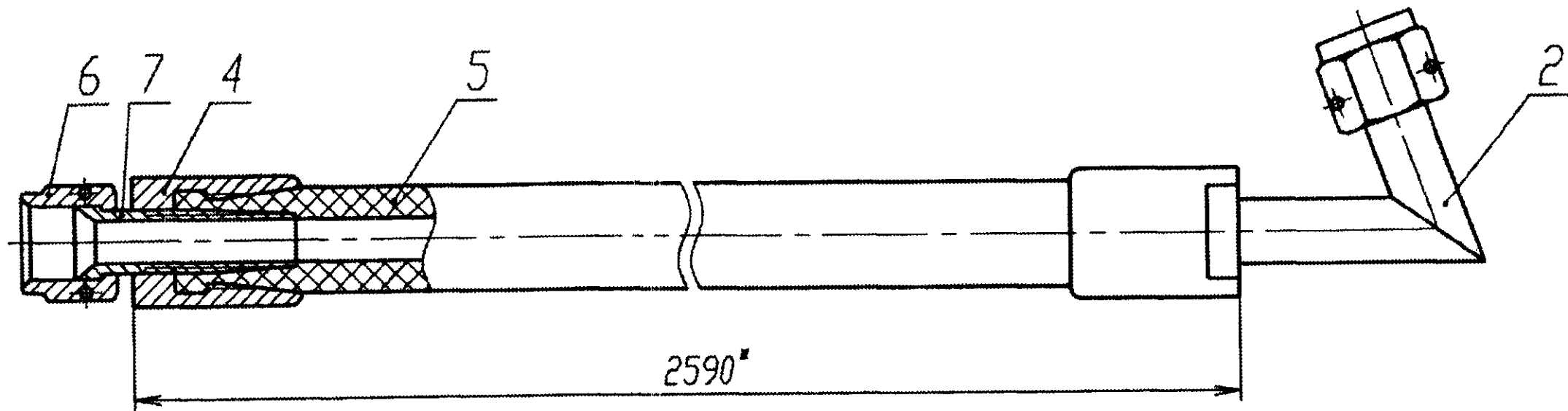


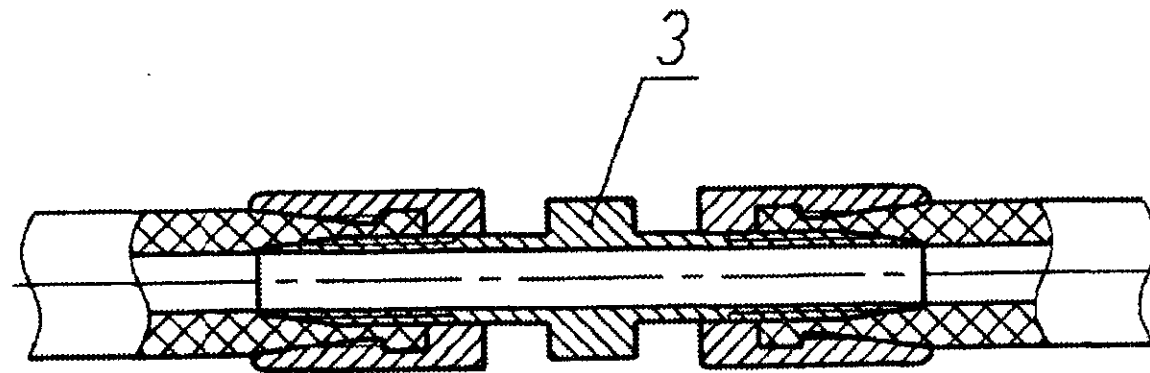
First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
						<u>Documents</u>		
Reference No.	A3			AK-630 Sb 114-16 SB	Assembly drawing			
					<u>Assembly units</u>			
	A4	2		AK-630 Sb114-34	Elbow	1		
					<u>Components</u>			
	A3	3		AK-630 114-45	Nipple		max.1	
	A3	4		AK-630 114-91	Coupling	2	max.4	
	A3	6		AK-630 114-32	Coupling nut	1		
	A4	7		AK-630 114-85	Nipple	1		
Sign and Date					<u>Materials</u>			
		5			Hose 5U8-85	1	L=850mm	
Dupl. Inv. No.					TU 38.005-1515-92		L=1670mm	
Alternate Inv. No.								
Sign and Date					AK-630 Sb 114-16			
	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 two pieces of hoses, one of which of size 1670 mm, by mounting additional component pos.3 and increasing no. of components pos.4.
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 component pos.7, 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 114-16 SB			
Amend.	Sheet	Doc.No.	Sign	Date	Hose Assembly drawing	Type	Weight	Scale
Developed by						A	0.750	1:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by								

AK-630 114-45

First use

Reference No.

