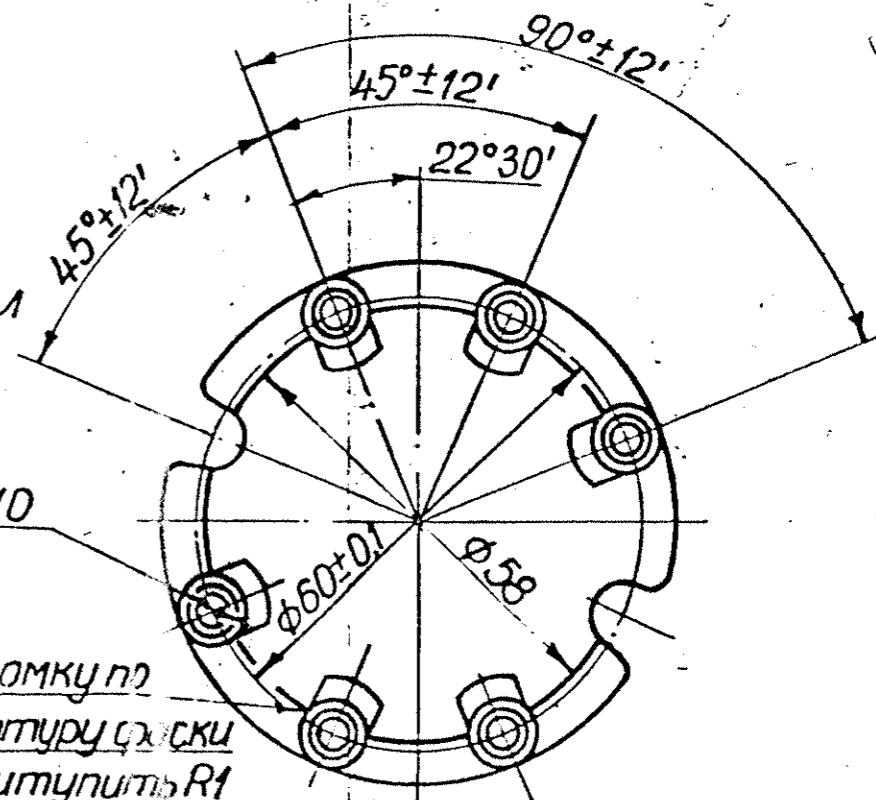
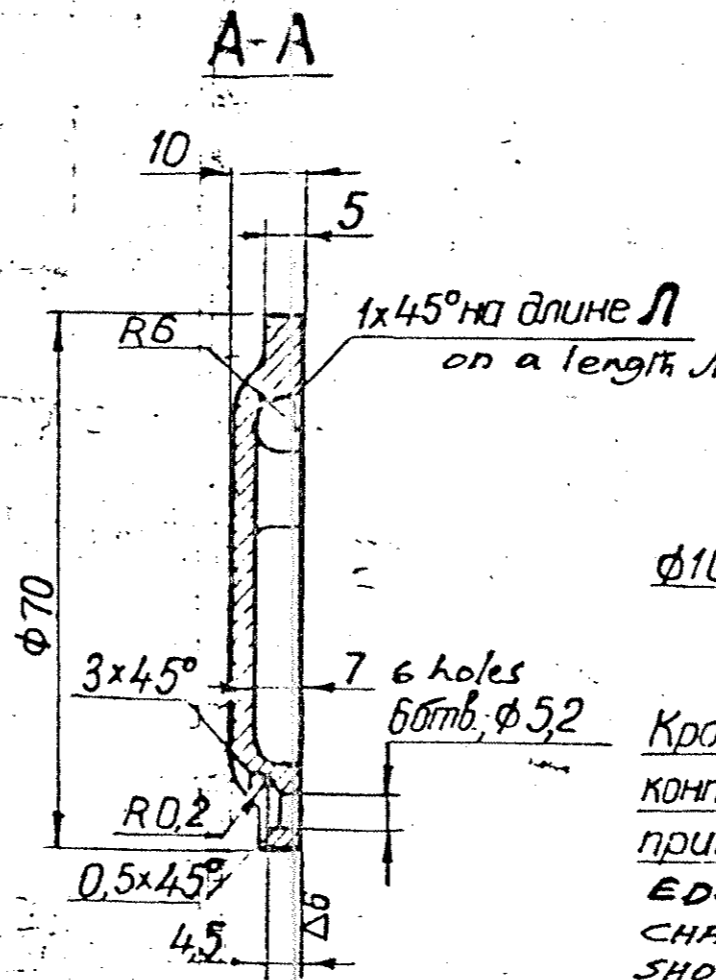
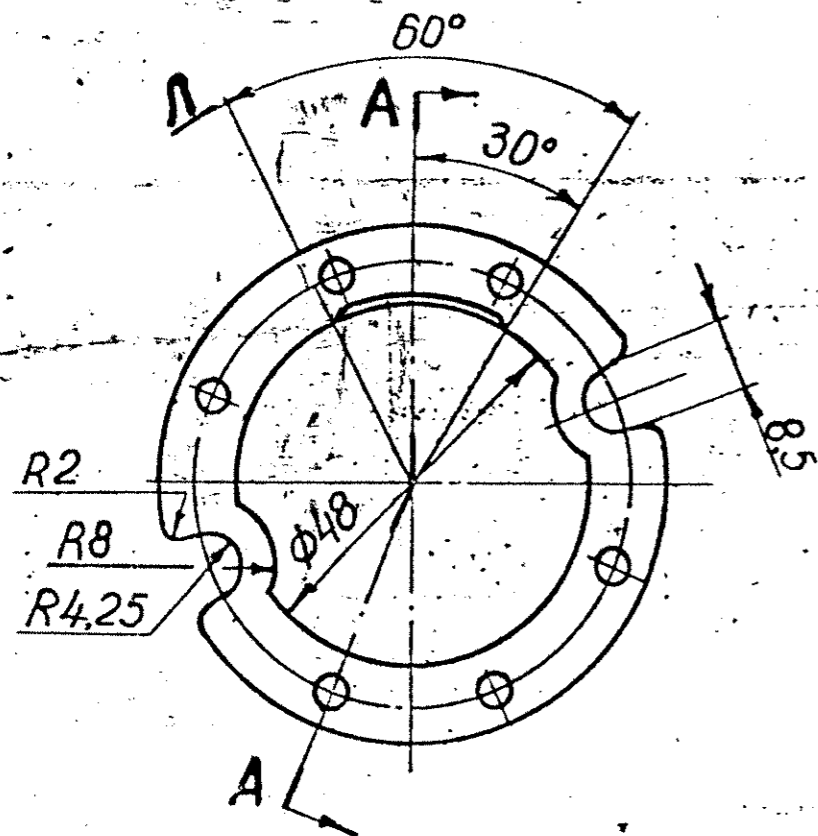


DRAWING NUMBER
AK 150H-007

ОСТАЛЬНОЕ SPECIFIED.

Допуски на литье по 56-15 (АН 1026-55)
Допуски на свободные размеры по 22АТ52-7кп.

③ пред. откл. размеров отливки по ОСТ 1.41154-72
LIMIT DEVIATIONS ON CASTING DIMENSIONS AS PER OST 1.41154-72.



Кромку по контуру отливки притупить R1
EDGE ALONG CHAMFER CONTOUR SHOULD BE BLUNTED TO R1.

4. Анодировать.

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

1. DIE CASTING ACCURACY CLASS $\int_T 2$.
2. UNSPECIFIED RADIUS TRANSITIONS IN CASTING SHOULD BE PERFORMED.
3. THE INNER CAVITY SHOULD BE CHECKED FOR TIGHTNESS UNDER THE AIR PRESSURE OF 2 kg/cm^2 . AIR LEAKAGE IS NOT ALLOWED.
4. TO BE ANODIZED.

		PST. MASS 46.3	TO BE STAMPED OR MARKED WHERE INDICATED THIS ϕ (LETTERS)
		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	MATERIAL - ALUMINIUM ALLOY AN9, OST 190021-71.	USED ON - AK 150C-01C5
DRN	SCALE - 1:1	CONTR. (STATE OF INSPECTION (HEAVY VEHICLES) AVADL	
END	DIMENSIONS IN mm.	TITLE - CAP	
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	B S CAT NUMBER	
APPD	ALL THREADS CONFORM TO	DRAWING NUMBER AK 150H-007	
DATE 28/76			

DRAWING NUMBER
AK150H-15-C6

TOLERANCES ON FREE DIMENSIONS ARE AS PER 22 AT 52-cl.7.

GROOVE HAVING WIDTH OF UPTO 1.0 mm DEPTH OF UPTO 0.1 mm. OVER DIAMETER IS ALLOWED ON SURFACE D₂ NEAR TAPER. HEAT PART AK150H-054 UPTO A TEMPERATURE OF 220°C BEFORE PRESS FITTING PART AK150B-088.

BEFORE PRESSING, COAT SURFACE OF PART AK150B-088 WITH UNIFORM LAYER OF BAKELITE VARNISH OR VARNISH K 965, GOST 15030-69, AS PER TECHNOLOGICAL INSTRUCTIONS. CHECK SURFACE K BY BLUEING. CLOSE-FIT AS PER GAUGE SHOULD BE AT LEAST 75%.

