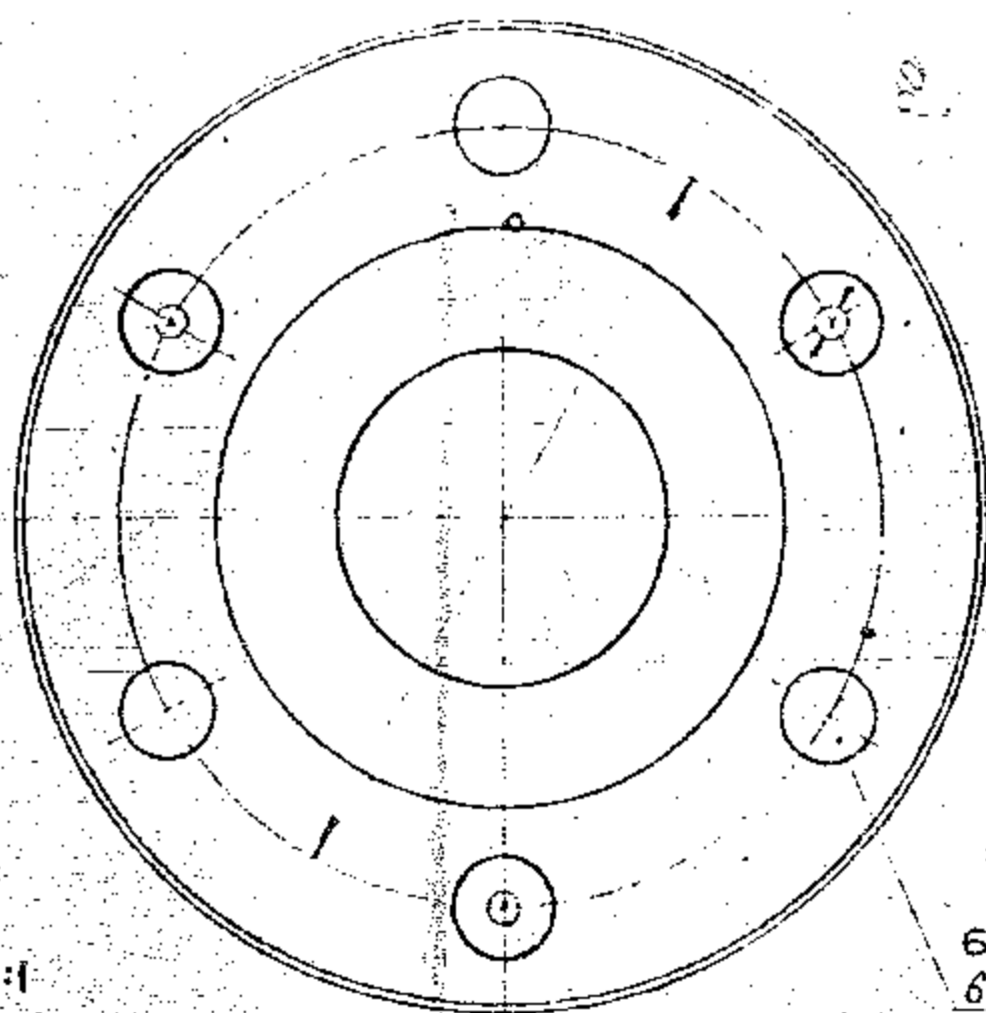
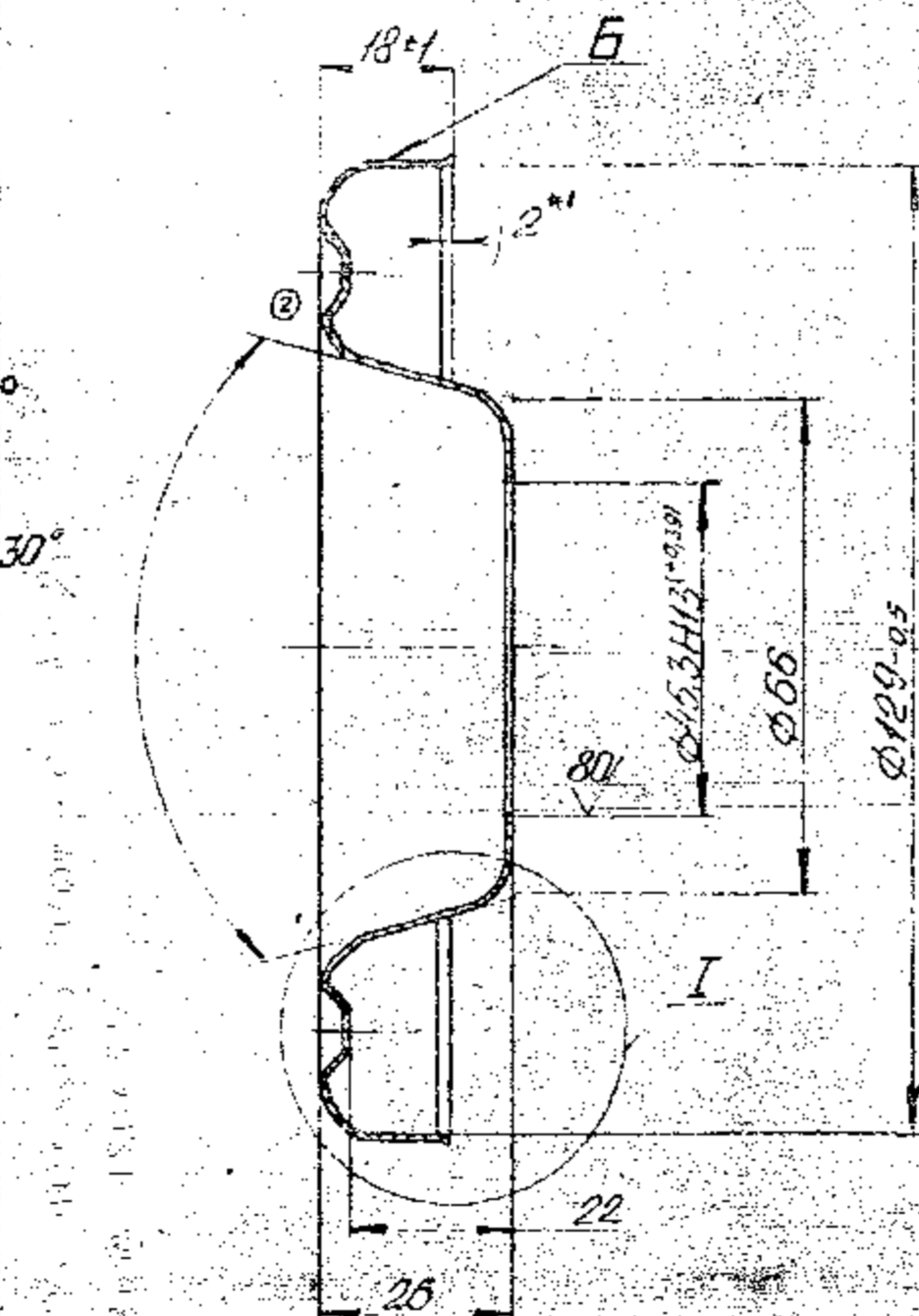
