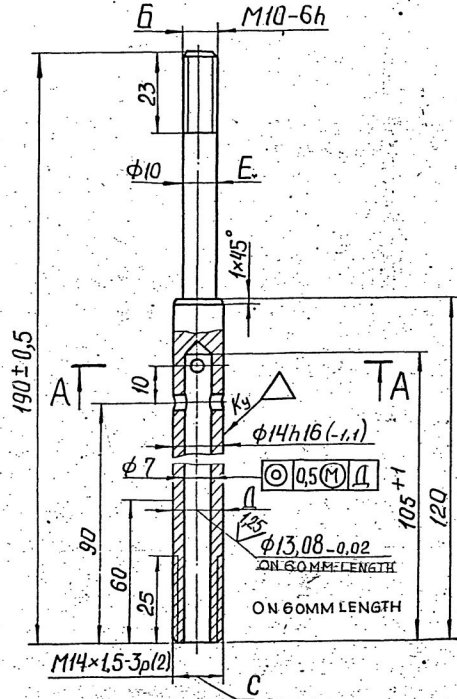


DRAWING NUMBER
20-29-16-7

Rz.80



EXPLANATORY NOTE:-

MATERIAL QUOTED : 45XGOST 4543-71

45X = GRADE OF STEEL.

CHEMICAL COMPOSITION %:

CARBON = 0.41 - 0.49

SILICON = 0.17 - 0.37

MANGANESE = 0.50 - 0.80

CHROMIUM = 0.80 - 1.10

PHOSPHORUS = 0.035

SULPHUR = 0.035

COPPER = 0.30

NICKEL = 0.30

MAXIMUM

MECHANICAL PROPERTIES:

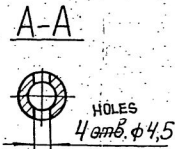
ULTIMATE TENSILE STRENGTH $\text{Kgf/mm}^2 = 105 \text{ (MIN)}$

% RELATIVE ELONGATION = 9 (MIN)

YIELD POINT $\text{Kgf/mm}^2 = 85 \text{ (MIN)}$

% REDUCTION ACROSS SECTION = 45 (MIN)

IMPACT STRENGTH $\text{Kgf.m/cm}^2 = 5 \text{ (MIN)}$



NOTE:-

1. NON-INDICATED LIMIT DEVIATIONS OF DIMENSION:

H14, h14, $\pm \frac{IT14}{2}$

2. COATING: μ_3 xp. COATING ABSENCE IS ALLOWED ON THE THREAD AND ON INNER SURFACES.

3. MAKE C THREAD TO GOST 4608-81.

4. WHILE MAKING B THREAD BY ROLLING IT IS ALLOWED TO MAKE E DIMENSION EQUAL TO AVERAGE THREAD DIAMETER.

5. K23 COATING IS ALLOWED.

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

EST. WT. 0.14 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.

