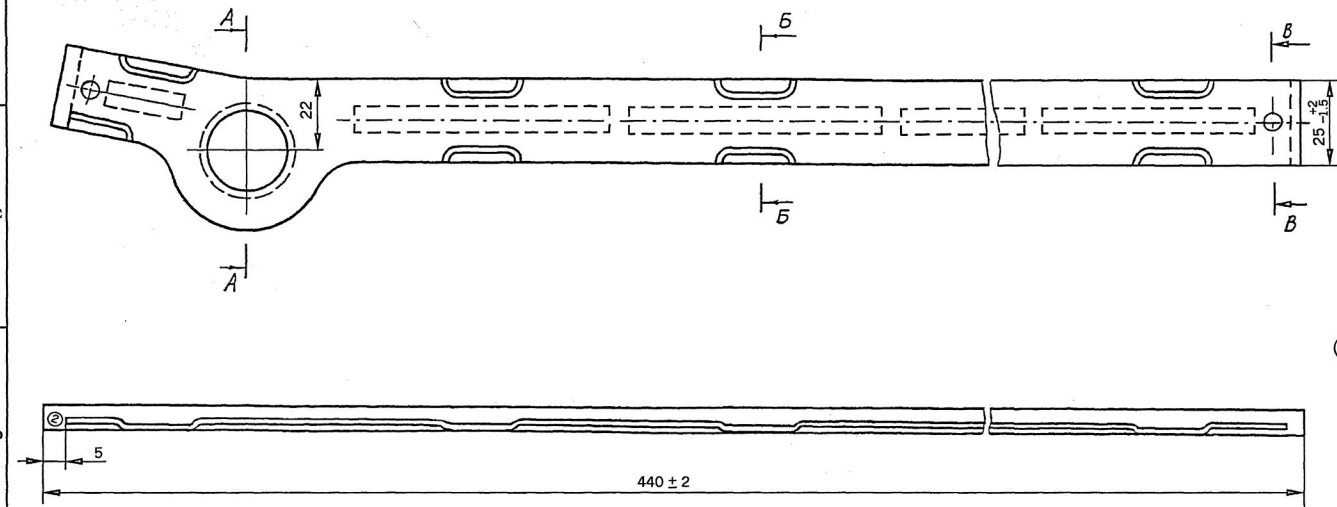


DRAWING NUMBER
172.2M.02.015cbCb

SHEET No. 1 OF 1

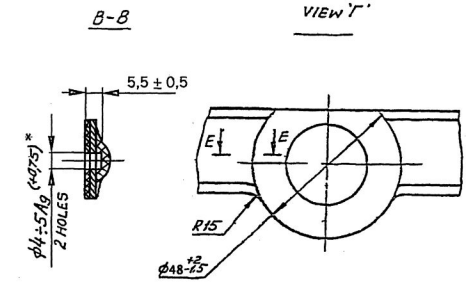
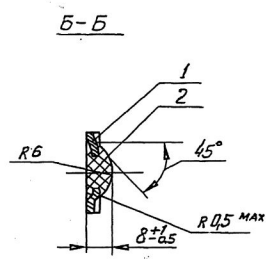
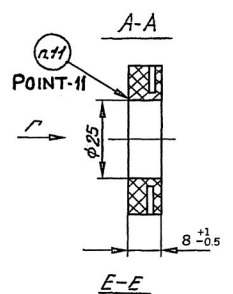
COMMON TO T-90 " & BLT
 DRG. RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 8
 (B.JAYAVELUJITOID)
 15-04-08



- 1. COMPONENT 2 IS TO BE MANUFACTURED FROM RUBBER-HD-68-TY-905216-75-NBR + CR (BNC Grade of CQA(HV))
- 2. RUBBER FILM IS ALLOWED ON NON-RUBBERISED SURFACES.
- 3. MISMATCH SHIFT OF PRESS MOULD AXES NOT TO BE MORE THAN 1mm.
- 4. SURFACES OF STAMPED RECESSES ON BOTH SIDES OF THE COMPONENT OVER A LENGTH OF 10 mm AND WIDTH 3 mm AS WELL AS THE EDGES OF STAMPED RECESSES SHOULD BE FREE FROM RUBBER, DRESSING IS ALLOWED.
- 5. ON THE SURFACES OF RUBBER LOCAL CAVITIES OF Ø 4 mm MAX AND 1 mm MAX IN DEPTH IN A QUANTITY OF NOT MORE THAN 4 PIECES ARE ALLOWED.
- 6. TECHNICAL REQUIREMENTS FOR ACCEPTANCE OF COMPONENT ARE WITH TY-905216-75-GGDE-263161-NBR + CR (BNC Grade of CQA(HV))
- 7. ROUNDING OFF CORNERS WITH A RADIUS OF 1 mm MAXIMUM IS ALLOWED.
- 8. GASKET IS TO BE GLUED BY HOT METHOD (VULCANIZING) USING GLUE "LEIKONAT" TY 6-14-95-75.
- 9. IN THE AREA OF STAMPED RECESSES PEELING OF RUBBER TO A DEPTH OF 4 mm IS ALLOWED.
- 10. * DIMENSIONS FOR REFERENCE.
- 11. MARK THE MANUFACTURER'S SYMBOL AND NUMBER OF THE COMPONENT IN RAISED LETTERS ПO-3 GOST 2930-62

EXPLANATORY NOTE: (U)
 12. REFERENCE NOTE 1 ON MATERIAL FOR ITEM 2, RUBBER GRADE HD-68-TY 005 216-75

PHYSICAL AND MECHANICAL PARAMETERS	
TYPE OF RAW RUBBER	CKH-18
RUPTURE STRENGTH	90 Kgf/cm ² MIN
ELONGATION OF RUPTURE	250 % MIN
RESIDUAL ELONGATION	12 % MAX
HARDNESS IN CONVENTIONAL UNITS	55 TO 70 (OF T1P)
DENSITY	1.24 ± 0.05 g/cm ³
WORKING TEMPERATURE	-50° C TO +100° C
WORKING MEDIUM	AIR, OILS, LUBRICANTS



