

GUN & SHELL FACTORY COSSIPORE KOLKATA-700 002



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HORIZONTAL BUFFER

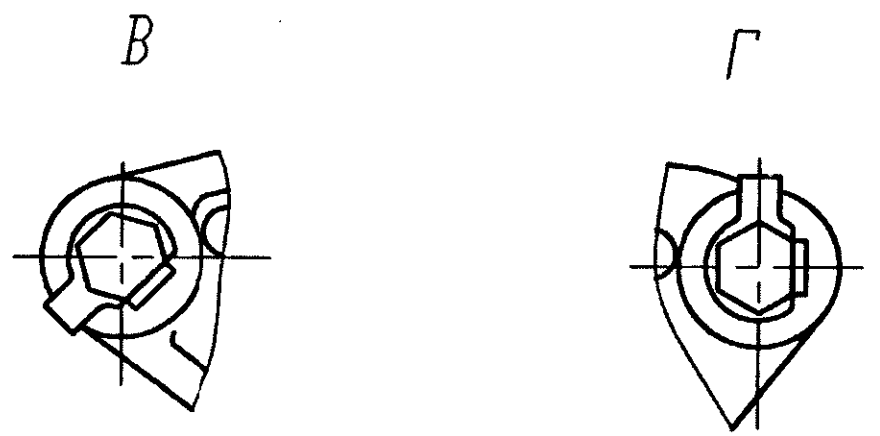
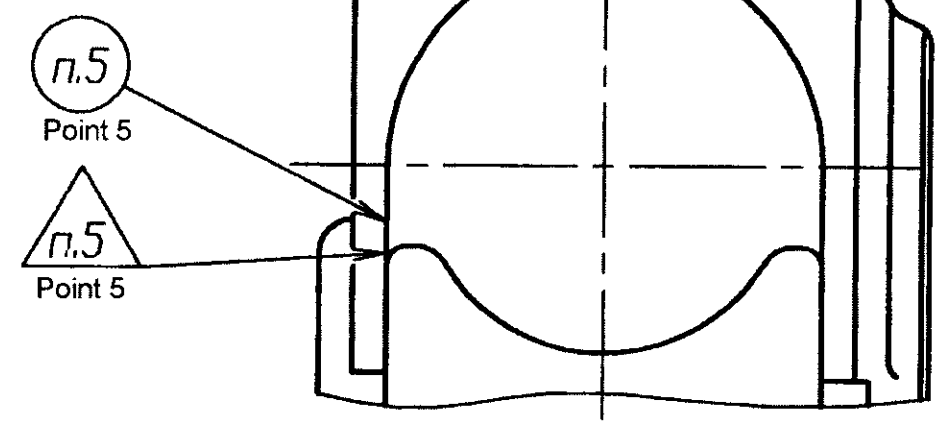
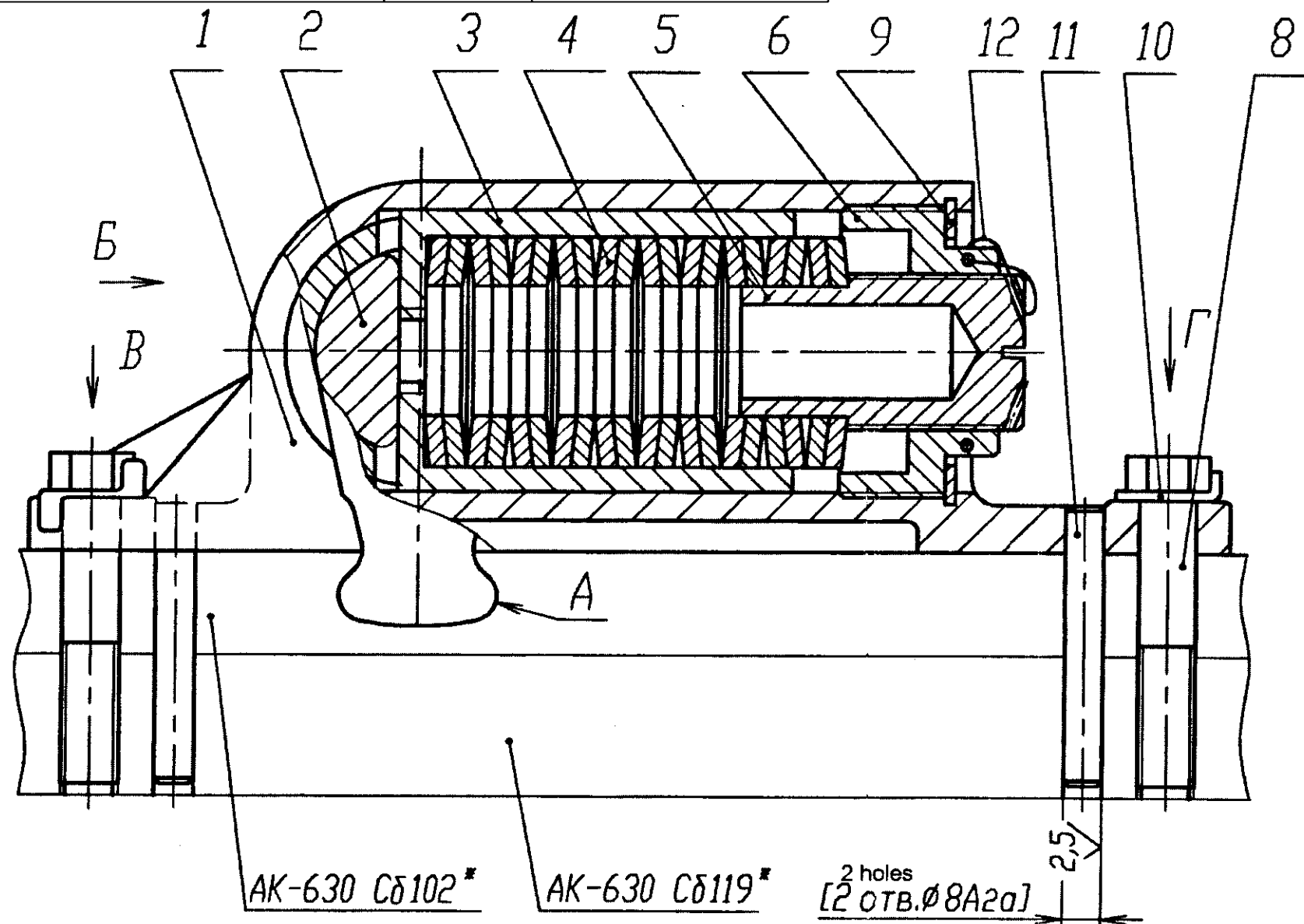


