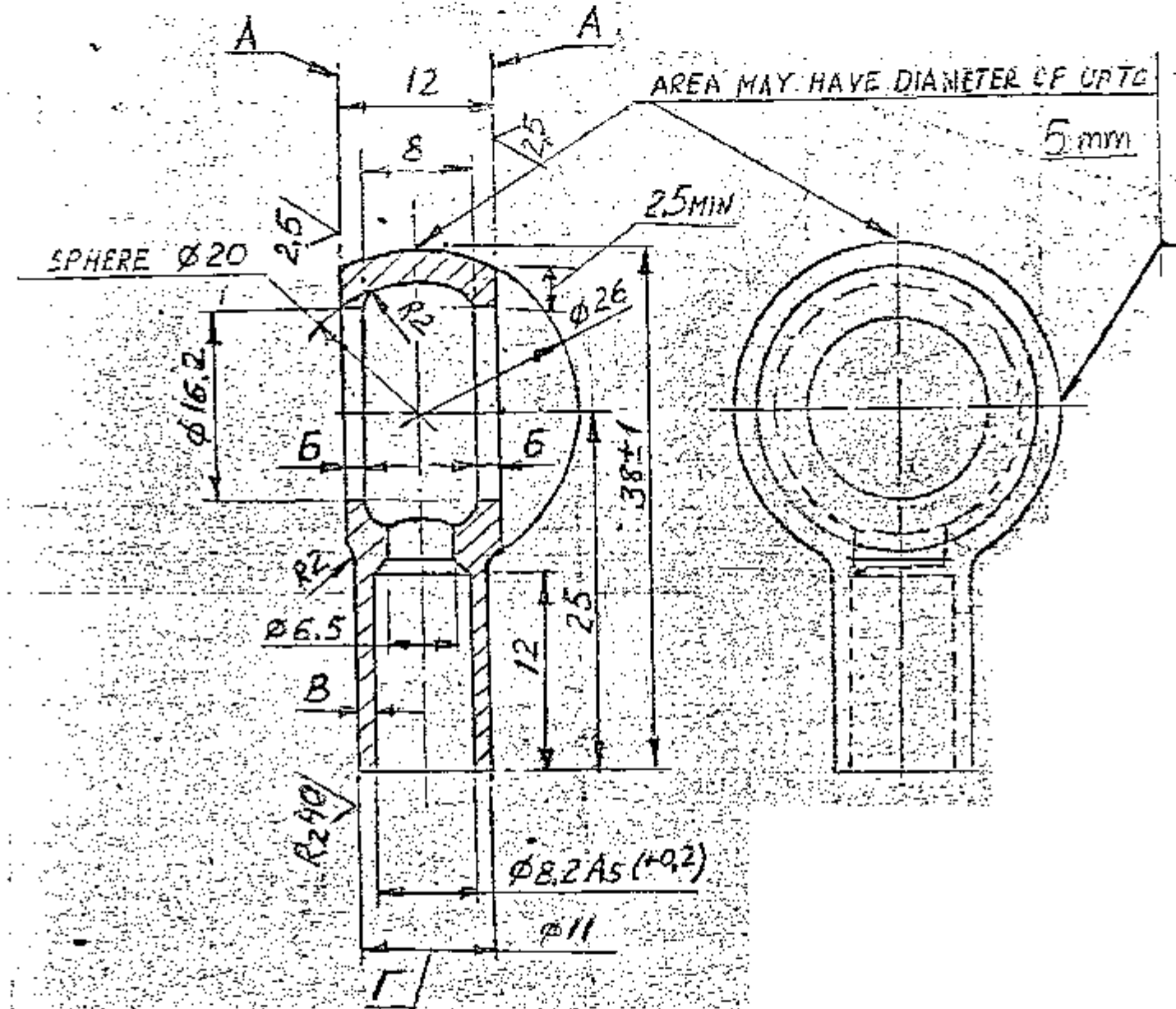


DRAWING NUMBER

322-17

R280 (✓)

ROUGH (✓) CYLINDRICAL SURFACE FROM BOTH SIDES
4mm max, IN WIDTH IS PERMITTED.



- ALTERNATE MATERIAL IS STEEL 30, 40 GOST 1050-74.
- UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS :
FOR HOLES - AS PER A7
FOR SHAFTS - AS PER B7
FOR OTHERS - AS PER CM7
- WALL THICKNESS DIFFERENCE B SHOULD NOT EXCEED 0.2mm.
- TOLERANCE ON PARALLELISM OF PLANES A SHOULD BE 0.05mm.
- TOTAL TOLERANCE ON ALIGNMENT AND INTERSECTION OF AXIS OF SURFACE I WITH RESPECT TO AXIS OF PLANES A SHOULD BE R 0.3mm OVER THE LENGTH OF CYLINDRICAL PORTION.
- THICKNESS OF WALL B MAY BE ATLEAST 1.5mm.
- USED FOR PARTS, DELIVERED AS SPARE-PARTS IS COATING: ZINC PLATED 6 MICRONS THICK, OILED, WITH REMOVAL OF HYDROGEN EMBRITTLEMENT.
- USED FOR TROPICAL VERSION IS COATING: CADMIUM-PLATED 9 MICRONS THICK, OILED, WITH REMOVAL OF HYDROGEN EMBRITTLEMENT.
- INTERNAL SURFACE MAY HAVE NO COATING.
- MARK AND STAMP FINAL ACCEPTANCE ON THE TAG (PART 540-551) FOR BATCH OF PARTS AND SEAL.

