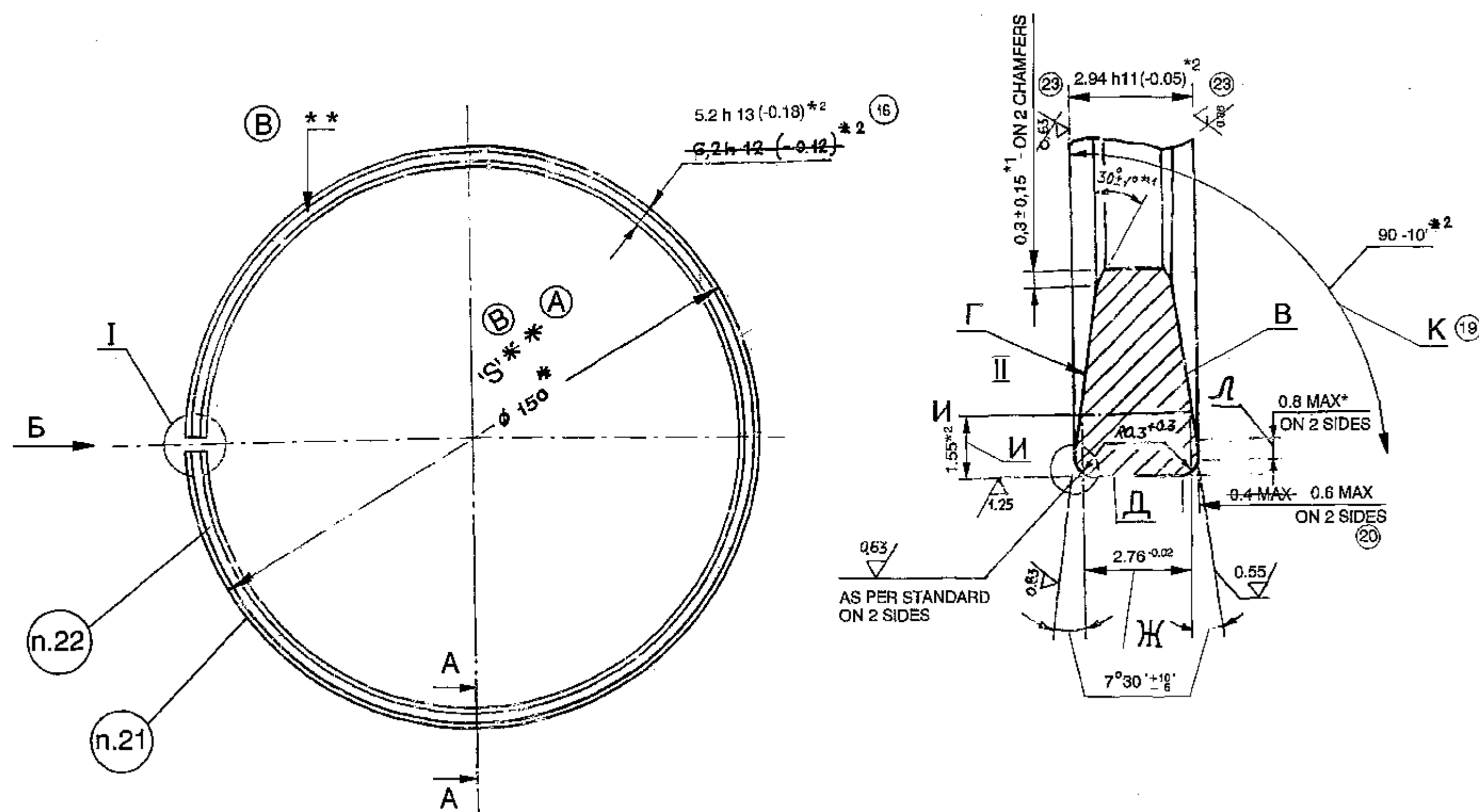


P. JANARDHANAN
 DT: 23 Apr 10, JTO (C)

INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NIL

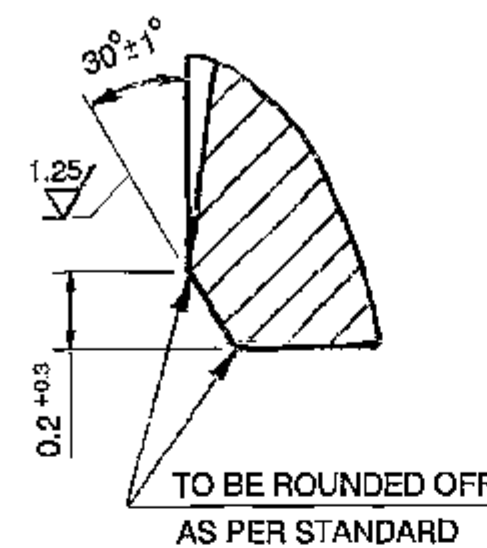
KVD No. 78076

SIZE A1



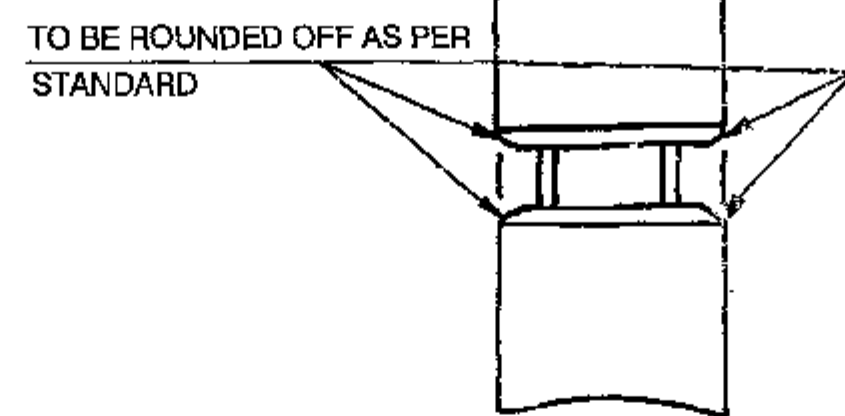
II ALTERNATE

M 20 : 1
SCALE 20 : 1



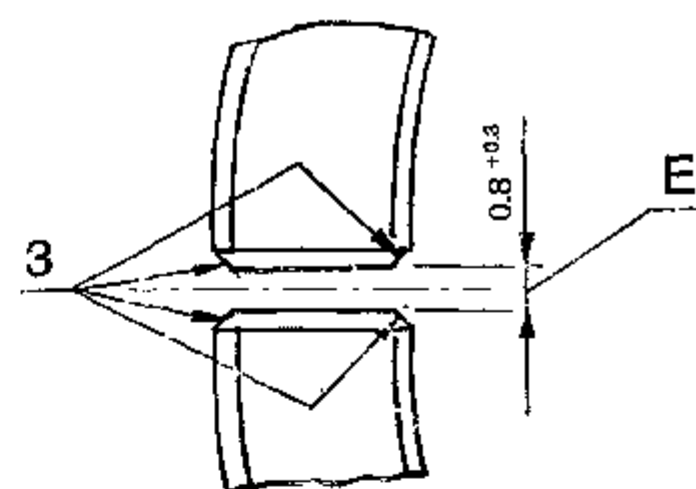
VIEW 5

M 10 : 1
SCALE 10 : 1



I

M 5 : 1
SCALE 5 : 1



REPAIR SIZES DIMENSION

CATEGORY	DIMENSION 'S'
3304 - 06 - 9 R1	150.2
3304 - 06 - 9 R2	150.5

REPAIR SIZE DIMENSION **

CATEGORY	DIMENSION 'S'
3304 - 06 - 9 R1	150 - 10
3304 - 06 - 9 R2	150 - 20

- INSPECTION GROUP III AS PER TECHNICAL REQUIREMENT TT - 11.
- HRC 42...50
- THE RING SHOULD BE SUBJECTED TO HEAT - TREATMENT ON A SPECIAL STAR TYPE MANDREL.
- BUCKLING OF SURFACES 'B' AND 'I' SHOULD NOT EXCEED 0.05 mm.
- RING SHOULD NOT HAVE ANY SURFACE MARKS, CRACKS AND METALLURGICAL DEFECTS.
- THE RING SHOULD BE CHECKED FOR DEFECTS BY MAGNETIC FIELD FLAW DETECTOR AND DEMAGNETIZED BEFORE BEING COATED WITH CHROMIUM MOLYBDENUM ALLOY EVERY BATCH SHOULD BE SUBJECTED TO SPOT CHECKING ON THE DEMAND OF QID.
- SURFACE 'A' IN COMPRESSED STATE SHOULD BE PROVIDED WITH COATING : Cr-10. AS THICK AS 100-160 MICRONS AS PER UA-212-76. DEPTH OF SPONGY LAYER 30-80µ, SEPERATE SPONGES HAVING DEPTH 30µ MIN ARE PERMITTED.
- HV 800 TO 1100 OF CHROMIUM MOLYBDENUM BEFORE FORMATION OF SPONGY LAYER TO BE CHECKED AS PER UA - 212 - 76.
