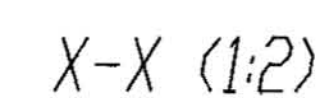
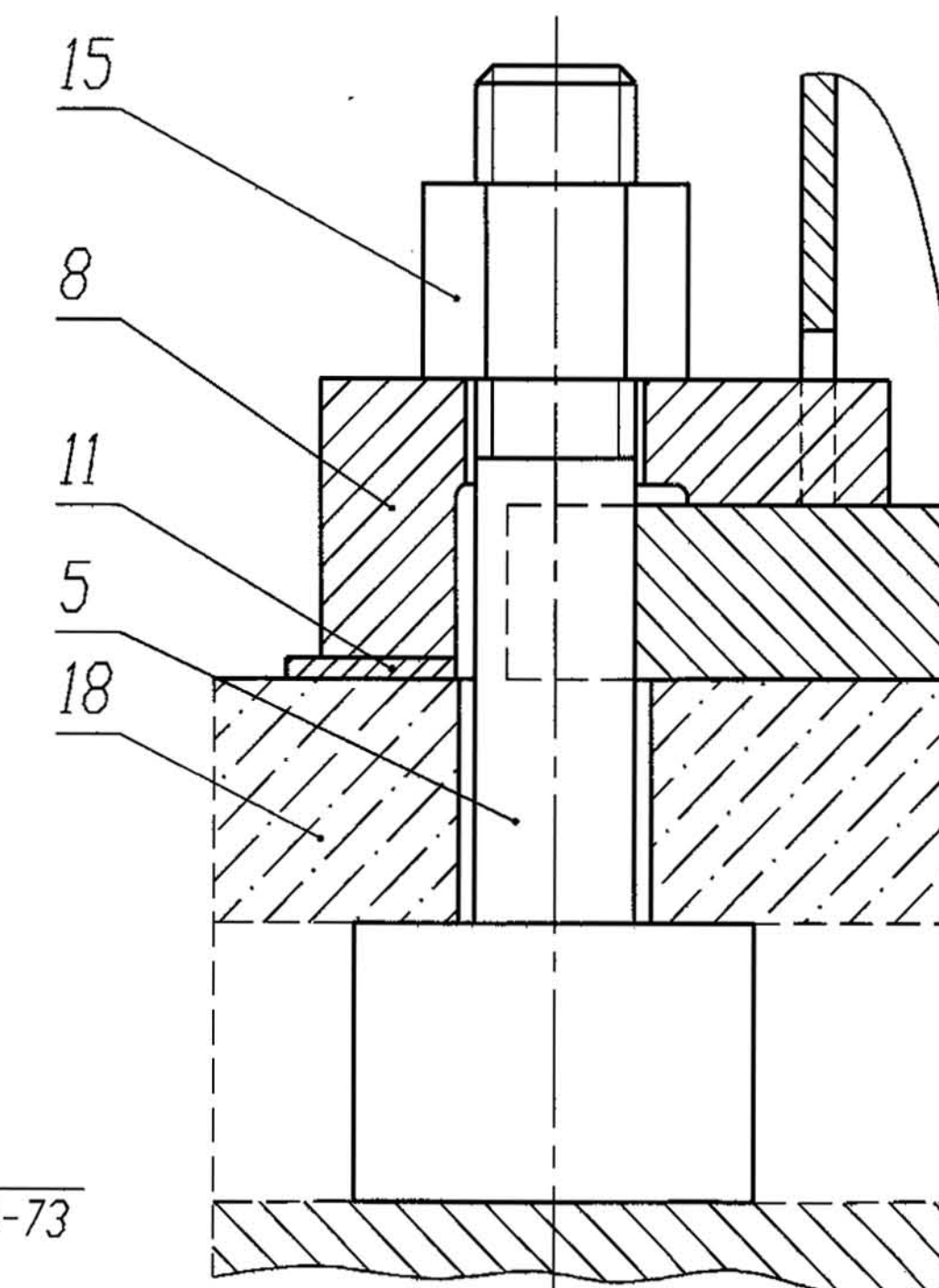
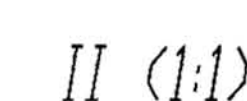
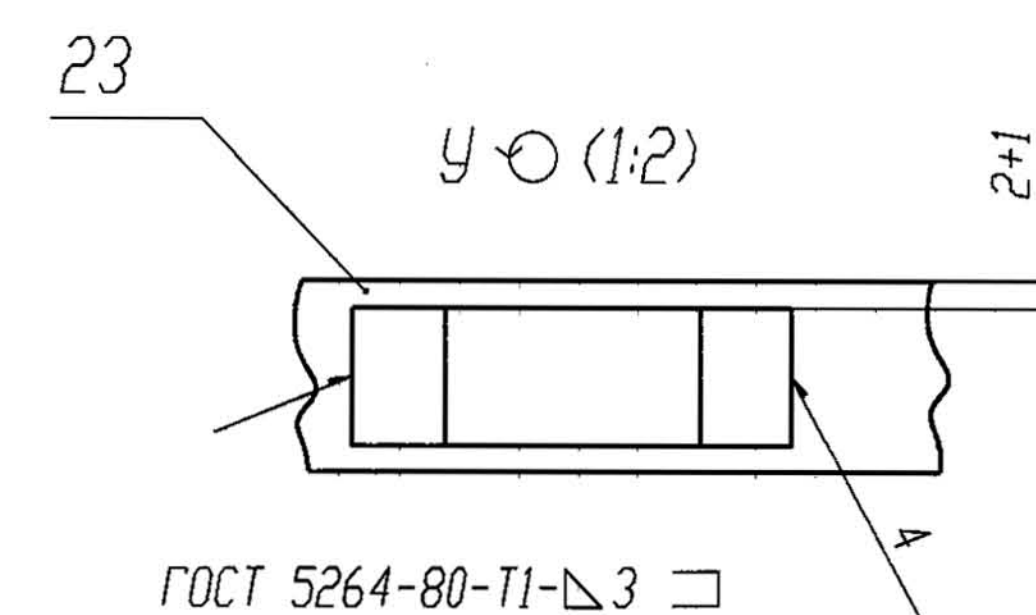
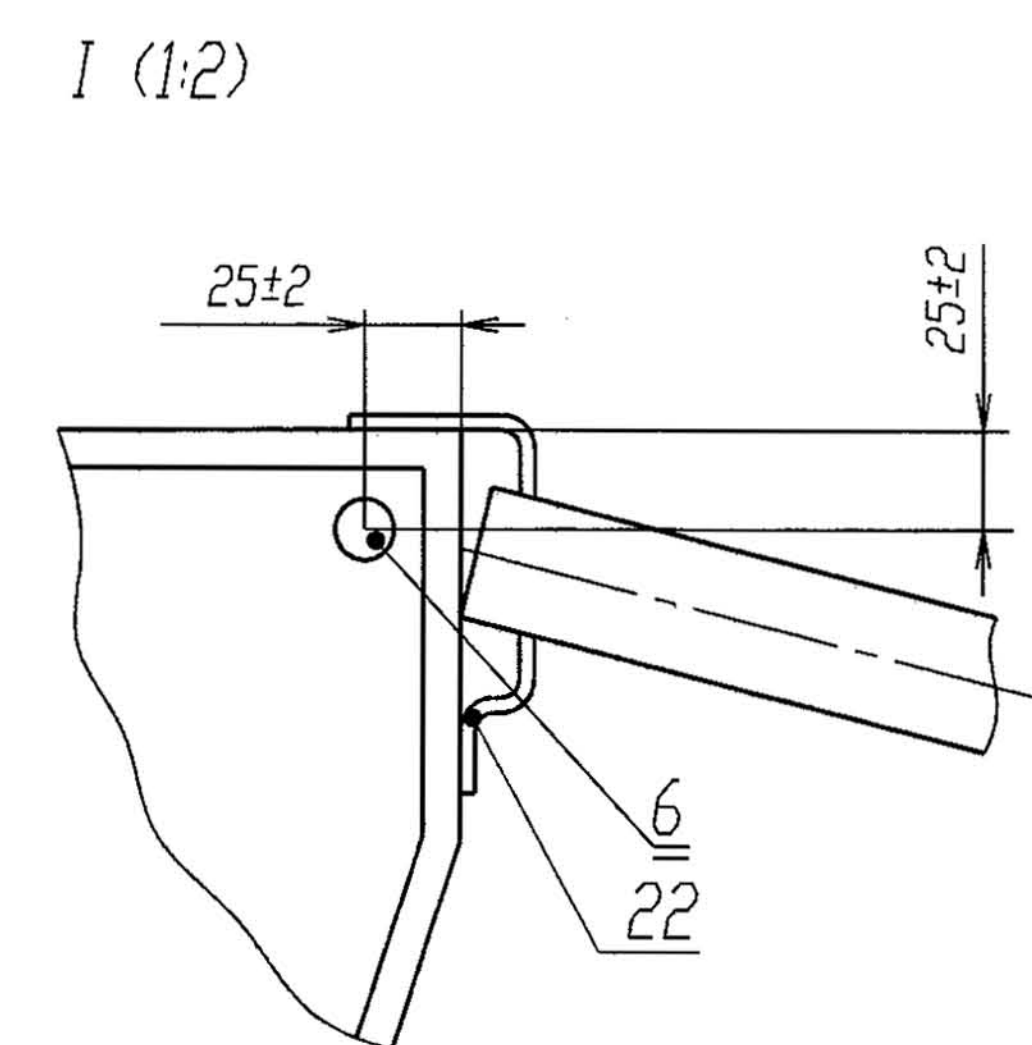
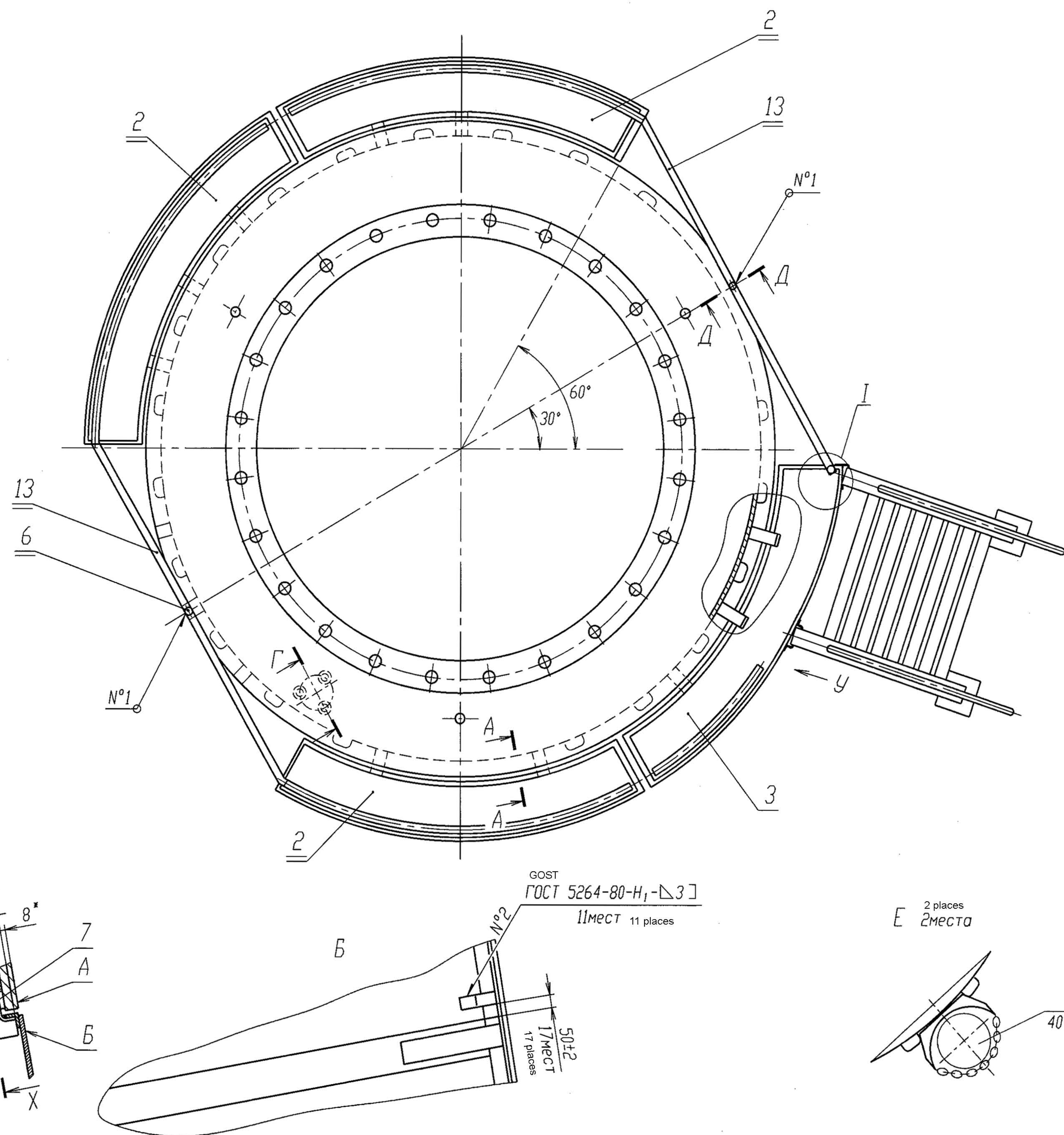