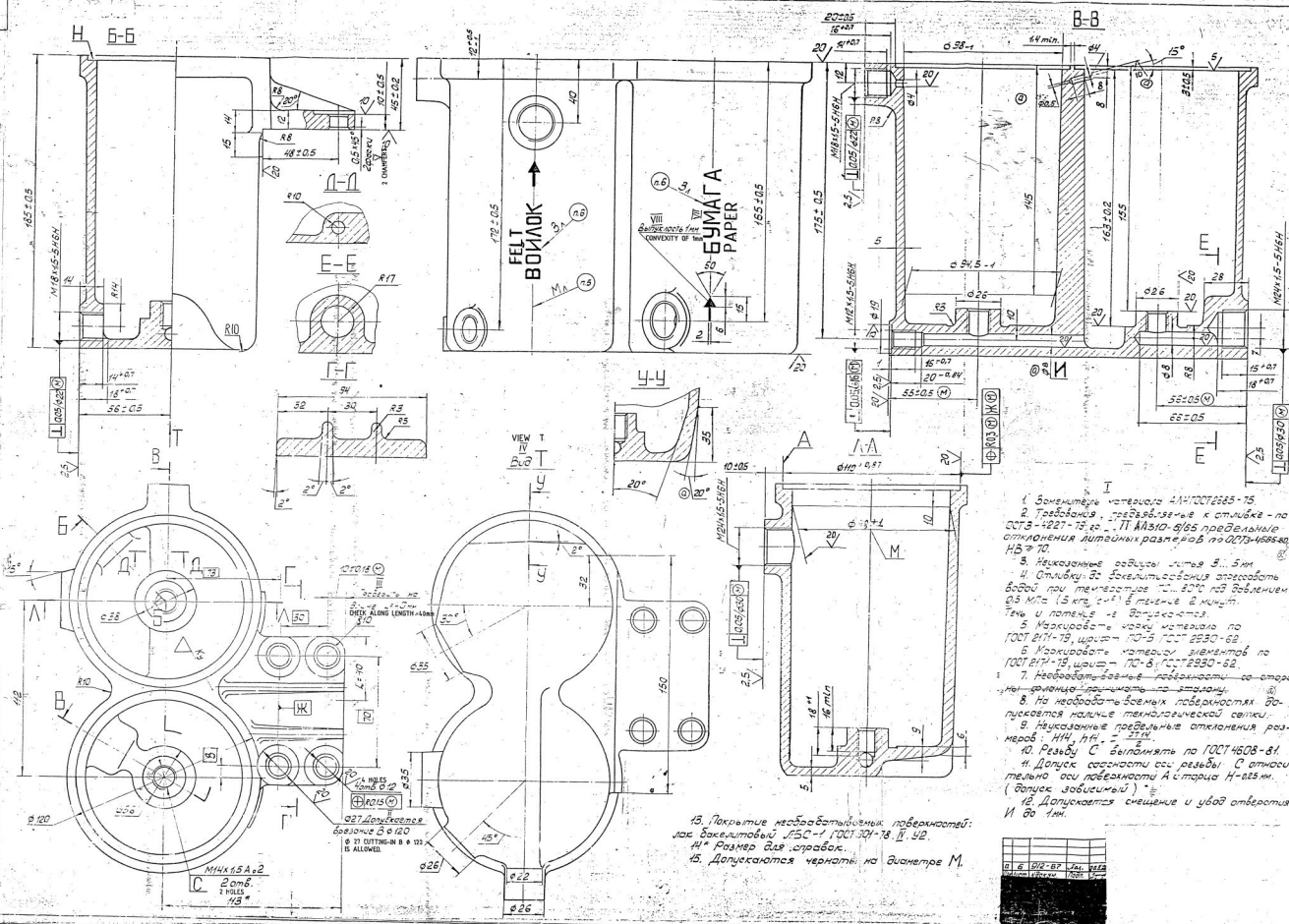
DRN	CHD	TCO	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	ALL THREADS TO CONFORM TO	ISSUE	DATE	NATURE OF AMENDMENTS
				23-9-86	1:1						
MATERIAL :- 45X GOST 4543-71						USED ON CB 20-29-08-8					
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)						A V A D I					
TITLE : COUPLING ROD						D S CAT NUMBER					
DRAWING NUMBER 20-29-16-7											

SUPERSEDES DRG. NO. 20-29-16-6, AUTHY NOTN. NO. 010-86.

EXPLANATORY NOTE ADDED ON 21-3-92

SIZE A2





1. Substitutes A/V GOST 2609-75.
2. Requirements for the coating are according to GOST-1207-75 group 1, T1 A4310-9/05 limit deviations of coating dimensions are according to GOST-4565-80, 15 H270.
3. Non-indicated coating radiuses are 3...5 mm.
4. Before hobbiting subject the coating to a water pressure test under the pressure of 0.5 MPa(5 kgf/cm²) at the temperature of 70...80°C for 5 minutes. Leakage and smearing are not allowed.
5. Mark the material mark according to GOST 2171-75, IIO-5 type, GOST 2030-65.
6. Mark the elements material according to GOST 2171-75, IIO-0 type, GOST 2030-65.
8. Manufacturing set is allowed on non-working surfaces.
9. Non-indicated limit deviations of dimensions: H14, H16, H21M.
10. Make thread C according to GOST 6608-61.
11. Tolerance of concentricity of C thread axis relative to A surface and B face is 0.15 mm. (Tolerance is dependent one).
12. Displacement and run-off of M hole is allowed up to 1 mm.
13. Coat of non-working surfaces phenol-formaldehyde lacquer АФ-1, GOST 901-78, XI, 12.
14. Dimension for reference.
15. Nonchances on B diameter are allowed.

