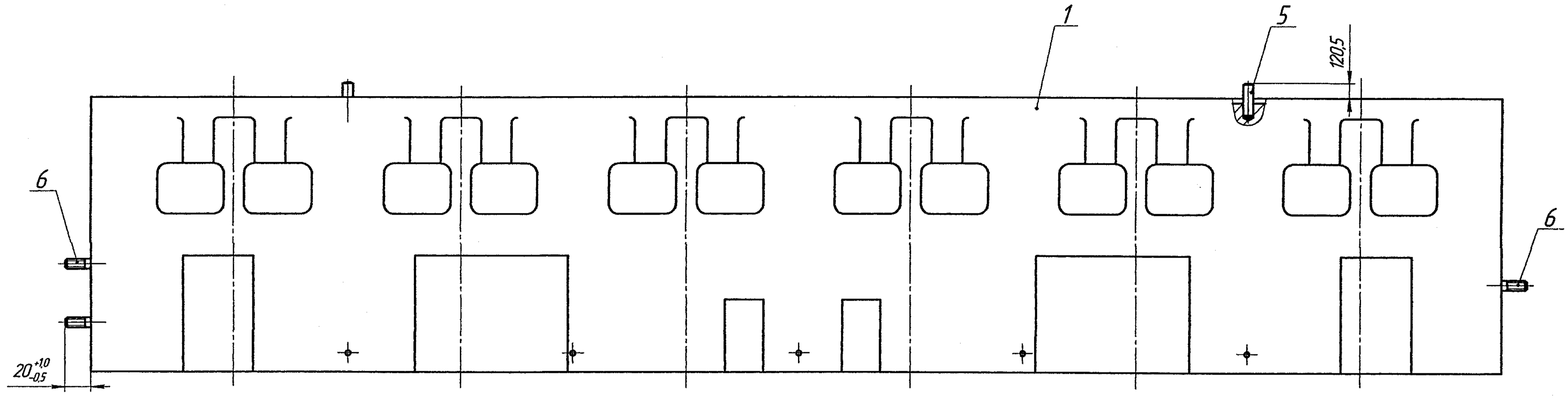


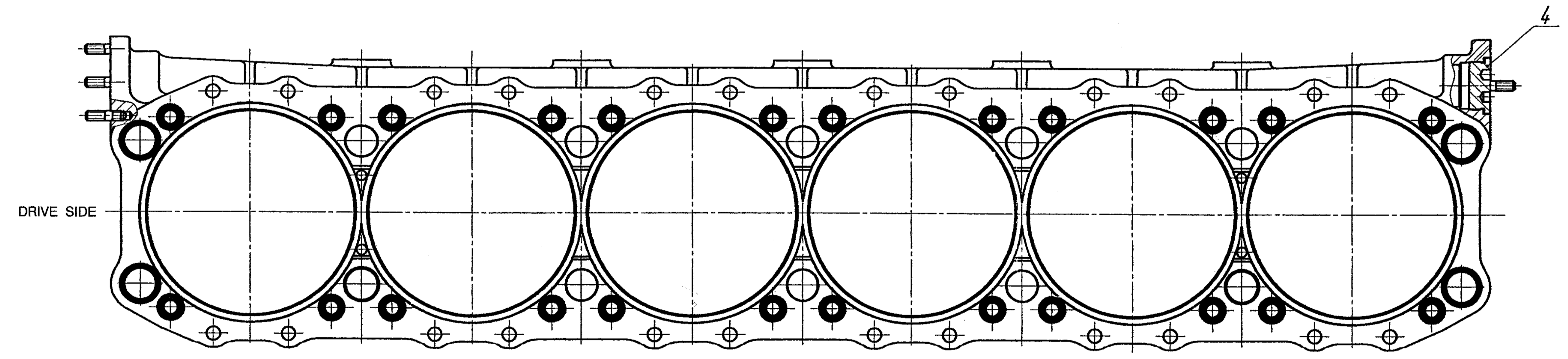


DRAWING NUMBER  
Cb303-02-23cb

SHEET No. 1 OF 1



1. LEAK TEST IS CARRIED OUT WITH WATER UNDER PRESSURE 0.25 Mpa (2.50 Kg/cm<sup>2</sup>) ... 0.30 Mpa (3.00 Kg/cm<sup>2</sup>) AT TEMPERATURE 60°C ... 70°C FOR 3 MINUTES MINIMUM. LEAKAGE IS NOT ALLOWED.
2. LEAK PROOFNESS TEST IS ALLOWED BEFORE FIXING OF STUDS & PINS.



DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE-NIL  
DRG. REPLACES ISSUE - 2 & Cb 303 - 02 - 16 cb Vide NOTN No. 196 - 09

V92-S2  
F-164  
10  
SIZE A1

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)