EXPLANATORY NOTE :-

- MATERIAL QUOTED : 35 GOST 1050-74.
Alt Matl Quoted : 30 & 40 GOST 1050-74.
30, 35 & 40 = GRADES OF STEEL.
a) CHEMICAL COMPOSITION :-

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C	Si	Mn	Cr	P	S	Cu	Ni
30	0.27 - 0.35	0.17- 0.37	0.50- 0.80	0.25	0.035	0.040	0.25	0.25
MAXIMUM								
35	0.32- 0.40	0.17- 0.37	0.50- 0.80	0.25	0.035	0.040	0.25	0.25
40	0.37- 0.45	0.17- 0.37	0.50- 0.80	0.25	0.035	0.040	0.25	0.25

- MECHANICAL PROPERTIES :-

GRADE OF STEEL	TENSILE STRENGTH Kgf/mm ² (min)	YIELD POINT Kgf/mm ² (min)	ELONGATION % (min)	REDUCTION IN AREA % (min)	IMPACT STRENGTH Kgf.m/cm ² (min)
30	50	30	21	50	8
35	54	32	20	45	7
40	58	34	19	45	6

KVD No: 60732

**
CS 322-01-4 TO CS 322-12-4
CS 322-07-4
CS 20-22-01-4
CS 20-22-03-4
CS 20-22-05-5

Ⓐ ALTERNATE MATERIAL: STEEL O80 M40(ENB)
TO BS: 970 PL 1-1983 OR 35 CS TO IS: 1570

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

EST. WT. 0.027 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

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

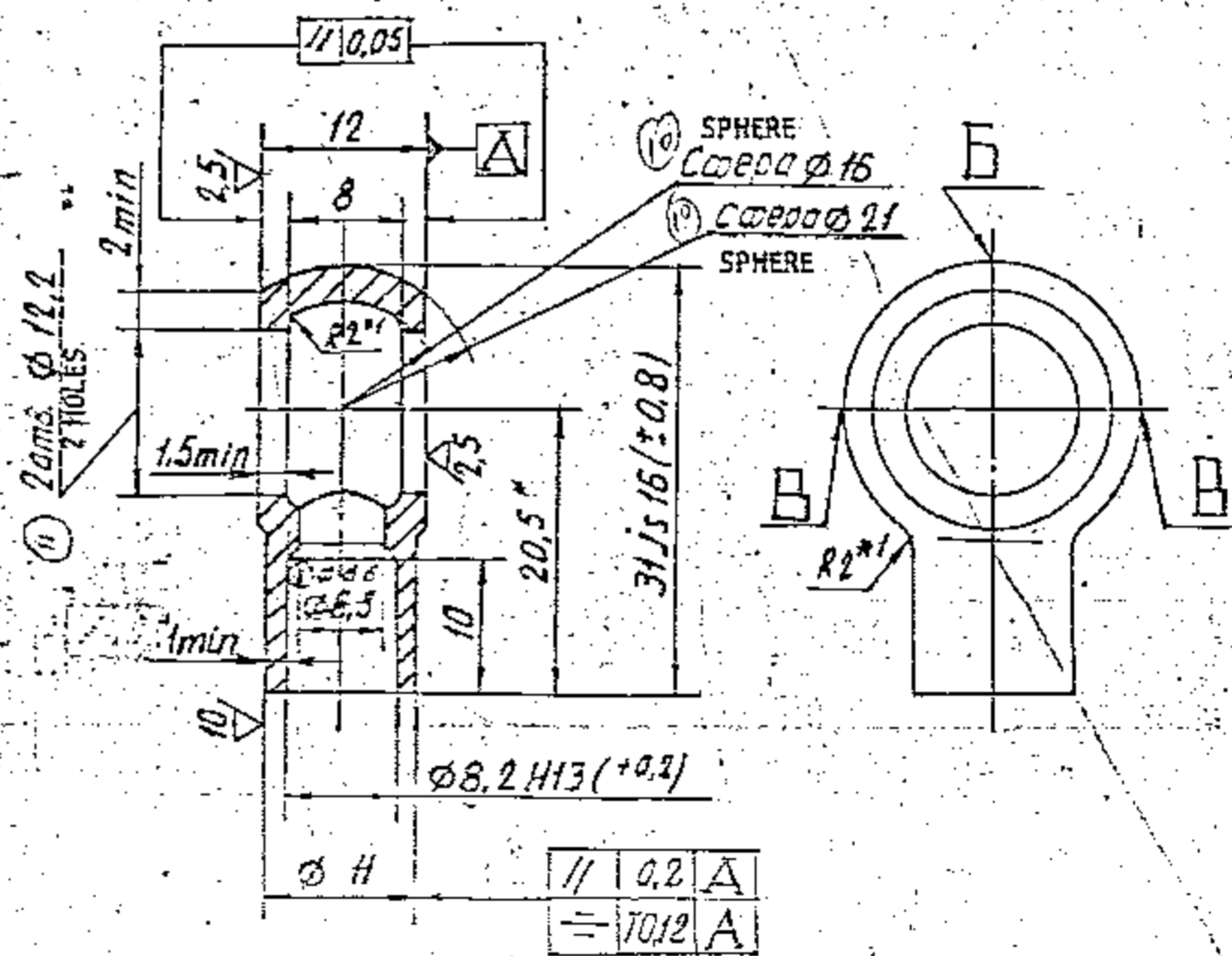
DRN	CHD	TCD	APPD	DATE	SCALE	DIMENSIONS IN mm.	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	MATERIAL :- 35 GOST 1050-74	USED ON :- ** SEE ABOVE
				22-12-89	2:1			CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A D I	
								TITLE SWIVEL - ELBOW	
								D S CAT NUMBER	DRAWING NUMBER 322-17
ISSUE	DATE	NATURE OF AMENDMENTS							

