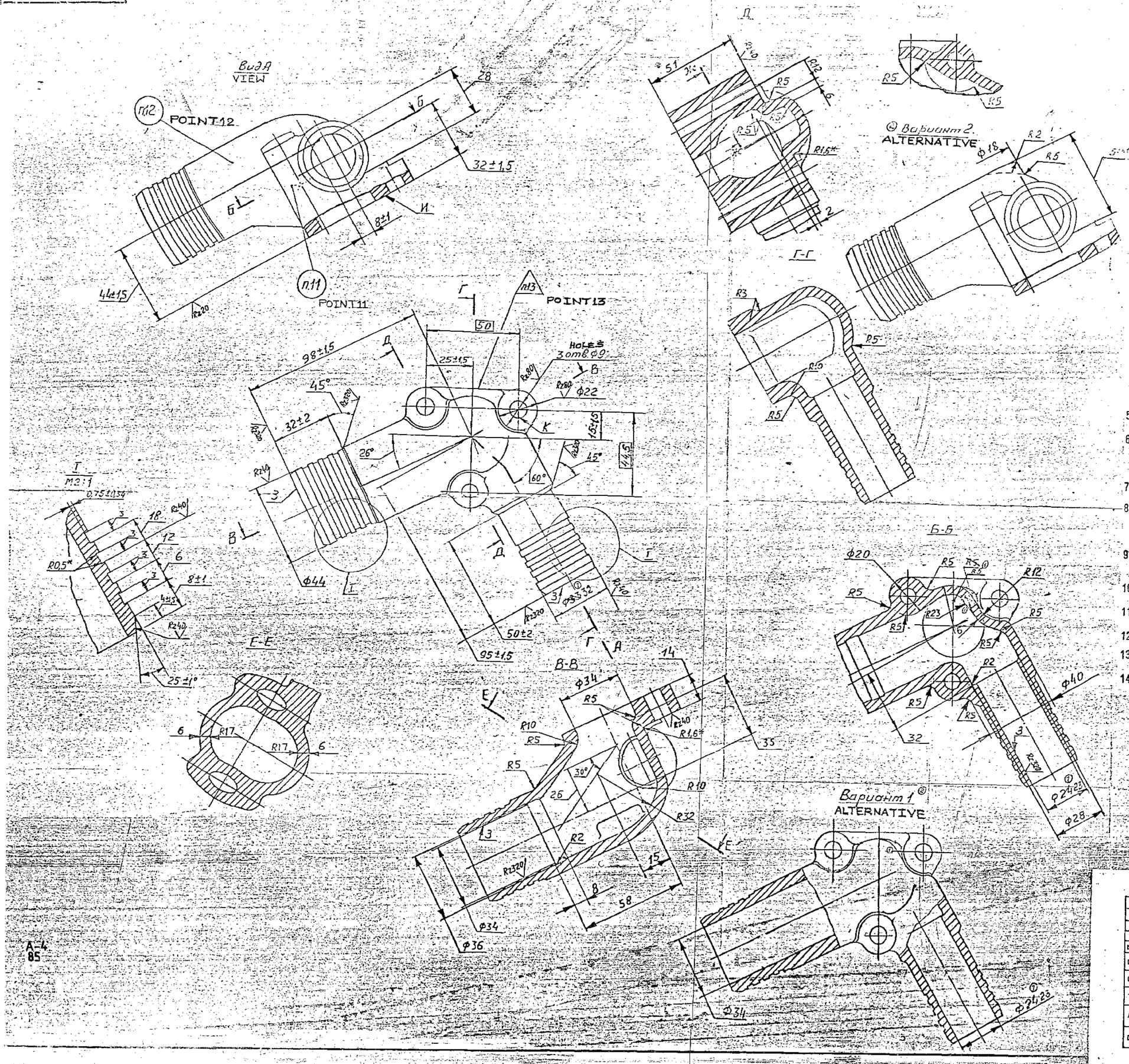

1. Requirements for casting should be in accordance with TTM - 65 - 78.
2. Components should be subjected to a pressure test with water at a temperature of 60 to 80°C under a pressure of 2.5 - 3 Kgf/cm² for 2 minutes. Leakage of water is not permitted. Component may be subjected to a pressure test with air under a pressure not less than 4 Kgf/cm² in water bath for 1-2 minutes.
3. Unmachined surfaces are to be coated with phenol-formaldehyde lacquer UA-10-73.
4. Unspecified maximum diametrical and linear tolerances castino dimensions are: For diameters and linear dimensions $^{+1.5}_{-1.0}$ mm upto 50 mm. $^{+2.0}_{-1.5}$ mm above 50 mm. Unspecified maximum tolerance of machined holes: as per A7, shafts. as per B7. Others: as per cm8.
5. Drafts: 2° beyond tolerance on casting dimension.
6. Shift of axes of holes K from the true position should not exceed 0.2 mm (MMC)
7. Non-flatness of surface И should not exceed 0.1 mm.
8. Minimum wall thickness should be 3 mm at places of machining.
9. Rough spots on surface 3 are permissible.
10. *Dimensions are to be ensured by tool.
11. Material grade is to be marked.
12. Component number is to be marked.
13. To be punched.
14. *1 Dimensions for reference.

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

			EST. MASS 0.368 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS #
			LETTERS 1	
			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		SCALE : 1 : 1	MATERIAL : AA9 - GOST 2685-75	USED ON : СЗ 406-13-44
CHD		DIMENSIONS IN mm		
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
APPD			TITLE : ELBOW FOR DRAINING WATER FROM CYLINDER HEAD L. N	
DATE 29-01-85		ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER 406-35-18

A-4
85