

# GUN & SHELL FACTORY COSSIPORE KOLKATA-700 002



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📍 NOTE AK630 SB 114 PZ IS NOT  
AVAILABLE

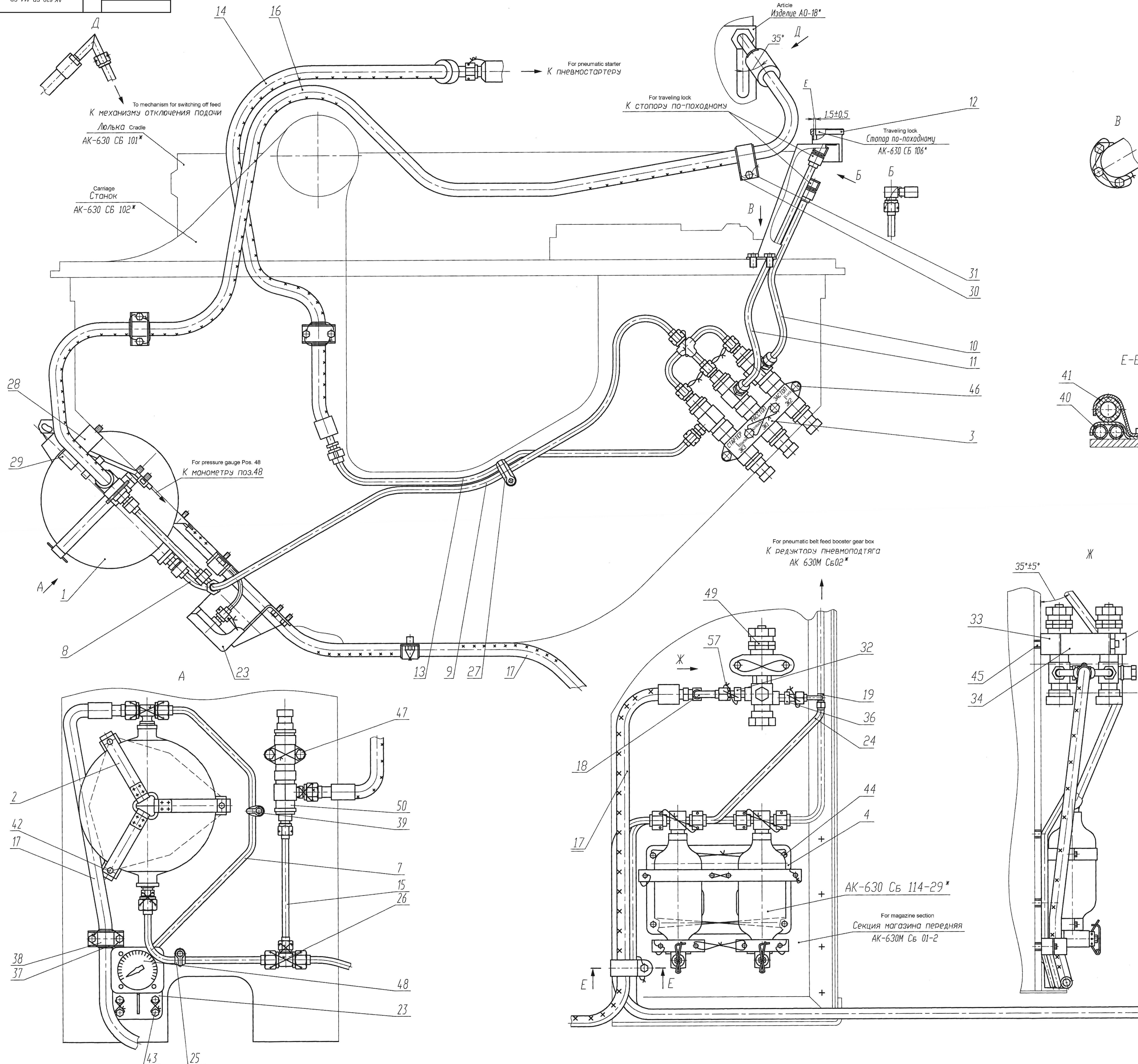


First use	Format	Zone	Position	Designation		Nomenclature			Qty.	Remarks	
							<u>Documents</u>				
Reference No.	A0			AK-630 Sb 114 SB		Assembly drawing					
	A1			AK-630 Sb 114 PZ		Pneumatic circuit diagram					
						<u>Assembly units</u>					
	A4		1	AK-630 Sb 114-1		Evacuator chamber			1		
	A4		2	AK-630 Sb 114-2		Evacuator chamber fastener			1		
	A4		3	AK-630 Sb 114-3		Electro pneumatic valve			1		
						fastener					
	A4		4	AK-630 Sb 114-4		Fastener			1		
						Oil moisture separator					
	A4		7	AK-630 Sb 114-7		Pipe line			1		
Sign and Date	A4		8	AK-630 Sb 114-8		Pipe line			1		
	A4		9	AK-630 Sb 114-9		Pipe line			1		
	A4		10	AK-630 Sb 114-10		Pipe line			1		
	A4		11	AK-630 Sb 114-11		Pipe line			1		
Duplicate Inv. No.	A4		12	AK-630 Sb 114-12		Casing			1		
	A4		13	AK-630 Sb 114-13		Pipe line			1		
	A4		14	AK-630 Sb 114-14		Hose			1		
	A4		15	AK-630 Sb 114-15		Pipe line			4		
Alternate Inv no.											
Sign and Date						<b>AK-630. Sb 114</b>					
	Amend.	Sheet	Doc. No.	Sign	Date						
Orig. Inv. No.	Developed by					<b>Pneumatic equipment</b>			Type	Sheet	Sheets
	Checked by								A	1	4
	Head of Q.C.D										
	Approved by										

Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
A4		16	AK-630 Sb 114-16	Hose	1	
A4		17	AK-630 Sb 114-17	Hose	1	
A4		18	AK-630 Sb 114-18	Plug	1	
A4		19	AK-630 Sb 114-19	Plug	1	
A4		21	AK-630 Sb 114-21-01	Pipe line	1	
A4		22	AK-630 Sb 114-22-01	Pipe line	1	
A4		23	AK-630 Sb 114-102	Bracket	1	
A4		24	AK-630M Sb 02-3	Pipe line	1	
				<u>Components</u>		
A3		25	AK-630 114-1	Clamp	1	
A3		26	AK-630 114-4	Tee joint	1	
A3		27	AK-630 114-5	Clamp	1	
A3		28	AK-630 114-6	Base	1	
A3		29	AK-630 114-7	Clamp	1	
A4		30	AK-630 114-8	Gasket	1	
A3		31	AK-630 114-9	Clamp	1	
A3		32	AK-630 114-10	Adapter	2	
A3		33	AK-630 114-11	Base	1	
A3		34	AK-630 114-12	Insert	1	
A3		35	AK-630 114-13	Cover	1	
A3		36	AK-630 114-14	Adapter	2	
A4		37	AK-630 114-15	Gasket	4	
A3		38	AK-630 114-16	Clamp	4	
A3		39	AK-630 115-3	Clamp	1	
A3		40	AK-630M 02-3	Clamp	1	
Orig. Inv. No.						
Amend.	Sheet	Doc. No.	Sign	Date	<b>AK-630. Sb 114</b>	
						Sheet 2

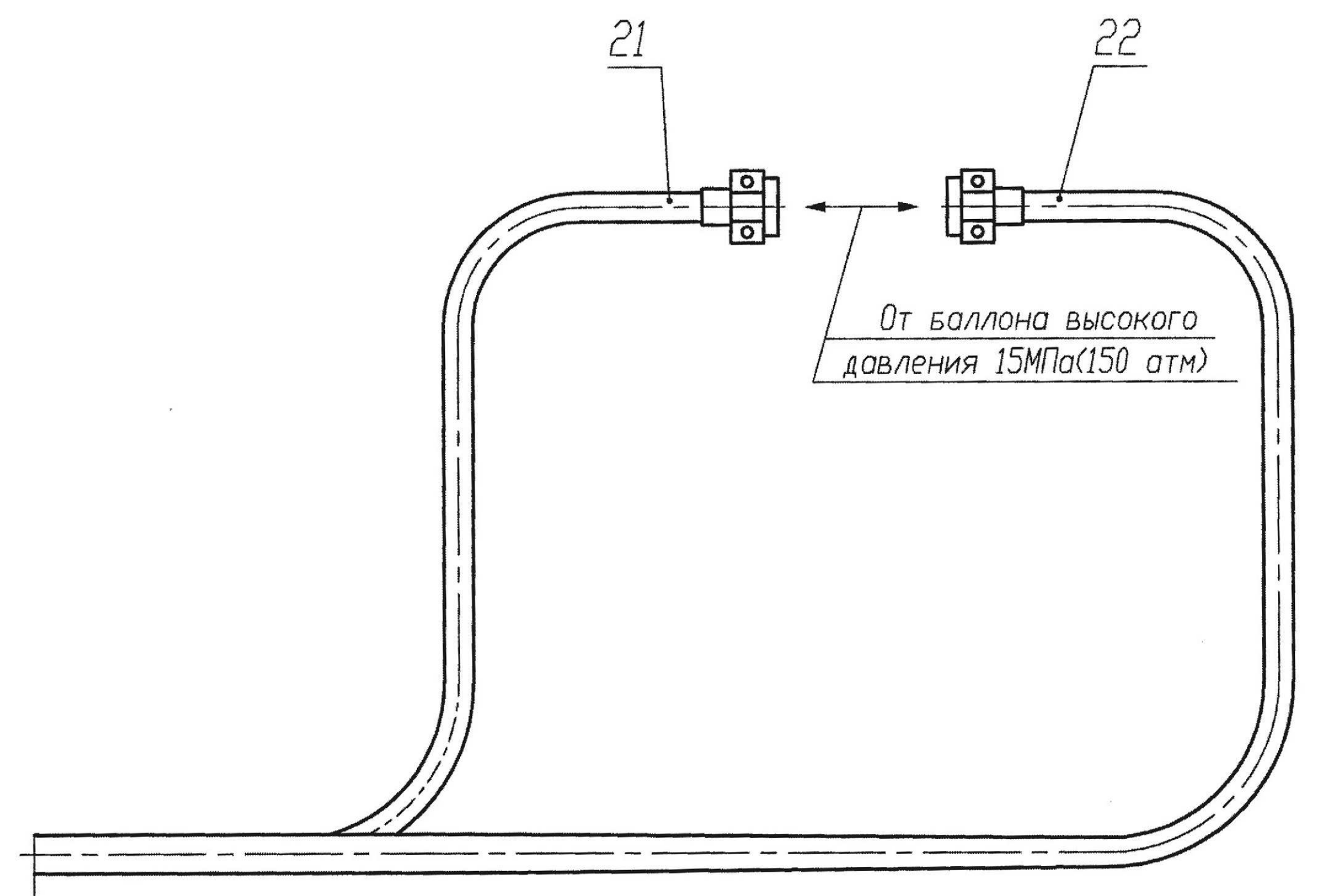
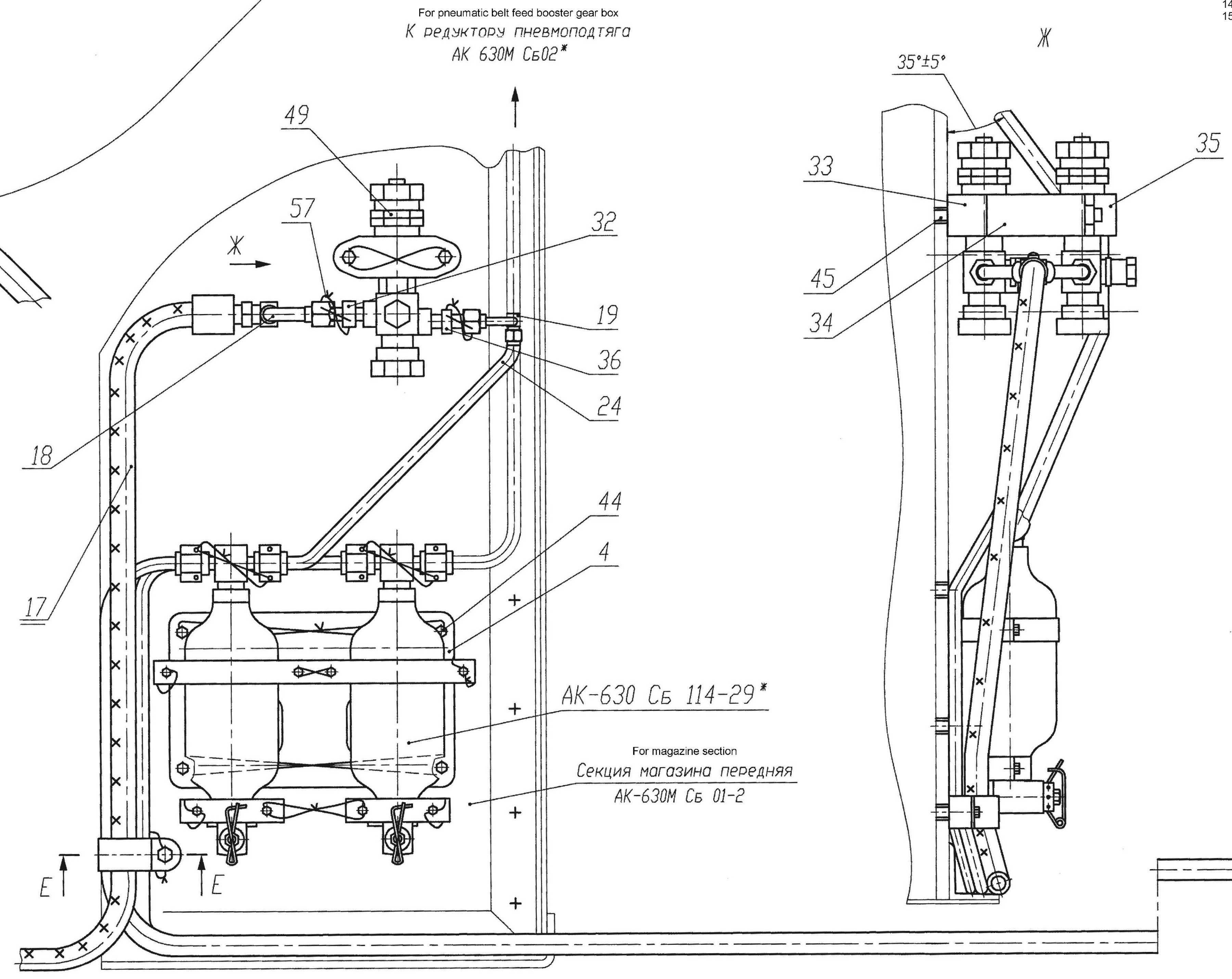
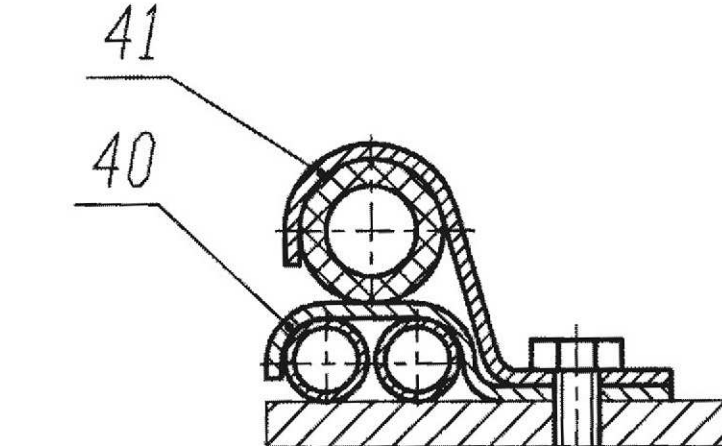
Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
A3		41	AK-630M 02-4	Clamp	1	
				<u>Standard articles</u>		
		42		Bolt 3M8-8gx16.109.40X.029	6	31...40.5 HRC E
				GOST 7798-70		
		43		Bolt 3M6-8gx16.109.40X.029	19	65.5...70
				GOST 7805-70		HRA
		44		Bolt 3M8-8gx12.109.40X.029	4	31...40.5 HRC E
				GOST 7798-70		
		45		Bolt	2	31...40.5 HRC E
				3M10-8gx110.109.40X.029		
				GOST 7798-70		
		46		Bolt 3M8-8gx25.109.40X.029	2	31...40.5 HRC E
				GOST 7798-70		
		47		Bolt 3M8-8gx35.109.40X.029	2	31...40.5 HRC E
				GOST 7798-70		
				<u>Other articles</u>		
		48		Air manometer MVU-100	1	
				MVU-TU		
		49		Air pressure regulator	2	
				IL 611 – 150 –70K		
Orig. Inv. No.						
Amend.	Sheet	Doc. No.	Sign	Date	AK-630. Sb 114	
						3





1. \* Article for reference.
2. Set gear box IA 611-150-70 in pneumatic equipment AK-630 Sb. 114 which should be checked as per value of external pressure, outlet of pressure should be in limits  $7 \pm 0.1$  mPa (70 ± 1 atm) with air pressure in cylinder 9-15 mPa (90-150 atm). Inspect readings on manometer Pos. 48.
3. Bend tube of hose pipes pos. 7, 8, 9, 10, 11, 13, 15, 21, 22, 24 as per standard specimen.
4. Assembly of pneumatic equipments should be checked for strength and air tightness of all hose pipe joints and sleeve of supply of air as per method point 3.2.14 and point 3.2.15 Ak-630, AK - 630M TU in contents AU.
5. Coating of tubes of hose pipes Pos. 7, 8, 9, 10, 11, 13, 15, 21, 22, 24. Prime AK-070 Yellow(2) Enamel khz - 124 grey (4), IV, Om.
6. AK-070 GOST 25718-83 Khv - 124 GOST 10144-89  
Coating of hinge nuts and projected surfaces of boss beyond nut is permissible.  
Check serviceability of electric air valve Pos. 50 and three valves Pos. 3 at temperature  $20 \pm 5$  °C after tightening and tying of bolts with wire during which minimum operating voltage should be ensured with pressure  $7 \pm 0.1$  mPa (70 ± 1 atm) but not more than 20V and during absence of pressure should not be more than 22V - consumption of current force at voltage 24V should not be more than 3.5 atm; leakage of air in non operating position at pressure  $7 \pm 0.1$  mPa (70 ± 1 atm) is not permissible. Value should not be switched for more than 60 sec during checking.  
Check assembled GM as per method point 3.2.14 and 3.2.15 on AK-630, AK-630M TU.
7. Tube of hose pipes should not pass near 5 mm from device article aggregates on which they are not fastened.
8. Local clearance between tubes and carriage not less than 3 mm is permissible at places of passing of hose pipes pos. 10, 11 through holes of carriage.
9. Blow hose Pos. 14, 16, 17 three dimensionally from ends with air pressure 6 mPa (60 atm) for 30 seconds before setting on article.
10. Carrying out assembly of set of elements on front magazine section AK-630 Sb 01.2, similarly on view ж and in section E-E during assembly of pneumatic feed belt booster AK-630M Sb 02 is permissible.
11. Carry out drainage of condensate from cylinder oil-moisture separator before sending article for approval test and service.
12. Straightening of casting Pos. 12 for ensuring dimension E is permissible.
13. During assembly for avoiding damage of locking device and serviceability of electrical air valve Pos. 50 and valve to be used in assembly pos. 3 during tightening and detaching of hinge nut of hose pipes and hose, is held with second wrench for avoiding rotation of pipe union valve.
14. Bending of tube at place during assembly is permissible.
15. Protect hose pipe ends AK - 630M Sb 02-3 Sb, AK-630 Sb 114-14 Sb, AK-630 Sb 114-21-01 SB, AK - 630 Sb 114-22-01 SB, AK - 630 Sb 114-29 sb, with stop plug AK-630 YO 100-30 IT, AK-630 YO 100-302T, AK-630 YO 100-303T, AK-630 100-304T.

E-E(1:1)



First contents  
 Refer. No.  
 Sign & Date  
 Alternates Inv. No. Duplicate Inv. No. Sign & Date  
 Inv. No. Sign & Date

				AK-630 SB 114 SB			
Amend	Sheet	Doc. No.	Sign	Date	Type	Weight	Scale
Developed by					A	23.00	1:2
Checked by					Sheet 1 Sheets 1		
Technician							
Head of bureau							
Head of O.C.D.							
Approved by							
					Steel 20X13 GOST 5632-72		
Format A0							



First use

Reference No.

Sign and Date

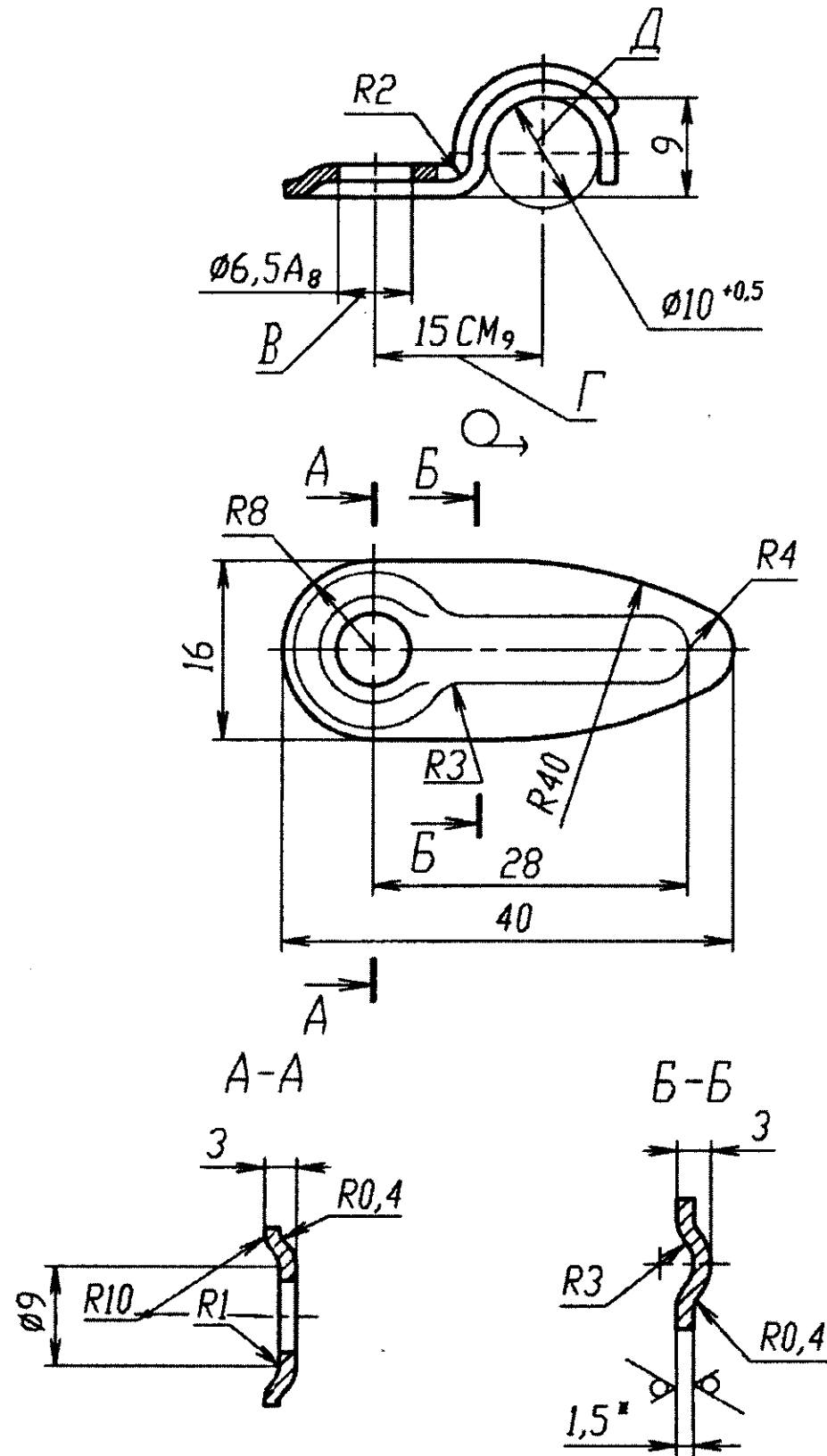
Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

Rz80  
✓(✓)



1. Substitute material Sheet  $\frac{B - PN - 01.5GOST19903 - 74}{K390 - III - 25GOST16523 - 97}$
2. \* Reference dimension.
3. Dimensions ensured by tool, except dimensions B, Γ, Д.
4. Blunt sharp edges ~0.4 mm.
5. Maximum deviation of dimensions: holes- as per A<sub>7</sub>; shafts- as per B<sub>7</sub>; others- as per CM<sub>7</sub> unless otherwise specified.
6. Coating Cd12.phos.  
Lacquer BF-4 with Nigrozene, 2 coats, made as per OST3-4123-78, IV, OM2.
7. Mark Ш, Ч and stamp K on tag.

					AK-630 114-1			
Amend.	Sheet	Doc.No.	Sign	Date	Clamp	Type	Weight	Scale
Developed by						A	0.005	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Sheet $\frac{BT - PN - 0 - 1GOST19904 - 90}{K390V4 - III - 25GOST16523 - 97}$			
Approved by								

First use

Reference No.

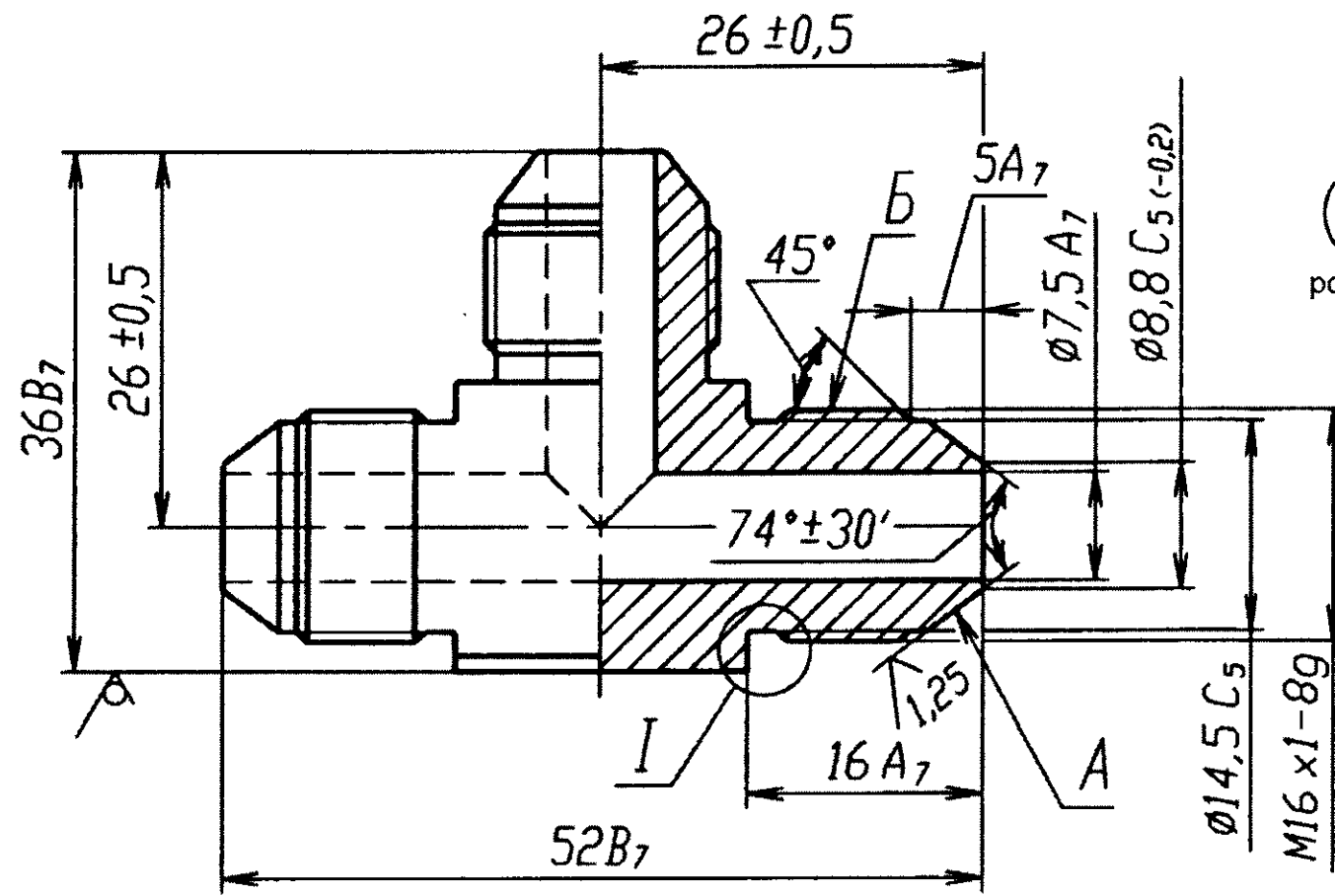
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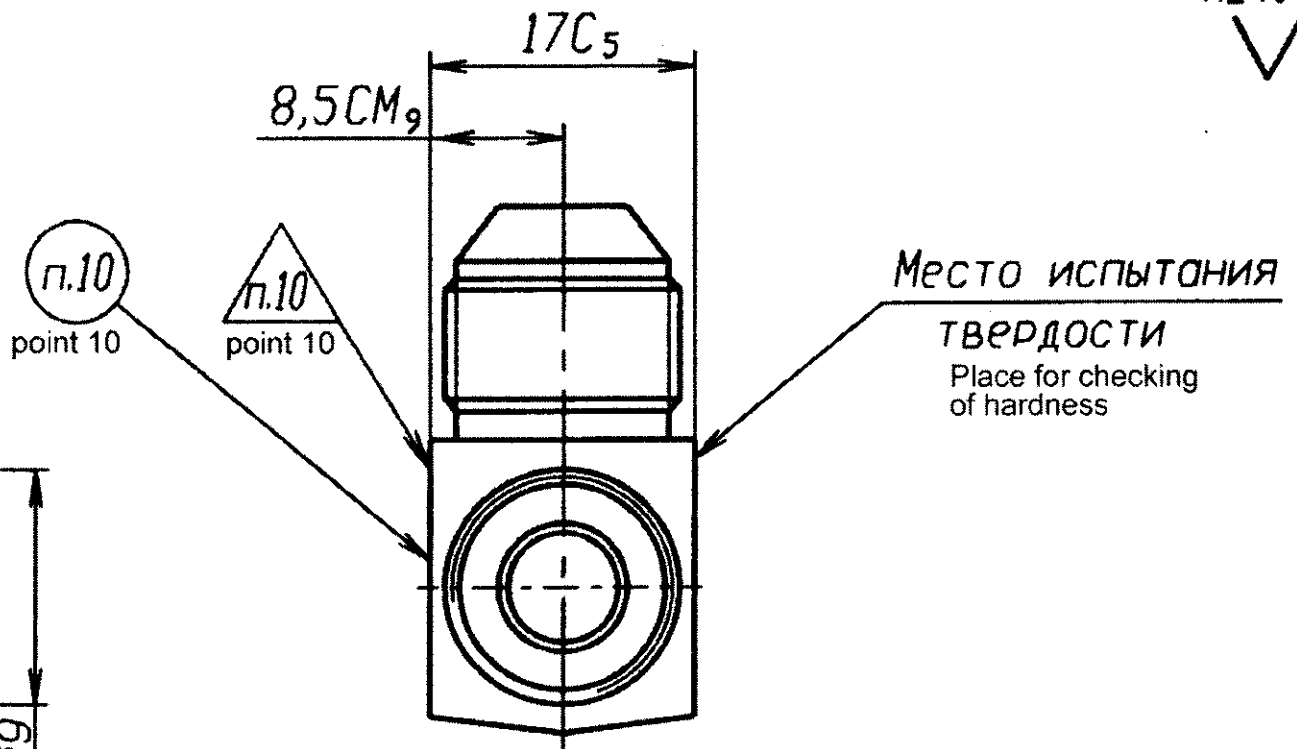
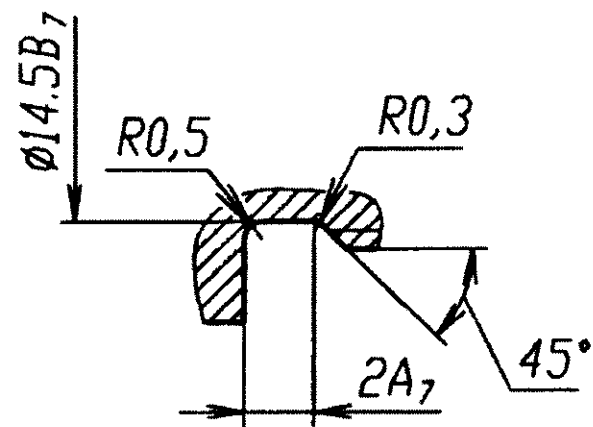
Alternate Inv. No

Sign and Date

Orig. inv. no.



I(5:1)



Rz40  
✓ (✓)

1. Substitute material- Steel 40 Kh GOST 4543-71.
2. 34...39.5 HRC<sub>E</sub>.
3. Blank- forging accuracy class T5 as per GOST 7505-89. Surface defects on un machined surfaces should not be larger than 0.5 mm in depth.
4. Forging gradient up to 7°.
5. Forging radii ~3 mm.
6. Inner angles R~0.4 mm.
7. Blunt sharp edges ~0.4 mm.
8. Run out of surface A with respect to mean diameter of thread B is not more than 0.05 mm.
9. Coating Cd6. phos.oil.
10. Mark Ш,Ч and stamp K, И as per AK-630, AK-630M TU I.

					AK-630 114-4			
Amend.	Sheet	Doc.No.	Sign	Date	Passage T-joint	Type	Weight	Scale
Developed by						A	0.083	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Steel 50 GOST 1050-88			
Approved by								

First use

Reference No.

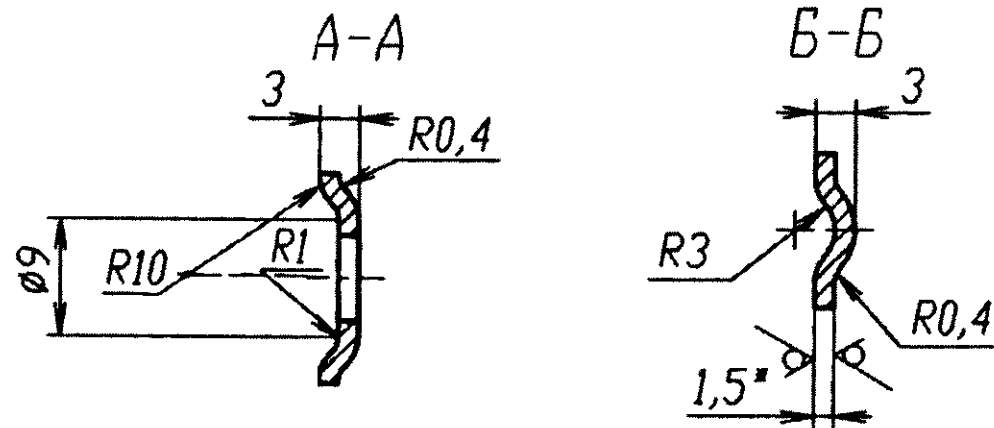
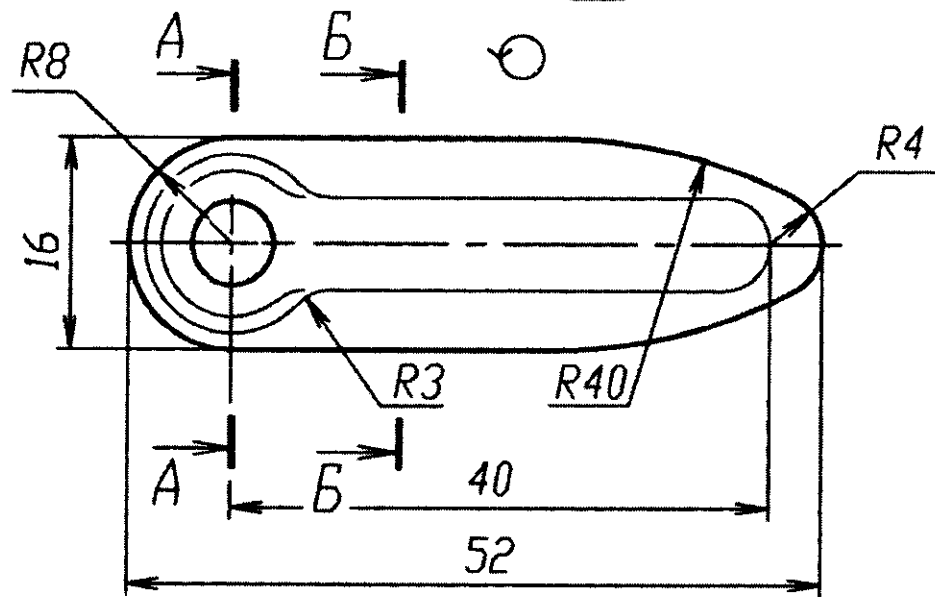
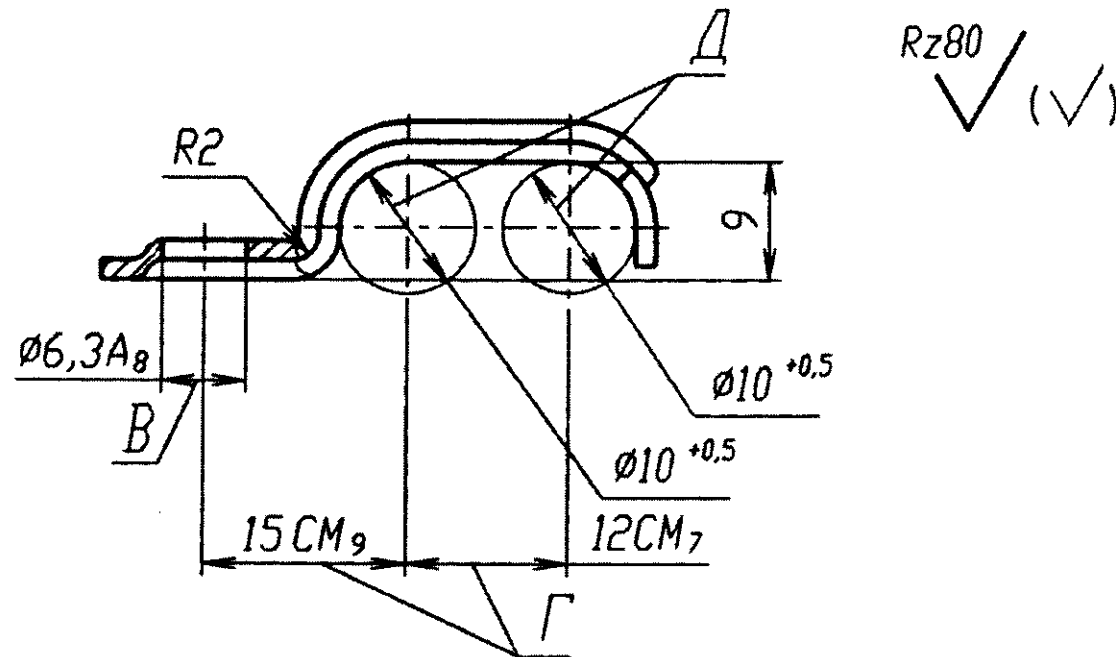
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. Substitute material: Sheet  $\frac{B - PN - 01.5GOST19904 - 90}{K390V4 - III - 25GOST16523 - 97}$
- 2.\* Reference dimension.
3. Dimensions ensured by tool, except dimensions B,Г,Д.
4. Blunt sharp edges ~ 0.4 mm.
5. Maximum deviation of dimensions: holes- as per A<sub>7</sub>; shafts- as per B<sub>7</sub>; others- as per CM<sub>7</sub> unless otherwise specified.
6. Coating Cd12.phos.  
Lacquer BF-4 with Nigrozene, 2 coats, made as per OST3-4123-78, IV, OM2.
7. Mark Ш, Ч and stamp K on tag.

					AK-630 114-5		
					Clamp		
Amend.	Sheet	Doc.No.	Sign	Date			
Developed by					A	0.007	2:1
Checked by					Sheet	Sheets	1
Head of Q.C.D					Sheet $\frac{BT - PN - 01.5GOST19904 - 90}{K390V4 - III - 25GOST16523 - 97}$		
Approved by							

AK-630 114-6

First use

Reference No.

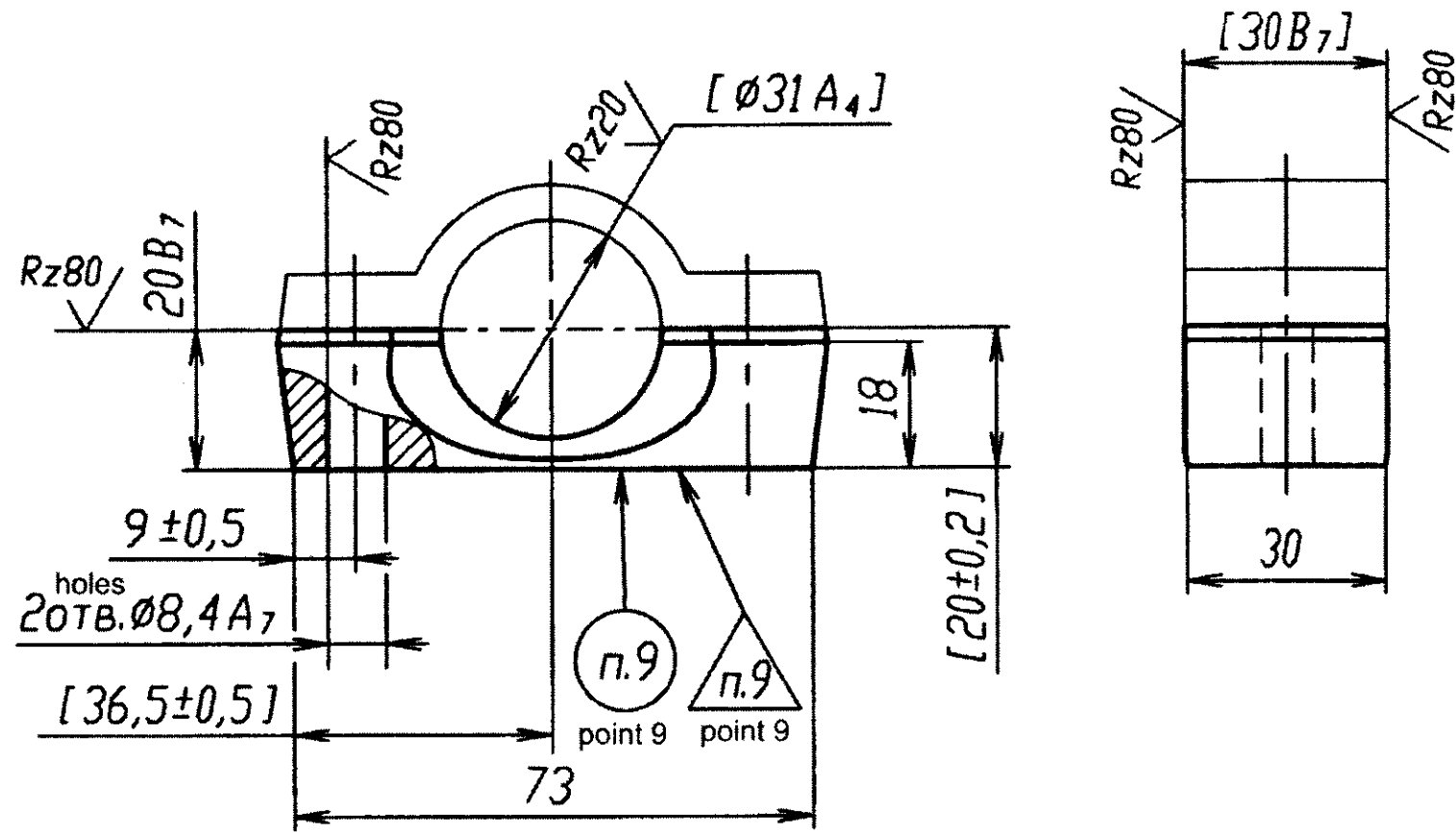
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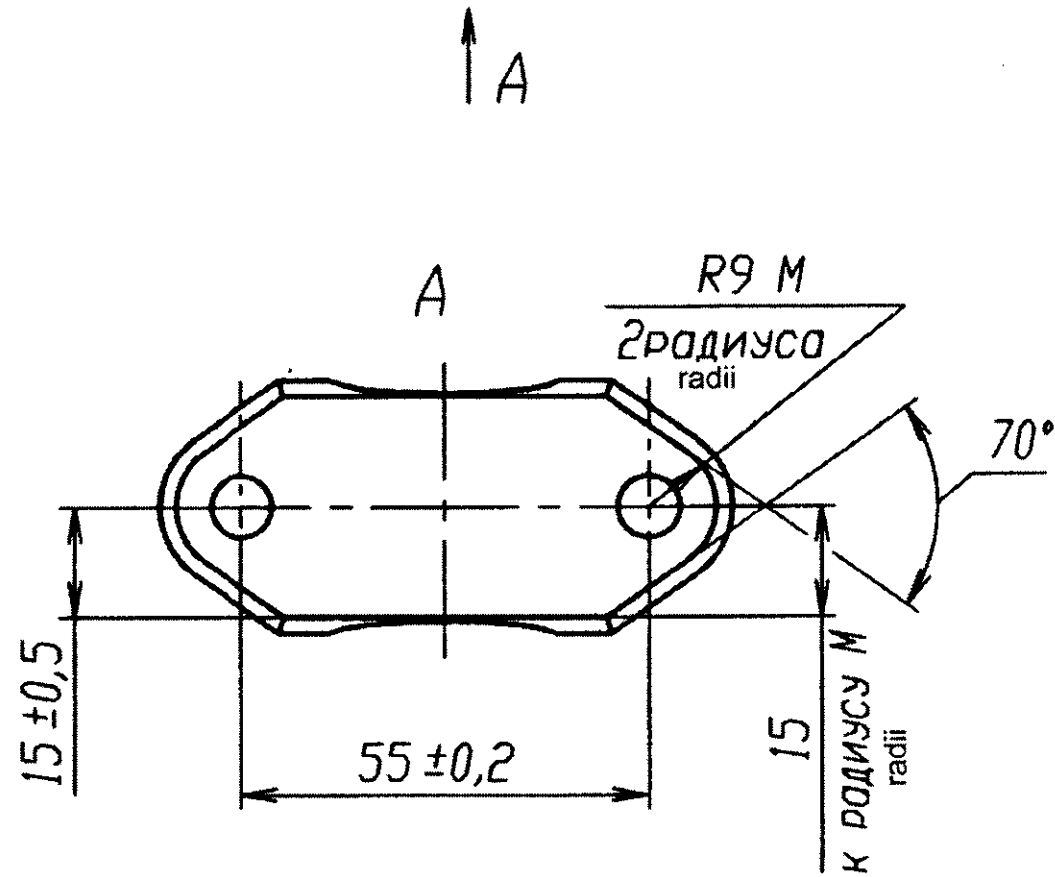
Alternate Inv. No

Sign and Date

Orig. inv. no.



1. Substitute material- alloy AMg6 GOST 4784-97
2. Forging gradient 7° unless otherwise specified.
3. Maximum deviation of dimensions obtained by forging by 6 th class OST 1.41187-78 unless otherwise specified.
4. Surface defects should not be larger than 0.3 mm in depth.
5. Check forged blanks by 3<sup>rd</sup> inspection group OST 92-1008-77 by checking hardness 100%.
6. Carry out machining for dimensions in square brackets together with component AK-630 114-7 and mark similarly.
7. Blunt sharp edges ~0.6 mm.
8. Coating Anodic Oxid.Cr. Primer AK-070, yellow (2) Enamel KhV-124, gray (4), IV, OM2 AK-070 GOST 25718-83 KhV-124 GOST 10144-89.
9. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.



					AK-630 114-6			
Amend.	Sheet	Doc.No.	Sign	Date	Base plate	Type	Weight	Scale
Developed by						A	0.090	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Alloy D1 GOST 4784-97			
Approved by								

First use

Reference No.

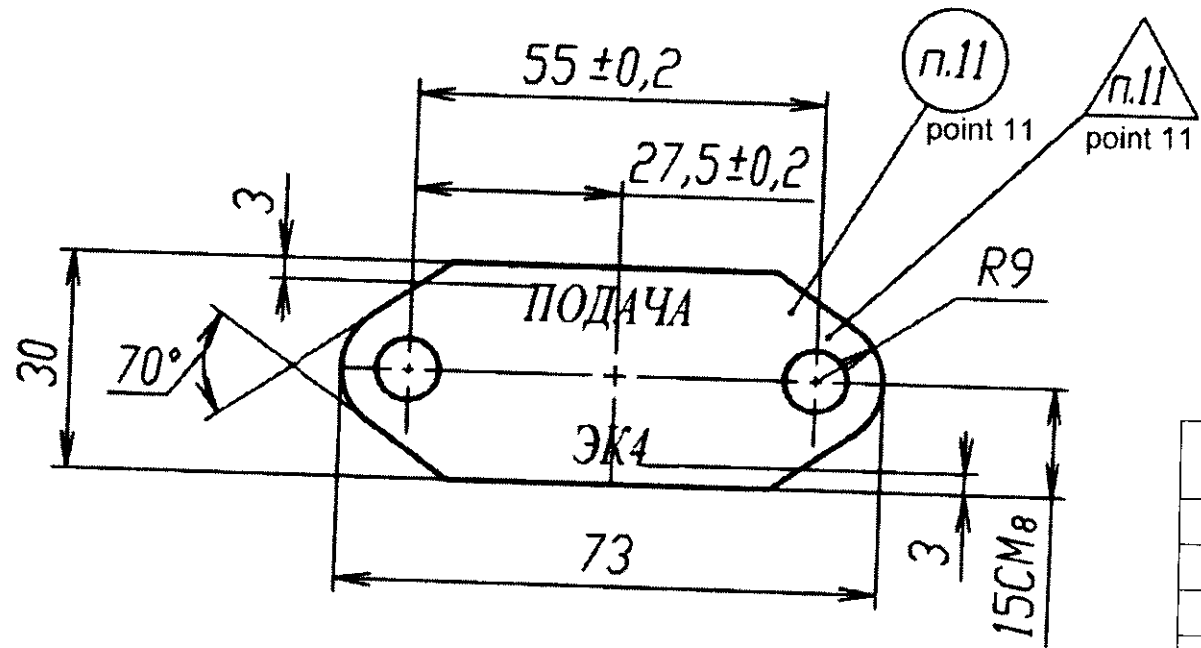
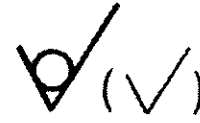
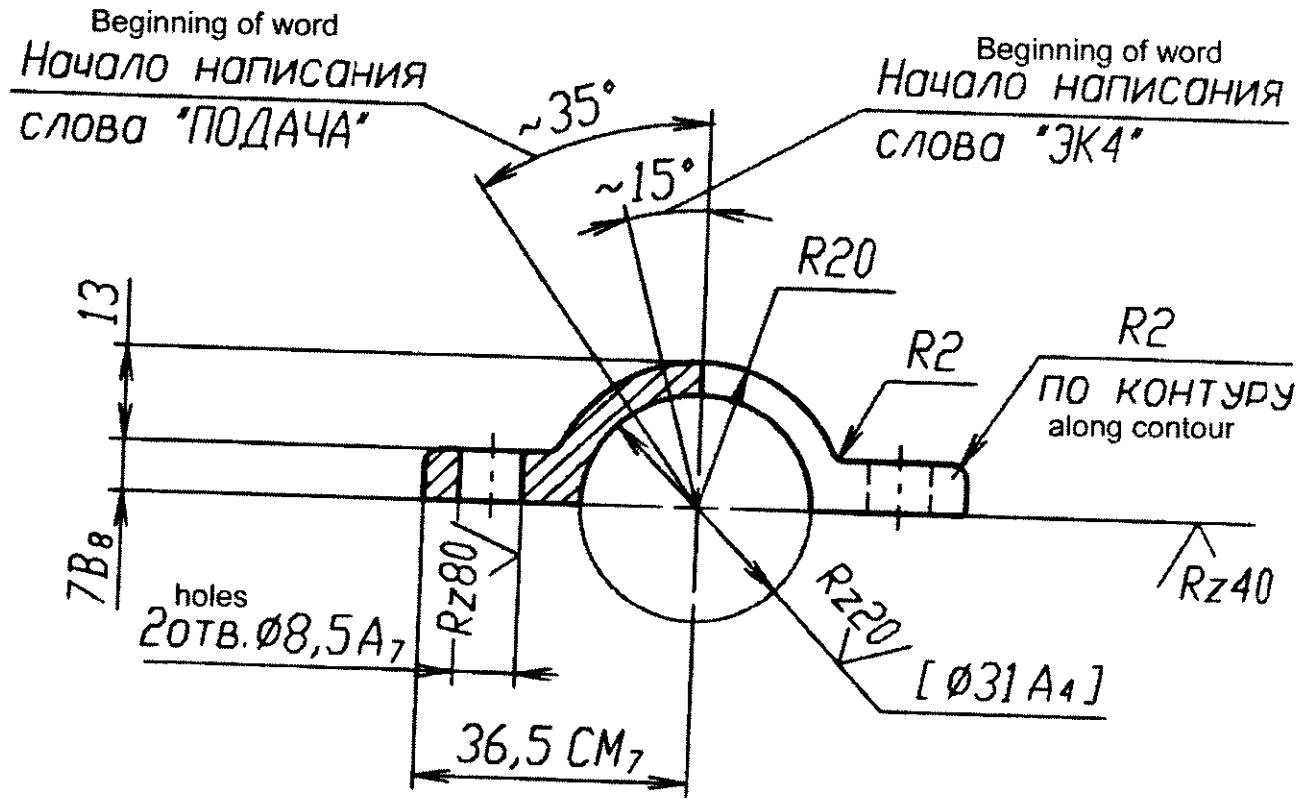
Sign and Date

Duplicate Inv. No.

Alternate Inv. No.

Sign and Date

Orig. inv. no.



1. Substitute material- alloy D16 GOST 4784-97.
2. Tolerance of forging dimensions as per 6 th accuracy class OST 1.41187-78.
3. Forging gradient up to 5°.
4. Check forged blanks by 3<sup>rd</sup> inspection group OST 92-1008-77 by checking hardness 100%.
5. Carry out machining for dimensions in square brackets together with component AK-630 114-6 and mark similarly.
6. Apply machined components together.
7. Engrave inscriptions. Letter size PO-5 GOST 2930-62.  
It is permissible to make inscriptions by strike stamping.
8. Blunt sharp edges ~0.4 mm.
9. Fill the engravings with enamel PF-115 black GOST 6465-76.
10. Coating Anodic Oxid.Cr.  
Primer AK-070, yellow (2)  
Enamel KhV-124, gray (4), IV, OM2  
AK-070 GOST 25718-83  
KhV-124 GOST 10144-89.
11. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 114-7			
Amend.	Sheet	Doc. No.	Sign	Date	Clamp	Type	Weight	Scale
Developed by						A	0.040	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D						Alloy D1 GOST 4784-97		
Approved by								

First use

Reference No.

Sign and Date

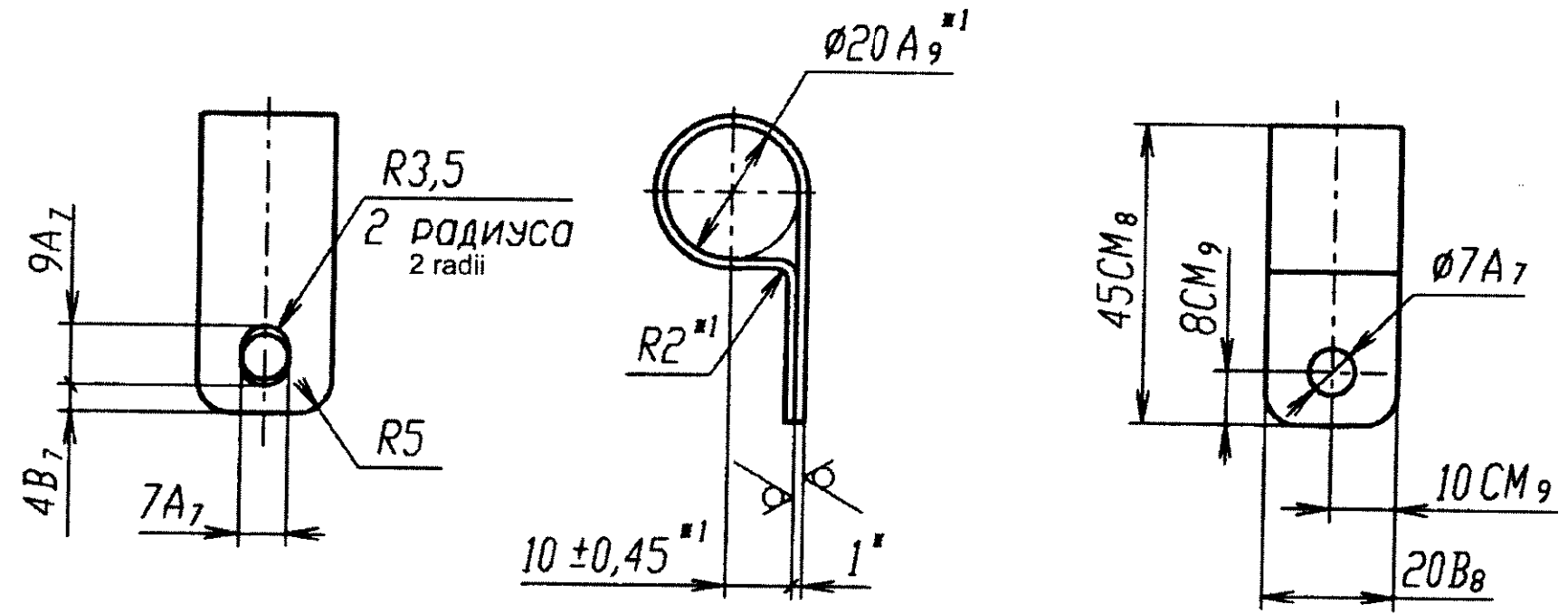
Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

Rz160  
✓(✓)



1. Unrolled length L = 116 mm.
- 2.\* Reference dimension.
- 3.\*1 Check dimensions in compressed condition.
4. Blunt sharp edges ~0.4 mm.
5. Coating Cd.12.phos.  
Lacquer BF-4 with Nigrozene, two coats, made as per OST 3-4123-78, IV, OM2.
6. Mark Ш, Ч and stamp K on tag.

					AK-630 114-9			
Amend.	Sheet	Doc. No.	Sign	Date	Clamp	Type	Weight	Scale
Developed by						A	0.025	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by					Sheet	BT - PN - 01GOST19904 - 90 K390V4 - III - 25GOST16523 - 97		

First use

Reference No.

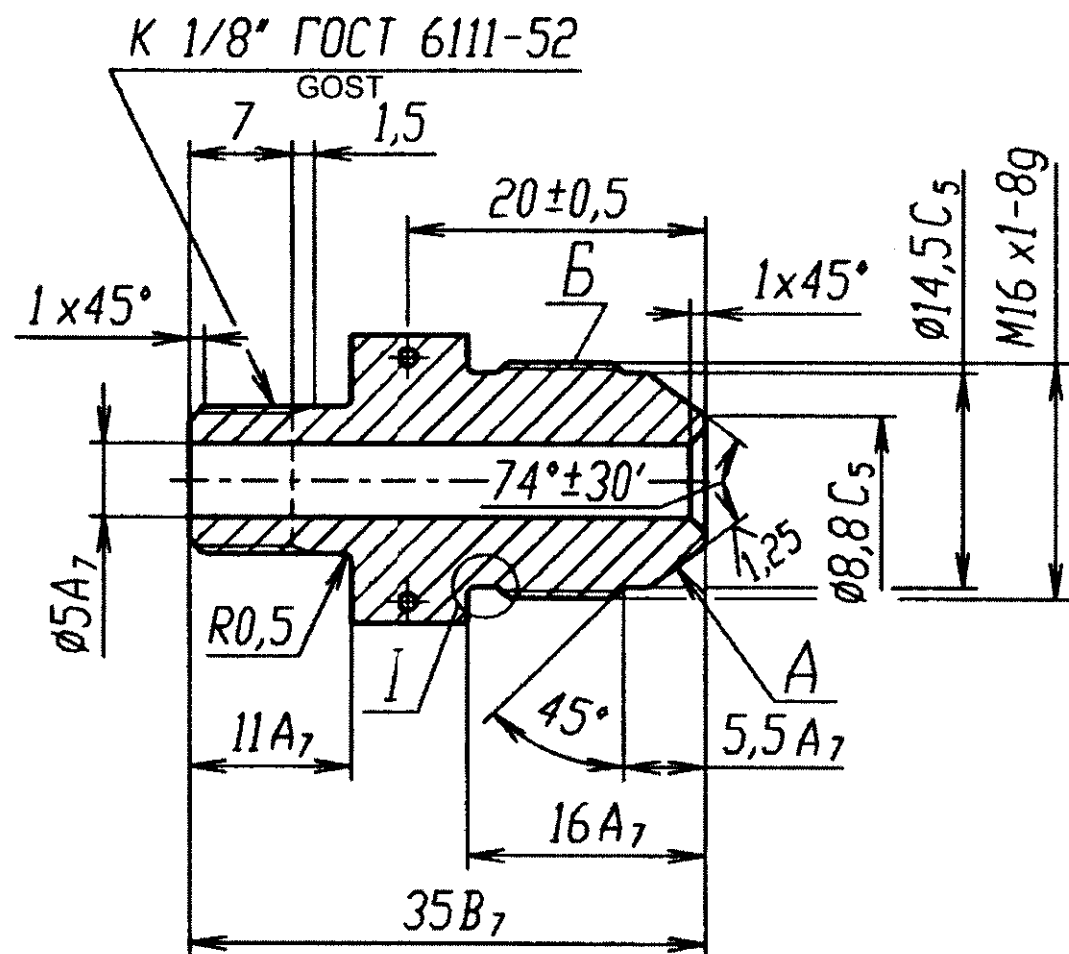
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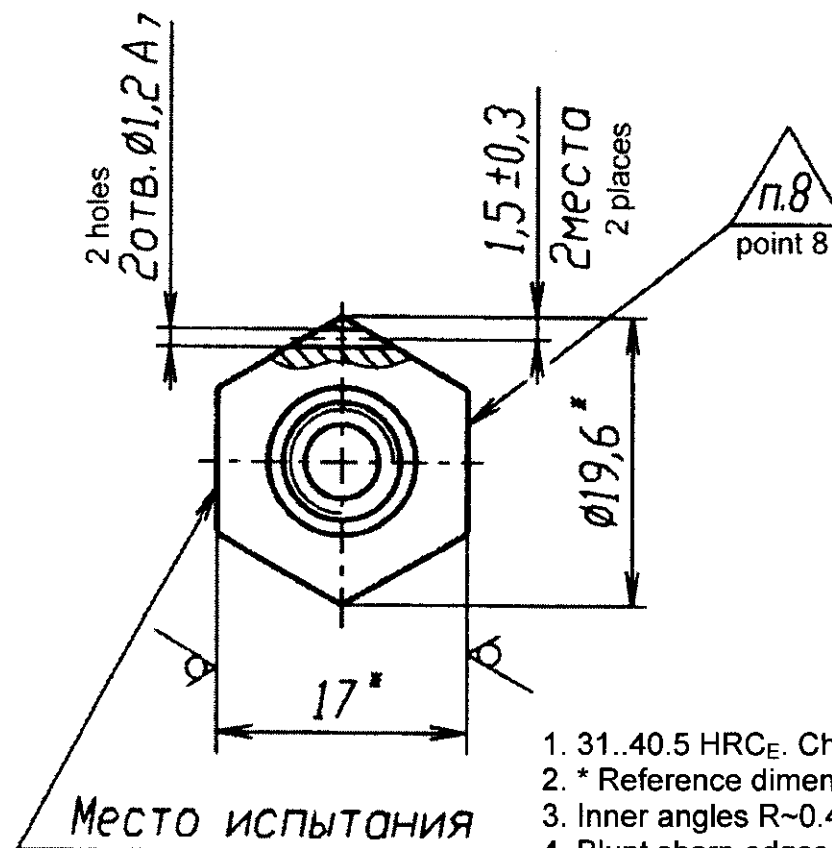
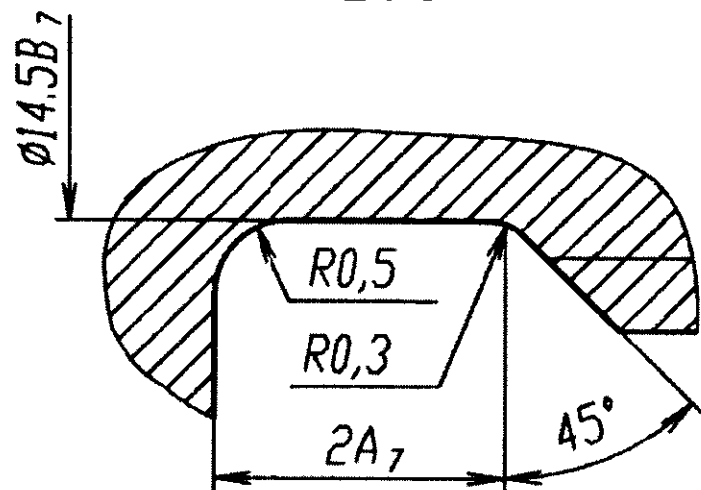
Alternate Inv. No

Sign and Date

Orig. inv. no.



I(20:1)



Место испытания  
ТВЕРДОСТИ  
Place for checking  
of hardness

1. 31..40.5 HRC<sub>E</sub>. Check 2...3% from the batch.
2. \* Reference dimensions.
3. Inner angles R~0.4 mm.
4. Blunt sharp edges ~0.4 mm.
5. Run out of surface A with respect to mean diameter of thread B not more than 0.05 mm.
6. Coating Cd6.phos.Oil.  
Absence of cadmium plating on inner surfaces is permissible.
7. Mark Ш, Ч and stamp K on tag.
8. Stamp И as per AK-630, AK-630M TU I.

AK-630 114-10

					Type	Weight	Scale	
Amend.	Sheet	Doc.No.	Sign	Date	Adaptor	A	0.080	2:1
Developed by								
Checked by								
Head of Q.C.D								
Approved by								
					Hexagon	17 - 5GOST8560 - 78 40Kh - T - VGOST1051 - 73		
					Sheets 1			

First use

Reference No.

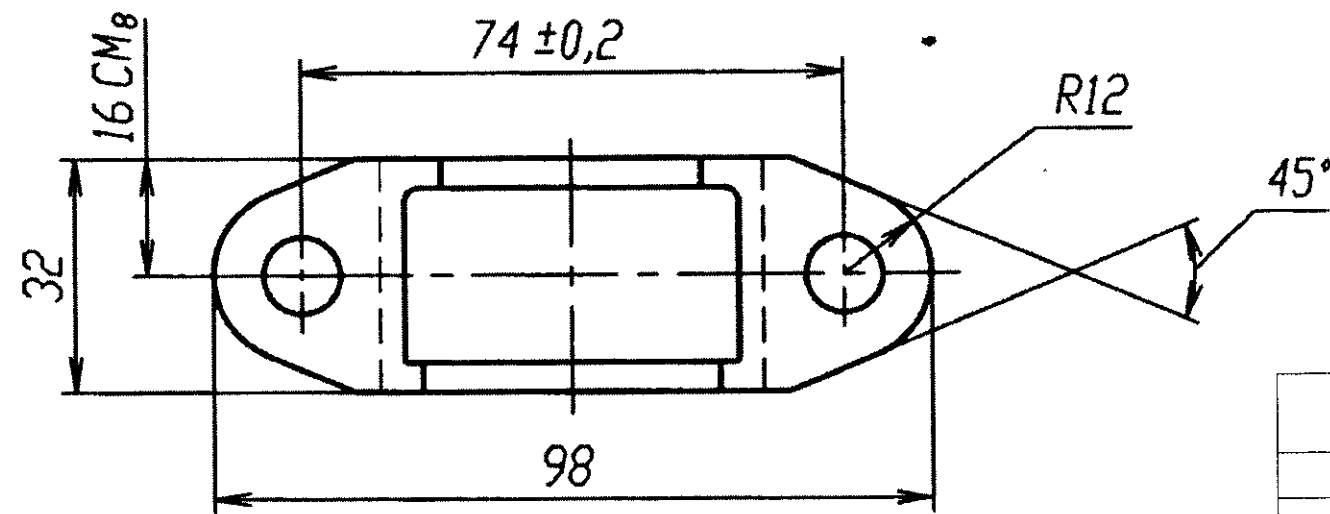
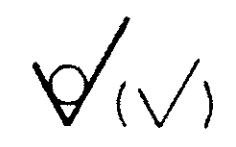
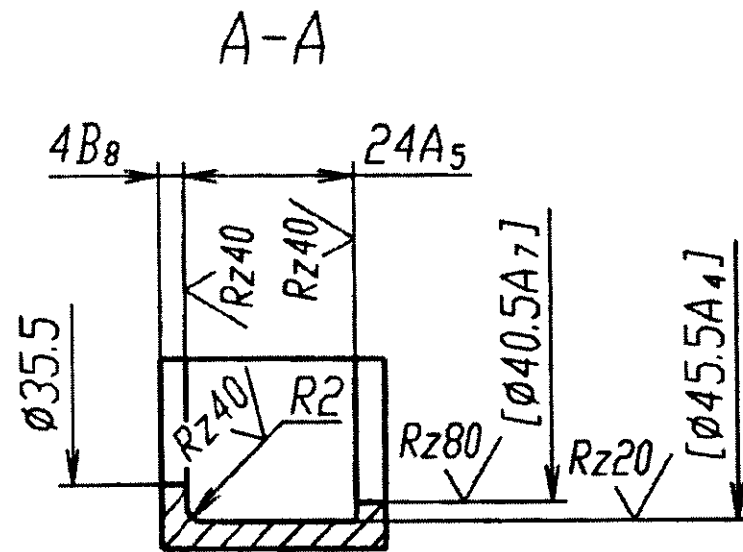
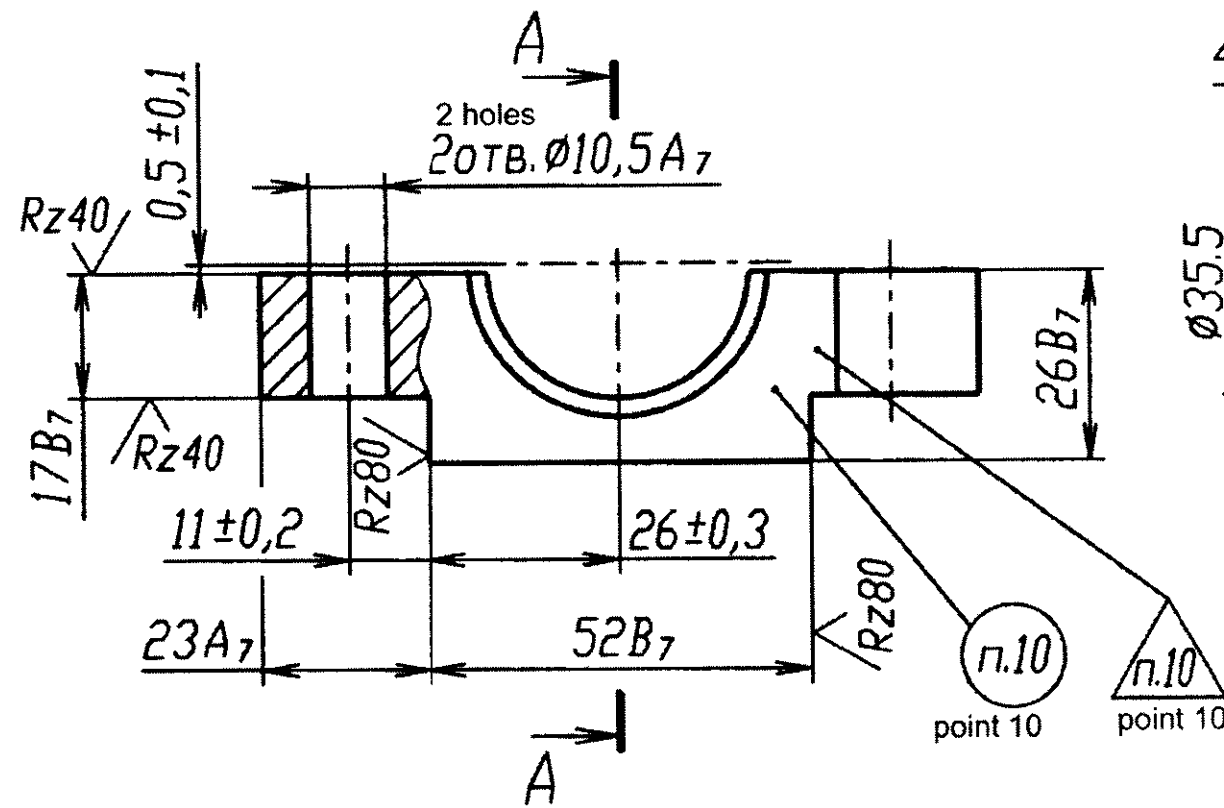
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. Substitute material- alloy D16 GOST 4784-97
2. Maximum deviation of dimensions obtained by forging by 6 th class OST 1.41187-78 unless otherwise specified.
3. Forging gradient up to 5°
4. Check forged blanks by 3<sup>rd</sup> inspection group OST 92-1008-77 by checking hardness 100%.
5. Carry out machining of dimensions in square brackets together with component AK-630 114-12.
6. Apply machined components together.
7. Inner angles R~0.4 mm.
8. Blunt sharp edges ~0.6 mm.
9. Coating Anodic Oxid.Cr.  
Primer AK-070, yellow (2)  
Enamel KhV-124, gray (4), IV, OM2  
AK-070 GOST 25718-83  
KhV-124 GOST 10144-89.
10. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 114-11			
Amend.	Sheet	Doc.No.	Sign	Date	Base plate	Type	Weight	Scale
Developed by						A	0.150	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Alloy D1 GOST 4784-97			
Approved by								



First use

Reference No.