3rd ALTERATION COMM. MINUTES POINT 6. DATE 27-2-09



DRAWING NUMBER
322-18

20/ (✓)



1. Неуказанные предельные отклонения размеров отверстий по H14, валов по h7, остальных - ± IT14

2. На поверхностях B допускается чернота шириной 4 мм, не более.

3. В месте Б допускается площадь 0,5 мм, не более.

4. Покрытие Цб хр по ИЦД-154 с удалением водородной хрупкости для деталей аттравляемых в зап. части и для комплектования объектов по ИВ-40.

5. Покрытие КД9 хр по ИЦД-102 с удалением водородной хрупкости для деталей в тропическом исполнении. Допускается отсутствие покрытия на внутренних поверхностях.

6. Заменитель материала сталь марок 10, 20 ГОСТ 1050-74.

7. Клеимать на бирке для партии деталей с опломбированием окончательно прачемки.

8* Размеры для справок.

9* Размеры обеспечить инструментом

- 1) UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS OF HOLES AS PER H14, SHAFTS AS PER H7, OTHER DIMENSIONS - ± IT14
- 2) BLOCK SPOTS NOT EXCEEDING 4mm WIDE ARE ALLOWED ON SURFACES B
- 3) AREA 0,5mm MAXIMUM IS ALLOWED ON PLACE Б
- 4) COATING : Zn 6, CHROMATIZING AS PER ИЦД-154 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT FOR COMPONENT TO BE DISPATCHED AS SPARES AND FOR COMPONENTS MAKING A COMPLETE SET OF ARTICLES AS PER ИВ-40

- 5) COATING : КД9, CHROMATIZING AS PER ИЦД-102 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT FOR COMPONENTS HAVING TROPICALIZED CONSTRUCTION INTERNAL SURFACES MAY HAVE NO COATING
- 6) ALTERNATE MATERIAL : STEEL GRADES 10, 20 ГОСТ 1050-74
- 7) FINAL ACCEPTANCE STAMP SHOULD BE MARKED ON A TAG FOR A BATCH OF COMPONENT AND SHOULD BE SEALED
- 8) * DIMENSION FOR REFERENCE
- 9) *1 DIMENSIONS TO BE ENSURED WITH TOOL

ⓑ ALTERNATE MATERIAL: STEEL 080 M40 (EN8) TO BS:970 PL-1-1983 OR 05 C4 TO IS:1570

CB 322-01-4	CB 322-07-4
CB 322-02-4	CB 322-08-4
CB 322-03-4	CB 322-09-4 CB 20-35-12
CB 322-05-4	CB 322-10-4 CB 3335-00-30CB
CB 322-06-4	CB 322-11-4 CB 322-12-4

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

EST. WT. 0,018 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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

WORK	DATE	MATERIAL	USED ON
DATE	DATE	STEEL 35, GOST 1050-74	SEE ABOVE **
DATE	DATE	CONTROLLER OF QUALITY ASSURANCE (HEAVY VENTLES)	
DATE	DATE	A V A D I	
DATE	DATE	SCALE - 2:1	
DATE	DATE	DIMENSIONS IN mm	
DATE	DATE	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69	
DATE	DATE	3rd ALTERATION COMM. MINUTES	
DATE	DATE	POINT 6, DATE 27-2-09	
DATE	DATE	AUTHY NOTN. No. BK 86-41	
DATE	DATE	NATURE OF AMENDMENTS	
DATE	DATE	ALL THREADS TO CONFORM TO	
DATE	DATE	S CAT NUMBER	
DATE	DATE	DRAWING NUMBER	
DATE	DATE	322-18	

