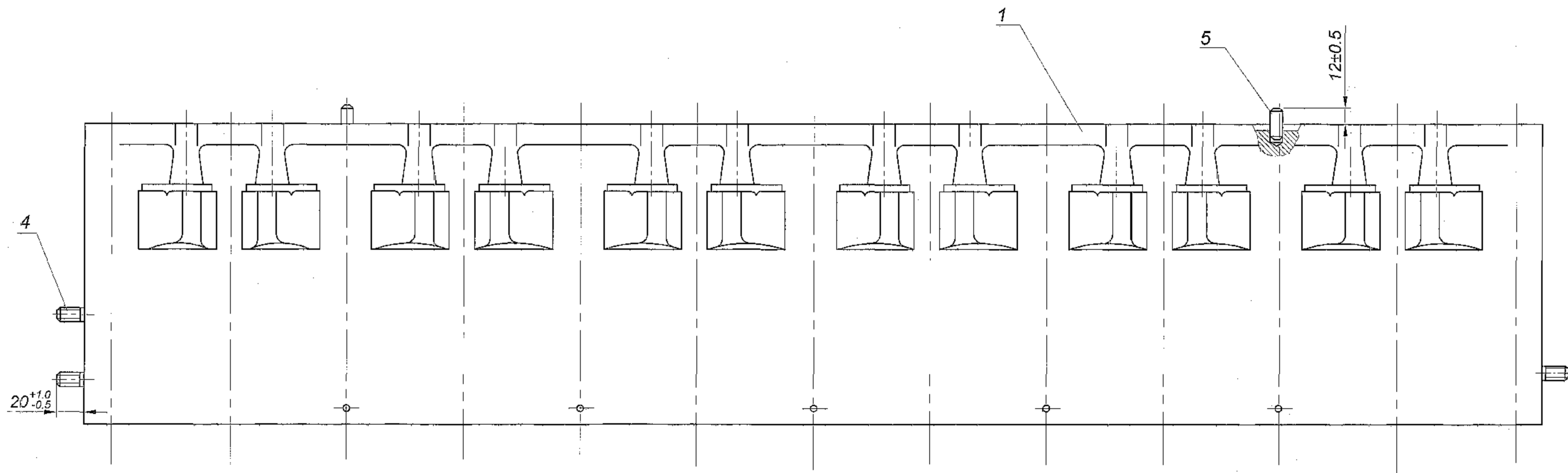
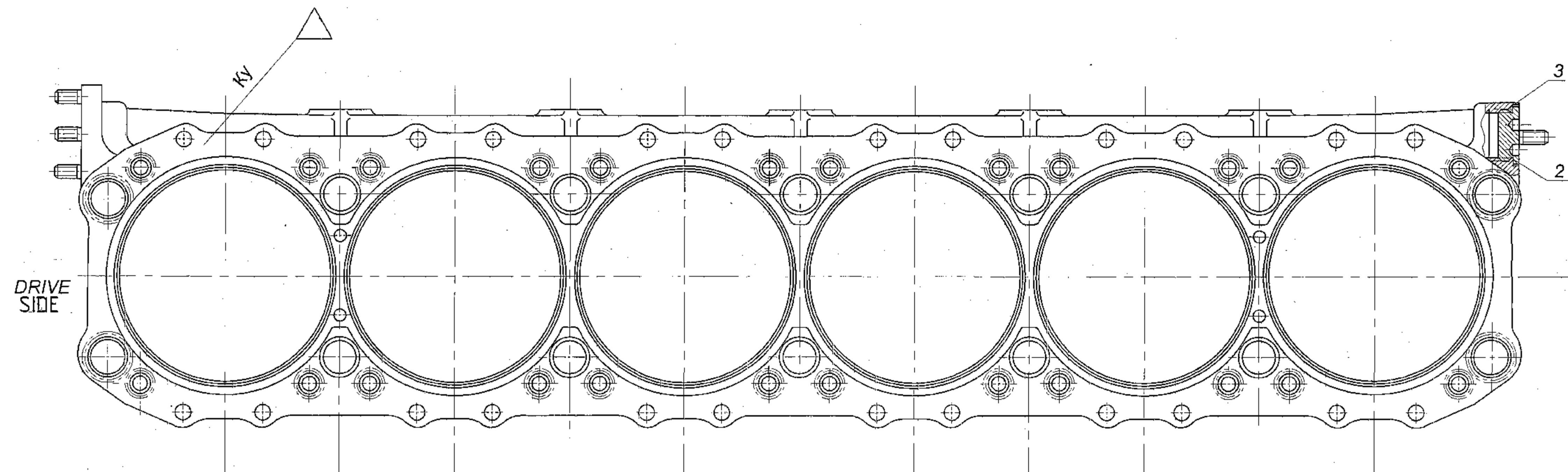


DRAWING NUMBER
Cb.303-02-23

SHEET No. 1 OF 1



1. Pressure test is to be carried out with water under a pressure of 0.25MPa (2.5Kgf/cm²) 0.3MPa (3 Kgf/Cm²) at temperature of 60.....70°C for 3 minutes minimum. This is to be conducted before mounting stud and pins.



DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 2

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

EST. WT. 28.36 TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

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

DRN	ALL	MATERIAL	USED ON
CHD	K. S. S. S.		Cb 303-01-23
APPD		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	01/2/87	AVADI	
SCALE	1:2		
DIMENSIONS IN mm			
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 2102 - 69			
ALL THREADS TO CONFORM TO			
ISSUE	DATE	NATURE OF AMENDMENTS	