DIFFERENCE OF ANGLES IN GAUGES USED FOR CHECKING TAPERS OF PARTS AK150H-15 AND AK150B-30 SHOULD NOT EXCEED 20'. RUN-OUT OF SURFACE D₃ AND D₄ WITH RESPECT TO CORRESPONDING ANGLE DIAMETERS OF THREADS M₁ AND M₂ SHOULD NOT EXCEED 0.1mm. RUN-OUT OF SURFACE D₁ WITH RESPECT TO SURFACE D₂ SHOULD NOT EXCEED 0.02 mm.

DEVIATION FROM SQUARENESS OF SURFACE D₂ TO SURFACE T SHOULD NOT EXCEED 0.03 mm.

DIFFERENCE IN WALL THICKNESS OF SLEEVE SHOULD NOT EXCEED 0.1 mm. OVALITY,

CONCAVITY AND CONVEXITY OF SURFACES D₁ AND D₂ SHOULD NOT EXCEED 0.005 mm.

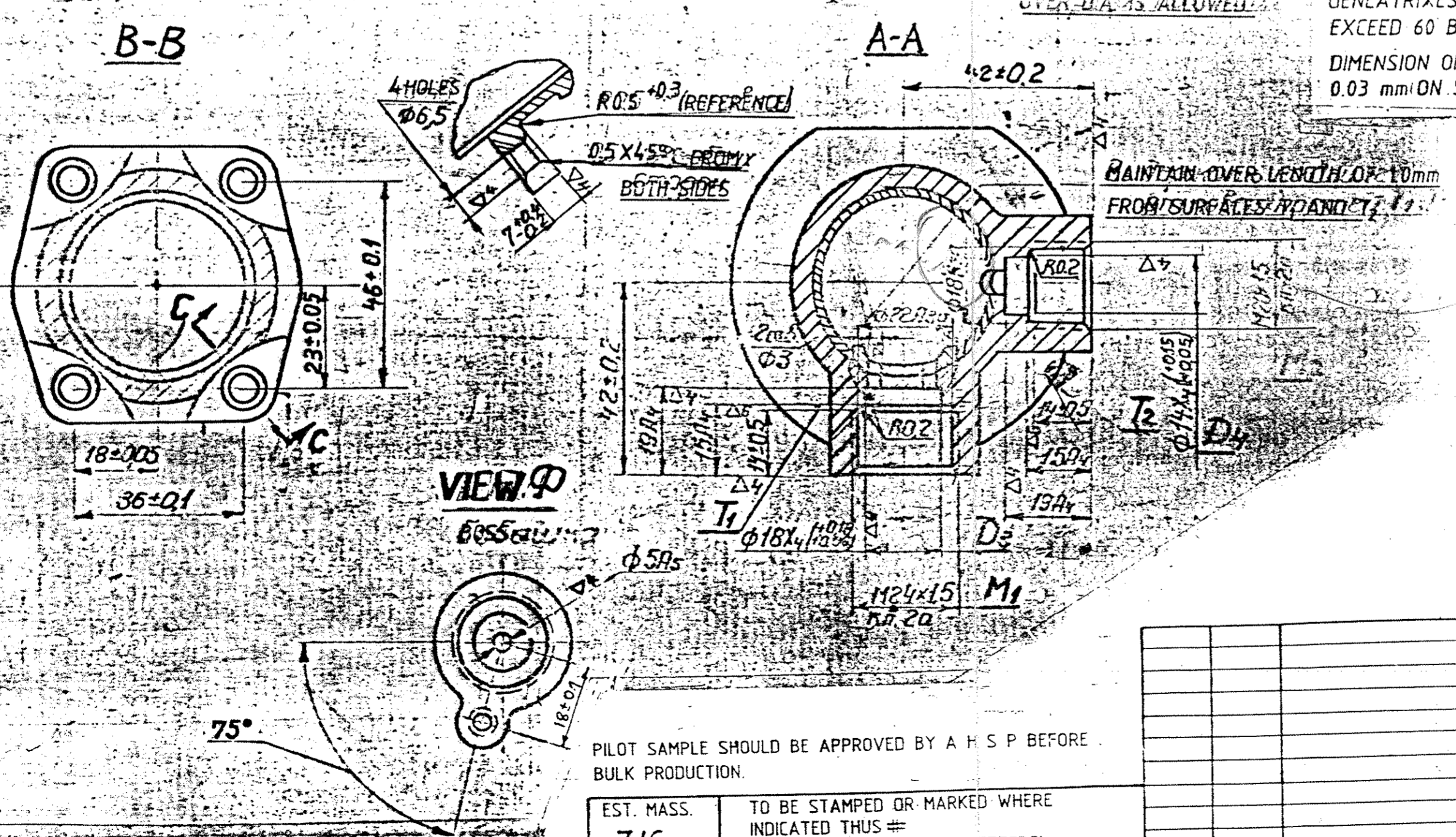
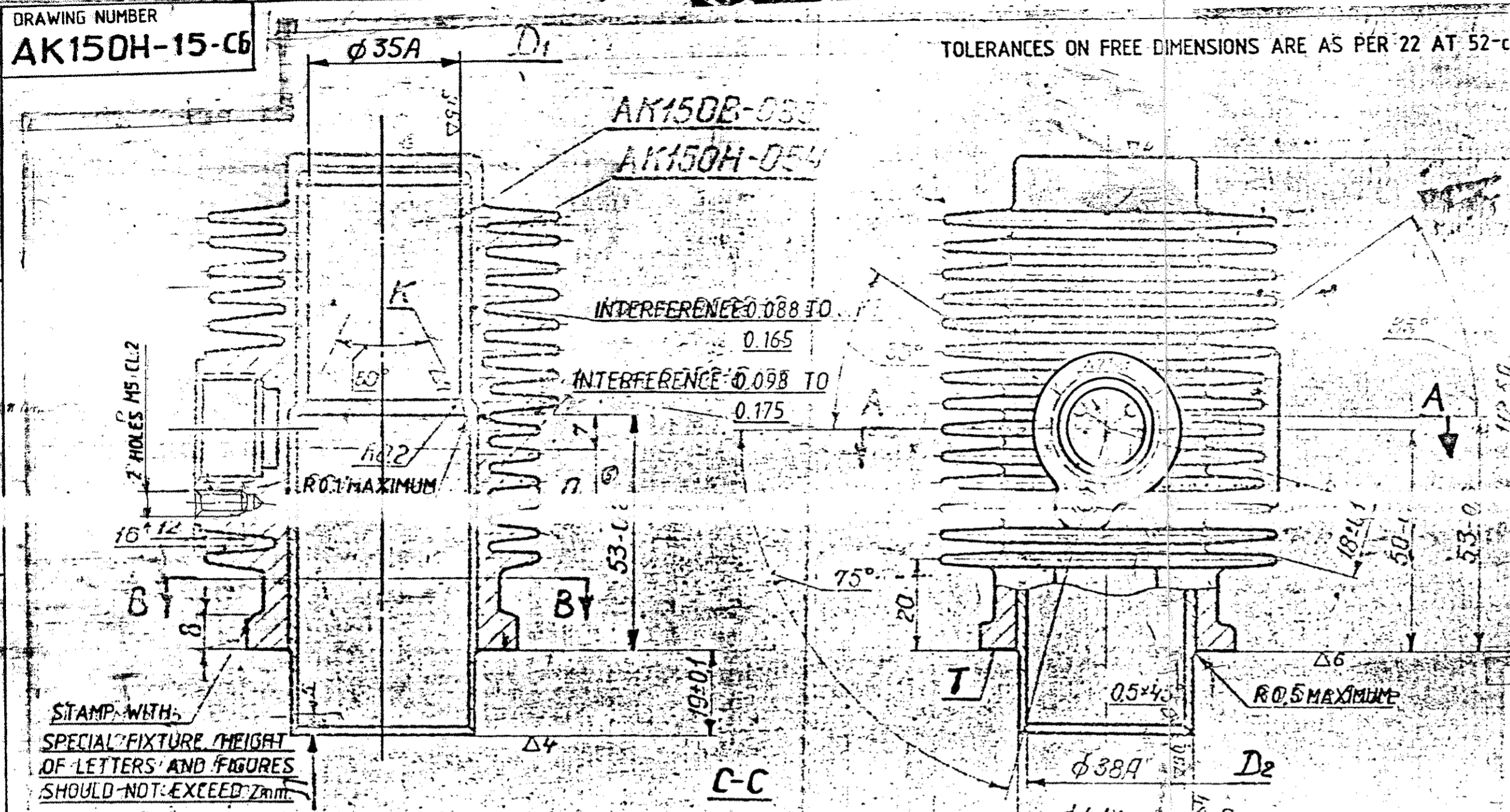
TAPER SHOULD NOT EXCEED 0.01 mm. LOBBING IS NOT ALLOWED.

OVALITY AND TAPER NOT EXCEEDING 0.03 mm ARE ALLOWED ON SECTION 2. MAKE CHAMFERS TO DEPTH OF THREAD AT AN ANGLE OF 90°.

CHECK NON-FLATNESS OF SURFACE T WITH TOOL MAKER'S STRAIGHT EDGE. CLEARANCE OF UPTO 0.03 mm IS ALLOWED. CHECK AIR TIGHTNESS BY AIR AT A PRESSURE OF 150 kg/cm². AIR LEAKAGE ALONG GENERATRICES OF SURFACES WITH MEDIUM DRIVE FIT SHOULD NOT EXCEED 60 BUBBLES PER MINUTE.

