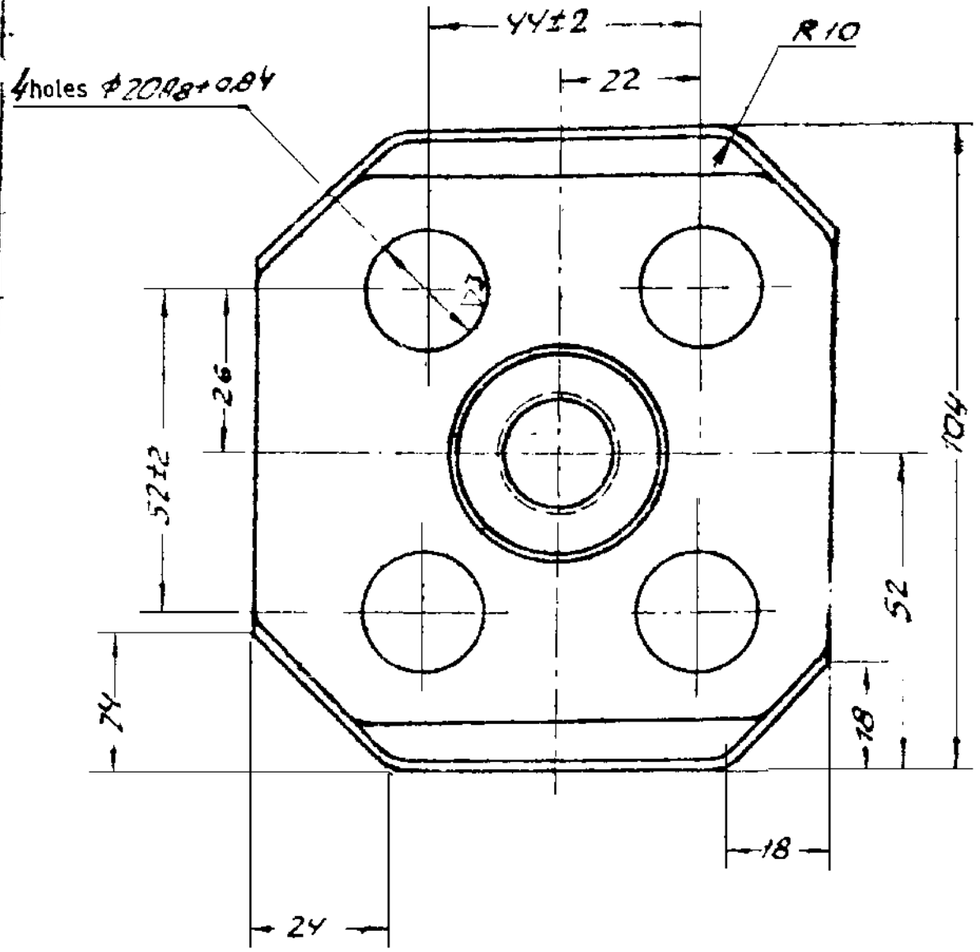
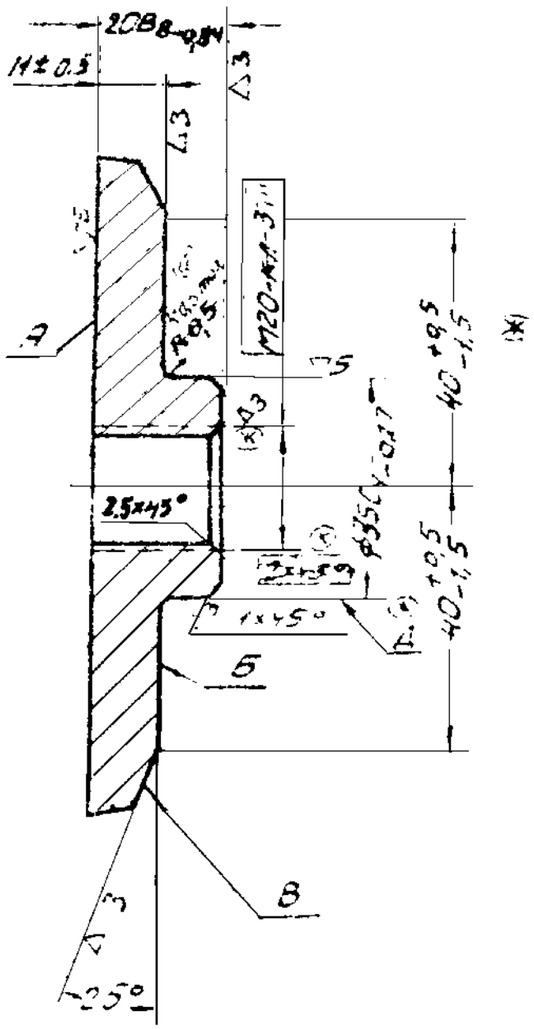
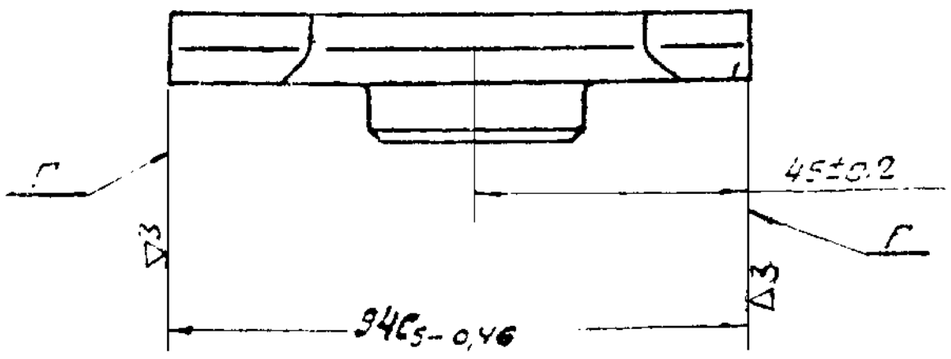
765-33-27







~Unless specified otherwise.

