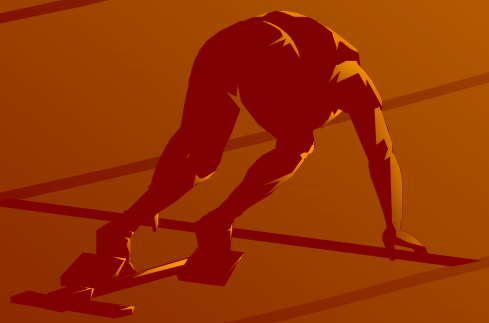
GUN & SHELL FACTORY
COSSIPORE
KOLKATA-700 002

- THESE DRAWINGS ARE EXCLUSIVE PROPERTY OF THE GENERAL MANAGER GUN AND SHELL FACTORY

- NO PART OF IT SHOULD BE COPIED ,TRANSMITTED OR REPRODUCED WITHOUT HIS PRIOR PERMISSION

- THE CD SHOULD BE RETURNED TO THE GENERAL MANAGER GUN AND SHELL FACTORY AFTER USE

MANTLET



Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
				Documents		
A1			AK-630 Sb 103 SB	Assembly drawing		
				Assembly units		
A4		1	AK-630 Sb 103-1	Mantlet base	1	
A4		2	AK-630 Sb 103-2	Mantlet cover	1	
A4		3	AK-630 Sb 103-3	Lock	2	
A4		4	AK-630 Sb 103-4	Lower packing	1	
A4		5	AK-630 Sb 103-5	Upper packing	1	
				Components		
*)		8	AK-630 103-1	Cover plate	2	*)A4x3
A3		10	AK-630 103-3	Cramp	2	
A4		11	AK-630 103-5	Cramp	1	

First use | Reference No. | Sign and Date | Duplicate Inv. No | Alternate Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date

AK-630. Sb 103

Developed by			
Checked by			
Head of Q.C.D			
Approved by			

Mantlet

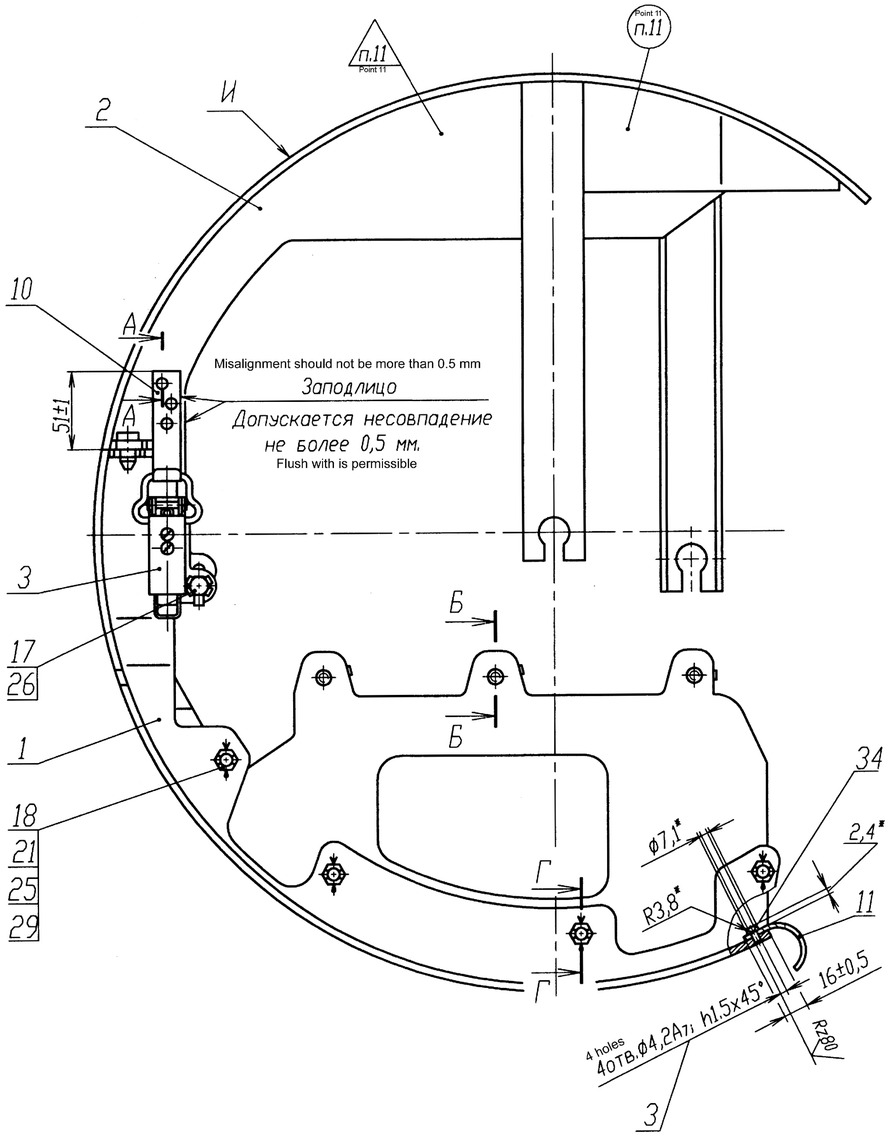
Type	Sheet	Sheets
A	1	2

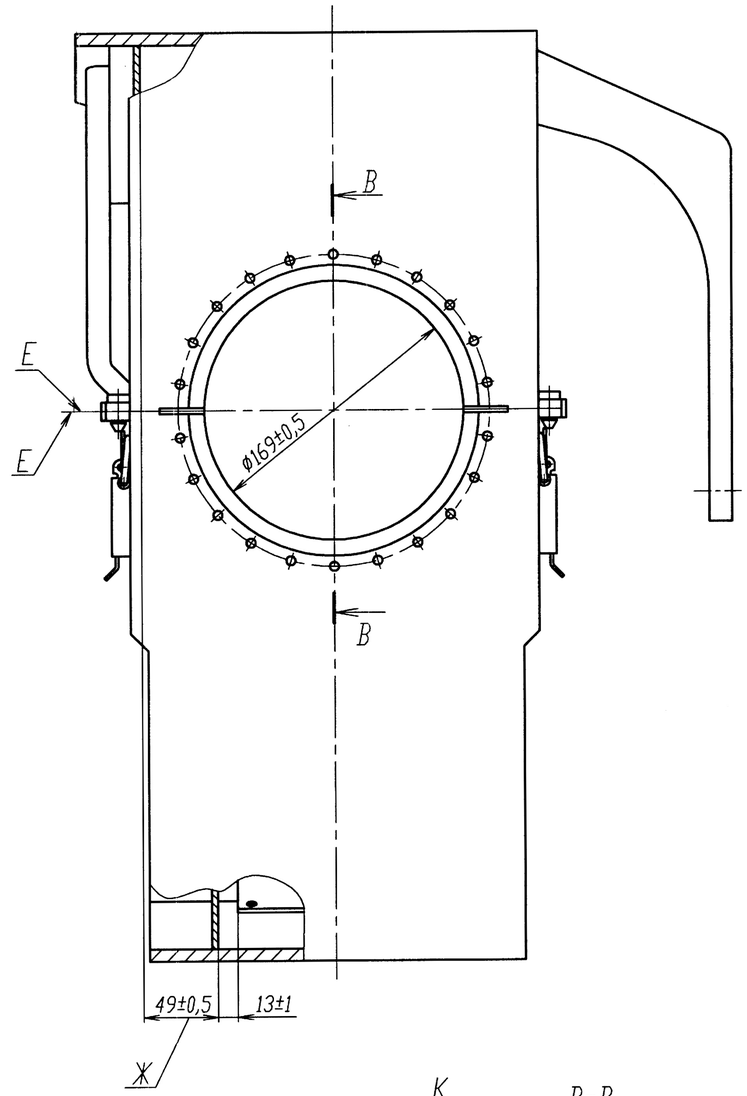
Sign and Date | Orig. Inv. No.

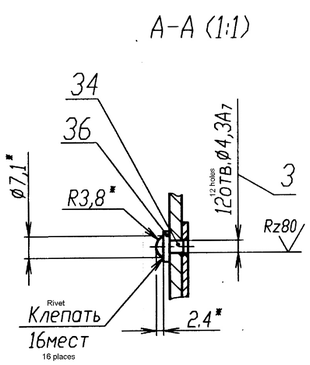
Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
				Standard articles		
		17		Bolt M8-8gx20.109.40X.029	5	*1)
				GOST 7798-70		
		18		Bolt 2M8-8gx60.109.40X.029	4	*1)
				GOST 7798-70		
		19		Nut M4-6G.10.40X.026	22	*1)
				GOST 5927-70		
		21		Nut M8-6G.10.40X.026	4	*1)
				GOST 5919-73		
		24		Washer 4.01.08KP.029	22	
				GOST 13463-77		
		25		Washer A8x1.5.25.029	4	
				GOST 11371-78		
		26		Washer 8.01.08KP.029	5	
				GOST 13463-77		
		29		Cotter pin 2x20.029	4	
				GOST 397-79		
		34		Rivet 4x14.03.15.026	16	
				GOST 10300-80		
		35		Screw 2.M4-6gx20.109.40X.029	22	*1)
				GOST 17475-80		65.5…70HRA
		36		Washer A4.25.029	12	
				GOST 11371-78		
			*1) Heat treatment of bolts pos.17,18 31…40.5HRC$_E$ nuts pos.21			
			31…39.5HRC$_E$ nuts pos.19 and screws pos.35 65.5…70HRA			

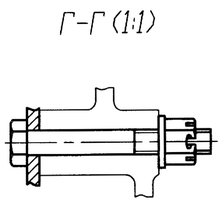
Sign and Date | Duplicate Inv. No | Alternate Inv. No. | Sign and Date

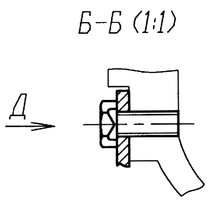
Orig. Inv. No.						AK-630. Sb 103	Sheet
							2
	Amend.	Sheet	Doc. No.	Sign	Date		

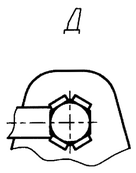


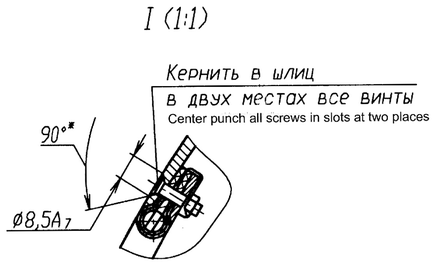


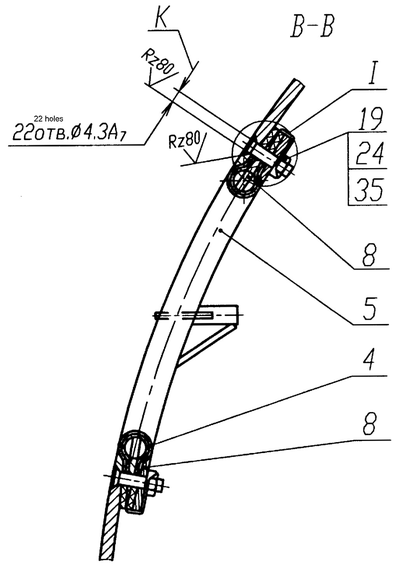












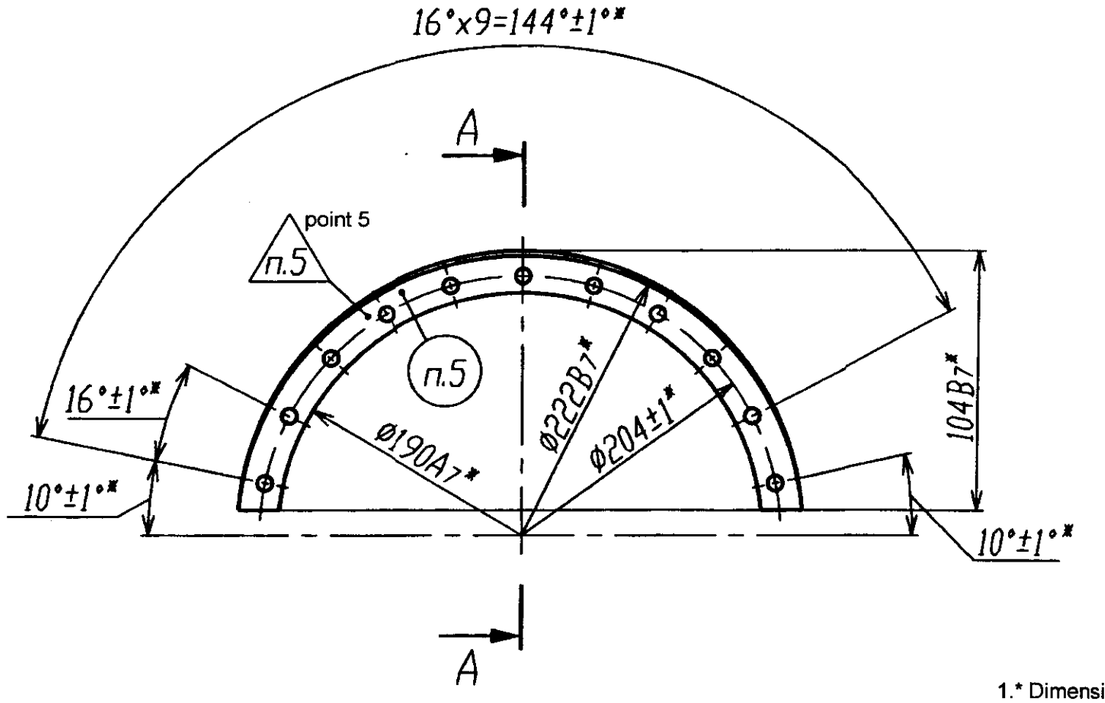
1. *Dimensions are ensured by tool.
2. Drill hole “3” in mask base pos. 1 and mask cover pos. 2 as per arrow pos. 10, lock pos. 3 and bracket pos.11 .
3. Drill hole K in mask base pos. 1 and mask cover pos. 2 on gasket pos. 8 .
4. Setting of lock should be ensured with tie-link till mating of mask cover and mask base on plane E from both sides. Local clearance not more than 0.2 mm is permissible .
5. During closing of lock by manual force,its locator should trigger under action of springs .
6. In assembly AK-630M SB.00 SB clearance should not be less than 1 mm at places of maximum closeness between bolts pos. 18 Sb 103 SB and carriage AK-630 102-47.

Placing of washer under bolt heads as per GOST 11371-78 is permissible .

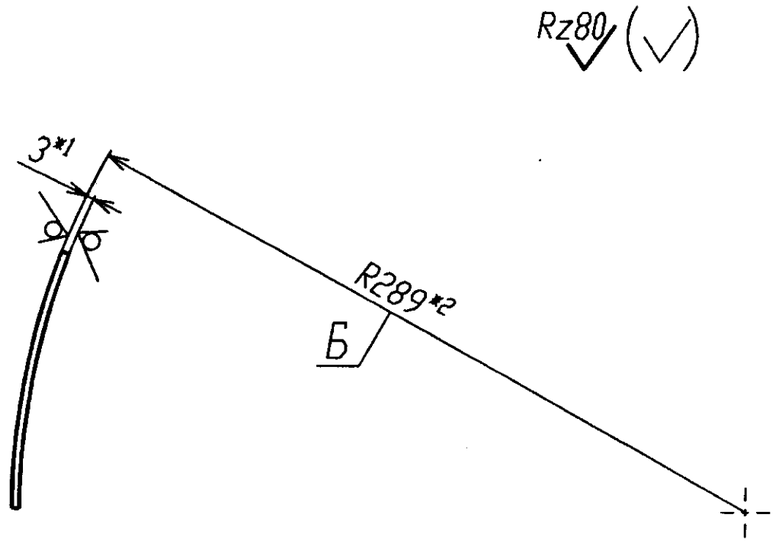
7. Carry out locking of bolts pos. 17,18 after final setting of mask on article.
8. Cut the lower packing and upper packing projecting beyond outer surface of mask at places of joint of mask cover and mask base parts, flush with from these surfaces.
9. Use of rivet 4X10.03.015.026 GOST 10299-80 during placement of components pos. 3,10 is permissible .
10. Coating :
    Primer AK-070, yellowish (2),
    Enamelkhv-124, gray (4, IV, Om_2
    Except surfaces E and И .
    Restore (till placement of assemblies pos. 4 and pos. 5) with lacquer in case of damage of surface И coatings.
    Primer AK-070 GOST 25718-83
    Enamel khv-124 GOST 10144-89.
11. Mark Ш,Ч,Н, Ha and stamp K on AK-630, AK-630M TU 1 . На-technological unit number of assembly .

