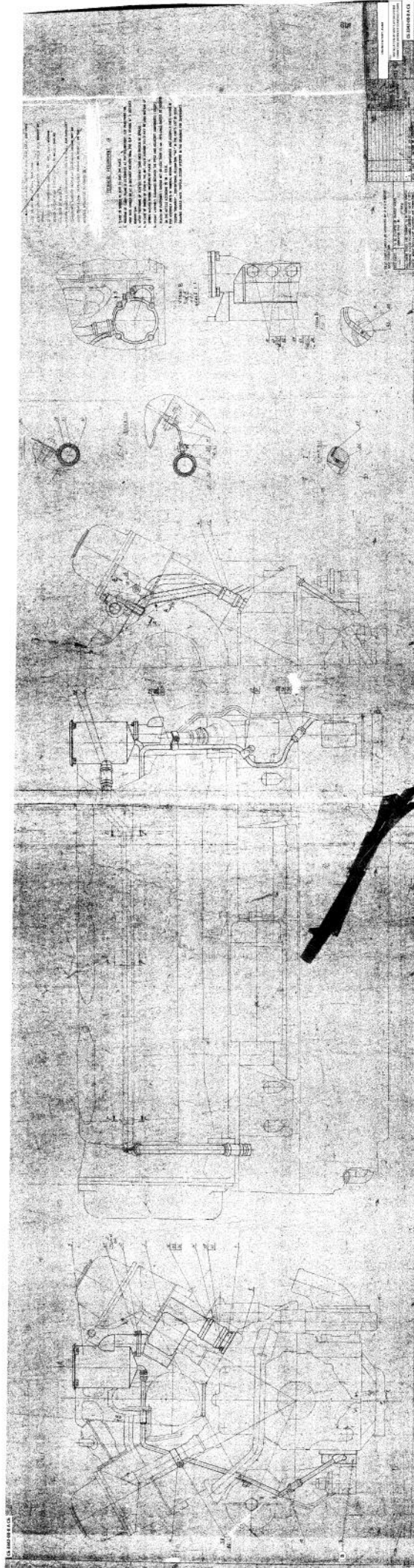
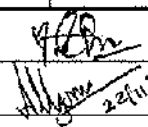
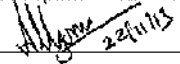
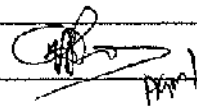
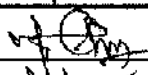
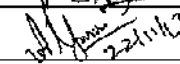
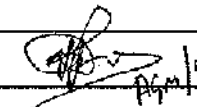




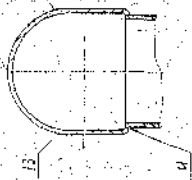
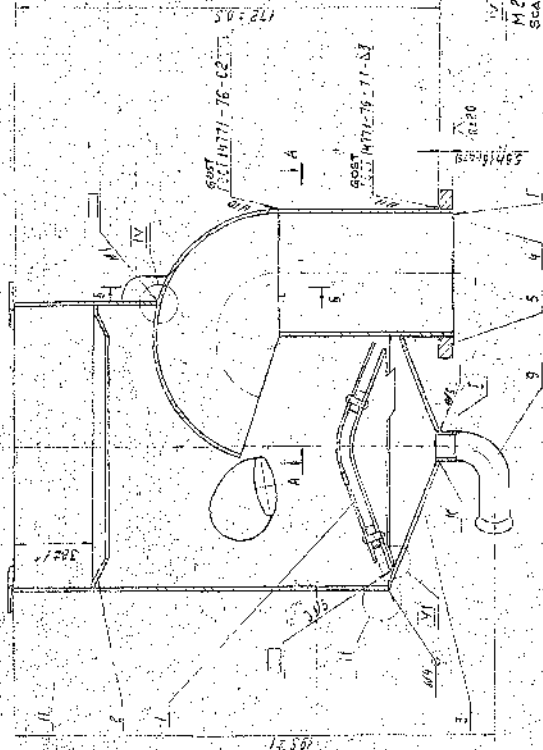
ITEM	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	No. OF	REMARKS
	CE 3342-00-8 CE		INSTALLATION OF		
	& ITEM LIST		VENTILATION SYSTEM		
			CRANK CASE		
1	CE 3342-185-1		ASSY FLANGE	1	
	& ITEM LIST				
2	CE 3342-187-1 CE		ASSY FUNNEL	1	
	& ITEM LIST				
3	CE 3342-188-3 CE		ASSY SEPERATOR OIL	1	
	& ITEM LIST				
4	CE 3342-221 CE		ASSY CLAMP	1	TH
	& ITEM LIST				
A 5	CE 402-92-1 & ITEM LIST	—————	ASSY SCAVENGE PUMP	1	DELETED
6	CE 3321-05-3		CLIP ASSY	6	TH
	& ITEM LIST				
7	3342-218-1		GASKET	1	TH
8	3342-224		PLATE CLAMPING	3	TH
9	3342-229-1		PIPE	1	
10	3342-230-1		PIPE	1	
A	21.11.13	GM Sanction vide Ltr No. EFA/P/P&P/118 Dt. 20.11.2013			
ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS
DRN		ENGINE FACTORY, AVADI TITLE: INSTALLATION OF VENTILATION SYSTEM CRANK CASE (WITHOUT SCAVENGE PUMP)			
CHD					
TCD					
APPD		SHT. No. 1 OF 3		D S CAT NUMBER	ITEM LIST FOR
DATE					CE 3342-00-8 A CE

ITEM	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	No. OF	REMARKS				
11	3342-231		HOSE	1	ТИ				
12	3342-232-5		PIPE	1					
13	3342-235		SHAFT	6	ТИ				
14	3342-243		CLIP HOSE	3	ТИ				
15	3342-247		WASHER	2	ТИ				
16	3342-251		HOSE	2	ТИ				
17	3342-252		HOSE	1	ТИ				
18	3342-253		HOSE	3	ТИ				
19	3342-254		RING	1					
20	353-21		WASHER LOCKING 9	1	ТИ				
21	301-97-1		GASKET	1	ТИ				
22	3320-140		CLIP HOSE	1	ТИ				
23	420-149-2		GASKET	2					
24	420-149-5		GASKET	4					
25	3335-77-3		CLAMP	1	ТИ				
26	356-138-1		BOLT M8 X 20	3	ТИ 3 PCS Replaces to item 46				
27	ХЛ 225-Л		CLAMP BAND	4	STANDARD ITEM LIST N233-59 SHTs 3				
28	ХЛ 475-Л		CLAMP BAND	2					
29	ХР -Л		CLAMP CLIP	6					
ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS				
DRN		ENGINE FACTORY, AVADI TITLE: INSTALLATION OF CRANK CASE VENTILATION SYSTEM WITHOUT SCAVENGE PUMP							
CHD	 22/11/13								
TCD									
APPD	 Agm/p	SHT. No. 2 OF 3 <table border="1" style="width: 100%;"> <tr> <td>D S CAT NUMBER</td> <td>ITEM LIST FOR</td> </tr> <tr> <td></td> <td>C5 3342-00-8 A C5</td> </tr> </table>				D S CAT NUMBER	ITEM LIST FOR		C5 3342-00-8 A C5
D S CAT NUMBER	ITEM LIST FOR								
	C5 3342-00-8 A C5								
DATE									

[illegible]

6-6 ALTERNATIVE

6-6
GOST 14771-76-C2

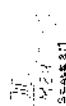


SCALE 2:1



SCALE 2:1

SCALE 2:1



1. THE SURFACE OF SURFACE "A" RELATIVE TO SURFACE "K" SHOULD NOT EXCEED 0.02 AT A LENGTH 100.
2. THE SURFACE OF SURFACE "F" SHOULD NOT EXCEED 0.01.
3. DURING THE ASSEMBLY OF THE SEPARATOR, THE SURFACE OF SURFACE "F" SHOULD NOT EXCEED 0.01.
4. THE SURFACE OF SURFACE "F" SHOULD NOT EXCEED 0.01.
5. AT SECTIONS "A-A" VOLUNTARY ROUNDS SHOULD BE MADE AS REQUIRED.
6. DURING ASSEMBLY THE RELATIVE ALIGNMENT OF COMPONENTS IS ALLOWED.
7. THE SURFACE OF SURFACE "F" SHOULD NOT EXCEED 0.01.
8. THE SURFACE OF SURFACE "F" SHOULD NOT EXCEED 0.01.
9. THE SURFACE OF SURFACE "F" SHOULD NOT EXCEED 0.01.
10. AFTER PRESSURE TEST, LEAKY POINTS MAY BE REPAIRED WITH PASTE AT 60.
11. DIMENSION FOR REFERENCE.
12. THE DIMENSION SHOULD COMPLY WITH TT 20103-74.
13. HOLES ARE NOT ALLOWED ON SURFACES "A" AND "F". THE SURFACE OF THE SPECIFIED SURFACE IS ALLOWED.

