


Агрегаты, обозначенные позициями 4, 5, 6, 10, монтируются в специальном боксе или металлической камере, обеспечивающих безопасность обслуживающего персонала. Шкалу манометров 2 и 3 защитить органическим стеклом. Воздушная магистраль и арматура должны быть рассчитаны на рабочее давление 200 кг/см². В воздушной магистрали обеспечить наклон трубопровода в сторону баллонной емкости. Травление воздуха на клапане 7 при давлении не выше 155 кг/см² не допускается.

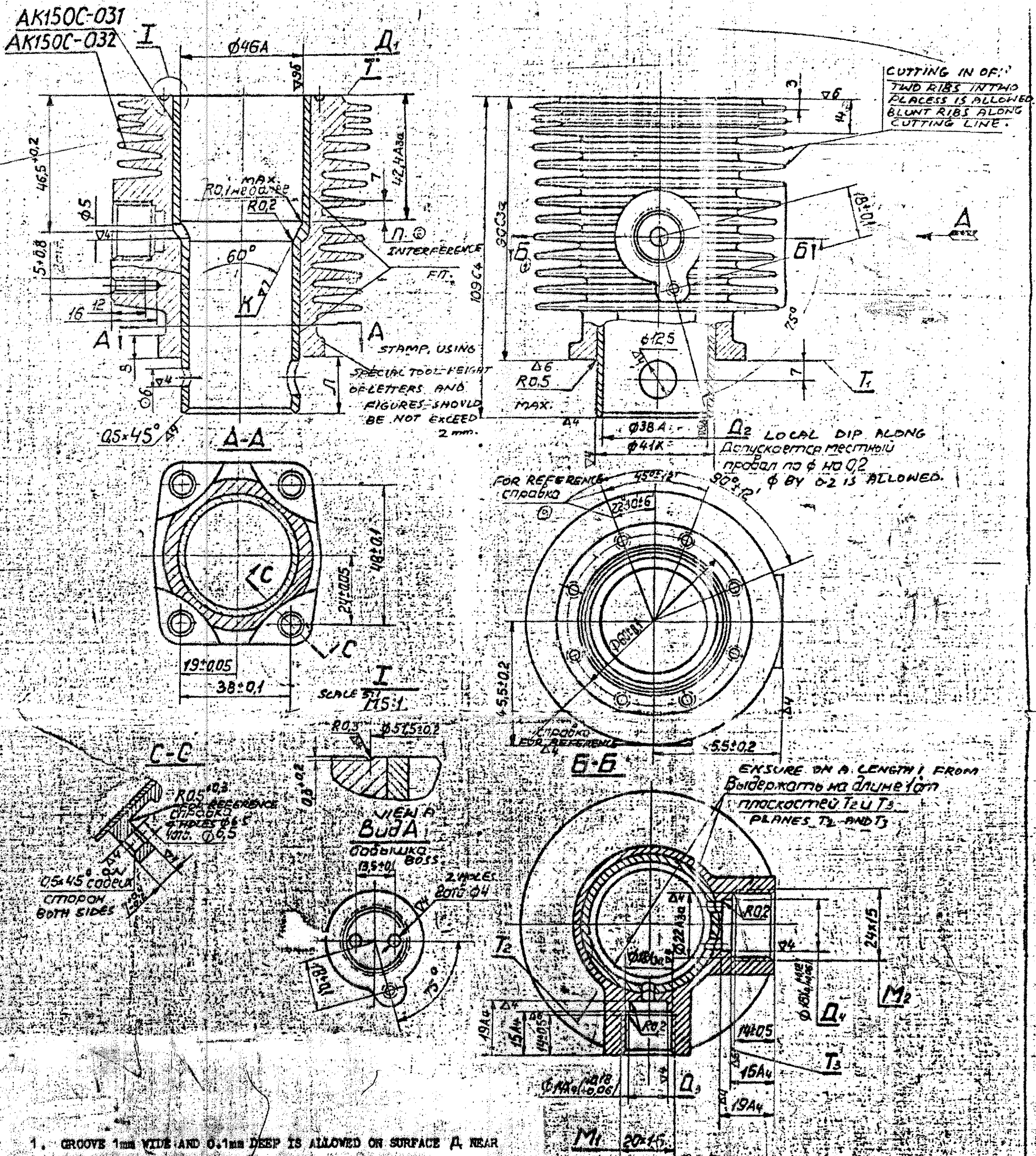
Units, designated with figures 4.5, 8, 10, should be mounted in special box or in metal chamber which provide safety of the attending personal. Scales of pressure gauges 2 and 3 should be protected with organic glass. Airline and fittings should be designed for working pressure of 200/Km² air line should be inclined towards cylinder. air loss through valve 7 at a pressure at least 165 Kq/Km² is not allowed.

20	Housing for blowing over of compressor
21	Aerothermometer or potentiometer
18	Gauge glass
17	Steam super heater or electric heater
16	Oil tank of 5-l capacity
15	Screen filter (Number of meshes 500-600 per one cm ²)
14	Cock
13	Lock pump with pressure-equalizing valve
12	Screen filter (Screen 0.1 GOST 6813-33)
11	Pressure gauge for working pressure 10Kg/Cm ² (Accuracy class 1.5-2.5)
	or for p=16 Kg/Cm ² (Accuracy class 1.6)
10	30-l cylinder for working pressure of 150 at.
9	Air cock
8	8-l cylinder for working pressure 150 at.
7	Safety valve
6	Automatic pressure regulator for working pressure 150 at.
5	Filter
4	Oil sump
3	Pressure gauge for working pressure 16Kg/Cm ² accuracy class 1.5-2.5 or p=25Kg/Cm ² accuracy class 1.5
2	Pressure gauge for working pressure of 250Kg/Cm accuracy class 2.5
1	Compressor AK B0 CB.
Ref. No.	Nomenclature

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	88158	MATERIAL:-	USED ON:- AK 150C -01CE
			CHD	Chattanooga		
			TCO	25796	CONTROLLERATE OF INSPECTION(HEAVY VEHICLES AVADI	
			APPD	[Signature]		
			DATE	25/7/86		
			SCALE -	 TITLE: AIR COMPRESSOR SET UP FOR TESTING COMPRESSOR		
			DIMENSIONS IN mm			
			TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.			
			ALL THREADS CONFORM TO	U S CAT NUMBER	DRAWING NUMBER AK150C CX (AK150C CTY)	
			ISSUE DATE	NATURE OF AMENDMENTS		