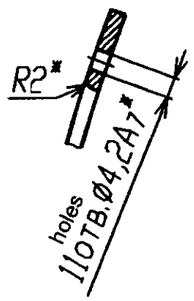
					AK-630 Sb103 SB	
Amend	Sheet	Doc. No.	Sign	Date	Mask Assembly drawing	Type: A; Weight: 7.800; Scale: 1:2
Developed by						Sheet; Sheets 1
Checked by						
Technician						
Head of bureau						
Head of Q.C.D						
Approved by						

AK-630 103-1



A-A(1:1)



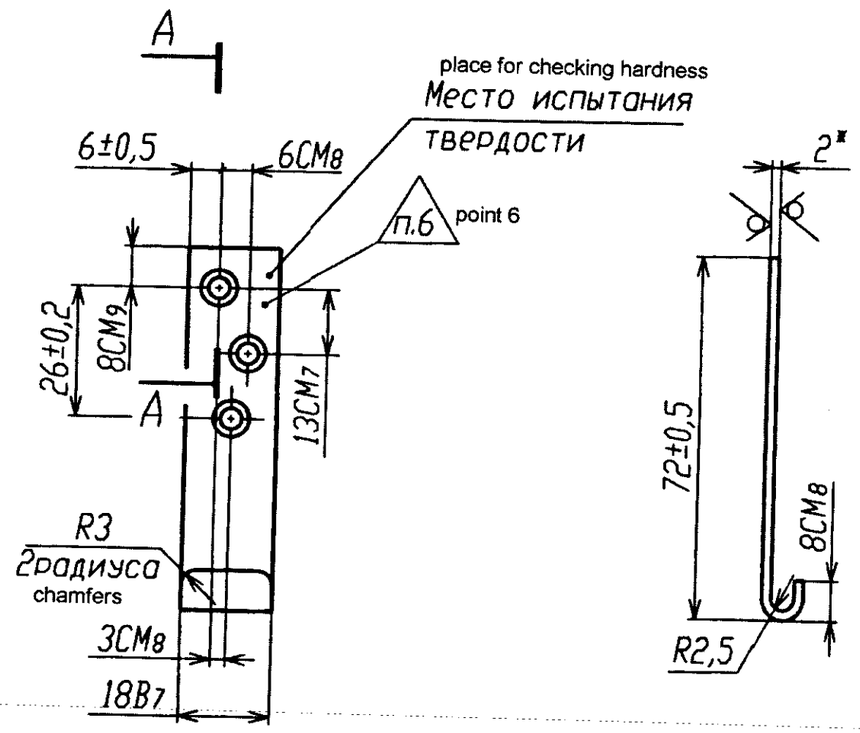


1.* Dimensions given before bending on radius Б.
2.*1 Reference dimension.
3.*2 Dimension ensured by tool.
4. Coating: Anodic Oxi.Cr.
5. Mark Ш , Ч and stamp К as per AK-630, AK-630M TU I.

Comment:

					AK-630M 103-1			
						Type	Weight	Scale
Amend.	Sheet	Doc.No.	Sign	Date	Cover plate	A	0.040	1:2
Developed by						Sheet	Sheets 1	
Checked by								
Head of Q.C.D					Sheet AMg6 BM-3 GOST 21631-76			
Approved by								

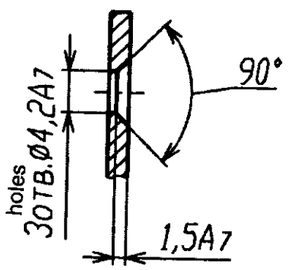
First use | Reference No. | Duplicate Inv. No | Sign and Date | Alternate Inv. No | Sign and Date | Orig. inv. no.



Rz80 (✓)

1. 34...39.5 HRC_E Check 3% of the batch, but not less than 3 components from the batch.
2. * Reference dimension.
3. Blunt sharp edges ~0.4 mm.
4. Coating Cd 12.phos. Lacquer BF-4 with Nigrozene, made as per OST 3-4123-78, IV, OM2.
5. Mark Ш , Ч and stamp K on tag.
6. Stamp И as per AK-630, AK-630M TU I.

A-A(2:1)



Comment:

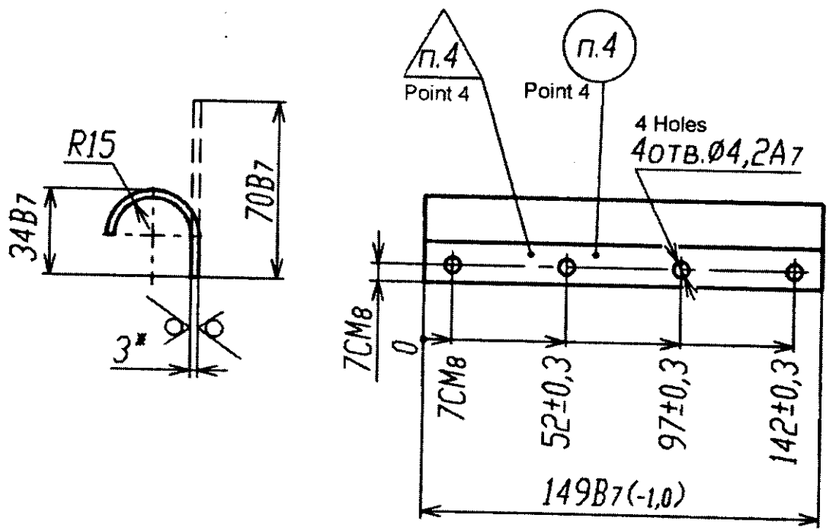
					AK-630 103-3			
Amend.	Sheet	Doc.No.	Sign	Date	Clamp	Type	Weight	Scale
Developed by						A	0.017	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					$Sheet \frac{BT-PN-O2GOST19904-90}{K490V4-III-40GOST16523-97}$			
Approved by								

First use | Reference No. | Duplicate Inv. No | Sign and Date | Alt. ..ate Inv. No | Sign and Date | Orig. inv. no.

Blank No. 406

AK-630 103-5

Rz80 (✓)



1..* Reference dimension
2.Blunt sharp edges ≈ 0.4 mm.
3.Coating: Anodic Oxi.Cr.
4.Mark Ш, Ч and stamp К as per AK-630, AK-630M TU I.

Approved KTONI | Approved by shop | First use
Approved TOsb | Reference No. | Dupl. Inv. No
Approved OGMet | Alternate Inv. No | Sign and Date
Orig. Inv. No. | Sign and Date | Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design chief				
Head of Q.C.D				
Approved by				

AK-630 103-5

Clamp

Type	Weight	Scale
A	0.075	1:2

Sheet | Sheets 1

Sheet AMg6 BM-3 GOST 21631-76

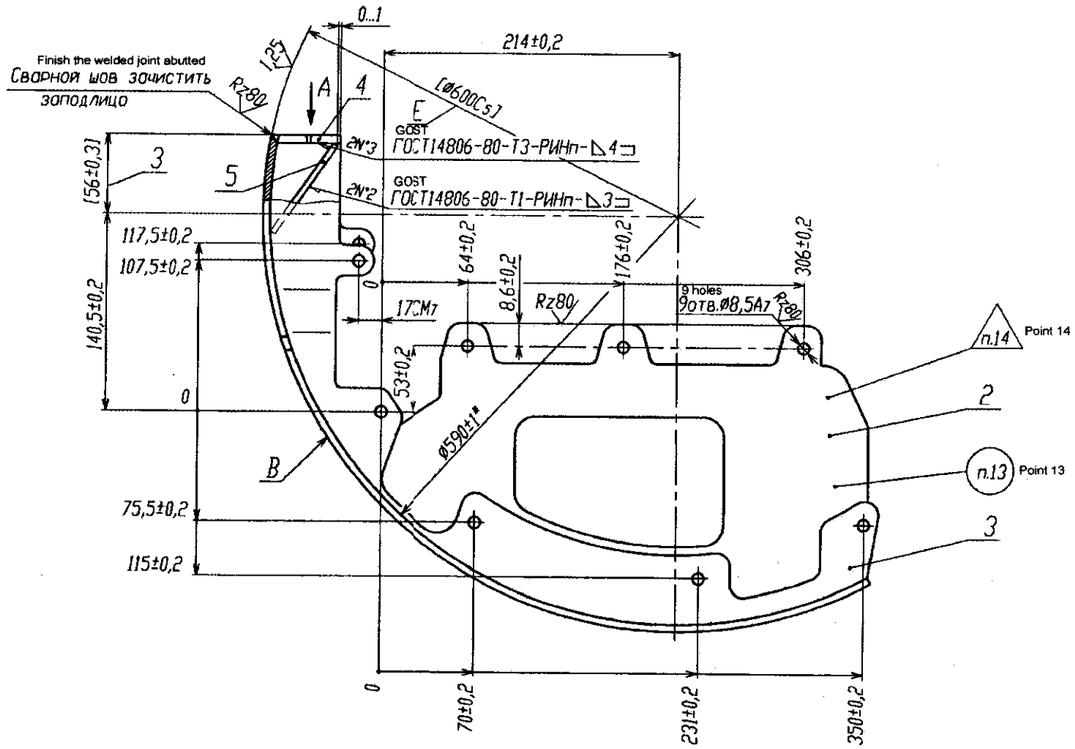
Copied by

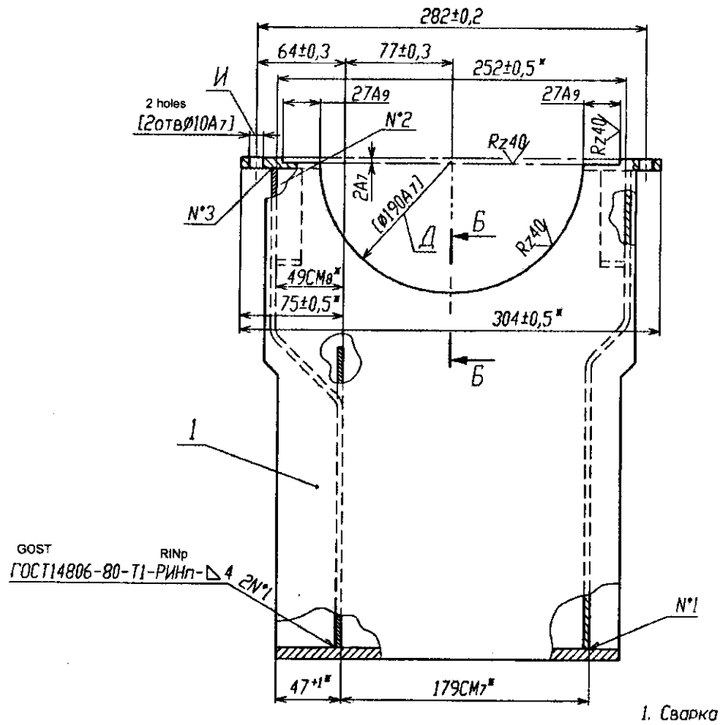
Format A4

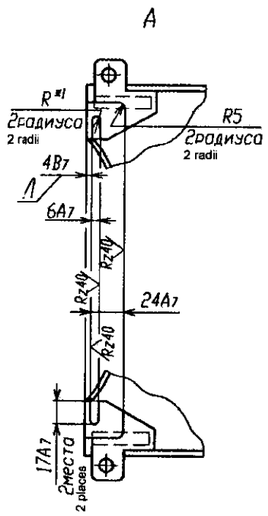
First use	Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
					Documents		
	A1			AK-630 Sb 103-1 SB	Assembly drawing		
Reference No.							
					Components		
	A2		1	AK-630 103-6	Lower half ring	1	
	A2		2	AK-630 103-7	Right wall	1	
	*)		3	AK-630 103-8	Left wall	1	*) A4 x3
	A4		4	AK-630 103-9	Plate	2	
	A4		5	AK-630 103-300	Rib	2	

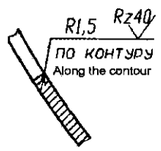
Sign and Date	Dupl. Inv. No.	Alternate Inv. No	Sign and Date	Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date		
Developed by					**AK-630M Sb 103-1**	
Checked by						Type: A; Sheet: ; Sheets: 1
					Base plate of mantlet	
Head of Q.C.D						
Approved by						









1. Argon - arc welding with the use of filler electrode Sv. AMg6 GOST 7871-75.
2. After the welding, the straightening of assembly is permitted.
3. * - Dimensions for reference.
4. *1 - Dimensions are ensured by tool.
5. Blunt the sharp edges ~ 0.4 mm.
6. During the drilling of hole И, maintain the dimension Ж (ref. AK-630 Sb 103SB)
7. Recess of plate pos. 4 in resepct of right side wall and left side wall pos. 2 and 3 for not more than 0.5 mm. is permitted.
8. After obtaining the dimensions 3 and И, carry out the machining as per the dimensions, given in square brackets, together with Sb 103-2
9. On obtaining the dimension E, the thickness of lower semi-ring pos. 1 for less than 4 mm is not permitted.
10. On making of dimension Л, the machining of component pos. 1 is permitted on the length - not more than 12 mm.
11. Coating: An. Ox. hard.
Surface B - varnish FBF-74D, 2 layers TU 6-05-1617-88. IV. OM2.
12. On detection of cracks on the welded joints, after the anodization for not more than once, it is permitted to carry out the rectification by filing (cutting out) of cracks and by argon-arc welding with subsequent coating of primer AK-070 GOST 25718-83.
13. Mark Ш, Ч, На. Put the same aggregate number on the jointly machined components AK-630 Sb 103-1 and AK-630 SB 103-2.
На - Technological aggregate number of assembly.
14. Stamp K as per AK-630, AK-630M TU I.

1. Сварка аргоно-дуговая с применением присадочной проволоки Св.АМг6 ГОСТ 7871-75.
2. После сварки допускается правка сборки.
3. * Размеры для сварки.
4. *! Размеры обеспеч. инстр.
5. Острые ребра притупить ≈ 0.4 мм.
6. При сверлении отв. И выдерживать размер Ж (см. АК-630 Сб103СБ).
7. Допускается утопание пластины поз.4 относительно стенки правой и стенки левой поз.2 и 3 не более 0,5 мм.
8. Обработку по размерам в квадратных скобках производить совместно со Сб103-2 после получения размеров 3 и И.
9. При получении размера Е толщина полукольца нижнего поз.1 менее 4 мм не допускается.
10. При выполнении размера Л обработка дет. поз. 1 допускается на длине не более 12 мм.
11. Покрытие: Ан. Окс. тв.
Поверхность В-лак ФБФ-74Д, 2слоя ТУ 6-05-1617-88. IV. ОМ2.
12. При обнаружении трещин в сварных швах после анодирования, не более одной, допускается производить исправление путем выпиливания (вырубания) трещин и аргоно-дуговую подварку с последующим покрытием грунтом АК-070 ГОСТ25718-83.
13. Маркировать Ш,Ч,На. На совместно обработанные АК-630 Сб103-1 и АК-630 СБ103-2 наносить одинаковые агрегатные номера.
На - технологический агрегатный номер сборки.
14. Клеймить К по АК-630, АК-630М ТУ. I.

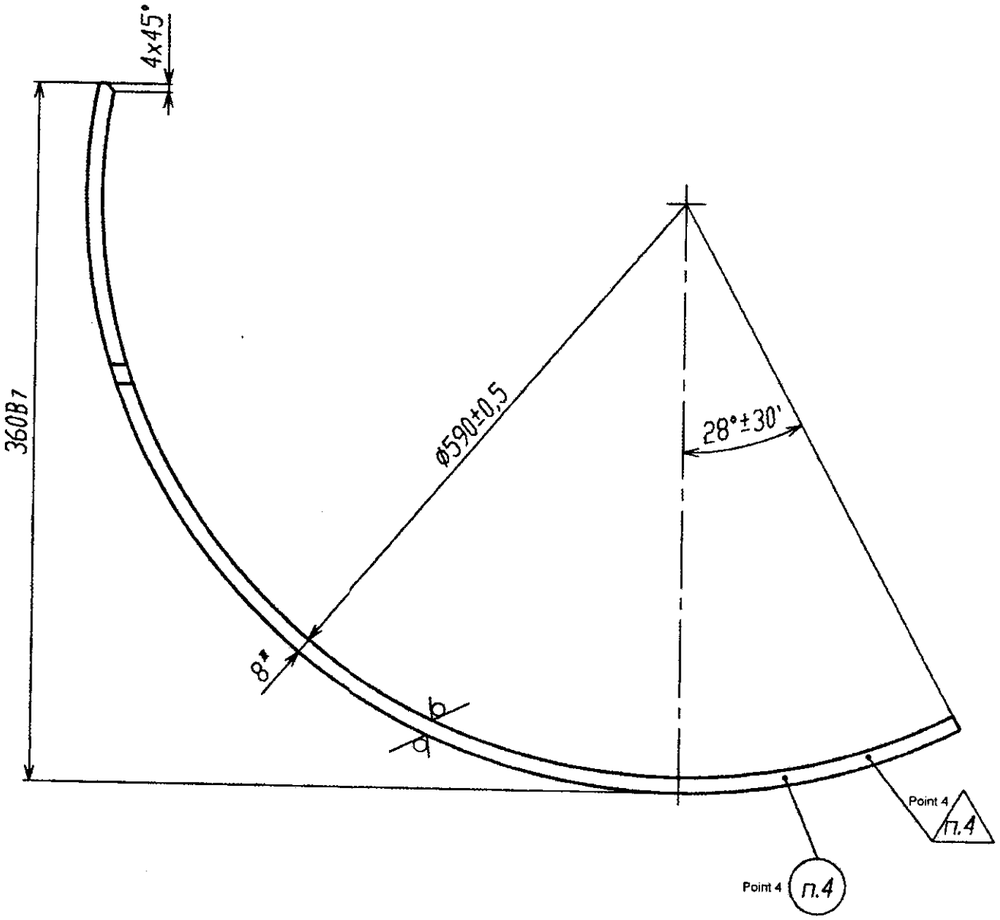
АК-630 Sb103 - 1 SB

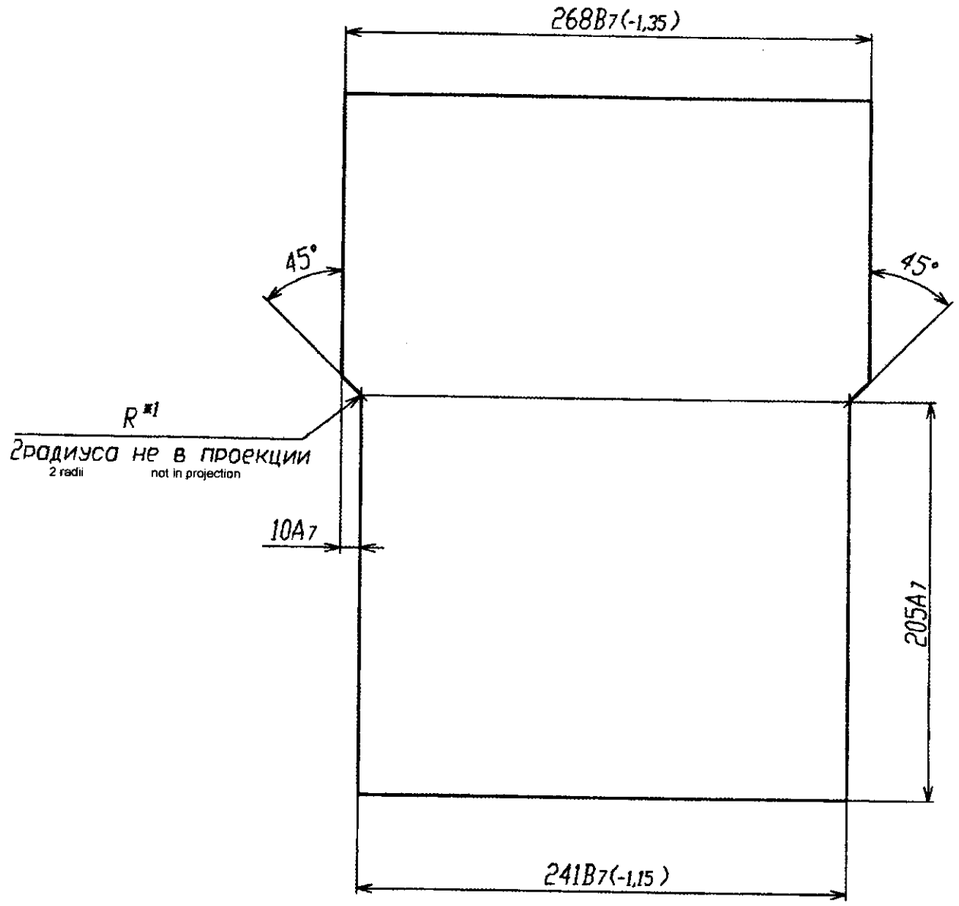
					АК-630 Сб103-1СБ	Type	Mass	Scale
Изм.	Лист	N докум.	Подп.	Дата		Лит.	Масса	Масштаб
Разраб.					Основание маски	A	3,320	1:2
Пров.					Сборочный чертеж	Лист	Листов 1	
Т.контр.					Base of the mask	Sheet	Total Sheets	
Н.контр.					Assembly drawing			
Утв.								