R0.5 FOR ALL
 MATING PLACES WITH
 BOSS Ø 48
 NOT TO BE CHECKED

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

EST. WT. 0.188 Kg	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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

DURING USE IT SHOULD WITHSTAND A PRESSURE UPTO 100 Kgf/cm²

EQUIVALENT MATERIAL: (C)
 NBR + CR (BNC Grade of CQA(HV))

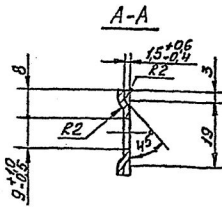
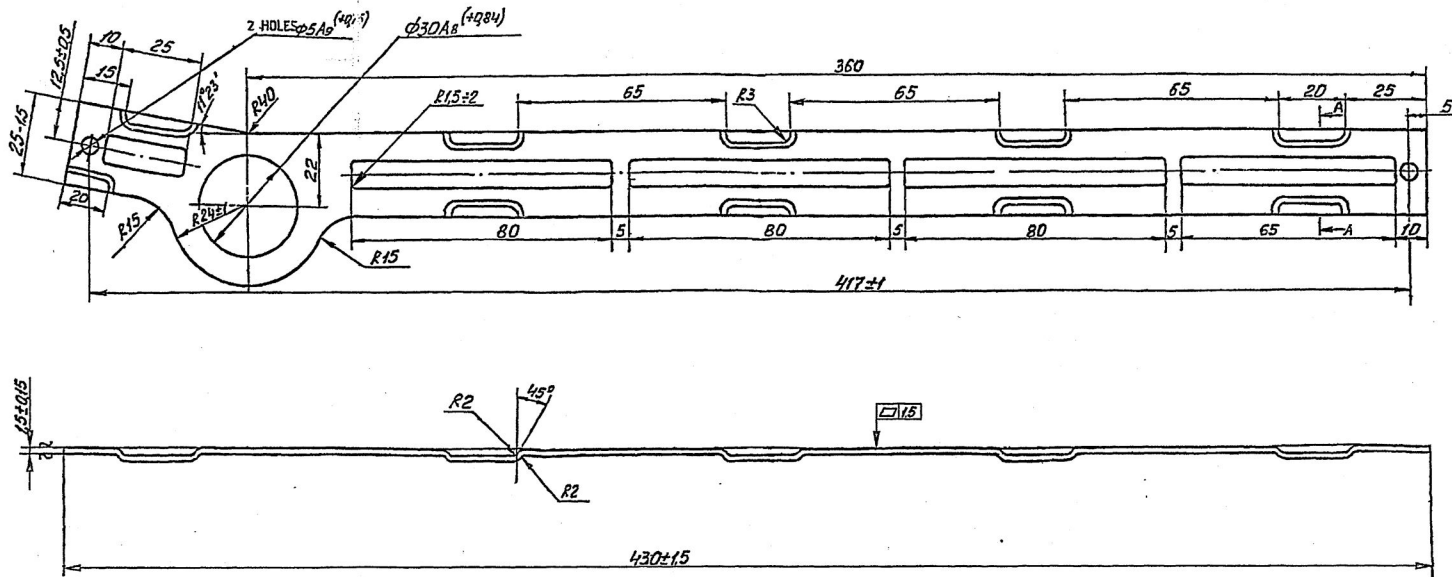
DRN	Sd / =	MATERIAL:-	USED ON:-
CHD	Sd / =		172 02 002 Cb-2Cb
APPD	Sd / =		188.02.002cbCb (8A)
DATE	20.1.87	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE:-	1:1	AVADI	
DIMENSIONS IN mm		TITLE:-	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69		GASKET	
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
ISSUE DATE NATURE OF AMENDMENTS			172.2M.02.015cbCb

F-13
 2
 SIZE A2



DRAWING NUMBER
172.2M.02.031

SHEET No. 1 OF 1



1. MAY BE MANUFACTURED FROM OPEN HEARTH STEEL 10K α 5-III Г GOST 16523-70.
2. DEVIATIONS FOR DIMENSIONS WITH UNSPECIFIED TOLERANCES ± 15 MM.
3. SHRINKAGE OF EDGES ARE NOT TO BE CHECKED IN THE STAMPED PLACES.
4. CORRUGATION AND DIE MARKS ARE ALLOWED ON THE COMPONENT SURFACE.
5. THE REST OF THE REQUIREMENTS SHOULD BE ACCORDING TO TY 005216-75 (APPENDIX 11).

EXPLANATORY NOTE: (1)

- REFERENCE MATERIAL QUOTED:-
QUALITY CARBON STEEL OF CATEGORY 5, HIGH FINISH ON QUALITY OF SURFACE FINISH, DEEP DRAWN TO GRADE 10 K α GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH STEEL GRADE 10 K α TO GOST 1050-74 OPEN HEARTH.
- REFERENCE NOTE 1 ON ALTERNATIVE MATERIAL:
QUALITY CARBON STEEL OF CATEGORY 5, SUPERIOR FINISH ON QUALITY OF SURFACE FINISH, DEEP DRAWN, TO GRADE 10 K α GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH STEEL GRADE 10K α TO GOST 1050-74 OPEN HEARTH.
- CHEMICAL COMPOSITION: AS PER STEEL GRADE 10 K α GOST 1050-74 OPEN HEARTH.

CONTENT OF ELEMENTS, %					
C	Si	Mn	Cr	S	P
			MAX		
0.07-0.14	0.07-MAX	0.25-0.50	0.15	0.040	0.035

RESIDUAL CONTENT OF COPPER & NICKEL SHOULD NOT EXCEED 0.25% EACH

- MECHANICAL PROPERTIES: AS PER STEEL GRADE 10 K α GOST 16523-70 OF CATEGORY 5, DEEP DRAWN

TENSILE STRENGTH Kgf/mm ²	ELONGATION %	CUPPING TEST DEPTH OF SPHERICAL HOLE MIN.	BEND TEST 180°
28-40	25	11.2	CLOSE

" COMMON TO T-90 " & BLT

DRG. RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 6

IB JAYAKULU (TODI)
-04-08

F-16
41

SIZE A2

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

EST. WT.
0.0956 Kg.