- DEVIATION IN TOTAL THICKNESS OF CHROMIUM MOLYBOEMUM LAYER FOR A SINGLE RING SHOULD NOT EXCEED 0.06 mm.
- ROUGHNESS OF SURFACE 'A' BEFORE FORMATION OF SPONGY LAYER - 0.32
- SPALLING OF CHROMIUM MOLYBDENUM ALLOY IS NOT PERMITTED.
- COATING O1 AFTER FORMATION OF SPONGY LAYER AS PER UA-570-84. TIN LAYER ON SURFACE 'A' MAY NOT TO BE DONE.
- PLACES 'B' ARE TO BE BLUNTED ON TWO SIDES TO RADIUS OR CHAMFER 0.3 TO 0.6 mm. TO BE ACCEPTED AS PER STANDARD.
- DIMENSION 'E' FOR NOMINAL DIAMETER.
- RADIAL CLEARANCE BETWEEN THE RING AND THE CALIBRATED WASHER $\phi 150 \pm 0.03$ mm WHEN THE TOLERANCE FOR QUALITY OF CALIBRATED WASHER is 0.0025 mm. MAX. (SEMIDEFERENCE DIAMETER) MAY BE 0.02 mm OVER ARC NOT MORE THAN 45° ANY ONE PLACE OR AT TWO PLACES WITH TOTAL ARC IN 45° LOCATED NOT NEARER THAN 30° FROM THE LOCK GAP, POINT, CLEARANCE IS NOT PERMITTED.
- NONFLATNESS OF SURFACE 'B' AND 'I' SHOULD BE CHECKED BY PAINTING IN GAUGE WHICH CORRESPONDS TO THE NOMINAL DIAMETER WITH SPECIAL TAPER PLUG WITH WEIGHT 2.5 Kg. THE IMPRINT SHOULD BE IN THE FORM OF UNINTERRUPTED BAND WITH A WIDTH OF 1.5mm OVER THE ENTIRE RANGE.
- BUCKLING OF RING SHOULD BE CHECKED AFTER TINNING BY PASSING IT THROUGH THE SLIT FIXURE . THE RING SHOULD FREELY PASS THROUGH THE SLIT IN THE FIXURE BY ITS OWN WEIGHT. THE DIMENSION 3 ± 0.01 mm TRACES LEFTOUT BY MEASURING TOOL ON SURFACES 'B' AND 'I' ARE ALLOWED.
- LOCK GAP IN FREE CONDITION 18...22* mm.
