

GUN & SHELL FACTORY COSSIPORE KOLKATA-700 002



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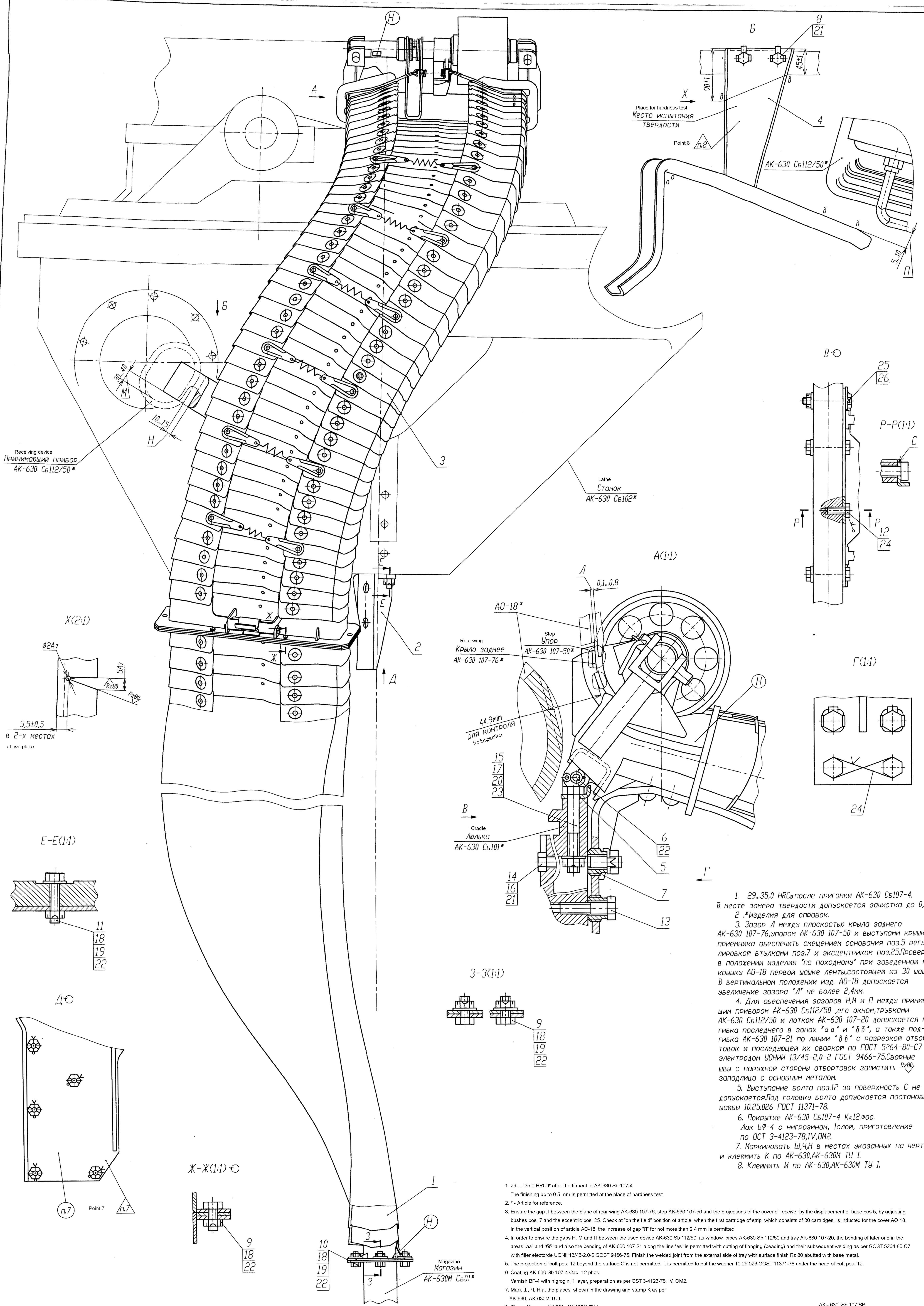
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FEED UNIT



First use	Format	Zone	Pos.	Designation		Nomenclature		Qty.	Remarks		
							<u>Documents</u>				
	A0			AK-630 Sb 107 SB		Assembly drawing					
Reference No.						<u>Assembly units</u>					
	A4		1	AK-630 Sb107-1		Lower hose		1			
	A4		2	AK-630 Sb107-2		Bracket		1			
	A4		3	AK-630 Sb107-3		Upper hose		1			
	A4		4	AK-630 Sb107-4		Bracket		1			
	A4		5	AK-630 Sb107-5		Base plate		1			
							<u>Components</u>				
		A4		6	AK-630 107-128		Pin		1		
	Sign and Date	A4		7	AK-630 107-1		Bush		4		
A3			25	AK-630 107-98		Eccentric		1			
						<u>Standard articles</u>					
Dupl. Inv. No.			8			Bolt M10-8gx25.109.40Kh.029		2			
						GOST 7798-70					
			9			Bolt 2M8-8gx20.109.40Kh.029		6			
Alternate Inv. No.						GOST 7798-70					
			10			Bolt 2M8-8gx25.109.40Kh.029		5			
						GOST 7798-70					
Sign and Date						AK-630 Sb 107					
	Amend.	Sheet	Doc. No.	Sign	Date						
Orig. Inv. No.	Developed by					Feed Unit		Type	Sheet	Sheets	
	Checked by							A	1	3	
	Head of Q.C.D										
	Approved by										



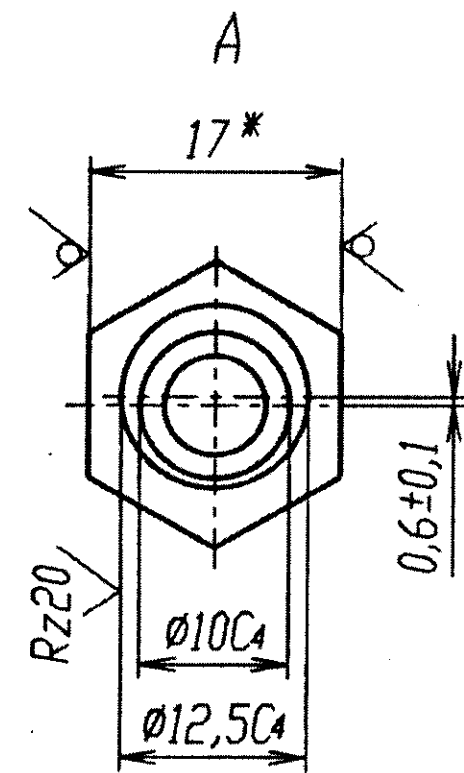
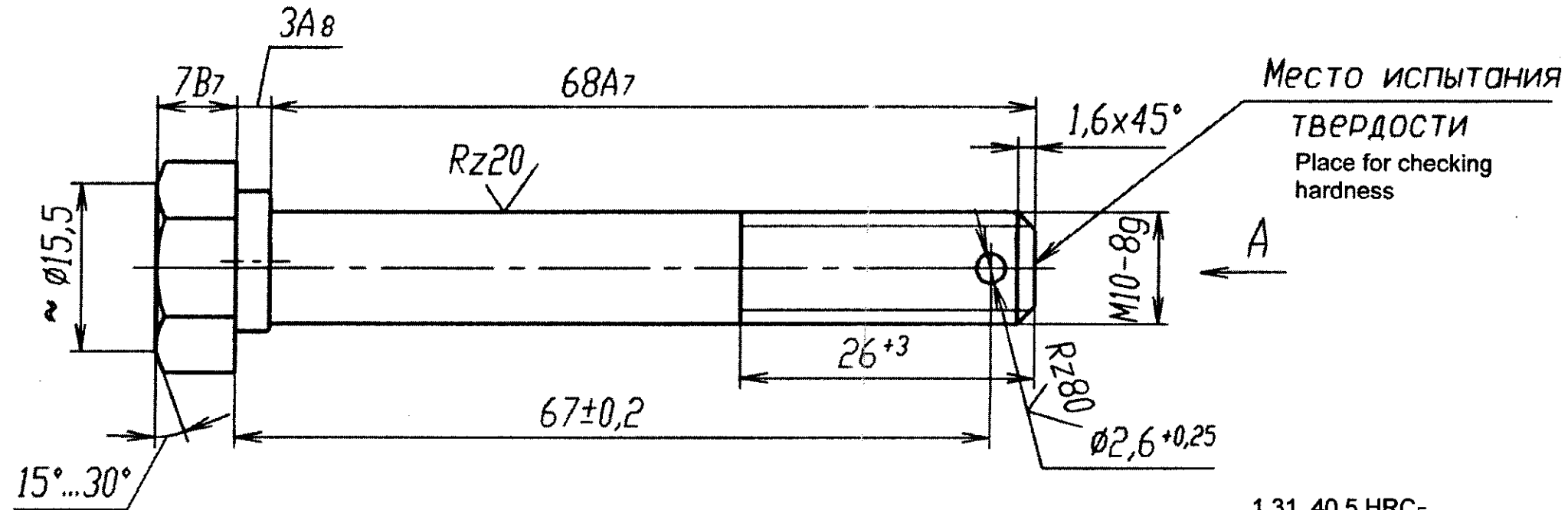
- 29...35,0 HRC после пригонки АК-630 Сб107-4. В месте замера твердости допускается зачистка до 0,5мм.
- * Изделия для справок.
- Зазор L между плоскостью крыла заднего АК-630 107-76, упором АК-630 107-50 и выступами крышки приемника обеспечить смещением основания поз.5 регулировочными втулками поз.7 и эксцентриком поз.25. Проверять в положении изделия "по походному" при заводной под крышку А0-18 первой шайке ленты, состоящей из 30 шайек. В вертикальном положении изд. А0-18 допускается увеличение зазора "L" не более 2,4мм.
- Для обеспечения зазоров H, M и П между принимающим прибором АК-630 Сб112/50, его окном, трубками АК-630 Сб112/50 и лотком АК-630 107-20 допускается подгибка последнего в зонах "а а" и "б б", а также подгибка АК-630 107-21 по линии "в в" с разрезкой отбортовки и последующей их сваркой по ГОСТ 5264-80-С7 электродом УОНИИ 13/45-2,0-2 ГОСТ 9466-75. Сварные швы с наружной стороны отбортовки зачистить R_{z80} заподлицо с основным металлом.
- Выступление болта поз.12 за поверхность С не допускается. Под головку болта допускается постановка шайбы 10.25.026 ГОСТ 11371-78.
- Покрытие АК-630 Сб107-4 $Ka12$ фос. Лак БФ-4 с нигрозином, 1 слой, приготовление по ОСТ 3-4123-78, IV, OM2.
- Маркировать Ш, Ч, Н в местах указанных на чертеже и клеить К по АК-630, АК-630М ТУ I.
- Клеить И по АК-630, АК-630М ТУ I.

- 29...35,0 HRC after the fitment of AK-630 Sb 107-4. The finishing up to 0.5 mm is permitted at the place of hardness test.
- * Article for reference.
- Ensure the gap L between the plane of rear wing AK-630 107-76, stop AK-630 107-50 and the projections of the cover of receiver by the displacement of base pos.5, by adjusting bushes pos.7 and the eccentric pos.25. Check at "on the field" position of article, when the first cartridge of strip, which consists of 30 cartridges, is inducted for the cover А0-18. In the vertical position of article А0-18, the increase of gap "L" for not more than 2.4 mm is permitted.
- In order to ensure the gaps H, M and П between the used device AK-630 Sb 112/50, its window, pipes AK-630 Sb 112/50 and tray AK-630 107-20, the bending of later one in the areas "aa" and "bb" and also the bending of AK-630 107-21 along the line "vv" is permitted with cutting of flanging (beading) and their subsequent welding as per GOST 5264-80-C7 with filler electrode УОНИИ 13/45-2.0-2 GOST 9466-75. Finish the welded joint from the external side of tray with surface finish $Rz 80$ abraded with base metal.
- The projection of bolt pos. 12 beyond the surface C is not permitted. It is permitted to put the washer 10.25.026 GOST 11371-78 under the head of bolt pos. 12.
- Coating AK-630 Sb 107-4 Cad. 12 phos. Varnish BF-4 with nigrogin, 1 layer, preparation as per OST 3-4123-78, IV, OM2.
- Mark Ш, Ч, Н at the places, shown in the drawing and stamp K as per AK-630, AK-630M TU I.
- Stamp И as per AK-630, AK-630M TU I.

AK-630 Sb 107 SB				AK-630 Сб107СБ		
Лист	№ докум.	Лист	Дата	Тип	Масса	Шкала
1		1		Узел питания	35,945	1:2
Сборочный чертеж				Лист	Архив 1	
Supply unit				Sheet	Total sheets	
Assembly drawing						

Лист 1 из 1
Сборочный чертеж
Лист 1 из 1
Сборочный чертеж

Rz40 (✓)

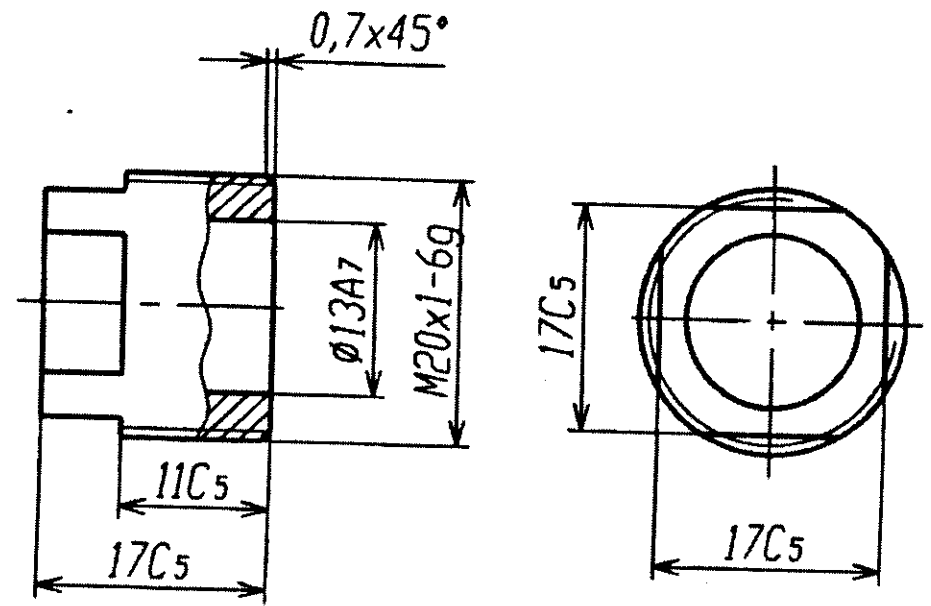


1. 31..40.5 HRC_E.
2. Position of eccentric and hole with respect to each other and sides of hexagon is arbitrary.
3. Coating Cd9. Cr. .It is permissible to avoid cadmium plating of holes.
- 4.* Reference dimension.
5. Mark Ш, Ч and stamp К, И on tag.

					AK-630 107-98			
Amend.	Sheet	Doc.No.	Sign	Date	Eccentric	Type	Weight	Scale
Developed by						A	0.055	2:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D						Hexagon	17 - 5 GOST 8560 - 78 40Kh - T - V GOST 1051 - 73	
Approved by								

AK-630 107-1

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

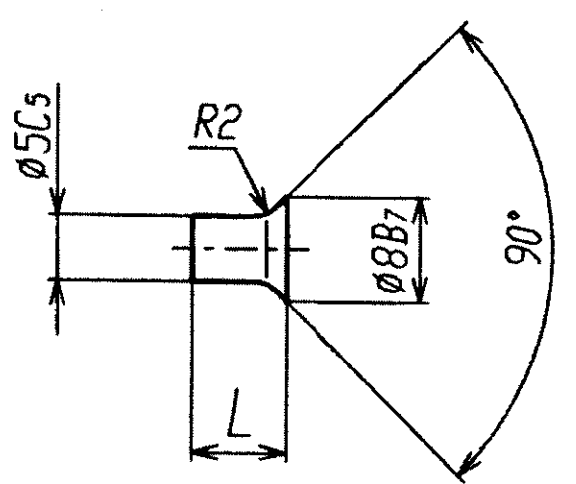


1. 38...44.5 HRC_E. Check hardness on 3..5% from the batch but not less than 3 nos.
2. Inner angles R~0.4 mm.
3. Blunt sharp edges R~0.6 mm.
4. Coating Cd6.Cr.
5. Mark Ш, Ч and stamp K, И on tag.

Amend.	Sheet	Doc. No.	Sign	Date

AK-630 107-1			
Bush	Type	Weight	Scale
	A	0.025	2:1
	Sheet	Sheets 1	
Steel 50 GOST 1050-88			

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
					<u>Documents</u>			
	A2			AK-630 Sb 107-1 SB	Assembly drawing			
Reference No.					<u>Assembly units</u>			
	A4		1	AK-630 Sb107-7	Lower hose	1		
	A4		2	AK-630 Sb107-8	Magazine frame	1		
	A4		3	AK-630 Sb107-9	Upper frame	1		
					<u>Components</u>			
	A4		4	AK-630 107-2-01	Rivet	1		
	A4		5	AK-630 107-3	Washer	1		
	A4		6	AK-630 107-4	Washer	1		
	Sign and Date							
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date						AK-630 Sb 107-1		
	Amend.	Sheet	Doc. No.	Sign	Date			
Orig. Inv. No.	Developed by					Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D							
	Approved by							
Lower hose								

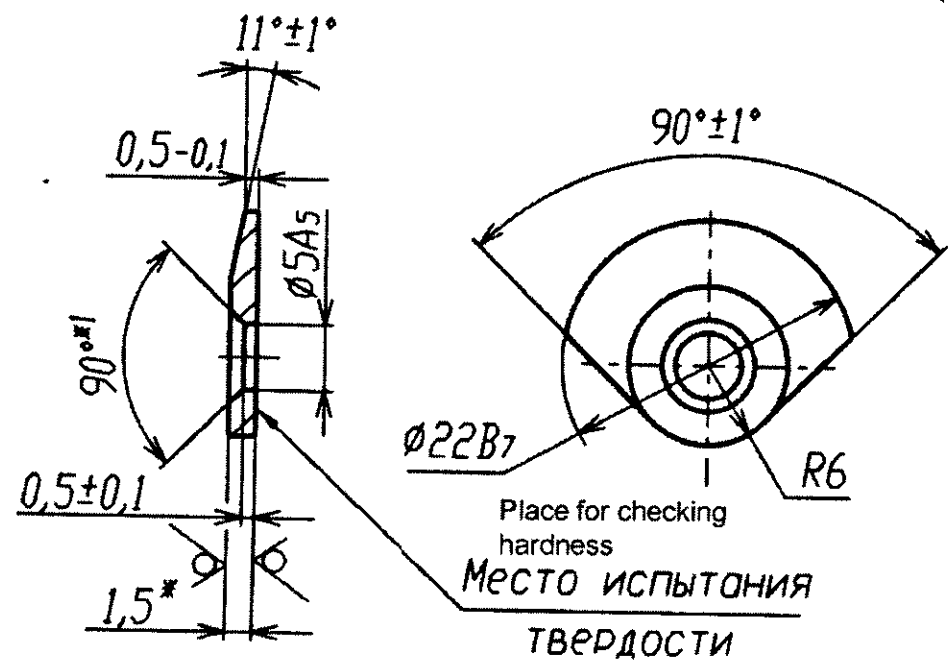
AK-630 107-2																																																		
Approved by shop	Reference No.																																																	
Approved KTONI	Sign and Date																																																	
Approved TOsb	Alternate Inv. No.	Dupl. Inv. No.	<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th>Designation</th> <th>L, mm</th> <th>Weight, kg</th> </tr> </thead> <tbody> <tr> <td>AK-630 107-2</td> <td>5.7 C₅ (-0.16)</td> <td>0.001</td> </tr> <tr> <td>-01</td> <td>7 C₅ (-0.2)</td> <td>0.001</td> </tr> <tr> <td>-02</td> <td>12 C₅</td> <td>0.002</td> </tr> <tr> <td>-03</td> <td>16 C₅</td> <td>0.003</td> </tr> </tbody> </table> <p>1. Substitute material –Steel 12Cr18Ni10Ti GOST 5632-72. 2. Blunt sharp edges R~0.2 mm. 3. Mark Ш, Ч and stamp K on tag. 4. Other technical requirements as per GOST 10304-80.</p>			Designation	L, mm	Weight, kg	AK-630 107-2	5.7 C ₅ (-0.16)	0.001	-01	7 C ₅ (-0.2)	0.001	-02	12 C ₅	0.002	-03	16 C ₅	0.003																														
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Approved OGMet	Sign and Date	Sign and Date	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td colspan="5" style="text-align: center;">AK-630 107-2</td> </tr> <tr> <td style="width: 15%;"></td> <td style="width: 15%;"></td> <td style="width: 15%;"></td> <td style="width: 15%;"></td> <td style="width: 15%;"></td> </tr> <tr> <td style="text-align: center;">Amend.</td> <td style="text-align: center;">Sheet</td> <td style="text-align: center;">Doc. No.</td> <td style="text-align: center;">Sign</td> <td style="text-align: center;">Date</td> </tr> <tr> <td colspan="5" style="text-align: center;">Developed by</td> </tr> <tr> <td colspan="5" style="text-align: center;">Checked by</td> </tr> <tr> <td colspan="5" style="text-align: center;">Head of Q.C.D</td> </tr> <tr> <td colspan="5" style="text-align: center;">Design bureau chief</td> </tr> <tr> <td colspan="5" style="text-align: center;">Head of Q.C.D</td> </tr> <tr> <td colspan="5" style="text-align: center;">Approved by</td> </tr> </table>			AK-630 107-2										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				
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Orig. Inv. No.	First use		<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 20%;"></td> <td style="width: 20%;"></td> <td style="width: 20%;"></td> <td style="width: 20%;"></td> <td style="width: 20%;"></td> </tr> <tr> <td style="text-align: center;">Rivet</td> <td style="text-align: center;">Type</td> <td style="text-align: center;">Weight</td> <td colspan="2" style="text-align: center;">Scale</td> </tr> <tr> <td></td> <td style="text-align: center;">A</td> <td></td> <td colspan="2" style="text-align: center;">2:1</td> </tr> <tr> <td colspan="2" style="text-align: center;">Sheet</td> <td colspan="3" style="text-align: center;">Sheets 1</td> </tr> <tr> <td colspan="5" style="text-align: center;">Steel 12Cr18Ni9Ti GOST 5632-72</td> </tr> </table>								Rivet	Type	Weight	Scale			A		2:1		Sheet		Sheets 1			Steel 12Cr18Ni9Ti GOST 5632-72																								
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Steel 12Cr18Ni9Ti GOST 5632-72																																																		

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Format A4

AK-630 107-4

Approved OGMet
 Orig. Inv. No.
 Head of Q.C.D.
 Design bureau chief
 Checked by
 Developed by
 Amend. Sheet Doc. No. Sign Date
 Sign and Date
 Alternate Inv. No. Dupl. Inv. No.
 Approved TOsb
 Sign and Date
 Approved KTONI
 Sign and Date
 Approved by shop
 Reference No.
 First use



Rz40 (✓)

1. 29...35.0 HRC_E . Check hardness on 3..5% of the batch but not less than 3 nos.
2. * Reference dimension.
3. *1Dimensions ensured by tool.
4. Blunt sharp edges R-0.2 mm.
5. Coating Cd12.Cr.
6. Mark Ш, Ч and stamp К, И on tag.

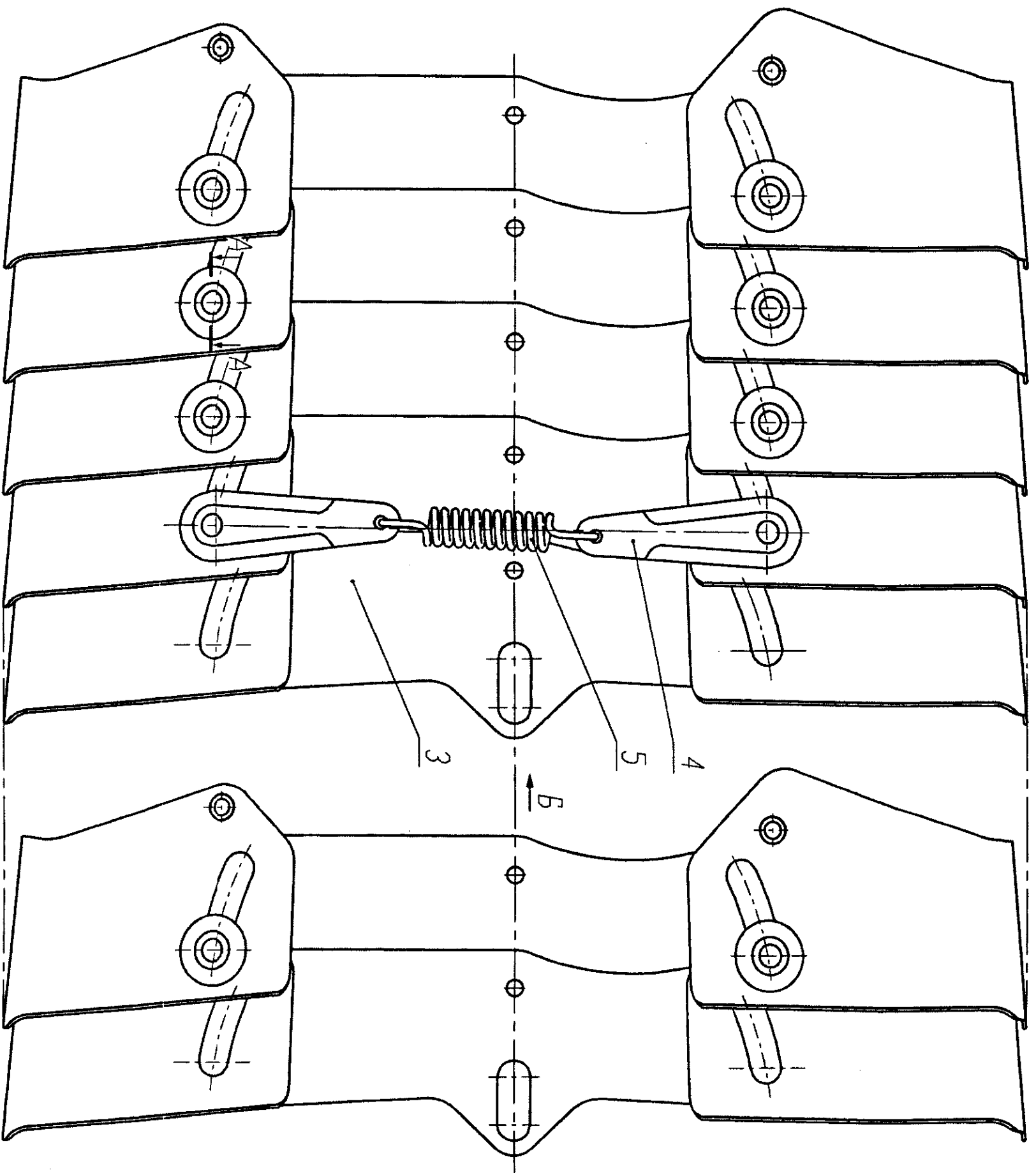
Amend.	Sheet	Doc. No.	Sign	Date

AK-630 107-4			
Type	Weight	Scale	
Washer	A	0.003	2:1
Sheet		Sheets 1	
Sheet <u>BT - PN - 01.5 GOST 19904 - 90</u>			
K 490V 4 - III - 40 GOST 16523 - 97			

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AK - 630 Sb 107 - 7 SB

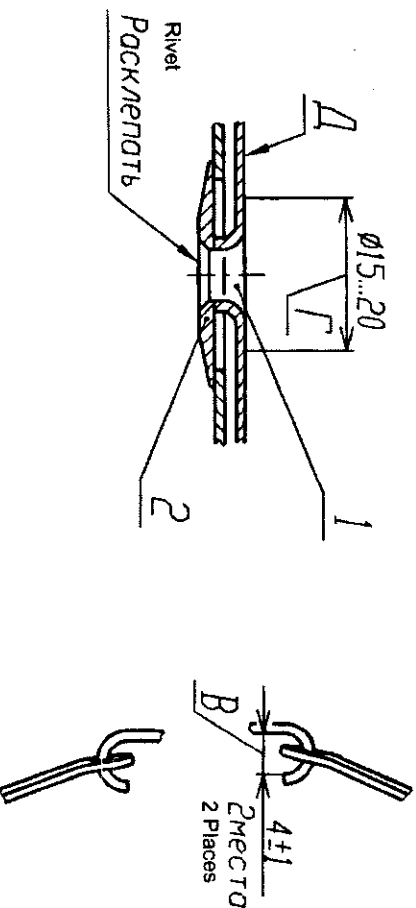
AK-630 СБ107-7СБ



Справ. N
Перв. примен.

A-A(2:1)
Для всех соединений
For all the joints

B
Для всех соединений
For all the joints



1. Собранный ружок должен легко без заедания укорачиваться и удлиняться, обеспечивать подвижность, верность и спиральность. Зоедния в отдельных звеньях не допускаются.
2. Внутренняя поверхность не должна иметь встречающихся выступов, препятствующих движению ленты.
3. Искривление шовов поз. 2 и плонков поз. 4 не допускается.
4. Плонки поз. 4 и пружины поз. 5 установить через каждые 4 рожки, закрепив первую как указано на чертеже. Концы пружин подогнуть обеспечив размер В.
5. Несовпадение заклепки поз. 1 с поверхн. Д не более 0,2 мм. Контролировать в зоне Г.
6. Маркировать Ш, Ч и клемить К но бирке по АК-630, АК-630М ТУ I.

Инв. N подл.	Подп. и дата	Взам. инв. N	Инв. N дубл.	Подп. и дата
--------------	--------------	--------------	--------------	--------------

1. The assembled hose should shorten (contract) and expand easily without jamming, ensure the radius, fan-shape and spiralness. Jamming in individual links is not permitted.
2. The internal surface should not have counter projections, which obstruct the movement of strip (tape).
3. Hogging of washers position 2 and plank position 4 is not permitted.
4. Set the planks position 4 and springs position 5 through every four frames, after having fastened the first one as shown in drawing. After ensuring the dimension B, bend the ends of springs.
5. Non-alignment of rivet position 1 with surface D is not more than 0.3 mm. Check in zone Г.
6. Mark Ш, Ч and stamp K on the tag as per AK-630, AK-630M TU I.

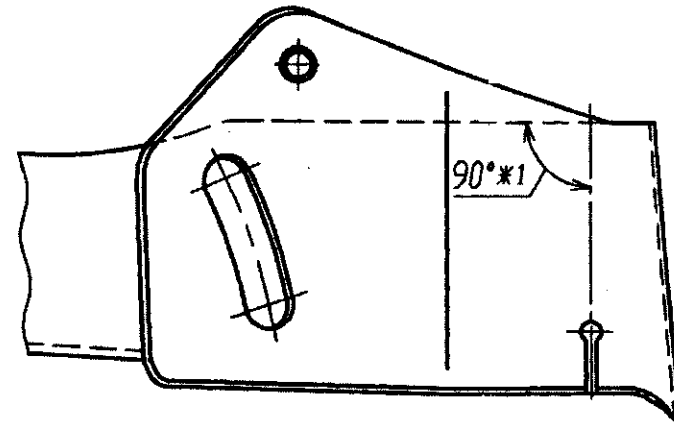
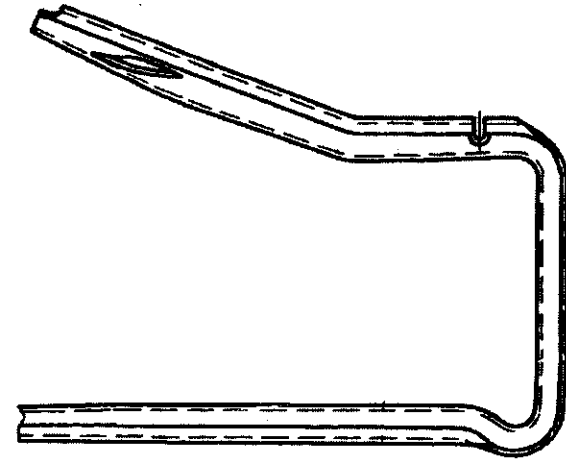
Изм./Лист	N дор./ж	Подп.	Дата
Разраб.			
Техн. отв.			
Начальн. упр.			
AK-630 СБ107-7СБ			
Lower Hose		Scale	
РУЖОК НИЖНИЙ		Лист	Листов
Сборочный чертеж		А	9,700 1:1
Assembly Drawing		Steel	Total Sheets 1

AK - 630 Sb 107 - 7 SB

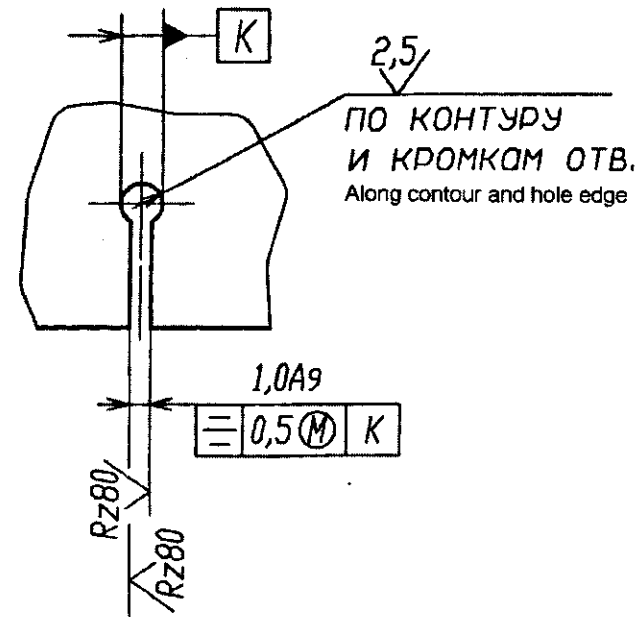
Вале 8 container 2

Формат А2

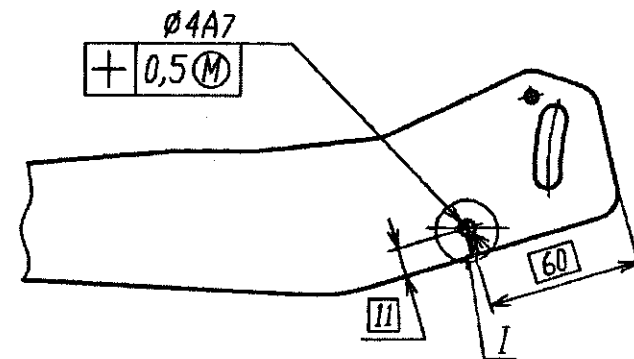
Рис. 2
 Drawing 2
 Остальное - см. Рис. 1 (лист 1)
 Remaining - refer drawing 1 (Sheet 1)



I(2:1)



Q₂ (1:2)



Inv. No.	Sign & Date	Alternate Inv. No.	Duplicate Inv. No.	Sign & Date	Reference No.	First	ks

Amend	Sheet	Doc. No.	Sign	Date

First use

Reference No.

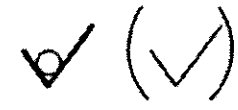
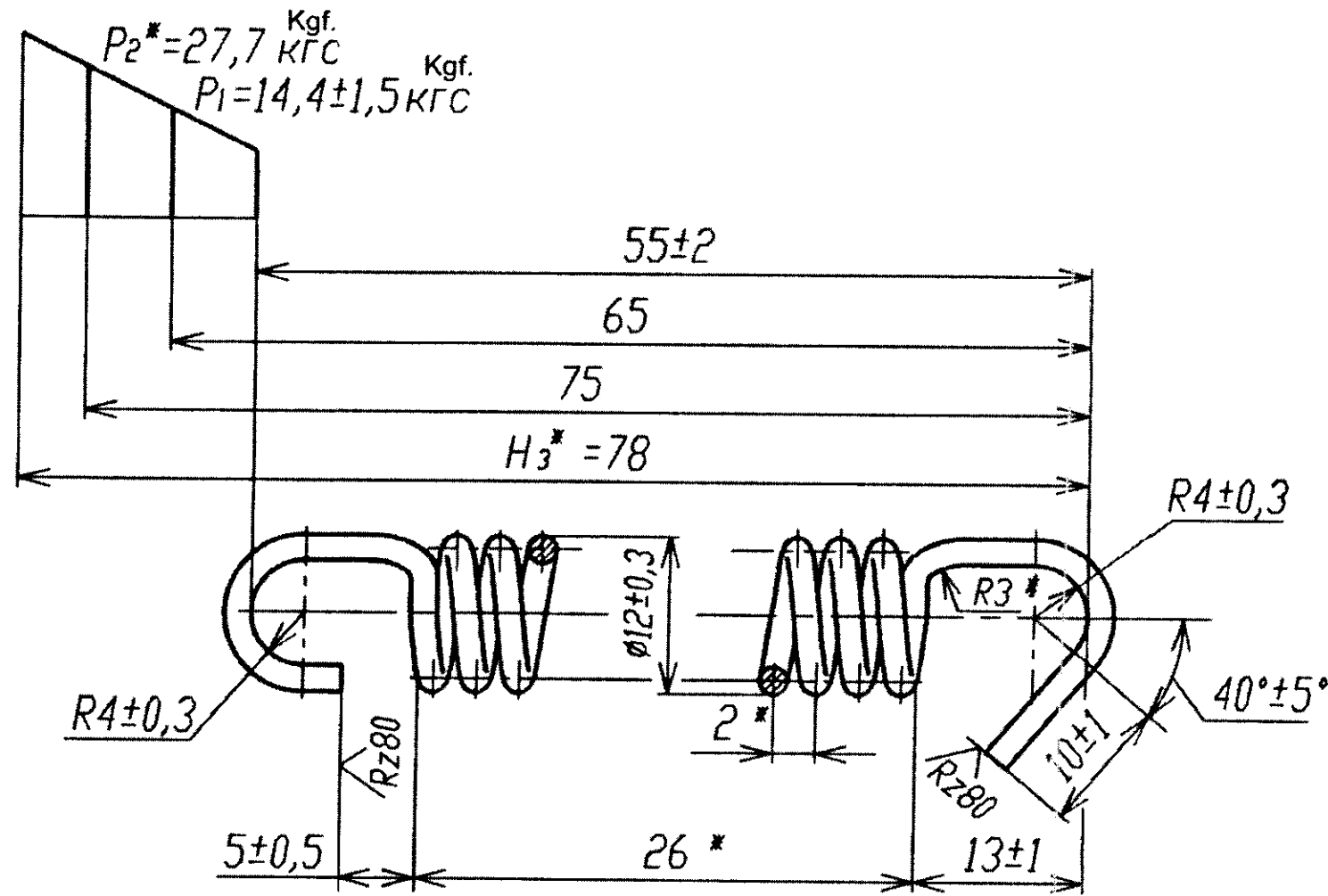
Sign and Date

Duplicate Inv. No

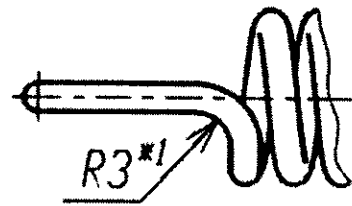
Alternate Inv. No

Sign and Date

Orig. inv. no.



1. $G^* = 80000\text{Pa}$ (8000 kgf/mm².)
2. $\tau^* = 1320\text{MPa}$ (132 kgf/mm².)
3. Heat treatment : Tempering 240°-260°.
4. Pre deformation time (at Nz) -24 hours.
5. $n = 12$
6. Coiling direction- right.
7. Length of uncoiled spring $L^* = 460\text{ mm}$.
8. Coating: Chem.Phos. accel.Cr./ impregnation
Lacquer BF-4 black ,made as per OST 3-4123-78, 2 coats IV, OM2.
- 9.* Reference dimensions.
- 10.*1 Dimensions ensured by tool.
11. Stamp K on batch tag.
14. Other technical requirements as per GOST 16188-70 for springs accuracy group II.



					AK-630 107-97			
Amend.	Sheet	Doc.No.	Sign	Date	Spring	Type	Weight	Scale
Developed by						A	0.012	2:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D						Wire V-1-2 GOST 9389-75		
Approved by								

AK-630 107-2

First use

Approved by shop
Reference No.

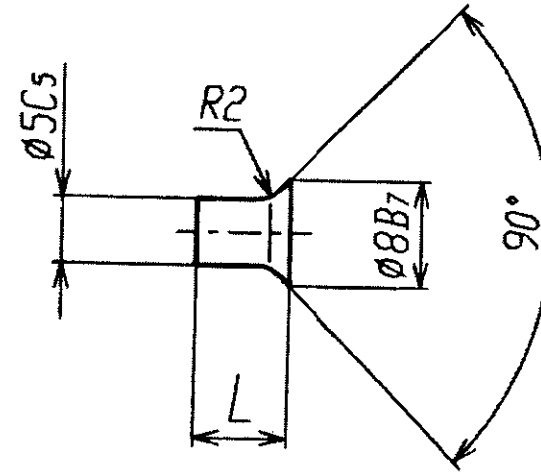
Approved KTONI
Sign and Date

Approved TOsb
Dupl. Inv. No.

Sign and Date

Approved OGMet
Orig. Inv. No.

Rz40 ✓



Designation	L, mm	Weight, kg
AK-630 107-2	5.7 C ₅ (-0.16)	0.001
-01	7 C ₅ (-0.2)	0.001
-02	12 C ₅	0.002
-03	16 C ₅	0.003

1. Substitute material –Steel 12Cr18Ni10Ti GOST 5632-72.
2. Blunt sharp edges R~0.2 mm.
3. Mark Ш, Ч and stamp K on tag.
4. Other technical requirements as per GOST 10304-80.

Amend.	Sheet	Doc. No.	Sign	Date

AK-630 107-2

Rivet

Steel 12Cr18Ni9Ti
GOST 5632-72

Type	Weight	Scale
A		2:1
Sheet	Sheets 1	

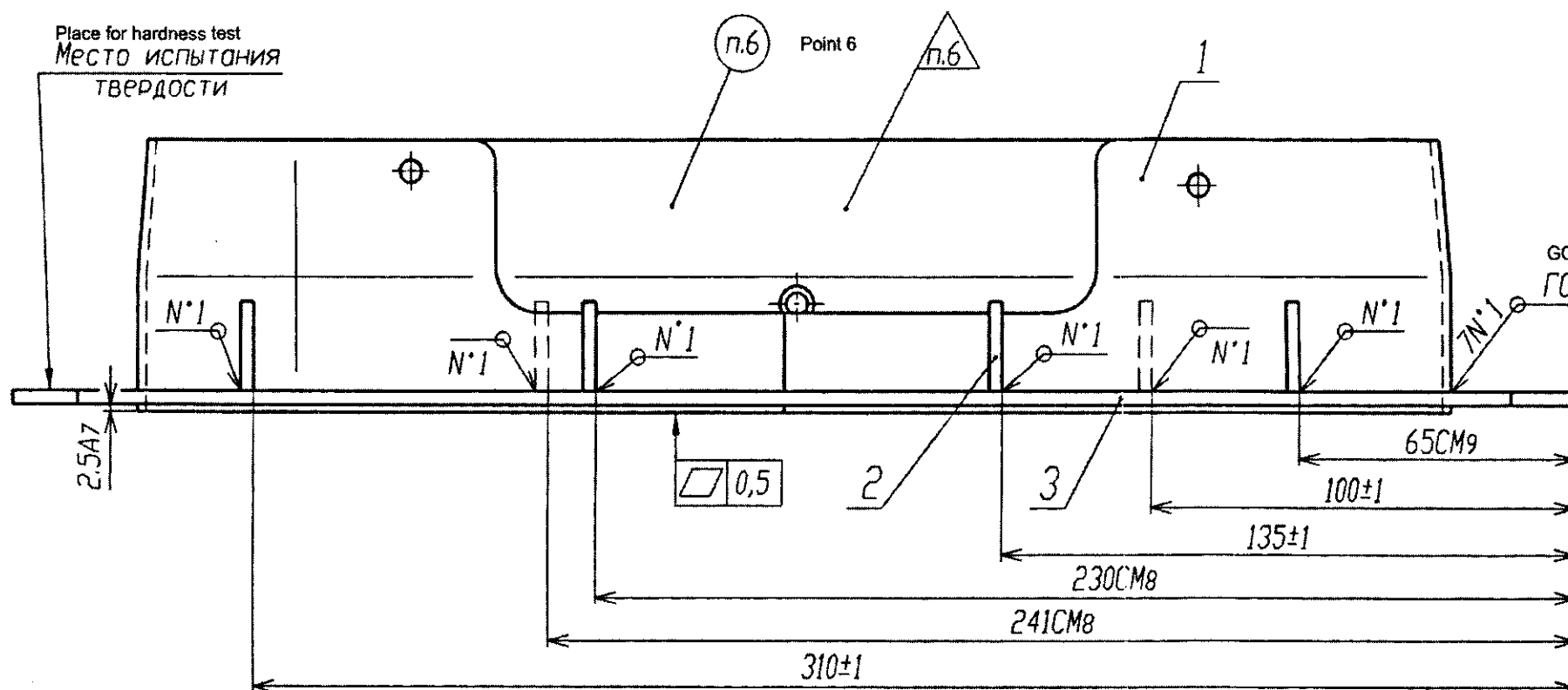
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Format A4

AK-630 СБ107-8СБ

AK - 630 Sb 107 - 8SB

Place for hardness test
Место испытания
ТВЕРДОСТИ



GOST
ГОСТ 5264-80-T1-Δ2

1. Электрод УОНИИ 13/45-2,0-2 ГОСТ 9466-75.
2. Допускается полуавтоматическая сварка в среде углекислого газа с применением присадочной проволоки 1,2 Св-08 Г2С ГОСТ 2246-70.
3. 29...35,0 HRCэ. В местах замера твердости допускается зачистка до 0,5 мм.
4. После сварки сборку нормализовать.
5. Покрытие Кd12. фос.
Лак БФ-4 с нигрозином, 1слой приготавление по ОСТ 3-4123-78, IV, OM2
6. Маркировать Ш, Ч и клеймить К, И по АК-630, АК-630М ТУ I.

1. Electrode UONII 13/45-2.0-2 GOST 9466-75.
2. Semi-automatic welding in the medium of carbonic acid gas with the use of electrode filler 1.2 Sv-08 G2S GOST 2246-70 is permitted.
3. 29...35 HRCэ. Finishing at the places for hardness test is permitted up to 0.5 mm.
4. After welding, normalize the assembly.
5. Coating Cad. 12 Phos.
Varnish BF-4 with nigrogin, 1 layer, preparation as per OST 3-4123-78, IV, OM2.
6. Mark Ш, Ч and stamp К, И as per АК-630, АК-630М ТУ I.

AK - 630 Sb 107 - 8SB

AK-630 СБ107-8СБ

Изм/Лист		N докум		Подп.		Дата		Type	Mass	Scale
Разроб.								Frame of magazine	Лит.	Масса
Проб.								Рамка магазина	A	1,100
Т.контр.								Assembly Drawing	Лист	Листов
Н.контр.								Сборочный чертеж	Sheet	Total Sheets 1
Утв.										

Вале 8 container 2

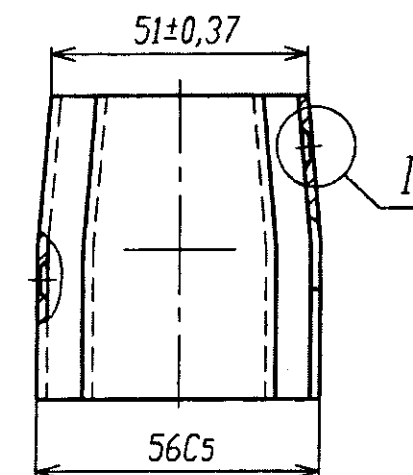
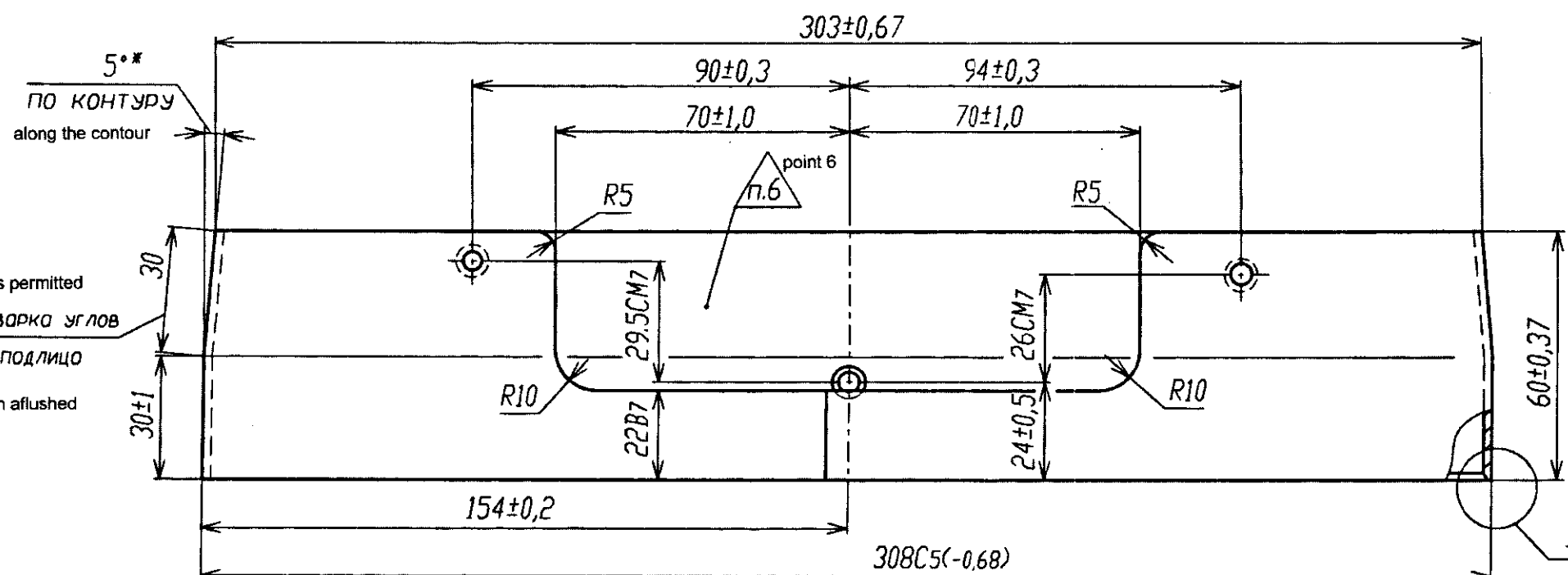
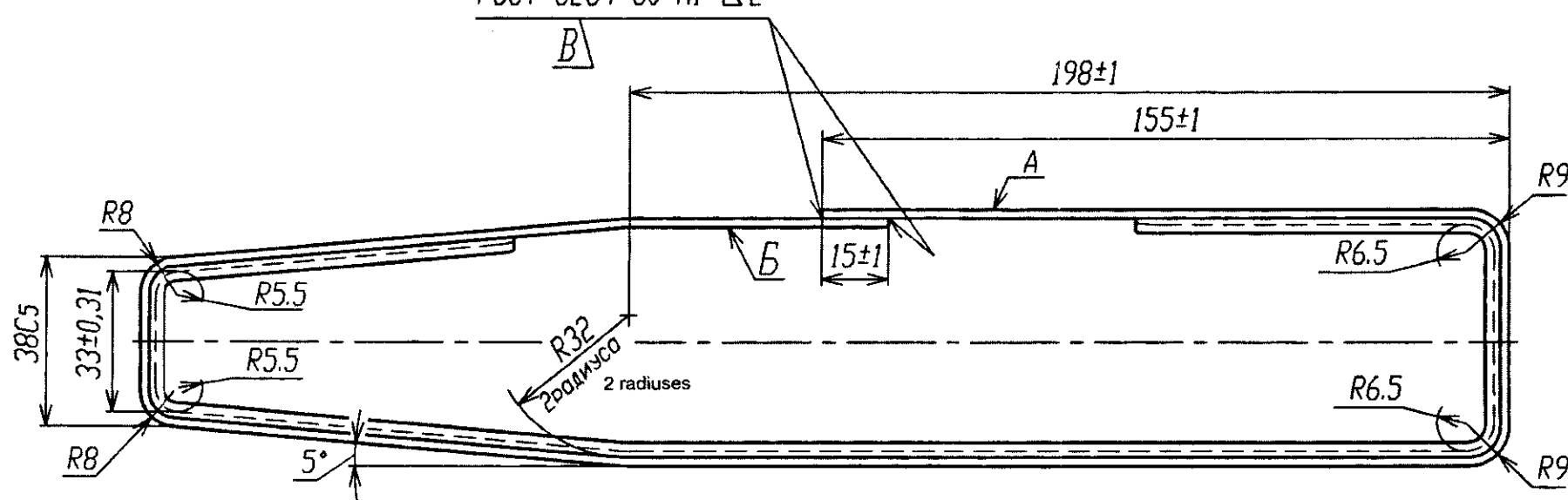
Формат А4х3

Пред. примеч.
 Число
 Инв. и дата
 Инв. и дата
 Инв. и дата
 Инв. и дата

28-101 009-ЖА
AK-630 107-32

GOST
ГОСТ 5264-80-Н1-Δ 2

Rz80 (✓)

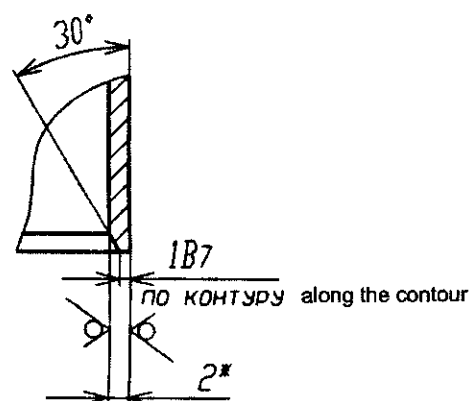


Welding of angles is permitted
Допускается сварка углов
Зачистить заподлицо
Finish aflushed

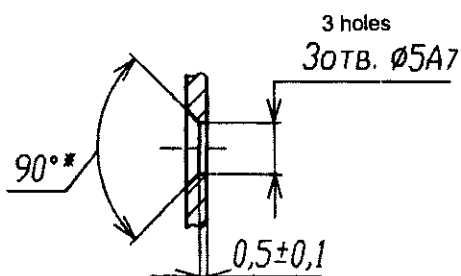
1. Heat treatment - high tempering.
2. Electrode УОНИИ 13/45-2,0-2 GOST 9466-75.
3. Welding as per GOST 14771-76-УП-Н1-2 is permitted with the electrode 1.2 СВ-0,8 Г2С GOST 2246-70.
4. Finish the welded joints B aflushed with planes A and B.
5. * - Dimension for reference.
6. Mark Ш, Ч on the tag and stamp K as per AK-630, AK-630M TU 1.

1. Термообработка - высокий отпуск.
2. Электрод УОНИИ 13/45-2,0-2 ГОСТ 9466-75.
3. Допускается сварка по ГОСТ 14771-76-УП-Н1-Δ 2 проволокой 1,2 Св-0,8 Г2С ГОСТ 2246-70.
4. Сварные швы В зачистить заподлицо с плоскостями А и Б.
5. *Размер для справок.
6. Маркировать Ш, Ч на бирке и клеймить К по АК-630, АК-630М ТУ 1.

I(2:1)



II(2:1)



				AK-630 107-32 Lit			Wt.	Scale
				Lower Frame			Лит.	Масса
				Рамка нижняя			А	0,515
				BT-PN-0 2 GOST 19904-90			Лист	Листов
				Sheet BT-PN-0 2 GOST 19904-90			Sheet	Total Sheets
				К190В 4-III-35 ГОСТ 16523-97				

Пров. примен.

Справк.

Подп. и дата

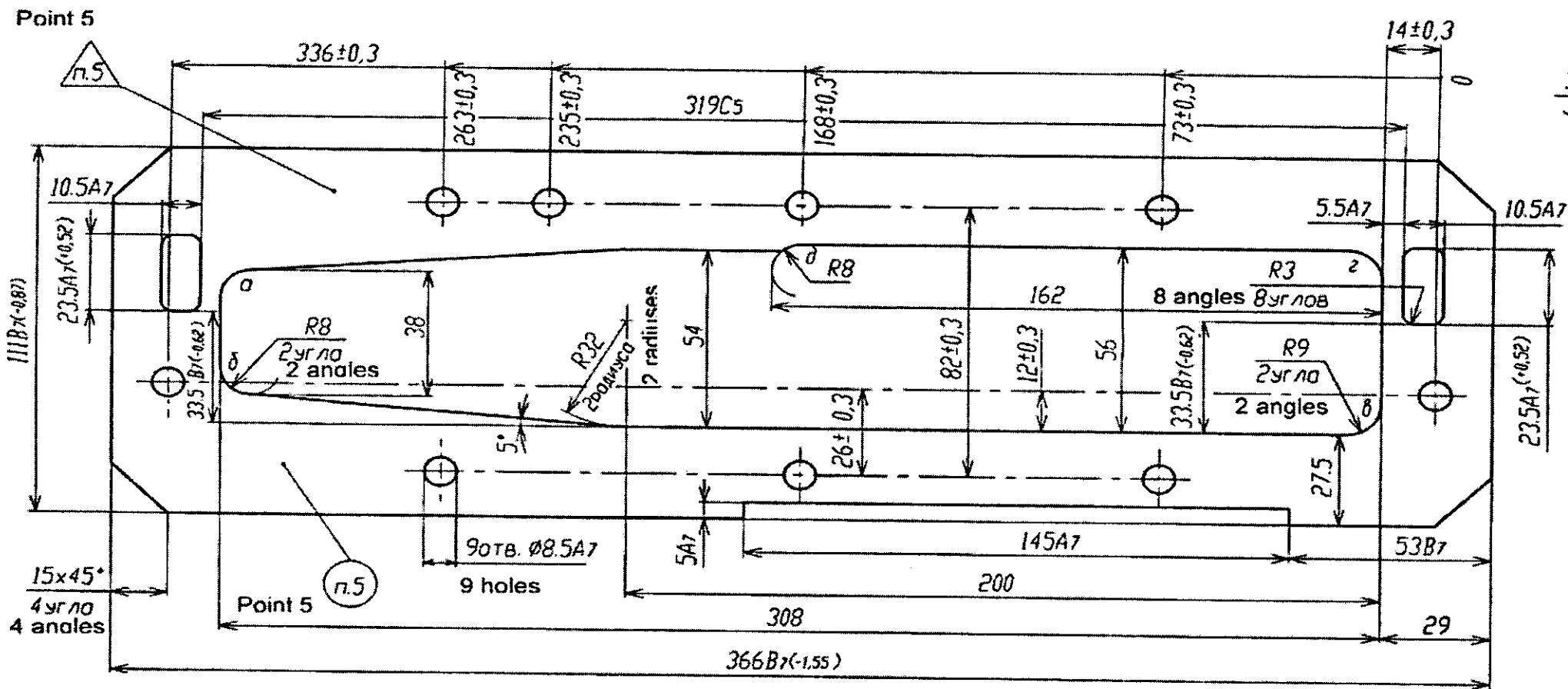
Взам. инв. №

Подп. и дата

Инв. №

AK-630 107-34

Rz80 (✓)



1. Допуск по контуру 'абвгд' - 0,3.
2. * - Размер для справок.
3. Внутренние углы $R \approx 0,4$ мм.
4. Острые ребра притупить $\approx 0,6$ мм.
5. Маркировать Ш, Ч и клеймить К, И по АК-630, АК-630М ТУ 1.

AK-630 107-34
 FLANGE OF MAGAZINE
 Sheet Б-ПН-0 3 GOST 19903-74
 K490B 4-III-35 GOST 16523-97

				AK-630 107-34		
				Type	Mass	Scale
				Лит.	Масса	Масштаб
				А	0,500	1:1
				Лист		
				Листов 1		
				Лист		
				Листов 1		
				Лист		
				Листов 1		
				Лист		
				Листов 1		

AK-630 107-33					
Approved OGMet	Approved TOSb	Approved KTONI	Approved by shop	First use	
Orig. Inv. No.	Alternate Inv. No.	Dupl. Inv. No.	Reference No.		
Sign and Date	Sign and Date	Sign and Date	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					

Rz80 (✓) (✓)

1.* Reference dimension.
 2. Blunt sharp edges R~0.6 mm.
 3. Chips as per specimen are permissible at the corners.
 4. Mark Ш, Ч and stamp K on tag.

AK-630 107-33			
Rib	Type	Weight	Scale
	A	0.003	1:1
Sheet		Sheets 1	

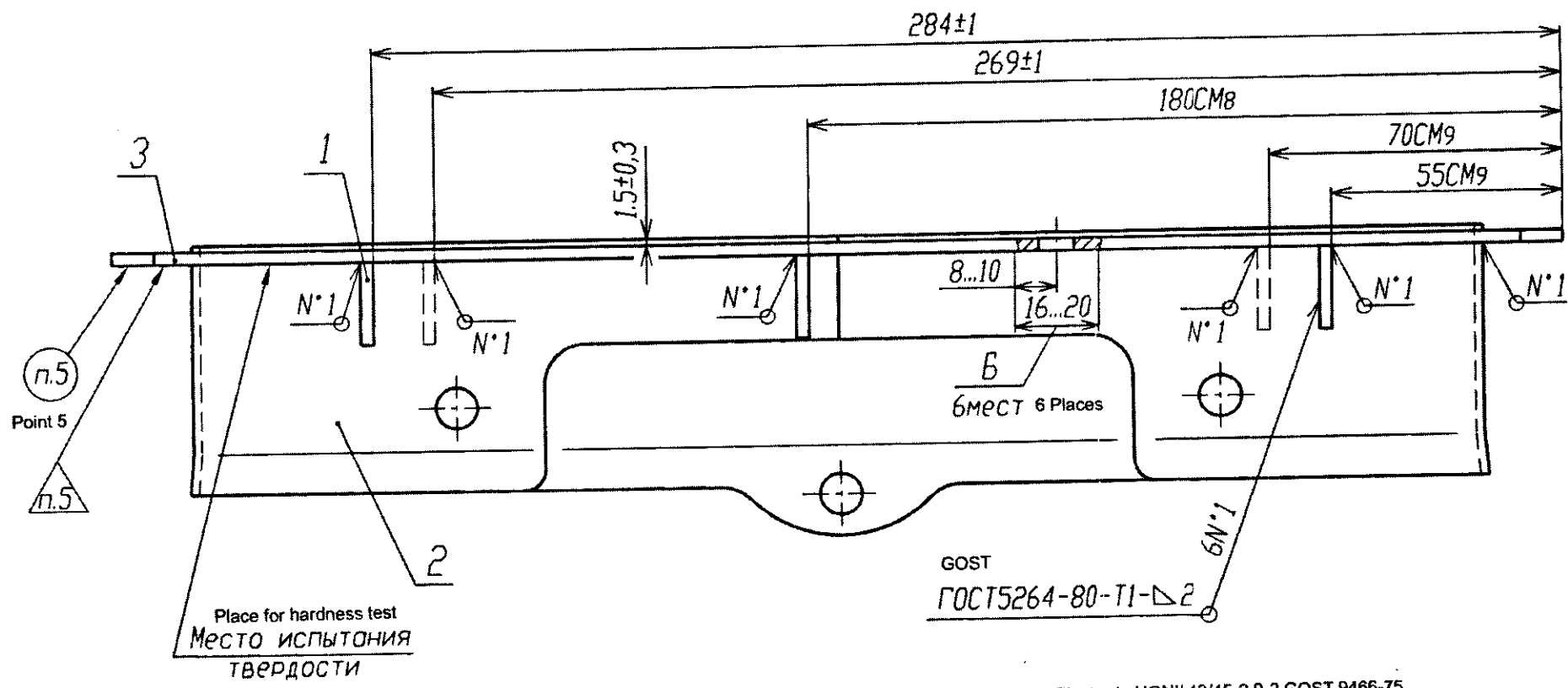
Sheet B - PN - 03 GOST 19903 - 74
K 490V 4 - III - 35 GOST 16523 - 97

Copied by

Format A4

First use		Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
						<u>Documents</u>			
Reference No.		A3			AK-630 Sb 107-9 SB	Assembly drawing			
		A4	1		AK-630 107-33	Rib	5		
		A2	2		AK-630 107-36	Upper frame	1		
		A3	3		AK-630 107-54	Frame	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 107-9		
		Developed by					Type	Sheet	Sheets
		Checked by					A		1
		Head of Q.C.D					Upper frame		
		Approved by							

AK-630 SB107-9SB
AK-630 SB107-9SB



1. Электрод УОНИИ 13/45-2,0-2 ГОСТ 9466-75.
2. Допускается полуавтоматическая сварка в среде углекислого газа с применением присадочной проволоки 1,2 Св-08 Г2С ГОСТ 2246-70.
3. 29...35,0 HRCэ. В местах замера твердости допускается зачистка до 0,5 мм.
4. Покрытие КД12. фос.
Лак БФ-4 с нигрозином, 1слой приготовление по ОСТ 3-4123-78, IV, ОМ2.
5. Маркировать Ш, Ч и клеймить К, И по АК-630, АК-630М ТУ 1.
6. В зонах Б - не варить.

1. Electrode UONII 13/45-2.0-2 GOST 9466-75.
2. Semi-automatic welding in the medium of carbonic acid gas with the use of electrode filler
- 1.2 Sv-08 G2S GOST 2246-70 is permitted.
3. 29...35.0 HRCэ. Finishing at the places for hardness test is permitted up to 0.5 mm.
4. Coating Cad. 12 Phos.
Varnish BF-4 with nigrogin, 1 layer, preparation as per OST 3-4123-78, IV, OM2.
5. Mark Ш, Ч and stamp К, И as per АК-630, АК-630М ТУ 1.
6. In the zones Б - do not weld.

AK - 630 SB107 - 9SB

AK-630 СБ107-9СБ

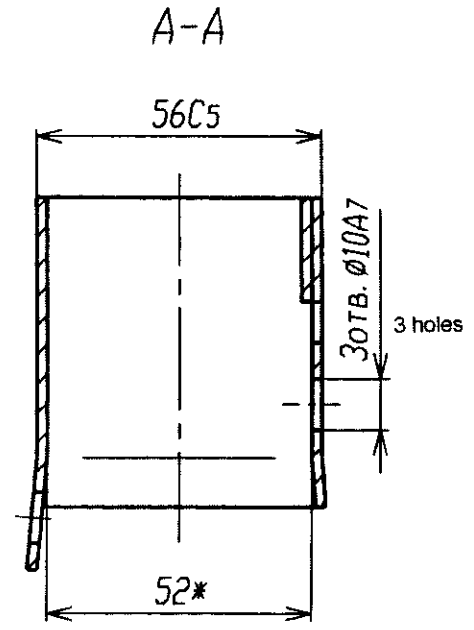
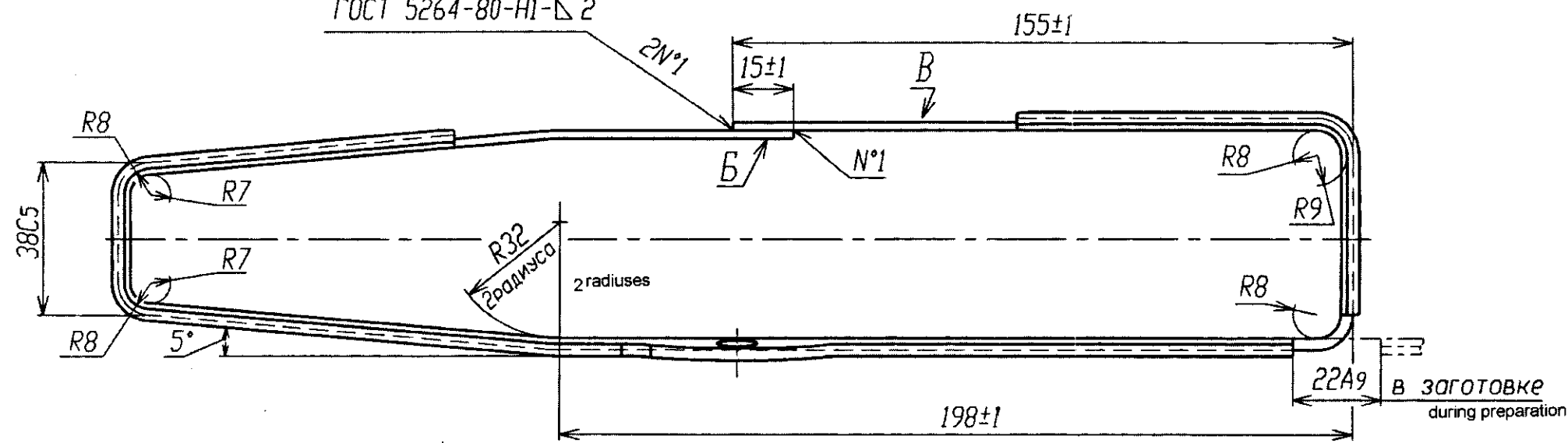
AK-630 СБ107-9СБ		Type	Mass	Scale
Upper Frame		Лит.	Масса	Масштаб
Рамка верхняя		A	1,020	1:1
Assembly Drawing		Лист	Листов	
Сборочный чертёж		Sheet	Total Sheets 1	
Изм.	Лист	И докум.	Подп.	Дата
Разраб.				
Проб.				
Т.контр.				
Н.контр.				
Утв.				

Bale 8 container 2

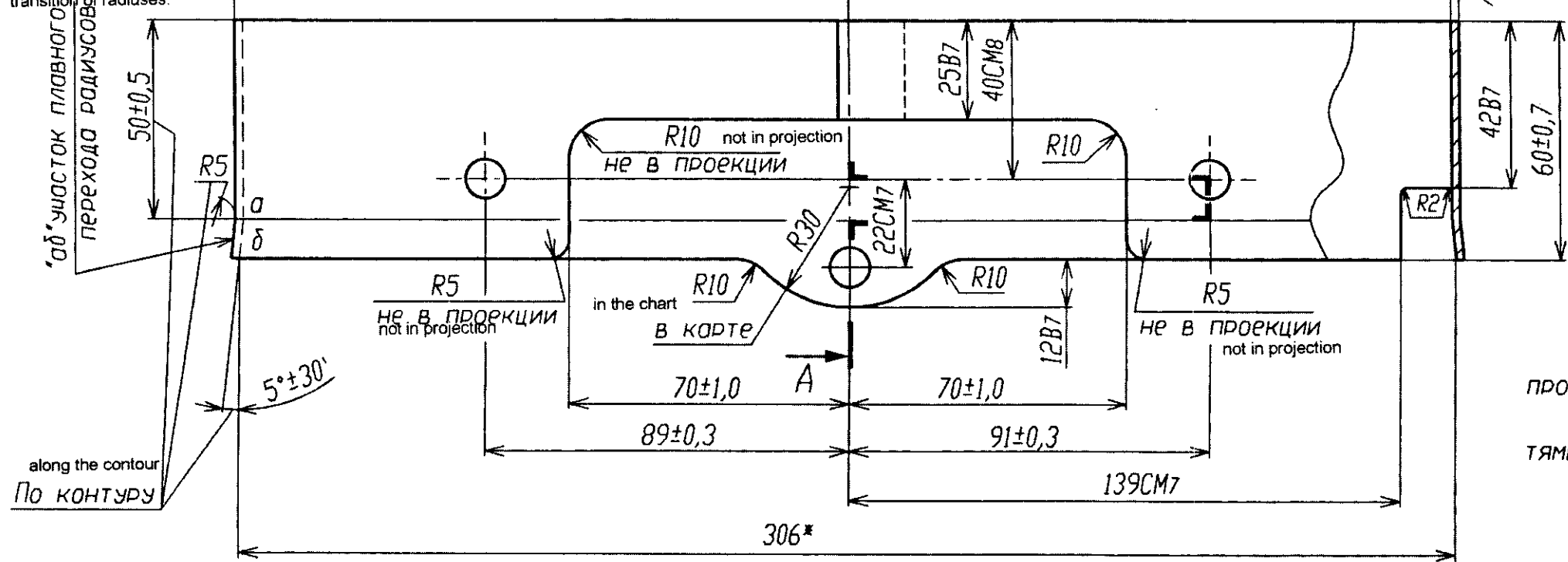
Формат А4х3

Лев. прив. / В.Н. / Подп. и дата / Изм. / Взам. / Подп. и дата

GOST
ГОСТ 5264-80-Н1-Δ 2



aб section of the smooth transition of radiuses.



1. Heat treatment: high tempering.
2. Electrode UONIИ 13/45-3.0-3 GOST 9466-75.
3. welding as per GOST 14771-76-UP-N1-2 is permitted with electorde 1.2 SV-08 G2S GOST 2246-70.
4. Finish the welded joints aflushed with planes Б and В.
5. * - Dimensions for reference.
6. Mark Ш, Ч and stamp К, И on the tag.

1. Термообработка : высокий отпуск.
2. Электрод УОНИИ 13/45-3,0-3 ГОСТ 9466-75.
3. Допускается сварка по ГОСТ 14771-76-УП-Н1-Δ 2 проволокой 1,2 Св-08 Г2С ГОСТ 2246-70.
4. Сварные швы зачистить заподлицо с плоскостями Б и В.
5. *Размеры для справок.
6. Маркировать Ш, Ч и клеймить К, И на бирке.

Лев. примен. Справ.Н Инв.Н подл. и дата Инв.Н подл. и дата Инв.Н подл. и дата

Bale 8 container 2

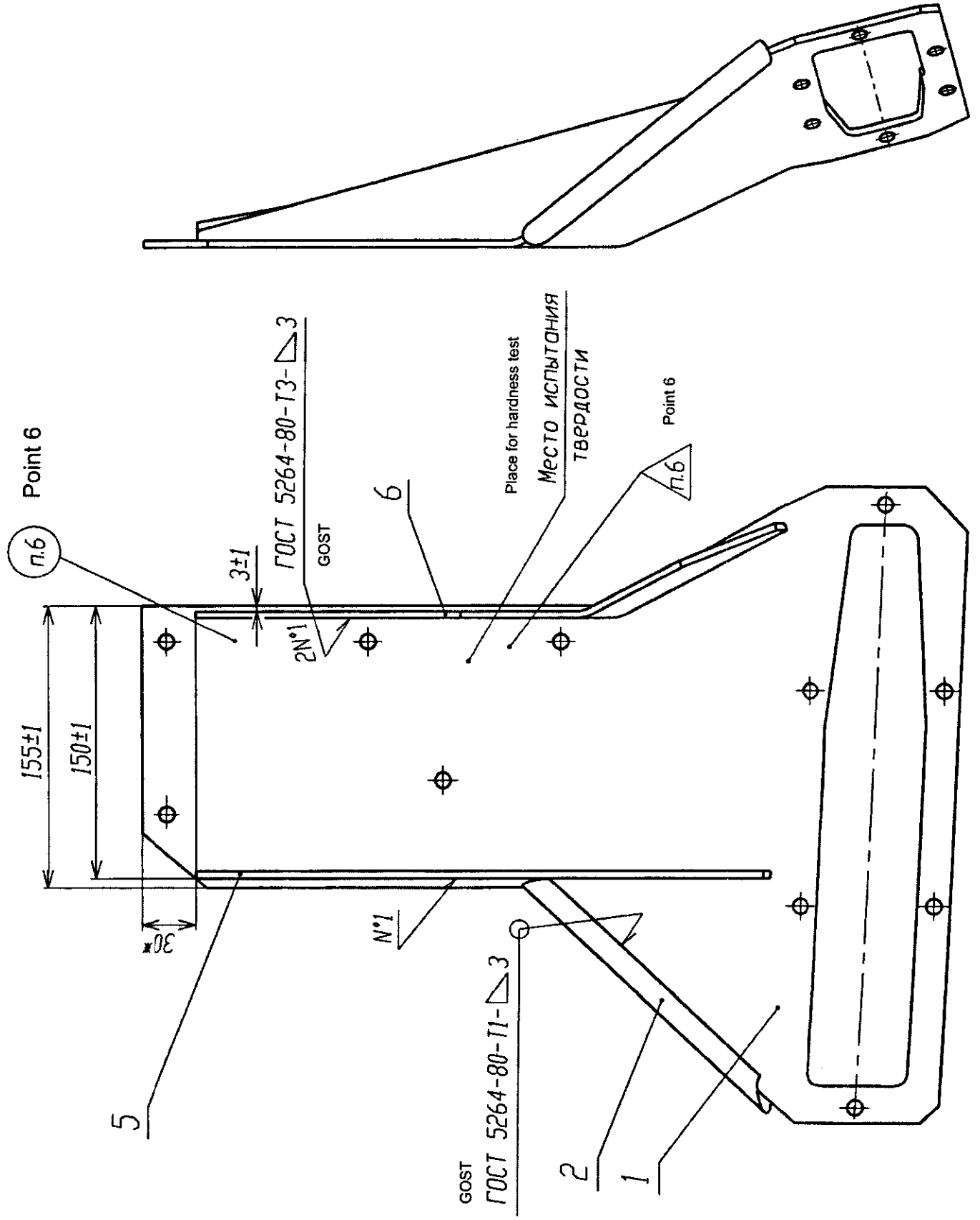
AK-630 107-36				Lit	Wt.	Scale
Upper Frame				Лит.	Масса	Масштаб
Рамка верхняя				A	0,515	1:1
BT-PN-0 2 GOST 19904-90				Лист	Листов 1	
Sheet 61-ПН-0 2 GOST 19904-90				Sheet	Total Sheets	
К 1908 4-Ш-75 GOST 16523-97						
К 490 V 4-Ш-35 GOST						

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
						<u>Documents</u>	
	A2	/		AK-630 Sb 107-2 SB	Assembly drawing		
Reference No.	A2	/	1	AK-630 107-8	Sheet	1	
	A4	/	2	AK-630 107-9	Rib	1	
	A4	/	5	AK-630 107-12	Rib	1	
	A3	/	6	AK-630 107-13	Rib	1	
Sign and Date							
Dupl. Inv. No.							
Alternate Inv. No.							
Sign and Date							
Orig. Inv. No.							