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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

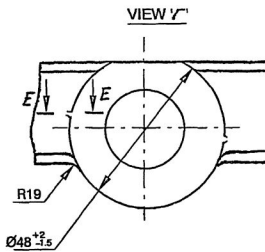
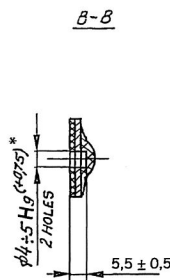
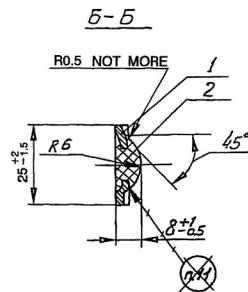
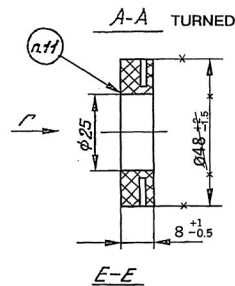
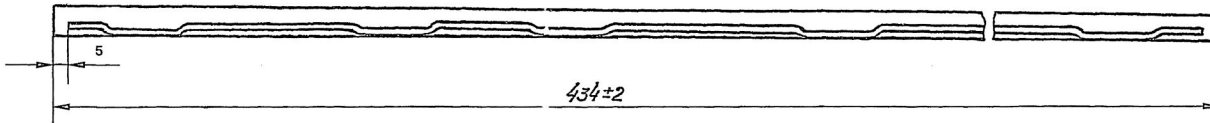
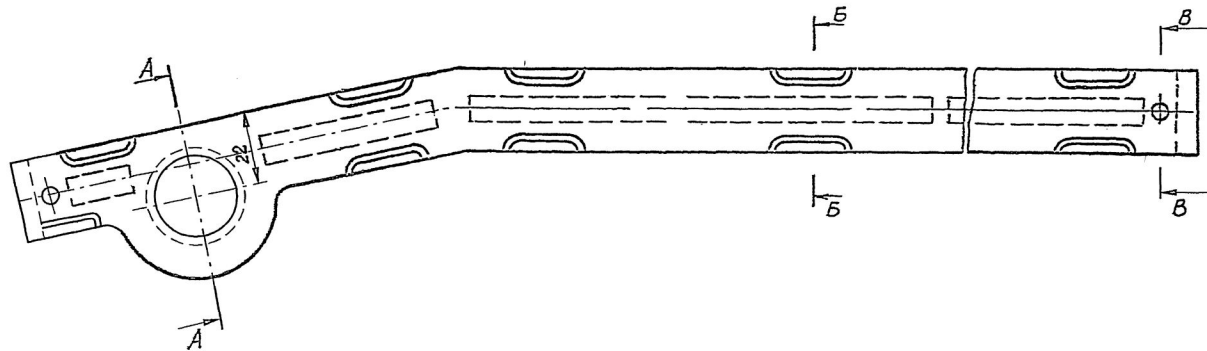
DRN	Sd / =	MATERIAL:-	USED ON:-
CHD	Sd / =	OPEN HEARTH STEEL 10K α 5-III GOST 16523-70	172 2M 02 015 Cbcb
APPD	Sd / =	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
DATE	20.01.87		
SCALE:-	1:1	TITLE:- FRAME	
DIMENSIONS IN mm			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69		D S CAT NUMBER	
ALL THREADS TO CONFORM TO			
L1	24.6.BB	DRAWING NUMBER	
ISSUE	DATE	172.2M.02.031	
EXPLANATORY NOTE ADDED			
NATURE OF AMENDMENTS			





DRAWING NUMBER
172.2M.02.016cbCb

SHEET No. 1 OF 1



R 0.5 FOR ALL
MATING SURFACES WITH
BOSS Ø 48
NOT TO BE CHECKED

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

EST. WT. 0.190 Kg 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.

1. COMPONENT 2 IS TO BE MANUFACTURED FROM RUBBER HO-00-1 TY-005216-75. NBR + CR (BNC Grade of CQA(HV))
2. RUBBER FILM IS ALLOWED ON NON RUBBERISED SURFACES.
3. MISMATCH (SHIFT) OF THE PRESS MOULD AXES NOT TO BE MORE THAN 1mm.
4. SURFACES OF STAMPED RECESSES ON BOTH SIDES OF THE COMPONENT OVER A LENGTH OF 10mm AND WIDTH 3mm AS WELL AS THE EDGES OF STAMPED RECESSES SHOULD BE FREE FROM RUBBER. DRESSING IS ALLOWED.
5. ON THE SURFACES OF RUBBER, LOCAL CAVITIES OF 4mm, MAXIMUM IN DIAMETER AND 1mm MAX. IN DEPTH IN A QUANTITY OF NOT MORE THAN 4 PIECES ARE ALLOWED.
6. TECHNICAL REQUIREMENTS FOR ACCEPTANCE OF COMPONENT ARE IN ACCORDANCE WITH TY-005216-75 CODE-2594-01. NBR + CR (BNC Grade of CQA(HV))
7. ROUNDING OFF OF CORNERS WITH A RADIUS OF 1mm. MAX IS ALLOWED.
8. GASKET IS TO BE GLUED BY HOT METHOD (VULCANIZING) "GLUE" LEIKONAT TY6-14-95-75.
9. IN THE AREA OF STAMPED RECESSES PEELING OF RUBBER TO A DEPTH OF 4mm IS ALLOWED.
10. *DIMENSIONS FOR REFERENCE.
11. MARK THE MANUFACTURER'S SYMBOL AND NUMBER OF THE COMPONENT IN RAISED LETTERS TO-3 GOST 2930-62.

