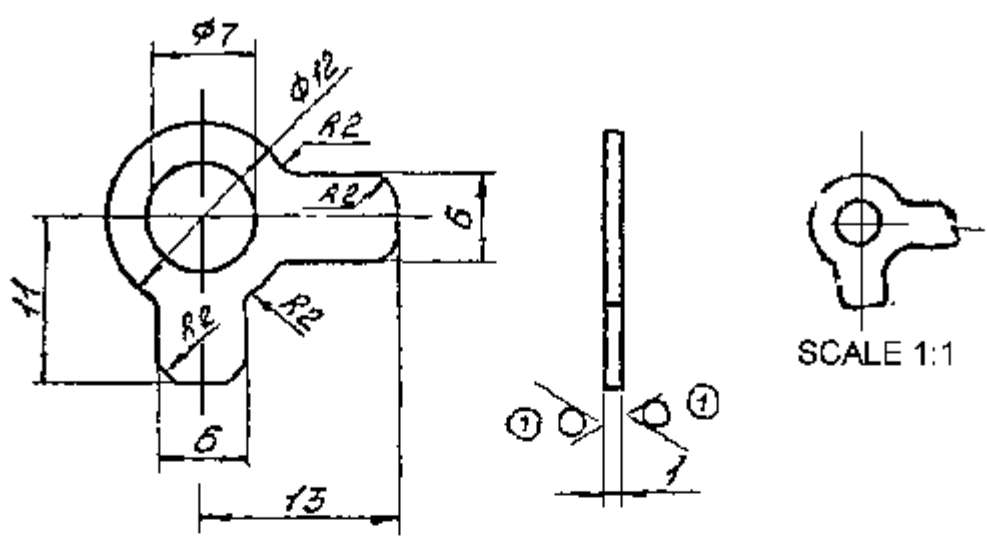


11-353

R280  
 ✓ (M)

дубликат №4



SCALE 1:1

TECH. CONDITIONS

1. Requirements to stamping - in compliance with standard 82050-16.
2. Straighten after stamping.
3. Burrs are not tolerable.
4. Coating: zinc <sup>Plated 15 micron thick</sup> 15 Cr according to ~~MM483-82~~ DR. GRADE B (Zn-15) TO IS 1573-60 WITH REMOVAL OF HYDROGEN EMBRITTLEMENT
5. Coating for tropicalized version - cadmium 9 Cr according to MM-104 OR CDE TO IS 1572-69 WITH REMOVAL OF HYDROGEN EMBRITTLEMENT.
6. EQ. MATERIAL (A) COLD ROLLED STEEL STRIP GRADE D TO IS 4030-73

00770-ICV	(A)	EQ. MATERIAL ADDED.
Removed 44-2000	<i>[Signature]</i>	
DC(I) No. & DATE	ISSUE	AMENDMENTS

APPROVED *[Signature]*  
 CHECKED *[Signature]*  
 CONTROLLERATE  
 OF  
 QUALITY ASSURANCE  
 (ICV)

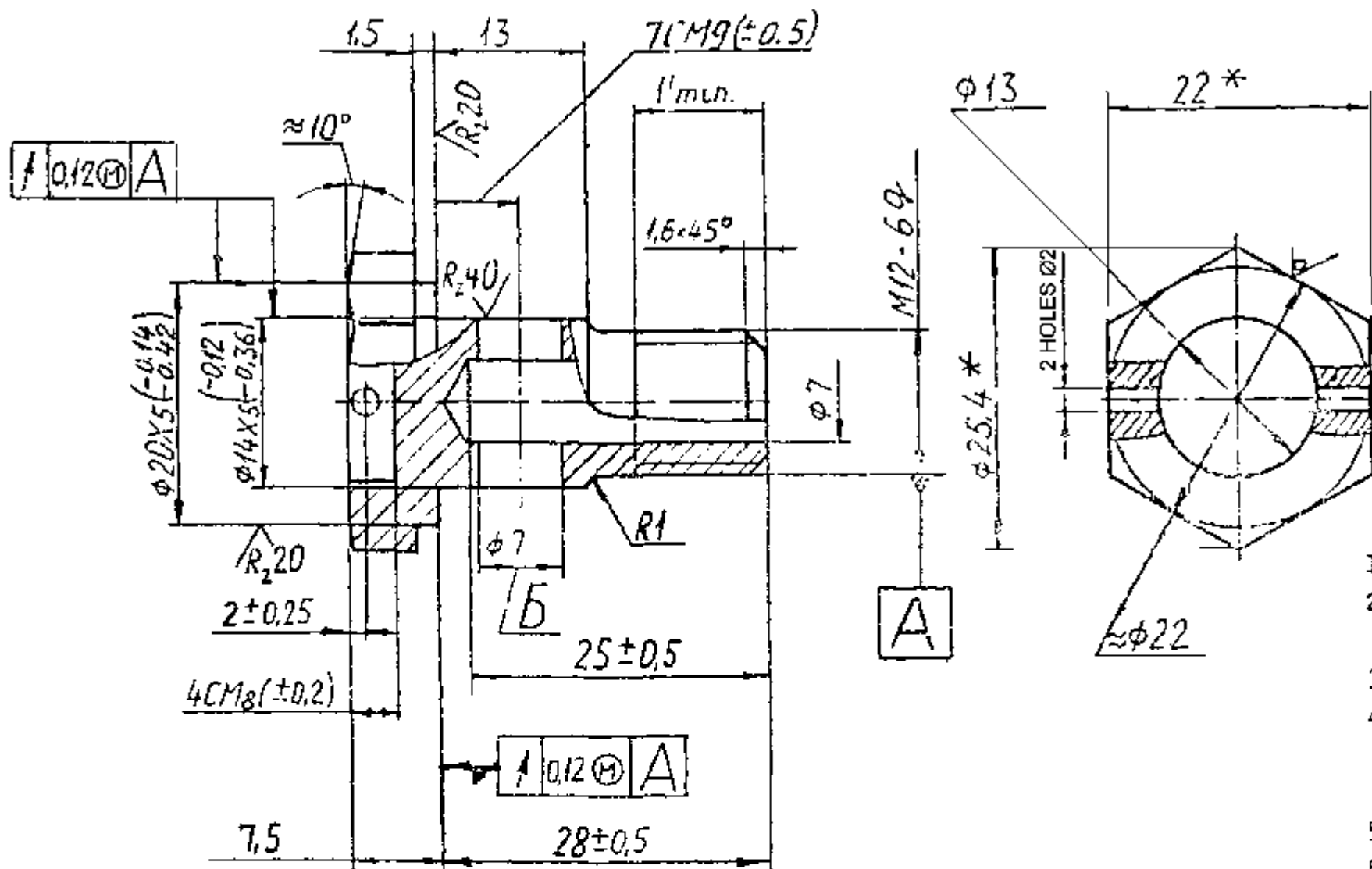
353-11

LOCK WASHER 7

BAND 08nc-M-2-1, GOST 503-81

	WEIGHT	SCALE
	0.0011	2:1
SHT 1	SHTS 1	

672-28-55



**TECHNICAL CONDITIONS**

1. HB 302 to 255 (Ø 3.5 to 3.8).
2. Isothermic heating HB 444 to 369 (Ø 2.9 to 3.2) is allowed. Check sizes before thermal treatment.
3. Substitute for material - steels 40X, 45X ГОСТ 4543-71.
4. Unspecified limit deviations of sizes: for holes - according to A<sub>7</sub>; for shafts - according to B<sub>7</sub>; others - according to CM<sub>8</sub>.
5. Location of holes B relative to hexahedron is arbitrary.
6. Coating: chemically oxidized oiled or chemically oxidized phosphatized oiled.
7. \* Sizes are given for reference.

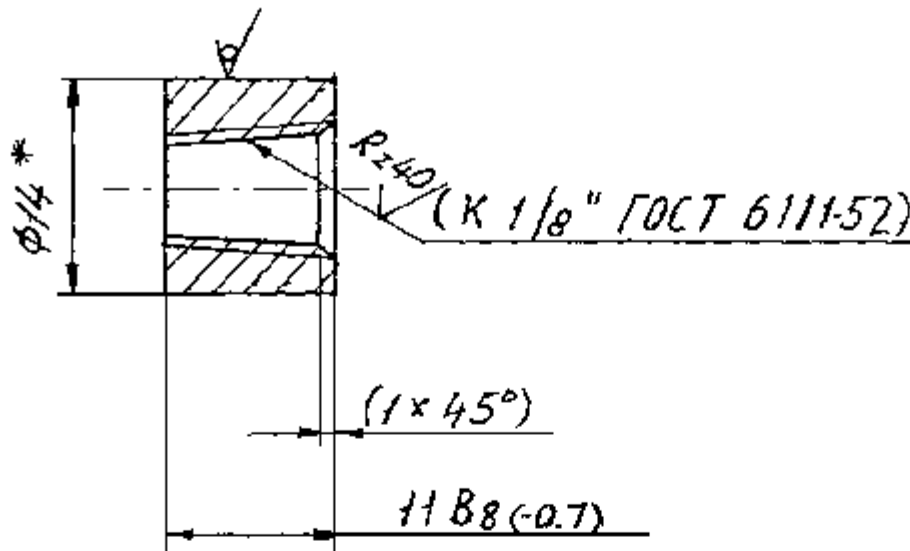
(A) EQ. MATERIAL: - HEXA. BAR, 40X ГОСТ 4543-71 OR EN 19A TO BS 970.

00780-ICV V. Romanov 26-04-2000	(A) Cura	EQ. MATERIAL ADDED
DCO) No. & DATE	ISSUE	AMENDMENTS

APPROVED <i>[Signature]</i>	<p><b>672-28-55</b></p> <p><b>CLAMP BOLT</b></p>		
CHECKED <i>[Signature]</i>			
<p>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</p>	<p>WEIGHT SCALE</p> <p>0.11 2:1</p>		<p>SHT 1 SHTS 1</p>
	<p>HEXAHE- 22-5 GOST 8560-78 DRON: 38XC-B-M-T-2 GOST 4543-71</p>		

672-51-40

Rz 80/ (✓)



**TECHNICAL CONDITIONS**

1. Alternate material is steel 15,25, GOST 1050-74.
2. Dimensions given in brackets are after assembly.
3. \* Dimension is given for reference.

(A) EQ. MATERIAL: - (A) - ROUND BAR, C-20 TO IS: 2073-70

00770-ICV	(A)	EQ. MATERIAL ADDED.
V. Koval	<i>[Signature]</i>	
4 APR 2000		
ICV(I) No. & DATE	ISSUE	AMENDMENTS

APPROVED **M. VASU**

CHECKED *After* **D. S. KUMAR**

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

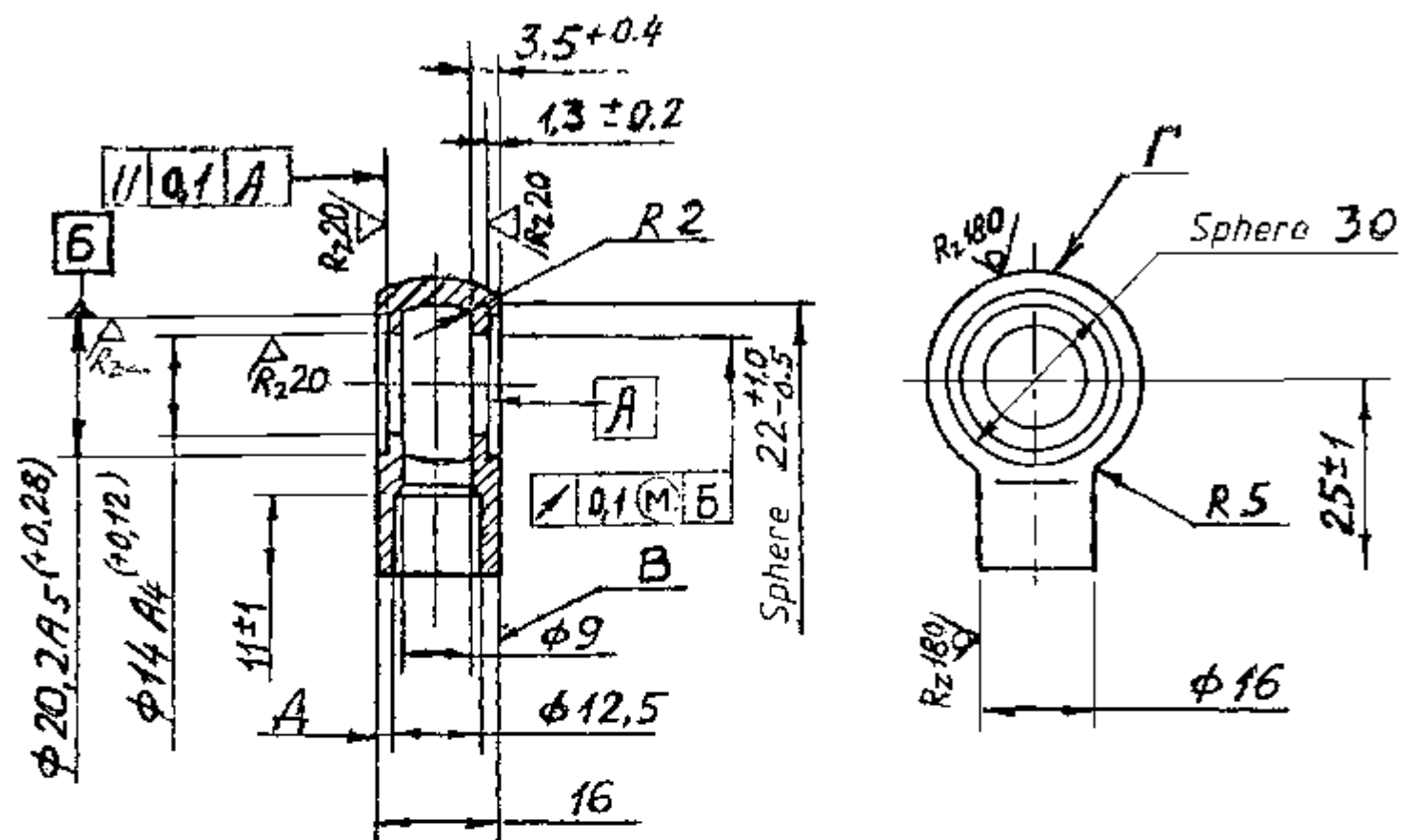
**672-51-40**

**BOSS**

WEIGHT	SCALE
0.007	2:1

SHT	SHTS
-----	------

ROUND BAR 14-5 ГОСТ 7417-75  
20-3 ГОСТ 1051-73



10. On machined surfaces, except for locating surfaces, cavities and other local defects with maximum measuring area of 2mm, to depth not exceeding 1/5<sup>th</sup> wall thickness, not more than 1 cavity per 3cm<sup>2</sup> of each surface are allowed. Distance between the cavities should be atleast 10mm.
11. Other requirements are as per OST 3-4365-79
12. Coating: Chemically parkerized, oiled.
13. Test for air tightness by covering the external surface with chalk and abundantly wetting with domestic kerosene ' GOST 4753-68 from inside kerosene traces should not appear on chalk coated surfaces. Observe for 5minutes after wetting. Check for air-tightness by feeding air in water bath at a pressure of 2kg/cm<sup>2</sup> for 1-2 minutes. Leakage of air is not allowed.

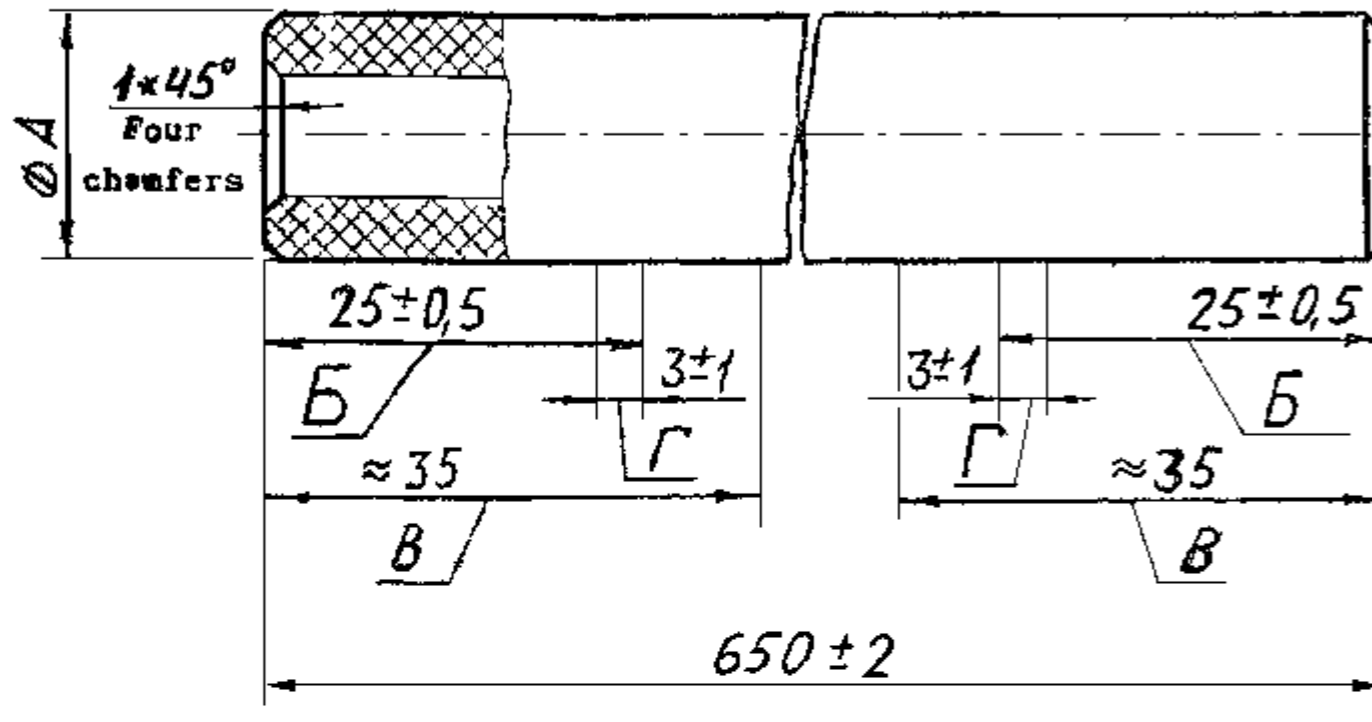
1. Alternate material is steel 25A and 35A GOST 977-75.
2. Unspecified limit deviations of dimensions for machined surfaces are as follows.  
For holes-as per A<sub>7</sub>.  
For shafts-as per B<sub>7</sub>.  
For others-as per CM<sub>7</sub>.
3. Unspecified radii should not exceed 1mm.
4. Drafts should not exceed 1°.
5. Gate residue not exceeding 2mm is allowed on surface Γ.
6. Displacement and misalignment of cylindrical shank axis with respect to plane B should not exceed 0,3mm.
7. Difference in wall thickness of dimension Δ should not exceed 0,5mm.
8. Lack of solder pattern traces to depth not exceeding 0,3mm are allowed on casting surfaces.
9. Displacement of parts contour along parting line should not exceed 0,3mm.

APPROVED		<b>672-55-6</b>	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		<b>REVOLVING ANGLE PIECE</b>	
		I OST 3-4365-79 30A, GOST 977-75	
		WEIGHT	SCALE
		0.07	1:1
		SHT 1	SHTS 1

675-10-17

**TECHNICAL CONDITIONS**

1. Break down part into categories of size A according to table Measure diameter on section 8. Mark category number on hose outer surface at distance B from end face using enamel H0-223, white 1, ГОСТ 14923-78, and type HO-8 ГОСТ 2930-62.
  2. Mark ends of hose which belong to different categories with number of respective category.
  3. On part at distance B make circular marks of approximately 20 mm long and  $\Gamma$  wide with enamel H0-223, white 1, ГОСТ 14923-78.
- EQ. MATERIAL: ENAMEL AS PER JSS 8010-1

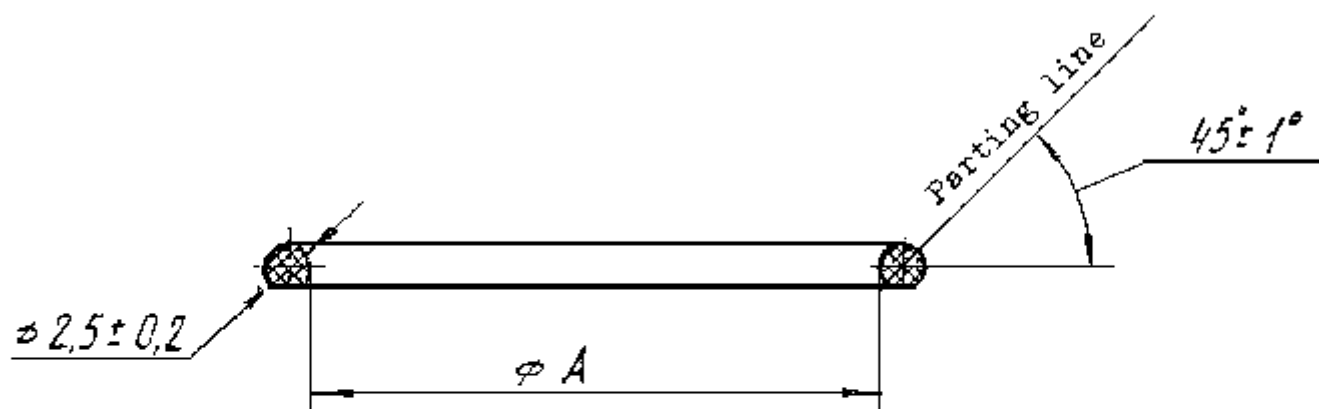


Category:	Ø A, mm
1	14.9 to 16
2	16 to 16.5

00770-ICV V. Condit A. A. 2000	(B)	EQ. MATERIAL ADDED
00017-ICV Roc-Hic 26-12-88	(A)	SPECIFICATION No IN THE MATERIAL COLUMN CHANGED FROM TY-38-0056016-79 TO READ ASTY-0056016-79
DC(I) No. & DATE	ISSUE	AMENDMENTS

APPROVED <i>[Signature]</i>	<b>675-10-17</b>			
CHECKED <i>[Signature]</i>				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	<b>HOSE</b>		WEIGHT	SCALE
			0.05	2:1
			SHT	SHTS
		SEALING HOSE 40Y 8-13(13) TY 0056016-79 (A)		

675-10-19



Designation	$\phi A$ , mm	Mass, kg
675-10-19	$37 \pm 0.6$	0.008
675-10-19-01	$69 \pm 0.8$	0.009

00770-ICV V-Ronald A.A. 2088	(A) Gum	EQ. MATERIAL ADDED
DC (I) NO DATE	ISSUE	NATURE AMENDMENT

### TECHNICAL CONDITIONS

- Sizes are ensured by means of tools.
- Seam not in excess of 0.3 mm along parting line of mould is tolerable.
- Tool marks are tolerable. Accept against test specimen.
- Make markings on tag.
- Other requirements - according to TV 005216-75 for article under code 25311.

(A) EQ. MATERIAL: - (α) RUBBER NO BA-10 TO BS 2751-82

APPROVED

675-10-19

CHECKED

WEIGHT SCALE

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

RING

SEE  
TABLE

2:1

SHT

SHTS

RUBBER B-14, TY 005216-75

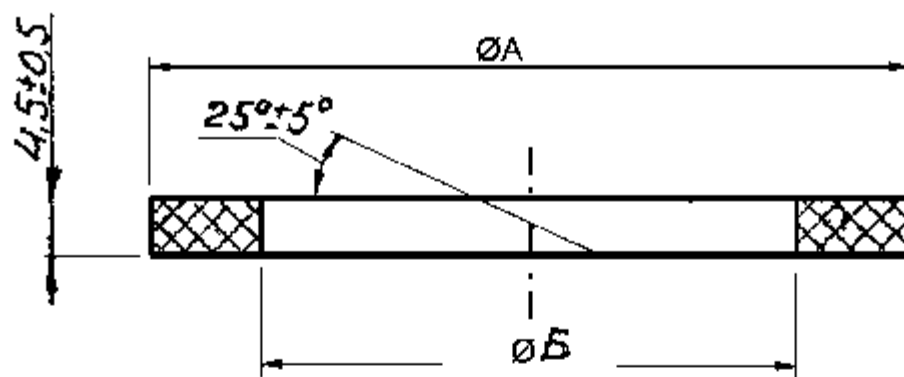
675-10-20

00770-1CV  
 Y. Romanov  
 A. A. 2.000  
 DC (E) NO  
 DATE

(A)  
 ISSUE

NATURE  
 AMENDMENT

EQ. MATERIAL ADDED



Designation	Ø A, mm	Ø B mm	Mass
(A) 675-10-20	35±0.7	25±0.7	0.0025
(A) -01	63±0.7	53±0.7	0.0061
(A) -02	62±0.7	51±0.7	0.0065
(A) -03	30±0.7	19±0.7	0.0028

### TECHNICAL CONDITIONS

- Cut glands during assembly.
- Other requirements - according to GOST 288-72.

(A) EQ. MATERIAL: - (A) WOOLEN FELT AS PER BS 4680-66

APPROVED

675-10-20

CHECKED

WEIGHT SCALE

SEE  
TABLE

2:1

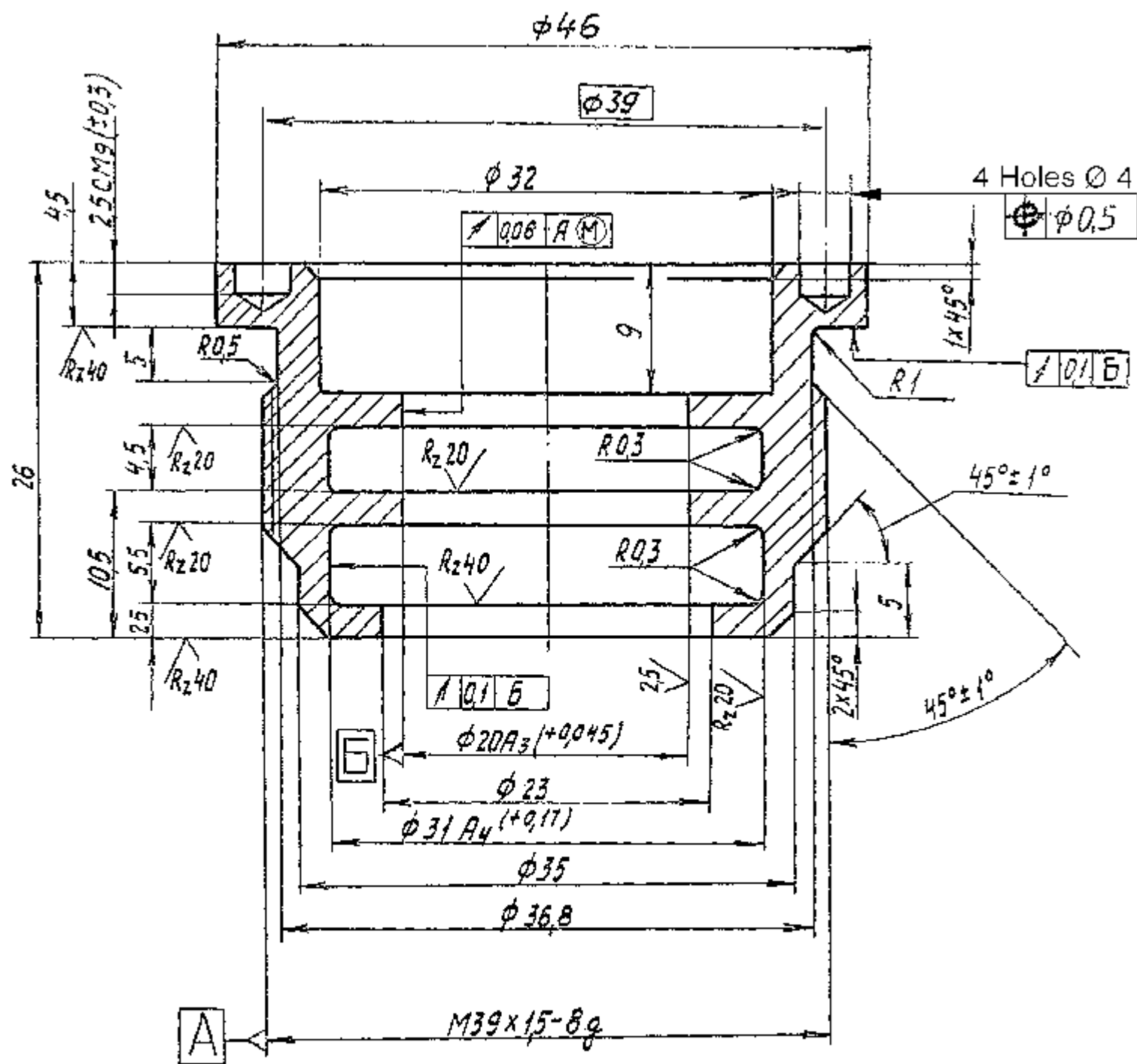
GLAND

SHT

SHTS

CONTROLLERATE  
 OF  
 QUALITY ASSURANCE  
 (ICV)

FINE WOOL FELT, GOST 288-72



**TECHNICAL CONDITIONS**

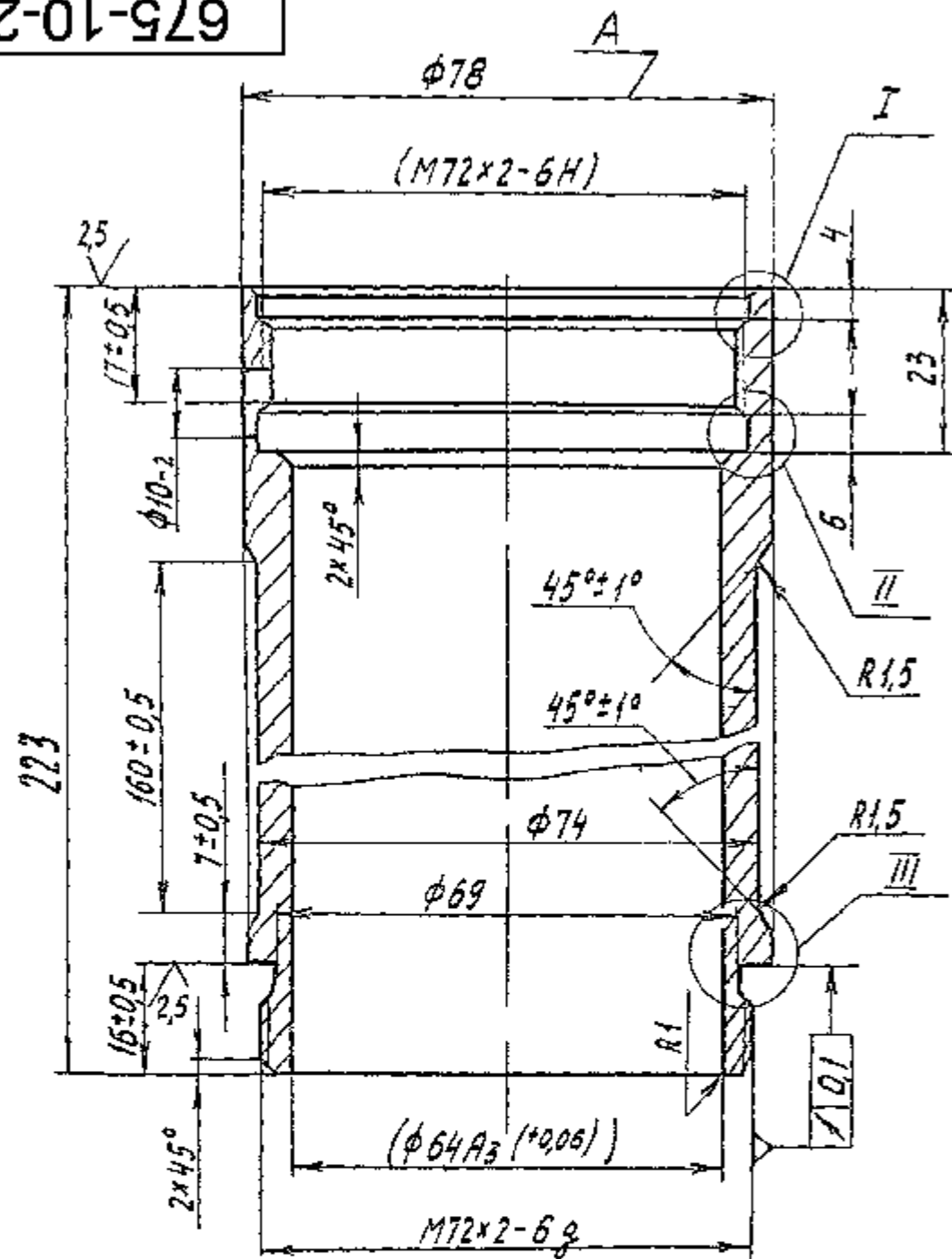
1. HB 285 to 341 (φ 3.6 to 3.3)
2. Substitute for material - steel 45X GOST 4543-71.
3. Unspecified limit deviations of sizes: for holes - according to A<sub>7</sub>; for shafts - according to B<sub>7</sub>; others - according to CM<sub>8</sub>.
4. Coating: zinc plated 9 Cr. Remove hydrogen embrittlement. Absence of coating on inner surfaces is tolerable.