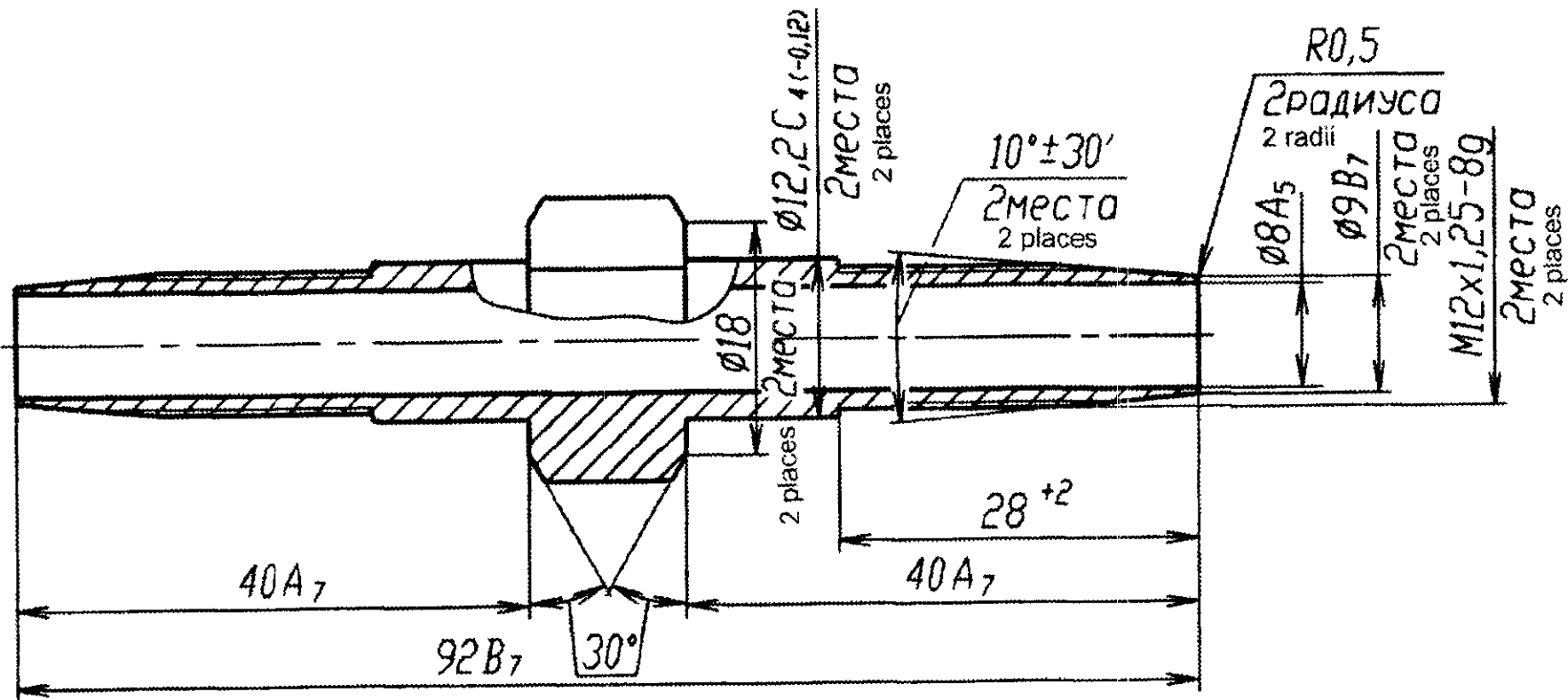
Sign and Date

Duplicate Inv. No.

Alternate Inv. No.

Sign and Date

Orig. inv. no.



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								

First use

Reference No.

