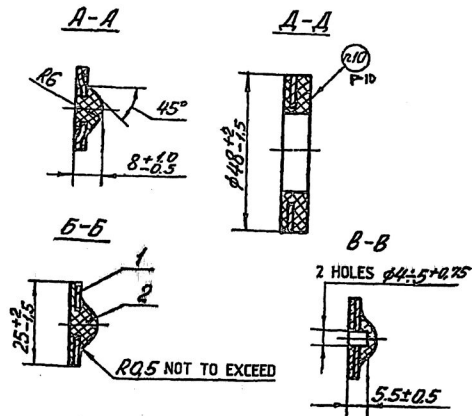
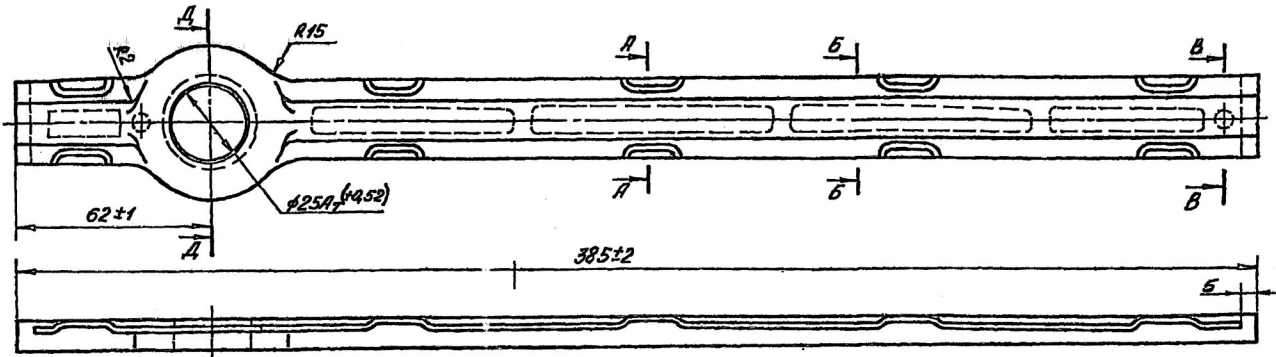


DRAWING NUMBER  
172.02.139cbCb

SHEET No. 1 OF 1



- (13D) 1. COMPONENT ITEM NO2 IS TO BE MANUFACTURED FROM RUBBER HD-68-1 TY 005216-75.
2. A FILM OF RUBBER ON UNRUBBERIZED SURFACES IS ALLOWED.
3. SHIFT OF AXIS OF DIE SHOULD NOT EXCEED 1mm.
4. ON THE SURFACES OF BOTH SIDES OF STAMPINGS ON LENGTH NOT LESS THEN 10mm AND ON WIDTH NOT LESS THEN 15mm AND ON EDGES, PRESENCE OF RUBBER IS NOT ALLOWED. DRESSING IS ALLOWED.
5. LOCAL CAVITIES WITH DIAMETER UP TO 4mm AND DEPTH UP TO 1mm TOTALLY IN QUANTITY NOT MORE THEN 4 ON SURFACE OF RUBBER ARE ALLOWED.
- (13D) 6. TECHNICAL REQUIREMENTS FOR ACCEPTANCE OF COMPONENTS SHOULD BE AS PER TY-005216-75 CODE-253464. NBR + CR (BNC Grade of CQA(HV))
7. ROUNDING OFF OF CORNERS WITH RADIUS UP TO 1mm IS ALLOWED.
8. GASKET IS TO BE GLUED BY HOT PROCESS (vulcanisation of rubber) WITH GLUE 'LEUKONAT' TY 6-14-95-75.
9. PEELING OFF OF LAYER UP TO DEPTH OF 4mm IN STAMPING AREAS IS ALLOWED.
10. NOTATION OF MANUFACTURING PLANT & COMPONENT NUMBER SHOULD BE MARKED BY RAISED TYPE AS PER 110.3 GOST 2930-62.

NBR + CR (BNC Grade of CQA(HV)) **EXPLANATORY NOTE:**

RUBBER HD - 68 - 1 Ty 005216-75.

CHEMISTRY	PHYSICAL PROPERTIES AND HARDNESS
NOT APPLICABLE	WORKING MEDIUM : AIR, OILS, LUBRICANTS TYPE OF RAW RUBBER : CKH-16 WORKING TEMPERATURE : -50 TO +100° C RUPTURE STRENGTH : 90 Kg/cm <sup>2</sup> (min) ELONGATION : 250 % (min) RESIDUAL ELONGATION : 12 % Max. HARDNESS (TYP) DEVICE : 55 - 70 DENSITY : 1.24 g/cm <sup>3</sup> ± 0.05 DURING USE IT SHOULD WITHSTAND A PRESSURE UPTO 100 Kg/cm <sup>2</sup>
PASTE (LEUKONAT) TY6 - 14 - 95 - 75.	
CHEMISTRY	PHYSICAL PROPERTIES AND HARDNESS
CONTENT OF 4,4'-4" TRITANETRISOCYANATE : 20 ± 1 % CONTENT OF INSOLUBLE INCLUSIONS IN DICHLOROETHANE = 0.1 % (max)	STRENGTH OF BOND BETWEEN RUBBER AND STEEL } = 40 Kg/cm <sup>2</sup> (min) DRYING OUT TIME : 40 minutes (max)

(13C) **EQUIVALENT MATERIAL:** (13D)  
NBR + CR (BNC Grade of CQA(HV)).