(A) EQ. MATERIAL: - ALLOY STEEL 40Cr1 MO 2.8 TO IS: 5517-69

APPROVED	675-10-21		
CHECKED	HOLDER		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	WEIGHT	SCALE	
	0.12	2.5:1	
	SHT	SHTS	
	STEEL 38XC GOST 4543-71		

00780-KV V. Romanov 20-4-2000	(A) EQ. MATERIAL ADDED
DC (I) NO DATE	NATURE AMENDMENT
ISSUE	

675-10-22



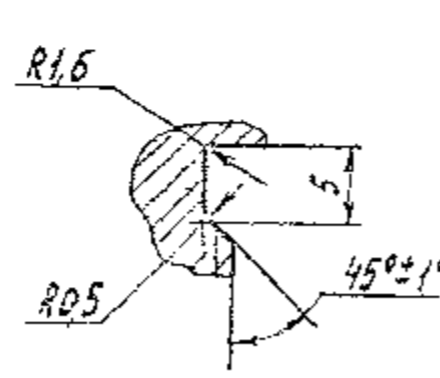
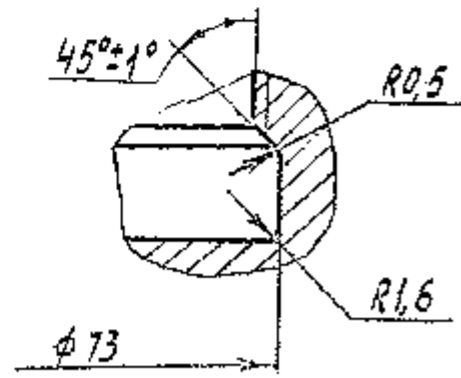
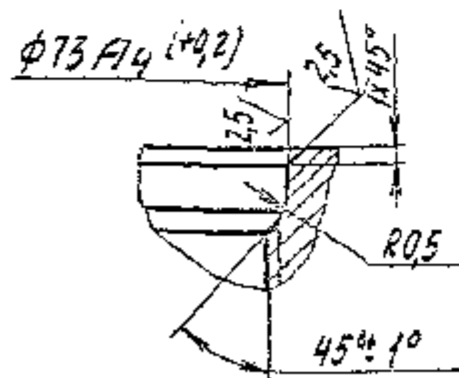
TECHNICAL CONDITIONS

- Substitute for material - steel 38XG ГОСТ 4543-71.
- Unspecified limit deviations of sizes for holes - according to A<sub>7</sub>, for shafts - according to B<sub>7</sub>, others - according to CM<sub>7</sub>.
- 3 Sizes in brackets - after assembly. It is allowed to machine all sizes when assembled, except for size A.
- Ⓐ EQ MATERIAL - Ⓐ ALLOY STEEL 40CY1 M028 TO 25:5517-69, EN-19 EN-24

I  
Scale 2:1

II  
Scale 2:1

III  
Scale 2:1



00770-ICV	Ⓐ	EQ MATERIAL ADDED
V. Kovalev	Grin	
44-2000		
DC (U) No	ISSUE	NATURE
DATE		AMENDMENT

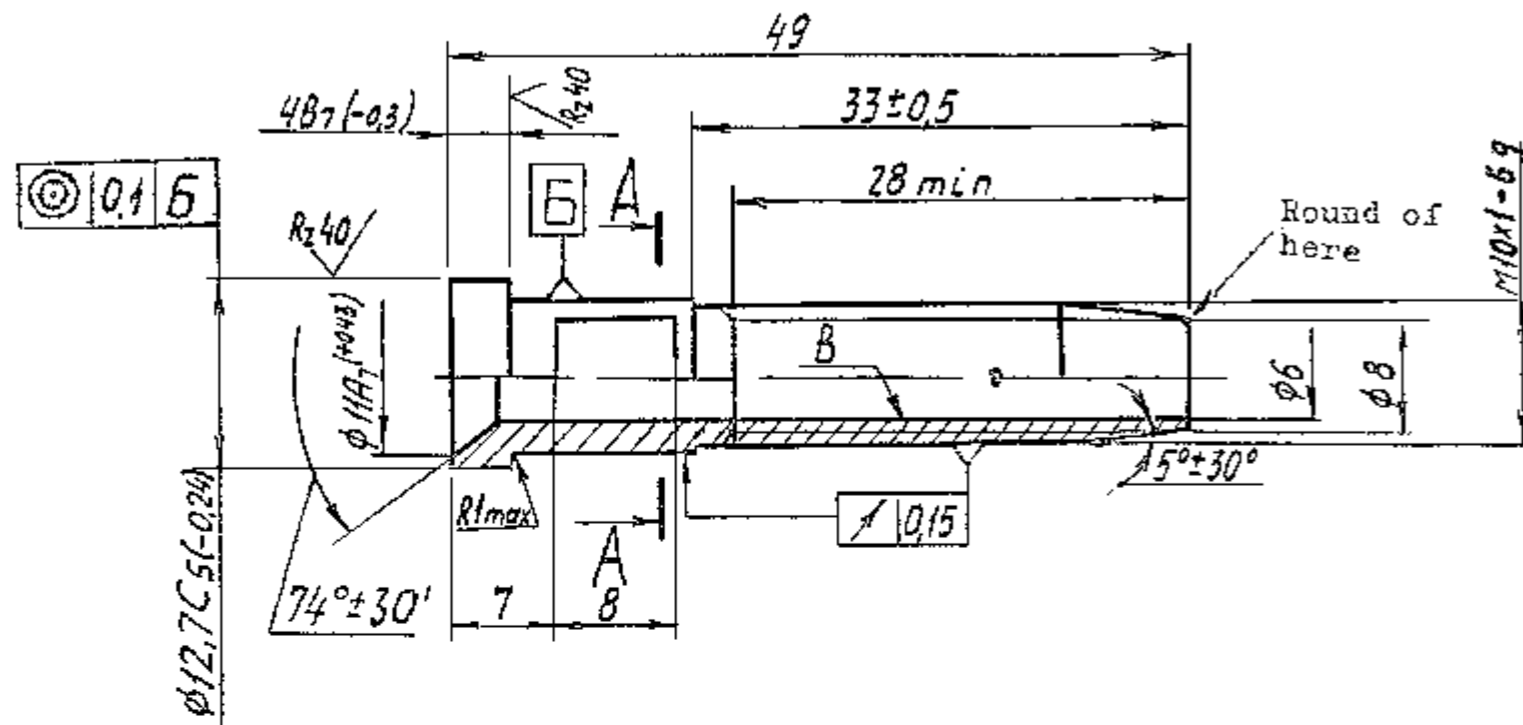
APPROVED	<i>[Signature]</i>	675-10-22	
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	STEEL 45x, GOST 4543-71	WEIGHT	SCALE
		1.75	1:1
		SHT	SHTS

675-10-23

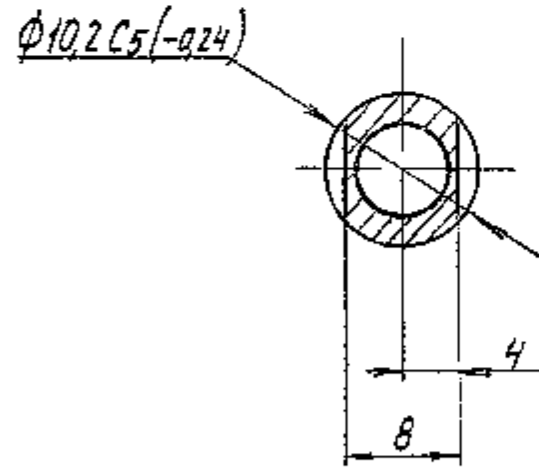
R280/ (✓)

**TECHNICAL CONDITIONS**

1. Substitute for material - steel 40 10CT 1050-74.
  2. Unspecified limit deviations of sizes for holes - according to A<sub>B</sub>, for shafts - according to B<sub>B</sub>, others - according to CM<sub>B</sub>.
  3. On surface B shoulder not in excess of 0.3 mm is tolerable.
  4. Coating zinc <sup>Plated 9 micron black</sup> & Cr Remove hydrogen embrittlement. Check sizes after coating. Absence of coating on inner surfaces is tolerable.
- Ⓐ EQ MATERIAL - (A) STEEL BAR C-45 TO IS 2073-74, EN8/EN-9



A-A

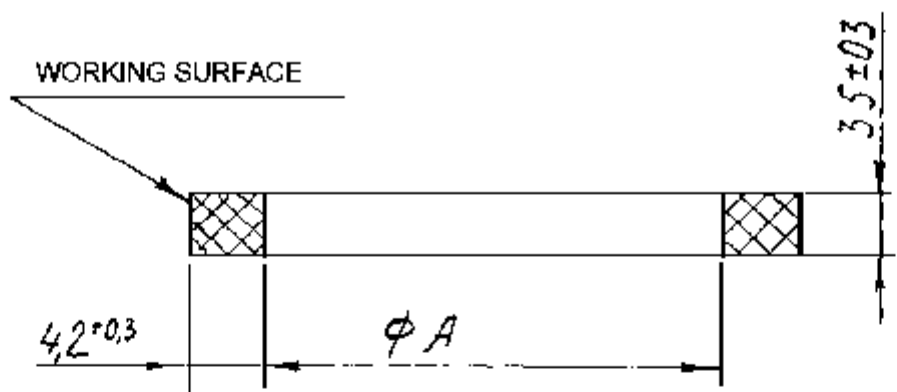


00770-12V 4 4-2000 DC(I) No. & DATE	(A) Grew	EQ MATERIAL ADDED
	ISSUE	AMENDMENTS

APPROVED	<i>[Signature]</i>	675-10-23	
CHECKED	<i>CAG</i>		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		NIPPLE	
		WEIGHT	SCALE
STEEL 45 GOST 1050-74		0.014	2:1
		SHT	SHTS

Продукт

Предназначені параметри



EQ. MATERIAL ADDED	NATURE-AMENDMENT
00780-ICV y Romo- 26 4-2000	DATE

Designation	Ø A, mm	Mass, kg
(A) 675-10-26	27.5 <sub>-0.5</sub>	0.001
(A) -01	55.5 <sub>-0.5</sub>	0.002

**TECHNICAL CONDITIONS**

1. Sizes are ensured by means of tools.
2. Make marks on tag.
3. Other requirements - according to TY 005216-75 for articles under code 253113.

(A) EQ. MATERIAL - NITRILE BA-70 BS-2151-82

APPROVED *[Signature]*

CHECKED *CNG*

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

675-10-26

RING

RUBBER 51-3029  
TY 005216-75

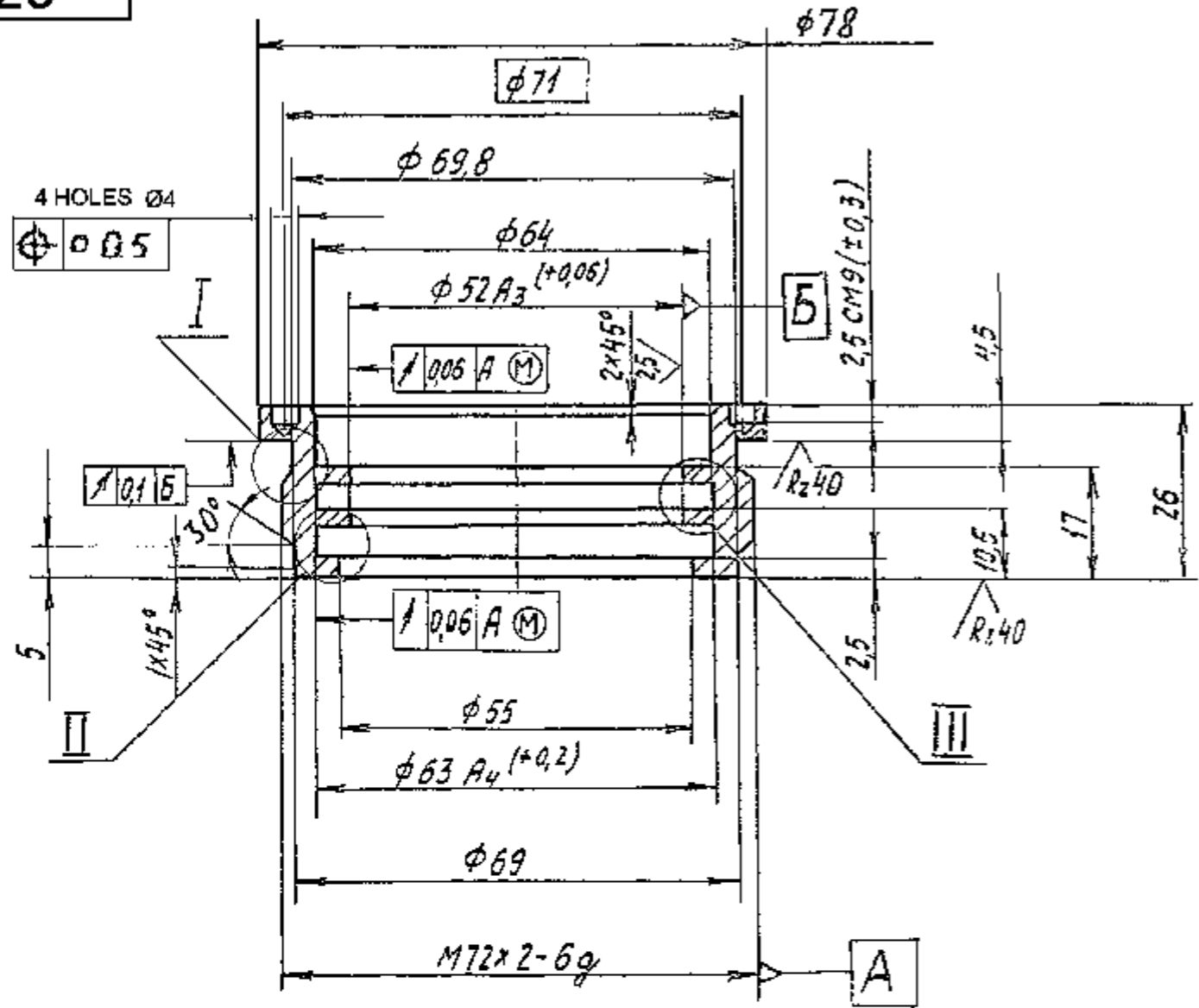
WEIGHT SCALE

SEE TABLE 2:1

SHT SHTS 1

675-10-27

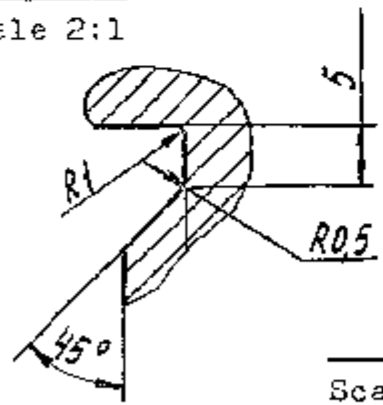
Rz 80  
✓(✓)



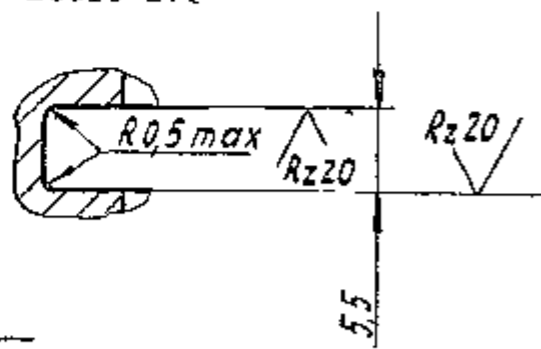
**TECHNICAL CONDITIONS**

1. HB 235 to 341 (σ 3.6 to 3.3)
  2. Substitute for material - steel 45X ГОСТ 4543-71.
  3. Unspecified limit deviations of sizes for holes - according to A<sub>7</sub>, for shafts - according to B<sub>7</sub>, others - according to CM<sub>8</sub>
  4. Coating zinc + Cr. Remove hydrogen embrittlement. Absence of coating on inner surfaces is tolerable.
- Plated by micron thick—  
 (A) EQ MATERIAL - ALLOY STEEL 40 Cr 1 TO IS:5517-69

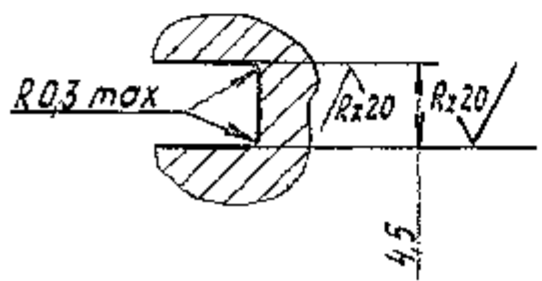
I  
Scale 2:1



II  
Scale 2:1

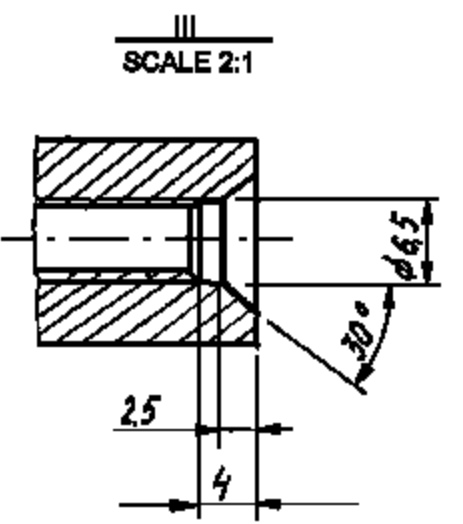
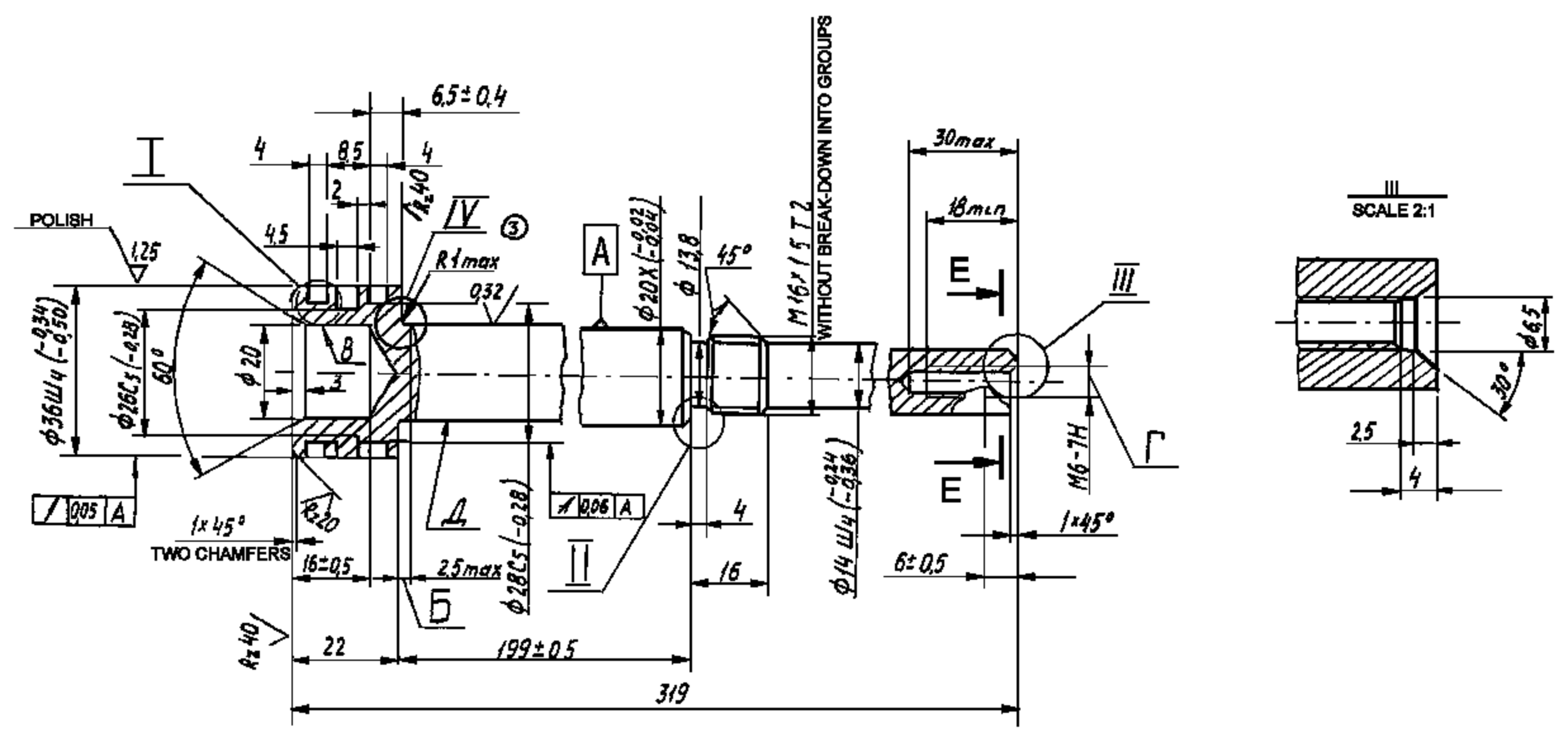


III  
Scale 2:1

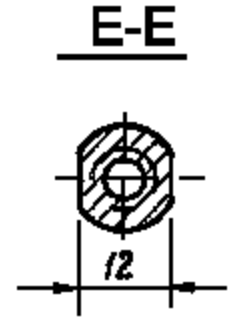
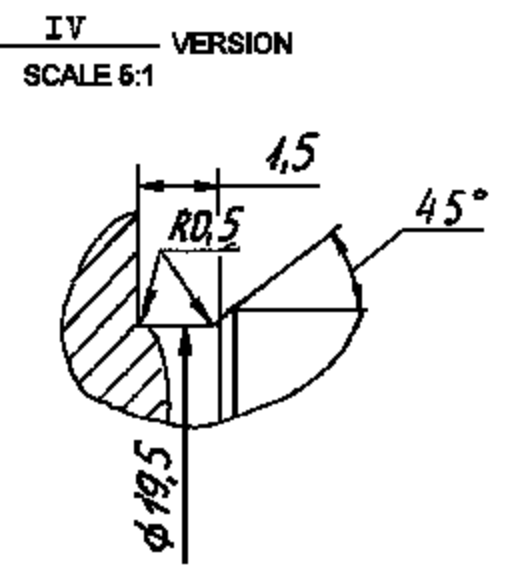
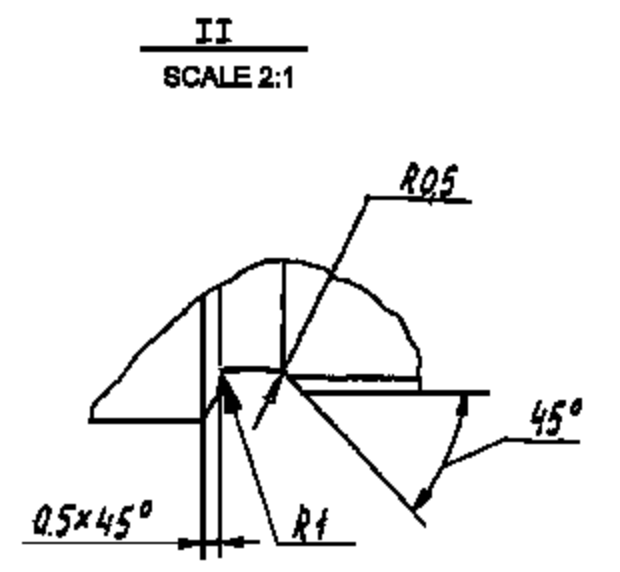
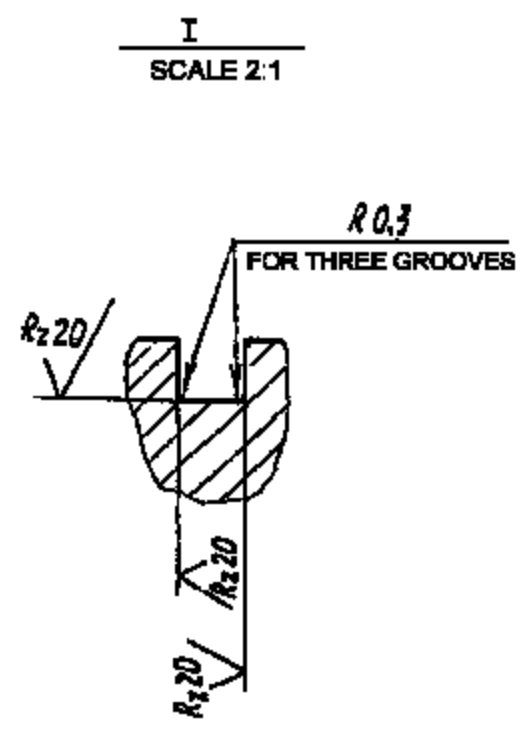


DOYBO-ICV v Romanov 26-4-2000	(A) Issue	EQ MATERIAL ADDED
DC(I) No. & DATE	ISSUE	AMENDMENTS

APPROVED		675-10-27	
CHECKED	CMG		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	HOLDER	WEIGHT	SCALE
		0.2	1:1
STEEL 38xC GOST 4543-71		SHT	SHTS

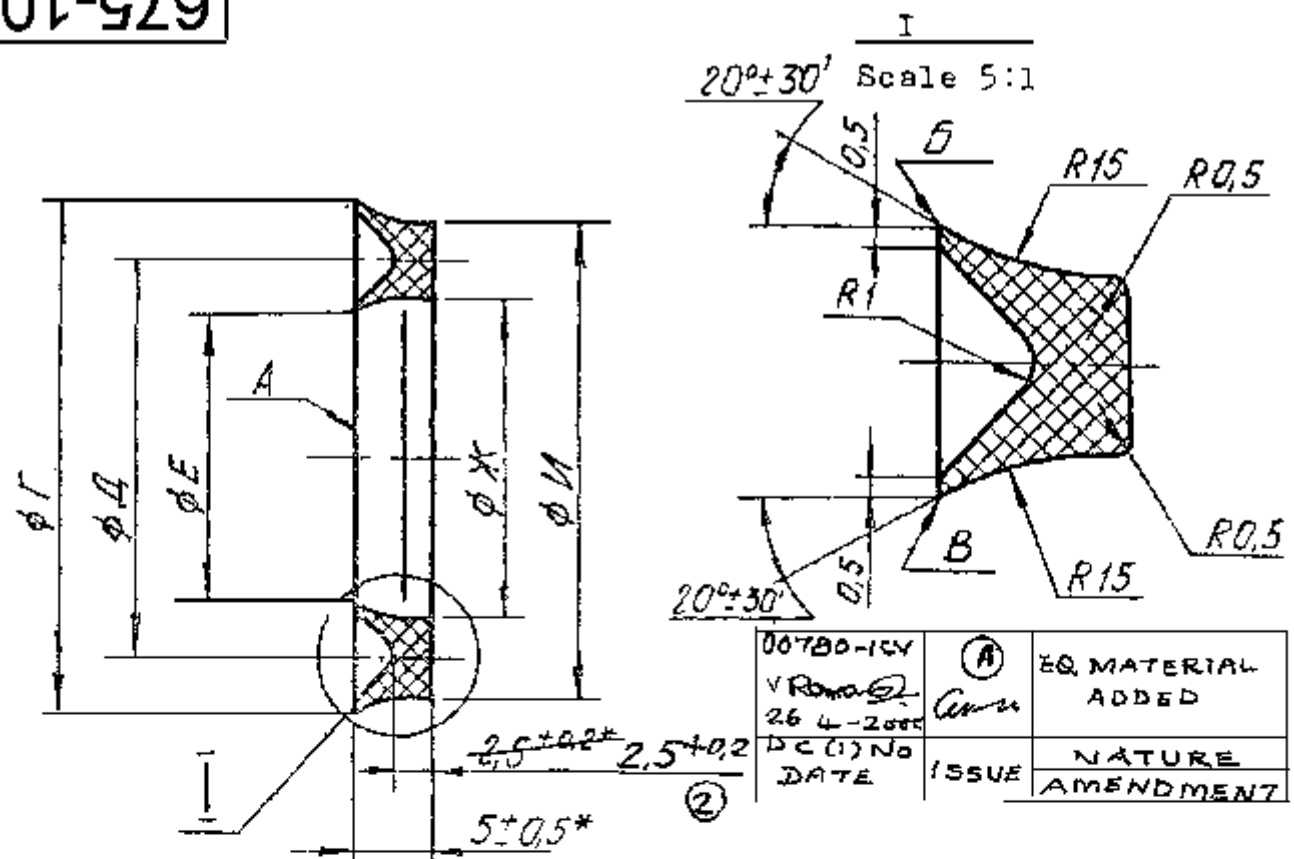


- TECHNICAL CONDITIONS**
1. HB 255 to 302 ( $\phi$  3.8 to 3.5)
  2. Unspecified limit deviations of sizes: for holes - according to A<sub>7</sub>; for shafts - according to B<sub>7</sub>; angular -  $\pm 1^\circ$ ; others - according to CM<sub>3</sub>.
  3. Coating of surface I: Cr 9 ... 60 microns by powder process. Check sizes after coating. Coating of other surfaces: Ch. ex. Cr pltd. oiled. Absence of chromium on section E and absence of coating on thread F and surface B are tolerable.
- Ⓐ EQ. MATERIAL: ALLOY STEEL 40CY1 M0 2 B TO IS: 5517-69



00780-ICV	Ⓐ	BQ. MATERIAL ADDED.
26-4-2000	ISSUE	AMENDMENTS
DC (ING. & DATE)		

APPROVED <i>[Signature]</i>	675-10-28		
CHECKED <i>[Signature]</i>			
CONTROLLERATE OF QUALITY ASSURANC (ICV)	ROD	WEIGHT	SCALE
		0.72	1:1
		SHT	SHTS
	STEEL 45x GOST 4543-71		



00700-ICV V.Roman 26.4-2000 DC (1) No DATE	① Amu	EQ. MATERIAL ADDED
	ISSUE	NATURE AMENDMENT

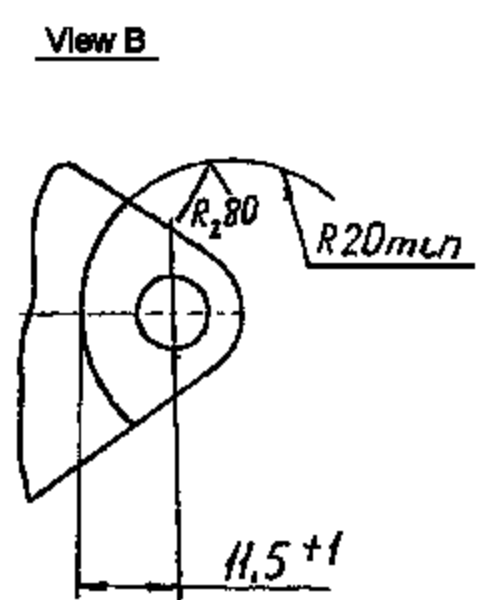
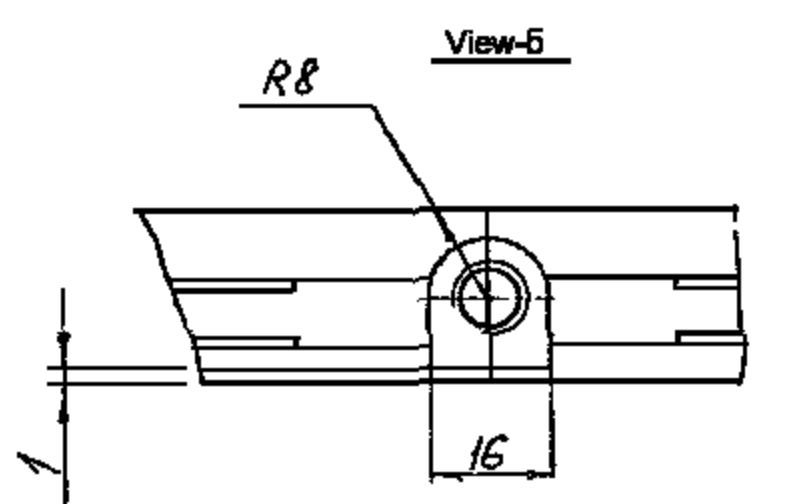
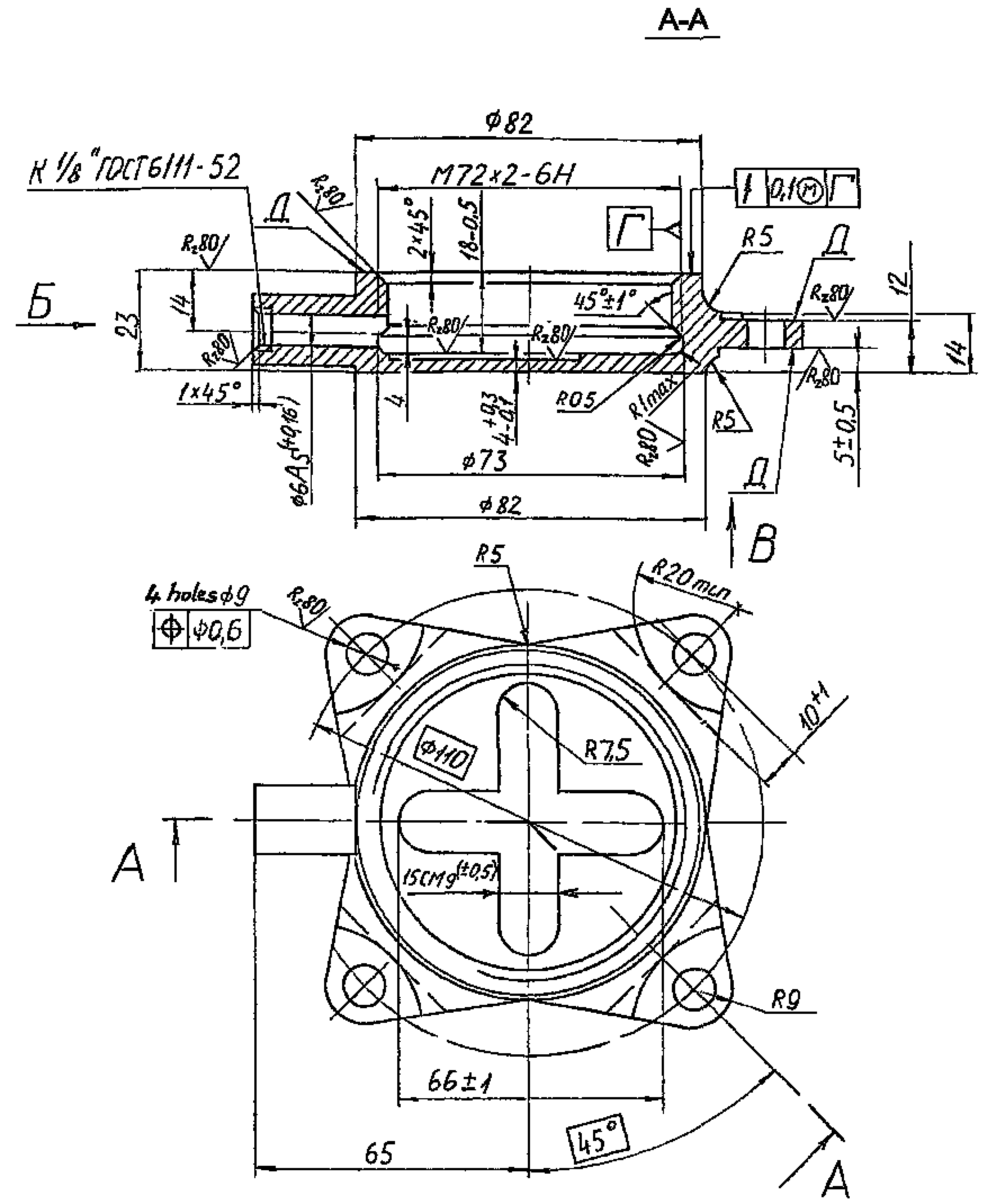
Designation	Size mm					Mass, kg
	$\phi I$	$\phi II$	$\phi E$	$\phi X$	$\phi M$	
① 675-10-29	65	58	51	53.2	62.8	0.006
① 675-10-29-01	33	26	19	21.2	30.8	0.004

① EQ. MATERIAL - NITRILE BA-10 BS-2751-82

TECHNICAL CONDITIONS

- Sizes are ensured by means of tools, except for those marked with asterisk.
- Unspecified limit deviations of sizes of up to 50 mm -  $\pm 0.4$  mm in excess of 50 mm -  $\pm 0.6$  mm.
- Absence of R0.5 from side of  $\phi M$  and  $\phi A$  is tolerable.
- Make markings of tag
- Other requirements - according to TY 005216-75 for articles under code 253121.

