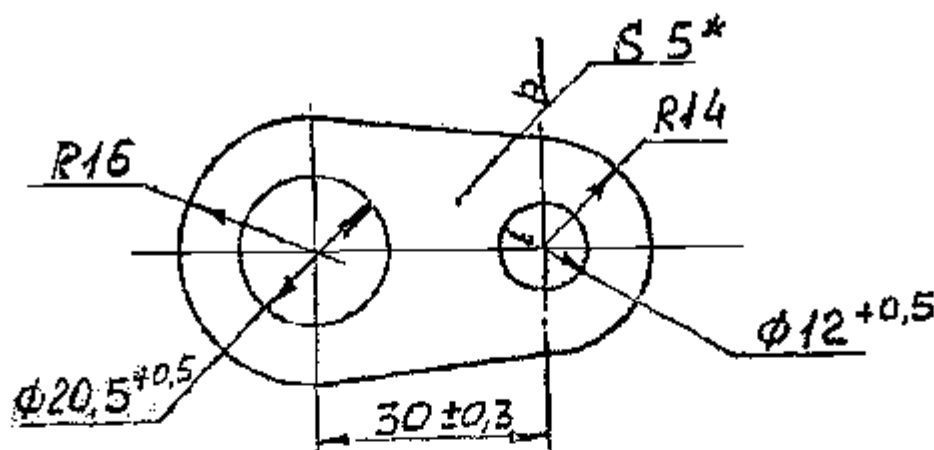
TECH. CONDITIONS

1. HB 285 to 341 (dia 3.6 to 3.3) or HRC 27 to 35. Test group 3 according to OCT 3-1163-72.
2. Unspecified limit deviations of sizes are as follows: shafts according to B₇, holes according to A₇, other values according to C₁₀.
3. Grinding not deeper than 0.5 mm is allowed on surface B to check it for hardness.
4. Turning of the axes of the sprocket teeth relative to the axis of the twin slot (version A - A) or the axis of the slot base (A - A) should not exceed 15' (dependent tolerance).
5. *Size for reference.
6. Coating: zinc plating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness.
7. When manufacturing the part according to A - A version, manufacture mating part 675-64-725 according to B - B version.
8. Presence of auxiliary hole Γ is tolerable.
9. The slotted hole may be checked with the help of a multipurpose gauge having the following dimensions: tooth thickness at pitch circle arc of 1.090₃ mm, major diameter of 25.80₃ mm, minor diameter of 24.0₃ mm.
10. Accuracy class according to ГОСТ 592-69 is 3.
11. Tolerance for pitch difference is 0.32 mm.

- (1) on 2 sides
- (2) A-A Scale 10:1
- (3) A-A Scale 10:1
- (4) Version
- (5) Twin slot

APPROVED	CK
CHECKED	CW
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	

675-64-702			
SPROCKET		WEIGHT	SCALE
		0.16	1:1
		SHT 1	SHTS 1
MATERIAL: Б-ПВ-0-6, ГОСТ 1990376 Steel 65Г, ГОСТ 1957-81			



TECHNICAL CONDITIONS

1. Material substitute: sheet Б-ПВ-0-5 ГОСТ 19903-74, sheet 10 ГОСТ 1577-70, sheet Б-ПВ-0-5 ГОСТ 19903-74, sheet 25 ГОСТ 1577-70.
2. Unspecified limit deviations of sizes are ± 0.5 mm.
3. Size is given for reference
4. Forging bevel and rounding of the edges up to 0.5 mm, max. are tolerable.

- (A) EQ MATERIAL: Fe 410 TO IS: 1079-88
 (B) Fe 410 TO IS: 5986-92

00848-ICV 11-06-1999 <i>[Signature]</i>	(B)	EQ. MATERIAL ADDED.
00699-ICV 14-06-1999 <i>[Signature]</i>	(A)	EQ. MATERIAL ADDED. IN DRAWING
DC(1)No. & DATE	ISSUE	AMENDMENTS

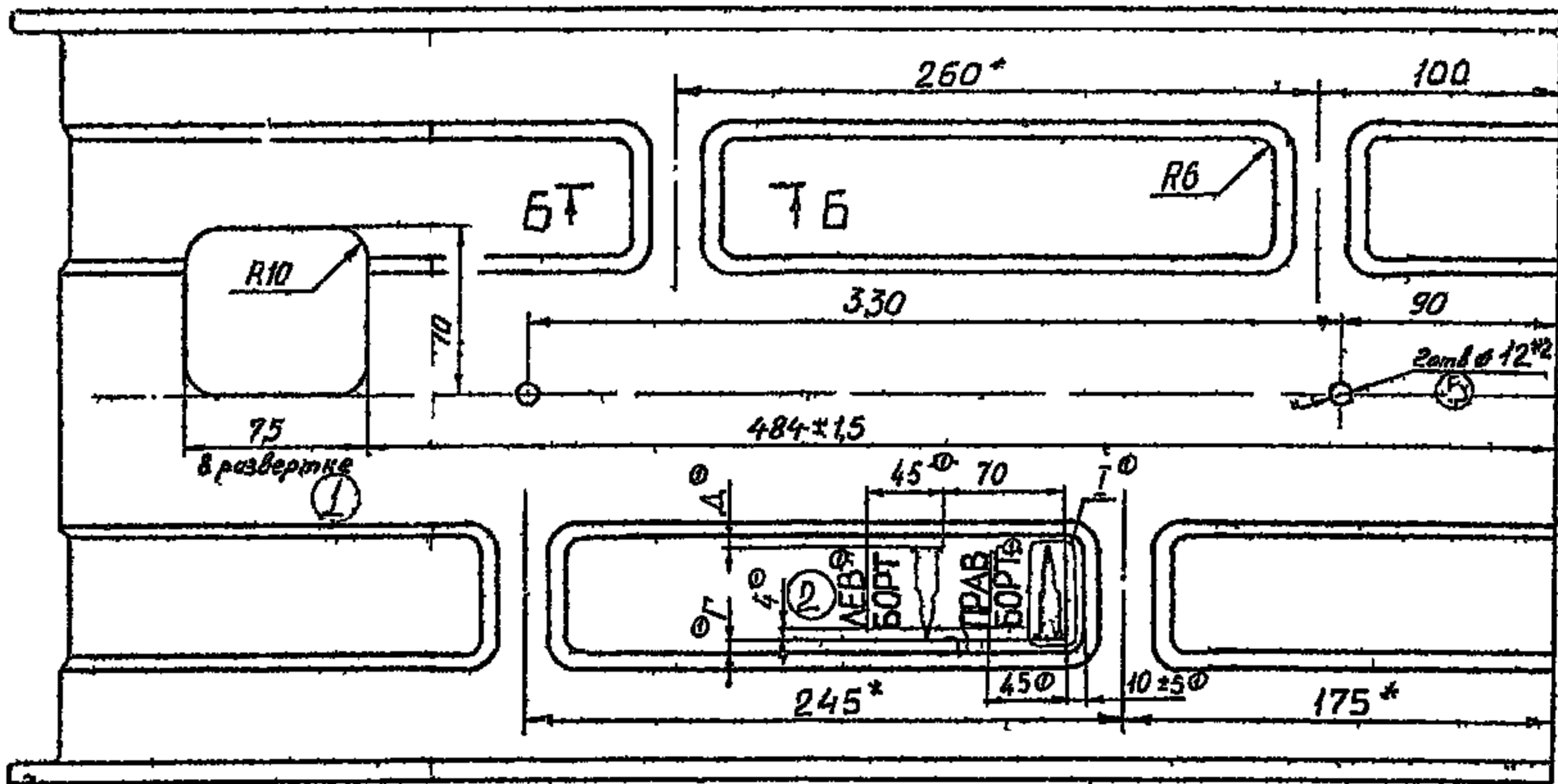
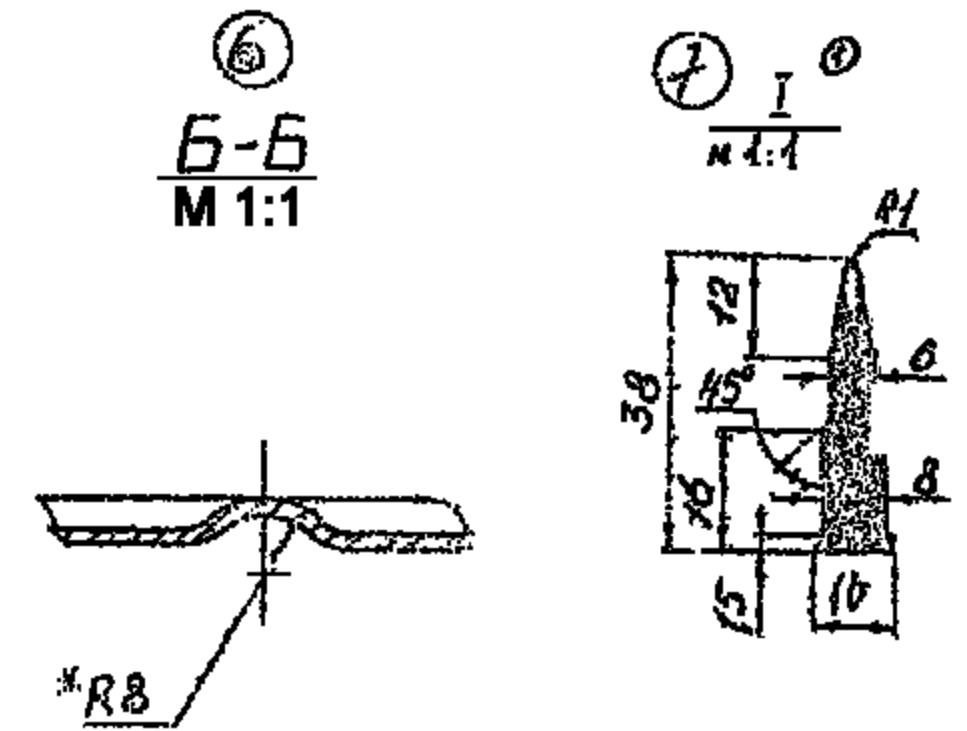
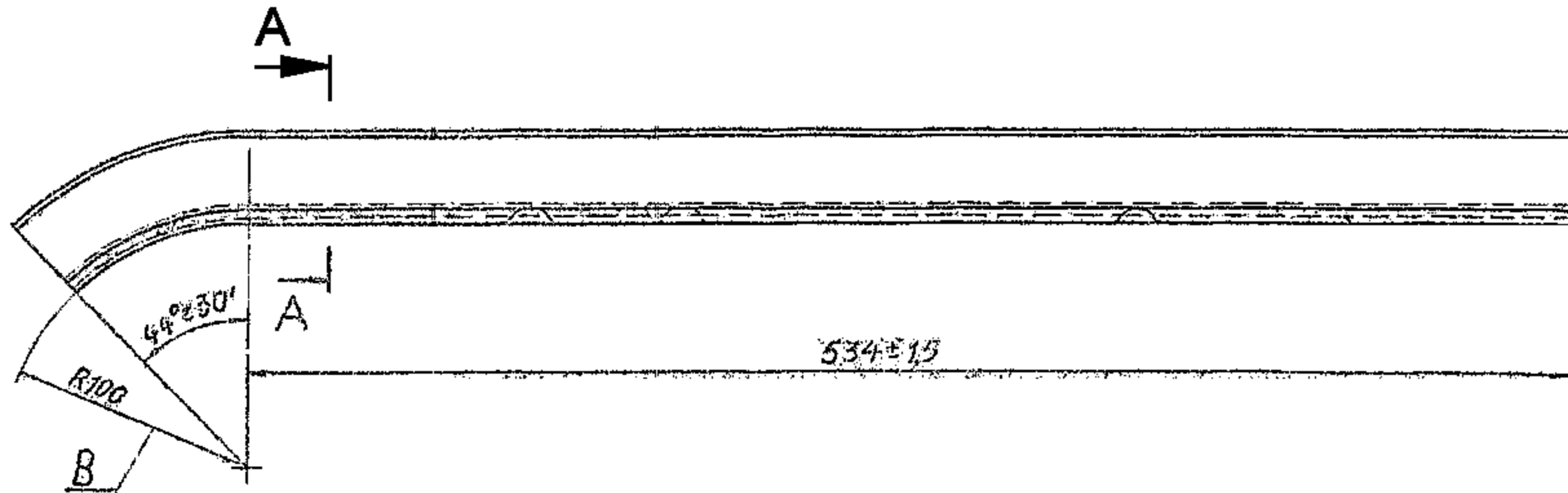
APPROVED
 CHECKED *[Signature]*
 CONTROLLERATE OF QUALITY ASSURANCE (ICV)

675-64-703

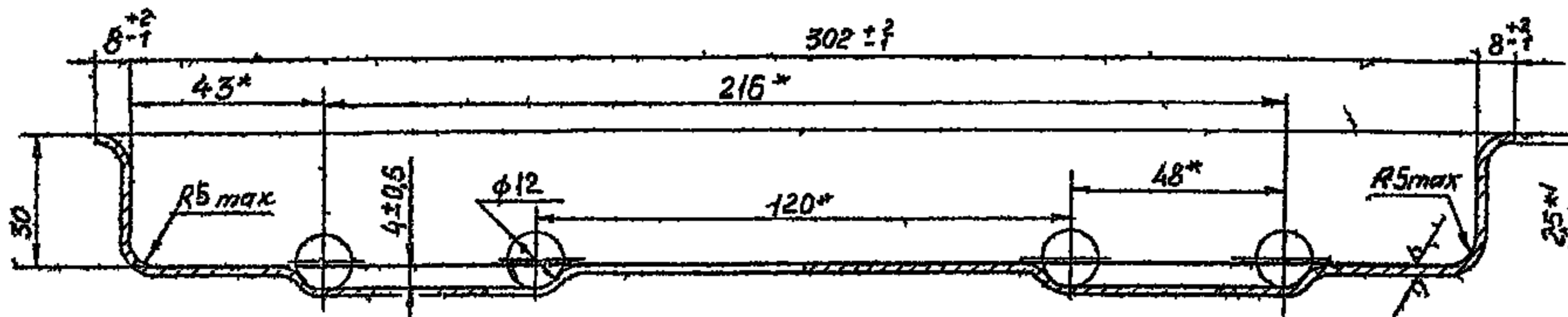
PLATE

WEIGHT	SCALE
0.035	1:1
SHT 1	SHTS 1

SHEET Б-ПВ-0-5 ГОСТ 19903-74
 20 ГОСТ 1577-81



A-A (H)
M 1:1



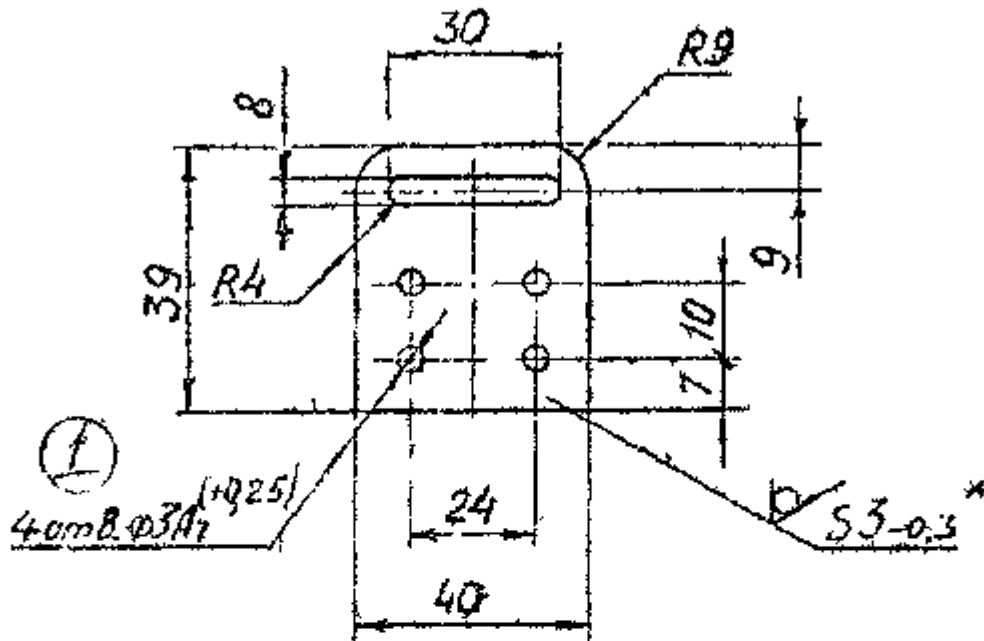
TECH. CONDITIONS

1. Substitute material: sheet AMr6EM-2.5, ГОСТ 21631-76.
2. Limit deviations of sizes are ±1 mm unless otherwise specified.
3. Stamping radii should not exceed 6 mm unless otherwise specified.
4. Tears and cracks with subsequent welding according to ГОСТ 14806-69-03 are tolerable.
5. The requirements for the quality of the welds are according to ГОСТ 5-4001-77 for unspecified welded joints.
6. Corrugation not higher than 0.5 mm at radius B is tolerable.
7. Ensure the sizes with the help of tools.
8. Sizes for reference.
9. Auxiliary holes.
10. Coating: hard anodizing, oxide film 30 to 50 microns thick, with subsequent dichromate treatment.
11. The difference between sizes I and II should not exceed 6 mm.
12. Make inscriptions and symbols on the tray with red enamel ИР-223, ГОСТ 14923-78 using type ИО-10, ГОСТ 2930-62.

- (1) developed
- (2) LEFT SIDE
- (3) RIGHT SIDE
- (4) A-A
- (5) Scale 1:1
- (6) 2 holes, dia 12
- (7) E-E
- (8) Scale 1:1
- (9) I
- (10) Scale 1:1

APPROVED *[Signature]*
 CHECKED *[Signature]*
 CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

675-64-704	
TRAY	WEIGHT SCALE 1.64 1:2
MATL SHEET AMr 65M-2.5, ГОСТ 21631-76	SHT 1 SHTS 1



TECH. CONDITIONS

1. Substitute material: sheet D95-3, ГОСТ 4784-74.
2. Limit deviations of sizes are ± 0.5 mm unless otherwise specified.
3. *Size for reference.

① 4 holes, dia 3A₇ (+0.25)

APPROVED *C. G. G.*
 CHECKED *Armen*
 CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

675-64-705

LUG

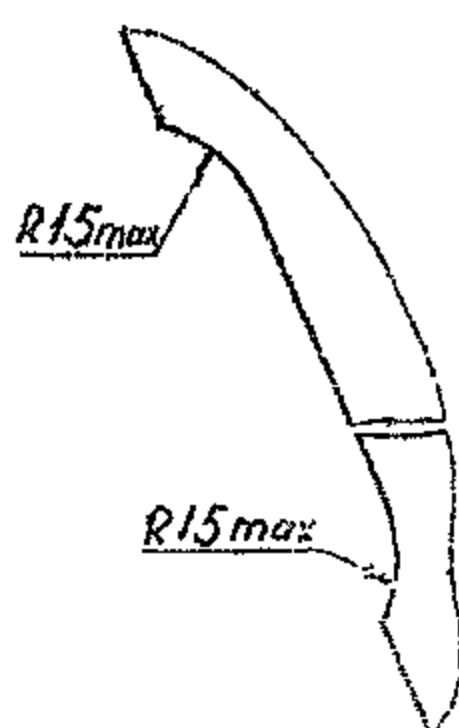
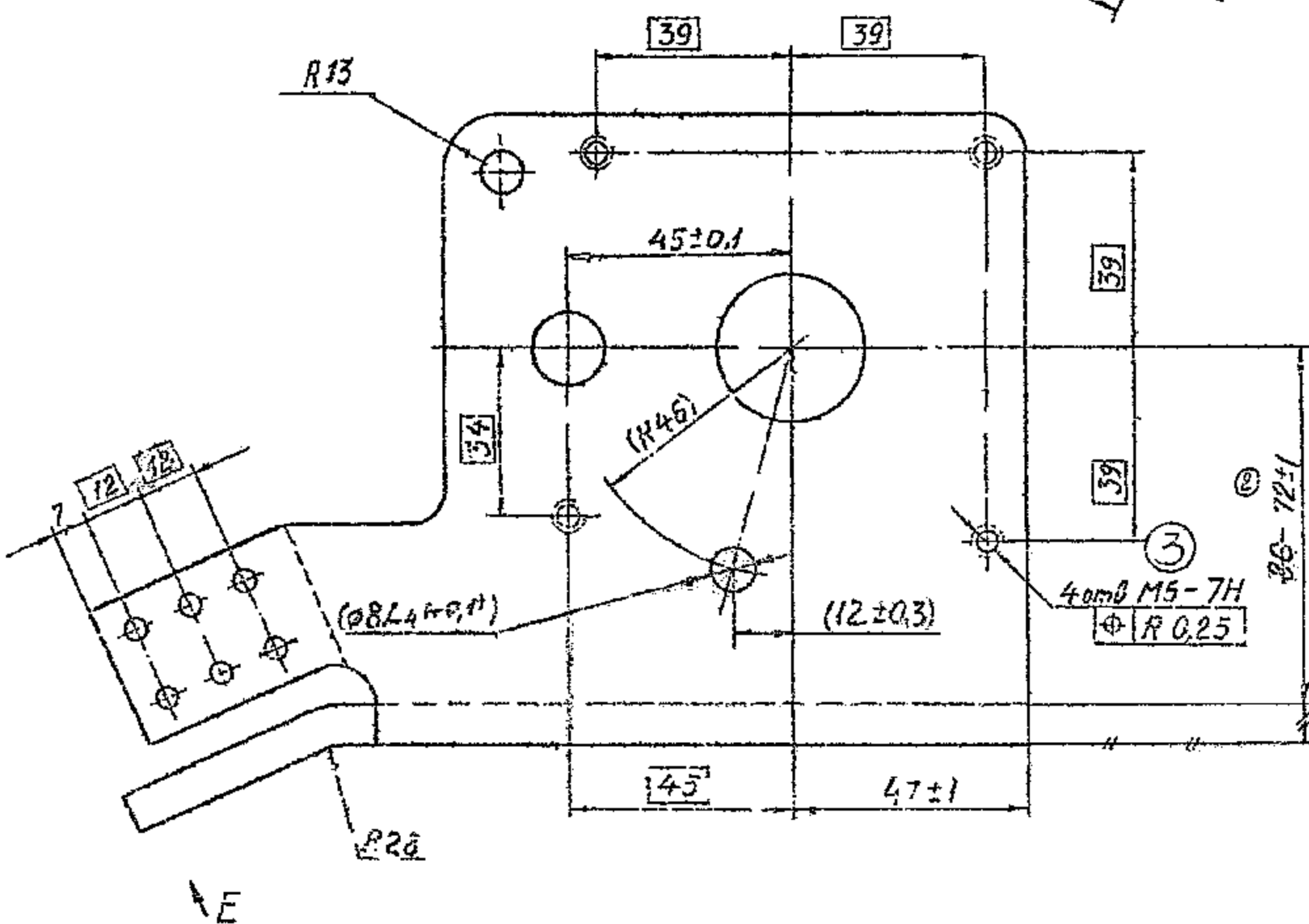
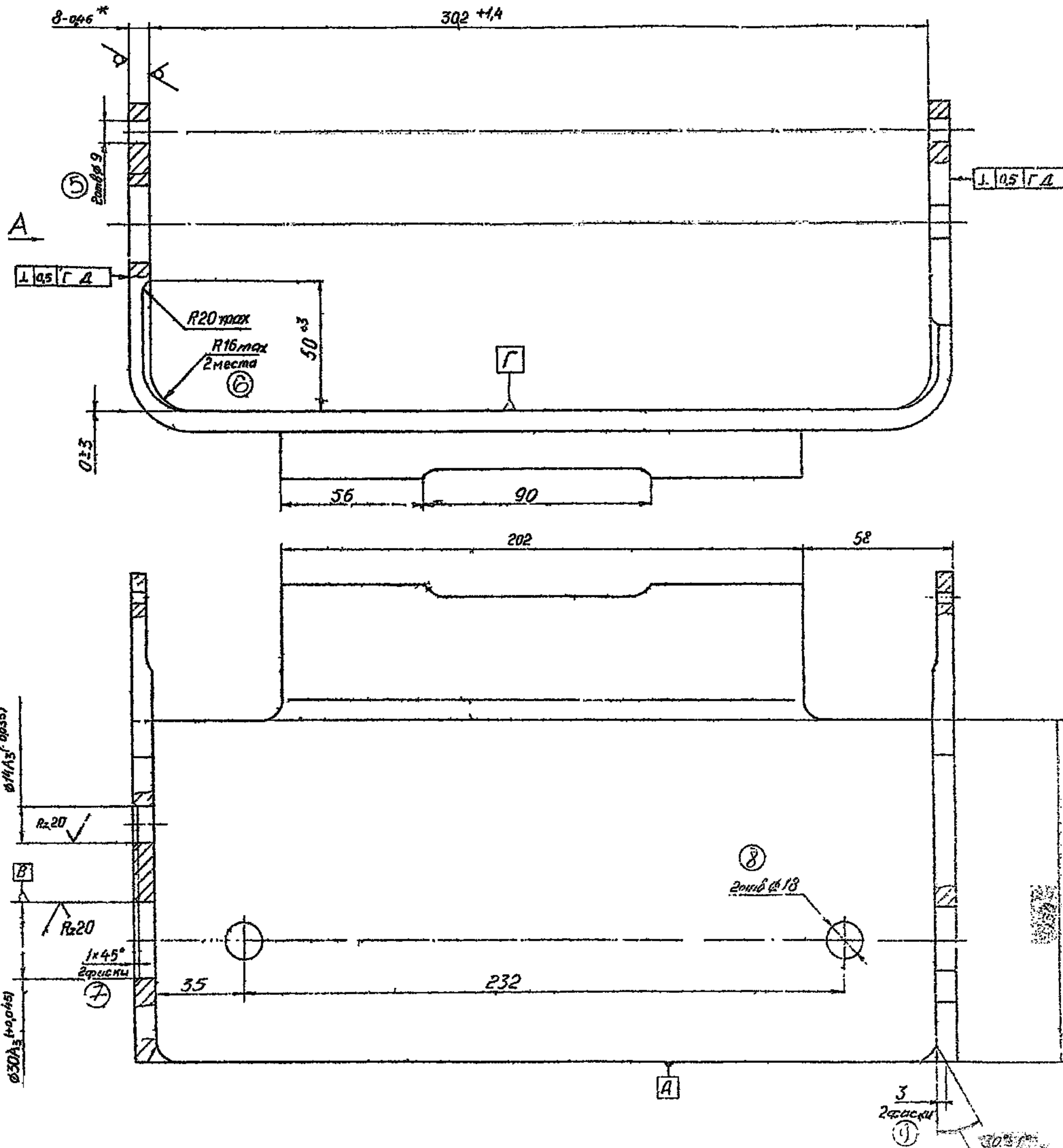
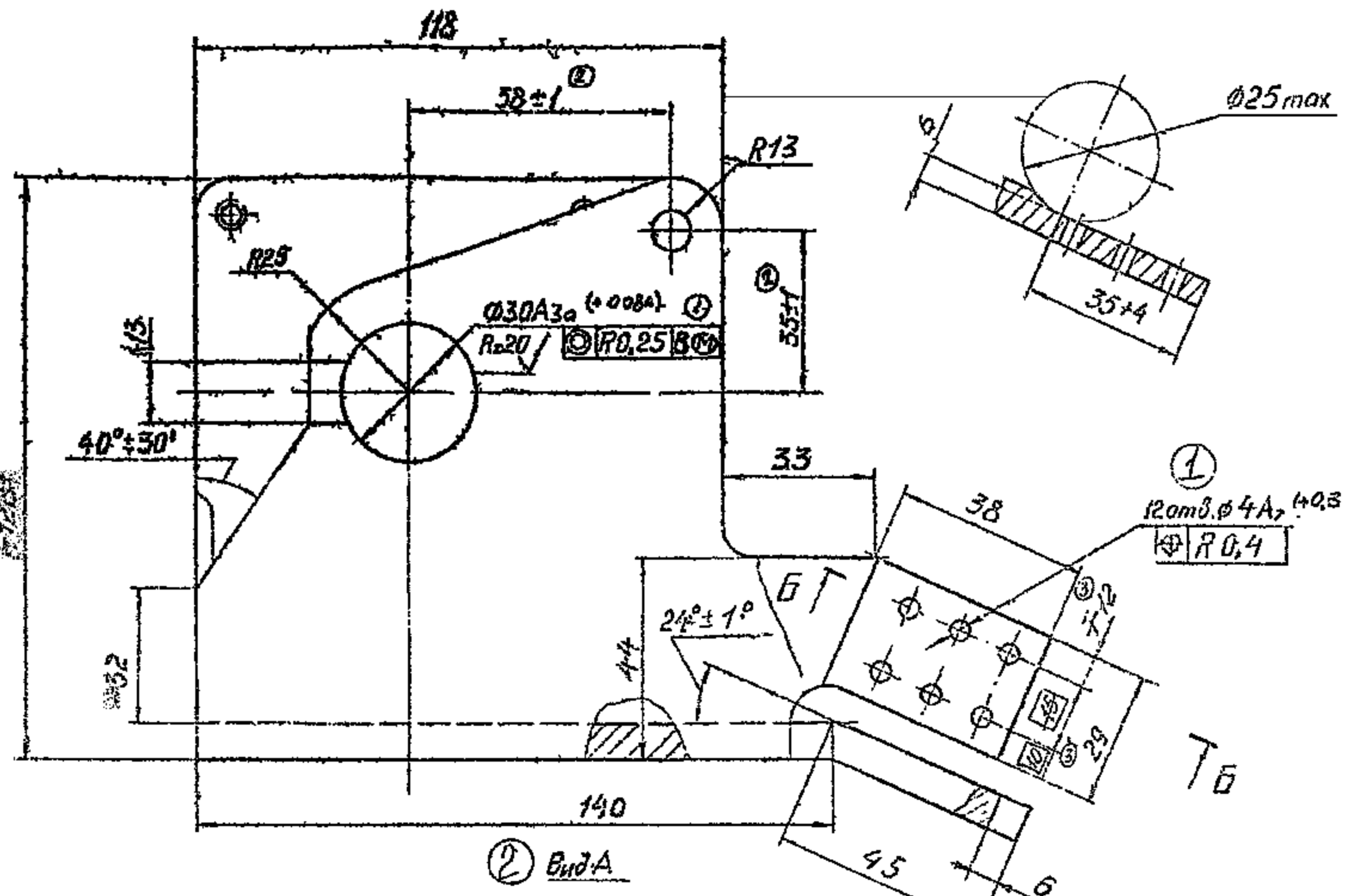
MATL STEEL SHEET D16AT-30,
 ГОСТ 21631-76

WEIGHT		SCALE	
0.008		1:1	
SHT 1	SHTS 1		

E-E

8-046*

302 +14



TECH. CONDITIONS

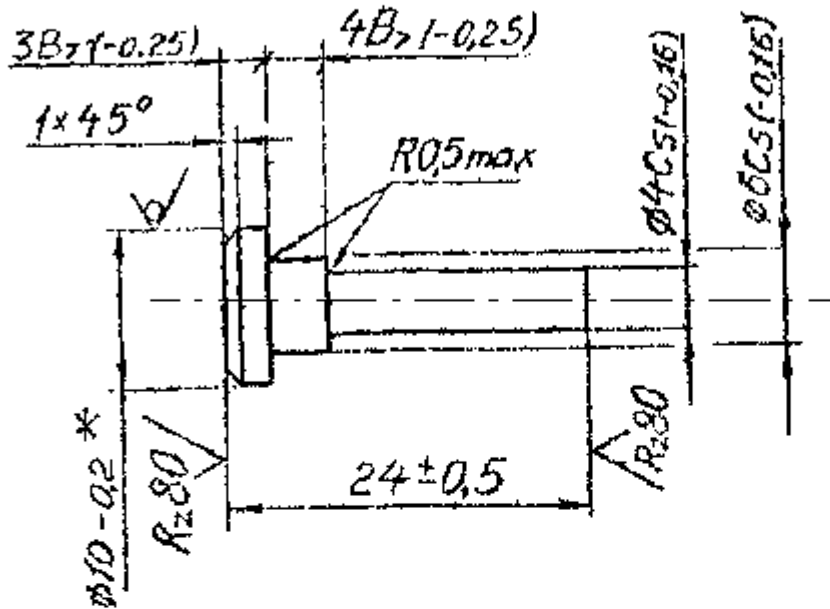
1. Substitute material: plate El6M-8, ГОСТ 21631-76.
2. Unspecified limit deviations of sizes are as follows: ±0.5 mm for up to 80 mm, ±1 mm for 80 mm to 200 mm, ±1.5 mm for more than 200 mm.
3. The stamping radii should not exceed 8 mm unless otherwise specified.
4. The sizes in brackets are after-assembly sizes.
5. The draft should not exceed 0.8 mm.
6. Tears and cracks with subsequent welding according to ГОСТ 14806-69-03 are tolerable.
7. The requirements for the quality of the welds are according to ГОСТ 3-0001-77 for unspecified welded joints.
8. *size for reference.
9. Coating: anodic oxidation with subsequent dichromate treatment or chemical phosphating, blue. The machined surfaces may be free of coating.

