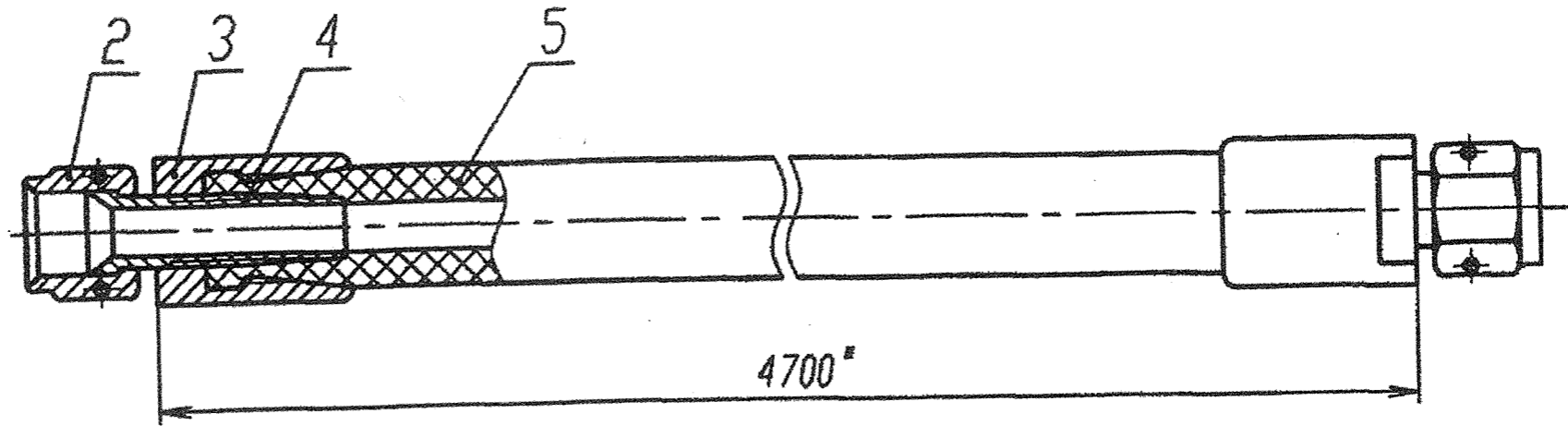


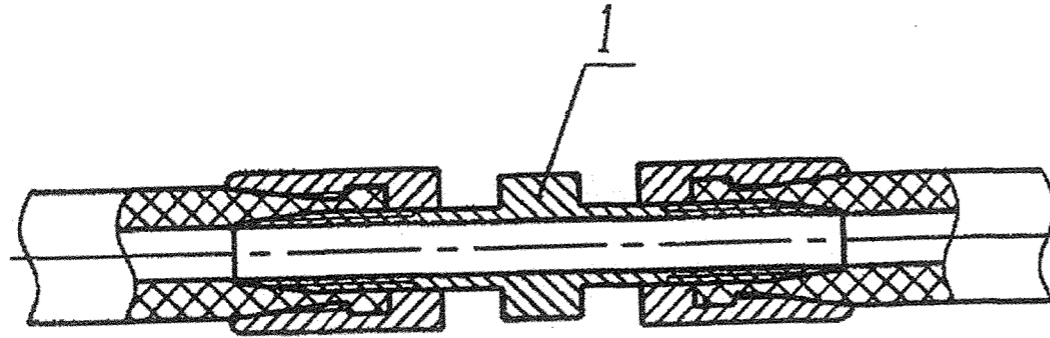
First use		Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks		
Reference No.						<u>Documents</u>				
		A3			AK-630 Sb 114-17 SB	Assembly drawing				
						<u>Components</u>				
		A3	1		AK-630 114-45	Nipple	1	max.2		
		A3	2		AK-630 114-32	Coupling	2			
		A3	3		AK-630 114-91	Coupling nut	2	max.6		
		A4	4		AK-630 114-85	Nipple	2			
						<u>Materials</u>				
			5			Hose 5U8-85	1	L=1750 mm +		
		Sign and Date						TU 38.005-1515-92		1750 mm +
								1200 mm		
Dupl. Inv. No.										
Alternate Inv. No.										
Sign and Date						AK-630 Sb 114-17				
		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								
						Hose				

First use

Reference No.