\*\* PV572.0718.0140 (13B)

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

EST. WT. 0.14 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	Sd/=	MATERIAL:-	USED ON :- 188.02.079cbCb
CHD	Sd/=	(13A)	172.02.079 C5-6
APPD	Sd/=	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
DATE	Dr. (.9)	TITLE:- <b>GASKET</b>	
SCALE:- 1:1		D S CAT NUMBER	
DIMENSIONS IN mm		DRAWING NUMBER	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69		172.02.139cbCb	
ALL THREADS TO CONFORM TO			
ISSUE	DATE	NATURE OF AMENDMENTS	

F-12  
10

SIZE A2

" COMMON TO T-90 " & BLT  
DRG.RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE-13

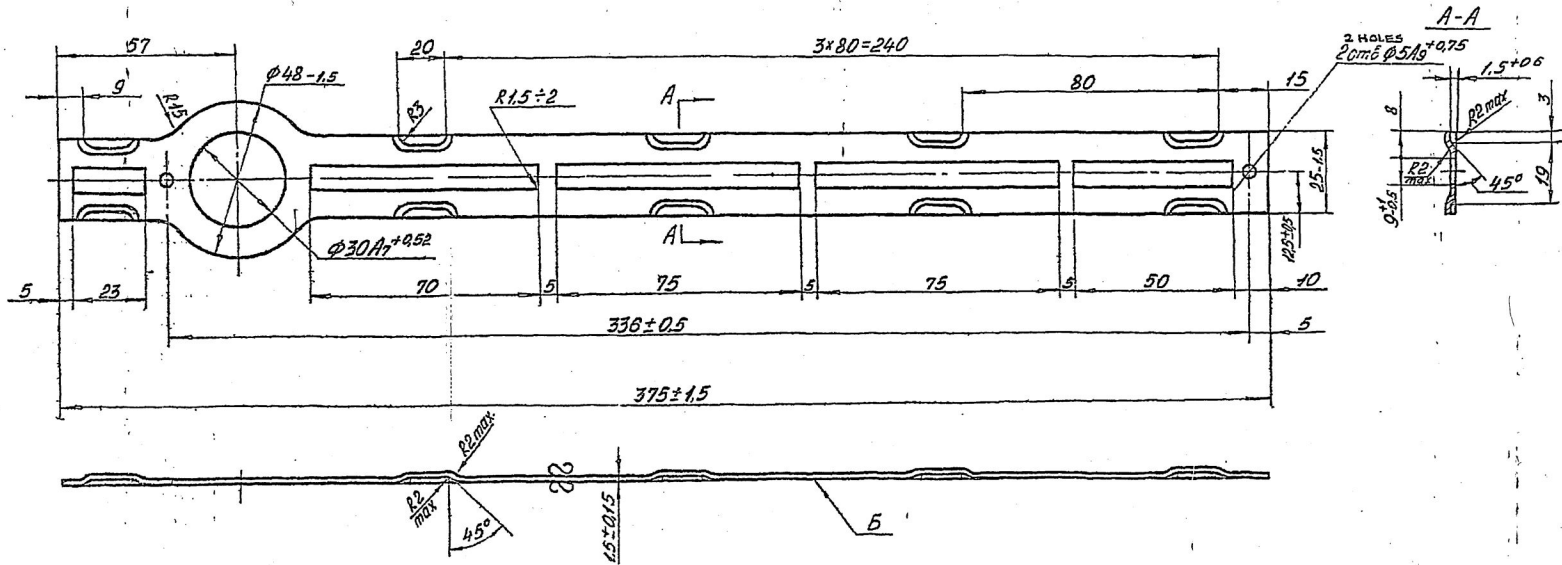
(B.JAYAVELU),JTDID  
-04-08



DRAWING NUMBER  
172.02.522

SHEET No. 1 OF 1

UNLESS OTHERWISE SPECIFIED ∇ 1



**EXPLANATORY NOTE**

DEEP DRAWN STEEL 10K11 GOST : 16523-70 .

CHEMISTRY	PHYSICAL PROPERTIES AND HARDNESS
C : 0.07 - 0.14	TENSILE STRENGTH : 28 - 40 Kgf/mm <sup>2</sup>
Si : 0.07 (max)	RELATIVE ELONGATION : 25 %
Mn : 0.25 - 0.50	BEND TEST : SHOULD WITHSTAND 180° BEND WITHOUT CRACK.
Cr : 0.10 (max)	
S : 0.040 (max)	CUPPING TEST : 112 mm SPHERICAL INDENTATION TO BE MADE BEFORE CRACKING.
P : 0.035 (max)	

1. MAY BE MANUFACTURED FROM OPEN HEARTH STEEL 10K11 5-III Г GOST 16523-70.
2. NON FLATNESS OF SURFACE "Б" SHOULD NOT BE MORE THEN 1.5mm.
3. DEVIATION ON DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE ±1.0 mm.
4. SHRINKAGE OF EDGES IN PLACES OF STAMPED RECESSES IS NOT TO BE CHECKED.
5. CORRUGATIONS AND TOOL MARKS ARE ALLOWED ON COMPONENT SURFACE.
6. THE REST OF REQUIREMENTS ACCORDING TO TY 005216-75 ( APPENDIX 1).