First use	Format	Zone	Position	Designation		Nomenclature		Qty.	Remarks
						<u>Documents</u>			
Reference No.	A1			AK-630 ST Sb133 SB		Assembly drawing			
	A4			AK-630 ST Sb133 PS		Certificate			
						<u>Assembly units</u>			
	A4		1	AK-630 ST Sb133-2		Stand		1	
	A4		2	AK-630 ST Sb133-3		Platform		3	
	A4		3	AK-630 ST Sb133-4		Platform		1	
	A4		4	AK-630 ST Sb133-5		Stair		1	
	A4		5	AK-630 ST Sb133-8		Assembled bolt		24	*
	A4		6	AK-630 ST Sb133-9		Jack		3	
	A4			AK-630 ST Sb133-10		Wrench		1	
					<u>Components</u>				
Sign and Date	A4		6	AK-630 ST 133-15		Pipe		3	
	A3		7	AK-630 ST 133-31		Rib		11	
	A3		8	AK-630 ST 133-51		Lug		24	*
	A3		11	AK-630 ST 133-53		Gasket		24	* by selection
Dupl. Inv. No.	A3			AK-630 ST 133-54		Gasket		24	* by selection
	A3			AK-630 ST 133-55		Gasket		24	* by selection
	A3			AK-630 ST 133-56		Gasket		24	* by selection
	A4		12	AK-630 102-48		Collar pin		3	
Alternate Inv. No.	A4		13	AK-630 ST 133-64		Pipe		2	
Sign and Date						AK-630 ST Sb133			
	Amend.	Sheet	Doc. No.	Sign	Date				
	Developed by								
Orig. Inv. No.	Checked by					Assembled stand	Type	Sheet	Sheets
							A	1	2
	Head of Q.C.D								
	Approved by								

Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
A2		18	AK-630ST 133-89	Bed plate	1	*
WD		20	AK-630ST 133-95	Rib	16	
				Sheet		
				B-PN-0-3.9 GOST 19903-74/K390B-		
				4-III 25 GOST 16523-97		
				B x H = 80 x 28 mm		
WD		21	AK-630ST 133-96	Lining	11	
				Steel 25 GOST 1050-88		
				L x B x H = 95x50x40 mm		
A4		22	AK-630ST 133-97	Clamp	1	
A4		23	AK-630ST 133-97-01	Clamp	1	
				<u>Standard articles</u>		
		14		Nut M14-6G.10.40Kh.029	3	31-40.5HRC
				GOST 5918-73		
		15		Nut M24-6G.10.40Kh.029	24	31-40.5HRC
				GOST 5931-70		
		16		Washer A14.25.029	3	
				GOST 11371-78		
		17		Cotter pin 3.2x32.029	3	
				GOST 397-79		
			* Supplied by			
			separate order			
Orig. Inv. No.					AK-630 ST Sb133	
	Amend.	Sheet	Doc. No.	Sign	Date	Sheet
						2

