

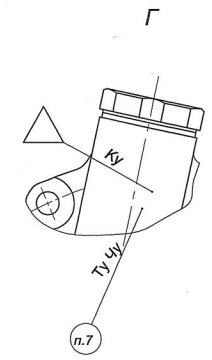
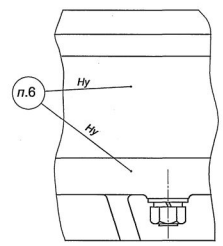
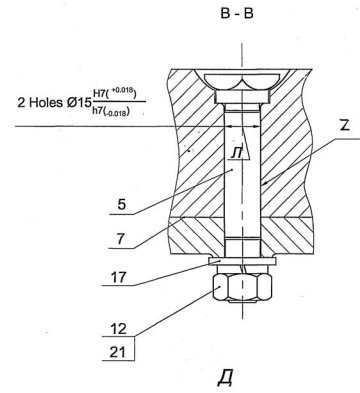
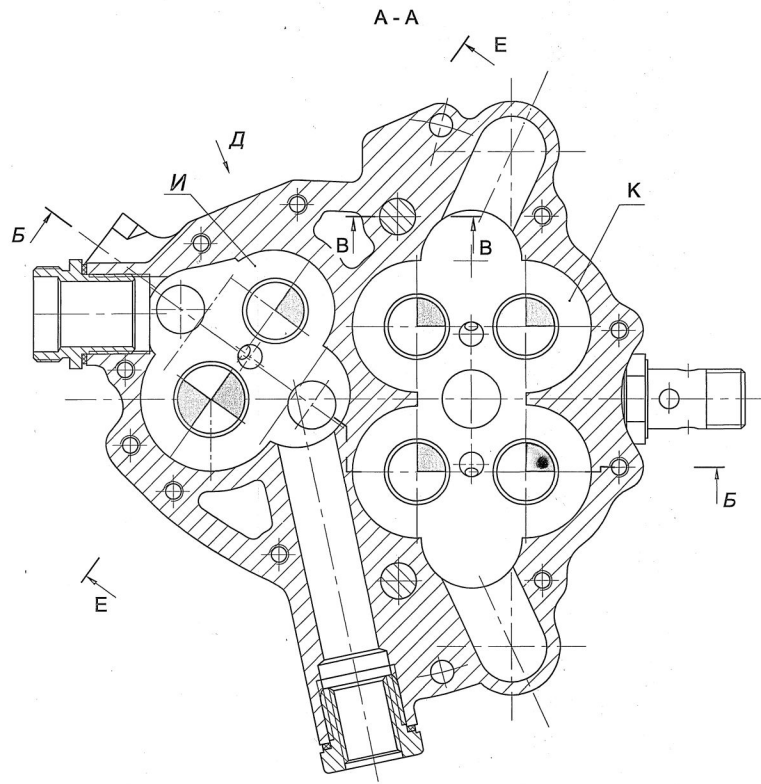
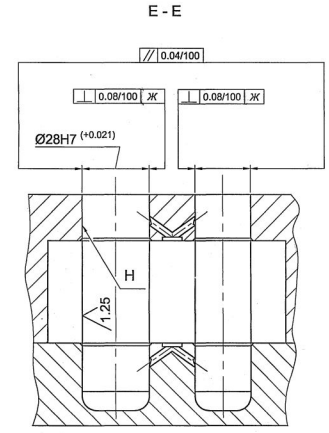
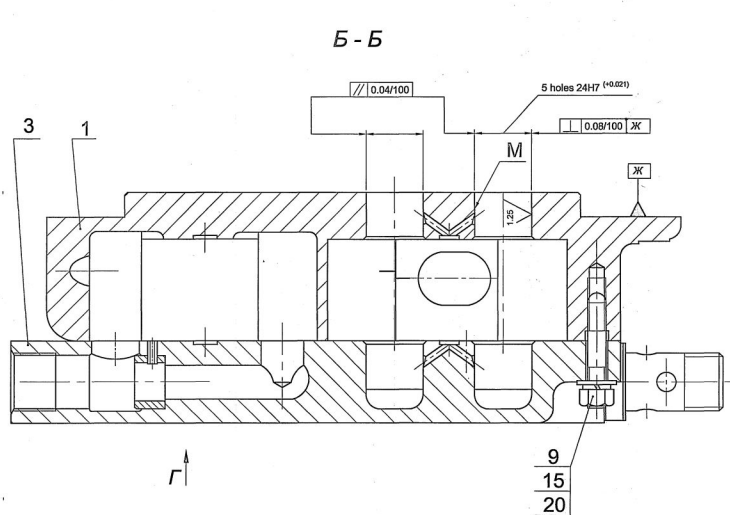
- Ⓐ 1. DIMENSIONS ARE TO BE ENSURED BY TOOL.
- 2. UNSPECIFIED LIMIT DEVIATION OF DIMENSIONS ± 0.3 mm.
- 3. FOLDS, CRACKS AND HOLES VISIBLE WITH NAKED EYES ARE NOT ALLOWED ON EDGES OF CONTOUR. THERE SHOULD NOT BE NOTCHES AND BREAKAGES.
- Ⓐ 4. DIMENSIONS FOR REFERENCE.

