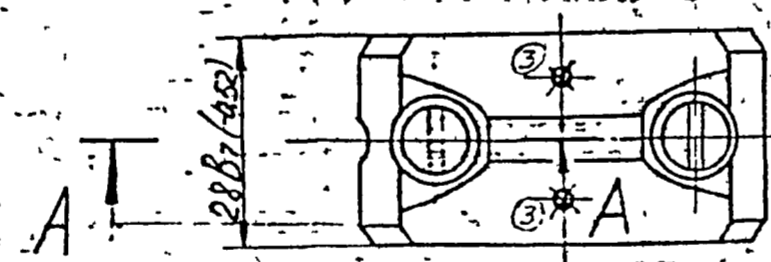
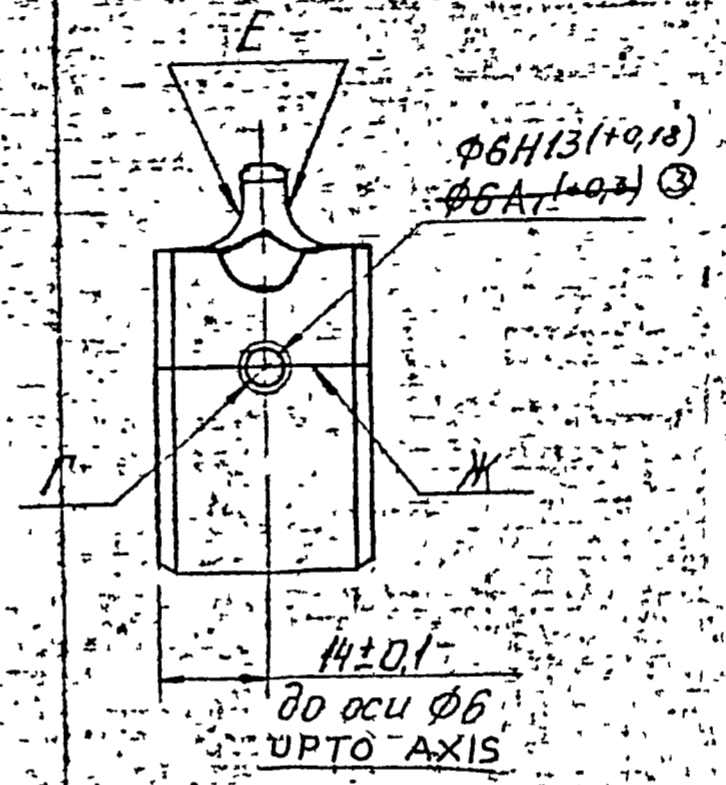
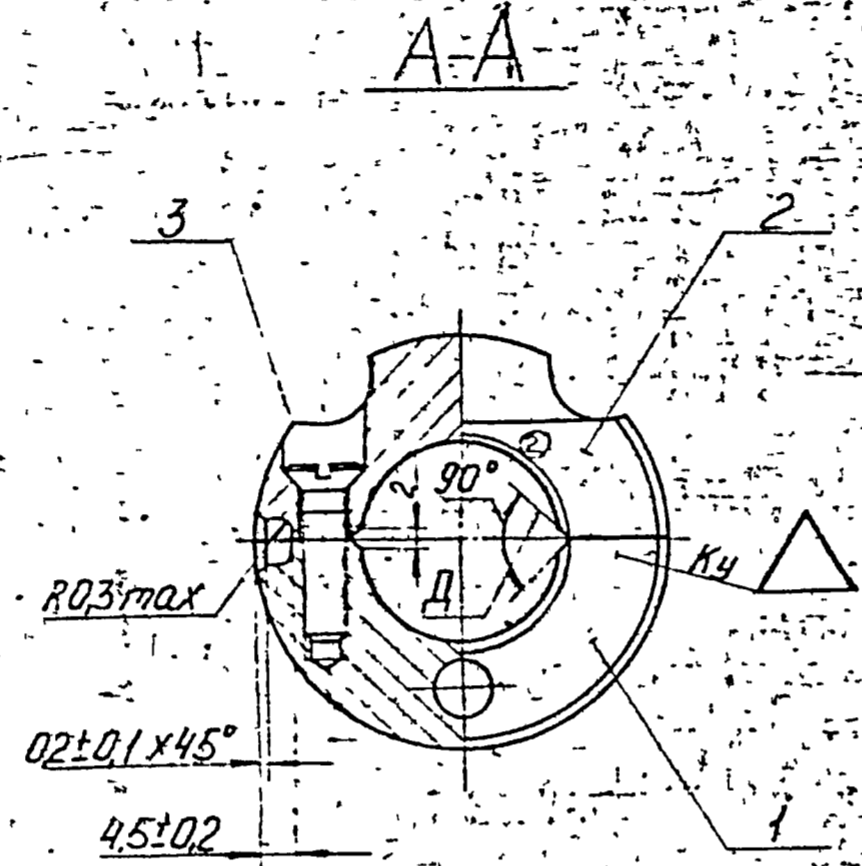
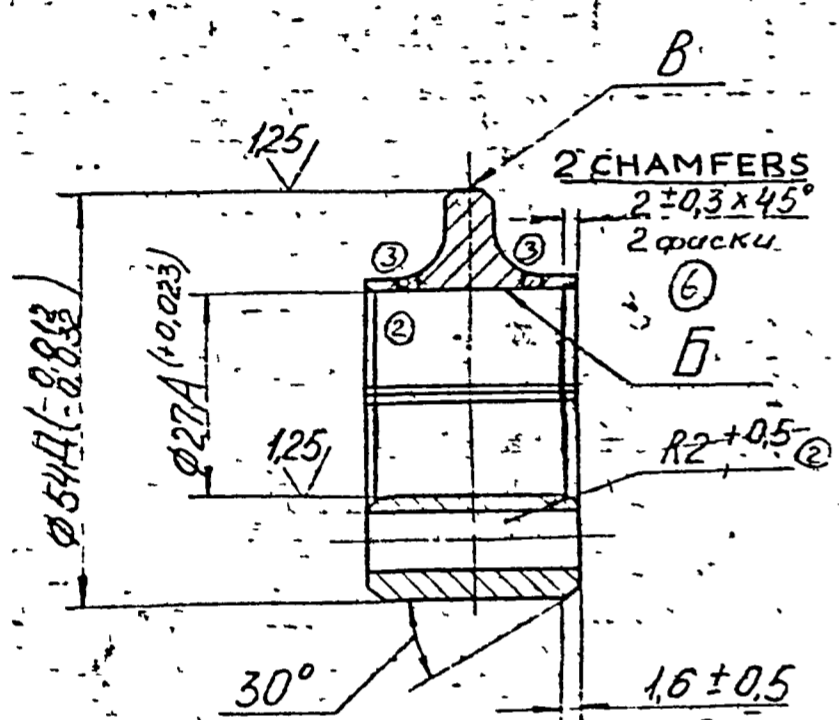


DRAWING NUMBER
CB 327-13-1



1. RADIAL RUN-OUT OF SURFACE B RELATIVE TO THE SURFACE B SHOULD NOT EXCEED 0.03mm
2. SHIFT OF GROOVE D RELATIVE TO THE JOINT PLANE K SHOULD NOT BE MORE THAN 0.5mm
3. NON-SYMMETRY OF SURFACES E RELATIVE TO THE HOLE Γ SHOULD BE 0.4mm MAX
4. SHIFT OF AXIS OF SURFACE B RELATIVE TO THE JOINT PLANE K SHOULD NOT EXCEED 0.5mm
5. REPLACEMENT AND READJUSTMENT OF BEARING COMPONENTS ARE NOT ALLOWED.

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

EST. WT
0.105

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

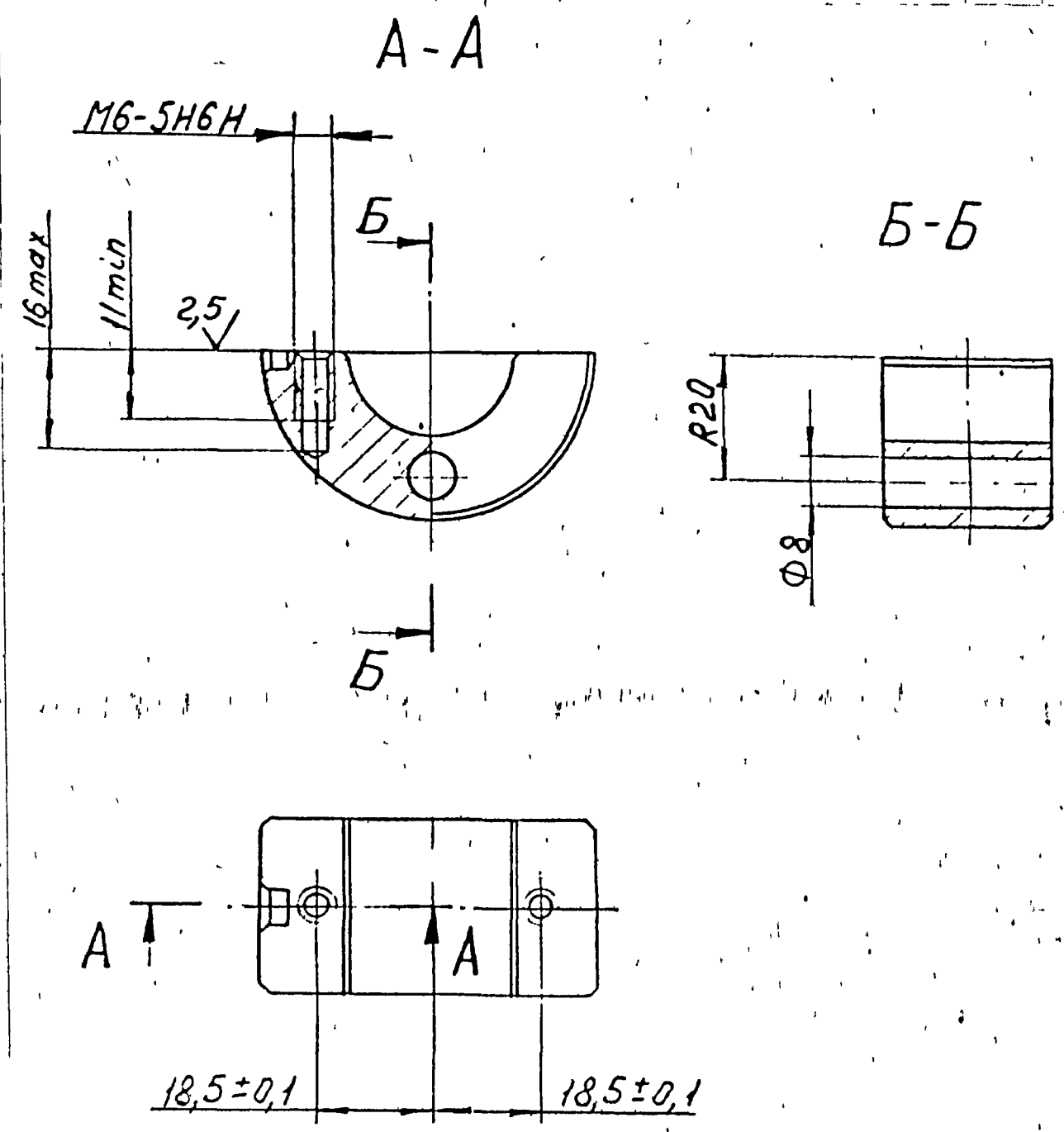
DRN	CHD	TCD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69	ALL THREADS TO CONFORM TO
				26-9-93	1:1			
MATERIAL :-				USED ON				
				CB 3327-04				
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)								
A V A D I								
TITLE								BEARING
D S CAT NUMBER								
DRAWING NUMBER							CB 327-13-1	
ISSUE	DATE	NATURE OF AMENDMENTS						

3-2488

A2

DRAWING NUMBER
327-42-1

20/ (✓)



- NOTE:-
1. INSPECTION GROUP IV AS PER TT-11
 2. ALTERNATE MATERIAL IS ALUMINIUM ALLOY D1 GOST 4784-74.
 3. HARDNESS HB ≥ 90 dB 1000 ≤ 3.7 .
 4. DIMENSIONS WITH UNSPECIFIED TOLERANCES ARE TO BE MAINTAINED AS PER CLASS 7 OF ACCURACY, OST 1010.
 5. TECHNICAL REQUIREMENTS FOR THREAD ARE TO BE CARRIED OUT AS PER STANDARD 82021-00.
 6. SHARP EDGES ARE TO BE BLUNTED.
 7. THREAD M6-5H6H MAY BE MADE "THROUGH".
 8. TO BE MAINTAINED FINALLY ACCORDING TO DRG:CB 327-13-1.

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

EST. WT. 0.058 kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # 1 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.

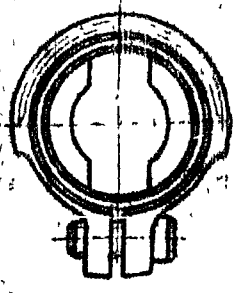
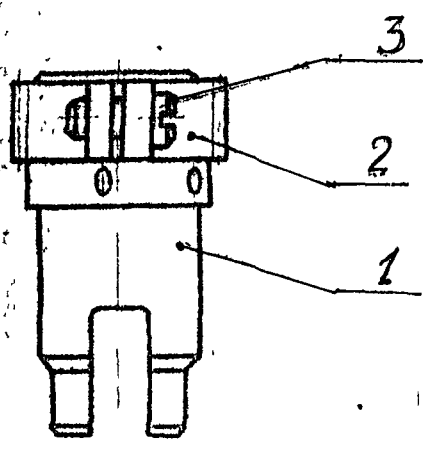
DRN	CHO	TCD	APPD	DATE	SCALE:-	MATERIAL:- ALUMINIUM ALLOY D1T GOST 21488-76	USED ON cb 327-13-1
				30-9-93	1:1	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES) AVADI	
					DIMENSIONS IN mm TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS:2102-69	TITLE BEARING PAD	
					ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER 327-42-1
ISSUE DATE	NATURE OF AMENDMENTS						

SIZE A3

DRAWING NUMBER

CB 3327 06

0
C
B
A



(A-8)

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

		EST WT 0.063 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	
		MATERIAL	USED ON CB 20-27-00-4 CB 327 00 45
ISSUE DATE	NATURE OF AMENDMENTS		
DRN	SCALE : 1 : 1	CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI	
CHD <i>18/Jan/86</i> <i>Dairba</i>	DIMENSION IN mm		
TCD <i>N. Subram</i>	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.		TITLE: CONTROL SLEEVE ASSY
APPD <i>brin</i>	ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER CB 3327 06
DATE <i>08-5-86</i>			

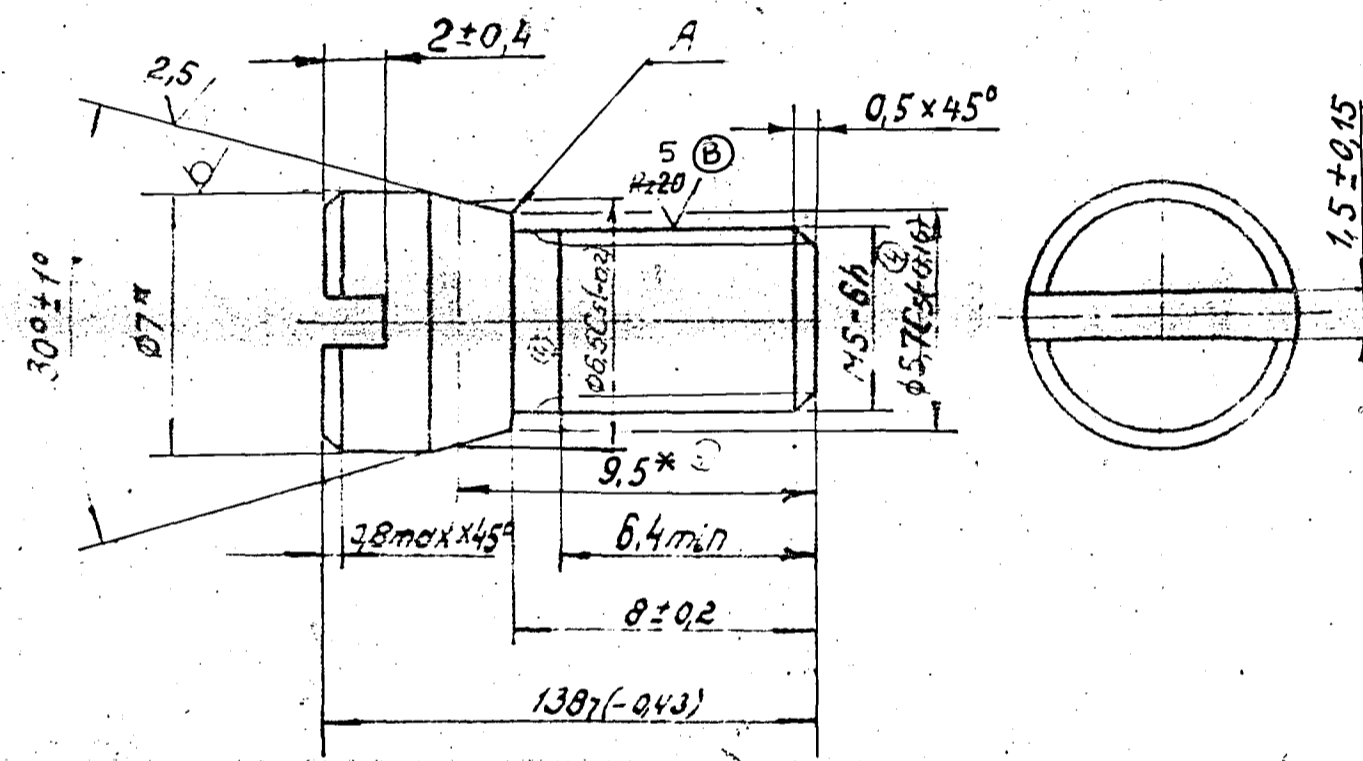
SIZE A4

DRAWING NUMBER

327 56 1

R240
 ✓
 ✓
 (B)

DRAWING INDIANISED BASED ON ISSUE 5



1. Подача контроля II по ТТ
2. Циануроват на глубину 0.10-0.25 мм. HRC ≥ 48
3. Изменение длины конуса 30° по окружности не более 0.5 мм
4. Допускается изготовление основания поза...
5. Покрытие хим. окс. прм.
6. Допускается использовать полкат 4 класса группы B ГОСТ 1051-73
7. Для обеспечения качества покрытия допускается удалять поверхностные дефекты прокатом с ослаблением его размера до 5 класса точности.
8. Кромку A допускается подтуплять фаской 0.3x45°
9. * размеры для справок.