- ① 12 holes, dia 4.7 (+0.3)
- ② View A
- ③ 4 holes M6-7H
- ④ View Z
- ⑤ 2 holes, dia 9
- ⑥ 2 chamfers
- ⑦ 2 chamfers
- ⑧ 2 holes, dia 18
- ⑨ 2 chamfers

APPROVED	<i>[Signature]</i>	675-64-706	
CHECKED	<i>[Signature]</i>	BASE	WEIGHT
CONTROLLERATE OF QUALITY ASSURANCE (ICV)			107
MATL		Plate AM-65-8, ГОСТ 21631-76	SHT
			SHTS

675-64-710

Rz.40 ✓ (✓)



1. Substitute material: round bar 10-5, TOCT 7417-75
35-B, TOCT 1051-75
2. *Size for reference.
3. Coatings: zinc plating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness.

APPROVED *CR*
 CHECKED *CB*
 CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

675-64-710

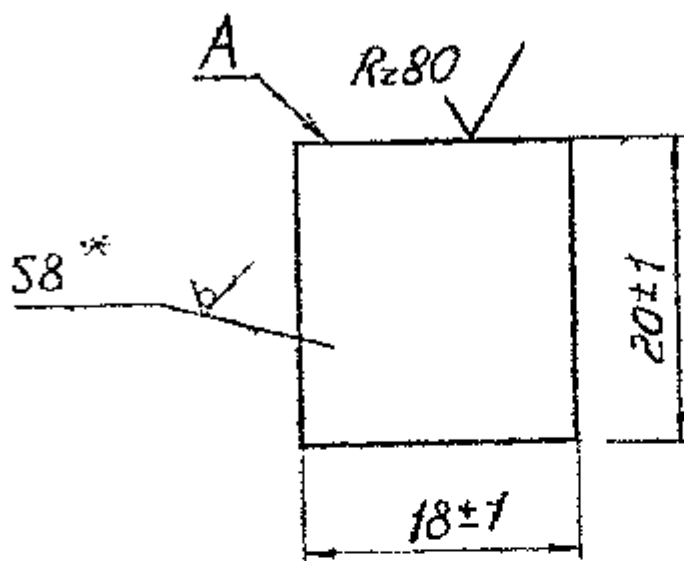
RIVET

ROUND BAR 10-5, TOCT 7417-75
20-B, TOCT 1051-75

WEIGHT		SCALE	
0.05		2:1	
SHT 1	SHTS 1	SHTS 1	

675-64-711

Rz 320 ✓(✓)



1. Draft of not more than 0.3 mm is tolerable. No draft is permitted on surface A.
2. *Size for reference.

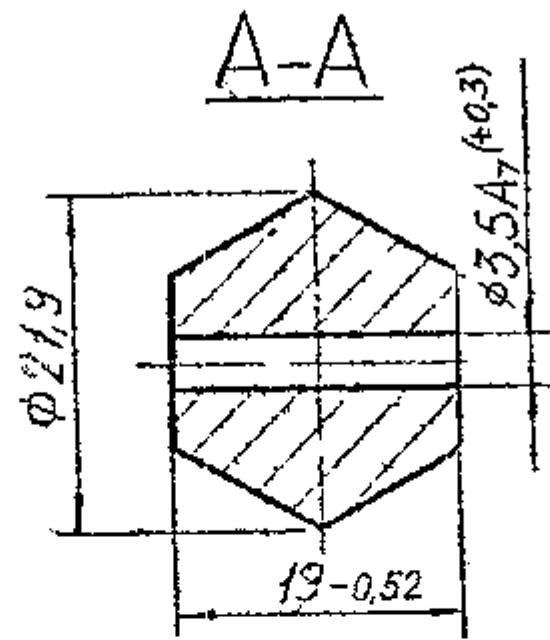
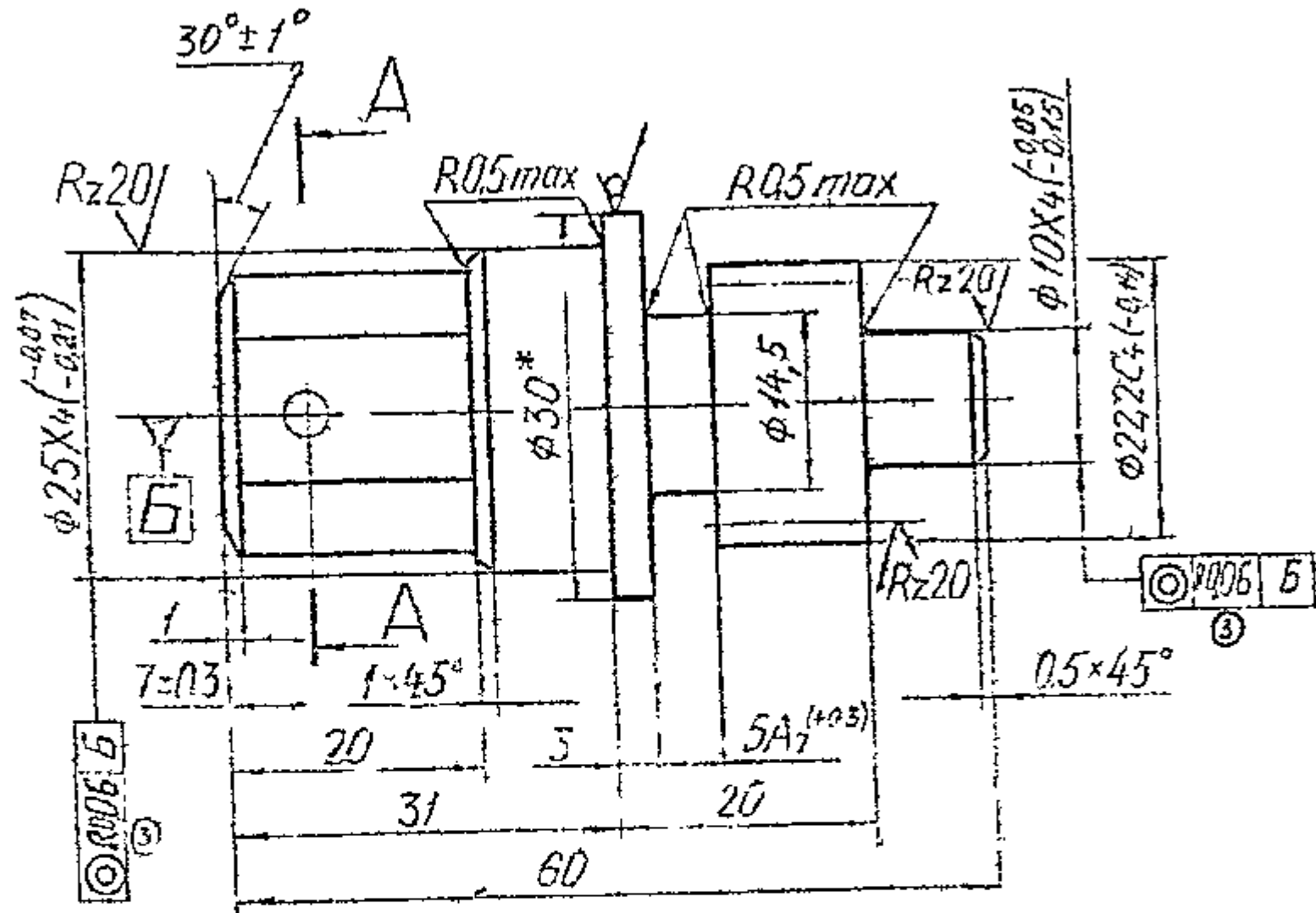
APPROVED *[Signature]*
 CHECKED *[Signature]*
 CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

675-64-711

ANGLE PIECE

PLATE AME 6E-8, TOCT 21631-16

WEIGHT		SCALE	
0.008		2:1	
SHT 1	SHTS 1		



1. Substitute material: round bar 30-5, GOST 7417-75...
38XC-B, GOST 4543-71
2. HB 285 to 341 (dia 3.6 to 3.3).
Test group 3 according to OCT 3-4704-80.
3. Unspecified limit deviations of sizes are as follows: holes according to B₇, other values according to G₁₀.
4. Data for checks are according to accuracy specifications OCT 3-3500-76. Perform the check relative to the common axis of the centers.
5. *Size for reference.
6. Coating: electrolessly oxidized coating with subsequent oiling.
7. Data for checks according to accuracy specifications GOST 1643-81. Perform the check relative to axis E.

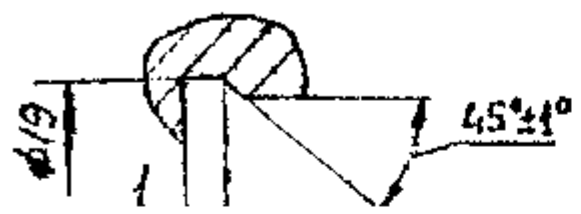
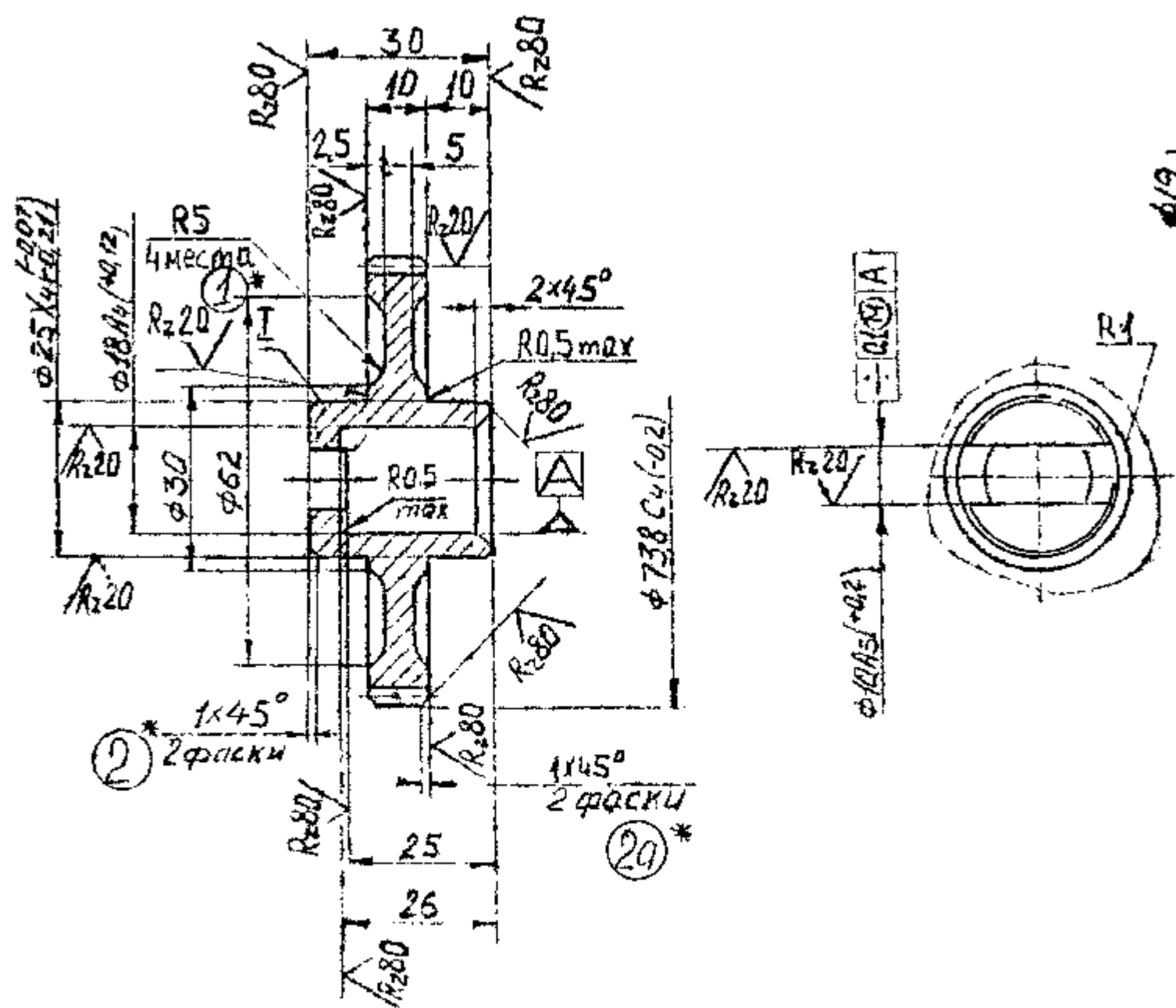
Module	m	1.5
Number of teeth	z	12
Normal basic rack	-	GOST 13755-81
Addendum modification coefficient	x	0.4
Degree of accuracy according to GOST 1643-81	-	10-Ba
Base tangent length	w	7.305 ^{-0.110} -0.150
Reference diameter	d ₀	18
Designation of drawing of mating part	-	675-64-715

APPROVED	<i>[Signature]</i>	675-64-714	
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		GEAR WHEEL	WEIGHT SCALE
			0.125 2:1
			SHT 1 SHTS 1
		ROUND 30-5, GOST 7417-75 BAR 38XC-B, GOST 4543-71	

675-64-715

Rz320
V(V)

⑤*
I вариант
M 5:1



- * (1) 4 places
 - * (2) 2 chamfers
 - * (2a) 2 chamfers
 - * (3) I version
- Scale 5:1

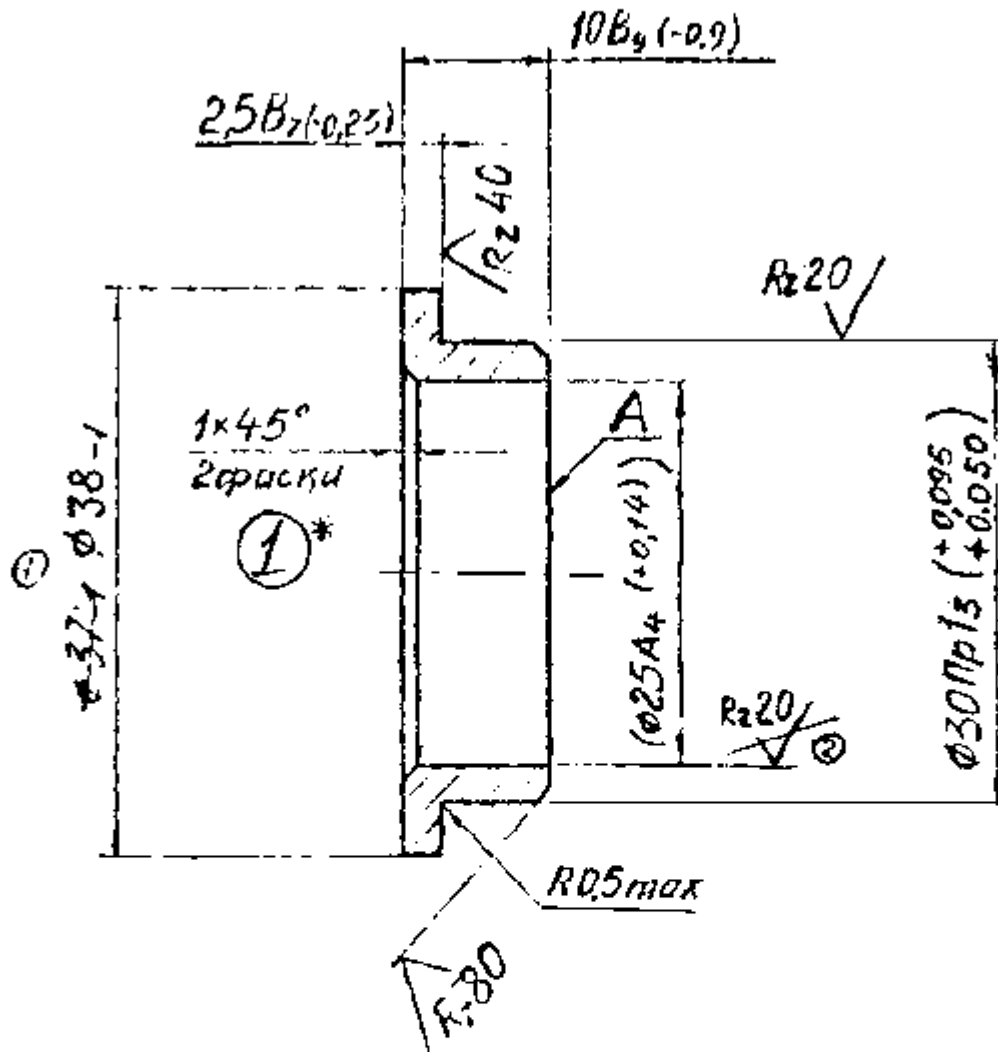
Module	m	1.5
Number of teeth	z	48
Normal basic rack	-	ГОСТ 13755-81
Addendum modification coefficient	X	-0.4
Degree of accuracy according to ГОСТ 1643-81	-	10-Bd
Base tangent length	W	20.585 ^{-0.110} -0.220
Reference diameter	d _a	72
Designation of drawing of mating part		675-64-714

1. Substitute material: steel 33XC, 40XC, ГОСТ 4543-71.
2. SB 285 to 341 (dia 3.6 to 3.3). Test group 5 according to OCT 3-1163-72.
3. Unspecified limit deviations of sizes are as follows: shafts according to B₇, holes according to A₇, other values according to G₇.
4. The requirements for the stamping are according to accuracy class II, ГОСТ 7505-74.
5. The surface defects on the non-machined surfaces should not exceed 0.5 mm.
6. Data for checks are according to accuracy specifications ГОСТ 1643-81. Perform the check relative to axis of surface A.
7. Coating: electrolessly oxidized coating with subsequent oiling.

APPROVED	<i>[Signature]</i>	675-64-715	
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	STEEL 38XC, GOST 4543-71	WEIGHT	SCALE
		0.261	1:1
		SHT	SHTS

675-64-716

Rz 160 ✓ (✓)



* (1) 2 chamfers

- Substitute material: bronze Br AK9-4, Br. AlM9-2, ГОСТ 18175-78.
- Casting radii should not exceed 1 mm.
- Marks not deeper than 0.5 mm left by the knockouts are tolerable on surface A.
- The rest of the requirements for the casting are according to Technical Requirements ТТ ЕЛ-445.
- The sizes given in brackets are after-assembly sizes.

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

675-64-716

BUSHING

BRONZE Br A9 #3Л
ГОСТ 493-79

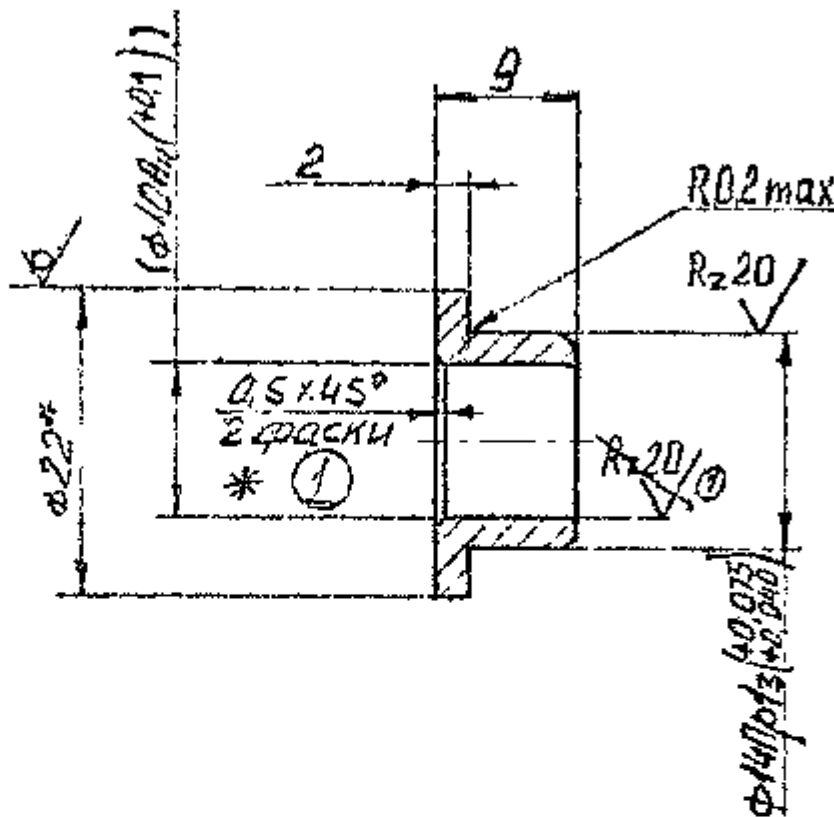
WEIGHT SCALE

0.022 2:1

SHT SHTS

675-64-717

82 80 ✓ (✓)



* (1) 2 chamfers

1. Substitute material: bronze Ep AMu 10-3-1.5, Ep AM9-4, ГОСТ 18175-78.
2. Unspecified limit deviations of sizes are as follows: shafts according to B₇, other values according to G₇.
3. *Size for reference.
4. The size in brackets is an after-assembly size.

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

675-64-717

BUSHING

ROUND BAR AKPHD 22 H A BRONZE
Ep AMu 9-2, GOST 162B-78

WEIGHT

SCALE

0.0077

2:1

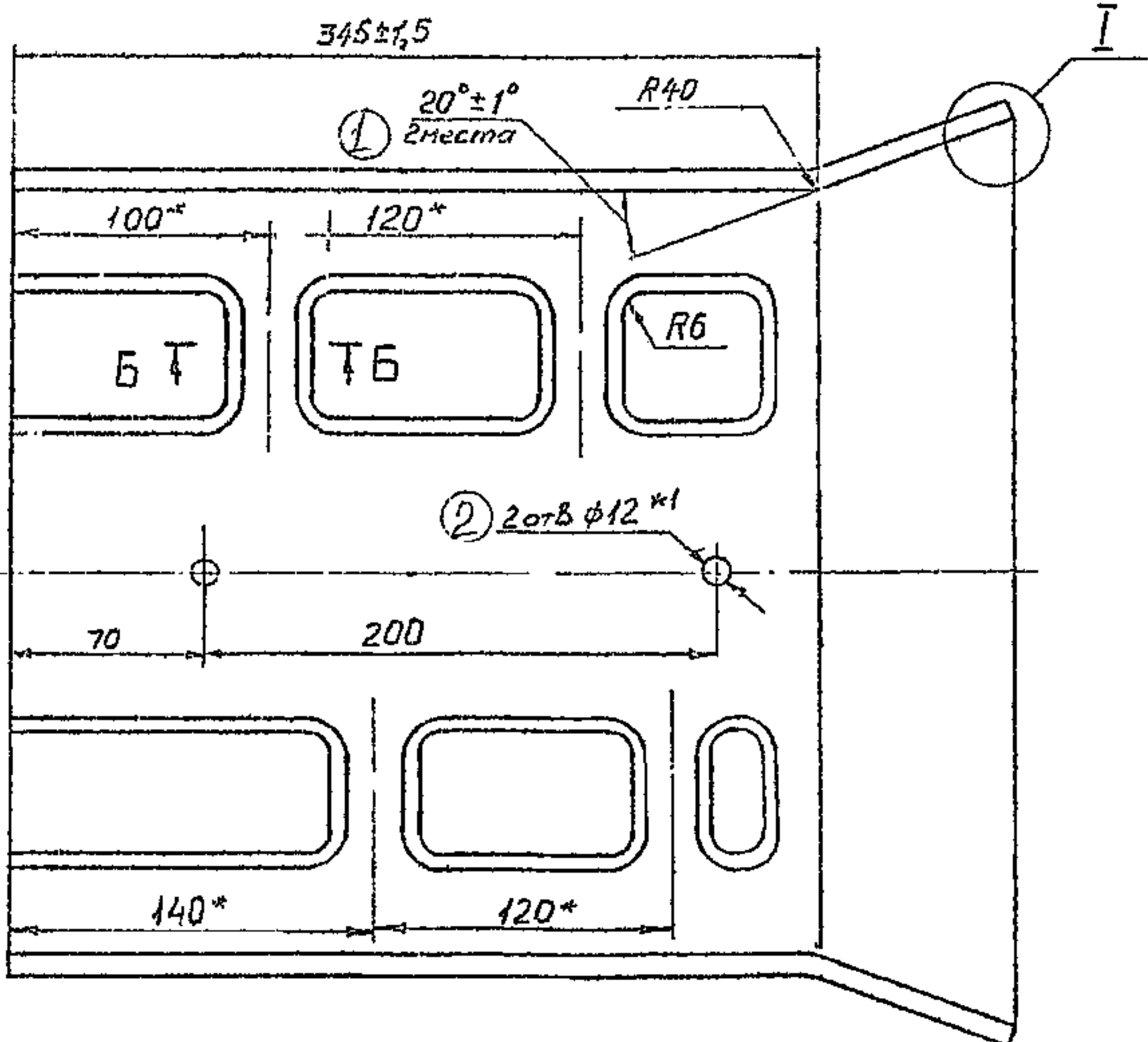
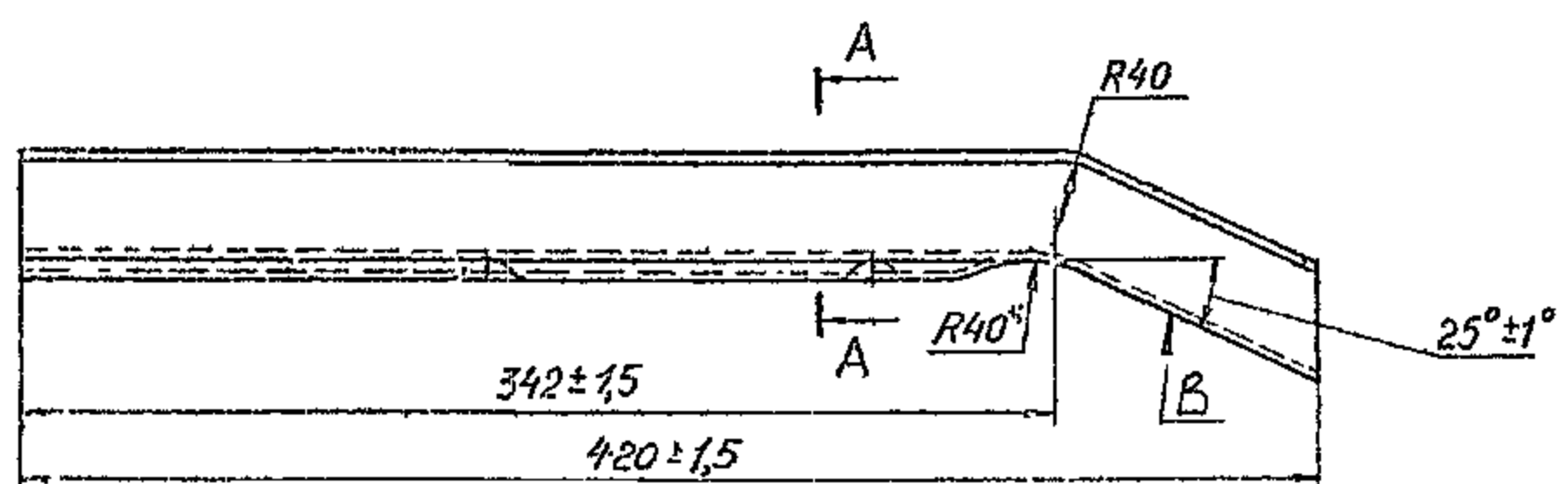
SHT