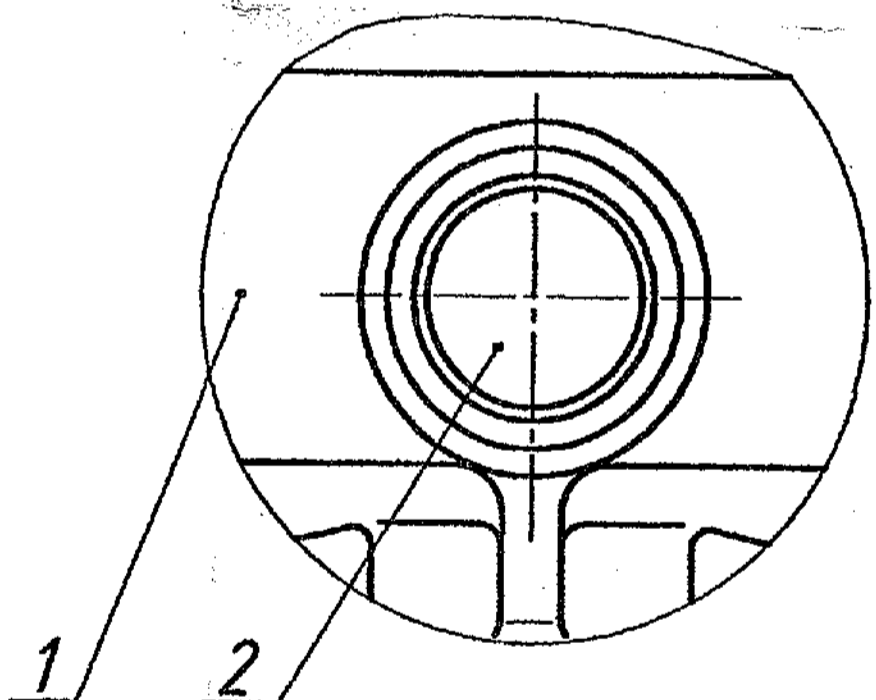
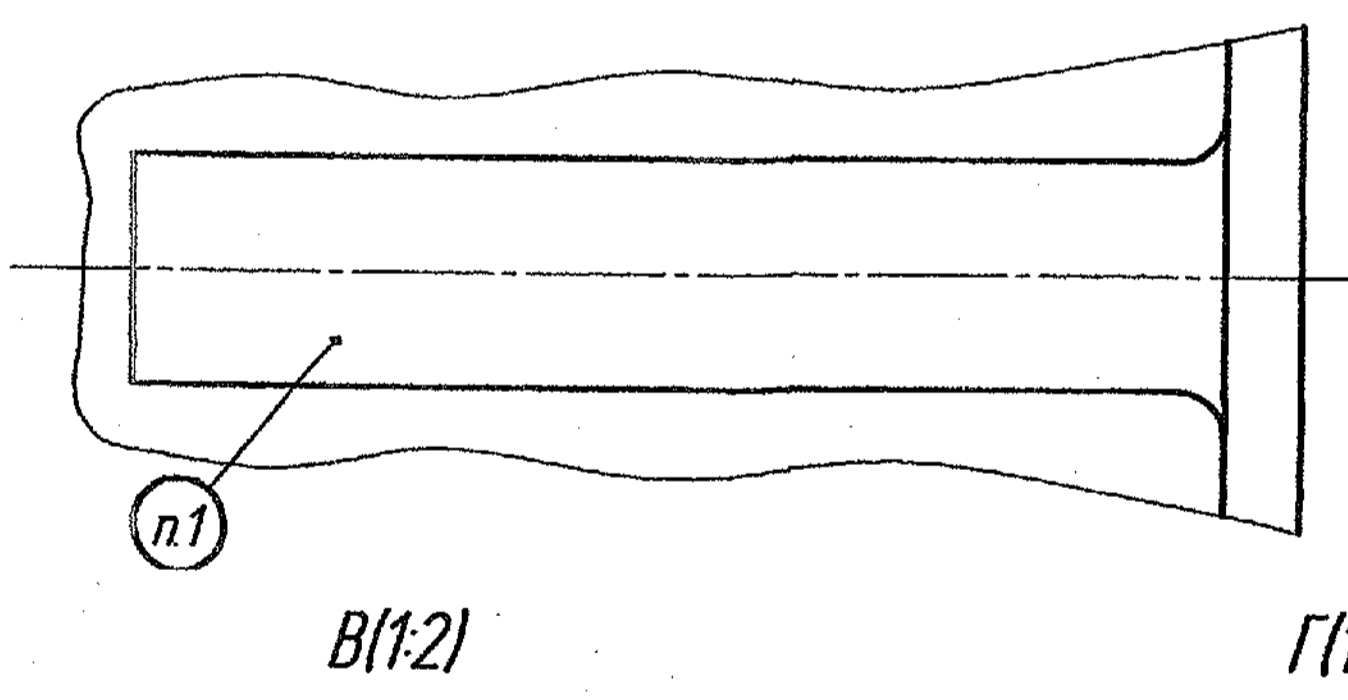
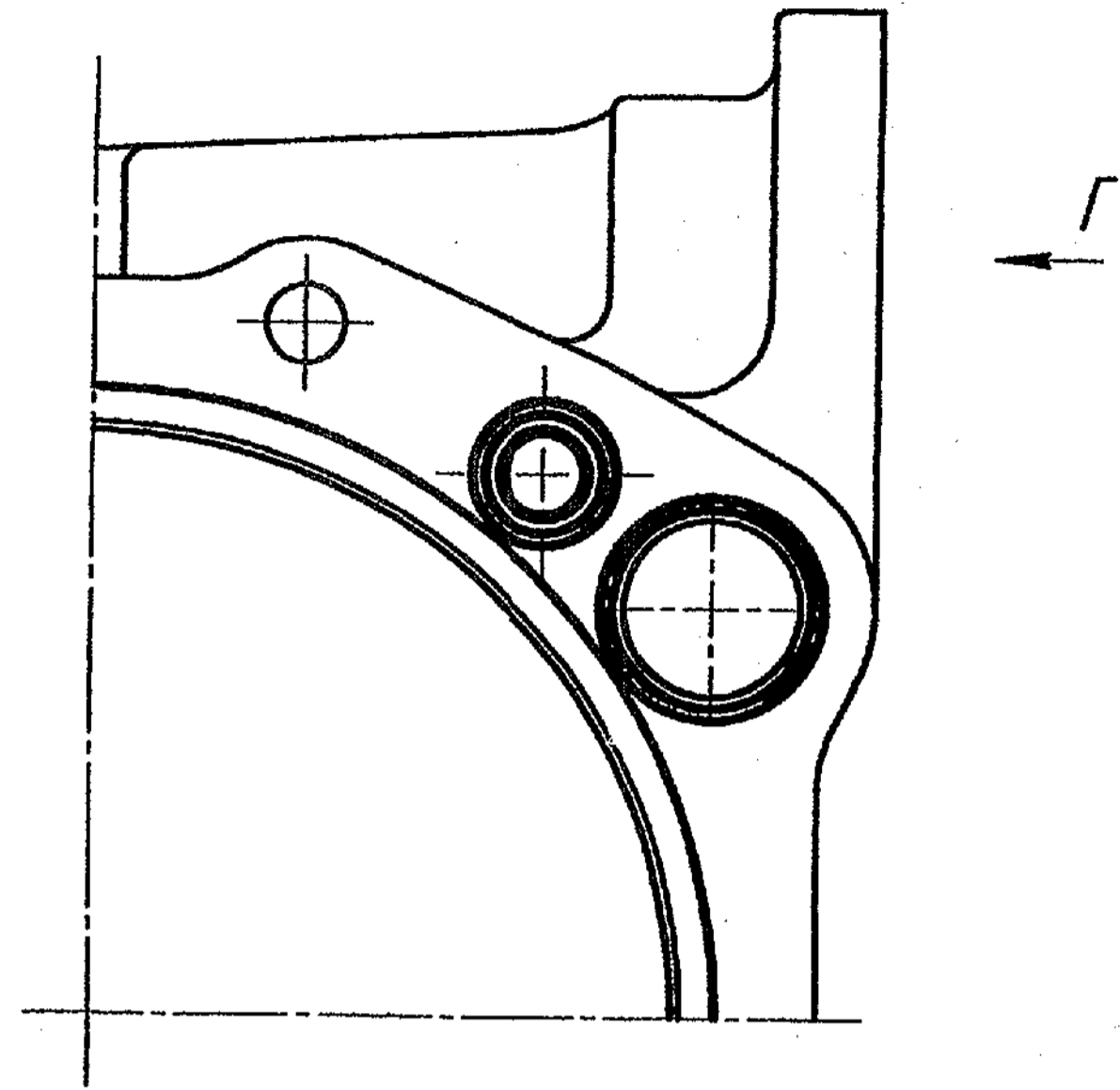
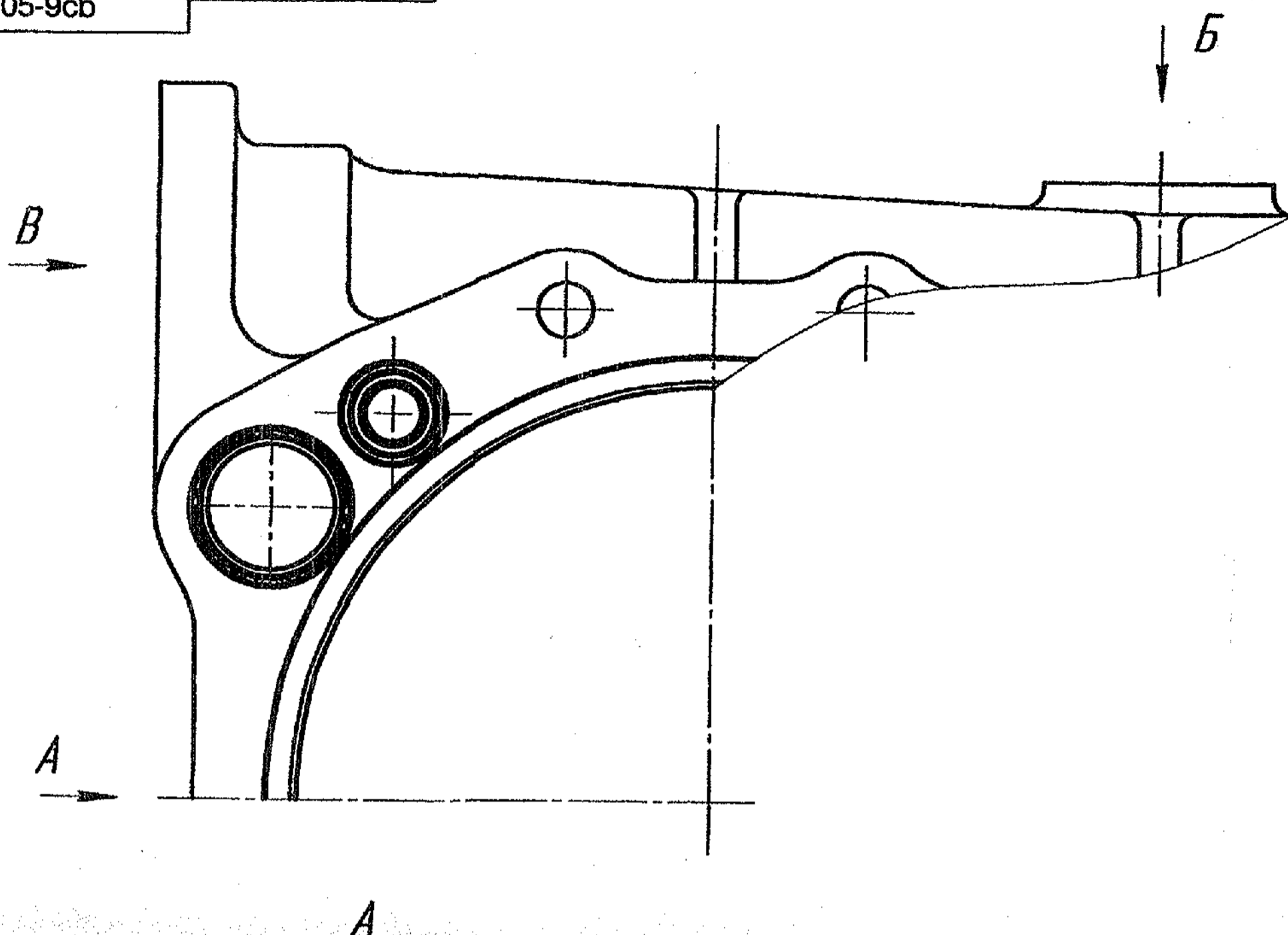
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS : 2102 - 69	ALL THREADS TO CONFORM TO IS:4218.PART- 4	MATERIAL :-	USED ON :- Cb303-01-23 Cb303-01-23-01
			09 DEC 2015	1 : 2				CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
								TITLE :- CYLINDER JACKET L.H. ASSY.	
								D S CAT NUMBER	
								DRAWING NUMBER Cb303-02-23cb	
ISSUE	DATE	NATURE OF AMENDMENTS							

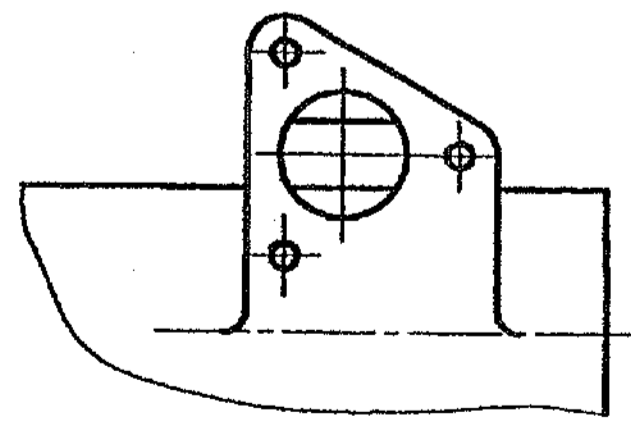
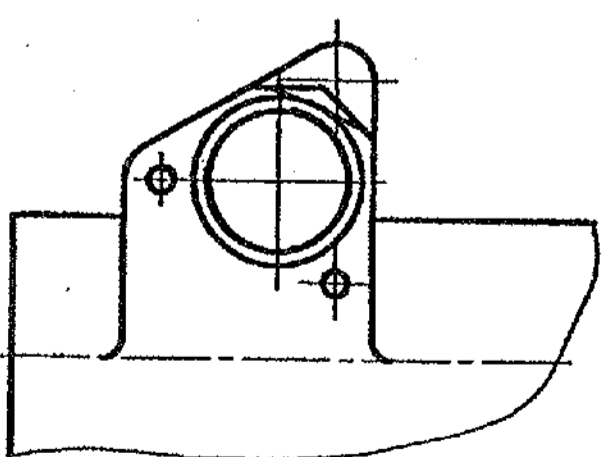
USED ON	ZONE	ITEM NO	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	QTY	REMARKS
I/L CREATED BASED ON RUSSIAN ORIGINAL ISSUE - NIL I/L REPLACES ISSUE - 3 & I/L Cb 303 -05 - 6 Vide NOTN No. 196 -09 Cb.303-02-23cb			Cb.303-05-9		CYLINDER JACKET		
			& ITEM LIST		LH ASSY		
		1	303-05-9		CYLINDER JACKET L.H	1	-ND-
					AK74(AJ19) GOST 1583-93		
		2	402-84		PLUG	3	
	<b>V92S2</b>						
	ISSUE	DATE	NATURE OF AMENDMENTS		ISSUE	DATE	NATURE OF AMENDMENTS
F-164	DRN	<i>jean</i>	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.				
15	CHD	<i>v</i>	TITLE : <b>CYLINDER JACKET L.H ASSY.</b>				
	APPD	<i>Max</i>					
	DATE	03.09.2015	SHT. NO. 1 OF 1	D S CAT NUMBER	ITEM LIST FOR <b>Cb.303-05-9</b>		