Option for expanding hoses
Вариант сращивания рукавов



1. * Reference dimension.
2. It is permissible to expand separate pieces of hoses with length 1750 mm+ 1750 mm+1200 mm (in specified sequence), by mounting additional components pos.1 and increasing no. of components pos.3.
3. Test for strength with air pressure 80 atm. Carry out testing by loading three times and keeping for 10 minutes.
Disturbance of strength and tightness of joints is not permissible.
4. Check quality of joints on one hose from the batch consisting not less than 5 nos. by cutting the hose to not more than 50 mm from side of hose L = 1750 mm, further use the shortened hose in article.
5. Mark Ш, Ч and stamp K on tag.

Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

					AK-630 Sb 114-17 SB			
Amend.	Sheet	Doc.No.	Sign	Date	Hose Assembly drawing	Type	Weight	Scale
Developed by						A	1.700	1:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by								

First use

Reference No.

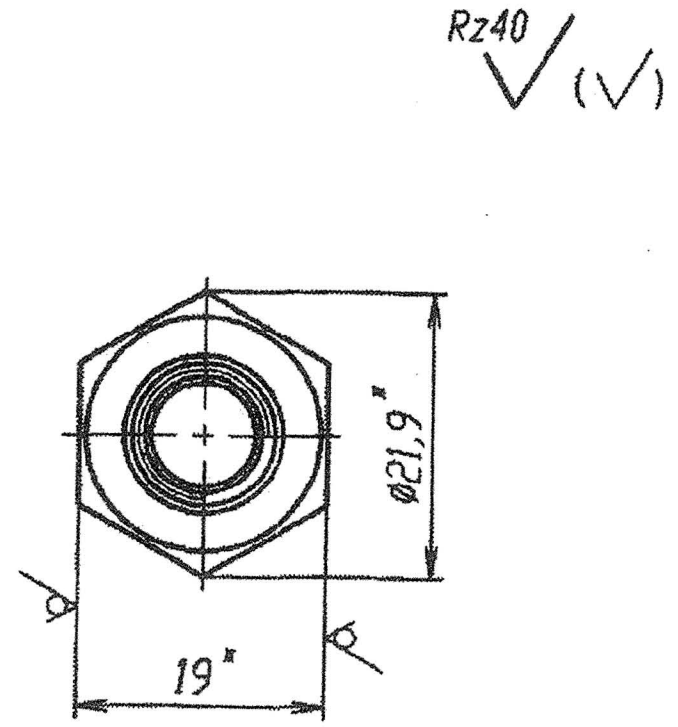
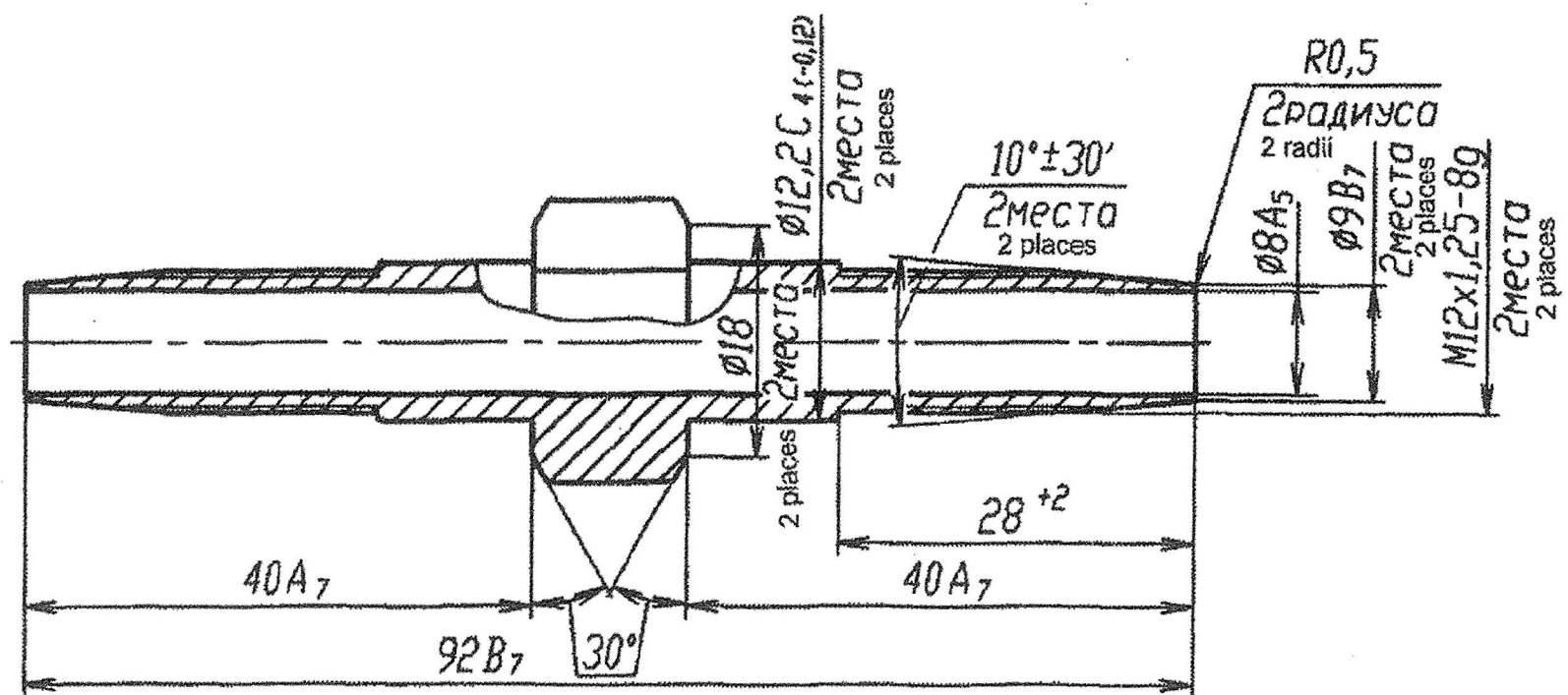
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