SCALE 2:1



SCALE 2:1



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USED ON

Cb 3342-188-3 Cb

ITEM	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	No. OFF	REMARKS
	Cb 3342-184-1 Cb		SUB ASSY BODY OIL		
	& ITEM LIST		SEPARATOR		
1	Cb 3342-186		SUB ASSY CONE	1	
	& ITEM LIST				
2	3342-190		CONE	1	
3	3342-191		CONE	1	
4	3342-197		PIPE	1	
5	3342-198-1		FLANGE	1	
6	3342-199		BRACKET	1	
7	3342-200		RIB	2	
8	3342-201		PIPE	1	
9	3342-202		TUBE	1	
10	3342-203		LUG	4	
11	3342-220-2		BODY OIL SEPARATOR	1	
12	3342-233		VOLUTE HALF R.H.	1	
13	3342-234		VOLUTE HALF L.H.	1	
ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS
DRN	<i>L. Gungulaw</i>		CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI		
CHD	<i>Dairb R. J. J.</i>		TITLE:		
TCD	<i>L. Gungulaw</i>		SUB ASSY BODY OIL SEPARATOR		
APPD	<i>W. J. J.</i>				
DATE	30-6-86	SHT. No OF	D S CAT NUMBER	ITEM LIST FOR	
				Cb 3342-184-1 Cb	

[illegible]

1999-2000	1999-2000
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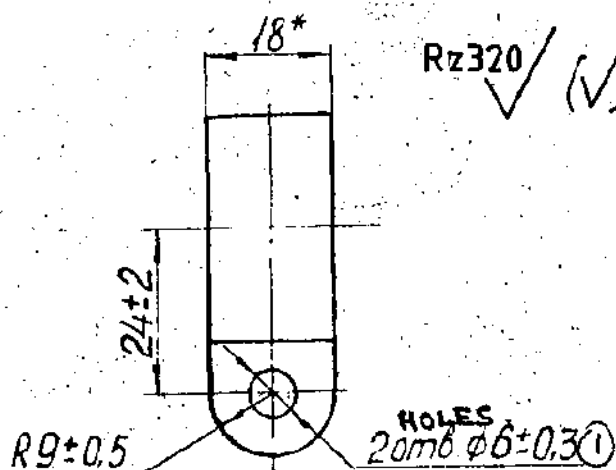
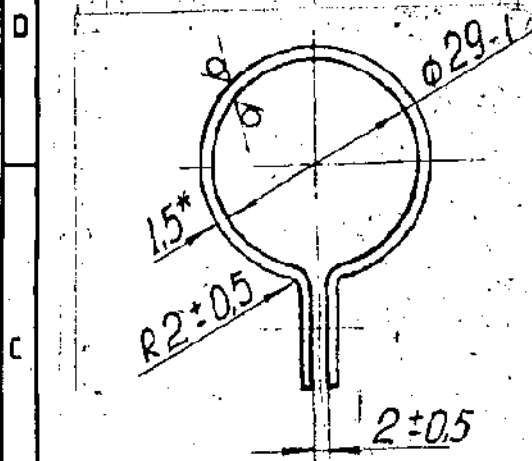


3. Gas welding is permitted. Welding should match with technical requirements 23.108-43-74.

Фонетика АЗ

DRAWING NUMBER

3342 243



© EQUIVALENT MATERIAL

G.F.D.D IS: 513-1994

1. Свободная длина = 124 мм.

2. Покрытие Ц 9, хр по ЦАА-154.

3. Допускается изготовление из детали 3320-150-1.

4. Размеры для справок.

1. LENGTH OF STRAIGHTENED COMPONENT = 124mm

2. COATING: Zn 9, CHROMATIZING AS PER INSTRUCTIONS ИТJ483-82.

3. MAY BE MANUFACTURED FROM COMPONENT 3320-150-1.

4. DIMENSIONS FOR REFERENCE.

5. In tropical design coating Cd.9, chromating as per UA-569-84, removing hydrogen embrittlement.

ⓑ

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

A-10

EST. WT

0.023 Kg

TO BE STAMPED OR MARKED WHERE

INDICATED THUS #

I LETTERS)

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

MATERIAL:

BAND 08 ПС-М-НТ-2-
1.5x18 GOST 503-74.81

USED ON:

CB 3342 00 B CB

ISSUE DATE NATURE OF AMENDMENTS

C 17.03.10 6th Alt. Comm. Mt. Minutes Pt. No. 1 Dt. 26.10.09

B 16.4.90 AUTHY. BK 86-195.

A 15.10.87 AUTHY. NOTN. No. BK 83-126.

SCALE: 1 : 1

DIMENSIONS IN mm

TOLERANCE ON DIMS UNLESS OTHERWISE STATED

ALL THREADS TO CONFORM TO

DATE 30/6/88

SIZE A4



TITLE:

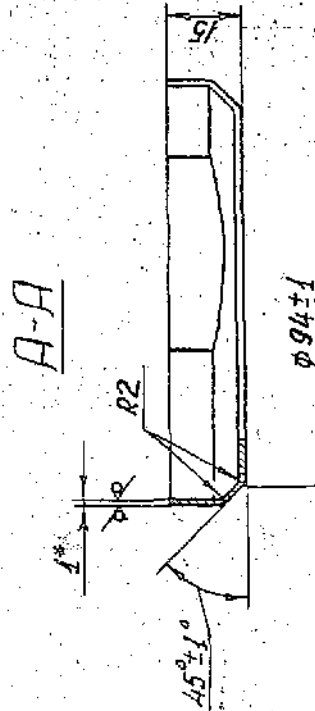
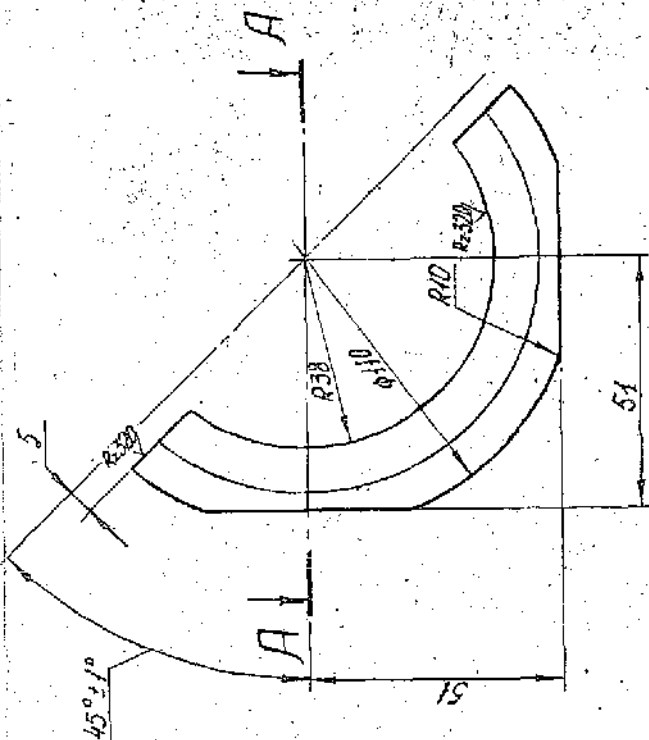
CLIP HOSE

D S CAT NUMBER

DRAWING NUMBER

3342 243

DRAWING NUMBER
3342-244



1. DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE OBTAINED WITH ACCURACY OF ± 0.5 mm.
2. * DIMENSION FOR REFERENCE