First use		Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks
						<u>Documents</u>		
Reference No.		A3	/		AK-630 Sb 120 SB	Assembly drawing		
						<u>Assembly units</u>		
		A4	/	1	AK-630M Sb 120-1	Body	1	
						<u>Components</u>		
		A3	/	2	AK-630 120-1	Lever	1	
		A4	/	3	AK-630 120-2	Cup	1	
		A3	/	4	AK-630 120-4	Disk spring	20	
		A4	/	5	AK-630 120-6	Screw	1	
		A4	/	6	AK-630 120-7	Nut	1	
Sign and Date								
Duplicate Inv. No.								
Alternate Inv no.								
Sign and Date					AK-630. Sb 120			
Orig. Inv. No.		Amend.	Sheet	Doc. No.	Sign	Date		
		Developed by				Type	Sheet	Sheets
		Checked by				A	1	2
		Head of Q.C.D				Horizontal buffer		
		Approved by						

AK - 630 SB 120 SB

First use
Reference No.

Sign and Date
Duplicate Inv. No.
Alternate Inv. No.
Sign and Date
Orig. Inv. No.



1. * Articles for reference.
2. Clearance of point A of lever pos. 2 should be in limit 0.05 ... 0.3 mm . Ensuring it by adjusting screw pos. 5 .
3. Machine on dimension in square brackets together with AK-630 SB 102 and AK-630 SB.119 in AK-630 SB 00.
4. Apply lubricant MS-70 GOST 9762-76.
5. Mark Ч,Н,Ha - unit no. and stamp K as AK-630 , AK-630M TU 1.

					AK - 630 SB 120 SB			
Amend	Sheet	Doc. No.	Sign	Date	Horizontal buffer Assembly drawing	Type	Weight	Scale
							A	4.490
Developed by						Sheet		
Checked by						Sheets 1		
Technician								
Head of QCD								
Approved by								

AK-630 120-7

First use

Reference No.

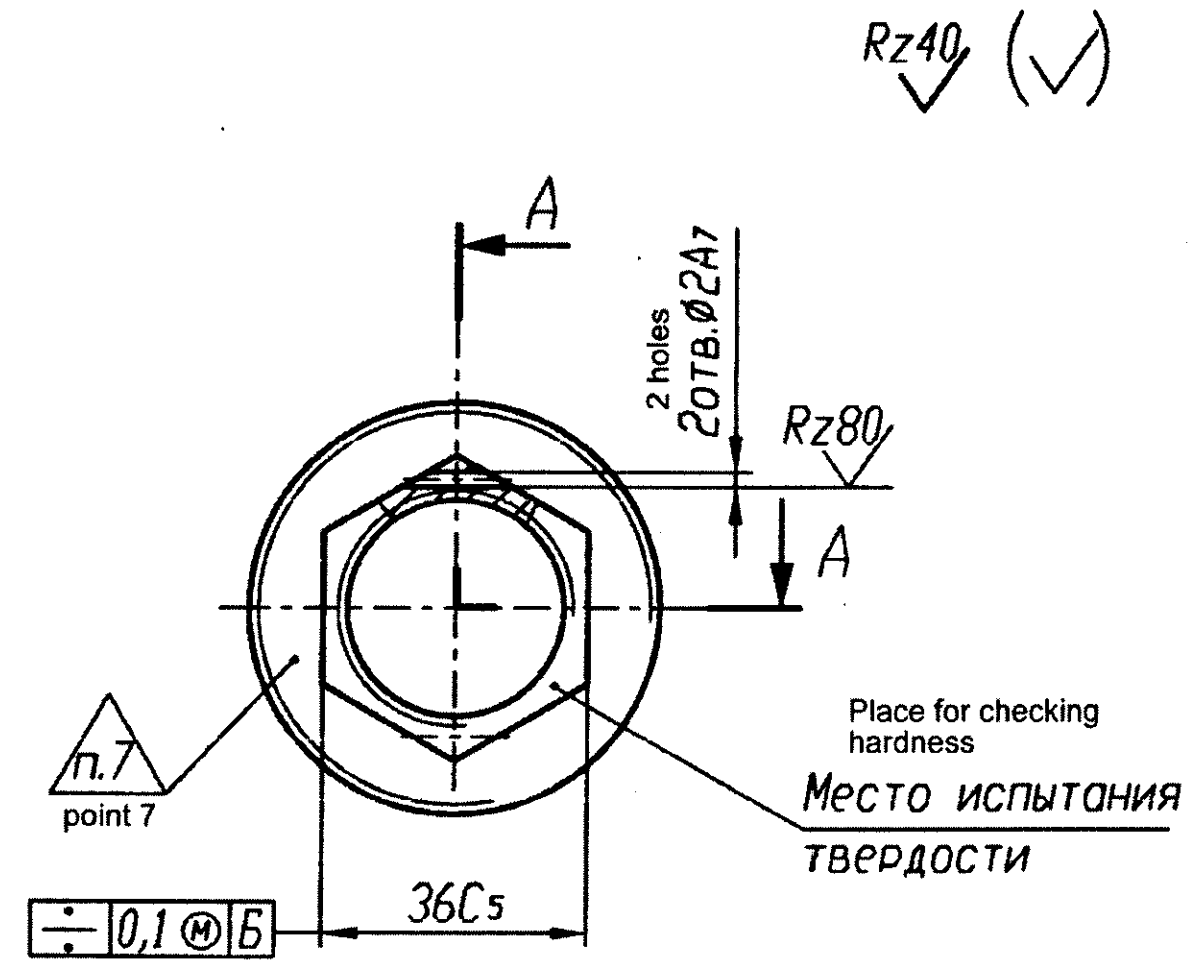
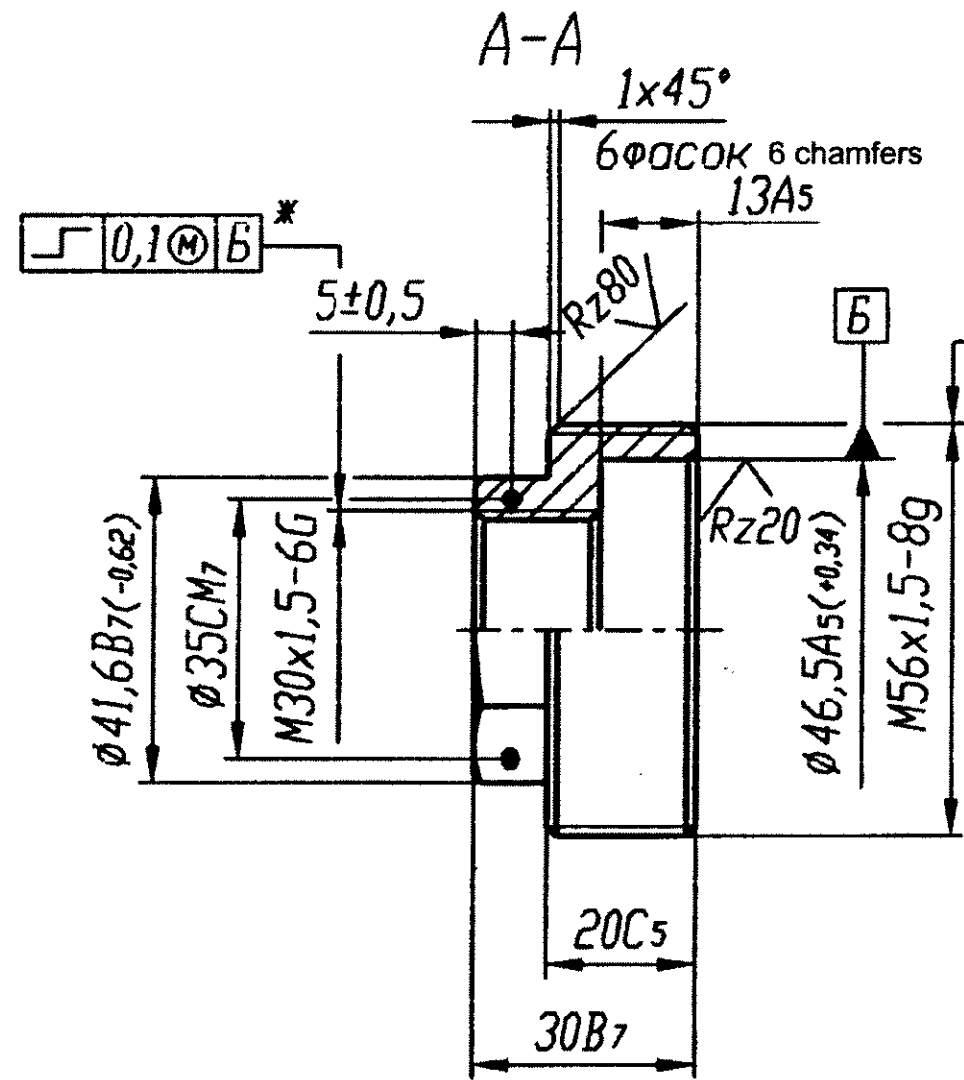
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz40 (✓)

