

DRAWING NUMBER
413-33-2

Rz 20/ (✓)

EXPLANATORY NOTE:

REFERENCE MATERIAL QUOTED:

6. CARBON STRUCTURAL, HOT ROLLED STEEL, GRADE 15 AND REFERENCE NOTE 1 ON ALTERNATE MATERIAL STEEL GRADE 20 TO GOST 1050-74.

a) CHEMICAL COMPOSITION:

GRADE OF STEEL	CONTENT OF ELEMENTS %						REMARKS
	C	Si	Mn	Cr	S	P	
15	0.12	0.17	0.35	0.25	0.040	0.035	REF. MATL
	0.19	0.37	0.65				
20	0.17	0.17	0.35	0.25	0.040	0.035	ALT. MATL
	0.24	0.37	0.65				

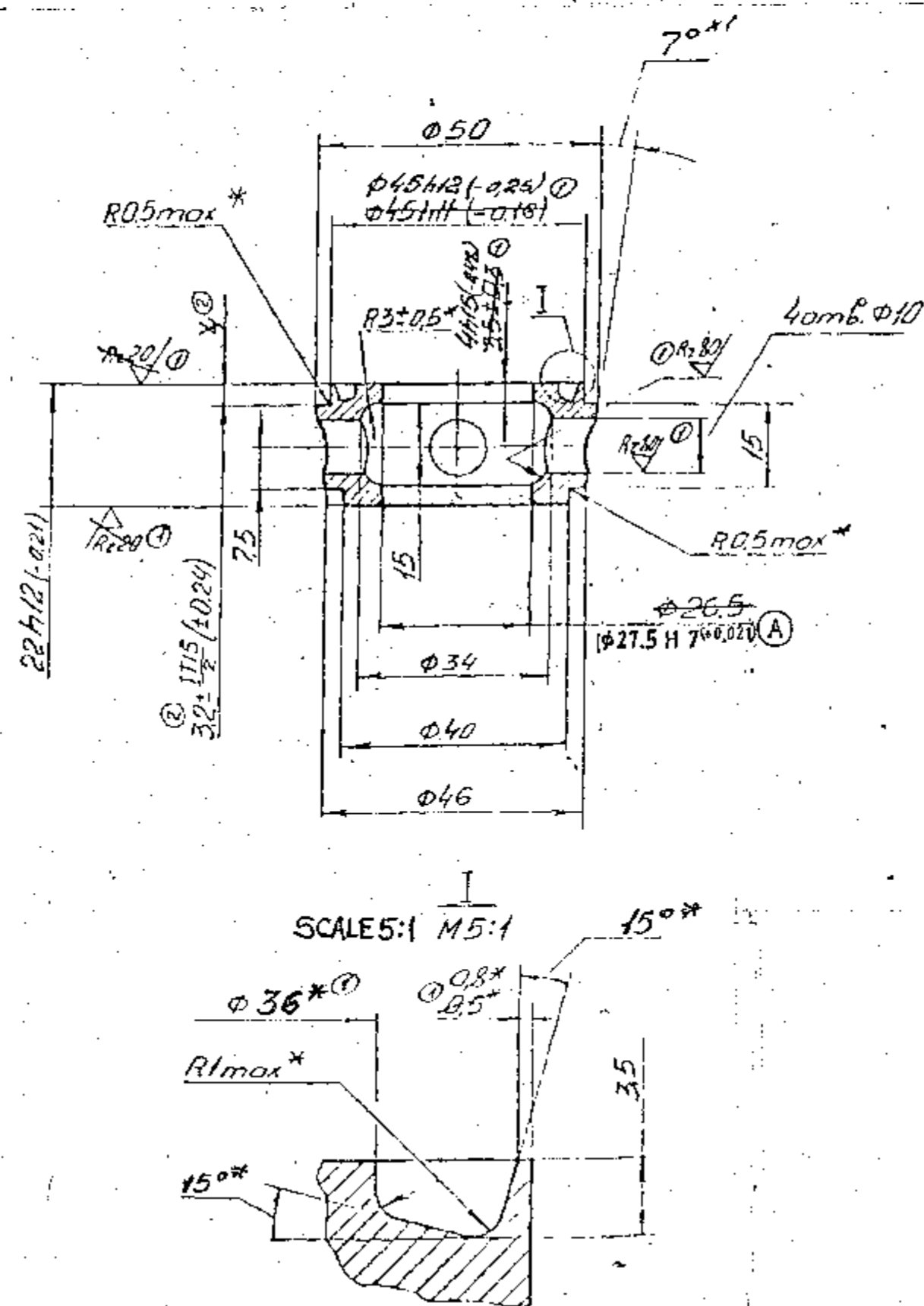
RESIDUAL CONTENTS OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH.

b) MECHANICAL PROPERTIES AS PER NORMALISED CONDITION.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	YIELD POINT Kg/mm ²	ELONGATION %	REDUCTION IN AREA %	HARDNESS B H N	REMARKS
15	38	23	27	55	149	Ref, Matl
20	42	25	25	55	163	Alt, Matl

1. Заменитель материала сталь 20 ГОСТ 1050-74.
 2. Неуказанные предельные отклонения размеров отверстий по H14, валов по h14, остальных по IT14.
 3. Клеить окончательную приемку на бирке для партии деталей.
 4. * Размеры обеспечиваются инструментом.
 5. * Размер для справок.

