GUN & SHELL FACTORY
COSSIPORE
KOLKATA-700 002

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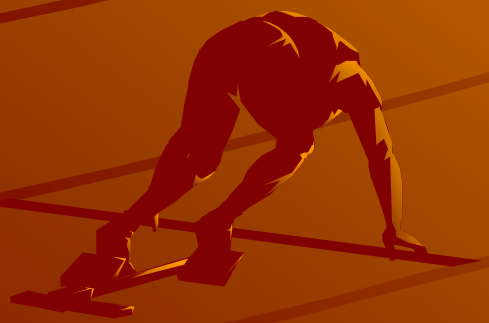
Travelling Lock



First use	Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
					Documents		
Reference No.	*)			AK-630 Sb 106 SB	Assembly drawing		*)A2x3
					Assembly units		
	A4		1	AK-630 Sb 106-1	Body	1	
					Components		
	A3		3	AK-630 106-1	Pin	1	
Sign and Date	A3		4	AK- 630 106– 2	Lever	1	
	A4		5	AK-630 106- 3	Pin	1	
	A3		6	AK-630 106-4	Spring	2	
	A4		7	AK-630 106-5	Plug	2	
Duplicate Inv. No	A3		8	AK-630 106- 6	Pin	1	
	A3		9	AK-630 106-7	Lever	1	
	A4		11	AK-630 106-9	Stock	1	
	A4		12	AK-630 106-10	Adjustment wheel	1	
Alternate Inv no.	A4		13	AK-630 106-11	Piston	1	
	A3		14	AK-630 106-12	Cylinder	1	

Sign and Date						
						AK-630. Sb 106
	Amend.	Sheet	Doc. No.	Sign	Date	
	Developed by					**Traveling lock**
Orig. Inv. No.	Checked by					
	Head of Q.C.D					
	Approved by					

Type	Sheet	Sheets
A	1	3

Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
A4		16	AK-630 106-14	Gasket	2	
A3		17	AK-630 106-15	Angle	2	
A4		18	AK-630 106-16	Gasket	1	
A4		19	AK-630 106-17	Cover	1	
A4		20	AK-630 106-18	Screw	5	
A4		21	AK-630 106-19	Cover	1	
A3		22	AK-630 106-20	Buffer	1	
A3		23	AK-630 106-21	Spring	1	
A3		24	AK-630 106-22	Retainer	1	
A4		25	AK-630 106-23	Bush	1	
A4		26	AK-630 106-24	Ring	1	
A3		27	AK-630 106-25	Internal spring	2	
A4		28	AK-630 106-26	Handle	1	
				Standard articles		
		37		Bolt 3M10-8gx30.109.40X.029	1	31…40,5 HRC_e
				GOST 7798-70		
		38		Bolt 3M10-8gx55.109.40X.029	1	31…40,5 HRC_e
				GOST 7798-70		
		39		Bolt M10-8gx55.109.40X.029	2	31…40,5 HRC_e
				GOST 7798-70		
		43		Screw M4-6gx6.33 H.026	2	
				GOST 1476-93		
		44		Screw M4-6gx8.33 H.40 X.026	2	
				GOST 1476-93		

Sign and Date | Duplicate Inv. No | Alternate Inv no. | Sign and Date | Orig. Inv. No.

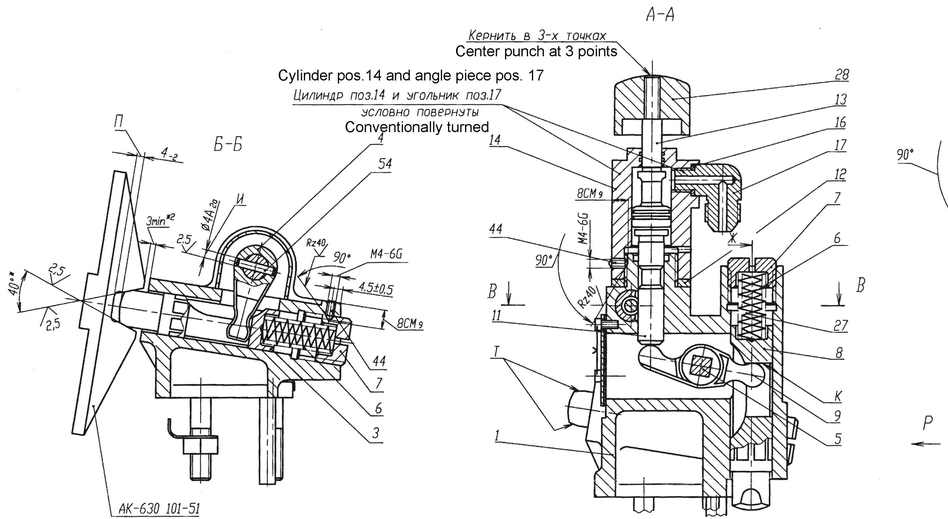
Amend.	Sheet	Doc. No.	Sign	Date	**AK-630. Sb 106**	Sheet 2

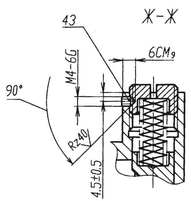
Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
		48		Nut 2M10-66.10.4X.029	1	
				GOST 5915 – 70		
		51		Washer 10.01.08KP.029	3	
				GOST 13463-77		
		54		Pin 2Pr22ax22.40X.	1	
				K38.5…45.5HRC$_E$.Chem.Phos.Oil.		
				OST 3-2234-93		
		55		Pin 8Pr22ax55.40X.	1	
				K38.5…45.5HRC$_E$.Chem.Phos.Oil.		
				OST 3-2234-93		
		56		Pin 8Pr22ax25.40X.	1	
				K38.5…45.5HRC$_E$.Chem.Phos.Oil.		
				OST 3-2234-93		
				Materials		
		57		Wire 0.6-T-12X18H10T	0.3	m
				GOST 18143-72		

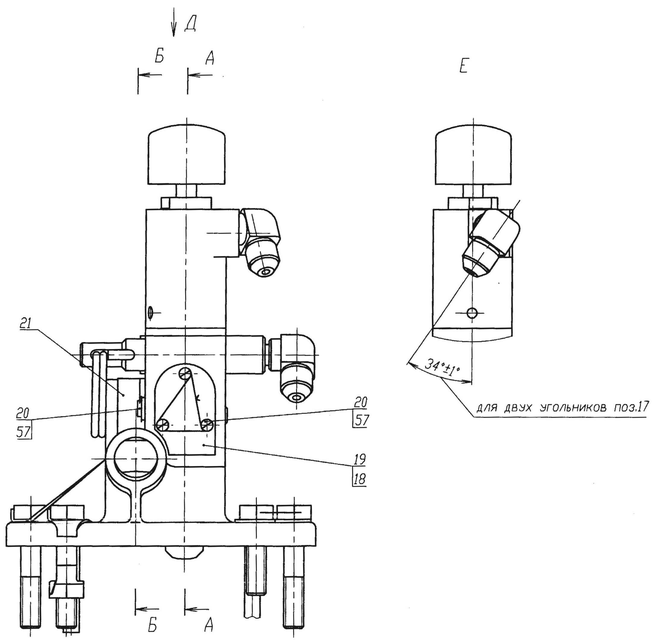
Sign and Date | Duplicate Inv. No | Alternate Inv no. | Sign and Date

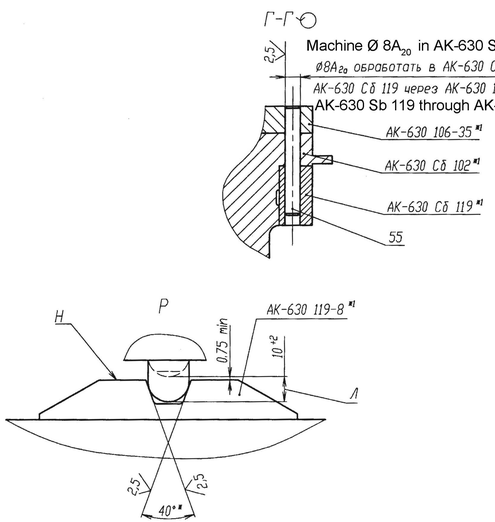
Orig. Inv. No.						AK-630. Sb 106	Sheet
							3
	Amend.	Sheet	Doc. No.	Sign	Date		

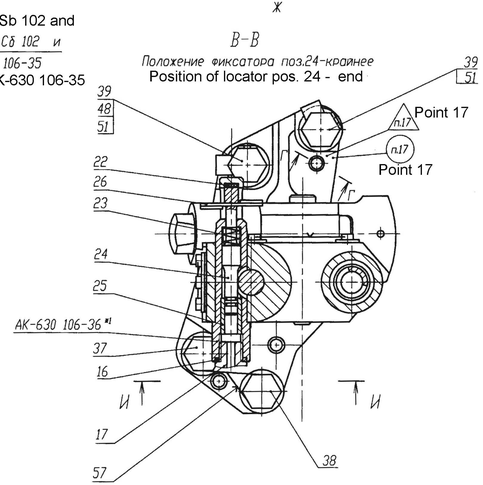
АК - 630 113 - 1

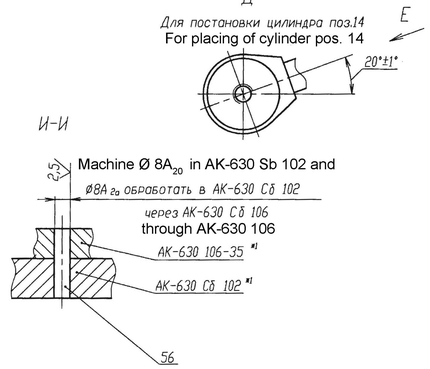












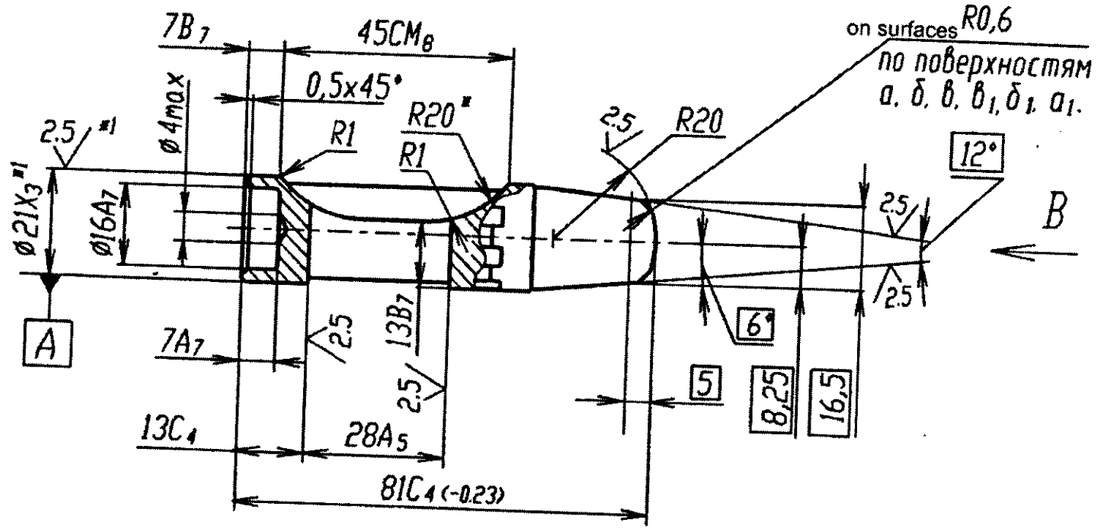
1. * Reference dimensions .
2. *1 Article for reference .
3. *2 Inspect dimension in AK-630M SB.00.
4. Coat cad. 6. Chrome after carrying out specifications of adjustment of ring assembly pos. 12 .
5. Carry out setting of cylinder pos. 14 (refer view Д) and angle piece pos. 17 (refer view Е) by fitting adjusting ring pos. 12 and gasket pos. 16. Thickness of component AK-630 106-10 should be not less than 2.8 mm .
6. Secure by adhesive 88 NP TU 38 105540 - 85 placement of buffer pos. 22 in sleeve comp. AK-630 106-36. Using of adhesive 88 SA TU 38 105 1760-89 is permissible .
7. Center punch screws pos. 43 and 44 at two points by center punching metal component in screw slots .
8. Lubricate all friction surfaces of components with lubricant MS-70 GOST 9762-76.
9. All movable components should move freely, without jamming and under influence of spring should energetically return to its initial position .
10. Carry out bending of stop washers pos. 51 and tying of screws pos. 20 and bolts pos. 27 and 38 with wire pos. 57 in AK-630M SB.00.
11. Carry out adjustment of catch AK-630 119-8 on pin pos. 8 till ensuring A filling of adjoining surface not less than 75% . It is permissible to file plane "K" of pin in case of non ensuring of dimension Л.
12. Carry out drilling of hole " И" after obtaining dimension "Л" and "П" during positioning of pin pos. 3, placed in stopper socket AK-630 101-51 and pin pos. 8, placed in catch slot AK-630 119-8 and on dimension "П" minus 1 mm surfaces of pins pos. 3 and 8 and lever pos. 4 and 9 should be pressed to each other .
13. File side surface of topper socket on pin till obtaining dimension "П" Fitting of adjoining surface should not be less than 75% .
14. Displacement of components AK-630 106-1 (pos. 3) in respect to components AK-630 101-51 (stopper socket) , is permissible , during which plane T of whole area should be placed in component AK-630 101-51.
15. Tighten plug pos. 7 up to stop , align on rotation plane and stop with screw pos. 43 and 44. At lower end position of piston pos. 13 after final filling of components AK-630 119-8 and AK-630 101-51.
16. Secure component pos. 28 by red, brown putty EP-0010 GOST 28379-89.
17. Mark Ш,Ч, На and stamp K on AK-630, AK-630M TU 1, На- technological unit of assembly number .