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

EST. WT. 0.1 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.

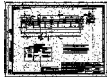
DRN	Sd/=	MATERIAL :-	USED ON :-
CHD	Sd/=	OPEN HEARTH STEEL	172 02 139 CbCb
APPD	Sd/=	10K11-5-III Г GOST 16523-70	
DATE	20.1.89	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE:- 1:1		AVADI	
DIMENSIONS IN mm		TITLE :-	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69		FRAME	
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
ISSUE DATE NATURE OF AMENDMENTS			172.02.522

800001-1  
 (B.JAYAVELUJ,TDID)  
 16-04-88

" COMMON TO T - 90 " & " B.I.T  
 DRG.RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 5

F-15  
27

SIZE A2



USED ON

172.02.079cb-6Cb  
 188.02.079cbCb  
 PV572.0718.0140 (13B)

"COMMON TO T-90" & BLT  
 I/L SEPARATELY CREATED BASED ON RUSSIAN ORIGINAL ISSUE -13

ZONE	ITEM NO	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	QTY	REMARKS
		172.02.139cbCb		GASKET		
		& ITEM LIST				
	1	172.02.522		FRAME	1	
	2	172.02.523		GASKET	1	N.D DETAILS COVERED IN ASSY DRG

ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS
13D	30.09.19	DRAWING AMENDED			
13C	01.07.19	DRAWING AMENDED			
13B	03.09.11	55150/COA(HV)/DB/BLT T-72 DT. 19.07.11			
13A	04.08.03	DRAWING AMENDED			

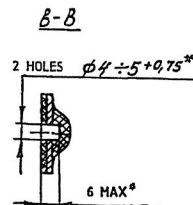
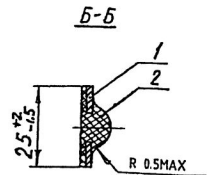
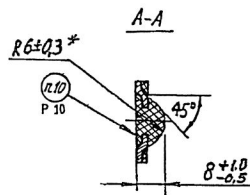
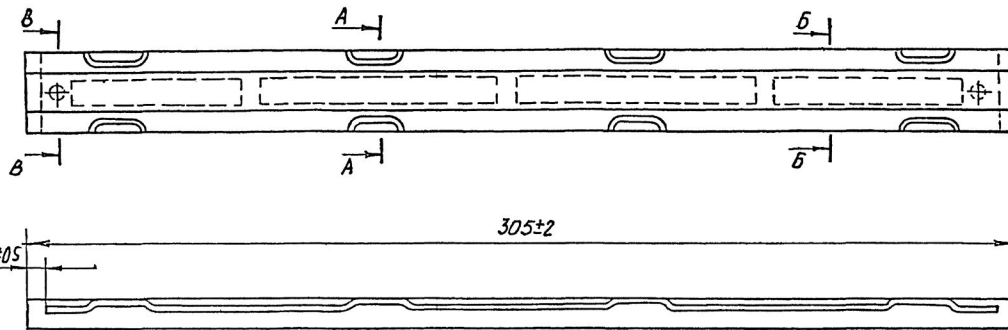
F-12 10	DRN	<i>P. Khanna</i>	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.		
	CHD	<i>G. Huskparaj</i>	TITLE :		
	APPD	<i>P. J. Gnanabalan</i>	<b>GASKET</b>		
	DATE	23-04-08	SHT. NO. 1 OF 1	D S CAT NUMBER	ITEM LIST FOR <b>172.02.139cbCb</b>



DRAWING NUMBER

172.02.144cb-1Cb

SHEET No. 1 OF 1



1. COMPONENT ITEM NO.2 IS TO BE MANUFACTURED FROM RUBBER  
HO-68-1 TY-005216-75, NBR + CR (BNC Grade of (QA(HV))
2. A FILM OF RUBBER ON UNRUBBERISED SURFACES IS ALLOWED.
3. SKEWNESS (DISPLACEMENT) OF DIE SHOULD NOT EXCEED 1mm
4. ON SURFACES OF BOTH SIDES OF STAMPING ON LENGTH NOT LESS THAN 10mm AND ON WIDTH NOT LESS THAN 1,5mm. AND ON THE EDGES & LENGTH OF STAMPINGS, PRESENCE OF RUBBER IS NOT ALLOWED. DRESSING IS ALLOWED.
5. ON RUBBERISED SURFACES LOCAL CAVITIES WITH DIAMETER UP TO 4mm & DEPTH UP TO 1mm IN QUANTITY NOT MORE THAN 4 IS ALLOWED.
6. REMAINING OF TECHNICAL REQUIREMENTS FOR ACCEPTANCE OF COMPONENTS SHOULD BE AS PER NBR + CR (BNC Grade of (QA(HV)) TY-005-216-75-003E-25307.
7. ROUNDING-OFF OF CORNERS UP TO RADIUS OF 1mm IS ALLOWED
8. GASKET IS PASTED BY METHOD OF HEAT VALCANISATION WITH GLUE "LEIKONAT" TY 6-14-95-75.
9. IN STAMPING AREAS, PEELING-OFF OF RUBBER UP TO A DEPTH OF 4mm IS ALLOWED.
10. NOTATION OF MANUFACTURING FACTORY AND NUMBER OF COMPONENT SHOULD BE MARKED BY RAISED TYPE no-3-GOST2930-62.
11. \*DIMENSIONS ARE ENSURED BY TOOL.