SHTS

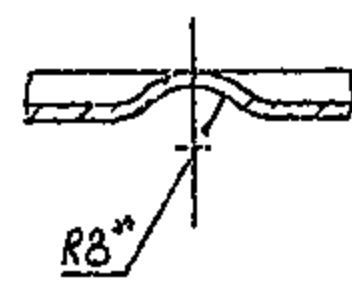
R=3:0 ✓ (✓)

⑤ I вариант

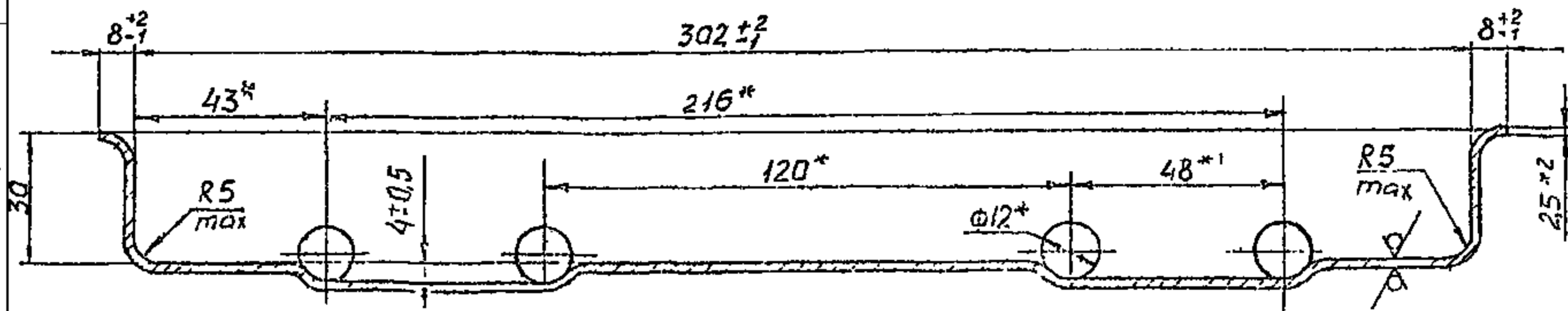
④ Б-Б
M 1:1



③ A-A
M 1:1

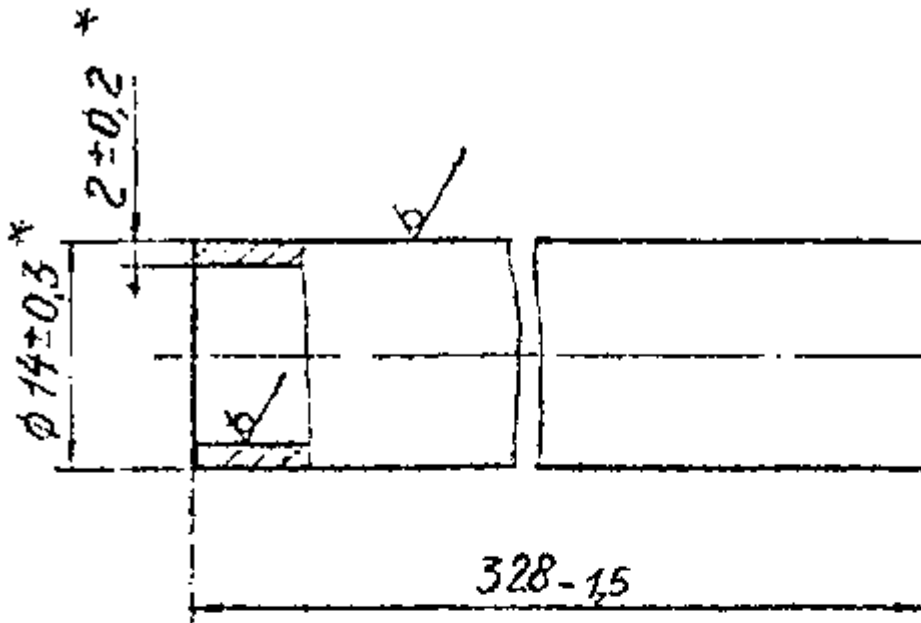


- ① 2 places
- ② 2 holes, dia 12^{M1}
- ③ A-A
Scale 1:1
- ④ B-B
Scale 1:1
- ⑤ Version
 1. Substitute material: sheet AlMgEM-2.5, ГОСТ 21651-76.
 2. Limit deviations of sizes are ±1 mm unless otherwise specified.
 3. Stamping radii should not exceed 6 mm unless otherwise specified.
 4. Coating: hard anodizing with subsequent bichromate treatment, oxide film 20 to 50 microns thick.
 5. The requirements for the quality of the welds are according to OCT 3-4001-77 for unspecified welded joints. Corrugation not higher than 1 mm on surface B is tolerable.
 6. *Ensure the sizes with the help of tools.
 7. ^{M1}Auxiliary holes.
 8. ^{M2}Size for reference.
 9. Tears and cracks with subsequent welding according to ГОСТ 14806-69-G3 are tolerable.



APPROVED *C. P. ...*
 CHECKED *B. ...*
 CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

675-64-718			
TRAY		WEIGHT	SCALE
		1.3	1:1
SHT 1 SHTS 1		SHT 1 SHTS 1	



1. Substitute material: tube 14x2.0, POCT 8734-75
R10, POCT 8733-74
2. *Sizes for reference.
3. Coating: zinc plating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness.
4. The inner surface may be free of coating.

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

675-64-720

TITLE

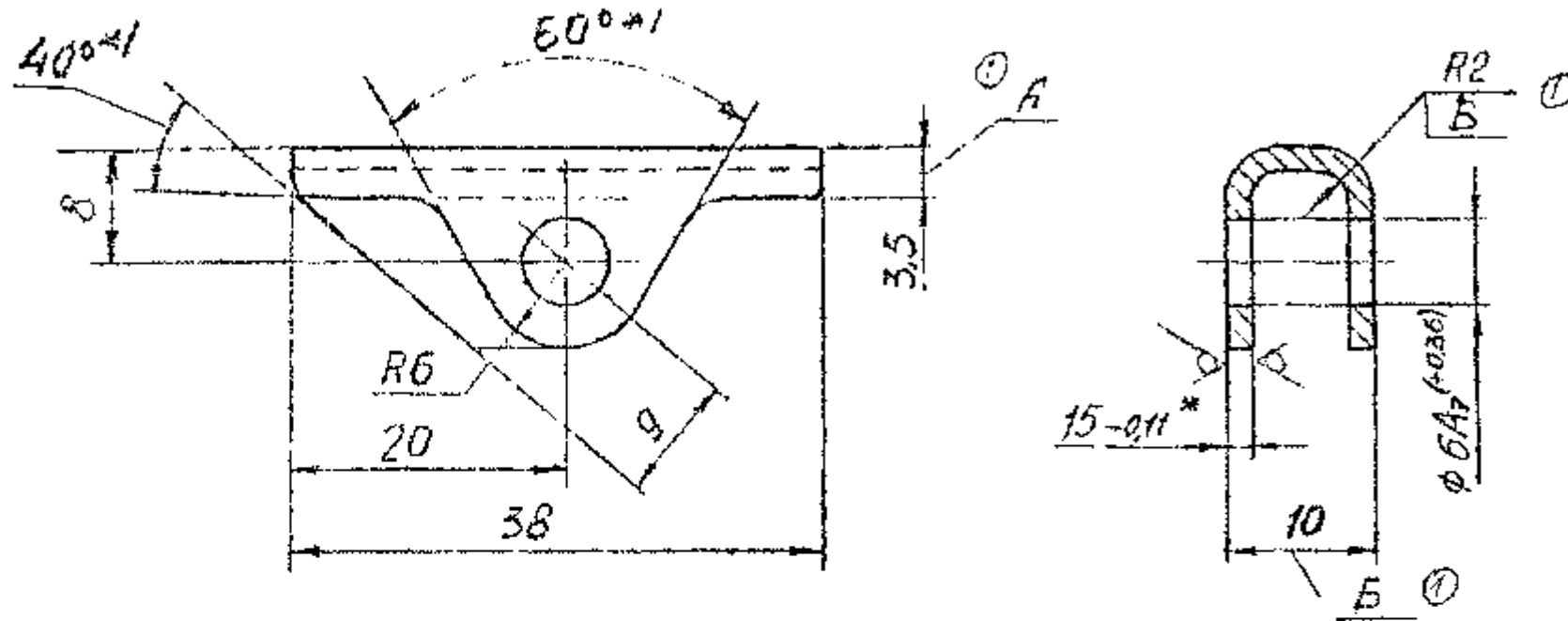
14x20, Poct 8734 - 75
TUBE B 20, Poct 8733-74

WEIGHT SCALE

0.193 2:1

SHT SHTS

① ~~Rz 80~~ Rz 160 ✓ (✓)

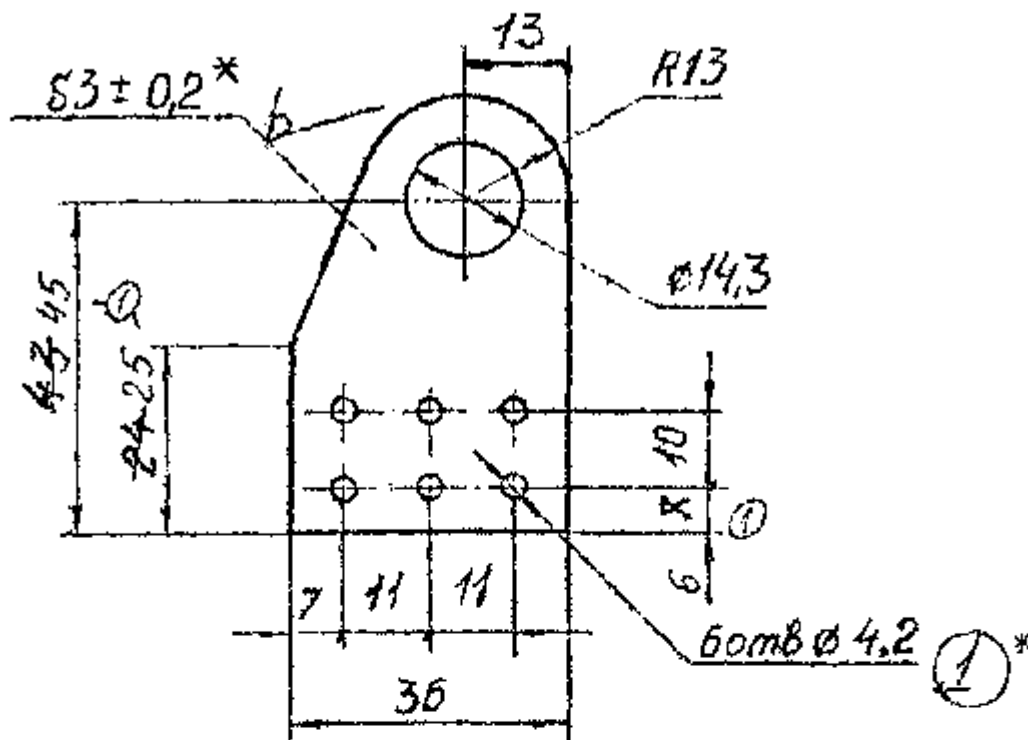


- (1) 1. Limit deviations of sizes are ± 0.5 mm unless otherwise specified.
- 2. The stamping radii should not exceed 8 mm unless otherwise specified.
- 3. Limit deviations of angle values are $\pm 1^\circ$ unless otherwise specified.
- 4. *Size for reference.
- 5. Coating: zinc plating followed by chromate treatment, zinc coat is 9 microns thick. Eliminate hydrogen brittleness.
- 6. *¹Ensure the developed sizes.
- 7. For shelves of size A size B may be increased up to 11 mm and radius B may be increased up to $(2^{+1.0}_{-0.5})$ mm.

APPROVED	<i>[Signature]</i>	675-64-721	
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		LOCK	
		WEIGHT	SCALE
		0.009	2:1
STEEL 10 ГОСТ 1050-74		SHT	SHTS

675-64-722

R_z 160 ✓ (✓)



*1) 6 holes, dia 4.2

1. Substitute material: steel sheet E-NY-0-3.0, ГОСТ 19903-74, 4-II-25, ГОСТ 16523-70
2. Unspecified limit deviations of sizes are as follows: holes according to A₇, shafts according to B₇, other values according to CK₇.
3. *Size for reference.
4. Coating: zinc plating followed by chromate treatment, zinc coat 9 microns thick, Eliminate hydrogen brittleness.
5. *1 Steel sheet E-NY-0-3.0, ГОСТ 19903-74, 4-II-20, ГОСТ 16523-70

APPROVED *[Signature]*
 CHECKED *[Signature]*
 CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

675-64-722

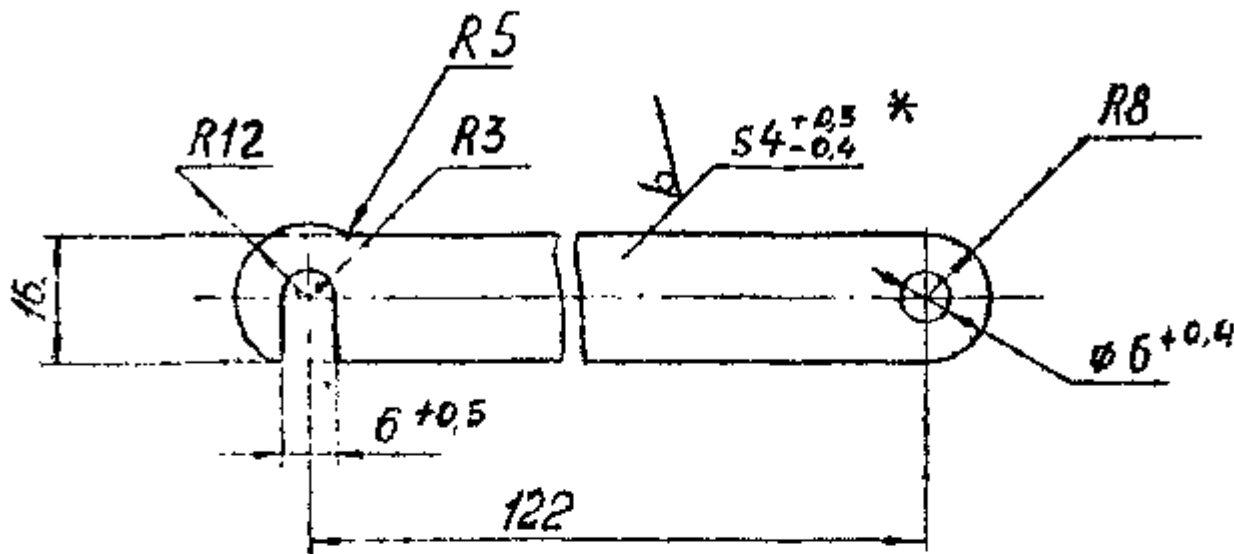
LUG

STEEL

WEIGHT	SCALE
0.036	1:1
SHT	SHTS

675-64-723

u
Rz 160 ✓ (✓)



1. Substitute material: steel sheet E-IV-0-4.0 GOST 19903-74
4-II-25, GOST 16523-70
2. Limit deviations of sizes are ± 0.5 mm unless otherwise specified.
3. *Size for reference.
4. Coating: zinc plating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness.
5. Draft not exceeding 0.4 mm is tolerable.

APPROVED *[Signature]*
 CHECKED *[Signature]*
 CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

675-64-723

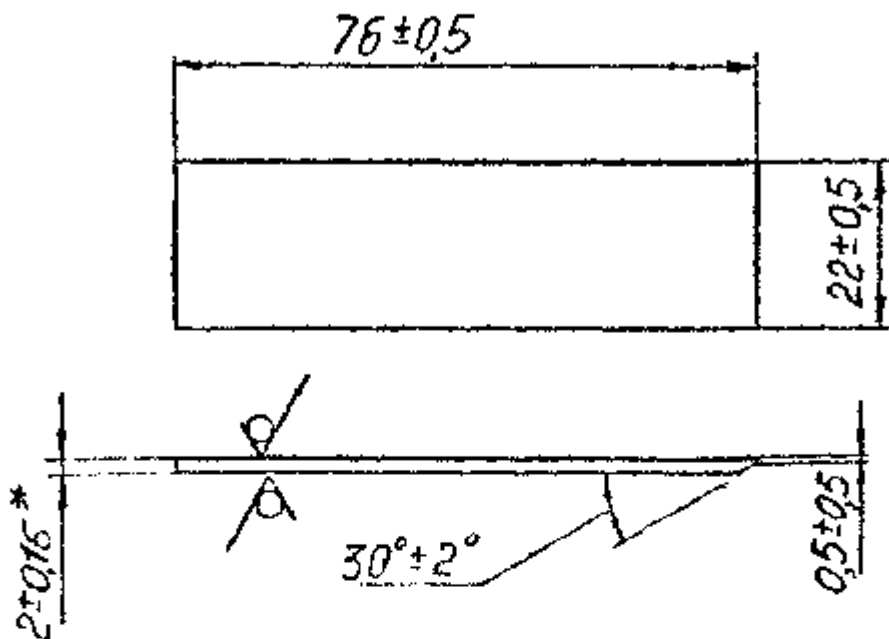
LEVER

WEIGHT	SCALE
0.073	1:1
SHT	SHTS

STEEL E-IV-0-4.0, GOST 19903-74
 SHEET 4-II-20, GOST 16523-70

675-64-724

Rz320/ (✓) (✓)



- (1) 1. Substitute material: steel sheet Б-ПУ-0-2.0, ГОСТ 19903-74,
4-И-П-35, ГОСТ 16523-70
 2. *Size for reference.
 3. Coating: zinc plating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness.

APPROVED

[Handwritten signature]

CHECKED

[Handwritten signature]

CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

675-64-724

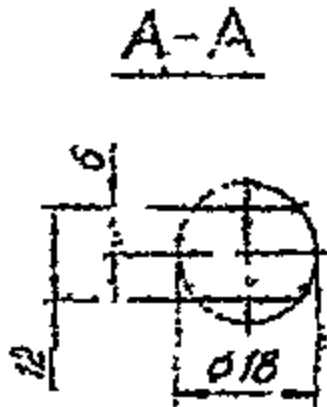
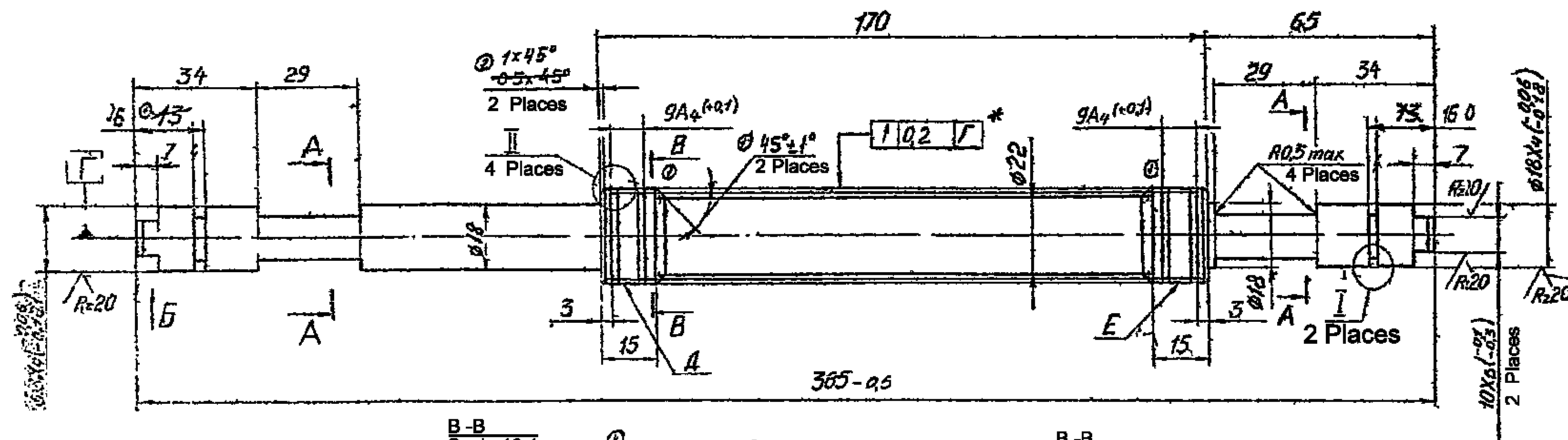
STRAP

WEIGHT SCALE

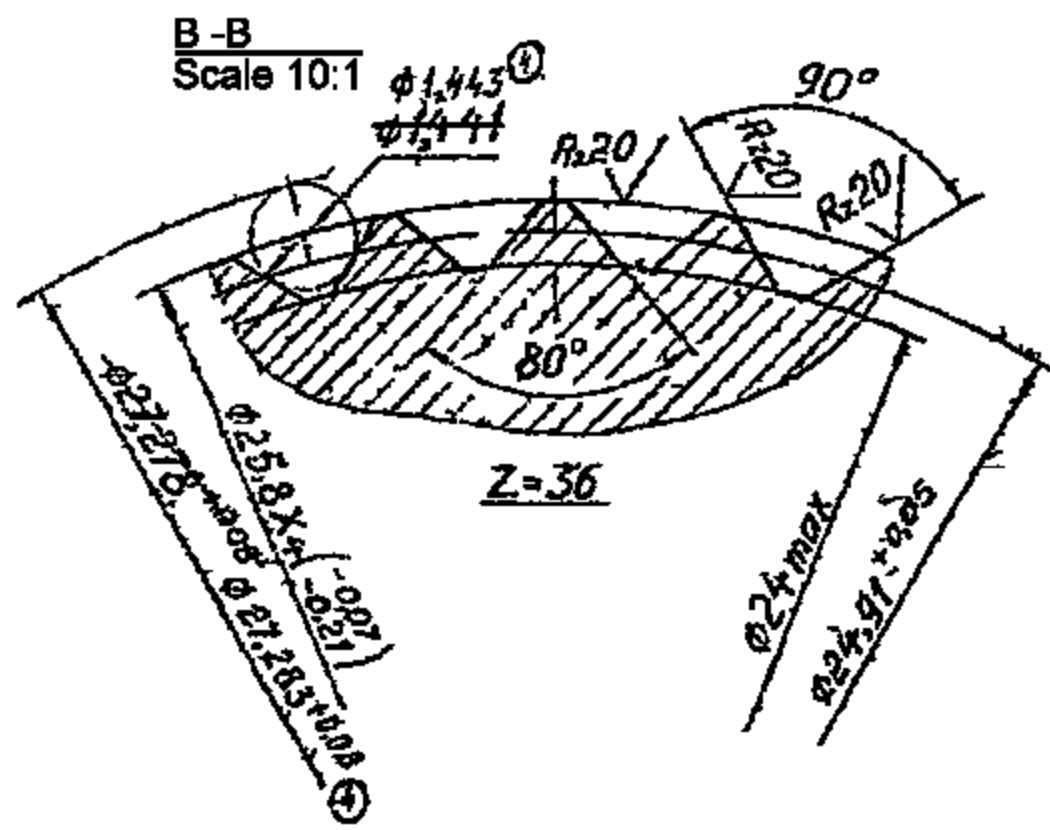
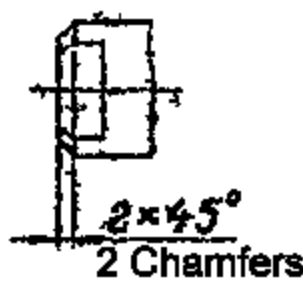
0.03 1:1

SHT 1 SHTS 1

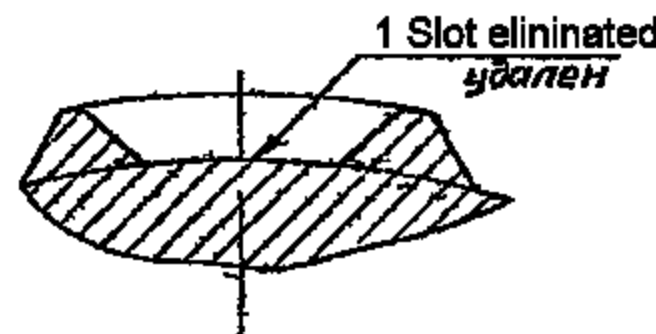
STEEL Б-ПУ-0-2.0, ГОСТ 19903-74
 SHEET И-П-65, ГОСТ 1577-81



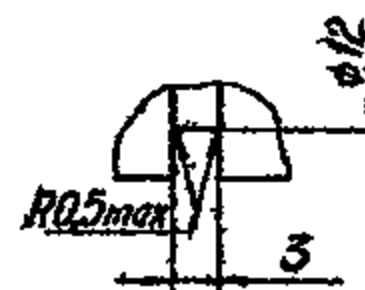
View - 5



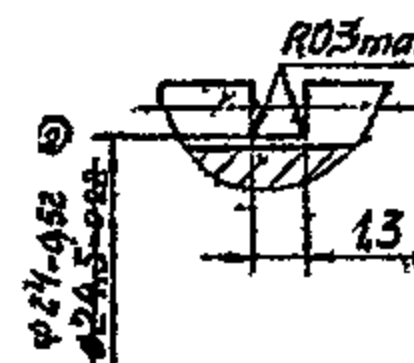
B-B Version Scale 10:1



I Scale 2:1



II Scale 5:1

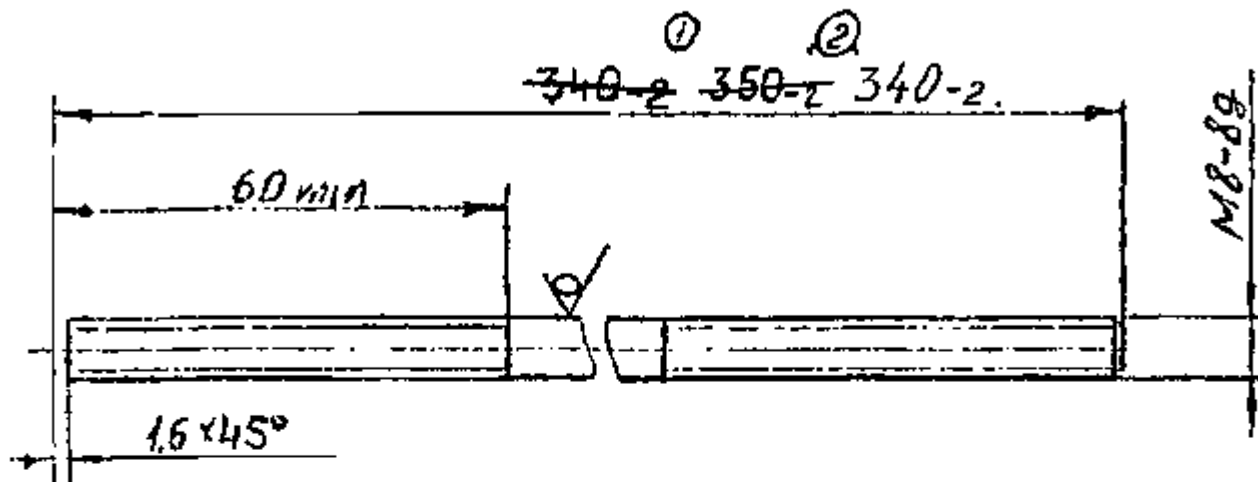


1. HB 255 to 302 (Ha 3.8 to 3.5). Test group 3 according to OCT 3.1163-72.
2. Unspecified limit deviations of sizes are as follows: holes according to H₇, shafts according to h₇, other values according to CH₇.
3. Arrangement of flats relative to each other is arbitrary.
4. The angular turn of the symmetry axes of the spline teeth on surface 2 relative to the symmetry axes of spline teeth on surface 1 should not exceed 10' (dependent tolerances).
5. Coating: zinc plating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness.
6. When manufacturing the part according to version B - B, manufacture mating parts 675-64-702 and 675-64-730 according to version A - A.
7. Anneal before cutting the splines.
8. When eliminating the spline, the cut should not exceed 0.3 mm.

APPROVED		675-64-725	
CHECKED		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		0.892	1:1
		SH 1 SHTS 1	
		Round Bar	30-5, GOST 7417-75 45X-B, GOST 4543-71

675-64-729

R240
✓(✓)



- (1) 1. Substitute material: steel Cr3, Cr4, Cr5, TOCT 380-71 and steel 15, 25, 30, 35, 40, 45, TOCT 1050-74.
- 2. The thread may be rolled on the rod free of chamfers at its ends, the diameter of the non-threaded portion should be equal to the pitch diameter of the thread.
- 3. Coating: zinc plating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness. Do not check the quality of the coating on the non-treated surfaces.