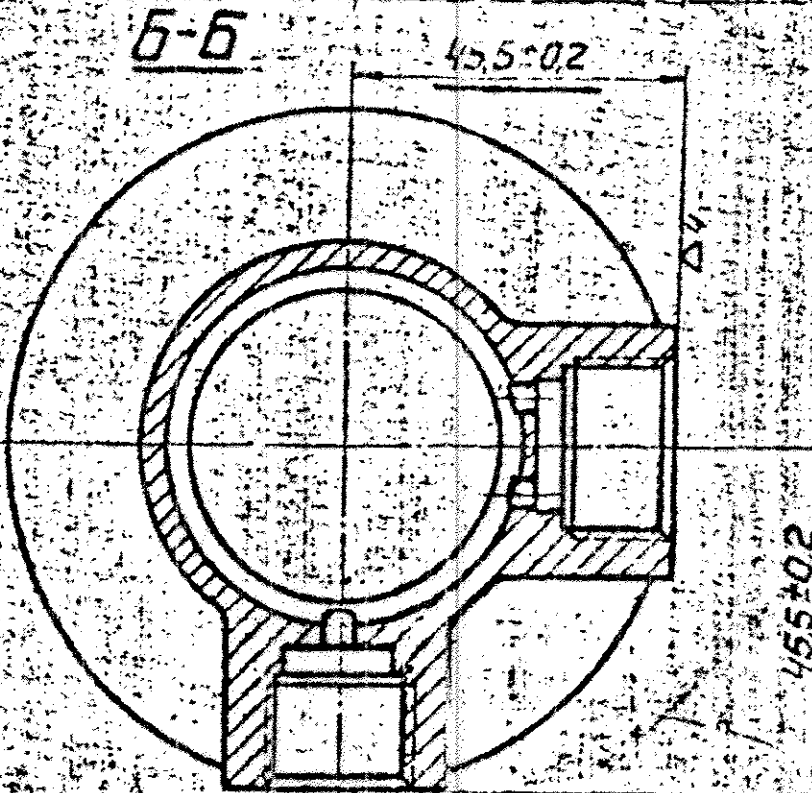
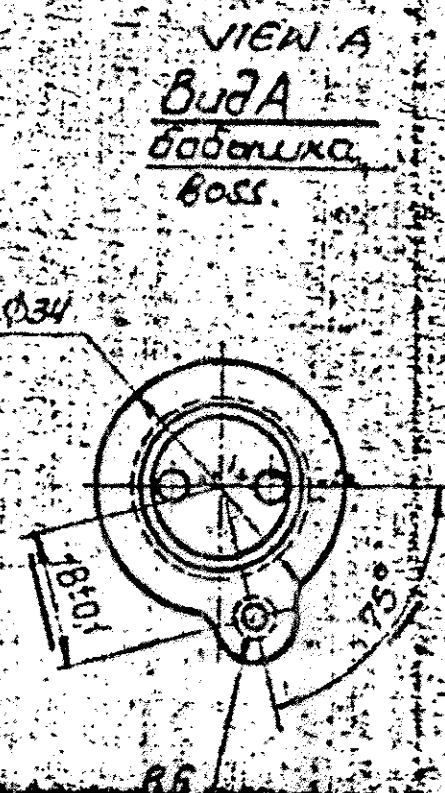
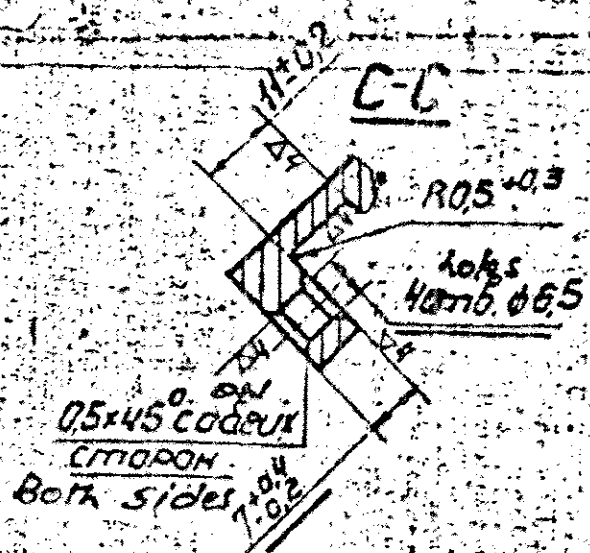
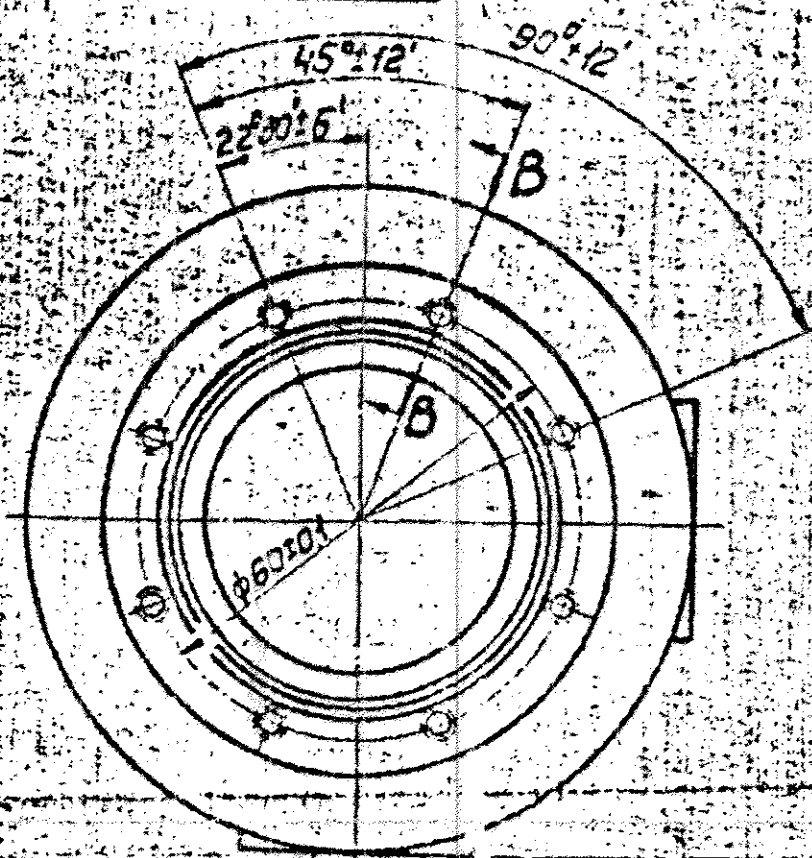
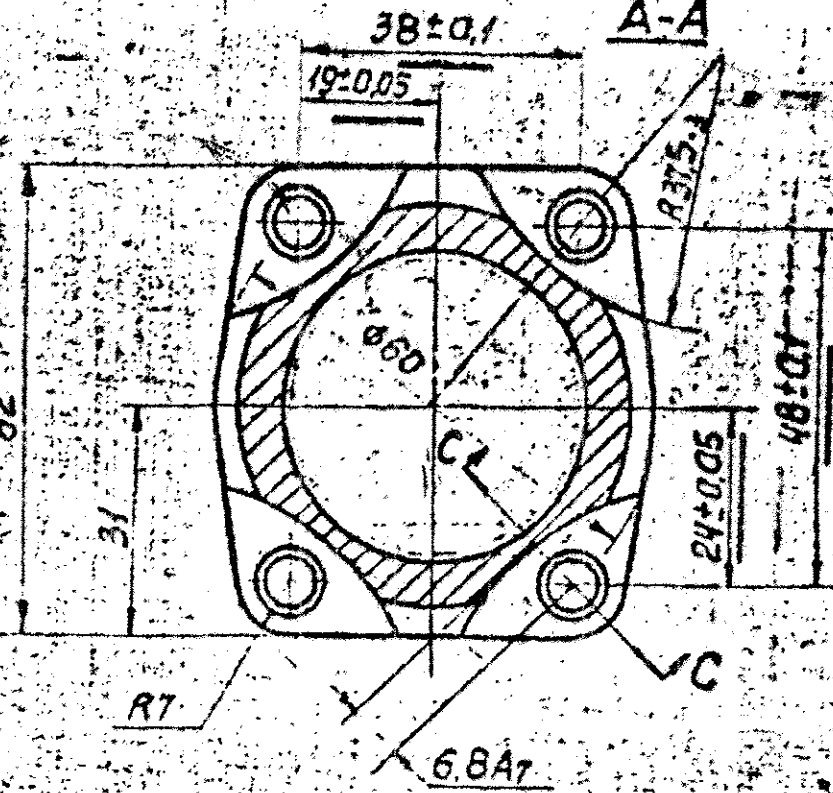
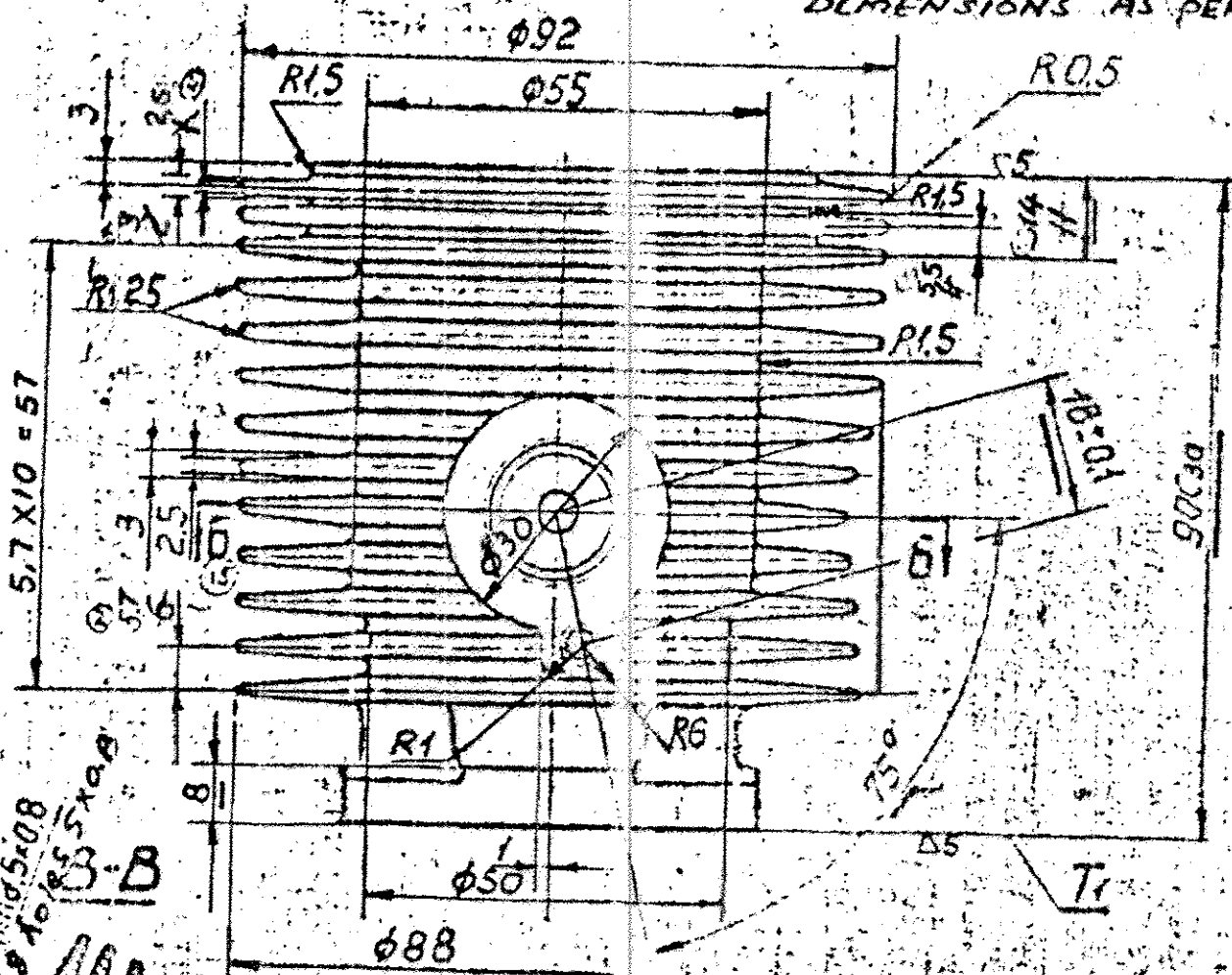
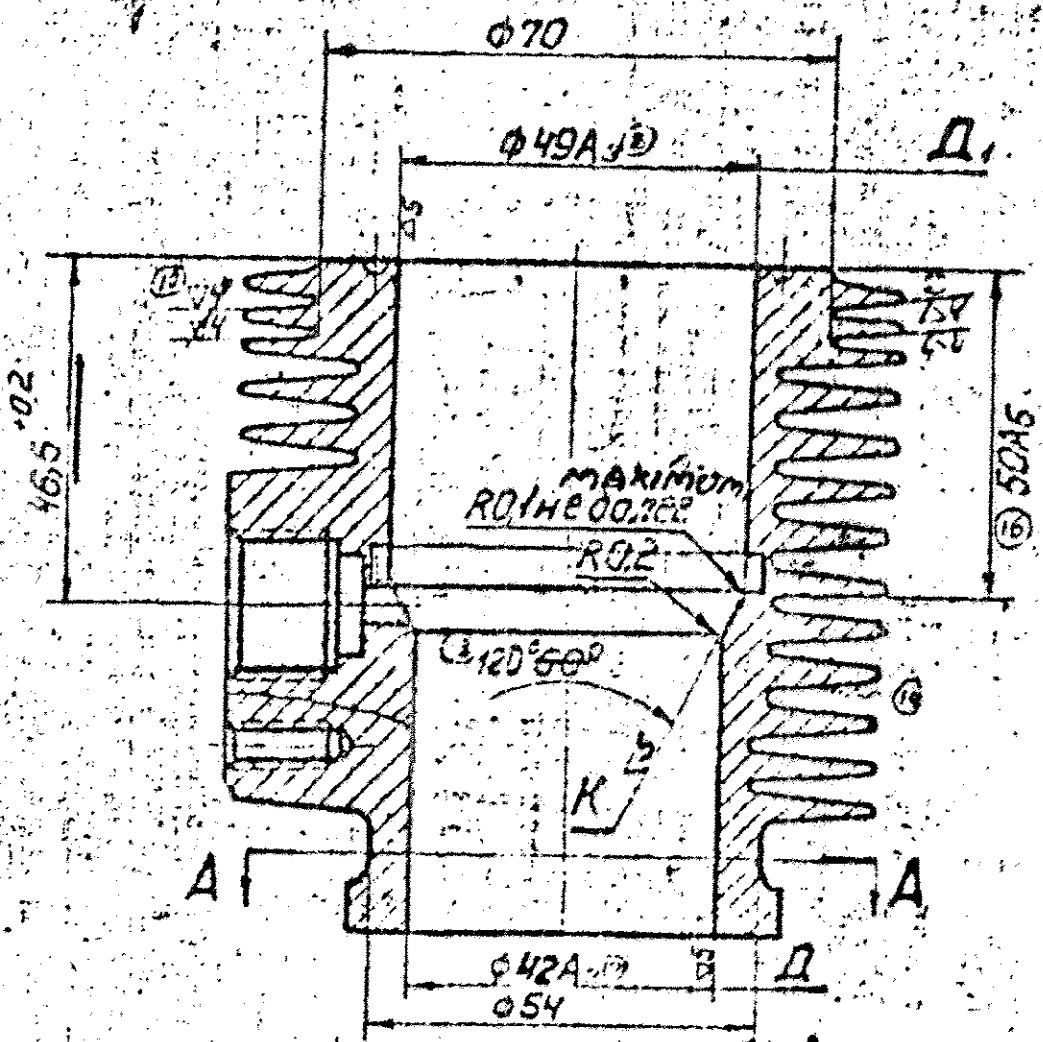
1. GROOVE 1mm WIDE AND 0.1mm DEEP IS ALLOWED ON SURFACE A, NEAR THE CONE.
2. PRIOR TO PRESS FITTING COAT SURFACE OF COMPONENT AK 1500-021 WITH AN UNEVEN LAYER OF BAKELITE LACQUER OR LACQUER No. 302-K0 965, GOOST 5090-69 ACCORDING TO THE TECHNOLOGICAL INSTRUCTIONS.
3. PRIOR TO PRESS-FITTING OF COMPONENT AK-150 C-031, HEAT UP COMPONENT AK 1500 TO A TEMPERATURE OF 220°C.