1. Диаметр материала АМ12072605-75
 2. Требования к обработке к отливке по ГОСТ-4227-75, к ПММА-9/05 по указанным отклонениям литых размеров по ГОСТ-16888-80, H5-70.
 3. Указанные радиусы кривых R...5mm
 4. Обработка поверхности материала вазой по температуре 120°C под давлением 0,5 МПа (5 кгс/см²) в течение 5 минут. Течи и потеки не допускаются.
 5. Обрабатывать корпус материала по ГОСТ 2171-75, шлицы по ГОСТ 2290-62.
 6. Обрабатывать материал элементов по ГОСТ 2171-75, шлицы по ГОСТ 2290-62.
 7. Не допускать зазоров и шероховатости на отливке.
 8. На обработанных поверхностях допускается наличие технологической сетки.
 9. Указанные предельные отклонения размеров: H14, H16.
 10. Резьбу С выполнять по ГОСТ 6608-61.
 11. Допуск концентричности резьбы С относительно оси резьбы А1-отража H=0,15 мм. (допуск записаный).
 12. Допускается смещение и уход отверстия И до 1мм.

13. Покрытие незабываемых поверхностей: лак бакелитовый Л5С-1 ГОСТ 301-78 II, 42.
 14. Размер для справок.
 15. Допускается чертота по диаметре М.

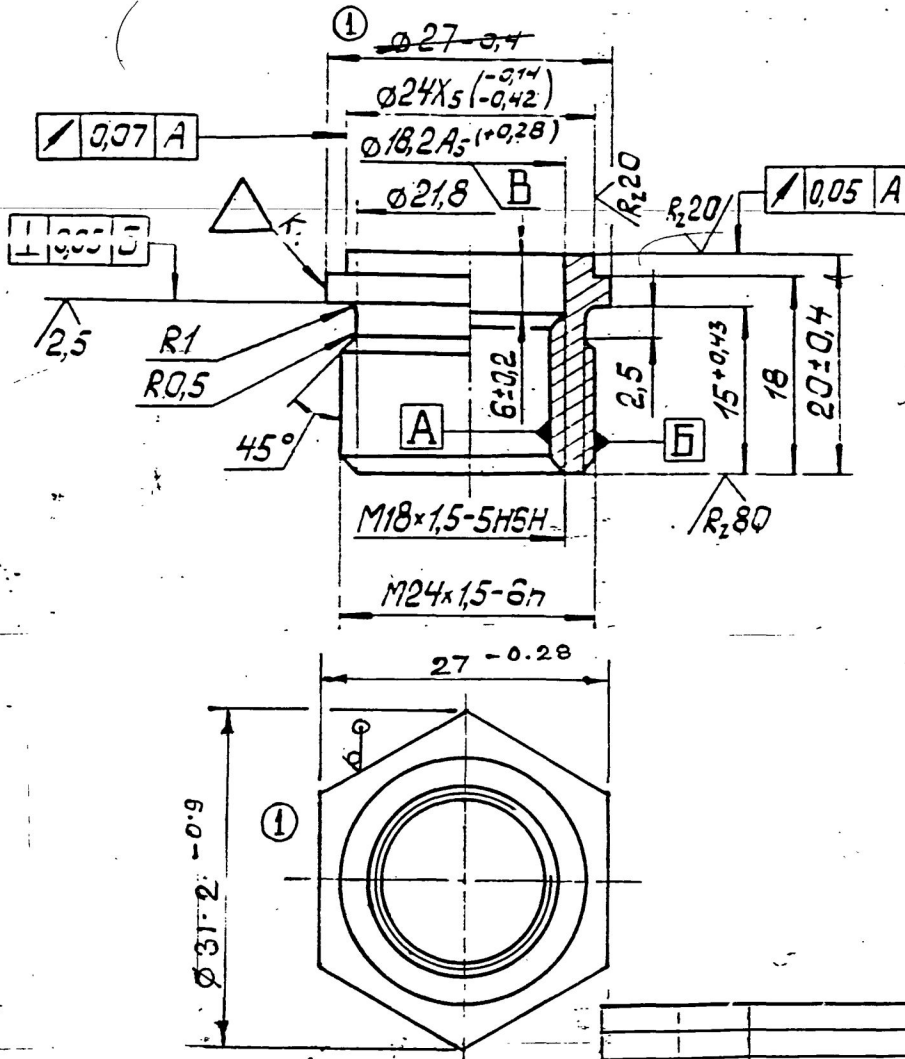
6	100	100	100
6	100	100	100
6	100	100	100