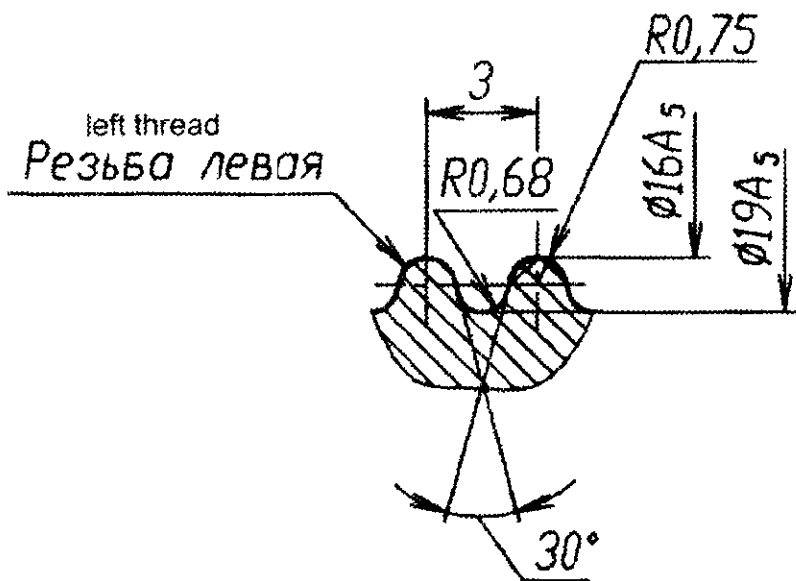
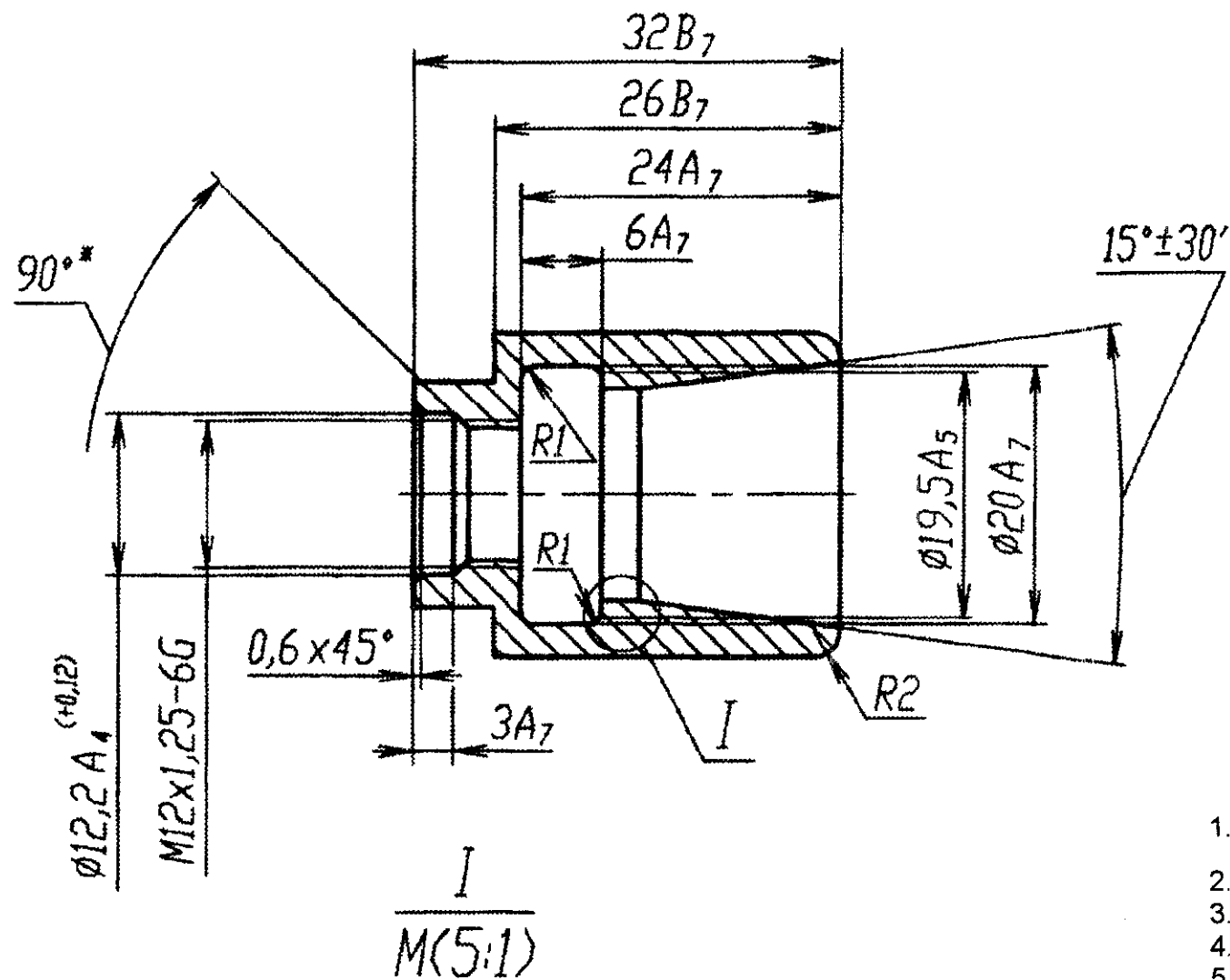
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