4. CHECK SURFACE K BY BLUING WITH THE HELP OF GAUGE. THE IMPRINT SHOULD COVER AT LEAST 75% OF THE SURFACE.
5. ANGULAR DIFFERENCE IN GAUGES FOR CHECKING CONES IN UNITS AK 150 C-18 AND AK1 50 C -16 SHOULD NOT EXCEED 20.
6. RUN OUT OF SURFACES Δ_4 & Δ_3 RELATIVE TO RESPECTIVE PITCH DIAMETERS OF THREADS M2 AND M1 SHOULD NOT EXCEED 0.1. RUN OUT OF SURFACE Δ_4 1 RELATIVE TO SURFACE M2 2 SHOULD NOT EXCEED 0.02.
7. NON SQUARENESS OF SURFACES T & T 1 RELATIVE TO CORRESPONDING SURFACES Δ_1 & Δ_2 SHOULD NOT EXCEED 0.03. DIFFERENCE IN WALL THICKNESS OF LINER SHOULD NOT EXCEED 0.1.
8. OVALITY, CONVEXITY AND CONCAVITY OF SURFACES Δ_1 , Δ_2 SHOULD NOT EXCEED 0.005; TAPER SHOULD NOT EXCEED 0.01. FACETING IS NOT ALLOWED.
9. OVALITY & TAPER ON SECTION A SHOULD NOT EXCEED 0.03. MAKE CHAMFERS TO A DEPTH OF THREAD AT AN ANGLE OF 90°. CHECK FOR TIGHTNESS UNDER THE AIR PRESSURE OF 30 kg/cm².
10. AIR LEAKAGE THROUGH CASTING SURFACES IS NOT ALLOWED.
11. TOTAL AIR SEEPAGE THROUGH GENERATRIX OF SURFACES WITH INTERFERENCE FIT SHOULD NOT EXCEED 60 BUBBLES PER MINUTE.
12. CHECK SURFACE T1 FOR NON FLATNESS WITH THE HELP OF TOOL MAKERS STRAIGHT EDGE. CLEARANCE MAY BE 0.03 MAX.
13. DEGREASING OF DIMENSION OF SURFACE Δ_1 ON SECTION A SHOULD BE 0.03.

