

USED ON
54 83 78
C5-A

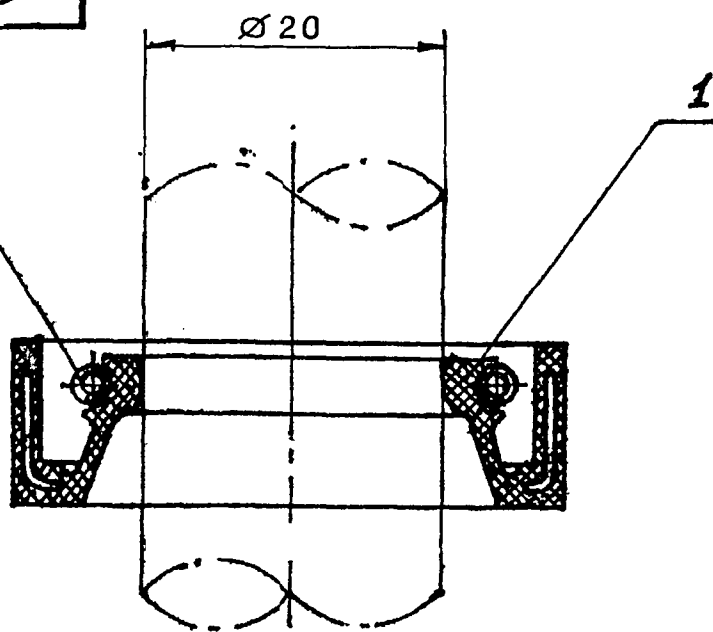
WILL RE-CREATED BASED ON RUSSIAN ORIGINAL ISSUE: -NIL

[illegible]

KVD No. 73147

DRG RE-INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE: 2.

DRAWING NUMBER
54 83 8 C5



1 BEFORE ASSEMBLING, THE SPRING ENDS SHOULD BE
SCREWED ONE IN TO ANOTHER NOT LESS THAN BY 3 TURNS.

F 155

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

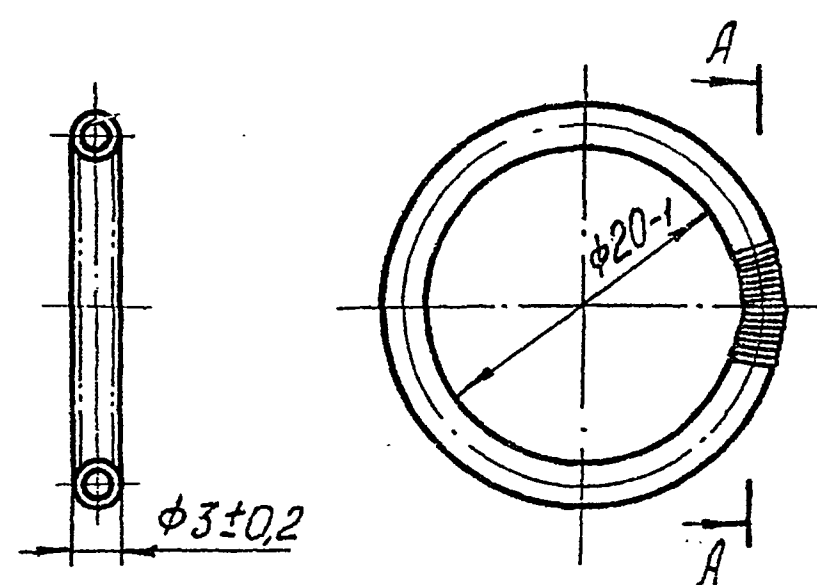
		EST. WT. 0.011	TO BE STAMPED OR MARKED WHERE INDICATED THUS ≠ (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT- SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
		MATERIAL:- —	USED ON 54 83 78 C5-A
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN <i>Chanchal</i>		SCALE:- 2:1 DIMENSIONS IN mm	
CHD <i>Chanchal</i>		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.	
TCD <i>Chanchal</i>		TITLE OIL SEAL ASSY	
APPD <i>Chanchal</i>		D S CAT NUMBER	DRAWING NUMBER 54 83 8 C5
DATE 16-12-98		ALL THREADS CONFORM TO	