1. Other requirements for forging are as per Class II, GOST 7505-74.
2. Burrs and sharp edges are not allowed.
3. Non-flatness of surface A should not exceed 0.1mm. and surface B should not exceed 0.2mm.
4. Provide in assembly as per dimensions given in [ ]
5. Alternate material is steel Cm3, Steel CM5, GOST380-71 and steel 20,25,30 GOST 1050-74.
6. Local recesses not exceeding 1mm are allowed on the unmachined surfaces.
7. Black spots of any size are allowed on surfaces B and Г.
8. Displacement of thread axis with respect surface A should not exceed 0.3mm.

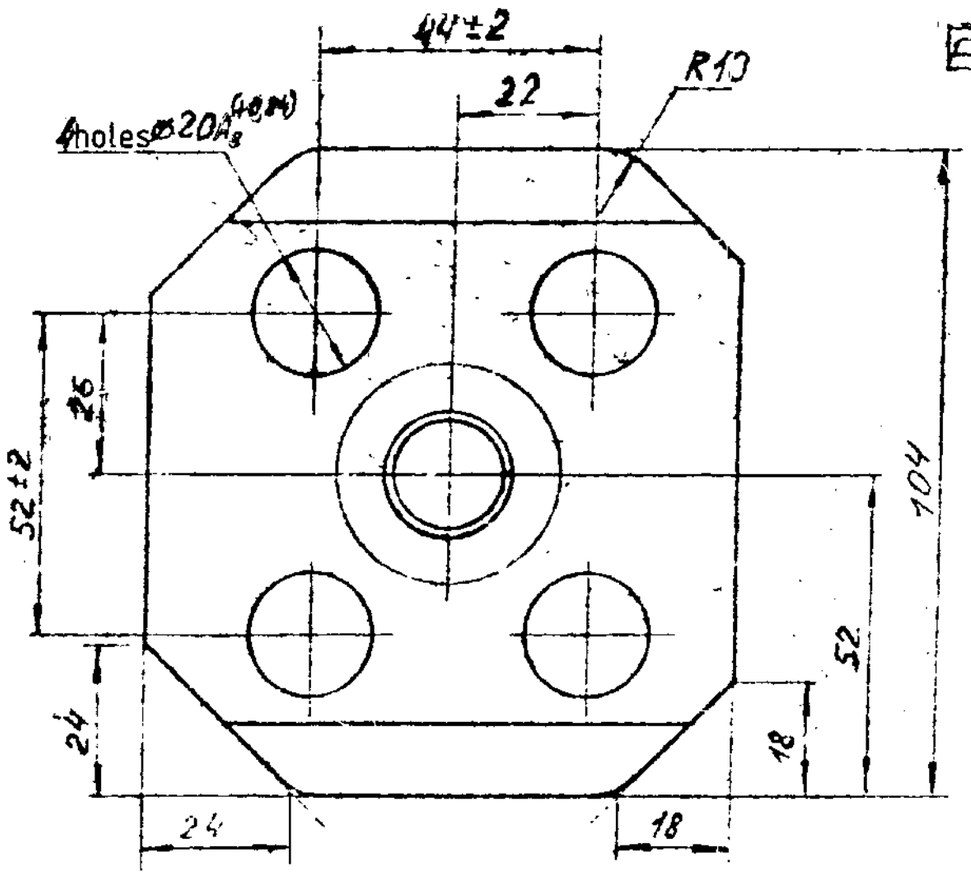
(A) EQ.MATERIAL:- Fe 510 To 15:5986-92 -

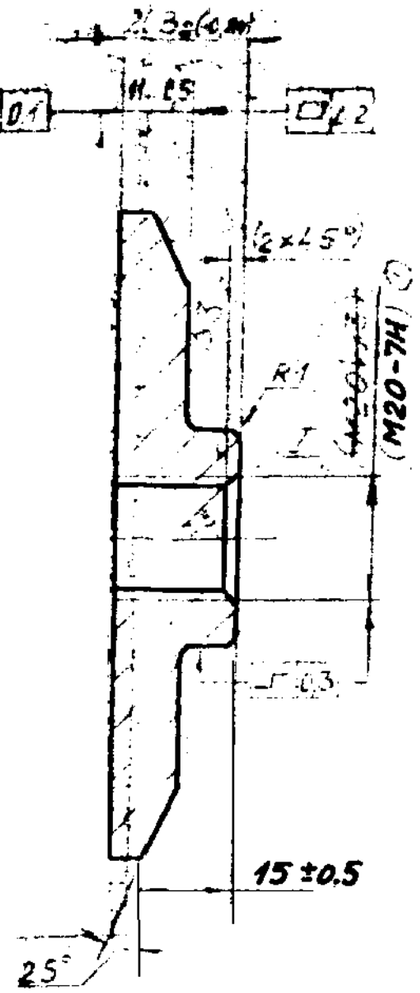
DO 757 ICV V Rao 17-1-2000	(A)	EQ.MATERIAL IS ADDED IN THE DRAWING
DC(I) NO	ISSUE	NATURE OF AMENDMENTS
DATE		