CYLINDER JACKET LH ASSY

DRAWING NUMBER
Cb.303-02-23

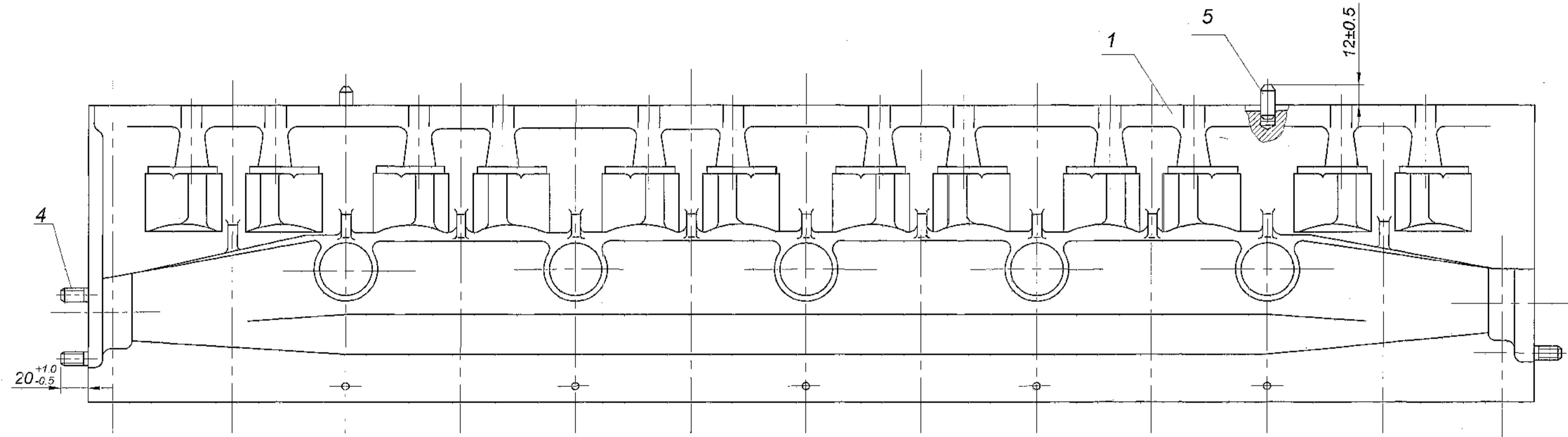
F-3
31
166

SIZE A1

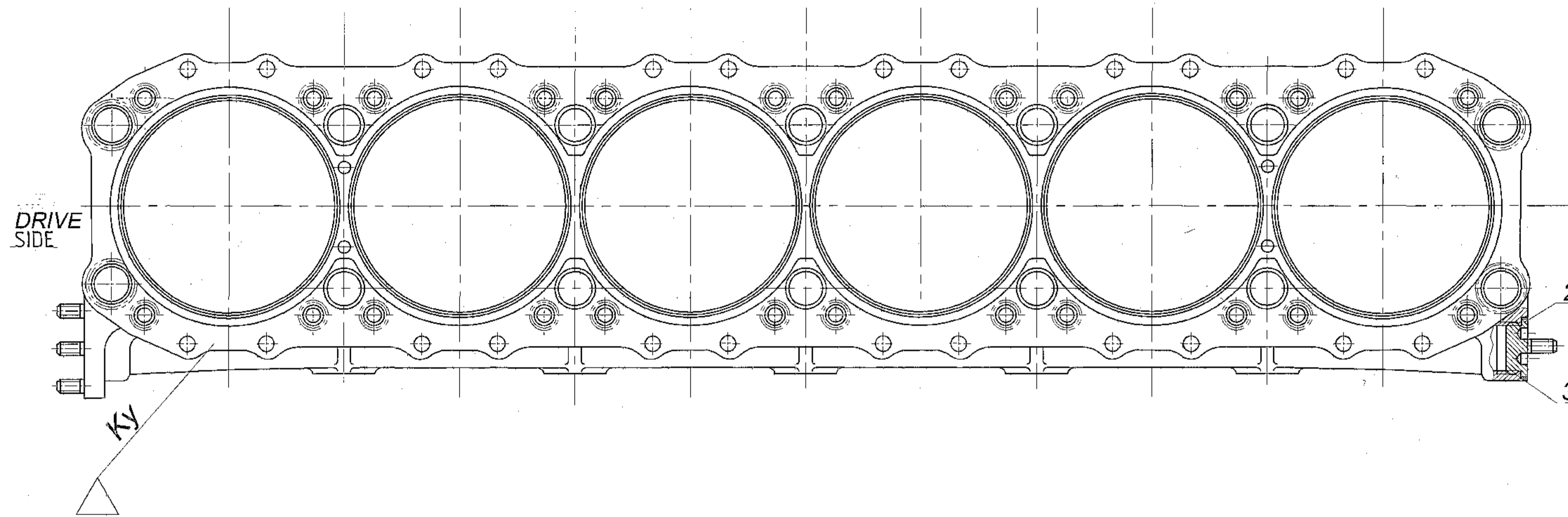


DRAWING NUMBER
Cb.303-03-16

SHEET No. 1 OF 1



1. Pressure test is to be carried out with water under a pressure of 0.25MPa (2.5Kg/cm²) ... 0.3MPa (3 Kg/cm²) at temperature of 60...70°C for 3 minutes minimum, This is to be conducted before mounting studs and pins.



DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 2

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

EST. WT. 28.36 TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)

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

DRN	CHD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS : 2102 - 69	ALL THREADS TO CONFORM TO	D S CAT NUMBER	USED ON -	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	TITLE :-	DRAWING NUMBER
			01/2/57	1:2					Cb 303-00-23		CYLINDER JACKET RH ASSY	Cb.303-03-16
ISSUE	DATE	NATURE OF AMENDMENTS										

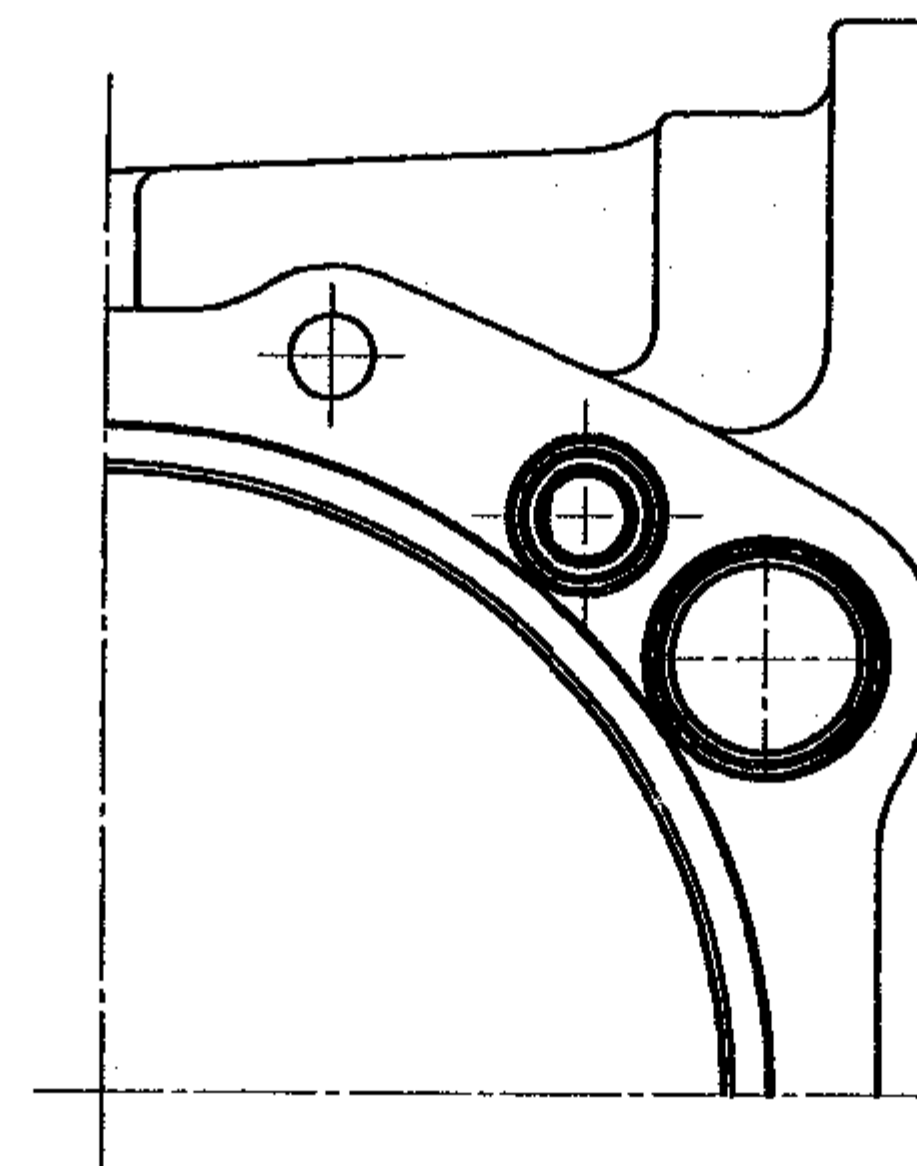
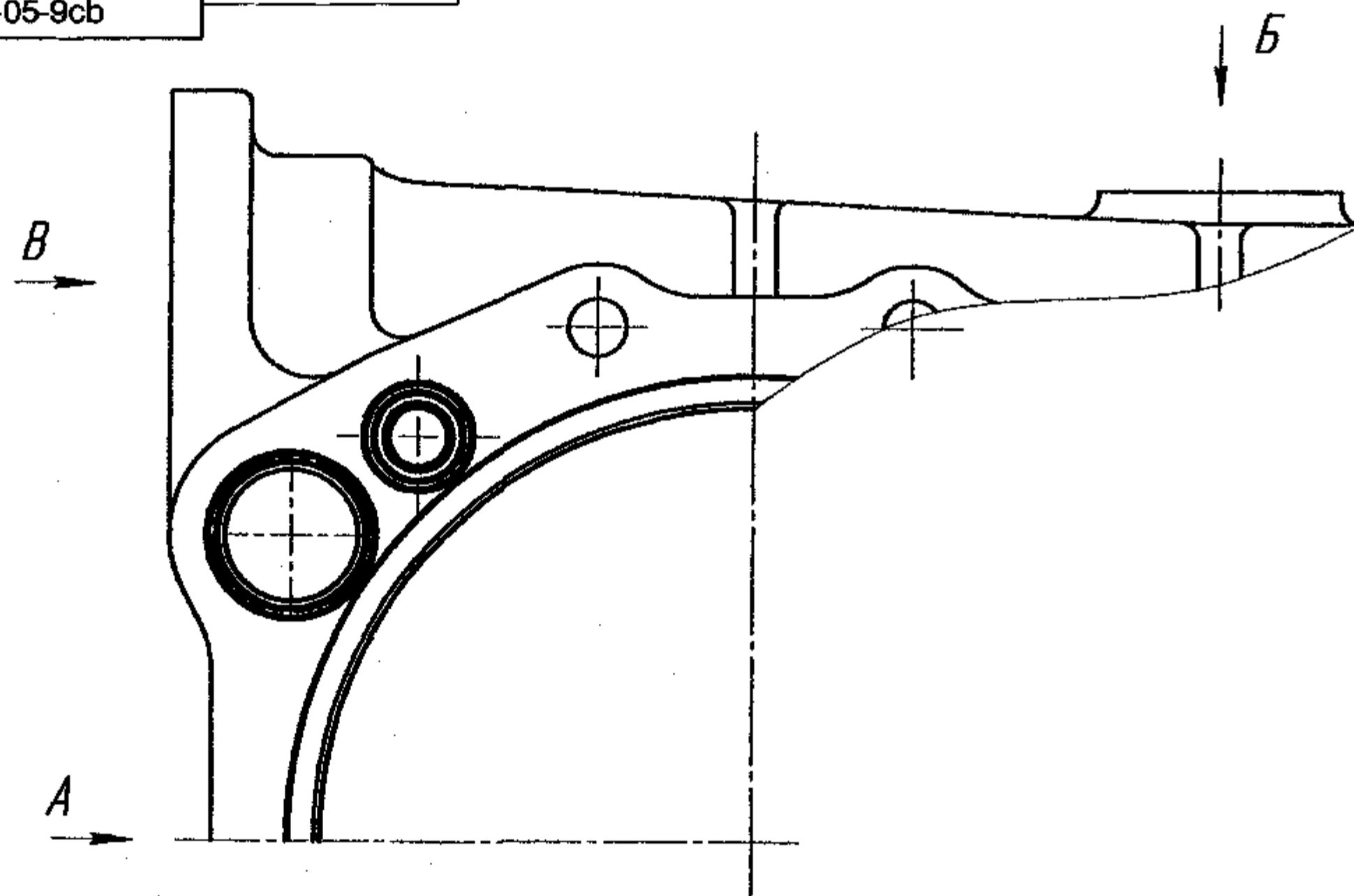
F-3
33
166