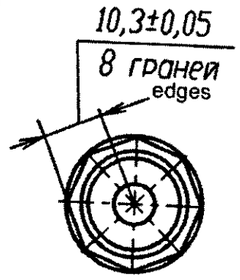
						AK - 630 SB 106 SB
Amend	Sheet	Doc. No.	Sign	Date		
Developed by					Traveling lock Assembly drawing	Type: A; Weight: 4.70; Scale: 1:1
Checked by						
Technician						Sheet; Sheets 1
Head of bureau						
Head of QCD						
Approved by						

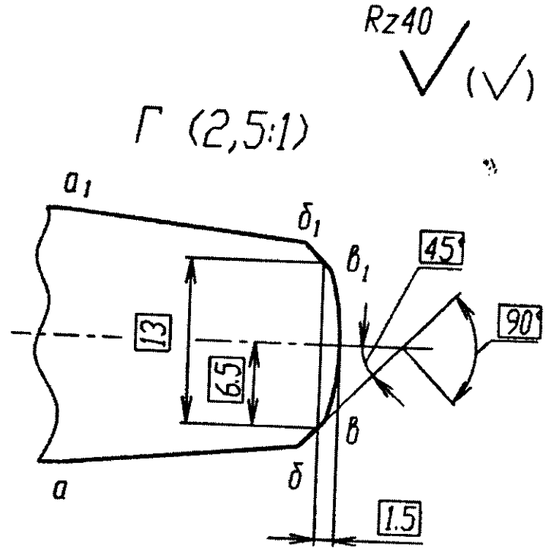
Format A2x3

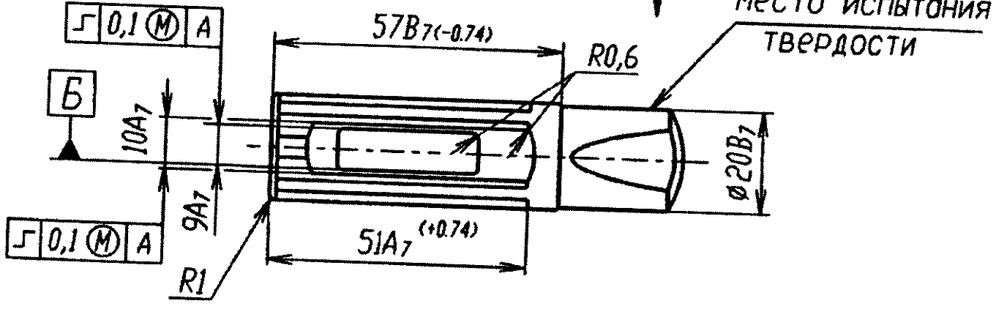
First remarks | Reference No. | Sign & Date | Duplicate Inv. No. | Alternate Inv. No. | Sign & Date | Inv. No.

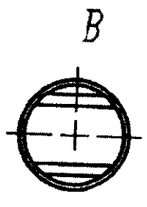
AK-630 106-1









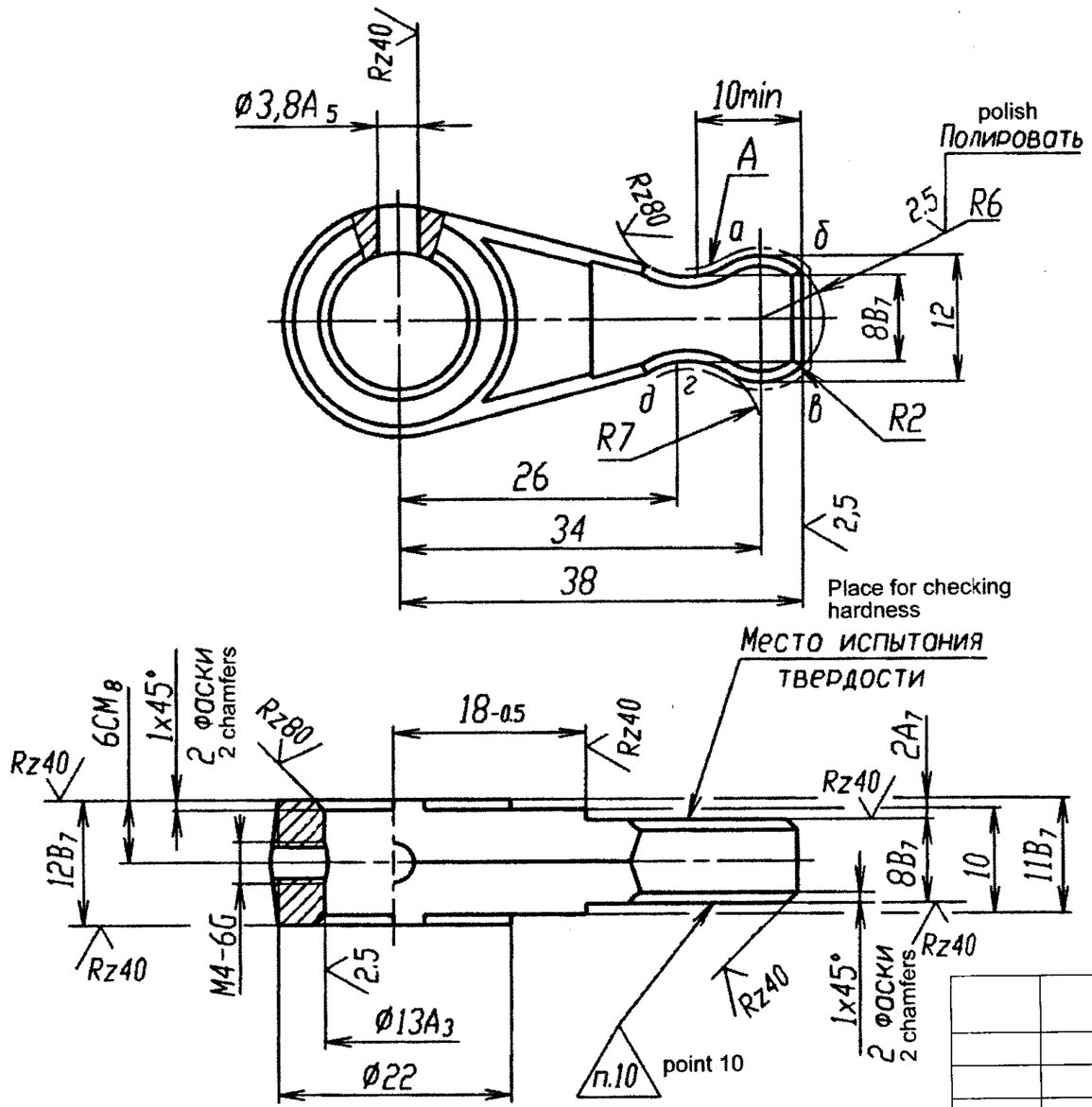


1. 38.5..44.5 HRC_E.
2. * Dimension ensured by tool.
3. Inner angles R~0.6 mm.
4. Blunt sharp edges ~0.6 mm.
5. *1 Dimensions and surface finish after coating.
6. Allowance of form of surfaces а, б, в and $а_1$, $б_1$ $в_1$ with respect to surfaces А, Б Т/2 is 0.1 mm.
7. Coating : external surfaces- Kh30 B;
   Others- Chem.Phos.oil.
8. Mark Ш, Ч and stamp К, И on tag.

Amend.	Sheet	Doc.No.	Sign	Date	AK-630 106-1			
Developed by					Pin	Type	Weight	Scale
Checked by						A	0.150	1:1
							Sheets 1	
Head of Q.C.D					Steel 40 Kh GOST 4543-71			
Approved by								

First use | Reference No. | Sign and Date | Duplicate Inv. No | Alternate Inv. No | Sign and Date | Orig. inv. no.

AK-630 106-2



1. Substitute material- steel 50A OST3-98-80.
2. Blank-Forging accuracy class T 5 GOST 7805-89.
   Surface defects on un machined surfaces should not be deeper than 0.5 mm.
3. 38.5..44.5 HRC_E.
4. Inner angles R~0.4 mm.
5. Blunt sharp edges ~0.6 mm.
6. Allowance for contour "абвг " from hole and point "д" – 0.12 mm.
7. Blunt sharp edges ~1 mm at places of chrome plating.
8. Coating of surface A- Kh42;
   For others- Cd 12.phos.
   Lacquer BF-4 with Nigrozene 2 coats, made as per OST 3-4123-78, IV, OM2.
9. Mark Ш, Ч on tag.
10. Stamp К, И as per AK-630, AK-630M TU I.

Amend.	Sheet	Doc.No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

AK-630 106-2

Lever

Type	Weight	Scale
A	0.050	2:1

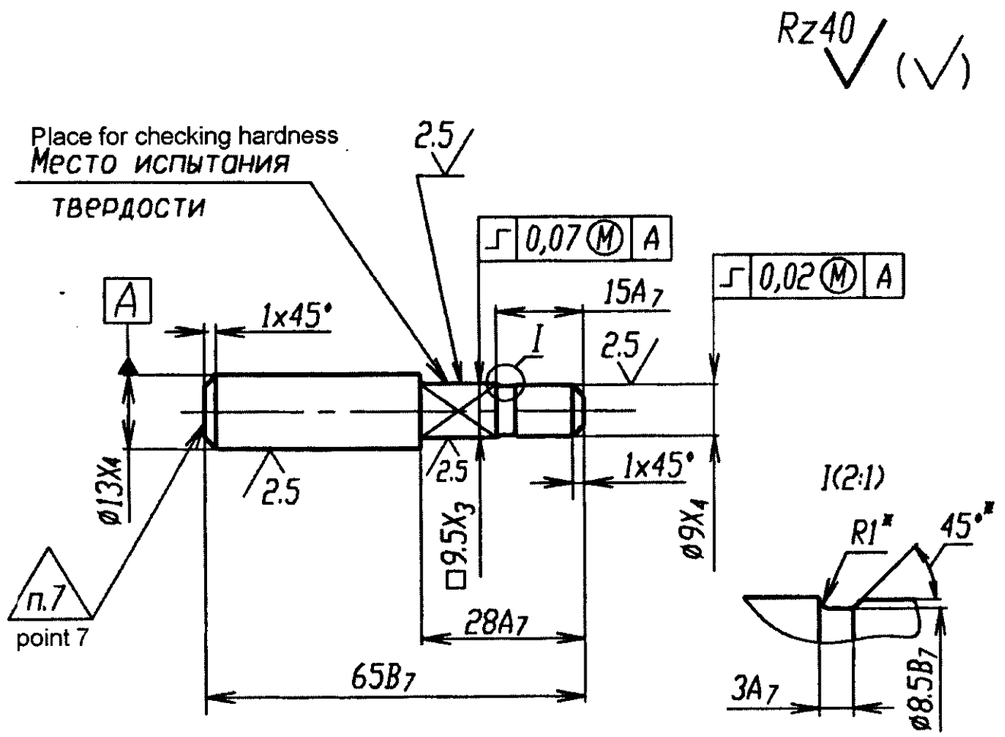
Sheets 1

Steel 50 GOST 1050-88

First use | Reference No. | Sign and Date | Duplicate Inv. No | Alternate Inv. No | Sign and Date | Orig. inv. no.

Blank No. 406

АК-630 106-3



1. 38.5...44.5 HRC_E.
2. *Dimension ensured by tool.
3. Inner angles ~ 0.6 mm.
4. Blunt sharp edges ~0.6 mm.
5. Coating Cd.12 Phos.
6. Mark Ш, Ч and stamp К on tag.
7. Stamp И as per АК-630, АК-630М TU I.

Approved by shop | First use | Reference No. | Approved KI ...NII | Sign and Date | Dupl. Inv. No. | Appr. ...d TOsb | Alternate Inv. No | Sign and Date | Approved OGMet | Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				

АК-630 106-3

Pin

Type	Weight	Scale
A	0.055	1:1

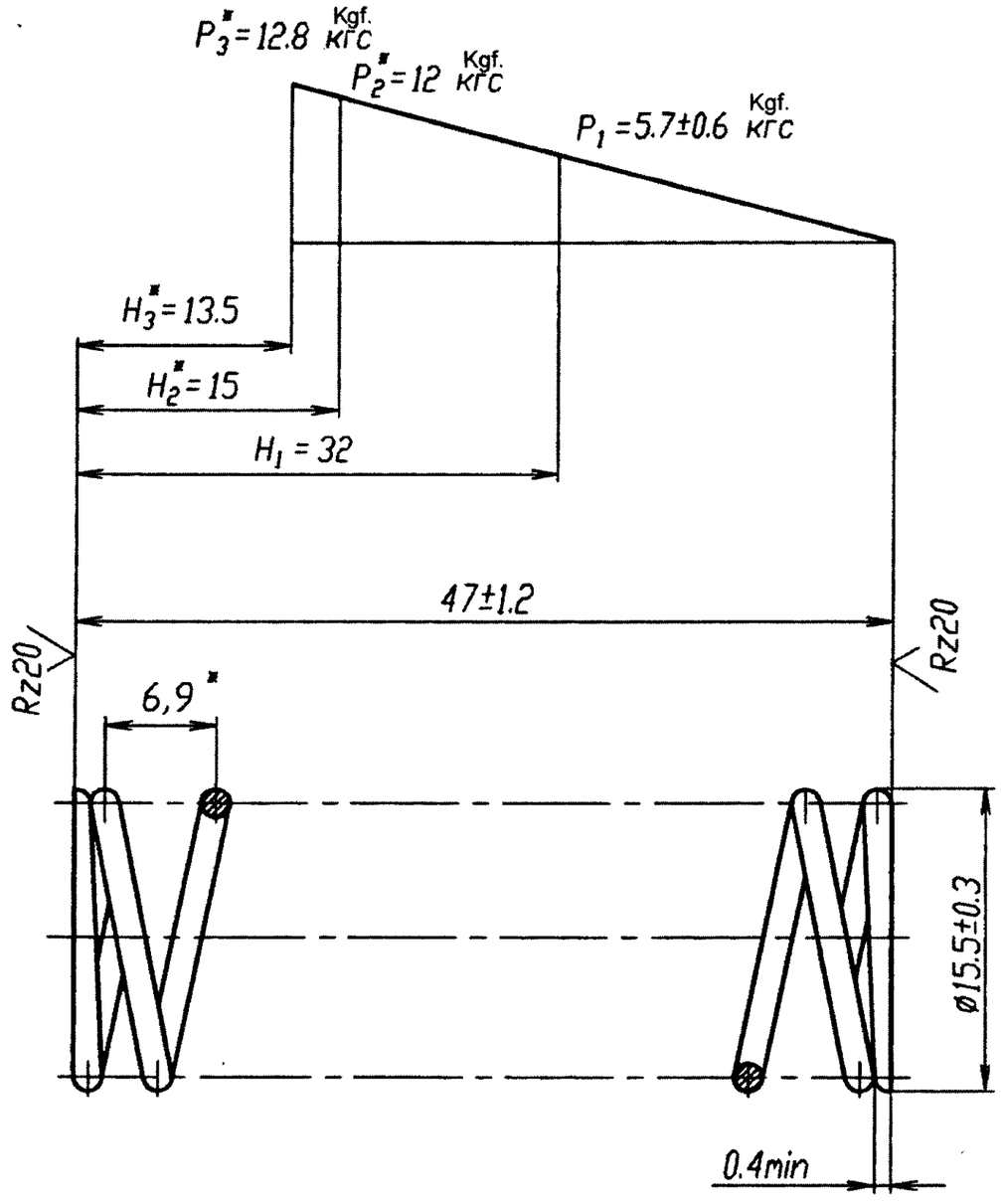
Sheet | Sheets 1

Steel 50 GOST 1050-88

Copied by

Format A4

AK-630 106-4



(√)

1. Group I.
2. G* = 8000 kgf/mm^2. τ_3* = 129 kgf/mm^2.
3. Unrolled length L* = 400 mm.
4. Coiling direction- right.
5. n = 6.5.
6. $n_1 = 8.5 \pm 0.25$.
7. Heat treatment- tempering 240-260^{0}C.
8. $D_g = 16A_5$ mm.
9. D_S.
10. Pre deformation time (at H_Z) –24 hours.
11. Coating Chem.phos. accel.Cr. Lacquer BF-4 with nigrozene, 2 coats, made as per OST 3-4123-78, IV, OM2.
12. * Dimensions as parameters for reference.
13. Other technical requirements as per GOST 16118-70.
14. 11. Mark Ш, Ч and stamp К, И on tag.

