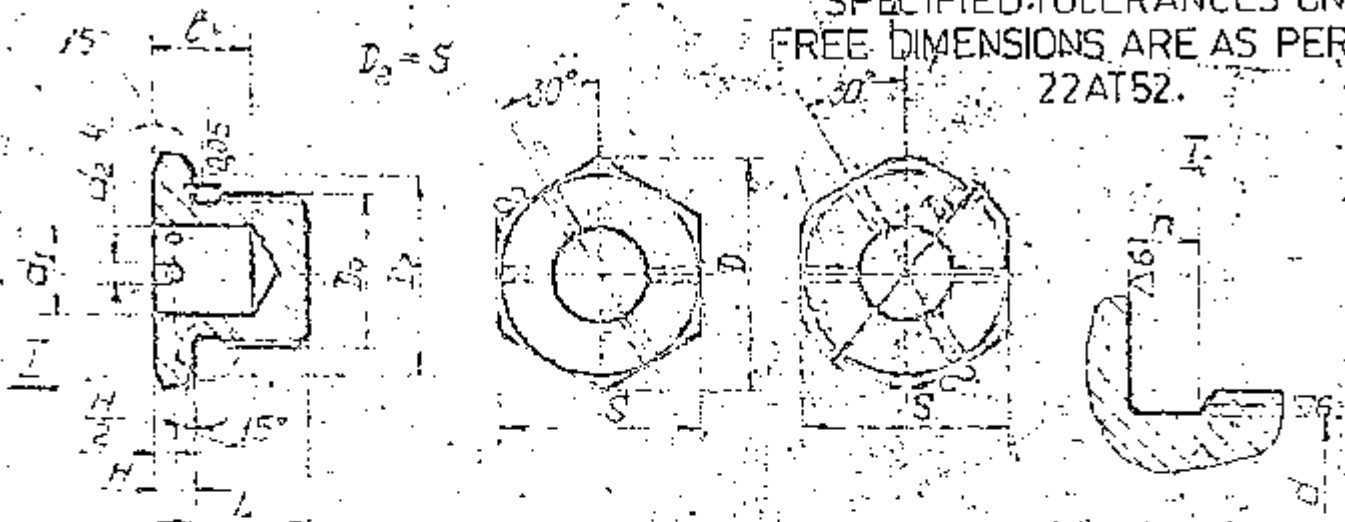


| | | | |
|--------------------------|--|---------------------|--------------|
| | | 12 HK | |
| PLUG | | EDITION 4, 1964. | |
| FOR RUBBER SEALING RINGS | | INSTEAD OF ISSUE 3. | |
| S.H.C. | | SHEET | TOTAL SHEETS |

UNLESS OTHERWISE SPECIFIED TOLERANCES ON FREE DIMENSIONS ARE AS PER 22AT52.



EXAMPLE OF MARKING OF CADMIUM-PLATED PLUG WITH THREAD M16x1,5 ; 12HK 16x1,5 - K.

| THREAD | Dc | TOLC _c | D | D1 | L | H | d | d1 | t | π | d2 |
|--------------|----|-------------------|------|----|----|---|-----|----|---|---|-----|
| M6 class 3/1 | | 11 | 12,7 | - | 12 | 4 | 4,5 | - | - | 2 | 1,5 |

Steel 45 - GOST 1051-73.

Thread before coating is as per 214 AT.

Turning and chamfer of thread are as per OST 100010-71.

Thickness of coating is 0,009 to 0,013.

Designation with other types of coating are as per 101 ATY (table.2).

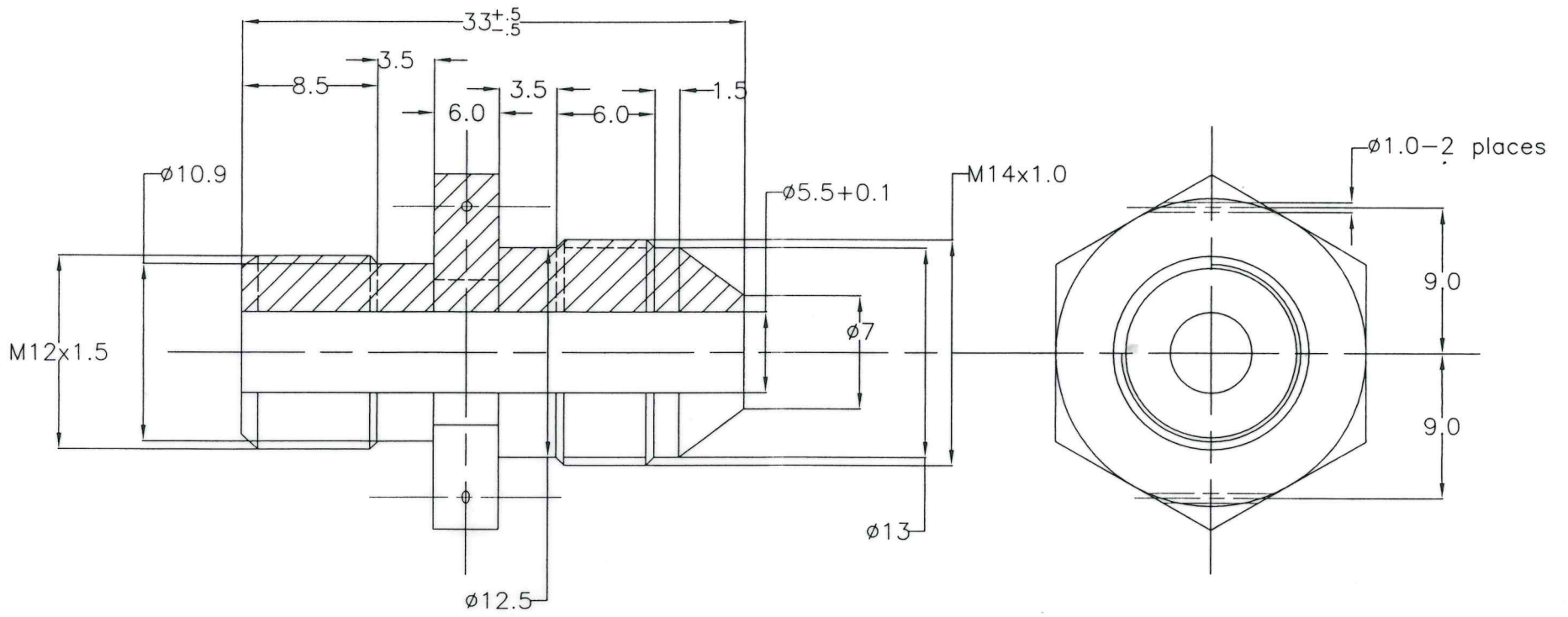
* For parts with threads M6, M8 and M10 designation of the part no. should contain pitch of thread.

(6x1 ; 8x1,25 ; 10x1,5)

| | |
|-------------------------------|--|
| 10.8.95 | 765-78-С86 |
| Design Check Approv | PLUG FOR RUBBER SEALING RINGS 12 HK |

CONTROLLED BY QUALITY ASSURANCE

92/107



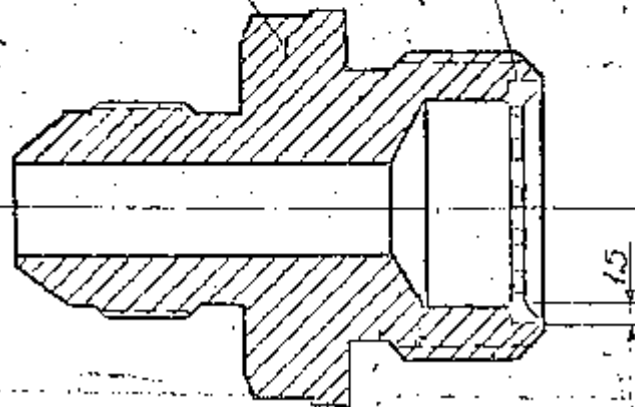
I 1223

| | | | | | |
|-------|------|------|---------|------------------------------|------------------------|
| AUTHD | | | | DRG.NO: 4680A-6 | USED ON |
| APPRD | | | | UNION | ADU2-016 |
| CHKD | | | 13/4/16 | | SCALE: NTS |
| DRAWN | | | | ORDNANCE FACTORY MEDAK | ISSUE |
| 2004 | NAME | SIGN | DATE | | MATERIAL: EN19, Bs:970 |

90-250A

ADY2-071

ADY2-053



SOLDER ALL OVER USING SOLDER

ROC 40

| REF. NO. | DESIGNATION | DESCRIPTION | QTY. | REMARKS |
|----------|-------------|--------------|------|---------|
| 2 | ADY2-053 | FILTER GAUGE | | |
| 1 | ADY2-071 | UNION | 1 | |

MATERIAL: —

ORG. NO. TO BE COPIED: —

SCALE: 1:2.11

DATE: 9-8-95

DR: [Signature]

CD: [Signature]

CHD: [Signature]

APP: [Signature]

