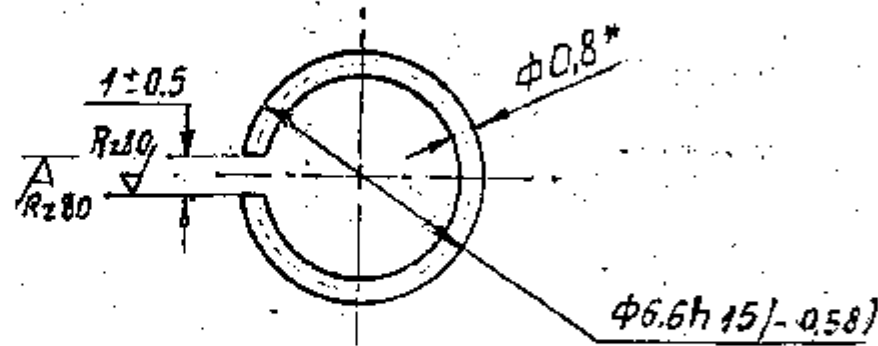


DRAWING NUMBER
304-34

(V/A)



1. Заносенцы не допускаются.
2. Покрытие хим. окс. прм.
3. *Размеры для справок.
4. Неплоскостность не более 0.8 мм (развод концов); местное искривление не допускается

1. BURRS ARE NOT PERMITTED.
2. COATING: CHEMICAL OXIDIZING OIL FINISHING.
3. *DIMENSIONS FOR REFERENCE.
4. NON FLATNESS SHOULD NOT EXCEED 0.8mm SPREAD ENDS LOCAL DISTORTION IS NOT ALLOWED.

5. **EXPLANATORY NOTE :**

MATERIAL QUOTED :-

WIRE - II 0,8 GOST 9389-75

II - SECOND CATEGORY

0,8 - NOMINAL DIAMETER OF THE WIRE

CHEMICAL COMPOSITION :-

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C	Mn	Si	S	P	Cr	Ni	Co
KT - 2	0,86 - 0,91	0,20 - 0,40	0,17 - 0,37	0,020	0,020	0,05	0,05	0,10
SK - 7	0,68 - 0,76	0,50 - 0,80	0,17 - 0,37	0,030	0,020	0,05	0,05	0,04

MECHANICAL PROPERTIES :-

TENSILE STRENGTH kgf/mm^2 215 - 260

NO: OF BENDS = 12 (MIN)

NO: OF TWISTS = 17 (MIN)

(A) EQUIVALENT MATERIAL
Gr. SM/SH IS: 4454-2001

K V D No, 78085.

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

EST. WT. 0,001 Kg TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)

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

DRN	G. N. N. N.	MATERIAL :- WIRE II - 0,8	USED ON
CHD		GOST 9389-75	CB 3304-02-4
TCD	Avizata	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
APPD		AVADI	
DATE	05-05-88	TITLE	
SCALE :-	5:1	RETAINING RING	
DIMENSIONS IN mm		D S CAT NUMBER	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69		DRAWING NUMBER	
ALL THREADS TO CONFORM TO		304-34	
ISSUE DATE	NATURE OF AMENDMENTS		