## EXPLANATORY NOTE: (L)

12 REFERENCE NOTE 1 ON MATERIAL FOR ITEM 2, RUBBER GRADE HO-68-1 TY-005 216-75

PHYSICAL AND MECHANICAL PARAMETERS		
TYPE OF RAW RUBBER	CKH-10	
RUPTURE STRENGTH	20 Kgf/cm <sup>2</sup> MIN	
ELONGATION OF RUPTURE	250 % MIN	
RESIDUAL ELONGATION	12 % MAX	
HARDNESS IN CONVENTIONAL UNITS	55 TO 70 (OF TYP)	
DENSITY	1.24 ± 0.05 g/cm <sup>3</sup>	
WORKING TEMPERATURE	-50° C TO + 100° C	DURING USE IT SHOULD WITHSTAND A PRESSURE UP TO 100 Kgf/cm <sup>2</sup>
WORKING MEDIUM	AIR, OILS, LUBRICANTS	

## EQUIVALENT MATERIAL: (ZE)

NBR + CR (BNC Grade of (QA(HV))

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

EST. WT. 0.11Kg 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	Sd/=	MATERIAL:-	
2D	01.07.19	83201/Tech Gen/EQ Mat/HVF dt. 25.09.19	
2C	19.01.12	55150/COA(HV)/DR/BLT I-72 DT. 19.07.11	
2B	03.09.11	55150/COA(HV)/DR/BLT I-72 DT. 19.07.11	
2A	04.08.03	N of a NO. COA(HV)/T90/02/001	
L1	24.8.88	EXPLANATORY NOTE ADDED.	
ISSUE	DATE	NATURE OF AMENDMENTS	

DRN	Sd/=	MATERIAL:-	
CHD	Sd/=		
APPD	Sd/=		
DATE	20-1-87	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE:-	1 : 1	AVADI	
DIMENSIONS IN mm			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69			
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
		DCAN: 5330381403	172.02.144cb-1Cb

(ZC) PV572.0756.0010  
USED ON:- PV572.0718.0140  
172.02.079cb-6 (2A) (2B)  
188.02.079cbCb



GASKET

\* COMMON TO T-90 & BLT KVD No. 72030  
DRG. RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE-2

(F-12)  
11

SIZE A2

(B.JAYAVELUJ, JTDI)  
-04-08

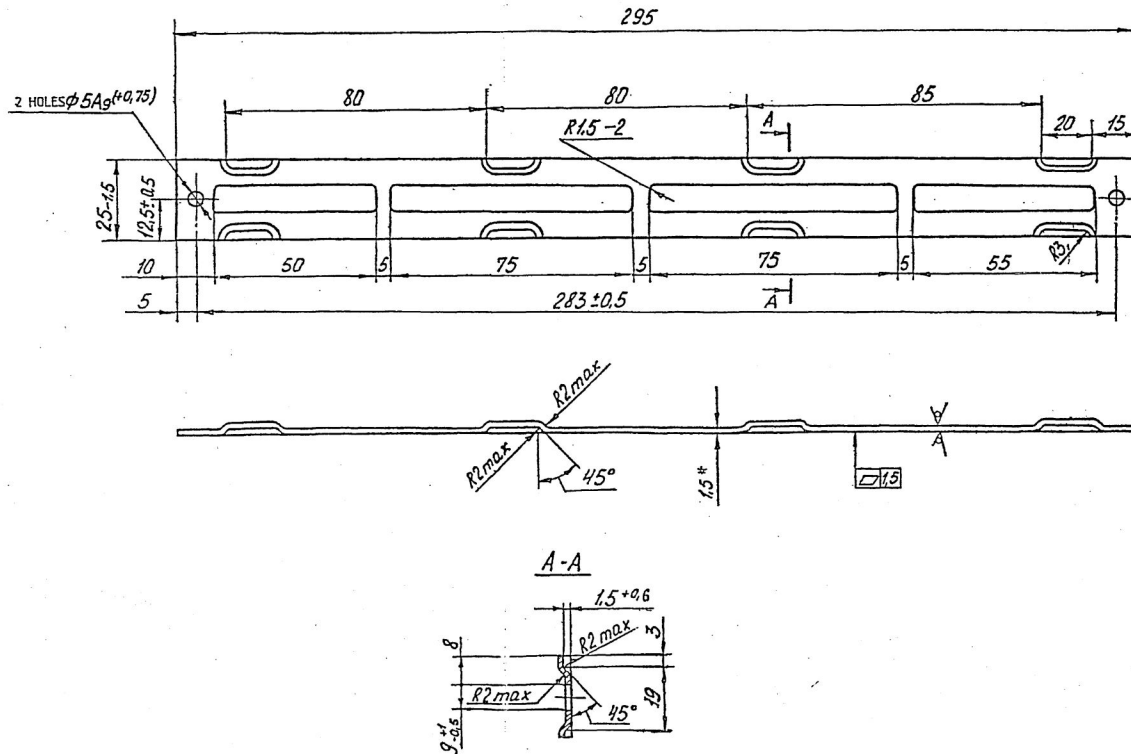




DRAWING NUMBER  
172.02.532-1

SHEET No. 1 OF 1

Rz 320 ✓ (✓)



- ALTERNATE MATERIAL - SHEET 15 GOST 19904-74  
4-II-15 GOST 16523-70.
- DEVIATIONS ON DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE  $\pm 1.0$  mm.
- SHRINKAGE OF EDGES IN PLACES OF STAMPED RECESSES IS NOT TO BE CHECKED.
- CORRUGATION AND TOOL MARKS ARE ALLOWED ON COMPONENT SURFACE
- REST OF TECHNICAL REQUIREMENTS SHOULD BE ACCORDING TO TY 005216-75, (APPENDIX I)
- \* DIMENSIONS FOR REFERENCE.

