



Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks	
				<u>Standard articles</u>			
		18		Bolt	24	*1	
				2M16-8gx60.109.40X.029			
				GOST 7798-70			
		19		Bolt M16-8gx60.109.40X.029	2	*1	
				GOST 7817-80			
		20		Nut M16-6G-10.40X.029	26	*2	
				GOST 5918-73			
		21		Screw VM6-8gx30.109.40X.029	1	*3	
				GOST 17475-80			
		22		Screw VM6-8gx20.109.40X.029	1	*3	
				GOST 17475-80			
		23		Rivet 4x28.37.10	2		
				GOST 10300-80			
		24		Washer A16.25.029	52		
				GOST 11371-78			
		25		Cotter pin 3.2x25.029	2		
				GOST 397-79			
		26		Cotter pin 4x36.029	26		
				GOST 397-79			
		27		Pin 3Pr22ax18.40X.	2		
				K38.5...45.5HRC.Chem.Phos.Oil.			
				OST 3-2234-93			
		28		Washer 8.65G.029	2		
				GOST 6402-70			
			*1) Heat treatment of bolts pos.18, 19 31...40.5 HRC <sub>E</sub> .				
Orig. Inv. No.							
Amend.	Sheet	Doc. No.	Sign	Date	AK-630. Sb 118		
					Sheet	2	

Sign and Date

Duplicate Inv. No.

Alternate Inv no.

Sign and Date

Orig. Inv. No.





First use

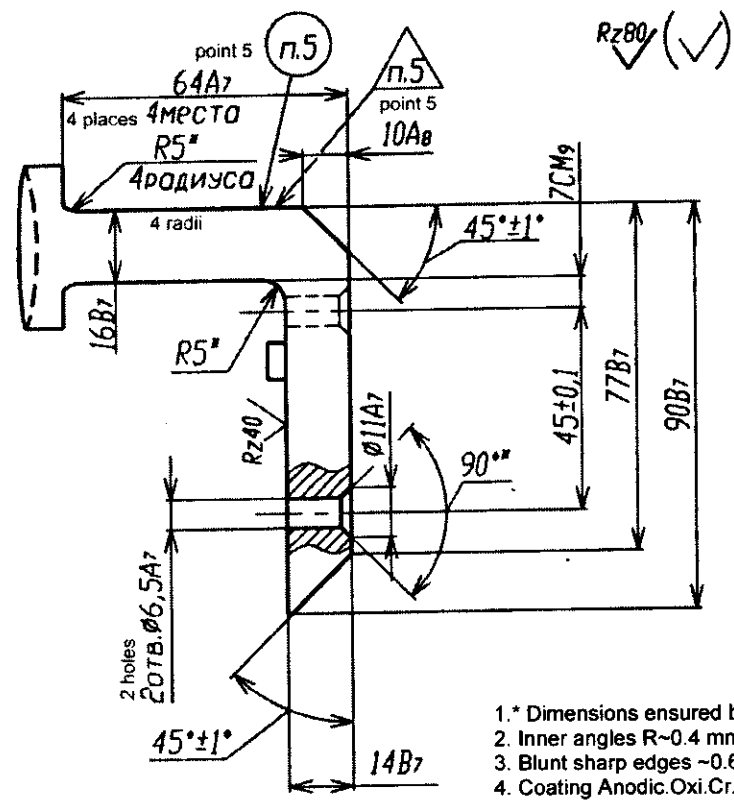
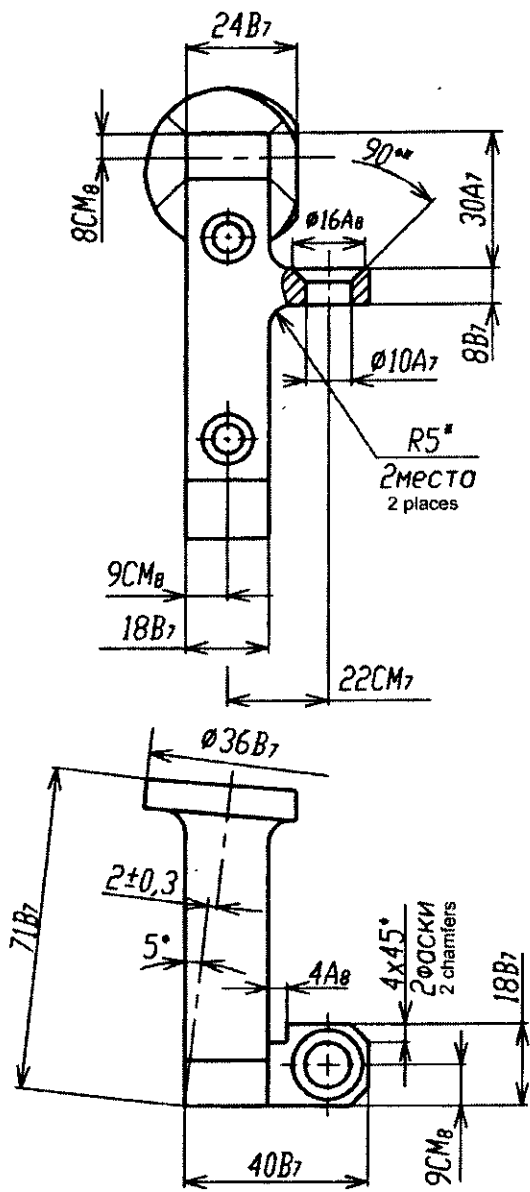
Reference No.

Duplicate Inv. No. Sign and Date

Alternate Inv. No.

Sign and Date

Orig. inv. no.



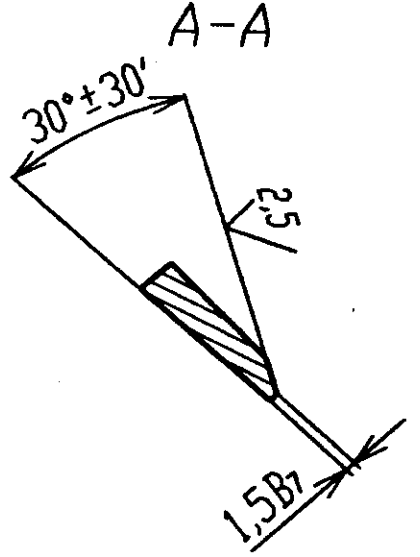
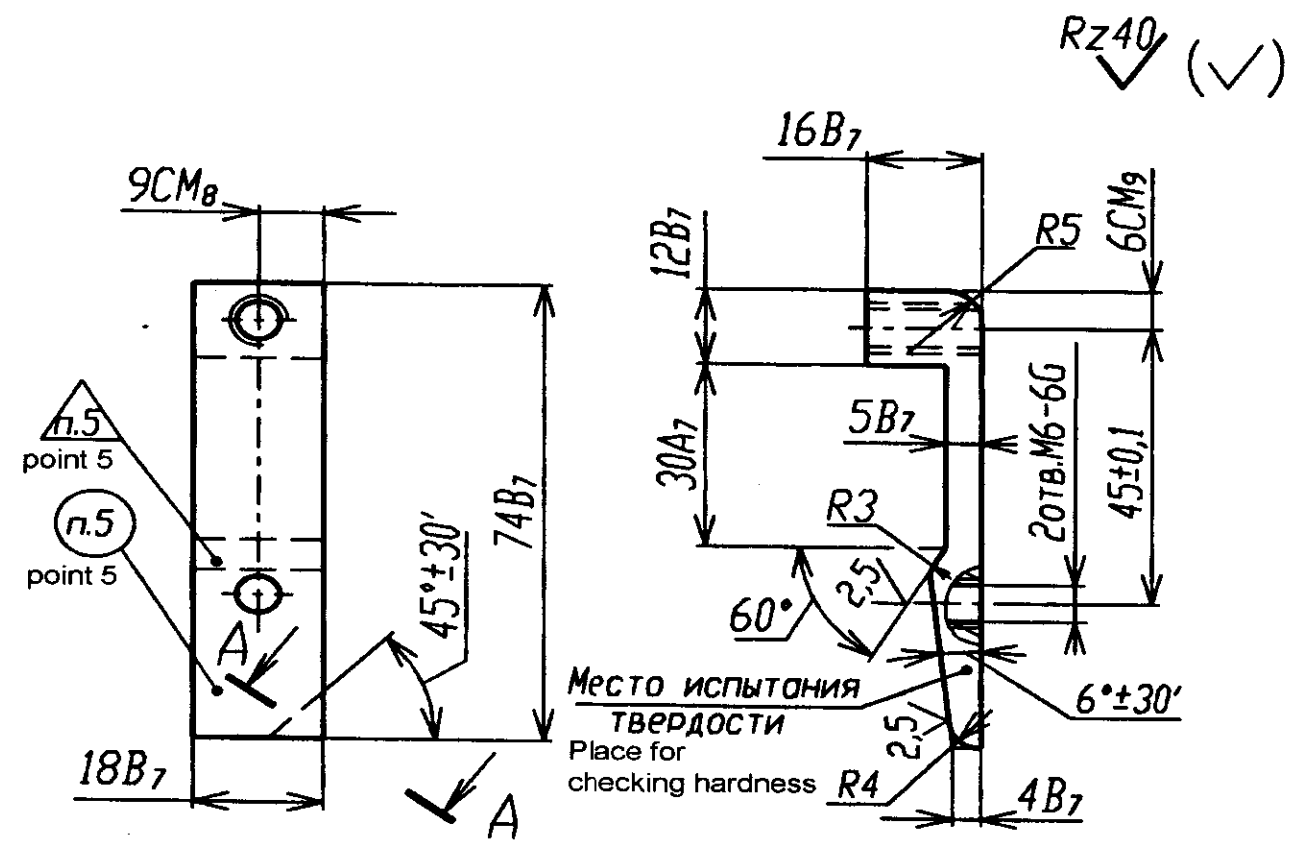
- 1.\* Dimensions ensured by tool.
- 2. Inner angles R~0.4 mm.
- 3. Blunt sharp edges ~0.6 mm.
- 4. Coating Anodic.Oxi.Cr.
- 5. Mark Ш,Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 118-1			
Amend.	Sheet	Doc.No.	Sign	Date	Bracket	Type	Weight	Scale
Developed by						A	0.120	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Alloy AMg6			
Approved by					GOST 4784-97			



AK-630 118-4

Approved OGMet		Sign and Date		Approved TOSb		Approved KTONI		Approved by shop		Reference No.		First use	
Orig. Inv. No.	Sign and Date	Alternate Inv. No.	Dupl. Inv. No.	Sign and Date	Approved TOSb	Approved KTONI	Approved by shop	Reference No.	First use				
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...44.5 HRC<sub>E</sub>.
2. Inner angles R~0.4 mm.
3. Blunt sharp edges ~ 0.4 mm.
4. Coating Cd12.phos.Oil.
5. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

Место испытания  
ТВЕРДОСТИ  
Place for  
checking hardness

AK-630 118-4

Strap

Steel 50 GOST 1050-88

Type	Weight	Scale
A	0.055	1:1
Sheet		Sheets 1

Copied by

Format A4





AK-630 118-9

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

1.\*Dimensions ensured by tool.  
 2.Blunt sharp edges ~ 0.4 mm.  
 3.Mark Ш, Ч and stamp K on tag.

<b>AK-630 118-9</b>				
<b>Bush</b>	Type	Weight	Scale	
	A	0.020	1:1	
	Sheet		Sheets 1	
Wheel <u>34 – VGOST2590 – 88</u> <u>12Cr18Ni9Ti – B – TGOST5949 – 75</u>				

Copied by

Format A4

AK-630 118-10

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

I M(2:1)

1.\* Dimension ensured by tool.  
 2. Blunt sharp edges ~0.4 mm.  
 3. Mark Ш, Ч and stamp K on tag.