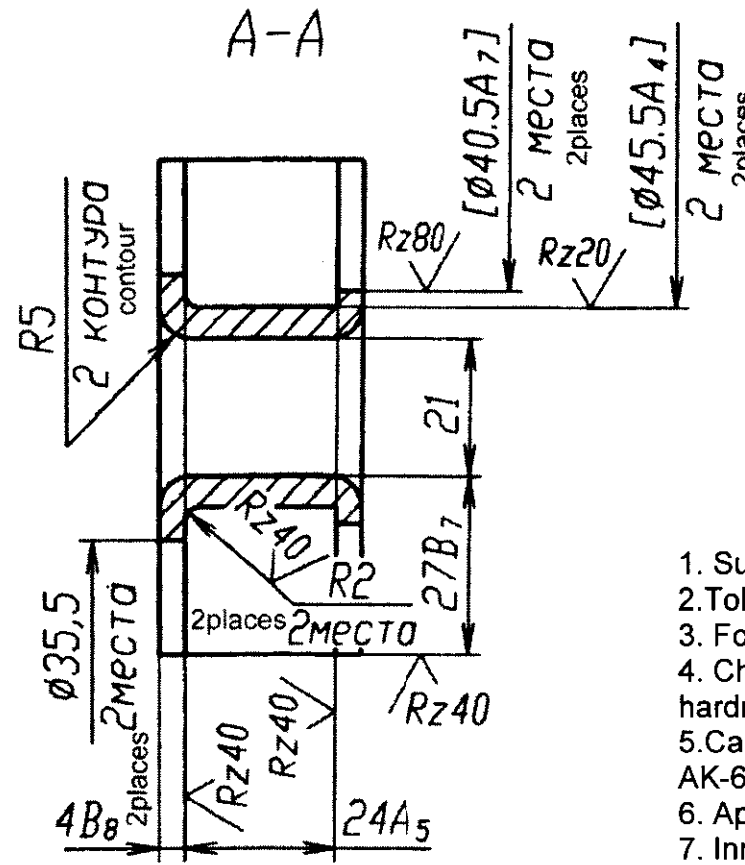
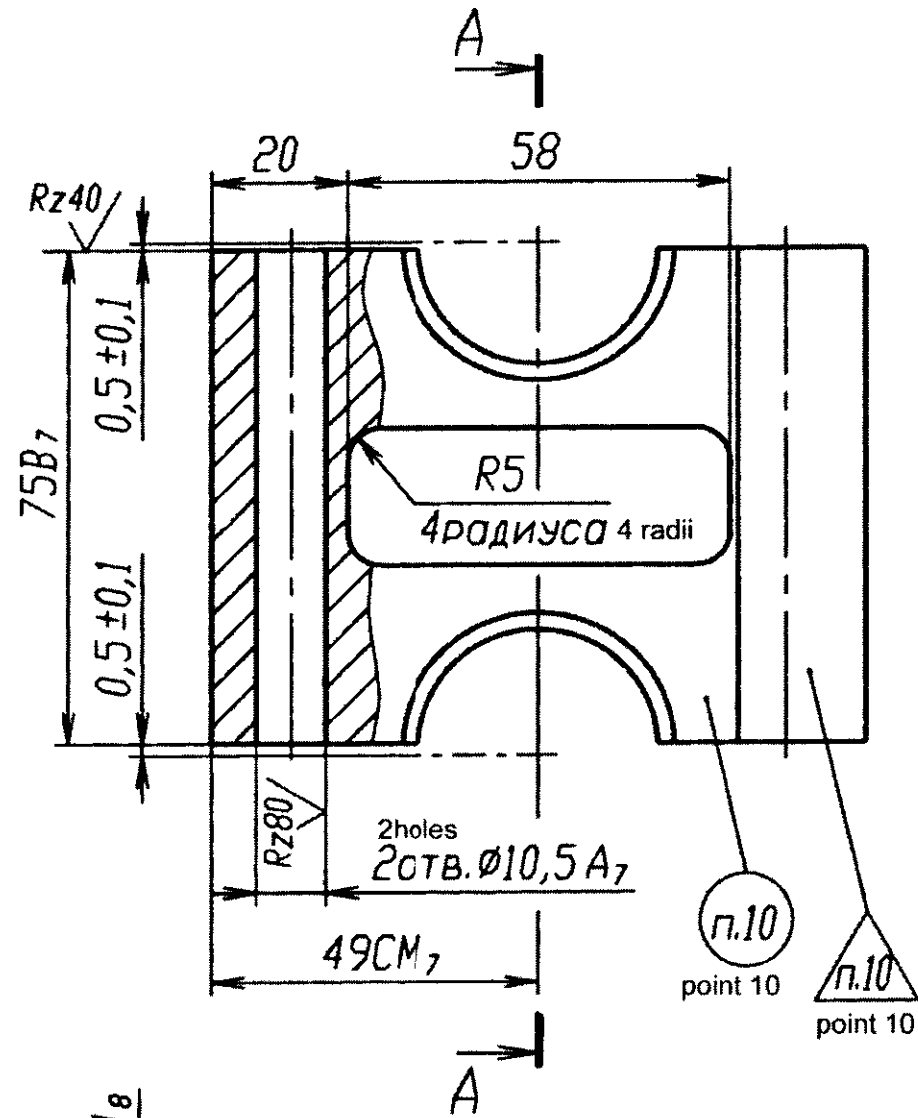
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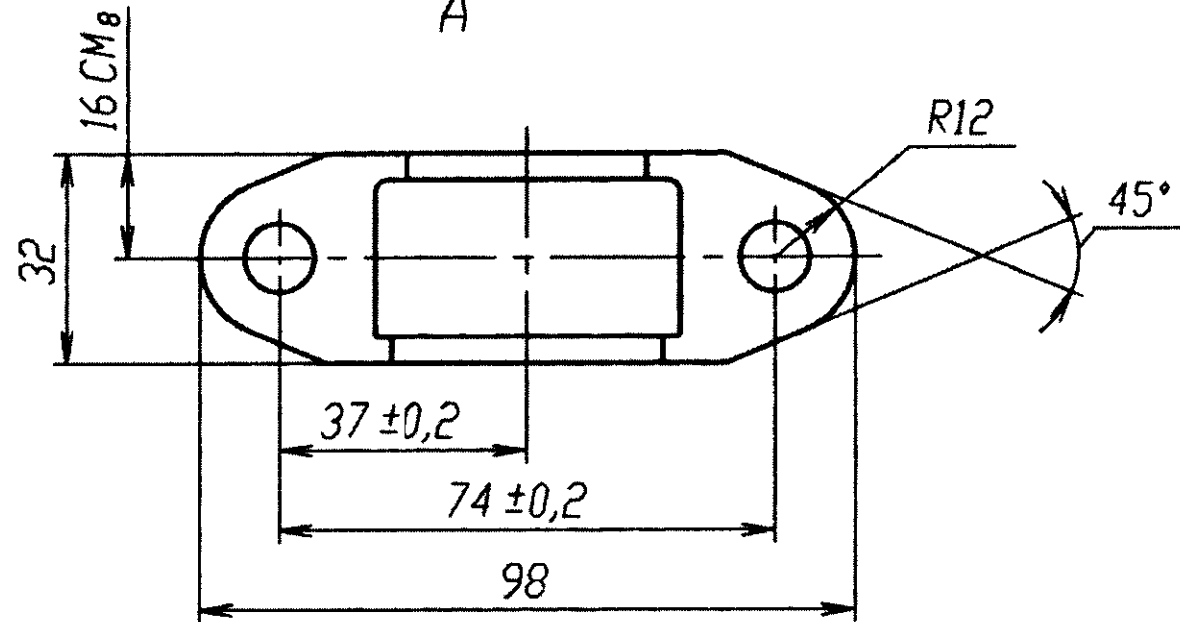
Alternate Inv. No

Sign and Date

Orig. inv. no.



✓(✓)



1. Substitute material- alloy D16 GOST 4784-97.
2. Tolerance for forging dimensions as per 6 th accuracy class OST 1.41187-78 .
3. Forging gradient up to 5° .
4. Check forged blanks by 3<sup>rd</sup> inspection group OST 92-1008-77 by checking hardness 100%.
5. Carry out machining of dimensions in square brackets together with component AK-630 114-11 and AK-630 114-13.
6. Apply machined components together.
7. Inner angles R~0.4 mm.
8. Blunt sharp edges ~0.4 mm.
9. Coating Anodic Oxid.Cr.  
Primer AK-070, yellow (2)  
Enamel KhV-124, gray (4), IV, OM2  
AK-070 GOST 25718-83  
KhV-124 GOST 10144-89.
10. Mark Ш , Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 114-12			
Amend.	Sheet	Doc.No.	Sign	Date	Insert	Type	Weight	Scale
Developed by						A	0.315	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Alloy D1 GOST 4784-97			
Approved by								

AK-630 114-13

First use

Reference No.

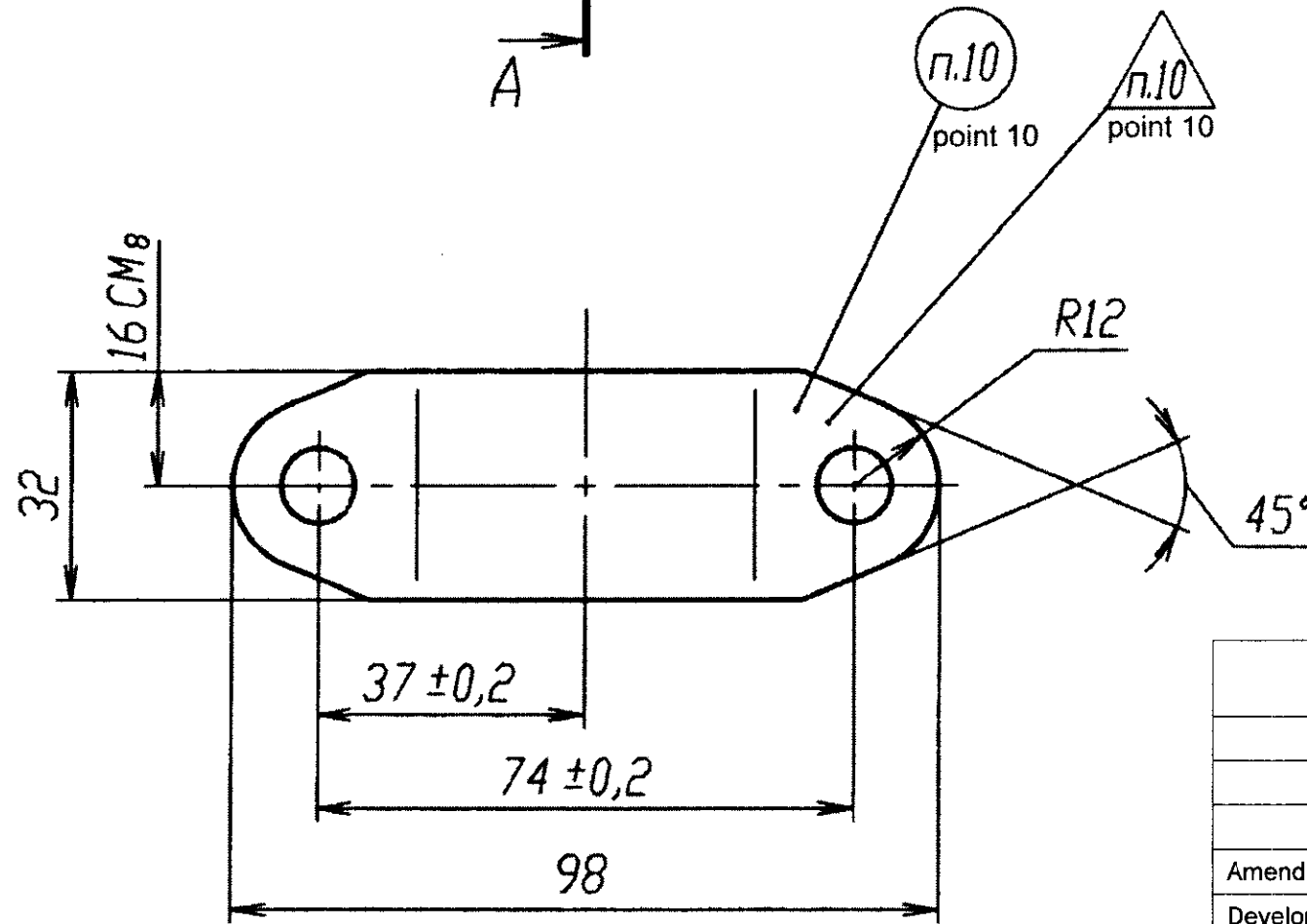
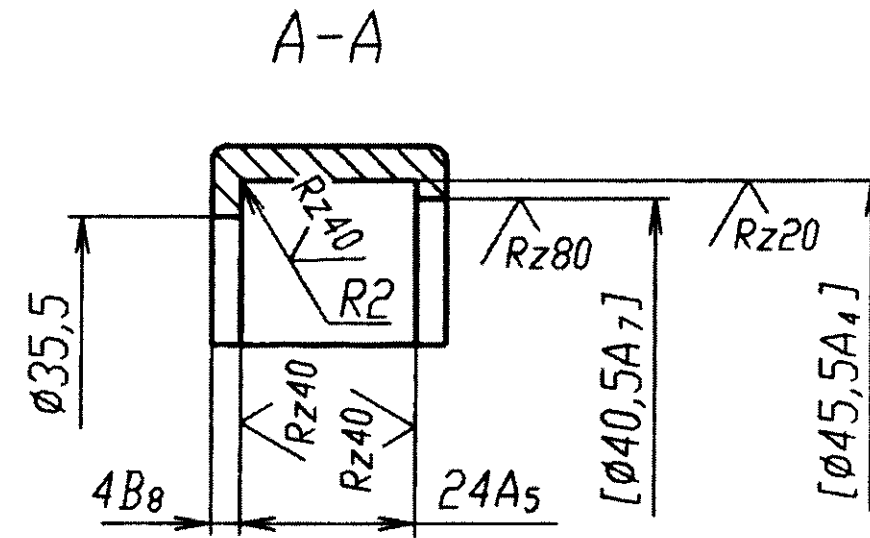
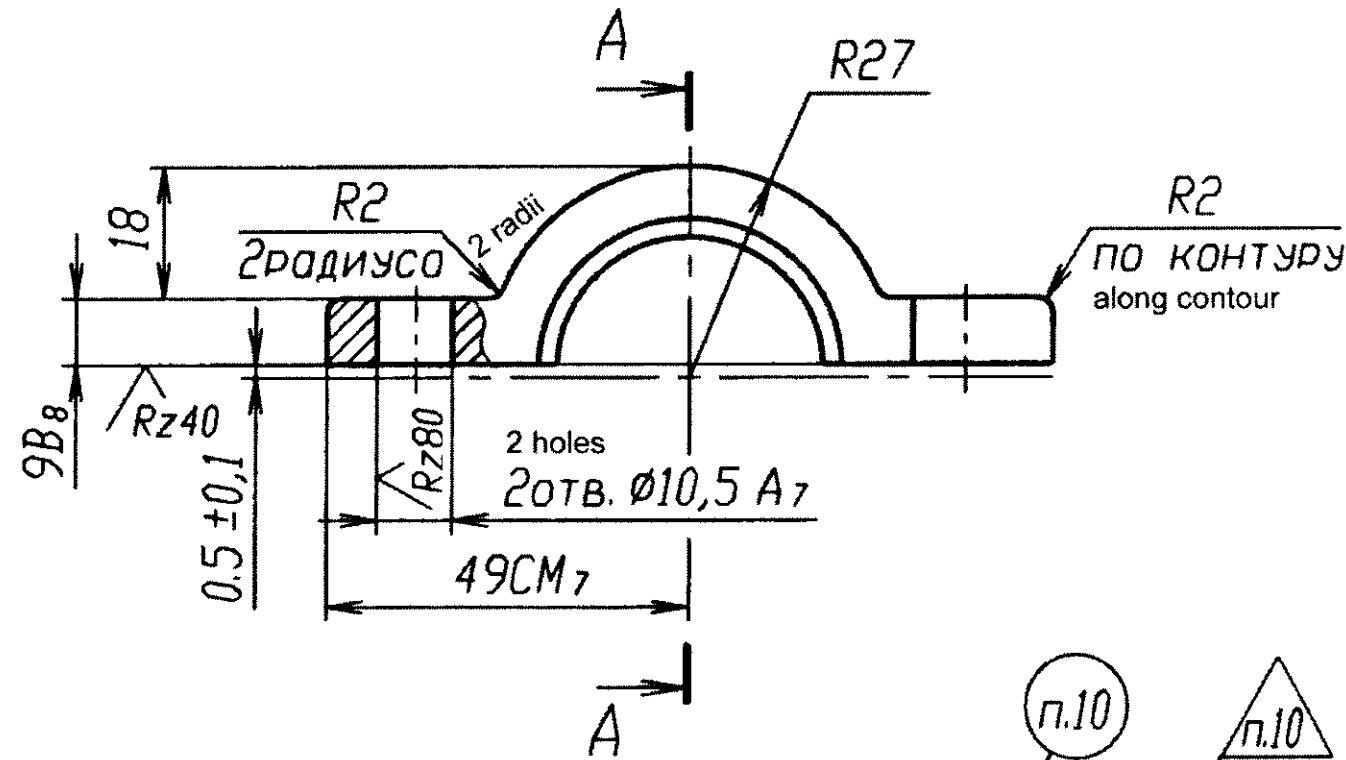
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. Substitute material- alloy D16 GOST 4784-97.
2. Tolerance for forging dimensions as per 6 th accuracy class OST 1.41187-78 .
3. Forging gradient up to 5° .
4. Check forged blanks as per 3<sup>rd</sup> inspection group OST 92-1008-77 by checking hardness 100%.
5. Carry out machining of dimensions in square brackets together with component AK-630 114-12.
6. Apply machined components together.
7. Inner angles R~0.4 mm.
8. Blunt sharp edges ~0.4 mm.
9. Coating Anodic Oxid. Cr.  
Primer AK-070, yellow (2)  
Enamel KhV-124, gray (4), IV, OM2  
AK-070 GOST 25718-83  
KhV-124 GOST 10144-89.
10. Mark Ш , Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 114-13			
Amend.	Sheet	Doc.No.	Sign	Date	Cover	Type	Weight	Scale
Developed by						A	0.060	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Alloy D1 GOST 4784-97			
Approved by								

First use

Reference No.

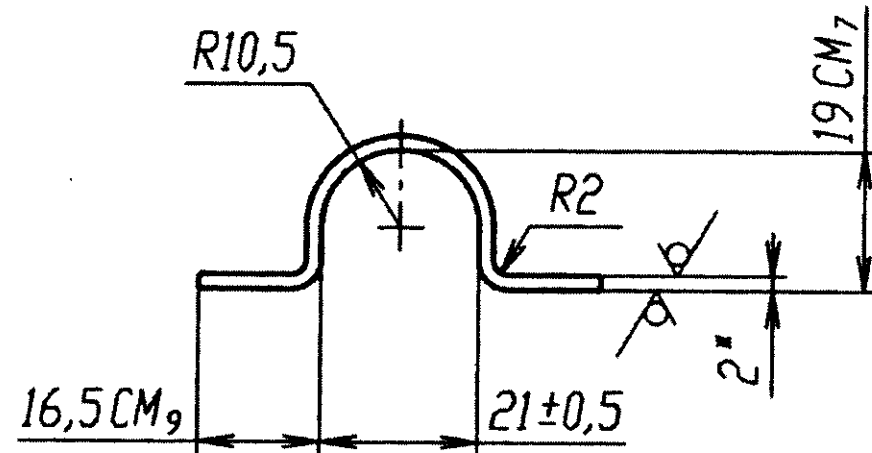
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

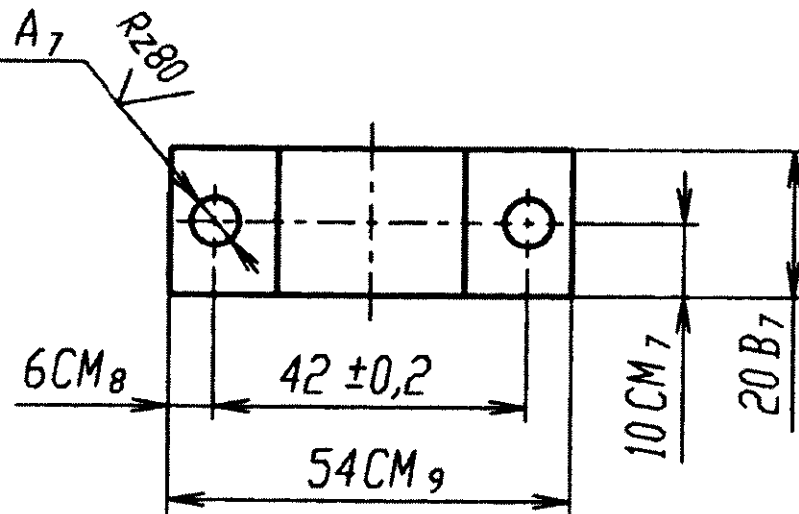
Orig. inv. no.



Rz160  
✓ (✓)

2 holes

20TB. Ø6,5 A7



1. \* Reference dimension.
2. Blunt sharp edges ~0.4 mm.
3. Unrolled length L = 80 mm.
4. Coating Cd.12.phos.  
Lacquer BF-4 with Nigrozene, two coats, made as per OST 3-4123-78, IV, OM2.
5. Mark Ш, Ч and stamp K on tag.

					AK-630 114-16			
Amend.	Sheet	Doc. No.	Sign	Date	Clamp	Type	Weight	Scale
Developed by						A	0.080	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Sheet	<i>B - PN - 02GOST19903 - 74</i> <i>K390V4 - III - 25GOST16523 - 97</i>		
Approved by								

First use

Reference No.

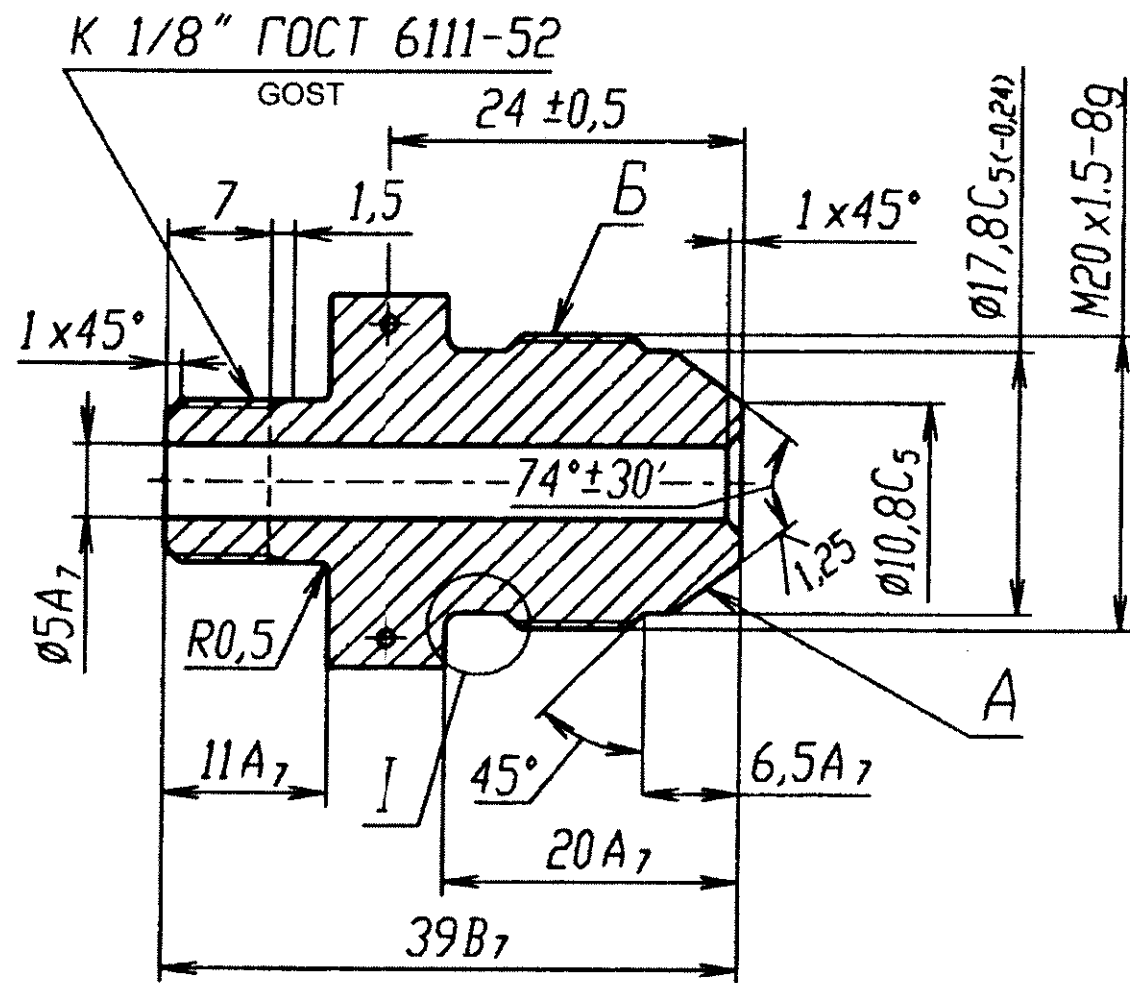
Sign and Date

Duplicate Inv. No

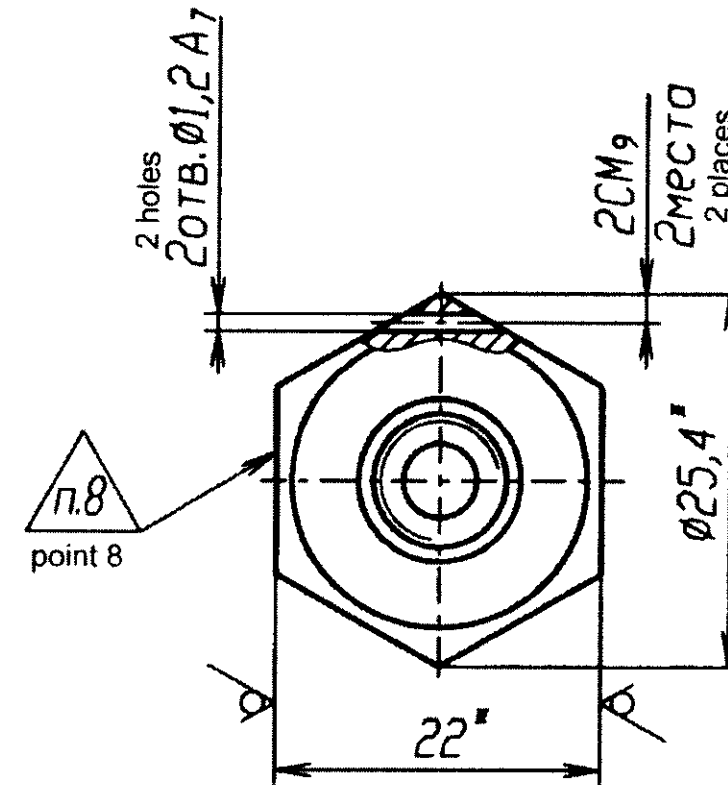
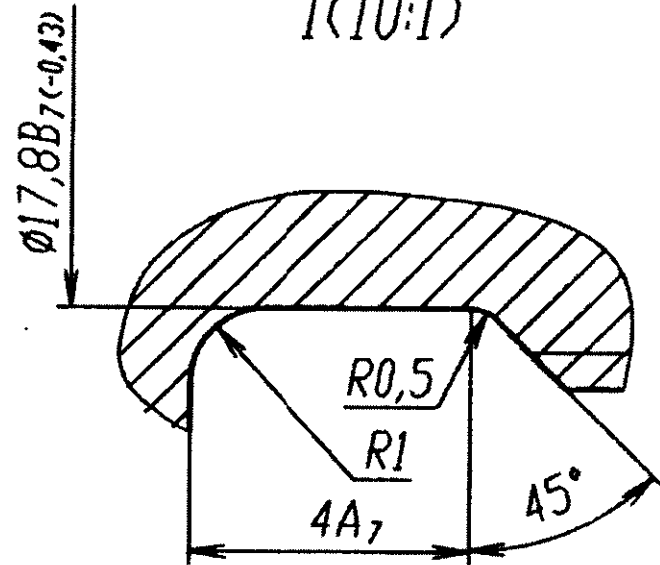
Alternate Inv. No

Sign and Date

Orig. inv. no.



I(10:1)



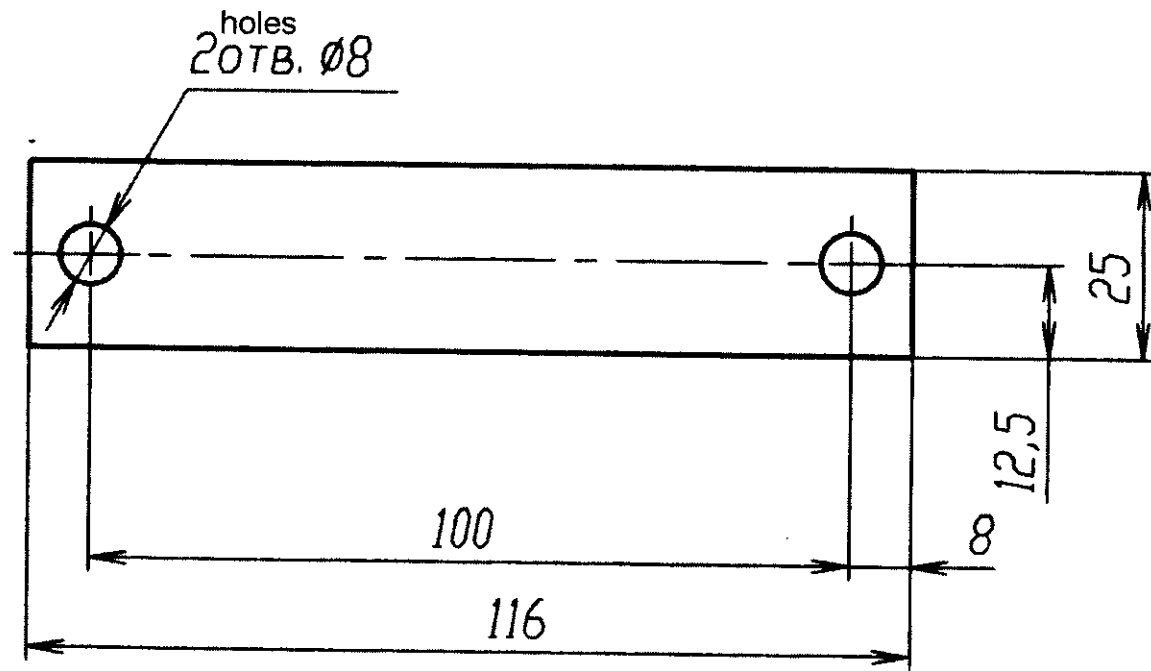
Rz40  
✓ (✓)

1. 31..40.5 HRC<sub>E</sub>. Check 2...3% from the batch.
2. \* Reference dimensions.
3. Inner angles R~0.4 mm.
4. Blunt sharp edges ~0.4 mm.
5. Run out of surface A with respect to mean diameter of thread B not more than 0.05 mm.
6. Coating Cd6.phos.Oil.  
Absence of cadmium plating on inner surfaces is permissible.
7. Mark Ш, Ч and stamp K on tag.
8. Stamp И as per AK-630, AK-630M TU I.

					AK-630 114-14			
Amend.	Sheet	Doc.No.	Sign	Date	Adaptor	Type	Weight	Scale
Developed by						A	0.100	2:1
Checked by						Sheets 1		
Head of Q.C.D					Hexagon	$\frac{22 - 5GOST8560 - 78}{40Kh - T - VGOST1051 - 73}$		
Approved by								

AK-630 114-8

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



- 1.\* Reference dimension.
- 2. Dimensions ensured by tool as per accuracy class 7.
- 3.Mark Ш, Ч and stamp K on tag.

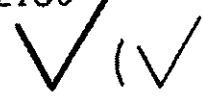
Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				

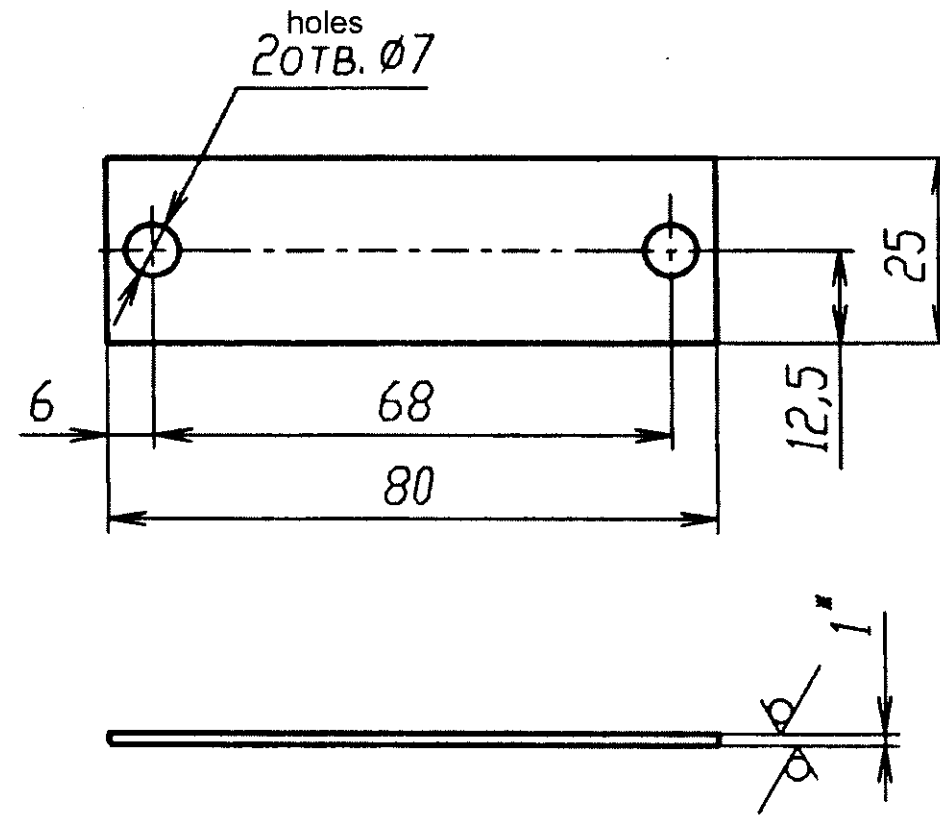
AK-630 114-8			
Gasket	Type	Weight	Scale
	A	0.040	1:1
Sheet		Sheets 1	
Plate 1N-I-MBS-M <sub>1</sub> -1 GOST 7338-90			

Copied by

Format A4

AK-630 114-15

Rz160  




- 1.\* Reference dimension.
- 2. Dimensions ensured by tool as per accuracy class 7.
- 3. Mark Ш, Ч and stamp K on tag.

Approved by shop		Reference No.		First use	
Approved KTONI		Sign and Date		Sign and Date	
Approved Tr.	Dupl. Inv. No.	Alternate Inv. No.	Dupl. Inv. No.	Sign and Date	Sign and Date
Approved OGMet	Orig. Inv. No.	Head of Q.C.D	Design bureau chief	Head of Q.C.D	Approved by
<b>AK-630 114-15</b>					
<b>Gasket</b>		Type	Weight	Scale	
		A	0.036	1:1	
Sheet			Sheets 1		
Plate 1N-I-MBS-M <sub>1</sub> -1					
GOST 7338-90					

Copied by

Format A4



First use

Reference No.

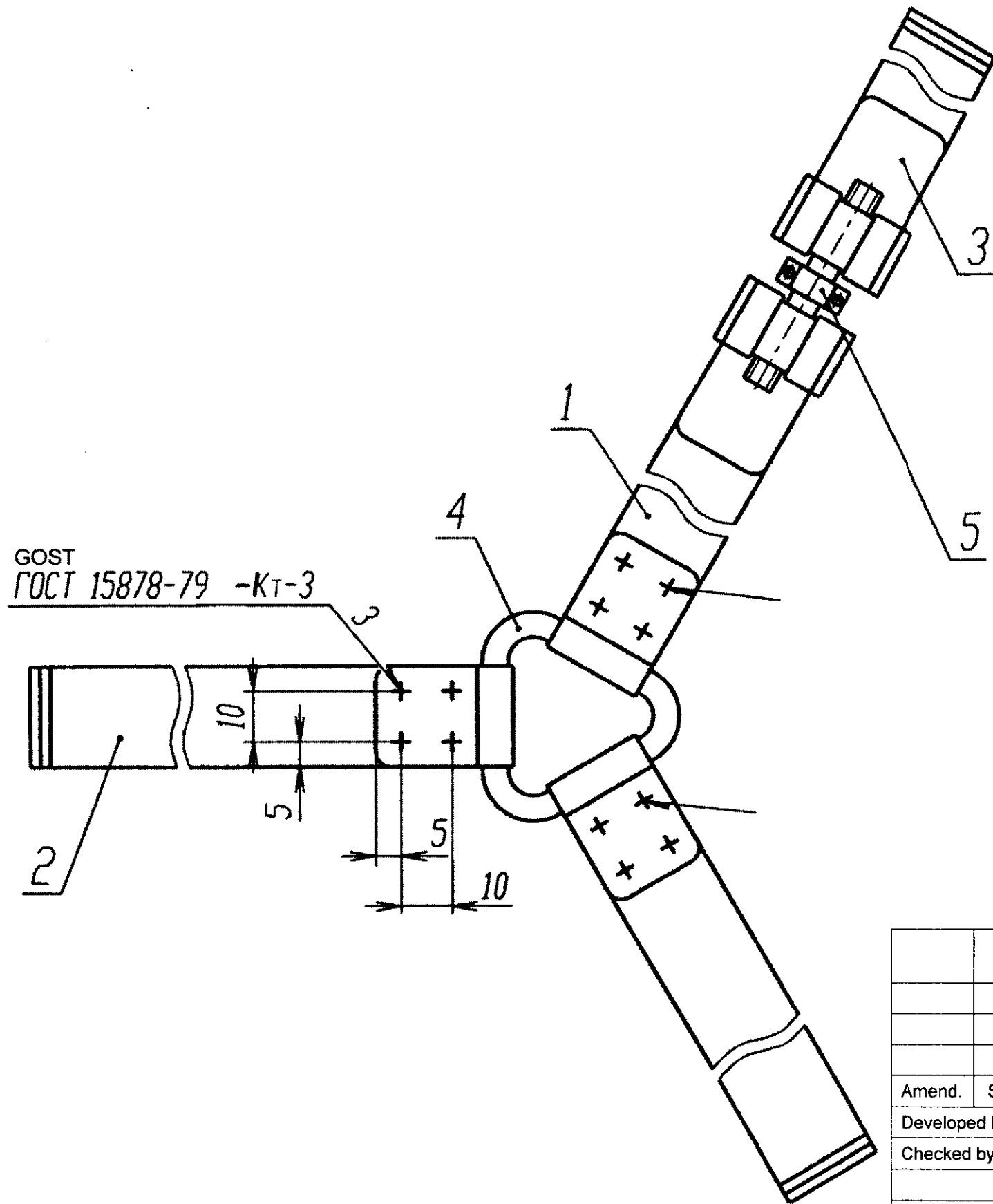
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



GOST  
ГОСТ 15878-79 -KT-3

1. After pressing clevis pos.4 with ties pos.1, pos.2 and welding , ensure free rotation of ties with respect to clevis.
2. Mark Ш , Ч and stamp K on tag.

					AK-630 Sb 114-2 SB			
Amend.	Sheet	Doc.No.	Sign	Date	<b>Evacuator chamber attachment Assembly drawing</b>	Type	Weight	Scale
Developed by						A	0.305	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by								



AK-630 114-20

First use

Approved by shop

Reference No.

Approved KTONI

Sign and Date

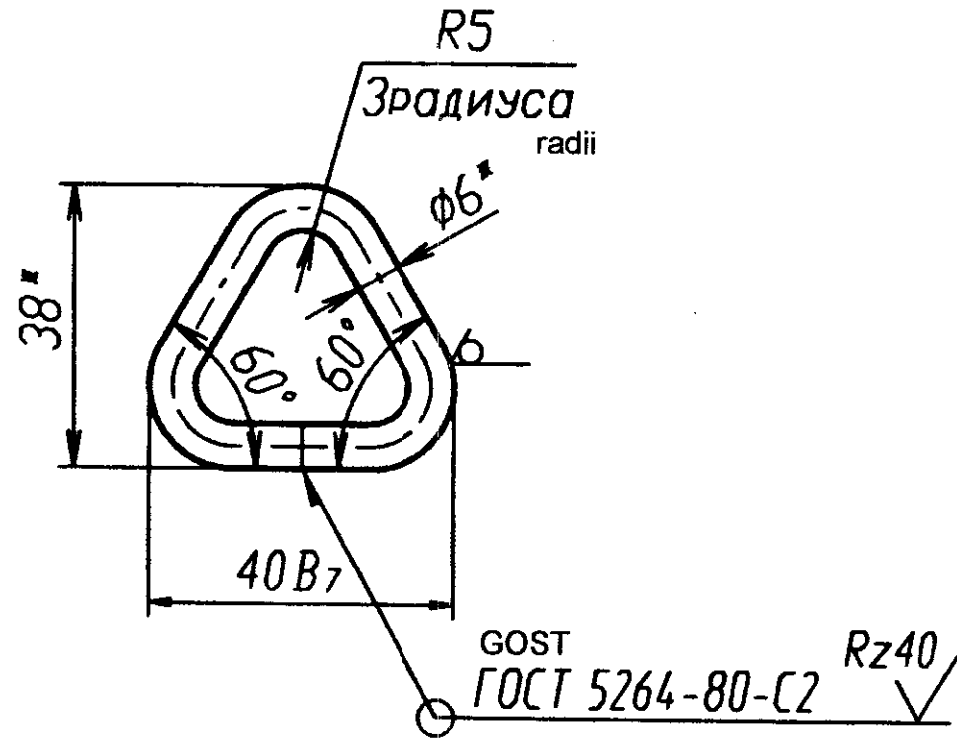
Approved Tcspb

Alternate Inv. No. Dupl. Inv. No.

Sign and Date

Approved OGMet

Orig. Inv. No.



1. Welding rod UONII 13/45-2.0-2 GOST 9466-75. Gas welding with wire 2.0 Sv08A GOST 2246-70 is permissible.
2. 34..39.5 HRC<sub>E</sub>. Check 3-5% components from batch but not less than 3 nos.-
- 3.\* Reference dimensions.
4. Coating Cd 12.phos.Oil.
5. Mark Ш, Ч and stamp К, И on tag.

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				

<b>AK-630 114-20</b>			
<b>Clevis</b>	Type	Weight	Scale
	A	0.016	1:1
Sheet		Sheets 1	
Wheel	6 - 5 GOST 7417 - 75		
	35 - N - V GOST 1051 - 73		

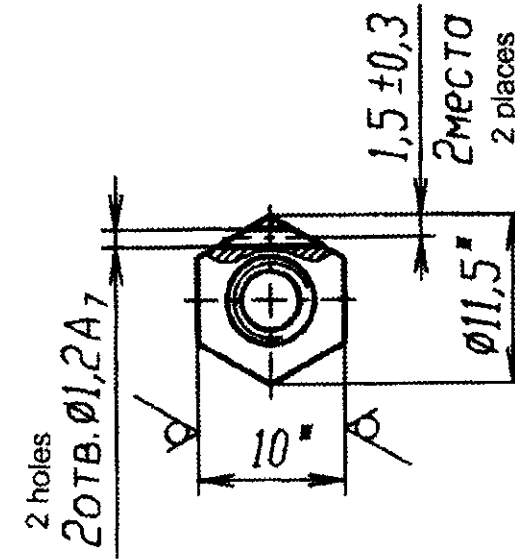
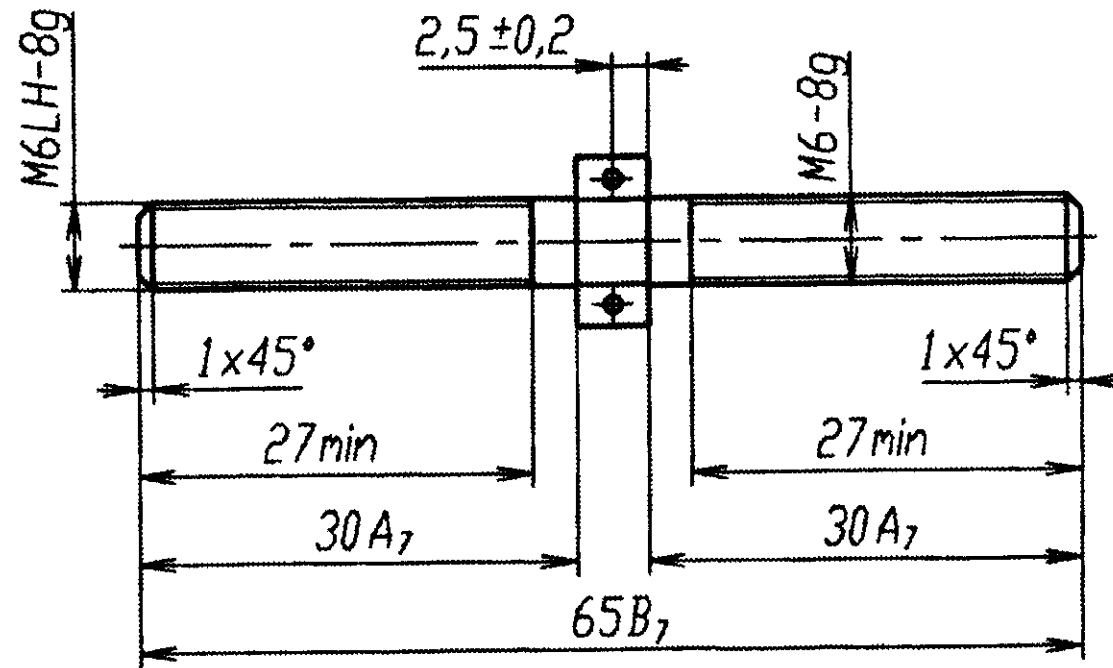
Сопод. by

Format A4

AK-630 114-21

First use

Reference No.



Rz80 ✓ (✓)

Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

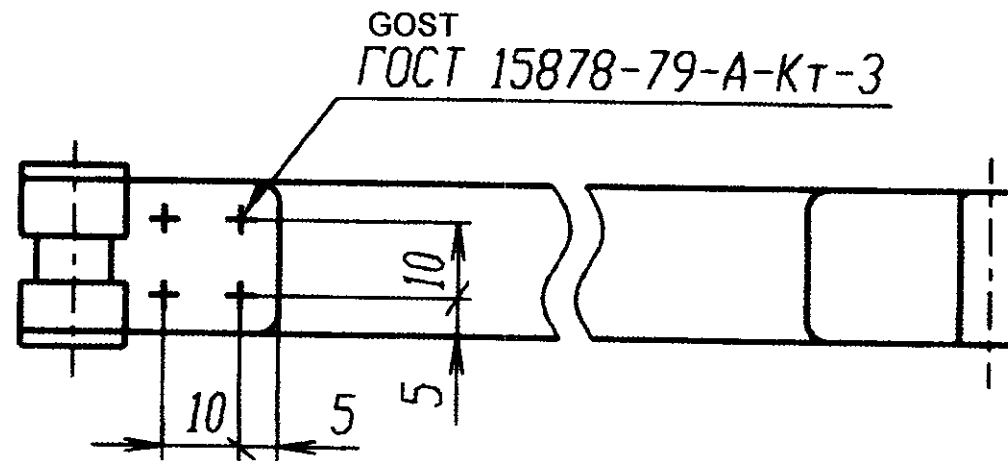
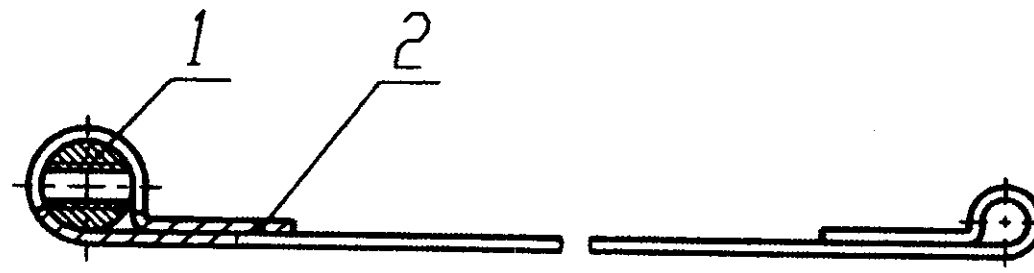
Orig. inv. no.

1. Substitute material- hexagon  $\frac{11 - 5GOST8560 - 78}{40GOST1051 - 73}$
2. 31..40.5 HRC<sub>E</sub>. Check 3..5% , but not less than 3 nos. from batch.
- 3.\* Reference dimensions.
4. Inner angles R~0.4 mm.
5. Blunt sharp edges ~0.4 mm.
6. Coating Cd6. phos.Oil.
7. Mark Ш, Ч and stamp K, И on tag.

					AK-630 114-21			
Amend.	Sheet	Doc.No.	Sign	Date	Tightening screw	Type	Weight	Scale
Developed by						A	0.010	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D						Hexagon $\frac{10 - 5GOST8560 - 78}{40Kh - T - VGOST1051 - 73}$		
Approved by								

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A4		✓	AK-630 Sb114-24 SB	Assembly drawing <i>2/13</i>			
					<u>Components</u>			
	A4		✓ 1	AK-630 114-59	Pin <i>2/13</i>	1		
	A3		✓ 2	AK-630 114-60	Band <i>2/13</i>	1		
Sign and Date								
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date								
Orig. Inv. No.	<b>AK-630 Sb 114-24</b>							
	Amend.	Sheet	Doc. No.	Sign	Date			
	Developed by					Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D					<b>Medium tie</b>		
Approved by								

AK-630 Sb114-24 SB



- 1. After pressing pin pos.1 with band pos.2 and welding, ensure that the pin does not fall out and rotates freely.
- 2. Mark Ш, Ч and stamp K on tag.

Approved OGMet	Orig. Inv. No.		Sign and Date		Approved TOsb		Approved KTONI		Approved by shop		Reference No.	First use
	Alternate Inv. No.		Dupl. Inv. No.		Sign and Date		Reference No.		Reference No.			
AK-630 Sb114-24 SB												
Amend. Sheet Doc. No. Sign Date					AK-630 Sb114-24 SB <b>Medium tie Assembly drawing</b>				Type		Weight	Scale
Developed by									A		0.060	1:1
Checked by									Sheet		Sheets 1	
Head of Q.C.D												
Design bureau chief												
Head of Q.C.D												
Approved by												

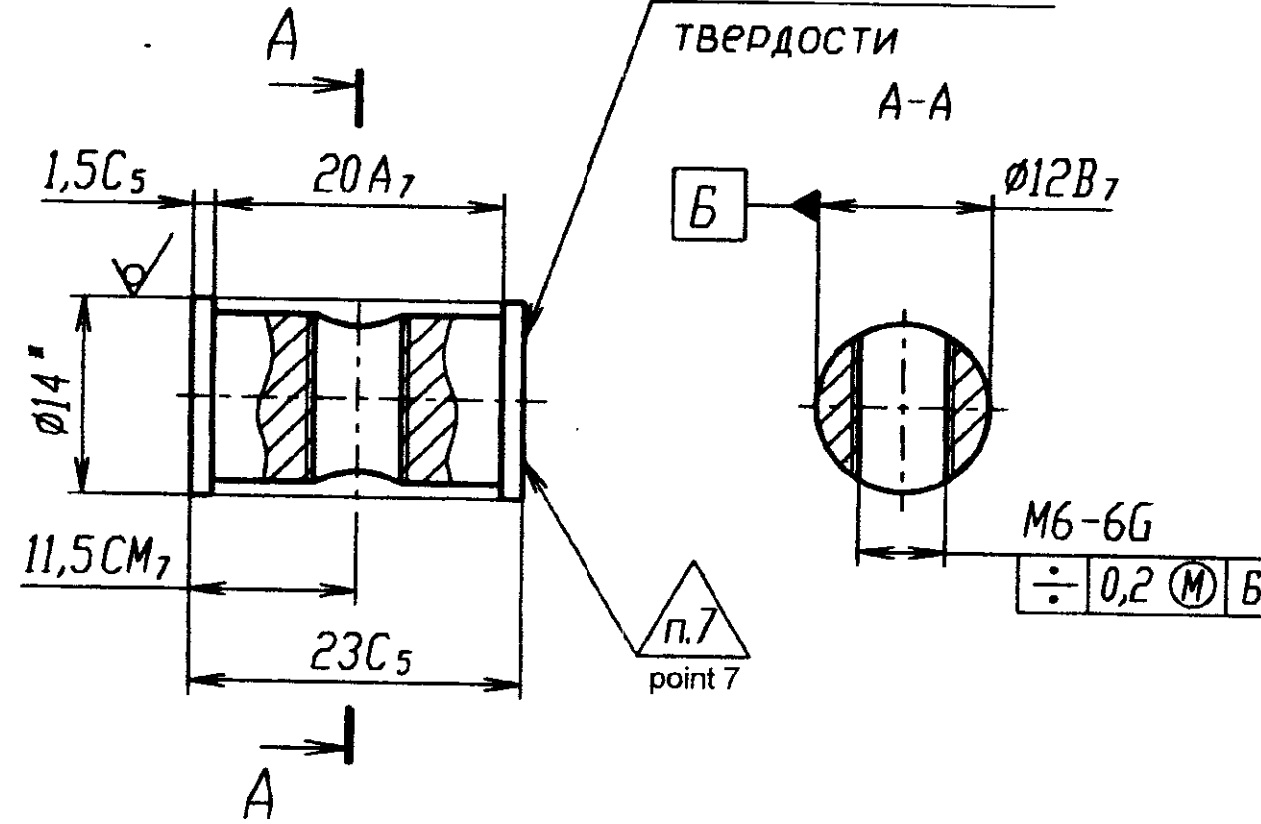
Conrad by

Format A4

AK-630 114-59

Rz80  
✓(✓)

Place for checking hardness  
Место испытания  
ТВЕРДОСТИ



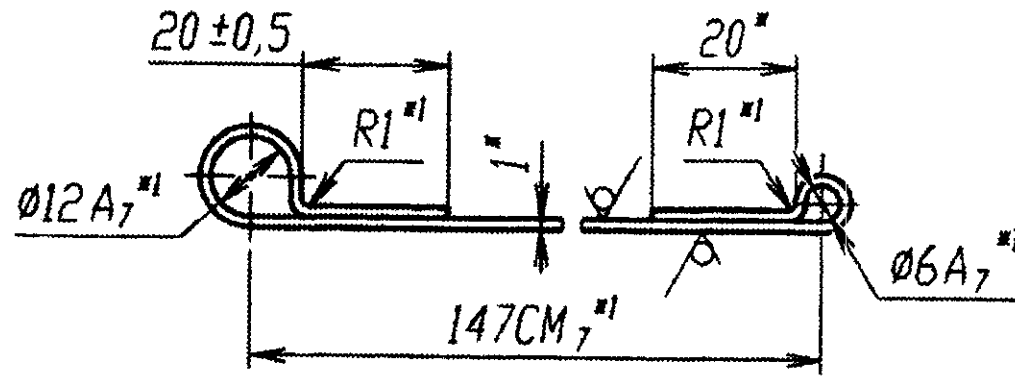
1. 34..39.5 HRC<sub>E</sub>.
2. \* Reference dimension.
3. Inner angles R~0.2 mm.
4. Blunt sharp edges ~0.2 mm.
5. Coating Cd6.Phos.Oil.
6. Mark Ш, Ч and stamp K on tag.
7. Stamp И as per AK-630, AK-630M TU I.

Approved OGMet	Approved TOSb	Approved KTONI	Approved by shop	First use	
Orig. Inv. No.	Alternate Inv. No.	Sign and Date	Reference No.		
Sign and Date	Dupl. Inv. No.	Sign and Date			
<b>AK-630 114-59</b>					
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					
Pin			Type	Weight	Scale
			A	0.020	1:1
Wheel			Sheet	Sheets 1	
			14 - 5 GOST 7417 - 75		
			50 - T - V GOST 1051 - 73		

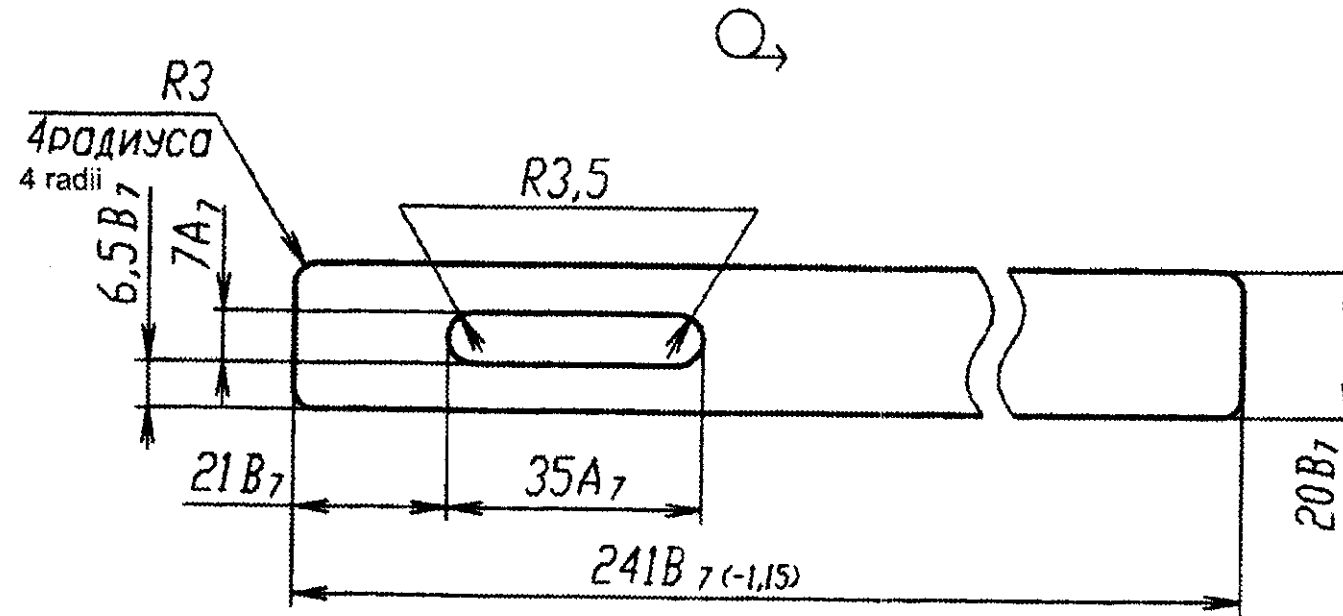
AK-630 114-60

First use

Reference No.



Rz80 ✓ (✓)



Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

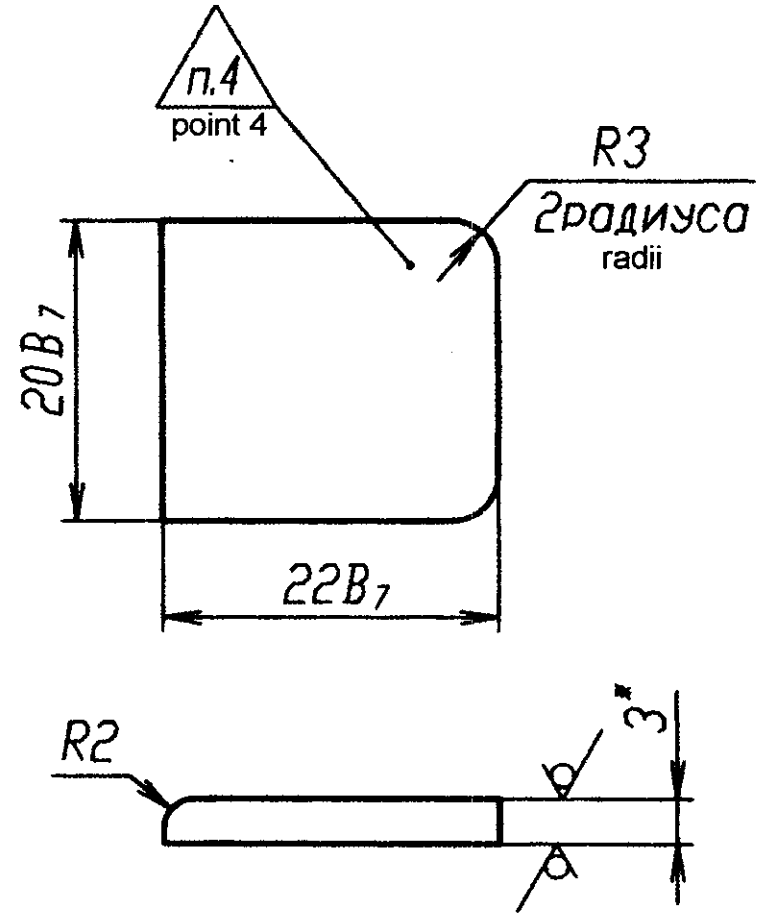
1. Substitute material- sheet  $\frac{BT - PN - 0 - 1GOST19903 - 74}{12Cr18Ni10Ti - M3bGOST5582 - 75}$ .
- 2.\* Reference dimensions.
- 3.\*1 Check dimensions in compressed condition.
4. Blunt sharp edges ~0.2 mm.
5. Mark Ч, Ш and stamp K on tag.

					AK-630 114-60			
Amend.	Sheet	Doc.No.	Sign	Date	Band	Type	Weight	Scale
Developed by						A	0.038	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Sheet $\frac{BT - 0 - PN - 1GOST19904 - 90}{12Cr18Ni10Ti - M3aGOST5582 - 75}$			
Approved by								

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks				
	Reference No.					<u>Documents</u>					
A3				AK-630 Sb114-25 SB	Assembly drawing						
					<u>Components</u>						
A4			1	AK-630 114-61	Plate	1					
	A3		2	AK-630 114-62	Band	1					
Sign and Date				AK-630 Sb 114-25							
	Amend.	Sheet	Doc. No.						Sign	Date	
Orig. Inv. No.	Developed by			Major tie			Type	Sheet	Sheets		
	Checked by						A		1		
	Head of Q.C.D										
	Approved by										
Sign and Date											
Dupl. Inv. No.											
Alternate Inv. No.											
Sign and Date											

AK-630 114-61

Rz80  
✓ (✓)



- 1.\* Reference dimensions.
2. Blunt sharp edges ~0.4 mm.
3. Mark Ш, Ч on tag.
4. Stamp K as per AK-630, AK-630M TU I.

First use																																			
Approved by shop																																			
Reference No.																																			
Approved KTONI																																			
Sign and Date																																			
Dupl. Inv. No.																																			
Approved TOSb																																			
Alternate Inv. No.																																			
Sign and Date																																			
Approved OGMet																																			
Orig. Inv. No.																																			
Head of Q.C.D																																			
Design bureau chief																																			
Head of Q.C.D																																			
Approved by																																			
<b>AK-630 114-61</b>																																			
Amend.	Sheet	Doc. No.	Sign	Date	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td colspan="3" style="text-align: center;"><b>Plate</b></td> <td style="text-align: center;">Type</td> <td style="text-align: center;">Weight</td> <td style="text-align: center;">Scale</td> </tr> <tr> <td></td> <td style="text-align: center;">A</td> <td style="text-align: center;">0.040</td> <td colspan="3" style="text-align: center;">2:1</td> </tr> <tr> <td colspan="2" style="text-align: center;">Sheet</td> <td colspan="4" style="text-align: center;">Sheets 1</td> </tr> <tr> <td colspan="6" style="text-align: center;">Sheet <i>B - PN - 3 GOST 19903 - 74</i></td> </tr> <tr> <td colspan="6" style="text-align: center;"><i>12Cr18Ni10Ti - M3B GOST 5582 - 75</i></td> </tr> </table>	<b>Plate</b>			Type	Weight	Scale		A	0.040	2:1			Sheet		Sheets 1				Sheet <i>B - PN - 3 GOST 19903 - 74</i>						<i>12Cr18Ni10Ti - M3B GOST 5582 - 75</i>					
<b>Plate</b>			Type	Weight		Scale																													
	A	0.040	2:1																																
Sheet		Sheets 1																																	
Sheet <i>B - PN - 3 GOST 19903 - 74</i>																																			
<i>12Cr18Ni10Ti - M3B GOST 5582 - 75</i>																																			

Copied by

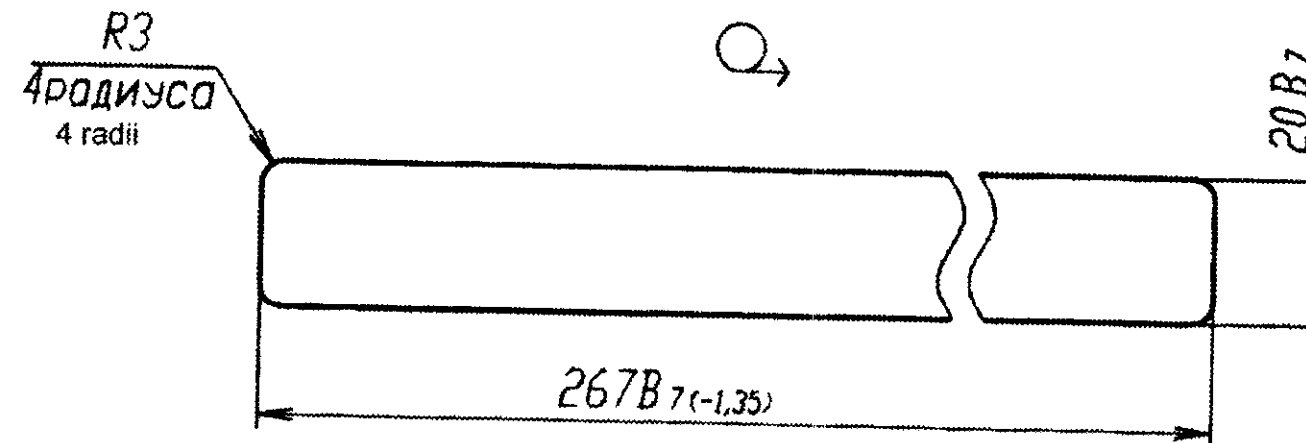
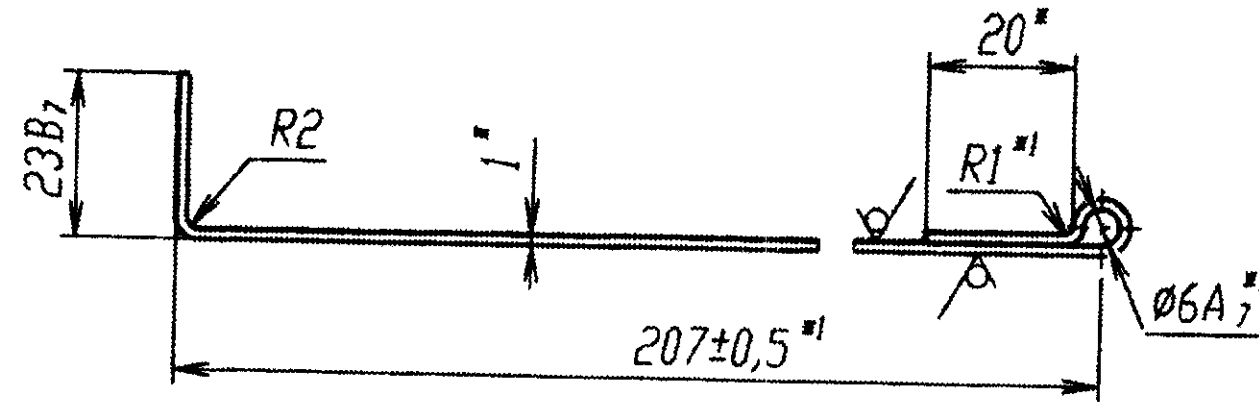
Format A4



AK-630 114-62

First use

Reference No.



Sign and Date

Duplicate Inv. No.

Alternate Inv. No.

Sign and Date

Orig. inv. no.

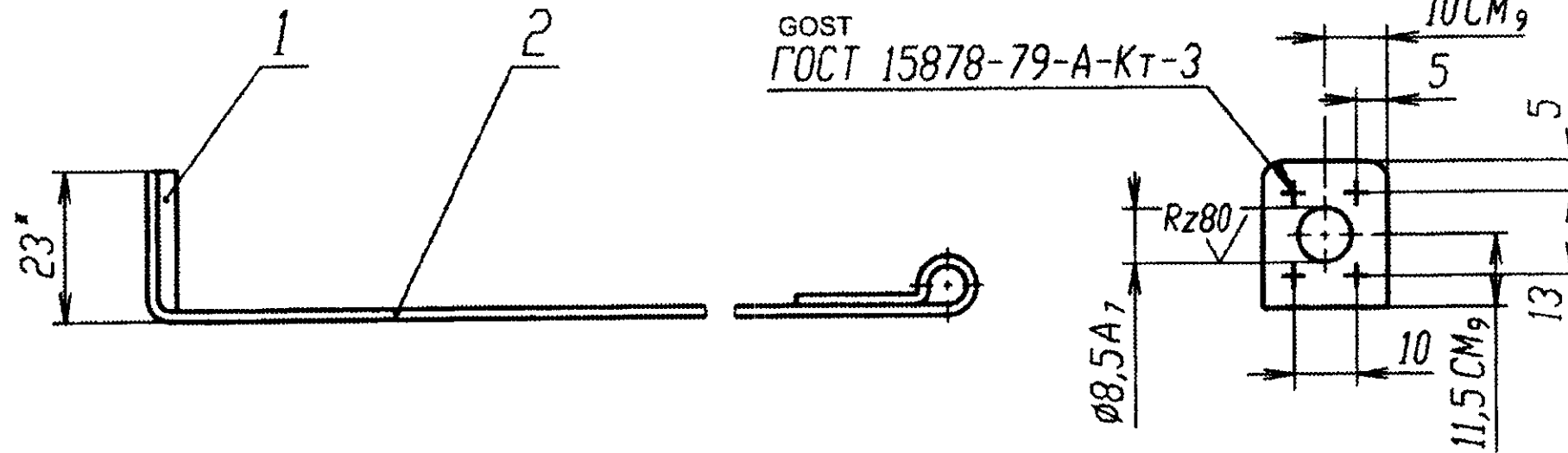
1. Substitute material- sheet  $\frac{BT - PN - 0 - 1GOST19903 - 74}{12Cr18Ni10Ti - M3bGOST5582 - 75}$ .
- 2.\* Reference dimensions.
- 3.\*1 Check dimensions in compressed condition.
4. Blunt sharp edges ~0.2 mm.
5. Mark Ч, Ш and stamp K on tag.

					AK-630 114-62			
Amend.	Sheet	Doc.No.	Sign	Date	Band	Type	Weight	Scale
Developed by						A	0.045	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D						Sheet $\frac{BT - 0 - PN - 1GOST19904 - 90}{12Cr18Ni10Ti - M3aGOST5582 - 75}$		
Approved by								

AK-630 Sb114-25 SB

First use

Reference No.



1.\* Reference dimension.  
2. Mark Ш, Ч and stamp K on tag.

					AK-630 Sb114-25 SB			
Amend	Sheet	Doc.No.	Sign	Date	Major tie rod Assembly drawing	Type	Weight	Scale
Developed by						A	0.055	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by								

Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A3		✓	AK-630 Sb114-26 SB	Assembly drawing			
					<u>Components</u>			
	A4		✓1	AK-630 114-61	Plate	1		
	A4		✓2	AK-630 114-63	Pin	1		
	A3		✓3	AK-630 114-64	Band			
Sign and Date								
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date								
Orig. Inv. No.					<b>AK-630 Sb 114-26</b>			
	Amend.	Sheet	Doc. No.	Sign	Date			
	Developed by					Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D					<b>Minor tie</b>		
	Approved by							

First use

Reference No.