EXPLANATORY NOTE:-(1)

7. a) REFERENCE MATERIAL QUOTED:-  
COLD ROLLED STEEL SHEET WITH NORMAL ROLLING ACCURACY ON THICKNESS  $1.5 \pm 0.11$  mm AS PER GOST 19904-74 OF STEEL GRADE 10Kn CATEGORY 5, GROUP II, HIGH FINISH ON SURFACE QUALITY, DEEP DRAWN GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH GOST 1050-74.
- b) REFERENCE NOTE 1 ON ALTERNATIVE MATERIAL:-  
COLD ROLLED STEEL SHEET WITH NORMAL ROLLING ACCURACY ON THICKNESS  $1.5 \pm 0.11$  mm AS PER GOST 19904-74 OF STEEL GRADE 15 CATEGORY 4, GROUP II, HIGH FINISH ON SURFACE QUALITY, GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH GOST 1050-74.
8. a) CHEMICAL COMPOSITION:-  
AS PER STEEL GRADE 10Kn & GRADE 15 GOST 1050-74.

GRADE OF STEEL	CONTENT OF ELEMENTS %					
	C	Si	Mn	Cr	S	P
10Kn	0,07-0,14	0,07MAX	0,25-0,50	0,15	0,040	0,035
15	0,12-0,19	0,17-0,37	0,35-0,65	0,25	0,040	0,035

RESIDUAL CONTENT OF COPPER & NICKEL SHOULD NOT EXCEED 0,25% EACH.

- b) MECHANICAL PROPERTIES:-  
AS PER STEEL GRADE 10Kn CATEGORY 5, GROUP II  $\Gamma$  AND GRADE 15 CATEGORY 4, GROUP II GOST 16523-70.

GRADE OF STEEL	TENSILE STRENGTH Kgf/mm <sup>2</sup>	ELONGATION %	CUPPING TEST DEPTH SPERICAL HOLE	BEND TEST 180° IN COLD STATE
10Kn	28-47	25 MIN.	11,2 MIN	CLOSE
15	34-47	24 MIN.	—	CLOSE

"COMMON TO T-90" & BLT  
DRG. RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE -

F-15  
28  
SIZE A2

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

EST. WT. 0.08 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	Sd / =	MATERIAL:- SHEET	USED ON:-
CHD	Sd / =	15 GOST 19904-74	172.02.144cb-1cb
APPD	Sd / =	5-II- $\Gamma$ -10Kn GOST 16523-70	
DATE	20.01.87	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE:-	1 : 1	AVADI	
DIMENSIONS IN mm		TITLE:-	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69		FRAME	
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
L1	24.6.88		172.02.532-1
ISSUE	DATE	NATURE OF AMENDMENTS	

