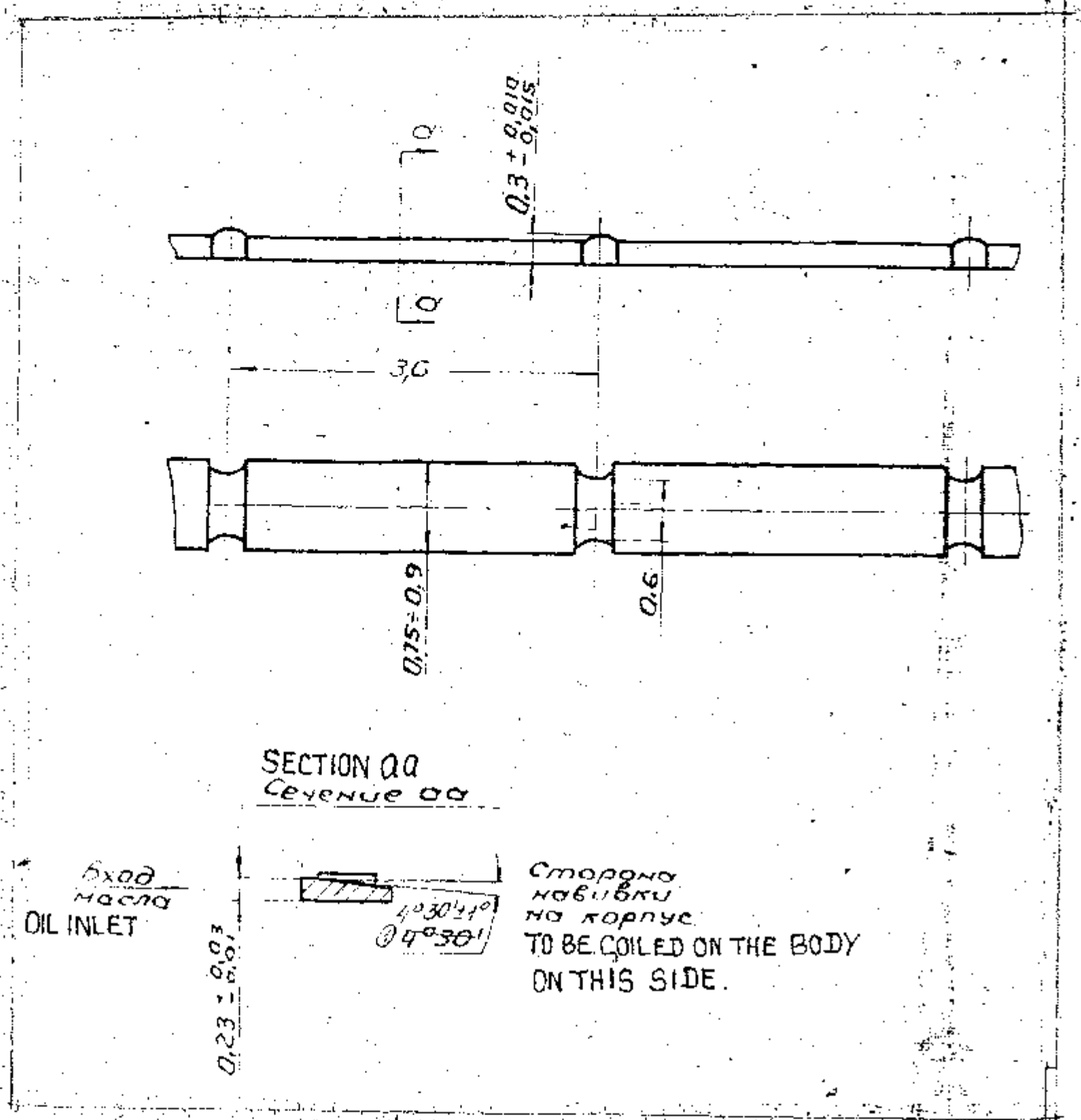




DRAWING NUMBER
313-47



SECTION AA
Сечение AA

ОИЛ ИНЛЕТ
Стороно навивки на корпус
TO BE COILED ON THE BODY ON THIS SIDE.