DRAWING NUMBER  
Cb303-05-9cb

SHEET No. 1 OF 1



1. MARK L.H. WITH LETTER SIZE 5- ПР3 GOST 26.008-85.
2. OTHER - REFER cb303-06-24.



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)

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>[Signature]</i>	MATERIAL:-	USED ON:- Cb303-02-23
CHD	<i>[Signature]</i>		
APFD	<i>[Signature]</i>		
DATE	09 DEC 2015	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
SCALE:-	1 : 1		
DIMENSIONS IN mm			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69		TITLE:- <b>CYLINDER JACKET L.H. ASSY.</b>	
ALL THREADS TO CONFORM TO IS:4218.PART- 4		D S CAT NUMBER	DRAWING NUMBER Cb303-05-9cb

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NIL  
 DRG. REPLACES ISSUE - 3 & Cb 303 - 05 - 6cb. Vide Notn No. 196 - 09  
 2-S2  
 184  
 4  
 E A2

USED ON	ZONE	ITEM NO	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	QTY	REMARKS
Cb.303-03-16cb  I/L CREATED BASED ON RUSSIAN ORIGINAL ISSUE - NIL I/L REPLACES ISSUE - MIL & I/L Cb 303 - 06 - 18 Vide Notfn No. 196-09			Cb.303-06-24 Cb		CYLINDER JACKET		
			& ITEM LIST		R.H SUB ASSY		
		1	303-06-24		CYLINDER JACKET R.H	1	-ND-
					AK7ч(АЛ9) GOST 1583-93		
		2	402-84		PLUG	3	
	<b>V92S2</b>						
	ISSUE	DATE	NATURE OF AMENDMENTS		ISSUE	DATE	NATURE OF AMENDMENTS
F-164	DRN		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.				
17	CHD		TITLE : <b>CYLINDER JACKET R.H SUB ASSY</b>				
	APPD						
	DATE	03.09.2015	SHT. NO. 1 OF 1	D S CAT NUMBER	ITEM LIST FOR <b>Cb.303-06-24</b>		

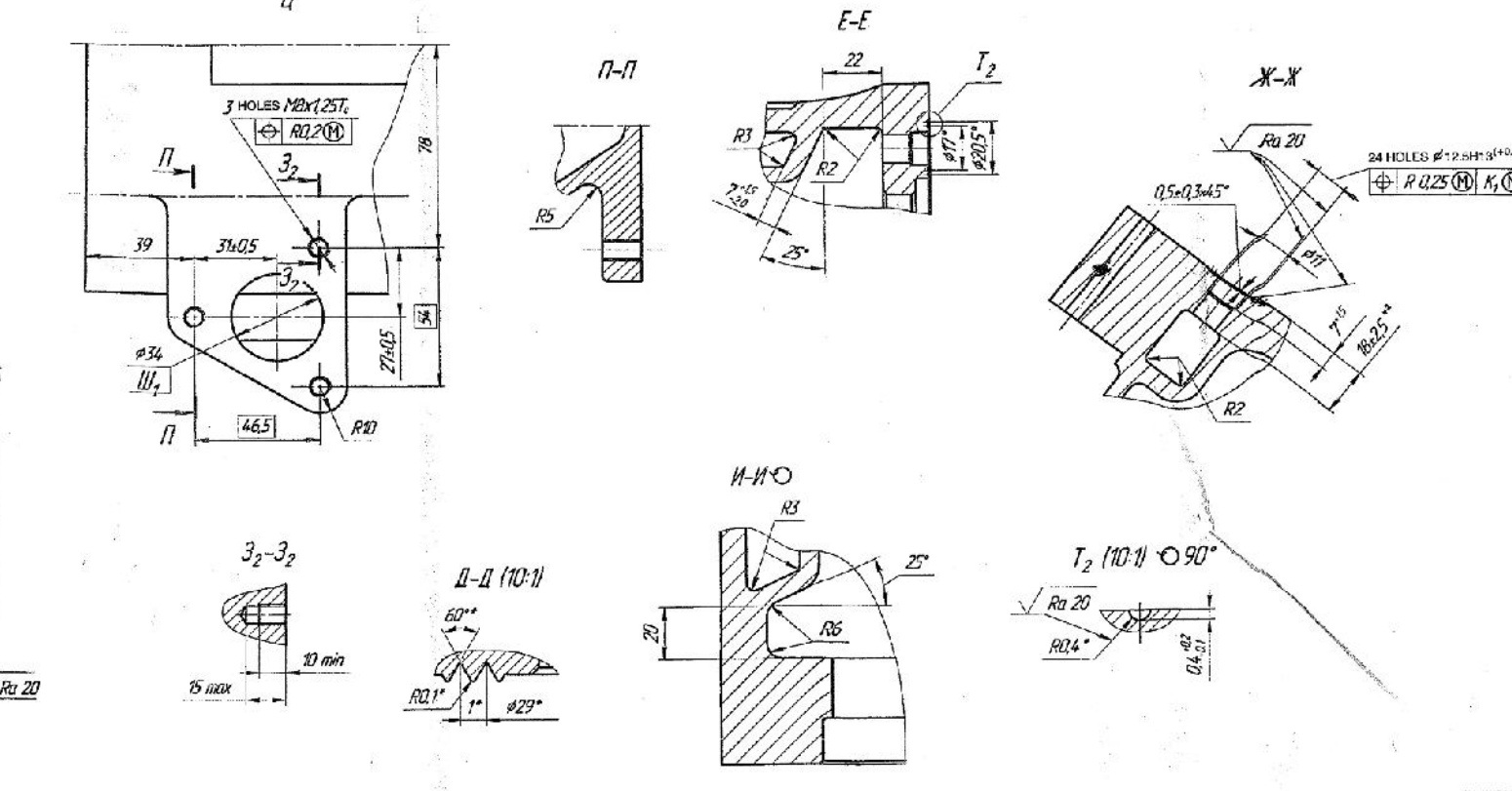
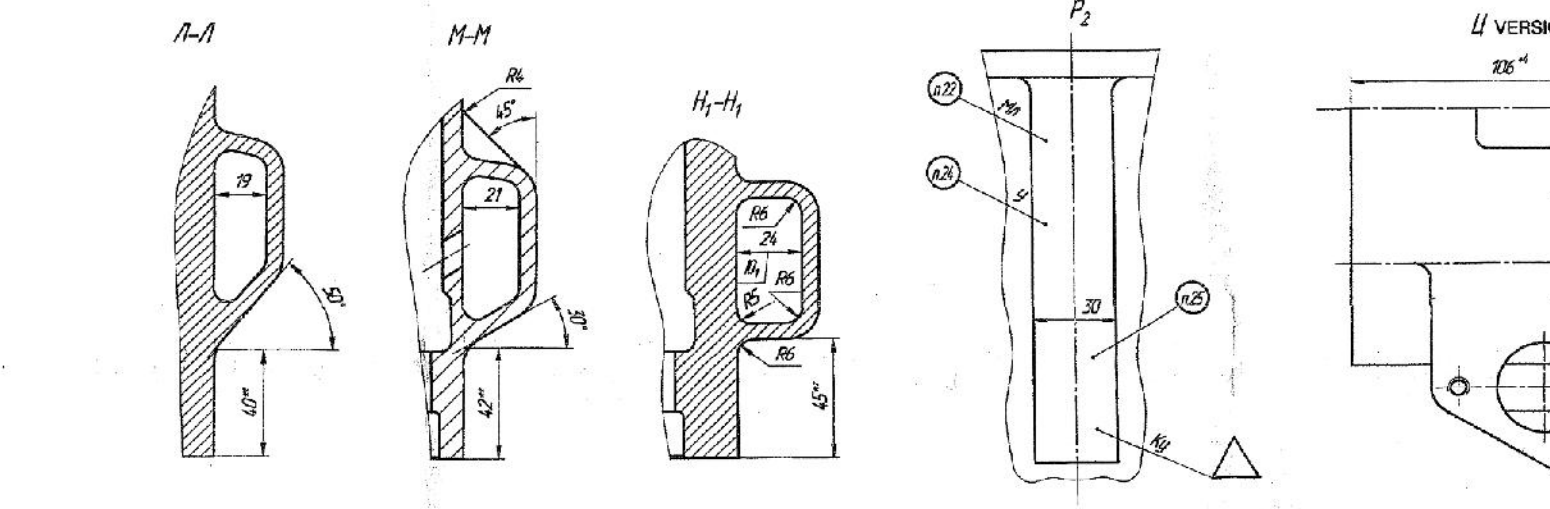
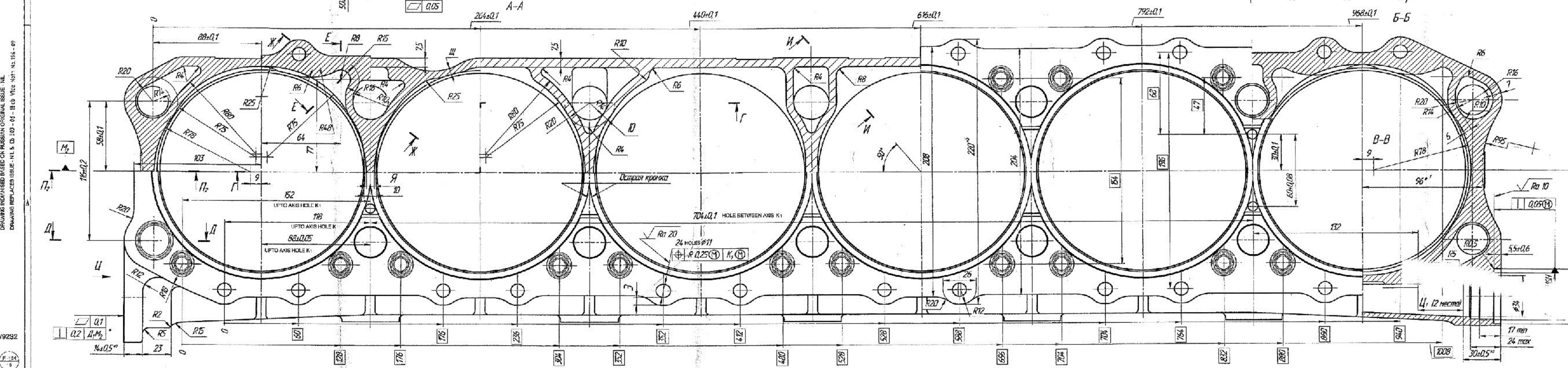
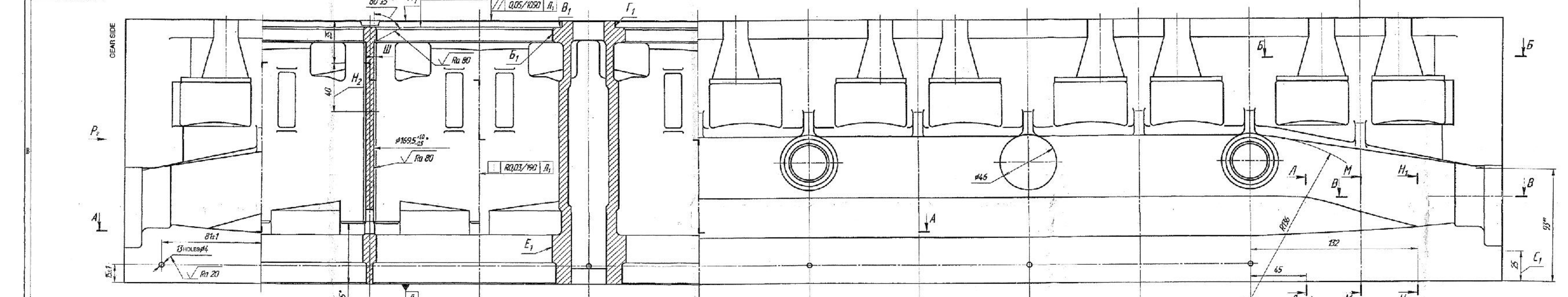