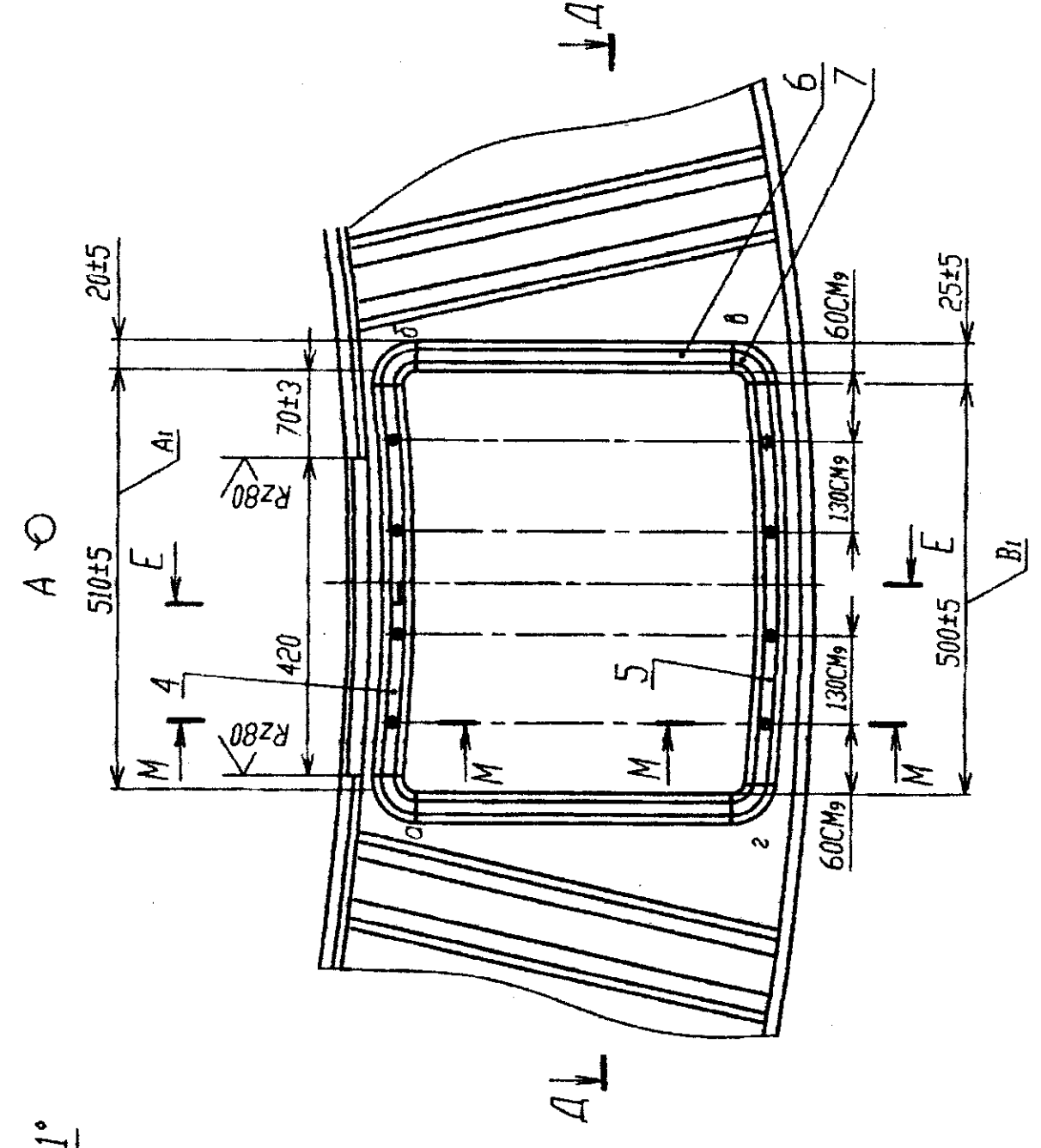
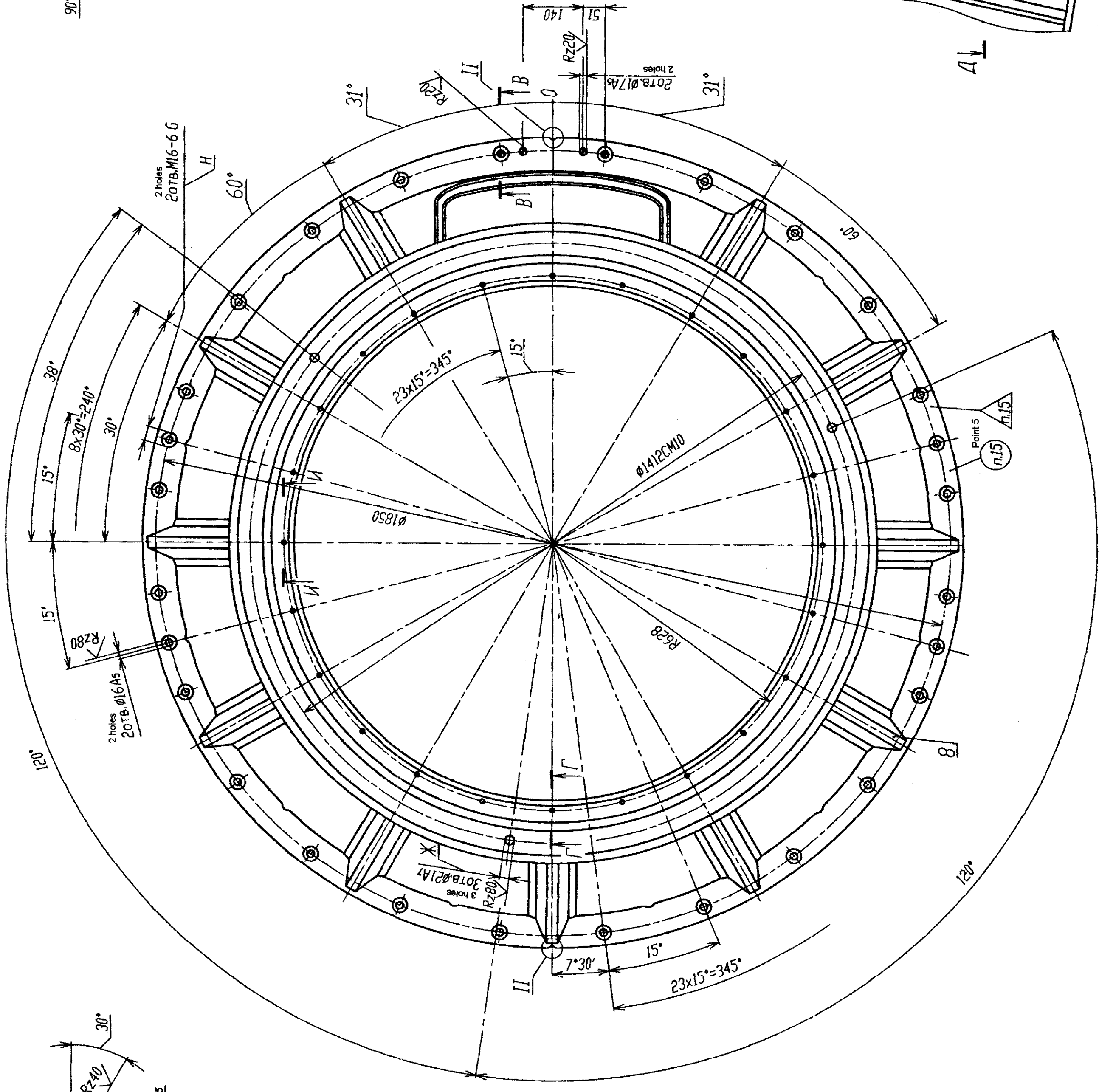
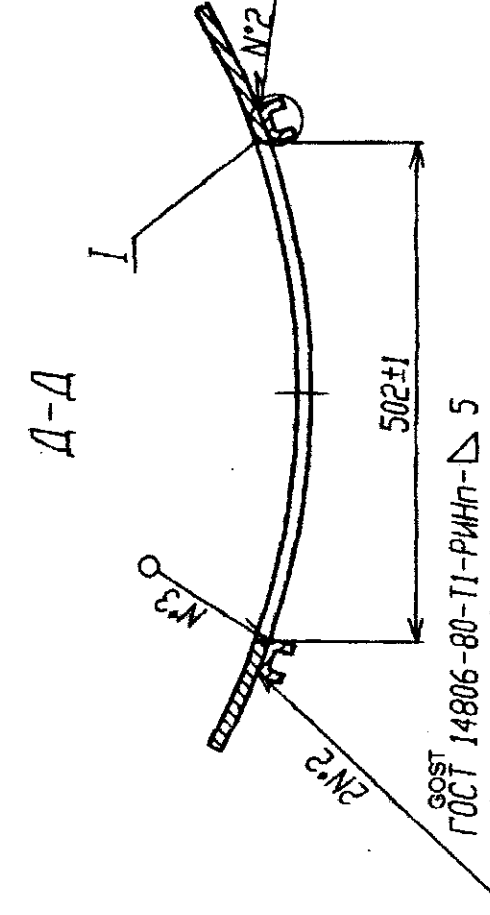
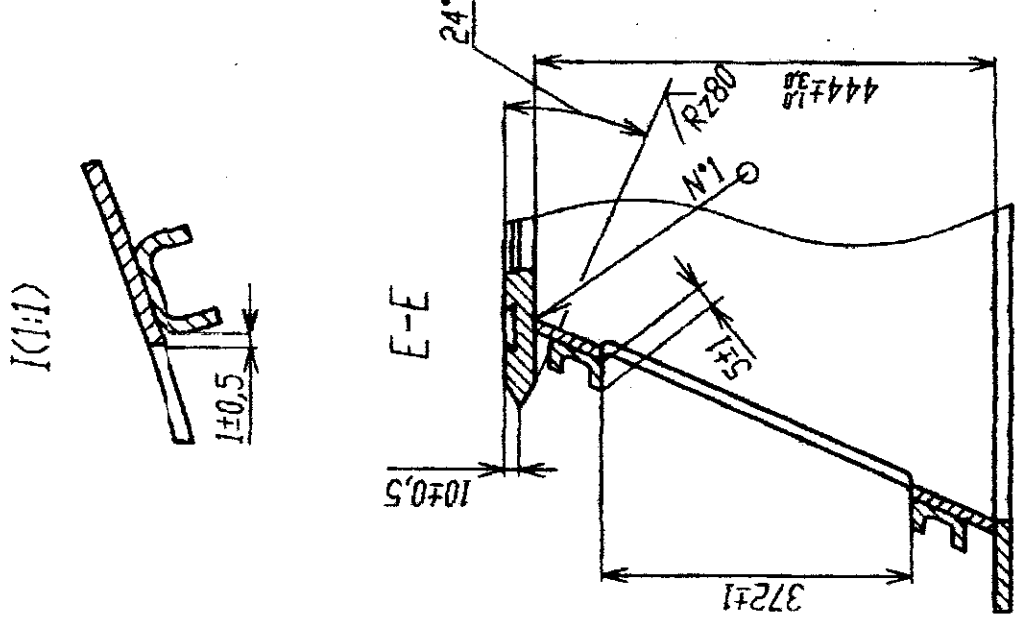
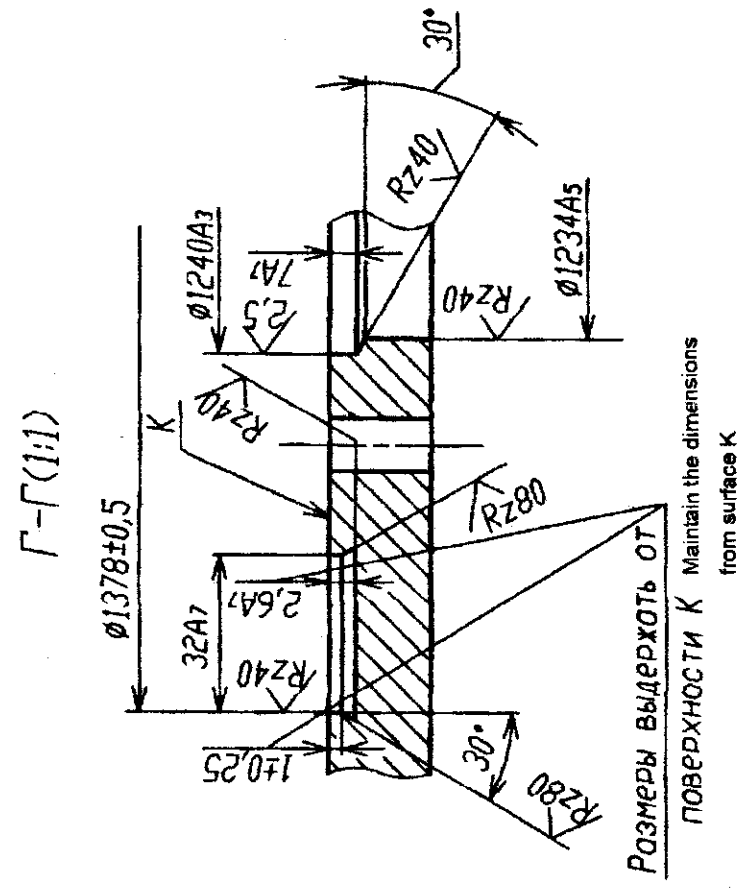
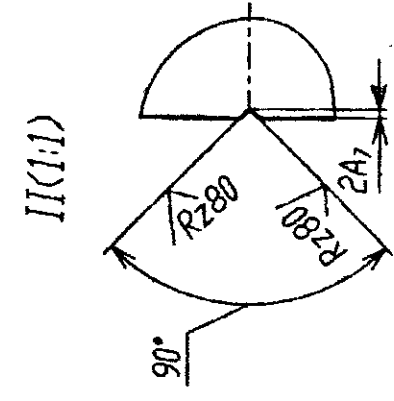
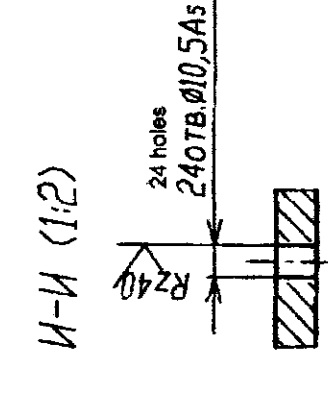
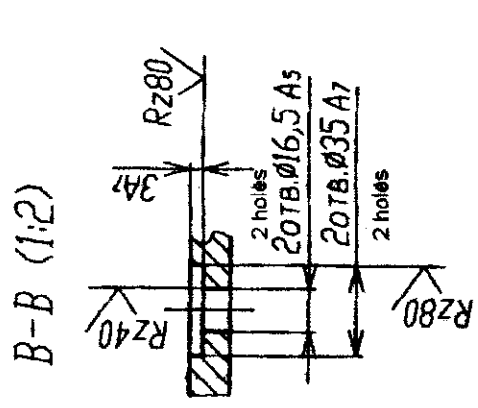
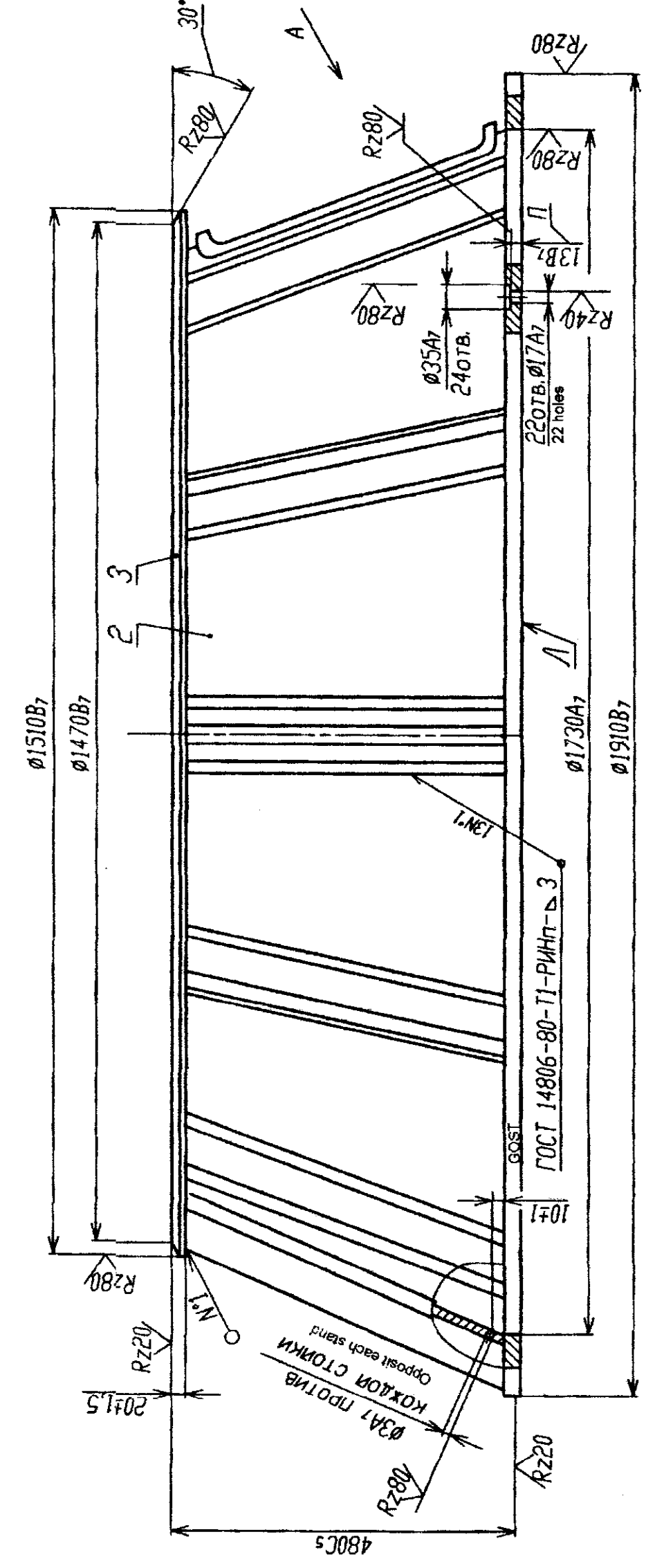
AK-630 118-10				
<b>Bolt</b>	Type	Weight	Scale	
	A	0.012	1:1	
Sheet		Sheets 1		
Steel 12Cr18Ni9Ti GOST 5632-72				

Copied by

Format A4

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A0			AK-630 Sb118-1 SB	Assembly drawing 163-7/13 10/7			
					<u>Assembly units</u>			
	A4	2		AK-630 Sb 118-12	Taper 163-7/13	1		
					<u>Components</u>			
	A3	3		AK-630 118-11	Upper ring 163-5/14	1		
	A3	4		AK-630 118-13	Shaping strip 163-5/14	1		
	A3	5		AK-630 118-14	Shaping strip 163-5/14	1		
	A3	6		AK-630 118-15	Shaping strip 163-5/14	2		
	A4	7		AK-630 118-16	Angle piece 163-5/14	4		
A3	8		AK-630 118-17	Support 163-5/14	11			
Sign and Date					<u>Materials</u>			
					Wire 3.15 SvAMg6	5	kg.	
					GOST 7871-75			
					Wire 10 SvAMg6	1	kg.	
Dupl. Inv. No.					GOST 7871-75			
Alternate Inv. No.								
Sign and Date					<b>AK-630 Sb 118-1</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>Taper</b>								

М-М (1:1) Weld with argon arc welding



1. Argon arc welding with the use of filler electrode 4.0 Sv AMIG-GOST 7871-75.
2. Adjust the ends of cone pos. 4 along the abutment with rings, before welding the local gaps for not more than 1.5 mm are permitted.
3. During welding, the binder between the stands for not more than 8 mm is permitted.
4. Before welding, the adjustment and the straightening of components is permitted.
5. Do not weld along the contour 'М' in the areas A1 and B1 from the external side.
6. The deviation from the parallelness of plane K in relation to plane L is not more than 0.3 mm.
7. The deviation of surfaces K and L is not more than 0.4 mm. The non-flatness up to 0.7 mm is permitted in the area of window.
8. Displacement of the axis of hole "H" in relation to standard position is  $\pm 2$  mm.
9. The tolerance for positioning of stand pos. 11 is  $\pm 1$ .
10. Displacement of the axis of hole in relation to standard position is not more than 0.2 mm, except three holes Ж.
11. Internal angles  $R = 0.4$  mm.
12. Blunt the sharp edges 0.4 mm.
13. While obtaining the dimension Г without facing, its marking is not required.
14. Mark 4 and stamp K as per AK-630, AK-630 M T U.

1. Сварка аргоном с применением присадочной проволоки 4.0 Sv AMIG ГОСТ 7871-75.
2. Торцы конуса поз. 4 пригнать по стыку с кольцами, местные зазоры до сварки допускаются не более 1.5 мм.
3. При сварке допускается гранность между стойками не более 8 мм.
4. Допускается подгонка и правка деталей до сварки.
5. На контуре 'обж' в зонах А1 и В1 не варить с внешней стороны.
6. При постановке детали поз.3 допускается подгибка стенки конуса поз.2.
7. Отклонение от параллельности плоскости К относительно плоскости Л не более 0.3мм.
8. Неплоскостность поверхности К и Л не более 0,4 мм. Допускается в зоне окна неплоскостность до 0,7 мм номинального положения  $\pm 2$  мм.
9. Смещение осей отв. "Н" относительно номинального положения отв. поз. 11:  $\pm 1$ .
10. Допуск на расположение стоек поз. 11:  $\pm 1$ .
11. Смещение осей отверстия относительно номинального расположения не более 0,2мм, кроме 3-х отв. Ж.
12. Внутренние углы  $R=0,4$ мм.
13. Острые ребра притупить 0,4мм.
14. При получении размера П без подготовки выполнения ее не требуется.
15. Маркировать 4 и клеймить К по АК-630, АК-630М ТУ 1.

AK-630 СБ118-1СБ		Контр. №	Масштаб
Исполн.	С.М.	№	1:500
Провер.	С.М.	№	1:500
Согласов.	С.М.	№	1:500
Утверд.	С.М.	№	1:500
Собранная чертёж	С.М.	№	1:500
Ассембли drawing	С.М.	№	1:500
Контр. №	С.М.	№	1:500

AK-630 118-11

First use

Reference No.

Sign and Date

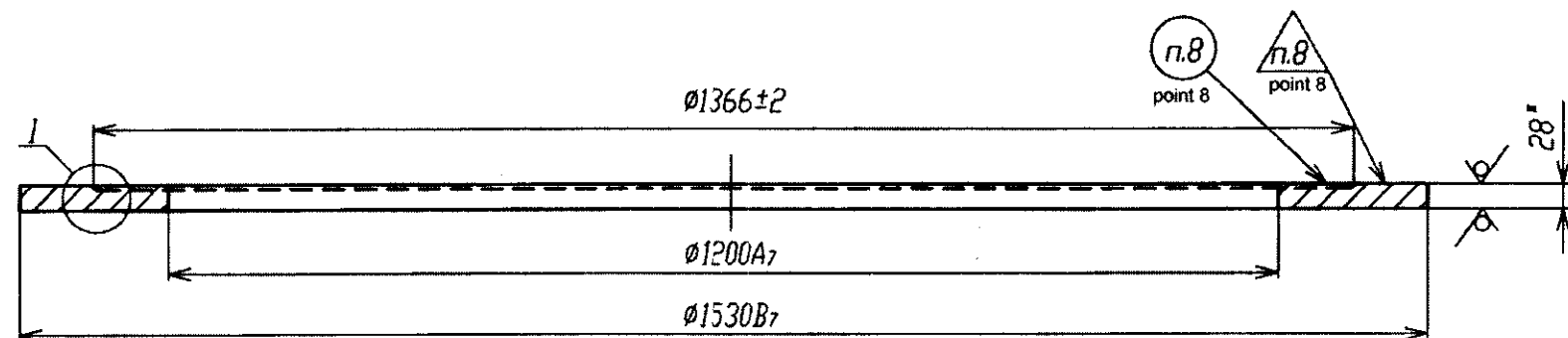
Duplicate Inv. No.

Alternate Inv. No.

Sign and Date

Orig. inv. no.

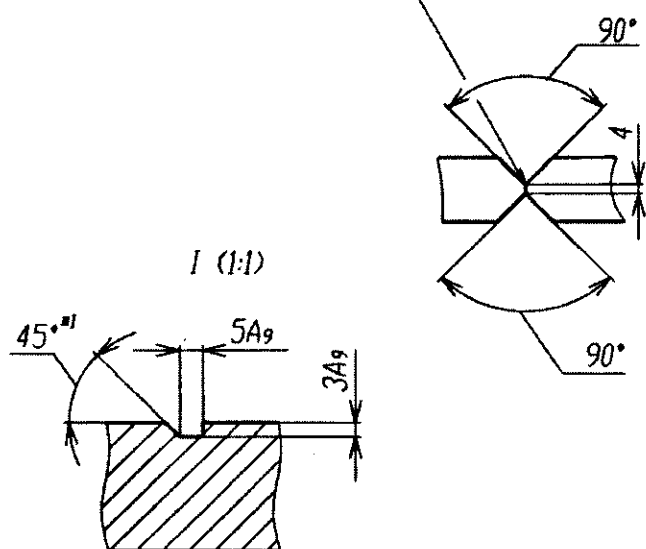
Rz80 (✓)



GOST  
ГОСТ 14806-80-С25-Р11п

Разделка под сварку Termination for welding

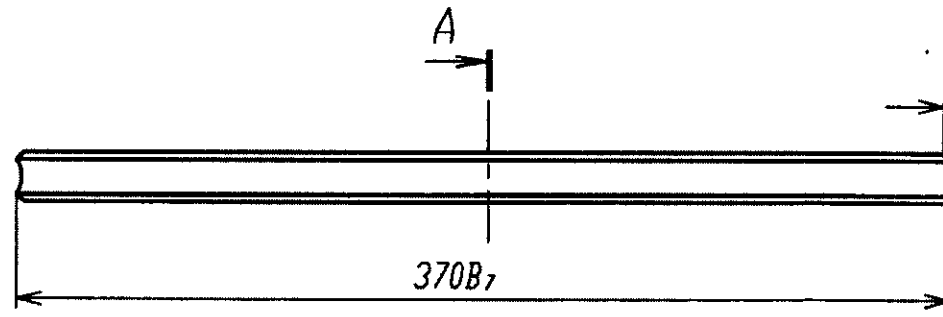
M (1:2)



1. Argon-arc welding by using filler wire 4.0 Sv AMg6 GOST 7871-75.
2. It is permissible to make from 4 parts.
3. \* Reference dimension.
4. \*1 Dimension ensured by tool.
5. Inner angles R~0.4 mm.
6. Blunt sharp edges ~0.6 mm.
7. Non flatness not more than 2 mm.
8. Mark Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 118-11			
Amend.	Sheet	Doc.No.	Sign	Date	Upper ring	Type	Weight	Scale
Developed by						A	54.5	1:5
Checked by						Sheet	Sheets	1
Head of Q.C.D					Plate AMg6 B-28 GOST 17232-99			
Approved by								

