

1. Tolerances for free dimensions are as per accuracy class 7 OST 1010.
2. Tolerances for casting and allowances for machining are as per accuracy class 5, of standards 56-15 and 56-16.
3. In case of great displacements in casting, the neck may be machined to provide panel fitting.
4. Run-out of $\phi 152C2a$ with respect to $\phi 47A1$ should not exceed 0.02mm.
5. End play of butt-end "XX" with respect to $\phi 47A1$ should not exceed 0.05mm.
6. pattern taper should be 2°.
7. Casting radii should be R 2mm.
8. Sand-blast the castings.
9. Permissible displacement of hole $\phi 8A3$ with respect to slot 10 should not exceed 0,07 mm.
10. Falling of NO-GO gauge through $\phi 152 C20$ is allowed in sector 25° not exceeding one sector; along circumference.
11. Carry-out heat treatment as per condition T5 GOST 2685-75.
12. Coating: Anodic oxidation, chromatization except for the places marked with X and threaded holes.
13. Surfaces marked with "X" should be coated with varnish, k ϕ -965 HBA 002 8004.
14. Technical requirements for casting, as per OST 190021-71, group B.
15. Paint external surface with hammer-riveted enamel as per instruction T43-47.
16. Sinking of bush 204.916 H should not exceed 0.2mm, with respect to surface "B" end frame.

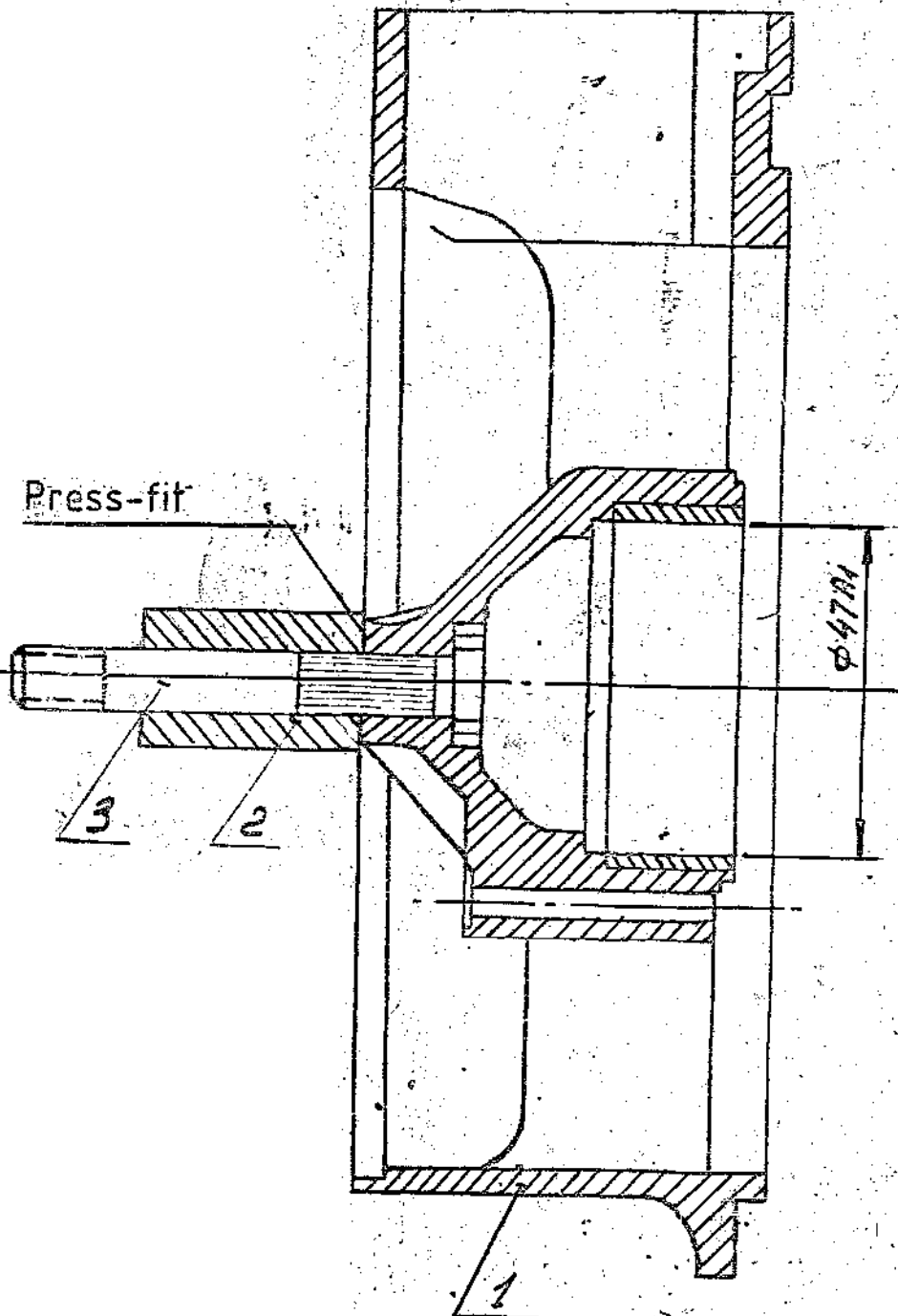
		Aluminium alloy АЛ-9		
2	120 208 H -1	GOST 2685 -75	Without drawing	
1	204 916 H	BUSH	1	
S no.	Designation	Description	Qty	Remarks
PLOT SAMPLE SHOULD BE APPROVED BY A.H.S.P BEFORE BULK PRODUCTION				
		EST. MASS	TO BE STAMPED OR INDICATED THUS (LETTERS)	
		0.655 Kg		
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNER TO HAVE R OUTSIDE				
R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE				
ISSUE DATE	NATURE OF AMENDMENTS			
DRW	SCALE: 1:1	MATERIAL	USED ON - 120 209 H	
CD	DIMENSIONS IN mm		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TC	TOLERANCE ON DIMS UNLESS OTHERWISE STATED		TITLE: END FRAME	
APPD	ALL THREADS TO CONFORM TO		D S CAT NUMBER	
DATE 7.10.87			DRAWING NUMBER 120 208 H	