A 16-8-10 4th Alt. Comm. Meeting Minutes
Point No. 13 Dt: 26-10-09

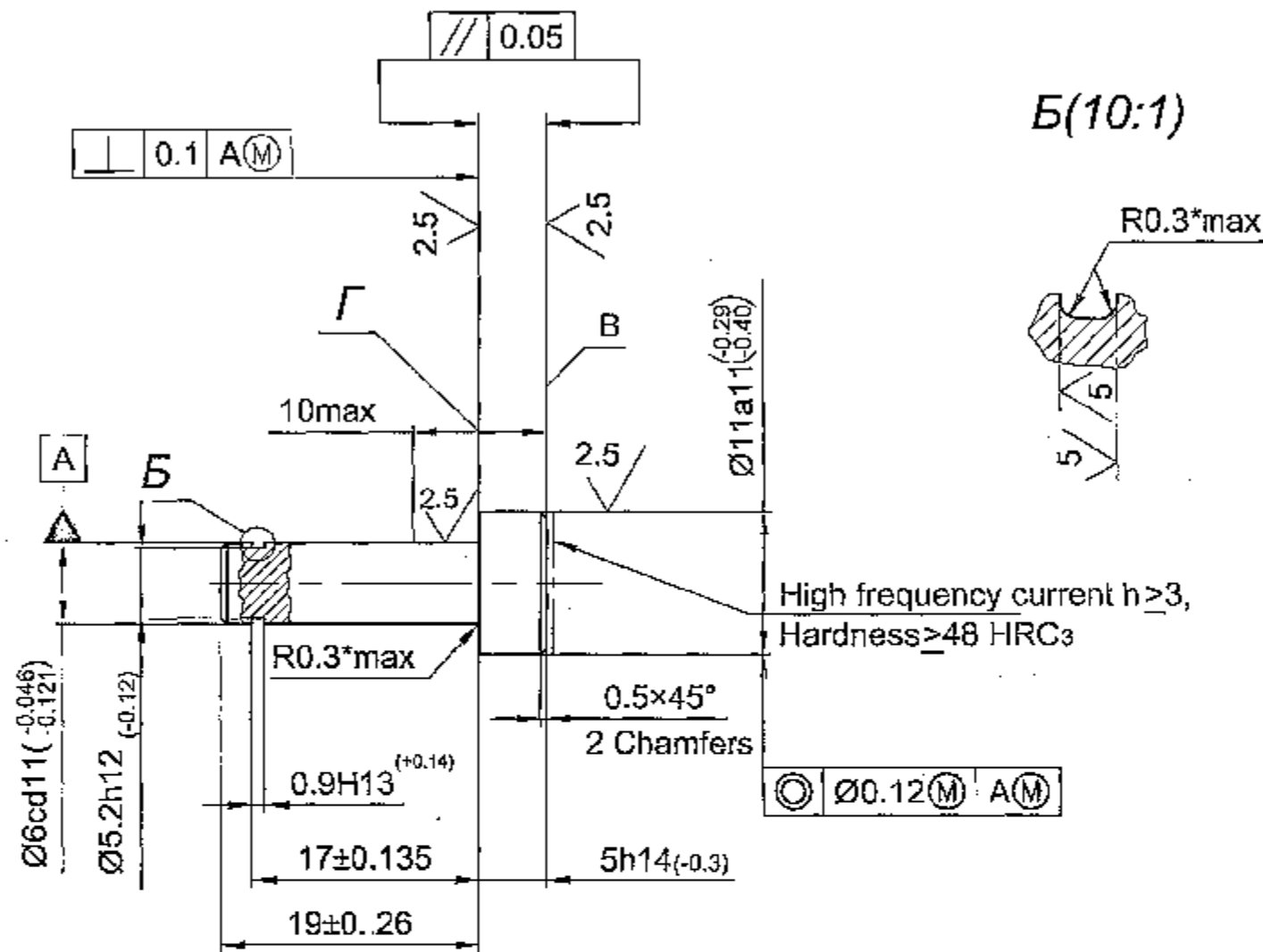
A3
116

SIZE A3



DRAWING NUMBER
315-651-28

10
(M)



1. Inspection group is III as per TT-11.
2. * Dimensions are ensured by tool.
3. Coating is carried out chemically oxidised, oiled as per instruction ИЛ-681-78.
4. Centred drill hole is not allowed on face B.
5. Hardening of surface A along length Γ is allowed.

High frequency current $h \geq 3$,
Hardness ≥ 48 HRC₃

Ø0.12 (M) A(M)

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

EST. WT. 0.0055 TO BE STAMPED OR MARKED WHERE
INDICATED THUS # (LETTERS)

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

DRN	MATERIAL:- STEEL 45X GOST 4543-71	USED ON:- Cb 315-660-34 Cb 315-660-35
CHD	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
APPD	TITLE:- CORRECTOR ROD	
DATE	D S CAT NUMBER	DRAWING NUMBER
SCALE:- 2:1		315-651-28
DIMENSIONS IN mm		
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69		
ALL THREADS TO CONFORM TO		

DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 4

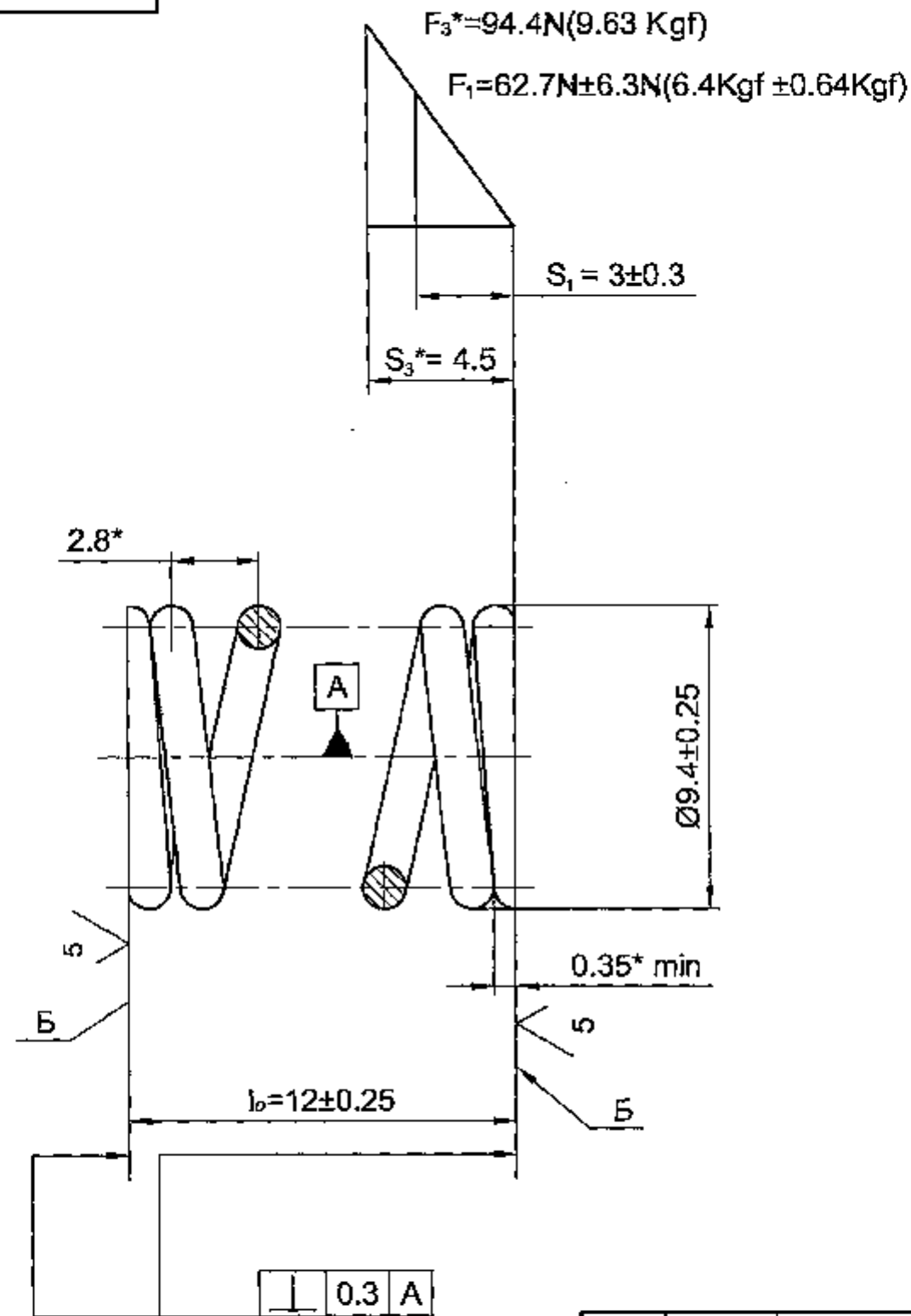
F-5
76
283
SIZE A3

ISSUE DATE NATURE OF AMENDMENTS

DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 3

DRAWING NUMBER
315-652-37

✓(✓)



1. $G^* = 78500 \text{ MPa}$ (8000 kgf/mm^2).
2. $T3^* = 888 \text{ MPa}$ (90.6 kgf/mm^2).
3. Spring winding direction RH.
4. $L = 141 \text{ mm}$.
5. $n = 3.5$.
6. $n1 = 5.5 \pm 0.25$.
7. Clearance between the supporting coil end and adjacent working coil is maximum 0.2mm.
8. Supporting surfaces B should be not less than 0.7 of circumference length.
9. Working coil pitch unevenness in free state should not be more than 0.2mm.
10. Residual deformation (permanent set) is not allowed after compressing the spring on sag 4mm.
11. Allowed to increase the outer diameter of supporting coils upto $\text{Ø} 9.6 \pm 0.25$ maximum.
12. Coating should be carried out with thickness of Zinc - 9 microns, chromium - 1 micron as per instruction ИЛ-749-88 after removal of hydrogen embrittlement.
13. *Dimensions and parameters are given for reference.
14. Alternate material is Wire ИЛ-1.4 as per instruction ТУ 14-4-923-78.