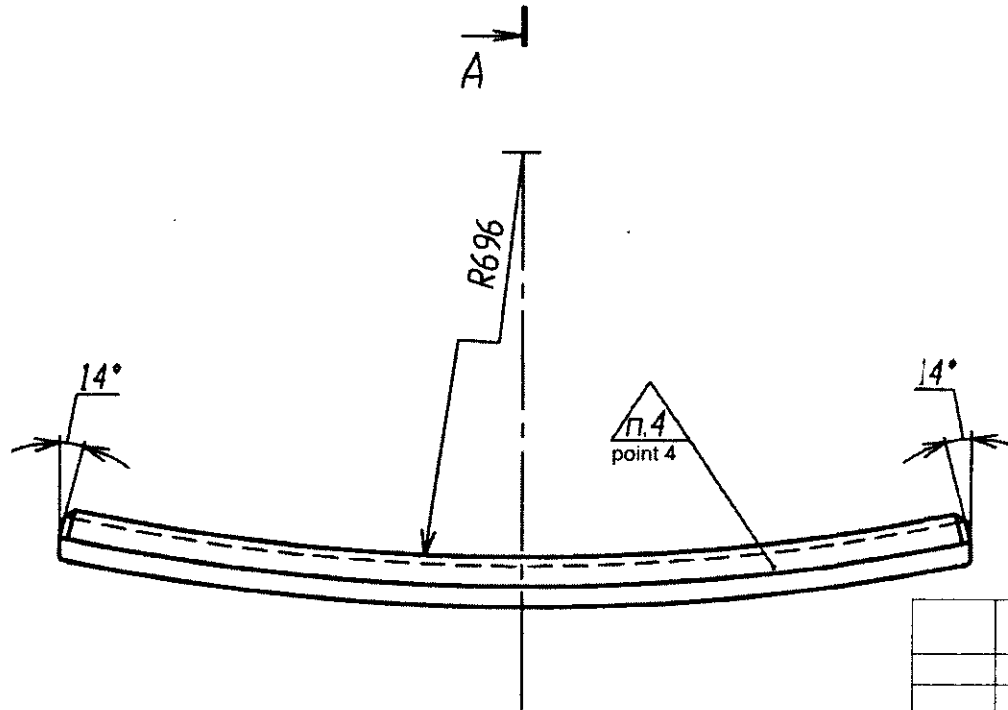
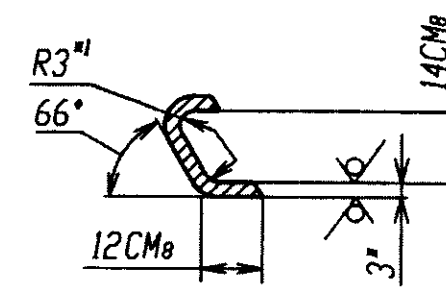
First use  
Reference No.  
Sign and Date  
Duplicate Inv. No  
Sign and Date  
Alternate Inv. No  
Sign and Date  
Orig. inv. no.



3x45° по боковому контуру  
ТОРЦА С 2-Х СТОРОН  
Along side contour of  
face from 2 sides

Rz80 (✓)

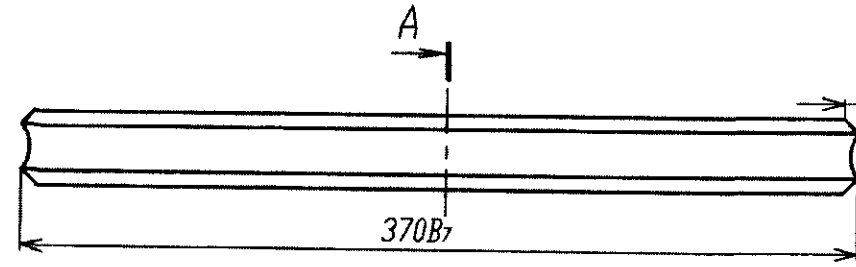
A-A (1:1)



- 1.\* Reference dimension.
- 2.\*1 Dimension ensured by tool.
3. Blunt sharp edges ~0.4 mm.
4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

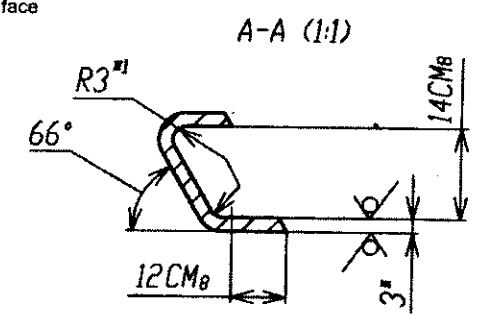
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Checked by						Sheet	Sheets 1	
Head of Q.C.D					Sheet AMg6 BM-3 GOST 21631-76			
Approved by								

First use  
Reference No.



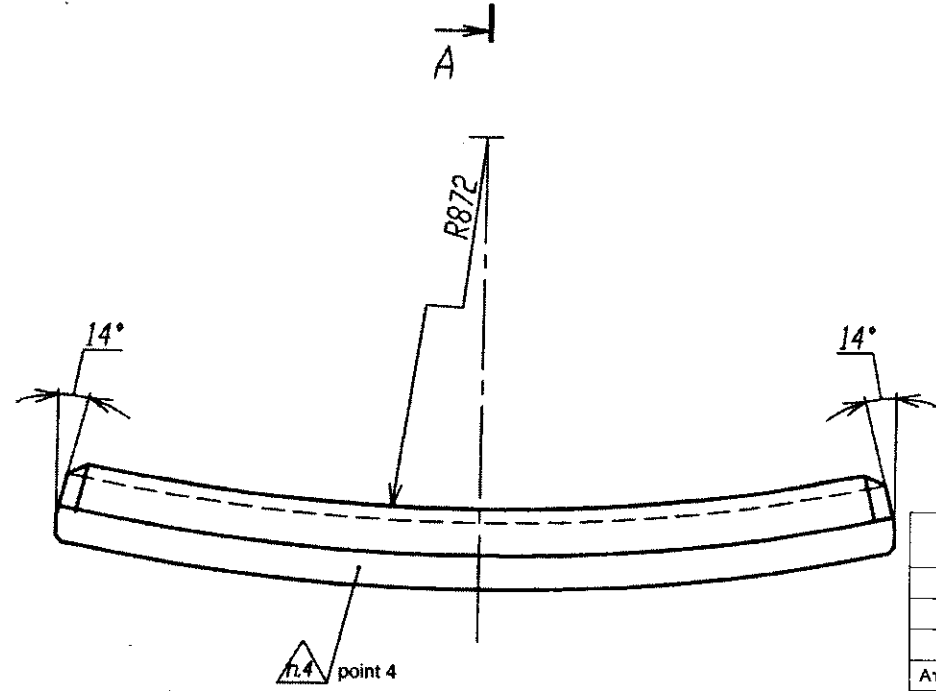
3x45° по боковому контуру  
ТОРЦА С 2-Х СТОРОН  
Along side contour of face  
from 2 sides.

Rz80 (✓)



- 1.\* Reference dimension.
- 2.\*1 Dimension ensured by tool.
- 3. Blunt sharp edges ~0.4 mm.
- 4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

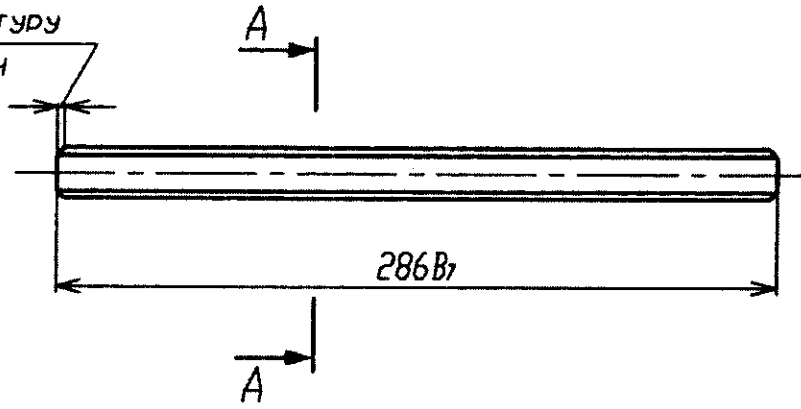
Sign and Date  
Duplicate Inv. No. Sign and Date  
Alternate Inv. No.  
Sign and Date  
Orig. inv. no.



					AK-630 118-14			
Amend.	Sheet	Doc.No.	Sign	Date	Shaping strip	Type	Weight	Scale
Developed by						A	0.105	1:2
Checked by						Sheet	Sheets	1
Head of Q.C.D					Sheet AMg6 BM-3 GOST 21631-76			
Approved by								

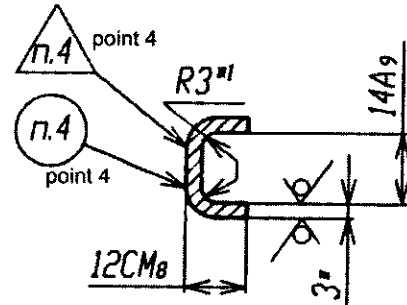
First use  
Reference No.

3x45° по наружному контуру  
торца с 2-х сторон  
On external contour of  
face from 2 sides.



Rz80 (✓)

A-A (1:1)



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

- 1.\* Reference dimension.
- 2.\*1 Dimension ensured by tool.
- 3. Bunt sharp edges ~0.4 mm.
- 4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 118-15			
Amend.	Sheet	Doc.No.	Sign	Date	Shaping strip	Type	Weight	Scale
Developed by						A	0.072	1:2
Checked by						Sheet	Sheets	1
Head of Q.C.D					Sheet AMg6 BM-3			
Approved by					GOST 21631-76			



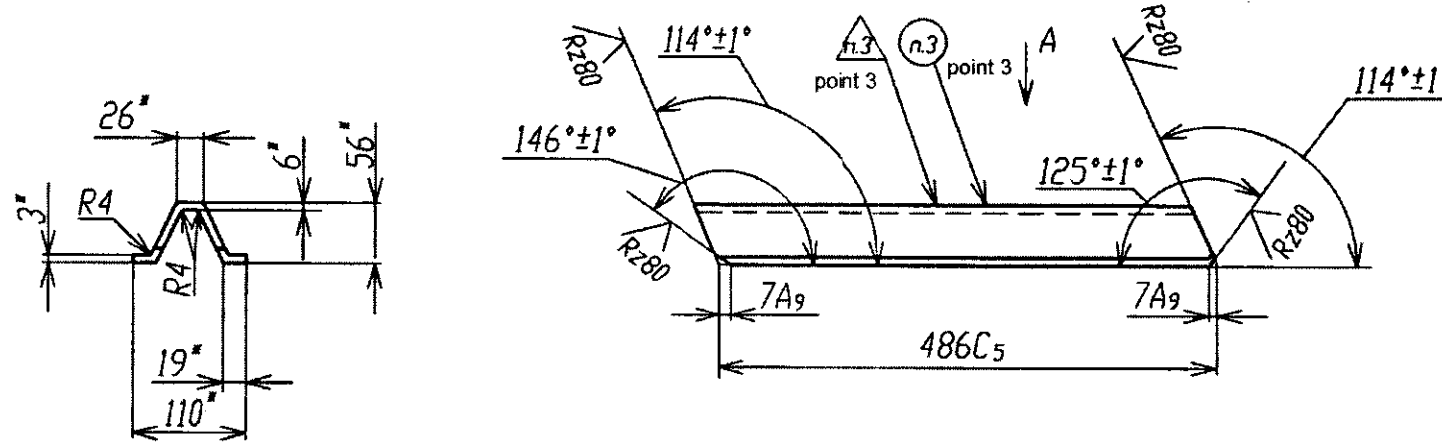
AK-630 118-16

Approved by shop Reference No.	Approved KTONI Sign and Date	Approved TOsb Dupl. Inv. No.	Approved OGMet Orig. Inv. No.	First Use																																																														
<p>A-A</p>																																																																		
<p>1. Blunt sharp edges ~0.4 mm.                  2.* Reference dimension.                  3.*1 Dimension ensured by tool.                  4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.</p>																																																																		
<p>AK-630 118-16</p>																																																																		
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th>Amend.</th> <th>Sheet</th> <th>Doc. No.</th> <th>Sign</th> <th>Date</th> </tr> </thead> <tbody> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> </tbody> </table>			Amend.	Sheet	Doc. No.	Sign	Date																																														<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="3">AK-630 118-16</th> </tr> <tr> <th>Type</th> <th>Weight</th> <th>Scale</th> </tr> <tr> <td style="text-align: center;">A</td> <td style="text-align: center;">0.031</td> <td style="text-align: center;">1:1</td> </tr> <tr> <td colspan="2">Sheet</td> <td>Sheets 1</td> </tr> </table>		AK-630 118-16			Type	Weight	Scale	A	0.031	1:1	Sheet		Sheets 1
Amend.	Sheet	Doc. No.	Sign	Date																																																														
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Sheet AMg6 BM-3 GOST 21631-97																																																																		

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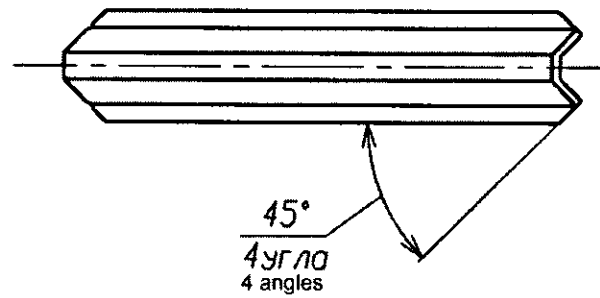
Format A4

✓(✓)



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

A



					AK-630 118-17			
Amend.	Sheet	Doc.No.	Sign	Date	Support	Type	Weight	Scale
						A	0.58	1:5
						Sheet	Sheets	1
					Head of Q.C.D	Profile AMg6 54083 ND $\frac{GOST8617-81}{GOST17576-81}$		
					Approved by			

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



AK-630 118-12

First use

Reference No.

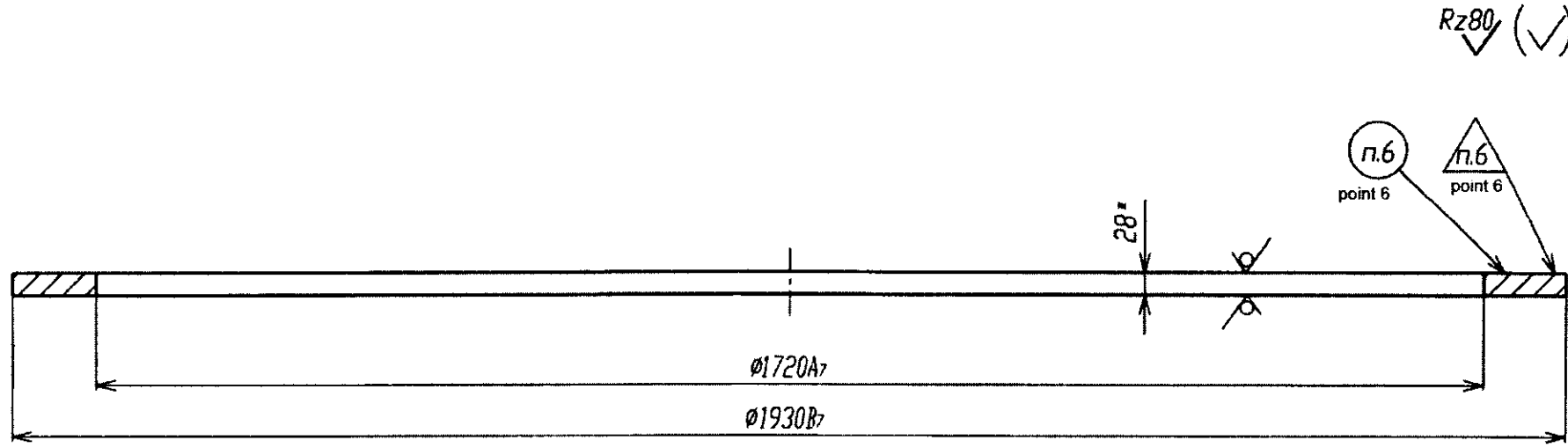
Sign and Date

Duplicate Inv. No.

Alternate Inv. No.

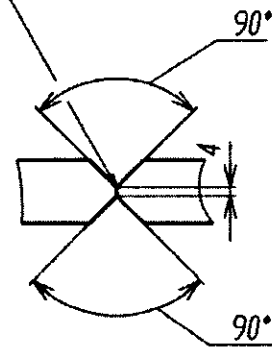
Sign and Date

Orig. Inv. no.



Разделка под сварку Termination for welding (1:2)

GOST  
ГОСТ 14806-80-С25-РИИП

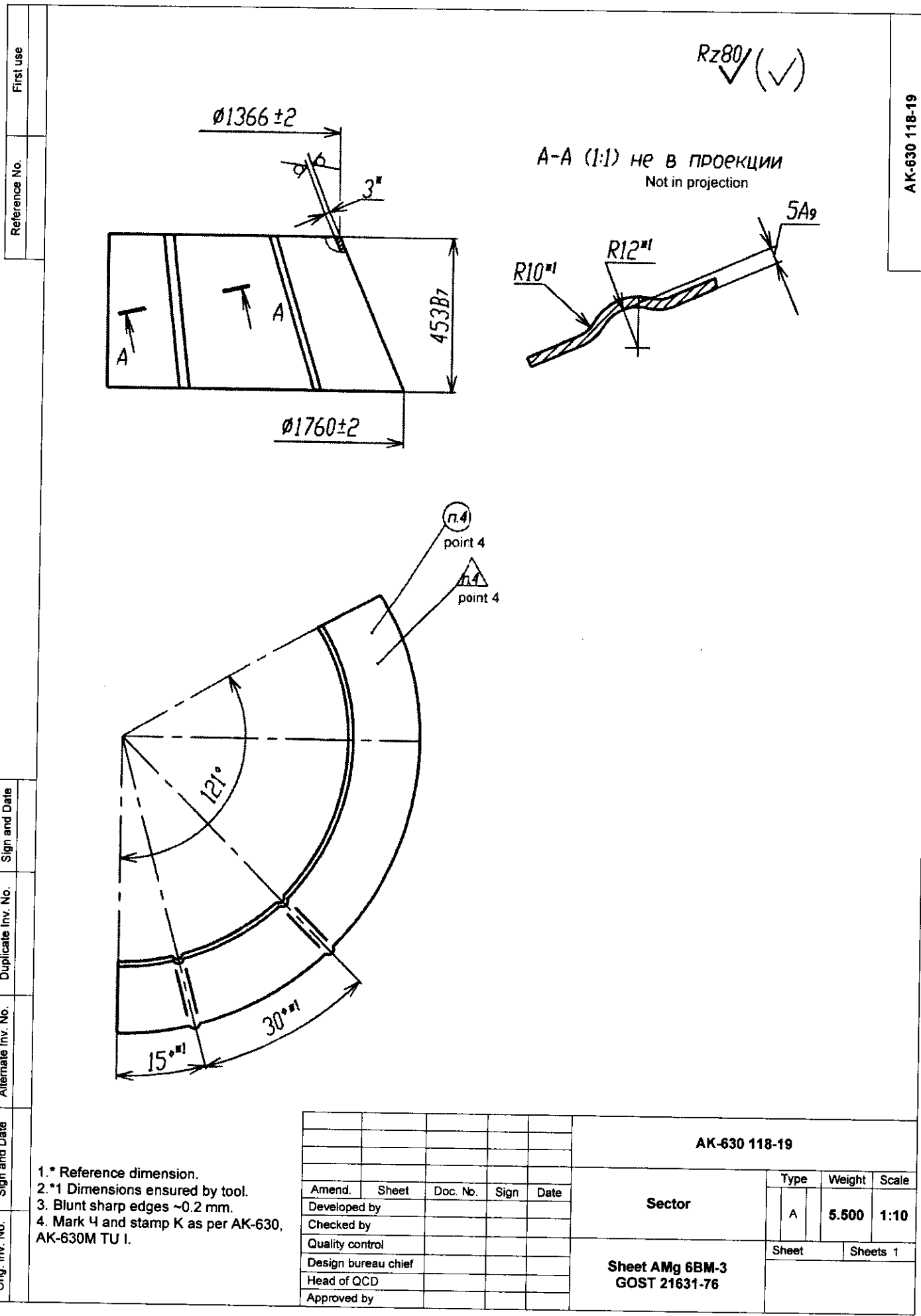


1. Argon-arc welding by using filler wire 4.0 Sv AMg6 GOST 7871-75.
2. It is permissible to make from 4 parts.
- 3.\* Reference dimension.
4. Blunt sharp edges ~0.6 mm.
5. Non flatness not more than 2 mm.
6. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 118-12			
Amend.	Sheet	Doc.No.	Sign	Date	Lower ring	Type	Weight	Scale
							A	45.000
Developed by						Sheet	Sheets	1
Checked by						Plate AMg6 B-28 GOST 17232-99		
Head of Q.C.D								
Approved by								







Reference No. \_\_\_\_\_  
First use

AK-630 118-19

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

- 1.\* Reference dimension.
- 2.\*1 Dimensions ensured by tool.
- 3. Blunt sharp edges ~0.2 mm.
- 4. Mark 4 and stamp K as per AK-630, AK-630M TU I.