DIMENSION OF SURFACE D₂ MAY BE REDUCED BY NOT MORE THAN 0.03 mm ON SECTION J.

AIR LEAKAGE THROUGH CAST SURFACE IS NOT ALLOWED. TOTAL



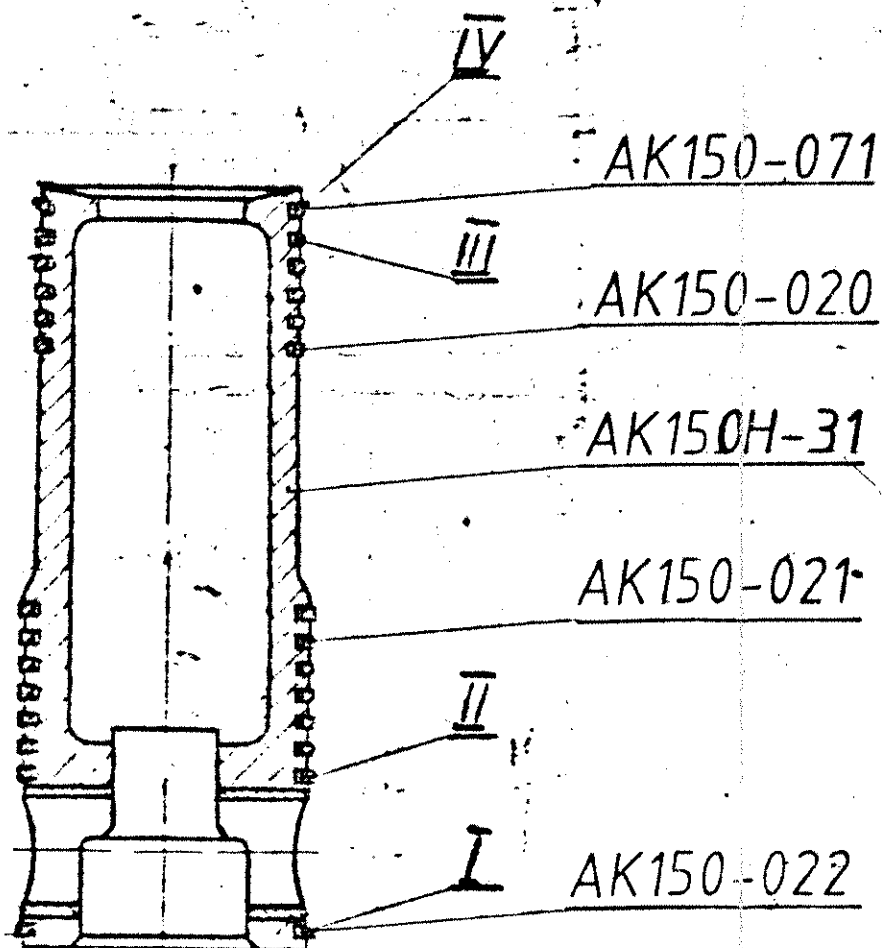
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. MASS. 716 TO BE STAMPED OR MARKED WHERE INDICATED THIS # 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	G. Narayana	MATERIAL	USED ON:- AK 150 C - 01 C6
CHD	Abhathacharya		
TCD	...		
APPD	...	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)	AVADI
DATE	22.7.80		
SCALE	1:1		
DIMENSIONS	IN mm	TITLE: CYLINDER III STAGE ASSY	
TOLERANCE	ON DIMNS UNLESS OTHERWISE STATED	D S CAT NUMBER	DRAWING NUMBER AK150H-15-C6
ALL THREADS	CONFORM TO		
ISSUE	DATE	NATURE OF AMENDMENTS	

AK 150H-32CB



INDEX OF ARTICLE	NO. OF PART AND POSITION OF RING			
	I	II	III	IV
AK150MK	AK150-022 WITH TAPER UP	AK150-022 WITH TAPER UP	AK150-071 WITH TAPER DOWN	AK150-071 WITH TAPER DOWN

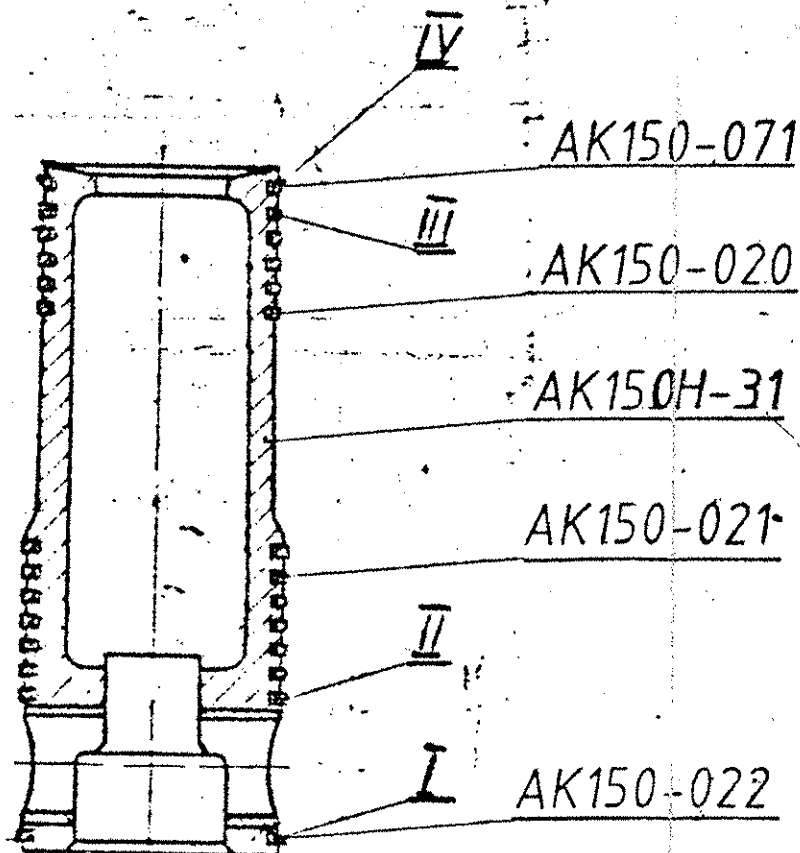
ARRANGE RING JOINTS AT 180° WITH RESPECT TO EACH OTHER.

IT IS ALLOWED TO PLACE ONE OR TWO RINGS AK150-022 WITH TAPER UP AND ONE RING AK150-071 WITH TAPER DOWN FOR COMPRESSORS AK150 MB, MA B AND MA2B IF OIL EJECTION EXCEEDS THE RATING.

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

EST. MASS.		TO BE STAMPED OR MARKED WHERE INDICATED THIS #	
141		LETTERS)	
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 2.10.86		SCALE - 1:1	MATERIAL:-
CD 2.10.86		DIMENSIONS IN mm	USED ON:- AK 150C 01CB
TLD 6.10.86		TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPD 11.10.86		ALL THREADS CONFORM TO	TITLE: PISTON 3rd STAGE ASSY
DATE 22.7.86			D S CAT NUMBER
			DRAWING NUMBER AK 150H-32CB

AK 150H-32CB



INDEX OF ARTICLE	NO. OF PART AND POSITION OF RING			
	I	II	III	IV
AK150MK	AK150-022 WITH TAPER UP	AK150-022 WITH TAPER UP	AK150-071 WITH TAPER DOWN	AK150-071 WITH TAPER DOWN

ARRANGE RING JOINTS AT 180° WITH RESPECT TO EACH OTHER.

IT IS ALLOWED TO PLACE ONE OR TWO RINGS AK150-022 WITH TAPER UP AND ONE RING AK150-071 WITH TAPER DOWN FOR COMPRESSORS AK150 MB, M2B AND M2B IF OIL EJECTION EXCEEDS THE RATING.