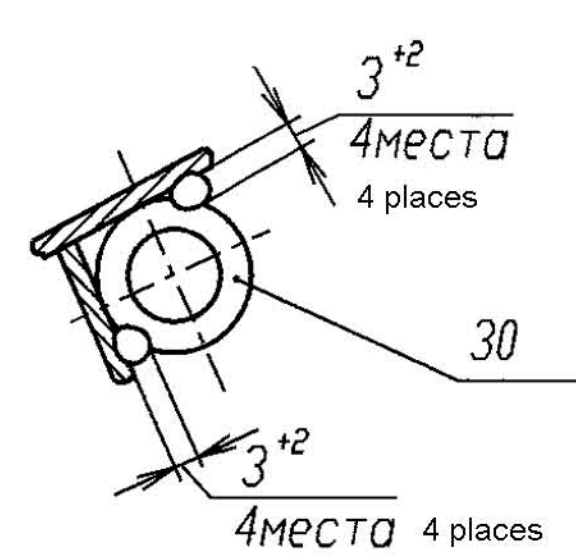
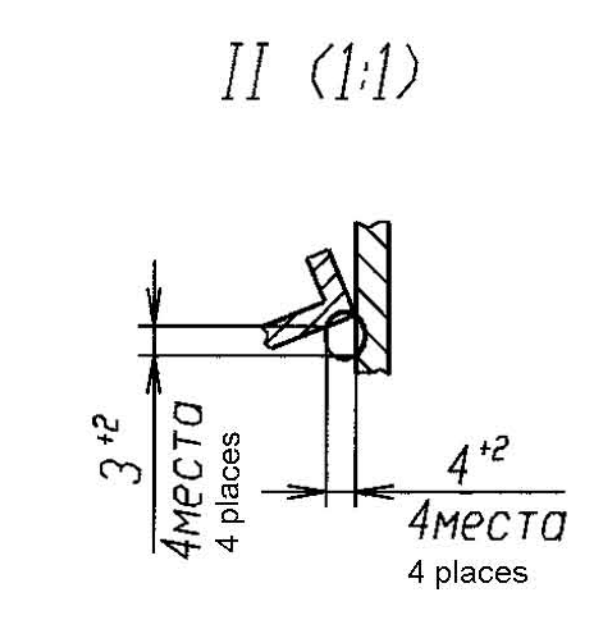
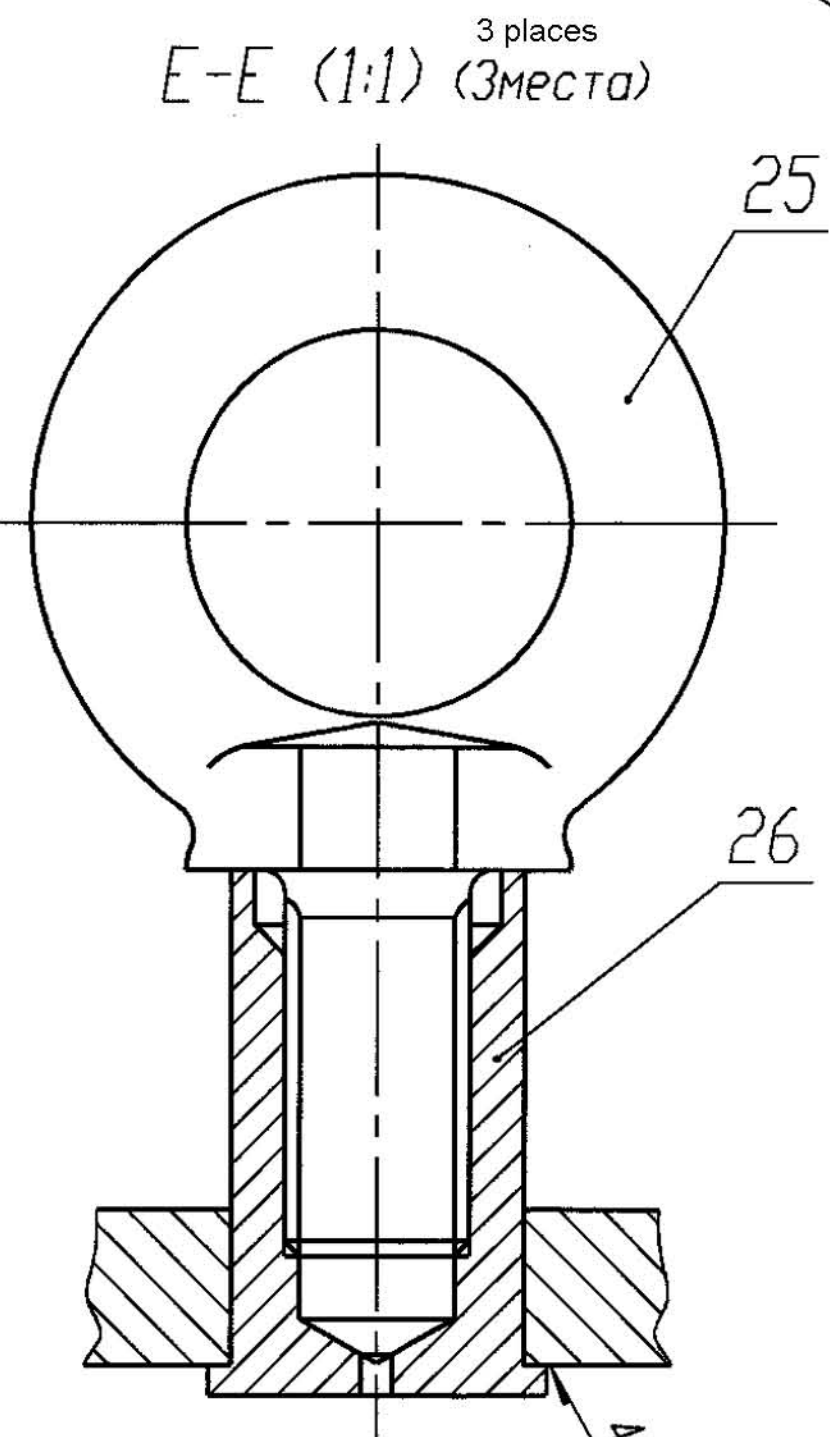
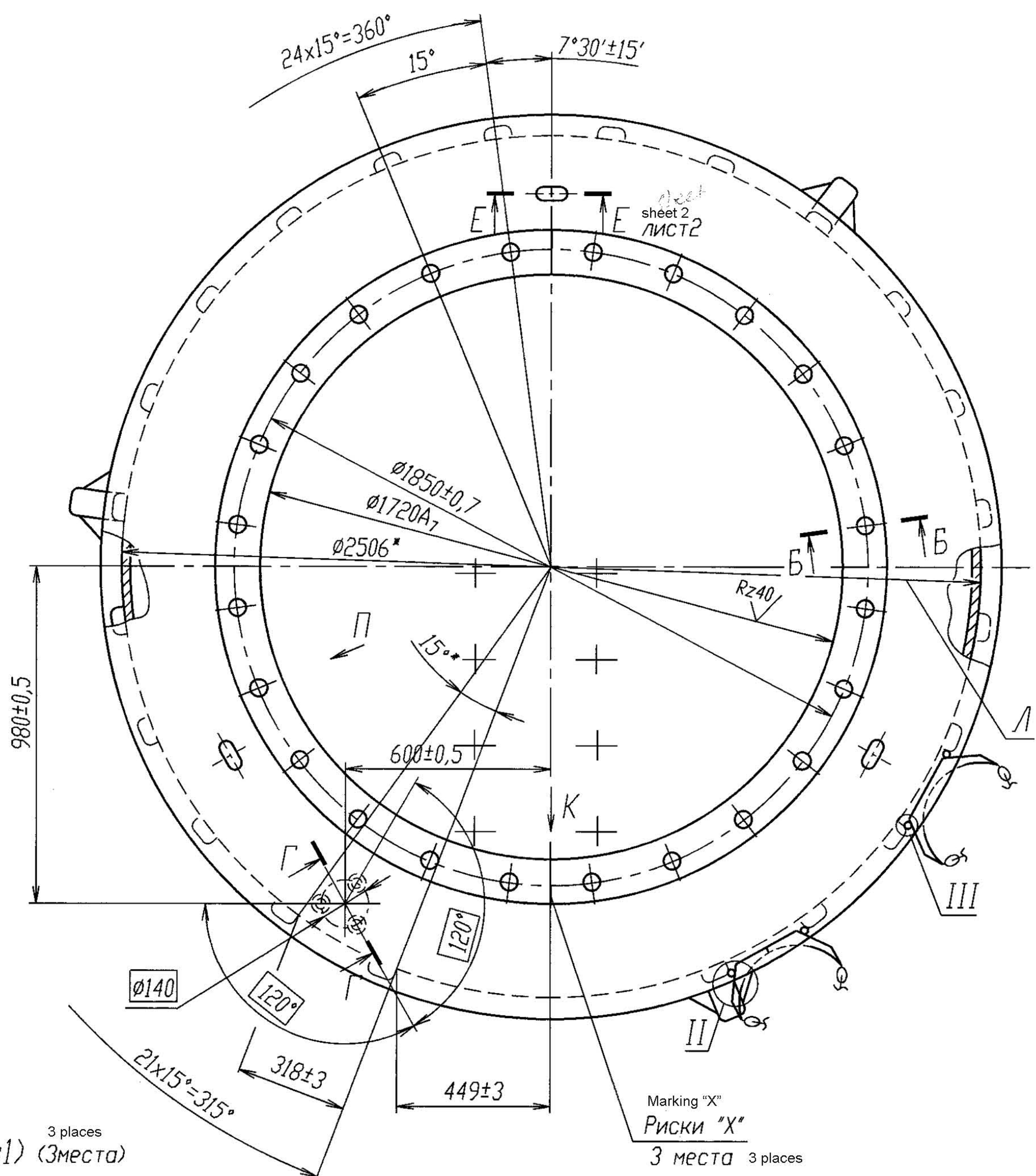
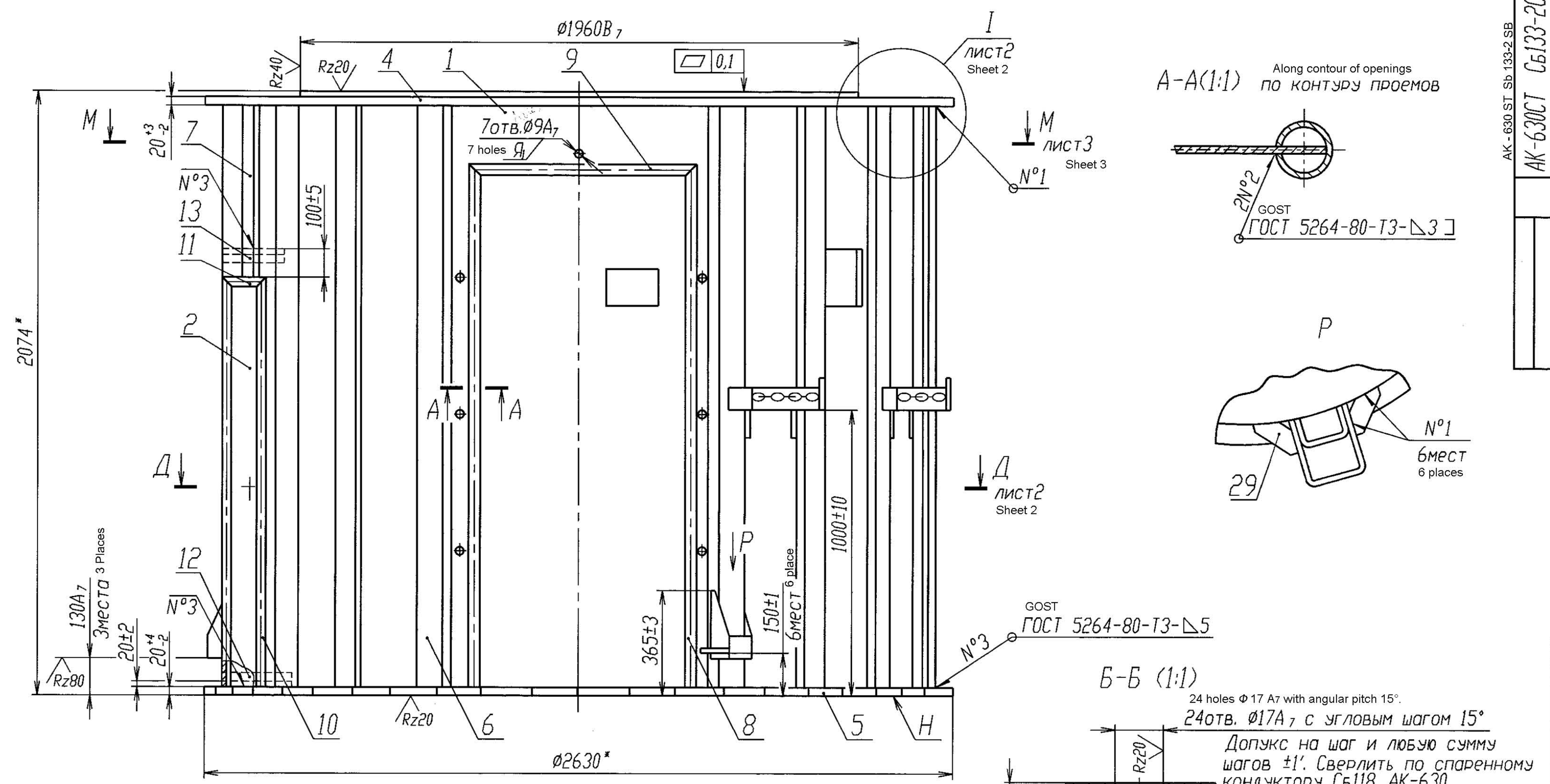