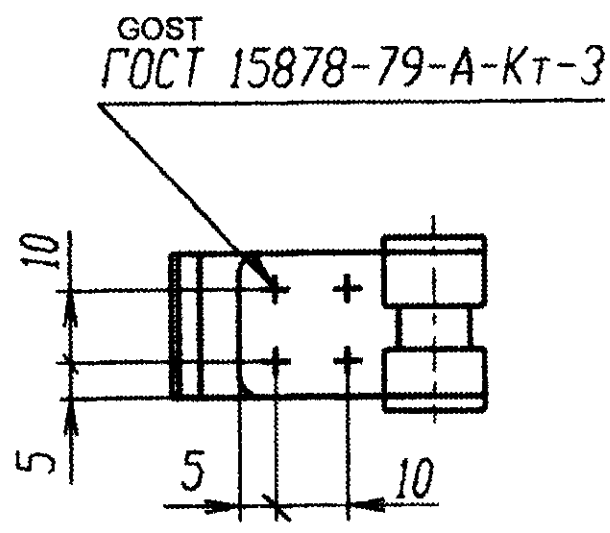
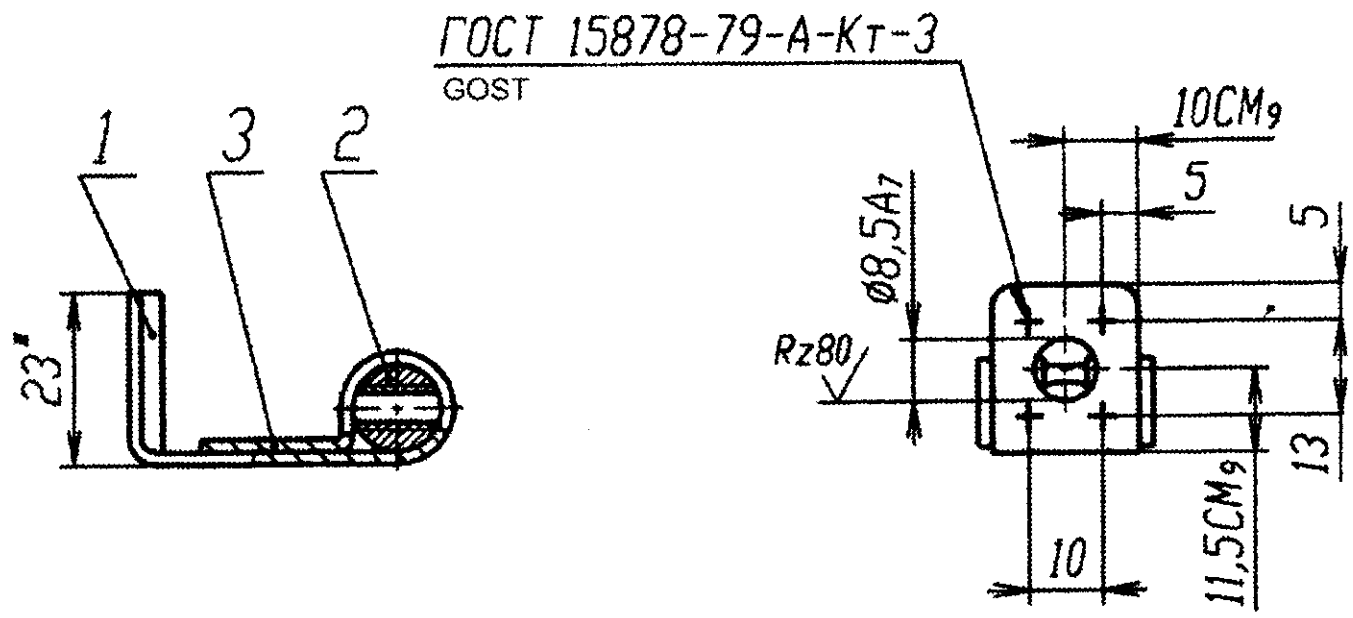
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



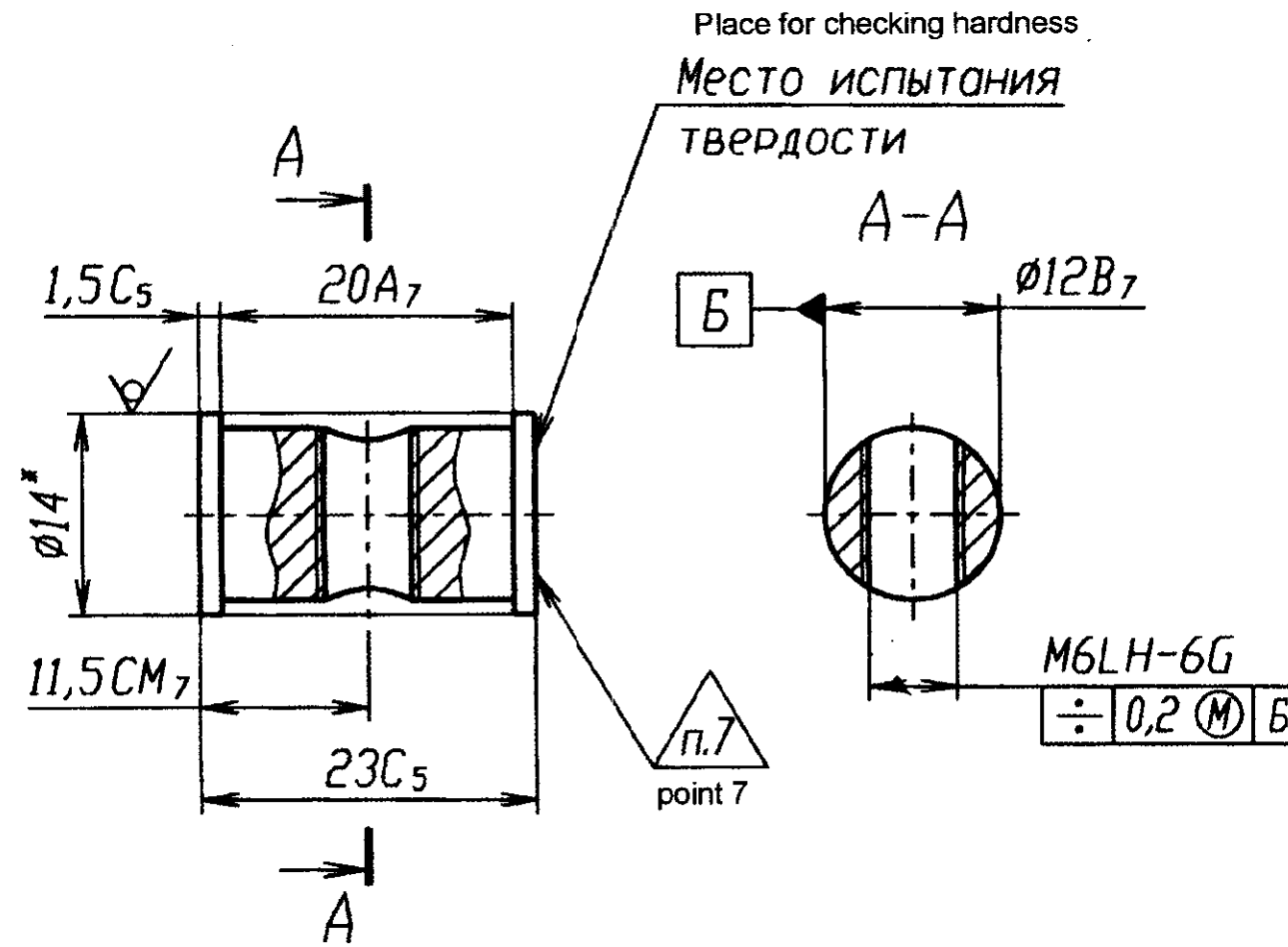
- 1.\* Reference dimension.
2. While pressing pin pos.2 with band pos.3 and welding, make sure that the pin does not fall out and rotates freely.
3. Mark Ш , Ч and stamp K on tag.

					AK-630 Sb114-26 SB			
Amend	Sheet	Doc.No.	Sign	Date	Minor tie rod Assembly drawing	Type	Weight	Scale
Developed by						A	0.055	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by								

Approved OGMet		Sign and Date	Approved TOsb	Approved KTONI	Reference No.	Approved by shop	First use	AK-630 114-61			
								<p>Rz80 ✓ (✓)</p> <p>п.4 point 4</p> <p>R3 2 радиуса radii</p> <p>20B7</p> <p>22B7</p> <p>R2</p> <p>3</p> <p>1. * Reference dimensions. 2. Blunt sharp edges ~0.4 mm. 3. Mark Ш, Ч on tag. 4. Stamp K as per AK-630, AK-630M TU I.</p>			
Orig. Inv. No.		Sign and Date	Alternate Inv. No.	Dupl. Inv. No.	AK-630 114-61			AK-630 114-61			
Amend.		Sheet	Doc. No.	Sign	Date	Plate	Type	Weight	Scale		
Developed by							A	0.040	2:1		
Checked by							Sheet	Sheets 1			
Head of Q.C.D						Sheet	Sheets 1				
Design bureau chief						Sheet B - PN - 3GOST19903 - 74					
Head of Q.C.D						12Cr18Ni10Ti - M3BGOST5582 - 75					
Approved by											

AK-630 114-63

Rz80  
✓(✓)



1. 34..39.5 HRC<sub>E</sub>.
2. \* Reference dimension.
3. Inner angles R~0.2 mm.
4. Blunt sharp edges ~0.2 mm.
5. Coating Cd6.Phos.Oil.
6. Mark Ш, Ч and stamp K on tag.
7. Stamp И as per AK-630, AK-630M TU I.

Approved OGMet	Sign and Date	Approved TOSb	Sign and Date	Approved KTONI	Reference No.	First use												
Orig. Inv. No.	Alternate Inv. No.	Dupl. Inv. No.	Sign and Date	Reference No.	First use													
<b>AK-630 114-63</b>																		
Amend.	Sheet	Doc. No.	Sign	Date	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td colspan="3" style="text-align: center;"><b>AK-630 114-63</b></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;">0.020</td> <td style="text-align: center;">1:1</td> </tr> <tr> <td colspan="2" style="text-align: center;">Sheet</td> <td style="text-align: center;">Sheets 1</td> </tr> </table>		<b>AK-630 114-63</b>			Type	Weight	Scale	A	0.020	1:1	Sheet		Sheets 1
<b>AK-630 114-63</b>																		
Type	Weight	Scale																
A	0.020	1:1																
Sheet		Sheets 1																
Developed by																		
Checked by																		
Head of Q.C.D																		
Design bureau chief																		
Head of Q.C.D																		
Approved by																		
Pin Wheel $\frac{14 - 5GOST7417 - 75}{50 - T - VGOST1051 - 73}$																		

Сопров. лист

Формат А4

AK-630 114-64

First use

Reference No.

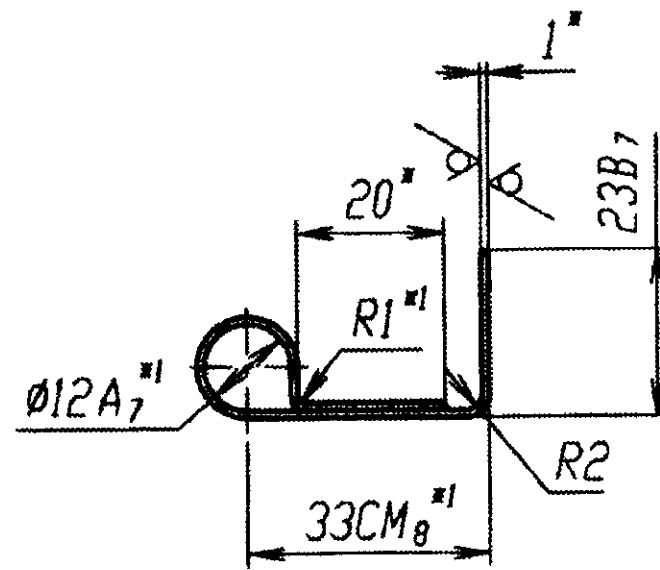
Sign and Date

Duplicate Inv. No

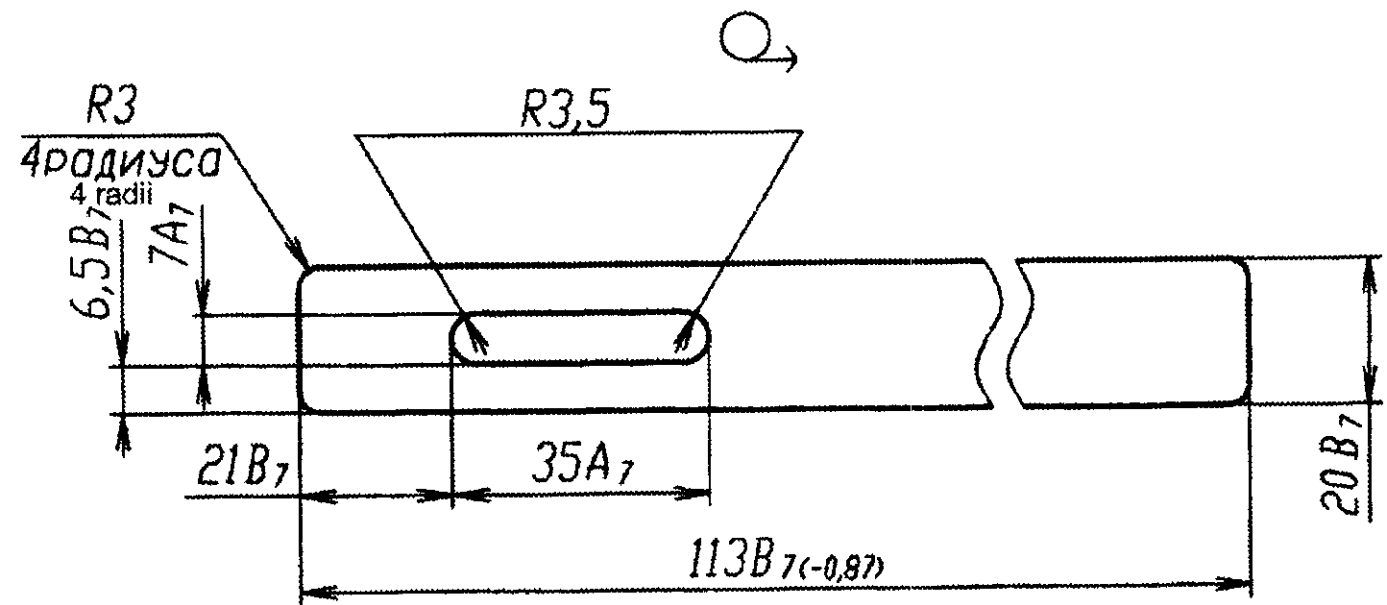
Alternate Inv. No

Sign and Date

1. Substitute material- sheet  $\frac{BT - PN - 0 - 1GOST19903 - 74}{12Cr18Ni10Ti - M3bGOST5582 - 75}$
- 2.\* Reference dimensions.
- 3.\*1 Check dimensions in compressed condition.
4. Blunt sharp edges ~0.2 mm.
5. Mark Ч, Ш and stamp K on tag.



Rz80 ✓ (✓)



Amend.	Sheet	Doc.No.	Sign	Date

AK-630 114-64

Type		Weight	Scale
A		0.025	1:1
Sheet	Sheets 1		

Band

Sheet  $\frac{BT - 0 - PN - 1GOST19904 - 90}{12Cr18Ni10Ti - M3aGOST5582 - 75}$

First use		Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks				
Reference No.		A3			AK-630 Sb114-3 SB	Assembly drawing						
		<u>Documents</u>										
		<u>Assembly units</u>										
		A4		✓		AK-630 Sb 114-27	Fork	1				
		<u>Components</u>										
		A3		✓	2	AK-630 114-22	Base plate	1				
		A3		✓	3	AK-630 114-23	Clamp	1				
		<u>Standard articles</u>										
					4		Bolt 3M8-8gx30.109.40Kh.029 GOST 7805-70	2	31-40.5HRC			
		<u>Other articles</u>										
Sign and Date				5		Electric air valve	3					
		<u>Other articles</u>										
		Sign and Date		<b>AK-630 Sb 114-3</b>								
				Amend.	Sheet	Doc. No.	Sign	Date				
				Developed by						Type	Sheet	Sheets
				Checked by						A		1
				Head of Q.C.D								
				Approved by								
				Attachment of electric air valves								
Orig. Inv. No.												
Sign and Date												
Alternate Inv. No.												
Dupl. Inv. no.												



First use

Reference No.

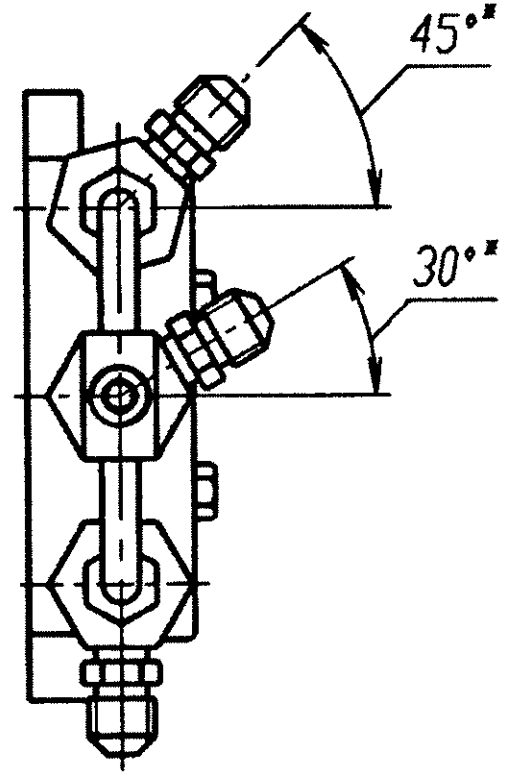
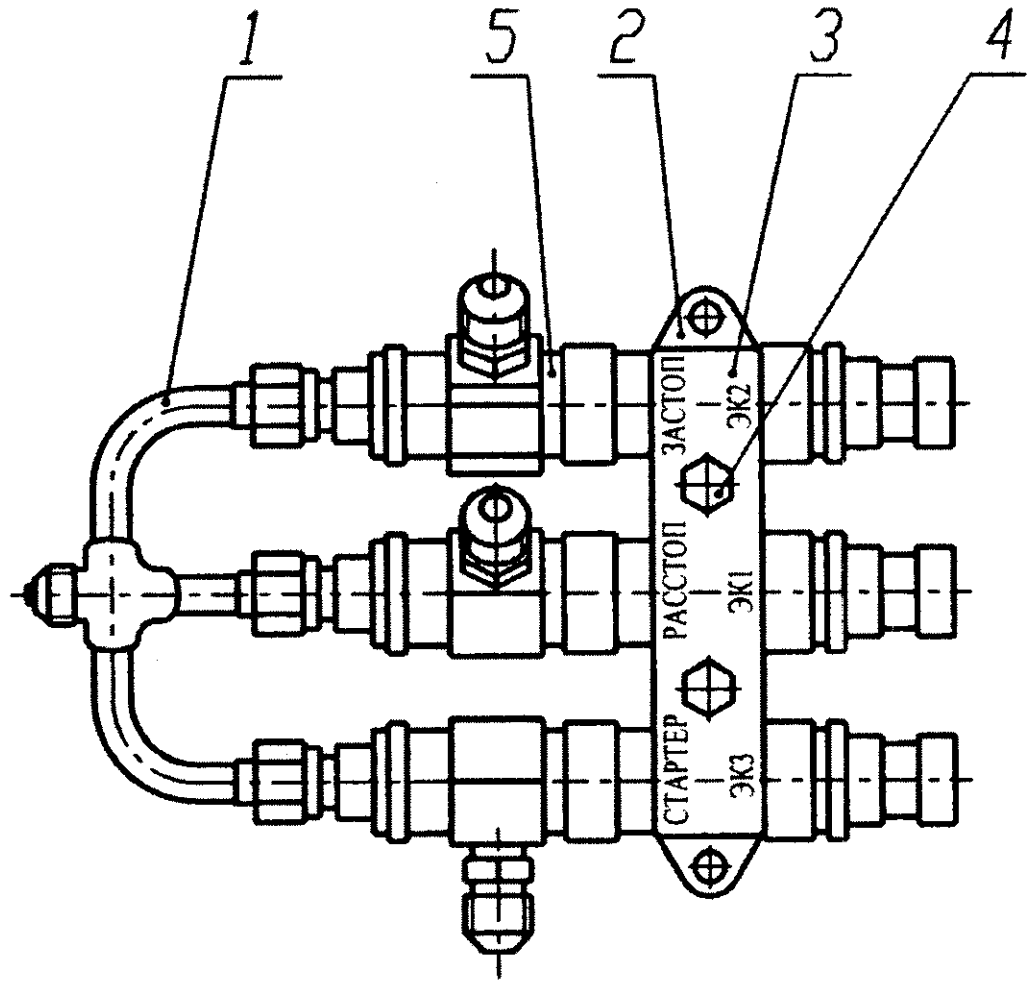
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



- 1.\* Reference dimension.
- 2. At the time of assembly, in order to avoid damage of locking and serviceability of electrically operated air valves pos.5 during tightening and removal of coupling nuts of plug pos.1, it is necessary to hold connecting pipes of valves against turning through.
- 3. 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 Sb114-3 SB

Attachment of electric air valves  
Assembly drawing

Type	Weight	Scale
A	1.650	1:2
Sheet	Sheets	1

AK-630 114-22

First use

Reference No.

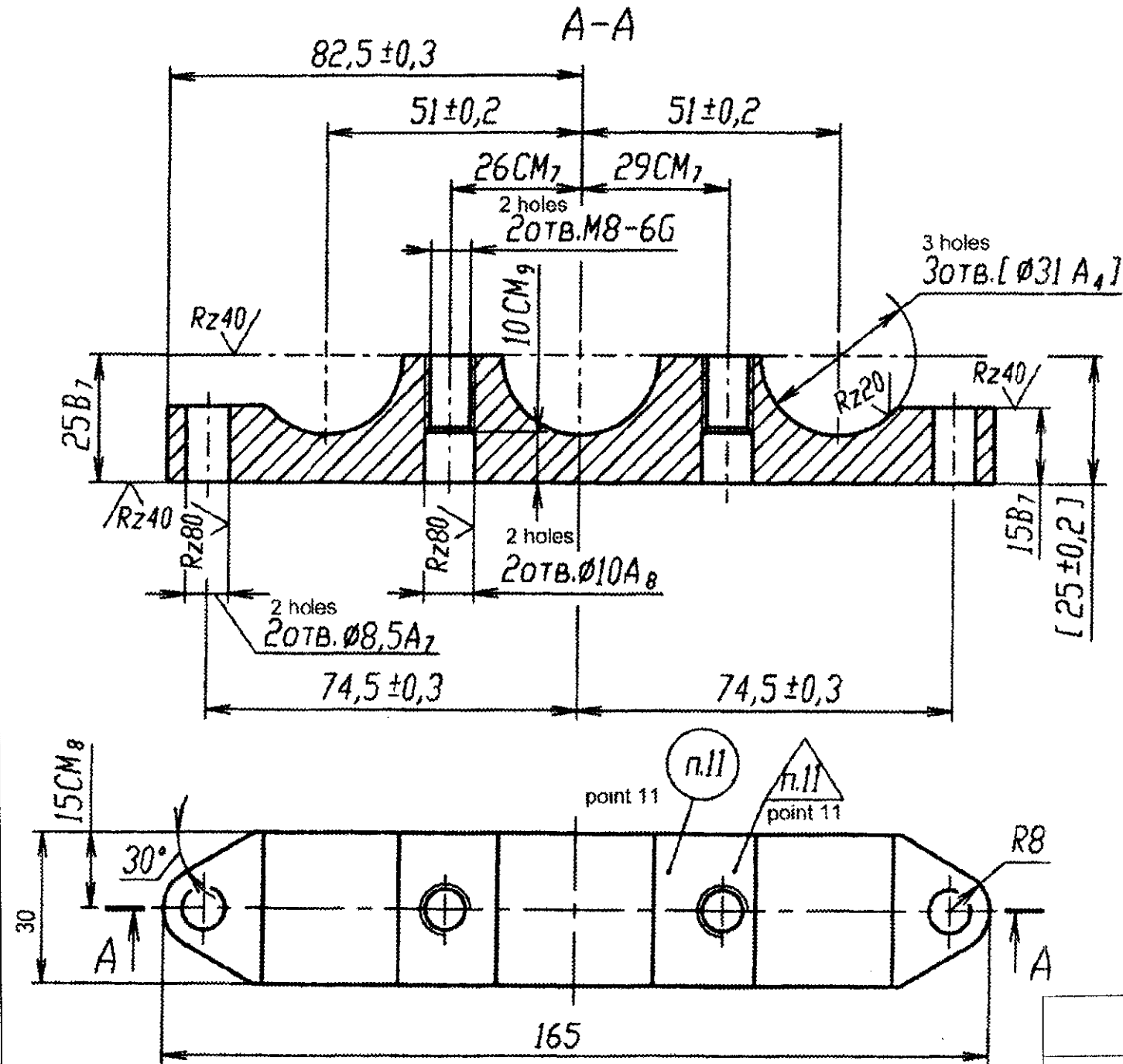
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



✓(✓)

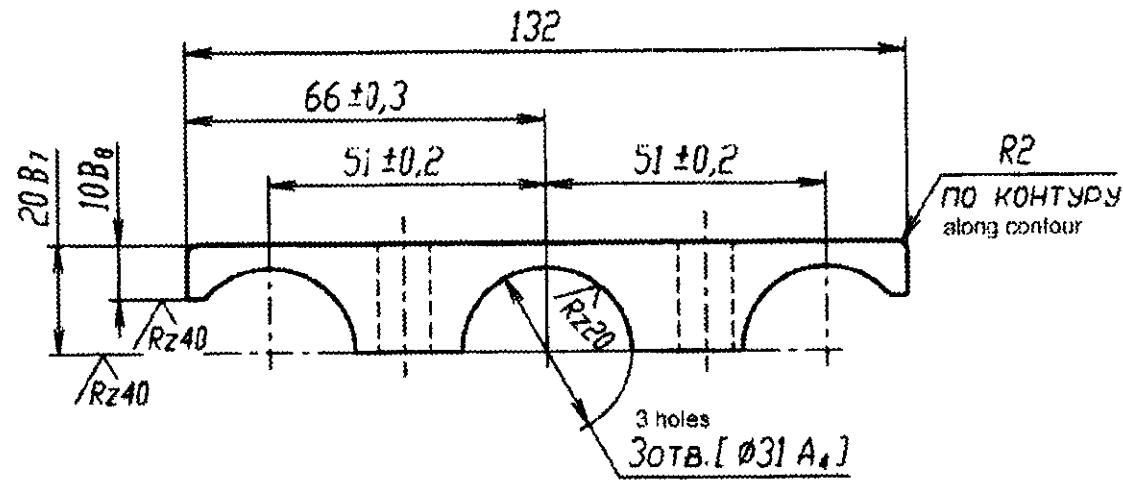
1. Substitute material- alloy D16 GOST 4784-97
2. Maximum deviation of dimensions obtained by forging by 6 th class OST 1.41187-78 unless otherwise specified.
3. Forging gradient up to 7°.
4. Check forged blanks by 3<sup>rd</sup> inspection group OST 92-1008-77 by checking hardness 100%.
5. Carry out machining of dimensions in square brackets together with component AK-630 114-23.
6. Apply machined components together.
7. Inner angles R~0.4 mm.
8. Blunt sharp edges ~0.4 mm.
9. It is permissible to manufacture components by machining of plate AMg6 B28 GOST 17232-99.
10. Coating Anodic Oxid.Cr.  
Primer AK-070, yellow (2)  
Enamel KhV-124, gray (4), IV, OM2  
AK-070 GOST 25718-83  
KhV-124 GOST 10144-89.
11. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 114-22			
Amend.	Sheet	Doc.No.	Sign	Date	Base plate	Type	Weight	Scale
Developed by						A	0.150	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Alloy D1 GOST 4784-97			
Approved by								

AK-630 114-23

First use

Reference No.



✓(✓)

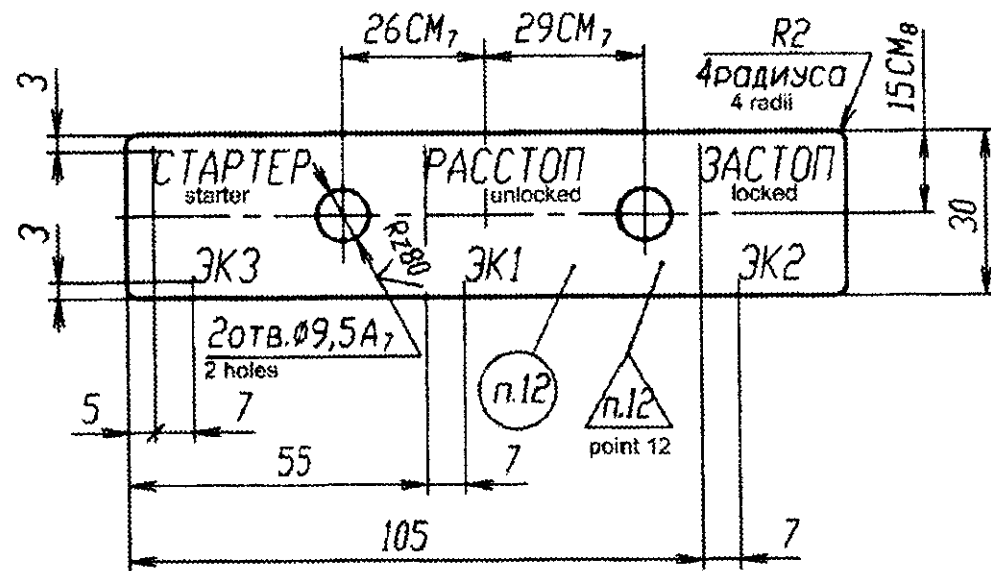
Sign and Date

Duplicate Inv. No.

Alternate Inv. No.

Sign and Date

Orig. inv. no.



1. Substitute material- alloy D16 GOST 4784-97
2. Maximum deviation of dimensions obtained by forging by 6 th class OST 1.41187-78 unless otherwise specified.
3. Forging gradient up to 7°
4. Check forged blanks by 3<sup>rd</sup> inspection group OST 92-1008-77 by checking hardness 100%.
5. Carry out machining of dimensions in square brackets together with component AK-630 114-23.
6. Apply machined components together.
7. Blunt sharp edges ~0.4 mm.
8. It is permissible to manufacture components by machining of plate AMg6 B28 GOST 17232-99.
9. Engrave inscriptions. Letter size PO-5 GOST 2930-62.
10. Fill inscriptions with enamel PF-115 black GOST 6465-76.
11. Coating Anodic Oxid.Cr.  
Primer AK-070, yellow (2)  
Enamel KhV-124, gray (4), IV, OM2  
AK-070 GOST 25718-83  
KhV-124 GOST 10144-89.
12. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

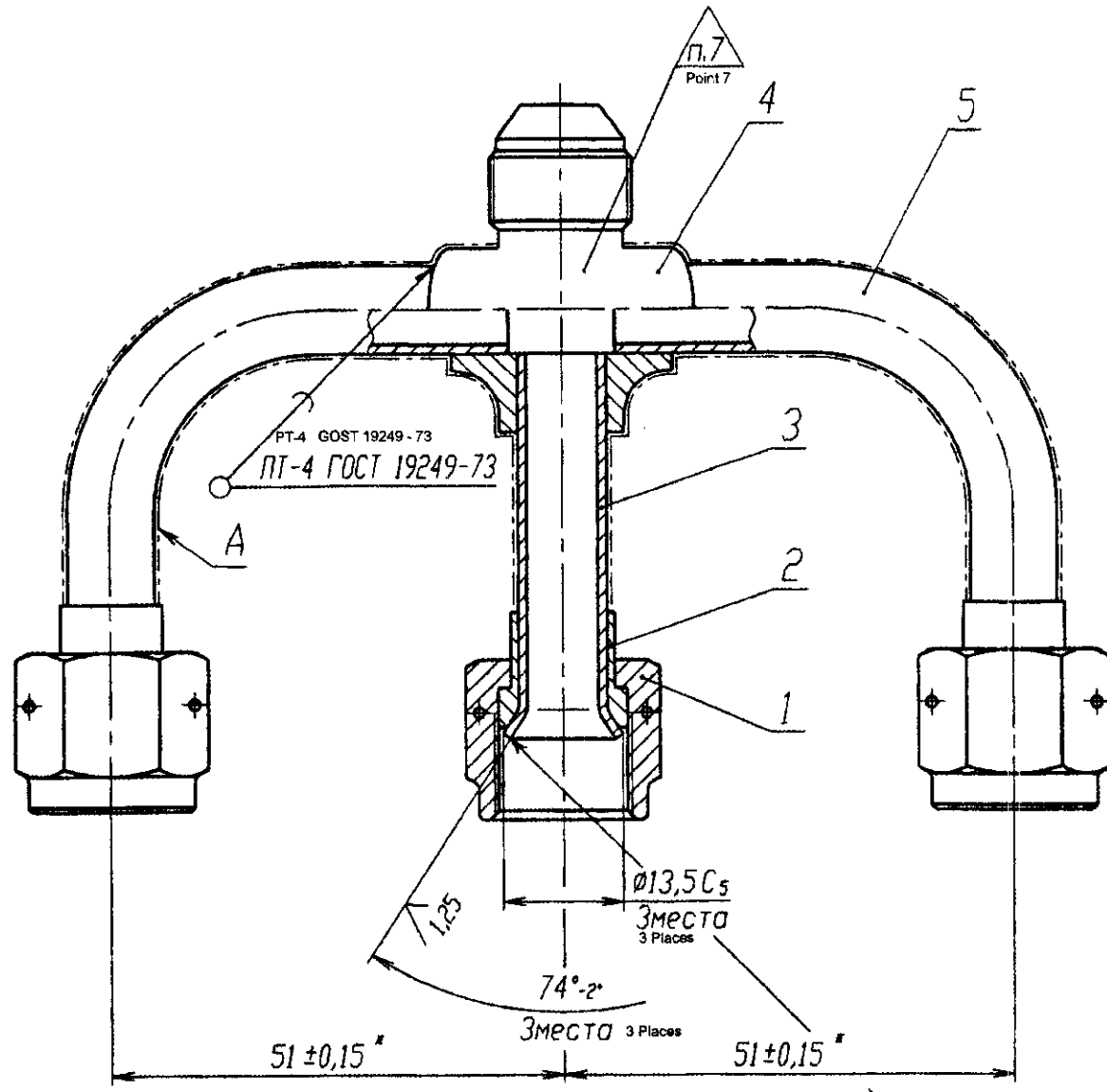
					AK-630 114-23		
					Clamp		
Amend.	Sheet	Doc.No.	Sign	Date			
Developed by					A	0.150	1:1
Checked by					Sheet	Sheets	1
Head of Q.C.D					Alloy D1 GOST 4784-97		
Approved by							

First use		Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.						<u>Documents</u>			
		A2		✓	AK-630 Sb114-27 SB	Assembly drawing			
							<u>Components</u>		
		A3		✓	AK-630 114-32-01	Coupling nut	3		
		A4		✓	AK-630 114-33-01	Nipple	3		
		A4		✓	AK-630 114-65	Pipe	1		
		A3		✓	AK-630 114-66	Cross-piece	1		
		A4		✓	AK-630 114-67	Pipe	2		
Sign and Date									
Dupl. Inv. No.									
Alternate Inv. No.									
Sign and Date							<b>AK-630 Sb 114-27</b>		
		Amend.	Sheet	Doc. No.	Sign	Date			
Orig. Inv. No.		Developed by				<b>Fork</b>	Type	Sheet	Sheets
		Checked by					A		1
		Head of Q.C.D							
		Approved by							

AK-630 СБ114-27СБ

AK-630 SB 114-27 SB

Листов, пронум.  
Страниц  
Лист и дата  
Лист и дата  
Лист и дата  
Лист и дата



Finish the burrs  
Зачистить заусенцы  
Трещины не допускаются  
Cracks are not permitted.

1. \* - Dimensions are to be ensured by tool.
2. Carry out the soldering on the fixture, which enables to set up the nipples pos. 2 exactly on the corresponding cones and tighten the nuts pos. 1. Carry out the soldering with brass L 63 GOST 15527-70.
3. Partial melting of passage sections is permitted. During this, the ball of  $\phi 6.35$  mm GOST 3722-81 should freely pass through the sections.
4. Test for durability at air pressure of 80 at.  
Carry out the test with three-times loading for 10 min. Breakdown of durability and intactness of joints is not permitted.
5. Coating of surface A - Cad. 9 chrome.  
Primer AK-070, yellow (2)  
Enamel Kh V - 124, gray (4)  
AK - 070 GOST 25718-83  
KhV-124 GOST 10144-89  
and other surfaces Cad. 9 chrome  
Non-cadmium plating of internal surfaces is permitted.
6. Mark Ш, 4 on the tag.
7. Stamp K as per AK-630, AK-630M TU I.

1. \* Размеры обеспеч. инстр.
2. Паять в приспособлении, позволяющем точно установить ниппели поз. 2 на соответствующих конусах и затянуть гайки поз. 1. Пайку производить латуной Л63 ГОСТ 15527-70.
3. Допускается частичное заплывание проходных сечений. При этом шарик  $\phi 6,35$  мм ГОСТ 3722-81 должен свободно проходить через сечения.
4. Испытать на прочность давлением воздуха 80 ат. Испытание производить трехкратным нагружением с выдержкой в течение 10 мин. Нарушение прочности и плотности соединения не допускается.
5. Покрытие поверхности А Кд9. хр.  
Грунтовка АК-070, желтая (2)  
Змаль ХВ-124, серая (4),  
АК-070 ГОСТ 25718-83  
ХВ-124 ГОСТ 10144-89  
остальных поверхностей Кд9. хр.  
Допускается непрокадмирование внутренних поверхностей.
6. Маркировать Ш, 4 на бирке.
7. Клеить К по АК-630, АК-630М ТУ I.

AK-630 SB 114-27 SB

				AK-630 СБ114-27СБ		
				Plug		
				Type	Mass	Scale
				Лит.	Масса	Масштаб
Изм/лист	№ докум.	Подп.	Дата	А	0,150	2:1
Разр.				Лист / Листов		
Пров.				Sheet / Total Sheets		
Т.контр.				Assembly drawing		
Н.контр.						
УТВ.						

First use

Reference No.

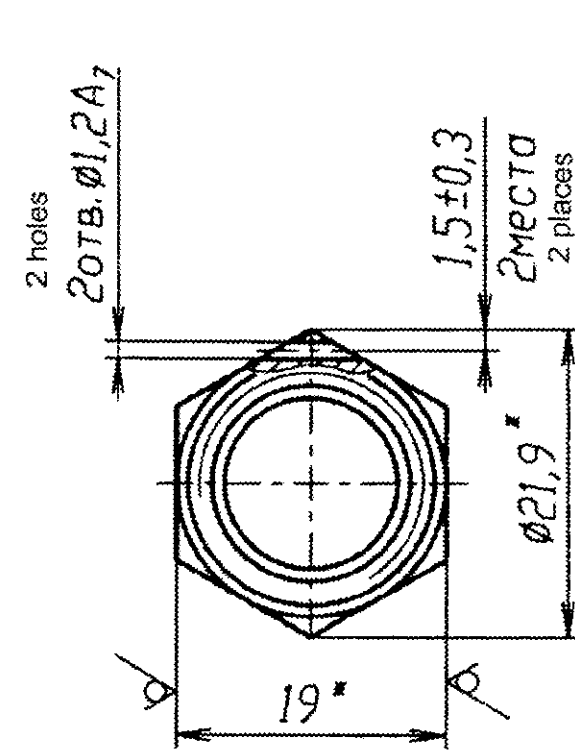
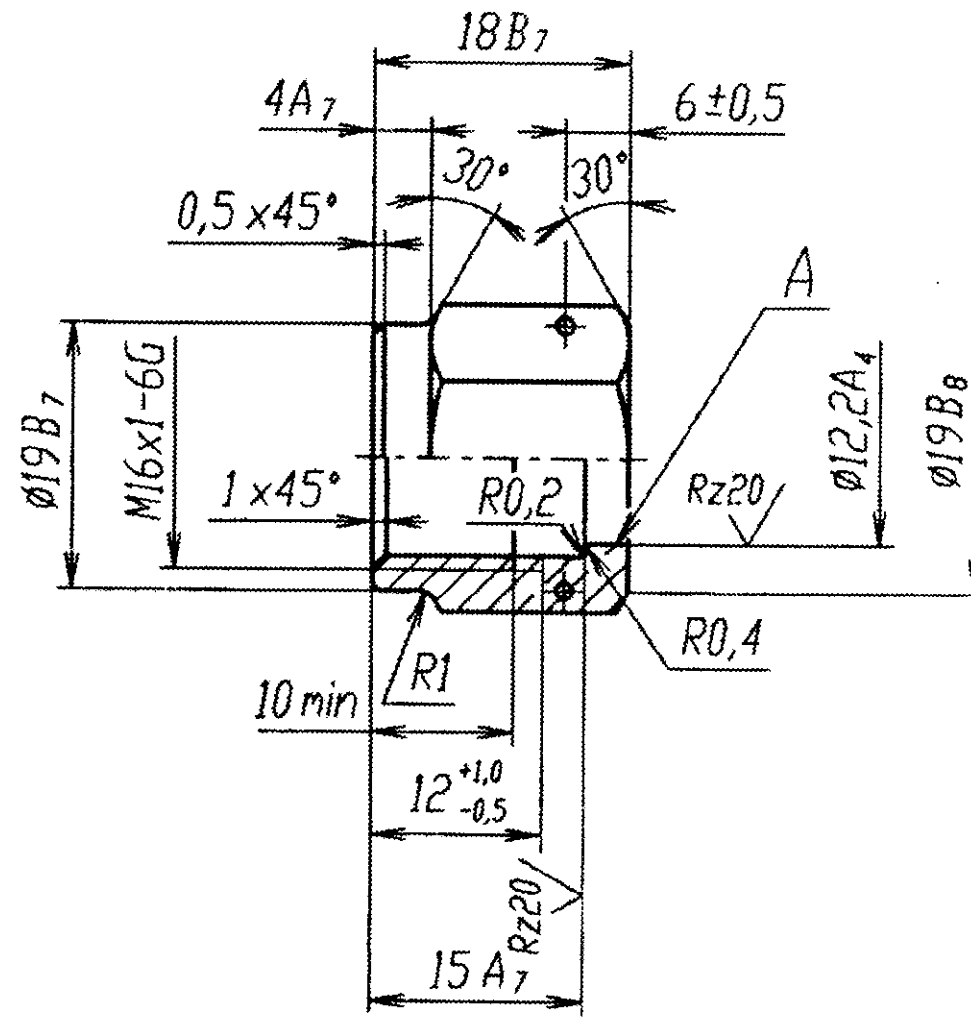
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. Substitute material- hexagon  $\frac{19 - 5GOST8560 - 78}{40GOST1051 - 73}$
2. 31..40.5 HRC<sub>E</sub>. Check 3..5% , but not less than 3 nos. from batch.
- 3.\* Reference dimensions.
4. Blunt sharp edges ~C.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.01 mm.
6. Mark Ш, Ч and стамп К, И on tag.

Designation	Coating
AK-630 114-32	Cd6.phos.
AK-630 -01	Without coating

					AK-630 114-32				
Amend.	Sheet	Doc.No.	Sign	Date	Coupling nut		Type	Weight	Scale
							A	0.025	2:1
Developed by							Sheet	Sheets	1
Checked by									
Head of Q.C.D									
Approved by					Hexagon $\frac{19 - 5GOST8560 - 78}{40Kh - T - VGOST1051 - 73}$				

AK-630 114-33

First use

Approved by shop

Reference No.

Approved KTONI

Sign and Date

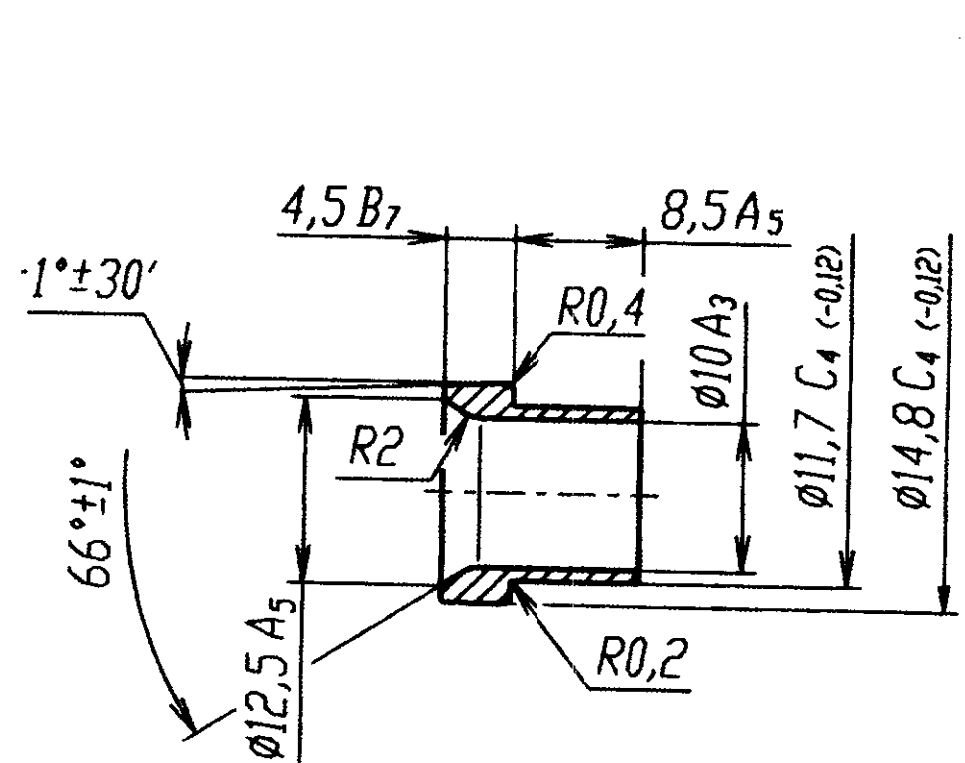
Approved TOSb

Alternate Inv. No

Sign and Date

Approved OGMet

Orig. Inv. No.



Rz20 ✓

Designation	Coating
AK-630 114-33	Kd12. pos
AK-630 -01	without coating

- 1.38.5...44.5 HRC<sub>E</sub>. Check on specimen.
2. Blunt sharp edges ~0.2 mm.
3. Mark Ш, Ч and stamp K, И on tag.

Amend.	Sheet	Doc. No.	Sign	Date

AK-630 114-33			
Nipple	Type	Weight	Scale
	A	0.008	2:1
Sheet		Sheets 1	
Steel 50 GOST 1050-88			

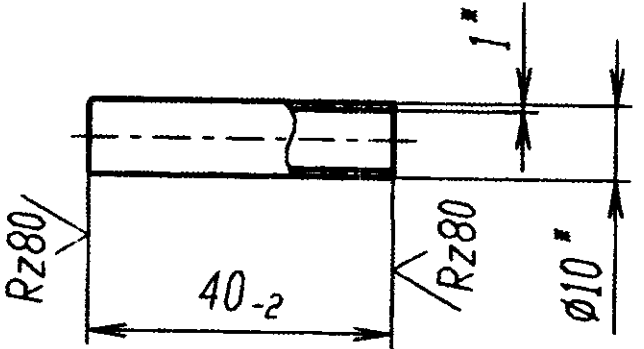
Copied by

Format A4

AK-630 114-65

Approved OGMet	Approved TOSb	Approved KTONI	Approved by shop	Reference No.	First use														
Orig. Inv. No.	Alternat. Inv. No.	Dupl. Inv. No.	Sign and Date																
Amend.	Sheet	Doc. No.	Sign	Date	<p>AK-630 114-65</p> <p>Pipe</p> <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th>Type</th> <th>Weight</th> <th>Scale</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>0.017</td> <td>1:1</td> </tr> <tr> <td>Sheet</td> <td colspan="2">Sheets 1</td> </tr> </tbody> </table> <p>Pipe M2 M10 x1 GOST 617-90</p>						Type	Weight	Scale	A	0.017	1:1	Sheet	Sheets 1	
Type	Weight	Scale																	
A	0.017	1:1																	
Sheet	Sheets 1																		
Developed by																			
Checked by																			
Head of Q.C.D																			
Design bureau chief																			
Head of Q.C.D																			
Approved by																			

1. \* Reference dimensions.
2. Blunt sharp edges ~0.4 mm.
3. Coating Chem. Pass.
4. Mark Ш, Ч and stamp K on tag.



Copied by

Format A4



First use

Reference No.

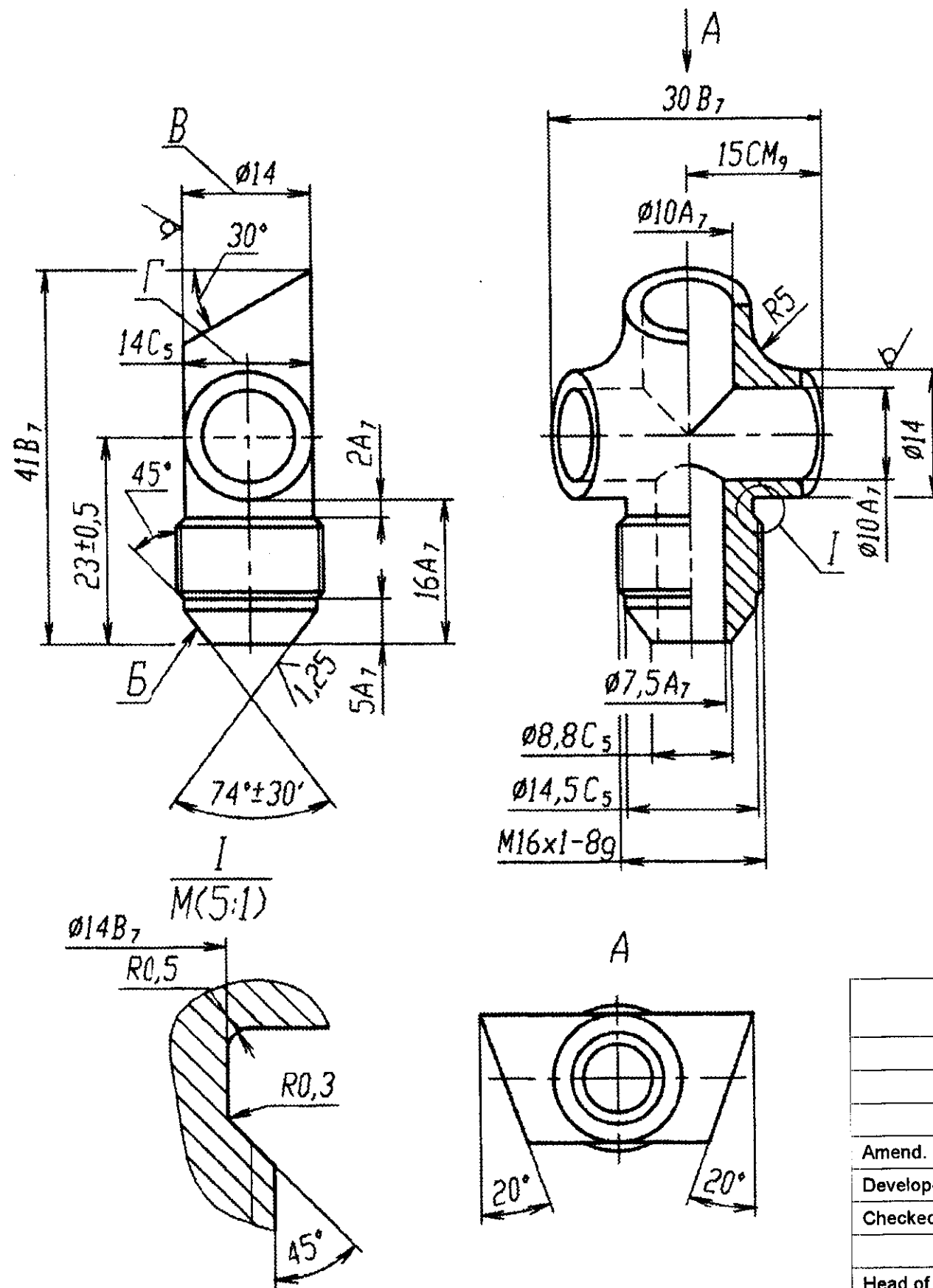
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



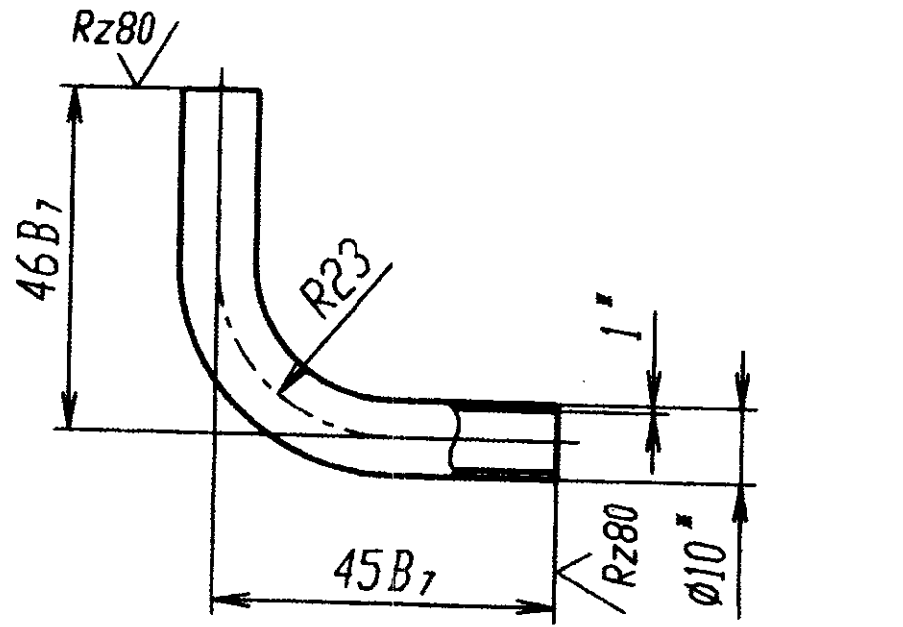
Rz40 ✓ (✓)

1. Substitute material- Steel 40 Kh GOST 4543-71.
2. Blank- forging accuracy class T5 as per GOST 7505-89.  
Surface defects on un machined surfaces should not be larger than 0.5 mm in depth.
3. Forging gradient up to 7°.
4. Inner angles R~0.4 mm.
5. Blunt sharp edges ~0.4 mm.
6. Cut of diameter B up to dimension Γ is permissible.
7. Run out of surface A with respect to mean diameter of thread is not more than 0.05 mm.
8. Mark Ш, Ч and stamp K on tag.

					AK-630 114-66			
Amend.	Sheet	Doc.No.	Sign	Date	Cross-piece	Type	Weight	Scale
						A	0.040	2:1
Developed by					Steel 50 GOST 1050-88	Sheet	Sheets 1	
Checked by								
Head of Q.C.D								
Approved by								

AK-630 114-37

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



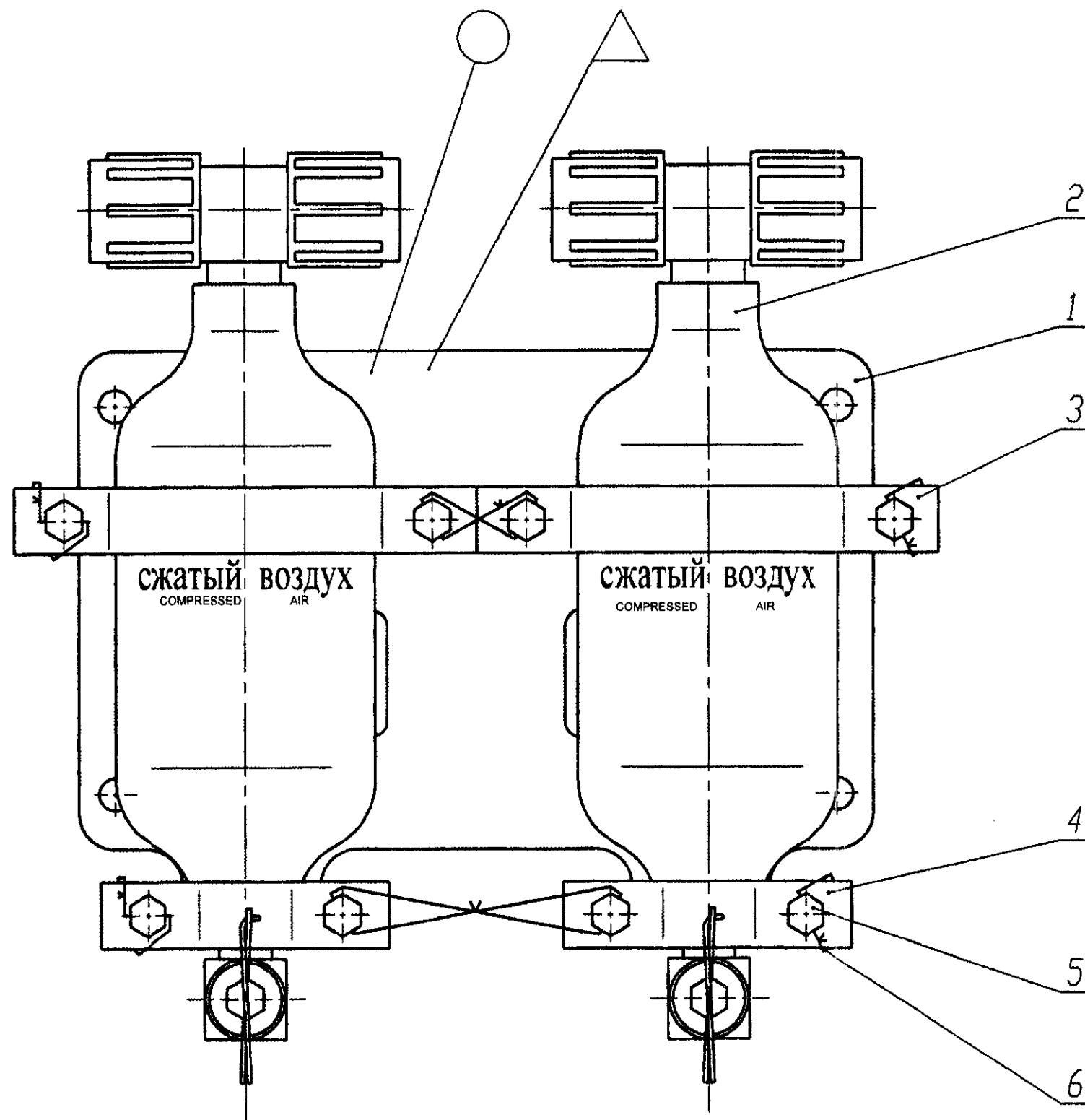
1. \* Reference dimensions.
2. Blunt sharp edges ~0.4 mm.
3. Coating Chem. Pass.
4. Mark Ш, Ч and stamp K on tag.

AK-630 114-67

Amend.	Sheet	Doc. No.	Sign	Date

Pipe	Type	Weight	Scale
	A	0.035	1:1
	Sheets 1		
Pipe M2 M10 x1 GOST 617-90			

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
						<u>Documents</u>		
Reference No.	A2		✓	AK-630 Sb 114-4 SB	Assembly drawing			
					<u>Assembly units</u>			
	A4		1	AK-630 Sb 114-28	Base plate of oil-moisture separators	1		
	A4		2	AK-630 Sb 114-29	Oil-moisture separator	2		
	A4		3	AK-630 Sb 114-30	Clamp	2		
	A4		4	AK-630 Sb 114-31	Clamp	2		
					<u>Standard articles</u>			
Sign and Date			5		Bolt 3M6-8gx20.109.40Kh.029 GOST 7805-70	8	65.5-70HRA	
					<u>Materials</u>			
Dupl. inv. No.			6		Wire 1-T-12Cr18Ni10Ti GOST 18143-72	0.5	m.	
Alternate Inv. No.								
Sign and Date								
Orig. Inv. No.								
	Amend.	Sheet	Doc. No.	Sign	Date	<b>AK-630 Sb 114-4</b>		
	Developed by							
	Checked by					<b>Attachment of oil-moisture separator</b>	Type	Sheet
					A			1
Head of Q.C.D								
Approved by								



Mark Ш, Ч and stamp K as per AK-630, AK-630M TU 1.

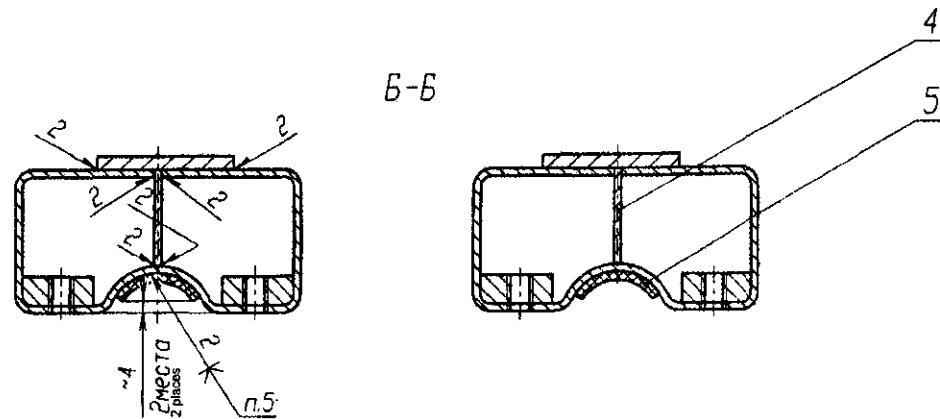
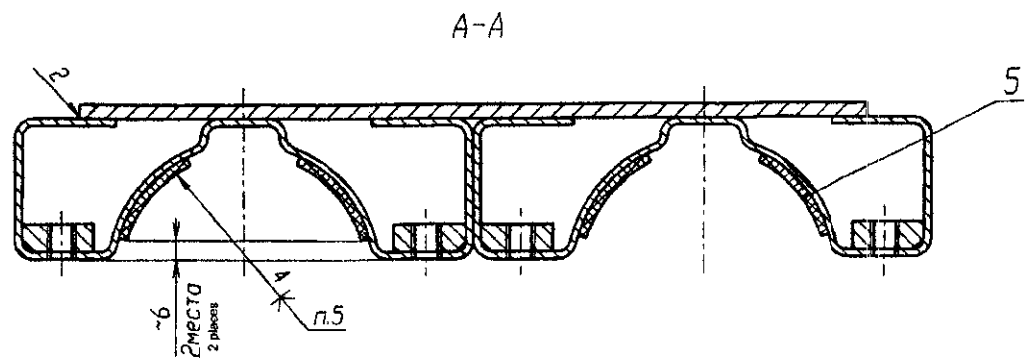
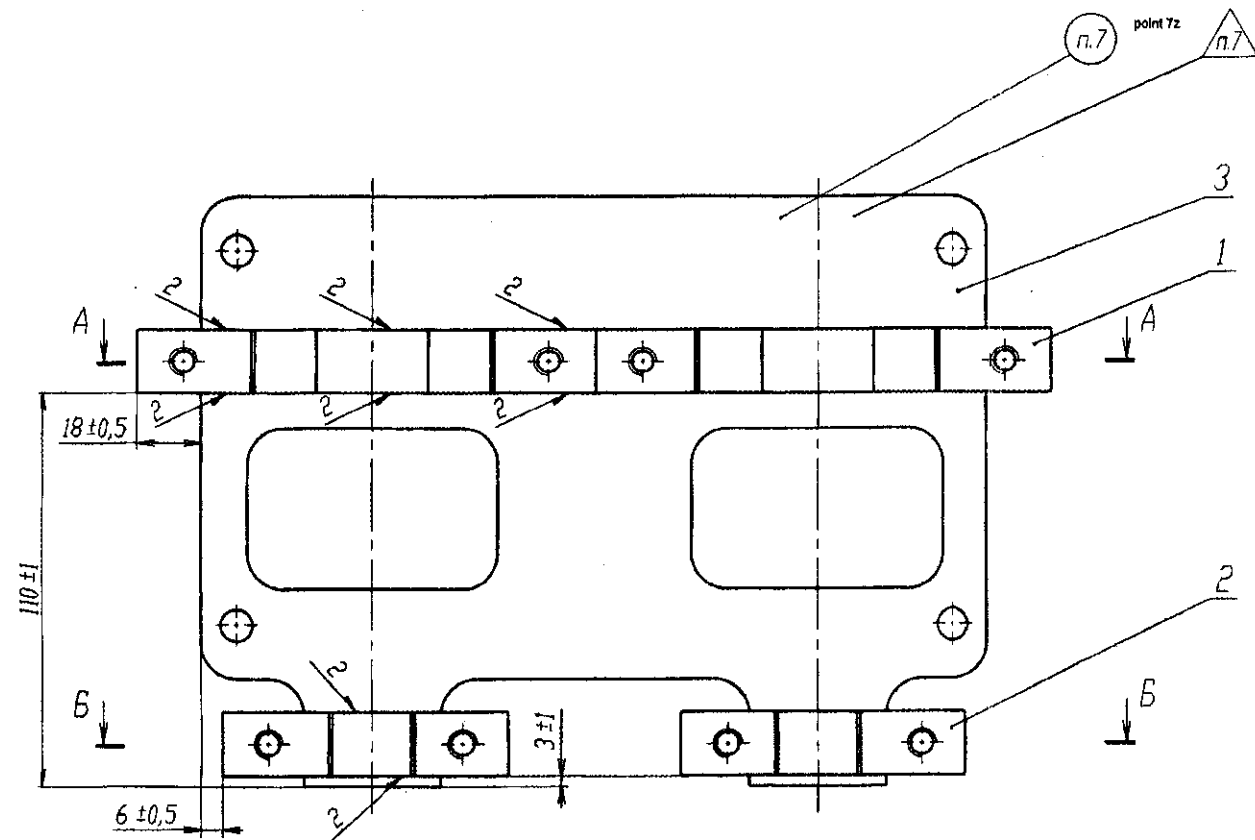
Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ 1.

Исполн. Лодт. и Лото  
 Провер. Лодт. и Лото  
 Разработ. Лодт. и Лото  
 Констр. Лодт. и Лото  
 Утвер. Лодт. и Лото

AK-630 SB 114-4 SB

				AK-630 СБ114-4СБ		
				Type	Mass	Scale
Изм.	Лист	№ докум.	Подп.	Дата	Fastening of oil-moisture separator	
Разраб.					Крепление	
Пров.					масловолагоотделителей	
Т.контр.					Сборочный чертеж	
				Лист	Листов 1	
				Assembly drawing		
				Sheet	Total Sheets	
				Утв.		

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A1		✓	AK-630 Sb114-28 SB	Assembly drawing			
					<u>Components</u>			
	A4		✓1	AK-630 sb114-39	Upper base plate	2		
	A4		✓2	AK-630 Sb114-38	Lower base plate	2		
					<u>Components</u>			
	A3		✓	AK-630 114-68	Frame	1		
	A4		✓	AK-630 114-87	Frame	2		
	A4		✓	AK-630 114-89	Gasket	6		
Sign and Date								
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date								
Orig. Inv. No.					<b>AK-630 Sb 114-28</b>			
	Amend.	Sheet	Doc. No.	Sign	Date			
	Developed by					Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D					Base plate of Oil-moisture separator		
	Approved by							



1. Welded joints as per GOST 5264-80-T1-Δ 2 and NI-Δ 2
2. Electrode UONI 13/45 2.0-2 GOST 9466-75.
3. Straightening and bending of mated components is permitted.
4. Welding in the medium of carbonic acid gas is permitted with the use of filler electrode 1.2 Sv - 08 G 2 S GOST 2246-70.
5. Glue the gaskets pos. 5 with glue 88 - NP TU 38 105 540-85.
6. Coating Kad 12, phos.  
Primer AK-070, yellow (2)  
Enamel KhV-124, gray (4), IV, OM2.  
AK-070 GOST 25718-83  
KhV-124 GOST 10144-89 before the setting of gasket pos. 5.
7. Mark III, 4 and stamp K as per AK-630, AK-630M TU 1.

1. Сварные швы по ГОСТ 5264-80-T1-Δ 2 и NI-Δ 2. Электрод УОНИ 13/45 2,0-2 ГОСТ 9466-75.
  2. Сварку производить по линии соприкосновения деталей.
  3. Допускается правка и подгибка сопрягаемых деталей.
  4. Допускается сварка в среде углекислого газа с применением присадочной проволоки 1,2Св-08Г2С ГОСТ 2246-70.
  5. Прокладки поз. 5 приклеить клеем 88-НП ТУ 38 105 540-85. Допускается применение клея 88-СА ТУ 38 1051760-89.
  6. Покрытие Кд12 фос.  
Грунтовка АК-070, желтая (2)  
Эмаль ХВ-124, серая (4), IV, OM2,  
АК-070 ГОСТ 25718-83  
ХВ-124 ГОСТ 10144-89
- до постановки прокладки поз. 5.
7. Маркировать ш, 4 и клеить К по АК-630, АК-630М ТУ 1.

				AK-630 СБ114-28СБ	
				Лит.	Масштаб
Изм.	Лист	№ докум.	Подп.	Дата	Основание масло-влагоотделителя
Разраб.					Сборочный чертёж
Провер.					Лист 1
Инженер					Листов 1
Утв.					Sheet 1
					Total Sheets

Спецификация  
Состав  
Вопросы и ответы  
Различные виды  
Вопросы и ответы

First use

Reference No.

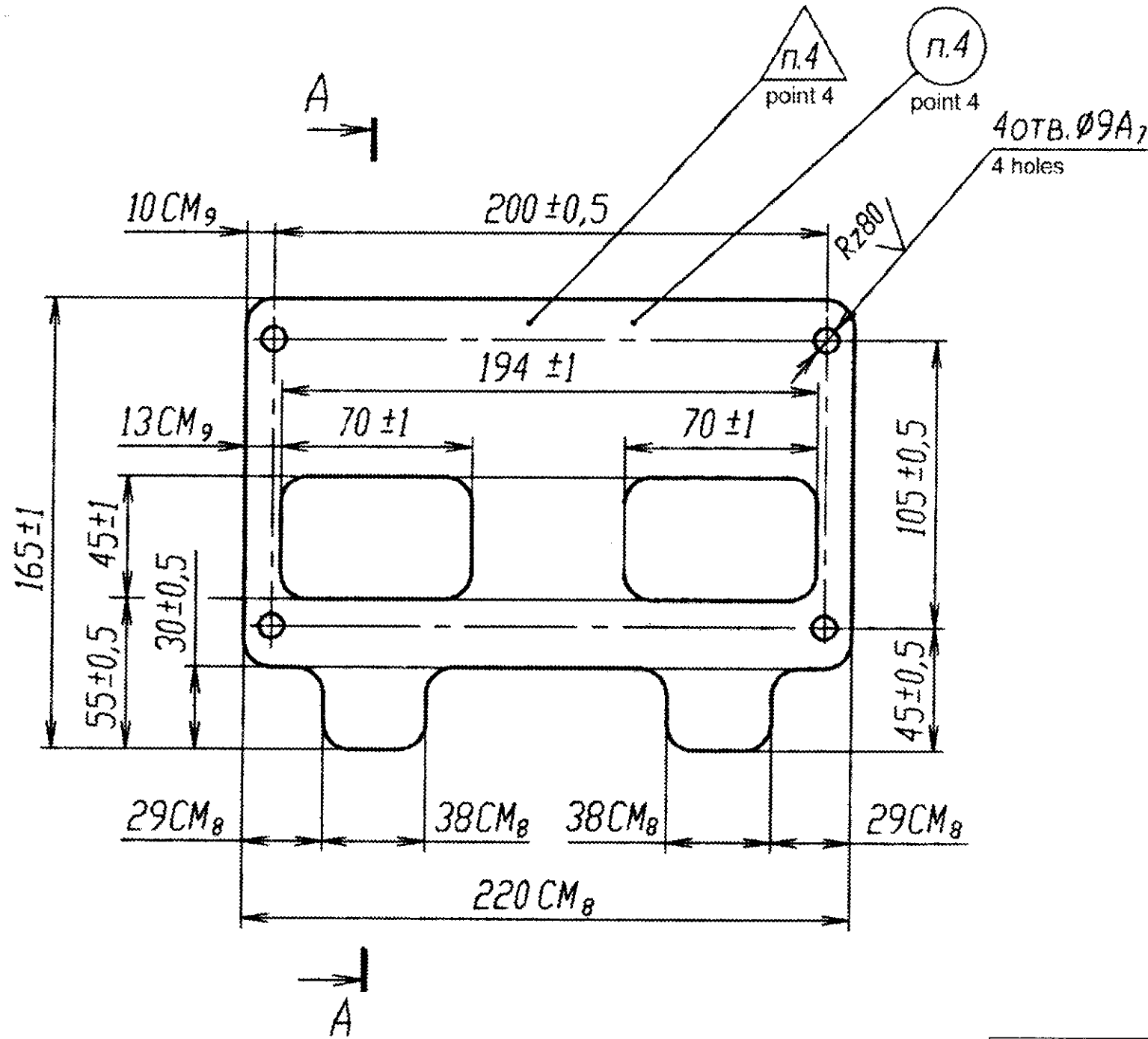
Sign and Date

Duplicate Inv. No

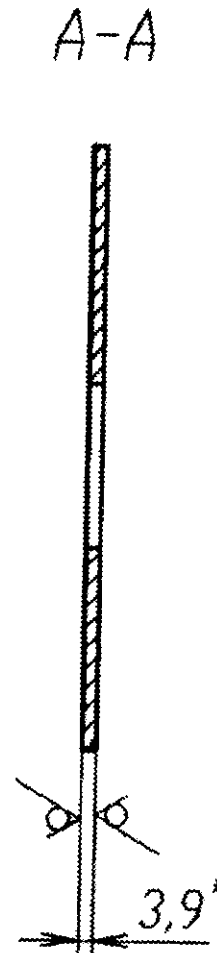
Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz320  
✓(✓)

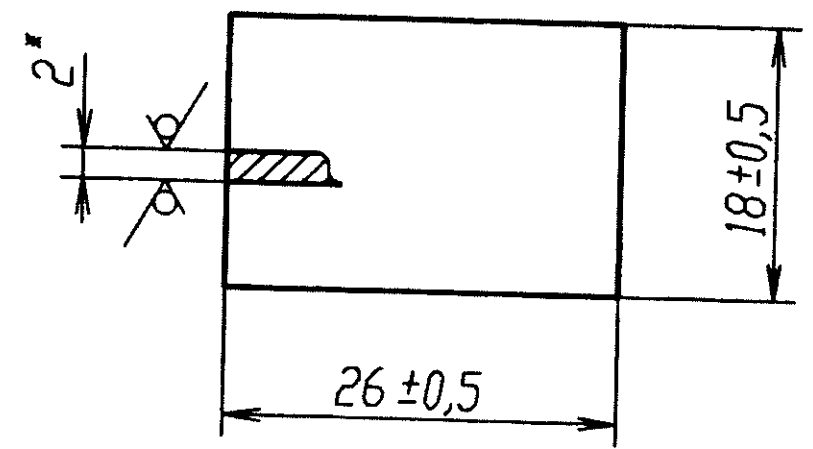


1. \* Reference dimension.
2. Radii along external and inner contours R~ 10 mm.
3. Blunt sharp edges ~0.4 mm.
4. Mark Ш, Ч and stamp K as per AK-630, AK-630 M TU I.

					<b>AK-630 114-68</b>			
Amend.	Sheet	Doc.No.	Sign	Date	Frame	Type	Weight	Scale
Developed by						A	0.820	1:2
Checked by						Sheet	Sheets	1
Head of Q.C.D						Sheet $\frac{B-PN-0-3.9GOST19903-74}{K390V4-III-25GOST16523-97}$		
Approved by								

AK-630 114-87

Approved OGMet	Orig. Inv. No.	Approved TC	Approved KTONI	Approved by shop	First use
	Sign and Date	Alternate Inv. No.	Sign and Date	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				



Rz320  
✓ (✓)

- 1.\* Reference dimensions.
- 2. Blunt sharp edges  $\sim 0.4$  mm.
- 3. Mark Ш, Ч and stamp K on tag.

AK-630 114-87

AK-630 114-87			
Rib	Type	Weight	Scale
	A	0.007	2:1
Sheet		Sheets 1	
Sheet $B - PN - 02 GOST 19903 - 74$			
Sheet $K390V4 - III - 25 GOST 16523 - 97$			

Copied by

Format A4



AK-630 114-89

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

1. \* Reference dimension.  
2. Mark Ш, Ч and stamp K on tag.