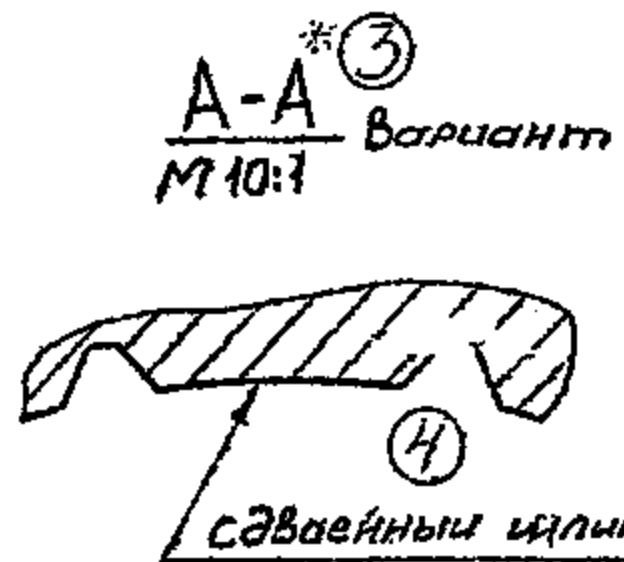
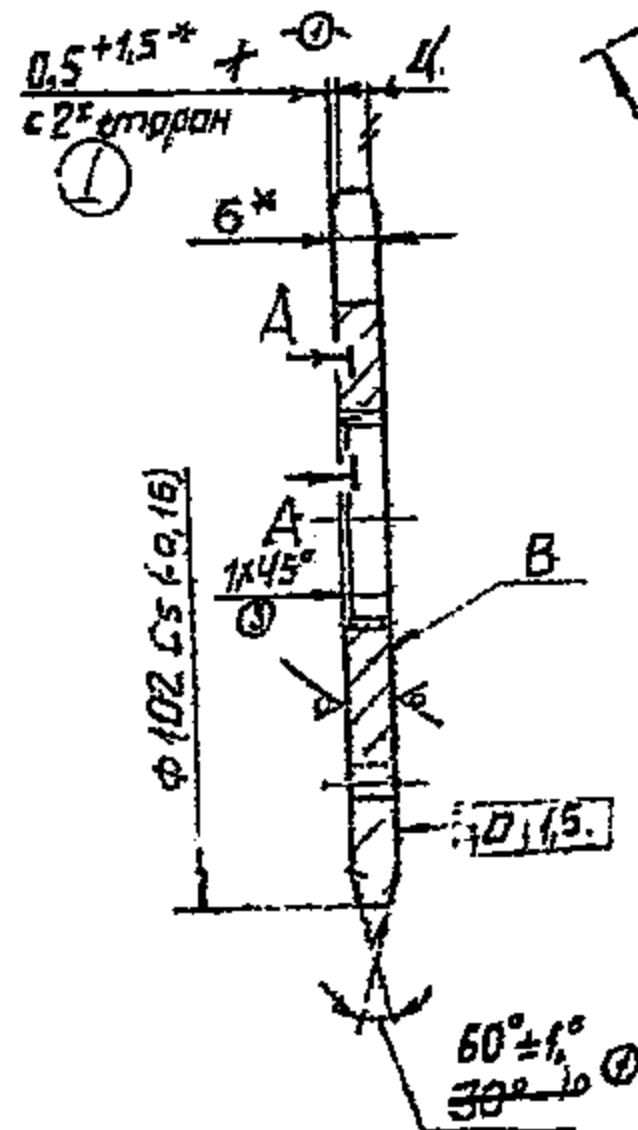
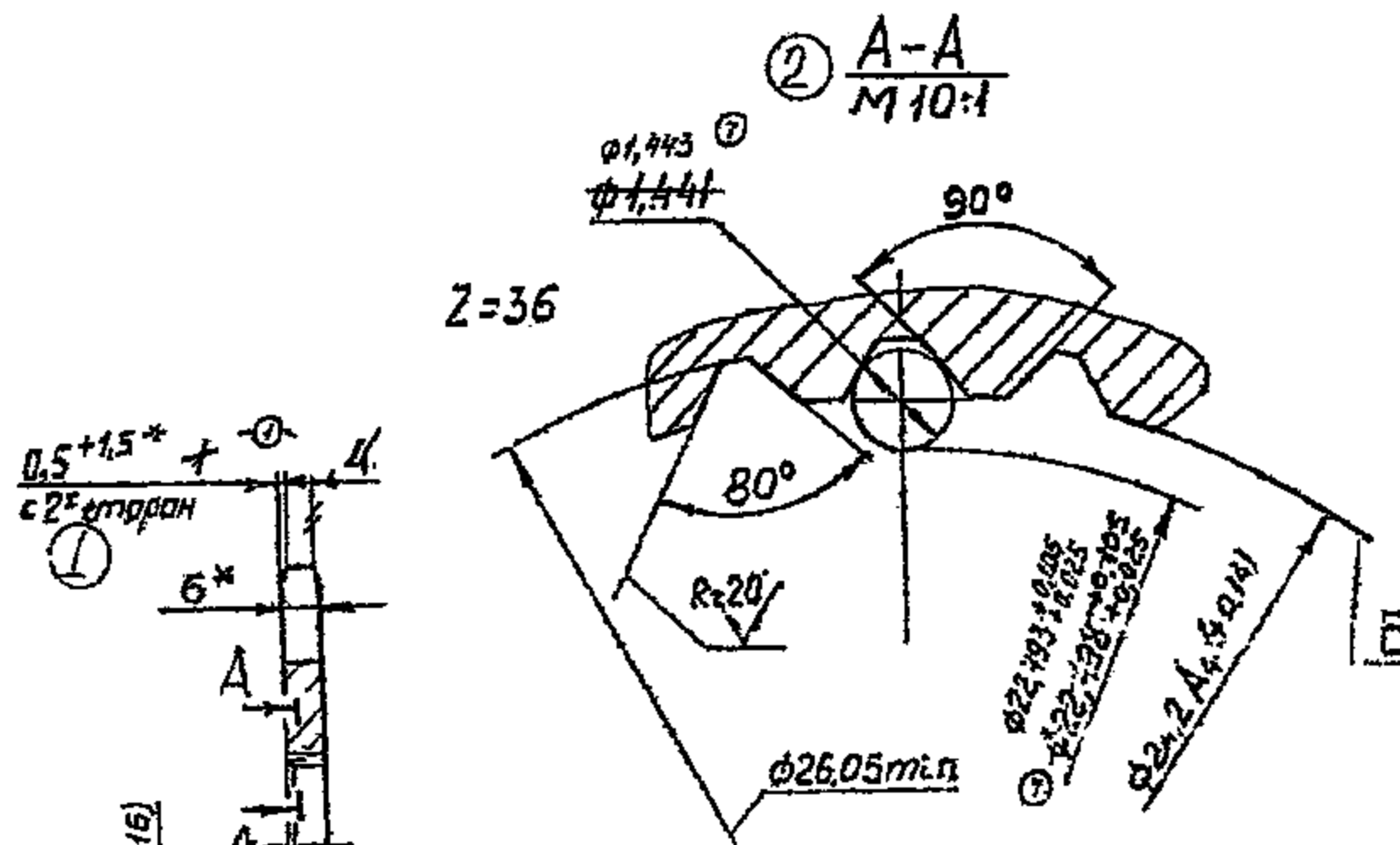
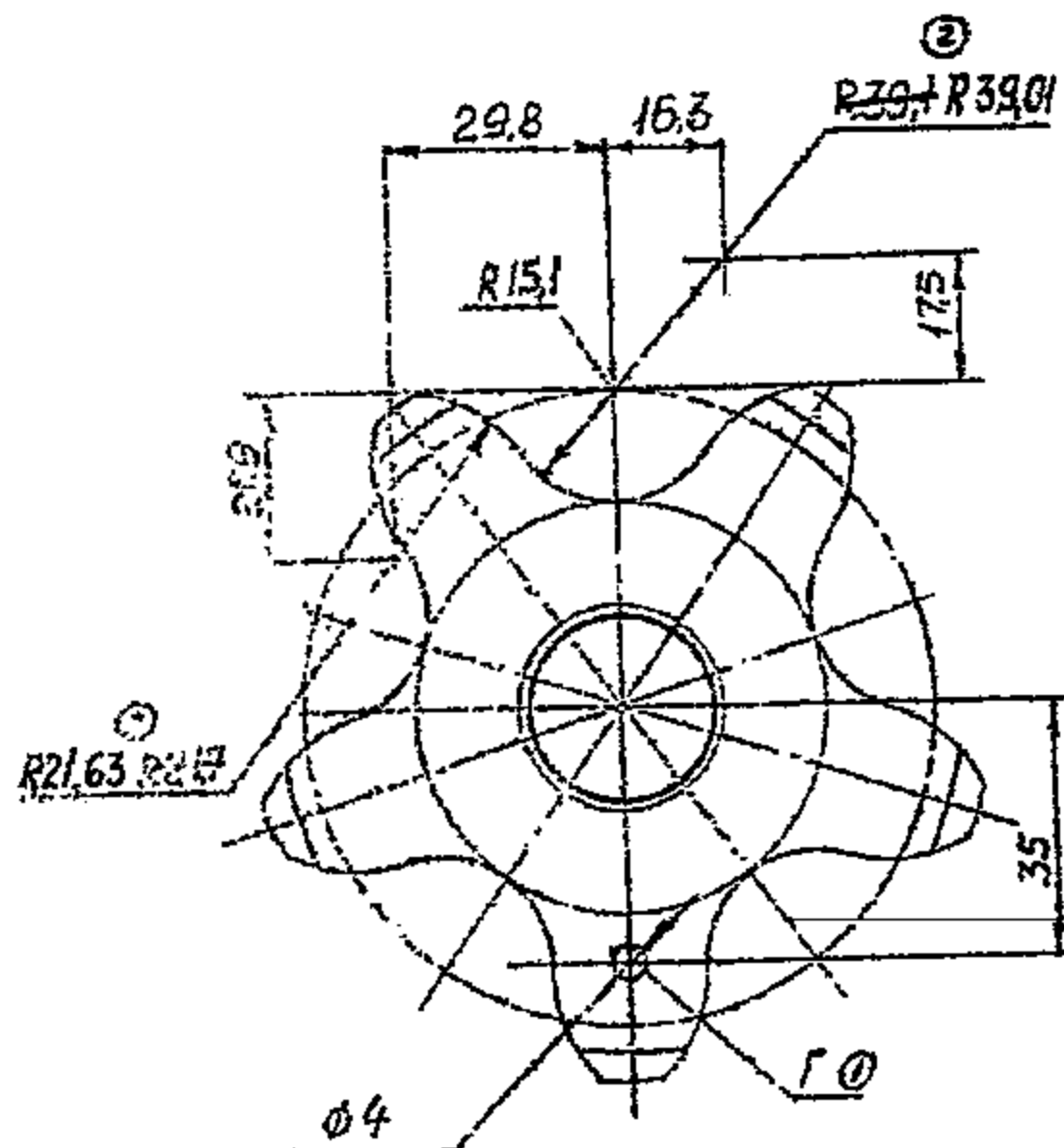
APPROVED *[Signature]*
 CHECKED *[Signature]*
 CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

675-64-729

BRACE

	WEIGHT	SCALE
	0.133	1:1
SHT	SHTS	

ROUND BAR 8-5 TOCT 7417-75
 20-B, TOCT 1051-73



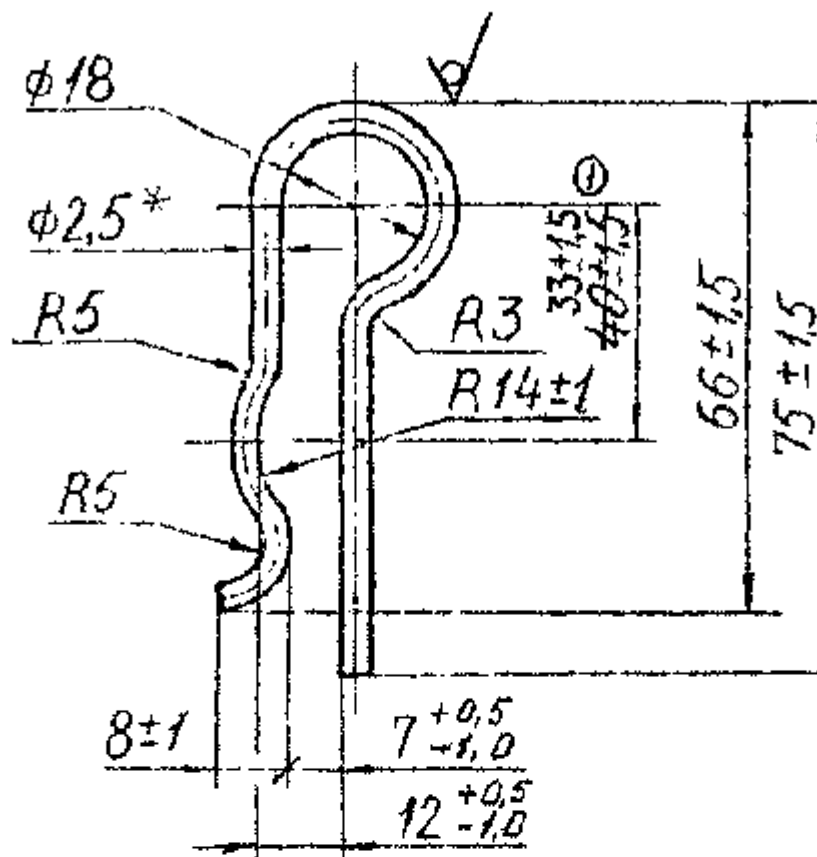
- (1) On 2 sides
- (2) A-A
Scale 10:1
- (3) A-A version
Scale 10:1
- (4) Twin splines
- (5) Number of teeth

Accuracy class according to GOST 591-69	h	5
Root circle diameter	d_1	56.50 ₅ (-0.4)
Tolerance for pitch difference	s_e	0.32
Radial runout of root circle relative to surface 3	E_o	0.63
Reference diameter	d_a	86.7

- (6) 1. HB 285 to 341 (dia 3.6 to 3.3) or HRC 27 to 35. Test group 3 according to GOST 3-1163-72.
- 2. Unspecified limit deviations of sizes are as follows: holes according to A_7 , shafts according to A_7 , other values according to CH_8 .
- 3. Turning of the axes of the sprocket teeth relative to the axis of the twin slot (version A - A) or relative to the axis of the slot space (A - A) should not exceed 15' (dependent tolerance).
- 4. *Size for reference.
- 5. Coating: zinc plating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness.
- 6. When manufacturing the part according to version A - A, manufacture mating part 765-64-725 according to version B - B.
- 7. Scraping not deeper than 0.5 mm on surface 3 is tolerable in order to check roughness.
- 8. Auxiliary hole Γ is permissible.
- 9. The splined hole may be checked with multi-purpose gauge having the following dimensions: tooth thickness at relative circle arc of 1.090₃ mm, major diameter of 25.80₃ mm and minor diameter of 24₂ mm.

APPROVED	<i>C.N.</i>	675-64-730	
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	SPROCKET	WEIGHT	SCALE
		0.236	1:1
		SHT 1 SHTS 1	
STEEL 5-17-0-6, GOST 19903-76 PLATE 65Г, GOST 1577-81			

Kz 320/
V(V)



- (1) 1. Limit deviations of sizes are ± 1 mm unless otherwise specified.
 2. Total length of the safety pin is about 160 mm.
 3. *Size for reference.
 4. Coating: electroless oxidizing with subsequent oiling.

APPROVED

[Signature]

675-64-759

CHECKED

[Signature]

CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

SAFETY PIN

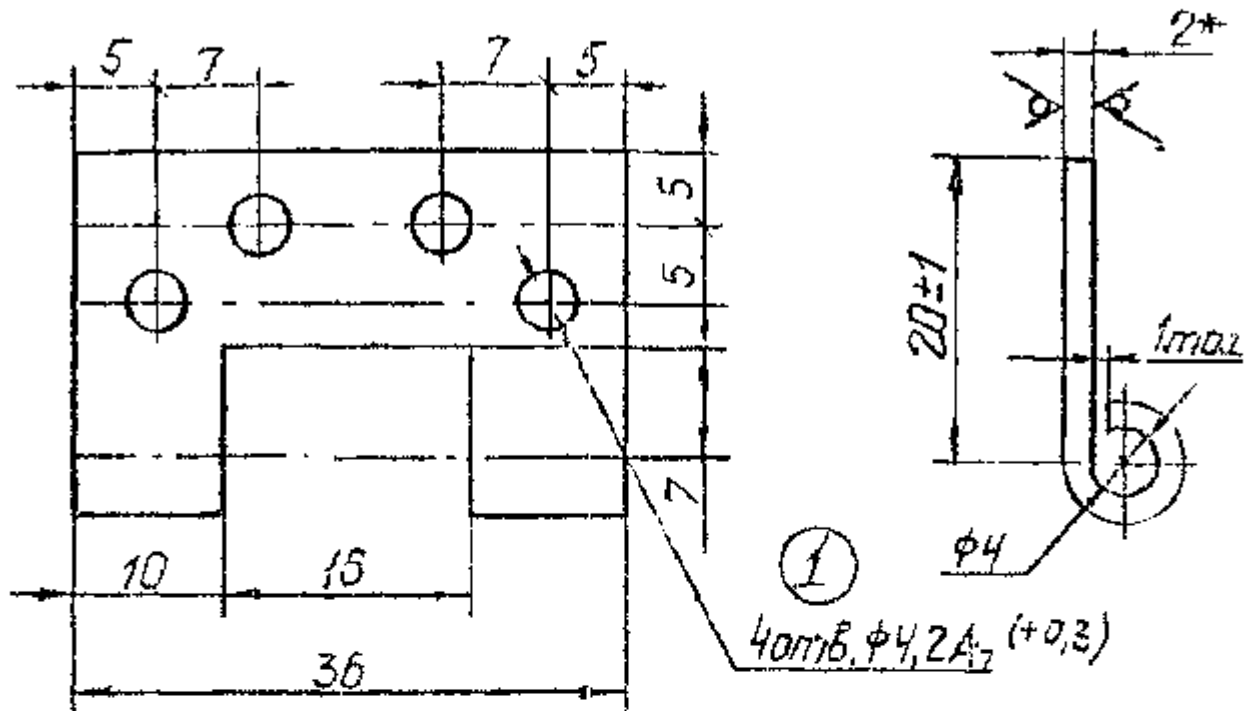
WEIGHT SCALE

0.005 1:1

SHT 1 SHTS 1

WIRE II-A-2.5, GOST 9389-75

Rz160
✓(V)



*(1) 4 holes, dia 4.2A₇ (+0.3)

1. Substitute material: sheet made of steel 15, 20, 08kn, ГОСТ 1050-74
2. Limit deviations of sizes are ±0.5mm unless otherwise specified.
3. *Size for reference.

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

675-64-778

UPPER HINGE

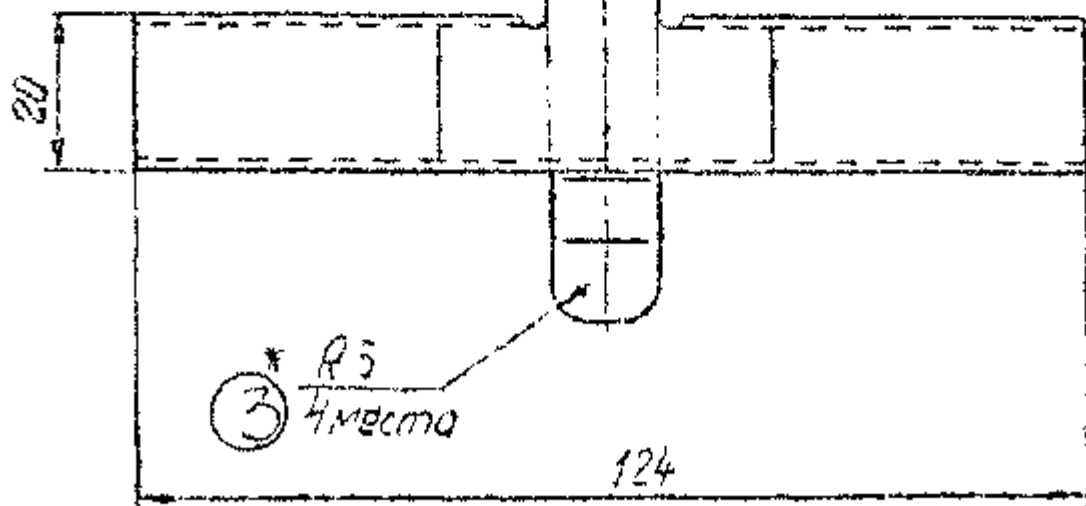
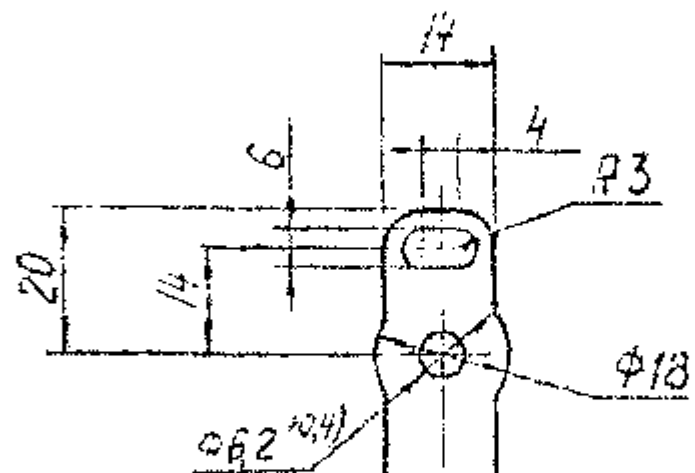
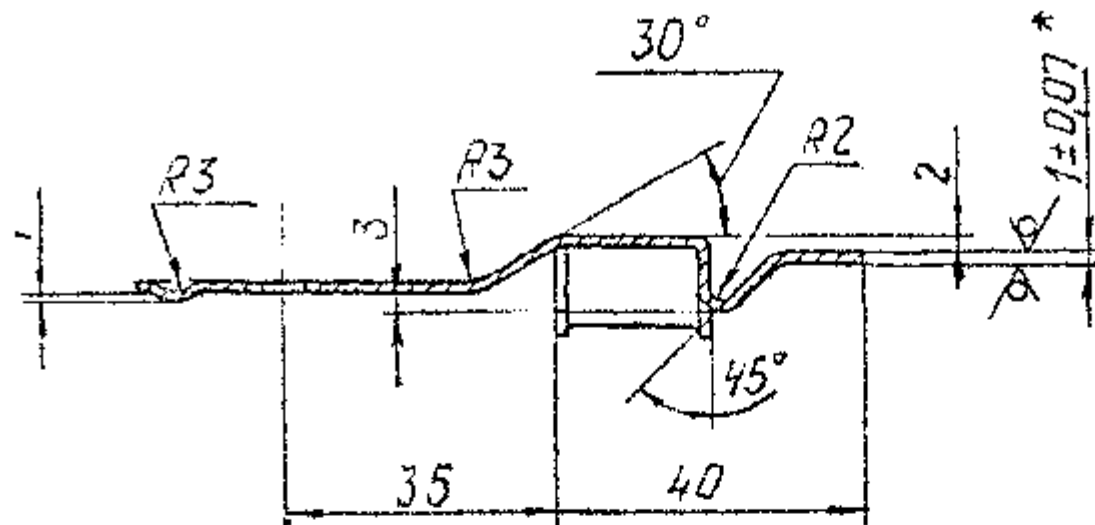
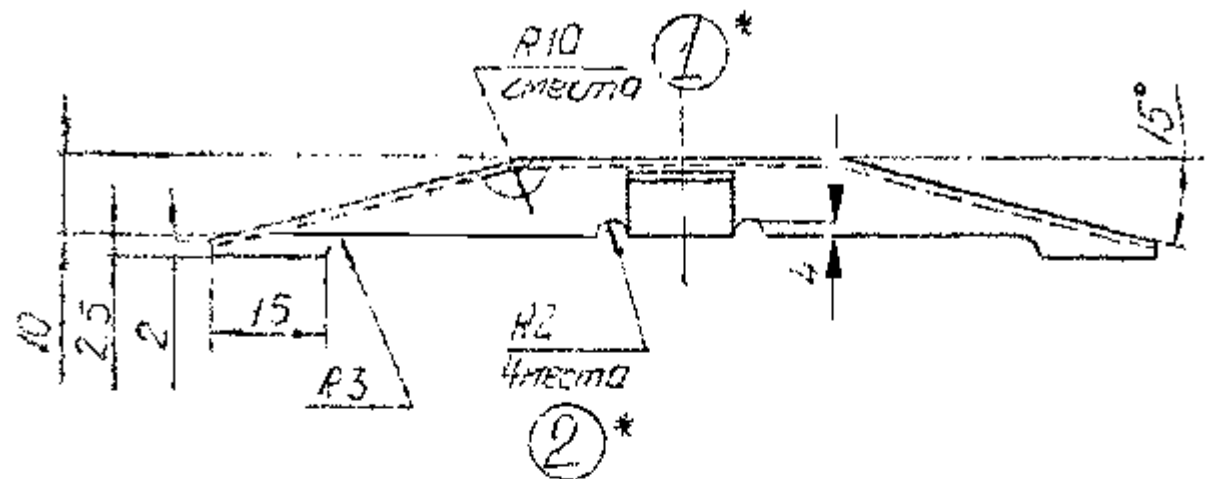
STEEL Б-ПГ-0-2, GOST 19904-74
SHEET 5-II-r-10, GOST 16523-70

WEIGHT SCALE

0.013 2:1

SHT 1 SHTS 1

675-64-783



* (1) 2 pieces

* (2) 4 pieces

* (3) 4 pieces

1. HRC 40 to 48, test group 5, OCT 3-1163-72.

2. Substitute material: steel 601, ГОСТ 14959-79.

3. Limit deviations of sizes are ± 0.5 mm unless otherwise specified.

4. Stamping radii should not exceed 1.5 mm unless otherwise specified.

5. Limit deviations of angular values are $\pm 1^\circ$ unless otherwise specified.

6. Coating: zinc plating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness.

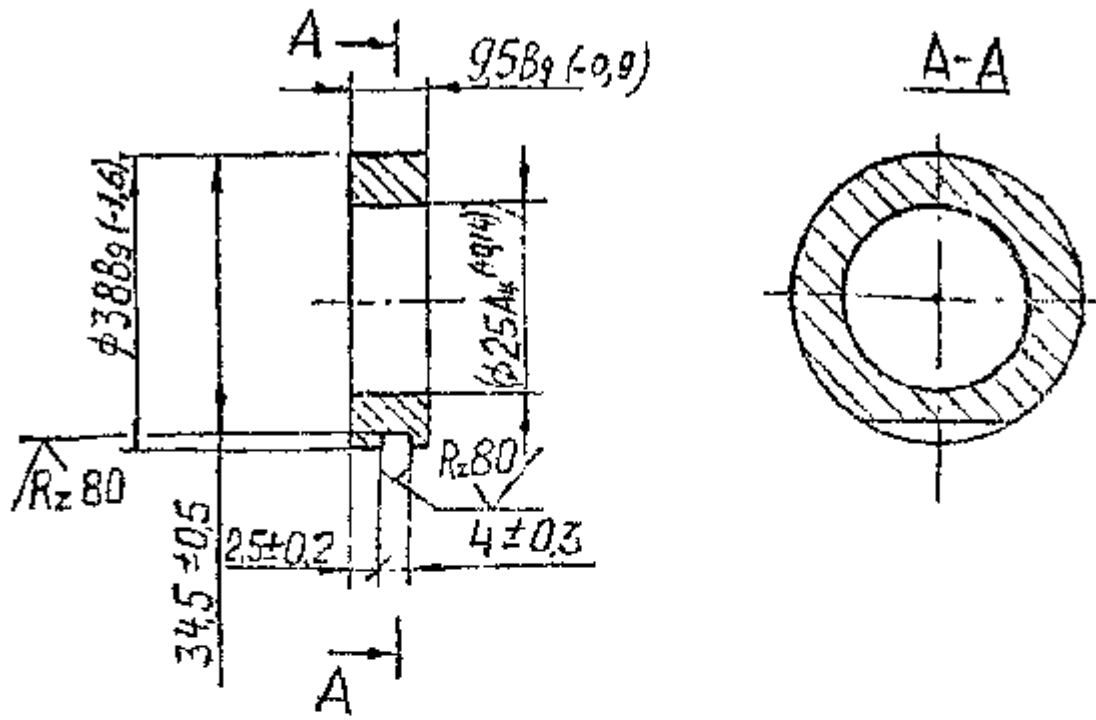
7. The sizes may be checked on a mandrel under a force of 29.4 N (3 kgf). Check the sizes before thermal treatment.

8. *Size for reference.

APPROVED	<i>[Signature]</i>	675-64-783	
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		WEIGHT	SCALE
		0.032	1:1
STEEL SHEET A-113-2-1-01 OCT 1994-74 II-65, ГОСТ 1542-71		SHT 1	SHTS 1

675-64-789

Rz 160 ✓ (✓)



1. Substitute material: bronze Ep A9X31, ГОСТ 493-79.
2. Casting radii should not exceed 1 mm.
3. The rest of the requirements are according to Technical Requirements of TM2-82.
4. The size in the brackets is an after-assembly size.