Amend.	Sheet	Doc.No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

AK-630 106-4

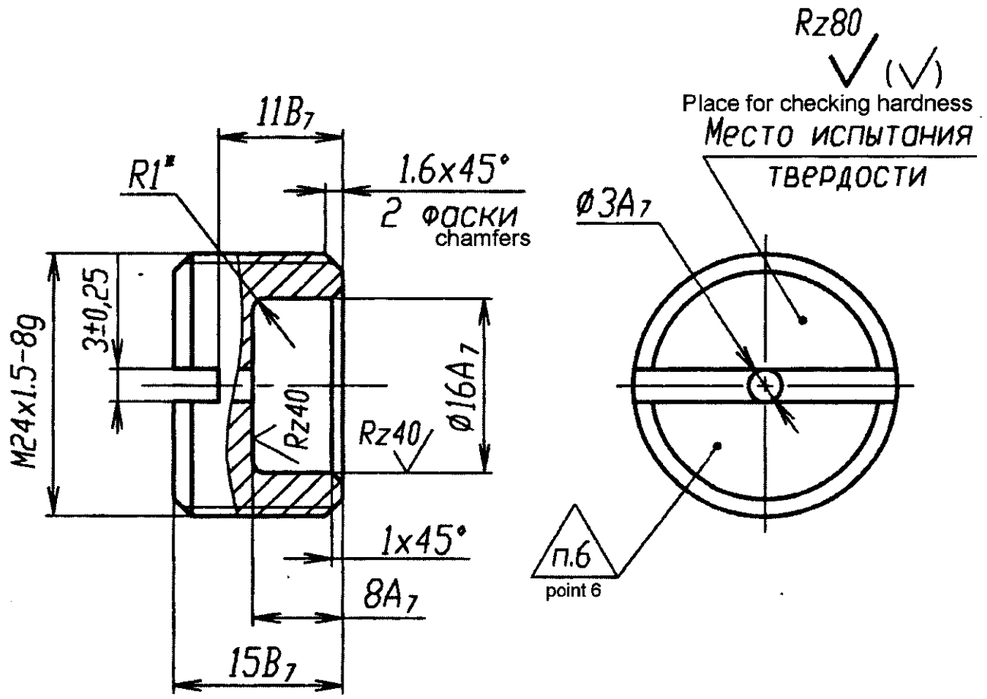
Spring

Type	Weight	Scale
A	0.005	5:1
Sheet	Sheets 1	

Wire V-1-1.6
GOST 9389-75

First use | Reference No. | Sign and Date | Duplicate Inv. No | Alternate Inv. No | Sign and Date | Orig. inv. no.

АК-630 106-5



1. 31..40.5 HRC_E.
2. * Dimension ensured by tool.
3. Blunt sharp edges ~0.4 mm.
4. Coating Cd 6.Phos. Oil.
5. Mark Ш, Ч and stamp К on tag.
6. Stamp И as per АК-630, АК-630М TU I.

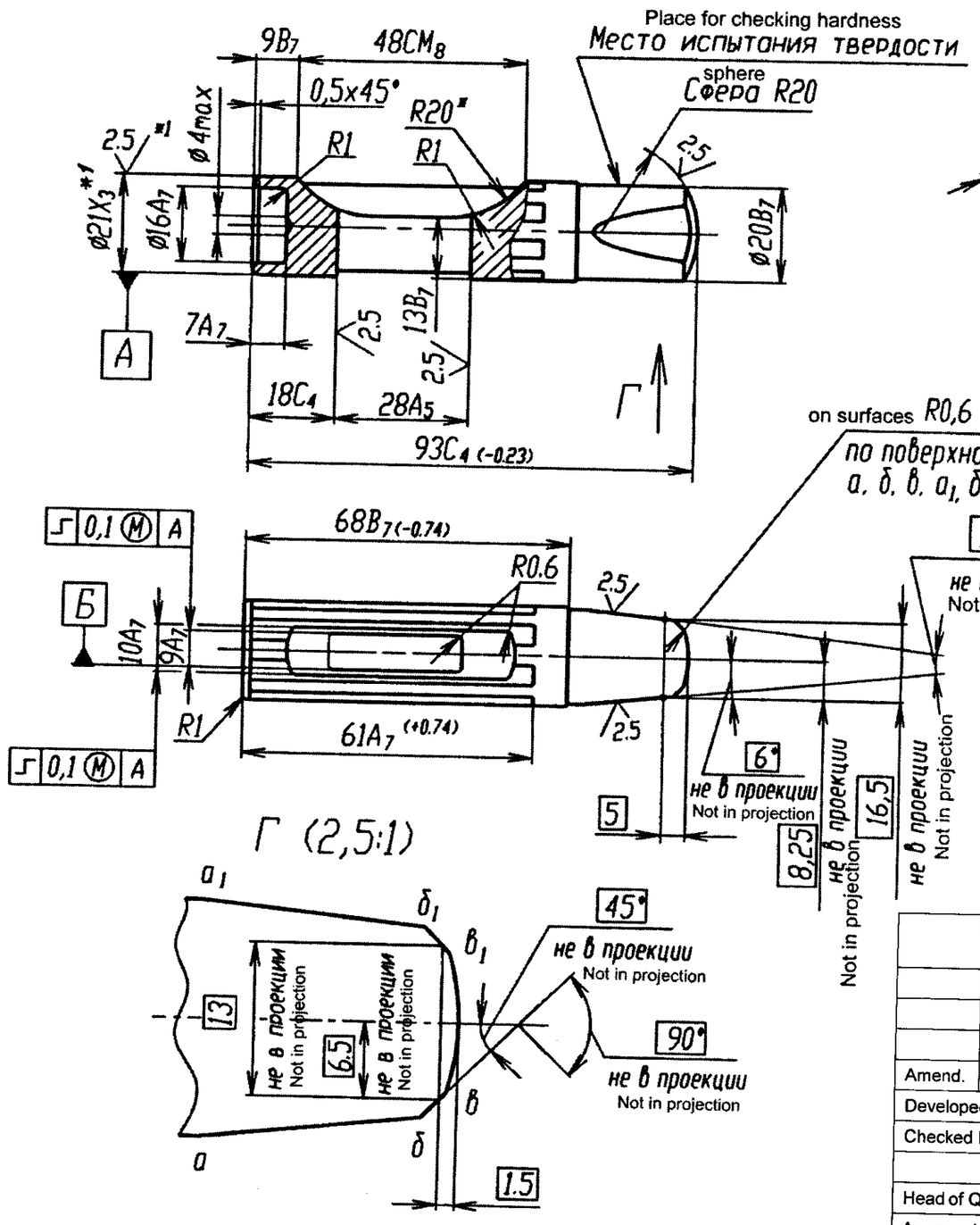
Amend.	Sheet	Doc. No.	Sign	Date				
					АК-630 106-5			
						Type	Weight	Scale
					Plug	A	0.030	2:1
						Sheet	Sheets 1	
Developed by								
Checked by								
Head of Q.C.D								
Design bureau chief								
Head of Q.C.D					Steel 40Kh GOST 4543-71			
Approved by								

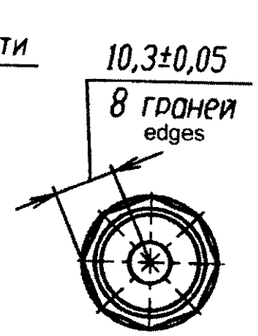
Approved by shop | First use | Reference No. | Approved КТС Ж | Sign and Date | Dupl. Inv. No. | Apprc Ж ТОsb | Alternate Inv. No | Sign and Date | Approved OGMet | Orig. Inv. No.

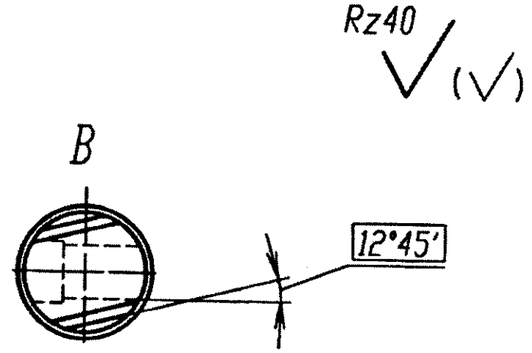
Copied by

Format A4

AK-630 106-6





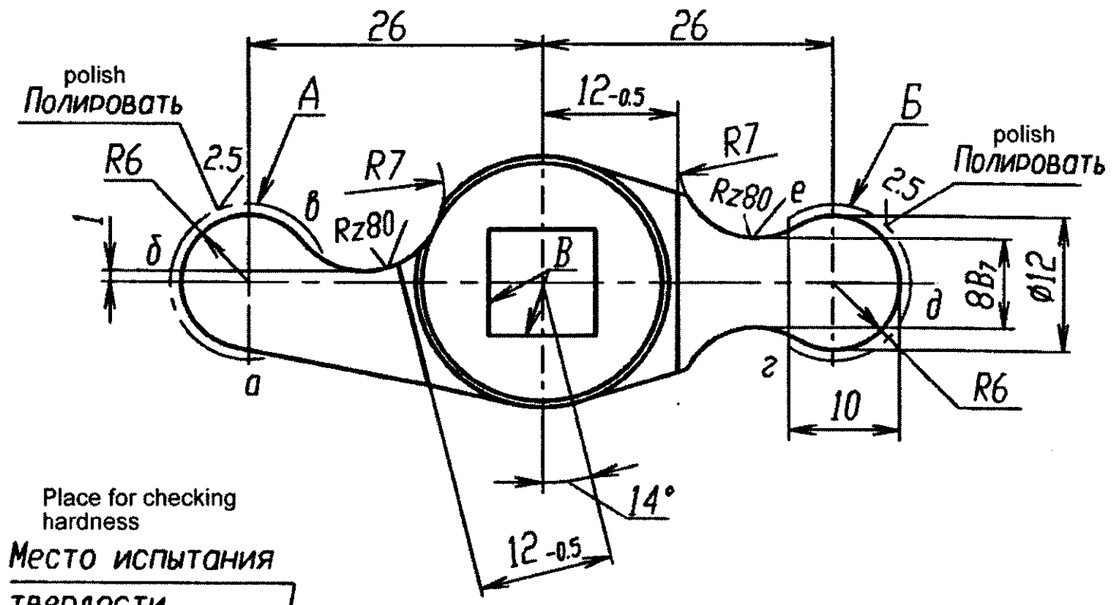


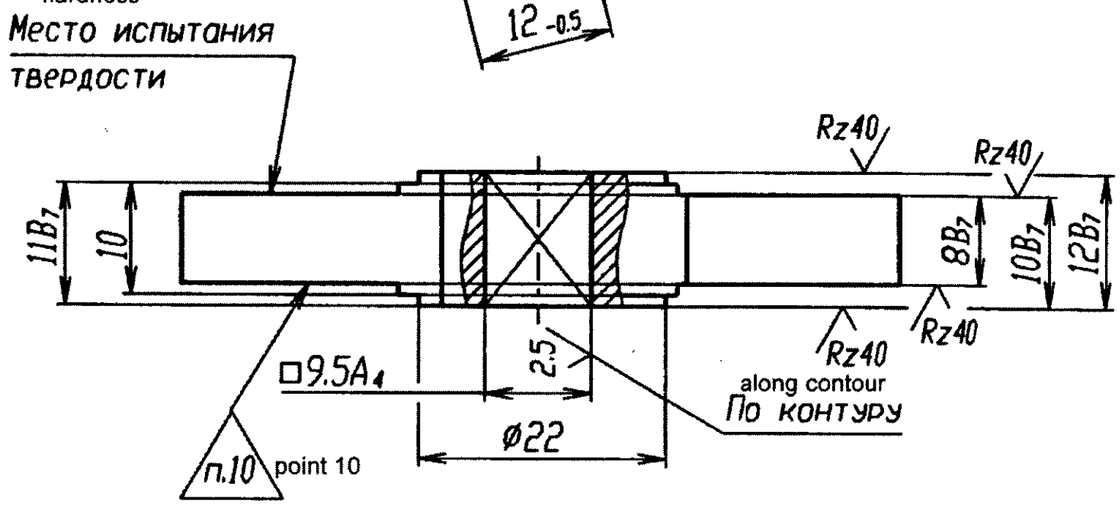
1. 38.5..44.5 HRC_E.
2. * Dimension ensured by tool.
3. *1 Dimensions and surface finish after coating.
4. Inner angles R~0.4 mm.
5. Blunt sharp edges ~0.6 mm.
6. Coating : external surfaces- Kh30 B
   Others- Chem.Phos.oil.
7. Mark Ш, Ч and stamp К, И on tag
8. Allowance of form of surfaces а, б, в and a_1, $б_1$ $в_1$ with respect to surfaces А, Б Т/2 is 0.1 mm.

					AK-630 106-6
Amend.	Sheet	Doc.No.	Sign	Date	
Developed by					Pin
Checked by					
Head of Q.C.D					
Approved by					Steel 40 Kh GOST 4543-71

Type	Weight	Scale
A	0.175	1:1
	Sheets 1	

First use | Reference No. | Duplicate Inv. No | Alternate Inv. No | Sign and Date | Orig. inv. no.





