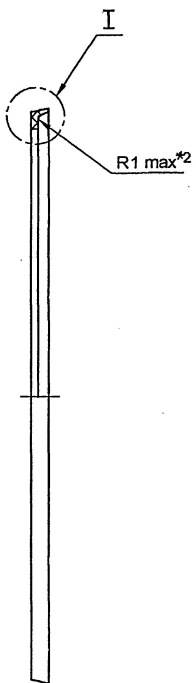


DRAWING NUMBER
432.40.127-2

SHEET No. 1 OF 1



- 1 DIMENSIONS MARKED WITH *1 ARE TO BE ENSURED BY TOOL
- 2 DIMENSIONS MARKED WITH *2 ARE GIVEN FOR REFERENCE
- 3 Б IS WORKING SURFACE
- 4 ON WORKING EDGE 'A' AND SURFACE Б, PERMITTED ARE MARKS LEFT BY GRINDING OFF THE FLASH TO A DEPTH 0.2mm AND TO A HEIGHT OF 0.2mm AND LOCAL INCONSIDERABLE BLUNTS OF R0.1mm
- 5 ON NON-WORKING SURFACES, ALLOWED ARE PROJECTIONS, DEPRESSIONS UPTO 0.5mm (THOSE ON SURFACE 'I' UPTO 0.2mm) BESIDES PERMISSIBLE ARE INCLUSIONS AND HOLLOW LEFT BY FALLEN-OUT INCLUSIONS UPTO 0.3mm HIGH AND DEEP (NOT MORE THAN THREE SUCH DEFECTS ON 100mm ARC, ARE PERMISSIBLE) IMPRINTS FROM MOULD OF NOT MORE THAN 0.5mm ALL THESE DEFECTS SHOULD BE GROUND
6. PERMISSIBLE ARE THE FOLLOWING DEFECTS:
 - a) ON COMPONENT SURFACE - MOIRE PATTERN, DULL SPOTS, MINOR BURNINGS, EMBEDMENT OF FOREIGN MATTER, MARKS WITHOUT EXPOLIATION CAUSED BY SEPARATION OF BLANK FROM MOULD,
 - b) ON NON-WORKING SURFACES - FLASH 0.3mm, MAX. FROM MOULD ALONG ITS SPLIT SURFACES AND TRACES LEFT BY MACHINING OF FLASH OF NOT MORE THAN 0.3mm,
 - c) SPONTANEOUS DISTORTION OF COMPONENT FORM
7. ON SURFACE 'B' THE COMPONENT NUMBER SHOULD BE MARKED BY IMPRINTING THE ENGRAVING OF THE MOULD. FOR THE PURPOSE, USE TYPE ITO-2 GOST 2930-62
8. SEALS SHOULD BE TRANSPORTED ON CARDBOARD OR PRESSBOARD MANDREL AT THIS, IT IS IMPERMISSIBLE THAT COMPONENTS BE DAMAGED BY CONTAINERS
9. DIAMETRICAL DIMENSIONS ARE TO BE CHECKED IN COMPLIANCE WITH INSTRUCTIONS Uc-51-10-35-78/81
10. OTHER REQUIREMENTS FOR ARTICLES, CODE 253122, ARE AS PER TY 005216-75

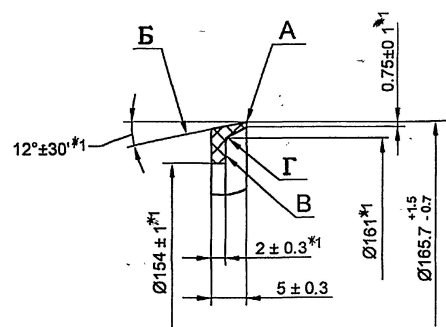
EXPLANATORY NOTE

THE COMPONENT 'SEAL' SHOULD BE PRODUCED AS PER RUBBER CODE OF PTIII CLASSIFICATION No 253122 AND GRADE UP II 1316 TO TY 005 216-75

THE TECHNICAL PARAMETERS OF THE SUBJECT ITEM SHOULD BE AS FOLLOWS:

- 1) WORKING MEDIA _____ LUBRICANT 'II'
- 2) OPERATING TEMPERATURE °C _____ FROM -20° TO +200°C
- 3) DESTINATION AND LIMIT _____ RECIPROCATING MOTION
PARAMETERS OF USE SEAL
- 4) HARDNESS _____ 76 - 88
- 5) RUPTURE STRENGTH Kgf/cm² _____
NOT LESS THAN _____ 160
- 6) ELONGATION AT RUPTURE % _____
NOT LESS THAN _____ 65
- 7) RESIDUAL ELONGATION AFTER RUPTURE % NOT MORE THAN _____ 5
- 8) DENSITY g/cm³ _____ 1,95 ± 0,05

I
SCALE 2:1



5A) 172.40.052cbCb
172.40.053cbCb
172.40.054cbCb

RUBBER COMPOUND UP II -1316
TY 005 216-75

5C) ALT. MATL: RUBBER GRADE FKM TO SPECN. CQA(HV)/FKM

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)
0.015	
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	Sd / =	MATERIAL:-	USED ON:- 172.40.018cb
CHD	Sd / =	SEE ABOVE	172.40.019cb
APPD	Sd / =		172.40.020cb
DATE	18-09-82	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE:- 1:1		AVADI	
DIMENSIONS IN mm		TITLE:-	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69		COLLAR 5B	
5C	13.01.07	L.No. 81312/CQA(HV)/DB-III/AII. Matl. dt. 12.10.06.	
5B	18.2.05	AS PER KIT LIST No. CQA(HV)/SET/0021	
5A	17.9.04	N OF A. No. CQA(HV)/T90/40/001	
4.5	18.11.88	AMDT. LIST. 6 / II. BOOK - 7	
ISSUE	DATE	NATURE OF AMENDMENTS	
D S CAT NUMBER		DRAWING NUMBER	
		432.40.127-2	

IR. RAMANI, JTO
10-03-06

" COMMON TO T-90 "
DRG. RE INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 3

F-78

SIZE A2