1. Substitute material- Steel 65S2VA-Sh OST 3-98-80.
2. 46.5..52.5 HRC_E.
- 3.* Dimensions ensured by tool.
4. Inner angles R~0.2 mm.
6. Coating Cd6. phos.oil.
7. Stamp K, И as per AK-630, AK-630M TU I.
8. Mark Ш,Ч on tag.

					AK-630 120-7			
Amend.	Sheet	Doc.No.	Sign	Date	Nut	Type	Weight	Scale
Developed by						A	0.160	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D						Steel 65 S2 VA GOST 14959-79		
Approved by								

AK-630 120-4

First use

Reference No.

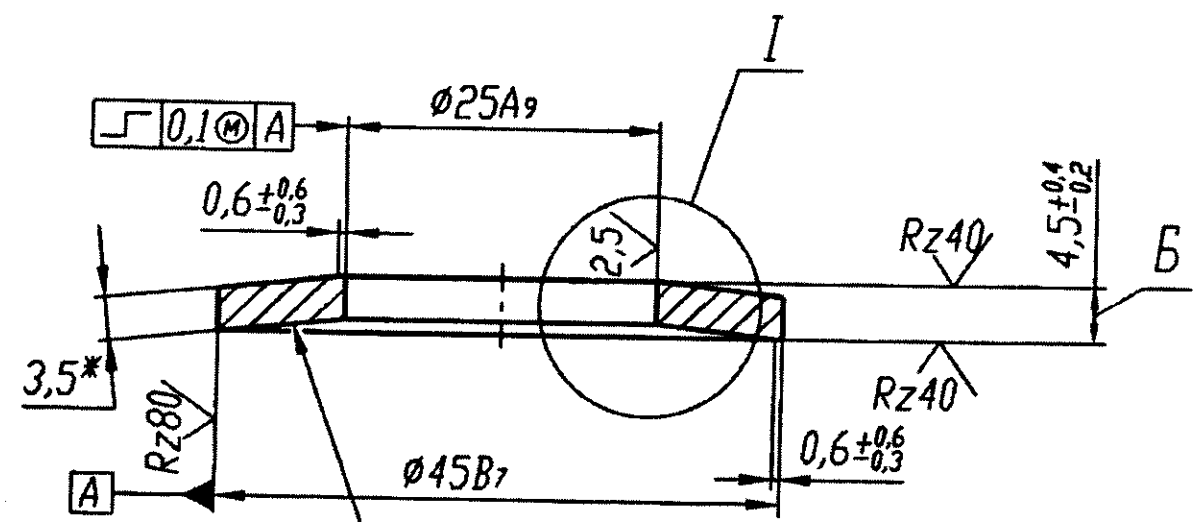
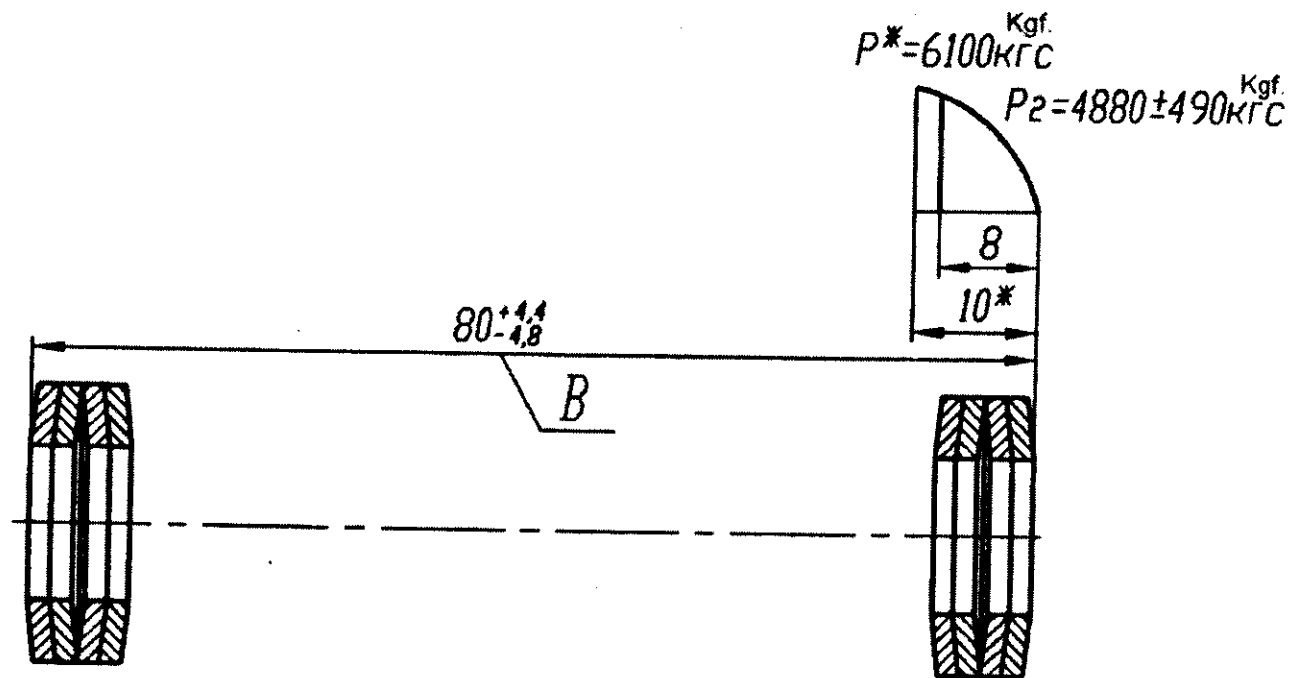
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Duplicate Inv. No

Alternate Inv. No

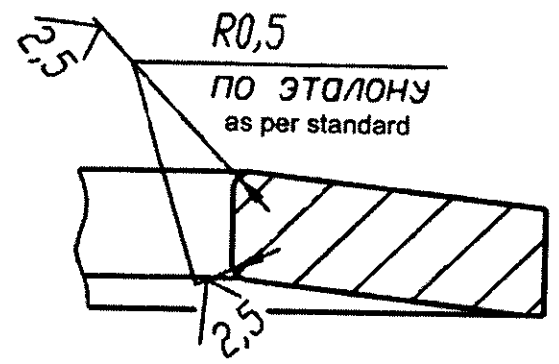
Sign and Date

Orig. inv. no.



Место испытания
ТВЕРДОСТИ
Place for checking
hardness

1(5:1)



1. Substitute material- multi leaf spring strip steel A $\frac{4.0 - 60VGOST7419 - 74}{65S2VAGOST14959 - 69}$ or sheet 4 65S2VA TU 14-1-723-73 with finish grinding to dimension $3.5_{-0.15}$ from two sides $^{1.25}\sqrt{\quad}$.
2. 47.5...51.5 HRC_E. Burying is permissible up to 0.1 mm at place of grinding for checking hardness.
3. $E^* = 20\ 000\ \text{kgf/mm}^2$, $\sigma^* = 323\ \text{kgf/mm}^2$.
4. Number of springs in set of Belleville springs $n = 20$.
5. Set assembled from components with dimension B, should have height of set within range of dimension B.
- 6.* Dimensions and parameters for reference.
7. Blunt sharp edges $\sim 0.4 \dots 0.6$ mm ensured by tool.
8. Brightening of surfaces after pre deformation is permissible.
9. Coating Chem.phos.accel.
Lacquer BF-4 with Nigrozene 2 layers, made as per OST 3-4123-78 IV, OM2.
10. Other technical requirements as per GOST 3057-90.
11. Mark set of springs with Ш, Ч and stamp K, И on tag. Use in set.

