

d	1	1,4	1,6	2	2,6	3	3,5	4	5	6	7	8	10
WEIGHT 1000 PIECES OF MFG HEADS AND POINTS kg.	0,008	0,013	0,021	0,037	0,084	0,124	0,165	0,268	0,576	0,993	1,531	2,257	4,275
WEIGHT OF 1000 PIECES OF RIVETS MADE FROM ALUMINIUM ALLOYS B65, A18 AND A19N, kg.													
NOMINAL	PML DEVS												
2		0,007	0,017										
3		0,009	0,021	0,030	0,048								
4		0,011	0,025	0,035	0,057	0,108							
5	+0,2	0,014	0,030	0,041	0,065	0,123	0,171						
6		0,016	0,034	0,046	0,075	0,138	0,191	0,274	0,380				
7		0,018	0,039	0,052	0,084	0,153	0,211	0,302	0,415				
8		0,020	0,043	0,058	0,089	0,168	0,231	0,328	0,451	0,772			
9		0,022	0,048	0,064	0,102	0,183	0,251	0,357	0,488	0,828			
10		0,025	0,052	0,069	0,111	0,198	0,272	0,384	0,522	0,884	1,36		
11			0,057	0,075	0,120	0,218	0,292	0,412	0,553	0,940	1,44		
12			0,061	0,081	0,129	0,228	0,312	0,439	0,594	0,998	1,52	2,00	
13				0,087	0,138	0,243	0,332	0,467	0,630	1,052	1,50	2,20	
14				0,093	0,147	0,258	0,352	0,494	0,668	1,108	1,58	2,31	3,30
15				0,100	0,156	0,273	0,372	0,521	0,702	1,164	1,77	2,42	3,44
16					0,165	0,288	0,392	0,549	0,738	1,220	1,85	2,53	3,59
17					0,208	0,413	0,576	0,774	1,276	1,93	2,63	3,79	
18					0,318	0,433	0,604	0,810	1,332	2,01	2,74	3,87	6,42
19					0,339	0,453	0,631	0,846	1,388	2,09	2,85	4,02	6,64
20	+0,3				0,348	0,473	0,658	0,882	1,444	2,17	2,90	4,18	6,87
22						0,513	0,713	0,954	1,558	2,33	3,17	4,45	7,31
24						0,558	0,788	1,028	1,668	2,49	3,30	4,73	7,76
26							0,823	1,088	1,780	2,65	3,61	5,02	8,21
28							0,878	1,170	1,882	2,81	3,82	5,31	8,66
30								1,240	2,004	2,97	4,04	5,59	8,10
32								1,312	2,116	3,13	4,23	5,88	8,55
34									2,228	3,30	4,47	6,17	10,00
36									2,340	3,46	4,60	6,45	10,15
38									2,452	3,62	4,80	6,74	10,80
40									2,564	3,78	5,12	7,03	11,34
42										5,33	7,91	11,78	
44										5,55	7,80	12,24	
46										5,77	7,89	12,58	
48	+0,4										8,17	13,13	
50											8,46	13,58	
52												14,03	
54												14,47	
56												14,82	
58												15,37	
60												15,82	

IF NECESSARY IT IS ALLOWED TO USE THE RIVET
LENGTH GIVEN BEYOND THE LIMITS OF HEAVY
LINES: IN THE CASE RIVETS WHOSE LENGTH IS
ABOVE 60-MM SHOULD BE TAKEN AT INTERVALS
OF 2 MM.

FOR DETERMINING WEIGHT OF RIVETS MADE FROM OTHER MATERIALS, WEIGHT
INDICATED IN TABLE SHOULD BE MULTIPLIED BY CO-EFFICIENTS.

FOR AL 5N - 0.93

FOR BRASS - 3.00

FOR AL 4 AND AL 3 - 1.06

FOR COPPER - 3.13

FOR STEEL - 2.76

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

		EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED. THUS Φ	
		(LETTERS)		
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MATCHED CORNERS TO HAVE R OUT- SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL	USED ON:-	
DRN 8/1/80	SCALE -			
CHKD 8/1/80	DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
YES 8/1/80	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: BUTTON HEAD RIVETS		
APPD 8/1/80	ALL THREADS CONFORM TO	D S CAT NUMBER		
25/7/80		DRAWING NUMBER 3515 A TO 3525 A		

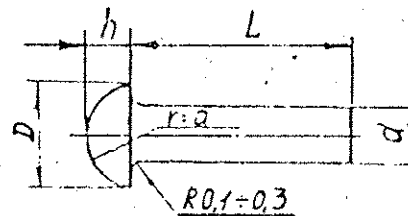


TABLE 1.

MATERIAL		SHEAR STRENGTH [sh.kgf/mm ² NOT LESS THAN	TENTATIVE DIAMETERS OF RIVETS	COATING	EXAMPLE OF DESIGNATION OF RIVET WITH LEXENDIG- MS d=4 AND l=12mm
ALUMINIUM ALLOYS.	B65	25 ³⁾	FROM 2,6 TO 10	ANODIC OXIDATION	3515A-4-12
	AMc5Π	16	FROM 2 TO 10		3516A-4-12
	A18	19	FROM 1,6 TO 6		3517A-4-12
	A19Π	28 ²⁾	FROM 2,6 TO 8		3518A-4-12
	AA1	-	FROM 1 TO 6		3519A-4-12
	AMU	-	FROM 2 TO 6	WITHOUT COATING	3520A-4-12
STEEL	Б5; 10	34	FROM 1 TO 10	ZINC-PLATING	3521A-4-12
	20Г2	50 ⁴⁾	FROM 3,5 TO 10		3522A-4-12
	12X18H9T	44	FROM 2 TO 6	WITH OUT COATING	3523A-4-12
BRASS Л63		-	FROM 1 TO 4	PASSIVATION	3524A-4-12
BRASS Л63 ANTI-MAGNETIC		-	FROM 1 TO 4		3524A ANT.-4-12
COPPER M2		-	FROM 1 TO 4		3525A-4-12

TABLE 2.

d	NOMINAL	1	1,4	1,6	2	2,6	3	3,5	4	5	6	7	8	10
	PERMISSIBLE DEVIATION	+0,1										+0,15		
D	NOMINAL	1,8	2,6	2,9	3,6	4,7	5,4	6,3	7,1	8	10,8	12,6	14,4	18
	PERMISSIBLE DEVIATION	+0,2					+0,3		+0,4		+0,5		+0,6	
h	NOMINAL	0,7	0,9	1	1,2	1,6	1,8	2	2,3	2,7	3,4	4	5,6	5,8
	PERMISSIBLE DEVIATION	+0,1					+0,15		+0,2		+0,25		+0,3	
MISALIGNMENT HEAD AXIS WITH RESPECT TO AXIS OF ROD		0,1					0,12		0,15		0,2		0,3	

- MARKING IS AS PER- 177AT.
- TECHNICAL SPECIFICATIONS ARE AS PER 104ATY, FOR RIVET MADE FROM A19 Π - AS PER 93 ATY 57.
- LENGTH DIMENSIONS OF POINTS AND DIAMETERS OF HOLES FOR RIVETS ARE AS PER 179 AT.
- OTHER TYPES OF COATINGS ARE USED IN COMPLIANCE WITH DESIGNER'S INSTRUCTIONS (SEE 104 ATY).
- FOR RIVET $d > 8$ AND $10 \text{ mm} \leq \text{sh} \leq 24,5 \text{ kgf/cm}^2$.
- FOR RIVETS $d > 6 \text{ mm}$ $\text{sh} = 27 \text{ kgf/cm}^2$.
- MAX. VALUE OF $\text{sh} = 6,3 \text{ kgf/cm}^2$.

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

		EST. MASS.	TO BE STAMPED ON MARKED WHERE LOCATED, 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		
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL:	USED ON:
DRN	8/1/80	SCALE -	SEE ABOVE	AK 150C - OICE
CPD	8/1/80	DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD	
TLD	8/1/80	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	TITLE: BUTTON HEAD RIVETS	
APPD	8/1/80	ALL THREADS CONFORM TO	B S CAY NUMBER	DRAWING NUMBER 3515A TO 3525A

DRG.NO: 3531AT03541A.

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SHEETS 2

SHEET. 2.

RANGE OF SIZES AND WEIGHT.

TABLE 3

d	1	1,4	1,6	2	2,6	3	3,5	4	5	6	7	8	10
WEIGHT OF 1000 PCS SNAP HEADS, kg.	0,009	0,005	0,006	0,018	0,037	0,054	0,088	0,129	0,252	0,406	0,510	0,963	1,881

L	STANDARD	WEIGHT OF 1000 PIECES OF RIVETS MADE OF ALUMINIUM ALLOYS B65, B18, AND A19, kg.
2		0006 0013
3		0008 0018 0022 0048
4		0010 0022 0027 0057 0079
5	+0,2	0013 0027 0033 0066 0084 0125
6		0015 0031 0039 0074 0109 0145 0203 0279
7		0017 0038 0045 0084 0124 0165 0230 0309
8		0018 0040 0050 0092 0139 0185 0257 0345 0581
9		0022 0045 0058 0101 0154 0205 0284 0381 0517
10		0024 0049 0062 0110 0166 0225 0311 0417 0673 100
11		0054 0067 0118 0184 0246 0338 0453 0729 108
12		0058 0079 0128 0199 0268 0365 0489 0785 116 136
13		0078 0137 0214 0288 0392 0525 0847 124 200
14		0084 0146 0229 0308 0429 0581 0887 139 211 247
15		0089 0155 0245 0326 0458 0597 0853 141 222 281
16		0164 0260 0348 0483 0633 1009 149 239 275
17	+0,3	0275 0366 0510 0669 1085 157 244 289
18		0280 0386 0537 0705 1121 185 255 304 499
19		0305 0407 0564 0741 1177 173 296 318 528
20		0310 0427 0591 0777 1232 181 277 332 544
22		0467 0645 0848 1344 197 299 361 589
24		0507 0699 0919 1456 213 320 388 634
26		0753 0990 1588 229 342 418 678
28		0807 1061 1680 245 384 446 723
30		1132 1782 281 388 475 788
32		1203 1904 277 408 504 812
34		2015 294 430 532 857
36		2128 310 452 561 892
38		2240 326 474 589 917
40		2352 342 498 618 942
42		517 617 1036
44	+0,4	539 675 1081
46		581 704 1128
48		792 1170
50		781 1213
52		1260
54		1305
56		1349
58		1394
		1439

IF NECESSARY RIVETS WITH LENGTHS OUTSIDE THE HEAVY LINES MAY BE USED WITH RIVETS LENGTH OVER 60 MM SHOULD BE TAKEN AT A 2 MM INTERVAL.