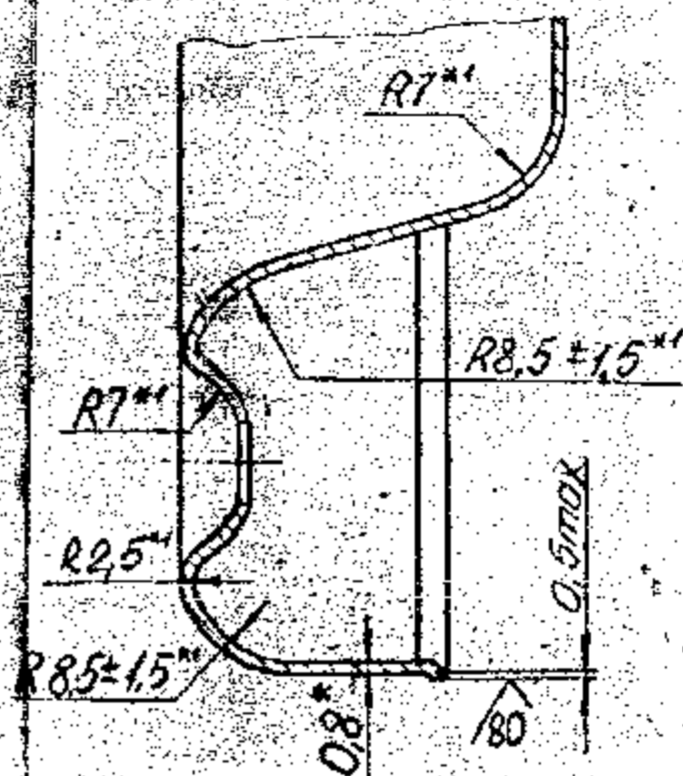


