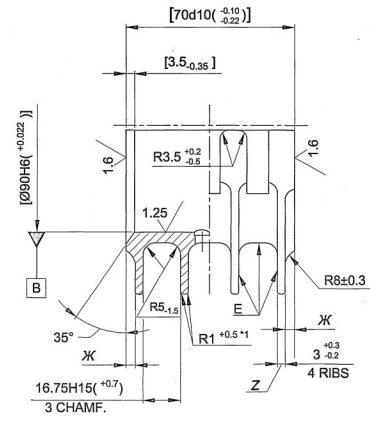
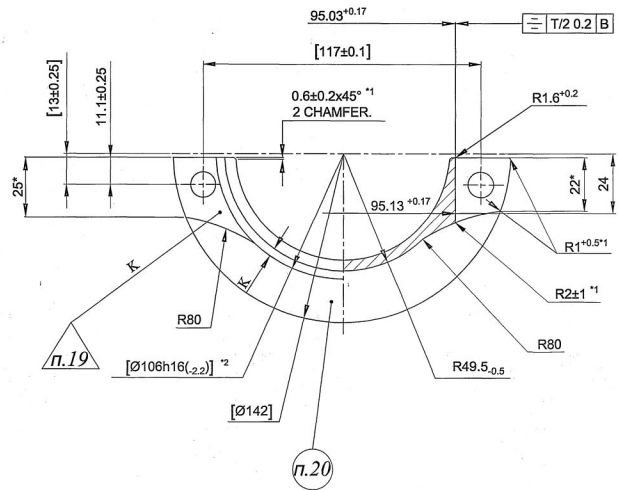
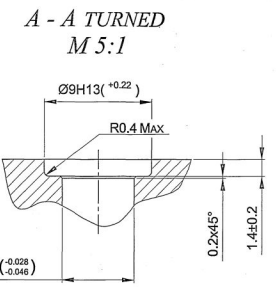
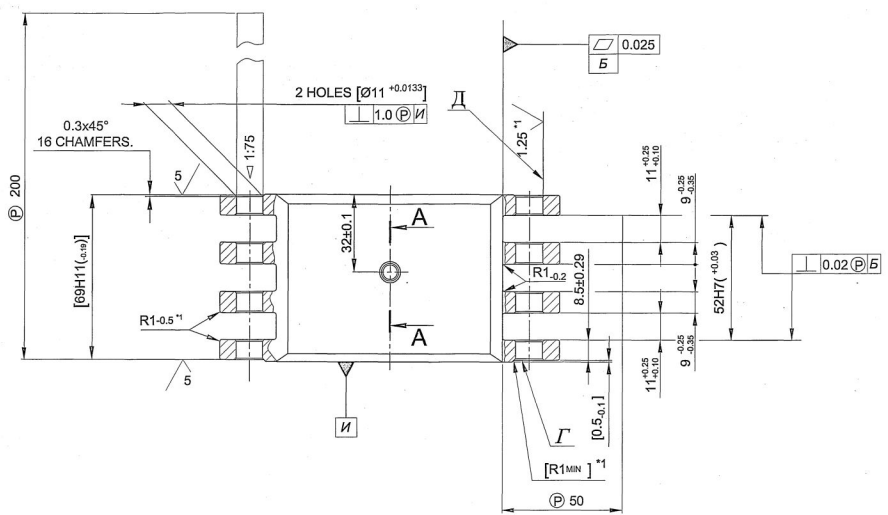


DRAWING NUMBER
304-15-2

2.5 ✓(✓)



1. Inspection group II as per TT-11.
2. The hardness is 302...341 HB.
3. After final Heat Treatment components should be as per TTM-82-82.
4. Alternate Material: Steel 18X2H4BA TY 14-1-381-72.
5. Un specified limit deviation of dimensions: H14, h14, ± IT/2
6. Machining should be done as per dimensions given in square brackets together with main connecting rod. Parts are used together.
7. Thickness variation of dimension 'K' should not be more than 1mm.
8. Smooth increase of surface 'Γ' up to 0.2 mm on the section Ø116 mm is allowed.
9. Hairlines, scratches, cavities, cracks of various origins, metallurgical defects, marks due to rough machining are not allowed on the surface of the part.
10. The slope of surface 'B' is checked by bluing as per instruction ИИ-613-85; by gauge, made to dimension according to the drawing 304-12-7. Matching should be a minimum of 80% of every tenon (curvature) with the uniform imprint.
11. Checking of matching of the surface 'B' (by bluing or by suffing) to the mating part is allowed. The matching of surface should have a minimum of 75% with uniform imprints.
12. Check the hole 'D' by gauge by 'bluing' as per instruction ИИ-613-85. The Bluing should uniformly cover minimum 80% of every pin.
13. Specify the hole 'D' by gauge in assembly with the connecting rod. The projection of the gauge is 1 mm.
14. After final machining of surface 'E' sand blast or polish by electro chemical method.
15. The reduction in dimension Z by 0.2 mm of the top of the edge is allowed in electro chemical method.
16. Cleaning of parts after heat treatment by shot blasting is allowed as per ИСЧП 05.08 ГОСТ 11964-81.
17. Roughness of surface 'E' before heat treatment is $Rz \leq 1$, and after shot blasting and sand blasting is $Rz \leq 1$.
18. Check with the magnetic defectoscope. Unclear places found is observed by 6 th fold magnifying glass. Acceptance is done as per TT ИВ-17.
19. Put the inspection stamp for testing with magnetic defectoscope.
20. Mark the mat. No. by etching method. Letter type as per ПЧ-3.5 ГОСТ 2930-62.
21. *Ensured by tool.
22. * Adopt as per the inspection specimen.
23. In separate portions of belt 'K' it is allowed to carry out with a minimum 1 mm of width.
24. *Dimension is given for reference.



DRAWING INDICATED BASED ON RUSSIAN ORIGINAL ISSUE - 27 COMMON TO V-9752 DRG. REPLACES 304-15-2, ISSUE-NIL VIDE BK NO. 91-81

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

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

0.965

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	CHD	TCO	APPO	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 2102-69	ALL THREADS TO CONFORM TO
MATERIAL - STEEL 18X2H4MA TY 14-1-381-72-PRESS WORK		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AYADI		TITLE MASTER CONNECTING ROD CAP		D S CAT NUMBER 304-15-2		USED ON - Cb 3304-02-4
ISSUE			DATE			NATURE OF AMENDMENTS		

SIZE A1

