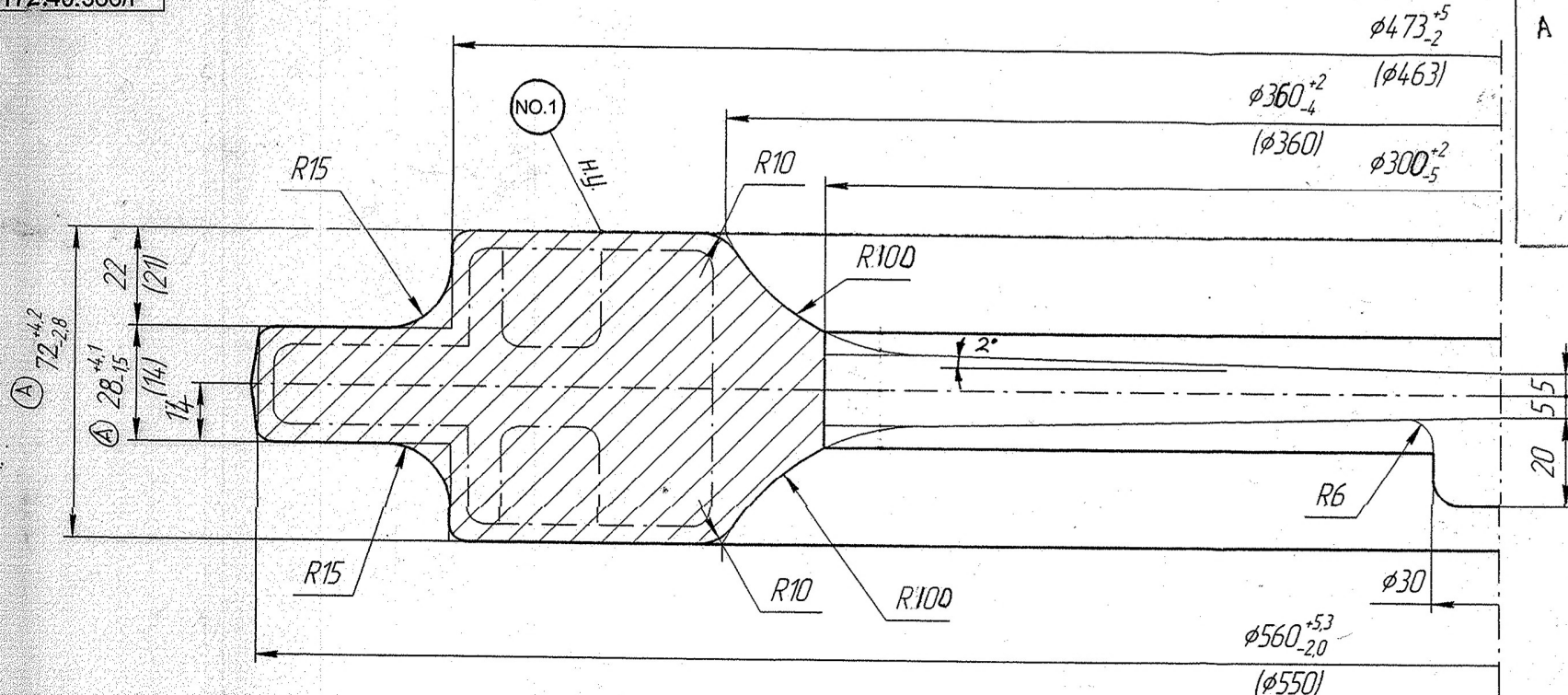


- 1 255 302HB
 2 Материал-заменитель детали поз 1 - сталь 30ХТСА ГОСТ 4543-71
 3 Допускается вместо полирования поверхностей любой вид обработки с обеспечением шероховатости Ra=1,6 мкм
 4 Допуск овальности поверхностей Ж и Р 0,025 мм
 5 Взаимное расположение пазов Н и отверстий П относительно системы отверстий, расположенных на диаметре М произвольное
 6 По 60-1 или ПК 62-0,5 ГОСТ 16130-90 Допускается сварка дуговая в среде защитных газов
 7 Допускается размер Ц выполнять $\phi 35,9 \pm 0,09$ мм
 8 На поверхностях У (4 паз) допускается уступ $0,2 \pm 0,3$ мм
 9 После обработки заглавок масляные каналы испытать на герметичность маслом, применяемым в трансмиссии, или дизельным топливом давлением (2,5±0,1) МПа [(25±1) кгс/см²] в течение 5 мин Течь не допускается
 10 *Размеры для справок
 11 *Размеры и шероховатость обеспечить инструментом
 12 Покрытие Хим Фос окс окр
 13 Измерение и испытание твердости проводить на участке, ограниченном размерами Ж и Ч
 14 Остальные требования по 520 Т31