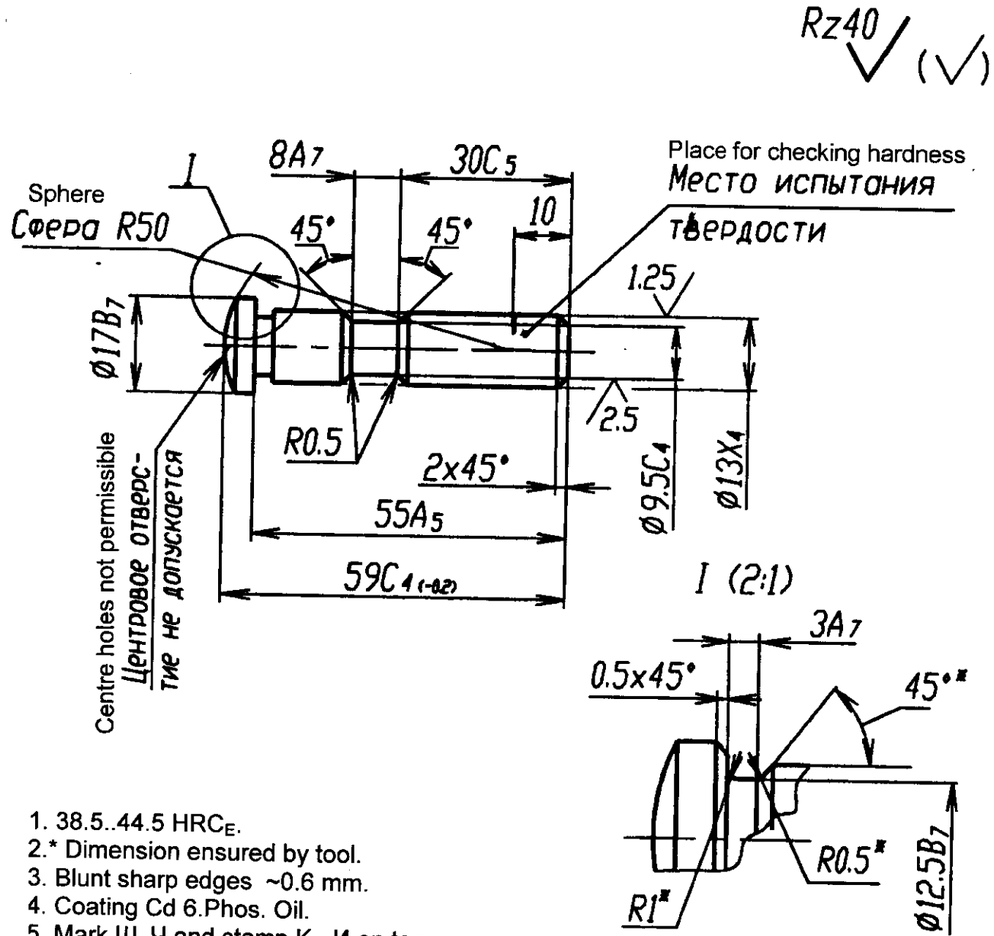
1. Substitute material- steel 50A OST3-98-80.
2. Blank-Forging accuracy class T 5 GOST 7805-89.
   Surface defects on un machined surfaces should not be deeper than 0.5 mm.
3. 38.5..44.5 HRC_E.
4. Inner angles R~0.4 mm.
5. Blunt sharp edges ~0.6 mm.
6. Allowance for contour "а б в" , "г д е " – 0.12 mm. from plane B of square.
7. Blunt sharp edges ~1 mm at places of chrome plating.
8. Coating of surface A and Б- Kh42;
   For others- Cd 12.phos.
   Lacquer BF-4 with Nigrozene 2 coats, made as per OST 3-4123-78, IV, OM2.
9. Mark Ш, Ч on tag.
10. Stamp К, И as per АК-630, АК-630М TU I.

					АК-630 106-7
Amend.	Sheet	Doc.No.	Sign	Date	Lever
Developed by					
Checked by					
Head of Q.C.D					Steel 50 GOST 1050-88
Approved by					

Type	Weight	Scale
A	0.056	2:1
Sheets 1		

Blank No. 406

AK-630 106-9



1. 38.5..44.5 HRC_E.
2.* Dimension ensured by tool.
3. Blunt sharp edges ~0.6 mm.
4. Coating Cd 6.Phos. Oil.
5. Mark Ш, Ч and stamp К, И on tag.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Heac of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				

AK-630 106-9

Rod	Type	Weight	Scale
	A	0.055	1:1
	Sheet	Sheets 1	
Steel 40Kh GOST 4543-71			

Approved by shop | First use | Reference No. | Approved KT...M | Sign and Date | Dupl. Inv. No. | Appr...d TOsb | Alternate Inv. No | Sign and Date | Approved OGMet | Orig. Inv. No.

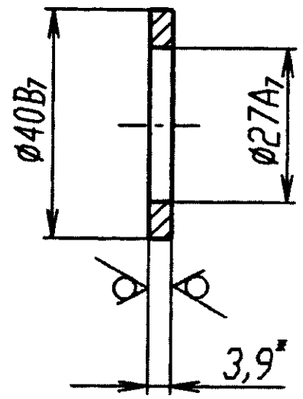
Copied by

Format A4

Blank No. 406

AK-630 106-10

Rz160 (√)



1.* Reference dimension.
2. Blunt sharp edges ~0.4 mm.
3. Mark Ш, Ч and stamp K on tag.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				

AK-630 106-10

Adjustment ring

Type	Weight	Scale
A	0.021	1:1

Sheet | Sheets 1

Sheet $\frac{B-PN-0\ 3.9 GOST\ 19903-74}{K490V\ 4-III-35 GOST\ 16523-97}$

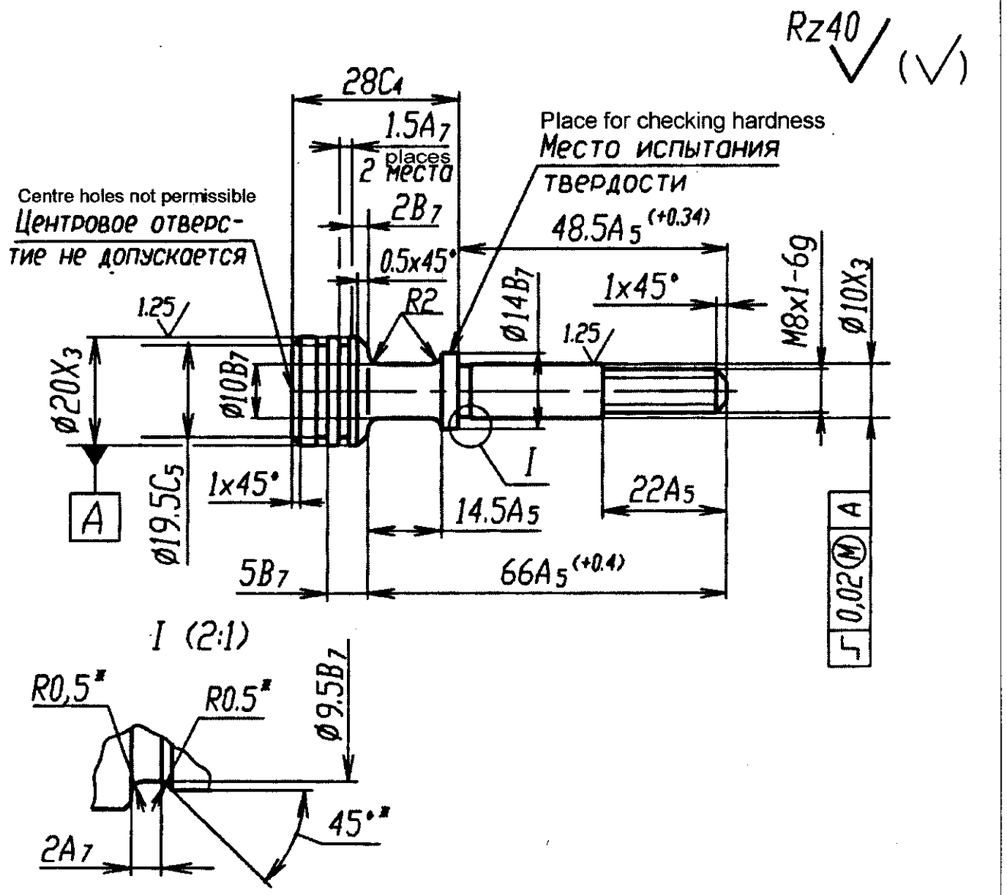
Approved by shop | First use | Reference No. | Approved K1 ...NI | Sign and Date | Dupl. Inv. No. | Appr...d TOsb | Alternate Inv. No | Sign and Date | Approved OGMet | Orig. Inv. No.

Copied by

Format A4

Blank No. 406

AK-630 106-11



1. HRC_E 38.5...44.5. Check hardness on 3-5% of the batch , but not less than 3 nos.
2. Dimensions ensured by tool.
3. Inner angles R~0.4 mm.
4. Blunt sharp edges ~0.6 mm.
5. Coating Cd 6.phos.Oil.
6. Mark Ш, Ч and stamp К, И on tag.

Amend.	Sheet	Doc. No.	Sign	Date	AK-630 106-11			
Developed by					Piston	Type	Weight	Scale
Checked by						A	0.075	1:1
Head of Q.C.D						Sheet	Sheets 1	
Design bureau chief					Steel 40Kh GOST 4543-71			
Head of Q.C.D								
Approved by								

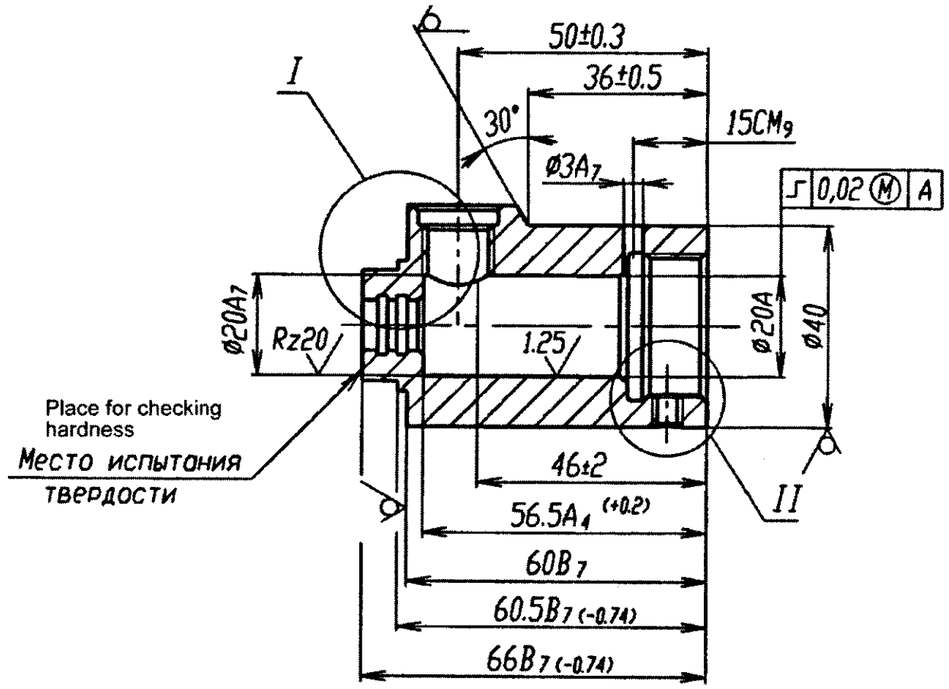
Copied by

Format A4

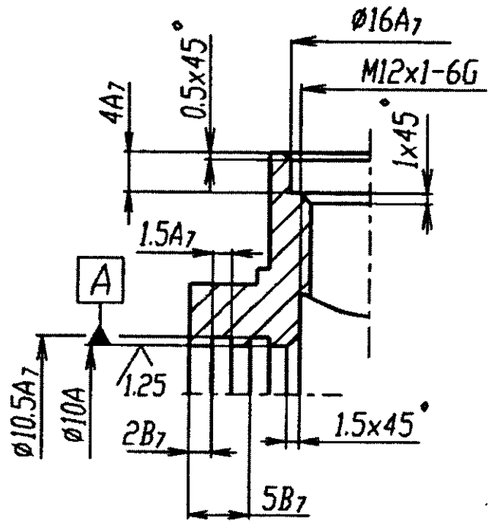
Approved by shop | First use | Reference No. | Approved KTO | Sign and Date | Dupl. Inv. No. | Appr. Ad TOsb | Alternate Inv. No | Sign and Date | Approved OGMet | Orig. Inv. No.

AK-630 106-12

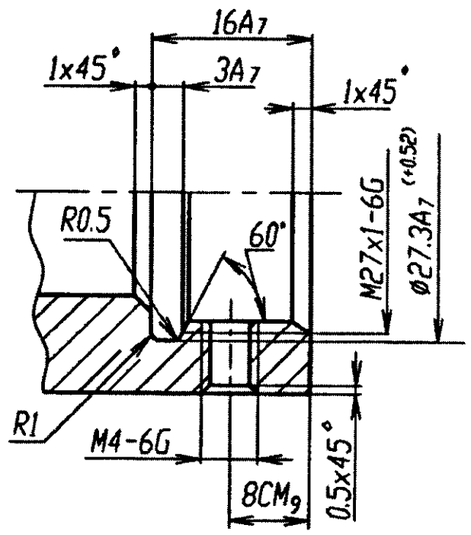
First use | Reference No. | Sign and Date | Duplicate Inv. No | Alternate Inv. No | Sign and Date | Orig. inv. no.



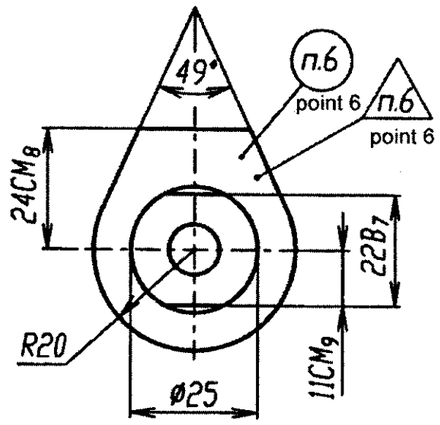
I(2:1)



II(2:1)



Rz40 (√)

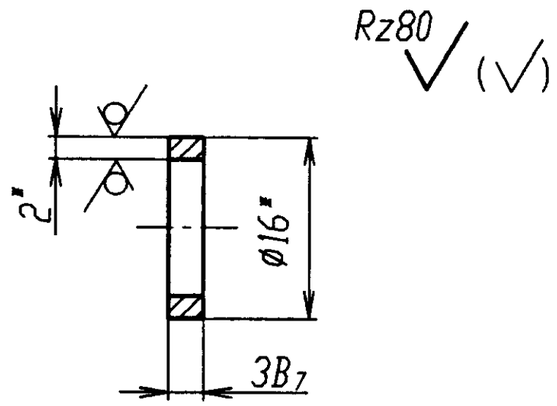


1. Blank-Forging accuracy class T 5 GOST 7805-89.
   Surface defects on un machined surfaces should not be deeper than 0.5 mm.
2. 38.5..44.5 HRC_E.
3. Inner angles R~0.4 mm.
4. Blunt sharp edges ~0.6 mm.
5. Coating : Cd 6. phos. oil.
6. Mark Ш, Ч and stamp К, И as per AK-630, AK-630M TU I.