SIZE A4

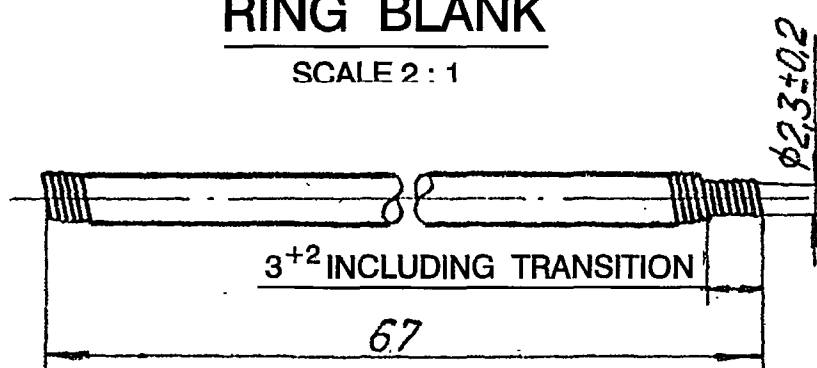
DRG. RE-INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE-6
COMPARED WITH ORIGINAL DRAWING
26-04-05

F-157
SIZE A2

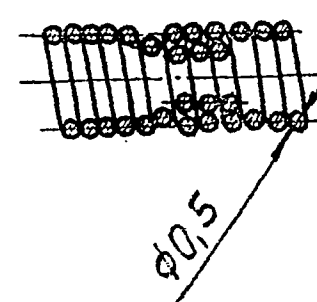
DRAWING NUMBER
54.83.029



RING BLANK
SCALE 2:1



A-A
SCALE 5:1



1. OXIDIZING OR OXIDE - PHOSPHATING.
2. LENGTH OF UNROUND WIRE SHOULD BE 1260 MM.
3. CLEARNCE BETWEEN COILS OF THE BLANK UPTO 0.5 MM IS ALLOWED.
4. TRANSITION FROM $\phi 3$ TO $\phi 2.3$. SHOULD NOT EXCEED THE LENGTH OF 3 COILS.
5. DIRECTION OF WINDING IS ARBITRARY.
6. TO ENSURE SPECIFIED $\phi 20$. IT IS ALLOWED TO ADJUST THE LENGTH OF THE BLANK.
7. MANUFACTURE OF WIRE II - 0.5 GOST 9389 - 75 IS ALLOWED.
8. STRENGTH OF SPRING LOCK IS TO BE CHECKED BY PLACING THE SPRING ON $\phi 25$ BAR

EXPLANATORY NOTE :-

9. MATERIAL QUOTED :- WIRE III - 0.5 COST 9389-75.

ALTERNATE MATERIAL QUOTED) - WIRE II - 0.5 GOST 9389-75
(REF. NOTE No.7)

CARSON STEEL COLD DRAWN WIRE.

AS REGARDS MECHANICAL PROPERTIES :- CATEGORY III OR II
DIAMETER OF WIRE - 0.5MM.

CHEMICAL COMPOSITION % TO MATERIAL GRADES KT-2 AND SK-7

	KT - 2	SK - 7
CARBON	= 0.86 - 0.91	0.66 - 0.76
MANGANESE	= 0.20 - 0.40	0.50 - 0.80
SILICON	= 0.17 - 0.37	0.17 - 0.37
SULPHUR	= 0.020 (MAX)	0.030 (MAX)
PHOSPHORUS	= 0.020 (MAX)	0.020 (MAX)
CHROMIUM	= 0.05 (MAX)	0.05 (MAX)
NICKEL	= 0.05 (MAX)	0.05 (MAX)
COPPER	= 0.10 (MAX)	0.04 (MAX)

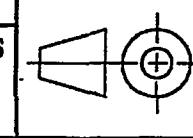
MECHANICAL PROPERTIES :-

	CATEGORY II	CATEGORY III
TENSILE STRENGTH Kgf/mm ²	220 - 265	170 - 220
No. OF TWISTS (MIN)	19	19

6A ALT. MATL:- TDC/VDC TO IS : 4454 Pt-II-2001

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

EST. WT. (Kg) 0.002	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	Sd/=	MATERIAL:-	USED ON:-
CHD	Sd/=	WIRE III - 0.5	54.83.8 Cb
TCD	Sd/=	GOST 9389 - 75	
APPD	Sd/=	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
DATE	7.8.86		
SCALE:-	2:1	TITLE:-  SPRING	
DIMENSIONS IN mm			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69		D S CAT NUMBER DRAWING NUMBER 54.83.029	
ALL THREADS TO CONFORM TO			
6A	4.11.05	Authy: Lt. No. 80001/CRA(HV)/GEN. dt. 7.10.05	
ISSUE	DATE	NATURE OF AMENDMENTS	