Формат А1

Инв.N подл. | Подп. и дата | Взам. инв.N | Инв.N дубл. | Подп. и дата

Rz80 (✓)





1. *- Dimension for reference.
2. *1- Dimensions are ensured by tool.
3. Blunt the sharp edges ~ 0.4 mm.
4. Mark Ш,Ч and stamp K as per АК-630, АК-630М ТУ. I.

1. *Размер для справок.
2. *1Размеры обеспеч. инстр.
3. Острые ребра притупить ≈0.4 мм.
4. Маркировать Ш,Ч и клеймить К по АК-630, АК-630М ТУ. I.

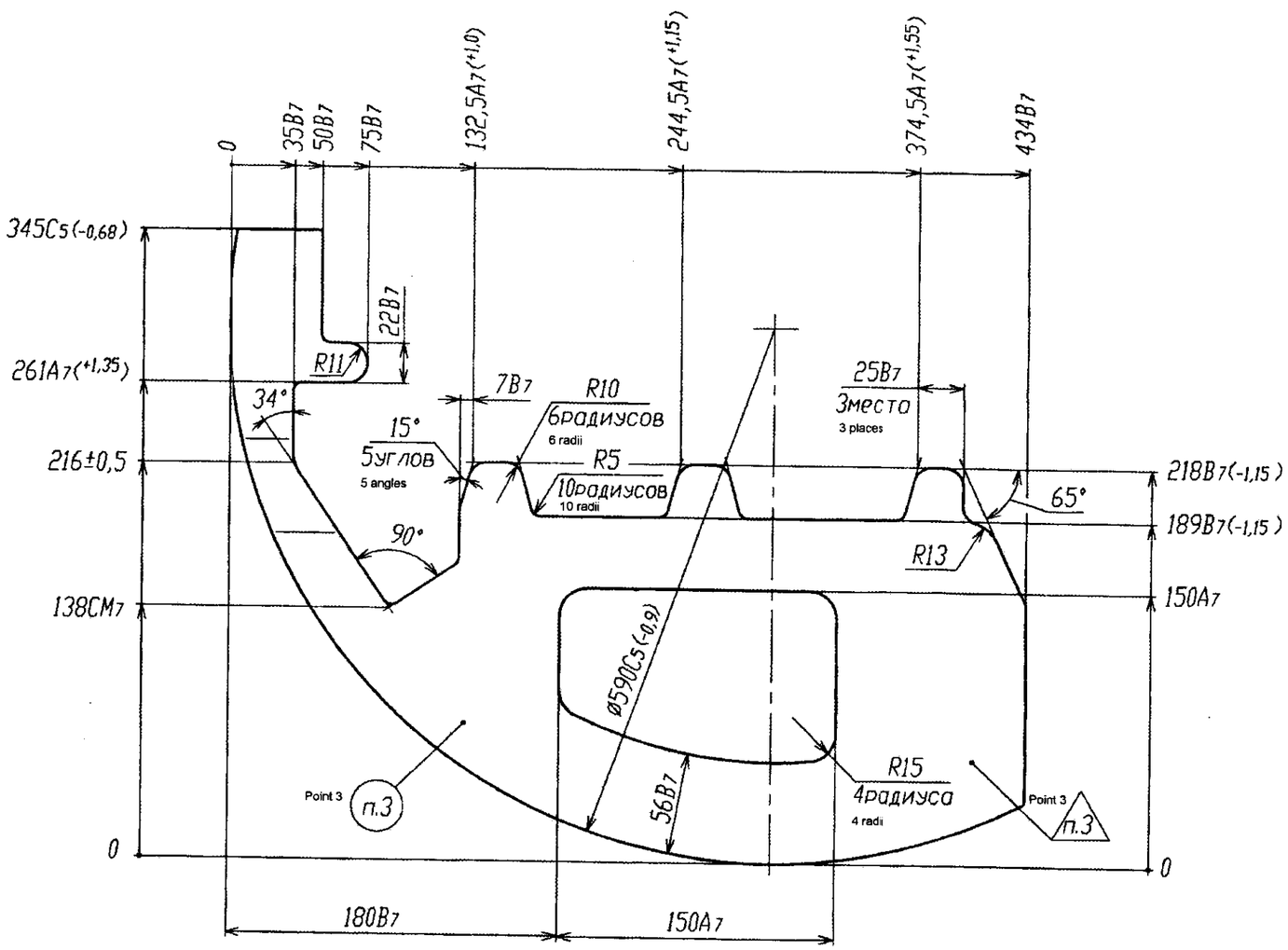
АК - 630 103-6

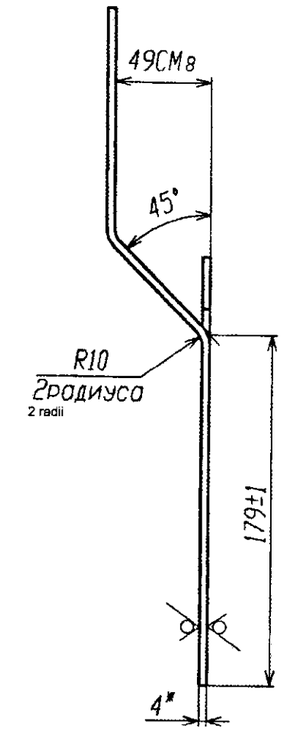
Изм.	Лист	N докум.	Подп.	Дата	АК-630 103-6	Type	Mass	Scale
Разраб.					Lower Semi-ring Полукольцо нижнее Sheet AMg6 M-8 GOST 21631-76	Лит.	Масса	Масштаб
Пров.						A	3,605	1:2
Т.контр.						Лист	Листов 1	
Н.контр.					Лист АМг6 М-8 ГОСТ 21631-76	Sheet	Total Sheets	
Утв.								

Формат А2

Перв. примен. | Справ.N | Инв.N подл. | Подп. и дата | Взам. инв.N | Инв.N дубл. | Подп. и дата

Rz40 (✓)





1. *- Dimension for reference.
2. Blund the sharp edges ~ 0.4 mm.
3. Mark Ш,Ч and stamp K as per AK - 630, AK-630M TU I.

1. *Размер для справок.
2. Острые ребра притупить ≈ 0.4 мм.
3. Маркировать Ш,Ч и клеймить К по АК-630, АК-630М ТУ. I.

Справ.N | Перв. примен.

Инв.N подл. | Подп. и дата | Взам. инв.N | Инв.N дубл. | Подп. и дата

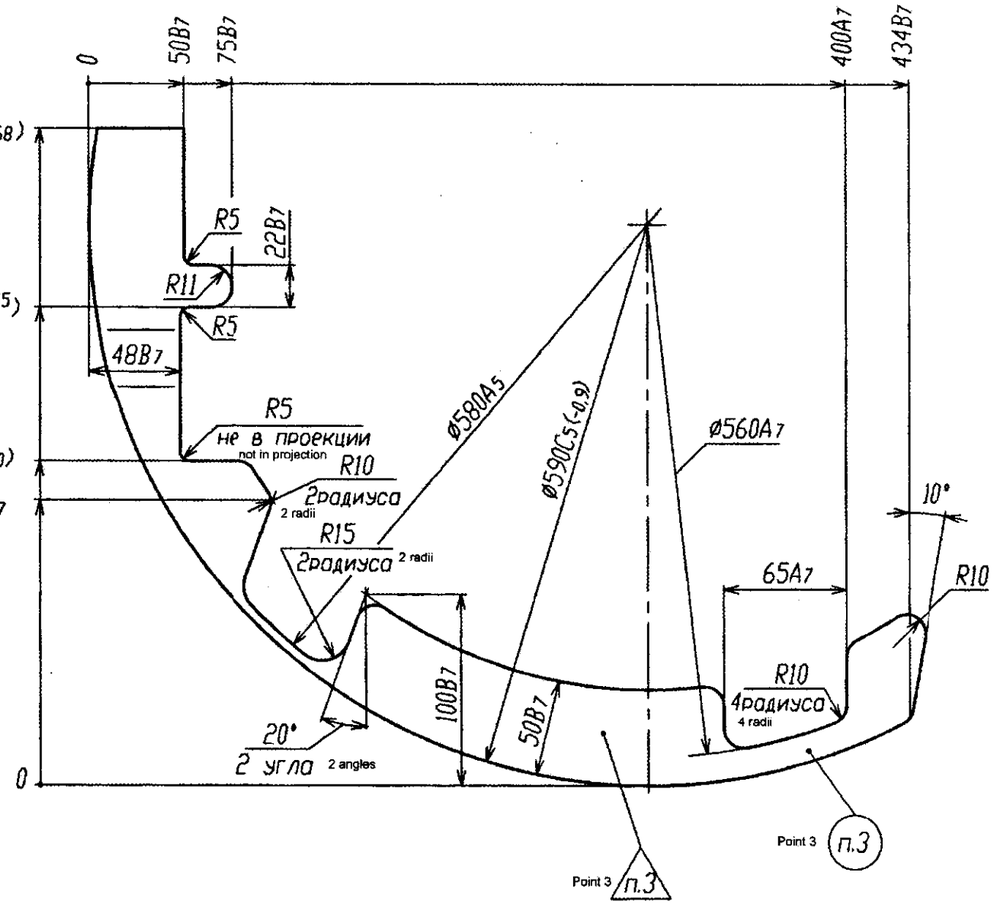
AK - 630 103-7

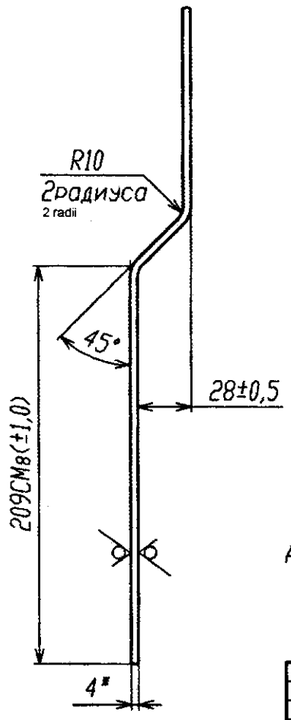
Изм.	Лист	N докум.	Подп.	Дата	АК-630 103-7	Type	Mass	Scale
Разраб.					Right side wall	Лит.	Масса	Масштаб
Пров.					Стенка правая	A	0,635	1:2
Т.контр.					Sheet AMg6 BM-4 GOST 21631-76	Лист	Листов 1	
Н.контр.					Лист АМг6 БМ-4 ГОСТ 21631-76	Sheet	Total Sheets	
Утв.								

Формат А2

АК-630 103-8

Rz80 (✓)





1. *- Dimension for reference.
2. Blunt the sharp edges ~ 0.4 mm.
3. Mark Ш,Ч and stamp K as per AK-630, AK-630M TU. I.

1. *Размер для справок.
2. Острые ребра притупить ≈0.4 мм.
3. Маркировать Ш,Ч и клеймить К по АК-630, АК-630М ТУ. I.

АК-630 103-8

Изм.	Лист	N докум.	Подп.	Дата	АК-630 103-8	Type	Mass	Scale
Разраб.					Left Wall / Стенка левая	Лит.	Масса	Масштаб
Пров.					Sheet AMg6 BM-4 GOST 21631-76	A	0,295	1:2
Т.контр.					Лист АМг6 БМ-4 ГОСТ 21631-76	Лист	Листов 1	
Н.контр.						Sheet	Total Sheets	
Утв.								

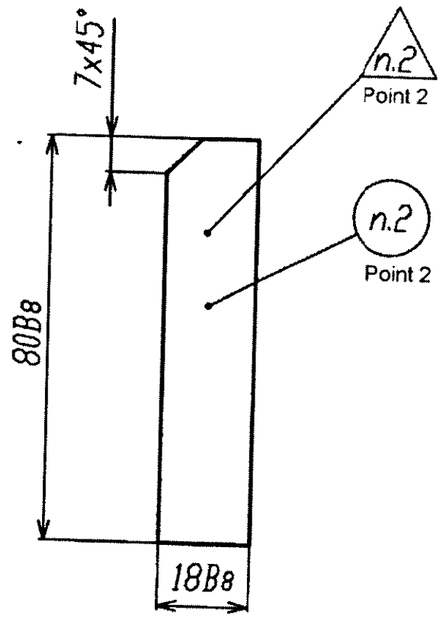
Формат А4х3

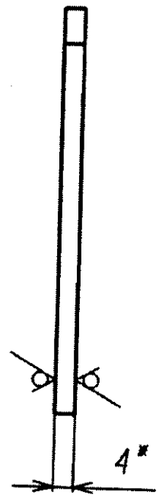
Перв. примен.
Справ.N
Подп. и дата
Инв.N подл.
Подп. и дата
Взам. инв.N
Инв.N дубл.
Подп. и дата

Blank No. 406

AK-630 103-300

Rz320 (✓)





1.* Reference dimension
2.Mark Ш, Ч and stamp K as per AK-630. AK-630M TU I.

Approved by shop | First use
Reference No.
Approved KTONI
Sign and Date
Dupl. Inv. No.
Approved TOsb
Alternate Inv. No
Sign and Date
Approved OGMet
Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design chief				
Head of Q.C.D				
Approved by				

Copied by

AK-630 103-300

Rib

Type	Weight	Scale
A	0.016	1:1

Sheet | Sheets 1

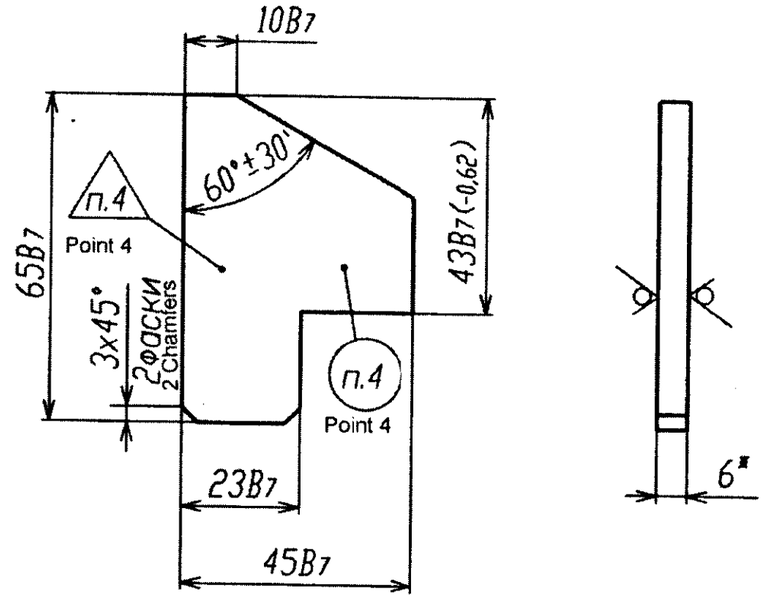
Sheet AMg6 BM-4
GOST 21631-76

Format A4

Blank No. 406

AK-630 103-9

Rz40 (✓)



1.* Reference dimension
2.Inner angles R ≈ 0.4 mm.
3.Blunt sharp edges ≈ 0.4 mm.
4.Mark Ш, Ч and stamp К as per АК-630, АК-630М ТУ I.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Head of Q.C.D				
Approved by				

AK-630 103-9

Plate

Type	Weight	Scale
A	0.022	1:1

Sheet | Sheets 1

Sheet A Mg6 M-6
GOST 21631-76

Approved by shop | First use
Reference No.
Approved KTONI
Sign and Date
Dupl. Inv. No.
Approved TOsb
Alternate Inv. No
Sign and Date
Approved OGMet
Orig. Inv. No.