7. TO ENSURE HIGH QUALITY OF COATING IT IS ALLOWED TO RECTIFY SURFACE DEFECTS OF ROLLED STOCK WITH DECREASE OF ITS SIZE AS PER ACCURACY CLASS 5
8. EDGE A MAY BE BLUNTED WITH CHAMFER 0.3X45°
9. DIMENSIONS FOR REFERENCE.

1. INSPECTION GROUP II AS PER TECHNICAL REQUIREMENTS !!
- (A) 2. TO BE CYANIDED TO A DEPTH OF 0.10 --- 0.25 MM HRC ≥ 48. HRC₃ ≥ 49.
3. VARIATION IN LENGTH OF TAPER 30° SHOULD NOT EXCEED 0.5 MM ALONG THE CIRCUMFERENCE.
4. BASE OF SLOT MAY BE MADE WITH R ≥ 35 MM.
5. COATING: CHEMICAL OXIDIZING, OIL FINISHING.
6. ROLLED STOCK OF CLASS 4 GROUP B. GOST 1051-73 MAY BE USED.

(C) EQUIVALENT MATERIAL
 040A04 (EN 2A) BS:970

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

EST. MASS 0.002 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

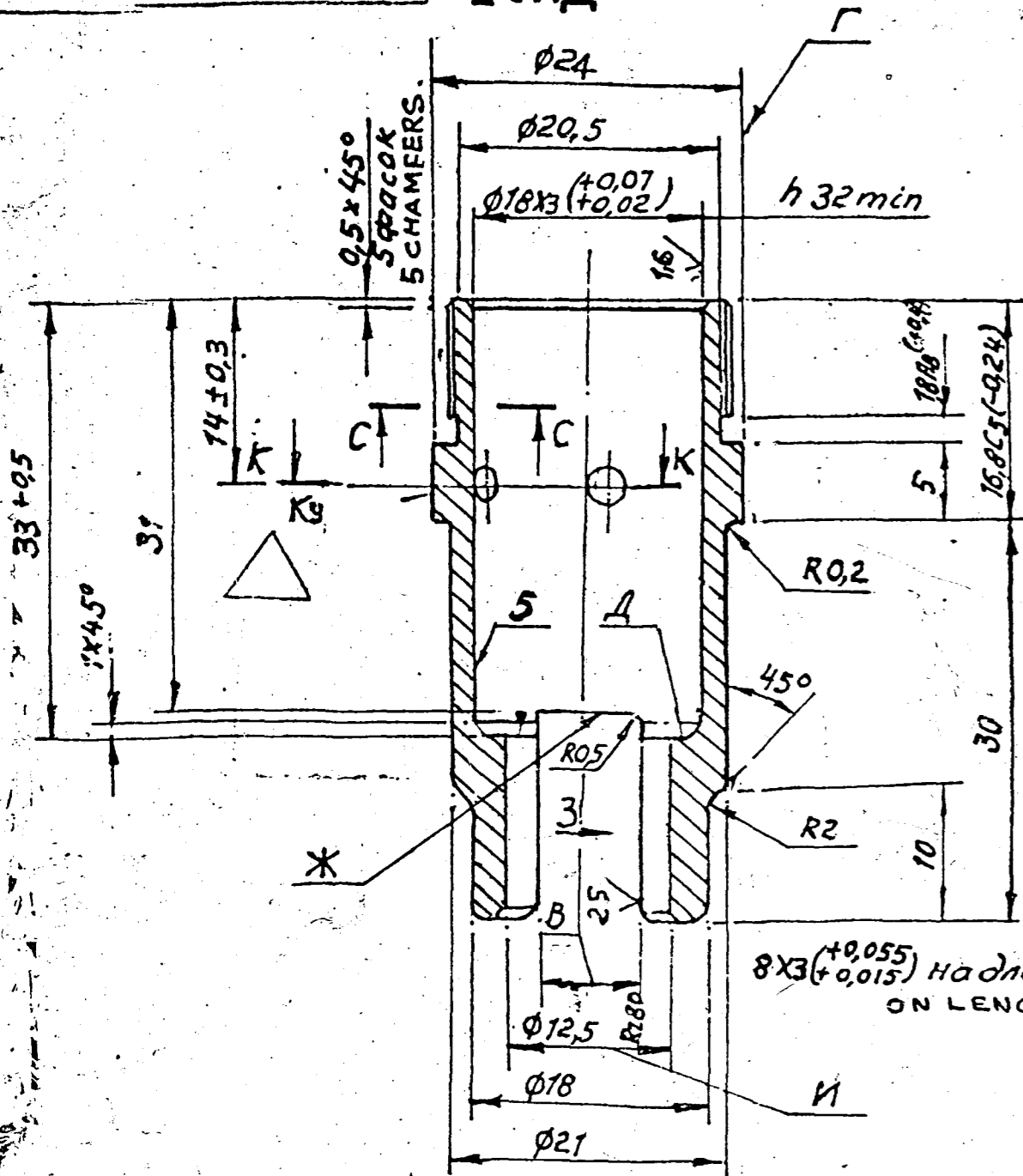
DRN	CHD	TCD	APPD	DATE	DIMENSIONS IN mm.	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	ALL THREADS CONFORM TO
				09-5-86			
MATERIAL: ROUND BAR 7.6 GOST 7417-75 10-B GOST 1051-73					USED ON:- CB 3327 06 CB 3327 06 3		
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI					TITLE:- RING WOOD SCREW		
D S'CAT NUMBER					DRAWING NUMBER 327 56 1		
ISSUE	DATE	NATURE OF AMENDMENTS					
C	1-7-10	4 th ALT. COMM. MEETING MINUTES POINT No.2 DATE 26-10-09					
B	26-9-93	AUTHY. BK90-393					
A	7.12.87	AUTHY BK 82-394.					

(A-0)
 SIZE A2

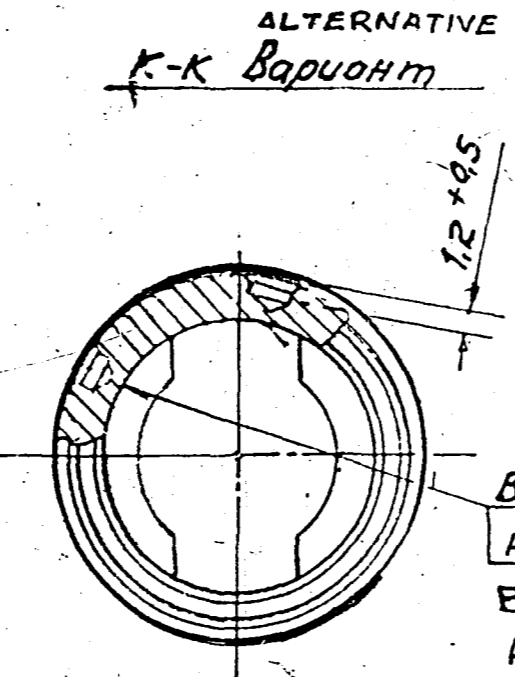
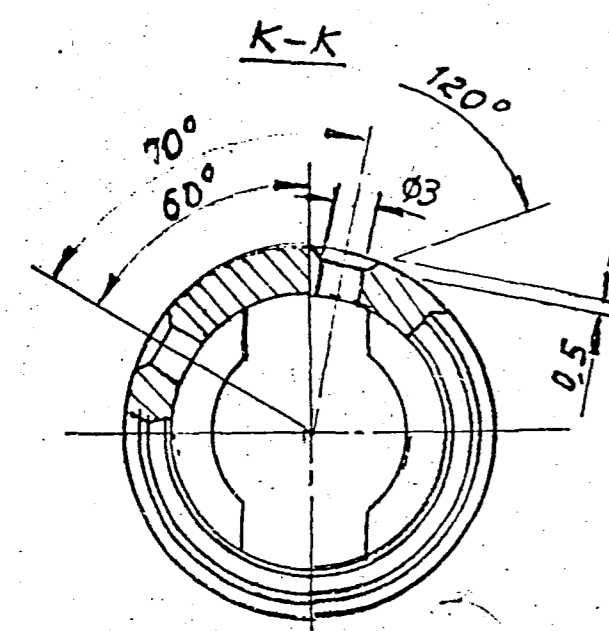
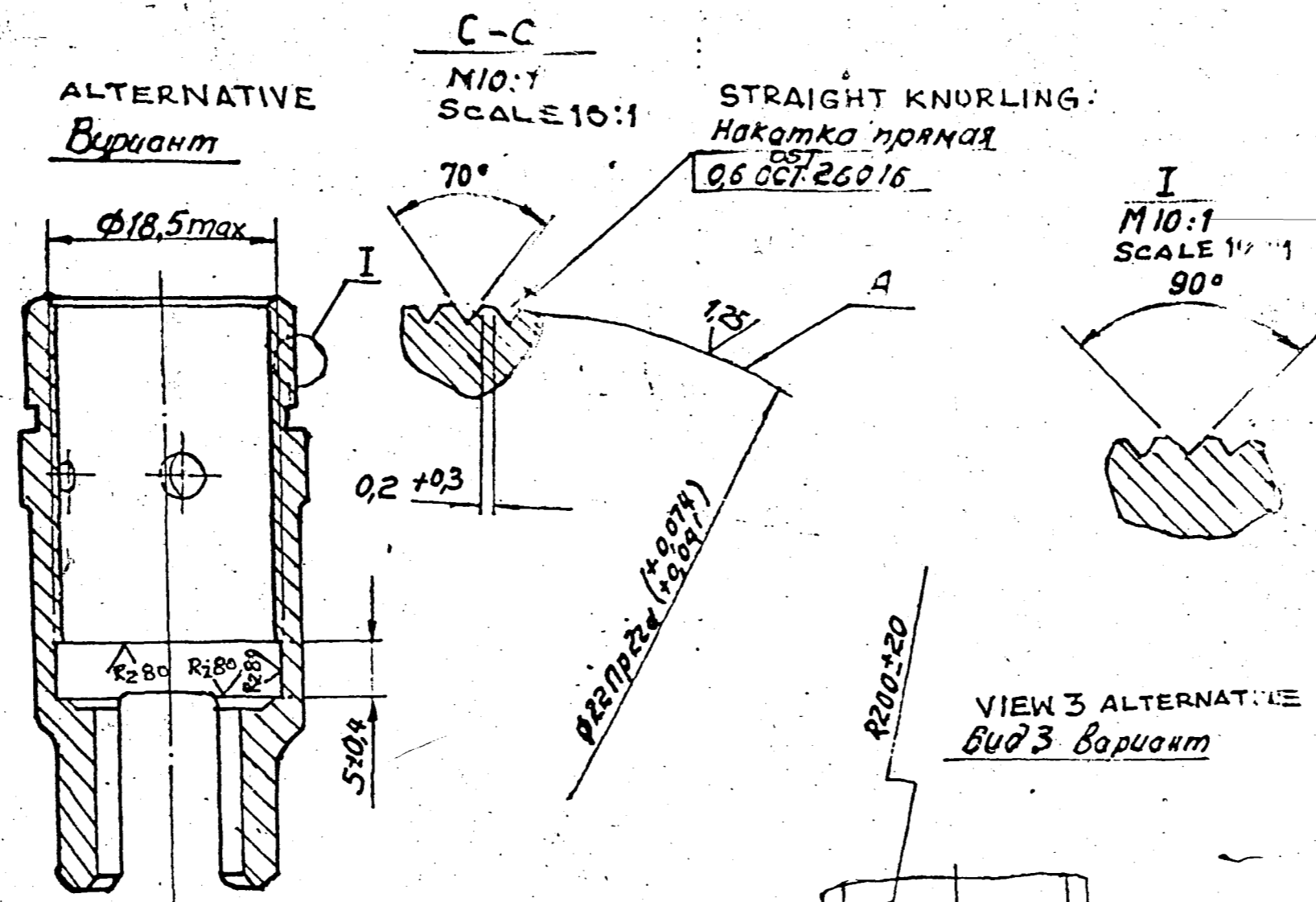
HS-L288

ЕСКД

R240/...



8x3 (+0,055 / +0,015) на длине от II ON LENGTH OF HOLE II



BULGING OF METEAL IS NOT ALLOWED.

- (A) 8. DURING MACHINING ENSURE SURFACE FINISH OF $\sqrt{\gamma}$ AND DIMENSION $\phi 24 \times 14 (-0,52) \text{ mm}$.
- (A) 12. * DIMENSION FOR REFERENCE.
- (B) ALTERNATE MATERIAL STEEL 070M20 (EN3A) TO BS: 970 - Pt-1-1983 (OR) 20 CB TO IS: 1570

3327.54

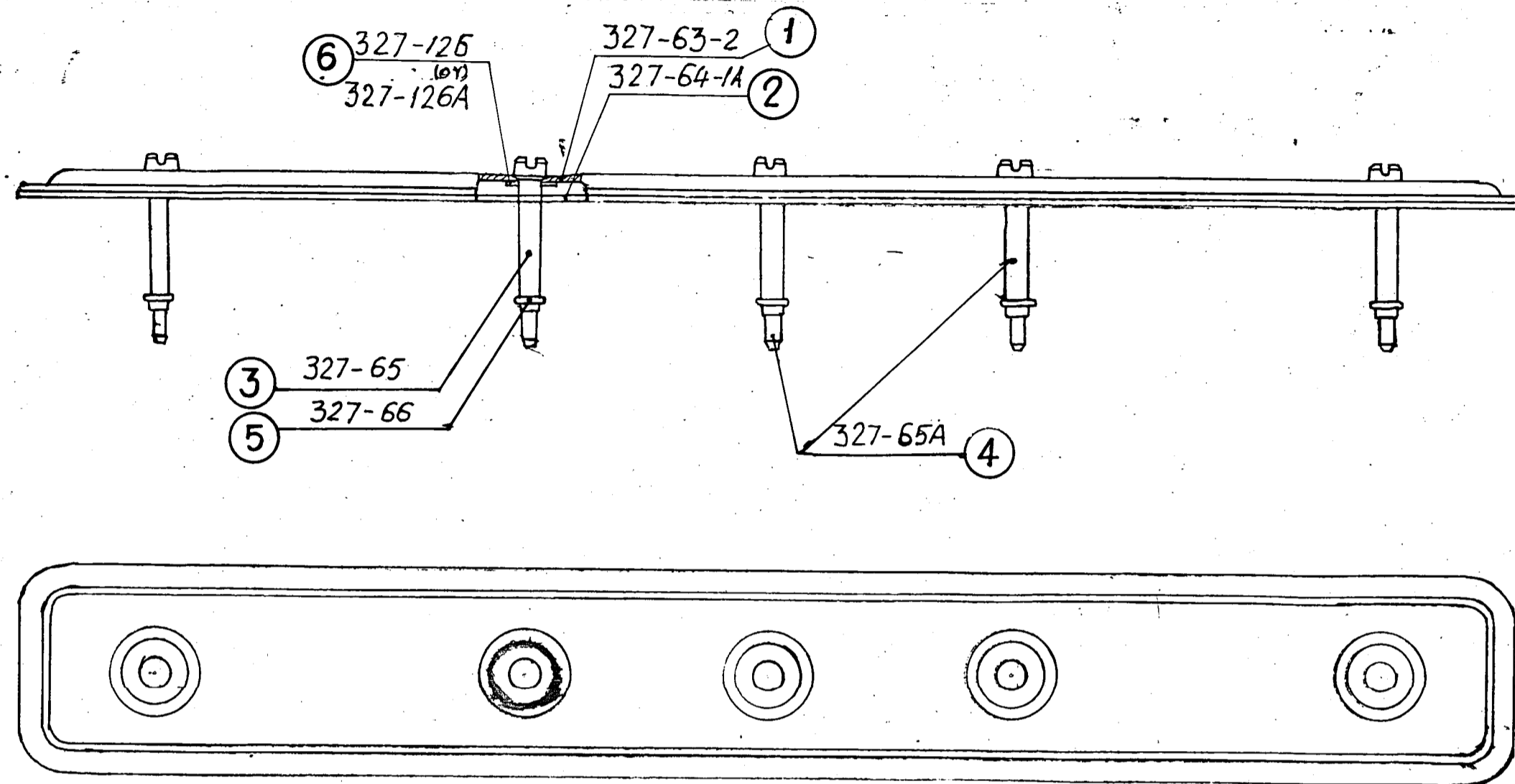
1. DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE MAINTAINED AS PER ACCURACY CLASS 7 OST 1010.
2. RUN OUT OF SURFACE A RELATIVE TO THE AXIS OF SURFACE SHOULD NOT EXCEED 0.03mm.
3. NON SYMMETRY OF AXIS OF SLOT B RELATIVE TO THE AXIS OF SURFACE SHOULD NOT EXCEED 0.02mm (MMC)
4. RADIUS FROM CUTTER 30mm MAY BE LEFT AFTER MACHING OF SLOT B.
5. ON SURFACE ISOLATED MARKS IN COMPLIANCE WITH STANDARD ARE ALLOWED.
6. COATING: CHEMICAL CHROMIZING, OIL FINISHING.
7. THERE MAY BE NO COATING ON THE SURFACE OF SLOT B, ALONG ITS PROFILE AND ON SURFACE ...
- (A) 8. ROUGHNESS IS ALLOWED ON SURFACE.
9. HOLE MAY BE INCREASED UPTO DIMENSION $\phi 18,08 \text{ mm}$.
10. ON FACE OF THE SLOT B CUTTING IN UPTO 0,5mm IS ALLOWED AFTER WITHDRAWAL OF GRINDING WHEEL.
11. ALTERNATE MATERIAL: STEEL GRADES, 25, 30 AND 40 GOST 1050-74.