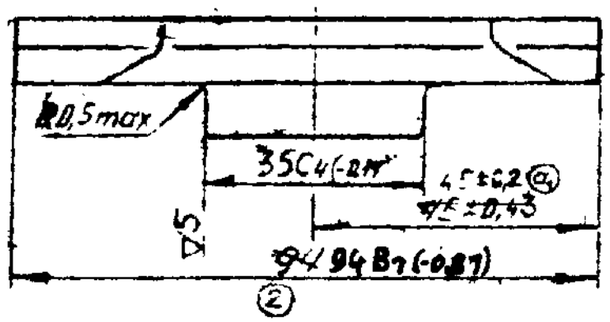
APPROVED	M VASU	765-33-27	
CHECKED	Rathak		WEIGHT 0·63 / SCALE 1:1
CONTROLLERATE OF QUALITY ASSURANCE (ICV) SECUNDERABAD		BASE	SHT / SHTS
		STEEL Cm5 Cn ГОСТ 380-71	74 OF 116

33

765-33-27-K







T / M2:1 Alternate

1. Alternate material is 35Л-7GOST 977-75.
2. Deviation limit for unspecified dimensions are as per Class II GOST 2009-55.
3. Cast radii should not exceed 1mm.
4. Pattern drafts should not exceed 1°.
5. Other requirements are as per OST-3-4365-79.
6. Dimensions given in brackets are after assembly.

Ⓐ EQ. MATERIAL - GRADE 1B TO IS:10343-89.

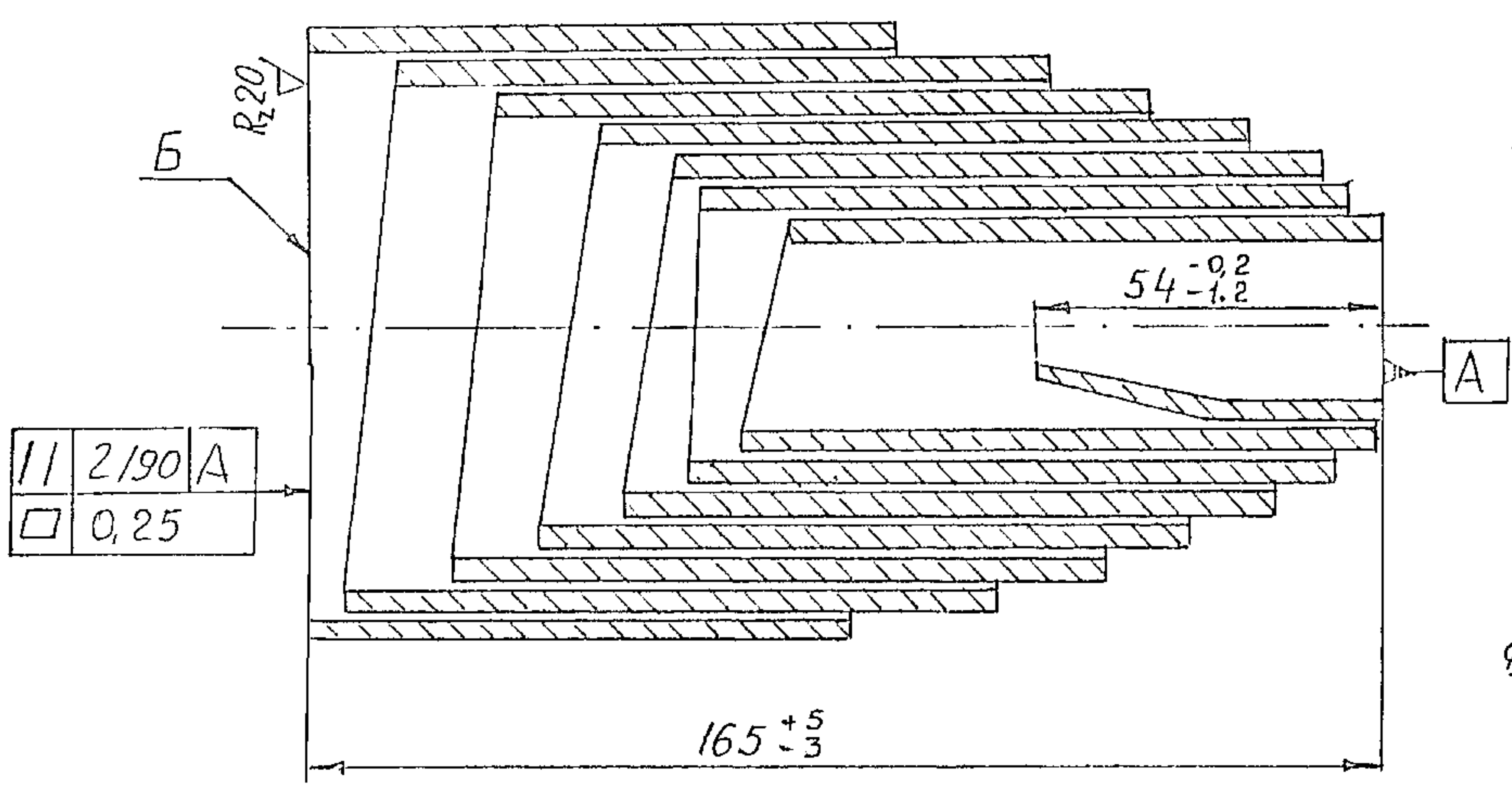
DC(I)No. DATE	ISSUE	NATURE OF AMENDMENTS
00825 31-10-2K	Ⓐ	EQ. MATERIAL ADDED IN THE DRAWING.