					AK-630 Sb 107-2		
Amend.	Sheet	Doc. No.	Sign	Date			
Developed by					Type	Sheet	Sheets
Checked by					A		1
Head of Q.C.D					Bracket		
Approved by							

AK-630 СБ107-2СБ

AK - 630 Sb 107 - 2SB



1. 29...35 HRCs. On the place for hardness test, the finishing up to 0.5 mm is permitted.
2. Electrode UONI 13/45-3.0-3 GOST 9466-75.
3. Semi-automatic welding in the medium of carbonic acid gas with the use of filler rod 1.2 Sv 08 G2S GOST 2246-70 is permitted.
4. * - Dimension for reference.
5. Coating Cad. 12. phos. Varnish BF-4 with nigrogin, 1 layer, preparation as per OST 3-4123-78, IV,OM2.
6. Mark Ш, Ч and stamp К, И as per AK-630, AK-630M TU 1.

1. 29...35 HRCs. В месте замера твердости допускается зачистка до 0,5 мм.
2. Электрод УОНИ 13/45-3,0-3 ГОСТ 9466-75.
3. Допускается полуавтоматическая сварка в среде углекислого газа с применением присадочной проволоки 1,2 Св 08 Г2С ГОСТ 2246-70.
4. *Размер для справки.
5. Покрытие Кад12. фос. Лак БФ-4 с нигрозином, 1 слой, приготовление по ОСТ 3-4123-78, IV,OM2.
6. Маркировать Ш, Ч и клеить К, И по АК-630, АК-630М ТУ 1.

AK - 630 Sb 107 - 2SB

Type		Mass		Scale	
Лист	Масса	Лист	Масса	Листов	Масштаб
А	4,300	А	4,300	1	1:2
Bracket Кронштейн				Лист	Total Sheets 1
Сборочный чертёж				Лист	Total Sheets 1
Assembly Drawing				Лист	Total Sheets 1

Бале 8 container 2

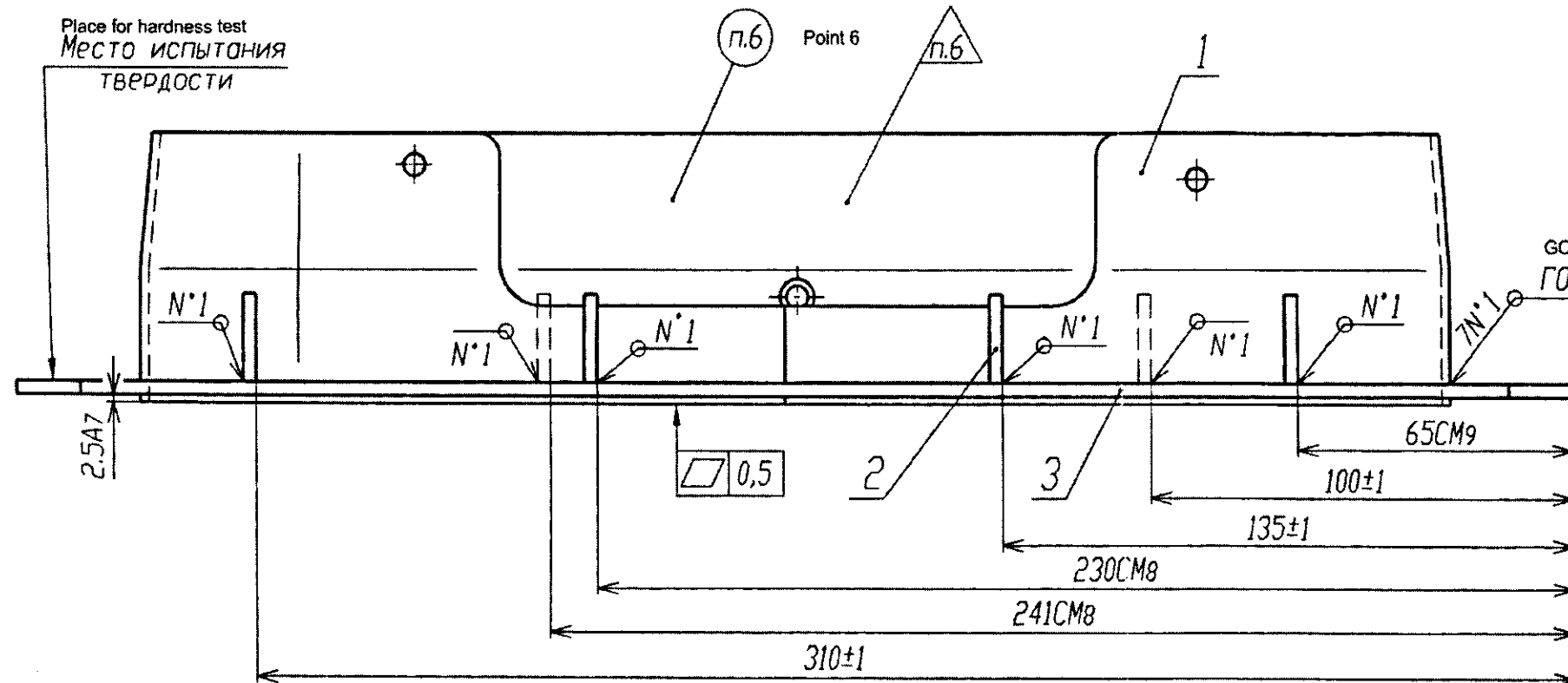
Формат А2

Имя, № подл.	Подл. и дата	Имя, № дубл.	Подл. и дата	Степан	Лева, поимен.
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AK-630 СБ107-8СБ

AK - 630 Sb 107 - 8SB

Place for hardness test
Место испытания
ТВЕРДОСТИ



1. Электрод УОНИИ 13/45-2,0-2 ГОСТ 9466-75.
2. Допускается полуавтоматическая сварка в среде углекислого газа с применением присадочной проволоки 1,2 Св-08 Г2С ГОСТ 2246-70.
3. 29...35,0 HRC_с. В местах замера твердости допускается зачистка до 0,5 мм.
4. После сварки сборку нормализовать.
5. Покрытие Кд12. фос.
Лак БФ-4 с нигрозином, 1слой приготавление по ОСТ 3-4123-78, IV, ОМ2
6. Маркировать Ш, Ч и клеймить К, И по АК-630, АК-630М ТУ I.

1. Electrode UONII 13/45-2.0-2 GOST 9466-75.
2. Semi-automatic welding in the medium of carbonic acid gas with the use of electrode filler
- 1.2 Sv-08 G2S GOST 2246-70 is permitted.
3. 29...35 HRC_s. Finishing at the places for hardness test is permitted up to 0.5 mm.
4. After welding, normalize the assembly.
5. Coating Cad. 12 Phcs.
Varnish BF-4 with nigrogin, 1 layer, preparation as per OST 3-4123-78, IV, OM2.
6. Mark Ш, Ч and stamp К, И as per АК-630, АК-630М ТУ I.

AK - 630 Sb 107 - 8SB

AK-630 СБ107-8СБ

		Type	Mass	Scale
Изм/лист	№ докум.	Подп.	Дата	
Разроб.				
Пров.				
Т.контр.				
И.контр.				
Утв.				
Frame of magazine Рамка магазина Assembly Drawing Сборочный чертёж				Лит. А
				Масса 1,100
				Шкала 1:1
		Лист	Листов 1	
		Sheet	Total Sheets 1	

Вале 8 container 2

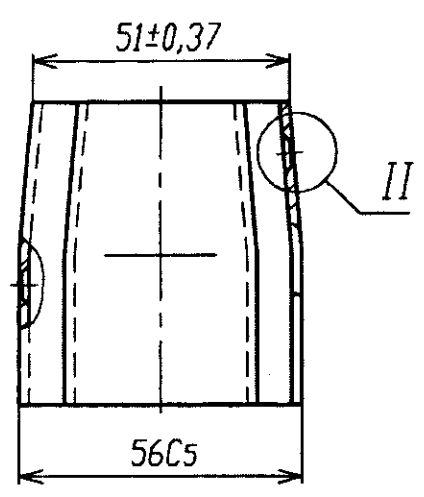
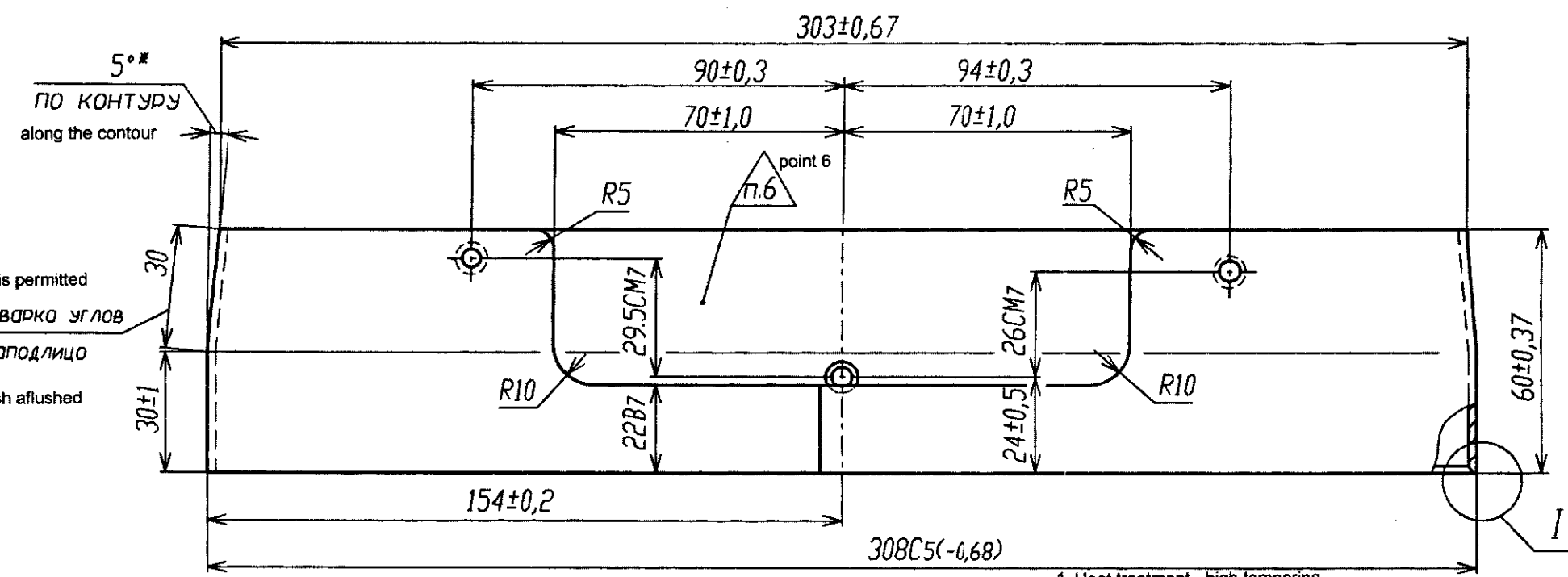
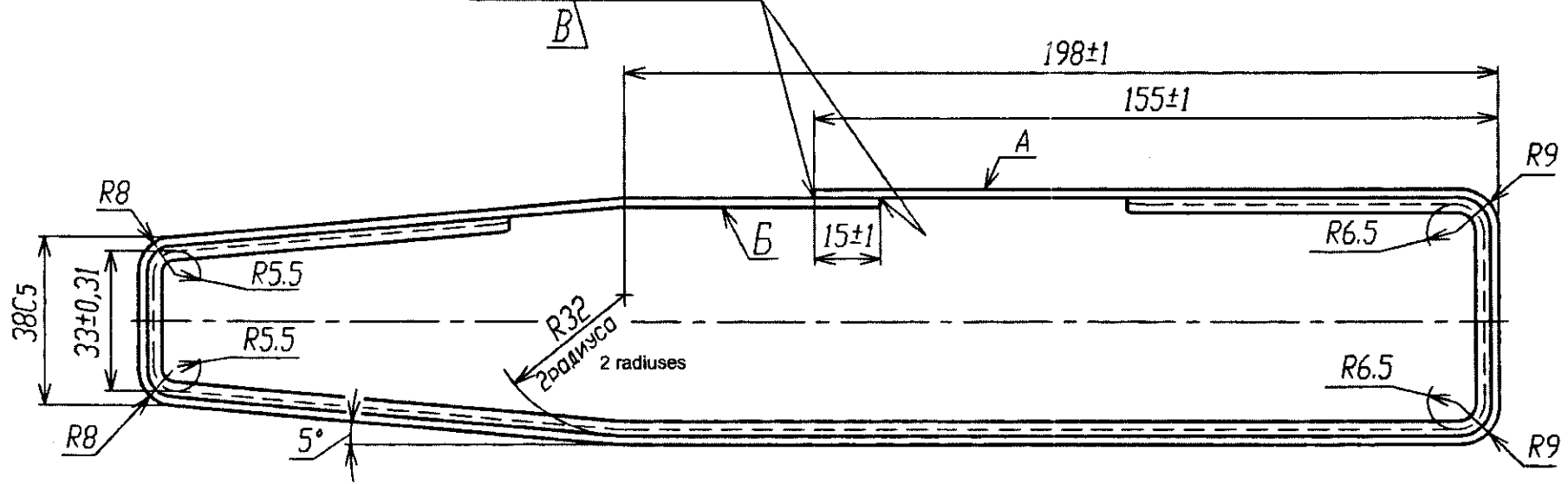
Формат А4х3

Лев. поимен.
 Словян.
 Подп. и дата
 Имя, Фамилия
 Подп. и дата
 Имя, Фамилия
 Подп. и дата

AK-630 107-32

GOST
ГОСТ 5264-80-Н1-Δ 2

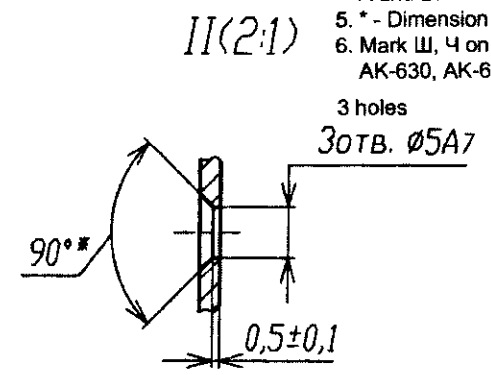
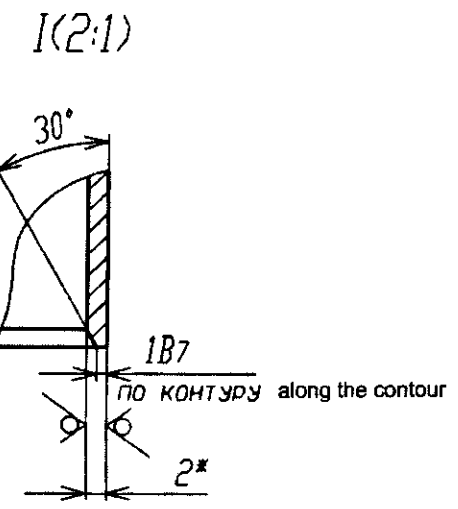
Rz80 (✓)



Welding of angles is permitted
Допускается сварка углов
Зачистить заподлицо
Finish aflushed

1. Heat treatment - high tempering.
2. Electrode УОНИИ 13/45-2.0-2 GOST 9466-75.
3. Welding as per GOST 14771-76-УП-Н1-2 is permitted with the electrode 1.2 СВ-0.8 ГЭС GOST 2246-70.
4. Finish the welded joints B aflushed with planes A and B.
5. * - Dimension for reference.
6. Mark Ш, Ч on the tag and stamp K as per АК-630, АК-630М ТУ 1.

1. Термообработка - высокий отпуск.
2. Электрод УОНИИ 13/45-2,0-2 ГОСТ 9466-75.
3. Допускается сварка по ГОСТ 14771-76-УП-Н1-Δ 2 проволокой 1,2 СВ-0,8 ГЭС ГОСТ 2246-70.
4. Сварные швы В зачистить заподлицо с плоскостями А и Б.
5. *Размер для справок.
6. Маркировать Ш, Ч на бирке и клеймить К по АК-630, АК-630М ТУ 1.



Лист 1 из 1
Дата
Изменения
Исполнитель
Проверен
Специалист
Проектировщик

AK-630 107-32				Lit	Wt.	Scale
Lower Frame Рамка нижняя				Лит.	Масса	Масштаб
ВТ-РН-0 2 GOST 19904-90				Лист	Листов 1	
Sheet ВТ-РН-0 2 GOST 19904-90				Sheet	Total Sheets	
Лист К490В 4-III-35 GOST 16523-97						

AK-630 107-33					
Approved OGMet	Approved TOsb	Approved KTONI	Approved by shop	First use	
Orig. Inv. No.	Alternate Inv. No.	Sign. and Date	Dupl. Inv. No.	Reference 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					

Rz80 (✓) (✓)

1.* Reference dimension.
 2. Blunt sharp edges R~0.6 mm.
 3. Chips as per specimen are permissible at the corners.
 4. Mark Ш, Ч and stamp K on tag.

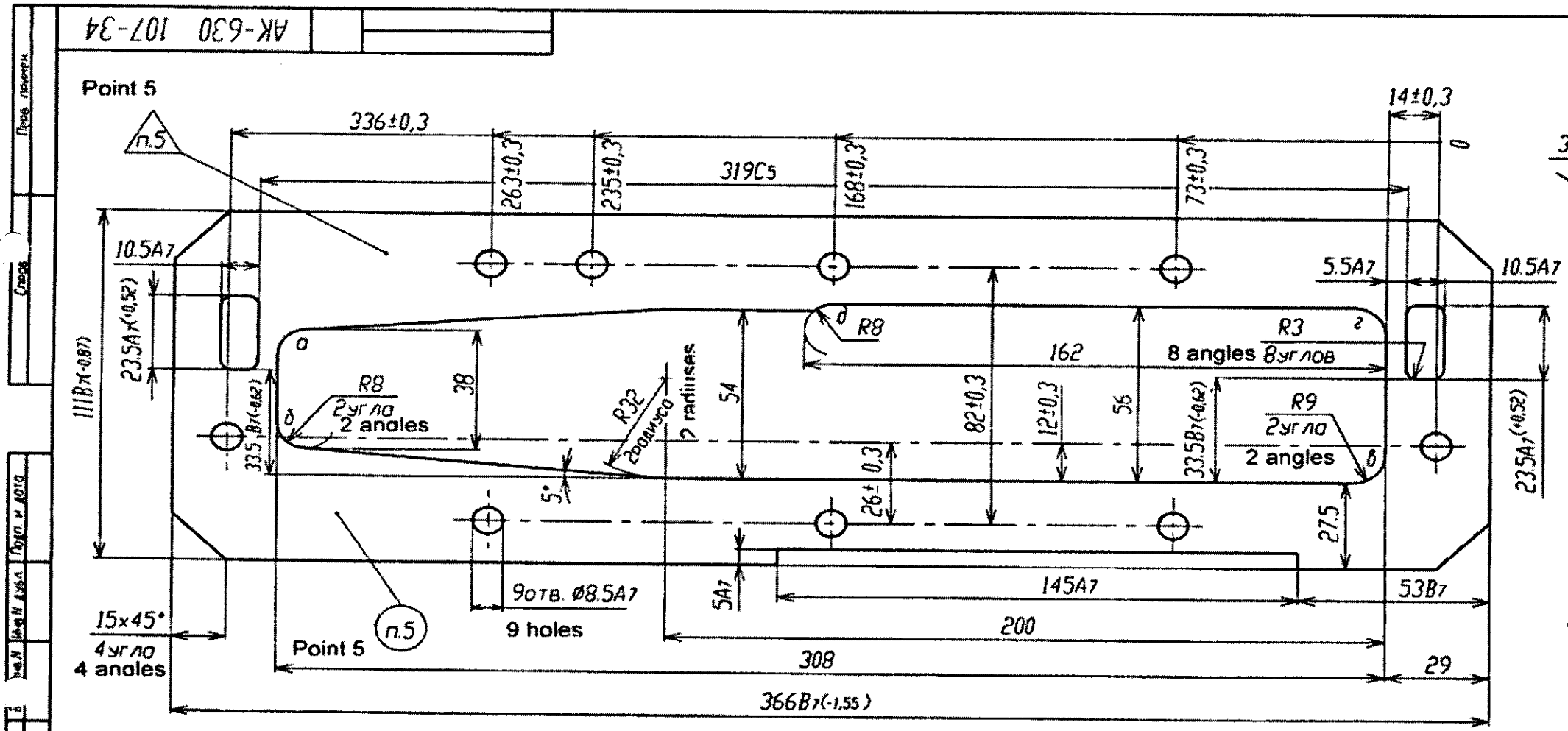
AK-630 107-33			
Rib	Type	Weight	Scale
	A	0.003	1:1
Sheet		Sheets 1	

Sheet B - PN - 03 GOST 19903 - 74
K 490V 4 - III - 35 GOST 16523 - 97

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Format A4

Rz80 (✓)



1. Tolerance along the contour 'абвгд' – 0.3.
 2. * - Dimension for reference.
 3. Internal angles $R \approx 0.4$ mm.
 4. Round off the sharp edges ~ 0.6 mm
 5. Mark Ш, Ч and stamp К, И as per АК-630, АК-630 М ТУ 1.
1. Допуск по контуру "абвгд" - 0,3 мм.
 2. * Размер для справок.
 3. Внутренние углы $R \approx 0,4$ мм.
 4. Острые ребра притупить $\sim 0,6$ мм.
 5. Маркировать Ш, Ч и клеймить К, И по АК-630, АК-630М ТУ 1.

AK-630 107-34
 FLANGE OF MAGAZINE
 Sheet Б-ПН-0 3 GOST 19903-74
 К490В 4-III-35 GOST 16523-97

				AK-630 107-34		
				Type	Mass	Scale
Изм.	Лист	№ докум.	Подп.	Дата	Лист	Масса
Разраб.					А	0,500
Проф.					Листов 1	
Монтаж.					Листов 1	
Исполн.					Лист	Total Sheets
Утв.					Лист	Total Sheets
				Лист Б-ПН-0 3 GOST 19903-74		
				К490В 4-III-35 GOST 16523-97		

Изм. Лист № докум. Подп. Дата
 Разраб. Проф. Монтаж. Исполн. Утв.

AK-630 107-34

Point 5

Point 5

15x45°
4 углов
4 angles

9 отв. Ø8.5A7
9 holes

8 angles 8 углов

2 углов 2 angles

7 radiuses

2 углов 2 angles

111B7(-0.87)

366B7(-1.55)

23.5A7(+0.52)

10.5A7

3°

14±0.3

0

5.5A7

10.5A7

73±0.3

168±0.3

319C5

235±0.3

263±0.3

336±0.3

33.5B7(+0.62)

56

12±0.3

162

R8

R3

R9

R32

R8

38

54

82±0.3

26±0.3

5

5A7

145A7

200

53B7

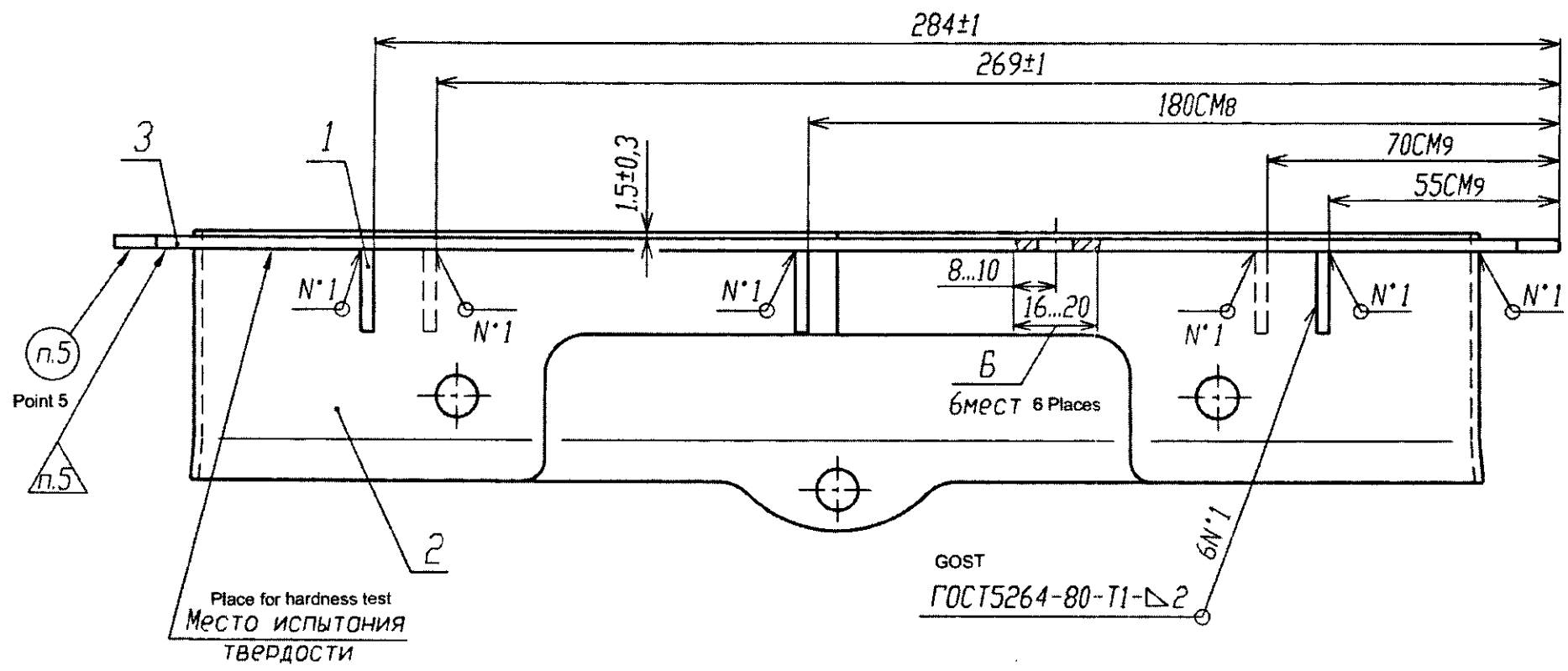
27.5

29

308

AK-630 Sb107-9SB
 AK-630 Sb107-9SB

Перв. примен.
 В.И.
 Инв. № экз. Подп. и дата
 Возм.
 Инв. № подл. Подп. и дата



1. Электрод УОНИИ 13/45-2,0-2 ГОСТ 9466-75.
2. Допускается полуавтоматическая сварка в среде углекислого газа с применением присадочной проволоки 1,2 Св-08 ГЭС ГОСТ 2246-70.
3. 29...35,0 HRC_a. В местах замера твердости допускается зачистка до 0,5 мм.
4. Покрытие Кд12. фос.
Лак БФ-4 с нигрозином, 1слои приготавливание по ОСТ 3-4123-78, IV, ОМ2.
5. Маркировать Ш, Ч и клеймить К, И по АК-630, АК-630М ТУ I.
6. В зонах Б - не варить.

1. Electrode UONII 13/45-2.0-2 GOST 9466-75.
2. Semi-automatic welding in the medium of carbonic acid gas with the use of electrode filler
- 1.2 Sv-08 G2S GOST 2246-70 is permitted.
3. 29...35.0 HRC_a. Finishing at the places for hardness test is permitted up to 0.5 mm.
4. Coating Cad. 12 Phos.
Varnish BF-4 with nigrogin, 1 layer, preparation as per OST 3-4123-78, IV, OM2.
5. Mark Ш, Ч and stamp К, И as per АК-630, АК-630М ТУ I.
6. In the zones Б - do not weld.

AK - 630 Sb107 - 9SB

				AK-630 СБ107-9СБ		
				Type	Mass	Scale
				Лит.	Масса	Масштаб
				A	1,020	1:1
Изм/Лист	№ докум.	Подп.	Дата	Upper Frame		
Разроб.				Рамка верхняя		
Проб.				Assembly Drawing		
Т.контр.				Сборочный чертёж		
Н.контр.				Лист	Листов	
Утв.				Sheet	Total Sheets	
					1	

Bale 8 container 2

Формат А4х3

First use

Reference No.

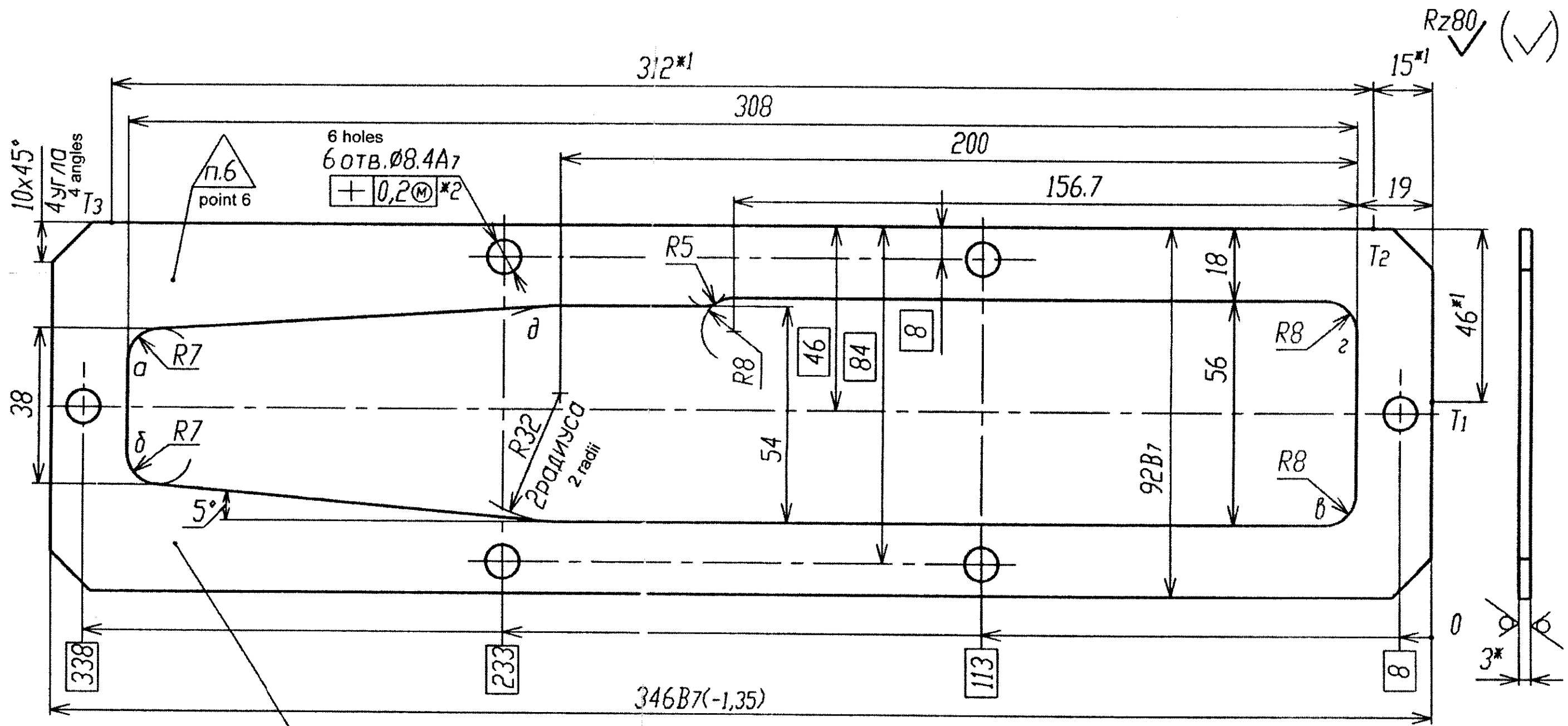
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

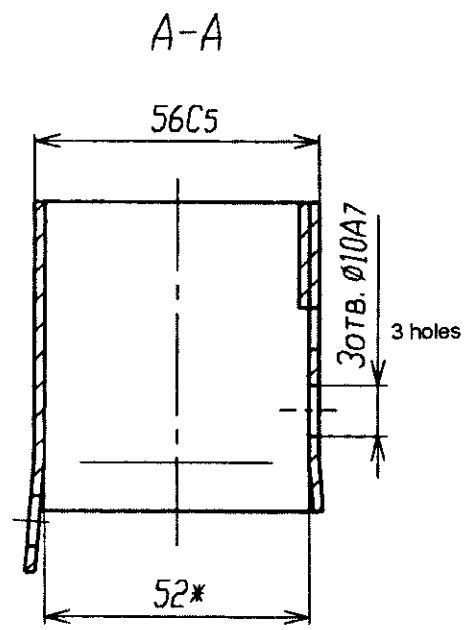
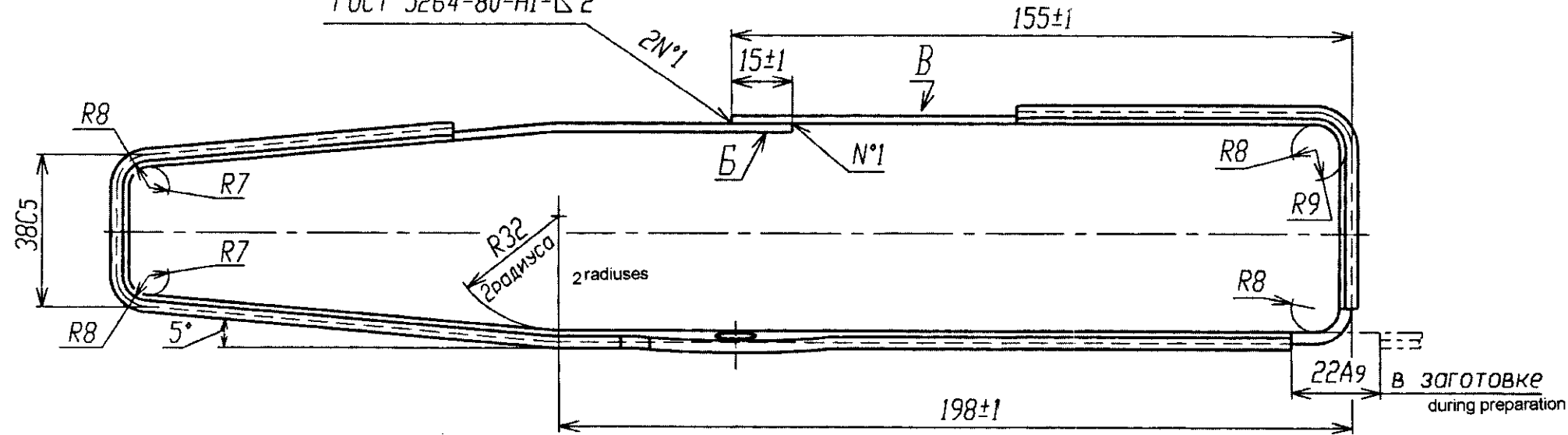


- 1.* Reference dimension.
- 2.*1 Dimensions ensured by tool.
- 3.*2 Deviation given with respect to points T₁, T₂, T₃.
- 4. Tolerance for contour абвгд- 0.3 mm with respect to datum points T₁, T₂, T₃.
- 5. Blunt sharp edges R~0.6 mm.
- 6. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 107-54			
Amend.	Sheet	Doc.No.	Sign	Date	Frame	Type	Weight	Scale
Developed by						A	0.360	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Sheet <u>B - PN - 03 GOST 19903 - 74</u>			
Approved by					K 490V 4 - III - 35 GOST 16523 - 97			

GOST

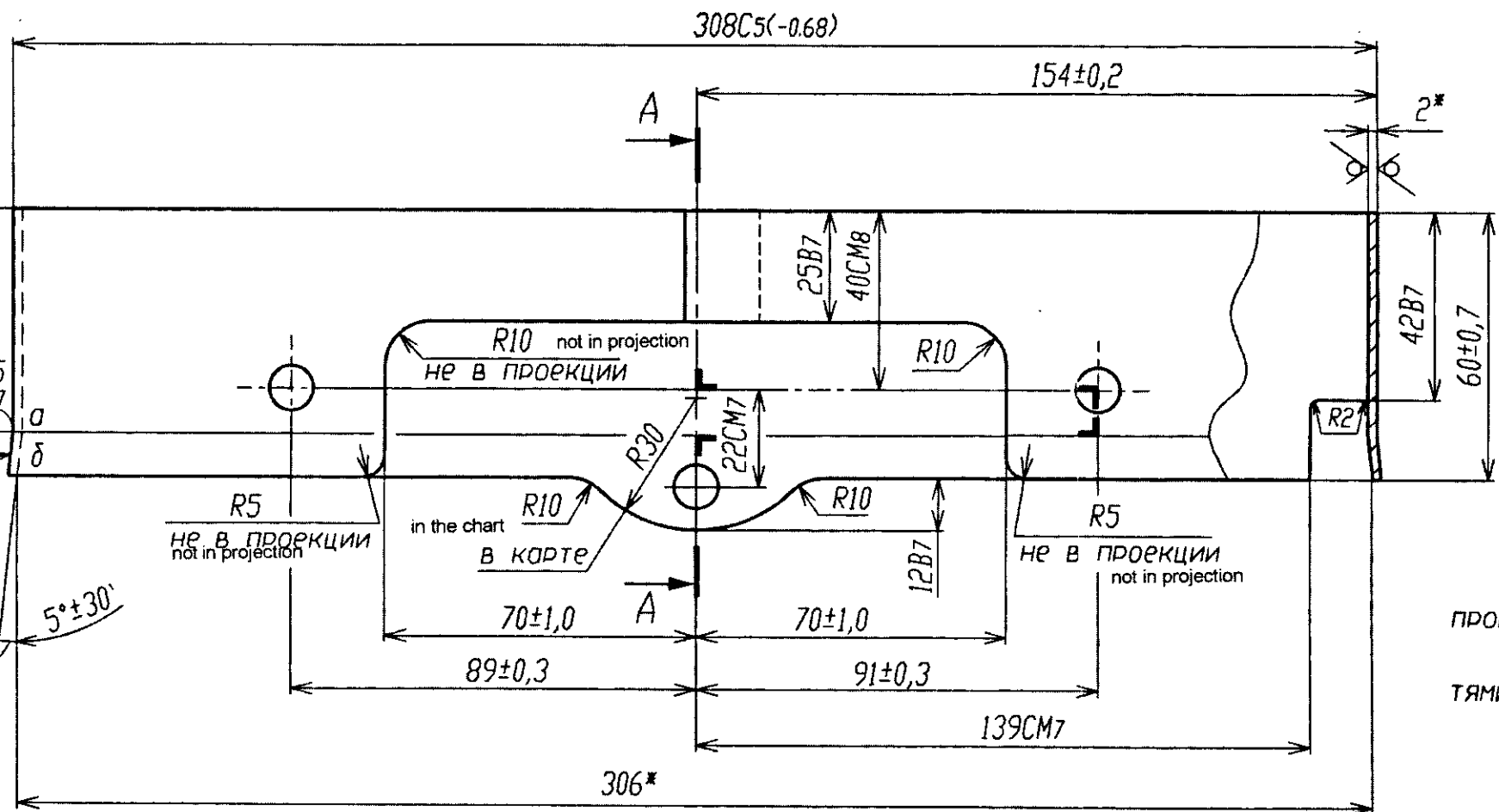
ГОСТ 5264-80-Н1-Δ 2



aб section of the smooth transition of radiuses.

аδ участок плавного перехода радиусов

along the contour По контуру



1. Heat treatment: high tempering.
2. Electrode UONIИ 13/45-3.0-3 GOST 9466-75.
3. welding as per GOST 14771-76-UP-N1-2 is permitted with electorde 1.2 SV-08 G2S GOST 2246-70.
4. Finish the welded joints afushed with planes Б and В.
5. * - Dimensions for reference.
6. Mark Ш, Ч and stamp К, И on the tag.

1. Термообработка : высокий отпуск.
2. Электрод УОНИИ 13/45-3,0-3 ГОСТ 9466-75.
3. Допускается сварка по ГОСТ 14771-76-УП-Н1-Δ 2 проволокой 1,2 Св-08 Г2С ГОСТ 2246-70.
4. Сварные швы зачистить заподлицо с плоскостями Б и В.
5. *Размеры для справок.
6. Маркировать Ш, Ч и клеймить К, И на бирке.

Лев. примен.
Справ. N
Взам.инв. N
Инв. N
Подп. и дата
Изм. N
Подп. и дата

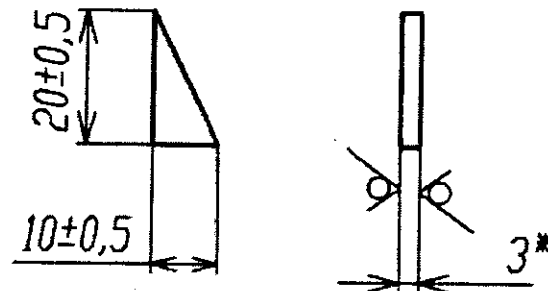
Bale 8 container 2

AK-630 107-36				Lit	Wt.	Scale
Upper Frame				Лит.	Масса	Масштаб
Рамка верхняя				A	0,515	1:1
BT-PN-0 2 GOST 19904-90				Лист	Листов 1	
Sheet BT-PN-0 2 GOST 19904-90				Sheet	Total Sheets	
К 1908 4-III-75 ГОСТ 14523-97						

AK-630 107-33

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

Rz80 (✓)



- 1.* Reference dimension.
2. Blunt sharp edges R~0.6 mm.
3. Chips as per specimen are permissible at the corners.
4. Mark Ш, Ч and stamp K on tag.

Amend.	Sheet	Doc. No.	Sign	Date

AK-630 107-33

Rib

Type	Weight	Scale
A	0.003	1:1

Sheet B - PN - 03 GOST 19903 - 74
K 490V 4 - III - 35 GOST 16523 - 97

Copied by

Format A4

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
						Documents		
Reference No.	A3			AK-630 Sb107-12 SB	Assembly drawing			
	A3		1	AK-630 107-44	Strip	1		
	A4		2	AK-630 107-45	Rib	1		
Sign and Date								
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date								
Orig. Inv. No.					AK-630 Sb 107-12			
	Amend.	Sheet	Doc. No.	Sign	Date			
	Developed by					Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D							
Approved by								
Strip								

First use

Reference No.

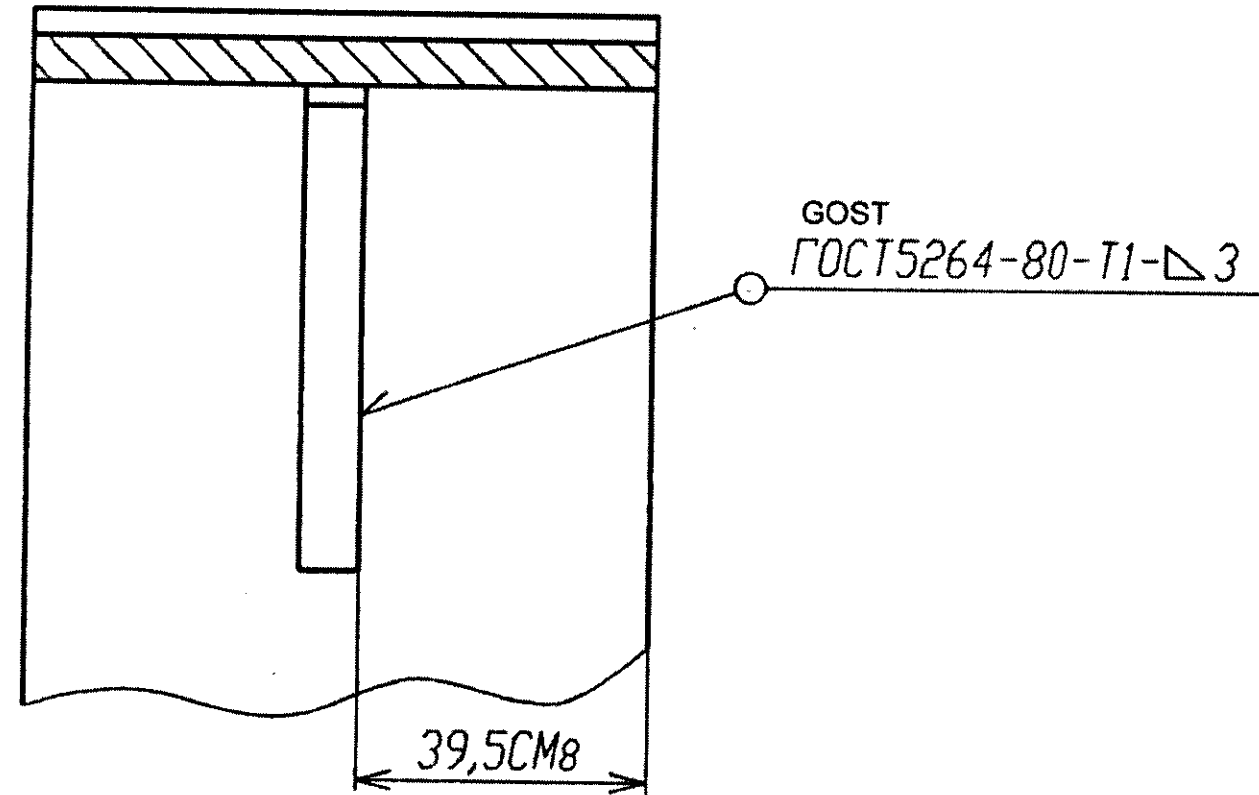
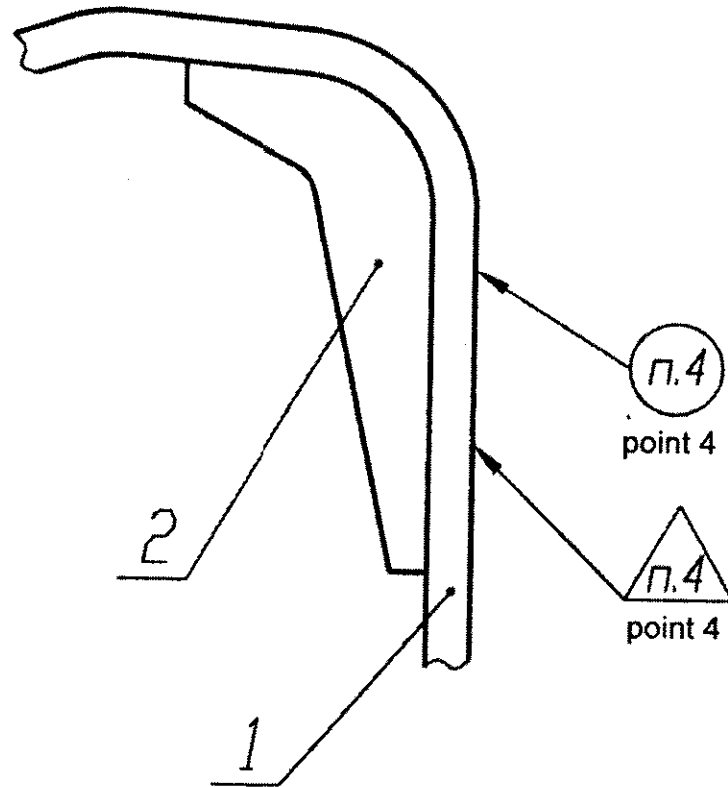
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. Welding rod 13/45-2.0-3 GOST 9466-75.
2. Semi automatic welding in carbon dioxide medium by using filler wire 1.2 Sv-08 G2S 2246-70 is permissible.
3. Deviation of contour AK-630 107-44, after making assembly, from contour of template made as per 5 th accuracy grade- 2 mm.
4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 Sb 107-12 SB				
Amend.	Sheet	Doc.No.	Sign	Date	Strip Assembly drawing	Type		Weight	Scale
Developed by						A		1.840	1:1
Checked by									
Head of Q.C.D						Sheet		Sheets 1	
Approved by									

First use

Reference No.

Sign and Date

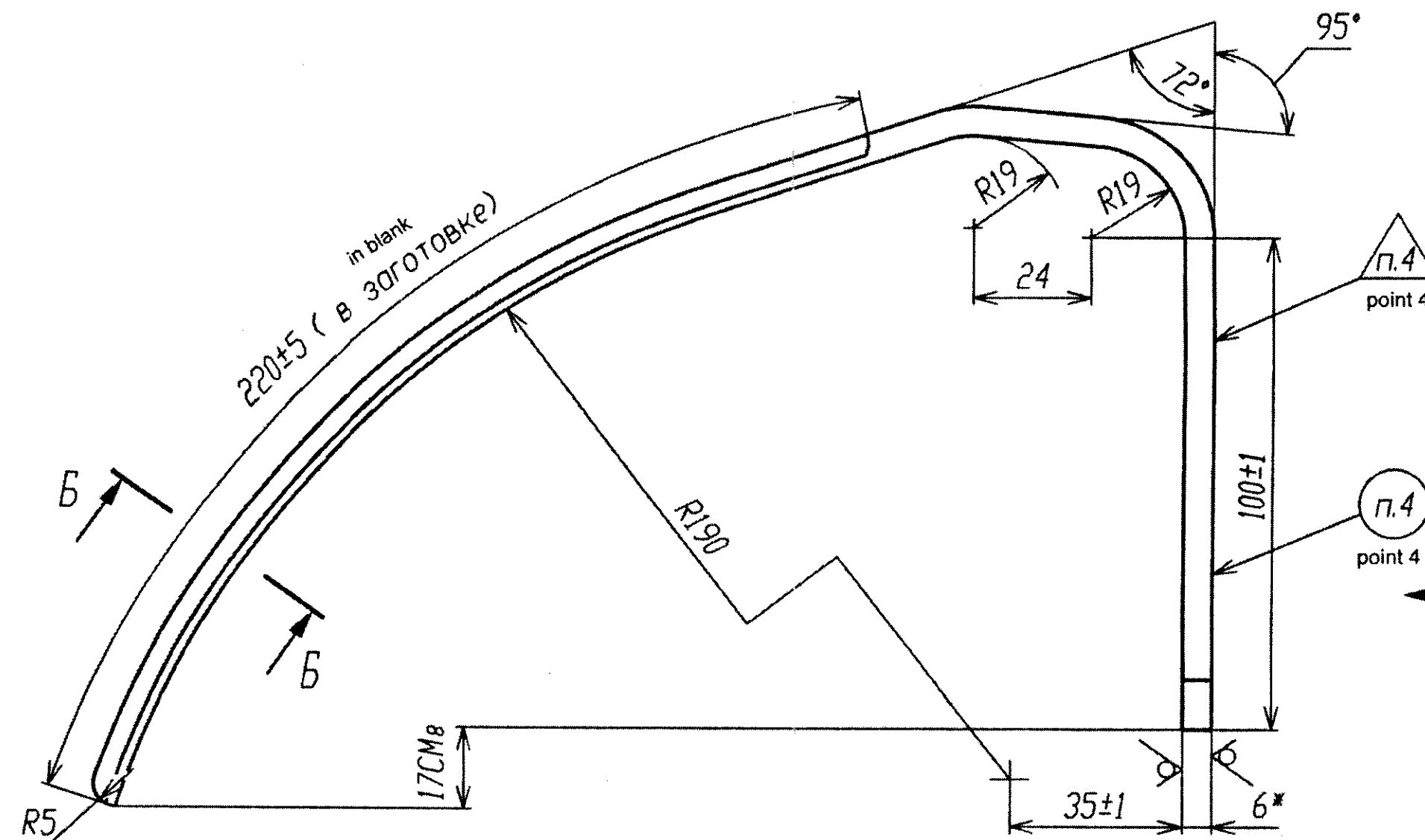
Duplicate Inv. No

Alternate Inv. No

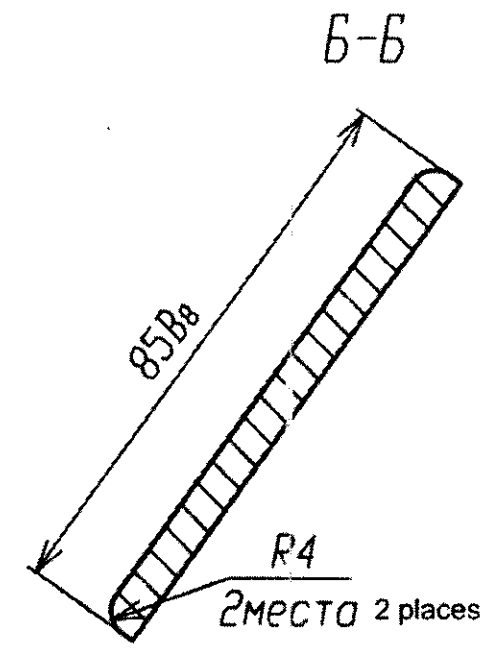
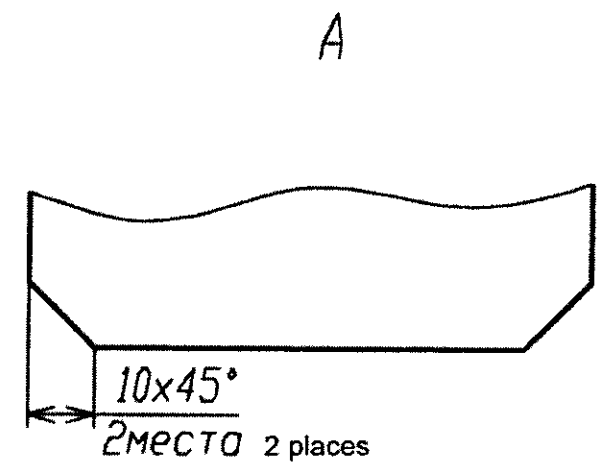
Sign and Date

Orig. inv. no.

Rz80 (✓)



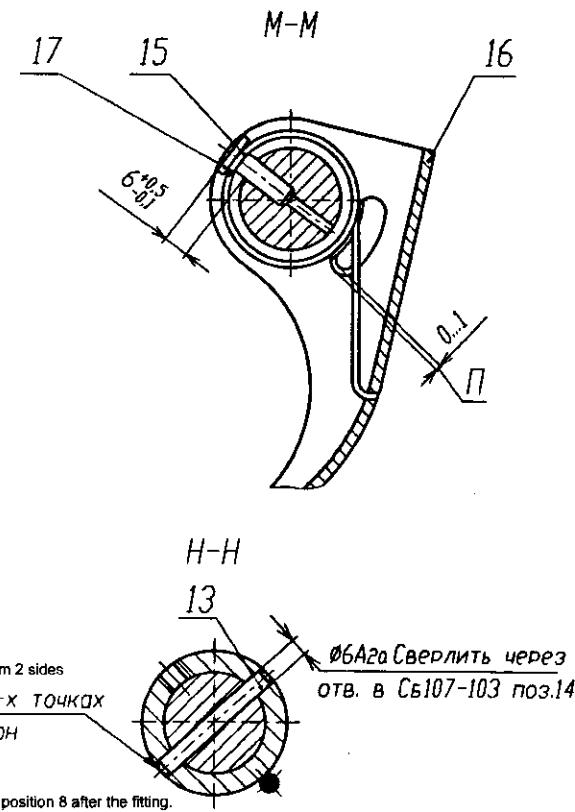
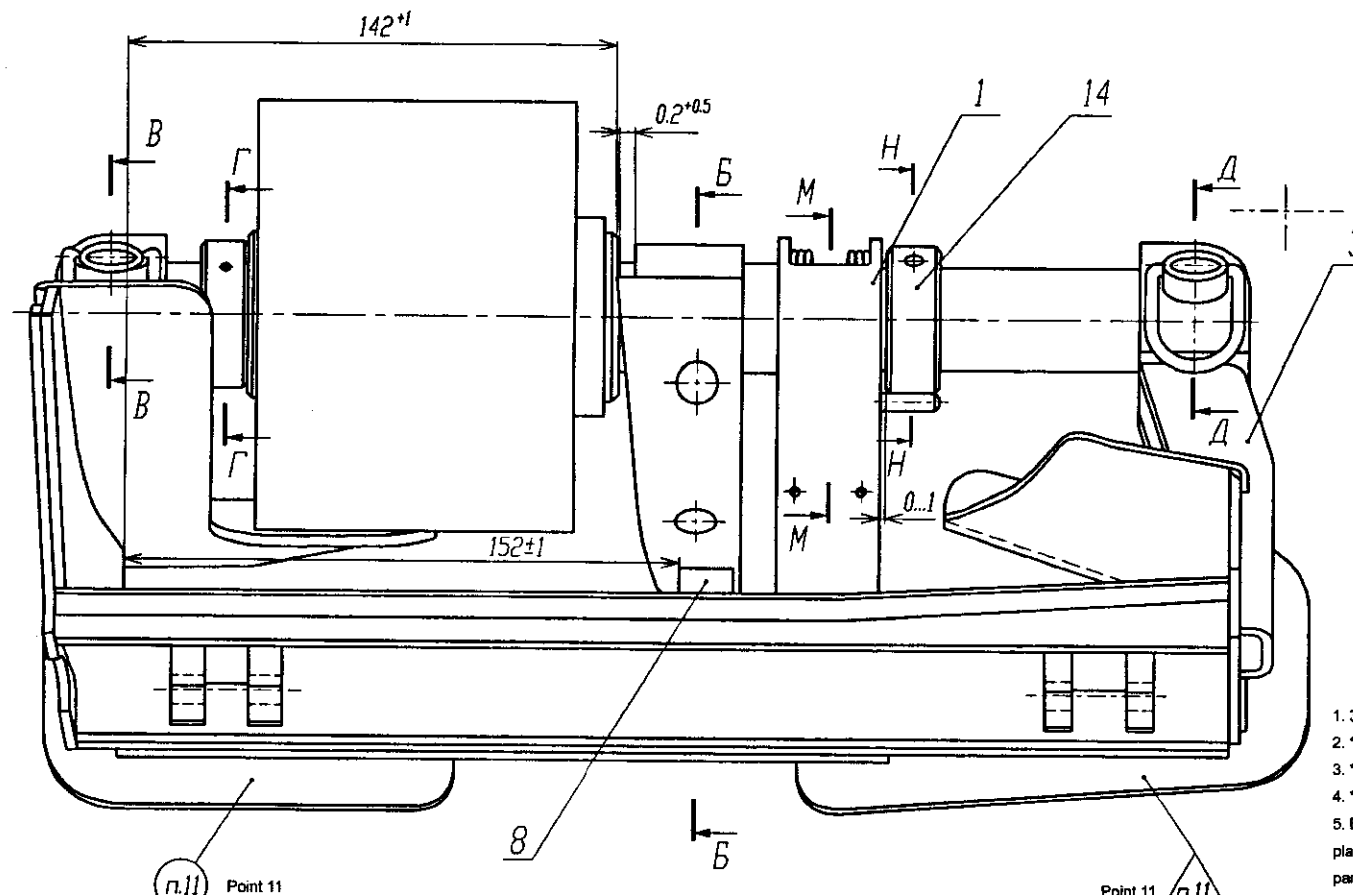
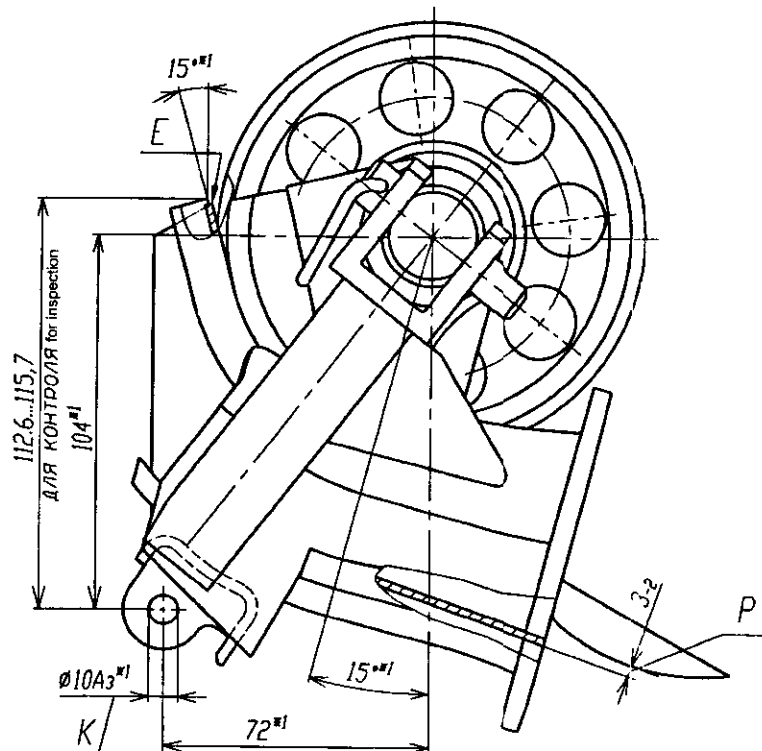
- 1.* Reference dimension.
- 2. Tolerance for contour of component- 1 mm.
- 3. Blunt sharp edges ~0.6 mm.
- 4. Mark Ш, Ч and stamp K as per AK-630, AK-630 TU I.



					AK-630 107-44			
Amend.	Sheet	Doc.No.	Sign	Date	Strip	Type	Weight	Scale
Developed by						A	1.460	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by					Sheet $\frac{B-PN-6GOST19903-74}{35-2GOST1577-93}$			

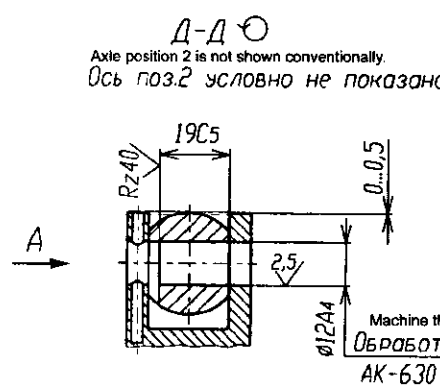
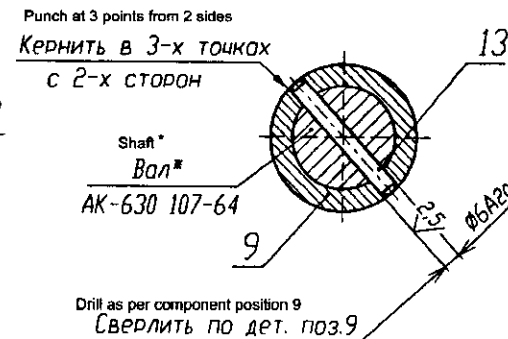
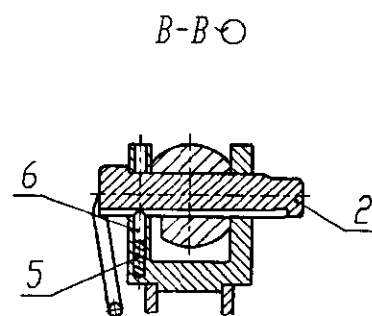
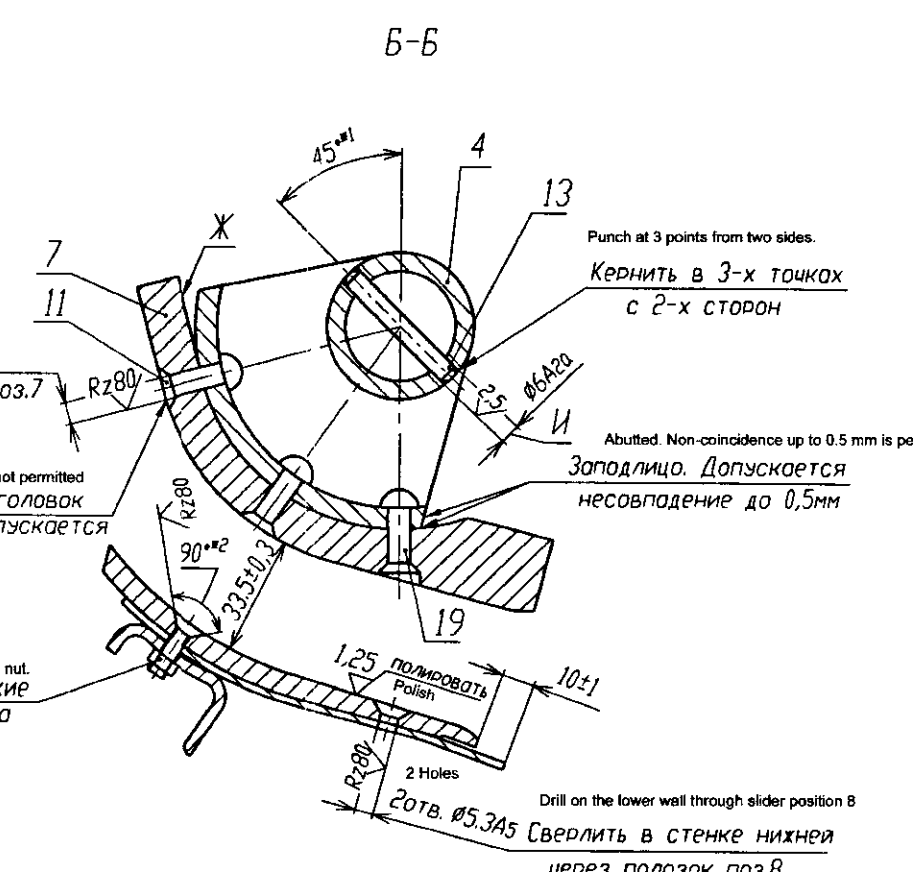
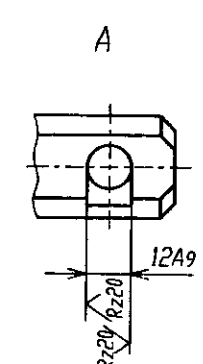
AK-630 107-45						
Approved OGMet	Orig. Inv. No.	Sign and Date	Alternate Inv. No.	Approved TOsb	Dupl. Inv. No.	
Approved KTONI	Sign and Date	Approved by shop	Reference No.	First use		
<p>1.* Reference dimension. 2. Tolerance on contour ~0.5 mm. 3. Blunt sharp edges R~0.6 mm. 4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.</p>						
AK-630 107-45						
				Type	Weight	Scale
Rib				A	0.055	1:1
				Sheet	Sheets 1	
				Sheet $B - PN - 8 GOST 19903 - 74$		
				35 - 2 GOST 1577 - 93		
		Copied by		Format A4		

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
								Documents
Reference No.	A1			AK-630 Sb107-13 SB	Assembly drawing			
	Assembly units							
	A4	1		AK-630 Sb107-16	Shaft	1		
	A4	2		AK-630 Sb107-17	Pin	2		
	A4	3		AK-630 Sb107-18	Collar	1		
	A4	14		AK-630 Sb107-19	Lock	1		
	Components							
	A3	4		AK-630 107-47	Support	1		
	A3	5		AK-630 107-48	Spring	2		
	A4	6		AK-630 107-49	Locator	2		
	A2	7		AK-630 107-50	Stop	1		
	A3	8		AK-630 107-51	Skid	1		
	A4	9		AK-630 107-52	Lock ring	1		
	A3	15		AK-630 107-93	Spring	1		
	A2	16		AK-630 107-94	Safety valve	1		
	A4	17		AK-630 107-95	Pin	1		
	Sign and Date	Alternate Inv. No.						
Sign and Date								
AK-630 Sb 107-13								
Orig. Inv. No.	Amend.	Sheet	Doc. No.	Sign	Date	Collar		
	Developed by					Type	Sheet	Sheets
	Checked by					A	1	2
	Head of Q.C.D							
	Approved by							



Punch at 3 points from 2 sides
Кернить в 3-х точках с 2-х сторон

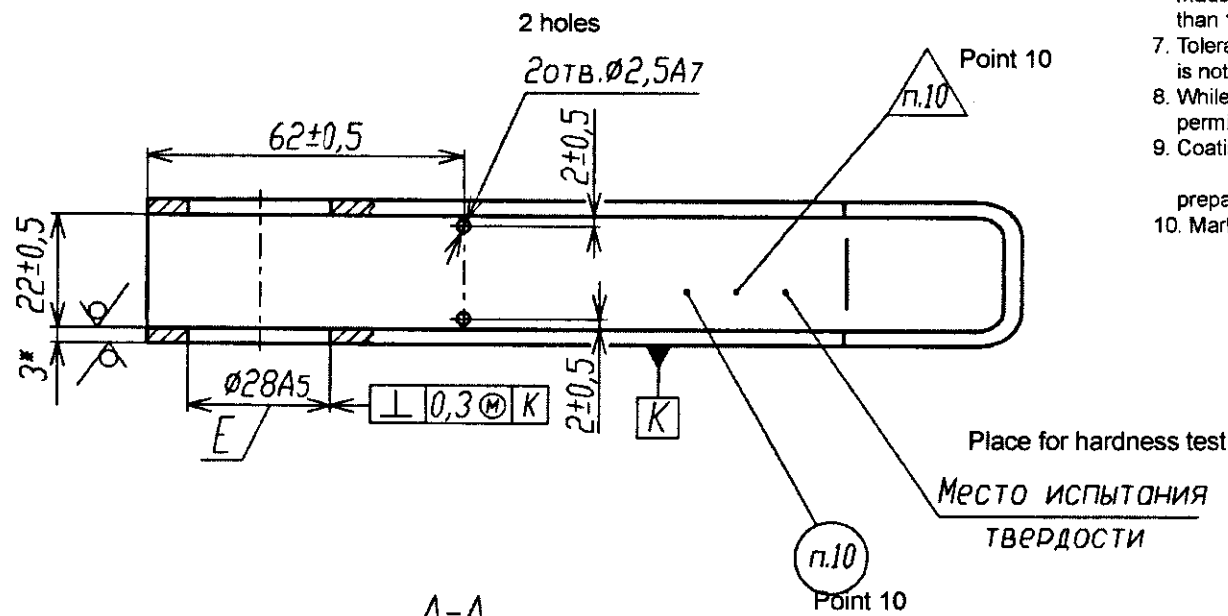
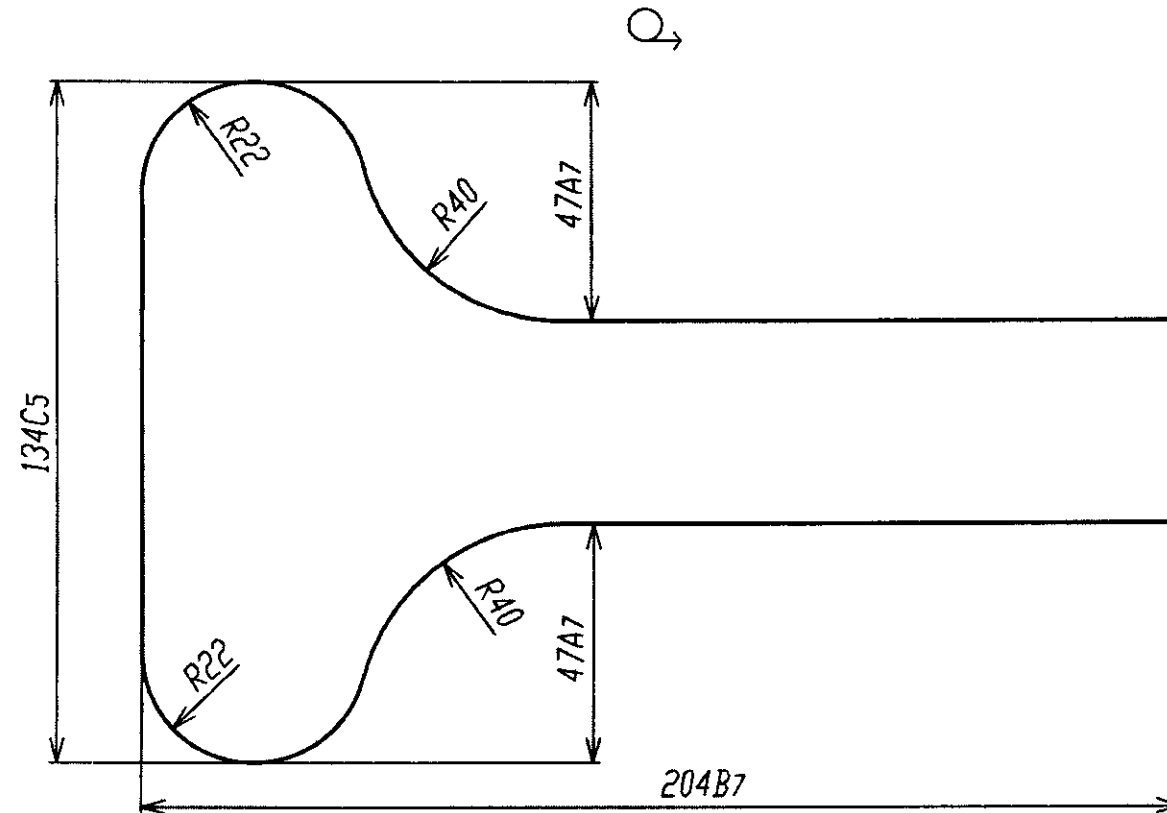
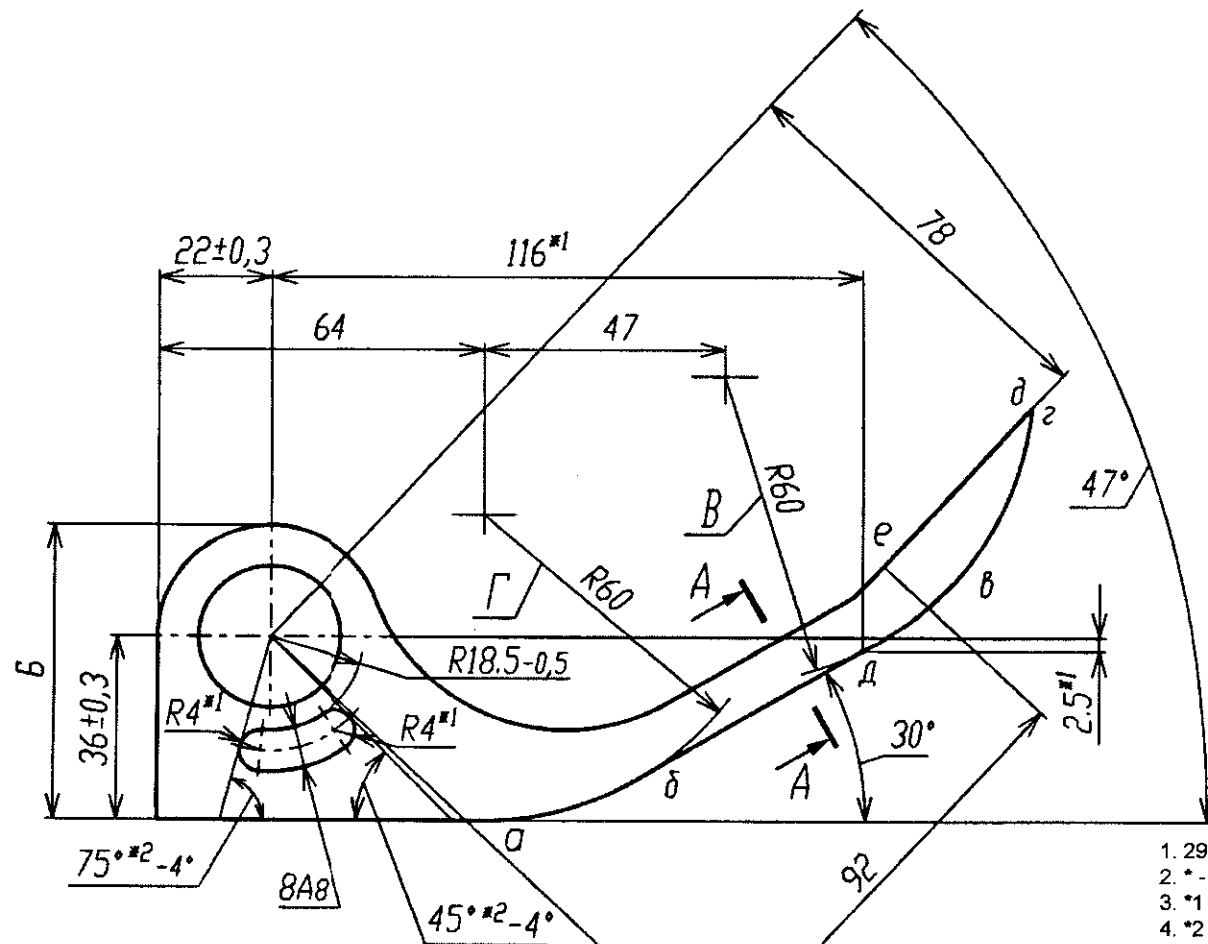
1. 38.5...44.5 HRCa of strip position 8 after the fitting.
2. * - Article for reference.
3. * 1 - Dimensions for reference.
4. * 2 - Dimensions are to be ensured by tool.
5. Before the drilling of hole VI, set the location of stop position 5 on the plane E. Sinking in of plane Ж from the plane E in respect of plane, which passes through the axis of hole K and in parallel to later one is 0.6...1 mm.



- 38,5...44,5 HRCa ползетка поз. 8 после пригонки.
- *Изделие для справок.
- *1 Размеры для справок.
- *2 Размеры обеспеченстр.
- Перед сверлением отв. И установить положение упора поз. 7 по плоскости E. Утопление плоскости Ж от плоскости E относительно плоскости, проходящей через оси отв. К и параллельно последней 0,6...1 мм.
- Для обеспечения размера 0,6...1 мм по п.5 допускается правка дет.107-76.
- Сборку Сб107-19 поз. 14 зафиксировать после установления размеров Р и П.
- Постановку упора поз. 7 и ползетка поз. 8 проверить шайкой-калибром со звеном: опертая звеном в боковую поверхность упора и отхотая к низу, шайка-калибр должно свободно проходить по всей головине. Соскакивание звена с упора не допускается.
- Острые ребра притупить: ползетка поз. 8 ~ 1 мм остальное ~ 0,6 мм.
- Покрытие после пригонки: ползетка поз. 8-Х24 вал АК-630 107-64-КА6.Фос. Лок БФ-4 с нигрозином, 1 слой, приготовление по ОСТ 3-4123-78, IV, OM2, кроме диаметра Ø30С.
- Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ I.

