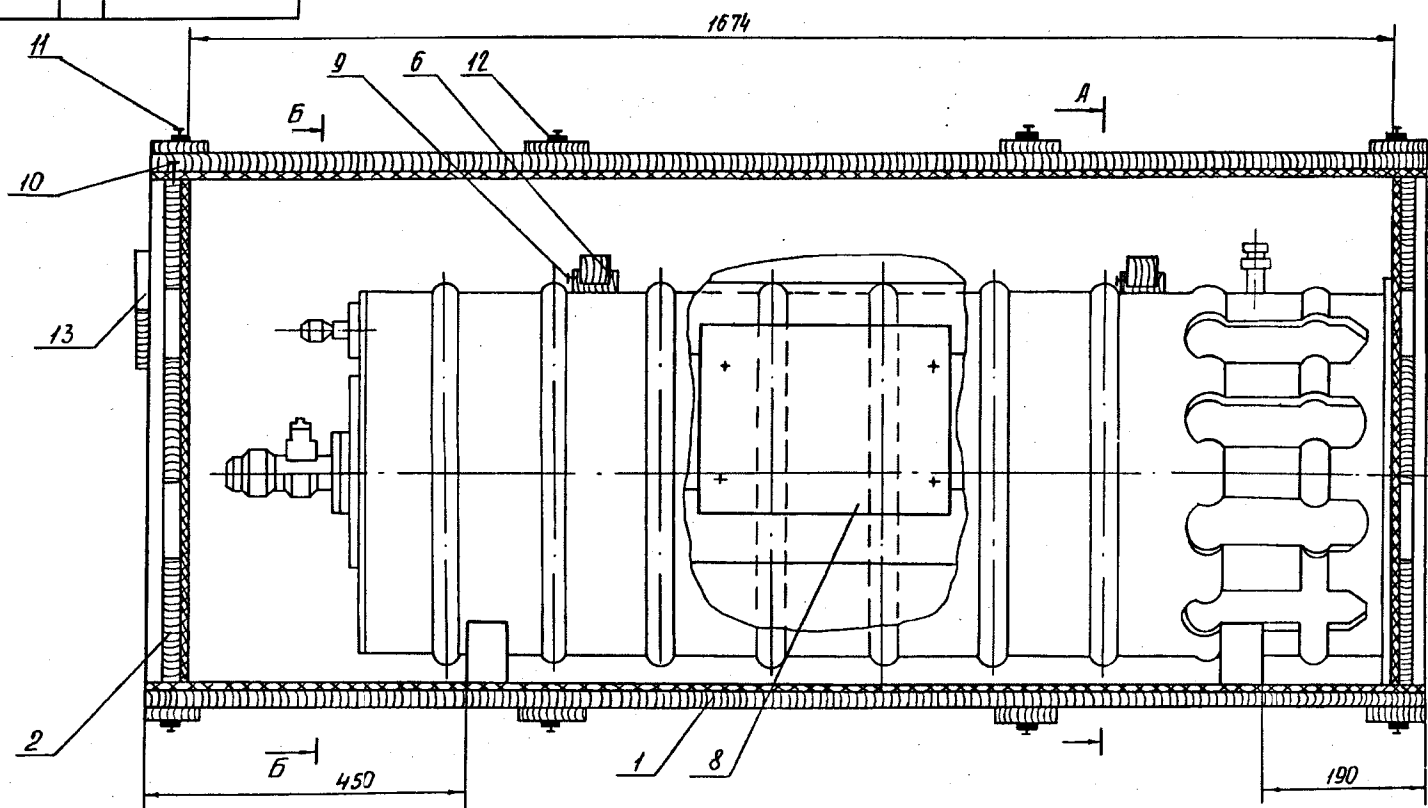


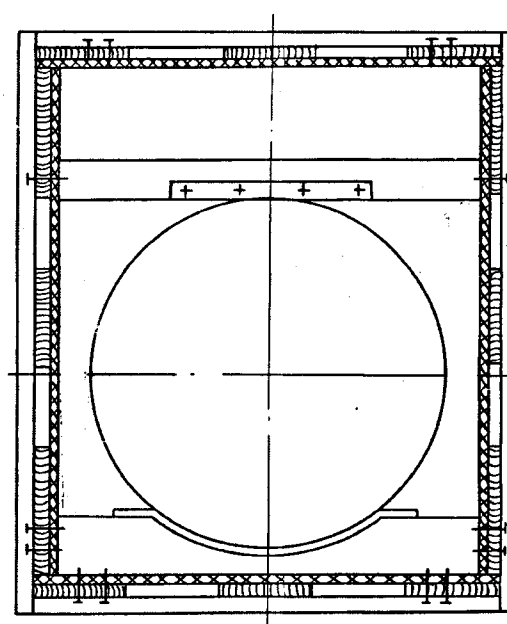
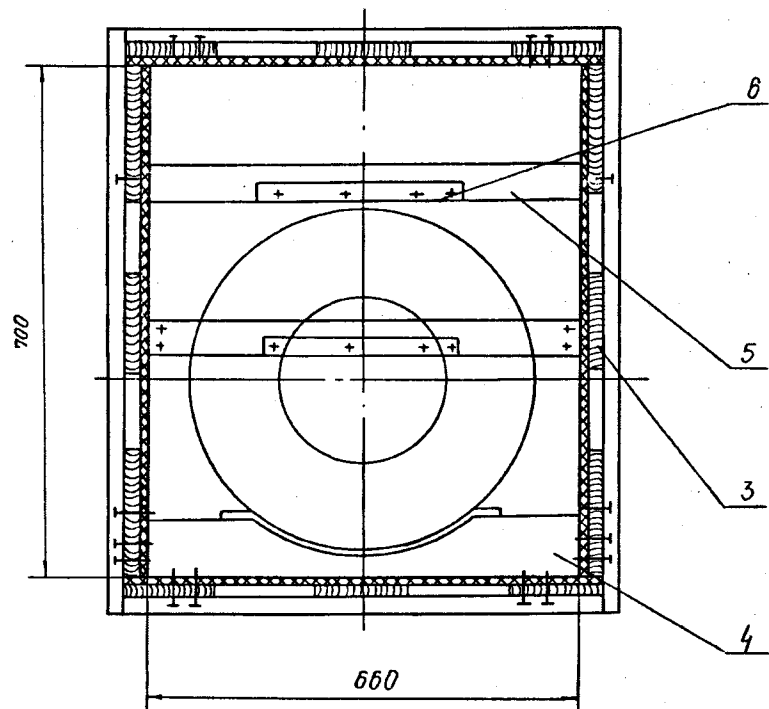
First Use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
					<u>Documents</u>		
Reference No.	A1			AK-630-Ya Sb 200-10TR SB	Assembly drawing		
					<u>Assembly units</u>		
	A4	1		AK-630-Ya Sb 200-10-1TR	Bottom-cover	2	
	A4	2		AK-630-Ya Sb 200-10-2TR	Face wall	2	
	A4	3		AK-630-Ya Sb 200-10-3TR	Side wall	2	
	A4	4		AK-630-Ya Sb 200-10-5TR	Support	2	
					<u>Components</u>		
Sign and D'	WD	5		AK-630-Ya 200-10-2TR	Felt G Pr A 8x100x180 GOST 6418-86	2	
	WD	6		AK-630-Ya 200-10-1TR	Board-2Khv-40x100 GOST 8486-86 BxHxL= 40±2x40±2x660±5	2	
	A3	8		AK-630-Ya 200-10-7TR	Tag	2	
					<u>Standard articles</u>		
Alternate Inv. No		9			Nails P 1.6x25 GOST 4028-63	75	
		10			Nails K 3x80 GOST 4028-63	200	
		11			Nails 2x25 GOST 4029-63	196	
Sign and Date					<b>AK-630-Ya Sb 200-10 TR</b>		
	Amend.	Sheet	Doc. No.	Sign	Date		
Orig. Inv. No.	Developed by				Type Sheet Sheets		
	Checked by				A 1 2		
	Head of Q.C.D				<b>Transportation box 3TR</b>		
	Approved by						