SIZE A1



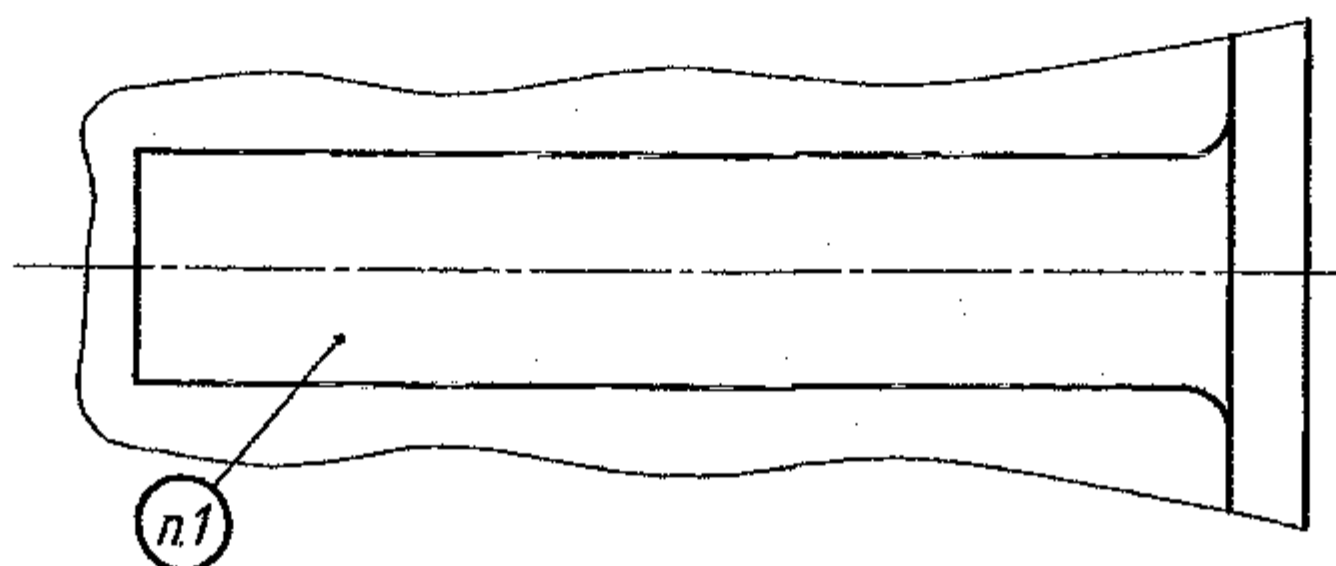
DRAWING NUMBER
Cb303-05-9cb

SHEET No. 1 OF 1

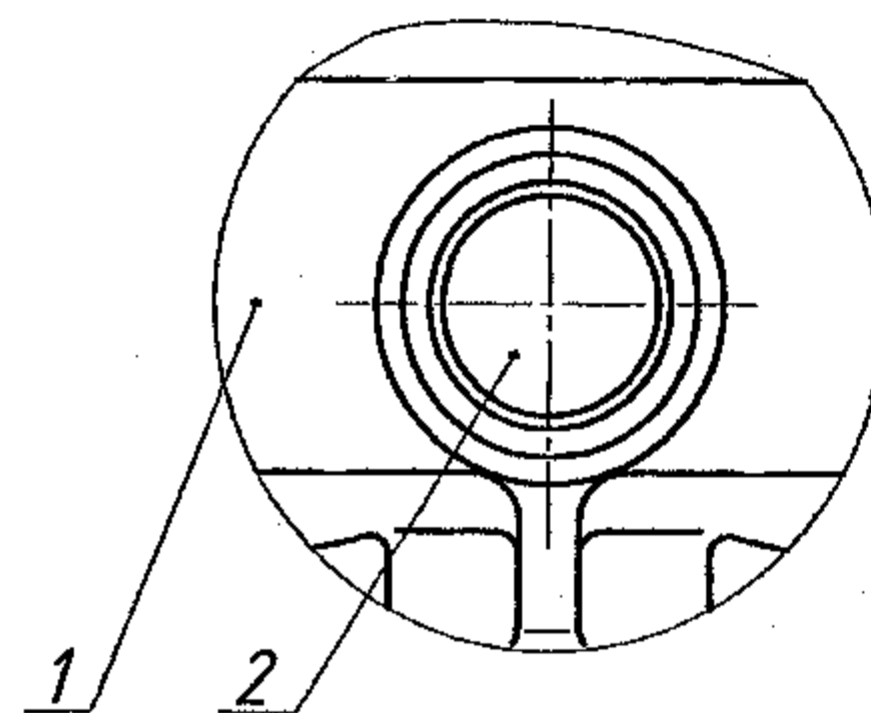


A

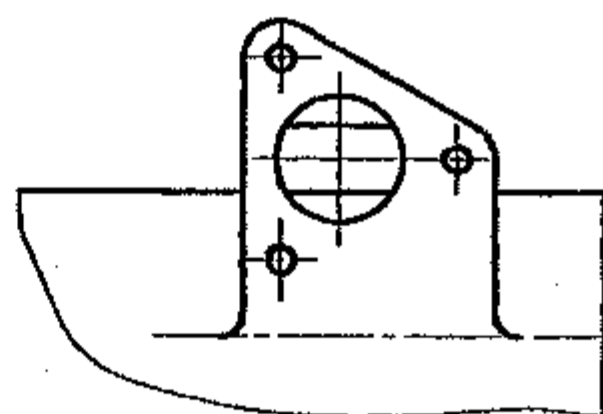
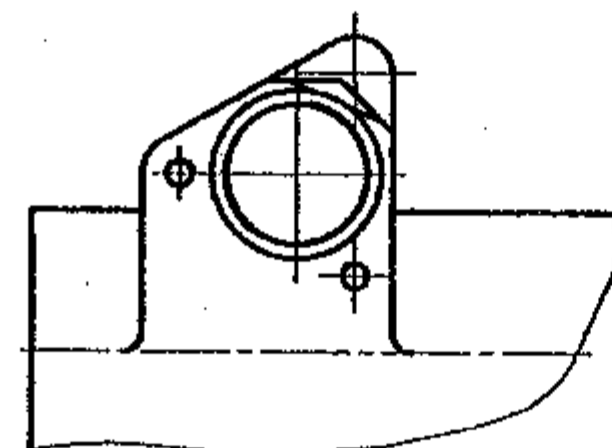
B



B(1:2)



G(1:2)



1. MARK L.H. WITH LETTER SIZE 5- П03 GOST 26.008-85.
2. OTHER - REFER cb303-06-24.

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

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

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

DRN	<i>[Signature]</i>	MATERIAL:-	USED ON:- Cb303-02-23
CHD	V01		
APPD	<i>[Signature]</i>	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
DATE	09 DEC 2015		
SCALE:-	1 : 1		
DIMENSIONS IN mm			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69		TITLE:-	CYLINDER JACKET L.H. ASSY.
ALL THREADS TO CONFORM TO IS:4218.PART- 4		D S CAT NUMBER	DRAWING NUMBER Cb303-05-9cb
ISSUE	DATE	NATURE OF AMENDMENTS	

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NIL
DRG. REPLACES ISSUE - 3 & Cb 303 - 05 - 6cb. Vide Notn No. 196 - 99

V92-S2

F-164
14
SIZE A2



DRAWING INDICATED BASED ON RUSSIAN ORIGINAL ISSUE - N.L.
DRAWING REPLACES ISSUE - N.L. VITE NOTN No. 18938.
V9252
F.184
43/70
SIZE A2x5