APPROVED	675-10-29		WEIGHT	SCALE
CHECKED CA			SEE TABLE	2:1
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	CUP		SHT	SHTS 1
			RUBBER 51-3029 TY 005216-75	



**TECHNICAL CONDITIONS**

1. Substitute for material - steel 38XC GOST 4543-71.
  2. Coating primer 0A-03K GOST 9109-81 and enamel N0-223, dark gray, GOST 14923-78 for outer surfaces, except for surfaces II.
  3. Unspecified limit deviations of sizes for holes - according to  $A_7$ , for shafts - according to  $B_7$ , others - according to  $CM_8$ .
  4. It is allowed to manufacture according to thickened dash-dot line.
  5. Local depressions not in excess of 0.5 mm on unmachined surfaces are tolerable.
  6. Unspecified requirements to forging - according to class II GOST 7505-74.
- (A) EQ MATERIAL - ALLOY STEEL (FORGING) 40Cr1Mo28 TO IS 5517-69  
 PRIMER TO JSS 3-47-13  
 ENAMEL TO JSS 8010-1

00780-ICV + Revised 26-4-2007 DATE	(A) Issue	EQ. MATERIAL ADDED
		NATURE AMENDMENT

APPROVED <i>[Signature]</i>	<b>675-10-30</b>	
CHECKED <i>[Signature]</i>	<b>COVER</b>	
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	WEIGHT	SCALE
	0.69	1:1
STEEL 45x GOST 4543-71	SHT	SHTS

675-10-32

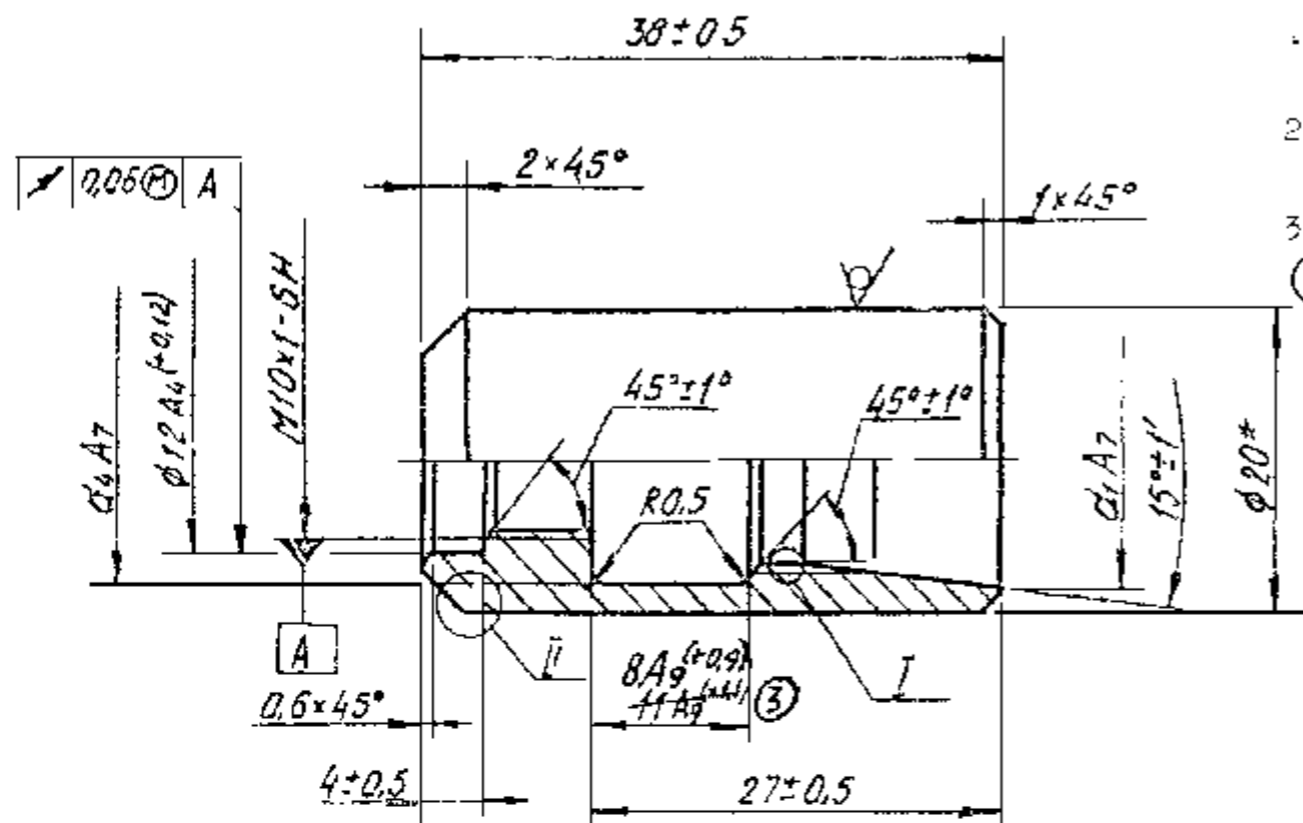
Восстановительный подлинник

Re80/ (✓) (✓)

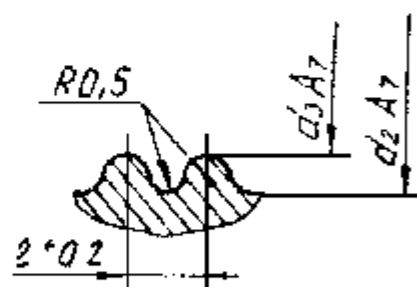
TECHNICAL CONDITIONS

- Coating: anodic oxidation with subsequent sealing in bichromate.
- Grooves for marking (element II) must be legible. Sizes of grooves are not subject for checking.
- \*Size is given for reference.

(A) EQ. MATERIAL:-(a) ALUMINIUM BAR GRADE 24534(W) TO IS: 133.83



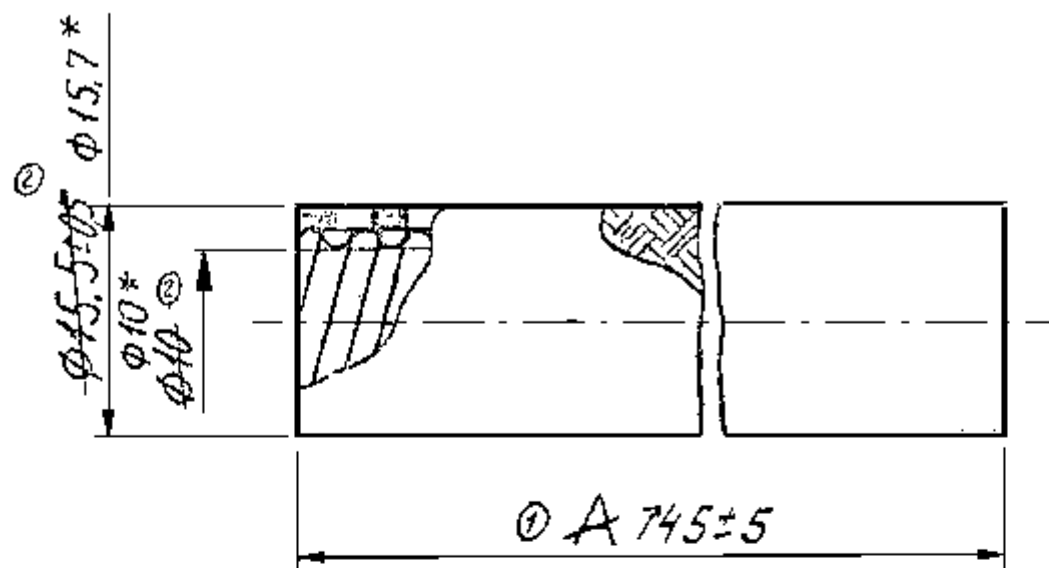
I  
Scale 5:1  
Left-hand thread



DESIGNATION	$d_1 A_7$	$d_2 A_7$	$d_3 A_7$	$d_4 A_7$	Mass, kg	Marking (element II)
675-10-32	$17^{+0.43}$	$15.5^{+0.43}$	$13.5^{+0.43}$	$16^{+0.43}$	0.014	
-01	$18^{+0.43}$	$16.5^{+0.43}$	$14.5^{+0.43}$	$17^{+0.43}$	0.012	

00770-ICV v <i>Amob</i> A & - 2500	(A) <i>Amob</i>	EQ. MATERIAL ADDED
DC(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED <i>Amob</i>	675-10-32			
CHECKED <i>CPH</i>	COUPLING		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)			SEE TABLE	2:1
	ROD $\#$ 1T kp. 20H GOST 21488-76	SHT	SHTS	



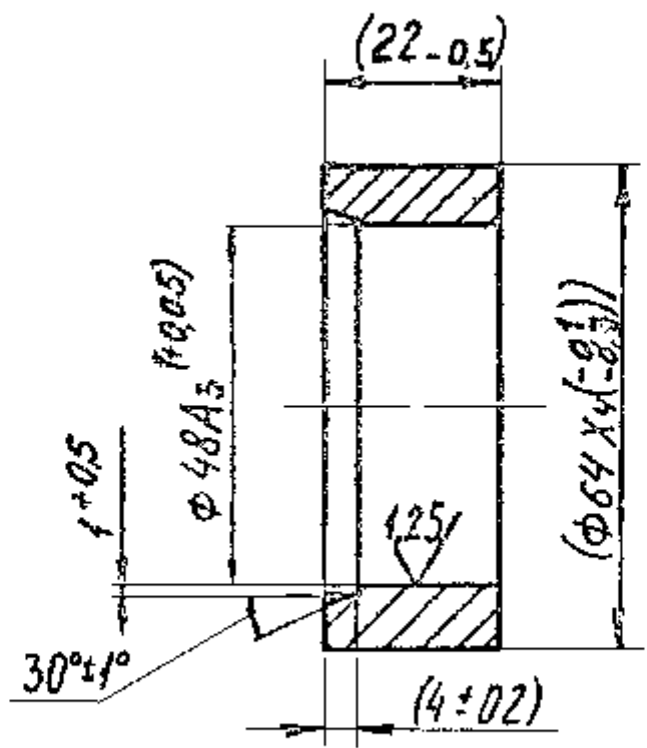
1. Substitute for material - sealed nose PTO8HO.449-118-10.
2. Requirements according to 8HO.449.117 TY.
3. \*Sizes are given for reference.

APPROVED <i>[Signature]</i>	<b>675-10-45</b>		
CHECKED <i>[Signature]</i>	<b>HOSE</b>	WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		0.158	1:1
		SHT	SHTS
	METAL HOSE 8HO.449-02-117 TY		

675-10-80

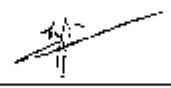
Rz80/ (✓)

007704CV V. Romanov	(A)	EQ. MATERIAL ADDED
4.4.2008	Issued	NATURE
DATE	ISSUE	AMENDMENT



1. Substitute for material - steel 45X ГОСТ 4543-71.
2. Sizes in brackets - after assembly.

(A) EQ. MATERIAL: - CDS TUBE GRADE 4 TO IS: 3074-65

APPROVED 

CHECKED. GPR

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

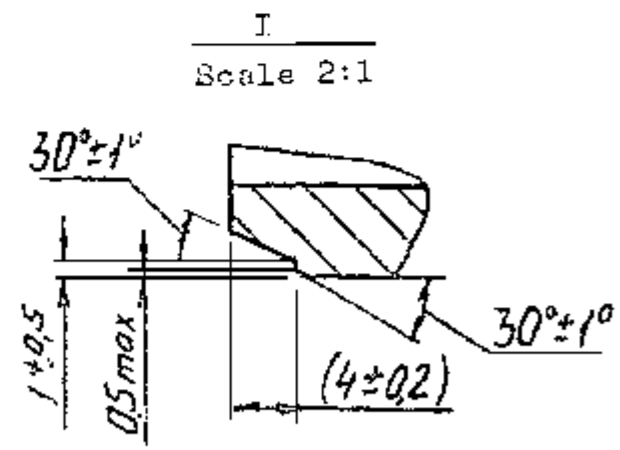
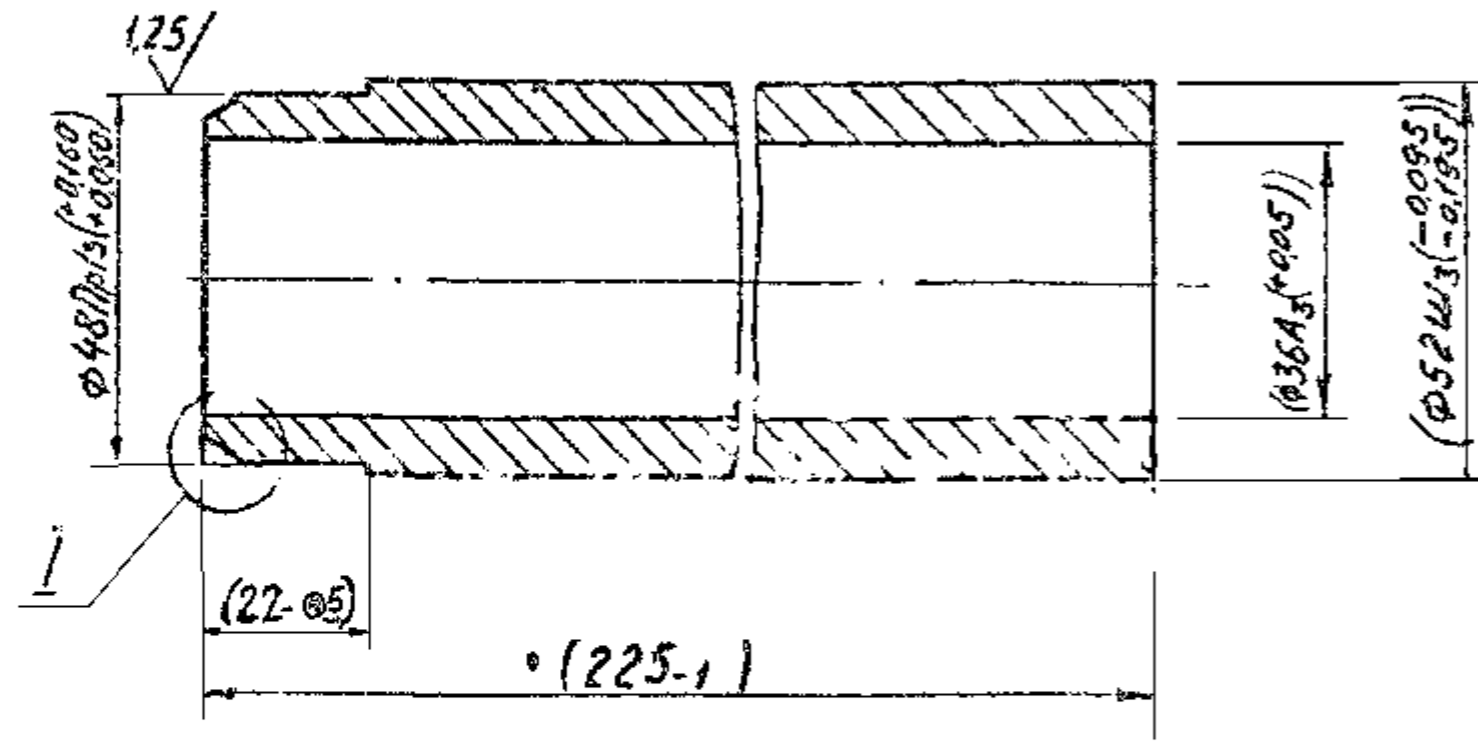
675-10-80		
HEAD	WEIGHT	SCALE
	0.28	1:1
	SHT	SHTS.
PIPE	65x12, GOST 8734-75 20, GOST 8733-74	

18-01-979

R280 ✓(M)

1. Substitute for material - steel 40X ГОСТ 4543-71.
2. Sizes in brackets - after assembly.


(A) EQ. MATERIAL: - (A) CDS TUBE GRADE TO IS: 3074-65, OR,  
ALLOY STEEL 40CT TO IS: 1570 OR EN-18



007/10-ICV	(A)	EQ. MATERIAL ADDED.
v. Revolt	Ex	
04-04-2000		
DC(I) No. & DATE	ISSUE	AMENDMENTS

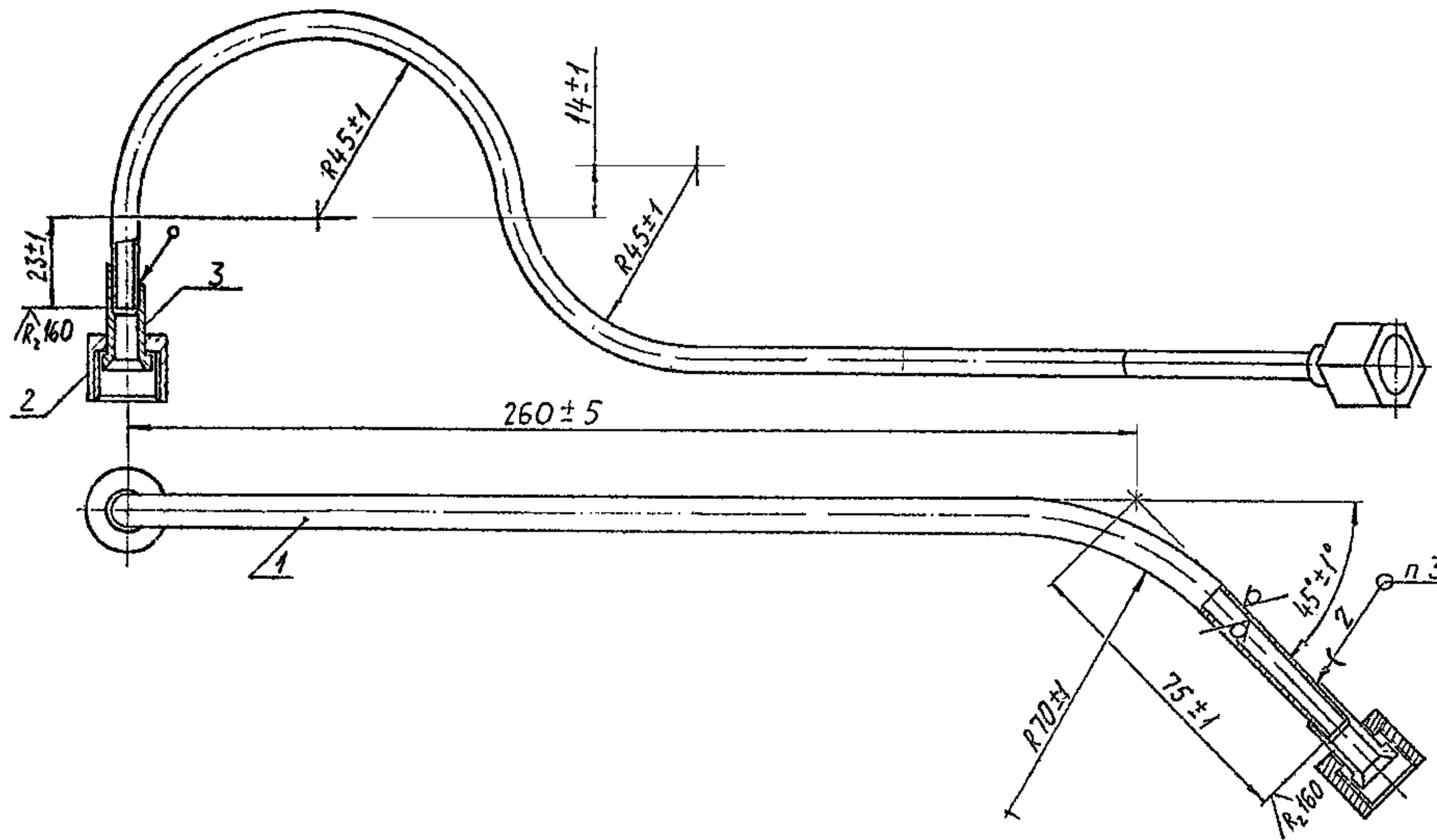
APPROVED	675-10-81		
CHECKED	PIPE		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	WEIGHT	SCALE	
	1.9	1:1	
PIPE	SHT	SHTS 1	
	54x12, GOST 8734-75 45X GOST 8733-74		

Ref. No.	Designation	Description	Qty	Remarks
	675-10-c6106CB	<u>Documents</u>		
		<u>Parts</u>		
(A) 1	675-10-16 EQ. MATERIAL: (B) a) CDS TUBE GRADE 4 (AS DRAWN) TO IS: 3074-65	Pipe Pipe 8x1 10CT 8734-75 B20 10CT 8733-74 L = 435 mm, approx. (A)	1	0.08 kg
2	700-30-241	Nut	2	
3	700-57-403	Nipple	2	
		00770-1CV (B) V. Roman 4.4-2000	EQ. MATERIAL ADDED	
		00140-1CV (A) 25-1-80	LENGTH OF PIPE AT REF. No. 1 WAS 450	
		DC(I) No & DATE	ISSUE	NATURE
AMENDMENT				

APPROVED		<b>675-10-Sb106</b>		
CHECKED	GPR	<b>PIPE</b>	WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)			SHT	SHTS

TECHNICAL CONDITIONS

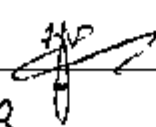
1. Part Ref. No. 1
    - (a) bend and determine length against reference standard,
    - (b) corrugations at points of bending - 1 mm, maximum, and ovality - 0.5 mm, maximum.
  2. Coating primer П-03К ГОСТ 9109-81 and enamel ИВ-223, dark gray, ГОСТ 14923-73 on outer surface.
  3. Solder with brass Л-63 ГОСТ 15527-70. Lack of solder penetration in seam should not exceed 50 % of lap joint. Grouped porosity and weak seal are not tolerable. Check lack of solder penetration, pores and weak seal by selective destruction of 1 % of total amount of lot, but not less than 1 pc per lot (lot is number of units submitted for check simultaneously). Other requirements - according to OCT 3-3619-77. OR, SOLDER BACuZn<sub>4</sub> IS 2927-75
  4. Perform leakage test at air pressure of  $(30^{+5})$  kgf/cm<sup>2</sup> in water bath for 2 min, minimum. It is allowed to perform test with summer fuel А-0,5 or winter fuel В-0,5 ГОСТ 305-73 at pressure of  $(50^{+5})$  kgf/cm<sup>2</sup> for 2 min, minimum. Leakage and sweating are not tolerable. After test flush pipe with rubber solvent gasoline ГОСТ 3134-78.
- Ⓐ EQUIVALENT:-(a) PRIMER AS PER IS 3-47-13  
 (b) ENAMEL AS PER IS 3-1010-11



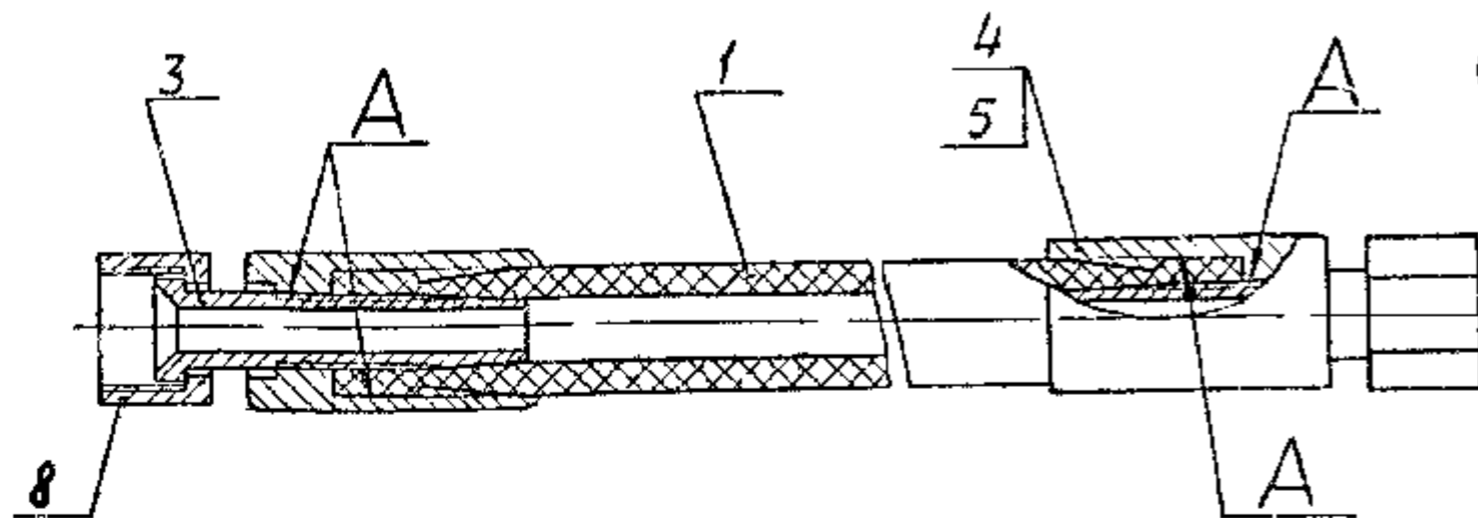
00770-ICV 4. Roman 02.4.2000 DATE	(A) Issue	ER. MATERIAL ADDED
		NATURE AMENDM

APPROVED <i>gpa</i>	675-10-Sb106Sb	
CHECKED <i>CoPR</i>	PIPE	WEIGHT SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		0.13 1:1
		SHT SHTS

Ref. No.	Designation	Description	Qty	Remarks
	675-10-c6107CB	<u>Documents</u> Assembly drawing		
		<u>Parts</u>		
1	675-10-17	Hose	1	
3	675-10-23	Nipple	2	
4	675-10-32	Coupling	2	Selection
5	675-10-32-01	Coupling	2	Selection
8	700-30-241	Nut	2	

APPROVED		<b>675-10-Sb107</b>		
CHECKED		GPR		
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>		<b>HOSE</b>		WEIGHT
				SCALE
			SHT	SHTS

675-10-Sb107Sb



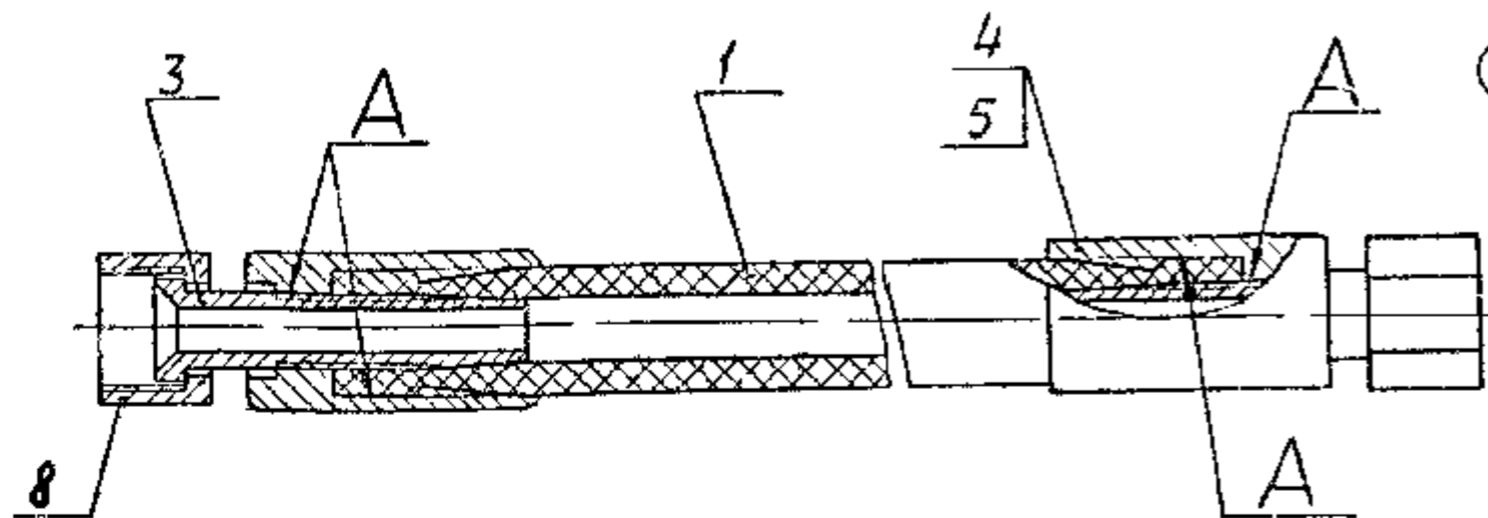
- 1 Assemble couplings Ref. Nos 4 and 5 with respective category of hose Ref. No. 1 according to table
- (A) 2 Prior to assembly lubricate surfaces A with zinc white paste ГОСТ 482-77, OR IS: 96
3. Perform assembly on special mandrel, Scores on inner surface of hose Ref No. 1 are not tolerable.
4. Perform leakage test with summer fuel А-0,5 or winter fuel З-0,5 ГОСТ 305-73 at pressure of  $(20^{+4})$  kgf/cm<sup>2</sup> for at least two minutes. Leakage of fuel is not tolerable. After test blow off hose with compressed air and close inlet holes of nipples Ref. No. 3 to protect inner surfaces from contamination.
5. Displacement of location mark of hose Ref. No. 1 from under couplings Ref. Nos 4 and 5 not in excess of 2 mm is tolerable.

Hose Ref No. 1	Coupling	
	Ref. No.	Designation
1	4	675-10-32
2	5	675-10-32-01

APPROVED <i>[Signature]</i>	675-10-Sb107Sb		
CHECKED <i>[Signature]</i>			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	HOSE	WEIGHT	SCALE
		0.2	1:1
	SHT	SHTS	

00770-ICV v. 2000 04 4 2000 DC (1) No DATE	(A) <i>[Signature]</i> ISSUE	EQ MATERIAL ADDED
		NATURE AMENDMENT

675-10-Sb107Sb





- 1 Assemble couplings Ref. Nos 4 and 5 with respective category of hose Ref. No. 1 according to table
- (A) 2 Prior to assembly lubricate surfaces A with zinc white paste ГОСТ 482-77, OR IS: 96
3. Perform assembly on special mandrel, Scores on inner surface of hose Ref No. 1 are not tolerable.
4. Perform leakage test with summer fuel А-0,5 or winter fuel З-0,5 ГОСТ 305-73 at pressure of  $(20^{+4})$  kgf/cm<sup>2</sup> for at least two minutes. Leakage of fuel is not tolerable. After test blow off hose with compressed air and close inlet holes of nipples Ref. No. 3 to protect inner surfaces from contamination.
5. Displacement of location mark of hose Ref. No. 1 from under couplings Ref. Nos 4 and 5 not in excess of 2 mm is tolerable.

Hose Ref No. 1	Coupling	
	Ref. No.	Designation
1	4	675-10-32
2	5	675-10-32-01

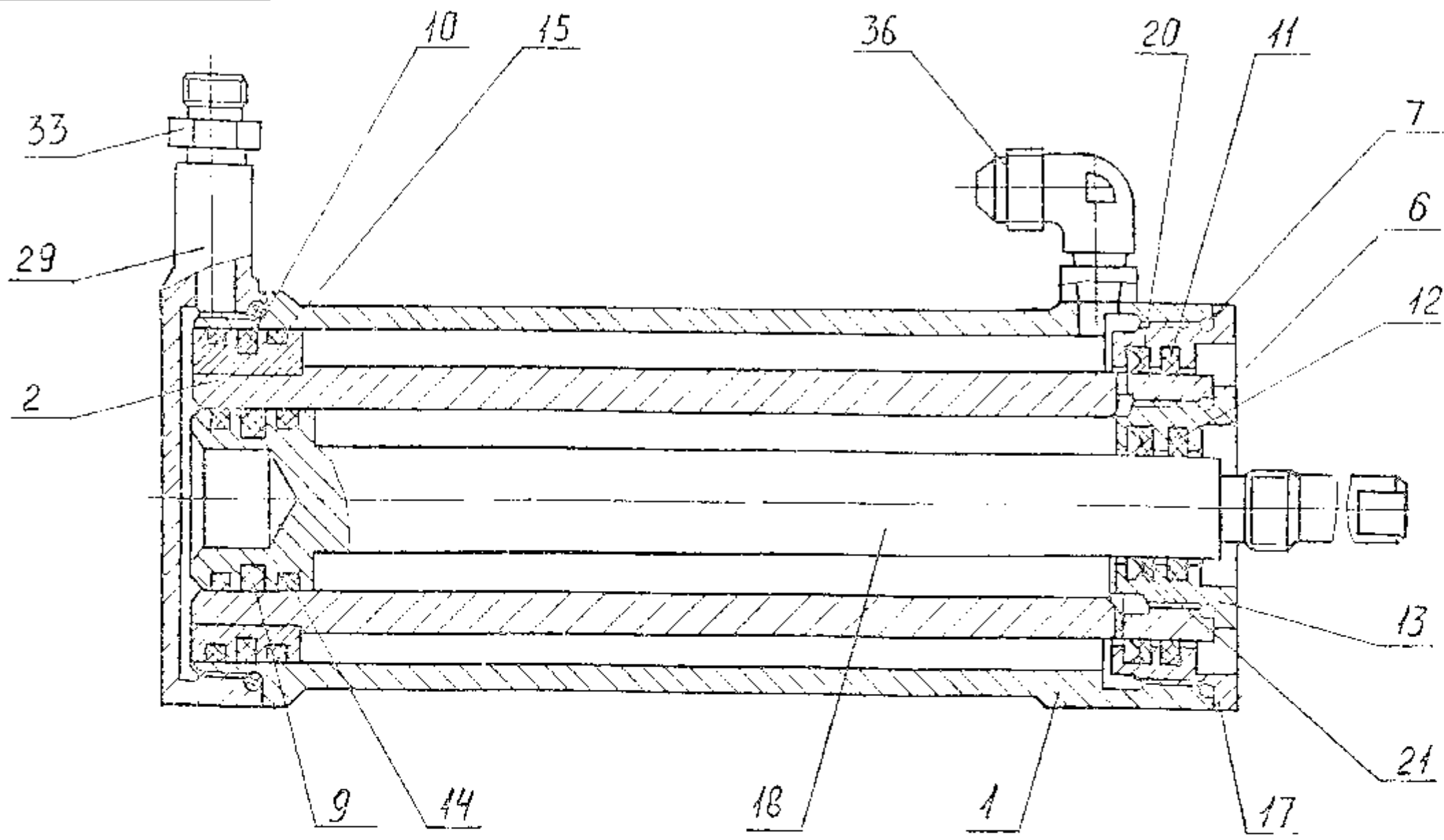
APPROVED <i>[Signature]</i>	675-10-Sb107Sb		
CHECKED <i>[Signature]</i>			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	HOSE	WEIGHT	SCALE
		0.2	1:1
	SHT	SHTS	

00770-ICV v. 2000 04.4.2000 DC (1) No DATE	(A) <i>[Signature]</i> ISSUE	EQ MATERIAL ADDED
		NATURE AMENDMENT

Ref. No.	Designation	Description	Qty	Remarks
		<u>Documents</u>		
	675-10-c610805	Assembly drawing		
		<u>Assembly Units</u>		
1	675-10-c6109	Body	1	
2	675-10-c6133	Cylinder	1	
		<u>Parts</u>		
6	675-10-19	Ring	1	
7	675-10-19-01	Ring	2	
9	675-10-20	Gland	1	
10	675-10-20-01	Gland	1	
11	675-10-20-02	Gland	1	
12	675-10-20-03	Gland	1	
13	675-10-21	Holder	1	
14	675-10-26	Ring	2	
15	675-10-26-01	Ring	2	
17	675-10-27	Holder	1	
18	675-10-28	Rod	1	
20	675-10-29	Cup	1	
21	675-10-29-01	Cup	1	
29	675-10-30	Cover	1	
33	765-08-253	Pipe union	1	
36	765-78-65	Angle	1	

APPROVED 	<b>675-10-Sb108</b>		
CHECKED 	<b>CYLINDER</b>		WEIGHT
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>			SCALE
			SHTS

675-10-Sb108Sb




**TECHNICAL CONDITIONS**

1. Clean all parts and assemblies before assembly.
2. Prior to assembly impregnate glands with graphite lubricant CK62/6-r3 POCT 3333-80. **RESERVO GREASE GRAPHITE EX.10C IN COMPLIANCE WITH INSTRUCTIONS 053.25 2.89.00001.**
3. Prior to assembly damp rings in spindle oil AV POCT 1642-75.
4. Pistons should move in both directions without jerks and seizing at pressure of 0.5 MPa (5 kgf/cm<sup>2</sup>) maximum.
5. Perform leakage test at air pressure of (2<sup>+0.5</sup>) MPa or (20<sup>+5</sup>) kgf/cm<sup>2</sup> for at least two minutes alternatively supplying air to each pipe union. Pressure drop by 0.3 MPa (3 kgf/cm<sup>2</sup>) for at least two minutes is tolerable.
6. Prior to installation cut glands according to drawings.
7. Install parts Ref. Nos 33 and 36 on zinc white paste POCT 482-77. (OR) IS:96

00770-ICV	(A)	EQ. MARERIAL ADDED.
04-04-2000	ISSUE	AMENDMENTS

APPROVED	<i>[Signature]</i>	<b>675-10-Sb108Sb</b>		
CHECKED	<i>[Signature]</i>			
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>		<b>CYLINDER</b>		
			WEIGHT	SCALE
			5.2	1:1
		SHT	SHTS	

Ref. No.	Designation	Description	Qty	Remarks
	675-10-c6109CE	<u>Documents</u> Assembly drawing		
		<u>Parts</u>		
1	675-10-22	Cylinder	1	
3	672-51-40	Boss	1	

APPROVED 

CHECKED *GPR*

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

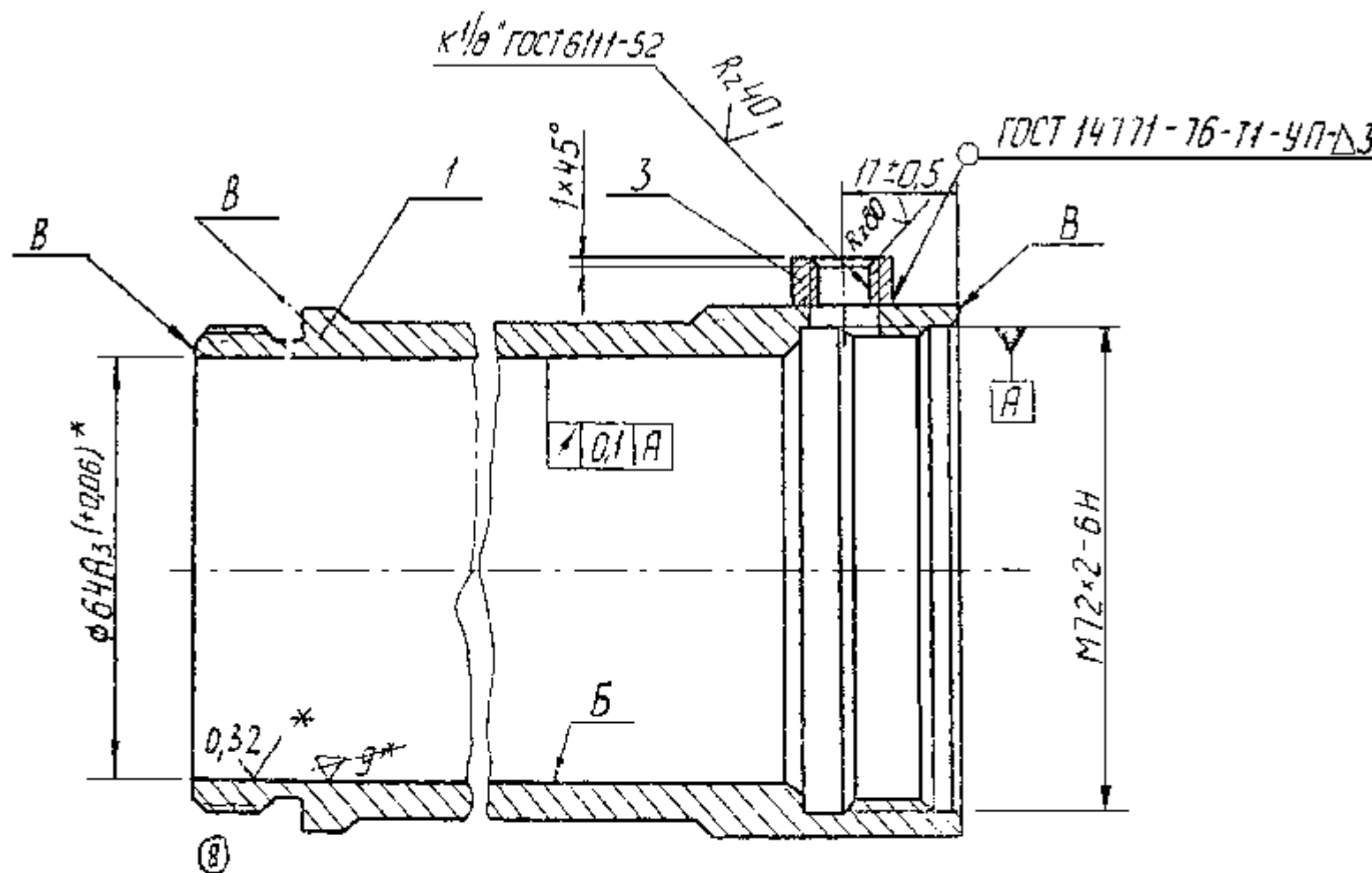
675-10-Sb109

BODY

	WEIGHT	SCALE
SHT	SHTS	

675-10-Sb109Sb

TECHNICAL CONDITIONS



1. HB 285 to 341 ( $\phi$  3.6 to 3.3).
2. Check thread in part Ref. No. 3 after welding.
3. Coating of surface B - hard plating; chromium coating 9. Coat outer surfaces, except for surfaces B and thread, with primer ПН-03К ГОСТ 9109-81 and paint with enamel ПЭ-223, dark gray, ГОСТ 14923-78.
4. Test body for leakage at air pressure of  $(30^{+5})$  kgf/cm<sup>2</sup> in water bath for at least two minutes. Leakage is not tolerable. It is allowed to test with summer fuel Л-0,5 or winter fuel З-0,5 ГОСТ 305-73 under pressure of  $(50^{+5})$  kgf/cm<sup>2</sup> for at least two minutes. Leakage and sweating are not tolerable.
5. \*Size and roughness - after coating.
6. Other requirements to quality of welds - according to OCT 3-4001-77 for off-design welded joints.

