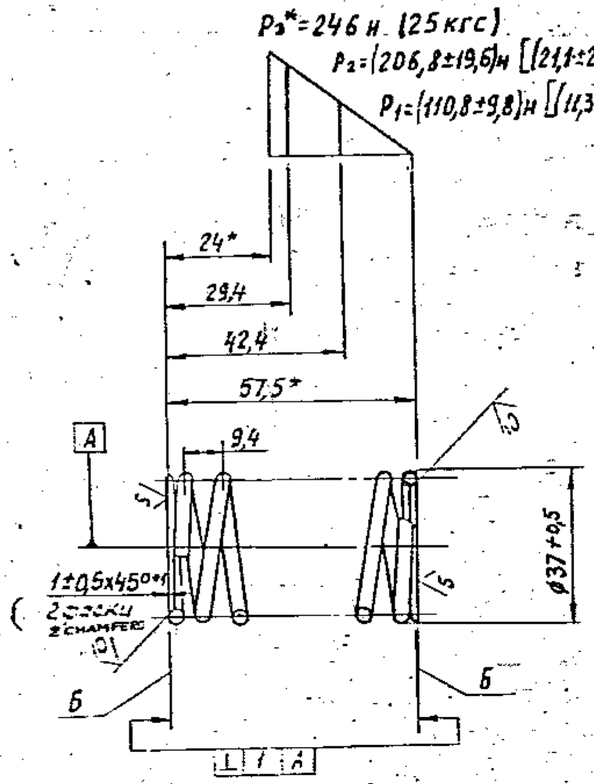
DRAWING NUMBER
306-66-2A



1) DIRECTION OF SPRING COILING – L,H .

2) LENGTH OF DEVELOPED SPRING – 770mm .

3) NUMBER OF WORKING COILS — 5-25 .

4) TOTAL NUMBER OF COILS – 7,25±0,5 .

5) INTERNAL DIAMETER OF SPRING SHOULD BE CHECKED BY A CHECKING BAR (Φ29,8-0,03mm) THE SPRING SHOULD GO DOWN THE VERTICAL CHECKING BAR BY GRAVITY .

6) CHECKING UNDER LOADS P1 AND P2 IS COMPULSORY FOR EVERY SPRING .

7) THICKNESS OF THE RESTING COIL END SHOULD BE NOT LESS THAN 0,8mm .

8) THE GAP BETWEEN THE END OF THE RESTING COIL AND THE ADJACENT WORKING COIL SHOULD NOT EXCEED 0,4mm .

9) RESTING SURFACE Б SHOULD HAVE AT LEAST 5/8 OF THE LENGTH OF THE COIL CIRCUMFERENCE .

10) THE GAP BETWEEN SURFACE Б AND THE SURFACE PLATE SHOULD NOT EXCEED 0,2mm .

11) INCREASES OF THE EXTERNAL DIAMETER OF THE RESTING COILS UP TO 37,75mm. MAX. IS PERMISSIBLE .

12) VARIATION IN THE PITCH OF THE NON LOADED SPRING SHOULD NOT EXCEED 0,5mm .

13) PERMANENT DEFORMATION AFTER COIL TO COIL COMPRESSION OF THE SPRING IS NOT PERMISSIBLE .

14) COATING : LACQUER ГФ95 AS PER И.Л. 09-73 CONTACT PLACES OF THE RESTING COILS MAY NOT HAVE COATING .

(2A) 15) SPRING SHOULD BE HARDENED BY SHOTS AS PER UM ~~159-75~~ 508-83 .

16) RESTING SURFACES Б MAY BE GROUND AFTER HARDENING THE SPRING BY SHOTS .

17) THE COMPONENT SHOULD BE CHECKED FOR DEFECTS BY MAGNETIC FIELD FLAW DETECTOR. TECHNICAL REQUIREMENTS AND ACCEPTANCE RULES ARE IN ACCORDANCE WITH TECHNICAL REQUIREMENTS UB – 17 .

18) * DIMENSIONS AND PARAMETERS ARE FOR REFERENCE .

19) *1 DIMENSION AFTER HARDENING THE SPRING BY SHOTS .

(2A) ~~20) ALTERNATE MATERIAL WIRE 51-ФА GOST 1071-81 .~~

EXPLANATORY NOTE :

MATERIAL QUOTED : WIRE I – 3.5, 68ГА GOST 1071-81.

ALTERNATE MATERIAL QUOTED : WIRE 51XФA GOST 1071-81.

WIRE = HEAT TREATED STEEL SPRING WIRE.

I = CLASS I BY MECHANICAL PROPERTIES.

3.5 = DIAMETER OF WIRE WITH NORMAL ACCURACY ± 0.03.

68ГА = GRADE OF WIRE AS PER GOST 1071-81.

WIRE 51XФA = GRADE OF WIRE MADE FROM ALLOY STEEL AS PER GOST 14959-79.

11 (a) CHEMICAL COMPOSITION : % FOR GRADE 68ГА AS PER GOST 1071-81.

CONTENT OF ELEMENTS								
C	Si	Mn	S	P	Ni	Cr	Al	Cu
			MAXIMUM					
0.65-0.76	0.15-0.25	0.70-1.00	0.025	0.025	0.20	0.12	0.05	0.15

b) MECHANICAL PROPERTIES :- AS PER GOST 1071-81 FOR GRADE 68ГА.

1. ULTIMATE STRENGTH [illegible] Kgf/mm² = 150 - 180

2. No: OF BENDS (min) = 7

2 (a) CHEMICAL COMPOSITION : % FOR GRADE 51XФA AS PER GOST 14959-79.

C	Si	Mn	Cr	VANADIUM	S	P
					MAXIMUM	
0.47-0.55	0.15-0.30	0.30-0.60	0.75-1.10	0.15-0.25	0.025	0.025

b) MECHANICAL PROPERTIES : AS PER GOST 14963-78

ULTIMATE RUPTURE STRENGTH = 105 Kgf/mm² (max)

(3) ** MATERIAL:-
Wire 51XФA-K-1A-II-Д-3.5
GOST 1071-81.
(3A) CQA(HV)5.06.606E
CQA(HV)5.06.610E

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

EST. WT.	TO BE STAMPED OR MARKED WHERE INDICATED THUS ⊕
0.857 Kg	(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
3A	15.7.15	Pt. 11, 7th Alt. Comm. Meeting Dt. 11.4.12
3	4.12.08	NOTN. No: 436-03 (F-158)
2A	18.5.94	AUTHY. Notn. No. BK 84-704.

DRN
CHD
TCD
APPD
DATE 23-5-89
SCALE :- 1 : 1
DIMENSIONS IN mm.
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69
ALL THREADS TO CONFORM TO

MATERIAL :- ** (3)
WIRE I 3.5 / 68ГА GOST 1071-81.

USED ON :- CB-20-06-12-6
Cb 486-12-44, CB-20-06-13-6
Cb 486-13-44 CQA(HV)-117-2

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)
A V A D I

TITLE
VALVE SPRING SMALLER

D S CAT NUMBER

DRAWING NUMBER
306-66-2A

SIZE A2

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 2 (BK 82-309)
KVD NO 78117