-
- Technical drawing of a mechanical part, likely a bracket or support, showing two views: a side view (left) and a top view (right).
- The side view (left) shows a rectangular base with a hatched section, a curved top surface with radius $R200$, and a vertical flange with a $4 \times 45^\circ$ chamfer. The drawing is labeled with $GOST\ 5460-80-C8$ and a square symbol.
- The top view (right) shows a rectangular base with a hatched section, a curved top surface with radius $R200$, and a vertical flange with a 5×1 chamfer. The drawing is labeled with $GOST\ 5264-80-11$ and a triangle symbol.



1. Сварка электродуговая электродом
УОНИИ 13/45-3,0-3 ГОСТ 9466-75.
2. * Размеры для справок.
- 3.¹ Изделие для справок.
4. После навески площадок поз. 2 и поз. 3
несовпадение плоскостей А и Б не более 4 мм.
Окна под крючки лестницы обработать по месту.
5. Трубы дет. поз. 6 и поз. 13 приваривать по месту
после установки площадок.
6. Момент затяжки гаек поз. 15 $M_{зот} = 60 \cdot 15$ кгт.
7. По условиям работы испытательного участка
допускается постановка болтов поз. 5 не менее 21 шт.
8. Скобы, поз. 22, 23 приварить по месту, обеспечив
свободное хождение лап лестницы, поз.4
9. Покрытие
наружные и внутренние поверхности
Грунтовка АК-070, желтая, (2)
Змаль ХВ-124, серая, (4)
АК-070 ГОСТ 25718-83
ХВ-124 ГОСТ 10144-89
10. Маркировать Ш, Ч и клеймить Кр по АК-630,
АК-630М ту I.
11. Масса стенда указана без фундаментной плиты
АК-630М 133-89.

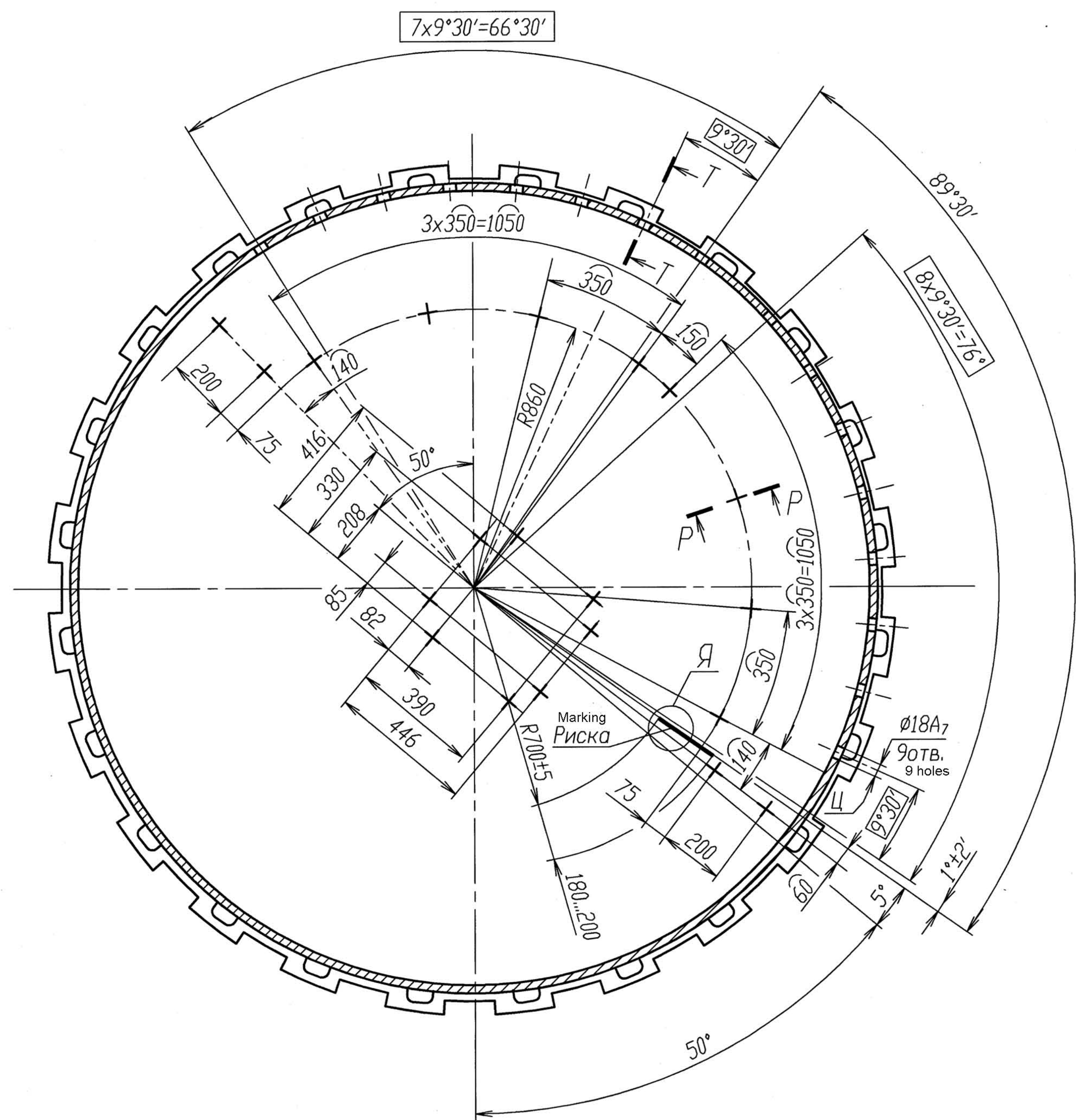
					AK-630CT СБ133СБ		
					Type	Mass	Scale
					Rig in assembly		
					Стенд в сборе		
					СБОРОЧНЫЙ ЧЕРТЕЖ		
Изм./Лист	N докум.	Подп.	Дата		Лист	Масса	Масштаб
Разоб.					A	2340	1:10
Пров.							
Т.контр.					Лист	Листов	
Нормиро				Assembly drawing	Sheet	Total sheets	
Нормиро							
Чтв.							