TITLE: FLAT-TOP COUNTERSUNK-HEAD RIVETS WITH 90°

FOR DETERMINING THE WEIGHT OF RIVET MADE OF OTHER MATERIALS MULTIPLY THE WEIGHT INDICATED IN TABLE BY THE FOLLOWING:

FOR AMr 5H - 0.93

FOR AMu AND A.1 - 0.96

FOR STEEL - 2.76

FOR BRASS - 3.00

FOR COPPER - 3.13

DRAWING NUMBER
3531A TO 3541A

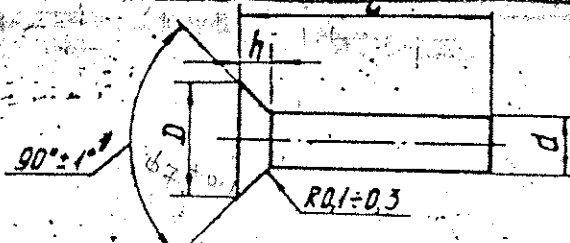


TABLE : 1

MATERIAL		SHEAR STR- ENGTH T_{sh} kgf/mm ² NOT LESS THAN	TENTATIVE DIAMETER OF RIVETS.	COATING	EXAMPLE OF DESIGNA- TION OF RIVETS WITH DIMENSIONS d=4 AND L=12 mm
ALUMINUM ALLOYS	B65	25 ⁴⁾	FROM 2.6 TO 10	ANODIC OXIDATION	3531A-4-12
	AM15 H	16	FROM 2 TO 10		3532A-4-12
	A 18	19	FROM 1.6 TO 6		3533A-4-12
	A 19 H	28 ³⁾	FROM 2.6 TO 8		3534A-4-12
	AA1	-	FROM 1 TO 6		3535A-4-12
	AMU	-	FROM 2 TO 6	WITHOUT COATING	3536A-4-12
STEEL	15: 10	34	FROM 1 TO 10	ZINC PLATING	3537A-4-12
	20 F2	50 ⁵⁾	FROM 3.5 TO 10		3538A-4-12
	12X18H9T	44	FROM 2 TO 6	WITHOUT COATING	3539A-4-12
BRASS A63		-	FROM 1 TO 4	PASSIVATION	3540A-4-12
BRASS A63 ANTIMAGNETIC		-	FROM 1 TO 4		3540AaHT-4-12
COPPER M2		-	FROM 1 TO 4		3541A-4-12

TABLE : 2

d	NOMINAL	1	1.4	1.6	2	2.6	3	3.5	4	5	6	7	8	10
	permissible deviation					+0.1						+ 0.15		
D	NOMINAL	1.9	2.7	2.9	3.9	4.6	5.2	6.1	7	8.8	10.3	12.2	13.9	17.3
	permissible deviation					± 0.1						± 0.2		± 0.3
h reference		0.5	0.7	1	1.1	1.2	1.4	1.6	2	2.4	2.8	3.2	4	

- 1 MARKING IS AS PER 177 AT.
- 2 TECHNICAL SPECIFICATIONS ARE AS PER 104 ATY, FOR RIVETS MADE FROM A 19H - AS PER 93 ATY 57.
- 3 LENGTH, DIMENSIONS OF POINTS AND DIAMETERS OF HOLES FOR RIVETS ARE AS PER 179 AT.

- 1 DIMENSION IS PROVIDED WITH TOOL.
- 2 OTHER TYPES OF COATING ARE USED IN COMPLIANCE WITH DESIGNER'S INSTRUCTIONS (SEE 104 ATY)
- 3 FOR RIVET $d > 6$ mm - $T_{sh} = 27$ kgf/mm²,
- 4 FOR RIVET $d = 8$ AND 10 mm - $T_{sh} = 24.5$ kgf/mm²,
- 5 MAX. VALUE OF $T_{sh} = 63$ kgf/mm².

SHEET 1 OF 2.

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

		EST. MASS.	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.	
ISSUE DATE	NATURE OF AMENDMENTS		
DRN	SCALE -	MATERIAL:-	USED ON:-
CHD	DIMENSIONS IN mm	SEE TABLE 1.	AK 150C 50 CB AK 150C 51 CB
TCD	TOLERANCE DIMNS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APPO		TITLE: FLAT-TOP COUNTERSUNK-HEAD RIVETS WITH 90°	
DATE	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
22.7.86.			3531A TO 3541A

1. MATERIAL:

STEEL, GRADE 45: 38 X A AND 30 X FCA:
ALUMINIUM ALLOY GRADES А1Т AND А1 П
BRASS GRADES А63ПТ AND АС59-1:

2. HEAT TREATMENT OF BOLTS:

OF STEEL, GRADE 30 X FCA- σ_B $120 \pm 10 \text{ Kgf/MM}^2$ (FOR AUSTEMPERING-
 σ_B $120 \pm 10 \text{ Kgf/MM}^2$).

OF STEEL, GRADE 38 X A- σ_B $90 \pm 110 \text{ Kgf/MM}^2$ (HRC 27 - 34):

OF ALUMINIUM ALLOY, GRADE А1П - $\sigma_B \geq 38 \text{ Kgf/MM}^2$.

3. THREAD IS AS PER GOST 9150-59, TOLERANCE ZONES ARE AS PER GOST 16093-70:

-6g FOR THREAD LESS THAN M_3 AND 6 FOR THREAD M_3 AND MORE
THAN ARE FOR BOLTS OF STEEL AND BRASS FOR ELECTROPLATING.
-6h-FOR BOLTS OF ALUMINIUM ALLOY AND BRASS FOR PASSIVATING
TREATMENT.

4. COATING:

FOR BOLTS OF STEEL, GRADES 45 AND 38 X A- GALVANIZING:

OF STEEL, GRADE 30 X FCA $d_1 \leq 8 \text{ mm}$ - GALVANIZING $d_1 \geq 10 \text{ mm}$
- CADMIUM PLATING:

OF ALLUMINIUM ALLOY - ANODIC OXIDATION: OF BRASS -
PASSIVATING TREATMENT.

OTHER TYPES OF COATINGS SHOULD BE SPECIFIED BY DESIGNER
(SEE 101ATY)

5. RATED BREAKING FORCES ON BREAKAGES OF BOLTS OF STEEL, GRADES - 45: 38 X A: 30 X FCA AND OF ALLUMINIUM ALLOY - AS PER 2AP**6. RANGE OF SIZES AND WEIGHT - AS PER 5AP, TABLE 1 AND 14.****7. BOLTS WITH LOCKING HOLE IN HEAD MAY BE MANUFACTURED AS PER 182AT AS REQUIRED.****8. TECHNICAL SPECIFICATIONS ARE AS PER 101ATY.**

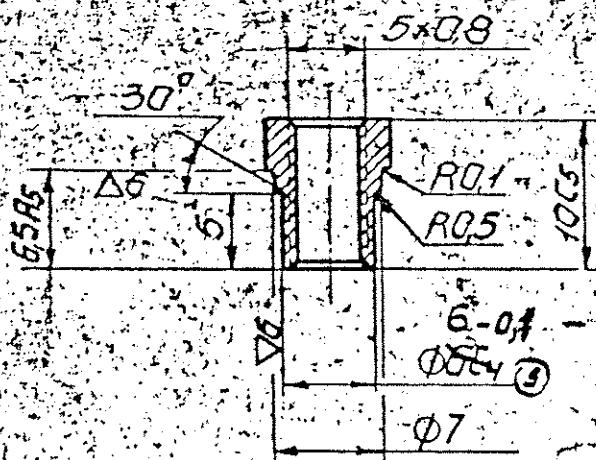
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

		EST. MASS.	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.		
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL	USED ON:-	
DRN <i>2/25</i>	SCALE:-			
CHD <i>2/25</i>	DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
TCD <i>2/25</i>	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: BOLT HEXAGONAL		
APPD <i>2/25</i>	ALL THREADS CONFORM TO	D S CAT NUMBER		
DATE 25/7/86		DRAWING NUMBER 3001A:3002A:3003A 3005A:3006A		

DRAWING NUMBER
AK150B - 042

UNLESS OTHERWISE SPECIFIED.

TOLERANCES ON FREE DIMENSIONS ARE
AS PER 22AT52 CLASS 7.



MAKE CHAMFERS TO A DEPTH OF THREAD AT AN
ANGLE OF 90° TO 120°.

HARDNESS RC = 28 TO 35.

OXIDIZE.