TABLE - 1

SHEET	DRAWING / PICTURE	DESCRIPTION	No. OF TP
1	MAIN VIEW	C <sub>1</sub>	22
	VIEW FROM ABOVE	3 M <sub>2</sub>	14
	A-A	C, D, E, F	16, 25
	B-B	H <sub>1</sub>	23
	G-G	A <sub>1</sub> , B <sub>1</sub> , C <sub>1</sub> , D <sub>1</sub> , E <sub>1</sub> , F <sub>1</sub>	28, 21, 16, 26
	H <sub>1</sub> -H <sub>1</sub>	H <sub>1</sub>	22
	H <sub>2</sub>	H <sub>2</sub>	22
2	VIEW FROM BOTTOM	H <sub>2</sub> , Y <sub>2</sub> , Y <sub>3</sub>	20, 11, 14
	3-3	K <sub>1</sub> , L <sub>1</sub> , M <sub>1</sub> , P <sub>1</sub>	9
	K-K	3, H <sub>2</sub> , E <sub>2</sub> , X <sub>2</sub> , B <sub>2</sub> , E <sub>1</sub>	13, 14
	Y-Y	Q <sub>2</sub>	5

MATERIAL:   
 USED ON: Об.303-06-24cb   
 CONTROLLED BY: QUALITY ASSURANCE (UJAY PRAKASH)   
 DATE: 11.02.2015   
 DRAWING NUMBER: Об.303-06-24cb   
 CYLINDER JACKET   
 R.H SUB ASSY

- REQUIREMENTS MEANT FOR CASTING AS PER TMS-27-87.
- CASTING ACCURACY 10 TO 15 GOST 26665-85.
- LIMIT DEVIATIONS: THICKNESS OF WALL 0.1 mm; MORE THAN 6 (FROM 4 TO 10) mm; UNSPECIFIED DRAFT: CASTING RADI 3...5 mm.
- AIR TIGHTNESS TEST OF WATER SPACE AND SHAFTS OF ANCHOR PINS WITH WATER AT TEMPERATURE 60°C UNDER PRESSURE 0.2 MPa (2.0 kg/cm²) FOR 5 MINUTES MINIMUM. LEAKAGE OF WATER IS NOT PERMITTED. AIR PRESSURE TESTING IS PERMITTED IN WATER TANK UNDER PRESSURE 0.2 MPa (2.0 kg/cm²). AIR LEAKAGE IS NOT PERMITTED.
- UNSPECIFIED LIMIT OF DEVIATION OF DIMENSIONS - OBTAINED REMOVED LAYER OF METAL H<sub>1</sub>, H<sub>2</sub>, & H<sub>3</sub>.
- TECHNICAL REQUIREMENTS FOR THREAD - AS PER STANDARD GOST-90.
- NON-PARALLELISM OF SURFACE A<sub>1</sub> AND B<sub>1</sub> IS PERMITTED TO CHECK IN PRESSED CONDITION.
- NON-FLATNESS OF SURFACE H<sub>1</sub> SHOULD BE CHECKED BY COLOUR ON FITTING BAND 5<sub>1</sub> & E<sub>1</sub> AS PER INSTRUCTION 104-13-85. PREPARATION AND APPLICATION SHOULD BE ACCORDING TO INSTRUCTION 101-13-85. IMPRINT OF COLOUR SHOULD BE UNIFORM ON CIRCUMFERENCE AND WITH MINIMUM 2 mm.
- IN CASE OF PROJECTION OF SURFACE H<sub>1</sub> ABOVE SURFACE P<sub>1</sub>, CARRYOUT CHECKING BY MACHINING BY 20 DIA 23H15mm AT ENTIRE HEIGHT OF CASTING.
- ENSURE DIMENSION 1 NOT MORE THAN 25.5 mm AT HEIGHT Q<sub>1</sub> FROM PLANE D<sub>1</sub>. IT IS PERMITTED TO DRESS WITH SMOOTH SUB-OPERATION AT ENTIRE PROFILE OF FILE ENSURING THE WALL THICKNESS.
- MAKE WALL THICKNESS MINIMUM 5mm AT PLACES Y<sub>1</sub>.
- NOTCHES WITH DEPTH NOT MORE THAN 0.02mm IS PERMITTED ON SURFACES P<sub>1</sub>, B<sub>1</sub> AND E<sub>1</sub>. USE AS PER STANDARD.
- DRILL THE HOLE X<sub>2</sub> IN 3° OR 4° CYLINDER.
- IT IS PERMITTED TO CARRY OUT: DIMENSION P<sub>1</sub> NOT LESS THAN 6mm, DIMENSION Q<sub>2</sub> NOT LESS THAN 4mm, DIMENSION H<sub>2</sub> NOT LESS THAN 4mm, DIMENSION H<sub>3</sub> NOT LESS THAN 1.5mm, DIMENSION A<sub>1</sub> NOT LESS THAN 5.5mm, LOCAL THINNING UP TO 4mm IS PERMITTED AS PER DIMENSION K<sub>1</sub>, DIMENSION E<sub>2</sub> NOT LESS THAN 4mm DURING DRILLING OF HOLE H<sub>1</sub>.
- NOTCHES ON SURFACE A<sub>1</sub> AROUND 8 EXTREME ANCHOR SHAFTS 32 AS PER SECTION J<sub>1</sub>-J<sub>1</sub>. DAMAGE OF SURFACE P<sub>1</sub> IS PERMITTED.
- THICKNESS OF WALL 1/2 UP TO 1.7mm IS PERMITTED ON SECTION H<sub>2</sub>.
- ARC WELDING FOR PLUGS, STEP, NO. 2, IT IS PERMITTED NON-STANDARD MANUAL ARC WELD.
- UN-MACHINED SURFACES SHOULD BE TAKEN AS PER STANDARD.
- \* DIMENSIONS ARE ENGRAVED BY TOOL.
- \* DIMENSIONS FOR REFERENCE.
- \*\* DIMENSION FOR CONSTRUCTION OF FOUNDARY REBUIE.
- MARK THE MATERIAL GRADE AS PER GOST 217-90 WITH LETTER SIZE 6 FIPS GOST 25.08-85.
- LOCATE IN H<sub>1</sub> SMOOTHLY CHANGE DIMENSION K<sub>1</sub> TO DIMENSION H<sub>1</sub>.
- MARK BY IMPACT METHOD GIVEN ACCORDING TO INSTRUCTION TTM-27-87 WITH LETTER SIZE 6 FIPS GOST 25.08-85.
- MARK BY IMPACT METHOD 170° WITH LETTER SIZE 6 FIPS GOST 25.08-85.
- LOCATION OF SPECIFIED SURFACES ARE GIVEN IN TABLE 1. DIMENSIONS B<sub>1</sub> AND H<sub>1</sub> IN TABLE 2.
- TRACE IS ALLOWED FROM TOOL 1/127 H<sub>1</sub> 127mm ON THE SURFACE A<sub>1</sub>.