					AK-630 106-12	
Amend.	Sheet	Doc.No.	Sign	Date	Cylinder	Type: A; Weight: 0.435; Scale: 1:1
Developed by						
Checked by						Sheets 1
Head of Q.C.D					Steel 40 Kh GOST 4543-71	
Approved by						

Blank No. 406

AK-630 106-14



1. Substitute material: Sheet DPRNM 3x1500 M2 GOST 495-92.
2.* Reference dimensions.
3. Blunt sharp edges ~0.4 mm.
4. Mark Ш, Ч and stamp К on tag.

Approved by shop | First use
Reference No.
Approved KTO.VT
Sign and Date
Dupl. Inv. No.
Approv. /TOsb
Alternate Inv. No
Sign and Date
Approved OGMet
Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				

AK-630 106-14

Gasket

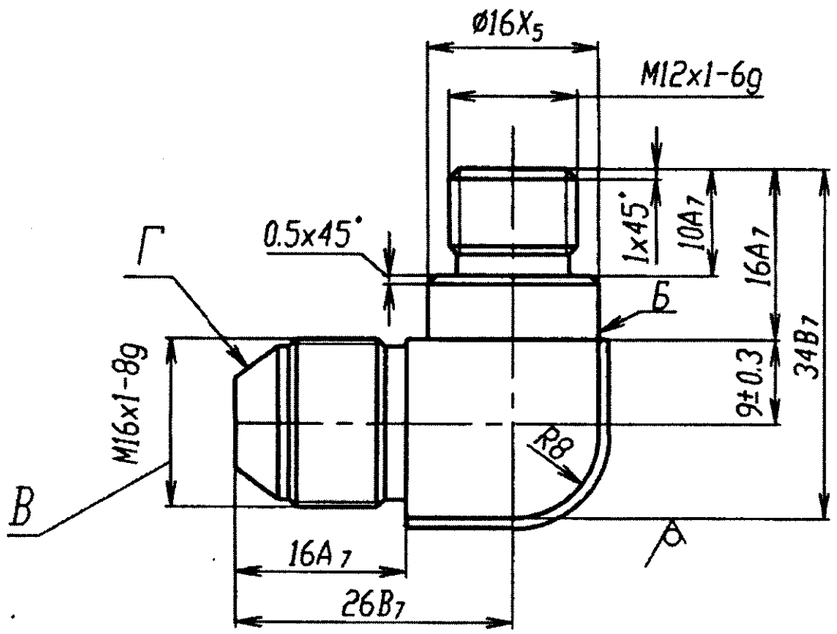
Type	Weight	Scale
A	0.003	2:1

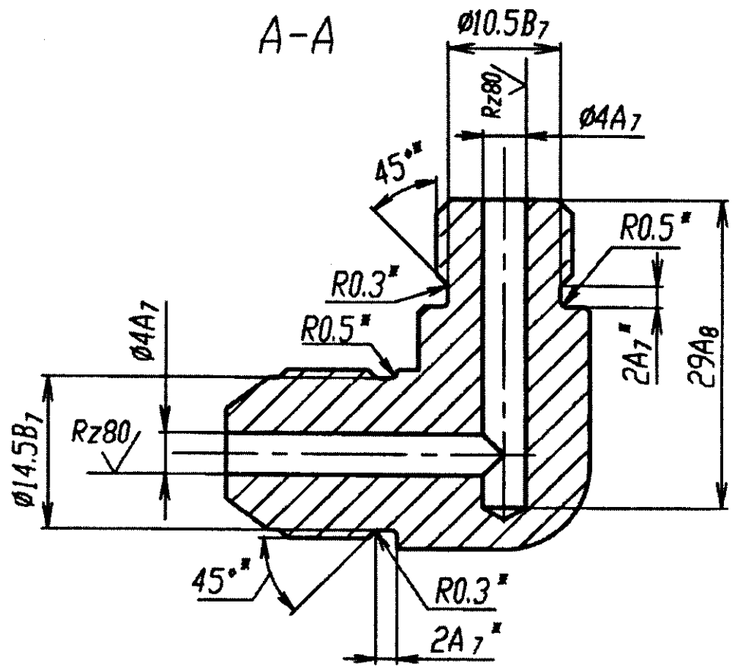
Sheet | Sheets 1

Pipe M2-M 16x2
GOST 617-90

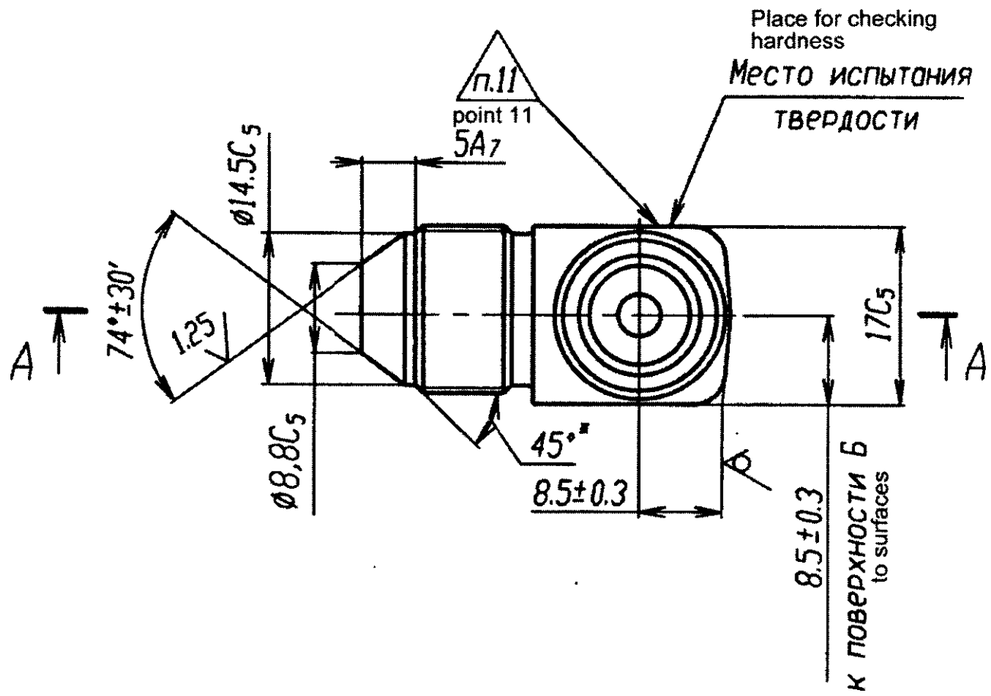
Copied by | Format A4

AK-630 106-15





Rz40 (√)



1. Blank-Forging accuracy class T 5 GOST 7805-89.
2. Forging gradient 7^0 unless otherwise specified.
3. Surface defects on un machined surfaces should not be deeper than 0.3 mm.
4.* Dimensions ensured by tool.
5. Blunt sharp edges ~0.6 mm.
6. 38.5..44.5 HRC_E.
7. Coating : Cd 6. phos. oil.
8. Run out of taper Г surface with respect to mean diameter of thread B not more than 0.05 mm.
9. It is permissible to avoid cadmium plating of inner surfaces Ø4 A_7.
10. Mark Ш, Ч and stamp K on tag.
11. Stamp И as per AK-630, AK-630M TU I.

Amend.	Sheet	Doc.No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

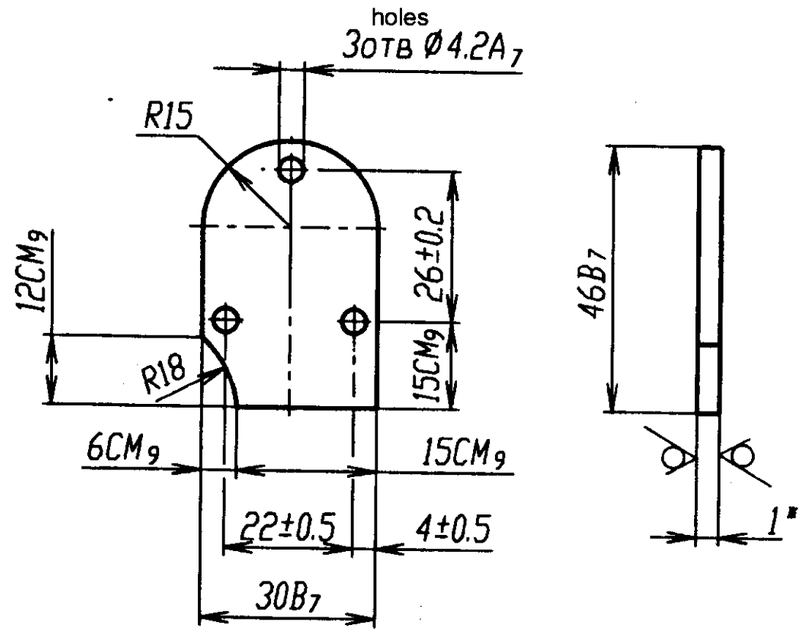
AK-630 106-15

Angle piece	Type	Weight	Scale
	A	0.070	2:1
		Sheets 1	
Steel 40 Kh GOST 4543-71			

First use | Reference No. | Sign and Date | Duplicate Inv. No | Alternate Inv. No | Sign and Date | Orig. inv. no.

Blank No. 406

AK-630 106-16



1.* Reference dimension.
2. It is permissible to seal the holes as per comp. AK-630 106-17.
3. Dimensions ensured by tool.
4. Mark Ш, Ч and stamp К on tag.

Approved KTON | Approved by shop | First use
Approved OGMet | Osb | Reference No.
Sign and Date | Alternate Inv. No | Dupl. Inv. No. | Sign and Date
Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				

AK-630 106-16

Gasket

Type	Weight	Scale
A	0.001	1:1

Sheet | Sheets 1

Plate 1N-I MBS-M_1-1
GOST 7338-90

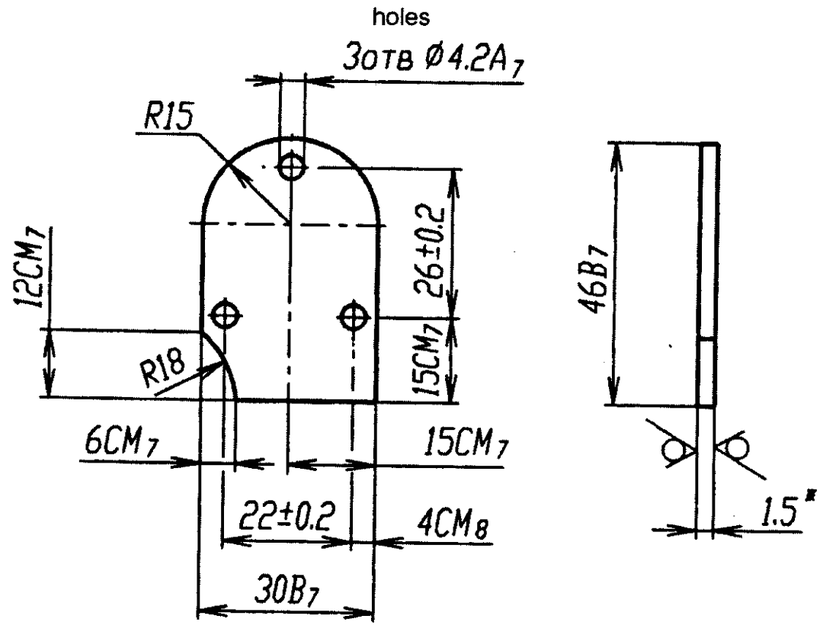
Copied by

Format A4

Blank No. 406

AK-630 106-17

Rz80 (√)



1.* Reference dimension.
2.Dimensions ensured by tool.
3.Blunt sharp edges ~0.4 mm.
4. Coating Cd 12.phos. Lacquer BF-4 with Nigrosine , two coats, made as per OST 3-4123-78 IV, OM2.
5. Mark Ш, Ч and stamp К on tag.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				

AK-630 106-17

Gasket

Type	Weight	Scale
A	0.015	1:1

Sheet | Sheets 1

Sheet $\frac{BT-PN-O1.5GOST19904-90}{K490V4-III-35GOST16523-97}$

Copied by

Format A4

Approved KTONI

Approved OGMet

Sign and Date | First use

Reference No.

Approved by shop

Sign and Date

Alternate Inv. No

Approved Jsb

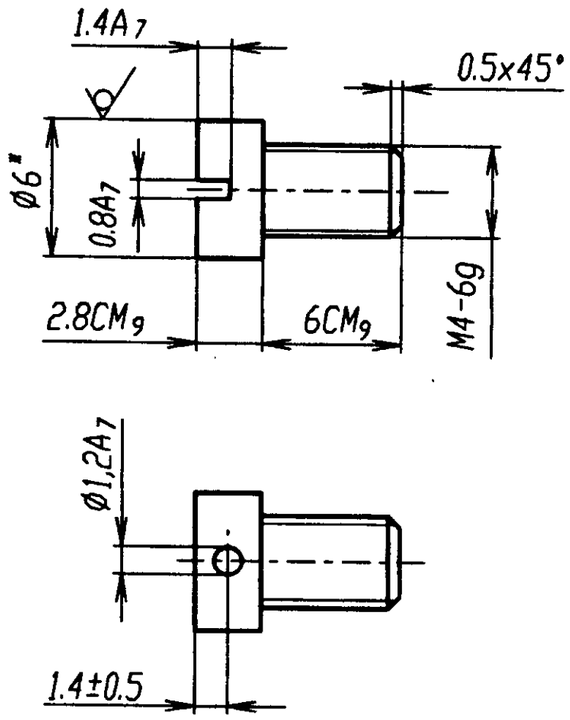
Dupl. Inv. No.

Orig. Inv. No.

Blank No. 406

AK-630 106-18

Rz80 (√)



1. 65.5...70 HRA ; check on test specimen.
2. * Reference dimension.
3. Inner angles R~0.2 mm.
4. Blunt sharp edges ~0.6 mm.
5. Coating Cd 6. phos.Oil.
6. Mark Ш, Ч and stamp К, И on tag.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				

Copied by

AK-630 106-18

Screw

Type	Weight	Scale
A	0.001	4:1

Sheet | Sheets 1

Wheel $\frac{6-5GOST\ 7417-75}{40KhV-N\ GOST\ 1051-73}$

Format A4

Approved KTONI

Approved OGMet

Orig. Inv. No.

Sign and Date

Approved Osb

Dupl. Inv. No.