DRAWING NUMBER
413 37 1

✓ (D)



I
M2:1
SCALE 2:1



3 HOLES
30±0.5/1.1/1.1 ±0.3
R0.5

EXPLANATORY NOTE

7. REFERENCE MATERIAL QUOTED: COLD ROLLED SHEET STEEL, HIGH ACCURACY ON ROLLING 'A', 0.8mm THICK TO GOST 13904-74, AND HIGH SURFACE FINISH 'T'. EXTREMELY DEEP DRAWING 'B' AND MANUFACTURED IN ACCORDANCE WITH COLD-ROLLED THIN SHEET STEEL Gde. 08kn TO GOST 9045-80. a) CHEMICAL COMPOSITION AS PER GOST 9045-80.

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C MAX	Mn	S	P	Si	Cr	Ni	Cu
08kn	0.10	0.20-0.40	0.030	0.025	0.03	0.10	0.10	0.15

b) MECHANICAL PROPERTIES:

CATEGORY	GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	ELONGATION % min.
B'	08kn	26-37	28

8. REFERENCE NOTE '1' ON ALTERNATE MATERIAL QUALITY CARBON STEEL COLD ROLLED GRADES 08kn, 10 AND 10kn TO GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL TO GOST 1050-74.

a) CHEMICAL COMPOSITION AS PER GOST 1050-74.

GRADE OF STEEL	CONTENT OF ELEMENTS %					
	C	Si	Mn	Cr	S	P
08kn	0.05-0.11	0.05-0.17	0.35-0.65	0.10	0.040	0.035
10	0.07-0.14	0.17-0.37	0.35-0.65	0.15	0.040	0.035
10kn	0.07-0.14	0.07 max	0.25-0.50	0.15	0.040	0.035

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH. MANGANESE CONTENT UP TO 0.25% AS REGARDS LOWER LIMIT, IS ALLOWED IN THE STEEL OF GRADE 08kn MEANT FOR PRODUCTION OF SHEET STEEL FOR COLD STAMPING.

b) MECHANICAL PROPERTIES AS PER GOST 16523-70.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	ELONGATION % min
08kn	28-40	25
10	30-42	25
10kn	28-40	25

1. ALTERNATE MATERIAL 08kn, 10, AND 10kn (RIPING) GOST 1050-74.
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ±0.3mm.
3. UNSPECIFIED RADII R1±0.5mm
4. CORRUGATIONS UP TO 0.3mm DEEP ARE ALLOWED ON SURFACE 'B'
5. * DIMENSIONS FOR REFERENCE
6. * DIMENSIONS ARE TO BE ENSURED BY TOOL.