Б-Б

А-А



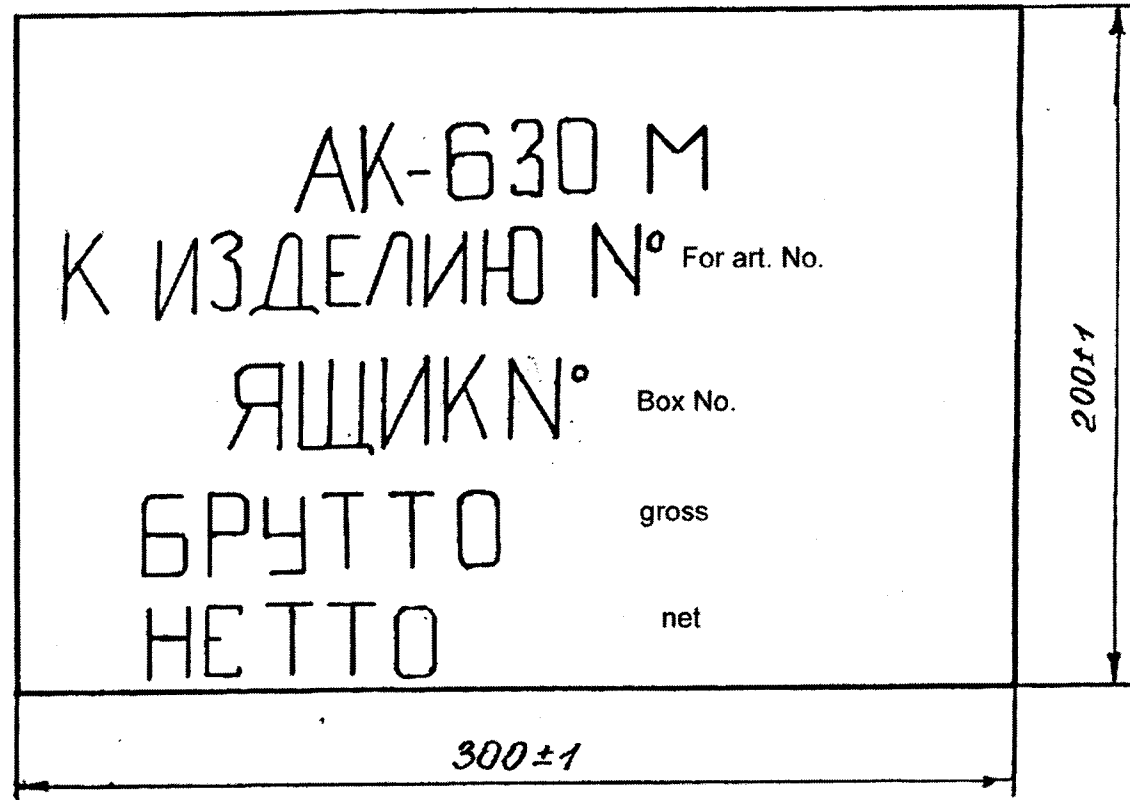
- Для спецпоставок доски обрезные, без обзола, строганные. Отверстия от сучков не допускаются.
- Опора поз.4 прибивается ко дну и боковым стенкам по 2 гвоздя поз. 10.
- Изделие закрепить 2<sup>ми</sup> брусками поз.5, которые прибивать по 2 гвоздя поз.10 к боковым стенкам ящика.
- Углы ящика обить стальной лентой поз.11.
- На 2<sup>х</sup> боковых сторонах ящика закрепить бирки поз.8 с указанием индекса изделия, № ящика и № изделия.
- Манипуляционные знаки № 1,3,11,9 (☞ ☛ ☜ ☝) с размерами для ярлыка №4 по ГОСТ 14192-96, располагать на бирке поз.8, кроме знака 9.
- Надписи и знаки выполнять эмалью ПФ-115 черная ГОСТ 6465-76, шрифт ПО-24 ГОСТ 2930-62 располагать симметрично. Остальную транспортную маркировку нанести краской на бирке поз.8 в соответствии с ГОСТ 14192-96 и договора.
- Остальные технические условия по ГОСТ В 6454-75.
- Внутреннюю поверхность и дно ящика обить пергамином кровельным П-350 ГОСТ 2697-83 или бумагой ДБ ГОСТ 2697-83 или бумагой ДБ ГОСТ 8828-89 с креплением ее дранью 3,5-5x25 поз.15 и гвоздями поз.11.
- После укупорки ящик опломбировать с использованием проволоки КО-0,5 ГОСТ 792-67 и 4<sup>х</sup> пломб I-6x10-АД1М ГОСТ 18677-73 в местах крепления ленты в замок.
- Допускается местная непрострожка каждой стороны площадью не более 20% глубиной до 1мм и чистой обработки Rz 1200.
- Для спецпоставок ящик выполнять сплошным с теми же размерами, что и решетчатый с учетом поз.13 и без древесноволокнистой плиты Т-400 ГОСТ 4598-86.

- For the special supply, the dressed corner cut boards, without ware, are used. Holes due to knots are not permitted.
- Nail the support pos. 4 to the bottom and side walls by 2 nails each pos. 10.
- Fasten the article with two bars pos. 5, which are nailed with 2 nails each pos. 10 to the side walls of box.
- Pad up the corners of box with steel strip pos. 11.
- Fasten the tags pos. 8, indicating the index of article, box number and the article number, on two side walls of the box.
- Arrange the manipulation signs no. 1,3,11,9 (☞ ☛ ☜ ☝) with the dimensions for label no. 4 as per GOST 14192-96, on the tag pos. 8, except the sign no. 9.
- Make the inscriptions and markings with enamel PF-115, black GOST 6465-76, font PO-24 GOST 2930-62, arrange them symmetrically. Carry out the remaining transportation markings with paint on tag pos. 8 in conformity with GOST 14192-96 and the agreement.
- Other technical specifications as per GOST V 6454-75.
- Pad up the internal surface and the bottom of box with roofing glassine П-350 GOST 2697-83 or with paper DB GOST 2697-83 or with paper DB GOST 8828-89 while fastening it with wooden rd 3.5 to 5x25 pos. 15 and nails pos. 11.
- After the packing, seal the box by using the wire КО-0,5 GOST 792-67 and 4 seals I-6x10-AD1M GOST 18677-73 at the places for fastening of strip for lock.
- Local non-pecking of each side is permitted with the area not more than 20 % of depth up to 1 mm and with the finishing Rz 1200.
- For the special supply, make the box with same dimensions and which is calculated with the consideration of pos. 13 and with out wooden fibre board plate Т-400 GOST 4598-86.