ALL THREADS TO BE MADE TO STANDARD

FINISH TO BE AS SPECIFIED

THE DIMENSIONS OF THIS DRAWING ARE TO BE TAKEN FROM THE DIMENSIONS OF THE PART

SYSTEM TO BE USED, PART NO. MANUFACTURERS NAME SYSTEM

NOTE: —

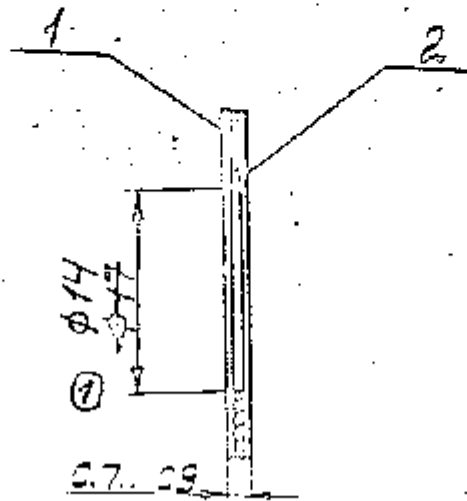
UNION (UNIT)

ADY2-06

CONT. ALL PARTS OF QUALITY ASSURANCE (INVENTORY CONTROL & RELEASE)

48/107

AAZ-09



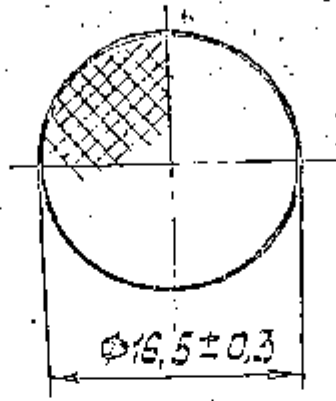
1. THICKNESS OF RUBBER COATING SHOULD BE 0.2 TO 0.3mm ON EACH SIDE. DRESS FLASH OFF RUBBER ALONG CONTOUR OF GASKET.
2. VALCANIZE RUBBER PART-2 TO PART-1. DIFFERENCE IN THICKNESS OF GASKET AT DIFFERENT POINTS SHOULD NOT EXCEED 0.1mm.

| 2 | AAZ-09-1 | FILED, FINDER FOR IDENTIFIED TYP-005 1115-73 | 2 | |
|-----|-------------|--|-----|---------|
| 1 | AAZ-090 | GASKET | 1 | |
| NO. | DESIGNATION | REMARKS | QTY | REMARKS |

| | | | |
|--|------|--|--|
| MATERIAL - AAZ-09 | | GASKET (UNIT) | |
| ALL DIMENSIONS IN MILLIMETERS | | STAMPING ETCH, PART NO. | |
| DRG. NOT TO BE SCALED | | MANUFACTURERS NAME & YEAR | |
| SCALE 1-2:1 | | DATE | |
| DATE 1-9-8-95 | | TOLERANCE OF DIMENSIONS UNLESS OTHERWISE SPECIFIED | |
| DSN <i>Acc</i> | DATE | AAZ-09 | |
| CHK <i>Acc</i> | | | |
| USD <i>Acc</i> | | | |
| APP <i>Acc</i> | | | |
| CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) | | | |
| 49/107 | | | |

AA 42-053

✓



MATERIAL GAUZE LOW BRASS No. 025 GOST 6613-75.

MIL. DIMENSIONS IN INCHES

DRG. NOT TO BE SCALED

SCALE 1-2:1

DATE 1-9-8-95

DRW. SK

TCO. SK

CHD. SK

APP. SK

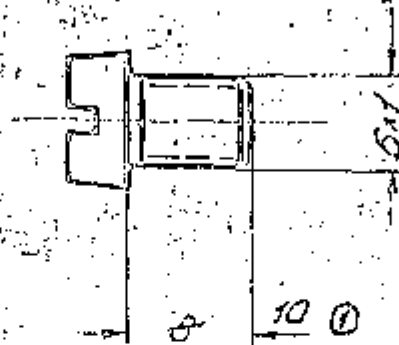
FILTER GAUZE

AA 42-053

CONTROLER

66/107

AA92-062



PAINT HEAD WITH ENAMEL
 RCP 223 OR ENAMEL Hu, 25.

| | |
|---|---|
| MATERIAL: BLANK-SCREW 3157A-G-B MATERIAL: STEEL 10 GOST 5663 Tc 515 | |
| NO SHARP EDGES & CORNERS TO BE PERMITTED | ALL THREADS TO CONFORM TO SPECIFICATION |
| REQ. NOT TO BE COATED | STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFG. |
| SCALE: 2:1 | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED |
| DATE: 9-8-96 | USED ON- |
| DRN. S/S | MT: 60H |
| CD. S/S | SCREW |
| CHD. S/S | AA92-062 |
| APR. S/S | |

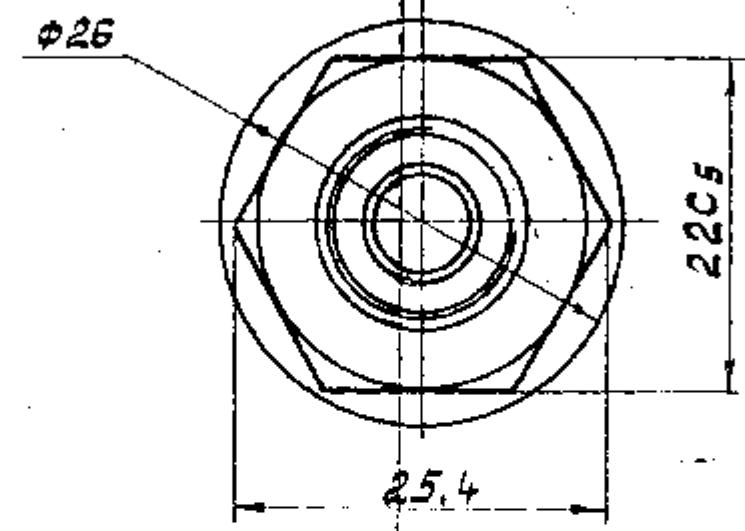
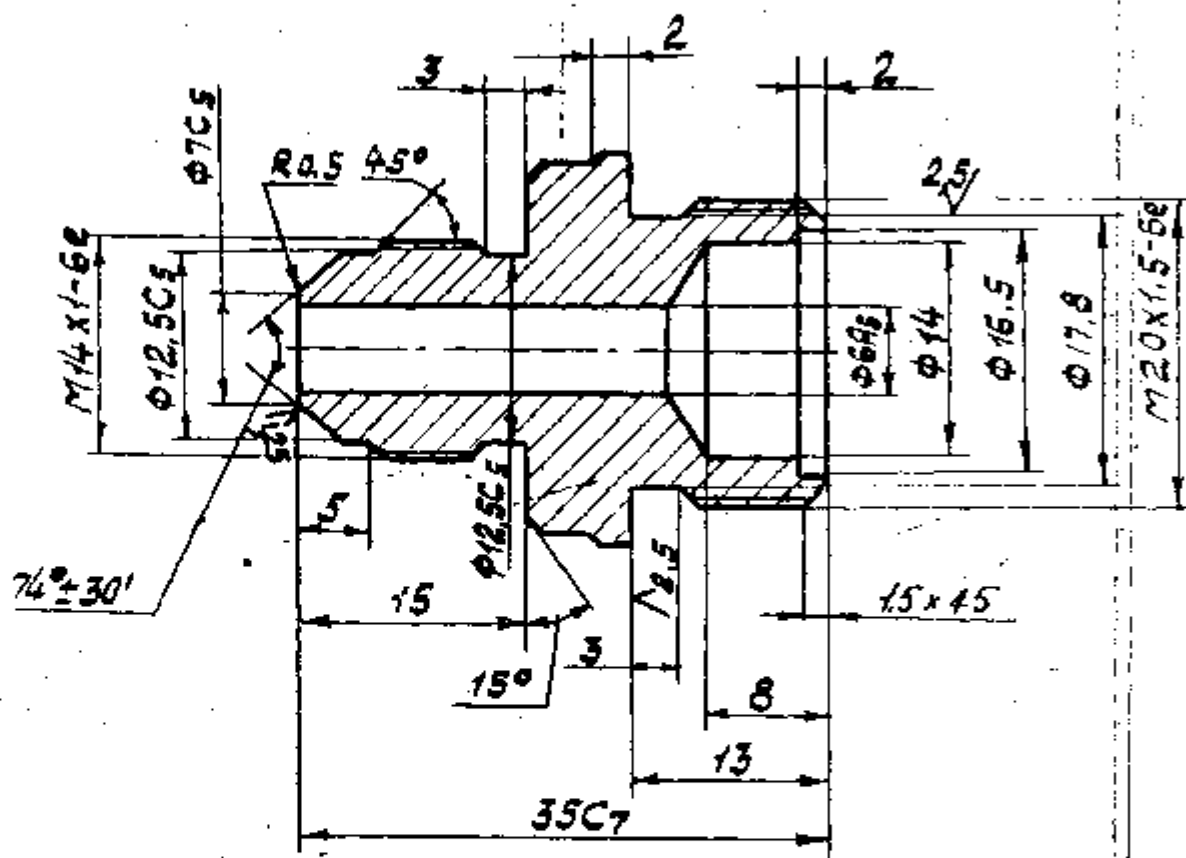
CONTROLLERATE OF QUALITY ASSURANCE
 (INFANTRY COMBAT VEHICLES)

67/107

ADY2-071

R240
 ✓ (V)

UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS PER 22 AT 52 - CLASS 7.



COATING: CADMIUM PLATED 9 TO 15 MICRONS THICK.