REQUIREMENTS FOR STAMPING AS PER STANDARD 82050-16

NET WEIGHT	FOR ASSEMBLY	QUANTITY OF UNITS PER OBJECT
0.700	CB 313-03-3	1
0.640	CB 313-04-2	1
	CB 313-05-7	1
0.445	CB 3313-03-4	2
0.415	CB 413-04	1
0.330	CB 413-05	1
0.255	CB 413-06	1
0.640	CB 413-116	1

EXPLANATORY NOTE:

REFERENCE MATERIAL QUOTED: BRASS WIRE/COLD DRAWN 'A' SQUARE ROUND SECTION 'KP' NORMAL MANUFACTURING ACCURACY 'H' SOFT CONDITION 'M', DIA 0.5 (±0.040)mm, GRADE Л63 TO GOST 1066-80 AND MANUFACTURED IN ACCORDANCE WITH BRASS GRADE Л63 TO GOST 15527-70.

a) CHEMICAL COMPOSITION AS PER GOST 15527-70

BRASS GRADE	CONTENT OF ELEMENTS %							
	BASIC ELEMENTS		ADMIXTURES MAXIMUM					
	Cu	Zn	Pb	Fe	Sb	Bi	P	TOTAL
Л63	62.0-65.0	REMAINDER	0.07	0.2	0.005	0.002	0.01	0.5

b) MECHANICAL PROPERTIES AS PER GOST 1066-80

BRASS GRADE	CONDITION	ULTIMATE TENSILE STRENGTH KgF/mm ² MIN	RELATIVE ELONGATION % MIN
Л63	SOFT	35	20

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

EST. MASS TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	TCD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	ALL THREADS CONFORM TO
				19-5-86	20:1			
MATERIAL - WIRE AKPHM 0.5 BRASS Л63 GOST 1066-80								USED ON: CB 413-04-1 CB CB 413-05-1 CB CB 413-06-1 CB
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES AVADI)								TITLE:- STRIP FILTERING
ISSUE DATE NATURE OF AMENDMENTS								D S CAT NUMBER
								DRAWING NUMBER 313-47

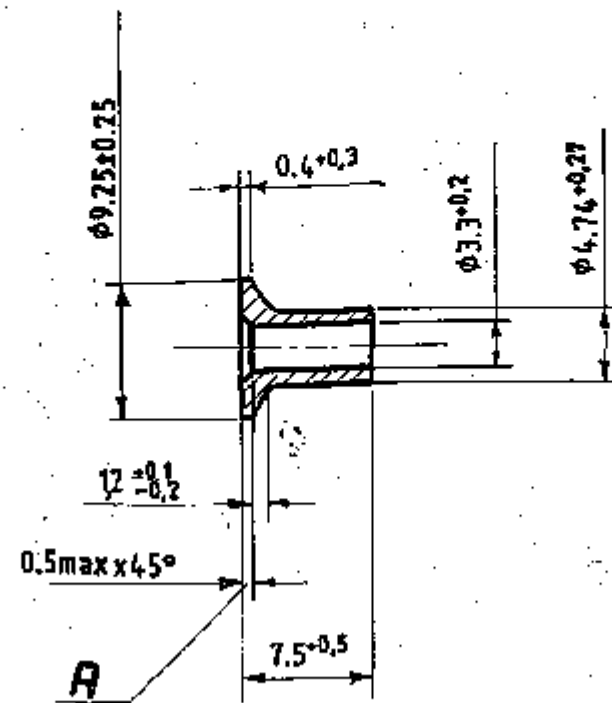
(A-6)

SIZE A2



DRAWING NUMBER:

3313 174



EXPLANATORY NOTE

6. REFERENCE MATERIAL QUOTED:

BRASS Λ 63 TO GOST 15527-70.