(A) MATERIAL ROUND BAR 24-5 GOST 7417-75 20 B GOST 1051-73

(A-8)

EST. MASS 0,035 Kg		TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)	
3rd ALTERATION COMM		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE DATE	27 09 85	NATURE OF AMENDMENTS	MINUTES POINT 4, 27-5-85
DRN	SCALE - 2 : 1	MATERIAL: - STEEL - 20 (A) GOST 1050-74 - SEE ABOVE	USED ON: - CB 3327-06
CHD	DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI.	
TCD	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	TITLE: - SLEEVE ROTARY	
APPO	ALL THREADS CONFORM TO	DRAWING NUMBER 3327 54	
DATE		D S CAT NUMBER	

DRAWING NUMBER
CS 327 10 52



1. COMPONENT 327-64-1A SHOULD BE BONDED TO COMPONENT 327-63-2 WITH SEALANT AS PER SPECIFICATIONS 6-10-1010-75

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

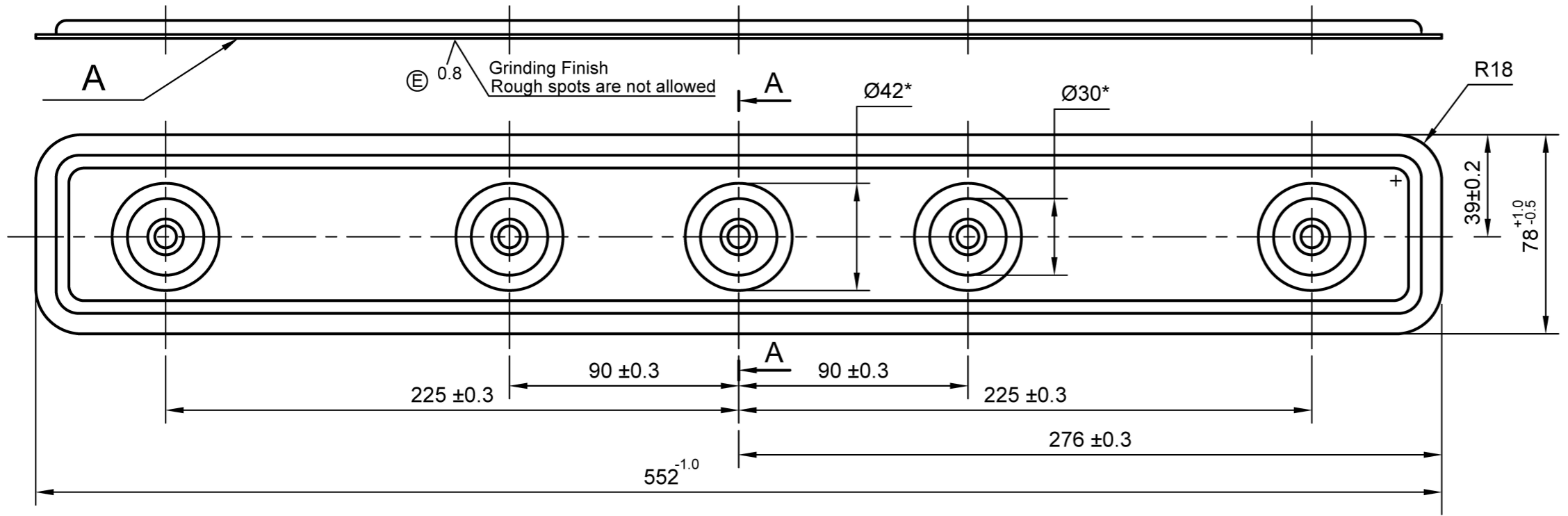
EST. MASS **0.018 Kg** TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

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

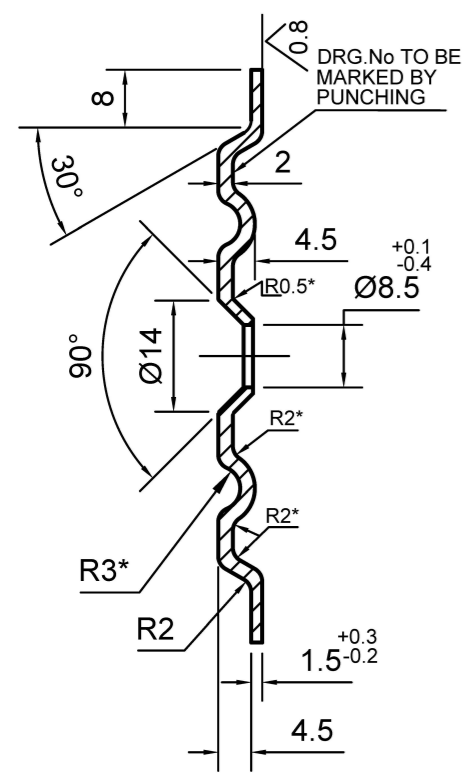
DRN	CHD	TCD	APPD	DATE	SCALE - 1 : 2	DIMENSIONS IN mm.	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	ALL THREADS CONFORM TO
				11.5.86				
MATERIAL :-					USED ON :-			
					CS 327 00 45			
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI					TITLE :-			
					COVER HOUSING			
D S CAT NUMBER					DRAWING NUMBER			
					CS 327 10 52			
ISSUE	DATE	NATURE OF AMENDMENTS						

(A-8)

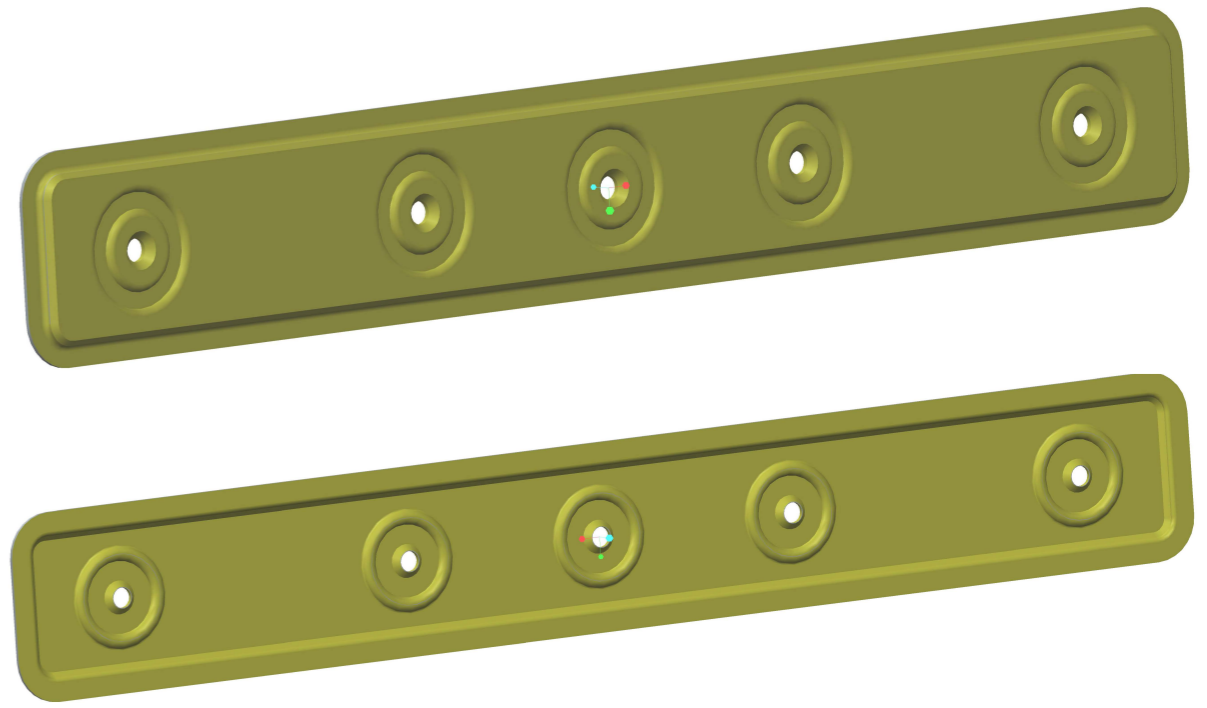
SIZE A2



SECTION : A : A
SCALE : 1 : 1



1. REQUIREMENTS FOR CASTING AS PER STANDARD 82050-16.
2. VARIATION IN THICKNESS OF FLANGE SHOULD NOT EXCEED 0.5MM.
3. AXIES OF HOLE SHOULD BE IN ONE PLANE, SHIFT SHOULD NOT EXCEED 0.2MM.
4. NON-STRAIGHTNESS OF SURFACE "A" NOT EXCEEDING 0.8MM. SHOULD BE CHECKED WITH COVER FASTENED TO SURFACE PLATE WITH FIVE SCREW.
5. SHARP EDGES SHOULD BLUNTED.
6. LOCAL THINNING OF FLANGE THICKNESS TO 1MM. IS ALLOWED.
7. COATING : Cd,9, CHROMATIZING IN ACCORDANCE WITH ИЦП-104 ЦП 569-84 WITH ELIMANATION OF HYDROGEN EMBRITTLEMENT.
- 8.* DIMENSIONS FOR REFERENCE
- 9.* DIMENSIONS FOR REFERENCE .
10. ALTERNATE MATERIAL : STEEL , GRADES ~~10K AND 00~~ 10КП, 8ПС AND 10 GOST 1050-74.
11. SURFACE MAY BE MACHINED TO ROUGHNESS NOT LESS THAN IN THIS CASE THICKNESS OF WALL OF TAPPER HOLE SHOULD NOT BE LESS THAN 1.5mm.



Ⓓ
EQUIVALENT MATERIAL :-
GRADE "D" IS : 513 -1994.

PILOT SAMPLE SHOULD BE APPROVED BY ASHP BEFORE BULK PRODUCTION

EST. WT. 0.695Kg	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	

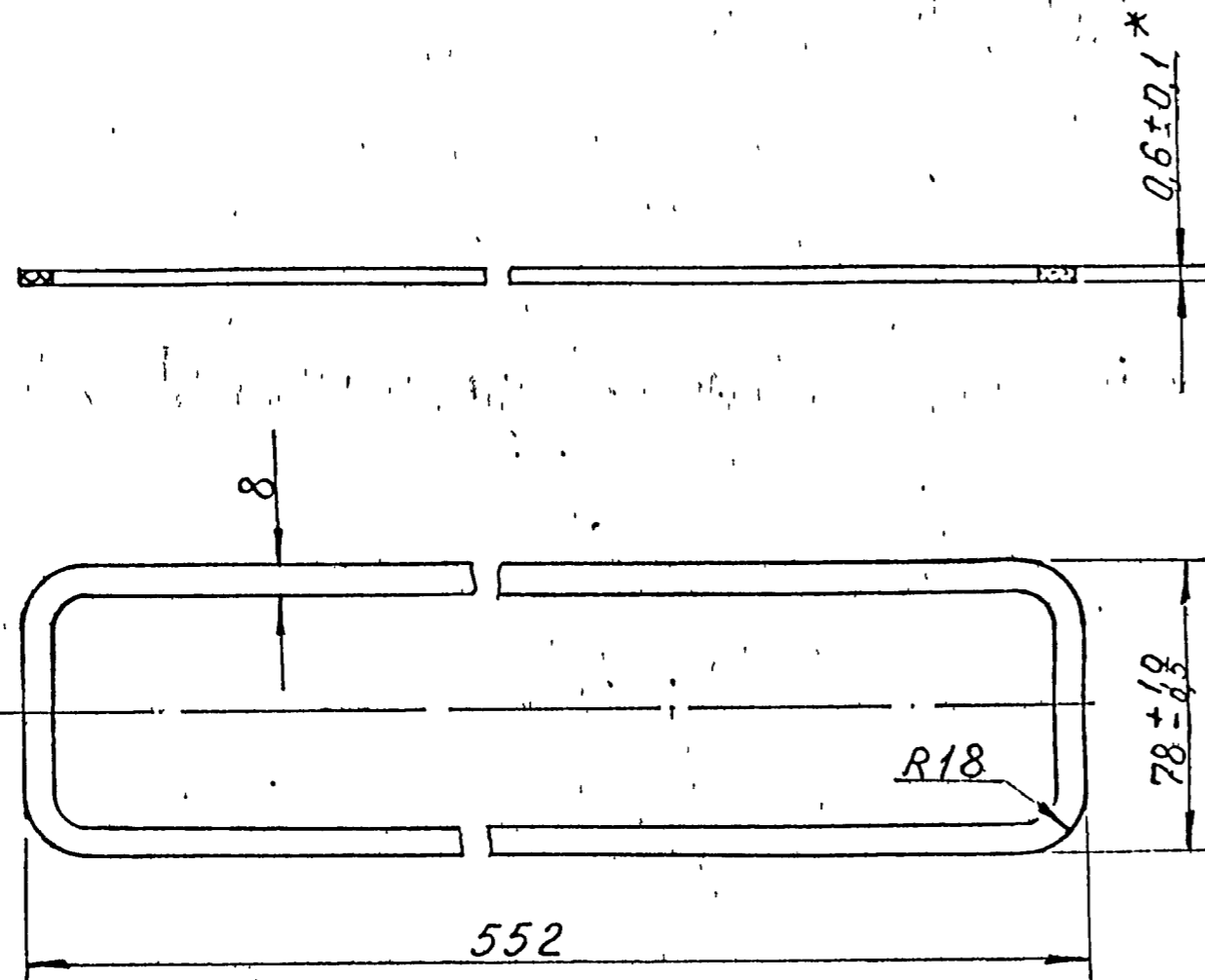
ISSUE	DATE	NATURE OF AMENDMENTS
E	26-09-17	GRINDING FINISH ADDED
D	18.03.10	4th A.C.M. Point No.1 Dt.26-10-09
C	21-9-93	AUTHY. NOTN.NO BK 85-666
B	15-2-88	AUTHY. NOTN. NO. BK 83-141
A	23-9-87	AUTHY. NOTN. NO. BK 83-11

DRN		MATERIAL:-	USED ON :-
CHD		SHEET : A-2 GOST 19904-74	C5 327-10-52
TCD		II-Br-08КП GOST 9045-80	
APPD		CONTROLLERATE OF QUALITY ASSURANCE HEAVY VEHICLES AVADI	
DATE		TITLE	
SCALE:- 1 : 2		COVER HOUSING	
ALL DIMNS IN MM.		D . S. CAT NUMBER	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69		DRAWING No.	
ALL THREADS TO CONFORM TO		327-63-2	

DRAWING NUMBER
327-64-1A

NOTE-

- 1 ALTERNATE MATERIAL ПОН -Б-1.0 OR ПМБ.1.0 GOST 481-80.
2. IN TROPICALIZED MAKE THE COMPONENTS SHOULD BE MANUFACTURED FROM RUBBERIZED ASBESTOS FABRIC ПМБ Т 0 6 GOST- 481-80 AND SHOULD HAVE MARKING WITH YELLOW PAINT AS STRIP ON THE SIDE SURFACE OF FINISHED GASKETS
- 3 * DIMENSIONS FOR REFERENCE

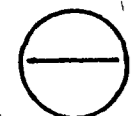


PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

EST. WT. 0.0117 Kg. TO BE STAMPED OR MARKED WHERE INDICATED THUS # 1 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.

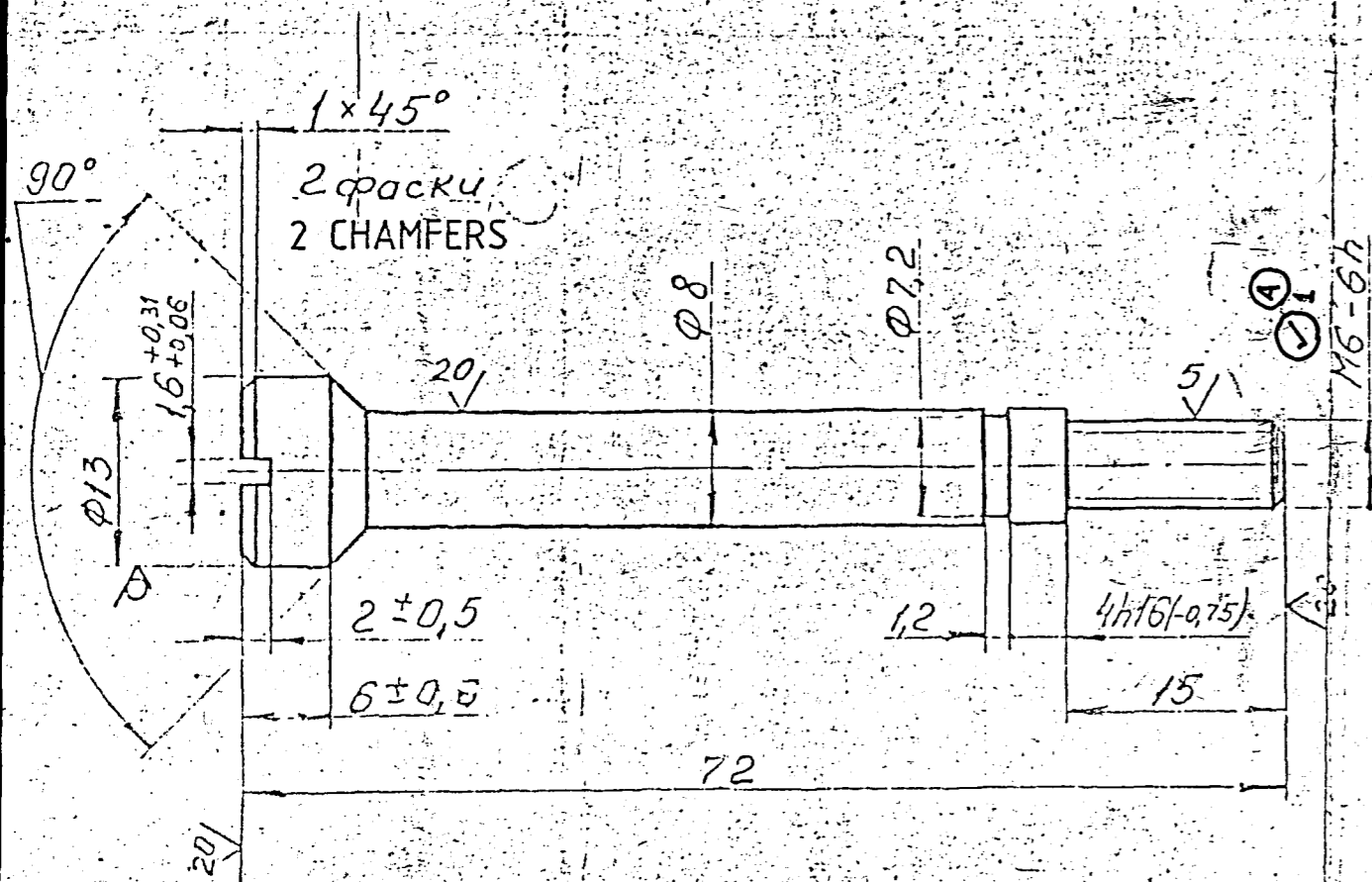
DRN	<i>S. J. J.</i>	MATERIAL:- RUBBERISED ASBESTOS FABRIC ПМБ 0.6 GOST 481-80	USED ON c b 327-10-52
CHD	<i>S. J. J.</i>	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES) AVADI	
TCD	<i>S. J. J.</i>		
APPO	<i>S. J. J.</i>	TITLE GASKET	
DATE	30/09-93		
SCALE:- 1/2		D S. CAT NUMBER	DRAWING NUMBER 327-64-1A
DIMENSIONS IN mm TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69			
ALL THREADS TO CONFORM TO			
ISSUE DATE	NATURE OF AMENDMENTS		