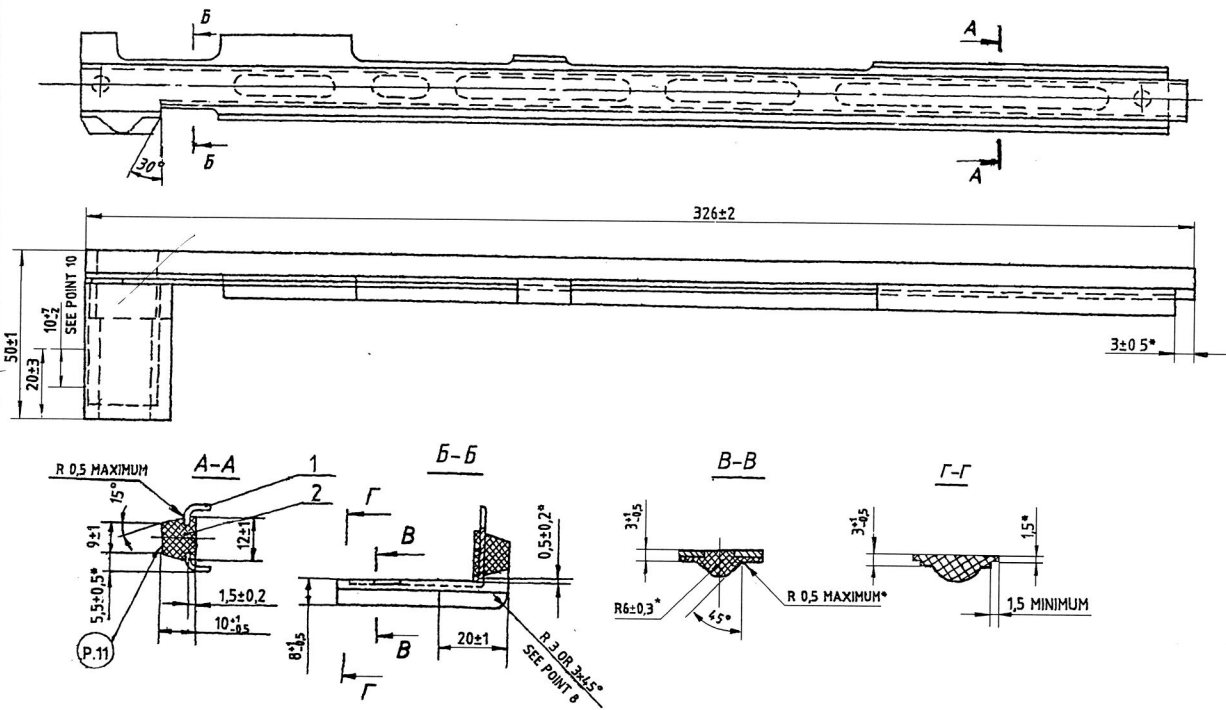






COMMON TO T-90 & BLT  
DRAWING RE-INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 5  
IB JAYAVELUJ, T0101  
FEB 07

DRAWING NUMBER  
**172.02.145cb-ACb**  
SHEET No. 1 OF 1



1. COMPONENT 2 SHOULD BE MANUFACTURED FROM RUBBER HO-00-  
TY-006216-75. NBR + CR (BNC Grade of CQA(HV))
2. ON THE UN-RUBBERIZED SURFACES EXCEPT FACES OF FLANGES, A THIN FILM OF RUBBER IS ALLOWED.
3. SKEWNESS OF AXES OF DIE SHOULD NOT EXCEED 1mm.
4. ON RUBBERISED SURFACES, LOCAL CAVITIES WITH A DIAMETER UPTO 4mm DEPTH UPTO 1mm IN QUANTITY NOT MORE THAN 4mm IS ALLOWED.
5. TECHNICAL REQUIREMENTS FOR ACCEPTANCE OF COMPONENT SHOULD BE IN ACCORDANCE WITH TY-006216-75 CODE 250101.
6. ROUNDING - OFF OF CORNERS UPTO RADIUS OF 1mm IS ALLOWED.
7. DIMENSIONS WITHOUT SPECIFY TOLERANCES ARE GIVEN TO PROVIDE MANUFACTURE OF DIE.
8. RADIUS R3 OR 3x45° (SEE SEC. 5-B) SHOULD BE GRINDED IN THE TIME OF MOUNTING ON ROOF.
9. GASKET IS TO BE PASTED BY HEAT VULCANIZATION WITH GLUE (LEIKONAT) TY 6-14-95-75.

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

EST. WT. (Kg) 0.146	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.	

10. ON TANK FACES OF COMPONENT AND ON SURFACES AT WIDTH OF 1.5 MIN FROM BOTH SIDES, AT LENGTH OF 10<sup>±2</sup> IN THE PRESENCE OF RUBBER IS NOT ALLOWED.
11. TO BE MARKED NOTATIONS OF MANUFACTURING FACTORY AND COMPONENT NUMBER BY RAISED TYPE AS PER 3 GOST 2930-62.
12. \*DIMENSIONS ARE ENSURED BY THE TOOLS.

EQUIVALENT MATERIAL:-  
NBR + CR (BNC Grade of CQA(HV))

EXPLANATORY NOTE

RUBBER HO-00-00-1	
CHEMISTRY	PHYSICAL PROPERTIES AND HARDNESS
NOT APPLICABLE	WORKING MEDIUM : AIR, OILS, LUBRICANTS
	WORKING TEMPERATURE : -50 TO +100°C
	TENSILE STRENGTH : 90 Kgf/cm <sup>2</sup> (min)
	ELONGATION : 250 % (min)
	HARDNESS (TIP) DEVICE : 55-70
	DENSITY : 1.24 g/cm <sup>3</sup> ± 0.05
	RESIDUAL ELONGATION : 12 % Max
	DURING USE IT SHOULD WITHSTAND A PRESSURE UPTO -
	TYPE OF RAW RUBBER: CKH-18 100 Kgf/cm <sup>2</sup>
PASTE (LEIKONAT) TY 6-14-95-75.	
CHEMISTRY	PHYSICAL PROPERTIES AND HARDNESS
CONTENT OF 4, 4', 4'' TRITANETRISOCYANATE : 20±1% CONTENT OF INSOLUBLE INCLUSIONS IN DICHLOROETHANE = 0.1 % (max)	STRENGTH OF BOND BETWEEN RUBBER AND STEEL } = 40 Kgf/cm <sup>2</sup> (min)
	DRYINGOUT TIME : 40 minutes (max)