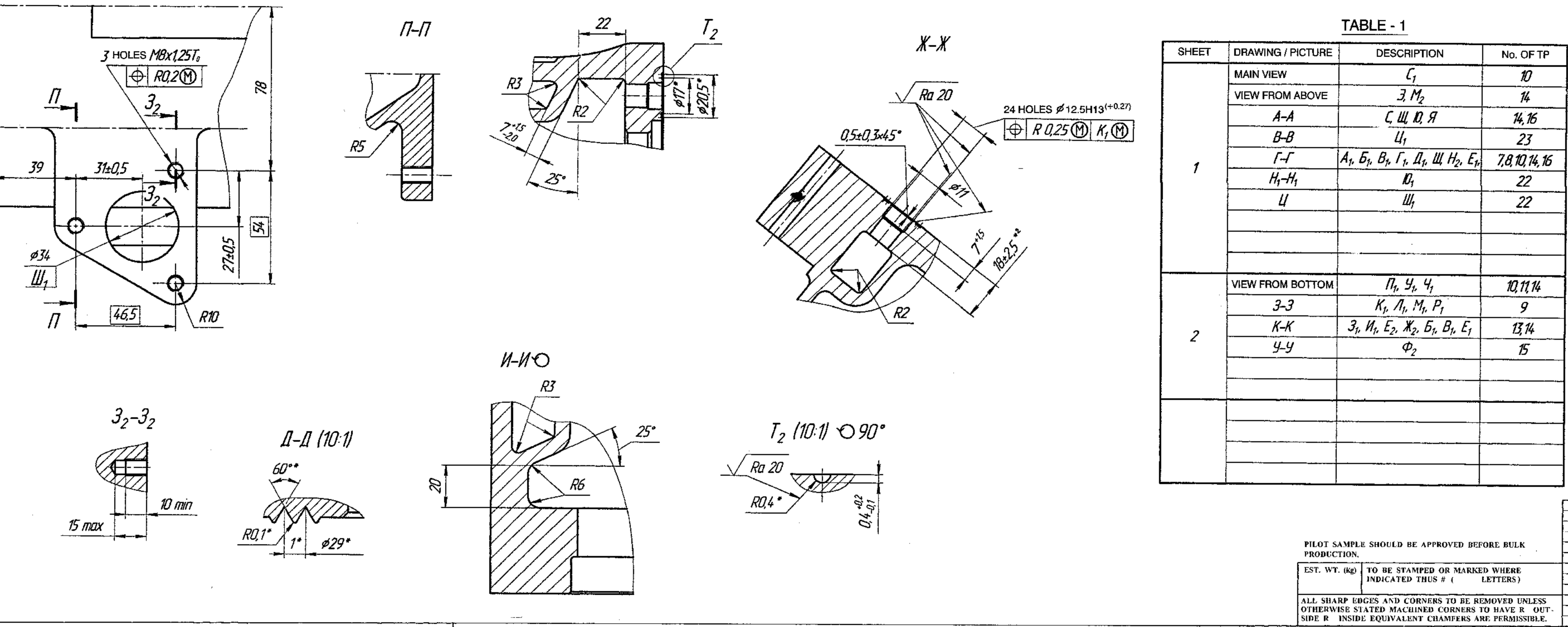
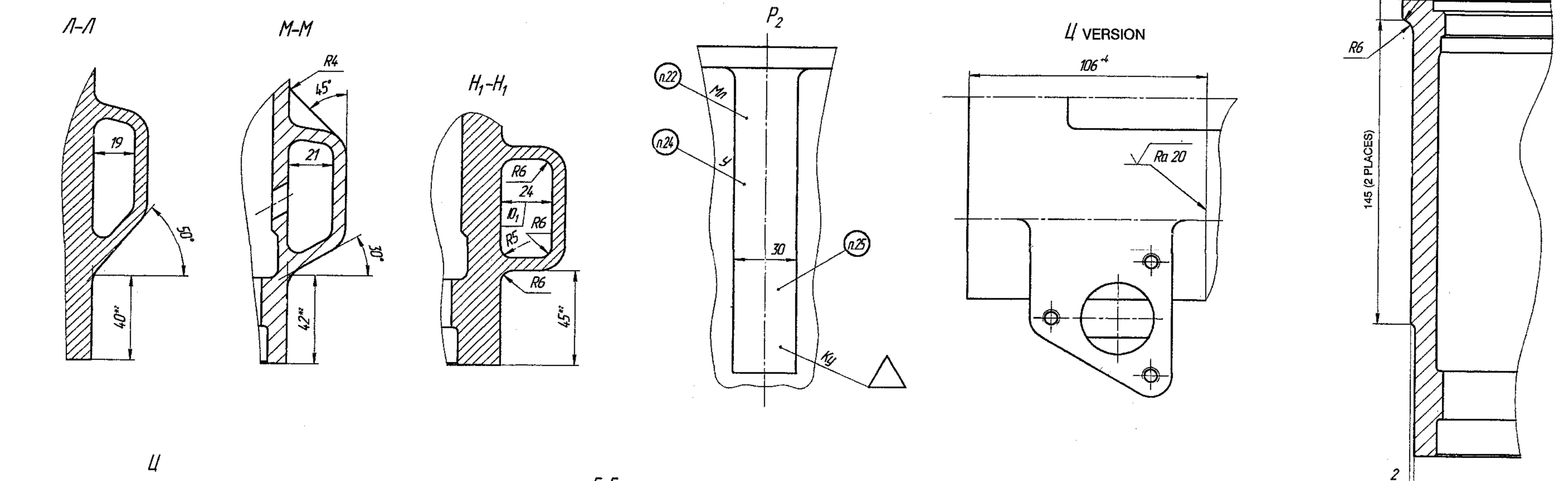
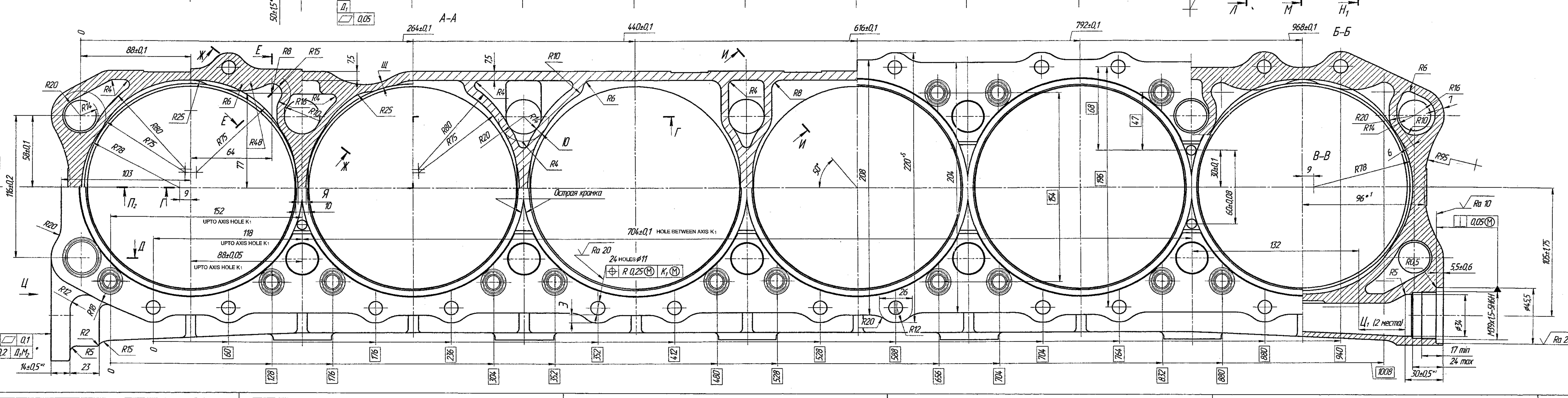
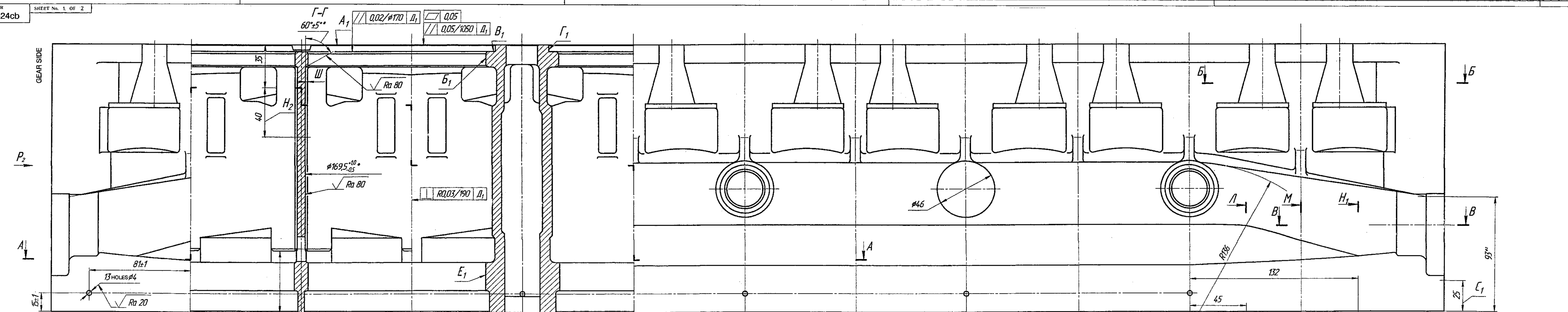


TABLE - 1

SHEET	DRAWING / PICTURE	DESCRIPTION	No. of TP
1	MAIN VIEW	C ₁	10
	VIEW FROM ABOVE	3 M ₂	14
	A-A	C, M, H, P ₁	14, 15
	B-B	L ₁	23
	F-F	A ₁ , B ₁ , B ₂ , F ₁ , H ₁ , H ₂ , E ₁	7, 8, 10, 16
	H ₁ -H ₁	H ₁	22
	L ₁	L ₁	22
2	VIEW FROM BOTTOM	H ₁ , H ₂ , H ₃	10, 11, 14
	3-3	K ₁ , M ₁ , M ₂ , P ₁	9
	K-K	3, M ₁ , E ₂ , X ₂ , B ₂ , B ₁ , E ₁	13, 14
	4-4	Φ ₂	15