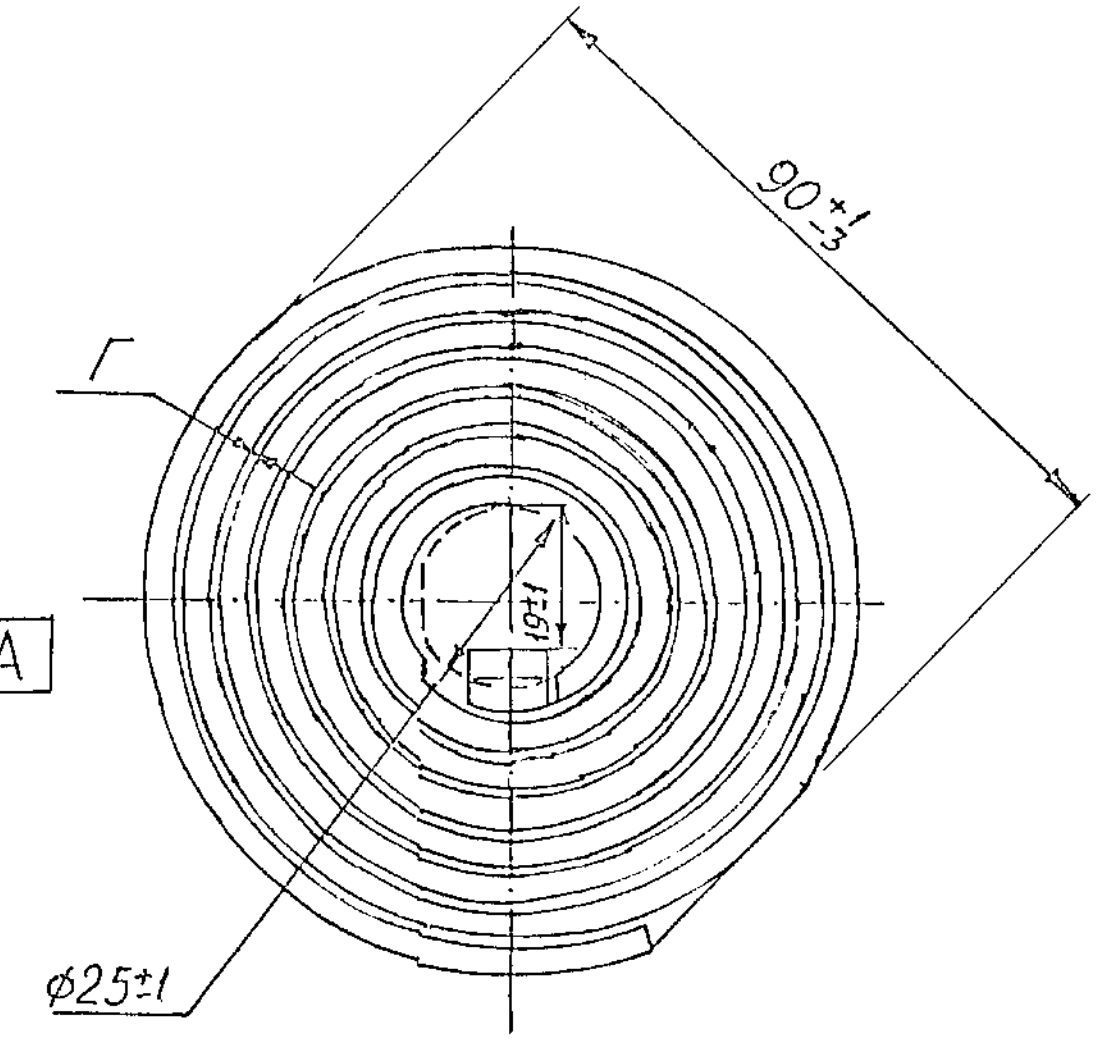
Ⓐ Material: Steel 30Л-ГОСТ 977-75
Group 1 OCT 3-4365-79

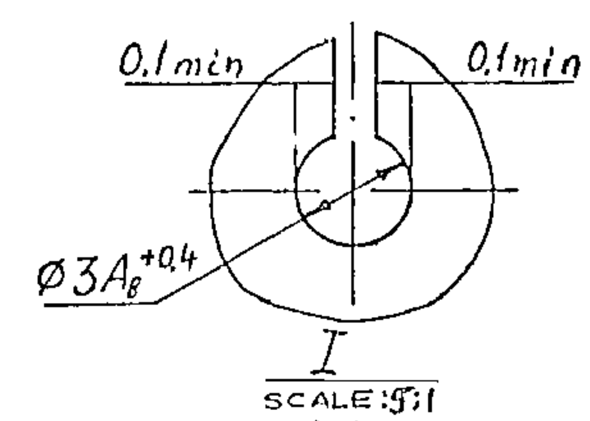
APPROVED	H VASU	765-33-27-K	
CHECKED	Pathak		
CONTROLLERATE OF QUALITY ASSURANCE (ICV) SECUNDERABAD		BASE	WEIGHT 0·63 / SCALE 1:1
			SHT SHTS 75 OF 116