(21)

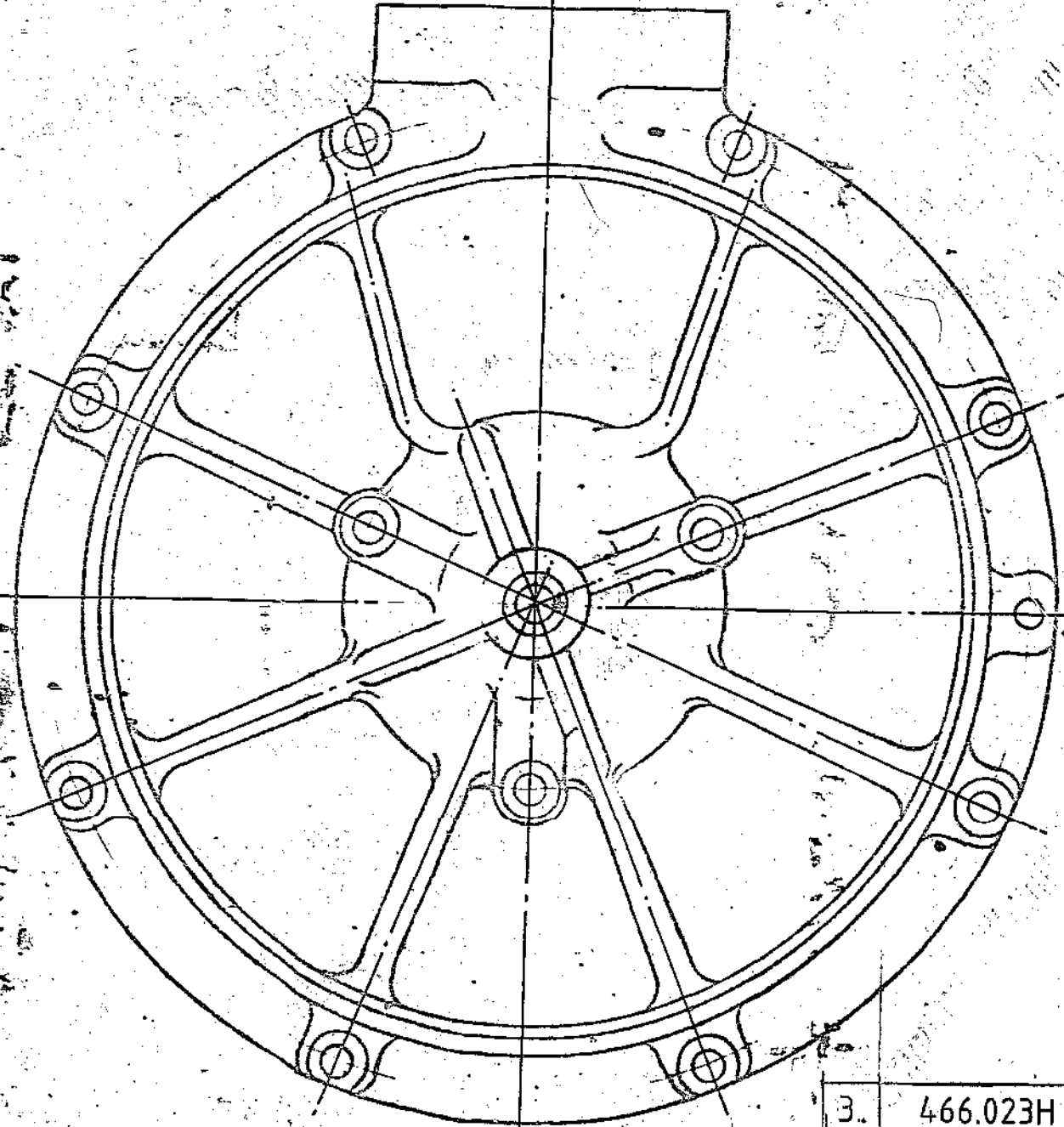
5-0111-80
4-0024-78
3-250-78
2-220-78
1-140-78/76