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

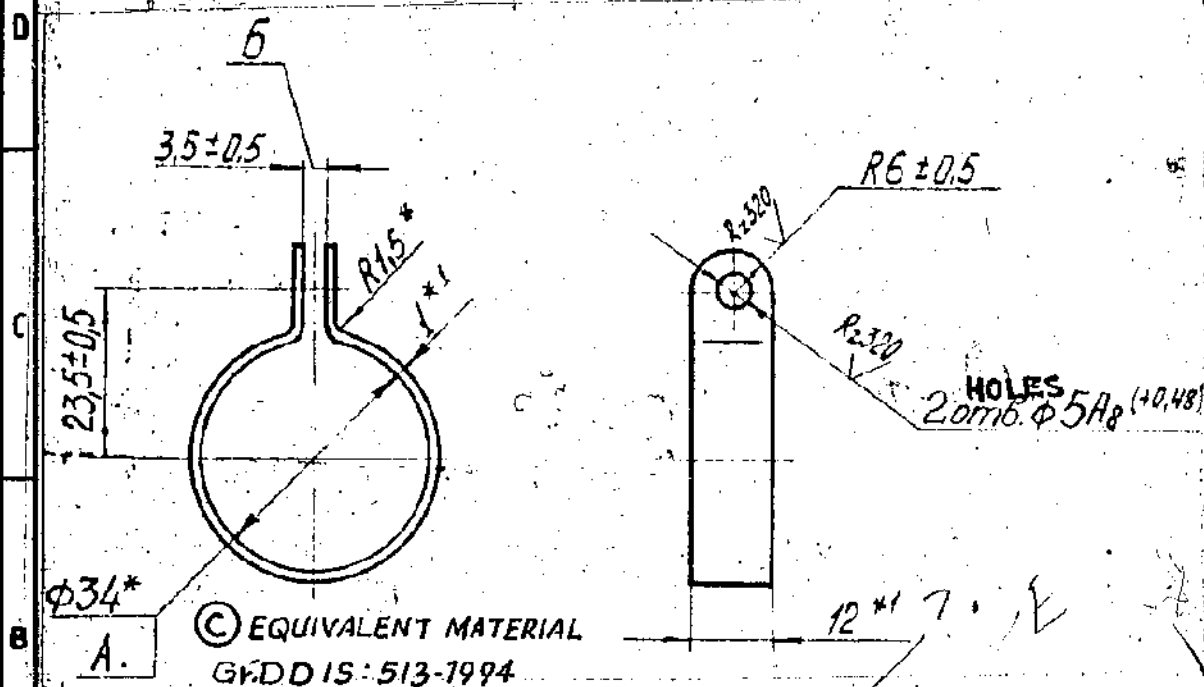
EST. MASS 0 022 19 TO BE STAMPED OR MARKED WHERE INDICATED THUS & LETTERS

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

[illegible]

DRAWING NUMBER

3342 246



1. LENGTH OF STRAIGHTENED COMPONENT = 127.5 mm.
2. DIMENSIONS "B" SHOULD BE CHECKED ON MANDREL φA.
3. THE COMPONENT MAY BE MANUFACTURED FROM STEEL 08K_n GOST 1050-74.
4. * DIMENSIONS SHOULD BE ENSURED BY TOOL.
5. #1 DIMENSIONS FOR REFERENCE.
6. IN TROPICAL DESIGN, COATING C.I.9, CHROMATIZING, AS PER UJ-569-84, REMOVING HYDROGEN EMBRITTLEMENT.

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

EST WT

0.01 Kg

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

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

MATERIAL

BAND 08ΠC-M-2-0-1x12
GOST 503-74 81 @

USED ON

C6 3342 221 C6

NATURE OF AMENDMENTS

SCALE: 1 : 1

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)
AVADI

DIMENSIONS IN mm

TOLERANCE ON DIMNS
UNLESS OTHERWISE
STATED



TITLE

CLAMP

ALL THREADS CONFORM TO

D S CAT NUMBER

DRAWING NUMBER

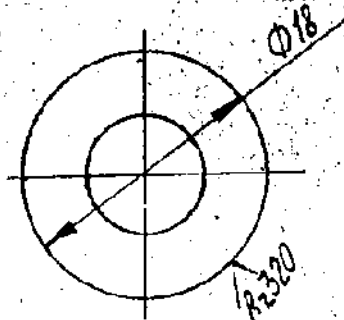
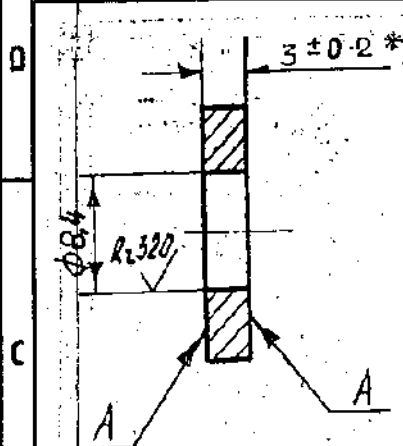
3342 246

DATE 26.06.86

SIZE A4

DRAWING NUMBER

3342 247



(B) EQUIVALENT MATERIAL
Gr. 0 IS:513-1994

1. INSPECTION GROUP V TT-11.
2. COATING: Zn 15, CHROMATIZING, AS PER INSTRUCTIONS U 483-82
3. DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE OBTAINED WITH ACCURACY OF $\pm 0.3\text{mm}$.
4. THE COMPONENT SHOULD BE STRAIGHTENED AFTER STAMPING.
5. THE COMPONENT MAY BE MANUFACTURED FROM THE ROUND BAR 18-5 GOST 7417-75, ROUGHNESS OF SURFACE A Rz 80.
6. *DIMENSION FOR REFERENCE.
7. IN TROPICAL DESIGN, COATING Cd, CHROMATIZING, AS PER U A-569-84, REMOVING HYDROGEN EMBRITTLEMENT

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

EST WT

0.0017 Kg

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

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

MATERIAL : SHEET

USED ON

STEEL 10

CB 3342 00 8 CB

GOST 1050-74

B 21.5.10. 4th Alt. Comm. Mt. Minutes Pt. No. 2 Dt. 26.10.09

A 16.3.70 AUTHY. No. BK 86 - 195.

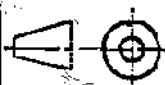
ISSUE DATE NATURE OF AMENDMENTS

DRN SCALE : 2 : 1

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)
AVADI

CHD DIMENSIONS IN mm

TOLERANCE ON DIMS
UNLESS OTHERWISE
STATED



TITLE

WASHER

APPD ALL THREADS CONFORM TO

D S CAT NUMBER

DRAWING NUMBER

DATE 20.1.86

3342 247

SIZE A4

DRAWING NUMBER
3342-251

EXPLANATORY NOTE

3. MATERIAL QUOTED :- 40 Y12 - 0.7 (7) TY 005 5046-80

GROUP No - 40

TYPE OF HOSE - Y

INTERNAL DIAMETER - 12mm

OPERATING PRESSURE - 0.7 MPa (7 Kgf/cm²)

FABRIC REINFORCED HOSE CONSISTING OF INTERNAL RUBBER LAYER
2 LAYERS OF DOMESTIC FABRIC TO GOST 1104-69 AND EXTERNAL RUBBER
LAYER. MINIMUM THICKNESS OF INTERNAL RUBBER LAYER SHOULD BE 15mm.

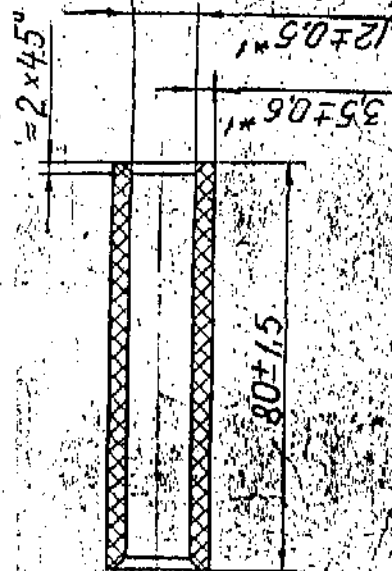
HOSE SHOULD BE SERVICEABLE IN ANY CLIMATIC CONDITIONS WITH
OPERATING PRESSURE MENTIONED ABOVE.

MINIMUM PERMISSIBLE RADIUS OF } - 144 mm
BENDING IN OPERATING CONDITIONS

MASS OF 1 METRE LENGTH OF HOSE - 0.260 Kg

RUBBER USED FOR INTERNAL AND EXTERNAL LAYERS OF HOSE SHOULD
BE IN COMPLIANCE WITH THE FOLLOWING PARAMETERS:

- a) CONDITIONAL TENSILE STRENGTH ----- 90 Kgf/cm² (min)
- b) ELONGATION OF RUPTURE % ----- 250 (min)
- c) HARDNESS MEASURED BY DEVICE TWM - 2 ----- 10±4 Kgf/cm²
- d) BRITTLENESS TEMPERATURE ----- Not above than minus 55°C

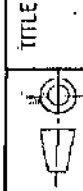


1. * Рубер-прокладочный концентрат
40472-40473-0056016-1200
2. * Разметка для отправки
1. * - WRAPPED HOSE 40Y12-0.7 (7) TY 0056016-80
2. * DIMENSIONS FOR REFERENCE

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

EST. WT. 0.016 Kg
TO BE STAMPED OR MARKED WHERE INDICATED THUS $\frac{H}{I}$ (LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R. OUT SIDE
INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

TITLE
HOSE



D S CAT NUMBER
0 S CAT NUMBER

DRAWING NUMBER
3342-251

USED ON
CB 3342-00-8 CB

MATERIAL -
NOTE No:1 ABOVE

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)
AVAGI

SCALE: 1:1
DIMENSIONS IN mm
TOLERANCE ON DIMNS
UNLESS OTHERWISE
STATED JS:2102-69
ALL THREADS TO
CONFORM TO

DATE: 26-06-86
APPROVED: [Signature]
CHECKED: [Signature]
DRAWN: [Signature]

ISSUE DATE
A 20.8.92
NATURE OF AMENDMENTS
At 20.8.92
At 20.8.92
At 20.8.92

3. MATERIAL QUOTED : 40 Y 12 - 0.7 (7) TO TY 0056016-80.

GROUP No: 40

TYPE OF HOSE - Y

INTERNAL DIAMETER - 12mm

OPERATING PRESSURE - 0.7 MPa (7 Kgf/mm²)

FABRIC REINFORCED HOSE CONSISTING OF INTERNAL RUBBER LAYER, 2 LAYERS OF DOMESTIC FABRIC TO GOST 1104-69, AND EXTERNAL RUBBER LAYER. MINIMUM THICKNESS OF INTERNAL RUBBER LAYER SHOULD BE 15mm.