EXPLANATORY NOTE: (L1)

12. REFERENCE NOTE 1 ON MATERIAL FOR ITEM 2, RUBBER GRADE HO-00-1 TY-005216-75.

PHYSICAL AND MECHANICAL PARAMETERS	
TYPE OF RAW RUBBER	CKH-18
RUPTURE STRENGTH	90 Kg/cm ² MIN
ELONGATION OF RUPTURE	250 % MIN
RESIDUAL ELONGATION	12 % MAX
HARDNESS IN CONVENTIONAL UNITS	55 TO 70 (OF TWP)
DENSITY	1.24 ± 0.03 g/cm ³
WORKING TEMPERATURE	-50°C TO +100°C
WORKING MEDIUM	AIR, OILS, LUBRICANTS

DURING USE IT SHOULD WITHSTAND A PRESSURE UPTO 100 Kg/cm²

EQUIVALENT MATERIAL: (L1)

NBR + CR (BNC Grade of CQA(HV))

COMMON TO T-90 & BLT
DRG. BE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 8

F-13
3

SIZE A2

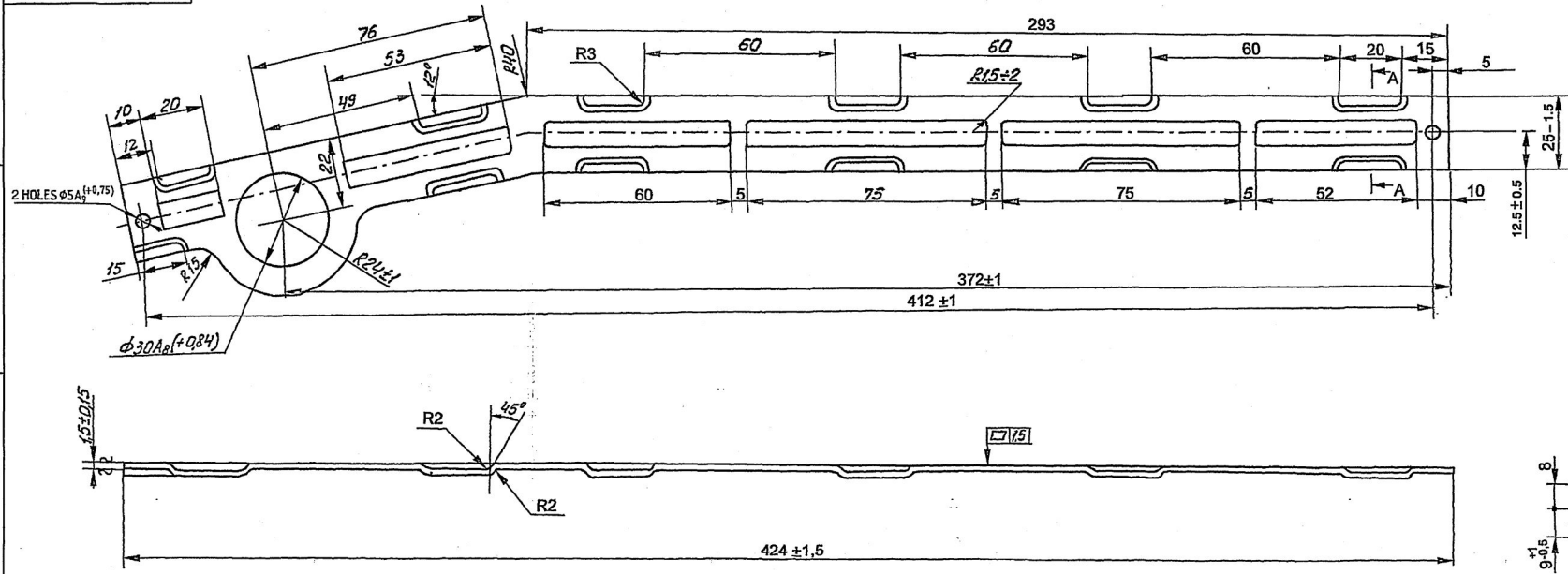
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CHD	Sd / =	---	172 02 002 Cb-2
APPD	Sd / =		188.02.002cbCb (GA)
DATE	12.12.86	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
SCALE:-	1 : 1	TITLE:-	
DIMENSIONS IN mm		GASKET	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69		D S CAT NUMBER	DRAWING NUMBER
ALL THREADS TO CONFORM TO			172.2M.02.016cbCb
ISSUE	DATE	NATURE OF AMENDMENTS	
8 C	30.09.19	83201/TECH GEN/EQ.MATL/HVF dt. 25.09.19	
8 B	01.07.19	83201/Tech Gen/EQ. Matl/HVF dt. 02.04.19	
8 A	4.8.03	N OF A No. CQA(HV)/T90/02/001.	
L1	24-6-88	EXPLANATORY NOTE ADDED	



DRAWING NUMBER
172.2M.02.033

SHEET No. 1 OF 1

▽1(▽)



7. a) CHEMICAL COMPOSITION: AS PER STEEL GRADE 10 KII GOST 1050-74
OPEN HEARTH

CONTENTS OF ELEMENTS %					
C	Si	Mn	Cr	S	P
			MAX		
0.07 - 0.14	0.07 - MAX	0.25 - 0.50	0.15	0.040	0.035

RESIDUAL CONTENT OF COPPER & NICKEL SHOULD NOT EXCEED
0.25% EACH.

b) MECHANICAL PROPERTIES AS PER STEEL GRADE 10 KII GOST 16523-70
OF CATEGORY 5, DEEP DRAWN.