ALT. MATL:-

STEEL 40Cr4Mo3 TO IS: 5517-78

OR En 19 TO BS: 970. HRC. 25-32

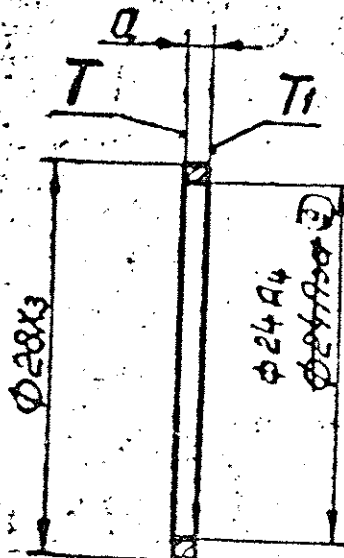
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

			EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THUS #
			1.65	(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.	
ISSUE	DATE	NATURE OF AMENDMENTS		
DRW	CPR	SCALE - 2:1	MATERIAL:- STEEL 38XA	USED ON:-
CHK	Chattach	DIMENSIONS IN mm	TY14-1-950-74.	AK150B - 36CB
TCD	V. P. R.	TOLERANCE ON DIMNS	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD:	
APPD	W	UNLESS OTHERWISE STATED.	TITLE: NUT	
DATE	ALL THREADS CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
22.7.86				AK150B - 042

DRAWING NUMBER
AK 150 B-050

5

DIMENSION a	QTY.
1.2±0.05	1
1.3±0.05	1
1.4±0.05	1
1.5±0.05	1
1.6±0.05	1
1.7±0.05	1



BLUNT SHARP EDGES R 0.3. NON PARALLELITY OF BUTTENDS T AND T₁ SHOULD NOT EXCEED 0.05 mm.

ALT. MATL:-

AL. ALLOY. SHEET GDE. 19000.0
TO IS: 737-86

KVD 74783

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

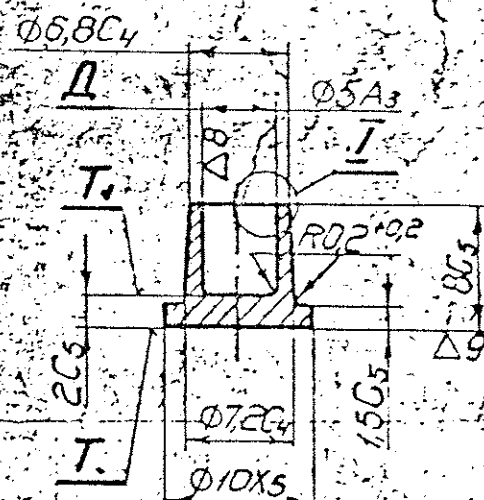
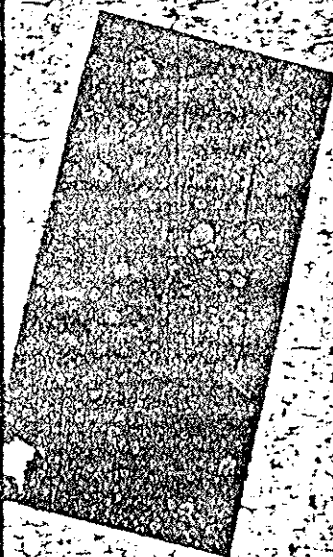
		EST. MASS. 0.4	TO BE STAMPED OR MARKED WHERE INDICATED THUS *
		LETTERS!	
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT- SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	
Draw R. Prnt		SCALE -	MATERIAL:- ALUMINIUM ALLOY A4-M GOST 21488-76
CHK Blutinsky		DIMENSIONS IN mm	USED ON:- AK 150 C -19 CE
TCD R. Prnt		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPO Pyr			TITLE: GASKET
DATE 22.7.86		ALL THREADS CONFORM TS	DRAWING NUMBER AK 150B-050

DRAWING NUMBER

AK 150B-052

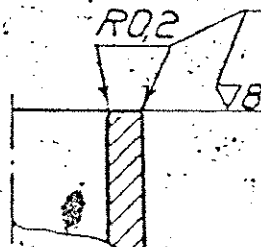
▽6 UNLESS OTHERWISE SPECIFIED.

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POLISH

SCALE: 5:1



MAINTAIN DIMENSION A OVER A LENGTH OF 5.6 mm. SHOULDER IS NOT ALLOWED.

DEVIATION FROM THE SQUARENESS OF SURFACES T AND T₁ WITH RESPECT TO SURFACE A SHOULD NOT EXCEED 0.03 mm.

DEVIATION FROM FLATNESS OF SURFACE T SHOULD NOT EXCEED 0.001 mm.

DRILL TRACE TO A DEPTH UPTO 0.5 mm IS ALLOWED ON SURFACE T₁.

BLUNT SHARP EDGES WITH R 0.3.

ALT. MATL:-

HARDNESS RC = 35 TO 42.

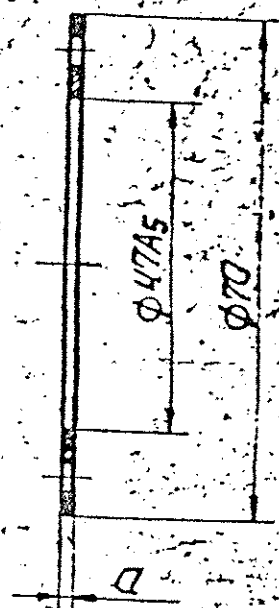
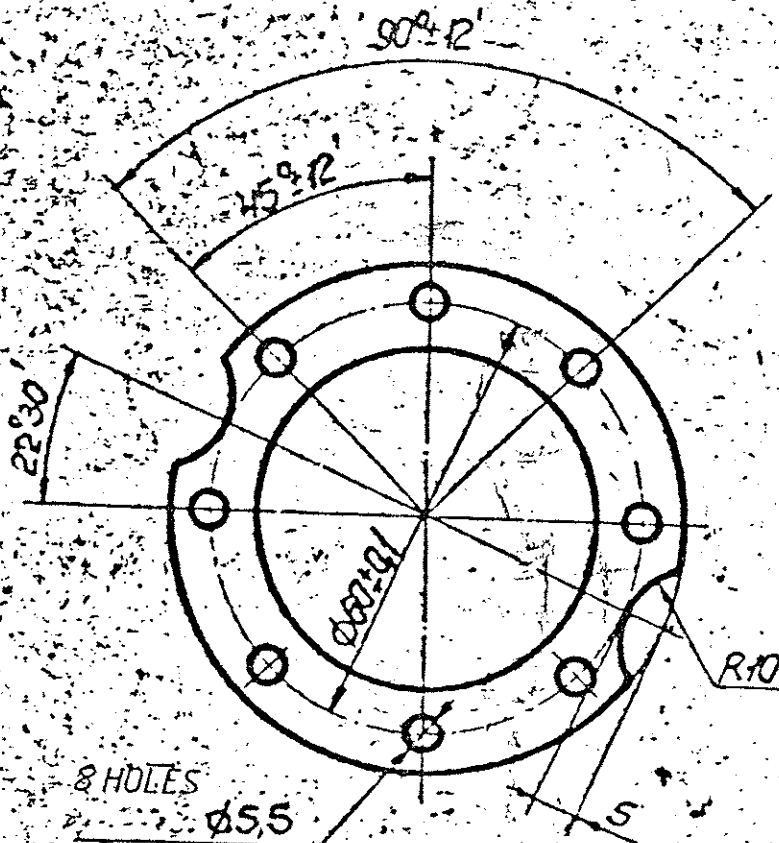
STEEL EN56C TO BS:970, HRC 35-42

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

			EST. MASS. 2	TO BE STAMPED OR MARKED WHERE INDICATED THUS Φ
				(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.	
ISSUE	DATE	NATURE OF AMENDMENTS		
DRAWN G. R. R.		SCALE - 2:1	MATERIAL:- STEEL 20X13 TY 14-1-37872	USED ON:- AK 150C-19 CE
CHKD B. R. R.		DIMENSIONS IN mm		
TEL G. R. R.		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APPROV G. R. R.			TITLE: VALVE	
DATE 22.7.86		ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER AK 150B-052

DRAWING NUMBER
AK 150B-053

TOLERANCES ON FREE DIMENSIONS
AS PER 22AT52 CLASS 7.



TOLERANCES ON DIMENSIONS ARE GIVEN FOR DIE.

a	QTY.
0.1	1705
0.2	1705

ALT. MATL: -
AL. ALLOY SHEET GDE.
19000 'O' TO IS: 737:86

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

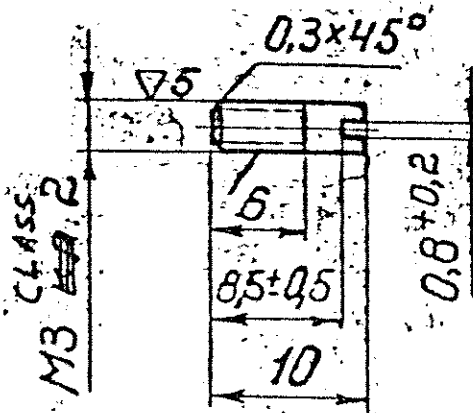
		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS 1
		1	LETTERS
ISSUE DATE		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
DRN	NATURE OF AMENDMENTS	MATERIAL: - FOIL A5-M	USED ON: - AK 150C. 01CB
CHK	SCALE: - 1:1	GOST 618-73	
YCB	DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AYADI	
APPD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: GASKET	
DATE	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
25/7/86			AK 150B-053

DRAWING NUMBER

AK150B-077

▽4

UNLESS STATED OTHERWISE

TOLERANCES ON FREE DIMENSIONS ARE
AS PER 22AT52 CLASS 7.