GRADE OF BRASS	CONTENT OF ELEMENTS %							
	BASIC ELEMENTS		ADMIXTURES MAXIMUM					
	Cu	Zn	Pb	Fe	Sb	Bi	P	TOTAL
Λ 63	62.0-65.0	REMAINDER	0.07	0.2	0.005	0.002	0.01	0.5

1. MAY BE ANNEALED.
2. SHIFT OF HOLE AXIS RELATIVE TO THE BAR AXIS SHOULD NOT EXCEED 0.2mm
3. SHIFT OF HEAD AXIS RELATIVE TO THE BAR AXIS SHOULD NOT EXCEED 0.3mm
4. CHAMFER A MAY NOT BE DONE.
5. MACHINING OF HOLE AND CHAMFER A TO SURFACE ROUGHNESS $Rz 6.3$ IS ALLOWED.

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

EST WT.
0.0008 Kg

TO BE STAMPED OR MARKED WHERE INDICATED THUS II (LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

DRS

CHD

TCB

APRD

DATE

SCALE: 2 : 1

DIMENSIONS IN mm

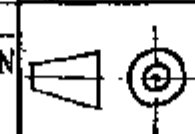
TOLERANCE ON DIMN
UNLESS OTHERWISE
STATED

ALL THREADS TO
CONFORM TO

MATERIAL: BRASS Λ 63
GOST 15527-70 STAMPING

USED ON: CB 413 04 1 CB
CB 413 05 1 CB
CB 413 06 1 CB

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)
AVADI



TITLE

RIVET TUBULAR

D S CAT NUMBER

DRAWING NUMBER

3313 174

8	7	6	5	4	3	2	1
ISSUE	DATE	NATURE OF AMENDMENTS					

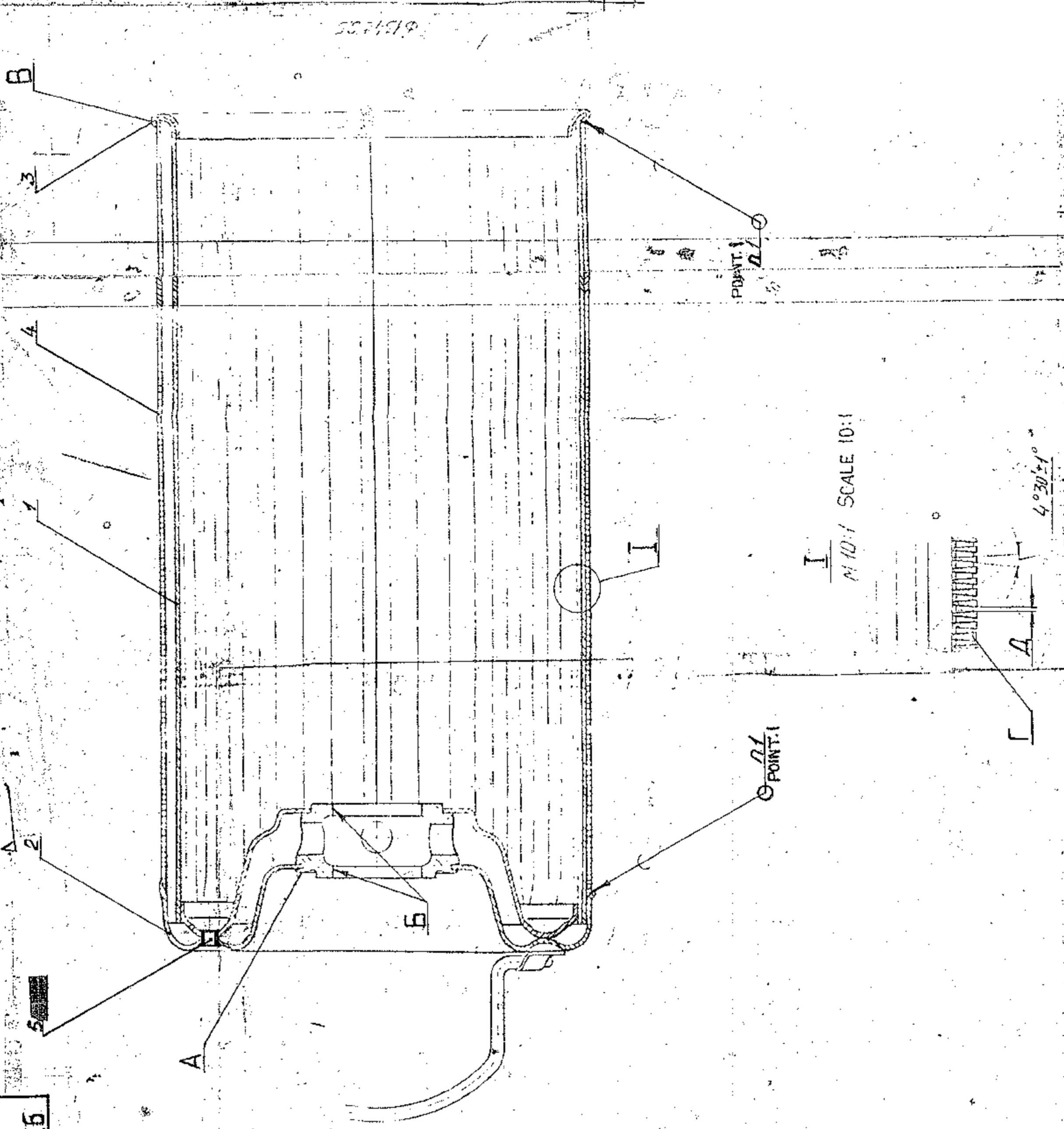
A-6

SIZE A3



SIZE A2
A6

DRAWING NUMBER
CB 413-04-106



1. SOLDER PASTE POLICY 30-0.5 GOST 71931-76 TO BE SOLDERED AS PER INSTRUCTIONS UM-639-80.