HOSE SHOULD BE SERVICEABLE IN ANY CLIMATIC CONDITIONS WITH OPERATING PRESSURE MENTIONED ABOVE.

MINIMUM PERMISSIBLE RADIUS OF BENDING IN OPERATING CONDITIONS

MASS OF 1 METRE LENGTH OF HOSE	-	0.260 Kg
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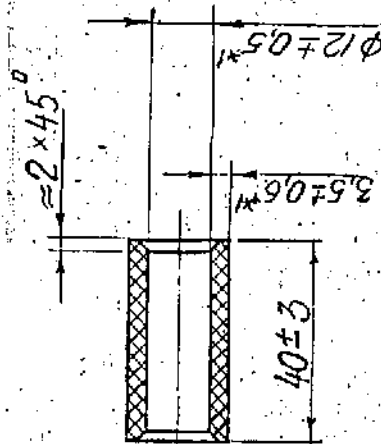
RUBBER USED FOR INTERNAL AND EXTERNAL LAYERS OF HOSE SHOULD BE IN COMPLIANCE WITH THE FOLLOWING PARAMETERS.

a) CONDITIONAL TENSILE STRENGTH - 90 Kgf/mm² (min)-

b) ELONGATION AT RUPTURE %		- 250 (min)	
1	100	100	100
2	100	100	100
3	100	100	100
4	100	100	100
5	100	100	100
6	100	100	100
7	100	100	100
8	100	100	100
9	100	100	100
10	100	100	100
11	100	100	100
12	100	100	100
13	100	100	100
14	100	100	100
15	100	100	100
16	100	100	100
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22	100	100	100
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81	100	100	100
82	100	100	100
83	100	100	100
84	100	100	100
85	100	100	100
86	100	100	100
87	100	100	100
88	100	100	100
89	100	100	100
90	100	100	100
91	100	100	100
92	100	100	100
93	100	100	100
94	100	100	100
95	100	100	100
96	100	100	100
97	10		

TABLE I
HARDNESS MEASURED BY
DEVICE TWM - 2

(H) BRITTLINESS TEMPERATURE



* Рукав прокладочный конструкт
40412-747474 38 0056016 - 2280
*1 Размеры для справки

WIRAPPE HOSE 40Y12-0.7 (7) TY 0056016-8D-

2.1 DIMENSIONS FOR REFERENCE.

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

EST. WT.	TO BE STAMPED OR MARKED	WHERE
008 K2	INDICATED THIS # -	LETTERS)

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

2

2

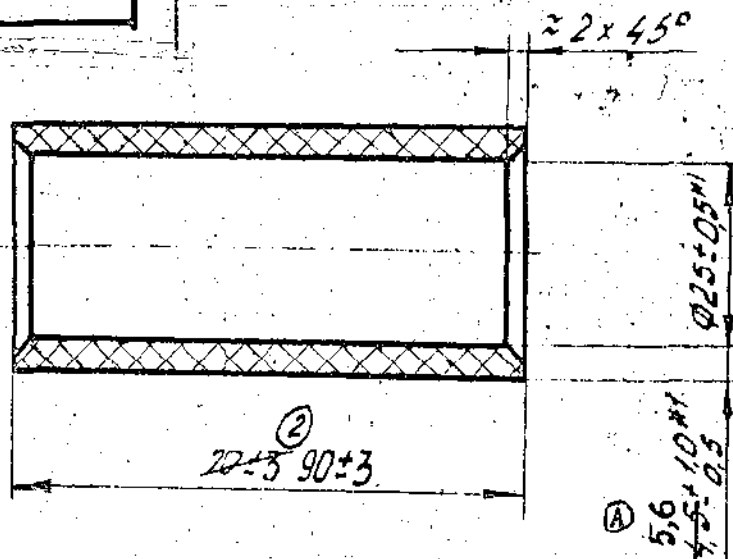
17

7

2

		DRN	MATERIAL :-	USED ON
		CND	SEE NOTE No: 1 ABOVE	CB 3342-00-8 [6]
		TCD		
		APPD		
		DATE		
		SCALE:- 1 : 1		
		DIMENSIONS IN mm		
		TOLERANCE ON DIMMS UNLESS OTHERWISE STATED IS 2702-69		
		FALL THREADS TO CONFORM TO		
ISSUE DATE	NATURE OF AMENDMENTS			

3342 253



1. *MANDREL-WRAPPED HOSE 40Y25-0.7 (7) TY 0056016-00.
2. THE FACES OF THE COMPONENT SHOULD BE COATED WITH ELASTOMETRIC ADHESIVE OF GRADE 23C-A TY 38-105290-75:81 THE COMPONENT SHOULD BE MARKED WITH YELLOW POINT.
3. *1 DIMENSIONS FOR REFERENCE.

A-10

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

EST WT
0.06 KgTO BE STAMPED OR MARKED WHERE
INDICATED THUS *
(LETTERS)ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS
OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-
SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

MATERIAL

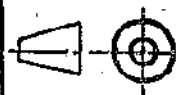
USED ON

HOSE *

CB 3342 00 0 CB

A 1110-89 AUTHY. BK 85-503.
ISSUE DATE NATURE OF AMENDMENTSSCALE: 1 : 1
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)
AVADI

DIMENSIONS IN mm

TOLERANCE ON DIMNS
UNLESS OTHERWISE
STATED

TITLE

HOSE

ALL THREADS CONFORM TO

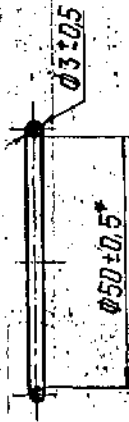
D S CAT NUMBER

DRAWING NUMBER

3342 253

DATE 20-6-86

DRAWING NUMBER
3342-254



EXPLANATORY NOTE :

- MATERIAL QUOTED : RUBBER 783-2-251231 TY 005216-75.
- CODE - 251231 - UNVULCANIZED OIL AND PETROL RESISTANT RUBBER.
- RUBBER GRADE : 783-2.
- OPERATING TEMPERATURE : -40 TO +80°C.
- WORKING MEDIUM - OIL & PETROL.
- DURING ENDUSE IT SHOULD WITHSTAND A PRESSURE UPTO - - 10 Kg/cm².

MECHANICAL PROPERTIES :

RUPTURE STRENGTH = 125 Kg/cm² (min)

ELONGATION AT RUPTURE = 250 % (min)

HARDNESS TO TYP DEVICE % = 65 - 80

DENSITY g/cm³ = 1.21 ± 0.05

- Размер обеспечивается инструментом.
- Маркировать на этикетке.
- В производстве использовать - ТУ 1100 ГОСТ 15152-69.
- Остальные требования по ТУ 005216-75.
- Допускается изготовление в соответствии с требованиями ГОСТ 1.32.

- *DIMENSIONS IS ENSURED BY TOOL.
- TO BE MARKED ON A TAG.
- TO BE MADE-AS PER T III H100, GOST 15152-69.
- THE REST OF THE REQUIREMENTS AS PER TY 005216-75.

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

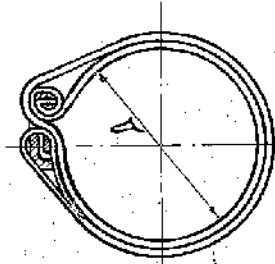
EST. WT. 0.014 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS () LETTERS)

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

DRN	783-2-251231	MATERIAL	TY 005216-75	USED ON	CB 3342-00-8 CB
CHD	783-2-251231				
TED	783-2-251231				
APPD	26-06-86				
DATE	26-06-86				
SCALE	1:1				
DIMENSIONS IN THE TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-65		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI			
ALL THREADS TO CONFORM TO		TITLE RING			
ISSUE DATE		D S EAT NUMBER		DRAWING NUMBER	
NATURE OF AMENDMENTS		3342-254			

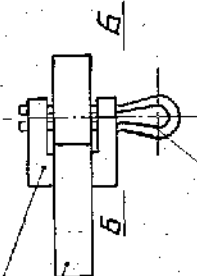
STANDARD ITEM LIST No.
N 233-59 SHT. 1.