					<b>AK-630 118-19</b>			
Amend.	Sheet	Doc. No.	Sign	Date	<b>Sector</b>	Type	Weight	Scale
Developed by						A	5.500	1:10
Checked by					<b>Sheet AMg 6BM-3 GOST 21631-76</b>	Sheet		Sheets 1
Quality control								
Design bureau chief								
Head of QCD								
Approved by								

Format A3

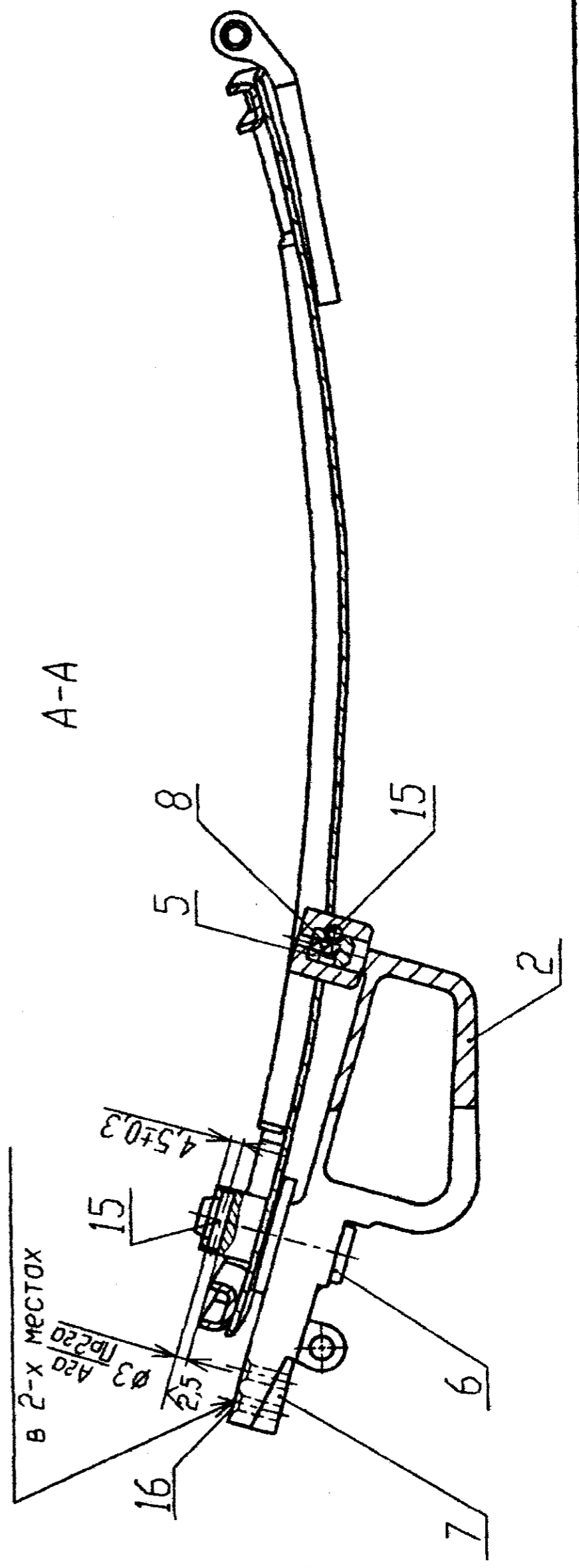
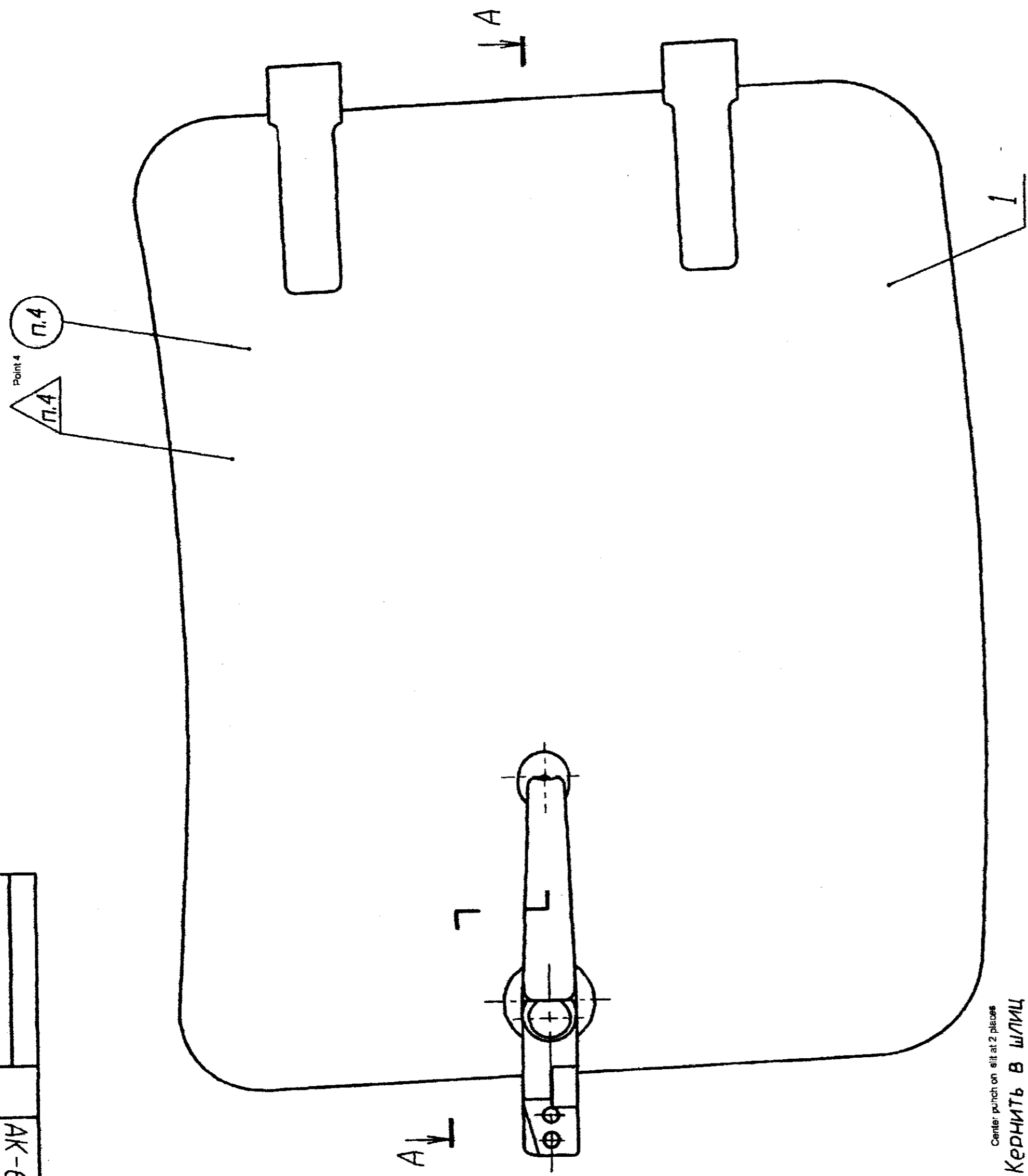
First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A2			AK-630 Sb118-2 SB	Assembly drawing			
					<u>Assembly units</u>			
	A4		1	AK-630 Sb 118-3	Shutter 163-7/13	1		
	A4		2	AK-630 Sb 118-5	Handle 163-7/13	1		
					<u>Components</u>			
	A4		5	AK-630 118-21	Sleeve 163-5/11	1		
	A4		6	AK-630 118-22	Pin 163-5/11	1		
	A3		7	AK-630 118-24	Strap	1		
	A3		8	AK-630 118-25	Spring	1		
Sign and Date					<u>Standard articles</u>			
			15		Pin 3Pr22ax25.40 Kh K38.5.45.5 HRC Chem.phos.oil. OST 3-2234-93	2		
Dupl. Inv. No.			16		Screw VM6-8gx20.109.40Kh.029 GOST 17475-80	2	65.5-70HRA	
Alternate Inv. No.								
Sign and Date					<b>AK-630 Sb 118-2</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>Shutter</b>		
	Approved by							



927-81190 089-2СБ

AK-630 SB-18-2SB

ИВН ПОЛ/ ПОЛ И ДОТ	ВЗКМЧН/Н	ИВН/КВЛ	ПОЛ И ДОТ
СРРВ/Н	ЛРРВ/ПРИМЧН		



1. Lubricate the rubbing surfaces of wall pos.5 with grease MS-70 GOST 9762-76.
2. The wall should move freely and under the effect of spring pos. 8 it should return with force to its initial position.
3. The handle pos. 2 should freely rotate on the axle pos. 6. The gap between the handle and bush should be not more than 0.2 mm.
4. Mark II, 4 and stamp K as per AK-630, AK-630M TU I.

1. Трещиесе поверхности стакано поз. 5 смазотъ смазкой MS-70 ГОСТ 9762-76.
2. Стакан должен свободно перемещаться и под действием пружины поз 8 должен энергично возвращаться в исходное положение.
3. Рукоятка поз. 2 должна свободно вращаться на оси поз. 6. Зазор между рукояткой и втулкой должен быть не более 0,2 мм.
4. Маркировать 4 и клеить К по АК-630, АК-630М ТУ I.

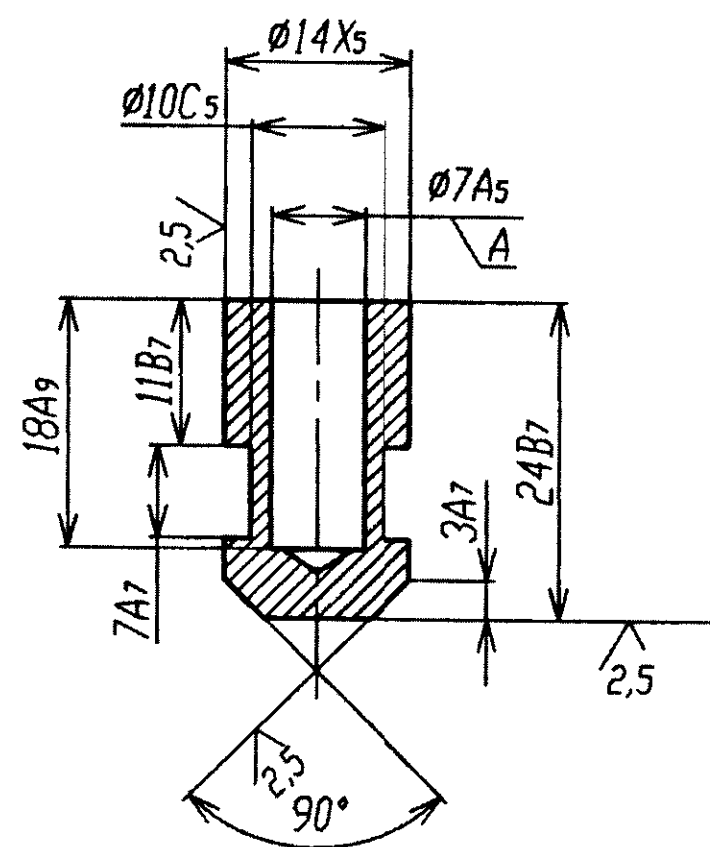
AK-630 SB-18-2SB

AK-630 СБ118-2СБ		Type	Scale
Лист	Масса	Лист	Масштаб
A	2,990	1:2	
Дверца		Sheet	Total sheets
Сборочный чертёж		Лист	Листов
ИЗМ/ИСТ	Н	ДОЗ/УМ	ПОЛП
ПОДП	ДАТО		
КОСОВ			
ЛЮБ			
Т.КОНТР.			
Н.КОНТР.			
УТВ.			

ФОРМАТ А2

AK-630 118-21

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



Rz40 (✓)

1. 38.5..44.5 HRC<sub>E</sub>. Check on specimen.
2. Blunt sharp edges ~0.4 mm.
3. Coating Cd6.phos.oil. It is permissible to avoid cadmium plating of hole A.
4. Mark Ш, Ч and stamp K on tag.

Amend.	Sheet	Doc. No.	Sign	Date

<b>AK-630 118-21</b>			
<b>Sleeve</b>	Type	Weight	Scale
	A	0.025	2:1
	Sheet		Sheets 1
Steel 50 GOST 1050-88			

Copied by

Format A4

<b>AK-630 118-22</b>					
Approved OGMet	Orig. Inv. No.	Sign and Date	Alternate Inv. No.	Approved TOsb	Dupl. Inv. No.
Approved KTONI	Sign and Date	Approved by shop			
				Reference No.	
				First use	

Rz40 (✓) (✓)

$\phi 18$   
 $2,5$   
 $20^\circ$   
 $2$   
 $58$   
 $Rz20$   
 $1 \times 45^\circ$   
 $\phi 25$   
 $5$

1. Substitute material: Steel 50A OST3-98-80.
2. Inner angles R~0.4 mm.
3. Blunt sharp edges ~0.4 mm.
4. Coating Cd12.phos.Oil.
5. Mark Ш, Ч and stamp K on tag.

Copied by

Format A4

First use

Reference No.

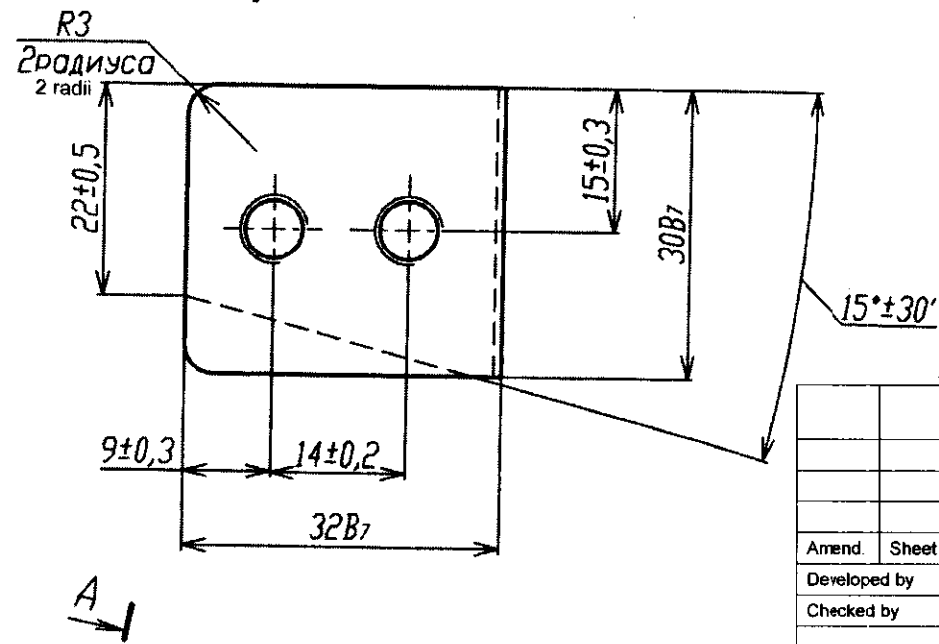
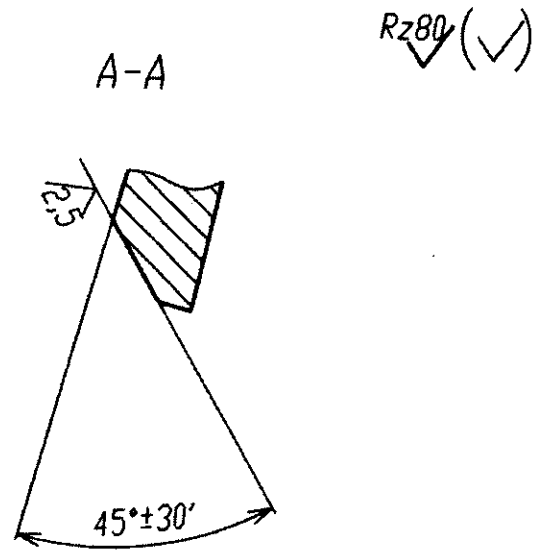
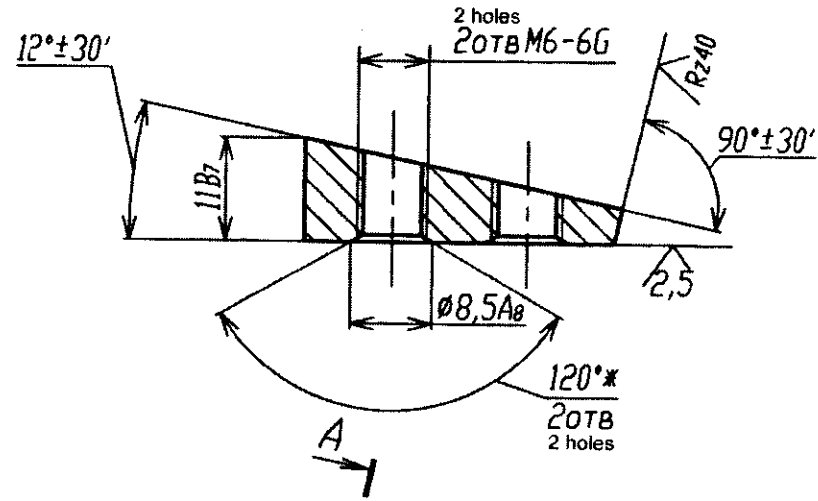
Sign and Date

Duplicate Inv. No.

Alternate Inv. No.