APPROVED <i>[Signature]</i>	675-10-Sb109Sb		
CHECKED <i>[Signature]</i>			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	BODY	WEIGHT	SCALE
		1.76	1:1
		SHT	SHTS

Ref. No.	Designation	Description	Qty	Remarks
		<u>Documents</u>		
	675-10-c61180E	Assembly drawing		
		<u>Parts</u>		
1	672-55-6	Revalving Angle Piece	1	Replacement with Ref. No. 8 is allowed
3	675-10-45	Hose	1	
5	700-31-806	Washer	2	
6	700-33-92	Nut	3	
7	672-28-55	Clamp bolt	1	
8	700-55-203	Swivel elbow	1	Replacement with Ref. No. 1 is allowed
9	700-56-224	T-Joint	1	Replacement with Ref. No. 18 is allowed
11	765-10-1496	Hose	1	
13	765-10-2114	Pipe	1	
14	765-10-2115	Pipe	1	
15	765-10-2118	Pipe	1	
16	765-10-2232	Pipe	1	
17	765-10-2359	Sleeve	4	
18	765-10-2451	T-Joint	1	Replacement with Ref. No. 9 is allowed

APPROVED *[Signature]*

CHECKED *[Signature]*

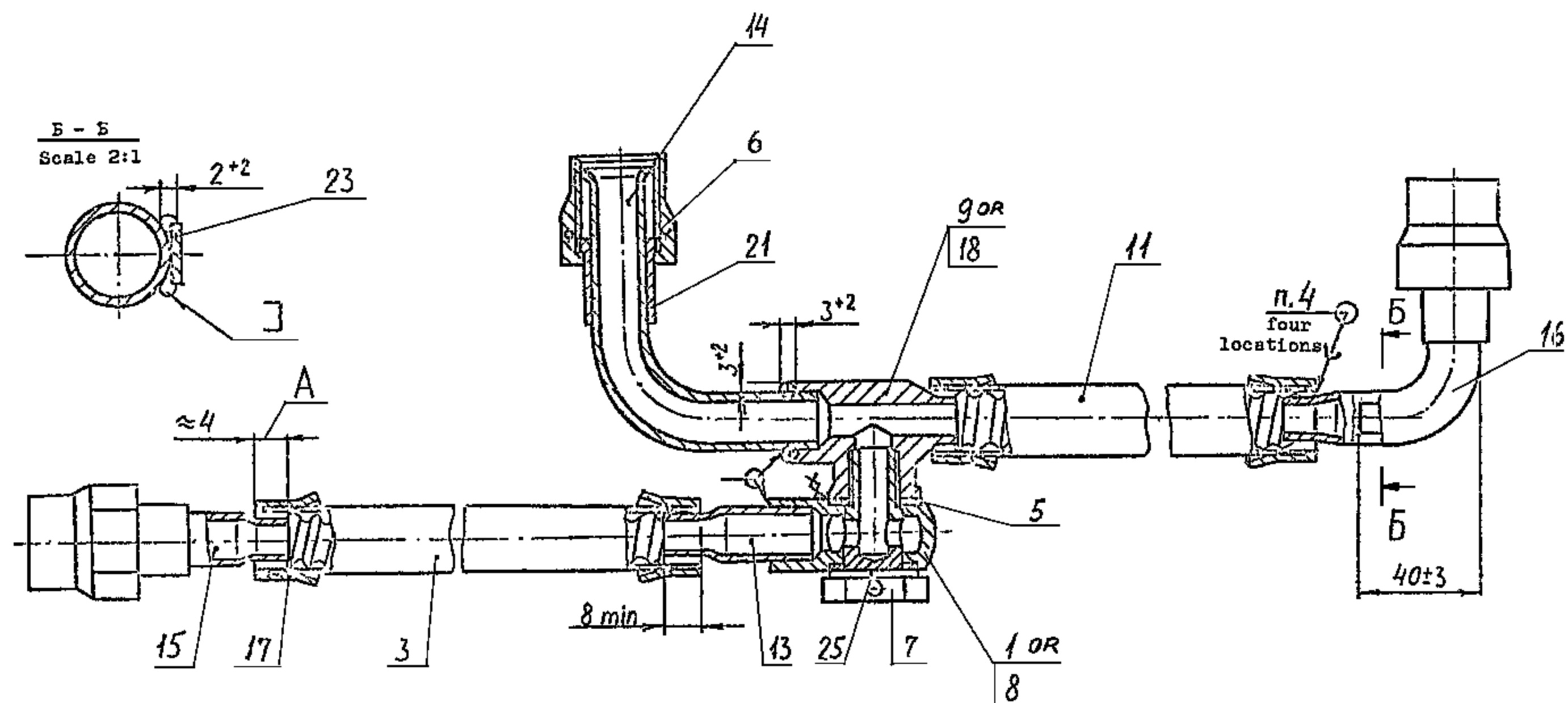
CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

<b>675-10-Sb118</b>		
<b>HOSE</b>	WEIGHT	SCALE
	SHT 1	SHTS 2

Ref. No.	Designation	Description	Qty	Remarks
21	765-84-6	Nipple	3	
23	KB-50-969	Lug for sealing	1	
		<u>Materials</u>		
25 (A)	EQUIVALENT MATERIAL: MILD STEEL WIRE, GALVANISED 1mm DIA, 1/4 HARD TO IS: 280-78 UTS 37 Kgf/mm <sup>2</sup> (min)	Wire K01 FOOT 792-67, L = 150 mm	1	

00 469-ICV <i>Bob</i>	(A) <i>Bob</i>	EQUIVALENT MATERIAL ADDED FOR REF NO 25
14 SEP '94 DCC/NO/DATE	ISSUE	NATURE
AMENDMENTS		

APPROVED <i>[Signature]</i>	<b>675-10-Sb118</b>			
CHECKED <i>[Signature]</i>	<b>HOSE</b>		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				
			SHT 2	SHTS 2




**TECHNICAL CONDITIONS**

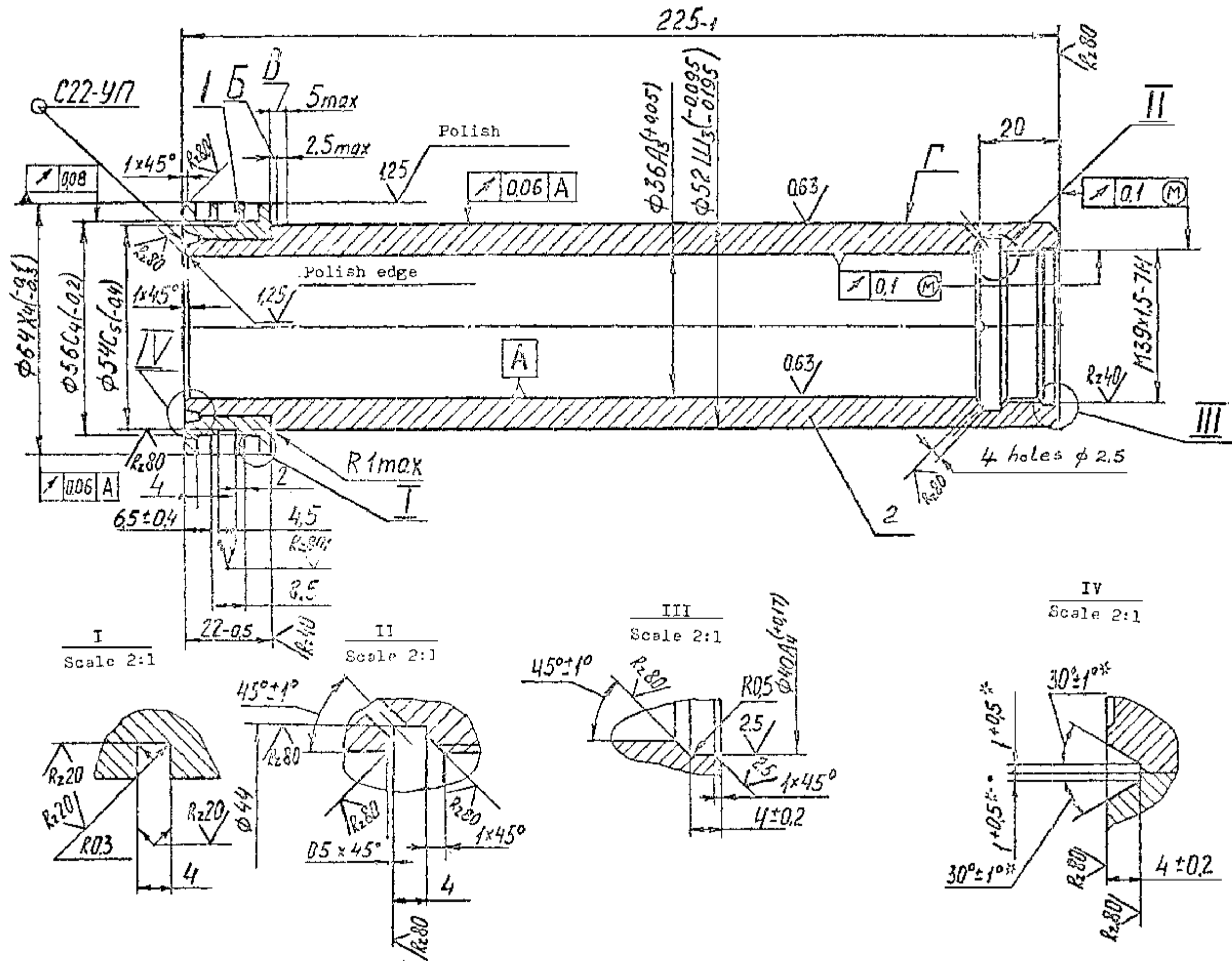
1. Parts Ref. Nos 14 and 16 should be in one end same plane. Angular displacement of  $\pm 2^\circ$ , maximum, is tolerable.
2. Bend and assemble parts Ref. Nos 14 and 16 according to standard made to suit requirements.
3. Prior to assembly ends of hoses Ref. Nos 3 and 11, pipes Ref. Nos 13, 15 and 16 and T-piece Ref. Nos 9 and 18 to be soldered should be tinned with solder NCp40 or NCp45 ГОСТ 19738-74 over 7 to 10 mm. Diameter of hose sections of  $(15.2_{-0.3})$  mm being tinned should enter part Ref. No. 17, OR, ~~TINNED SOLDER GRADE SA CuAg 16 A TO IS: 2927-75~~ It is allowed not to make diameter of hose section being tinned equal to  $(15.2_{-0.3})$  mm; in this case, cup Ref. No. 17 should be crimped over length A to obtain clearance of 0.6 mm, maximum, between hose and cup.
4. Solder NCp45 or NCp40 ГОСТ 19738-74. Requirements to soldering - according to OCT 3-3620-77.
5. Gas welding. Filling wire  $\alpha 2.08TA$  ГОСТ 2246-70.
6. Perform leakage test in water bath at pressure of  $1.96 \cdot 10^5 + 0.98 \cdot 10^5$  Pa or  $(2^{+1})$  kgf/cm<sup>2</sup> for at least 30 s. Air leakage is not tolerable.
7. Coating: varnish KQ-815 ГОСТ 11066-74, aluminum powder ПАН-1 or ПАН-2 ГОСТ 5494-71 according to Instructions ИЛ23-74, OR, VARNISH TO IN/OPC/15 (NAVAL STORES), AL PASTE TO IS: 269
8. Requirements to quality of welds - according to OCT 3-4001-77 for off-design joints.

APPROVED		675-10-Sb118Sb	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		WEIGHT	SCALE
		0.59	1:1
		SHT	SHTS

00770-ICV	(A)	ES. MATERIAL ADDED
4. Round		
A.A. 2000		NATURE
DC (1) No	ISSUE	AMENDMENT
DATE		

Ref. No.	Designation	Description	Qty	Remarks
	675-10-c6133CB	<u>Documents</u> Assembly drawing		
		<u>Parts</u>		
1	675-10-80	Head	1	
2	675-10-81	Pipe	1	

APPROVED		<b>675-10-Sb133</b>		
CHECKED	<i>O.P.R.</i>	<b>CYLINDER</b>		WEIGHT
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				SCALE
			SHT	SHTS

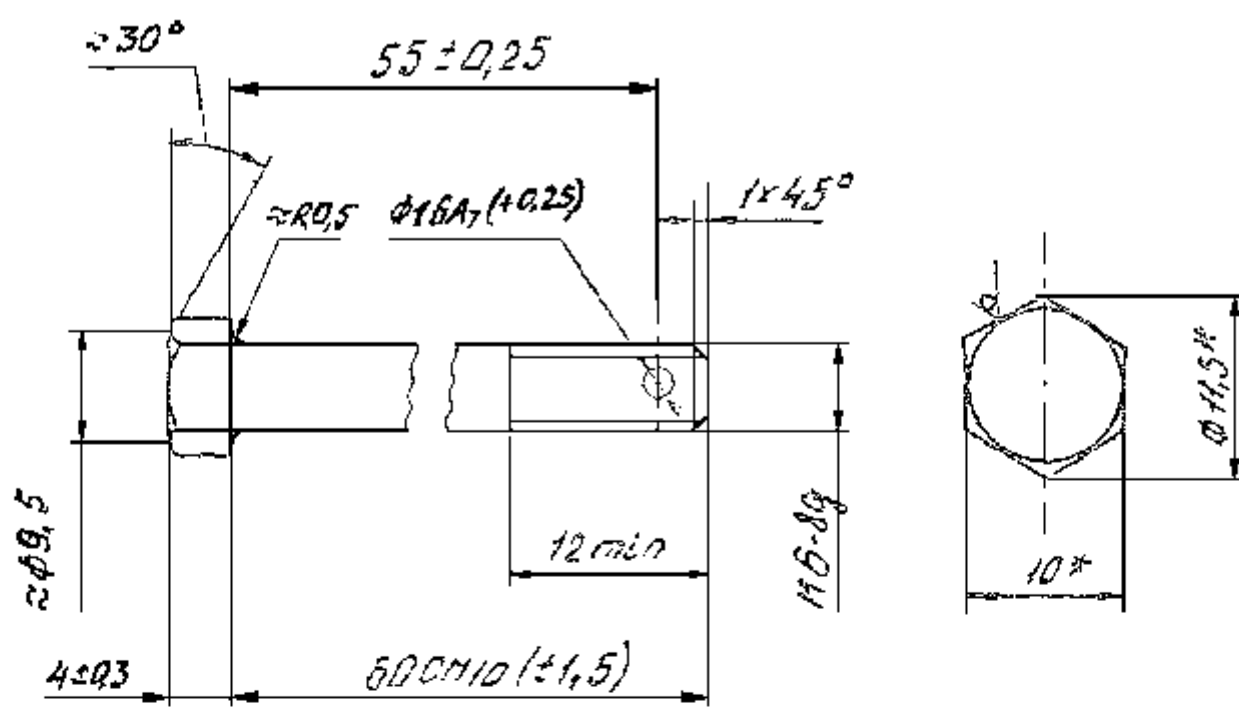


**TECHNICAL CONDITIONS**

1. Welding according to ГОСТ 14771-76. Filling wire ch.08P2C ГОСТ 2246-70.
2. Unspecified limit deviations of sizes: for holes - according to A7; for shafts - according to B7; others - according to CM7.
3. Coating of surfaces A and B: hard plating chromium coating 9. Protect thread from coating. It is allowed to coat section B with hard plating chromium coating 6. Absence of coating on section B is tolerable. Coating of other surfaces: Ch. ex. oiled.
4. Other requirements to quality of welds - according to OCT 3-4001-77 for off-design welded joints.
5. \*Sizes are given for reference.

APPROVED <i>[Signature]</i>	675-10-Sb133Sb		
CHECKED GPR	CYLINDER	WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		2.1	1:1
		SHT	SHTS

R<sub>z</sub> 80  
✓(M)



- 1 DISPLACEMENT OF AXIS OF HOLE WITH RESPECT TO AXIS OF BOLT BODY SHOULD NOT EXCEED 0,2 mm.
- 2 POSITION OF HOLE WITH RESPECT TO THE HEXAGONAL ROD IS ARBITRARY.
- 3 REST OF THE TECHNICAL REQUIREMENTS ARE AS PER GOST 1759-70, PART 1.
- 4\* DIMENSIONS ARE GIVEN FOR REFERENCE.
- 5 TYPE OF COATING: CADMIUM <sup>PLATED</sup> 9 MICRON THICK, CHROMATISATION.
- ⓑ 6 k ZINC PLATING 9 MICRON THICKNESS, CHROMATISATION IS ALSO ALLOWED. OR GRADE B (Z.N-13) TO IS: 1573-60
- Ⓐ EQ. MATERIAL: (a) STEEL BAR G-45 TO IS: 2073-70 OR EN 8 TO BS: 970

00770-ICV	Ⓐ	EQ. MATERIAL ADDED.
4 APR 00	Amr	
DC(I) No. & DATE	ISSUE	AMENDMENTS

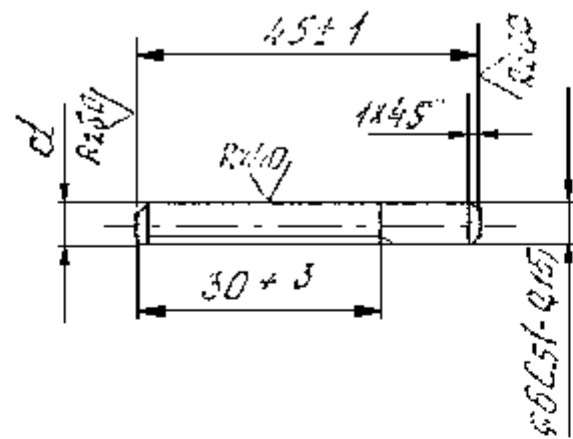
APPROVED M. VASU  
 CHECKED *[Signature]* B. MISREDDY

700-28-646

CONTROLLERATE  
 OF  
 QUALITY ASSURANCE  
 (ICV)

**BOLT**  
 HEXAGONAL ROD 10-5 GOST 8560-78  
 45-B GOST 1051-73

WEIGHT	SCALE
0.013	2:1
SHT 1	SHTS 1



1. Alternate material is steel 25, GOST 1050-74.
2. Thread may be made by rolling without chamfer at the end of rod, in this case, unthreaded portion of rod should be equal to angle diameter of thread.
3. Thread should be clean, it should not have burrs, stripped turns and dents.

- (A) 4. EQ. MATL. :- BRIGHT BAR TYPE 'D' Gdc2(25CB) TO IS: 9550-80.  
 (B) EQ. MATERIAL :- STEEL BAR C-25 TO IS: 2073-70

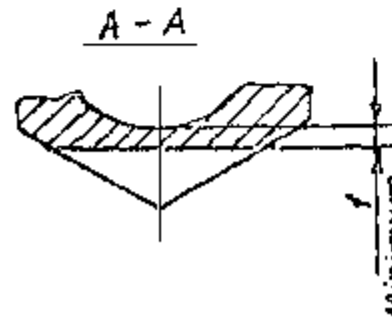
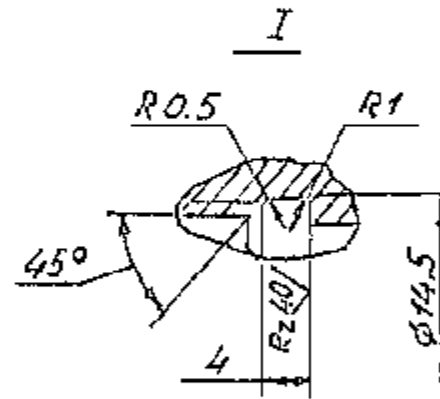
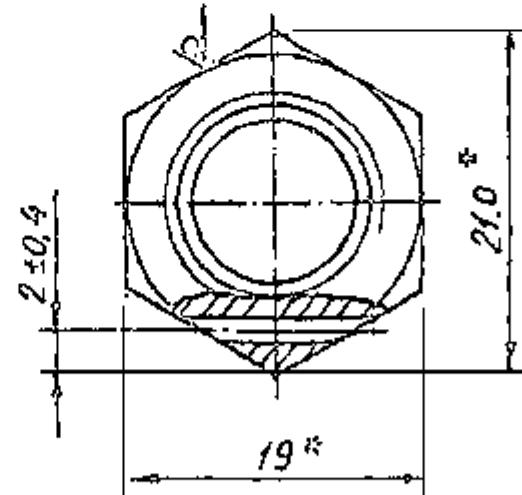
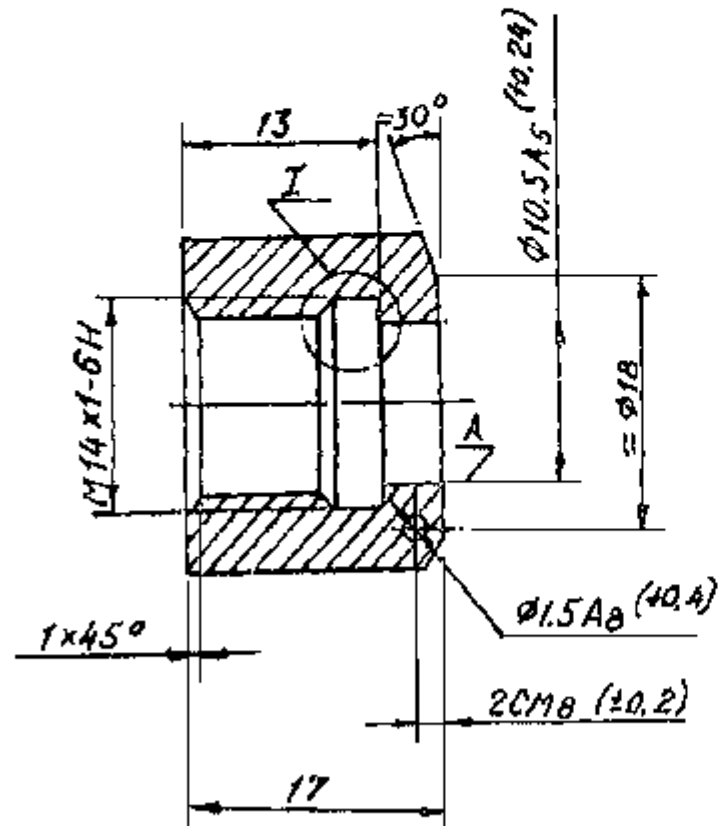
DESIGNATION	d
700-29-507	M6-6g
700-29-508	M6-6g Left hand.

00780-ICV v. Roman 26 APR 00	(B) Cum	EQ. MATERIAL ADDED.
00450-ICV Buh 26 AUG 94	(A) GK	NOTE NO. 4 FOR EQUIVALENT MATERIAL NEWLY ADDED (D-1151)
DC(I)No. & DATE	ISSUE	AMENDMENTS

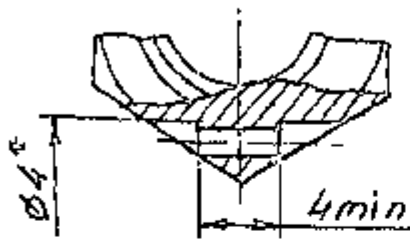
APPROVED	H VASU	<b>700-29-507 to 508</b>	
CHECKED	W. M. S. K. & D. P.		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	<b>STUD</b>	WEIGHT	SCALE
		10.010	1:1
		SHT	SHTS
STEEL 20 GOST 1050-74			

**TECHNICAL CONDITIONS**

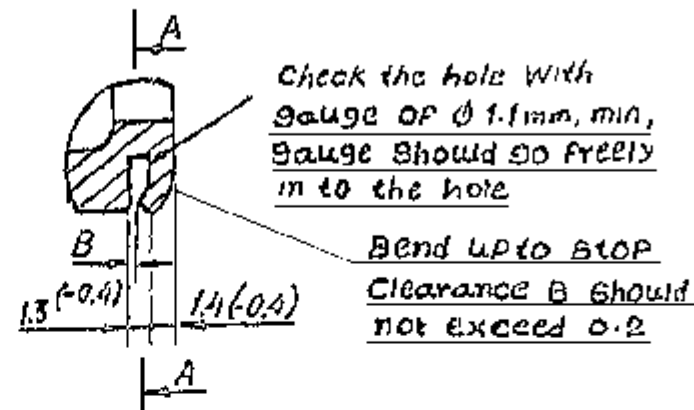
1. ALTERNATE MATERIAL IS STEEL 25, 30, 35 AND 40 GOST 1050 - 74
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS : FOR HOLES - AS PER A7, FOR SLAFT - AS PER B7 AND FOR THE REST AS PER CM7
3. DISPLACEMENT OF SURFACE 'A' WITH RESPECT TO THREAD SHOULD NOT EXCEED 0.2 MM.
4. \* DIMENSIONS ARE GIVEN FOR REFERENCE.
5. COATING ZINC - PLATED, 9 MICRONS THICK CHROMATIZED, REMOVE HYDROGEN EMBRITTLEMENT COATING ON INTERNAL SURFACE NEED NOT BE CHECKED.
6. ROD WITH MINIMUM DIAMETER OF 1 MM SHOULD PASS THROUGH HOLE 5



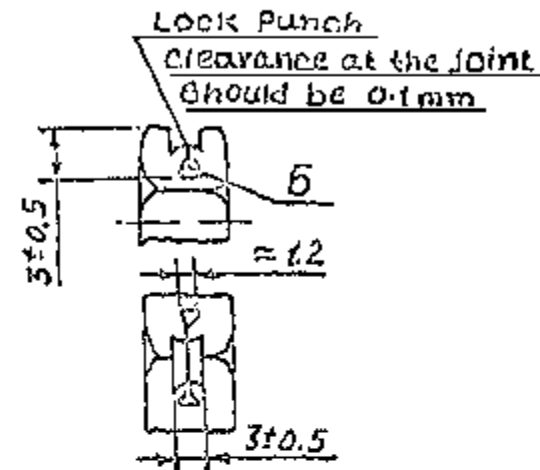
**ALTERNATE-1**



**ALTERNATE-2**



**ALTERNATE-3**



EQUIVALENT MATERIAL - IS 45 C8 Gr 2 to IS 9550 - 80

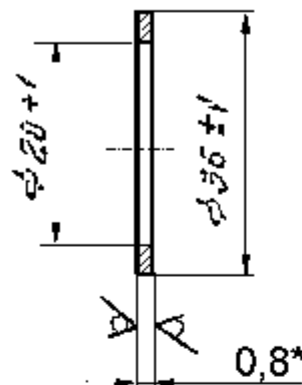
EQUIVALENT MATERIAL - CLASS 4 TO IS . 2004 - 78

EQUIVALENT MATERIAL :- (a) STEEL BAR C 45 TO IS : 2073 - 70 OR EN 8 TO BS . 970 OR EN - 8 / EN 9.

EQUIVALENT MATERIAL - CARBON STEEL C 50, C 46, C 30, C 25 TO IS 1570 - 61

NEAREST EQ. MATERIAL		00951-JCV	DRAWING REVISED & RETRACED.
HEXAGON BAR 19.5, GOST 8560-78 45-B, GOST 1051-73		18-11-02 DC(No. & DATE)	
ORGL MATERIAL:-		ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF		ALL THREADS TO CONFORM TO SPECIFICATION	
DRG. NOT TO BE SCALED		STAMP OR ETCH, PART No. MANUFACTURER'S NAME & YEAR OF MFR.	
SCALE: 2:1		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	
DATE: 18-11-02		USED ON:	
DRN. MS hdd	WT :- (Kg)	<b>700-30-241</b> <b>UNION NUT</b>	
TCD. MS hdd	0.023		
CHD. MS hdd			
APPD. MS hdd			
<b>CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)</b>			

89E-1E-00L



1. Alternate material is steel 10 and 10KП GOST 1050-74.
2. \* Dimension is given for reference.
3. Coating: Zinc-plated, 24 microns thick, chromated.  
Remove hydrogen embrittlement.

ⓑ EQ. MATERIAL: (a) COLD ROLLED STEEL STRIPS GRADE EDD ( $\frac{1}{2}$ H) TO IS: 4030-73

ⓑ

D.S CAT(PART) NO: LV2/RCV-5310-017671-  
DESCRIPTION: WASHER FLAT

00770-ICV ⓑ

V. R. 2000

4 APR 00

00549-ICV ⓐ

12 MAR 96

DC(I) No.

& DATE

ⓑ

EQ. MATERIAL ADDED.

ⓐ

D.S CAT PART No. AND

DESCRIPTION ADDED

FOR THE DRAWING.

ISSUE

AMENDMENTS

APPROVED

M. VASU

CHECKED

H. M. SHANKL

700-31-368

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

GASKET

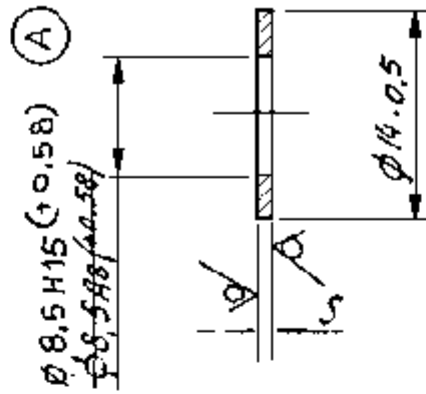
WEIGHT SCALE

0.0025 1:1

SHT SHTS

SHEET A-08 ГОСТ 19904-74  
II-RT-DRK, ГОСТ 9045-80

700-31-761/762



DESIGNATION	S, mm	MASS, Kg
700-31-761	0.2-0.03	0,00015
700-31-762	0.5-0.05	0.00038

(C) EQ. MATERIAL:- HOT ROLLED STEEL SHEET S<sub>2</sub>-34 TO IS: 1079-73 OR EN2B (KILLED STEEL) TO BS: 970.

(B) EQ. MATL:- GRADE 'D' TO IS: 513.

1. Alternate material is steel cm3, cm5, GOST 380-71 and steels 08, 10kn, 15, 20 GOST 1050-74.

00770-ICV V. Romanov A. 4-2070	(C) Anon	EQ. MATERIAL ADDED
00759-ICV V. Romanov 31-01-2070	(B) Anon	EQ. MATERIAL ADDED.
00288-ICV  Sady 27 AUG 91	(A) NO CDM	ID WAS $\phi 8.5 A_8 (+0.58)$ MASS OF 700-31-761 WAS 0,015 AND 700-31-762 WAS 0,038. (D-1102/ICV)
D.I.(2) NO. DT	ISSUE	AMENDMENTS & NATURE

APPROVED  
CHECKED  
CONTROLLERATE OF QUALITY ASSURANCE (ICV)

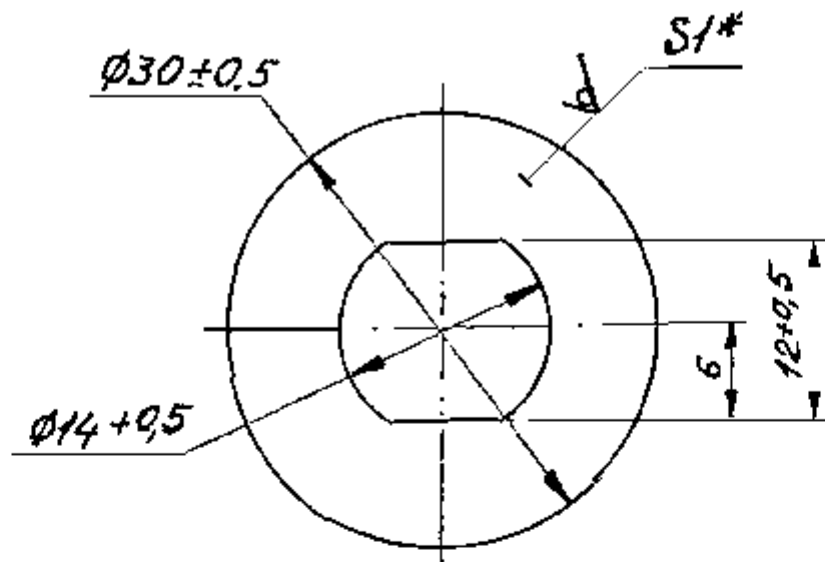
700-31-761/762

WASHER

WEIGHT SCALE  
SEE TABLE  
SHT 1 SHTS 1

STEEL 10, GOST 1074-74

700-31-770



- 1) Alternate material is steel 08nc and 10 GOST 1050-74
- 2) \* Dimension is given for reference.

