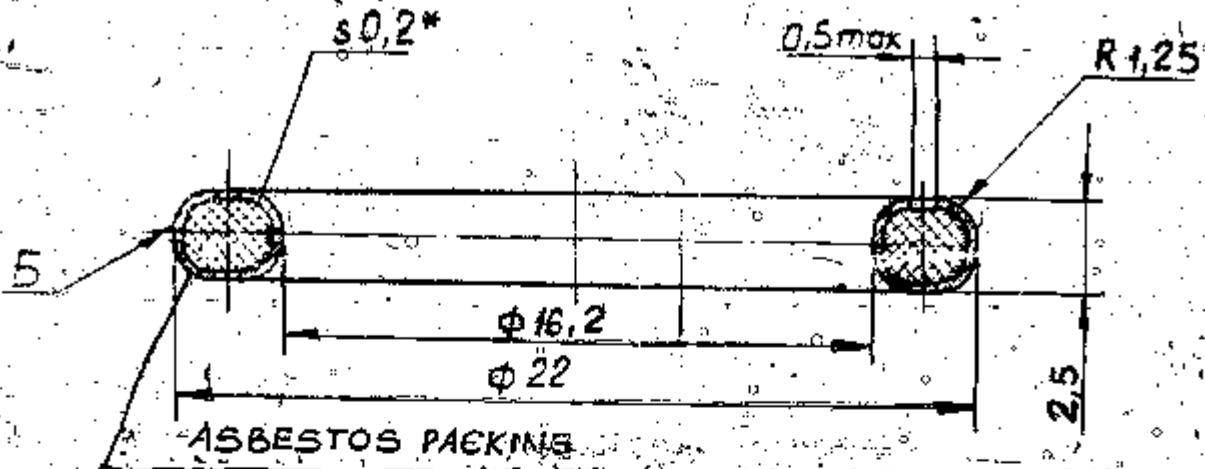


355-11



- 1 ALTERNATE MATERIAL IS STRIP 0,22 TO 0,3mm THICK GOST 1173-77.
- 2 TOLERANCE ON ROUNDNESS OF SURFACE B SHOULD BE WITHIN THE DIAMETER TOLERANCE.
- 3 USED FOR PACKING IS ASBESTOS CORD WAOH 1,5 GOST 1779-72.
- 4 RINGS SHOULD BE TIGHTLY FILLED WITH PACKING.
- 5 DISPLACEMENT OF SHEATHING EDGE FROM THE MEAN DIAMETER OF RING SHOULD NOT EXCEED 0,35mm.
- 6 PROJECTION OF ONE EDGE OF SHEATHING IN RESPECT TO THE OTHER ONE SHOULD NOT EXCEED 0,3mm.
- 7 PROJECTION OF ASBESTOS FIBRE IF NEGLIGIBLE BEYOND THE SHEATHING JOINT IS PERMITTED.
- 8 UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:- FOR HOLES - AS PER A7
SHAFTS - AS PER B7.
AND OTHERS - AS PER CM7.
- 9 MARK DESIGNATION, DATE OF MANUFACTURE AND STAMP FINAL ACCEPTANCE ON THE TAG FOR BATCH OF PARTS.
- 10 *DIMENSION IS GIVEN FOR REFERENCE.