AK-630 114-89				
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				

AK-630 114-89			
Gasket	Type	Weight	Scale
	A	0.003	1:1
			Sheets 1
Plate 1N-I MBS-M <sub>1</sub> -1 GOST 7338-90			

Copied by

Format A4



AK-630 Sb114-38 SB

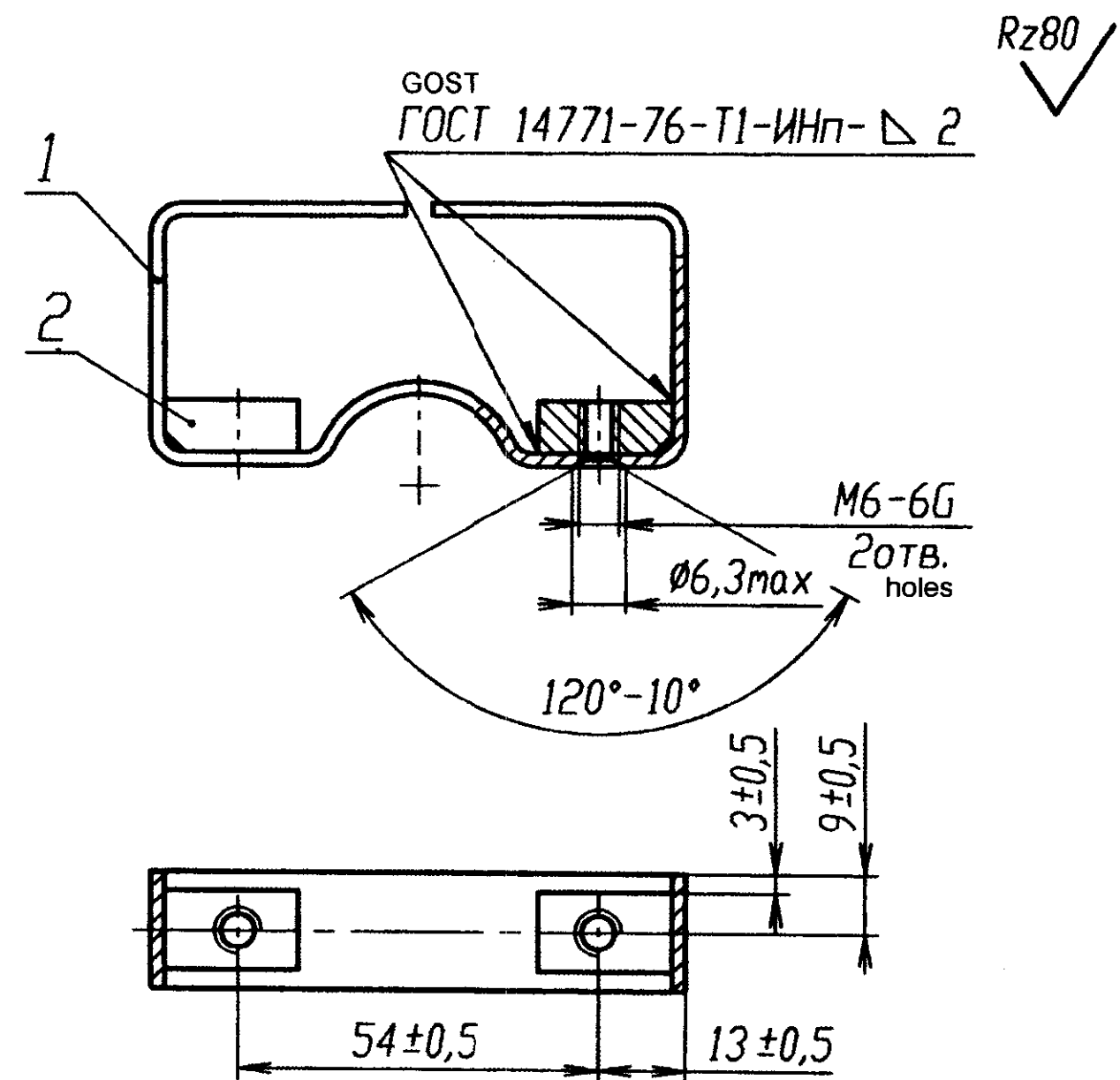
First use

Approved by shop  
Reference No.

Approved KTONI  
Sign and Date

Approved Tcusb  
Altermate Inv. No Dupl. Inv. No.

Approved OGMet  
Orig. Inv. No. Sign and Date



1. Argon-arc welding by using filler wire 2 Sv-18KhMA GOST 2246-70. Use of wire 2 Sv-08A GOST 2246-70. It is permissible to carry out welding in carbon dioxide medium by using filler wire 1.2 Sv-08G2S GOST 2246-70.
2. Mark III, 4 and stamp K on tag.

Amend.	Sheet	Doc. No.	Sign	Date

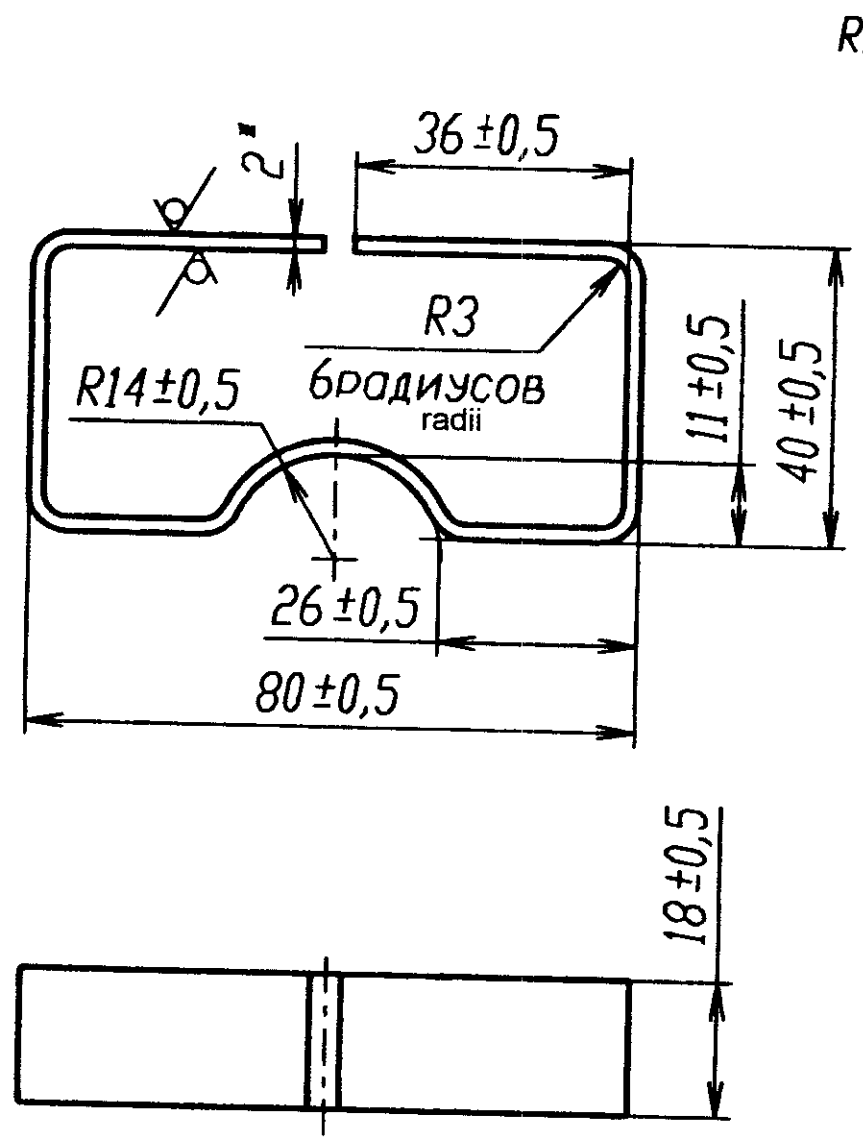
AK-630 Sb114-38 SB			
Type	Weight	Scale	
A	0.090	1:1	
Sheet	Sheets 1		

Copied by

Format A4

AK-630 114-92

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



- \* Reference dimensions.
- Blank length  $L = 228 \pm 1$  mm.
- Blunt sharp edges  $\sim 0.4$  mm.
- Mark Ш, Ч and stamp K on tag.

Amend.	Sheet	Doc. No.	Sign	Date

<b>AK-630 114-92</b>			
<b>Clamp</b>	Type	Weight	Scale
	A	0.065	1:1
	Sheet	Sheets 1	
Sheet	B - PN - 02 GOST 19903 - 74 K 390V 4 - III - 25 GOST 16523 - 97		

Сопров. лист  
Формат А4

<b>AK-630 114-95</b>					
Approved OGMet	Orig. Inv. No.	Sign and Date	Alternate Inv. No.	Approved Tusb	Dupl. Inv. No.
				Approved KTONI	Sign and Date
				Approved by shop	Reference No.
					First use

1. Blunt sharp edges ~0.4 mm.  
 2. Mark Ш, Ч and stamp K on tag.

<b>AK-630 114-95</b>									
<b>Insert</b>	Type	Weight	Scale						
	A	0.015	2:1						
	Sheet		Sheets 1						
Steel 25 GOST 1050-88									

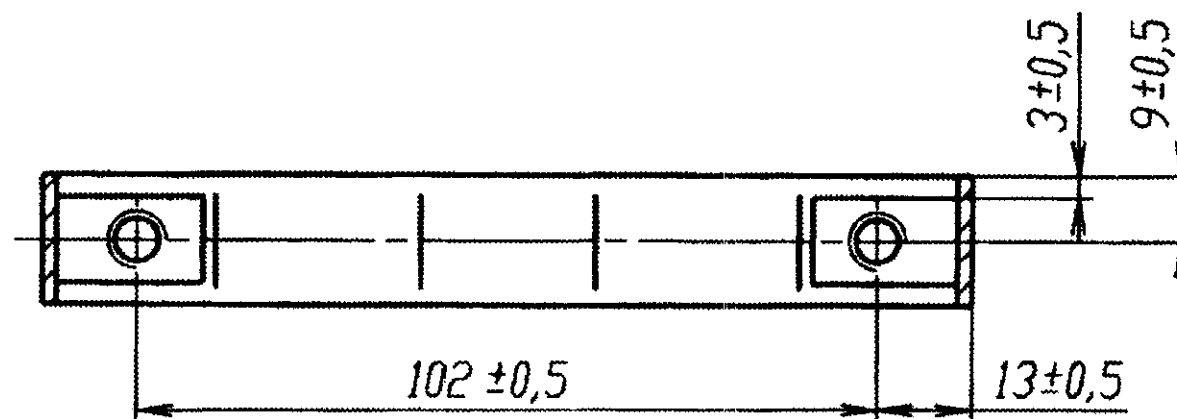
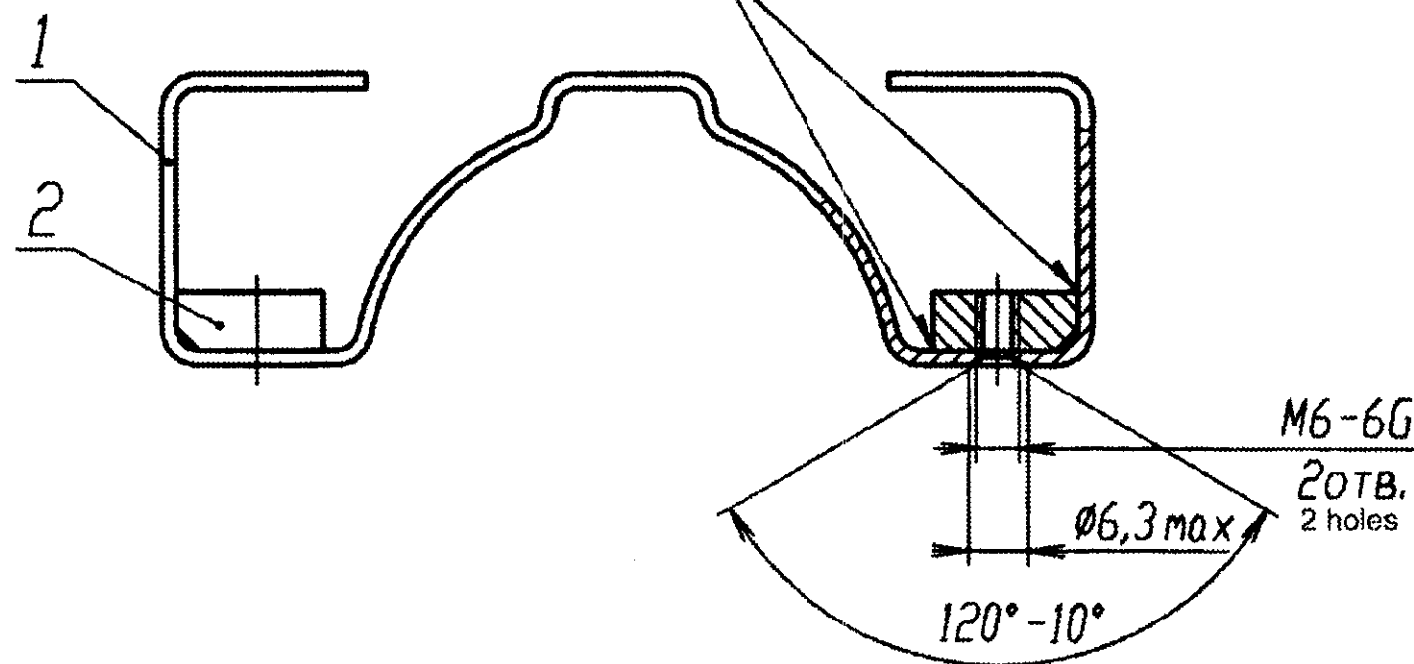
Control by

Formet A4

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
Reference No.					<u>Documents</u>		
	A3		✓	AK-630 Sb114-39 SB	Assembly drawing		
					<u>Components</u>		
	A3		✓1	AK-630 114-94	Clamp	1	
	A4		✓2	AK-630 114-95	Insert	2	
Sign and Date					<b>AK-630 Sb 114-39</b>		
	Amend.	Sheet	Doc. No.	Sign	Date		
Sign and Date	Developed by						
	Checked by						
Orig. Inv. No.	Head of Q.C.D				<b>Upper base plate</b>		
	Approved by						
Orig. Inv. No.					Type	Sheet	Sheets
					A		1

GOST ГОСТ 14771-76-T1-ИИП- Δ 2

Rz80



1. Argon-arc welding by using filler wire 2 Sv-18KhMA GOST 2246-70.  
It is permissible to use wire 2 Sv-08A GOST 2246-70.
2. Welding in CO<sub>2</sub> medium is permissible by using filler wire 1.2 Sv-08 G2S GOST 2246-70.
3. Mark Ш, 4 and stamp K on tag.

					AK-630 Sb114-39 SB			
Amend.	Sheet	Doc.No.	Sign	Date	Upper base-plate Assembly drawing	Type	Weight	Scale
Developed by						A	0.105	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by								

First use

Reference No.

Sign and Date

Duplicate Inv. No

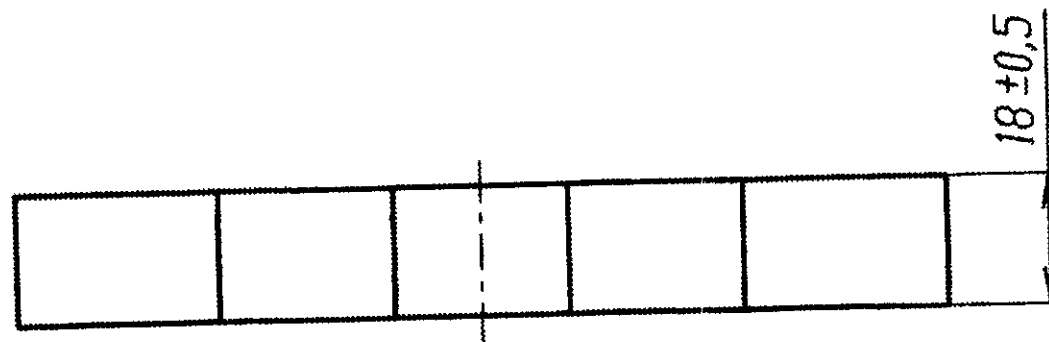
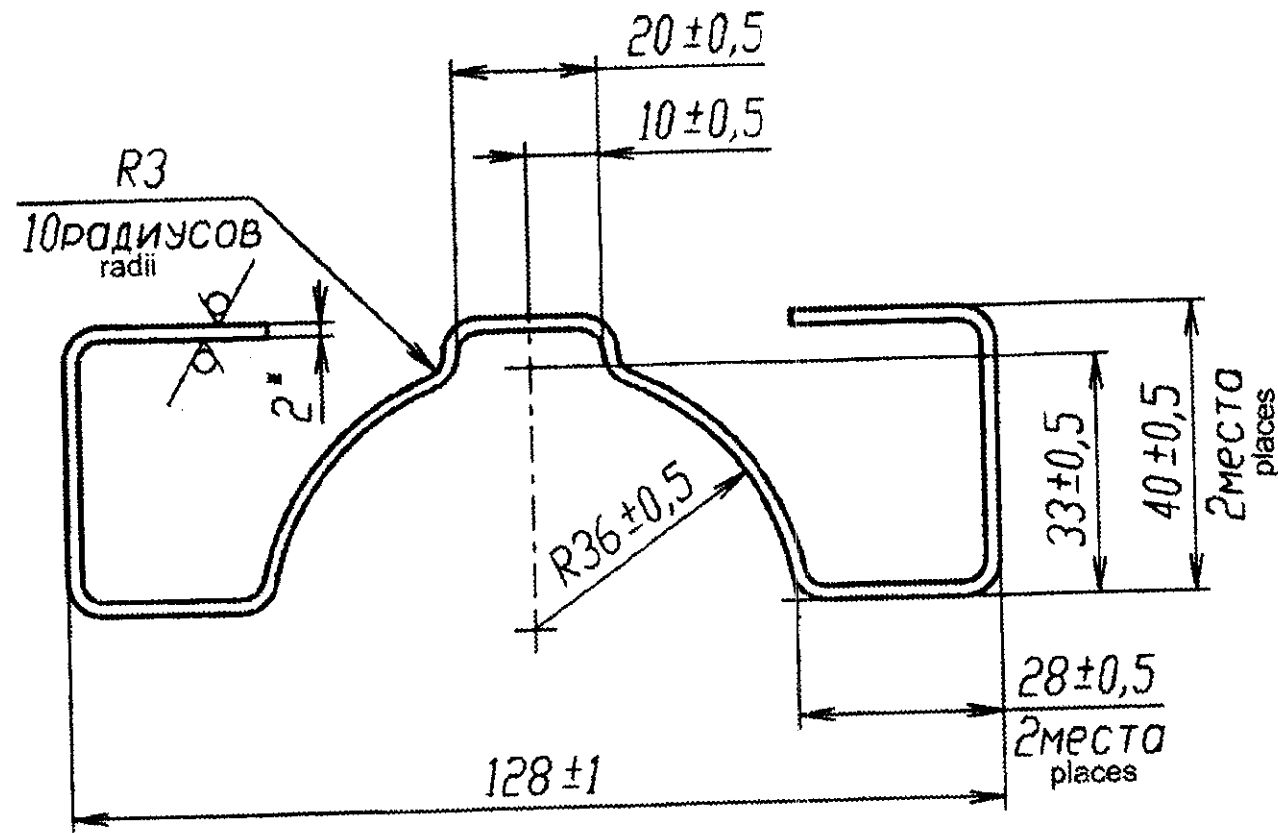
Alternate Inv. No

Sign and Date

Orig. inv. no.

AK-630 114-94

Rz80  
✓(✓)



- 1.\* Reference dimension.
2. Unrolled length  $L = 295 \pm 1$  mm.
3. Mark Ш, Ч and stamp К on tag.

					AK-630 114-94			
Amend.	Sheet	Doc.No.	Sign	Date	Clamp	Type	Weight	Scale
Developed by						A	0.080	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Sheet $B - PN - 02GOST1993 - 74$			
Approved by					K390V - 4 - III - 25GOST16523 - 97			

First use

Reference No.

Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



AK-630 114-95

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

1. Blunt sharp edges ~0.4 mm.  
 2. Mark Ш, Ч and stamp K on tag.

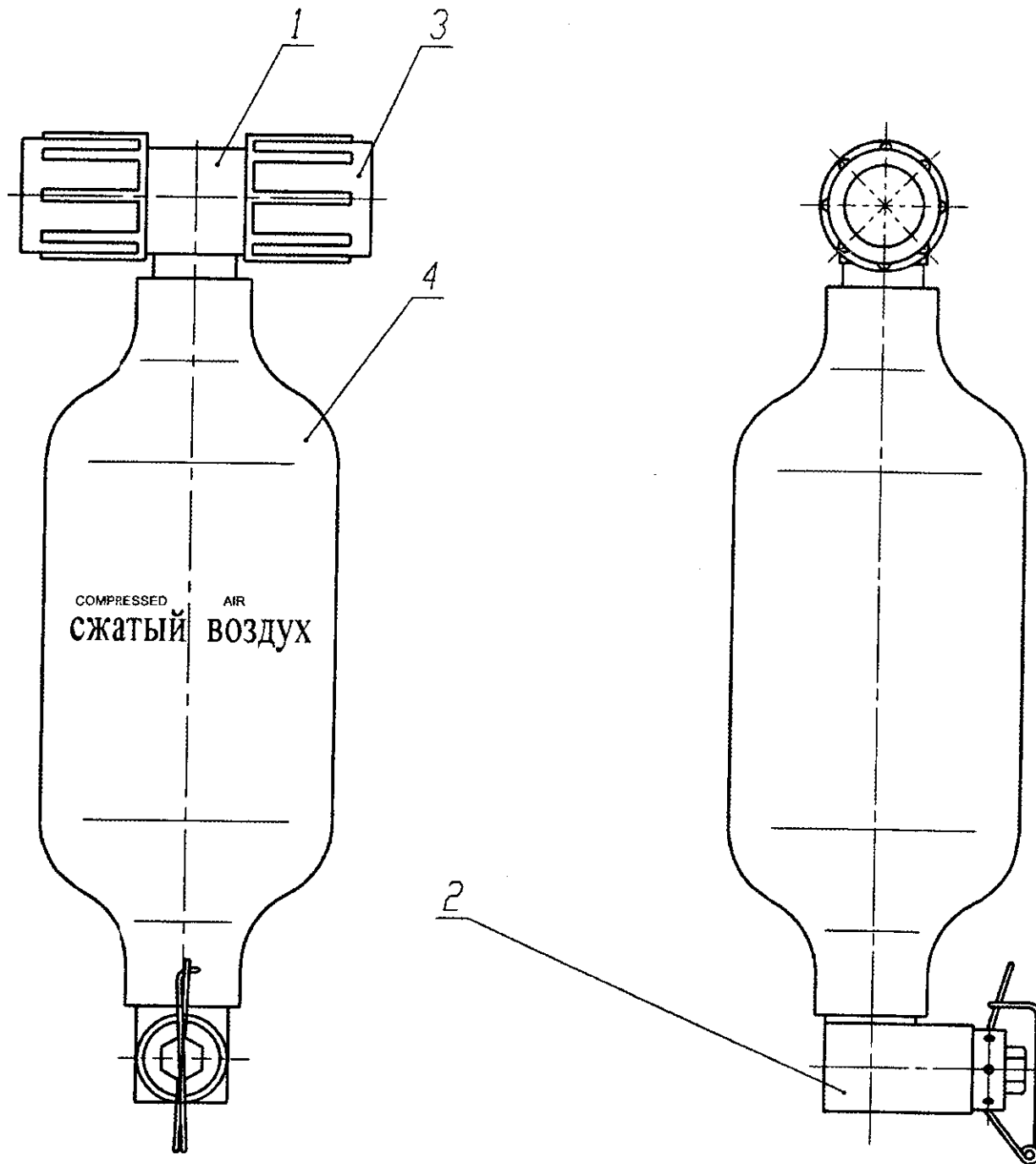
AK-630 114-95				
Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				
Copied by				

AK-630 114-95			
Insert	Type	Weight	Scale
	A	0.015	2:1
	Sheet		Sheets 1
Steel 25 GOST 1050-88			

Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks																																			
							First use																																		
				<u>Documents</u>																																					
A2		✓	AK-630 Sb114-29 SB	Assembly drawing																																					
				<u>Assembly units</u>																																					
A4		✓ 1	AK-630 Sb 114-35 <sub>35</sub>	Tee joint with pipe	1																																				
A4		✓ 2	AK-630 Sb 114-60 <sub>36</sub>	Discharge valve	1																																				
				<u>Components</u>																																					
A3		✓ 3	AK-630-01 100-301T	Cover	2																																				
				<u>Other articles</u>																																					
		4		Cylinder 0.4-150	1																																				
				TU 14-3-768-78																																					
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%; text-align: center;">Sign and Date</td> <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> <td style="width:15%;"></td> </tr> <tr> <td style="text-align: center;">Dupl. Inv. No.</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td style="text-align: center;">Alternate Inv. No.</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td style="text-align: center;">Sign and Date</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td style="text-align: center;">Orig. Inv. No.</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </table>							Sign and Date							Dupl. Inv. No.							Alternate Inv. No.							Sign and Date							Orig. Inv. No.						
Sign and Date																																									
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Alternate Inv. No.																																									
Sign and Date																																									
Orig. Inv. No.																																									
<b>AK-630 Sb 114-29</b>																																									
				<b>Oil-moisture separator</b>																																					
Amend.	Sheet	Doc. No.	Sign	Date	Type	Sheet																																			
Developed by					A	1																																			
Checked by																																									
Head of Q.C.D																																									
Approved by																																									

AK-630 СБ114-29СБ

AK-630 Sb 114 - 29 SB



1. Баллон поз. 4 перед постановкой в него тройника с трубкой поз. 1 и вентиля сливного поз. 2 продуть поочередно с двух концов сжатым воздухом давлением 80 ат. в течение 10 сек. на отсутствие инородных тел.

2. Перед постановкой в баллон тройник поз. 1 поочередно продуть через штуцера сжатым воздухом давлением 80 ат. в течение 20 сек. на отсутствие инородных тел.

3. Покрытие наружной поверхности баллона  
Грунтовка АК-070, желтая (2)  
Эмаль ХВ-124, серая (4), IV, OM2,  
АК-070 ГОСТ 25718-83  
ХВ-124 ГОСТ 10144-89

4. На баллон нанести надпись "Сжатый воздух" эмалью ПФ-115, белой, ГОСТ 6465-76. Шрифт ПО-5 ГОСТ ГОСТ 2930-62.

5. Несимметричность расположения надписи не более 3 мм. Допускается располагать надпись в две строки.

6. Маркировать Ш, Ч и клеймить К на бирке.

- Before the fitment of tee with pipe pos. 1 and drain valve pos. 2 on the cylinder, blow it with compressed air alternatively from both the ends at the pressure of 80 at. for 10 seconds in order to ensure the absence of foreign bodies in it.
- Before the fitment on cylinder, blow the tee pos. 1 through the pipe union with compressed air with pressure of 80 at. for 20 seconds in order to ensure the absence of foreign bodies in it.
- Coating of the external surface of cylinder:  
Primer AK - 070, yellow (2),  
Enamel KhV-124, gray (4), IV, OM2,  
AK-070 GOST 25718-83  
KhV-124 GOST 10144-89.
- On cylinder, make the inscription "Compressed Air" with enamel PF-115, white, GOST 6465-76. Font PO-5 GOST 2930-62.
- Non-symmetry of the positioning of inscription is not more than 3 mm. It is permitted to arrange the inscription in two lines.
- Mark Ш, Ч and stamp K on the tag.

AK-630 Sb 114 - 29 SB

AK-630 СБ114-29СБ

				AK-630 Sb 114 - 29 SB		
				Type	Mass	Scale
				Лит.	Масса	Масштаб
Изм/Лист	№ докум	Подп.	Дата	А	1,350	1:1
Разраб.				Oil-moisture separator Масловолагоотделитель		
Пров.				СБОРОЧНЫЙ ЧЕРТЕЖ Assembly drawing		
Т.контр.				Лист	Листов	
И.контр.				Sheet	Total Sheets	
Утв.						

Бале 9 \_ Container 6

Формат А2

Изм. № Подп. и дата Изм. № Подп. и дата Изм. № Подп. и дата Изм. № Подп. и дата Изм. № Подп. и дата

Лев. плеч.

Справ.

First use

Reference No.

Sign and Date

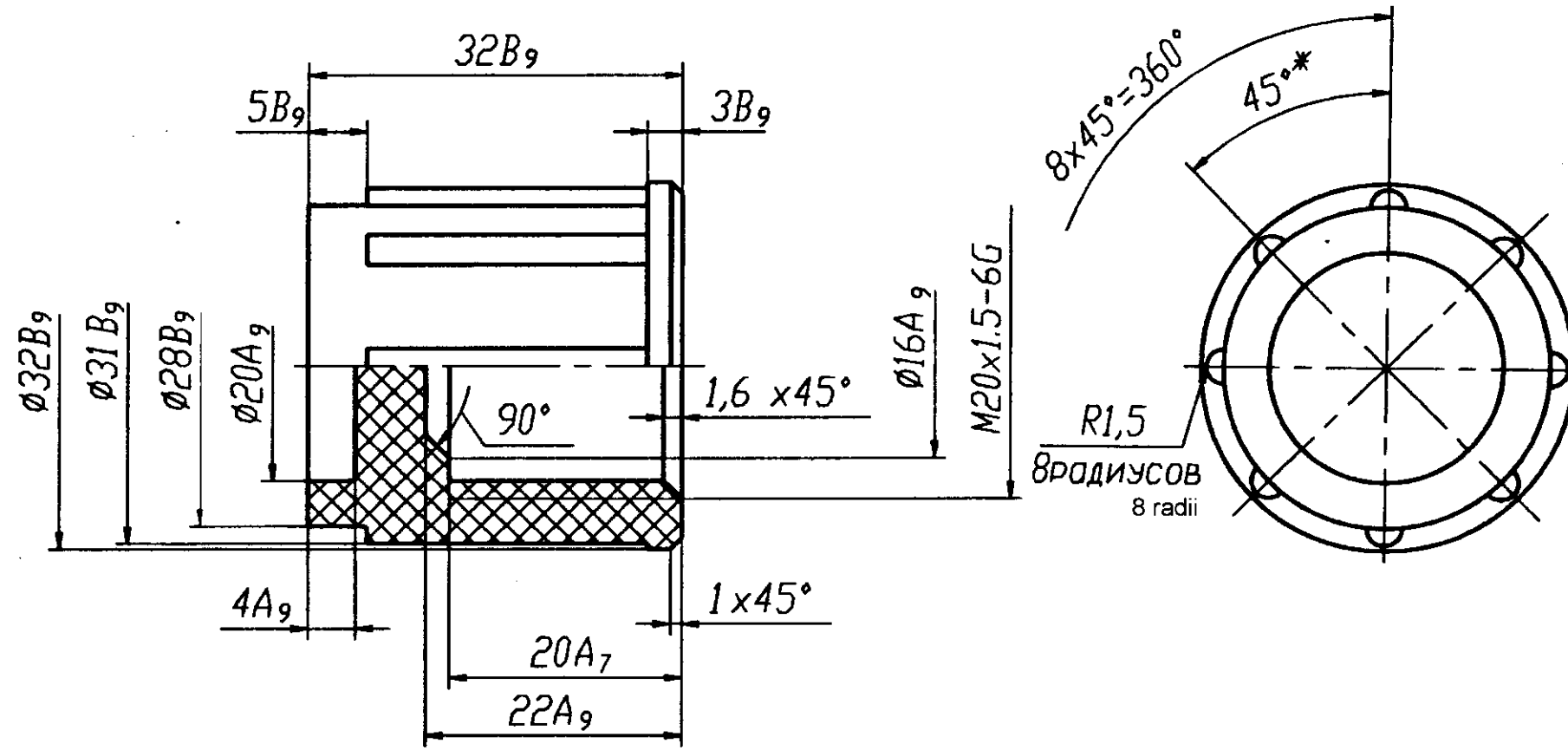
Duplicate Inv. No

ite Inv. No

Alt

Sign and Date

Orig. inv. no.



1. It is permissible to make the components from polyamide 6 PA6-210/310 OST 6-06-S9-93.
2. Radii R~ 0.4 mm unless otherwise specified.
3. Blunt sharp edges R~0.4 mm.
4. Technical requirements as per OST VZ-4346-80.
5. Surface finish of moulding surfaces of press mould  $0.32 \sqrt{\quad}$ .
- 6.\* Maximum deviation of dimensions between axes of any two projections  $\pm 1^\circ$ .
7. Colour of material is not standardized.
8. Mark Ш, Ч and stamp K on batch tag.

Comment:

					AK-630 -Yu 100-301 T			
					<b>Cover</b>	Type	Weight	Scale
						A	0.005	2:1
						Sheet	Sheets	1
					Polyethylene 209 GOST 16338-85			
Amend.	Sheet	Doc.No.	Sign	Date				
Developed by								
Checked by								
Head of Q.C.D								
Approved by								

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
Reference No.					<u>Documents</u>		
	A3		✓	AK-630 Sb114-36 SB	Assembly drawing		
					<u>Assembly units</u>		
	A4		1✓	AK-630 Sb114-37	Valve	1	
					<u>Components</u>		
	A2		2✓	AK-630 114-74	Body	1	
	A4		3✓	AK-630 114-77	Clip	1	
Sign and Date							
Dupl. Inv. No.							
Alternate Inv. No.							
Sign and Date							
Orig. Inv. No.							
	Amend.	Sheet	Doc. No.	Sign	Date	<b>AK-630 Sb 114-36</b>	
	Developed by				Type		
	Checked by				A		1
Head of Q.C.D				<b>Discharge valve</b>			
Approved by							

First use

Reference No.

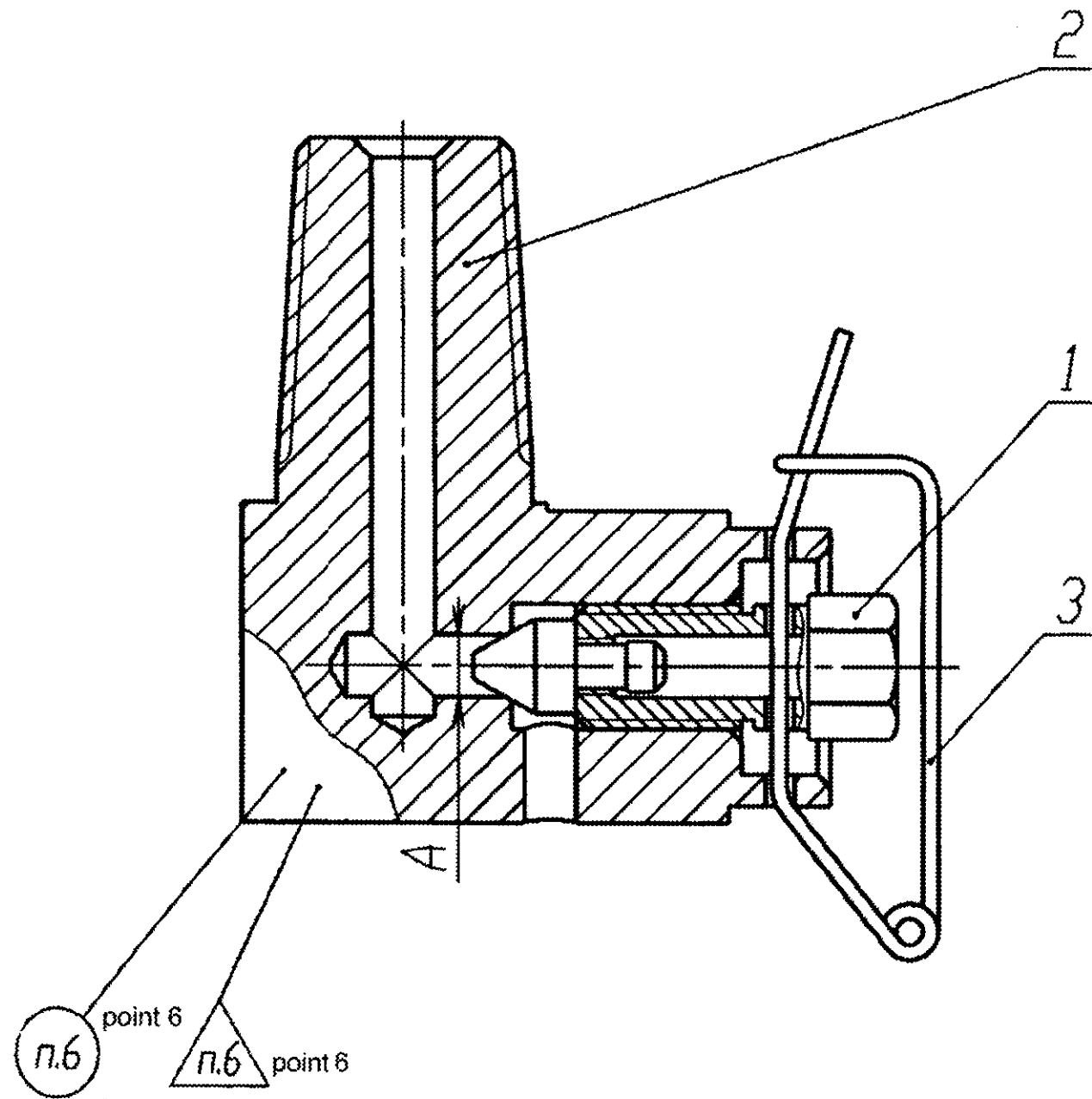
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. Press sharp edge of hole A component pos.2 with taper of valve pos. 1 during assembly.
2. Lubricate thread Sb. pos.1 with lubricant MS-70 GOST 9762-76.
3. Set the valve at middle position and blow with compressed air (3..5 kgf/cm<sup>2</sup>) through connecting pipe for 20..30 sec.
4. Test the valve with air pressure P = 150 kgf/cm<sup>2</sup> by keeping under pressure for five minutes once and five times for 2 minutes opening the valve after each testing. Leakage of air through valve is not permissible.
5. After testing, lock the valve with clip pos.3. In case if there is misalignment of clip hole, turn the valve screw clock wise until obtaining alignment.
6. Mark Ш , Ч and stamp K as per AK-630, AK-630M TU I.

AK-630 Sb 114-36 SB

Amend.	Sheet	Doc.No.	Sign	Date	Discharge valve Assembly drawing	Type	Weight	Scale
						A	0.150	2:1
						Sheet	Sheets	1
Head of Q.C.D								
Approved by								

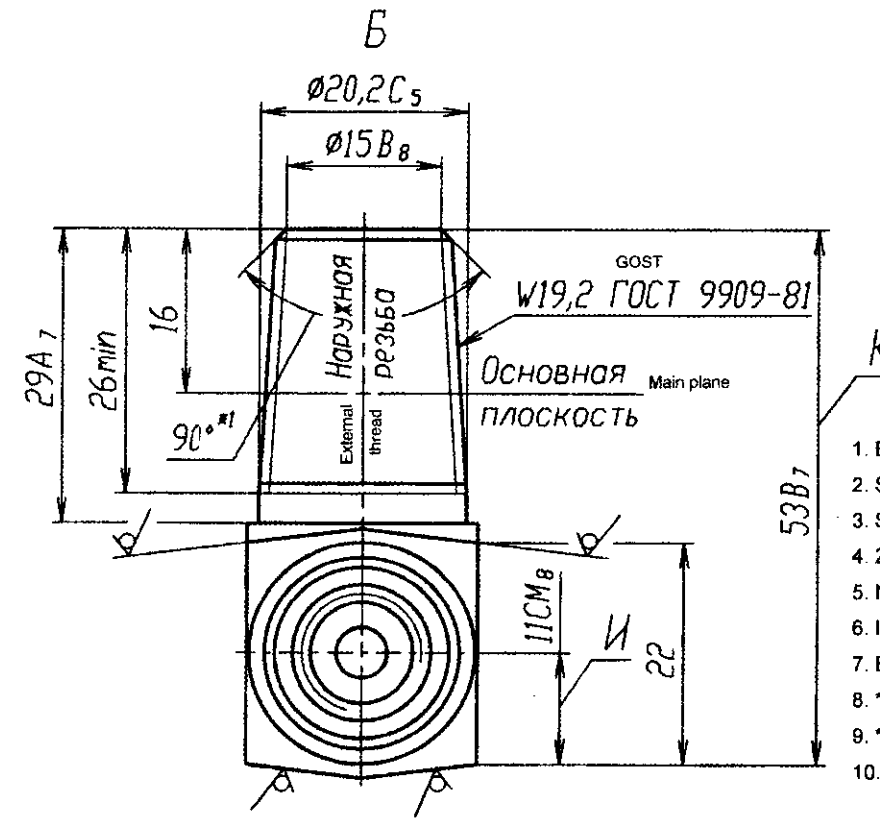
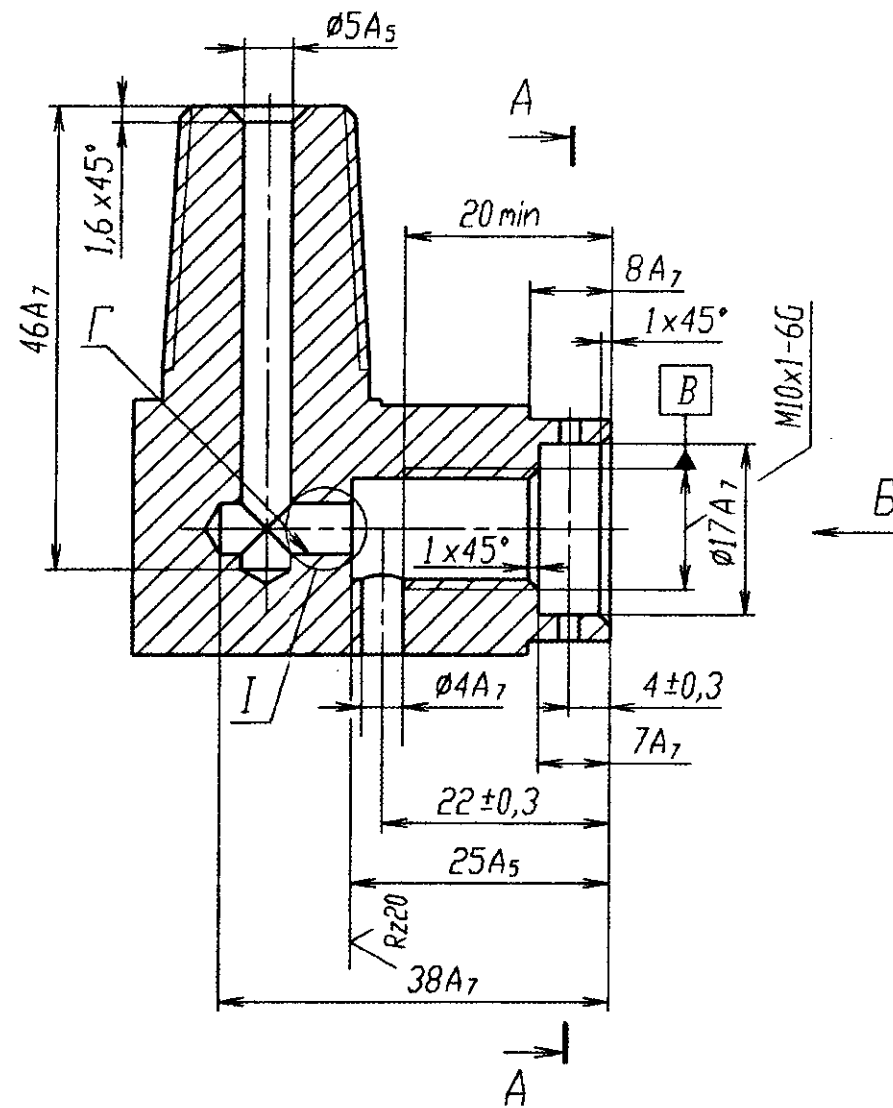
<b>AK-630 114-77</b>					
Approved OGMet	Approved T	Approved KTONI	Approved by shop	First use	
Orig. Inv. No.	Alternate Inv. No.	Dupl. Inv. No.	Reference No.		
Sign and Date	Sign and Date				

Rz80  
✓ (✓)

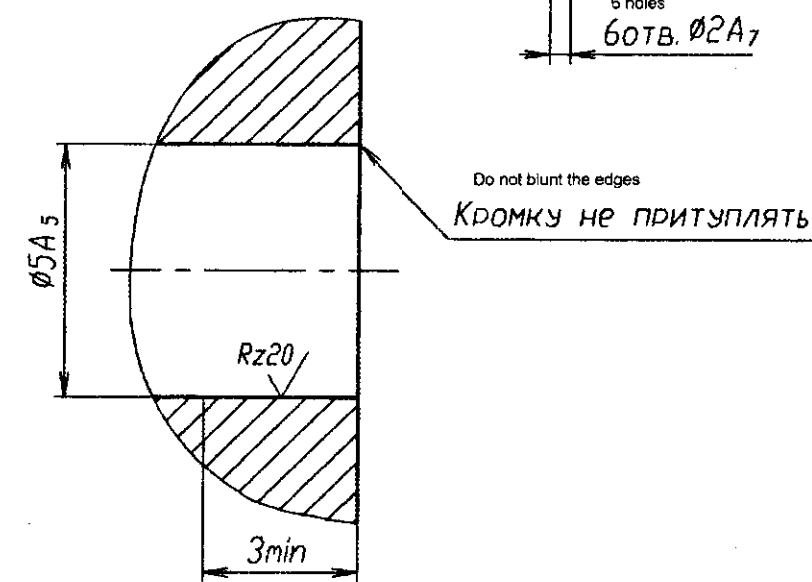
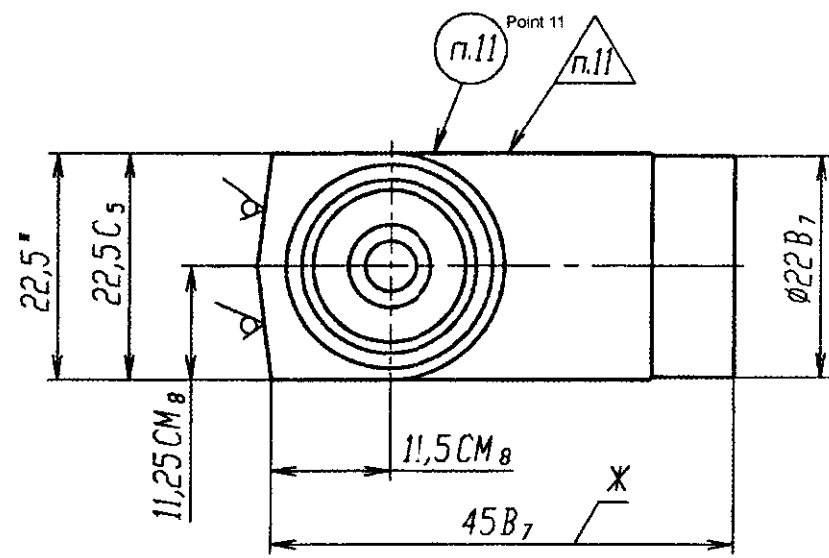
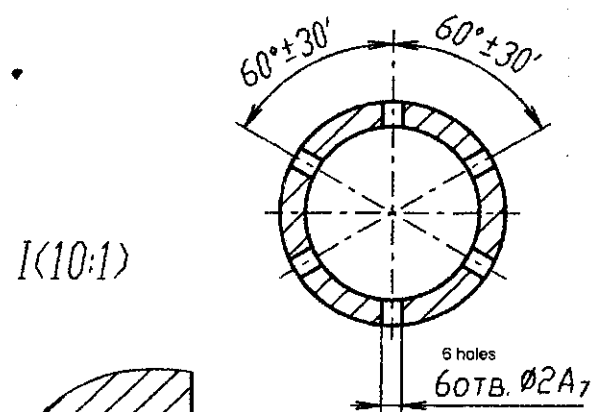
Technical drawing showing a clip with various dimensions and tolerances. The main drawing includes a curved section with a length of 40, a 38° angle, a 149° angle, a diameter of Ø4,5A<sub>7</sub>, a thickness of 12,75, and a 10° angle. It also shows a radius of R2 and a note '2 радиуса radii'. A detail view shows a 1x45° chamfer, a radius of R1,25, and dimensions of 9±0,5, 5±0,5, and 2,5A<sub>7</sub>. A length dimension of 50±1 is shown at the bottom with a note '1,2\*'. Surface texture Rz80 is indicated with a checkmark.

1.\* Reference dimension.  
 2. Tempering 240°...260°C.  
 3. Tolerance for external contour ± 0.3 mm.  
 4. Pre deform in tied position for 24 hours.  
 5. Coating Chem.Phos.Impregnation.  
 Lacquer BF-4 with Nigrosine, 2 coats made as per OST 3-4123-78, IV, OM2.  
 6. Mark Ш, Ч and stamp К, И on tag.



1. Blank for stamping, class of accuracy T5 as per GOST 7505-89.
2. Stamping inclinations (drafts) up to 7°.
3. Surface defects on non-machinable surfaces should not be deeper than 0.5 mm.
4. 229...269 HB.
5. Non-coaxiality of surface Г in relation to surface В is 0.07 mm (tolerance is dependent).
6. Internal angles R ~ 0.4 mm.
7. Blunt the sharp edges ~ 0.4 mm.
8. \* - Dimension is given for the dimensions Ж, И, К.
9. \*1 - Dimension is ensured by tool.
10. Coating: Chem. phos. followed by oil treatment.  
Varnish BF-4 black, preparation as per OST 3-4123-78.  
2 layers IV, OM2.
11. Mark Ш, Ч and stamp К, И.

A-A



1. Заготовка штамповка класс точности Т5 по ГОСТ 7505-89.
2. Штамповочный уклон до 7°.
3. Поверхностные дефекты на необрабатываемых поверхностях не должны быть глубиной более 0,5 мм.
4. 229...269 HB.
5. Несосность поверхности Г относительно поверхности В 0,07 мм (допуск зависимый).
6. Внутренние углы R ~ 0,4 мм.
7. Острые ребра притупить ~ 0,4 мм.
8. \* Размер задан для размеров Ж, И, К.
9. \*1 Размер обеспеч. инстр.
10. Покрытие Хим. Фос. прп.  
Лак БФ-4 черный, приготовление по OST 3-4123-78.  
2 слоя IV, OM2.
11. Маркировать Ш, Ч и клеймить К, И.

ИМЕН. Лист. Справ. Имен. А.С. Подп. и дата. Взаминен. Имен. А.С. Подп. и дата. Имен. Подп.

AK-630 Sb 114-74		AK-630 114-74		Type	Mass	Scale
Изм/Лист	И докум.	Подп.	Дата	Body	Лит.	Масса
Разраб.				Корпус	A	0,205
Пров.				Steel 30 Kh 13 GOST 5632-72	Лист	Листов 1
Т.контр.				Сталь 30X13	Sheet	Total Sheets
И.контр.				ГОСТ 5632-72		
УТВ.						



First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A3		✓	AK-630 Sb114-37 SB	Assembly drawing			
					<u>Components</u>			
	A4		✓	AK-630 114-75	Valve	1		
	A3		✓ 2	AK-630 114-76	Screw	1		
Sign and Date								
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date					<b>AK-630 Sb 114-37</b>			
	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							
					<b>Valve</b>			

AK-630 Sb114-37 SB

First use

Reference No.

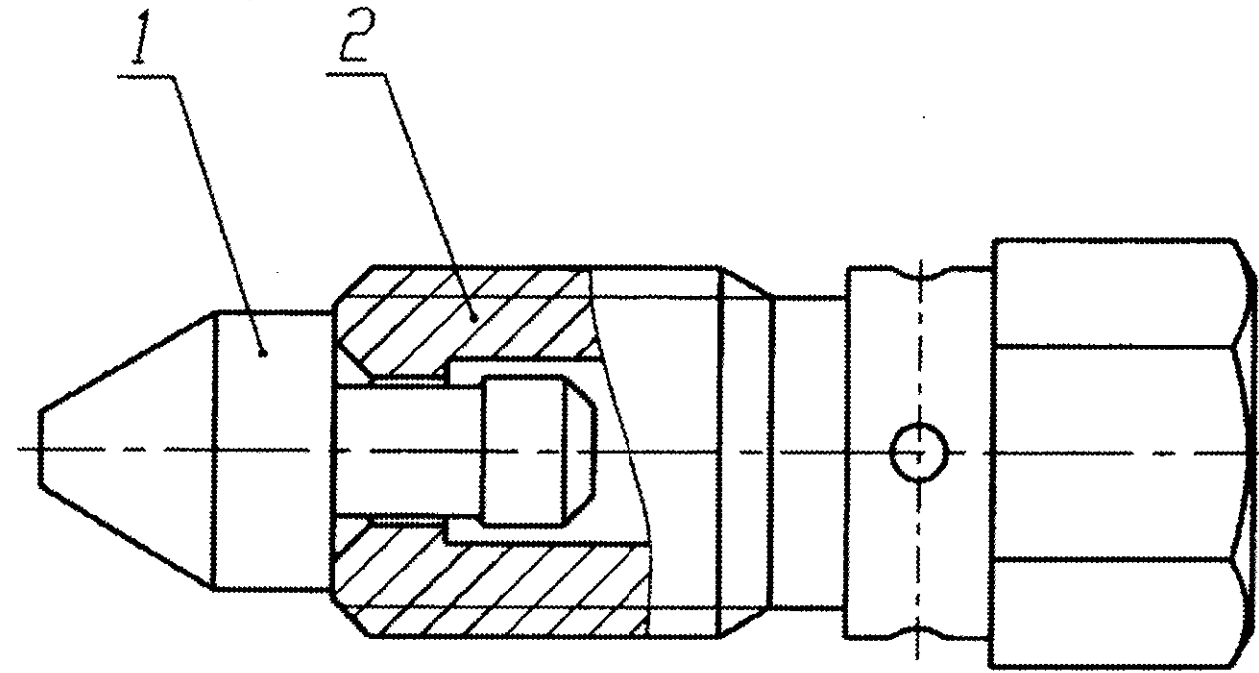
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Mark Ш , Ч and stamp K on tag.

					AK-630 Sb114-37 SB				
					Valve Assembly drawing	Type	Weight	Scale	
Amend.	Sheet	Doc.No.	Sign	Date		A	0.020	5:1	
Developed by									
Checked by									
Head of Q.C.D									
Approved by									
					Sheet		Sheets 1		

AK-630 114-75

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

1. 38.5...45.5 HRC<sub>E</sub>. Check hardness on 2..3% of the batch .  
2. Inner angles R~0.4 mm.  
3. Blunt sharp edges ~0.4 mm.  
4. Coating Cd9.Cr.  
5. Mark Ш, Ч and stamp K, И on tag.

AK-630 114-75				
Valve	Type	Weight	Scale	
	A	0.012	5:1	
	Sheet		Sheets 1	
	Steel 40 Kh GOST 4543-71			

Copied by

Format A4

First use

Reference No.

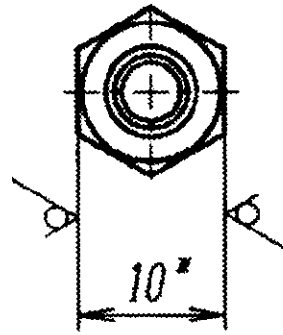
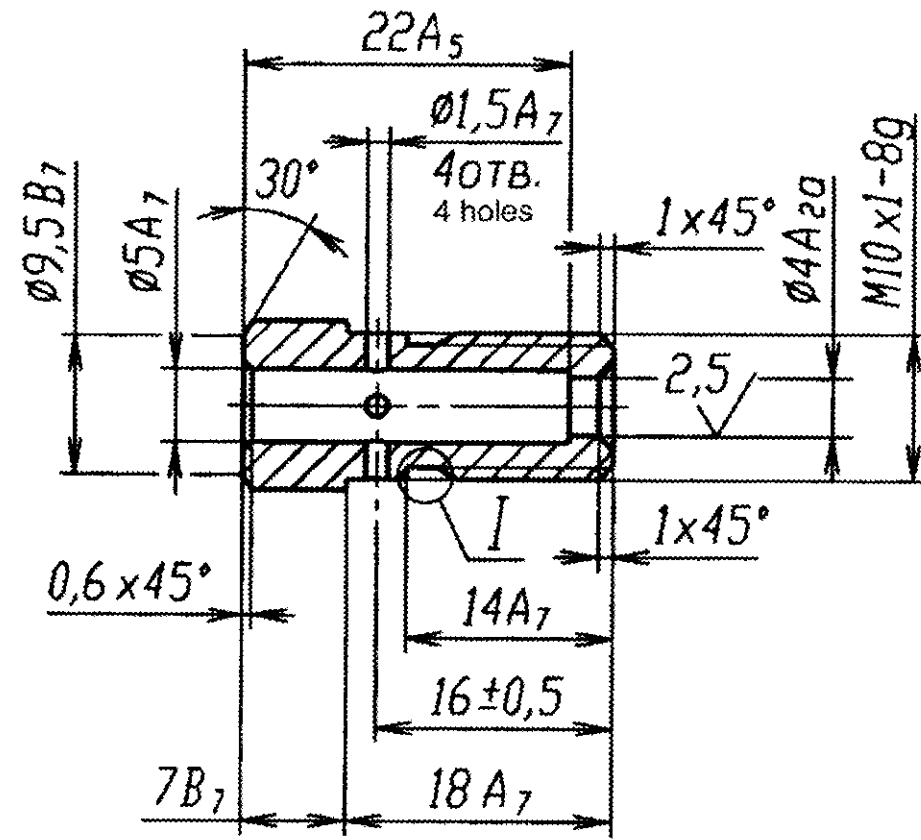
Sign and Date

Duplicate Inv. No

Alternate Inv. No

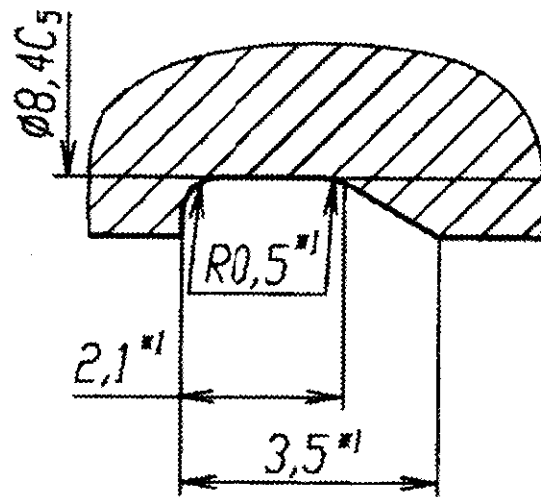
Sign and Date

Orig. inv. no.



1. 38.5...44.5 HRC<sub>E</sub> . Check on test-specimen .
- 2.\* Reference dimensions.
- 3.\*1 Dimensions ensured by tool.
4. Inner angles R~0.4 mm.
5. Blunt sharp edges ~0.6 mm.
6. Coating Cd9. Cr.
- It is permissible to avoid cadmium plating of holes.
7. Mark Ш, Ч and stamp K, И on tag.

I(5:1)



AK-630 114-76

					AK-630 114-76			
Amend.	Sheet	Doc.No.	Sign	Date	Screw	Type	Weight	Scale
							A	0.020
Developed by								
Checked by								
Head of Q.C.D								
Approved by								
					Hexagon	10 - h11GOST8560 - 78 40Kh - V - NGOST1051 - 73		
						Sheet	Sheets	1

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A3		✓	AK-630 Sb114-35 SB	Assembly drawing			
					<u>Components</u>			
	A2		✓	AK-630 114-73	Tee joint	1		
	A4		✓	AK-630 114-93	Pipe	1		
Sign and Date								
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date								
Orig. Inv. No.	<b>AK-630 Sb 114-35</b>							
	Amend.	Sheet	Doc. No.	Sign	Date			
	Developed by					Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D					<b>Tee joint with pipe</b>		
Approved by								

First use

Reference No.

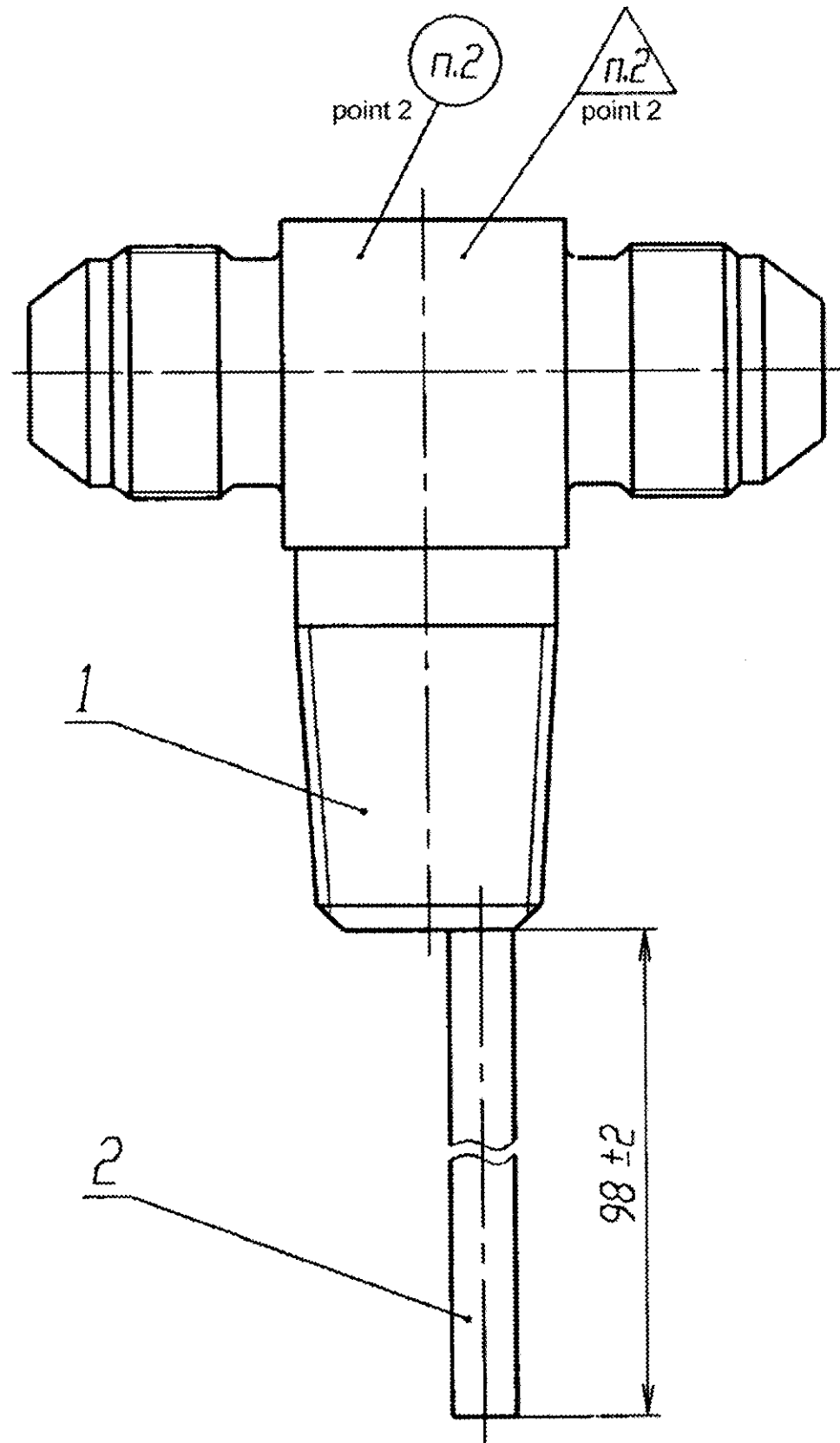
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

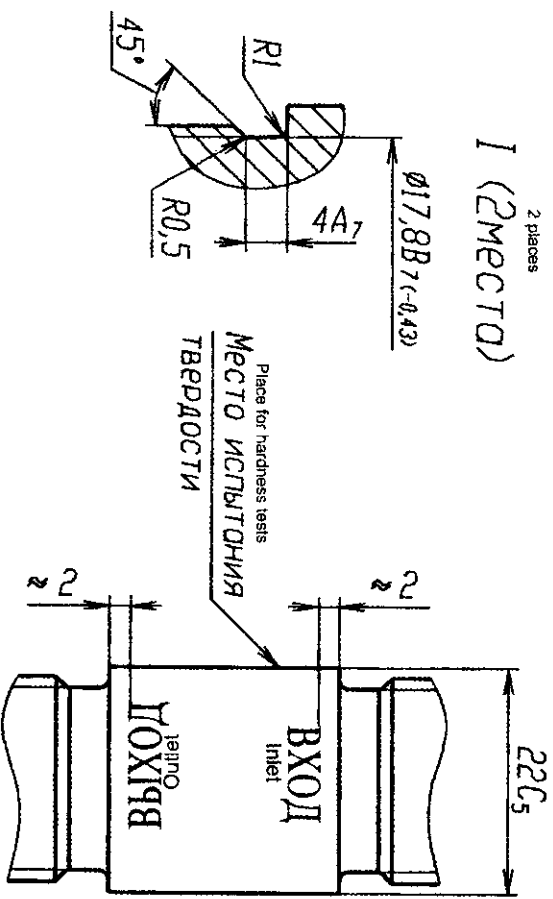
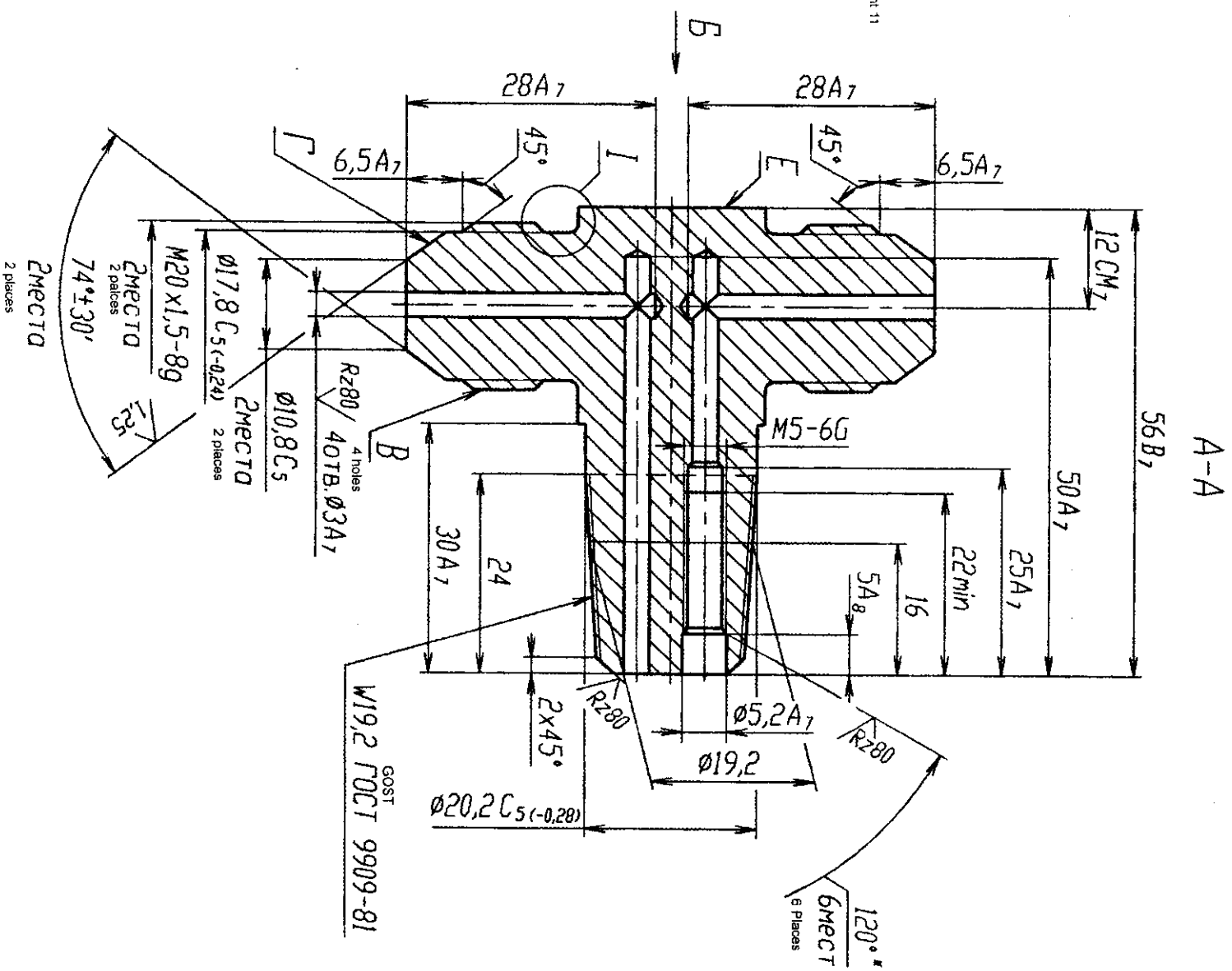
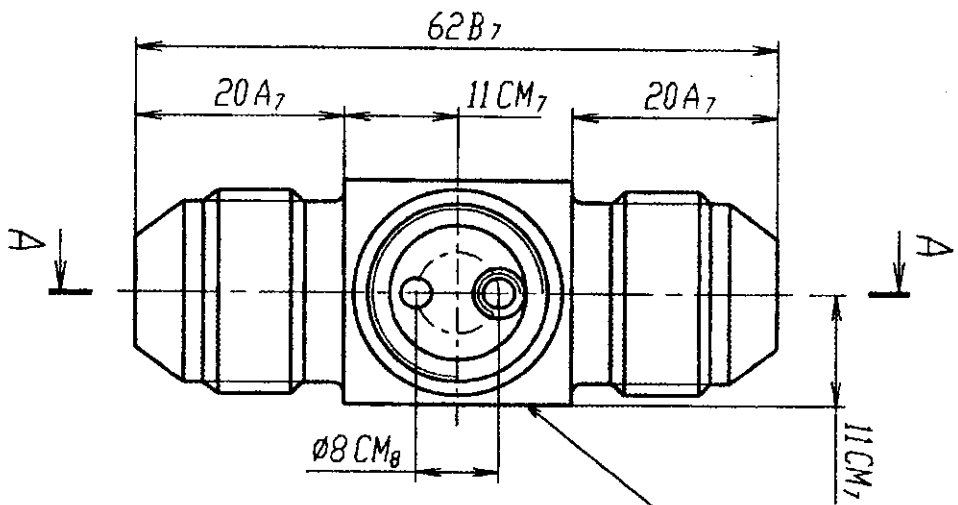


1. Secure tube pos.2 with compound without filler E5-1 OST V 84-167-90.
2. Mark Ш , Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 Sb 114-35 SB			
Amend.	Sheet	Doc.No.	Sign	Date	Tee-joint with tube Assembly drawing	Type	Weight	Scale
Developed by						A	0.245	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by								

Изм. N	Подп.	Изм. N	Подп.	Изм. N	Подп.

Справ. N	Перв. примен.



1 (2 места)  
2 places

1. 29...35,0 НРС.
  2. \* - Dimension is ensured by tool.
  3. Internal angle R ~ 0,4 mm.
  4. Blunt the sharp edges ~ 0,4 mm.
  5. Run out of surface Γ in relation to mean diameter of thread B is not more than 0,05 mm.
  6. Coating: Cad. 6. phos. followed by oil treatment.
  7. Non-cadmium plating of internal surfaces is permitted.
  8. Engrave the inscriptions with font PO-3 GOST 2930-62.
  9. Non-symmetry of the position of inscriptions is not more than 2 mm.
  10. Test with hydraulic pressure of 150 at. for 5 minutes.
- Leakage and sweating are not permitted.
- During test, the pressure is fed from the side of conical pipe union.
- Remaining holes are to be blanked.
10. Mark Ш, Ч on the tag.
  11. Stamp K as per АК-630, АК-630М ТУ I.
  12. Center hole is permitted on surface E.

1. 29...35,0 НРС.
2. \* Размер обеспеч. инстр.
3. Внутренние углы R ~ 0,4 мм.
4. Острые края пригнать ~ 0,4 мм.
5. Биение поверхности Γ относительно среднего диаметра резьбы В не более 0,05 мм.
6. Покрытые кад. фос. прм.
7. Надписи непрокалываемые внутренних поверхностей.
8. Несимметричность расположения надписей не более 2 мм.
9. Испытать гидравлическим давлением 150 ат в течение 5 мин.
10. Течь и потение не допускаются.
11. При испытании давление подается со стороны конического штуцера. Остальные отверстия заглушаются.
12. Моржировать Ш, Ч на бирке.
11. Клеить К по АК-630, АК-630М ТУ I.
12. На поверхности E допускается центровое отверстие.