AK-630 Sb107-13 SB		AK-630 Сб107-13СБ	
Нек	Головина	Лист	Масса
Сборочный чертёж	Assembly Drawing	А	6,830
		Лист	Листов
		1	1

Изв. N 1000/1 Подл. и дата
 Изм. N 1000/2 Подл. и дата
 Изм. N 1000/3 Подл. и дата
 Изм. N 1000/4 Подл. и дата
 Изм. N 1000/5 Подл. и дата
 Изм. N 1000/6 Подл. и дата
 Изм. N 1000/7 Подл. и дата
 Изм. N 1000/8 Подл. и дата
 Изм. N 1000/9 Подл. и дата
 Изм. N 1000/10 Подл. и дата



1. 29...35.0 HRC±. Carry out the hardness check for 2 %.
2. * - Dimensions for reference.
3. *1 - Dimensions are ensured by tool.
4. *2 - Carry out the inspection of dimensions with respect to hole E and point D.
5. The height difference of the sides of dimension Б is not permitted for more than 0.5 mm.
6. Deviation of contour 'абвг' from the contour of template, which is made as per 5th class of accuracy GOST 2689-54, is not more than 1 mm.
7. Tolerance on contour 'де' with respect to hole E and point D is not more than 0.5 mm.
8. While bending on radiuses B and Г, the corrugations are permitted.
9. Coating: Cad. 12. Phos. Varnish BF-4 with nigrojin 1 layer. preparation as per OST 3-4123-78, IV, OM2.
10. Mark Ш, Ч and stamp К, И as per AK-630, AK-630M TU I.

1. 29...35,0 HRC±. Проверку твердости производить на 2%.
2. * Размеры для справок.
3. *1 Размеры обеспеч. INSTR.
4. *2 Контроль размеров производить относительно отверстия E и точки D.
5. Допускается разновысотность бортов по размеру Б не более 0,5 мм.
6. Отклонение контура 'абвг' от контура шаблона, изготовленного по 5-му классу точности ГОСТ 2689-54 не более 1 мм.
7. Допуск по контуру 'де' относительно отверстия E и точки D не более 0,5 мм.
8. При гибке по радиусам B и Г допускаются гофры.
9. Покрытие Кд12. фос. Лак БФ-4 с нигрозином 1 слой приготовление по OST 3-4123-78, IV, OM2.
10. Маркировать Ш, Ч и клеймить К, И по АК-630, АК-630М ТУ I.

Лев. перечень
Словарь
Подп. и дата
Изм. и дата
Взаминв.И
Изм. и дата
Изм. и дата

Bale 8 container 2

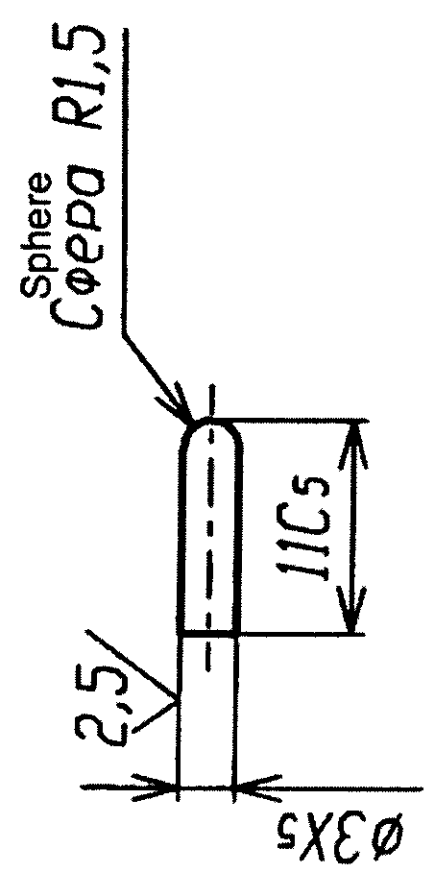
				AK-630 107-94		
				Лит.	Масса	Шкала
Safety Device / Fuse				А	0,250	1:1
Предохранитель						
В-РН-0 3 GOST 19903-74						
Sheet В-РН-0 3 ГОСТ 19903-74				Sheet Total sheets 1		
Лист К490В 4-III-35 ГОСТ 16523-97						
Утв. К 490В 4 III 35 GOST						

Формат А2

AK-630 107-49	
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Approved OGMet	Approved TOSb	Approved KTONI	Approved by shop
Sign and Date	Sign and Date	Sign and Date	Reference No.
Orig. Inv. No.	Alternate Inv. No.	Dupl. Inv. No.	First use

Rz40 (✓)



- 1.38.5...44.5 HRC_E. Check hardness on 3 -5% of the batch but not less than 3 nos.
2. Blunt sharp edges R~0.4 mm.
3. Coating Cd6.phos.
4. Mark Ш, Ч and stamp K, И on tag

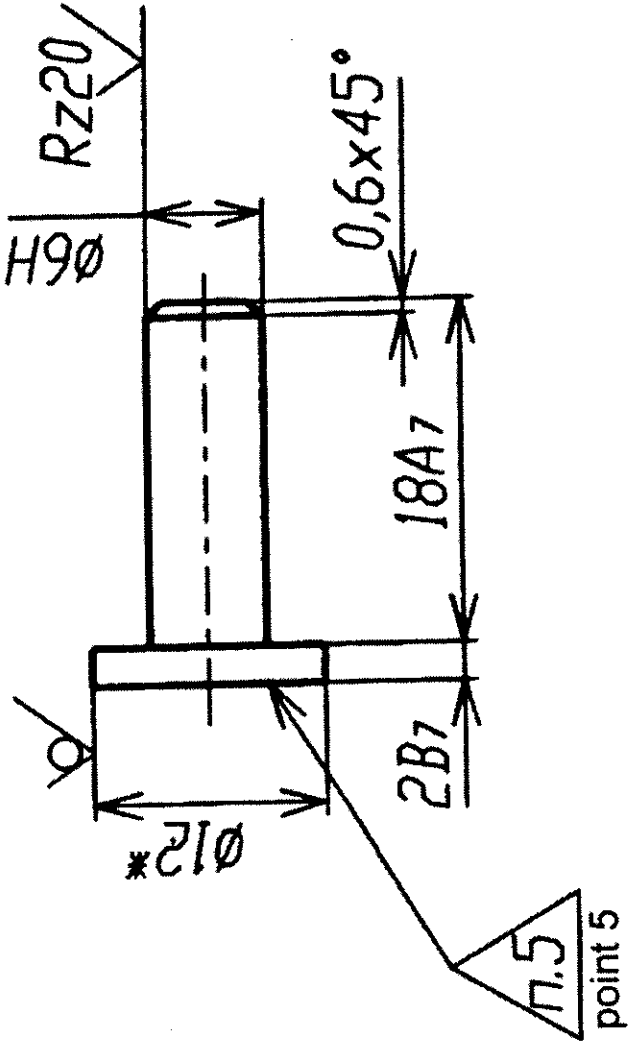
AK-630 107-49				
Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				
Type		Weight	Scale	
A		0.001	2:1	
Sheet		Sheets 1		
Locator pin		Steel 50		
		GOST 1050-88		

Format A4

Copied by

AK-630 107-95

RZ80 (✓)



1. 34...39.5 HRC_E. Check hardness on 3..5% of the batch, but not less than 3 nos.
- 2.* Reference dimension.
3. Blunt sharp edges $R \sim 0.6$ mm.
4. Coating Cd12.phos.
Lacquer BF-4 with Nigrosine , single coat, made as per OST 3-4123-78, IV, OM2.
5. Mark Ш, Ч on tag and Stamp K, И as per AK-630, AK-630M TU I.

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

AK-630 107-95			
Amend.	Sheet	Doc. No.	Sign
Developed by			Date
Checked by			
Head of Q.C.D			
Design bureau chief			
Head of Q.C.D			
Approved by			
Type		Weight	Scale
A		0.009	2:1
Sheet		Sheets 1	
Pin			
Wheel 12 - 5 GOST 7417 - 75			
50 - V - T GOST 1051 - 73			

Format A4

Copied by

First use

Reference No.

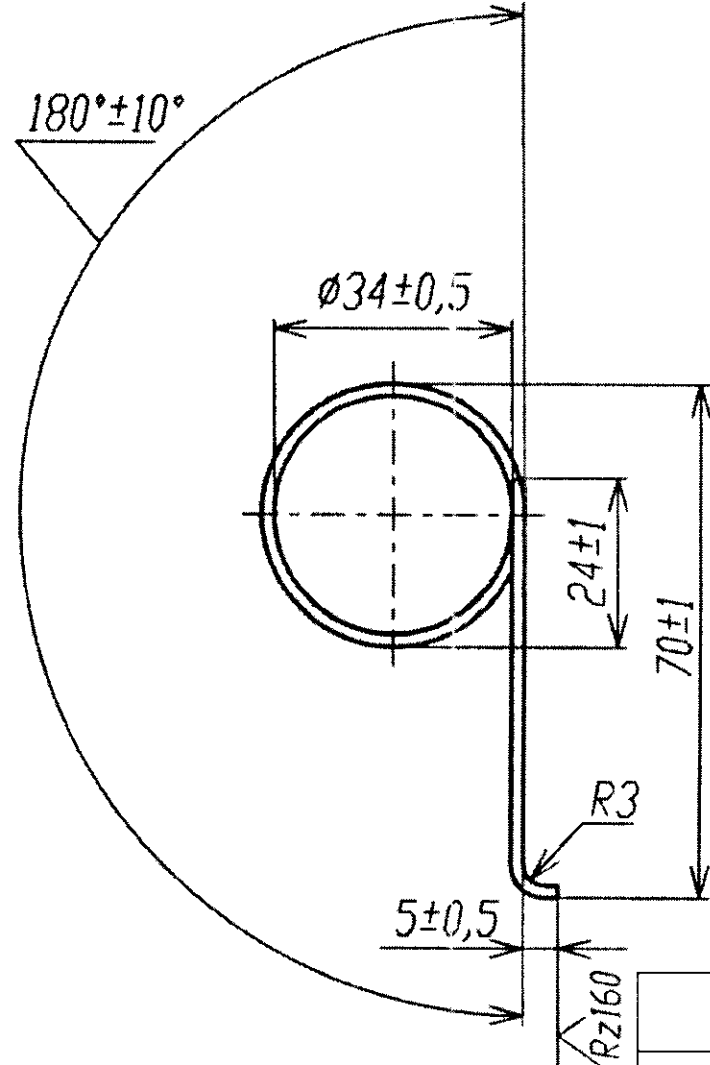
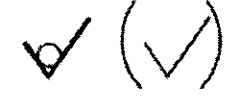
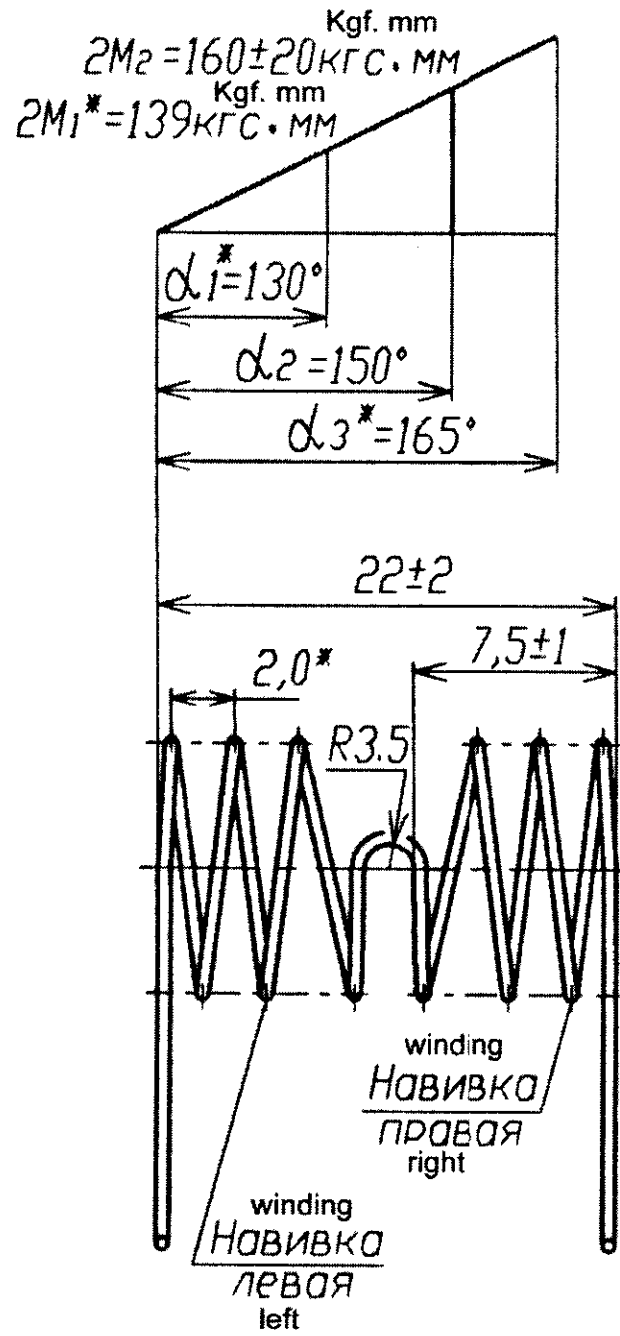
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. Group II.
2. $E^* = 20000 \text{ kgf/mm}^2$; $\sigma_z^* = 161 \text{ kgf/mm}^2$.
3. Length of uncoiled spring $L^* = 800 \text{ mm}$.
4. Coiling direction- right, left.
5. $n = 3+3$
6. Heat treatment : Tempering $240^\circ-260^\circ$.
7. Pre deformation time (at α_z) -12 hours
8. $D_s = 28 C_5$.
9. Coating: Chem.Phos. accel.
Lacquer BF-4 with Nigrosine, 2 coats, made as per OST 3-4123-78, IV, OM2.
- 10.* Dimensions and parameters for reference.
11. Other technical requirements as per OST 3-2561-91.
12. Mark Ш, Ч and stamp K, И on tag.

					AK-630 107-93			
Amend.	Sheet	Doc.No.	Sign	Date	Spring	Type	Weight	Scale
Developed by						A	0.030	
Checked by						Sheet	Sheets	1
Head of Q.C.D					Wire V-1-1.8 GOST 9389-75			
Approved by								

First use

Reference No.

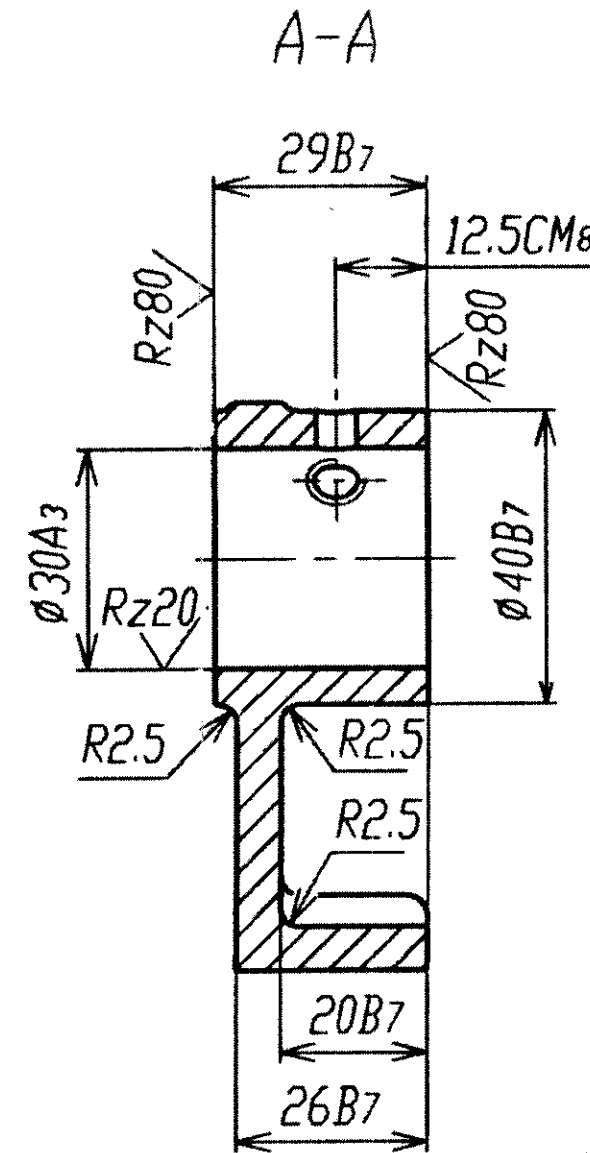
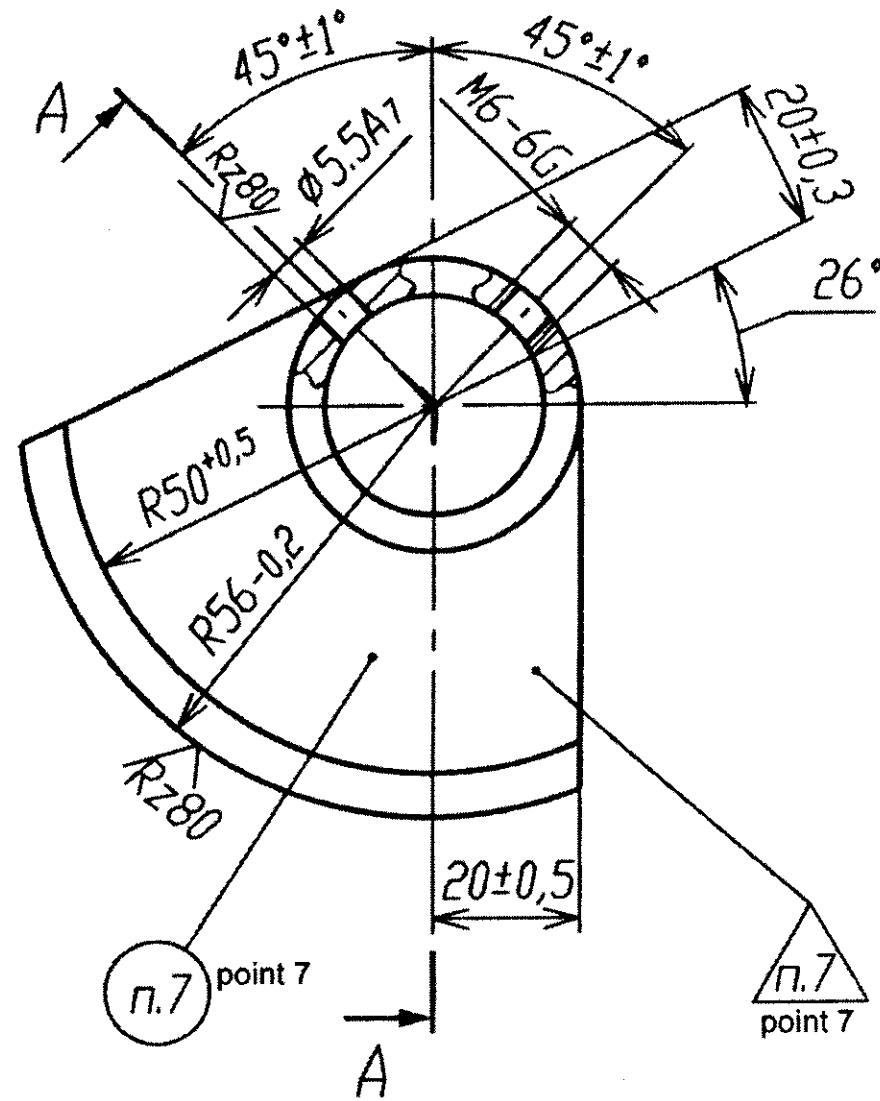
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



✓ (✓)

1. Accuracy of casting 8-0-0-7 GOST 26645-85.
2. Draft as per GOST 3212-92 toward increase in dimensions.
3. Surface finish of casting surfaces as per test specimen
4. 38.5...44.5 HRC_E.
5. Blunt sharp edges ~0.6 mm.
6. Coating Cd12, phos.
Lacquer BF-4 with Nigrozene, single layer, made as per OST 3-4123-78, IV. OM2.
7. Mark Ш, Ч, П and stamp К, И as per AK-630, AK-630M TU I.

					AK-630 107-47			
Amend.	Sheet	Doc.No.	Sign	Date	Support	Type	Weight	Scale
Developed by						A	0.330	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by					Casting	$\frac{K30 - II - OST3 - 4365 - 79}{50L - GOST977 - 88}$		

First use

Reference No.

Sign and Date

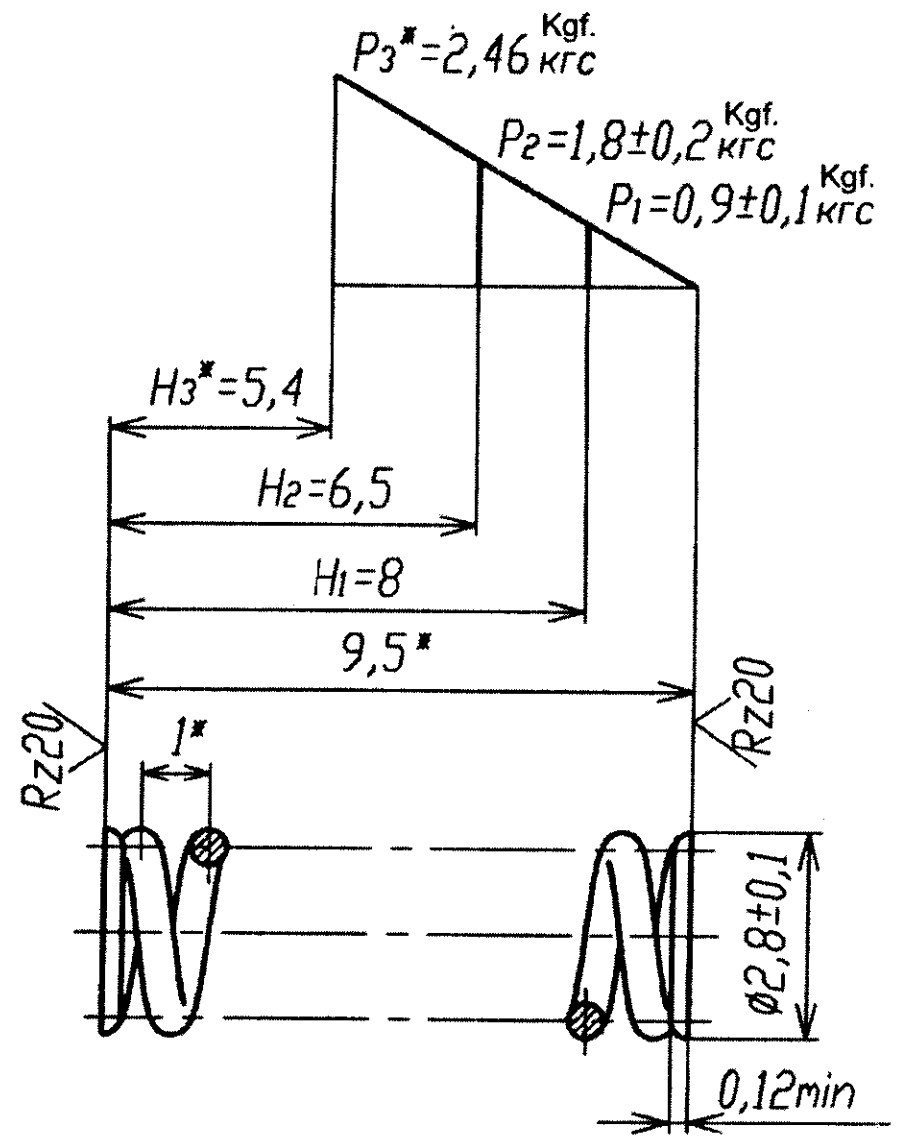
Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

✓ (✓)



1. Group III.
2. $G^* = 8000 \text{ kgf/mm}^2$; $\tau_z^* = 155 \text{ kgf/mm}^2$.
3. Length of uncoiled spring $L^* = 80 \text{ mm}$.
4. Coiling direction- right.
5. $n = 8.5$
6. $n_1 = 10.5 \pm 0.25$
7. Heat treatment : Tempering 240^0-260^0 .
8. $D_g = 3A_5$.
9. D_s
10. Pre deformation time (at N_z) -24 hours.
11. Coating: Chem.Phos. accel.Cr.
- Lacquer BF-4 with Nigrosine, 2 coats, made as per OST 3-4123-78, IV, OM2.
- 12.* Dimensions and parameters for reference.
13. Stamp K, И on tag.
14. Other technical requirements as per GOST 16188-70.
15. Mark Ш, Ч on tag.

					AK-630 107-48			
Amend.	Sheet	Doc.No.	Sign	Date	Spring	Type	Weight	Scale
Developed by						A	0.0003	10:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D						Wire V-1-0.5 GOST 9389-75		
Approved by								

First use

Reference No.

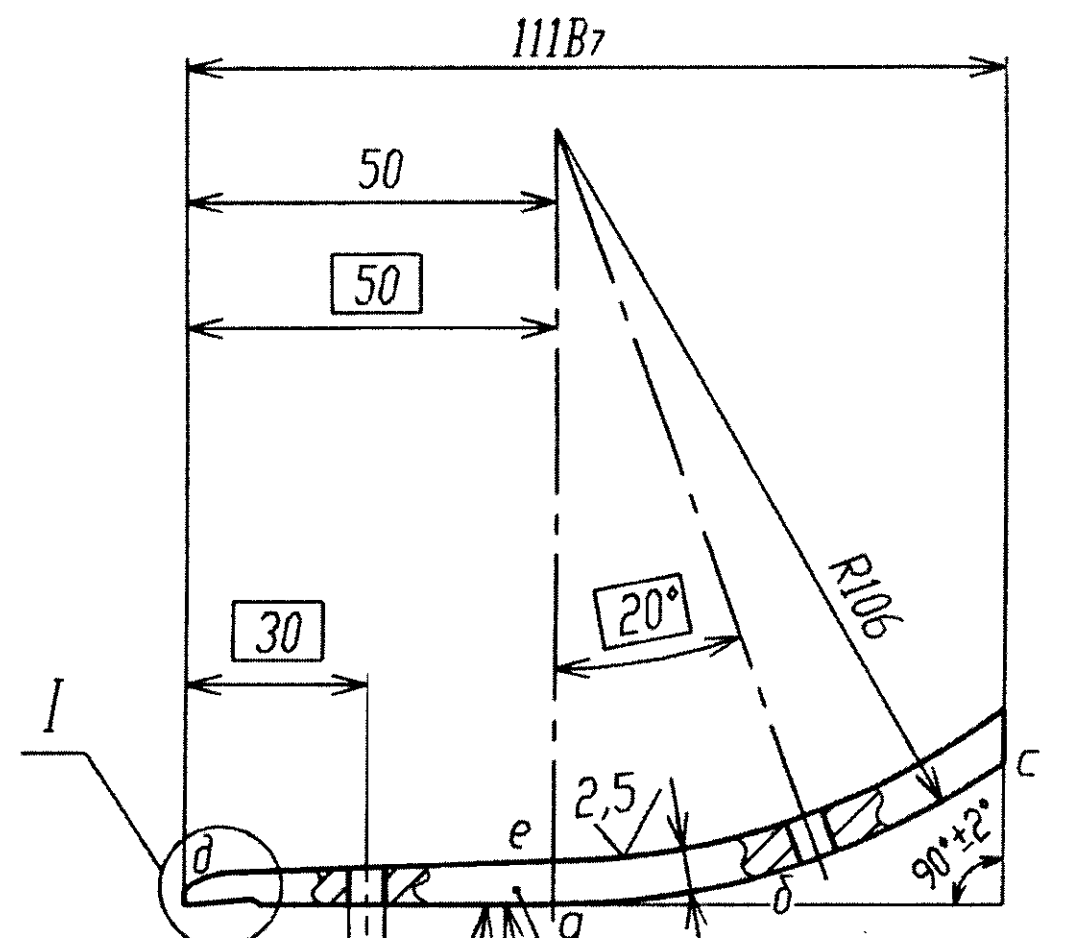
Sign and Date

Duplicate Inv. No

Alternate Inv. No

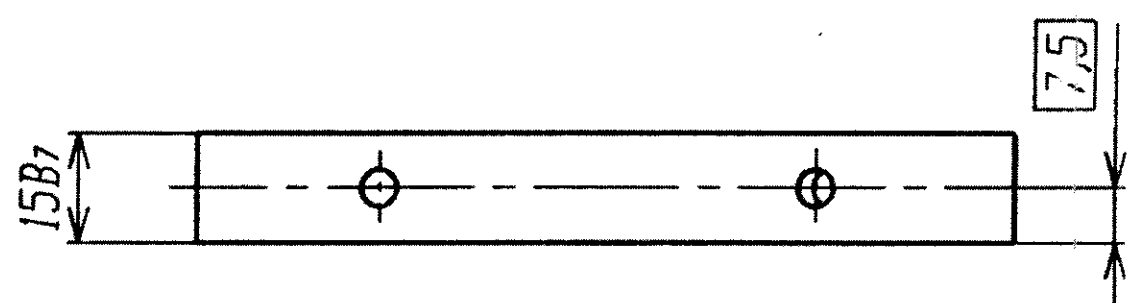
Sign and Date

Orig. inv. no.

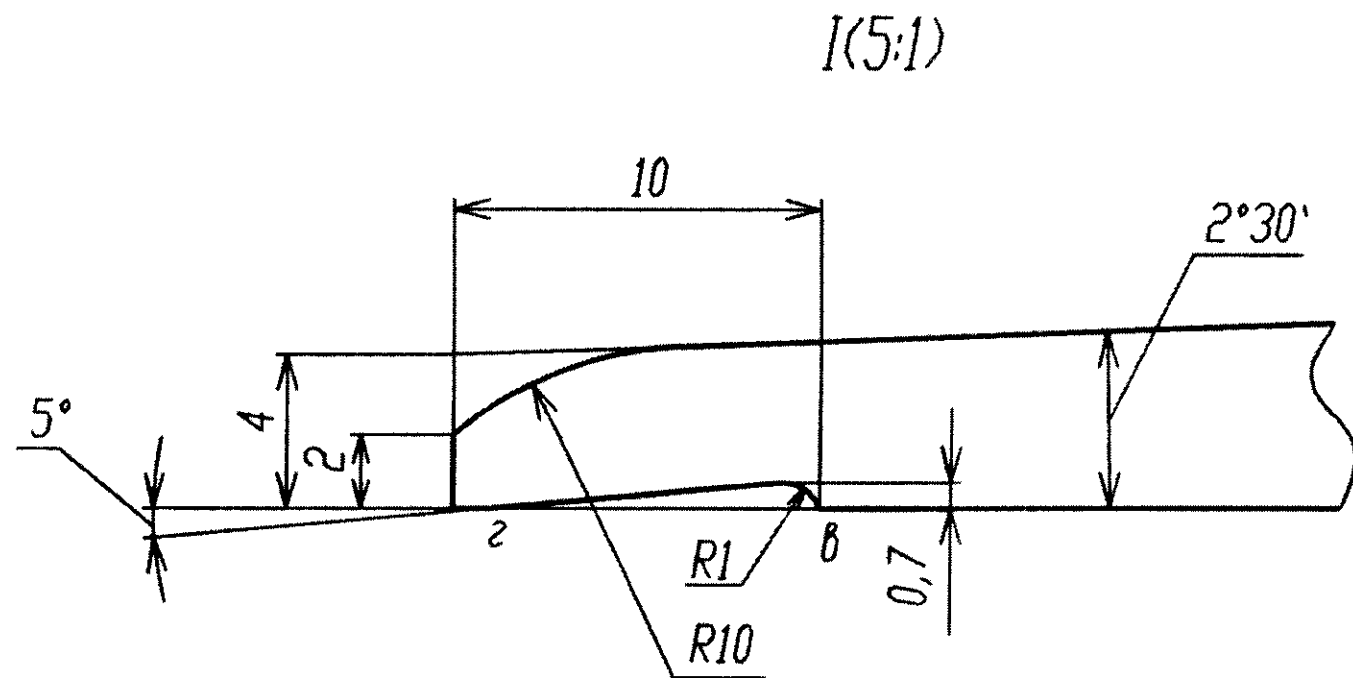


2 holes
2 ОТВ. Ø5.1A7
⊕ 0,3M *1

RZ80
п.6 point 6
п.6 point 6



Rz40 (✓)



1. Deviation of contour "abc" from contour of template, made as per 5 th accuracy class GOST 2689-54 is not more than 0.5 mm.
2. Tolerance for contour "br" "де" is 0.3 mm.
- 4.*1 Deviation given for tool.
5. Blunt sharp edges ~1 mm.
6. Mark Ш, Ч and stamp К, И as per AK-630, AK-630M TU I.

					AK-630 107-51			
Amend.	Sheet	Doc.No.	Sign	Date	Skid	Type	Weight	Scale
Developed by						A	0.065	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D						Steel 50 GOST 1050-88		
Approved by								

First use		Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
						<u>Documents</u>			
Reference No.		A3	/		AK-630 Sb107-16 SB	Assembly drawing			
		A3	/	1	AK-630 107-62	Roller	1		
		A3	/	2	AK-630 107-63	Shell	1		
		*)	/	3	AK-630 107-64	Shaft	1	*)A4 x 3	
		A4	/	4	AK-630 107-65	Gland shell	2		
		A4	/	5	AK-630 107-66	Gland	2		
						<u>Standard articles</u>			
Sign and Date				8		Rivet 4x12.03.15.029	3		
						GOST 10299-80			
				9		Bearing 942/30	2		
						GOST 4060-78			
Dupl. Inv. No.									
Alternate Inv. No.									
Sign and Date						AK-630 Sb 107-16			
Orig. Inv. No.		Amend.	Sheet	Doc. No.	Sign	Date			
		Developed by					Type	Sheet	Sheets
		Checked by					A		1
		Head of Q.C.D							
		Approved by							
							Shaft		

First use

Reference No.

Sign and Date

Duplicate Inv. No

Alternate Inv. No

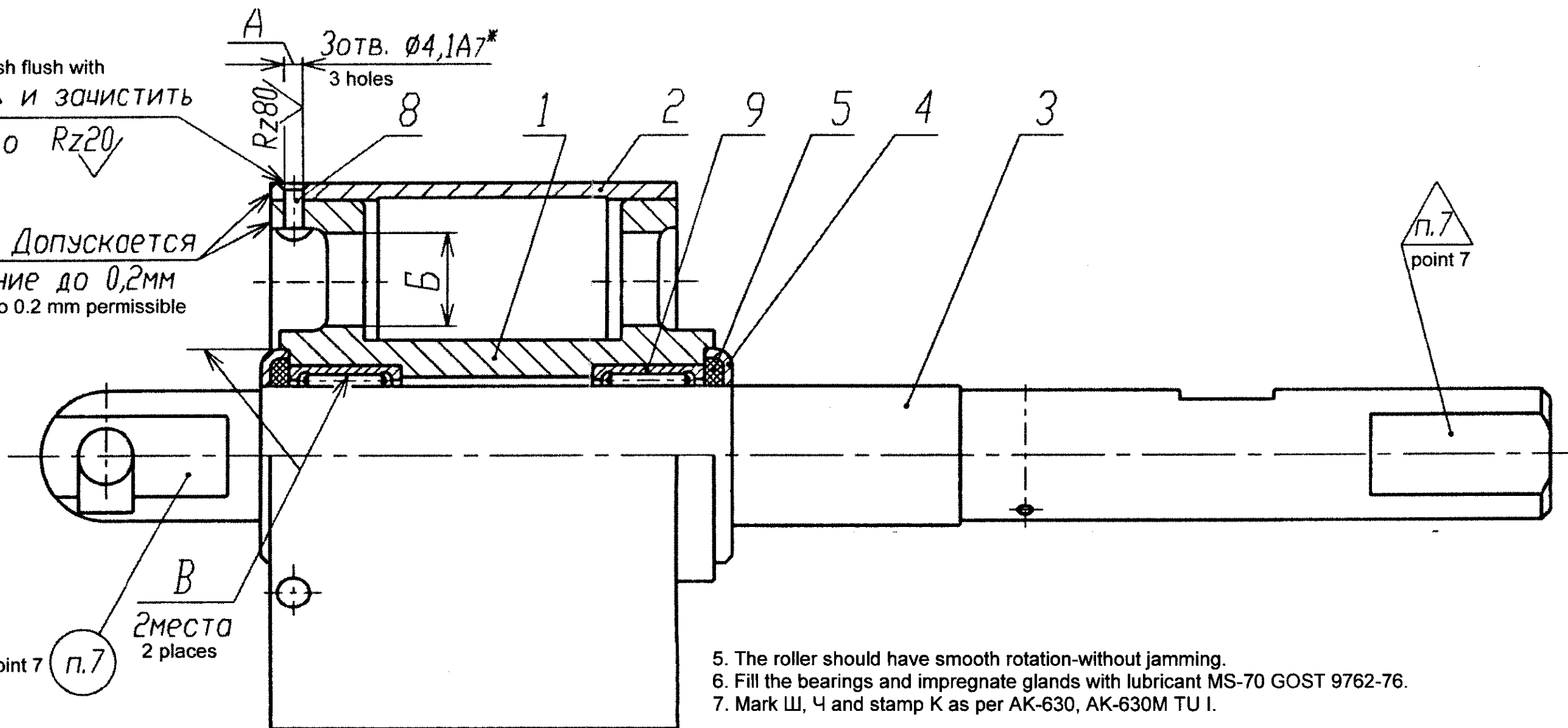
Sign and Date

Orig. inv. no.

Rivet and polish flush with
Расклепать и зачистить
 заподлицо Rz20

Flush with
Заподлицо. Допускается
 несовпадение до 0,2мм
 Misalignment upto 0.2 mm permissible

point 7 (п.7)
 2 места
 2 places



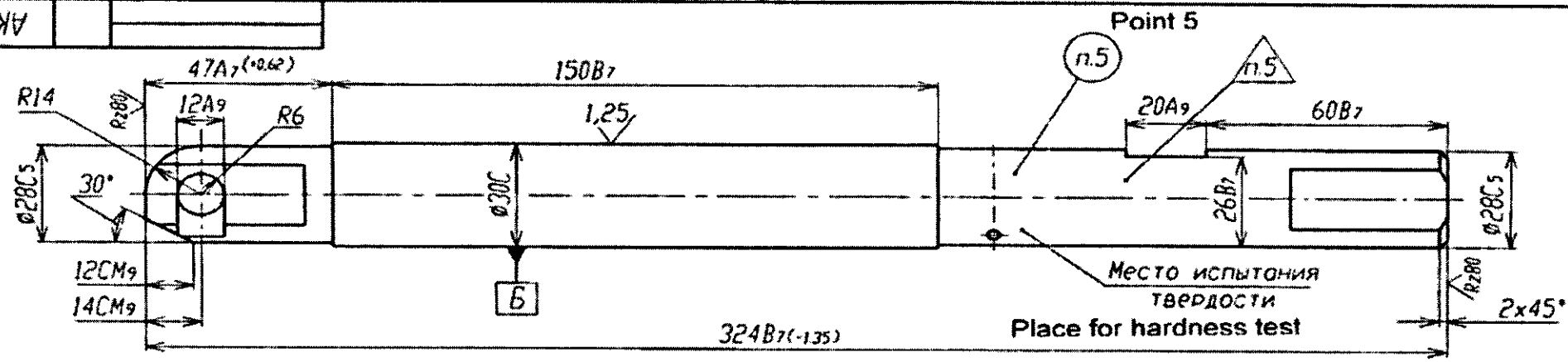
- 5. The roller should have smooth rotation-without jamming.
- 6. Fill the bearings and impregnate glands with lubricant MS-70 GOST 9762-76.
- 7. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

- 1.* Machine hole A together with shell pos.2.
- 2. Pos. of hole A with respect to hole B is arbitrary.
- 3. Coat components pos.1 and 2 after riveting and filing of rivets with:
 places of filing- Chem.Phos. accel. or primer VL-02 , colourless single coat, at localized places.
 Lacquer BF-4, black, made as per OST 3-4123-78, IV, OM2, except surface B.
 Primer VL-02 GOST 12707-77.
- 4. Send assembly for coating without components:
 AK-630 107-64, AK-630 107-65, AK-630 107-66 and bearings 942/30 GOST 4060-78. Carry out final assembly in
 AK-630 Sb107-13 SB after machining and coating of comp. AK-630 107-64.

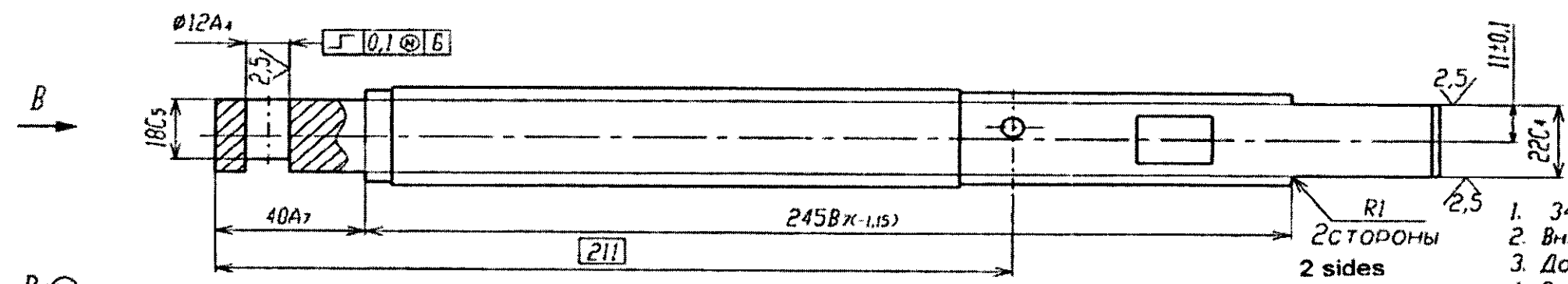
					AK-630 Sb 107-16 SB			
Amend.	Sheet	Doc.No.	Sign	Date	Shaft Assembly drawing	Type	Weight	Scale
Developed by						A	3.200	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by								

AK-630 107-64

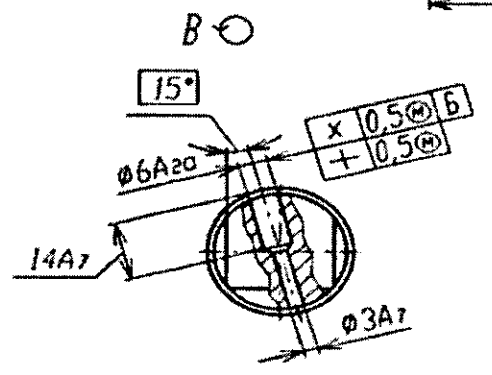
Rz40 (✓) (✓)



1. 34...39.5 HRC_с.
2. Internal angles $R \approx 0.4$ mm.
3. Retention of center hole is permitted.
4. Round off the sharp edges ~ 0.6 mm
5. Mark III, Ч and stamp K, И as per AK-630, AK-630 M TY I.



1. 34..39,5 HRC_с.
2. Внутренние углы $R \approx 0,4$ мм.
3. Допускается сохранение центров. отв.
4. Острые ребра притупить $R \approx 0,6$ мм.
5. Маркировать Ш, Ч и клеймить К, И по АК-630, АК-630М ТУ I.



AK-630 107-64				Type	Mass	Scale
Shaft				Лит	Масса	Масштаб
Вал				A	1,570	1:1
Steel 40 Kh GOST				Лист		
Сталь 40X ГОСТ4543-71				Sheet	Total Sheets	

First use

Reference No.

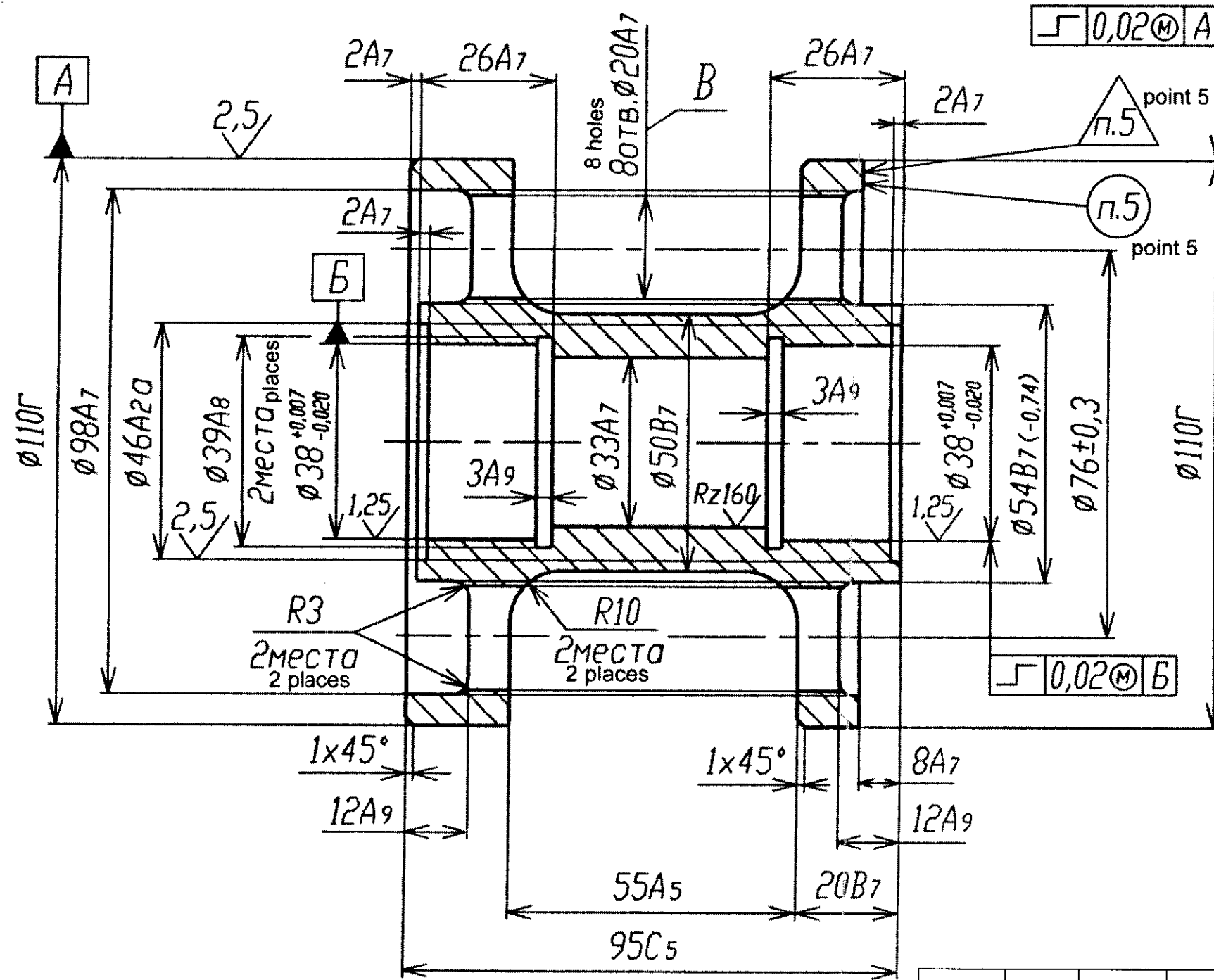
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



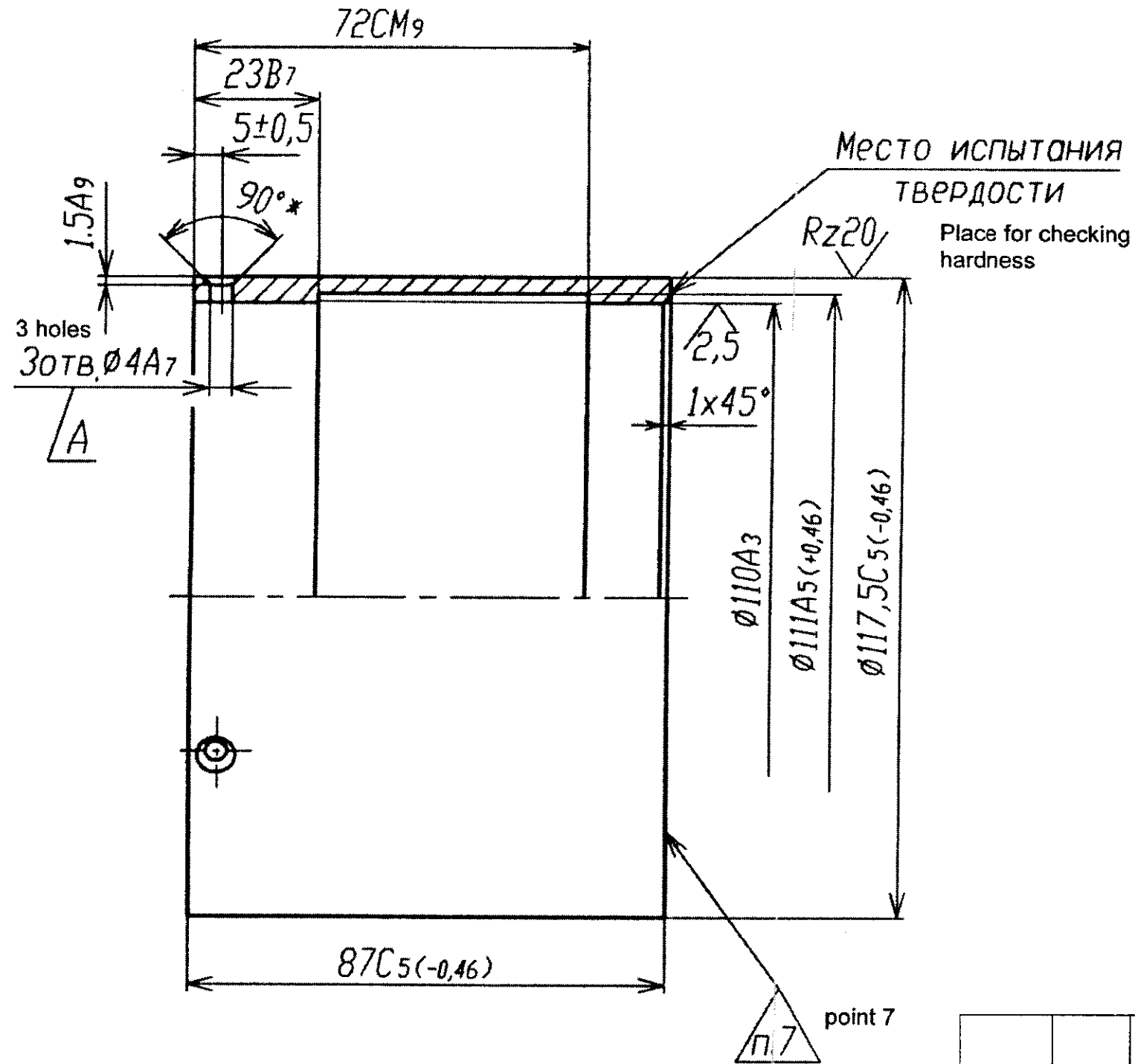
$Rz40$ (✓) (✓)

1. Inner angles $R \sim 0.4$ mm.
2. Holes B equidistant along circumference .
Tolerance for pitch and any number of pitches $\pm 1^\circ$.
3. Blunt sharp edges ~ 0.6 mm.
4. Coating : Anodic oxi.Cr.
5. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

AK-630 107-62

					AK-630 107-62			
Amend.	Sheet	Doc.No.	Sign	Date	Roller	Type	Weight	Scale
Developed by						A	0.57	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Rod V95 KR 130 GOST 21488-97			
Approved by								

Rz80 ✓ (✓)



1. 34..39.5 HRC_E.
 2. * Reference dimension.
 3. Holes A are placed along circumference at interval $120^{\circ} \pm 1^{\circ}$.
 4. Inner angles R~0.4 mm.
 5. Blunt sharp edges ~0.6 mm.
 6. Coating: cd 12. phos.
 7. Mark Ш, Ч on tag.
- Stamp K, И as per AK-630, AK-630M TU I.

First use

Reference No.

Sign and Date

Duplicate Inv. No

Alternate Inv. No

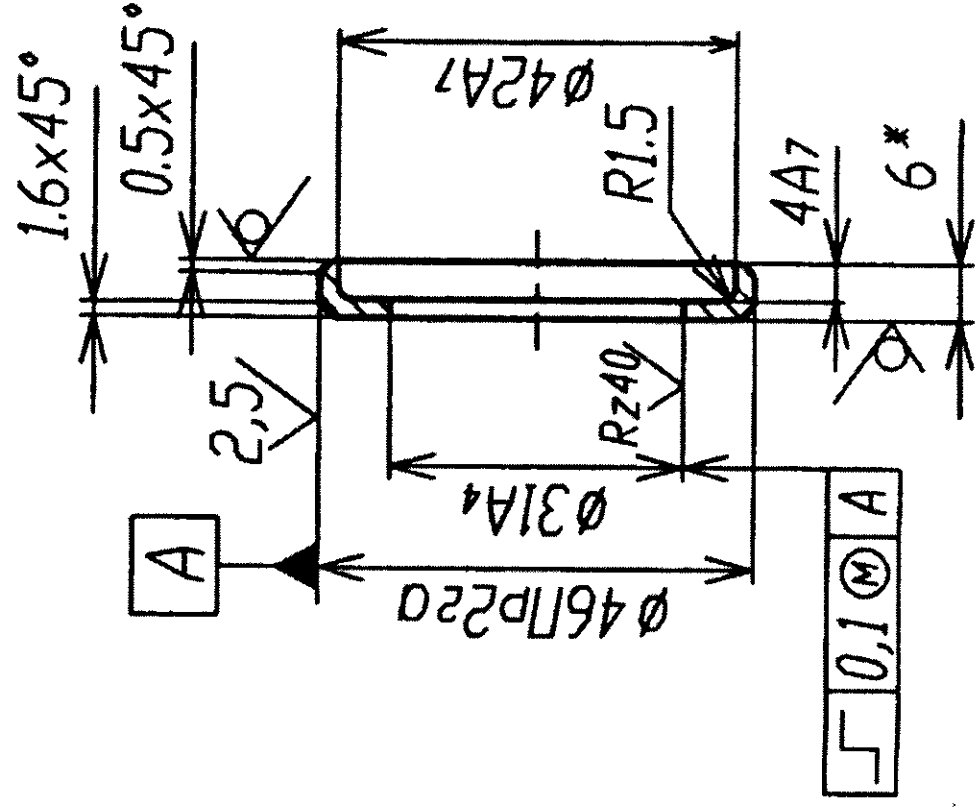
Sign and Date

Orig. inv. no.

					AK-630 107-63			
Amend.	Sheet	Doc.No.	Sign	Date	Shell	Type	Weight	Scale
Developed by						A	0.790	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D						Pipe $\frac{133 \times 16 \text{ GOST } 8732 - 78}{V45 \text{ GOST } 8731 - 74}$		
Approved by								

AK-630 107-65

RZ80 (✓)



1. 38.5...44.5 HRC_E. Check on 3..5% of the batch, but not less than 3 nos.
- 2.* Reference dimension.
3. Blunt sharp edges R~0.4 mm.
4. Coating Cd12.phos.
Lacquer BF-4 with Nigrosine, single coat, made as per OST 3-4123-78, IV OM2.
5. Mark Ш, Ч and stamp K, И on tag.

Approved OGMet	Approved TOsb	Approved KTONI	Approved by shop
Orig. Inv. No.	Sign and Date	Dupl. Inv. No.	Sign and Date
Amend.	Sheet	Doc. No.	Sign
Developed by	Date		
Checked by			
Head of Q.C.D			
Design bureau chief			
Head of Q.C.D			
Approved by			

AK-630 107-65

Gland shell	Type	Weight	Scale
	A	0.03	1:1
Sheet			Sheets 1
Sheet B - PN - 6 GOST 19903 - 74			
Sheet 50 - 2 - T GOST 1577 - 93			

Format A4

Copied by

First use

Reference No.

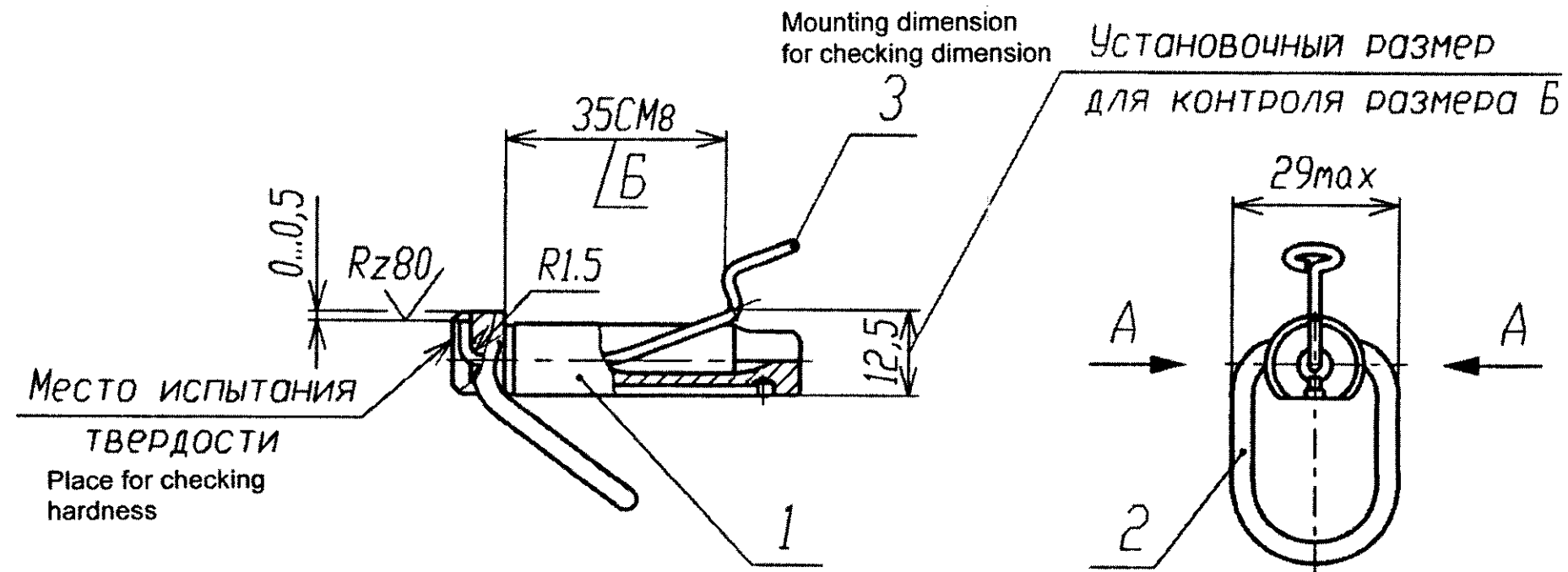
Sign and Date

Duplicate Inv. No

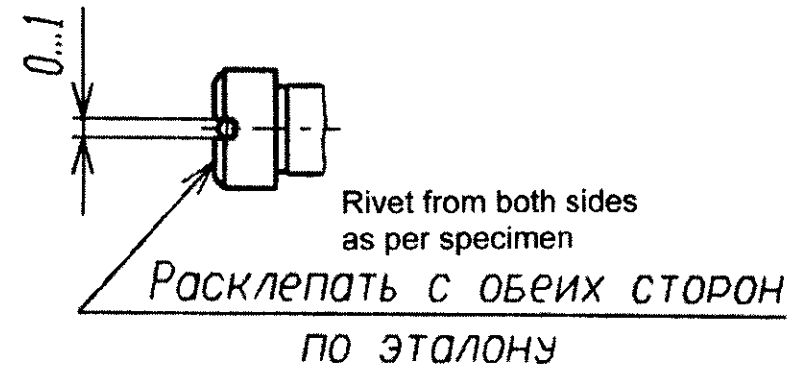
Alternate Inv. No

Sign and Date

Orig. inv. no.



Место испытания
ТВЕРДОСТИ
Place for checking
hardness



1. 38.5...44.5 HRC_E.
2. During heat treatment ,press ring of pin pos.2 as per indicators A.
3. Coating Cd6.phos.Oil.
Coat places of riveting with primer AK-070 GOST 25718-83.
4. Fit the retainer pos.3 after coating..
5. After riveting, oscillation of retainer is not permissible.
6. Mark Ш, Ч and stamp К, И on tag.

					AK-630 Sb 107-17 SB				
					Pin Assembly drawing		Type	Weight	Scale
							A	0.050	1:1
Amend.	Sheet	Doc.No.	Sign	Date			Sheet	Sheets 1	
Developed by									
Checked by									
Head of Q.C.D									
Approved by									

First use

Reference No.

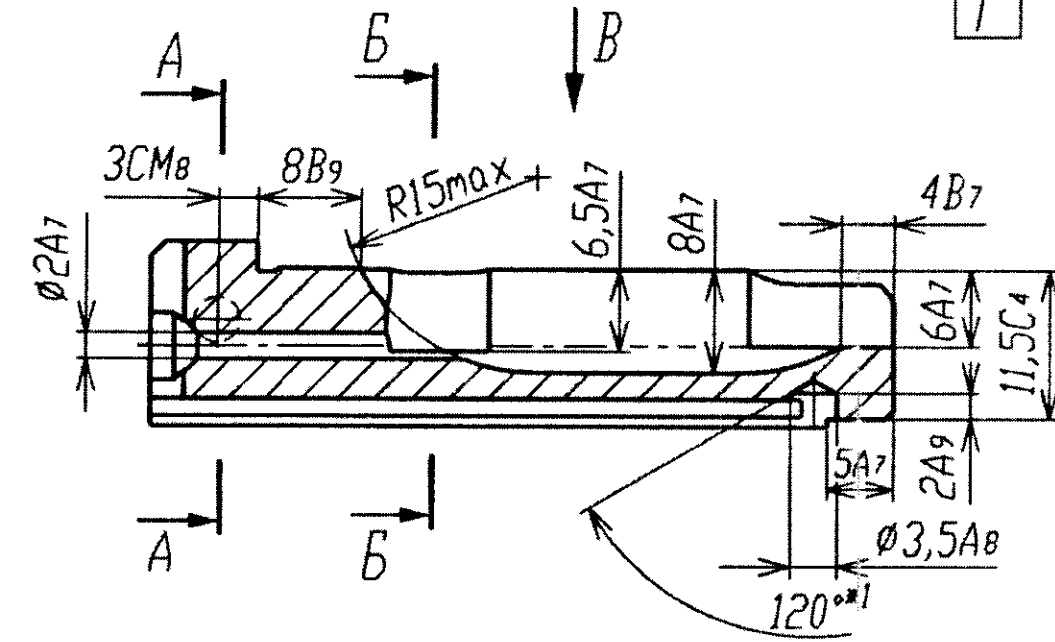
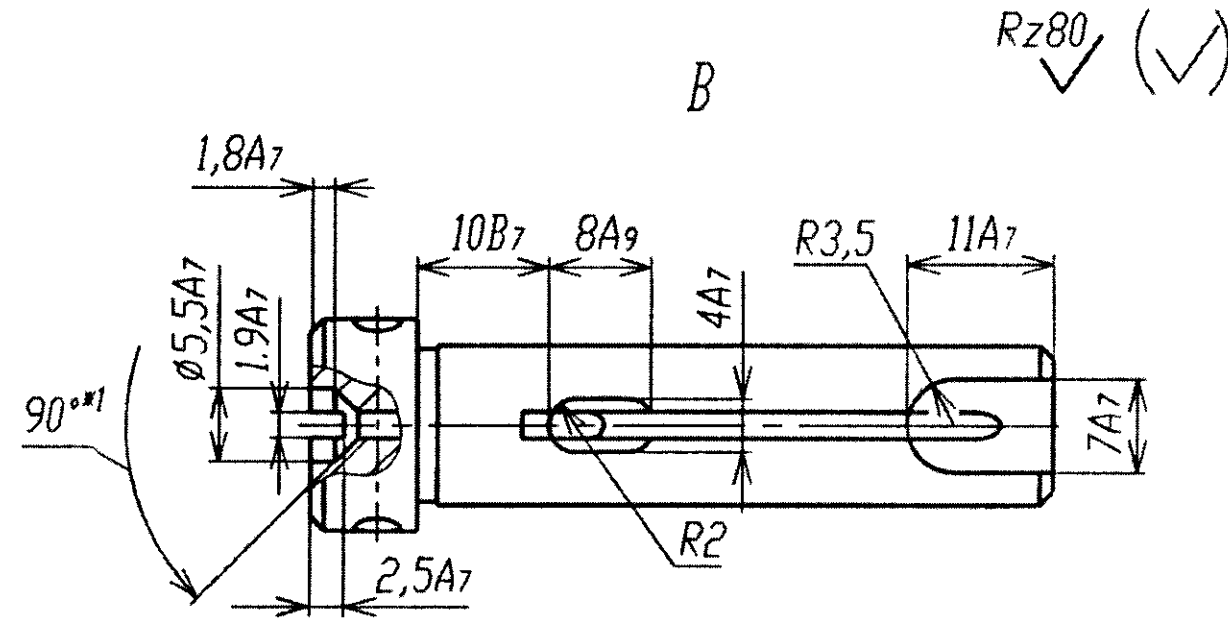
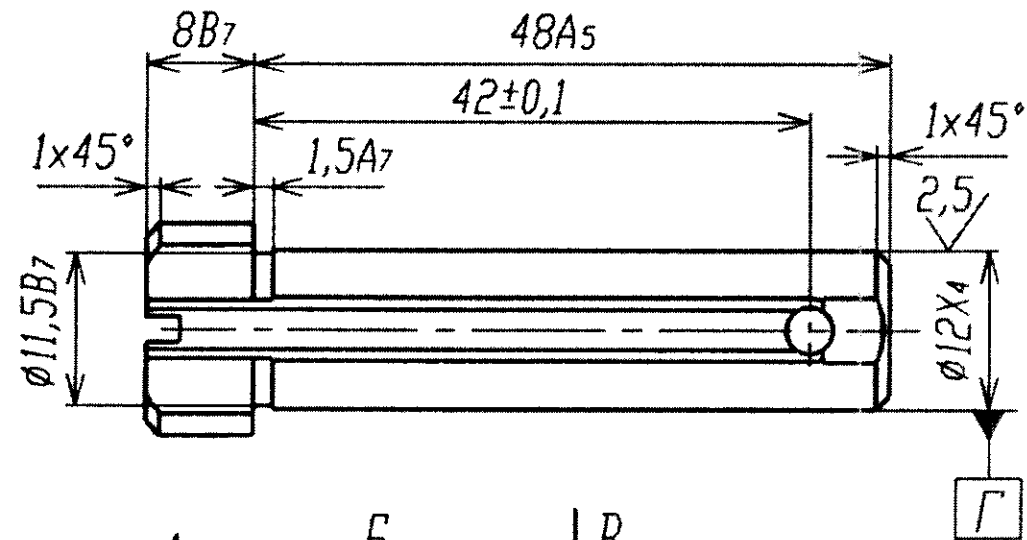
Sign and Date

Duplicate Inv. No

Alternate Inv. No

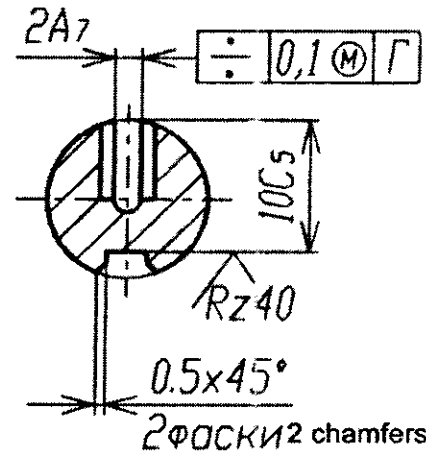
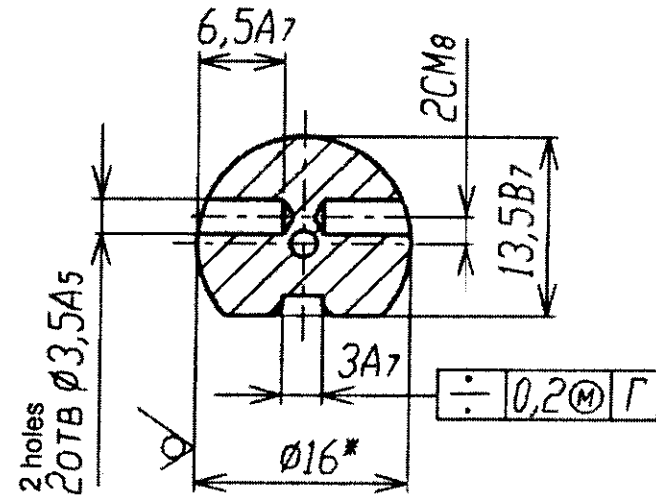
Sign and Date

Orig. inv. no.



A-A

B-B



- 1.* Reference dimension.
- 2.*1 Dimension ensured by tool.
3. Inner angles R~0.4 mm.
4. Blunt sharp edges R ~0.6 mm.
5. Mark Ш, Ч and stamp K on tag.

AK-630 107-70

Amend.	Sheet	Doc.No.	Sign	Date	AK-630 107-70			
					Pin	Type	Weight	Scale
						A	0.45	2:1
						Sheet	Sheets 1	
					Head of Q.C.D			
					Approved by			
					Wheel	16 - 5 GOST 7417 - 75 50 - T - V GOST 1051 - 73		

AK-630 107-71

First use

Approved by shop
Reference No.

Approved KTONI
Sign and Date

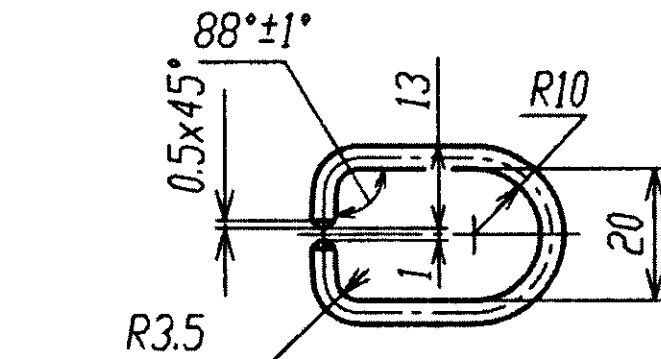
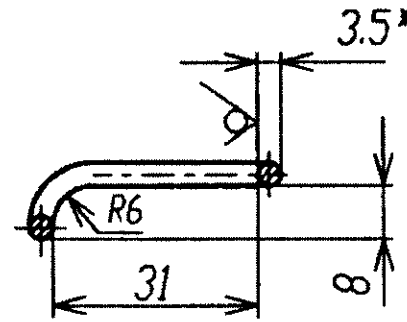
Approved TOSb
Dupl. Inv. No.

Approved Inv. No.

Sign and Date

Approved OGMet
Orig. Inv. No.

Rz80 (✓)



НЕ В ПРОЕКЦИИ Not in projection

- 1.* Reference dimension.
- 2. Tolerance on contour of component ~ 1 mm.
- 3. Mark Ш, Ч and stamp K on tag.

Amend.	Sheet	Doc. No.	Sign	Date

AK-630 107-71

Ring pin

Type	Weight	Scale
A	0.006	1:1

Wheel 3.5 - 5GOST7417 - 75
40Kh - T - V GOST 1051 - 73

Copied by

Format A4

AK-630 107-72			
Approved OGMet	Approved TOSb	Approved KTONI	Approved by shop
Orig. Inv. No.	Alternate Inv. No.	Sign and Date	Reference No.
Design bureau chief	Head of Q.C.D	Dupl. Inv. No.	First use
Checked by	Developed by	Sign and Date	
Amend.	Sheet	Doc. No.	
		Sign	
		Date	

Rz80 (✓)

1. Heat treatment- tempering 240...260°C.
 2.* Reference dimension.
 3. Coating Cd6.phos.Oil.
 4. Mark Ш, Ч and stamp K, И on tag.

AK-630 107-72				
Locator		Type	Weight	Scale
		A	0.010	2:1
Wire V-I-1.8 GOST 9389-75		Sheet		Sheets 1

Copied by

Format A4

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
					<u>Documents</u>			
Reference No.	A1			AK-630 Sb107-12 SB	Assembly drawing			
					<u>Components</u>			
					*			
	*)		1	AK-630 107-73	Lower wall	1	*)A4x3	
	A3		2	AK-630 107-74	Rear wall	1		
	*)		3	AK-630 107-75	Front wing	1	*)A4x3	
	A3		4	AK-630 107-76	Rear wing	1		
	A3		5	AK-630 107-77	Front support	1		
	A3		6	AK-630 107-78	Rear support	1		
	A3		7	AK-630 107-79	Left lug	1		
	A3		8	AK-630 107-80	Front rib	1		
	A3		9	AK-630 107-81	Rear rib	1		
	A4		10	AK-630 107-82	Front brace	1		
	A4		11	AK-630 107-83	Rib	1		
	A3		12	AK-630 107-84	Right lug	1		
	Dupl. Inv. No.	A3		13	AK-630 107-85	Front wall	1	
		A4		14	AK-630 107-86	Rib	1	
A3			15	AK-630 107-87	Lug	1		
A3			16	AK-630 107-88	Rib	1		
Alternate Inv. No.	A3		17	AK-630 107-89	Lug	1		
Sign and Date	AK-630 Sb 107-18							
	Amend.	Sheet	Doc. No.	Sign	Date			
Orig. Inv. No.	Developed by					Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D							
	Approved by							
Collar								

First use

Reference No.