EST. MASS		TO BE STAMPED OR MARKED WHERE INDICATED THIS \Rightarrow	
737		LETTERS!	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.			
ISSUE DATE	NATURE OF AMENDMENT	MATERIAL	USED ON: AK 130-C-01CB
2/28/68	SCALE 1:1		
CHECKED BY	DIMENSIONS IN IN.	[CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
2/28/68	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: CYLINDER FIRST STAGE ASSY.	
APPROVED BY	ALL-THREADS CONFC IN TO	B & CAT NUMBER	TRAWER NUMBER AK 130C 18 CB

DRAWING NUMBER
AK 150 C 032

LIMIT DEVIATIONS OF
 (19) Prod. mkn. pos. 008
 CASTING DIMENSIONS
 DIMENSIONS 0001.1 + 0.2
 AS PER QST 191159 -72

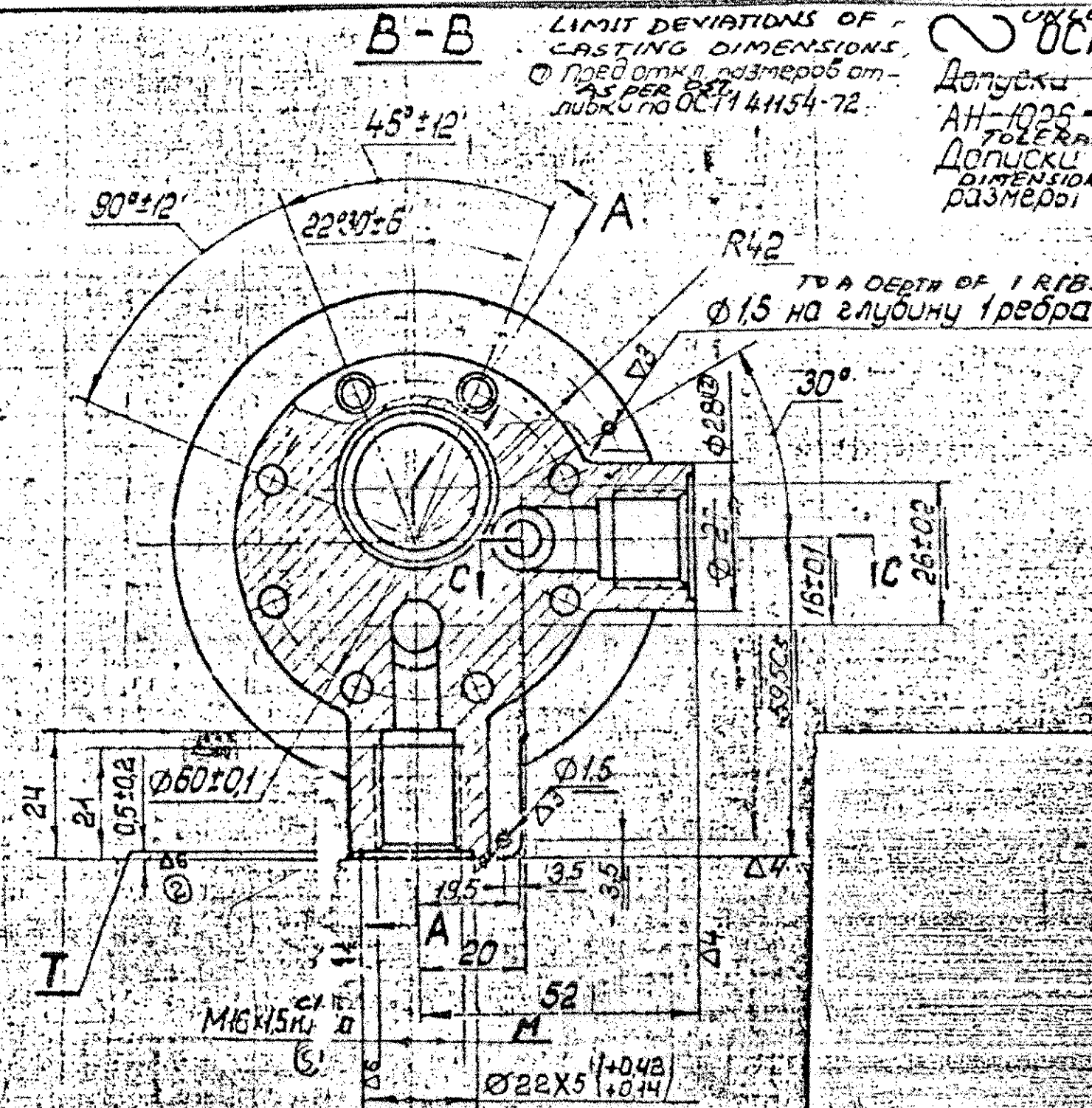
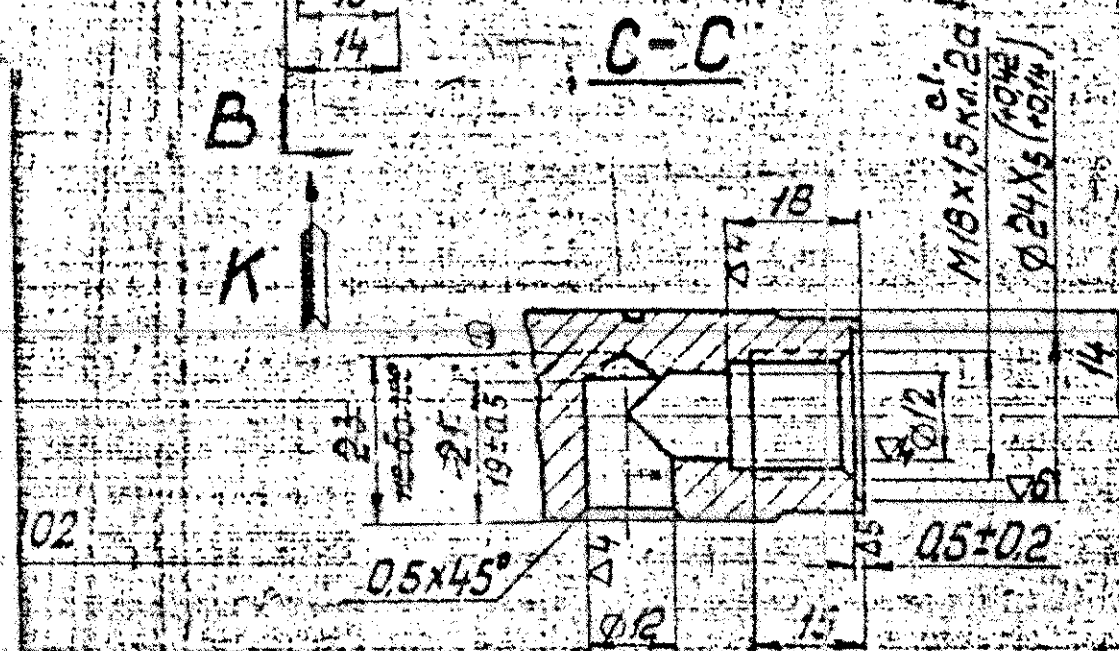
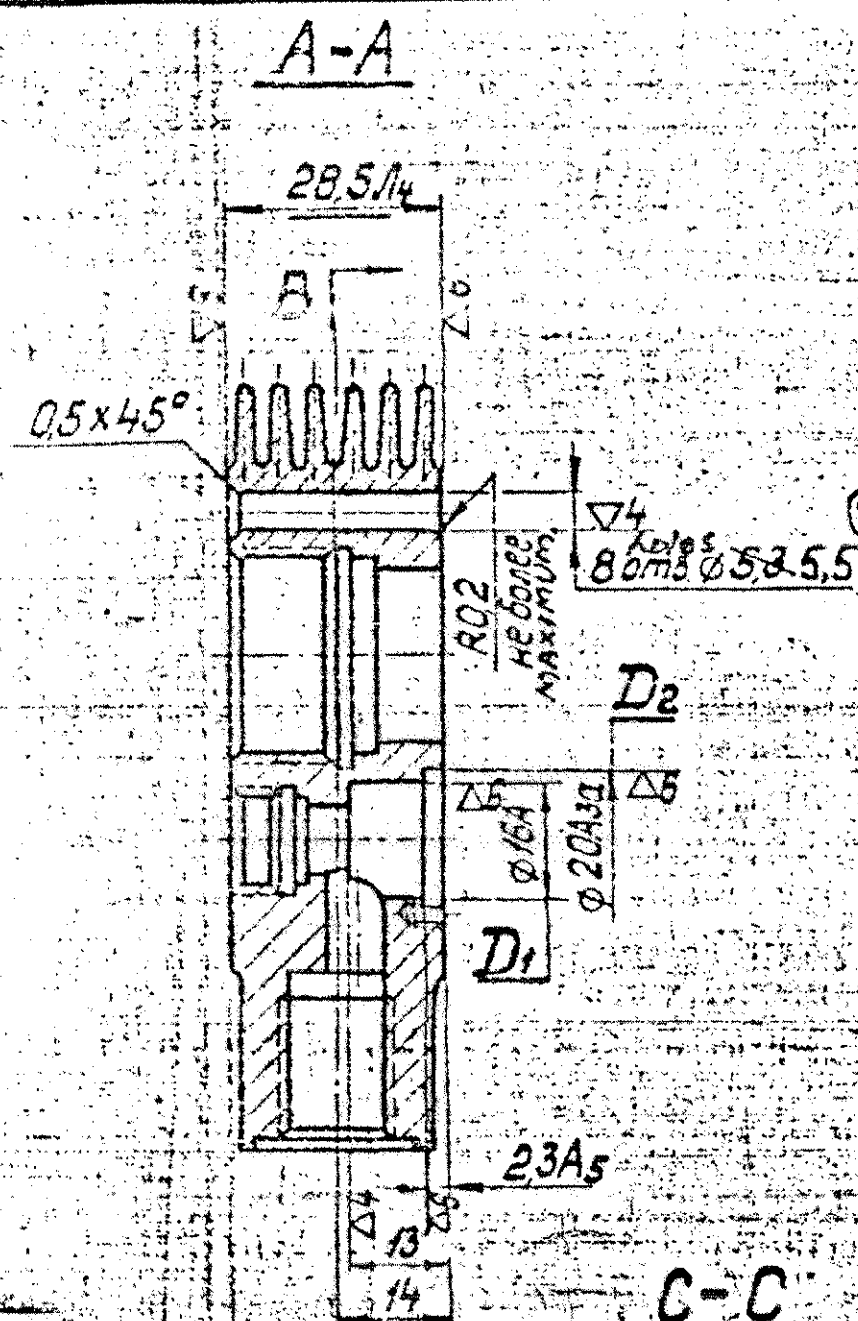
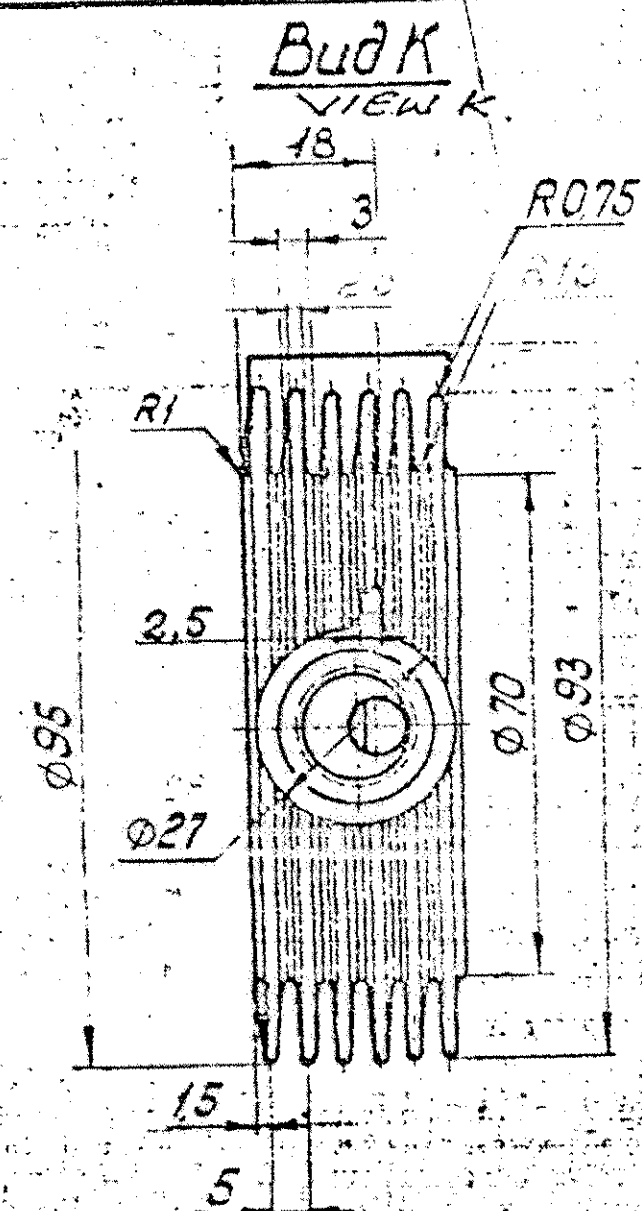
UNLESS OTHERWISE SPECIFIED,
 DIMENSIONS AS PER 22 AT52-74