SIZE A3

327-65

ЕСКД

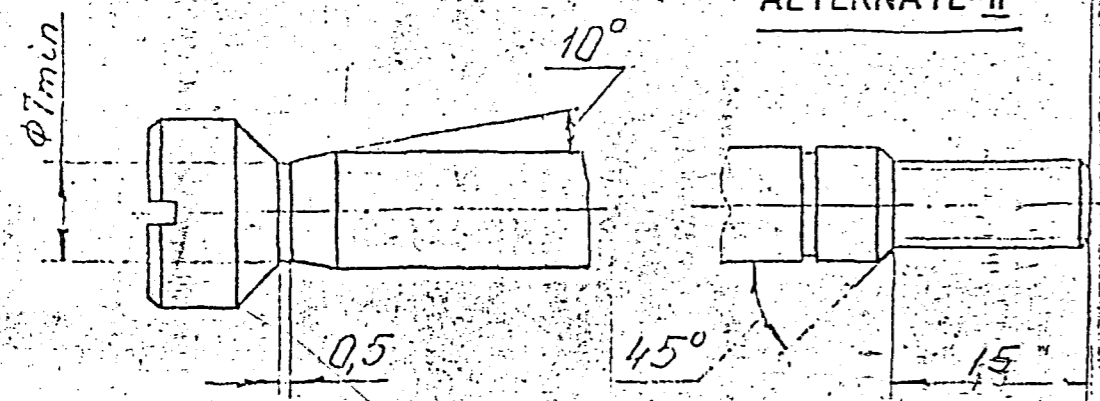


ALTERNATE-I

Вариант I

Вариант II

ALTERNATE-II



1. Заменитель материала сталь 35, 40, 50 ГОСТ 1050-74
2. Неуказанные предельные отклонения размеров: $H14, h14, \pm \frac{IT14}{2}$
3. Покрытие Ц 3. хр по ЦЛ-483-82 с удалением водородной хрупкости.
4. В пропическом исполнении покрытие К 29. хр по ЦЛ-569-84 с удалением водородной хрупкости.
5. На резьбе допускается отсутствие покрытия.
6. При прорезке паза под отвертку допускается оставление радиуса от фрезы не менее 25мм.
7. Вместо сбега резьбы допускается канавка диаметром 5,4мм и шириной 2,5мм.
8. При высадке головки винта допускается изготовление винта из круга 8-5 ГОСТ 7417-75 с шероховатостью необрабатываемых поверхностей.
9. Допускается использовать прокат 4 класса группы В ГОСТ 1051-73. Для обеспечения качественного покрытия, допускается удалять поверхностные дефекты проката с прослаблением его размера до 5 класса точности.

10. REPAIR SIZE DIMENSIONS ARE ADDED BASED ON LT. NO: 82847/CH/QAS/ED.

DT. 27 MAR 95 AS FOLLOWS:

REPAIR SIZE DIMENSION ADDED WHERE INDICATED THUS (C)

11	ВК 85-870		
Мзм	Лист	В докум.	Подп. Дев

SL.No.	R	REMARKS
(C) 1	M6-6h	1. ALL OTHER CONDITIONS AS PER STD. DRG. 2. MARK REPAIR SIZE.

- 1) ALTERNATE MATERIAL: STEEL 35,40,50 GOST 1050-74.
- 2) UNSPECIFIED TOLERANCES OF DIMENSIONS $H14, h14, \pm \frac{IT14}{2}$
- 3) COATING: Zn 3 Cr AS PER ЦЛ-483-82 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
- 4) FOR TROPICAL USE: COATING Cd9 Cr AS PER ЦЛ-569-84 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
- 5) THREAD MAY NOT BE COATED.
- 6) RADIUS FROM CUTTER $R \geq 25mm$ MAY BE LEFT AFTER CUTTING OF SLOT FOR SCREW DRIVER.
- 7) INSTEAD OF RUN OUT OF THREAD, CLEARANCE GROOVE WITH DIAMETER 5.4mm AND WIDTH OF 2.5mm IS ALLOWED.
- 8) IT IS ALLOWED TO MANUFACTURE SCREW FROM BAR 8-5 GOST 7417-75 10-5 GOST 1051-73 WITH SURFACE ROUGHNES OF NON-MACHINED SURFACES (C) IN CASE OF UPSETTING SCREW HEAD.
- 9) ROLLED STOCK OF CLASS 4 GROUP B. GOST 1051-73 MAY BE USED TO ENSURE HIGH QUALITY COATING, IT IS ALLOWED TO RECTIFY SURFACE DEFECTS ON ROLLED STOCK BY SLACKENING ITS DIMENSIONS AS PER ACCURACY CLASS 5,

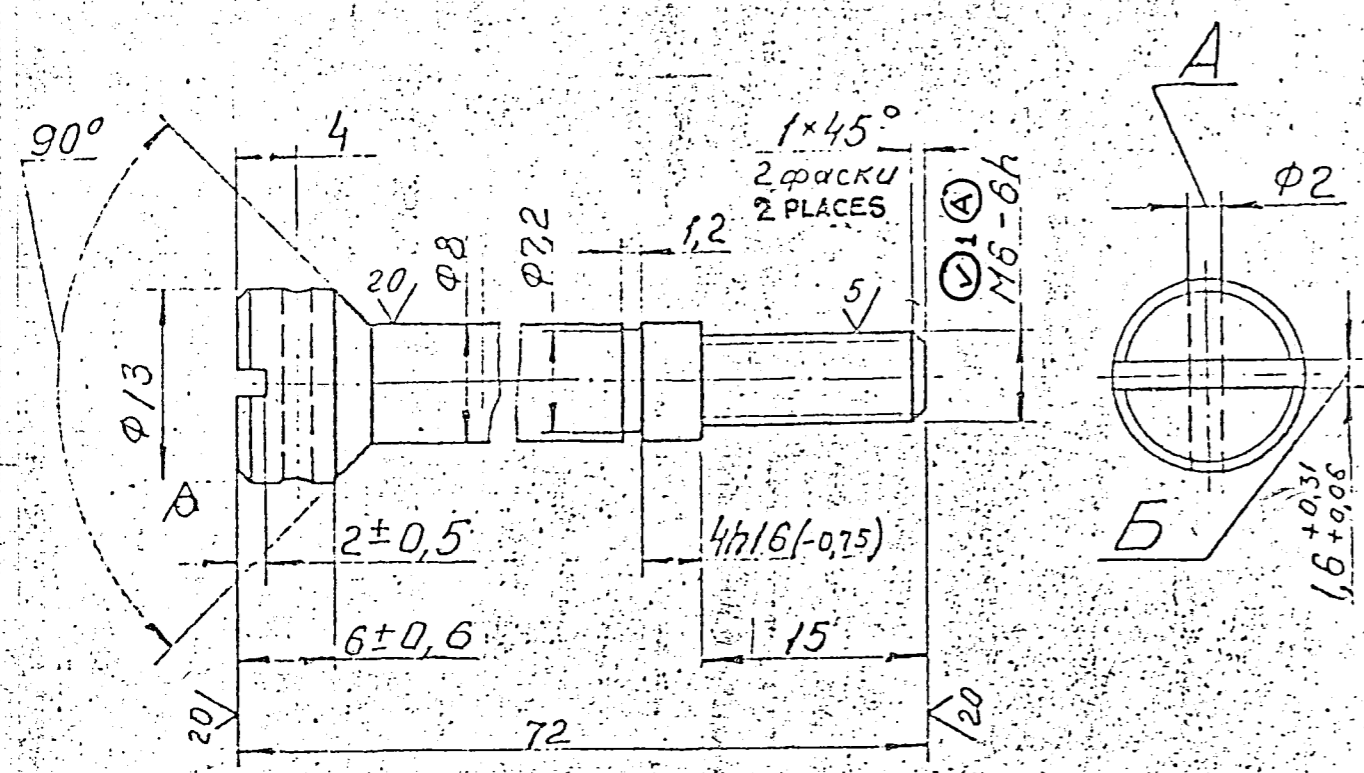
* * ROUND BAR 13-4 GOST 7417-75 45-5 GOST 1051-73.

(B) ALTERNATE MATERIAL: STEEL 080 M40 (EN8) TO BS: 970 Pt-1-1983 OR 45 CB TD IS-1570.

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

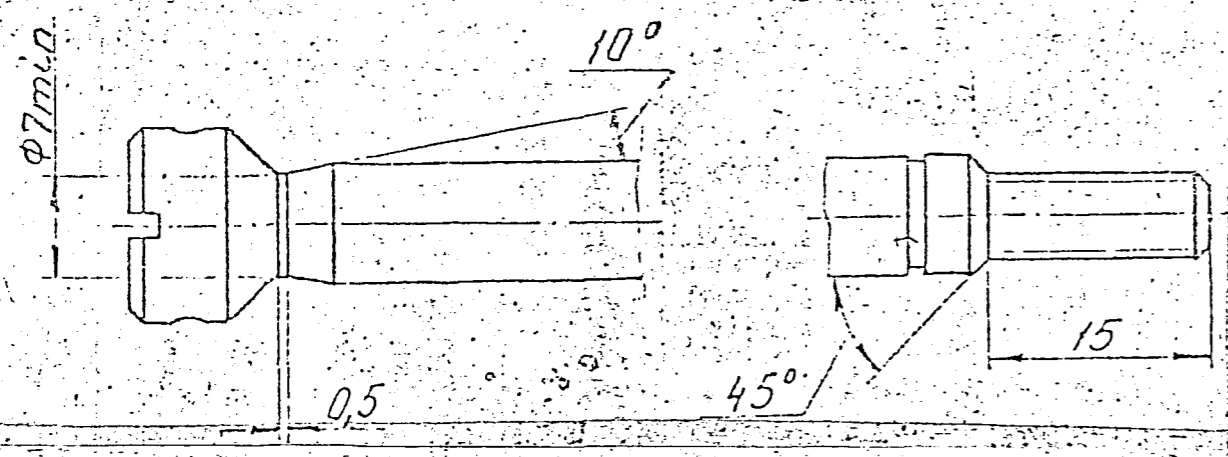
EST. MASS	0,027 Kg.	TO BE STAMPED OR MARKED WHERE INDICATED THUS #	LETTERS I
ISSUE DATE	13-2-09	NATURE OF AMENDMENTS	3rd ALTN. COMM. MIN. POINT 8, DT. 27-2-09
DRN	13-2-09	SCALE: 2 : 1	REPAIR SIZE ADDED
CHD	13-2-09	DIMENSIONS IN mm	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R. OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE
TCD	13-2-09	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	MATERIAL: SEE ABOVE. USED ON: CB 327-10-52
APPD	13-2-09	DATE 17-2-88	CONTROL RATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A D I
DATE 17-2-88	ALL THREADS TO CONFORM TO	D S CAT NUMBER	TITLE: COVER SCREW
		DRAWING NUMBER	327-65

ЕСКД



ALTERNATE I
Вариант I

ALTERNATE II
Вариант II



1. Заменитель материала сталь 35, 40, 50 ГОСТ 1050-74.
2. Неуказанные предельные отклонения размеров: $H14, h14, \pm \frac{IT14}{2}$
3. Расположение паза Б относительно отверстия А безразлично.
4. Покрытие Ц.З. хр по ЦЛ-483-82 с удалением водородной хрупкости.
5. В тропическом исполнении покрытие Кд 9 хр по ЦЛ-569-84 с удалением водородной хрупкости.
6. На резьбе допускается отсутствие покрытия.
7. Допускается вскрытие отверстия А в пазу Б.
8. При прорезке паза Б допускается ослабление радиуса от фрезы не менее 25мм.
9. Вместо сбега резьбы допускается канавка диаметром 5,4мм и шириною 2,5мм.
10. При высадке головки винта допускается изготовление винта из круга 8-5 ГОСТ 7417-75 с шероховатостью необрабатываемых поверхностей.
11. Допускается использовать прокат 4 класса группы В ГОСТ 1051-73. Для обеспечения качественного покрытия допускается удалять поверхностные дефекты проката с прослаблением его размера до 5 класса точности.

- 1) ALTERNATE MATERIAL: STEEL 35, 40 AND 50 GOST 1050-74.
- 2) UNSPECIFIED DEVIATIONS IN DIMENSIONS $H14, h14, \pm \frac{IT14}{2}$
- 3) LOCATION OF GROUP Б, RELATIVE TO HOLE А IS ARBITRARY.
- 4) COATING Zn3 Cr AS PER ЦЛ-483-82 WITH THE REMOVAL HYDROGEN BRITTLENESS.
- 5) FOR TROPICAL MANUFACTURING COATING Cd9Cr AS PER ЦЛ569-84 WITH THE REMOVAL OF HYDROGEN EMBRITTLEMENT.

- 6) ABSENCE OF COATING ON THREADS IS PERMITTED.
- 7) OPENING OF HOLES 'A' IN SLOT 'B' IS ALLOWED.
- 8) DURING CUTTING OF GROOVE Б, RADIUS OF MILLING TOOL NOT LESS THAN 25mm IS ALLOWED.
- 9) RISE OF THREADS GROOVE WITH DIAMETER 5,4 AND BREADTH 2,5mm IS ALLOWED IN PLACE OF RISE OF THREADS.
- 10) DURING SETTING OF HEAD OF SCREW, IT IS PERMITTED TO MANUFACTURE THE SCREWS FROM ROUND BAR 8-5 GOST 7417-75 WITH SURFACE FINISH OF NOT-MACHINED SURFACES.
- 11) ROLLED STOCK OF CLASS 4 GROUP B GOST 1051-73 MAY BE USED. TO ENSURE HIGH QUALITY OF COATING, IT IS ALLOWED TO RECTIFY SURFACE DEFECTS OF ROLLED STOCK WITH DECREASE OF ITS DIMENSIONS AS PER ACCURACY CLASS 5.
- 12) REPAIR SIZE DIMENSION ADDED BASED ON LETTER No. B2847/OH/QAS/ED. DT. 27 MAR '95 AS PER TABLE 1. REPAIR SIZE DIMENSION ADDED WHERE INDICATED THUS ⓐ.

ⓑ ALTERNATE MATERIAL: STEEL 080 M40 (EN 8) TO BS: 970 Pt-1-1983 OR 45 CB TO IS: 1570.

SL. No.	R	REMARKS.
1	M 8-6h	1. ALL OTHER CONDITIONS AS PER STD. DRG. 2. MARK REPAIR SIZE.

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

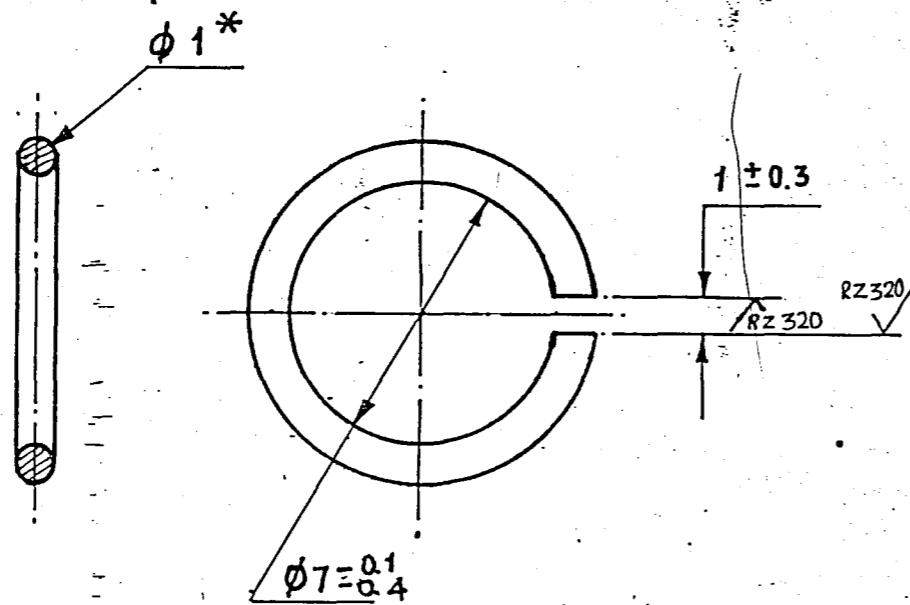
EST. WT. 0.026 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	TCD	APPD	DATE	SCALE	DIMENSIONS IN mm.	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69	TITLE	D S CAT. NUMBER	DRAWING NUMBER
				17-2-88	2:1			COVER SCREW		327-65A
C	12-8-10	4 th Alt. Comm. Meeting Minutes Point No. 11 Dt: 26-10-09								
B	13-7-09	3 rd ALTERATION COMM. MINUTES POINT B, DATE 27-2-09								
A	5-9-95	REPAIR SIZE ADDED								
ISSUE	DATE	NATURE OF AMENDMENTS								

И	8K85-870	1
Мат. Лист	в докум.	Лист

DRAWING NUMBER
327-66

✓ (✓)



1. LENGTH OF STRAIGHTENED COMPONENT 24 mm
2. ---
- * 3. DIMENSION FOR REFERENCE.
4. COATING: IS CD9, CHROMATIZING IN ACCORDANCE WITH ~~УУА-104~~ WITH ELIMINATION OF HYDROGEN - EMBRITTLEMENT.
 (A) УА-569-84

EXPLANATORY NOTE:-

MATERIAL QUOTED: WIRE II-1.0 GOST 9389-75.
 CARBON STEEL COLD-DRAWN WIRE.
 II= SECOND CATEGORY AS REGARDS MECHANICAL PROPERTIES.
 1.0 = DIAMETER OF WIRE WITH TOLERANCE ± 0.03
 MANUFACTURING ACCURACY- NORMAL ACCURACY.
 MAY BE MANUFACTURED FROM ANY OF THE SINGLE GRADE.
 CHEMICAL COMPOSITION :

	KT 2	SK 7	
CARBON	= 0.86 - 0.91	0.68 - 0.76	} MAXIMUM
MANGANESE	= 0.20 - 0.40	0.50 - 0.80	
SILICON	= 0.17 - 0.37	0.17 - 0.37	
SULPHUR	= 0.020	0.030	
PHOSPHORUS	= 0.020	0.020	
CHROMIUM	= 0.05	0.05	
NICKEL	= 0.05	0.05	
COPPER	= 0.10	0.04	

MECHANICAL PROPERTIES :-

ULTIMATE TENSILE STRENGTH $\text{kgf/mm}^2 = 210-250$
 NO. OF TWISTS = 17

(C) EQUIVALENT MATERIAL
 Gr. SM/SH IS: 4454-2001

KVD 63474
EXPLANATORY NOTE ADDED ON 20-1-92

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

EST. WT. (B)
 0.00015 kg
 0.0005 kg
 TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

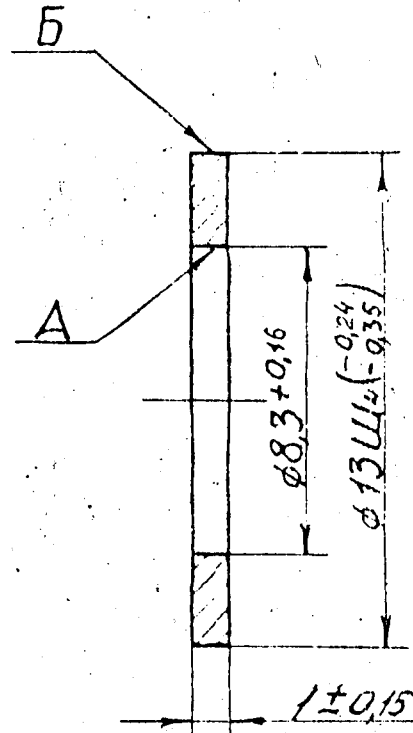
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

ISSUE	DATE	NATURE OF AMENDMENTS	DRN CHD TCD	MATERIAL:- WIRE II-1.0 GOST 9389-75	USED ON CB 327-10-52
			APPD DATE 8-5-86	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADL	
			SCALES- 5:1	TITLE THRUST RING	
			DIMENSIONS IN mm TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69.	D S CAT NUMBER	DRAWING NUMBER 327-66
			ALL THREADS TO CONFORM TO		
C	16-8-10	4 th Alt. Comm. Meeting Minutes Point No.13 Dt.26.10.09			
B	21.9.93	BK 86-441			
A	15-2-88	AUTHY. NOTN. No. BK 85-141.			