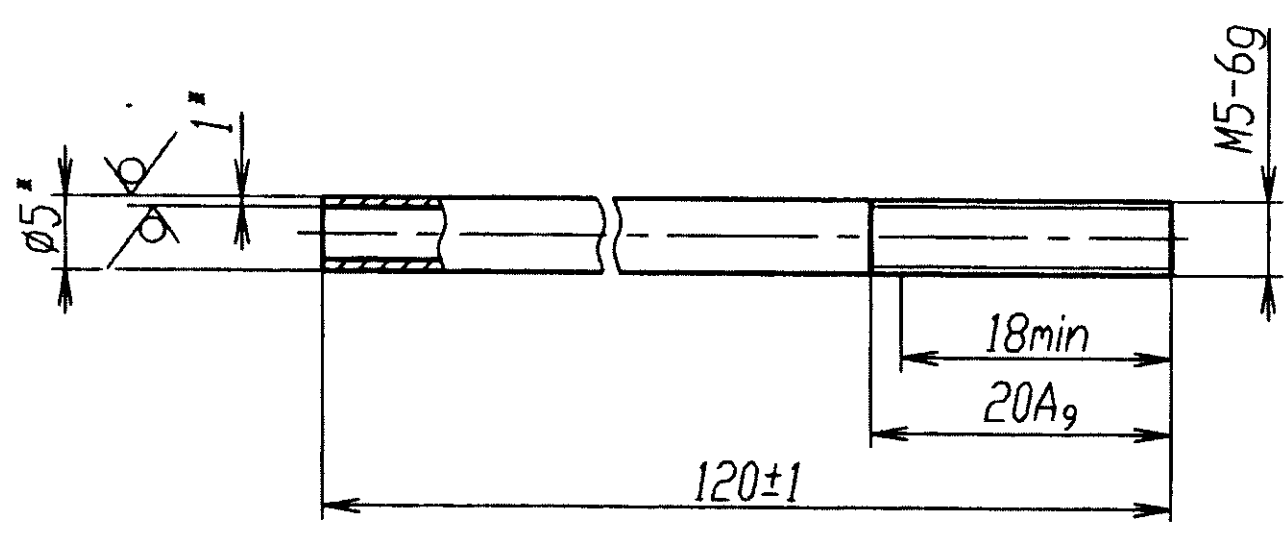
АК-630 114-73				АК-630 114-73			
Тренинг				Тренинг			
Изм./лист	№ докум.	Подп.	Дата	Изм./лист	№ докум.	Подп.	Дата
Steel 20 Kh 13 GOST 5632-72				Steel 20 Kh 13 GOST 5632-72			
ГОСТ 5632-72				ГОСТ 5632-72			
Лист 1				Лист 1			
Steel				Steel			
Толщ. Sheets				Толщ. Sheets			
0,215				0,215			
2:1				2:1			

AK-630 114-73

Формат А2

AK-630 114-93

Approved OGMet	Sign and Date	Alternate Inv. No.	Approved T. No.	Dupl. Inv. No.	Sign and Date	Approved KTONI	Reference No.	Approved by shop	First use																																											
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td style="width:5%;">Amend.</td> <td style="width:5%;">Sheet</td> <td style="width:5%;">Doc. No.</td> <td style="width:5%;">Sign</td> <td style="width:5%;">Date</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									<p><b>AK-630 114-93</b></p> <table border="1" style="width:100%; border-collapse: collapse;"> <tr> <td rowspan="2" style="width:50%; text-align:center; vertical-align:middle;">Pipe</td> <td style="width:10%;">Type</td> <td style="width:10%;">Weight</td> <td style="width:10%;">Scale</td> </tr> <tr> <td style="text-align:center;">A</td> <td style="text-align:center;">0.015</td> <td style="text-align:center;">2:1</td> </tr> <tr> <td colspan="2">Sheet</td> <td colspan="2">Sheets 1</td> </tr> </table>		Pipe	Type	Weight	Scale	A	0.015	2:1	Sheet		Sheets 1	
Amend.	Sheet	Doc. No.	Sign	Date																																																
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Checked by																																																				
Head of Q.C.D																																																				
Design bureau chief																																																				
Head of Q.C.D																																																				
Approved by																																																				
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	A	0.015	2:1																																																	
Sheet		Sheets 1																																																		



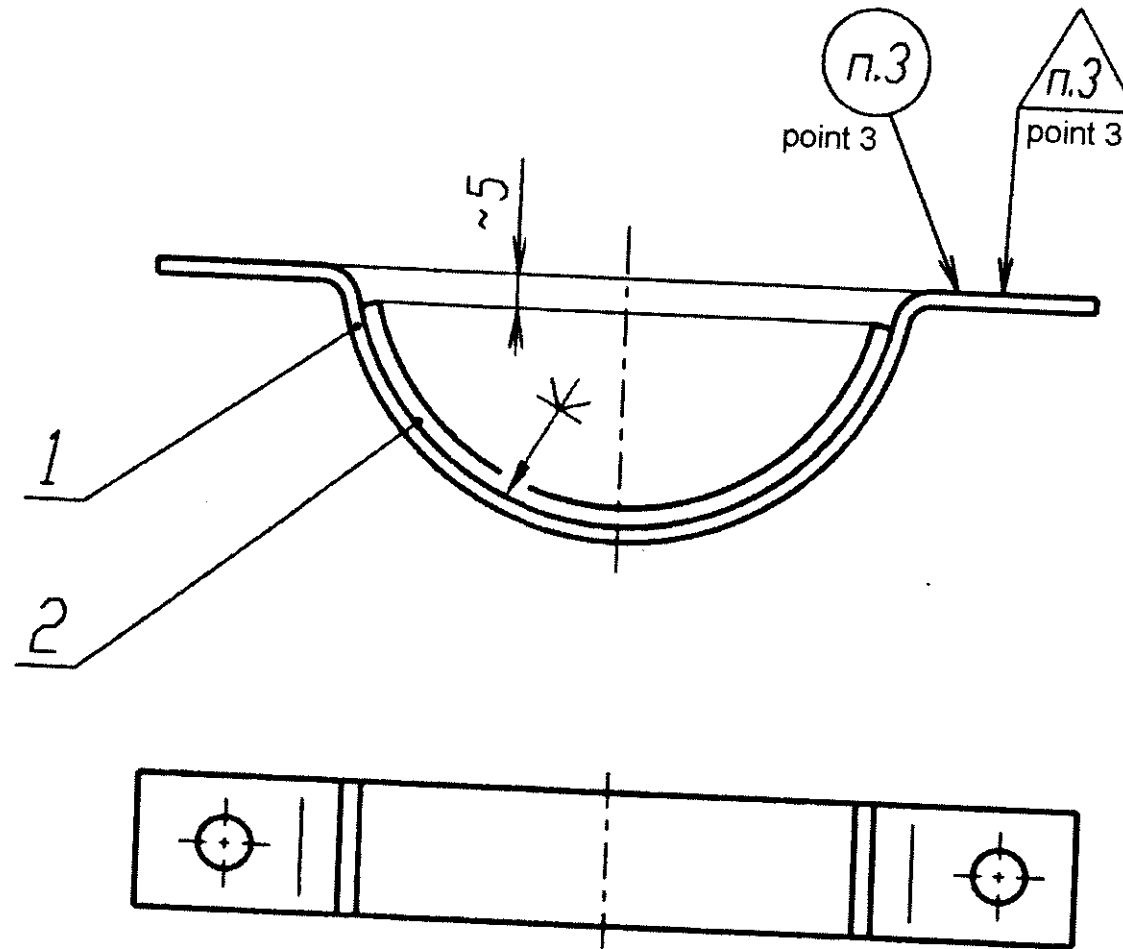
1. Substitute material – Pipe  $\frac{5x1GOST 8734 - 75}{V20GOST 8733 - 74}$
2. \* .Reference dimensions.
3. Blunt sharp edges ~0.4 mm.
4. Coating Chem.Phos.Oil.  
Lacquer BF-4 black, made as per OST 3-4123-78, single coat, IV, OM2.
5. Mark Ш, Ч and stamp K on tag.

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Format A4







1. Paste gasket pos.2 with adhesive 88-NP TU 38 105540-85.
2. Application of adhesive 88-SA TU 38.105.1760-89 is permissible.
3. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

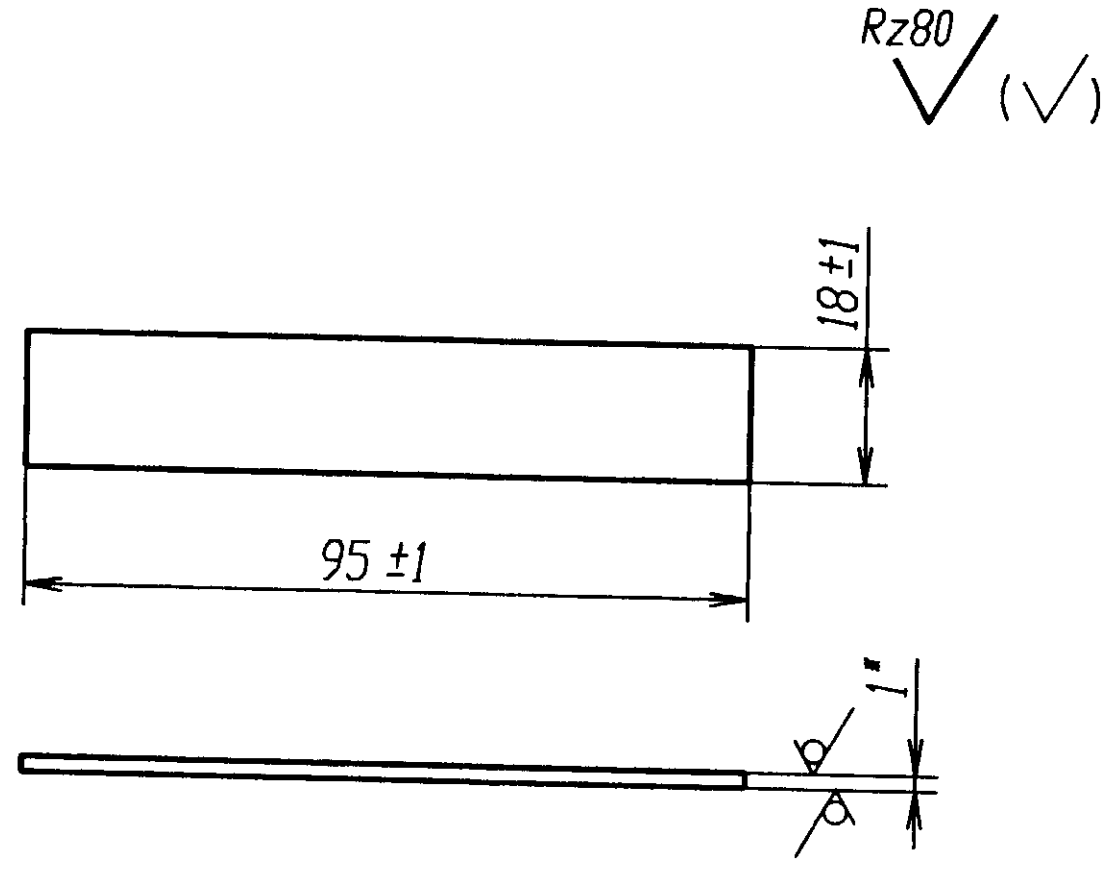
Approved OGMet	Approved T.	Approved KTONI	Approved by shop	Reference No.	First use																																																																		
Orig. Inv. No.	Alternate Inv. No.	Dupl. Inv. No.	Sign and Date	Sign and Date																																																																			
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Amend.	Sheet	Doc. No.	Sign	Date																																																																			
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AK-630 114-86

First use					AK-630 114-86																																																																																																											
Approved by shop																																																																																																																
Reference No.																																																																																																																
Approved KTONI					<p>1.* Reference dimensions.                  2. Blank length 158 B<sub>7</sub> mm.                  3. Coating Chem.Phos.Impregnation                  Lacquer BF-4 colorless, made as per OST 3-4123-78, single coat, IV, OM2.                  4. Mark Ш, Ч on tag.                  5. Stamp K.</p>																																																																																																											
Sign and Date																																																																																																																
Approved T.C.					<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td colspan="5" style="text-align: center;">AK-630 114-86</td> </tr> <tr> <td style="width: 10%;"></td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> <td style="width: 10%;"></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> <td colspan="2" style="text-align: center;">Type</td> <td style="text-align: center;">Weight</td> <td style="text-align: center;">Scale</td> </tr> <tr> <td colspan="5" style="text-align: center;">Developed by</td> <td colspan="2" style="text-align: center;">A</td> <td style="text-align: center;">0.037</td> <td style="text-align: center;">1:1</td> </tr> <tr> <td colspan="5" style="text-align: center;">Checked by</td> <td colspan="2" style="text-align: center;">Sheet</td> <td colspan="2" style="text-align: center;">Sheets 1</td> </tr> <tr> <td colspan="5" style="text-align: center;">Head of Q.C.D</td> <td colspan="4" rowspan="3" style="text-align: center;">                     Sheet <u>BT - O - PN - 2GOST19904 - 90</u>                      12Cr18Ni10Ti - M3aGOST 5582 - 75                 </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 style="text-align: center;">Approved OGMet</td> <td colspan="4"></td> <td colspan="4" style="text-align: center;">                     Copied by _____ Format A4                 </td> </tr> <tr> <td style="text-align: center;">Orig. Inv. No.</td> <td colspan="4"></td> <td colspan="4"></td> </tr> <tr> <td style="text-align: center;">Sign and Date</td> <td colspan="4"></td> <td colspan="4"></td> </tr> <tr> <td style="text-align: center;">Alternate Inv. No.</td> <td colspan="4"></td> <td colspan="4"></td> </tr> <tr> <td style="text-align: center;">Dupl. Inv. No.</td> <td colspan="4"></td> <td colspan="4"></td> </tr> </table>			AK-630 114-86														Amend.	Sheet	Doc. No.	Sign	Date	Type		Weight	Scale	Developed by					A		0.037	1:1	Checked by					Sheet		Sheets 1		Head of Q.C.D					Sheet <u>BT - O - PN - 2GOST19904 - 90</u> 12Cr18Ni10Ti - M3aGOST 5582 - 75				Design bureau chief					Head of Q.C.D					Approved OGMet					Copied by _____ Format A4				Orig. Inv. No.									Sign and Date									Alternate Inv. No.									Dupl. Inv. No.								
AK-630 114-86																																																																																																																
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Checked by					Sheet		Sheets 1																																																																																																									
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Design bureau chief																																																																																																																
Head of Q.C.D																																																																																																																
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Alternate Inv. No.																																																																																																																
Dupl. Inv. No.																																																																																																																

AK-630 114-88

Approved OGMet	Approved T. 3	Approved KTONI	Approved by shop	First use
Orig. Inv. No.	Alternate Inv. No.	Sign and Date	Reference No.	
Sign and Date	Dupl. Inv. No.	Sign and Date		



- \* Reference dimensions.
- Mark Ш, Ч and stamp K on tag.

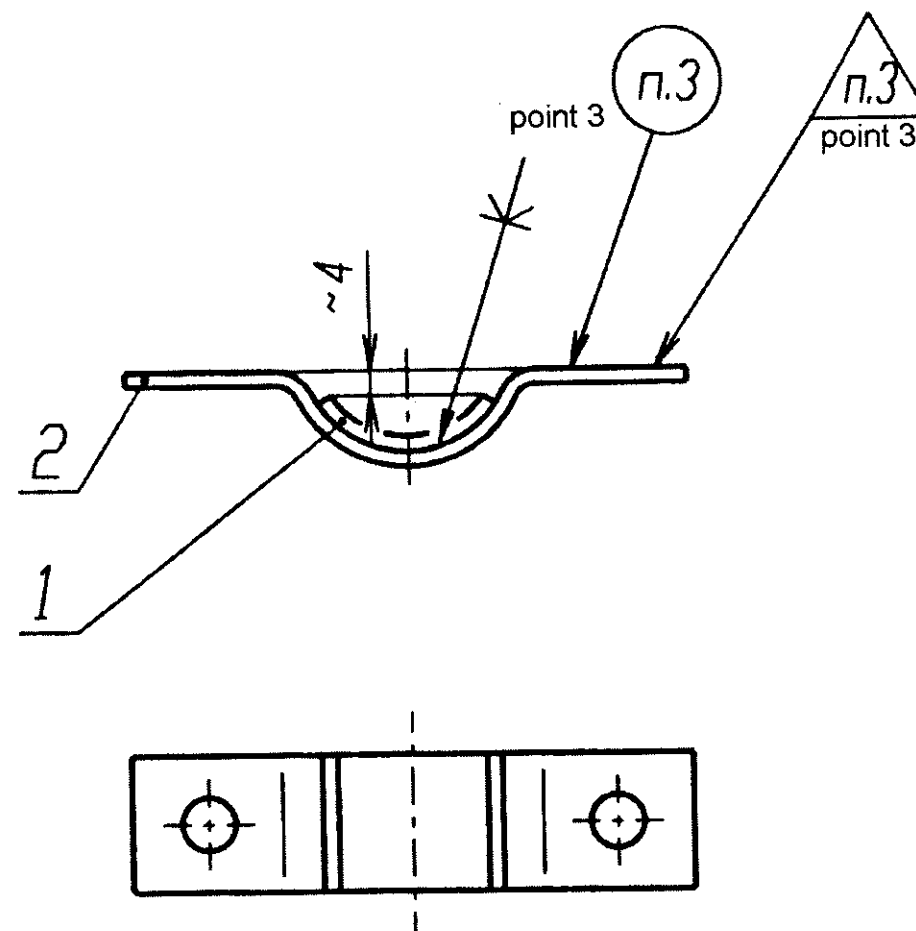
AK-630 114-88				
Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				
<b>Gasket</b>		Type	Weight	Scale
		A	0.010	1:1
		Sheet	Sheets 1	
Plate 1N-I MBS-M <sub>1</sub> -1		GOST 7338-90		

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Format A4

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A4		✓	AK-630 Sb114-31 SB	Assembly drawing			
					<u>Components</u>			
	A4		✓	AK-630 114-89	Gasket	1		
	A4		✓	AK-630 114-90	Clamp	1		
Sign and Date								
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date								
Orig. Inv. No.	<b>AK-630 Sb 114-31</b>							
	Amend.	Sheet	Doc. No.	Sign	Date			
	Developed by					Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D					<b>Clamp</b>		
	Approved by							

AK-630 Sb114-31 SB



1. Paste gasket pos.1 with adhesive 88-NP TU 38 105540-85.
2. Application of adhesive 88-SA TU 38.105.1760-89 is permissible.
3. Mark Ш, Ч and stamp К as per AK-630, AK-630M TU I.

Approved OGMet: \_\_\_\_\_  
 Orig. Inv. No.: \_\_\_\_\_  
 Sign and Date: \_\_\_\_\_  
 Alternate Inv. No.: \_\_\_\_\_  
 Dupl. Inv. No.: \_\_\_\_\_  
 Sign and Date: \_\_\_\_\_  
 Approved TO: \_\_\_\_\_  
 Dupl. Inv. No.: \_\_\_\_\_  
 Sign and Date: \_\_\_\_\_  
 Approved KTONI: \_\_\_\_\_  
 Sign and Date: \_\_\_\_\_  
 Reference No.: \_\_\_\_\_  
 Approved by shop: \_\_\_\_\_  
 First use: \_\_\_\_\_


AK-630 Sb114-31 SB

**Clamp  
Assembly drawing**

Type	Weight	Scale
A	0.060	1:1
Sheet		Sheets 1

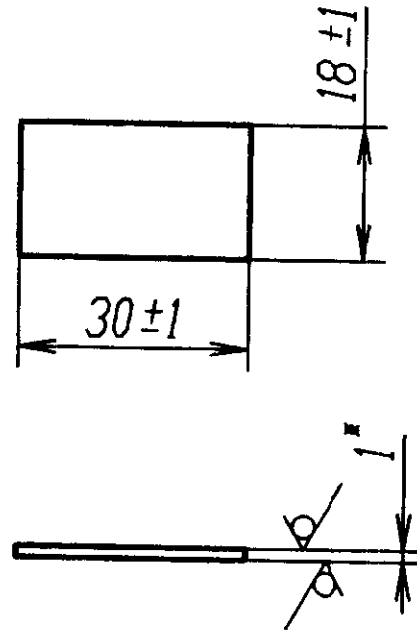
Copied by

Format A4

AK-630 114-89

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

Rz80



- 1.\* Reference dimension.
- 2. Mark Ш, Ч and stamp K on tag.

Amend.	Sheet	Doc. No.	Sign	Date

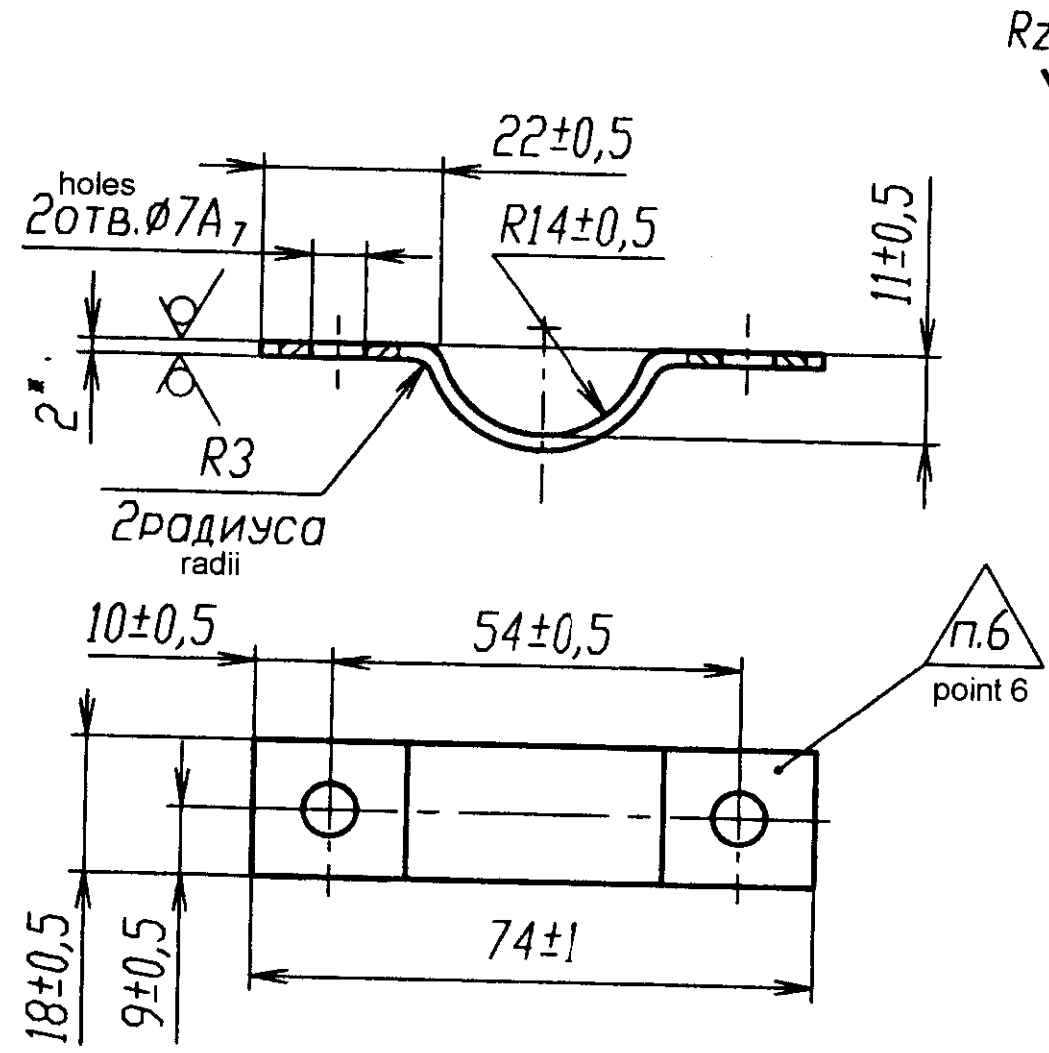
AK-630 114-89			
Gasket	Type	Weight	Scale
	A	0.003	1:1
Sheets 1			
Plate 1N-I MBS-M <sub>1</sub> -1 GOST 7338-90			

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Format A4

AK-630 114-90

Approved OGMet	Approved TC	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		



- 1.\* Reference dimensions.
2. Blank length 85 mm.
3. Blunt sharp edges  $\sim 0.6$  mm.
4. Coating Chem.Phos.Impregnation  
Lacquer BF-4 colorless, made as per OST 3-4123-78, single coat, IV, OM2.
5. Mark Ш, Ч on tag.
6. Stamp K.

Amend.	Sheet	Doc. No.	Sign	Date

<b>AK-630 114-90</b>			
<b>Clamp</b>	Type	Weight	Scale
	A	0.023	1:1
	Sheet	Sheets 1	
Sheet $B - PN - 02 GOST 19904 - 90$			
Sheet $K390V4 - III - 25 GOST 16523 - 97$			



First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A3			AK-630 Sb 114-7 SB	Assembly drawing			
					<u>Components</u>			
	A3		1	AK-630 114-28	Coupling nut	2		
	A4		2	AK-630 114-29	Nipple	2		
	A4		3	AK-630 114-31	Pipe	1		
Sign and Date								
Dupl. inv. No.								
Alternate Inv. No								
Sign and Date					<b>AK-630 Sb 114-7</b>			
	Amend.	Sheet	Doc. No.	Sign	Date			
	Developed by					Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D					<b>Pipeline</b>		
	Approved by							

First use

Reference No.

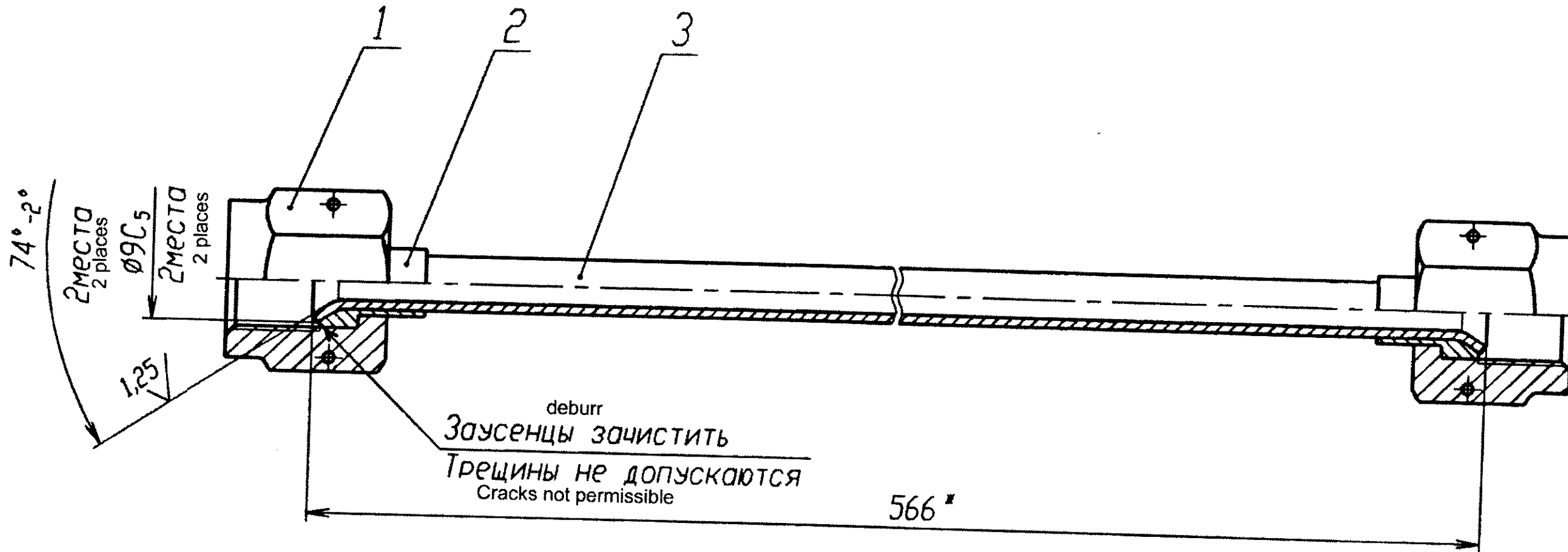
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. \* Reference dimension.
2. Test for strength with air pressure 80 atm. Carry out testing by loading three times and keeping for 10 minutes.  
Disturbance of strength and tightness of joints is not permissible.
3. Mark Ш, Ч and stamp K on tag.

					AK-630 Sb 114-7 SB			
Amend.	Sheet	Doc.No.	Sign	Date	<b>Pipeline Assembly drawing</b>	Type	Weight	Scale
Developed by						A	0.130	2:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by								

First use

Reference No.

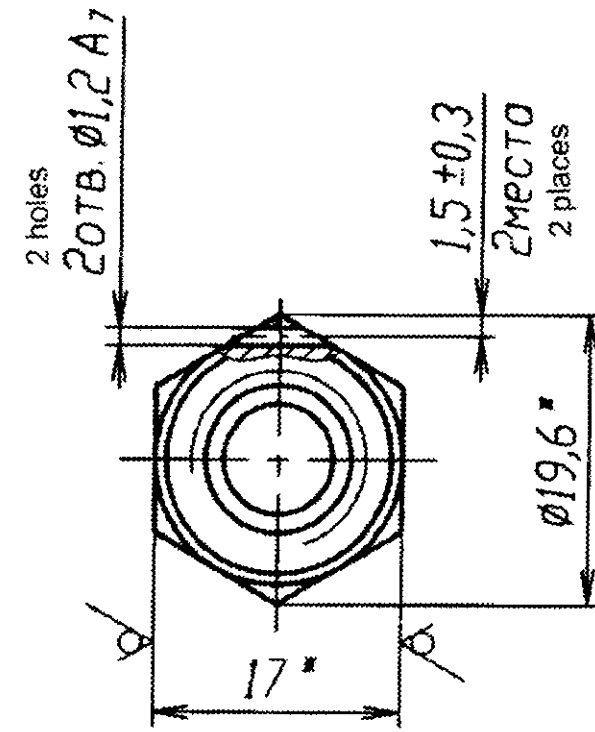
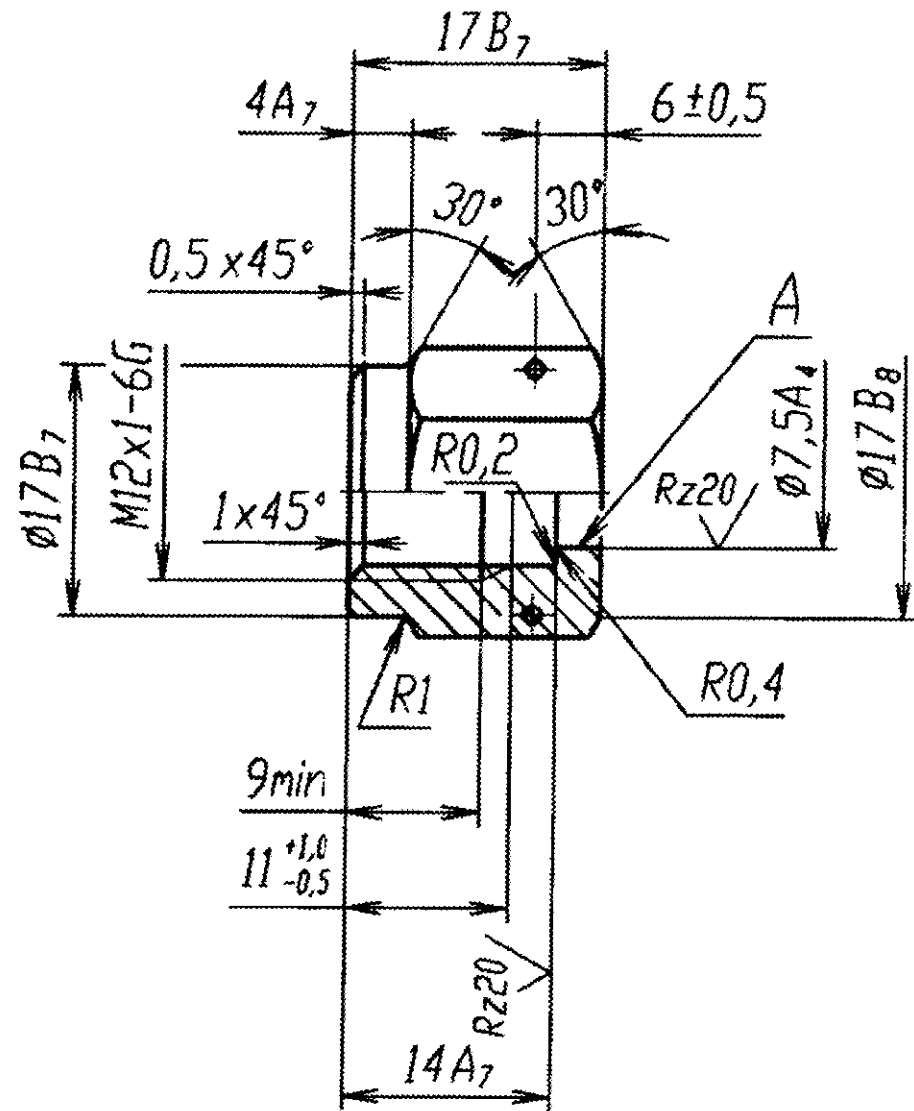
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



$Rz40$  ✓ (✓)

1. Substitute material- hexagon  $\frac{17 - 5GOST8560 - 67}{40GOST1051 - 73}$
2. 31..40.5 HRC<sub>E</sub>. Check 3..5% , but not less than 3 nos. from batch.
- 3.\* Reference dimensions.
4. Blunt sharp edges ~0.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.01 mm.
6. Mark Ш, Ч and stamp K, И on tag.

					AK-630 114-28			
Amend.	Sheet	Doc.No.	Sign	Date	Coupling nut	Type	Weight	Scale
Developed by						A	0.020	2:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D						Hexagon $\frac{17 - 5GOST8560 - 78}{40Kh - T - VGOST1051 - 73}$		
Approved by								

AK-630 114-29

First use

Approved by shop

Reference No.

Approved KTONI

Sign and Date

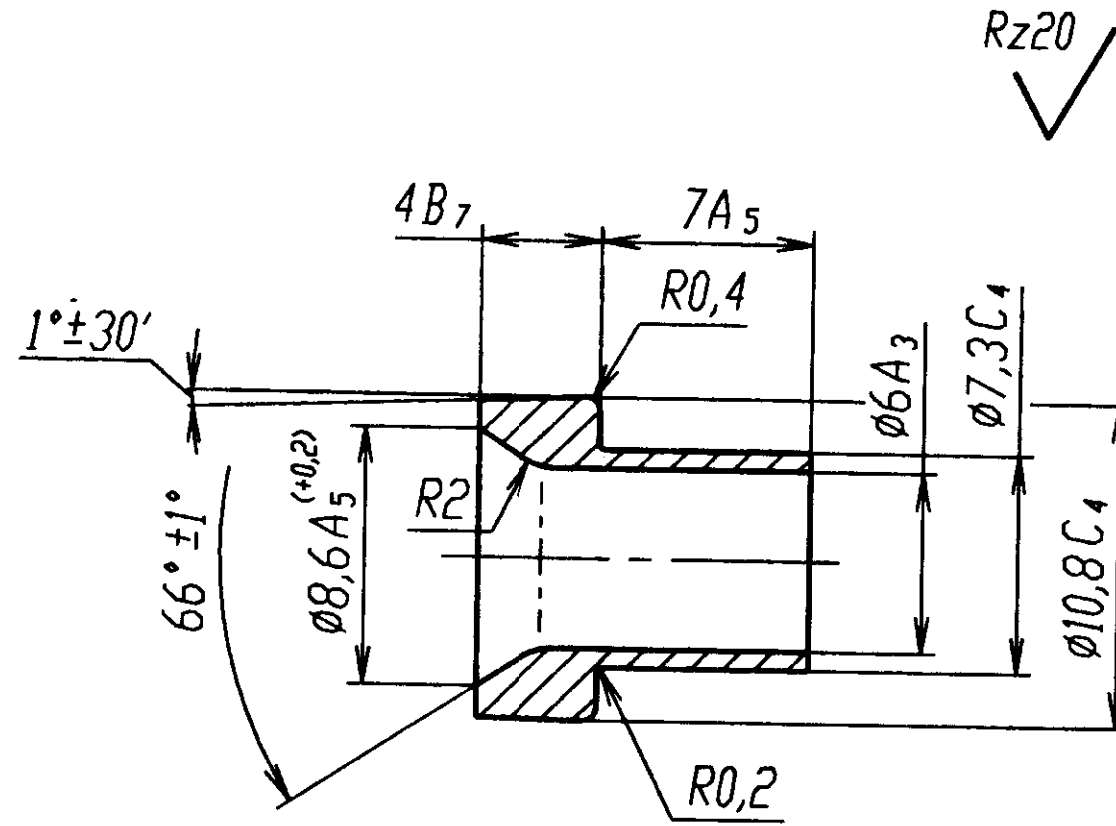
Approved TC

Alternate Inv. No.

Dupl. Inv. No.

Sign and Date

Approved OGMet  
Orig. Inv. No.



1. 38.5...44.5 HRC<sub>E</sub>. Check on specimen.
2. Blunt sharp edges ~0.2 mm.
3. Coating Cd12.phos.
4. Mark Ш, Ч and stamp K, И on tag.

AK-630 114-29

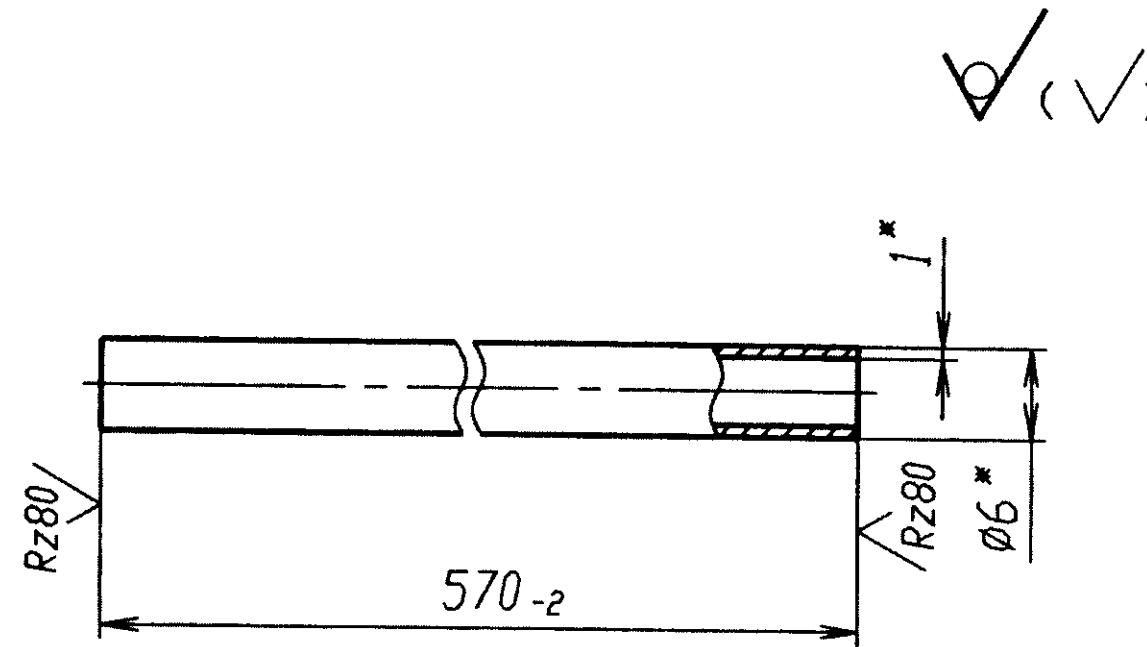
Amend.	Sheet	Doc. No.	Sign	Date

<b>Nipple</b>	Type	Weight	Scale
	A	0.005	4:1
	Sheet	Sheets 1	
Steel 50 GOST 1050-88			

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Format A4

AK-630 114-31



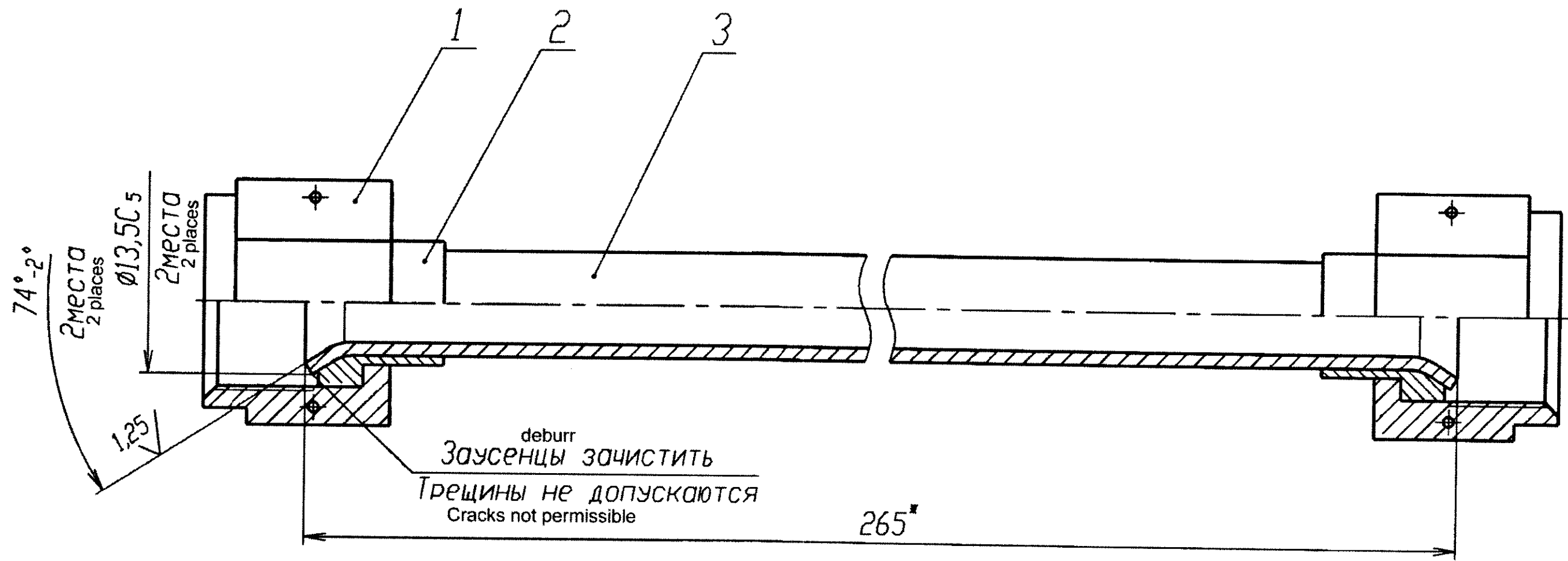
- 1.\* Reference dimensions.
2. Blunt sharp edges ~0.4 mm.
3. Coating : Chem.Pass.
4. Mark Ш, Ч and stamp K on tag.

Approved OGMet	Approved TC	Approved KTONI	Approved by shop	Reference No.	First use			
Orig. Inv. No.	Alternate Inv. No.	Dupl. Inv. No.	Sign and Date					
Amend.	Sheet	Doc. No.	Sign	Date	<b>AK-630 114-31</b>			
Developed by					<b>Pipe</b>	Type	Weight	Scale
Checked by						A	0.150	2:1
Head of Q.C.D					Sheet	Sheets 1		
Design bureau chief					Pipe M2 M6x1 GOST 617-90			
Head of Q.C.D								
Approved by								

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Format A4





1. \* Reference dimension.
2. Test for strength with air pressure 80 atm. Carry out testing by loading three times and keeping for 10 minutes.  
Disturbance of strength and tightness of joints is not permissible.
3. Mark Ш, Ч and stamp K on tag.

					AK-630 Sb 114-8 SB			
Amend.	Sheet	Doc.No.	Sign	Date	<b>Pipeline Assembly drawing</b>	Type	Weight	Scale
Developed by						A	0.180	2:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by								

First use

Reference No.

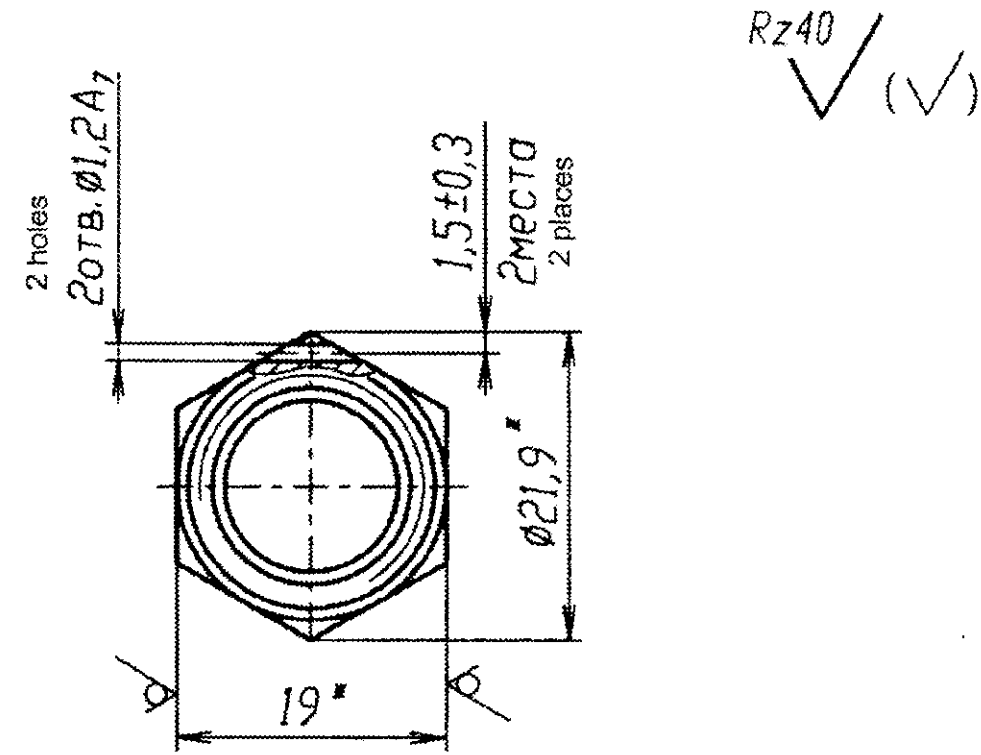
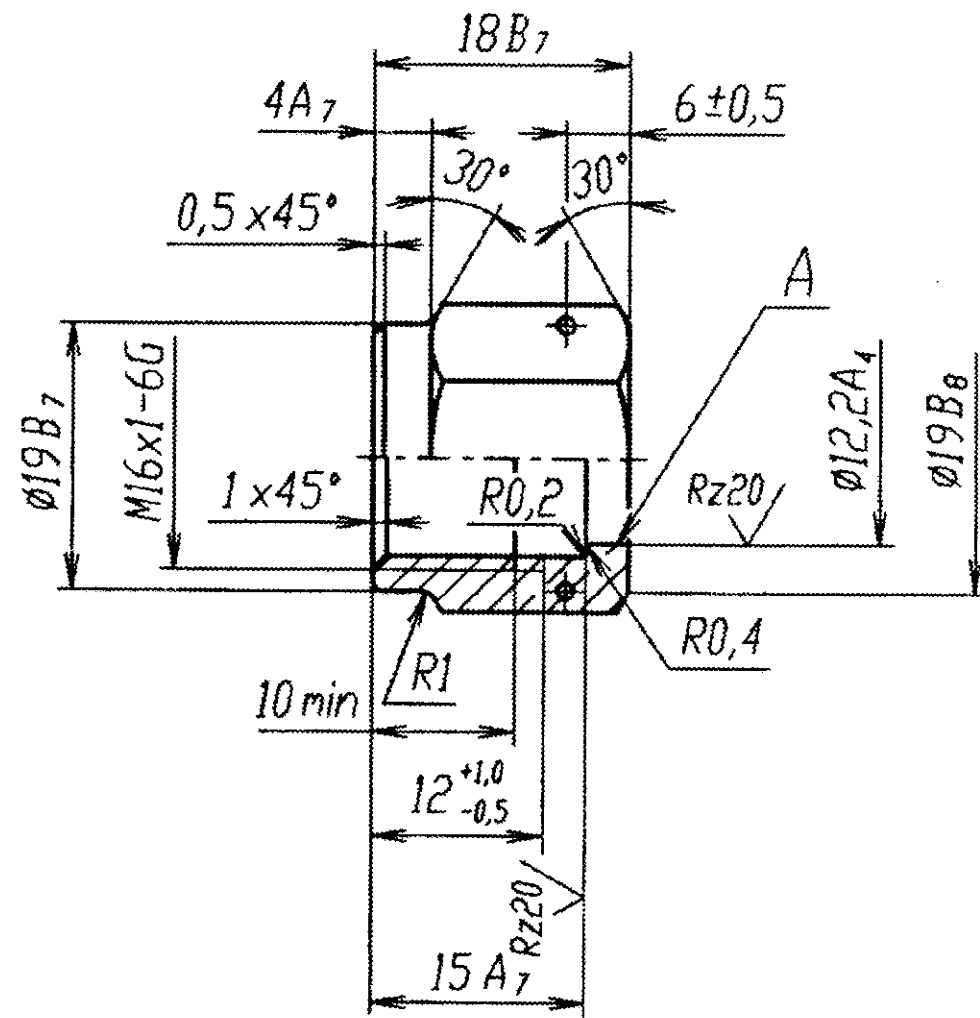
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



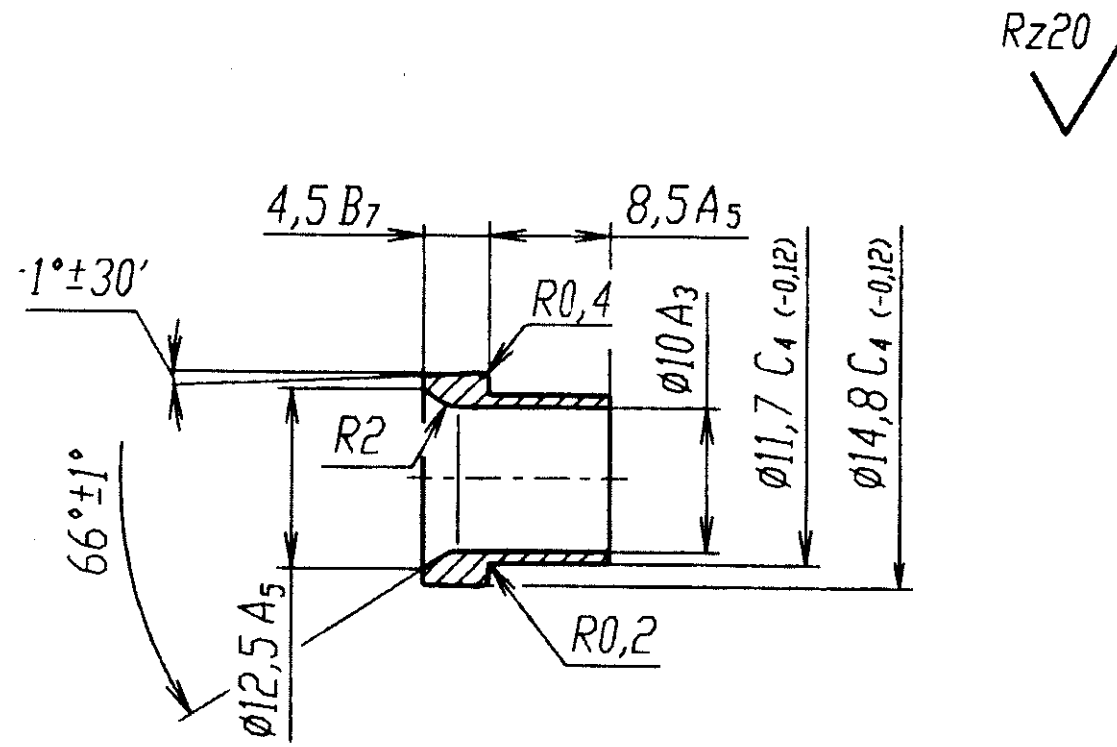
1. Substitute material- hexagon  $\frac{19 - 5GOST8560 - 78}{40GOST1051 - 73}$
2. 31..40.5 HRC<sub>E</sub>. Check 3..5% , but not less than 3 nos. from batch.
- 3.\* Reference dimensions.
4. Blunt sharp edges ~0.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.01 mm.
6. Mark Ш, Ч and stamp K, И on tag.

Designation	Coating
AK-630 114-32	Cd6.phos.
AK-630 -01	Without coating

					AK-630 114-32				
Amend.	Sheet	Doc.No.	Sign	Date	Coupling nut		Type	Weight	Scale
							A	0.025	2:1
Developed by									
Checked by									
Head of Q.C.D									
Approved by									
						Hexagon $\frac{19 - 5GOST8560 - 78}{40Kh - T - VGOST1051 - 73}$	Sheet	Sheets	1



AK-630 114-33



Rz20 ✓

Designation	Coating
AK-630 114-33	Kd12. pos
AK-630 -01	without coating

- 1.38.5...44.5 HRC<sub>E</sub>. Check on specimen.
2. Blunt sharp edges ~0.2 mm.
3. Mark Ш, Ч and stamp K, И on tag.

Approved OGMet	Sign and Date	Approved TC	Alternate Inv. No.	Approved KTONI	Sign and Date	Approved by shop	Reference No.	First use
Orig. Inv. No.	Amend.	Sheet	Doc. No.	Sign	Date			
Developed by					<p style="text-align: center;"><b>AK-630 114-33</b></p> <p style="text-align: center;"><b>Nipple</b></p> <p style="text-align: center;">Steel 50 GOST 1050-88</p>	Type	Weight	Scale
Checked by						A	0.008	2:1
Head of Q.C.D						Sheet	Sheets 1	
Design bureau chief								
Head of Q.C.D								
Approved by								

Copied by

Format A4

AK-630 114-34

										First use	
										Approved by shop Reference No.	
										Approved KTONI Sign and Date	
										Approved 1 Dupl. Inv. No.	
										Approved OGMet Orig. Inv. No.	
										Sign and Date	
										Alternate Inv. No.	
										b	

$280_{-2}$   
 $RZ80$   $RZ80$   $1^*$   $\phi 10^*$

1.\* Reference dimensions.  
 2. Blunt sharp edges ~0.4 mm.  
 3. Coating Chem.Pass.  
 4. Mark Ш, Ч and stamp K on tag.

AK-630 114-34									
Pipe	Type	Weight	Scale						
	A	0.180	1:1						
		Sheet	Sheets 1						
Pipe M2 M10x1 GOST 617-90									

Copied by

Format A4

First use		Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.						<u>Documents</u>			
	A3		✓	AK-630 Sb114-33 SB	Assembly drawing				
						<u>Components</u>			
	A3		✓	AK-630 114-32-01	Coupling nut	1			
	A4		✓	AK-630 114-72	Nipple	1			
	A3		✓	AK-630 114-84	End cap	1			
Sign and Date									
Dur. Inv. No.									
Alternate Inv. No.									
Sign and Date						<b>AK-630 Sb 114-33</b>			
	Amend.	Sheet	Doc. No.	Sign	Date				
Orig. Inv. No.	Developed by					<b>Elbow</b>	Type	Sheet	Sheets
	Checked by						A		1
	Head of Q.C.D								
	Approved by								

First use

Reference No.

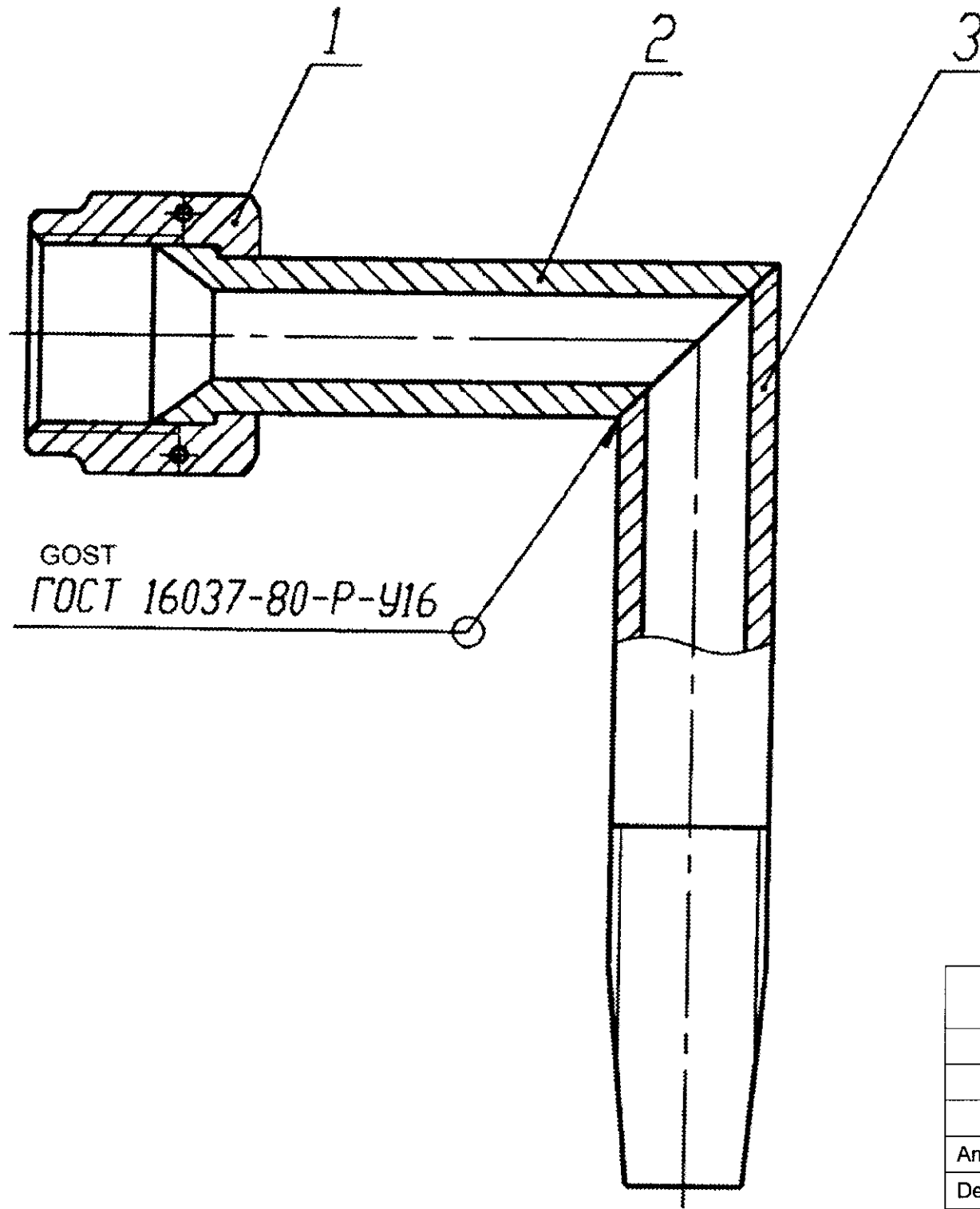
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. Welding rod TsL-11-3.0-2 GOST 9466-75.
2. Use of argon-arc welding is permissible. Filler wire 2 Sv -0.6 Cr19Ni9Ti GOST 2246-70.
3. Coating of external surface Chem. phos. Lacquer BF-4 with Nigrozene , 2 layers, made as per OST3-4123-78, IV, OM2, remaining Chem.phos.
4. Mark Ш , Ч and stamp K on tag.

					AK-630 Sb114-33 SB			
Amend.	Sheet	Doc.No.	Sign	Date	Angle piece Assembly drawing	Type	Weight	Scale
Developed by						A	0.050	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by								

AK-630 114-32

First use

Reference No.

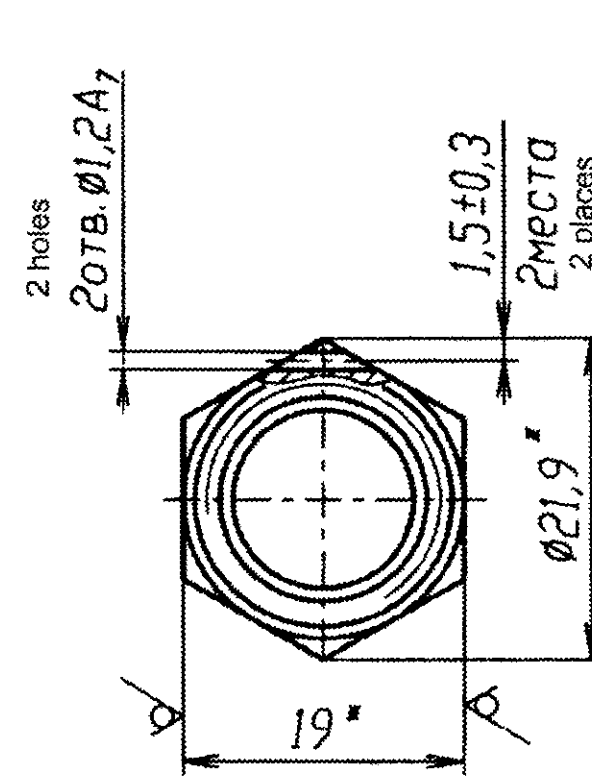
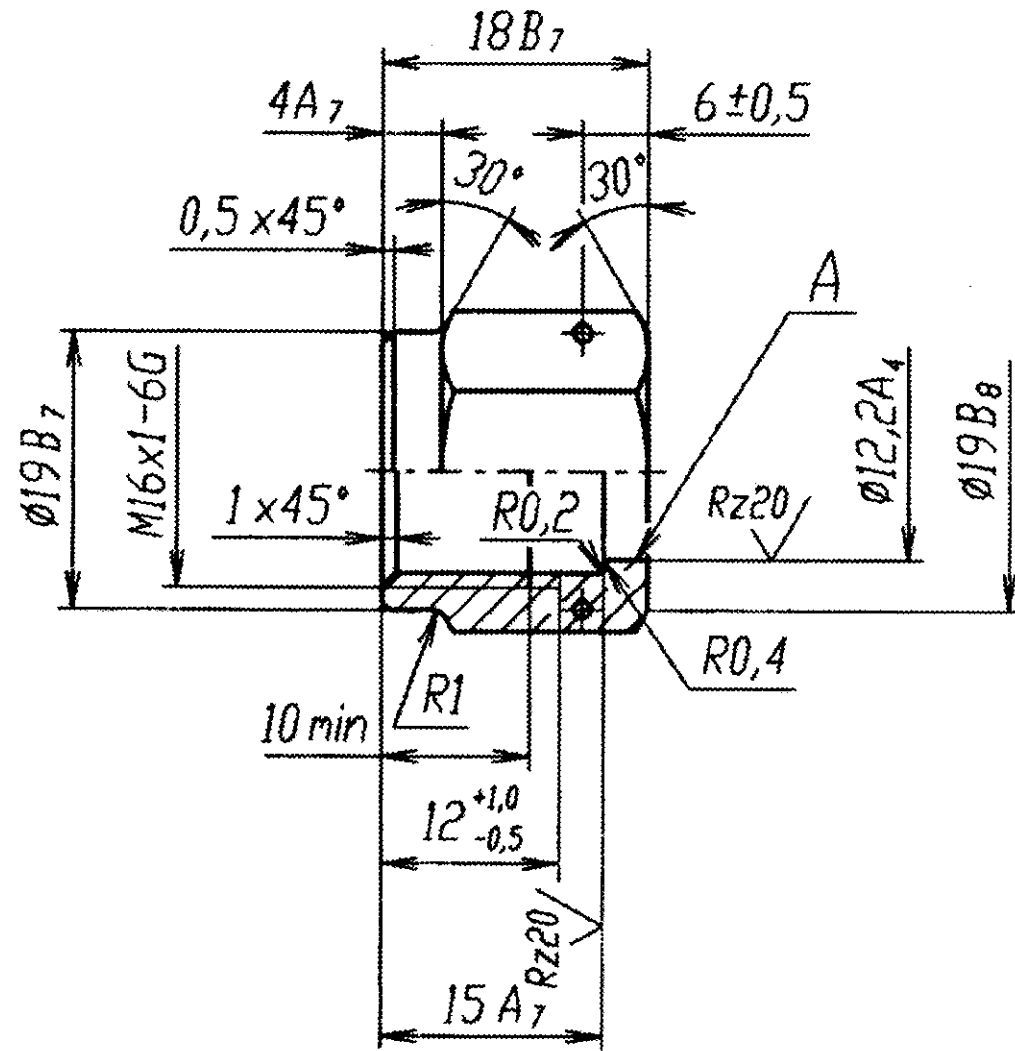
Sign and Date

Duplicate Inv. No.

Alternate Inv. No.

Sign and Date

Orig. inv. no.



Rz40 ✓ (✓)

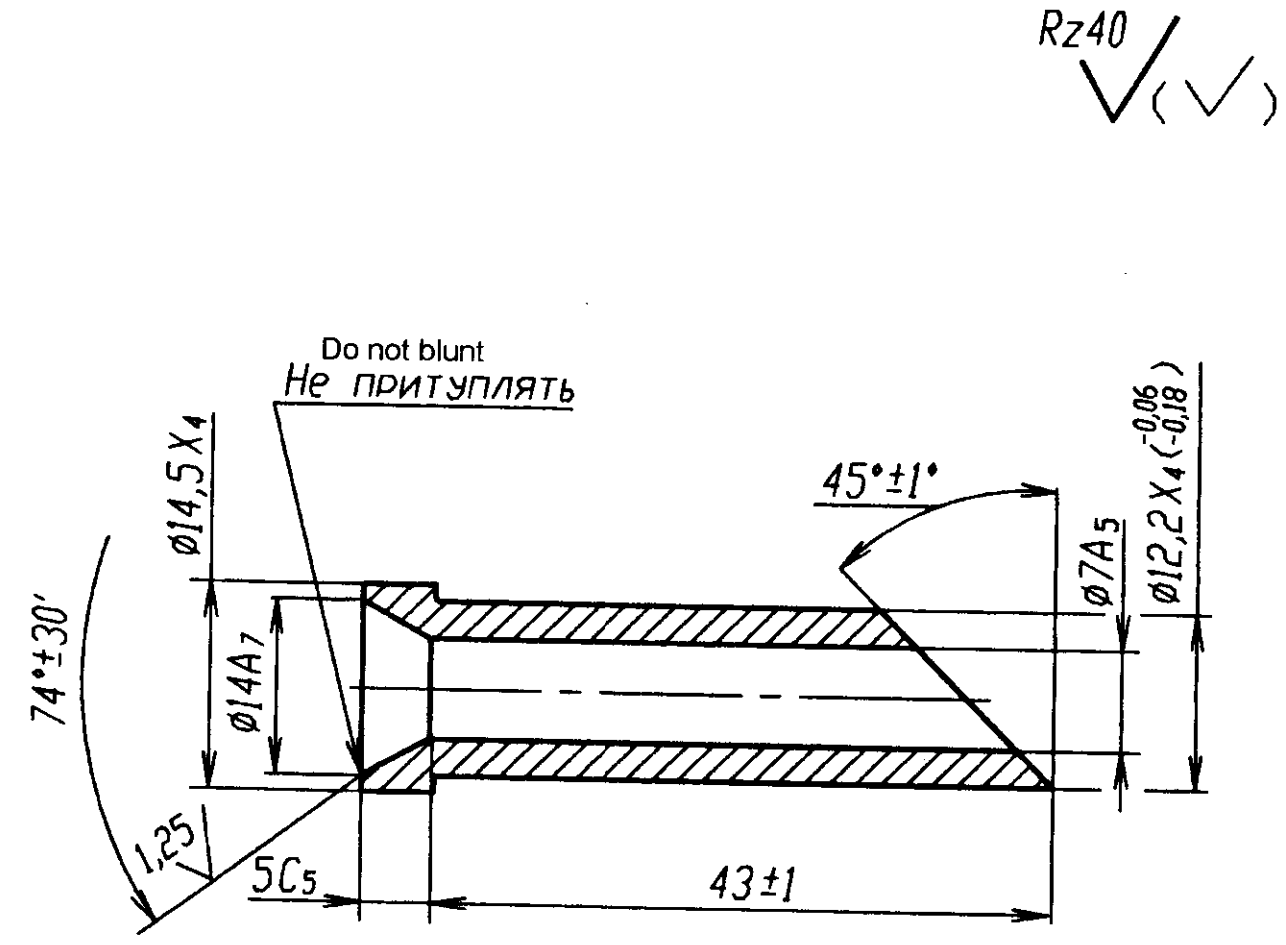
1. Substitute material- hexagon  $\frac{19 - 5GOST8560 - 78}{40GOST1051 - 73}$
2. 31..40.5 HRC<sub>E</sub>. Check 3..5% , but not less than 3 nos. from batch.
- 3.\* Reference dimensions.
4. Blunt sharp edges ~0.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.01 mm.
6. Mark Ш, Ч and stamp K, И on tag.

Designation	Coating
AK-630 114-32	Cd6.phos.
AK-630 -01	Without coating

					AK-630 114-32			
Amend.	Sheet	Doc.No.	Sign	Date	Coupling nut	Type	Weight	Scale
Developed by						A	0.025	2:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Hexagon $\frac{19 - 5GOST8560 - 78}{40Kh - T - VGOST1051 - 73}$			
Approved by								

AK-630 114-72

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



1. Inner angles R~0.4 mm.
2. Blunt sharp edges R~0.2 mm.
3. Mark Ш, Ч and stamp K on tag.

Amend.	Sheet	Doc. No.	Sign	Date

<b>AK-630 114-72</b>			
<b>Nipple</b>	Type	Weigh	Scale
	A	0.015	2:1
Steel 12Cr18Ni9Ti GOST 5632-72		Sheets 1	

AK-630 114-84

First use

Reference No.

Sign and Date

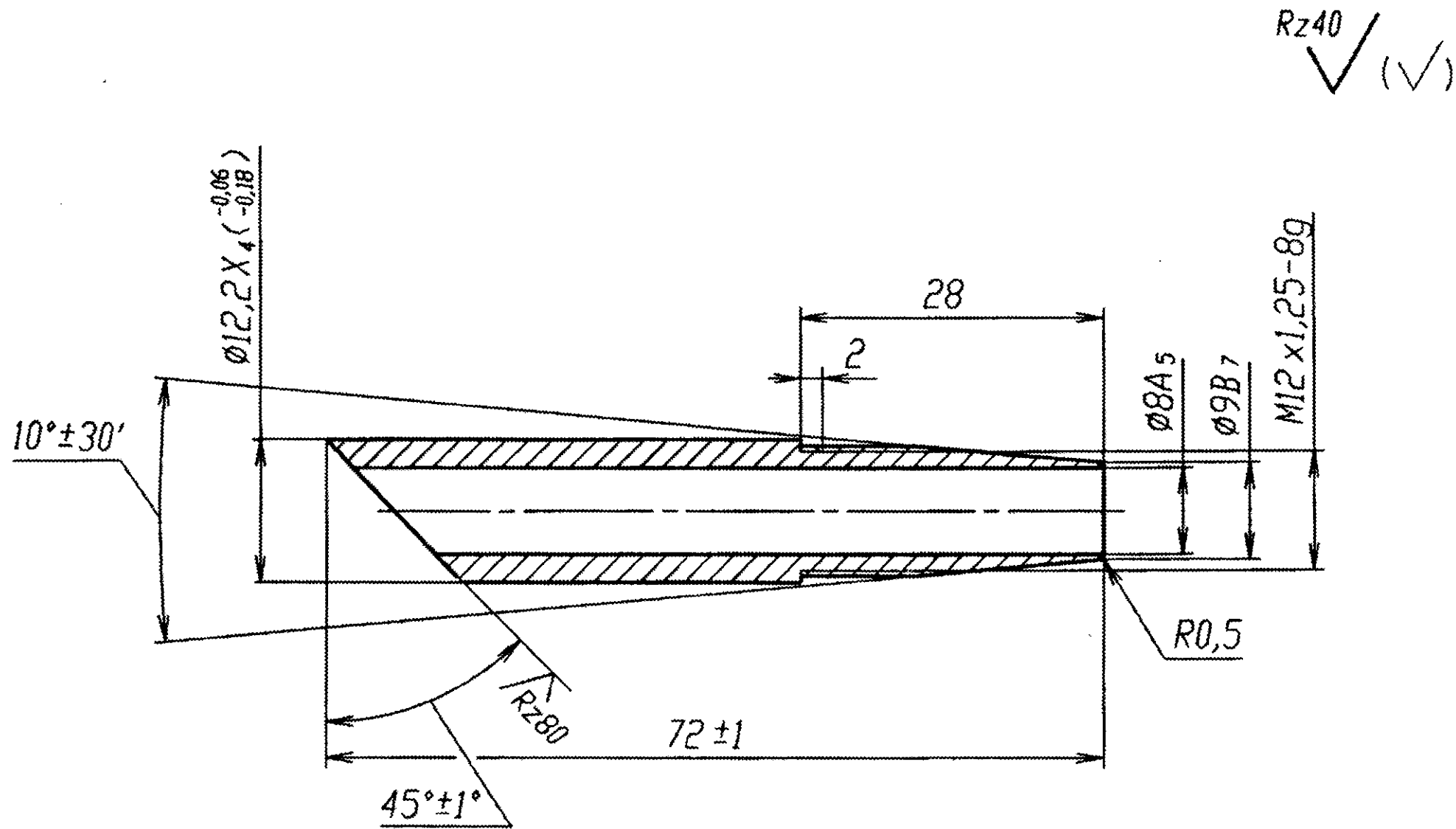
Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

1. Blunt sharp edges ~0.4 mm.
2. Mark Ш, 4 and stamp K on tag..



					<b>AK-630 114-84</b>			
Amend.	Sheet	Doc.No.	Sign	Date	End cap	Type	Weight	Scale
Developed by						A	0.030	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D						Steel 12Cr18Ni9Ti GOST 5632-72		
Approved by								

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks			
Reference No.					<u>Documents</u>					
	A3		✓	AK-630 Sb114-34 SB	Assembly drawing					
					<u>Components</u>					
	A3		✓	AK-630 114-32-01	Coupling nut	1				
	A4		✓	AK-630 114-69	Nipple	1				
	A3		✓	AK-630 114-70	End cap	1				
Sign and Date	<b>AK-630 Sb 114-34</b>									
	Amend.	Sheet	Doc. No.	Sign	Date					
	Developed by									
Orig. Inv. No.	Checked by									
	Elbow							Type	Sheet	Sheets
								A		1
								Head of Q.C.D		
Approved by										
Sign and Date	Dupl. Inv. No.									
	Alternate Inv. No.									
	Sign and Date									



AK-630 Sb114-34 SB

First use

Reference No.