1. THREAD MAY BE MADE BY ROLLING.
2. THREAD RUN-OUT CHAMFERS AND RECESSES ARE AS PER OST 100010-71.

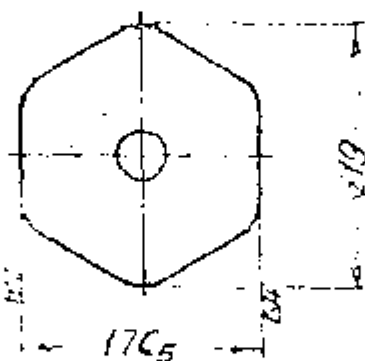
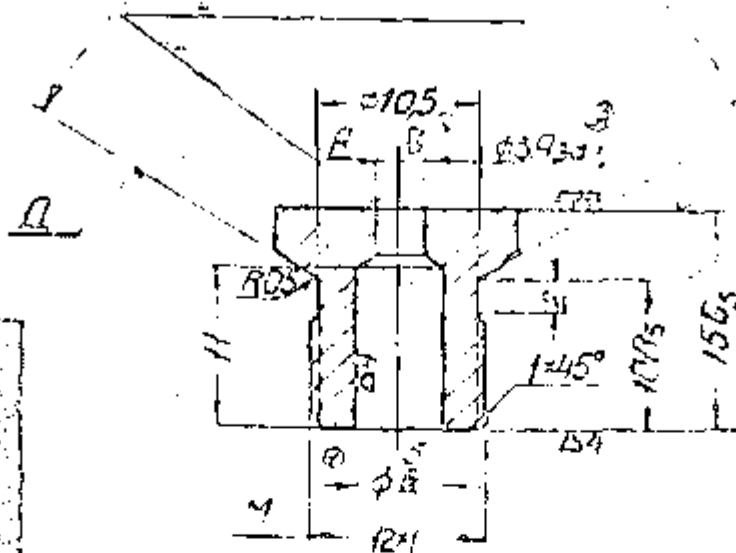
| | | |
|---|--|---|
| MATERIAL: - STEEL A-12 F0CT 1414-75 | | |
| ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF | ALL THREADS TO CONFORM TO SPECIFICATION | STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR. |
| DRG. NOT TO BE SCALED | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | USED ON: 68/107 |
| SCALE: - 2:1 | DATE: - 10-08-1995 | |
| DRN. [Signature] | WT: - (Kg) | |
| TCD | | UNION |
| CHD [Signature] | | ADY2-071 |
| APD [Signature] | | |
| CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) ADY2-056 | | |

AA 42-073

UNLESS OTHERWISE SPECIFIED, TOLERANCES ON FREE DIMENSIONS ARE AS PER 22AT52-CL 7.

120°

DO NO BLUNT EDGE



MACHINE SURFACE A AND B IN UNIT

AA Y3-03.

RUN-OUT OF SURFACE A, WITH RESPECT TO ANGLE

DIAMETER OF THREAD M SHOULD NOT EXCEED 0.05 MM.

PASSIVATE.

| | | |
|---|--|---|
| MATERIAL - BRASS AC59-1-A-T DRAWN BAR GOST 2060-73. | | |
| ALL SHARP EDGES & CORNERS TO BE CHAMFERED | ALL THREADS TO CONFORM TO SPECIFICATION | STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF 1977 |
| DRG. NOT TO BE SEALED | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | USED OR- |
| SCALE - 2:1 | <p>SOCKET</p> <p>AA 42-073</p> | |
| DATE - 10-8-95 | | |
| DRN <i>SJK</i> | WT - (Kg) | |
| TED. <i>SJK</i> | | |
| CHD <i>SJK</i> | | |
| APD <i>SJK</i> | | |

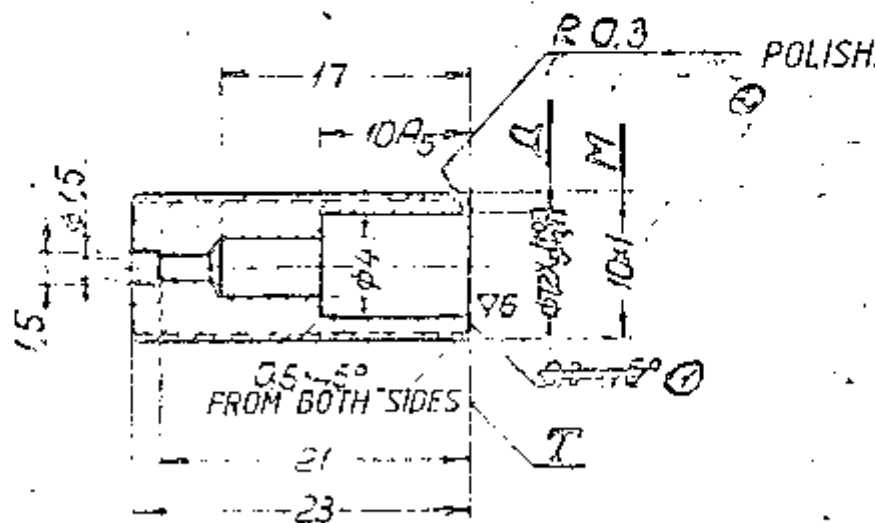
CONTROLLERATE OF QUALITY ASSURANCE

(INFANTRY COMBAT VEHICLES)

69/107

AY2-074

UNLESS OTHERWISE SPECIFIED
TOLERANCE FOR FREE DIMENSIONS
ARE AS PER 22AT52 CLASS 7



HARDNESS HRC = 48 TO 54

RUN-OUT OF ANGLE DIAMETER OF THREAD
M WITH RESPECT TO AXIS OF DIAMETER A,
SHOULD NOT EXCEED 0.1.
END-PLAY OF BUTTEND T WITH RESPECT
TO THE ANGLE DIAMETER OF THREAD M
SHOULD NOT EXCEED 0.05

DRESS BURRS.

PASSIVATE.

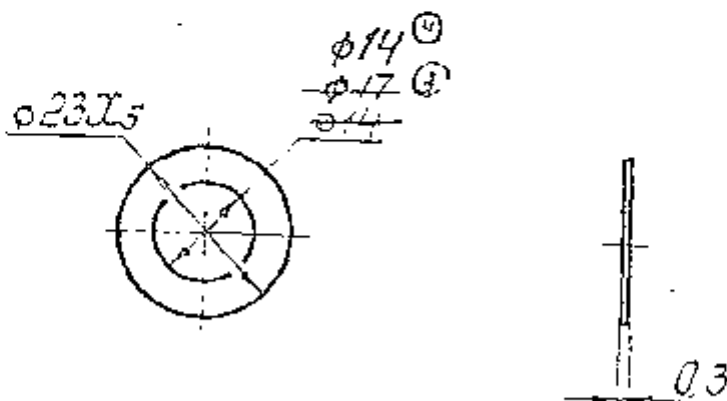
| | | |
|---|--|--|
| MATERIAL :- STEEL 30X13 TECH SPEC. TY 14-1-378-72 | | |
| ALL DIMENSIONS ARE TO BE CONTROLLED | ALL THREADS TO CONFORM TO SPECIFICATION | STAMP OR ETCH PART NO. MANUFACTURERS NAME & YEAR OF MFG. |
| DRG. NOT TO BE RECALC. | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | USED OR NOT |
| SCALE :- 2:1 | | |
| DATE :- 9-8-95 | | |
| DRN. SRE | UT :- (K9) | |
| TD. SRE | | |
| CHD. SRE | | |
| APD. SRE | | |
| | | ADJUSTING SCREW |
| | | AY2-074 |

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

70/107

AYV-090

TOLERANCES ON FREE DIMENSIONS ARE AS PER 22AT52.- CLASS 7.

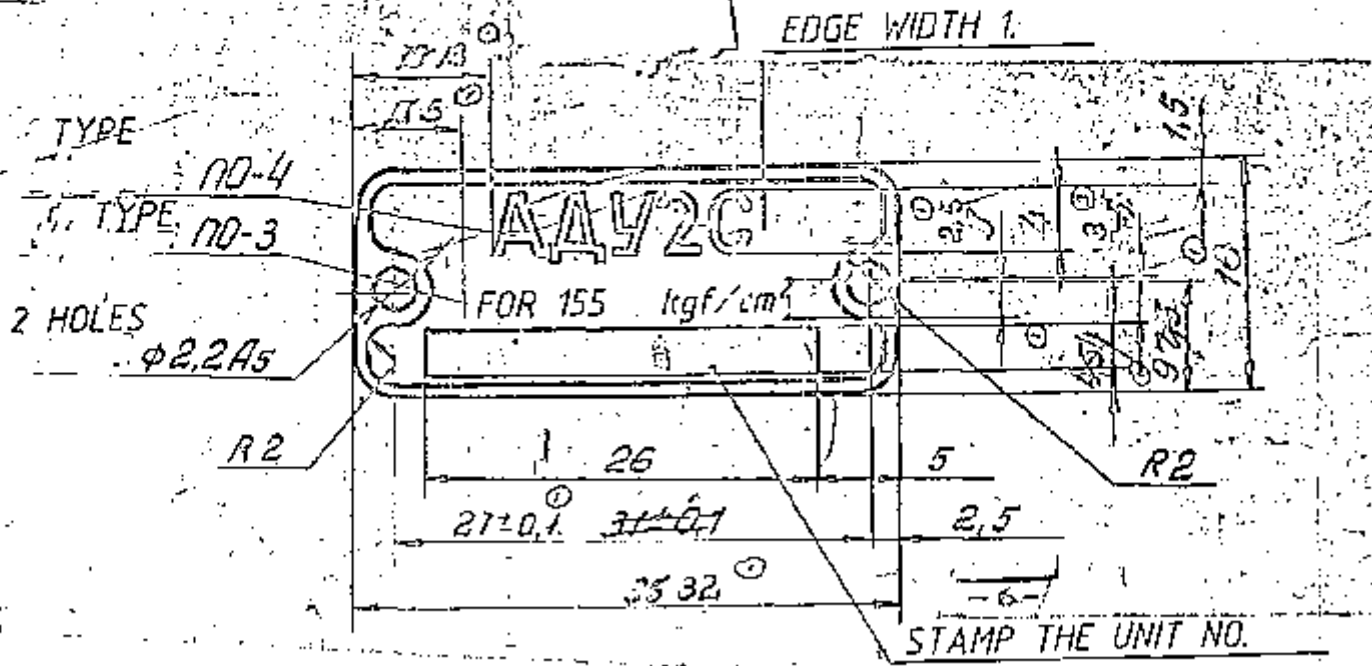


BRASS PLATING.