(A) EQ. MATERIAL:- (A) COLD ROLLED STEEL STRIP GRADE EDD (1/2 H) TO IS: 4030-73

00770-ICV v. <i>Road</i> 4-4-2000 DC(I) No. & DATE	(A) <i>W</i>	EQ. MATERIAL ADDED.
	ISSUE	AMENDMENT'S

APPROVED *H VASU*  
CHECKED *SKUMAR*

700-31-770

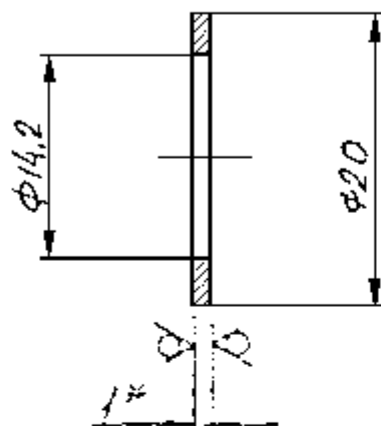
CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

WASHER

WEIGHT	SCALE
0.004	2:1
SHT 1	SHTS 1

STEEL A1.0, GOST 19904-74  
II-BF-08kn, GOST 9045-80

700-31-806



1. Unspecified limit deviations of dimensions are  $\pm 0.5$  mm.
2. \* Reference dimension.

Ⓐ EQ. MATERIAL; - ALU. STRIP GRADE 19500, 0' CONDITION TO IS: 737-74

00780-ICV

26 APR 00

DC(I) No.

& DATE

Ⓐ

*Caru*

ISSUE

EQ. MATERIAL ADDED.

AMENDMENTS

APPROVED

*M. V. G. D.*

CHECKED

*[Signature]* D. S. K. D. M. S.

700-31-806

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

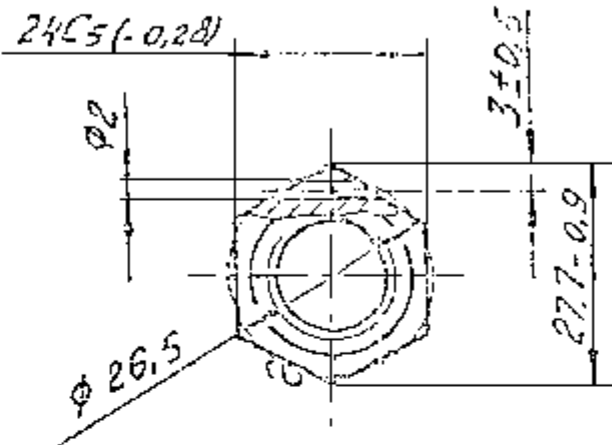
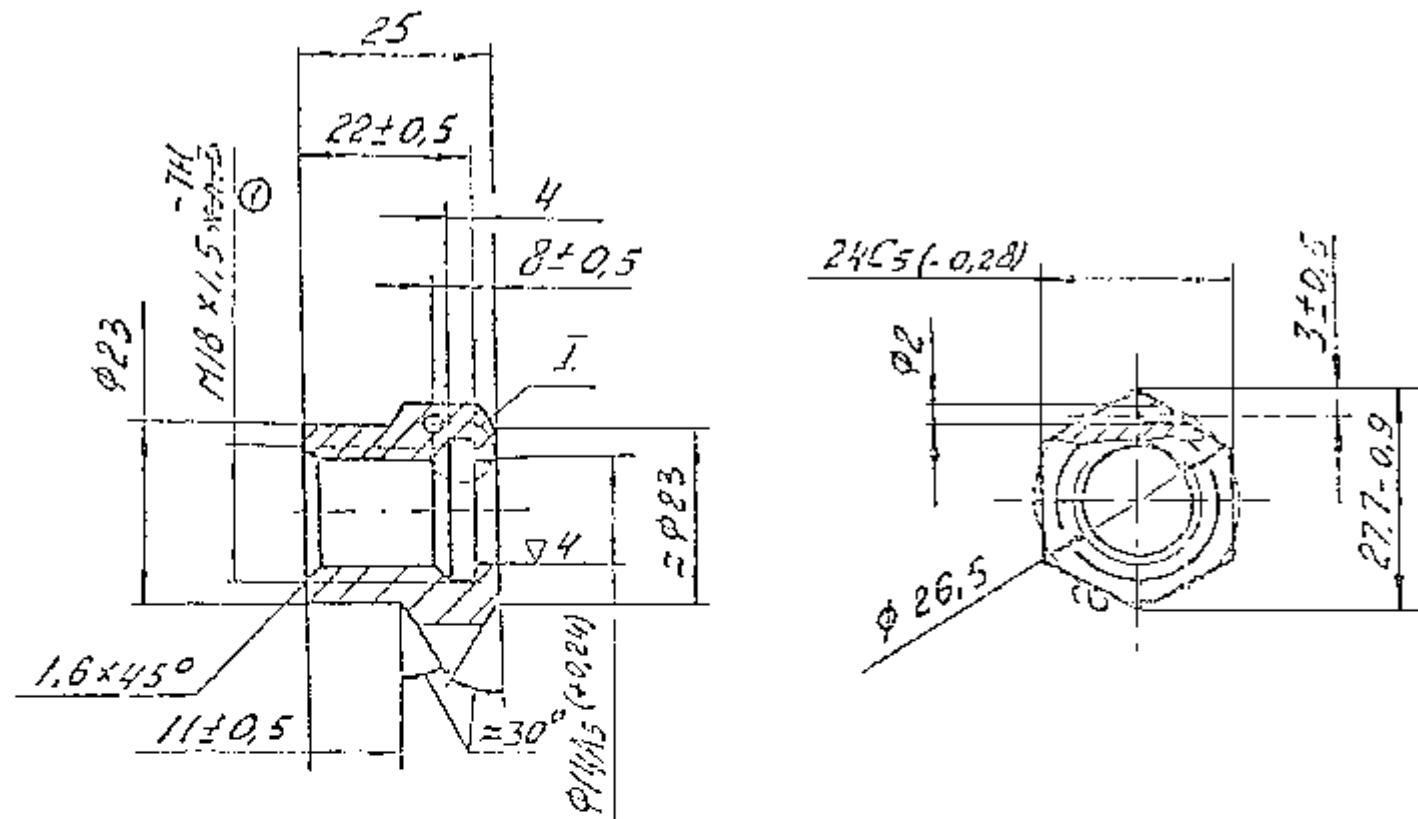
WASHER

WEIGHT SCALE

0.0074 2:1

SHT SHTS

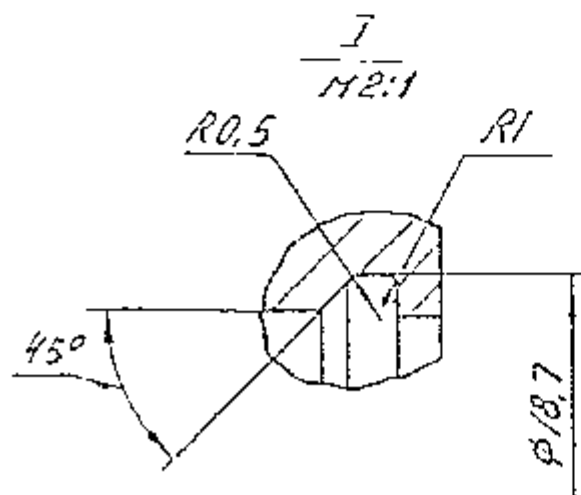
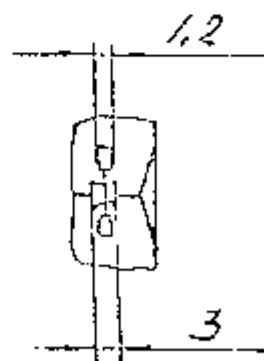
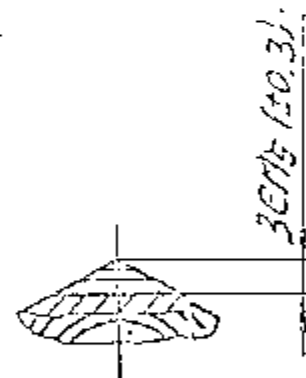
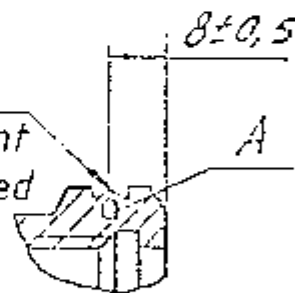
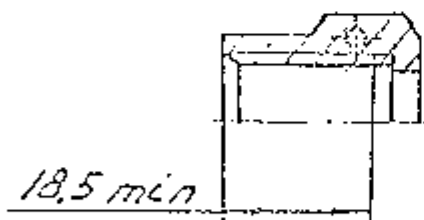
SHEET A4 1M-1 GOST 21631-76



II Alternate

Alternate

Lock-punch, Clearance at joint should not exceed 0.1 mm.



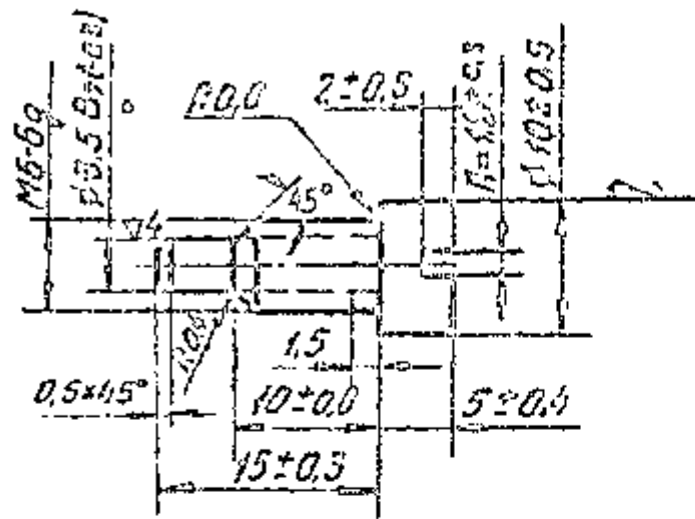
- ⓑ 8, UTS 72.5 Kg/mm<sup>2</sup> (min), ELONGATION 20% (min).
- ⓒ EQ. MATERIAL :- STAIN LESS STEEL BAR 04CY 18 N110 T120 TO IS: 6527

1. Alternate material is 20x23H18 and 12x18H10T GOST 5632-72.
2. Unspecified limit deviations of dimensions of machined surfaces are as follows:  
For holes -as per A<sub>7</sub>  
for shafts -as per B<sub>7</sub>.
3. Manufacture as per dotted line is allowed.
4. Rod, diameter not less than 1 mm, should pass through hole A.
5. If the part is made as per Alternate II, do not manufacture it as per dotted line.

- ⓐ 6. EQ. MATERIAL :- ALLOY STEEL 04CY 18 N110 T120 TO IS : 6603-72.
- ⓑ 7. ALTERNATE MATERIAL :- 304 S 15 TO BS : 970-83.

00780-ICV 26 APR 00	ⓐ Grun	EQ. MATERIAL ADDED.
00606-ICV 02 FEB 97	ⓑ Grun	NOTE FOR UTS AND ALTERNATE MATERIAL ADDED. (1/97 N OF A)
00477-ICV 19 OCT 94	ⓐ Bib	NOTE No.6 FOR EQ. MATERIAL ADDED.
DCI No. & DATE	ISSUE	AMENDMENTS

APPROVED	M. VASU	700-33-92	
CHECKED	22/04/2		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		NUT	
		12x18H9T GOST 5632-72	
		WEIGHT	SCALE
		0.039	1:1
		SHT	SHTS



- 1) Alternate material is steel cm6, GOST 380-71 and steel 35, 40, 50 GOST 1050-74 as well as steel 40 Г and 30 Г 2, GOST 4543-71.
- 2) Brinell hardness is 255 to 207 ( 3,8 to 4,2 ) or HRC 26 to 18.
- 3) Incomplete thread should not exceed 1,5 mm.
- 4) Coating :- Chemically oxidation, oiling or chemical oxidation, parkerizing oiling.
- 5) It is allowed to perform dimension A equal to 1,2<sup>+0,3</sup><sub>-0,08</sub>

Ⓐ EQ. MATERIAL:- STEEL C-45 TO IS: 6517-69, EN-8/EN-9

00770-ICV v. Roman 4-4-2000	Ⓐ Cur	EQ. MATERIAL ADDED.
DC(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED *[Signature]* H VAS  
CHECKED *[Signature]* D. SKUMAR

700-35-21

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

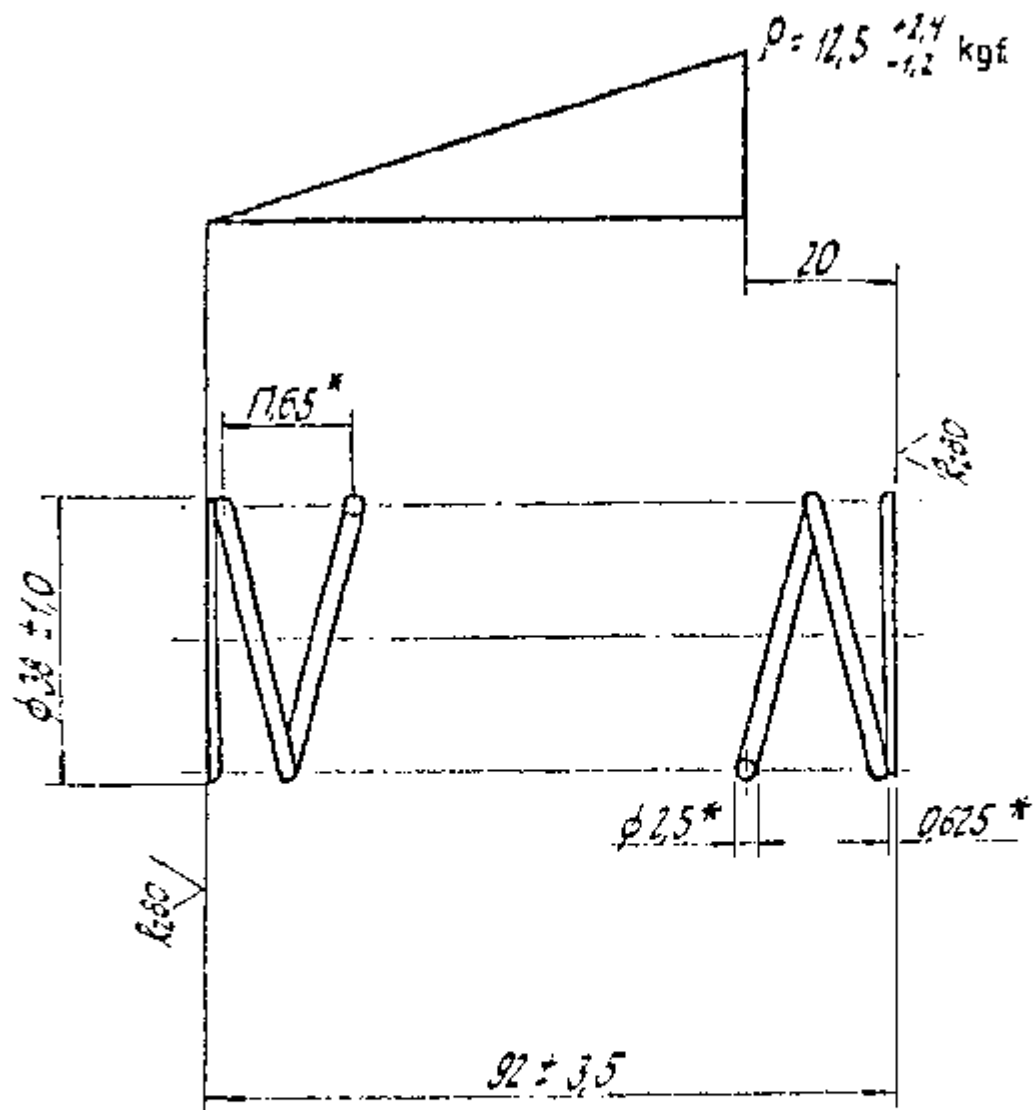
SCREW

WEIGHT SCALE

0.05 2:1

SHT 1 SHTS 1

STEEL 45, GOST 1050-74



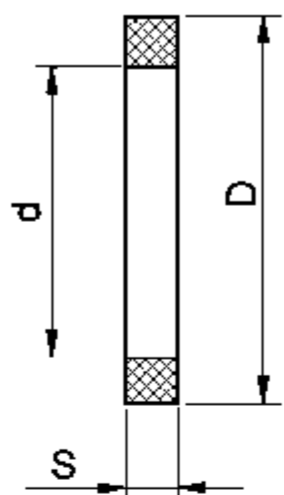
- 1). Shear modulus  $G^* = 8000 \text{ kgf/mm}^2$ .
- 2). Tangential twisting stress (maximum)  $T_3^* = 80 \text{ kgf/mm}^2$ .
- 3). Total length of the spring  $L^* = 710 \text{ mm}$ .
- 4). Number of working turns  $n = 5 \pm 0.5$ .
- 5). Number of complete turns  $n_1 = 7 \pm 0.5$ .
- 6). Direction of winding is arbitrary.
- 7). Machined surface of the butt-ends should be not less than  $3/4$  of the turn.
- 8). Deviation of the generatrix of the spring from the perpendicular to the butt-ends should not exceed  $2 \text{ mm}$ .
- 9). Increase in the external diameter of supporting turns may be upto  $0.8 \text{ mm}$  above tolerance.
- 10). \* Dimensions are given for reference.
- 11). Coating: Chemically parkerized, accelerated chromated oiled K-17, GOST 10877-76, as per instructions for 053.25289.00002 coated with varnish KO-815 GOST 11066-74.

(A) EQ.MATERIAL:- (A) SPRING STEEL WIRE GRADE 3 TO IS: 4454-75 (PE4)

00770-ICV	(A)	EQ.MATERIAL ADDED.
v. Ramo	<i>[Signature]</i>	
4 APR 00		
DCI No. & DATE	ISSUE	AMENDMENTS

APPROVED	<i>[Signature]</i> M.VASU	700-38-1318	
CHECKED	<i>[Signature]</i> 22/04/00		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	WIRE-II-2.5, GOST 9389-75	WEIGHT	SCALE
		0.0255	1:1
		SHT	SHTS

700-40-260



- 1) OTHER TECHNICAL REQUIREMENTS ARE AS PER TECHNICAL SPECIFICATION TY B1-04-395-75.
- 2) PART SHOULD CORRESPOND TO APPROVED STANDARD. DIMENSIONS MM.

DESIGNATION	d		D		S		MASS kg	D S CAT PART No.
	NOMINAL	DEVIATION	NOMINAL	DEVIATION	NOMINAL	DEVIATION		
-23	42	+0.7	52	2.0	±0.20		0.0018	
-24	45		55			0.0018		
-25	45		66			0.0044		
-26	50		56			0.0012		
-27	50		60			0.0020		
-28	52	+1.0	62	1.0		0.0021		
-29	66		72		0.003			
-30	68		78		0.0027			
-31	76		85		0.0027			
-32	95		125		0.012			

- (A) EQ. MATERIAL:- VULCANIZED FIBRE SHEET AS PER IS:4820-68
- (B) FOR SHEET THICKNESS ABOVE 1.5 mm.
- (C) IS:4819-68 FOR THICKNESS UP TO 1.4 mm

DESIGNATION	d		D		S		MASS kg	D S CAT PART No.
	NOMINAL	DEVIATION	NOMINAL	DEVIATION	NOMINAL	DEVIATION		
700-40-260	3	+0.5	15	0.6	1.5	±0.15	0.0003	
-01	5		10	0.5			0.0002	
-02	5		12				0.0002	
-03	5		15				0.0002	
-04	6		12				0.0002	
-05	8		14				0.0002	LVZ/RCV-5330-014023
-06	10		16				0.0002	" -5330-014024
-07	12		18				0.0002	" -5330-014025
-08	13		22	-0.6			0.0004	" -5330-014026
(B) -09	14		24				0.0005	" -5330-014027
(B) -10	16	+0.6	22		0.0003	" -5330-014028		
-11	16		27		0.0007	" -5330-014029		
(B) -12	18		26		0.0005	" -5330-014030		
(B) -13	20		25		0.0004	" -5330-014031		
(B) -14	20		30		0.0009			
-15	22	0.7	32		0.0010			
-16	24		32		0.0003			
(B) -17	27		35		0.0009			
-18	30		36		0.0007			
-19	30		40		0.0013			
(B) -20	33	+0.7	45	0.7	0.0017			
-21	37		46		0.0014			
-22	40		48		0.0013			

00867  
N. S. 2001

00829  
-15  
17-10-2000

00770-1CV  
V. R. S.  
4.4.2000

00605-1CV  
21-4-97

DC(I) No. & DATE

ISSUE

AMENDMENTS

(C) IS:4819-68 WAS  
IS:419-68

(B) SHEET THICKNESS ABOVE  
1.5 mm FOR IS:4820-68  
& IS:419-68 FOR  
THICKNESS UP TO 1.4 mm

(A) EQ. MATERIAL ADDED

DRAWING REVISED  
AND RETRACED.  
(2/97 N OF A)

COMPRESSED ASBESTOS  
FIBRE GDE. 0/1 TO IS:2712.

NEAREST EQ. MATERIAL  
FIBRE BOARD GDE. KF Ø (A)  
GOST 14613-69.

ORGL MATERIAL:-

ALL SHARP EDGES & COR-  
NERS TO BE ROUNDED OFF

ALL THREADS TO CONFORM  
TO SPECIFICATION

STAMP OR ETCH, PART No.  
MANUFACTURER'S  
NAME & YEAR OF MFR.

DRG. NOT TO BE SCALED

TOLERANCE ON DIMENSIONS  
UNLESS OTHERWISE  
SPECIFIED

SCALE: SEE TABLE

DATE: 17-4-97

WT :- (Kg)

SEE TABLE

700-40-260

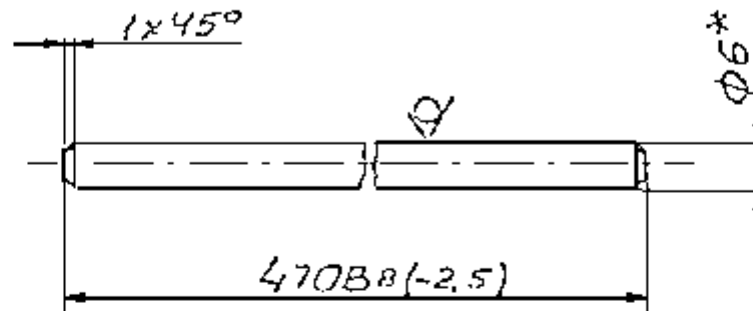
GASKET

DS CAT No.

CONTROLLERATE OF QUALITY ASSURANCE  
(INFANTRY COMBAT VEHICLES)

700-48-178

Rz 80 (✓)



- 1). Alternate material is steel 25 GOST 1050-74.
- 2). Non-straightness should not exceed 0.5 mm.
- 3). \* Dimension is given for reference.

(A) EQ. MATERIAL: - ROUND BAR C20 TO IS: 2073-10

00782-ICV

(A)

5 MAY 2000

ICV

EQ. MATERIAL ADDED.

DC(I)No. & DATE

ISSUE

AMENDMENTS

APPROVED

M. VASU

700-48-178

CHECKED

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

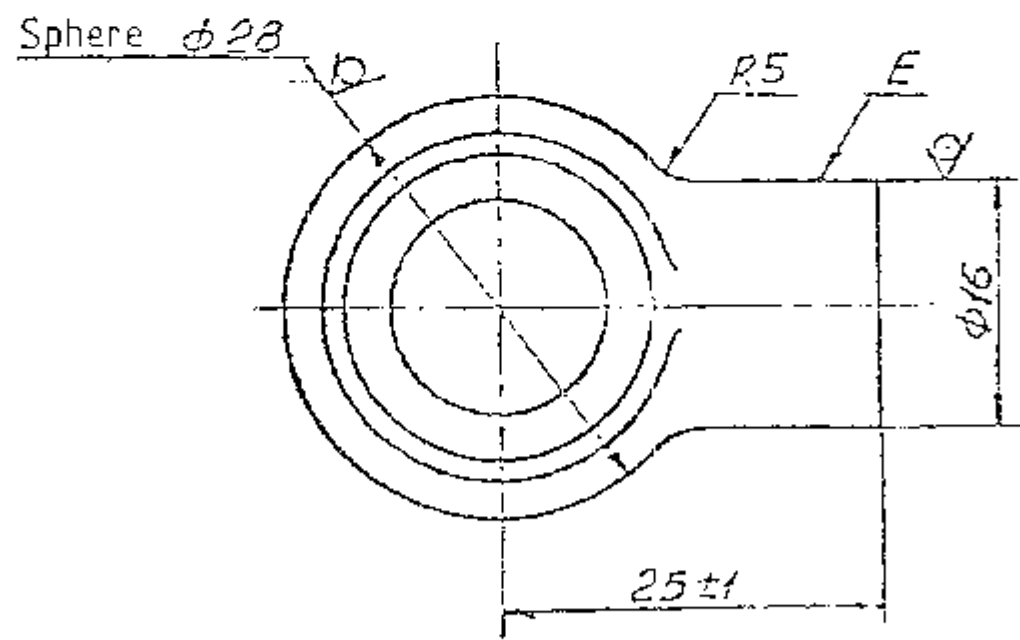
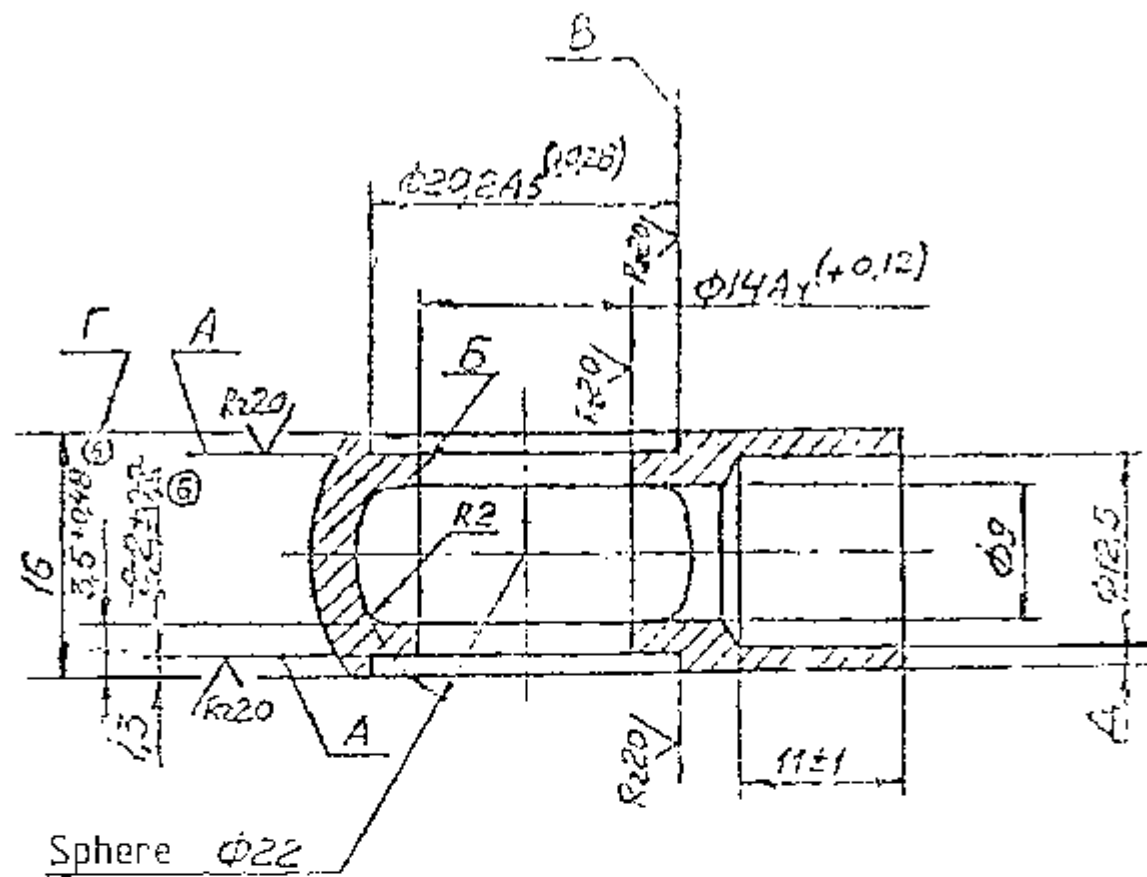
AXLE

WEIGHT SCALE

0.105 1:1

SHT SHTS

ROUND BAR 6-5 GOST 7417-75  
20-B GOST 1051-73



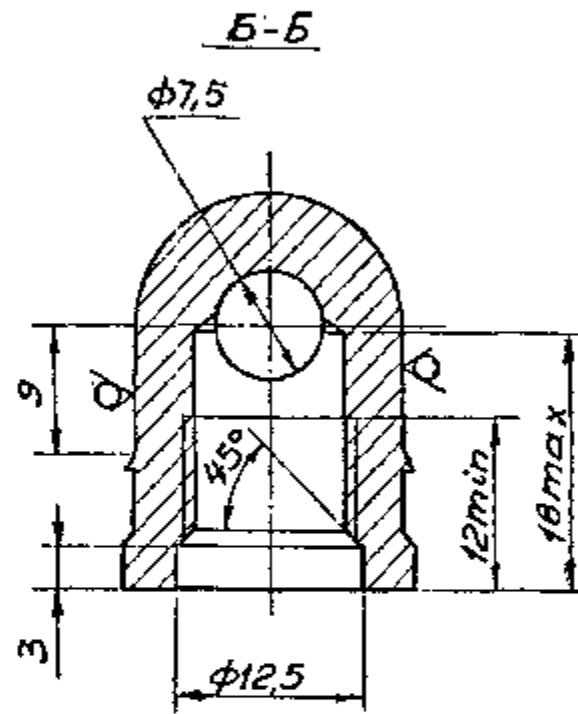
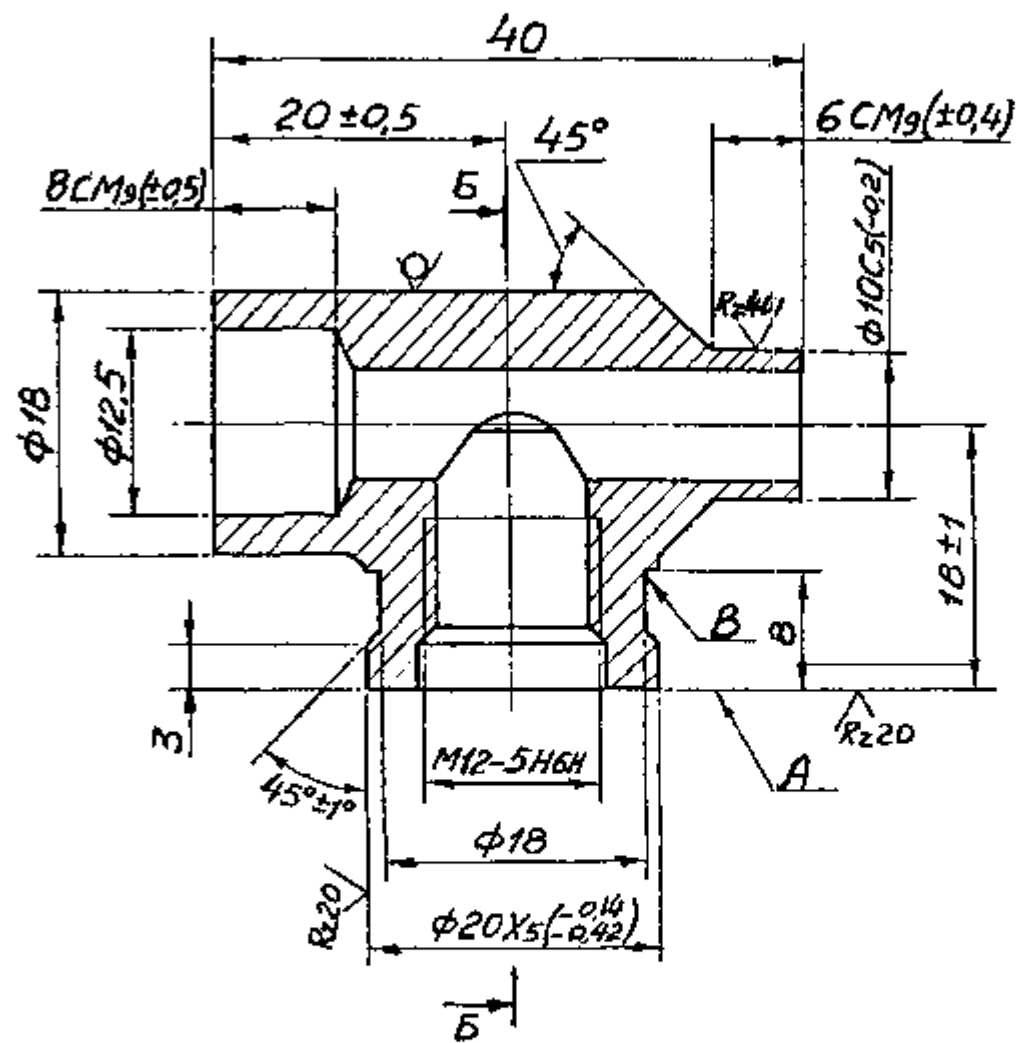
**TECHNICAL CONDITIONS**

1. Alternate material is steel 25,35 GOST 1050-74, and 15F and 20F GOST 4543-71
  2. Rest of the requirements for forging are as per class II, GOST 7505-74.
  3. Unspecified limit deviations of dimensions are as follows for holes-as per A7, for shafts-as per B7 and for the rest as per CMa.
  4. Displacement and skewness of axis of surface E with respect to surface F should not exceed 0,3mm.
  5. Trace due to milling cutter on surface E is allowed.
  6. Non-parallelity of surfaces A should not exceed 0,1mm.
  7. Run-out of surface B with respect to axis of surface B should not exceed 0,1mm (qualified tolerance).
  8. Variation in wall thickness of dimension A should not exceed 0,5mm.
  9. Type of coating. Chemically oxidized, impregnated with oil.
  10. Part may be made from steel 30n-I, 35n-I, 40n-I GOST 977-75 by precision investment coating.
- (A) EQ. MATERIAL : 20 C8 Gde-1 TO IS 9550-80  
 (B) EQ. MATERIAL:- STEEL FORGING CLASS 2A (25 C8) TO IS: 2004-78

00780-ICV V. Comas 24-4-2000	(B)	EQ. MATERIAL ADDED.
00718-ICV V. Comas 12-8-99	(A)	EQ. MATERIAL ADDED.
DCI No. & DATE	ISSUE	AMENDMENTS

APPROVED	<i>M. VASO</i>	<b>700-55-203</b>	
CHECKED	<i>DSKVAJZ</i>		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	<b>SWIVEL ANGLE</b>	WEIGHT	SCALE
		0.07	2:1
STEEL 20, GOST 1050-74		SHT 1	SHTS 1

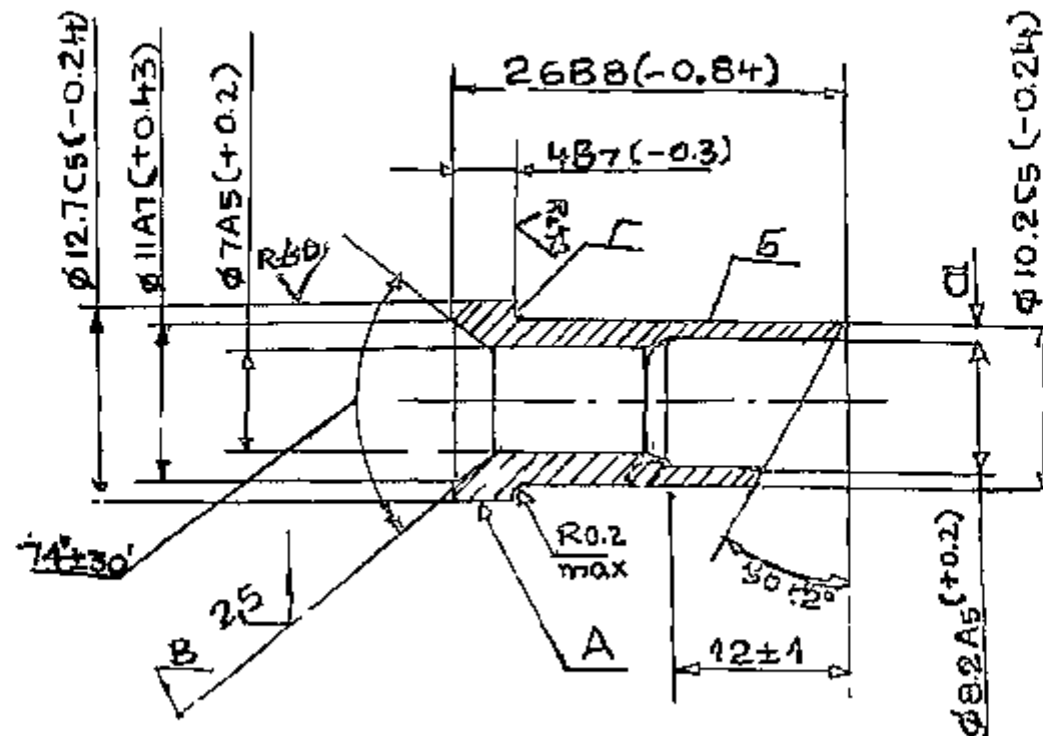
Rz80/√(√)



1. Alternate material is steel cm5, GOST 380-71 and steel 30 and 35, GOST 1050-74.
  2. Unspecified limit deviations of dimensions of surfaces to be machined are as follows:  
 For holes -as per A<sub>7</sub>  
 for shafts -as per B<sub>7</sub>  
 for others -as per CM<sub>8</sub>  
 Other requirements for forging are as per class II, GOST 7505-74.
  3. Unspecified stamping radii should not exceed R5 mm.
  4. Non-squareness of surface A with respect to the angle diameter of thread should not exceed 0.1 mm over a length of 20 mm (Qualified tolerance).
  5. Tool incision of not more than 1 mm is allowed on surface B.
- Ⓐ EQ. MATERIAL: -STEEL FORGING CLASS 2A (2.5 CB) TO IS: 2004-78

007801CV Y. Roman 26 APR 2001	Ⓐ Cann	EQ. MATERIAL ADDED
DCI No. & DATE	ISSUE	AMENDMENTS

APPROVED	<i>M. VAS</i>	<b>700-56-224</b>		
CHECKED	<i>180123 20.04.02</i>			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	<b>T-JOINT</b>		WEIGHT	SCALE
	STEEL 20 GOST 1050-74		0.03	2:1
SHT 1			SHTS 1	



1. ALTERNATE MATERIAL IS STEEL 15, 20, 25 GOST 1050 -74 AND 15Г, 20Г GOST 4543 -71.
2. THE FOLLOWING ARE ALLOWED WITH RESPECT TO SURFACES A AND B MACHINED FROM ONE SETTING.
  - a). RADIAL RUN - OUT OF SURFACE B SHOULD NOT EXCEED 0.15 mm. (QUALIFIED TOLERANCE)
  - b). END - PLAY OF SURFACE C SHOULD NOT EXCEED 0.06 mm
3. DIFFERENCE IN MEASUREMENTS OF DIMENSIONS A SHOULD NOT EXCEED 0.2 mm.