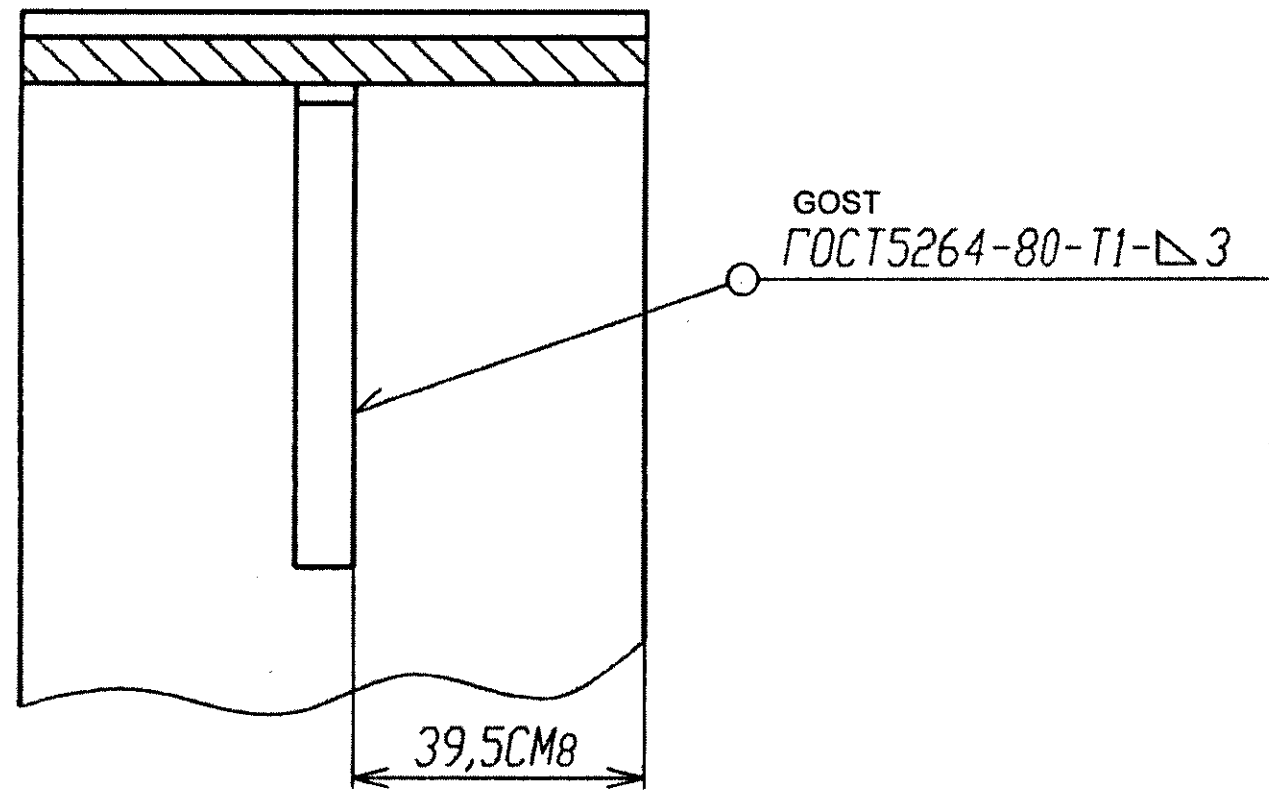
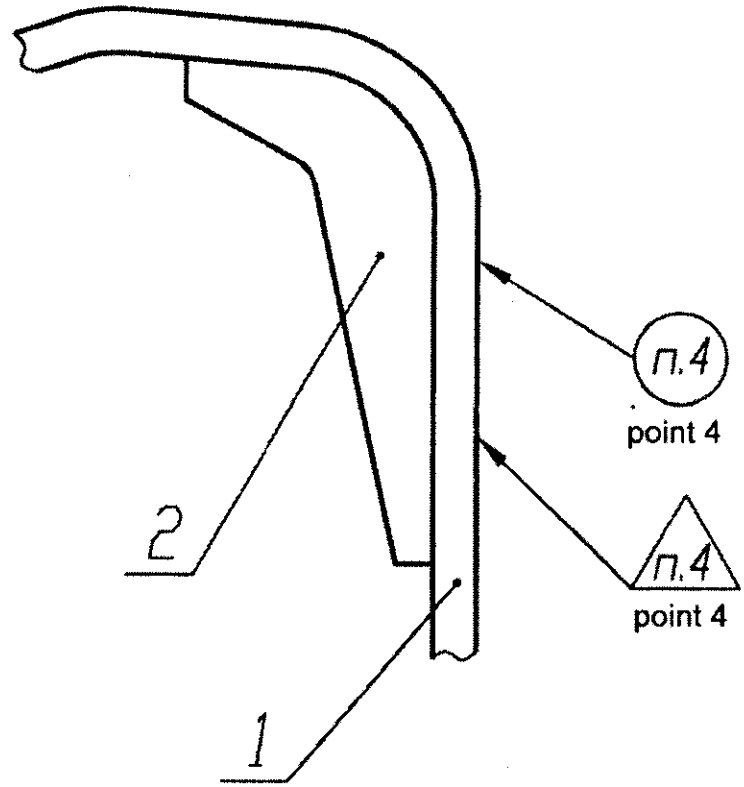
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. Welding rod 13/45-2.0-3 GOST 9466-75.
2. Semi automatic welding in carbon dioxide medium by using filler wire 1.2 Sv-08 G2S 2246-70 is permissible.
3. Deviation of contour AK-630 107-44, after making assembly, from contour of template made as per 5 th accuracy grade- 2 mm.
4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 Sb 107-12 SB			
Amend.	Sheet	Doc.No.	Sign	Date	Strip Assembly drawing	Type	Weight	Scale
Developed by						A	1.840	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by								

AK-630 107-82					
Approved OGMet	Approved by shop	Approved KTONI	Approved TOsb	First use	
Orig. Inv. No.	Alternate Inv. No.	Sign and Date	Dupl. Inv. No.	Reference No.	
Head of Q.C.D.	Design bureau chief	Sign and Date	Sign and Date	Sign and Date	
Checked by	Developed by	Amend.	Sheet	Doc. No.	Sign
Approved by	Head of Q.C.D.	Date	Date	Date	Date

Rz80, (✓) (✓)

1. * Reference dimension.
 2. Tolerance on contour "абв" – 0.5 mm.
 3. Blunt sharp edges R~0.6 mm.
 4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

AK-630 107-82				
Front brace		Type	Weight	Scale
		A	0.025	1:1
		Sheet	Sheets 1	
Sheet <i>B - PN - 03 GOST 19903 - 74</i>				
<i>K 490V 4 - III - 35 GOST 16523 - 97</i>				

Copied by

Format A4

AK-630 107-86

First use

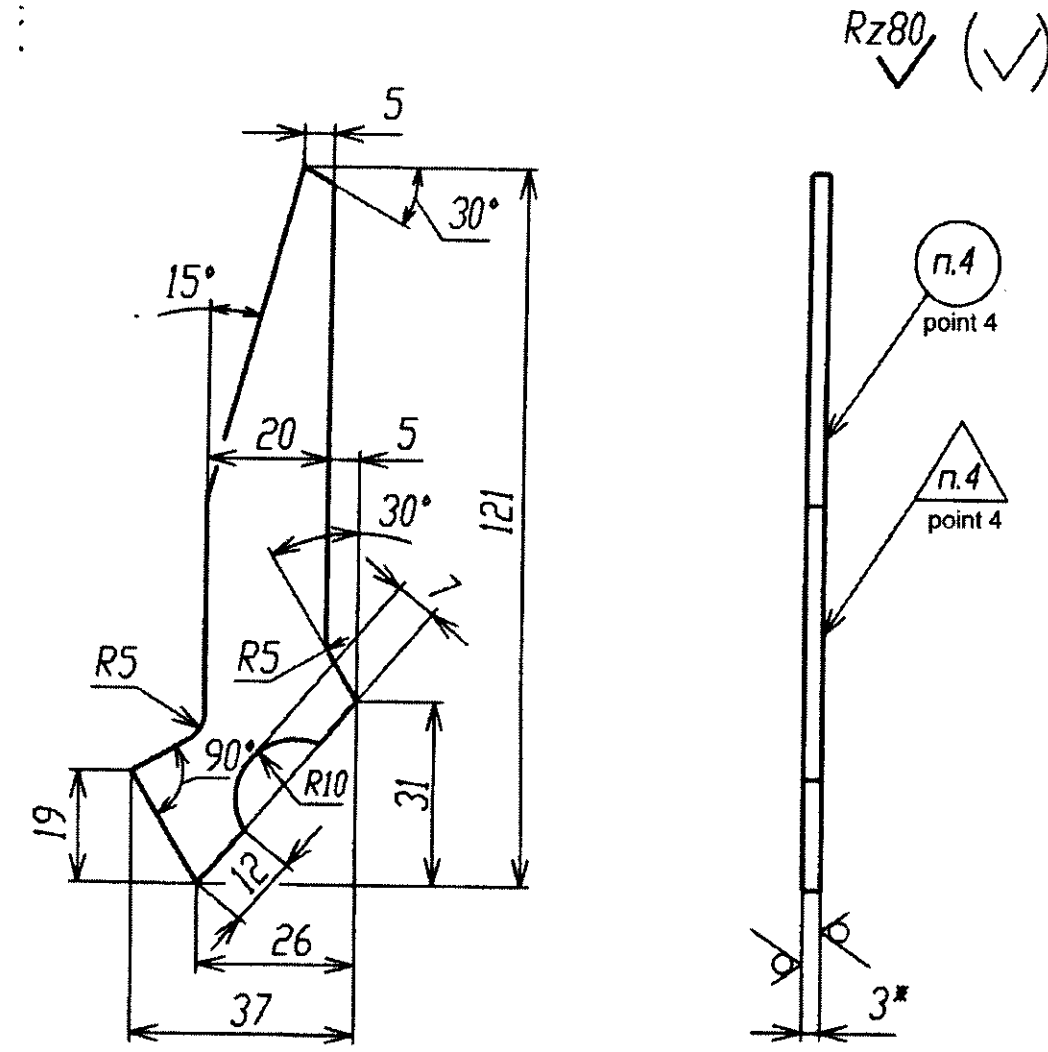
Approved by shop
Reference No.

Approved KTONI
Sign and Date

Approved TOSb
Dupl. Inv. No.

Sign and Date

Approved OGMet
Orig. Inv. No.



- 1.* Reference dimension.
- 2. Tolerance on contour - 0.5 mm.
- 3. Blunt sharp edges R~0.6 mm.
- 4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

Amend.	Sheet	Doc. No.	Sign	Date

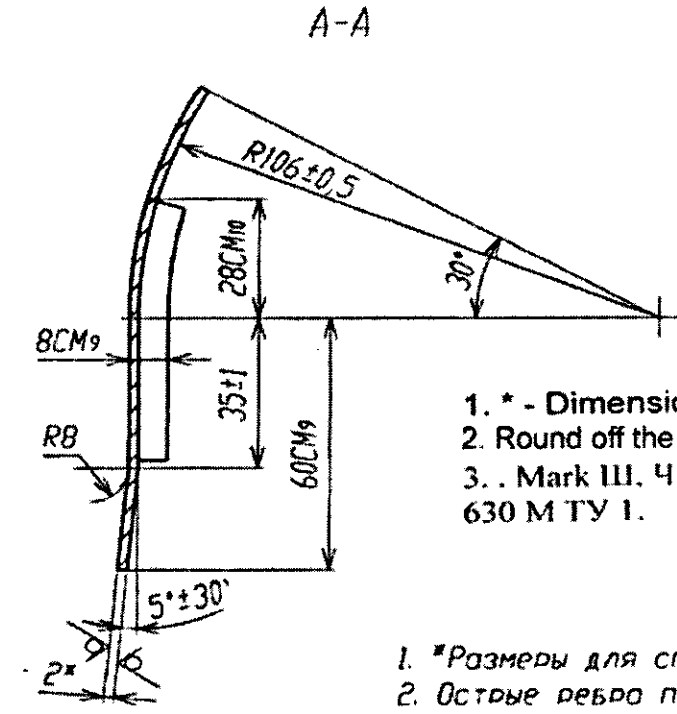
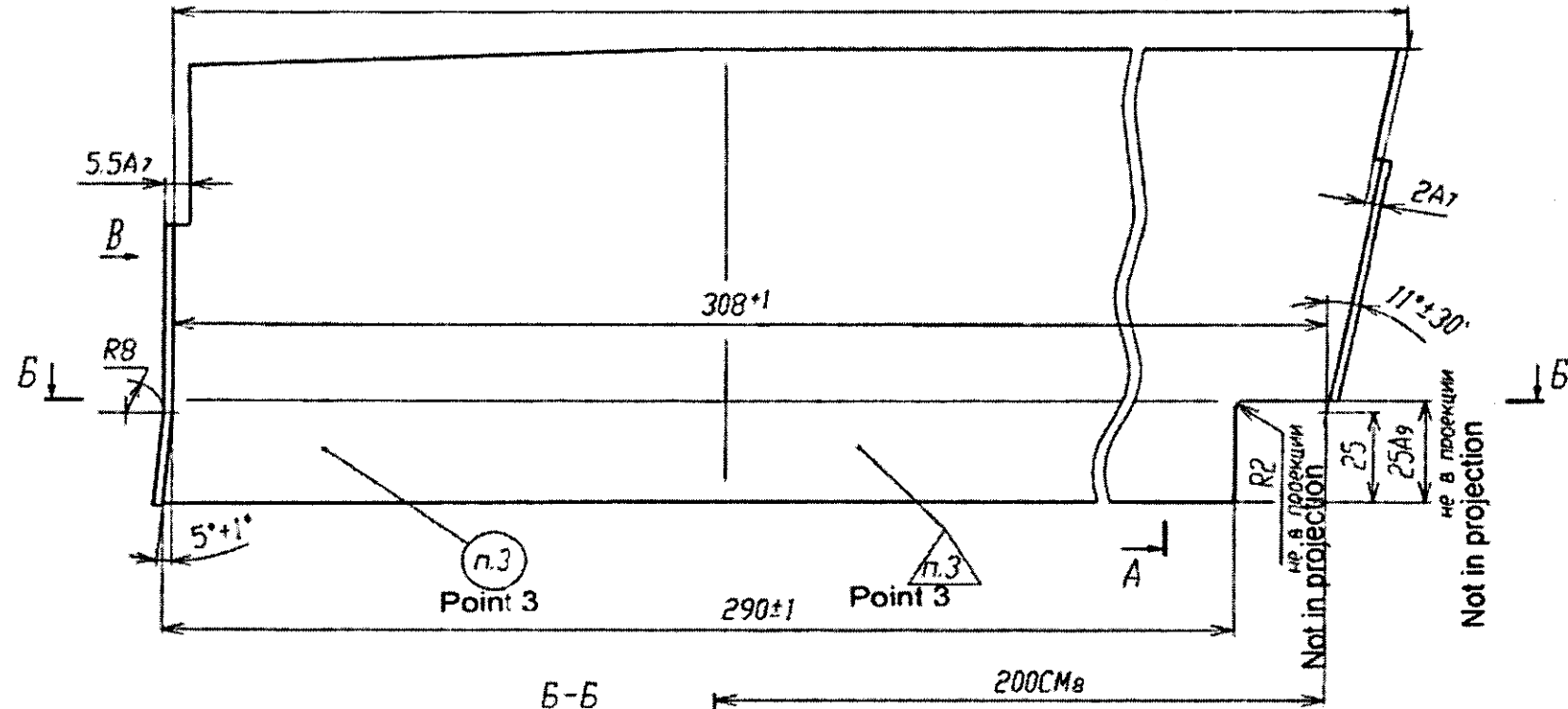
AK-630 107-86			
Type	Weight	Scale	
Rib	A	0.040	1:1
Sheet	Sheets 1		
Sheet	B - PN - 03 GOST 19903 - 74		
Sheet	K 490V 4 - III - 35 GOST 16523 - 97		

AK-630 107-73

326*

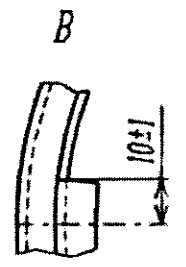
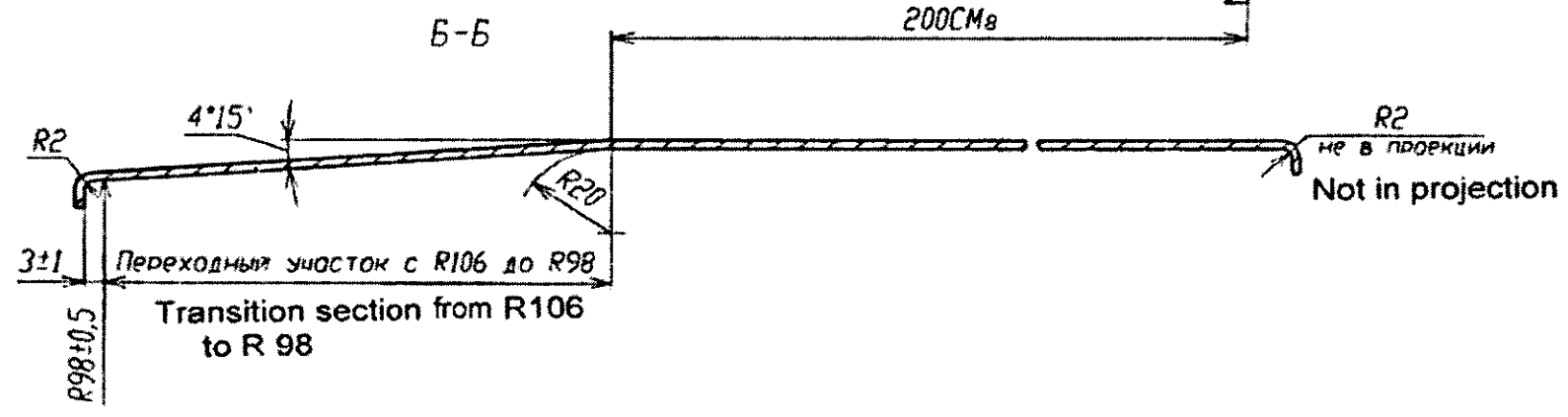
A

Rz80 (✓)



1. * - Dimensions for reference.
2. Round off the sharp edges ~ 0.6 mm
3. Mark Ш, Ч and stamp K as per AK-630, AK-630 M TY 1.

1. *Размеры для справок.
2. Острые ребра притупить ~ 0,6 мм.
3. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ 1.

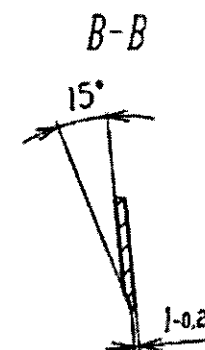
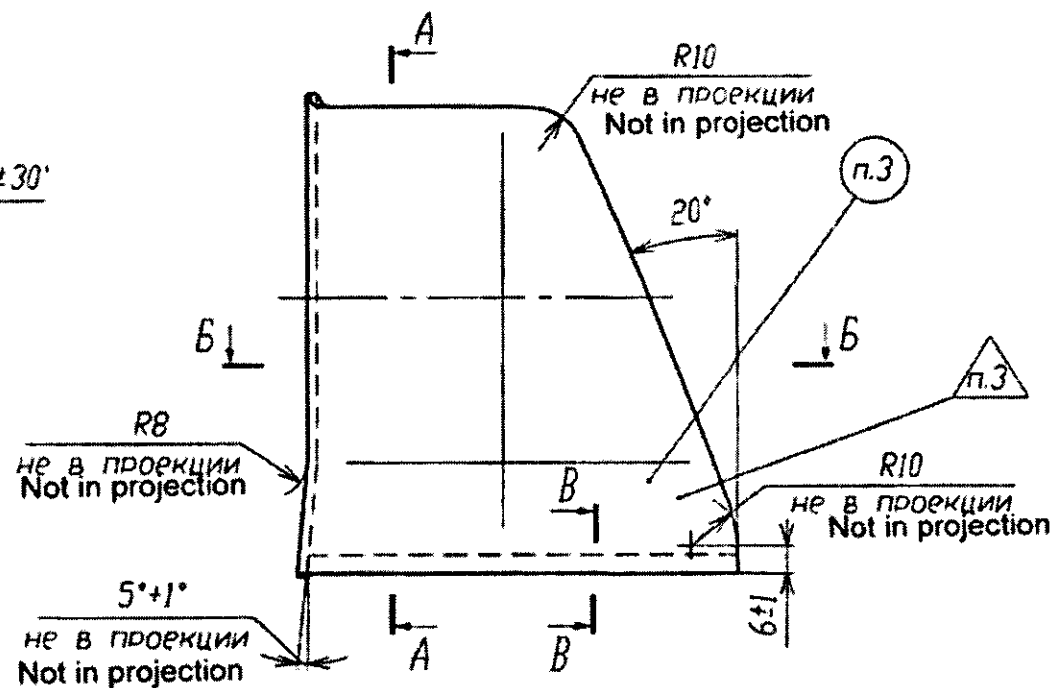
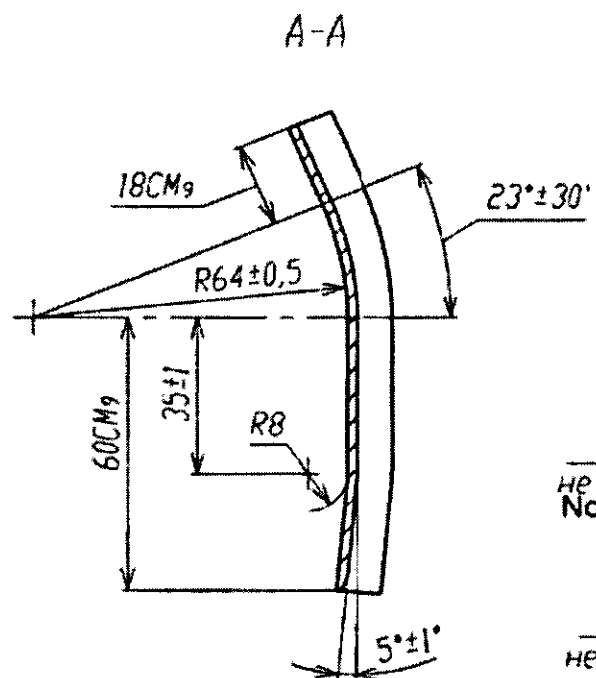


		AK-630 107-73		Type	Mass	Scale
Изм/Лист	№ докум	Изд	Дата	Стенка Lower Wall	0,560	1:1
Разраб				нижняя		
Проф				Лист	Листов 1	
Технол				Sheet	Total Sheets	
Испол				Лист 61-ПН-0 2 ГОСТ 19904-90		
Упр				Лист 4908 4-III-35 ГОСТ 16523-97		

Формат А4:3

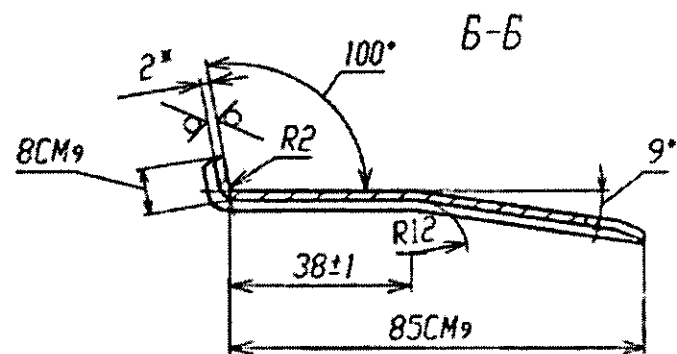
AK-630 107-75

Rz80 (✓)



1. * - Dimension for reference.
2. Round off the sharp edges ~ 0.6 mm
3. Mark III, Ч and stamp K as per AK-630, AK-630 M TY I.

1. *Размер для справок.
2. Острые ребра притупить ~ 0,6 мм.
3. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ I.



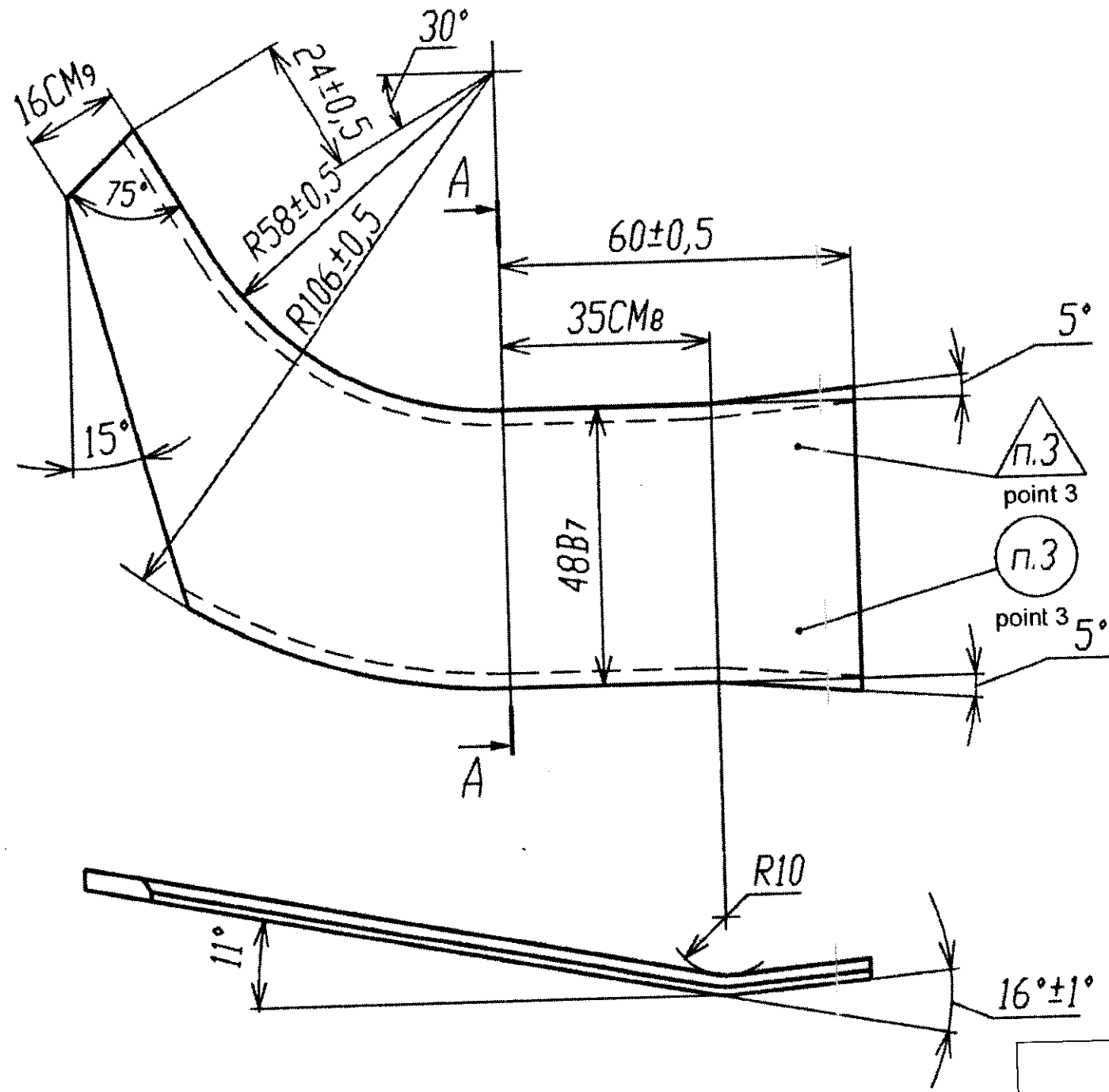
Bale 8 Container 2

		AK-630 107-75		Type	Mass	Scale
ИЗМ.	Лист	№ докум.	Подп.	Дата	Арт.	Масса
Разработ.					A	0.120
Провер.					1:1	
Гоним.					Лист	Листов
Исполн.					Sheet	Total Sheets
Утв.					51-ПН-0 2 ГОСТ 19904-90	
					K490E 4-III-35 ГОСТ 16523-97	

Разр. проект
 Спр. и
 Изм. и
 Подп. и
 Дата

First use

Reference No.



Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

- 1.* Reference dimension.
- 2. Blunt sharp edges ~0.4 mm.
- 3. Mark Ш, Ч and stamp K 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-630 107-74

Rear wall

Type	Weight	Scale
A	0.150	1:1
Sheet	Sheets 1	

Sheet B - PN - 03GOST19903 - 74
K490V 4 - III - 35GOST16523 - 97

First use

Reference No.

Sign and Date

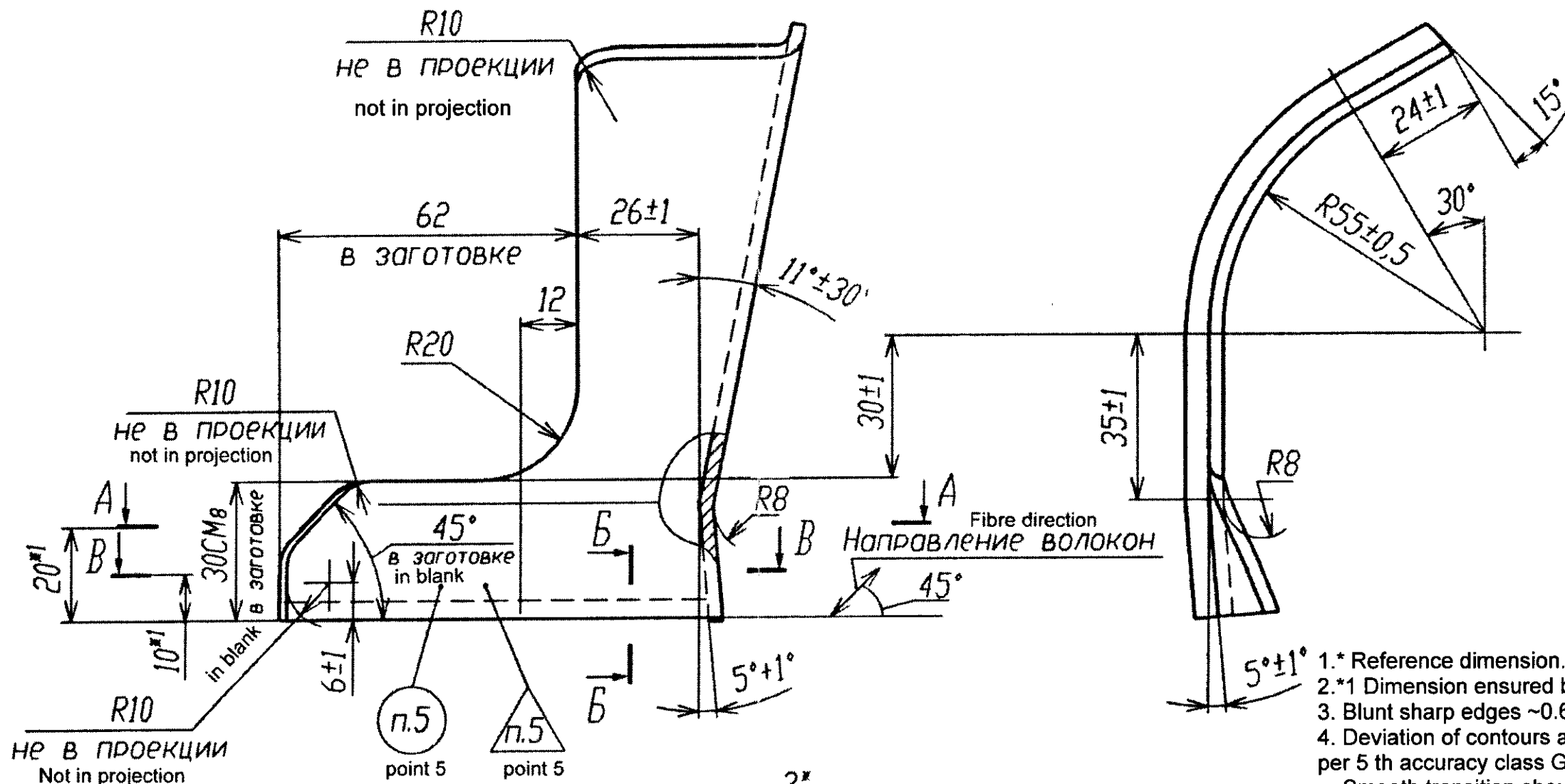
Duplicate Inv. No

Alternate Inv. No

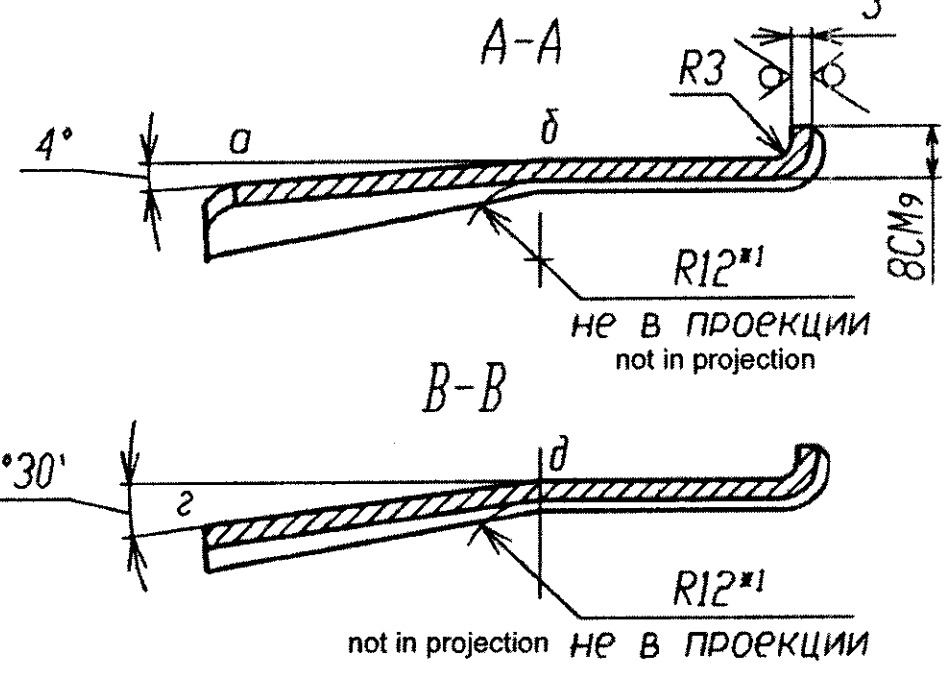
Sign and Date

Orig. inv. no.

Rz80 (✓) (✓)



- 1.* Reference dimension.
- 2.*1 Dimension ensured by tool.
3. Blunt sharp edges ~0.6 mm.
4. Deviation of contours аб, гд from contours of template, made as per 5 th accuracy class GOST 2689-54 is not more than 0.5 mm. Smooth transition should be ensured from section to section.
5. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.



					AK-630 107-76			
Amend.	Sheet	Doc.No.	Sign	Date	Rear wing	Type	Weight	Scale
Developed by						A	0.170	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Sheet <u>B - PN - 03 GOST 19903 - 74</u>			
Approved by					K490V 4 - III - 35 GOST 16523 - 97			

First use

Reference No.

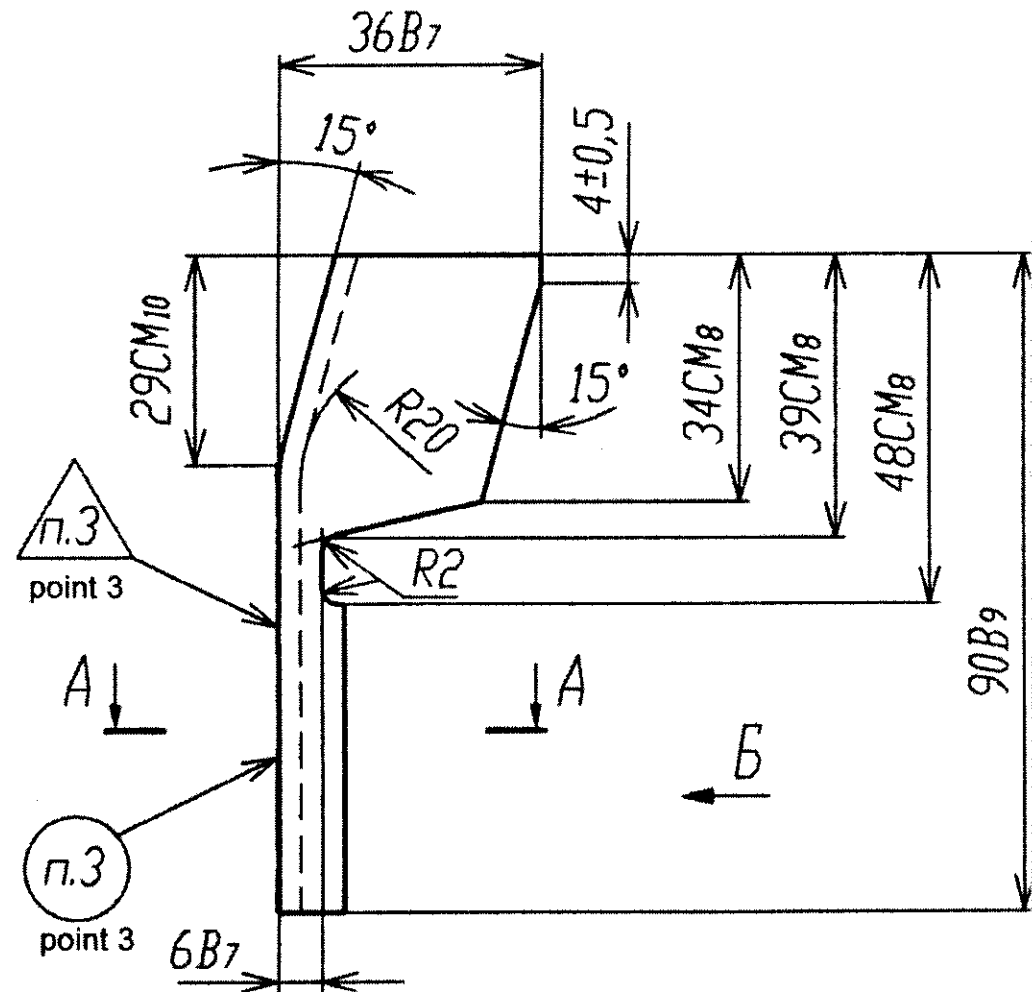
Sign and Date

Duplicate Inv. No

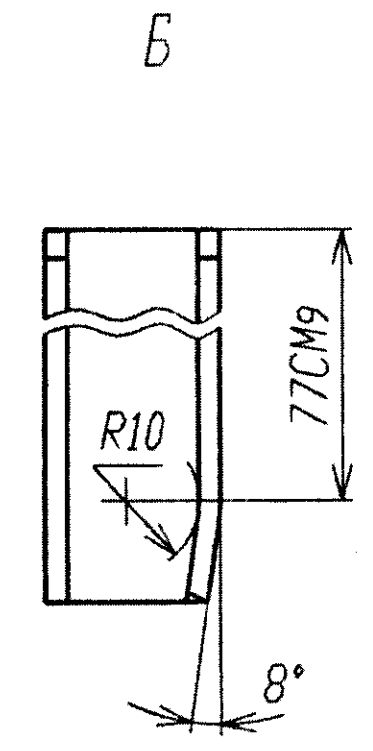
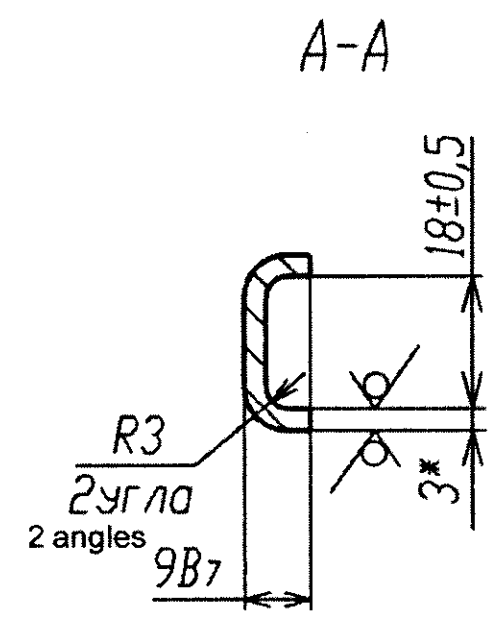
Alternate Inv. No

Sign and Date

Orig. inv. no.



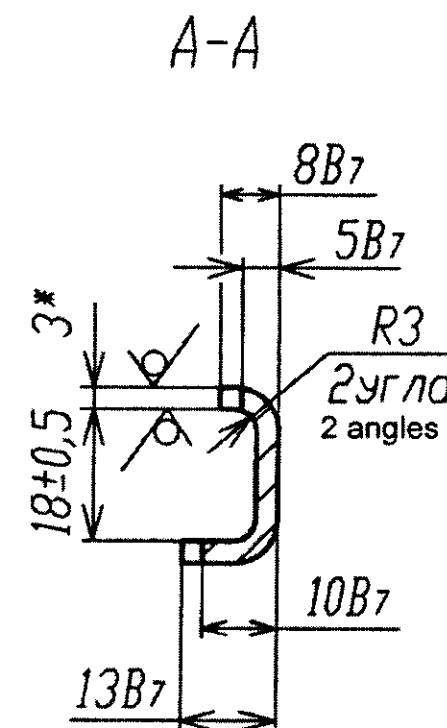
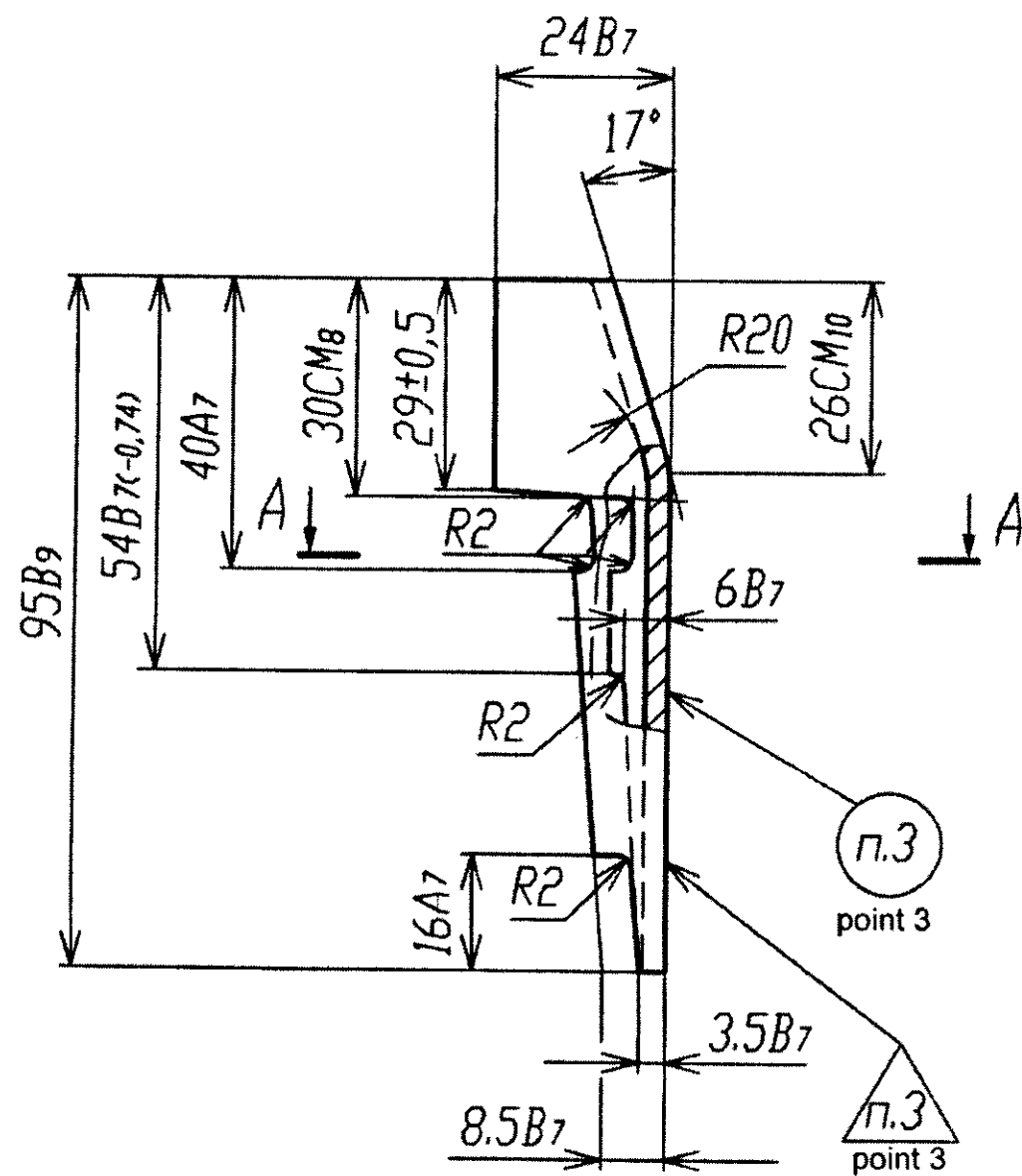
Rz80 (✓) (✓)



- 1.* Reference dimension.
- 2. Blunt sharp edges ~0.6 mm.
- 3. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 107-77			
Amend.	Sheet	Doc.No.	Sign	Date	Front support	Type	Weight	Scale
Developed by						A	0.100	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Sheet	B - PN - 03 GOST19903 - 74 K490V 4 - III - 35 GOST16523 - 97		
Approved by								

Rz80 (✓)



- 1. * Reference dimension.
- 2. Blunt sharp edges ~0.6 mm.
- 3. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 107-78				
					Rear support		Type	Weight	Scale
							A	0.070	1:1
							Sheet	Sheets 1	
					Sheet <u>B - PN - 03 GOST 19903 - 74</u>				
					K490V 4 - III - 35 GOST 16523 - 97				
Amend.	Sheet	Doc.No.	Sign	Date					
Developed by									
Checked by									
Head of Q.C.D									
Approved by									

First use

Reference No.

Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

First use

Reference No.

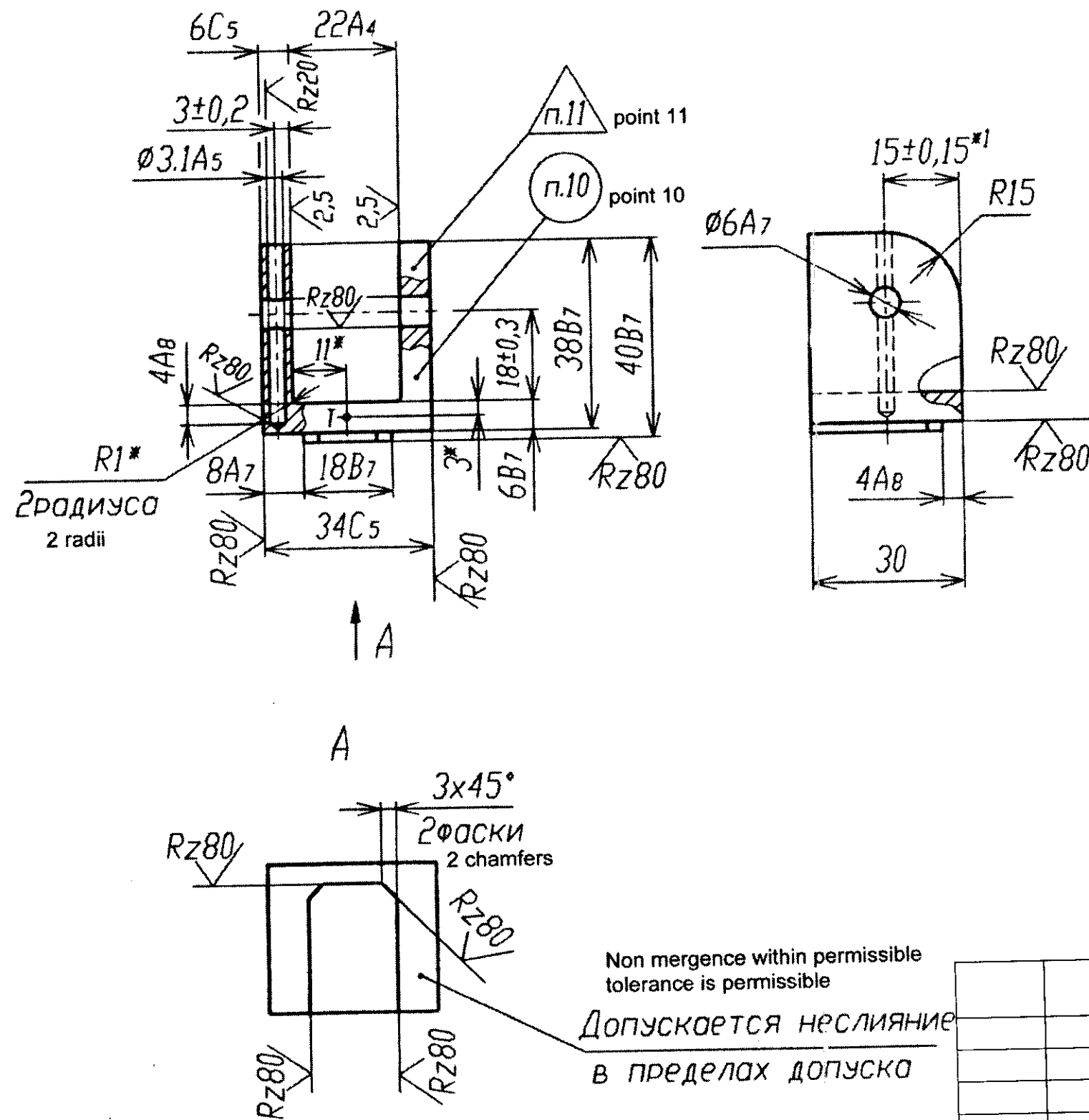
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



✓ (✓)

1. Accuracy of casting 8-0-0-7 GOST 26645-85.
2. Draft as per GOST 3212-92 toward increase in dimensions.
3. Casting radii R = 2 mm unless otherwise specified.
4. Shift on parting plane up to 0.3 mm.
5. Marks from pusher not exceeding 0.5 mm are permissible.
6. Surface finish of casting surfaces as per test specimen.
7. * Dimensions ensured by tool.
8. *1 Dimension given with respect to datum point T.
9. Mark Ш, Ч on tag.
10. Mark П as per AK-630, AK-630M TU I.
11. Stamp K as per AK-630, AK-630M TU I.

Non mergence within permissible tolerance is permissible
 Допускается неслияние в пределах допуска

					AK-630 107-79			
Amend.	Sheet	Doc.No.	Sign	Date	Left lug	Type	Weight	Scale
Developed by						A	0.140	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Casting	K25 - IIOST3 - 4363 - 79 35LGOST977 - 88		
Approved by								

First use

Reference No.

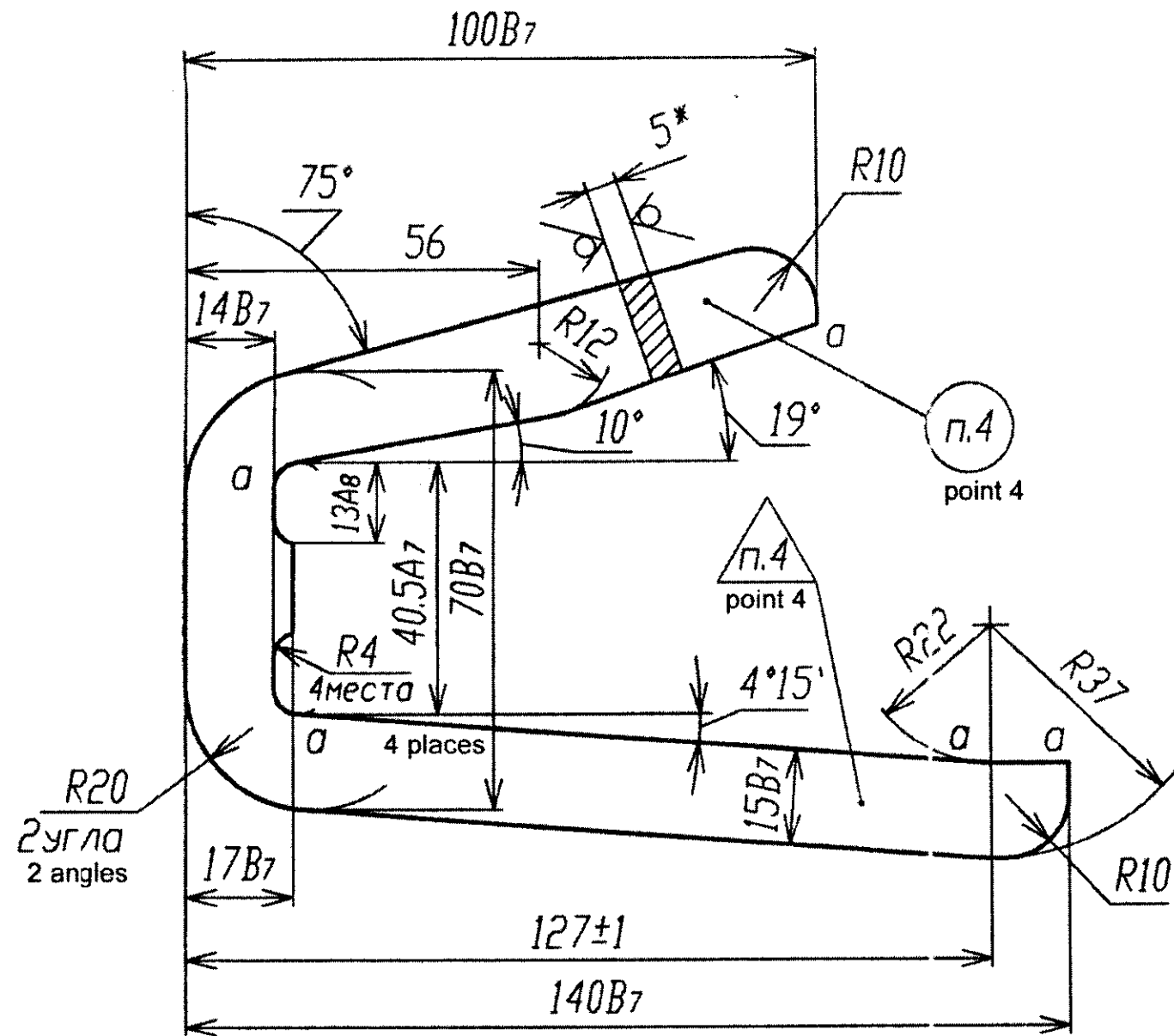
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

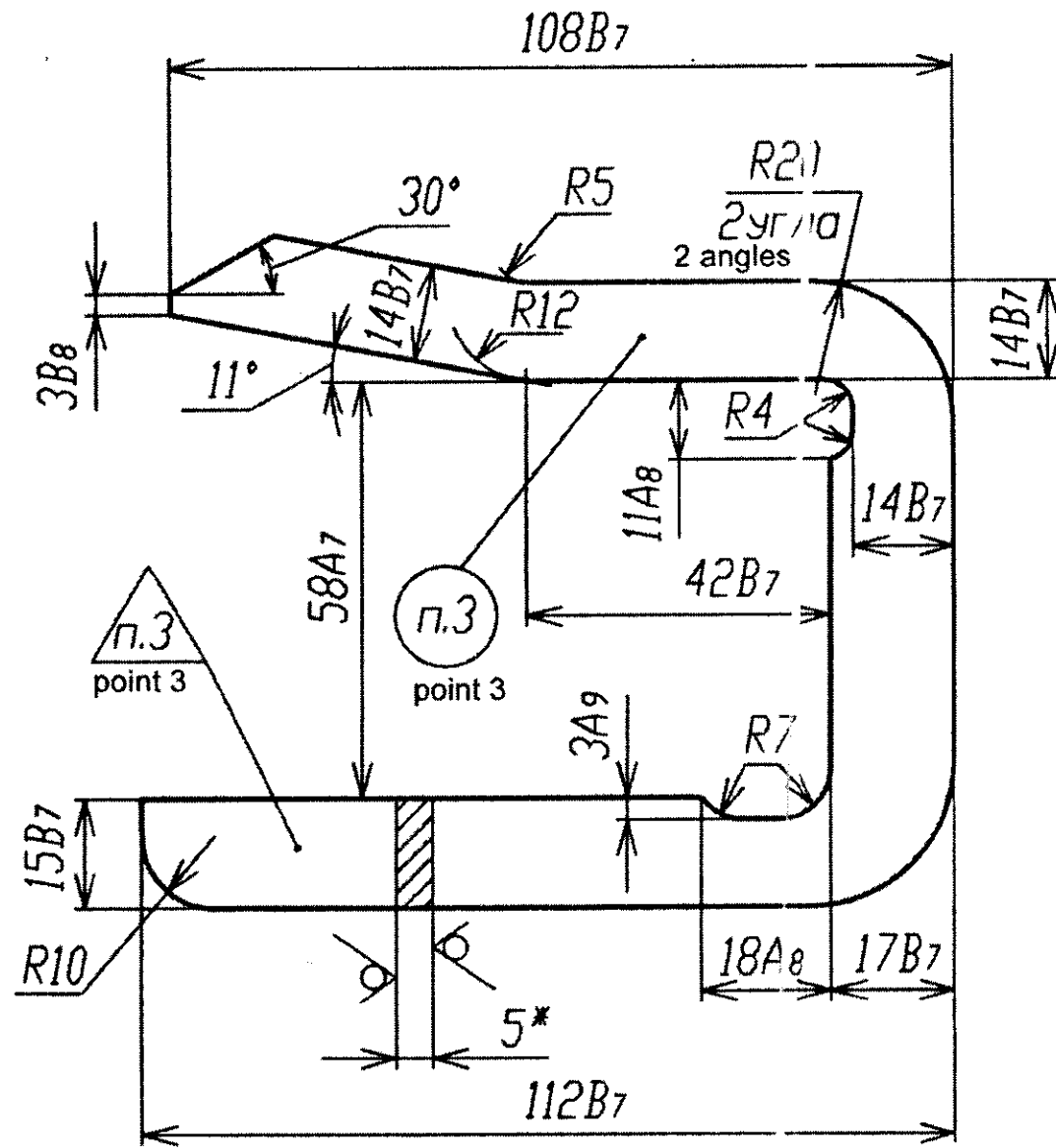


Rz80 (✓)

- 1.* Reference dimension.
2. Tolerance for contour "aa"- 0.5 mm.
3. Blunt sharp edges ~0.6 mm.
4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 107-80				
					Front rib				
					Type		Weight	Scale	
					A			0.150	1:1
					Sheet		Sheets 1		
					Sheet $\frac{B - PN - 5GOST19903 - 74}{35 - 2GOST1577 - 93}$				
Amend.	Sheet	Doc.No.	Sign	Date					
Developed by									
Checked by									
Head of Q.C.D									
Approved by									

Rz80 (✓)



- 1. * Reference dimension.
- 2. Blunt sharp edges ~0.6 mm.
- 3. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU 1.

					AK-630 107-81			
Amend.	Sheet	Doc.No.	Sign	Date	Rear rib	Type	Weight	Scale
Developed by						A	0.140	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by								
					Sheet $\frac{B - PN - 5GOST19903 - 74}{35 - 2GOST1577 - 93}$			

First use

Reference No.

Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

First use

Reference No.

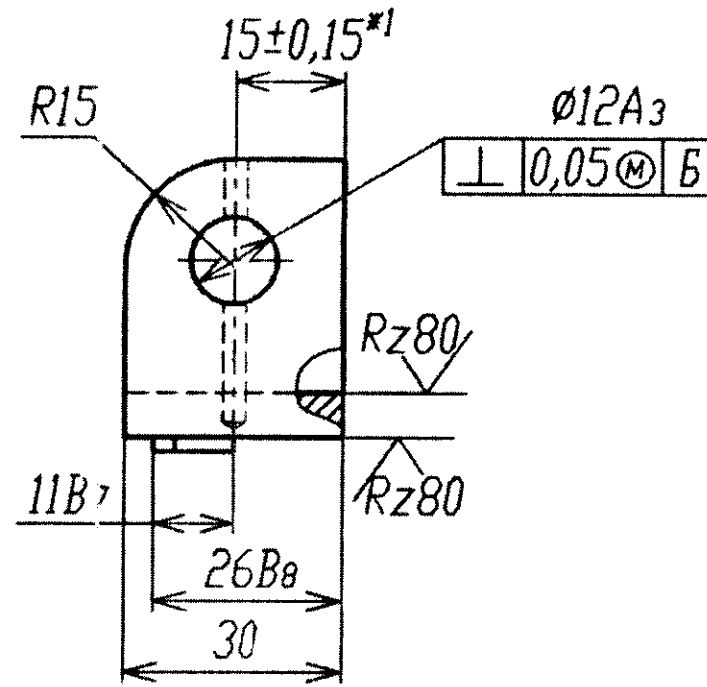
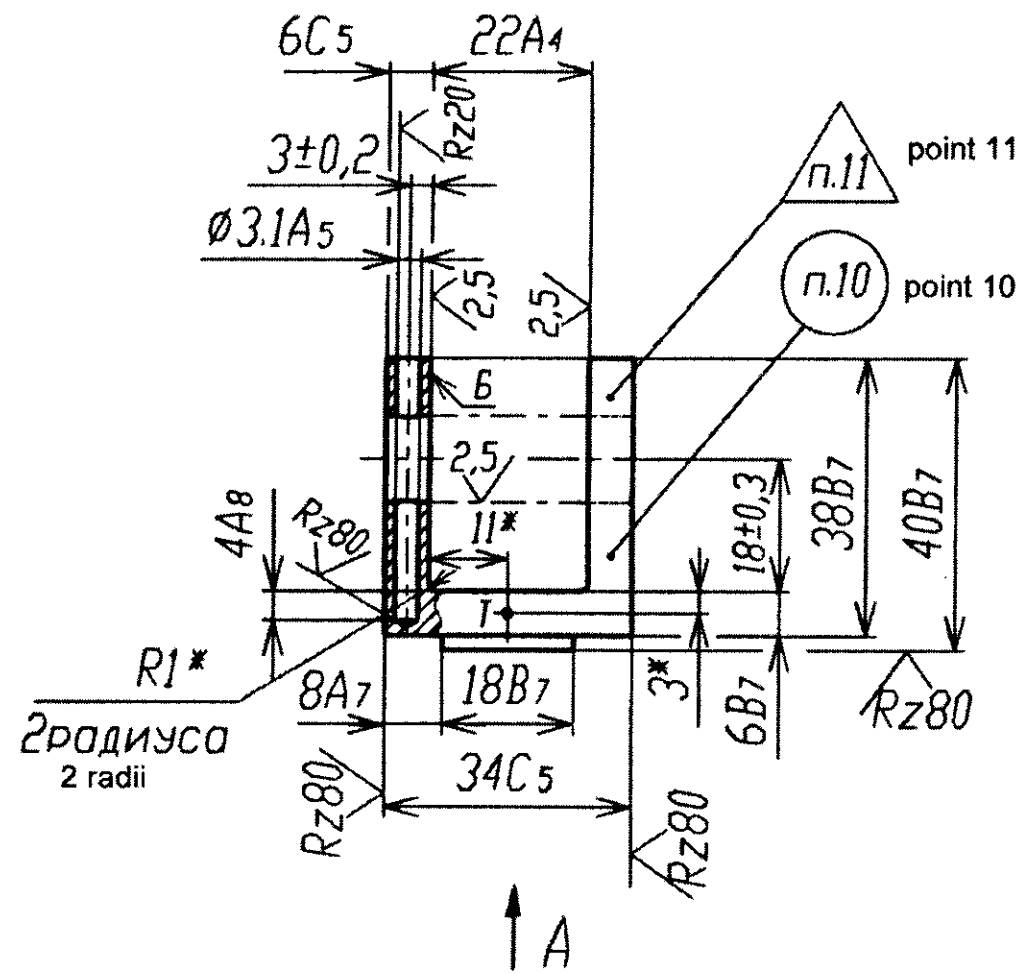
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

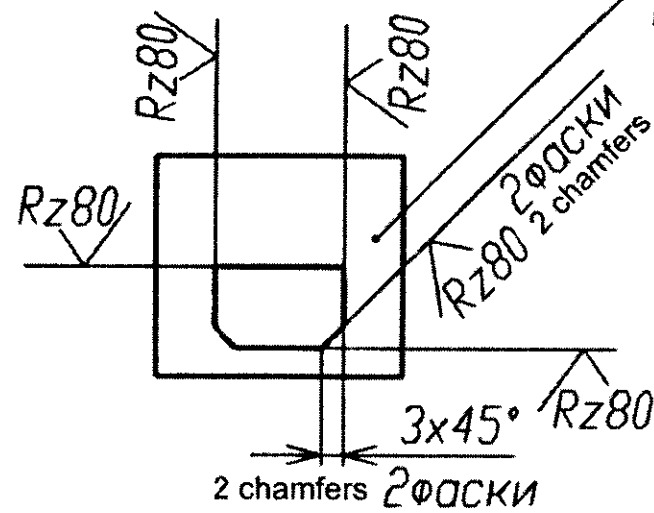


✓ (✓)

1. Accuracy of casting 8-0-0-7 GOST 26645-85.
2. Draft as per GOST 3212-92 toward increase in dimensions.
3. Casting radii R = 2 mm unless otherwise specified.
4. Shift on parting plane up to 0.3 mm.
5. Marks from pusher not exceeding 0.5 mm are permissible.
6. Surface finish of casting surfaces as per test specimen.
7. * Dimensions ensured by tool.
8. *1 Dimension given with respect to datum point T.
9. Mark Ш, Ч on tag.
10. Mark П as per AK-630, AK-630M TU I.
11. Stamp K as per AK-630, AK-630M TU I.

Non mergence within permissible tolerance is permissible

Допускается неслияние
в пределах допуска



					AK-630 107-84			
Amend.	Sheet	Doc.No.	Sign	Date	Right lug	Type	Weight	Scale
Developed by						A	0.120	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Casting	K25 - IIOST3 - 4363 - 79 35LGOST977 - 88		
Approved by								

First use

Reference No.

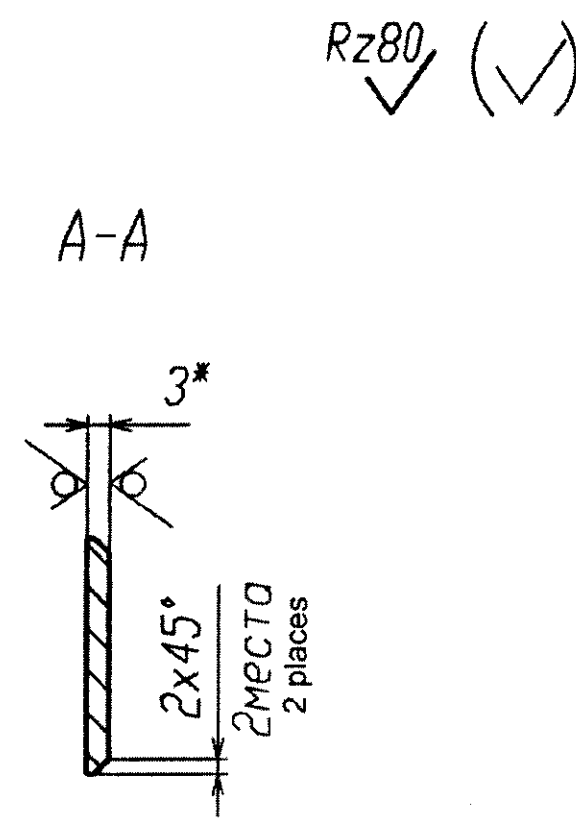
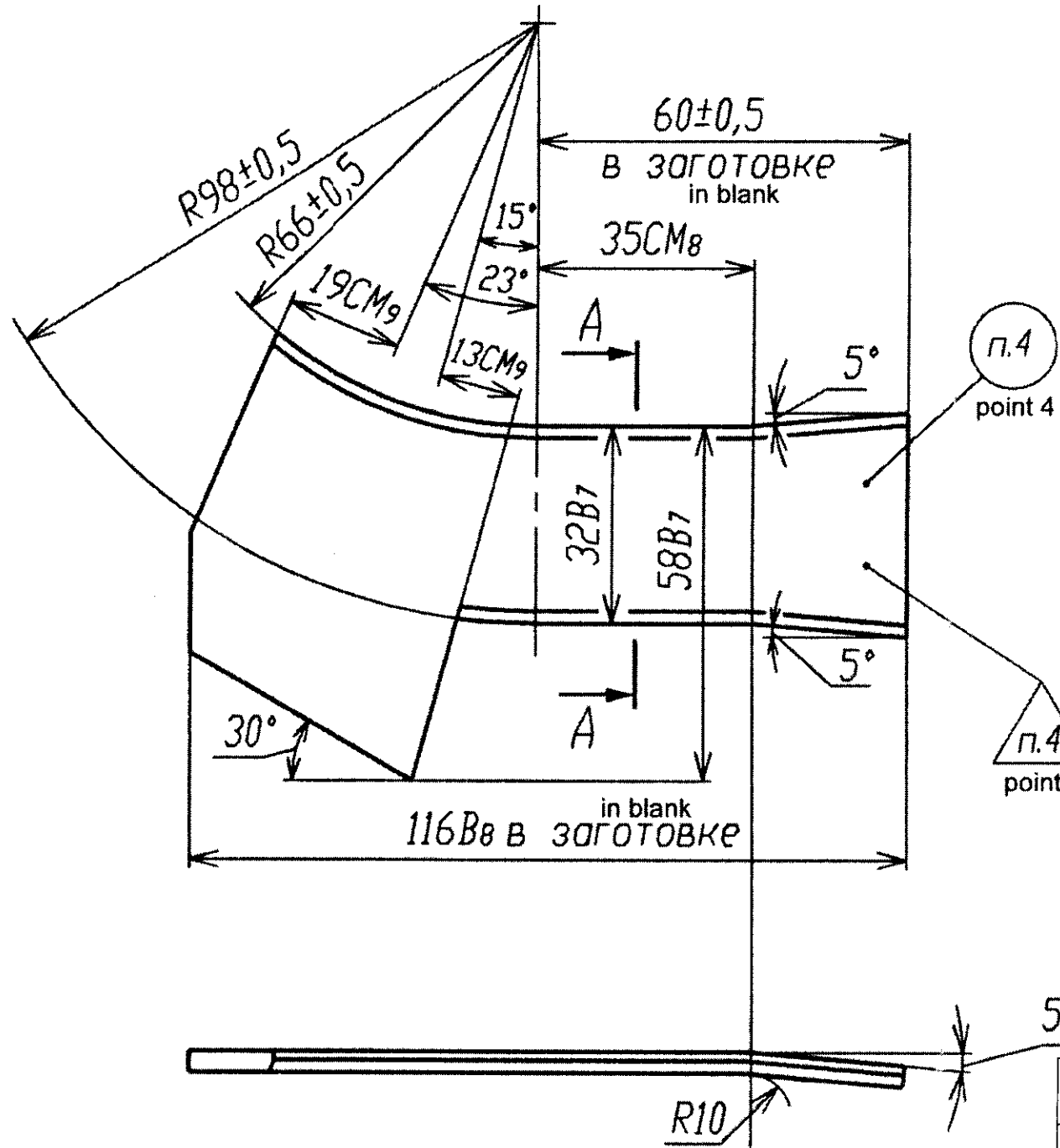
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



- 1.* Reference dimension.
- 2. Inner angles R~0.4 mm.
- 3. Blunt sharp edges ~0.6 mm.
- 4. Mark Ш, Ч and stamp K 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-630 107-85			
Front wall	Type	Weight	Scale
	A	0.100	1:1
Sheet	Sheets 1		
Sheet	<i>B - PN - 03 GOST 19903 - 74</i> <i>K 490V 4 - III - 35 GOST 16523 - 97</i>		

First use

Reference No.

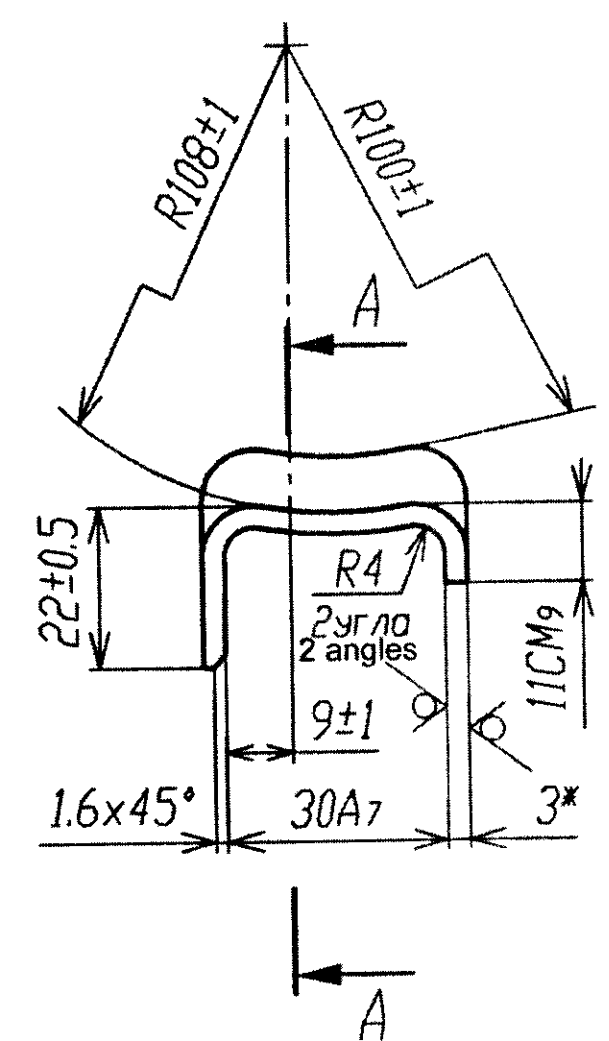
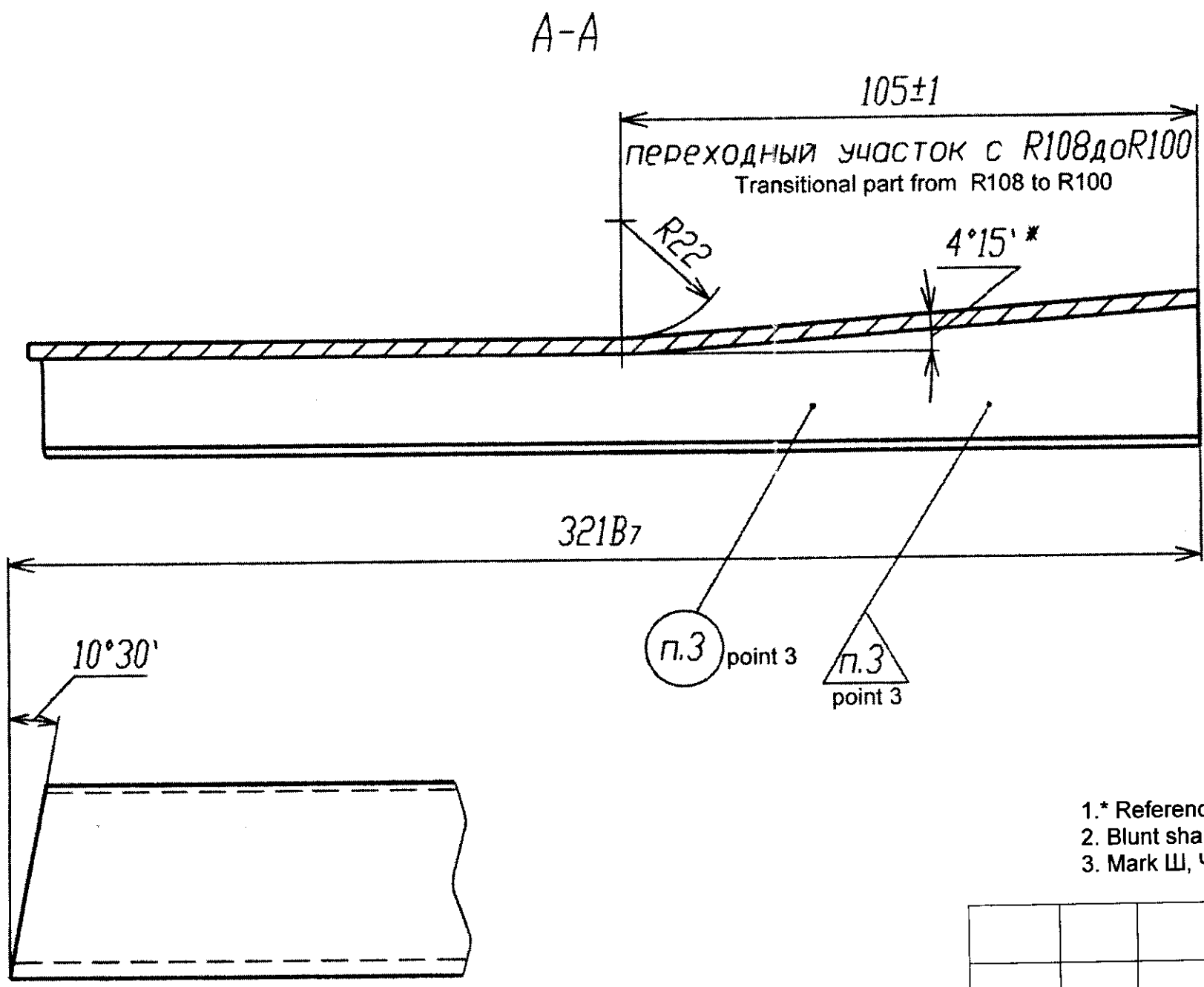
Duplicate Inv. No. Sign and Date

Alternate Inv. No.

Sign and Date

Orig. inv. no.

Rz80 (✓) (✓)



- 1.* Reference dimension.
- 2. Blunt sharp edges ~0.6 mm.
- 3. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 107-88			
Amend.	Sheet	Doc.No.	Sign	Date	Rib	Type	Weight	Scale
Developed by						A	0.450	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D						Sheet $\frac{B - PN - 03 GOST 19903 - 74}{K490V 4 - III - 35 GOST 16523 - 97}$		
Approved by								

First use

Reference No.

Sign and Date

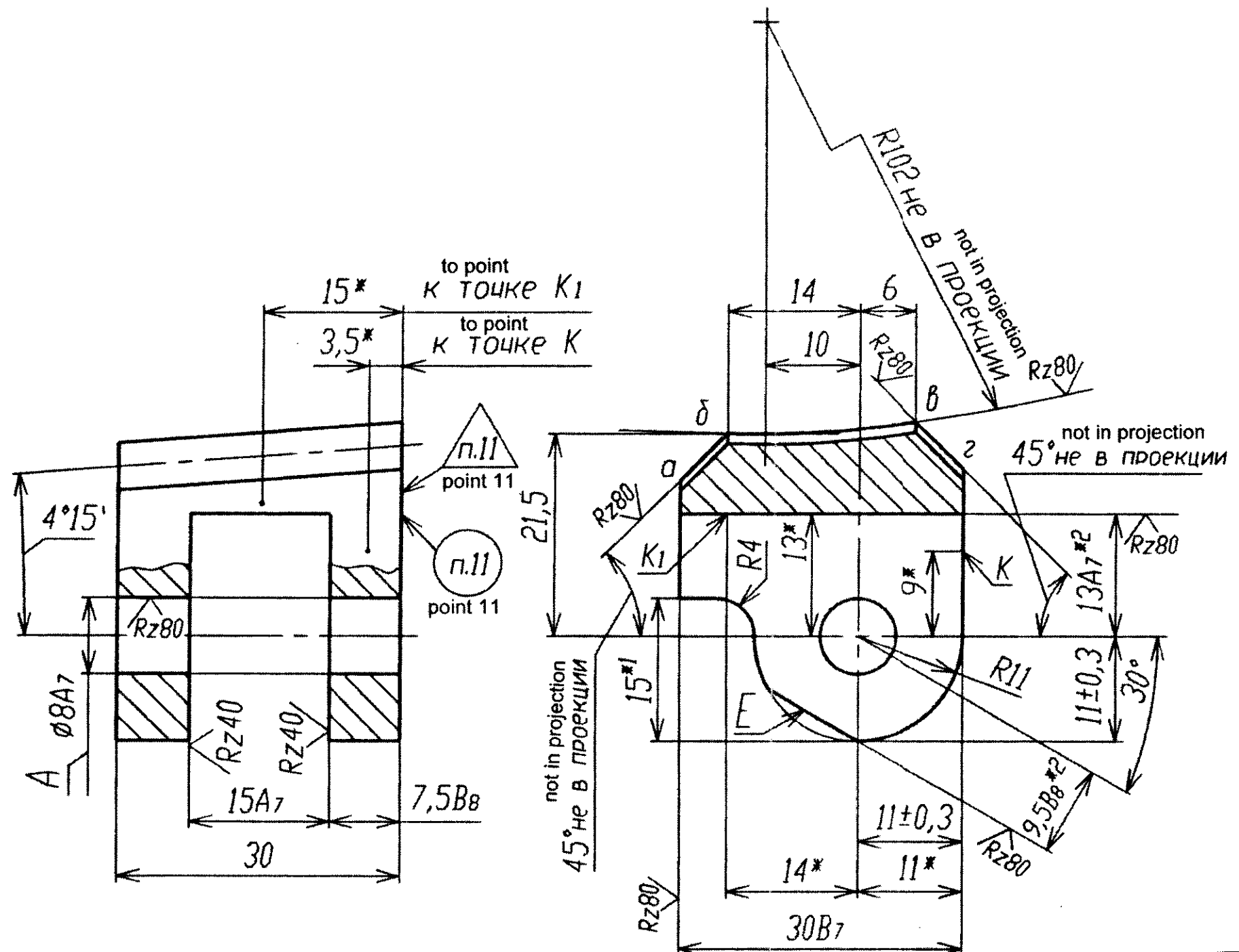
Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

✓ (✓)



1. Accuracy of casting 8-0-0-7 GOST 26645-85.
2. Draft as per GOST 3212-92 toward increase in dimensions.
- 3.. Shift on parting plane up to 0.3 mm
- 4.. Marks from pusher not exceeding 0.5 mm are permissible
- 5.. Casting radii R = 2 mm unless otherwise specified
6. Surface finish of casting surfaces as per test specimen.
7. * Dimensions ensured by tool.
8. *1 Dimensions given before machining of surface E.
9. *2 Dimension given with respect to surface A and point K
10. Tolerance for contour aб, вr, not more than 0.5 mm for contour бв not more than 0.3 mm with respect to surface A and point K1
11. Mark П and stamp K as per AK-630, AK-630M TU I.
Mark Ш, Ч on batch tag.