FIRST SAMPLE SHOULD BE APPROVED BY A H S P BEFORE
 BULK PRODUCTION.
 TEST MASS: TO BE STAMPED OR MARKED WHERE
 INDICATED THIS IS LETTERS.
 ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS
 OTHERWISE SPECIALLY MARKED OTHERWISE TO HAVE A RADIUS.
 SEE R INSE EQUIVALENT DIMENSIONS ARE PERMISSIBLE.

MATERIAL	AL9 GOST 3485-75	SPED ON	10-29-24-8
CONTROLLER OF QUALITY	A. V. RANCO	DATE	10-29-24-8
TITLE	FUEL FILTER CASE	DRAWING NUMBER	20-29-24-8



DRAWING NUMBER
20-29-35



1. All Matl. IS STEEL 40, 50 GOST 1050-74.
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:
FOR HOLES - AS PER A7, FOR SHAFTS - AS PER B7
FOR OTHERS - AS PER CM7
3. THREAD TRACE ON SURFACE 'B' IS PERMITTED.
4. COATING: CADMIUM-PLATED, 9 MICRONS THICK
OILED. ABSENCE OF COATING ON THE INTERNAL SURFACE IS ALLOWED.

①A EQUIVALENT MATERIAL
STEEL 080M40 (EN8) TO BS: 970 OR
45 CB TO IS: 7570

① * 27-5 GOST 8560-78
45 GOST 1051-74

KVD No. 63465

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

EST. WT. 0.03 Kg TO BE STAMPED OR MARKED WHERE
INDICATED THUS \equiv (LETTERS)

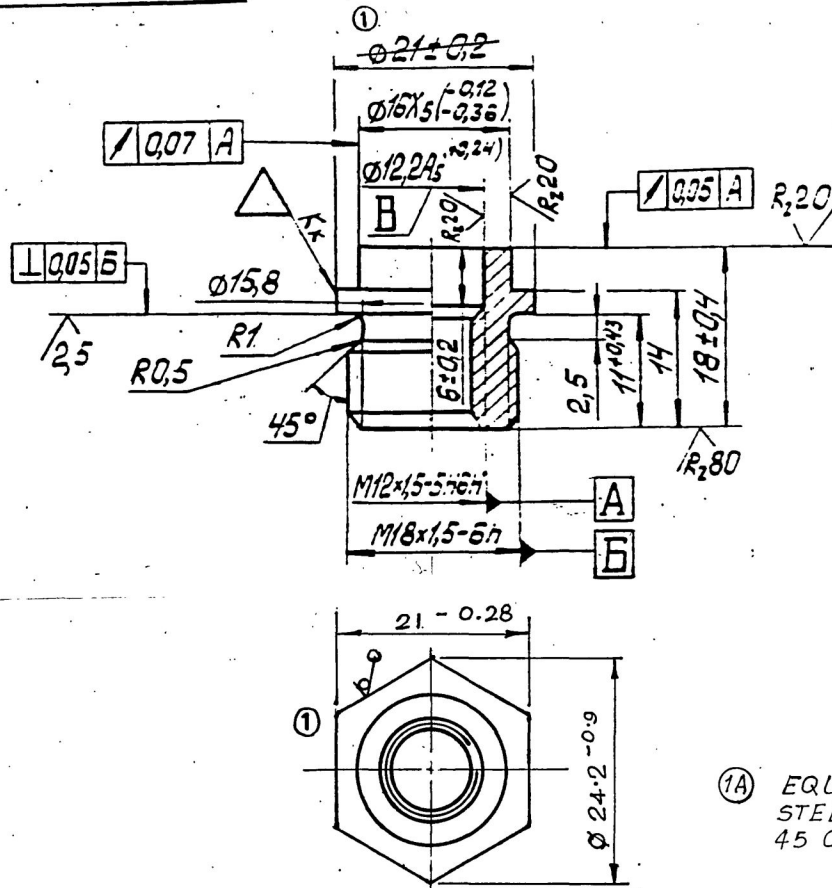
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS
OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE
INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

