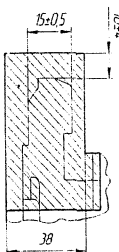
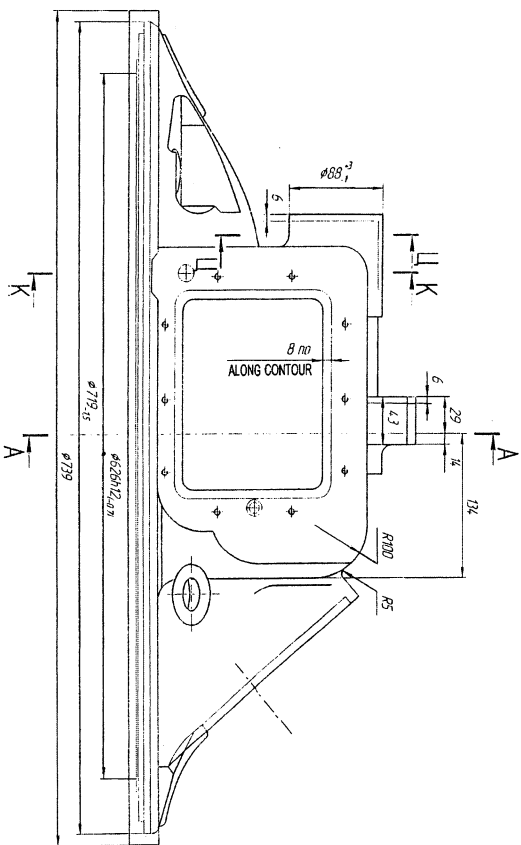


1. GRADE OF STEEL: HEAT TREATMENT. METHOD OF ACCEPTANCE AND TESTING SHOULD COMPLY WITH THE LIST OF COMPONENTS MADE OUT OF SPECIAL STEEL. HARDNESS MEDIUM.
2. REQUIREMENT FOR CASTING SHOULD COMPLY WITH 172TY6.
3. ACCURACY OF CASTING 11, 0, 0 - 10. GOST 26645-86.
4. OPENING IN CASTING IS TO BE CHECKED BY THE SMOOTH PASSAGE OF DUMMY, MADE AS PER MINIMUM DIMENSIONS 147A.1. IN THIS CASE RADI IN CORNERS OF DUMMY SHOULD NOT EXCEED R4MM.
5. MOUNT SOCKET FOR DEVICE TKH-HC (6A1.335.0517A) IS TO BE CHECKED BY THE DUMMY HEAD OF DEVICE, MADE AS PER OVERALL DIMENSION OF THE HEAD DRAWING. CLEARANCE BETWEEN HEAD OF DEVICE AND UNIT OF HATCH SHOULD BE NOT LESS THAN 3MM. GRINDING OF MOUNT; SOCKET IS ALLOWED.
6. OTHER REQUIREMENT SHOULD COMPLY WITH 520TY1.
7. COMPONENT IS TO BE CHECKED AS PER WEIGHT. MAXIMUM PERMISSIBLE WEIGHT 68KG.
8. RESIDUES ARE ALLOWED AFTER CUTTING THE RISERS ABOVE TOLERANCE FOR MACHINING.
9. IN TH AREA OF MACHINING RECTIFICATION OF DEFECTS AFTER HEAT TREATMENT IS NOT ALLOWED.
10. TOLERANCE FOR ALLOWANCE ±4.
11. IN PLACES OF FINING CORE UNEVEN RUN WITHIN THE LIMITS OF TOLERANCE FOR ALLOWANCE IS ALLOWED.
12. DATUM SURFACE SHOULD BE UNIFORM AND CLEAN.
13. RECTIFICATION OF THROUGH DEFECTS ON LUG WITH AN AREA OF 2CM² IS ALLOWED BY ONSUNING SURFACE FINISHING AND DIMENSIONS AS PER DRAWING.
14. * DIMENSIONS FOR REFERENCE.
15. SCALE 1:2
16. REFER COMPONENT 506. NS 188.11.001, FOR OTHER DETAILS.

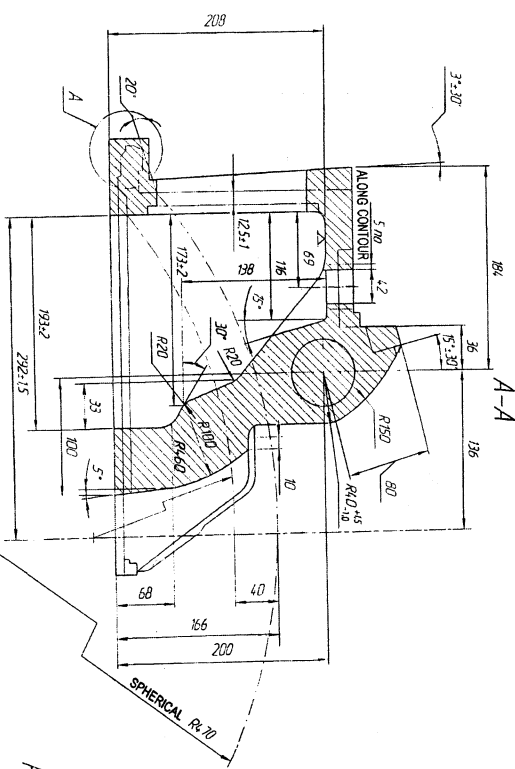
APPROVED
TECH-CELL

SHEET 1 OF 2.