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

EST. MASS.		TO BE STAMPED OR MARKED WHERE INDICATED THUS #	
141		(LETTERS)	
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	MATERIAL:-	USED ON:-
DRN 2.10.86	SCALE - 1:1	-	AK 150C 01CB
APPD 22.7.86	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
DATE	ALL THREADS CONFORM TO	TITLE: PISTON 3rd STAGE ASSY	
22.7.86		D S CAT NUMBER	DRAWING NUMBER AK 150H-32CB

DRAWING NUMBER

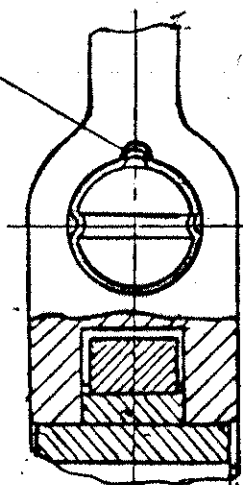
AK 150H -38 CB

VIEW A

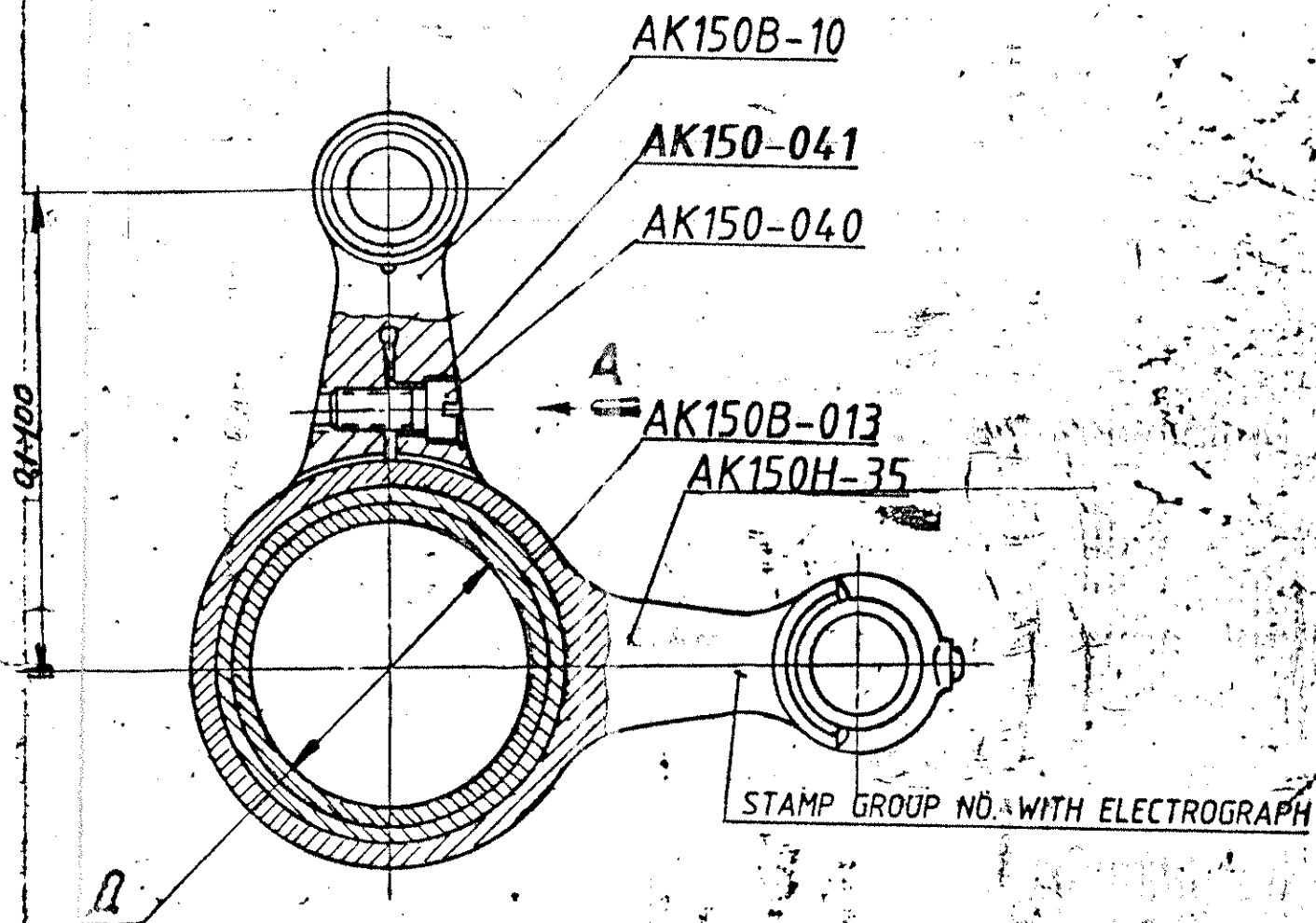
SCALE 2:1

50

SECURE DURING ASSEMBLY.



0.4 ± 0.15



DIMENSION	NO. OF GROUP	STAMP OF GROUP
φ41 +0.013	I	o
φ41 +0.027 -0.014	II	o o

ENSURE TIGHT FIT OF PARTS AK150B-013 AND AK150B-10 BY TIGHTENING PART AK150-040.

OVALITY OF SURFACE A SHOULD NOT EXCEED 0.02.

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

EST. MASS. 278.2 TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

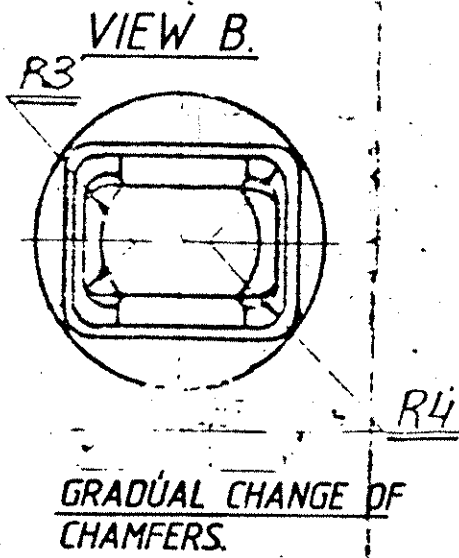
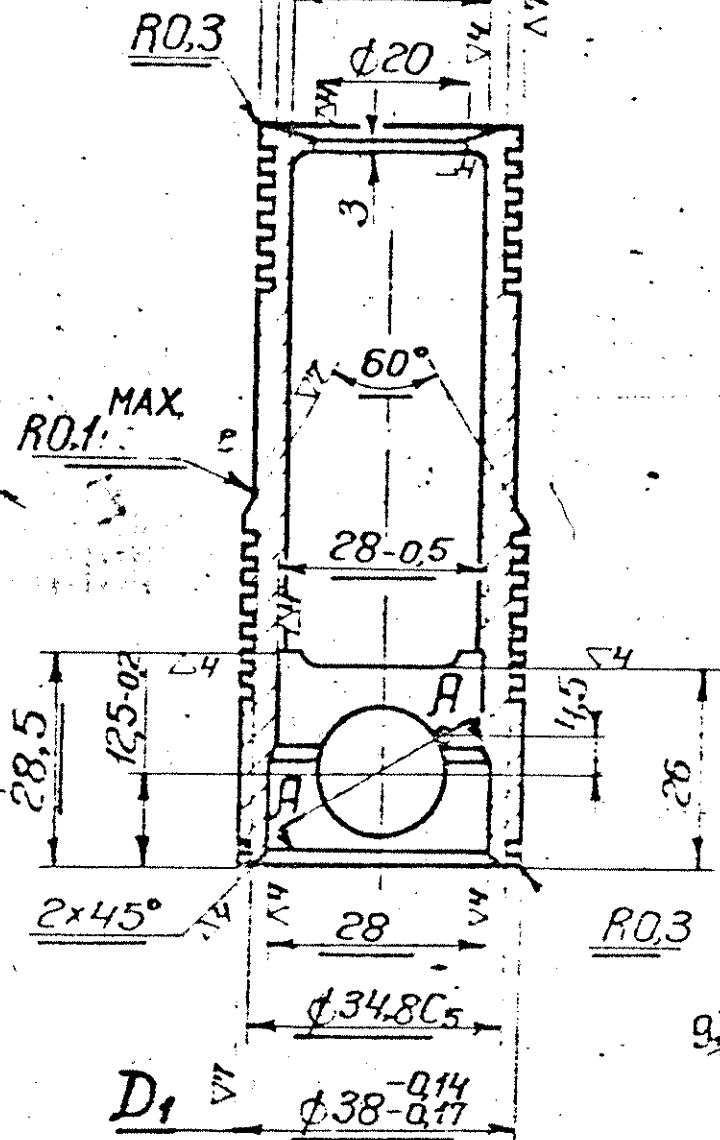
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	<i>du</i>	MATERIAL :-	USED ON: AK150C-52CB
CHD	<i>Bhatalia</i>		
TCD	<i>...</i>		
APPD	<i>...</i>		
DATE	22.7.88	CONTROLLER OF INSPECTION (HEAVY VEHICLES)	AVADI
SCALE	1:1		
DIMENSIONS IN mm		TITLE:	CONNECTING RODS ASSY.
TOLERANCE ON DIMS UNLESS OTHERWISE STATED.		D S CAT NUMBER	DRAWING NUMBER AK150H-38 CB
ALL THREADS CONFORM TO			
ISSUE	DATE	NATURE OF AMENDMENTS	

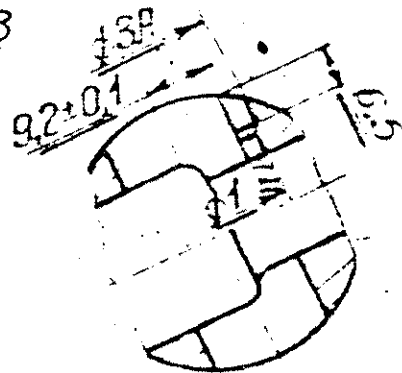
157

DRAWING NUMBER
AK 150H 088

D_2 $\phi 35^{-0.19}$
 $\phi 31.7C_5$
 $\phi 26$
 $\phi 20$



A-A



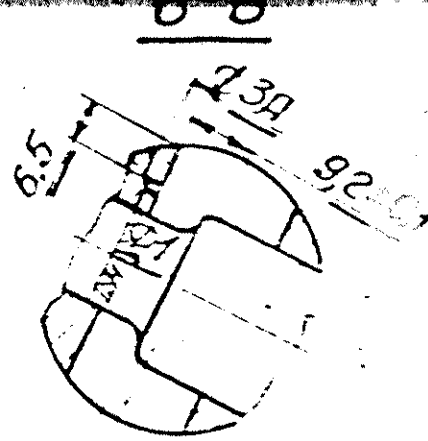
DIMENSION D_3	GROUP
$\phi 17A$	I
$\phi 17,1A$	II
$\phi 17,2A$	III

DIMENSIONS, WHICH ARE UNDERLINED WITH SHOULD BE PROVIDED IN UNIT AK 150 H - 31

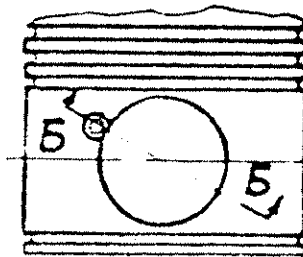
RUN-OUT OF SURFACE D_1 WITH RESPECT TO D_2 SHOULD NOT EXCEED 0.02.