Alternate Inv. No

Sign and Date

Approved by shop

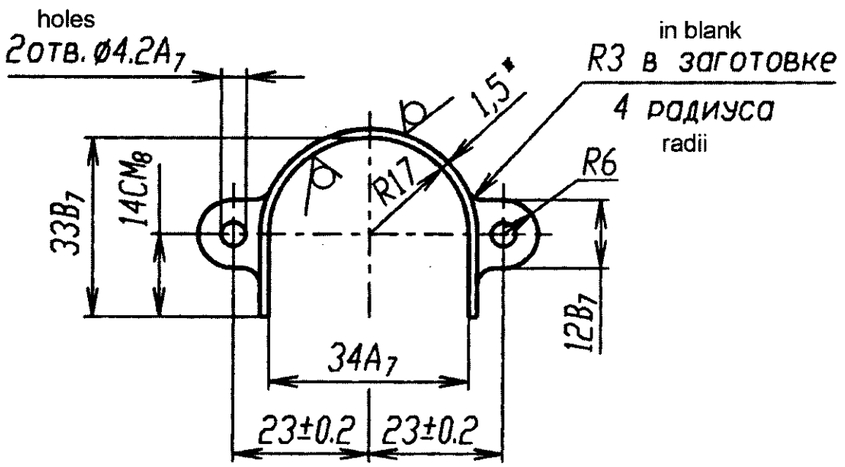
Reference No.

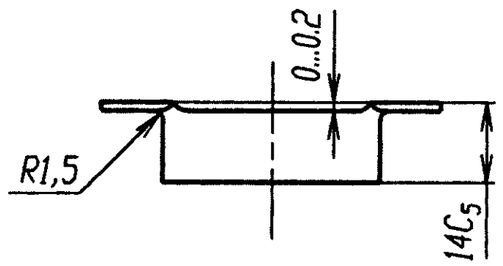
First use

Blank No. 406

АК-630 106-19			

Rz80 (√)





1.* Reference dimension.
2.Blunt sharp edges ~0.4 mm.
3.Coating Cd 12. phos.
Lacquer BF-4 with Nigrosine , two coats, made as per OST 3-4123-78 IV, OM2.
4. Mark Ш, Ч and stamp К on tag.

Approved KTONI | Approved by shop | First use
Approved OGMet | Approved | Reference No.
Orig. Inv. No. | Dupl. Inv. No. | Sign and Date
Sign and Date | Alternate Inv. No | Sign and Date

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				

АК-630 106-19

Cover

Type	Weight	Scale
A	0.017	1:1

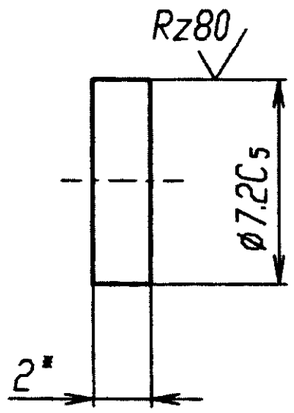
Sheet | Sheets 1

Sheet $\frac{BT-PN-O1.5GOST19904-90}{K490V4-III-35GOST16523-97}$

Copied by | Format A4

Blank No. 406

AK-630 106-20



1.* Reference dimension.
2.Blunt sharp edges ~0.4 mm.
3. Mark Ш, Ч and stamp К on tag.
4. It is permissible to use fibre board FT-2 TU 5458-835-024 8643-92.

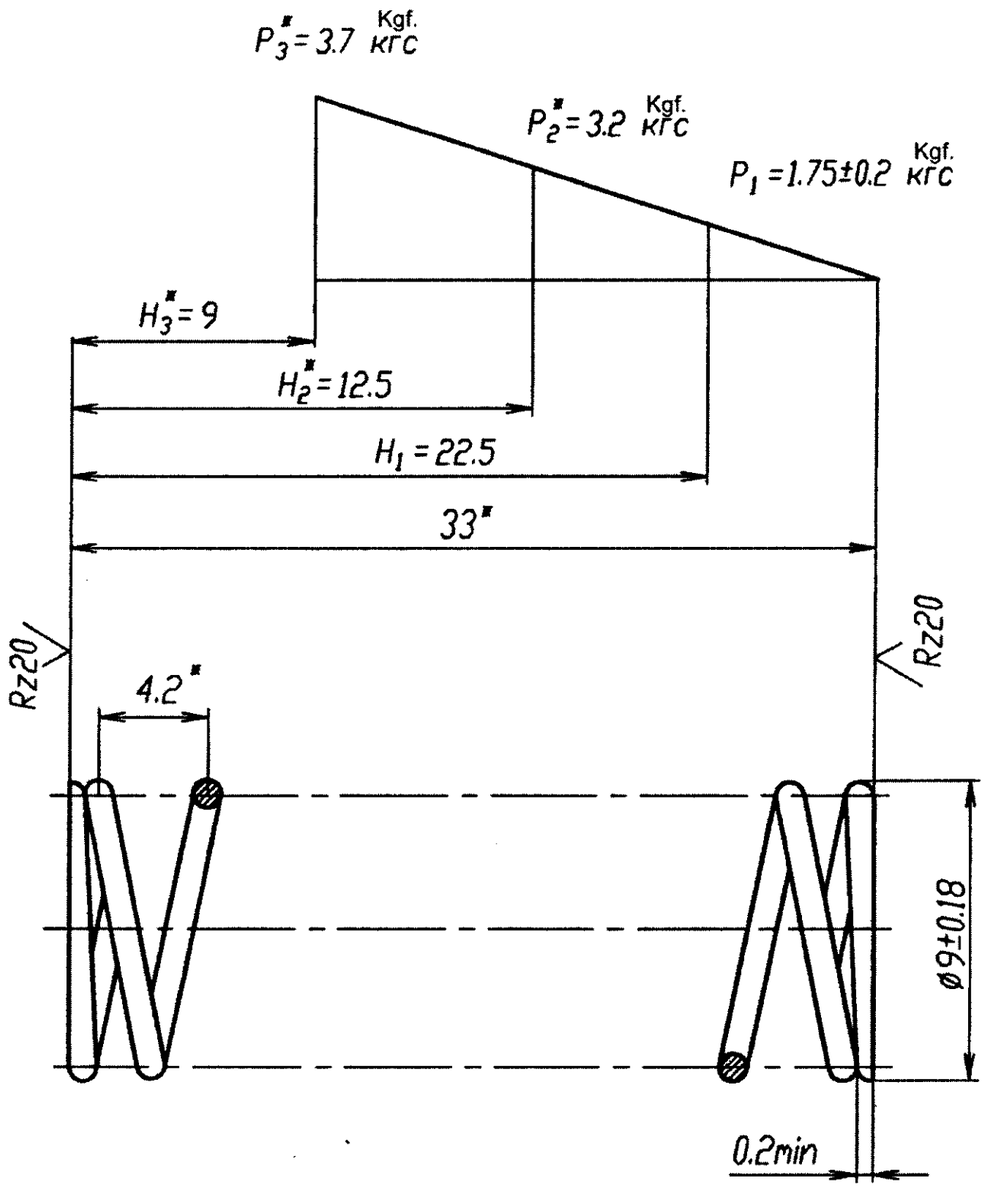
Amend.	Sheet	Doc. No.	Sign	Date	**AK-630 106-20**			
					Buffer	Type: A	Weight: 0.0002	Scale: 5:1
Developed by						Sheet	Sheets 1	
Checked by								
Head of Q.C.D					Fibre board FT-2 GOST 14613-83			
Design bureau chief								
Head of Q.C.D								
Approved by								

Approved KTONI | Approved by shop | Approved OGMet | Approved Osb | First use | Reference No. | Sign and Date | Dupl. Inv. No. | Alternate Inv. No | Sign and Date | Orig. Inv. No.

Copied by

Format A4

AK-630 106-21



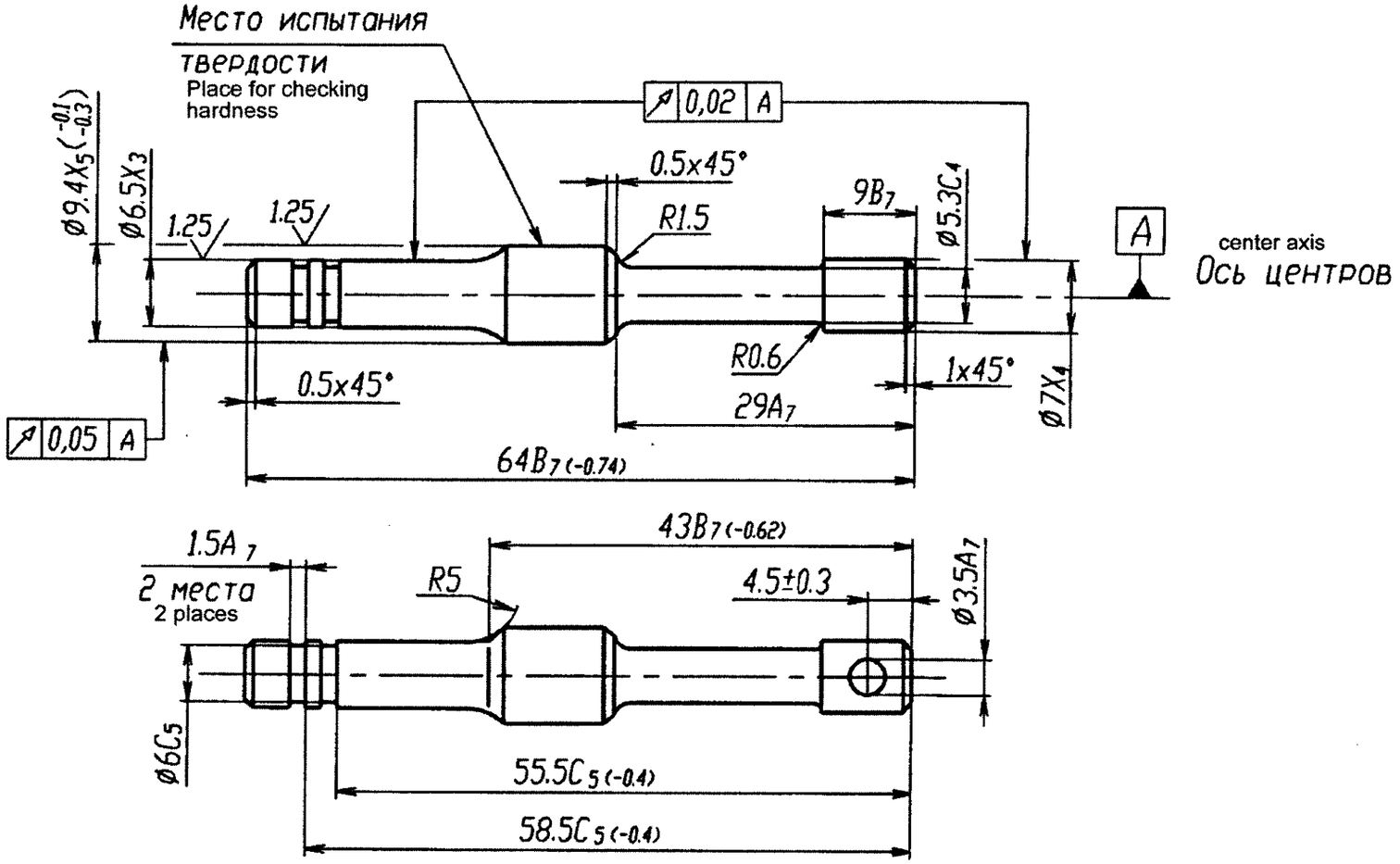
√(√)

1. Group I.
2. G* = 8000 kgf/mm^2. τ_3* = 127 kgf/mm^2.
3. Unrolled length of spring L* = 275 mm.
4. Coiling direction- right.
5. n = 7.5.
6. $n_1 = 9.5 \pm 0.5$.
7. Heat treatment- tempering 240-260^{0}C.
8. $D_g = 10A_5$ mm.
9. D_S.
10. Pre deformation time (at H_Z) –24 hours.
11. Coating Chem.phos. accel.Cr. Lacquer BF-4 with nigrozene, 2 coats, made as per OST 3-4123-78, IV, OM2.
12. * Dimensions and parameters for reference.
13. Other technical requirements as per GOST 16118-70.
14. Mark Ш, Ч and stamp К, И on tag.

Amend.	Sheet	Doc.No.	Sign	Date	AK-630 106-21			
Developed by					Spring	Type	Weight	Scale
Checked by						A	0.001	5:1
						Sheet	Sheets 1	
Head of Q.C.D					Wire V-1-0.9 GOST 9389-75			
Approved by								

First use | Reference No. | Duplicate Inv. No | Alternate Inv. No | Sign and Date | Orig. inv. no.

AK-630 106-22



Rz40 (√)

1. 38.5..44.5 HRC_E.
2. Inner angles R~0.4 mm.
3. Blunt sharp edges ~0.4 mm.
4. Coating Cd 6.phos.Oil.
5. Mark Ш, Ч and stamp К, И on tag.

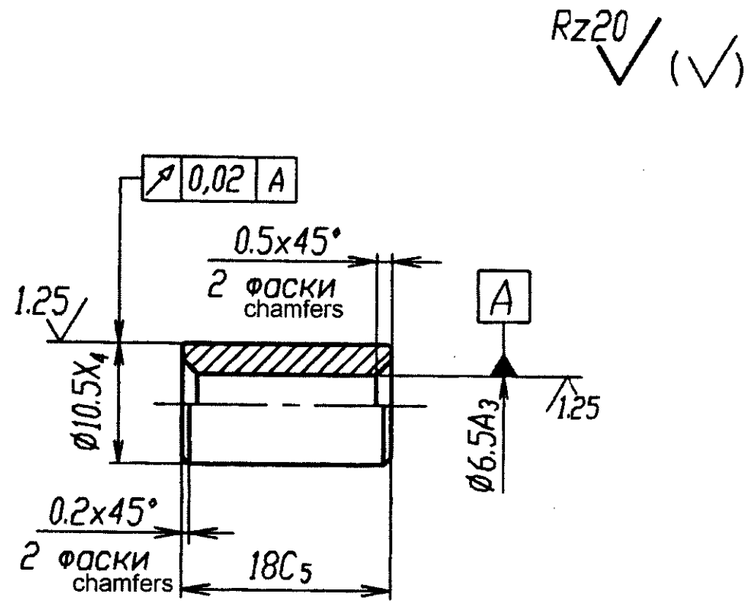
					AK-630 106-22
Amend.	Sheet	Doc.No.	Sign	Date	Locator
Developed by					Type: A; Weight: 0.017; Scale: 2:1
Checked by					Sheet: ; Sheets: 1
Head of Q.C.D					Steel 40 Kh GOST 4543-71
Approved by					

First use | Reference No. | Duplicate Inv. No | Alternate Inv. No | Sign and Date | Orig. inv. no.

Blank No. 406

AK-630 106-23

Approved by shop | First use | Reference No. | Approved KTONI | Sign and Date | Dupl. Inv. No. | Approved Osb | Alternate Inv. No | Sign and Date | Approved OGMet | Orig. Inv. No.