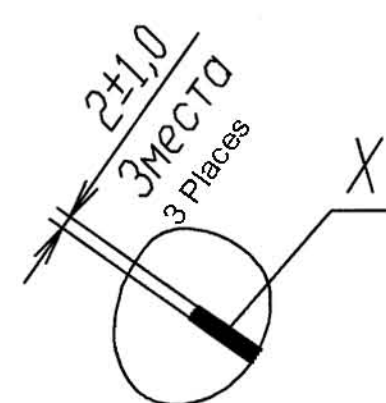
1. * - Dimensions for reference.
2. Electric arc welding with electrode UONI 13/45-2.0-3 GOST 9466-75 and with electrode NIAT-5-3.0-3 GOST 9466-75.
3. Touch the ends of body pos. 1 abutted with ring pos. 4 and base pos. 5. Coincide the windows 160x42 on component pos. 5 with windows on assembly pos. 1.
4. Before the welding, the local gaps of not more than 1.5 mm are permitted.
5. Before the welding, the bending and straightening of components is permitted.
6. In order to ensure the abutment of section, the placing of gaskets pos. 16 for the magazine is permitted.
7. During assembly, set the component pos. 17 by welding to suit the requirement.
8. Tolerance of the perpendicularity of surface П in respect of surface H is not more than 3 mm.
9. *2 – Make the dimensions only for article AK – 630.
10. It is permitted to make the hole Ш along the contour of magazine AK-630 M SB01SB as per the dimension Л.
11. On the places, where the bolts pos. 19 nearly approaches to the rib pos. 6, it is permitted to put the washers pos. 24 instead of washers pos. 15. Finish the welded joints with Rz 80 up to the base metal on the places of setting of washers.
12. During packing, drill the hole Я to suit the requirement as per the technological door.
13. Engrave the marking "X" with depth 0.5 +0.2 and fill with enamel PF-115 red, IV, OM2. Enamel PF – 115 GOST 6465-76.
14. After having ensured the free movement of pins of lodgment AK-630 ST SB 133-11, weld the pipes of pos. 30 to suit the requirement. Mark the lodgments and the places for lodgment with same number according to AK-630, AK-630M TU I with font PO-5 GOST 2630-62 and fill with enamel PF-115, red IV OM2 GOST 6465-76.
15. It is permitted to carry out the marking (machining) of hole Л and the slots 4 through the hole of magazine AK-630M SB 01 after its fitment as per marking X and fastening with dove-tails pos. 14. Do not make the holes and slots, which fall on the rib of component pos. 6.

					AK - 630 ST Sb 133-2 SB				
					AK-630СТ СЫ133-2СБ				
					Type	Mass	Scale		
					Лит.	Масса	Масштаб		
Изм/Ист	N докум.	Подп.	Дато		Лит.	А	2100	1:10	
Разработ.									
Пров.									
Т.контр.					Сборочный чертёж				
Начертано					Rig				
Н.контр.					Assembly drawing				
Утв.									
					Лист 1	Листов 3			
					Sheet		Total sheets		

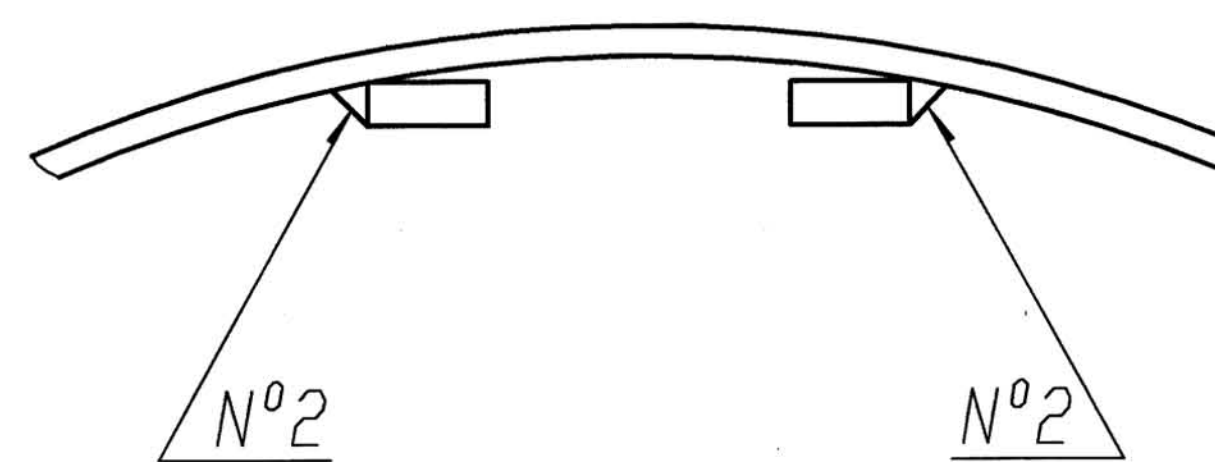
Формат А1



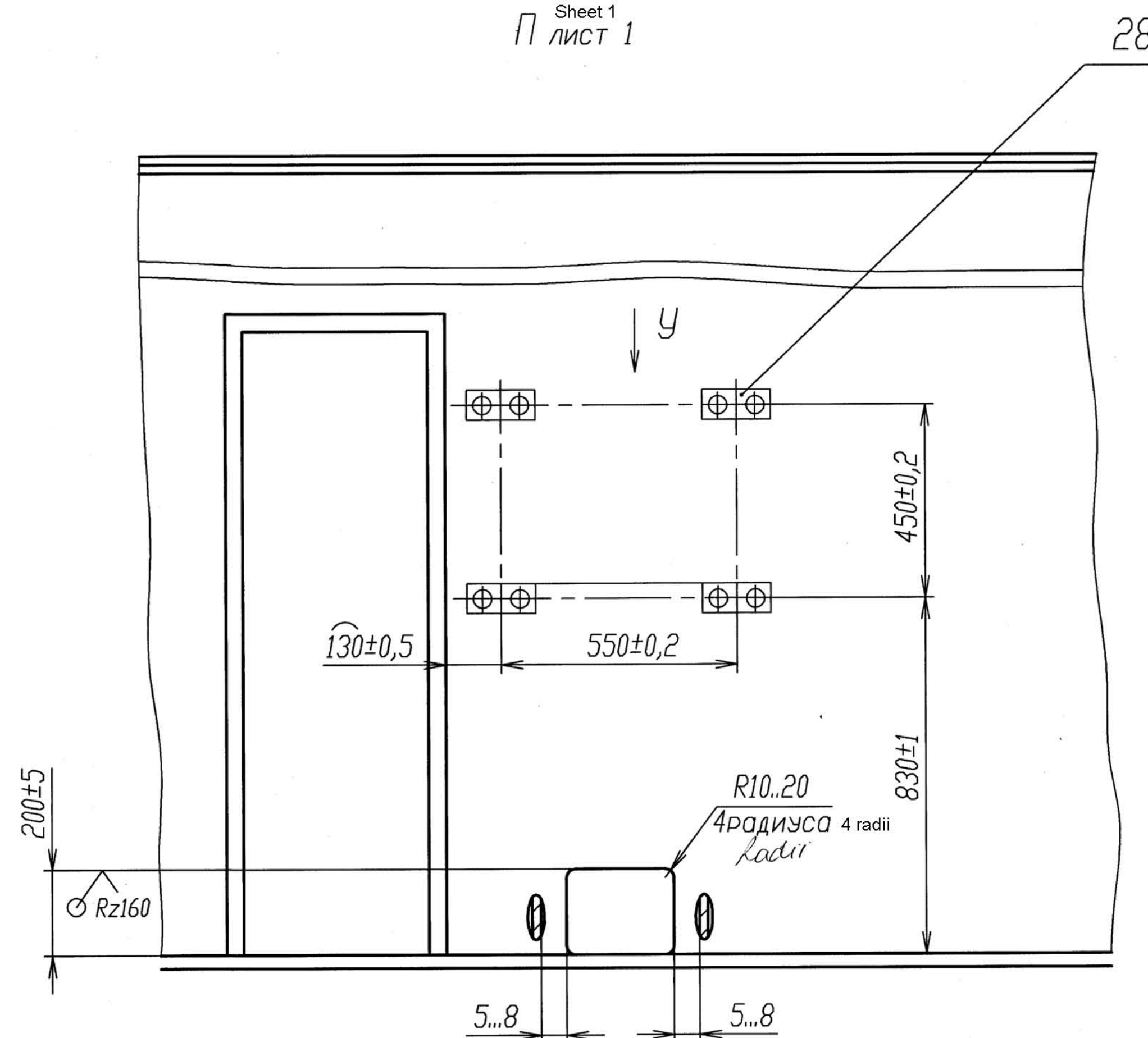
Я (1:1)