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

EST WT 0.16 Kg TO BE STAMPED OR MARKED WHERE INDICATED THIS BY LETTERS

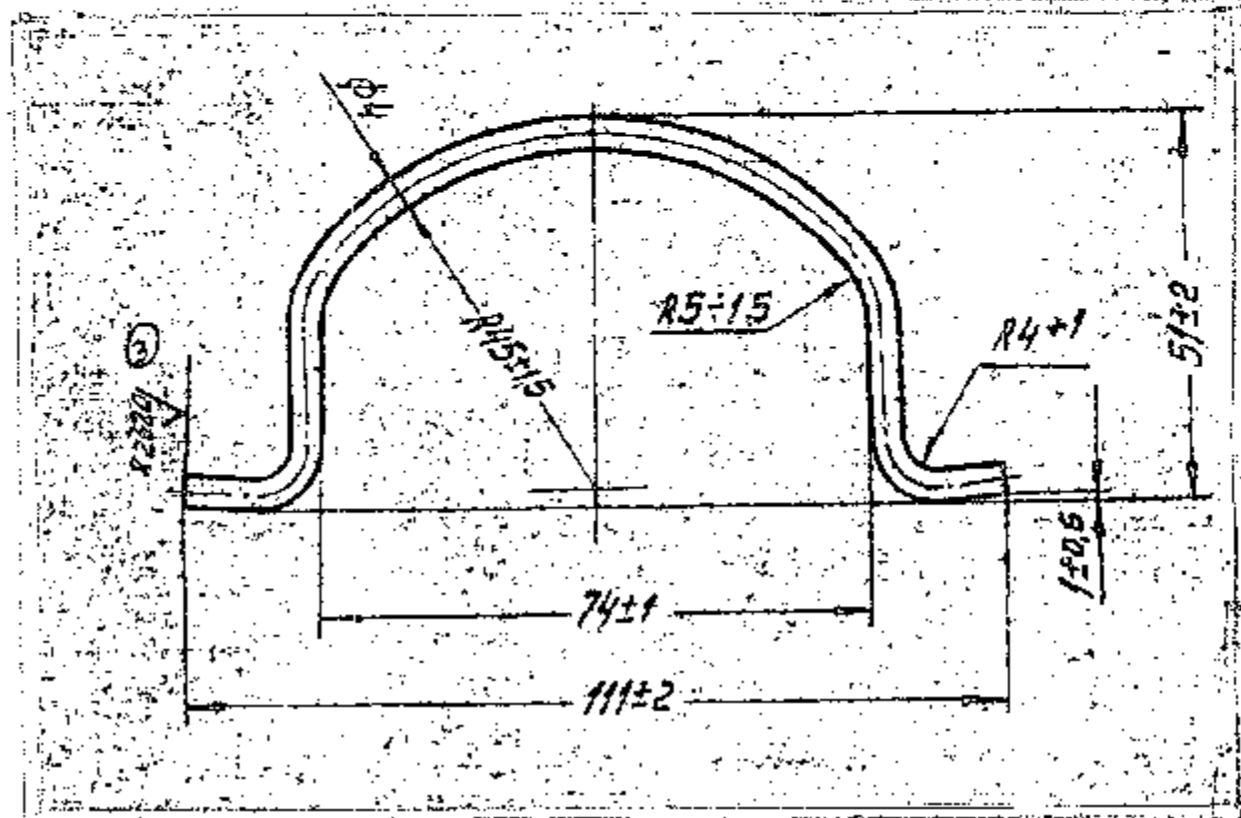
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

DRN	DRN	MATERIAL: SHEET	USED ON
CHD	CHD	AD. GOST 19904-74	Ch 413 44 20b
TEO	TEO	0.8/0.8kn GOST 9045-80	
APPD	APPD	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)	
DATE	DATE	AVADI	
SCALE 1:1	SCALE 1:1		
DIMENSION IN mm	DIMENSION IN mm	TITLE	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	COVER FIRST SECTION	
ALL THREADS TO CONFORM TO	ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
ISSUE	DATE		413 37 1
	NATURE OF AMENDMENTS		



413-38

(✓) (✓)



LENGTH OF STRAIGHTENED COMPONENT ≈ 174mm.