1. 38.5..44.5 HRC_E. Check on specimen.
2. Blunt sharp edges ~0.2 mm.
4. Coating Cd 6.Cr.
5. Mark Ш, Ч and stamp К, И on tag.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				

Copied by

AK-630 106-23

Bush

Type	Weight	Scale
A	0.008	2:1

Sheet | Sheets 1

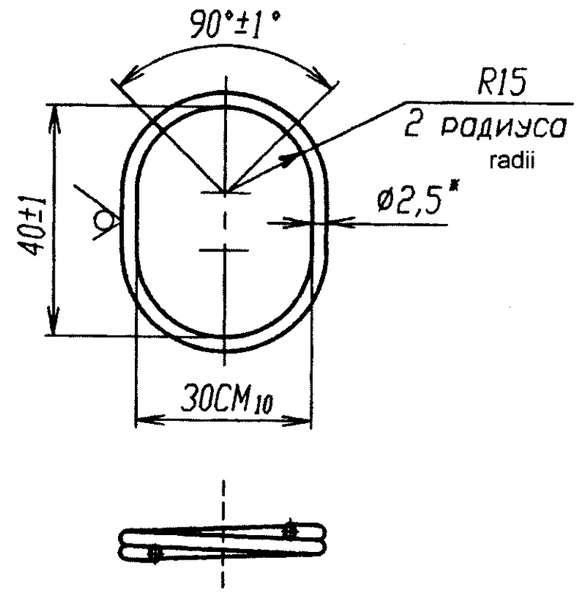
Steel 50 GOST 1050-88

Format A4

Blank No. 406

AK-630 106-24			

Rz80 (√)



1. Substitute material : Wheel $\frac{3-5\,GOST\,7417-75}{50-T-V\;GOST\;1051-73}$
2. 69..72 HRA, Check on specimen.
3.* Reference dimension.
4. Blunt sharp edges ~0.4 mm.
5. Number of turns n = 1.8
6. Coating Cd 12.phos. Oil.
7. Mark Ш, Ч and stamp К, И on tag.

Approved KTONI | Approved by shop | First use
Approved OGMet | Reference No.
Approved Dsb | Sign and Date
Orig. Inv. No. | Alternate Inv. No | Dupl. Inv. No. | Sign and Date

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				

Copied by

AK-630 106-24

Ring

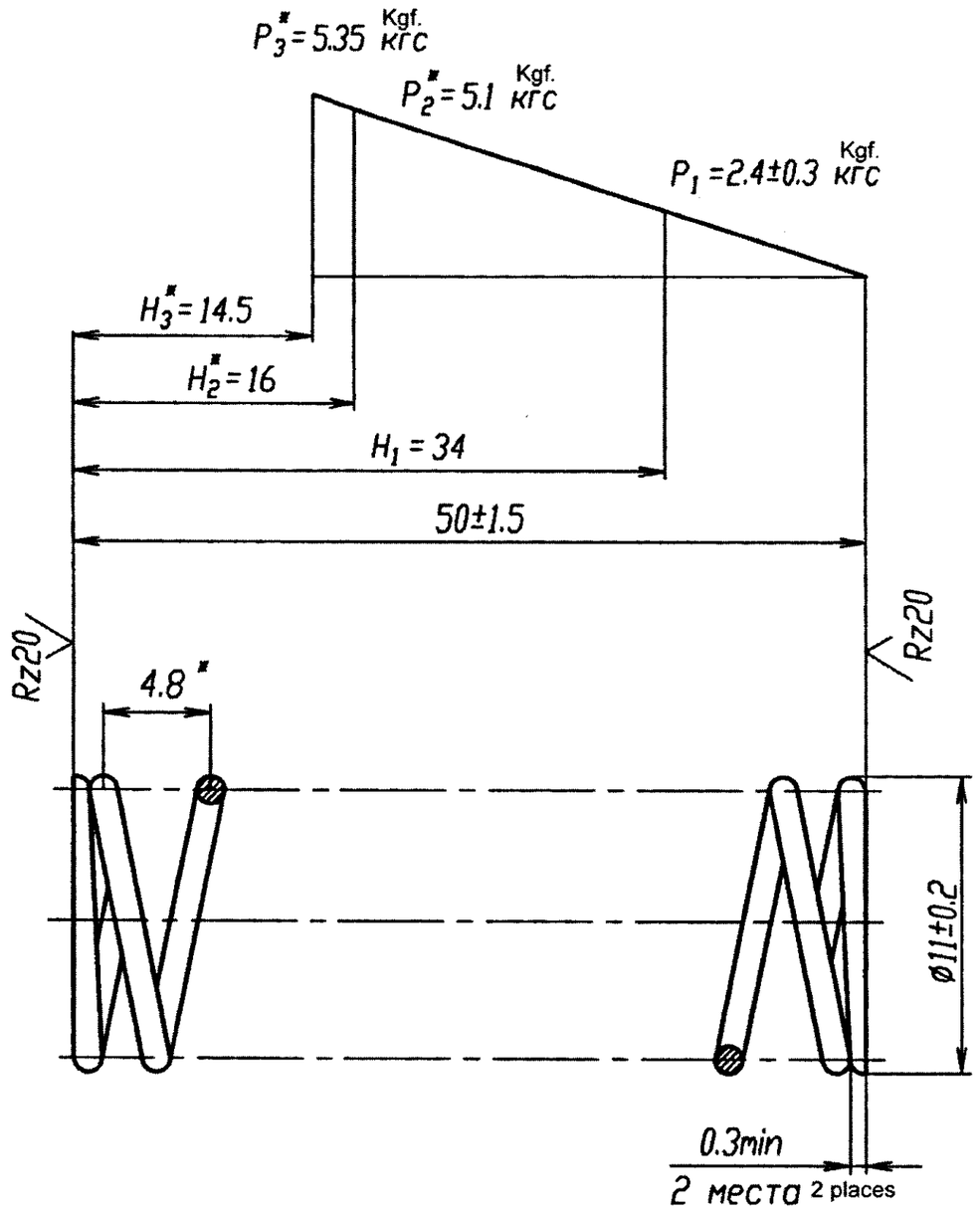
Type	Weight	Scale
A	0.009	1:1

Sheet | Sheets 1

Wire 2.5-50
GOST 17305-91

Format A4

AK-630 106-25



1. Group III.
2. $G^* = 8000$ kgf/mm^2. $\tau_3^* = 118$ kgf/mm^2.
3. Unrolled length of spring $L^* = 400$ mm.
4. Coiling direction- left.
5. n = 10.
6. $n_1 = 12 \pm 0.5$.
7. Heat treatment- tempering 240-260^{0}C.
8. $D_g = 11.8A_5$
9. D_S.
10. Pre deformation time (at H_Z) –24 hours.
11. Coating Chem.phos. accel.Cr. Lacquer BF-4 with nigrozene, 2 coats, made as per OST 3-4123-78, IV, OM2.
12. * Dimensions and parameters for reference.
13. Other technical requirements as per GOST 16118-70.
14. Mark Ш, Ч and stamp К, И on tag.

Amend.	Sheet	Doc.No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

AK-630 106-25

Inner Spring

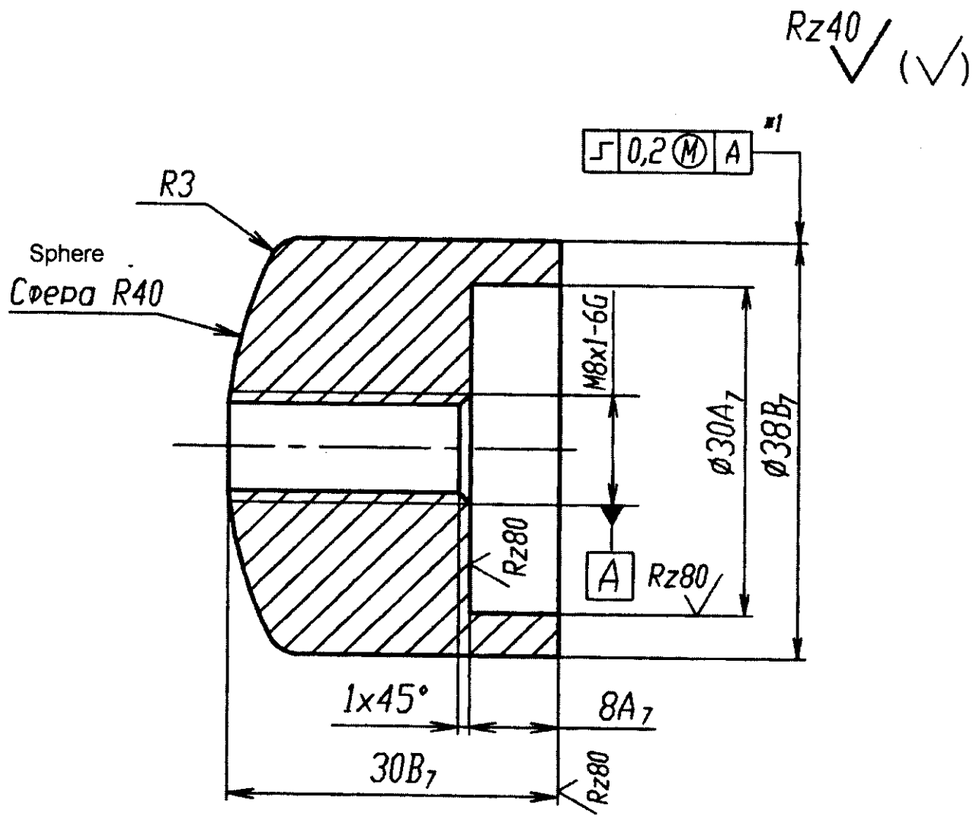
Type	Weight	Scale
A	0.002	5:1
Sheet	Sheets 1	

Wire V-1-1.1
GOST 9389-75

First use | Reference No. | Sign and Date | Duplicate Inv. No | Alternate Inv. No | Sign and Date | Orig. inv. no.

Blank No. 406

AK-630 106-26



1.*1Dimensions ensured by tool.
2.Inner angles R~0.4 mm.
3.Blunt sharp edges ~0.6 mm.
4.Coating An.Oxi.Cr.
Lacquer BF-4 with Nigrosine , two coats, made as per OST 3-4123-78 IV, OM2.
5. Mark Ш, Ч and stamp K on tag.

Approved by shop | First use
Reference No.
Approved KTONI
Sign and Date
Dupl. Inv. No.
Osb
Approved
Alternate Inv. No
Sign and Date
Approved OGMet
Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				

AK-630 106-26

Handle

Type	Weight	Scale
A	0.07	2:1

Sheet | Sheets 1

Rod V95 KR40
GOST 21488-97

Copied by

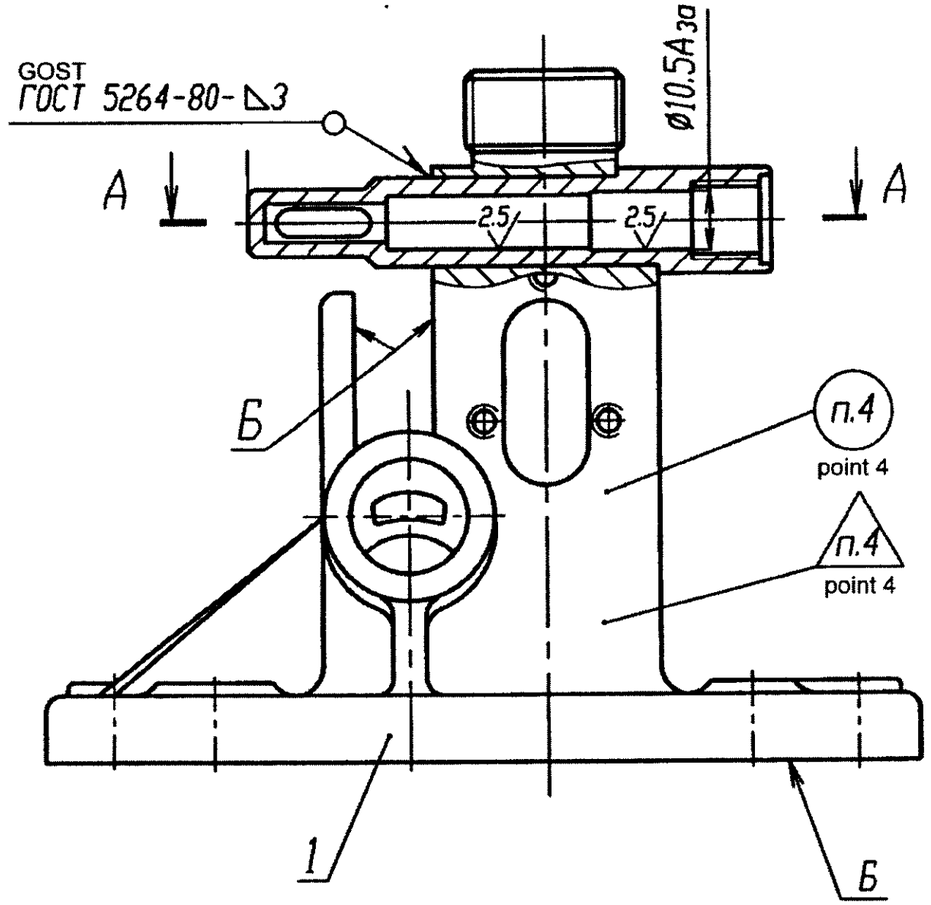
Format A4

First use / Reference No.	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
					Documents		
	A3			AK-630 Sb 106-1 SB	Assembly drawing		
					Components		
	*)		1	AK-630 106-35	Body	1	*) A2 x 3
	A4		2	AK-630 106-33	Sleeve	1	

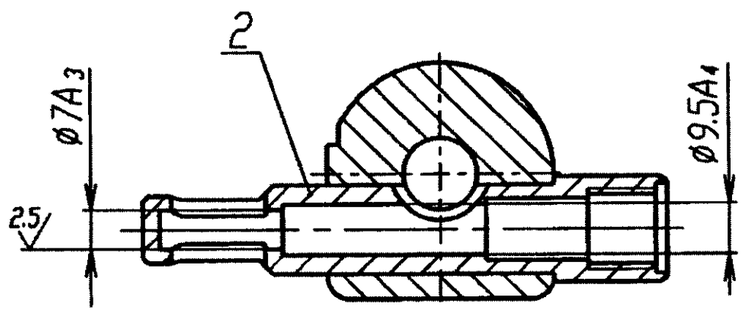
Sign and Date / Dupl. Inv. No. / Alternate Inv. No / Sign and Date / Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date	AK-630 Sb 106-1		
Developed by					Body	Type: A	Sheet:	Sheets: 1
Checked by							
Head of Q.C.D							
Approved by							