DATE	17-3-80	MATERIAL	Hex bar	USED ON:	C620-27-01-4
SCALE	2:1		45 GOST 1050-74 * ①		C6 20-29-08-8
ISSUE	1A	DATE	10-7-10	CONTROLLER OF QUALITY ASSURANCE HEAVY VEHICLES AVACI	
	1	DATE	16.2.01	TITLE BUSHING	
		DATE	22.9.2000	DRAWING NUMBER 20-29-35	
NATURE OF AMENDMENTS			D S CAT NUMBER		

SIZE A3



DRAWING NUMBER
20-29-36



1. Alt. Matl. IS STEEL 40, 50, GOST 1050-74.
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:
FOR HOLES - AS PER A, SHAFTS - AS PER B, OTHERS - AS PER C.
3. THREAD TRACE ON SURFACE B IS PERMITTED.
4. COATING: CADMIUM-PLATED 9 MICRONS THICK. OILED. ABSENCE OF THE COATING ON THE INTERNAL SURFACE IS ALLOWED.

(1A) EQUIVALENT MATERIAL
STEEL 080 M40 (EN 8) TO BS: 970 OR
45 CB TO IS: 1570

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

EST. WT. 0.18 kg TO BE STAMPED OR MARKED WHERE INDICATED THUS #1 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	AS	MATERIAL: ① hex bar	USED ON
CHD	AS	21-5 GOST 8560-78	CS 20-27-01-4
YCD	AS	45-B GOST 1051-73	CS 20-29-08-8
APPD	CS	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.	
DATE	28-2-01.	SCALE:- 2 : 1	
DIMENSIONS IN mm		TOLERANCE ON DRHNS UNLESS OTHERWISE STATED IS : 2102-69.	
ALL THREADS TO CONFORM TO		D S CAT NUMBER	
D S CAT NUMBER		DRAWING NUMBER	
DRAWING NUMBER		20-29-36	



SIZE A3

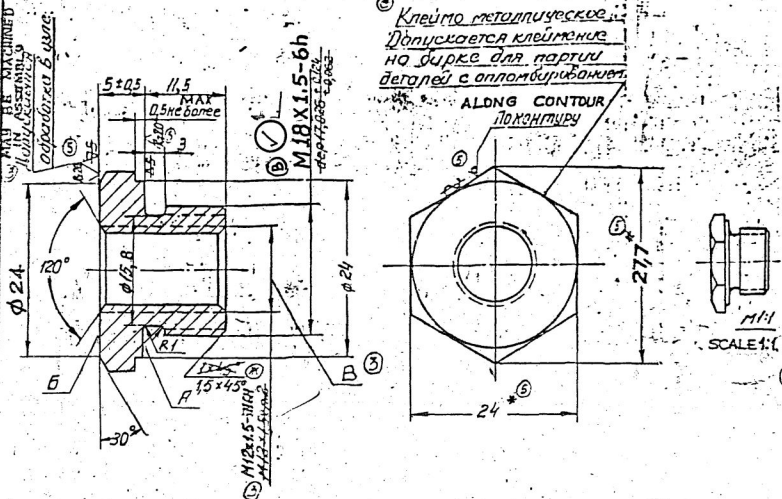


1-901-10E

TO BE PUNCHED. MARKING ON TAG FOR A BATCH OF COMPONENTS WITH PACKING AND SEALING IS PERMISSIBLE.