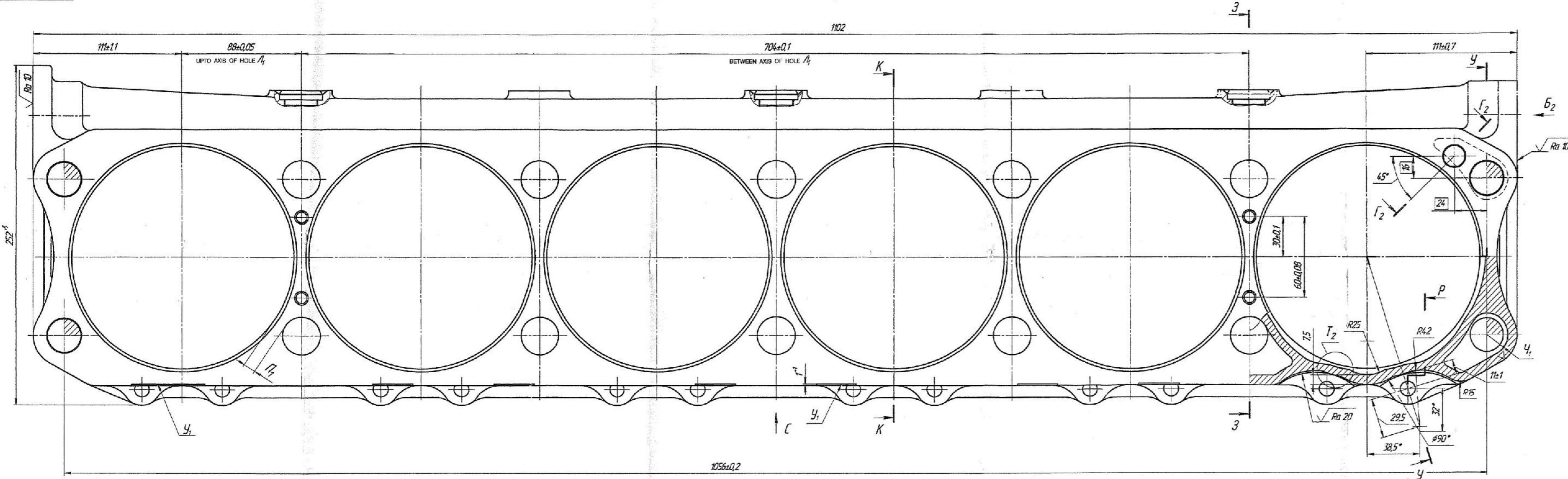
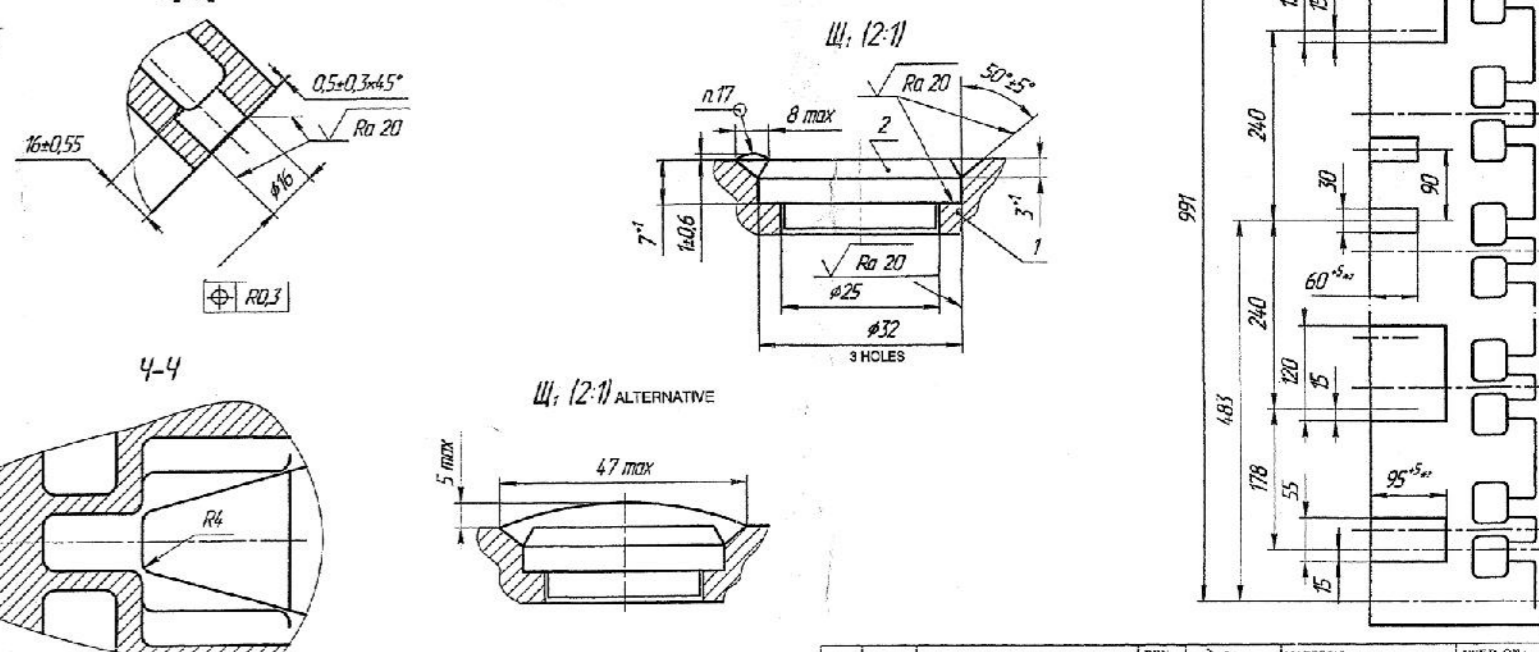
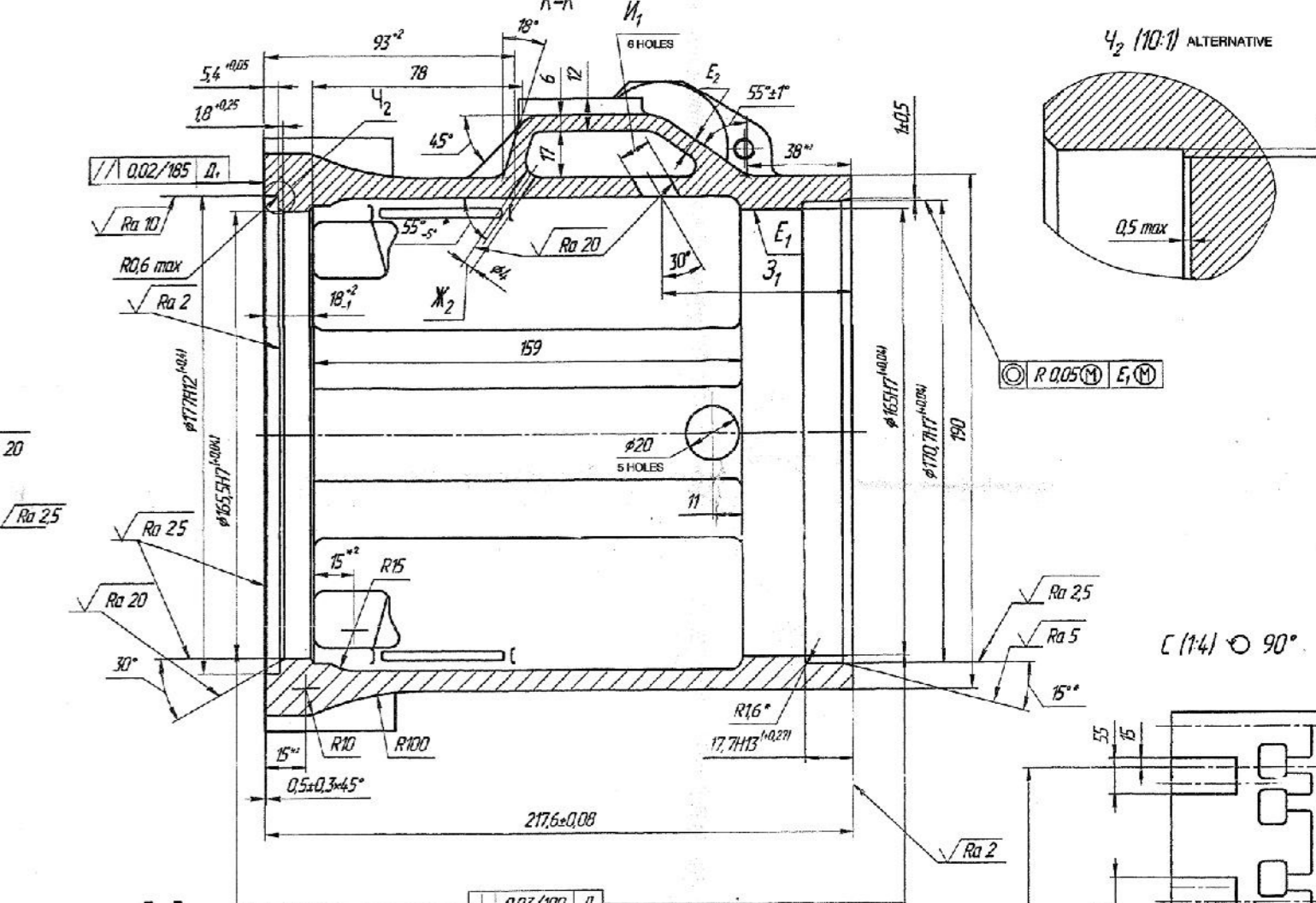
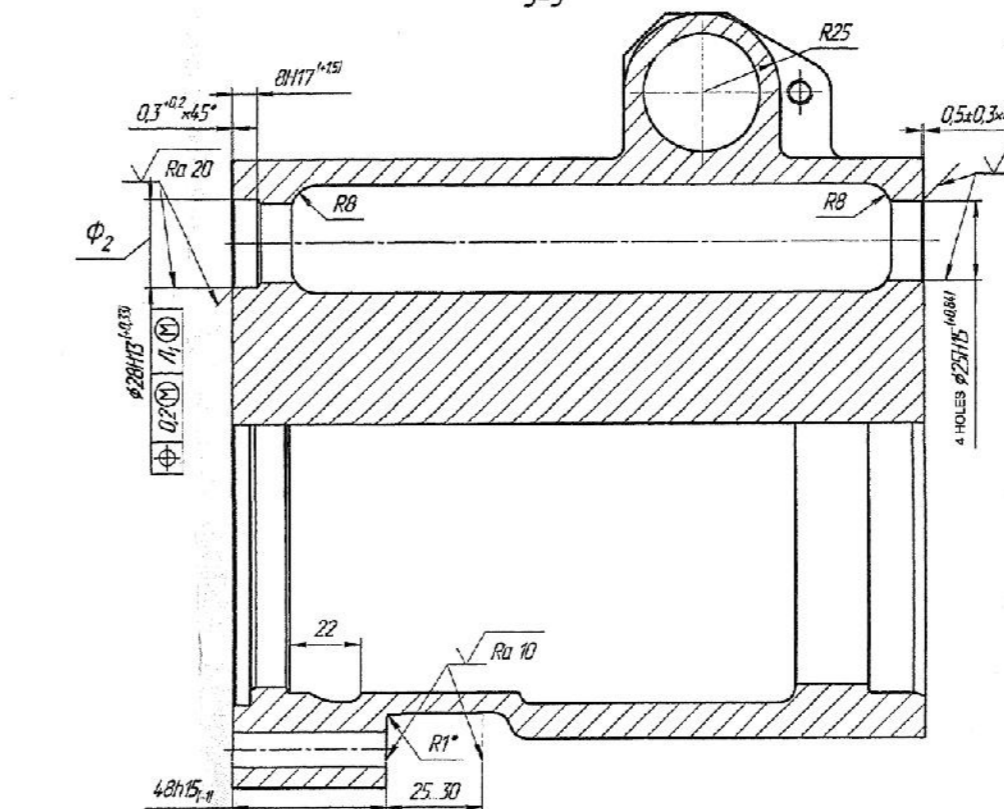
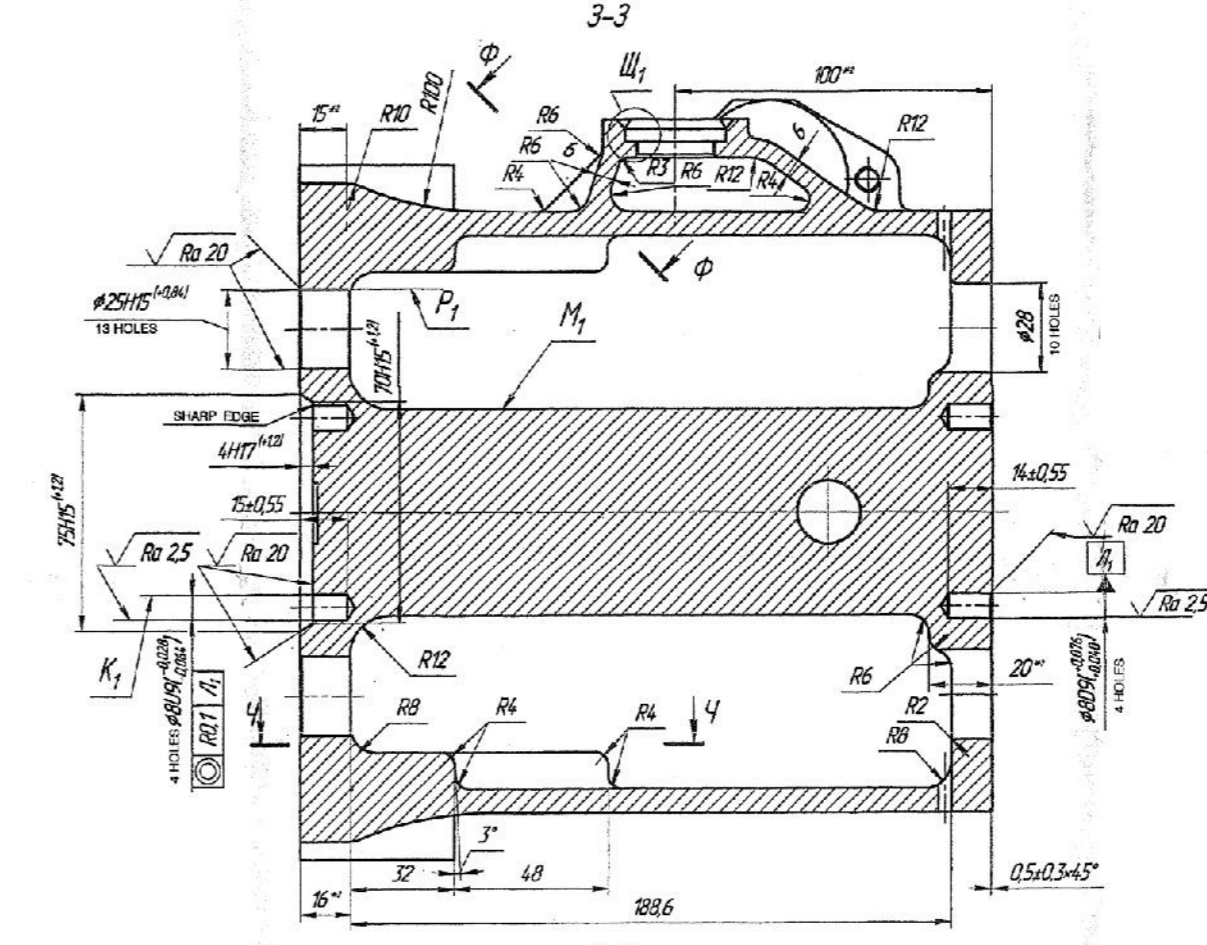
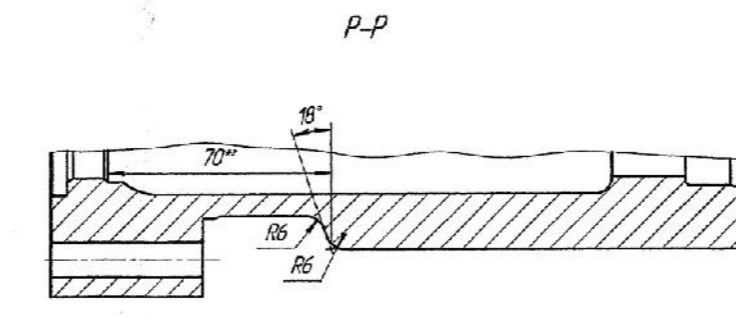
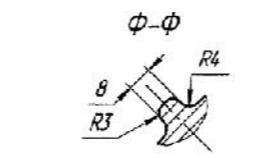
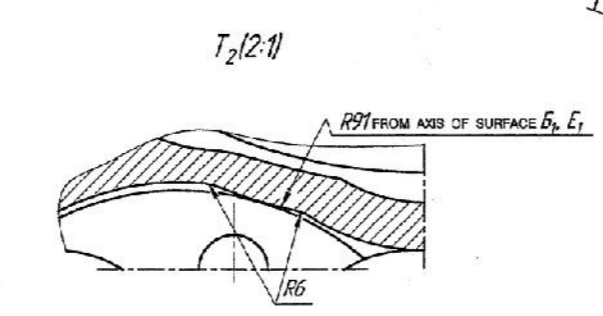
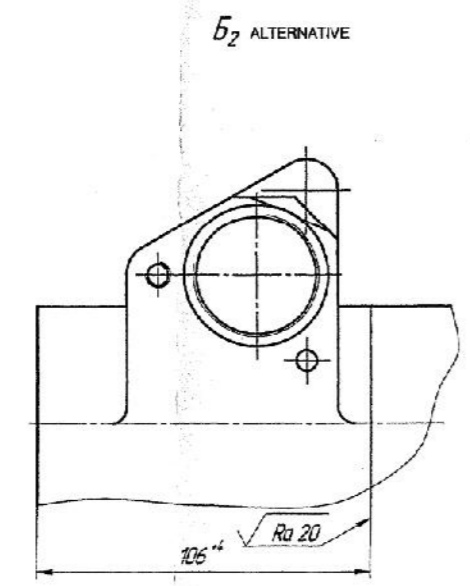
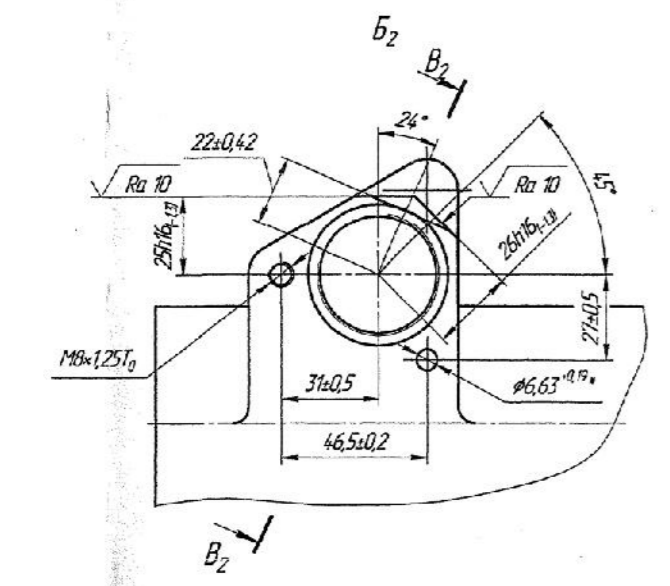