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

EST. WT. **0.002** TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)

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

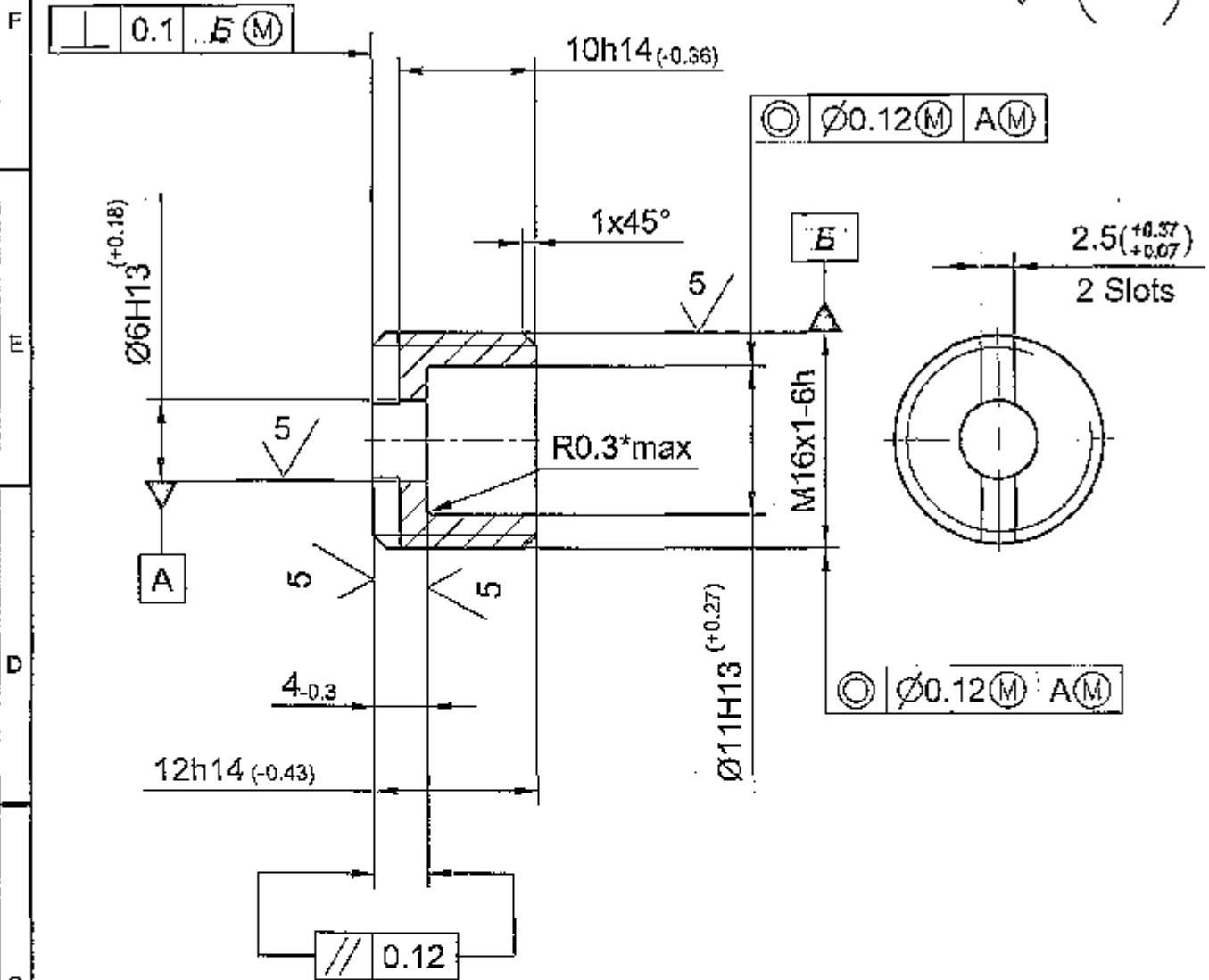
DRN		MATERIAL :- Wire Б-2А-П-1.4	USED ON :-
CHD		GOST 9389-75	Сб 315-660-34
APPD		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	13/3/82	AVADI	
SCALE:-	5:1	TITLE :-	
DIMENSIONS IN mm		CORRECTOR SPRING	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69		D S CAT NUMBER	DRAWING NUMBER
ALL THREADS TO CONFORM TO			315-652-37
ISSUE	DATE	NATURE OF AMENDMENTS	

F-5
77
283
SIZE A3

DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 4

DRAWING NUMBER
315-653-12

10 ✓ (✓)



1. * Dimension is ensured by tool.
2. Coating: Chemically oxidised oiled as per instruction VIT-681-87.