23. Осмотрное

Клеймо металлическое
Допускается клеймение
по бурке для партии
деталей с опломбировкой



Inspection group V
Tolerance on free dimensions are as per class 7 accuracy of OST 1010.
Tech. Requirements for thread are as per standard 82021-00.
End play on surface A relative to the axis of external thread should not exceed 0.1 mm on $\varnothing 23$. End play on surface B relative to the axis of internal thread should not exceed 0.15 mm on $\varnothing 23$. Thread dimensions are to be checked before coating, internal thread may not be coated. Sharp edges should be blunted turning of face on $\varnothing 26$ C5 is permissible. Coating is Cd 9 Cr as per 447-104 with hydrogen embrittlement removed.
Alternate material-steel grades 40 and 50, Gost 1050-74
*Dimensions for reference.

ALTERNATE MATERIAL: STEEL 080M40 (EN 8)
TO BS: 970 P.C.I-1983 OR 45 C8 TO IS: 1570

COA(HV)5.07.502E Cb 306-01-36 * C5-20-29-08-8
COA(HV)5.07.504E Cb 306-02-36 * C5-3329-01-11
Cb 337-120 * C5-3301-15-44
PILOT SAMPLE SHOULD BE APPROVED BY A.H.S.P BEFORE BULK PRODUCTION

D	9-6-09	3 rd ALTN. COMM. MINUTES POINT B. DT 27-2-09
C	9-9-08	USED ON NUMBER ADDED
B	20-5-94	REPAIR SIZES ADDED BK 82-207
A	25-10-00	AUTHY BK 85-141
ISSUE	DATE	NATURE OF AMENDMENTS
DHN	1/2	SCALE: 2:1
CHD	5/11	DIMENSIONS IN mm
ICD	9/2	TOLERANCE ON DIMMS UNLESS OTHERWISE STATED
APPD	1/1	ALL TITRATIONS TO COMPDPH 11

EST. MASS	0.022 Kg	TO BE STAMPED ON MARKED WHERE INDICATED THUS #
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE A OUTSIDE R INSIDE EQUIVALENT (CHAPPLERS ARE PERMISSIBLE)		
MATERIAL	24-5 GOST 8560-78 HEXAGON 45 GOST 1051-73	USED ON- C5 3301-15-30 *
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A D I		
TITLE	BUSH	
DRAWING NUMBER	301-106-1	

ISSUE	DATE	NATURE OF AMENDMENTS
E	5.3.14	Authy. Point No.11 of 7 th Alt. Comm. Meeting at EFA.

EXPLANATORY NOTE:-

MATERIAL QUOTED :- HEXAGONAL BAR 24-5 GOST 8560-78.
45- GOST 1051-73.

ALTERNATE MATERIAL QUOTED :- 40 AND 50 GOST 1050-74.

BRIGHT STEEL HEXAGONAL FROM GRADE 45 STEEL WITH WIDTH ACROSS FLATS 24 mm; OF ACCURACY CLASS - 5 AS PER GOST 1051-73.

CHEMICAL COMPOSITION:-

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C	Si	Mn	Cr	P	S	Cu	Ni
40	0.37-0.45	0.17-0.37	0.50-0.80	0.25	0.035	0.040	0.25	0.25
45	0.42-0.50	0.17-0.37	0.50-0.80	0.25	0.035	0.040	0.25	0.25
50	0.47-0.55	0.17-0.37	0.50-0.80	0.25	0.035	0.040	0.25	0.25

MECHANICAL PROPERTIES:-

GRADE OF STEEL	TENSILE STRENGTH	YIELD POINT	ELONGATION	REDUCTION IN AREA	IMPACT STRENGTH
	kgf/mm ²	kgf/mm ²	%	%	kgf.m/cm ²
40	58	34	19	45	6
45	61	36	16	40	5
50	64	38	14	40	4