NON-SQUARENESS OF SURFACE D_3 WITH RESPECT TO D_1 SHOULD NOT EXCEED 0.015 OVER LENGTH 20.

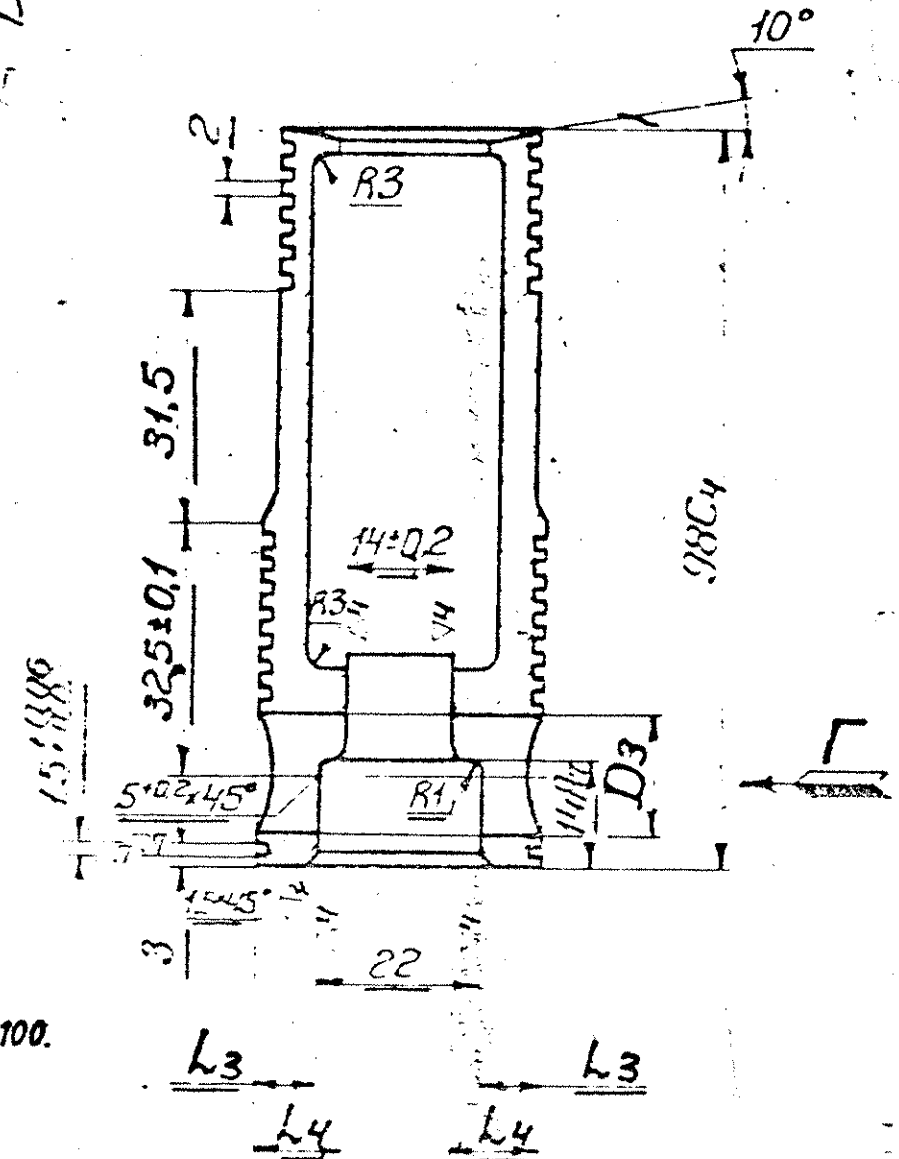
6 UNLESS SPECIFIED OTHERWISE.
TOLERANCE ON FREE DIMENSIONS ARE AS PER 22AT52-7th CLASS.



VIEW 1



HARDNESS HB \geq 100.



DISPLACEMENT OF AXIS ϕD_3 WITH RESPECT TO AXIS ϕD_1 SHOULD NOT EXCEED 0.05.

DO NOT BLUNT SHARP EDGES ALONG EXTERNAL SURFACES

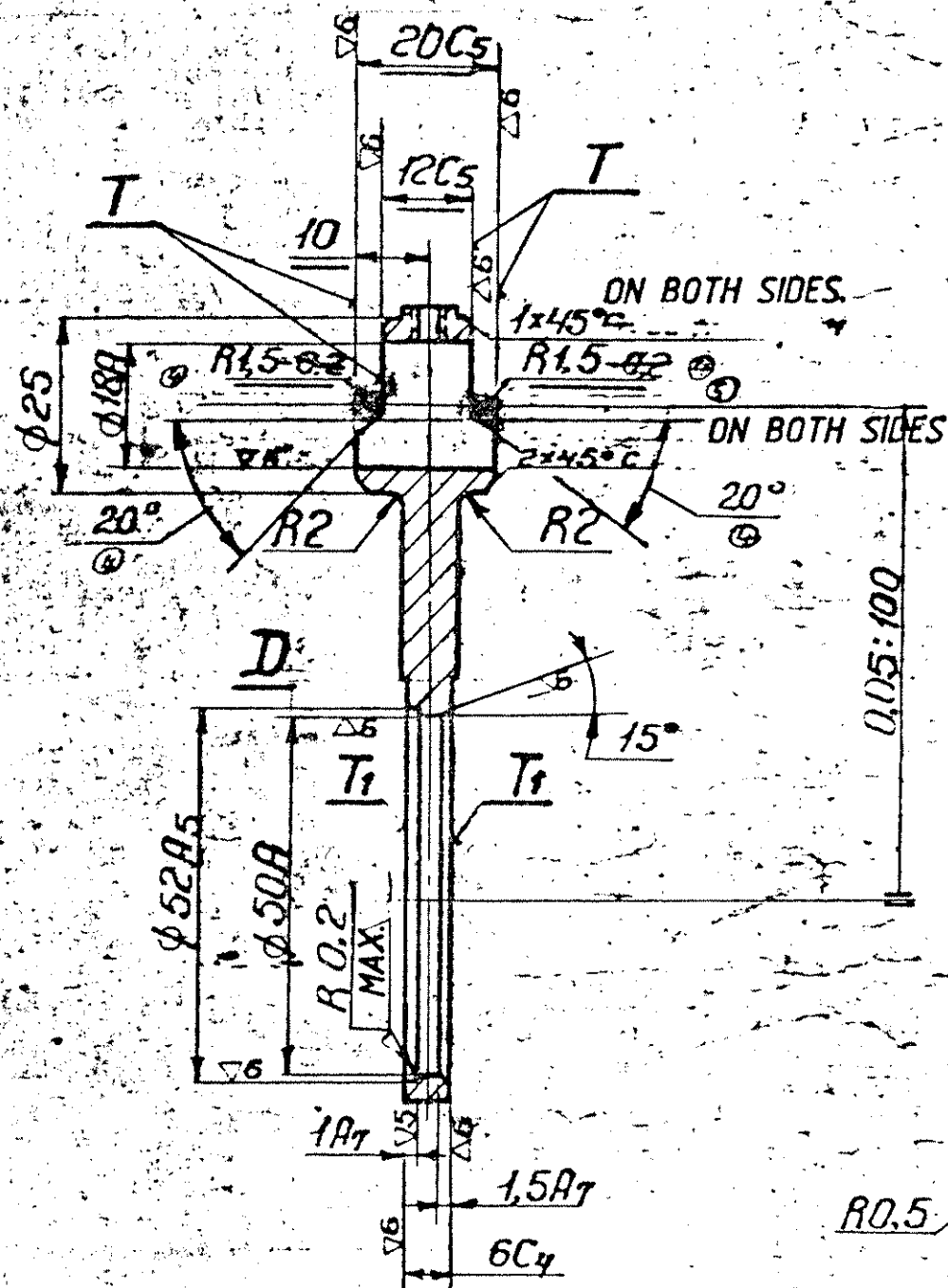
DIFFERENCE IN DIMENSIONS L_3 AND L_4 SHOULD NOT EXCEED 0.1.