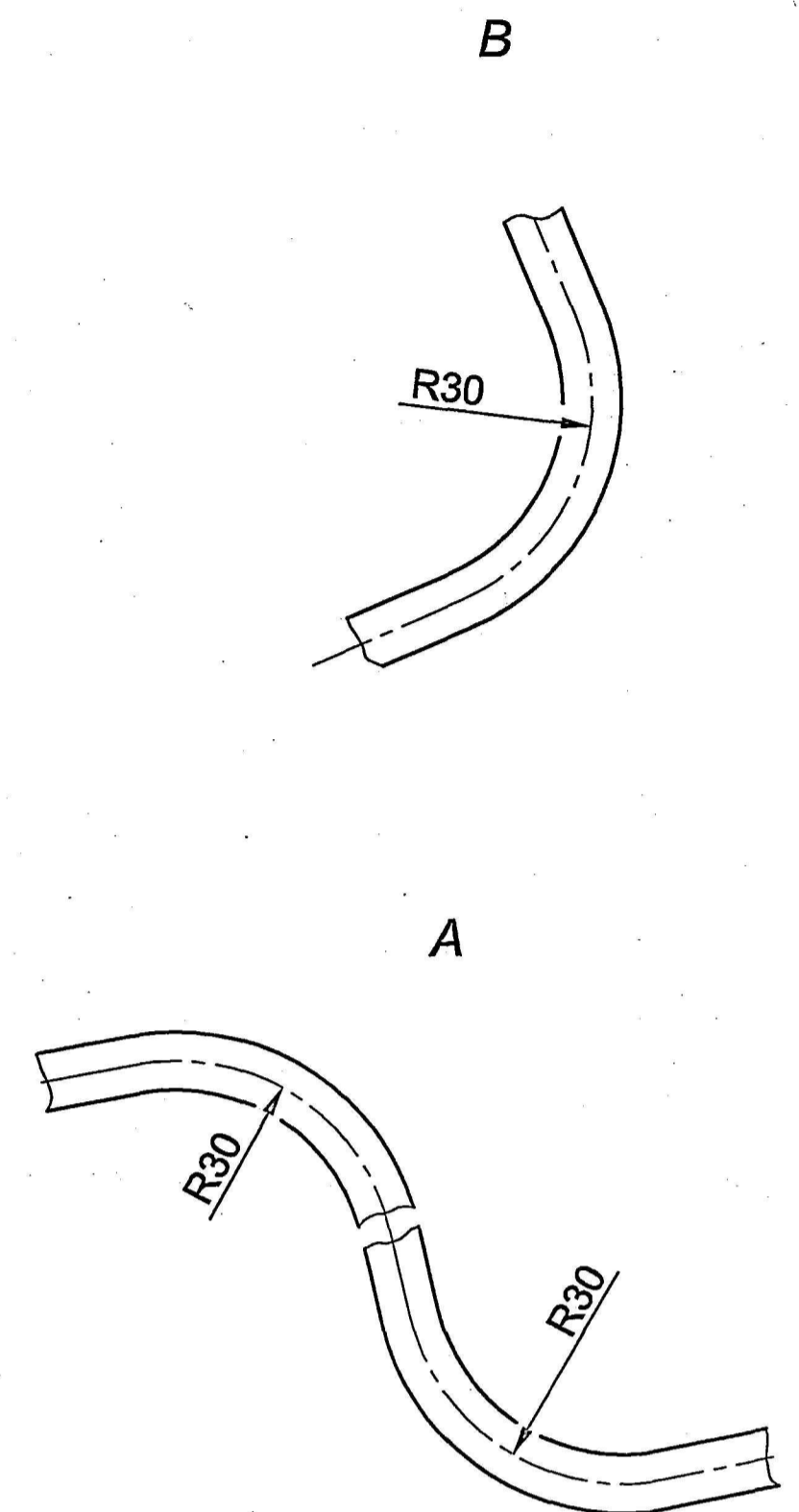
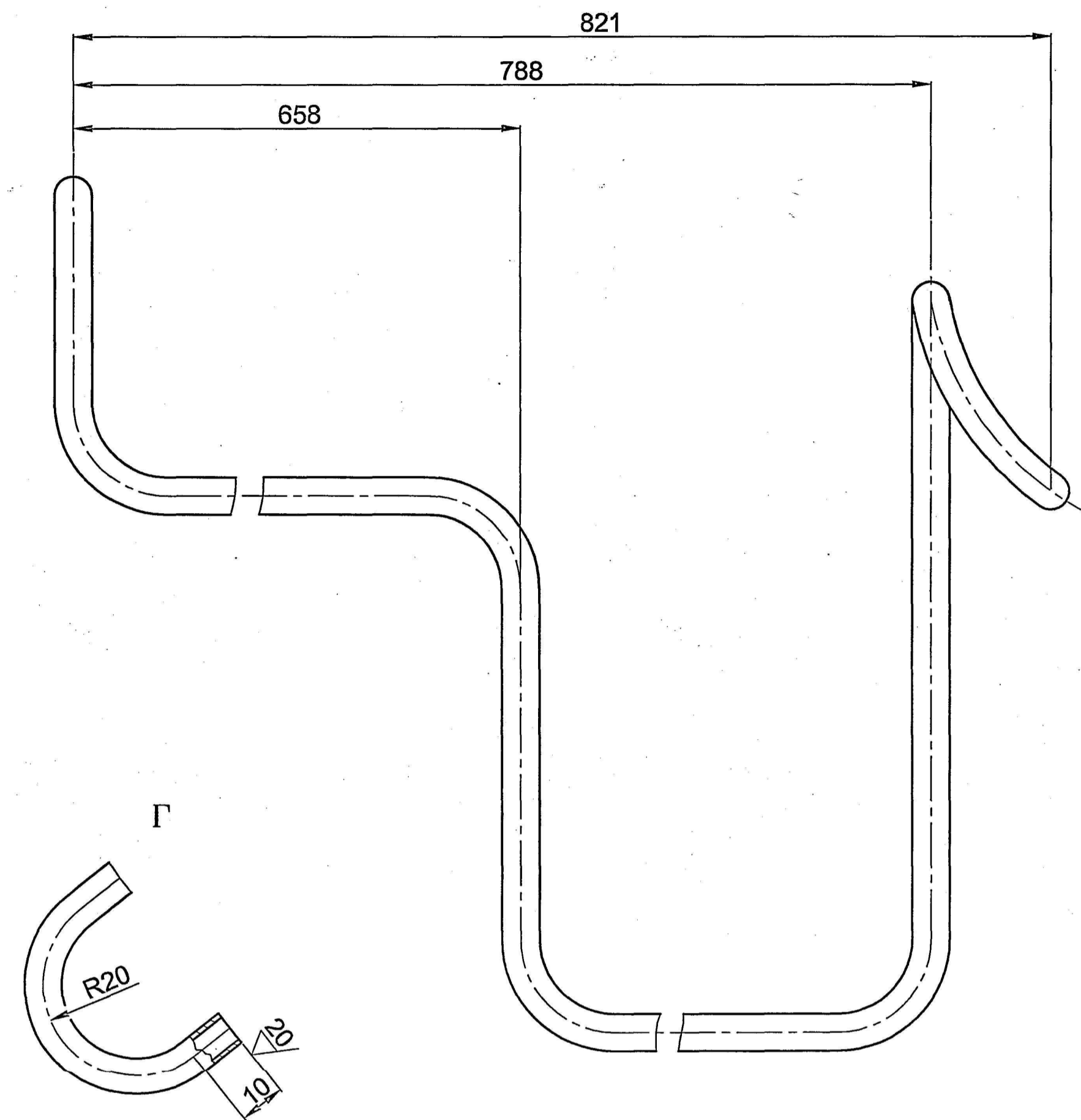