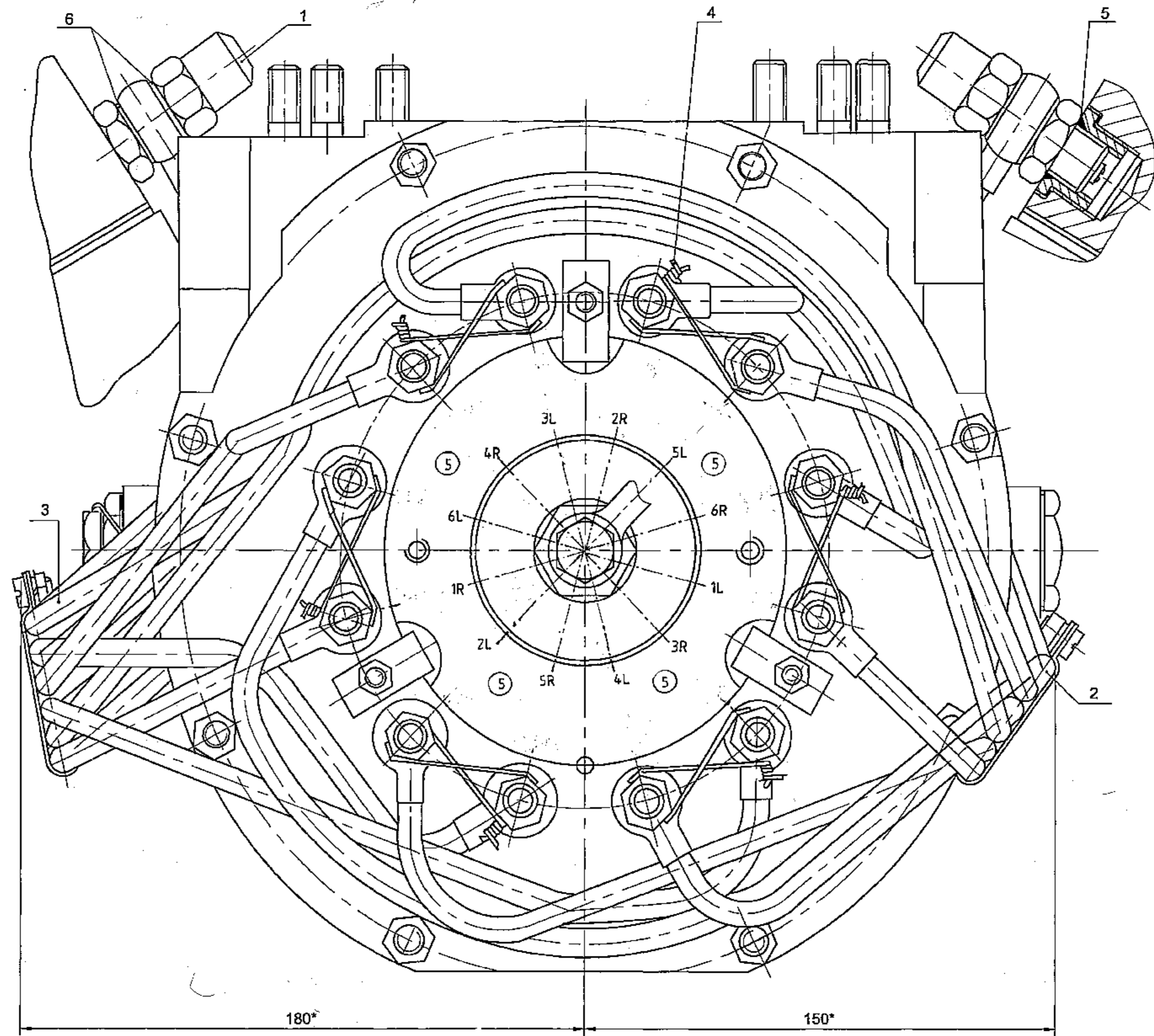
Ⓐ ** CQA(HV) 5.06.001E

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

			EST. MASS 100 PIECES 0,12 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS \square LETTERS)
A	10-03-75	Pl. 11 of 7th All. Comm. Meeting 01.11-4-72	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 - STRIP 0,2 M3 GOST - 1173-77	USED ON - CB 310-00-7C6 ** CB 20-01-00-8
DRN		SCALE - 5:1	CONTROL LITATE OF INSPECTION (HEAVY VEHICLES) AVADI	
LDN		DIMENSIONS IN mm	TITLE COPPER ASBESTOS SEALING RING 16-22	
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	O S CAT NUMBER	DRAWING NUMBER 355-11
APPD		ALL THREADS CONFORM TO		
DATE	19/8/77			



DRAWING NUMBER
Cb.322-00-9



1. Gap between pipes and adjoining parts should be minimum 1.5mm while mounting (except the fastening area).
2. Mounting of pipe lines on the engine to be carried out as per technical requirement *ИВ-152Д*.
3. Components and assembly units having conventional symbol "T И", in the part list of given drawing in "remarks" column, should have tropicalized construction, as specified in the drawing for components.
4. * Dimensions are given for reference.

DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 4

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: 1:1	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69	ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
MATERIAL :-								USED ON :- Gen. Assy.	
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI								TITLE :- COMPRESSED AIR STARTING TUBING ASSY	
ISSUE								DATE	
NATURE OF AMENDMENTS								DRAWING NUMBER Cb.322-00-9	

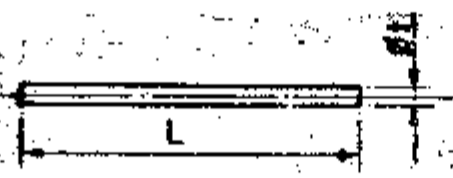
F-4
144
253
SIZE A1







DRAWING NUMBER
354-22



KVD NO	L mm	LMY DEVIATIONS mm	USED ON
	50	±1.5	
78705	60	±1.5	CB 3338-401-10 CB 3330-200
78706	80	±2	CB 3334-00-7 CB 327-00-45
78707	100	±2	CB 3338-00-16 CB 327-00-45 CB 3335-00-24 CB 3334-00-8CB
78708	120	±2	CB 419-00-4 CB 310-00-7 CB 322-00-4CB CB 20-22-00-7
78709	160	±2	CB 327-00-45 CB 3335-00-24 CB 3334-00-2
78710	200	±2	CB 327-00-45 CB 3334-00-27
78711	260	±3	CB 3334-10-27 CB 20-29-00-8
78712	350	±3	CB 3334-407-4 CB 3329-00-13
78713	430	±3	CB 411-00-41
78714	500	±3	CB 327 00 45
	600	±3.5	
	800	±5	

ADDITIONAL REQUIREMENTS

- PER MANUFACTURE OF LOCK WIRE AS PER DRAWING 354-22
1. THE WIRE SHOULD BE PROVIDED WITH ZINC COATING. DIAMETER OF WIRE AFTER COATING SHOULD BE 1.38 mm
 2. QUALITY OF WIRE SHOULD NOT EXCEED HALF OF THE TOLERANCE ON DIAMETER
 3. THE WIRE SHOULD BE MANUFACTURED FROM LOW CARBON ROLLED STEEL AS PER GOST 1050-74
 4. ULTIMATE RUPTURE STRENGTH OF ZINC PLATED WIRE SHOULD NOT BE LESS THAN MPa (37 Kg/mm²)
 5. THE WIRE SHOULD WITHSTAND NOT LESS THAN 7 BENDINGS THROUGH 180° AND NOT LESS THAN 25 TWISTINGS THROUGH 360°
 6. THE SURFACE OF WIRE SHOULD NOT HAVE BLOW HOLES, CRACKS, MARKS, BLACK FILMS, OXIDE SPOTS, BURRS AND RUST. THERE SHOULD NOT BE ANY UNCOATED AREAS ON THE WIRE.
 7. ON WIRE FRACTURE, THERE SHOULD NOT BE ANY CRACKS, BUCKLES, FISSURES, BLISTERS, AND SHRINKAGE CAVITIES
 8. WIRE ZINC COATING SHOULD BE BOUND TO THE STEEL WHEN WOUND ON CYLINDER WITH DIAMETER EQUAL TO WIRE FIVE FOLD DIAMETER, THE WIRE SHOULD NOT HAVE ANY PEELINGS AND FISSURES OF ZINC COATING.

EXPLANATORY NOTE:-

REFERENCE MATERIAL QUOTED:- LOW CARBON STEEL
To GOST 1050-74.

CHEMICAL COMPOSITION %

GRADE	C	Si	Mn	MAXIMUM				
				Cr	P	S	Cu	Ni
15	0.12-0.19	0.17-0.37	0.35-0.65	0.25	0.035	0.040	0.25	0.25

MECHANICAL PROPERTIES

1. ULTIMATE TENSILE STRENGTH Kgf/mm² (min) = 38
2. YIELD POINT Kgf/mm² (min) = 23
3. PERCENTAGE ELONGATION % (min) = 27
4. REDUCTION IN AREA % (min) = 55
5. HARDNESS BHN (MAX) = 149

COMMON TO V-92S2 & UTD-20 ENGINES

(E) EQUIVALENT MATERIAL IS: 549

(D) ** ITEM USED IN VARIOUS LENGTHS ON VARIOUS ASSEMBLIES OF V46-6, V92-S2, & UTD-20, ENGINE.

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

EST. WT. 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	APPROVED	MATERIAL	USED ON: CB 20-35-00-5 CB 3338-402-4 CB SEE TABLE **
CHO	APPROVED		
TCD	APPROVED		
APPD	APPROVED		
DATE	18-3-86	CONTROL RATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	AVADI
F	15-7-15	Pt. 11 of 7th Alt. Comm. Meeting Dt: 11-4-12	
E	8-7-10	4th ALT. COMM. Mtg. MINUTES POINT No. 5 Dt: 26-10-09	
D	28.8.08	USED ON NUMBER ADDED	
C	30.6.01	AUTHY 90211/AKSP/ED dt 27.3.01	
B	15.1.02	AUTHY LE No. 11002671NB-II, / 522 dt 12.1.02	
A	15.2.88	AUTHY NOTN NO. BK 81-406	
ISSUE	DATE	NATURE OF AMENDMENTS	
		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	TITLE LOCK WIRE
		ALL THREADS TO CONFORM TO	D.S CAT NUMBER
			DRAWING NUMBER 354-22