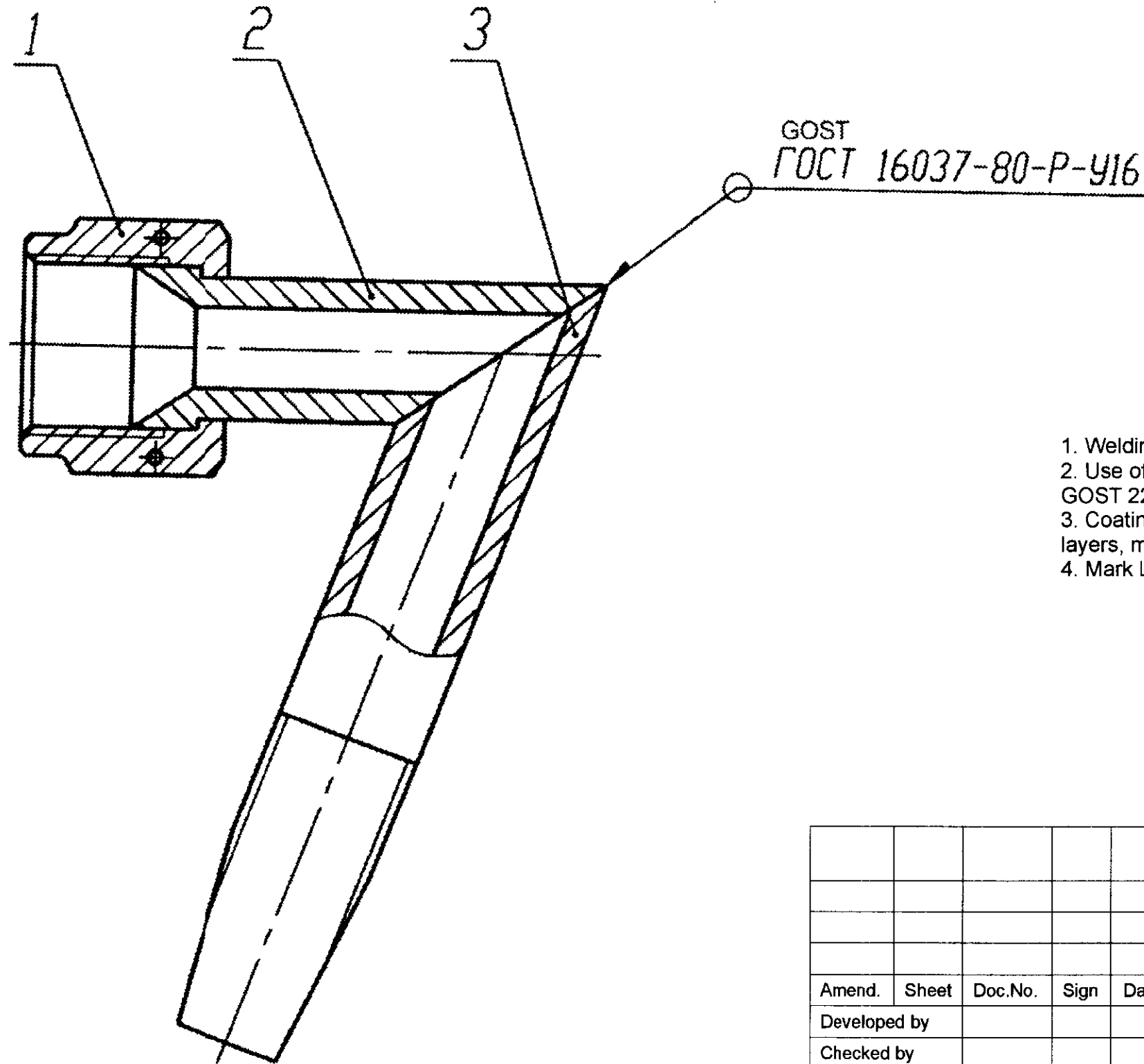
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. Welding rod TsL-11-3.0-2 GOST 9466-75.
2. Use of argon-arc welding is permissible. Filler wire 2 Sv -0.6 Cr19Ni9Ti GOST 2246-70.
3. Coating of external surface Chem. phos. Lacquer BF-4 with Nigrozene , 2 layers, made as per OST3-4123-78, IV, OM2, remaining Chem.phos.
4. Mark Ш , Ч and stamp K on tag.

					AK-630 Sb114-34 SB			
Amend.	Sheet	Doc.No.	Sign	Date	Angle piece Assembly drawing	Type	Weight	Scale
Developed by						A	0.070	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by								

First use

Reference No.

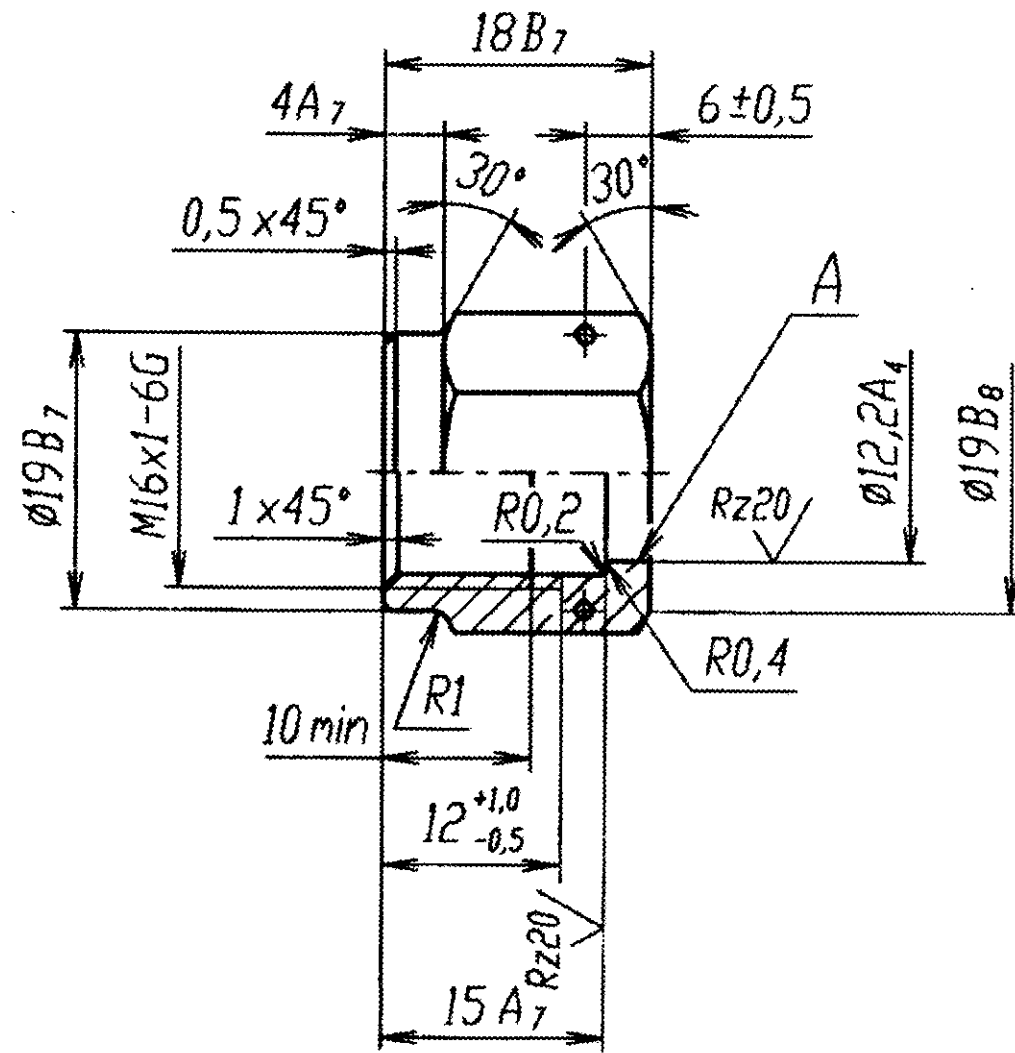
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz40 ✓ (✓)

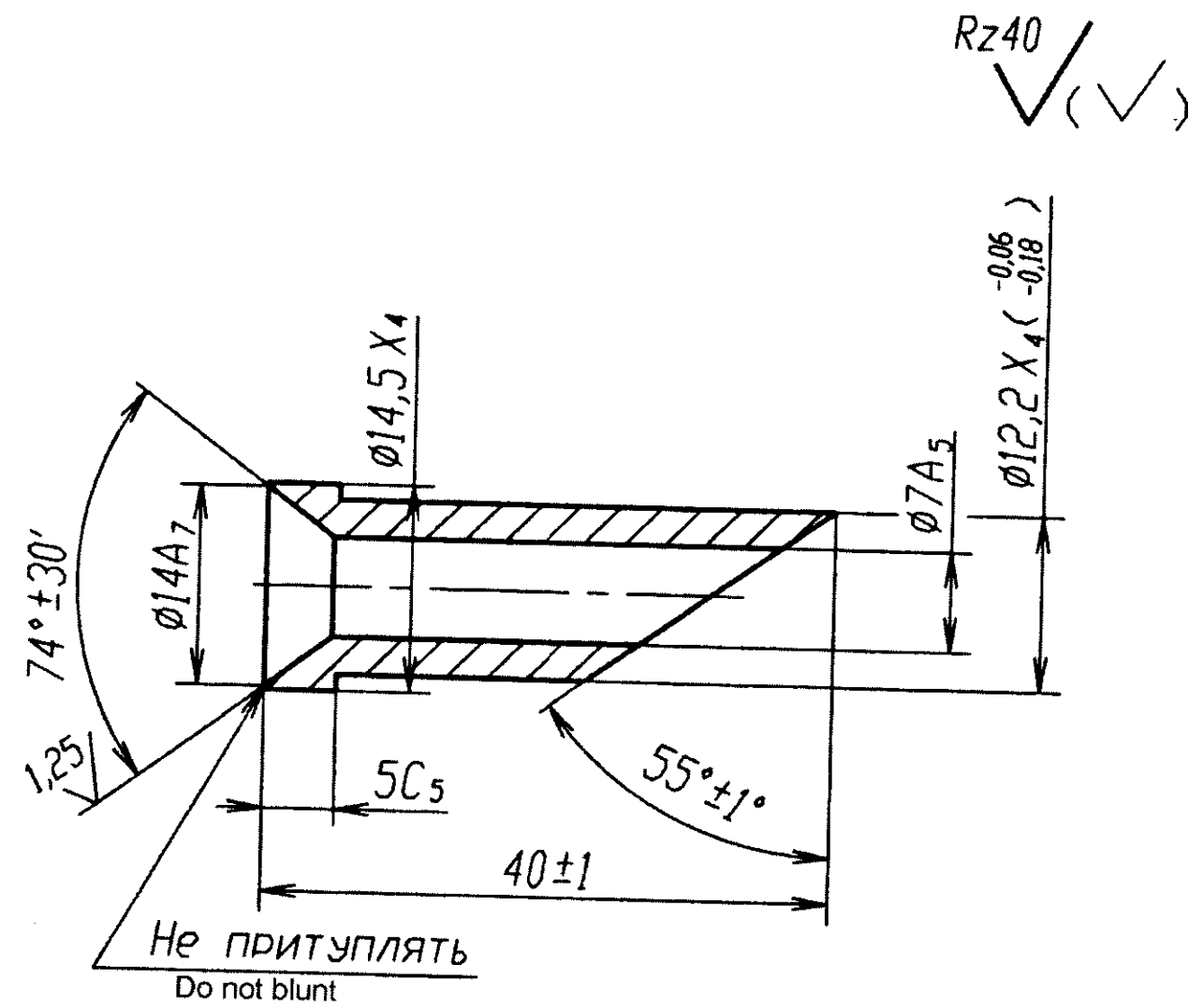
1. Substitute material- hexagon  $\frac{19 - 5GOST8560 - 78}{40GOST1051 - 73}$
2. 31..40.5 HRC<sub>E</sub>. Check 3..5% , but not less than 3 nos. from batch.
- 3.\* Reference dimensions.
4. Blunt sharp edges ~0.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.01 mm.
6. Mark Ш, Ч and stamp K, И on tag.

Designation	Coating
AK-630 114-32	Cd6.phos.
AK-630 -01	Without coating

					AK-630 114-32				
Amend.	Sheet	Doc.No.	Sign	Date	Coupling nut		Type	Weight	Scale
							A	0.025	2:1
							Sheet	Sheets 1	
					Hexagon $\frac{19 - 5GOST8560 - 78}{40Kh - T - VGOST1051 - 73}$				

AK-630 114-69

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



1. Inner angles  $R \sim 0.4$  mm.
2. Blunt sharp edges  $R \sim 0.4$  mm.
3. Mark Ш, Ч and stamp K on tag.

Amend.	Sheet	Doc. No.	Sign	Date

<b>AK-630 114-69</b>			
<b>Nipple</b>	Type	Weight	Scale
	A	0.010	2:1
Sheet		Sheets 1	
Steel 12Cr18Ni9Ti GOST 5632-72			

AK-630 114-70

First use

Reference No.

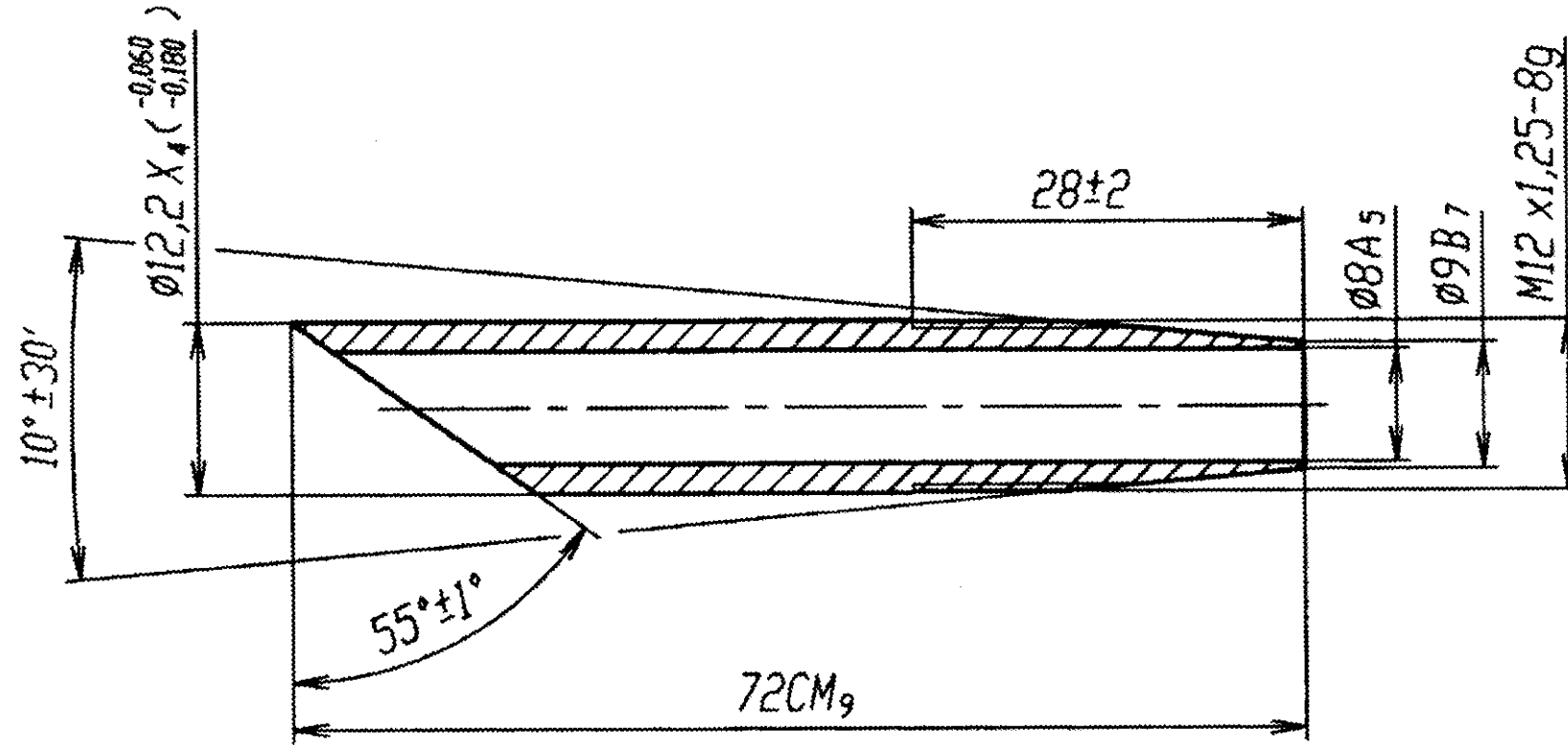
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz40  
✓(✓)

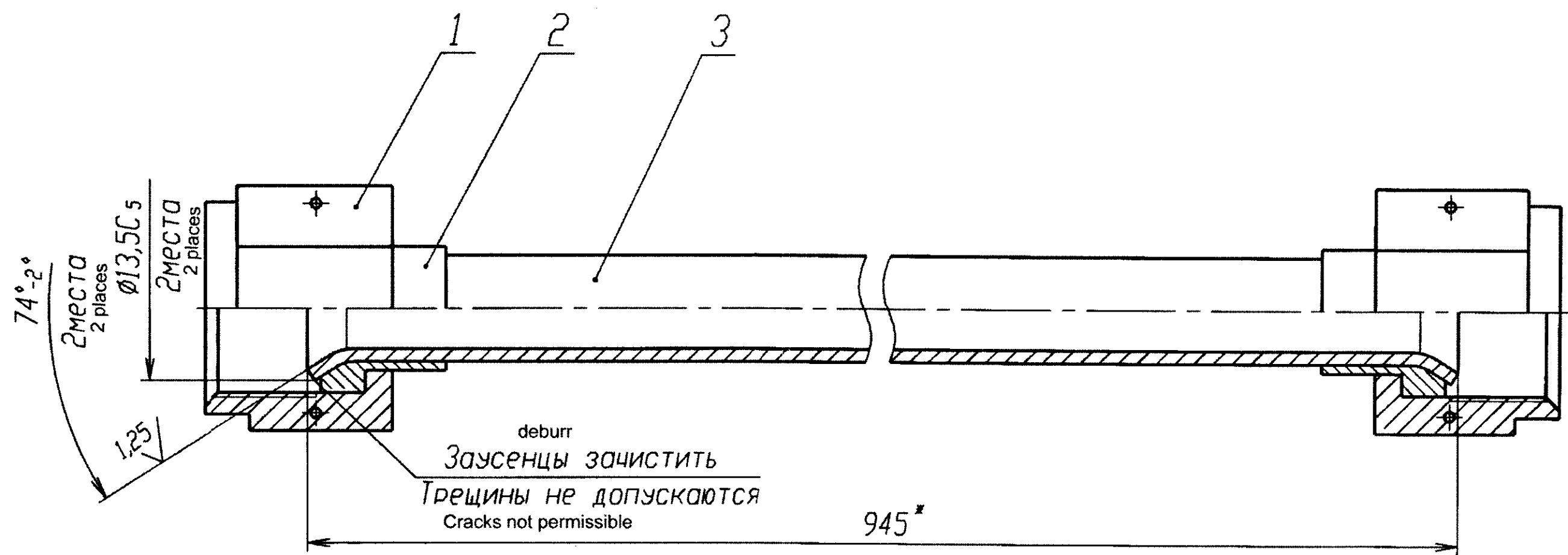
1. Inner angles R~0.4 mm.
2. Blunt sharp edges ~0.4 mm.
3. Mark Ш, Ч and stamp K on tag.

					<b>AK-630 114-70</b>			
Amend.	Sheet	Doc.No.	Sign	Date	End cap	Type	Weight	Scale
Developed by						A	0.040	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Steel 12Cr18Ni9Ti GOST 5632-72			
Approved by								

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.	<u>Documents</u>							
	A3			AK-630 Sb 114-9 SB	Assembly drawing			
	<u>Components</u>							
	A3		1	AK-630 114-32	Coupling nut	2		
	A4		2	AK-630 114-33	Nipple	2		
A4		3	AK-630 114-35	Pipe	1			
Sign and Date	<b>AK-630 Sb 114-9</b>							
	Amend.	Sheet	Doc. No.	Sign	Date			
Orig. Inv. No.	Developed by				<b>Pipeline</b>	Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D							
	Approved by							
Sign and Date								
Dupl. Inv. No.								
Alternate Inv. No.								

First use

Reference No.



Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

1. \* Reference dimension.
2. Test for strength with air pressure 80 atm. Carry out testing by loading three times and keeping for 10 minutes.  
Disturbance of strength and tightness of joints is not permissible.
3. Mark Ш, Ч and stamp K on tag.

					AK-630 Sb 114-9 SB			
Amend.	Sheet	Doc.No.	Sign	Date	<b>Pipeline Assembly drawing</b>	Type	Weight	Scale
Developed by						A	0.230	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by								

First use

Reference No.

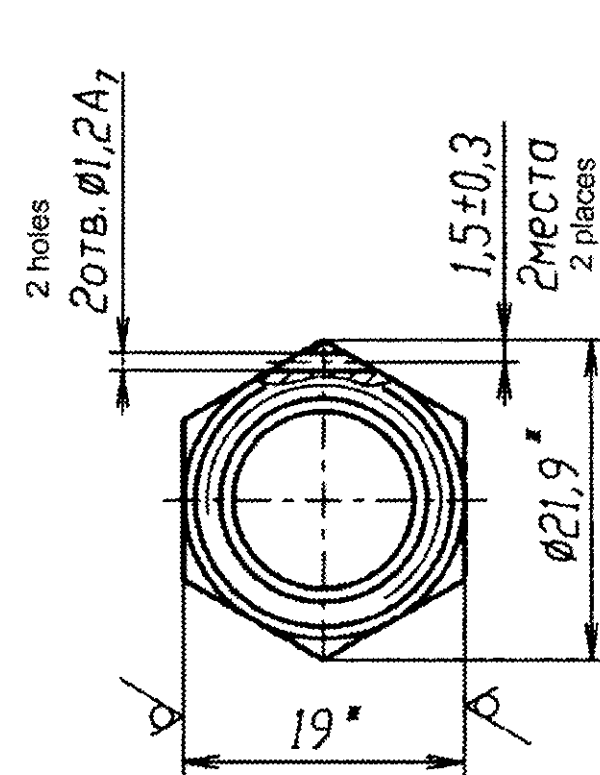
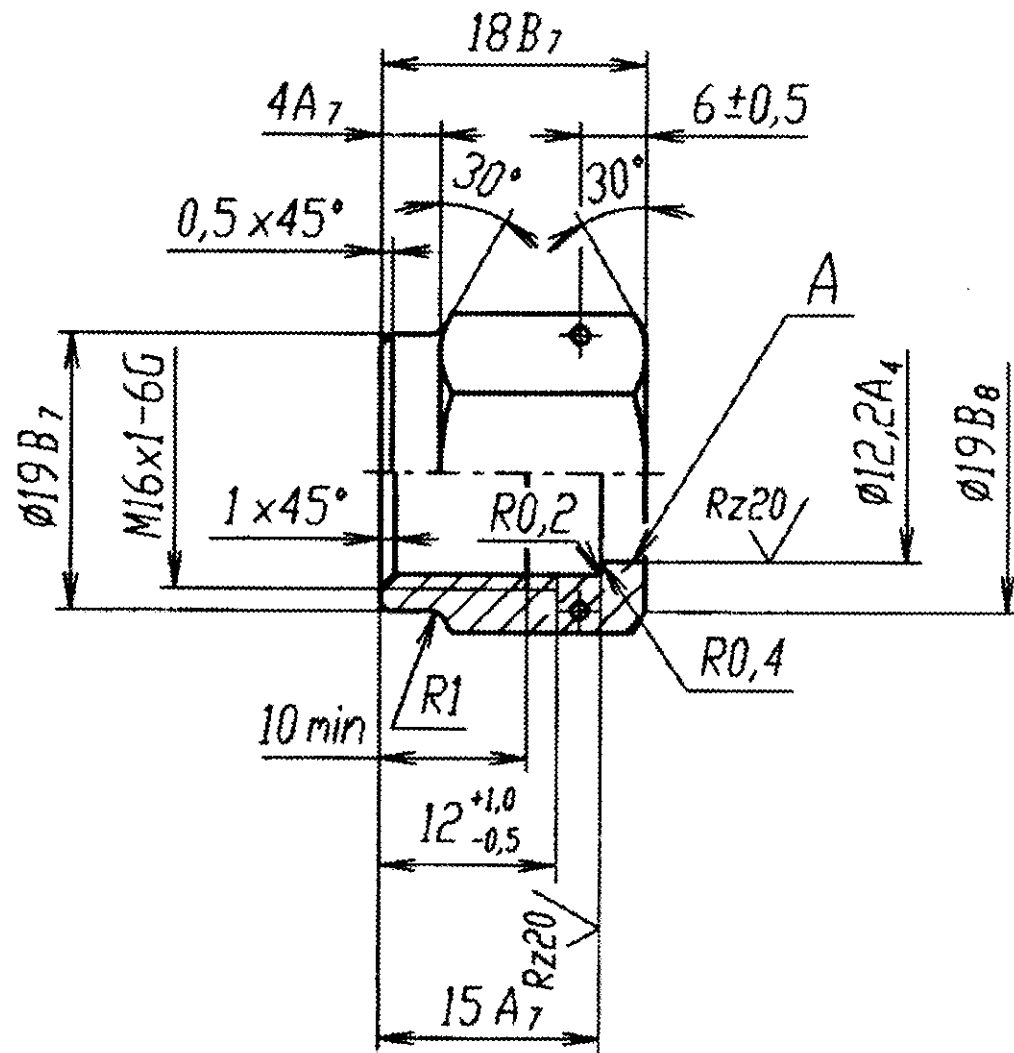
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz40 ✓ (✓)

1. Substitute material- hexagon  $\frac{19 - 5GOST8560 - 78}{40GOST1051 - 73}$
2. 31..40.5 HRC<sub>E</sub>. Check 3..5% , but not less than 3 nos. from batch.
- 3.\* Reference dimensions.
4. Blunt sharp edges ~0.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.01 mm.
6. Mark Ш, Ч and stamp K, И on tag.

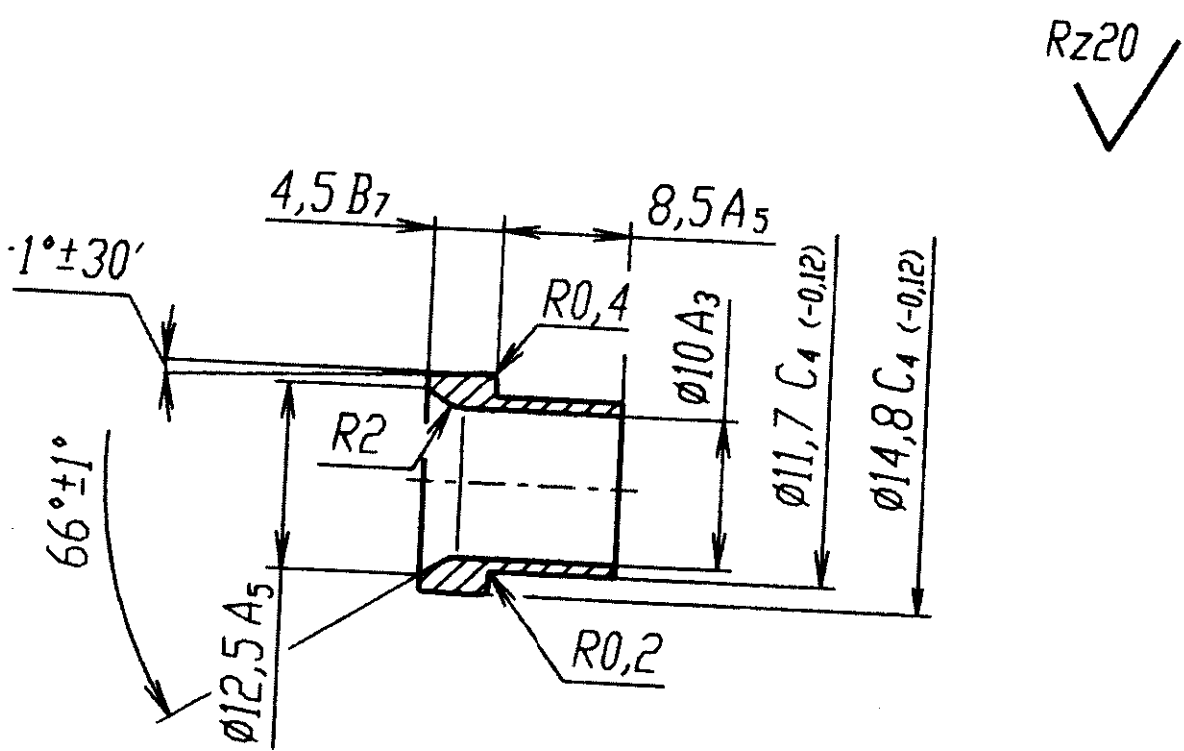
Designation	Coating
AK-630 114-32	Cd6.phos.
AK-630 -01	Without coating

					AK-630 114-32			
Amend.	Sheet	Doc.No.	Sign	Date	Coupling nut	Type	Weight	Scale
Developed by						A	0.025	2:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D						Hexagon $\frac{19 - 5GOST8560 - 78}{40Kh - T - VGOST1051 - 73}$		
Approved by								

AK-630 114-33

Blank No. 406

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



Designation	Coating
AK-630 114-33	Kd12. pos
AK-630 -01	without coating

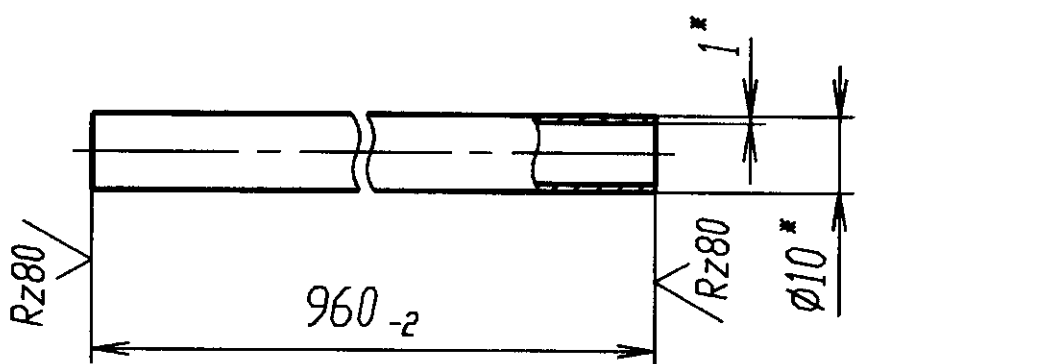
- 1. 38.5...44.5 HRC<sub>E</sub>. Check on specimen.
- 2. Blunt sharp edges ~0.2 mm.
- 3. Mark Ш, Ч and stamp K, И on tag.

AK-630 114-33					
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					
Nipple			Type	Weight	Scale
			A	0.008	2:1
			Sheet	Sheets 1	
Steel 50 GOST 1050-88					

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**AK-630 114-35**

Approved OGMet	Orig. Inv. No.		Approved KTONI	Sign and Date	Approved TC	Dupl. Inv. No.	Sign and Date	Approved by shop	Reference No.		First use
	Amend.	Sheet							Doc. No.	Sign	
<b>AK-630 114-35</b>											
<p style="text-align: center;">  </p> <p>           1.* Reference dimensions.            2. Blunt sharp edges ~0.4 mm.            3. Coating Chem. Pass.            4. Mark Ш, Ч and stamp K on tag.         </p>											
<b>AK-630 114-35</b>											
<b>Pipe</b>											
						Type	Weight	Scale			
						A	0.190	1:1			
						Sheet		Sheets 1			
<b>Pipe M2 M10x1</b> <b>GOST 617-90</b>											

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Format A4

First use		Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks		
Reference No.		A3			AK-630 Sb 114-10 SB	Assembly drawing				
		<u>Documents</u>								
		<u>Components</u>								
		A3		✓	AK-630 114-32	Coupling nut	2			
		A4		✓	AK-630 114-33	Nipple	2			
A4		✓	AK-630 114-36	Pipe	1					
Sign and Date										
Dupl. Inv. No.										
Alternate Inv. No.										
Sign and Date					<b>AK-630 Sb 114-10</b>					
		Amend.	Sheet	Doc. No.	Sign	Date				
Orig. Inv. No.		Developed by					Type	Sheet	Sheets	
		Checked by					A		1	
		Head of Q.C.D					<b>Pipeline</b>			
		Approved by								

First use

Reference No.

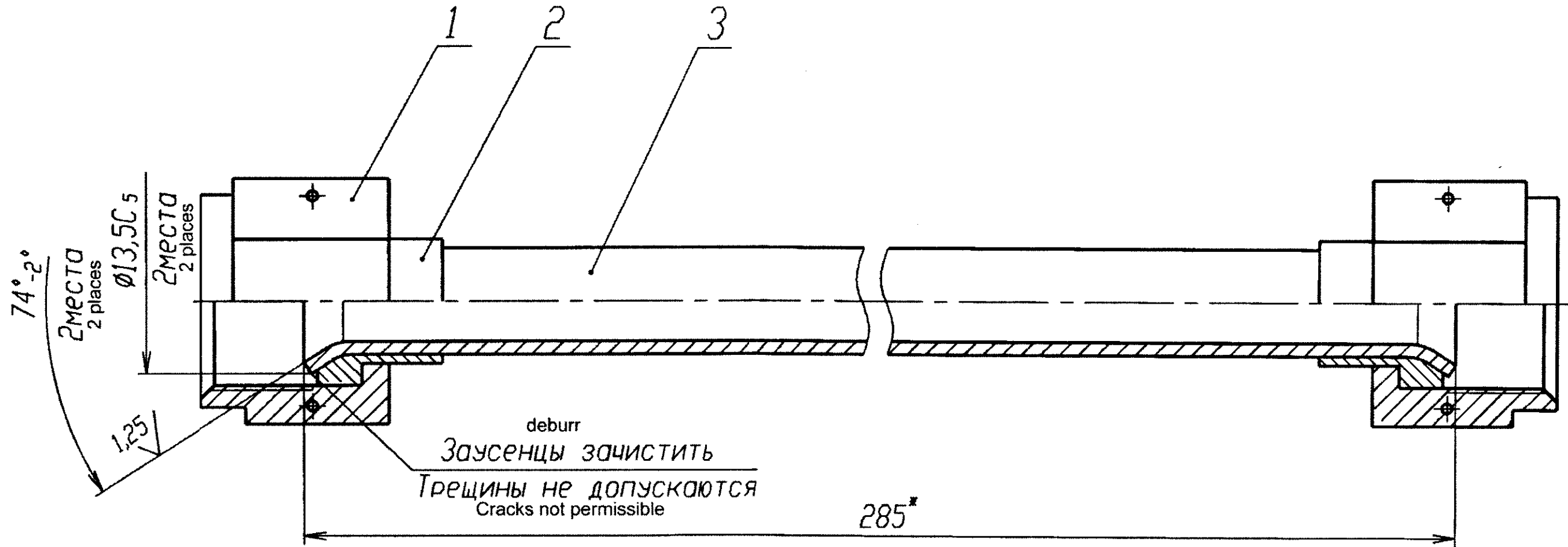
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. \* Reference dimension.
2. Test for strength with air pressure 80 atm. Carry out testing by loading three times and keeping for 10 minutes. Disturbance of strength and tightness of joints is not permissible.
3. Mark Ш, Ч and stamp K on tag.

					AK-630 Sb 114-10 SB			
Amend.	Sheet	Doc.No.	Sign	Date	<b>Pipeline Assembly drawing</b>	Type	Weight	Scale
Developed by						A	0.130	2:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by								

First use

Reference No.

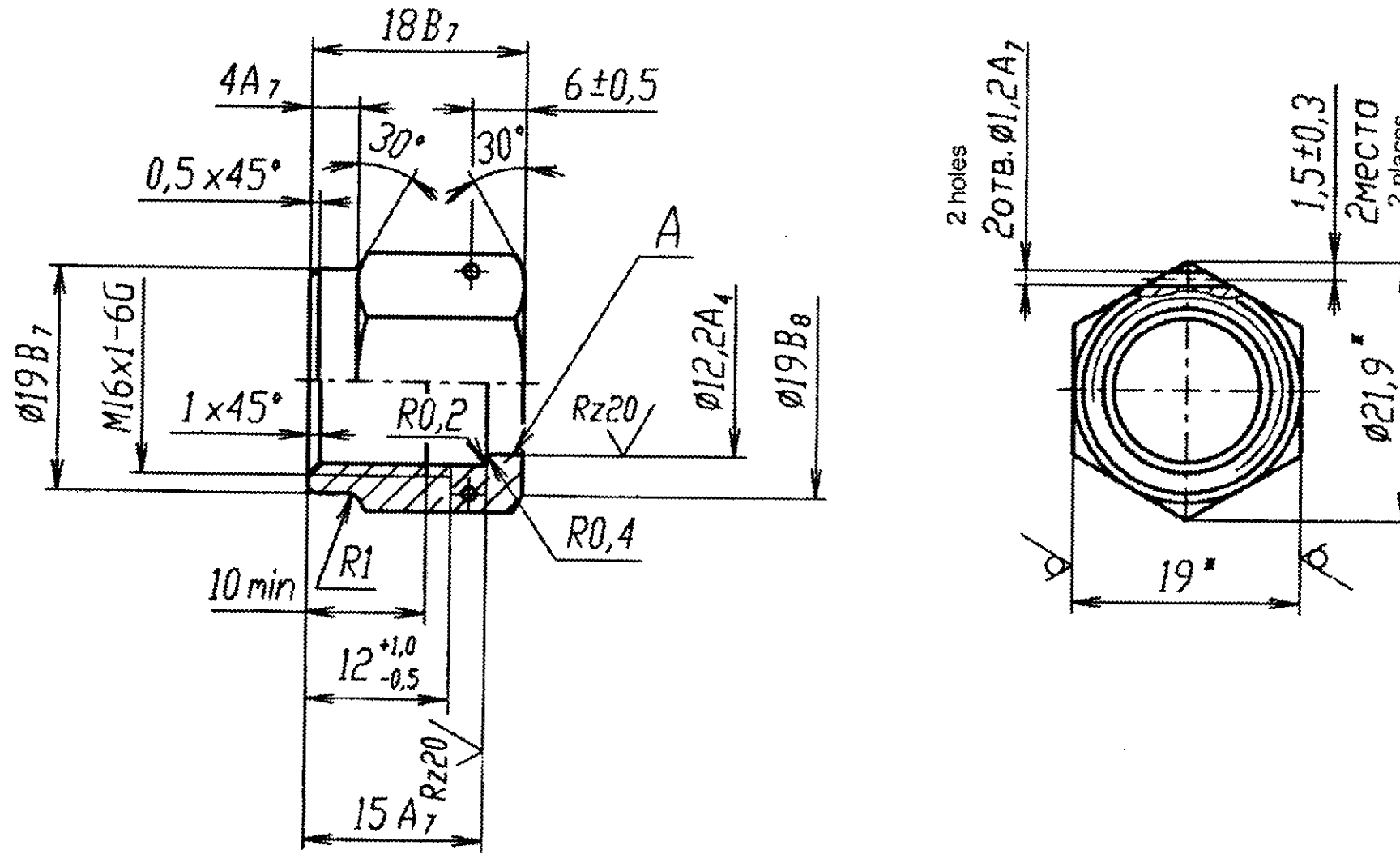
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz40 ✓ (✓)

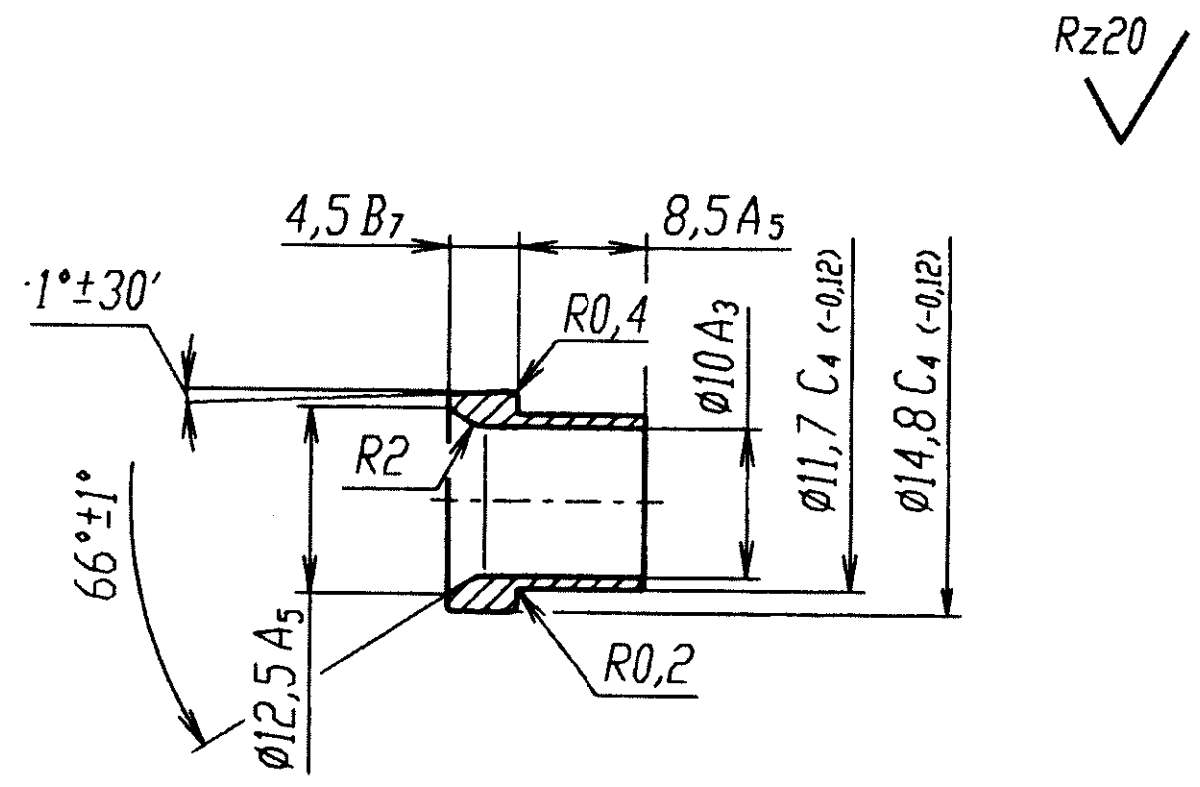
1. Substitute material- hexagon  $\frac{19 - 5GOST8560 - 78}{40GOST1051 - 73}$
2. 31..40.5 HRC<sub>E</sub>. Check 3..5% , but not less than 3 nos. from batch.
- 3.\* Reference dimensions.
4. Blunt sharp edges ~0.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.01 mm.
6. Mark Ш, Ч and stamp K, И on tag.

Designation	Coating
AK-630 114-32	Cd6.phos.
AK-630 -01	Without coating

					AK-630 114-32		
					Coupling nut		
					Type	Weight	Scale
					A	0.025	2:1
					Sheet	Sheets 1	
					Hexagon $\frac{19 - 5GOST8560 - 78}{40Kh - T - VGOST1051 - 73}$		
Amend.	Sheet	Doc.No.	Sign	Date			
Developed by							
Checked by							
Head of Q.C.D							
Approved by							

AK-630 114-33

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



Rz20 ✓

Designation	Coating
AK-630 114-33	Kd12. pos
AK-630 -01	without coating

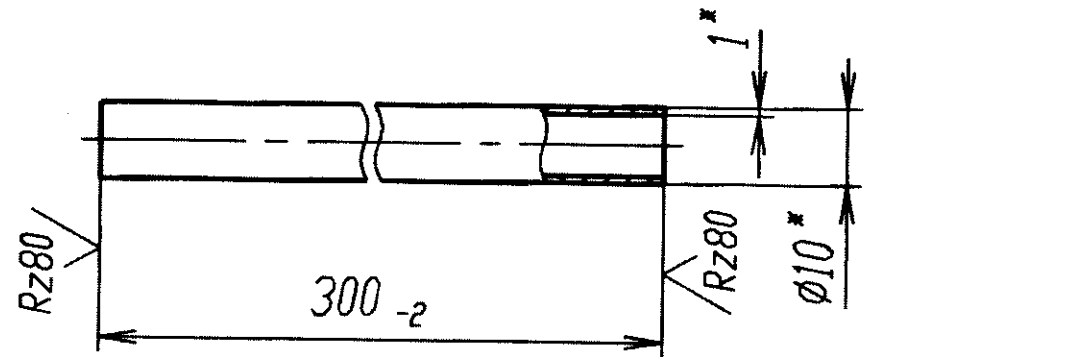
- 1.38.5...44.5 HRC<sub>E</sub>. Check on specimen.
2. Blunt sharp edges ~0.2 mm.
3. Mark Ш, Ч and stamp K, И on tag.

Amend.	Sheet	Doc. No.	Sign	Date

<b>AK-630 114-33</b>			
<b>Nipple</b>	Type	Weight	Scale
	A	0.008	2:1
	Sheet		Sheets 1
Steel 50 GOST 1050-88			

AK-630 114-36

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



- 1.\* Reference dimensions.
- 2. Blunt sharp edges  $\sim 0.4$  mm.
- 3. Coating Chem. Pass.
- 4. Mark Ш, Ч and stamp K on tag.

Amend.	Sheet	Doc. No.	Sign	Date

<b>AK-630 114-36</b>				
<b>Pipe</b>	Type	Weight	Scale	
	A	0.110	1:1	
Sheet		Sheets 1		
Pipe M2 M10 x 1 GOST 617-90				

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Format A4

First use		Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
Reference No.						<u>Documents</u>		
	A3	<del>1</del>			AK-630 Sb 114-11 SB	Assembly drawing		
						<u>Components</u>		
	A3	✓1			AK-630 114-32	Coupling nut	2	
	A4	✓2			AK-630 114-33	Nipple	2	
	A4	✓3			AK-630 114-37	Pipe	1	
Sign and Date					<b>AK-630 Sb 114-11</b>			
	Amend.	Sheet	Doc. No.	Sign	Date			
Orig. Inv. No.	Developed by				<b>Pipeline</b>	Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D							
	Approved by							
Sign and Date								
Dupl. Inv. No.								
Alternate Inv. No.								

AK-630 Sb 114-11 SB

First use

Reference No.

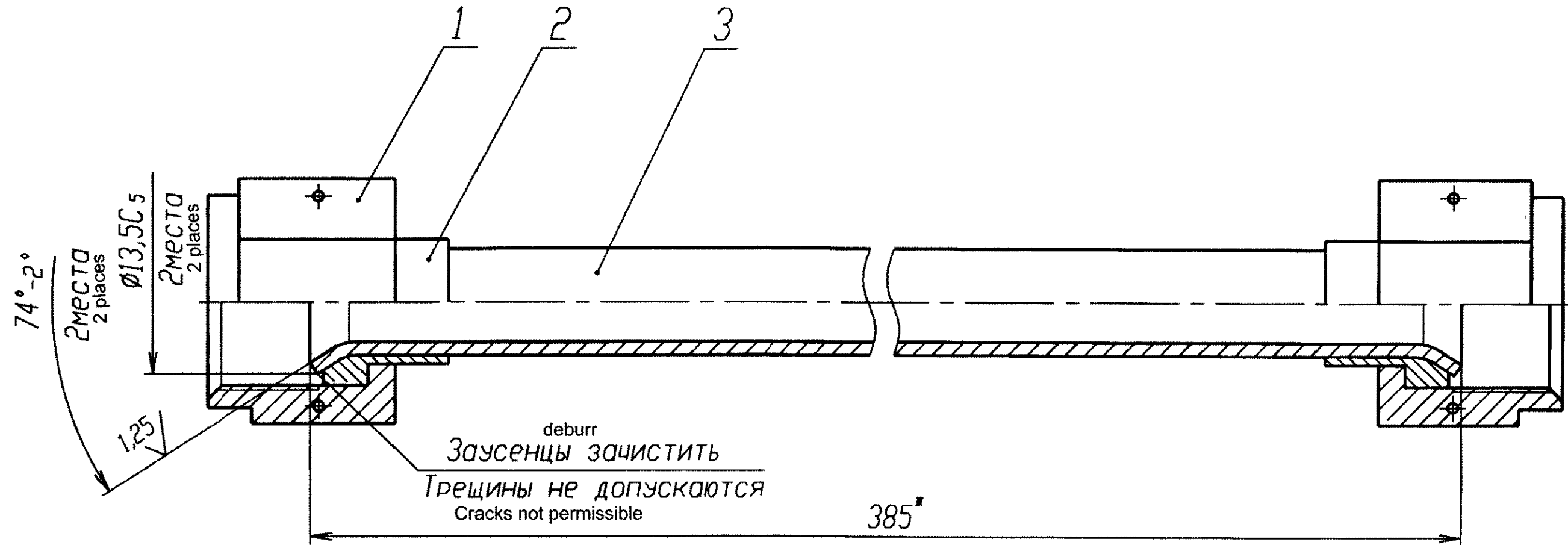
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. \* Reference dimension.
2. Test for strength with air pressure 80 atm. Carry out testing by loading three times and keeping for 10 minutes.  
Disturbance of strength and tightness of joints is not permissible.
3. Mark Ш, Ч and stamp K on tag.

					AK-630 Sb 114-11 SB			
Amend.	Sheet	Doc.No.	Sign	Date	<b>Pipeline Assembly drawing</b>	Type	Weight	Scale
Developed by						A	0.160	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by								



AK-630 114-32

First use

Reference No.

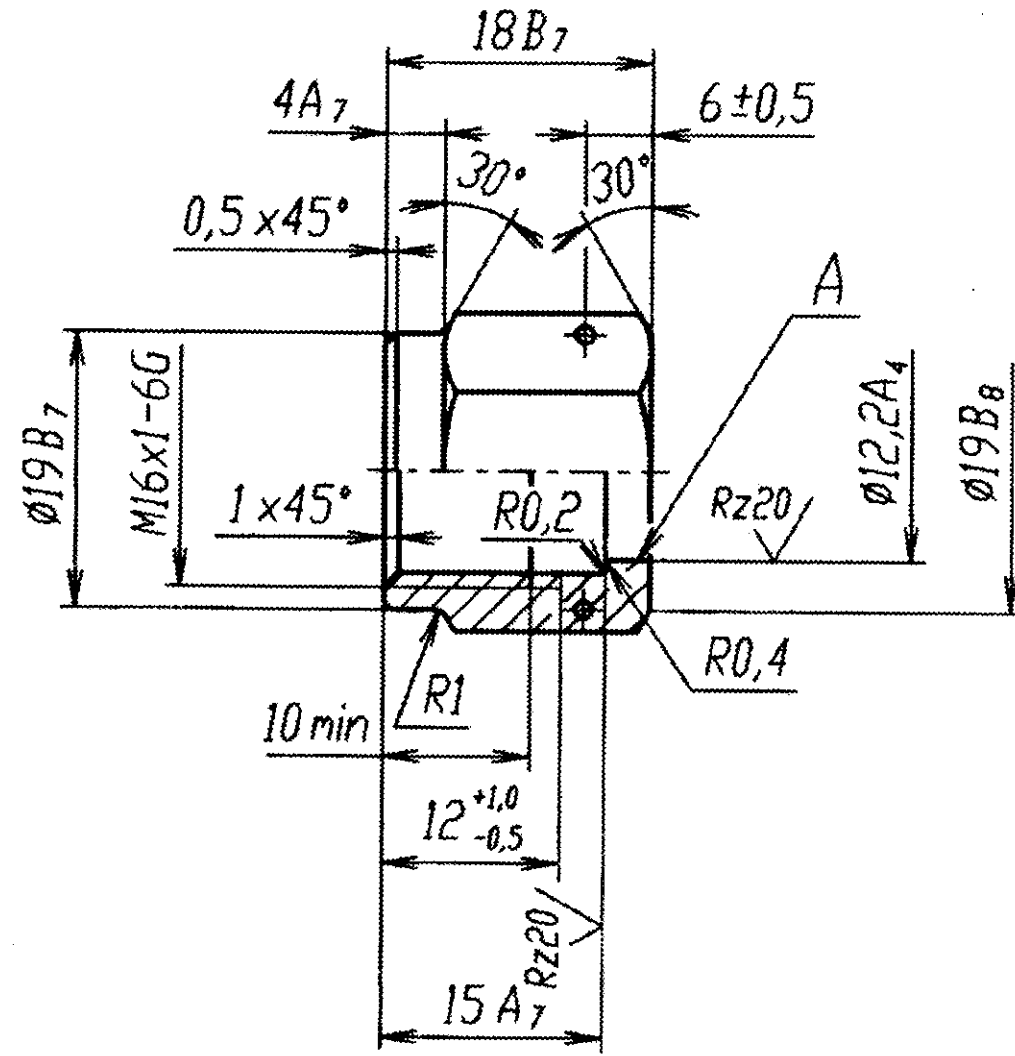
Sign and Date

Duplicate Inv. No.

Alternate Inv. No.

Sign and Date

Orig. inv. no.

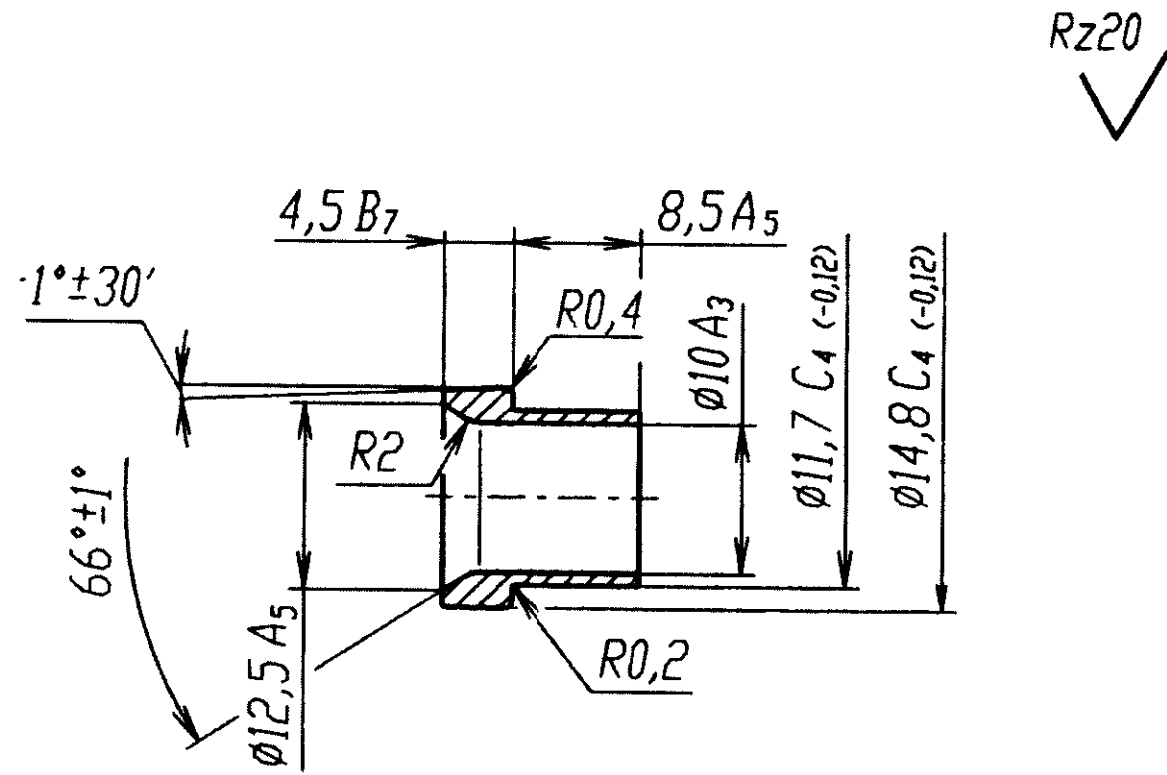


1. Substitute material- hexagon  $\frac{19 - 5GOST8560 - 78}{40GOST1051 - 73}$
2. 31..40.5 HRC<sub>E</sub>. Check 3..5% , but not less than 3 nos. from batch.
- 3.\* Reference dimensions.
4. Blunt sharp edges ~0.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.01 mm.
6. Mark Ш, Ч and stamp K, И on tag.

Designation	Coating
AK-630 114-32	Cd6.phos.
AK-630 -01	Without coating

					AK-630 114-32				
Amend.	Sheet	Doc.No.	Sign	Date	Coupling nut		Type	Weight	Scale
							A	0.025	2:1
Developed by									
Checked by									
Head of Q.C.D									
Approved by					Hexagon $\frac{19 - 5GOST8560 - 78}{40Kh - T - VGOST1051 - 73}$				
							Sheet	Sheets 1	

AK-630 114-33



Designation	Coating
AK-630 114-33	Kd12. pos
AK-630 -01	without coating

- 1.38.5...44.5 HRC<sub>E</sub>. Check on specimen.
2. Blunt sharp edges ~0.2 mm.
3. Mark Ш, Ч and stamp K, И on tag.

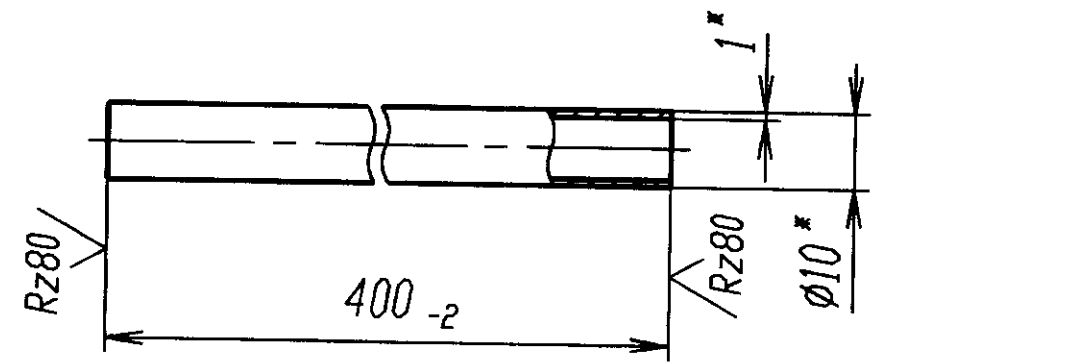
Approved OGMet	Approved TC	Approved KTONI	Approved by shop	Reference No.	First use
Orig. Inv. No.	Alternate Inv. No.	Sign and Date	Dupl. Inv. No.	Sign and Date	Sign and Date
Amend.	Sheet	Doc. No.	Sign	Date	
Developed by					
Checked by					
Head of Q.C.D					
Design bureau chief					
Head of Q.C.D					
Approved by					
<b>AK-630 114-33</b>					
<b>Nipple</b>		Type	Weight	Scale	
		A	0.008	2:1	
		Sheet	Sheets 1		
		Steel 50 GOST 1050-88			

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AK-630 114-37

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



- 1.\* Reference dimensions.
- 2. Blunt sharp edges  $\sim 0.4$  mm.
- 3. Coating Chem. Pass.
- 4. Mark Ш, Ч and stamp K on tag.

Sign and Date	Sign and Date	Sign and Date	Sign and Date	Sign and Date

<b>AK-630 114-37</b>			
<b>Pipe</b>	Type	Weight	Scale
	A	0.160	1:1
	Sheet	Sheets 1	
Pipe M2 M10 x 1 GOST 617-90			

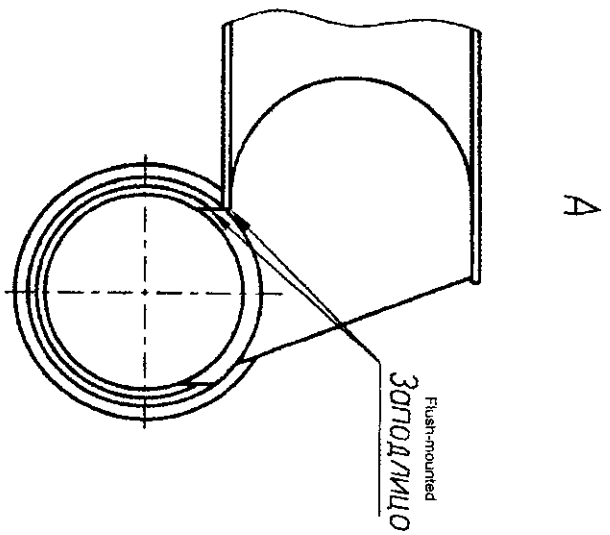
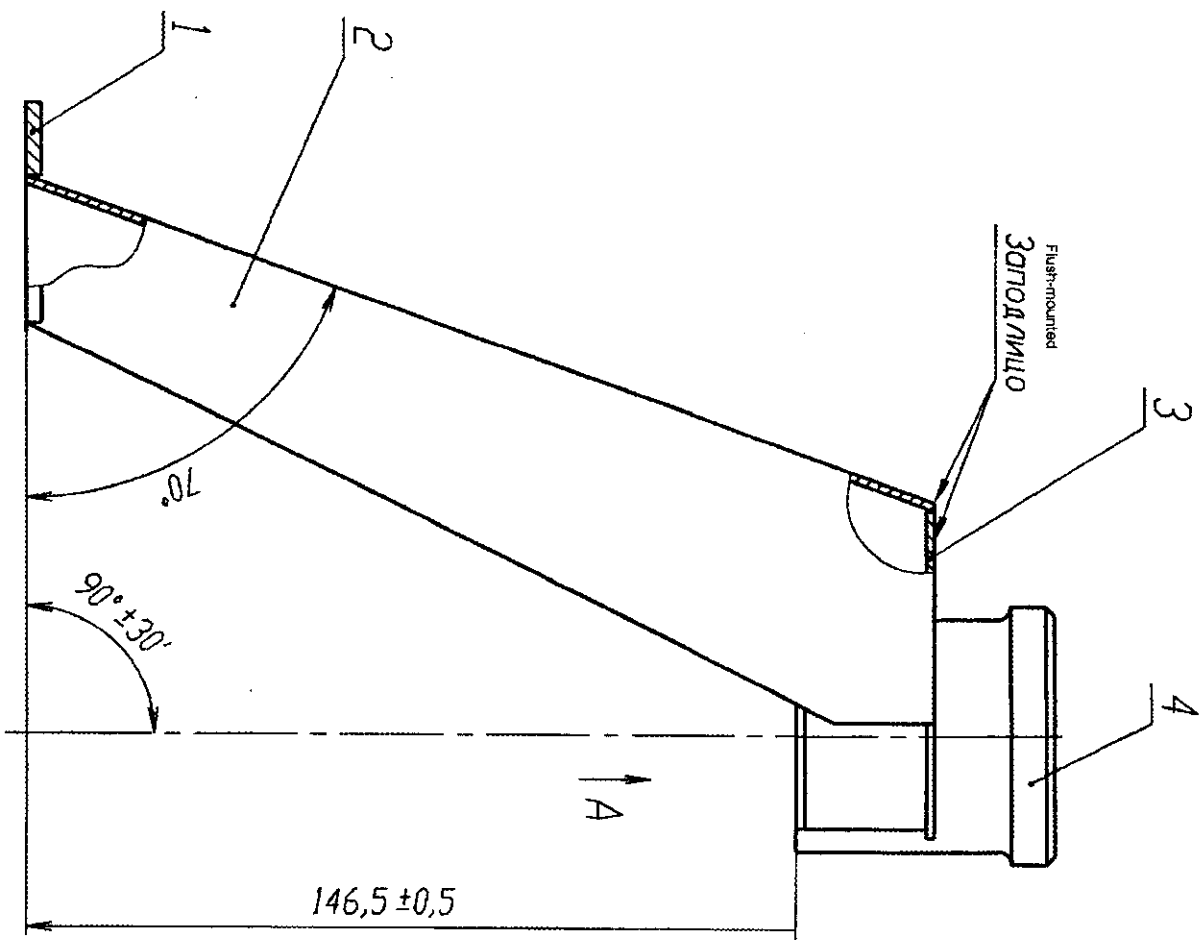
Copied by

Format A4

First use		Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.		<u>Documents</u>							
		A2		✓	AK-630 Sb 114-12 SB	Assembly drawing			
		<u>Components</u>							
		A4		✓1	AK-630 114-38	Base plate	1		
		A3		✓2	AK-630 114-39	Tray	1		
		A4		✓3	AK-630 114-40	Cover	1		
		A3		✓4	AK-630 114-41	Cylinder	1		
Sign and Date	<b>AK-630 Sb 114-12</b>								
	Amend.	Sheet	Doc. No.	Sign	Date				
	Developed by								
Orig. Inv. No.	Checked by					<b>Casing</b>	Type	Sheet	Sheets
							A		1
	Head of Q.C.D								
	Approved by								
Sign and Date		Dupl. Inv. No.		Alternate Inv. No.					

Изм. N	подл.	Подп. и дата	Взаминв. N	Изм. N дубл.	Подп. и дата

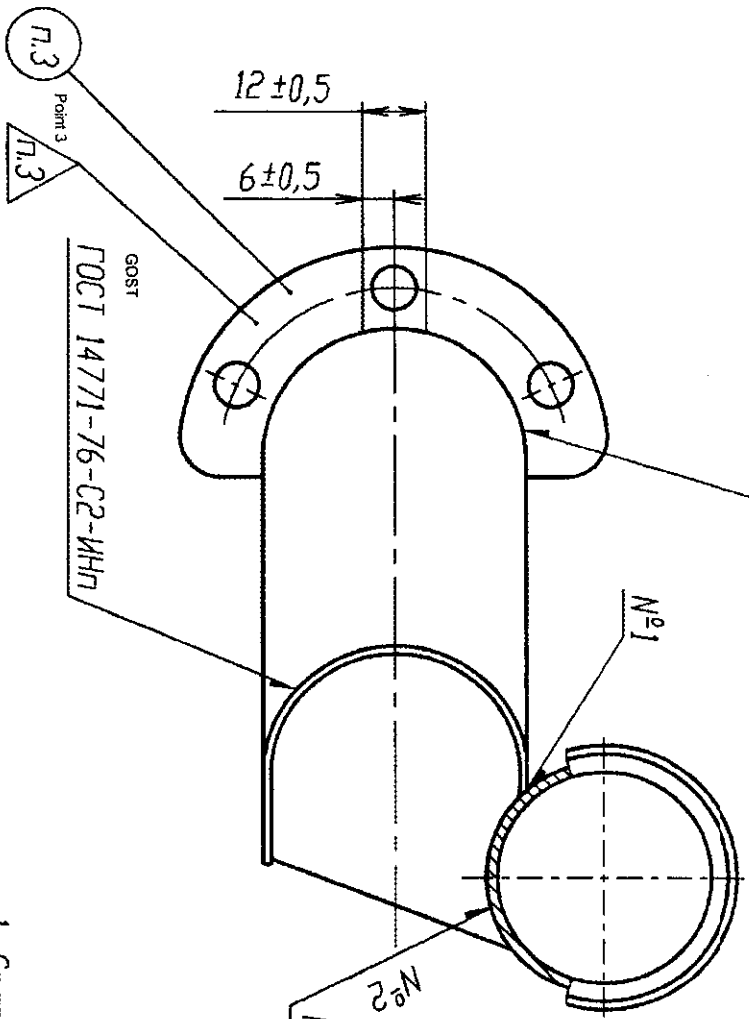
Справ. N	Перв. примен.



AK-630 Sb 114-12 SB

AK-630 СБ114-12СБ

GOST  
ГОСТ 14771-76-11-ИНН-2-210



1. Argon - arc welding with the use of filler electrode 2 Sv - 06Kh19N9T GOST 2246-70.
2. Coating of external surface -  
Primer VL-02, colorless (1),  
Primer AK-070, yellow (1),  
Enamel Kh-V-124, gray (4), IV OM 2  
VL-02 GOST 12707-77  
Primer AK-070 GOST 25718-83  
Enamel KhV-124 GOST 10144-89
3. Mark, Ш, Ч and stamp K as per AK 630, AK-630M TU 1.

GOST  
ГОСТ 14771-76-11-ИНН-2

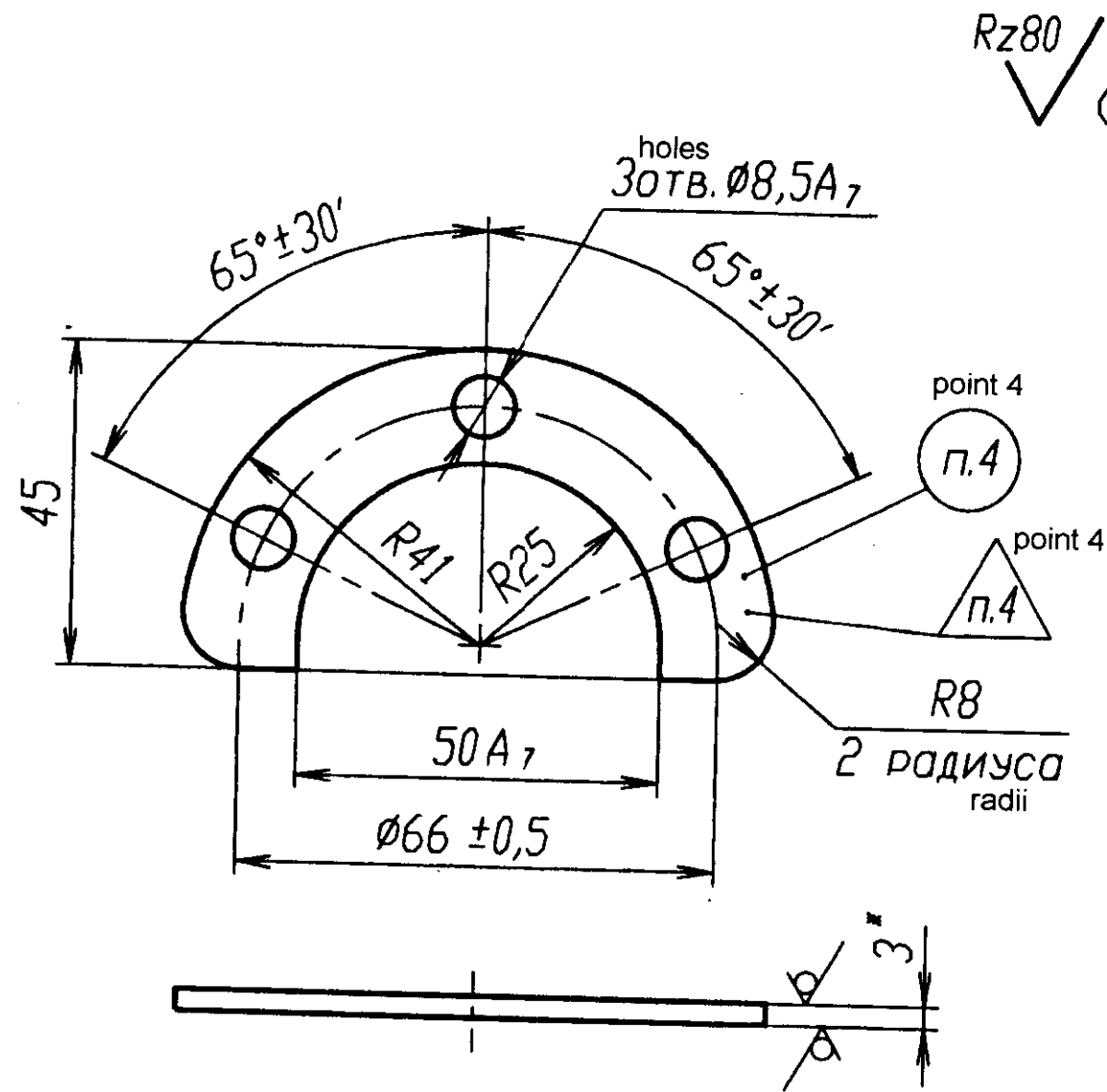
1. Сварка аргоно-дуговая с применением присадочной проволоки 2 Св-06Kh19N9T ГОСТ 2246-70.
2. Покрытие наружной поверхности -  
Грунтовка ВЛ-02, бесцветная (1),  
Грунтовка АК-070, желтая (1),  
Эмаль ХВ-124, серая (4), IV, ОМ2  
ВЛ-02 ГОСТ 12707-77  
Грунтовка АК-070 ГОСТ 25718-83  
Эмаль ХВ-124 ГОСТ 10144-89
3. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ 1.

AK-630 Sb 114-12 SB

AK-630		СБ114-12СБ	
Сварка		Кожух	
Сборочный чертеж		Сборочный чертеж	
Лист	Класс	Листов	Классификация
4	0,400	1:1	
Лист	Листов		
Sheet	Total Sheets		

AK-630 114-38

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



- 1.\* Reference dimensions.
2. Blunt sharp edges ~0.4 mm.
3. Tolerance for contour 0.5 mm.
4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

Amend.	Sheet	Doc. No.	Sign	Date

<b>AK-630 114-38</b>			
<b>Base plate</b>	Type	Weight	Scale
	A	0.040	1:1
	Sheet	Sheets 1	
Sheet <u>B - PN - 3 GOST 19903 - 74</u>			
12Cr18Ni10Ti - M3B GOST 5582 - 75			

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Format A4

AK-630 114-39

First use

Reference No.

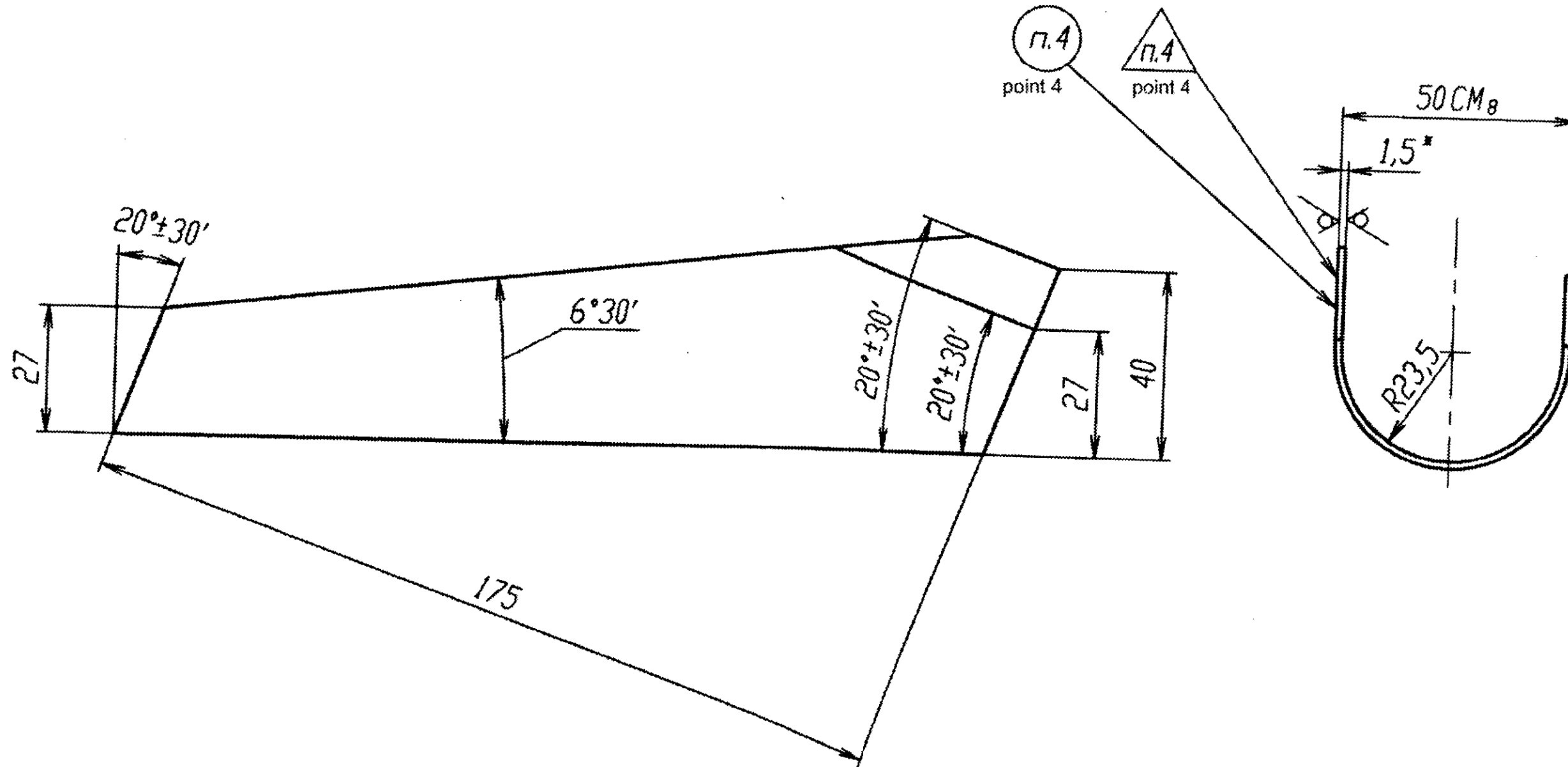
Sign and Date

Duplicate Inv. No.