(A/8)
SIZE A3

327-126

ЕСАД



1. Радиальное биение отверстия А относительно оси поверхности Б не более 0,4 мм.

2. Детали должны соответствовать утвержденному эталону.

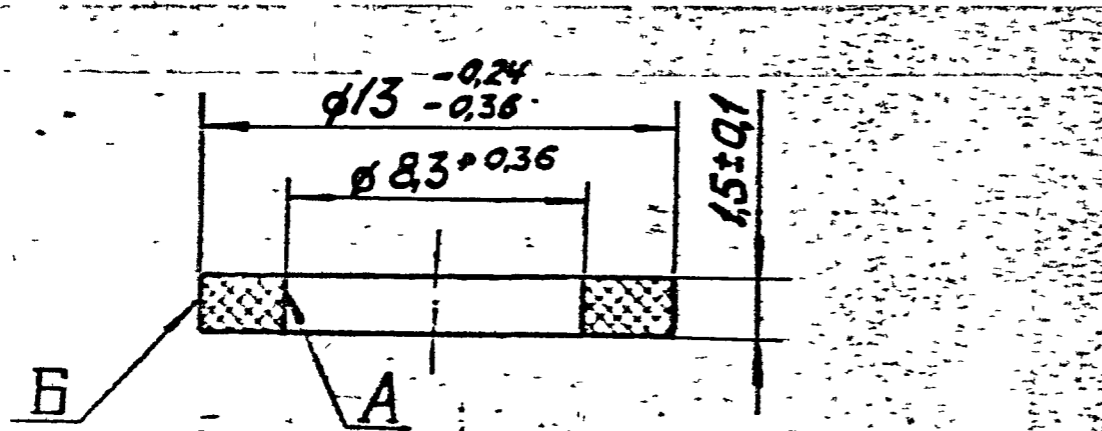
3. Остальные требования по ТУ 81-04-395-75.

1. RUN-OUT OF HOLE A RELATIVE TO AXIS OF SURFACE B SHOULD NOT EXCEED 0.4 MM.
2. COMPONENTS SHOULD AGREE WITH APPROVED STANDARD.
3. THE REST OF THE REQUIREMENTS - IN ACCORDANCE WITH ТУ 81-04-395-75

(A) MATERIAL: - FIBRE ϕ T1, 1st GRADE GOST 14613-83

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS #
		0.0001 Kg	LETTERS) (A-8)
A	15.2.88	AUTHY. NOTN. NO. BK 83-88	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE - 5 : 1	MATERIAL: - FIBRE ϕ T1 (A) USED ON: cb 327 10 52 SEE ABOVE GOST 14613-83 cb 327 00 45 cb 20-27-00-4
CHD		DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	TITLE: - GASKET (1.0 mm)
APD		ALL THREADS CONFORM TO	D S CAT NUMBER
DATE	08.15.88		DRAWING NUMBER 327 126

327-126A



1. SUBJECT THE PART TO HEAT-TREATMENT IN COMPLIANCE WITH INSTRUCTIONS U-150-131/68.
2. RADIAL RUN-OUT OF SURFACE A WITH RESPECT TO THE AXIS OF SURFACE B SHOULD NOT EXCEED 0.2MM.
3. CARRY OUT ACCEPTANCE AS PER STANDARD.
4. STAMP FINAL ACCEPTANCE AND MARK DATE OF MANUFACTURE OF BATCH OF PARTS ON THE LABEL.
5. OTHER TECHNICAL REQUIREMENTS AND ACCEPTANCE ARE AS PER OCT 4 Γ 0.005. 0.51

EXPLANATORY NOTE -

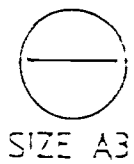
- 6 MATERIAL QUOTED -- POLYAMIDE A6 - 210 / 311 - 14 OST 6-06-C9-76
- 1 APPEARANCE AND COLOUR
CRUMB (GRANULE) FROM WHITE TO LIGHT YELLOW COLOUR OR COLOURED SPOT INCLUSION OF OXIDES PARTICLES ARE ALLOWED NOT MORE THAN 18 FOR 100 g OF POLYAMIDE
- 2 SIZE OF CRUMB (GRANULE)
DIAMETER = 2,0 - 4,0
LENGTH = 1,0 - 5,0
- 3 MOISTURE CONTENT % = 0,2 (MAX)
- 4 RELATIVE VISCOSITY = 2,4 (MIN)
- 5 % CONTENT OF EXTRACTABLE SUBSTANCES = 1,5 (MAX)
- 6 % CONTENT OF UN-CHOPPED CRUMBS (GRANULES) = 0,5 (MAX) FOR A LENGTH UP TO 20mm
- 7 MELTING TEMPERATURE = 215°C (MIN)

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

EST WT TO BE STAMPED OR MARKED WHERE INDICATED THIS = (LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE AS BE EQUIVALENT CHAMFERS ARE PERMISSIBLE

DATE	24-4-87	MATERIAL -	POLYAMIDE A6-210 / 311-14	USED ON	CS 327-00-45
SCALE	5:1	OST	6-06-C9-76		CS 327-10-52
ISSUE	1	DATE		CONTROL	DATE
				OF QUALITY ASSURANCE	HEAVY VEHICLES
				AVAD	
		TITLE	GASKET (1.5 mm)		
		D S CAT NUMBER		DRAWING NUMBER	327-126A
ISSUE	DATE	NATURE OF AMENDMENTS			



SIZE A3

USED ON

CB 327-00-45
 CB 327-00-47-01
 CB 327-00-73

(B)

(C)

(A)

ITEM	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	NO OFF	REMARKS
	CB 315 664 2		BUSH		
	& ITEM LIST				
1	315 613 3		STOP DISC	1	
2					
3					
4	315 615 3		LEVER STOP	1	
5	315-616-4 315-616-7		BUSH	1	
6	315 644		LOCKING RING	1	
7	315 646 1		BEARING No. 8109 GOST 6874-75 ETY 500 - 45	1	

ROL No. 2536
 RESTRICTION
 Certified Correct Copy of Sealed Drawing
 19 DEC 2021
 A. SAMPATH, JTO (D)
 FOR CONTROLLER
 Controllerate of Quality Assurance
 (Heavy Vehicles)
 Ministry of Defence (DGQA)
 Chennai-600 054.

C	16.12.21	AUTHY: CQA(HV) NOTING No. 81240/CQA(HV)/DB/ENG/AMDT Dt. 03.12.2021.			
B	05.07.19	USED ON NUMBER ADDED.			
A	7.12.87	AUTHY BK 83-297.			
ISSUE	DATE	NATURE OF AMENDMENTS	ISSUE	DATE	NATURE OF AMENDMENTS
DRN	[Signature]		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
CHD	[Signature]		TITLE: BUSH		
TCD	[Signature]		D S CAT NUMBER		
APPD	[Signature]		ITEM LIST FOR		
DATE	11.5.86.		SHT 1 OFF 1 CB 315 664 2		

COMMON TO V46-6 & V92-S2

COMMON TO V46-6 & V92-S2

COMPRESSED AIR.

2. JAMMING OF BEARING IS NOT ALLOWED.

1. Узел протыть, продуть сжатым воздухом.
2. Заведание & подшипника не допускается.

Время

7 315-646-1

315-613-3

Клеймо металлургическое

TO BE PUNCHED

315-644

315-616-7 (B)

~~315-616-4~~

4 315-615-3

0.015
0.014
Hanna

INTERFERENCE

0.15
0.030
30300

CLEARANCE

CONTROL No. 2536
RESTRICTED
Certified Correct Copy of Sealed Drawing specification as per
18 Oct 2021
A. SAMPATH, JTO (D)
FOR CONTROLLER
Controllerate of Quality Assurance
(Heavy Vehicles)
Ministry Of Defence (DGQA)
Avadi, Chennai-600 054

** Cb 327-00-47-01 (A)
Cb 327-00-73

			EST. MASS 0044 Kg.	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)
B	16.12.21	Authy. Nr.NO: 81240/CQA(HV) /DB/ENG/AMDT Dt.03.12.21.		
A	5.7.19	USED ON NUMBER ADDED		
ISSUE DATE	NATURE OF AMENDMENTS	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		
DRN	SCALE - 1 : 1	MATERIAL :-	USED ON: - Cb 327-00-45 **	
CHD <i>Das</i>	DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
TCD <i>Das</i>	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE:-	BUSH	
APPD <i>Das</i>	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER Cb 315-664-2	

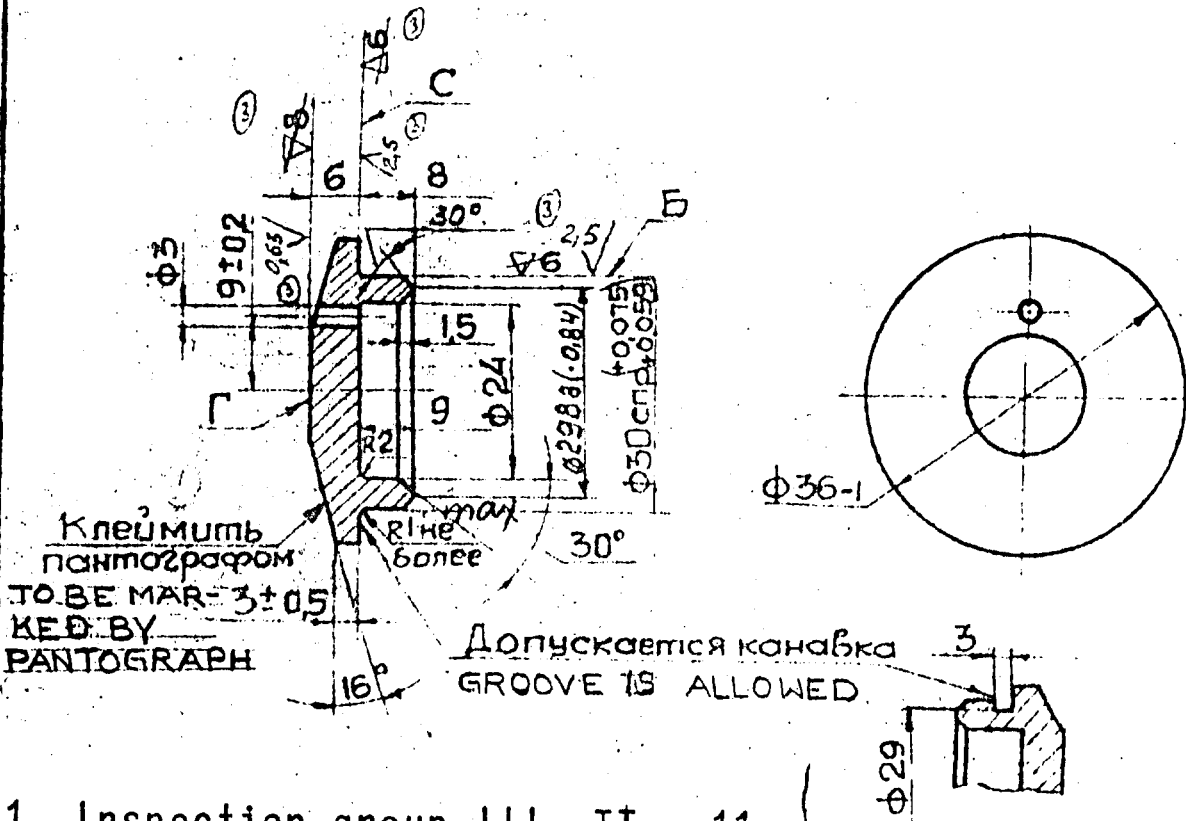
A6

315-615-3

8240
V/V 4 (V)
3

SHEET No. 1 OF 2

DRAWING INDIANISED BASED ON ISSUE 3 (2)



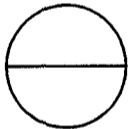
1. Inspection group III, TT - 11.
2. ~~HRC 60-63~~. HRC₃ 61... 64
3. Dimensions with unspecified tolerances should be obtained as per accuracy class 7 OST 1010.
4. Non-parallelism of faces "Г" and "С" should not exceed 0.05 mm. at diameter 14 mm.
5. Non-squareness of face "Г" relative to axis of surface Б should not exceed 0.05 mm. at dia. 14 mm.
6. Sharp edges should be blunted.
7. Recess with dia of 5 mm and depth of 1.5 mm is allowed on bottom Ø 24 mm.
8. Coating:- Chemical oxidizing, oil finishing.

A-6

СЭ 315-664-2

		EST. MASS 0.05 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS
B 9.7.22	SHEET 2 CREATED.	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
A 23.11.87	AUTHY BK 82-394	MATERIAL:- STEEL W X15 GOST 801-78	USED ON:- CB 315 615 2
ISSUE DATE	NATURE OF AMENDMENTS	CONTROLLERATE OF INSPECTION HEAVY VEHICLE AVADI	
SCALE	- 1 : 1	TITLE:- LEVER STOP	
CHOICE	DIMENSIONS IN mm.	D S CAT NUMBER	DRAWING NUMBER 315 615 3
TED	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	Sht 1 of 2	
APPO	ALL THREADS CONFORM TO		
DATE			

SHEET 2 CREATED ISSUE-"B", BASED ON CQA(HV) NOTING No. 111909/CQA(HV)/DB/ENG/T-90/ALT.COMM dt. 05 Aug 2020 & POINT No.3 OF 14TH ACM



DRAWING NUMBER
315-615-3

SHEET No. 2 OF 2

EXPLANATORY NOTE:

Material Quoted: Steel ШX15 GOST 801-78

Ш- beginning - Ball Bearing

X - Alloyed with Chrom

15 - Mass fraction of Chrom (1.5%)

CHEMICAL COMPOSITION: AS PER GOST 801-78

CONTENT OF ELEMENTS %

GRADE OF STEEL	C	Si	Mn	Cr	S	P	Ni	Cu	Ni+Cu
					Maximum				
ШX15	0.95 - 1.05	0.17 - 0.37	0.20 - 0.40	1.30 - 1.60	0.02	0.027	0.30	0.25	0.50

MECHANICAL PROPERTIES

Hardness - 179 - 207 HB

Note : Any other parameters given in specification to be adhered in ToTo.