TENSILE STRENGTH Kgf/mm ²	ELONGATION %	CUPPING TEST DEPTH OF SPHERICAL HOLE MIN	BEND TEST 180°
28-40	25	11.2	CLOSE

- MAY BE MANUFACTURED FROM OPEN HEARTH STEEL 10 KII 5-III-G
GOST 16523-70.
- DEVIATIONS FOR DIMENSIONS WITH UNSPECIFIED TOLERANCES ± 1.5 mm.
- SHRINKAGE OF EDGES ARE NOT TO BE CHECKED IN THE STAMPED PLACES.
- CORRUGATION AND TOOL MARKS ARE ALLOWED ON COMPONENT SURFACE.
- REMAINING REQUIREMENT SHOULD BE IN COMPLIANCE WITH TY 005216 - 75
(APPENDIX 1)

EXPLANATORY NOTES : (L1)

- REFERENCE MATERIAL QUOTED :-
QUALITY CARBON STEEL OF CATEGORY 5, HIGH FINISH ON
QUALITY OF SURFACE FINISH, DEEP DRAWN TO GRADE 10 KII
GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH
STEEL GRADE 10 KII TO GOST 1050-74 OPEN HEARTH.
- REFERENCE NOTE 1 ON ALTERNATE MATERIAL:
QUALITY CARBON STEEL OF CATEGORY 5, SUPERIOR FINISH ON
QUALITY OF SURFACE FINISH, DEEP DRAWN TO GRADE 10 KII
GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH
STEEL GRADE 10 KII TO GOST 1050-74 OPEN HEARTH.

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

EST. WT.
0.0970 Kg

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	Sd / =	MATERIAL:- OPEN HEARTH STEEL 10KII-5-II Γ GOST 16523-70	USED ON :- 172 2M 02 016 CbCb
CHD	Sd / =	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	TITLE:- FRAME
APPD	Sd / =		
DATE	24-2-87	D S CAT NUMBER	
SCALE:- 1:1		DRAWING NUMBER 172.2M.02.033	
DIMENSIONS IN mm			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69			
ALL THREADS TO CONFORM TO			
L1	24.6.88	EXPLANATORY NOTE ADDED.	
ISSUE	DATE	NATURE OF AMENDMENTS	

" COMMON TO T - 90 " & BLT
DRG. RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 6

F-16
42

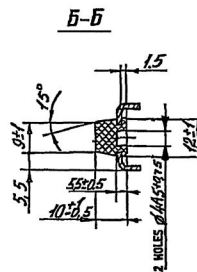
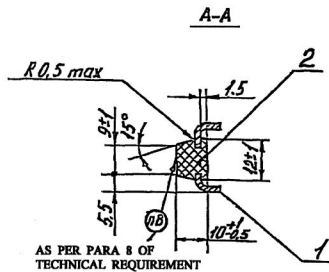
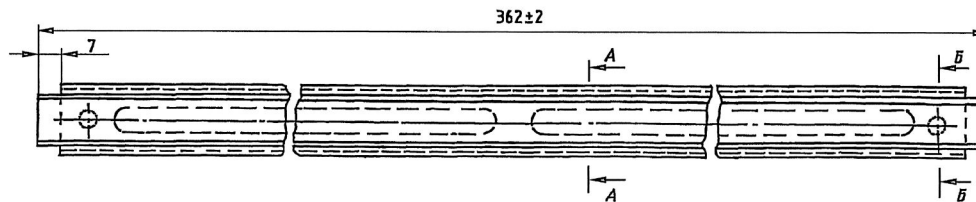
SIZE A2





DRAWING NUMBER
175.02.033cbCb

SHEET No. 1 OF 1



- 10 1. COMPONENT 2 SHOULD BE MANUFACTURED FROM RUBBER HO-68-1 TY 005216-75.
2. NON-RUBBERIZED SURFACES EXCEPT THE SHOULDER FACES ARE ALLOWED TO HAVE A RUBBER FILM.
3. MISALIGNMENT (SKEWNESS) OF AXES OF MOULD IS NOT TO BE MORE THAN 1 mm.
4. ON RUBBERIZED SURFACES UPTO 4 LOCAL CAVITIES WITH DIA UPTO 4 mm AND A DEPTH UPTO 1mm ARE ALLOWED.
- 10 5. ACCEPTANCE OF COMPONENT-IN ACCORDANCE WITH TY 005216-75, CODE 253161.
6. ALLOWED IS ROUNDING OFF CORNERS TO R 1mm, MAXIMUM.
7. GASKET IS TO BE GLUED BY HOT GLUING PROCESS (VULCANIZING METHOD) WITH GLUE "LEUKONAT" TY 6-14-95-75.
8. MANUFACTURING FACTORY DESIGNATION AND COMPONENT NUMBER ARE TO BE MARKED IN RAISED CHARACTERS, TYPE NO 3 AS PER GOST 2930-62.

- 10 EXPLANATORY NOTE: 1)
2. REFERENCE NOTE 1 ON MATERIAL FOR ITEM 2, RUBBER GRADE HO 68-1 TY 005 216-75.

PHYSICAL AND MECHANICAL PARAMETERS	
TYPE OF RAW RUBBER	CKH-18
RUPTURE STRENGTH	90 Kg/cm ² MIN
ELONGATION OF RUPTURE	250 % MIN
RESIDUAL ELONGATION	12 % MAX
HARDNESS IN CONVENTIONAL UNITS	55 TO 70 (OF T1P)
DENSITY	1.24 ± 0.05 g/cm ³
WORKING TEMPERATURE	-50°C TO +100°C
WORKING MEDIUM	AIR, OILS, LUBRICANTS

DURING USE IT SHOULD WITHSTAND A PRESSURE UPTO 100 Kg/cm²

- 1C EQUIVALENT MATERIAL: 10

NBR + CR (BNC Grade of CQA(HV))

* COMMON TO T-90 * & BLT
DRG. RE INDIANISED BASED ON RUSSIAN ORIGINAL. ISSUE - 11

(B.JAYAVELUJ.)TODD
26 MAR 08

F-11
15

SIZE A2

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

EST. WT.	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
0.174 Kg	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