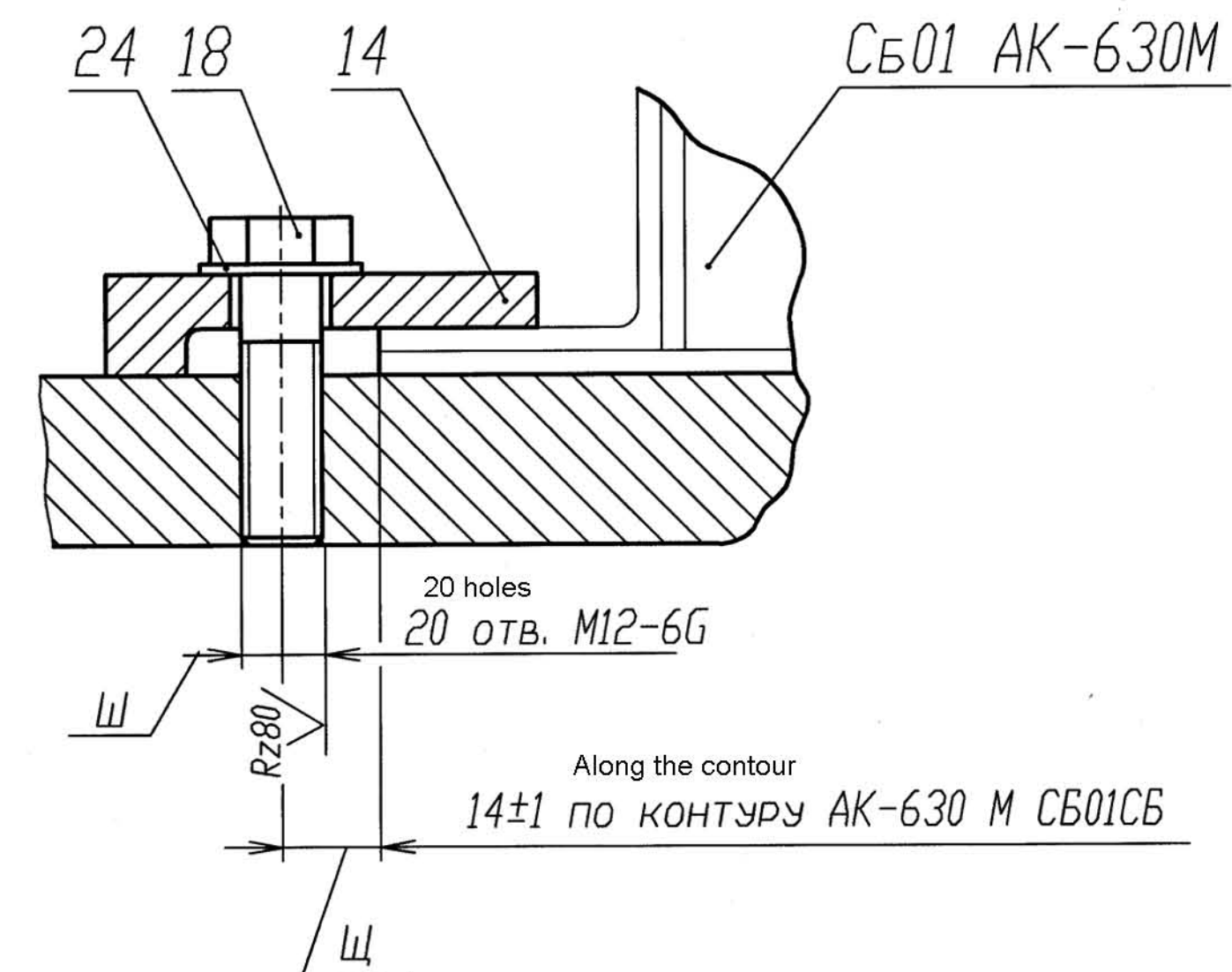
U Sheet 3
У ЛИСТ 3



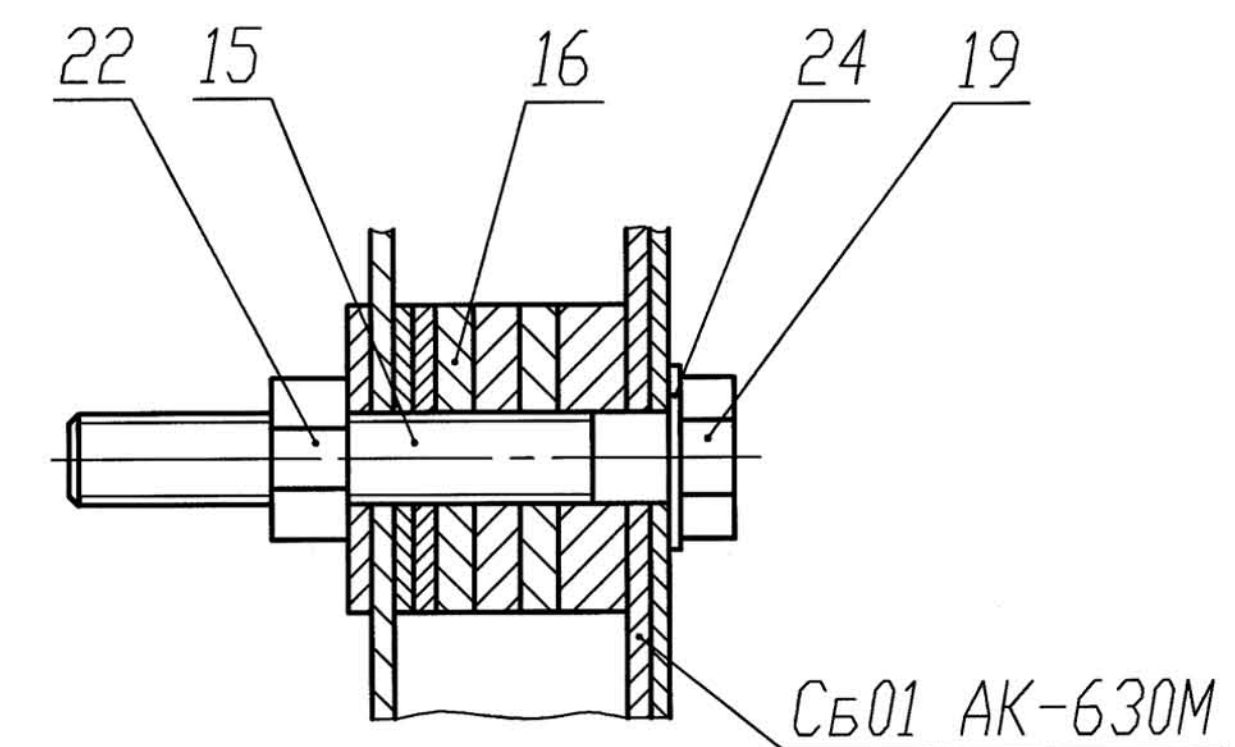
Sheet 1
ЛИСТ 1



P-P (1:1) ☉



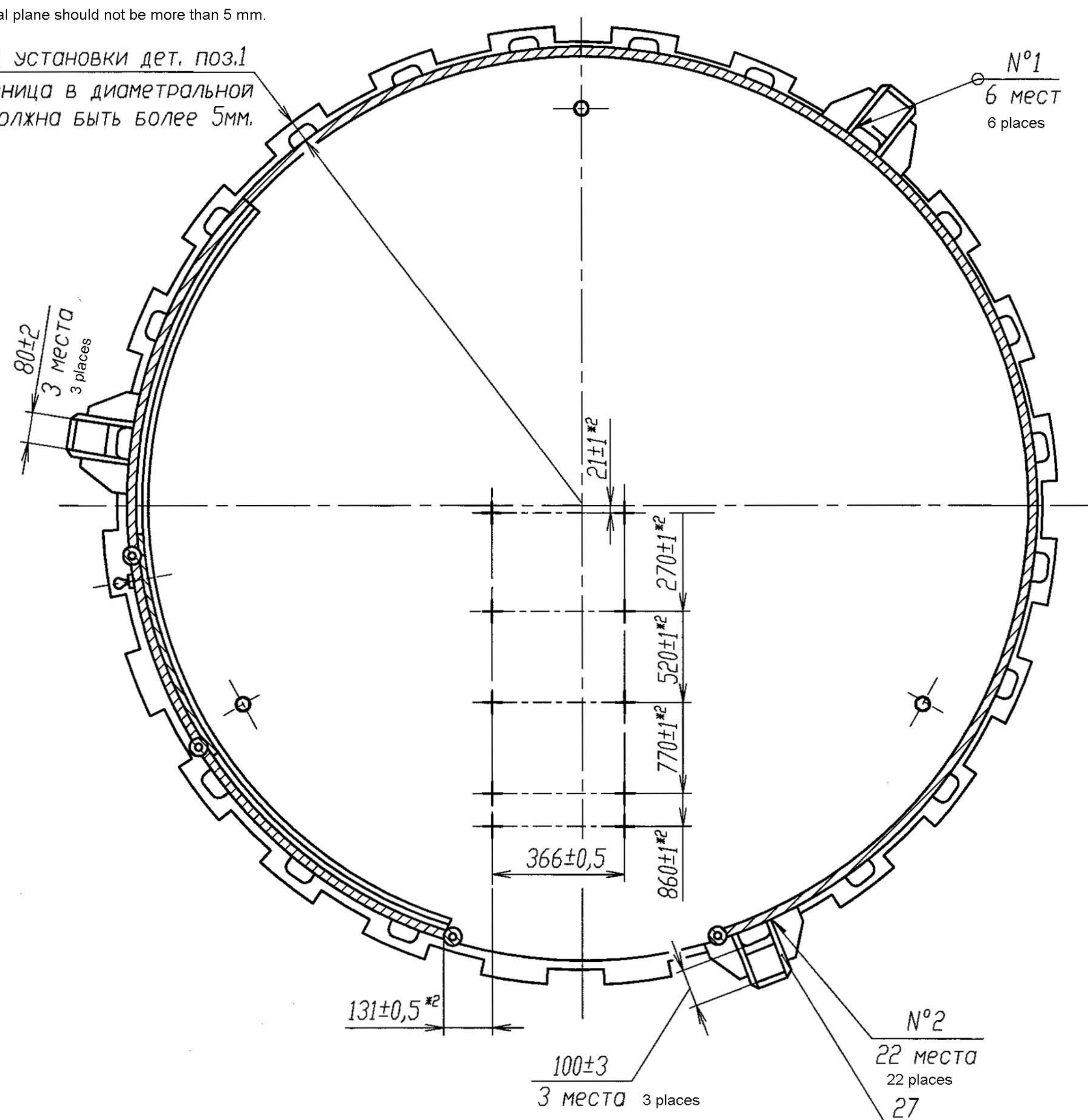
T-T (1:1) ☉