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

			EST. WT. Refer Sht 1 of 2	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 :- Refer Sht 1 of 2	USED ON :- Refer Sht 1 of 2
ISSUE	DATE	NATURE OF AMENDMENTS		
DRN		SCALE :- —	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
		DIMENSIONS IN mm		
CHD		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS : 2102 - 69		TITLE :- LEVER STOP
APPR		ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER 315-615-3 SHT 2 of 2
DATE	09 Jul 2022			
SIZE	A4			

DRAWING NUMBER
315-644

✓ (✓)

EXPLANATORY NOTE

3 REFERENCE MATERIAL QUOTED

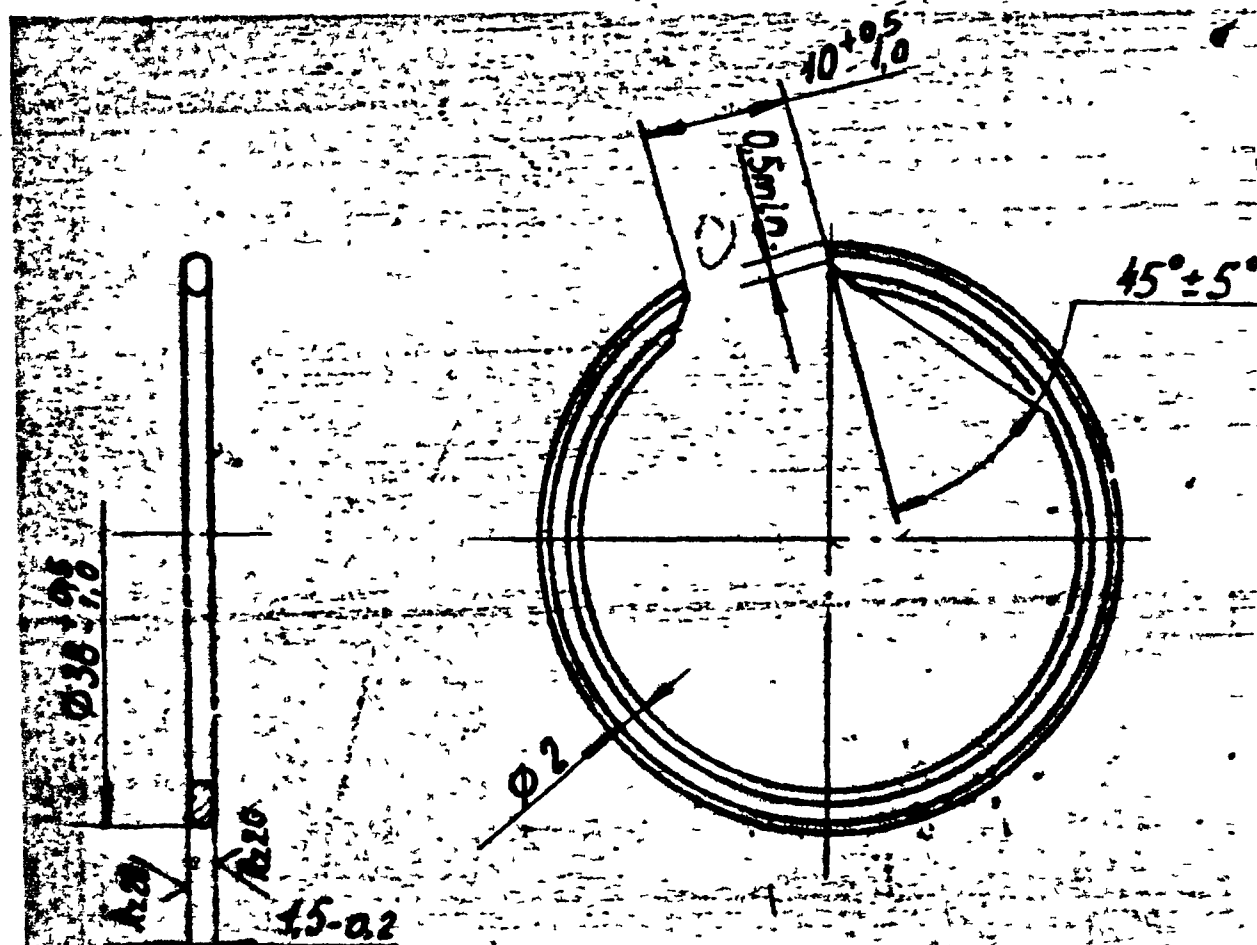
(a) CARBON STEEL COLD-DRAWN WIRE, SECOND CATEGORY, (II),
DIAMETER 2.0mm WITH NORMAL ACCURACY OF TOLERANCE $\pm \begin{matrix} 0.020 \\ 0.015 \end{matrix}$
TO EITHER OF GRADES KT-2 AND SK-7

(b) CHEMICAL COMPOSITION

CONTENTS %	GRADES	
	KT-2	SK-7
CARBON	0.86-0.91	0.68-0.76
MANGANESE	0.20-0.40	0.50-0.80
SILICON	0.17-0.37	0.17-0.37
SULPHUR (max)	0.020	0.030
PHOSPHORUS(max)	0.020	0.030
CHROMIUM	0.05	0.05
NICKEL	0.05	0.05
COPPER	0.10	0.04

MECHANICAL PROPERTIES

TENSILE STRENGTH— 180-205 Kg/mm²
NO OF BENDS (min)- 9
NO OF TWISTS-(min) 16



1. BLANK LENGTH (L) APPROXIMATELY 105 mm.

2. COATING: CHEMICALLY OXIDIZED, OILED.

PLOT SAMPLE SHOULD BE APPROVED BY A F S P BEFORE
BULK PRODUCTION

EST WT TO BE STAMPED OR MARKED WHERE
0.002 Kg INDICATED THUS $\frac{0.002}{1}$ LETTERS!

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS
OTHER USE STATED MACHINED CORNERS TO HAVE R OUT SIDE
SIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

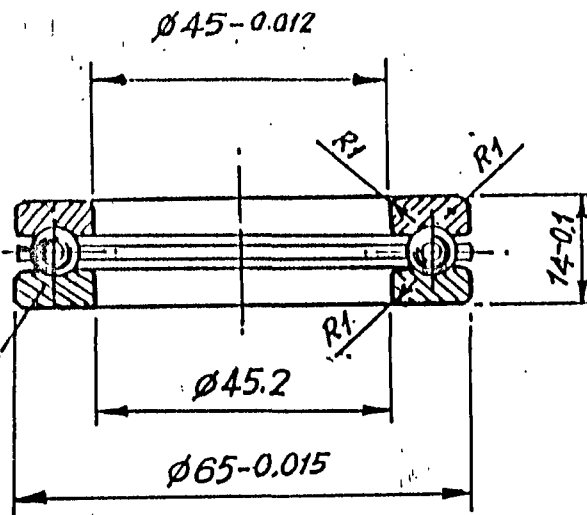
DRN	9 Nov 87	MATERIAL - WIRE- II-2	USED ON: CB 315 664 2
CHK	18 March	GOST 9389-75	Cb 20-15-664-1
TCD	17 March	CONTROL RATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
APPD	17 March		
DATE	4-5-87		
SCALE	2.1		
DIMENSIONS IN mm			
TOLERANCE ON DIMNS			
UNLESS OTHERWISE			
STATED IS 2100-69			
ALL THREADS TO			
CONFORM TO			
DIS CAT NUMBER			
DRAWING NUMBER			315-644

A6

DRAWING NUMBER

315-646-1

IT IS PERMITTED TO SUPPLY,
BEARINGS WITHOUT ONE RING
WITH INTERNAL DIAMETER
45.2-NO 308109 AS PER GOST
6874-75 AND ETY 500-65(A)



DRAWING INDIANISED
BASED ON ISSUE 1

KVD NO 63493



EXPLANATORY NOTE:

MATERIAL QUOTED: NO 8109 GOST 6874-75 AND ETY 500

SINGLE DIRECTION THRUST BALL BEARING TO Specn. ETY 500

8109 = CODE OF BEARING .

INDIAN EQUIVALENT:

FAG }
SKF } 51109

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

EST. WT. (0.095 WITH 1 YOKE) 0.15 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.

MATERIAL:- NO 8109 GOST 6874-75 & ETY 500-65(A)	USED ON CB 315.664.2
---	-----------------------------

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)
AVADI.

	TITLE BEARING
--	-------------------------

D S CAT NUMBER	DRAWING NUMBER 315-646-1
----------------	------------------------------------

A	7-12-87	AUTHY BK 83-297
ISSUE	DATE	NATURE OF AMENDMENTS
DRN	<i>[Signature]</i>	SCALE:- 1:1 DIMENSIONS IN mm
CHD	<i>[Signature]</i>	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS 2102-62
TCD	<i>[Signature]</i>	ALL THREADS CONFORM TO
APPD	<i>[Signature]</i>	
DATE	8-5-86	

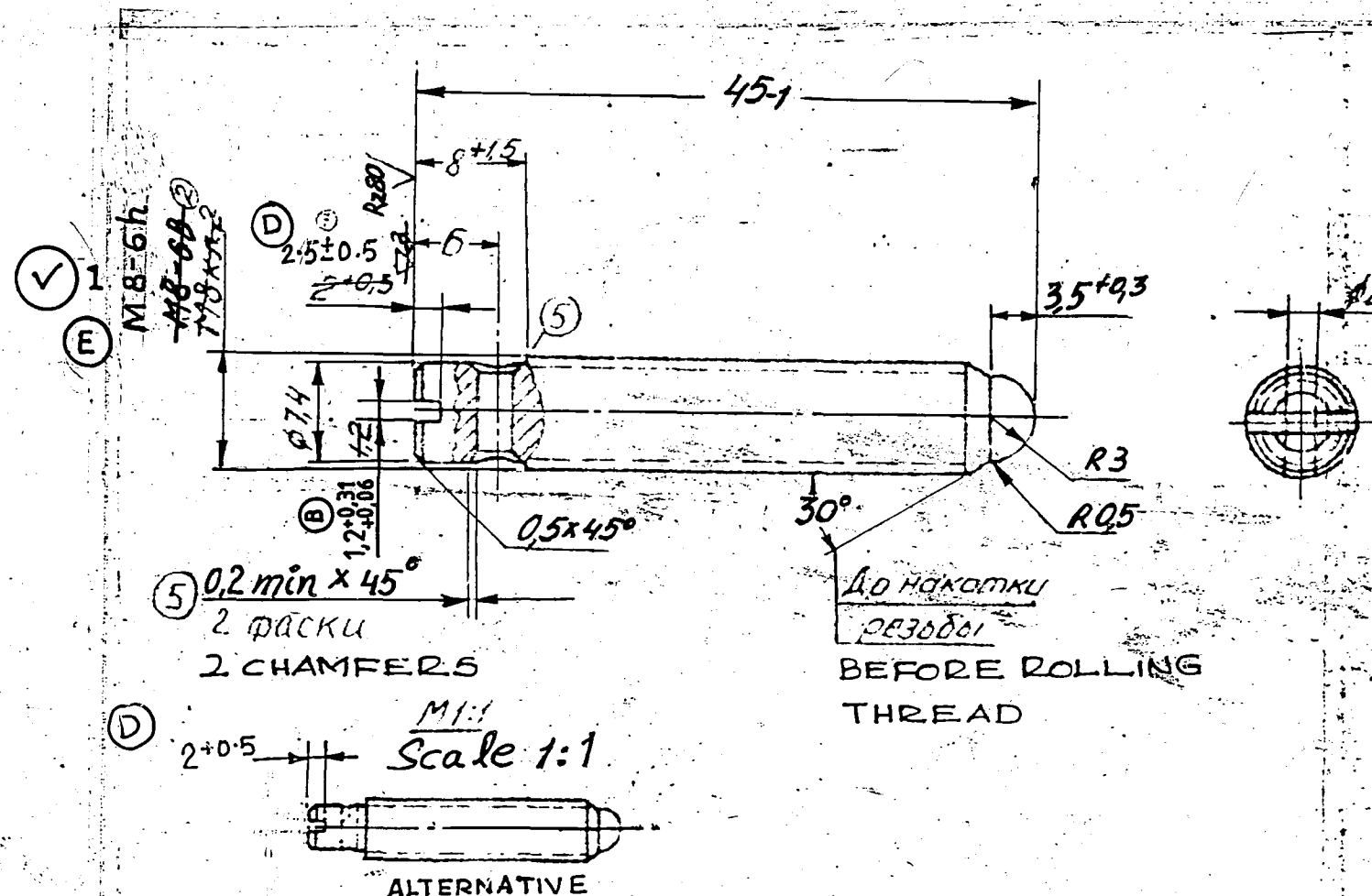
USED ON

CB 327-00-45

ITEM LIST CREATED BASED ON RUSSIAN ORIGINAL ISSU (B.K. 48)

ITEM NO	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	NO OFF	REMARKS
	CB 315-663-21 & ITEM LIST		REGULATOR BODY ASSY		
1	CB 315-601-9 & ITEM LIST		REGULATOR BODY	1	
2	CB 3315-602-1 & ITEM LIST		REGULATOR SPRING FIRST	1	
3	CB 3315-603-2 & ITEM LIST		REGULATOR SPRING SECOND	1	
4	CB 315-608-1 & ITEM LIST		ROLLER WITH LEVER	1	TU
5	CB 315-661-1 & ITEM LIST		SPRING LEVER	1	
6	CB 315-668 & ITEM LIST		SEALING RING	1	
7	CB 327-18-1A & ITEM LIST		REINFORCED SEALING RING	1	
8	315-49		LOCK SCREW	2	TU
9	315-64		SEMI CIRCULAR <small>H3X13 GOST- HKM 4092</small>	1	
10	315-639		WASHER	1	

ISSUE DATE	NATURE OF AMENDMENTS	ISSUE DATE	NATURE OF AMENDMENTS
DRN	<i>G. Naryanov</i>	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI TITLE:- REGULATOR BODY ASSY	
CHD	<i>Star. B. Naryanov</i>		
TCD	<i>Naraini pers.</i>		
APPD	<i>P.S.</i>		
DATE	3-3-88	SHEET 1 OF 2	ITEM LIST FOR CB 315-663-21



1. Группа контроля III по ТТ-11
2. Цинковать на глубину 0,10-0,25 мм, HRC ≥ 40, проверить прорезанным капиллярным
3. Размеры без допусков выполнять по 7 классу точности ОСТ 1010.
4. Технические требования на резьбу выполнять по нормам 82021-00.
5. При прорезке паза под отвертку допускается оставление радиуса фрезы R ≥ 25 мм.
6. Цинковать и пассивировать по УИА-154. Толщина слоя покрытия 0,003-0,006 мм. На внутренних поверхностях допускается отсутствие цинка и покрытия.
7. Размеры контролировать до покрытия.
8. Покрытие из 3-х пр по УИА-154, УИА-483-82.
9. В техническом исполнении покрытие КД 9 хр по УИА-104 с удалением водородной хрупкости.

1. Inspection group III, TT-11
2. Casehardening by cyaniding to a depth of 0.10 to 0.25 mm. HRC ≥ 40; to be checked with hardness-test file.
3. Dimensions with unspecified tolerances should be made as per accuracy class 7 OST 1010.
4. Technical requirements for thread as per standard 82021-00
5. During cutting the slot for screwdriver, radius R ≥ 25 mm. from cutter is allowed.
6. There may be no coating on the internal surfaces. Coating Zn-3Cr should be as per instruction УИА-483-82. Coating: Cd 9 chromating as per instructions УИА-104 with elimination of hydrogen embrittlement.
7. Dimensions are to be calibrated before coating.

EXPLANATORY NOTE :-

8. MATERIAL QUOTED : STEEL 10 GOST 1050-74.
 STEEL 10 = GRADE OF STEEL.

a) CHEMICAL COMPOSITION :

CARBON = 0.07 - 0.14
 SILICON = 0.17 - 0.37
 MANGANESE = 0.35 - 0.65
 CHROMIUM = 0.15 (max)
 PHOSPHORUS = 0.035 (max)
 SULPHUR = 0.040 (max)
 COPPER = 0.25 (max)
 NICKEL = 0.25 (max)

b) MECHANICAL PROPERTIES :

TENSILE STRENGTH Kgf/mm² (min) = 34
 YIELD POINT Kgf/mm² (min) = 21
 % ELONGATION = 31 (min)
 % REDUCTION IN AREA = 55 (min)

9. REPAIR SIZE DIMENSION ARE ADDED BASED ON LETTER NO: 22347/DH/QAS/ED DT 27 MAR 95, WHERE INDICATED THUS (R) AS FOLLOWS.

SI.No	R	REMARKS
1	M 10x6 h	ALL OTHER CONDITIONS AS PER STD DRG. MARK REPAIR SIZE

KVD No. 78511

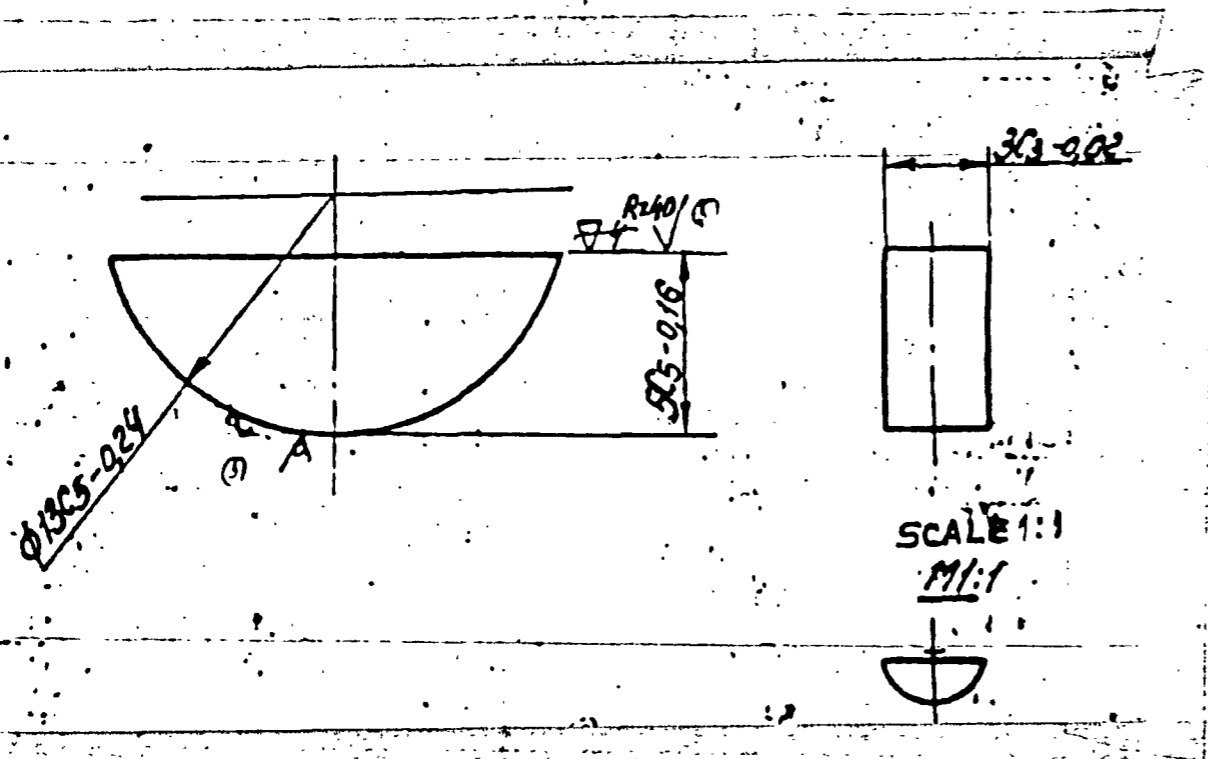
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)
0.012 Kg	

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

DRN	MATERIAL :-	USED ON:-
CHD	STEEL 10	CB 315 663 21
TCO	GOST 1050-74	CB 20-15-663-4
APPD	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
DATE	TITLE:-	
SCALE - 2:1	LIMITER SCREW	
DIMENSIONS IN mm.	D S CAT NUMBER	DRAWING NUMBER
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.		315 49
ALL THREADS CONFORM TO		
ISSUE	DATE	NATURE OF AMENDMENTS

DRAWING NUMBER
315-64



1. INSPECTION GROUP IV TT-11.
2. ~~HRC 26-30~~ HRC 26-32
3. COATING : COATING OXIDIZING OIL FINISHING.
4. SHARP EDGES ARE NOT ALLOWED.

EXPLANATORY NOTE :-

MATERIAL QUOTED : 13-4 GOST 7417-75
45 GOST 1051-73

SIZED COLD DRAWN STEEL

13 = DIAMETER IN mm.

4 = CLASS OF ACCURACY (-0.120)

45 = SIZED STEEL GRADE AS PER GOST 1051-73

a) CHEMICAL COMPOSITION : (AS PER GOST 1050-74.)