- 1.* Reference dimensions.
- 2. Inner angles R~0.4 mm.
- 3. Blunt sharp edges ~0.4 mm.
- 4. Coating Cd6. phos. Oil. It is permissible to avoid cadmium plating of inner surfaces.
- 5. Mark III, 4 and stamp K, on tag.

					AK-630 114-45			
Amend.	Sheet	Doc.No.	Sign	Date	Nipple	Type	Weight	Scale
Developed by						A	0.055	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D						Hexagon		
Approved by						19 - 5GOST8560 - 78 40Kh - T - VGOST1051 - 73		

First use

Reference No.

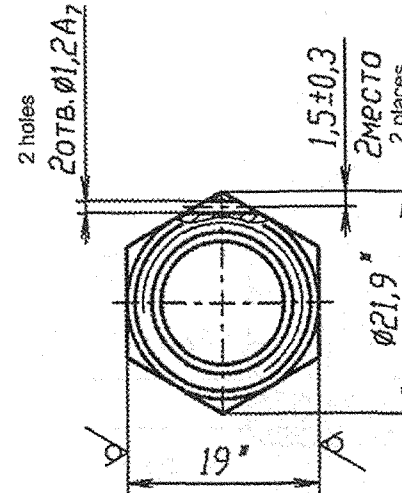
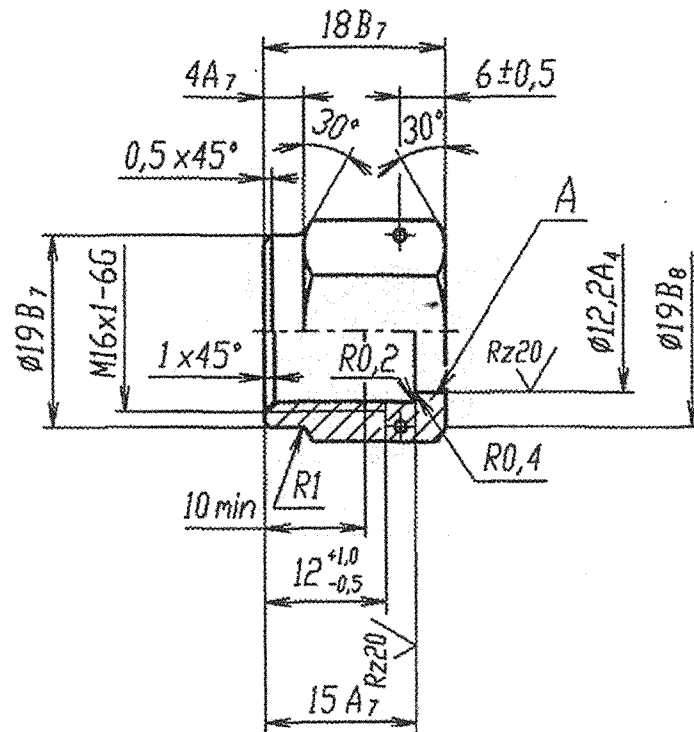
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz40 ✓ (✓)

