

DRAWING NUMBER
413-41-1

0(✓)

EXPLANATORY NOTE:

6. REFERENCE MATERIAL QUOTED

COLD ROLLED SHEET STEEL, HIGH ACCURACY ON ROLLING A 0.8mm THICK
TO GOST 19904-74, AND HIGH SURFACE FINISH EXTREMELY DEEP DRAWING
BT AND MANUFACTURED IN ACCORDANCE WITH COLD ROLLED THIN STEEL SHEET
GRADE 08kn TO GOST 9045-80.

CHEMICAL COMPOSITION AS PER GOST 9045-80.

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C Max	Mn	S	P	Si	Cr	Ni	Cu
08kn	0.10	0.20-0.40	0.030	0.025	0.03	0.10	0.10	0.15

MECHANICAL PROPERTIES AS PER GOST 1050-74

CATEGORY	GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	ELONGATION % Min
BT	08kn	26 - 37	28

7. REFERENCE NOTE 1 ON ALTERNATE MATERIAL QUALITY CARBON STEEL, COLD ROLLED GRADES 08kn, 10 AND 10kn TO GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL TO GOST 1050-74.

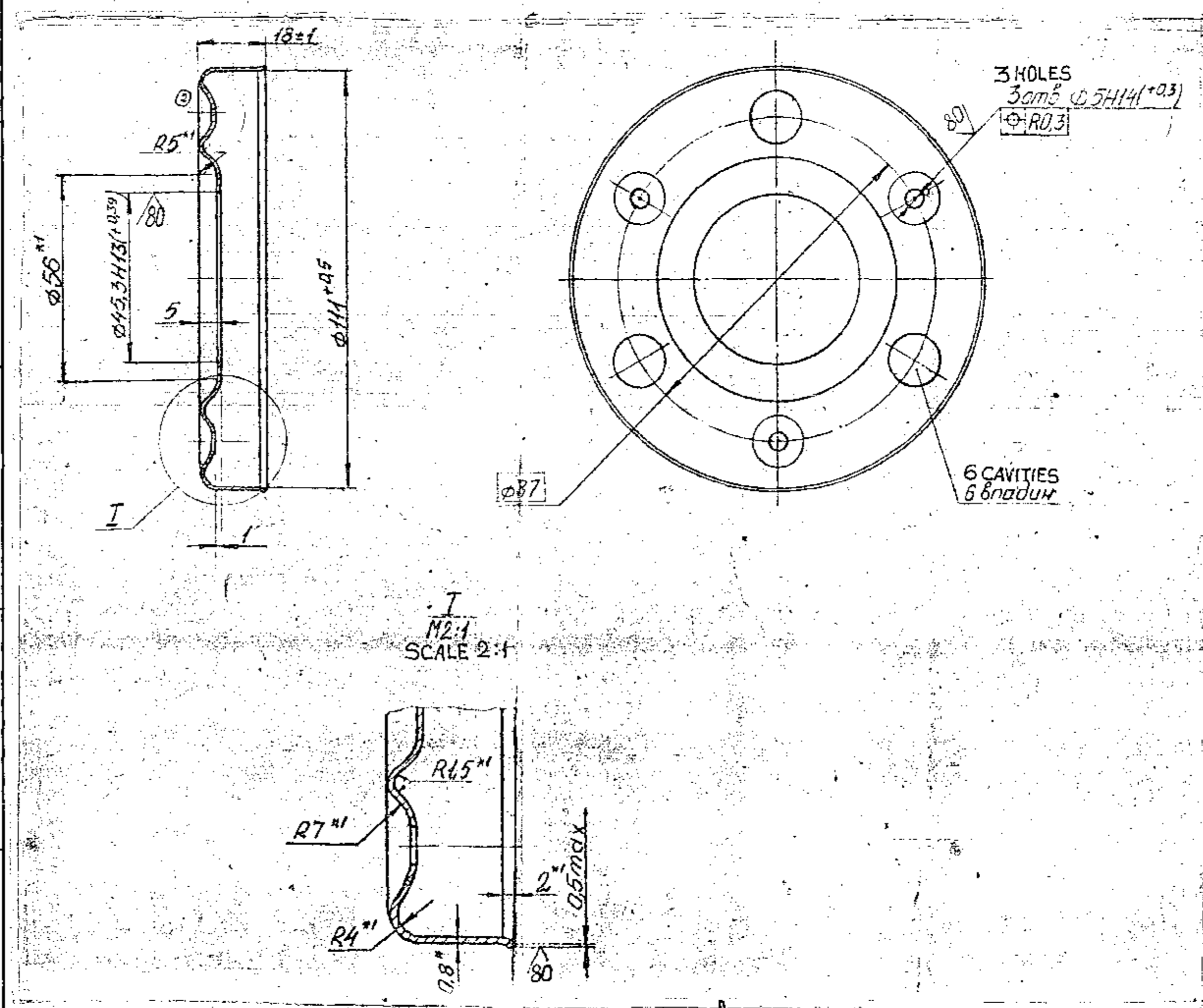
a) CHEMICAL COMPOSITION AS PER GOST 1050-74