APPROVED *[Signature]*
 CHECKED *[Signature]*
 CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

675-64-789

BUSHING

BRONZE Ep.-7.7
 TI TM2-82

WEIGHT		SCALE	
0.022		1:1	
SHT 1	SHTS 1		

Ref. No.	Designation	Description	Qty	Remarks
	675-64-cd300 CE	<u>List of Documents</u> Tray		
		<u>Assembly Units</u>		
1	675-64-cd301	Lock	1	
2	675-64-cd302	Pillar	1	
3	675-64-cd303	Hinge	4	
4	675-64-cd306	Middle tray	1	
5	675-64-cd307	Tray	1	
6	675-64-cd308	Sprocket shaft	1	
7	675-64-cd325	Tray	1	
		<u>Parts</u>		
10	672-31-71	Tab washer	1	
11	672-3B-96	Spring	1	
13	675-64-640	Handle	1	
15	675-64-714	Gear	1	
16	675-64-715	Gear	1	
23	675-64-720	Tube	1	
24	675-64-721	Retainer	1	
27	675-64-722	Lug	2	
28	675-64-723	Lever	1	
29	675-64-724	Strap	2	
30	675-64-759	Safety pin	1	
31	700-31-15	Washer	1	
32	700-38-907	Spring	1	
33	700-40-88	Gasket	3	Max. qty
34	700-47-358-03	Axle	1	
		<u>Standard Items</u>		
38		Nut M6.6.019 FOCT 5927-70	3	
41		Rivet 4x10.35.10 FOCT 10300-68	32	
42		Rivet 4x14.36 Anodic oxidation with subsequent sealing in bichromate FOCT 10300-80	24	
45		Washer 6x1.01.019 or 6x1.02.019 FOCT 11371-78	70	Max. qty
49		Cotter pin 1.6x10.019 FOCT 397-79	1	
51		Lock pin 5Hp2 _{2a} x20 FOCT 3128-70, 2 chamfers	1	FB207 to 255 (dia. 4.2 to 3.8)

APPROVED
CHECKED

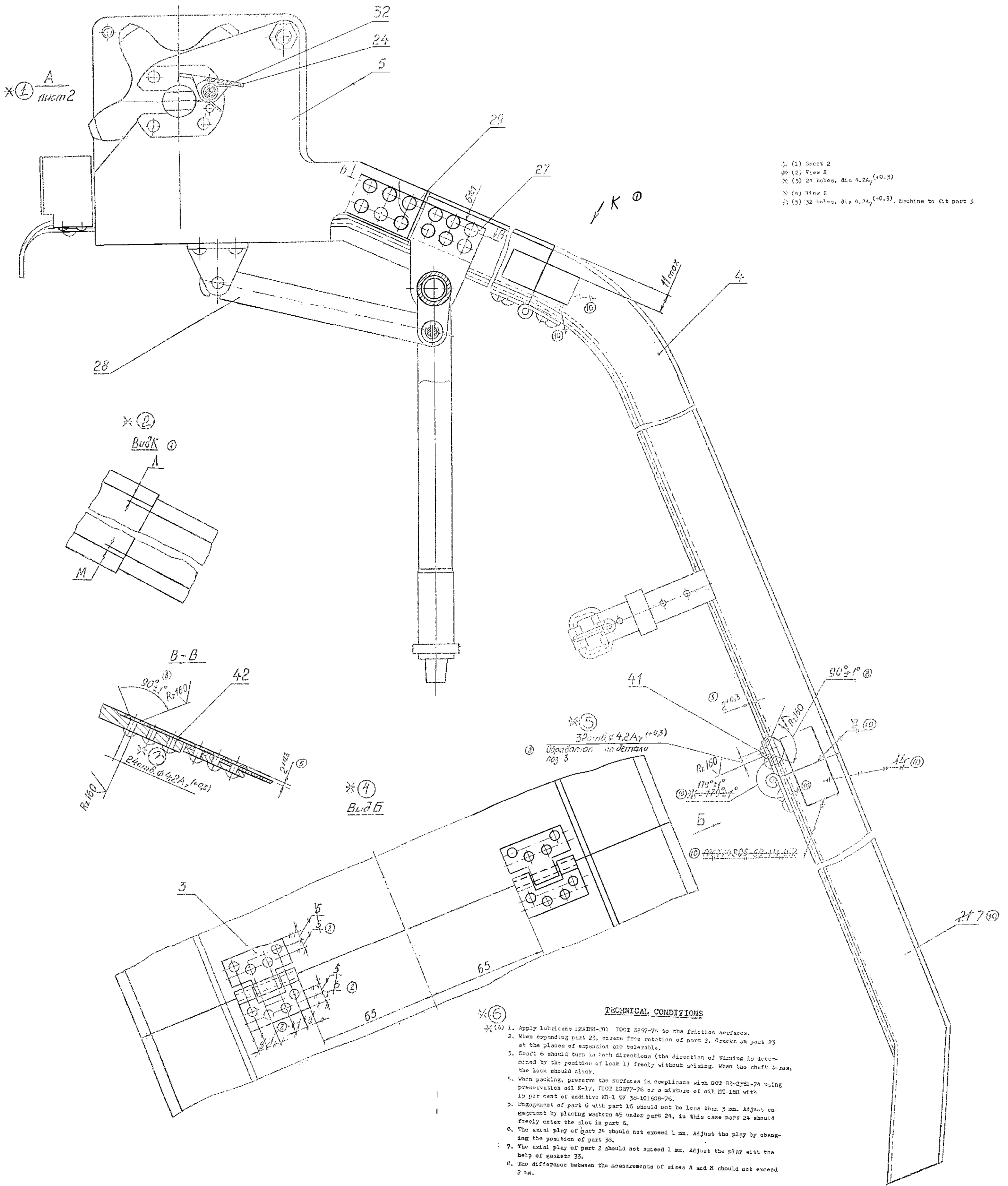
675-64-Sb300

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

TRAY

WEIGHT SCALE

SHU 1 SHS 1

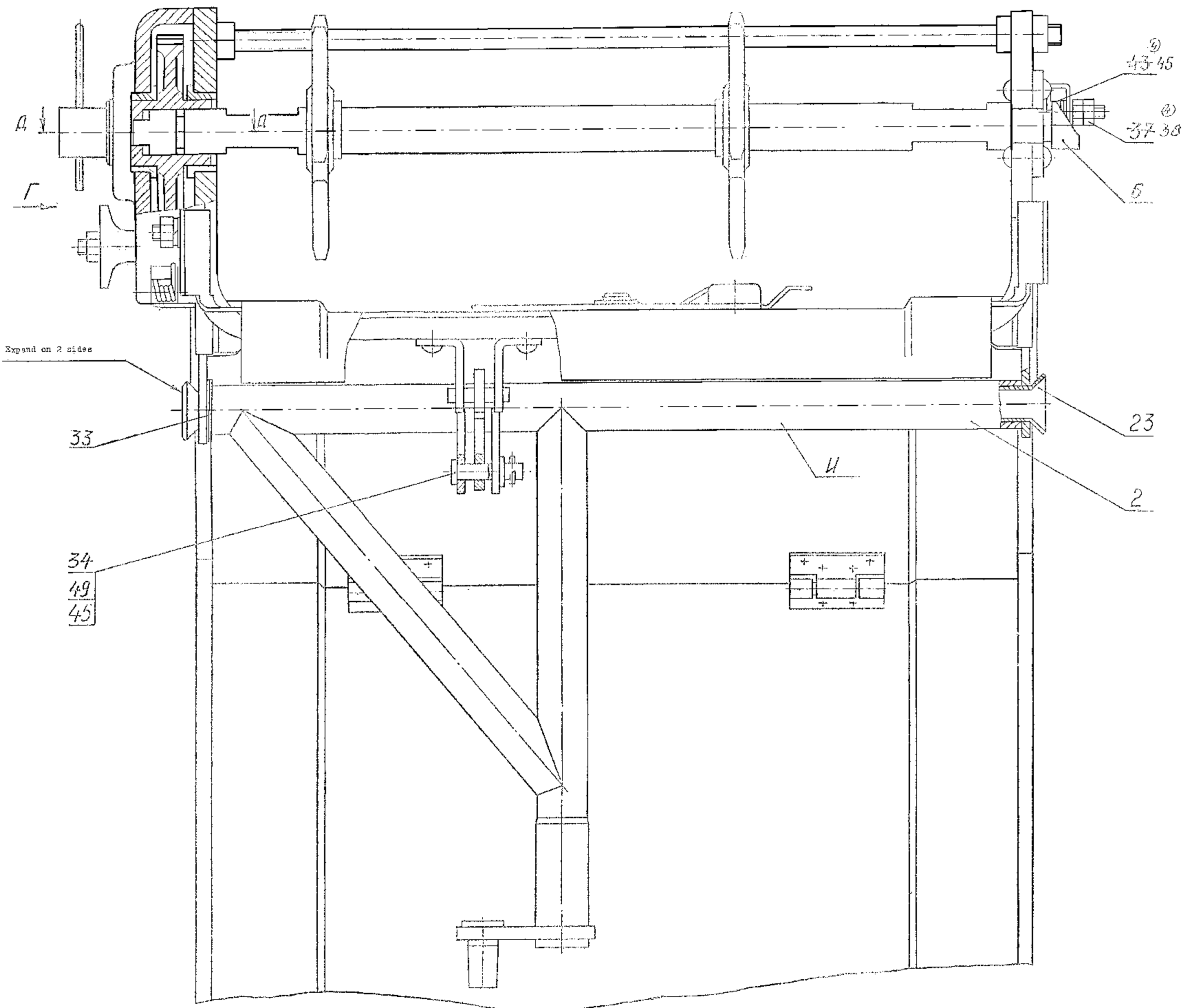


(1) Sheet 2
 (2) View K
 (3) 24 holes, dia 4.2A₇ (+0.3)
 (4) View B
 (5) 32 holes, dia 4.2A₇ (+0.3), machine to fit part 3

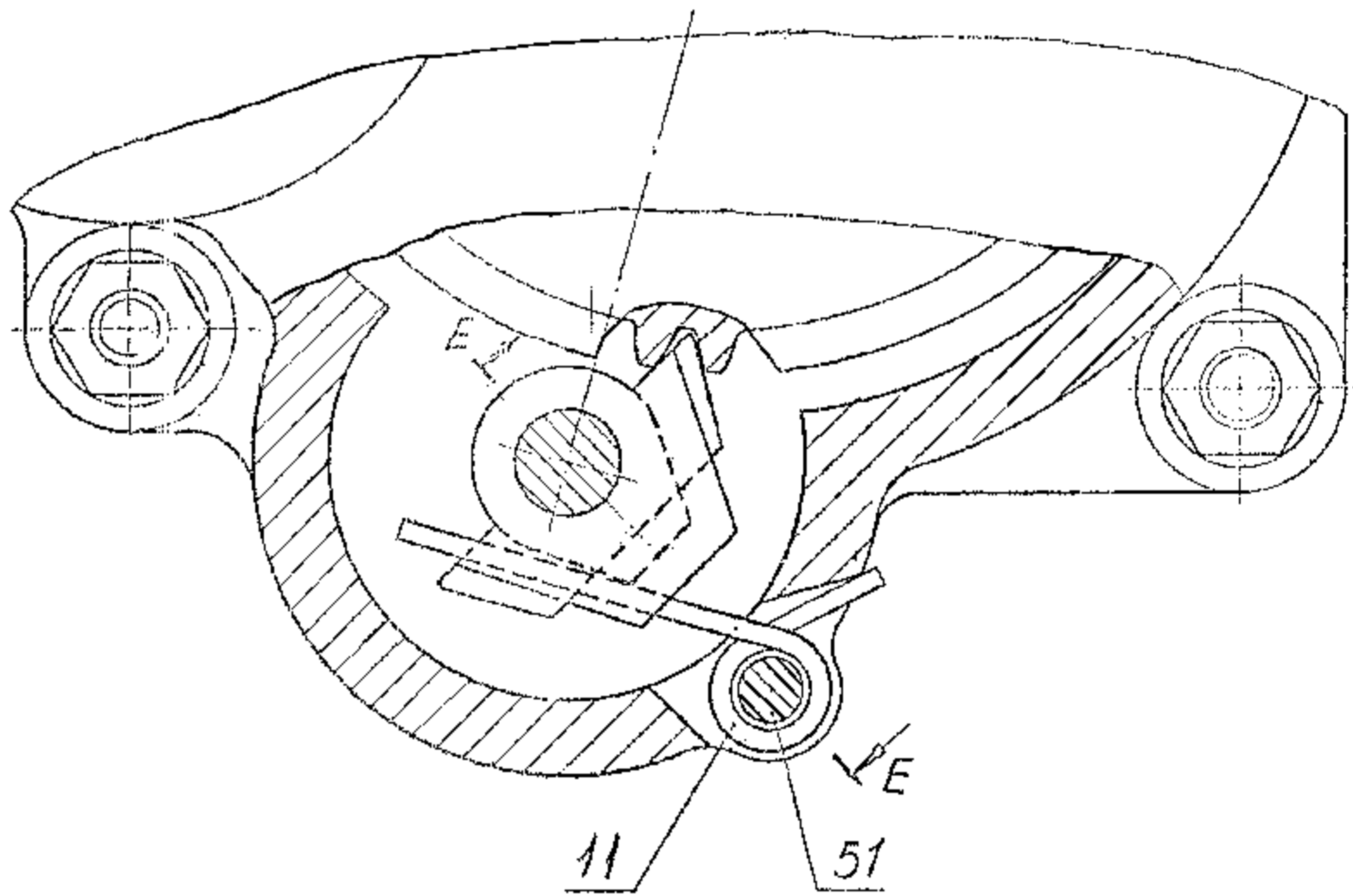
APPROVED
 CHECKED
 CONTROLLER
 OF
 QUALITY ASSURANCE
 (ICV)

675-64-Sb300Sb
TRAY
 ASSEMBLY DRAWING
 WEIGHT SCALE
 10.15 1:1
 SHT 1 SETS 2

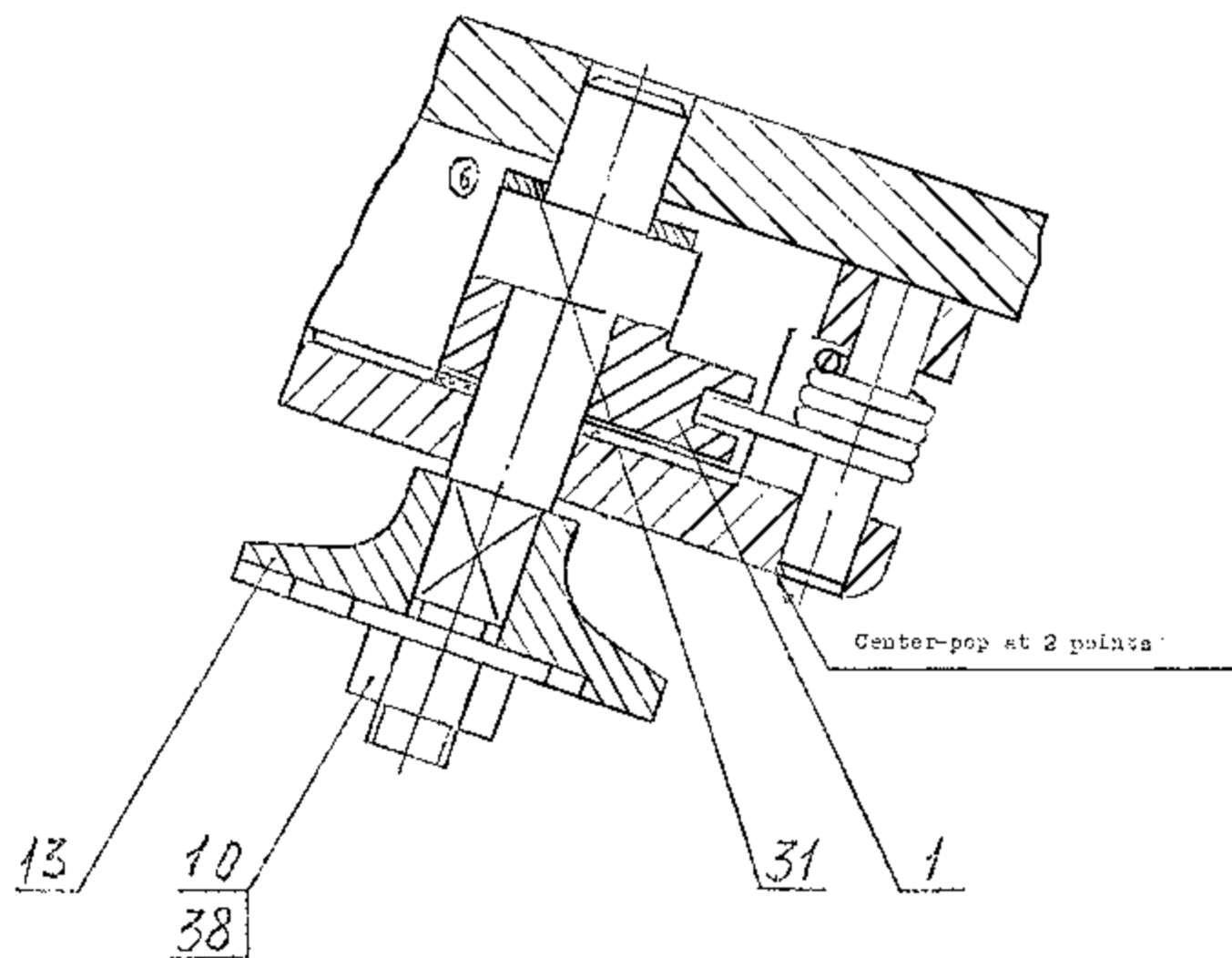
View A, sheet 1



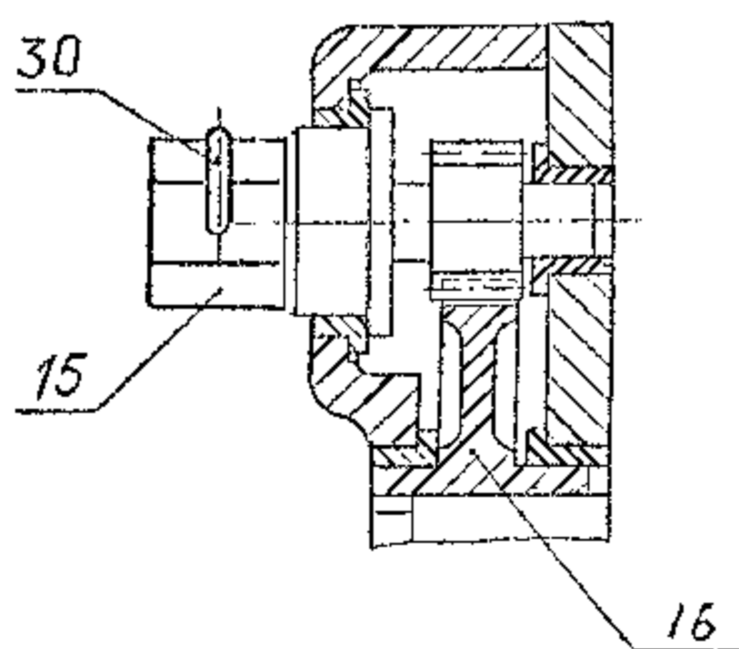
View F
Scale 2:1



View B
Scale 2:1



A-A



APPROVED *[Signature]*
 CHECKED *[Signature]*
 CONTROL RATE
 OF
 QUALITY ASSURANCE
 (ICV)

675-64-Sb300Sb

TRAY
ASSEMBLY DRAWING

WEIGHT	SCALE
SHT 2	SHTS 2

Ref. No.	Designation	Description	Qty	Remarks
	675-64-cd301 CB	<u>List of Documents</u> Assembly drawing		
		<u>Parts</u>		
1	675-64-691	Ratchet	1	
2	675-64-692	Axle	1	
		<u>Standard Items</u>		
5		Lock pin 31p2 _{2a} x12 FOCT 3128-70 2 chamfers	1	HB 207 to 257 (dia 4.2 to 3.8)

APPROVED



CHECKED



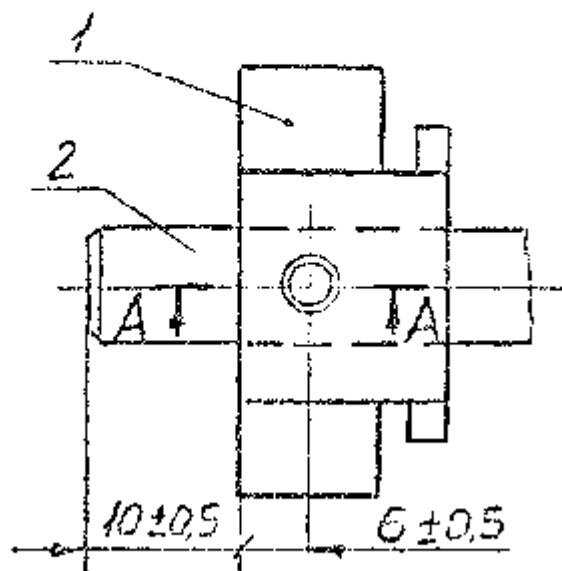
675-64-Sb301

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

LOCK

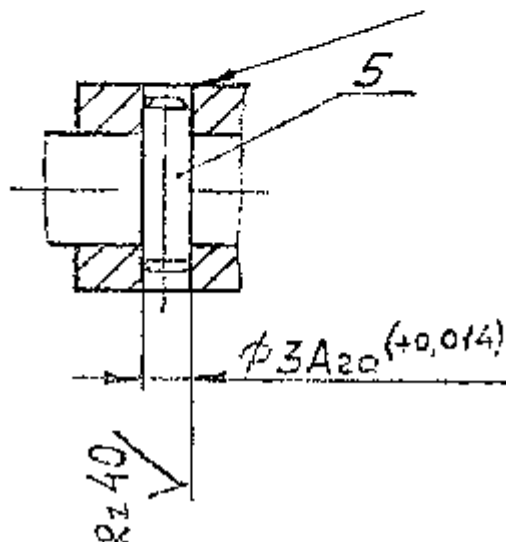
WEIGHT SCALE

SHT SH'S 1



A-A

Center-pop around the circumference on 2 sides



APPROVED

CHECKED

675-64-Sb301Sb

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)


LOCK

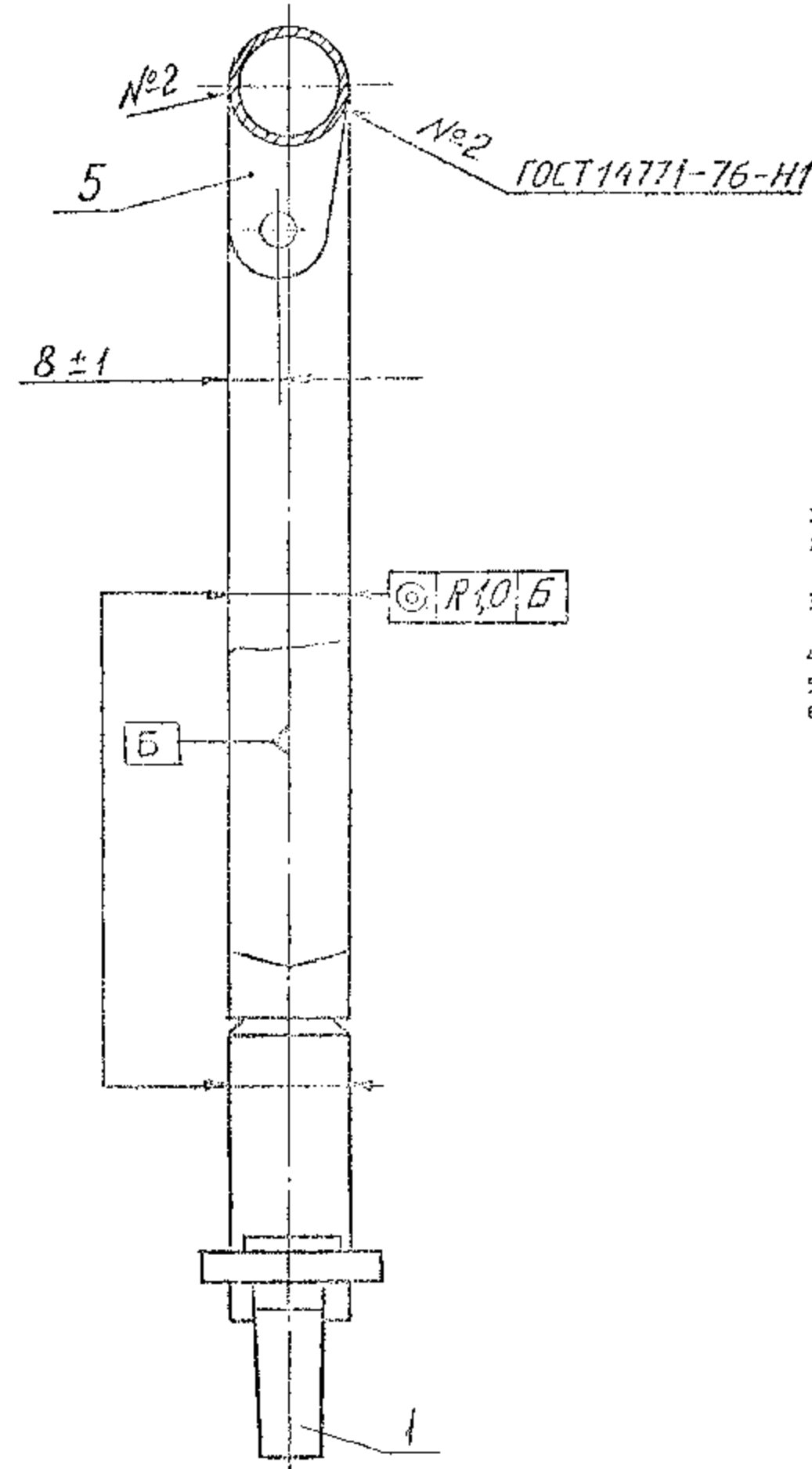
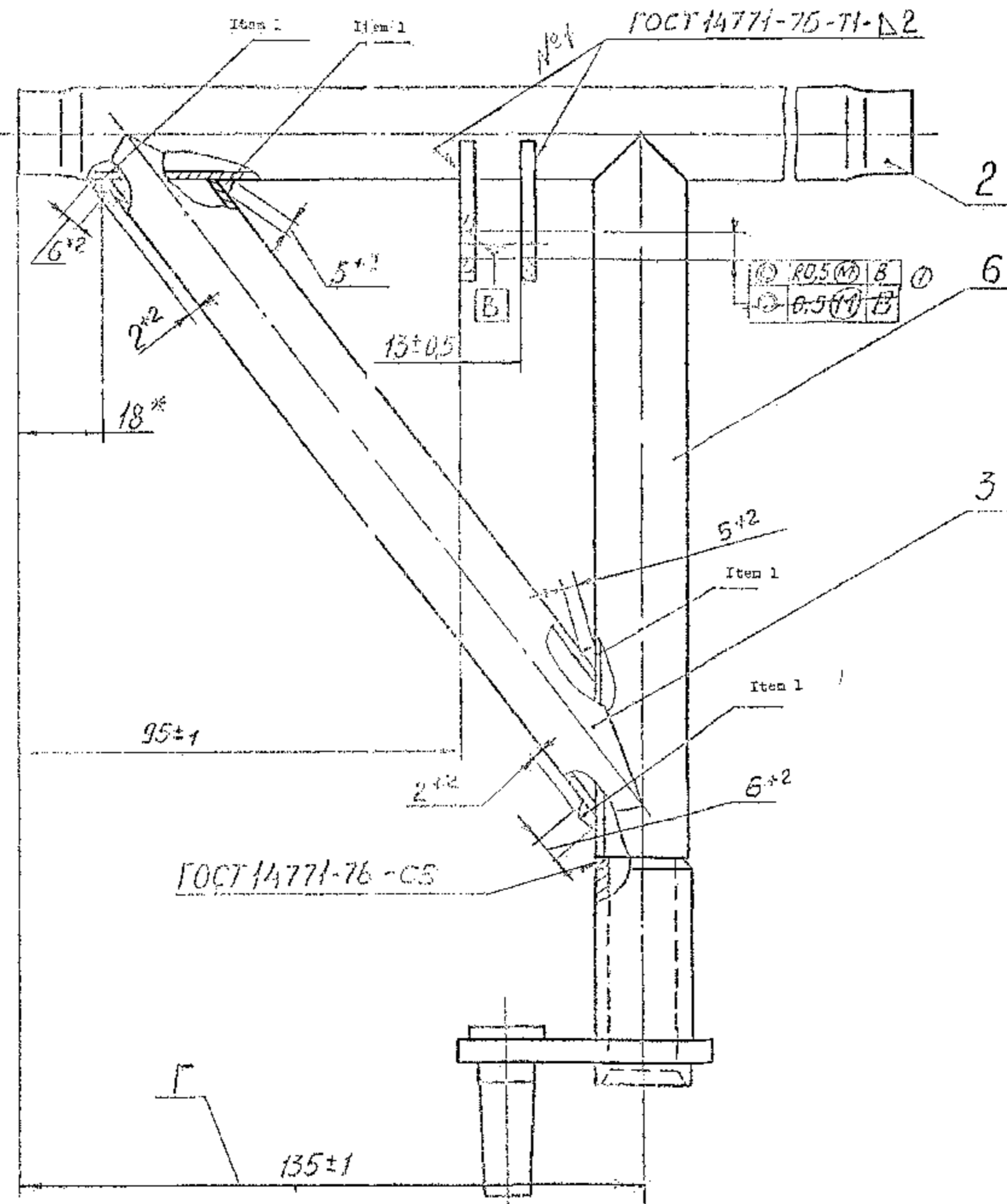
WEIGHT SCALE

0.066 2:1

SHT SIITS 1

Ref. No.	Designation	Description	Qty	Remarks
		<u>List of Documents</u>		
	675-64-c6302 CH	Assembly drawing		
		<u>Assembly Units</u>		
1	675-64-c6305	Support	1	
		<u>Parts</u>		
2	675-64-694	Tube	1	
3	675-64-695	Jib	1	
5	675-64-697	Lug	2	
6	675-64-698	Pillar	1	



APPROVED		675-64-Sb302		
CHECKED	<i>SUPKORD</i>	PILLAR		WEIGHT
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				SCALE
			SHT	SHTS

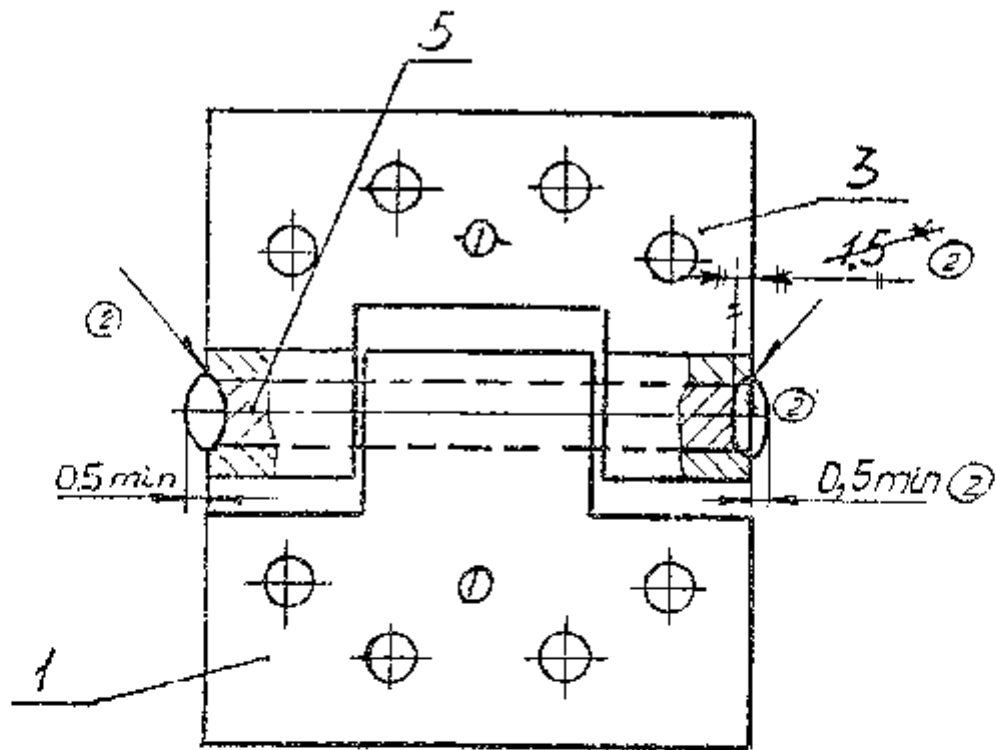


1. Electric arc welding, ГОСТ 14771-76.
2. The requirements for the quality of the welds are according to OCT 3-4001-77 for unspecified welded joints.
3. Coating: zinc plating followed by chromate treatment, zinc coat 9 microns thick. Remove hydrogen brittlest. Absence of coating on inner surfaces is tolerable.
4. Size F is given for welding of part 6.
5. Do not check the quality of coating at welds.
6. *Size for reference.