Sign and Date

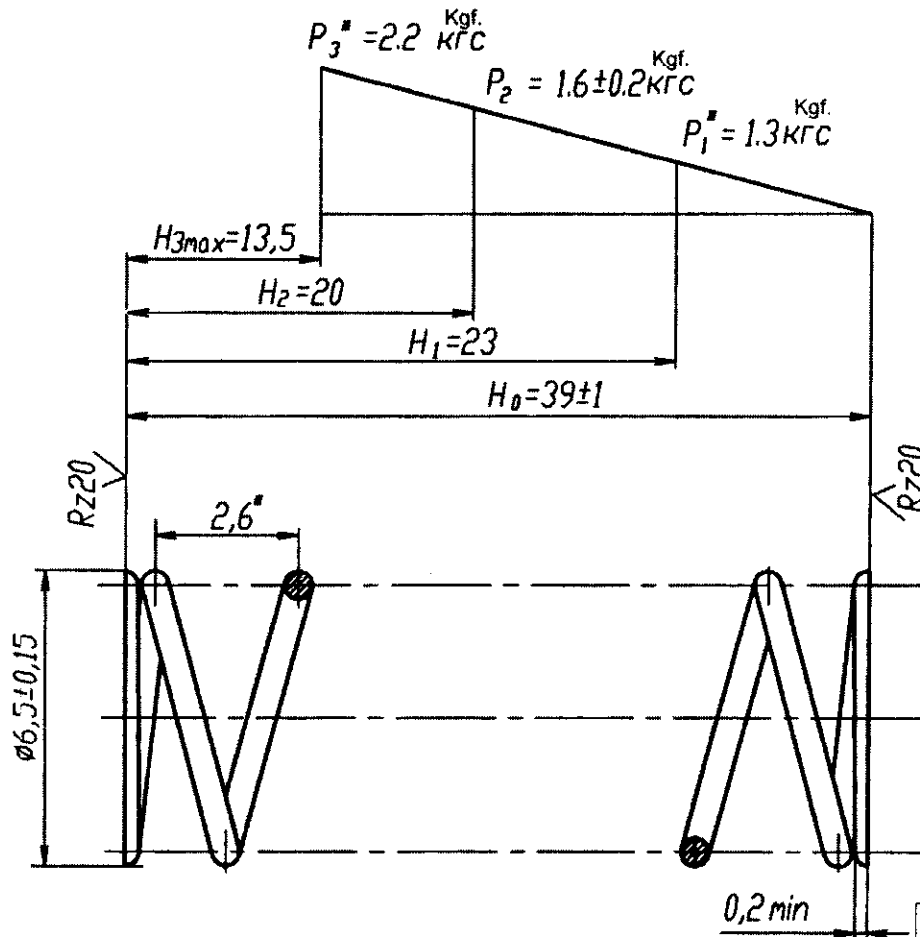
Orig. inv. no.



1. 38.5...44.5 HRC<sub>E</sub>. Check on test specimen.
- 2.\* Dimension ensured by tool.
3. Blunt sharp edges ~0.4 mm.
4. Coating Cd.12 Cr.
5. Mark Ш, Ч and stamp K, И on tag as per AK-630 TU, AK-630M TU I.

					AK-630 118-24			
Amend.	Sheet	Doc.No.	Sign	Date	Strap	Type	Weight	Scale
Developed by						A	0.030	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Steel 40 Kh GOST 4543-71			
Approved by								

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

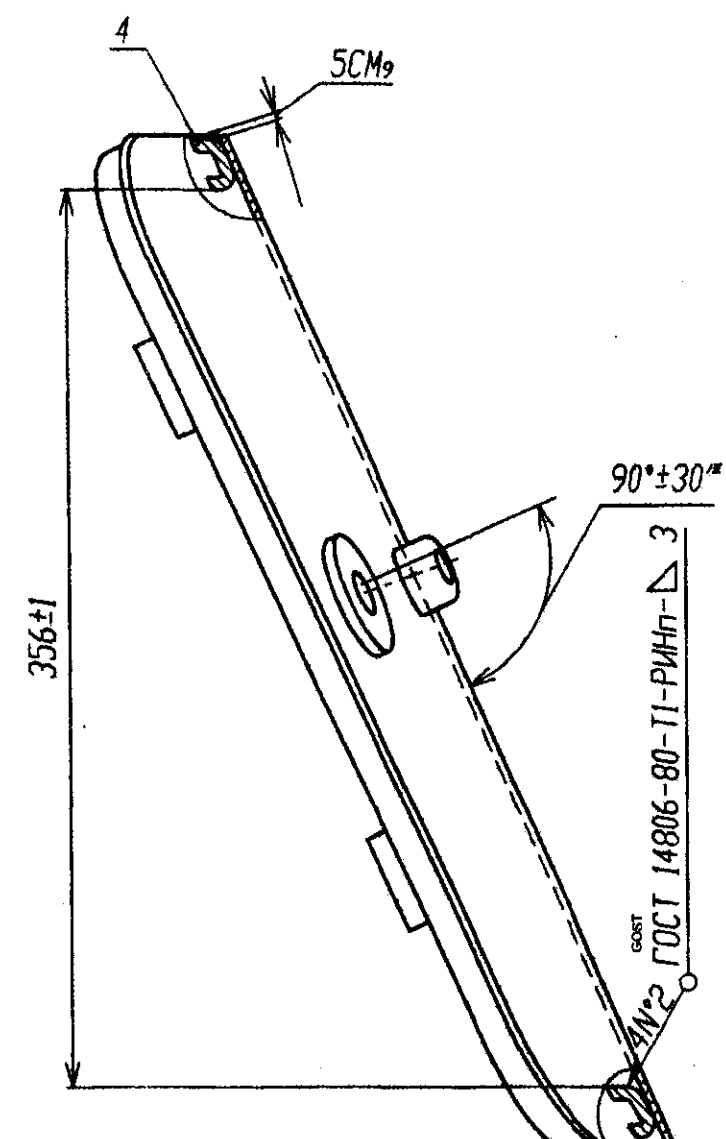
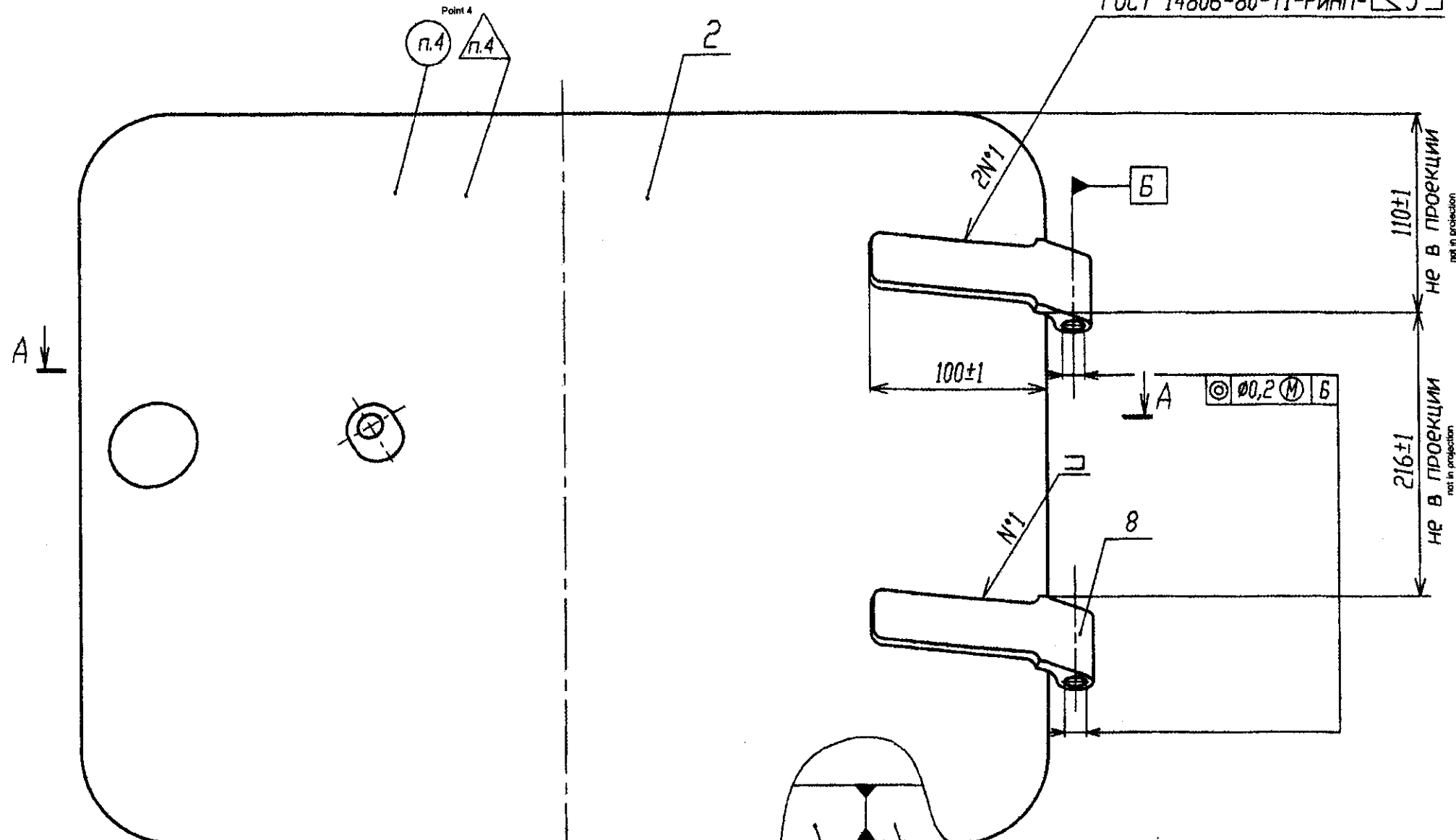


✓(✓)

1. Group III.
2. Shear module  $a = 8000 \text{ kgf/mm}^2$ .
3. Heat treatment- tempering  $240^\circ\text{C}-260^\circ\text{C}$ .
4. Tangential stress at twist (Maximum)  $\tau_3^* = 112 \text{ kgf/mm}^2$ .
5. Unrolled length of spring  $L^* = 320 \text{ mm}$ .
6. No. of working turns  $n = 14.5$ .
7. No. of complete turns  $n_1 = 16.5 \pm 0.5$ .
8. Coiling direction-right.
9. Diameter of control bar  $D_s$ , diameter of control shell  $D_0 = 7 A_s$ .
10. Pre deformation time (at  $N_2$ ) -24 hours.
11. Coating Chem.phos.accel. Cr./ impregnation with lacquer BF-4 with Nigrozene 2 layers, made as per OST3-4123-78, IV, OM2.
12. Other technical parameters as per GOST 16188-70.
- 13\* Dimensions and parameters for reference.
14. Mark Ш, 4 and stamp K on tag.

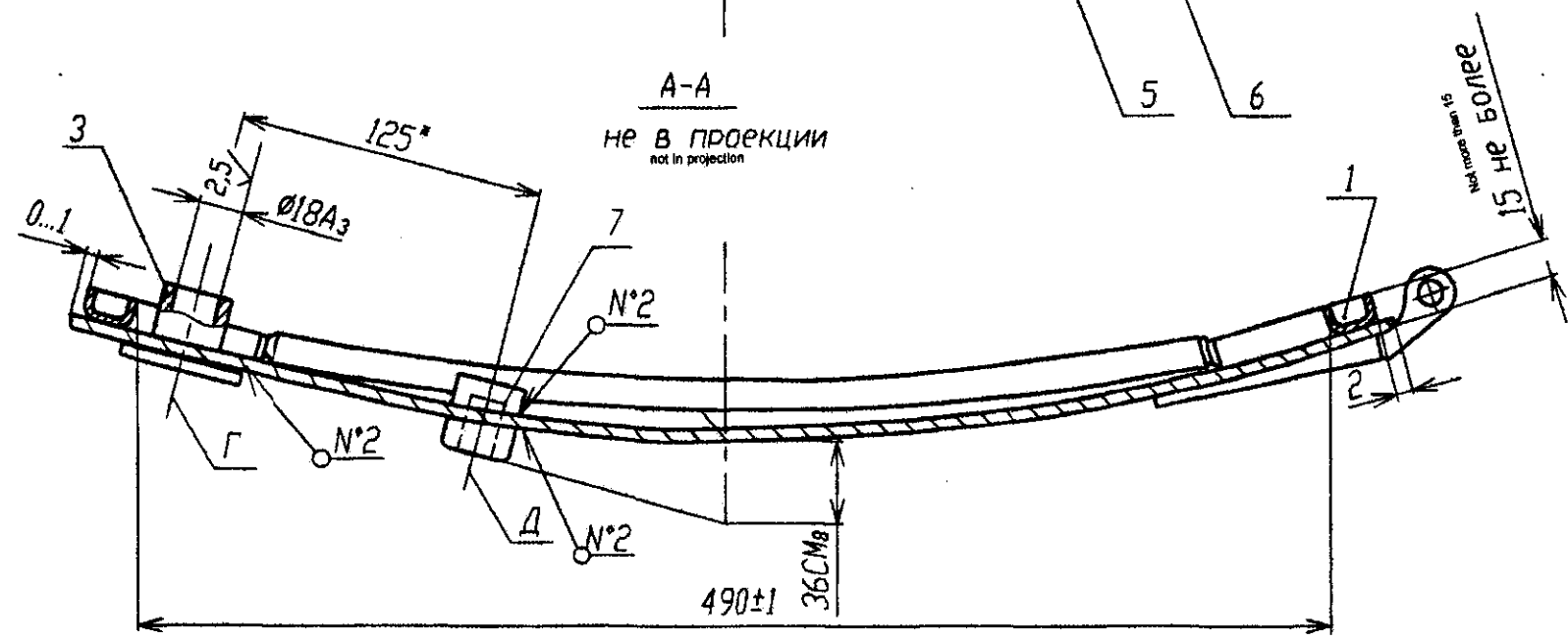
					AK-630 118-25			
Amend.	Sheet	Doc.No.	Sign	Date	Spring	Type	Weight	Scale
Developed by						A	0.00094	
Checked by						Sheet	Sheets 1	
Head of Q.C.D					Wire V-1-0.7			
Approved by					GOST 9389-75			

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A2			AK-630 Sb118-3 SB	Assembly drawing 163-9/6			
					<u>Assembly units</u>			
	A4	2		AK-630 Sb 118-7	Loop 163-7/13	1		
					<u>Components</u>			
	A3	1		AK-630 118-15	Shaping strip 163-5/14	2		
	A2	2		AK-630 118-30	Shutter 163-9/6	1		
	A4	3		AK-630 118-32	Bush 163-5/11	1		
	A3	4		AK-630 118-33	Shaping strip 163-5/14	1		
	A3	5		AK-630 118-34	Shaping strip 163-5/14	1		
A4	6		AK-630 118-35	Angle piece 163-5/11	4			
A4	7		AK-630 118-36	Stop 163-5/11	1			
Sign and Date								
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date								
Orig. Inv. No.								
				<b>AK-630 Sb 118-3</b>				
Amend.	Sheet	Doc. No.	Sign	Date				
Developed by					<b>Shutter</b>	Type	Sheet	Sheets
Checked by						A		1
Head of Q.C.D								
Approved by								



- 1. Argon arc welding with the use of filler electrode 4.0 Sv AMg6 GOST 7871-75.
- 2. \* - Dimensions are ensured by tool.
- 3. Non-parallelness of the axis of hole Г in relation to hole Д is not more than 0.3 mm.
- 4. Mark Ш, Ч and stamp К as per AK - 630, AK - 630M TU I.

1. Сварка аргонодуговая с применением присадочной проволоки 4,0 Св АМг6 ГОСТ 7871-75.
2. Размеры обеспеч. инстр.
3. Непараллельность оси отв. Г относительно отв.Д не более 0,3 мм.
4. Маркировать Ш, Ч и клеймить К по АК-630 ТУ, АК-630М ТУ I.



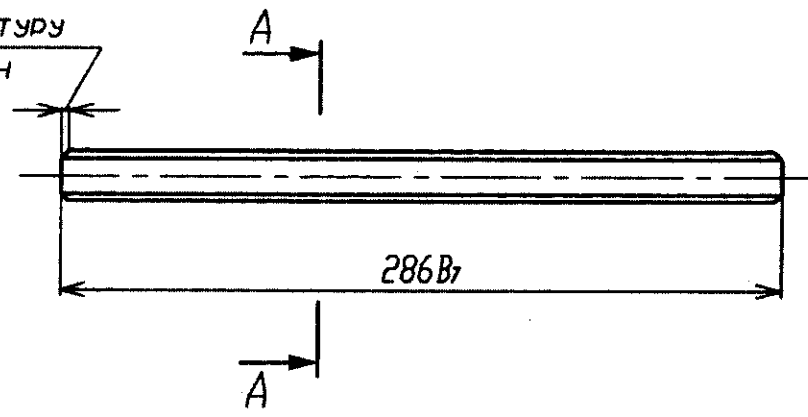
Листовая таблица

ИЗМ. ПОДП. ПОДАТЬ И ДАТА  
 ВЕРНУТЬ ИЛИ  
 ПОДАТЬ ИЛИ  
 ПОДАТЬ ИЛИ  
 ПОДАТЬ ИЛИ

		AK-630 СБ118 -ЗСБ		Type	Mass	Scale
ИЗМ.	Лист	№ докум.	Подп.	Дата	Лист	Масса
РАЗРАБ.					А	2,400
ПРОБ.					Лист	Листов
МОНТ.					Sheet	Total Sheets
ИЗМОНТ.						
УТВ.						

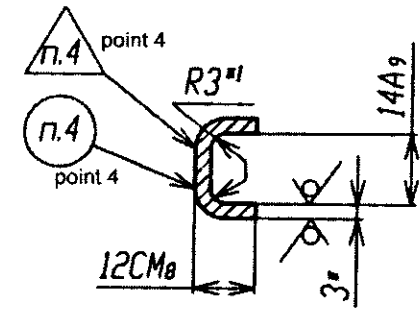
First use  
Reference No.  
Sign and Date  
Duplicate Inv. No  
Alternate Inv. No  
Sign and Date  
Orig. inv. no.

3x45° по наружному контуру  
ТОРЦА С 2-Х СТОРОН  
On external contour of  
face from 2 sides.



Rz80 (✓)

A-A (1:1)



- 1. \* Reference dimension.
- 2. \*1 Dimension ensured by tool.
- 3. Blunt sharp edges ~0.4 mm.
- 4. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

					AK-630 118-15			
Amend.	Sheet	Doc.No.	Sign	Date	Shaping strip	Type	Weight	Scale
Developed by						A	0.072	1:2
Checked by						Sheet	Sheets	1
Head of Q.C.D					Sheet AMg6 BM-3			
Approved by					GOST 21631-76			





AK-630 118-32

First use

Approved by shop  
Reference No.

Approved KTONI

Sign and Date

Approved TOSb  
Dupl. Inv. No.