1. ALTERNATE MATERIAL: STEEL 20 GOST 1050-74.
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS OF HOLES AS PER H14, OF SHAFTS AS PER h14, OF THE REST OF DIMENSION $\pm IT 14$.
3. MARK OF FINAL ACCEPTANCE SHOULD BE PUT ON TAG FOR BATCH OF COMPONENTS.
4. * DIMENSIONS ARE TO BE ENSURED BY TOOL.
5. *1 DIMENSION FOR REFERENCE.
6. * DIMENSION PUT IN BRACKETS AFTER ASSEMBLY.



SCALE 5:1 M5:1

ORG. (UN)ANISED BASED ON RUSSIAN ORIGINAL ISSUE - 3

A 6
SIZE A2

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

EST. MASS 0.14 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)

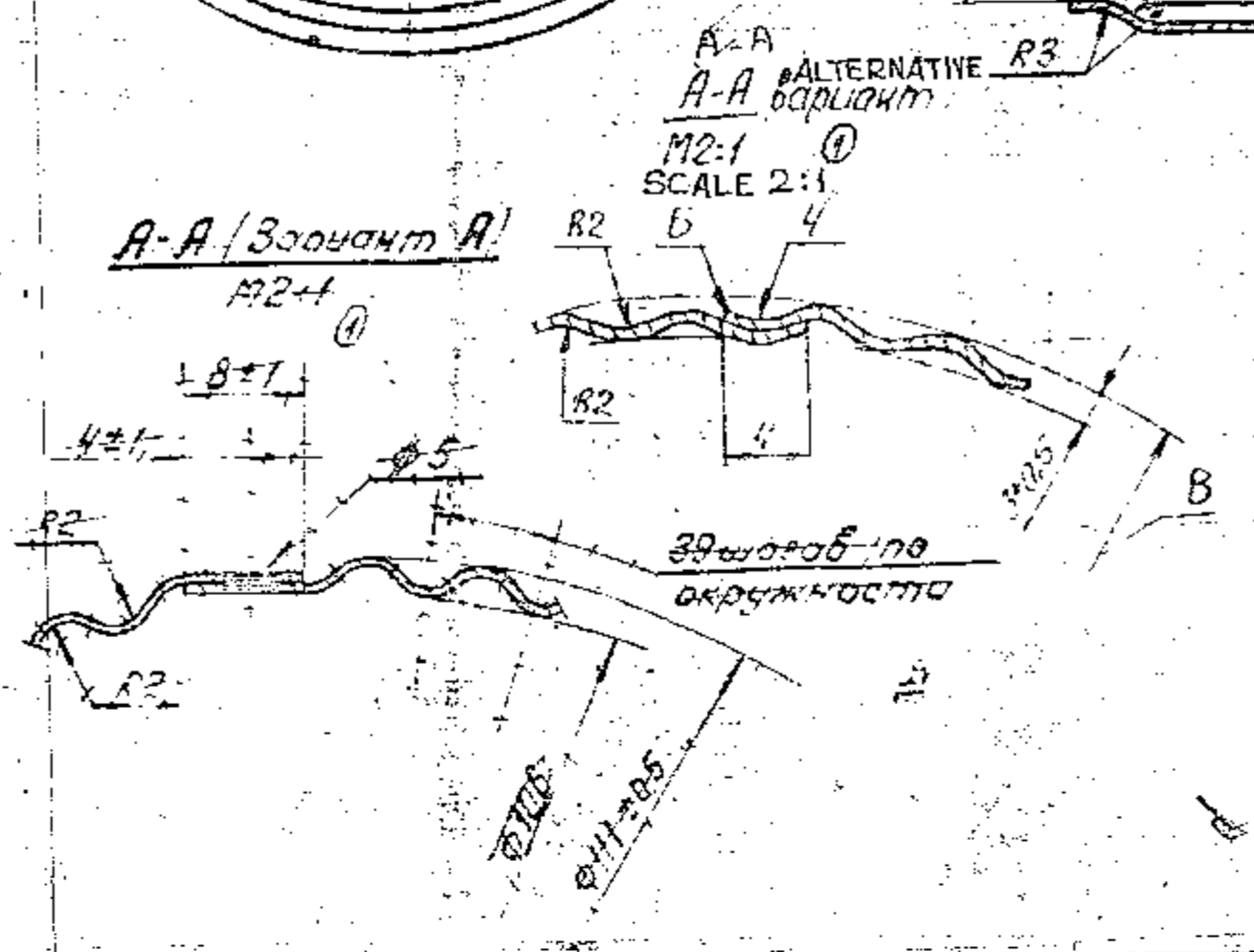