EXPLANATORY NOTE:

1. REFERENCE MATERIAL QUOTED :

SPRING WIRE CATEGORY II NORMAL MANUFACTURING ACCURACY
 4 (±0.04) mm DIA TO GOST 9389-75 AND MANUFACTURED IN ACCORDANCE
 WITH QUALITY CARBON STRUCTURAL STEEL GRADE 70 TO GOST 1050-74

a) CHEMICAL COMPOSITION AS PER GOST 1050-74

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C	Si	Mn	Cr	S	P	Cu	Ni
70	0.67 0.75	0.17 0.37	0.50 0.80	0.25	0.040	0.035	0.25	0.25

b) MECHANICAL PROPERTIES OF CATEGORY II WIRE AS PER GOST 9389-75

TENSILE STRENGTH Kgf/mm ²	No. OF BENDS Min (2d)	No. OF TWISTS Min
150 - 175	6	13

ORG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE

A 6

SIZE A3

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

EST WT 0.02 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTERS)

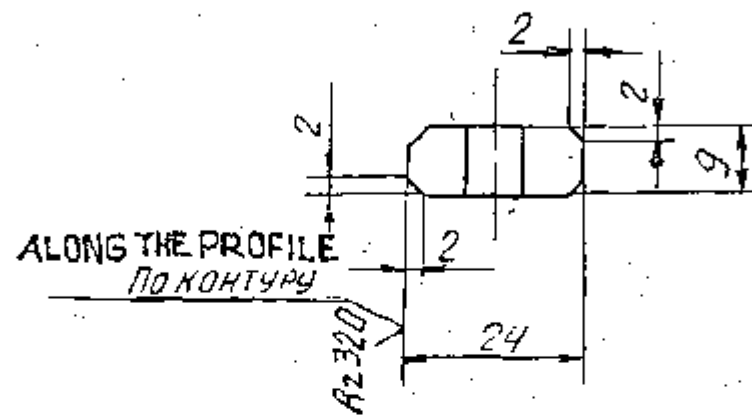
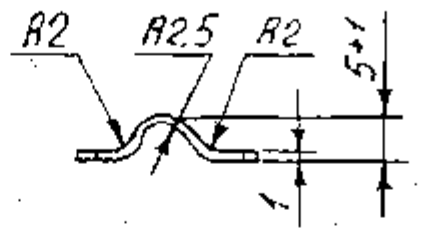
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

DRN	CHD	TCD	APPO	DATE	DIMENSIONS IN mm	SCALE	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	ALL THREADS CONFORM TO	MATERIAL WIRE II 4; GOST 9389-75	USED ON CB 413-14-205
				19-5-86		1:1			CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
									TITLE FIRST SECTION HANDLE	
									D S CAT NUMBER	DRAWING NUMBER 413-38
8	7	6	ISSUE	DATE	NATURE OF AMENDMENTS					



DRAWING NUMBER

413 43



Размеры без допусков выполнять с точностью $\pm 0,5 \text{ мм}$.
 Зазусенцы зачистить.
 Заменитель материала сталь 08нс, 10 и 10кп ГОСТ 1050-74.

1. DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE OBTAINED WITH AN ACCURACY OF $\pm 0.5 \text{ mm}$
2. BURRS SHOULD BE DRESSED.
3. ALTERNATE MATERIAL: STEEL, 08nc, 10 AND 10Kn (RIMMING) GOST 1050-74

EXPLANATORY NOTE

4. REFERENCE MATERIAL: LUTED: COLD ROLLED SHEET STEEL, ON HIGH ACCURACY ON ROLLING "A" 1mm THICK TO GOST 19904-74, AND HIGH SURFACE FINISH "I" EXTREMELY DEEP DRAWING "BF" AND MANUFACTURED IN ACCORDANCE WITH COLD-ROLLED THIN SHEET STEEL GOST 9045-80. CHEMICAL COMPOSITION AS PER GOST 9045-80.