9783875

U/L CREATED BASED ON RUSSIAN ORIGINAL ISSUE - 11

F-1H
58

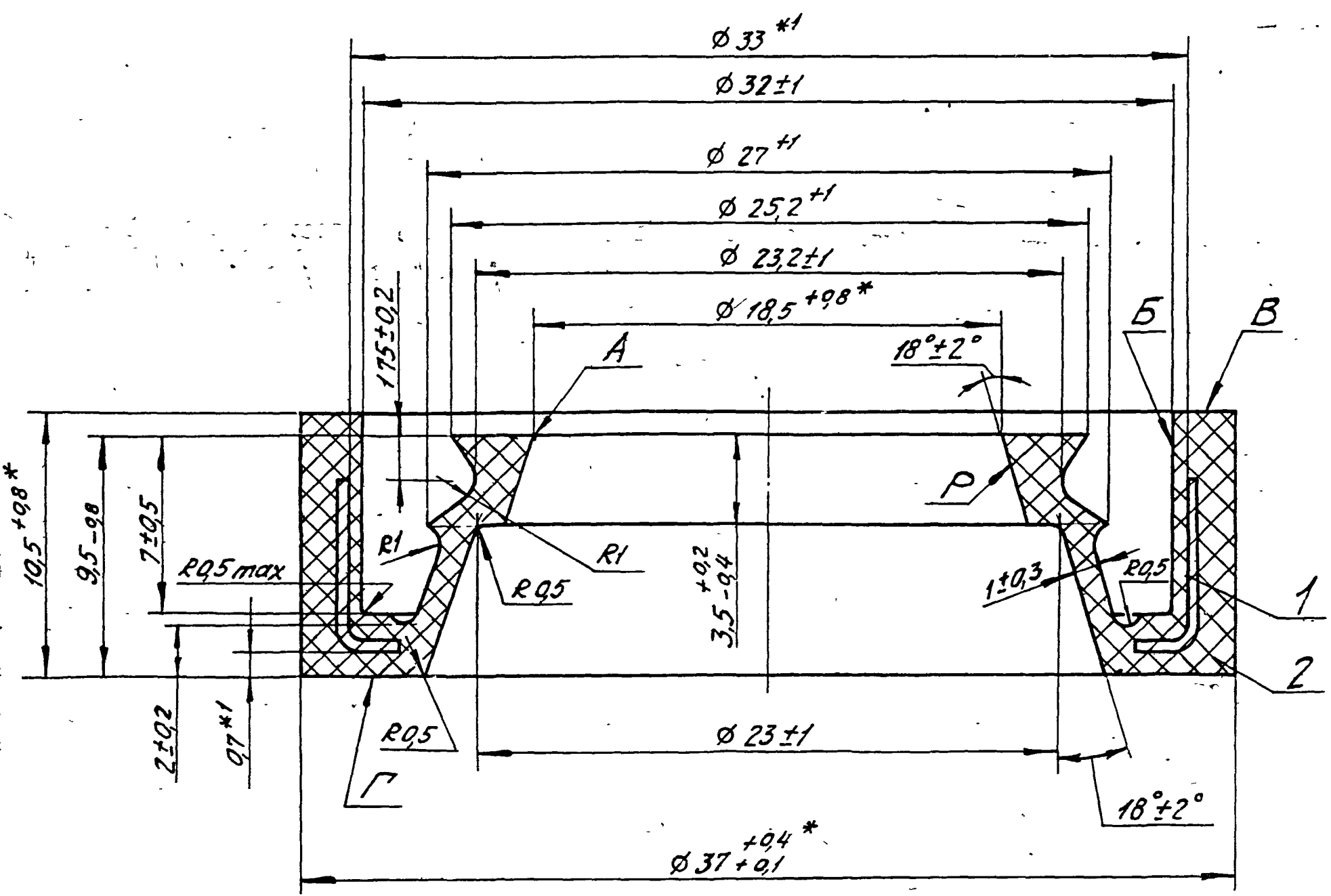
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REPLACES 54.83.25 CB ISSUE-10, VIDE NOTN.NO. N41-89 (AL.No. 13/2).