- REQUIREMENTS MEANT FOR CASTING AS PER TTM-27-87.
- CASTING ACCURACY 10-0-0-10 GOST 26645-85.
- LIMIT DEVIATIONS:
THICKNESS OF WALL ± 1 mm.
MORE THAN 6 (FROM 1 TO 2) mm:
UNSPECIFIED DRAFT CASTING RADIUS ± 0.5 mm.
- AIR TIGHTNESS TEST OF WATER SPACE AND SHAFTS OF ANCHOR PINS WITH WATER AT TEMPERATURE 80°C UNDER PRESSURE 0.2^{MPa} ($2^{\text{kgf/cm}^2}$) FOR 5 MINUTES MINIMUM. LEAKAGE OF WATER IS NOT PERMITTED. AIR PRESSURE TESTING IS PERMITTED IN WATER TANK UNDER PRESSURE 0.2^{MPa} ($2^{\text{kgf/cm}^2}$). AIR LEAKAGE IS NOT PERMITTED.
- UNSPECIFIED LIMIT OF DEVIATION OF DIMENSIONS - OBTAINED REMOVED LAYER OF METAL H₁₄, H₁₄, $\pm 1/14$.
- TECHNICAL REQUIREMENTS FOR THREAD - AS PER STANDARD 82021-00.
- NON-PARALLELISM OF SURFACE A₁ AND B₁ IS PERMITTED TO CHECK IN PRESSED CONDITION.
- NON-FLATNESS OF SURFACE B₁ SHOULD BE CHECKED BY COLOUR ON FITTING BAND B₁ & E₁ AS PER INSTRUCTION M-613-85. PREPARATION AND APPLICATION SHOULD BE ACCORDING TO INSTRUCTION M-613-85. IMPRINT OF COLOUR SHOULD BE UNIFORM ON CIRCUMFERENCE AND WIDTH MINIMUM 2 mm.
- IN CASE OF PROJECTION OF SURFACE M₁ ABOVE SURFACE P₁, CARRYOUT CHECKING BY MACHINING R₂₀ DIA 28H11S¹² AT ENTIRE HEIGHT OF CASING.
- ENSURE DIMENSION H₁ NOT MORE THAN 25.5 mm AT HEIGHT C₁ FROM PLANE A₁. IT IS PERMITTED TO DRESS WITH SMOOTH SUB-OPERATION AT ENTIRE PROFILE WHILE ENSURING THE WALL THICKNESS.
- MAKE WALL THICKNESS MINIMUM 5mm AT PLACES Y₁.
- NOTCHES WITH DEPTH NOT MORE THAN 0.03mm IS PERMITTED ON SURFACES F₁, B₁ AND E₁. USE AS PER STANDARD.
- DRILL THE HOLE X₂ IN 3RD OR 4TH CYLINDER.
- IT IS PERMITTED TO CARRY OUT:
DIMENSION P₁ NOT LESS THAN 6mm, DIMENSION S NOT LESS THAN 4mm, DIMENSION III NOT LESS THAN 4mm, DIMENSION III NOT LESS THAN 1.5mm, DIMENSION H NOT LESS THAN 5.5mm, LOCAL THINNING UP TO 4mm IS PERMITTED AS PER DIMENSION K₁, DIMENSION E₂ NOT LESS THAN 4mm DURING DRILLING OF HOLE H₁.
- NOTCHES ON SURFACE A₁ AROUND 3 EXTREME ANCHOR SHAFTS S₂ AS PER SECTION A-A. DAMAGE OF SURFACE F₁ IS PERMITTED.
- THICKING OF WALL H UP TO 7.7mm IS PERMITTED ON SECTION H₂.
- ARGON ARC WELDING FOR PLUGS, ITEM No. 2. IT IS PERMITTED NON-STANDARD MANUAL ARC WELD.
- ON MACHINED SURFACES SHOULD BE TAKEN AS PER STANDARD.
- * DIMENSIONS ARE ENSURED BY TOOL.
- ** DIMENSIONS FOR REFERENCE.
- ** DIMENSION FOR CONSTRUCTION OF FOUNDARY RESIDUE.
- MARK THE MATERIAL GRADE AS PER GOST 2171-90 WITH LETTER SIZE 5-TP3 GOST 28.008-85.
- LOCATION ON L₁, SMOOTHLY CHANGE DIMENSION K₁ TO DIMENSION III₁.
- MARK BY IMPACT METHOD GIVEN ACCORDING TO INSTRUCTION TTM-27-87 WITH LETTER SIZE 5-TP3 GOST 28.008-85.
- MARK BY IMPACT METHOD 'TIO' WITH LETTER SIZE 5-TP3 GOST 28.008-85.
- LOCATION OF SPECIFIED SURFACES ARE GIVEN IN TABLE 1. DIMENSIONS S₁ AND H₁ IN TABLE 2.
- TRACE IS ALLOWED FROM TOOL YD17H12¹² mm ON THE SURFACE A₁.

PILOT SAMPLE SHOULD BE APPROVED BEFORE BULK PRODUCTION.

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

TOLERANCE ON DIMS UNLESS OTHERWISE STATED P. 280-289

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

ISSUE DATE: NATURE OF AMENDMENTS:

MATERIAL: USED ON: Cb.303-03-16

DATE: 03.09.2005

SCALE: 1:1

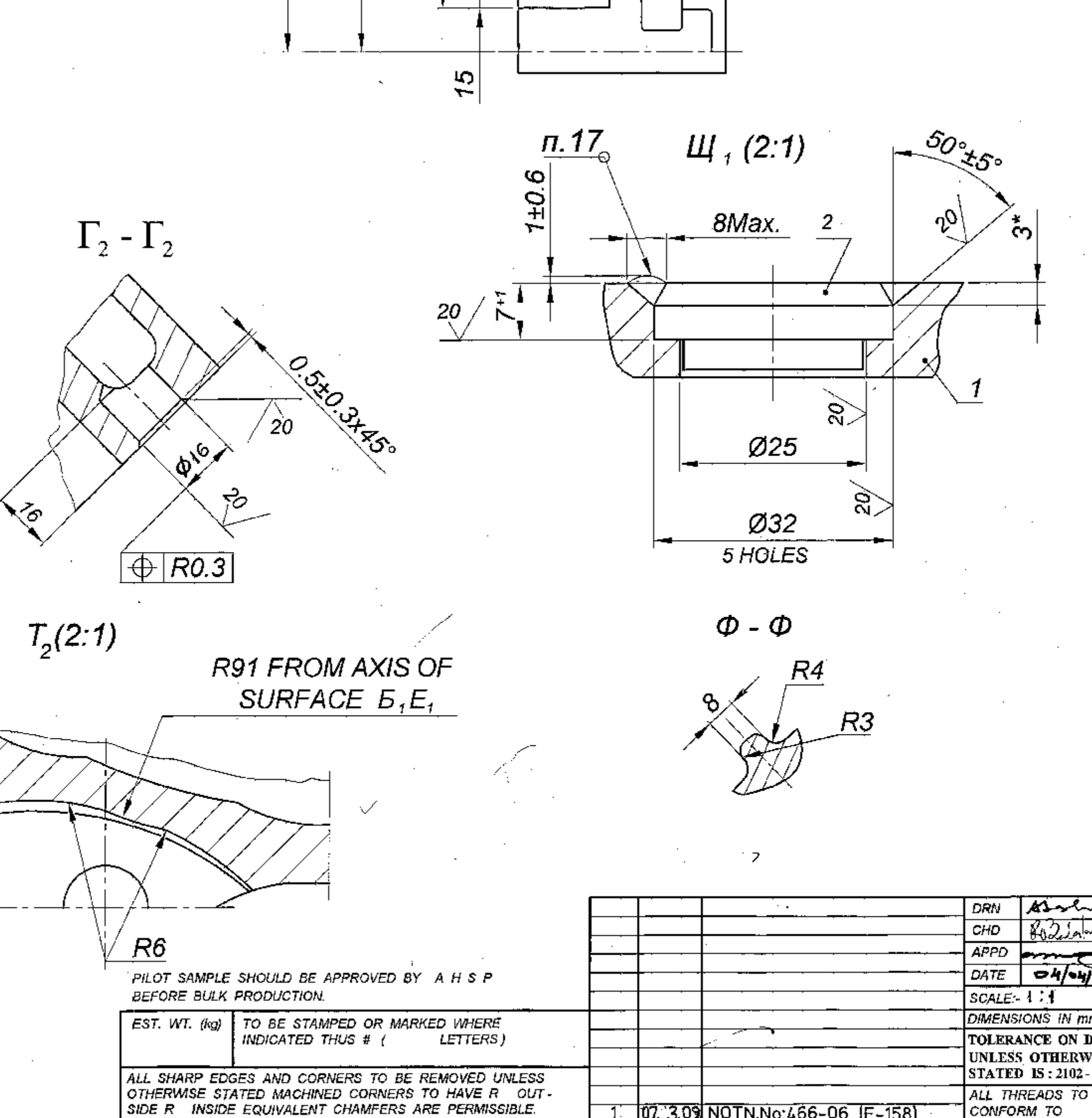
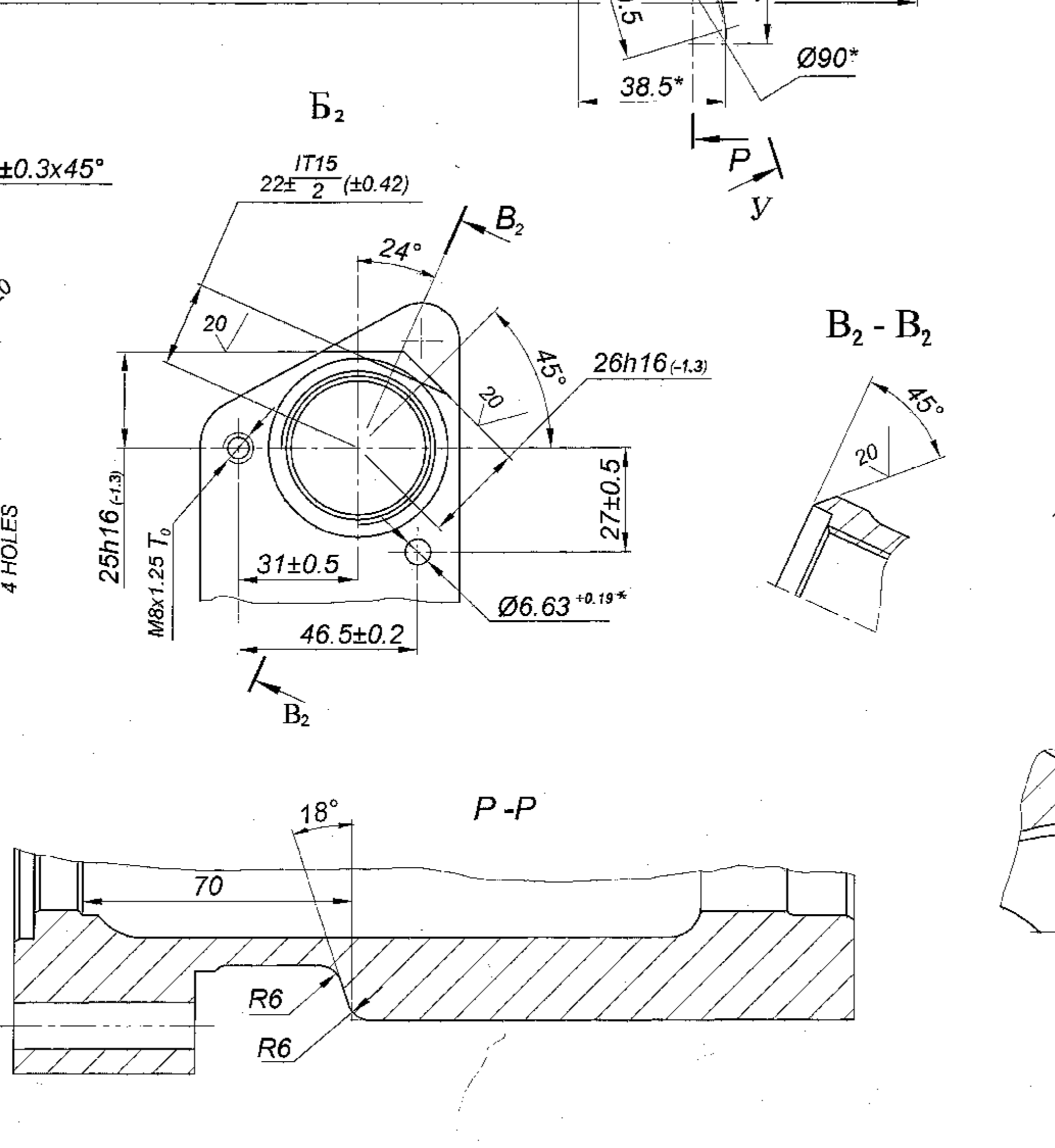