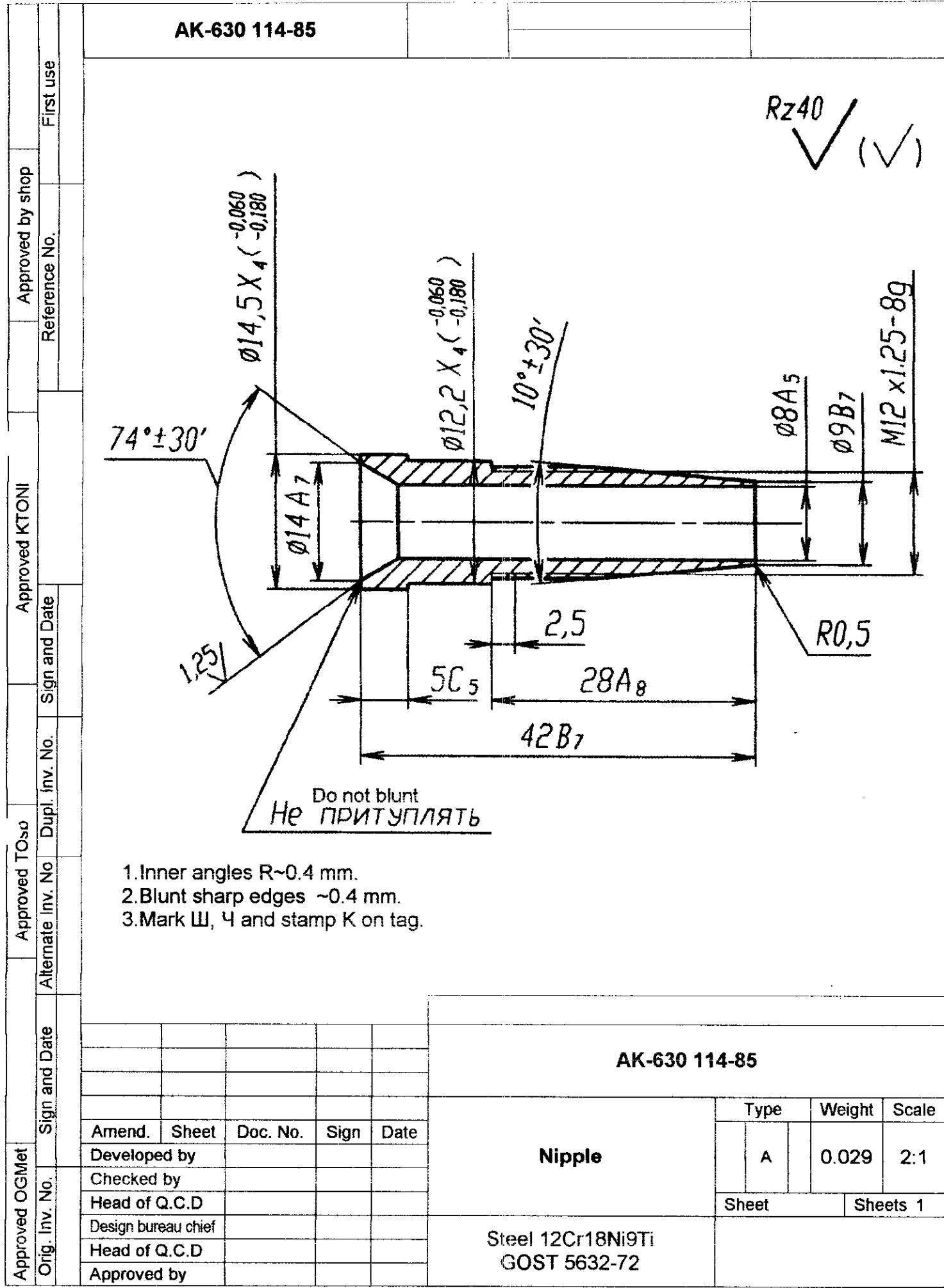
Orig. inv. no.



1. Substitute material- wheel $\frac{25 - h1GOST7417 - 75}{12Cr18Ni10Ti - VTU14 - 1 - 3957 - 85}$
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			
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					Wheel	$\frac{25 - VGOST2590 - 88}{12Cr18Ni9Ti - B - TGOST5949 - 75}$		
Approved by								

AK-630 114-85



AK-630 Sb114-34 SB

First use

Reference No.