| | | |
|---|--|---|
| MATERIAL :- BRASS 163-M-n GOST 2208-70 | | |
| ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF | ALL THREADS TO CONFORM TO SPECIFICATION | STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR. |
| DRG. NOT TO BE SCALED | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | USED ON:- |
| SCALE :- 1:1 | | |
| DATE :- 10-8-95 | | |
| DRN. SK | WT :- (KG) | GASKET |
| TCD. SK | | |
| CHD. SK | | AYV2-090 |
| APP. SK | | |
| CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) | | 71/107 |

960-2578

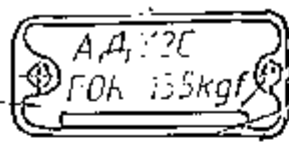
TOLERANCE FOR FREE DIMENSIONS ARE AS PER 22AT52.



TYPE NO-4
 TYPE NO-3
 2 HOLES
 $\phi 2.2A5$

EXTERNAL VIEW.
 SCALE 1:1

BLACK COLOUR.



COLOUR OF ALUMINIUM SHEET.

TYPE OF LETTERS AND FIGURES ARE AS PER GOST 2930-62.

COAT THE LABEL WITH A LAYER OF VARNISH AK-113

| | | |
|--|--|---|
| MATERIAL - ALUMINUM ALLOY ALUM SHEET 0.5 GOST 2163-75 | | |
| ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED | ALL THREADS TO CONFORM TO SPECIFICATION | STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFG. |
| DRG. NOT TO BE SCALED | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | USED ON - 765-78-086 |
| SCALE 1- 2:1 | DATE 1- 10-08-1995 | |
| DRG. <i>Kovalev</i> | WT 1- (kgf) 0.8 | LABEL A442-096 |
| FCO. <i>Kovalev</i> | | |
| CHD <i>KS</i> | | |
| APD <i>KS</i> | | |
| CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) | | 72/107 |

| DESIGNATION | DESCRIPTION | FOR ITEM | MATERIAL AND TECHNICAL SPECIFICATION (TY) | WEIGHT OF ONE PIECE IN GRAMS | INCORPORATED IN (DESIGNATION OF ASSY DRAWING) | REMARKS |
|-------------|--|----------|---|------------------------------|---|-------------------------------------|
| AD42-01B | AUTOMATIC PRESSURE REGULATOR (GENERAL VIEW.) | | | 1200 | | FOR UNIT. AA42 AA42C AA42M |
| AD42-1A | AUTOMATIC PRESSURE REGULATOR (INSTALLATION DRAWING). | | | 1200 | | FOR UNIT. AA42 AA42C |
| AD42M-2A | AUTOMATIC PRESSURE REGULATOR (INSTALLATION DRAWING) | | | 1200 | | FOR UNIT AA42M |
| AD43-03 | BODY (UNIT) | 1 | | 435 | AD42-01B | |
| AD43-05 | REDUCING VALVE (UNIT) | 1 | | 49 | AD42-01B | FOR UNIT AA42C |
| AD43-05-2 | REDUCING VALVE (UNIT) | 1 | | 49 | AD42-01B | FOR UNIT AA42 AA42M |
| AD43-06 | VALVE (UNIT) | 1 | | 12 | AD42-01B | |
| AD43-08 | VALVE (UNIT) | 1 | | 58 | AD42-01B | |
| | | | | | | AD42; AD42M AA42C CN |

AUTOMATIC PRESSURE CONTROL

| DESIGNATION | DESCRIPTION | QUANTITY PER ONE ITEM | MATERIAL AND TY. | WEIGHT OF ONE PIECE IN GRAMS | INCORPORATED IN (DESIGNATION OF ASSY DRAWING) | REMARKS |
|--------------|--------------------------|-----------------------|---------------------------------------|------------------------------|---|----------------------------|
| | | | | | | |
| ADY2-06 | UNION (UNIT). | 1 | | 48 | ADY2-01B | FOR UNIT. ADY2 ADY2C |
| ADY2-07 | UNION (UNIT). | 1 | | 48 | ADY2-01B | FOR UNIT. ADY2M |
| ADY2-09 | GASKET (UNIT). | 1 | | 1 | ADY2-01B | |
| ADY-04A | COVER WITH VALVE (UNIT). | 1 | | 114 | ADY2-01B | |
| <u>PARTS</u> | | | | | | |
| ADY3-002 | BUSH. | 1 | STEEL 95x18 TY 14-1-377-72. | 37 | ADY3-08 | |
| ADY3-003 | VALVE. | 1 | STEEL 17x18H9 TY 14-1-378-72 | 25 | ADY3-05 ADY3-05-2 | |
| ADY3-005 | REDUCING VALVE BODY. | 1 | BRONZE 6x110 -4-4 GOST 1628-72. | | ADY3-05-2 ADY3-05 | |

1
2
3

| DESIGNATION | DESCRIPTION | QTY ONLY ARTICLE | MATERIAL AND TECHNICAL SPECIFICATIONS | WEIGHT OF ONE PIECE IN GRAMS | INCORPORATED IN DESIGNATION OF ASSY DRAWING) | REMARKS |
|-------------|-------------------|------------------|--|------------------------------|--|---------|
| ADY3-007 | VALVE. | 1 | STEEL 17x18H9 TY 14-1-378-72. | 21 | ADY3-08 | |
| ADY3-008 | BODY | 1 | ALUMINIUM ALLOY AKD GOST 21488-76. | 343 | ADY3-03 | |
| ADY3-009 | LOCK. | 1 | STEEL 12x18H10 -M, STEEL-1 GOST 4986-70. | 1 | ADY2-015 | |
| ADY3-010 | NUT. | 1 | BRASS A.C59-1 nT GOST 2060-73. | 7. | ADY2-015 | |
| ADY3-013A | ADJUSTMENT SCREW. | 1 | STEEL 12x13 TY 14-1-378-72. | 15 | ADY2-015 | |
| ADY3-018 | UNION. | 1 | STEEL 38xA TY 14-1-950-74. | 50 | ADY2-015 | ADY2C |
| ADY3-019 | UNION. | 1 | STEEL 12x13 TY 14-1-378-72. | 23 | ADY3-03 | |
| ADY3-020 | GASKET. | 1 | RUBBER MIX 3825 TY38 005 1166-73. | 1 | ADY3-06 | |
| ADY3-021 | VALVE BODY | 1 | BRONZE H10-4-4 GOST 1628-72. | 11 | ADY3-06 | |

4 OF 10

ADY2C CP.
4/107

| DESIGNATION | DESCRIPTION | QTY/UNIT | MATERIAL AND TECHNICAL SPECIFICATIONS (TY) | WEIGHT OF ONE PIECE IN GRAMS. | INCORPORATED IN (DESIGNATION OF ASSY. DRAWING) | REMARKS. |
|----------------------------------|------------------|----------|---|-------------------------------|--|-------------------------------------|
| AQY2-072 | UNION. | 1 | STEEL A12 GOST 1414-54 | 47.4 | AQY2-07 | FOR UNIT AQY2H |
| AQY2-073 | SEAT | 1 | BRASS 2-C59-1 GOST 2060-73. | 14 | AQY3-03 | |
| AQY2-074 | ADJUSTING SCREW. | 1 | STEEL 30x13 TY14-1-378-72 | 7.7 | AQY3-052 AQY3-05 | |
| AQY2-090 | GASKET | 1 | BRASS 163-M GOST 2208-70. | 0.5 | AQY2-09 | |
| AQY2-095 AQY2-096 AQY2-097 | TAG | 1 | ALUMINIUM ALLOY AM4-M SHEET 0.5 GOST21631-76 | 0.8 | AQY2-016 | FOR UNIT AQY2H AQY2C AQY2L |
| AQY-004 | LOCK NUT. | 1 | STEEL 38xA TY14-1-950-74 | 19.7 | AQY2-016 | |
| AQY-007 | WASHER | 2 | STEEL 17x10 H9 TY14-1-378-72 | 2 | AQY2-016 | |
| AQY-008 | SPRING | 1 | BRIGHT POLISHED CARBON TOOL STEEL 24-B-12x10 H9 TY14-130151-74 | 15. | AQY2-016 | |