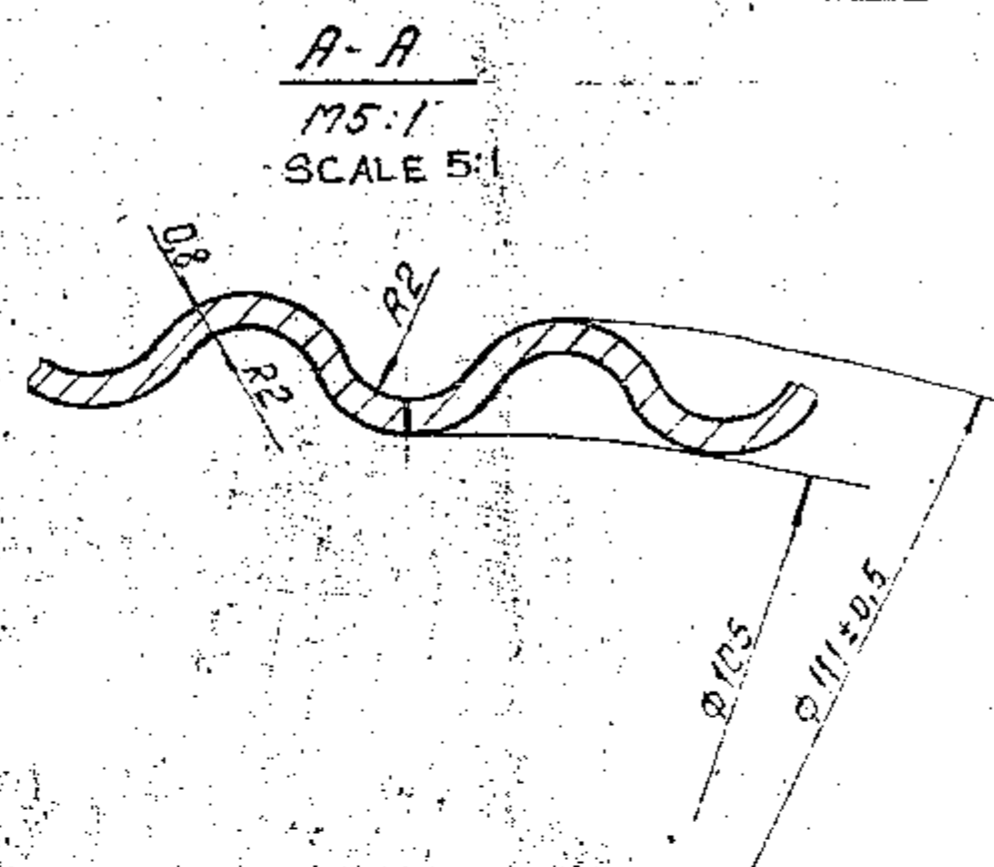
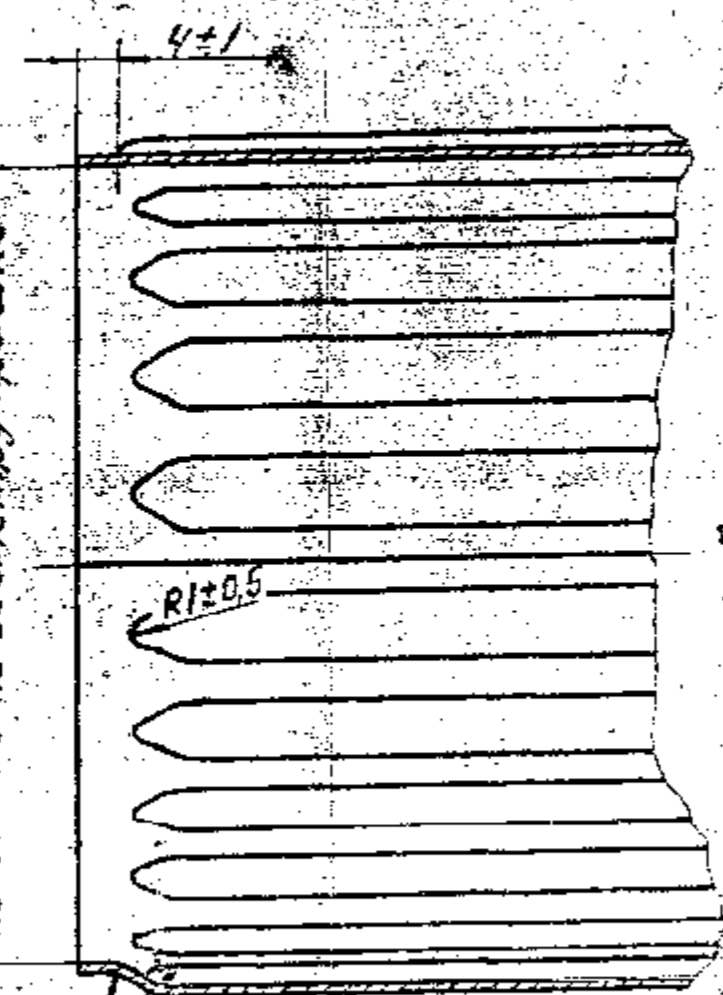
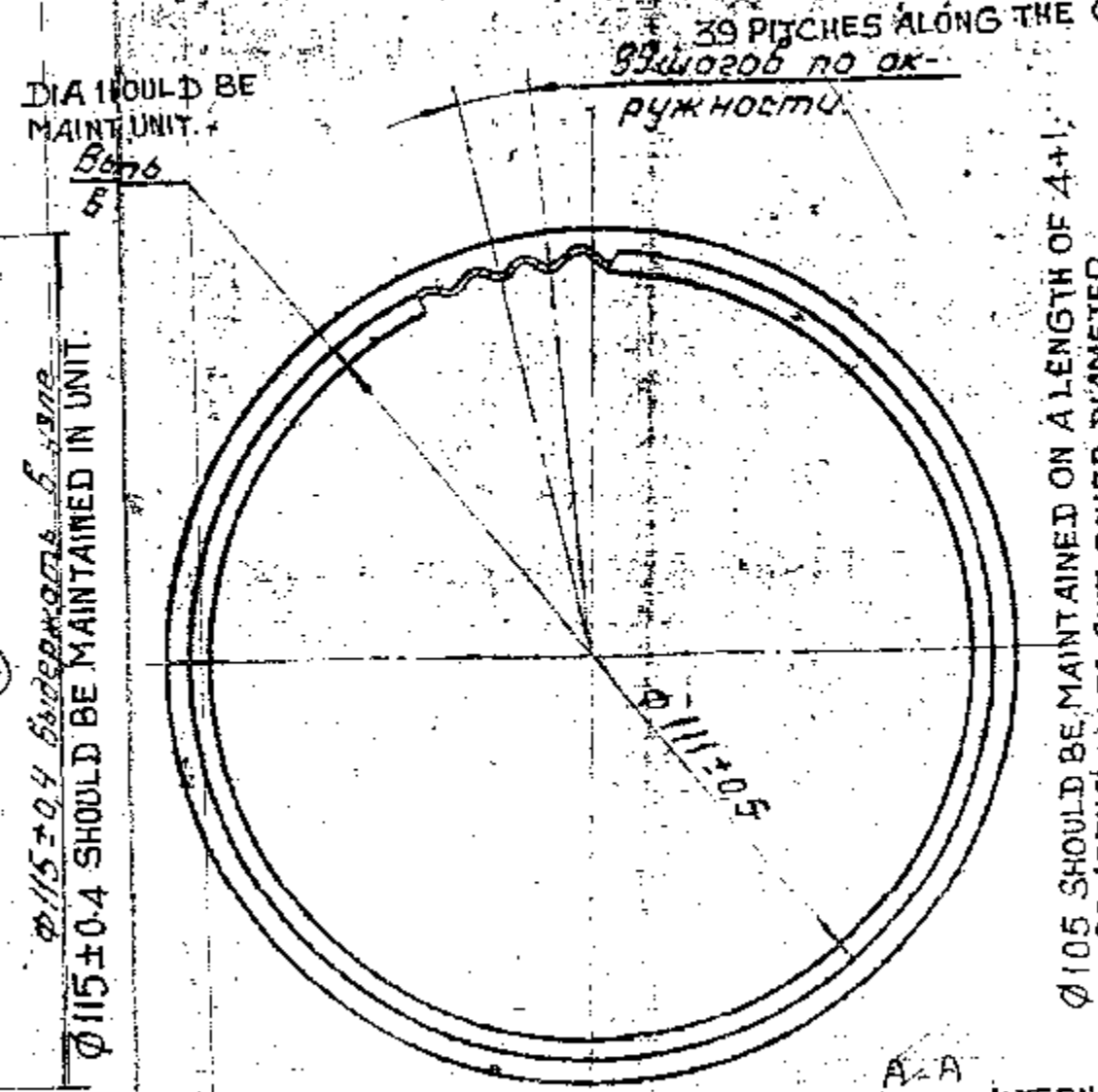
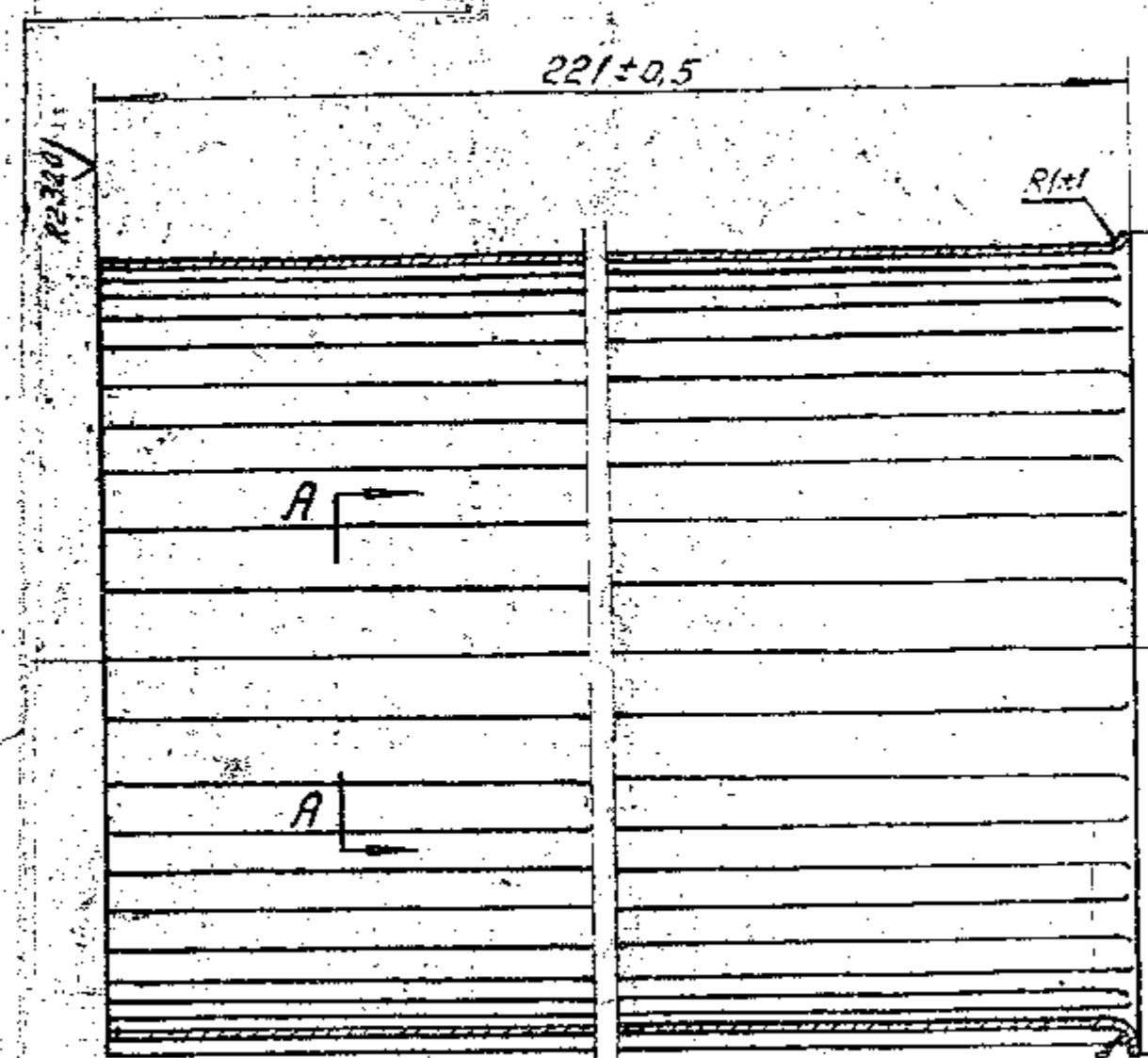
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	TCD	APPD	DATE	SCALE - 1:1	MATERIAL -	USED ON -
				19-5-86		STEEL 15 GOST 1050-74	CG 413-8-1 CG 413-11-1 CG 413-12-1
DIMENSIONS IN mm.						CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.						TITLE -	
ALL THREADS CONFORM TO						SEALING BUSH	
A 20.9.89 AUTHY. BK 84-802.						D S CAT NUMBER	
ISSUE DATE NATURE OF AMENDMENTS						DRAWING NUMBER	
						413-33-2	