120.209H



1. Dimension 47A1 should be maintained after press fitting of bolt, ref.No.3. and press fitting of bush ref.no. 2 by force.



S.No	Designation	Description	Qty	Remarks
3.	466.023H	Bolt	1	
2.	204.330H	Bush	1	
1.	120.208H	END FRAME Shield	1	

PLDT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

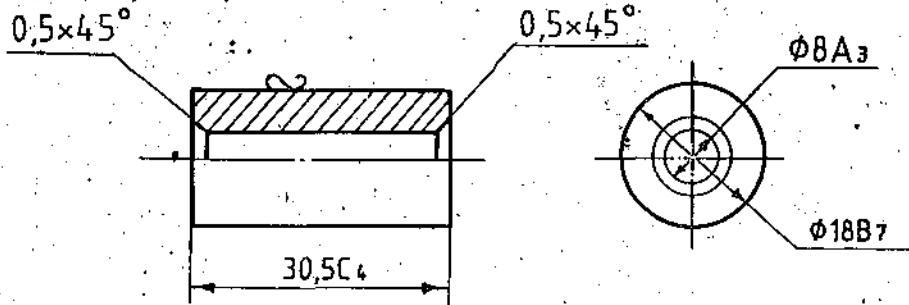
EST. MASS 0.707 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS LETTERS	(22)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE & BEVEL EQUIVALENT CHAMFERS ARE PERMISSIBLE		
ISSUE DATE	NATURE OF AMENDMENTS	
DRN	SCALE: 1:1	MATERIAL: — USED ON: 002 145
CHKD	DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: SHIELD
APPD	ALL THREADS CONFORM TO	D S CAT NUMBER
DATE 9-9-07		DRAWING NUMBER 120.209 H



DRAWING NUMBER

204-330 H

▽ 5



1) ANODIZE AS PER TU4-8.

2) ALTERNATE MATERIAL IS BAR, IT GOST 21488-76 GOST 4784-74



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 OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
			MATERIAL: BAR, 16T GOST 4784-74 GOST 21488-76	USED ON: 120 209 H
ISSUE	DATE	NATURE OF AMENDMENTS	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
DRN		SCALE - 1:1		
CHD		DIMENSIONS IN mm	TITLE:- BUSH	
TCD		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED.		
APPD		ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER 204-330 H
DATE	9-9-07			

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SIZE A4

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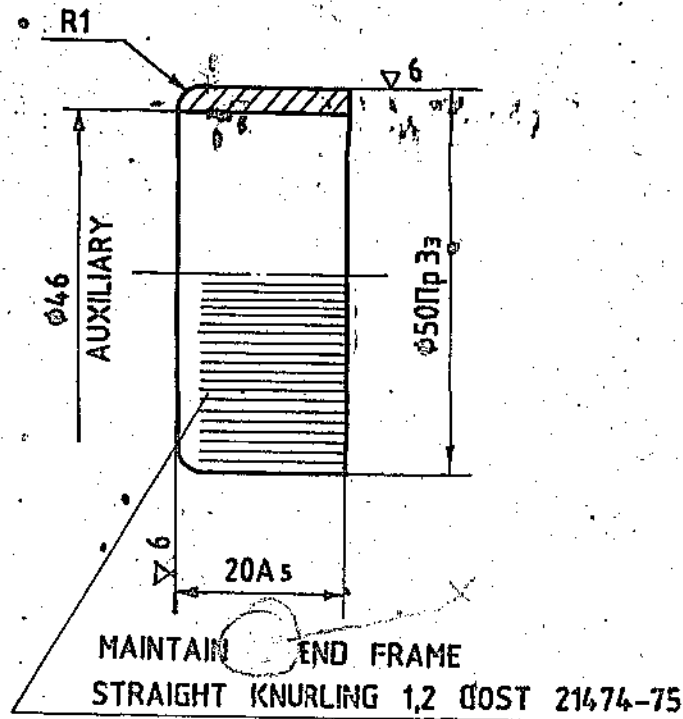
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DRAWING NUMBER

