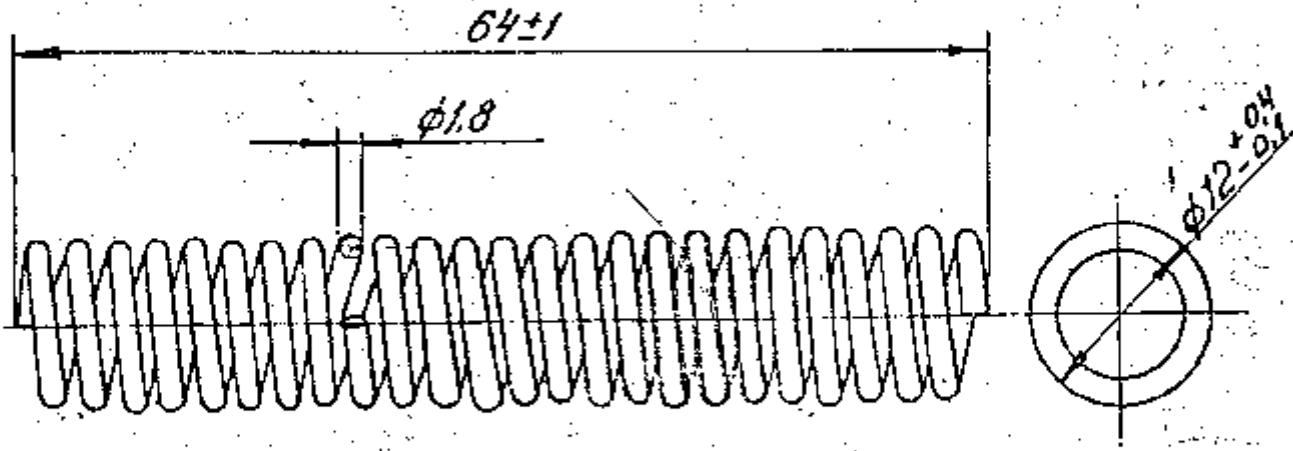


COILING

✓ R.H.  
C



1. Група контроля - по ТУ И. (2)
2. Неравномерность шага не более 0,2 мм.
3. Пружину проверять по чертежу сб. 3315-603-2.
4. Острые кромки затушить.
5. Длину подогнать в узле.

2. IRREGULARITY OF PITCH SHOULD NOT EXCEED 0.2 MM.
3. SPRING SHOULD BE CHECKED AS PER DRAWING CB 3315-603-2.
4. SHARP EDGES SHOULD BE BLUNTED.
5. LENGTH SHOULD BE ADJUSTED IN UNIT. (A-6)

(A) EQUIVALENT MATERIAL

Gr. DH/DM IS: 4454-2001

PILOT SAMPLE SHOULD BE APPROVED BY ATSP BEFORE BULK PRODUCTION

		EST. MASS 0.0175 Kg	TO BE STAMPED ON MARKED WHERE INDICATED THIS # LETTERS
A.	16.8.10	4 <sup>th</sup> Alt. Comm. Meeting Minutes Point No.13 Dt: 26-10-09	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE SPECIFIED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL WIRE 3 A-TI-10 USED DW- CB 3315-603-2 POST 922-75
DRN		SCALE: 2:1	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI
CHD		DIMENSIONS IN mm	
TEC		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	
APPD			REGULATOR SPRING SECOND
DATE	7-4-88	ALL THREADS TO CONFORM TO	D/S CAT. NUMBER
			DRAWING NUMBER 3315-624-2

DRG INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE NO. (NIL)