A-A



CLAMP CLIP X P

CLAMP BAND X P C



SPLIT PIN

63x20 GOST 397-79

B-G

SCALE 2:1

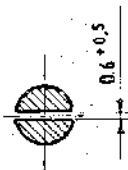


DIAGRAM OF BAND WINDING

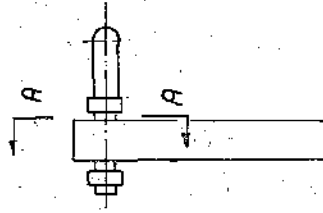
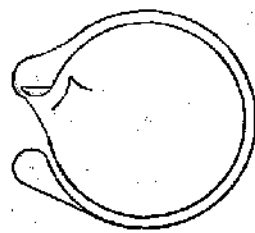


DIAGRAM OF SPLIT PIN ROTATION

DURING TIGHTENING



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

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

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

DRY	CHD	TCD	APPO	DATE	SCALE	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	ALL THREADS CONFORM TO	ISSUE	DATE	NATURE OF AMENDMENTS
MATERIAL						CONTROLLERATE OF INSPECTION HEAVY VEHICLES		TITLE		
USED ON						AVADI		UNIVERSAL CLAMP		
CB 3342 00 & 05								STANDARD ITEM LIST No.		
								N 233-59 SHT. 1 OF 3		

A-10

SIZE A3



NOMENCLATURE : ABBREVIATED "BAND"

FULL "BAND" 10-M-RT-3-0-0-529 GOST 503-71 OR
BAND 10-M-3-0-0-0-10 GOST 503-71

SYMBOL	Band length external dia.	Weight of 1 component, kg	USED ON
2M-175	0 175 10-12 0006	0 175 10-12 0006	
2M-200	0 200 13-16 0007	0 200 13-16 0007	
2M-225	0 225 17-20 0008	0 225 17-20 0008	
2M-250	0 250 21-24 0009	0 250 21-24 0009	
2M-275	0 275 25-28 0010	0 275 25-28 0010	
2M-300	0 300 29-32 0011	0 300 29-32 0011	
2M-325	0 325 33-36 0012	0 325 33-36 0012	
2M-350	0 350 37-40 0013	0 350 37-40 0013	
2M-375	0 375 41-44 0014	0 375 41-44 0014	
2M-400	0 400 45-48 0015	0 400 45-48 0015	
2M-425	0 425 49-52 0016	0 425 49-52 0016	
2M-450	0 450 53-56 0017	0 450 53-56 0017	
2M-475	0 475 57-60 0018	0 475 57-60 0018	
2M-500	0 500 61-64 0019	0 500 61-64 0019	

SYMBOL	Band length external dia.	Weight of 1 component, kg	USED ON
2M-500	0 500 61-64 0018	0 500 61-64 0018	
2M-525	0 525 65-68 0020	0 525 65-68 0020	
2M-550	0 550 69-72 0021	0 550 69-72 0021	
2M-575	0 575 73-76 0022	0 575 73-76 0022	
2M-600	0 600 77-80 0023	0 600 77-80 0023	
2M-625	0 625 81-84 0024	0 625 81-84 0024	
2M-650	0 650 85-88 0025	0 650 85-88 0025	
2M-675	0 675 89-92 0026	0 675 89-92 0026	
2M-700	0 700 93-96 0027	0 700 93-96 0027	
2M-725	0 725 97-100 0028	0 725 97-100 0028	
2M-750	0 750 101-104 0029	0 750 101-104 0029	
2M-775	0 775 105-108 0030	0 775 105-108 0030	
2M-800	0 800 109-112 0031	0 800 109-112 0031	

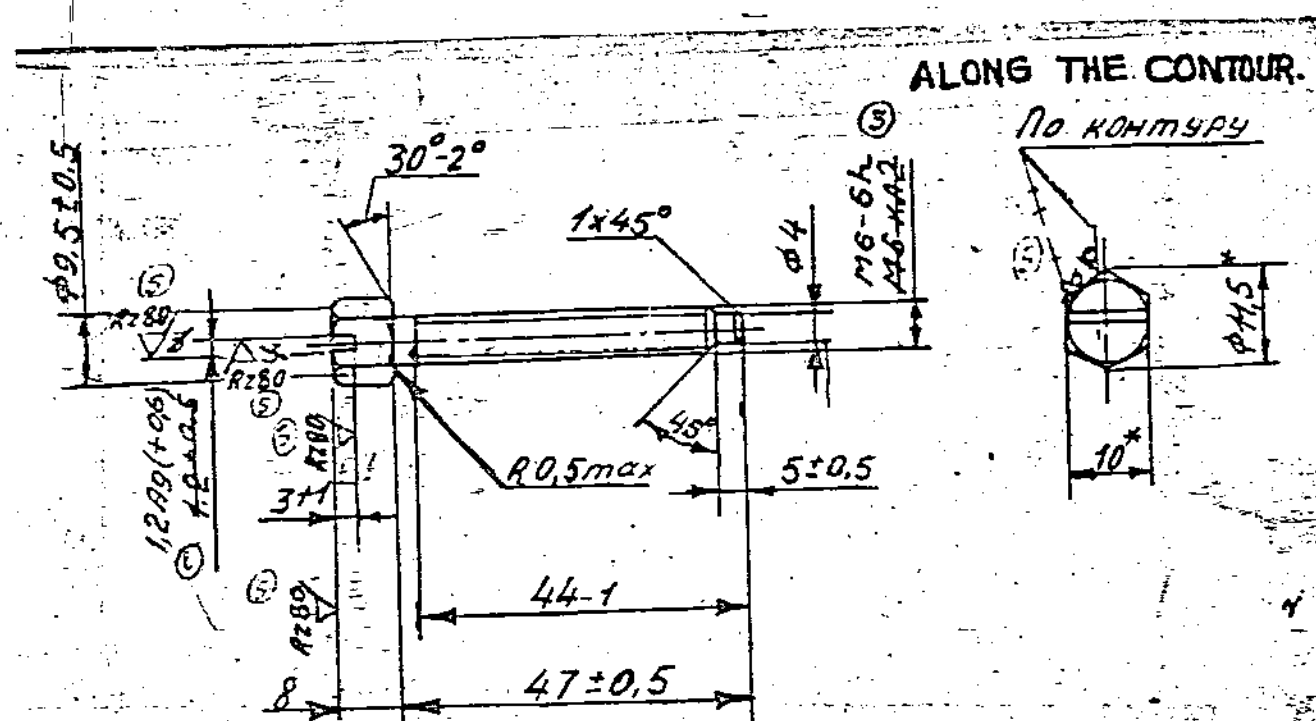
1. MATERIAL: 10 GOST 1050-74.
ALTERNATE MATERIAL: 08, 08G AND 10G GOST 1050-74 AND GOST 380-71.
CONTING: CR 4-5, CHROMIZING.
WITH ELIMINATION OF HYDROGEN ENRICHMENT.
2. FEATHER-EDGE SHAPING OF BAND SHOULD NOT EXCEED 3 PER CENTRE LENGTH.
3. THE FOLLOWING DEVIATIONS ARE ALLOWED ON THE LENGTH OF THE BAND:
UP TO 500 ± 5
ABOVE 500 ± 10
4. THE LENGTH OF THE BAND SHOULD BE CALCULATED WITH THE FORMULA:
 $L = 2\pi R + 100$ WHERE R EXTERNAL DIAMETER OF HOSE.
5. THE LENGTH OF BANDS ABOVE 800 IS NOT SPECIFIED, BUT IT SHOULD HAVE ZERO AT THE END.
6. BANDS MORE THAN 800 LONG SHOULD BE DELIVERED TO ASSEMBLY COILED AS A CIRCLE WITH INNER DIAMETER NOT LESS THAN 150.
7. THE BAND MAY BE MANUFACTURED FROM THE SHEET MATERIAL. IN THIS CASE, CUTTINGS, SURFACE RUFFLES AND TINS ARE NOT ALLOWED.
8. THE REST OF THE SPECIFICATIONS AS PER GOST 503-71.
9. TO BE ENTERED IN THE DRAWINGS AS PER STANDARD No. 0.

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

TO BE STAMPED OR MARKED WHERE
INDICATED THIS " " (LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED INPRESS
OTHERWISE STATED MAXIMUM CORNERS TO HAVE R CUT-
SIDE R. INSIDE EQUIVALENT DIAMETERS ARE PERMISSIBLE.

2533 04	2533 04	2533 04	2533 04
SEE NOTE NO. 1 ABOVE	SEE NOTE NO. 1 ABOVE	SEE NOTE NO. 1 ABOVE	SEE NOTE NO. 1 ABOVE
DATE	DATE	DATE	DATE
SCALE	SCALE	SCALE	SCALE
UNLESS OTHERWISE STATED	UNLESS OTHERWISE STATED	UNLESS OTHERWISE STATED	UNLESS OTHERWISE STATED
ALL DIMENSIONS	ALL DIMENSIONS	ALL DIMENSIONS	ALL DIMENSIONS
CONFORM TO	CONFORM TO	CONFORM TO	CONFORM TO
ISSUE	DATE	NATURE OF IMPROVEMENTS	ISSUE
UNIVERSAL CLAMP			STANDARD ITEM LIST No. N 233-59 SHT 2 OF 2



14. MATERIAL QUOTED : 10-5 GOST 8560-78
45 GOST 1051-73

ALTERNATE MATERIAL QUOTED : STEEL GRADES 40 & 50 TO GOST 1050-74.