1. INSPECT CASTING AS PER THE SECOND GROUP.
2. SPECIFICATIONS AMTY483-61 FOR CASTING.
3. CHILL CASTING, ACCURACY CLASS A_1 4.
4. DISPLACEMENT OF RIBS ALONG THE METAL MOULD PARTING LINE SHOULD NOT EXCEED 0.5.
5. THE THICKNESS OF RIBS MAY BE INCREASED BY 0.4 ALONG THE METAL MOULD PARTING LINE.
6. CASTING RADII, NOT SPECIFIED IN THE DRAWING, SHOULD BE R_3 .
7. CASTING DRAFT OF BOSSES SHOULD BE 3
8. GROOVE UPTO 1mm WIDE AND 0.05mm DEEP IS ALLOWED ON SURFACE A_1 , NEAR CONE.
9. CHECK SURFACE K BY BLUEING WITH THE HELP OF GAUGE. THE IMPRINT SHOULD COVER ATLEAST 75% OF THE SURFACE.
10. ANGULAR DIFFERENCE IN THE GAUGES FOR CHECKING OF THE CONES OF COMPONENTS AK150C-032 AND AK150C-031 SHOULD NOT EXCEED 20'.
11. ENSURE THE UNDERLINED DIMENSIONS IN UNIT AK 150C-18.
12. RUN OUT OF SURFACE A_1 , RELATIVE TO SURFACE A_1 SHOULD NOT EXCEED 0.02.
13. OVALITY AND TAPER OF SURFACES A_1 , AND A_1 SHOULD NOT EXCEED 0.01.
14. NON SQUARENESS OF SURFACE A_1 TO T_1 SHOULD NOT EXCEED 0.05 ON A LENGTH OF 50.
15. DURING MILLING OF FLANGE R37.5 ± 0.3 CUTTING-IN IN RIB IS ALLOWED.
16. HARDNESS HB 65 \pm 110.
17. TO BE ANODIZED, EXCEPT FOR PLACES TO BE MACHINED IN UNIT AND SURFACES A_1 , A_1 , K.

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS Φ
		1.02	LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENTS		
DRN <i>Shaw</i>	SCALE - 1:1	MATERIAL - ALUMINIUM ALLOY 1/4 OST 190C21-71	USED BY - AK 150C-19 CB
ENG <i>Chittick</i>	DIMENSIONS IN IN.	CONTOLLERATE OF INSTRUCTION (HEAVY VEHICLES) AVADA	
TEN <i>Shaw</i>	TOLERANCE OF DIMS UNLESS OTHERWISE STATED	TITLE - CYLINDER JACKET FIRST STAGE	
APPRO <i>Shaw</i>		S CAT NUMBER	DRAWING NUMBER AK 150C 032
DATE 1970-2-26	ALL THRU DCS CONFORM 179		

DRAWING NUMBER
AK 150C 074



1. THE INSPECTION GROUP OF CASTING - SECOND.
2. CHILL CASTING. ACCURACY CLASS T4.
3. CASTING RADII, NOT SPECIFIED IN THE DRAWING SHOULD BE R3.
4. THE THICKNESS OF RIBS MAY BE INCREASED BY 0.4 IN THE PLACES OF METAL MOULD PARTING LINE.
5. ENSURE THE UNDERLINED DIMENSIONS IN UNIT AK150C-40.
6. MAKE CHAMFERS TO A DEPTH OF THREAD AT AN ANGLE OF 90 - 120.
7. RUN OUT OF SURFACE D2 RELATIVE TO D1 SHOULD NOT EXCEED 0.02 (TO BE ENSURED TECHNOLOGICALLY).
8. RUN OUT OF SURFACE T RELATIVE TO PITCH DIAMETER OF THREAD H SHOULD NOT EXCEED 0.1.
9. HARDNESS HB 65 - 110.
10. TO BE ANODIZED EXCEPT FOR THE SURFACES TO BE MACHINED IN UNIT AK 150C-40. COATING MAY BE REMOVED FROM THE FACES OF THE FIRST RIBS.

LIMIT DEVIATIONS OF
CASTING DIMENSIONS
① Пред откл. размеров от
AS PER DET.
subk no OCT 141154-72

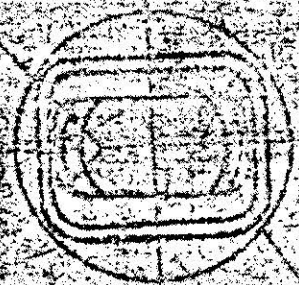
UNLESS OTHERWISE SPECIFIED.
 Душукы на 1026-55 (55-151)
 TOLERANCES ON ALL
 Душукы на 1026-55 (55-151)
 DIMENSIONS ARE IN INCHES
 размеры по 22152-7K1

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			
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL:		USED ON:-	
2-7-86	SCALE - 1:1	ALUMINIUM ALLOY A.A.4		AK 150C 40 CB	
2-7-86	DIMENSIONS IN mm	DST 90021-71			
2-7-86	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD			
2-7-86	ALL THREADS CONFORM TO	TITLE:		HEAD	
		B & S CAY NUMBER		DRAWING NUMBER	
				AK 150C 074	