Copied by

Format A4

Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
				Documents		
A1			AK-630 Sb 103-2 SB	Assembly drawing		
				Components		
A4		1	AK-630 103-9	Plate	2	
A2		2	AK-630 103-10	Outer half ring	1	
*)		3	AK-630 103-11	Upper wall	1	*)A4x3
*)		4	AK-630 103-12	Upper left wall	1	*)A4x3
A3		5	AK-630 103-13	Left support	1	
A3		6	AK-630 103-14	Right support	1	
A4		7	AK-630 103-15	Pin	2	
A4		8	AK-630 103-16	Insert	2	

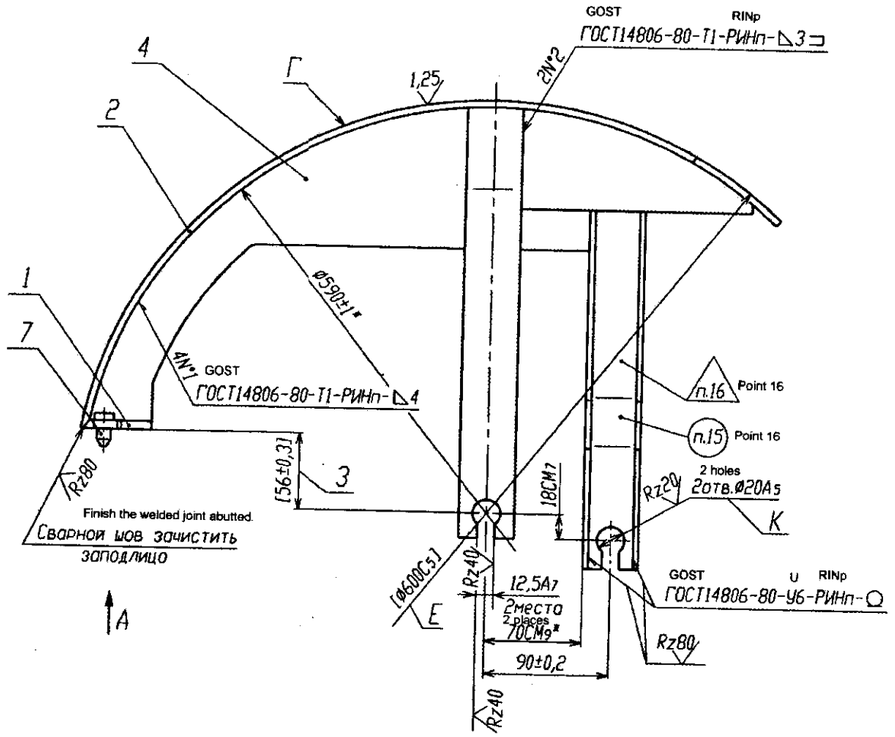
First use | Reference No. | Sign and Date | Dupl. Inv. No. | Alternate Inv. No | Sign and Date | Orig. Inv. No.

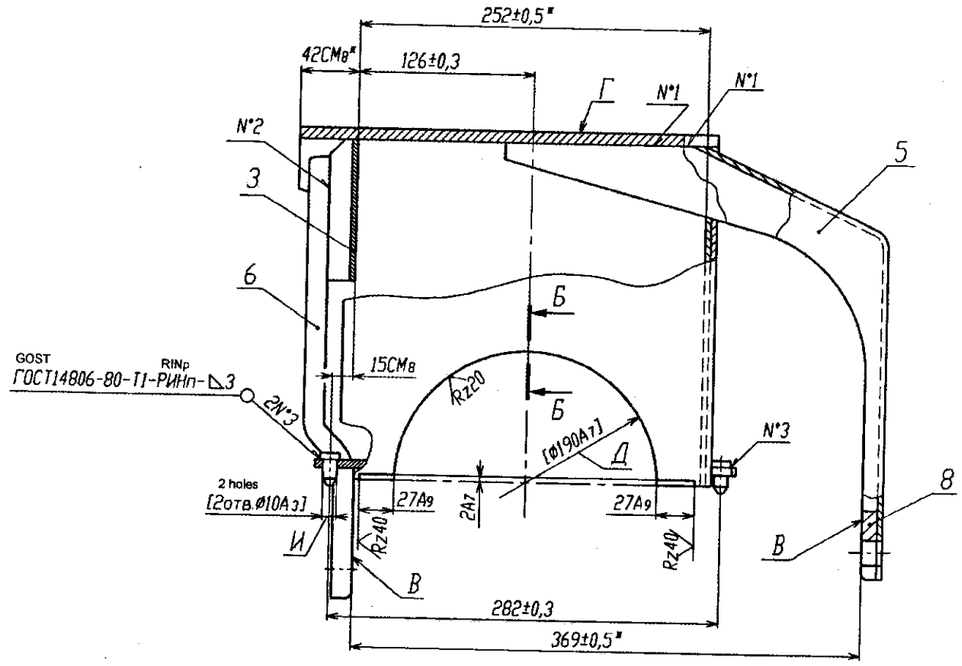
Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

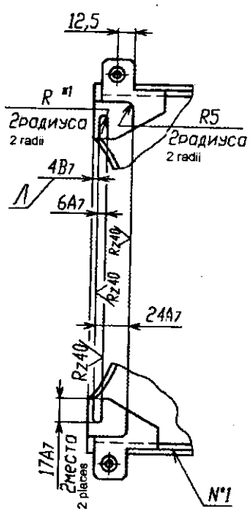
AK-630M Sb 103-2

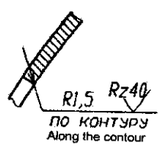
Mantlet cover

Type	Sheet	Sheets
A		1









1. Argon - arc welding with the use of filler electrode 3.15 Sv AMg6 GOST 7871-75.
2. After the welding, the straightening of assembly is permitted.
3. * - Dimensions for reference.
4. *1 - Dimensions are ensured by tool.
5. Blunt the sharp edges ~ 0.4 mm.
6. During the drilling of hole И, maintain the dimension Ж (ref. AK-630 Sb 103SB)
7. Recess of plate pos. 1 in resepct of right side wall and left side wall pos. 3 and 4 for not more than 0.5 mm. is permitted.
8. Non-perpendicularity of surfaces B and Г is permitted for not more than 0.2 mm.
9. Fix up the pins pos. 7 on the plates pos. 1 by welding each one at two points.
10. After obtaining the dimensions 3 and И, carry out the machining as per the dimensions, given in square brackets, together with AK-630 Sb 103-1.
11. On obtaining the dimension E, the thickness of upper semi-ring pos. 2 for less than 4 mm is not permitted.
12. On making of dimension Л, the machining of component pos. 2 is permitted on the length - not more than 12 mm.
13. Coating: An. Ox. hard.
    Surface Г - varnish FBF-74D, 2 layers TU 6-05-1617-88. IV. OM2.
14. On detection of cracks on the welded joints, after the anodization for not more than once, it is permitted to carry out the rectification by filing (cutting out) of cracks and by argon-arc welding with subsequent coating of primer AK-070 GOST 25718-83.
15. Mark Ш, Ч, На. Put the same aggregate number on the jointly machined components AK-630 Sb 103-1 and AK-630 SB 103-2.
    На - Technological aggregate number of assembly.
16. Stamp K as per AK-630, AK-630M TU I.

1. Сварка аргоно-дуговая с применением присадочной проволоки 3,15 Св. АМг6 ГОСТ7871-75.
2. После сварки допускается правка сборки.
3. * Размеры для справки.
4. *1 Размеры обеспеч. инстр.
5. Острые ребра притупить ≈ 0.4 мм.
6. При сверлении отв. И выдерживать размер Ж (см. АК-630 Сб103СБ).
7. Допускается утопание пластины поз.1 относительно стенки верхней и стенки верхней левой поз.3 и 4 не более 0,5 мм.
8. Неперпендикулярность поверхностей В и Г допускается не более 0,2 мм.
9. Штыри поз.7 фиксировать в пластинах поз.1 приваркой каждого в двух точках.
10. Обработку по размерам в квадратных скобках производить совместно с АК-630 Сб103-1 после получения размеров 3 и И.
11. При получении размера Е толщина полукольца верхнего поз.2 менее 4 мм не допускается.
12. При выполнении размера Л обработка дет. поз.2 допускается на длине не более 12 мм.
13. Покрытие: Ан. Окс. тв.
Поверхность Г-лак ФБФ-74Д 2слоя ТУ6-05-1617-88. IV.ОМ2.
14. При обнаружении трещин в сварных швах после анодирования, не более одной, допускается производить исправление путем выпиливания (вырубания) трещин и аргоно-дуговую подварку с последующим покрытием грунтом АК-070 ГОСТ25718-83.
15. Маркировать Ш,Ч,На. На совместно обработанные АК-630 Сб103-1 и АК-630 СБ103-2 наносить одинаковые агрегатные номера.
На - технологический агрегатный номер сборки.
16. Клеймить К по АК-630, АК-630М ТУ. I.

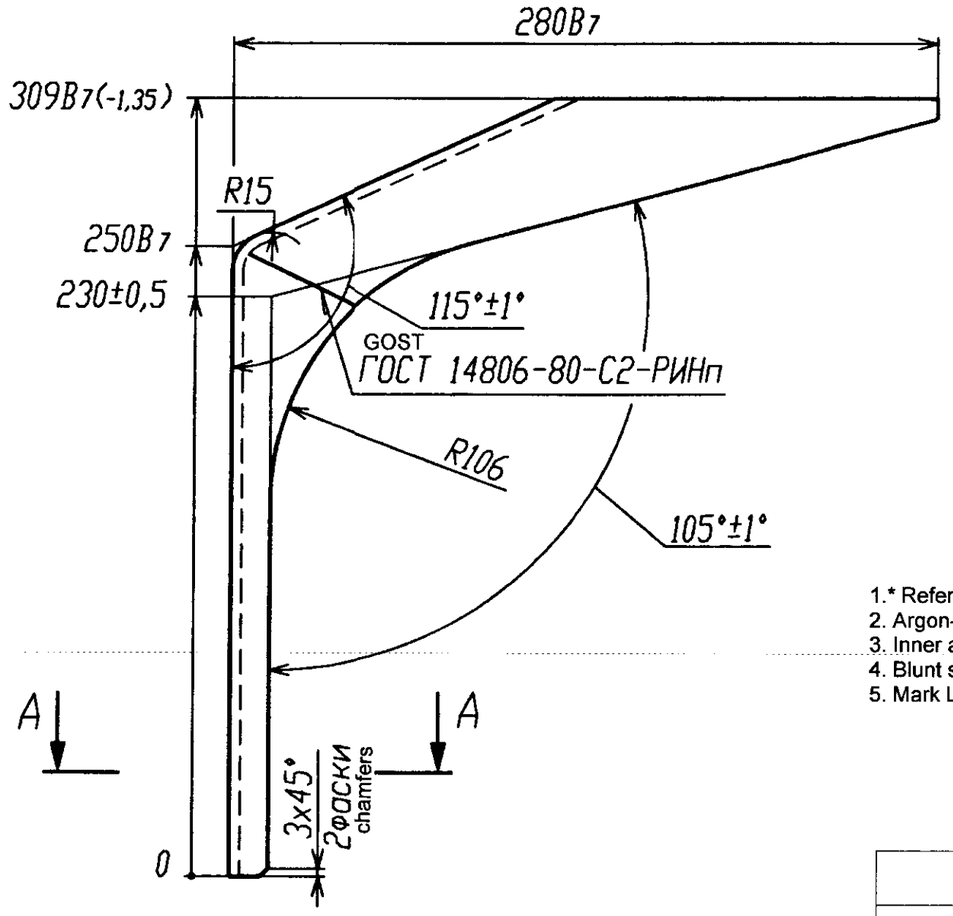
AK-630 Sb103 - 2 SB

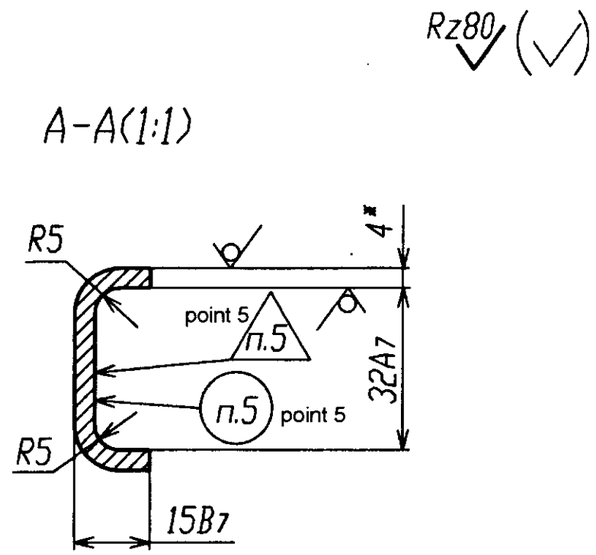
					АК-630 Сб103-2СБ			
Изм.	Лист	N докум.	Подп.	Дата	Cover of mask	Type	Mass	Scale
Разраб.					Крышка маски	Лит.	Масса	Масштаб
Пров.						A	3,740	1:2
Т.контр.					Сборочный чертеж	Лист	Листов 1	
Н.контр.					Assembly drawing	Sheet	Total Sheets	
Утв.								

Формат А1

Инв.N подл. | Подп. и дата | Взам. инв.N | Инв.N дубл. | Подп. и дата

AK-630 103-13





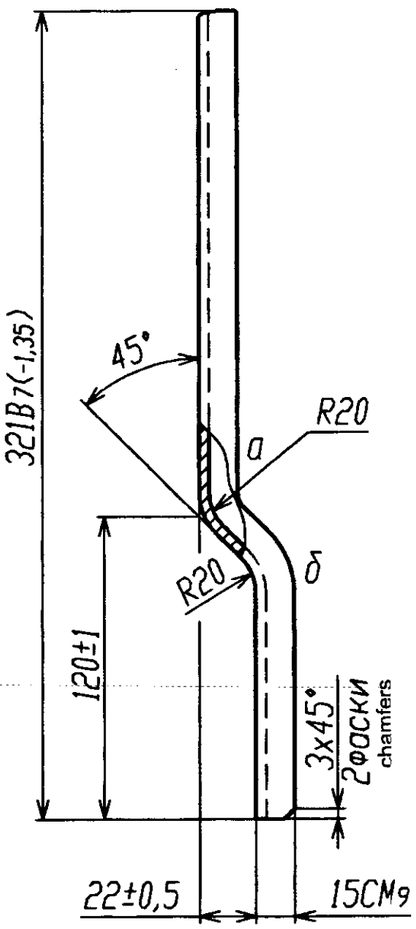
1.* Reference dimensions.
2. Argon-arc welding using filling wire 2 Sv.AMg6 GOST 7871-75.
3. Inner angles R~0.4 mm.
4. Blunt sharp edges ~0.4 mm.
5. Mark Ш, Ч and stamp К as per AK-630, AK-630M TU I.

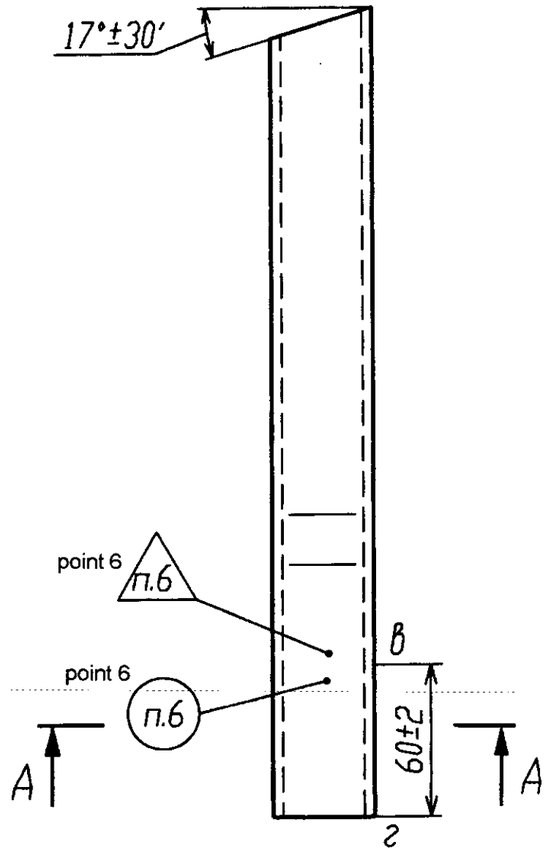
Comment:

					AK-630 103-13			
					Left support	Type	Weight	Scale
Amend.	Sheet	Doc.No.	Sign	Date		A	0.420	1:2
Developed by						Sheet	Sheets 1	
Checked by								
Head of Q.C.D					Sheet AMg6 BM-4 GOST 21631-76			
Approved by								

First use | Reference No. | Duplicate Inv. No | Sign and Date | Alternate Inv. No | Sign and Date | Orig. inv. no.