GRADE OF STEEL	CONTENT OF ELEMENTS %					
	C	Si	Mn	Cr	S	P
08kn	0.05 - 0.11	0.05 - 0.17	0.35 - 0.65	0.10	0.040	0.035
10	0.07 - 0.14	0.17 - 0.37	0.35 - 0.65	0.15	0.040	0.035
10kn	0.07 - 0.14	0.07 Max	0.25 - 0.50	0.15	0.040	0.035

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH. MANGANESE CONTENT UP TO 0.25% AS REGARDS LOWER LIMIT, IS ALLOWED IN THE STEEL OF GRADE 08kn MEANT FOR PRODUCTION OF SHEET STEEL FOR COLD STAMPING.

b) MECHANICAL PROPERTIES AS PER GOST 16523-70.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	ELONGATION %Min
08kn	28 - 40	25
10	30 - 42	25
10kn	28 - 40	25



- ALTERNATE MATERIAL : STEEL 08kn, 10 AND 10kn (RIMMING) GOST 1050-74.
- UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ±0.3mm.
- UNSPECIFIED RADII R1±0.5mm.
- * DIMENSION FOR REFERENCE.
- *1 DIMENSIONS ARE TO BE ENSURED BY TOOL.

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

EST WT 0.09Kg 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	CHD	TCO	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	AL THREADS CONFORM TO	ISSUE	DATE	NATURE OF AMENDMENTS
					1:1						
MATERIAL : A08 GOST 19904-74 BT 08kn GOST 9045-80						USED ON CF 413.15.1		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI			
TITLE COVER SECOND SECTION						D S CAT NUMBER		DRAWING NUMBER: 413-41-1			

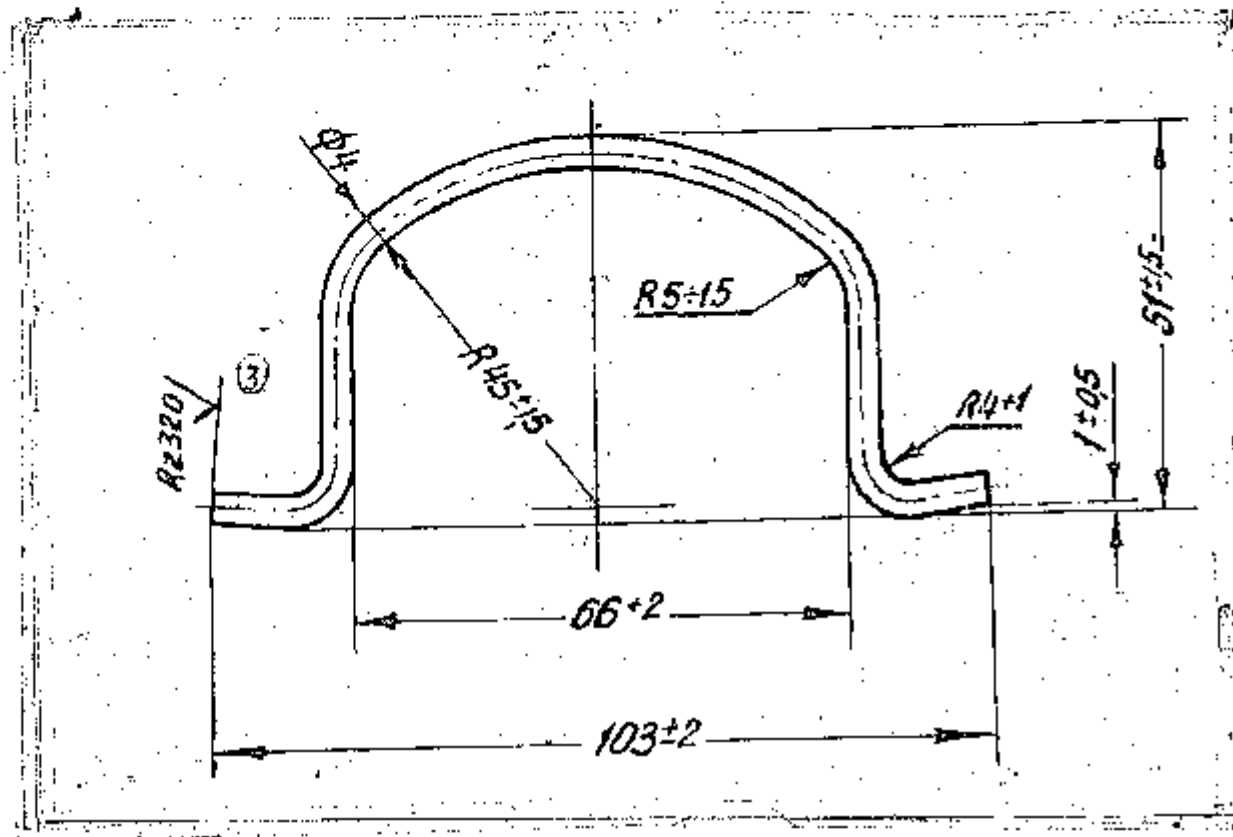
DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 2