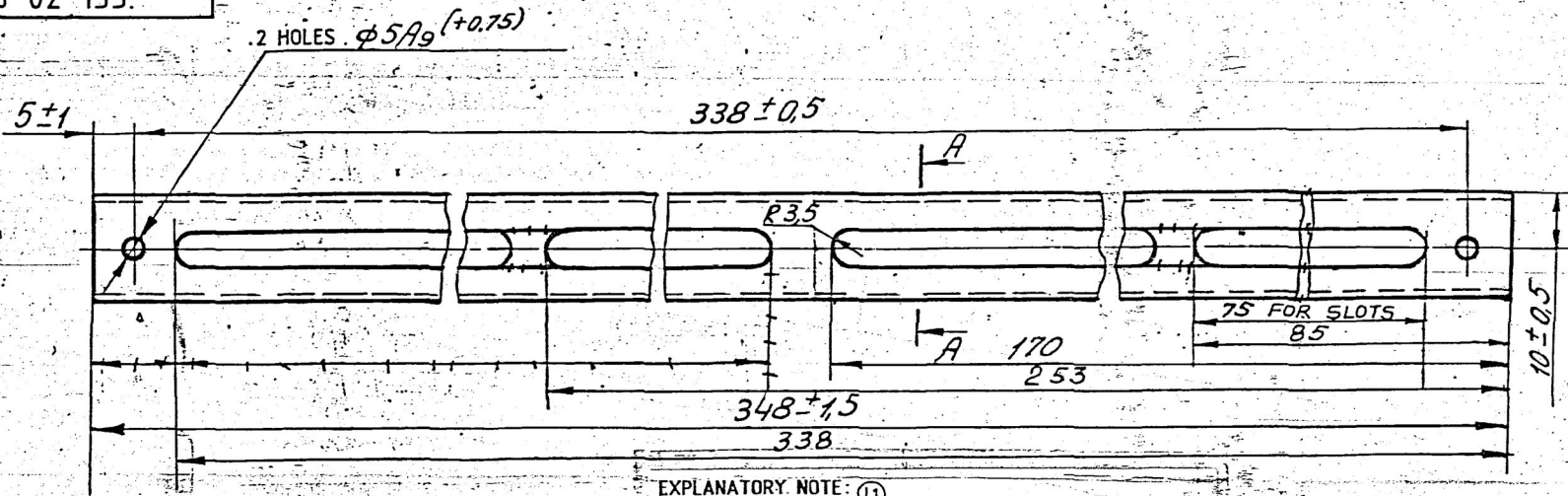
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CHD	Sd / =		172 02 079 Cb - 6
APPD	Sd / =		188.02.079cbCb (1A) (1B)
DATE	20 - 1 - 87	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
SCALE:- 1 : 1			
DIMENSIONS IN mm			
TOLERANCE ON DIMENS UNLESS OTHERWISE STATED IS : 2102 - 69		TITLE:- GASKET	
1D	30.09.19	N OF A No. CQA(HV)/T90/02/001.	
1C	01.07.19	EXPLANATORY NOTE ADDED.	
1B	03.09.11	NATURE OF AMENDMENTS	
1A	4.8.03		
L1	24-6-88		
ISSUE	DATE		
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
		DCAN: 5330581614	175.02.033cbCb



DRAWING NUMBER

175 02 133.

▽1



EXPLANATORY NOTE: (L1)

7.a) REFERENCE MATERIAL QUOTED:-

QUALITY CARBON STEEL OF CATEGORY 5, HIGH FINISH ON QUALITY OF SURFACE FINISH, DEEP DRAWN TO GRADE 10 Kn GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH STEEL GRADE 10 Kn TO GOST 1050-74 OPEN HEARTH.

b) REFERENCE NOTE 1 ON ALTERNATIVE MATERIAL:

QUALITY CARBON STEEL OF CATEGORY 5, SUPERIOR FINISH ON QUALITY OF SURFACE FINISH, DEEP DRAWN, TO GRADE 10 Kn GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH STEEL GRADE 10 Kn TO GOST 1050-74 OPEN HEARTH.

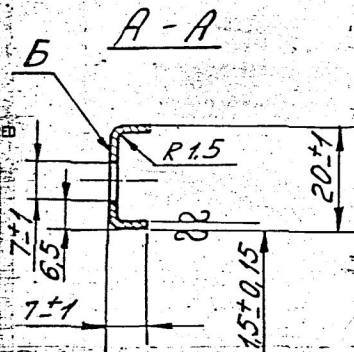
8.a) CHEMICAL COMPOSITION: AS PER STEEL GRADE 10 Kn GOST 1050-74 OPEN HEARTH.

CONTENT OF ELEMENTS %					
C	Si	Mn	Cr	S	P
0.07-0.14	0.07-MAX	0.25-0.50	0.15	0.040	0.035
MAX					

RESIDUAL CONTENT OF COPPER & NICKEL SHOULD NOT EXCEED 0.25% EACH.

b) MECHANICAL PROPERTIES: AS PER STEEL GRADE 10 Kn GOST 16523-70 OF CATEGORY 5, DEEP DRAWN.

TENSILE STRENGTH Kgf/mm ²	ELONGATION %	CUPPING TEST DEPTH OF SPHERICAL HOLE MIN.	BEND TEST 180°
28-40	25	11.2	CLOSE



- MAY BE MANUFACTURED FROM OPEN HEARTH STEEL 10Kn-5-III GOST 16523-70.
- BUCKLING OF SURFACE "b" NOT TO BE MORE THEN 15mm.
- AXIAL DISPLACEMENT OF HOLES AND SLOTS FROM TRUE POSITION NOT TO EXCEED 1mm.
- DEVIATIONS OF DIMENSIONS WITH UNSPECIFIED TOLERANCES ARE ±1.0mm
- AT THE PLACES OF BEND NATURAL THINNING AND PRESSING MARKS ARE ALLOWED.
- THE REST OF THE REQUIREMENTS TO BE IN ACCORDANCE WITH TY 005216-75 (SUPPLEMENT 1)

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

EST. MASS. 0.11 Kg. 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	CHD	TCO	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
				20-1-87	1:1					175 02 133
MATERIAL:- STEEL 10Kn-5-II GOST 16523-70 OPEN HEARTH						USED ON:- 175 02 033 C5		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
TITLE: FRAME						D S CAT NUMBER		DRAWING NUMBER		
L1 24-6-88 EXPLANATORY NOTE ADDED						NATURE OF AMENDMENTS				