6/107

| DESIGNATION | DESCRIPTION | QTY/UNIT | MATERIAL AND TECHNICAL SPECIFICATION (TY) | WEIGHT OF ONE PIECE IN GRAMS | INCORPORATED IN (DESIGNATION OF ASSY. DRAWING) | REMARKS |
|-------------|-------------|----------|--|------------------------------|--|---------|
| ADY-019A | NUT | 1 | STEEL 12x13 TY14-1-377-72 | 62 | ADY2-015 | |
| ADY-022 | BUSH | 1 | STEEL 12x13 TY14-1-377-72 | 7 | ADY2-015 | |
| ADY-023 | SPRING | | BRIGHT POLISHED CARBON TOOL STEEL 4-B-12x18 H9 TY14130151-76 | 18.5 | ADY2-015 | |
| ADY-024 | SPRING | 1 | BRIGHT POLIS -HED CARBON TOOL STEEL 4-B-12x18 H9 TY14130151-76 | 49.5 | ADY2-015 | |
| ADY-026 | BUSH | 1 | STEEL 40x13 TY14-1-377-72 | 10 | ADY2-015 | |
| ADY-027 | GASKET | 1+2 | DIAPHRAM SHEET VII TY38005 206/6018-74 | 6.3 | ADY2-015 | |
| ADY-028A | VALVE | 1 | STEEL 15x18 TY14-1-377-72 | 25 | ADY-04A | |
| ADY-029A | NUT | 1 | STEEL 12x13 TY14-1-377-72 | 18 | ADY2-015 | |
| ADY-030A | BUSH | 1 | STEEL 12x13 TY14-1-377-72 | 17 | ADY2-015 | |
| ADY-033 | LOCK PIN | 1 | BRASS 63-7 GOST 2060-73 | | ADY2-015 | |

7/107

| | | |
|-----------------------|--|-----------------|
| ADY2, ADY2H, ADY2C | | СТ |
| SHEETNO. 7 | | TOTAL NO. OF 30 |

| DESIGNATION | DESCRIPTION | QTY | MAT AND PER TECHNICAL SPECIFICATIONS (TY) | Wt of one piece (gms) | INCORPORATED IN (Desn. of assy. drg) | REMARKS |
|----------------------|-----------------|-----|--|-----------------------|--------------------------------------|--------------------------|
| AQY-035-2 | SPRING | 1 | WIRE B-13 MPTY3-632-67 | 3 | ADY3-05-2 | FOR unit AA2 AA211 |
| AQY-035 | SPRING | 1 | bright-polished carbon tool steel 12-8-12X16H9 TY 24180151-70 | 2,7 | ADY3-05 | FOR UNIT ADY2C |
| AQY-037 | GASKET | 1 | PARONITE PTM5T gost 481-71 | 0,1 | ADY2-01B | |
| AQY-040 | UPPER MEMBRANCE | 1 | bronze БРБ 2M-02 gost 1789-70 | 0,7 | ADY2-01B | |
| AQY-041 | LOWER MEMBRANCE | 1 | bronze БРБ 2M-02 gost 1789-70 | 0,7 | ADY2-01B | |
| AQY-057 | CAP | 1 | Alluminium alloy А19 OST 90021-71 | 15 | ADY2-01B | |
| AQY-058A | COVER | 1 | Alluminium alloy А19 OST 90021-71 | 89 | ADY-04A | |
| MU40-017 | PACKING RING | 1 | Rubber mix 3825 TY38005 1166-73 | 0,5 | ADY2-01B | |
| | | | | | | 8 / 107 8 OF 10 |
| ADY2; ADY211; ADY2C. | | | | | | CP |

| DESIGNATION | DESCRIPTION | QTY PER UNIT. | MATERIAL & TECHNICAL SPECIFICATION (TY) | WT. OF ONE PIECE IN GRAMS | INCORPORATED IN DESIGNATION OF ASSY DRG) | REMARKS |
|---------------------------------|---------------|---------------|--|---------------------------|--|---------|
| <u>STANDARDIZED PARTS</u> | | | | | | |
| KO 0,8 GOST 792-67 L=1600 | LOCKING WIRE | 1 | WIRE KO 0,8 GOST 792-67 | 1,11 | AAY2-016 | |
| 6 65 F 05 GOST 6402-70 | SPRING WASHER | 4 | STEEL 65F GOST 11850-72 | 0,487 | AAY2-016 | |
| 12HK6X1 | PLUG | 1 | STEEL 45 TY 14-1-151- -72 | 4,5 | AAY2-016 | |
| 2262A-176-2 | PACKING RING | 1 | RUBBER MIX WPN-1078 TY 38 005 1166-73 | 0,17 | AAY2-016 | |
| 2186A-9-2 | PACKING RING | 3 | RUBBER MIX B-14-1 TY 38 005 1166-73 | 0,145 | AAY2-016 | |
| 33M51-14-10,2- -1 | WASHER | 1 | ALU. ALLY... AAM GOST 12572-67 | 0,528 | AAY3-03 | |

9/107

9 OF 10

| | | | |
|----------|---------|-------|----------|
| APPROVED | Checked | Drawn | Date |
| | | | 12.12.83 |
| TRACKED | Checked | Drawn | Date |
| | | | 12.12.83 |

ORDNANCE FACTORY
PROJECT
HYDERABAD

AAY2: AAY2C
AAY2 H

.Cn

| DESIGNATION | DESCRIPTION | QTY | MATERIAL AND TECHNICAL SPECIFICATIONS | WT. OF ONE PIECE IN gms | INCORPORATED IN DESIGNATION OF ASSY. DRAWING | REMARKS |
|--------------------|--------------|-----|---------------------------------------|-------------------------|--|---------------------------|
| 33M51-26-20,2-1,5 | WASHER | 2 | ALUMINIUM A.Д.1M, GOST 12592-67 | 0.8 | A.Д.У2-01b | |
| 33M51 - 26-20,2-2 | WASHER | 1 | ALUMINIUM A.Д.1M, GOST 12592-67 | 1 | A.Д.У2-01b | IF REQD. |
| 4680A-6 | UNION | 1 | STEEL 12X18H9T, TY141-378-72 | 11,2 | A.Д.У2-01b | FOR UNIT A.Д.У 2 A.Д.У 2C |
| HBT226-14X1 | SHIPMENT CAP | 3 | TY6-05-1572-72 GOST 15151-69 | 5 | A.Д.У2-01b | PURCHASED |
| K 1114 | NUT | 1 | BRASS ЖС9-1 Г GOST 2060-73 | 9 | A.Д.У3-05 A.Д.У3-05-2 | |
| K 3515 | SCREW | 4 | STEEL 38XA TY14-1-950-74 | 6,8 | A.Д.У2-01b | |
| H 4001 | SCREW RIVET | 2 | STEEL 20 GOST 1051-73 | 0,2 | A.Д.У2-01b | |
| K 7213 | WASHER | 4 | STEEL 20 GOST 16523-70 | 0,19 | A.Д.У2-01b | |
| K 7309 | WASHER | 1 | ALUMINIUM A.Д.1M GOST 12592-67 | 0,3 | A.Д.У2-01b | |
| SEAL OST1 10067-71 | SEAL | 3 | ROUND PIPE 6x0,75 A.Д.М GOST 18475-73 | 1 | A.Д.У2-01b | |
| | | | | | | CP |
| SUM TOTAL QTY'S 10 | | | | | | |

A.Д.У2; A.Д.У2И; A.Д.У2С. CP

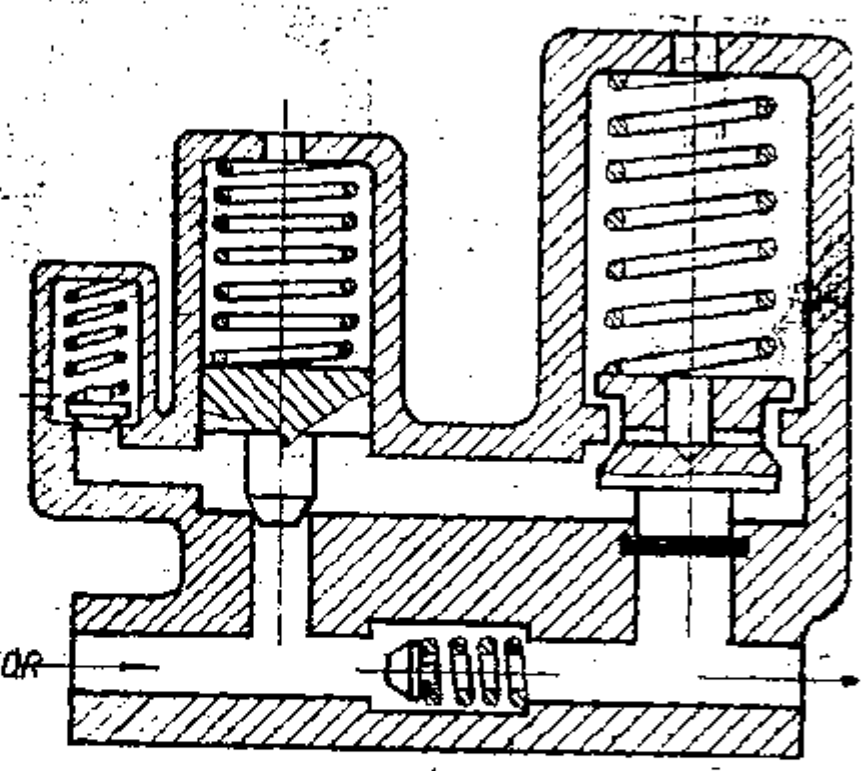
10/107

| | | | |
|-------|----------------|----|---------|
| DRN. | P. R. B. B. S. | 22 | 28 1283 |
| CHKD. | | | |
| APD. | | | |