33

765-33-28



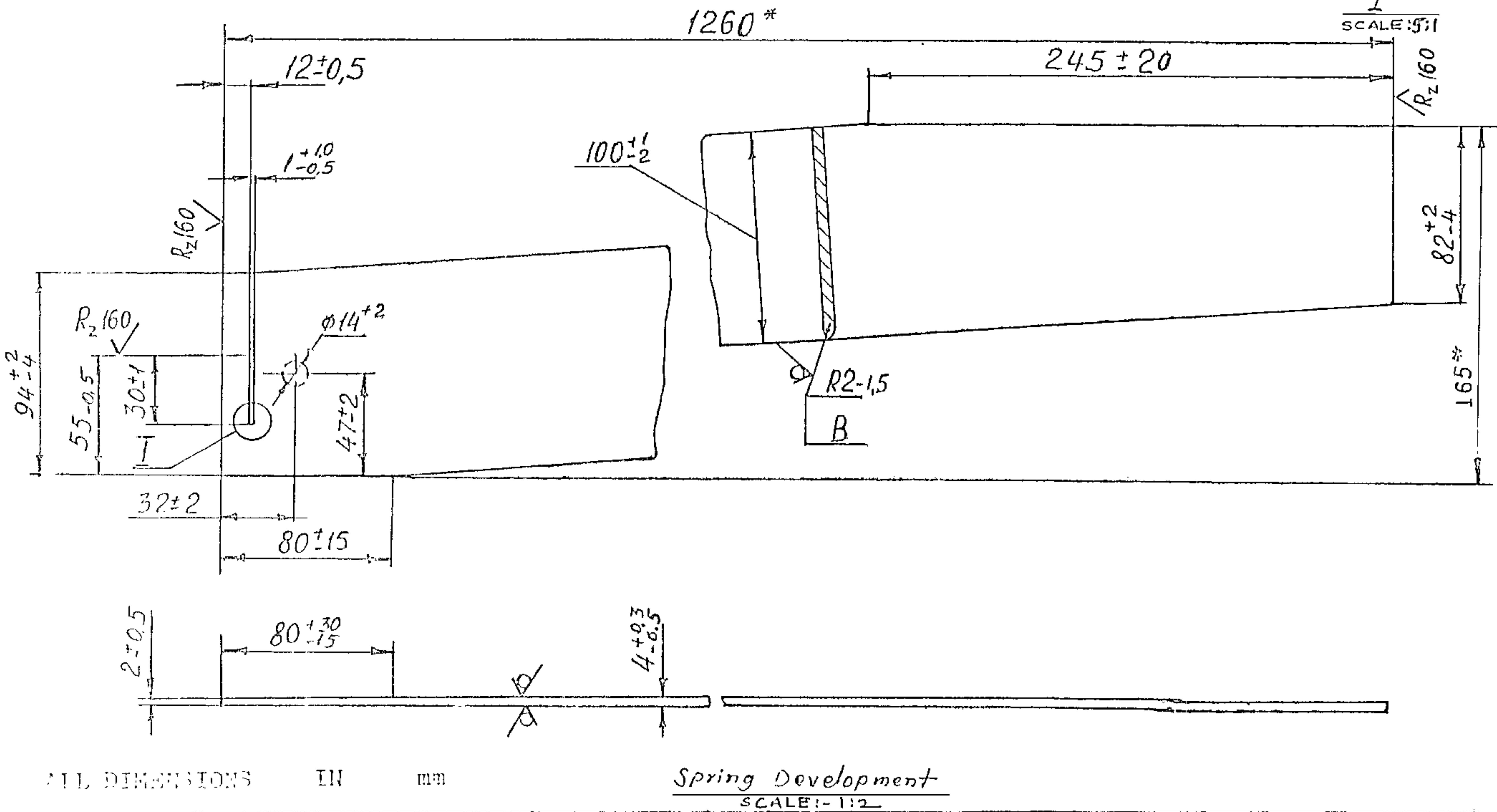




TECHNICAL CONDITIONS

Rz 80 (✓)

1. Scabs, hair cracks and other material faults are not allowed.
2. Direction of spring coiling is arbitrary.
3. n= 5.5 ±0.25
4. n_1 = 7±0.25
5. HB 364 to 477 (ø 3.2 to 2.8). Perform heat treatment in assembly after welding.
6. Alternate material is STEEL 60C2XA GOST 14959-79.
7. Spring may be made as per thick dash-dot line.
8. Clearance between operating coils should be Г= $1_{-0.7}$ mm. Local contact of coils and local clearances not exceeding 2.5 mm are allowed.
9. Surface A should have atleast three points lying in one plane over a length of the coil bearing surface.
10. Non-squareness of surface A and Б with respect to generatrix of the spring outer coil should not exceed 3 mm over a length of 175 mm.
11. Blunting of edges may be performed with making chamfer 0.5 x 45° in place of radius B.
12. When manufacturing from a sheet the grain should be found along the spring development.
13. Stamping draft not exceeding 0.4 mm with blunting of edges with R=$2_{-1.5}$ mm or with chamfer 0.5 x 45° is allowed.
14. * Dimensions are given for reference.