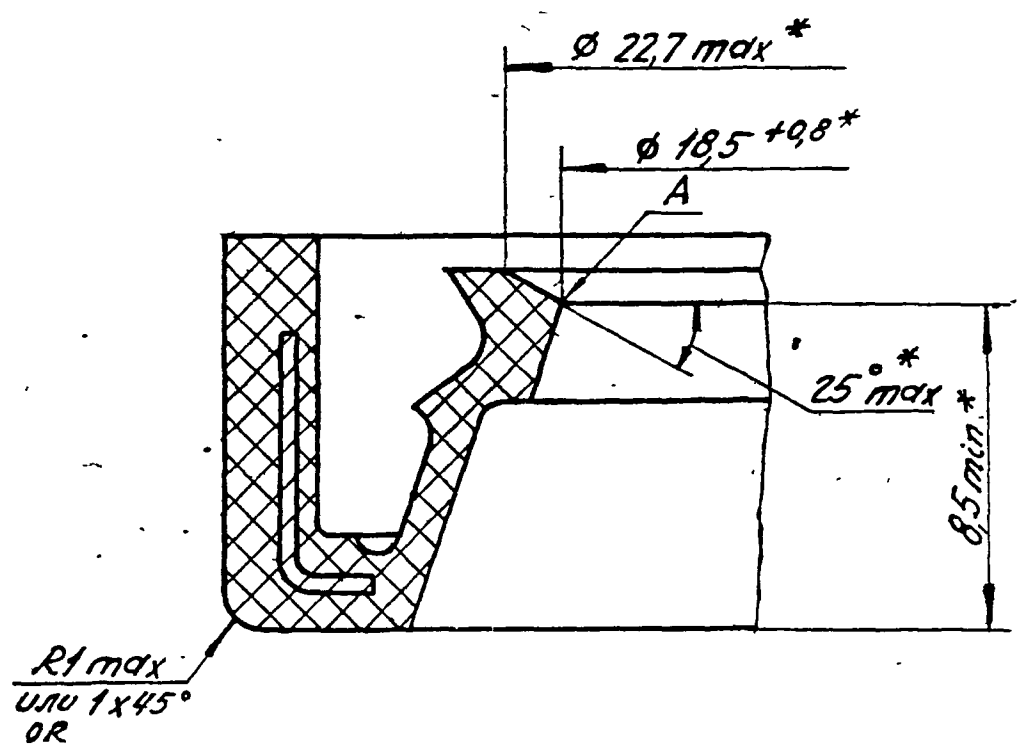
DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 11.

SIZE A2

DRAWING NUMBER
54.83.25 CB CB



ALTERNATE OF PREPARING.
Вариант изготовления
OPERATING EDGE.
рабочей кромки



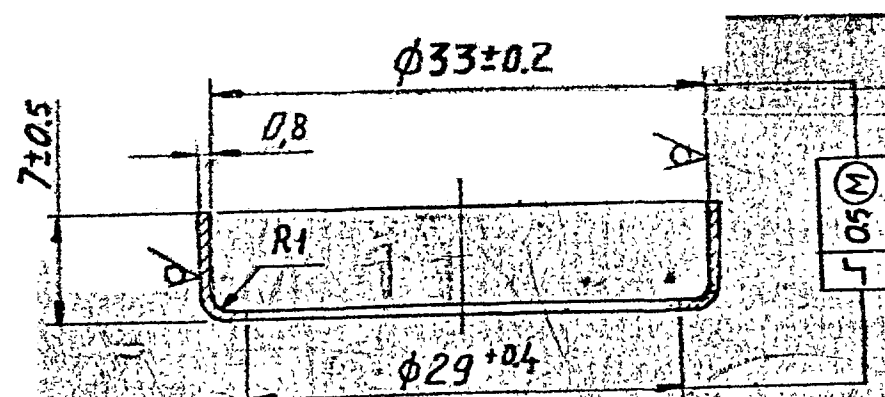
1. DIMENSION EXCEPT DESIGNATED WITH * SHOULD BE ENSURED BY TOOL.
2. EDGE A AND SURFACE P OPERATING ON SURFACE P TRACES FROM GRINDING WHEEL ARE ALLOWED.
3. ROUNDING OFF RADIUS OF EDGE A MAY NOT EXCEED 0.2 MM.
4. ON THE NON-WORKING SURFACE OF FEATHER PORTION, PRESENCE OF FLASHES, WITH LIGHT EXCEEDING 0.5 MM OVER A DISTANCE OF NOT LESS THAN 0.8 MM FROM THE EDGE 'A', ARE NOT ALLOWED.
5. SECTIONS WITHOUT RUBBER COATING ARE ALLOWED ON SURFACE ALONG THE ENTIRE HEIGHT OF THE FRAME.
6. ON FACE B FLASH AND PROJECTION EXCEEDING 0.5 MM ALONG PARTING PLANE OF DIE ARE NOT ALLOWED.
7. EVENLY SPACED DENTS WITH DIMENSIONS NOT EXCEEDING 3x3 MM ON SURFACE Γ TO THE DEPTH OF RUBBER LAYER ARE ALLOWED.
8. TO BE MARKED ON TAG.
9. TO BE MARKED BY ENGRAVING WITH TYPE 110 - 2 GOST 2930-62 AS PER TY 005216-75.
- 10.* 1 DIMENSIONS FOR REFERENCE.
11. OTHER REQUIREMENT AS PER TY 005216-75 CODE 253131.