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C MAX	Mn	S	P	Si	Cr	Ni	Cu
08nc	0.10	0.20-0.40	0.030	0.025	0.03	0.10	0.00	0.15

a) MECHANICAL PROPERTIES:

CATEGORY	GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm^2	ELONGATION % min
BF	08nc	26-37	28

5. REFERENCE NOTE "B" ON ALTERNATE MATERIAL: QUALITY CARBON STEEL COLD ROLLED GRADES 08nc, 10 AND 10kn TO GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL 1050-74.

a) CHEMICAL COMPOSITION AS PER GOST 1050-74

GRADE OF STEEL	CONTENT OF ELEMENTS %					
	C	Si	Mn	Cr	S	P
08nc	0.05-0.11	0.05-0.17	0.35-0.65	0.10	0.040	0.035
10	0.07-0.14	0.17-0.37	0.35-0.65	0.15	0.040	0.035
10kn	0.07-0.14	0.07 max	0.25-0.50	0.15	0.040	0.035

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH. MANGANESE CONTENT UP TO 0.25% AS REGARDS LOWER LIMIT, IS ALLOWED IN THE STEEL OF GRADE 08nc MEANT FOR PRODUCTION OF SHEET STEEL FOR COLD STAMPING.

b) MECHANICAL PROPERTIES AS PER GOST 16523-70.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm^2	ELONGATION % min
08nc	28-40	25
10	38-42	25
10kn	28-40	25

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.		DRN	Boe	MATERIAL: SHEET	USED ON: CB 413 14 2 CB
EST MASS 0.0018 kg		CHD	Dmitry	A1.0 GOST 19904-74	CB 413 15 1 CB
TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)		ICD	Andrey	II-BF-08Kn GOST 9045-80	CB 413 16 1 CB
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		APPD	301	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)	
SCALE: 1 : 1		DATE	20.05.74	AVADI	
DIMENSIONS IN mm		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.		TITLE: LUG	
ALL THREADS CONFORM TO		D S CAT NUMBER		DRAWING NUMBER: 413 43	