DRAWING NUMBER
413 39

✓(✓)



ВАРИАНТ 5
ALTERNATIVE 5

EXPLANATORY NOTE

1. REFERENCE MATERIAL QUOTED: COLD ROLLED SHEET STEEL, HIGH ACCURACY, IN ROLLING ACCORDANCE TO GOST 19904-74 AND HIGH SURFACE FINISH II. EXTREMELY DEEP DRAWING 'BF' AND MANUFACTURED IN ACCORDANCE WITH COLD ROLLED THIN SHEET, FOR FORMING TO GOST 3045-80 AT CHEMICAL COMPOSITION AS PER GOST 1050-74.

GRADE OF STEEL	CONTENT OF ELEMENTS %						
	C	Mn	S	P	Cr	Ni	Cu
08nc	0.10	0.20-0.40	0.030	0.035	0.03	0.10	0.15

CATEGORY	GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	ELONGATION % min
		26-37	28

2. REFERENCE NOTE B' ON ALTERNATE MATERIAL QUALITY: CARBON STEEL COLD ROLLED GRADES 08nc, 10 AND 10Knl TO GOST 10523-70 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL 1050-74.

3. CHEMICAL COMPOSITION AS PER GOST 1050-74.

GRADE OF STEEL	CONTENT OF ELEMENTS %						
	C	Mn	S	P	Cr	Ni	Cu
08nc	0.05-0.11	0.05-0.17	0.035-0.05	0.10	0.040	0.035	
10	0.07-0.14	0.17-0.37	0.15-0.05	0.15	0.040	0.035	
10Knl	0.07-0.14	0.07 max	0.25-0.50	0.15	0.040	0.035	

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH. MANGANESE CONTENT UP TO 0.25% AS REGARDS LOWER LIMIT, IS ALLOWED IN THE STEEL OF GRADE 08nc MEANT FOR PRODUCTION OF SHEET STEEL FOR COLD STAMPING.

4. MECHANICAL PROPERTIES AS PER GOST 10523-70.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	ELONGATION % min
08nc	28-40	25
10	30-42	25
10Knl	28-40	25

- DELETED.
- DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE OBTAINED WITH AN ACCURACY OF ±0.5mm
- COMPONENT SURFACES SHOULD BE SMOOTH AND CLEAN. EDGES SHOULD BE FREE FROM FISSURES AND BURRS.
- CRACKS ARE NOT ALLOWED.
- PROFILE OF BENDS IS NOT TO BE CHECKED.
- MAY BE MANUFACTURED AS PER ALTERNATIVE '5'.
- ALTERNATE MATERIAL: STEEL, GRADES 08nc, 10 AND 10Knl (RIMMING) GOST 1050-74.
- PROJECTION OF EDGE 'B' BEYOND DIAMETER 'B' IS NOT ALLOWED.
- SEAM RESISTANCE WELDING.

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

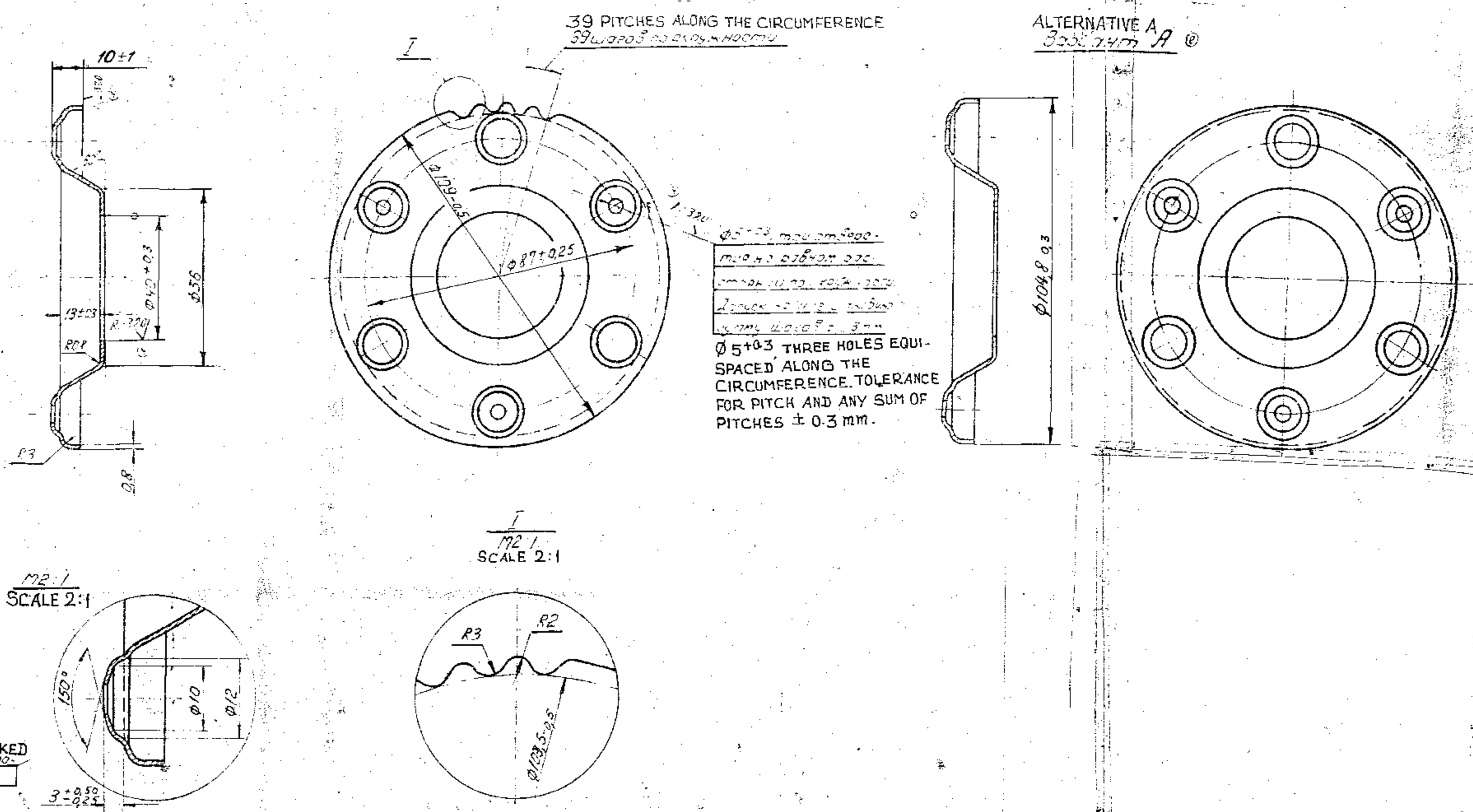
EST. MASS 0.375 kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)