1. BH 255... 302
 2. Alternative material for component item 1- steel 30X/CA ГОСТ 4543-71.
 3. Instead of lapping of surfaces, any type of machining with ensuring of surface finish Ra= 1.6 microns may be carried out.
 4. Tolerance for ovality of surfaces Ж and P should be 0.025 mm.
 5. Relative positioning of sites H and П relative to the holes, located on the diameter M, is Optional.
 6. По 60-1 or/и ПК 62-0.5 ГОСТ 16130-90. Arc welding in gas shielded medium maybe carried out in the area of welding of plugs, rough spots and reduction of dimension Ж upto 0.25 mm is permitted on the arc with length not exceeding 70 mm
 7. Dimension Ц may be maintained $\phi 35,9 \pm 0,09$ mm
 8. On the surfaces У (4 slots), shoulder $0,2 \pm 0,3$ mm is permitted.
 9. After brazing the plugs, they of ducts should be tested for air-tightness with oil used in the transmission oil or with diesel at a pressure of 2.5 ± 0.1 Mpa [(25 ± 1) kgf/cm²] for 5 minutes. Leakage is not allowed.
 10. *Dimensions are for reference.
 11. *Dimensions and surface finish should be ensured with the tool.
 12. Coating : chemical phosphating coating of finish.
 13. Stamping and testing of hardness should be done in the section, limited by dimensions Ж and Ч.
 14. Remaining requirements are as per 520.T31.

DATE	BY	CHECKED	APPROVED	MATERIAL	USED ON
1972.05.01	И.И.И.	И.И.И.	И.И.И.	172.40.064cCb	
				CONTROLLETS OF QUALITY ASSURANCE (HEAVY VEHICLES)	
				AVADI	
				TITLE: STOPPING BRAKE HOUSING (RIGHT-HAND) ASSY.	
				D.S. CAT NUMBER	DRAWING NUMBER
					172.40.064cCb

DRAWING NO.
172.40.366/F



ISS.	MODIFICATION	DATE
A	72 ^{+4.2} -2.8 THICKNESS DIMN. WAS 70 ^{+4.2} -2.8 28 ^{+4.1} -1.5 DIMN. WAS 26 ^{+4.1} -1.5 NOTE ADDED. REF. JWM/TRANS/HY NO. 07271/TRANS/ MATL. PLN. /AU/07 DE 07.05.07	31.5.07

TECHNICAL REQUIREMENTS

- | | |
|--|---|
| 01. MARK CODE OF SHOP IN-CHARGE. | 08. PROJECTION DUE TO DEBURRING - UPTO 2.4 MM. |
| 02. < 256 HB. | 09. CONTINUOUS OR STAMPED BURR ALONG THE CONTOUR OF FORGING AND IN THE HOLE MAY BE ALLOWED. |
| 03. DESCALES (SHOT BLASTING) | 10. IT MAY BE MADE OUT OF STEEL 38XC, IN THIS CASE MARK THE GRADE OF STEEL CONVENTIONALLY AS "X". |
| 04. SURFACE DEFECTS IN DEPTH UPTO 0.5 OF ACTUAL MACHINING ALLOWANCE. | 11. STAMPING DRAFTS - 7° |
| 05. DISPLACEMENTS (SHIFT OF AXES OF DIES) UPTO 1.8 MM. | 12. UNSPECIFIED FILLET RADII - R 4. |
| 06. ECCENTRICITY OF BROACHED HOLE UPTO 3.0 MM. | 13. DIMENSIONS WITHOUT TOLERANCES NOT TO BE CHECKED. |
| 07. WARPAGE UPTO 3.0 MM. | 14. PAINT RED OXIDE. |

NOTE: FORGING IS COMMON FOR
T-90 COMPT. NO. 172.40.367/F

T 90

MATERIAL	FORGING WT.		
30XGCA GOST 4543-71	67.0 KGS		
ALT. MATERIAL	HAMMER	SCALE	
38XC GOST 4543-71	EK-32	NTS	
DRAWN	CHECKED	APPROVED	
<i>h. Bujko</i> 11/10/03	<i>[Signature]</i>	<i>[Signature]</i>	
DRAWING NO. 172.40.366/F		NOMENCLATURE: R.H STOPPING BRAKE BODY	
HEAVY VEHICLES FACTORY AVADI, CHENNAI			

MACHINED COMPONENTS (GROUP -IV)