TABLE - 2

CYLINDER NUMBER WITH SIDE	DIMENSION $H_1, \text{mm}$	DIMENSION $3, \text{mm}$
1	24	73
2	21	71
3	16	69
4	17	67
5	20	65
6	12	63



FILES SAMPLE SHOULD BE APPROVED BEFORE BULK PRODUCTION

ENT WFL 00 TO BE STAMPED OR MARKED WHERE INDICATED THIS J (LETTERS)

SCALE: 1:1

DIMENSIONS IN mm

TOLERANCES ON DIMENSIONS UNLESS OTHERWISE SPECIFIED

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED

CONFORM TO ISO 2768-M

ISSUE DATE: NATURE OF AMENDMENTS

MATERIAL: USED ON: C8303-06-16

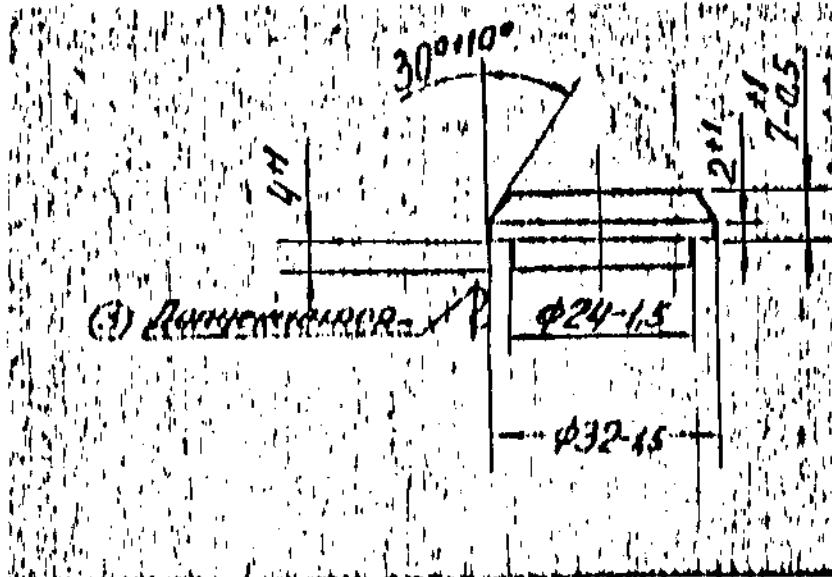
CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES) AVAM

TITLE: CYLINDER JACKET RH ASSY.