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

AK-630 107-89

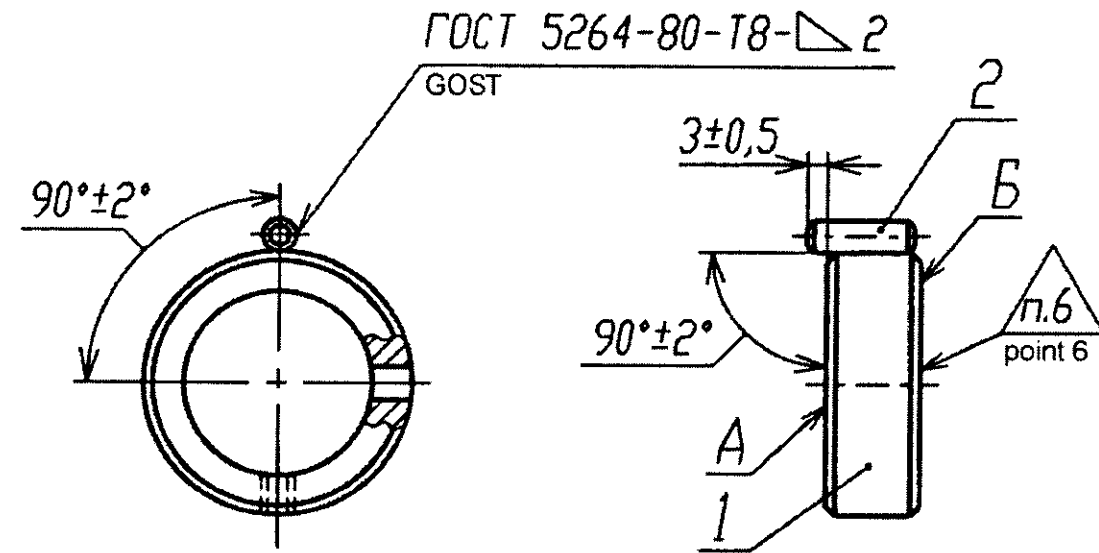
Lug	Type	Weight	Scale
	A	0.098	2:1
	Sheet	Sheets	1
Casting $\frac{K25 - IIOST3 - 4363 - 79}{35LGOST977 - 88}$			

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
						<u>Documents</u>	
Reference No.	A4	/		AK-630 Sb107-19 SB	Assembly drawing		
					<u>Components</u>		
	A4	/	1	AK-630 107-92	Lock ring	1	
					<u>Standard articles</u>		
			2		Pin 5C ₃ x16.40Kh	1	
					Chem.Phos.Oil. OST 3-2234-93		
Sign and Date							
Dupl. Inv. No.							
Alternate Inv. No.							
Sign and Date							
Orig. Inv. No.							

					AK-630 Sb 107-19		
Amend.	Sheet	Doc. No.	Sign	Date			
Developed by					Type	Sheet	Sheets
Checked by					A		1
Head of Q.C.D					Lock		
Approved by							

AK-630 Sb 107-19SB

Approved OGMet
 Orig. Inv. No.
 Head of Q.C.D
 Design bureau chief
 Checked by
 Developed by
 Amend. Sheet Doc. No. Sign Date
 Sign and Date
 Approved TOSb
 Alternate Inv. No. Dupl. Inv. No. Sign and Date
 Approved KTONI
 Sign and Date
 Approved by shop
 Reference No.
 First use



1. Welding rod NIAT -5-2.0-3 GOST 9466-75.
2. Argon-arc welding is permissible.
3. Polish surfaces A and B from rolls.
4. Coating Cd12.phos.
- Lacquer BF-4 with Nigrosine, single coat, made as per OST 3-4123-78, IV, OM2.
5. Mark Ш, Ч on batch tag.
6. Stamp K, И as per AK-630, AK-630M TU I.

AK-630 Sb 107-19SB

Lock
 Assembly drawing

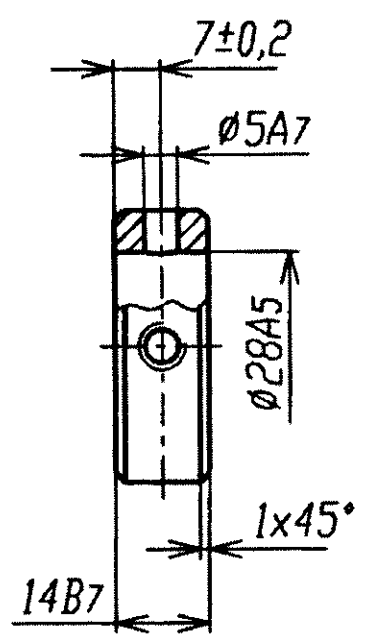
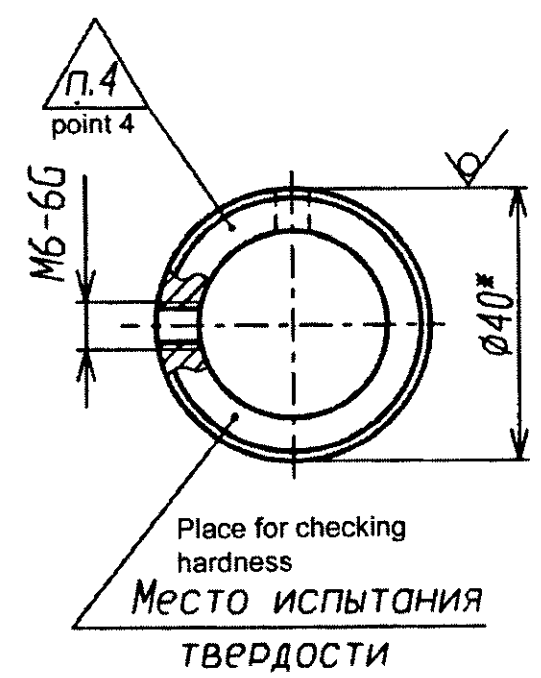
Type	Weight	Scale
A	0.045	1:1
Sheet		Sheets 1

Copied by

Format A4

AK-630 107-92

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



1. 34...39.5 HRC_E.
2. * Reference dimension.
3. Mark Ш, Ч on tag.
4. Stamp К, И as per AK-630, AK-630M TU I.

Amend.	Sheet	Doc. No.	Sign	Date

AK-630 107-92

Lock ring

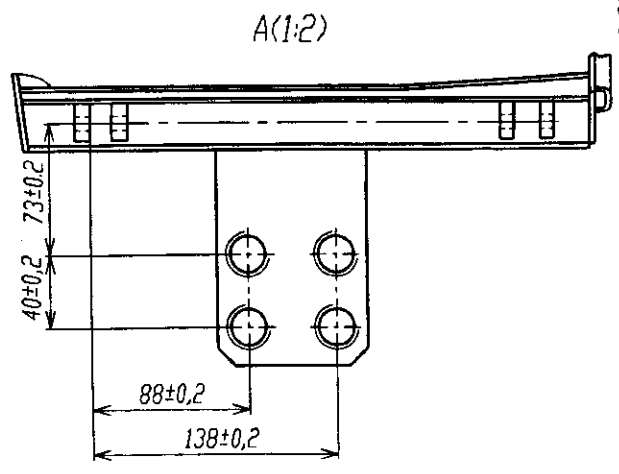
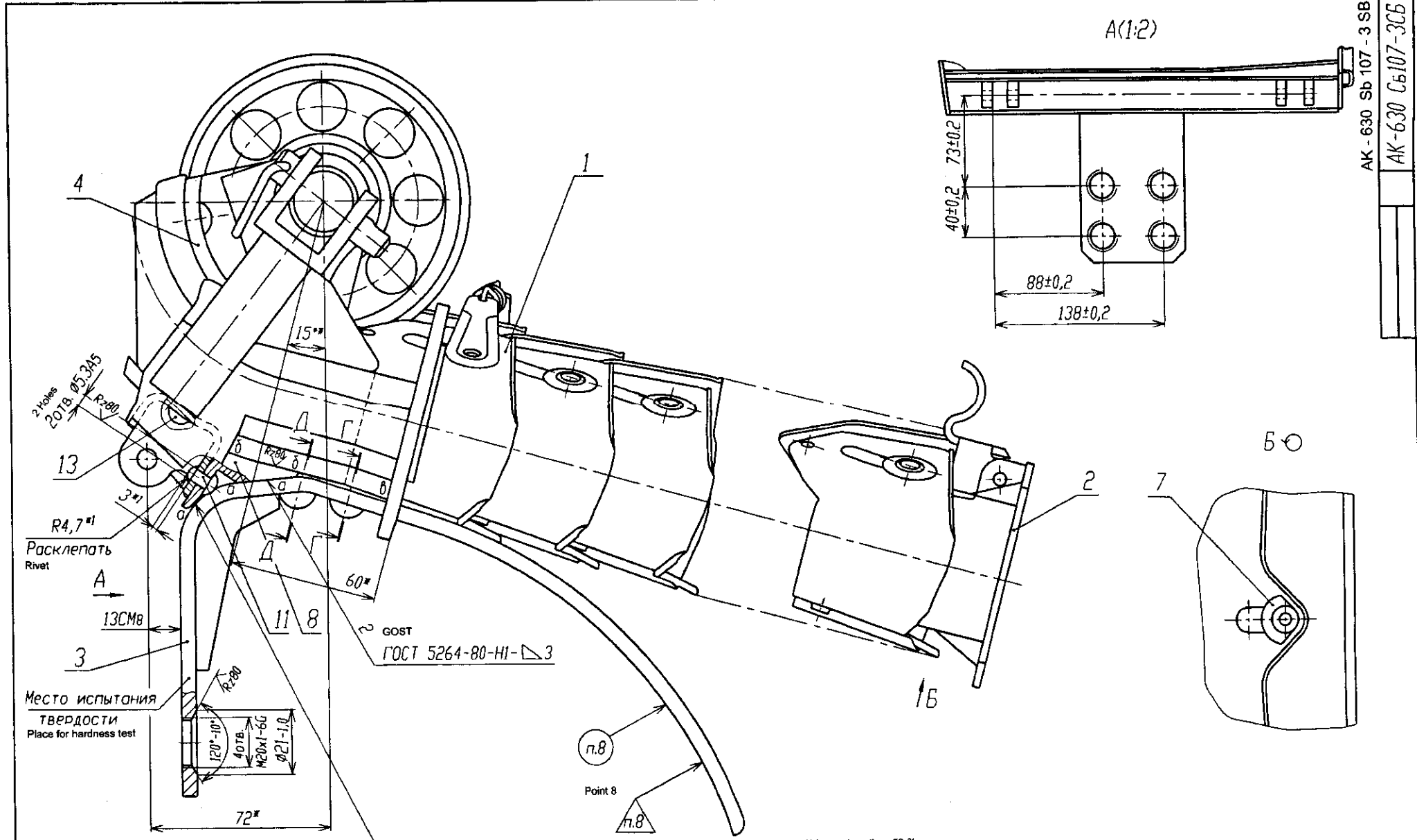
Type	Weight	Scale
A	0.035	1:1
Sheet	Sheets 1	

Wheel $V - 40 GOST 2590 - 88$
 $40 - ZGP - TOGOST 1050 - 88$

Copied by

Format A4

First use		Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
						<u>Documents</u>			
	A2				AK-630 Sb 107-3 SB	Assembly drawing			
Reference No.						<u>Assembly units</u>			
	A4	/	1		AK-630 Sb107-10	Upper hose	1		
	A4	/	2		AK-630 Sb107-11	Lower frame	1		
	A4	/	3		AK-630 Sb107-12	Strip	1		
	A4	/	4		AK-630 Sb107-13	Collar	1		
						<u>Components</u>			
	A4	/	5		AK-630 107-2-01	Rivet	3		
	A4	/	6		AK-630 107-3	Washer	2		
	A4	/	7		AK-630 107-4	Washer	1		
	A3	/	8		AK-630 107-17	Insert	1		
	A4	/	9		AK-630 107-18	Washer	2		
	A4	/	10		AK-630 107-2-02	Rivet	1		
	A4	/	16		AK-630 107-2-03	Rivet	1		
Dupl. Inv. No.						<u>Standard articles</u>			
Alternate Inv. No.			11			Rivet 5x14.21	2		
						GOST 10299-80			
Sign and Date						AK-630 Sb 107-3			
		Amend.	Sheet	Doc. No.	Sign	Date			
Sign and Date		Developed by					Type	Sheet	Sheets
Orig. Inv. No.		Checked by					A	1	2
		Head of Q.C.D					Upper hose		
		Approved by							



AK-630 Sb 107-3 SB
AK-630 Cb107-3CB

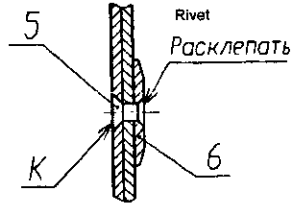
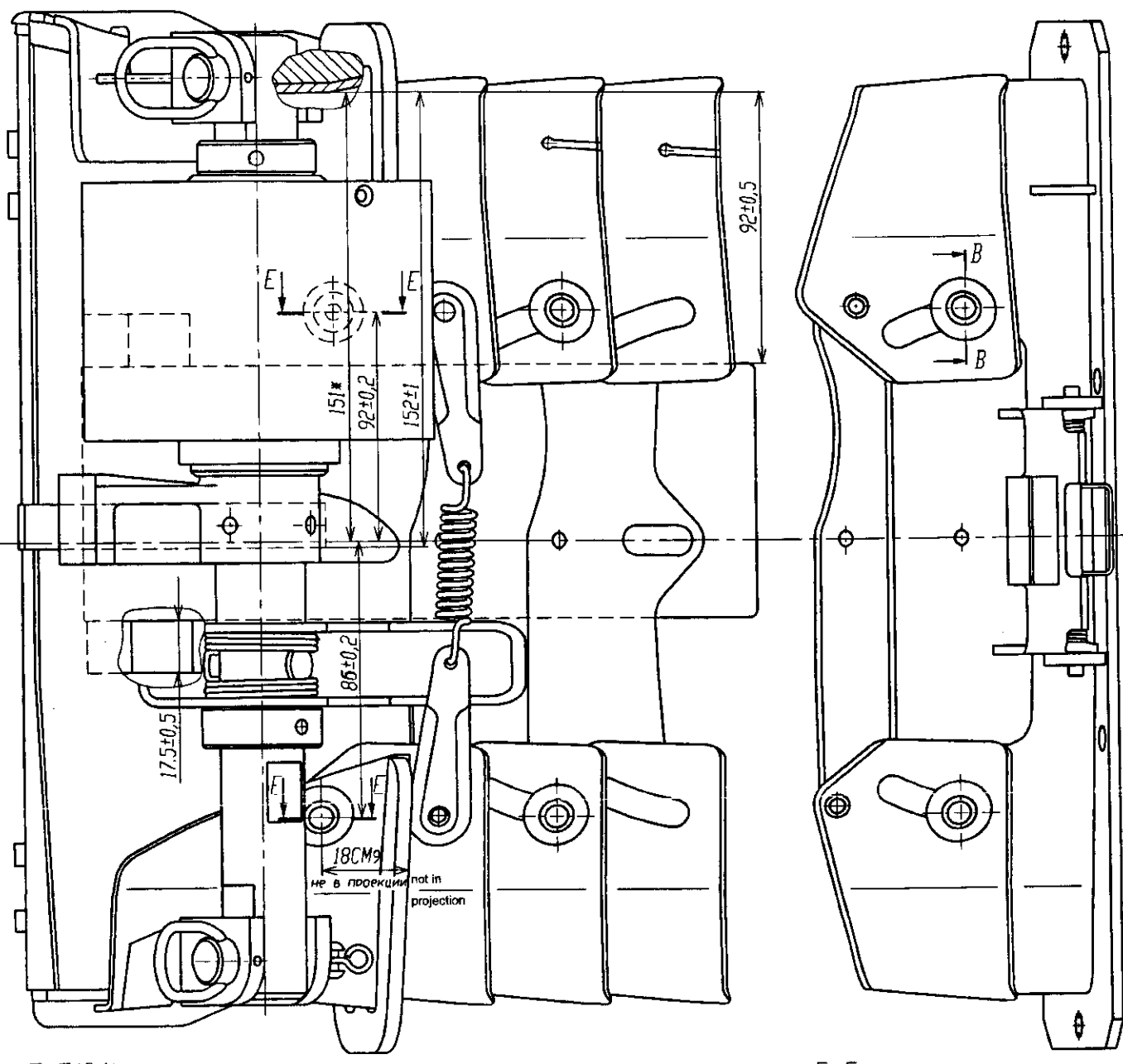
Расклепать Rivet

Место испытания ТВЕРДОСТИ Place for hardness test

GOST ГОСТ 5264-80-Н1-3

By way of filing, ensure the abutment of bushing position 8 along the contour "aaa", "bb" for not less than 50%.
Обеспечить пригиловкой прилегание вкладыша поз.8 по контурам "aaa", "bb" не менее 50%

B-B
Зместа 3 Places

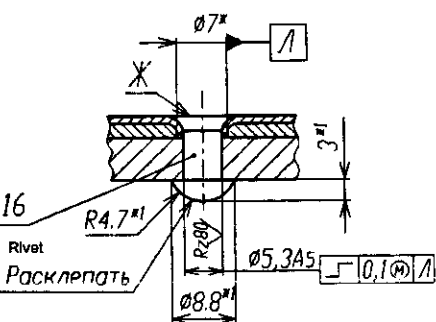


- 29...35 HRCa. At the place for hardness test, it is permitted to finish up to 0.5 mm. After the adjustment of bushing (insertion piece) position 8 with band position 3, temper in assembly.
- * - Dimensions for reference.
- * 1 - Dimensions are to be ensured by tool.
- In order to ensure the abutment of band to the neck position 4 and to the top hose position 1 and for ensuring the twisting of top hose with in limiting angles for specifications (conditions), which are similar to assembled article, the turning in and the adjustment of band is permitted. Along the contour "6" the feeler gauge 0.5 mm should not pass through.

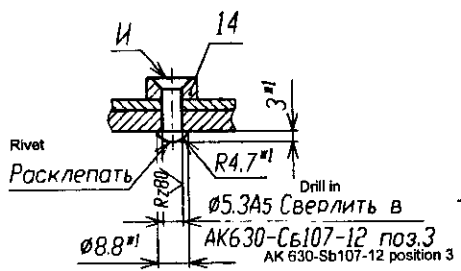
- 29...35 HRCa. В месте замера твердости допускается зачистка до 0,5 мм. Закалить в сборе после пригонки вкладыша поз.8 с полосой поз.3.
- * Размеры для справок.
- * 1 Размеры обеспеч. инстр.
- Для обеспечения прилегания полосы к горловине поз.4 и рукаву верхнему поз.1 и для обеспечения скручивания рукоя верхнего на предельные углы в условиях, аналогичных собранному изделию допускается подгибка и пригонка полосы. По контуру "bb" щуп 0,5 мм не должен проходить.
- Выступление головок заклепок Ж, И, К не допускается. Зачистить заплоско Rz80.
- Острые ребра притупить ~ 0,6 мм.
- Покрытие Ka12. фос.
- Лок БФ-4 с нигрозином, 1 слой, приготовление по OST 3-4123-78, IV, OM2 в сборе вкладыша с полосой.
- Маркировать Ш, Ч, На и клеить К, И по АК-630, АК-630М ТУ I.
- На - технологический агрегатный номер сборки.

- Head projection of rivets Ж, И, К is not permitted. Finish abutted with Rz 80 V.
- Blunt the sharp ribs ~ 0.6 mm.
- Coating Cad 12. phos.
- Varnish BF-4 with nigrogin, 1 layer, preparation as per OST 3-4123-78, IV, OM2 in assembly of bushing (insertion piece) with band.
- Mark Ш, Ч, На and stamp К, И as per АК-630, АК-630М ТУ I.
- На - Technological aggregate number of assembly.

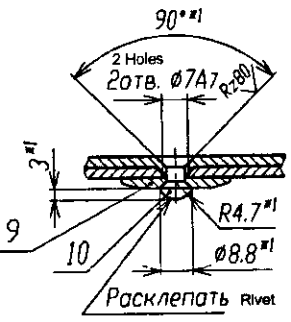
Г-Г(2:1) Ø



Д-Д Ø



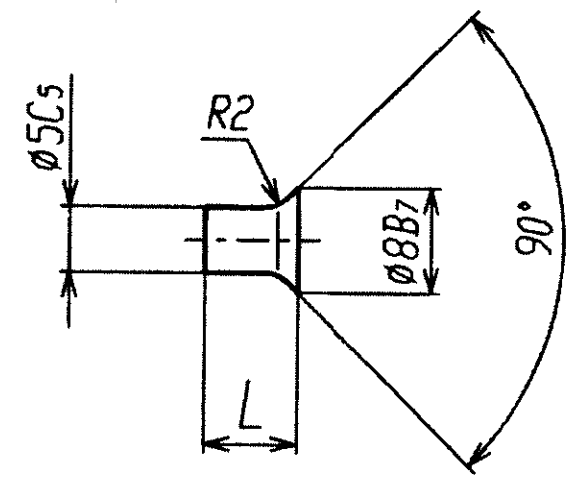
Е-Е



AK-630 Sb 107-3 SB		AK-630 Cb107-3CB	
Upper hose		Руков верхний	
СБОРОЧНЫЙ ЧЕРТЕЖ		ASSEMBLY DRAWING	
Лист	18,30	Листов	1:1
Лист		Листов	
Лист		Листов	

AK-630 107-2

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



Rz40 ✓

Designation	L, mm	Weight, kg
AK-630 107-2	5.7 C ₅ (-0.16)	0.001
-01	7 C ₅ (-0.2)	0.001
-02	12 C ₅	0.002
-03	16 C ₅	0.003

1. Substitute material -Steel 12Cr18Ni10Ti GOST 5632-72.
2. Blunt sharp edges R~0.2 mm.
3. Mark Ш, Ч and stamp K on tag.
4. Other technical requirements as per GOST 10304-80.

Amend.	Sheet	Doc. No.	Sign	Date

AK-630 107-2			
Type	Weight	Scale	
Rivet	A	2:1	
Steel 12Cr18Ni9Ti GOST 5632-72	Sheet	Sheets 1	

Copied by

Format A4

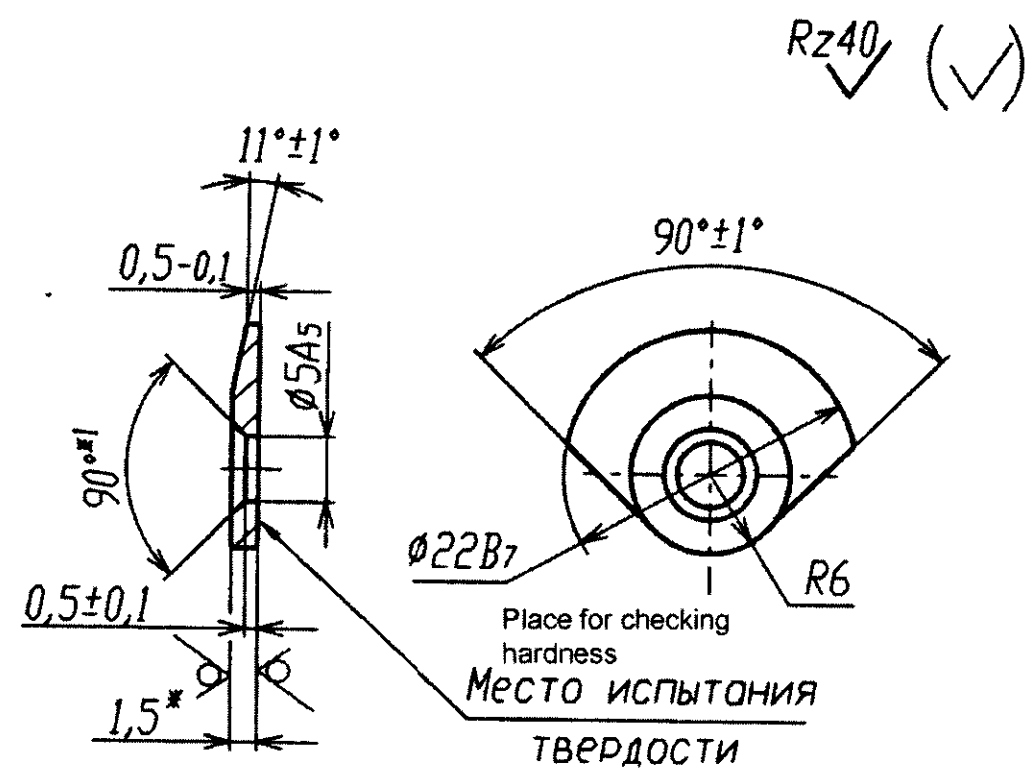
AK-630 107-3																	
Approved by shop	Reference No.																
Approved KTONI	Sign and Date																
Approved TOSb	Dupl. Inv. No.	<p>1. 29...35.0 HRC_E. Check hardness on 3..5% of the batch but not less than 3 nos.</p> <p>2. * Reference dimension.</p> <p>3. *1 Dimensions ensured by tool.</p> <p>4. Blunt sharp edges R~0.2 mm.</p> <p>5. Coating Cd12.Cr.</p> <p>6. Mark Ш, Ч and stamp K on tag.</p> <p>7. It is permissible to make by cold extrusion from sheet</p> <p><u>BT - PN - 01.5 GOST 19904 - 90</u></p> <p><u>K 490V 4 - III - 40 GOST 16523 - 97</u></p>															
Alternate Inv. No.	Sign and Date																
Approved OGMet	Orig. Inv. No.			AK-630 107-3													
Amend.	Sheet	Doc. No.	Sign	Date	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td colspan="3" style="text-align: center;">Washer</td> </tr> <tr> <td style="text-align: center;">Type</td> <td style="text-align: center;">Weight</td> <td style="text-align: center;">Scale</td> </tr> <tr> <td style="text-align: center;">A</td> <td style="text-align: center;">0.005</td> <td style="text-align: center;">2:1</td> </tr> <tr> <td colspan="2" style="text-align: center;">Sheet</td> <td style="text-align: center;">Sheets 1</td> </tr> </table>	Washer			Type	Weight	Scale	A	0.005	2:1	Sheet		Sheets 1
Washer																	
Type	Weight	Scale															
A	0.005	2:1															
Sheet		Sheets 1															
Developed by																	
Checked by																	
Head of Q.C.D																	
Design bureau chief																	
Head of Q.C.D																	
Approved by																	
Sheet <u>BT - PN - 01.5 GOST 19904 - 90</u> <u>K 490V 4 - III - 40 GOST 16523 - 97</u>																	

Copied by

Format A4

AK-630 107-4

First use	
Approved by shop Reference No.	
Approved KTONI	
Sign and Date	
Approved TOsb Dupl. Inv. No.	
Alternate Inv. No.	



1. 29...35.0 HRC_E. Check hardness on 3.5% of the batch but not less than 3 nos.
2. * Reference dimension.
3. *1 Dimensions ensured by tool.
4. Blunt sharp edges R~0.2 mm.
5. Coating Cd12.Cr.
6. Mark Ш, Ч and stamp К, И on tag.

AK-630 107-4				
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				
Washer		Type A	Weight 0.003	Scale 2:1
Sheet			Sheets 1	
Sheet <u>BT - PN - 01.5 GOST 19904 - 90</u> <u>K490V 4 - III - 40 GOST 16523 - 97</u>				

Copied by

Format A4

First use

Reference No.

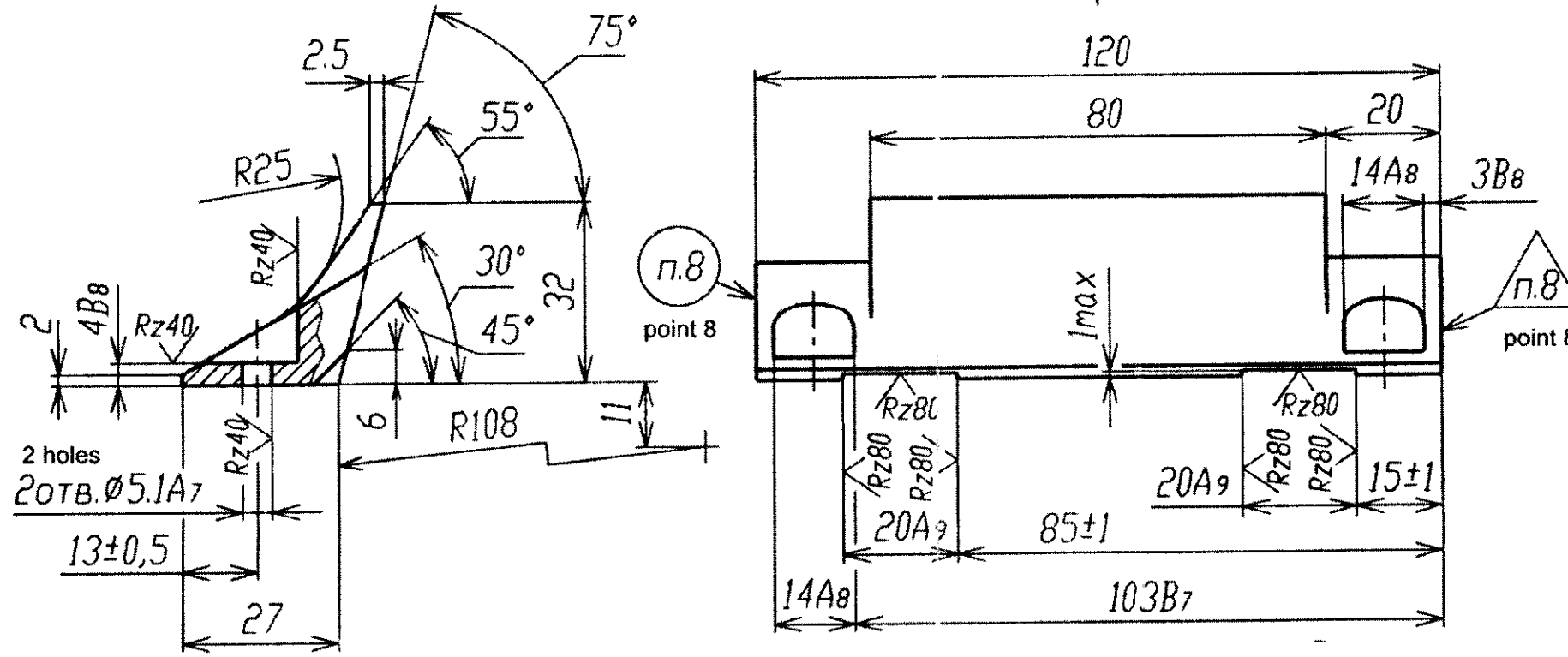
Sign and Date

Duplicate Inv. No

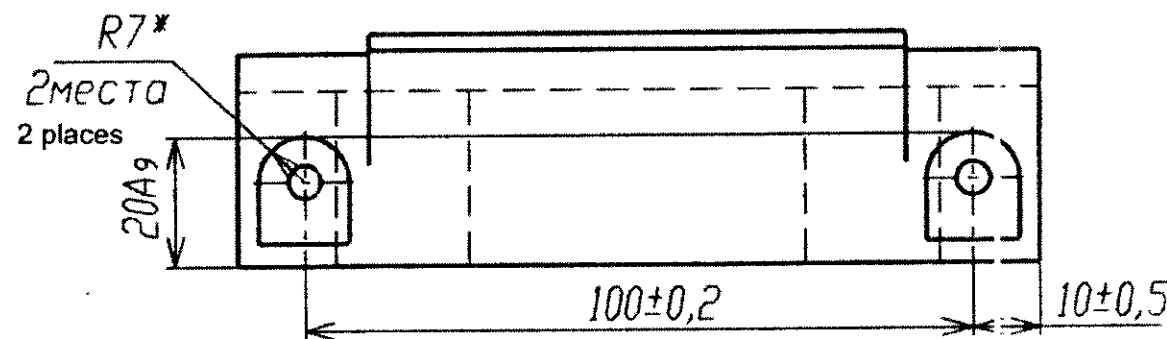
Alternate Inv. No

Sign and Date

Orig. inv. no.

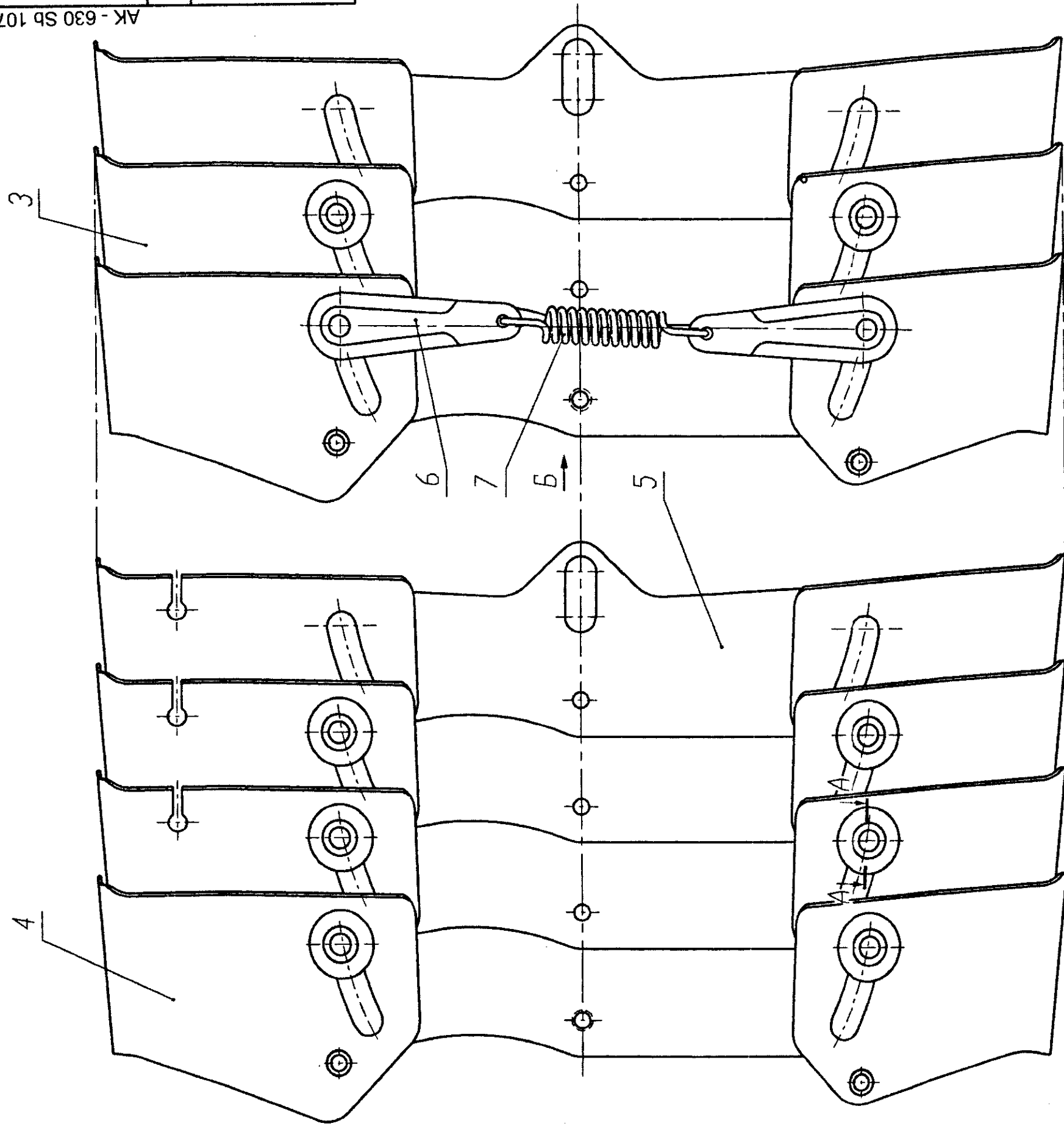


✓ (✓)



1. Accuracy of casting 8-0-0-7 GOST 26645-85.
2. Draft as per GOST 3212-92 toward increase in dimensions.
3. Displacement along plane of parting line up to 0.2 mm.
4. Marks from pusher not exceeding 0.3 mm is permissible.
5. Casting radii R = 2 mm unless otherwise specified.
6. Surface finish of casting surfaces as per test specimen.
- 7.* Dimension ensured by tool.
8. Mark Ш, Ч, П and stamp K as per AK-630, AK-630M TU I.

					AK-630 107-17			
Amend.	Sheet	Doc.No.	Sign	Date	Insert	Type	Weight	Scale
Developed by						A	0.280	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by					Casting	1OST3-4365-79 35L-GOST977-88		



1. Собранный рукав должен легко без заеданий укорачиваться и удлиняться. Зазедания в отдельных звеньях не допускаются.

2. Внутренняя поверхность не должна иметь встречающихся выступов, препятствующих движению ленты.

3. Искривление шайб поз. 2 и планок поз. 6 не допускается.

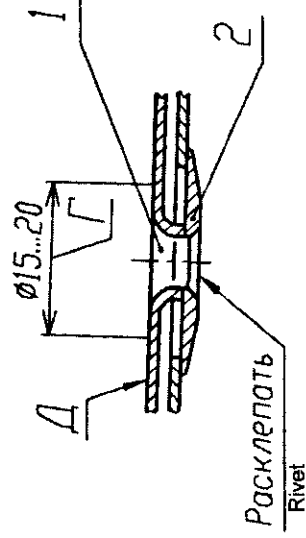
4. Планки поз. 6 и пружины поз. 7 установить через кожухи 4 рамки, закрепив первую как указано на чертеже. Концы пружин подогнуть обеспечив размер В.

5. Несовпадение заклепки поз. 1 с поверхн. Д не более 0,2 мм. Контролировать в зоне Г.

6. Маркировать Ш, Ч и клеить К на бирке по АК-630, АК-630М ТУ 1.

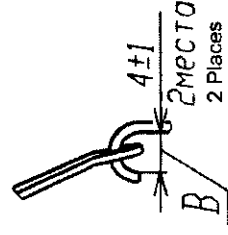
A-A(2:1)

Для всех соединений
For all the joints



Б

Для всех соединений
For all the joints



Расклепать
Rivet

- The assembled hose should shorten (contract) and expand easily without jamming, ensure the radius, fan-shape and spirithness. Jamming in individual links is not permitted.
- The internal surface should not have counter projections, which obstruct the movement of strip (tape).
- Hogging of washers position 2 and plank position 6 is not permitted.
- Set the planks position 6 and springs position 7 through every four frames, after having fastened the first one as shown in drawing. After ensuring the dimension B, bend the ends of springs.
- Non-alignment of rivet position 1 with surface D is not more than 0.3 mm. Check in zone Г.
- Mark Ш, Ч and stamp K on the tag as per AK-630, AK-630M TU 1.

AK - 630 Sb 107 - 2SB

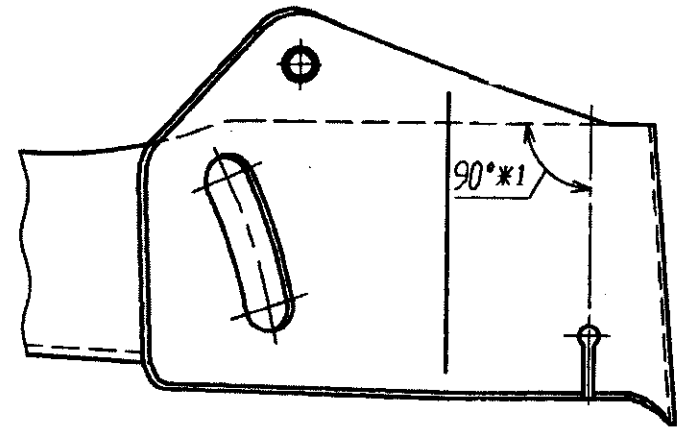
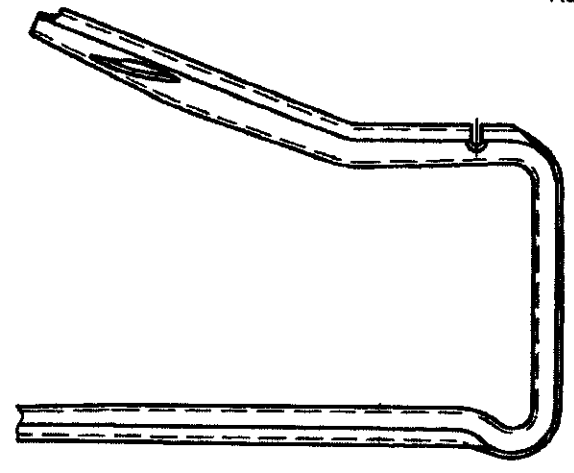
AK-630 СБ107-10СБ

Upper hose		Scale	
Лист / Sheet	Масса / Mass	Лист / Sheet	Масштаб / Scale
А / 1	8,200	А / 1	1:1
Рукав верхний / Upper hose		Сборочный чертеж / Assembly Drawing	
Лист / Sheet		Листов / Total Sheets	
		1	

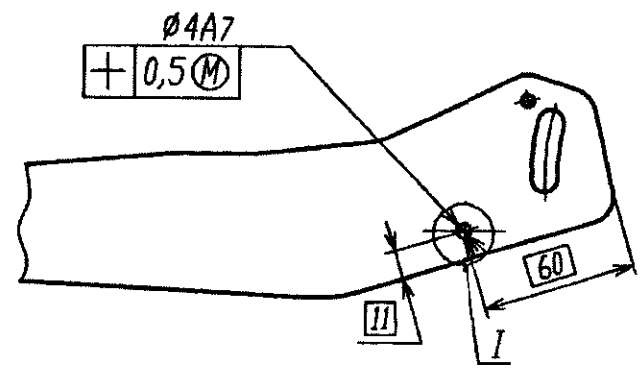
Всего 8 контейнеров 2

Формат А2

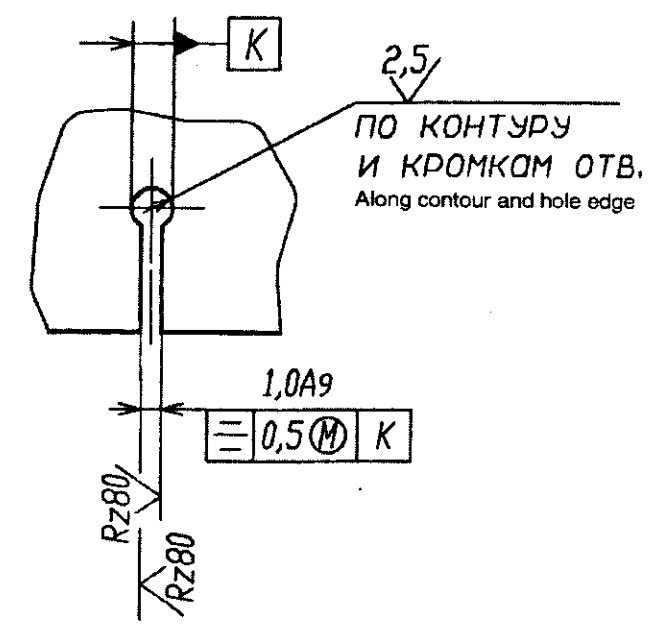
Рис. 2
Drawing 2
Остальное - см. Рис. 1 (лист 1)
Remaining - refer rawing 1 (Sheet 1)



Q₂ (1:2)



I(2:1)



ПО КОНТУРУ
И КРОМКОМ ОТВ.
Along contour and hole edge

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

First use

Reference No.

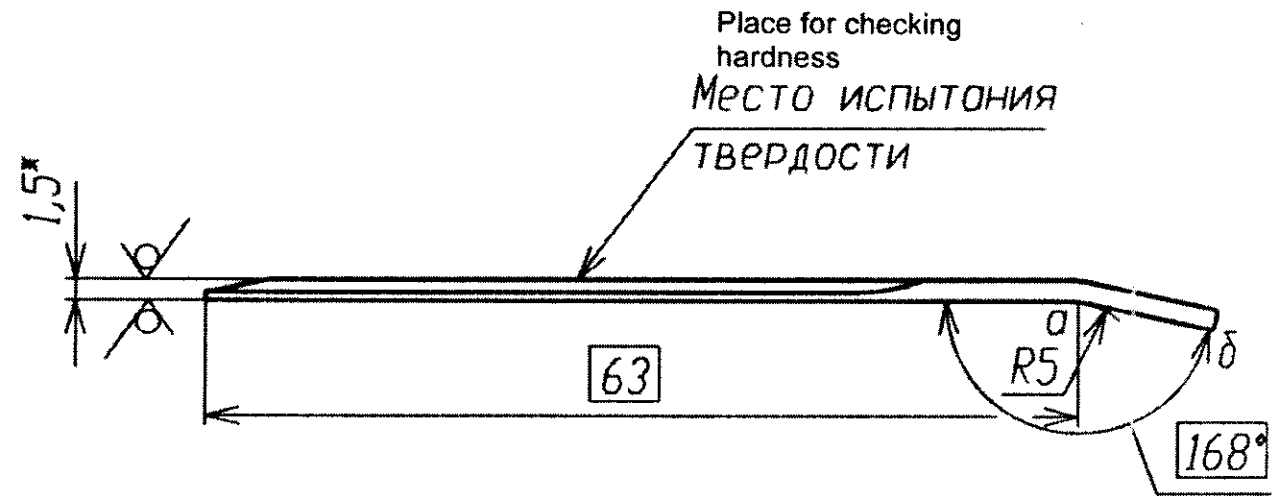
Sign and Date

Duplicate Inv. No

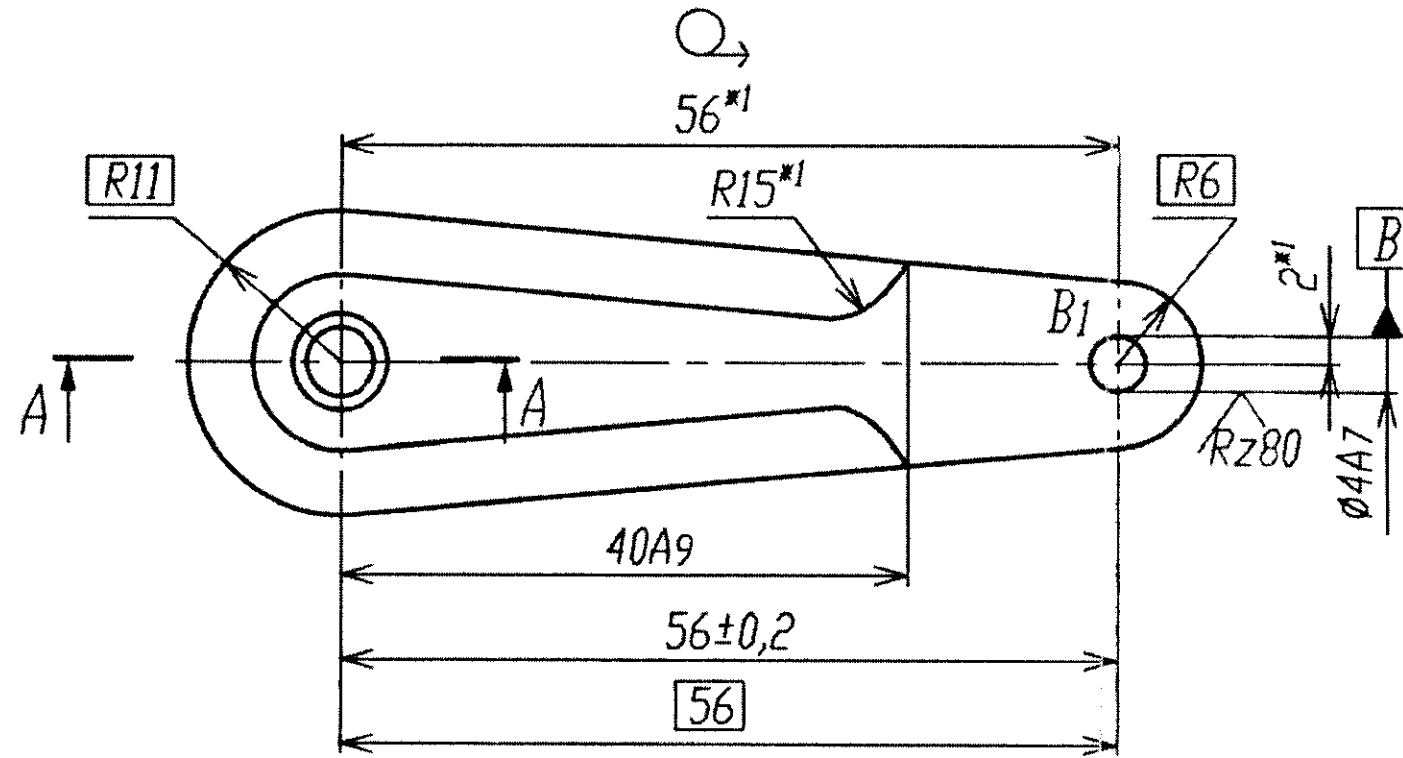
Alternate Inv. No

Sign and Date

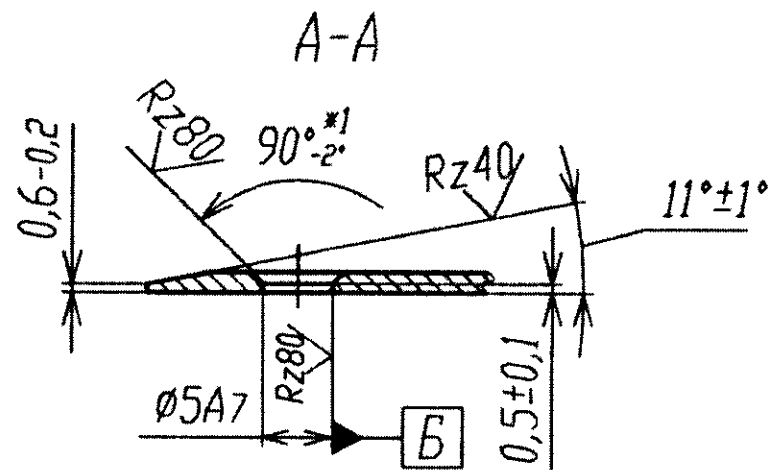
Orig. inv. no.



Rz160 (✓)



1. 29...35.0 HRC_E. Check hardness on 3..5% of the batch but not less than 3 nos.
2. Tolerance for shape of surface a6 T is 0.5 mm.
3. Tolerance for shape of profile of the blank with regard to surfaces B and B T 0.5 mm.
- 4.* Reference dimension.
- 5.*1 Dimension ensured by tool.
6. Coating Cd12. Cr.
7. B₁- locating point.
8. Mark Ш, Ч and stamp K, И on tag.



					AK-630 107-96			
Amend.	Sheet	Doc.No.	Sign	Date	Strap	Type	Weight	Scale
Developed by						A	0.015	2:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by					Sheet	B - PN - 01.5 GOST 19904 - 90 K 490V 4 - III - 40 GOST 16523 - 97		

First use

Reference No.

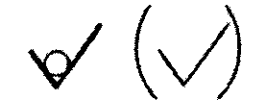
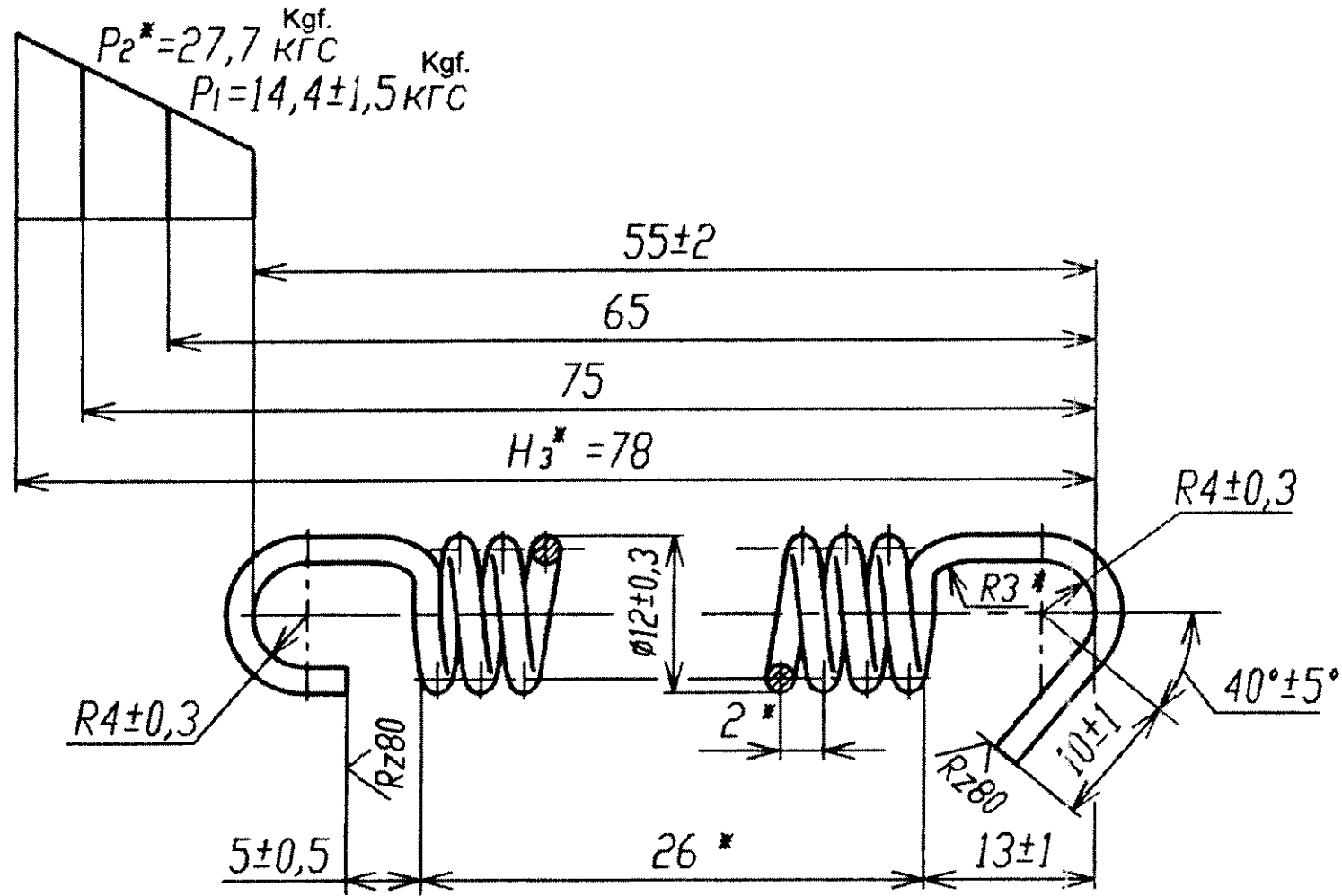
Sign and Date

Duplicate Inv. No

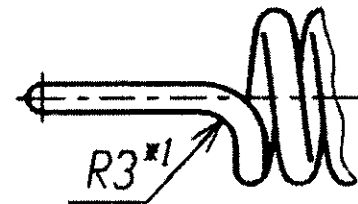
Alternate Inv. No

Sign and Date

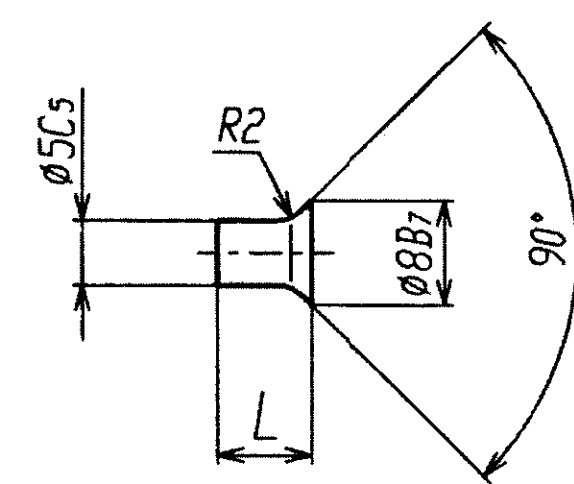
Orig. inv. no.



1. $G^* = 80000\text{Pa}$ (8000 kgf/mm².)
2. $\tau^* = 1320\text{MPa}$ (132 kgf/mm².)
3. Heat treatment : Tempering 240°-260°.
4. Pre deformation time (at Nz) -24 hours.
5. $n = 12$
6. Coiling direction- right.
7. Length of uncoiled spring $L^* = 460\text{ mm}$.
8. Coating: Chem.Phos. accel.Cr./ impregnation
Lacquer BF-4 black ,made as per OST 3-4123-78, 2 coats IV, OM2.
- 9.* Reference dimensions.
- 10.*1 Dimensions ensured by tool.
11. Stamp K on batch tag.
14. Other technical requirements as per GOST 16188-70 for springs accuracy group II.



					AK-630 107-97			
Amend.	Sheet	Doc.No.	Sign	Date	Spring	Type	Weight	Scale
Developed by						A	0.012	2:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D						Wire V-1-2 GOST 9389-75		
Approved by								

AK-630 107-2																				
Approved by shop Reference No.																				
Approved KTONI Sign and Date																				
Approved TOsb Dupl. Inv. No.																				
Approved OGMet Orig. Inv. No.																				
Sign and Date																				
Alternate Inv. No.																				
																				
<table border="1" style="margin: auto;"> <thead> <tr> <th>Designation</th> <th>L, mm</th> <th>Weight, kg</th> </tr> </thead> <tbody> <tr> <td>AK-630 107-2</td> <td>5.7 C₅ (-0.16)</td> <td>0.001</td> </tr> <tr> <td>-01</td> <td>7 C₅ (-0.2)</td> <td>0.001</td> </tr> <tr> <td>-02</td> <td>12 C₅</td> <td>0.002</td> </tr> <tr> <td>-03</td> <td>16 C₅</td> <td>0.003</td> </tr> </tbody> </table>						Designation	L, mm	Weight, kg	AK-630 107-2	5.7 C ₅ (-0.16)	0.001	-01	7 C ₅ (-0.2)	0.001	-02	12 C ₅	0.002	-03	16 C ₅	0.003
Designation	L, mm	Weight, kg																		
AK-630 107-2	5.7 C ₅ (-0.16)	0.001																		
-01	7 C ₅ (-0.2)	0.001																		
-02	12 C ₅	0.002																		
-03	16 C ₅	0.003																		
<p>1. Substitute material –Steel 12Cr18Ni10Ti GOST 5632-72. 2. Blunt sharp edges R~0.2 mm. 3. Mark Ш, Ч and stamp K on tag. 4. Other technical requirements as per GOST 10304-80.</p>																				
AK-630 107-2																				
				Rivet	Type A	Weight	Scale 2:1													
				Steel 12Cr18Ni9Ti GOST 5632-72		Sheet Sheets 1														

Copied by

Format A4

AK-630 107-3

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

Rz80 ✓ (✓)

Place for checking hardness
Место испытания ТВЕРДОСТИ

0,5

11°±1°

RZ40

0,5^{+0,2}_{-0,1}

90°*1

Ø5A5

0,6-0,2

1,5*

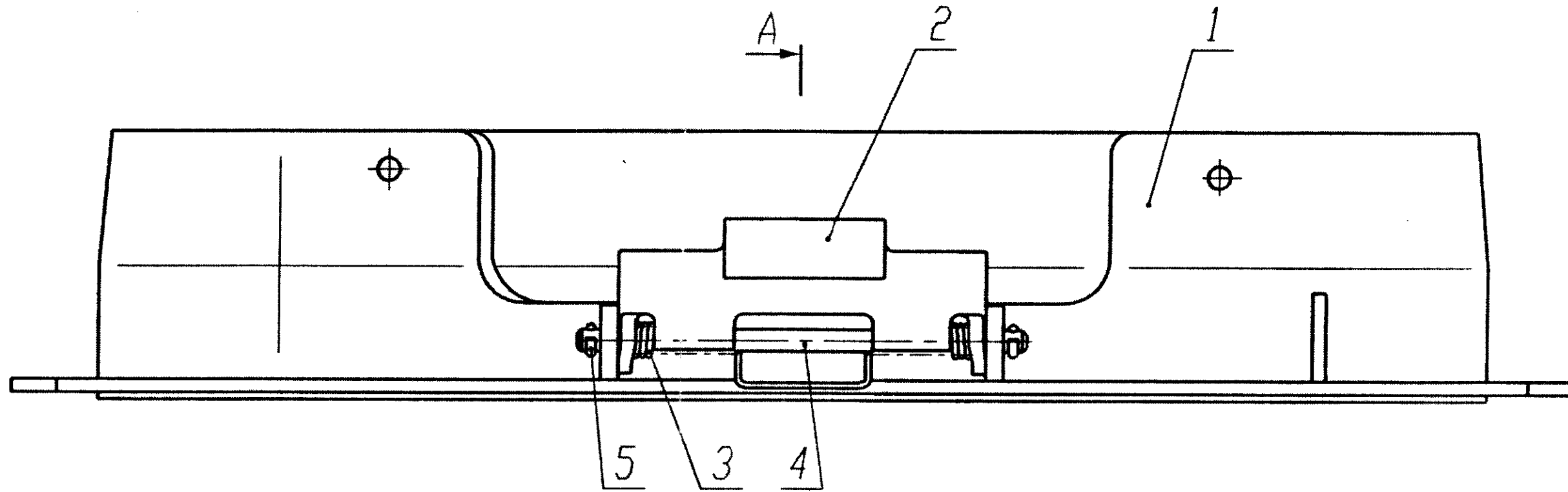
Copied by

Format A4

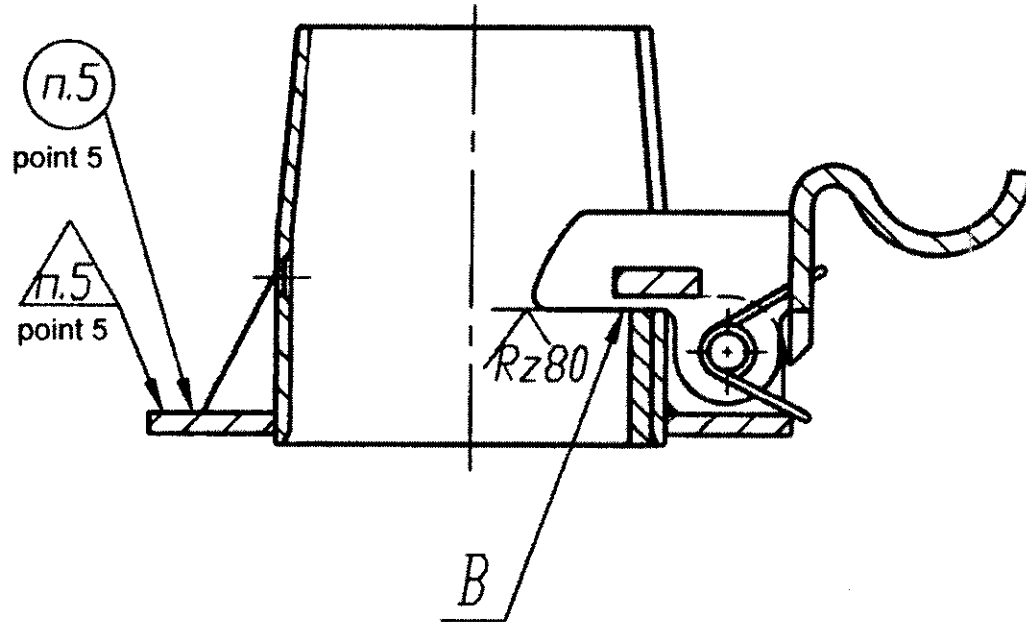
First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
						<u>Documents</u>		
Reference No.	A3			AK-630 Sb 107-11 SB	Assembly drawing			
					<u>Assembly units</u>			
	A4		1	AK-630 Sb107-14	Lower frame	1		
	A4		2	AK-630 Sb107-15	Catch	1		
					<u>Components</u>			
	*)		3	AK-630 107-41	Spring	1	*)Ax3	
	A4		4	AK-630 107-42	Pin	1		
					<u>Standard articles</u>			
Sign and Date			5		Cotter pin 2x16.029	2		
					GOST 397-79			
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date					AK-630 Sb 107-11			
	Amend.	Sheet	Doc. No.	Sign	Date			
Orig. Inv. No.	Developed by					Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D							
	Approved by							
						Lower frame		

First use

Reference No.



A-A



1. Catch pos.2 should swiftly return to initial position by spring pos.3.
2. Passage of belt N1 from bottom to top inside frame pos.1 should be smooth, without rubbing.
3. Catch should firmly hold suspended belt on it.
4. Ensure fitting of catch to the frame on plane B.
5. Lubricate rubbing surfaces with lubricant MS-70 GOST 9762-76.
6. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

Sign and Date

Duplicate Inv. No

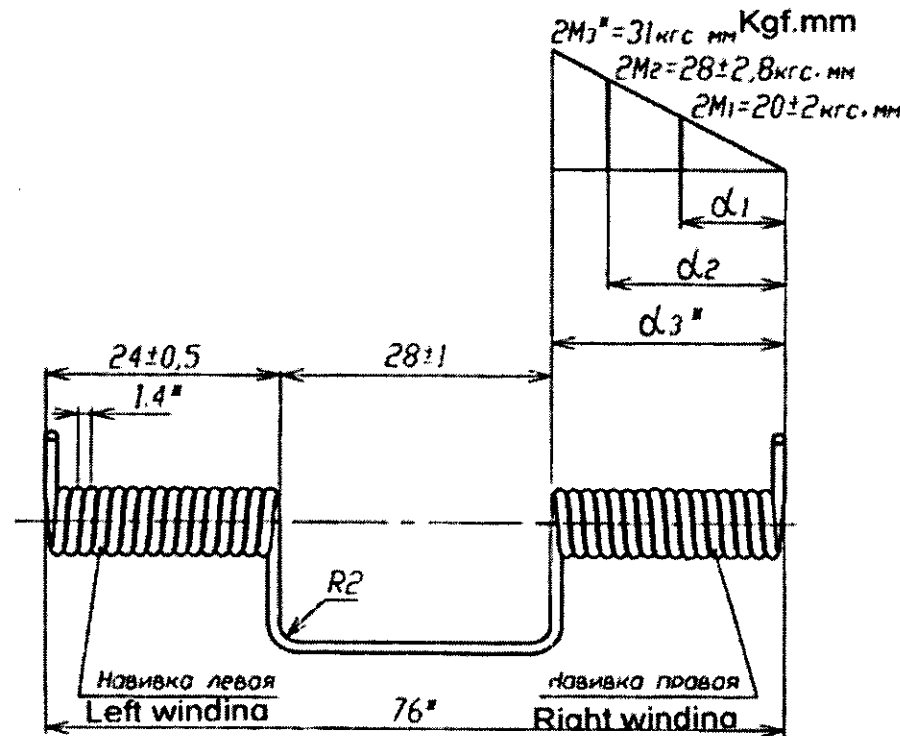
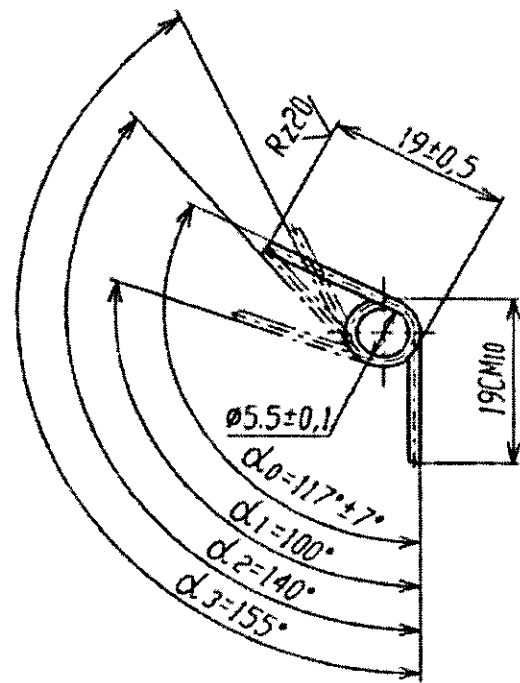
Alternate Inv. No

Sign and Date

Orig. inv. no.

					AK-630 Sb 107-11 SB				
Amend.	Sheet	Doc.No.	Sign	Date	Lower frame Assembly drawing	Type	Weight	Scale	
Developed by						A	1.120	1:1	
Checked by						Sheet	Sheets 1		
Head of Q.C.D									
Approved by									

AK-630 107-41

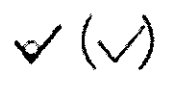


1. Группа II.
2. $E^* = 20000 \text{ кгс/мм}^2$ $\sigma_3^* = 95 \text{ кгс/мм}^2$.
3. Длина развернутой пружины $L^* = 850 \text{ мм}$.
4. Направление навивки - правое, левое.
5. $2n = 33$.
6. Термообработка - отпуск $240 \dots 260^\circ\text{C}$.
7. Время замотки (при α_3) 24 часа.
8. $D_c = 5C_5$.
9. Покрытие: Хим. фос. ускоренное хро. Лак БФ-4 с нигрозином, 2 слоя, приготовление по ОСТ 3-4123-78, IV, OM2.
10. * Размеры и параметры для справок.
11. Остальные технические требования по ОСТ 3-2561-91.
12. Маркировать Ш, Ч и клеить К, И на бирке.

6. Heat treatment – tempering $240 \dots 260^\circ\text{C}$.
7. Pre-deformation time (during α_3) 24 hours.
8. $D_c = 5C_5$.
9. Coating Chem. Phos. accelerated chrome. Varnish БФ-4 with nigrosine, 2 layers, preparation as per OСТ 3- 4123-78, IV, OM2.
10. * - Dimensions and parameters for reference.
11. Remaining technical requirements as per OСТ 3-2561-91.
12. Mark Ш, Ч, and stamp К, И on the tag.

				AK-630 107-41		
				Тип	Mass	Scale
				Лист	Масса	Масштаб
				A	0,007	2:1
				Лист Листов 1		
				Sheet Total Sheets		
				SPRING ПРУЖИНА		
				WIRE Проволока В-1-1,2 ГОСТ 9389-75		

Проверено
 Согласовано
 Разработано
 Проверено
 Утверждено



AK-630 107-42

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

Rz40 ✓ (✓)

1. 38.5...44.5 HRC_E. Check hardness on 3-5% of the batch but not less than 3 nos.
 2. * Reference dimension.
 3. Blunt sharp edges R~0.4 mm.
 4. Coating Cd6.phos.
 5. Mark Ш, Ч and stamp K, И on tag.

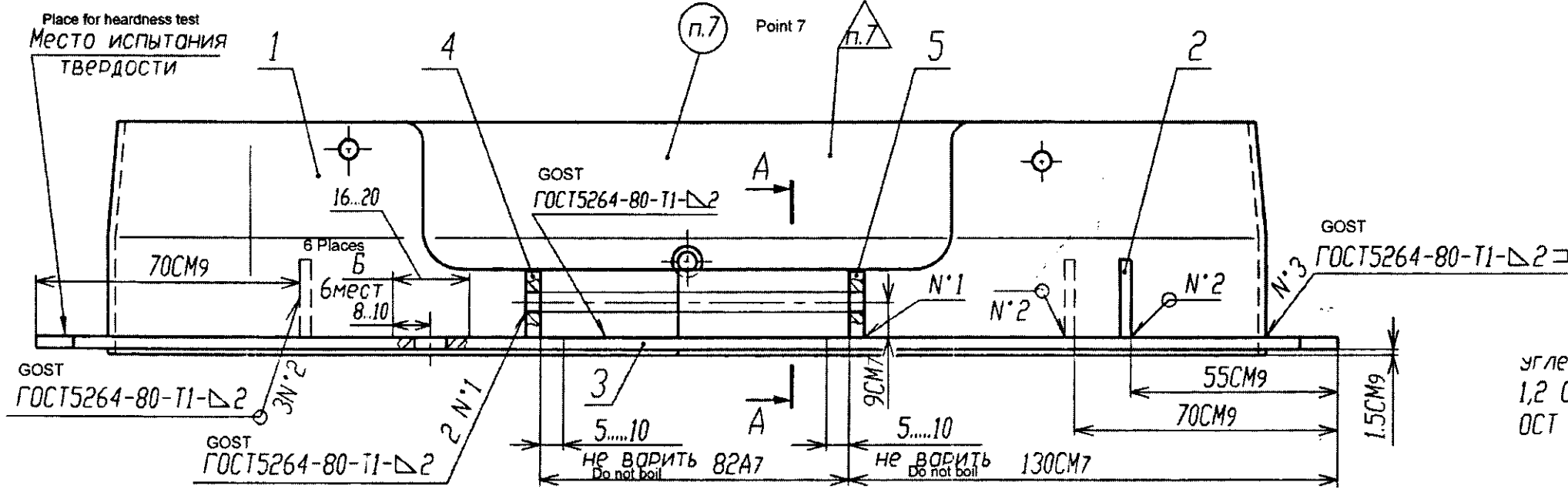
AK-630 107-42									
Amend.	Sheet	Doc. No.	Sign	Date	Pin	Type	Weight	Scale	
Developed by						A	0.015	2:1	
Checked by						Sheet	Sheets 1		
Head of Q.C.D									
Design bureau chief									
Head of Q.C.D					Wheel 5 - 5GOST 7417 - 75				
Approved by					50 - T - V GOST 1051 - 73				

Copied by

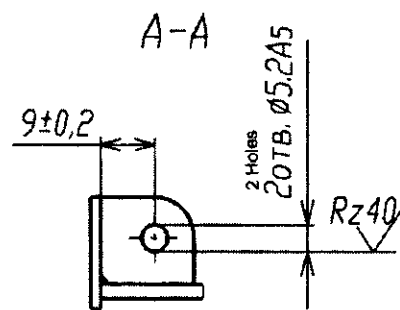
Format A4

AK-630 СБ107-14СБ

AK - 630 Sb 107 - 14SB



1. Electrode UONI 13/45-2,0-2 GOST 9466-75.
2. Допускается полуавтоматическая сварка в среде углекислого газа с применением присадочной проволоки 1,2 Св-08 ГС ГОСТ 2246-70. Сварные швы II категории ОСТ 3-4001-91.
3. В зонах Б - не варить.
4. После сварки сборку нормализовать.
5. 29...35 HRC_с. В месте замера твердости допускается зачистка до 0,5 мм.
6. Покрытие Кd12. фос. Лак ВФ-4 с нигрозином, 1 слой приготовления по ОСТ 3-4123-78, IV, OM2.
7. Маркировать Ш, Ч и клеймить К, И по АК-630, АК-630М ТУ I.



1. Electrode UONI 13/45-2,0-2 GOST 9466-75.
2. Semi-automatic welding in the medium of carbonic acid gas with the use of electrode filler 1,2 Sv-08 G2S GOST 2246-70 is permitted. Welding joints of II category OST 3-4001-91.
3. In the zones Б - do not boil.
4. After welding, normalize the assembly.
5. 29...35 HRC_с. Finishing at the places for hardness test is permitted up to 0.5 mm.
6. Coating Cad. 12 Phos. Varnish BF-4 with nigrogin, 1 layer, preparation as per OST 3-4123-78, IV, OM2.
7. Mark Ш, Ч and stamp К, И as per АК-630, АК-630М ТУ I.

AK - 630 Sb 107 - 14SB

				AK-630 СБ107-14СБ		
				Type	Mass	Scale
				Лит.	Масса	Масштаб
Изм.	Лист	№ докум.	Подп.	Дата		
РАЗР.					A	0,970 1:1
ПРОВ.						
Т.КОНТ.					Лист	Листов 1
И.КОНТ.					Sheet	Total Sheet 1
УТВ.						

Вале 8 container 2

Формат А4х3

Листов 1

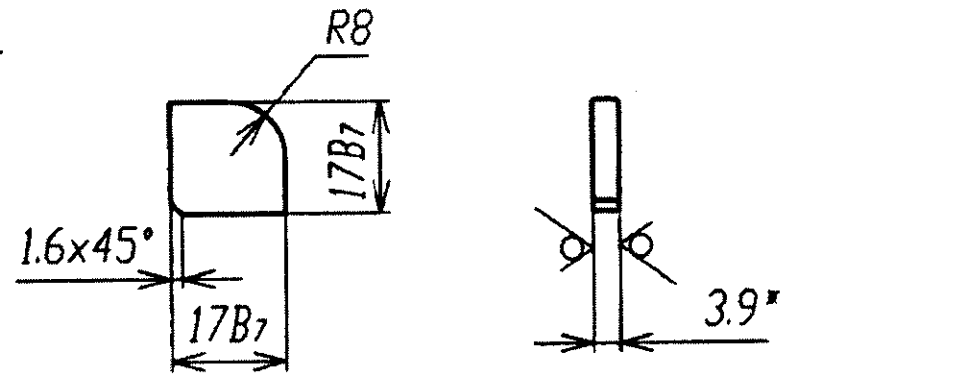
Слов N

Изм N

Изм N

AK-630 107-56

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



Rz80 (✓) (✓)

- 1.* Reference dimension.
- 2. Blunt sharp edges R~0.6 mm.
- 3. Mark Ш, Ч and stamp K on tag.

