



- Grade of metal treatment, method of acceptance and testing comply with the list for components made out of special steel.
- Accuracy of casting as per GOST 20645-85.
- Dimension given in brackets are after welding the bracket on hub.
- On surface H and I (see r/r) should be 17 mm is allowed.
- Dimension of minor diameter of thread L₁ by 0.2 mm is allowed (see r/r) above the tolerance and screwing in of no greater at depth not exceeding 1 mm is allowed.
- Dimension H₁ (see r/r) for holes L₂ (see main view) should not be less than 7 mm over a distance of 10 mm from surface H for the rest of the length should not be less than 5 mm.
- Dimension L₁ (see r/r) with surface finishing R_a=0.80 microns is to be maintained over a length of 125 mm for the rest of the length.
- For ensuring dimension L₁ (see r/r) R_a may be removed.
- Dimension C₁ is to be checked at a distance of not less than 32 mm from surface H (see r/r).
- On surface H (see r/r) tool marks are allowed by 0.2 mm.
- On surface P (see main view) technological allowance with value not exceeding 10 mm is allowed.
- Coming out of drill to thread H₂ (see A-A) to the outer side is allowed.
- After removing technological allowance between machined and casting surfaces are allowed by 0.2 mm.
- On surface H₂ (see main view) technological allowance with value not exceeding 10 mm is allowed.
- For ensuring dimension C₁ (see C-C) on the area marked with dot and dash line (see view from the left) machining with surface finishing R_a=0.80 microns is allowed. Machining may be restricted by casting through, for ensuring dimension B by not more than 1 mm. In section restricted with dimension C₂ any not building up in flange with surfaces T of bracket, raising up of building up should not exceed 1 mm.
- * Dimension for reference.
- On surface V, D, H, section without rectifying the casting surface with a tool less than 25% are allowed.
- Use designated with dot and dash lines with dimension M₁H₁ (see V) and H₁ C₁ (see main view) may be made along the entire length of boss.
- Value of shoulder A₁ (see r/r) need not be checked.
- Other requirements as per GOST 171.
- * Dimension and surface finishing are to be ensured by tool.
- For ensuring dimension for finishing of surface L₂ (see r/r) with surface finishing R_a=0.80 microns is allowed, within the limits of tolerance zone for dimension L₂ (see r/r).
- On surface F₁ T₁ (see main view) black spots are allowed by not exceeding 1/30 of the total area.

DIMENSIONS GIVEN IN BRACKETS ARE ALTERNATIVE

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DATE	BY	CHECKED	APPROVED	REVISION

PILOT SAMPLE SHOULD BE APPROVED BY A B S P BEFORE SERIAL PRODUCTION.

SEE "N" FOR RE DIMENSIONS OR MARKS WHERE SHOWN IN INDICATED THROU HOLE LETTERS.

THIS DRAWING SHALL BE CONTROLLED BY THE QUALITY CONTROL DEPARTMENT BY THE MANUFACTURER CONTROL TO DATE. IN OTHER CASES, DIMENSIONS SHALL BE CONTROLLED BY THE MANUFACTURER.

DATE	BY	CHECKED	APPROVED	REVISION

DATE: 1970.11.15
NATURE OF AMENDMENTS:

ITEM NO. 172.01.636-4
LH SUPPORT OF ROAD WHEEL ARM
DRAWING NUMBER 172.01.636-4