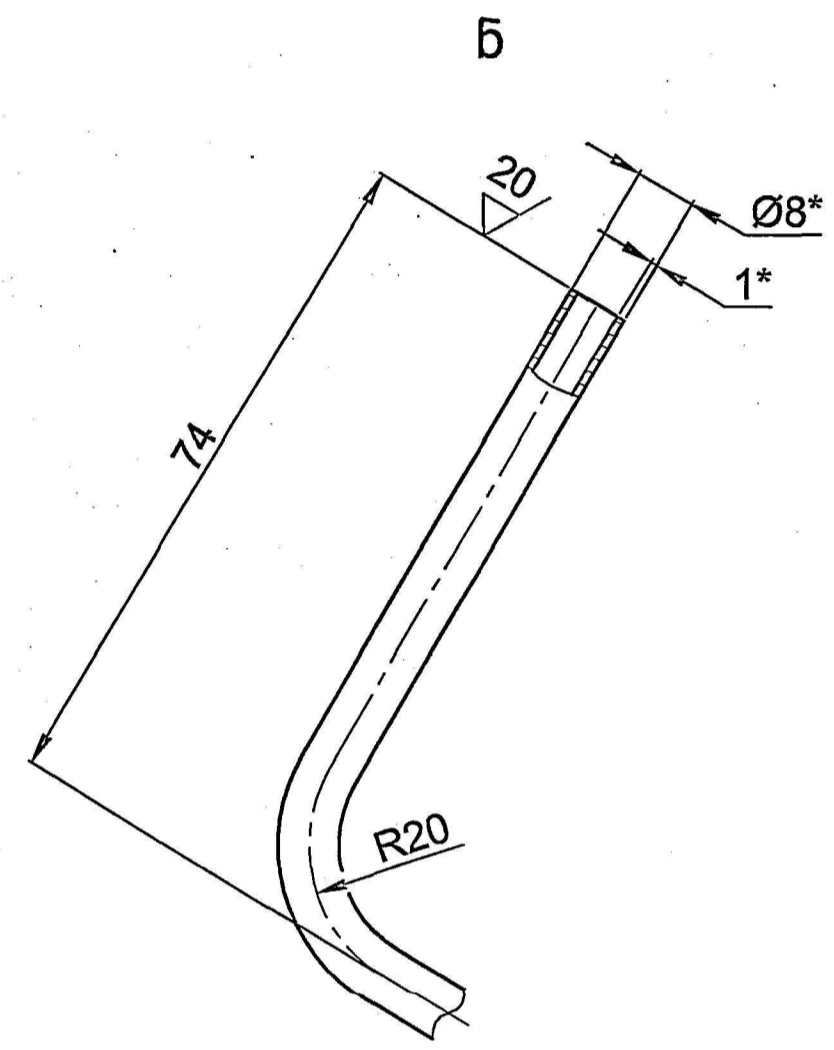
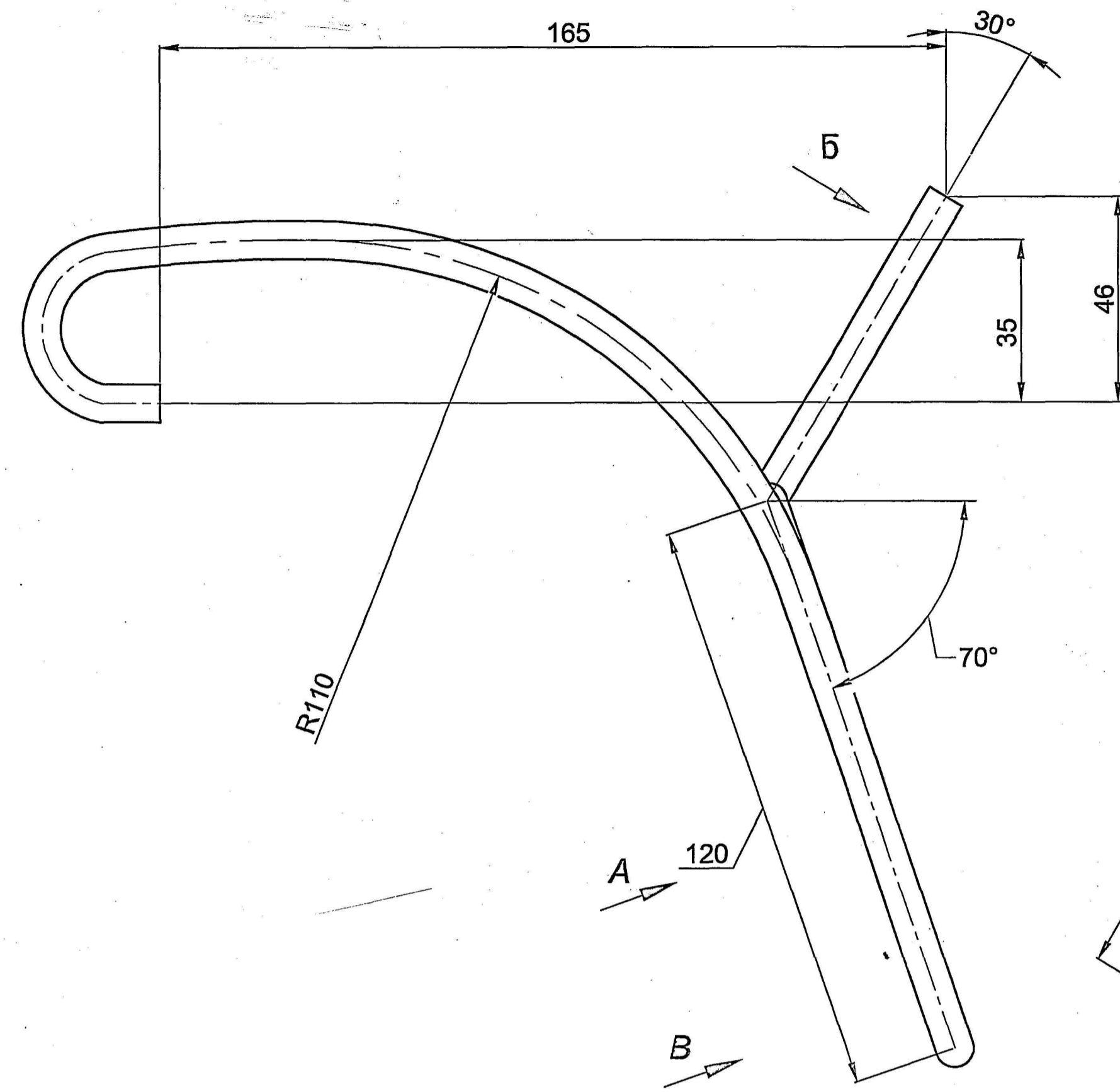
8	AK 83-267	AK 83-267	AK 83-267
7	AK 83-267	AK 83-267	AK 83-267