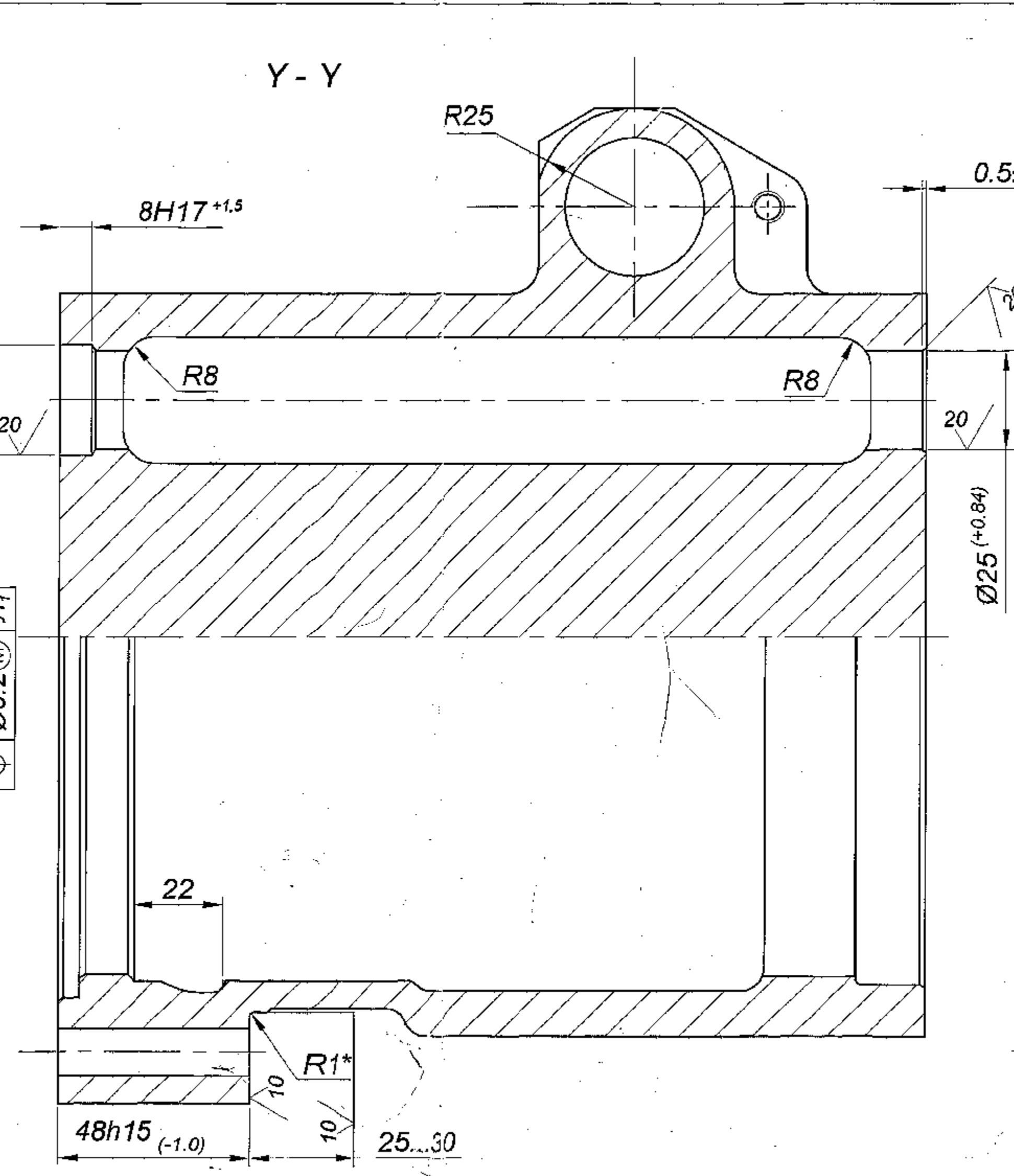
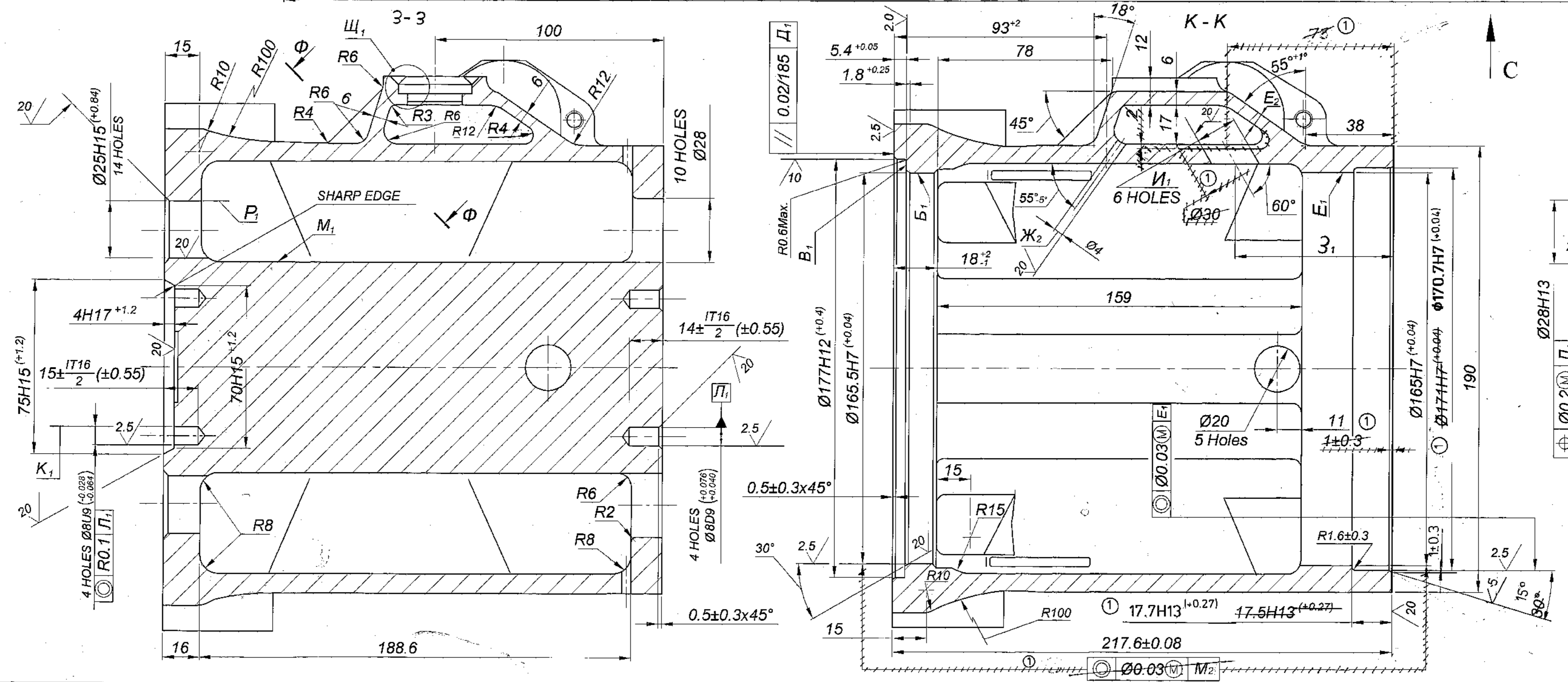
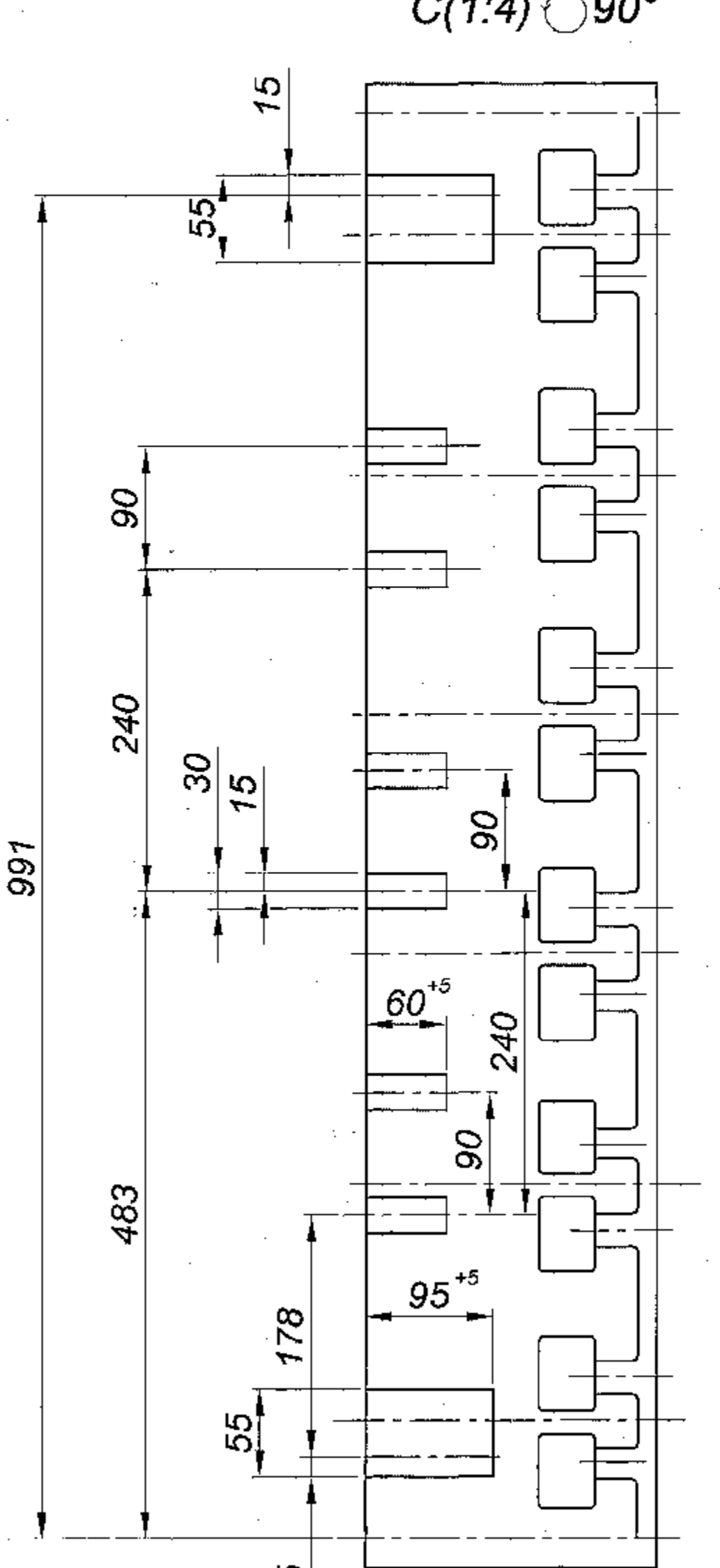
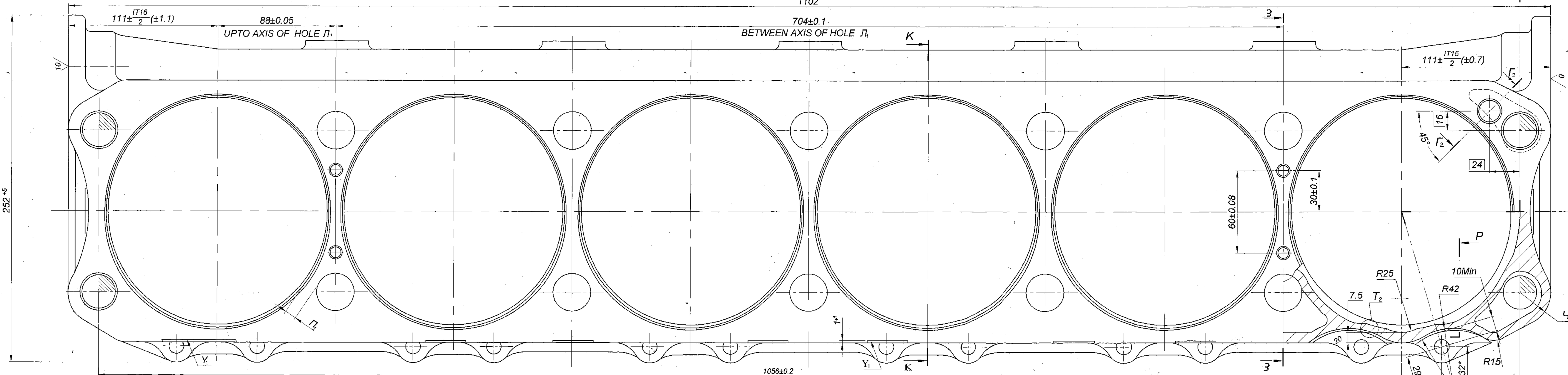
DIMENSIONS IN mm

CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES) AYADI

TITLE: CYLINDER JACKET R.H. SUB ASSY

DRAWING NUMBER SHEET 2 Cb.303-06-24cb





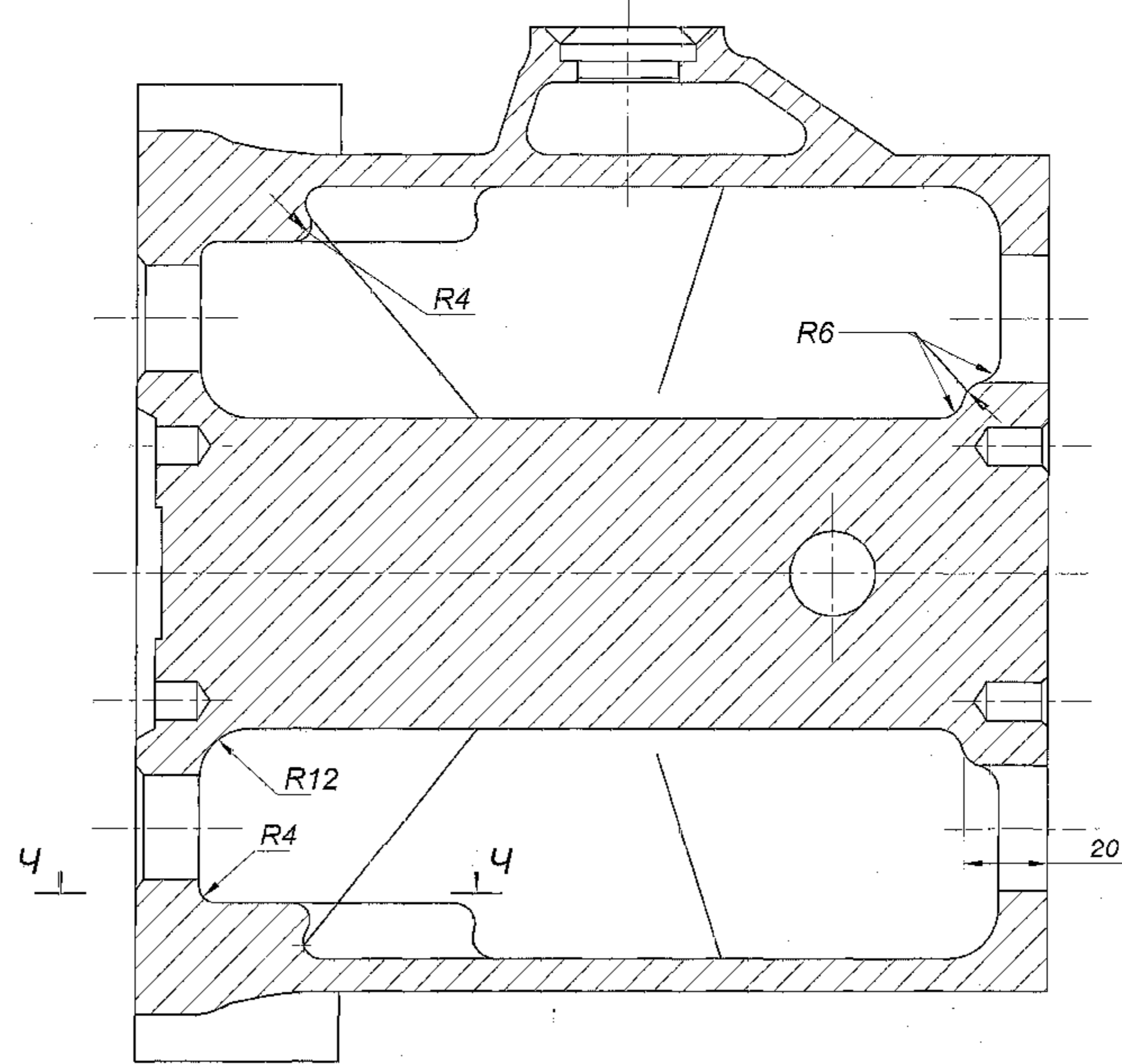
DRN: 41-1-1	MATERIAL: _____	USED ON: CE 303-03-16
CHD: 26.12.1958		
DATE: 04/10/58	CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
SCALE: 1:1		
DIMENSIONS IN mm	TITLE: CYLINDER JACKET R.H ASSY	
EST. WT. (kg) _____	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED BY THIS DR.	D S CAT NUMBER _____
TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)	ALL THREADS TO CONFORM TO _____	DRAWING NUMBER SH1 2 OF 3 Cb.303-06-24
		ISSUE DATE _____ NATURE OF AMENDMENTS _____

DRG. INDICATED BASED ON RUSSIAN ORIGINAL ISSUE - M.I.

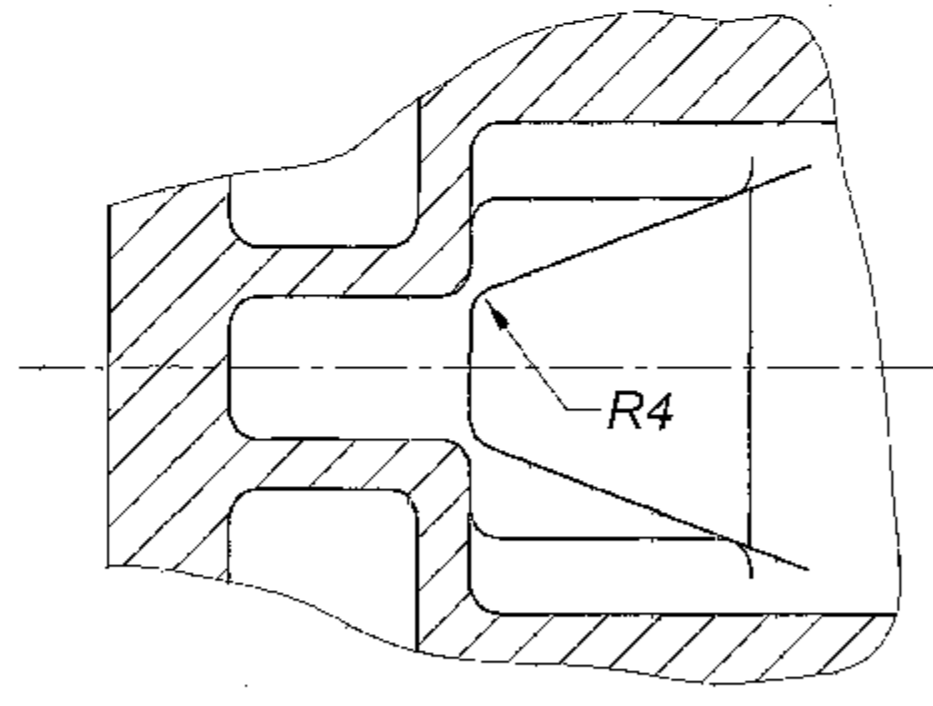
SIZE A2 x 4



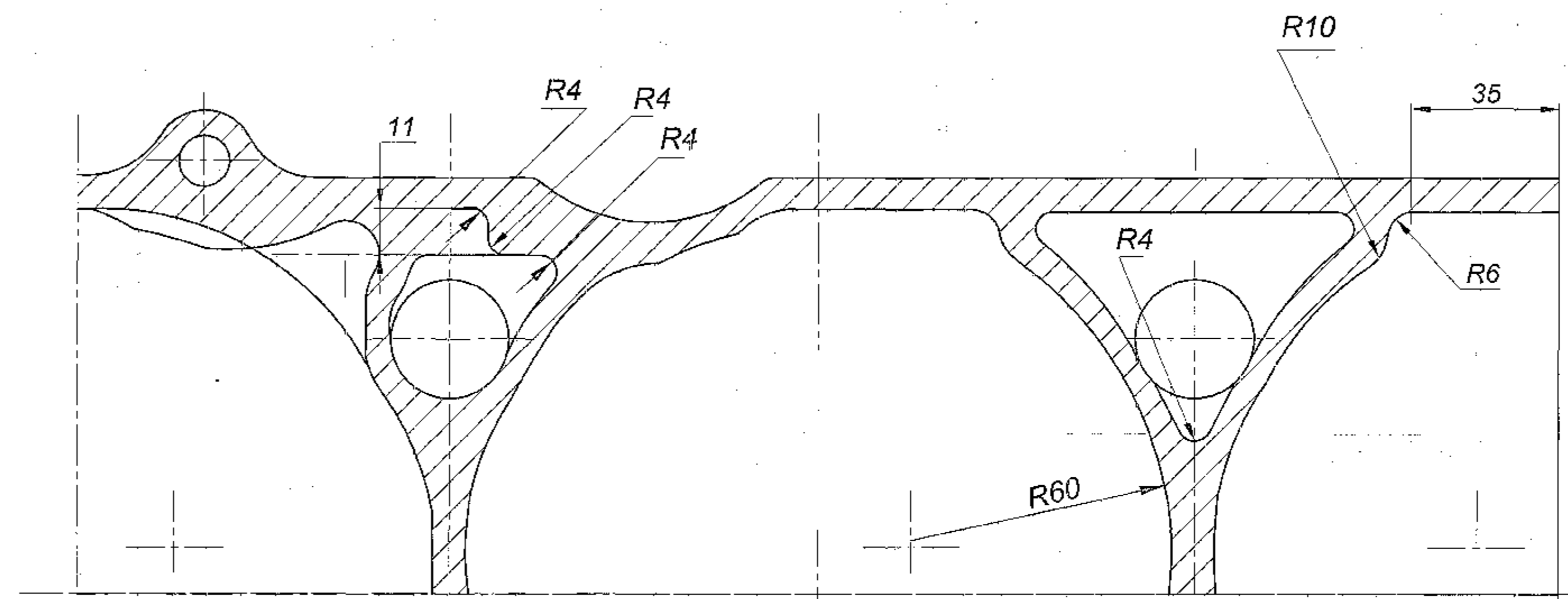
3-3 ALTERNATE



4-4



A-A ALTERNATE



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

EST. WT. 28.38 TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS).

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

DRN	CHD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 2102-69	ALL THREADS TO CONFORM TO	MATERIAL	USED ON
			02/2/82						Cb 303-03-16
					CONTROLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)		AVADI		
					TITLE		CYLINDER JACKET RH ASSY		
					D S CAT NUMBER		DRAWING NUMBER		
							Cb.303-06-24		
					ISSUE DATE		NATURE OF AMENDMENTS		

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NIL