Sl No	LF No	Drawing No	Nomenclature
1	6106401050	172.40.146	RING ENGAGING EXTREME RIGHT
2	6106401051	172.40.147	INITIATING RING MIDDLE R.H
3	6106401052	172.40.148	ENGAGING RING EXTREME LH
4	6106401053	172.40.149	ENGAGING RING MIDDLE, LH
5	6106401065	172.40.225	RELEASE RING III FRICTION CLUTCH
6	6101040031	172.40.225-1	3RD FRICTION CLUTCH RELEASING RING
7	6106401068	172.40.229	BOOSTER INNER
8	6106401070	172.40.231	BOOSTER
9	6106401071	172.40.232	BOOSTER
10	6106401084	172.40.246	EPICYCLE OF TRAIN IV
11	6106401085	172.40.247	GEAR CROWN 3RD PLANETARY GEAR SET
12	6106401096	172.40.270	BOOSTER
13	6101040033	172.40.270-1	BOOSTER
14	6106401097	172.40.271	CROWN
15	6106401098	172.40.308	DISCHARGE RING
16	6101040041	172.40.308-1	RELEASE RING
17	6101040042	172.40.309	CROWN GEAR OF 2ND PLANETARY GEAR SET
18	6101040043	172.40.310	CROWN GEAR OF 3RD PLANETARY GEAR SET
19	6101040044	172.40.311	EPICYCLIC GEAR OF 4TH PLANETARY SET
20	6101040052	172.40.319	DRUM
21	6101040053	172.40.320	CROWN
22	6101040054	172.40.321	BOOSTER
23	6101040055	172.40.322	INNER BOOSTER
24	6101040056	172.40.323	INNER BOOSTER
25	6101040057	172.40.324	BOOSTER
26	6101040059	172.40.326	THRUST DISK
27	6101040061	172.40.328	RIGHT HAND REAR ENGAGING RING
28	6101040062	172.40.329	RIGHT-HAND MIDDLE ENGAGING RING
29	6101040063	172.40.330	LEFT HAND REAR ENGAGING RING
30	6101040064	172.40.331	LEFT-HAND MIDDLE ENGAGING RING
31	6101040108	172.40.366	STOPPING BRAKE HOUSING (RIGHT-HAND)
32	6101040109	172.40.367	STOPPING BRAKE HOUSING (LEFT-HAND)
33	6106404014	172.43.008	PACKING COVER
34	6106401118	175.40.021	HOUSING OF MAIN BRAKE RH
35	6106401119	175.40.022	HOUSING OF MAIN BRAKE L
36	6106401120	175.40.023	BOOSTER INNER
37	6106401127	175.40.025	CROWN GEAR OF 2ND PLANETARY GEAR SET
38	6106401128	175.40.026	DRUM
39	6106401126	175.40.027-2	BOOSTER OUTER
40	6106401131	175.40.030-1	BOOSTER
41	6106401132	175.40.031	THRUST DISC
42	6106401146	175.40.052	BOOSTER BODY RIGHT
43	6106401147	175.40.053	HOUSING LH BOOSTER
44	6106402034	175.41.050	HUB FAN STEEL 38XC
45	6106402035	175.41.051	PLATE PRESSURE
46	6106406229	175.45.112	TOOTHED COUPLING
47	6101041013	188.41.006	FAN HUB

MACHINED COMPONENTS (GROUP -IV)

Sl no.	Nomenclature & drawing No.	Manufacturing technology & Testing / Inspection Facilities required to produce the item		Must be possessed by the vendor in his premises (P&M list and testing / inspection equipment list to be submitted)	May be possessed by the vendor in his premises or out sourced (Self declaration to be submitted)	FIRM Compliance (Y/N)	Remarks
1	Components as per enclosed list of Machined Components (Group IV) <i>Total items = 47 Nos</i>	TECHNOLOGY-1	Turning	CNC Turning dia 600mm suitable to accommodate component of diameter in the range of dia 250 to 600mm with 0.010mm accuracy			
			Milling & Drilling	HMC and/or VMC suitable to the components upto the size 630mm diameter with 0.010 accuracy			
			Gear Hobbing		Gear Hobbing of Mod 3 x cutting ϕ 400 with gear cutting accuracy of class of Din 7 or better accuracy		
		TECHNOLOGY-3	Gear Shaping		Gear Shaping of Mod 5 with gear cutting accuracy of class of Din 7 or better accuracy.		
			Hardening & Tempering		Hardening & Tempering furnace with Oil quenching facility		
			Protection coating		Oxidising Plant		
		TECHNOLOGY-4	Raw material		Firm should be capable to arrange the raw material like Forging, Casting, Bar material etc as per drawing specification and standard.		

Sl no.	Nomenclature & drawing No.	Manufacturing technology & Testing / Inspection Facilities required to produce the item		Must be possessed by the vendor in his premises (P&M list and testing / inspection equipment list to be submitted)	May be possessed by the vendor in his premises or out sourced (Self declaration to be submitted)	FIRM Compliance (Y/N)	Remarks
1	Components as per enclosed list of Machined Components (Group IV)	TEST / INSPECTION-1	3D CMM	3D CMM 500 x 500mm.			
			Gear Profile Tester		Gear Profile Tester (Max module 5)		
			Surface Roughness Tester	Surface Roughness Tester for Ra & Rz values			
			Gauges	Standard Gauges for checking Holes and threads suitable to the requirement of the components. Firm should submit the undertaking in this regard that they will create the facilities within 6 months from the date of receipt of order.			
			Measuring Instruments	Gear Teeth Micrometer, Vernier Caliper, Groove Vernier, Radius gauge, Feeler Gauge etc. suitable to the requirement of the components			
		TEST / INSPECTION-2	Hardness measurement		Brinell / Rockwell Hardness Tester		

Note : Justification for alternate facilities may be shared to prove that alternate facilities can be utilised to manufacture the item wherever the facilities are mentioned above are not available, but vendor has alternate facilities.