Amend.	Sheet	Doc. No.	Sign	Date

AK-630 107-56			
Type	Weight	Scale	
A	0.010	1:1	
Sheet		Sheets 1	
Sheet $\frac{B - PN - 03.9 GOST 19903 - 74}{K490V 4 - III - 35 GOST 16523 - 97}$			

Copied by

Format A4

AK-630 107-55																																							
Approved OGMet	Orig. Inv. No.	Sign and Date	Approved TOsb	Dupl. Inv. No.	Sign and Date																																		
Approved KTONI	Sign and Date	Approved by shop	Reference No.	First use																																			
<p>1.* Reference dimension. 2. Blunt sharp edges R~0.6 mm. 3. Mark Ш, Ч and stamp K on tag.</p>																																							
AK-630 107-55																																							
<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th>Amend.</th> <th>Sheet</th> <th>Doc. No.</th> <th>Sign</th> <th>Date</th> </tr> </thead> <tbody> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> </tbody> </table>			Amend.	Sheet	Doc. No.	Sign	Date																					<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th>Type</th> <th>Weight</th> <th>Scale</th> </tr> <tr> <td style="text-align: center;">A</td> <td style="text-align: center;">0.011</td> <td style="text-align: center;">1:1</td> </tr> <tr> <td colspan="2">Sheet</td> <td>Sheets 1</td> </tr> </table>			Type	Weight	Scale	A	0.011	1:1	Sheet		Sheets 1
Amend.	Sheet	Doc. No.	Sign	Date																																			
Type	Weight	Scale																																					
A	0.011	1:1																																					
Sheet		Sheets 1																																					
Developed by Checked by Head of Q.C.D Design bureau chief Head of Q.C.D Approved by			Front support Sheet $B - PN - 03.9GOST19903 - 74$ $K490V4 - III - 35GOST16523 - 97$																																				

Copied by

Format A4

First use

Reference No.

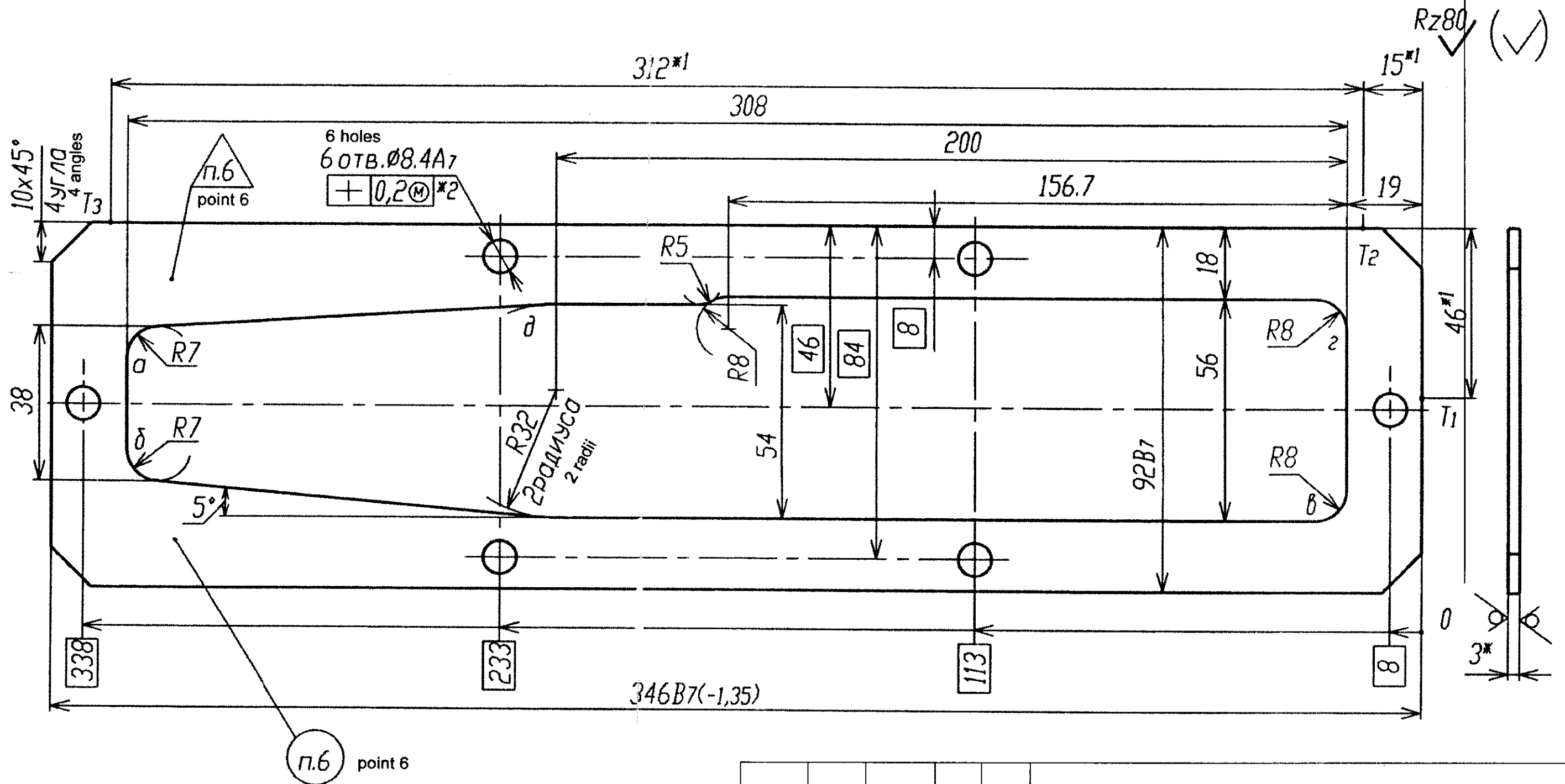
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



- 1.* Reference dimension.
- 2.*1 Dimensions ensured by tool.
- 3.*2 Deviation given with respect to points T₁, T₂, T₃.
- 4. Tolerance for contour абвгд- 0.3 mm with respect to datum points T₁, T₂, T₃.
- 5. Blunt sharp edges R~0.6 mm.
- 6. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

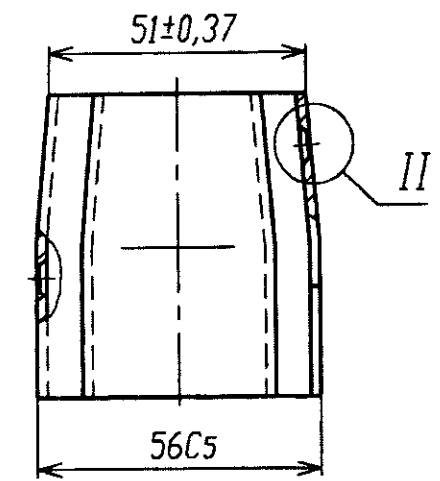
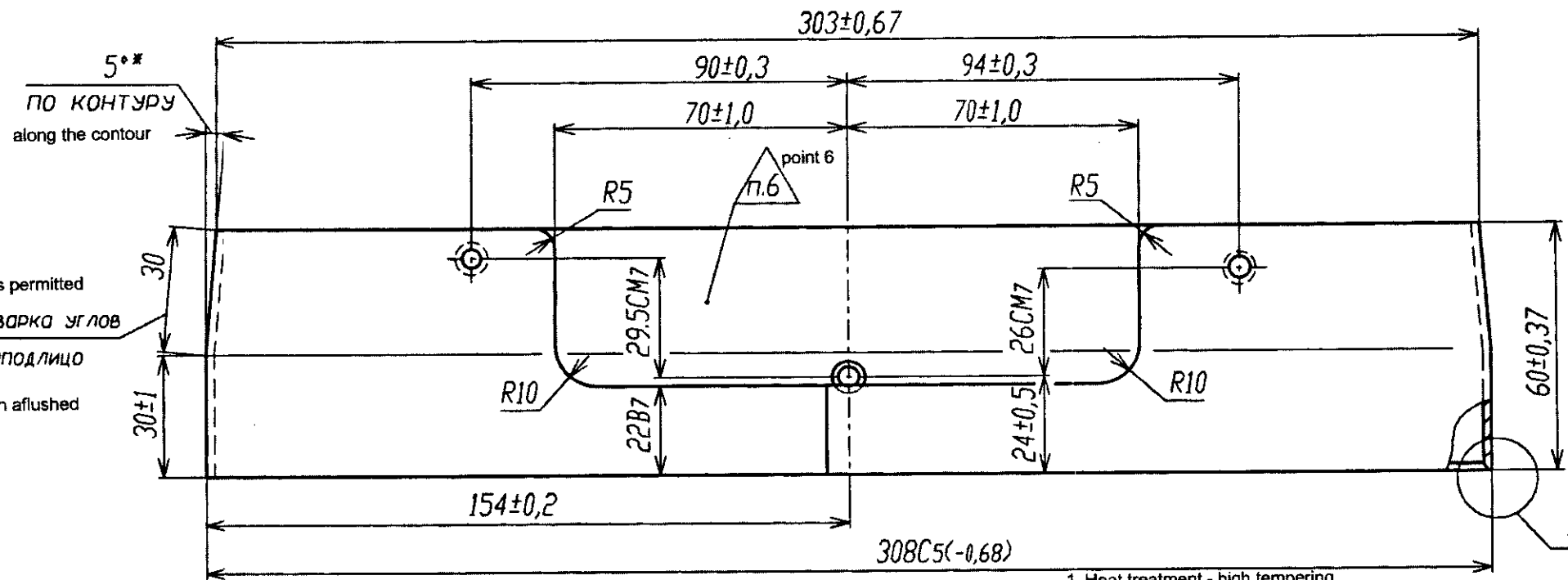
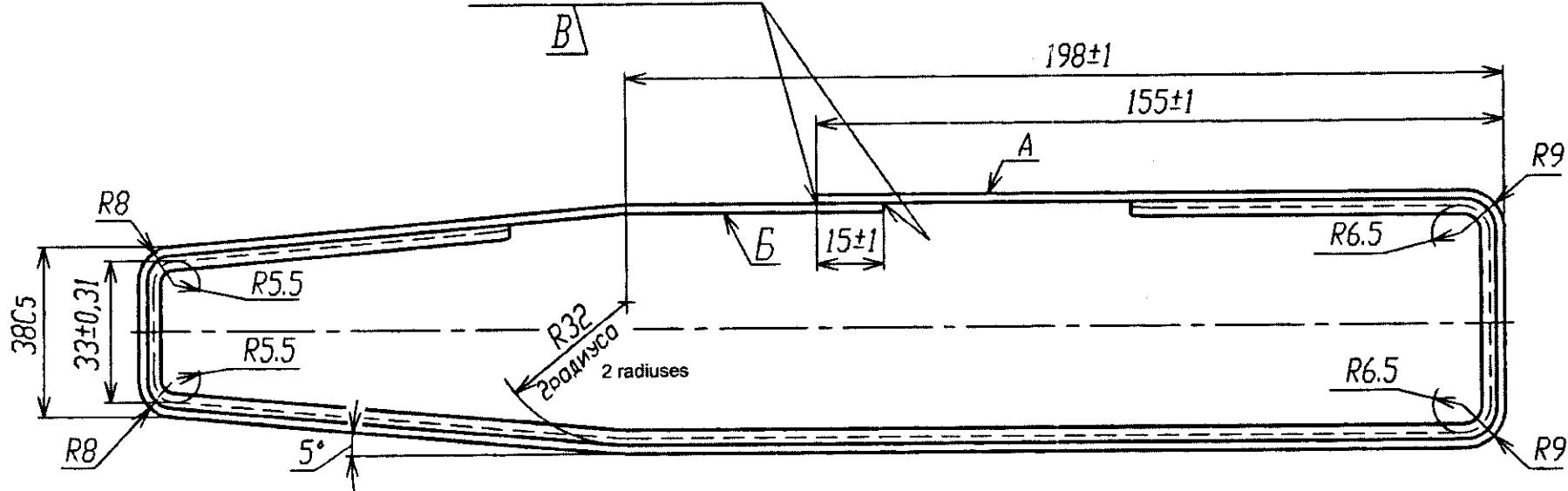
Amend.	Sheet	Doc.No.	Sign	Date

AK-630 107-54			
Type	Weight	Scale	
		A	0.360
Sheet	Sheets 1		
Sheet <i>B - PN - 03 GOST 19903 - 74</i> <i>K 490 V 4 - III - 35 GOST 16523 - 97</i>			

AK-630 107-32

GOST
ГОСТ 5264-80-Н1-Δ2

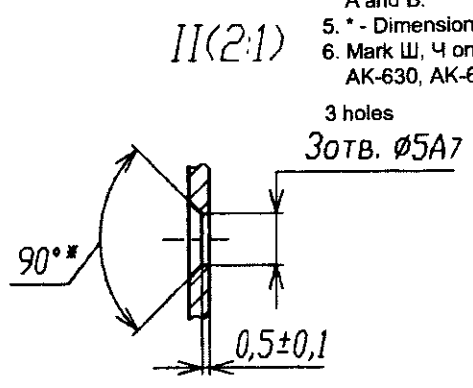
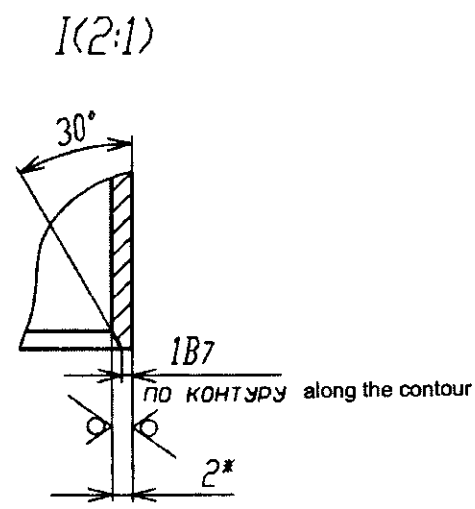
Rz80 (✓)



Welding of angles is permitted
Допускается сварка углов
Зачистить заподлицо
Finish aflushed

1. Heat treatment - high tempering.
2. Electrode УОНИИ 13/45-2.0-2 GOST 9466-75.
3. Welding as per GOST 14771-76-УП-Н1-2 is permitted with the electrode 1.2 СВ-0.8 Г2С GOST 2246-70.
4. Finish the welded joints B aflushed with planes A and Б.
5. * - Dimension for reference.
6. Mark Ш, Ч on the tag and stamp K as per AK-630, AK-630M TU 1.

1. Термообработка - высокий отпуск.
2. Электрод УОНИИ 13/45-2,0-2 ГОСТ 9466-75.
3. Допускается сварка по ГОСТ 14771-76-УП-Н1-Δ2 проволокой 1,2 СВ-0,8 Г2С ГОСТ 2246-70.
4. Сварные швы В зачистить заподлицо с плоскостями А и Б.
5. *Размер для справок.
6. Маркировать Ш, Ч на бирке и клеймить К по АК-630, АК-630М ТУ 1.



AK-630 107-32		Lit	Wt.	Scale
Lower Frame		Лит.	Масса	Масштаб
Рамка нижняя		A	0,515	1:1
BT-PN-0 2 GOST 19904-90		Лист	Листов	
Sheet BT-PN-0 2 GOST 19904-90		Лист	Листов	
К490В 4-III-35 ГОСТ 16523-97				

Лев. примен.
Слов. и
Взвешив. и
Изн. подл.

First use

Reference No.

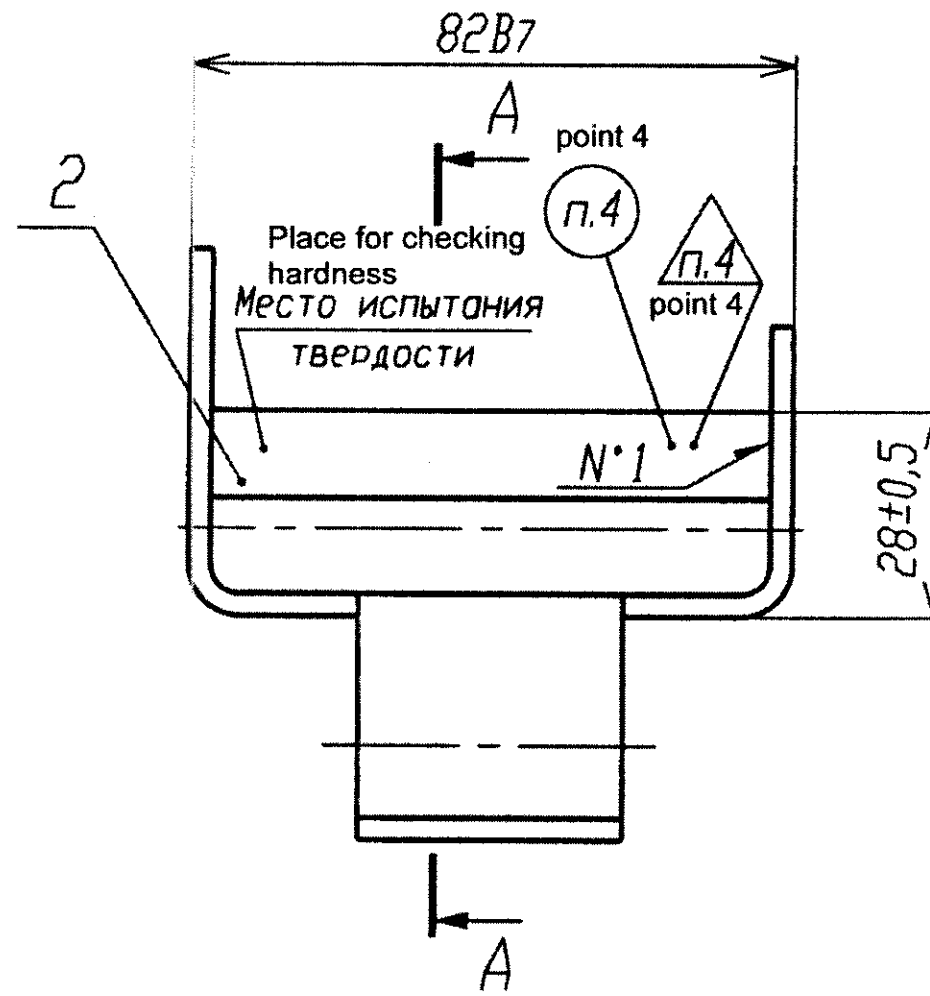
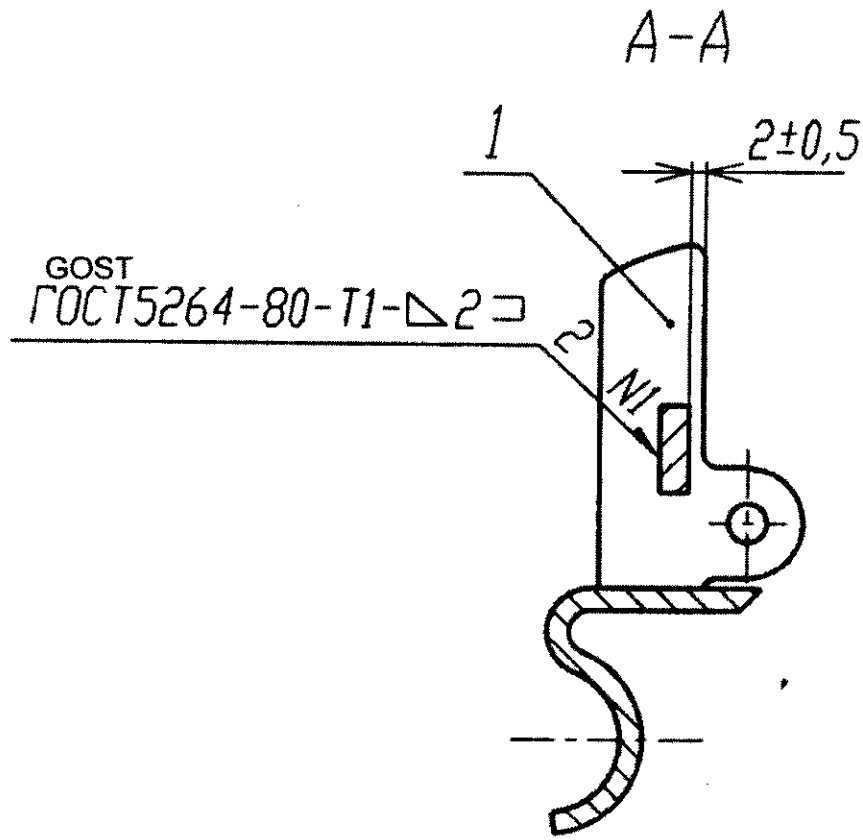
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. Welding rod 13/45-2.0-2 GOST 9466-75.
2. 29..35 HRC_E. Filing up to 0.5 mm is permissible on place for checking hardness.
3. Coating Cd12, phos.
Lacquer BF-4 with Nigrozene, single layer , made as per OST 3-4123-78, IV. OM2.
4. Mark Ш, Ч and stamp K, И as per AK_630, AK-630M TU I.

					AK-630 Sb 107-15 SB					
					Catch Assembly drawing			Type	Weight	Scale
								A	1.120	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.

Sign and Date

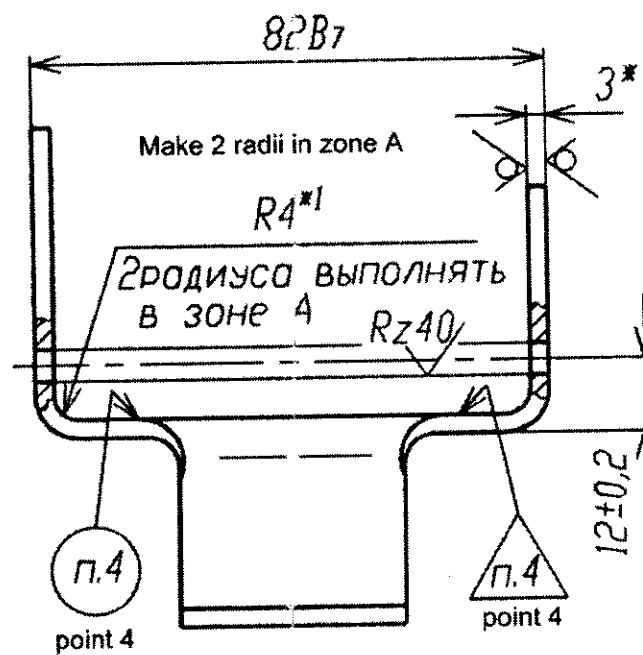
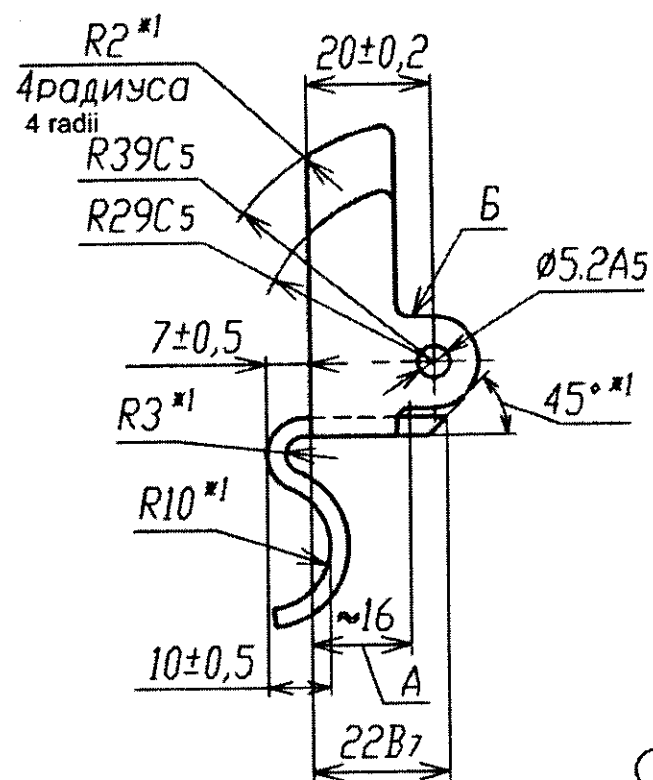
Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

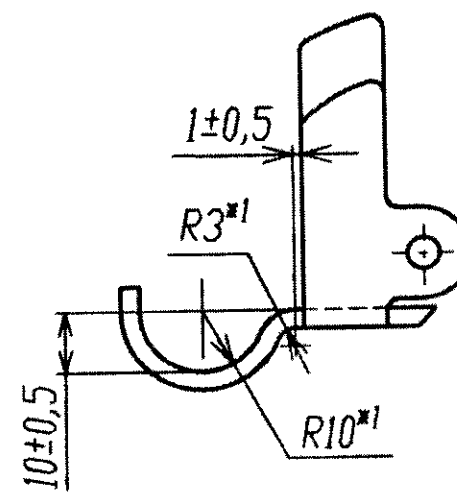
drawing 1
Рис.1



drawing.2
Рис.2

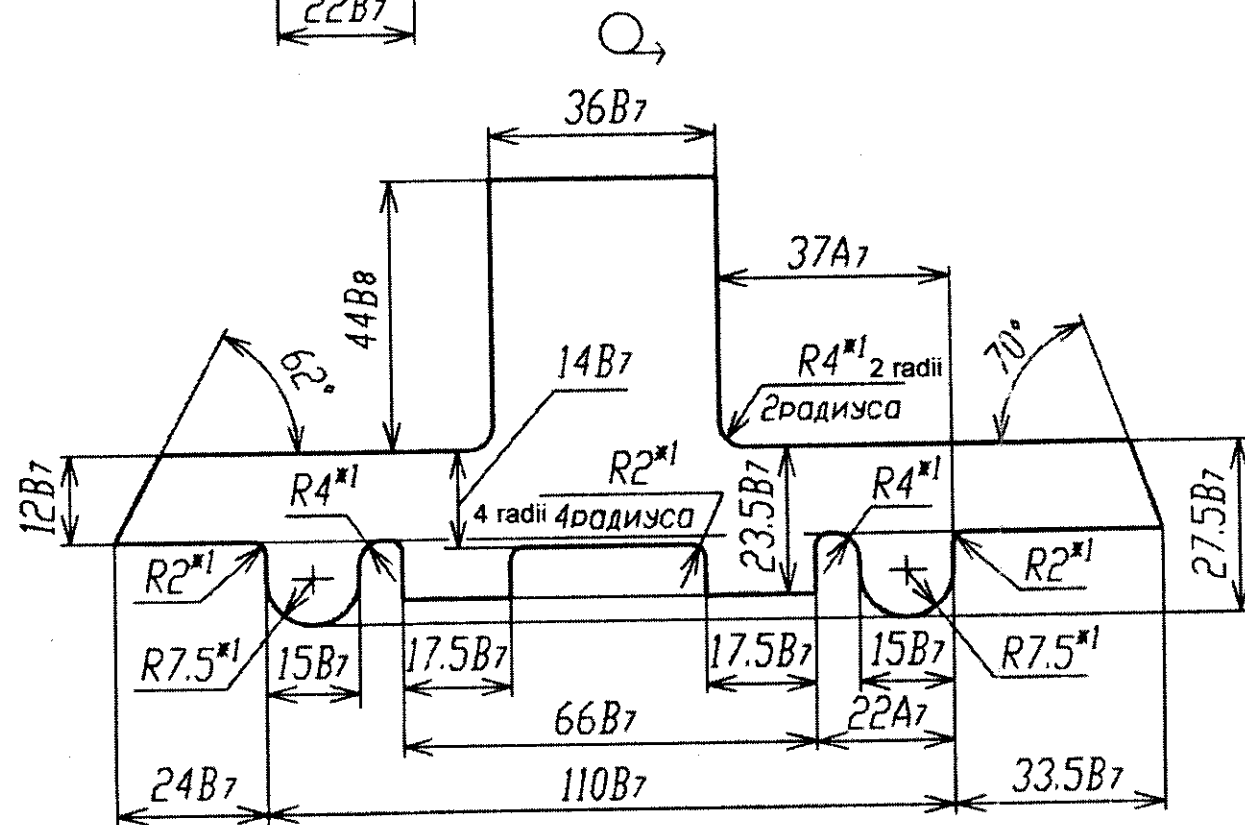
Rz80 (✓) (✓)

Остальное - см. Рис.1
Remaining refer drawing 1



Designation	Drawing
Обозначение	Рис
AK-630 107-58	1
AK-630 107-58-01	2

- 1.* Reference dimension.
- 2.*1 Dimension ensured by tool.
3. Deviation in height of surfaces Б not more than 0.5 mm.
4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.



Amend.	Sheet	Doc.No.	Sign	Date

AK-630 107- ⁵⁸ 58-01			
Catch	Type	Weight	Scale
	A	0.100	1:1
Sheet	Sheets 1		
Head of Q.C.D			
Approved by			
Sheet	B - PN - 03 GOST 1993 - 74 K490V4 - III - 35 GOST 16523 - 97		

AK-630 107-59						
Approved OGMet	Orig. Inv. No.	Sign and Date	Alternate Inv. No.	Approved TOSb	Dupl. Inv. No.	
Approved KTONI	Sign and Date	Approved by shop	Reference No.	First use		
<p>1.* Reference dimension. 2. Blunt sharp edges R~0.6 mm. 3. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.</p>						
AK-630 107-59						
				Type	Weight	Scale
Strap				A	0.030	1:1
				Sheet	Sheets 1	
				Sheet $\frac{B - PN - 03.9 GOST 19903 - 74}{K 490V 4 - III - 35 GOST 16523 - 97}$		
				Approved by _____		

Copied by

Format A4

First use

Reference No.

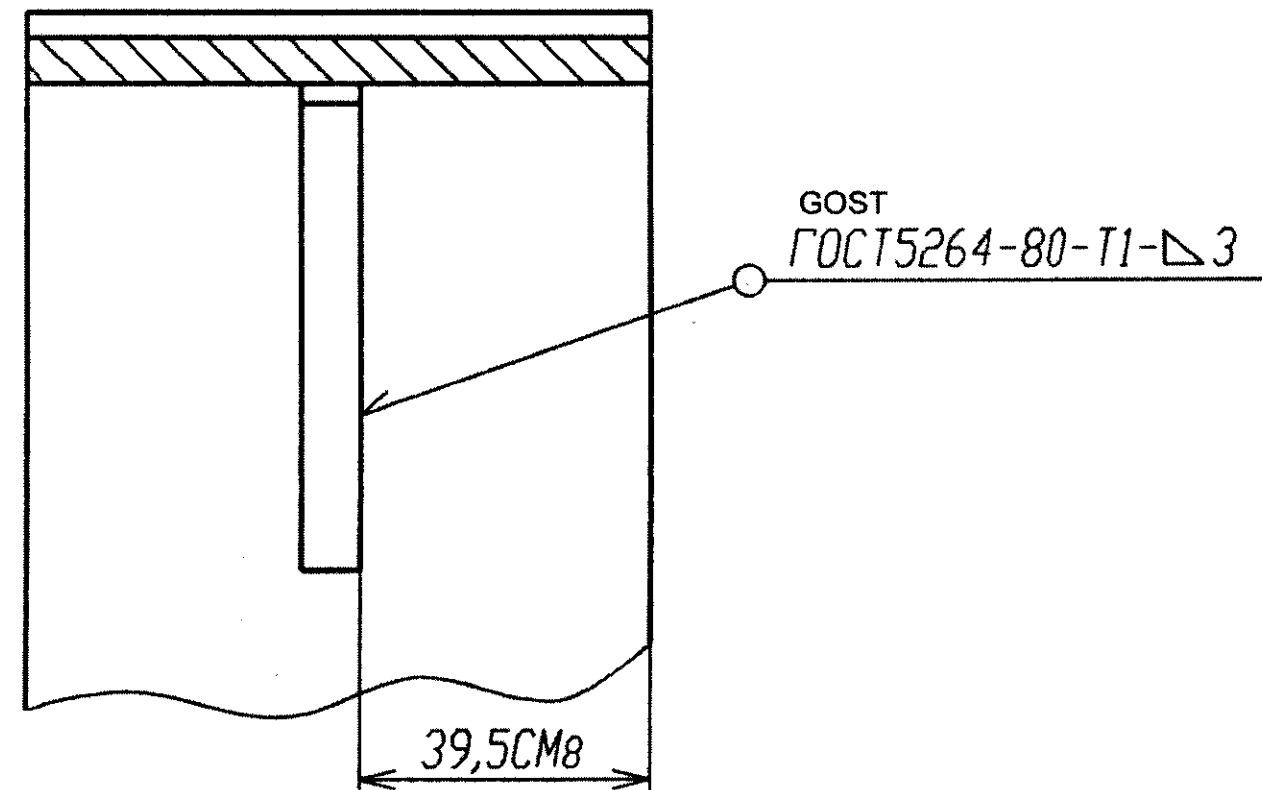
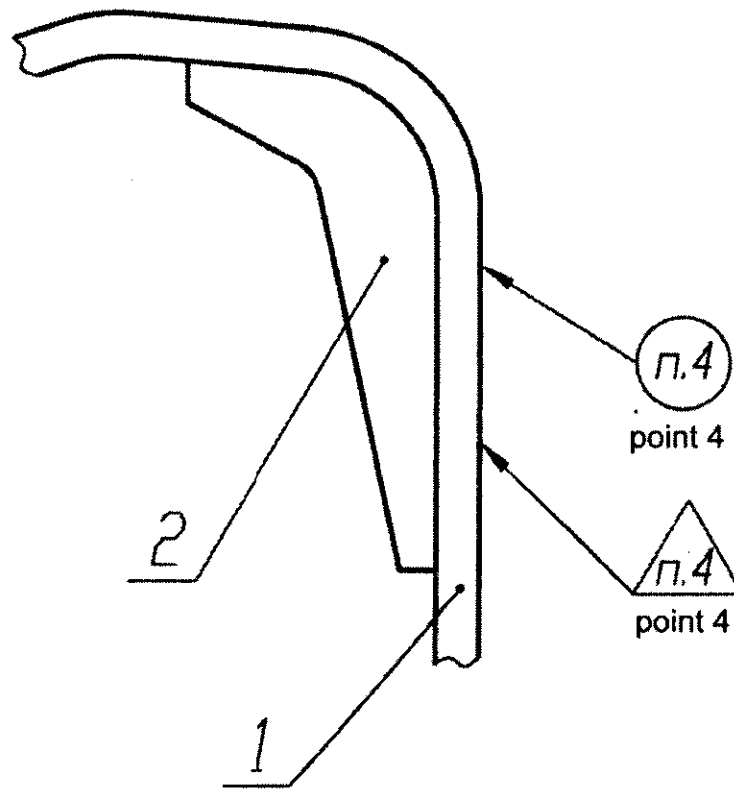
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. Welding rod 13/45-2.0-3 GOST 9466-75.
2. Semi automatic welding in carbon dioxide medium by using filler wire 1.2 Sv-08 G2S 2246-70 is permissible.
3. Deviation of contour AK-630 107-44, after making assembly, from contour of template made as per 5 th accuracy grade- 2 mm.
4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 Sb 107-12 SB				
Amend.	Sheet	Doc.No.	Sign	Date	Strip Assembly drawing	Type		Weight	Scale
Developed by						A		1.840	1:1
Checked by						Sheet		Sheets 1	
Head of Q.C.D									
Approved by									

First use

Reference No.

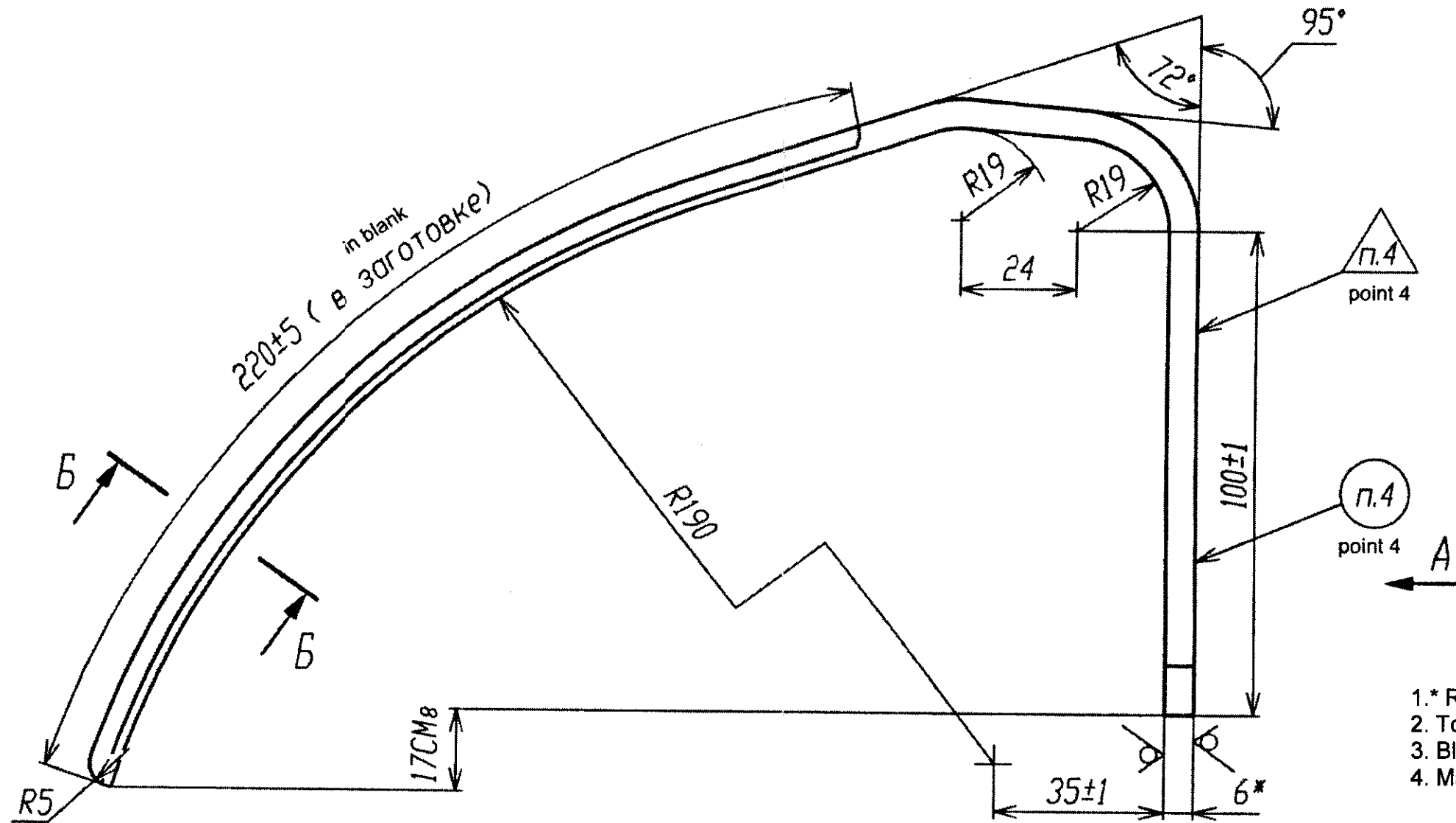
Sign and Date

Duplicate Inv. No

Alternate Inv. No

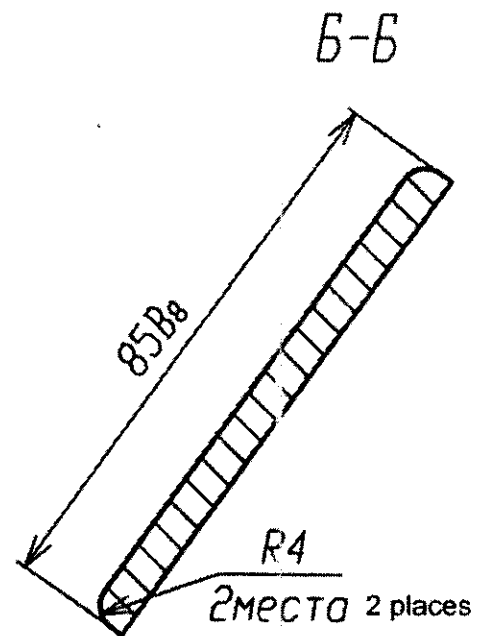
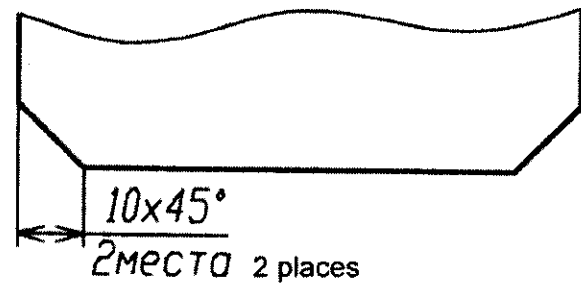
Sign and Date

Orig. inv. no.



Rz80 (✓)

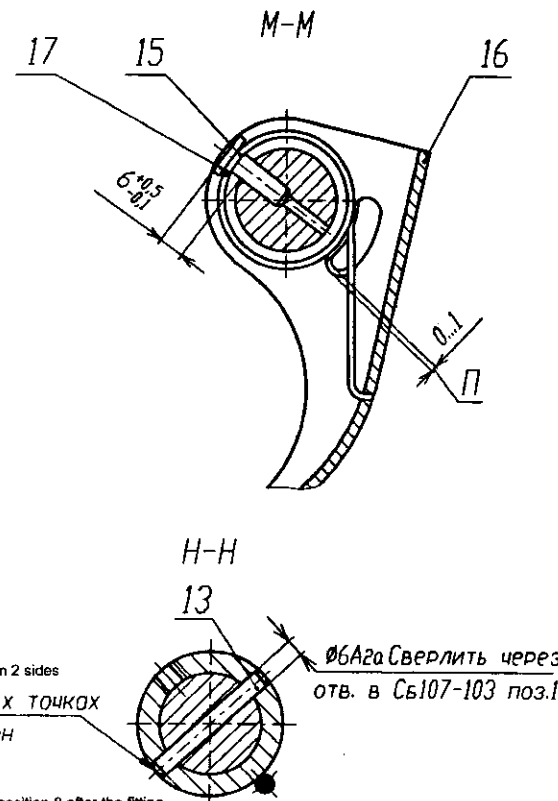
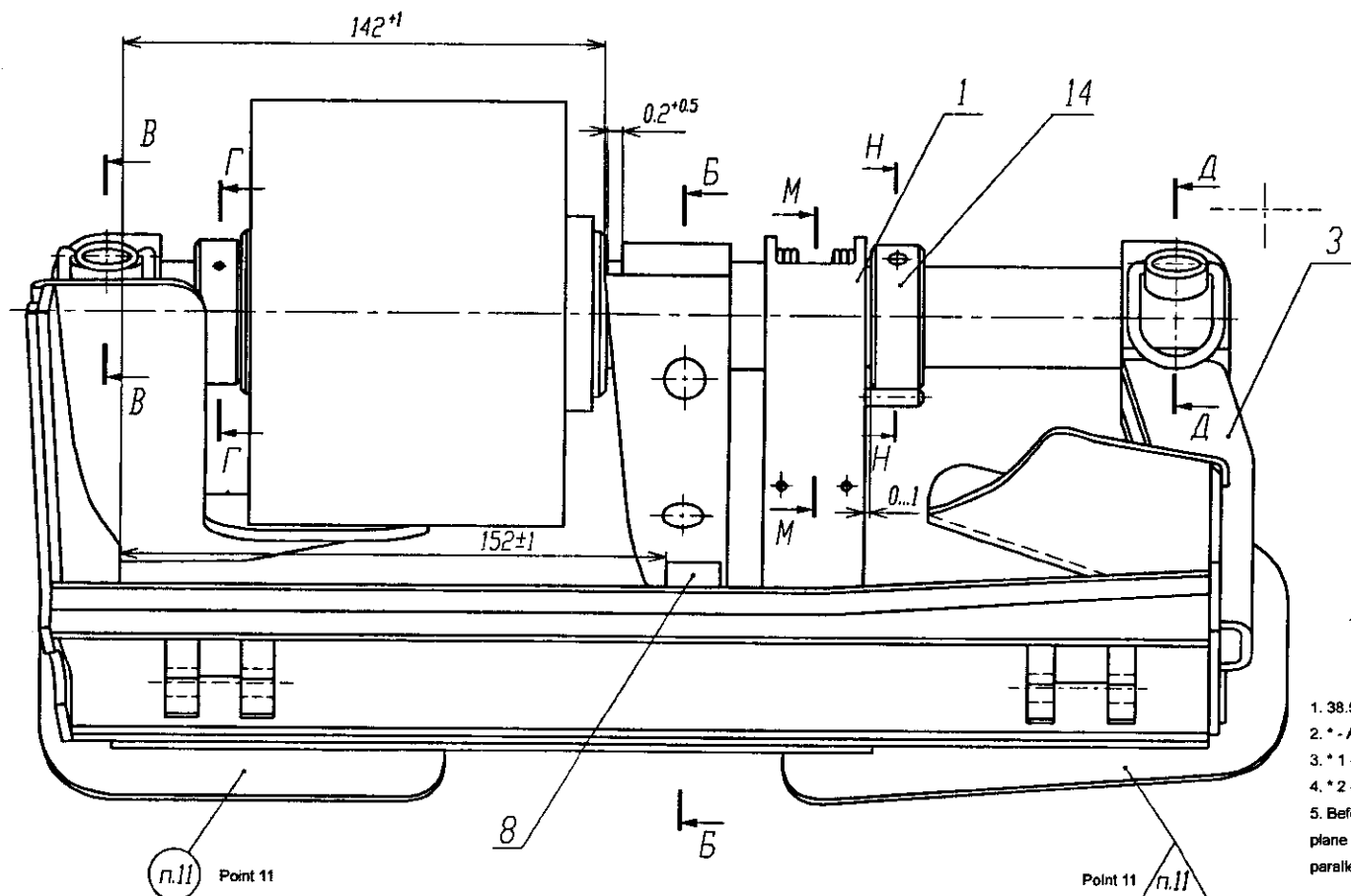
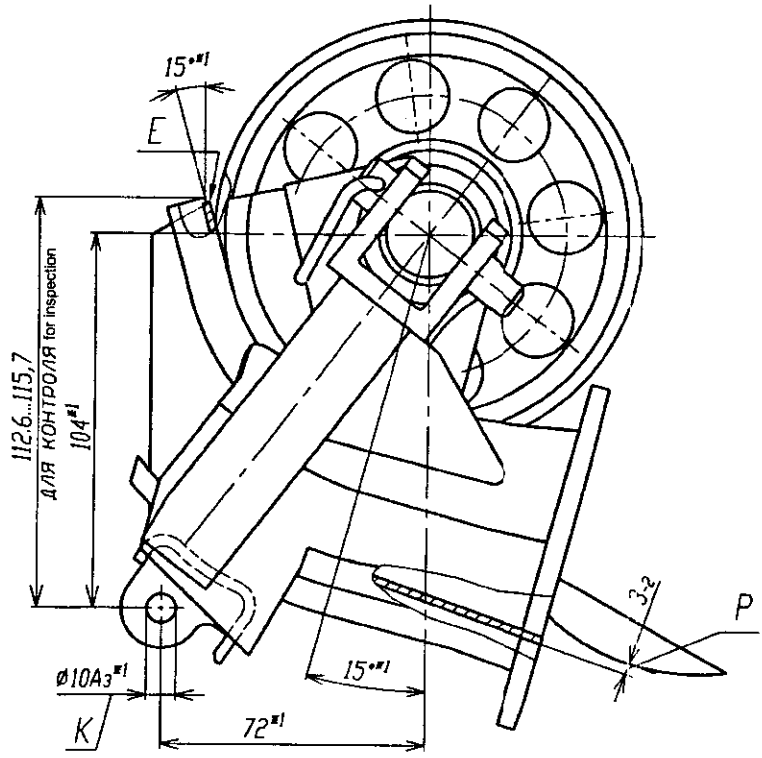
- 1.* Reference dimension.
2. Tolerance for contour of component- 1 mm.
3. Blunt sharp edges ~0.6 mm.
4. Mark Ш, Ч and stamp K as per AK-630, AK-630 TU I.



					AK-630 107-44			
Amend.	Sheet	Doc.No.	Sign	Date	Strip	Type	Weight	Scale
							A	1.460
Developed by						Sheet	Sheets	1
Checked by								
Head of Q.C.D								
Approved by								
					Sheet	$\frac{B - PN - 6GOST19903 - 74}{35 - 2GOST1577 - 93}$		

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
					<u>Documents</u>			
Reference No.	A1			AK-630 Sb107-13 SB	Assembly drawing			
					<u>Assembly units</u>			
	A4		1	AK-630 Sb107-16	Shaft	1		
	A4		2	AK-630 Sb107-17	Pin	2		
	A4		3	AK-630 Sb107-18	Collar	1		
	A4		14	AK-630 Sb107-19	Lock	1		
					<u>Components</u>			
		A3		4	AK-630 107-47	Support	1	
Sign and Date	A3		5	AK-630 107-48	Spring	2		
	A4		6	AK-630 107-49	Locator	2		
	A2		7	AK-630 107-50	Stop	1		
	A3		8	AK-630 107-51	Skid	1		
	A4		9	AK-630 107-52	Lock ring	1		
	A3		15	AK-630 107-93	Spring	1		
	A2		16	AK-630 107-94	Safety valve	1		
	A4		17	AK-630 107-95	Pin	1		
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date								
Orig. Inv. No.	AK-630 Sb 107-13							
	Amend.	Sheet	Doc. No.	Sign	Date			
	Developed by					Type	Sheet	Sheets
	Checked by					A	1	2
	Head of Q.C.D							
Approved by								

Collar

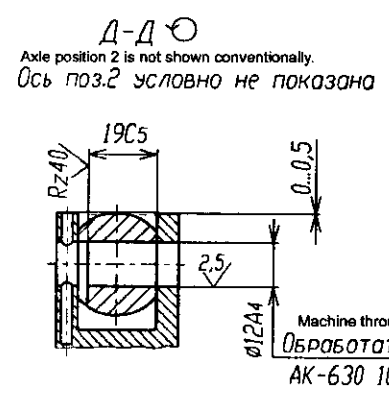
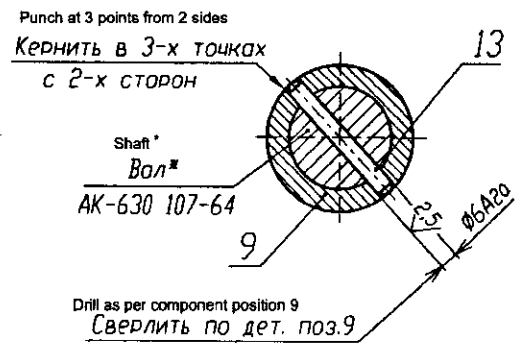
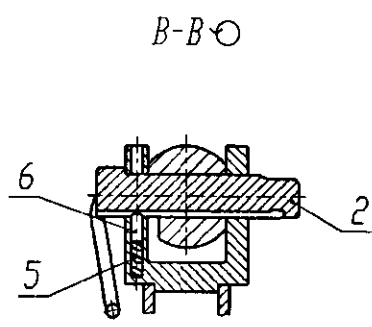
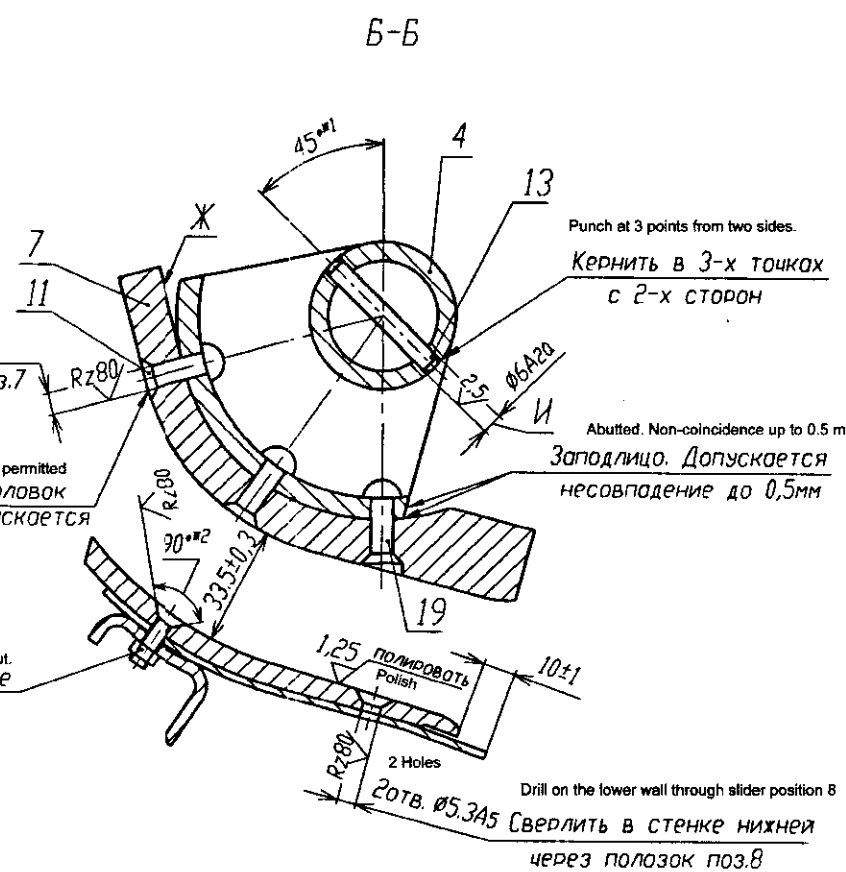
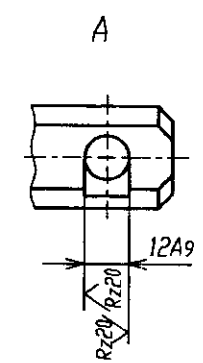


Punch at 3 points from 2 sides
Кернить в 3-х точках с 2-х сторон

Ø6A2 сверлить через отв. в Сб107-103 поз.14

- 38.5...44.5 HRCs of strip position 8 after the fitting.
- * - Article for reference.
- * 1 - Dimensions for reference.
- * 2 - Dimensions are to be ensured by tool.
- Before the drilling of hole И, set the location of stop position 5 on the plane E. Sinking in of plane Ж from the plane E in respect of plane, which passes through the axis of hole K and in parallel to later one is 0.6...1 mm.

- 38.5...44.5 HRCs ползка поз. 8 после пригонки.
- * Изделие для справок.
- * 1 Размеры для справок.
- * 2 Размеры обеспечен стр.
- Перед сверлением отв. И установить положение упора поз. 7 по плоскости E. Утопание плоскости Ж от плоскости E относительно плоскости, проходящей через ось отв. K и параллельно последней 0,6...1 мм.
- Для обеспечения размера 0,6...1 мм по п.5 допускается правка дет.107-76.
- Сборку Сб107-19 поз. 14 зафиксировать после установления размеров P и П.
- Постановку упора поз. 7 и ползка поз. 8 проверить шайкой-калибром со звеном: опертая звеном в боковую поверхность упора и отхота к низу, шайка-калибр должна свободно проходить по всей горловине. Соскакивание звена с упора не допускается.
- Острые ребра притупить: ползков поз. 8 ~ 1 мм остальное ~ 0,6 мм.
- Покрывать после пригонки: ползков поз. 8 - X24 вал АК-630 107-64-Кдб.фос. Лак БФ-4 с нигрозином, 1 слой, приготовление по ОСТ 3-4123-78, IV, OМ2, кроме диаметра Ø30С.
- Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ 1.



- In order to ensure the dimension of 0.6...1 mm as per point 5, the straightening of component 107-76 is permitted.
- After the setting of dimensions P and П, fix the assembly Sb107-19 position 14.
- Check the fitment of stop position 7 and the strip position 8 by the cartridge gauge with link: supported with link on side surface of stop and pulled downward, the cartridge-gauge should freely pass over the complete neck.
- Jumping of link from stop is not permitted.
- Blunt the sharp ribs: strip position 8 - 1 mm and remaining - 0.6mm.
- Coating after the filament: strip position 8 - Chrome 24 (Kh 24). shaft AK - 630 107-64 - Cad 6 phos. varnish BF-4 with nigrogin, 1 layer, preparation as per OST 3-4123-78, IV, OМ2, except diameter Ø 30 С.
- Mark Ш, Ч and stamp K as per АК-630, АК-630М ТУ 1.

Machine through the hole on the lug of АК-630 107-79
Обработать через отв. в проушине АК-630 107-79

3 Holes
30тв. Ø6.4A5
Сверлить через упор поз.7
Drill through stop position 7.

Projection of rivet head is not permitted
Выступление головок заклепок не допускается

Abutted. Non-coincidence up to 0.5 mm is permitted.
Заподлицо. Допускается несовпадение до 0,5мм

Technological screw and nut.
ТЕХНОЛОГИЧЕСКИЕ ВИНТ И ГАЙКА

Drill on the lower wall through slider position 8
20тв. Ø5.3A5 Сверлить в стенке нижней через ползков поз.8

Левый размер
Правый размер
Внутренний диаметр
Внешний диаметр
Длина
Ширина
Высота

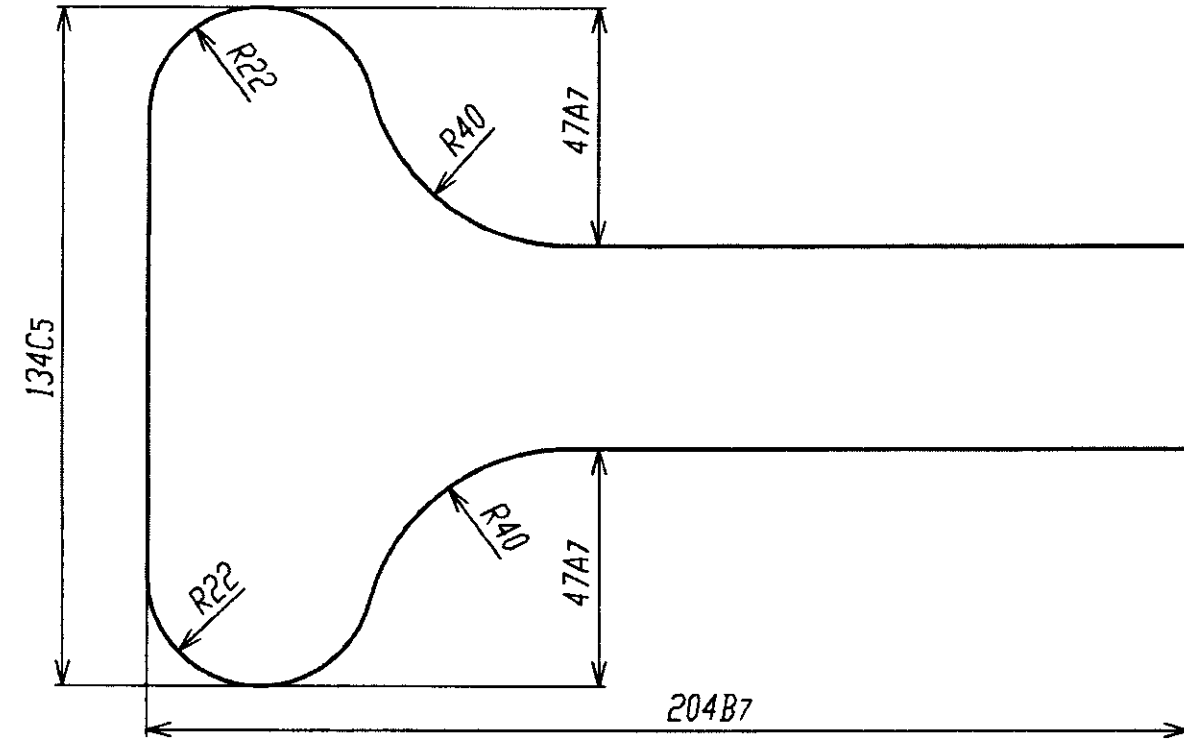
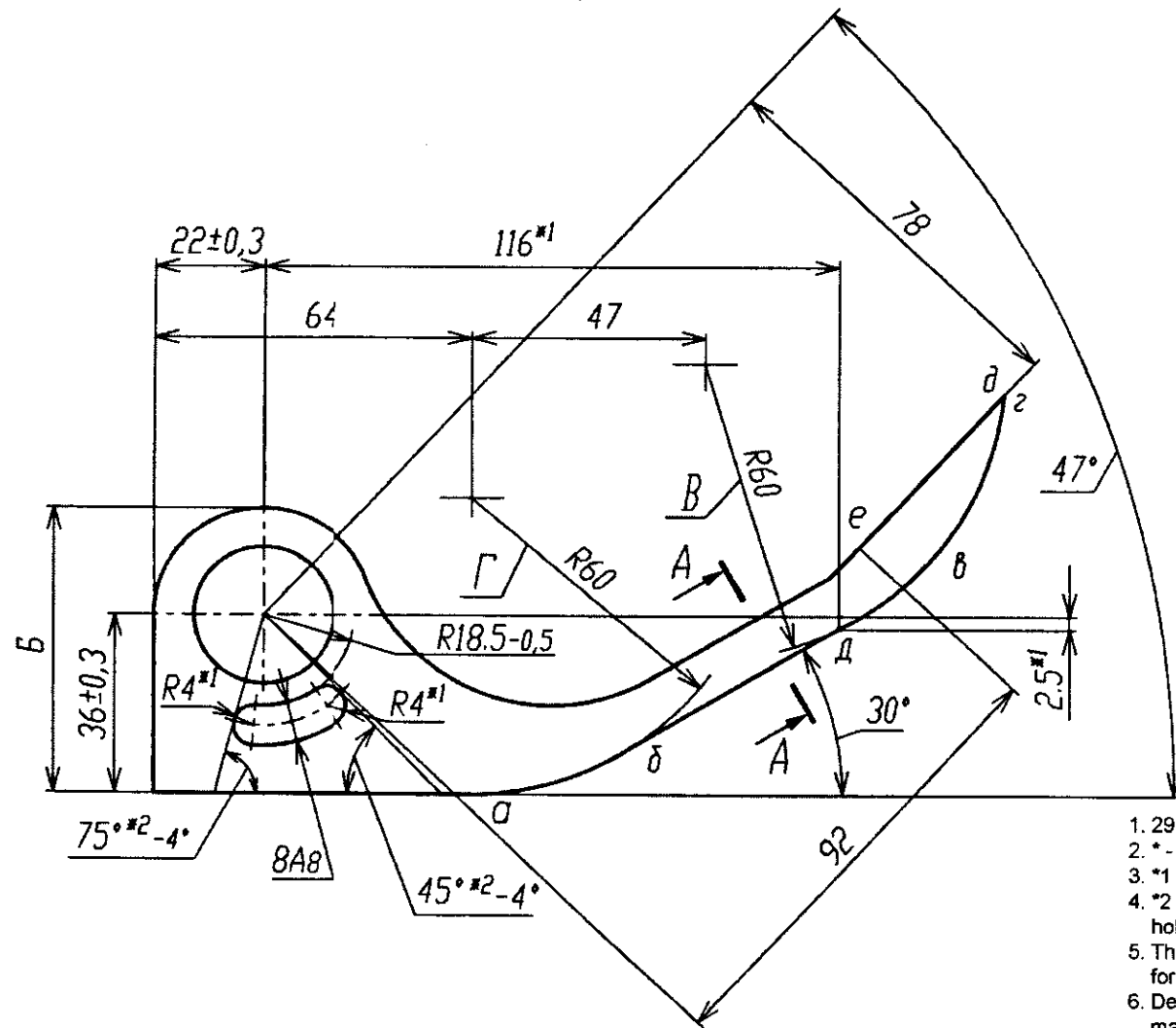
AK - 630 Sb107-13 SB		AK-630 Cb107-13CB	
Изм.	Лист	№ докум.	Подп.
Разраб.	Лист	Масса	Масштаб
Прооб.	Лист	6,830	1:1
Контр.	Лист	Сборочный чертёж	
Лист	Листов	Assembly Drawing	
УТВ.	УТВ.	Sheet Total Sheets 1	

AK-630 107-49							
Approved OGMet	Approved KTONI	Approved by shop	First use				
Orig. Inv. No.	Sign and Date	Reference No.					
Approved TOsb	Sign and Date						
Alternate Inv. No.	Dupl. Inv. No.						
<p>1. 38.5...44.5 HRC_E . Check hardness on 3 -5% of the batch but not less than 3 nos. 2. Blunt sharp edges R~0.4 mm. 3. Coating Cd6.phos. 4. Mark Ш, Ч and stamp K, И on tag</p>							
AK-630 107-49							
				Locator pin	Type A	Weight 0.001	Scale 2:1
				Steel 50 GOST 1050-88		Sheet Sheets 1	

Copied by

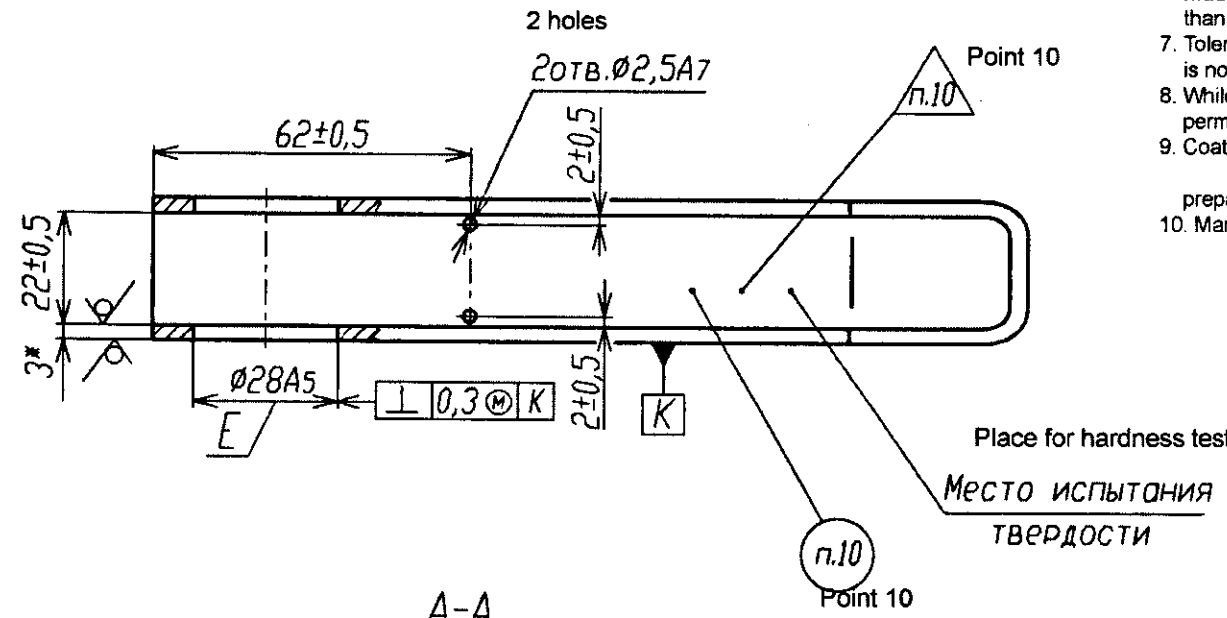
Format A4

AK-630 107-95																																													
Approved OCMet	Approved by shop																																												
Orig. Inv. No.	Reference No.	<p>1. 34...39.5 HRC_E. Check hardness on 3..5% of the batch, but not less than 3 nos. 2.* Reference dimension. 3.Blunt sharp edges R~0.6 mm. 4. Coating Cd12.phos. Lacquer BF-4 with Nigrosine , single coat, made as per OST 3-4123-78, IV, OM2. 5. Mark Ш, Ч on tag and Stamp K, И as per AK-630, AK-630M TU I.</p>																																											
Approved Inv. No.	Sign and Date	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td colspan="5" style="text-align: center;">AK-630 107-95</td> </tr> <tr> <td style="width: 40%;"></td> <td style="width: 10%;">Type</td> <td style="width: 10%;">Weight</td> <td colspan="2" style="width: 30%;">Scale</td> </tr> <tr> <td style="text-align: center;">Pin</td> <td style="text-align: center;">A</td> <td style="text-align: center;">0.009</td> <td colspan="2" style="text-align: center;">2:1</td> </tr> <tr> <td></td> <td colspan="2">Sheet</td> <td colspan="2">Sheets 1</td> </tr> </table>				AK-630 107-95						Type	Weight	Scale		Pin	A	0.009	2:1			Sheet		Sheets 1																					
AK-630 107-95																																													
	Type	Weight	Scale																																										
Pin	A	0.009	2:1																																										
	Sheet		Sheets 1																																										
Approved TOsb	Sign and Date	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%;">Amend.</td> <td style="width: 10%;">Sheet</td> <td style="width: 10%;">Doc. No.</td> <td style="width: 10%;">Sign</td> <td style="width: 10%;">Date</td> </tr> <tr> <td> </td> <td> </td> <td> </td> <td> </td> <td> </td> </tr> <tr> <td colspan="5">Developed by</td> </tr> <tr> <td colspan="5">Checked by</td> </tr> <tr> <td colspan="5">Head of Q.C.D</td> </tr> <tr> <td colspan="5">Design bureau chief</td> </tr> <tr> <td colspan="5">Head of Q.C.D</td> </tr> <tr> <td colspan="5">Approved by</td> </tr> </table>				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				
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																																													
Approved KTONI	Dupl. Inv. No.	Wheel $\frac{12 - 5GOST 7417 - 75}{50 - V - T GOST 1051 - 73}$																																											
Sign and Date	Sign and Date	Copied by _____ Format A4																																											



1. 29...35.0 HRC_с. Carry out the hardness check for 2 %.
2. * - Dimensions for reference.
3. *1 - Dimensions are ensured by tool.
4. *2 - Carry out the inspection of dimensions with respect to hole E and point D.
5. The height difference of the sides of dimension Б is not permitted for more than 0.5 mm.
6. Deviation of contour 'абвг' from the contour of template, which is made as per 5th class of accuracy GOST 2689-54, is not more than 1 mm.
7. Tolerance on contour 'де' with respect to hole E and point D is not more than 0.5 mm.
8. While bending on radiuses B and Г, the corrugations are permitted.
9. Coating: Cad. 12. Phos. Varnish BF-4 with nigrojin 1 layer. preparation as per OST 3-4123-78, IV, OM2.
10. Mark Ш, Ч and stamp К, И as per AK-630, AK-630M TU 1.

1. 29...35,0 HRC_с. Проверку твердости производить на 2%.
2. * Размеры для справок.
3. *1 Размеры обеспеч. инстр.
4. *2 Контроль размеров производить относительно отверстия E и точки D.
5. Допускается разновысотность бортов по размеру Б не более 0,5 мм.
6. Отклонение контура 'абвг' от контура шаблона, изготовленного по 5-му классу точности ГОСТ 2689-54 не более 1 мм.
7. Допуск по контуру 'де' относительно отверстия E и точки D не более 0,5 мм.
8. При гибке по радиусам B и Г допускаются гофры.
9. Покрытие Кд12. фос. Лак БФ-4 с нигрозином 1 слой приготвление по OST 3-4123-78, IV, OM2.
10. Маркировать Ш, Ч и клеймить К, И по АК-630, АК-630М ТУ 1.



Bale 8 container 2

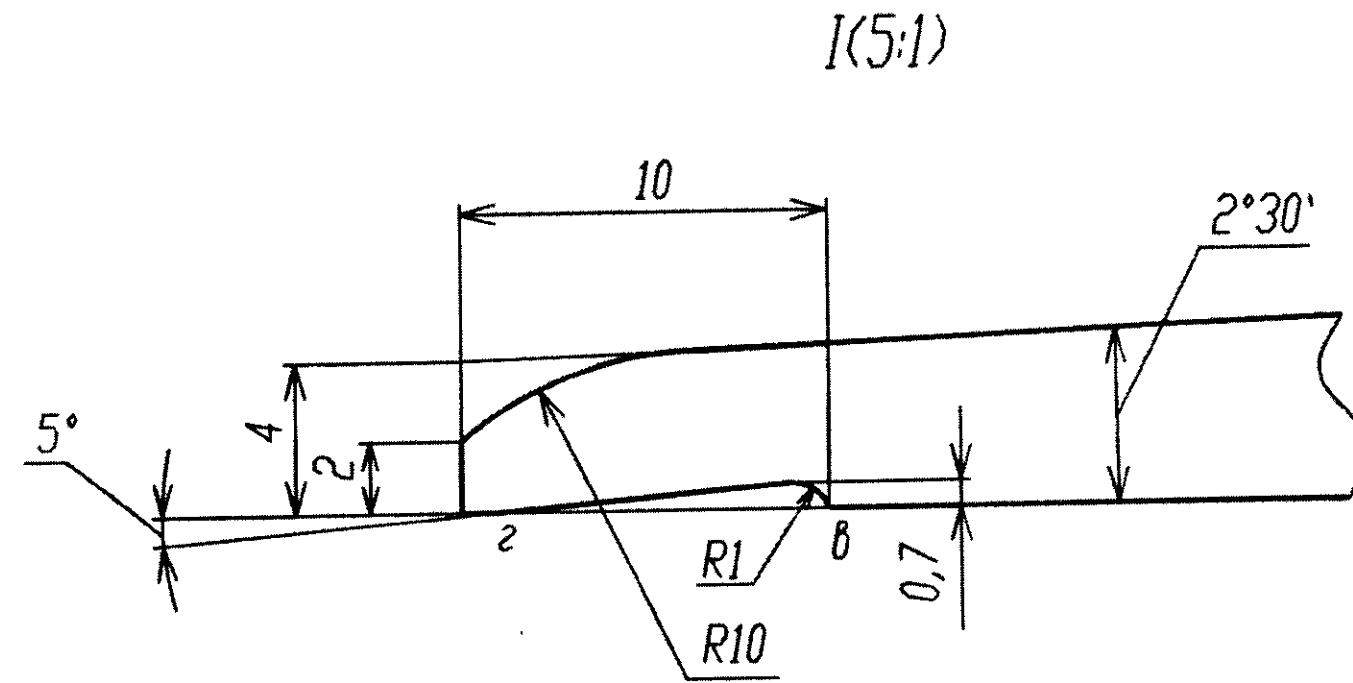
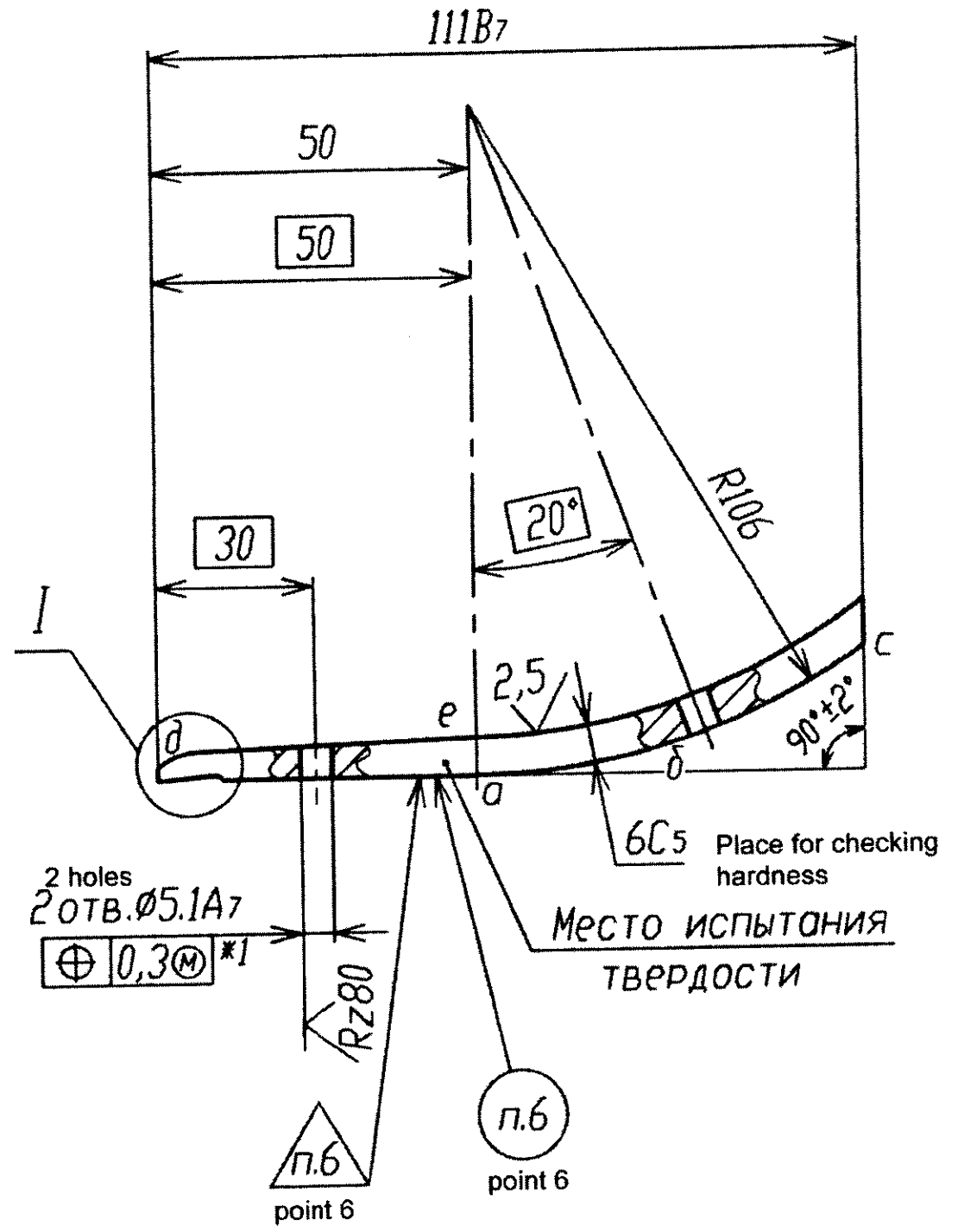
AK-630 107-94

		AK-630 107-94		Lit	Wt.	Scale
		Safety Device / Fuse		Лит.	Масса	Масштаб
		Предохранитель		A	0,250	1:1
		В-РН-0 3 GOST 19903-74		Лист	Листов 1	
		Б-РН-0 3 GOST 19903-74		Sheet	total sheets 1	
		К490В 4-III-35 GOST 16523-97				
		К490V 4 III 35 GOST				

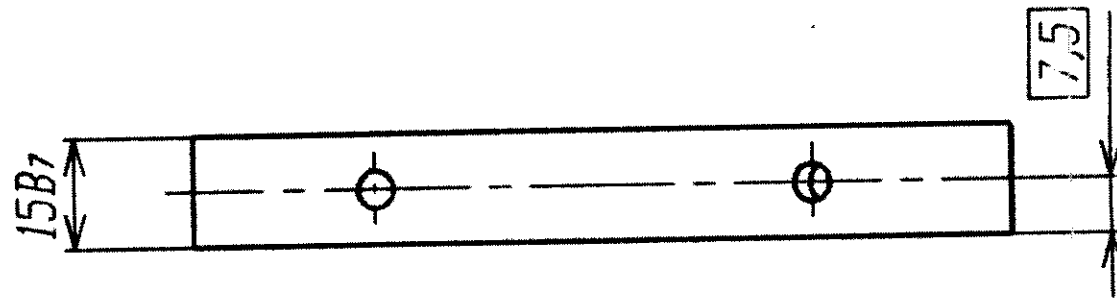
ФОРМАТ А2

Прев. протеч. Сварочн. Подп. и дата. Возмичивн. Имян. Фамил. Подп. и дата. Имян. Подп. и дата.