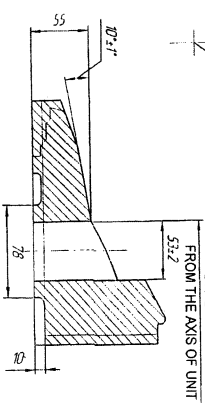
① None is added.	T 80
② View E: Dim. 142±.5 added.	MATERIAL CASTING WT
③ View A: Dim. 142±.5 added.	172 TY6 68 Kg
④ View D: Dim. 38 rounded to 43.	ALT. MATERIAL HARDER SCALE
⑤ View P-P: Dim. 55 rounded to 50.	1:2
⑥ View A-A: Dim. 110 rounded to 105.	DRAWN CHECKED APPROVED
⑦ Dim. 142 rounded to 140.	DESIGNED
⑧ View U-U: B-B, Callout corrected.	DATE
⑨ View U-U: Dim. 137, 147, 53 added.	APPENDICES
⑩ View 2 D: Dim. 112 added.	DRAWING NO. 188.11.001/C
⑪ View B-B: Dim. 281 rounded to 241.	NOMENCLATURE HATCH UNIT
	HEAVY VEHICLES FACTORY
	AVD/CB/BNVA



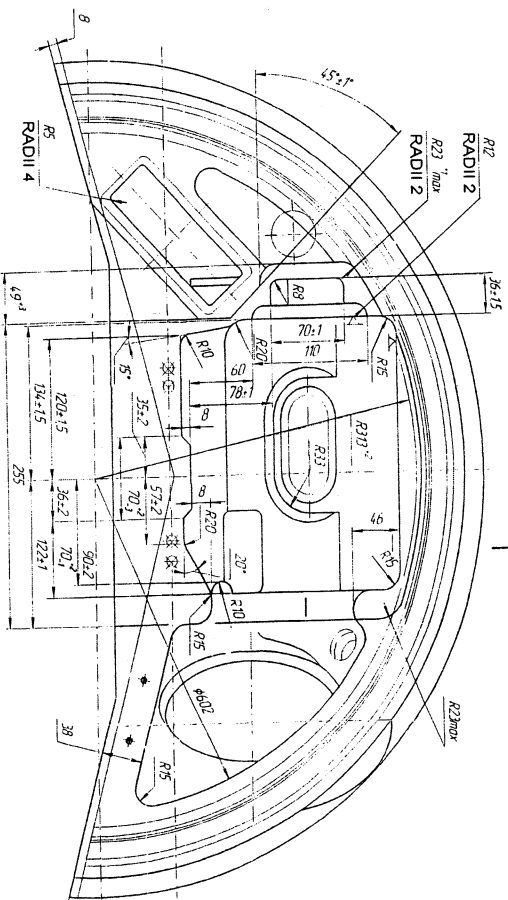
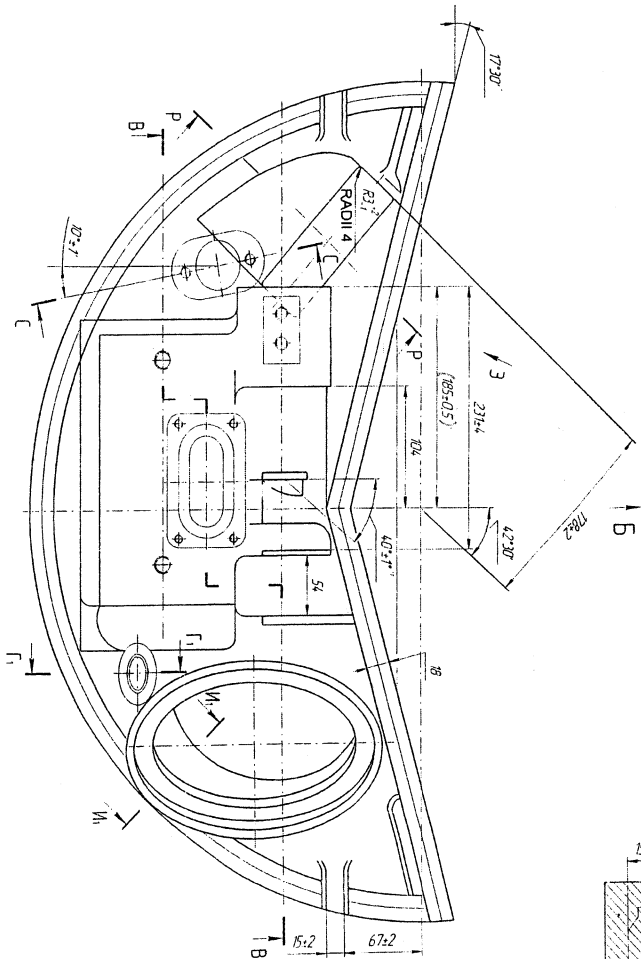
A: (1:1)



B



P.P. O



188-11-CC1
HATCH UNIT
SHEET 2 of 2