2. IN EXCEPTIONAL CASES RUPTURES ON FILTERING STRIP F ARE ALLOWED UP TO 4 SOLDERED PLACES WITH TOTAL AREA NOT EXCEEDING 2.5cm² ARE ALLOWED. CLEARANCE IN THE PLACE OF SOLDERING SHOULD NOT EXCEED 0.1mm. TO BE CHECKED WITH MICROSCOPE ACCURACY OF MEASUREMENT 0.01mm.
3. CLEARANCE $\Delta = 0.025$ TO 0.09 mm IS TO BE ENSURED BY TOOL DURING COILING OF STRIP F ON THE CUP.
4. IN PLACE A TIGHT FITTING OF MATING COMPONENTS SHOULD BE ENSURED; CAULKING OF COMPONENT 2 IS ALLOWED.
5. COMPONENT 3 IS TO BE FLANGED BEFORE COILING OF STRIP F.
6. THERE MAY BE NO COATING AT PLACES OF FLANGING AND COATING.
7. MISALIGNMENT OF SURFACES B AND 8 SHOULD NOT EXCEED 0.2mm (MMC).
8. ASSEMBLY UNIT IS TO BE SUBJECTED TO ANTI CORROSIVE TREATMENT.
9. ϕ DIMENSION FOR REFERENCE.

DRW	CHK	DES	APPD	DATE	SCALE	MATERIAL	USED ON
							CB 413-04-12 (2A) CB 413-00-15
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI						TITLE FIRST SLOT-TYPE ? FILTERING SECTION	
DIMENSIONS IN mm TOLERANCE ON DIMS UNLESS OTHERWISE STATED.						D S CAT NUMBER DRAWING NUMBER CB 413-04-106	
ALL THREADS CONFORM TO							
ISSUE	DATE	USED ON NUMBER ADDED.		NATURE OF AMENDMENTS			
2A	02.08.17						

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

EST. MASS 1445 Kg

TO BE STAMPED OR MARKED WHERE INDICATED THIS # LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED (MACHINED CORNERS TO HAVE R OUT-SIDE R. INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

SCALE 10:1

POINT: I

4°30'±1°