A 6
SIZE A2



DRAWING NUMBER

413-42

LENGTH OF STRAIGHTENED COMPONENT \approx 17 mm.**EXPLANATORY NOTE:**1. REFERENCE MATERIAL QUOTED :

SPRING WIRE CATEGORY II NORMAL MANUFACTURING ACCURACY

4 (± 0.04) mm DIA TO GOST 9389-75 AND MANUFACTURED IN ACCORDANCE WITH QUALITY CARBON STRUCTURAL STEEL GRADE 70 TO GOST 1050-74a) CHEMICAL COMPOSITION AS PER GOST 1050-74

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C	Si	Mn	Cr	S	P	Cu	Ni
70	0.67 0.75	0.17 0.37	0.50 0.80	0.25	0.040	0.035	0.25	0.25

b) MECHANICAL PROPERTIES OF CATEGORY II WIRE AS PER GOST 9389-75

TENSILE STRENGTH Kg/mm ²	No. OF BENDS Min (2d)	No. OF TWISTS Min
150 - 175	6	13

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 3

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

EST WT
0.019 Kg

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 OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

	DRN	<i>[Signature]</i>	MATERIAL WIRE II 4;	USED ON
	CHD	<i>[Signature]</i>	GOST 9389-75	CB 413-15-1 CB
	TED	<i>[Signature]</i>		
	APPD	<i>[Signature]</i>		
	DATE	19-5-'86	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
	DIMENSIONS IN mm			
	SCALE	1:1		
	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED			
	ALL THREADS CONFORM TO			
	ISSUE	DATE	D S CAT NUMBER	DRAWING NUMBER
		NATURE OF AMENDMENTS		413-42

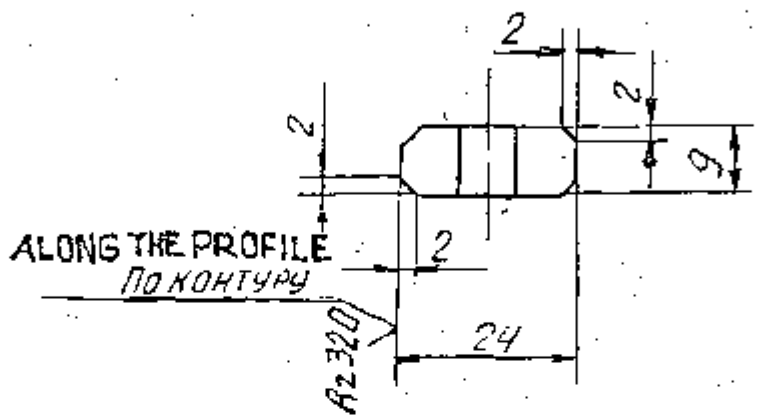
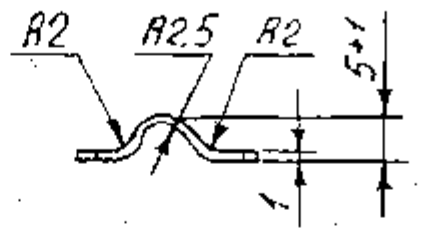
A 6

SIZE A3



DRAWING NUMBER

413 43



Размеры без допусков выполнять с точностью $\pm 0,5 \text{ мм}$.
 Заусенцы зачистить.
 Заменитель материала сталь 08нс, 10 и 10кп ГОСТ 1050-74.

1. DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE OBTAINED WITH AN ACCURACY OF $\pm 0.5 \text{ mm}$
2. BURRS SHOULD BE DRESSED.
3. ALTERNATE MATERIAL: STEEL, 08nc, 10 AND 10Kn (RIMMING) GOST 1050-74

EXPLANATORY NOTE

4. REFERENCE MATERIAL: LUTED: COLD ROLLED SHEET STEEL, ON HIGH ACCURACY ON ROLLING "A" 1mm THICK TO GOST 19904-74, AND HIGH SURFACE FINISH "I" EXTREMELY DEEP DRAWING "BF" AND MANUFACTURED IN ACCORDANCE WITH COLD-ROLLED THIN SHEET STEEL GOST 9045-80. CHEMICAL COMPOSITION AS PER GOST 9045-80.

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C MAX	Mn	S	P	Si	Cr	Ni	Cu
08kn	0.10	0.20-0.40	0.030	0.025	0.03	0.10	0.70	0.35

a) MECHANICAL PROPERTIES:

CATEGORY	GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm^2	ELONGATION % min
BF	08kn	26-37	28

5. REFERENCE NOTE "B" ON ALTERNATE MATERIAL: QUALITY CARBON STEEL COLD ROLLED GRADES 08nc, 10 AND 10kn TO GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL 1050-74.

a) CHEMICAL COMPOSITION AS PER GOST 1050-74

GRADE OF STEEL	CONTENT OF ELEMENTS %					
	C	Si	Mn	Cr	S	P
08nc	0.05-0.11	0.05-0.17	0.35-0.65	0.10	0.040	0.035
10	0.07-0.14	0.17-0.37	0.35-0.65	0.15	0.040	0.035
10kn	0.07-0.14	0.07 max	0.25-0.50	0.15	0.040	0.035

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH. MANGANESE CONTENT UP TO 0.25% AS REGARDS LOWER LIMIT, IS ALLOWED IN THE STEEL OF GRADE 08nc MEANT FOR PRODUCTION OF SHEET STEEL FOR COLD STAMPING.

b) MECHANICAL PROPERTIES AS PER GOST 16523-70.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm^2	ELONGATION % min
08nc	28-40	25
10	38-42	25
10kn	28-40	25

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.		DRN	Boe	MATERIAL: SHEET	USED ON: CB 413 14 2 CB
EST MASS 0.0018 kg		CHD	Dmitry	A1.0 GOST 19904-74	CB 413 15 1 CB
TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)		ICD	Andrey	II-BF-08Kn GOST 9045-80	CB 413 16 1 CB
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		APPD	301	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)	
A-6		DATE	20.05.74	AVADI	
SCALE: 1:1		DIMENSIONS IN mm		TITLE: LUG	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.		ALL THREADS CONFORM TO		D S CAT NUMBER	
DRAWING NUMBER: 413 43					