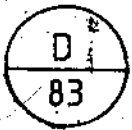
204 916 H

5 UNLESS STATED OTHERWISE



1) CARRY-OUT HEAT TREATMENT HRC 38 TO 42.

COATING: ZINC PLATING 9 MICRONS THICK CHROMATIZATION.



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

		EST. MASS.	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: STEEL 30X FCA GOST - 8733-74 GOST 8734-75	USED ON: 120 208 H
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE - ---	
CHD		DIMENSIONS IN □□	
TCD		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED.	
APPD		ALL THREADS CONFORM TO	
DATE	9-9-07	D S CAT NUMBER	DRAWING NUMBER 204 916 H
SIZE	A4		

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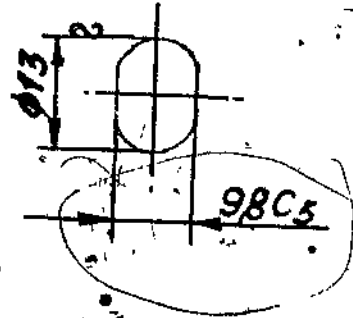
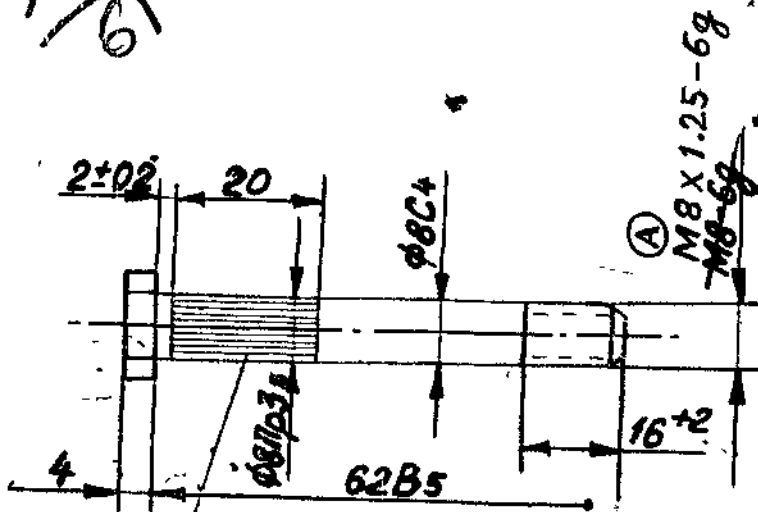
466-023H

▽5 - Unless otherwise specified,

1. Tolerance for free dimensions are as per accuracy Class 7, OST 1010.
2. Carry-out Heat Treatment. H R C 30 TO 34.
3. Knurling traces are allowed on $\phi 8 C_4$.
4. Coating:- Zinc-plating, 9 microns thick, chromatization. Dehydrogenate.
5. Elements of thread are as per GOST 10549-80.

NOT No. 0111-80

Handwritten: 1/14/61



Straight knurling 0,8 GOST 21474-75

Handwritten: (1) Touch with No. (2)

Handwritten: * STEEL 30XA TY 14-1-950-74 GOST 7417-75

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

(75)

		EST. MASS 0.027 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS (IN LETTERS)
A	18.4.02	AUTHY Lt No 10023/ IND-III/506 dt 17.4.02	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 - SEE ABOVE * USED ON - 120.209 H
DRN	SCALE - 1.1		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
CHD	DIMENSIONS IN mm		
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED		TITLE BOLT
APPD	ALL THREADS CONFORM TO		D S CAT NUMBER
DATE	9-9-87		DRAWING NUMBER 466 023 H

1. 1990年10月1日以前，
2. 1990年10月1日以后，

3. 1990年10月1日以后，
4. 1990年10月1日以后，

5. 1990年10月1日以后，
6. 1990年10月1日以后，