APPROVED	<i>[Signature]</i>	675-64-Sb302Sb		
CHECKED	<i>[Signature]</i>			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		PILLAR	WEIGHT	SCALE
			0.504	1:1
			SHT	SHTS

Ref. No.	Designation	Description	Qty	Remarks
		<u>List of Documents</u>		
	675-64-c6303	Assembly drawing		
		<u>Parts</u>		
1	675-64-699	Lower hinge	1	
3	675-64-778	Upper hinge	1	
		<u>Materials</u>		
5		Wire 4.0-C-I TUCF 3282-74 L = 33 mm	1	


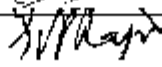
APPROVED		675-64-Sb303		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		HINGE		
			SHT	SHT'S

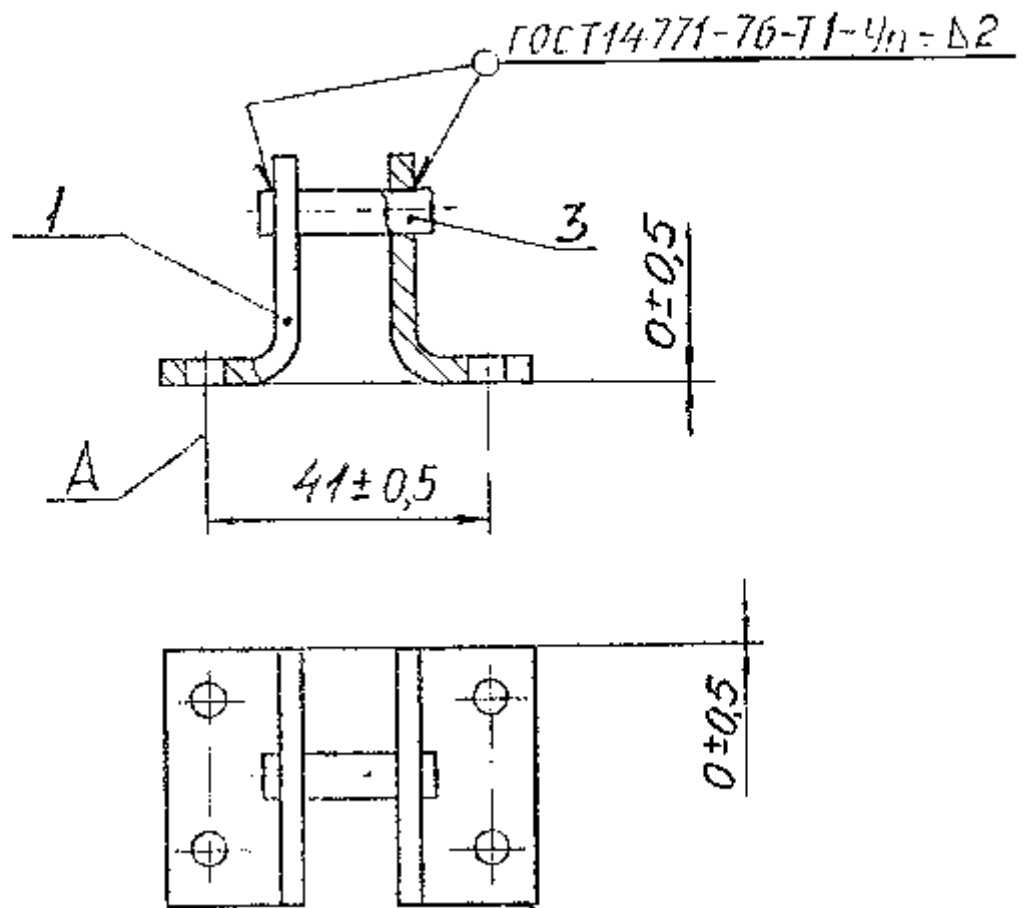


1. CO₂-shielded welding, ГОСТ 14771-76.
2. *Size for reference.
3. The requirements for the quality of the weld are according to OCT 5-4001-77 for unspecified welded joints.
4. Coating: zinc plating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness.

APPROVED	<i>[Signature]</i>	675-64-Sb303Sb		
CHECKED	<i>[Signature]</i>			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	HINGE		WEIGHT	SCALE
			0.044	2:1
			SHT	SHTS

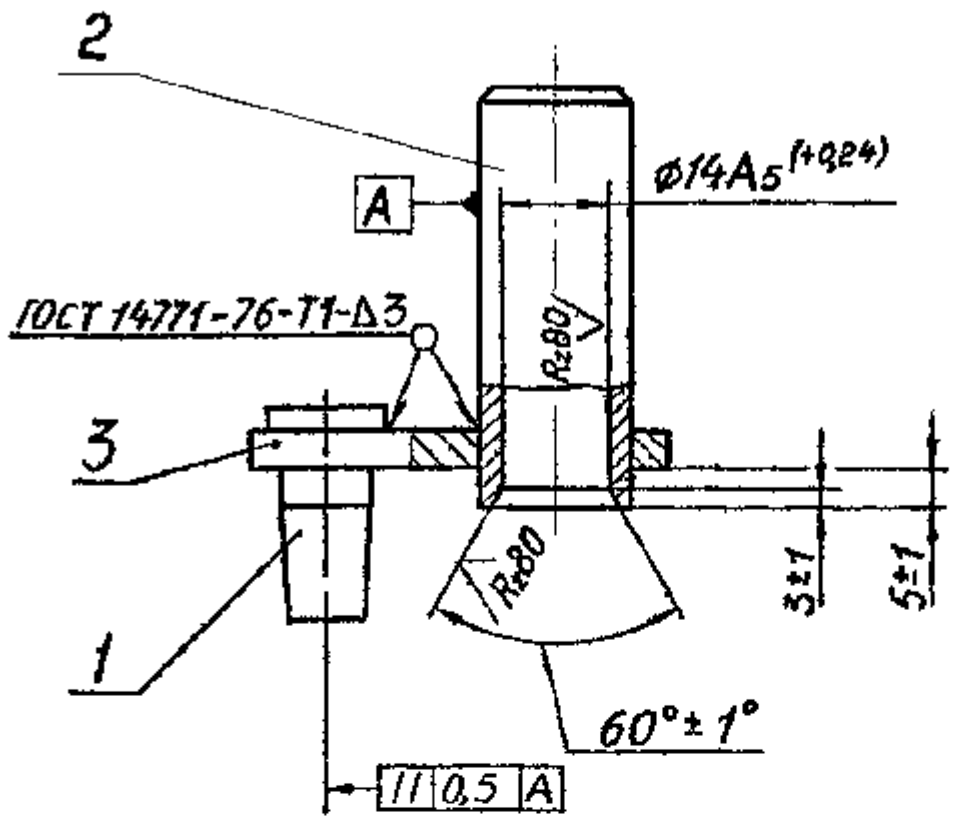
Ref. No.	Designation	Description	Qty	Remarks
		<u>List of Documents</u>		
	675-64-c6304 CE	Assembly drawing		
		<u>Parts</u>		
1	675-64-700	Lug	2	
		<u>Standard Items</u>		
3		Lock pin 67p2 _{2a} x25 TOCT 3128-70	1	HB 207 to 255 (dia 4.2 to 3.8)

APPROVED		675-64-Sb304		
CHECKED		BRACKET		WEIGHT
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				SCALE
		SHT	SHTS	



1. The requirements for the quality of the welds are according to OCT 3-4001-77 for unspecified welded joints.
2. Coating: zinc plating followed by chromate treatment, zinc coat 9 microns thick. Eliminate hydrogen brittleness.

APPROVED	<i>[Signature]</i>	675-64-Sb304Sb		
CHECKED	<i>[Signature]</i>			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	BRACKET		WEIGHT	SCALE
			0.05	1:1
		SIT	SHTS	



OCT 14771-76-71-A3

(1) 1. The requirements for the quality of the welds are according to OCT 3-4001-77 for unspecified welded joints.

APPROVED *[Signature]*
 CHECKED *[Signature]*
 CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

675-64-Sb305Sb

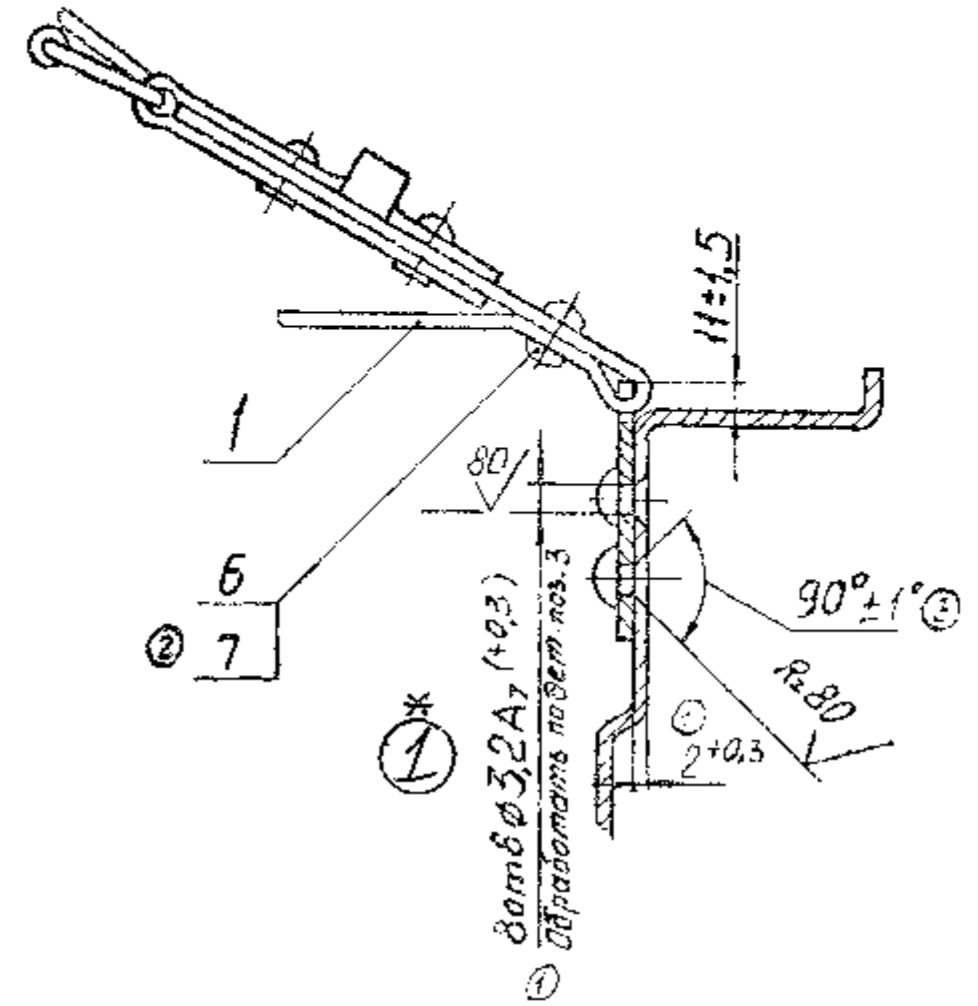
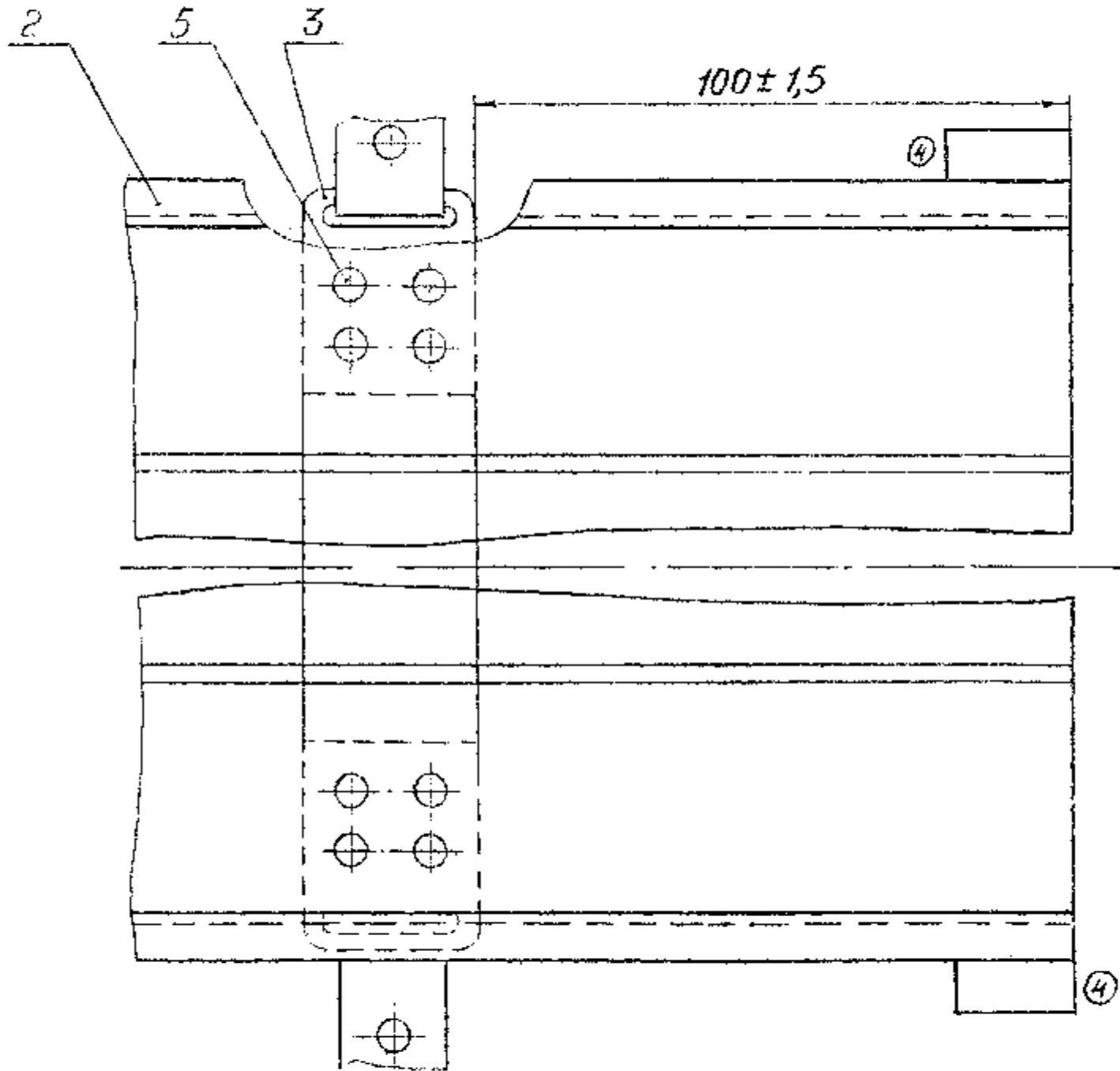
SUPPORT
 ASSEMBLY DRAWING

WEIGHT		SCALE	
0.14		1:1	
SHT 1	SHTS 1		

Ref. No.	Designation	Description	Qty	Remarks
		<u>List of Documents</u>		
	675-64-06306 CE	Assembly drawing		
		<u>Assembly Units</u>		
1	675-64-06318	Belt	2	
2	675-64-06326	Troy	1	
		<u>Parts</u>		
3	675-64-705	Lug	2	
		<u>Standard Items</u>		
5		Rivet 3x10.36	8	
		Anodic oxidation with subsequent sealing in bichromate 100T 10300-80		
6		Rivet steel, nickel plated 3X-25 002 17-600-75	2	
7		Washer 4.01.019 or 4.02.019 700T 11371-78	2	

APPROVED	<i>CPO</i>	675-64-Sb306		
CHECKED	<i>JVP/low</i>			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		MIDDLE TRAY		
			SHT	SIITS

675-64-Sb306Sb



* (1) 8 holes, dia 3.2A7 (+0.3), Machine to fit part 3


APPROVED *Ch*
 CHECKED *Suplov*
 CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

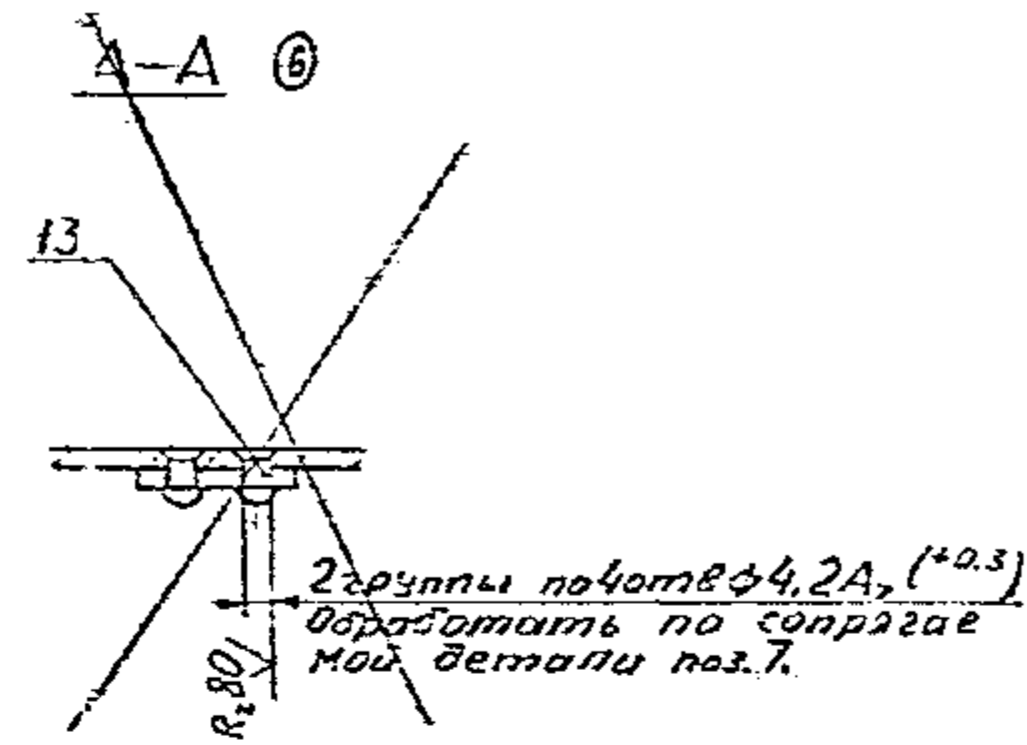
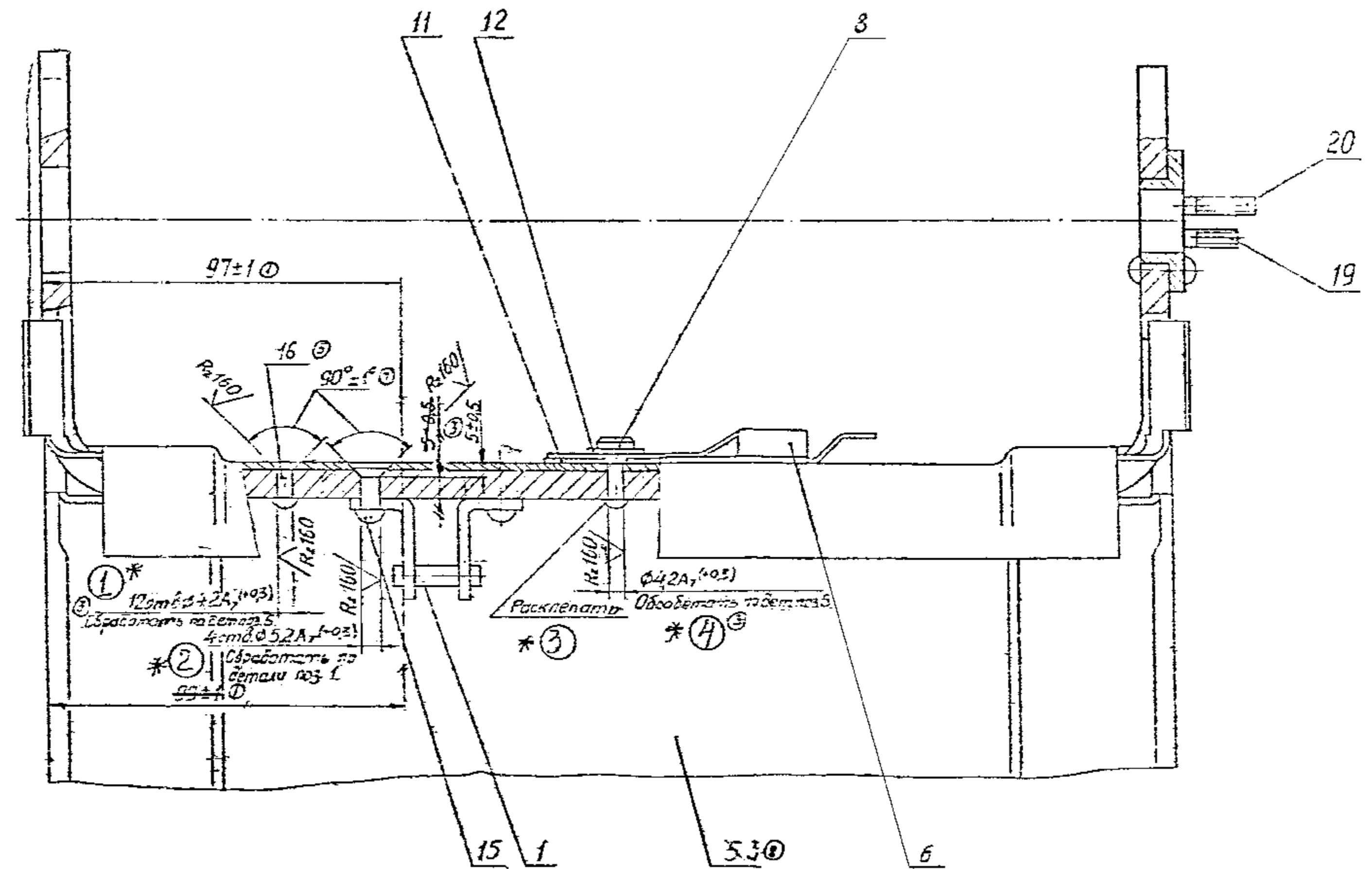
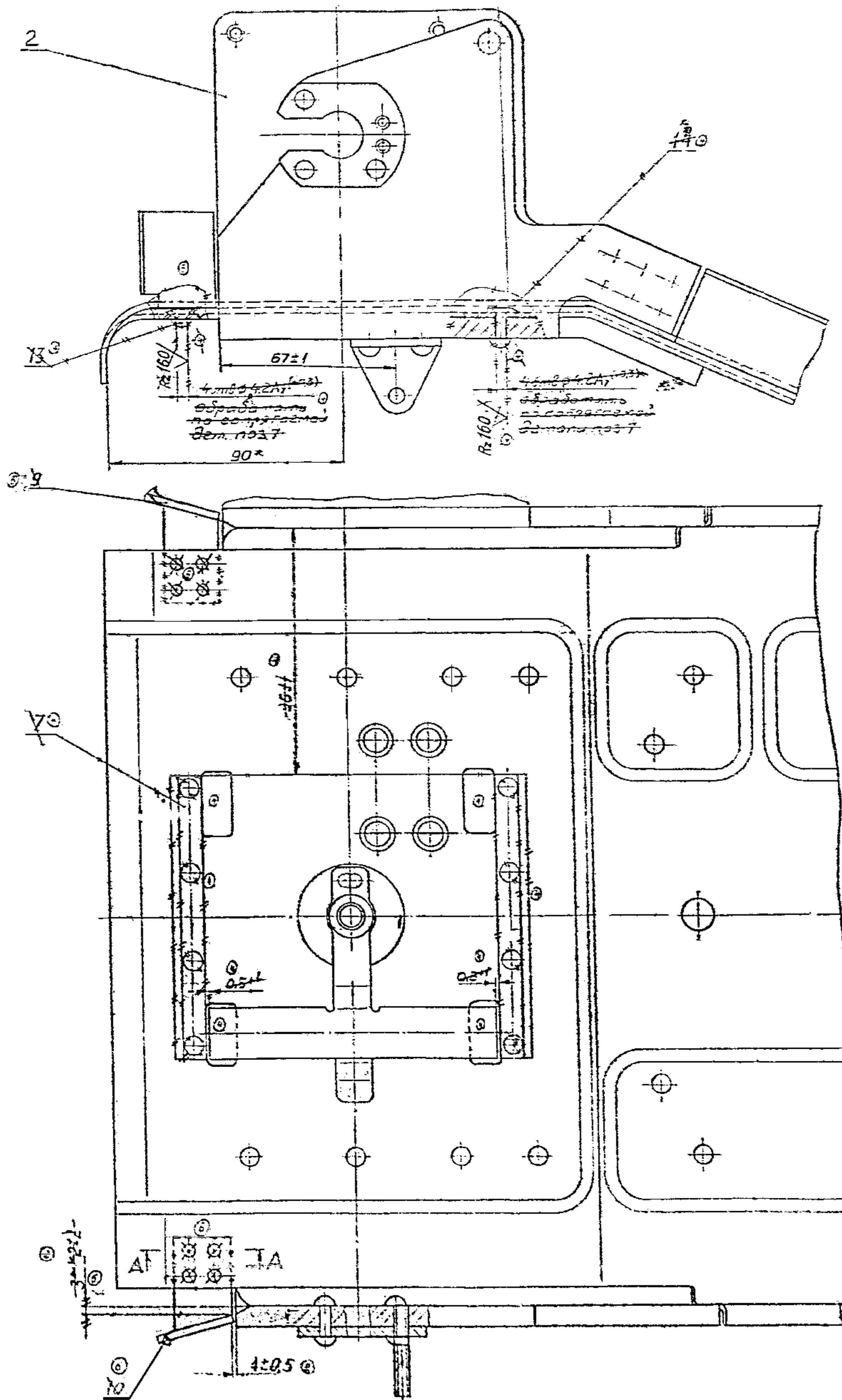
675-64-Sb306Sb

TRAY

WEIGHT	SCALE
1.68	1:1
SHI	SIITS

Ref. No.	Designation	Description	Qty	Remarks
	675-64-c6307 CE	<u>List of Documents</u> Assembly drawing <u>Assembly Units</u>		
1	675-64-c6304	Bracket	1	
2	675-64-c6310	Housing	1	
3	675-64-c6324	Tray	1	
		<u>Parts</u>		
6	675-64-783	Guide	1	
8	675-64-710	Rivet	1	
11	700-31-432	Washer	1	
12	700-31-632	Washer	1	
		<u>Standard Items</u>		
16		Rivet 4x16.36 Anodic oxidation with sub- sequent sealing in bichro- mate TOCT 10300-80	12	
19		Stud M5 x $\frac{T_2}{5g}$ x 16.66.019	1	
20		TOCT 22036-76 Stud M6 x $\frac{T_1}{8g}$ x 25.66.019	1	
15		TOCT 22036-76 Rivet 5x16.36 Anodic oxidation with sub sequent sealing in bichro mate TOCT 10299-80	4	