- EQ. MATERIAL :-
- i) STEEL TO IS: 7283-74 (MATERIAL AS PER IS : 226-75 )
  - ii) MATERIAL 10 C4 TO IS: 9550-80 Gr I OR
  - iii) CLASS I A GRADE 15 C8 TO IS, 2004 - 78 OR
  - iv) STEEL BAR C10 OR C14 OR C15 Mn 75 OR C20 OR C25 Mn 75 OR C30 TO IS: 2073 - 70. OR
  - v) STEEL BAR C14 TO IS: 2073 - 70. OR
  - vi) STEEL BAR C15 Mn 75, C20 TO IS: 2073 - 70. OR
  - vii) STEEL BAR C25 Mn 75, C30 TO IS: 2073 - 70

00883-ICV  
 R. Y. Sharma  
 01-06-2001  
 DC(I) No. & DATE

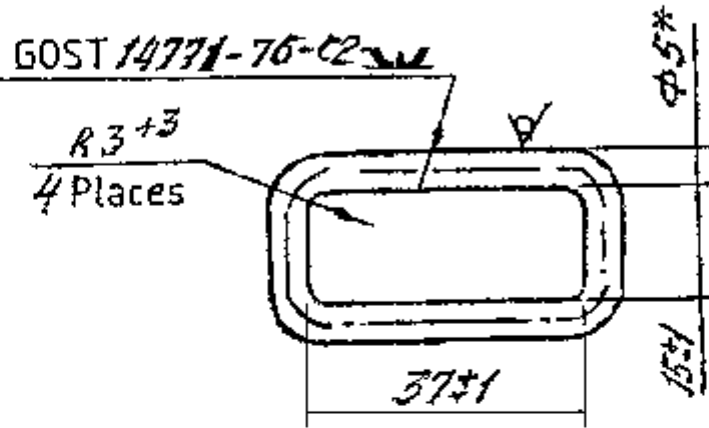
DRAWING REVISED AND RETRACED

ORGL MATERIAL:- STEEL 10 GOST 1050-74		ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART No. MANUFACTURER'S NAME & YEAR OF MFR.	
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON: 785-78-Sb312, 785-10-Sb565, 785-08-Sb422, 785-05-Sb427, 875-04-Sb103, 875-05-Sb136, 875-10-Sb108	
SCALE: 2:1	DATE: 01-06-2001	<h1>NIPPLE</h1>	
DRN. R. Sharma	WT :- (Kg) 0.007		
TCD. R. Sharma		<h2>700-57-403</h2>	
CHD. R. Sharma			
APPD. R. Sharma		DS CAT No.	
<b>CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)</b>			

NOTE: ALL DIMENSIONS ARE IN mm

730-10-41

R2320/ VNI



1. Alternate material is wire, type KC GOST 792-67.
  2. \* Dimension is given for reference.
  - 2K. Gas butt welding may be used.
  - 2 V. Dress weld.
- Ⓐ EQ. MATERIAL: - MILD STEEL WIRE (BRIGHT DRAWN) TO IS: 280-72

00780-ICV V Roman 26 APR 2000	Ⓐ Cura	EQ. MATERIAL ADDED.
IX(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED

CHECKED

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

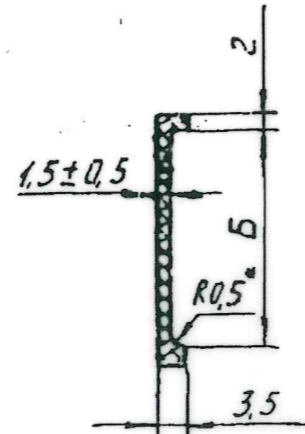
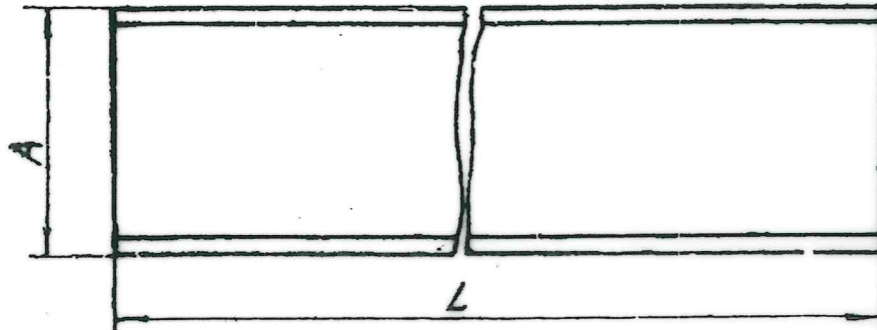
730-10-41

HINGE

WEIGHT	SCALE
0.019	1:1
SHT	SHTS

WIRE 5.0-10 GOST 17305-71

765-06-455 / 461



DESIGNATION	A*	B	L	WEIGHT
765-06-455 (A)	25	21±1	30±1	0,002
(B) 765-06-456 (A)	25	21±1	45±1	0,003
(C) LV2/ICVS 5330395595 765-06-457 (A)	25	21±1	60±1	0,004
(D) LV2/ICVS 5330395596 765-06-458 (A)	25	21±1	95±2	0,006
(E) LV2/ICVS 5330395597 765-06-459	25	21±1	120±2	0,007
765-06-460	35	31±1	170±2	0,014
765-06-461	25	21±1	80±2	0,005

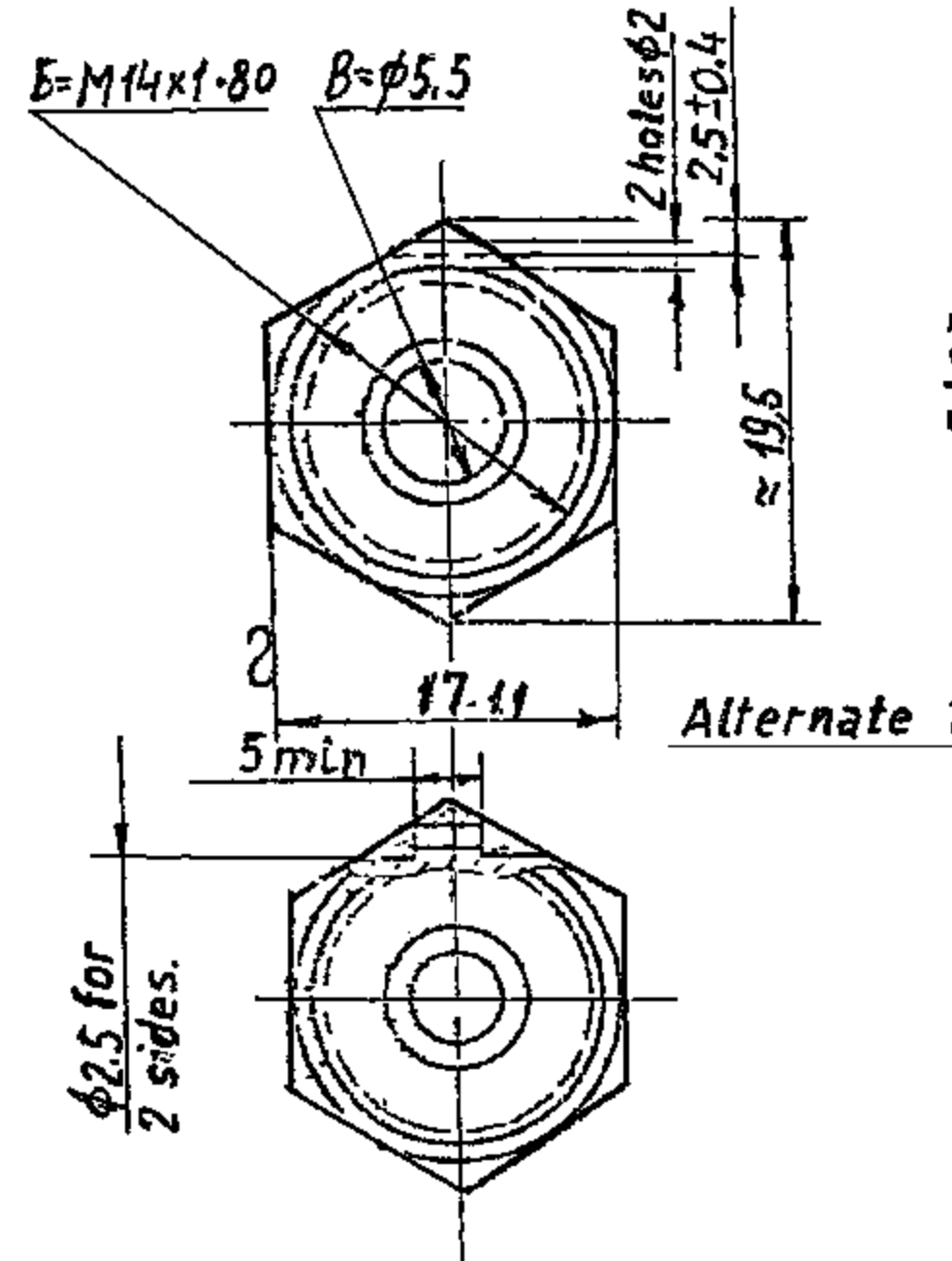
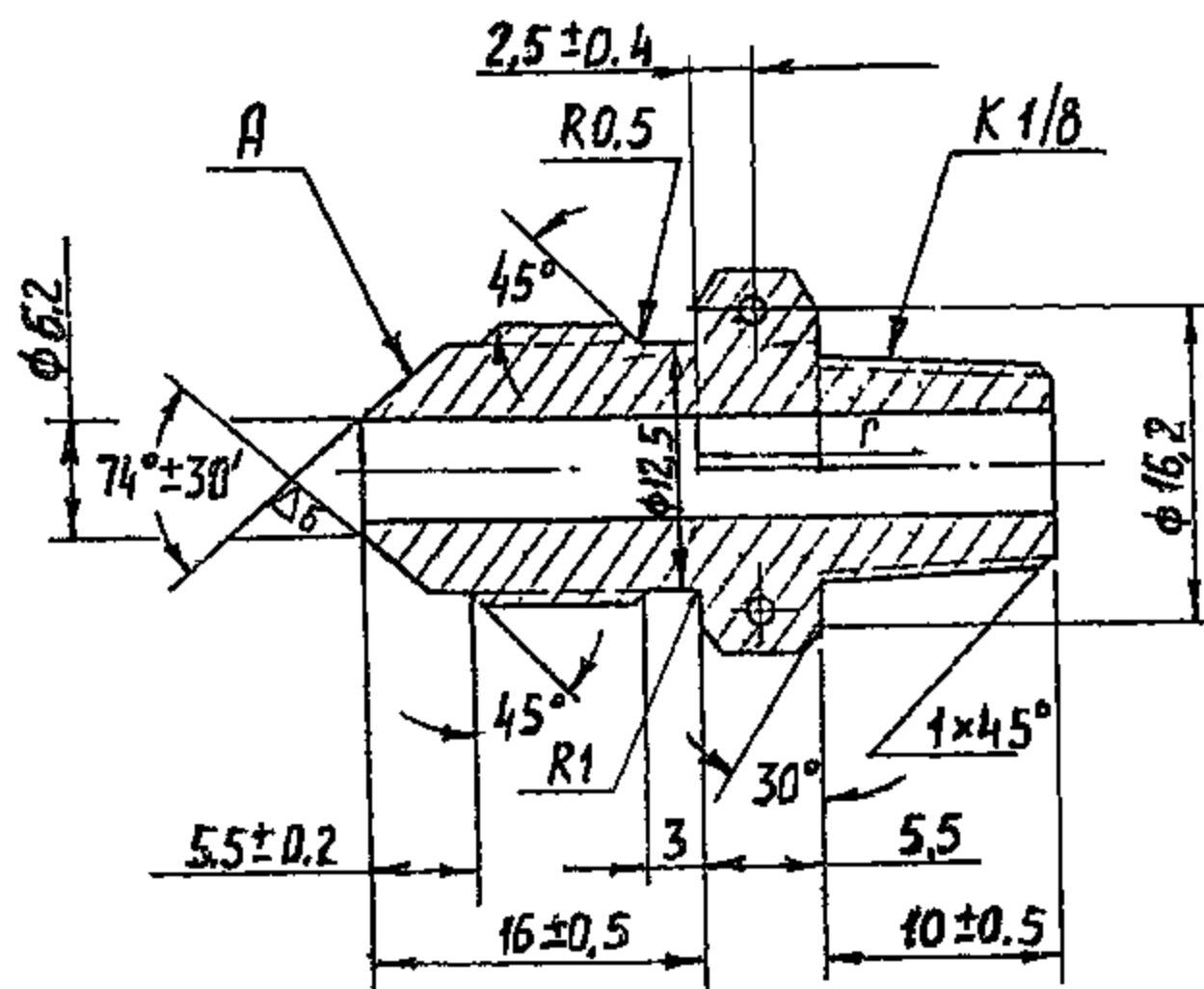
**TECHNICAL CONDITIONS**

- \*PROVIDE DIMENSIONS WITH TOOL.
  - ALTERNATE MATERIAL IS RUBBER 649 TY 005216-75.
  - THE PART IS DELIVERED BY SECTIONS OF ANY LENGTH, BUT NOT LESS THAN 1000 mm.
  - MARK ON TAG.
  - OTHER REQUIREMENTS ARE AS PER TY 005216-75 FOR ITEMS 254112.
- (A) EQ. MATERIAL:- CHLOROPENE RUBBER C-60 TO BS. 2752-82  
 (B) EQ. MATERIAL:- GRADE-BA 70 TO BS: 2751-82.  
 FOR 765-06-456

DC(D) No. & DATE	ISSUE	AMENDMENTS	DC(D) NO. DATE	ISSUE	NATURE OF AMENDMENT
01135-ICV 15-01-2014	(E)	D CAN NO. LV2/ICVS 5330395597 ADDED TO DRG. NO. 765-06-459 AND NOMENCLATURE "GASKET" AMENDED AS "PACKING MATERIAL"	00905-KV 11-12-01	(B)	EQ. MATERIAL ADDED
01135-ICV 15-01-2014	(D)	D CAN NO. LV2/ICVS 5330395596 ADDED TO DRG. NO. 765-06-458 AND NOMENCLATURE "GASKET" AMENDED AS "PACKING MATERIAL"	00848-ICV 11-12-01	(A)	EQ. MATERIAL ADDED
01135-ICV 15-01-2014	(C)	D CAN NO. LV2/ICVS 5330395595 ADDED TO DRG. NO. 765-06-457 AND NOMENCLATURE "GASKET" AMENDED AS "PACKING MATERIAL"			

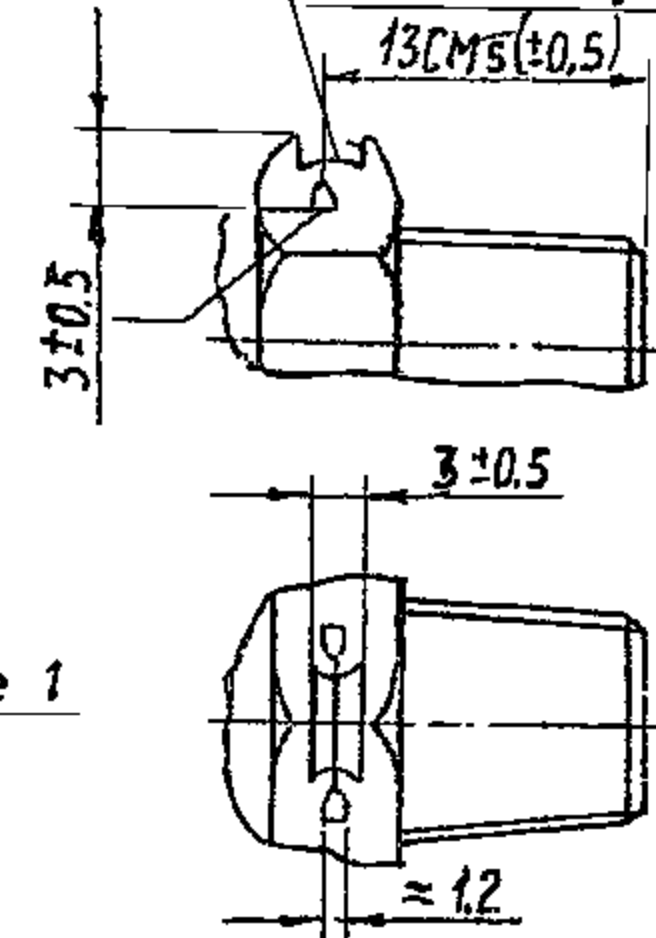
APPROVED	<i>H VASU</i>	<b>765-06-455 / 461</b>		
CHECKED	<i>M. J. ...</i>	<b>GASKET</b> (TABLE DRAWING)	WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)			SEE TABLE	1:1
		(A) RUBBER 637 TY 005216-75		SHT

Kit A  
209  
C7114



Alternate 2

Lock punch Clearance at point should not exceed 0.1 mm



Alternate 1

1. Blunt sharp edges.
2. Run out of surface A with respect to angle diameter of thread B should not exceed 0.05 mm.
3. Perform dimensions without deviations as per accuracy class 7, OST 1010.
4. Coating: Zink-plated, 9 microns thick, chromated. Remove hydrogen embrittlement. Do not check coating on inner surfaces.
5. Misalignment of axes not exceeding 0.5 mm is allowed on section F when hole B is machined on 2 sides.
6. Rod not less than 1 mm in diameter, should pass through hole D.

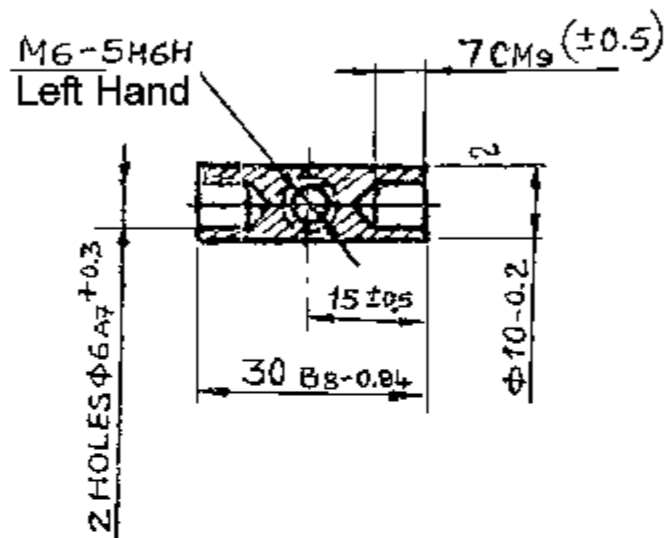
- (A) EQ. MATERIAL CLASS 4 (45 CB) IS. 2004-70
- (B) EQ. MATERIAL:- STEEL BAR GY 3 TO IS: 9550-80
- (C) EQ. MATERIAL:- HEX. BAR C 45 TO IS: 2073-70 OR
- (D) C 45 TO IS: 1570.

DC(1) No. DATE	ISSUE	AMENDMENTS
01019-ICV 24 APR 06	(E)	DS CAT PART No. ADDED AND DESCRIPTION WAS UNION.
00905-ICV 25-09-01	(D)	EQ. MATERIAL ADDED.
00780-ICV 26-4-2000	(C)	EQ. MATERIAL ADDED
00717-ICV 12-8-99.	(B)	EQ. MATERIAL ADDED
00680-ICV 16-02-99	(A)	EQUIVALENT MATERIAL CLASS 4 (45 CB) IS: 2004-70 ADDED IN THE DRAWING

APPROVED	M VASU	765-08-253	DS CAT PART No. (E) LV2/ICVs 4730-007419	
CHECKED			WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		UNION PIPE	0.03	2:1
			SHT 1 SHTS 1	
		45, GOST 1050-74		

765-10-121

UNLESS SPECIFIED OTHERWISE



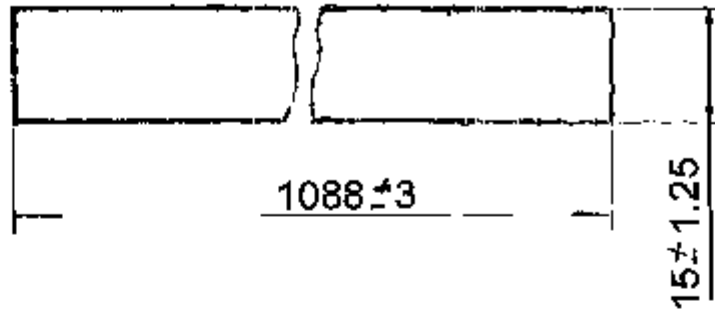
1. ALTERNATE MATERIAL IS STEEL cm6 GOST 380 - 71 AND 35, 40 , 50 , GOST 1050 - 74 AND 40 GOST 4543 - 71.
- 2 COATING : ZINC-PLATED 9 MICRONS THICK , CHROMATIZED, REMOVE HYDROGEN EMBRITTLEMENT INSPECT DIMENSIONS BEFORE COATING
3. HOLES MAY BE FREE OF ZINC - PLATING

EQUIVALENT MATERIAL ROUND BAR C-40 TO IS 2073 - 70.,  
BRIGHT BAR TYPE 'O' Gde 2(25 C8) TO IS 9550-80

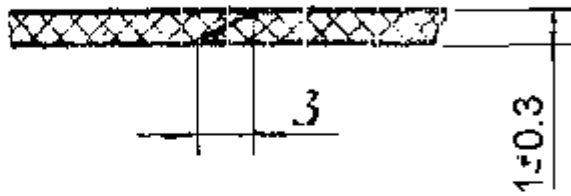
NEAREST EQVT MATERIAL		00877 -107  U.S. Col Gen	DRAWING REVISED, RETRACED, AND DS. CAT NO ADDED
ORGL MATERIAL 20 GOST 1050-74			ISSUE
ALL SHARP EDGES & COR- NERS TO BE ROUNDED OFF.	ALL THREADS TO CONFORM TO SPECIFICATION.	STAMP OR PCK, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.	
DRG. NOT TO BE SCALED	SCALE:- 1:1	USED ON:- 765.10.C8450	
DATE :- 11.5.2001	TOLERANCE ON DIMENSIO- NS UNLESS OTHERWISE SPECIFIED		
DRN.	WT :-(Kg) 0.0135	<b>SHAFT</b>	
ECN.	 DRAWING NO <b>765-10-121</b>	DS/CAT PART NO LV2/RCV 5315-006794	
CHK.			
APD.	<b>CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)</b>		

NOTE:-  
1. All Dimensions are in mm.

765-10-385



Band by vulcanizing



1. Gasket may be made from two parts, band with adhesive No. 1 and thin vulcanize as per instructions, 053.25200.00004.
2. Other requirements are as per Technical specifications Ty 005216-75.
3. Alternate material is rubber 632.638-1, Ty 005216-75.

Material : Plate 254311-1 Ty 005216-75, (A)  
Rubber 637

ICV No. & DATE

ISSUE

AMENDMENTS

APPROVED

*M. V. S.*

CHECKED

*H. M. S.*

765-10-385

CONTROLLERATE  
 OF  
 QUALITY ASSURANCE  
 (ICV)

GASKET

WEIGHT SCALE

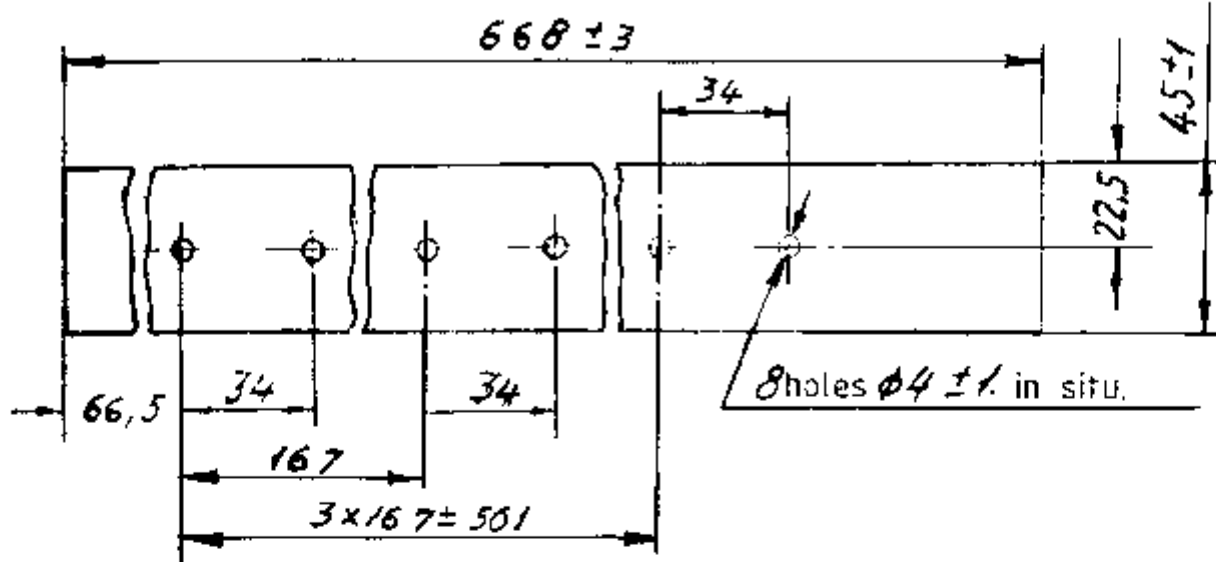
0.013 1:1

SHT

SHTS

SEE ABOVE

765-10-747



Thickness  $10 \pm 0.5$

1. Deviation of centres of holes from their true position should not exceed 2mm
2. Other requirements are as per Technical specifications Ty 38-105817-81.
- ③. Two parts may be pasted with adhesive N88 Hn Technical specifications Ty38-105540-73 according to sketch OR FEVICOL SR998.

Pasting sketch



4. Alternate material is spongy plate Igr pressed type Technical specifications Ty 38-105867-75.

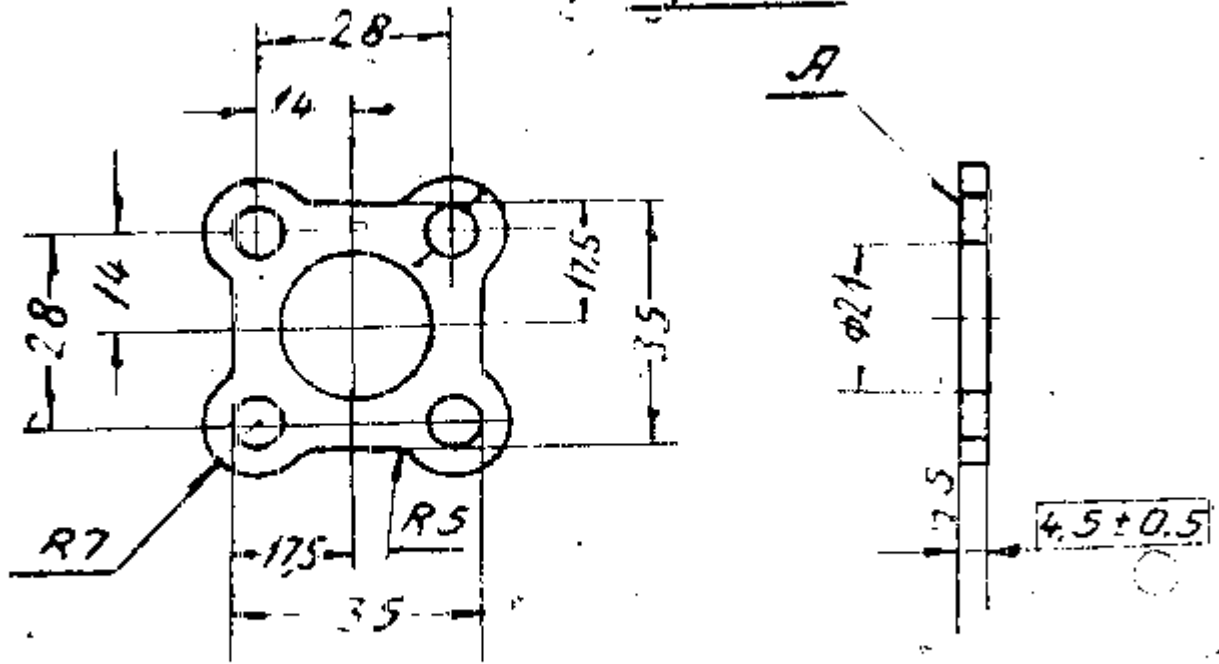
00799- -ICV V. Ramani 01.5.2000	② Grun	D.S. CAT No. ADDED.
00770-ICV V. Ramani A.4.2000	① Grun	EQ. MATERIAL ADDED
DC (I) NO DATE	ISSUE	NATURE AMENDMENT

APPROVED	M. VASU	<b>765-10-747</b>	D.S. CAT NO: ② LV2/RLV-5330-021386	
CHECKED	D. SKUMAR		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	<b>GASKET</b>	0.15 1:2		
		SHT 1 SHTS 1		
		spongy plate Igr press type TY 38-105817-81		

765-10-841

Unless otherwise specified

4 Holes  $\phi 7$



- 1) Blunt sharp edges.
- 2) Displacement of axes of holes should not exceed 0,25 mm from true position.
- 3) Machine dimension  $\pm$   in assembly.
- 4) Non-flatness of surface A should not exceed 0,2mm.
- 5) Alternate material is steel cm6cn, GOST 380-71. and 20 GOST 1050-74
- 6) Perform dimensions without deviations with accuracy of  $\pm 0,5$  mm.
- 7) Stamping draft should not exceed 0,5 mm.

APPROVED

M. VASIL

765-10-841

223 of 342

CHECKED

D.S. KUMAR

WEIGHT

SCALE

CONTROLLERATE

FLANGE

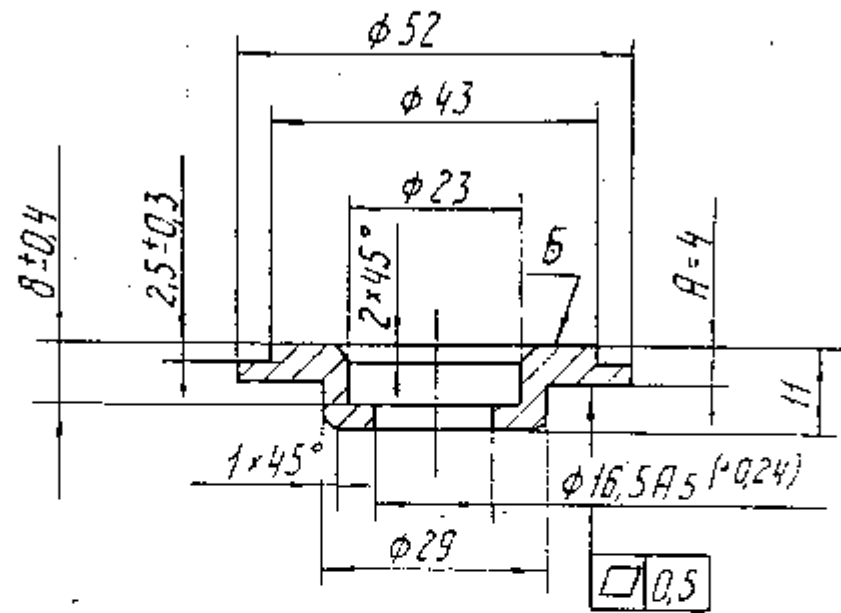
SHT

SHTS

INSPECTION

STEEL cm5cn GOST 380-71

REV



1. Alternate material is steel cm6cn ГОСТ 380-71 and 15, 20, 25, 30, 45 ГОСТ 1050-74.
2. Coating: Zinc-plated, 9 microns thick, chromated. Remove hydrogen embrittlement.
3. Unspecified limit deviation of dimensions are as follows:  
For holes - as per A<sub>7</sub>  
shafts - as per B<sub>7</sub>.
4. Washer may be made by precision investment casting material.