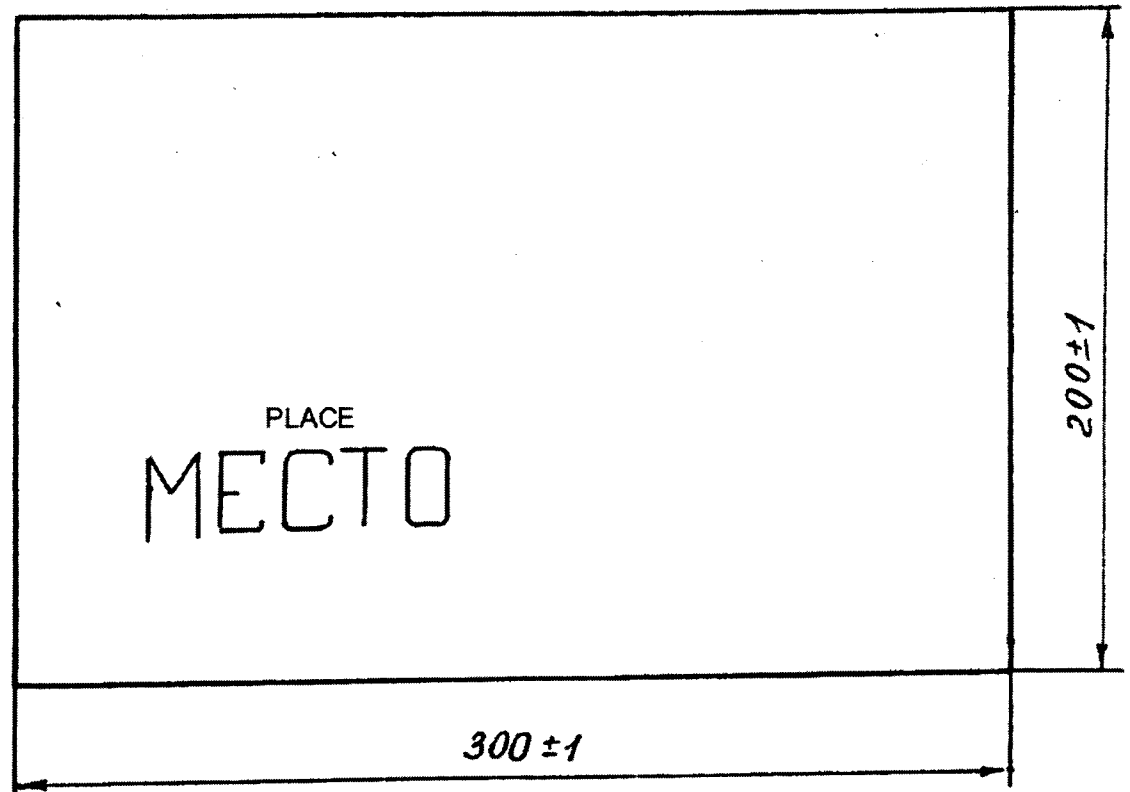
Изм.		Лист		Масса		Масштаб	
№	Дата	№	Дата	г	кг	1:5	
Исполн. _____				Ящик транспортно-рабочий №3 ТР			
Провер. _____				Сборочный чертеж			
Т.компр. _____				Transportation Box No. 3 TR			
И.компр. _____				Sheet 1			
Собрано _____				Total Sheets			

AK-630-Ya 200-9-7 TR

option Вариант I



option Вариант II



1. Make inscriptions with enamel PF-115 black GOST 6465-76.
2. Letter size PO-24 GOST 2930-62.
3. Option II- tag for article as per contract.

First use						AK-630-Ya 200-9-7 TR			
Reference No.									
Sign and Date									
Duplicate Inv. No									
Alternate Inv. No									
Sign and Date									
Orig. inv. no.									
						AK-630-Ya 200-9-7 TR			
Amend.	Sheet	Doc.No.	Sign	Date	Tag		Type	Weight	Scale
Developed by							A	0.050	1:2
Checked by							Sheet	Sheets	1
Head of Q.C.D									
Approved by					Birch veneer- birch FK/II NSh 1525x1525x4 GOST 3916.1-96				

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A3			AK-630-Ya Sb 200-10-1TR SB	Assembly drawing			
					<u>Components</u>			
	WD		1	AK-630-Ya 200-10-4TR	Board-2Khv-25x125 GOST 8486-86 L=1770±5	3		
	WD		2	AK-630-Ya 200-10-5TR	Board-2Khv-25x100 GOST 8486-86 L=712 ± 5	4		
	WD		4	AK-630-Ya 200-28TR	Plate Tgr A 4.0 GOST 4598-86 B x H = 712 ± 5 x 1770± 5	1		
					<u>Standard articles</u>			
			4		Nails 2x25 GOST 4029-63	32		
			5		Nails K 2.5x60 GOST 4028-63	32		
	Sign and Date					<b>AK-630-Ya Sb 200-10-1 TR</b>		
Amend.		Sheet	Doc. No.	Sign	Date			
Developed by					Type	Sheet	Sheets	
Checked by					A		1	
Head of Q.C.D					<b>Bottom-cover</b>			
Approved by								

First use

Reference No.