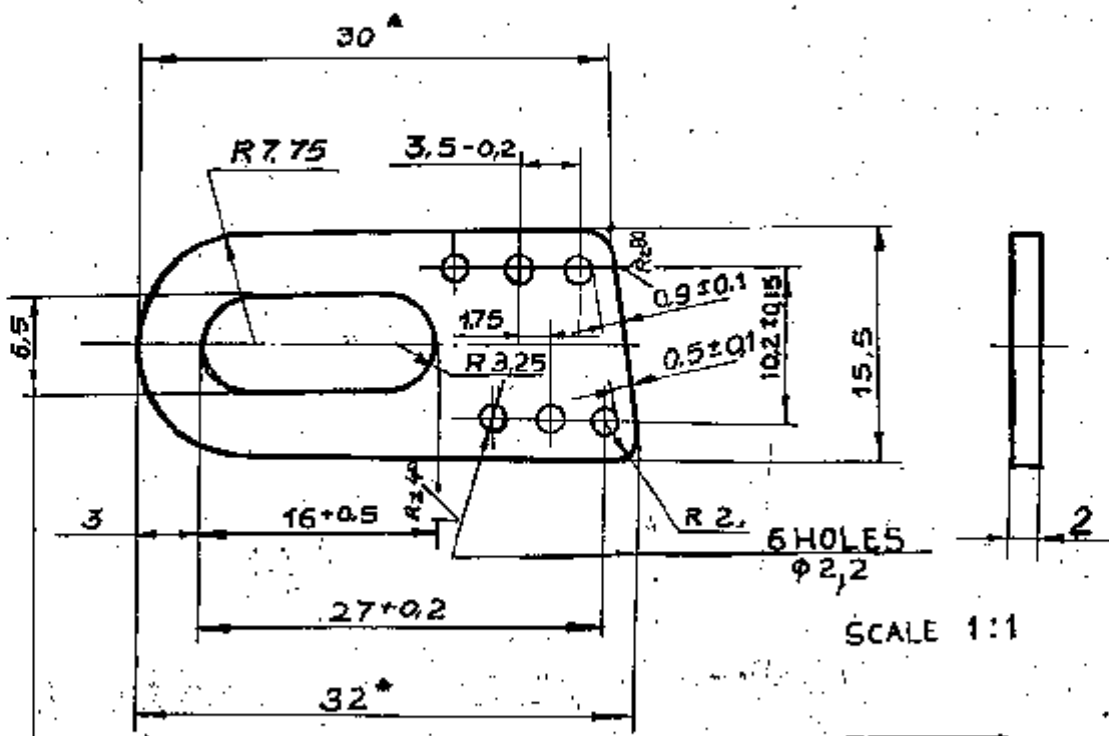
7740  
7740  
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3315-627-2

(V) (V)

DRAWING INDIANISED BASED ON ISSUE 5

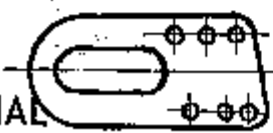


TO BE DRESSED

(B)

EQUIVALENT MATERIAL

Gr. Q. IS:513-1994



1. Inspection group III, T T - 11.
2. To be casehardened by cyaniding all over to depth of 0.1 to 0.2 mm. ~~HRC ≥ 48~~. To be checked with hardness-test file. **HRC ≥ 49**
3. Requirements for stamping as per standard 82050-16
4. Dimensions with unspecified tolerances for machining should be obtained as per A7, B7 OST 1010.
5. After stamping the component should be straightened, the fins should be fettled.
6. \*Dimensions for reference.
7. Face is allowed in the place of transition of inclined surface into radius R 2 mm.

(A-6)

1. 3315-627-2  
 2. 1-7-10  
 3. 1-12-8  
 4. AUTHY BK 82-394, 83-126  
 5. SCALE - 2 : 1  
 6. DIMENSIONS IN mm.  
 7. TOLERANCE ON DIMS UNLESS OTHERWISE STATED  
 8. ALL THREADS CONFORM TO

EST. MASS	0.0048 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS *	(LETTERS)
DATE	1-7-10	NATURE OF AMENDMENTS	4th ALT. COMM. Mtg. MIN. POINT No 2 DT. 26-10-09
DATE	1-12-8	NATURE OF AMENDMENTS	AUTHY BK 82-394, 83-126
ORIGINATOR	SCALE - 2 : 1	MATERIAL	-10-BH-2-0-2 (A) STRIP GOST 503-71 81
CHD	DIMENSIONS IN mm.	USED ON	CB 3315 603 2
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLER	RATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPROVED	ALL THREADS CONFORM TO	TITLE	SECOND SPRING SHACKLE
DATE	23.5.86	D SCAT NUMBER	DRAWING NUMBER 3315 627 2