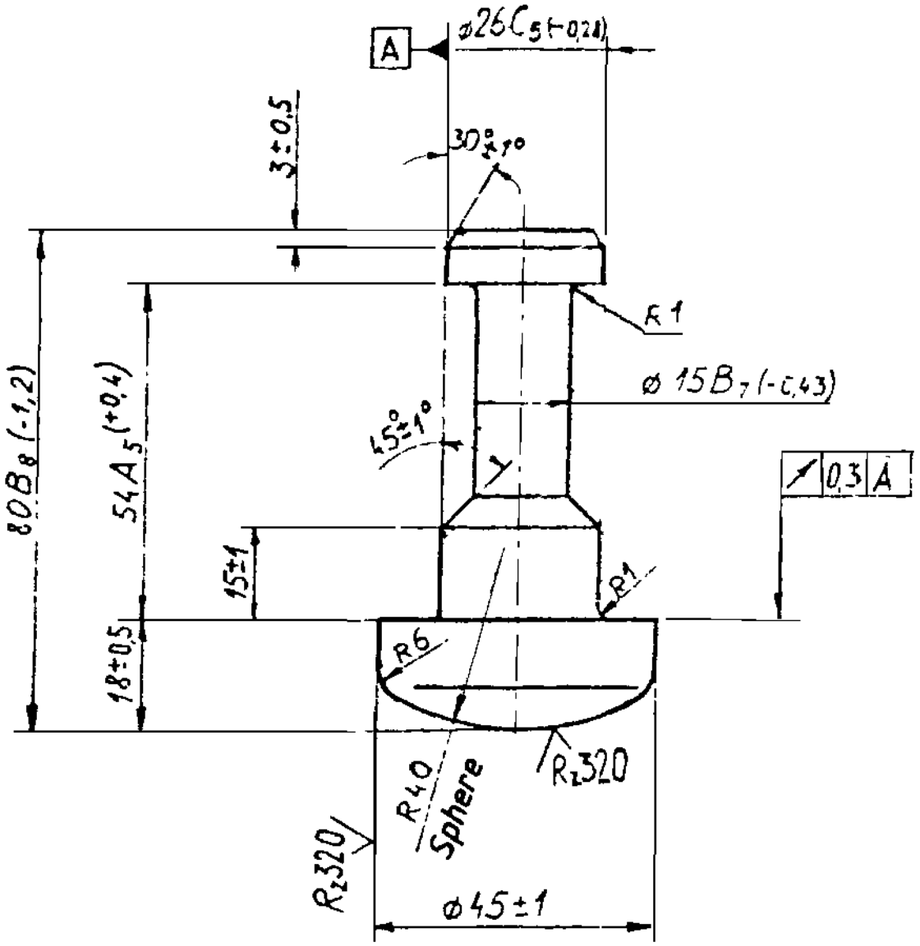
ALL DIMENSIONS IN mm

Ⓐ COLD ROLLED STEEL STRIP GRADE 9(55 Si7) TO IS:2507-75			
EQUIVALENT MATERIAL	004-58 —ICV 26-8-94	Ⓐ	EQ. MATERIAL ADDED [D-1315]
STEEL 60C2 GOST 14959-79			
ORGL MATERIAL	DCHOS / DATE	ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.	ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP ... NO. ... NAME & YEAR OF ...
DRG. NOT TO BE SCALED			
SCALE:- 1:1	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON:- 765-33-Sb107
DATE :-			
DRN.	WT :-(Kg) 3.98	765-33-28	
TCD.			
CHD.		SPRING	
APD.			

CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)

765-33-41

$R_z 80$ √(√)



TECHNICAL CONDITIONS

1. Requirements for forging are as per class II GOST 7505-74.
2. Alternate material is STEEL 33xC, 40xC GOST 4543-71.
3. HB 255 to 302 (ø 3.8 to 3.5).
4. Local recesses not exceeding 1 mm are allowed on the unmachined surfaces.
5. Blunted burr along the perimeter of the head not exceeding 1 mm for one side is allowed beyond positive tolerance.
(A) 6. Equivalent Material: Alloy Steel 40Cr1Mo28 to IS: 4367-67.

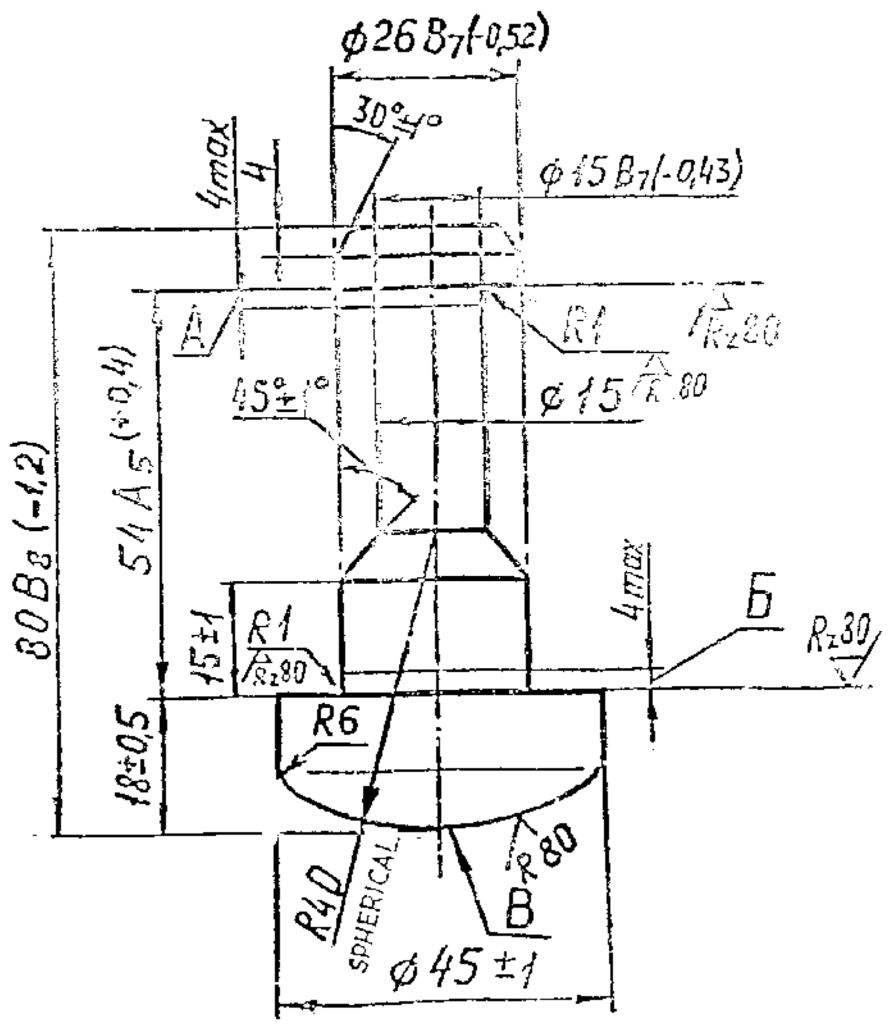
DC(I)No. & DATE	ISSUE	AMENDMENTS
00458-ICV 26 AUG 94	(A)	NOTE No.6 FOR EQUIVALENT MATERIAL ADDED. (D-1315)