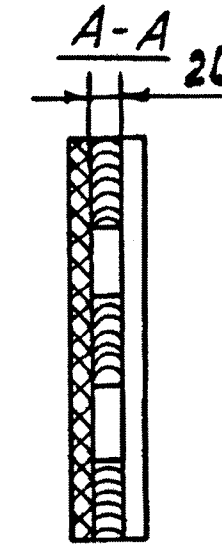
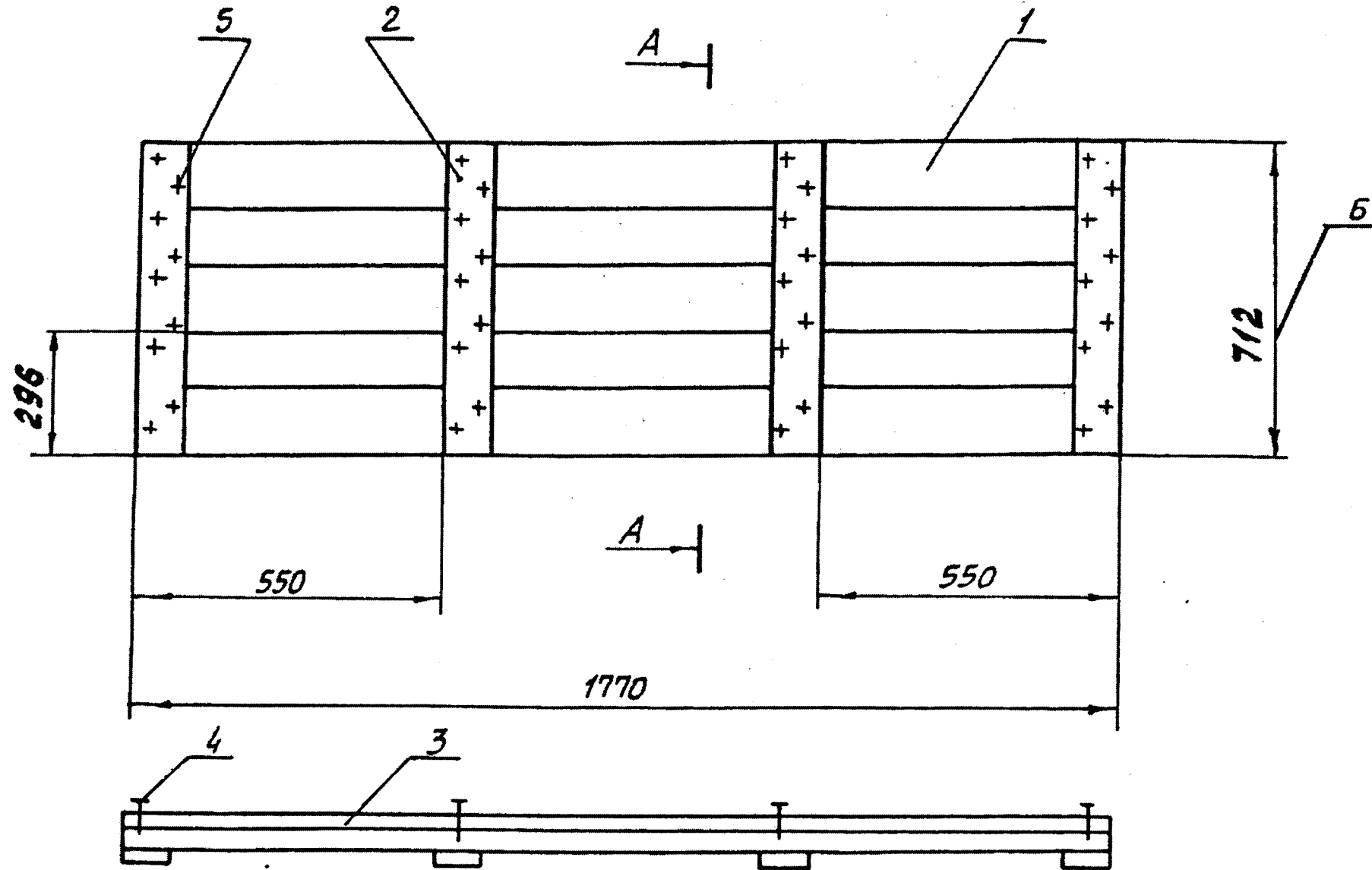
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



R<sub>z</sub> 500  
√(√)

1. Maximum deviation of dimensions as per standard accuracy class GOST 6449-5-82.
2. It is permissible to make size B from boards 2 Khv-25 GOST 8486-86 of different width, if they are not less than 70 mm.
3. For special supplies, absence of localized dressing in shape from each side in area not exceeding 20% , depth up to 1 mm is permissible.  
Surface finish  $R_z 1200 \sqrt{\quad}$ .
4. For special supplies, joining of boards in  $\frac{1}{4}$  K-2 as per GOST 9330-76, maintaining dimensions A and B and without plate.