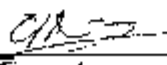
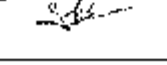
APPROVED		675-64-Sb307			
CHECKED					
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		UPPER TRAY		WEIGHT	SCALE
				SHT 1	SIITS 1

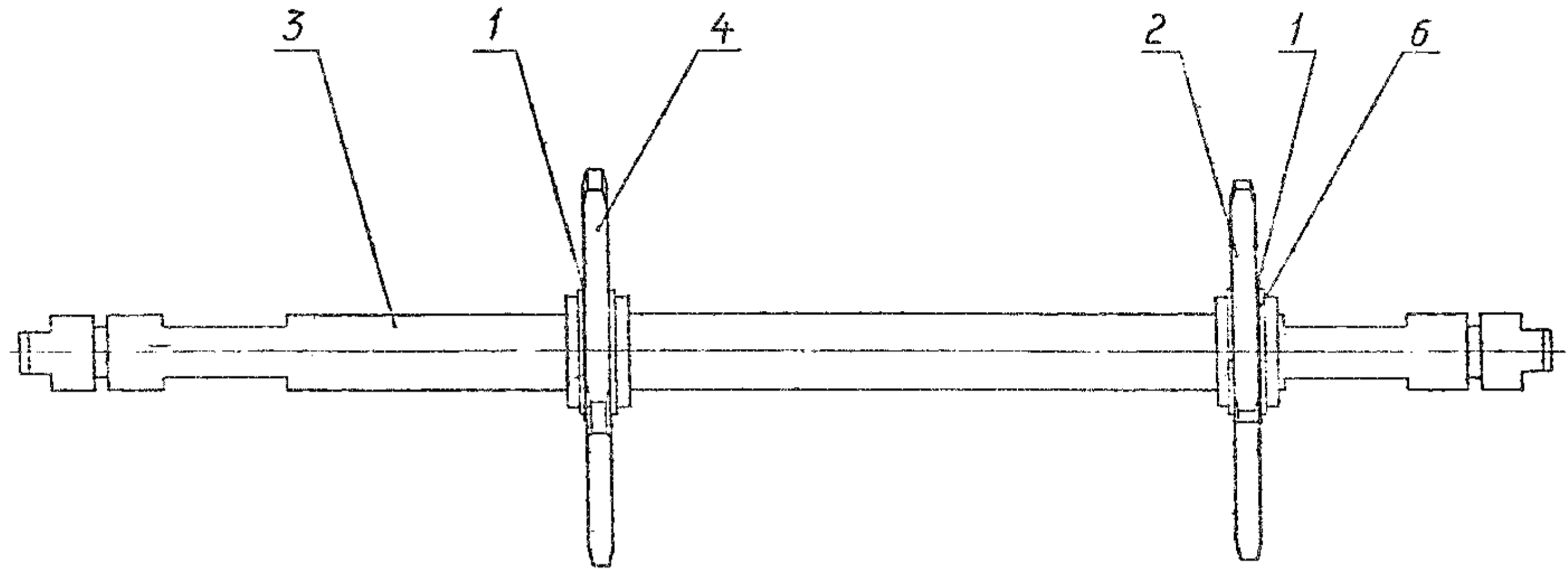
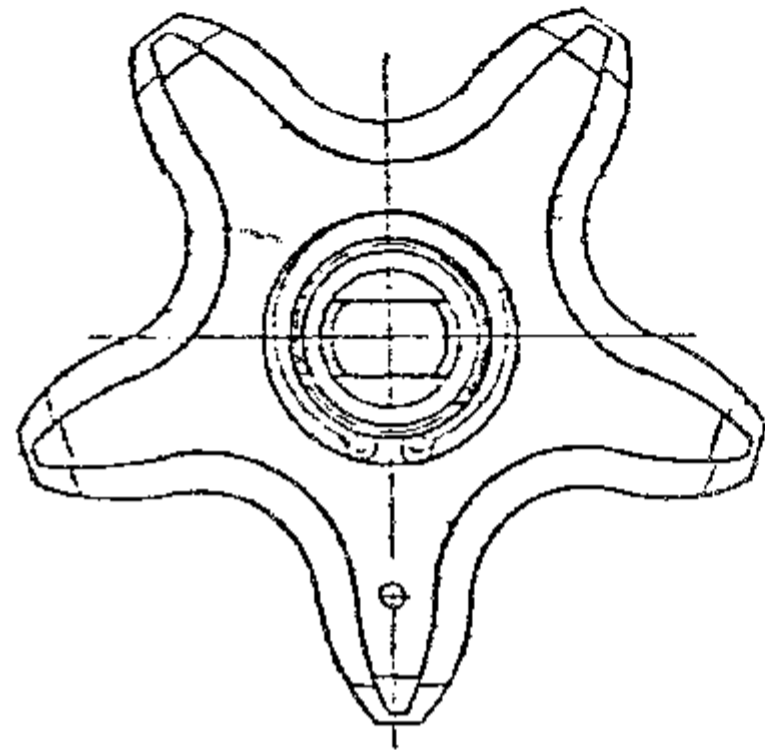


- TECHNICAL CONDITIONS**
- *1. 12 holes, dia 4.24 (+0.3). Machine to fit part 5
 - *2. 4 holes, dia 5.24 (+0.3). Machine to fit part 1
 - *3. Peen down
 - *4. Machine to fit part 5.
 - 5. 1. Part 6 should freely rotate on part 9.
 - 2. Part 6 should reliably enter the slots of assembly 5.
 - 3. *Size for reference.
 - 4. Fit the studs on paste zinc white paint, OCT 482-77 and turn them in as far as they will go.

APPROVED		675-64-SB307Sb	
CHECKED	<i>[Signature]</i>	WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		3.508	1:1
		SHT	SHTS

Ref. No.	Designation	Description	Qty	Remarks
	675-64-c6308 CE	<u>List of Documents</u> Assembly drawing		
		<u>Parts</u>		
1	675-64-306	Washer	10	Max. qty
2	675-64-702	Sprocket	1	
3	675-64-725	Shaft	1	
4	675-64-730	Sprocket	1	
		<u>Standard Items</u>		
6		Ring 1E2E FOCT 13940-68	4	

APPROVED		675-64-Sb308			
CHECKED					
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		SPROCKET SHAFT		WEIGHT	SCALE
				SHI	SHTS





TECHNICAL CONDITIONS

1. Axial play of parts 2 and 4 should not exceed 0.3 mm. Adjust the play with the help of washers 1.
2. When fitting part 2, align the symmetry axis of the teeth with the symmetry axis of the teeth of part 4.

APPROVED		675-64-Sb308Sb			
CHECKED	<i>[Signature]</i>				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		SPROCKET SHAFT		WEIGHT	SCALE
				1.36	1:1
		SHT	SHTS		

Ref. No.	Designation	Description	Qty	Remarks
		<u>List of Documents</u>		
	675-64-c6310 CS	Assembly drawing		
		<u>Assembly Units</u>		
1	675-64-c6327	Body	1	
		<u>Parts</u>		
4	675-64-701	Bushing	1	
5	675-64-706	Base	1	
6	675-64-716	Bushing	1	
7	675-64-717	Bushing	1	
8	675-64-729	Brace	1	
		<u>Standard Items</u>		
9		Nut M6. 6.019	4	
10		FOCT 5927-70		
		Nut M8. 6.019	4	
		FOCT 5927-70		
12		Washer 6T65F.06	4	
		FOCT 6402-70		
13		Washer 8T65F06	4	
		FOCT 6402-70		
14		Washer 6x1.01.019	4	
		or 6x1.02.019		
		FOCT 11371-68		
15		Screw M4. 8x1.0x6.019	6	
		FOCT 1476-75		
11		Rivet 4x20.36	3	
		Anodic oxidation with subsequent anodizing in bichromate FOCT 10299-80		
17		Stud M6 x $\frac{T_1 2}{8g}$ x 16. 66.019	4	
		FOCT 22034-76		
18		Lock pin 5Hp2 _{2g} x14	2	HB 207 to 255 (dia 4.2 to 3.8)
		FOCT 3128-70, 2 chamfers		

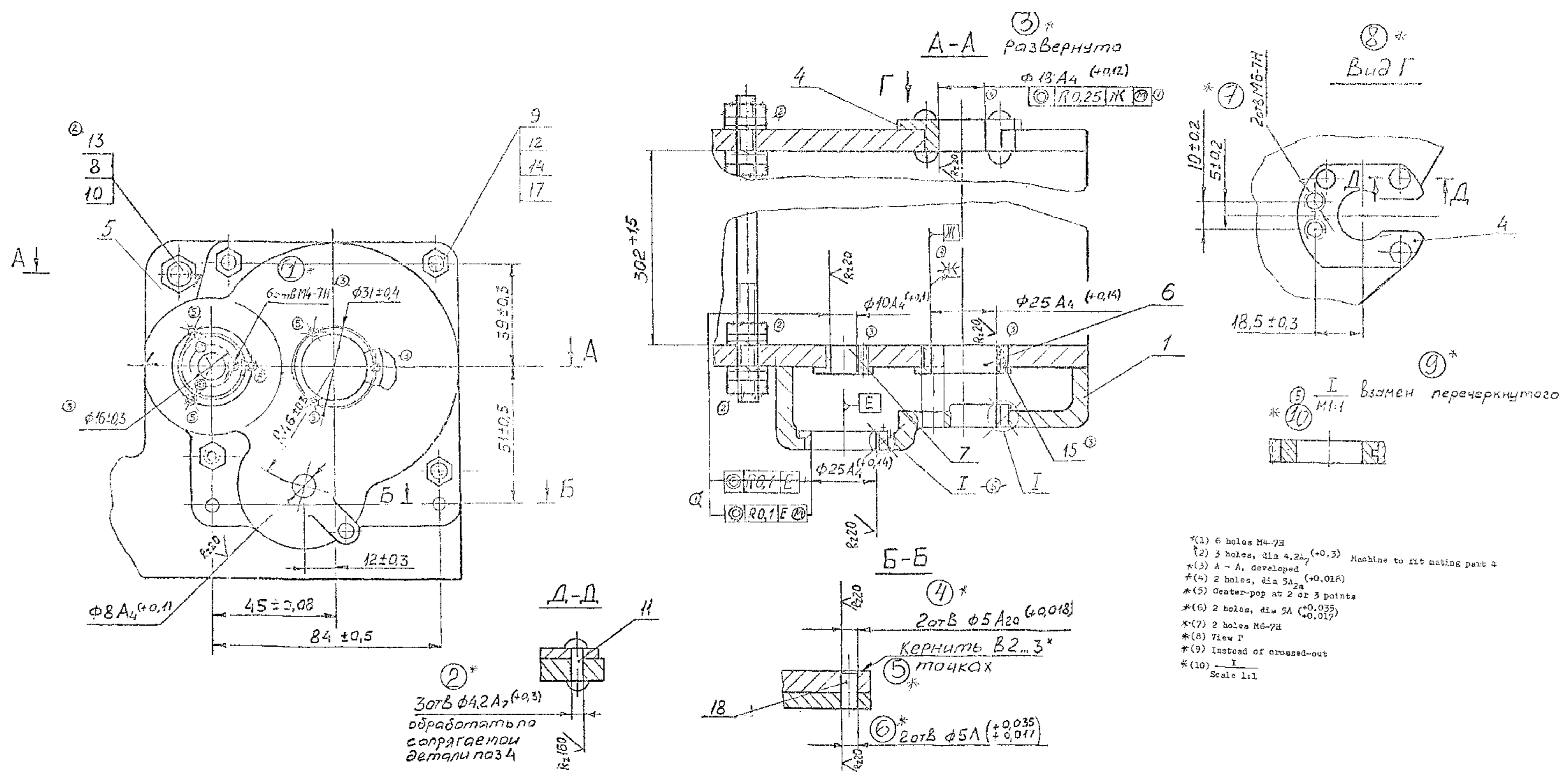
APPROVED 
CHECKED 
CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

675-64-Sb310

HOUSING

WEIGHT SCALE

SHT SHTS



- * (1) 6 holes M4-7H
- * (2) 3 holes, dia 4,2 (+0,3) Machine to fit mating part 4
- * (3) A - A, developed
- * (4) 2 holes, dia 5A (+0,01A)
- * (5) Center-pop at 2 or 3 points
- * (6) 2 holes, dia 5A (+0,035)
- * (7) 2 holes M6-7H
- * (8) View Г
- * (9) Instead of crossed-out
- * (10) $\frac{I}{M1:1}$ Scale 1:1



②*
Зотв $\phi 4,2 A_7 (+0,3)$
обработать по
сопрягаемой
детали поз 4

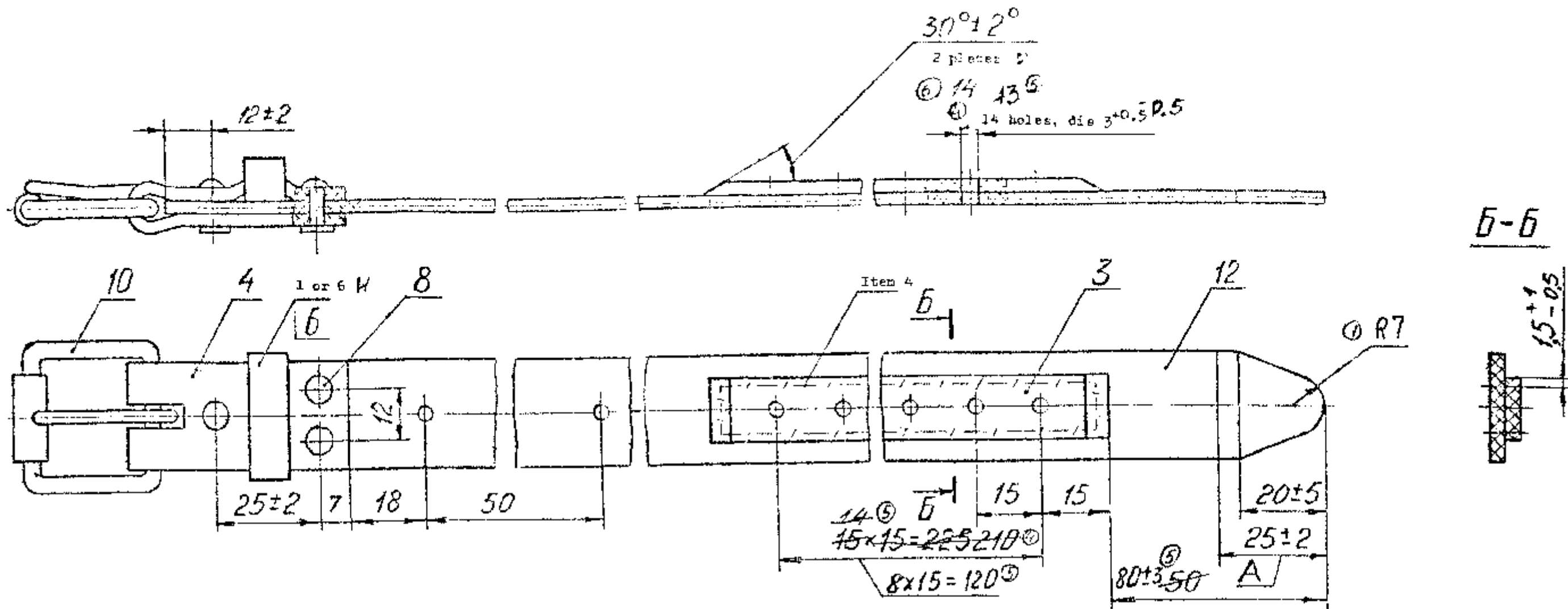
④*
Зотв $\phi 5 A_2 (+0,018)$
кернить $B2 \dots 3^*$
точках

⑤*
Зотв $\phi 5 A_1 (+0,035)$
 $\pm 0,017$

APPROVED	<i>[Signature]</i>	675-64-Sb310Sb	
CHECKED	<i>[Signature]</i>	HOUSING	WEIGHT
CONTROLLERATE OF QUALITY ASSURANCE (ICV)			2.28
		SHT	SHTS
		1	1

Ref. No.	Designation	Description	Qty	Remarks
		<u>List of Documents</u>		
	675-64-c6318 GB	Assembly drawing		
		<u>Assembly Units</u>		
1	700-10-c6446	Belt loop		1 pc., may be replaced with part 6
		<u>Parts</u>		
4	701-267-162	Strap	1	1 pc., may be replaced with part 1
6	765-94-768	Belt loop		
3	765-94-82	Strap	1	
		<u>Standard Items</u>		
8		Rivet steel, nickel-plated 3X-25 OCT 17-600-76	3	
10		Buckle N-10-08, steel, zinc-plated OCT 17-602-76	1	
12		Belt strip NPT 25x3.1; grade 1 OCT 16996-71 L = (460 ±3) mm	1	

APPROVED		675-64-Sb318			
CHECKED					
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		BELT		WEIGHT	SCALE
			SHT	SHT'S	



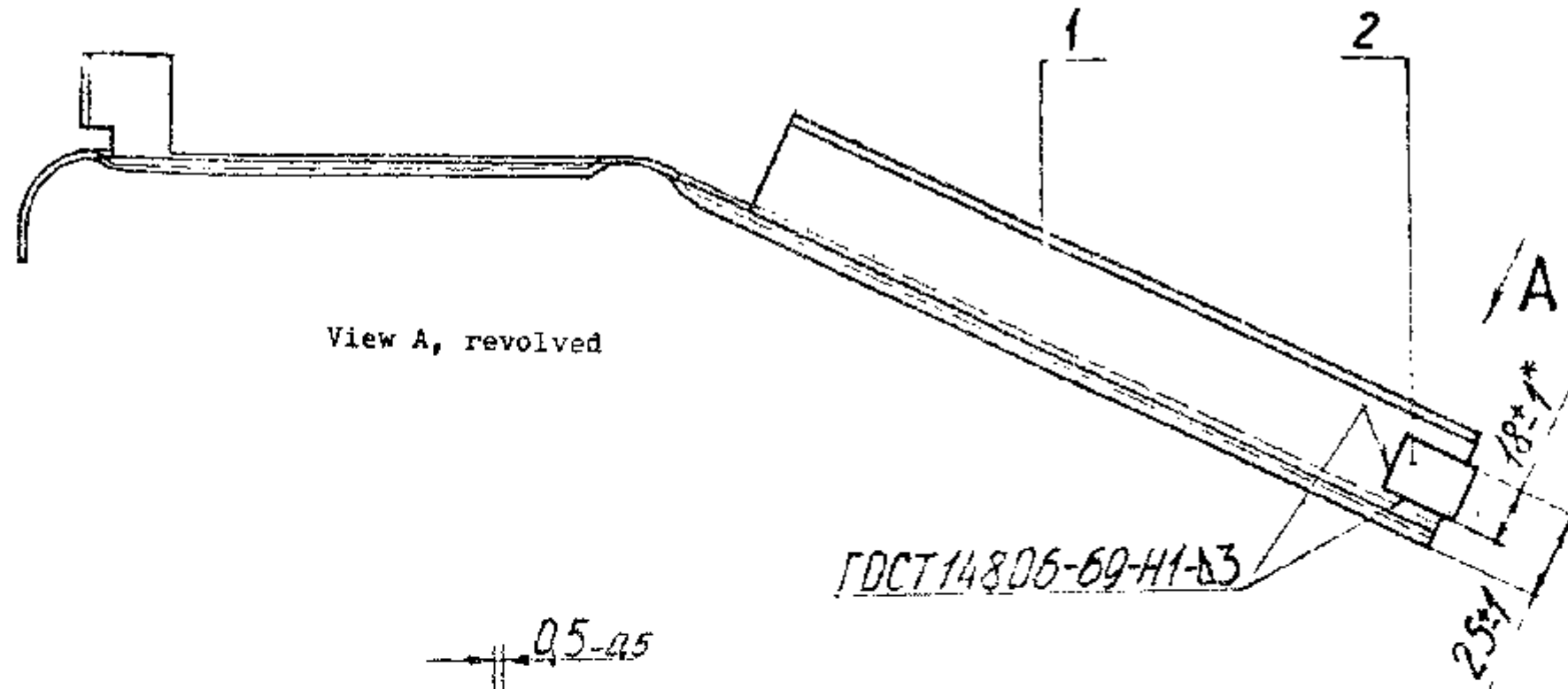
1. The material may be substituted by a two-layer belt without a filler, TOCT 16996-71.
2. Unspecified limit deviations of sizes are ± 1 mm.
3. Strap 3 is made of harness leather, TOCT 1904-81, not thinner than 1.75 mm.
4. Cotton glossy threads No.1, TOCT 6309-80, Tery threads, knots, unsewed portions are intolerable.
5. Bakelize the belt end at section A with phenol-formaldehyde lacquer, TOCT 901-78 and squeeze, after that scrape the butt end. Accept against the reference belt.

APPROVED	<i>[Signature]</i>	675-64-Sb318Sb			
CHECKED	<i>[Signature]</i>				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		BELT		WEIGHT	SCALE
				0.04	1:1
				SHT 1	SHTS 1

Ref. No.	Designation	Description	Qty	Remarks
		<u>List of Documents</u>		
	675-64-c6324 CB	Assembly drawing		
		<u>Parts</u>		
1	675-64-707	Tray	1	
2	675-64-711	Angle-piece	2	

APPROVED	<i>[Signature]</i>	675-64-Sb324		
CHECKED	<i>[Signature]</i>	TRAY		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				
			SHT 1	SHTS 1

675-64-Sb324Sb



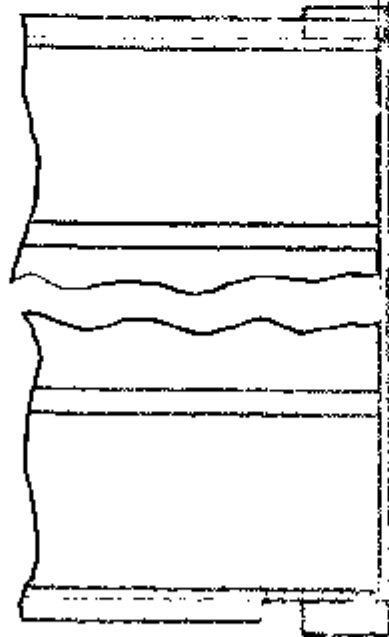
View A, revolved

DCT 14806-69-H1-83

0.5-0.5


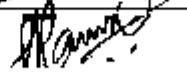
TECHNICAL CONDITIONS

1. The requirements for the quality of the welds are according to OCT 3-4001-77 for unspecified welded joints.
2. Coating: hard anodizing, oxide film 30 to 50 microns thick, with subsequent bichromate treatment.
3. Size for reference.

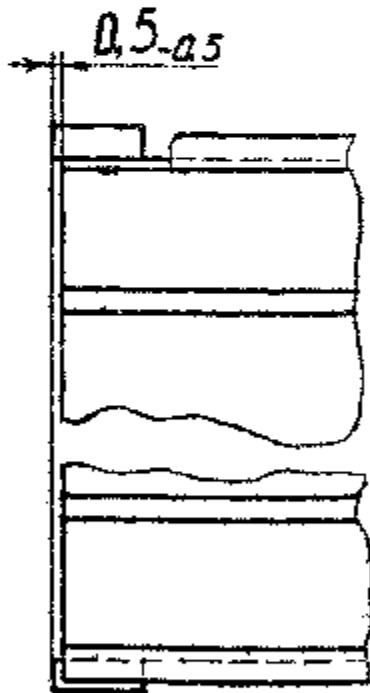
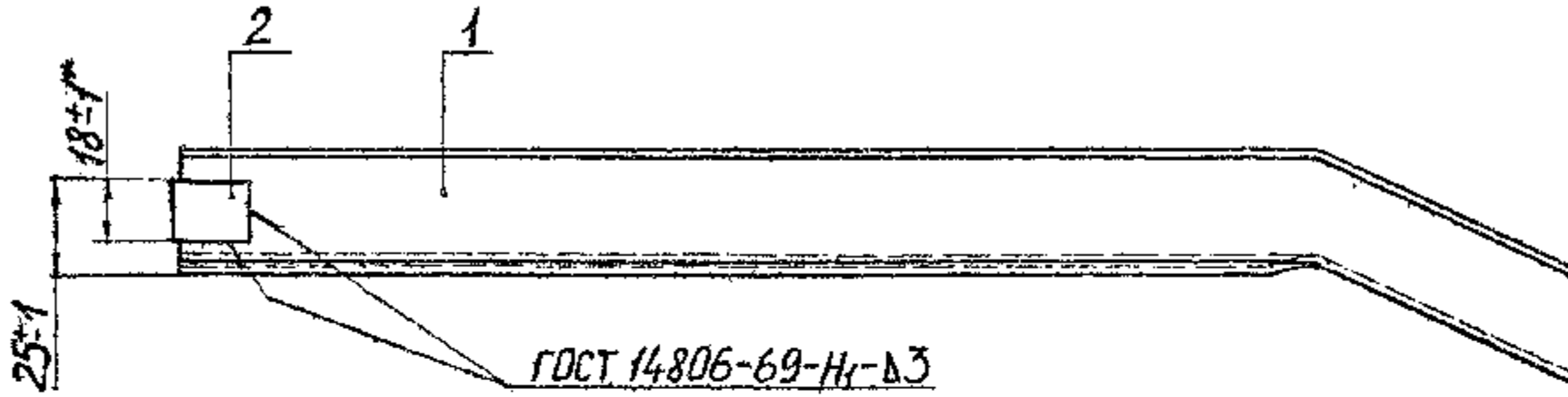


APPROVED <i>[Signature]</i>	675-64-Sb324Sb	
CHECKED <i>[Signature]</i>		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	TRAY	WEIGHT SCALE
	ASSEMBLY DRAWING	1.076 1:2
		SIT 1 SHTS 1

Ref. No.	Designation	Description	Qty	Remarks
		<u>List Documents</u>		
	675-64-c5325 c B	Assembly drawing		
		<u>Parts</u>		
1	675-64-710	Tray	1	
2	675-64-711	Angle-piece	2	

APPROVED		675-64-Sb325		
CHECKED		TRAY	WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				
			SHT 1	SHTS 1


675-64-Sb325Sb

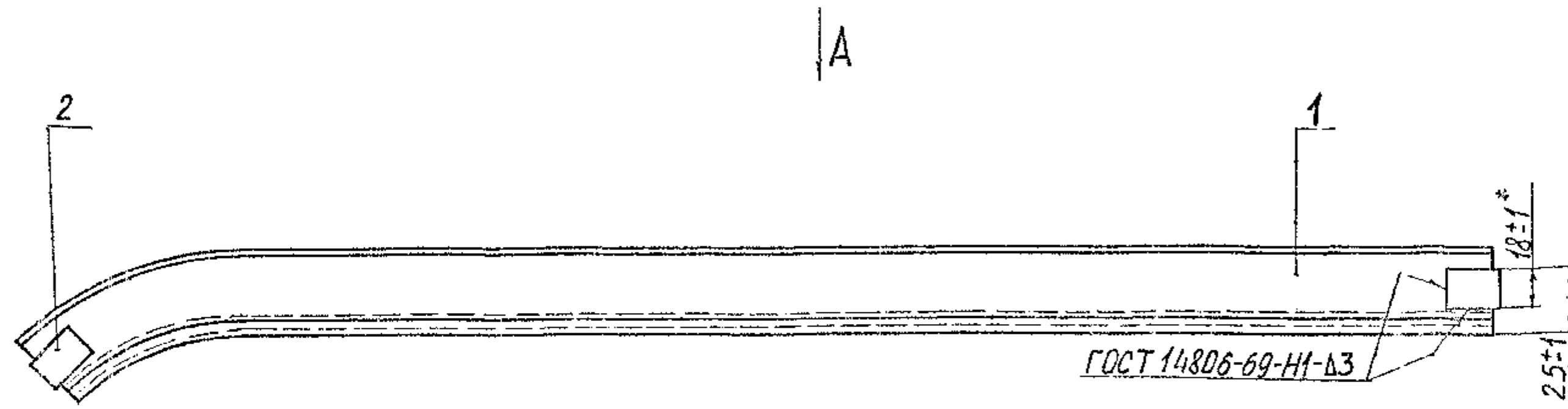


1. The requirements for the quality of the welds are according to OCE 3-4001-77 for unspecified welded joints.
2. Coating: hard anodizing, oxide film 30 to 50 microns thick, with subsequent bichromate treatment.