Casting I OST 3-4365-79  
45 GOST 977-75 in this case:

- a) Unspecified casting radii should not exceed 1 mm.
- b) Other requirements as per OST 3-4365-79.
- c) Perform dimension A=4.5
- d) Feeder trace on surface B should not exceed 0.3 mm.
- e) Alternate material

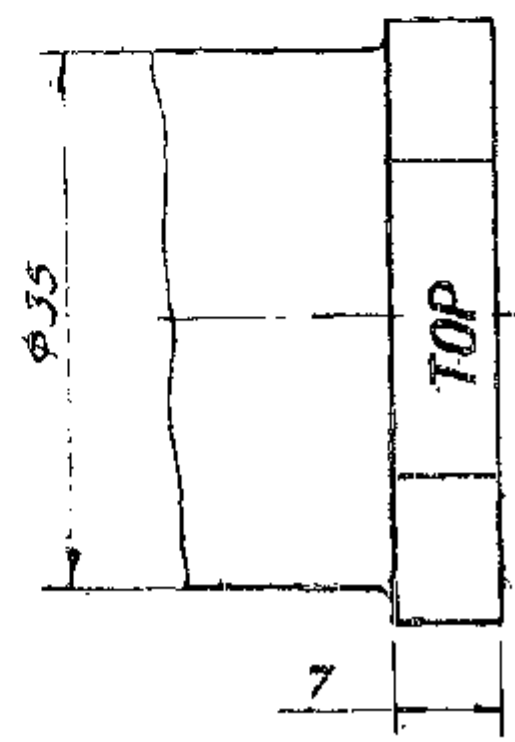
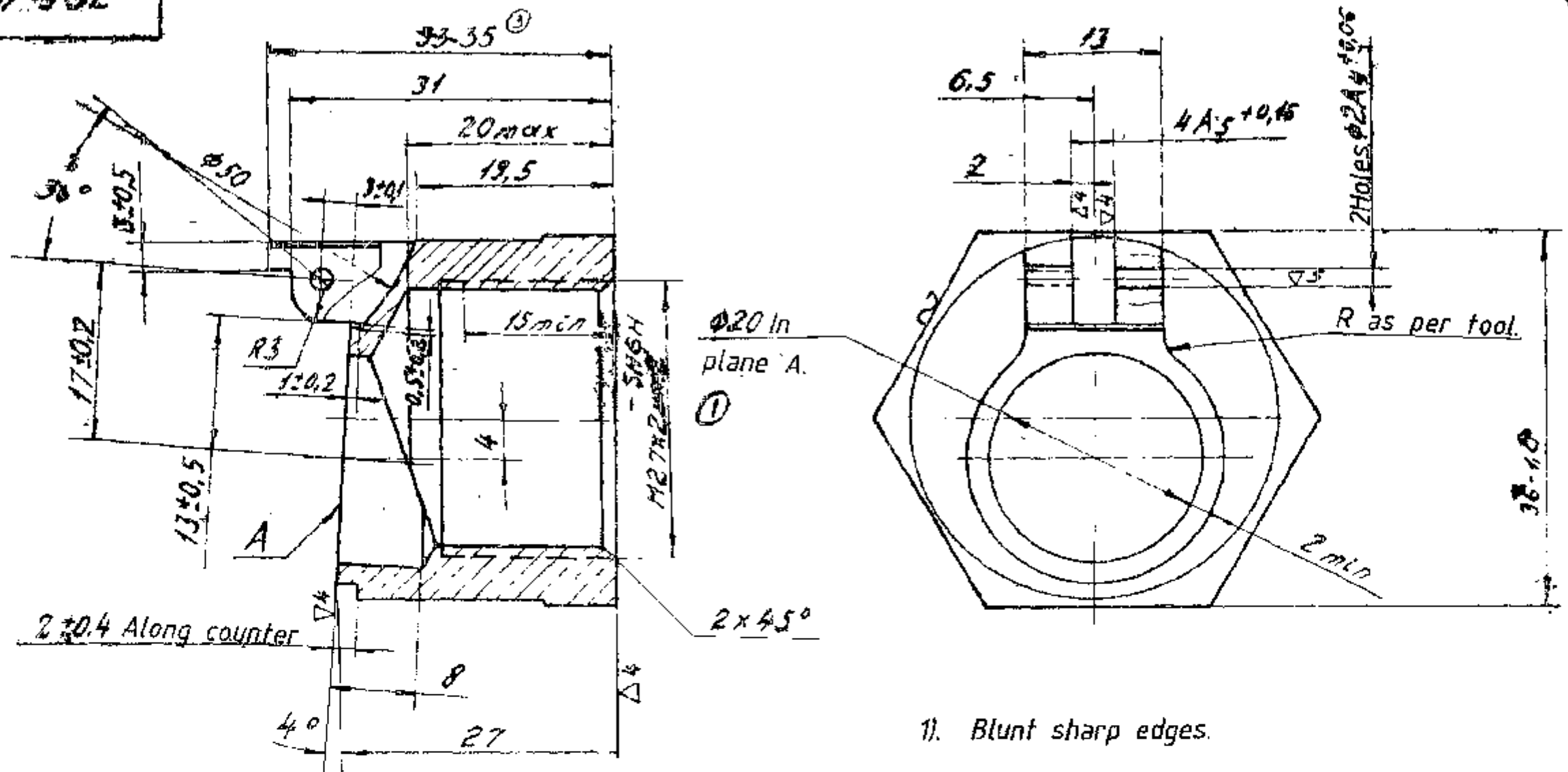
Castings I OST 3-4365-79 I OST 3-4365-79  
30A GOST 977-75 35A GOST 977-75 and  
I OST 3-4365-79  
40A GOST 977-75

- (A) EQ. MATERIAL - ~~HOT ROLLED STEEL SHEET ST 34 TO IS: 1074-73~~
- (B) EQ. MATERIAL - HOT ROLLED STEEL SHEET ST 34 TO IS: 1079-73

17-436  
 12-482  
 27-3-2002  
 4-4-2000  
 DC (1) NO  
 DATE

00931-1CV 27-3-2002	(B)	EQ. MATERIAL HOT ROLLED STEEL SHEET ST 34 TO IS: 1079-73 ADDED & ISSUE (A) CANCELLED
00770-1CV 4-4-2000	(A)	EQ. MATERIAL ADDED
DC (1) NO DATE	ISSUE	NATURE AMENDMENT

APPROVED:	765-10-1087	
CHECKED: H.M. SHERK	238 of 342	
CONTROLLERATE OF INSPECTION (ICV)	WASHER	WEIGHT SCALE
		0.073 1.1
	STEEL CM 5C N ГОСТ 380-71	SHT SHTS

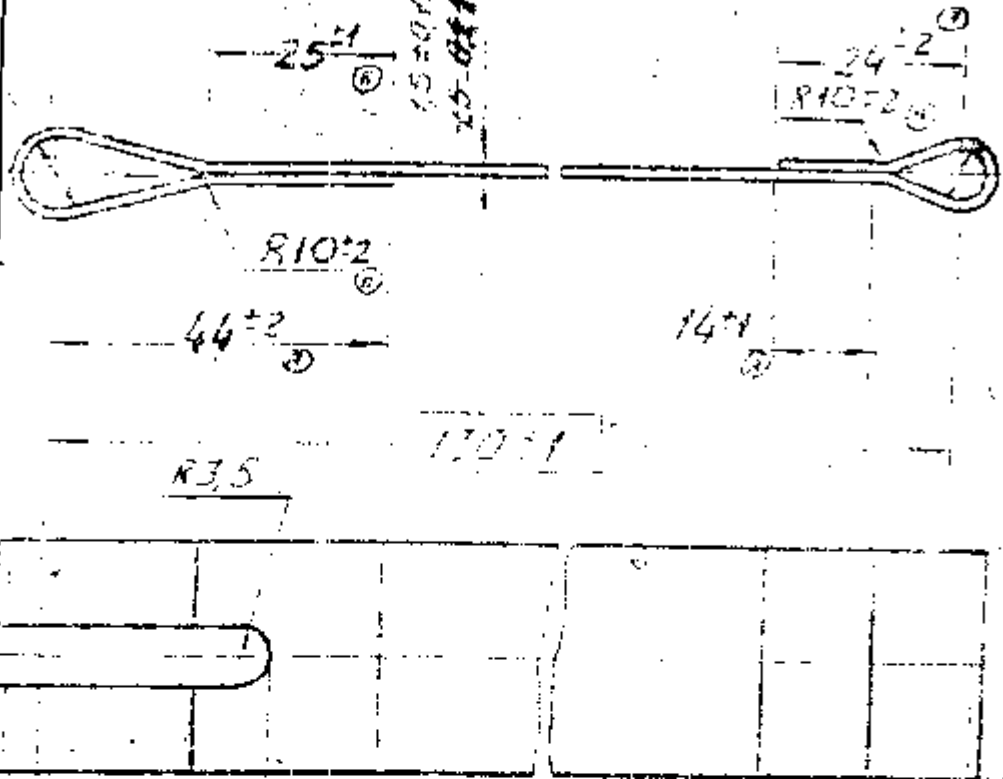


- 1). Blunt sharp edges.
- 2). Perform dimensions specified without deviations: diametric dimensions as per accuracy class 7, length as per accuracy class 8 OST 1010.
- 3). Non-flatness of surface A should not exceed 0.2 mm.
- 4). Apply letters by pressing to a depth not exceeding 0.2 mm, size of type should be 5.

01092 REV	DS CAT NO. LV2/ICVS 3040-023164 ADDED AND NOMENCLATURE "BODY" AMENDED AS "ADAPTOR HOUSING"	AMENDMENTS
ADD DATE		

APPROVED	27/10/90	DS CAT NO: LV2/ICVS 3040-023164	765-10-1100	239-7342
ISSUED	H.M. Shaikh	ADAPTOR HOUSING		
CONTROLLERATE OF INSPECTION (ICV)		BODY		
		BOP 416T W 36H FOCT 21488-76		
		0 05 2		SHT / SHIS

00780-1CV  
 V. Romanov  
 26.4.2000  
 DATE  
 ISSUE  
 NATURE  
 AMENDMENT



- (B) EQ. MATERIAL: - HOT ROLLED STEEL SHEET ST-34 TO IS: 1019-73 OREN 2B (KILLED STEEL) TO 85:970
- 1) Perform dimension specified without deviations with an accuracy of  $\pm 0,5$  mm.
  - 2) Blunt sharp edges.
  - 3) Machine dimensions given in  in assembly.

(A) EQ. MAT: COLD ROLLED LOW CARBON STEEL STRIP G&EVO ANNEALED TO IS: 513-86.

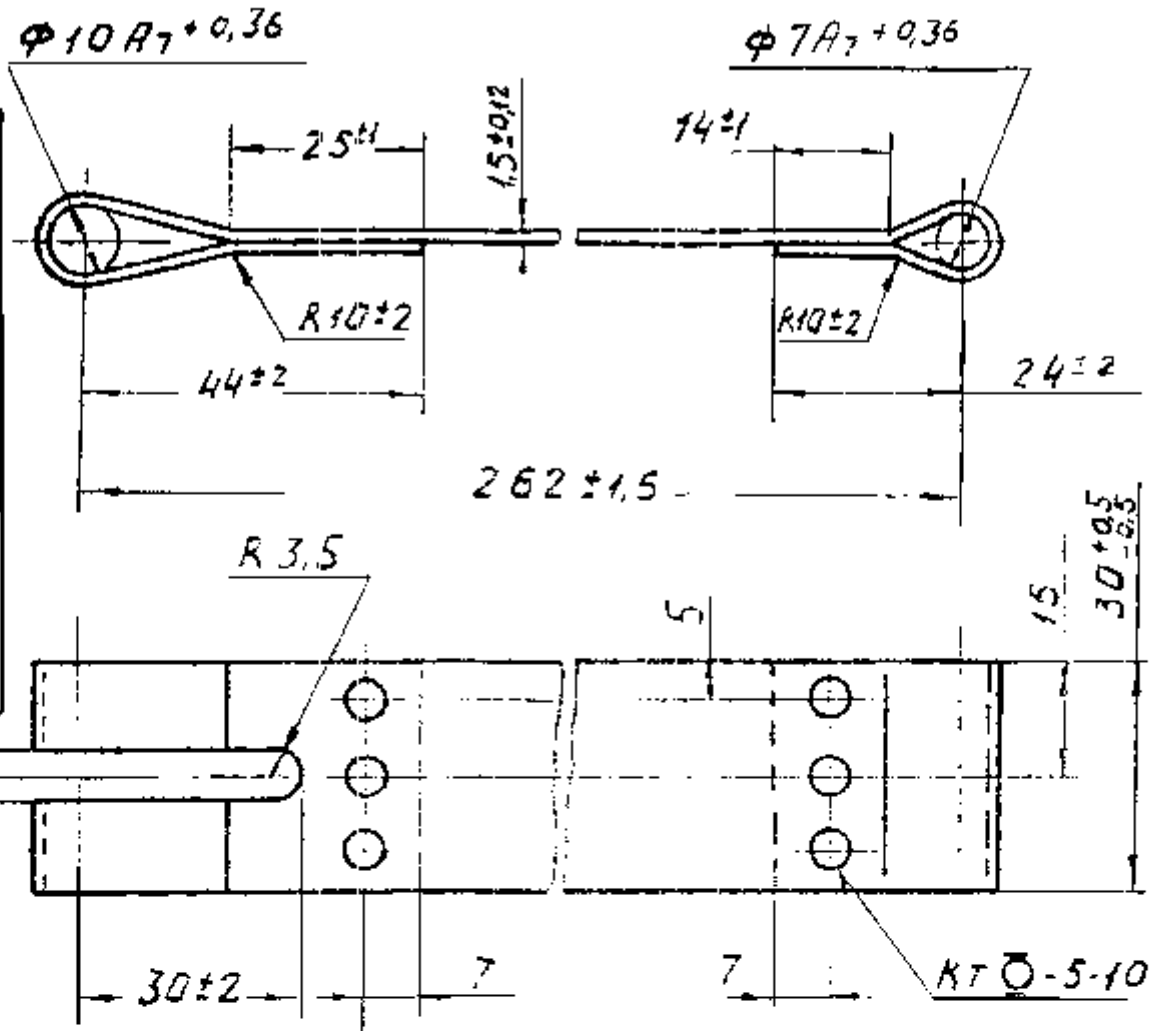
00780-1CV Bulb 15-1-95	(A)	NOTE NO. 4 FOR EQUIVALENT MATERIAL NEWLY ADDED (P-11512)
001016 DATE	ISSUE	NATURE
AMENDMENTS		

APPROVED	M. V. ASD	765-10-1146	242 of 342
CHECKED	H. M. Shevchuk		
CONTROLLERATE OF INSPECTION (ICVI)	BAND	WEIGHT	SCALE
		0.085	1:1
		SHT	SHTS
	10	FOCT	1050-74

765-10-1147

2

06497-ICV Rings 16-1-95	DEC NO. & DATE	AMENDMENTS
(A)	15806	NATURE
		(D=1-51)



- (A) 5). EQ. MATL. :- COLD ROLLED LOW CARBON STEEL STRIP 0.42 'O' ANNEALED TO IS: 513-84.
- 1). Perform dimensions specified without deviations with an accuracy of  $\pm 0.5$ .
  - 2). Blunt sharp edges.
  - 3). Apply primer all over with -03-K GOST 9109-81. and paint with enamel n $\phi$ -223 Dark-gery GOST 14923-78.
  - 4). Coating: Chemically parkerized, chromated.
- (B) EQ. MATERIAL: - HOT ROLLED SEEL SHEET St-34 TO IS: 1079-73

00782-ICV v. Romagosa	EQ. MATERIAL ADDED	NATURE AMENDMENT
09-5-2080	(B)	ISSUE
DATE		

APPROVED  
CHECKED  
CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

*[Signature]*  
H M Sh... KH

765-10-1147

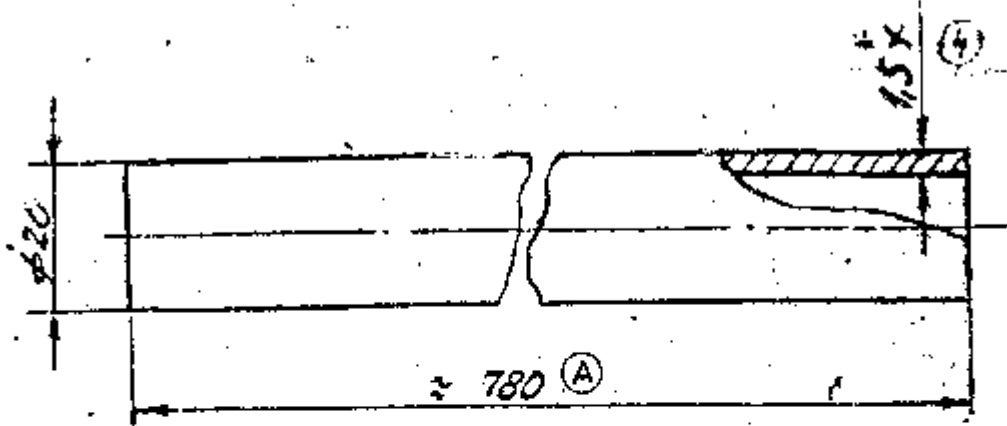
WEIGHT SCALE

0.13 1:1

SHT SHTS

10 OCT 1050-74

BAND



- (B) EQ. MATERIAL:- C D S TUBE 4 TO IS: 3074-65
- 1). Blunt sharp edges.
  - 2). Anneal and clean off scale.
  - 3). Sandblast.
  - 4). Bend the tube and make length more precise using standard made in situ.
  - 5). Ovality and corrugations not exceed 2 are allowed in places of bending.
  - 6). Bending tool, traces which do not damage the surface, are allowed.
  - 7). \* Dimension is given for reference.

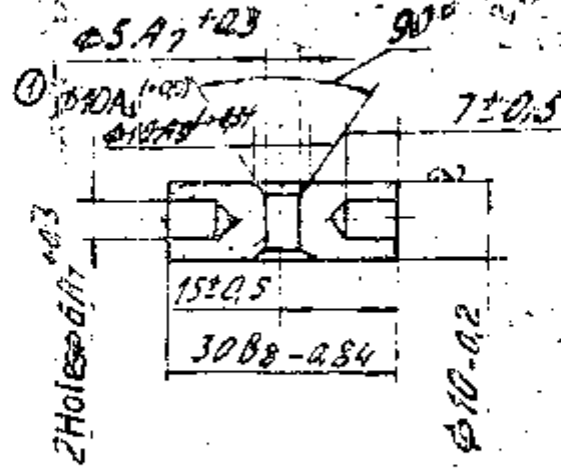
20x1.5 FOCT 8734-75  
 Material:- Tube B70 FOCT 8733-74

00782-ICV V. Ramo 09-5-2000	(B)	EQ. MATERIAL ADDED
00141-ICV 26-12-89	(A)	LENGTH OF PIPE WAS 650
DC(D) No. & DATE	ISSUE	NATURE
AMENDMENT		

APPROVED	H. M. Sharma	765-10-1165	344 of 242
CHECKED	H. M. Sharma		244 of 242
CONTROLLERATE OF INSPECTION (ICV)	PIPE	WEIGHT	SCALE
		3445	1:1
		SHT	SHTS
	SFE ABOVE		114

765-10-1387

Unless stated otherwise



EQ. MATERIAL ADDED	NATURE AMENDMENT
(B)	ISSUE
00780-1CV V-020-03-2	DC (D) NO
26-4-2000	DATE

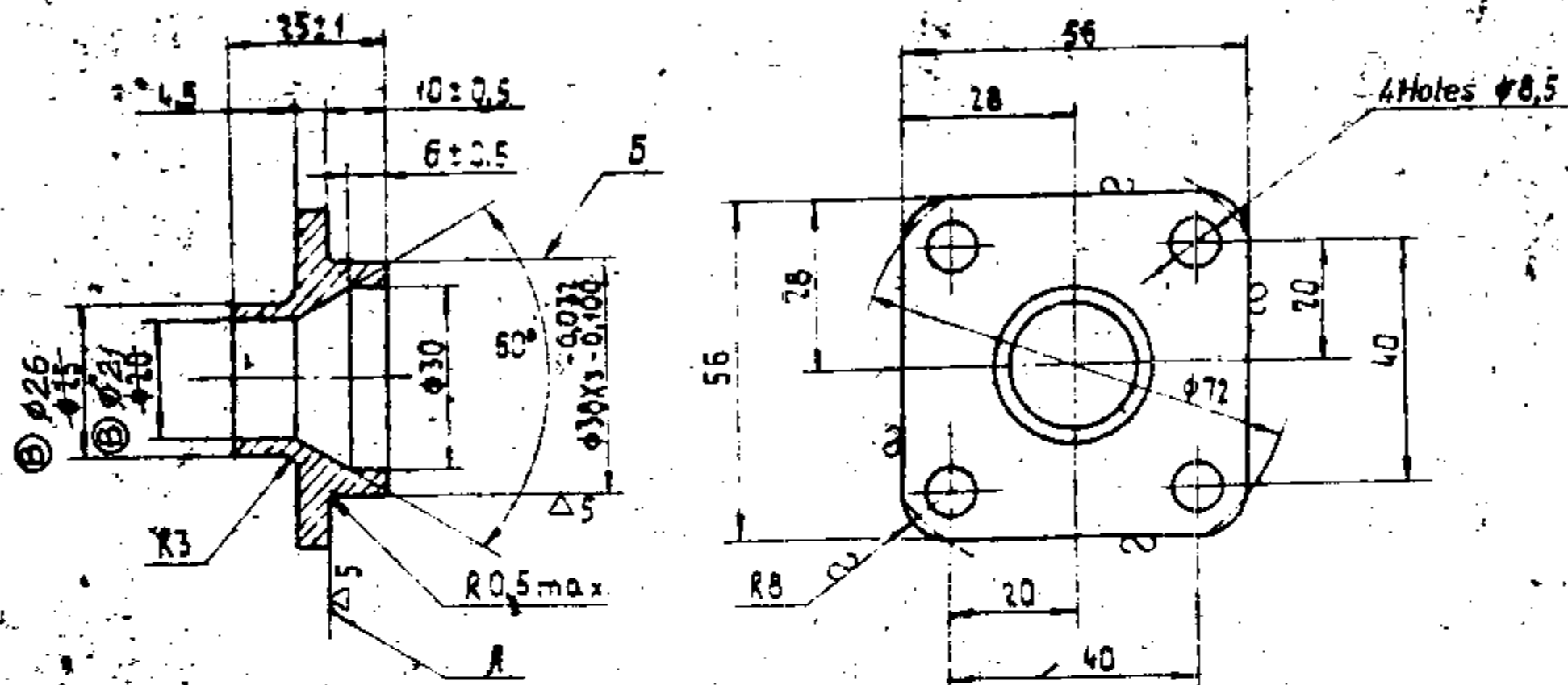
- Blunt sharp edges.
- Alternate material is 25 GOST 1050-74.

- (A) 3. EQ. MATL. 1- BRIGHT BAR TYPE 0' Gdc 2 (25CB) TO IS: 9550-80.
- (B) EQ. MATERIAL: - STEEL BAR C-25 TO IS: 2073-70

00450-1CV 26-8-94	(A)	NOTE No. 3 FOR EQUIVALENT MATERIAL NEWLY ADDED. (D-1151)
DC (D) No. & DATE	ISSUE	NATURE
AMENDMENTS		

APPROVED	M. V. V. S. O.	765-10-1387 250 of 342		
CHECKED	H. M. Shaukh			
CONTROLLERATE OF INSPECTION (ICV)	SHAFT		WEIGHT	SCALE
			0.014	1:1
			SHT	SHTS
		20 GOST 1050-74		

▽ 3 Unless stated otherwise



- 1) Blunt sharp edges.
- 2) Perform dimensions specified without deviations as per accuracy class 7, OST 1010.
- 3) Non-flatness of surface A should not exceed 0,25 mm.
- 4) Non-squareness of surface A with respect to the axis of surface B should not exceed 0,2 mm over length 50mm.
- 5) Displacement of axes of holes from true position should not exceed 0,25 mm.
- 6) Flange may be made along the conventional dotted line.
- 7) Alternate material is steel cm5, GOST 380-71 and 25, 30, 35, GOST 1050-74.
- 8) Other requirements placed upon forging are as per class II GOST 7505-74.
- 9) Local recesses not exceeding 0,7 mm are allowed on unfinished surfaces.
- 10) Flange may be made by precision investment casting in this case :-
  - a) Perform dimensions specified without deviations as per accuracy class 7, OST 1010.
  - b) Unspecified radii should not exceed R1,0 mm.
  - c) Pattern drafts shouldnt exceed 1°.
  - d) Displacement along the part line should not exceed 0,3 mm.

e) Knock-out traces should not exceed 0,3 mm.

f) Material is casting OST 3-4365-79

g) Surface finish should not be worse than that specified in the drawing.

h) Other requirements placed upon casting are as per OST -3-4365-79.

Ⓐ EQ. MATERIAL:- STEEL FORGING CLASS 2A (25C8) TO IS: 2004-78  
 CARBON STEEL CASTING 20-40 TO IS: 1030-74

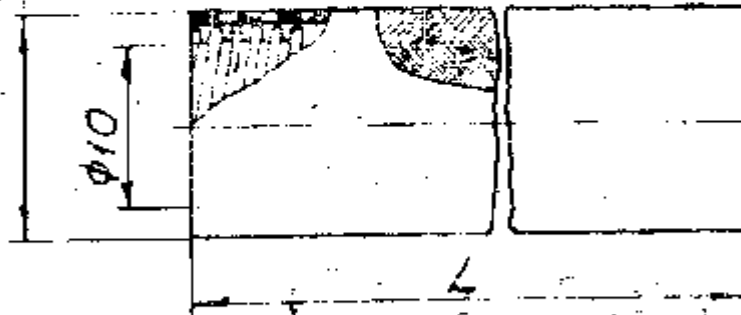
00876-100	Ⓐ	DIMENSION φ21 WAS φ20
11.5.2001	Am	DIMENSION φ26 WAS φ25.
00782-100	Ⓐ	EQ. MATERIAL ADDED
09.5.2000	Am	NATURE
DCUT No	ISSUE	AMENDMENT
DATE		

APPROVED	IS WAS	765-10-1417		251
CHECKED	H.M. Shaikh			242
CONTROLLERATE OF INSPECTION (ICV)		FLANGE		WEIGHT
				SCALE
		20 OCT 1050-74		0.14
				1:1
				SHT
				SHTS

Имя и фамилия инженера  
 Имя и фамилия мастера  
 Имя и фамилия оператора  
 Имя и фамилия рабочего

765-10-1496/1497

$\phi 15,5 \pm 0,5$



**MATERIAL**

- 1). Alternate is pressure-tight hose PTC 8A 0.449.118-10
- 2). Other Specifications are as per 8A 0.449.117 Ty.

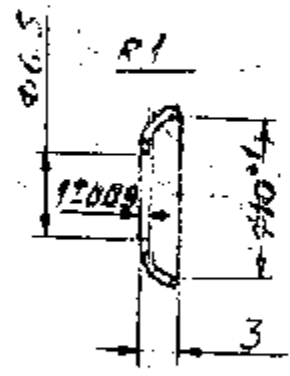
Designation	L	Weight
765-10-1496	570 <sup>10</sup>	0.186
765-10-1497	200	0.060

APPROVED	<i>M. V. V. V.</i>	765-10-1496/1497		252 of 342	
CHECKED	<i>H.M. Skanick</i>	HOSE		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)				SEE TABLE	2:1
		Pressure-tight hose CPFC 8A 0-449-117 TY		SHT	SHTS

765-10-1695

2

80770-1CV	V. Rana	(A)	EQ. MATERIAL ADDED
4.4.2000			
DECLD NO			
Date			
ISSUE			
NATURE			
AMENDMENT			



1. BLUNT SHARP EDGES.
  2. PERFORM DIMENSIONS WITHOUT DEVIATIONS WITH ACCURACY OF  $\pm 0.5\text{mm}$ .
  3. DISTORTION OF EDGES AND ECCENTRICITY ARE ALLOWED WITHIN THE LIMIT OF TOLERANCE ON DIMENSIONS.
  4. COATING: ZINC-PLATED, 9 MICRONS THICK, OILED. REMOVE HYDROGEN EMBRITTLEMENT.
- (A) EQ. MATERIAL (A) HOT ROLLED STEEL STRIP GRADE 5E-34 TO IS: 1078-73 OR EN 28 (KILLED STEEL) TO BS 970.

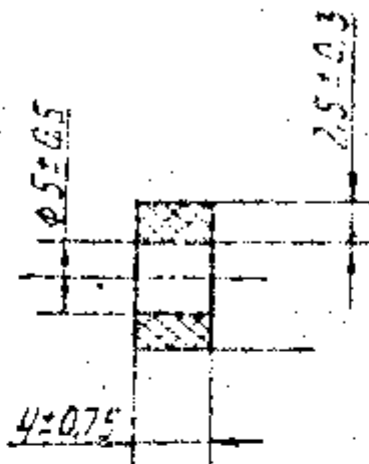
Doc

APPROVED	M. VASU	765-10-1695	
CHECKED	H.M. SL. KL	WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)		0.003	2:1
		SHT	SHTS
STEEL 10		10CT1050-74 (A)	81 OF 92

9691-01-591

Спецификация

Спецификация



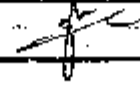
1. MARK ON TAG.
2. OTHER REQUIREMENTS ARE AS PER TECHNICAL SPECIFICATIONS TY 005216-75, FOR ARTICLES CODE 254120.

ПОСЛ. Ч. ЛСТ

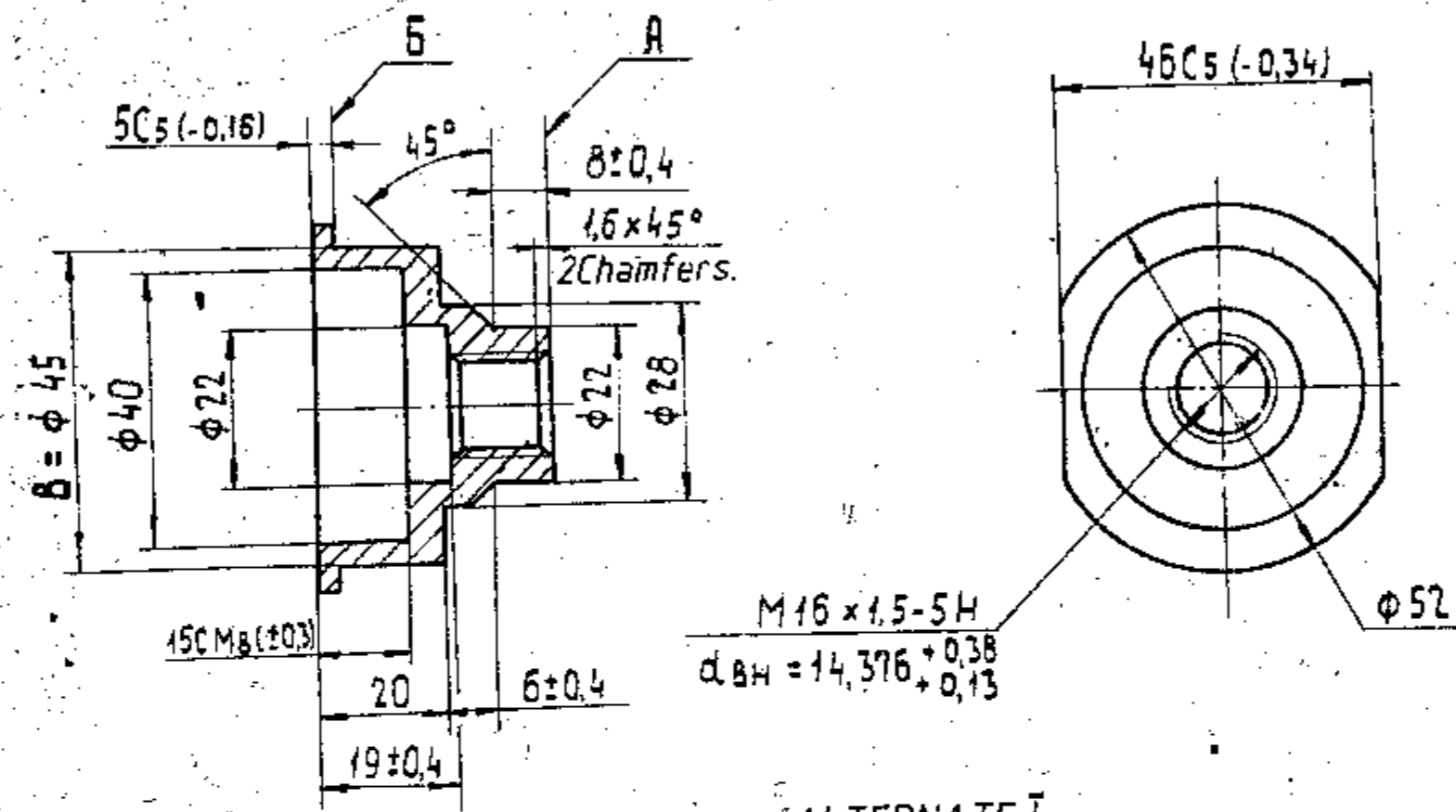
ЧИС. Ч. ЛСТ

ЧИС. Ч. ЛСТ

209 of 372

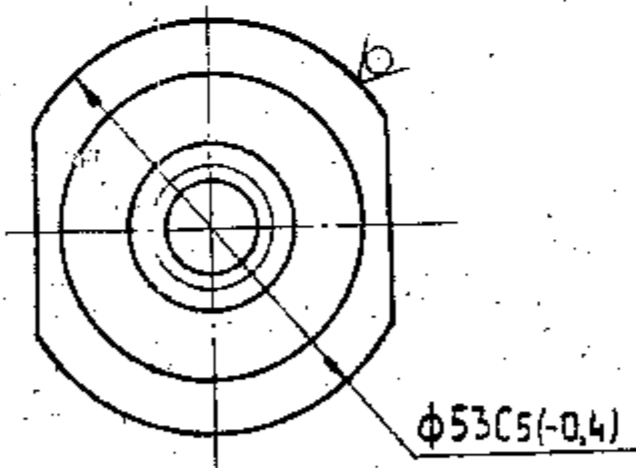
APPROVED		С. ВАСИ	765-10-1696		
CHECKED			BUSHING	WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)				0.003	2:1
			SMT	SMTS	
RUBBER 637 TY 005216-75 <sup>(A)</sup>					

765-10-1723

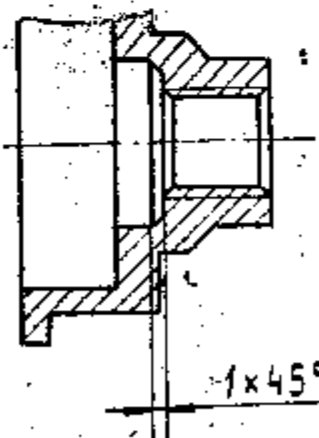


M16 x 1.5-5H  
d.BH = 14.376 +0.038  
+0.13

ALTERNATE I



ALTERNATE



- 1). Alternate material is steel cm6cn, GOST 380-71, and steel 15, 20, 25, 30, and 45, GOST 1050-74. R280
  - 2). Unspecified limit deviations of dimensions are as follows; for holes - as per A7, for shafts - as per B7.
  - 3). Non-squareness of surface A with respect to axis of thread should not exceed 0.1 mm over a length of 15 mm (Qualified tolerance).
  - 4). Non-squareness of surface B with respect to axis of thread should not exceed 0.5mm over a length of 40 mm.
  - 5). Coating: Zinc-plating, 9 microns thick, chromating. Remove hydrogen embrittlement.
  - 6). The nut may be made by precision investment casting. Material is casting: OST-4365-79 in this case: 30A-GOST 977-75.
    - a). alternate material is casting OST-4365-79 35A-GOST 977-75.
    - b). unspecified casting radii should not exceed 1mm.
    - c). other requirements are as per OST 3-4365-79.
    - d). Incision not exceeding 0.2 mm is allowed on surface B.
- (A) EQ. MATERIAL - (B) STEEL BAR C-40 TO IS: 2073-70

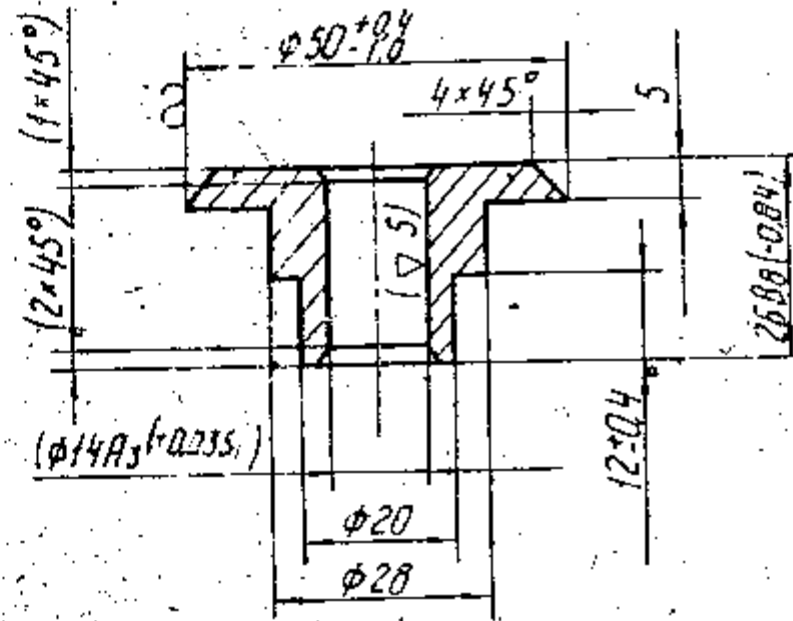
Подп. и дата. Подп. и дата. Подп. и дата. Подп. и дата. Подп. и дата. Подп. и дата. Подп. и дата. Подп. и дата.