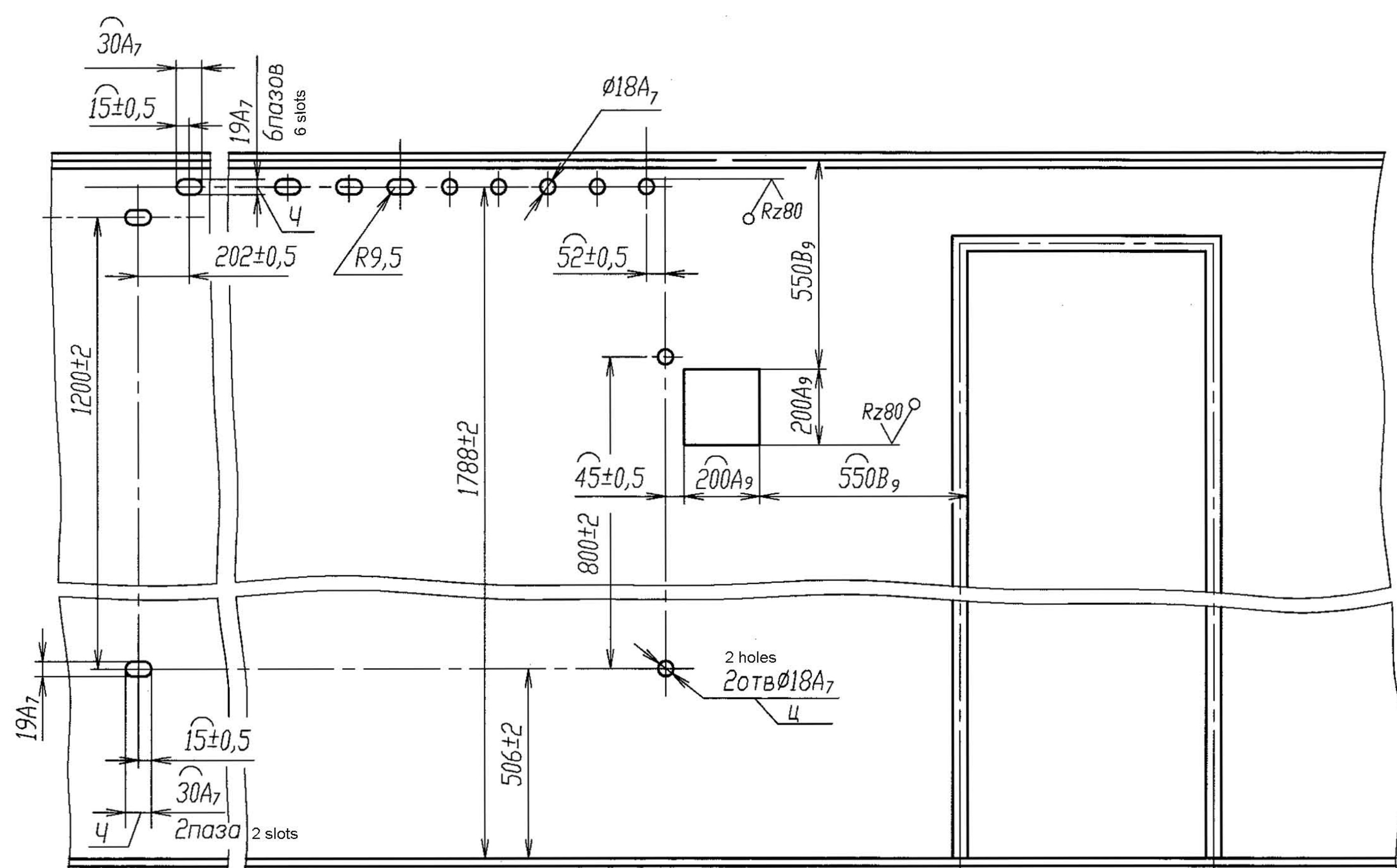
Д-Д Sheet 1
ЛИСТ 1

47 *2 Dimension for the fitment of component pos. 1 for welding.
The difference in diametrical plane should not be more than 5 mm.