CARBON = 0.42 - 0.50

SILICON = 0.17 - 0.37

MANGANESE = 0.50 - 0.80

CHROMIUM = 0.25 (max)

SULPHUR = 0.040 (max)

PHOSPHORUS = 0.035 (max)

COPPER = 0.25 (max)

NICKEL = 0.25 (max)

b) MECHANICAL PROPERTIES :

TENSILE STRENGTH Kgf/mm² = 61 (min)

YIELD POINT Kgf/mm² = 36 (min)

ELONGATION % = 16 (min)

REDUCTION IN AREA % = 40 (min)

KVD NO 78512 & 63484

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

EST. WT. 0.001 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # 1 LETTERS)

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

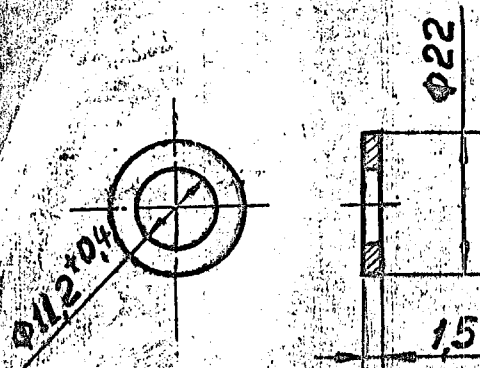
DRN		MATERIAL:-	USED ON: C6 20-15-663-4
CHD		ROUND BAR 13-4 GOST 7417-75	C6 315-663-21
TCD		45 GOST 1051-73	
APPO		CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES)	
DATE	15/5-87	AVADI	
SCALE:-	5:1	TITLE	
DIMENSIONS IN mm		SEMI CIRCULAR KEY 3X5	
TOLERANCE ON DIMNS		D S CAT NUMBER	
UNLESS OTHERWISE STATED IS:2102-69		DRAWING NUMBER	
ALL THREADS TO CONFORM TO		315-64	
A	23-11-87	NATURE OF AMENDMENTS	
ISSUE DATE			

A-6
SIZE A3

315-639

2

315-639



1. ~~Требования контроля У по ТУ Н 0~~
2. Требования, предъявляемые к штамповке, по нормам 82050-16.
3. Непопскость не более 0,2мм.
4. Завуенцы и острые кромки не допускаются.
5. Покрытие Ц.13-25. Хр по ИУИ-154.

УИ-483-82

1. REQUIREMENTS FOR STAMPING AS PER STANDARD 82050-16.

2. NON FLATNESS SHOULD NOT EXCEED 0.2MM.

3. ROUNDS AND SHARP EDGES ARE NOT ALLOWED.

5. COATING: ZN 13-25 CHROMATIZING AS PER INSTRUCTIONS, УИ-483-82

A-6

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS	
		0.003 Kg	LETTERS)	
A. 15 2 89 AUTHY BK 63-126		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL:- 10-BH-2-0-1.5 GOST 503-71 81	USED ON:- СБ 315 663 21
DRN	SCALE - 1 : 1		CONTROLLER RATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD	DIMENSIONS IN mm.		TITLE:- WASHER	
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.		D S CAT NUMBER	
APPD	ALL THREADS CONFORM TO		DRAWING NUMBER	
DATE	03-5-86		315 639	

DRAWING NUMBER

315-639-1

EXPLANATORY NOTE:-

MATERIAL QUOTED : 10-BH-2-HO-1.5 GOST 503 - 71. STEEL STRIP

ALT. MATERIAL QUOTED : STEEL A 1.5 GOST 19904-74
II - BГ - 08KП GOST 9045-80.

LOW CARBON STEEL, COLD ROLLED STRIPS.

- 10 = GRADE OF MATERIAL TO GOST 1050-74.
- BH = HIGHLY COLD WORKED.
- 2 = SURFACE QUALITY GROUP TO GOST 503 - 71.
- HO = UN-TRIMMED EDGES.
- 1.5 = THICKNESS IN mm.
- A = HIGH ACCURACY OF ROLLING TO GOST 19904-74.
- II = HIGH SURFACE FINISH TO GOST 9045-80.
- BГ = EXTREMELY DEEP DRAWN.
- 08KП = GRADE OF MATERIAL TO GOST 9045-80.

a) CHEMICAL COMPOSITION % AS PER GOST 1050-74.

GRADE	C	Si	Mn	Cr		P		S		Cu	Ni
				M	A	X	I	M	U		
10	0.07 - 0.14	0.17 - 0.37	0.35 - 0.65	0.15		0.035		0.040		0.25	0.25

b) MECHANICAL PROPERTIES.

GRADE	ULTIMATE TENSILE STRENGTH Kg f/m ² (Min)	YIELD POINT Kgf/mm ² (Min)	PERCENTAGE ELONGATION % (Min)	HARDNESS B H N (Max)
10	35	21	24	137

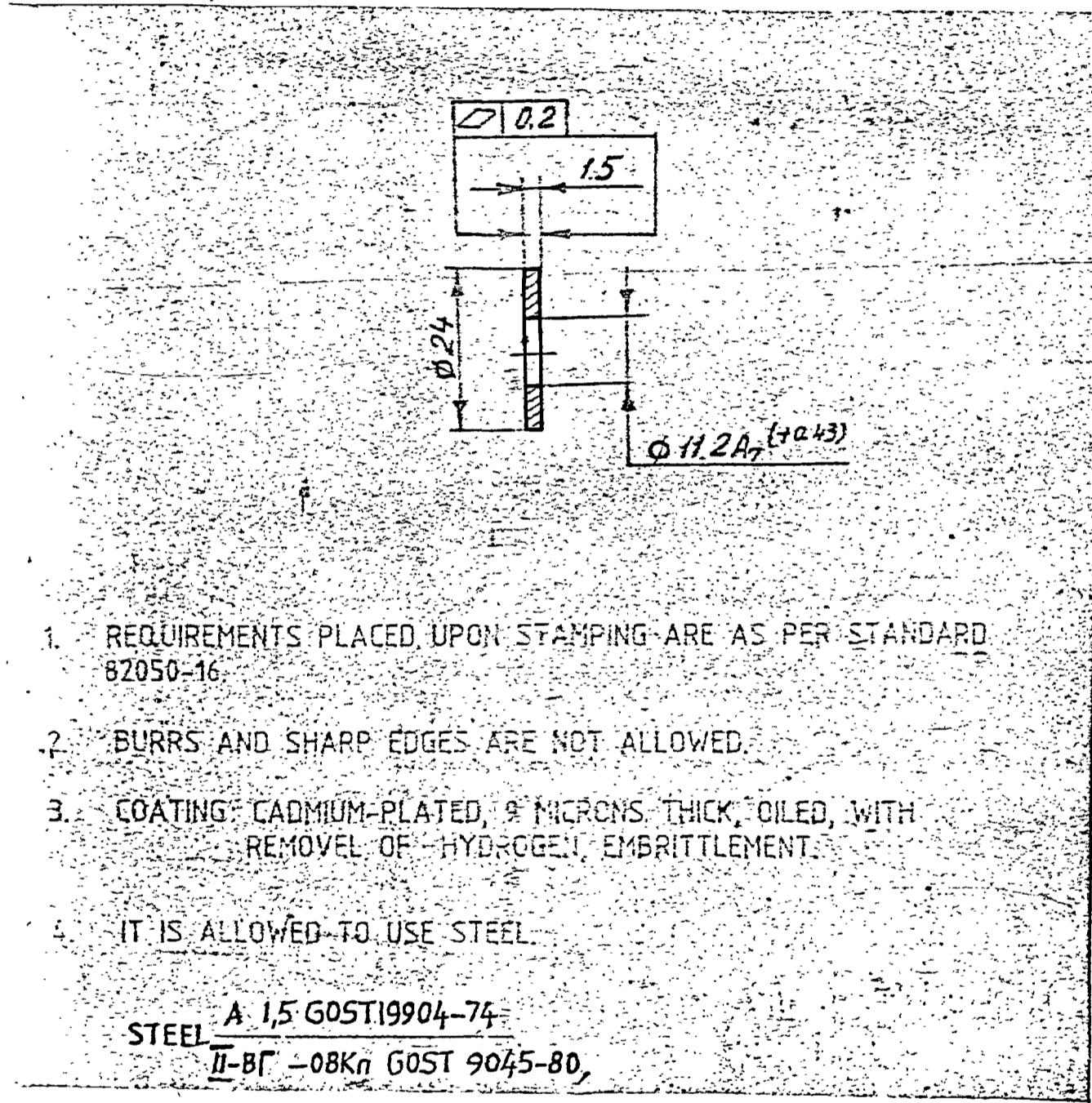
c) CHEMICAL COMPOSITION % AS PER GOST 9045 - 80

GRADE	C (Max)	Mn	S	P	Si		Cr	Ni	Cu	ARSENIC	NITROGEN
					M	A					
08KП	0.10	0.20 - 0.40	0.030	0.025	0.03		0.10	0.10	0.15	0.08	0.008

d) MECHANICAL PROPERTIES

GRADE	ULTIMATE TENSILE STRENGTH Kgf / mm ²	RELATIVE ELONGATION % (Min)
08KП	26 - 37	28

Ⓐ EQUIVALENT MATERIAL
Gr. 0 IS:513-1994



1. REQUIREMENTS PLACED UPON STAMPING ARE AS PER STANDARD 82050-16.
2. BURRS AND SHARP EDGES ARE NOT ALLOWED.
3. COATING: CADMIUM-PLATED, 9 MICRONS THICK, OILED, WITH REMOVAL OF HYDROGEN EMBRITTLEMENT.
4. IT IS ALLOWED TO USE STEEL

STEEL A 1.5 GOST 19904-74
II-BГ - 08KП GOST 9045-80,

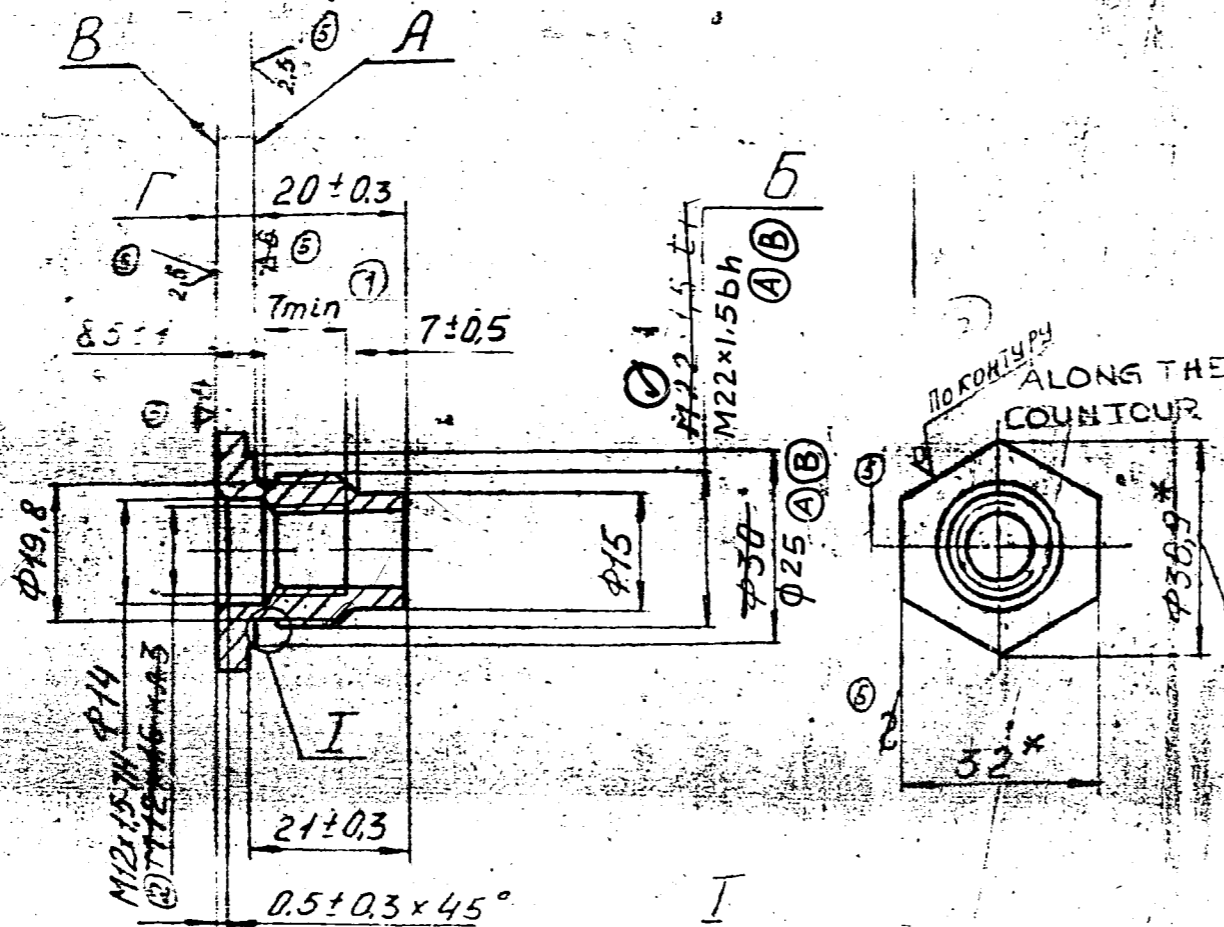
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. WT. 0.004 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS # (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	W. J. ...	MATERIAL :-	USED ON :-
CHD	...	STRIP 10-BH-2-HO-1.5	CE 20-39-00-3
TD	N. D. ...	GOST 503-71	CE 20-15-663-6
APPD	...	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	24-6-86	A V A D I	
SCALE	-1:1	TITLE	
DIMENSIONS IN mm		WASHER 11	
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 202-69		D S CAT NUMBER	
ISSUE	A	DATE	1-7-10
NATURE OF AMENDMENTS		DRAWING NUMBER	
		315-639-1	

DRAWING NUMBER

315 682 1



NO	DIMENSION
N	розмер
n/n	Г
1	5.9-0.2
2	5.7-0.2
3	5.5-0.2
4	5.3-0.2

M5:1
SCALE 5:1
2.5±0.5



2. Thread surface should be clean, free from scores, burrs, stripped thread, dents and corrosion marks.
3. Unspecified limit deviations of dimensions of female components as per A7 and of male components as per B7.
4. Run-out of face A relative to thread 5 should not exceed 0.05 mm. (MMC)
5. Non-parallelism of faces A and B should not exceed 0.1 0.1 mm.
6. Sharp edges are not allowed.
7. Coating: Zn 3 chromating as per instructions 493-82
8. There may be no coating on the internal surface.
9. During machining of face A, cutting in at dia-19.8 mm upto 0.3 mm is allowed.
10. Dimension A may be obtained with dia 36 mm.
11. *Dimensions for reference.

12. REPAIR SIZE DIMENSION ARE ADDED BASED ON LETTER NO:
 (B) 82846/0H/QA9/ED DT 27 MAR '95 AS FOLLOWS.

REPAIR SIZE DIMENSION ARE ADDED WHERE INDICATED THUS:

SI.No	R	REMARKS
1	M24 x 1.5 t1	ALL OTHER CONDITIONS AS PER STD DRG. MARK REPAIR SIZE

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

EST. MASS 0.059 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 mm.	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	MATERIAL - HEXAGON BAR	USED ON:-
				03.5.86	- 1:1			32-6 GOST 8560-78	CB 315 663 21
					CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI				
					TITLE:- BUSH				
					D S CAT NUMBER		DRAWING NUMBER		
							315 682 1		
ISSUE	DATE	NATURE OF AMENDMENTS							
B	5-9-95	REPAIR SIZE ADDED							
A	8-2-94	AUTHY. NOTN. No. BK77-245							

A-6
SIZE A3

(B. JAYAVELU)
JTO (D)

DRAWING NUMBER
351 - 02

Rz40/ (✓)

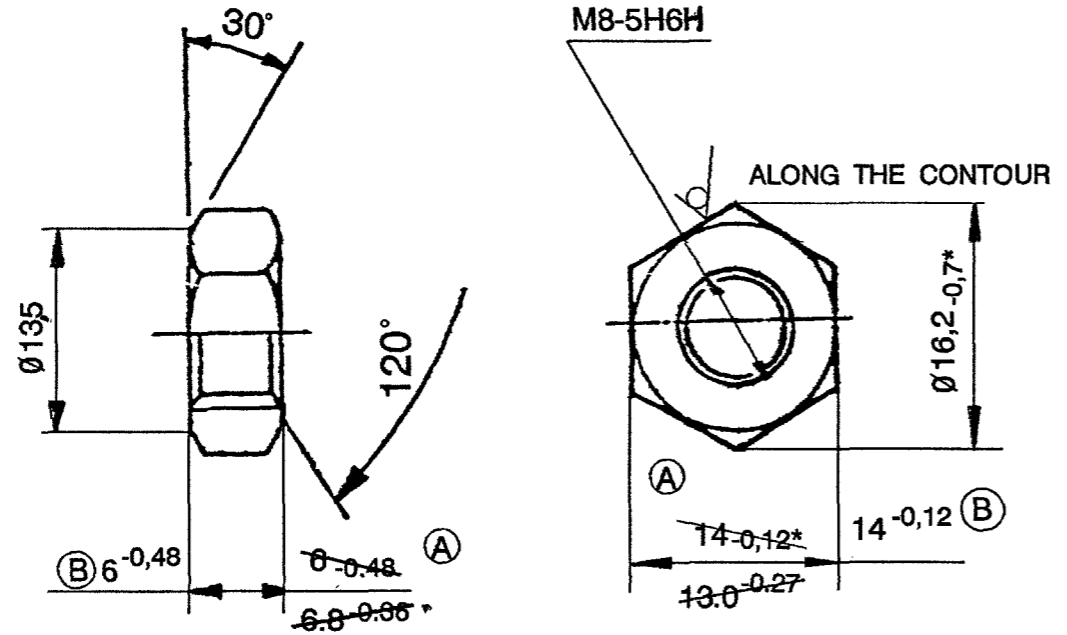
EXPLANATORY NOTE :

7. MATERIAL QUOTED :- HEXAGON BAR 14-4 GOST 8560-78
45-5 GOST 1051-73

⊙ BRIGHT STEEL OF HEXAGONAL CROSS SECTION 14mm ACROSS FLAT, ACCURACY CLASS - 4 TO GOST 8560-78. AND MANUFACTURED FROM COLD DRAWN SIZED STEEL OF GROUP B SURFACE QUALITY TO GOST 1051-73.
ALTERNATE MATERIAL QUOTED - STEEL GRADE 40 & 50 TO GOST 1050-74.