REPAIR SIZE DIMENSIONS ARE ADDED BASED ON LETTER NO: 82847/OH/QAS/ED. DT: 27 MAR '95 AS FOLLOWS:

REPAIR SIZE DIMENSION ADDED WHERE INDICATED THUS: (checkmark)

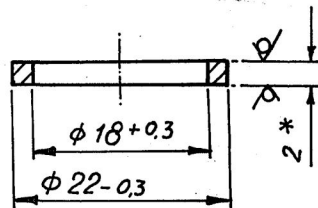
S/NO	R	REMARKS
4	M20x1.5-6h	ALL OTHER CONDITIONS AS PER STD DRG. MARK REPAIR SIZE

COMMON TO V-9252 & UTD-20 ENGINES

A-2



DRAWING NUMBER
329 30 2



1. ALTERNATE MATERIAL : COPPER, GRADES M2 AND M3 GOST 859-78.
2. TO BE ANNEALED.
3. DIMENSION FOR REFERENCE.

EXPLANATORY NOTE:

(I) REFERENCE MATERIAL QUOTED.

COPPER SHEET, COLD ROLLED Δ SQUARE SECTION OF NORMAL ACCURACY OF THICKNESS AND WIDTH 'M', SOFT 'M', THICKNESS 2mm, TO GOST 495-77 AND MANUFACTURED IN ACCORDANCE WITH COPPER GRADE M1 TO GOST 859-78.

(II) REFERENCE NOTE '1' ON ALTERNATE MATERIAL : COPPER SHEET

GRADE M2 AND M3 TO GOST 859-78.

a) CHEMICAL COMPOSITION AS PER GOST 859-78.

GRADE OF MATERIAL	CONTENT OF ELEMENTS %											REMARKS
	Cu + Ag Min	IMPURITIES (MAX)										
		Bi	Sb	As	Fe	Ni	Pb	Sn	S	Zn	O	
M1	99.9	0.001	0.002	0.002	0.005	0.002	0.005	0.002	0.004	0.004	-	Ref. Matl
M2	99.7	0.002	0.005	0.01	0.05	0.2	0.01	0.05	0.01	-	0.07	Alt Matl
M3	99.5	0.003	0.05	0.01	0.05	0.2	0.05	0.05	0.01	-	0.08	Alt Matl

b) MECHANICAL PROPERTIES AS PER GOST 495-77.

GRADE OF MATERIAL	MATERIAL CONDITION	ULTIMATE TENSILE STRENGTH Kgf/mm ²	ELONGATION % Min	HARDNESS B H N	REMARKS
M1 M2 M3	M	20 - 27	36	55	Ref. Matl Alt Matl Alt Matl

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

EST. MASS 0.0029 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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

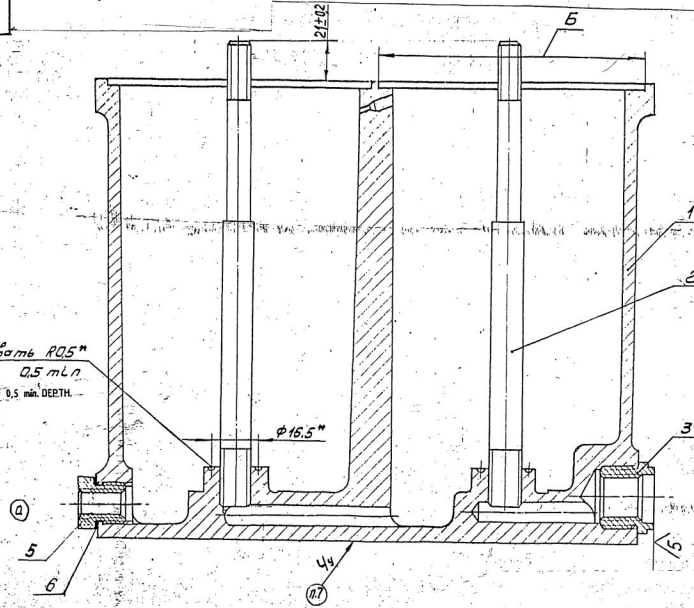
DRN	<i>[Signature]</i>	MATERIAL - SHEET	USED ON 13
CHD	<i>[Signature]</i>	Δ Π PH M2 M1 GOST 495-77	(63329 00 #)
TCO	<i>[Signature]</i>	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APPD	<i>[Signature]</i>	DATE 02.06.86	
SCALE	2:1	TITLE:- GASKET	
DIMENSIONS IN mm		D S CAT NUMBER	
TOLERANCE ON DIMS UNLESS OTHERWISE STATED.		DRAWING NUMBER 329 30 2	
ALL THREADS CONFORM TO		AUTHY. NOTN. NO. BK 81-406	
ISSUE DATE	15-2-88	NATURE OF AGREEMENTS	