F. 12  
12  
SIZE A2

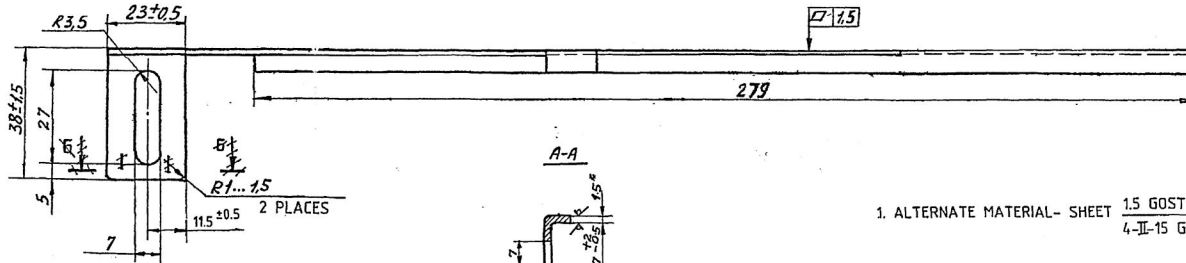
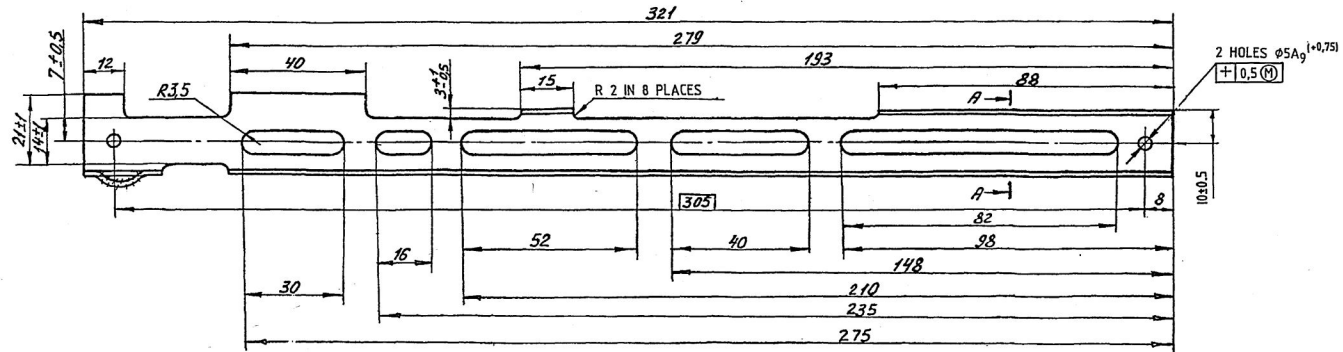
DRN	Sd=	MATERIAL:-	USED ON :- 188.02.079cbCb
CHD	Sd=		172.02.079cb-6Cb
APPD	Sd=		** IN BULK
DATE	04.02.87	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
SCALE:-	1 : 1	TITLE:- <b>GASKET</b>	
DIMENSIONS IN mm		D S CAT NUMBER	DRAWING NUMBER
TOLERANCE ON DIMENS UNLESS OTHERWISE STATED IS : 2102-69			<b>172.02.145cb-ACb</b>
ISSUE	DATE	NATURE OF AMENDMENTS	
5E	30.09.19	83201/TECH GEN/EQ MATL/HVF dt. 25.09.19	
5D	01.07.19	83201/Tech Gen/EQ Matl/HVF dt. 02.04.19	
5C	03.09.11	85150/CQA(HV)/08/BLT T-77 DT. 19.07.11	
5B	22-5-09	AS PER KIT LIST No. CQA(HV)/SET/0047 (KIT No.1)	
5A	04.08.03	N of A No. CQA(HV)/T90/02/001.	



DRAWING NUMBER  
172.02.534-1A

SHEET No. 1 OF 1

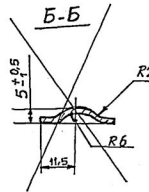
Rz 320 ✓(V)



**EXPLANATORY NOTE :**

DEEP DRAWN STEEL 10KN 16523-70.

CHEMISTRY	PHYSICAL PROPERTIES AND HARDNESS
C : 0.07 - 0.14	TENSILE STRENGTH : 28 - 40 Kgf/mm <sup>2</sup>
Si : 0.07 (max)	RELATIVE ELONGATION : 25 %
Mn : 0.25 - 0.50	BEND TEST : SHOULD WITHSTAND 180° BEND WITHOUT CRACK.
Cr : 0.10 (max)	CUPPING TEST : 11.2 mm SPHERICAL INDENTATION TO BE MADE BEFORE CRACKING.
S : 0.040 (max)	
P : 0.025 (max)	



- ALTERNATE MATERIAL- SHEET 1.5 GOST 19904-74  
4-II-15 GOST 16523-70
- DEVIATION ON DIMENSIONS WITH SPECIFIED TOLERANCES SHOULD BE ±1mm.
- NATURAL THINNING OF METAL AND PRESSING MARKS ARE ALLOWED IN PLACES OF BENDING.
- THE REST OF TECHNICAL REQUIREMENTS IN ACCORDANCE WITH TY 005216-75.(APPENDIX - I)
- DIMENSION 23 AT TAIL END (SECTION B-B) IS NOT TO BE CHECKED.
- \*DIMENSIONS FOR REFERENCE.

**EXPLANATORY NOTE:-**

REFERENCE NOTE NUMBER 4 DELETED.

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)

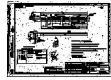
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE FERMISIBLE.