CHEMICAL COMPOSITION :

STEEL GRADE	C O N T E N T O F E L E M E N T S %							
	C	Si	Mn	Cr(max)	S	P	Ni	Cu
40	0.37-0.45	0.17-0.37	0.50-0.80	0.25	M A X I M U M			
					0.040	0.035	0.10	0.15
45	0.42-0.50	0.17-0.37	0.50-0.80	0.25	0.040	0.035	0.10	0.15
50	0.47-0.55	0.17-0.37	0.50-0.80	0.25	0.040	0.035	0.10	0.15



1. ROLLED STOCK OF GROUP B CLASS 4 GOST 1051-73 MAY BE USED TO ENSURE HIGH QUALITY OF COATING, IT IS ALLOWED TO ELIMINATE SURFACE DEFECTS OF ROLLED STOCK WITH DECREASE OF DIMENSIONS AS PER ACCURACY CLASS 5.
2. ALTERNATE MATERIAL :- STEEL GRADES 40 AND 50 GOST 1050 - 74.
3. THE REST OF THE TECHNICAL REQUIREMENTS AS PER STANDARD 82052 - 00.
5. COATING :- Cd 3, CHROMATIZING AS PER UUL-104 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
6. *DIMENSIONS FOR REFERENCE.

MECHANICAL PROPERTIES :

STEEL GRADE	YIELD POINT Kg/mm ² (min)	ULTIMATE TENSILE STRENGTH Kg/mm ² (min)	PERCENTAGE ELONGATION (min)	REDUCTION OF AREA % (min)	IMPACT STRENGTH Kgfm/cm ² (min)
40	34	58	19	45	6
45	36	61	16	40	5
50	38	64	14	40	4

⊙ Material: STEEL 709M40 (EN-19) TO BS-970 Pt-1-1983

- **
- ⊙ CQA(HV)5.06.606E
- ⊙ CQA(HV)5.06.610E
- ⊙ Cb 3312-90-9

Eb 20-01-00-8, Cb 20-06-12-6, Cb 20-06-13-6, Cb 20-09-07, Cb 20-19-00-1, Cb 20-11-00-6, Cb 20-12-00-13, Cb 20-13-01-8, Cb 20-20-00-10, Cb 20-22-00-7, Cb 20-08-00-7, Cb 3301-00-37, Cb 306-01-20, Cb 306-02-20, Cb 306-03-3, Cb 306-04-2, Cb 321-04-4, Cb 447-01-1, Cb 421-04-3, Cb 421-18-1, Cb 3301-00-44, Cb 3301-15-44, Cb 306-01-36, Cb 306-02-36, Cb 3308-15-2, Cb 3312-90-14, Cb 419-00-20, Cb 3320-00-43, Cb 315-663-33, Cb 3334-02-10, Cb 3336-00-11, Cb 337-100, Cb 3342-00-21.

USED ON:- **
 ⊙ Cb 406-12-44
 ⊙ Cb 406-13-44
 ⊙ Cb 20-27-00-4
 ⊙ Cb 20-15-663-4
 ⊙ Cb 3342-00-8cb
 ⊙ Cb334-73-1
 ⊙ Cb3334-02-3
 ⊙ Cb327-145-10
 ⊙ Cb327-145-15
 ⊙ Cb315-663-21

ISSUE	DATE	NATURE OF AMENDMENTS	DRN	Sd/=
G	04.01.22	USED ON NUMBER ADDED.	CHD	Sd/=
F	04.01.20	USED ON NUMBER DELETED.	TCD	Sd/=
E	15.7.15	Pt. 11, 7 th Alt. Comm. Meeting Dt. 11.4.12	APPD	Sd/=
D	18.5.09	Authy: Third Alt. Comm. Minutes Point: 5 Dated 27-02-2009.	DATE	08-05-86
C	25.8.08	USED ON NUMBER ADDED	SCALE:-	2:1
B	24-12-07	ALT. COMMITTEE MEETING MINUTES. POINT No. 2.18 Dt. 18-12-2007.	DIMENSIONS IN mm	
A	15-03-04	AUTHY. Lt. No.110094/IND-III/577, Dt. 19-02-04.	TOLERANCE ON DIMNS	UNLESS OTHERWISE STATED IS: 2102 - 69

MATERIAL :-
 ⊙ 14-4 GOST 8560-78
 ⊙ 45-5 GOST 1051-73

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)
 AVADI

TITLE :-
NUT M8

D S CAT NUMBER
 DRAWING NUMBER
351 - 02

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

EST. WT. 0,0055 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.

COMMON TO V-92S2 & UTD-20 ENGINES
 DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE -N/L

SIZE A3

DRAWING NUMBER
353-04-1

EXPLANATORY NOTE :

Rz60
✓(✓)

7. REFERENCE MATERIAL QUOTED:

COLD ROLLED LOW CARBON STEEL STRIP HIGHLY COLD WORKED 'BH' CONDITION. SURFACE QUALITY '2' 1mm THICK TO GOST 503-81 AND MANUFACTURED IN ACCORDANCE WITH QUALITY CARBON STRUCTURAL STEEL GRADE 10 AND REFERENCE NOTE 5. ON ALTERNATE MATERIAL STEEL GRADES 15 AND 08nc TO GOST 1050-74.

a) CHEMICAL COMPOSITION:

GRADE OF STEEL	CONTENT OF ELEMENTS %						REMARKS
	C	Si	Mn	Cr	S	P	
10	0.07-0.14	0.17-0.37	0.35-0.65	0.15	0.040	0.035	Ref. Matl
15	0.12-0.19	0.17-0.37	0.35-0.65	0.25	0.040	0.035	Alt. Matl
08nc	0.05-0.11	0.05-0.17	0.35-0.65	0.10	0.040	0.035	Alt. Matl

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

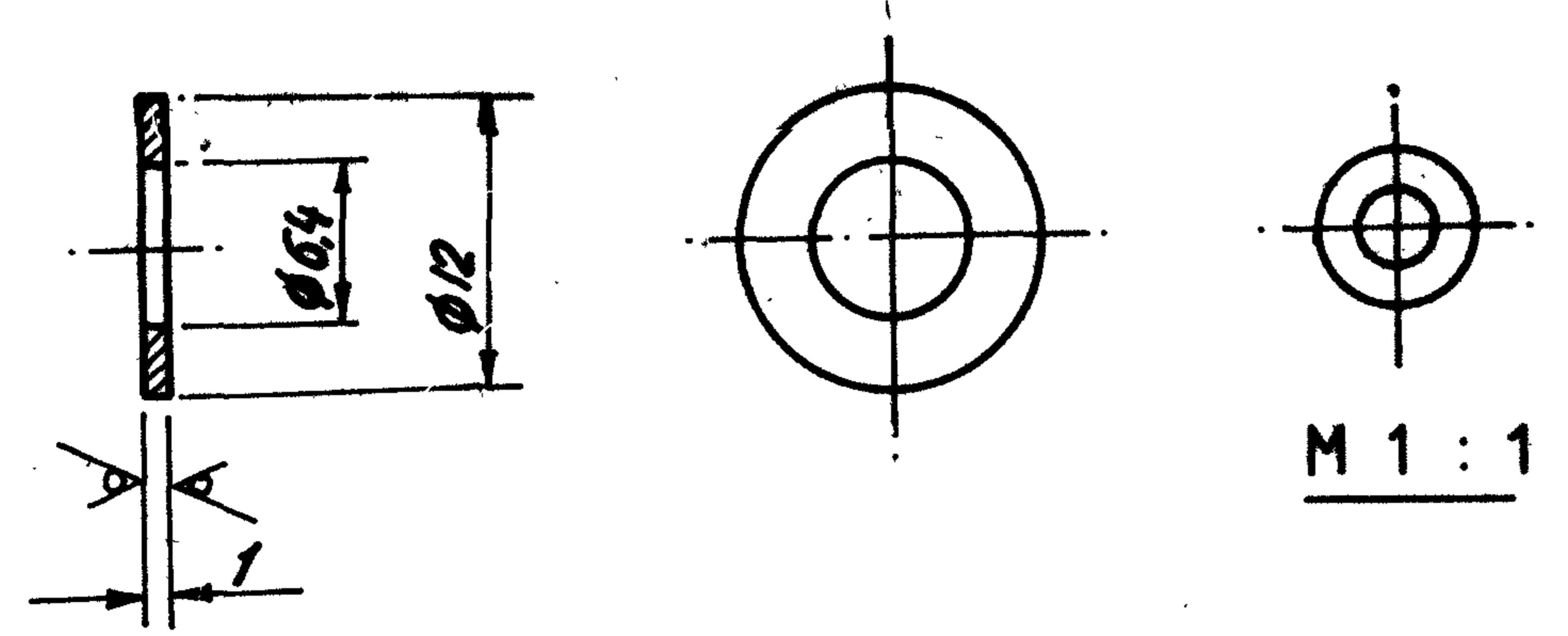
b) MECHANICAL PROPERTIES AS PER GOST 503-81

GRADE OF STEEL	CONDITION OF MATERIAL	ULTIMATE TENSILE STRENGTH σ_{t2} /mm ²	ELONGATION
10	BH	55 MIN	—

c) MECHANICAL PROPERTIES AS PER GOST 16523-70 FOR ALTERNATE MATERIAL QUOTED.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH σ_{t2} /mm ²	ELONGATION %
15	36 - 47	24
08nc	28 - 40	25

- cb 20-01-00-8
- cb 20-11-05-2
- cb 20-06-00-4
- cb Y 36-11-07-01
- cb 3338-00-16
- cb 3338-401-10
- cb 3338-004-7
- COA(HV)5.06.001E(B)
- COA(HV)5.06.607E(C)
- cb 411-00-56 (F)
- cb 3308-00-23
- cb 3308-00-17 (E)
- cb 327-00-73
- cb 327-00-47-01 (D)



1. DIMENSIONS WITH UNSPECIFIED TOLERANCES - AS PER STANDARD 82050-16.
2. THE COMPONENT SHOULD BE STRAIGHTENED AFTER STAMPING.
3. BURRS ARE NOT ALLOWED.
4. COATING: CADMIUM 9, CHROMATIZING AS PER ЦУЛ-104 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
5. ALTERNATE MATERIAL: STEEL GRADES 15, 08nc GOST 1050-74.
6. REQUIRED FINISHING OF SURFACES BEING STAMPED SHOULD BE ENSURED BY TOOL.

(A) EQUIVALENT MATERIAL
Gr. 0 IS:513-1994

COMMON TO V46-6 & V92S2

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

EST WT 0.00063 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

ISSUE	DATE	NATURE OF AMENDMENTS
F	23.11.21	USED ON NUMBER ADDED.
E	16.08.21	USED ON NUMBER ADDED.
D	17.7.19	USED ON NUMBER ADDED.
C	15-7-15	Pt. 11 of 7th Alt. Comm. Meeting Dt. 11-4-12
B	18-3-15	Pt. 11 of 7th Alt. Comm. Meeting Dt. 11-4-12
A	19-5-10	4 th Alt. Comm. Mt. Minutes Pt. No. 2 Dt. 26.10.09

DRN
CHD
TCD
APPD
DATE 25-3-21
SCALE: 2 : 1
DIMENSIONS IN mm
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS : 2102-69
ALL THREADS TO CONFORM TO

MATERIAL: STRIP 10 - BH - 2 - 1 GOST 503-71

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI

TITLE: WASHER BRIGHT 6

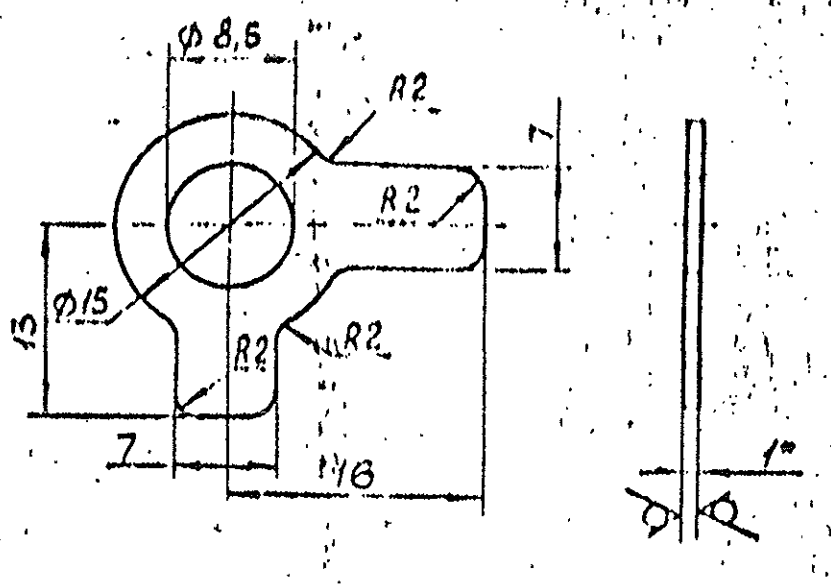
D'S CAT NUMBER DRAWING NUMBER 353 04 1

USED ON: cb 3342-100-3 cb 315-663-21 cb 411-00-48 cb 447-00-1

DRAWING NUMBER
353-16-1

EXPLANATORY NOTE :-

Rz80 ✓ ✓



5. MATERIAL QUOTED : STRIP 08ΠC-M-2-1 GOST 503-81.
COLD ROLLED LOW CARBON STEEL TYPE.
08ΠC = GRADE OF STEEL , M = CONDITION OF MATERIAL-SOFT.
2 = SECOND GROUP , -1 = THICKNESS IN mm.
- (a) CHEMICAL COMPOSITION : (AS PER GOST 1050-74)
C = 0.05 - 0.11 , SI = 0.06 - 0.17 , Mn = 0.35 - 0.60
Cr = 0.10 (max) , S = 0.040 (max) , P = 0.035 (max)
Cu = 0.25 (max) , Ni = 0.25 (max).
- (b) MECHANICAL PROPERTIES : (AS PER GOST 503-81)
ULTIMATE TENSILE STRENGTH Kgf/mm² = 32 - 45
% RELATIVE ELONGATION = 17 (min)

1. REQUIREMENTS FOR STAMPING ARE AS PER STANDARD 82050-16.
2. STRAIGHTEN AFTER STAMPING.
3. COATING : ZINC-PLATED, 9 MICRONS THICK, OILED WITH REMOVAL OF HYDROGEN EMBRITTLMENT.
4. * DIMENSION IS GIVEN FOR REFERENCE.

(B) EQUIVALENT MATERIAL
Gr. O. IS: 513-1994

- (A) **
Cb 3301-00-44 CB 3301-00-37
Cb 413-115-9 CB 315-663-21
Cb 315-663-33 CB 20-27-00-4
Cb 3336-00-11 CB 20-09-07
Cb 337-100 CB 20-11-00-6
Cb 413-115-6 CB 20-01-00-8.
CQA(HV)5.06.001E (C) Cb 20-08-00-7
Eb 20-12-00-13

KVD No. 63629 : COMMON TO V-92S2 & UTD-20 ENGINES

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

EST. WT. 0.0019 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.

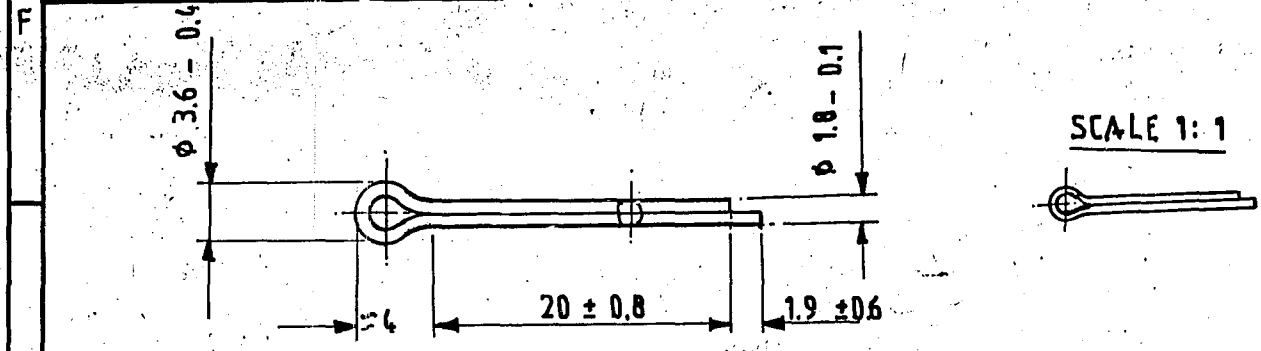
ISSUE	DATE	NATURE OF AMENDMENTS
D	17.07.17	USED ON NUMBER DELETED
C	18-03-15	Pl. 11 of 7th Alt. Comm. Meeting Dt. 11-4-12
B	10.03.10	4 th Alt. Comm. Mtg. Minutes Pt. No. 1 Dt. 26.10.09
A	28.8.08	USED ON NUMBER ADDED

DRN	24/09/90	MATERIAL :- STRIP 08ΠC-M-2-1 GOST 503-81	USED ON ** SEE ABOVE
CHD	9/2		
ICD	Chomh Pura	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES) AVADI	TITLE LOCK WASHER 8
APPD			
DATE	9-1-1990	D S CAT NUMBER	DRAWING NUMBER 353-16-1
SCALE	2:1		
DIMENSIONS IN mm TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS:2102-69			
ALL THREADS TO CONFORM TO			



SIZE A3

DRAWING NUMBER
354-12 SHT 10F 2



SCALE 1:1

1. TO BE ANNEALED.
2. COATING CADMIUM 3. CHROMATIZING AS PER Uyl-104 WITH ELIMINATION OF HYDROGEN ENBRITTEMENT.

(A) EQUIVALENT MATERIAL
IS: 549

- * *
- Cb 20-01-00-8
- Cb 20-15-663-4
- Cb 20-27-00-4
- Cb 20-34-12
- CQA(HV)5.06.001E (B)

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

			EST. WT 1000 PIECES 0.479 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	
B	18-03-15	Pt. 11 of 7th Alt. Comm. Meeting Dt. 11-4-12	MATERIAL —	USED ON Cb 334-73-1
A	8-7-10	4th ALT. COMM. Mtg. MINUTES POINT No. 3 DT. 26-10-09		Cb 315-662-3
				Cb 315-663-21
ISSUE	DATE	NATURE OF AMENDMENTS		** SEE ABOVE
DRN		SCALE 2 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD		DIMENSION IN mm		
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED		TITLE COTTER PIN 2 X 20
APPD		ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER 354-12 SHT 10F 2
DATE	1-5-82			
SIZE	A4			