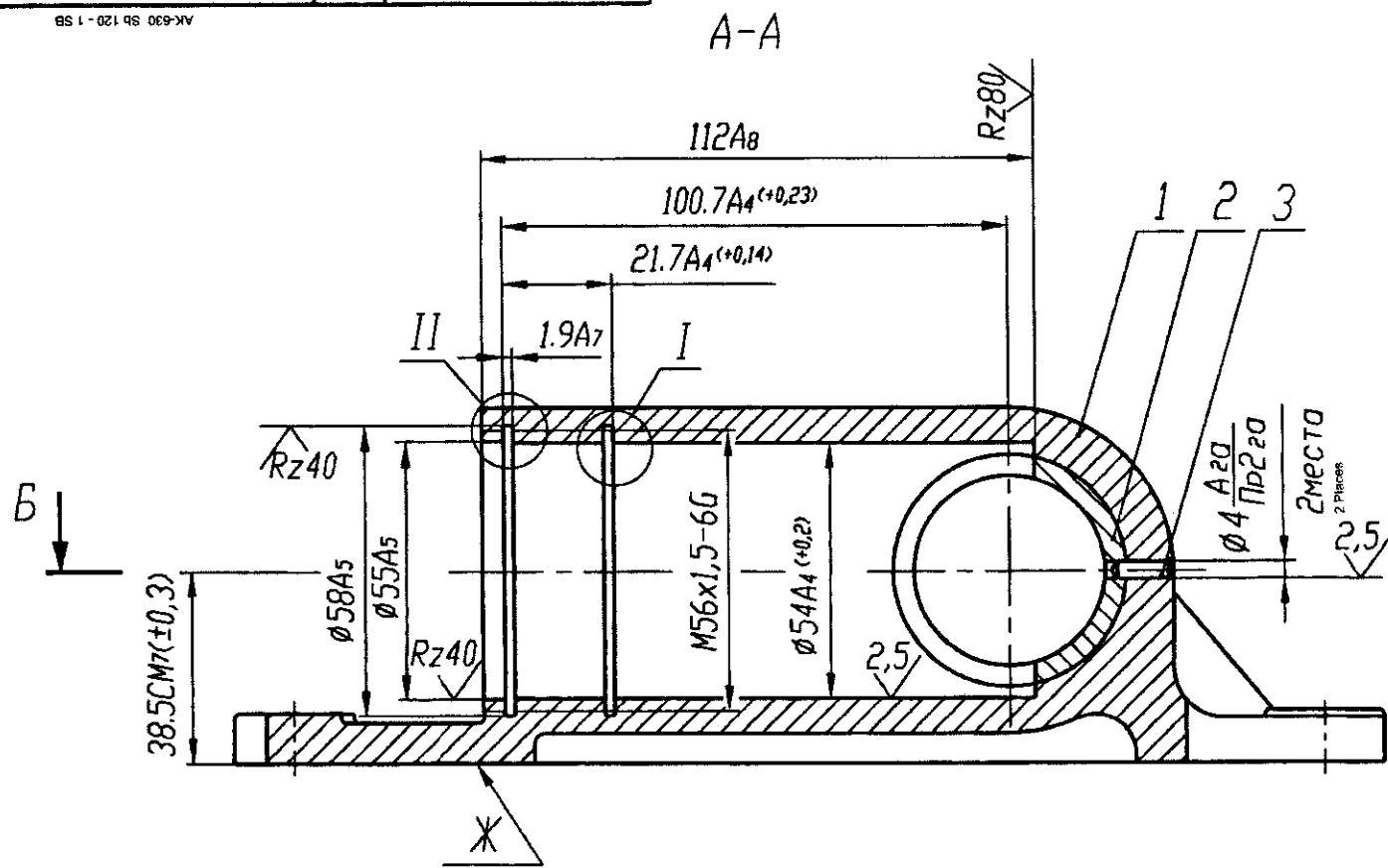
					AK-630 120-4			
Amend.	Sheet	Doc.No.	Sign	Date	Belleville spring	Type	Weight	Scale
Developed by						A	0.018	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Multiple leaf spring strip steel A $\frac{3.5 - 60VGOST7419 - 74}{65S2VAGOST14959 - 69}$			
Approved by								

AK-630 120-2						
Approved OGMet	Sign and Date	Approved TOSb	Sign and Date	Approved KTONI	Sign and Date	
Orig. Inv. No.	Alternate Inv. No.	Dupl. Inv. No.	Reference No.	Approved by shop	First use	
<p>Место испытания ТВЕРДОСТИ Place for checking hardness</p>						
<ol style="list-style-type: none"> 1. Substitute material- Steel 65S2VA-Sh OST3-98-80. 2. 46.5...52.5 HRC_E. 3. Blunt sharp edges ~0.4 mm. 4. Coating Cd6.phos.Oil. Decrease in cadmium layer on inner surfaces is permissible. 5. Mark Ш, Ч and stamp К, И on tag. 						
AK-630 120-2						
				Type	Weight	Scale
Sleeve				A	0.460	1:1
				Sheet	Sheets 1	
Steel 65S2 VA GOST 14959-79						
Approved by						