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

EST. WT. 0.009 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	CHD	TCD	APPD	DATE	SCALE	DIMENSIONS IN	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69	ALL THREADS TO CONFORM TO	ISSUE	DATE	NATURE OF AMENDMENTS
MATERIAL :-								USED ON :- 54.83.8CB			
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)								A V A D I			
TITLE								CUP WITH FRAME			
D S CAT NUMBER								DRAWING NUMBER 54.83.25 CB CB			

DRAWING NUMBER
54-83-027-1



1. COMPONENT SHOULD BE SHOT-BLASTED.
2. BRASS PLATING OF COMPONENT IS ALLOWED.
3. REQUIREMENTS FOR COMPONENT SHOULD BE IN ACCORDANCE WITH TY 005216-75 (APPENDIX No. 1)
4. * DIMENSION FOR REFERENCE.
5. ALTERNATE MATERIAL : SHEET 0.8 GOST 19904-74
5-II-Γ 10 GOST 16523-70.

EXPLANATORY NOTE:-

MATERIAL QUOTED:- SHEET 0.8 GOST 19904-74
5-II-Γ 10Kp GOST 16523-70.

ALTERNATE MATERIAL:- SHEET 0.8 GOST 19904-74
5-II-Γ 10 GOST 16523-70

THICKNESS = 0.8 mm, COLD ROLLED SHEET STEEL TO GOST 19904-74.

CATAGORY = 5

QUALITY OF SURFACE FINISH = II GROUP

Γ = DEEP DRAWN

Kp = RIMMED STEEL

MATERIAL GRADE = 10Kp OR 10 TO GOST 1050-74.

CHEMICAL COMPOSITION:-

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	CARBON	SILICON	MANGANESE	CHROMIUM	SULPHUR	PHOS-PHORUS	COPPER	NICKEL
						(MAXIMUM)		
10Kp	0.07-0.14	0.07(max)	0.25-0.50	0.15	0.040	0.035	0.25	0.25
10	0.07-0.14	0.17-0.37	0.35-0.65	0.15	0.040	0.035	0.25	0.25

MECHANICAL PROPERTIES FOR GRADES 10Kp AND 10.

YIELD POINT Kgf/mm ² (MIN)	ULTIMATE TENSILE STRENGTH Kg/mm (MIN)	% ELONGATION (MIN)	REDUCTION OF AREA % (MIN)
21	34	31	55

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

EST. WT. 0.006 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 OUT SIDE INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	TCD	APPD	DATE	SCALE	DIMENSIONS IN	TOLERANCE ON DIMNS	UNLESS OTHERWISE STATED IS: 2102-69	ALL THREADS TO CONFORM TO	MATERIAL:- SHEET 0.8 GOST 19904-74 5-II-Γ 10Kp GOST 16523-70	USED ON 54-83-25 C6
				21-6-88	2:1					CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES) AVADI	
										TITLE	
										FRAME	
										D S CAT NUMBER	DRAWING NUMBER
											54-83-027-1

SIZE-A3