DRG. INDIVANISED BASED ON RUSSIAN ORIGINAL ISSUE NO. 0 (BK 03-265)



DRAWING NUMBER
322-23-9

✓(✓)



1. Unfolded length of pipe should be $L \approx 1283 \text{ mm}$.
2. Tolerance of ovality for pipe in bending areas should be 0.8mm (semi difference of diameters).
3. Bending-tool marks are allowed.
4. * Dimensions are given for reference.

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

EST. WT. (Kg) TO BE STAMPED OR MARKED WHERE INDICATED THUS # (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.

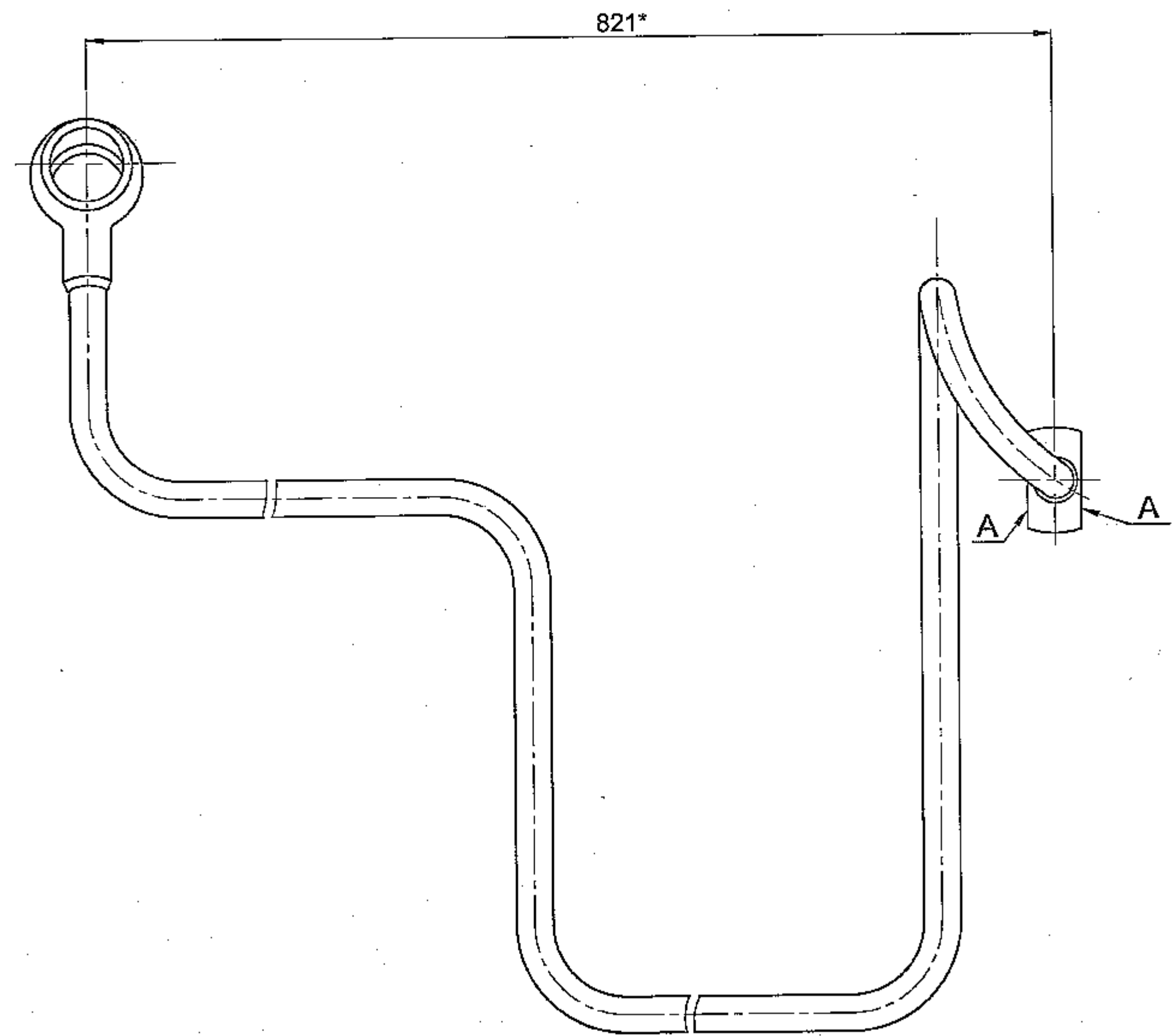
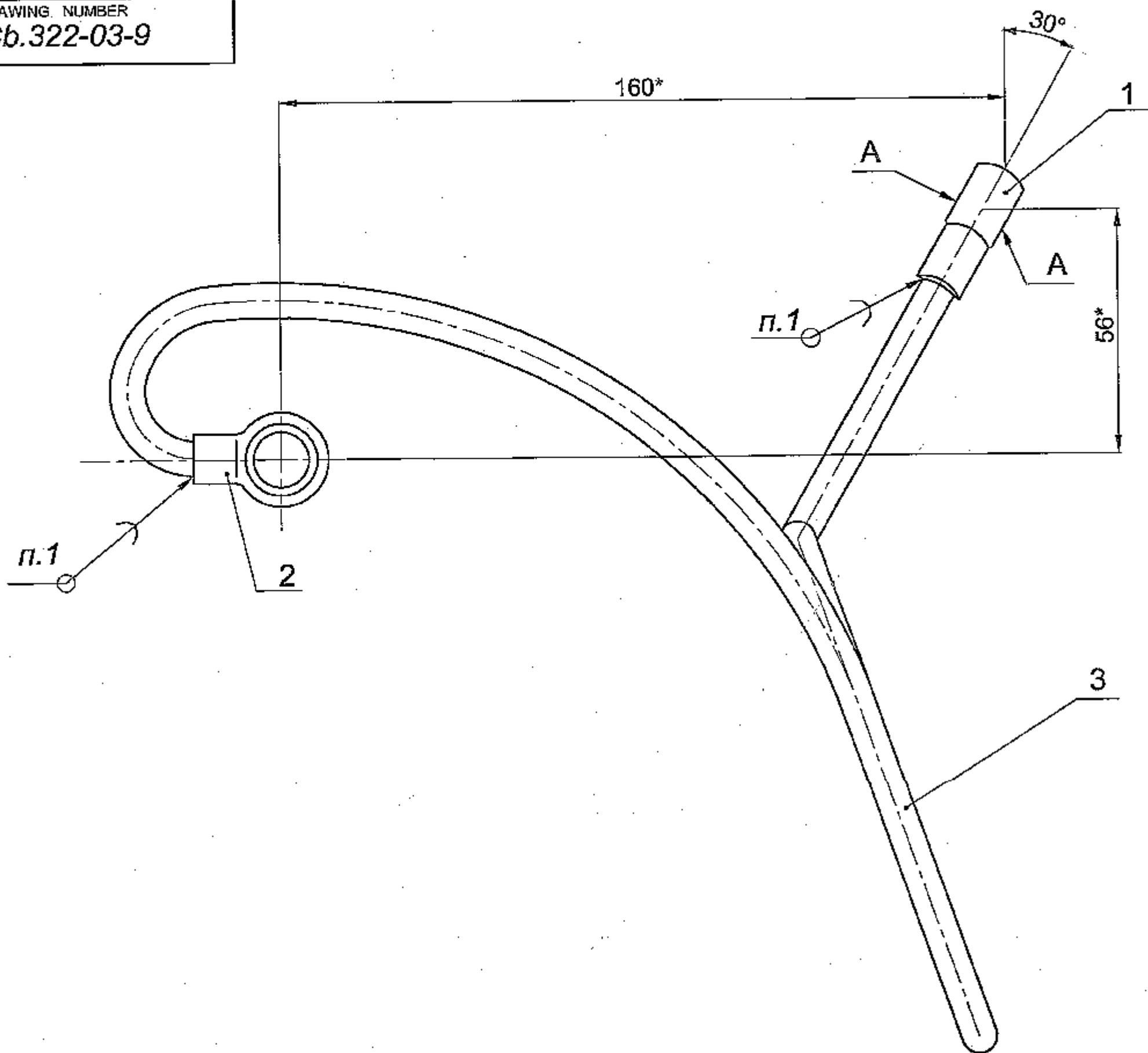
DRN	CHD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69	ALL THREADS TO CONFORM TO	MATERIAL :- PIPE 8x1-20A TY 14-3-480-76	USED ON :- C5 322 - 03 - 9	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	TITLE :- 3rd LH CYLINDER PIPE	D S CAT NUMBER	DRAWING NUMBER 322-23-9
ISSUE	DATE	NATURE OF AMENDMENTS											

DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 1

F-4
177
253

SIZE A1

DRAWING NUMBER
Cb.322-03-9



1. Wire Л63 Gost 12920-67.
2. Varnish coating ГФ - 95 as per ИЛ-628-86.
3. On surface "A" sag and overflow of varnish are not allowed, but dressing them with subsequent coating with enamel ИЛ-5123-Red-Sinamen Gost 7462-73 is permitted.
4. Check the pipe as per dummy in the assembly unit sb.322-14-9.
5. Before coating carryout the test for air tightness with air in water under pressure $(0.4 \pm 0.1) \text{ MPa}$ ($(4 \pm 1) \text{ Kgf/cm}^2$). Air - leakage is not allowed.
6. After coating carry out the test for airtightness with diesel fuel under pressure $(9.5 \pm 0.5) \text{ MPa}$ ($(95 \pm 5) \text{ Kgf/cm}^2$) for a period of minimum 2 minutes. Leakage of fuel is not permitted. Check selectively minimum 10 % of pipes.
7. * Dimensions are given for reference.

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

EST. WT.(Kg) 0.250	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
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ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	APPD.	MATERIAL :-	USED ON :- CB 322 -14 -9
CHD	DATE 03-03-07	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	TITLE :- 3 rd LEFT HAND CYLINDER TUBE ASSY
APPD.	SCALE: 1:1		
DIMENSIONS IN mm.		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69	D S CAT NUMBER
4A 13.08.08 D.O.CORRECTION			
ISSUE	DATE	NATURE OF AMENDMENTS	DRAWING NUMBER CB 322-03-9

DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 4

F-4
150
253
SIZE A2