Amend.	Sheet	Doc.No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

AK-630-Ya Sb 200-10-1 TR SB

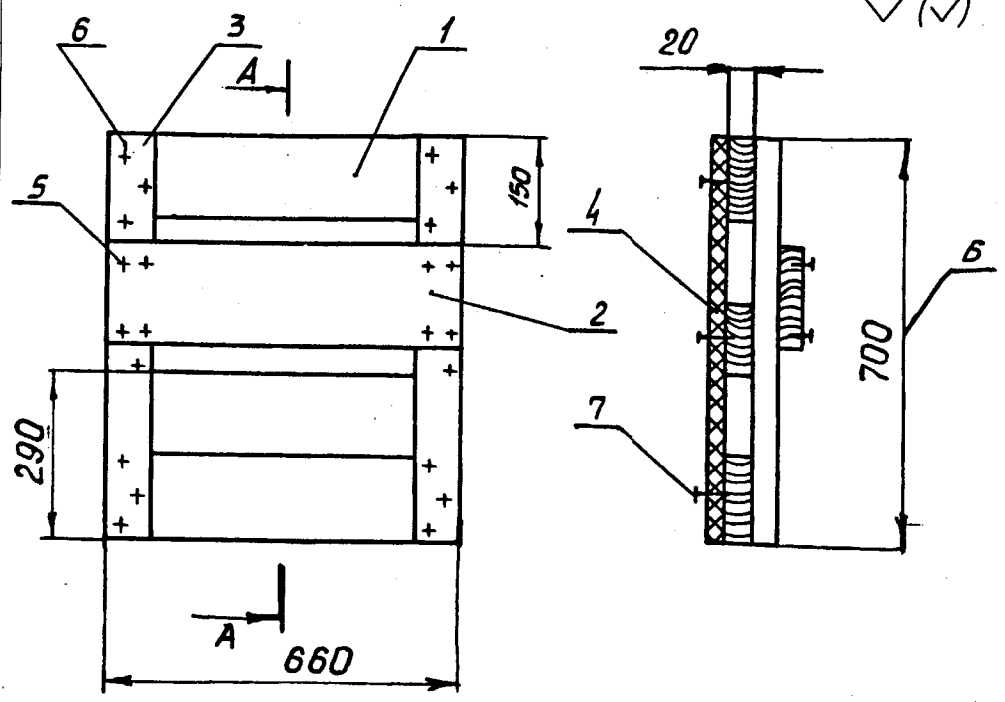
Cover-bottom  
Assembly drawing

Type	Weight	Scale
A	21	1:10
Sheet	Sheets 1	

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					Documents			
	A4	/		AK-630-Ya Sb 200-10-2TR SB	Assembly drawing			
					Components			
	WD	/	1	AK-630-Ya 200-10-7TR	Board-2Khv-25 x125 GOST 8486-86 L=660±5	3		
	WD	/	2	AK-630-Ya 200-10-8TR	Board-2Khv-25 x100 GOST 8486-86 L=662 ± 5	1		
	WD	/	3	AK-630-Ya 200-10-9TR	Board-2Khv-25 x100 GOST 8486-86 L=700 ± 5	2		
	WD	/	4	AK-630-Ya 200-10-10TR	Plate Tgr A 4.0 GOST 4598-86 B x H = 660 ± 5 x 700± 5	1		
					Standard articles			
			5		Nails K 3x80 GOST 4028-63	18		
			6		Nails K 2.5x60 GOST 4028-63	8		
		7		Nails 2x25 GOST 4029-63	18			
Sign and Date	<b>AK-630-Ya Sb 200-10-2 TR</b>							
	Amend.	Sheet	Doc. No.	Sign	Date			
Orig. Inv. No.	Developed by				<b>Face wall</b>	Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D							
	Approved by							

AK-630 -Ya Sb200-10-2TR SB

Approved OGMat	Sign and Date	Approved TOSb	Sign and Date	Approved by shop	Reference No.	First use
Orig. Inv. No.		Alternate Inv. No.				
		Dupl. Inv. No.				



1. Maximum deviation of dimensions as per mean accuracy class GOST 6449.5-82.
2. It is permissible to assemble dimension B from boards- 2 Khv-25 GOST 8486-86 having various widths but not less than 70 mm.
3. Absence of planing at separate places on each side, of area not exceeding 20% and depth up to 1 mm with surface finish Rz 1200 for export supply is permissible.
4. For export supplies joining of boards- in 1/4 K-2 GOST 9330-70, maintaining dimensions A and B without plate.