D & CAT NUMBER: Cb303-06-24cb

DRAWING NUMBER  
402-84

Rz 0.0



ALTERNATE MATERIAL : ДИМЕТРИЧЕСКАЯ КР 32А, ГОСТ 21400;  
UNMACHINED OVER EXTERNAL DIAMETER.

A3  
34

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

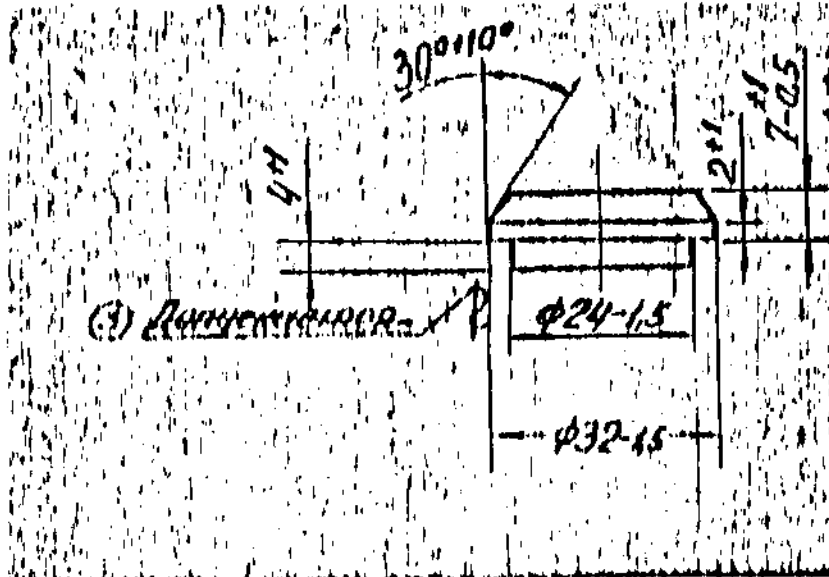
		EST. WT. 0.016 kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS =    ( LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT- SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
		MATERIAL:- АЛ 9 ГОСТ 2685-75 CASTING.	USED ON СБ 303-03-7 СБ 3301-15-30 СБ 303-02-7
ISSUE DATE	NATURE OF AMENDMENTS	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.	
DRM <i>[Signature]</i>	SCALE:- 1:1 DIMENSIONS IN mm	TITLE END CAP	
CHD <i>[Signature]</i>	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS 2102-69		
TCD <i>[Signature]</i>	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER 402-84
APPO <i>[Signature]</i>			
DATE 24 <sup>2</sup> / <sub>89</sub>			

SIZE A4



DRAWING NUMBER  
402-84

Rz 0.0



ALTERNATE MATERIAL : ДИМЕТРИЧЕСКОЕ КР 32А, ГОСТ 21400;  
UNMACHINED OVER EXTERNAL DIAMETER.

A3  
34

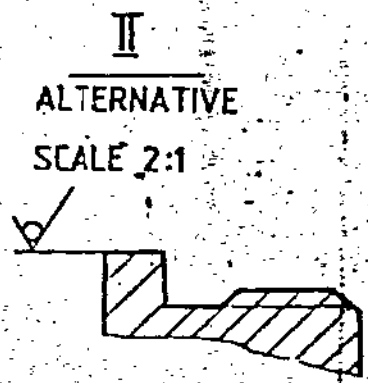
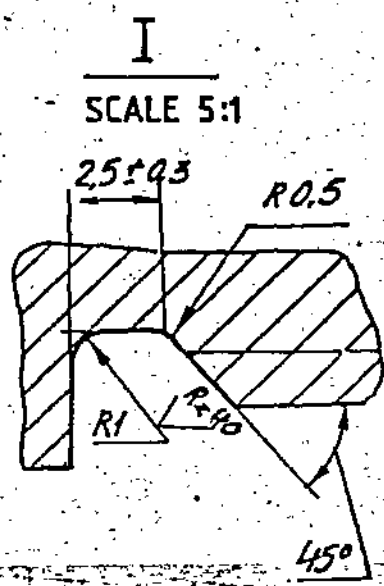
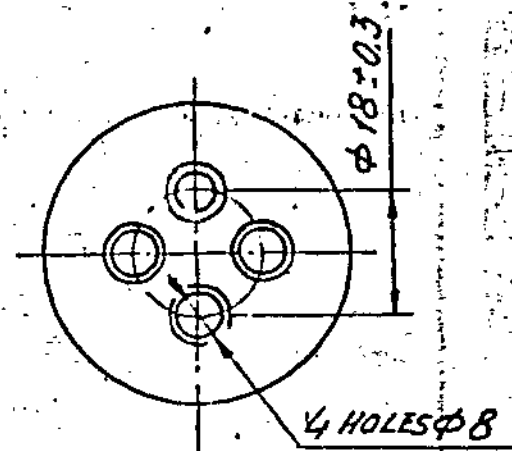
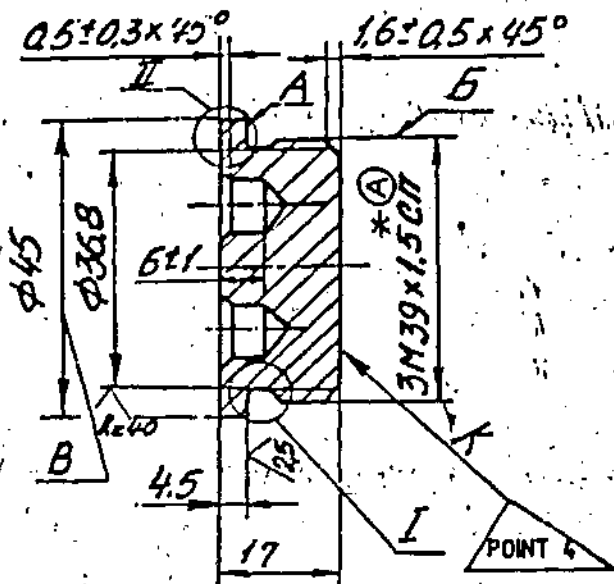
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

		EST. WT. 0.016 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.	
		MATERIAL:- АЛ 9 ГОСТ 2685-75 CASTING.	USED ON СБ 303-03-7 СБ 3301-15-30 СБ 303-02-7
ISSUE DATE	NATURE OF AMENDMENTS	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.	
DRM <i>[Signature]</i>	SCALE:- 1:1 DIMENSIONS IN mm	TITLE END CAP	
CHD <i>[Signature]</i>	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS 2102-69	D S CAT NUMBER	
TCD <i>[Signature]</i>	ALL THREADS CONFORM TO	DRAWING NUMBER 402-84	
APPO <i>[Signature]</i>			
DATE 24 <sup>2</sup> / <sub>89</sub>			

SIZE A4

DRAWING NUMBER

303-13-4



I  
SCALE 5:1

II  
ALTERNATIVE  
SCALE 2:1

1. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS: FOR HOLES AS PER A7, FOR SHAFTS AS PER B7. Rz80/ (✓)
2. TECHNICAL REQUIREMENTS FOR THREAD - AS PER STANDARD 82021-00.
3. END PLAY OF SURFACE 'A' RELATIVE TO SURFACE 'B' ALONG  $\Phi B$  SHOULD NOT EXCEED 0.1mm.
4. TO BE MARKED BY PUNCHING.
5. DIAMETER 'B' MAY BE OBTAINED WITH TOLERANCE h 16 (-1,6), ON THE SURFACE OF DIAMETER 'B' ROUGH SPOTS ARE PERMISSIBLE.

6. EXPLANATORY NOTE:

MATERIAL QUOTED: БАРЕПАЖ 9-4 GOST 1628-78  
 БАЖ 9-4 = GRADE OF MATERIAL  
 CHEMICAL COMPOSITION% (AS PER GOST 18175-78)  
 BASIC COMPONENT  
 ALUMINIUM = 8.0-10.0; IRON = 2.0-4.0; COPPER = REST  
 IMPURITIES (MAX)  
 TIN = 0.1; Si = 0.1; Pb = 0.01; P = 0.01;  
 Zn = 1.0; Mn = 0.5; TOTAL IMPURITIES = 1.7  
 MECHANICAL PROPERTIES (AS PER GOST 1628-78)  
 ULTIMATE TENSILE STRENGTH  $Kgf/mm^2 = 55$  (min)  
 RELATIVE ELONGATION% = 15 (min)  
 BRINELL HARDNESS (HB) = 110-180

Ⓐ T. \* REPAIR SIZE DIMENSION, R1=3M42 X 1.5. ADDED BASED ON LETTER No. 82847/DH/QAD/ED. DT. 26 DEC 94.

KVD NO. 78974

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

EST. WT. 0.17 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.