00971-1CV	(B)	DS CAT No. ADDED AND DESCRIPTION WAS NUT
JUN 04	(A)	EQ. MATERIAL ADDED
4-A-2000		NATURE AMENDMENT
DCU) NO	ISSUE	
DATE		

APPROVED	M.V. [Signature]	(B) 765-10-1723 259 of 342
CHECKED	H.M. [Signature]	DS CAT No. LV2/ICVS 5240-023139
CONTROLLERATE OF INSPECTION (ICV)	(B) NUT	WEIGHT SCALE
	NUT ASSEMBLED WASHER	0.12 1:1
	CT5 cn GOST 380-71	SHT SHTS

9211-01-591

▽3(▽)



1. Alternate material is steel cm 6 cn, GOST 380-71, and steel 15,20,25 and 30 GOST 1050-74.
2. Unspecified limit deviations of dimensions are for holes - as per A7, for shafts - as per B7.
3. Dimensions and roughness of surfaces given in brackets are after assembly.
4. The bush may be made by precision investment casting. Material is casting OCT3-4365-79 25A-GOST 977-75.

In this case;

- a) Alternate material is casting from steel 35A, GOST 977-75.
- b) Unspecified casting radii should not exceed 1mm.
- c) Other requirements are as per OCT3-4365-79.

(A) EQ. MATERIAL: - COLD ROLLED STEEL BAR ST42 TO IS: 7270-74

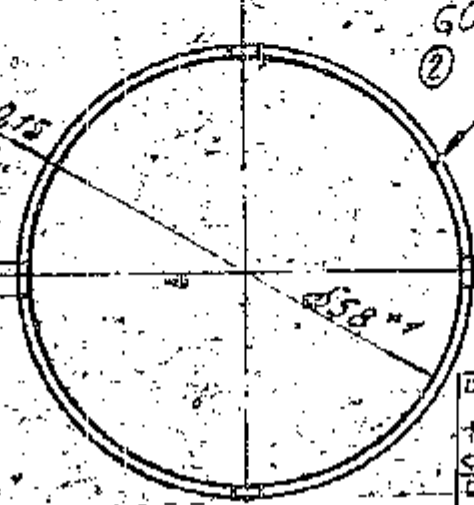
00782-ICV	(A)	EQ. MATERIAL ADDED
V. Romang	Curm	
09.5.2000		
DC(17) No	ISSUE	NATURE
DATE		AMENDMENT

APPROVED	M. VASU	765-10-1726		260 of 342
CHECKED	H.M. Shaikh			
CONTROLLERATE OF INSPECTION (ICV)		BUSH		WEIGHT SCALE
		Steel cm 5 cn, FOCT 380-71		0.115 1:1
				SHT SHTS

765-10-1728



4 Slots 4x1



GOST 16037-80-C1-1  
 ② 1 In any place  
 dress weld flash.

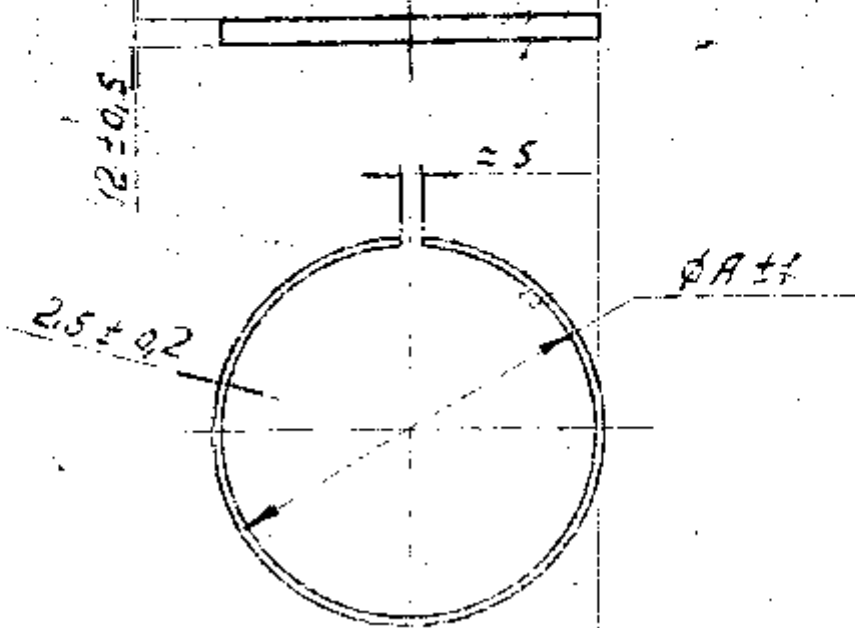
DOTB2-TCV	(A)	EQ MATERIAL ADDED
H. Remond	Ann	
09-5-2000		
DATE	ISSUE	NATURE
		AMENDMENT

1. Burrs are allowed.
2. Perform dimensions without deviations with accuracy of  $\pm 0.5$  mm.
3. Displacement of slots from true position should not exceed 0.5 mm.
4. Alternate material is steel 15, 20, 2530, GOST1050-74
5. It is allowed to perform welding as per GOST 14771-76-C1.

(A) EQ MATERIAL:- STEEL BAR C-10 TO IS: 2073-70

APPROVED	M. VASU	765-10-1728		262 of 342
CHECKED	H.M. Shakti		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)		PIPE	0.135	1:1
		10 GOST 1050-74	SHT	SHTS

DOTS/ICV	①	EQ. MATERIAL ADDED
V. P. D. No.	①	
DCI/No	①	
DATE		
ISSUE		
AMENDMENT		



① EQ. MATERIAL:- STAINLESS STEEL STRIP 04Cr18Ni10Ti20 TO ISC 6911-72 FOR DRGNO. 765-10-1743

Designation	A	Weight
① 765-10-1743	240	0.175
765-10-1744	250	0.182

APPROVED	REVISION	765-10-1743/1744	
CHECKED	H.M. Sha kh	263 of 342	
CONTROLLERATE OF INSPECTION (ICV)	RING		WEIGHT SCALE
			SEE TABLE 1:5
	12 X 18 H 9 T GOST 5632-72		SHT SHTS

765-10-1746

1.5 ± 0.15      φ210 ± 0.5

Maintain in Assy.

A

155 ± 0.5

ГОСТ 14774-76-С2-УП

① 20x20H9T

20x20H9T

② B

ГОСТ 10052-52-75

EQ. MATERIAL ADDED	NATURE AND AMENDMENT	①	ISSUE
		②	ISSUE
Q0782-104		09.5.2000	
V. Romanov			
DESIGN DATE			

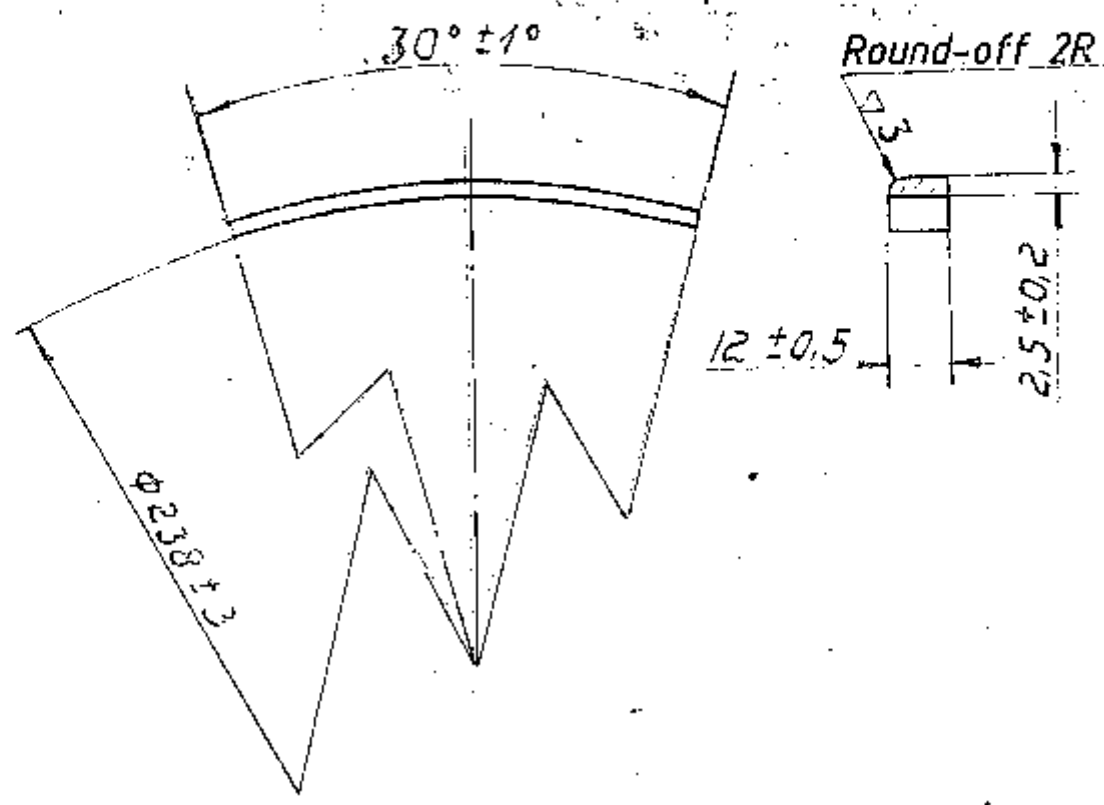
1. Burrs are not allowed.
  2. Use welding wire  $\phi$  08x20H9 T7T, GOST 2246-70. Dress the weld flush on two sides.
  3. Non-squareness of surfaces  $\bar{b}$  and B to axis of surface A, should not exceed 1 mm over a length of 155 mm.
  4. Alternate material is 20x23H18 and 12x18H9T, GOST 5632-72.
  5. Tool marks with depth not exceeding 0.2 mm are allowed on internal surface of pipe.
- ① EQ. MATERIAL: - STAINLESS STEEL 04 Cr 18 Ni 10 Ti 20 TO 15/6911-72

APPROVED	M. V. [Signature]	765-10-1746	264 of 342
CHECKED	H. N. [Signature]		
CONTROLLER OF INSPECTION (ICV)	PIPE	WEIGHT	SCALE
		1.38	1:5
		SHT	SHTS
	12 x 18 H10 T TOCT 5632-72		

765-10-1747

Unless otherwise specified.

DCU No	09.5-2000	DATE	
ISSUE	(A)	ISSUE	
AMENDMENT		NATURE	
		AMENDMENT	



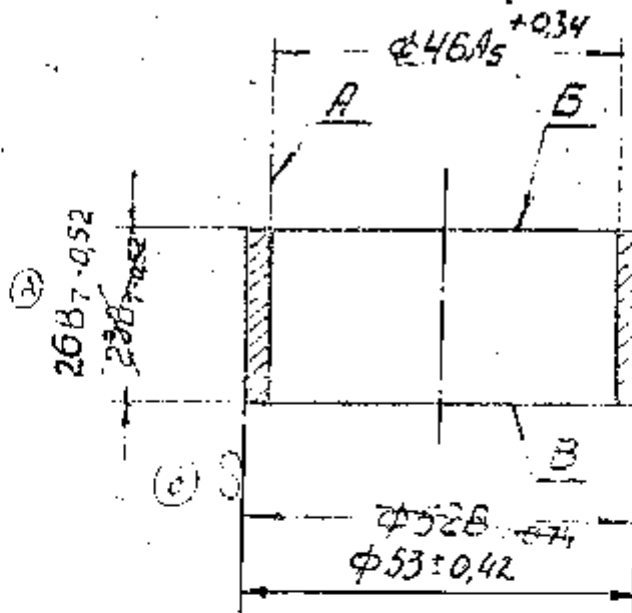
1. Blunt sharp edges.
  2. Alternate material is 12x18 H10T 5632-72.
- (A) EQ. MATERIAL :- STAINLESS STEEL SHEET 04 CY 18 NI 10 TI 20 TD  
IS: 6911-72

APPROVED		765-10-1747	265 of 342
CHECKED	H.M. Shaikh		
CONTROLLERATE OF INSPECTION (ICV)	COVER PLATE	WEIGHT	SCALE
		0.013	1:1
		SHT	SHTS
	12 X 18 H 9 T GOST 5632-72		114

841-01-596

⑥ V3 (V)

00482-10V V. Kozlov of 5-2000	①	EQ. MATERIAL ADDED
OC/DN/0 DATE	ISSUE	NATURE AMENDMENT

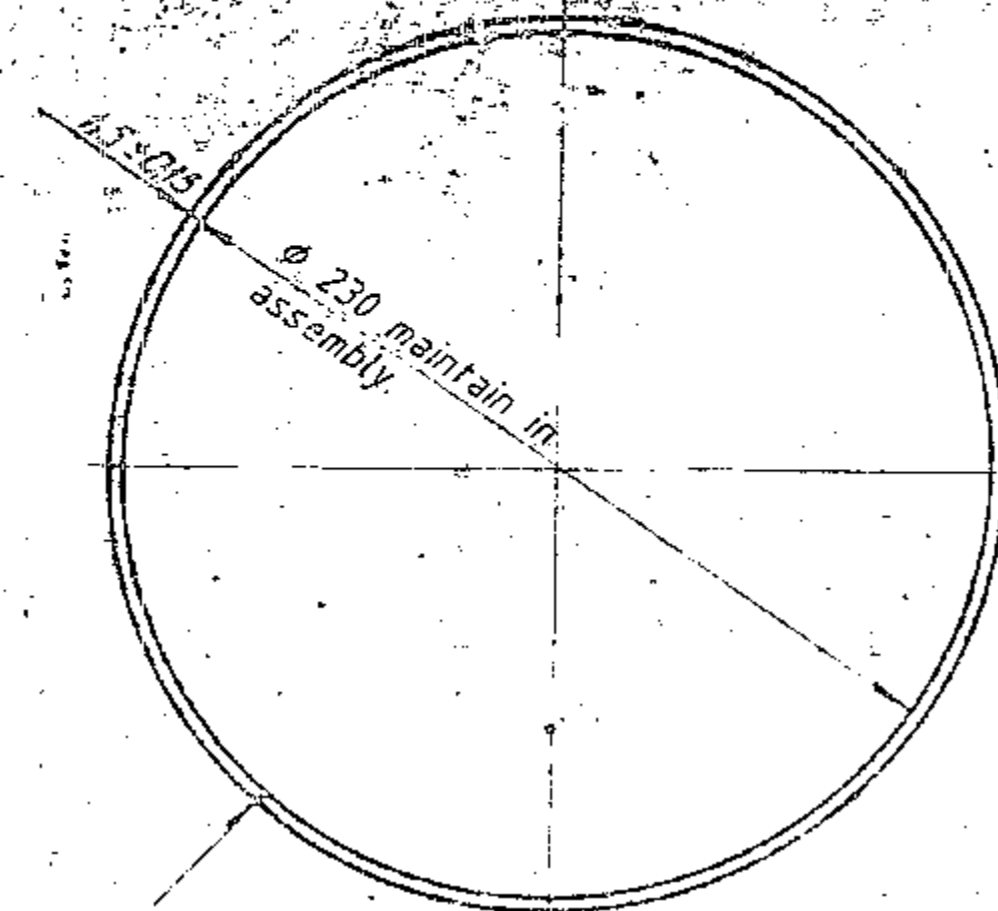
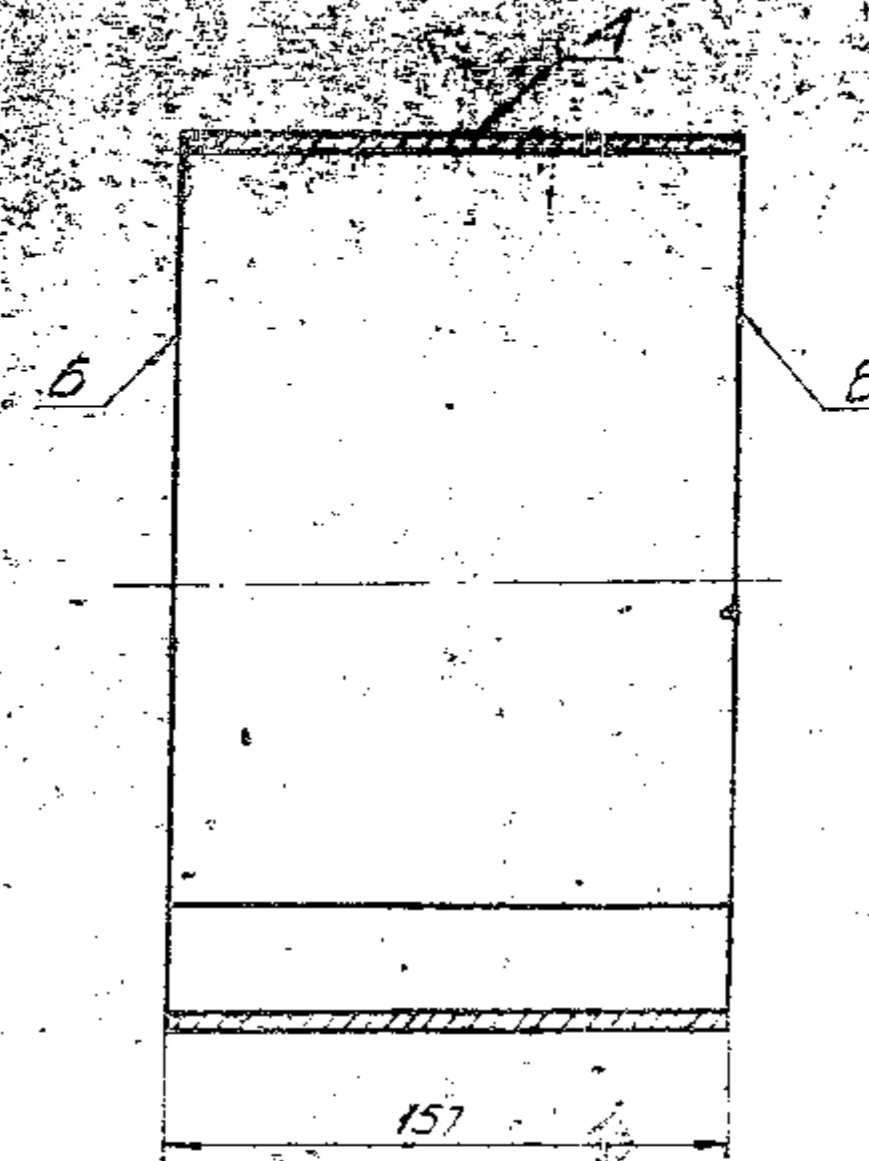


1. Blunt sharp edges.
2. Run-out of surfaces B and B with respect to axis of surface A should not exceed 0.1 mm.
3. Alternate material is steel cm $\bar{3}$ cn GOST 380-71 and 15, 25, and 30 GOST 1050-74.
4. Wall thickness difference should not exceed 0.5 mm.

① EQ. MATERIAL: -HOT ROLLED STEEL BAR C-30 TO IS: 2073-70

APPROVED	BY: VASU	765-10-1748		266 of 342
CHECKED	H.M. She	BUSHING		
CONTROLLERATE OF INSPECTION (IC VI)				
		20 GOST 1050-74	0.083	1:1
			SHT	SHTS

00782-ICV



② At any place GOST 14771-76-C2-УП.

- 1). Burrs are not allowed.
- 2). Provide dimensions without deviations with an accuracy of  $\pm 0.5$  mm.
- 3). Use welding wire  $\phi 08 \times 20 \text{H9 } \Gamma 7\text{T}$ , 2246-70. Dress the weld flush from outside.
- 4). Non-squareness of surface  $\bar{b}$  and  $\bar{B}$  to axis of surface A should not exceed 1 mm over a length of 157 mm.
- 5). Alternate material is 12x18H9T and 20x23H18 GOST 5632-72.
- 6). Tool marks with depth not exceeding 0.2 mm are allowed on internal surface.

Ⓐ REQ. MATERIAL:- STAINLESS STEEL SHEET 04CY18NI10TI20 TO IS: 6911-72

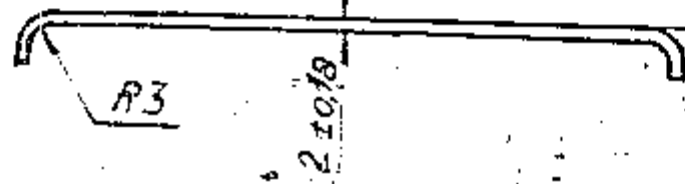
00782-ICV	Ⓐ	EQ. MATERIAL ADDED
V. Ramad	Ass	
09-5-2000		
DC(I) NO	ISSUE	NATURE
DATE		AMENDMENT

APPROVED	M. V. V. G. D.	765-10-1749	
CHECKED	H. M. S. K. R. H.	WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)		1.28	1:2
		SHT	SHTS
		12 X 18 H10T ГОСТ 5632-72	

765-10-1750

2

00782-11V	(A)	EQ. MATERIAL ADDED
N. Roman	Am	NATURE
09-S-2000	ISSUE	AMENDMENT
DATE		



1. Burrs are not allowed.
  2. Provide dimensions without deviation with an accuracy of  $\pm 0.5$ .
  3. Alternate material is steel 15, 20, 25, and 30 GOST 1050-74.
- (A) EG. MATERIAL: -STEEL SHEET (HOT ROLLED) S4-34 TO IS: 1079-72

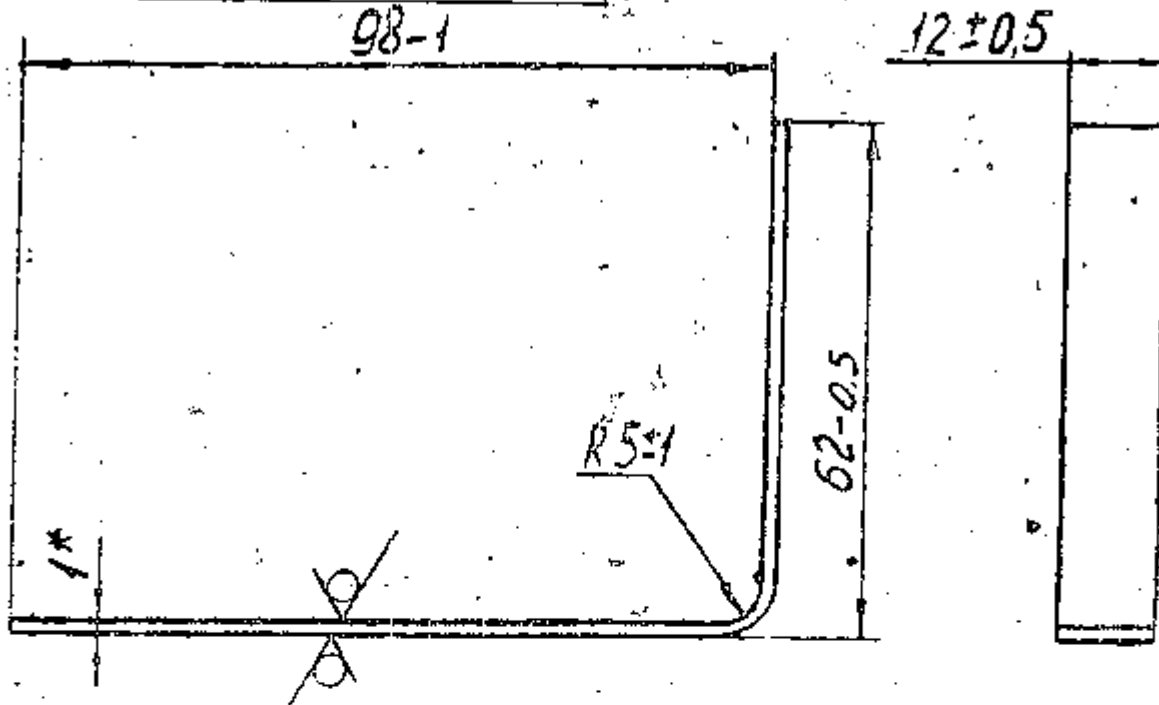
APPROVED	M. Roman	765-10-1750		2684342	
CHECKED	H.M. Sh...	RIB		WEIGHT SCALE	
CONTROLLER OF INSPECTION (ICV)		10 GOST 1050-74		0.057	1:1
				SHT	SHTS



765-10-1862

Rz 320

007B2-ICV Y. Roman 09.5.2000	(A) Carm	EQ. MATERIAL ADDED
D C (3) NO DATE	ISSUE	NATURE AMENDMENT



1. Alternate material is of steel sheet 08KП, GOST 1050-74.
  2. \*Dimension is given for reference.
- (A) EQ. MATERIAL: COLD ROLLED STEEL SHEET Gde D ( $\frac{1}{2}$  H) TO IS: 4030-73

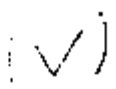
Sheet A-ПV-0-1 GOST 19904-74  
5-II-Г-10 GOST 16523-70

007B2-ICV  
 Y. Roman  
 09.5.2000  
 D C (3) NO  
 DATE

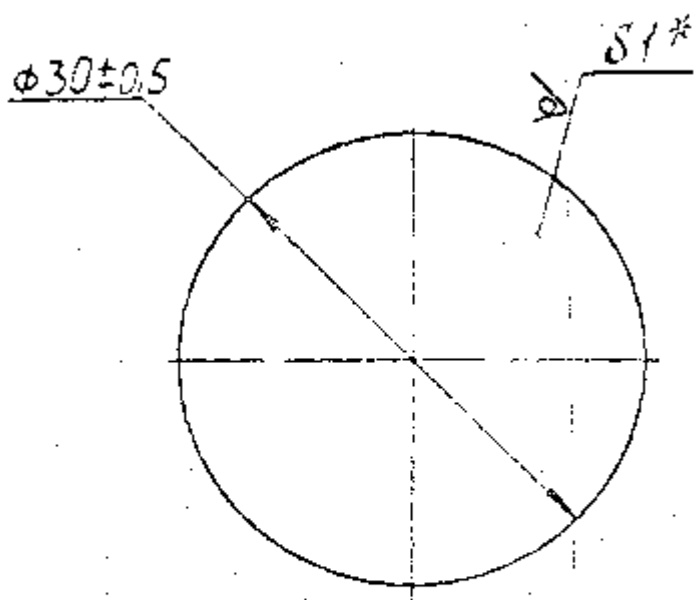
APPROVED	BY VASH	765-10-1862	
CONTROLLED	H.M.S.L. - K2	291 04342	
CONTROLLERATE OF INSPECTION (ICV)	COVER PLATE	WEIGHT	COEFF
		0.014	1.1
		SHT	SHTS
SEE ABOVE			

765-10-1863

2330



00782-1CV	(A)	EQ. MATERIAL ADDED
V. Romas	mm	
09.5.2008		NATURE
DATE		AMENDMENT



1. Alternate material is sheet of steel 08 Kn and 10 Kn, GOST 1050-74.

2. \*Dimension is given for reference.

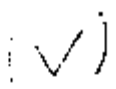
(A) EQ. MATERIAL :- COLD ROLLED STEEL SHEET Gd. D (4H) TO IS: 4030-73

2007-1301

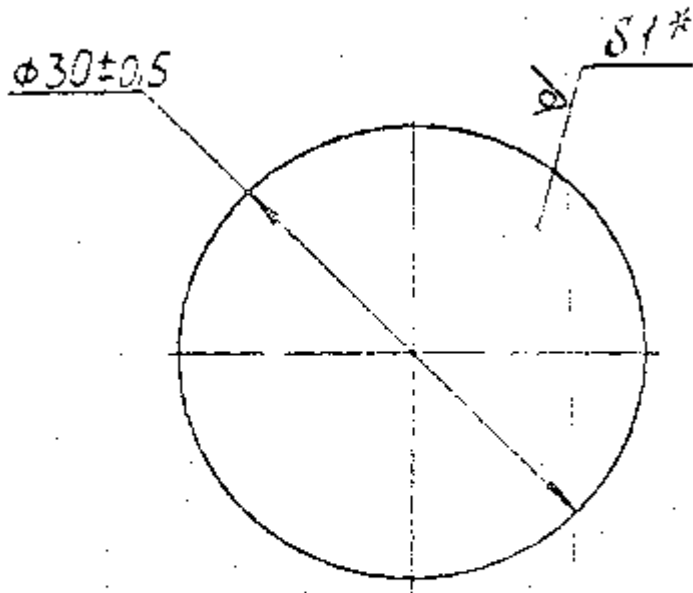
APPROVED		765-10-1863	292 of 342
CHECKED	H.M.520-KR		
CONTROLLERATE OF INSPECTION (ICV)		COVER PLATE	WEIGHT SCALE 0.0014 2.1
		Sheet	SHT SHTS
		A-ny-0-1 OCT 19904-74	
		5-II-T-10 OCT 16523-70	

765-10-1863

2330



00782-1CV	(A)	EQ. MATERIAL ADDED
V. Romas	mm	
09.5.2008		NATURE
DATE		AMENDMENT



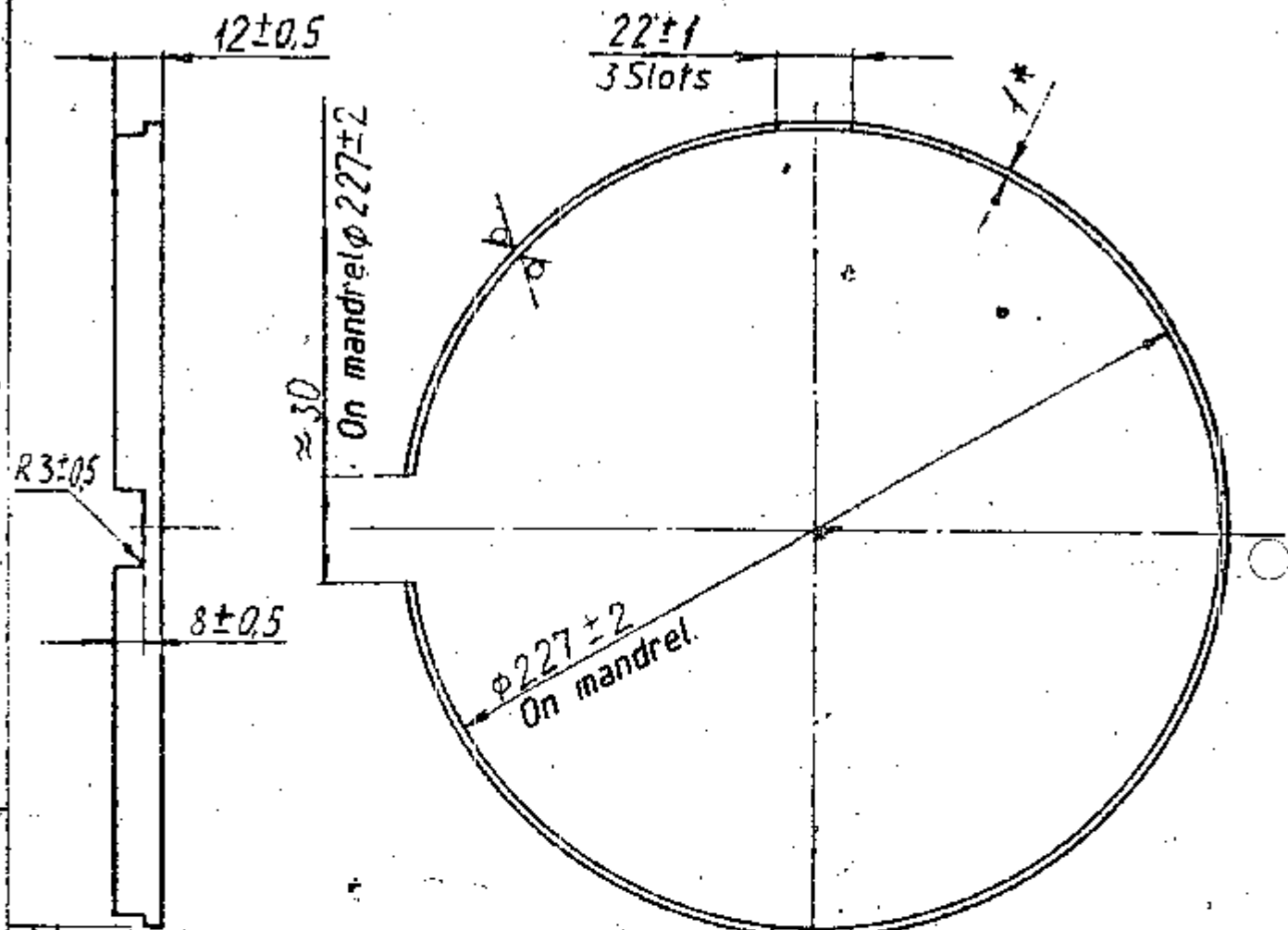
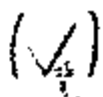
1. Alternate material is sheet of steel 08 Kn and 10 Kn, GOST 1050-74.

2. \*Dimension is given for reference.

(A) EQ. MATERIAL :- COLD ROLLED STEEL SHEET Gd. D (4H) TO IS: 4030-73

2007-1301

APPROVED		765-10-1863	292 of 342
CHECKED	H.M.520-KR		
CONTROLLERATE OF INSPECTION (ICV)		COVER PLATE	WEIGHT SCALE 0.0014 2.1
		Sheet	SHT SHTS
		A-ny-0-1 OCT 19904-74	
		5-II-T-10 OCT 16523-70	



- (A) EQ. MATERIAL:- COLD ROLLED STEEL SHEET, G<sub>02</sub>, D (1/2 H) TO IS: 4030-73
1. Alternate material is sheet of steel 08Kn, and 10 Kn, GOST 1050-74.
  2. \*Dimensions are given for reference.

Sheet A-ΠY-0-1 GOST 19904-74.  
5-II-Γ-10-GOST-16523-70.

DATE	ISSUE	AMENDMENT
00702-1CV	(A)	EQ. MATERIAL ADDED
V. Romanov		NATURE
04.5.2000		

APPROVED			
CHECKED	H.M. Scler	765-10-1864	293 of 362
CONTROLLERATE OF INSPECTION (ICV)	COVER	WEIGHT	SCALE
		0.060	1:2
		SHT	SHTS
SHEET	A-ΠY-0-1 GOST 19904-74 5-II-Γ-10 GOST 16523-70		