



1. Check dimension U in brackets pos. 8 and 9 at top end position of bracket handle pos. 6 and 7; is ensured by adjustment of link pos. 11, 12, 13, 14.
2. Pin (refer view Γ) thread joints in link pos. 11, 12, 13 and 14 after adjusting as per length.
3. Surface u of body should be uniform, without cuts and projections; end should be in conformity with standard. During closing of cover after operation of slide pos. 58, should be ensured by tight fitting of packing to surface u of fairing body, which controls for clearance. It is permitted to file surface u and pasting on it of glass cloth grade T-10/2-0 (100) GOST 19170-2001 with poly ether resin grade PN-1 or PN-3 GOST 27952-88 with 2% additive of aluminum powder PAP-1 or PN-3 GOST 5494-71 following dressing for ensuring mentioned requirements. Carry out pasting of packing with cover by glue 8-NP TU 38-105.540-85. Using of glue 88-SA TU 38105 1760-89 is permissible.
4. Fairing cover should lock with locator AK-630 113-50 opened up to extreme top. During movement of cover down, lower end of cylinder pos.2 should not jam with fairing body.
5. Cylinder pos. 2 should lock with slide pos. 38 during pressing on button pos. 39 till stop.
6. Ring pos. 17 should fit to mask Sb.103 with tensile not less than 1 mm in assembled article.
7. Cutting and shortening of ring in conformity with length of groove contour of fairing body is permissible during placement of it.
8. Carry out shortening of ring from maximum rough section of working surface. Mating should be positioned from any side of groove in zone "ab" (refer M-M).
9. Paste ring pos. 17 and cord pos. 18 at places of mating through insert with glue 88-NP TU 105-540-85. Cuts should not be present on mating places.
10. Mating of packing pos. 31 should be positioned in lower part of cover of fairing pos. 21 angle cut end 45°; carry out pasting with glue 88-NP TU 38.105.540-85. Using of glue 88-SA TU38.105 1760-89 is permissible.
11. Point outer places of surfaces of body pos. 20 and cover of fairing pos. 21 rubbed in process of assembly and testing with resin grade PN-1 or PN-3 with additive aluminum powder with color with remaining surfaces and enamel KhV-124, grey (4), IV, OM2, KhV-124 GOST 10144-89 before sending.
12. Absence or placing of plates pos. 45 and 46 not more than two pieces for ensuring assembly of bracket pos. 6, 7, 8 and 9 with locking bolts of components 119-4 is permissible between fairing wall and bracket.
13. Gap u between locking pos. 26 and 27 is permissible.
14. Application of putty EP-0010 GOST 28379-89 on all components set on fairing body except components and assemblies pos. 15, 17, 18, 24, 25, 26, 27, 28, 30 and cutting of inner surfaces of fairing body with set components following lubrication with poly ether composition with chrome oxide is permissible.
15. Paste shaping strip made of glass cloth grade T-10/2 with poly ether resin of grade PN-1 or PN-3 with 2% additive of aluminum powder after final assembly of fairing with fairing cover along contour "BГД". Pasting and machining of outer surfaces as per standard (refer sub-assembly 11 sheets 2). Carrying out of moulding of shaping strip in cover comp. 113-2 together with pasting of shaping strip after final assembly of fairing along contour "BГД" is permissible.
16. Deviation of surfaces u and Э of brackets from minimum position should not be more than 0.3 mm.
17. Reference dimension.
18. Article for reference.
19. Misalignment of hole Γ , in relation with hole Δ , should not be more than 0.2 mm in loop AK-630 sb.113-53 fastened on fairing body. Application of poly ether resin on loop for ensuring mentioned requirements; and for surfaces B, and B₁ and clearing and pasting with glass cloth poly resin following cleaning is permissible.
20. Split cotter pin in Sb.113-53 finally in Sb.113 Sb.
21. Placing of rivet pos.84 is arbitrary.
22. Lubricate base pos. 1 and bracket with plate pos. 4 along fitting contour with poly ether composition with chrome oxide flush with inner plane of fairing.
23. File flush with Rz 80, projection of rivet pos. 85 is not permissible.
24. Spill cotter pin in Sb.113-53 finally in Sb.113 Sb.
25. Gaps in joints should not be less than 5 mm during assembly of shaping strip of components 113-5. Cutting of shaping strip and drilling of holes $\text{Ø}4.3 \text{ A5}$ for obtaining gaps is permissible.
26. Fill gaps between fairing body of component pos. 20 and components pos. 26, 27 with epoxy compound ES-3P OST V84-167-90.
27. Coating of inner surfaces, except mating end-fitting place of metallic components and rubber packing Real shielded suspension TPK 2 OST 3-1545-84, 1 layer, outer surfaces, filed faces of screws pos. 68, 69 and nut pos. 75.
28. Primer AK-070, yellow (2).
29. Enamel KhV-124, grey (4), IV, om, AK-070 GOST 25718-83, KhV-124 GOST 10144-89.
30. Using of composition OS 11-07 TU 84-725-95, 1 layer for coating inner surfaces, except mating and fitting place of metallic components and rubber packing surfaces is permissible.
31. Mark u , ч , H, Ha - aggregate number of article and stamp K as per AK-630, AK-630M TU 1.

| AK - 630 Sb 113 SB | | | | | | |
|--------------------------|-------|----------|------|----------------|--------|-------|
| Amend. | Sheet | Doc. No. | Sign | Date | | |
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| Fairing Assembly drawing | | | | Type | Weight | Scale |
| | | | | A | 63.0 | 1:4 |
| Technician | | | | Sheets 2 | | |
| | | | | Head of Bureau | | |
| Head of O.C.D | | | | Approved by | | |
| | | | | Approved by | | |