Rz40 (✓)



1. Deviation of contour "abc" from contour of template, made as per 5 th accuracy class GOST 2689-54 is not more than 0.5 mm.
2. Tolerance for contour "вг" "де" is 0.3 mm.
- 4.*1 Deviation given for tool.
5. Blunt sharp edges ~1 mm.
6. Mark Ш, Ч and stamp К, И as per AK-630, AK-630M TU I.



					AK-630 107-51			
Amend.	Sheet	Doc.No.	Sign	Date	Skid	Type	Weight	Scale
Developed by						A	0.065	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Steel 50 GOST 1050-88			
Approved by								

First use

Reference No.

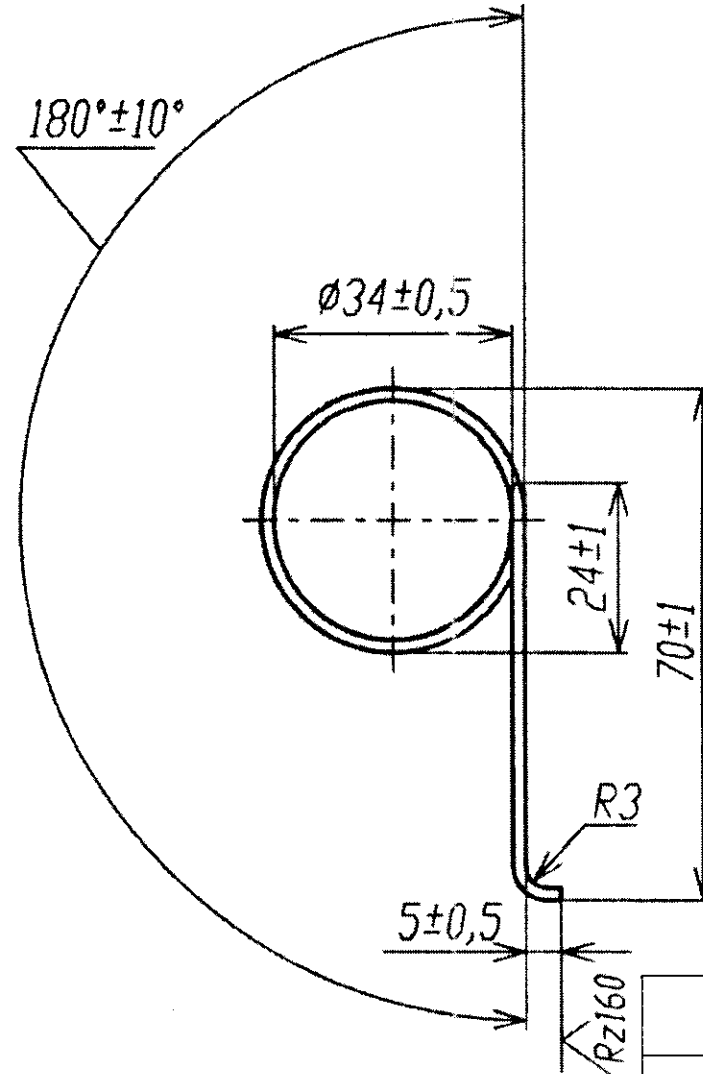
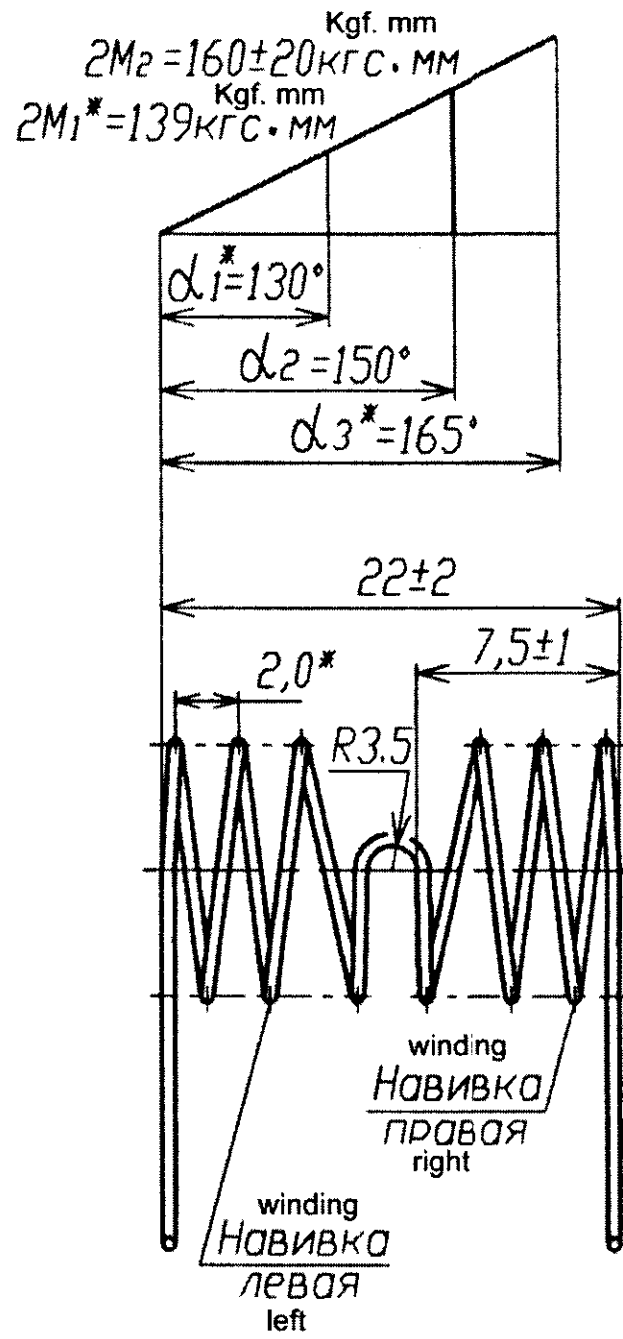
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



✓ (✓)

1. Group II.
2. $E^* = 20000 \text{ kgf/mm}^2$; $\sigma_z^* = 161 \text{ kgf/mm}^2$.
3. Length of uncoiled spring $L^* = 800 \text{ mm}$.
4. Coiling direction- right, left.
5. $n = 3+3$
6. Heat treatment : Tempering 240^0-260^0 .
7. Pre deformation time (at α_z) -12 hours
8. $D_s = 28 C_5$.
9. Coating: Chem.Phos. accel.
Lacquer BF-4 with Nigrosine, 2 coats, made as per OST 3-4123-78, IV, OM2.
- 10.* Dimensions and parameters for reference.
11. Other technical requirements as per OST 3-2561-91.
12. Mark Ш, Ч and stamp К, И on tag.

					AK-630 107-93			
Amend.	Sheet	Doc.No.	Sign	Date	Spring	Type	Weight	Scale
Developed by						A	0.030	
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Wire V-1-1.8 GOST 9389-75			
Approved by								

First use

Reference No.

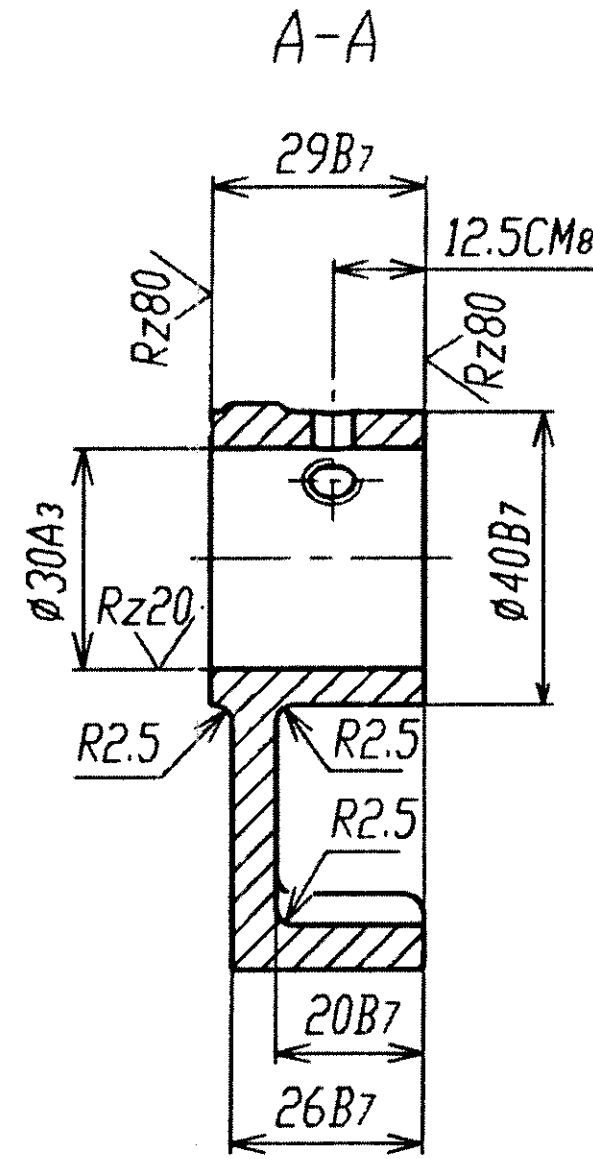
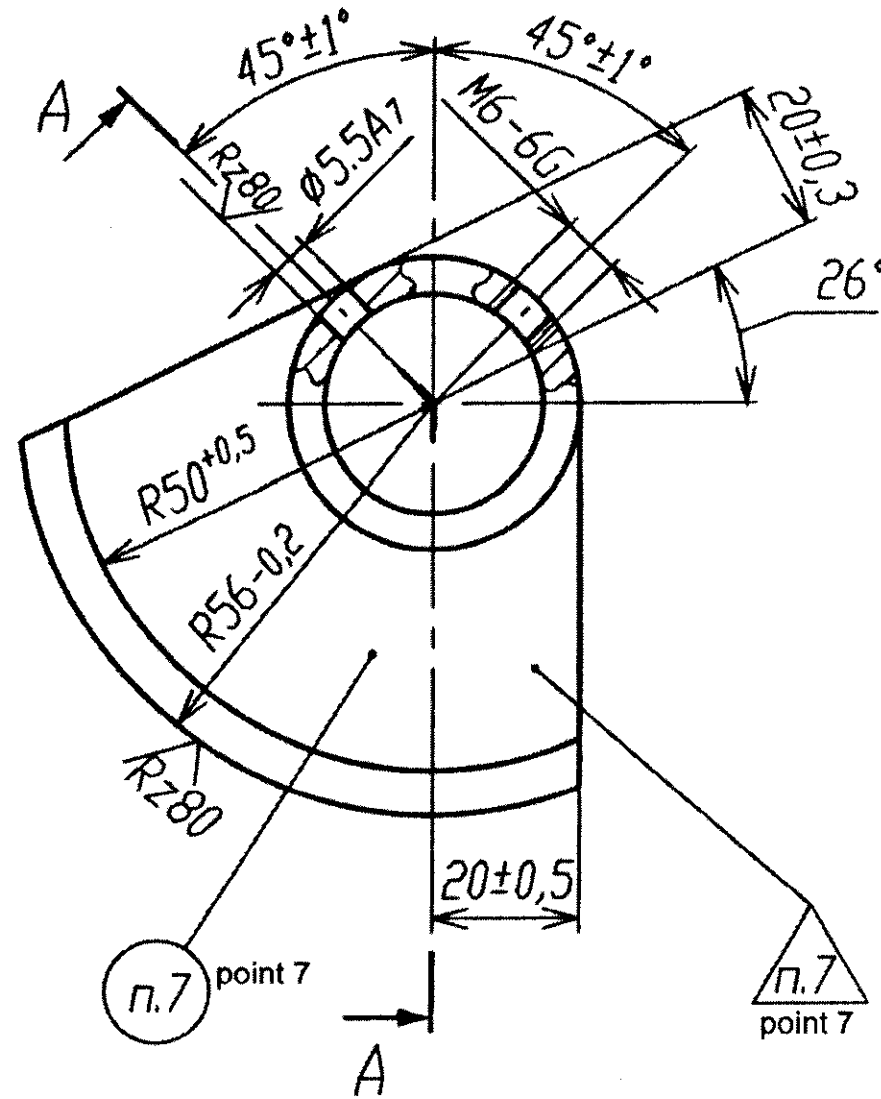
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



✓ (✓)

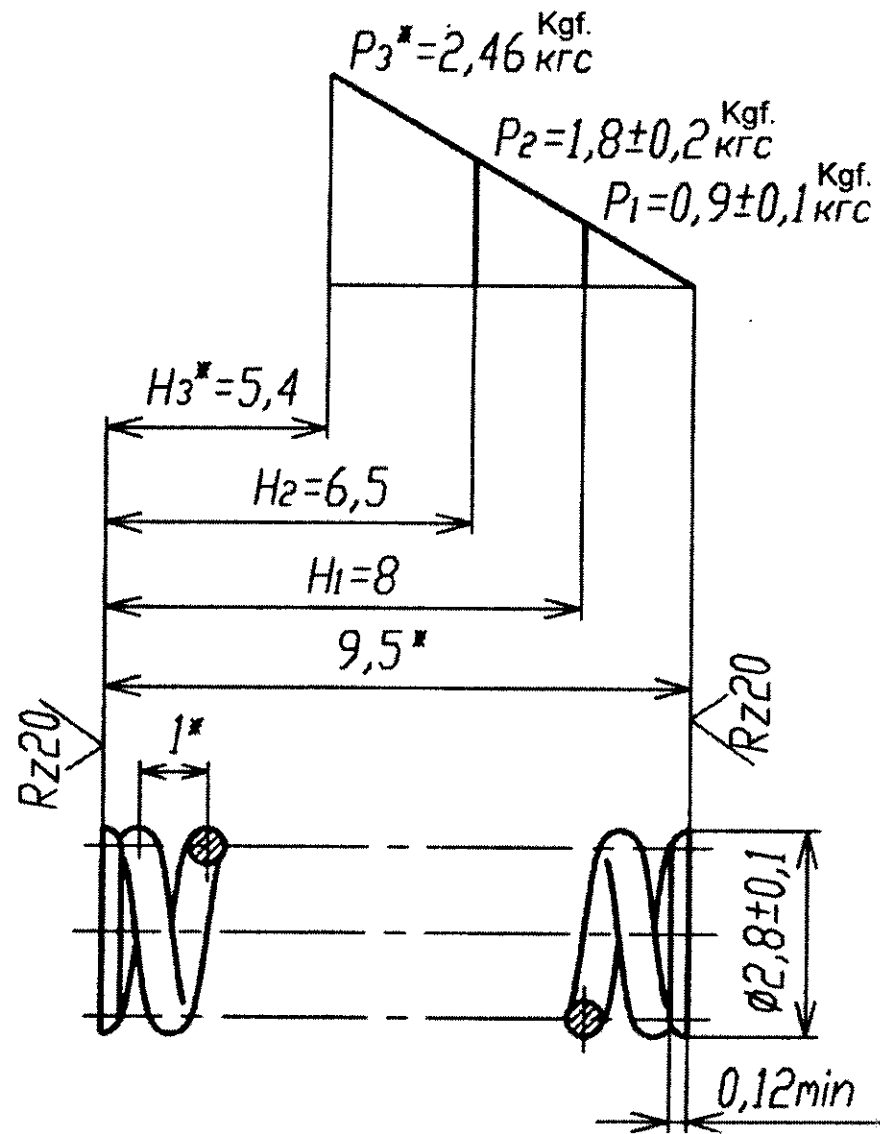
1. Accuracy of casting 8-0-0-7 GOST 26645-85.
2. Draft as per GOST 3212-92 toward increase in dimensions.
3. Surface finish of casting surfaces as per test specimen
4. 38.5...44.5 HRC_E.
5. Blunt sharp edges ~0.6 mm.
6. Coating Cd12, phos.
Lacquer BF-4 with Nigrozene, single layer, made as per OST 3-4123-78, IV. OM2.
7. Mark Ш, Ч, П and stamp К, И as per AK-630, AK-630M TU I.

					AK-630 107-47			
Amend.	Sheet	Doc.No.	Sign	Date	Support	Type	Weight	Scale
Developed by						A	0.330	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by					Casting $\frac{K30 - II - OST3 - 4365 - 79}{50L - GOST977 - 88}$			

First use

Reference No.

✓ (✓)



1. Group III.
2. $G^* = 8000 \text{ kgf/mm}^2$; $\tau^*_z = 155 \text{ kgf/mm}^2$.
3. Length of uncoiled spring $L^* = 80 \text{ mm}$.
4. Coiling direction- right.
5. $n = 8.5$
6. $n_1 = 10.5 \pm 0.25$
7. Heat treatment : Tempering 240^0-260^0 .
8. $D_g = 3A_5$.
9. D_s
10. Pre deformation time (at N_z) -24 hours.
11. Coating: Chem.Phos. accel.Cr.
Lacquer BF-4 with Nigrosine, 2 coats, made as per OST 3-4123-78, IV, OM2.
- 12.* Dimensions and parameters for reference.
13. Stamp K, И on tag.
14. Other technical requirements as per GOST 16188-70.
15. Mark Ш, Ч on tag.

Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

					AK-630 107-48			
Amend.	Sheet	Doc.No.	Sign	Date	Spring	Type	Weight	Scale
Developed by						A	0.0003	10:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D						Wire V-1-0.5 GOST 9389-75		
Approved by								

First use		Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
						<u>Documents</u>			
Reference No.		A3			AK-630 Sb107-16 SB	Assembly drawing			
						COMPONENTS			
		A3	✓	1	AK-630 107-62	Roller	1		
		A3	✓	2	AK-630 107-63	Shell	1		
		*)		3	AK-630 107-64	Shaft	1	*)A4 x 3	
		A4	✓	4	AK-630 107-65	Gland shell	2		
		A4	✓	5	AK-630 107-66	Gland	2		
						<u>Standard articles</u>			
Sign and Date				8		Rivet 4x12.03.15.029	3		
						GOST 10299-80			
				9		Bearing 942/30	2		
						GOST 4060-78			
Dupl. Inv. No.									
Alternate Inv. No.									
Sign and Date									
Orig. Inv. No.									
						AK-630 Sb 107-16			
		Amend.	Sheet	Doc. No.	Sign	Date			
		Developed by					Type	Sheet	Sheets
		Checked by					A		1
		Head of Q.C.D					Shaft		
		Approved by							

First use

Reference No.

Sign and Date

Duplicate Inv. No

Alternate Inv. No

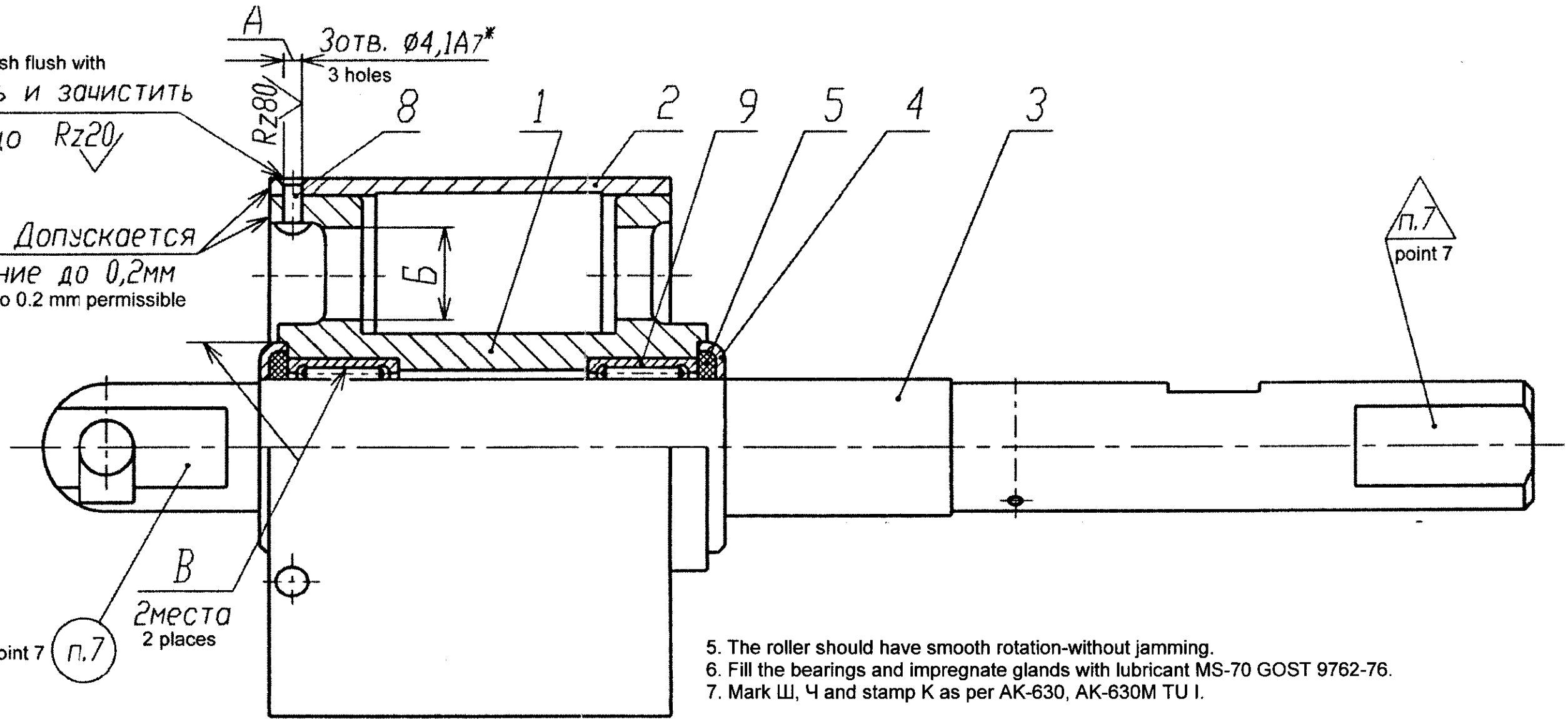
Sign and Date

Orig. inv. no.

Rivet and polish flush with
Расклепать и зачистить
заподлицо Rz20

Flush with
Заподлицо. Допускается
несовпадение до 0,2мм
Misalignment upto 0.2 mm permissible

point 7 (п.7)
2 места
2 places

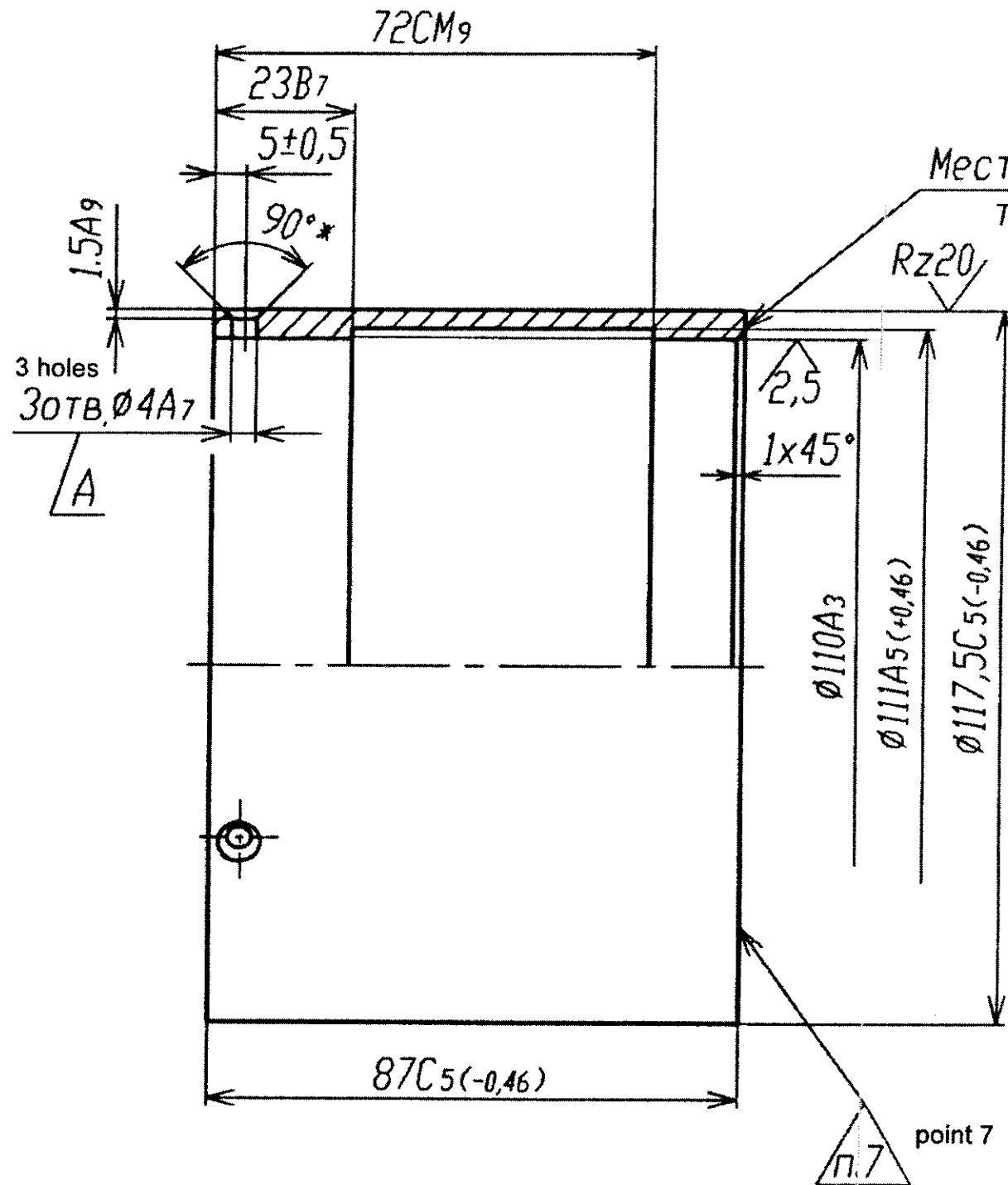


- 1.* Machine hole A together with shell pos.2.
2. Pos. of hole A with respect to hole B is arbitrary.
3. Coat components pos.1 and 2 after riveting and filing of rivets with:
places of filing- Chem.Phos. accel. or primer VL-02 , colourless single coat, at localized places.
Lacquer BF-4, black, made as per OST 3-4123-78, IV, OM2, except surface B.
Primer VL-02 GOST 12707-77.
4. Send assembly for coating without components:
AK-630 107-64, AK-630 107-65, AK-630 107-66 and bearings 942/30 GOST 4060-78. Carry out final assembly in
AK-630 Sb107-13 SB after machining and coating of comp. AK-630 107-64.

					AK-630 Sb 107-16 SB			
Amend.	Sheet	Doc.No.	Sign	Date	Shaft Assembly drawing	Type	Weight	Scale
Developed by						A	3.200	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by								

AK-630 107-63

Rz80 (✓) (✓)



Место испытания
ТВЕРДОСТИ
Rz20
Place for checking
hardness

1. 34..39.5 HRC_E.
 2. * Reference dimension.
 3. Holes A are placed along circumference at interval $120^{\circ} \pm 1^{\circ}$.
 4. Inner angles R~0.4 mm.
 5. Blunt sharp edges ~0.6 mm.
 6. Coating: cd 12. phos.
 7. Mark Ш, Ч on tag.
- Stamp K, И as per AK-630, AK-630M TU I.

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

					AK-630 107-63			
Amend.	Sheet	Doc.No.	Sign	Date	Shell	Type	Weight	Scale
Developed by						A	0.790	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by					Pipe	133x16 GOST 8732 - 78 V45 GOST 8731 - 74		

AK-630 107-63

First use

Reference No.

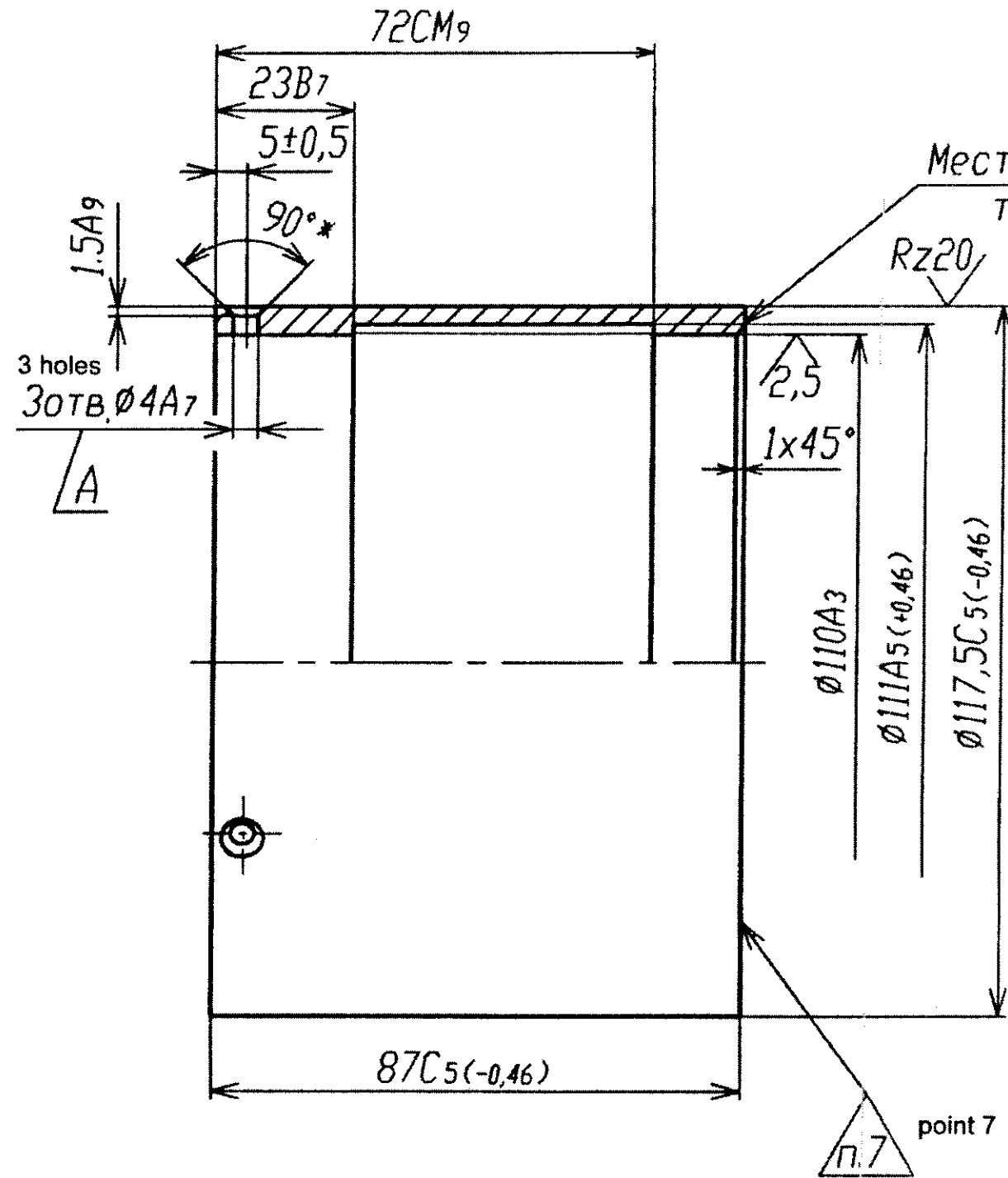
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz80 (✓) (✓)

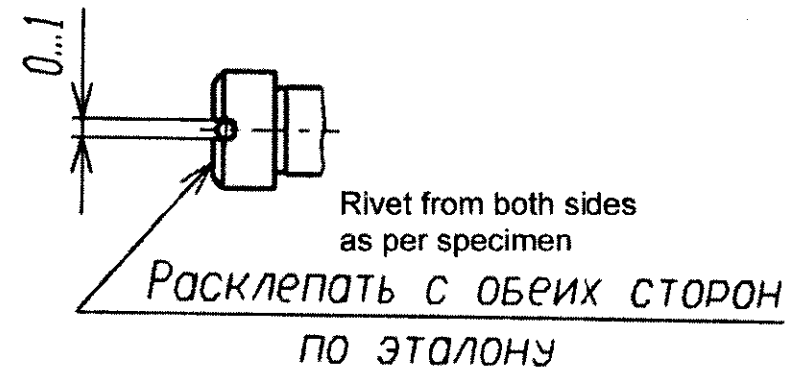
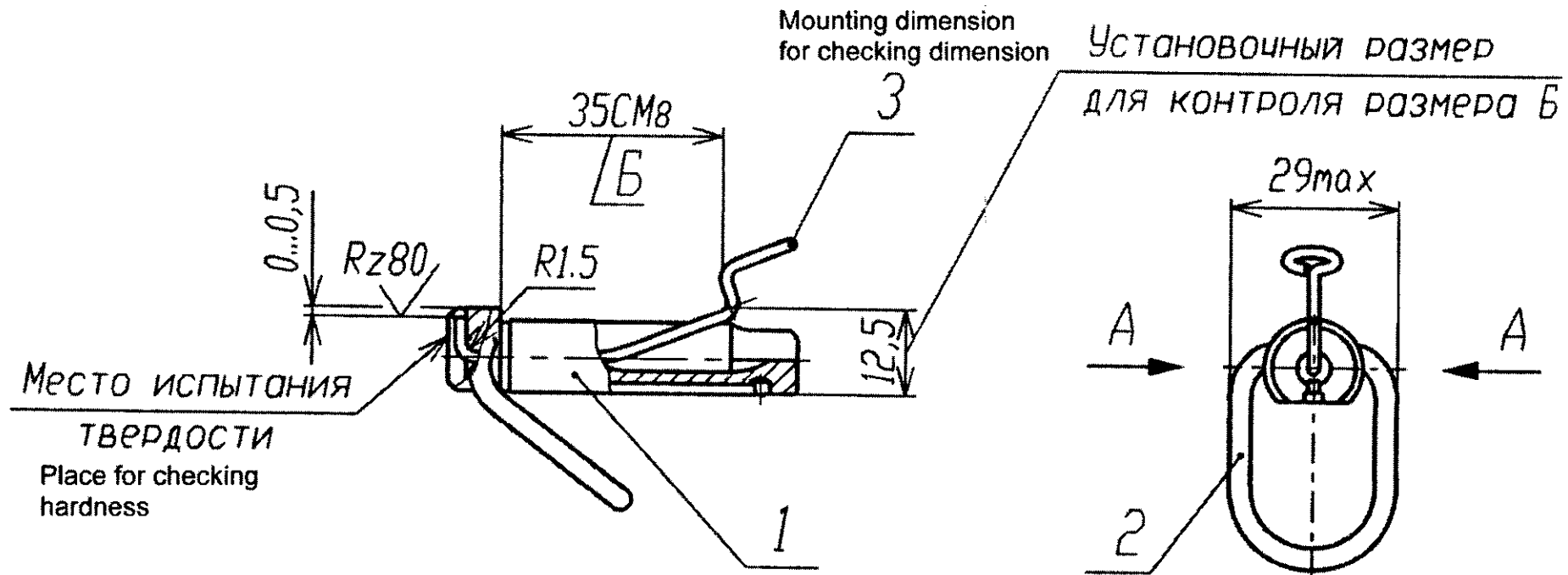
Место испытания
ТВЕРДОСТИ
Place for checking
hardness

1. 34..39.5 HRC_E.
2. * Reference dimension.
3. Holes A are placed along circumference at interval $120^{\circ} \pm 1^{\circ}$.
4. Inner angles R~0.4 mm.
5. Blunt sharp edges ~0.6 mm.
6. Coating: cd 12. phos.
7. Mark Ш, Ч on tag.
Stamp K, И as per AK-630, AK-630M TU I.

					AK-630 107-63			
Amend.	Sheet	Doc.No.	Sign	Date	Shell	Type	Weight	Scale
Developed by						A	0.790	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D						Pipe $\frac{133 \times 16 \text{ GOST } 8732 - 78}{V45 \text{ GOST } 8731 - 74}$		
Approved by								

First use

Reference No.



Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

1. 38.5...44.5 HRC_E.
2. During heat treatment ,press ring of pin pos.2 as per indicators A.
3. Coating Cd6.phos.Oil.
Coat places of riveting with primer AK-070 GOST 25718-83.
4. Fit the retainer pos.3 after coating..
5. After riveting, oscillation of retainer is not permissible.
6. Mark Ш, Ч and stamp K , И on tag.

					AK-630 Sb 107-17 SB			
Amend.	Sheet	Doc.No.	Sign	Date	Pin Assembly drawing	Type	Weight	Scale
Developed by						A	0.050	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by								

First use

Reference No.

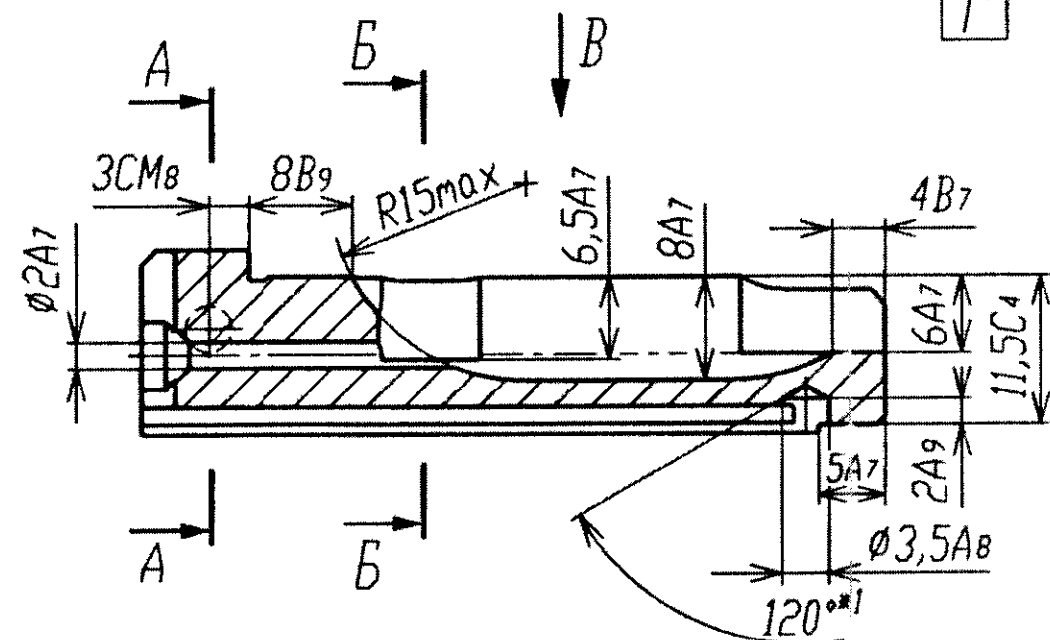
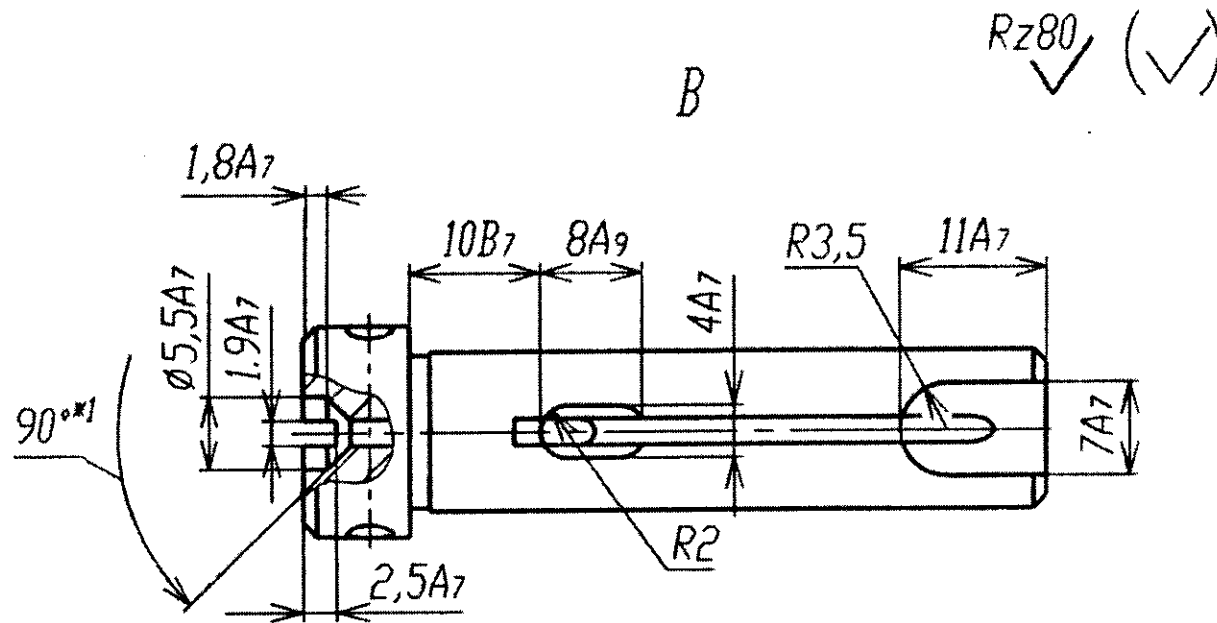
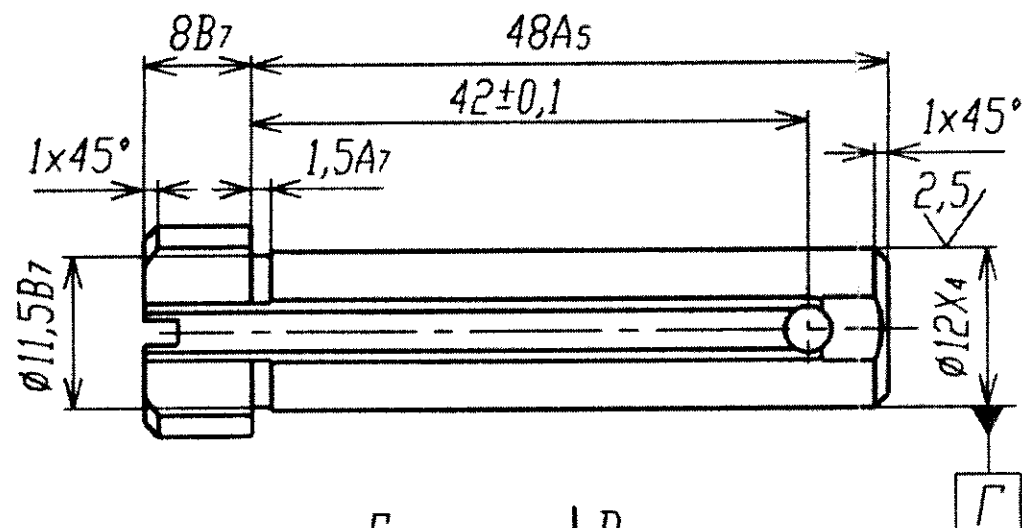
Sign and Date

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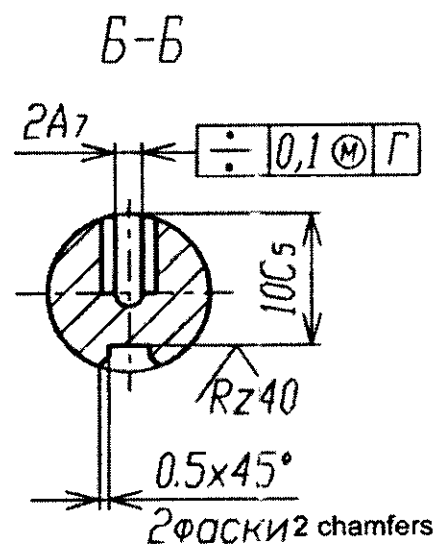
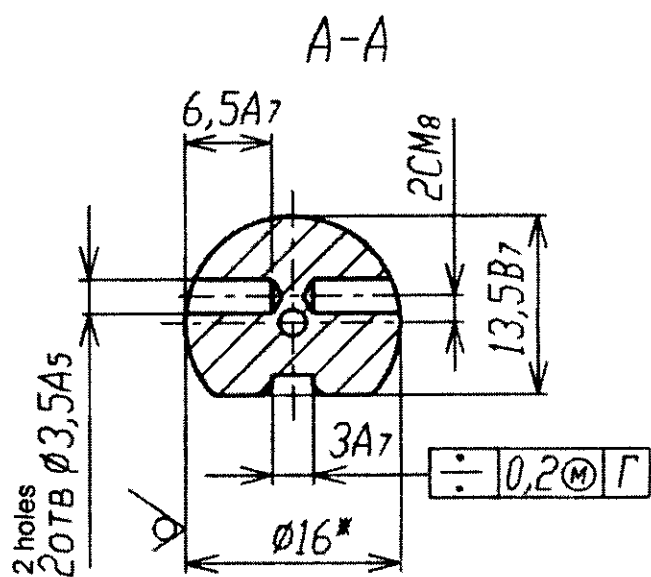
Alternate Inv. No

Sign and Date

Orig. inv. no.



- 1.* Reference dimension.
- 2.*1 Dimension ensured by tool.
- 3. Inner angles R~0.4 mm.
- 4. Blunt sharp edges R ~0.6 mm.
- 5. Mark Ш, Ч and stamp K on tag.

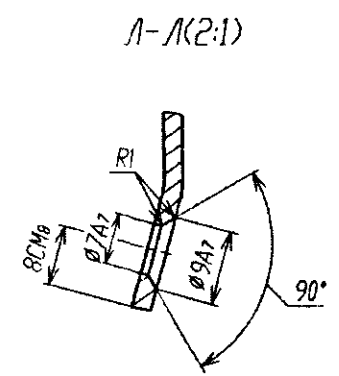
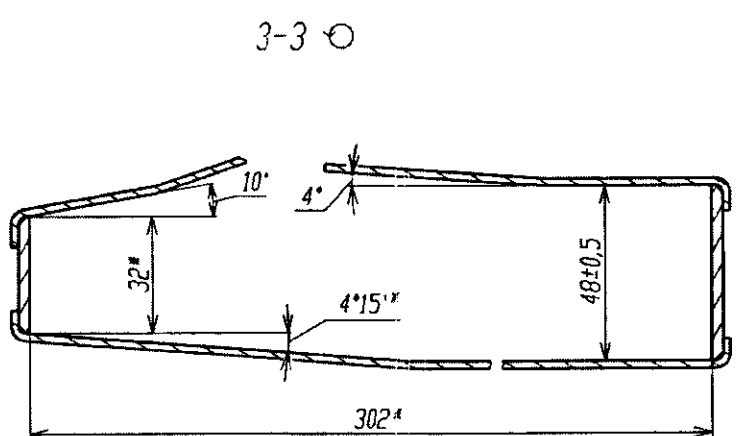
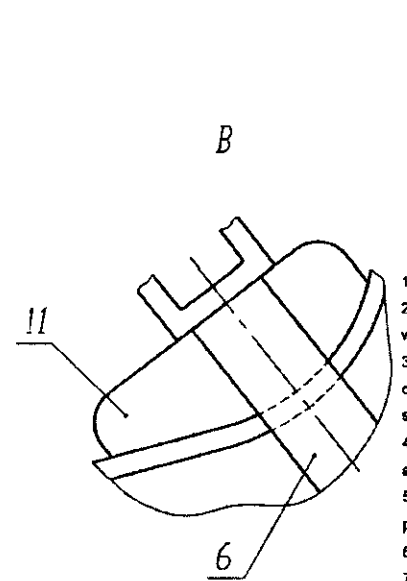
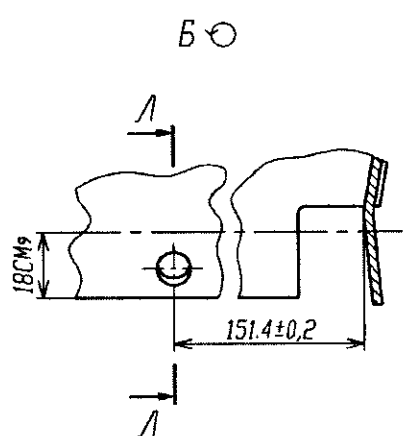
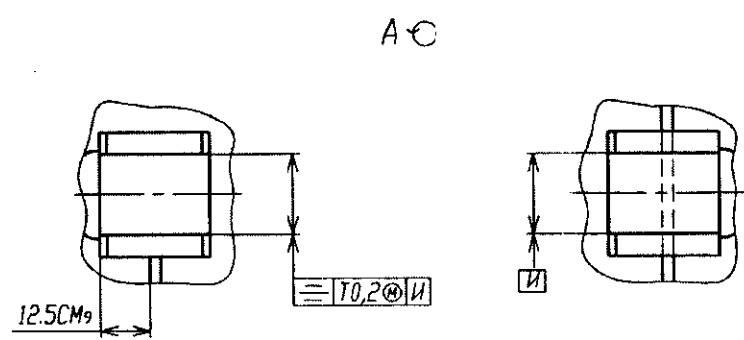
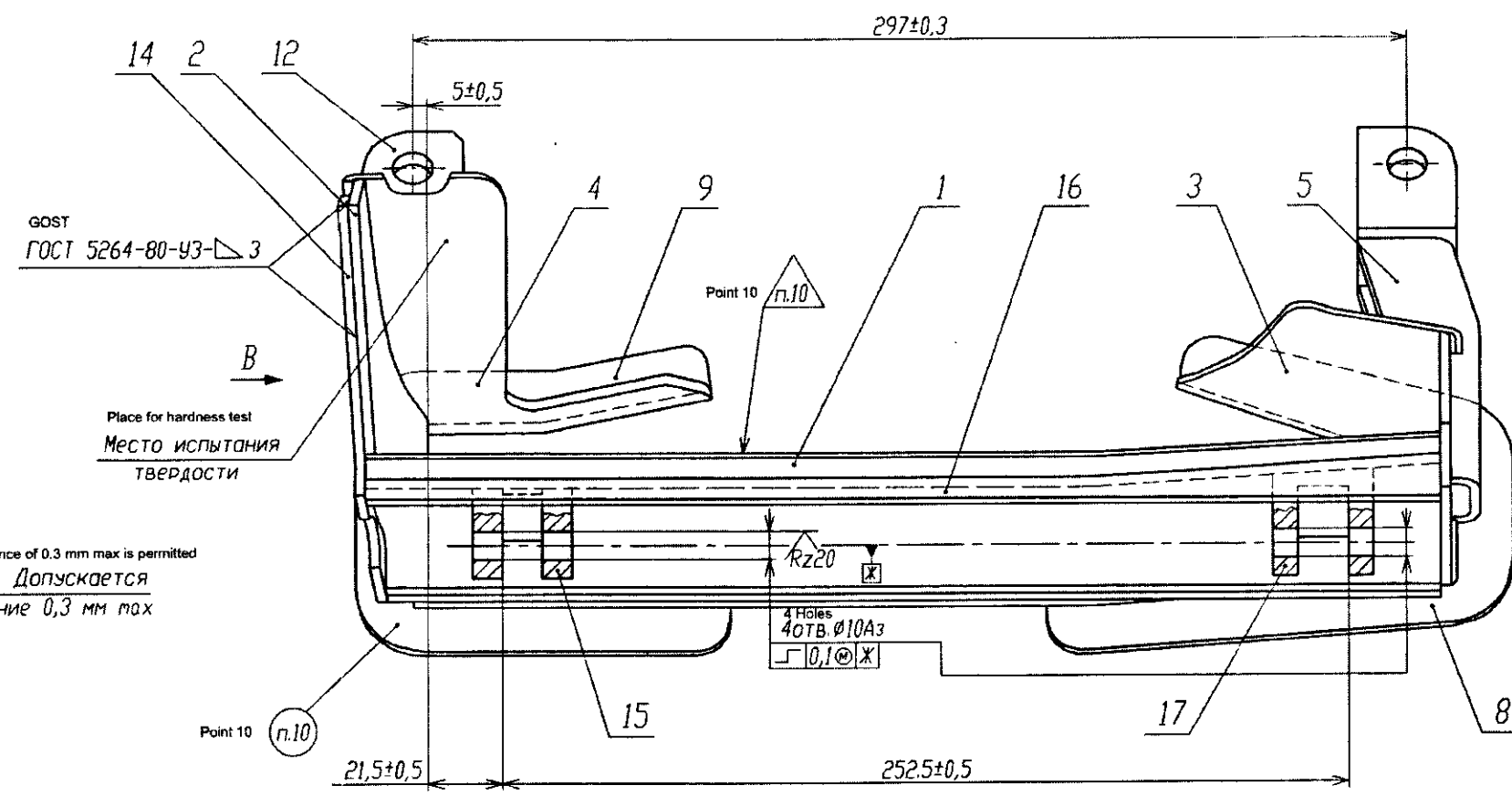
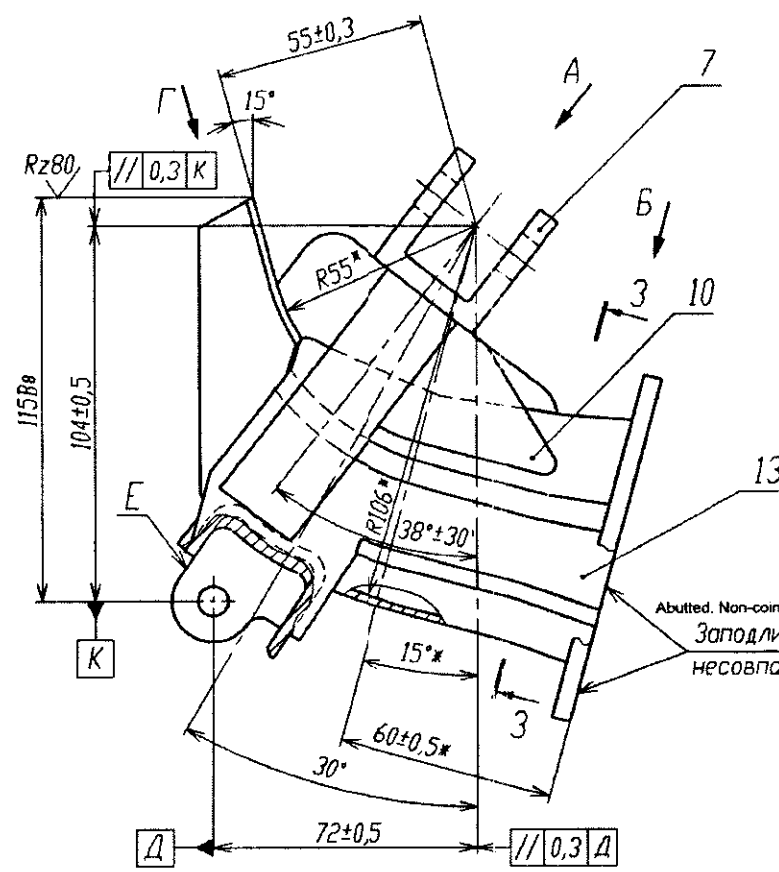


Amend.	Sheet	Doc.No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

AK-630 107-70

Pin	Type	Weight	Scale
	A	0.45	2:1
	Sheet	Sheets 1	
Wheel	16 - 5 GOST 7417 - 75 50 - T - V GOST 1051 - 73		

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
					<u>Documents</u>			
Reference No.	A1			AK-630 Sb107-18 SB	Assembly drawing			
					<u>Components</u>			
					*			
	*)		1	AK-630 107-73	Lower wall	1	*)A4x3	
	A3		2	AK-630 107-74	Rear wall	1		
	*)		3	AK-630 107-75	Front wing	1	*)A4x3	
	A3		4	AK-630 107-76	Rear wing	1		
	A3		5	AK-630 107-77	Front support	1		
	A3		6	AK-630 107-78	Rear support	1		
	A3		7	AK-630 107-79	Left lug	1		
	A3		8	AK-630 107-80	Front rib	1		
	A3		9	AK-630 107-81	Rear rib	1		
	A4		10	AK-630 107-82	Front brace	1		
	A4		11	AK-630 107-83	Rib	1		
	A3		12	AK-630 107-84	Right lug	1		
	Dupl. Inv. No.	A3		13	AK-630 107-85	Front wall	1	
		A4		14	AK-630 107-86	Rib	1	
A3			15	AK-630 107-87	Lug	1		
A3			16	AK-630 107-88	Rib	1		
Alternate Inv. No.	A3		17	AK-630 107-89	Lug	1		
Sign and Date	AK-630 Sb 107-18							
	Amend.	Sheet	Doc. No.	Sign	Date			
Orig. Inv. No.	Developed by					Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D							
	Approved by							
Collar								



1. Электрод УОНИИ 13/45-3,0-2 ГОСТ 9466-75.
 2. Допускается полуавтоматическая сварка в среде углекислого газа с применением присадочной проволоки 1,2 Св-08 ГЭС ГОСТ 2246-70.
 3. Сварку производить по наружному периметру соприкосновения деталей. Катет сварки 3 мм, кроме указанного.
 4. Наплывы сварки в пазах проушин поз. 15 и 17 зачистить со стороны плоскости E.
 5. Допускается припиловка и подгибка деталей по мере надобности.
 6. 321...375 HB.
 7. При обнаружении трещин в сварных швах после закалки, допускается исправление их методом вырубания (засверловки) с последующей заваркой электродом НИАТ-5-3,0-2 ГОСТ 9466-75 и проведением низкого отпуска.
 8. *Размеры для справок.
 9. Покрытие Ка12. фос. Лак БФ-4 с нигрозином, 1 слой, приготовление по ОСТ 3-4123-78, IV, OM2. Пропитку не производить в пазах и отверстиях поз. 7,12,15,17.
 10. Маркировать Ш, Ч и клеймить К, И по АК-630, АК-630М ТУ I
1. Electrode UONIИ 13/45-3.0-2 GOST 9466-75.
 2. Semi-automatic welding in the medium of carbonic acid gas with the use of filler rod 1.2 Sv-08 G2S GOST 2246-70 is permitted.
 3. Carry out the welding along the external perimeter of touching components. Cathetus of welding is 3 mm, except for the specified ones.
 4. Finish the influx of welding in the grooves of lug position 15 and 17 from the side of plane E.
 5. Filing and bending of components as per the requirement is permitted.
 6. 321...375 HB
 7. On the detection of cracks on the welded seams, after tempering their correction is permitted by cutting out (drilling) with subsequent welding with electrode NIAT-5-3.0-2 GOST 9466-75 and by carrying out low tempering.
 8. * - Dimensions for reference.
 9. Coating Cad 12 phos. Varnish BF-4 with nigrogin, 1 layer, preparation as per OST 3-4123-78, IV, OM2. Do not carry out the impregnation (soaking) in the grooves and holes positions 7, 12, 15, 17.
 10. Mark Ш, Ч and stamp К, И as per АК-630, АК-630М ТУ I.

Изм. в проекте
 Проверен
 Составлен
 Проект и авто
 Проект и авто
 Проект и авто

AK-630 Sb 107 - 18 SB		AK-630 Cb107-18CB	
Изм.	Лист	№ докум.	Подп.
Дата	Дата	Дата	Дата
Горловина		Масса	1:1
Сборочный чертеж		Лист	Листов
Assembly Drawing		Sheet	Total Sheets

AK-630 107-82					
Approved OGMet	Sign and Date	Approved TOsb	Sign and Date	Approved KTONI	Reference No.
Orig. Inv. No.	Alternate Inv. No.	Dupl. Inv. No.	Inv. No.	Sign and Date	Approved by shop
				First use	

Rz80 (✓) (✓)

1.* Reference dimension.
 2. Tolerance on contour "a6b" – 0.5 mm.
 3. Blunt sharp edges R~0.6 mm.
 4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

AK-630 107-82				
Front brace	Type	Weight	Scale	
	A	0.025	1:1	
	Sheet	Sheets 1		
Sheet <u>B - PN - 03 GOST 19903 - 74</u>				
Sheet <u>K 490V 4 - III - 35 GOST 16523 - 97</u>				

Copied by

Format A4

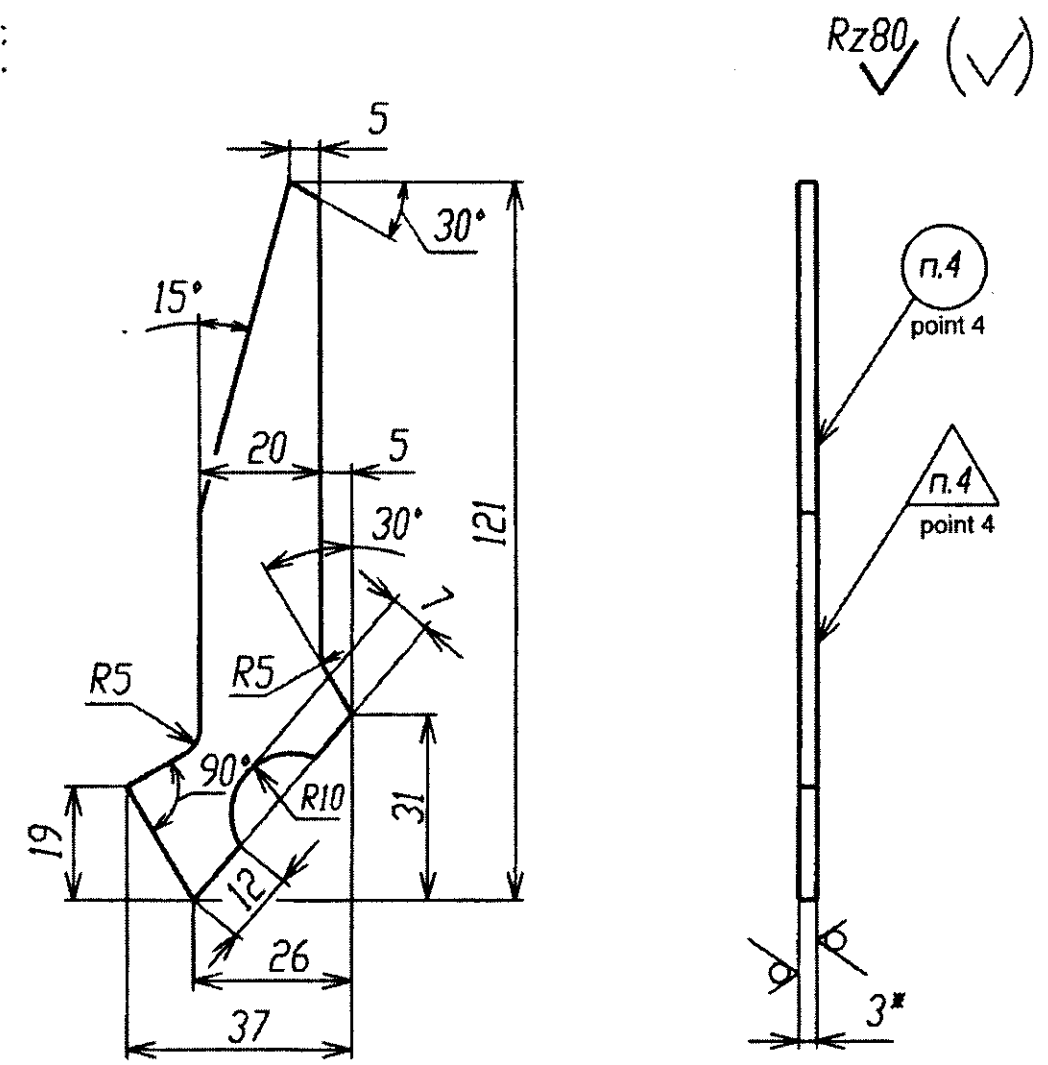
AK-630 107-83							
Approved OGMet	Orig. Inv. No.	Sign and Date	Approved TOsb	Dupl. Inv. No.	Sign and Date		
Approved KTONI	Approved by shop		Reference No.		First use		
<p>1.* Reference dimension. 2. Tolerance on contour "aB" – 0.5 mm. 3. Blunt sharp edges R~0.6 mm. 4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.</p>							
AK-630 107-83							
				Rib	Type	Weight	Scale
				A	0.050	1:1	
				Sheet	Sheets 1		
				Sheet <u>B – PN – 0 GOST19903 – 74</u>			
				<u>K490V 4 – III – 35 GOST16523 – 97</u>			

Copied by

Format A4

AK-630 107-86

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



Rz80 (✓)

- 1. * Reference dimension.
- 2. Tolerance on contour - 0.5 mm.
- 3. Blunt sharp edges R~0.6 mm.
- 4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

Amend.	Sheet	Doc. No.	Sign	Date

AK-630 107-86			
Rib	Type	Weight	Scale
	A	0.040	1:1
Sheet		Sheets 1	
Sheet $\frac{B - PN - 03 GOST 19903 - 74}{K 490V 4 - III - 35 GOST 16523 - 97}$			

Rz80 (✓)

First use

Reference No.

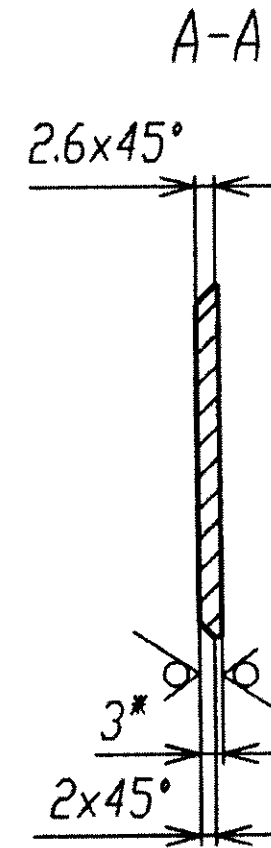
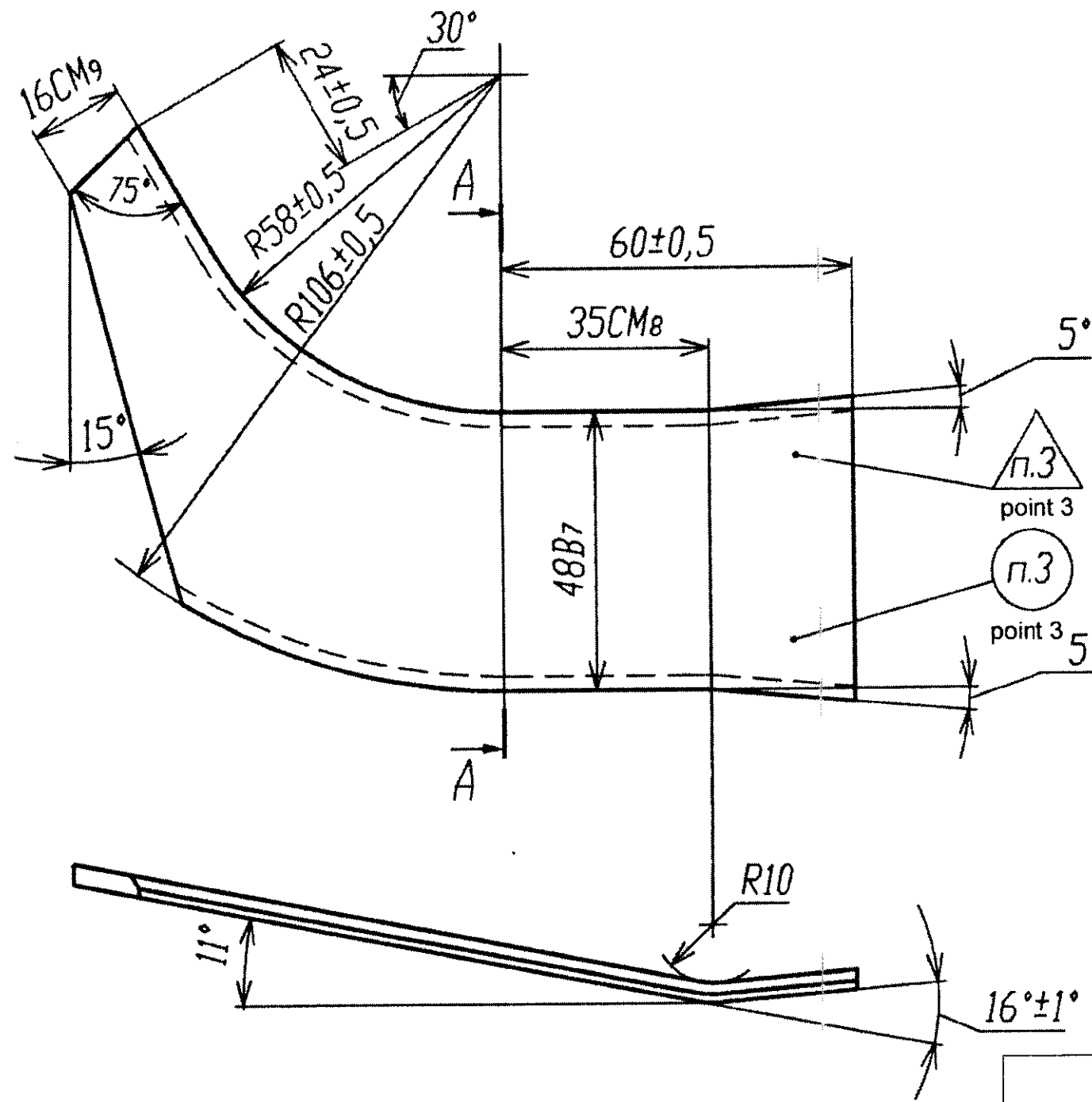
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

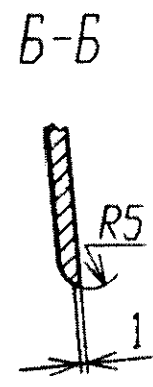
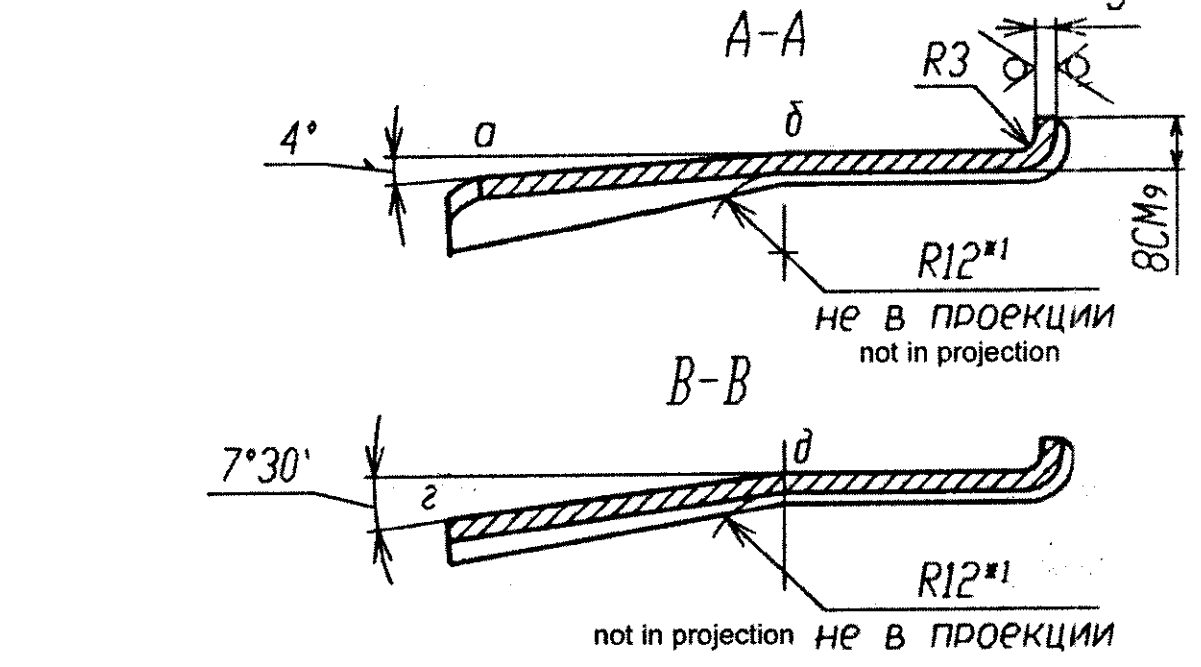
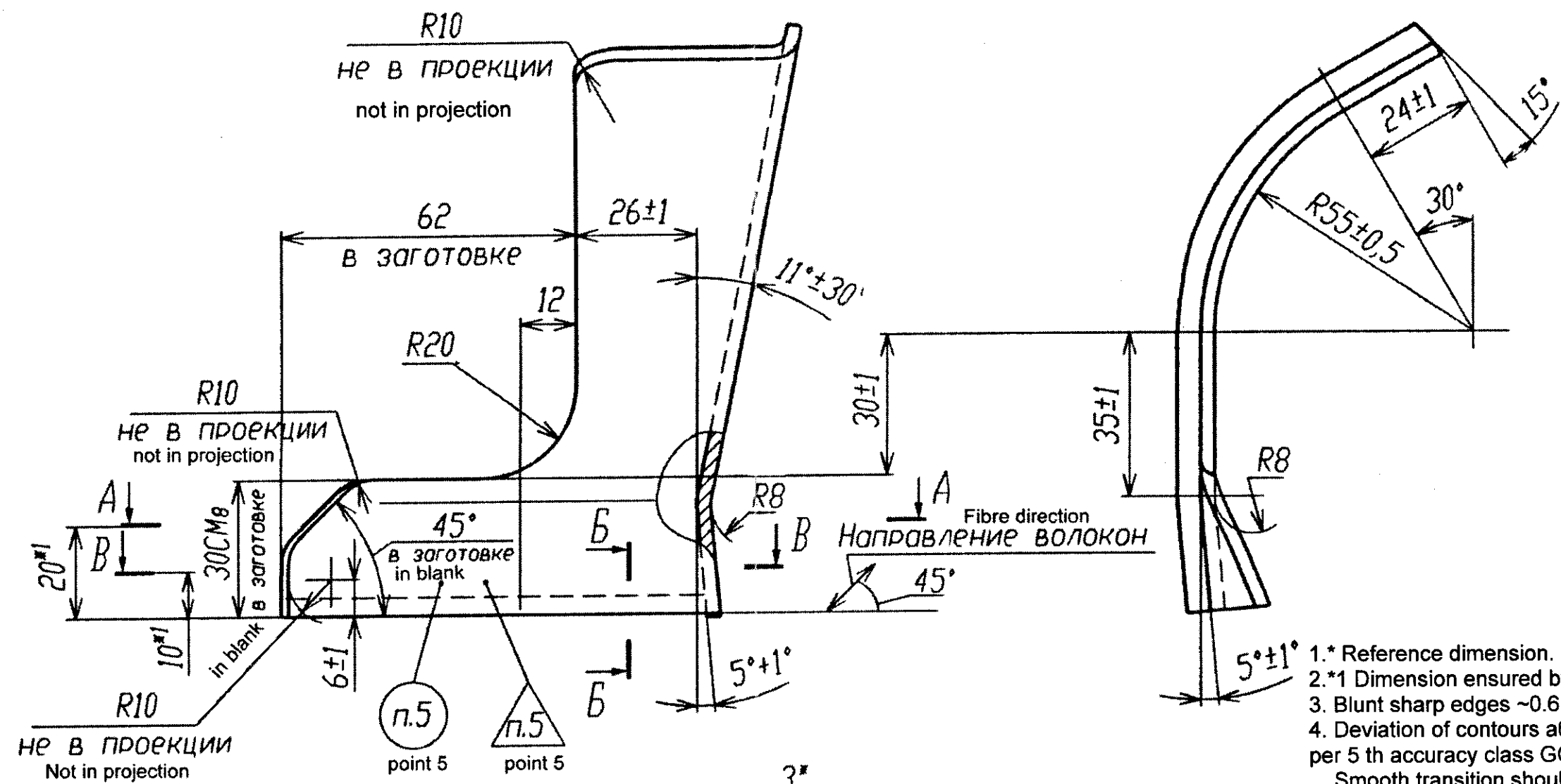
Orig. inv. no.



1. * Reference dimension.
2. Blunt sharp edges ~0.4 mm.
3. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 107-74			
					Rear wall			
					Type		Weight	Scale
					A		0.150	1:1
					Sheet		Sheets 1	
					Sheet <i>B - PN - 03GOST19903 - 74</i>			
					<i>K 490V 4 - III - 35GOST16523 - 97</i>			
Amend.	Sheet	Doc.No.	Sign	Date				
Developed by								
Checked by								
Head of Q.C.D								
Approved by								

Rz80 (✓)



- 1.* Reference dimension.
- 2.*1 Dimension ensured by tool.
- 3. Blunt sharp edges ~0.6 mm.
- 4. Deviation of contours аб, гд from contours of template, made as per 5 th accuracy class GOST 2689-54 is not more than 0.5 mm. Smooth transition should be ensured from section to section.
- 5. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

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

					AK-630 107-76			
Amend.	Sheet	Doc.No.	Sign	Date	Rear wing	Type	Weight	Scale
Developed by						A	0.170	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Sheet <u>B - PN - 03 GOST 19903 - 74</u>			
Approved by					K 490V 4 - III - 35 GOST 16523 - 97			

Rz80 (✓)

First use

Reference No.