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

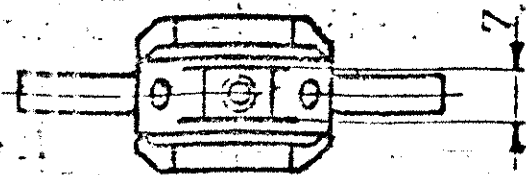
		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS Φ (LETTERS)
ISSUE DATE	NATURE OF AMENDMENTS	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
DRN h. P. M. S.	SCALE:-	MATERIAL:-	USED ON:-
CHO B. P. M. S.	DIMENSIONS IN mm	ALUMINIUM ALLOY B95T1 GC3T 91488-76	AK 150H - 31 CB
TCD h. P. M. S.	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APFD h. P. M. S.	ALL THREADS CONFORM TO	TITLE:	PISTON III rd STAGE
DATE 22.7.86		D S CAT NUMBER	DRAWING NUMBER AK 150H - 088

162

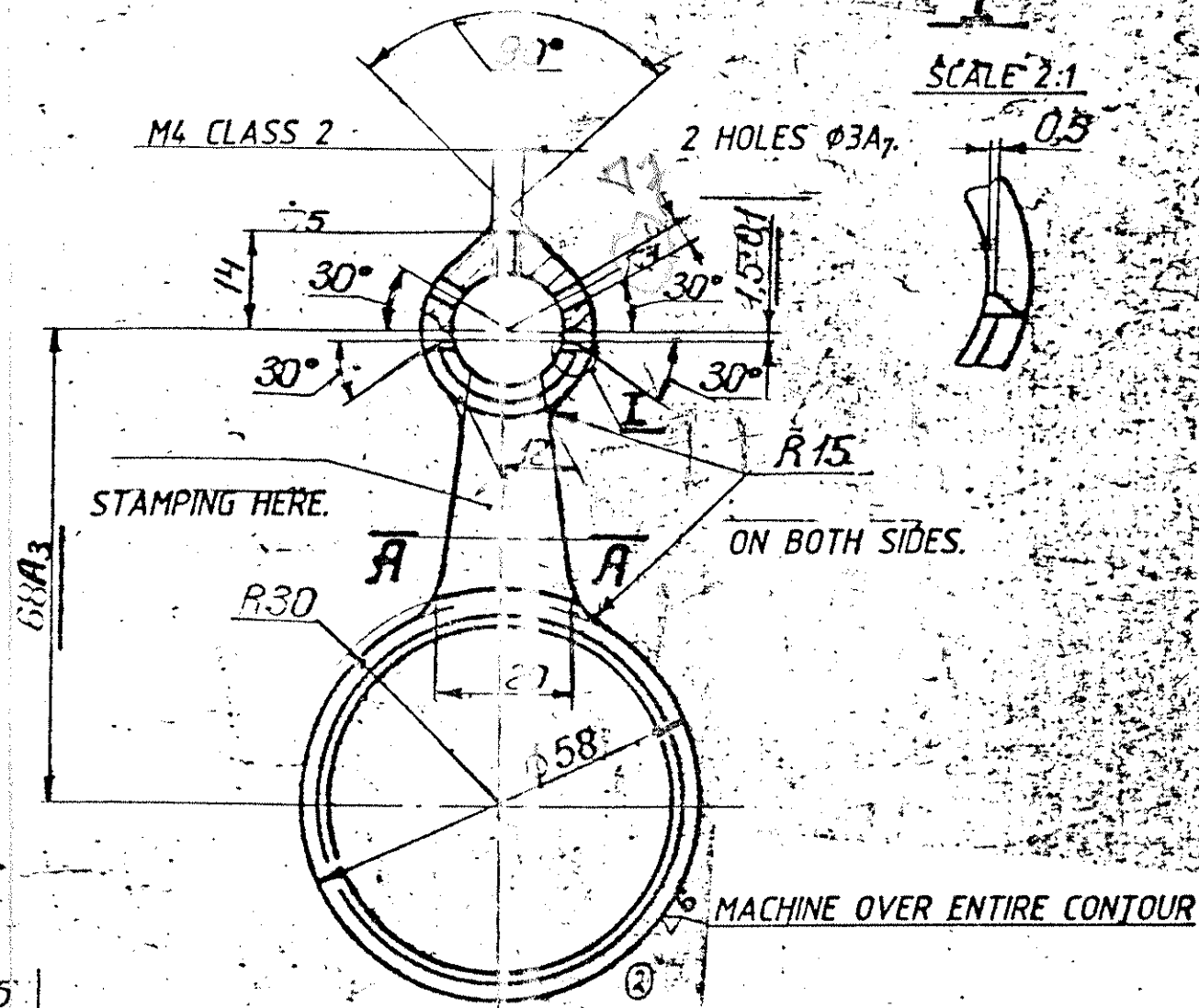
DRAWING NUMBER
AK150H-092



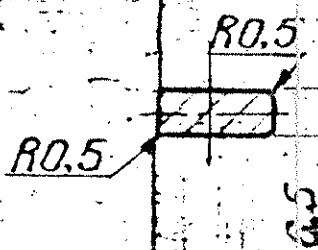
VIEW D



UNLESS SPECIFIED OTHERWISE,
TOLERANCE ON STAMPING ARE AS PER
555-65 (AH-1985)
TOLERANCE AT FREE DIMENSIONS ARE
AS PER 22AT52.



A-A



ALT. MATL:-
STEEL 40Cr4M03 TO IS: 5517-78
OR EN 19 TO BS: 970. HRC. 28-37

HARDNESS HRC 28 TO 37.
-PARKERIZING BY OXIDATION
EXCEPT SURFACE T.

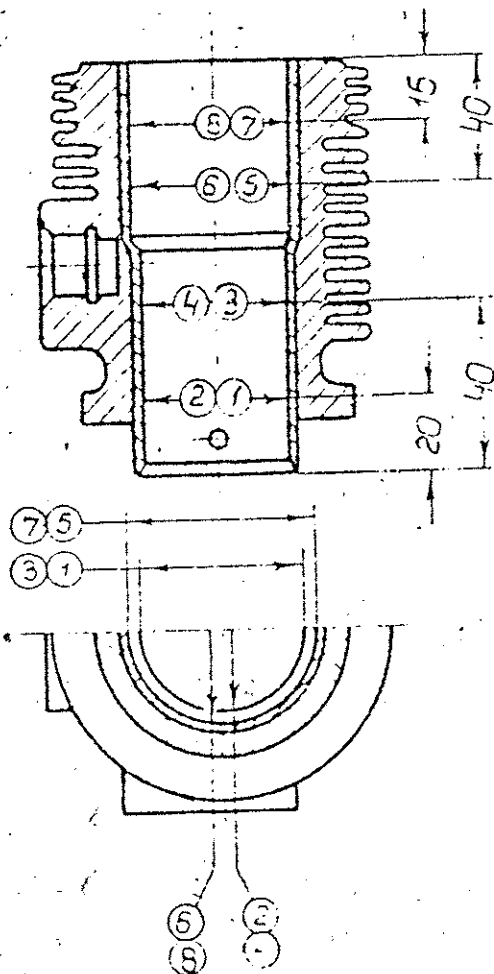
RUN-OUT OF BUTT-ENDS T₁ WITH RESPECT TO SURFACE D SHOULD NOT EXCEED 0.05.MM.
CHECK BY MAGNETIC FLOW DETECTOR, CRACKS NOT ALLOWED.
PROVIDE DIMENSIONS, WHICH ARE UNDERLINED BY _____ IN UNIT AK 150H-35.
IT IS ALLOWED TO PROVIDE RECTANGULAR GROOVE, SECURING A DISTANCE OF 29 MM FROM CENTRE, INSTEAD OF RADIAL GROOVE R 30 ON ROD.

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

EST. MASS.		TO BE STAMPED OR MARKED WHERE INDICATED THUS #	
80		(LETTERS)	
ISSUE DATE		NATURE OF AMENDMENTS	
DRN		SCALE - 1:1	
CHD		DIMENSIONS IN mm	
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	
APPD		ALL THREADS CONFORM TO	
DATE		D S CAT NUMBER	
22-7-86		DRAWING NUMBER	
		AK 150H-092	
		MATERIAL:- STEEL 3B X A	
		TY 14 -1-950-74	
		USED ON:- AK 150 H-35C5	
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI			
TITLE: CONNECTING ROD 3rd STAGE			

Designation and description of units sketch with indication of measuring places

Цилиндр I ступ.
AK150C-18 пемлузел.
First stage cylinder



Indication of measuring place	Designation according to drawing	Actual dimensions			Note
		Before test	After test	Wear out	
1					
2					
3	$\phi 38.4^{(+0.02)}$				
4					
5					
6	$\phi 46.7^{(+0.02)}$				
7					
8					

SHEET 1 OF 3

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS \oplus LETTERS)	
		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 cel		SCALE -	MATERIAL :-	USED ON:- AK150C -01CB
CHD Bhattacharya		DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADL	
TD Sardar		TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	TITLE:- AIR COMPRESSOR TABLE OF MICRO MEASUREMENTS.	
APPD K		ALL THREADS CONFORM TO	B S CAT NUMBER	DRAWING NUMBER AK 1508 TM-AK 1508-01
DATE 25/7/80				

Designation and description of units sketch with indication of measuring places	Indication of measuring place	Dimension according to drawing	Actual dimension			
			Before test	After test	Wear out	Note
<p>① AK150C-16 Поршень со ② AK150C-100 Втулкой изед. Position with bushings (Units)</p> <p>Для всех канавок For circular grooves Проверить указанные размеры во всех канавках. Check specified dimensions in all grooves</p>	1					
	2					
	3	0.38 ^{+0.17} _{-0.17}	②			
	4					
	5	0.45 ^{+0.22} _{-0.25}				
	6					
	7					
	8					
	9	0.12 ^{+0.04} _{-0.04}				
	10					
	11					
	12	15 ^{+0.06} _{+0.02}				
	13					
	14					
	15					
	16					
	17					
	18					