SCREW MAY BE MADE WITHOUT SLOTS.

ALT. MATL:-

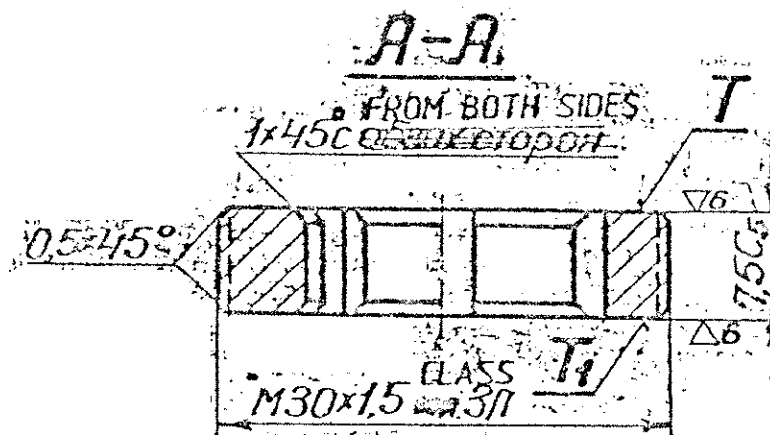
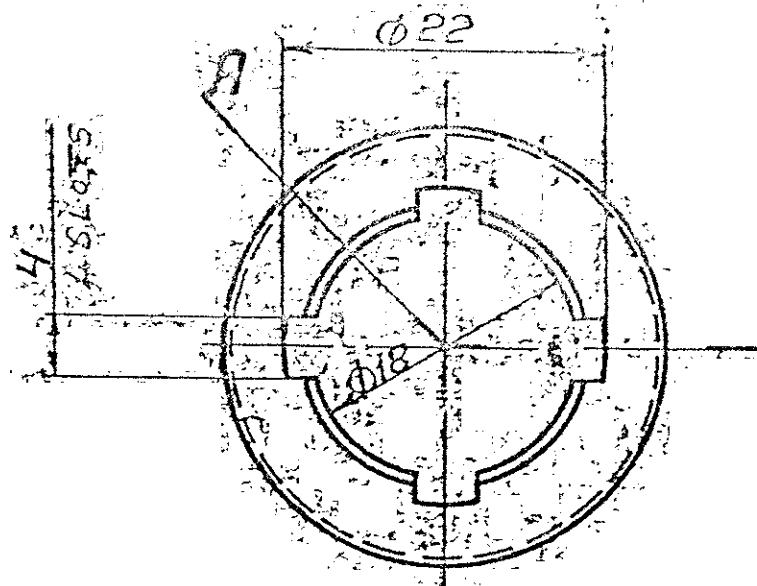
CU & CU ALLOY GDE CA 104
TO BS: 2874-86

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

		EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THUS *
		0.6	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	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN F. P. W.		SCALE - 2 : 1	MATERIAL:- BRASS 5c 59-1 GOST 2060-73
CHD G. P. W.		DIMENSIONS IN mm	USED ON:- AK 150C 40CE
TCD G. P. W.		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPD K. S.		ALL THREADS CONFORM TO	TITLE: SCREW
DATE 22.7.86		D S CAT NUMBER	DRAWING NUMBER AK150B-077

AK 150B 079

UNLESS OTHERWISE SPECIFIED.
TOLERANCES ON FREE DIMENSIONS ARE
AS PER 22AT52 CLASS 7.



RUN-OUT OF SURFACES T AND T₁ WITH RESPECT TO ANGLE
DIAMETER OF THREAD SHOULD NOT EXCEED 0.08 mm.

THREAD BEFORE COATING IS AS PER 214AT.

HARDNESS HRC 28 TO 35.

CADMIUM PLATING, 9 TO 13 MICRONS THICK.

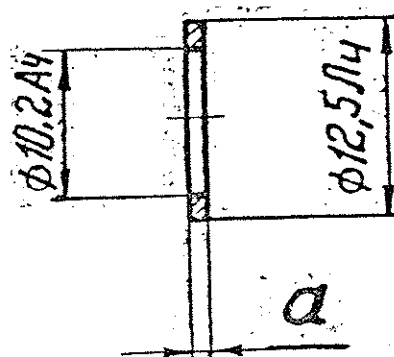
ALT. MATL:-

STEEL 40Cr4 Mo3 TO IS:
5517-78 OR EN 19 TO BS:970
HRC. 28-35

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

			EST. MASS. 15	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	
ISSUE DATE	NATURE OF AMENDMENTS		MATERIAL:- PIPE B-32x8-38xA GOST 21729-76	USED ON:- AK 150C-19 C5
SCALE - 2:1			CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
DIMENSIONS IN mm			TITLE: NUT	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.			D S CAT NUMBER	
ALL THREADS CONFORM TO			DRAWING NUMBER AK 150B-079	

DRAWING NUMBER
AK 150 B 085



KVD 74765

DRESS BURRS.

ALT. MATL: AL. ALLOY SHEET 19000'0'
TO IS: 737-86

a	QTY.	WEIGHT
1	1	
1.2	1	
1.3	1	
1.4	1	
1.5	1	
1.6	1	
1.8	1	

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

		EST. MASS. 0.4	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.	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL:- BAND A 1M GOST 13726-78	USED ON:- AK 150 C - 19C5
EDW h. p. m. s.	SCALE - 2 : 1		
CHD B. h. a. t. t. e. s. t.	DIMENSIONS IN mm		
TCD a. p. m. s.	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APPD h. p. m. s.	ALL THREADS CONFORM TO	TITLE: WASHER	
DATE 22.7.86		D S CAT NUMBER	DRAWING NUMBER AK 150 B - 085

AK150B - 089

STEEL 40Cr4Mo3 TO IS:5517-78
OR En19 TO BS:970. HRC 28-35

PROT. SAMPLE SHOULD BE APPROVED BY A H S PERSON BEFORE

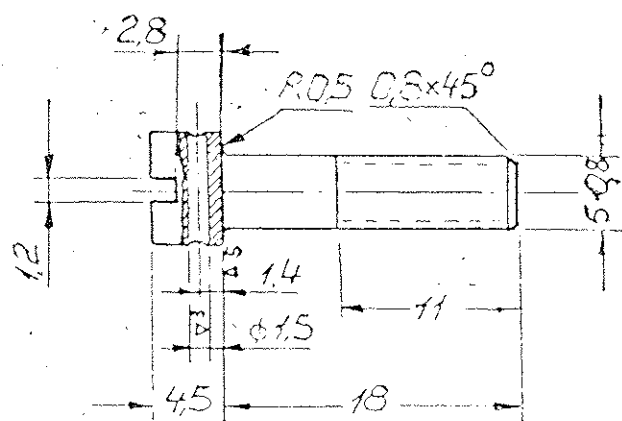
		EST. MASS.		TO BE STAMPED OR MARKED WHERE INDICATED THUS *	
		1.0		(LETTERS)	
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.			
ISSUE	DATE	NATURE OF AMENDMENTS			
DRM	CDL	SCALE - 2:1		MATERIAL:- STEEL 38XA	
CHD	Bhatnagar	DIMENSIONS IN mm		USED ON:- AK150B-36CB	
TCD	V. Ram	TOLERANCE ON DIMS UNLESS OTHERWISE STATED		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APPD	K			TITLE: NUT	
DATE	22.7.96	ALL THREADS CONFORM TO		D S CAT NUMBER	
				DRAWING NUMBER AK150B - 089	

DRAWING NUMBER

AK 150 B.091



UNLESS OTHERWISE SPECIFIED

TOLERANCES ON FREE DIMENSIONS ARE
AS PER IS 228152 CLASS 7.

WORK PIECE IS PART AK150B-141.

WORK PIECE AND CHAMFER ARE AS PER 163.MT

WHEN THREAD IS MADE BY ROLLING

THREAD BEFORE COATING IS AS PER 214AT.

HARDNESS RC = 24 TO 30.

ATL-MATL:-

STEEL Gde 40Cr4Mo3 TO IS: 5517-78
OREn 19 TO BS: 970 HRC 26-32

KVD.74789

CADMIUM PLATING, 9 TO 13 MICRONS THICK

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

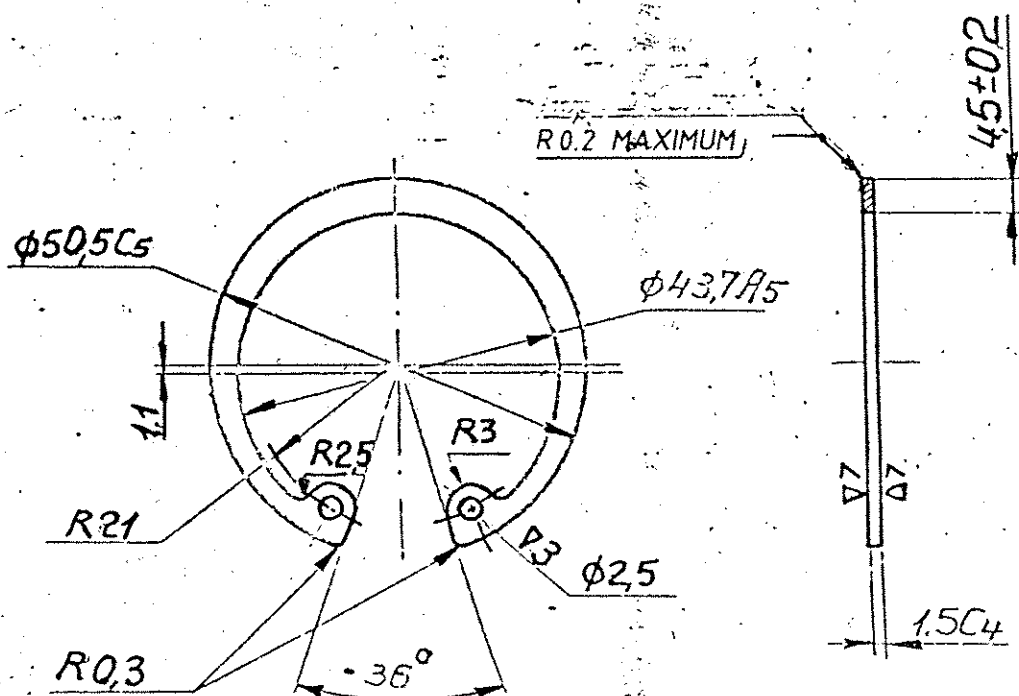
		EST. MASS. 4.2	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT- SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUED	DATE	NATURE OF AMENDMENTS	
DRN		SCALE:- 2:1	MATERIAL:- STEEL 38XA
CRD		DIMENSIONS IN mm	USED ON:- AK 150C-07C6
YCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD
APPD		ALL THREADS CONFORM TO	TITLE: SCREW
DATE		D S CAT NUMBER	DRAWING NUMBER AK 150B-091