- PISTON RING ELASTICALLY 2200 TO 3000 gm ON BAND DEVICE IN CASE DIMENSION 'E' IS PROVIDED.
- DIMENSION 'W' IS GIVEN FOR CHECKING DIMENSION 'K'.
- THREE LAST DIGITS OF COMPONENT NUMBER SHOULD BE MARKED.
- TO BE MARKED 'TOP'.
- MARKING SHOULD BE DONE WITH SOLUTION No.5 AS PER UA-16-73 TYPE No.3 GOST 2930-82.
- * DIMENSION FOR REFERENCE.
- ** DIMENSIONS ARE TO BE ENSURED BY TOOL.
- ** DIMENSIONS AFTER CHROMIUM MOLYBDENUM COATING.
- VARIATION IN RADIAL THICKNESS OF RINS SHOULD NOT EXCEED 0.1mm.
- DIMENSION 'K' SHOULD BE CHECKED IN FREE CONDITION OF RING.
- BAND 'T' UNIFORM ALONG PERIMETER IS ALLOWED.
- ** 29A. CHECK SIZE 'E' USING A SIZED WASHER WITH A DIAMETER OF 150.10 ± 0.03 mm FOR RING 3304-06-9 R1 AND THAT HAVING A DIAMETER OF 150.20 ± 0.03 mm FOR RING 3304-06-9 R2.
- ** 29B. MARKS R1 OR R2 TO BE APPLIED USING SOLUTION No.5 PREPARED ACCORDING TO In 16-73. LETTERING ITO-3 GOST 2930-82.

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

EST. WT. (Kg) 0.045 ** 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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	Sd / =	MATERIAL :- STEEL	USED ON :-
CHD	Sd / =	4 x 5 M 1C-U1	Cb3304-01-8cb
APPD	Sd / =	GOST 6850-73	
DATE	29.8.1987	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE:-	1 : 1	AVADI	
DIMENSIONS IN mm		TITLE :-	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69		PACKING RING PISTON	
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
ISSUE	DATE		3304-06-9