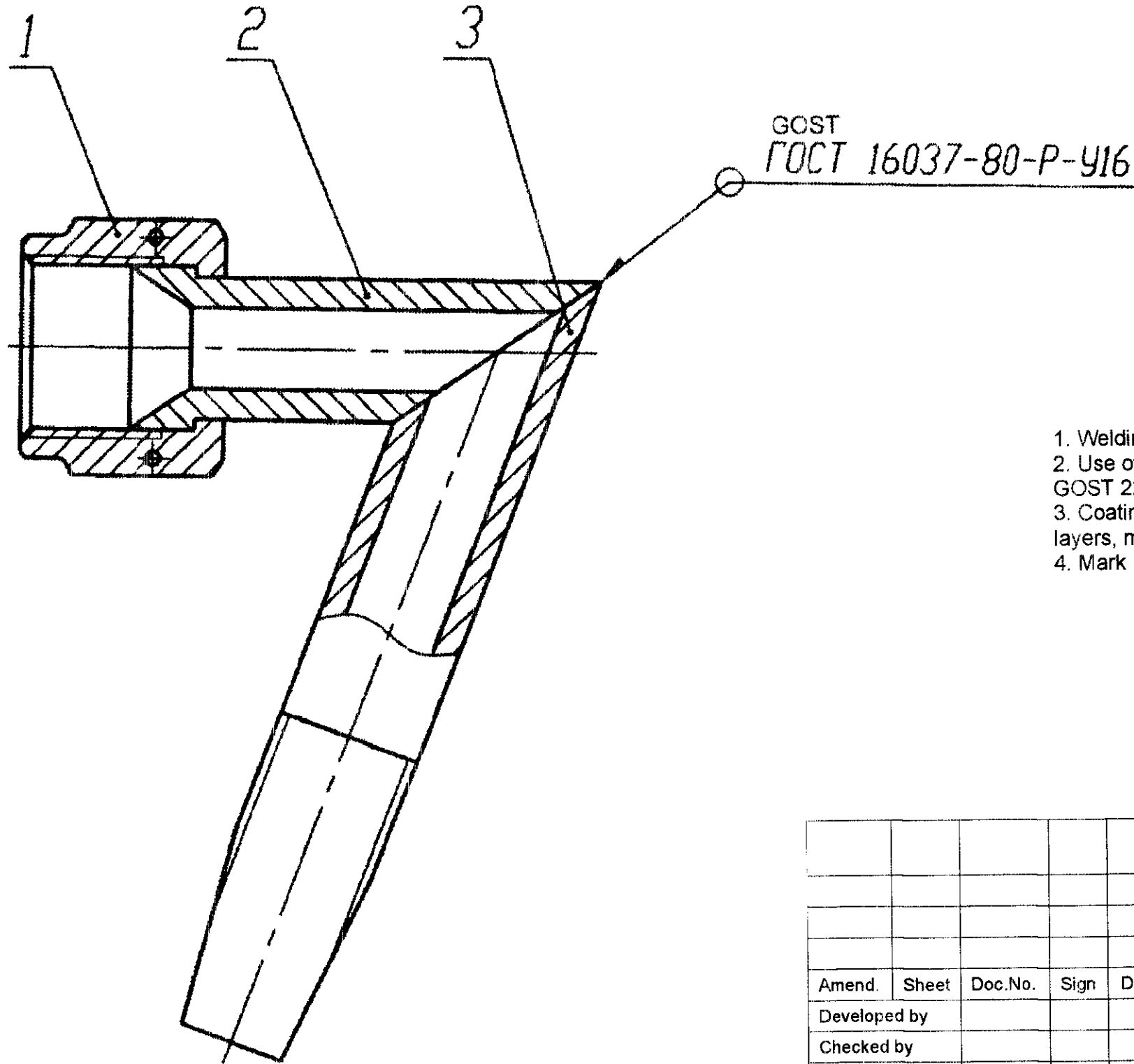
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