DRAWING NUMBER
AK 150 B .093



UNLESS STATED OTHERWISE

TOLERANCES ON FREE DIMENSIONS ARE
AS PER 22AT52 CLASS 7.



TECHNICAL SPECIFICATIONS ARE AS PER 714M55.

HARDNESS RC = 42 TO 48.

PARKERIZE WITH OXIDATION.

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

ALT. MATL.:

COLD ROLLED STEEL STRIP

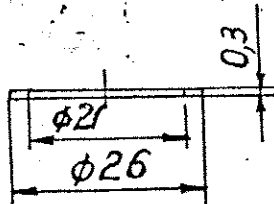
Gde 5 (75C6) TO IS: 2507-75

KND 74790

			EST. MASS 6	TO BE STAMPED ON PARTS WHERE INDICATED THIS (LETTERS)
ISSUE	DATE	NATURE OF AMENDMENTS	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
APPROVED	25/7/80	SCALE - 1:1	MATERIAL - STEEL 60C2A GOST 2283-69	USED ON:- AK150C-01 C5
DESIGNED		DIMENSIONS IN MM	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADL	
TO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	FILE:- LOCKING RING	
APPROVED		ALL THREADS CONFORM TO	B S CAT NUMBER	DRAWING NUMBER AK150B-093

DRAWING NUMBER
AK 150 B.095

TOLERANCES ON FREE DIMENSIONS ARE
AS PER 22AT52 CLASS 7.



DRESS THE BURRS.

CADMIUM PLATING 9 TO 13 MICRONS THICK.

ALT. MATL:-

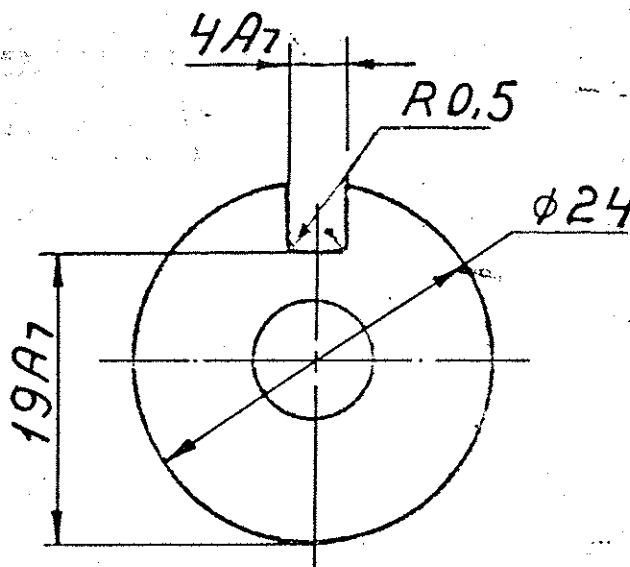
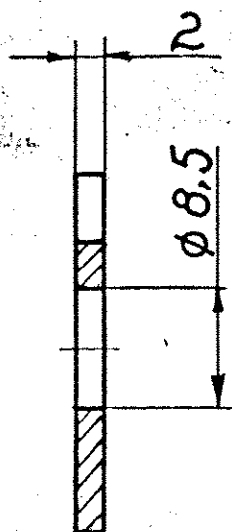
STEEL Gde D TO IS: 513-86

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

		EST. MASS 0.4	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	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN GPI	8	SCALE - 1:1	MATERIAL:- STEEL 10, 90ST 16523-70
END GPI		DIMENSIONS IN mm	USED ON:- AK150C-01 C6
TCO d N/kg		TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADL
APPD W		ALL THREADS CONFORM TO	TITLE:- WASHER
DATE 25/1/8		D S CAT NUMBER	DRAWING NUMBER AK150B-095

DRAWING NUMBER
AK 150 B.098

TOLERANCE FOR FREE DIMENSIONS
ARE AS PER 22AT52-CLASS 7.



ATL. MATL:-

STEEL Gde 40 Cr4 TO IS: 5517-78
OR EN 19 TO BS: 970. HB: 202-248.

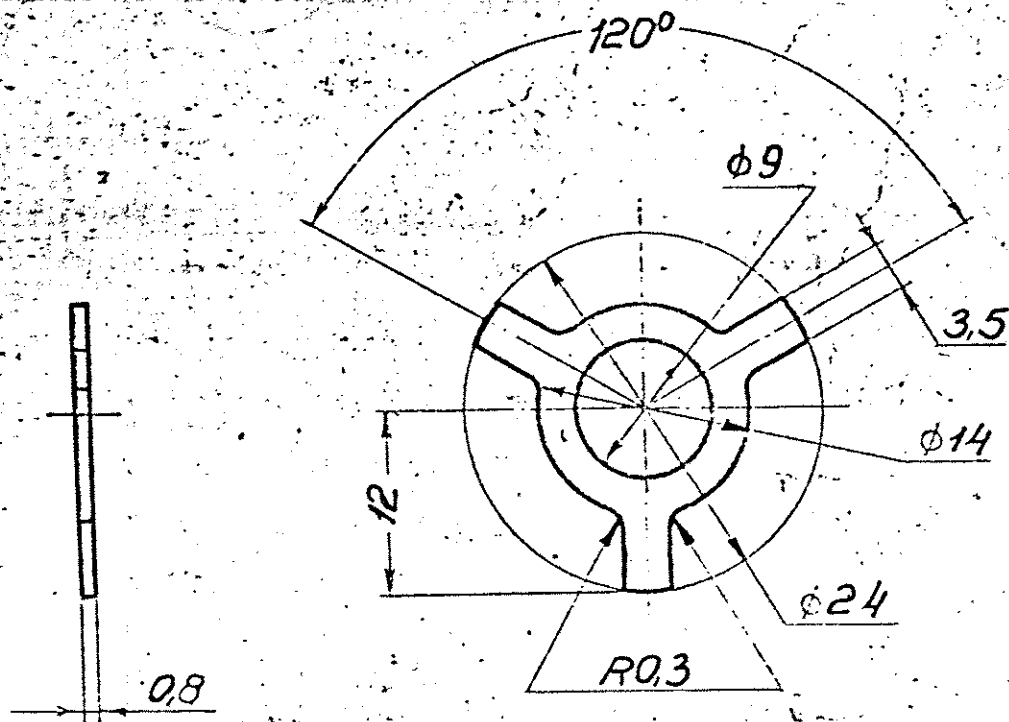
OXIDIZE.

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

			EST. MASS 6	TO BE STAMPED OR MARKED WHERE INDICATED THUS # 1 LETTERS)
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL:- STEEL 30X7 CA USED ON:- AK 150 C.01 CB GOST 11268-65	
CHKD Chhatrathy		SCALE - 2:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TED a. Mahalingam		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE:- WASHER	
APPD 25/12		ALL THREADS CONFORM TO	B S CAT NUMBER	DRAWING NUMBER AK 150 B-098

DRAWING NUMBER
AK 150B-099

TOLERANCES FOR FREE DIMENSIONS ARE
AS PER 22AT52-CLASS 7.



ALT. MATL:-
STEEL Gd'D TO IS: 513-86

KVD 74792

DRESS THE BURRS.

OXIDIZE.

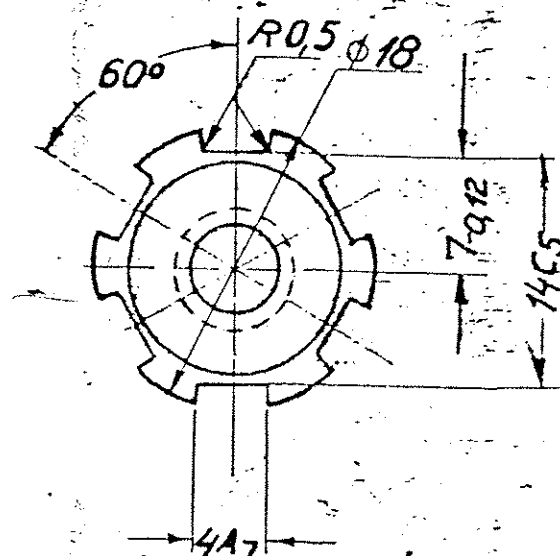
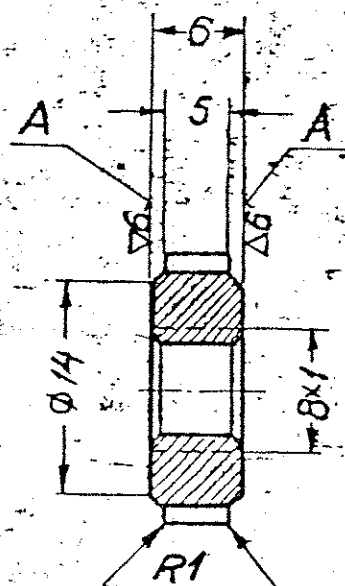
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

			EST. MASS 0.8	TO BE STAMPED OR MARKED WHERE INDICATED THIS (S)
				LETTERS)
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL - STEEL 10 605T 16523-70	USED ON:- AK 150C-01C5
DRN CR		SCALE - 2:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AYAD	
CHD Blattuch		DIMENSIONS IN mm	TITLE:- LOCK WASHER	
TCD S. Mahal		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	B S CAT NUMBER	
APPO Vn		ALL THREADS CONFORM TO	DRAWING NUMBER AK 150B-099	
DATE 25/7/16				

DRAWING NUMBER
AK 150 B.100

▽4 UNLESS OTHERWISE SPECIFIED.