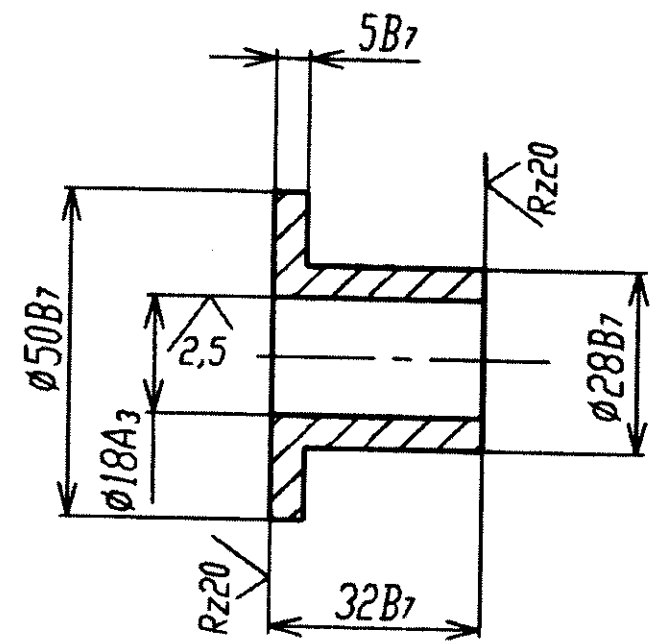
Alternate Inv. No.

Sign and Date

Approved OGMet  
Orig. Inv. No.

Amend.	Sheet	Doc. No.	Sign	Date

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



Rz80 (✓)

AK-630 118-32

Bush

Alloy AMg6 GOST 4784-97

Type	Weight	Scale
A	0.033	1:1

Sheet Sheets 1

Copied by

Format A4

AK-630 118-33

First use

Reference No.

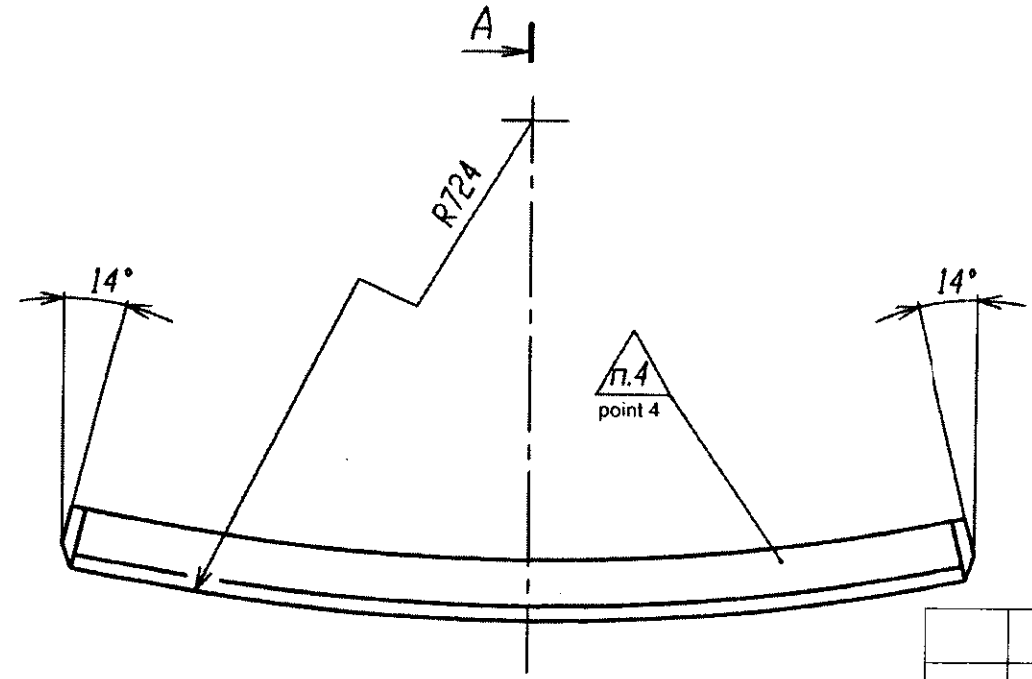
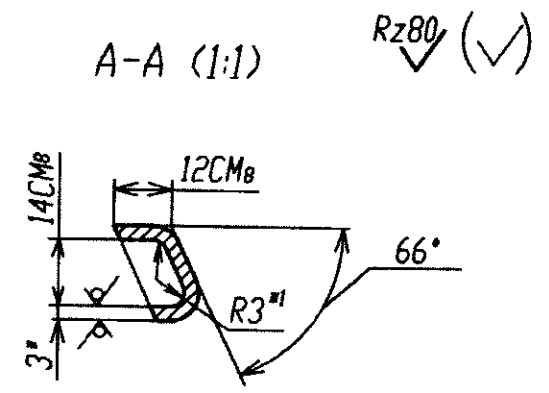
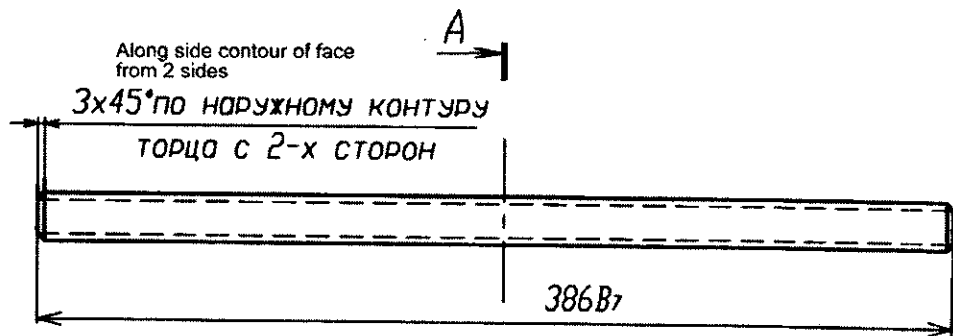
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

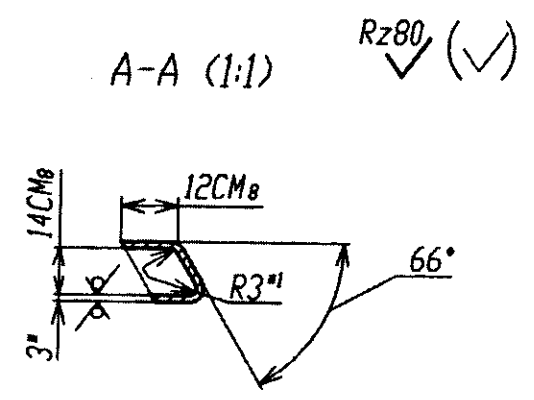
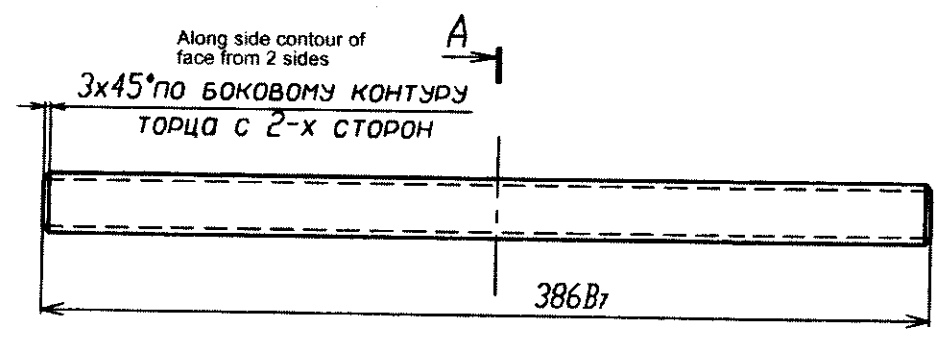
Orig. inv. no.



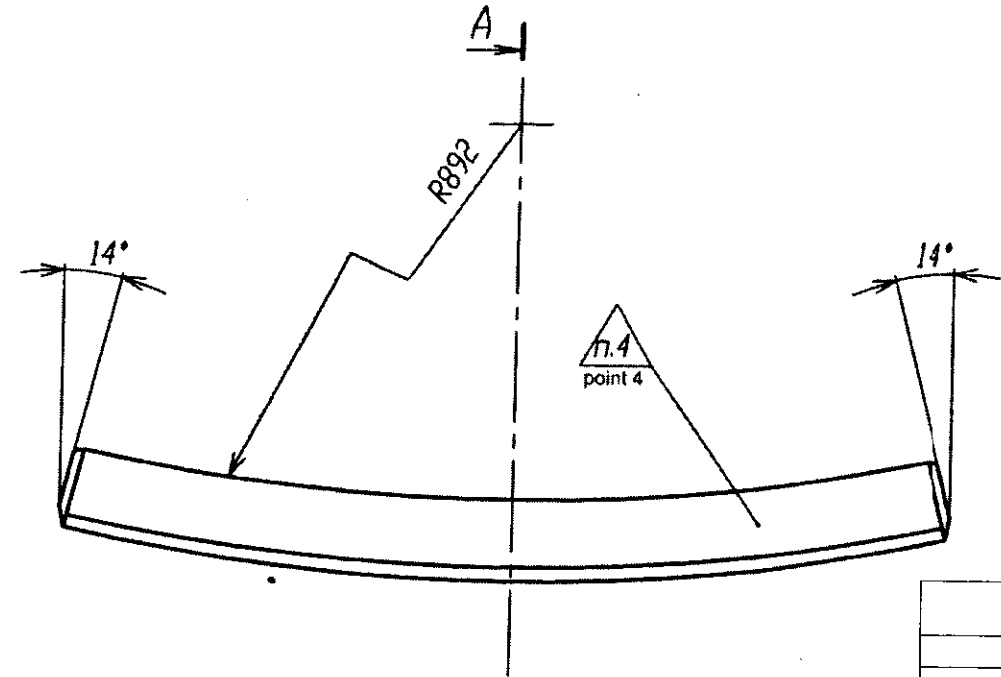
- 1.\* Reference dimension.
- 2.\*1 Dimension ensured by tool.
- 3. Blunt sharp edges ~0.4 mm.
- 4. Mark Ш, Ч on tag and stamp K as per AK-630 TU, AK-630M TU I.

					AK-630 118-33			
Amend.	Sheet	Doc.No.	Sign	Date	Shaping strip	Type	Weight	Scale
Developed by						A	0.110	1:2
Checked by						Sheet	Sheets	1
Head of Q.C.D					Sheet AMg6 BM-3 GOST 21631-76.			
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.\*1 Dimension ensured by tool.
- 3. Blunt sharp edges ~0.4 mm.
- 4. Mark Ш, Ч on tag and stamp K as per AK-630 TU, AK-630M TU I.

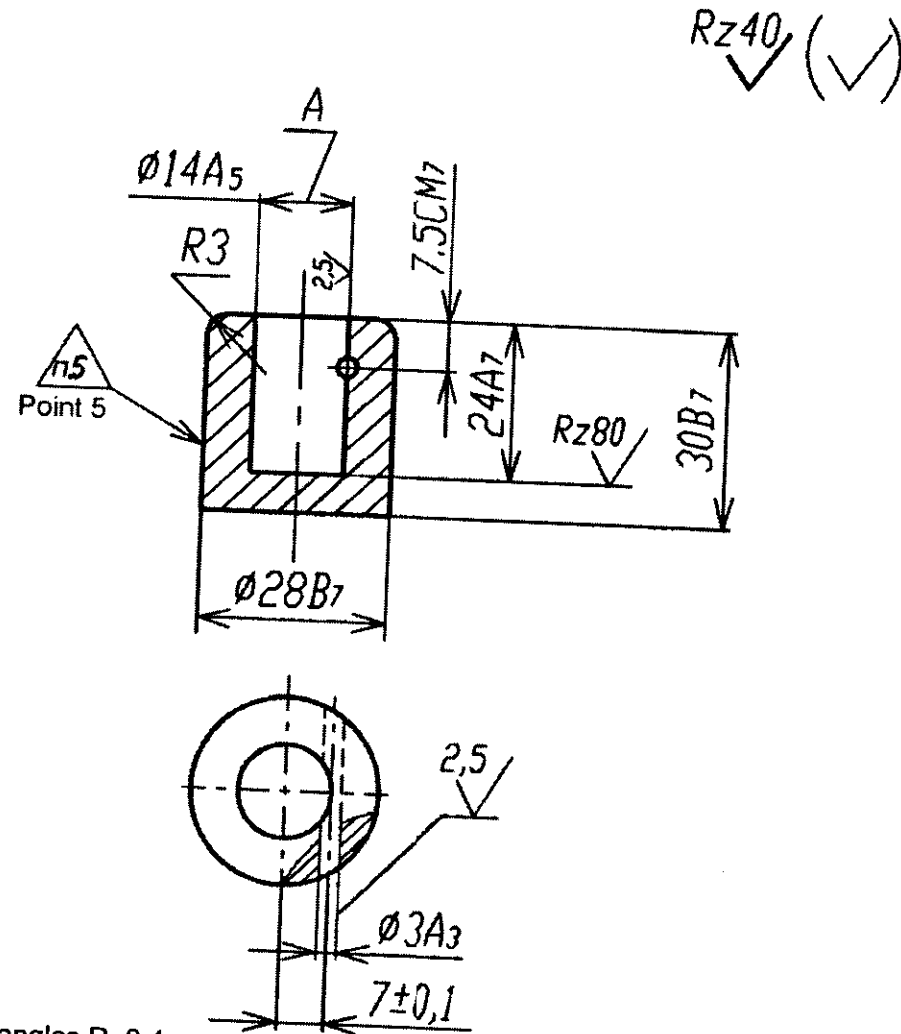


					AK-630 118-34			
Amend.	Sheet	Doc.No.	Sign	Date	Shaping strip	Type	Weight	Scale
Developed by						A	0.110	1:2
Checked by						Sheet	Sheets	1
Head of Q.C.D					Sheet AMg6 BM-3			
Approved by					GOST 21631-76.			



AK-630 118-36

Blank No. 406



1. Inner angles R~0.4 mm.
2. Blunt sharp edges ~0.4 mm.
3. anodic Oxid. Hard on inner surface A and adjoining face to it.
4. Mark III, 4 on batch tag.
5. Stamp K as per AK-630, AK-630M TU I.

Approved OGMet	Sign and Date	Alternate Inv. No.	Approved TOSb	Dupl. Inv. No.	Sign and Date	Approved KTONI	Reference No.	Approved by shop	First use
Orig. Inv. No.									
Amend.	Sheet	Doc. No.	Sign	Date	<b>AK-630 118-36</b>				
Developed by					<b>Stop</b>	Type	Weight	Scale	
Checked by						A	0.025	1:1	
Head of Q.C.D						Sheet	Sheets 1		
Design bureau chief					Alloy AMg6 GOST 4784-97				
Head of Q.C.D									
Approved by									

Copied by

Format A4



AK-630 Sb118-7 SB

First use

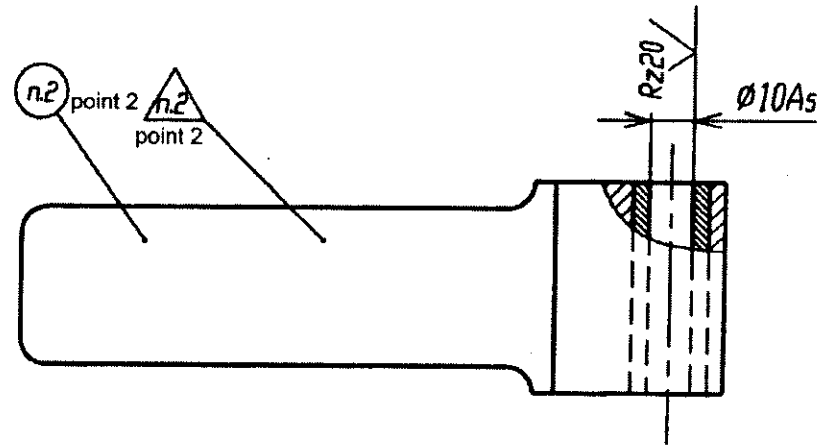
Reference No.

Sign and Date

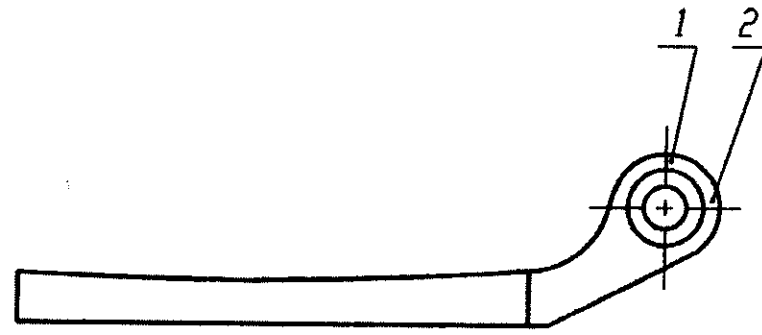
Duplicate Inv. No

Sign and Date

Orig. inv. no.



- 1. Blunt sharp edges ~0.4 mm.
- 5. Mark 4 and stamp K as per AK-630 AK-630 M TU I.

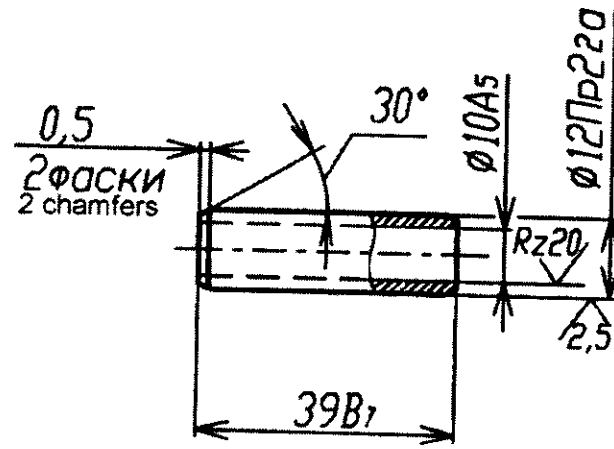


AK-630 Sb118-7 SB							
Amend.	Sheet	Doc.No.	Sign	Date			
Loop Assembly drawing					Type	Weight	Scale
					A	0.350	1:1
					Sheet	Sheets	1
Head of Q.C.D							
Approved by							



AK-630 118-37

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



Rz40 (✓)