1. Substitute material- hexagon $\frac{19 - 5GOST8560 - 78}{40GOST1051 - 73}$
2. 31..40.5 HRC_E. Check 3..5% , but not less than 3 nos. from batch.
- 3.* Reference dimensions.
4. Blunt sharp edges ~0.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.01 mm.
6. Mark Ш, Ч and stamp К, И on tag.

Designation	Coating
AK-630 114-32	Cd6.phos.
AK-630-01	Without coating

					AK-630 114-32				
Amend.	Sheet	Doc.No.	Sign	Date	Coupling nut		Type	Weight	Scale
							A	0.025	2:1
Developed by							Sheet	Sheets 1	
Checked by									
Head of Q.C.D									
Approved by					Hexagon $\frac{19 - 5GOST8560 - 78}{40Kh - T - 1GOST1051 - 73}$				

First use

Reference No.

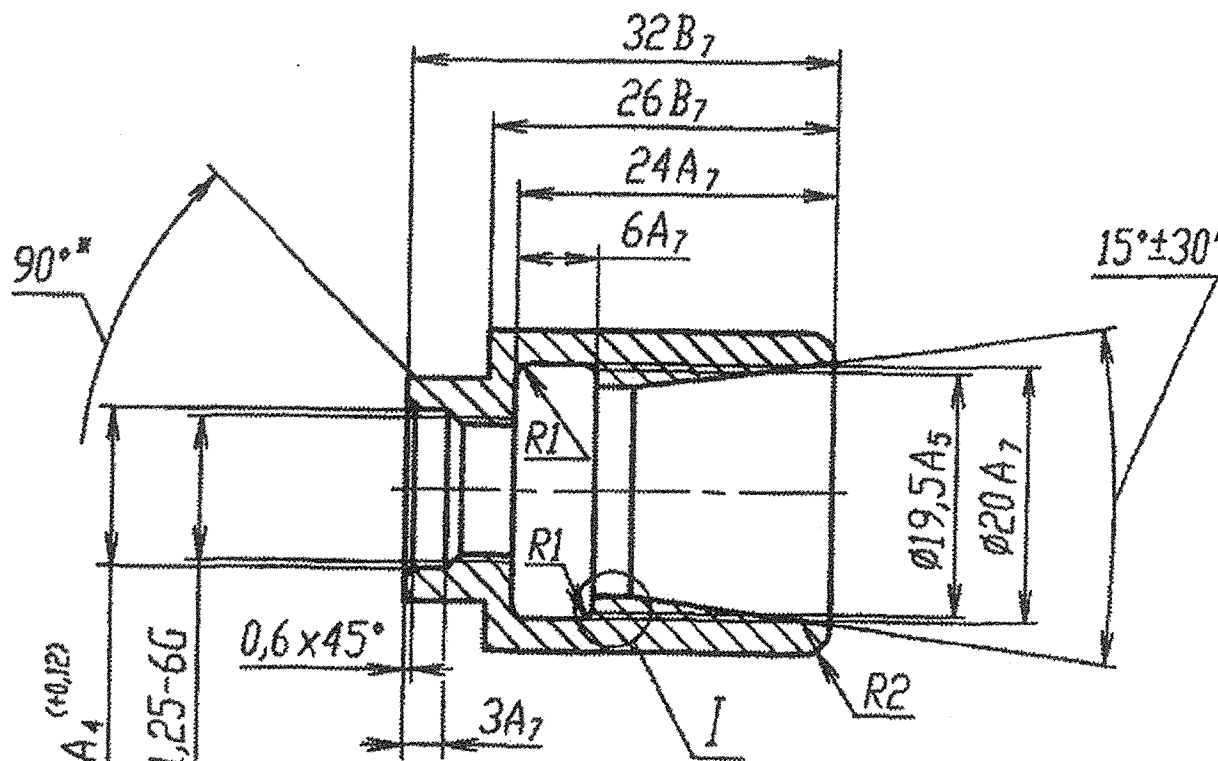
Sign and Date

Duplicate Inv. No

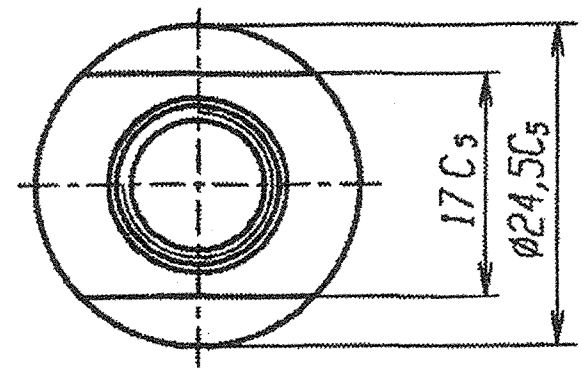
Alternate Inv. No

Sign and Date

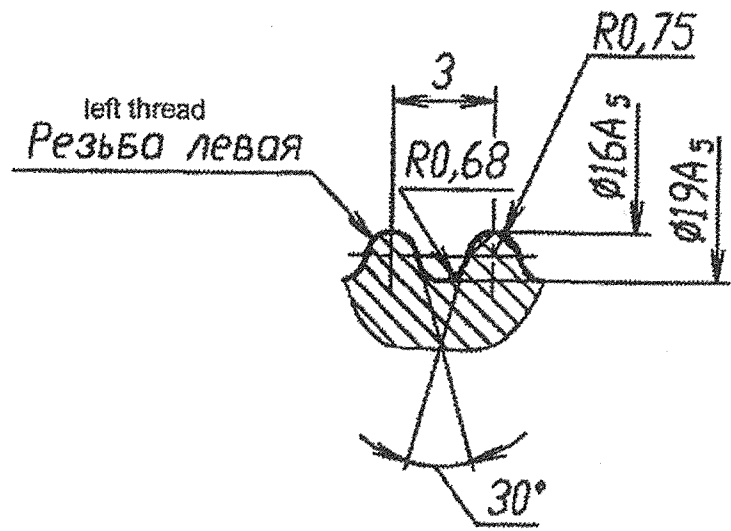
Orig. inv. no.



Rz40
✓ (✓)



I
M(5:1)