TOLERANCES ON FREE DIMENSIONS ARE
AS PER 22AT52-CLASS 7.



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

RUN OUT OF SURFACES A WITH RESPECT TO ANGLE DIAMETER
OF THREAD SHOULD NOT EXCEED 0.1 mm.

MAKE CHAMFERS TO A DEPTH OF THREAD AT AN ANGLE OF 120°.

HARDNESS RC = 24 TO 30.

ALT. MATL:-

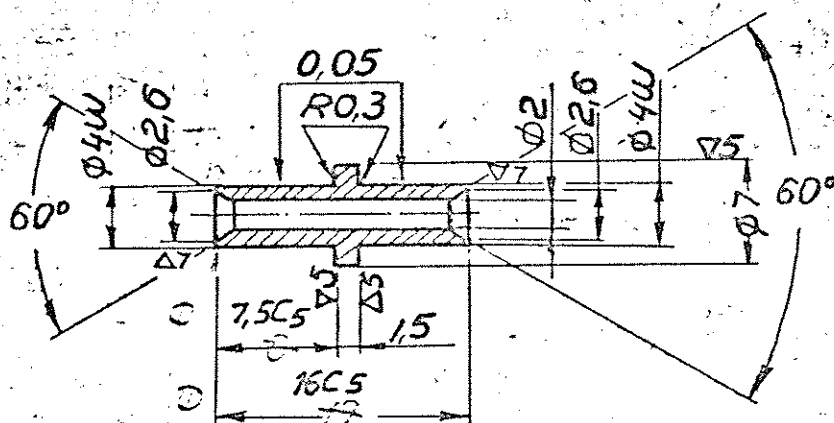
STEEL Gd 40 Cr 4 TO IS: 5517-78
OR EN 19 TO BS: 970 HRC. 24-30

			EST. MASS 7	TO BE STAMPED OR MARKED WHERE INDICATED THIS (LETTERS)
ISSUE	DATE	NATURE OF AMENDMENTS	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
28/11/8		SCALE - 2:1	MATERIAL - STEEL 45 TY 14-1-151-72	USED ON:- AK150C-01 CB
28/11/8		DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADL	
28/11/8		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE:- NUT	
APPD		ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER AK-150B-100
DATE 28/11/8				

DRAWING NUMBER
AK 150B-101

UNLESS OTHERWISE SPECIFIED.

TOLERANCES ON FREE DIMENSIONS ARE
AS PER 22AT52 CLASS 7.



ALT. MATL:-
COPPER & COPPER ALLOY
Gde CA 104 TO BS:2874-86

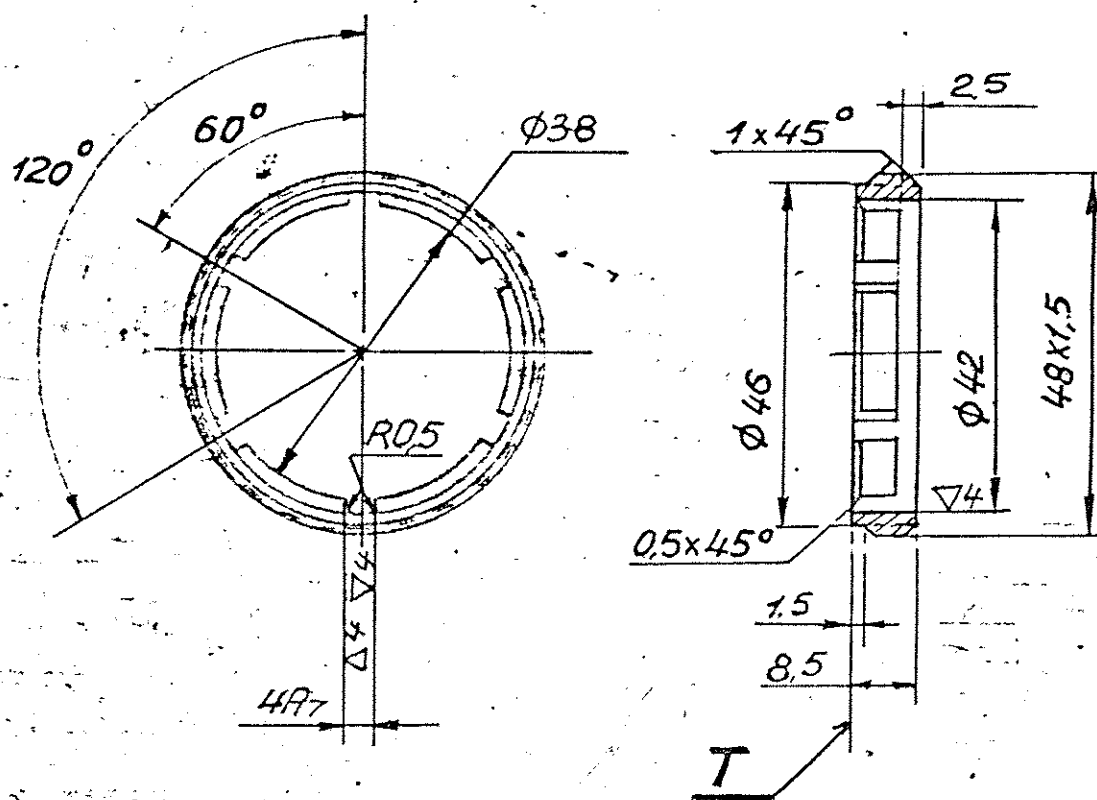
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

			EST. MASS 1.5	TO BE STAMPED OR MARKED WHERE INDICATED THUS
				LETTERS)
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. ROUNDED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE	DATE	NATURE OF AMENDMENTS	SCALE - 2:1	MATERIAL - BRONZE EPA *9-A GOST 1628-72
CHKD			DIMENSIONS IN mm	USED ON:- AK 150C 01CB
TCD			TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD
APPD			ALL THREADS CONFORM TO	TITLE - BUSH
DATE				D S CAT NUMBER
				DRAWING NUMBER AK 150B-101

DRAWING NUMBER
AK 150 B -102

▽5 UNLESS OTHERWISE SPECIFIED.

TOLERANCES ON FREE DIMENSIONS ARE
AS PER 22AT52 CLASS 7.



RUN-OUT OF SURFACE T WITH RESPECT TO ANGLE DIAMETER OF THREAD
SHOULD NOT EXCEED 0.1 mm.

THREAD TRACES ARE ALLOWED ON SURFACE $\phi 46$.

THREAD BEFORE COATING IS AS PER 214 AT.

HARDNESS RC = 24 TO 31.

COATING: CADMIUM 9 TO 13 MICRONS THICK.

ALT. MATL:-

STEEL Gde 40Cr4 Mo3 TO
IS: 5517-78 OREn 19 TO BS: 970
HRC. 24-31.

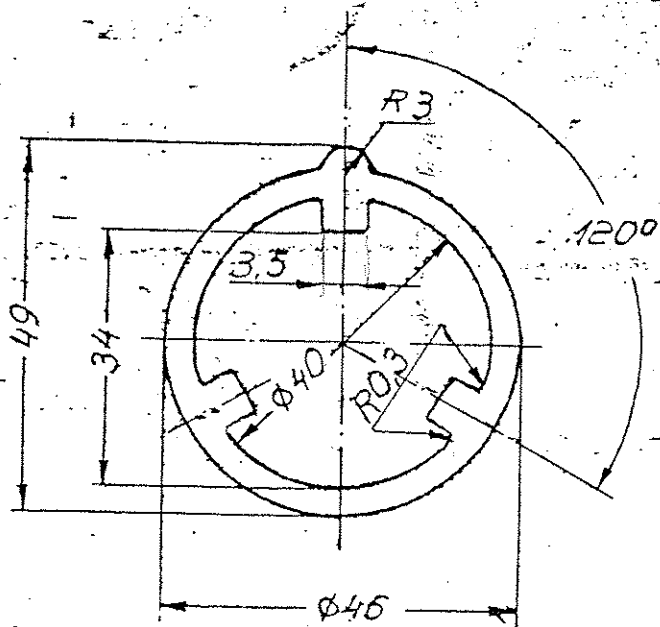
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

			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	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL:- PIPE 51XB- 38XA GOST 21729-76	USED ON:- AK 150 C - 01 C5
DRW		SCALE - 1:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADK	
CHD		DIMENSIONS IN mm	TITLE:- NUT	
TCD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
APPD		ALL THREADS CONFORM TO	DRAWING NUMBER AK150B-102	
DATE				

DRAWING NUMBER
AK.150B.103

TOLERANCES FOR FREE DIMENSIONS ARE
AS PER 22AT52 CLASS 7.