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


AK-630 118-37

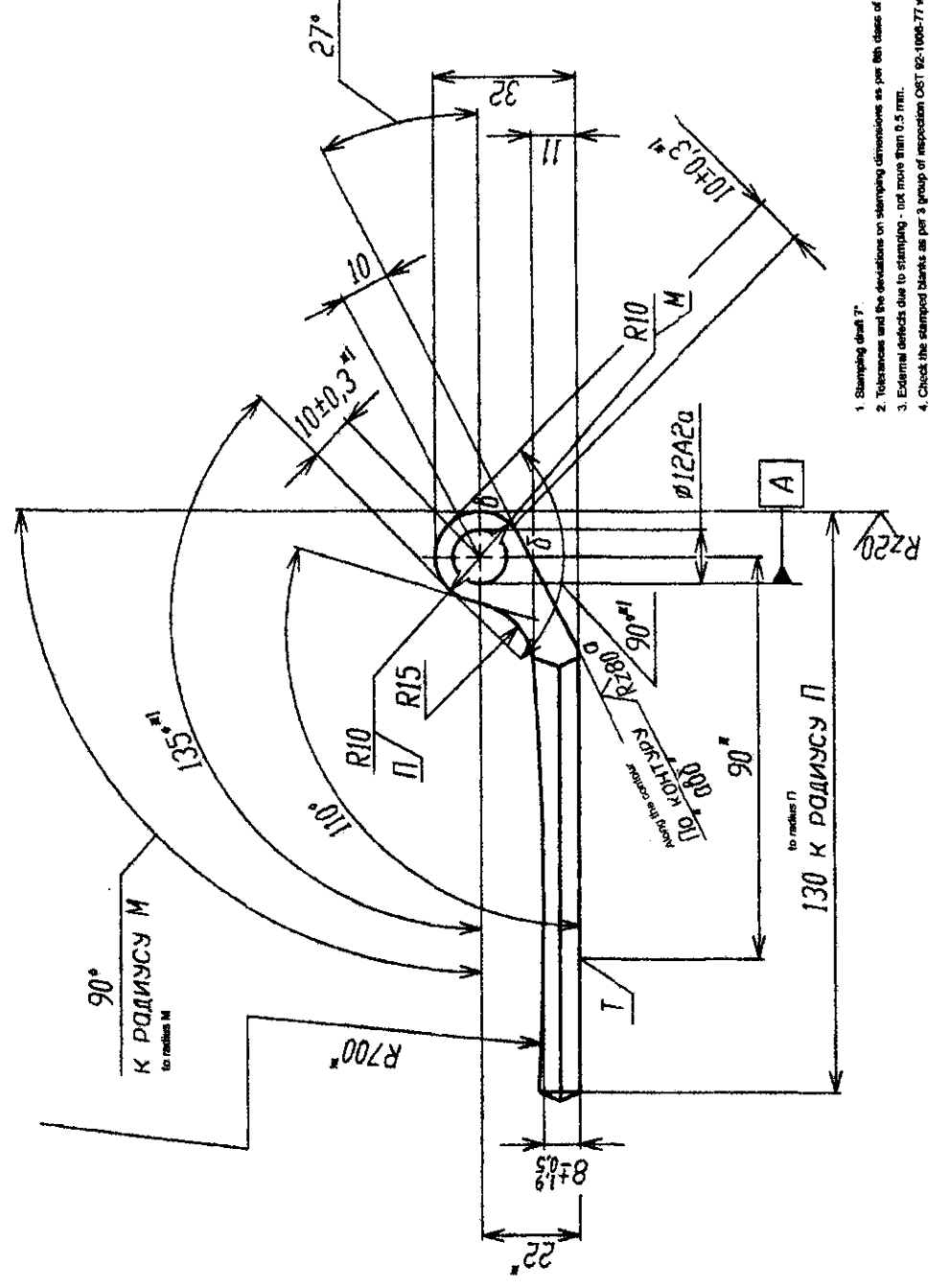
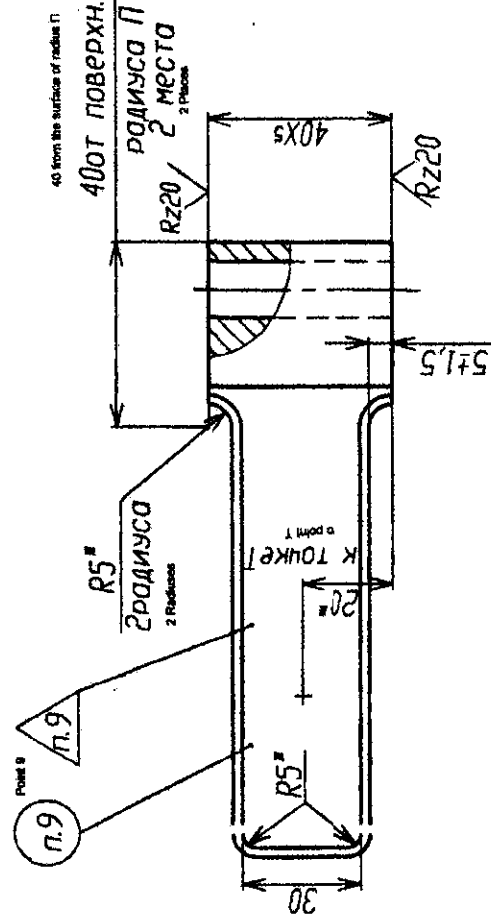
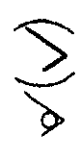
Bush

Steel 12Cr18Ni9Ti  
GOST 5632-72

Type	Weight	Scale
A	0.017	1:1
Sheet	Sheets 1	

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Format A4



1. Stamping draft T.
2. Tolerances and the deviations on stamping dimensions as per 8th class of accuracy - see per OST 1.41187-78.
3. External defects due to stamping - not more than 0.5 mm.
4. Check the stamped blanks as per a group of inspection OST 92-1008-77 with 100 % hardness test.
5. Dimensions are ensured by fit.
6. 1. Dimensions are given in relation to point T.
7. Tolerance along the contour "del" in respect of base surface A and point T - not more than 0.5 mm.
8. Bust the sharp edges - 0.8 mm.
9. Mark Ш, Ч and stamp К as per AK-630, AK-630M TU I.

1. Штамповочный уклон 7°.
2. Допуски и отклонения на штамповочные размеры по 6 классу точности по OST 1.41187-78.
3. Внешние дефекты от штамповки не более 0,5мм.
4. Контроль штампованных заготовок производить по 3 группе контроля OST 92-1008-77 со 100% проверкой твердости.
5. Размеры обеспеч. INSTR.
6. Размеры заданы относительно точки Т.
7. Допуск по контуру "обв" относительно базовой поверхности А и точки Т не более 0, 5мм.
8. Острые ребра притупить≈0,6мм.
9. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ту I.

№-№ ПОДЛ. (подл. и авто)	Взам.ин.№	И-№Н.К.№П.	Подл. и авто
Сред.№	Лев. пр.ин.№		

AK-630 118-31		Scale	
Тип	Масш.	Масш.	Масш.
Лист	А	Листов	1:1
Loop		Листов	
Петля		Листов	
AK-630 118-31		ГОСТ 4784-97	
Сллов АМГ 6		ГОСТ 4784-97	

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
								Reference No.
					<u>Documents</u>			
	A3			AK-630 Sb118-4 SB	Assembly drawing <del>163-5/14</del>			
					<u>Components</u>			
	A3	1		AK-630 118-2	Loop <sup>5/14</sup> <del>163-7/13</del>	1		
	A4	2		AK-630 118-41	Bush <del>163-5/11</del>	2		
Sign and Date					<b>AK-630 Sb 118-4</b>			
	Amend.	Sheet	Doc. No.	Sign				Date
Sign and Date					<b>Loop</b>	Type	Sheet	Sheets
						A		1
Orig. Inv. No.								
Orig. Inv. No.								
Head of Q.C.D								
Approved by								

AK-630 Sb 118-4 SB

First use

Reference No.

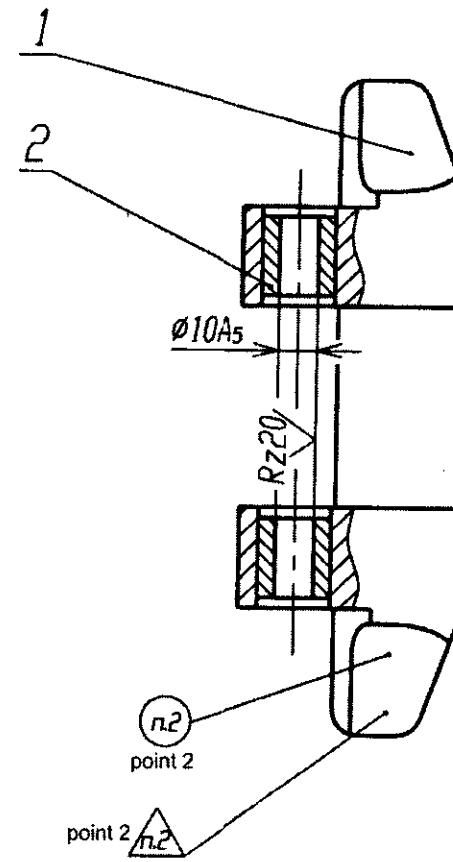
Sign and Date

Duplicate Inv. No.

Alternate Inv. No.

Sign and Date

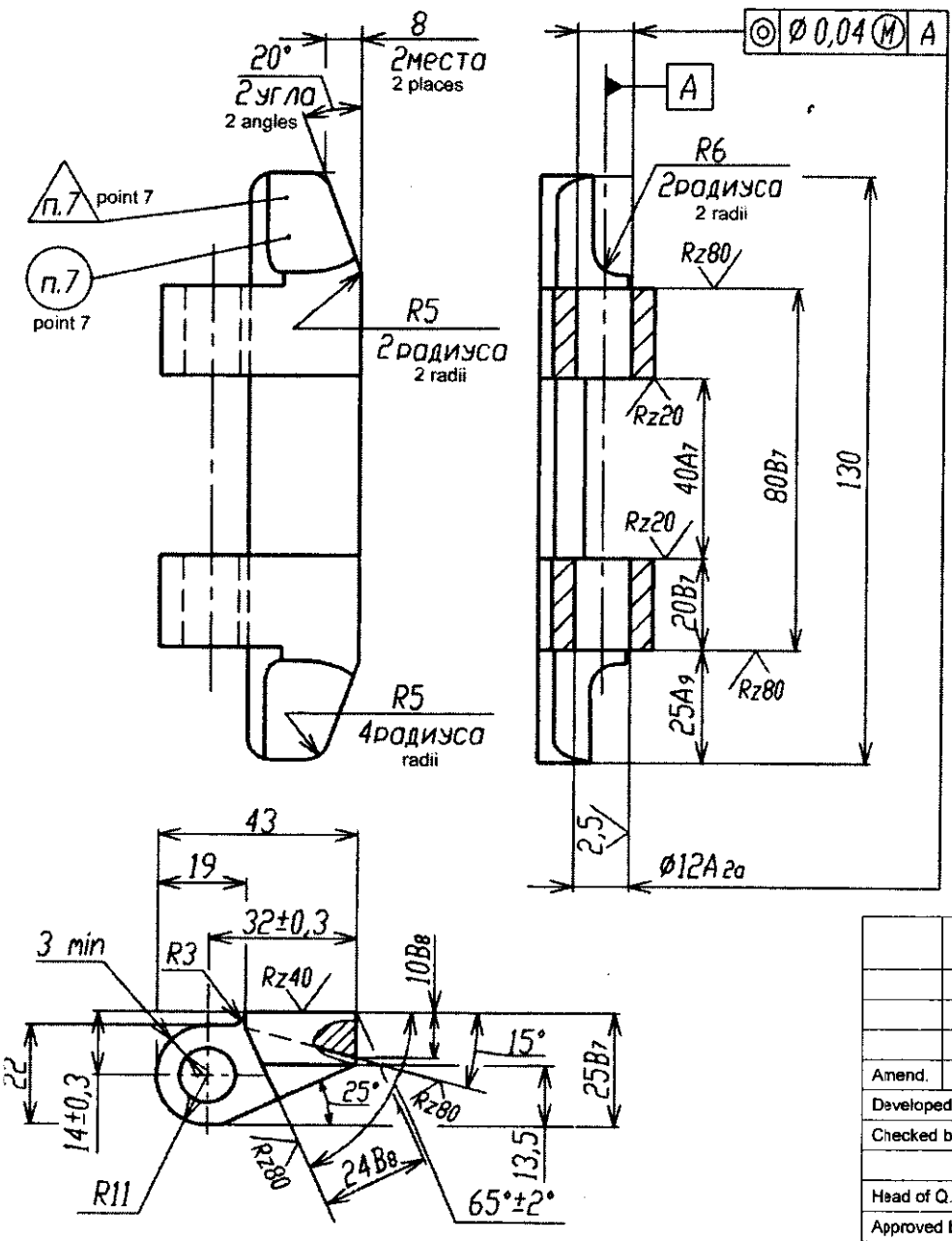
Orig. inv. no.



1. Faces of bushes pos.2 should not project beyond faces of loop pos.1.
2. Mark  $\nabla$  and stamp K as per AK-630, AK-630 M TU I.

					AK-630 Sb118-4 SB			
Amend.	Sheet	Doc.No.	Sign	Date	Loop Assembly drawing	Type	Weight	Scale
							A	0.090
Developed by						Sheet	Sheets	1
Checked by								
Head of Q.C.D								
Approved by								

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



1. Forging gradient 7°
2. Allowances and deviations for forging dimensions as per 6th accuracy class OST 1.41187-78.
3. External defects of forging up to 0.5 mm.
4. Inspection of forged blanks as per 3 rd group of inspection OST 92-1008-77 by checking hardness 100%.
5. Blunt sharp edges ~0.6 mm.
6. Inner angles R~0.4 mm.
7. Mark Ш, Ч and stamp K as per AK-630, AK630M TU I.

					AK-630 118-2			
Amend.	Sheet	Doc.No.	Sign	Date	Loop	Type	Weight	Scale
Developed by						A	0.080	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Alloy AMg6			
Approved by					GOST 4784-97			

AK-630 118-41

Approved OGMet	Sign and Date	Alternate Inv. No.	Approved TOSb	Dupl. Inv. No.	Sign and Date	Approved KTONI	Reference No.	Approved by shop	First use
<div style="text-align: center;"> </div> <p>1. Blunt sharp edges ~0.4 mm. 2. Mark Ш, Ч and stamp K on tag.</p>	AK-630 118-41								
Amend.	Sheet	Doc. No.	Sign	Date	<b>Bush</b>		Type	Weight	Scale
Developed by					Steel 12Cr18Ni9Ti GOST 5632-72		A	0.011	2:1
Checked by							Sheet	Sheets 1	
Head of Q.C.D									
Design bureau chief									
Head of Q.C.D									
Approved by									

Copied by

Format A4

First use										Reference No.									
Format	Zone	Pos.	Designation				Nomenclature				Qty.	Remarks							
<u>Documents</u>																			
A3			AK-630 Sb118-5 SB				Assembly drawing				163-5/14								
<u>Components</u>																			
A2	1		AK-630 118-20				Handle				163-9/16	1							
A4	2		AK-630 118-27				Bush				163-5/11	1							
Sign and Date		Amend.		Sheet	Doc. No.	Sign	Date	<b>AK-630 Sb 118-5</b>											
		Developed by																	
		Checked by						<b>Handle</b>		Type	Sheet	Sheets							
										A		1							
		Head of Q.C.D																	
Approved by																			
Orig. Inv. No.																			
Sign and Date																			
Dupl. Inv. No.																			
Sign and Date																			

AK-630 Sb118-5 SB

First use

Reference No.

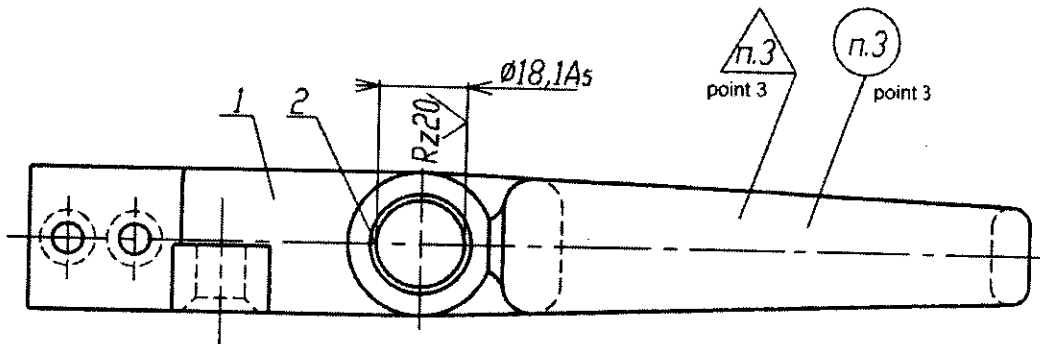
Sign and Date

Duplicate Inv. No.

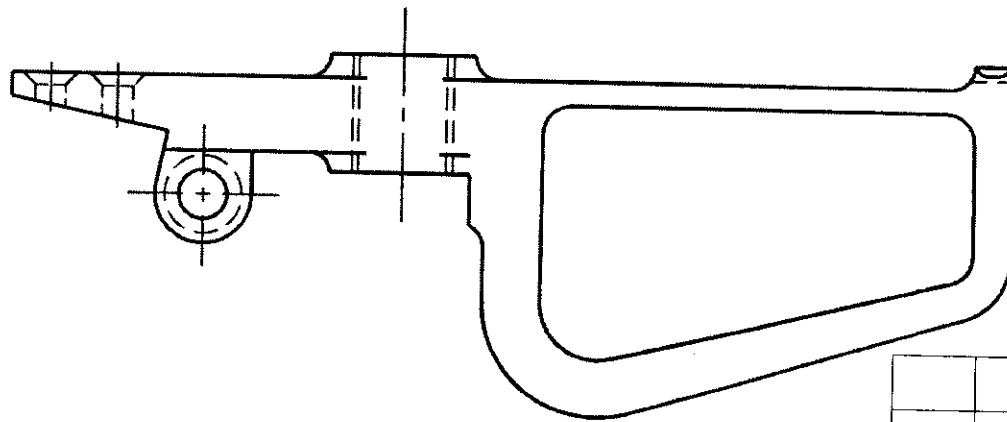
Alternate Inv. No.

Sign and Date

Orig. inv. no.