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

F-5
79
283

EST. WT. (Kg)
0.01

TO BE STAMPED OR MARKED WHERE
INDICATED THUS # (LETTERS)

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

MATERIAL :-
STEEL 45
GOST 1050-88

USED ON :-
CS 315 -660 - 34
CS 315 -660 - 35

4A 18-8-08 D. O. CORRECTION
ISSUE DATE NATURE OF AMENDMENTS

DRN
Asobu
SCALE :- 2 : 1
DIMENSIONS IN mm

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)
AVADI

CHD
P. B. Balabhisam
APPD
TOLERANCE ON DIMENSIONS
UNLESS OTHERWISE STATED
IS : 2102 - 69

TITLE :-
4A **CORRECTOR HOUSING**

DATE
12/3/07
ALL THREADS TO
CONFORM TO

D S CAT NUMBER

DRAWING NUMBER
315-653-12

SIZE A4



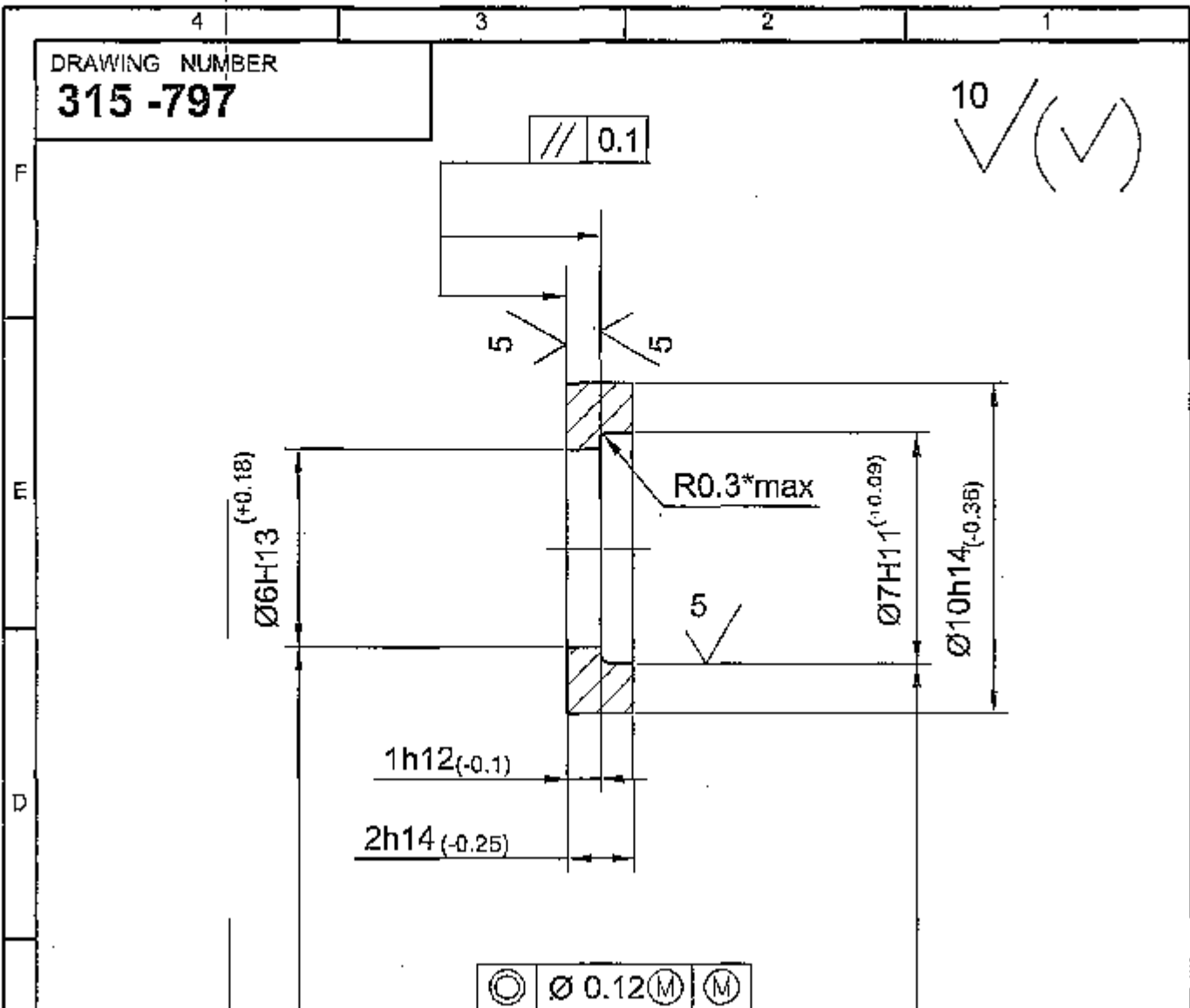


DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 3

F-5
86
283

DRAWING NUMBER
315 -797

10
✓ (✓)

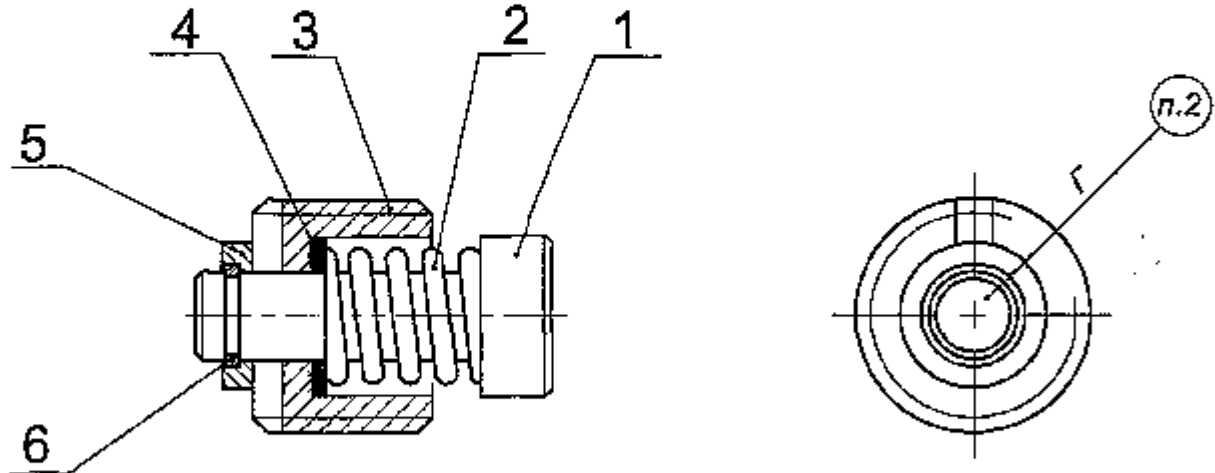


1. Inspection group is IV as per T T-11.
2. 28...35 HRCø.
3. Coating: Chemically oxidised, oiled as per instruction ИЛ-681-87.
4. * Dimension is ensured by tool.

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

		EST. WT. (Kg) 0.0008	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
		MATERIAL :- STEEL 45X GOST 4543-71	USED ON :- C5 315 - 660 - 34 C5 315 - 660 - 35
ISSUE DATE	NATURE OF AMENDMENTS	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
DRN <i>Atul</i>	SCALE :- 5 : 1 DIMENSIONS IN mm	TITLE :- WASHER	
CHD <i>R. B. ...</i>	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS : 2102 - 69		
APPD <i>[Signature]</i>	ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER 315 -797
DATE 21/3/67			
SIZE A4			

DRAWING NUMBER
Cb.315-660-34



1. Tighten the corrector spring item 2 with the help of adjusting washer set item 4 in such a way, that under the load of 79.4 N(8.1 Kgf), corrector rod item 1 with respect to corrector body item 3 should be equal to 0.9 ± 0.1 mm.
2. Mark the letter A by electric spark method.

DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 3

F-5
32
283

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

		EST. WT. 0.02	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
		MATERIAL :-	USED ON :- Cb 315-662-16
ISSUE DATE	NATURE OF AMENDMENTS		
DRN	SCALE :- 2 : 1		
	DIMENSIONS IN mm		
CHD	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS : 2102 - 69		
APPD	TITLE :- MOMENT CORRECTOR ASSY.		
DATE	ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER Cb.315-660-34
SIZE A4			