Число рабочих витков 19 ± 1  
 No. OF WORKING COILS 19 ± 1

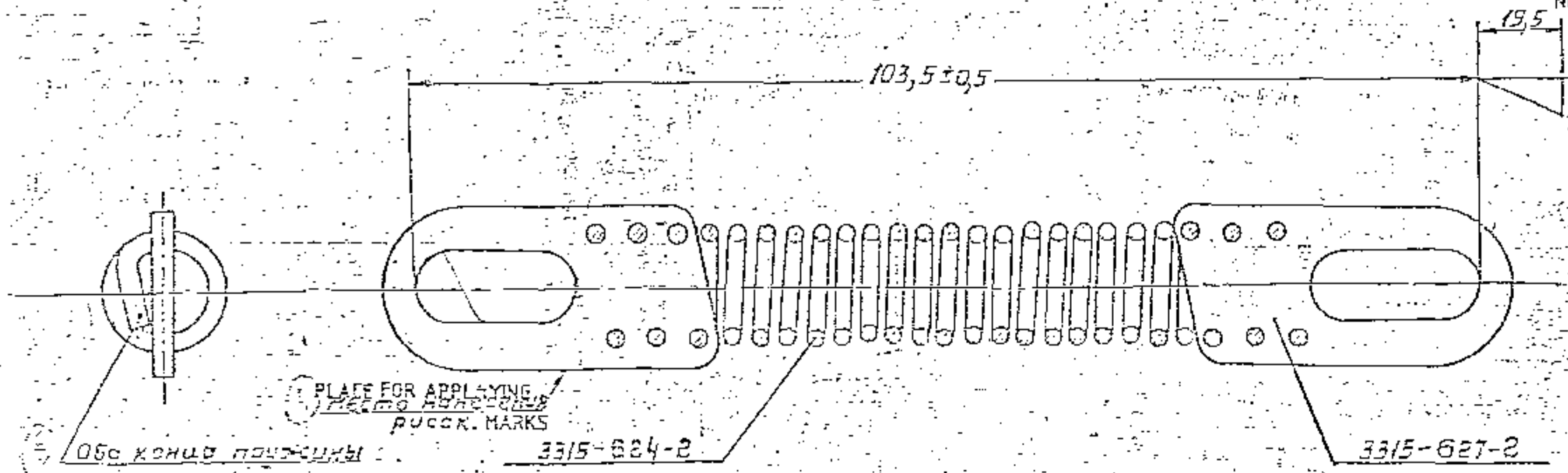


PLATE FOR APPLYING  
 РУССКО-АНГЛИЙСКИЕ  
 РУССК. MARKS

Оба конца пружины  
 придать к шарниру так,  
 чтобы шарнир не мог  
 повернуться.  
 BOTH ENDS OF SPRING SHOULD  
 BE BENT TO SHACKLES IN SUCH A  
 WAY THAT SHACKLES DO NOT TURN.

Цинк-сплав на величину слоя 0,007 ± 0,015 мм с толеран-  
 цией удаления безвредной хрупкости и посветления  
 по ЦЧЗ-154.

Допускается обеспечение нагрузки изменением числа рабо-  
 чих витков в узле.

Пружина по нагрузке делить на 3 группы:

- I группа с нагрузкой 10 ± 0,5 кг
- II группа с нагрузкой 10 ± 0,2 кг
- III группа с нагрузкой 10 ± 0,5 кг

После испытания на нагрузку на одной из серий узлов  
 метить № группы рисками:  
 I группа - одна риска  
 II группа - две риски  
 III группа - три риски

Обе серии волжны лежать в одной плоскости.  
 Покрытие цинком ЦЧЗ-154 с удалением безвредной  
 хрупкости.

Допускается отсутствие цинка на поверхности  
 рисок.

THE FOLLOWING LOADS MAY BE PROVIDED WITH CHANGES IN  
 WORKING COILS IN THE ASSEMBLY.

SPRINGS WITH LOAD MAY BE DIVIDED INTO 3 GROUPS:

- I GROUP WITH LOAD 10 ± 0,5 Kg
- II GROUP WITH LOAD 10 ± 0,2 Kg
- III GROUP WITH LOAD 10 ± 0,5 Kg

AFTER THE LOAD TESTS, MARK THE GROUP NUMBER ON ONE OF  
 THE SHACKLES OF ASSEMBLY. 1st GROUP - ONE MARK.

2nd GROUP - TWO MARKS.  
 3rd GROUP - THREE MARKS.

BOTH THE SHACKLES SHOULD BE LAID ON A SINGLE PLANE.

COATING: Zn.9 TO 15, CHROMATIZING AS PER UJ 483-82  
 REMOVING HYDROGEN BRITTLENESS.

THERE MAY BE NO ZINC COATING ON SURFACES OF MARKS.

11/11/82 2071/11/11/82

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

EST. WT. 0,027 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS # ( LETTERS)
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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	D.S. CAT NUMBER	DRAWING NUMBER
				3-3-68	2:1				CB 3315-603-2
MATERIAL								USED ON	
								CB 315-663-21	
CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES)								A V A D I	
TITLE								REGULATOR SPRING SECOND ASSY	
ISSUE								DATE	
NATURE OF AMENDMENTS									