AK-630 -Ya Sb200-10-2 TR SB				
Amend.	Sheet	Doc. No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Design bureau chief				
Head of Q.C.D				
Approved by				

Face wall Assembly drawing	Type	Weight	Scale
	A	7.0	1:10
Sheet		Sheets 1	

Copied by \_\_\_\_\_ Format A4

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
Reference No.					<u>Documents</u>			
	A3	/		AK-630-Ya Sb 200-10-3TR SB	Assembly drawing			
					<u>Components</u>			
	WD	/	1	AK-630-Ya 200-10-11TR	Board-2Khv-25 x100 GOST 8486-86 L= 788 ± 5	4		
	WD	/	2	AK-630-Ya 200-10-12TR	Board-2Khv-25 x125 GOST 8486-86 L= 1770 ± 5	4		
	WD	/	4	AK-630-Ya 200-29TR	Plate Tgr A 4.0 GOST 4598-86 B x H = 700 ± 5x 1770± 5	1		
					<u>Standard articles</u>			
			5		Nails 2x25 GOST 4029-63	32		
			6		Nails K 2.5x60 GOST 4028-63	32		
	Sign and Date					<b>AK-630-Ya Sb 200-10-3 TR</b>		
Amend.		Sheet	Doc. No.	Sign	Date			
Developed by					Type	Sheet	Sheets	
Checked by					A		1	
Head of Q.C.D					<b>Side wall</b>			
Approved by								

First use

Reference No.

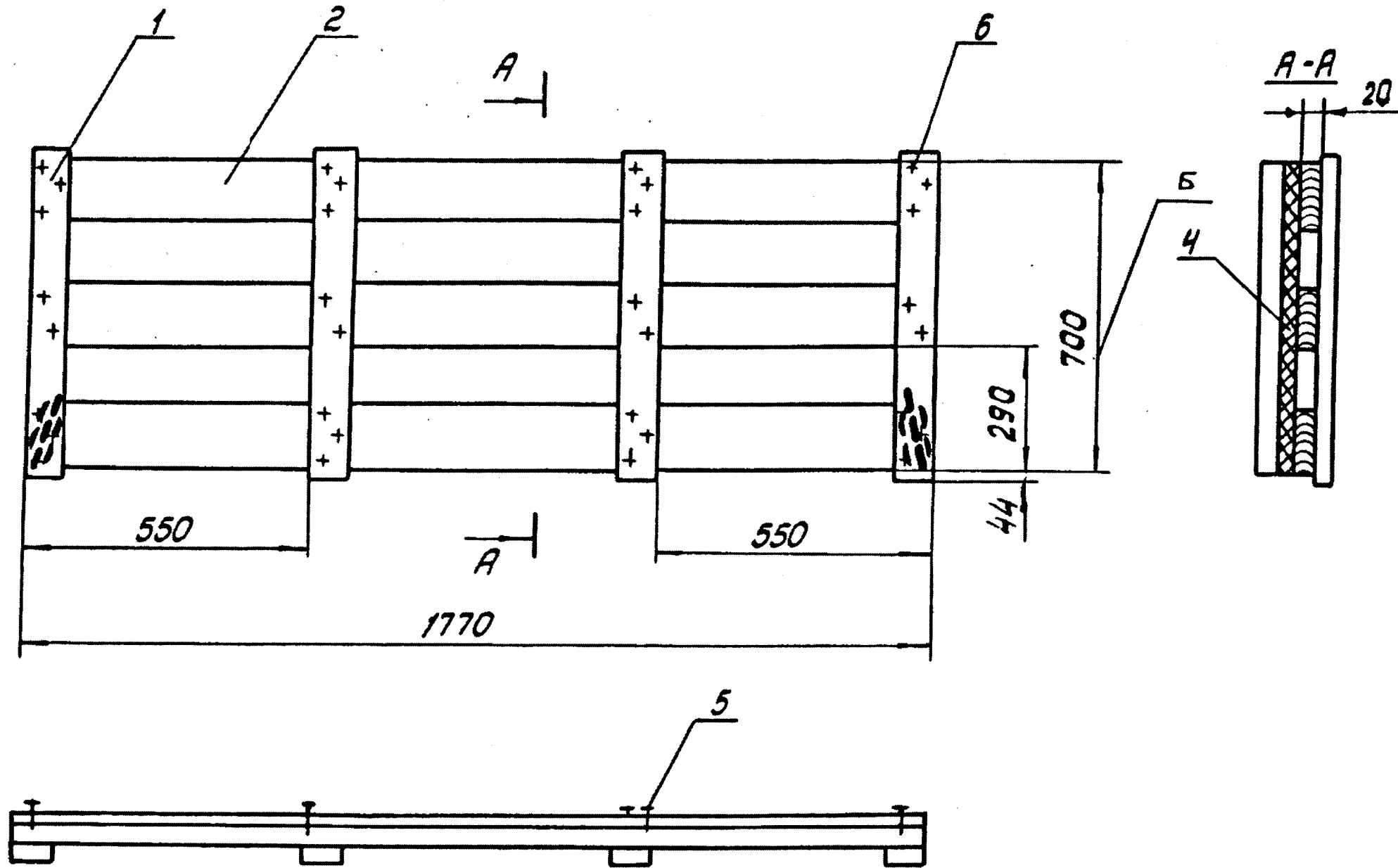
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