SHEET 2 OF 3

EST. MASS		TO BE STAMPED OR MARKED WHERE INDICATED THIS # LETTERS)	
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	MATERIAL :-	USED ON :- AK 150C-01CB
DRW	SCALE -	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD	DIMENSIONS IN mm.	TITLE - AIR COMPRESSOR TABLE OF MICRO MEASUREMENTS.	
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	B S CAT NUMBER	DRAWING NUMBER
APPD	ALL THREADS CONFORM TO	AK 1508 TM — AK 1508-01	
DATE 25/1/80			

PROTECTIVE CAPS

HST 226

SHEET 2 SHEETS

THREAD D ₀	D	D ₁	d	L	l ₁	TOLERANCE L ₁ ±0.1	TOLERANCE D ₁ ±0.5	TOLERANCE D ₀ ±0.3	TOLERANCE D ₀ ±0.5	C	L	d ₁	TOLERANCE D ₁ ±0.5	NO. OF TYPES.
M10x1	15	3	6		2							14	15.5	
M12x1	18	11	8	10		12	19					15	17.5	
M14x1	20	15	9					2	2	1		18	19.5	2.5
M14x1.5	22	15	11	12	25	14					45°	20	21.5	
M16x1	26	17	13									23	25	
M16x1.5	27	16	15	13		15						24	26	
M18x1	31	18	16		3	24						28	30	
M18x1.5	33	22	18									30	32	
M20x1*	34	23	20									31	33	
M20x1.5	37.5	27	22	15		18	26	3		15		35	37	
M22x1.5	42.5	37	25		3.5							40	42	35
M24x1.5, 2	44.5	33	28	15		20	28				3	42	44	
M27x1.5	47	36	32		4						3	44	46	
M30x1.5	51	40	35									48	50	
M33x1.5	54	43	38	16	4.5	22	31			2		51	53	5
M33x2	57	46	40		5	24						54	56	

1. MATERIAL: POLYAMIDE, GRADE П А6-110 OR ПА6-120/320 OST 5-06-С9-76. IT IS ALLOWED TO USE OTHER GRADES OF KAPRON RESIN UPON AGREEMENT BETWEEN THE CUSTOMER AND MANUFACTURER.
2. TOLERANCES ON FREE DIMENSIONS ARE AS PER 22AT52.
3. PATTERN DRAFT 1°. SHRINKAGE 1.5%.
4. IT IS ALLOWED TO MAKE CAPS AS PER DRAWING ИП1-398-00
5. * USE FOR COMMERCIAL ITEMS.
6. DIMENSIONS ARE PROVIDED BY TOOLING AND ARE NOT CHECKED IN PARTS. DIMENSIONS ARE CHECKED BY CONSUMERS IN UP TO 5% OF PARTS.
7. THREAD IS SUBJECTED TO CHECKING. IT IS ALLOWED TO CHECK THREAD BY STANDARD THREAD GAUGE APPROVED BY CUSTOMER.

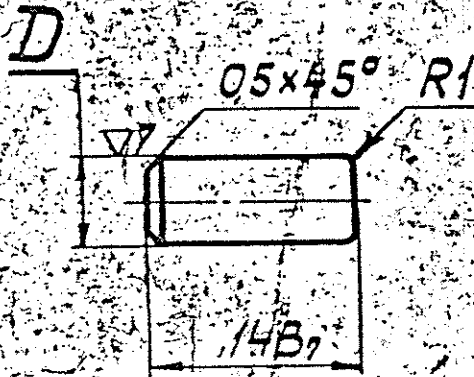
PILOT SAMPLE SHOULD BE APPROVED BY A.H.S.P. BEFORE BULK PRODUCTION.

EST. MASS.	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.	
ISSUE DATE	NATURE OF AMENDMENTS
DRN <i>8/1/84</i>	SCALE -
CHKD <i>8/1/84</i>	DIMENSIONS IN mm
TCD <i>8/1/84</i>	TOLERANCE ON DIMS UNLESS OTHERWISE STATED
APPD <i>8/1/84</i>	ALL THREADS CONFORM TO
MATERIAL: -	
USED ON: -	
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
	TITLE: SAFETY CAP
U.S. PAT NUMBER	DRAWING NUMBER
	HST 226

DRAWING NUMBER
 PH5-038

UNLESS STATED OTHERWISE

193



Dimension D	GROUP
φ6C	I
φ6,1C	II
φ6,2C	III

HARDNESS HRC 35 TO 42.
 OXIDIZE.

ALT. MATL:-

STEEL Gde 4.0 Cr 4 Mo 3 TO IS: 5517-78

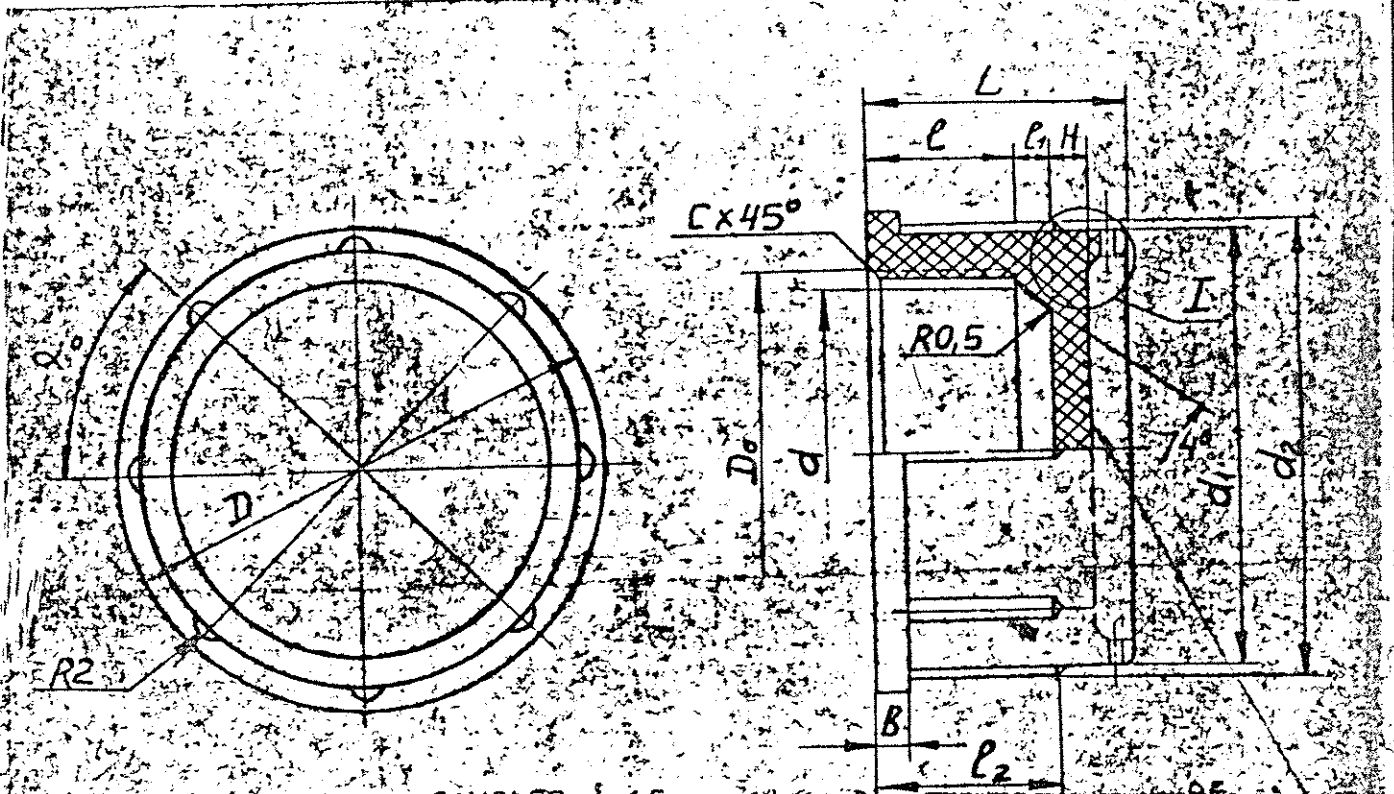
OR EN 19 70 BS: 970. HRC 35-42

DRESS THE BURRS

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

		EST. MASS. 3.1	TO BE STAMPED OR MARKED WHERE INDICATED THIS * LETTERS)
			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 Cv		SCALE - 2:1	MATERIAL:- STEEL 38 X A TY 14-1-950-74
CHK Bhattachar		DIMENSIONS IN mm	USED ON:- AK 150 B -04 - C/B C5
TCD Sgudha		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPD Vr			TITLE: LOCK - PIN
DATE 22.7.86		ALL THREADS CONFORM TO	D.S CAT NUM-SEE DRAWING NUMBER PH5-038

PROTECTIVE CAPS ARE USED FOR PROTECTING THE UNITS AND PIPE LINES FROM CLOGGING AND ALSO FOR PROTECTING THREADS OF PARTS FROM DAMAGE DURING TRANSPORTATION AND STORAGE.