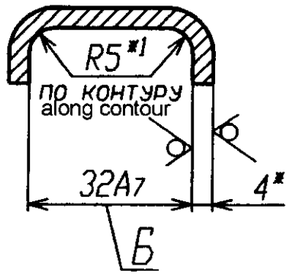
AK-630 103-14





Rz80 (✓)

A-A(1:1)



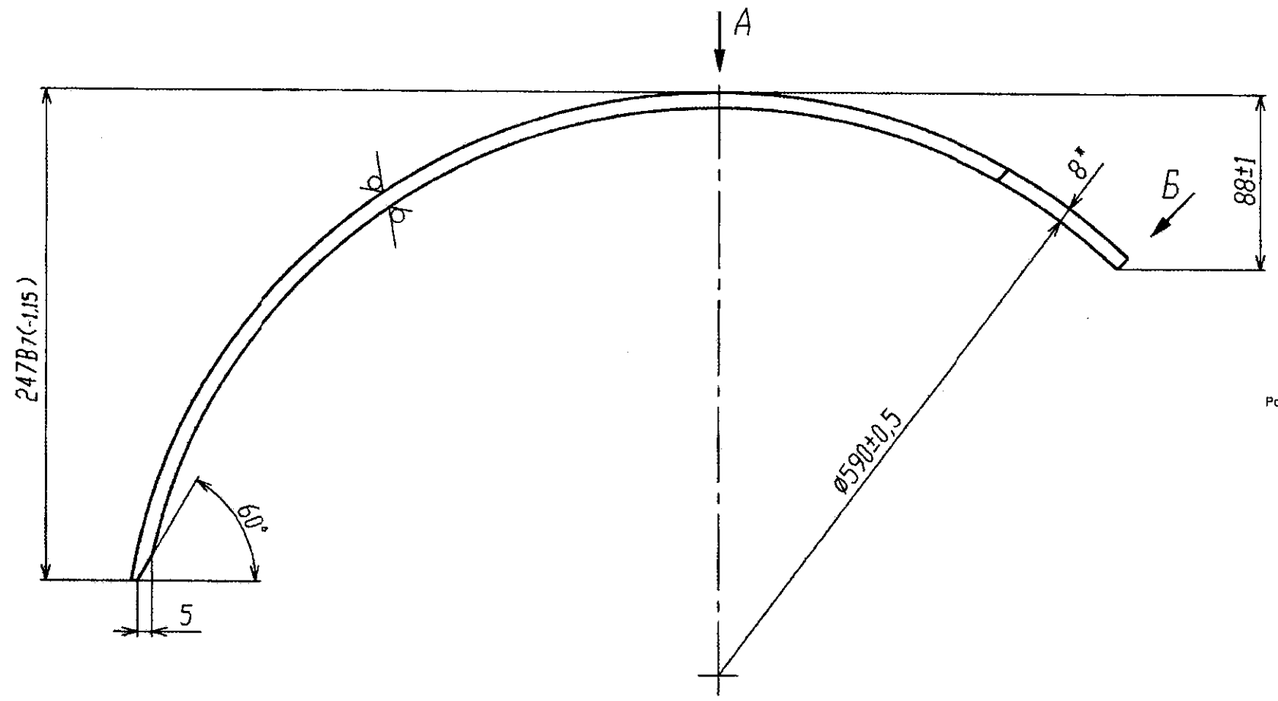
1.* Reference dimensions.
2.*1 Dimension ensured by tool.
3. Decrease in sheet thickness after stamping on section аб to dimension 3.5 is permissible.
4. Check dimension Б on section вг , on remaining length, increase of groove to dimension $32A_9$ is permissible.
5. Blunt sharp edges ~0.4 mm
6. Mark Ш, Ч and stamp К as per АК-630, АК-630М ТУ I.

Comment:

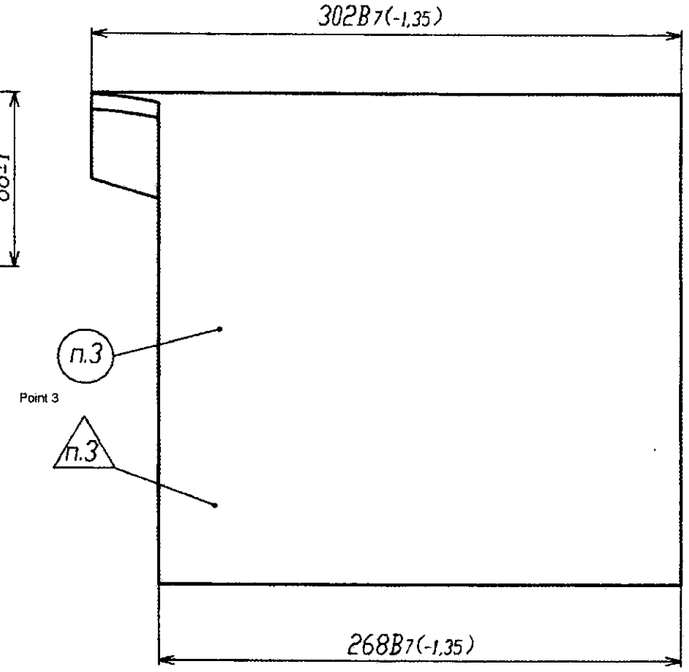
Amend.	Sheet	Doc.No.	Sign	Date	AK-630 103-14			
Developed by					Right support	Type	Weight	Scale
Checked by						A	0.185	1:2
						Sheet	Sheets 1	
Head of Q.C.D					Sheet AMg6 BM-4 GOST 21631-76			
Approved by								

First use | Reference No. · | Sign and Date | Duplicate Inv. No | Alte. .ie Inv. No | Sign and Date | Orig. inv. no.

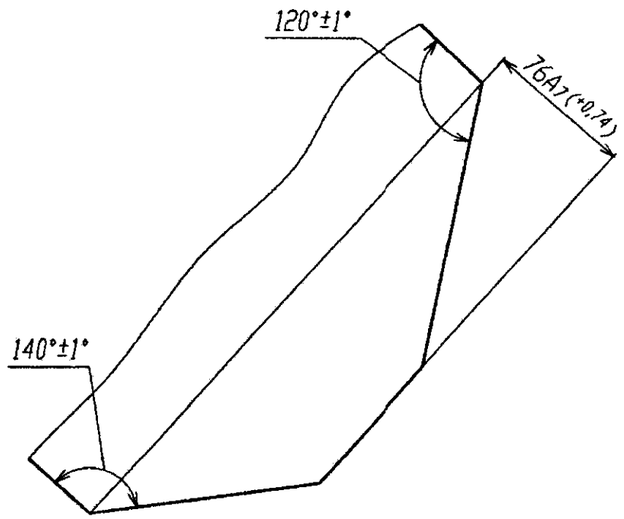
Rz80

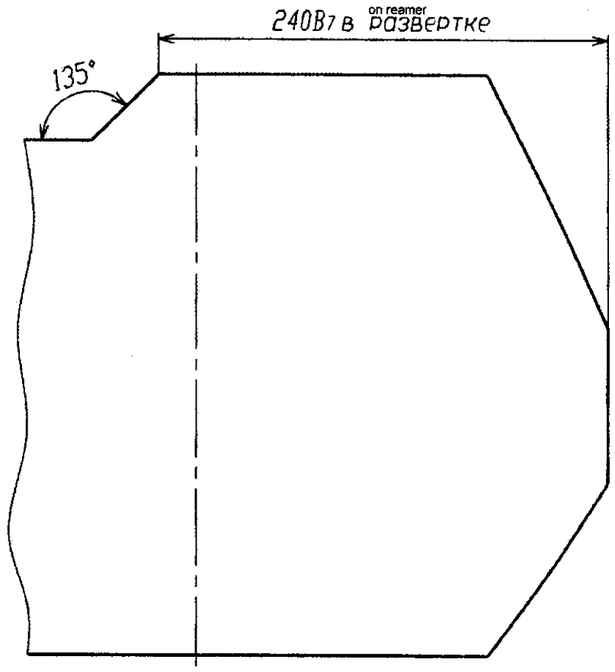


А



Б





1. *- Dimension for reference .
2. Blunt the sharp edges ~0.4 mm.
3. Mark Ш,Ч and stamp К as per АК-630, АК-630М ТУ. I.

1. *Размер для справок.
2. Острые ребра притупить ≈0.4 мм.
3. Маркировать Ш,Ч и клеймить К по АК-630, АК-630М ТУ. I.

АК - 630 103-10

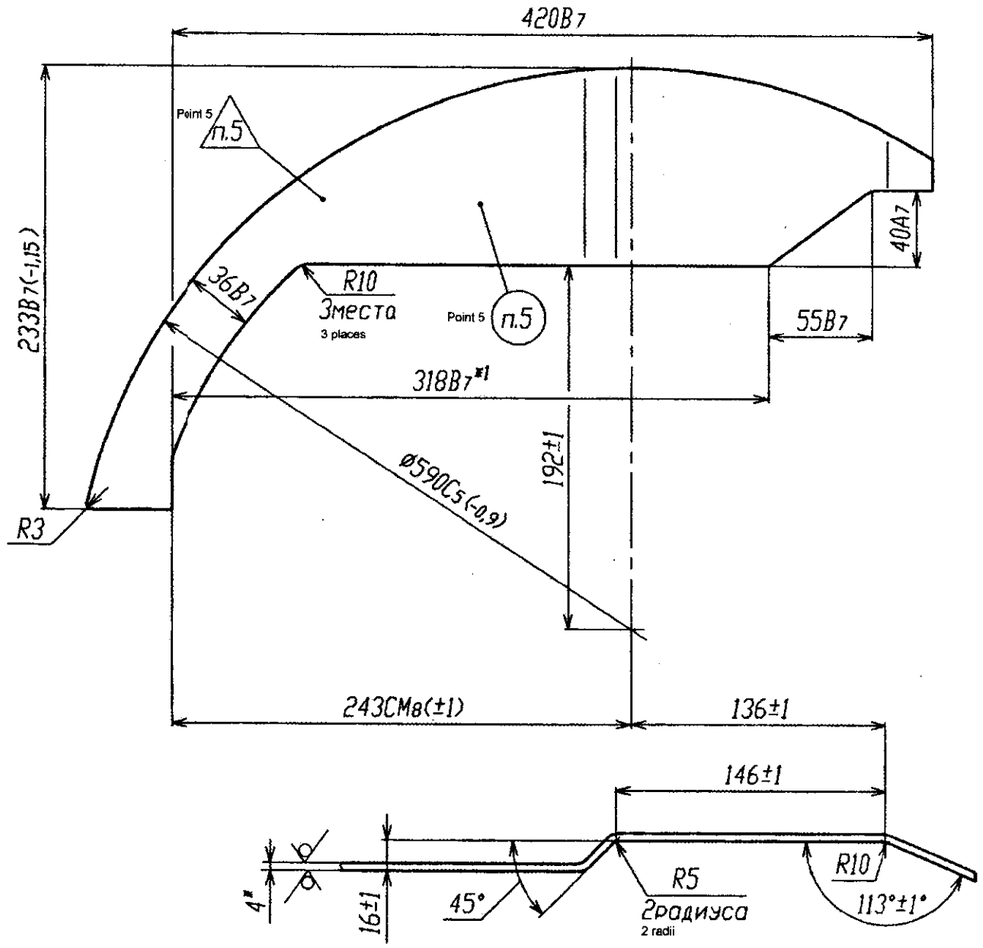
					АК-630 103-10	Type	Mass	Scale
Изм.	Лист	N докум.	Подп.	Дата	Upper Semi-Ring Полукольцо верхнее	Лит.	Масса	Масштаб
Разраб.						A	3,615	1:2
Пров.						Лист	Листов 1	
Т.контр.								
Н.контр.					Лист АМг6 М-8 ГОСТ 21631-76	Sheet	Total Sheets	
Утв.								

Sheet AMg6 M-8 GOST 21631-76 Формат А2

Перв. примен.
Справ.N
Подп. и дата
Инв.N подл.
Взам. инв.N
Инв.N дубл.
Подп. и дата

АК-630 103-11

Rz80 (✓)



1. *- Dimension for reference.
2. *1- Dimension for reaming.
3. Internal angles R ~ 0.4 mm.
4. Blunt the sharp edges ~ 0.4 mm.
5. Mark Ш,Ч and stamp K as per АК-630, АК-630 М ТУ I.

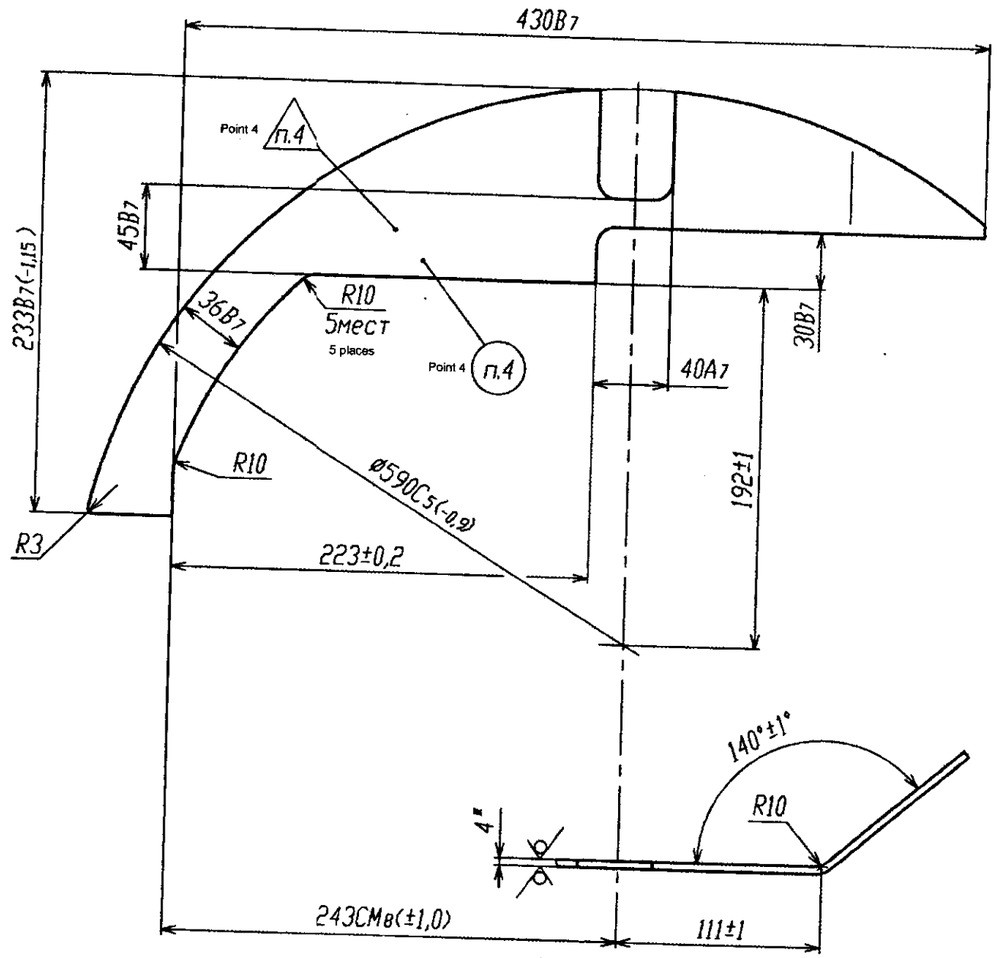
1. *Размер для справок.
2. *1Размер для развертки.
3. Внутренние углы R ≈ 0.4 мм.
4. Острые ребра притупить ≈ 0.4 мм.
5. Маркировать Ш,Ч и клеймить К по АК-630, АК-630М ТУ. I.

АК-630 103-11

					АК-630 103-11			
Изм.	Лист	N докум.	Подп.	Дата	Upper wall Стенка верхняя	Type	Mass	Scale
Разраб.						Лит.	Масса	Масштаб
Пров.						A	0.360	1:2
Т.контр.						Лист	Листов 1	
Н.контр.					Лист АМг6 БМ-4 ГОСТ 21631-76	Sheet	Total Sheets	
Утв.								

Sheet АМг6 БМ-4 21631-76 Формат А4х3

Перв. примен.
Инв.N
Подп. и дата
Инв.N дубл.
Взам.
Подп. и дата
Инв.N подл.



Rz80 (✓)

1. *- Dimension for reference.
2. Internal angles R~ 0.4 mm.
3. Blund the sharp edges ~0.4 mm.
4. Mark Ш,Ч and stamp К as per АК-630, АК-630М ТУ I.

1. *Размер для справок.
2. Внутренние углы R ≈ 0.4 мм.
3. Острые ребра притупить ≈ 0.4 мм.
4. Маркировать Ш,Ч и клеймить К по АК-630, АК-630М ТУ. I.

АК - 630 103-12

Изм.	Лист	N докум.	Подп.	Дата	АК-630 103-12			
Разраб.					Upper Left Wall Стенка верхняя левая	Type	Mass	Scale
Пров.						Лит.	Масса	Масштаб
Т.контр.						A	0,300	1:2
Н.контр.					Лист АМг6 ВМ-4 ГОСТ 21631-76	Лист	Листов 1	
Утв.						Sheet	Total Sheets	

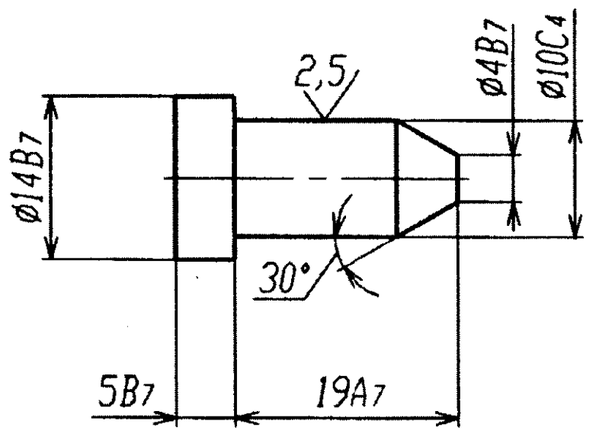
Sheet AMg6 BM-4 21631-76 Формат А4х3

Перев. примен.
Инв.N подл. | Подп. и дата | Взам. инв.N | Инв.N дубл. | Подп. и дата

Blank No. 406

AK-630 103-15

Rz80 (✓)



1.Inner angles R ≈ 0.4 mm.
2.Blunt sharp edges ≈ 0.4 mm.
3.Mark Ш, Ч and stamp К on tag.

Approved by shop | First use
Reference No.
Approved KTONI
Sign and Date
Dupl. Inv. No.
Approved TOsb
Alternate Inv. No
Sign and Date
Approved OGMet
Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design chief				
Head of Q.C.D				
Approved by				

AK-630 103-15

Cover pin

Type	Weight	Scale
A	0.005	2:1

Sheet | Sheets 1

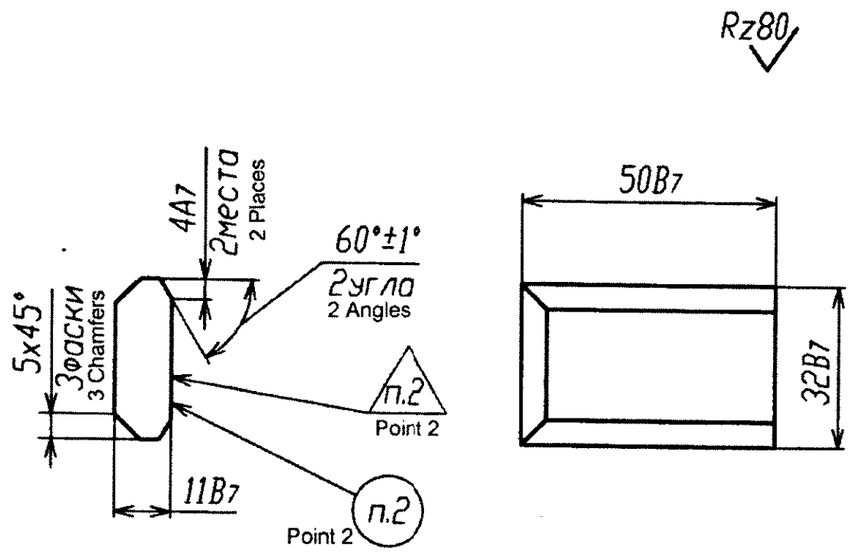
Alloy AMg6
GOST 4784-97

Copied by

Format A4

Blank No. 406

AK-630 103-16



1.Blunt sharp edges ≈ 0.4 mm.
2.Mark Ш, Ч and stamp К as per АК-630, АК-630М ТУ I.