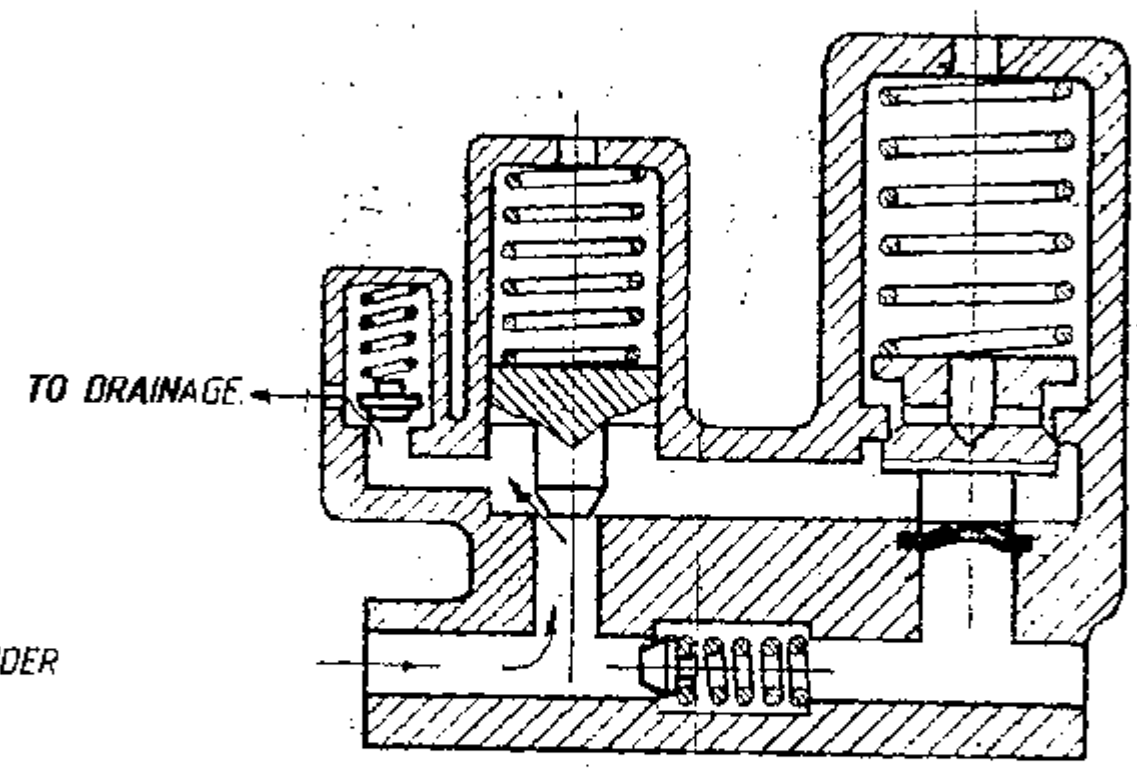
OPERATION DIAGRAM OF UNIT
 AUTOMATIC PRESSURE REGULATOR AAY2

| | |
|----------------|------------------|
| AAY2 | CX |
| AAY2 | CTY |
| APPENDIX NO. 1 | |
| SHEET. 1 | NO. OF SHEETS. 1 |

ARRANGEMENT OF REGULATOR VALVES WHEN COMPRESSOR WORKS, TO FILL CYLINDER IN FULL.



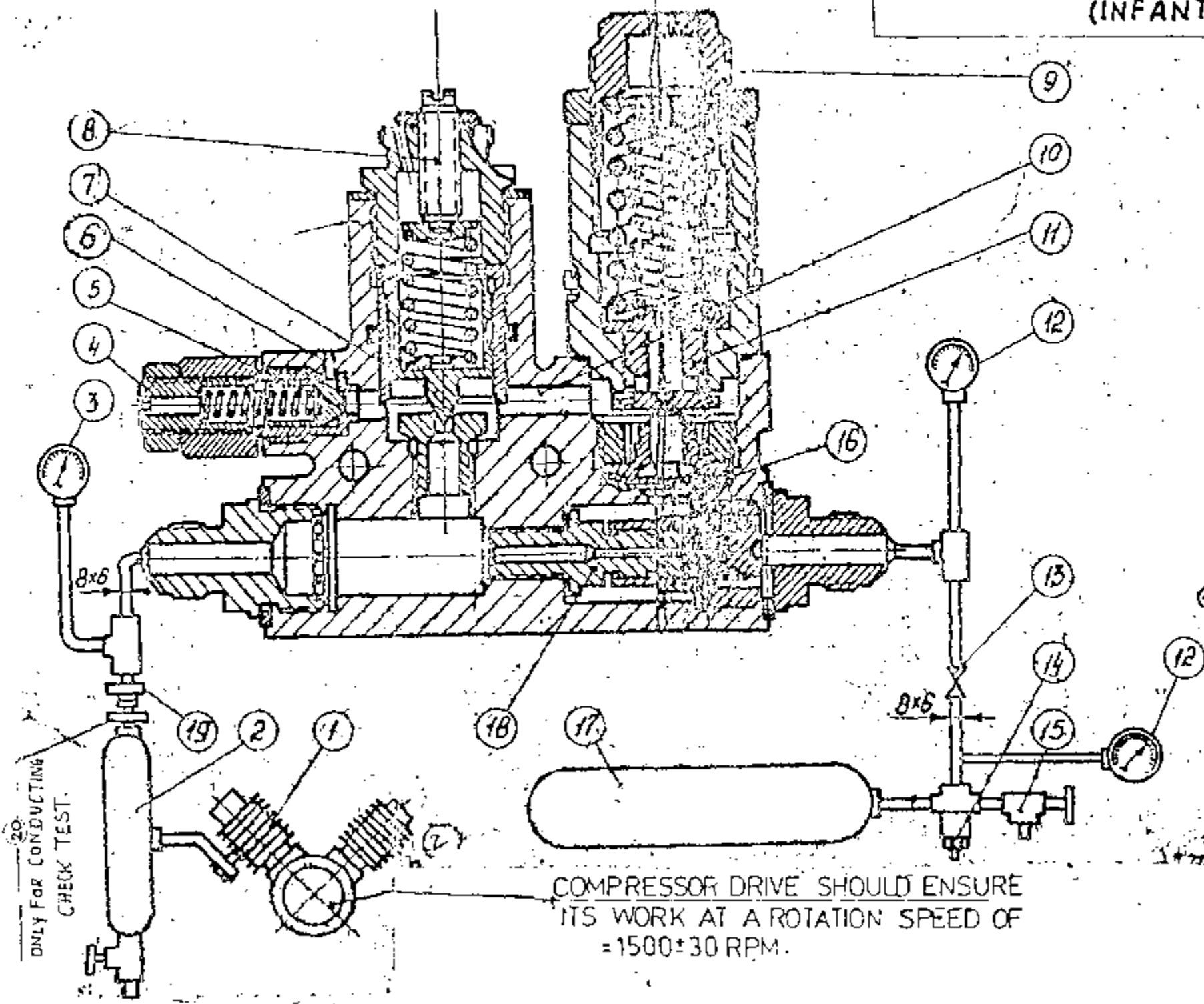
ARRANGEMENT OF REGULATOR VALVES, WHEN COMPRESSOR RUNS IDLE.



| | | |
|--|--|---|
| MATERIAL | | |
| ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF | ALL THREADS TO CONFORM TO SPECIFICATION | STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR. |
| ORG. NOT TO BE SCALED | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | USED DR:- 765-78-086 |
| SCALE :- | DATE :- 10.8.95 | |
| DRN. <i>Q. S.</i> | WT :- (Kg) | AUTOMATIC PRESSURE REGULATOR AAY2 |
| TCO. <i>Q. S.</i> | | AAY2 CTY AAY2 CX |
| CHD. <i>Q. S.</i> | | |
| APD. <i>Q. S.</i> | | |
| CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) | | |
| | | 18/107 |

| | | | | | | |
|---------|-------|--------|------|----------|--|------------------------|
| SNO | Sheet | DOC NO | SIGN | DATE | AUTOMATIC PRESSURE REGULATOR ADY2 | ADY2 CX ADY2 CTY |
| DRAWN | KNRAO | | | 10/11/75 | | |
| CHECKED | | | | | | |
| TCD | | | | | | |
| APPVD | AG | | | | | APPENDIX 3 |
| | | NAME | SIGN | DATE | | SHEET 1 TOTAL SHEETS |

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)



| | | |
|------|---|---------|
| 21 | | |
| 20 | SILICA GEL FILTER | |
| 19 | AIR FILTER UNIT 442 | |
| 18 | NON RETURN VALVE | |
| 17 | 8 Lt. Cylinder for working pressure of 150 kg/cm ² | |
| 16 | DIAPHRAGM | |
| 15 | DRAIN LOCK | |
| 14 | Pressure reducing valve for a working pr. of 165 kg/cm ² | |
| 13 | SHUT OFF COCK | |
| 12 | Pressure gauge for working pressure of 250 kg/cm ² | |
| 11 | CUT-IN VALVE | |
| 10 | AIR RELEASE CHANNEL | |
| 9 | CUT-IN VALVE NUT | |
| 8 | CUT-OUT VALVE SCREW | |
| 7 | CUT-OUT VALVE | |
| 6 | OUTLET | |
| 5 | Regulator, pressure reducing valve | |
| 4 | ADJUSTING SCREW | |
| 3 | Pressure gauge for working pressure 250 kg/cm ² | |
| 2 | OIL SUMP FILTER | |
| 1 | COMPRESSOR AK150 | |
| RANK | DESCRIPTION | Remarks |