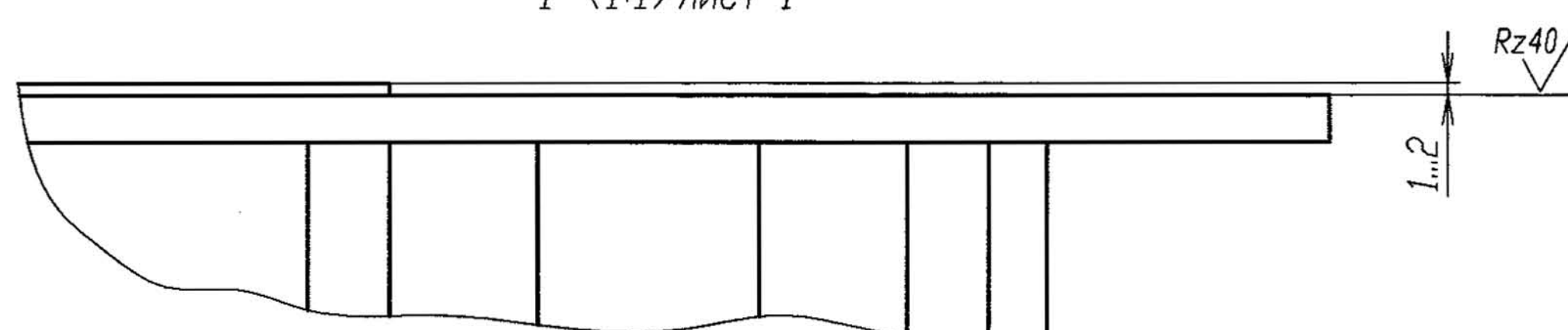
47*2 Размер для установки дет. поз.1
под сварку. Разница в диаметральной
плоскости не должна быть более 5мм.



К sheet 1
лист 1



I (1:1) Sheet 1
ЛИСТ 1



Изм	Лист	№ докум.	Подп.	Дат.

**EQUIVALENT MATERIAL LIST FOR TEST STAND TO DRAWING No.- AK-630 ST Sb 133 SB
(FOR ASSEMBLY & FACTORY TEST PURPOSE ONLY)**

Sl. No.	Component	Drawing No.	OEM Material	Recommended Equivalent Material	REMARKS/REF.
1	UPPER RING	AK-630 ST 133-4	SHEET PN-03GOST 19903-74/ 25-2-GOST16523-93	Grade Fe 490 to IS : 5986-02	
2	BASE	AK-630 ST 133-5	SHEET PN-30GOST 19903-74/ 25-2-GOST1577-93		
3	RIB	AK-630 ST 133-31	SHEET B-PN-12GOST 19903-74/ 25-2-TGOST1577-93		
4	PLATE	AK-630 ST 133-74	SHEET B-PN-5GOST 19903-74/ 25-2GOST16523-97		
5	STOP	AK-630ST 133-81	SHEET B-PN-6GOST 19903-74/ 25-2-GOST1577-93		
6	RIB	AK-630 ST 133-79	SHEET B-PN-6GOST 19903-74/ 25-2-GOST1577-93		
7	SIDE PLATE	AK-630 ST 133-1	SHEET B-PN-03 GOST 19903-74/ K-390V-4-III25GOST16523-97		
8	SIDE PLATE	AK-630 ST 133-2	SHEET B-PN-03 GOST 19903-74/ K-390V4-III25GOST16523-97		
9	OF BODY	AK-630 ST 133-41	SHEET B-PN-03 GOST 19903-74/ K-390V4-III25GOST16523-97		
10	SUPPORT	AK-630 ST 133-76	SHEET B-PN-6GOST 19903-74/ 25-2-GOST16523-97		
11	RIB	AK-630 ST 133-6	SHEET B-PN-03 GOST 19903-74/ K-390V-4-III25GOST16523-97		
12	WASHER	AK-630 ST 133-57	SHEET B-PN-03 GOST 19903-74/ K-390V-4-III25GOST16523-97		
13	PLATE	AK-630 ST 133-28	SHEET B-PN-03.9 GOST 19903-74/ K490V4-III25GOST16523-97		
14	SHEET	AK-630 ST 133-29	SHEET B-PN-5GOST 19903-74/ 25GOST1577-93		
15	GUSSET PLATE	AK-630 133-21	SHEET B-PN-03 GOST 19903-74/ K490V4-III35GOST16523-97		
16	SHEET	AK-630 ST 133-13	SHEET B-PN-5GOST 19903-74/ 25GOST1577-93		

17	CLAMP	AK-630 ST 133-97	SHEET B-PN-0-3.9 GOST 19904-74/ K-390V-4-III25GOST16523-97	Grade 490 Y to IS : 14491-97	
18	MAJOR SHAPING STRIP	AK-630 ST 133-6	PIPE 20X1.5GOST8734-75/V20GOST8733-87	Designation CDS-3 to IS : 3074-05, Condition as drawn or as drawn & tempered.	
19	UPPER SHAPING STRIP	AK-630 ST 133-9	PIPE 20X1.5GOST8734-75/V20GOST8733-87		
20	MINOR SHAPING STRIP	AK-630 ST 133-11	PIPE 20X1.5GOST8734-75/V20GOST8733-87		
21	UPPER SHAPING STRIP	AK-630 ST 133-12	PIPE 20X1.5GOST8734-75/V20GOST8733-87		
22	HANDLE	AK-630 ST 133-72	PIPE 20X1.5GOST8734-75/V20GOST8733-87		
23	PIPE	AK-630 ST 133-15	PIPE 20X2.8 GOST 3262-75		
24	PIPE	AK-630 ST 133-64	PIPE 20X2.8 GOST 3262-75		
25	TUBE	AK-630 133-14	PIPE 20X2.8 GOST 3262-75		
26	PIPE	AK-630 133-15	PIPE 20X2.8 GOST 3262-75		
27	SUPPORT	AK-630 133-26	PIPE 20X2.8 GOST 3262-75		
28	TUBE	AK-630 133-22	PIPE 20X2.8 GOST 3262-75	SUITABLE SIZE OF IS : 1239 (PART 1) -2004	
29	CLAW	AK-630 ST 133-46	STEEL 35 GOST 1050-88		
30	EYE BOLT	AK-630 ST 133-92	STEEL 30KhGSA GOST 4543-71	IS : 4367-91 Designation 25Cr13Mo6 (component to be suitably heat treated to achieve the hardness as stipulated in the drawing. LRS-30, Secondary refined steel shall be used.	
31	BUSH	AK-630 ST 133-93	48-VGOST2590-88/30KhGSA GOST 4543-71		
32	DOOR	AK-630 ST 133-34	SHEET AMg6BM-3 GOST 21631-76		
33	PIN	AK-630 ST 102-48	STEEL 50 GOST 1050-88		
34	LUG	AK-630 ST 133-51	STEEL 40 GOST 1050-88		
35	GASKET	AK-630 ST 133-53	STEEL 25 GOST 1050-88		
36	ANGLE PIECE	AK-630 133-16	ANGLE 50X50X5-VGOST8509-93/VStZps2-IGOST535-88		
37	ANGLE PIECE	AK-630 133-17	ANGLE 50X50X5-VGOST8509-93/VStZps2-IGOST535-88		
38	ANGLE PIECE	AK-630 133-18	ANGLE 50X50X5-VGOST8509-93/VStZps2-IGOST535-88		

39	MAJOR GUIDE	AK-630 ST 133-36	ANGLE 25X25X4-VGOST8509-93/NSIzps2-IGOST535-88	Fe-410-0 of IS:1977-75	
40	LEFT SUPPORT	AK-630 133-23	ANGLE 50X50X5-VGOST8509-93/NSIzps2-IGOST535-88		
41	RIGHT SUPPORT	AK-630 133-24	ANGLE 50X50X5-VGOST8509-93/NSIzps2-IGOST535-88		
42	STEP	AK-630 133-25	ANGLE 50X50X5-VGOST8509-93/NSIzps2-IGOST535-88		
43	BOLT	AK-630 ST 133-65	WHEEL VGOST2590-88/40Kh-3-TGOST4543-71		
44	SCREW	AK-630 ST 133-68	STEEL 40Kh GOST 4543-71	BS 970 En 19	
45	NUT	AK-630 ST 133-69	STEEL 40Kh GOST 4543-71		
46	SUPPORT	AK-630 ST 133-70	STEEL 40Kh GOST 4543-71		
47	SCREW	AK-630 ST 133-71	STEEL 40Kh GOST 4543-71		
48	HEAD	AK-630 ST 133-73	WHEEL 40-VGOST2590-88/25-B-Ggost1050-88	Design 30 C8 to IS : 5517-04, *	
49	GASKET	AK-630 ST 133-58	WHEEL 12-h12GOST7417-75/25-V-NGOST1051-73		
50	PIN	AK-630 ST 133-91	Grade 25 C8 to IS : 11169 (Pt-1)-84		

NOTES:-

1. Equivalent material recommended with the ref. to JSG:019-1989 & lists of equivalent material provided by CQA (Met) for other Assy. of AK-630M NAVAL GUN.
2. Fasteners required for assy. may be taken similar Standard Fasteners as desired strength or manufactured from En 19 BS : 970.

APPROVED BY
JTGM/ORD.

[Signature]
06/12/11

PREPARED BY
JWM/CDO

[Signature]

Note: — ① The firm has to provide NAAL TC for all material as mentioned above.