0.8



DRESS THE BURRS.

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

ALT. MATL: -

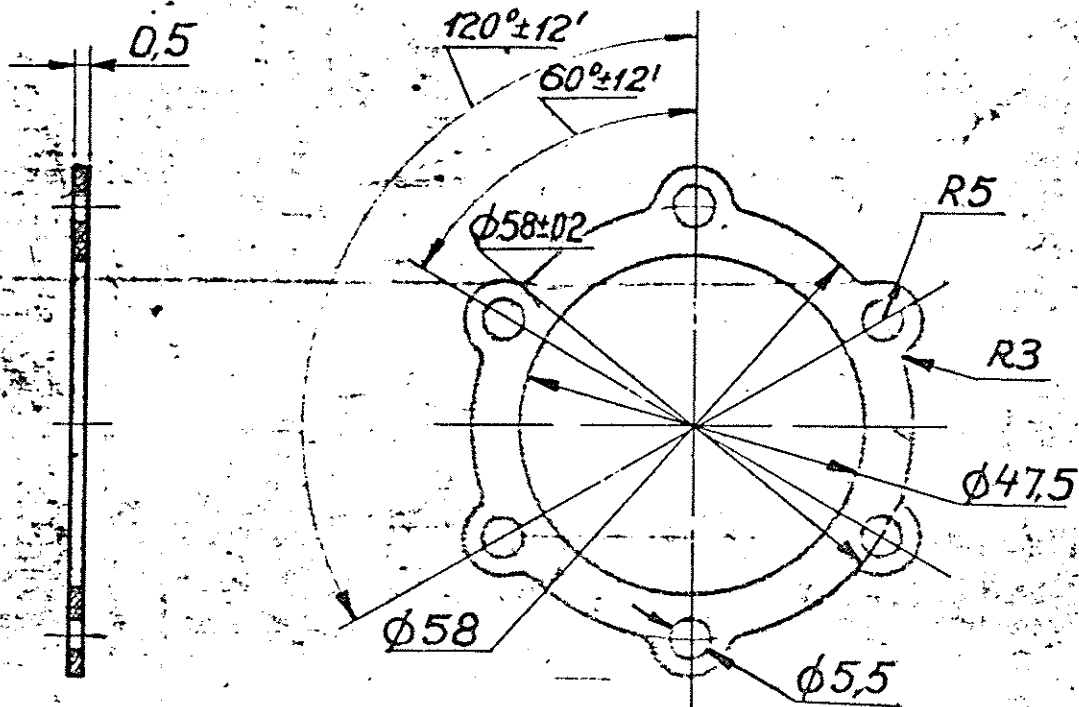
STEEL Gde 'D' TO IS: 513-86.

CADMIUM PLATING 9 TO 13 MICRONS THICK.

		EST. MASS 3	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.		
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL - STEEL 10 GOST 16523-70	USED ON: - AK150C.01C5
CHK	25/10	SCALE - 1:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHK	25/10	DIMENSIONS IN mm	TITLE - WASHER	
TCO	25/10	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	DRAWING NUMBER AK150B-103	
APPD	25/10	ALL THREADS CONFORM TO		

DRAWING NUMBER
AK.150B-104

TOLERANCES ON FREE DIMENSIONS ARE
AS PER 22AT52-CLASS 7.



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

ALT. MATL :-

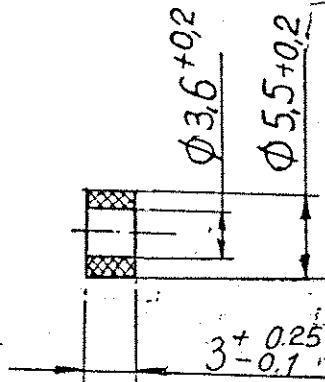
COMPRESSED ASBESTOS FIBER JOINING

Gde A/I TO IS : 2712-79

			EST. MASS 1	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	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL :- PARONITE PM5-T-GOST 481-71	USED ON :- AK150C-01C5
DRN	8/1/79	SCALE - 1:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAIL	
CHD	8/1/79	DIMENSIONS IN mm	TITLE :- GASKET	
TCD	8/1/79	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
APPD	8/1/79	ALL THREADS CONFORM TO	DRAWING NUMBER AK150B-104	

DRAWING NUMBER
AK.150B.105

▽6



ALT. MATL:-

RUBBER Gde BA 80 T0BS: 2751-82.

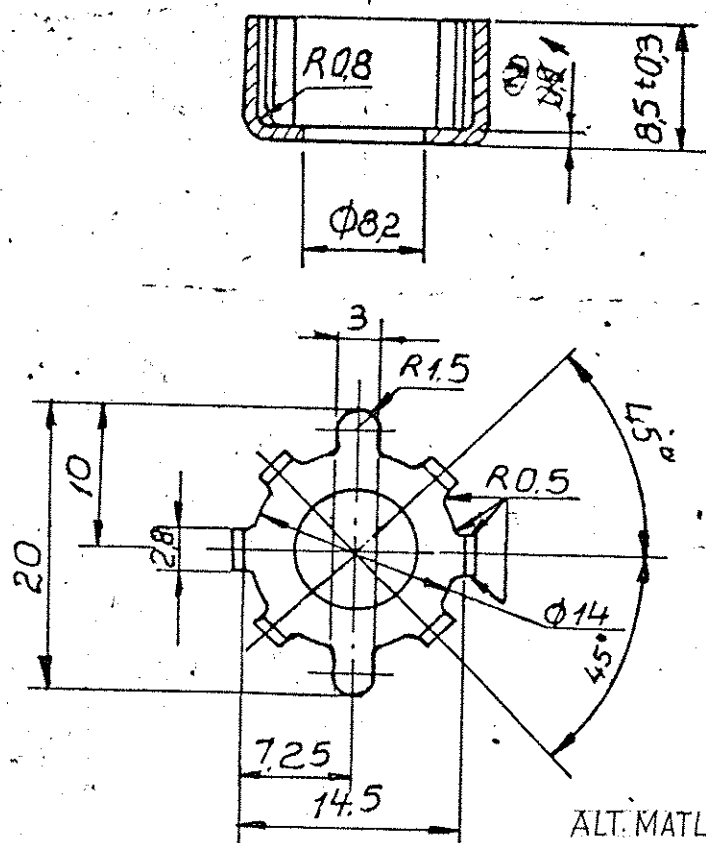
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

		EST. MASS 0,05	TO BE STAMPED OR MARKED WHERE INDICATED THIS LETTER(S)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHANGES ARE PERMISSIBLE.	
ISSUE	DATE	NATURE OF AMENDMENTS	
CP	1/1	SCALE - 2:1.	MATERIAL :- RUBBER UP-7 1078A TY 38005 1166-73
CHD	1/1	DIMENSIONS IN mm	USED ON:- AK 150C-01C6
TCD	1/1	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADL
APPD	1/1	ALL THREADS CONFORM TO	TITLE:- RING
DATE	25-6/18		DRAWING NUMBER AK150B-105

DRAWING NUMBER

AK 150B - 106

TOLERANCE FOR FREE DIMENSIONS ARE AS PER
22AT52 - 7th CLASS.



ALT. MATL:-

STEEL Gde 'D' TO IS: 513-86

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

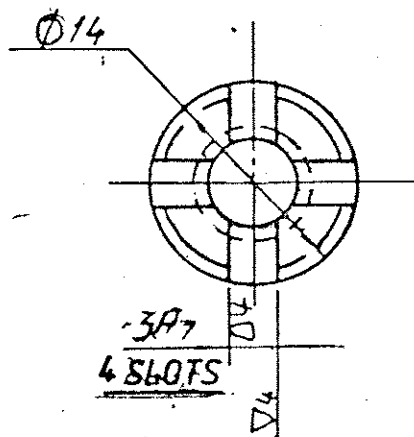
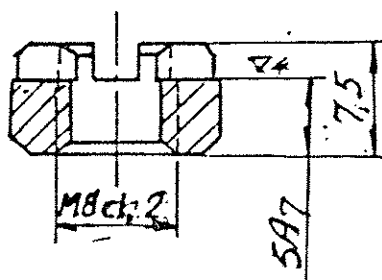
			EST. MASS. 2	TO BE STAMPED OR MARKED WHERE INDICATED THUS 
			LETTERS	
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT- SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL:- STEEL 10 GOST 16523-70	USED ON:- AK 150C-52 C6
DRW	28/8	SCALE - 2:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHKD	28/8	DIMENSIONS IN mm	TITLE: LOCK WASHER	
APPD	28/8	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	DRAWN BY: AK 150B - 106	
DATE		ALL THREADS CONFORM TO		

DRAWING NUMBER
AK 150 B -107

▽5 UNLESS OTHERWISE SPECIFIED.

TOLERANCES ON FREE DIMENSIONS ARE
AS PER 22AT52 CLASS 7.

BOTH SIDES 0.5X45°



CHAMFER TO A DEPTH OF THREAD AT AN ANGLE OF 90 TO 120°.

HARDNESS H R C 20 TO 30.

OXIDIZE.