Approved by shop | Reference No. | First use
Approved KTONI | Sign and Date | Dupl. Inv. No
Approved TOsb | Alternate Inv. No
Approved OGMet | Sign and Date | Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design chief				
Head of Q.C.D				
Approved by				

AK-630 103-16

Insert

Type	Weight	Scale
A	0.045	1:1

Sheet | Sheets 1

Alloy AMg6
GOST 4784-97

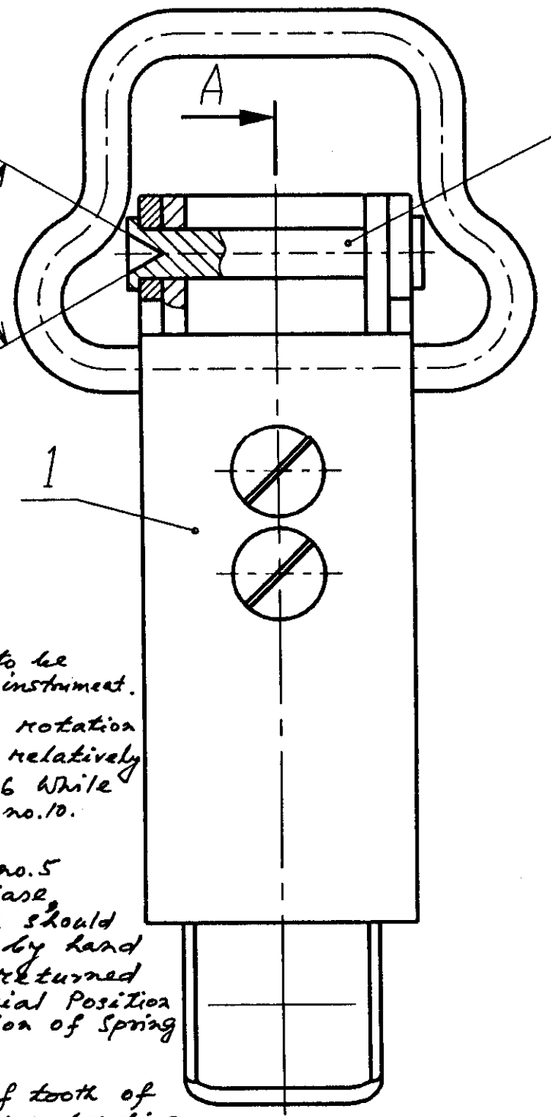
Copied by

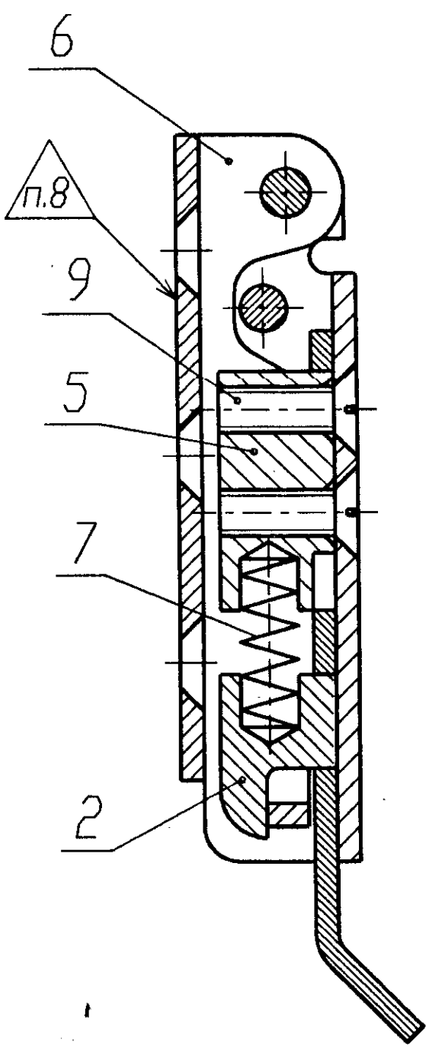
Format A4

First use / Reference No.	Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
					Documents		
	A3			AK-630 Sb 103-3 SB	Assembly drawing		
					Assembly units		
	A4		1	AK-630 Sb 103-6	Lever with clevis	1	
	A4		2	AK-630 Sb 103-7	Retainer	1	
					Components		
	A4		3	AK-630 103-21	Stop	1	
	A3		6	AK-630 103-22	Base plate	1	
	A3		7	AK-630 103-23	Spring	2	
					Standard articles		
Sign and Date			9		Screw BM4-6gx12.109.40Kh.026	2	65.5..70
					GOST 17475-80		HRA
			10		Pin 4h9x25.50Cd6 Cr.	1	
					GOST 10774-80		
Dupl. Inv. No.							
Alternate Inv. No.							

Sign and Date						
						AK-630M Sb 103-3
	Amend.	Sheet	Doc. No.	Sign	Date	
	Developed by					**Lock**
Orig. Inv. No.	Checked by					
	Head of Q.C.D					
	Approved by					

Type	Sheet	Sheets
A		1





1. Dimension to be ensured by instrument.
2. Ensure free rotation of lever no.1 relatively with base no.6 while flaring pin no.10.
3. While stop no.5 pressed to base, locator no. 2 should be shifted by hand force and returned to its initial position under action of spring no.7.
4. Stopping of tooth of locator under bending of base should result by hand pressure on lever. Sawing of radius part of locator is permitted.
5. Faces of threaded part of screws no.9 to be sawed flush with surface of stop and centre punched in three points each.
6. Rubbing surfaces to be lubricated with lubricant МС-70 GOST 9762-76.
7. Mark Ш, Ч on tag.
8. Stamp К as per АК-630, АК-630М ТУ1.

1. *Размер обеспеч. инстр.
2. При развальцевании штифта поз.10 обеспечить свободное вращение рычага поз.1 относительно основания поз.6.
3. При упоре поз.5, прижатом к основанию, фиксатор поз.2 должен перемещаться от усилия руки и возвращаться в исходное положение под действием пружин поз.7.
Допускается припиловка зуба фиксатора.
4. Заход зуба фиксатора под загиб основания должен происходить от нажатия рукой на рычаг.
Допускается припиловка радиусной части фиксатора.
5. Торцы резьбовой части винтов поз.9 припилить заподлицо с плоскостью упора и кернить в трех точках каждый.
6. Трущиеся поверхности смазать смазкой МС-70 ГОСТ9762-76.
7. Маркировать Ш,Ч на бирке.
8. Клеймить К по АК-630, АК-630М ТУ. I.

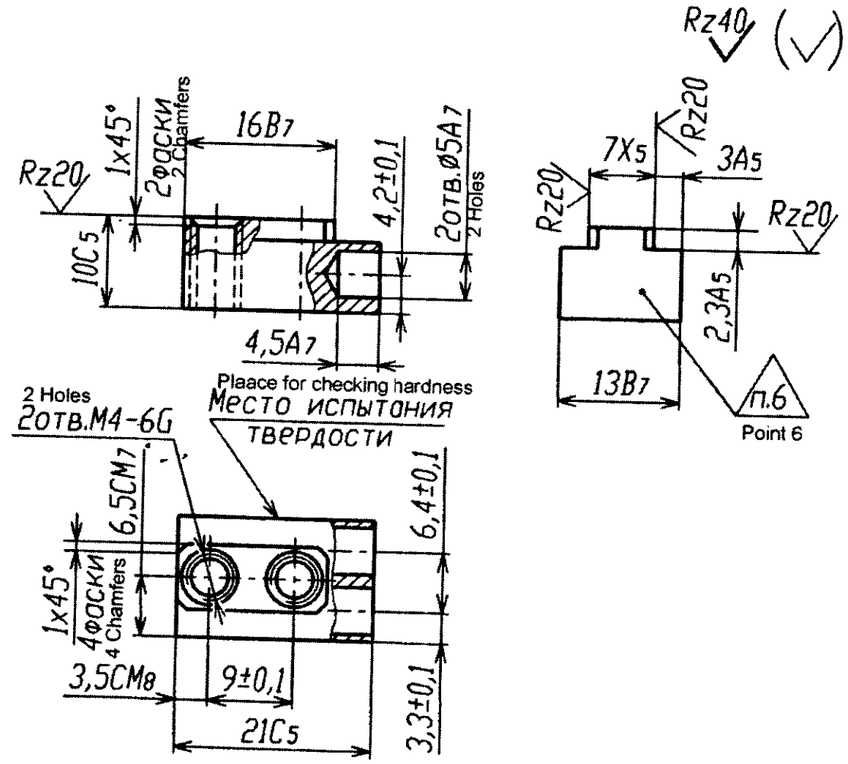
АК-630 Сб103-3СБ

Изм.	Лист	N докум.	Подп.	Дата	Lock Замок	Лит.	Масса	Масштаб
Разраб.						А	0,450	2:1
Пров.					Сборочный чертеж Assy. drg.	Лист	Листов 1	
Т.контр.								
Н.контр.								
Утв.								

Перв. примен.
Справ.N
Подп. и дата
Инв.N дубл.
Взам.инв.N
Подп. и дата
Инв.N подл.

Blank No. 406

AK-630 103-21



1. 38.5...44.5 HRC_E.
2. Inner angles R ≈ 0.4 mm.
3. Blunt sharp edges ≈ 0.4 mm.
4. Coating Cd 6.phos.Oil. It is permissible to avoid cadmium plating of holes.
5. Mark Ш, Ч and stamp K on tag.
6. Stamp И as per AK-630, AK-630M TU I.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design chief				
Head of Q.C.D				
Approved by				

AK-630 103-21

Stop

Type	Weight	Scale
A	0.015	2:1

Sheet | Sheets 1

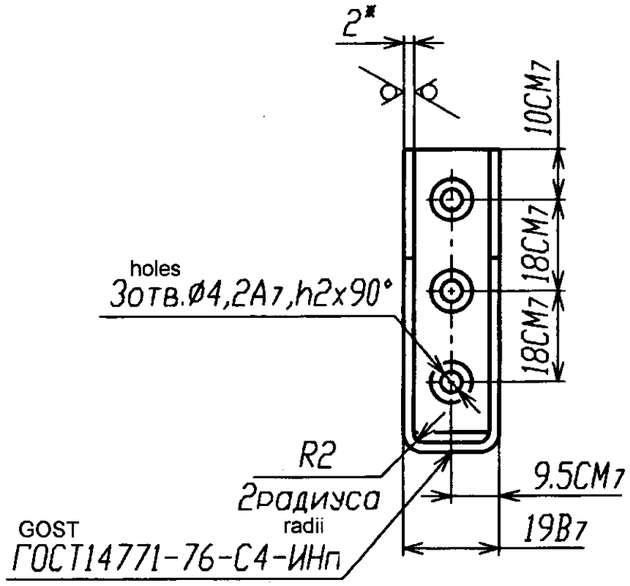
Steel 50
GOST 1050-88

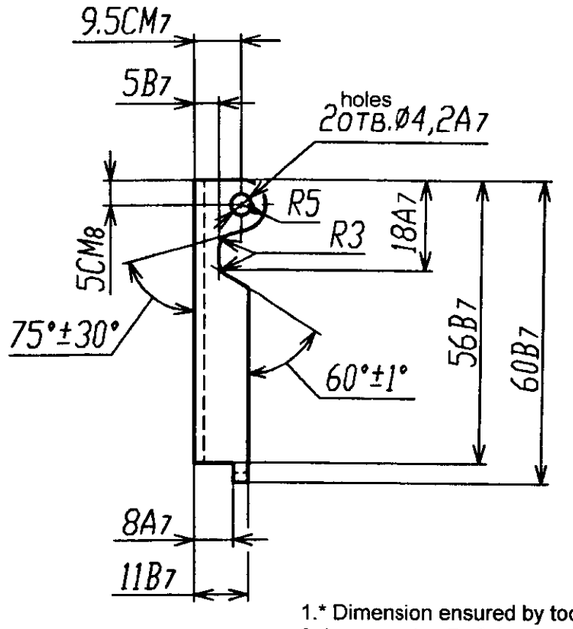
Approved KTONI | Approved by shop | First use | Reference No. | Sign and Date | Dupl. Inv. No.
Approved TOsb | Alternate Inv. No | Sign and Date
Approved OGMet | Orig. Inv. No.

Copied by

Format A4

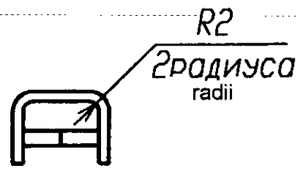
AK-630 103-22





Rz80 (✓)

1.* Dimension ensured by tool.
2. Inner angles R~0.4 mm.
3.Blunt sharp edges ~0.4 mm.
4. Coating Anodic Oxidation Cr.
5. Mark Ш,Ч and stamp К as per AK-630, AK-630M TU I.

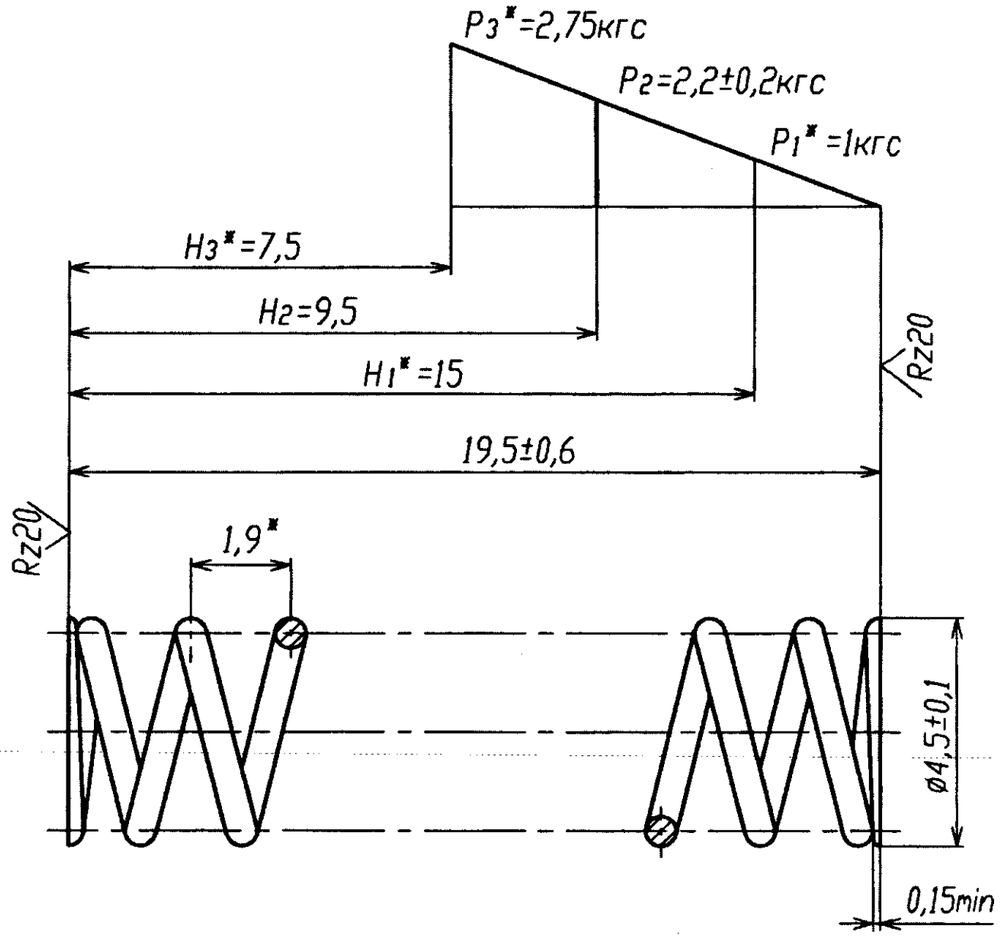


					AK-630 103-22
Amend.	Sheet	Doc.No.	Sign	Date	Base plate
Developed by					Type: A; Weight: 0.046; Scale: 1:1
Checked by					Sheet; Sheets 1
Head of Q.C.D					$Sheet\frac{BT-PN-02GOST19904-90}{K490V4-III-40GOST16523-97}$
Approved by					

First use | Reference No. | Duplicate Inv. No | Sign and Date | Orig. inv. no.

Comment:

AK-630 103-23



1.* Dimensions and parameters for reference.
2. Group III.
3. G* = 8000 khf/mm^2 ; τ_3^* = 150 kgf/mm^2.
4. Length of uncoiled spring L*= 160 mm.
5. Coiling direction- right.
6. n = 10.
7 n_1 = 12 ± 0.5.
8. Heat treatment- tempering 240^0-260^{0}C.
9. $D_G = 5A_5$.
10. D_S
11. Pre deformation time (at N_Z) 24 hours.
12. Coating Chem.phos.accel. Lacquer BF-4 with Nigrozene two coats, made as per OST3-4123-78, IV, OMG.
13. Other technical requirements as per GOST 16118-70.
14. Mark Ш,Ч and stamp К on tag.