APPROVED	<i>[Signature]</i>	675-64-Sb325Sb		
CHECKED	<i>[Signature]</i>			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		TRAY ASSEMBLY DRAWING	WEIGHT	SCALE
			1.316	1:2
			SHT 1	SHTS 1

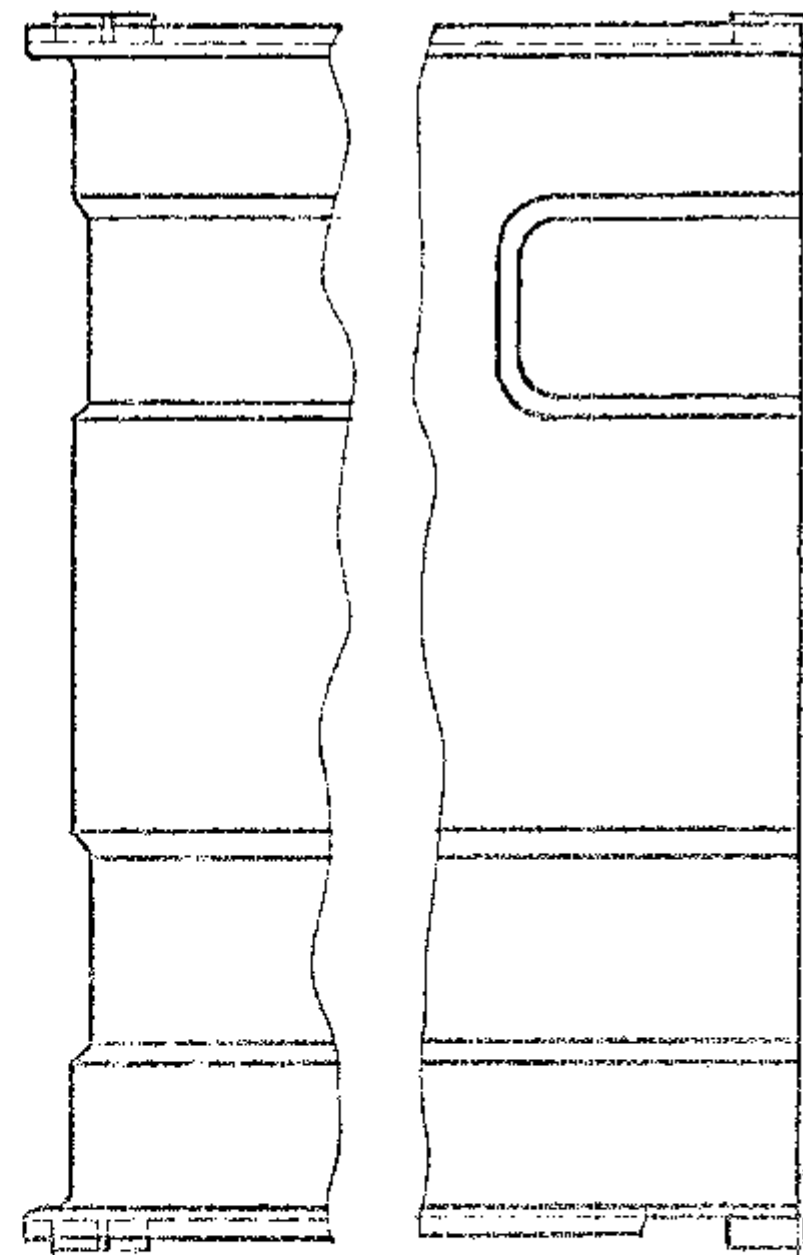
r. No.	Designation	Description	Qty	Remarks
		<u>List of Documents</u>		
	675-64-c6326 c5	Assembly drawing		
		<u>Parts</u>		
1	675-64-704	Tray	1	
2	675-64-711	Angle-piece	4	

APPROVED		675-64-Sb326		
CHECKED		TRAY		WEIGHT
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				
		SHT 1	SITS 1	



View A

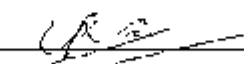
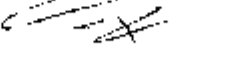
1. The requirements for the quality of the welds are according to OCT 3-4001-77 for unspecified welded joints.
2. Coating: hard anodizing, oxide film 30 to 50 microns thick, with subsequent bichromate treatment.
3. *Size for reference.



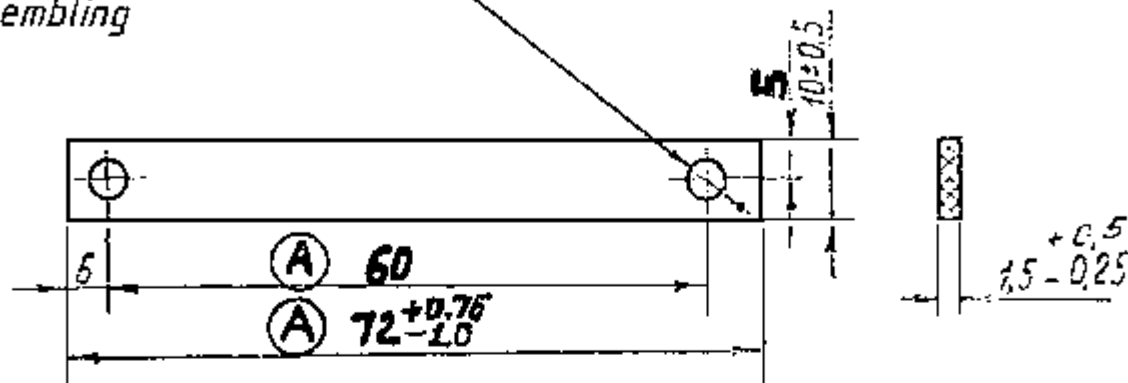
0.5-0.5

APPROVED	<i>[Signature]</i>	675-64-Sb326Sb		
CHECKED	<i>[Signature]</i>			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		TRAY	WEIGHT	SCALE
			1.656	1:2
			SHT 1 SHTS 1	

Ref. No.	Designation	Description	Qty	Remarks
		<u>List of Documents</u>		
	675-64-c6327 CB	Assembly drawing		
		<u>Parts</u>		
1	675-64-790	Body, aluminium A7-4 FOCT 2685-75	1	0.256 kg
2	675-64-789	Bushing	2	

APPROVED		675-64-Sb327		
CHECKED			BODY	WEIGHT
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				
	SHT 1			SHTS 1

Punch 2 Hole $\phi 5$. in
assembling



- 1) Alternate material is leather, type "K", GOST 1904-70.
- 2) Other requirements are as per Technical specifications TY38-105816-75.
- 3) Alternate material is leather, GOST 1904-70,
2 $\begin{matrix} +0.75 \\ -0.5 \end{matrix}$ mm thick.

Ⓑ EQ. MATERIAL:- HARNESS LEATHER IS: 580-73

00769-ICV + Remo 23/12-99	Ⓑ	EQ. MATERIAL ADDED
DC(1) No DATE	ISSUE	NATURE AMENDMENT

00329- ICV		DIMENSION - 92 $\begin{matrix} +0.75 \\ -1.00 \end{matrix}$ & 80 CHANGED TO - 72 $\begin{matrix} +0.75 \\ -1.00 \end{matrix}$ & 60 RESPECTI- VELY - CENTRE DISTAN- CE - 5 CHANGED TO 60
JUN 92	Ⓐ	
DC(1) No & DATE	ISSUE	NATURE OF AMEDMENTS

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

700-10-1074

STRAP BELT

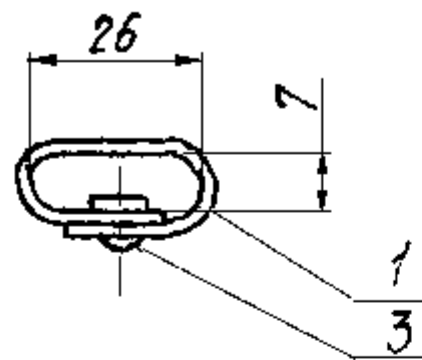
LEATHER TYPE A
GOST 1904-70

WEIGHT SCALE

0.002 1:1

SHT SHTS

700-10-Sb446



			<u>Other articles.</u>	
3	Ⓐ	BUTTON TYPE	Rivet Kholniten	
			Steel, nickle-plated 3x-25	1
			OST 17x-600-B1	
			<u>Parts.</u>	
1	700-10-1074		Strap belt.	1 For KM3 650-72-97
REF. NO	DESIGNATION		DESCRIPTION	QTY REMARKS.

01009-ICV
[Signature]

Ⓐ

REF NO'S, DESCRIPTION
BUTTON TYPE RIVET STEEL,
NICKLE-PLATED 3X25
OST 17 X 600/B1 WAS
RIVET-KHOLNITEN STEEL
NICKLE-PLATED 3X25

DC(I)No. & DATE

ISSUE

AMENDMENT'S

APPROVED *[Signature]*
C.P. RAO, SGT
CHECKED *[Signature]*
S. S. S. S. S.

700-10-Sb446

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

STRAP ASSY.

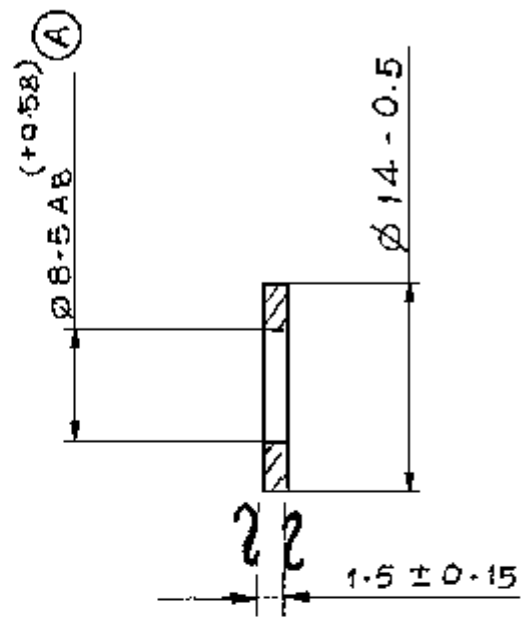
WEIGHT SCALE

0.011 1:1

SHT SHTS

700-31-15

Восстановленный дубликат №2 ✓



USED ON		
675-53-084	3	3

EQ. MATERIAL: GRADE '0' TO IS: 513
 1) Alternate material is steel cm2, cm3, cm5, GOST 380-71 and steel 08kn, 10, 15, 20, 25, and 30, GOST 1050-74

EQ. MATL: C 14 IS: 1570

00753-ICV v. Romo 23 FEB 00	©	EQ. MATERIAL ADDED.
00720-ICV v. Romo 30 AUG 99	®	EQ. MATERIAL ADDED.
00288-ICV Arey 27 AUG 91	®	I.D. WAS ERRONEOUSLY WRITTEN AS $\phi 8588 (+0.58)$ (D-1102/ICV)
DC(I) No. & DATE	ISSUE	AMENDMENTS

APPROVED
 CHECKED

M. Vasu
U. Balachandran

700-31-15

CONTROLLERATE OF QUALITY ASSURANCE (ICV)

WASHER

WEIGHT SCALE

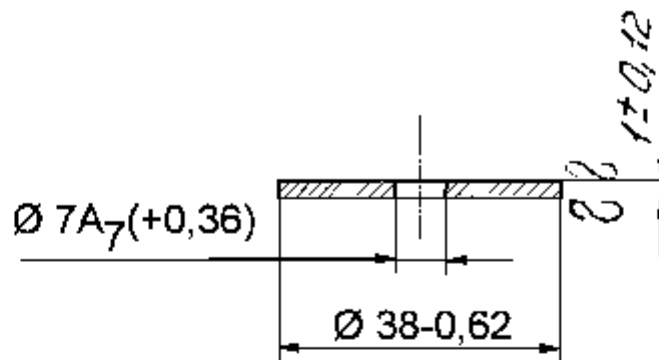
0.0012 1:2

SHT SHTS

CT 3 KЛ GOST 380-71

700-31-432

(A/A)



1. Alternate material is Steel cm3, GOST 380-71 and Steel 15, 20, 25, 08kn, 08nc, 10, 10kn GOST 1050-74.
2. Coating: Zinc-plated, 9 microns thick, chromated. Remove hydrogen embrittlement.

NEAREST EQ. MATERIAL

STEEL Cm 3 KГ GOST 380-71

ORGL MATERIAL:-

DC(I)No. & DATE

ISSUE

AMENDMENTS

ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF

ALL THREADS TO CONFORM TO SPECIFICATION

STAMP OR ETCH, PART No. MANUFACTURER'S NAME & YEAR OF MFR.

DRG. NOT TO BE SCALED

SCALE: 1:1

TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED

USED ON:

DATE: 22 AUG 1995

DRN. *[Signature]* WT :- (Kg)

TCD. *[Signature]* 0,008

700-31-432



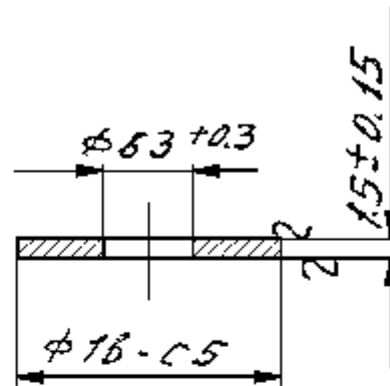
WASHER

DS CAT No.

CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)

700-31-632

(A)



1. Alternate material is 08kn, 10, 10kn, 20 GOST 1050-74 and CT3 GOST 380-71.

(B) 2. Coating: 0.12-TIN PLATED 12 MICRONS THICK.

(A) 3. INDIAN EQUIVALENT MATERIAL COLD ROLLED LOW CARBON STEEL SHEET GDE ST 42-1079 TO IS: 1079-73.

00497-ICV
Boj
 16 JAN 95
 DC(I)No.
 & DATE

(A)
AS
 ISSUE

NOTE No. 3 FOR
 EQ. MATERIAL ADDED.

AMENDMENTS

APPROVED

[Signature] # VASU

CHECKED

[Signature]

700-31-632

CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

WASHER

WEIGHT SCALE

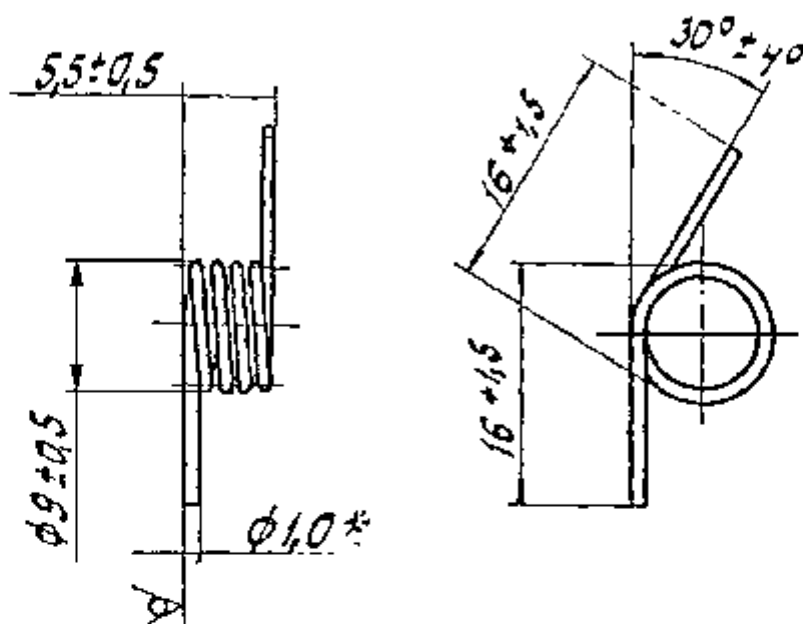
0.002 2:1

SHT SHTS

STEEL CT 3 kn, GOST 380-71

700-38-907

R_i 320 (✓)



1. Total length of spring is $L^* = 130\text{mm}$.
2. Number of working coils is $n = 4.25$.
3. Direction of winding is right hand.
4. * Reference dimensions
5. Coating. Chemically parkerized, accelerated, chromated, impregnated with preservation oil K-17 GOST 10877-76 as per instructions 053.25289.00002 or with varnish KO-815 GOST 11066-74.

APPROVED

[Signature] II VARI

CHECKED

[Signature]

700-38-907

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

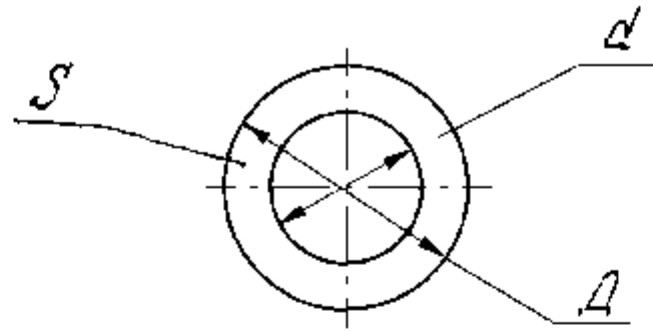
SPRING

WEIGHT SCALE

0.001 2:1

SHT SHTS

WIRE II-1.0, GOST 9389-75



Ⓐ 3) EQUIVALENT MATERIAL IS DD TO IS:1079 OR IS:513

Designation	Dimension, MM			Material	Mass, kg
	A	d	S		
700-40-84	φ168 ₈ (-0.7)	φ114 ₇ ^(+0.13)	0.1-0.02	steel 10 GOST 1050-74	0.0171
700-40-85	φ168 ₈ (-0.7)	φ114 ₇ ^(+0.13)	0.3-0.04	Steel 10 GOST 1050-74	0.0003
700-40-86	φ168 ₈ (-0.7)	φ114 ₇ ^(+0.13)	0.5±0.05	08KN GOST 9045-80	0.0005
700-40-87	φ168 ₈ (-0.7)	φ114 ₇ ^(+0.13)	0.8±0.08	Steel 08KN GOST 1050-74	0.0008
REF. DC(D) 01007-1CV LN 5/ICVS/9330-0248 94 700-40-88	φ228 ₇ (-0.5)	φ168 ₈ ^(-0.7)	1±0.09	Steel 08KN GOST 1050-74	0.0014
700-40-89	φ168 ₈ (-0.7)	φ114 ₇ ^(+0.13)	1±0.09	Steel 08KN GOST 1050-74	0.001
700-40-90					

1) Alternate material is steel 08kn, 08, 10, 10kn, GOST 1050-74

2) Coating, Chemically parkerized, chromatized, accelerated, oiled or chemically oxidised, oiled

00331-ICV
Amberg
7 JUL 92
DC(D)No.
& DATE

Ⓐ
HP
21/11

NOTE FOR EQUIVALENT MATERIAL ADDED.

ISSUE

AMENDMENTS

APPROVED

M VASU

CHECKED

[Signature] DSKEMAR

700-40-84/90

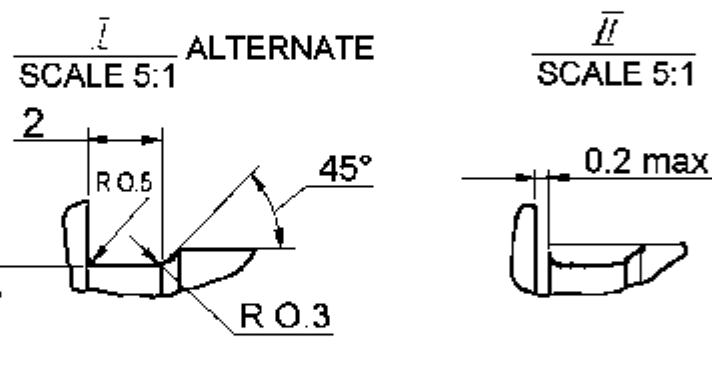
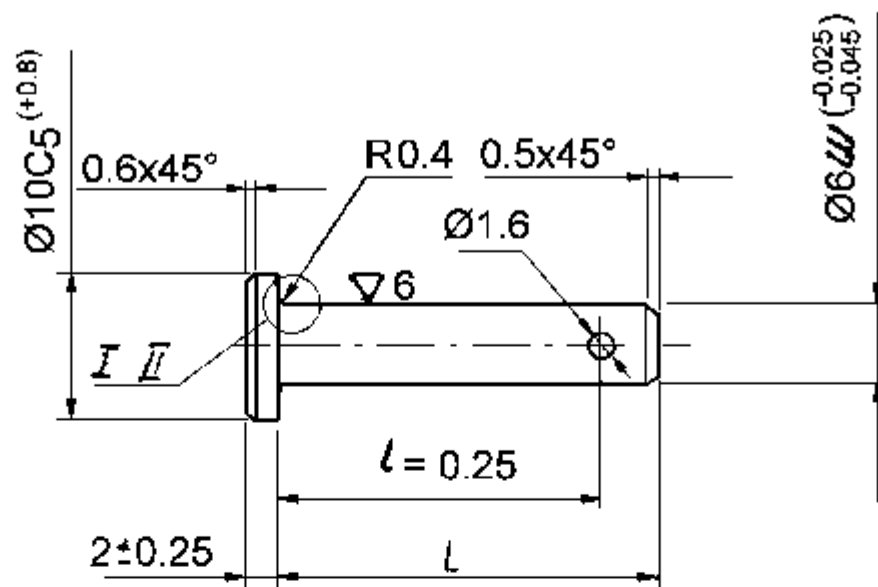
CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

GASKET

WEIGHT SCALE

SEE TABLE 2:1

SHT SHTS



TECHNICAL CONDITIONS

1. HB 321 to 228 (Ø3.4 to 4.0).
2. Alternate material is 38XC, 40X, 40XC, 45X, GOST 4543-71.
3. Unspecified limit deviations of dimensions are as follows:
For holes -as per A₇ and
for shafts -as per B₇
4. Displacement of holes from axis of rod should not exceed 0.3mm
5. Coating: Zinc-plated, 9 microns thick, chromated
Remove hydrogen embrittlement.

- Ⓐ 6. Equivalent material is 40Cr4 Mo3 to IS:5517.
 Ⓑ EQ.MATERIAL:- 40 Cr 1 Mo 2B TO IS: 5517.

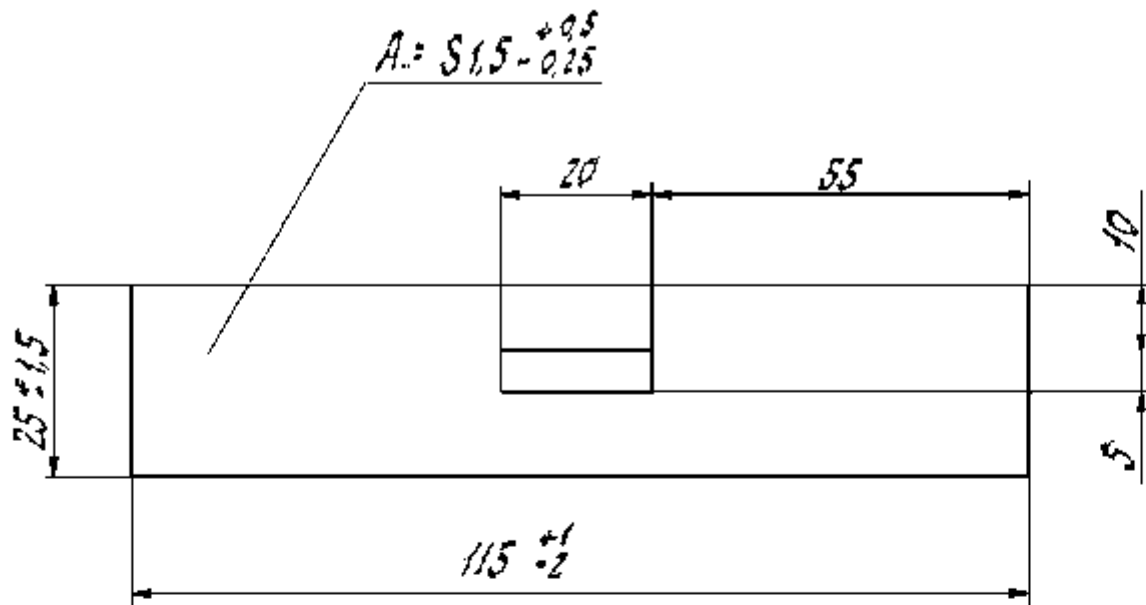
DESIGNATION	L,MM	L,MM	MASS,Kg.
700-47-358	14±0,43	10	0,0043
-01	16±0,43	12	0,0047
-02	20±0,52	16	0,0056
-03	25±0,52	21	0,0067
-04	35±0,62	30	0,010

© DS CAT No. LV2/ICVS-5315-0252278.

01065-ICV 8 OCT 09	Ⓒ	DS CAT No. LV2/ICVS 5315-0252278 ADDED & NOMENCLATURE 'AXLE' AMENDED AS PIN STRAIGHT HEADED AGAINST DRG No.700-47-358
00820-ICV 17 OCT 00	Ⓑ	EQ. MATERIAL ADDED.
00321-ICV 11 FEB 92	Ⓐ	NOTE FOR EQUIVALENT MATERIAL ADDED.
DCI No. & DATE	ISSUE	AMENDMENTS

APPROVED	 CONTROLLERATE OF QUALITY ASSURANCE (ICV)	700-47-358 AXLE		WEIGHT	SCALE
CHECKED				SEE TABLE	2:1
		SHT	SHTS		
		38xA GOST 4543-71			

701-267-162



- 1). Alternate material is harness leather of type K GOST 1904-70
 - 2). Other requirements are to be as per Technical Specifications Ty 38-105816-75.
 - 3). Alternate material is leather GOST 1904-70 in this case the dimension 'A' = 52 ± 0.75
- Ⓐ EQ. MATERIAL: - HARNESS LEATHER IS: 580-73

00749-ICV

Ⓐ

v. Romo
23 DEC 99

EQ. MATERIAL ADDED.

DC(I)No.
& DATE

ISSUE

AMENDMENTS

APPROVED

CHECKED

701-267-162

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

STRAP

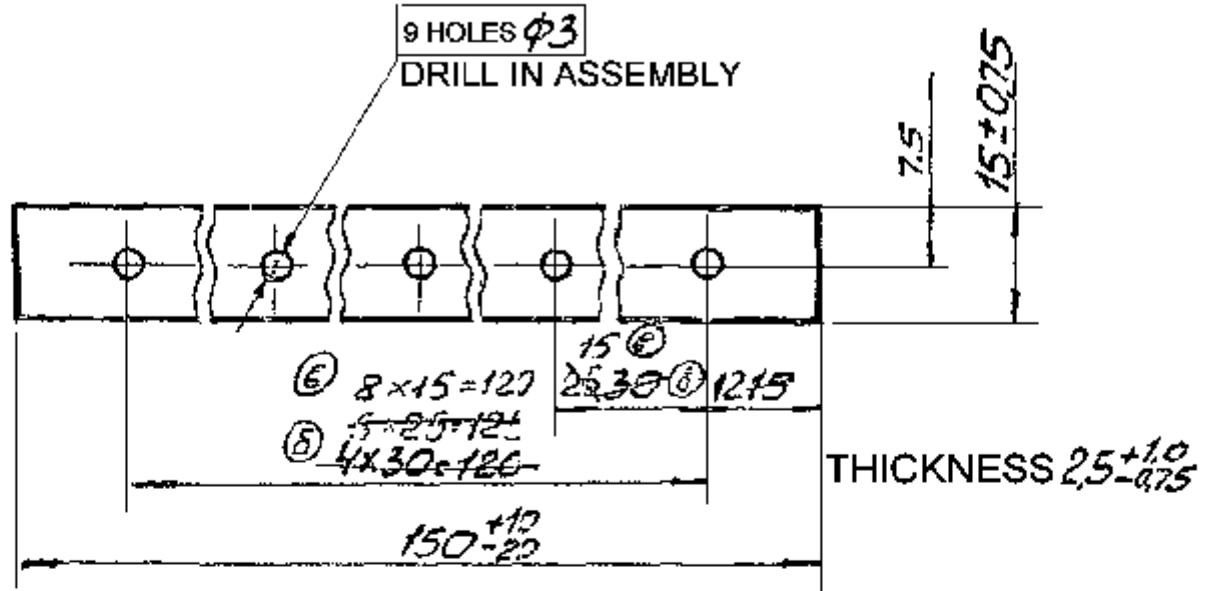
WEIGHT SCALE

0.005 1:1

SHT SHTS

Hardness Leather
type 1 GOST 1904-70

765-94-82



- 1) Alternate material is harness leather type "K" GOST 1904-70.
 - 2) Other requirements are as per TY 38-105 816-75.
- Ⓐ EQ. MATERIAL:- HARNESS LEATHER IS: 580-73

00749-ICV

v. Roman

23-12-99

DC(I) No. & DATE

Ⓐ

EQ. MATERIAL ADDED.

ISSUE

AMENDMENTS

APPROVED

[Signature]
E.P. RADSSOL

CHECKED

[Signature]
K.S. RAD, A/P

765-94-82

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

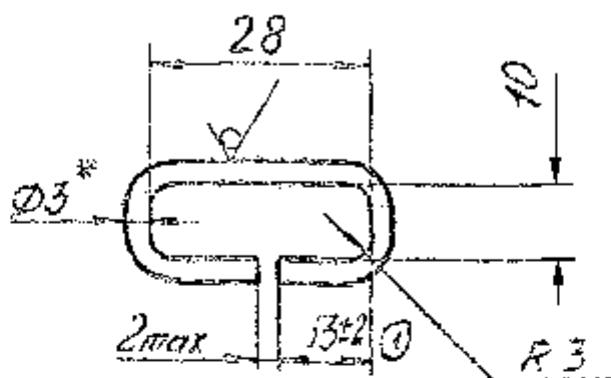
COVER

LEATHER HARNESS 'Л'
GOST 1904-70

WEIGHT SCALE

0.006 1:1

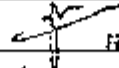
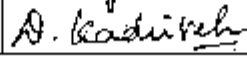
SHT 1 SHTS 1



1. Unspecified limit deviations of dimensions are $\pm 1\text{mm}$.
2. Misalignment of edges should not exceed 1mm.
3. * Dimension is given for reference.

(A) EQ. MATERIAL:- MILD STEEL WIRE, GALVANISED, SAFT DRAWN OR 1/4 HARD TO IS: 280-78 WITH TENSILE STRENGTH 37 kg/mm^2 MINIMUM.

00749-ICV H. Vasu 23-12-99	(A)	EQ. MATERIAL ADDED.
DC(I)No. & DATE	ISSUE	AMENDMENT'S

APPROVED  H. VASU
CHECKED  A. Kadavath

765-94-768

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)



STRAP

WEIGHT SCALE

0.005 1:1

SHT 1 SHTS 1

Ref. No.	Designation	Description	Qty	Remarks
		<u>List of Documents</u>		
	675-64-c6305 CE	assembly drawing		
		<u>Parts</u>		
1	675-64-693	Pintle	1	
2	675-64-696	Support	1	
3	675-64-703	Plate	1	

APPROVED		675-64-Sb305		
CHECKED		SUPPORT		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				
		SHT	SHTS	