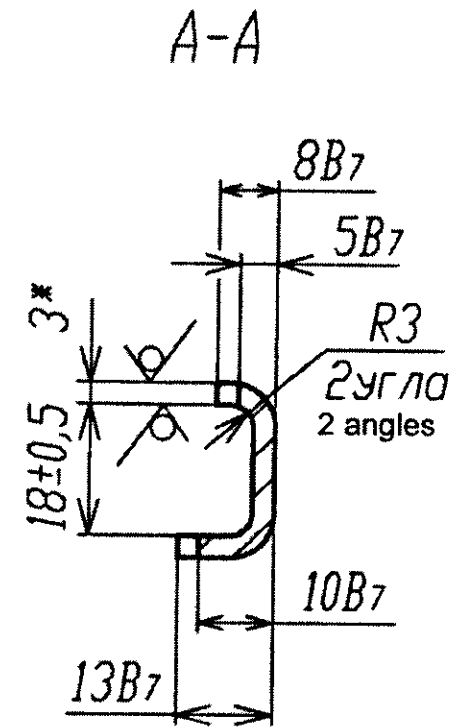
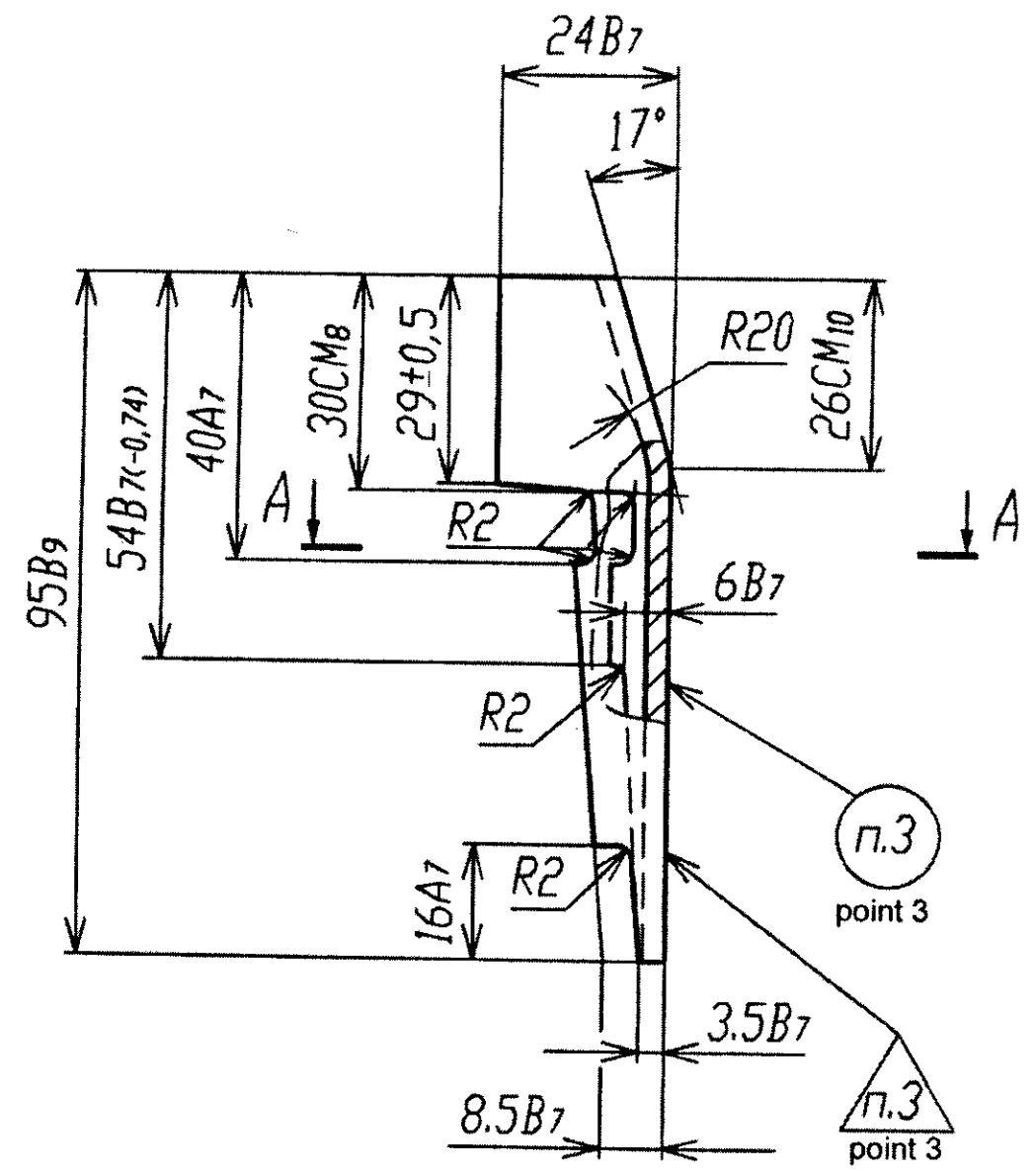
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. * Reference dimension.
2. Blunt sharp edges ~0.6 mm.
3. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 107-78			
Amend.	Sheet	Doc.No.	Sign	Date	Rear support	Type	Weight	Scale
Developed by						A	0.070	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D						Sheet $\frac{B - PN - 03 GOST 19903 - 74}{K 490V 4 - III - 35 GOST 16523 - 97}$		
Approved by								

First use

Reference No.

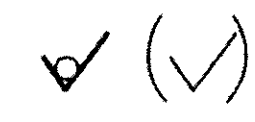
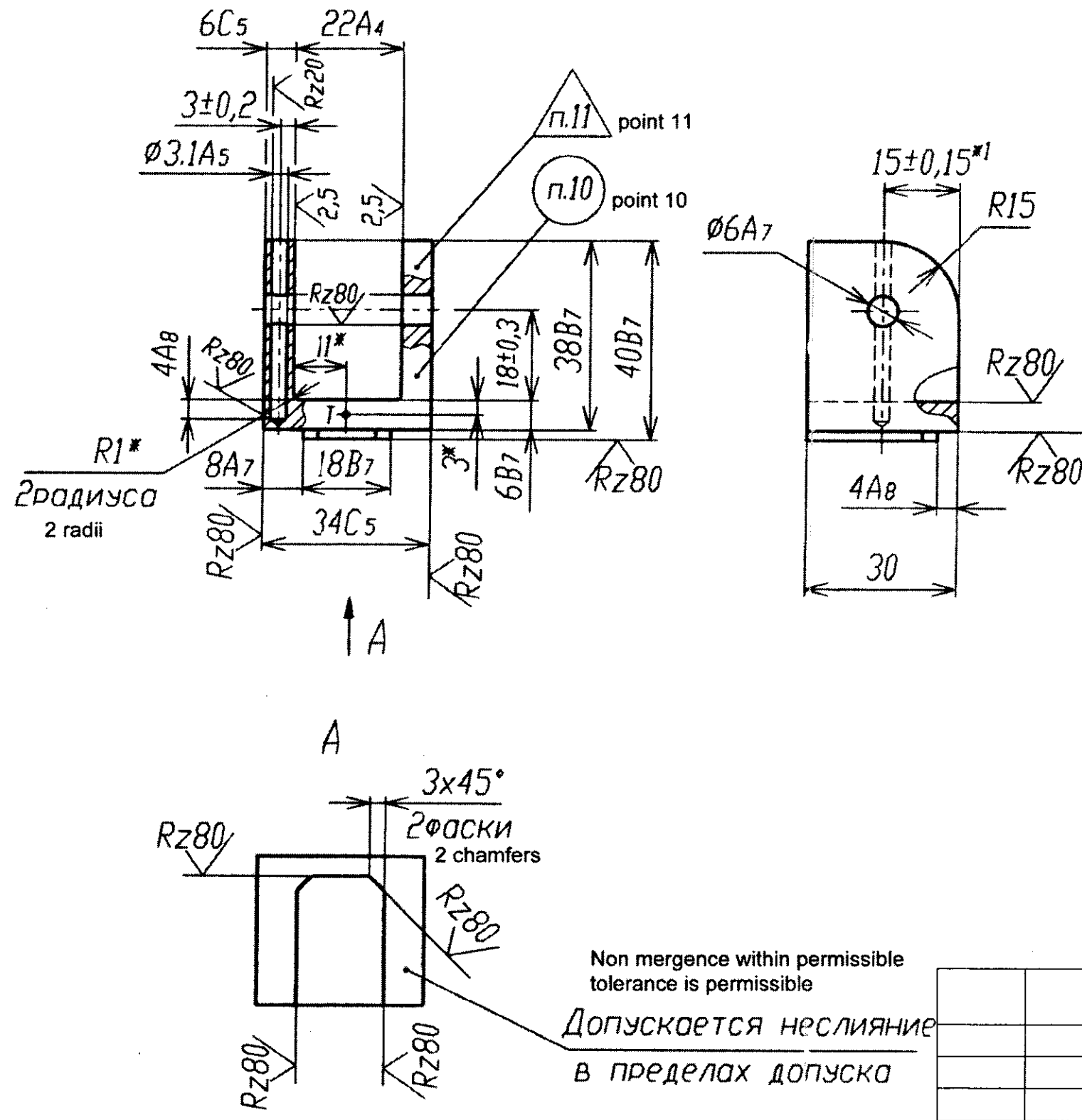
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. Accuracy of casting 8-0-0-7 GOST 26645-85.
2. Draft as per GOST 3212-92 toward increase in dimensions.
3. Casting radii R = 2 mm unless otherwise specified.
4. Shift on parting plane up to 0.3 mm.
5. Marks from pusher not exceeding 0.5 mm are permissible.
6. Surface finish of casting surfaces as per test specimen.
7. * Dimensions ensured by tool.
8. *1 Dimension given with respect to datum point T.
9. Mark Ш, Ч on tag.
10. Mark П as per AK-630, AK-630M TU I.
11. Stamp K as per AK-630, AK-630M TU I.

Non mergence within permissible tolerance is permissible
 Допускается неслияние в пределах допуска

					AK-630 107-79			
Amend.	Sheet	Doc.No.	Sign	Date	Left lug	Type	Weight	Scale
Developed by						A	0.140	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Casting	K25 - ИОСТ3 - 4363 - 79 35LGOST977 - 88		
Approved by								

First use

Reference No.

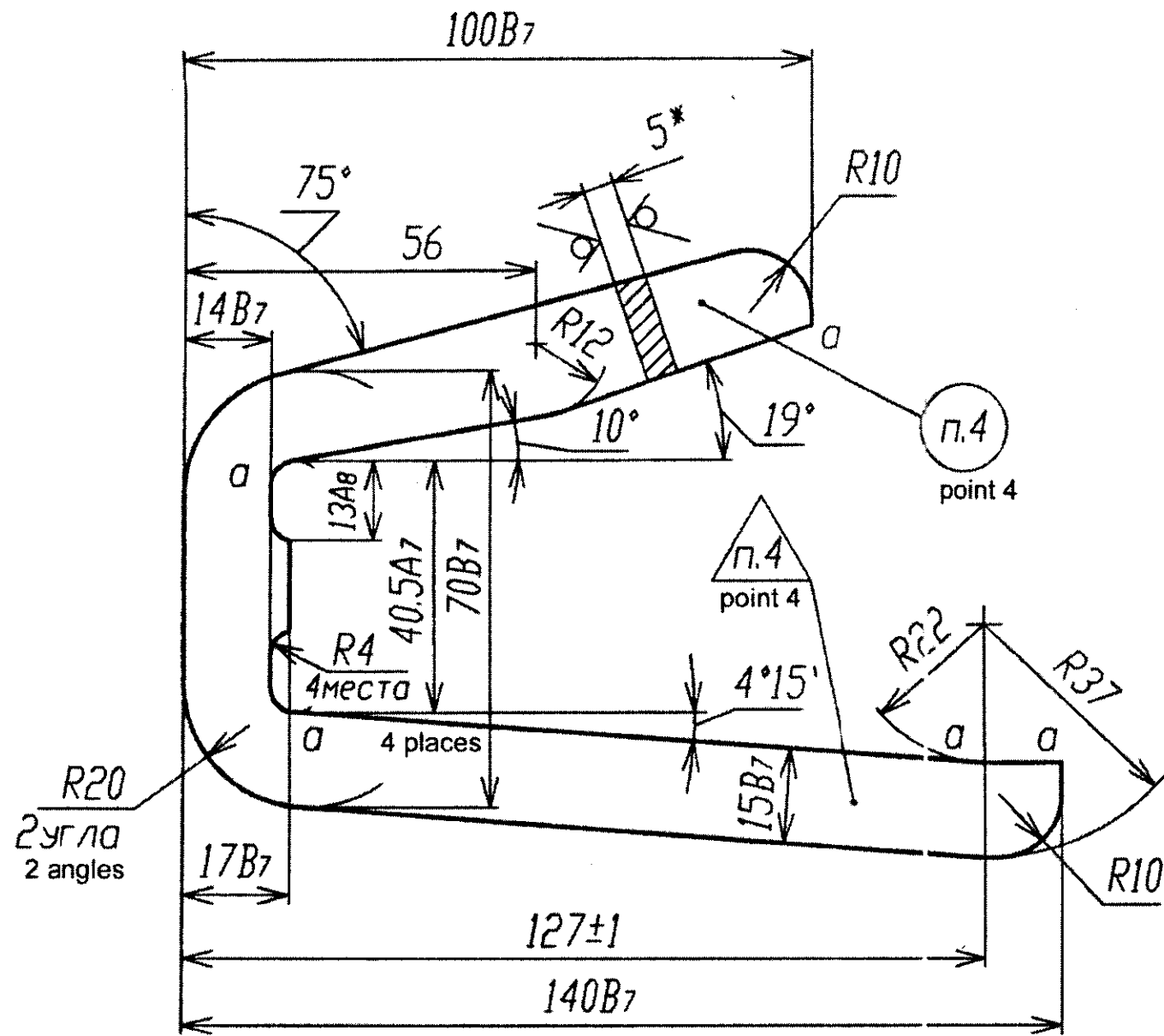
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



- 1.* Reference dimension.
2. Tolerance for contour "aa"- 0.5 mm.
3. Blunt sharp edges ~0.6 mm.
4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 107-80		
					Front rib		
					Type	Weight	Scale
					A	0.150	1:1
					Sheet	Sheets 1	
					Sheet $\frac{B - PN - 5GOST19903 - 74}{35 - 2GOST1577 - 93}$		
Amend.	Sheet	Doc.No.	Sign	Date			
Developed by							
Checked by							
Head of Q.C.D							
Approved by							

AK-630 107-84

First use

Reference No.

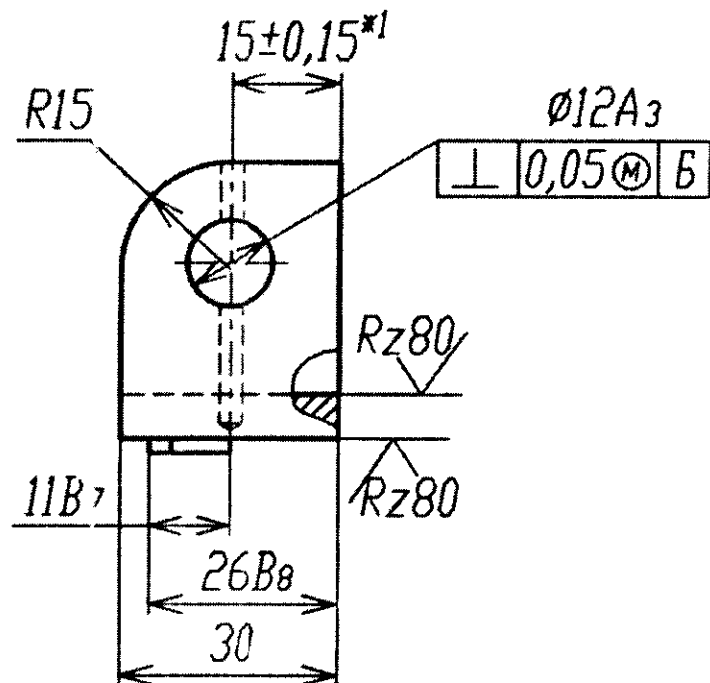
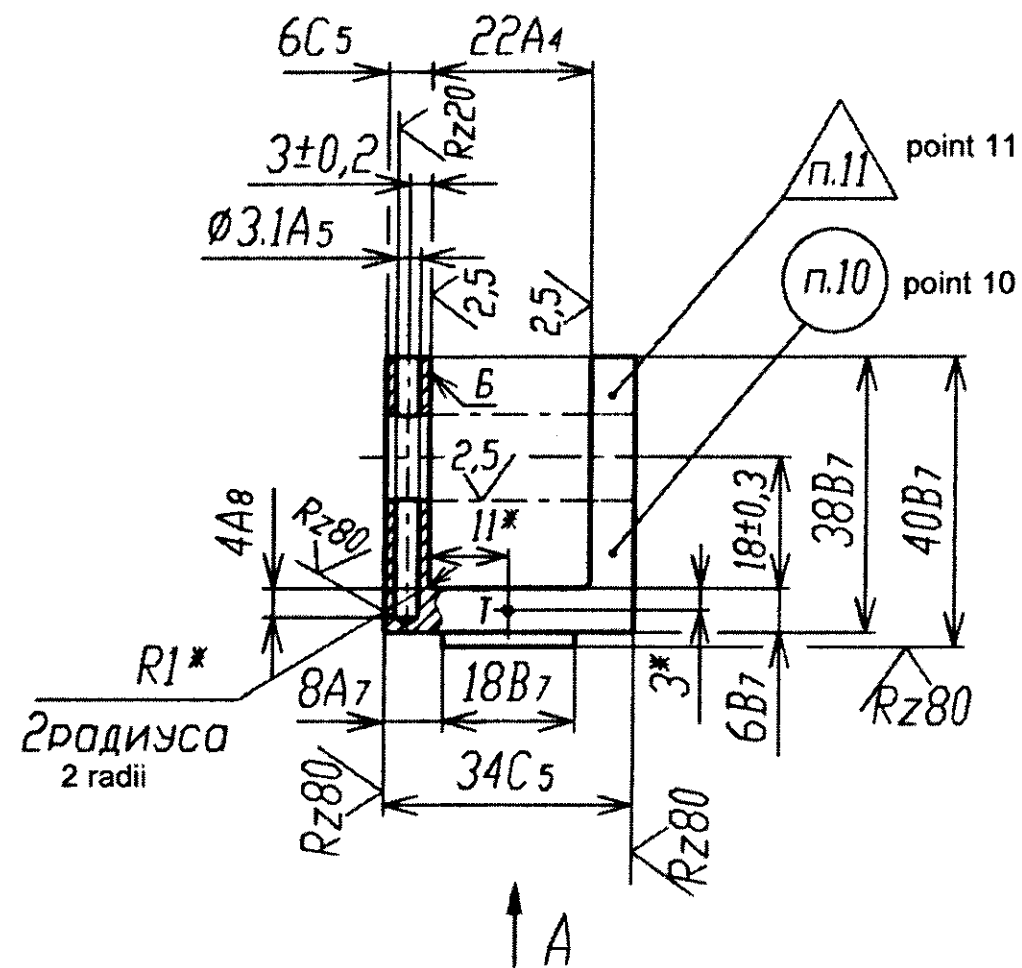
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

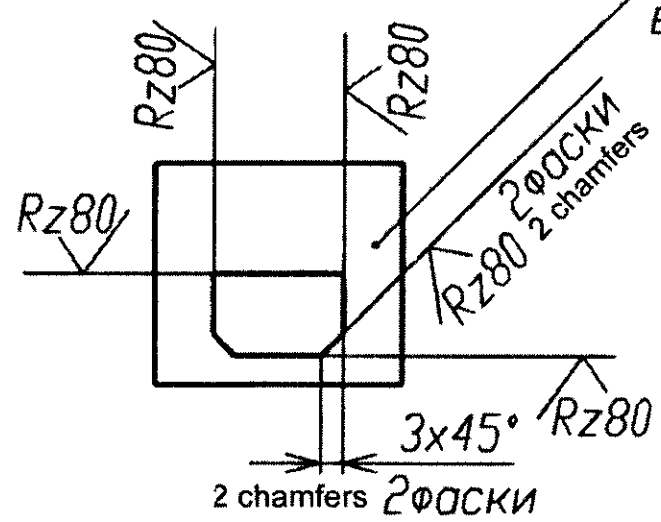


✓ (✓)

1. Accuracy of casting 8-0-0-7 GOST 26645-85.
2. Draft as per GOST 3212-92 toward increase in dimensions.
3. Casting radii R = 2 mm unless otherwise specified.
4. Shift on parting plane up to 0.3 mm.
5. Marks from pusher not exceeding 0.5 mm are permissible.
6. Surface finish of casting surfaces as per test specimen.
7. * Dimensions ensured by tool.
8. *1 Dimension given with respect to datum point T.
9. Mark Ш, Ч on tag.
10. Mark П as per AK-630, AK-630M TU I.
11. Stamp K as per AK-630, AK-630M TU I.

Non mergence within permissible tolerance is permissible

Допускается неслияние в пределах допуска



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

AK-630 107-84			
Right lug	Type	Weight	Scale
	A	0.120	1:1
Sheet	Sheets 1		
Casting	K25 - IIOST3 - 4363 - 79 351 GOST 977 - 88		

First use

Reference No.

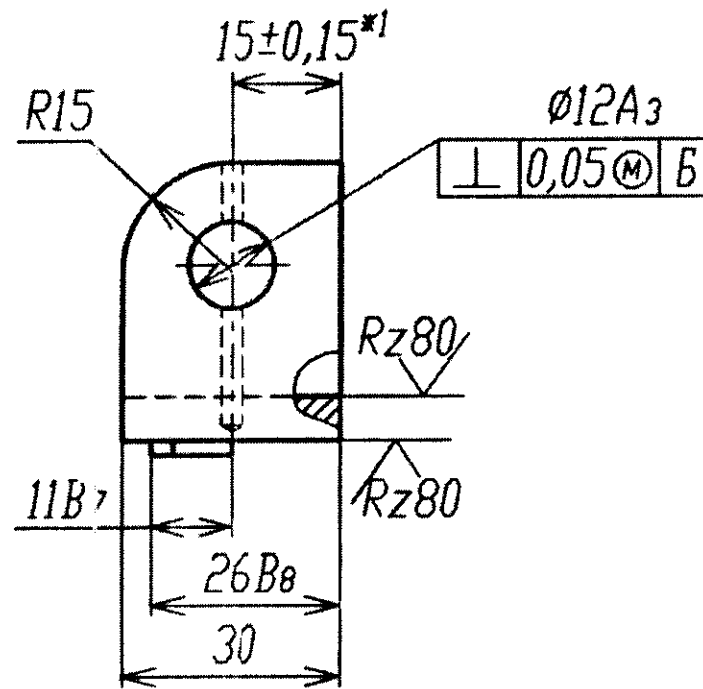
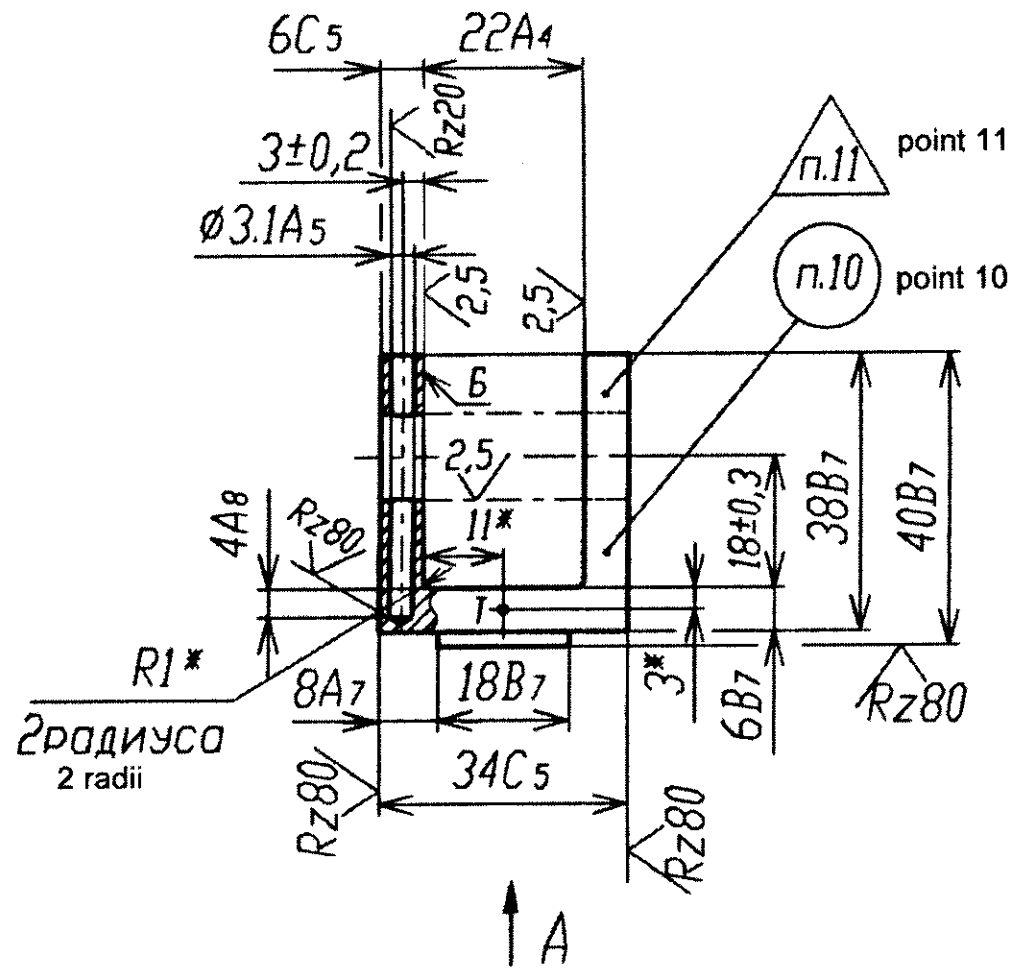
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

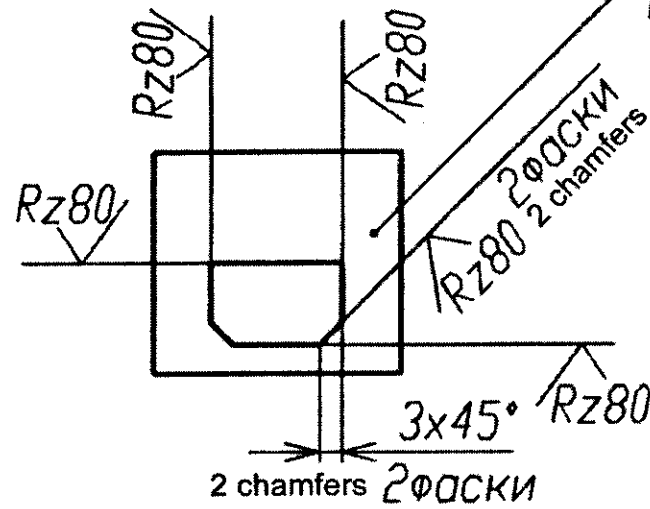


✓ (✓)

1. Accuracy of casting 8-0-0-7 GOST 26645-85.
2. Draft as per GOST 3212-92 toward increase in dimensions.
3. Casting radii R = 2 mm unless otherwise specified.
4. Shift on parting plane up to 0.3 mm.
5. Marks from pusher not exceeding 0.5 mm are permissible.
6. Surface finish of casting surfaces as per test specimen.
7. * Dimensions ensured by tool.
8. *1 Dimension given with respect to datum point T.
9. Mark Ш, Ч on tag.
10. Mark П as per AK-630, AK-630M TU I.
11. Stamp K as per AK-630, AK-630M TU I.

Non mergence within permissible tolerance is permissible

Допускается неслияние в пределах допуска



					AK-630 107-84			
Amend.	Sheet	Doc.No.	Sign	Date	Right lug	Type	Weight	Scale
Developed by						A	0.120	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Casting	K25 - ИОСТ3 - 4363 - 79		
Approved by						35LGOST977 - 88		

First use

Reference No.

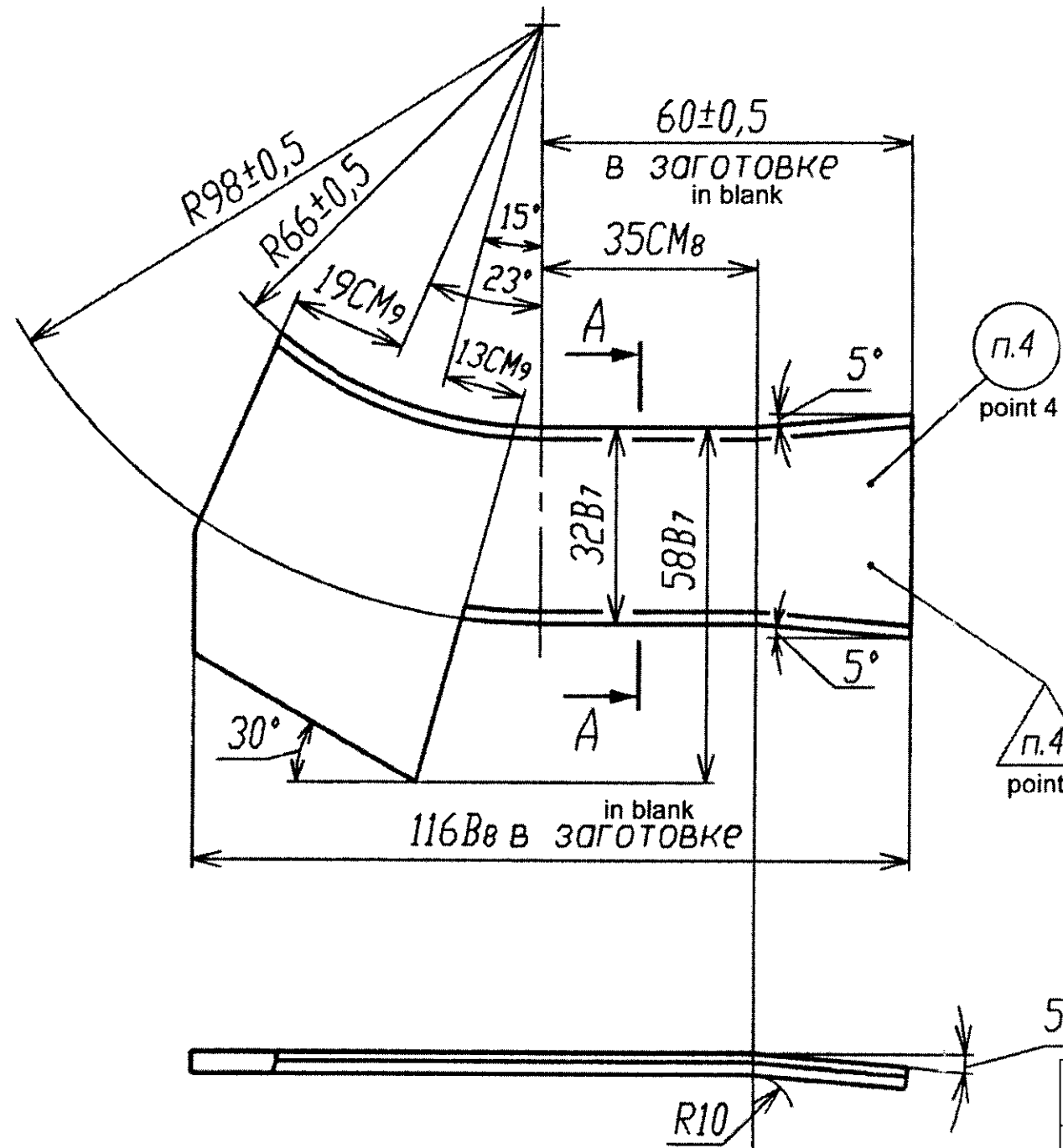
Sign and Date

Duplicate Inv. No

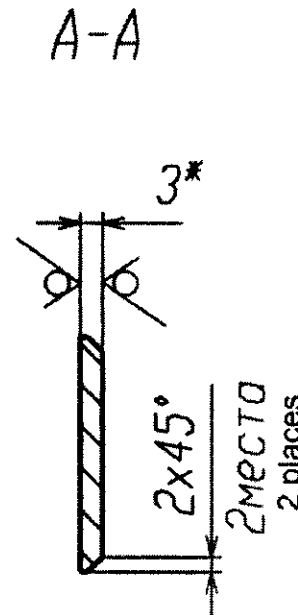
Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz80 (✓)



- 1.* Reference dimension.
- 2. Inner angles R~0.4 mm.
- 3. Blunt sharp edges ~0.6 mm.
- 4. Mark Ш, Ч and stamp K 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-630 107-85

Front wall	Type	Weight	Scale
	A	0.100	1:1
	Sheet	Sheets 1	
Sheet $\frac{B - PN - 03 GOST 19903 - 74}{K 490V 4 - III - 35 GOST 16523 - 97}$			

First use

Reference No.

Sign and Date

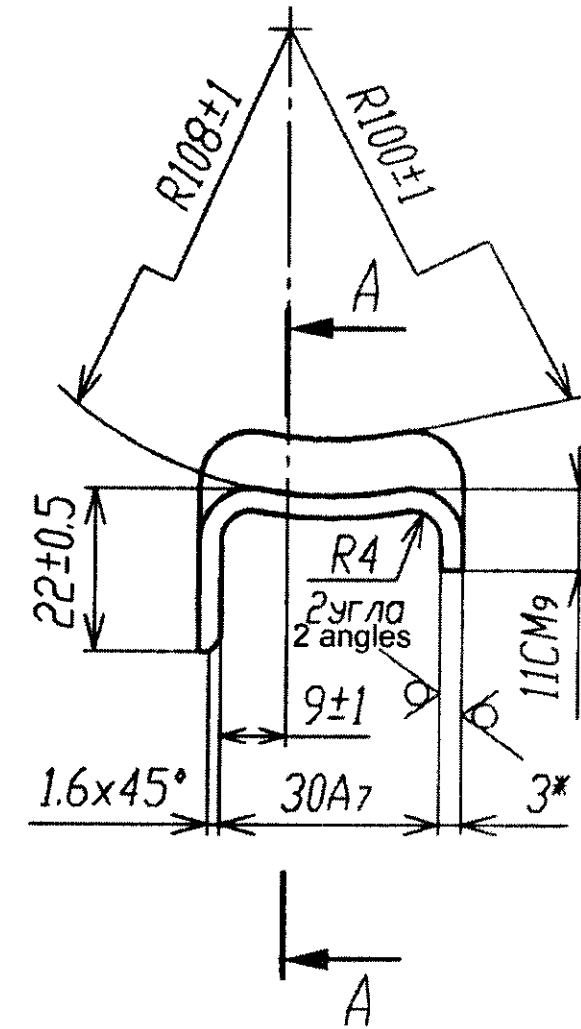
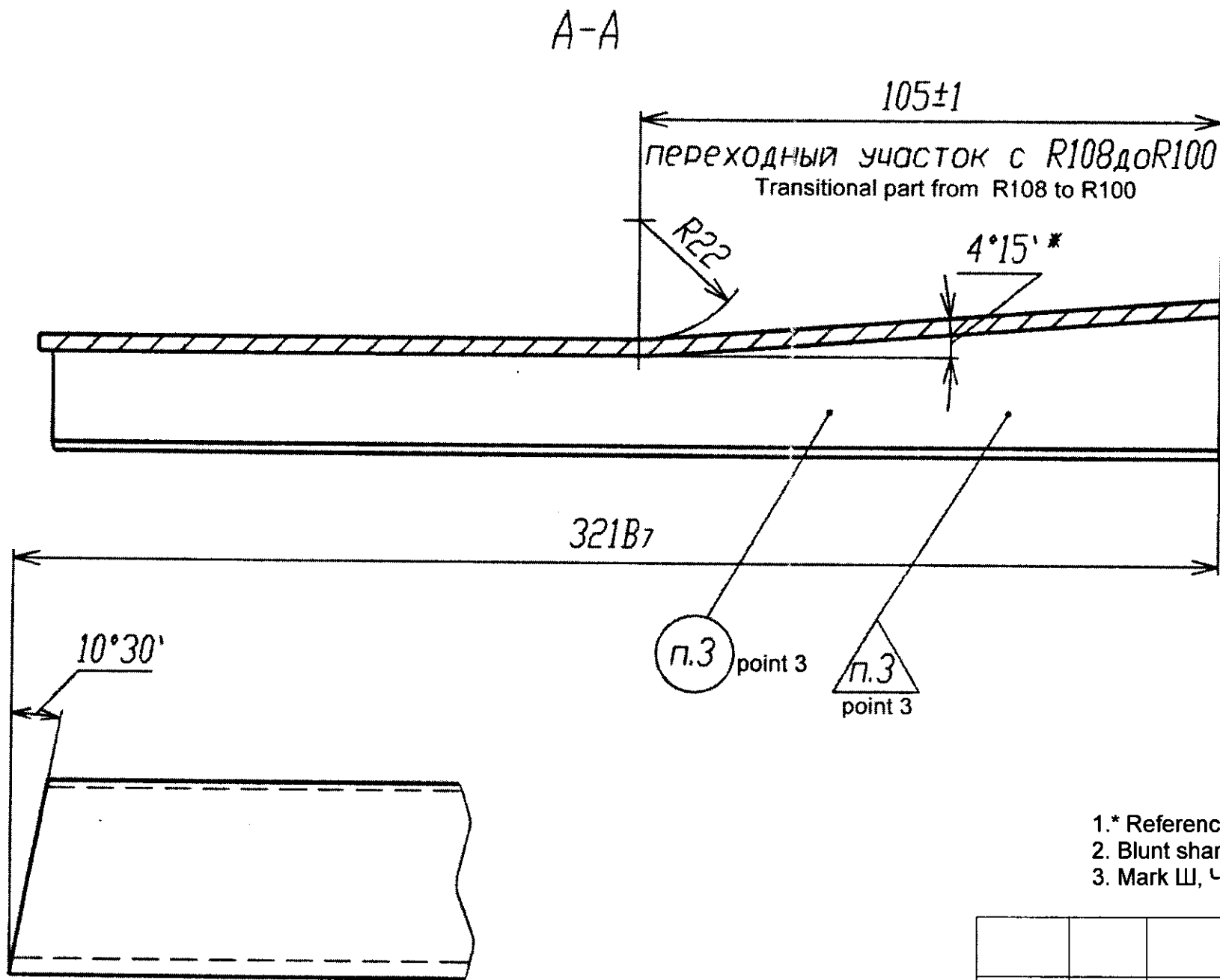
Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

Rz80 (✓) (✓)



- 1.* Reference dimension.
- 2. Blunt sharp edges ~0.6 mm.
- 3. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 107-88			
Amend.	Sheet	Doc.No.	Sign	Date	Rib	Type	Weight	Scale
Developed by						A	0.450	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Sheet $\frac{B - PN - 03 GOST 19903 - 74}{K 490V 4 - III - 35 GOST 16523 - 97}$			
Approved by								

First use

Reference No.

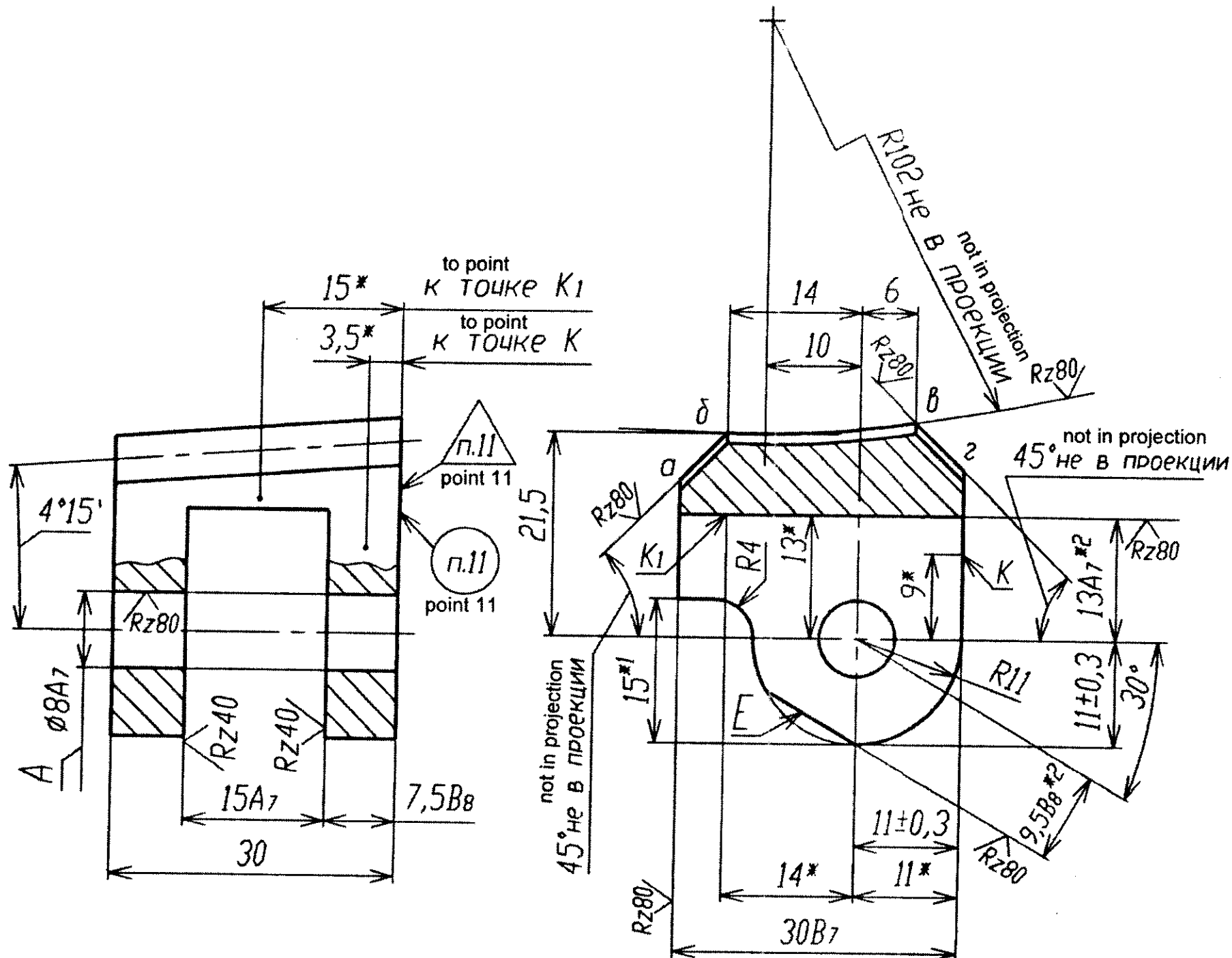
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. Accuracy of casting 8-0-0-7 GOST 26645-85.
2. Draft as per GOST 3212-92 toward increase in dimensions.
- 3.. Shift on parting plane up to 0.3 mm
- 4.. Marks from pusher not exceeding 0.5 mm are permissible
- 5.. Casting radii R = 2 mm unless otherwise specified
6. Surface finish of casting surfaces as per test specimen.
7. * Dimensions ensured by tool.
8. *1 Dimensions given before machining of surface E.
9. *2 Dimension given with respect to surface A and point K
10. Tolerance for contour аб, вг, not more than 0.5 mm for contour бв not more than 0.3 mm with respect to surface A and point K1
11. Mark П and stamp K as per AK-630, AK-630M TU I.
Mark Ш, Ч on batch tag.

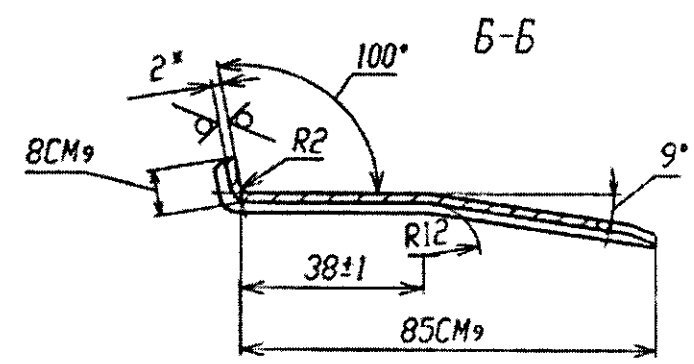
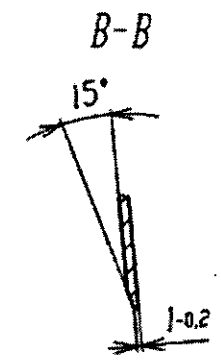
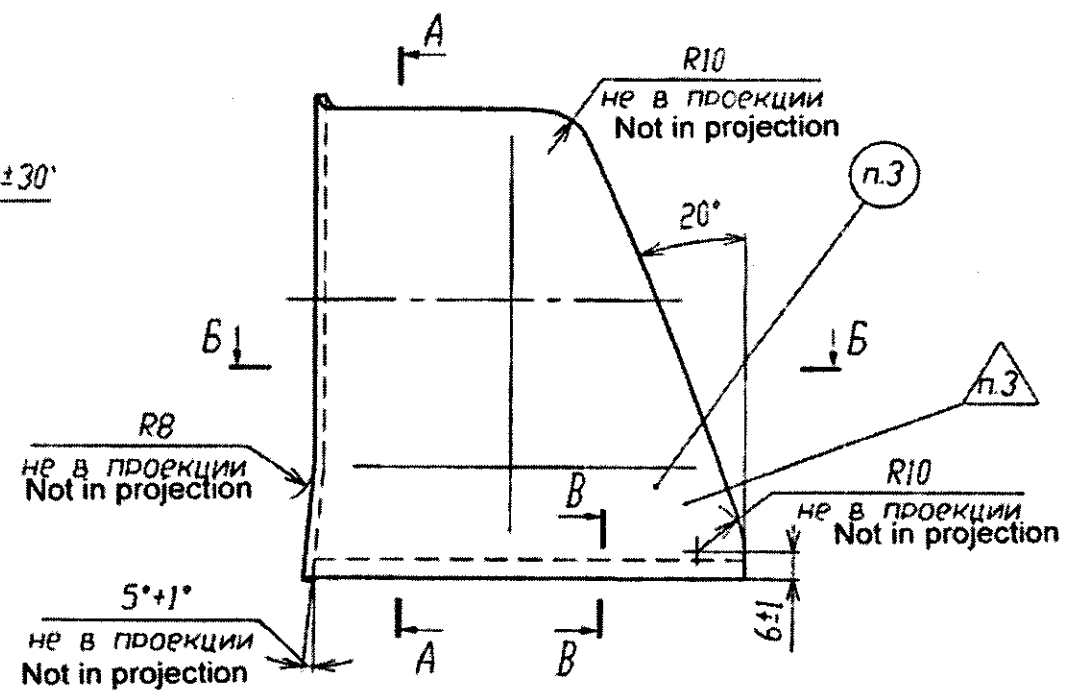
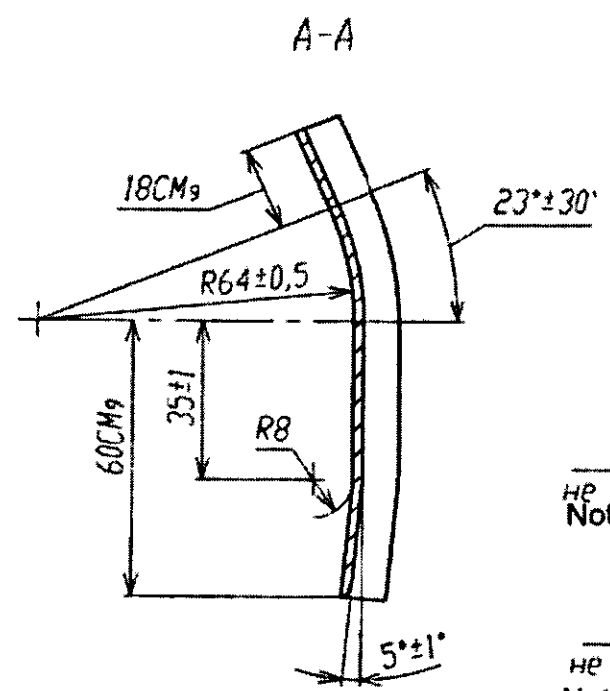
Amend.	Sheet	Doc.No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

AK-630 107-89

Lug	Type	Weight	Scale
	A	0.098	2:1
	Sheet	Sheets 1	
Casting	K25 - IIOST3 - 4363 - 79 35LGOST977 - 88		

AK-630 107-75

Rz80 (✓)



1. * - Dimension for reference.
2. Round off the sharp edges ~ 0.6 mm
3. Mark III, Ч and stamp K as per AK-630, AK-630 M TU 1.

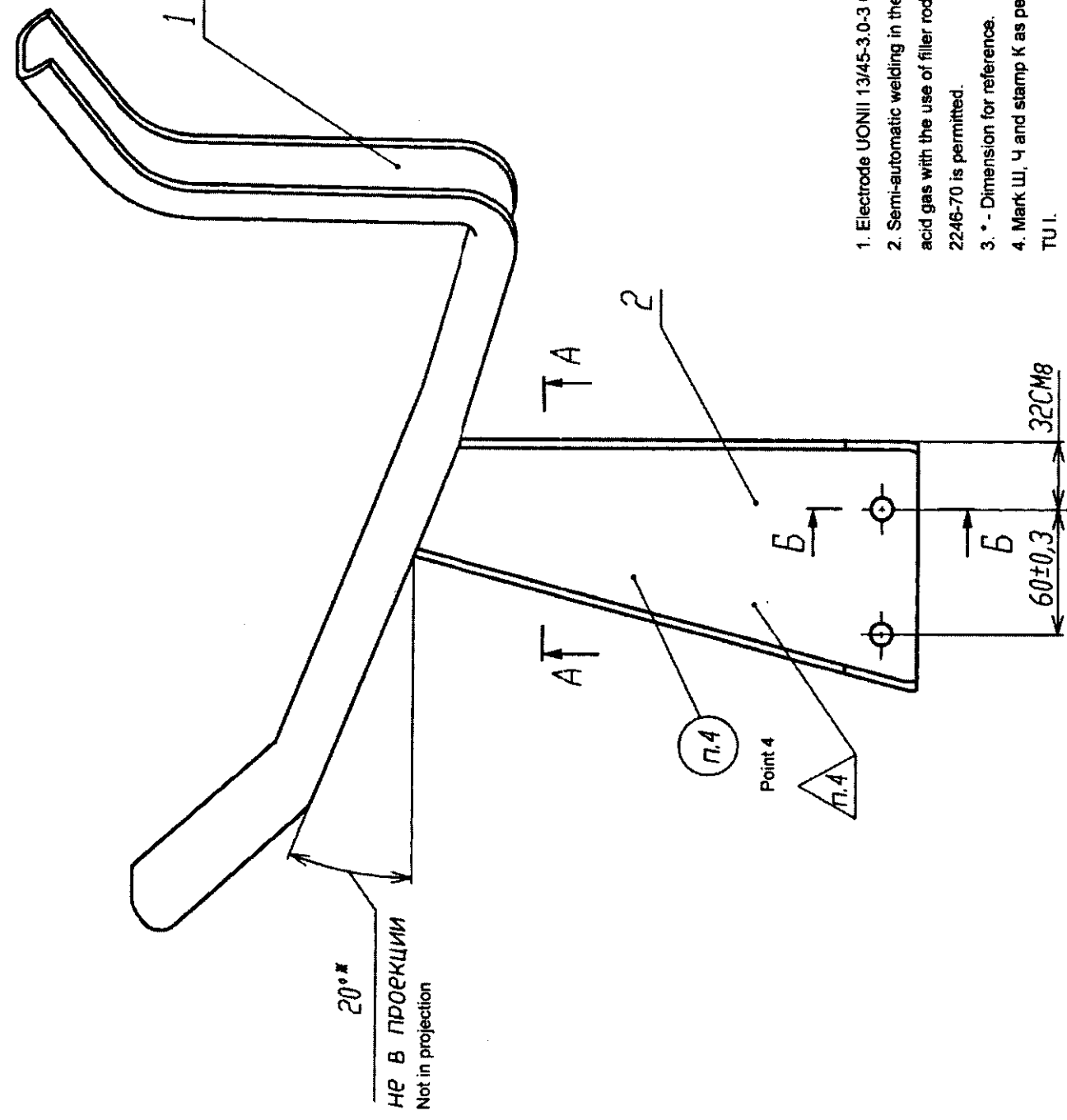
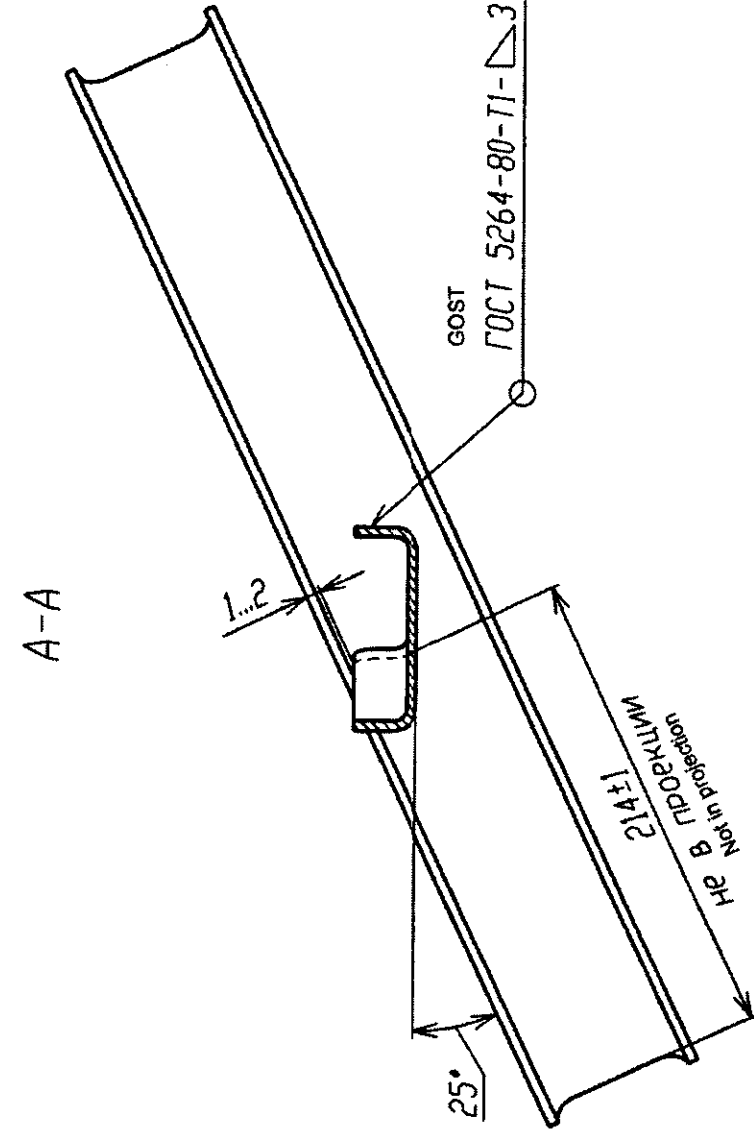
1. *Размер для справок.
2. Острые ребро притупить ~ 0,6 мм.
3. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ 1.

Пред. проект
 Спроект.
 Провер.
 Конст.
 Изм. и доп.
 Дата
 Подп. и дата
 Взам.
 Дата

				AK-630 107-75		
				Front Vane (flap)		
				Крыло		
				переднее		
				Type	Mass	Scale
				Лит.	Масса	Масштаб
				A	0,120	1:1
				Sheet		
				Лист		
				Листов		
				Sheet		
				Total Sheets		
				Лист 61-ПН-0 2 ГОСТ 19904-90		
				К1908 4-III-35 ГОСТ 16523-97		

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
					<u>Documents</u>		
Reference No.	A4			AK-630 Sb107-19 SB	Assembly drawing		
					<u>Components</u>		
	A4		1	AK-630 107-92	Lock ring	1	
					<u>Standard articles</u>		
		2		Pin 5C ₃ x16.40Kh	1		
				Chem.Phos.Oil. OST 3-2234-93			
Sign and Date							
Dupl. Inv. No.							
Alternate Inv. No.							
Sign and Date							
Orig. Inv. No.							

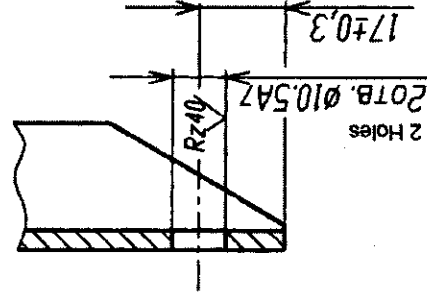
					AK-630 Sb 107-19		
Amend.	Sheet	Doc. No.	Sign	Date			
Developed by					Type	Sheet	Sheets
Checked by					A		1
Head of Q.C.D					Lock		
Approved by							



1. Electrode УОНИ 13/45-3.0-3 GOST 9466-75.
2. Semi-automatic welding in the medium of carbonic acid gas with the use of filler rod 1.2 Sv 08 G2S GOST 2246-70 is permitted.
3. * - Dimension for reference.
4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

1. Электрод УОНИ 13/45-3,0-3 ГОСТ 9466-75.
2. Допускается полуавтоматическая сварка в среде углекислого газа с применением присадочной проволоки 1,2 Св-08 Г2С ГОСТ 2246-70.
3. *Размер для справок.
4. Маркировать Ш,Ч и клеймить К по АК-630, АК-630М ТУ I.

B-B(1:1)



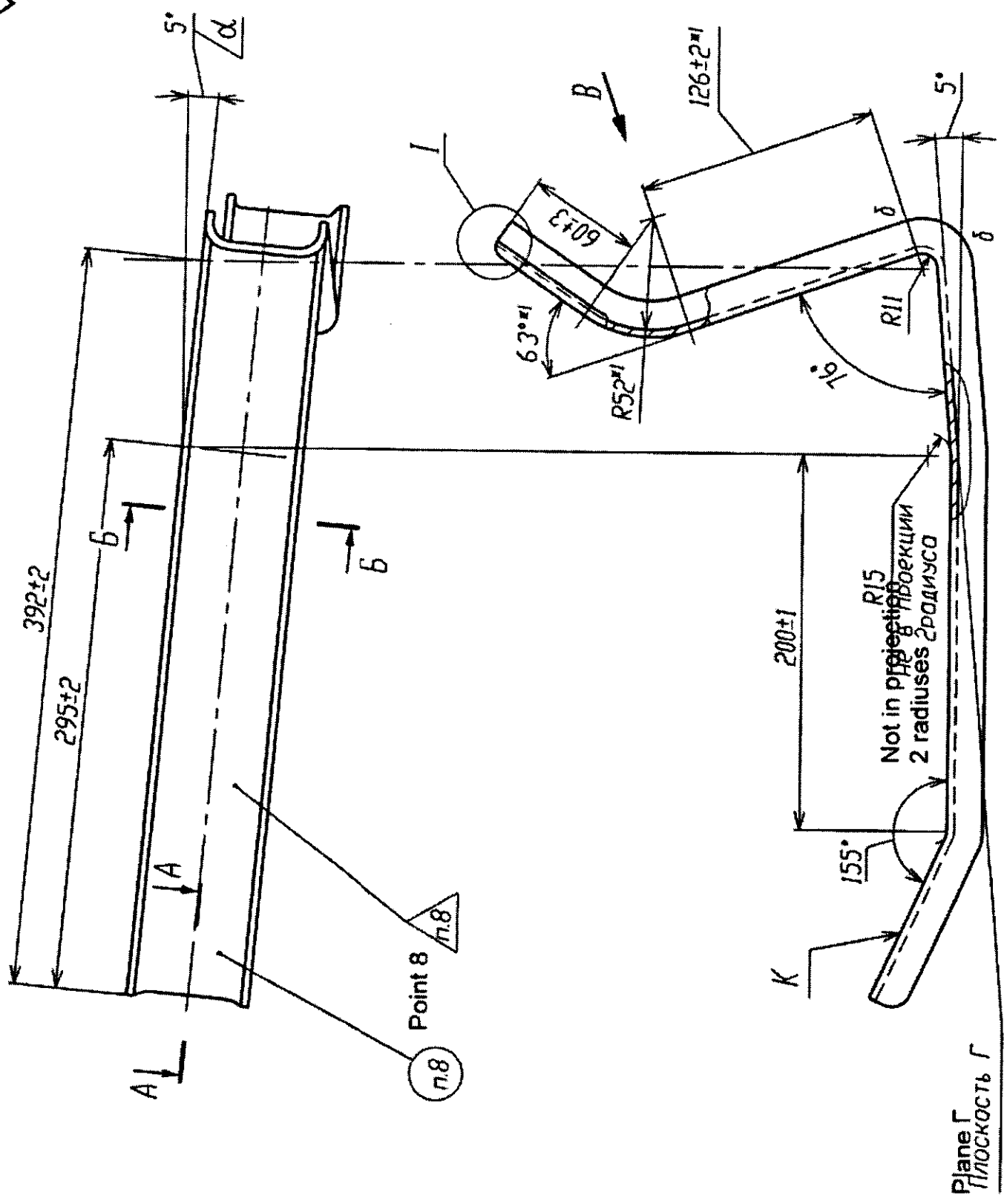
AK-630 Sb 107 - 4 SB

AK-630 СБ107-4СБ

№ п/п	Изм./лист	№ док-мт	Подп.	Дата	Тип	Scale		Лист	Листов
						Масштаб	Масштаб		
					А	1:2	2.300	1	1:2
Bracket КРОШТЕЙН					Лист	Листов			
Сборочный чертеж					Лист	Листов			
Assembly Drawing					Sheet	Total Sheets	1		

Rz80 (✓)

AK-630 107-20



1. * - Dimension for reference.

2. *1 Dimensions are given on plane E.

3. Angle α is given on plane E.

4. Tolerance along the contour aaa is ± 0.5 mm; passage of radius \mathcal{X} in straight line and the reduction of dimension D up to 12 mm is permitted on section 'bb'.

5. While bending, the depressions are permitted with subsequent welding and finishing.

6. Presence of 4 technological holes of $\Phi 12A_7$ is permitted on surface K along the axial line of part, except on the places of bends.

1. *Размер для справок.

2. *1Размеры даны в плоскости E.

3. Угол α дан в плоскости E.

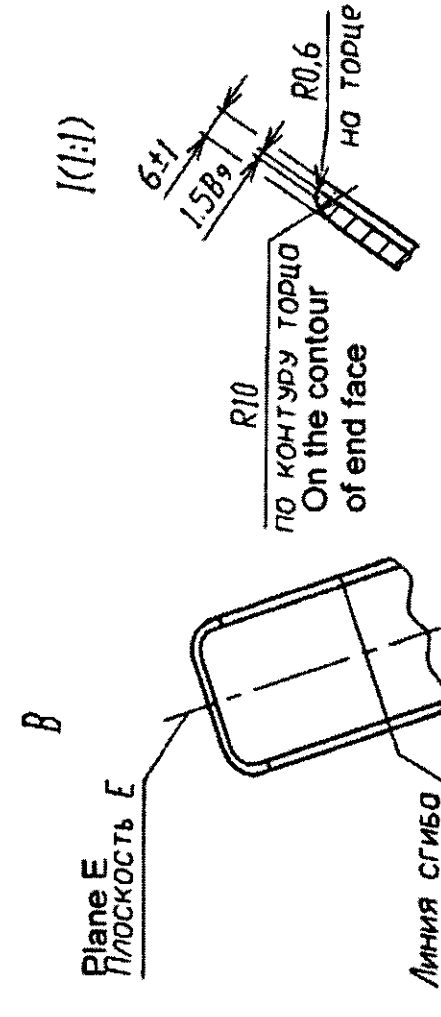
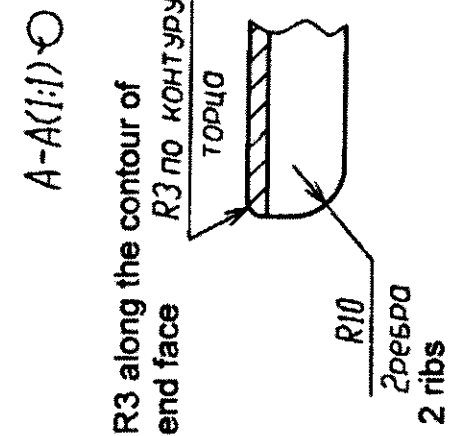
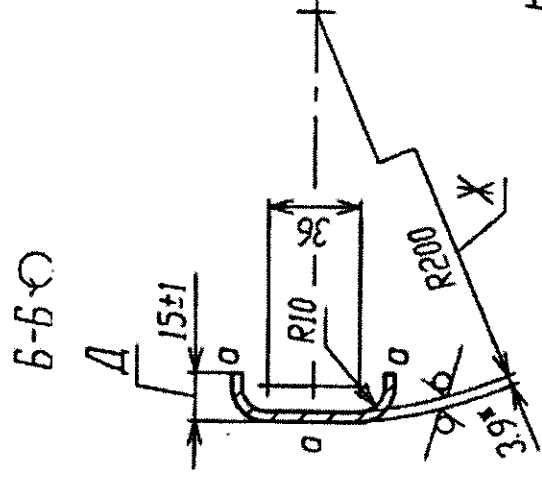
4. Допуск по контуру aaa $\pm 0,5$ мм; на участке 'bb' допускается переход радиуса \mathcal{X} в прямую линию и уменьшение размера D до 12 мм.

5. Допускаются надрывы при гибке с последующей заваркой и зачисткой.

6. На поверхности K по осевой линии детали, кроме мест перегибов, допускается наличие 4-х технологических отверстий $\Phi 12A_7$.

7. Острые ребра притупить ≈ 1 мм.

8. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ 1.



7. Round off (blunt) the sharpedges ≈ 1 mm.

8. Mark Ш, Ч and stamp К as per АК-630, АК-630М ТУ 1.

Лист / Sheet		Масса / Mass		Шкала / Scale	
№	Изм.	№	Масса	№	Шкала
1	А	1,160	1:2		
ИЗМ. № ДОКУМ. ПОЛН. ДОТ		Лист / Sheet		Масса / Mass	
УТВЕРЖ.		Листов / Total Sheets		Шкала / Scale	
И. КОМП.		Лист / Sheet		Масса / Mass	
УТВ.		Лист / Sheet		Масса / Mass	

AK-630 107-20

Trough / Tray / Лоток

5-ПН-0.3.9 ГОСТ 19903-74
К498 4-III-35 ГОСТ 16323-97

Формат А2

First use

Reference No.

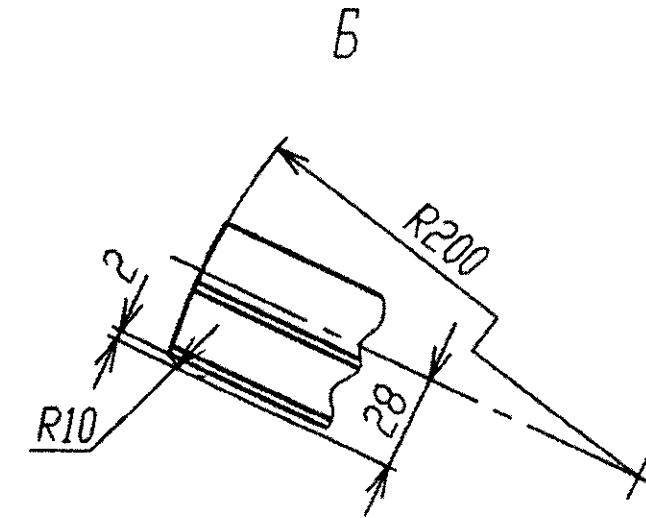
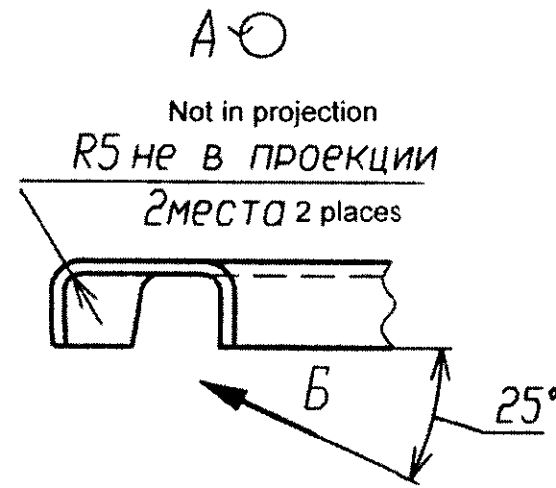
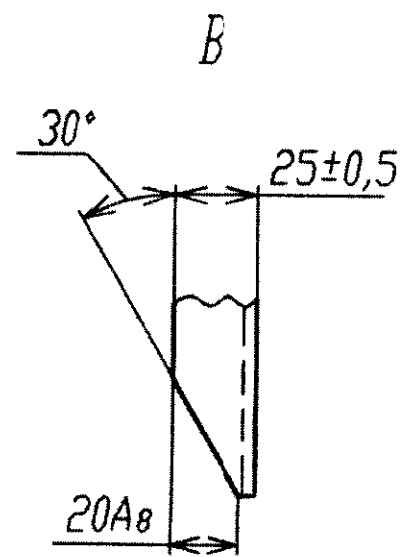
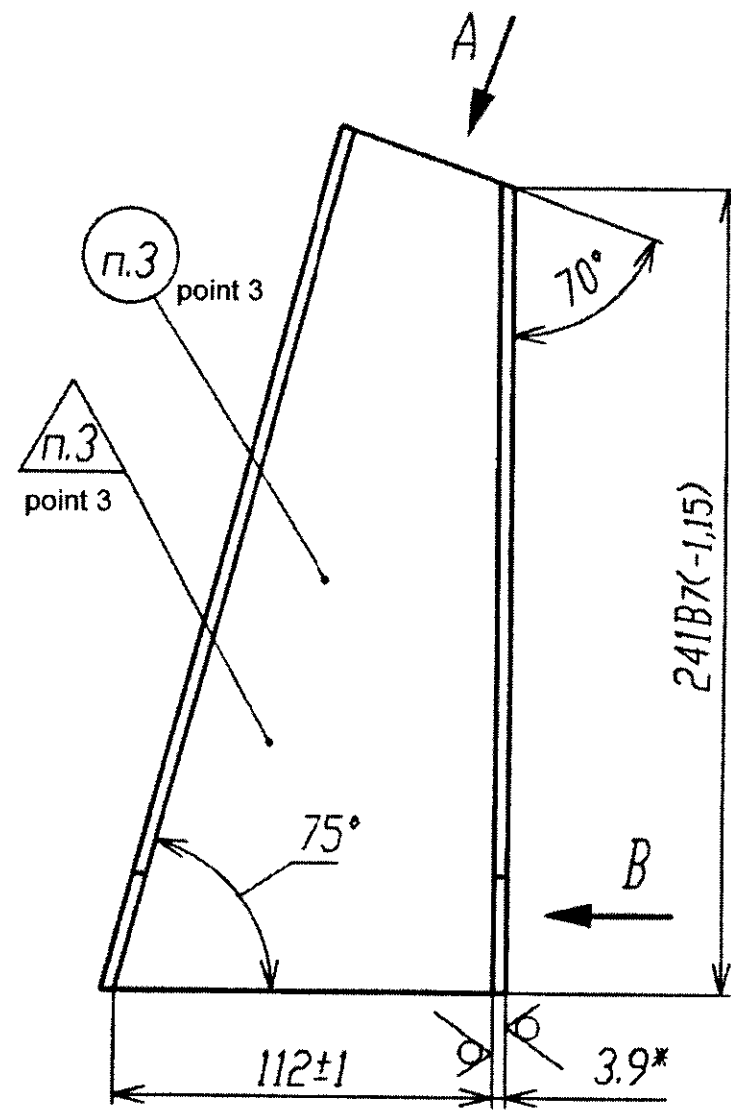
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz80 (✓)

- 1.* Reference dimension.
2. Blunt sharp edges ~0.6 mm.
3. Mark Ш, Ч and stamp K as per AK-630, AK-630 TU I.

					AK-630 107-21			
Amend.	Sheet	Doc.No.	Sign	Date	Base plate	Type	Weight	Scale
Developed by						A	0.980	1:2
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by					Sheet $\frac{B - PN - 03.9 GOST 19903 - 74}{K 490V 4 - III - 35 GOST 16523 - 97}$			

AK-630 СБ107-5СБ

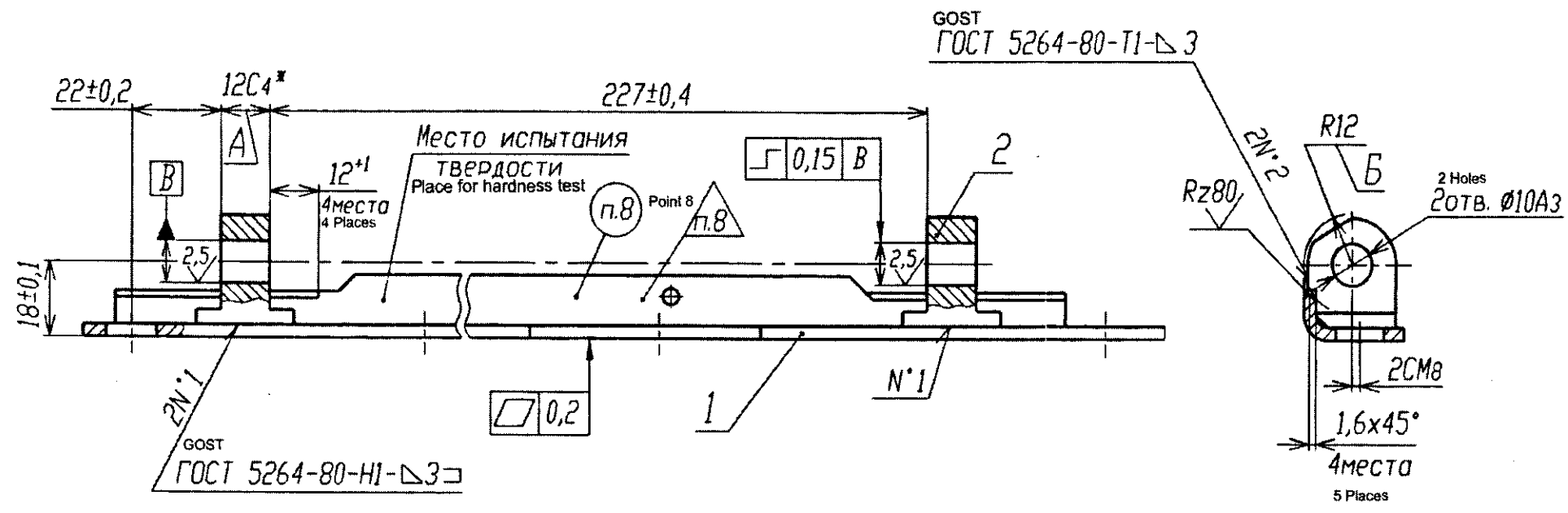
Перв. примен.

908.Н

Подп. и дата

Изм. №, д.в.в.

Взам. инв. №



1. Electrode UONIИ 13/45-3.0-3 GOST 9466-75.
2. Semi-automatic welding in the medium of carbonic acid gas with the use of electrode filler 1.2 Sv-08 G2S GOST 2246-70 is permitted.
3. 29...35 HRCa. Finishing at the places for hardness test is permitted up to 0.5 mm.
4. * - Dimensions for reference.
5. Finish the planes of stand position 2 as per dimension A against the influx of welding in the zone B.
6. Sawing of reference (supporting) planes of stand is permitted as per the requirement.
7. Coating Cad. 6 Phos. followed by oil treatment.
8. Mark Ш, Ч and stamp К, И as per AK-630, AK-630M TU I.

1. Электрод УОНИИ 13/45-3,0-3 ГОСТ 9466-75.
2. Допускается полуавтоматическая сварка в среде углекислого газа с применением присадочной проволоки 1,2 Св-08 Г2С ГОСТ 2246-70.
3. 29...35 HRCa. В местах замера твердости допускается зачистка до 0,5 мм.
4. *Размеры для справок.
5. Плоскости стоек поз. 2 по размеру А зачистить от наплывов сварки в зоне Б.
6. Допускается припиловка опорных плоскостей стоек по мере надобности.
7. Покрытие Кдб. фос. прм.
8. Маркировать Ш, Ч и клеймить К, И по АК-630, АК-630М ТУ I.

AK - 630 Sb 107 - 2SB

				AK-630 СБ107-5СБ		
				Type	Mass	Scale
Изм.	Лист	№ докум.	Подп.	Дата	Лит.	Масса
Разроб.					А	0,345
Пров.					Лист	Листов 1
Т.контр.					Sheet	Total Sheet 1
И.контр.					Assembly Drawing	
Утв.						

Bale 8 container 2 Формат А4х3

AK-630 107-26					
Approved OGMet	Approved TOsb	Approved KTONI	Approved by shop	First use	
Orig. Inv. No.	Alternate Inv. No.	Sign and Date	Dupl. Inv. No.	Reference 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					

Rz80 (✓) (✓)

1. Inner angles R~0.4 mm.
 2. Blunt sharp edges R~0.6 mm.
 3. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

AK-630 107-26

Type	Weight	Scale
A	0.052	1:1

Support

Steel 35
GOST 1050-88

Sheet	Sheets 1
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Format A4