COMMON TO BLT

F-13 64

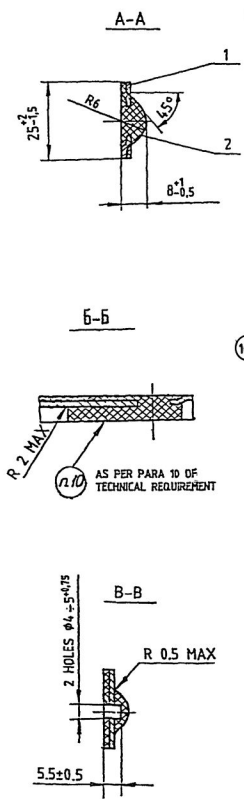
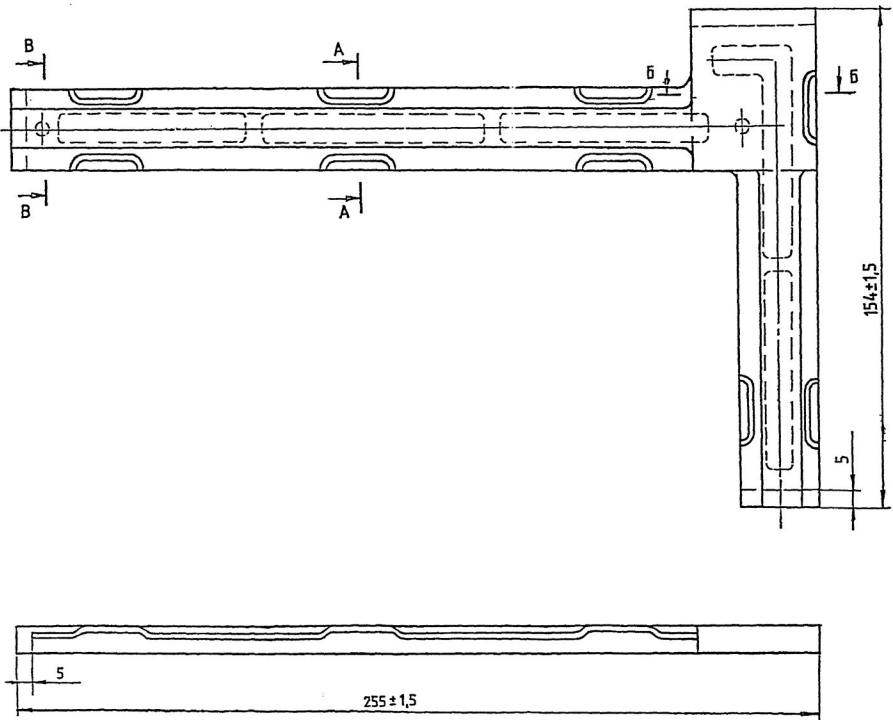
SIZE A3





DRAWING NUMBER
175.02.034cb-1Cb

SHEET No. 1 OF 1



1. Component 2 is to be manufactured from rubber ~~HO-60-1 TY 005216-75~~, NBR + CR (BNC Grade of CQA(HV))
2. Rubber film is allowed on non-rubberized surfaces.
3. Misalignment (skewness) of axes of the mould should not to exceed 1mm.
4. On the surfaces of stamped recesses on both sides as well as on the edges, of stamped recesses at a length and width of not less than 10mm and 1.5mm, respectively, rubber is not allowed. Dressing is permitted.
5. On rubberized surfaces, upto 4 local cavities with diameter upto 4mm and a depth not exceeding 1mm are allowed.
6. Technical requirements on acceptance of the component to be in accordance with ~~TY005216-75~~, code ~~253164~~, NBR + CR (BNC Grade of CQA(HV))
7. It is allowed to round off the corners, radius 1mm, max.
8. Gasket is to be glued by hot glueing process (vulcanizing method) with glue "Leikonat" TY6-14-95-75.
9. Peeling of rubber to a depth upto 4mm is allowed in the area of stamped recesses.
10. Manufacturing factory designation and component number are to be marked in raised characters type no-3 GOST 2930-62.

EXPLANATORY NOTE: (1)

11. REFERENCE NOTE 1 ON MATERIAL FOR ITEM 2, RUBBER GRADE HO 60-1 TY 005 216-75.

PHYSICAL AND MECHANICAL PARAMETERS	
TYPE OF RAW RUBBER	CR-18
RUPTURE STRENGTH	90 Kg/cm ² MIN
ELONGATION OF RUPTURE	250 % MIN
RESIDUAL ELONGATION	12 % MAX
HARDNESS IN CONVENTIONAL UNITS	55 TO 70 (OF TYP)
DENSITY	1.24 ± 0.05 g/cm ³
WORKING TEMPERATURE	-50°C TO +100°C
WORKING MEDIUM	AIR, OILS, LUBRICANTS

DURING USE IT SHOULD WITHSTAND A PRESSURE UPTO 100Kg/cm²

EQUIVALENT MATERIAL: (100)

NBR + CR (BNC Grade of CQA(HV))

COMMON TO T-90 " & BLT
 DRG. RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 10
 (B.JAYAVELUJ, JTOID)
 26 MAR 08

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

EST. WT.	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)	10D	10C	10B	10A	L1
0.11 Kg.		30.09.19	01.07.19	03.09.11	4.8.03	24.6.88
		83201/TECH GEN/EQ.MATL/HVF dt. 25.09.19	83201/Tech Gen/EQ.Mat/HVF dt. 02.04.19	55150/CQA(HV)/DB/BLT T-72 DT. 19.07.11	N OF A No. CQA(HV)/T90/02/001.	EXPLANATORY NOTE ADDED.
	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	ISSUE	DATE	NATURE OF AMENDMENTS		

DRN	Sd / =	MATERIAL:-	USED ON:-
CHD	Sd / =		PV572.0718.0140
APPD	Sd / =		172.02.079Cb-8 (10A) 10B
DATE	20.04.87		188.02.079cbCb
SCALE:-	1:1		
DIMENSIONS IN mm			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69			
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)			
AVADI			
TITLE:-			GASKET
D S CAT NUMBER			
DCAN: 53303816			
DRAWING NUMBER			175.02.034cb-1Cb