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

EST. WT. 50 PIECES 0.066g 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	APPO	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS. UNLESS OTHERWISE STATED IS 2102 - 69	ALL THREADS TO CONFORM TO	DS CAT NUMBER	DRAWING NUMBER
				12-7-96	1:1					412-57-1A
MATERIAL: PAPER K 120, GOST 23436-83			USED ON: CE 3312-90-5			CONTROLLER OF QUALITY ASSURANCE HEAVY VEHICLES A V A D I			TITLE: GASKET	
ISSUE	DATE	NATURE OF AMENDMENTS	AUTHY. NOTN. No. BK 87-606.							

DRAWING NUMBER
Cb.3312-90-14



1. It is permitted to increase the dimension Δ upto $\varnothing 15.5H7^{(+0.019)}$ by ensuring the clearance $Z=0..0.036$ mm after mounting tight fit bolts.
2. Pressure test for cavity Π and K should be carried out with oil for diesel engine at temperature $(90_{-5}^{+10})^{\circ}C$ for a minimum period of 2 minutes, or diesel fuel at temperature $(20\pm 5)^{\circ}C$ with pressure for cavity Π $-(1.5\pm 0.1)$ MPa $[(15\pm 1) \text{ kgf/cm}^2]$, cavity K $-(1.1\pm 0.1)$ MPa $[(11\pm 1) \text{ kgf/cm}^2]$. While sending as spares carry out the air tightness test for cavity Π and K with pressure (1.4 ± 0.1) MPa $[(14\pm 1) \text{ kgf/cm}^2]$. Oil leakage is not permitted. During pressure test, measure the pressure in cavity Π and K at the opposite sides from oil supply line
3. Pressure test to be carried out with gasket, item 7.
4. For assembly units, which are not to be sent as spares carry out the air tightness test in assembly unit Cb.3312-00-22.
5. In tropical design, components marked with designation "T" in column "Remarks" of the part list of given drawing should be of tropical construction, as specified in the working drawings.
6. Mark with letter type П10-5 Gost 2930-62.
7. While sending as spares, mark with letter type П10-6-Gost 2930-62.
8. Longitudinal tool marks due to withdrawal of tool on the surface M with depth not exceeding 0.02mm is permitted.

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

EST. WT.(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	APPD	DATE	MATERIAL	USED ON
					CB 3312-00-12
				CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	AVADI
				TITLE: HOUSING WITH COVER ASSY	
				D S CAT NUMBER	
				DRAWING NUMBER	
				Cb.3312-90-14	

DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 3

F-4
15
15
SIZE A1