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 5

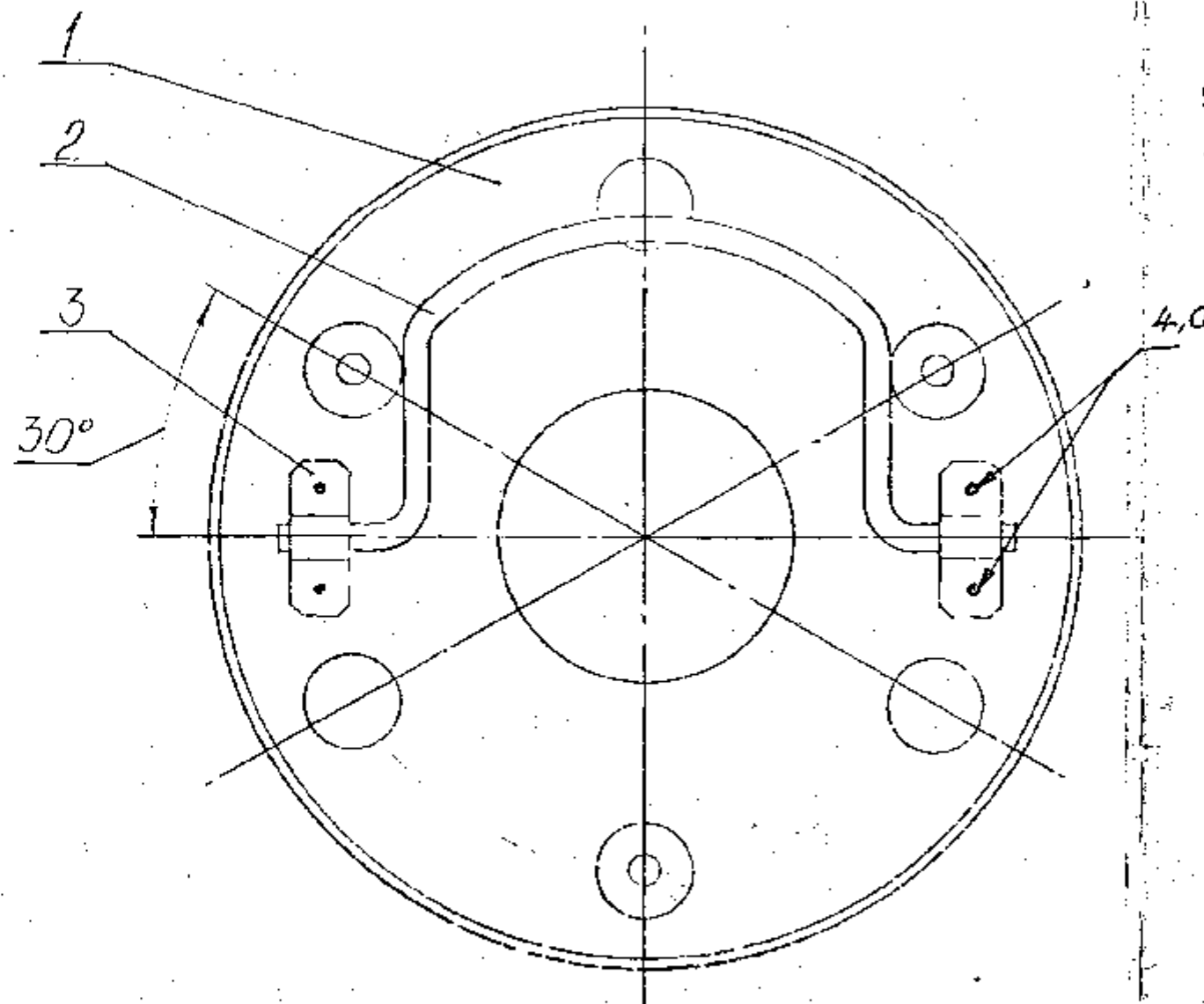
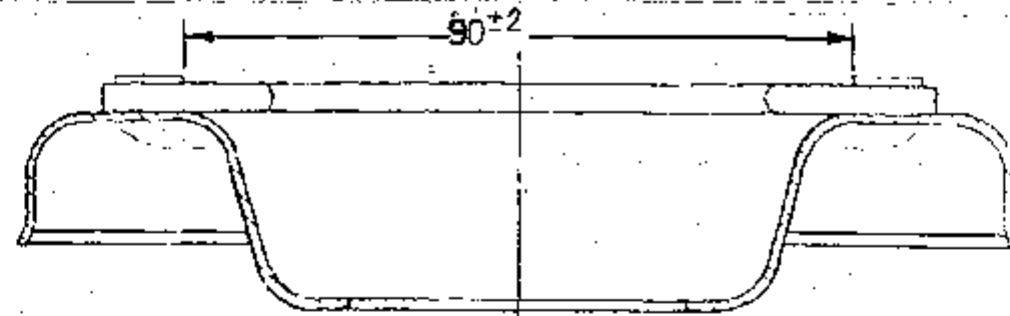
A-6

SIZE A-3



DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 3

DRAWING NUMBER
ЄБ 413 14 2СБ



1. COATING: Sn 6.
2. THERE MAY BE NO COATING AT PLACES OF SPOT WELDING.
3. THERE MAY BE NO COATING AT PLACE OF CONTACT OF COMPONENTS 1, 2 AND 3.
4. COMPONENT '2' SHOULD TURN FREELY WITHOUT JAMMING.
5. RESISTANCE SPOT WELDING.
6. COATING: Zn 6, CHROMATIZING AS PER INSTRUCTIONS УЛ-183-82.

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

EST. MASS 0.162 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 PERMISSIBLE.

			DRN	<i>Bob</i>	MATERIAL:-	USED ON:-
			CHD	<i>Dmitry</i>		ЄБ 413 04 1СБ
			TCD	<i>Marina</i>		
			APPD	<i>Konstantin</i>	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
			DATE	19-5-86		
			SCALE	- 1 : 1		
			DIMENSIONS IN mm			TITLE: SUB ASSY FIRST SLOT TYPE FILTERING SECTION
			TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.			
			ALL THREADS CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
			ISSUE	DATE		ЄБ 413 14 2СБ

A-6

SIZE A3