DRN	Sd / =	MATERIAL:- SHEET	USED ON:-
CHD	Sd / =	15 GOST 19904 - 74	172.02.145cb-A
APPD	Sd / =	5 - II - F - 10KN GOST 16523-70	
DATE	04 - 02 - 87	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
SCALE: 1:1		TITLE:-	
DIMENSIONS IN mm		FRAME	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69		D S CAT NUMBER	
ALL THREADS TO CONFORM TO IS : 4218 Pt. IV		DRAWING NUMBER	
ISSUE	DATE	NATURE OF AMENDMENTS	172.02.534-1A

" COMMON TO T-90 " & BLT  
DRG.RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - N/1  
B.AYANVELUJ,ITODI  
15-04-88

F-15  
29

SIZE A2



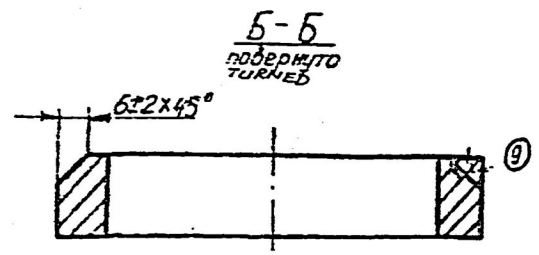
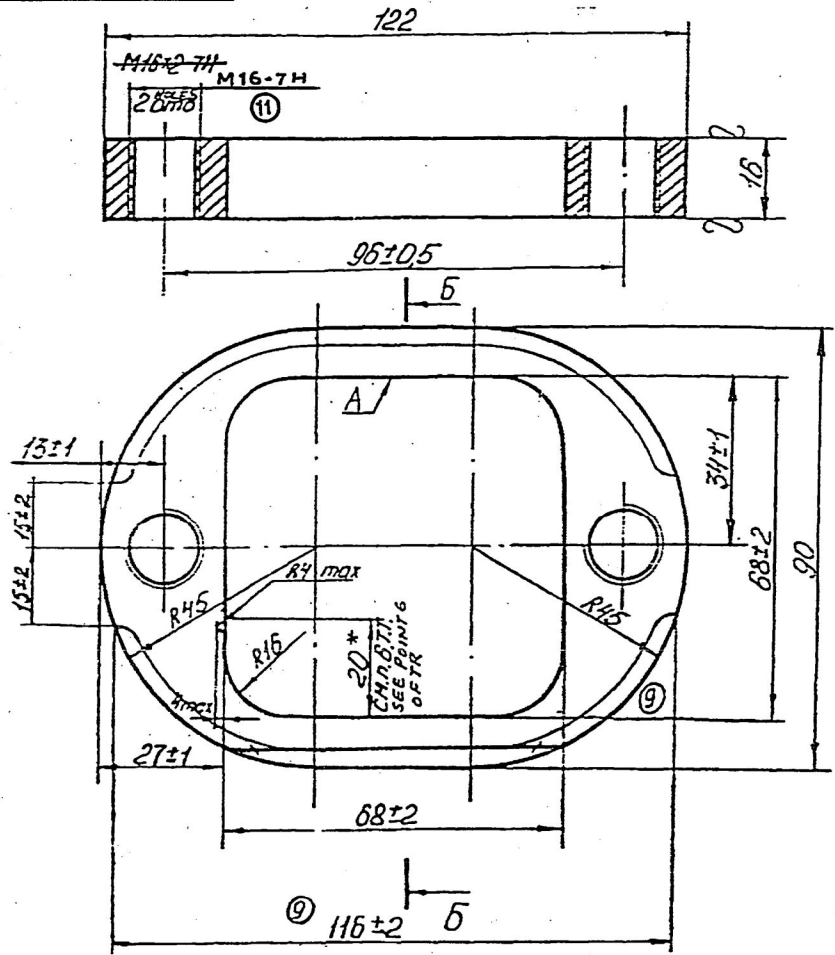


"COMMON TO T-90" & BLT  
DRG RE-INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 10

B. JAYAVELU, JTO (D)  
04-03-08

F-14  
76  
SIZE A3

DRAWING NUMBER: 175.02.496  
SHEET No 1 OF 1



1. GRADE OF STEEL, HEAT TREATMENT, METHODS OF TESTING AND ACCEPTANCE TO BE IN ACCORDANCE WITH THE EXISTING LIST OF COMPONENTS MANUFACTURED FROM SPECIAL STEEL, HARDNESS - LOW.
2. DEVIATION OF COMPONENT PROFILE FROM THE TEMPLATE (CONSTRUCTED AS PER NOMINAL DIMENSIONS) NOT TO EXCEED 1 mm.
3. RULES FOR QUALITY INSPECTION AND ACCEPTANCE OF FLAME-CUT EDGES TO BE AS PER OST B3-4301-80.
5. NON - FLATNESS OF COMPONENT ON 16 mm DIMENSION NOT TO EXCEED 1 mm.
6. LOCAL METAL TEARS SHOWN WITH DOTTED LINE ARE ALLOWED ON SURFACE "A" IN THIS CASE, THE SURFACE FINISH UPTO 1000 ✓ IS ALLOWED.
7. \* DIMENSION FOR REFERENCE.

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

EST. WT. (Kg) 0.46 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	Sd/=	MATERIAL:- SPECIAL STEEL (SEE POINT 1 OF T.R)	USED ON:- PV572.0718.0140 172.02.079cb-bCb 188.02.079cbCb (11A) (11B)
CHD	Sd/=	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
APPD	Sd/=		
DATE	07-02-89	SCALE:- 1:1	
DIMENSIONS IN mm		TITLE:- <b>FLANGE</b>	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69			
11B	03.09.11	55150/CQA(HV)/08/BLT T-72 DT. 19.07.11	D S CAT NUMBER
11A	04.08.03	N OF A No. CQA(HV)/T90/02/001.	
11	9.7.90	172M.450 "A"-88, AMDT.11/1.	
ISSUE	DATE	NATURE OF AMENDMENTS	DRAWING NUMBER <b>175.02.496</b>