10.5 GOST 8560-78

40 GOST 1051-73

10 = ACCROSS FLATS OF HEXAGONAL BAR.

5 = CLASS OF ACCURACY.

40,45,50= GRADE OF STEEL : BRIGHT STEEL.

a) CHEMICAL COMPOSITION :- AS PER GOST 1050-74.

GRADE OF STEEL	C O N T E N T O F E L E M E N T S %							
	C	Si	Mn	Cr	S	P	Ni	Cu
40	0.37-0.45	0.17-0.37	0.50-0.80	M	A	X	I	M
				0.25	0.040	0.035	0.10	0.15
45	0.42-0.50	0.17-0.37	0.50-0.80	0.25	0.040	0.035	0.10	0.15
50	0.47-0.55	0.17-0.37	0.50-0.80	0.25	0.040	0.035	0.10	0.15

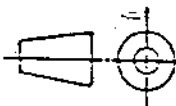
b) MECHANICAL PROPERTIES :- AS PER GOST 1050-74.

GRADE OF STEEL	YIELD POINT Kgf/mm ²	RELATIVE ELONGATION %	REDUCTION OF AREA %	IMPACT STRENGTH Kgf/mm ²	ULTIMATE TENSILE STRENGTH Kgf/cm ²	HARDNESS B H N
	M I N I M U M					MAX
40	34	19	45	6	58	217
45	36	16	40	5	61	229
50	38	14	40	4	64	241

(B) EQUIVALENT MATERIAL STEEL
45C8 TO IS:1570

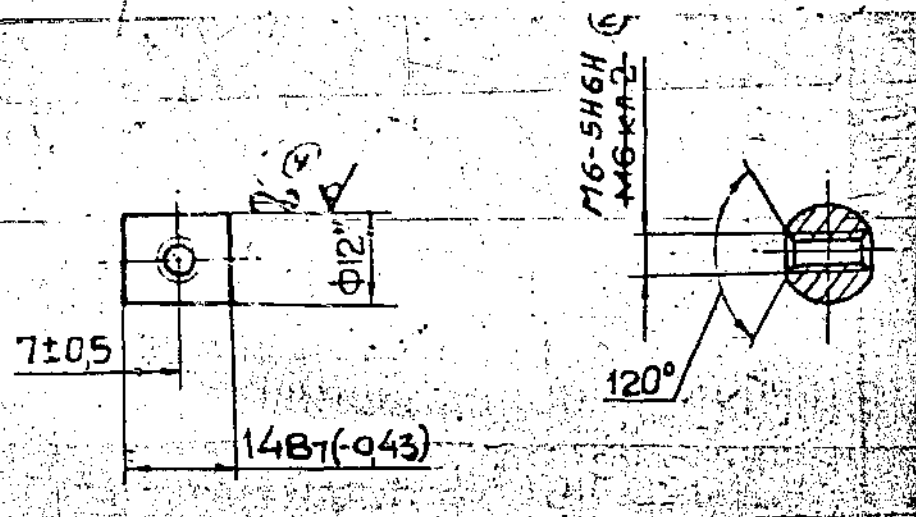
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE
BULK PRODUCTION.

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

			DRN	<i>Graph A.</i>	MATERIAL :-	10-5 GOST 8560-78	USED ON :-	
			CHD	<i>Khil</i>	HEXAGON BAR	45 GOST 1051-73	CB 3321-05-3 4	(A)
			TCD	<i>Narain Puri</i>			CB 421-18-2	
			APPD	<i>22</i>	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)			
			DATE	26-06-86	A V A D I			
			SCALE :-	1 : 1				
			DIMENSIONS IN mm.					
			TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69		BOLT CLAMP			
B	12-8-10	4 th Alt. Comm. Meeting Minutes	Point No. 11 Dt: 26-10-09		D S CAT NUMBER		DRAWING NUMBER	
A		AUTHY NOTN BK 85-361	ALL THREADS TO CONFORM TO					
ISSUE	DATE	NATURE OF AMENDMENTS				321-17-3		

DRAWING NUMBER

321-18-2



2. SHIFT OF THREAD AXIS RELATIVE TO THE BAR AXIS SHOULD NOT EXCEED 0.3 mm.

4. * DIMENSION FOR REFERENCE.

5. THE COMPONENT MAY BE MANUFACTURED FROM ROUND BAR

12.5 GOST 7417-75

40 GOST 1051-73

6. COATING : Cd 9, CHROMATIZING IN ACCORDANCE WITH U.S. 103 WITH SUBSEQUENT ELIMINATION OF HYDROGEN EMBRITTLEMENT.

EXPLANATORY NOTE :-

Rz40

7. MATERIAL QUOTED : 12.5 GOST 7417-75
45 GOST 1050-74

(B)

ALTERNATE MATERIAL QUOTED : ROUND BAR 12.5 GOST 7417-75
40 GOST 1051-73

STEEL ROUND SIZED 12.5 DIAMETER.

GRADE OF STEEL = 45 & 40 TO GOST 1050-74.

a) CHEMICAL COMPOSITION :- AS PER GOST 1050-74.

ELEMENTS %	45	40
CARBON	0.42 - 0.50	0.37 - 0.45
SILICON	0.17 - 0.37	0.17 - 0.37
MANGANESE	0.50 - 0.80	0.50 - 0.80
CHROMIUM	0.25 (max)	0.25 (max)
SULPHUR	0.040 (max)	0.040 (max)
PHOSPHORUS	0.035 (max)	0.035 (max)
NICKEL	0.10 (max)	0.10 (max)
COPPER	0.15 (max)	0.15 (max)

b) MECHANICAL PROPERTIES :-

	45	40
YIELD POINT Kgf/mm ²	36 (min)	34 (min)
ULTIMATE TENSILE STRENGTH Kgf/mm ²	61 (min)	58 (min)
ELONGATION %	16 (min)	19 (min)
REDUCTION OF AREA %	40 (min)	45 (min)
IMPACT STRENGTH Kgf/mm ²	5 (min)	6 (min)

(B)

Material: STEEL 709M40 (EN-19) TO BS-970 Pt-1-1983

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

EST. WT. 0.009 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTERS)

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

GRN	GRN	MATERIAL:-	USED ON
CHN	CHN	12.5 GOST 7417-75	CB 3321-05-2 CB
TED	TED	45 GOST 1051-73	
APPD	APPD		
DATE	30-06-86	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE:-	1:1	AVADI	
DIMENSIONS IN mm		TITLE	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69		NUT CLAMP	
ALL THREADS TO CONFORM TO		D S CAT NUMBER	
ISSUE DATE	NATURE OF AMENDMENTS	DRAWING NUMBER	
		321-18-2	

A
7

SIZE A3

DRAWING NUMBER
353-04-2

Rz80 ✓ ✓ φ

EXPLANATORY NOTE :-

10, MATERIAL QUOTED STRIP 10-BH-2-1.5
GOST 503-81

ALTERNATE MATERIAL QUOTED : STEEL GRADE 15 TO GOST 1050-74.
STRIP = COLD ROLLED STRIP (LOW CARBON) WITH TRIMMED EDGES.

10 & 15 = GRADE OF STEEL.

B H = HIGHLY COLD WORKED.

2 = GROUP OF SURFACE QUALITY. 15 = THICKNESS.

a) CHEMICAL COMPOSITION :-

GRADE OF STEEL	C O N T E N T O F E L E M E N T S %							
	C	Si	Mn	Cr	P	S	Cu	Ni
10	0.07-0.14	0.17-0.37	0.35-0.65	M A X I M U M				
				0.15	0.035	0.040	0.25	0.25
15	0.12-0.19	0.17-0.37	0.35-0.65	0.15	0.035	0.040	0.25	0.25

b) MECHANICAL PROPERTIES :- TO GRADE 10 AS PER GOST 503-81.

ULTIMATE TENSILE STRENGTH Kgf/mm² (min) = 55

c) MECHANICAL PROPERTIES :- TO GRADE 15 AS PER GOST 1050-74.