Comment:

Amend.	Sheet	Doc.No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

AK-630 103-23

Spring

Type	Weight	Scale
A	0.0003	10:1
Sheet	Sheets 1	

Wire V-1-0.6
GOST 9389-75

First use | Reference No. | Sign and Date | Duplicate Inv. No | Alternate Inv. No | Sign and Date | Orig. inv. no.

First use	Reference No.	Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
						Documents		
		A4			AK-630 Sb 103-6 SB	Assembly drawing		
						Components		
		A3		1	AK-630 103-17	Lever	1	
		A4		2	AK-630 103-18	Clevis	1	

Sign and Date	Dupl. Inv. No.	Alternate inv. No	Orig. Inv. No.	Amend.	Sheet	Doc. No.	Sign	Date
				Developed by				
				Checked by				
				Head of Q.C.D				
				Approved by				

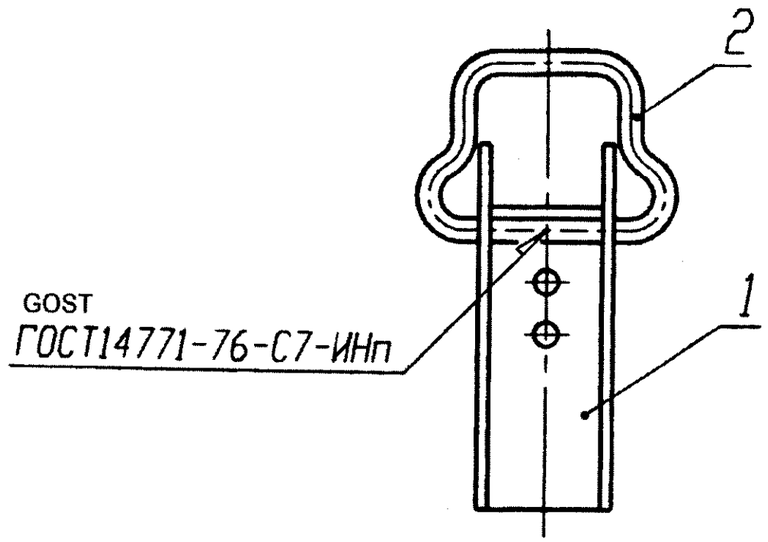
AK-630 Sb 103-6

Lever with clevis

Type	Sheet	Sheets
A		1

Blank No. 406

AK-630 Sb103-6SB



1. Argon arc welding by using filler wire 2 Sv.-08A GOST 2246-70. Gas welding with wire 2Sv-08A GOST 2246-70 is permissible.
2. Coating Cd12.Phos.Oil.
3.Mark Ш, Ч and stamp К on tag.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design chief				
Head of Q.C.D				
Approved by				

AK-630 Sb103-6SB

Lever with clevis
Assembly drawing

Type	Weight	Scale
A	0.040	1:1

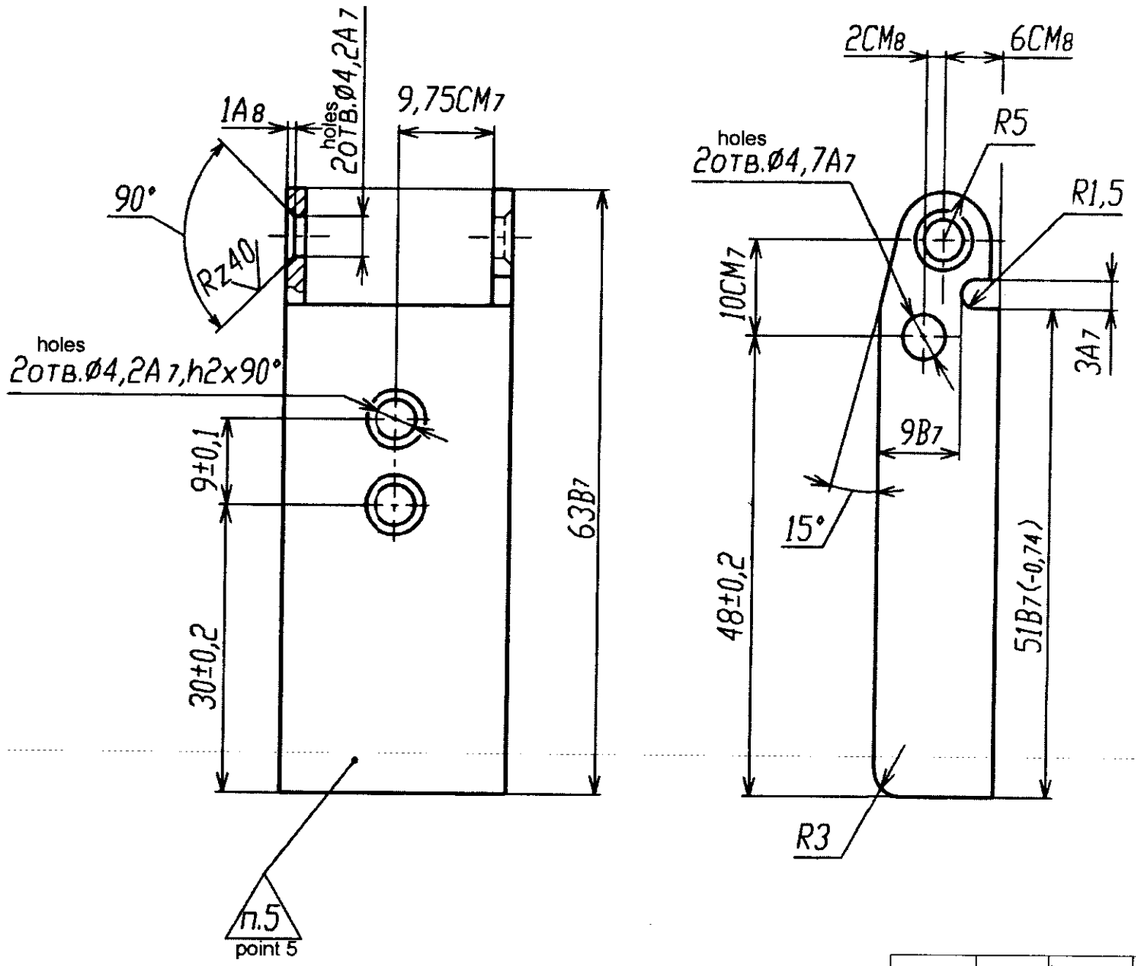
Sheet | Sheets 1

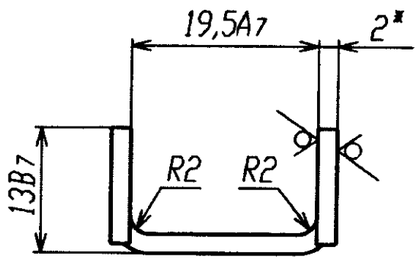
Approved by shop | First use
Reference No.
Approved KTONI
Sign and Date
Approved TOsb
Dupl. Inv. No.
Alternate Inv. No
Sign and Date
Approved OGMet
Orig. Inv. No.

Copied by

Format A4

AK-630 103-17





Rz80 (✓)

1.* Reference dimensions.
2. Inner angles R~0.4 mm.
3. Blunt sharp edges ~0.4 mm.
4. Mark Ш,Ч as per AK-630, AK-630M TU I on tag.
5. Stamp K as per AK-630, AK-630M TU I.

Comment:

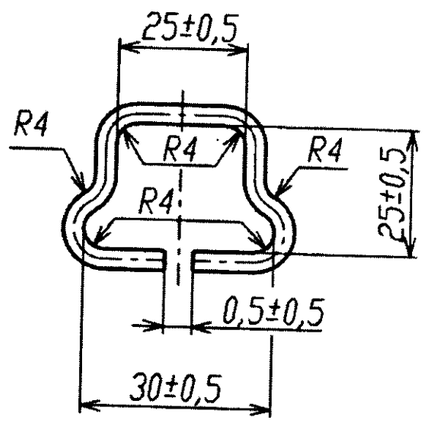
					AK-630 103-17
Amend.	Sheet	Doc.No.	Sign	Date	
Developed by					Lever
Checked by					
Head of Q.C.D					
Approved by					$Sheet \frac{BT-PN-02GOST19904-90}{K490V4-III-40GOST16523-97}$

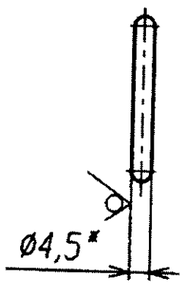
Type	Weight	Scale
A	0.030	2:1
Sheet	Sheets 1	

First use | Reference No. | Duplicate Inv. No | Sign and Date | Alternate Inv. No | Sign and Date | Orig. inv. no.

Blank No. 406

AK-630 103-18





Rz80 (✓)

1. Substitute materials: Round bar $\frac{4-5\,GOST\,7417-75}{35-N-V\,GOST\,1051-73}$

2..* Reference dimension
3.Blunt sharp edges ≈ 0.4 mm.
4.Mark Ш, Ч and stamp К on tag.

Approved by shop	First use
Reference No.	
Approved KTONI	
Sign and Date	
Dupl. Inv. No.	
Approved TOsb	
Alternate Inv. No	
Sign and Date	
Approved OGMet	
Orig. Inv. No.	

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design chief				
Head of Q.C.D				
Approved by				

AK-630 103-18

Clevis

Type	Weight	Scale
A	0.006	1:1

Sheet | Sheets 1

Wire 4.5-35
GOST 5663-79

Copied by

Format A4

First use	Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
					Documents		
	A4			AK-630 Sb 103-7 SB	Assembly drawing		
Reference No.							
					Components		
	A4		1	AK-630 103-19	Retainer	1	
	A3		2	AK-630 103-20	Base plate	1	

Sign and Date | Dupl. Inv. No. | Alternate Inv. No | Sign and Date | Orig. Inv. No.

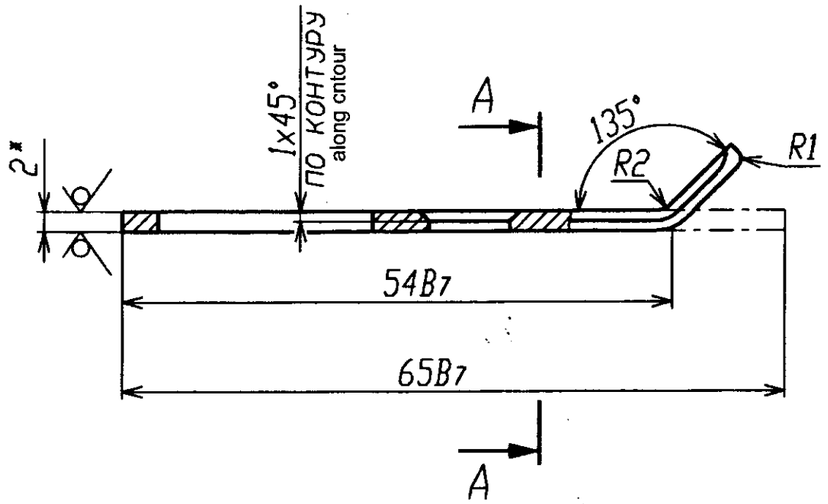
Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

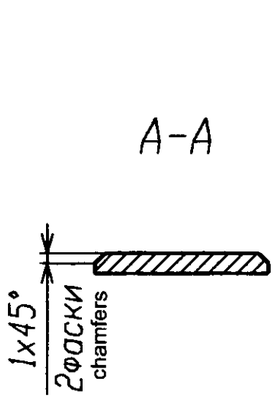
AK-630 Sb 103-7

Retainer

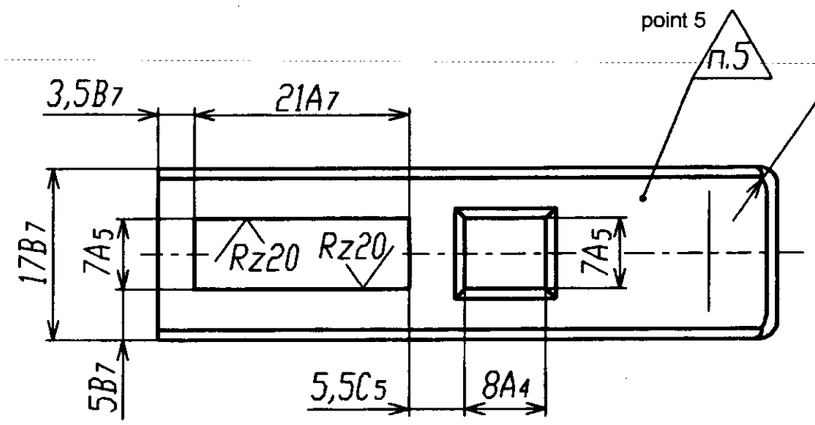
Type	Sheet	Sheets
A		1

AK-630 103-20





Rz40 (✓)



1.* Reference dimensions.
2. Inner angles R~0.4 mm.
3. Blunt sharp edges ~0.4 mm.
4. Mark Ш,Ч on tag.
5.Stamp K as per AK-630, AK-630M TU I.

Comment:

Amend.	Sheet	Doc.No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

AK-630 103-20

Base plate

Type	Weight	Scale
A	0.018	2:1

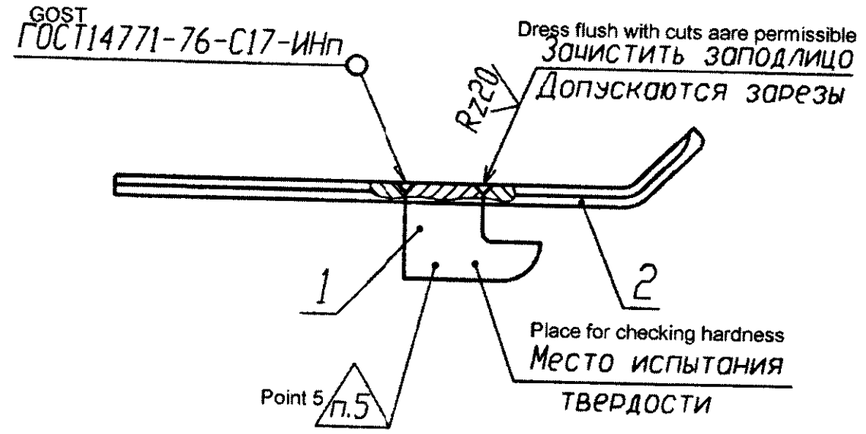
Sheet Sheets 1

Sheet $\frac{BT-PN-02GOST19904-90}{K490V4-III-40GOST16523-97}$

First use | Reference No. | Duplicate Inv. No | Alternate Inv. No | Sign and Date | Orig. inv. no. | Sign and Date

Blank No. 406

AK-630 Sb103-7SB



1. Argon-arc Welding by using filler wire 2 Sv-08A GOST 2246-70.
2. 34…39.5 HRC_E.
3. Coating Cd 12.HRC_E.
4. Mark Ш, Ч and stamp К on tag.
5. Stamp И as per AK-630, AK-630M TU I.

Approved by shop | First use | Reference No. | Approved KTONI | Sign and Date | Approved TOsb | Dupl. Inv. No. | Alternate Inv. No | Sign and Date | Approved OGMet | Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design chief				
Head of Q.C.D				
Approved by				

AK-630 Sb103-7SB

Retainer
Assembly drawing

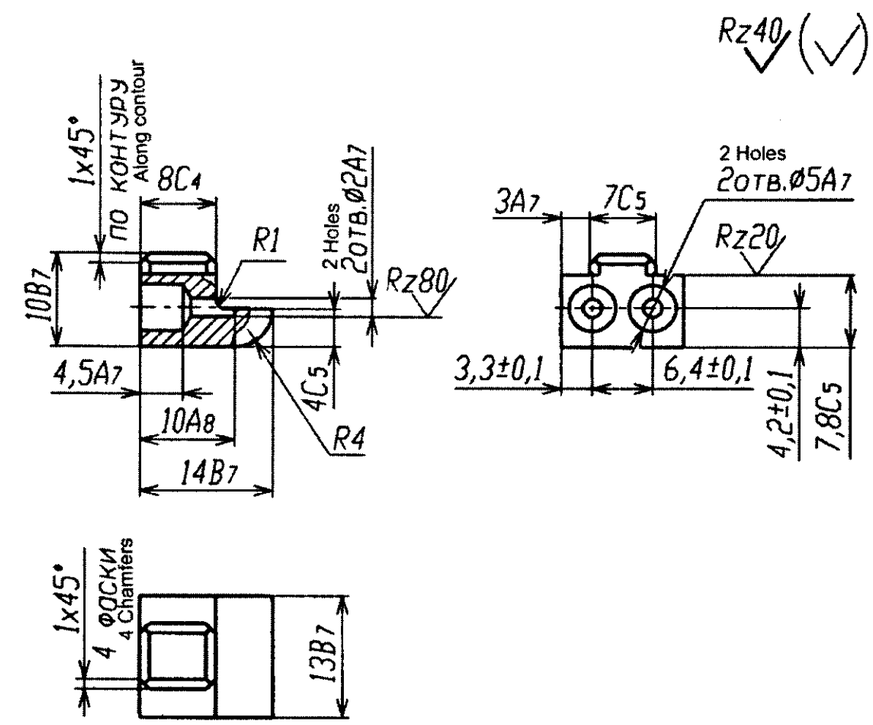
Type	Weight	Scale
A	0.027	2:1

Sheet | Sheets 1

Copied by | Format A4

Blank No. 406

AK-630 103-19



1.Inner angles R ≈ 0.4 mm.
2.Blunt sharp edges ≈ 0.4 mm.
3.Mark Ш, Ч and stamp К on tag.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design chief				
Head of Q.C.D				
Approved by				

AK-630 103-19

Retainer	Type	Weight	Scale
	A	0.009	2:1
	Sheet	Sheets 1	

Steel 50
GOST 1050-88

Approved KTONI
Approved by shop
Approved TOsb
Approved OGMet
First use
Reference No.
Sign and Date
Dupl. Inv. No.
Alternate Inv. No
Orig. Inv. No.