ALT. MATL:-

STEEL Gde 40 Cr4 TO IS: 5517-78

OR EN 19 TO BS: 970. HRC. 20-30

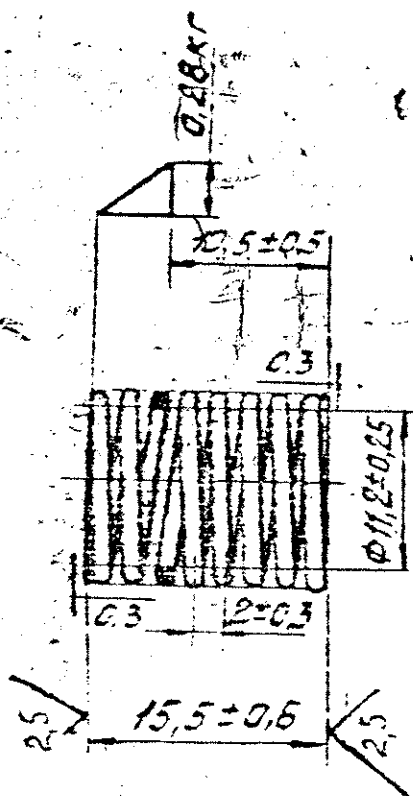
PILOT SAMPLE SHOULD BE APPROVED BY A M S P BEFORE BULK PRODUCTION.

		EST. MASS. 6	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.	
ISSUE/DATE	NATURE OF AMENDMENTS		
DRW CLL	SCALE - 2:1	MATERIAL:- STEEL 45 TY 14-1-151-72	USED ON:- AK 150C-52 C6
CHD B. L. T. A. C. K.	DIMENSIONS IN mm		
TCD S. S. O. U. A. H. A.	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APPD K. S.		TITLE: NUT	
DATE	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER AK 150 B -107

DRAWING NUMBER
AK150B-111

✓(✓)

NUMBER OF WORKING TURNS	7
TOTAL NUMBER OF TURNS	9
DIRECTION OF WINDING	RIGHT HAND



1. TECH. SPECIFICATION IS AS PER OST 1 00793-75.
2. DIMENSIONS ARE GIVEN AFTER TEN TIMES TURN TO TURN COMPRESSION.
3. 3rd GROUP OF INSPECTION.

ALT. MATL:-

SPRING STEEL WIRE GDE-3
TOIS: 4454 (PART-I)-81

COATING:- CADMIUM-PLATING
9 MICRONS THICK.

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

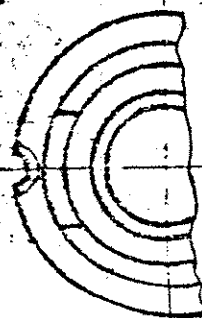
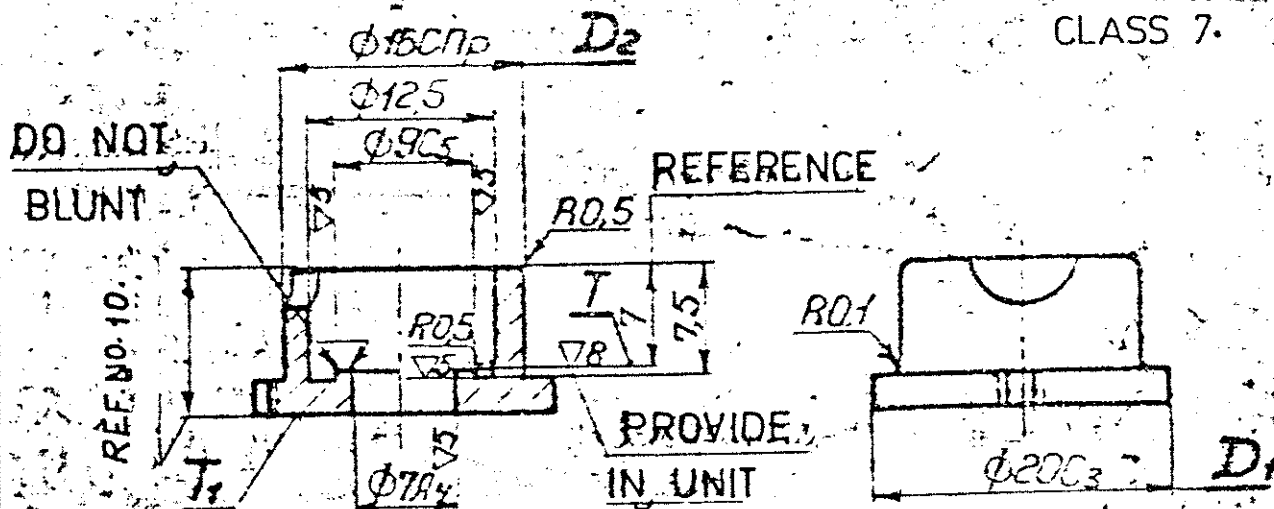
		EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THIS
		1.8.	LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRW G. P. R.		SCALE - 2:1	MATERIAL:- WIRE IIA - 0.9 GOST 9389-75
CHK G. P. R.		DIMENSIONS IN mm	USED ON:- AK 150B 60 CE
TCD G. P. R.		TOLERANCE ON DIMS, UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD
APPD G. P. R.			TITLE: SPRING
DATE 22.7.86		ALL THREADS CONFORM TO	DRAWING NUMBER AK150B-111

DRAWING NUMBER

AK 150B-115

▽6

UNLESS SPECIFIED OTHERWISE
TOLERANCES ON FREE DIMENSI-
-ONS ARE AS PER 22 AT 52,
CLASS 7.



ALT. MATL:-

Cu AND Cu ALLOY Gde CA 104
TO BS: 2874-86.

DIMENSIONS ARE GIVEN WITH
THE ACCOUNT FOR COATING.
REMOVE LAYER OF LEAD FROM
SURFACES T AND T_1 IN UNIT
AFTER PRESS-FITTING. RUN-OUT
OF SURFACE D_1 WITH RESPECT
TO D_2 SHOULD NOT EXCEED 0.03mm.
(PROVIDE TECHNOLOGICALLY).

ELECTROPLATING: LEAD,
10 TO 20 MICRONS THICK.
DO NOT LEAD PLATE
INTERNAL SURFACES.

HARDNESS $H_b = 200$ TO
240.

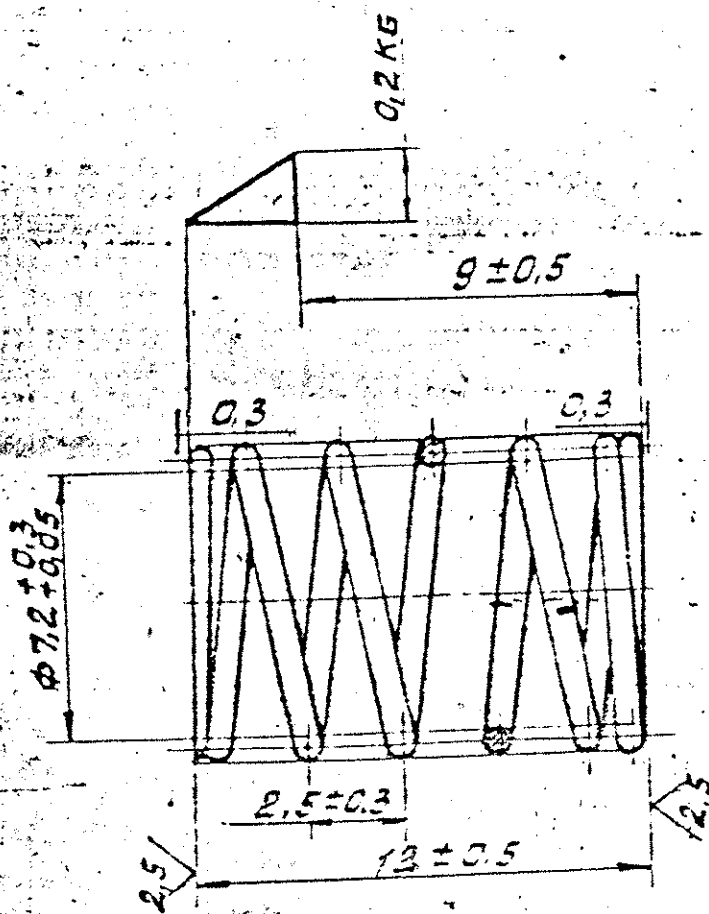
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

		EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THUS *
		11%	(LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL:-	USED ON:-
DRW G. R. R.	SCALE - 2:1	BRONZE БРАЖН 10-4-4	AK 150C 40 CE
CHK G. R. R.	DIMENSIONS IN mm	GOST 1628-72	
TCD G. R. R.	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APPO G. R. R.		TITLE: VALVE BODY	
DATE 22.7.86	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER AK150B-115

AK 150B-116

✓(✓)

NUMBER OF WORKING TURNS	4,5
TOTAL NUMBER OF TURNS	6,5
DIRECTION OF COILING	RIGHT-HAND



1. TECHNICAL SPECIFICATIONS ARE AS PER OST 100793-75.
2. DIMENSIONS ARE GIVEN AFTER SPRING IS COMPRESSED, WITH TURNS TOUCHING, 10 TIMES.
3. INSPECTION GROUP 3.

ALT. MATL:-

SPRING STEEL WIRE GDE-3
TO IS: 4454 (Pt-1)-81COATING:- CADMIUM-PLATED,
9 MICRONS THICK.

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

EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTERS)
0.4	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUED DATE	NATURE OF AMENDMENTS
DRN G. P. M.	SCALE:- 5:1
CHO G. P. M.	DIMENSIONS IN mm
TCD G. P. M.	TOLERANCE ON DIMS UNLESS OTHERWISE STATED
APPD G. P. M.	ALL THREADS CONFORM TO
DATE 22.7.80	
MATERIAL:- WIRE IIA - 0,6 GOST 9389 -75 STEEL 70 GOST 1050-74	
USED ON:- AK 150C 19.05	
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TITLE: SPRING	
D S CAT NUMBER	
DRAWING NUMBER AK 150B-116	