R<sub>z</sub> 500/√(√)

1. Maximum deviation of dimensions as per standard accuracy class GOST 6449-5-82.
2. It is permissible to make size B from boards 2 Khv-25 GOST 8486-86 of different width, if they are not less than 70 mm.
3. Absence of localized dressing in shape from each side in area not exceeding 20%, depth up to 1 mm is permissible.  
Surface finish  $R_z 1200 \sqrt{\cdot}$ .
4. For special supplies, joining of boards in  $\frac{1}{4}$  K-2 as per GOST 9330-76, maintaining dimensions A and B and without plate.

Amend.	Sheet	Doc.No.	Sign	Date
Developed by				
Checked by				
Head of Q.C.D				
Approved by				

AK-630-Ya Sb 200-10-3 TR SB

Side wall  
Assembly drawing

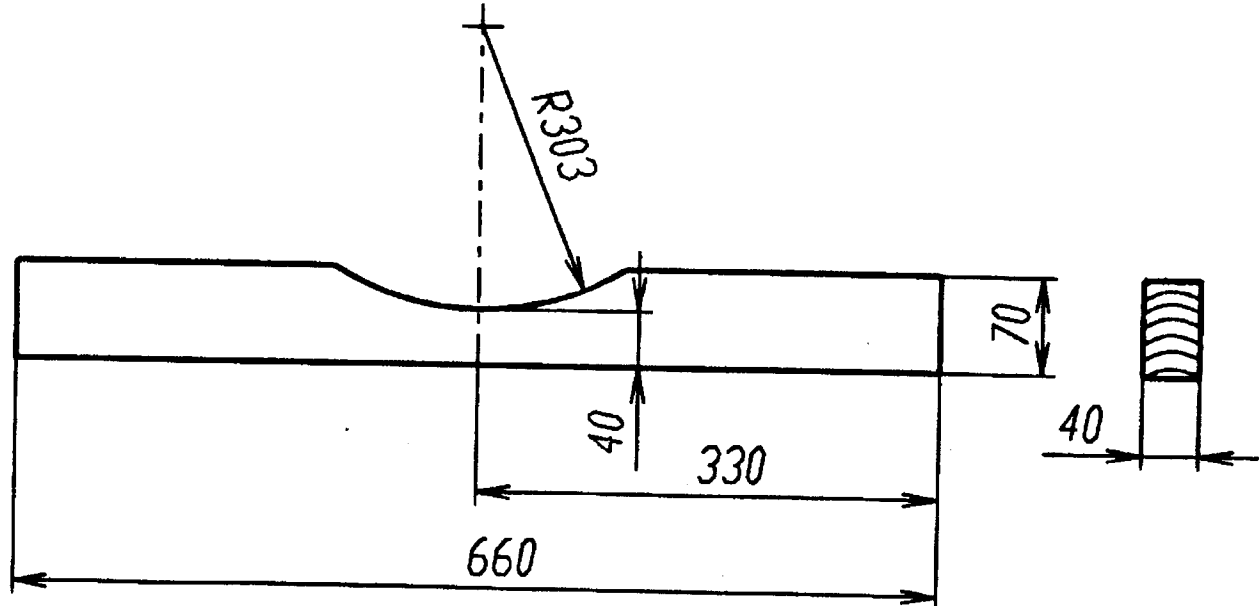
Type	Weight	Scale
A	21	1:10
Sheet	Sheets	1

First use	Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
Reference No.					Documents		
	A4			AK-630-Ya Sb 200-10-5TR SB	Assembly drawing		
					Components		
	A4	1		AK-630-Ya 200-10-17TR	Support	1	
	WD	2		AK-630-Ya 200-10-18TR	Felt G Pr A 10x40x320	1	
					GOST 6418-86		
					Standard articles		
			3		Nails P 1.6 x 25	10	
					GOST 4028-63		
Sign and Date							
Sign and Date					<b>AK-630-Ya Sb 200-10-5 TR</b>		
	Amend.	Sheet	Doc. No.	Sign	Date		
	Developed by					Type	Sheet
	Checked by					A	1
	Head of Q.C.D						
Orig. Inv. No.	Approved by						



AK-630-Я 200-10-17 TP

Rz800  
 ✓ (✓)



Предельные отклонения размеров по среднему классу точности ГОСТ 6449.5-82.

Перв. примен.	Справ. N	Подп. и дата	Изм. N	Взам. инв. N	Изм. N	Дзвл.	Подп. и дата

AK-630-Я 200-10-17 TP

Опора

Доска-2хв-50 ГОСТ 8486-86

Лит.	Масса	Масштаб
A	1,5	1:5
Лист	Листов I	

Формат А4