Alternate Inv. No.

Sign and Date

Orig. inv. no.

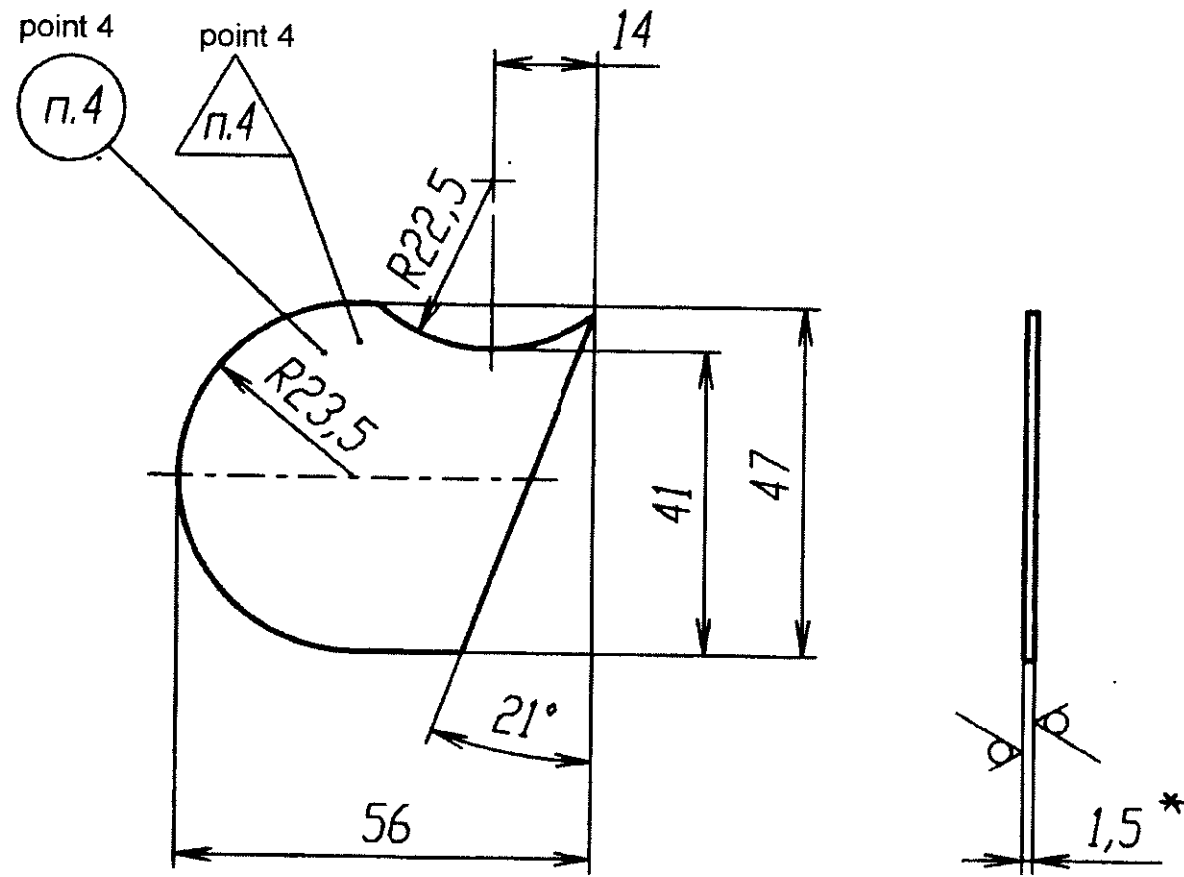


1. \* Reference dimensions.
2. Blunt sharp edges  $\sim 0.4$  mm.
3. Tolerance on contour  $-0.5$  mm.
4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 114-39			
Amend.	Sheet	Doc.No.	Sign	Date	Tray	Type	Weight	Scale
Developed by						A	0.225	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D						Sheet $\frac{BT - 0 - PN - 1.5GOST19904 - 90}{12Cr18Ni10T - M3aGOST5582 - 75}$		
Approved by								

AK-630 114-40

Rz80  
√ (√)



- 1.\* Reference dimensions.
- 2. Blunt sharp edges ~0.4 mm.
- 3. Tolerance for contour 0.5 mm.
- 4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

Approved OGMet	Sign and Date					Approved TC	Alternate Inv. No.	Dupl. Inv. No.	Sign and Date	Approved KTONI	Reference No.	Approved by shop	First use	
	Amend.	Sheet	Doc. No.	Sign	Date									
Orig. Inv. No.						AK-630 114-40					AK-630 114-40			
Developed by						Cover			Type	Weight	Scale			
Checked by									A	0.020	1:1			
Head of Q.C.D									Sheet		Sheets		1	
Design bureau chief						Sheet			B - PN - 1.5 GOST 19904 - 90					
Head of Q.C.D						Sheet			12Cr18Ni10Ti - M3a GOST 5582 - 75					
Approved by														

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Format A4



AK-630 114-41

First use

Reference No.

Sign and Date

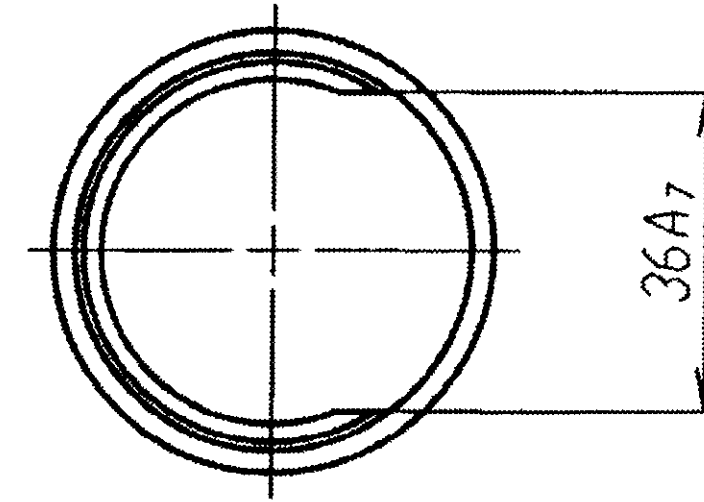
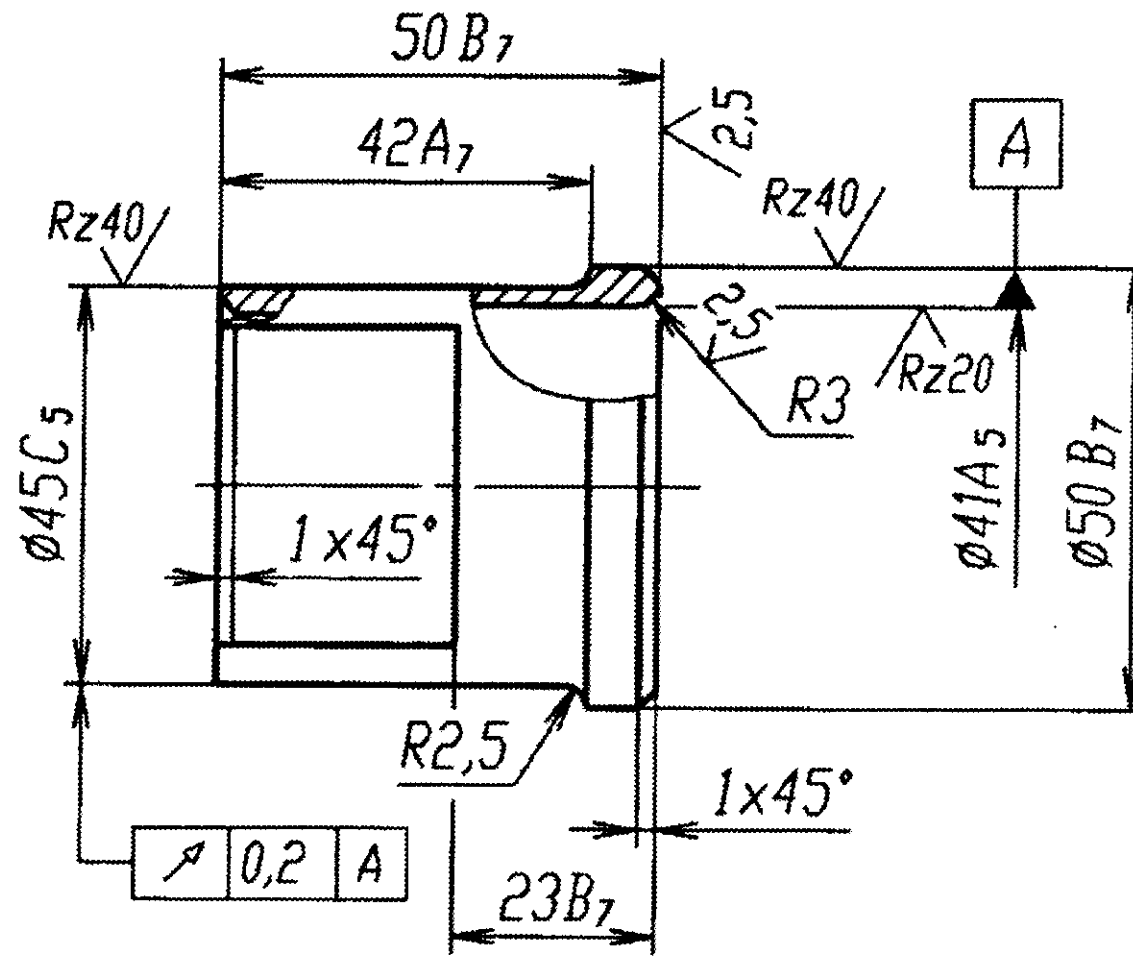
Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

1. Inner angles R~0.4 mm.
2. Blunt sharp edges ~0.4 mm.
3. Mark Ш, Ч and stamp K on tag.

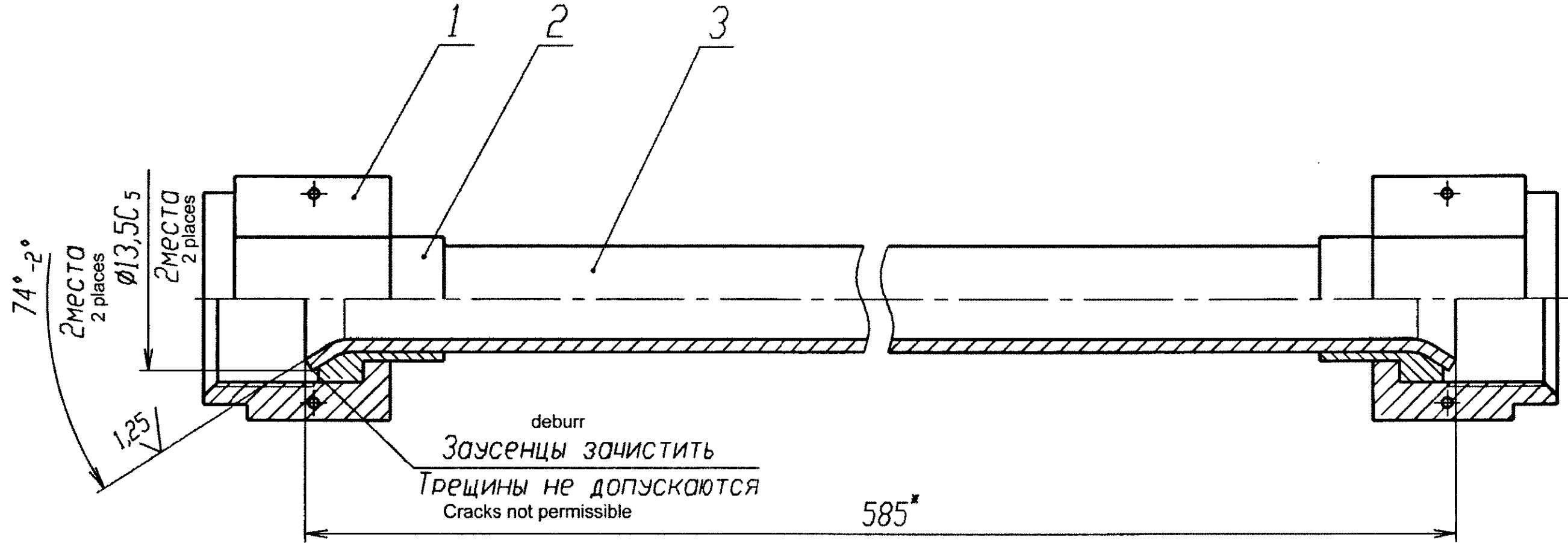


					AK-630 114-41			
Amend.	Sheet	Doc.No.	Sign	Date	Cylinder	Type	Weight	Scale
Developed by						A	0.100	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Steel 12Cr18Ni9Ti GOST 5632-72			
Approved by								



First use

Reference No.



Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

1. \* Reference dimension.
2. Test for strength with air pressure 80 atm. Carry out testing by loading three times and keeping for 10 minutes.  
Disturbance of strength and tightness of joints is not permissible.
3. Mark Ш, Ч and stamp K on tag.

					AK-630 Sb 114-13 SB			
Amend.	Sheet	Doc.No.	Sign	Date	<b>Pipeline Assembly drawing</b>	Type	Weight	Scale
Developed by						A	0.170	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by								

AK-630 114-32

First use

Reference No.

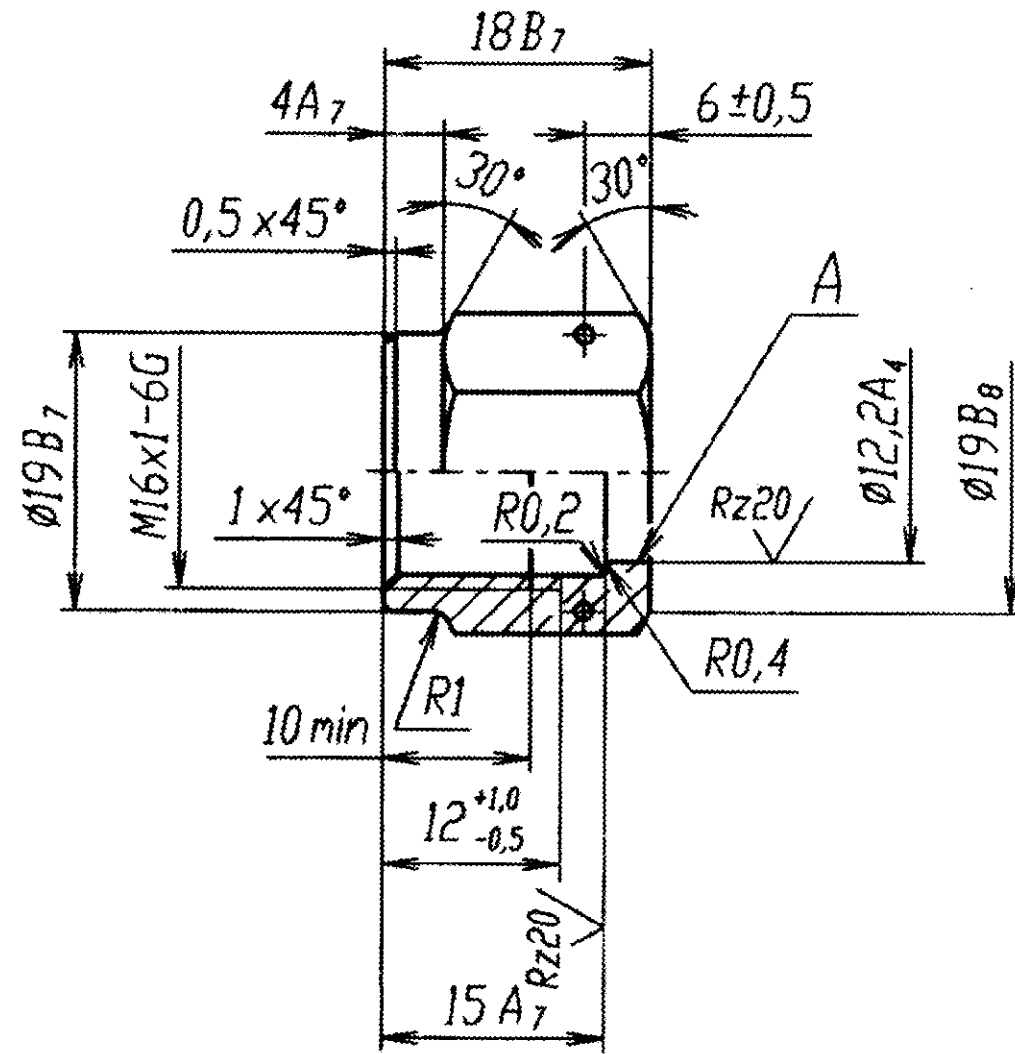
Sign and Date

Duplicate Inv. No.

Alternate Inv. No.

Sign and Date

Orig. inv. no.



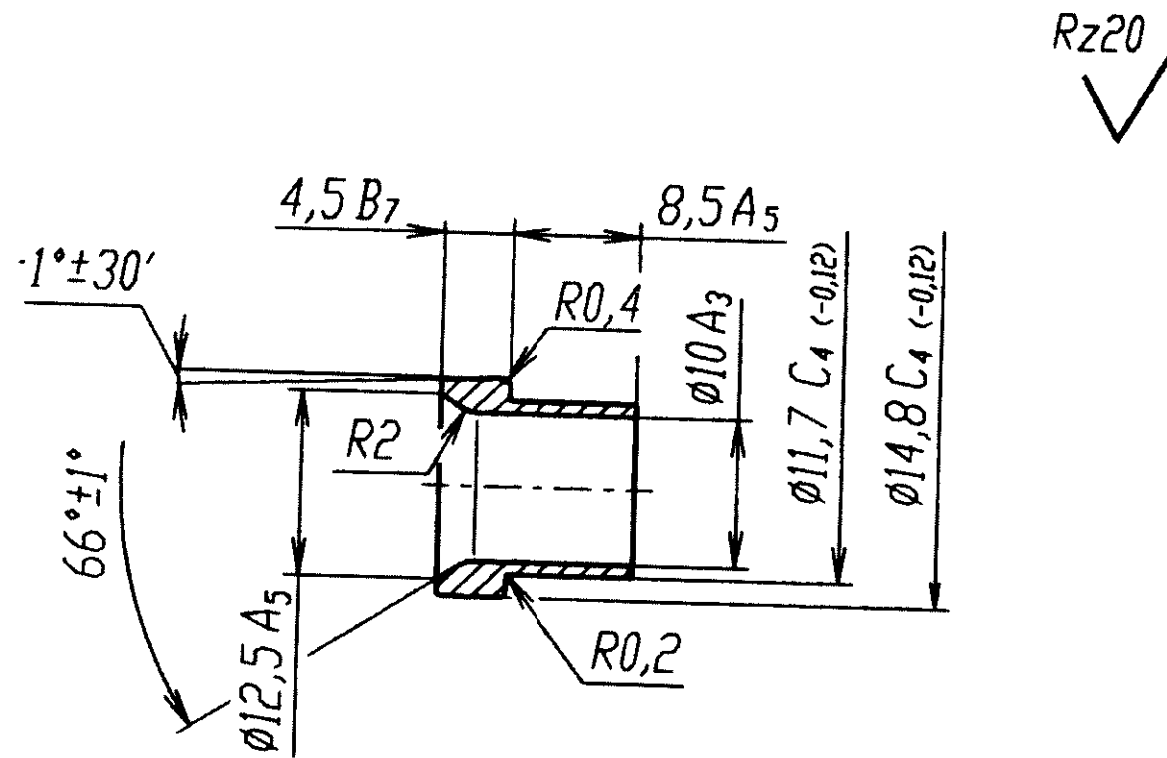
Rz40 ✓ (✓)

1. Substitute material- hexagon  $\frac{19 - 5GOST8560 - 78}{40GOST1051 - 73}$
2. 31..40.5 HRC<sub>E</sub>. Check 3..5% , but not less than 3 nos. from batch.
- 3.\* Reference dimensions.
4. Blunt sharp edges ~0.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.01 mm.
6. Mark Ш, Ч and stamp K, И on tag.

Designation	Coating
AK-630 114-32	Cd6.phos.
AK-630 -01	Without coating

					AK-630 114-32			
Amend.	Sheet	Doc.No.	Sign	Date	Coupling nut	Type	Weight	Scale
						A	0.025	2:1
Developed by					Hexagon $\frac{19 - 5GOST8560 - 78}{40Kh - T - VGOST1051 - 73}$	Sheet	Sheets	1
Checked by								
Head of Q.C.D								
Approved by								

AK-630 114-33



Rz20 ✓

Designation	Coating
AK-630 114-33	Kd12. pos
AK-630 -01	without coating

1. 38.5...44.5 HRC<sub>E</sub>. Check on specimen.
2. Blunt sharp edges ~0.2 mm.
3. Mark Ш, Ч and stamp K, И on tag.

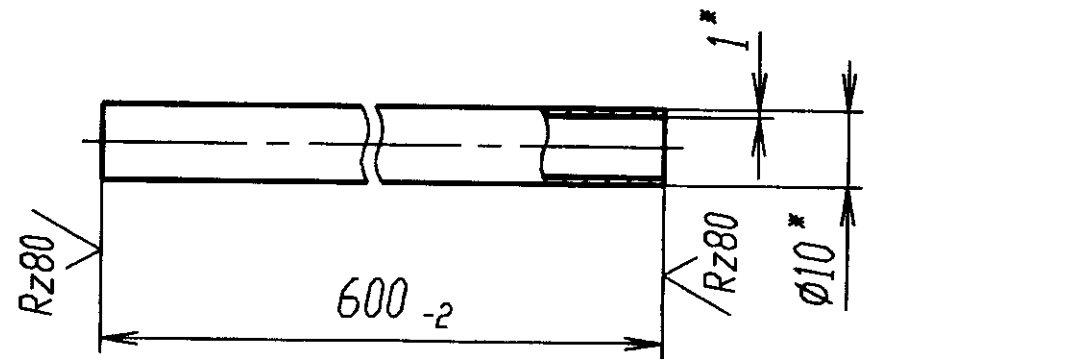
Approved OGMet	Approved TC	Approved KTONI	Approved by shop	Reference No.	First use
Orig. Inv. No.	Alternate Inv. No.	Dupl. Inv. No.	Sign and Date	Sign and Date	Sign and Date
Amend.	Sheet	Doc. No.	Sign	Date	Date
Developed by					
Checked by					
Head of Q.C.D					
Design bureau chief					
Head of Q.C.D					
Approved by					
<b>AK-630 114-33</b>					
<b>Nipple</b>			Type	Weight	Scale
			A	0.008	2:1
			Sheet	Sheets 1	
Steel 50 GOST 1050-88					

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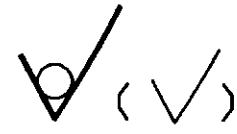
Format A4

AK-630 114-42

Approved OGMet	Sign and Date	Approved T. $\text{с}$	Approved KTONI	Approved by shop	First use
	Orig. Inv. No.	Alternate Inv. No.	Sign and Date	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				



- 1.\* Reference dimensions.
- 2. Blunt sharp edges  $\sim 0.4$  mm.
- 3. Coating Chem. Pass.
- 4. Mark Ш, Ч and stamp K on tag.



AK-630 114-42

Pipe

Pipe M2 M10x1  
GOST 617-90

Type	Weight	Scale
A	0.168	1:1
Sheet	Sheets 1	

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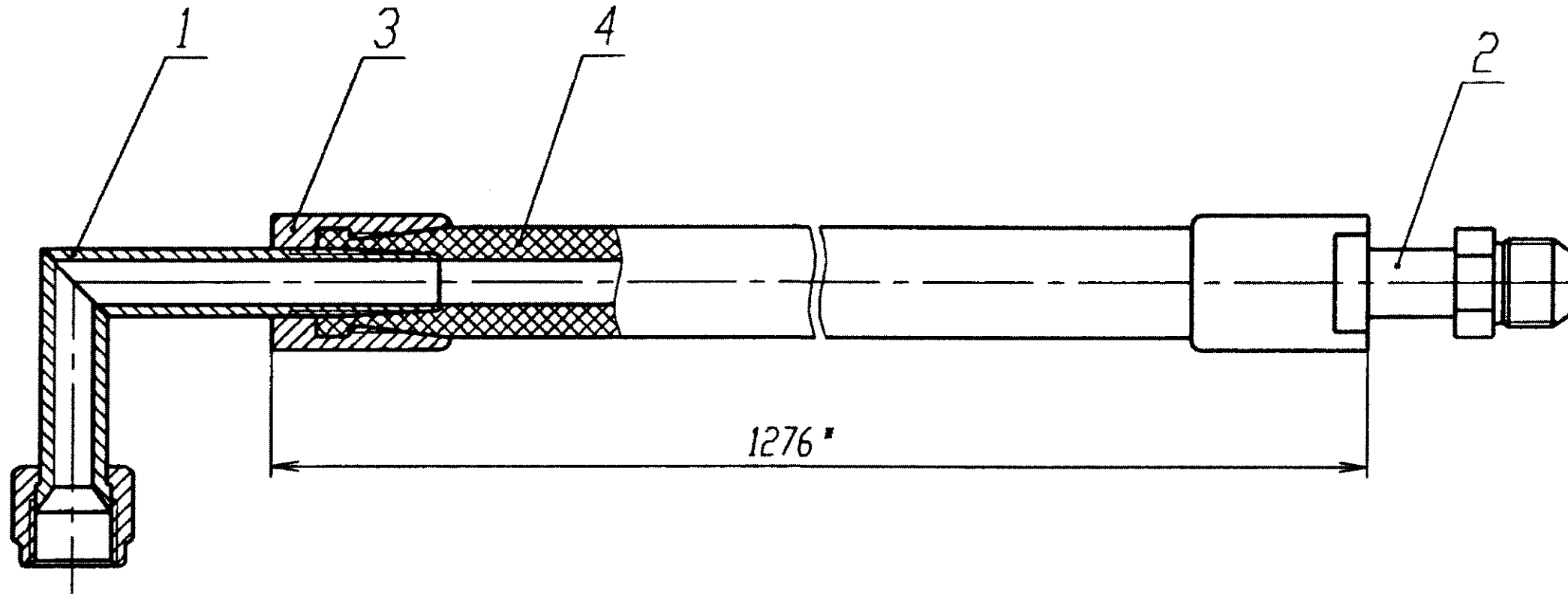
Format A4

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
						<u>Documents</u>		
Reference No.	<del>A3</del>			AK-630 Sb 114-14 SB	Assembly drawing			
					<u>Assembly units</u>			
	A4		1	AK-630 Sb114-32	Elbow	1		
					<u>Components</u>			
	A3		2	AK-630 114-43	Nipple	1		
	A3		3	AK-630 114-91	Coupling	2		
					<u>Materials</u>			
Sign and Date			4		Hose 5U8-85	1	L=1260 mm	
					TU 38.005-1515-92			
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date					<b>AK-630 Sb 114-14</b>			
	Amend.	Sheet	Doc. No.	Sign				Date
Orig. Inv. No.	Developed by				<b>Hose</b>	Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D							
	Approved by							

AK-630 Sb 114-14 SB

First use

Reference No.



Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

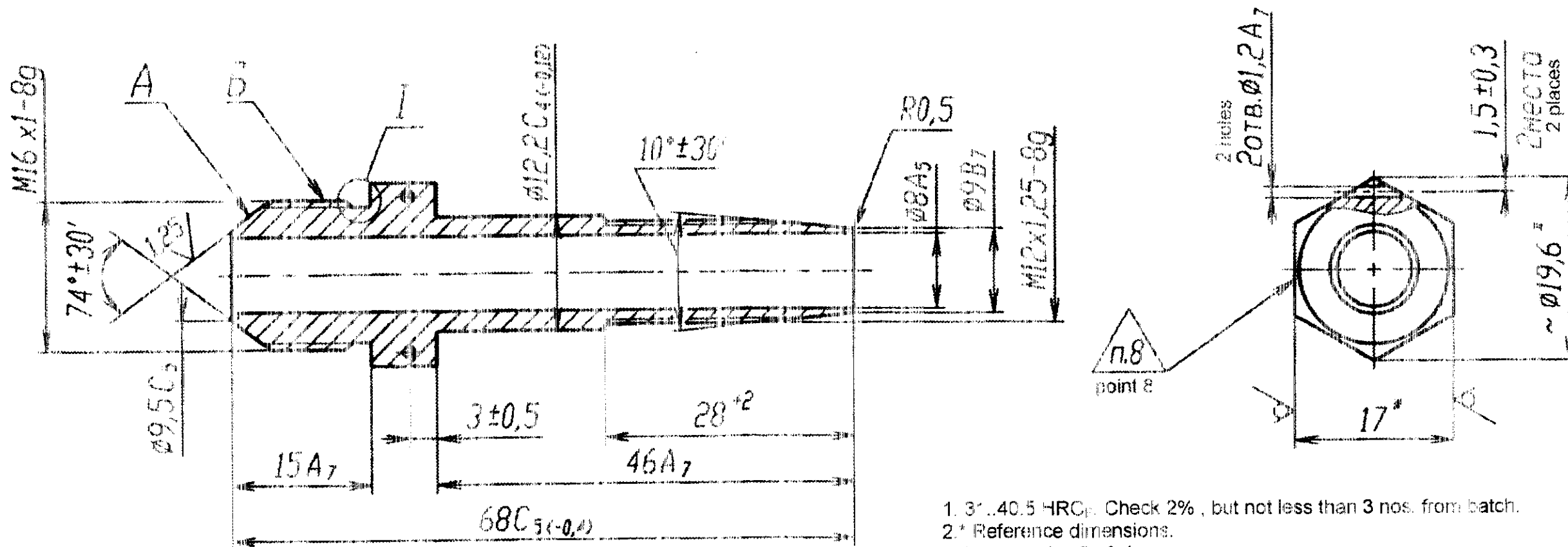
1. \* Reference dimension.
2. Test for strength with air pressure 80 atm. Carry out testing by loading three times and keeping for 10 minutes.  
Disturbance of strength and tightness of joints is not permissible.
3. Check quality of joints on one hose from the batch consisting not less than 5 nos. by cutting the hose to not more than 50 mm from side of component pos.2, further use the shortened hose in article.
4. Mark Ш , Ч and stamp K on tag.

					AK-630 Sb 114-14 SB			
Amend.	Sheet	Doc.No.	Sign	Date	<b>Hose Assembly drawing</b>	Type	Weight	Scale
Developed by						A	0.500	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by								

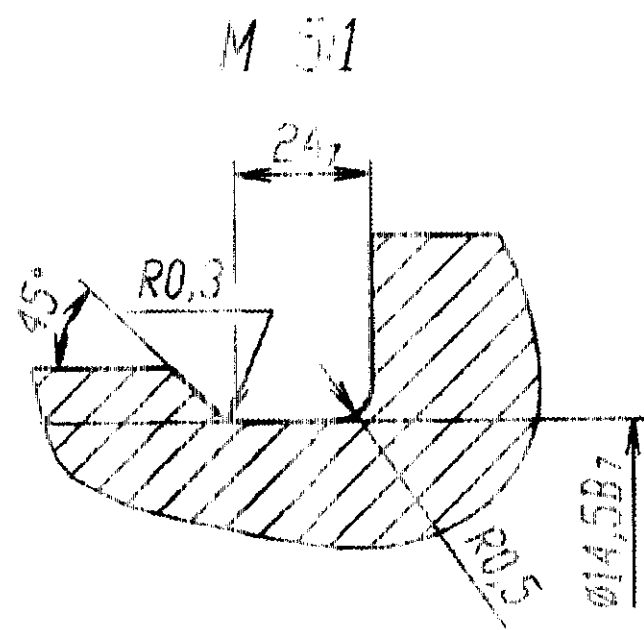


AK-630 114-43

Rz40 ✓ (✓)



1. 31..40.5 HRC<sub>p</sub>. Check 2% , but not less than 3 nos. from batch.
2. \* Reference dimensions.
3. Inner angles F<sub>i</sub>-0.4 mm.
4. Eliminate sharp edges ~0.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.05 mm.
6. Coating Cd6.phos.Oil.  
It is permissible to avoid cadmium plating of inner surfaces
7. Mark Ш 4 and stamp K on tag.
8. Stamp И as per AK-630, AK-630M TU I.



					AK-630 114-43			
Amend.	Sheet	Doc.No.	Sign	Date	Nipple	Type	Weight	Scale
Developed by						A	0.035	2:1
Checked by						Sheet	Sheets 1	
Head of D.C.D					Hexagon	17 - 5GOST73560 - 78		
Approved by					40Kh - T - VGOST105 - 73			

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

First use

Reference No.

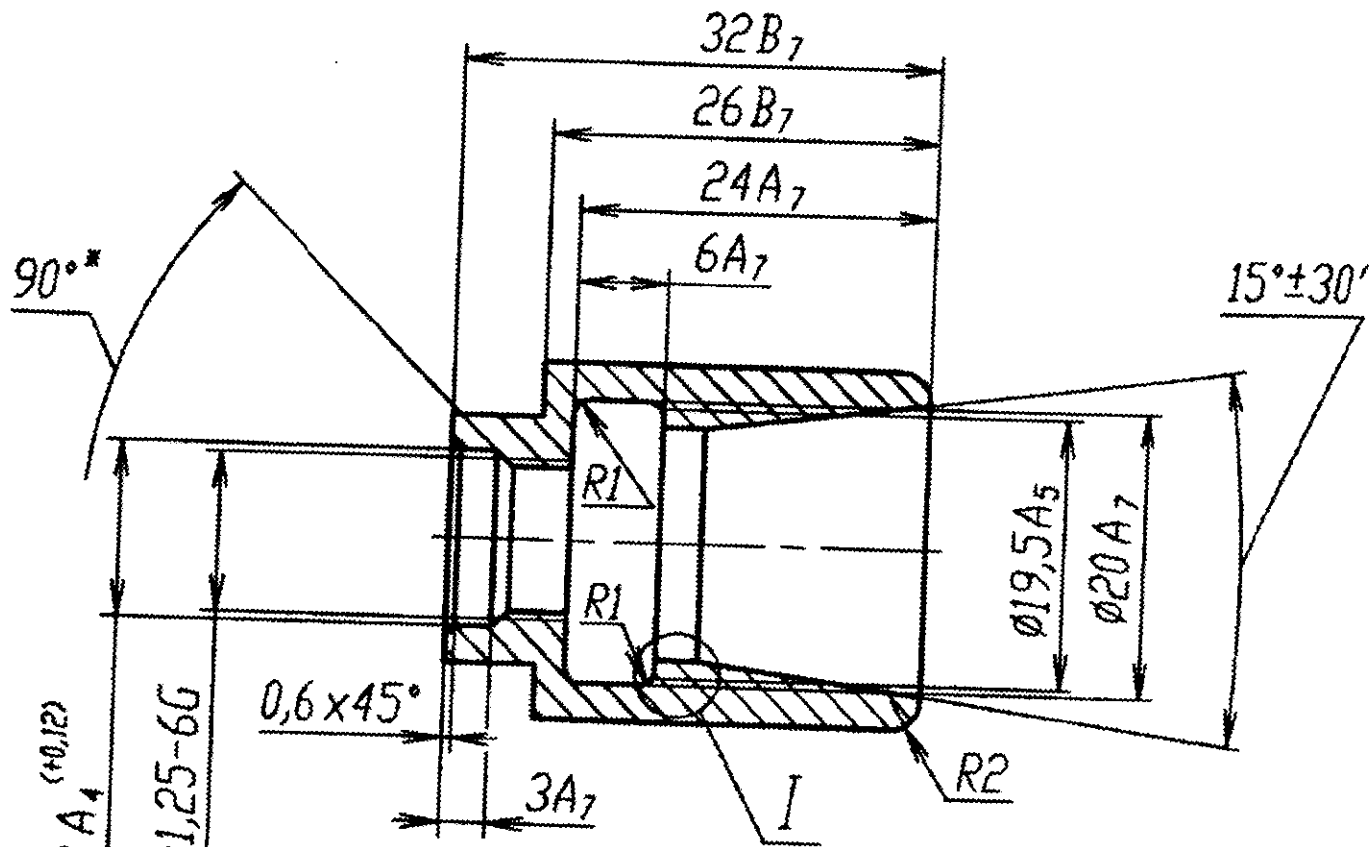
Sign and Date

Duplicate Inv. No

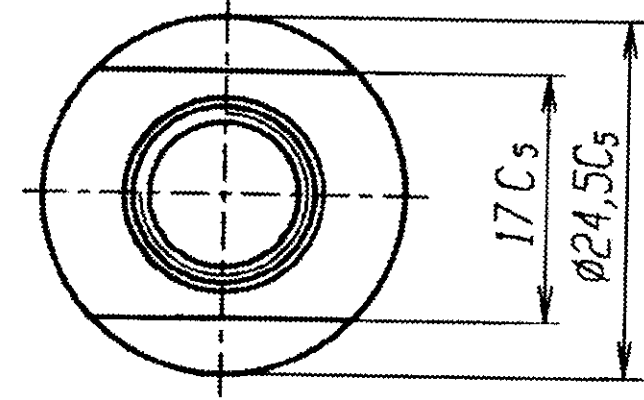
Alternate Inv. No

Sign and Date

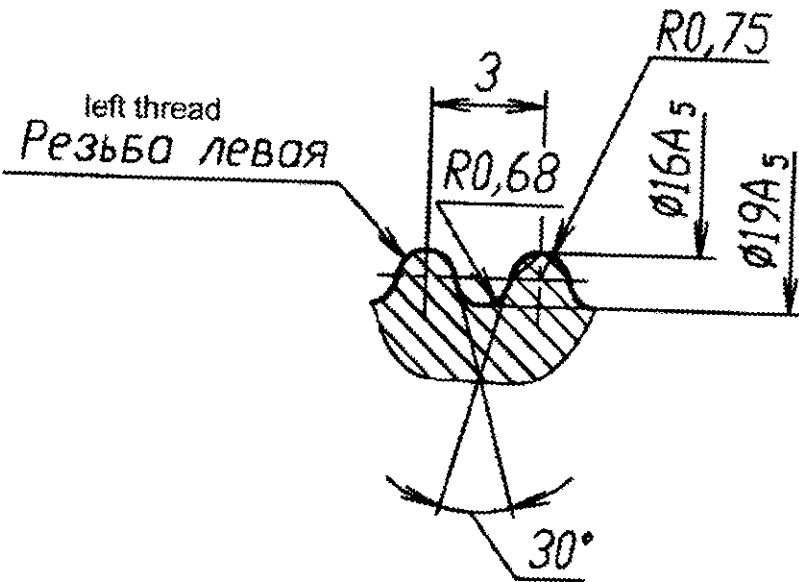
Orig. inv. no.



Rz40 ✓ (✓)



I  
M(5:1)



1. Substitute material- wheel  $\frac{25 - h1GOST7417 - 75}{12Cr18Ni10Ti - VTU14 - 1 - 3957 - 85}$
2. \* Dimensions ensured by tool.
3. Inner angles R~0.4 mm.
4. Blunt sharp edges ~0.6 mm.
5. Coating Ep.
6. External view of component as per test specimen.
6. Mark Ш, Ч and stamp K on tag.

					AK-630 114-91			
Amend.	Sheet	Doc.No.	Sign	Date	Coupling	Type	Weight	Scale
Developed by						A	0.050	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Wheel	$\frac{25 - VGOST2590 - 88}{12Cr18Ni9Ti - B - TGOST5949 - 75}$		
Approved by								

First use		Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
Reference No.						<u>Documents</u>		
	A3			AK-630 Sb 114-15 SB	Assembly drawing			
						<u>Components</u>		
	A3	✓	✓	AK-630 114-32	Coupling nut	2		
	A4	✓	✓	AK-630 114-33	Nipple	2		
	A4	✓	✓	AK-630 114-44	Pipe	1		
Sign and Date								
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date								
	Amend.	Sheet	Doc. No.	Sign	Date	<b>AK-630 Sb 114-15</b>		
	Developed by							
	Checked by					Type	Sheet	Sheets
	Head of Q.C.D					A		1
Approved by					<b>Hose</b>			
Orig. Inv. No.								

First use

Reference No.

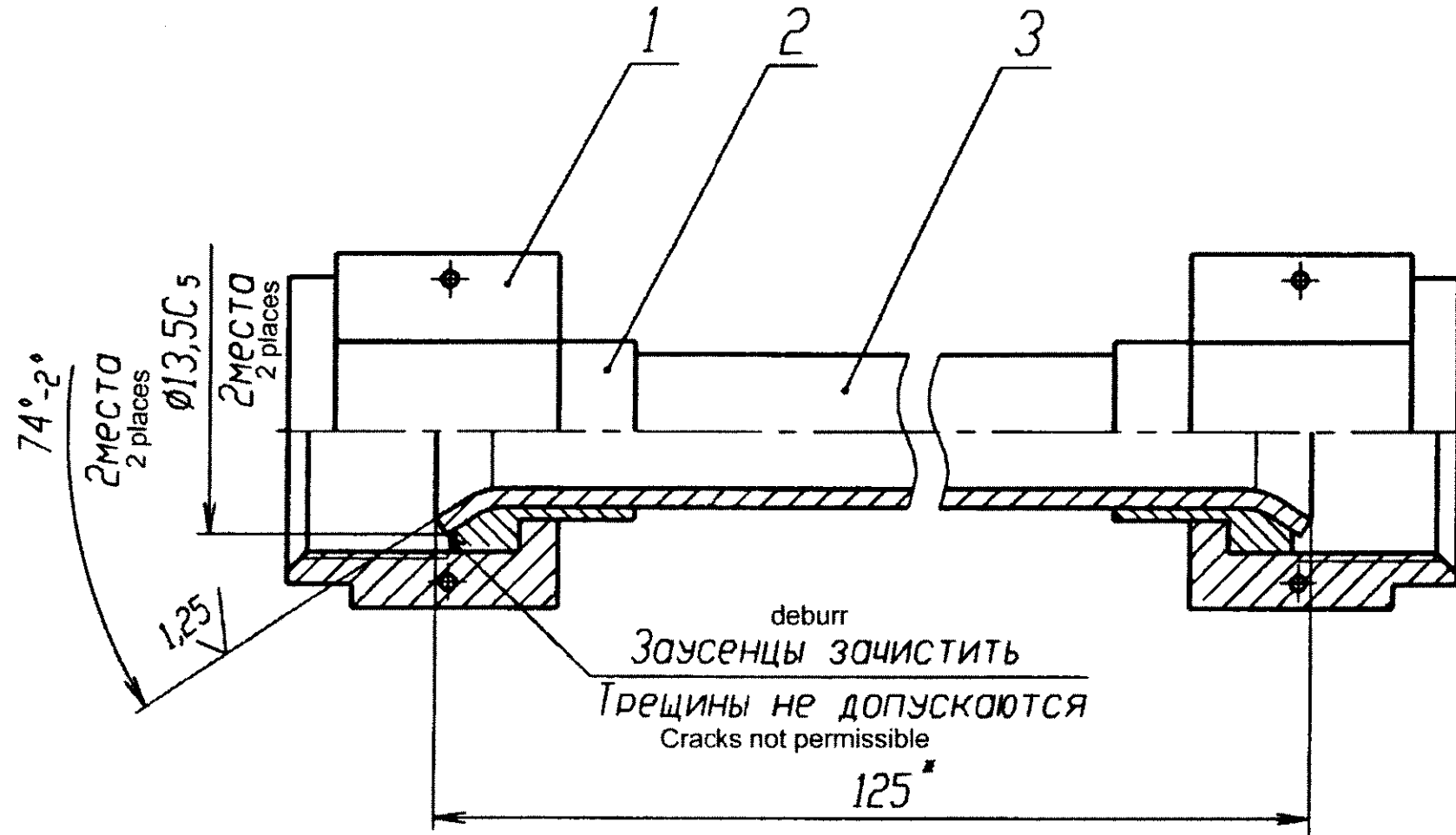
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



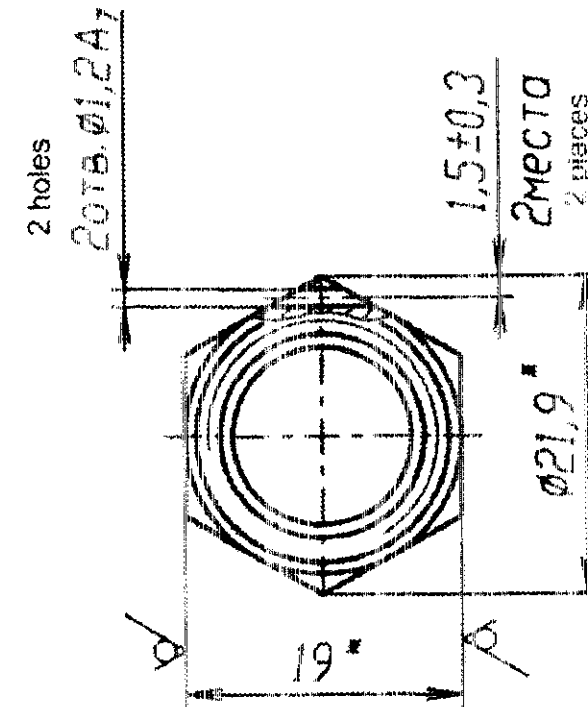
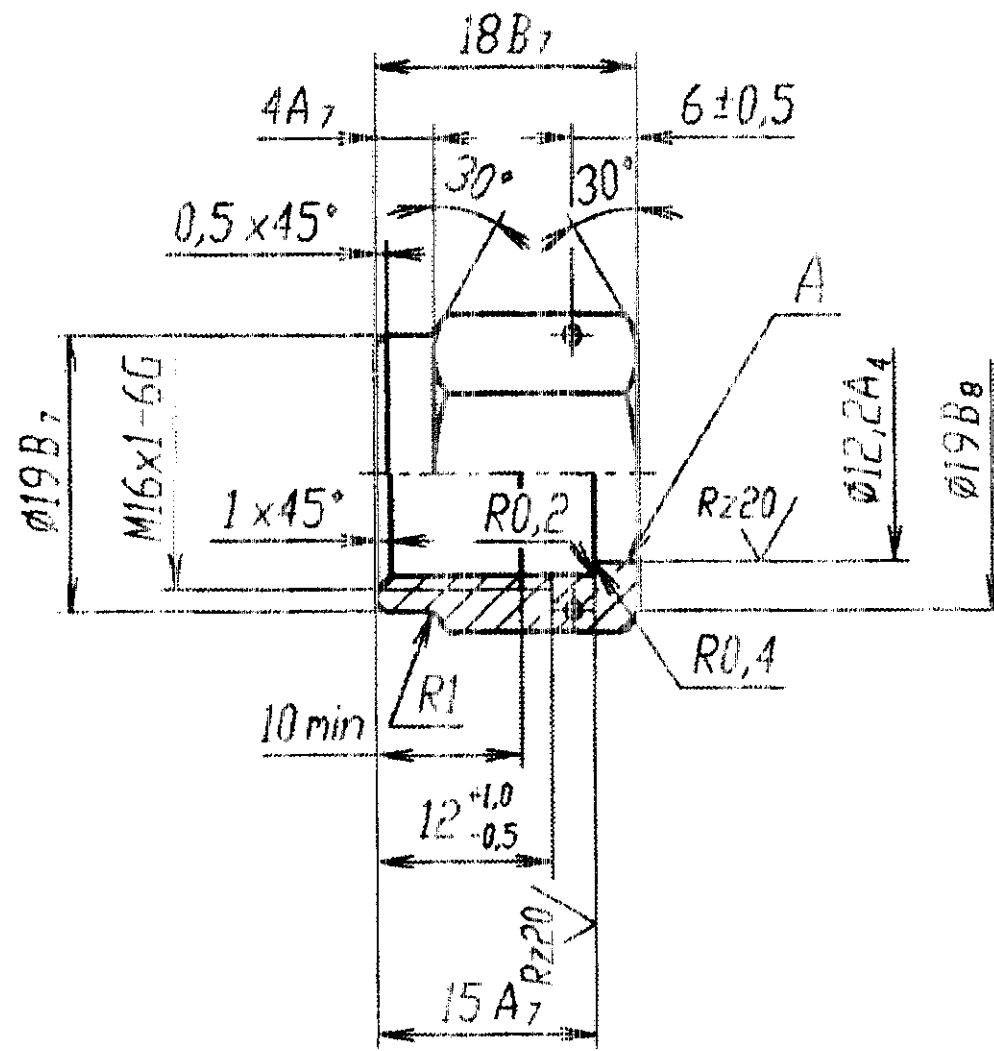
1. \* Reference dimension.
2. Test for strength with air pressure 80 atm. Carry out testing by loading three times and keeping for 10 minutes.  
Disturbance of strength and tightness of joints is not permissible.
3. Mark Ш, Ч and stamp K on tag.

					AK-630 Sb 114-15 SB			
Amend.	Sheet	Doc.No.	Sign	Date	<b>Pipeline Assembly drawing</b>	Type	Weight	Scale
Developed by						A	0.106	2:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by								

AK-630 114-32

First use

Reference No.



Rz40 ✓ (✓)

Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

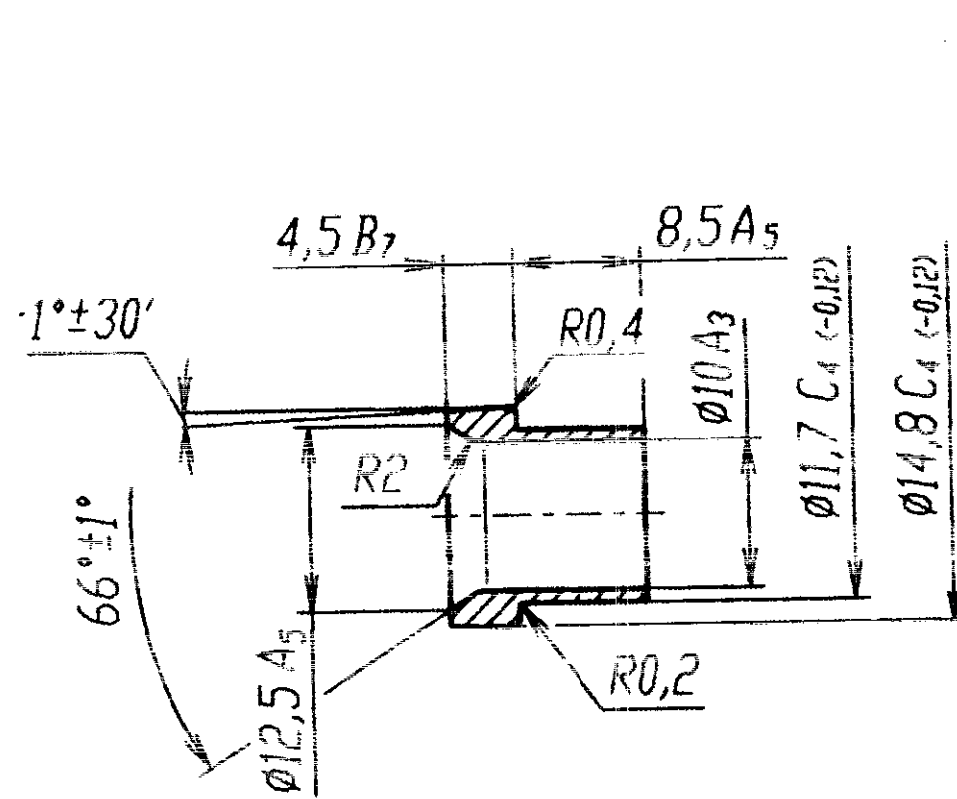
1. Substitute material- hexagon  $\frac{19 - 5GOST8560 - 78}{40GOST1051 - 73}$
2. 31..40.5 HRC<sub>E</sub>. Check 3..5% , but not less than 3 nos. from batch.
3. \* Reference dimensions
4. Blunt sharp edges ~0.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.01 mm.
6. Mark Ш, Ч and stamp K, И on tag.

Designation	Coating
AK-630 114-32	Cd6.phos.
AK-630 -01	Without coating

					AK-630 114-32			
Amend.	Sheet	Doc.No.	Sign	Date	Coupling nut	Type	Weight	Scale
							A	0.025
Developed by					Hexagon $\frac{19 - 5GOST8560 - 78}{40Kh - T - VGOST1051 - 73}$	Sheet	Sheets	1
Checked by								
Lead of Q.C.D								
Approved by								

AK-630 114-33

Approved by shop  
Reference No.  
Approved KTONI  
Sign and Date  
Approved TCsp  
Dupl. Inv. No.  
Sign and Date  
Approved OGM/et  
Orig. Inv. No.  
Sign and Date



Designation	Coating
AK-630 114-33	Kd12. pos
AK-630 -01	without coating

1. 38.5...44.5 HRC<sub>E</sub>. Check on specimen.
2. Blunt sharp edges  $\sim 0.2$  mm.
3. Mark Ш, Ч and stamp К, И on tag.

AK-630 114-33				
Amend.	Sheet	Doc. No.	Sign	Date
<b>Nipple</b>				
Steel 50 GOST 1050-88				
			Type	Weight
			A	0.008
			Scale	2:1
			Sheet	Sheets 1

Copied by

Format A4

AK-630 114-44

Approved by shop	Approved KTONI	Approved TCOB	Approved OCM/et		
Reference No.	Sign and Date	Altermate Inv. No. Dupl. Inv. No.	Sign and Date	Sign and Date	Sign and Date
First use					

1. \* Reference dimensions.  
 2. Blunt sharp edges ~0.4 mm.  
 3. Coating Chem. Pass  
 4. Mark Ш, Ч and stamp K on tag.

AK-630 114-44										
Amend.	Sheet	Doc. No.	Sign	Date	Type	Weight	Scale			
Developed by					A	0.040	1:1			
Checked by					Sheet		Sheets 1			
Head of Q.C.D					Pipe					
Design bureau chief					Pipe M2 M10x1					
Head of Q.C.D					GOST 617-90					
Approved by										

Copied by

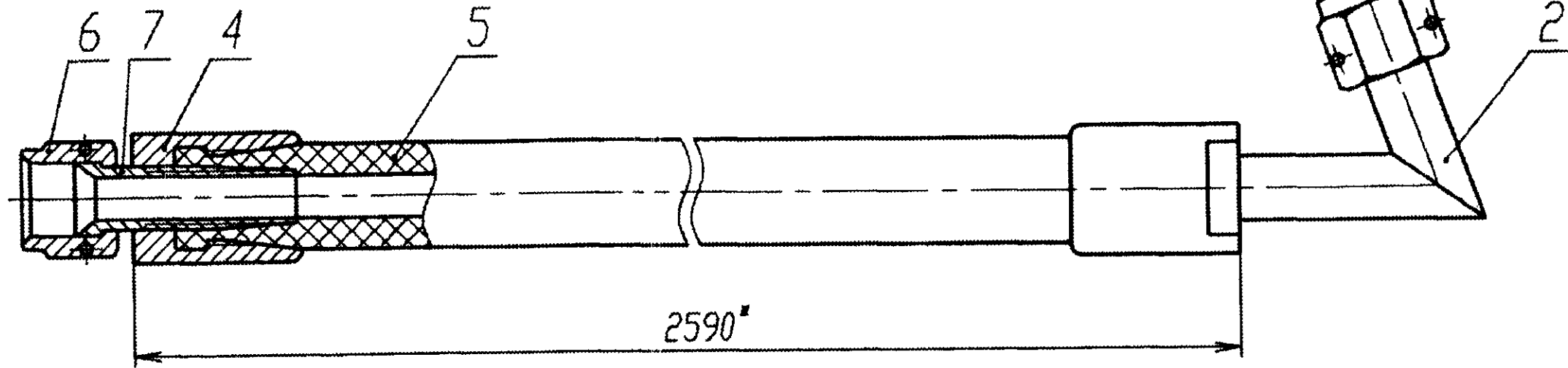
Export A4

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
						<u>Documents</u>		
Reference No.	A3			AK-630 Sb 114-16 SB	Assembly drawing			
					<u>Assembly units</u>			
	A4		2	AK-630 Sb114-34	Elbow	1		
					<u>Components</u>			
	A3		3	AK-630 114-45	Nipple		max.1	
	A3		4	AK-630 114-91	Coupling	2	max.4	
	A3		6	AK-630 114-32	Coupling nut	1		
	A4		7	AK-630 114-85	Nipple	1		
Sign and Date					<u>Materials</u>			
			5		Hose 5U8-85	1	L=850mm	
Dupl. Inv. No.					TU 38.005-1515-92		L=1670mm	
Alternate Inv. No.								
Sign and Date					<b>AK-630 Sb 114-16</b>			
	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							
<b>Hose</b>								

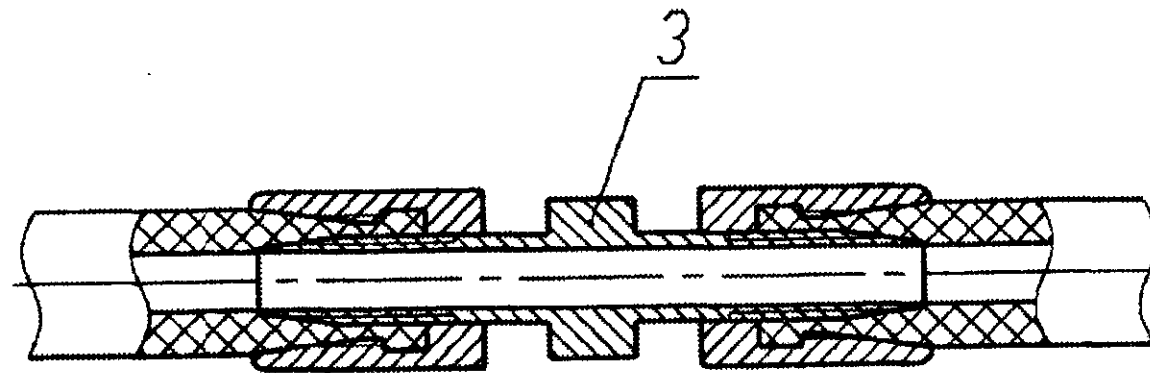


First use

Reference No.



Option for expanding hoses  
Вариант сращивания рукавов



1. \* Reference dimension.
2. It is permissible to expand two pieces of hoses , one of which of size 1670 mm, by mounting additional component pos.3 and increasing no. of components pos.4.
3. Test for strength with air pressure 80 atm. Carry out testing by loading three times and keeping for 10 minutes.  
Disturbance of strength and tightness of joints is not permissible.
4. Check quality of joints on one hose from the batch consisting not less than 5 nos. by cutting the hose to not more than 50 mm from side of component pos.7, further use the shortened hose in article.
5. Mark Ш , Ч and stamp K on tag.

Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

					AK-630 Sb 114-16 SB			
Amend.	Sheet	Doc.No.	Sign	Date	<b>Hose Assembly drawing</b>	Type	Weight	Scale
Developed by						A	0.750	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by								

AK-630 114-45

First use

Reference No.

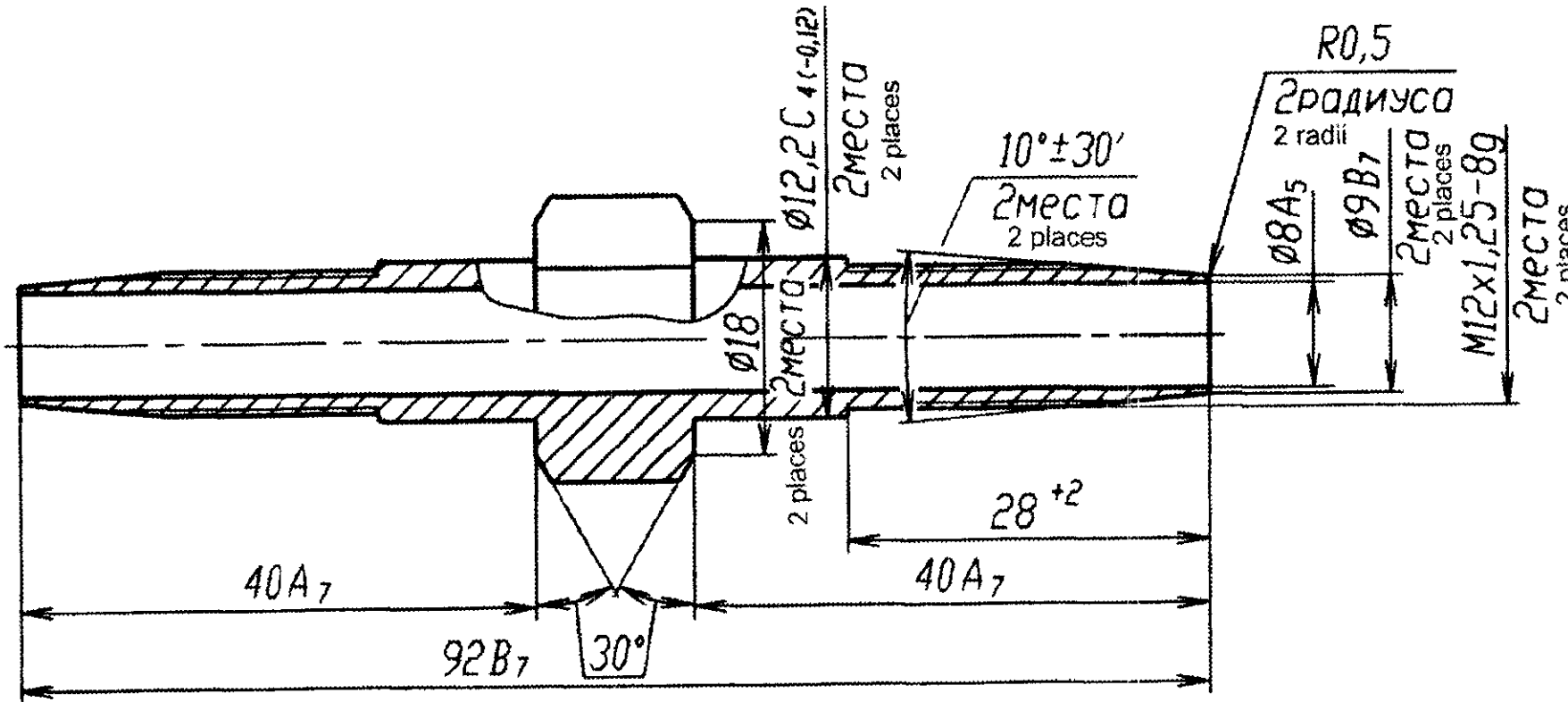
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz40  
✓ (✓)

1. \* Reference dimensions.
2. Inner angles R~0.4 mm.
3. Blunt sharp edges ~0.4 mm.
4. Coating Cd6. phos. Oil. It is permissible to avoid cadmium plating of inner surfaces.
5. Mark Ш, Ч and stamp K, on tag.

					AK-630 114-45			
Amend.	Sheet	Doc.No.	Sign	Date	Nipple	Type	Weight	Scale
Developed by						A	0.055	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D						Hexagon 19 - 5GOST8560 - 78		
Approved by					40Kh - T - VGOST1051 - 73			

First use

Reference No.

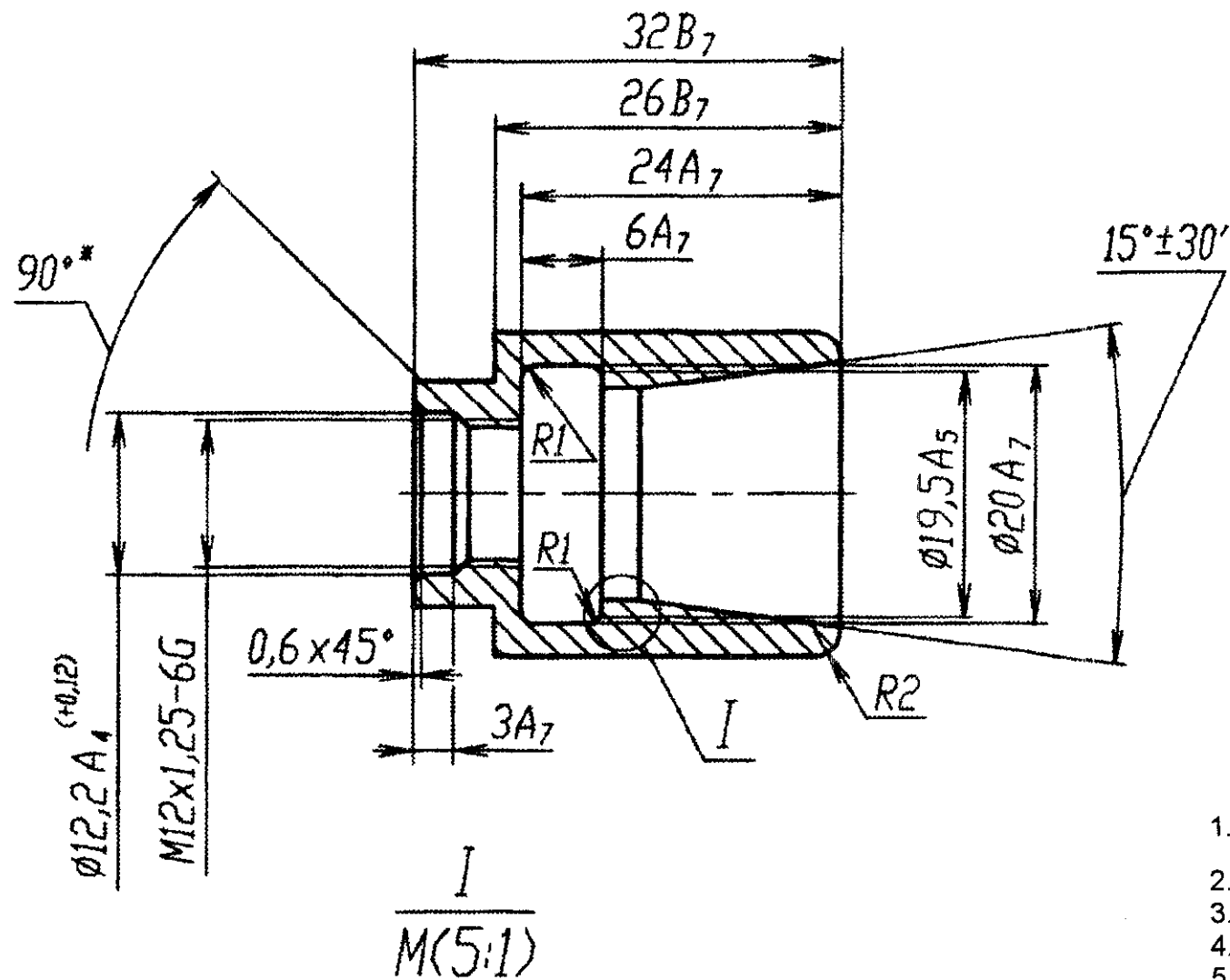
Sign and Date

Duplicate Inv. No

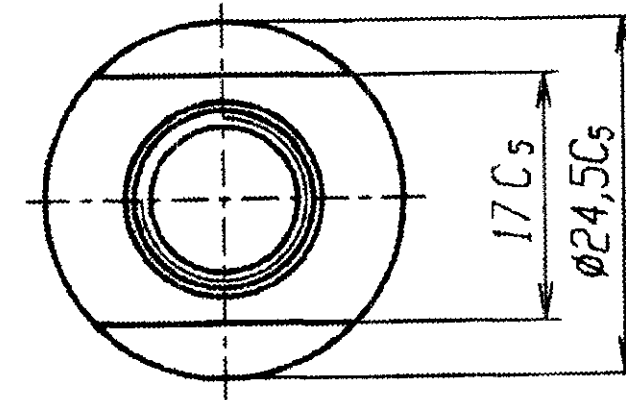
Alternate Inv. No

Sign and Date

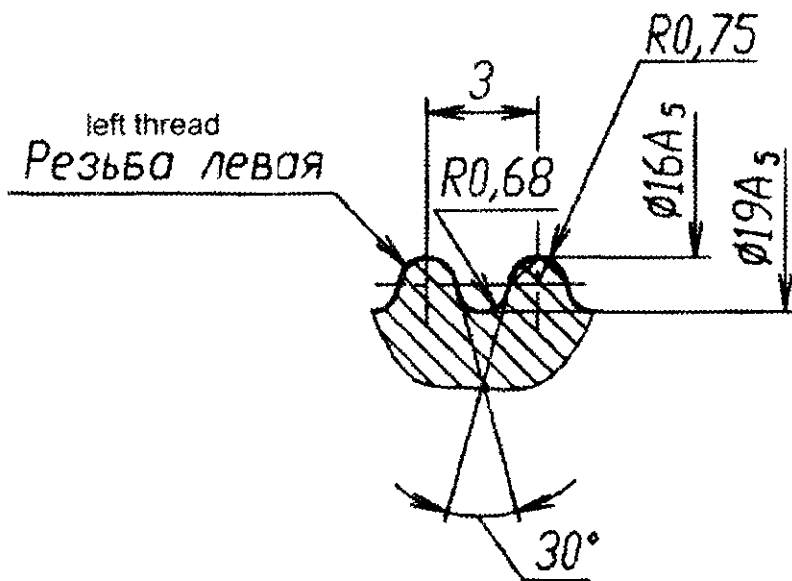
Orig. inv. no.



Rz40 ✓ (✓)



1. Substitute material- wheel  $\frac{25 - h1GOST7417 - 75}{12Cr18Ni10Ti - VTU14 - 1 - 3957 - 85}$
2. \* Dimensions ensured by tool.
3. Inner angles R~0.4 mm.
4. Blunt sharp edges ~0.6 mm.
5. Coating Ep.
6. External view of component as per test specimen.
6. Mark Ш, Ч and stamp K on tag.



					AK-630 114-91			
Amend.	Sheet	Doc.No.	Sign	Date	Coupling	Type	Weight	Scale
Developed by						A	0.050	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Wheel	$\frac{25 - VGOST2590 - 88}{12Cr18Ni9Ti - B - TGOST5949 - 75}$		
Approved by								

AK-630 114-32

First use

Reference No.