TENSILE STRENGTH Kgf/mm ²	YIELD POINT Kgf/mm ²	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH Kgf/cm ²
M I N I M U M				
38	23	27	55	

- 1.
2. DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE OBTAINED WITH ACCURACY $\pm 0.3\text{mm}$.
3. THE COMPONENT SHOULD BE STRAIGHTENED AFTER STAMPING.
4. BURRS ARE NOT ALLOWED.
5. COATING : Zn 15, Cr AS PER U/A- 483 - 82 WITH HYDROGEN EMBRITTLEMENT REMOVAL.
6. COATING WITH ZINC BY THERMAL DIFFUSION METHOD IS ALLOWED AS PER U U. (-1181.
7. COATING :- CADMIUM 9, CHROMATIZING AS PER U U. (-104 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
8. ALTERNATE MATERIAL : STEEL GRADE 15, GOST 1050-74.
9. REQUIRED FINISHING OF SURFACES BEING STAMPED SHOULD BE ENSURED BY TOOL.

EQUIVALENT-MATERIAL
Gr. 0 IS:513-1994

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

EST. WT. 0.0009 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTERS)

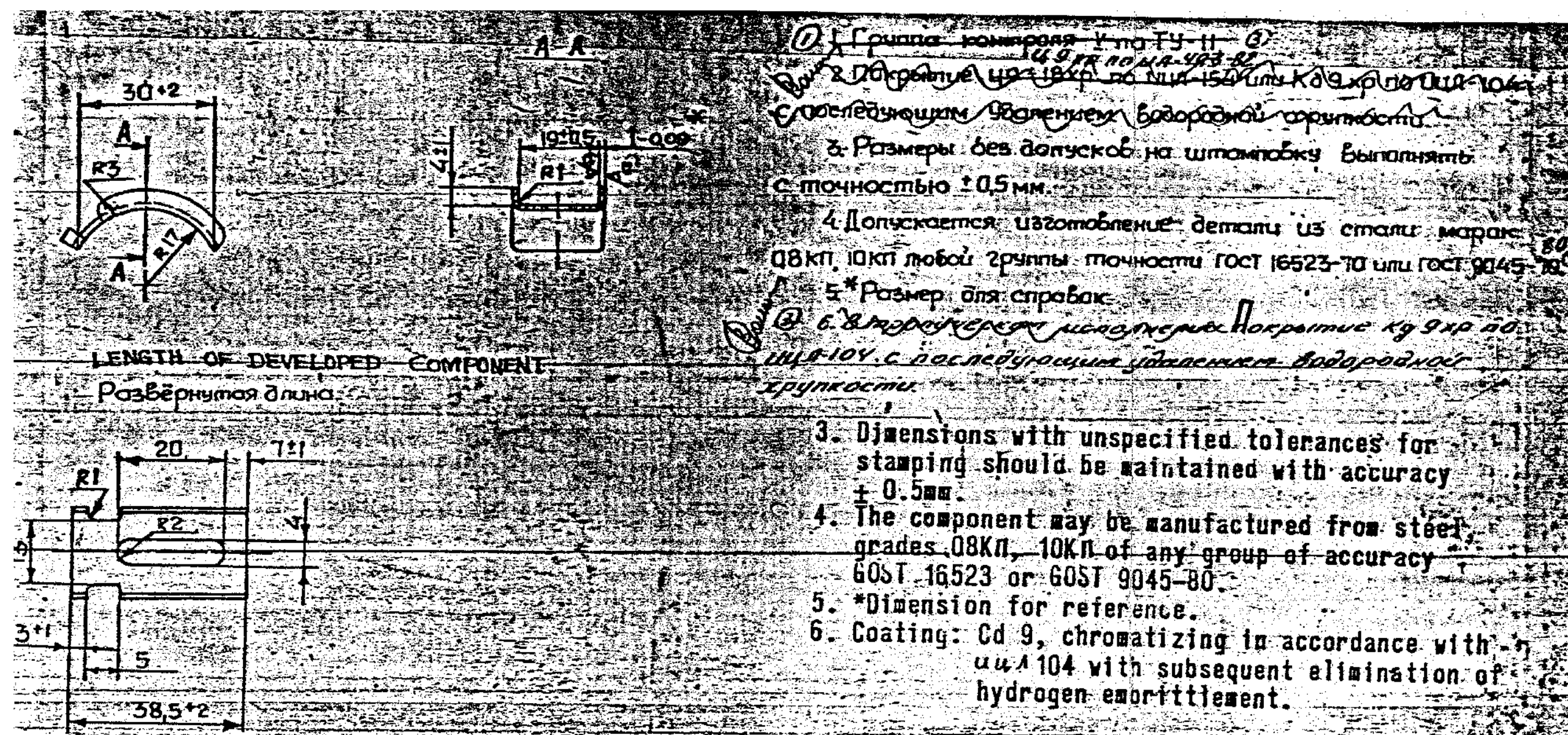
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE
INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	Approved	MATERIAL:-	USED ON C5 3321-05-34 C6
EN	Approved	STRIP 10-BH-2-1.5	C5 3338-401-10
TD	Approved	GOST 503-81	
APPD	Approved		
DATE	02-05-87	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES)	
SCALE:-	2 : 1	AVAD	
DIMENSIONS IN mm		TITLE	
TOLERANCE ON DIMS			
UNLESS OTHERWISE			
STATED IS:2102-69			
ALL THREADS TO		D S CAT NUMBER	DRAWING NUMBER
CONFORM TO			353-04-2
ISSUE DATE	NATURE OF AMENDMENTS		

KVD No.- 78673

A
11

SIZE A3



EXPLANATORY NOTE

7. MATERIAL QUOTED : 08nc-M-2-0-1
 GOST 503-81

ALTERNATE MATERIAL QUOTED : STEEL GRADES 08Kp, 10Kp OF ANY GROUP OF ACCURACY TO GOST 16523 OR 9045-80.

08nc = STEEL GRADE - SEMI-KILLED - LOW CARBON STEEL

M = SOFT

2 = GROUP OF SURFACE QUALITY.

1 = { THICKNESS.
 WITH TRIMMED EDGES.

a) CHEMICAL COMPOSITION :- AS PER GOST 1050-74.

GRADE OF STEEL	C O N T E N T O F E L E M E N T S %							
	C	Si	Mn	Cr	S	Ph	Cu	Ni
08nc	0.05-0.11	0.06-0.17	0.35-0.60	0.10	0.040	0.035	0.25	0.25
08Kp	0.05-0.11	0.03 (max)	0.25-0.50	0.10	0.040	0.035	0.25	0.25
10Kp	0.07-0.14	0.07-max	0.25-0.50	0.15	0.040	0.035	0.25	0.25

b) MECHANICAL PROPERTIES :- AS PER GOST 503-81

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	RELATIVE ELONGATION % (minimum)
08nc	32 - 45	17
08Kp	32 - 45	17
10Kp	32 - 45	17

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

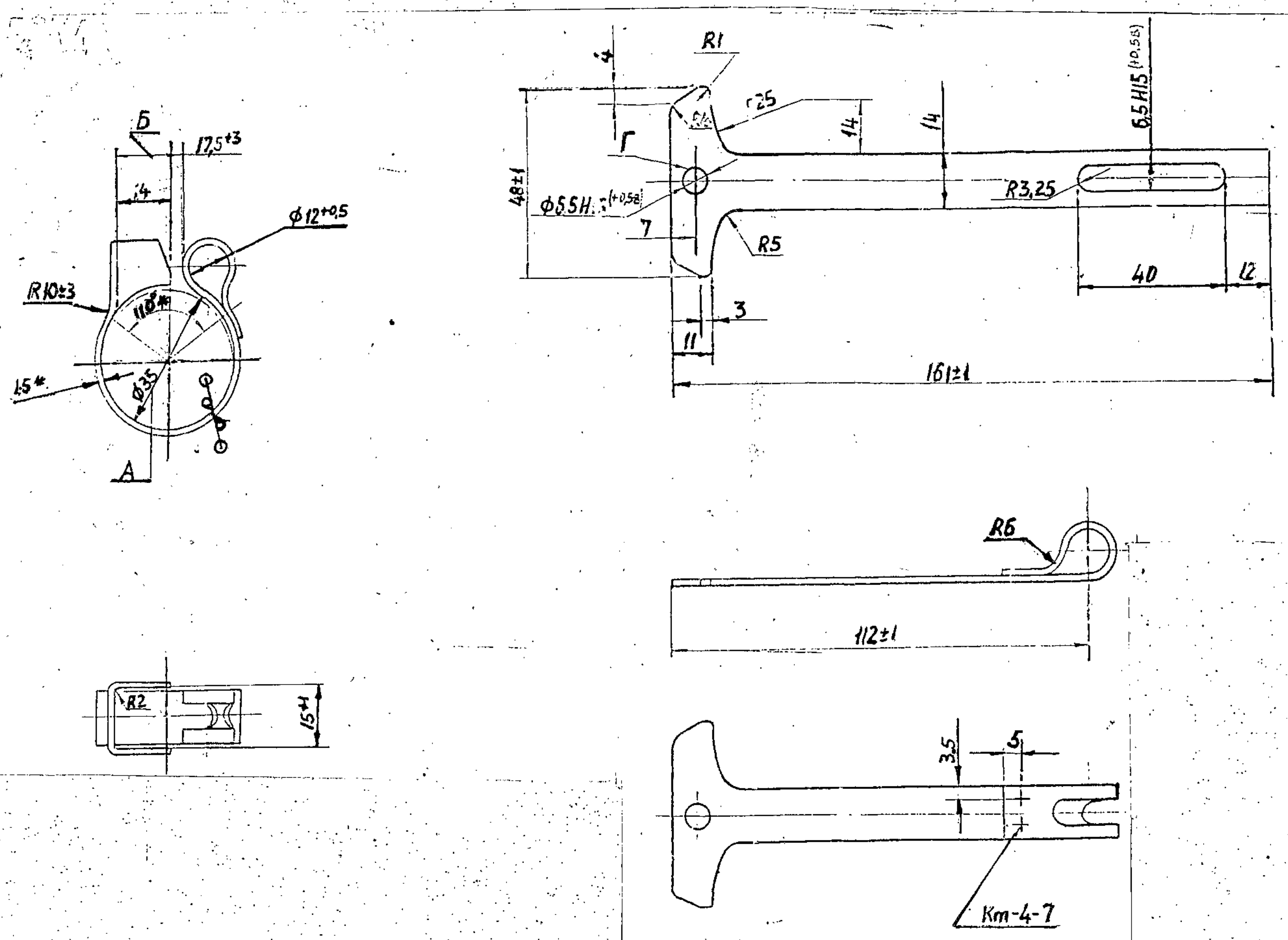
EST. WT. TO BE STAMPED OR MARKED WHERE INDICATED THUS #
 (LETTERS)