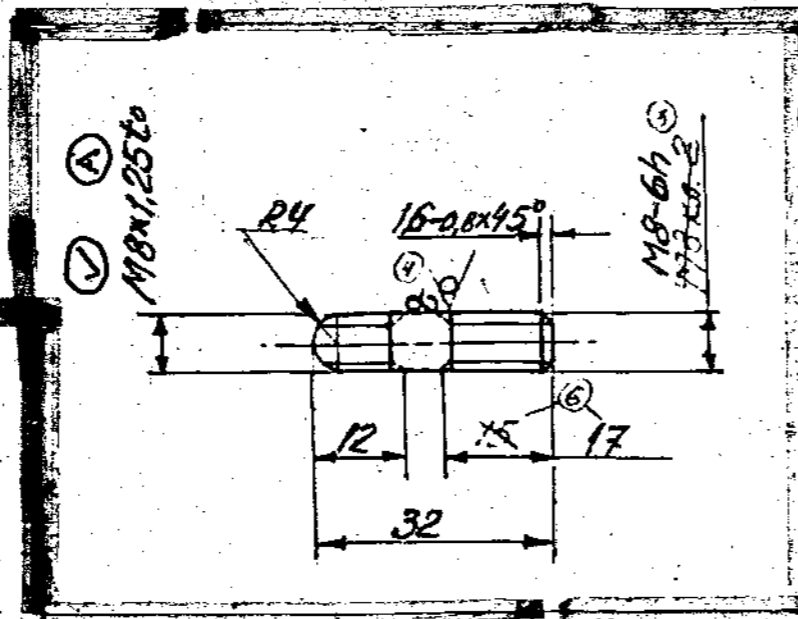
DRN	CHD	TCD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69.	ALL THREADS TO CONFORM TO IS: 2210 Pt IV	MATERIAL: BAR BP A * 9-4 GOST 1628-78	USED ON CE 303-02-710 CE 303-03-711
				20-8-96	1:1				CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADL	
TITLE								PLUG		
D S CAT NUMBER								DRAWING NUMBER		
								303-13-4		
ISSUE	DATE	NATURE OF AMENDMENTS								
A	20-1-95	REPAIR SIZES ADDED								

A-3  
67

DRAWING NUMBER  
350 123

EXPLANATORY NOTE :

Rz80



1. TECHNICAL REQUIREMENTS FOR THREADS AS PER STANDARD 82021-00.
2. DIMENSIONS WITH UNSPECIFIED TOLERANCES AND THE REST OF THE TECHNICAL REQUIREMENTS AS PER STANDARD 82052-00.
3. COATING: CADMIUM 3, CHROMATIZING AS PER ULS-104 WITH SUBSEQUENT ELIMINATION OF HYDROGEN EMBRITTLEMENT.
4. THE THREAD MAY BE MADE BY ROLLING WITH THE DIAMETER OF UN-THREADED PORTION WITHIN THE PITCH DIAMETER OF THREAD.
5. ALTERNATE MATERIAL: STEEL 40, 50, GOST 1050-74.
7. REPAIR SIZE DIMENSIONS ARE ADDED WHERE  
 (A) INDICATED THUS (✓), BASED ON OVERHAUL SPECIFICATIONS PART III REPAIR DRAWINGS. \*\*  
 (B) B. HARDNESS - 27--32 HRC.

6. REFERENCE MATERIAL QUOTED:

COLD DRAWN SIZED STEEL ROUND BAR  $\phi$  8mm TO GOST 7417-75 STEEL OF GRADE 45 TO 1051-73 AND MANUFACTURED IN ACCORDANCE WITH QUALITY CARBON STRUCTURAL STEEL GRADE 45 AND REFERENCE NOTE 5, OR ALTERNATE MATERIAL STEEL GRADES 40 & 50 TO GOST 1050-74.

a) CHEMICAL COMPOSITION AS PER GRADES 45, 40 & 50 TO GOST 1050-74.

GRADE OF STEEL	CONTENT OF ELEMENTS %					REMARKS	
	C	Si	Mn	Cr	S		P
45	0.42-0.50	0.17-0.37	0.50-0.80	0.25	0.040	0.035	Ref,Matl
40	0.37-0.45	0.17-0.37	0.50-0.80	0.25	0.040	0.035	Alt,Matl
50	0.47-0.55	0.17-0.37	0.50-0.80	0.25	0.040	0.035	Alt,Matl

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

b) MECHANICAL PROPERTIES UNDER NORMALISED CONDITION:

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm <sup>2</sup>	YIELD POINT Kgf/mm <sup>2</sup>	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH Kgm/cm <sup>2</sup>	HARDNESS B H N M A X	RE-MAR-KS
45	61	36	16	40	5	279	Ref,Matl
40	58	34	19	45	6	217	Alt,Matl
50	64	38	14	40	4	241	Alt,Matl

(B) \* MATERIAL:-  
STEEL 709 M40 (EN-19) TO BS-970 Pt.-1-1983.

SL. NO	REMARKS
1	M10 X 1.5 to
2	PCD 9.026 + 0.152 + 0.082

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

EST WT TO BE STAMPED OR MARKED WHERE INDICATED THUS # ( LETTERS )  
0.0117 Kg

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
C	20-5-09	Authy: Third Alt. Comm. Minutes Point 5 Dated 27-02-2009.
B	13-01-08	AUTHY-MIN. OF ALT. COM. MEET. POINT No.-2.12 Dt.- 07-02-07
A	10-11-95	REPAIR SIZE DIMNS ADDED

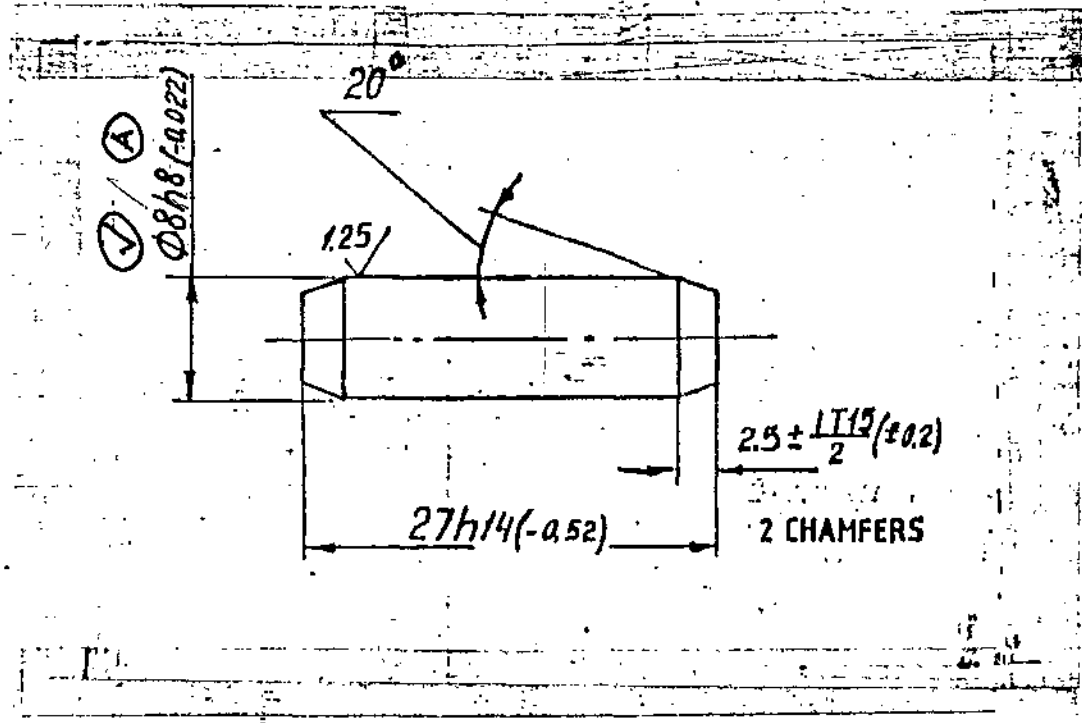
DRN	Shalabh
CHD	Rajan
TCO	Navin Puri
APPD	Shankar
DATE	25-3-'86
SCALE:	1 : 1
DIMENSIONS IN	mm
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS :	2102-69
ALL THREADS TO CONFORM TO	

MATERIAL: ROUND-BAR (C) GOST 7417-75 \* USED ON: 3311-20-10  
45 GOST 1051-73 \* 3311-20-6  
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI

TITLE: STUD M8x32  
D S CAT NUMBER  
DRAWING NUMBER 350 123

DRAWING NUMBER  
352-18-1

READ ✓ (✓)



EXPLANATORY NOTE :-

MATERIAL QUOTED:- ROUND GOST 7417-75  
45GOST 1051-74

45 = GRADE OF STEEL

CHEMICAL COMPOSITION % (AS PER GOST 1050-74)

- CARBON = 0.42 - 0.50
  - SILICON = 0.17 - 0.37
  - MANGANESE = 0.50 - 0.80
  - CHROMIUM = 0.25
  - PHOSPHORUS = 0.035
  - SULPHUR = 0.040
  - COPPER = 0.25
  - NICKEL = 0.25
- } MAXIMUM

MECHANICAL PROPERTIES (AS PER GOST/1050-74)

- TENSILE STRENGTH  $\text{kgf/mm}^2$  (min) = 61
- YIELD POINT  $\text{kgf/mm}^2$  (min) = 36
- RELATIVE ELONGATION % (min) = 16
- REDUCTION IN AREA % (min) = 40
- IMPACT STRENGTH  $\text{kgf/cm}^2$  (min) = 5

1. ALTERNATE MATERIAL: STEEL OF GRADES 40 AND 50, GOST 1050-74
  2. COATING: CHEMICAL OXIDATION AND OIL-FINISHING.
  3. REPAIR SIZE DIMENSIONS ARE ADDED WHERE INDICATED
- (A) THUS (✓) BASED ON OVERHAUL SPECIFICATION PART III REPAIR DRAWINGS. \*\*

S.No	R <sub>1</sub>	R <sub>2</sub>	REMARKS
1	∅8.5 - 0.022	∅9 - 0.022	ALL OTHER CONDITIONS AS PER STD DRG.

(B) EQUIVALENT MATERIAL  
STEEL O80M40 (EN8) TO BS 970 OR  
45 CB TO IS 1570

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

EST. WT. 0.0105kg 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	CHD	TCD	APPO	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69.	MATERIAL:- ROUND GOST 7417-75 45GOST 1051-74	USED ON CB 303-03-11
				30-09-88	2:1			CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.	
TITLE								PIN 8 x 27	
D S CAT NUMBER								DRAWING NUMBER	
								352-18-1	
ISSUE	DATE	NATURE OF AMENDMENTS							
B	10-7-10	4th ALT. COMM. Mfg. MINUTES POINT No 7 DT. 26-10-09			ALL THREADS TO CONFORM TO				
A	11.1.96	REPAIR SIZE DIMNS ADDED							

EXPLANATORY NOTE ADDED ON 18-9-91

Issue 1 - BK 83-683

SIZE A3