APPROVED	N VASU	765-33-41	
CHECKED	Rathak		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		STRIKER PIN	WEIGHT 0.35 / SCALE 1:1
		STEEL 38XC, GOST 4543-71	SHT 1 SHTS 1

A3

765-33-138

Rz 80 (✓)



TECHNICAL CONDITIONS

1. PATTERN DRAFTS SHOULD NOT EXCEED 1°.
2. UNSPECIFIED CASTING RADII SHOULD NOT EXCEED 2 MM.
3. DISPLACEMENT ALONG PARTING LINE NOT EXCEEDING 0.3 MM IS ALLOWED ON SURFACES OBTAINED BY CASTING.
4. MODEL TEEMING LAP WITH DEPTH NOT EXCEEDING 0.3 MM IS ALLOWED ON CAST SURFACES.
5. HB:255-302 (Ø 3.8---3.5)
6. STEPS WITH HEIGHT OR DEPTH NOT EXCEEDING 0.5 MM ARE ALLOWED ON SECTIONS A AND B.
7. STEP DUE TO REMOVING OF POURING GATE WITH HEIGHT NOT EXCEEDING 0.5 MM IS ALLOWED ON SURFACE B.
8. OTHER REQUIREMENTS ARE AS PER OST 3-4365-79.

NEAREST EQVT MATERIAL

CASTING: 1 OCT 3-4365-79
ESH FC4-GOST-977-75

ORGL MATERIAL

00150-KV
25-5-90
DCGIIE & DATE | ISSUE

NEW DRAWING INTRODUCED BASED ON MASTER PRINT RECEIVED FROM COLLABORATORS AS AN ALTERNATIVE TO DRG. No. 765-33-41. (OFPM No. D-585/ICV)

AMENDMENTS

ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.

ALL THREADS TO CONFORM TO SPECIFICATION.

STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.

DRG. NOT TO BE SCALED

SCALE:- 1:1

TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED

USED ON:- 765-33-C8107

DATE :- 25-5-90

DRN.
TCD.
WT :-(Kg) 0.35

CHD.
APD.

FLAT DIE

765-33-138

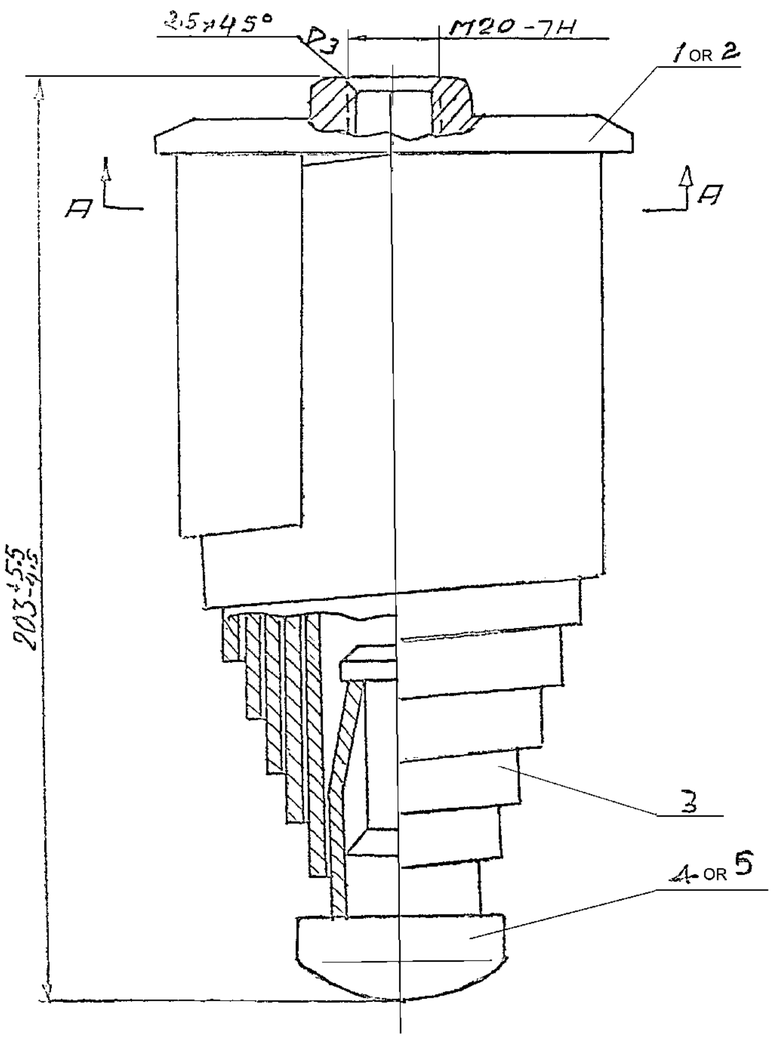
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)