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

DRW	END	TCD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	ALL THREADS CONFORM TO	MATERIAL - SHEET A 0.8 GOST 19904-74 II - BF - 08Knl GOST 3045-80	USED ON - LB 473-11 1CG
				26-5-86	1:1				CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADH	
								TITLE: BODY CUP SECOND SECTION		
								D S CAT NUMBER		
								DRAWING NUMBER 413 39		
ISSUE	DATE	NATURE OF AMENDMENTS								

A-6
SIZE A2





EXPLANATORY NOTE

9. REFERENCE MATERIAL QUOTED: COLD ROLLED SHEET STEEL, HIGH ACCURACY ON ROLLING 'A' 0.8mm THICK TO GOST 19904-74, AND HIGH SURFACE FINISH 'I' EXTREMELY DEEP DRAWING 'B' AND MANUFACTURED IN ACCORDANCE WITH COLD-ROLLED THIN SHEET STEEL 08kn TO GOST 9045-80. a) CHEMICAL COMPOSITION AS PER GOST 9045-80.

GRADE OF STEEL	CONTENT OF ELEMENTS %						
	C	Mn	S	P	Cr	Ni	Cu
08kn	0.10	0.20-0.40	0.020	0.025	0.03	0.10	0.15

b) MECHANICAL PROPERTIES:

CATEGORY	GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	ELONGATION % min
B'	08kn	26-37	28

10. REFERENCE NOTE '8' ON ALTERNATE MATERIAL QUALITY CARBON STEEL OLD ROLLED GRADES 08kn, 10 AND 10kn TO GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL TO GOST 1050-74.

a) CHEMICAL COMPOSITION AS PER GOST 1050-74

GRADE OF STEEL	CONTENT OF ELEMENTS %					
	C	Si	Mn	Cr	S	P
08kn	0.05-0.11	0.05-0.17	0.35-0.65	0.10	0.040	0.035
10	0.07-0.14	0.17-0.37	0.35-0.65	0.15	0.040	0.035
10kn	0.07-0.14	0.07 max	0.25-0.50	0.15	0.040	0.035

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH. MANGANESE CONTENT UPTO 0.25% AS REGARDS LOWER LIMIT, IS ALLOWED IN THE STEEL OF GRADE 08kn MEANT FOR PRODUCTION OF SHEET STEEL FOR COLD STAMPING.

b) MECHANICAL PROPERTIES AS PER GOST 16523-70.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	ELONGATION % min
08kn	28-40	25
10	30-42	25
10kn	28-40	25

- DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE OBTAINED WITH AN ACCURACY OF ±0.5mm
- UNSPECIFIED RADII DURING STAMPING SHOULD BE R1±0.5mm
- COMPONENT SURFACES SHOULD BE SMOOTH AND CLEAN THE EDGES SHOULD BE FREE FROM FISSURES AND BURNS.
- CRACKS ARE NOT ALLOWED.
- PROFILE OF BENDS IS NOT TO BE CHECKED.
- ALTERNATIVE A IS TO BE USED IN CASE, IF THE BODY OF SECOND SECTION CUP IS MANUFACTURED WITH UNCORRUGATED STRIP AS PER ALTERNATIVE B OF DRAWING 413-39
- ALTERNATE MATERIAL: STEEL GRADES 08kn, 10 AND 10kn (RIMMING) GOST 1050-74.