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

DRN	CHD	TCD	APPR	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2:12-59	ALL THREADS TO CONFORM TO	ISSUE	DATE	NATURE OF AMENDMENTS
				26-06-86							
MATERIAL :- STRIP 08nc-M-2-0-1 GOST 503-81						USED CN :- CB 3321-05-3 CB					
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)						A V A O I					
TITLE						GUIDE CLAMP BAND					
D S CAT NUMBER						DRAWING NUMBER					
						421-48-1					

DRAWING NUMBER
3321-08-3

DEVELOPED VIEW



1. ALTERNATIVE MATERIAL: SHEET I OR II GROUP OF SURFACE FINISH
2. COMPONENT IS SUBJECTED TO HIGH TEMPERING
3. UNSPECIFIED TOLERANCES ON DIMENSIONS: $\pm 0.5 \text{ mm}$
4. DIMENSIONS A AND B ARE TO BE CHECKED ON THE MANDREL $\phi 35 \text{ mm}$ WITH CONSIDERATION OF PLATE 1 mm THICK ALONG AN ARC OF 110° AS SHOWN IN DOTTED LINE.
5. EXPANSION OF HOLE F DURING BENDING IS ALLOWED, IF SO, THE BOLT BS SHOULD FREELY PASS THROUGH THE HOLE
6. FISSURES, CRACKS AND BULGES NOT ALLOWED.
7. COATING: Zn6, CY AS PER UA-483-32 OR Cd9, CY AS PER UA 569-84 WITH SUBSEQUENT REMOVAL OF HYDROGEN BRITTLENESS
8. COATING: Cd9, CY AS PER UA 569-84 WITH SUBSEQUENT REMOVAL OF HYDROGEN BRITTLENESS FOR TROPICALIZED MAKE
9. * DIMENSIONS FOR REFERENCE

(B) EQUIVALENT MATERIAL
Gr. D IS-513-1994.

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

EST. WT.
0.03 Kg

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

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

DRN	CHD	TCD	APPD	DATE	SCALE	DIMENSIONS	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2:02 - 69	ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
				02 JAN 99	1:1	mm				3321-08-3
MATERIAL: SHEET I OR II GROUP OF SURFACE FINISH					USED ON: 3321-05-408					
MATERIAL: SHEET I OR II GROUP OF SURFACE FINISH					CONTROL RATE OF QUALITY ASSURANCE (HEAVY VIBRATES) A V A C I					
MATERIAL: SHEET I OR II GROUP OF SURFACE FINISH					CLIP STRIP					
MATERIAL: SHEET I OR II GROUP OF SURFACE FINISH					D S CAT NUMBER					
MATERIAL: SHEET I OR II GROUP OF SURFACE FINISH					DRAWING NUMBER					

SIZE A2

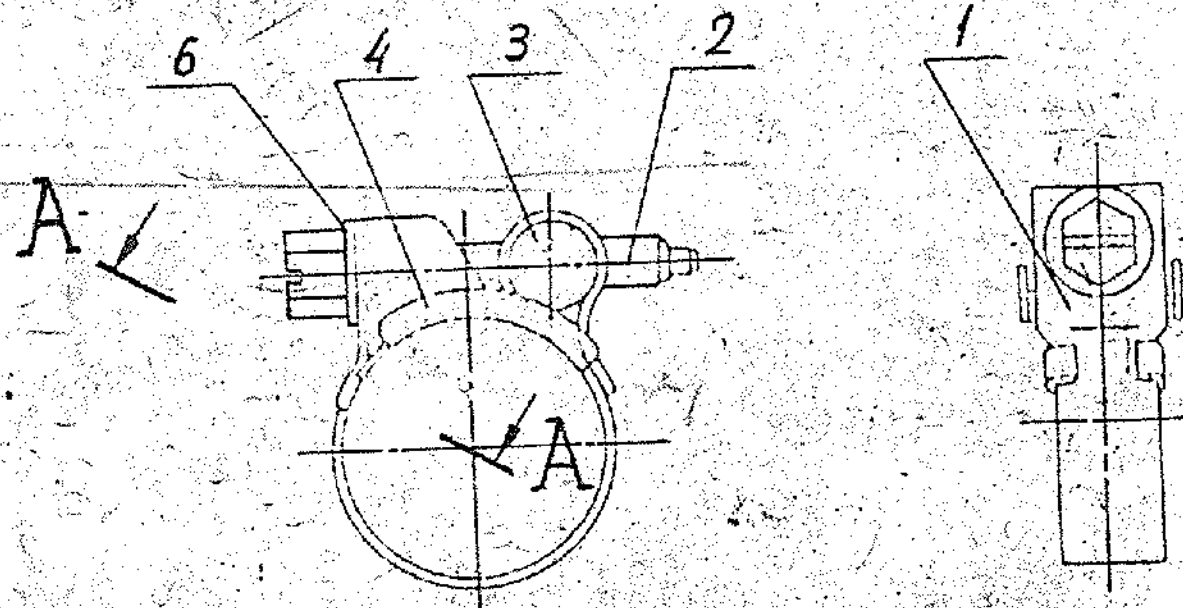
KVD No: 78239

DRG SUPERSEDED BY CB 3321-05-4 CB VIDE NOTN No BK-85-361

DRAWING NUMBER

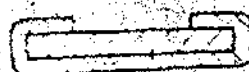
CB 3321-05-3 CB

ЕСКА



A-A TURNED
повернуто

SCALE 1:2



1. Загнутые крошки в сечении А-А должны обеспечивать свободное перемещение накладки, дет. поз 4, по ленте, дет. поз 1.
2. Детали, имеющие в спецификации данного чертежа, в графе "Примечание", условное обозначение "ТИ", должны иметь тропическое исполнение, предусмотренное рабочими чертежами, для сборочных единиц в тропическом исполнении.

1. BENT EDGES AS SHOWN IN SECTION A - A SHOULD ENSURE FREE MOVEMENT OF COVERPLATE 4, ALONG STRIP 1.
2. COMPONENTS MARKED WITH DESIGNATION "TI" IN COLUMN "REMARKS" OF THE PARTS LIST OF GIVEN DRAWING SHOULD BE OF TROPICALIZED CONSTRUCTION, AS SPECIFIED IN THE DRAWINGS FOR ASSEMBLY UNITS IN TROPICAL DESIGN.

1	Авт. BK 82-517	Авт. 1	1
2	Авт. 1	Авт. 1	1

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

EST. WT. 0.064 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTERS)

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

DRN	M. Amixato	MATERIAL	USED ON
CHD	Sh. P. P.		CB 3321-00-16
TCD	Navarin P.		
APPD	305		
DATE	29-3-88	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	AVADI
SCALE	1:1		
DIMENSIONS IN mm			
TOLERANCE ON DIMNS			
UNLESS OTHERWISE STATED IS 2102-69			
ALL THREADS TO CONFORM TO			
1A 20.12.09 5 th Alt. Comm. Mfg. Minutes Point No. 20			
ISSUE DATE	NATURE OF AMENDMENTS	D S CAT NUMBER	DRAWING NUMBER
			CB 3321-05-3 CB



TITLE
CLIP ASSY

D S CAT NUMBER

DRAWING NUMBER

CB 3321-05-3 CB

~~RECEIVED BY CG 3321 05 4 CG VIDE NOTN No. BK-85-361~~

[illegible]