F-11
16

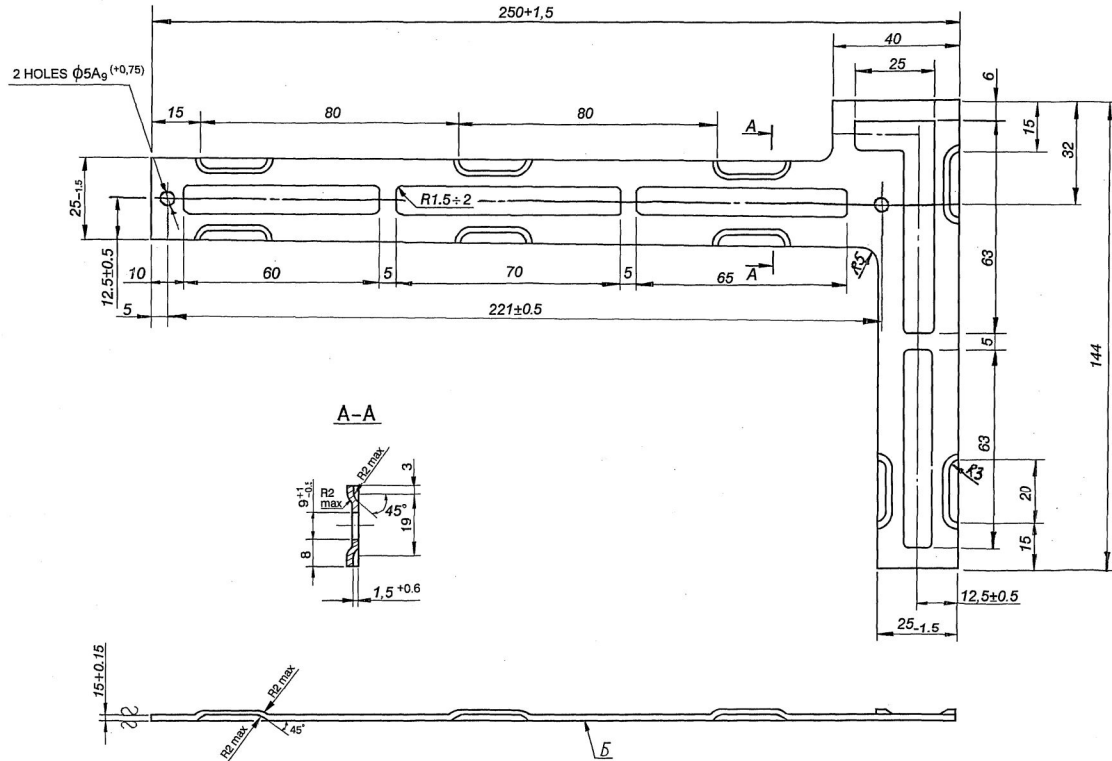
SIZE A2



DRAWING NUMBER
175.02.135-1

SHEET No. 1 OF 1

▽1 (▽)



1. MAY BE MANUFACTURED FROM OPEN HEARTH STEEL 10 Kn-5-III Г GOST 16523-70.
2. NON FLATNESS OF SURFACE "b" NOT TO BE MORE THAN 1.5 mm.
3. DEVIATION FROM DIMENSIONS WITH UNSPECIFIED TOLERANCES ± 1 mm.
4. AT THE PLACES OF STAMPED RECESSES SHRINKAGE OF EDGES NOT TO BE CHECKED.
5. FOLDED CORRUGATION AND TOOL MARKS ON THE SURFACE OF THE COMPONENT ARE ALLOWED.
6. THE REST OF THE REQUIREMENTS IN ACCORDANCE WITH TY 005216-75. (SUPPLEMENT 1).

EXPLANATORY NOTE (L)

- 7a) REFERENCE MATERIAL QUOTED :-
QUALITY CARBON STEEL OF CATEGORY 5, HIGH FINISH ON QUALITY OF SURFACE FINISH, DEEP DRAWN TO GRADE 10 KPI GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH STEEL GRADE 10 KPI GOST 1050-74 OPEN HEARTH.
- b) REFERENCE NOTE 1 ON ALTERNATIVE MATERIAL :-
QUALITY CARBON STEEL OF CATEGORY 5, SUPERIOR FINISH ON QUALITY OF SURFACE FINISH, DEEP DRAWN TO GRADE 10 KPI GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH STEEL GRADE 10 KPI TO GOST 1050-74 OPEN HEARTH.
- 8a) CHEMICAL COMPOSITION: AS PER STEEL GRADE 10 KPI GOST 1050-74 OPEN HEARTH.

CONTENT OF ELEMENTS %						
C	Si	Mn	Cr	S	P	MAX
0.07-0.14	0.07-MAX	0.25-0.80	0.15	0.040	0.035	

- b) MECHANICAL PROPERTIES: AS PER STEEL GRADE 10 KPI GOST 16523-70 OF CATEGORY 5, DEEP DRAWN.

TENSILE STRENGTH Kg/mm ²	ELONGATION %	CUPPING TEST DEPTH OF SPHERICAL HOLE MIN	BEND TEST 180°
28-40	25	11.2	CLOSE

R. BALAKRISHNAN
JTD(D)

COMMON TO T-90 & BLT
INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE -

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

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

0.08 Kg

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

DRN	Sd/=	MATERIAL :-	USED ON :-
CHD	Sd/=	STEEL 10Kn-5-II Г	175.02.034 Cb-1
APFD	Sd/=	GOST 16523-70 OPEN HEARTH	
DATE	20-01-87	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE:-	1 : 1	AVADI	
DIMENSIONS IN mm		TITLE :-	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69			FRAME
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
			175.02.135-1
L1	24.6.88	EXPLANATORY NOTE ADDED	
ISSUE	DATE	NATURE OF AMENDMENTS	

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65
SIZE A2