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

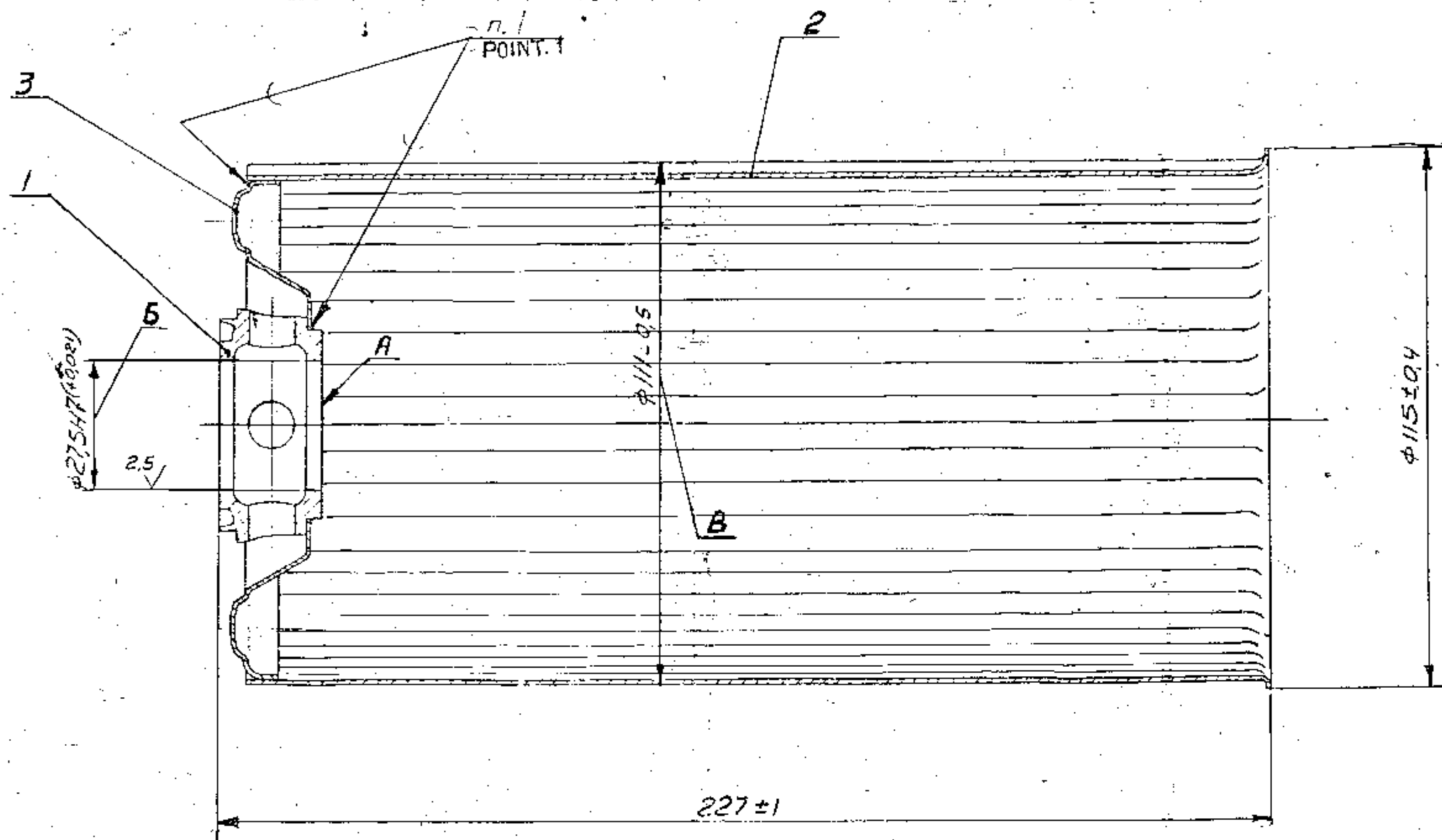
EST. MASS - 0.055 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)

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

DRN	CHD	TCD	APPD	DATE	SCALE - 1:1	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	ALL THREADS CONFORM TO	ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL - SHEET	A 0.8kn GOST 19904-74	USEN NO	CB 413 11 1 CE	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	TITLE -	BOTTOM CUP SECOND SECTION	D S CAT NUMBER	413 40
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DRAWING NUMBER
 СБ 413 11 1СБ



1. BRASS 63 GOST 15527-70.
2. COATING: Zn 6. CHROMATIZING AS PER INSTRUCTIONS UA-483-82. ASSEMBLY MAY BE PLATED ALONG WITH COMPONENT 3313-166 AFTER ITS PLATING.
3. TRACES FROM BRAZING DRESSING ARE ALLOWED ON SURFACE 'A'.
4. LOCAL ABSENCE OF COATING IS ALLOWED IN PLACES OF BRAZING, AT BOTTOM AND BODY JOINTS, IN THE DEPRESSIONS OF CUP BOTTOM (ON THE EXTERNAL & INTERNAL SURFACES).
5. HOLE 'B' IS TO BE FINALLY TAPPED AFTER COATING. THERE MAY BE NO COATING ON THE TAPPED SURFACE.
6. MISALIGNMENT OF HOLES 'B' AND DIAMETER 'B' SHOULD NOT EXCEED 0.2mm (MMC).

DRG. INDICATED BASED ON RUSSIAN ORIGINAL ISSUE - 3

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

EST. MASS 0.66 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)
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ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	TCD	APPD	DATE	SCALE	DIMENSIONS IN mm.	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	ALL THREADS CONFORM TO
				19-5-86	1:1			
MATERIAL:-					USED ON:-			
					СБ 413 05 1СБ			
CONTROLLER					RATE OF INSPECTION (HEAVY VEHICLES)			
					AVADI			
					TITLE: SUB ASSY CUP SECOND			
					SLOT TYPE FILTERING SECTION			
D S CAT NUMBER					DRAWING NUMBER			
					СБ 413 11 1СБ			
A	20.9.89	AUTHY. BK 84-841						
ISSUE	DATE	NATURE OF AMENDMENTS						

A-6
 SIZE A2