TEST SET FOR CHECKING AUTOMATIC PRESSURE REGULATOR

Arrange Units Ref. No. 1, 2, 17, 19 And 20 In a Special Box Or a Metal Chamber, Which Provides Safety To The Maintenance Personnel. Protect Dial Faces Of Pressure Gauges Ref 3 And 12 With Organic Glass. Air Supply Line And Fittings Should Be Calculated To a Pressure Of 200 Kg/cm².

| LINE NO. | | | APPLICATION | QUANTITY IN ITEM PIECE | QUANTITY IN SET PIECE | REMARKS |
|----------|-----------|------------|-------------------------|------------------------|-----------------------|---------|
| 1 | ADY- 04A | 7575136059 | COVER WITH VALVE (UNIT) | 1 | 1 | |
| 2 | | | | | | |
| 3 | ADY2- 04 | 775136055 | VALVE(UNIT) | 1 | 2 | |
| 4 | ADY2- 09 | 7575136002 | GASKET (UNIT) | 1 | 10 | |
| 5 | | | | | | |
| 6 | ADY3- 08 | 7575136006 | VALVE (UNIT) | 1 | 1 | |
| 7 | ADY3- 009 | 7575136012 | LOCK | 1 | 10 | |
| 8 | | | | | | |
| 9 | ADY3- 020 | 7575136017 | GASKET | 1 | 10 | |
| 10 | ADY3- 021 | 7575136018 | VALVE BODY | 1 | 1 | |
| 11 | | | | | | |
| 12 | ADY3- 030 | 7575136022 | UNION | 1 | 1 | |
| 13 | | | | | | |
| 14 | ADY2-046A | 7575136057 | BUSH | 1 | 1 | |
| 15 | ADY2- 050 | 7575136024 | SPRING | 1 | 1 | |
| 16 | ADY2- 051 | 7575136058 | NUT | 1 | 2 | |
| 17 | | | | | | |
| 18 | ADY2- 071 | 7575136027 | UNION | 1 | 1 | |
| 19 | | | | | | |
| 20 | ADY- 009 | 7575136035 | SPRING | 1 | 1 | |
| 21 | | | | | | |
| 22 | ADY- 023 | 7575136038 | SPRING | 1 | 1 | |
| 23 | ADY- 024 | 7575136039 | SPRING | 1 | 1 | |

ADY2 B4

| | |
|----------------|--------------|
| SHEET NO | TOTAL SHEETS |
| 1 | 2 |
| APPENDIX NO 10 | |

| LINE NO. | DESIGNATION | CODE OR PI | DESCRIPTION OF SPARE PART | APPLICATION | QUANTITY IN ITEM, PIECE. | QUANTITY IN SET, PIECE. | REMARKS |
|----------|-------------------|-------------|---------------------------|--------------|--------------------------|-------------------------|-----------------|
| 24 | AAV-027 | 7575136041 | GASKET | | 1 | 20 | 10 THICK - 0.7 |
| 25 | | | | | | | 10 THICK - 0.35 |
| 26 | AAV-035-2 | 7575136046 | SPRING | AAV2 AAV2 | 1 | 10 | |
| 27 | AAV-035 | 7575136047 | SPRING | AAV2C | 1 | 5 | |
| 28 | AAV-037 | 7575136048 | GASKET | | 1 | 10 | |
| 29 | AAV-040 | 7575136049 | UPPER DIAPHRAGM | | 1 | 10 | |
| 30 | AAV-041 | 7575136050 | LOWER DIAPHRAGM | | 1 | 10 | |
| 31 | | | | | | | |
| 32 | HUJ 40-017 | 7575136044 | PACKING RING | | 1 | 12 | |
| 33 | | | | | | | |
| 34 | 468A-094 | 7575505010 | LOCK | | 1 | 10 | |
| 35 | | | | | | | |
| 36 | 33M51-26-20,2-1,5 | 75042361039 | PACKING RING | | 2 | 20 | |
| 37 | | | | | | | |
| 38 | 2262A-176-2 | 7584199176 | PACKING RING | | 1 | 12 | |

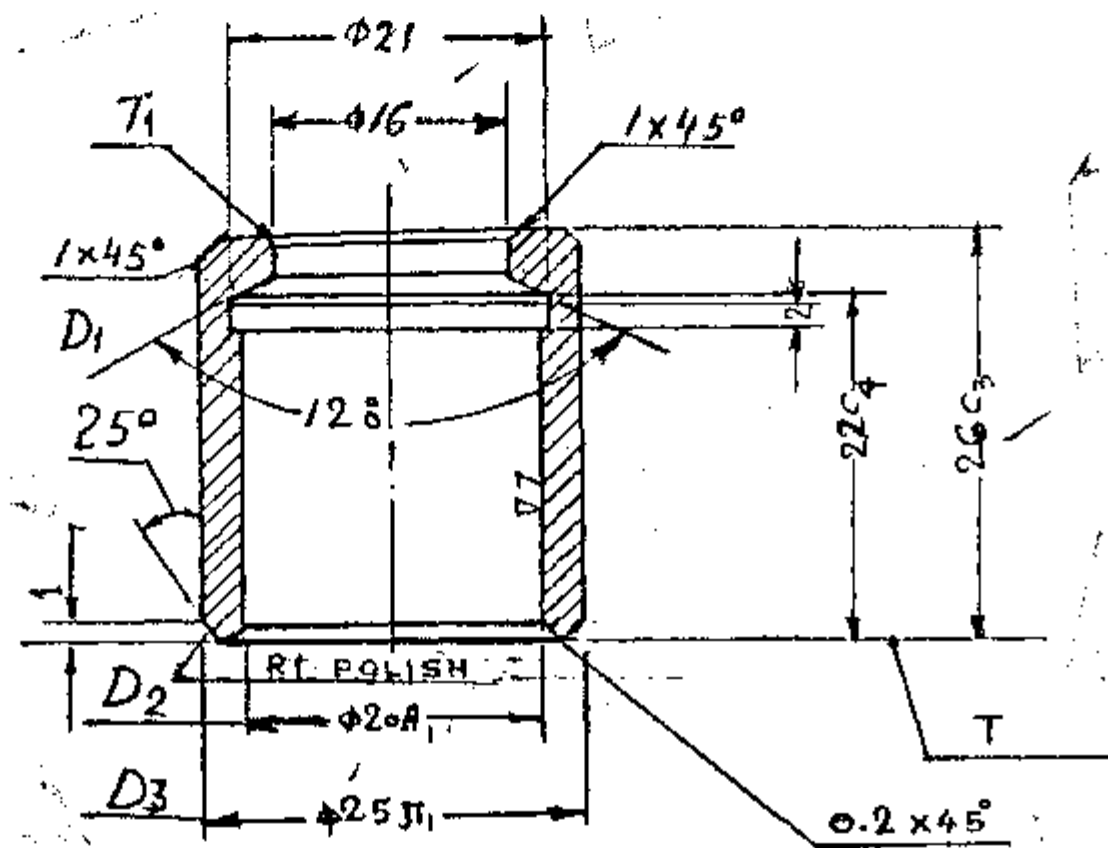
NOTE:- REPAIR SET SHOULD BE PRESERVED AND PACKED WITH A STORAGE LIFE AT NORMAL CONDITIONS - 3 YEARS, AND FOR THE RESERVE - 6 YEARS.

Appendix 10
248

| ISSUE DATE | ISSUE | NATURE OF AMENDMENTS | ECN NO | ISSUE DATE | ISSUE | NATURE OF AMENDMENTS |
|------------|------------|----------------------|--------|------------|-------|----------------------|
| DRN | <i>Am</i> | | | | | DATE: 10.8.95 |
| TCD | <i>Am</i> | | | | | USED OF 765-78-086 |
| CHD | <i>Am</i> | | | | | SHEET 2 OF 2 |
| APPD | <i>Set</i> | | | | | 34 of 107 |

AAV 2B4

AA43-002



TECHNICAL CONDITIONS - INDIANISED

1. BUSHING SHALL BE MACHINED FROM STAINLESS STEEL, MS C-18 M₂₅₀ TO IS: 1570-72 (PT. V).
2. BUSHING SHALL BE THROUGH HARDENED AND TEMPERED TO 55-60 HRC AND SHALL BE SUBJECTED TO SUB ZERO TREATMENT TO STABILIZE THE DIMENSIONS.
3. RUN OUT OF CYLINDRICAL SURFACES D₂ (Ø 20A₁) AND D₃ (Ø 25A₁) SHOULD NOT EXCEED 0.02 mm.
4. RUN OUT OF SURFACES D₁ AND D₂ SHOULD NOT EXCEED 0.01 mm.
5. SURFACE D₁ SHALL BE CHECKED WITH PRUSSIAN BLUE, TO ENSURE CLOSE AND REGULAR FIT.
6. NON-SQUARENESS OF SURFACE T₁ AND T WITH RESPECT TO CYLINDRICAL SURFACE D₃ SHOULD NOT EXCEED 0.02 mm.
7. UNSPECIFIED TOLERANCES ON DIMENSIONS ARE AS PER ORIGINAL SPECIFICATION 22 AT 52. VALUES OF OTHER TOLERANCES ARE AS UNDER :-

| | |
|-------------------------|--|
| 7.1 Ø 25 A ₁ | Ø 25 ^{+0.005} _{-0.003} |
| 7.2 Ø 20 A ₁ | Ø 20 ^{+0.013} _{-0.010} |
| 7.3 22 C ₄ | 22 ^{+0.140} _{-0.140} |
| 7.4 26 C ₃ | 26 ^{+0.045} _{-0.045} |

100% CHECK AS PER MICROMETER SURVEILLANCE TABLE PROVIDED WITH ASSEMBLY.