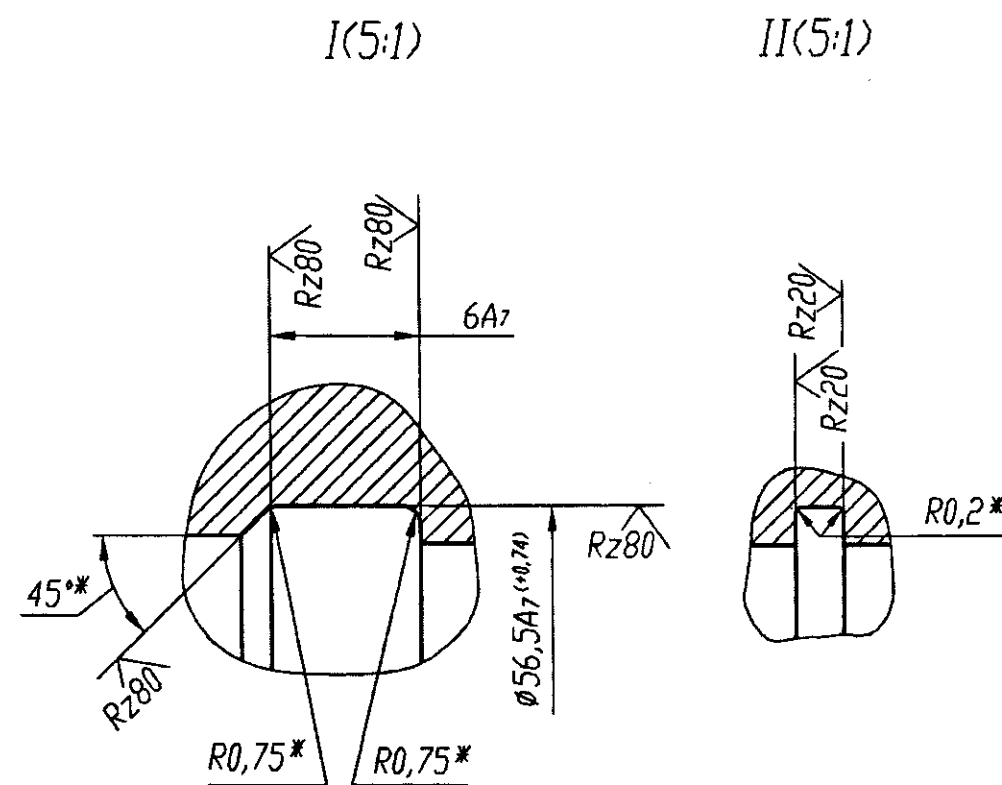
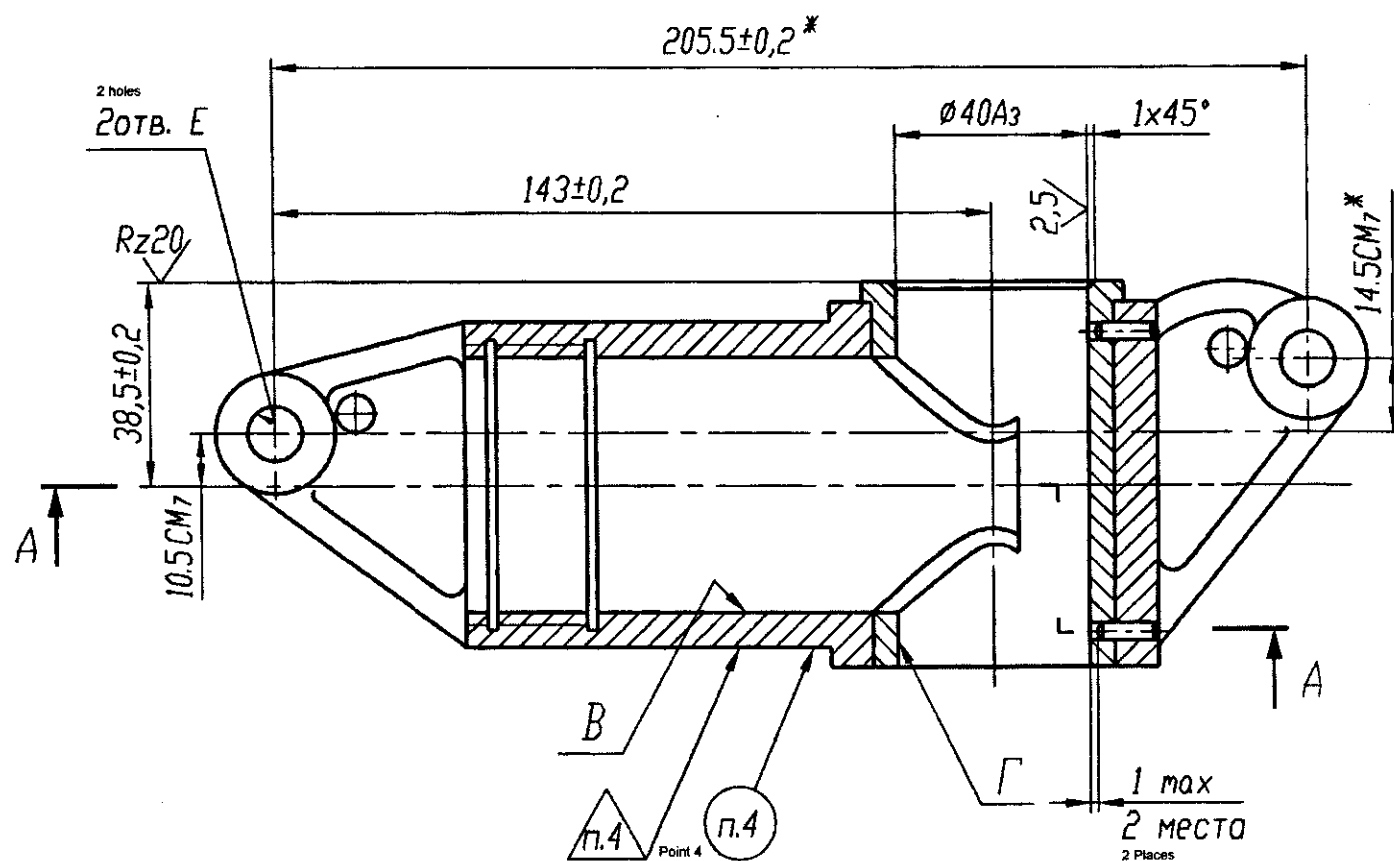
Copied by

Format A4

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A2	✓		AK-630 Sb120-1SB	Assembly drawing		*)A4x3	
					<u>Components</u>			
	A2	✓	1	AK-630 120-8	Body	1		
	A4	✓	2	AK-630 120-9	Bush	1		
					<u>Standard articles</u>			
			3		Pin 4Pr22ax 10.40Kh	2		
					K38.5..45.5 HRC Chem.phos.Oil.			
					OST 3-2234-93			
Sign and Date					AK-630 Sb 120-1			
	Amend.	Sheet	Doc. No.	Sign	Date			
Orig. Inv. No.	Developed by				Body	Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D							
	Approved by							
Sign and Date								
Alternate Inv. No.								
Dupl. Inv. No.								