Copied by

Format A4

Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
				Documents		
A4			AK-630 sb 103-4 SB	Assembly drawing		
				Assembly units		
A4		1	AK-630 sb 103-8	Lower gasket	1	
				Components		
A4		4	AK-630 103-24	Lower gasket	1	

First use | Reference No. | Sign and Date | Dupl. Inv. No. | Alternate Inv. No | Sign and Date | Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

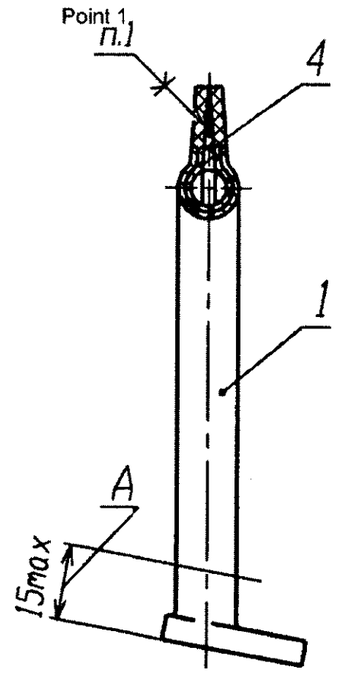
AK-630M sb 103-4

Lower packing

Type	Sheet	Sheets
A		1

Blank No. 406

AK-630 Sb103-4SB



1. Seal lower gasket pos.4 with adhesive 88-NP TU 38.105.540-85 in upper gasket pos.1, except two zones A.
2. It is permissible to use adhesive 88CA TU 38.105.1760-89.
3. Mark Ш, Ч and stamp К on tag.

Approved KTONI | Approved by shop | First use

Approved TOsb | Alternate Inv. No | Dupl. Inv. No.

Approved OGMet | Orig. Inv. No. | Sign and Date

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design chief				
Head of Q.C.D				
Approved by				

AK-630 Sb103-4SB

Lower packing Assembly drawing

Type	Weight	Scale
A	0.075	1:1

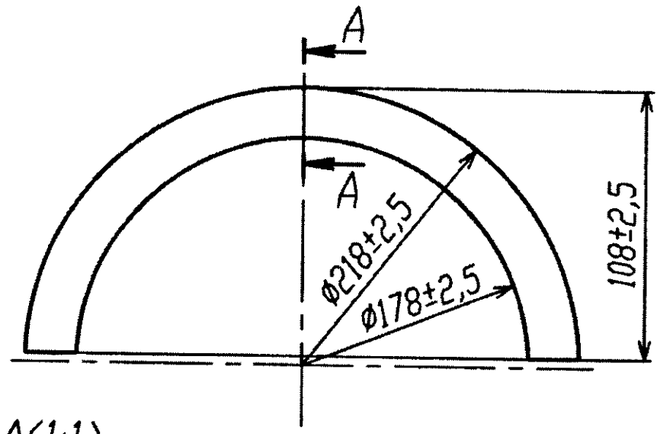
Sheet | Sheets 1

Copied by

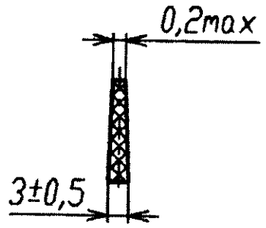
Format A4

Blank No. 406

AK-630 103-24



A-A(1:1)



1.Dimensions ensured by tool.
2. Permissible deviation for requirements of external appearance as per III group, table 6 TU 38.105 1959-90.
3. Surface finish of moulding surfaces of press mould $^{0.32}\sqrt{}$
4.Mark Ш, Ч and stamp К on batch tag.

Approved by shop | First use
Reference No.
Approved KTONI | Sign and Date
Dupl. Inv. No.
Approved TOsb | Alternate Inv. No
Sign and Date
Approved OGMet | Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design chief				
Head of Q.C.D				
Approved by				

AK-630 103-24

Lower gasket

Type	Weight	Scale
A	0.018	1:2

Sheet | Sheets 1

Rubber stock V-14NTA TU 38.0051166-98

Copied by

Format A4

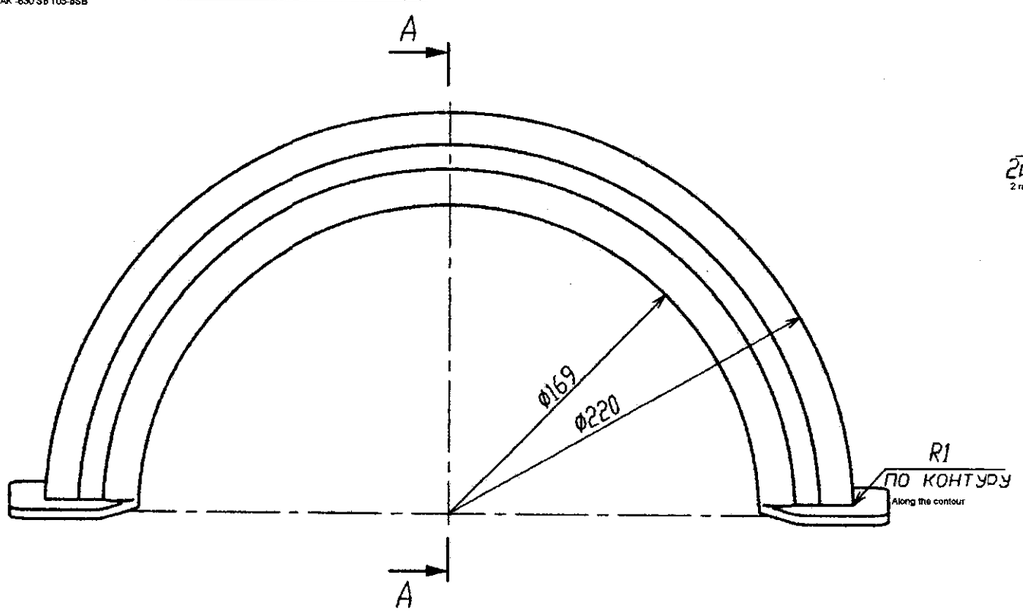
First use	Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
					Documents		
	*)			AK-630 Sb 103-8 SB	Assembly drawing		*) A4 x 3
					Materials		
			1		Rubber stock V-14 NTA	40	gm.
					TU 38 0051166-98		
			2		Avizent A GOST 2306-93	10	gm.
					50 ± 2 x 300 ± 2		

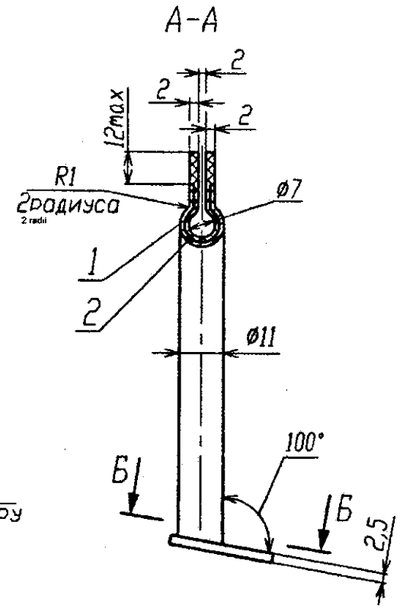
Amend.	Sheet	Doc. No.	Sign	Date	AK-630 Sb 103-8			
Developed by					Lower gasket	Type	Sheet	Sheets
Checked by						A		1
Head of Q.C.D								
Approved by								

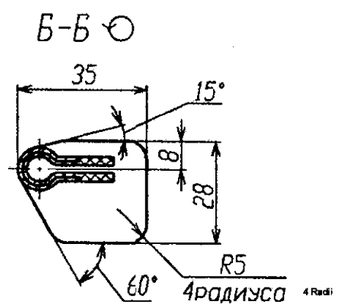
Reference No. | Orig. Inv. No. | Sign and Date | Alternate Inv. No | Dupl. Inv. No. | Sign and Date

АК-630 Сб103-8СБ

AK-630 Sb 103-8SB







1. Blank of avizent should be cut along the diagonal to interweaving thread.
2. Damages of avizent are not permitted, external view is as per test specimen.
3. Dimensions without tolerances as per 7 class of accuracy, are to be ensured by tool.
4. Roughness of mold-shaped surfaces of press mold is 0.32.
5. Mark Ш, Ч and stamp К on the tag.

1. Заготовка авизента должна быть вырезана по диагонали к нитям переплетения.
2. Повреждения авизента не допускаются, внешний вид по контрольному образцу.
3. Размеры без допусков по 7 классу точности, обеспечиваются инструментом.
4. Шероховатость формообразующих поверхностей прессформы $\sqrt{0,32}$.
5. Маркировать Ш,Ч и клеймить К на бирке.

АК-630 М Sb 103-8 SB

АК-630 Сб103-8СБ

Прокладка нижняя

Сборочный чертеж

Lower Gasket
Assembly drawing

Изм.	Лист	N докум.	Подп.	Дата
Разраб.				
Пров.				
Т.контр.				
Н.контр.				
Утв.				

Type	Mass	Scale
Лит.	Масса	Масштаб
А	0,050	1:1
Лист	Листов 1	
Sheet	Total Sheets	

Формат А4х3

Перв. примен.
Справ.N
Подп. и дата
Инв.N дубл.
Взам. инв.N
Инв.N подл.
Подп. и дата

First use	Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
					Documents		
	A4			AK-630 Sb 103-5 SB	Assembly drawing		
Reference No.							
					Assembly units		
	A4		1	AK-630 Sb 103-9	Upper packing	1	
					Components		
	A4		4	AK-630 103-25	Upper packing	1	

Sign and Date	Dupl. Inv. No.	Alternate Inv. No	Sign and Date	Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

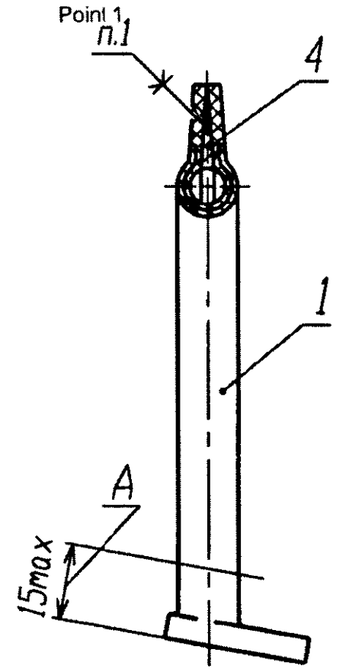
AK-630 Sb 103-5

Upper packing

Type	Sheet	Sheets
A		1

Blank No. 406

AK-630 Sb103-5SB



1. Seal upper gasket pos.4 with adhesive 88-NP TU 38.105.540-85 in upper gasket pos.1,
   except two zones A.
2. It is permissible to use adhesive 88CA TU 38.105.1760-89.
3. Mark Ш, Ч and stamp K on tag.

Approved KTONI | Approved by shop | First use | Reference No. | Sign and Date | No. | Dupl. Inv. No. | Approved TOsb | Alternate Inv. No | Sign and Date | Approved OGMet | Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design chief				
Head of Q.C.D				
Approved by				

AK-630 Sb103-5SB

Upper packing
Assembly drawing

Type	Weight	Scale
A	0.075	1:1

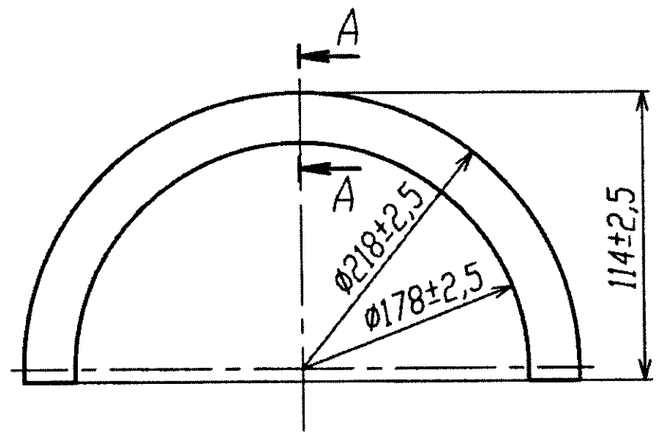
Sheet | Sheets 1

Copied by

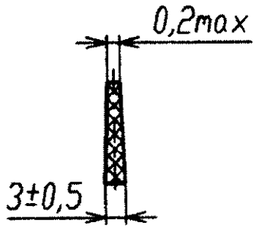
Format A4

Blank No. 406

AK-630 103-25



A-A(1:1)



1.Dimensions ensured by tool.
2. Permissible deviation for requirements of external appearance as per III group, table 6 TU 38.105 1959-90.
3. Surface finish of moulding surfaces of press mould $^{0.32}\sqrt{}$
4.Mark Ш, Ч and stamp К on batch tag.

Approved by shop | First use
Reference No.
Approved KTONI
Sign and Date
Dupl. Inv. No.
Approved TOsb
Alternate Inv. No
Sign and Date
Approved OGMet
Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design chief				
Head of Q.C.D				
Approved by				

Copied by

AK-630 103-25

Upper gasket

Type	Weight	Scale
A	0.018	1:2

Sheet | Sheets 1

Rubber stock V-14NTA
TU 38.0051166-98

Format A4

First use	Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
					Documents		
	*)			AK-630 Sb 103-9 SB	Assembly drawing		*) A4 x 3
Reference No.							
					Materials		
			1		Rubber stock V-14 NTA	40	gm.
					TU 38 0051166-98		
			2		Avizent A GOST 2306-93	10	gm.
					50 ± 2 x 300 ± 2		

Sign and Date | Dupl. Inv. No. | Alternate Inv. No | Sign and Date | Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

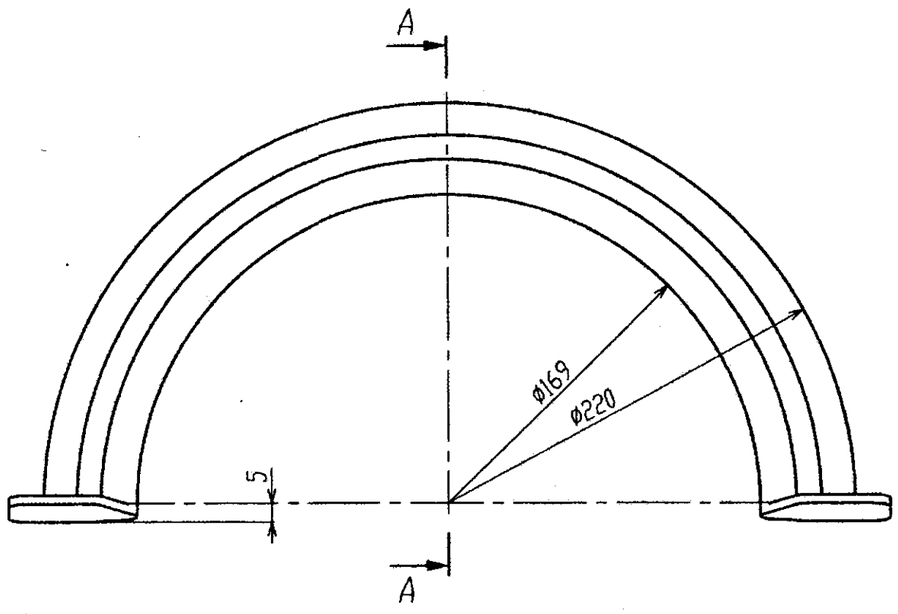
AK-630 Sb 103-9

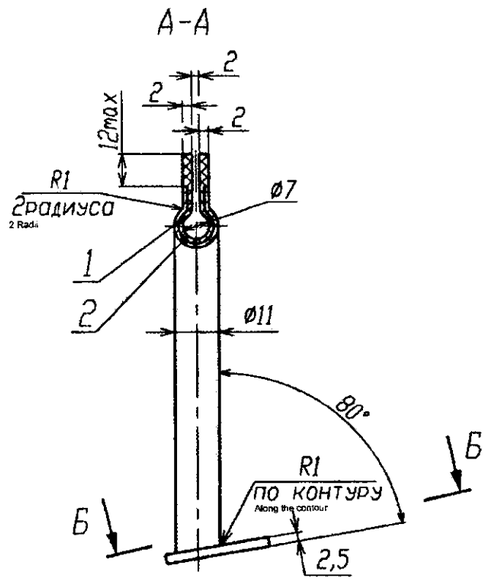
Upper gasket

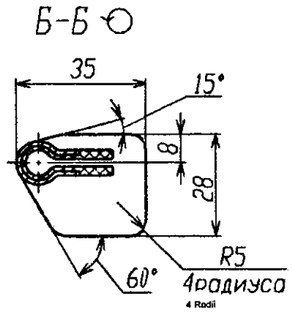
Type	Sheet	Sheets
A		1

АК-630 Сб103-9СБ

АК-630 Sb103 - 9 SB







1. Blank of avizent should be cut along the diagonal to interweaving thread.
2. Damages of avizent are not permitted, external view is as per test specimen.
3. Dimensions without tolerances as per 7 class of accuracy, are to be ensured by tool.
4. Roughness of mold-shaped surfaces of press mold is 0.32.
5. Mark Ш, Ч and stamp К on the tag.

1. Заготовка авизента должна быть вырезана по диагонали к нитям переплетения.
2. Повреждения авизента не допускаются, внешний вид по контрольному образцу.
3. Размеры без допусков по 7 классу точности, обеспечиваются инструментом.
4. Шероховатость формообразующих поверхностей прессформы 0,32.
5. Маркировать Ш,Ч и клеймить К на бирке.

AK-630 Sb103 - 9 SB

					АК-630 Сб103-9СБ		
Изм.	Лист	N докум.	Подп.	Дата		Type	Mass	Scale
Разраб.					Прокладка верхняя	Лит.	Масса	Масштаб
Пров.						А	0,050	1:1
Т.контр.						Лист	Листов 1
Н.контр.					Upper gasket Assembly drawing	Sheet	Total Sheets
Утв.							

Формат А4х3

Перв. примен.
Справ.N
Подп. и дата
Инв.N дубл.
Взам. инв.N
Подп. и дата
Инв.N подл.