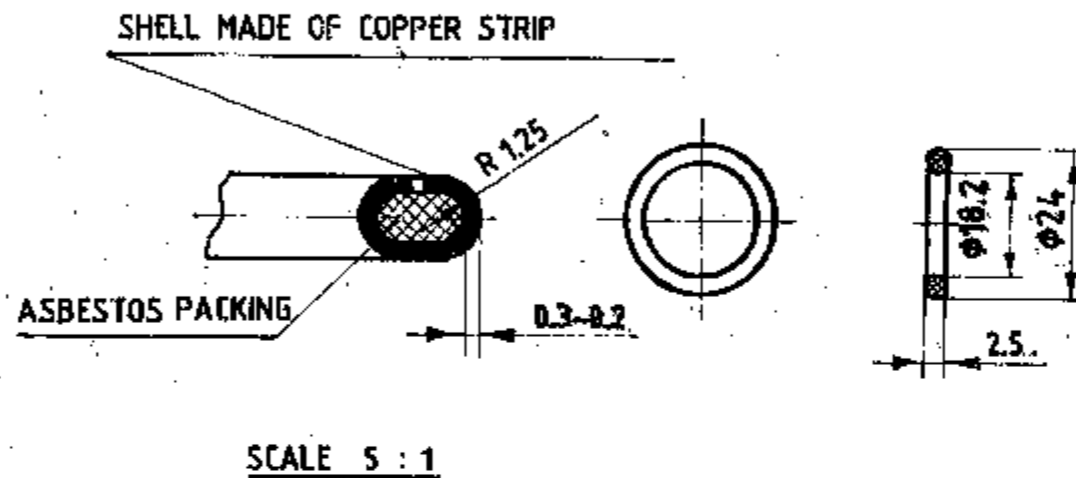
DRAWING NUMBER
355 08

EXPLANATORY NOTE:

1. REFERENCE MATERIAL QUOTED:

COPPER ASBESTOS SEALING RING 18.2mm I/D, 24mm O/D AND MANUFACTURED IN ACCORDANCE WITH MH 4152-62.

- a) COPPER SHEATH RING :- SOFT COPPER BAND GRADE M3 TO GOST 859-78.
- b) CORE- BRAIDED ASBESTOS CORD MADE OF CHRYSOTILE.
- c) CHEMICAL COMPOSITION AS PER GOST 859-78.



GRADE OF COPPER	CONTENT OF ELEMENTS %									
	COPPER & SILVER min	IMPURITIES MAXIMUM								
		Bi	Sb	AS	Fe	Ni	Pb	Sn	S	O
M3	99.5	0.003	0.05	0.01	0.05	0.2	0.05	0.05	0.01	0.08

COMMON TO V-92S2 & UTD-20 ENGINES

* (A)

(C) CQA(HV)5.06.001E

(B) { CQA(HV)5.07.502E
CQA(HV)5.07.504E

Ch 3304-15-30, Eb 3320-00-33, Cb 3301-00-44, Cb 3301-15-44, Cb 310-44, Cb 3335-00-24
 Cb 3335-00-24, Cb 20-01-00-8, Cb 3320-00-43, Cb 3335-00-9, Cb 337-100
 Cb 20-11-02-11, Cb 20-22-00-7, Cb 413-115-9, Cb 322-00-9, Cb 327-00-73, Cb 3338-404-7
 Cb 329-00-7, Cb 447-00-1, 346 01 3 Cb
 Cb 306-01-20, Eb 306-02-20, Cb 310-31, 346 00 Cb
 Cb 322-00-4, Cb 406-16-2, Cb 406-17-2, 176-32 Cb
 Eb 413-115-6, Cb 3300-00-27 CX

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

EST WT 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	CHD	TCD	APPD	DATE	SCALE	MATERIAL:	USED ON:
					1:1	M3 AND ASBESTOS	CB 413-115-6 CB 3329-01-11 Cb 447-00-1 CB 327-00-45 *
DIMENSIONS IN mm						CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED						TITLE:	
ALL THREADS CONFORM TO:						RING 18 x 24	
ISSUE DATE NATURE OF AMENDMENTS						D S CAT NUMBER DRAWING NUMBER	
						355 08	

(A.11)

SIZE A3