Б-Б



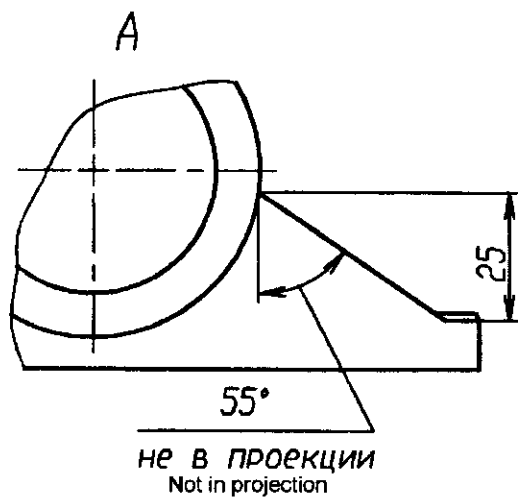
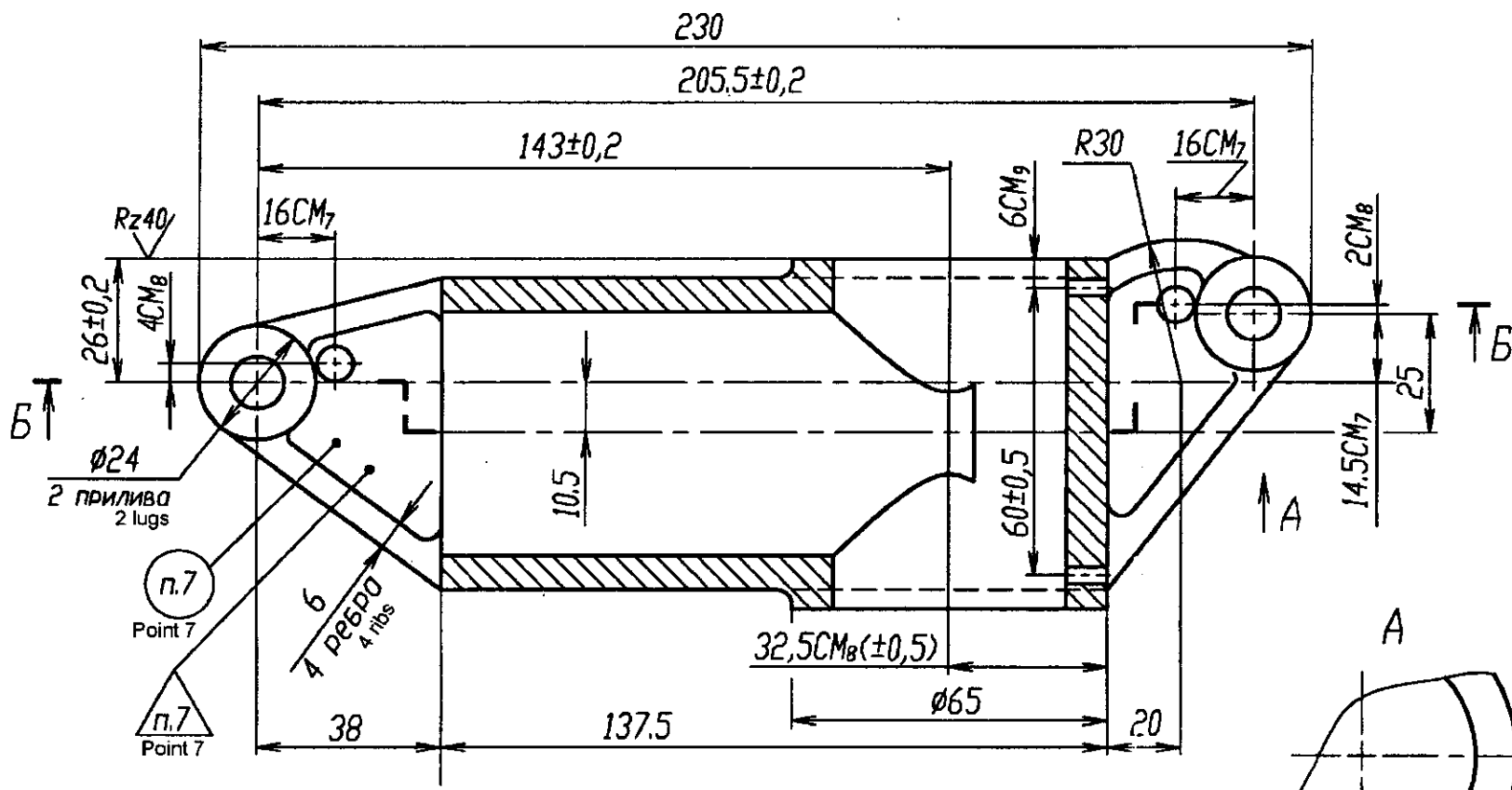
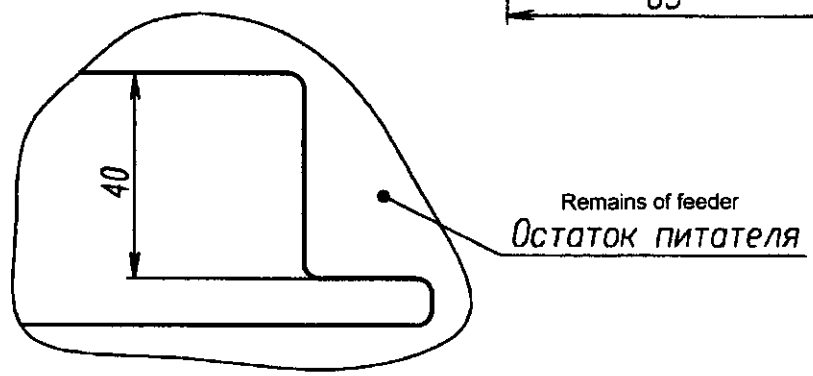
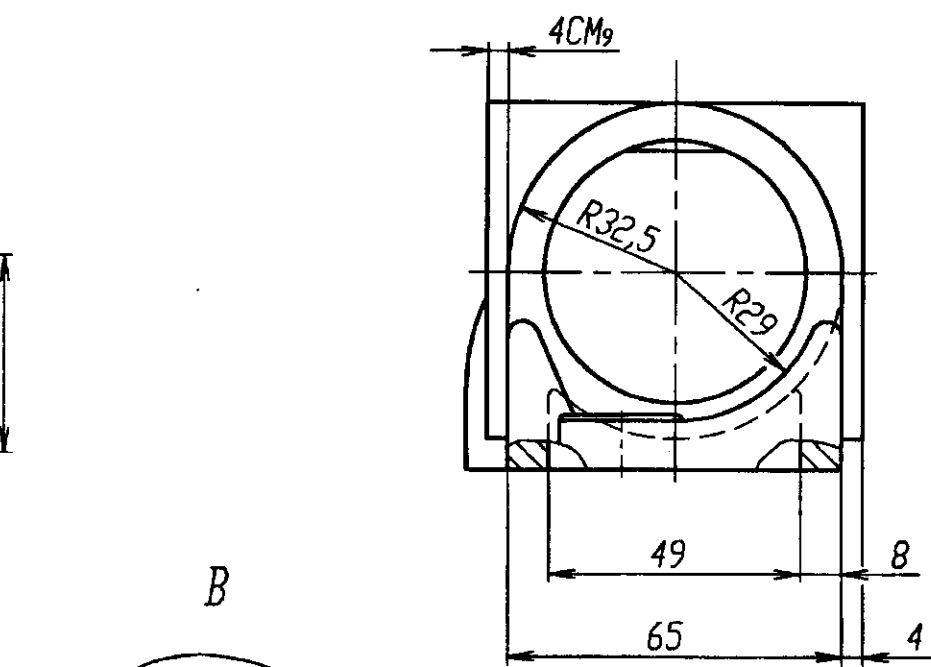
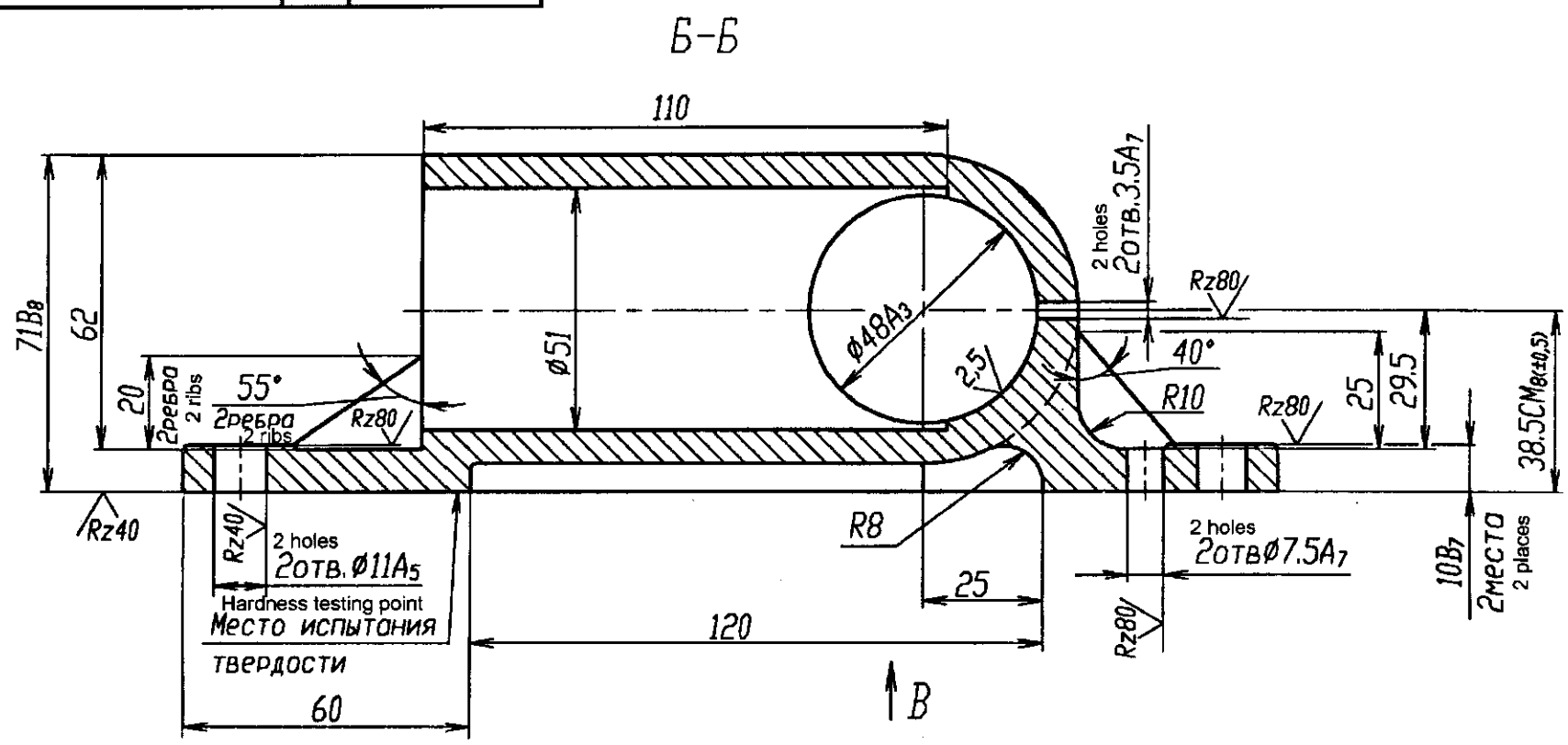
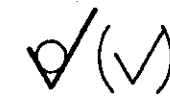
1. *Размеры обеспеч. INSTR.
2. Неперпендикулярность оси отв. Г относительно оси отв. В не более 0,1 мм.
3. Покрытие отв. В, Г, Е и плоскости Ж - Кад12. фос. остальных поверхностей - Кад12. фос. Грунтовка АК-070, желтая(2) Эмаль ХВ-124, серая(4) ,IV, OM2 . АК-070 ГОСТ 25718-83 ХВ-124 ГОСТ 10144-89
4. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ I.