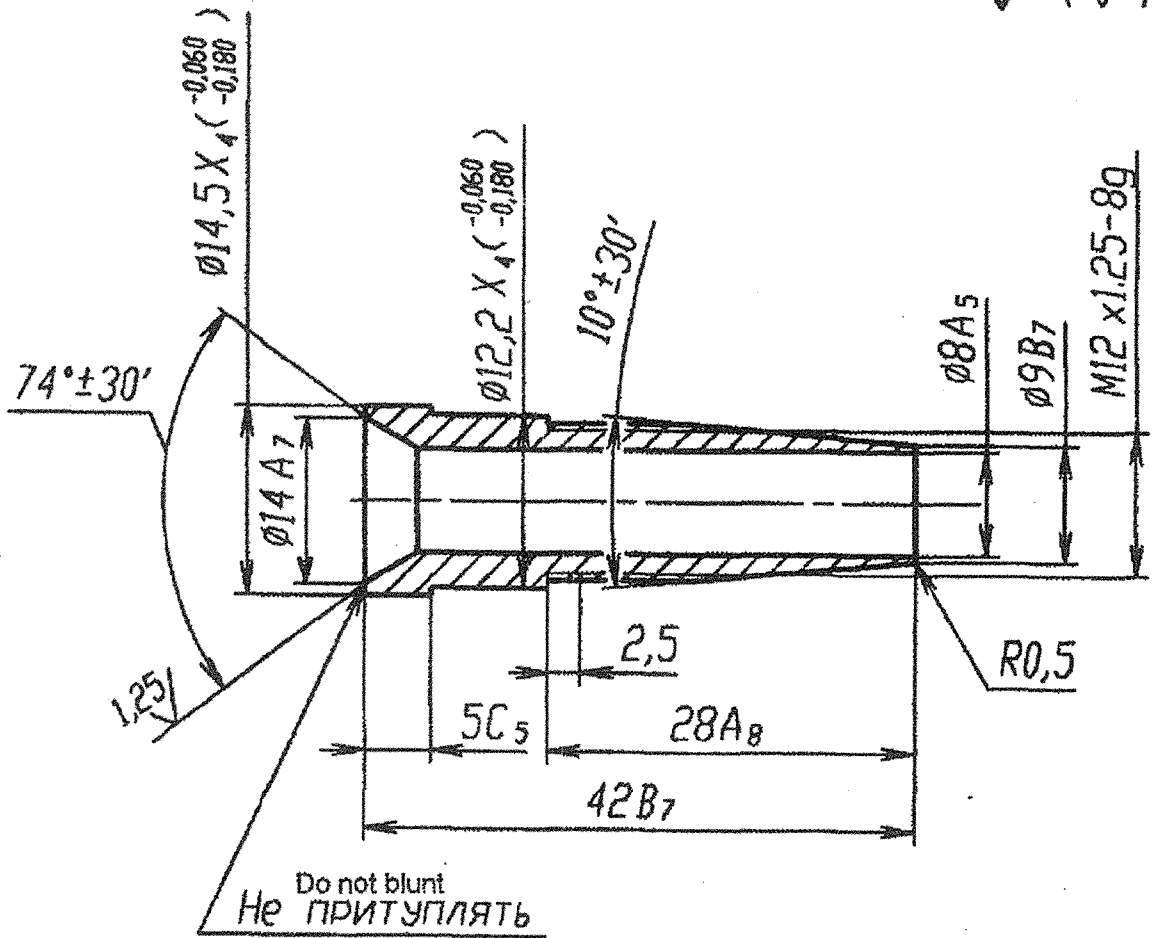
1. Substitute material- wheel $\frac{25 - h11GOST7417 - 75}{12Cr18Ni10Ti - VTU14 - 1 - 3957 - 85}$
2. * Dimensions ensured by tool.
3. Inner angles R~0.4 mm.
4. Blunt sharp edges ~0.6 mm.
5. Coating Ep.
- External view of component as per test specimen.
6. Mark Ш, Ч and stamp K on tag.

AK-630 114-91

					AK-630 114-91			
Amend.	Sheet	Doc.No.	Sign	Date	Coupling	Type	Weight	Scale
Developed by						A	0.050	2:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by					Wheel	$\frac{25 - VGOST2590 - 88}{12Cr18Ni9Ti - B - TGOST5949 - 75}$		