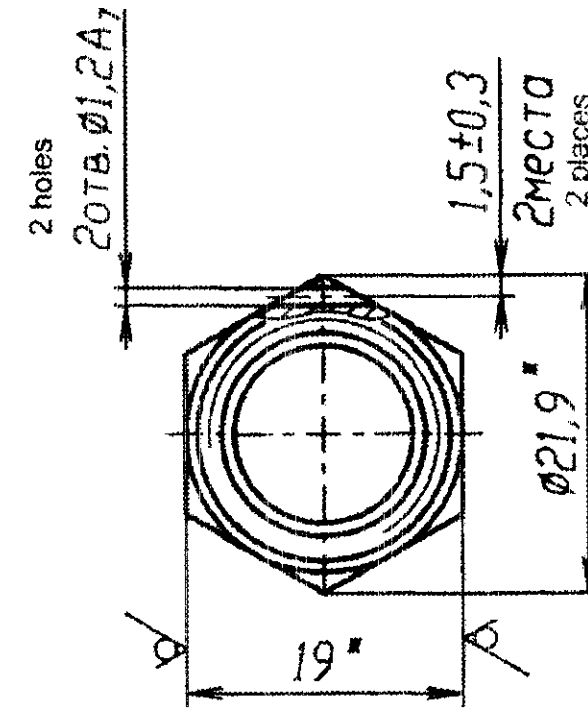
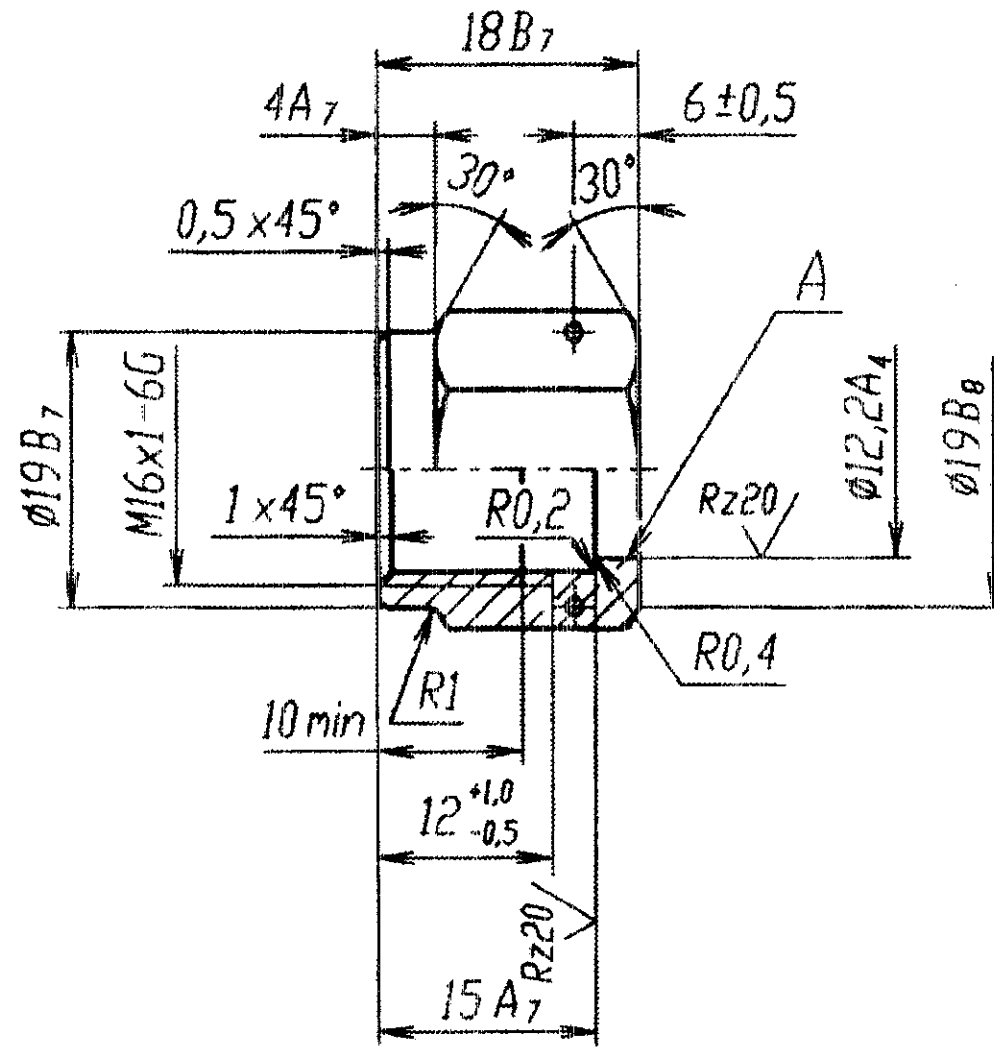
1. Welding rod TsL-11-3.0-2 GOST 9466-75.
2. Use of argon-arc welding is permissible. Filler wire 2 Sv -0.6 Cr19Ni9Ti GOST 2246-70.
3. Coating of external surface Chem. phos. Lacquer BF-4 with Nigrozene , 2 layers, made as per OST3-4123-78, IV, OM2, remaining Chem.phos.
4. Mark Ш , Ч and stamp K on tag.

					AK-630 Sb114-34 SB			
Amend.	Sheet	Doc.No.	Sign	Date	Angle piece Assembly drawing	Type	Weight	Scale
Developed by						A	0.070	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D								
Approved by								

AK-630 114-32

First use

Reference No.