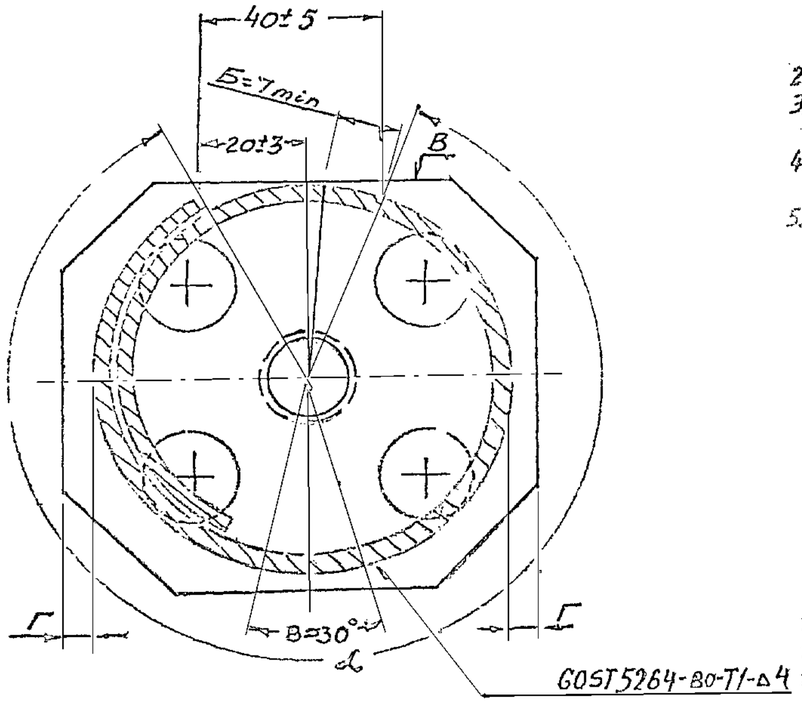
	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
			Technical Documents		
A3		765-33-cb107cb	Assembly Drawing		
			Parts		
12	1	765-33-27	Base		1pc, may be replaced by Ref No. 2
12	2	765-33-27-K	Base		1pc, may be replaced by Ref No 1
13	3	765-33-28	Spring	1	
12	4	765-33-41	Striker Pin		1 pc, may be replaced ny Ref No 5 (A)
(A) A3	5	765-33-138	Striker		1pc, may be replaced by Ref No 4

DC(I) No & DATE	ISSUE	NATURE
00128-ICV 25-8-89	(A)	NEW DRG No 765-33-138 AND ALL ITS CONNECTED ENTRIES ADDED NOTE IN 'REMARKS' COLUMN ADDED AGAINST — REF No 4 MAT' ELECTRODE 350 A GOST 9467-75, PRIMER & ENAMEL XB-518 KHAKI DELETED
AMENDMENTS		

APPROVED		765-33-Sb107	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		SPRING	WEIGHT / SCALE / SHT 1 SHTS 1

765-33-Sb107Sb





A - A

TECHNICAL CONDITIONS

1. Press tightly the spring bearing coil to the base and weld on arc α.
   Clearance between base and bearing coil not exceeding 0.15 mm is allowed on section Б from the begining of weld.
2. Cracks, pores on weld are not allowed.
3. Projection or sinking of spring beyond butt-end B should not exceed 0.1 mm.
4. Variation in measurements along dimensions Г should not exceed 2 mm.
5. Brinell hardness of spring is 477 to 365 (ø 2.8 to 3.2)
   Check on non-operating coil, heat treatment is carried out before mounting the block.
6. Spring should be sand blasted
7. After heat treatment compress the spring atleast three times till complete setting.
   During the check compression conducted after compressing the spring 3 times till complete setting, deformation is not allowed. In this case deviations ±1 mm are not considered, they are taken as an error during measurement.
8. Block play should not exceed 1.6 mm.
9. Misalignment of axes of upper and lower spring bases should not exceed 4 mm.
10. Decrease of weld upto Δ 3 is allowed on arc β
11. Coating: Chemical parkanizing, chromatizing accelerated
12. Apply primer ~~ф-4-03-К, GOST 9109-76, on to the external surfaces and paint with enamel XB-518 KHAKI~~ Technical specifications TY 6-10-966-75.

THE ABBRIVIATIONS AND SYMBOLS ARE BASED ON RUSSIAN SPECIFICATIONS

ALL DIMENSIONS IN mm

NEAREST EQ. MATERIAL			
ORGL MATERIAL:-	DC(I)No. & DATE	ISSUE	AMENDMENTS
ALL SHARF EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION		STAMP OR ETCH, PART No. MANUFACTURER's NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED			
SCALE: 1:1	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON: 675-33-Sb3
DATE :			
DRN. / TCD / CHD / APPD	WT :- (Kg) 4.96	765-33-Sb107Sb	
	SPRING ASSEMBLY DRAWING		DS CAT No.

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)