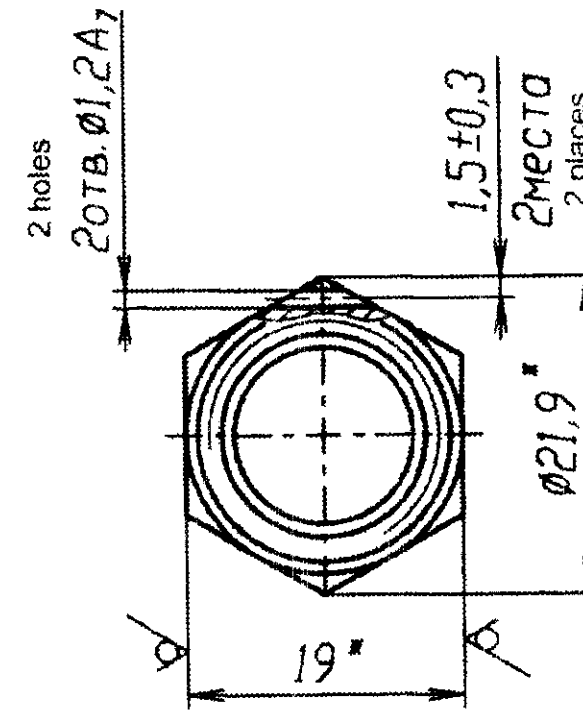
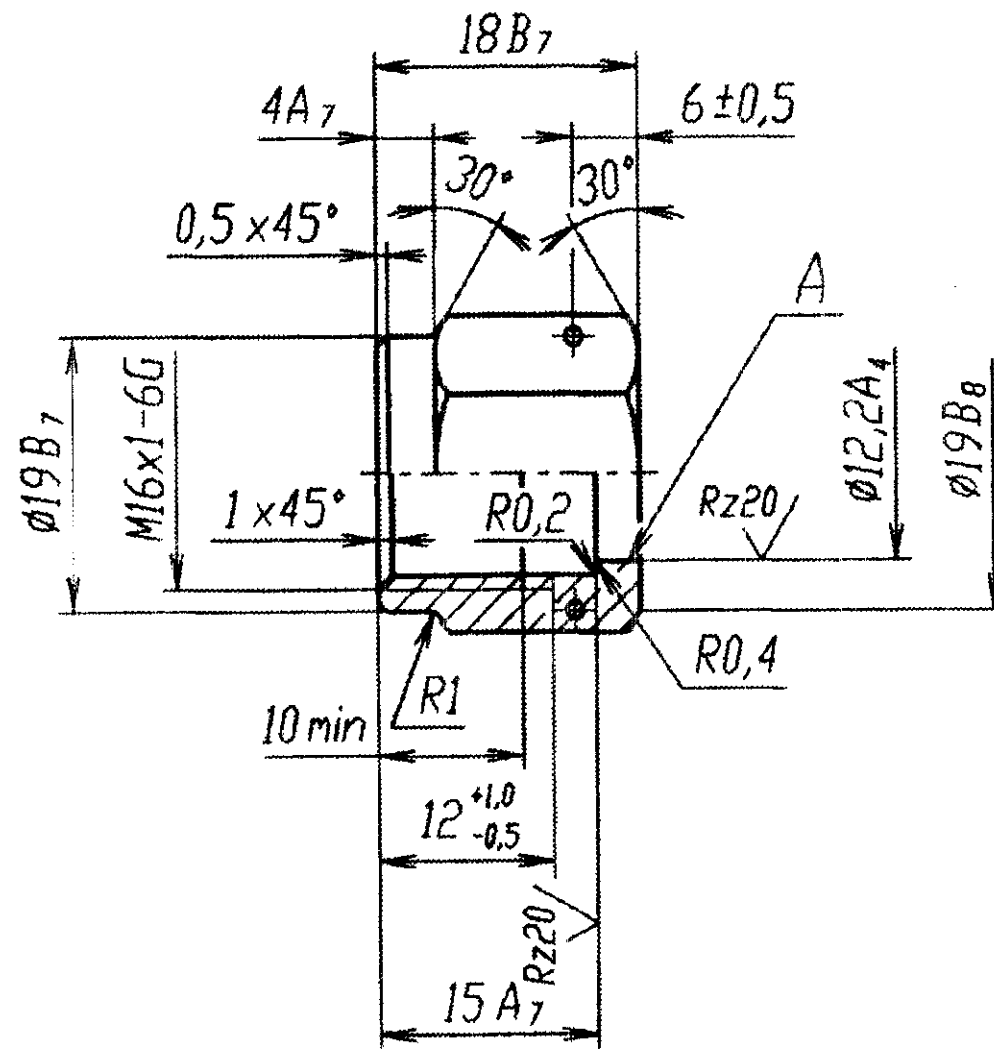
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz40 ✓ (✓)

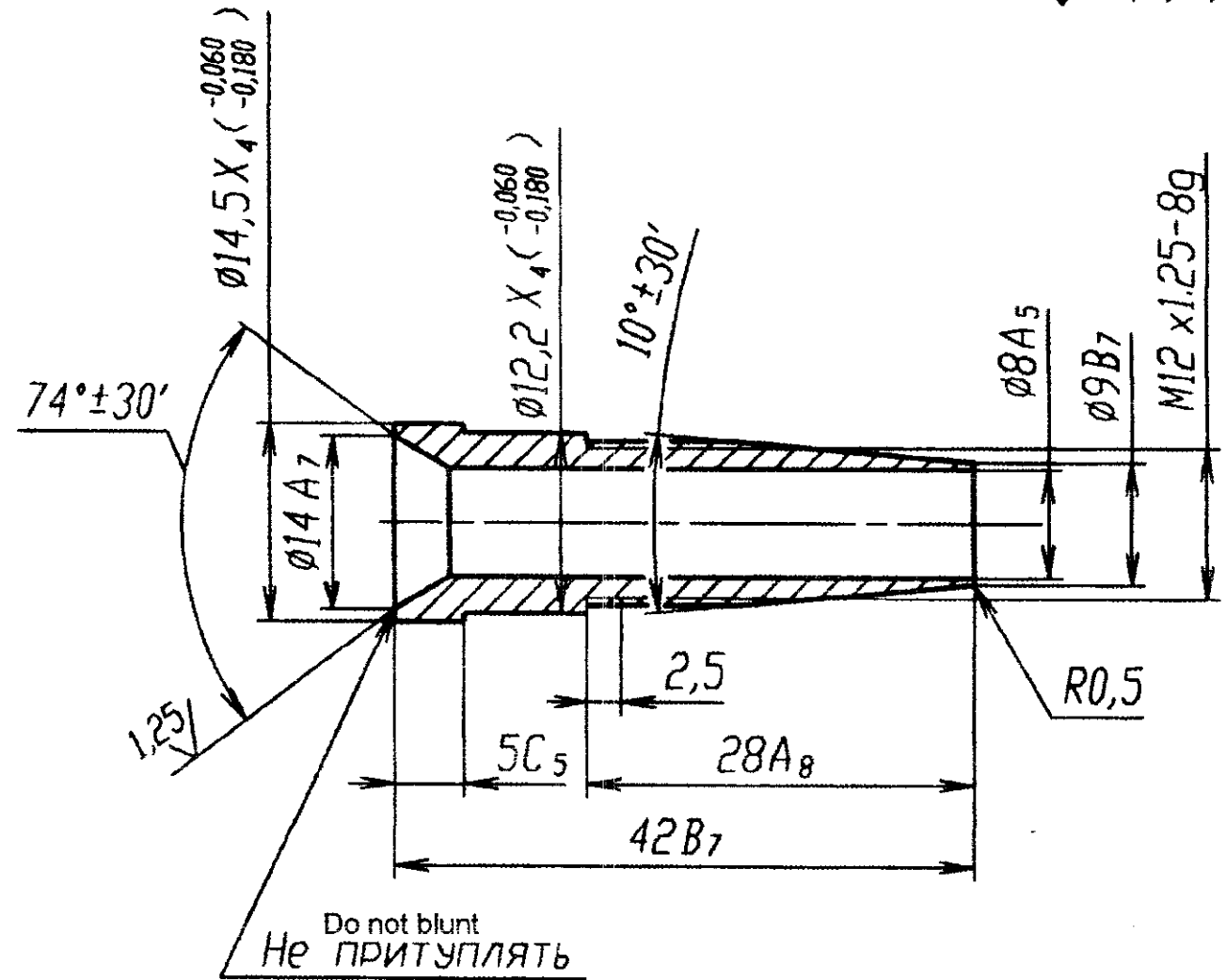
1. Substitute material- hexagon  $\frac{19 - 5GOST8560 - 78}{40GOST1051 - 73}$
2. 31..40.5 HRC<sub>E</sub>. Check 3..5% , but not less than 3 nos. from batch.
- 3.\* Reference dimensions.
4. Blunt sharp edges ~0.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.01 mm.
6. Mark Ш, Ч and stamp K, И on tag.

Designation	Coating
AK-630 114-32	Cd6.phos.
AK-630 -01	Without coating

					AK-630 114-32			
Amend.	Sheet	Doc.No.	Sign	Date	Coupling nut	Type	Weight	Scale
						A	0.025	2:1
Developed by					Hexagon $\frac{19 - 5GOST8560 - 78}{40Kh - T - VGOST1051 - 73}$	Sheet	Sheets	1
Checked by								
Head of Q.C.D								
Approved by								

AK-630 114-85

Rz40  
✓ (✓)



1. Inner angles  $R \sim 0.4$  mm.
2. Blunt sharp edges  $\sim 0.4$  mm.
3. Mark Ш, Ч and stamp K on tag.

Approved OGMet		Approved TOSO		Approved KTONI		Approved by shop		First use	
Orig. Inv. No.		Alternate Inv. No.		Dupl. Inv. No.		Sign and Date		Reference No.	
Sign and Date		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									
Copied by									
Format A4									
<b>AK-630 114-85</b>									
<b>Nipple</b>						Type	Weight	Scale	
						A	0.029	2:1	
						Sheet		Sheets 1	
						Steel 12Cr18Ni9Ti GOST 5632-72			

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A3		✓	AK-630 Sb114-34 SB	Assembly drawing			
					<u>Components</u>			
	A3		✓ 1	AK-630 114-32-01	Coupling nut	1		
A4		✓ 2	AK-630 114-69	Nipple	1			
A3		✓ 3	AK-630 114-70	End cap	1			
Sign and Date	<b>AK-630 Sb 114-34</b>							
	Amend.	Sheet	Doc. No.	Sign	Date			
Orig. Inv. No.	Developed by				<b>Elbow</b>	Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D							
	Approved by							
Sign and Date								
Dupl. Inv. No.								
Alternate Inv. No.								

AK-630 Sb114-34 SB

First use

Reference No.

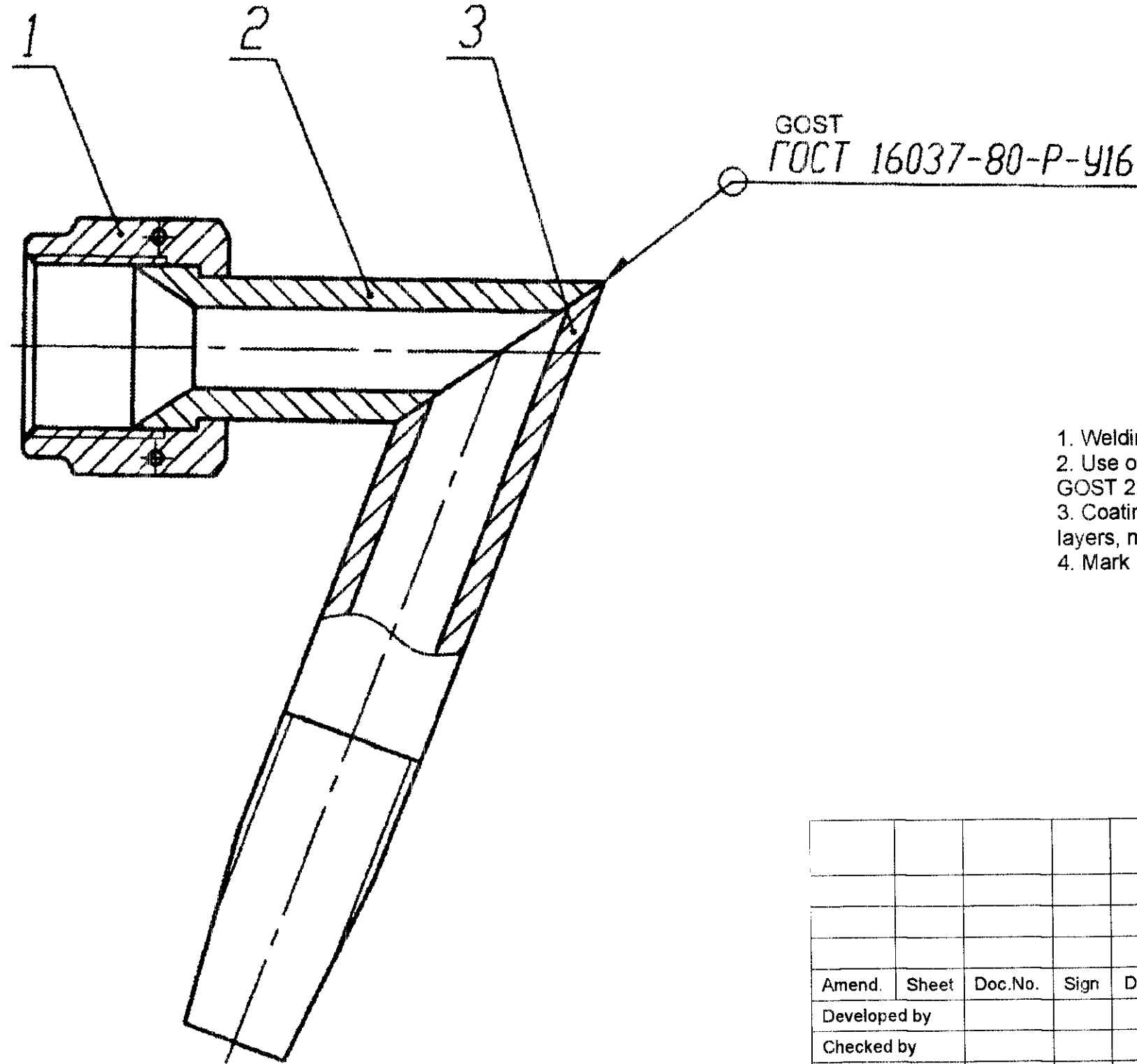
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



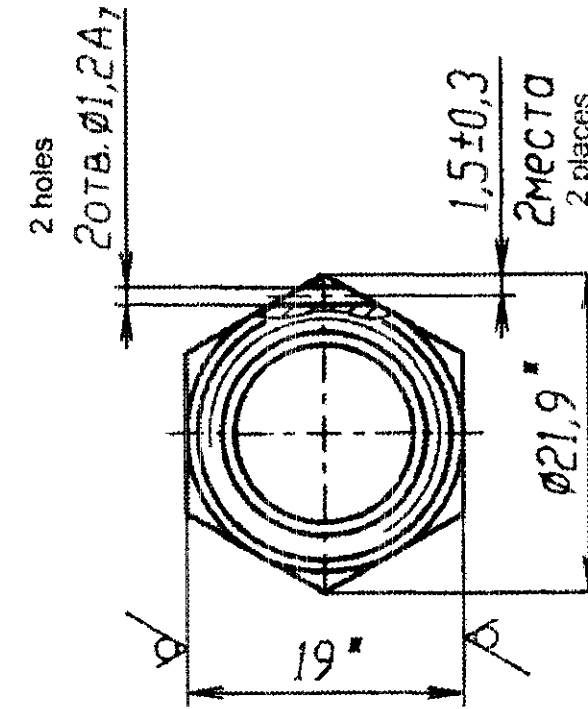
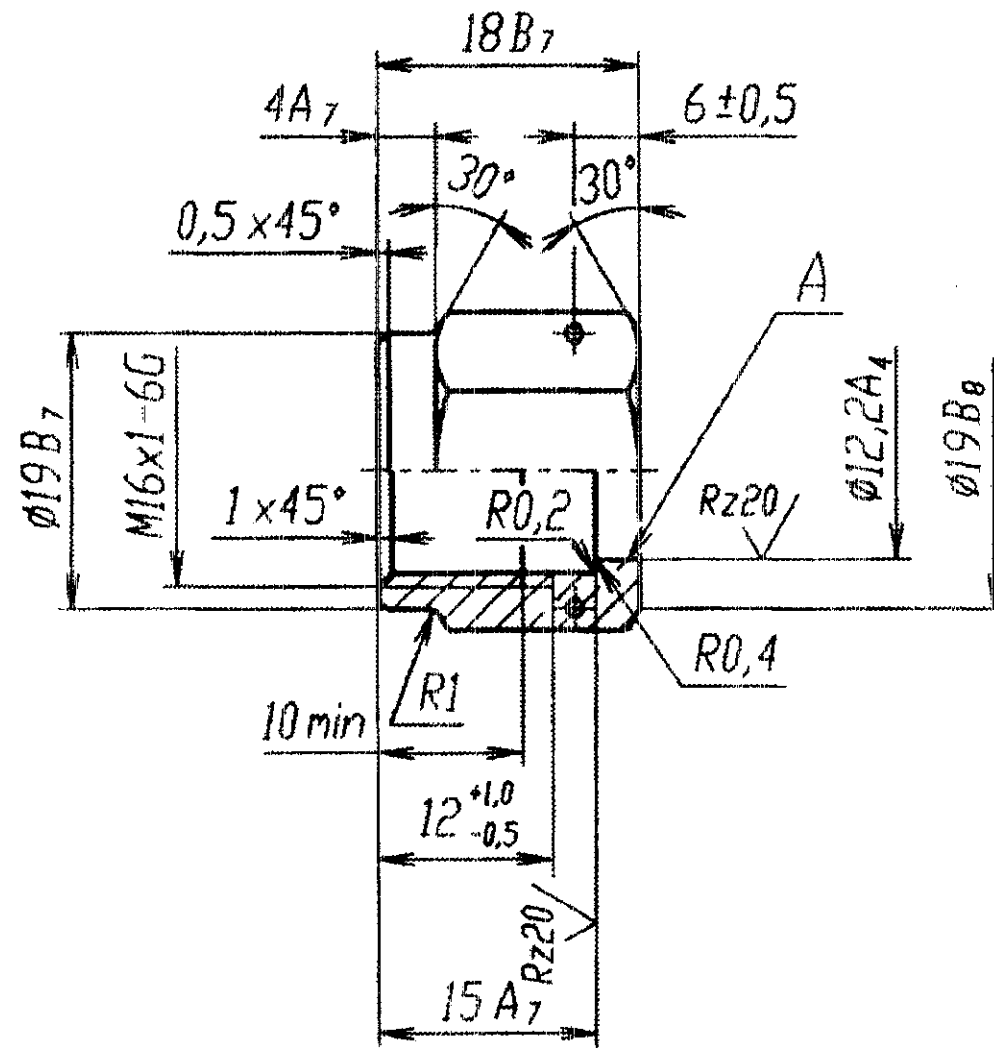
1. Welding rod TsL-11-3.0-2 GOST 9466-75.
2. Use of argon-arc welding is permissible. Filler wire 2 Sv -0.6 Cr19Ni9Ti GOST 2246-70.
3. Coating of external surface Chem. phos. Lacquer BF-4 with Nigrozene , 2 layers, made as per OST3-4123-78, IV, OM2, remaining Chem.phos.
4. Mark Ш , Ч and stamp K on tag.

					AK-630 Sb114-34 SB			
Amend.	Sheet	Doc.No.	Sign	Date	Angle piece Assembly drawing	Type	Weight	Scale
Developed by						A	0.070	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by								

AK-630 114-32

First use

Reference No.



Rz40 ✓ (✓)

Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

1. Substitute material- hexagon  $\frac{19 - 5GOST8560 - 78}{40GOST1051 - 73}$
2. 31..40.5 HRC<sub>E</sub>. Check 3..5% , but not less than 3 nos. from batch.
- 3.\* Reference dimensions
4. Blunt sharp edges ~0.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.01 mm.
6. Mark Ш, Ч and stamp K, И on tag.

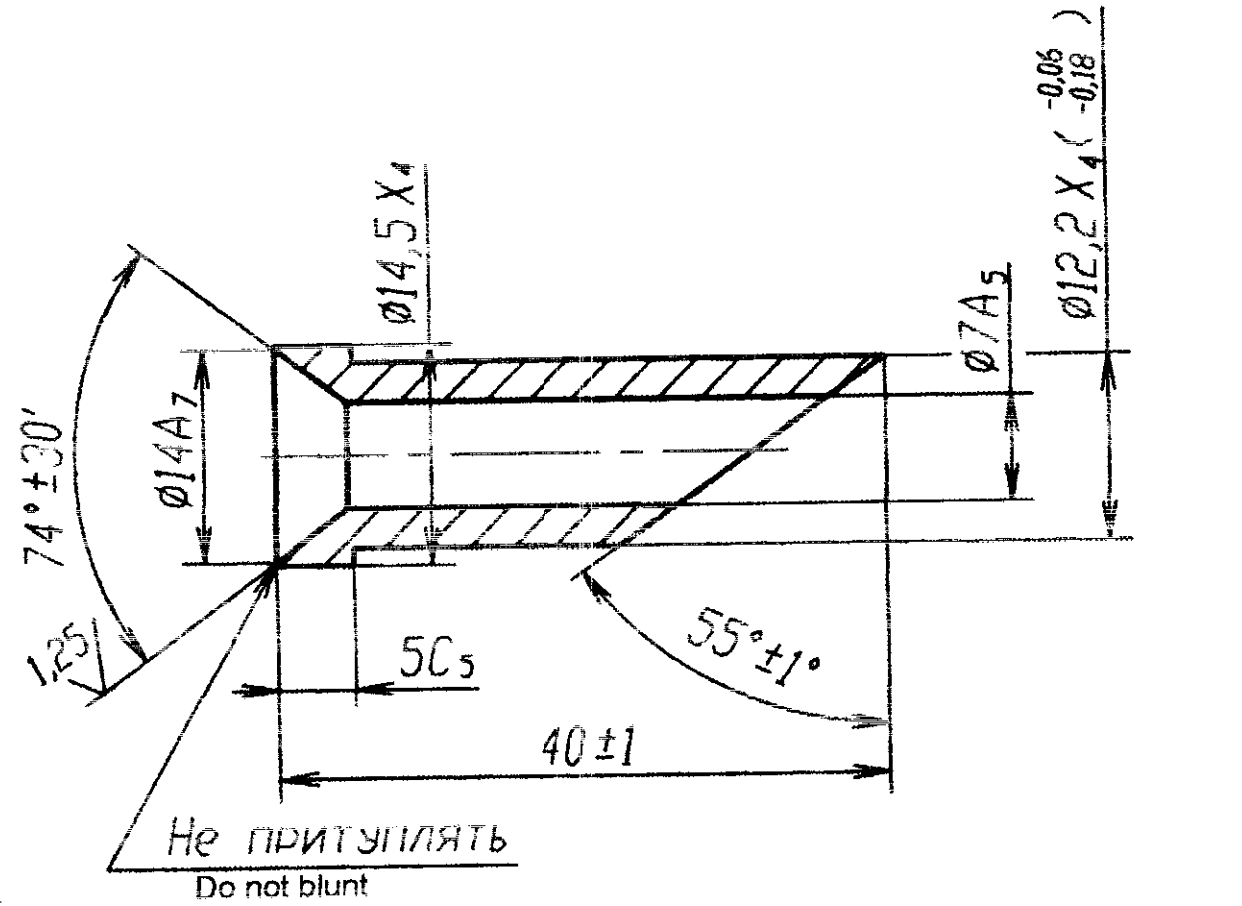
Designation	Coating
AK-630 114-32	Cd6.phos.
AK-630 -01	Without coating

					AK-630 114-32		
Amend.	Sheet	Doc.No.	Sign	Date			
Developed by					Coupling nut		
Checked by							
Head of Q.C.D					Hexagon $\frac{19 - 5GOST8560 - 78}{40Kh - T - VGOST1051 - 73}$		
Approved by							
					Type	Weight	Scale
					A	0.025	2:1
					Sheet	Sheets	1



AK-630 114-69

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



1. Inner angles  $R \sim 0.4$  mm.
2. Blunt sharp edges  $R \sim 0.4$  mm.
3. Mark Ш, Ч and stamp K on tag.

AK-630 114-69

Amend.	Sheet	Doc. No.	Sign	Date	<b>Nipple</b>	Type	Weight	Scale
Developed by						A	0.010	2:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D						Steel 12Cr18Ni9Ti		
Design bureau chief						GOST 5632-72		
Head of Q.C.D								
Approved by								

Copied by

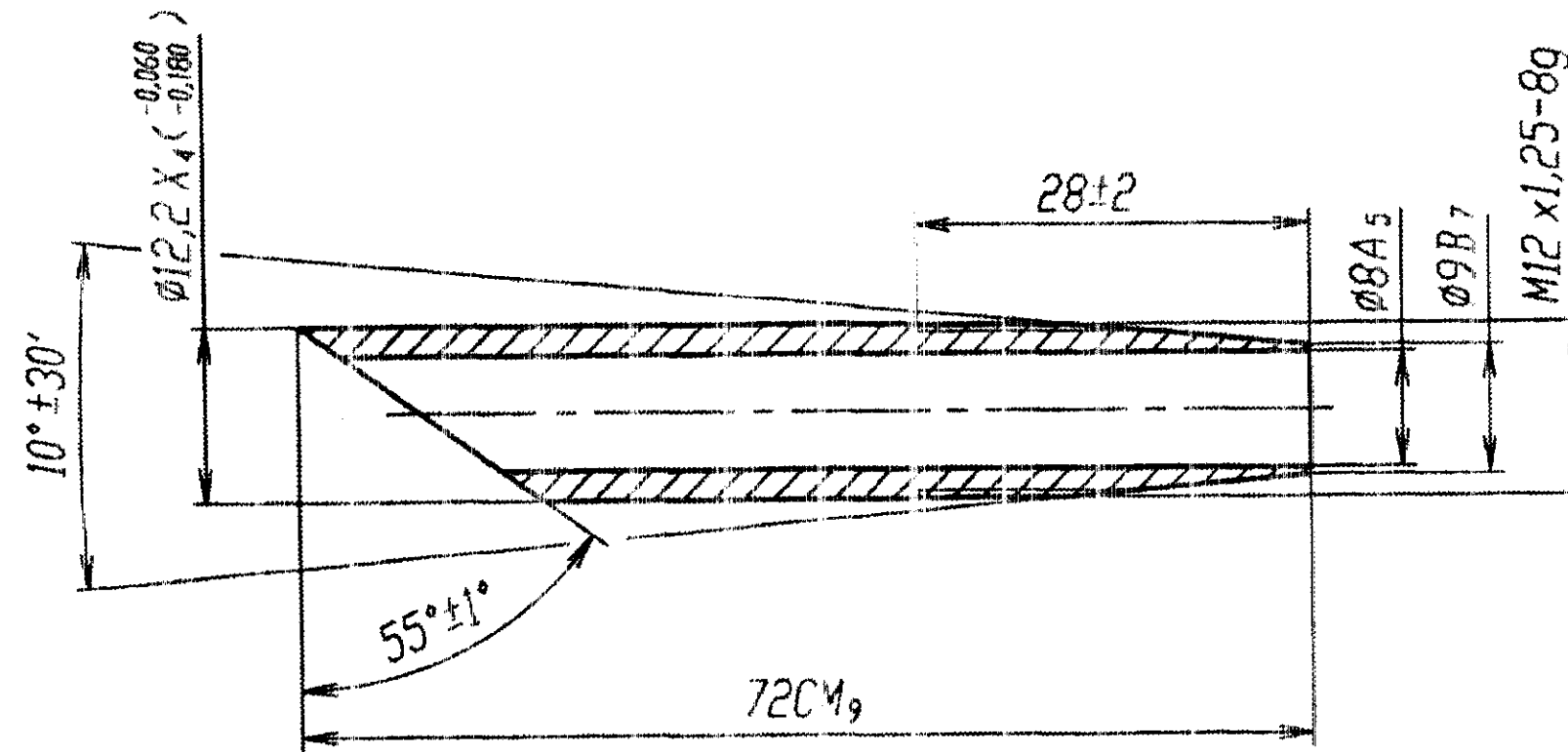
Format A4

AK-630 114-70

First use

Reference No.

Rz40  
✓(✓)



Sign and Date

Duplicate Inv. No.

Alternate Inv. No.

Sign and Date

Orig. inv. no.

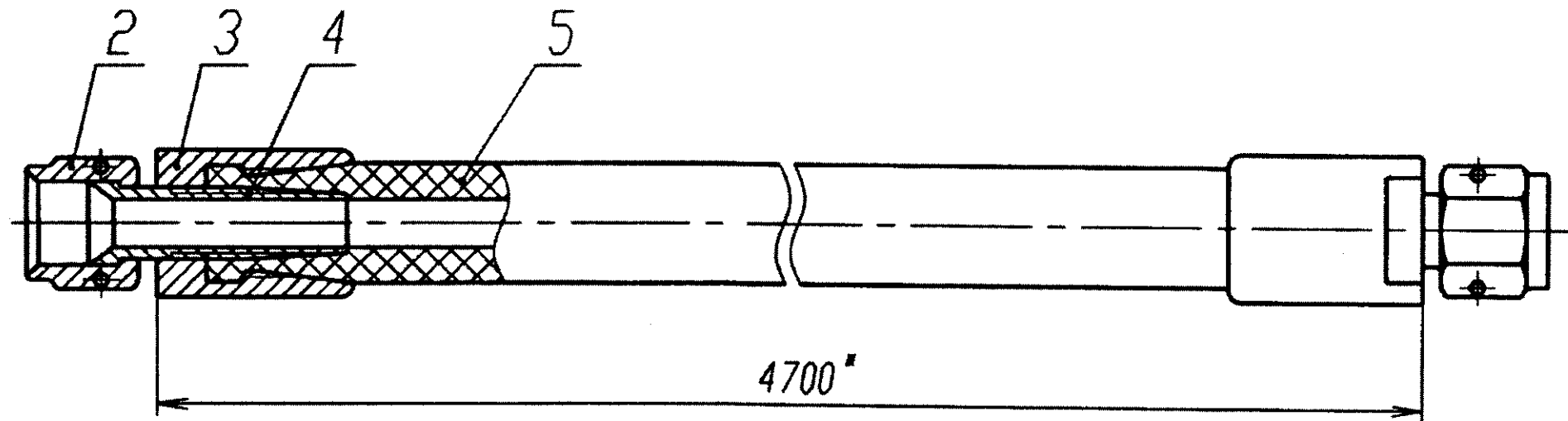
1. Inner angles R~0.4 mm.
2. Blunt sharp edges ~0.4 mm.
3. Mark W, 4 and stamp K on tag.

					AK-630 114-70			
Amend	Sheet	Doc.No.	Sign	Date	End cap	Type	Weight	Scale
							A	0.040
Developed by						Sheet	Sheets	1
Checked by								
Head of Q.C.D								
Approved by								
					Steel 12Cr18Ni9Ti			
					GOST 5632-72			

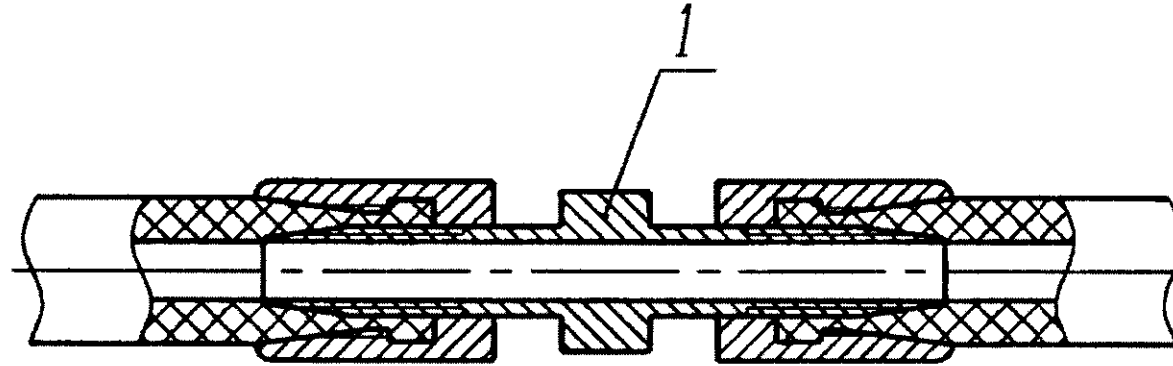
First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	<del>A3</del>			AK-630 Sb 114-17 SB	Assembly drawing			
					<u>Components</u>			
	A3		1	AK-630 114-32	Nipple	1	max.2	
	A3		2	AK-630 114-32	Coupling	2		
	A3		3	AK-630 114-32	Coupling nut	2	max.6	
	A4		4	AK-630 114-32	Nipple	2		
					<u>Materials</u>			
			5		Hose 5U8-85	1	L=1750 mm +	
					TU 38.005-1515-92		1750 mm +	
						1200 mm		
Sign and Date								
Lupl. Inv. No.								
Alternate Inv. No.								
Sign and Date								
Orig. Inv. No.					<b>AK-630 Sb 114-17</b>			
	Amend.	Sheet	Doc. No.	Sign	Date			
	Developed by					Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D					<b>Hose</b>		
Approved by								

First use

Reference No.



Option for expanding hoses  
ВАРИАНТ СРАЩИВАНИЯ РУКАВОВ



Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

1. \* Reference dimension.
2. It is permissible to expand separate pieces of hoses with length 1750 mm+ 1750 mm+1200 mm ( in specified sequence), by mounting additional components pos.1 and increasing no. of components pos.3.
3. Test for strength with air pressure 80 atm. Carry out testing by loading three times and keeping for 10 minutes.  
Disturbance of strength and tightness of joints is not permissible.
4. Check quality of joints on one hose from the batch consisting not less than 5 nos. by cutting the hose to not more than 50 mm from side of hose L = 1750 mm, further use the shortened hose in article.
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				

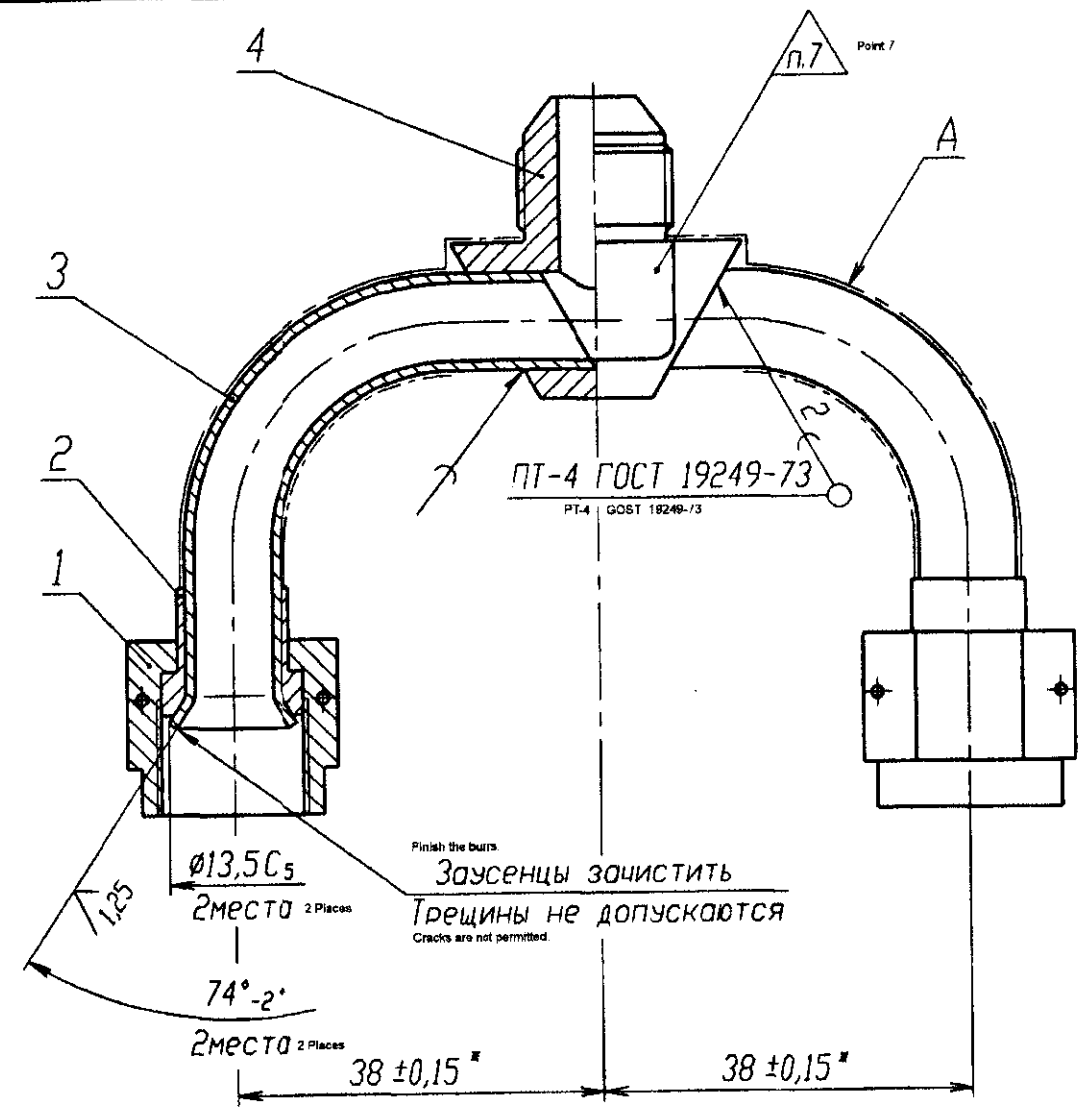
AK-630 Sb 114-17 SB

**Hose  
Assembly drawing**

Type	Weight	Scale
A	1.700	1:1
Sheet	Sheets	1

First use		Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
		<u>Documents</u>							
Reference No.	*)		✓		AK-630 Sb 114-18 SB	Assembly drawing		*)A4 x 3	
	<u>Components</u>								
	A3		✓	1	AK-630 114-32-01	Coupling nut	2		
	A4		✓	2	AK-630 114-33-01	Nipple	2		
	A4		✓	3	AK-630 114-47	Pipe	2		
	A3		✓	4	AK-630 114-48	Tee joint	1		
Sign and Date									
Dupl. Inv. No.									
Alternate Inv. No.									
Sign and Date									
Orig. Inv. No.						<b>AK-630 Sb 114-18</b>			
	Amend.	Sheet	Doc. No.	Sign	Date				
	Developed by					<b>Fork</b>	Type	Sheet	Sheets
	Checked by						A		1
	Head of Q.C.D								
	Approved by								

AK-630 СБ 114-18 СБ  
 АК-630 СБ 114-18 СБ



1. \* - Dimensions are to be ensured by tool.
2. Carry out the soldering on the fixture, which enables to set up the nipples pos. 2 exactly on the corresponding cones and tighten the nuts pos. 1. Carry out the soldering with brass L 63 ГОСТ 15527-70.
3. Partial melting of passage sections is permitted. During this, the ball of  $\Phi 6,35$  mm ГОСТ 3722-81 should freely pass through the sections.
4. Coating of surface A: Cad. 9 chrome.  
 Primer AK-070, yellow (2)  
 Enamel K1 V - 124, gray (4), IV, OM 2,  
 AK - 070 ГОСТ 25718-83  
 KHV-124 ГОСТ 10144-89  
 and other surfaces Cad. 9 chrome.  
 Non-cadmium plating of internal surfaces is permitted.
5. Test for durability at air pressure of 80 at.  
 Carry out the test with three-times loading for 10 min. Breakdown of durability and intactness of joints is not permitted.
6. Mark III, 4 on the tag.
7. Stamp K as per AK-630, AK-630M TU I.

1. \* Размеры обеспеч. инстр.
2. Паять в приспособлении, позволяющем точно установить nipples поз. 2 на соответствующих конусах и затянуть гайки поз. 1.  
 Пайку производить латуной Л63 ГОСТ 15527-70.
3. Допускается частичное заплывание проходных сечений.  
 При этом шарик  $\Phi 6,35$  мм ГОСТ 3722-81 должен свободно проходить через сечения
4. Покрытие поверхности А Кд9. хр.  
 Грунтовка АК-070, желтая (2)  
 Эмаль ХВ-124, серая (4), IV, OM 2,  
 АК-070 ГОСТ 25718-83  
 ХВ-124 ГОСТ 10144-89  
 остальных поверхностей Кд9. хр.  
 Допускается непрокадмирование внутренних поверхностей.
5. Испытать на прочность давлением воздуха 80 ат.  
 Испытание производить трехкратным нагружением с выдержкой в течение 10 мин. Нарушение прочности и плотности соединения не допускается.
6. Маркировать Ш, 4 на бирке.
7. Клеить К по АК-630, АК-630М ТУ I.

Изв. и пол. к. авто. / Взам. и пол. к. авто. / Сл. и пол. к. авто. / Пров. и пол. к. авто.

AK-630 СБ 114-18 СБ				AK-630 СБ114-18СБ		
				Type	Mass	Scale
				Лит.	Масса	Масштаб
				А	0,110	2:1
				Лист	Листов 1	
				Assembly drawing		
				Sheet	Total Sheets	
				Формат А4х3		

AK-630 114-32

First use

Reference No.

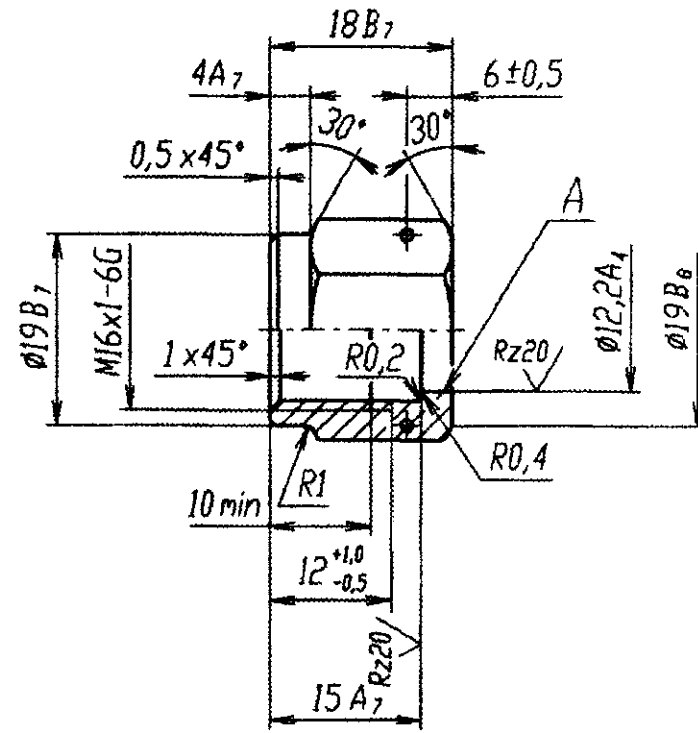
Sign and Date

Duplicate Inv. No.

Alternate Inv. No.

Sign and Date

Orig. inv. no.



Rz40 ✓ (✓)

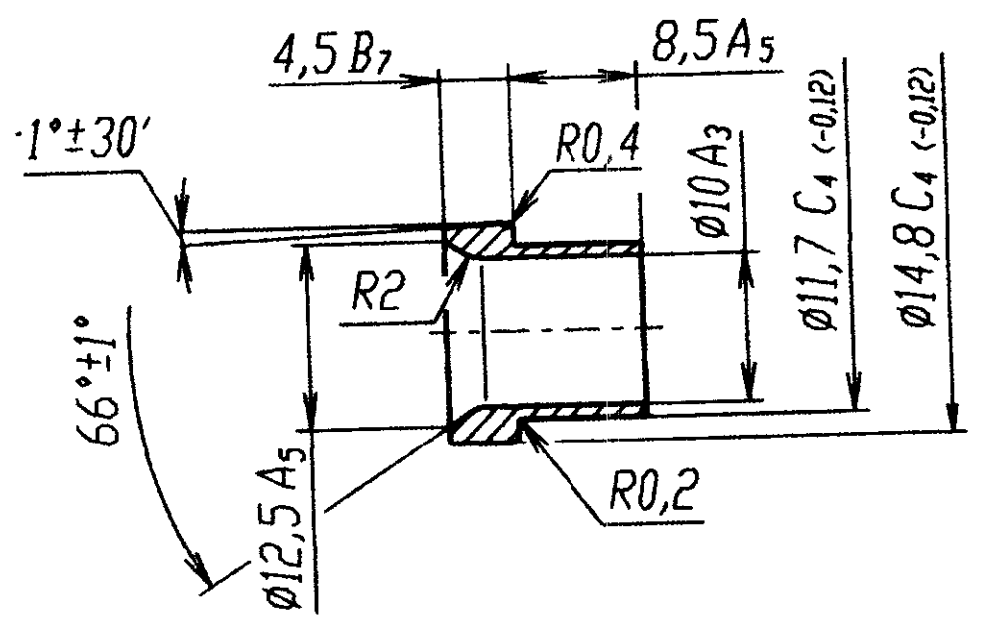
1. Substitute material- hexagon  $\frac{19 - 5GOST8560 - 78}{40GOST1051 - 73}$
2. 31.40.5 HRC<sub>E</sub>. Check 3.5% , but not less than 3 nos. from batch.
- 3.\* Reference dimensions.
4. Blunt sharp edges ~0.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.01 mm.
6. Mark Ш, 4 and stamp K, И on tag.

Designation	Coating
AK-630 114-32	Cd6.phos.
AK-630 -01	Without coating

AK-630 114-32					Type	Weight	Scale	
Amend.	Sheet	Doc.No.	Sign	Date	Coupling nut	A	0.025	2:1
Developed by						Sheet	Sheets	1
Checked by								
Head of Q.C.D					Hexagon $\frac{19 - 5GOST8560 - 78}{40Kh - T - VGOST1051 - 73}$			
Approved by								

AK-630 114-33

Rz20 ✓



Designation	Coating
AK-630 114-33	Ka12. pos
AK-630 -01	without coating

1. 38.5...44.5 HRC<sub>E</sub>. Check on specimen.
2. Blunt sharp edges ~0.2 mm.
3. Mark Ш, Ч and stamp K, И on tag.

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

Amend.	Sheet	Doc. No.	Sign	Date

<b>AK-630 114-33</b>			
<b>Nipple</b>	Type	Weight	Scale
	A	0.008	2:1
Sheet		Sheets 1	
Steel 50 GOST 1050-88			





First use

Reference No.

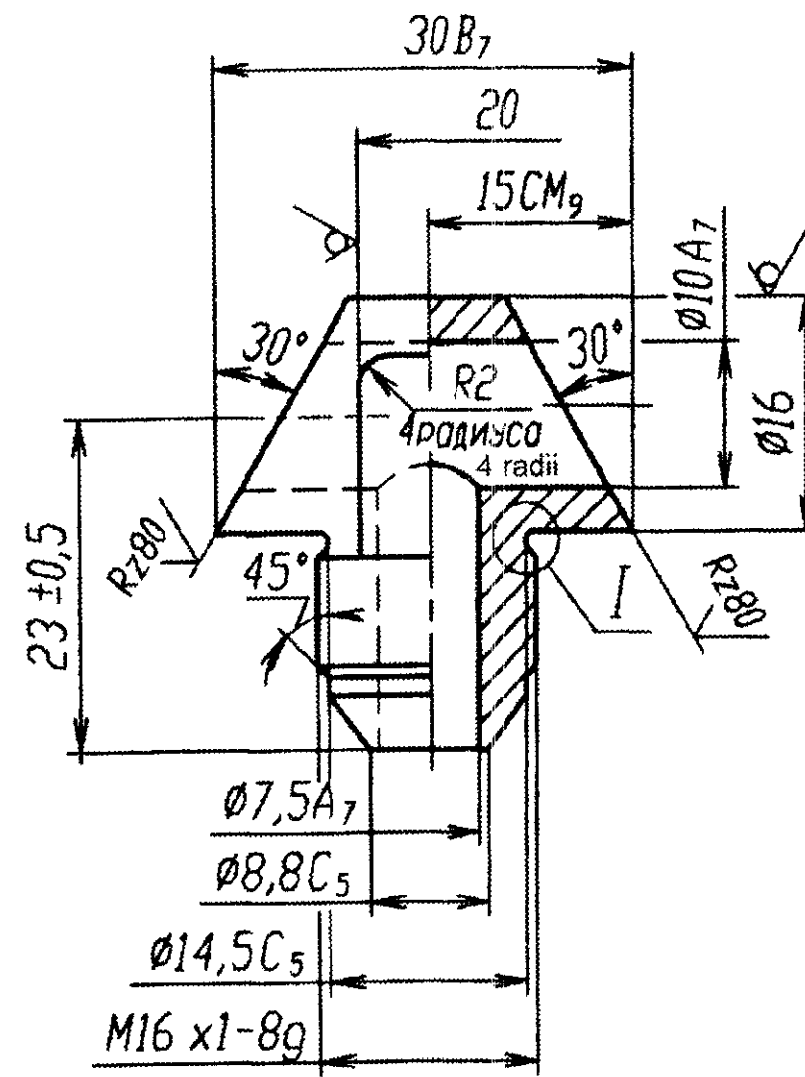
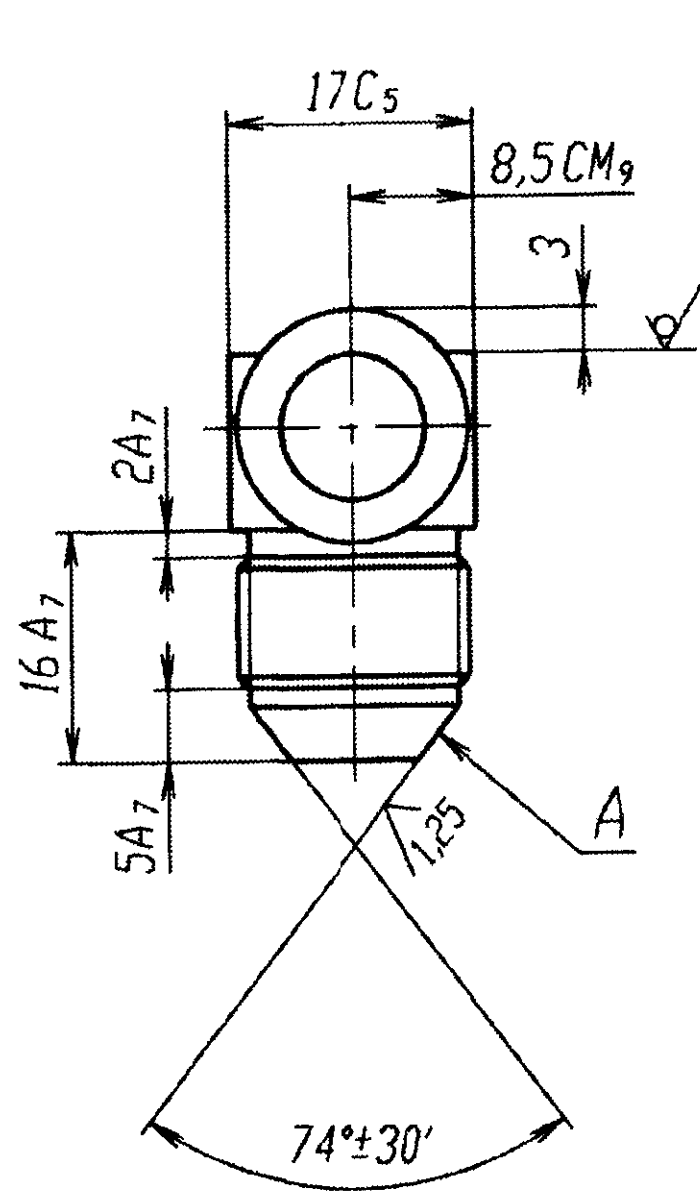
Sign and Date

Duplicate Inv. No

Alternate Inv. No

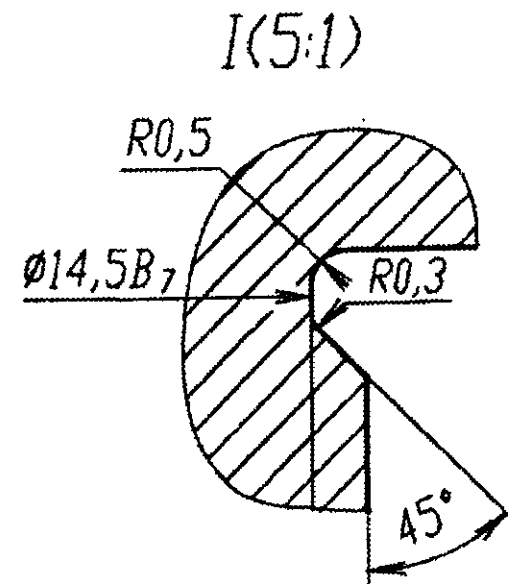
Sign and Date

Orig. inv. no.



Rz40  
✓ (✓)

1. Substitute material- Steel 40 Kh GOST 4543-71.
2. Blank- forging accuracy class T5 as per GOST 7505-89. Surface defects on un machined surfaces should not be larger than 0.5 mm in depth.
3. Forging gradient up to 7°.
4. Forging radii ~3 mm.
5. Inner angles R~0.4 mm.
6. Blunt sharp edges ~0.4 mm.
7. Run out of surface A with respect to mean diameter of thread is not more than 0.05 mm.
8. Mark Ш, Ч and stamp K on tag.

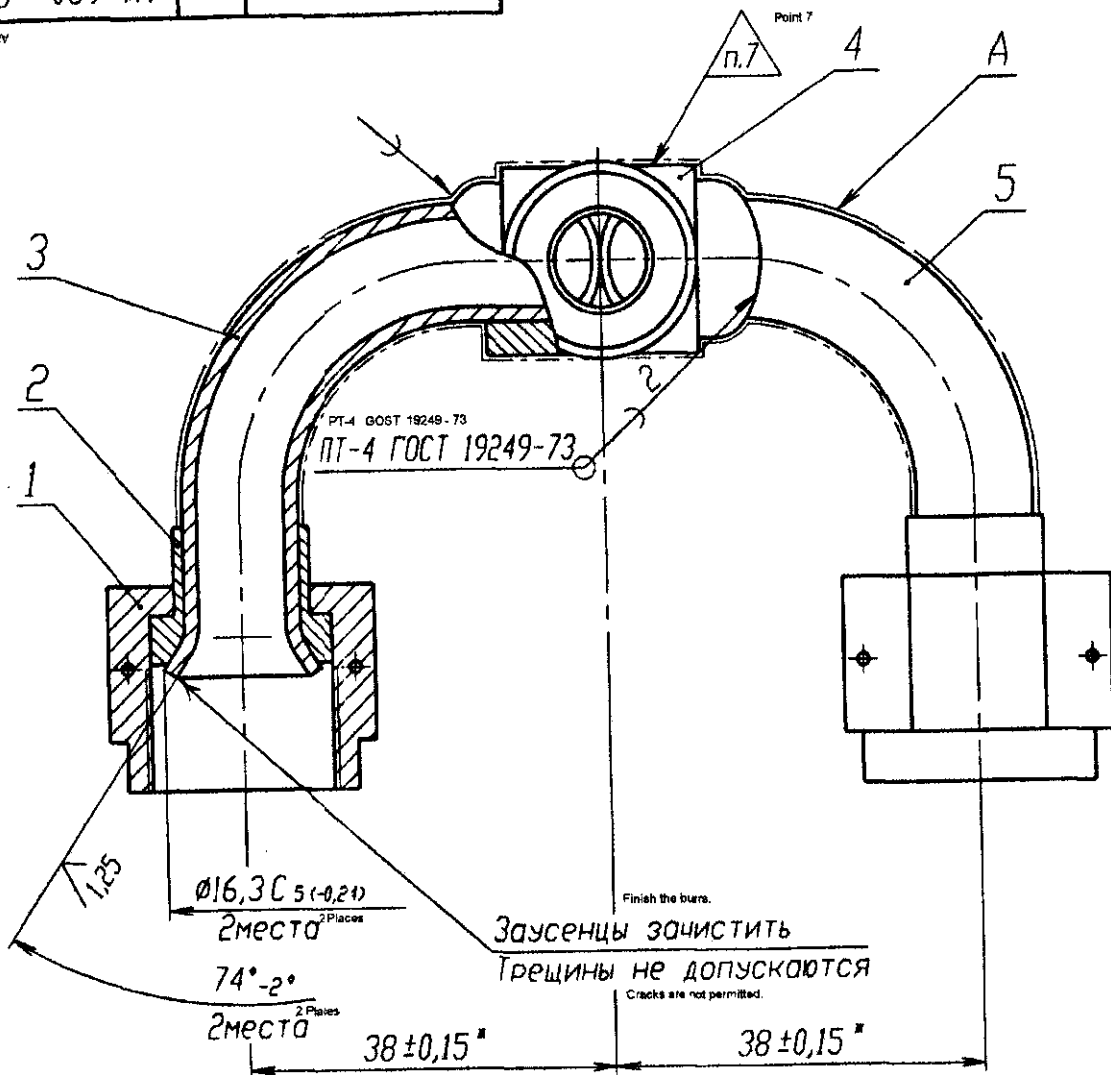


					AK-630 114-48			
Amend.	Sheet	Doc.No.	Sign	Date	T-joint	Type	Weight	Scale
Developed by						A	0.035	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Steel 50 GOST 1050-88			
Approved by								



AK-630 СБ114-19СБ

BS 61 111 95 003'W



1. \* Dimensions are ensured by tool.
2. Carry out the soldering on the fixture, which enables to set up the nipples pos. 2 exactly on the corresponding cones and tighten the nuts pos. 1. Carry out the soldering with brass L 63 GOST 15527-70.
3. Partial melting of passage section is permitted. During this, the ball of  $\phi 6,35$  mm GOST 3722-81 should freely pass through the section.
4. Test for durability by hydraulic pressure of  $P=18$  MPa (180 kgf/cm<sup>2</sup>) for 10 min. Breakdown of durability and intactness of joint and also the leakages, cracks, sweating on the welded joints and on the base of metal are not permitted.
5. Coating of surface A: Cad. 9 chrome.  
Primer AK-070 yellow (2)  
Enamel KhV-124, gray (4), IV, OM 2,  
AK-070 GOST 25718-83  
KhV-124 GOST 10144-89  
and other surfaces: Cad. 9 chrome.  
Non-cadmium plating of internal surfaces is permitted.
6. Mark III, 4 on the tag.
7. Stamp K as per AK-630, AK-630M TU I.

1.\* Размеры обеспеч. INSTR.  
 2. Паять в приспособлении, позволяющем точно установить ниппели поз. 2 на соответствующих конусах и затянуть гайки поз. 1.  
 Пайку производить латунью Л63 ГОСТ 15527-70.  
 3. Допускается частичное заплывание проходных сечений. При этом шарик  $\phi 6,35$  мм ГОСТ 3722-81 должен свободно проходить через сечения.  
 4. Испытать на прочность гидравлическим давлением  $P=18$  МПа (180 кгс/см<sup>2</sup>) с выдержкой в течение 10 мин. Нарушение прочности и плотности соединения, а также течи, трещин, слезок, потение в паянных соединениях и на основном металле не допускается.  
 5. Покрытие поверхности А Кд9. хр.  
 Грунтовка АК-070, желтая (2)  
 Эмаль ХВ-124, серая (4), IV, OM2,  
 АК-070 ГОСТ 25718-83  
 ХВ-124 ГОСТ 10144-89  
 остальных поверхностей Кд9. хр.  
 Допускается непрокадмирование внутренних поверхностей.  
 6. Маркировать Ш, Ч на бирке.  
 7. Клеить К по АК-630, АК-630М ТУ I.

AK 630 Sb 114-19 SB

				AK-630 СБ114-19СБ		
				Type	Mass	Scale
				Лит.	Масса	Масштаб
				А	0,200	2:1
				Вилка Сборочный чертёж Assembly drawing		
				Лист	Листов	
				Sheet	Total Sheets	
				Формат А4х3		

Лист 1 из 1  
 Проверено  
 Спроектировано  
 Подпись  
 Подпись  
 Подпись  
 Подпись

AK-630 114-49

First use

Reference No.

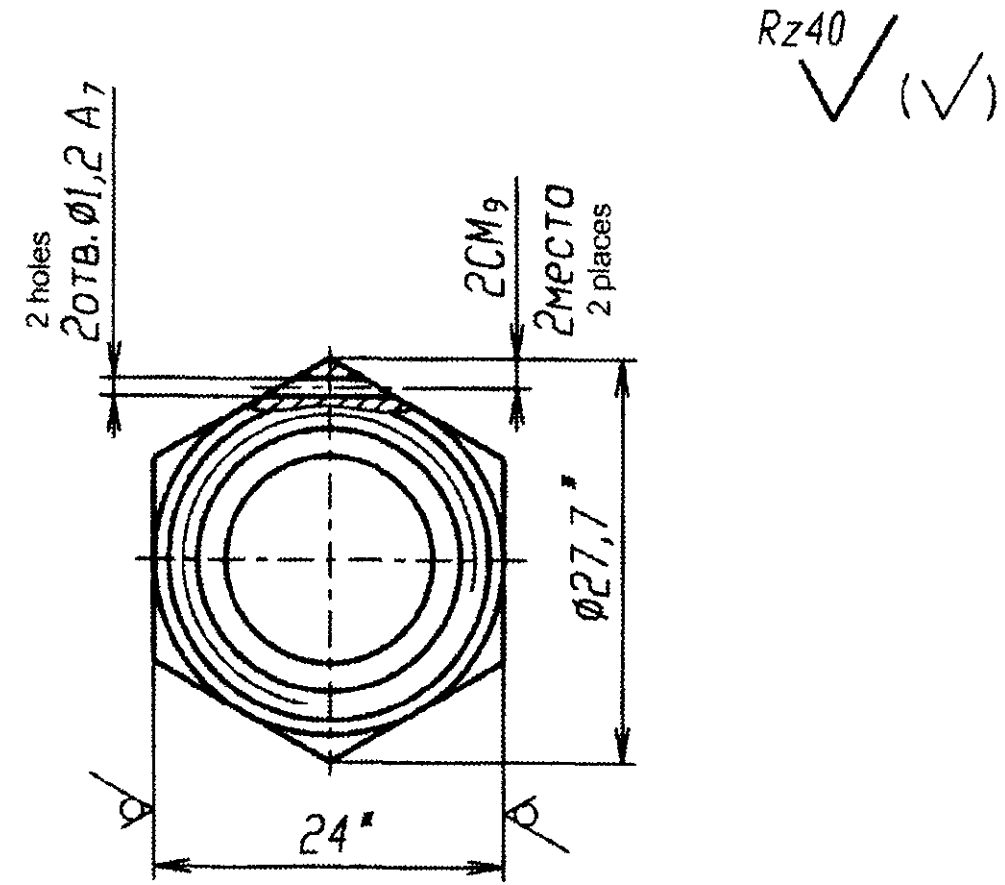
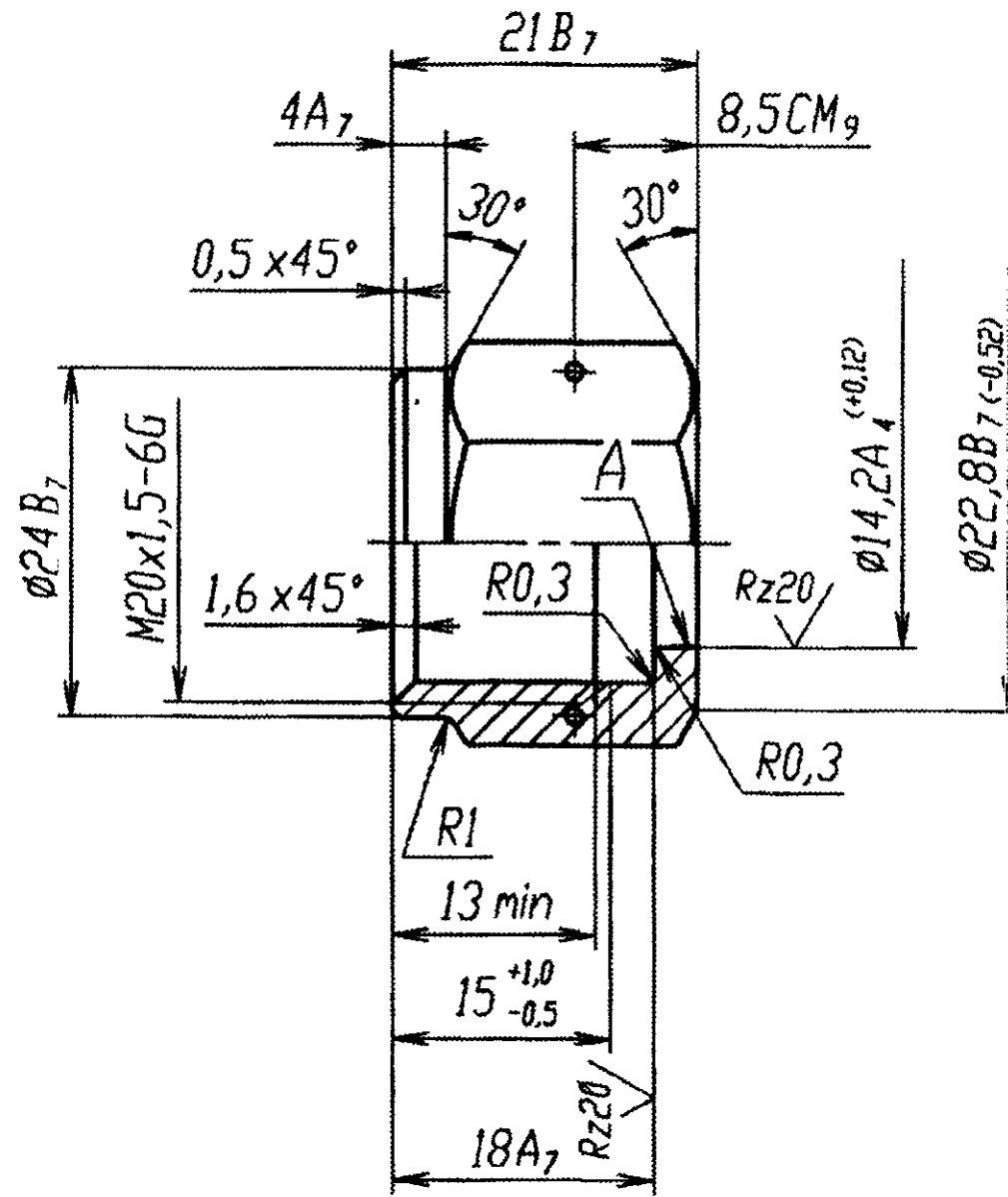
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

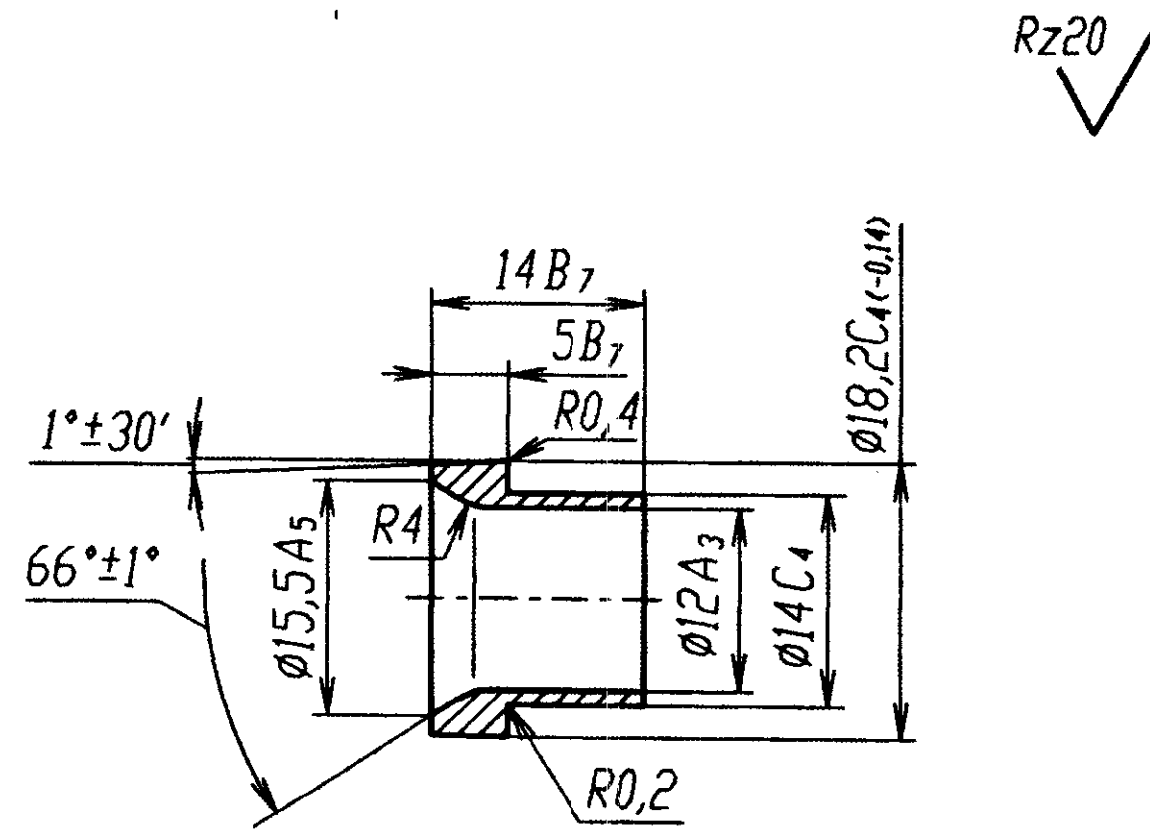


1. 31..40.5 HRC<sub>E</sub>. Check 3..5% , but not less than 3 nos. from batch.
- 2.\* Reference dimensions.
3. Blunt sharp edges ~0.2 mm.
4. Run out of surface A with respect to mean diameter of thread is not more than 0.01 mm.
5. Mark Ш, Ч and stamp К, И on tag.

Designation	Coating
AK-630 114-49	Cd6.phos.
AK-630114-49 -01	Without coating

AK-630 114-49					Type	Weight	Scale	
Amend.	Sheet	Doc.No.	Sign	Date	Coupling nut	A	0.030	2:1
Developed by						Sheet	Sheets	1
Checked by					Hexagon			
Head of Q.C.D					24 - 5GOST8560 - 78			
Approved by					40Kh - T - VGOST1051 - 73			

AK-630 114-50



Designation	Coating
AK-630 114-50	Ka12. pos
AK-630 114-50-01	without coating

1. Substitute material- Steel 50A OST 3-98-80.
2. 38.5...44.5 HRC<sub>E</sub>. Check on specimen.
3. Blunt sharp edges ~0.2 mm.
4. Mark Ш, Ч and stamp K, И on tag.

Approved OGMet	Sign and Date	Approved Tcosb	Dupl. Inv. No.	Sign and Date	Approved KTONI	Reference No.	Approved by shop	First use																			
Orig. Inv. No.		Alternate Inv. No.																									
Amend.	Sheet	Doc. No.	Sign	Date	<table border="1"> <thead> <tr> <th colspan="4">AK-630 114-50</th> </tr> <tr> <th rowspan="2">Nipple</th> <th>Type</th> <th>Weight</th> <th>Scale</th> </tr> </thead> <tbody> <tr> <td>A</td> <td>0.005</td> <td>2:1</td> </tr> <tr> <td colspan="4" style="text-align: right;">Sheets 1</td> </tr> <tr> <td>Steel 50 GOST 1050-88</td> <td colspan="3"></td> </tr> </tbody> </table>				AK-630 114-50				Nipple	Type	Weight	Scale	A	0.005	2:1	Sheets 1				Steel 50 GOST 1050-88			
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Steel 50 GOST 1050-88																											
Developed by																											
Checked by																											
Head of Q.C.D																											
Design bureau chief																											
Head of Q.C.D																											
Approved by																											

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Format A4

Approved OGMet		Approved Tusb		Approved KTONI		Approved by shop																																																								
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First use

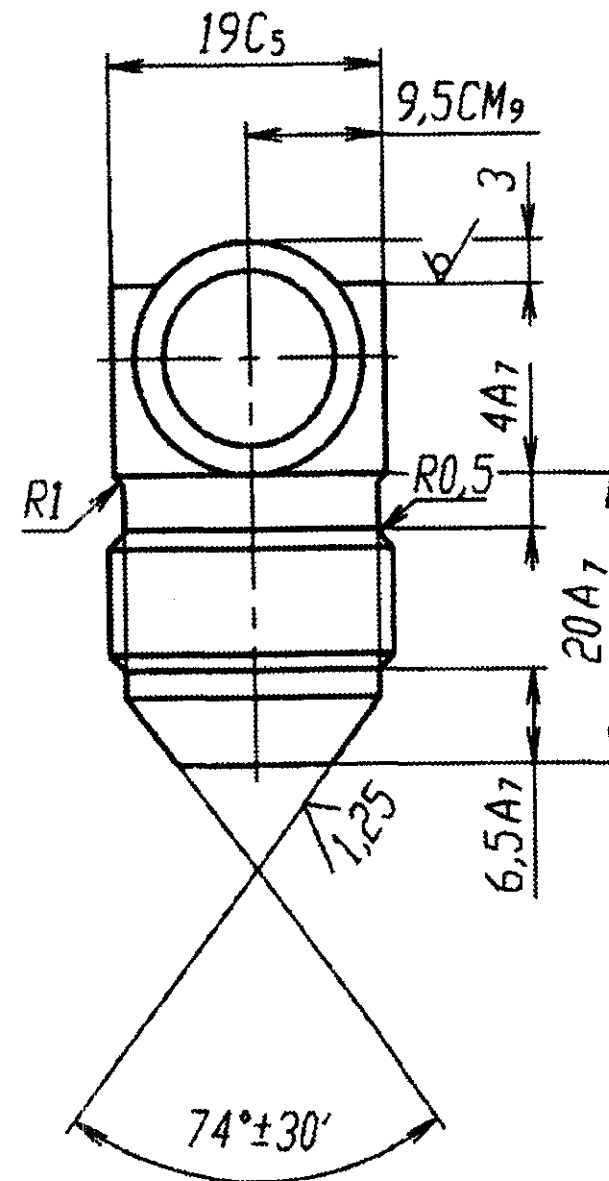
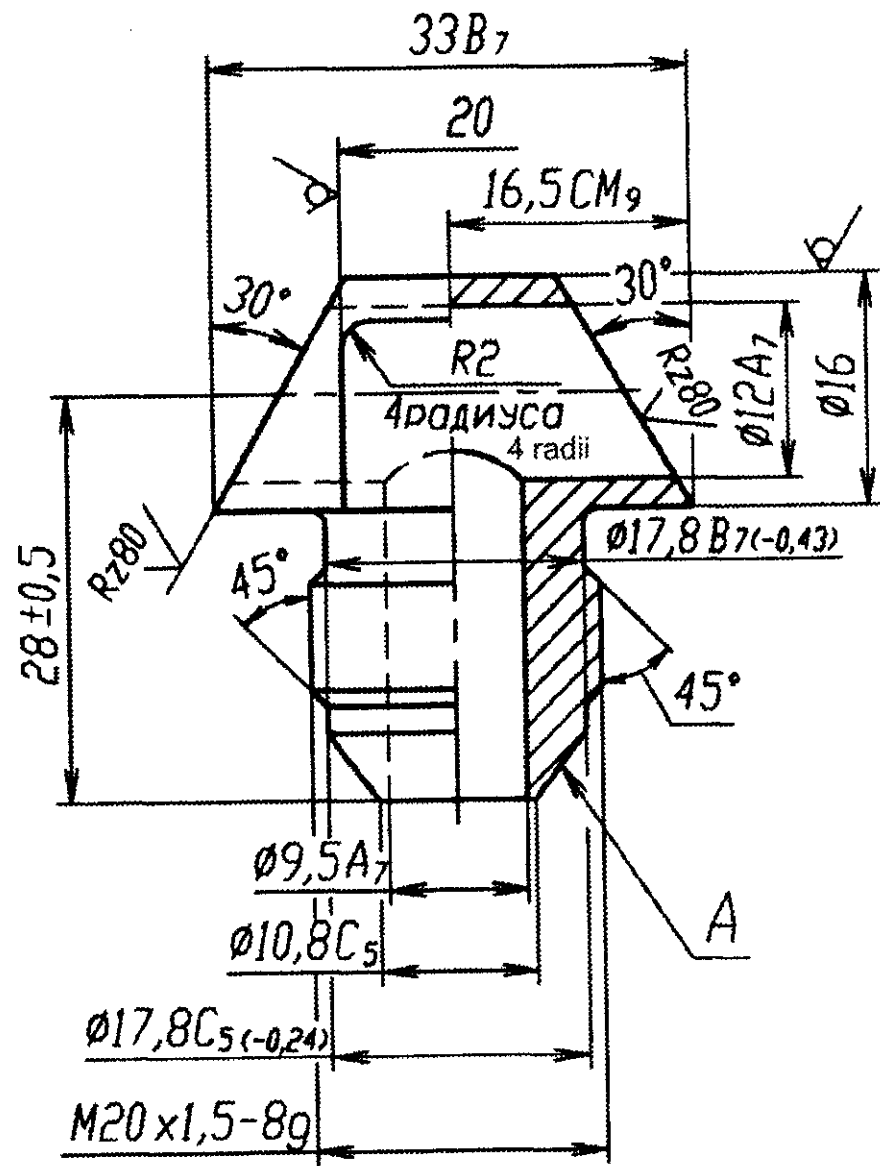
Reference No.

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz40  
✓ (✓)

1. Substitute material- Steel 40 Kh GOST 4543-71.
2. Blank- forging accuracy class T5 as per GOST 7505-89.  
Surface defects on un machined surfaces should not be larger than 0.5 mm in depth.
3. Forging gradient up to 7°.
4. Forging radii ~3 mm.
5. Inner angles R~0.4 mm.
6. Blunt sharp edges ~0.4 mm.
7. Run out of surface A with respect to mean diameter of thread is not more than 0.05 mm.
8. Mark Ш, Ч and stamp K on tag.

Amend.	Sheet	Doc.No.	Sign	Date

AK-630 114-52

T-joint

Type	Weight	Scale
A	0.080	2:1
Sheet	Sheets	1

Steel 50 GOST 1050-88