Rz40 ✓ (✓)

Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

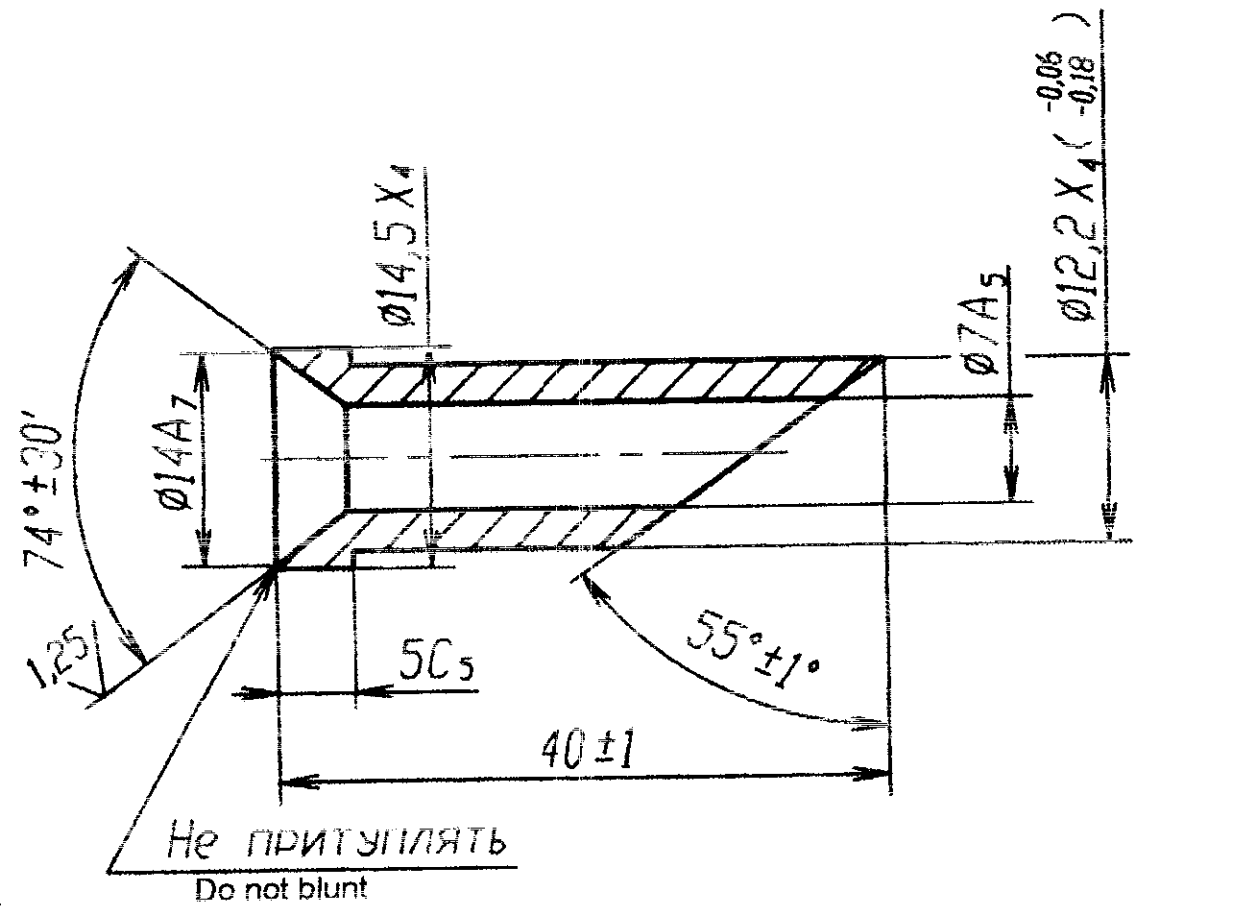
1. Substitute material- hexagon $19 - 5GOST8560 - 78$
 $40GOST1051 - 73$
2. 31..40.5 HRC_E. Check 3..5% , but not less than 3 nos. from batch.
- 3.* Reference dimensions
4. Blunt sharp edges ~ 0.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.01 mm.
6. Mark Ш, Ч and stamp K, 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
					Sheet	Sheets	1
					Hexagor $19 - 5GOST8560 - 78$ $40Kh - T - VGOST1051 - 73$		

AK-630 114-69

Approved by shop		Approved KTCNI		Approved Tusb		Approved OGMet	
Reference No.		Sign and Date		Alternate Inv. No		Sign and Date	
First use		Dupl. Inv. No.		Inv. No.		Inv. No.	