1. * - Dimensions are ensured by tool.
2. Non-perpendicularity of the axis of hole Г in relation to the axis of hole В is not more than 0.1 mm.
3. Coating of holes В, Г, Е and plane Ж - Cad. 12 phos. and other surfaces - Cad 12 phos. Primer АК - 070, yellow (2) Enamel KHV-124, gray (4), IV, OM2. АК-070 GOST 25718-83. KHV-124 GOST 10144-89.
4. Mark Ш, Ч and stamp К as per АК - 630, АК - 630М ТУ I.

AK-630 Sb 120 - 1 SB

AK-630 СБ120-1СБ		Type	Mass	Scale
Корпус		Лит.	2,800	1:1
Сборочный чертёж		Лист	Листов 1	
Assembly drawing		Sheet	Total Sheets	

Лев. лимен.
Слов.
Изм. и дата
Изм. и дата
Изм. и дата



1. Cast accuracy 9T-0-0-8 GOST 26645-85.
2. Surface finish the casting surface as per test specimen .
3. Draft as per GOST towards exceeding dimensions .
4. Casting radius $R \leq 3$ mm.
5. 38.5 ... 44.5 HRc.
6. Blunt sharp edges ≈ 0.4 mm .
7. Mark Ш, Ч, П and stamp К, И as per AK-630, AK-630M TU 1 .

First remarks
Refer. No.
Sign and Date
Duplicate Inv. No.
Alternate Inv. No.
Sign and Date
Inv. No.

				AK-630 120-8			
Amend Sheet	Doc. No.	Sign	Date	Body	Type	Weight	Scale
Developed by					A	2.400	1:1
Checked by					Sheet	Sheets 1	
Technician							
Head of QCD				Cast	K30-II OST3-4365-79 50L-GOST 977-88		
Approved by							