1. Faces of bush pos.2 should not project beyond faces of handle pos.1.
2. Blunt sharp edges ~0.2 mm.
3. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

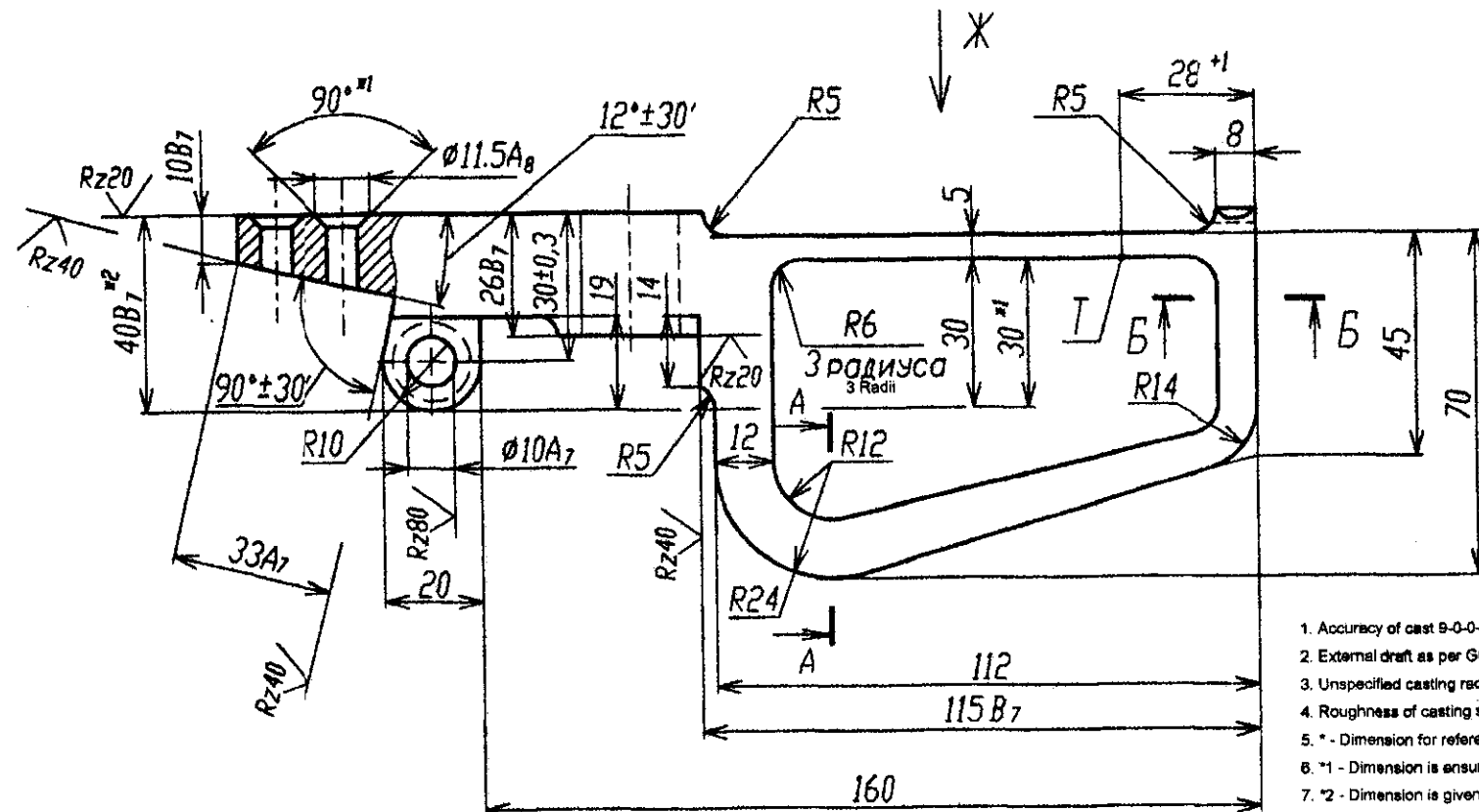
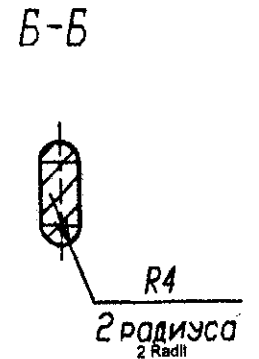
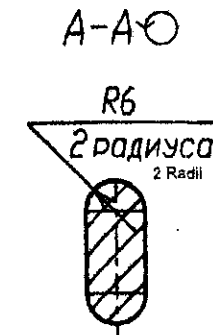
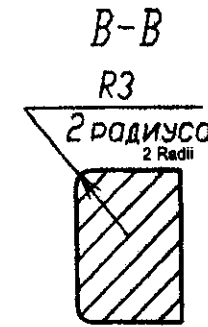
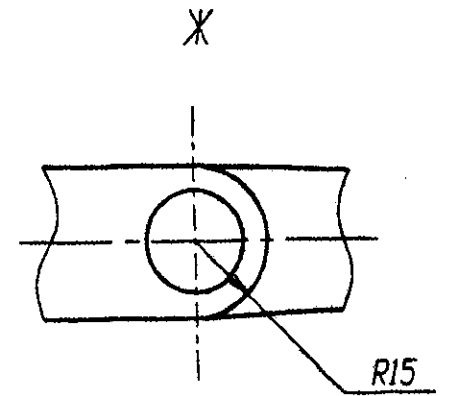
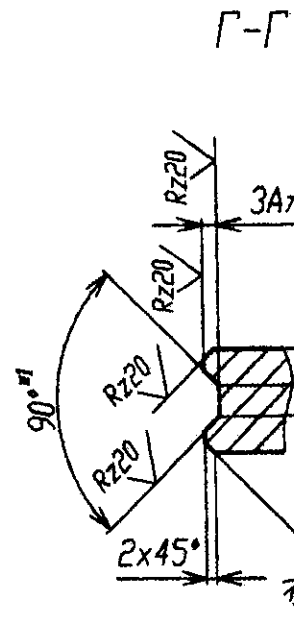
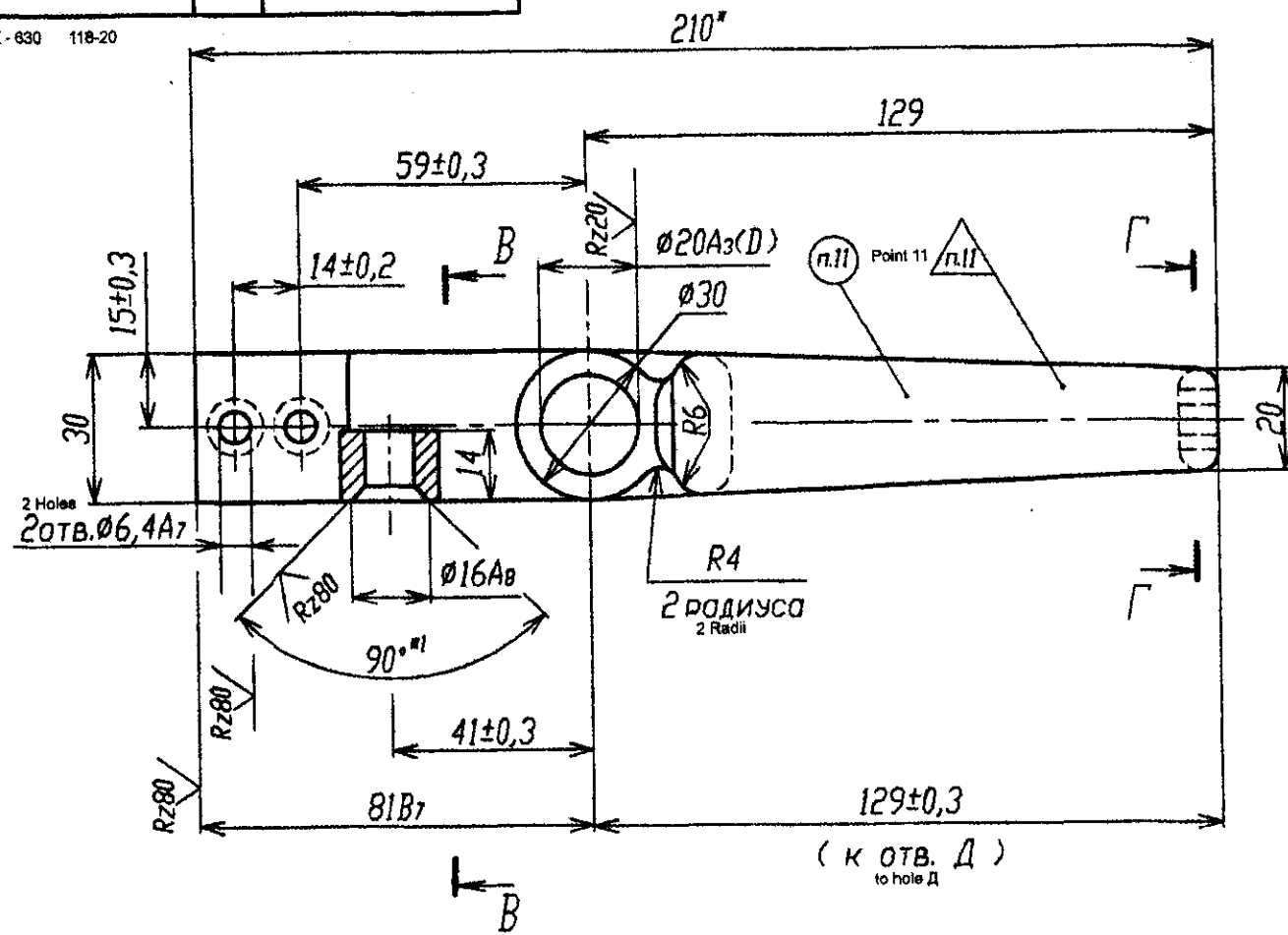


					AK-630 Sb118 - 5 SB			
Amend.	Sheet	Doc.No.	Sign	Date	Handle Assembly drawing	Type	Weight	Scale
							A	0.450
Developed by						Sheet Sheets 1		
Checked by								
Head of Q.C.D								
Approved by								



AK-630 118-20

AK-630 118-20



1. Accuracy of cast 9-0-0-9 GOST 26645-85.
2. External draft as per GOST 3212-92.
3. Unspecified casting radii - 3 mm.
4. Roughness of casting surface - as per test - specimen.
5. \* - Dimension for reference.
6. \*1 - Dimension is ensured by tool.
7. \*2 - Dimension is given in respect to point "T".
8. Internal angles R - 0.4 mm.
9. Blunt the sharp edges - 0.4 mm.
10. Coating Hard An. Ox.
11. Mark Ш, Ч, П and stamp K as per AK-630, AK-630M TU I.

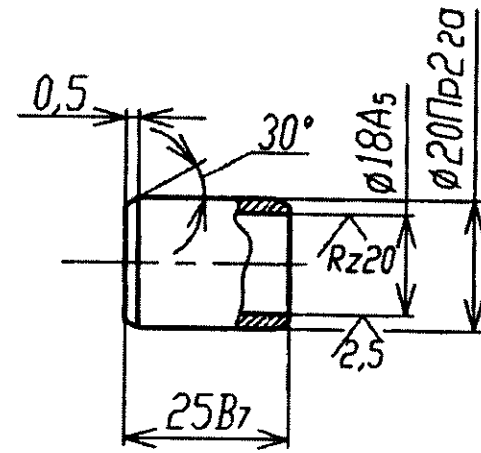
1. Точность отливки 9-0-0-9 ГОСТ 26645-85.
2. Формовочные уклоны по ГОСТ 3212-92 в сторону увеличения размеров.
3. Неуказанные литейные радиусы  $R \approx 3$  мм.
4. Шероховатость литейной поверхности по контрольному образцу.
5. \* Размер для справок.
6. \*1 Размер обеспеч. INSTR.
7. \*2 Размер задан относительно точки "Т".
8. Внутренние углы  $R \approx 0,4$  мм.
9. Острые ребра притупить  $\approx 0,4$  мм.
10. Покрытие Ан. Окс. тв.
11. Маркировать Ш, Ч, П и клеймить К по АК-630, АК-630М ТУ I.

AK-630 118-20			Type	Mass	Scale
AK-630 118-20			Лит.	0,27	1:1
Handle			Лист	Листов	
Ручейка			Лист	Листов	
11-OST 3-4227-79			Sheet	Total Sheets	
Casting			AMG LCH-T4 GOST 1583-89		
Отливка			Формат А2		

Base 9\_ Container 6

AK-630 118-27

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



Rz40 (✓)

1. Substitute material Steel 50A OST3-98-80.
2. 34-39.5HRC<sub>E</sub>. Check on specimen.
3. Blunt sharp edges ~0.4 mm.
4. Coating: Cd12 phos. oil.
5. Mark Ш, Ч and stamp K on tag.

Amend.	Sheet	Doc. No.	Sign	Date

AK-630 118-27			
Type	Weight	Scale	
		A	0.012
Sheet		Sheets 1	
Steel 50 GOST 1050-88			

Copied by

Format A4



AK-630 Sb118-10 SB

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

1.\* Reference dimension.  
 2. before pasting the canvas pos.2 with adhesive 88 NP TU 38.105 540-85 unfold nylon fabric, inner side of the cloth should fit to component pasted.  
 3. Application of adhesive 88-SA TU 38.105 1760-89 is permissible.  
 4. Mark Ш, Ч and stamp K on tag.

<b>AK-630 Sb118-10 SB</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				

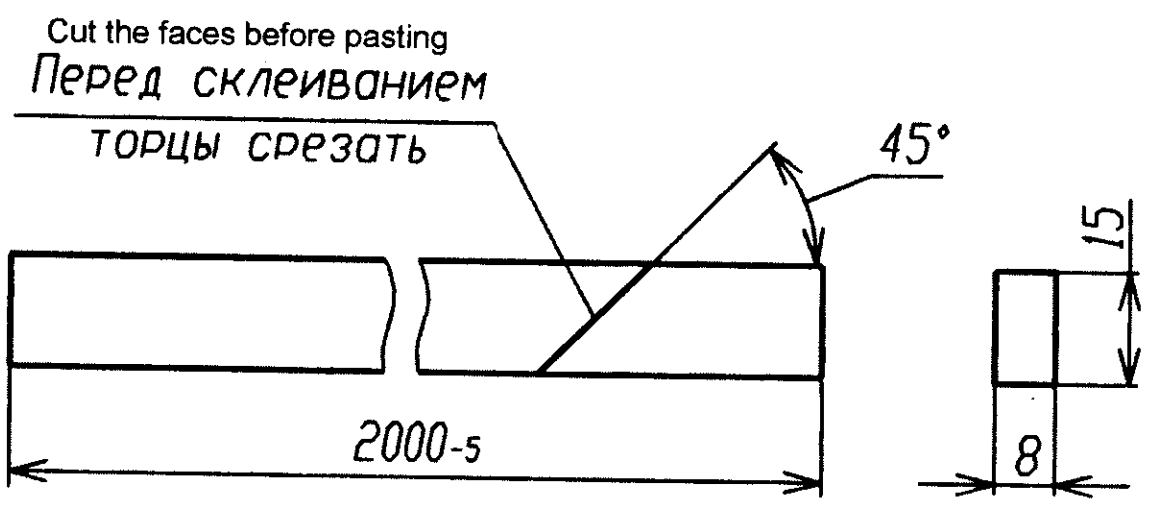
<b>Seal Assembly drawing</b>			
Type	Weight	Scale	
A	0.240	1:1	
Sheet		Sheets 1	

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Format A4

AK-630 118-5

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



1. It is permissible to paste using several parts.
2. 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-630 118-5			
Seal	Type	Weight	Scale
	A	0.220	1:1
	Sheet		Sheets 1
Spongy plate I-8 TU 38 105867-90			

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Format A4

AK-630 118-48

Approved OGMet  
 Orig. Inv. No.  
 Checked by  
 Head of Q.C.D  
 Design bureau chief  
 Approved by

Sign and Date

Alternate Inv. No.

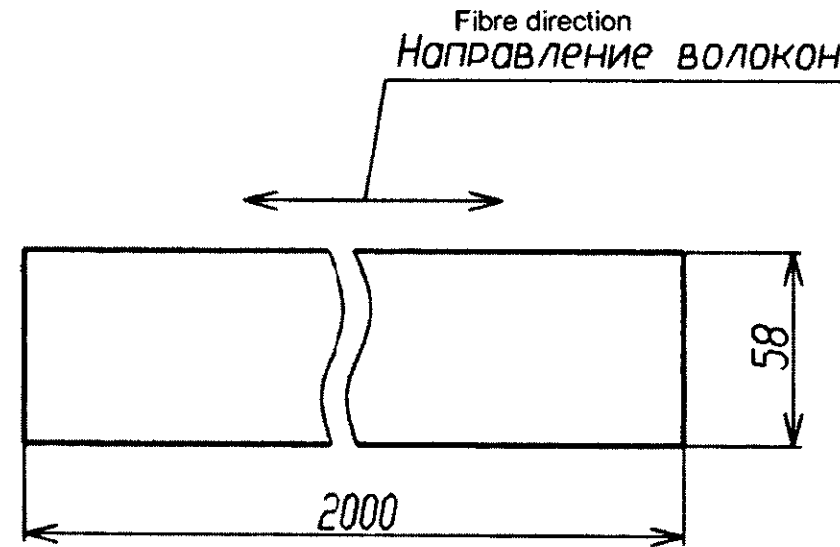
Approved TOsb  
 Dupl. Inv. No.

Sign and Date

Approved KTONI  
 Sign and Date

Approved by shop  
 Reference No.

First use



1. Arrange non stretching fibres in cross section.
2. Mark Ш, Ч and stamp K on tag

Amend.	Sheet	Doc. No.	Sign	Date

AK-630 118-48

Sheet

Type	Weight	Scale
A	0.165	1:2
Sheet	Sheets 1	

Fabric 300V  
 TU 105-1578-83

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Format A4

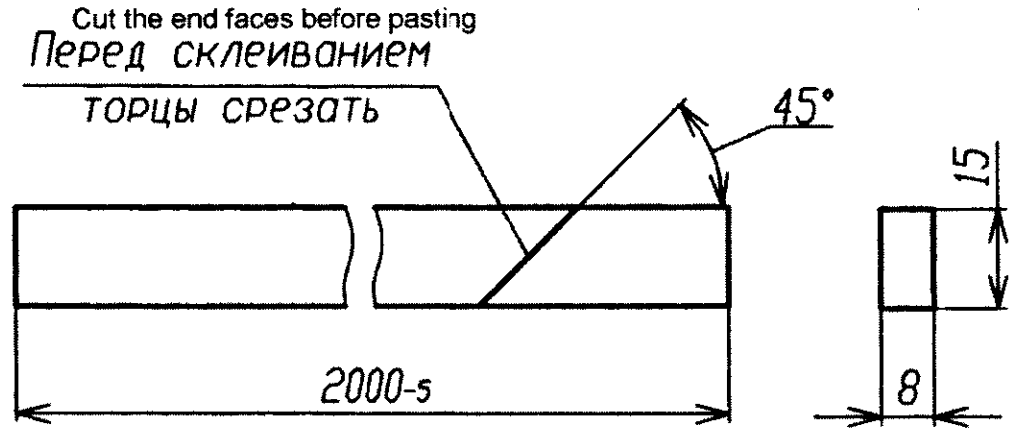
First use		Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
Reference No.						<u>Documents</u>		
	A4				AK-630 Sb118-11 SB	Assembly drawing <i>163-7/13</i>		
						<u>Components</u>		
	A4	1			AK-630 118-23	Seal <i>163-5/11</i>	1	
	A4	2			AK-630 118-49	Cloth <i>163-5/11</i>	1	
Sign and Date	<b>AK-630 Sb 118-11</b>							
	Amend.	Sheet	Doc. No.	Sign	Date			
	Developed by					Type	Sheet	Sheets
	Checked by					A		1
Orig. Inv. No.	Head of Q.C.D					<b>Seal</b>		
	Approved by							





AK-630 118-23

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



1. Pasting with several pieces is permissible.
2. Mark Ш, Ч and stamp K on tag.

Amend.	Sheet	Doc. No.	Sign	Date

AK-630 118-23

Packing

Type	Weight	Scale
A	0.230	1:1
Sheet	Sheets 1	

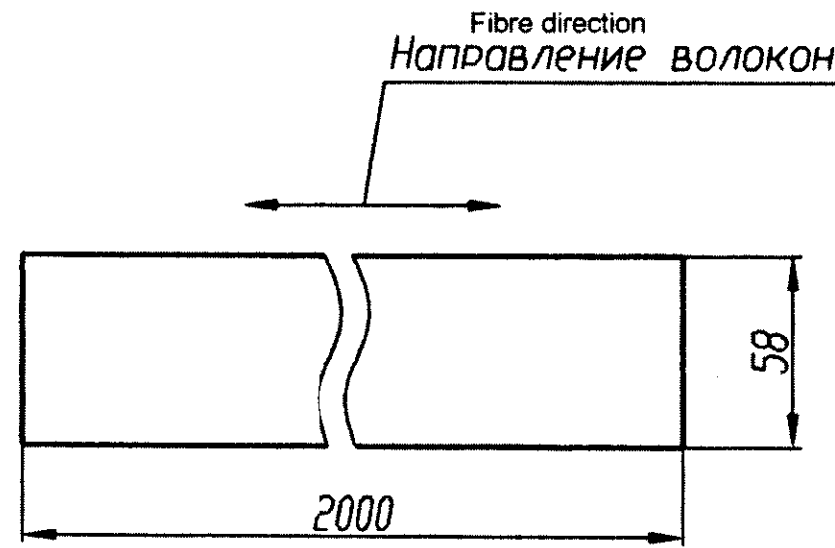
Sponged plate  
 I-8 TU 38 105867-90

Copied by

Format A4

AK-630 118-49

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



1. Arrange non stretching fibres in cross section.
2. Mark Ш, Ч and stamp K on tag

Amend.	Sheet	Doc. No.	Sign	Date

AK-630 118-49			
Sheet	Type	Weight	Scale
	A	0.145	1:2
Sheet		Sheets 1	
Fabric 300V TU 105-1578-83			

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Format A4