AK-630 Sb 106-1 SB



A-A

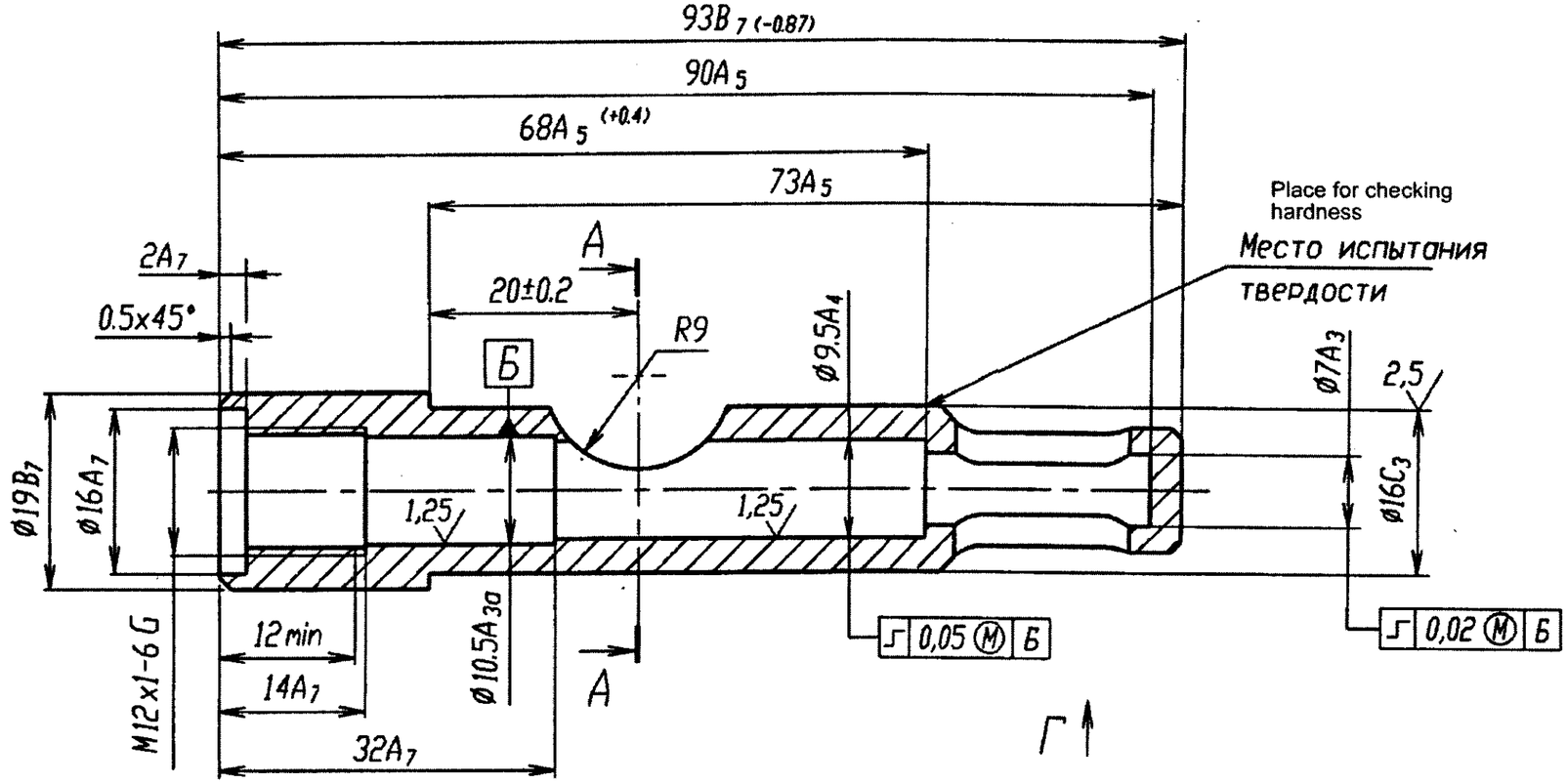


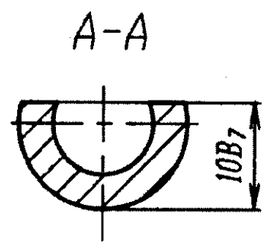
1. Argon-arc welding as per GOST 14771-76 with filler wire 5Sv.06 Cr.19Ni9Ti GOST 2246-70 is permissible.
   Welding rod UONII 13/45 3.0-3 GOST 9466-75.
2. Remove stress after welding.
3. Coating of inner surfaces, surface Б and thread- Chem.phos., for others:
Primer AK-070, yellow, (2)
Enamel KhV-124, gray, (4), IV OM2.
AK-070 GOST 25718-83
KhV-124 GOST 10144-89.
4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

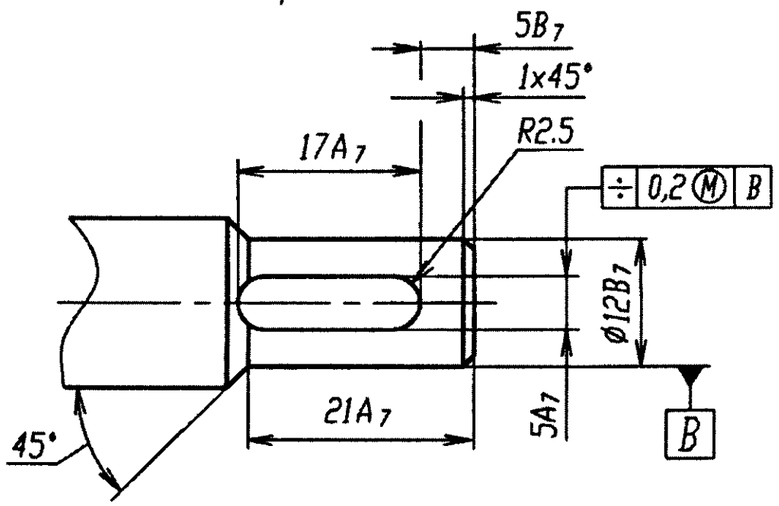
					AK-630 Sb 106-1 SB	
					Assembled body Assembly drawing	Type: A; Weight: 3.350; Scale: 1:1; Sheet; Sheets 1
Amend.	Sheet	Doc.No.	Sign	Date		
Developed by						
Checked by						
Head of Q.C.D						
Approved by						

First use | Reference No. | Duplicate Inv. No | Alternate Inv. No | Sign and Date | Orig. inv. no.

AK-630 106-36







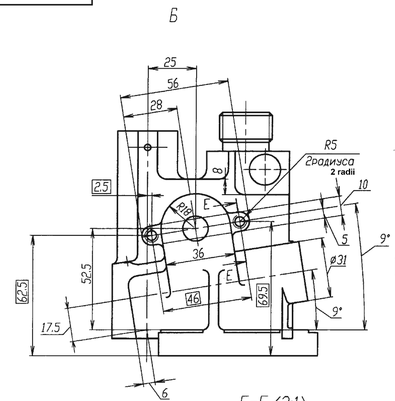
Rz80 (√)

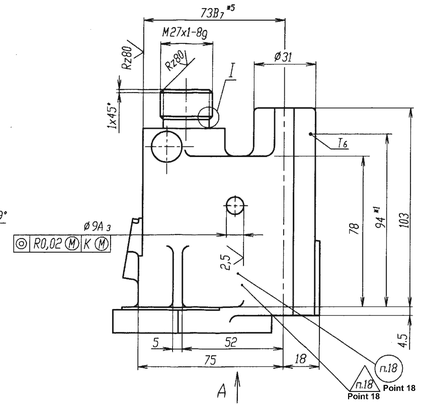
1. 34..39.5 HRC_E. Check hardness of 3-5% from the batch but not less than 3 nos.
2. Inner angles R~0.4 mm.
3. Blunt sharp edges ~0.6 mm.
4. Mark Ш, Ч and stamp К, И on tag.

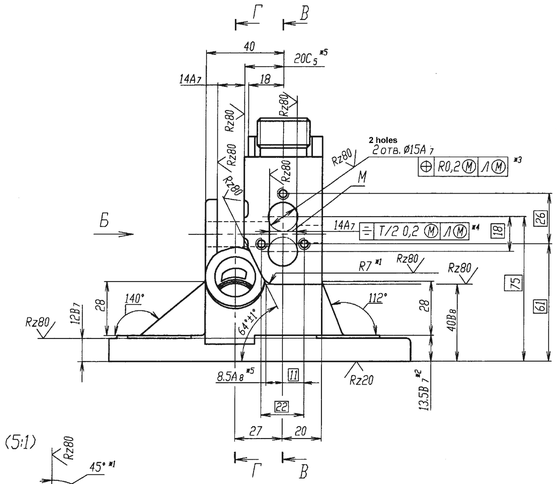
					AK-630 106-36			
						Type	Weight	Scale
Amend.	Sheet	Doc.No.	Sign	Date	Sleeve	A	0.085	2:1
Developed by						Sheet	Sheets 1	
Checked by								
Head of Q.C.D					Steel 35 GOST 1050-88			
Approved by								

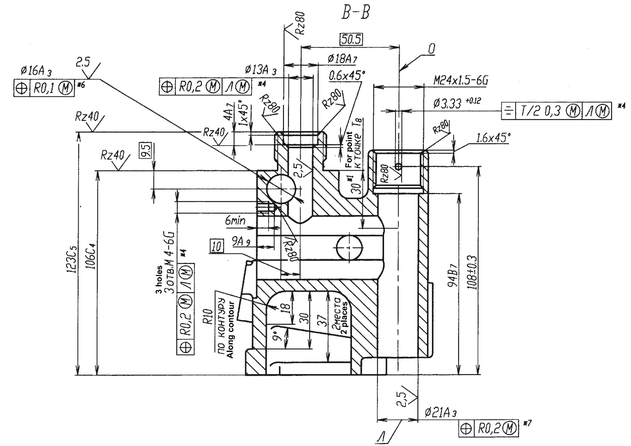
First use | Reference No. | Duplicate Inv. No | Alternate Inv. No | Sign and Date | Orig. inv. no.

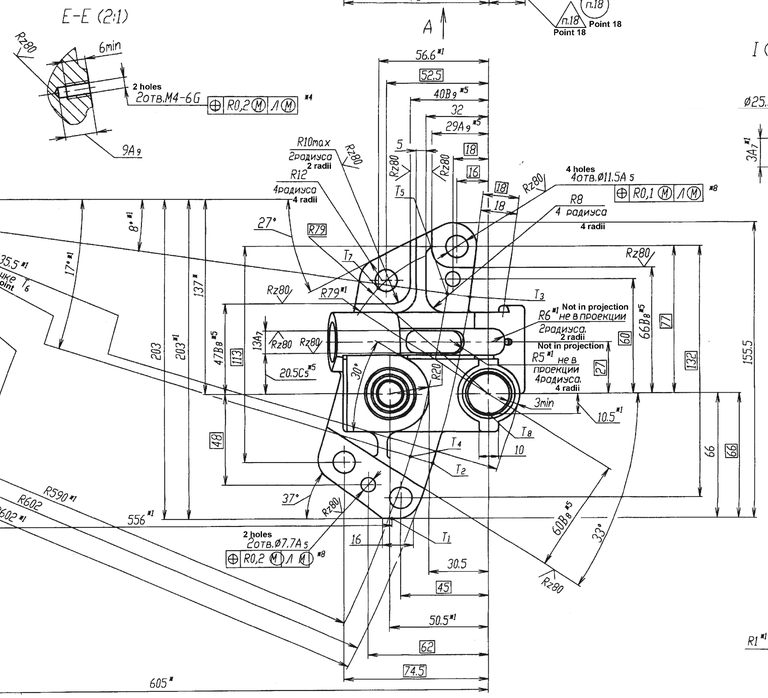
АК - 630 106-35

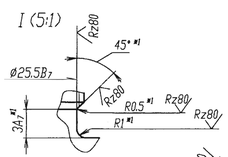


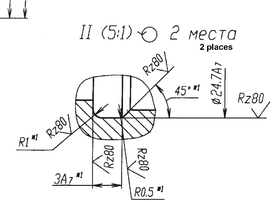


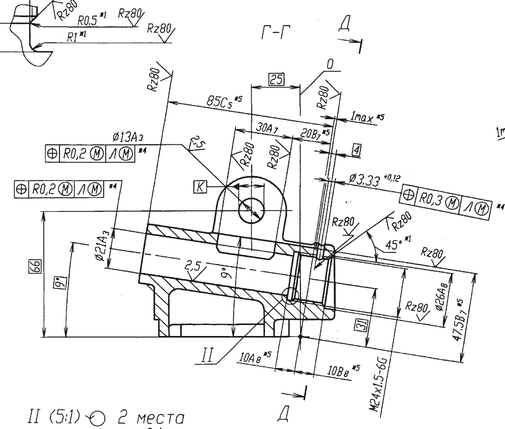


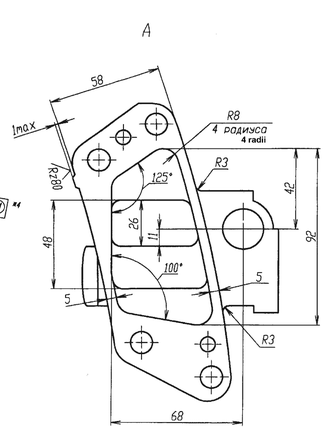


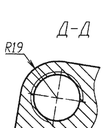












1. 27...33HRCe.
2. Casting accuracy 9T-0-0-9 as per GOST 26645-85.
3. Draft toward side of increase of dimensions as per GOST 3212-92.
4. Unless otherwise specified casting radii of inner angles 5 mm outer not more than 3 mm .
5. Displacement on plane joint should not be more than 0.3 mm. Traces from pusher ± 0.5 mm is permisible
6. Surface finish of casting surfaces as per test specimen .
7. Inner angles R 0.4 mm .
8. Blunt sharp edge 0.6 mm .
9. * Reference dimensions .
10. *1 Dimensions are ensured by tool .
11. *2 Dimensions are given in respect to datum points T1; T2; T3; T4; T5; T6.
12. *3 Deviation is given in respect to datum point T7 Till machining of slot M .
13. *4 Deviation is given in respect to datum point T7 .
14. *5 Dimensions are given in respect to surface A and point T7 .
15. *6 Deviation is given in respect to datum point T8 .
16. *7 Deviation is given in respect to datum points T1; T2; T3.
17. *8 Deviation is given in respect to datum point T3 .
18. Mark П,М,Ш,Ч and stamp К,И on АК-630, АК-630М ТУ 1

Amend	Sheet	Doc. No.	Sign	Date			
Developed by							
Checked by							
Technician							
Head of bureau							
Head of QCD							
Approved by							

АК - 630 106-35

Body

Type	Weight	Scale
A	3.280	1:1

Sheet | Sheets 1

Casting K-25-II OST3-4365-79 35L GOST 977-88

Format A2x3

First remarks | Reference No. | Sign & Date | Alternate Inv. No. | Duplicate Inv. No. | Sign & Date | Inv. No.