DRAWING NUMBER
AK 150H-31CB

TOLERANCES ON FREE
DIMENSIONS ARE AS
PER 22-AT-52 CLASS



SMOOTH CHANGE OF CHAMFERS

PLACE FOR STAMPING

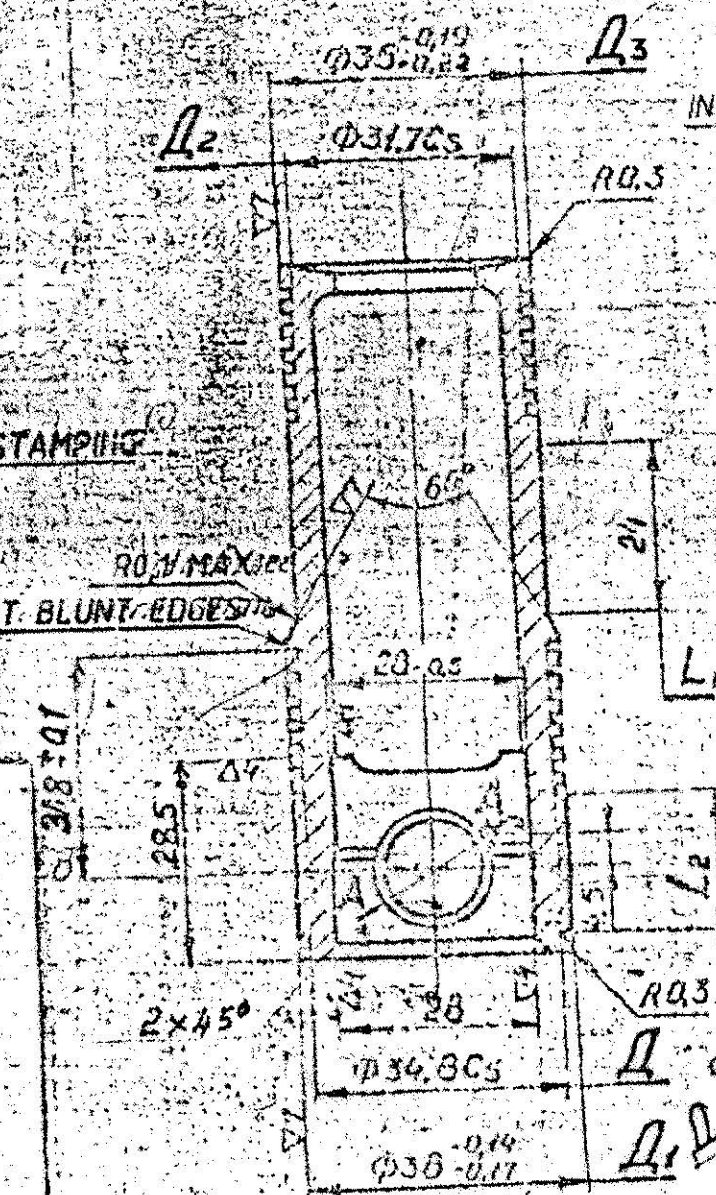
QUALITY AND TAPER OF SURFACE A_4 SHOULD NOT EXCEED 0.005 (FOR EACH BUSHING) WHILE ASSEMBLING THE UNIT. ASSEMBLE PARTS AK150-H08 AND AK150H-088 OF SAME GROUP. SLOT OF WIDTH UP TO 0.1mm, DEPTH UP TO 0.1mm OVER DIAMETER IS ALLOWED ON SURFACE A_2 . NEAR TAPER DIMENSION K IS MADE FOR ALL CIRCULAR SLOTS. VARIATION IN WALL THICKNESS OF PART AK150H-089 SHOULD NOT EXCEED 0.3mm. RUN-OUT OF SURFACE A RELATIVE TO A_1 AND SURFACE A_2 RELATIVE TO A_3 SHOULD NOT EXCEED 0.03 mm. RUN-OUT OF SURFACE A_1 RELATIVE TO A_3 SHOULD NOT EXCEED 0.02 mm.

NON-SQUARENESS OF SURFACES T_1 AND T_2 WITH RESPECT TO A_4 SHOULD NOT EXCEED 0.05 mm. NON-SQUARENESS OF SURFACES T_2 AND T_3 TO A_4 SHOULD NOT EXCEED 0.03 mm. OVER A LENGTH 20 mm. NON-SQUARENESS OF SURFACES OVER A LENGTH 40 mm. DISPLACEMENT OF AXIS OF ϕA_4 RELATIVE TO AXIS OF ϕA_1 SHOULD NOT EXCEED 0.03 mm. CHECK THE TAPER OF 60° BY BLUEING, BEARING PATTERN AT LEAST 75% AS PER GAUGE.

DO NOT BLUNT SHARP EDGES IN SLOTS ALONG EXTERNAL SURFACE,
SCREWS ARE NOT ALLOWED.

MAINTAIN TOLERANCE ON DIMENSION A 5 AND SURFACE FINISH OVER LENGTH L'.
PROJECTION OF PARTS AK150H-090 BEYOND PISTON SURFACE A 1 IS
NOT ALLOWED.

DIFFERENCE IN DIMENSIONS L3 AND L4. SHOULD NOT EXCEED 0.1.



INTERFERENCE 0.041

A-A AK150H-090

INTERFERENCE 0.070

GRAPHITE COATING IS APPLIED ON SURFACES T AND A, 3 OVER LENGTH
L1 AND L2 AS PER PLANT TECHNOLOGY.

ANODIZ IN CHROMIC ACID. INTERNAL SURFACES, BUTTENDS, THREE SLOTS
ON BOTH SIDES OF HOLE 44 CAN BE LEFT WITHOUT ANODIZING.



AK150H-090

AK150H-088

AK150H-089

IT IS ALLOWED TO MAKE HOLE #38
ON SURFACE D, OVER LENGTH L₅

DATE		EST. PASS.		TO BE STAMPED OR MARKED WHEN INDICATED THUS *	
		117		(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.			
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL:-		USED ON:-
DRI	6/10/73	SCALE - 1:1	-		AK 150H-32 CB
END	6/10/73	DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
TCD	6/10/73	TOLERANCE ON DIMNS	TITLE: PISTON WITH BUSH ASSY		
APPROV	6/10/73	UNLESS OTHERWISE STATED.	D S CAT NUMBER		
DATE		ALL THREADS CONFORM TO		DRAWING NUMBER	
22-1-74				AK 150H-31CB	