(A8)

SIZE A3

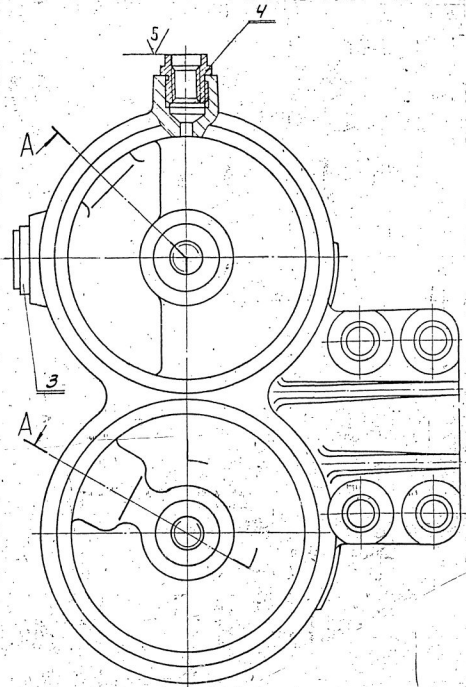


II
Заболцевать R0,5"
глубиной 0,5 мм.
ROLL R 0.5" OF 0.5 mm DEPTH.



1. После постановки втулок (детали 3,4)
"внутреннюю" резьбу втулок калибровать.
2. Допуск перпендикулярности торцов
втулок к среднему диаметру резьбы не более
0,05 мм (допуск зависимый) на φ15 мм (деталь 4)
и на φ23 мм (деталь 3).
3. Допускается подторцовка глубиной 0,1...0,5 мм.
4. На сопрягающиеся с корпусом фильтра
торцы втулок (детали 3,4) и прилегающие
к ним 2...4 нитки резьбы нанести лак 33Ш
по инструкции И240-280/75.
5. Допуск соосности оси стержня и оси
ступени ФБ не более 0,5 мм - допуск зависи-
мый.
6. Размеры обеспечить инструментом.
7. Маркировать обозначение узла в дол-
ности шрифтом П0-3 ГОСТ 2930-62.

1. Calibrate the internal thread of bushings after their mounting (parts 3,4).
2. Tolerance of squareness of bushings faces to the pitch diameter is not more than 0,05 mm (tolerance is dependent one) for φ 15 mm (part 4) and for φ 23 mm (part 3).
3. Facing h 0.1...0.5 mm is allowed.
4. Apply 33Ш lacquer on bushings faces (parts 3,4) mated with the filter case and 2...4 threads of a screw adjoining to them, by И240-280/75 manual.
5. Tolerance of concentricity of the rod axis and step axis φ B is not more than 0,5 mm - tolerance is dependent one.
6. Dimensions are ensured by a tool.
7. Mark the unit designation when sending as spare parts by П0-3 type, GOST 2930-62.



DRG. INDANISED BASED ON RUSSIAN ORIGINAL ISSUE-a. (312-87)

DRG. SUPERSEDES Cb 20-29-08-7. MAKE: 1982-02-83

2	2	9/2-87	1/14	10/28
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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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	TCO	APPO	DATE	SCALE	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2002-69	ALL THREADS TO CONFORM TO	MATERIAL	USED ON	CONTROLLER/DATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	A V A D I	TITLE	DRAWING NUMBER
				16 AUG 89	1:1				Cb 20-29-08-8			FUEL FILTER BODY	Cb 20-29-08-8