AK-630 114-85

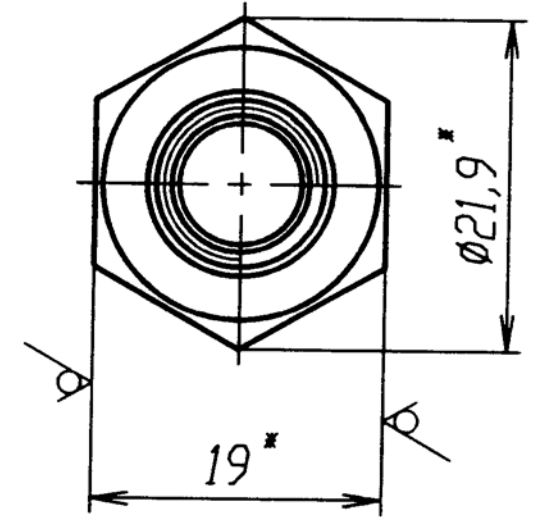
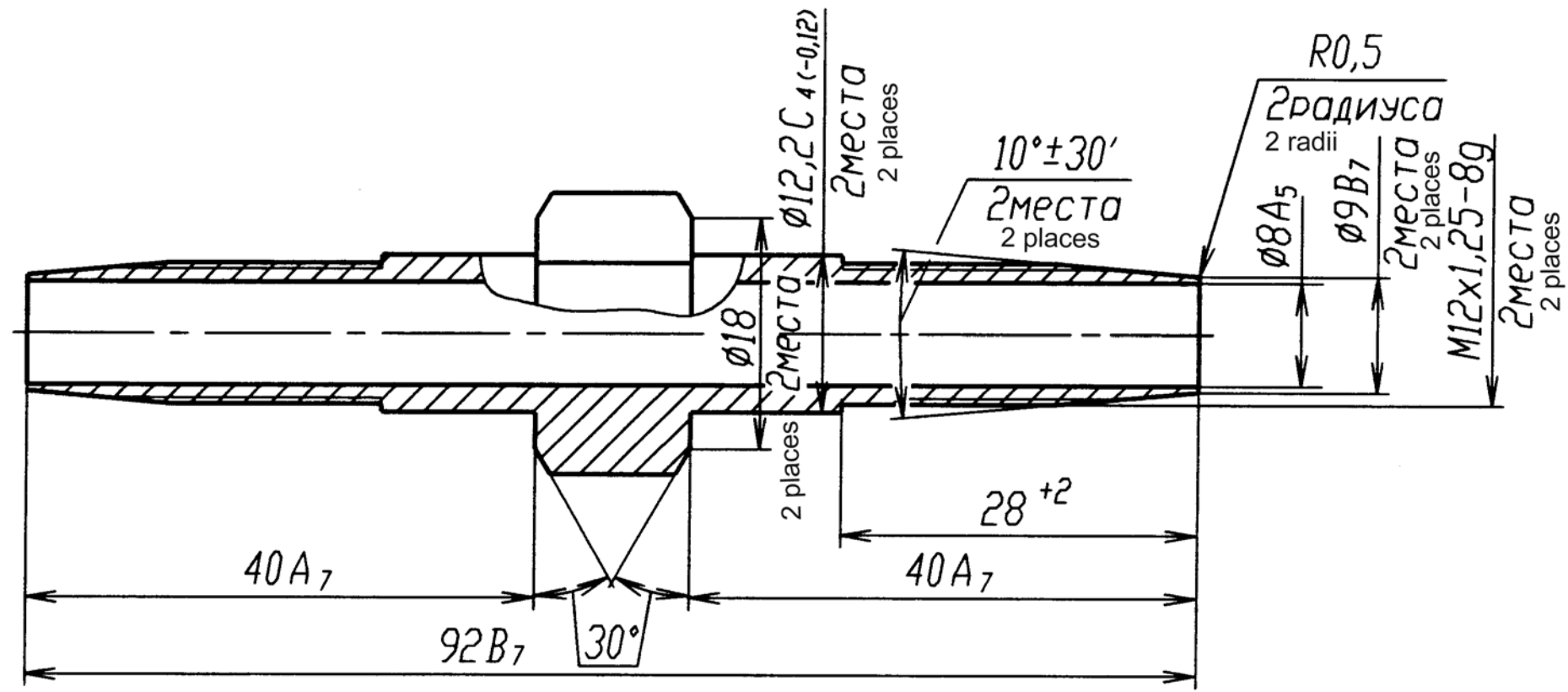
Rz40
 ✓ (✓)



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

Approved OGMet	Sign and Date	Approved TOso	Sign and Date	Approved KTONI	Sign and Date	Approved by shop	Reference No.	First use
Orig. Inv. No.	Alternate Inv. No.	Dupl. Inv. No.	Dupl. Inv. No.	Dupl. Inv. No.	Dupl. Inv. No.	Reference No.	Reference No.	Reference No.
AK-630 114-85								
Amend.				Sheet	Doc. No.	Sign	Date	
Developed by				Nipple				Type
Checked by				Steel 12Cr18Ni9Ti GOST 5632-72				A
Head of Q.C.D								Weight
Design bureau chief				Sheet				1
Head of Q.C.D				Sheets				1
Approved by				Formet 1.1				

Rz40
✓ (✓)



- 1.* Reference dimensions.
2. Inner angles R~0.4 mm.
3. Blunt sharp edges ~0.4 mm.
4. Coating Cd6. phos. Oil. It is permissible to avoid cadmium plating of inner surfaces.
5. Mark Ш, Ч and stamp K, on tag.

					AK-630 114-45			
Amend.	Sheet	Doc.No.	Sign	Date	Nipple	Type	Weight	Scale
Developed by						A	0.055	2:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D						Hexagon $\frac{19 - 5GOST8560 - 78}{40Kh - T - VGOST1051 - 73}$		
Approved by								