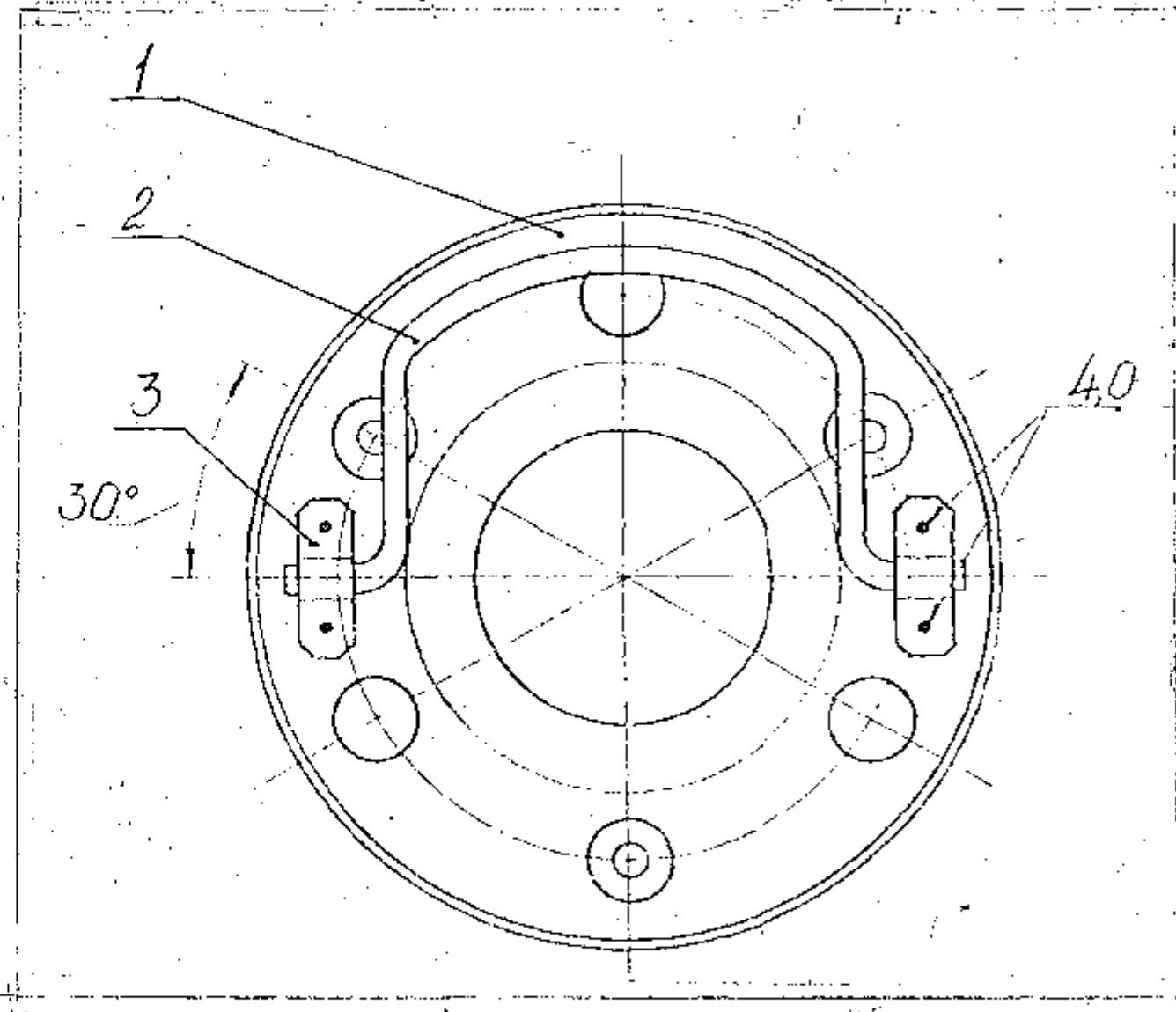
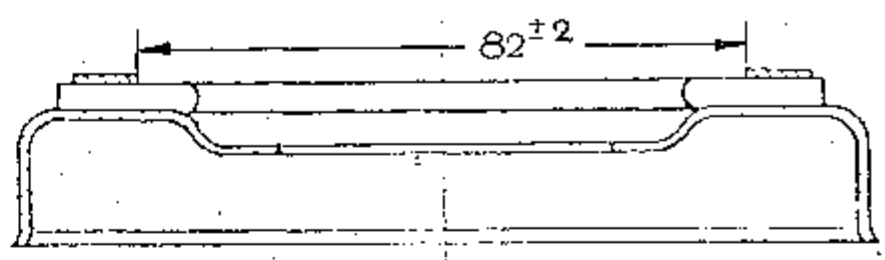
DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 5

SIZE A-3



DRAWING NUMBER
 C5 413 15 1C6

Rz 40 (✓)



1. COATING: Sn 6.
2. THERE MAY BE NO COATING AT PLACES OF SPOT WELDING.
3. THERE MAY BE NO COATING AT PLACES OF CONTACT OF COMPONENTS 1, 2 AND 3.
4. COMPONENT '2' SHOULD TURN FREELY WITHOUT JAMMING.
5. RESISTANCE SPOT WELDING.
6. COATING: Zn 6, CHROMATIZING AS PER INSTRUCTIONS U.S-483-BZ.

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 3

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

EST WT 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

ISSUE	DATE	NATURE OF AMENDMENTS

DRN	CHD	TCD	APPD	DATE	SCALE	DIMENSION	TOLERANCE	ALL THREADS
				20-5-86	1:1	IN mm	ON DIMNS UNLESS OTHERWISE STATED	TO CONFORM TO
MATERIAL					USED ON			
					C5 413 05 1C6			
CONTROLLER					RATE OF INSPECTION (HEAVY VEHICLES)			
					AVADI			
TITLE					SUB ASSY COVER SECOND			
D S CAT NUMBER					DRAWING NUMBER			
					C5 413 15 1C6			

A 6
 SIZE A3