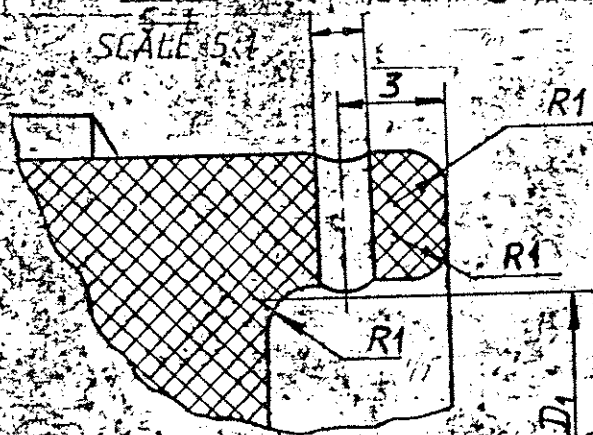
2 HOLES ϕ 1,5 (LOCKING HOLES)

MARK DIA AND PITCH, THREAD
Ex. 12x1,5

TYPE no-2.5 TO 5, GOST 2930-62.
HEIGHT OF EMBOSSED MARK IS 0.2 TO 0.4 MM.

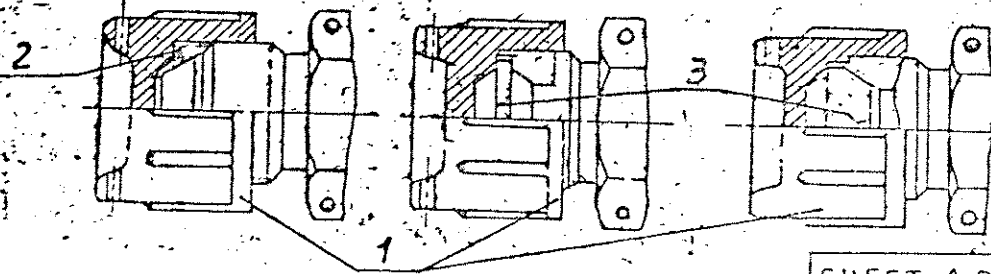
EXAMPLE OF CAP DESIGNATION WITH
THREAD: M 12 x 1.5

HBT 226 - 12 x 1.5



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

		EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE $R1$ OUT-SIDE & INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE DATE	NATURE OF AMENDMENT	MATERIAL	USED ON:-
URN <i>Sib</i>	SCALE -		
CHD <i>Shet</i>	DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD <i>Shet</i>	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	TITLE: SAFETY CAP	
APPD <i>Voy</i>	ALL THREADS CONFORM TO	D S CAT NUMBER	DR WING NUMBER
DATE 25/7/86			HBT 226



SHEET 1 OF 3

1 C.A.P	2 RING		SPACER	PLUG
	AS PER-1127	AS PER 1766	AS PER-1483	AS PER H20
HBT 226-10x1	2609C52-6-1.5-F	2262A-5-2	2625C55-7	
HBT 226-10x1.5	2609C52-5-1.5-F	2262A-216-2	2625C55-6.5	
HBT 226-12x1	2609C52-8-1.5-F	2262A-219-2	2625C55-11	
HBT 226-12x1.5	2609C52-7-1.5-F	2262A-6-2	2625C55-10.5	
HBT 226-14x1	2609C52-9-2-F	2262A-221-2	2625C55-13	
HBT 226-14x1.5	2609C52-9-2-F	2262A-6-2	2625C55-12.5	H20-14
HBT 226-16x1	2609C52-11-2-F	2262A-223-2	2625C55-15	
HBT 226-16x1.5	2609C52-11-2-F	2262A-10-2	2625C55-14.5	H20-16
HBT 226-18x1	2609C52-13-2-F	2262A-225-2	2625C55-17	
HBT 226-18x1.5	2609C52-13-2-F	2262A-12-2	2625C55-16.5	H20-18
HBT 226-20x1	2609C52-15-2-F	2262A-14-2	2625C55-18.5	H20-20
HBT 226-22x1.5	2609C52-16-2-F	2262A-16-2	2625C55-20.5	H20-22
HBT 226-24x1				
HBT 226-24x1.5	2609C52-18-2-F	2262A-229-2	2625C55-22.5	H20-24
HBT 226-27x1.5	2609C52-20-2.5-F	2262A-165-2	2625C55-25.5	H20-27
HBT 226-30x1.5	2609C52-22-3-F	2262A-333-2	2625C55-23.5	H20-30
HBT 226-33x1.5	2609C52-25-3-F	2262A-336-2	2625C55-31.5	H20-33
HBT 226-33x2	2609C52-25-3-F	2262A-335-2	2625C55-31	
HBT 226-36x1.5	2609C52-28-3-F	2262A-333-2	2625C55-34.5	H20-36
HBT 226-39x1.5	2609C52-32-2.5-F	2262A-152-2	2625C55-37.5	H20-39
HBT 226-39x2	2609C52-32-2.5-F	2262A-341-2	2625C55-37	
HBT 226-42x1.5	2609C52-35-2.5-F	2262A-153-2	2625C55-40.5	H20-42
HBT 226-45x1.5	2609C52-38-2.5-F	2262A-155-2	2625C55-43.5	H20-45
HBT 226-45x2	2609C52-38-2.5-F	2262A-154-2	2625C55-43	
HBT 226-48x1.5	2609C52-40-3-F	2262A-173-2	2625C55-45.5	H20-48
HBT 226-48x2	2609C52-40-3-F	2262A-155-2	2625C55-46	

DO NOT USE RING, 2609C52 AND SPACER 2625C55 IN NEW DESIGNS. THE FOLLOWING IS ALLOWED TO USE IN PREVIOUSLY DESIGNED ARTICLES.

a) PLUGS H 20 INSTEAD OF SPACERS 2625C55 WITHOUT AMENDMENTS IN DESIGN DOCUMENTATION PRIOR TO ITS REISSUE.

b) RING 2609C52 MADE OF RUBBER 1078, INSTEAD OF THE ONE INDICATED WITH LETTERS 'F'

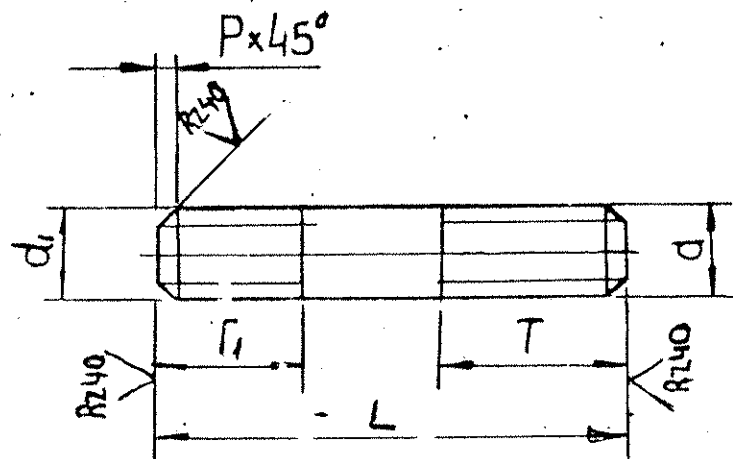
PILOT SAMPLE SHOULD BE APPROVED BY A.H.S.P BEFORE BULK PRODUCTION.

		EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THUS #.
			(LETTER:)
ISSUE DATE	NATURE OF AMENDMENTS	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
DRN & Mb	SCALE: - -	MATERIAL SEE ABOVE	USED ON: AK 150C C1C5 AAY2 016 C5
CHD & Mb	DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD & Mb	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	TITLE: SAFETY CAP	
APPD & Mb	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER H8T 226
DATE 25/7/11			

DRAWING NUMBER
K4 146

2.5/√(V)

DESIGNATION	THREAD D	THREAD D ₁	L	T	T ₁	P	WEIGHT g
K4146	YT6X1	M6-6g	30±0,4	14	12	0,7	5,3



- HRC 26 TO 32.
- THREAD d IS AS PER 25-A1 T1 IS AS PER OST 1 00105-73.
- UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS PER 22AT52.
- COATING CADMIUM-PLATING- 3 TO 6, MICRONS THICK.
- TECHNICAL SPECIFICATIONS ARE AS PER 101A TY.
- IT IS ALLOWED TO PROVIDE THE STUD END WITH THREAD d WITH RADIUS R (SPHERE) EQUAL TO DIAMETER OF STUD.
- STEEL 38XA MAY BE REPLACED BY STEEL 30XCA AS PER TECHNICAL SPECIFICATIONS TY14-1-950-74.

ALT. MATL:-
STEEL 40Cr4Mo3 TO IS:5517-78
OR EN19 TO BS:970. HRC. 35-42.

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

EST. MASS. 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	Chancel
CHD	Bhattacharya
TCD	SS Sankar
APPD	W. S.
DATE	22.7.80
SCALE	-
DIMENSIONS IN mm	
TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED.	
ALL THREADS CONFORM TO	
ISSUE	DATE
NATURE OF AMENDMENTS	

MATERIAL:- STEEL 38XA TYM-1-950-74	USED ON: AK150B-03-C/B-CB AK150B-04-4/B-CB
CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI	
TITLE: STUDS FOR SCREWING IN TO SOFT METAL	
D S CAT NUMBER	DRAWING NUMBER K4146