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

AK-630 114-69

Amend.	Sheet	Doc. No.	Sign	Date	Nipple	Type	Weight	Scale
Developed by						A	0.010	2:1
Checked by					Steel 12Cr18Ni9Ti GOST 5632-72	Sheet		Sheets 1
Head of Q.C.D								
Design bureau chief								
Head of Q.C.D								
Approved by								

Copied by

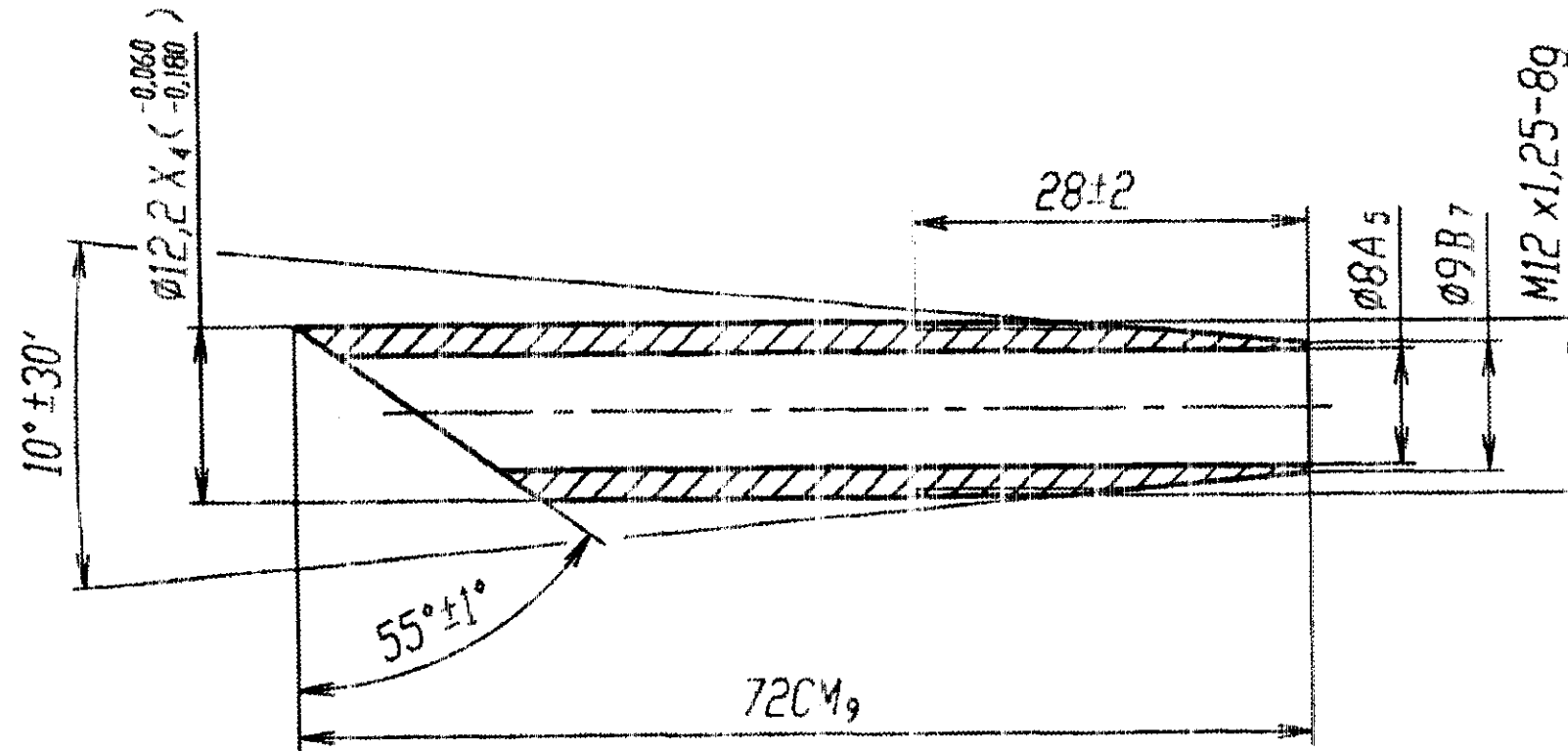
Format A4

AK-630 114-70

First use

Reference No.

Rz40
✓(✓)



Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

1. Inner angles R~0.4 mm.
2. Blunt sharp edges ~0.4 mm.
3. Mark W, 4 and stamp K on tag.

					AK-630 114-70			
Amend	Sheet	Doc.No.	Sign	Date	End cap	Type	Weight	Scale
						A	0.040	2:1
Developed by					Steel 12Cr18Ni9Ti GOST 5632-72	Sheet	Sheets	1
Checked by								
Head of Q.C.D								
Approved by								