- VALUE OF SURFACE ROUGHNESS SHALL BE AS UNDER:-
- | | |
|--------|------------------------------------|
| 2.1 V4 | Rz 40, UNLESS OTHERWISE SPECIFIED. |
| 2.2 V7 | 1.25 Min. |

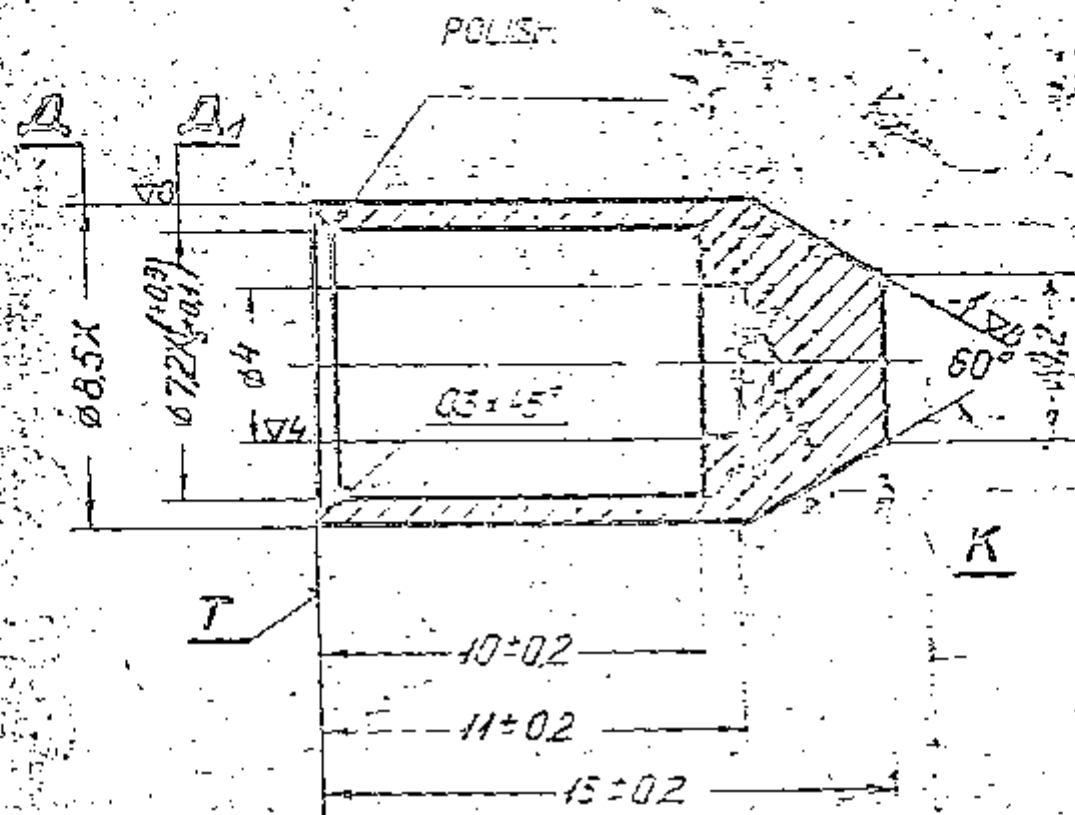
| | | | |
|--|--|---|------------|
| STEEL 95X18TY 14.1.377-72 | | ISSUE | AMENDMENTS |
| ORIG. MATERIAL | DATE | ISSUE | AMENDMENTS |
| ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF. DRG. NOT TO BE SCALED | ALL THREADS TO CONFORM TO SPECIFICATION. | STAMP OR ETCH, PART NO., MANUFACTURER'S NAME & YEAR OF MFG. | |
| SCALE:- 2:1 | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | USED ON:- | |
| DATE :- 08-2-91 | | | |
| DRN. [Signature] | WT :- (KG) | <p>BUSHING</p> <p>AA43-002</p> <p>CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)</p> | |
| TC [Signature] | | | |
| CHD [Signature] | | | |
| APD [Signature] | | | |

ALL DIMENSIONS IN mm

51/107

000-8707

UNLESS SPECIFIED OTHERWISE
TOLERANCE ON FREE DIMENSIONS
ARE AS PER 22AT5Z.



RUN-OUT OF SURFACE K WITH RESPECT TO SURFACE A SHOULD NOT EXCEED 0.01 MM.

RUN-OUT OF SURFACE T WITH RESPECT TO SURFACE A SHOULD NOT EXCEED 0.1 MM.

RUN-OUT OF SURFACE A, WITH RESPECT TO SURFACE A SHOULD NOT EXCEED 0.1 MM.

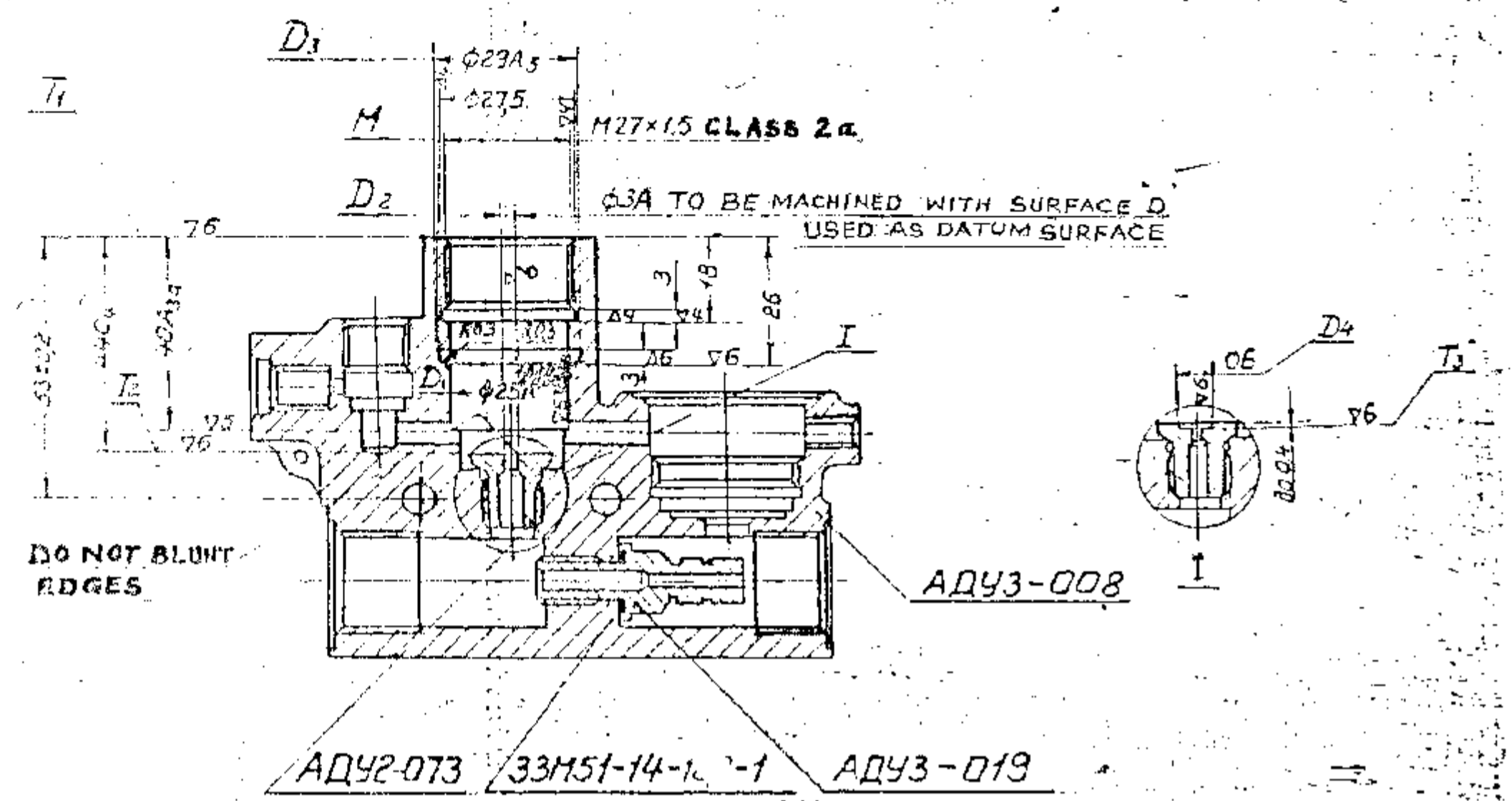
LAP SURFACE K TOGETHER WITH PART A.S. 12-055.

ELECTROPOLISH ALL OVER EXCEPT SURFACE K AND A.

| | | |
|---|--|--|
| MATERIAL - STEEL 17X18H9 TY 14-1-378-72 | | |
| ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED | ALL THREADS TO CONFORM TO SPECIFICATION | STAMP OR ETCH PART NO. MANUFACTURERS NAME & YEAR OF MFG. |
| DRG. NOT TO BE SCALED | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | USED ON - 765-78-c86 |
| SCALE - 5:1 | | |
| DATE - 10.8.95 | | |
| DRG. <i>Dr</i> | UT - (Rg) | |
| YCD. <i>Dr</i> | | |
| CRD. <i>Dr</i> | | |
| APD. <i>Dr</i> | | |
| | | |
| | | VALVE |
| | | ADY3-003 |

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES) 52/107

TECHNICAL CONDITIONS



1. QUALITY OF HOLE 'D₂' SHALL NOT EXCEED 0.01mm.
2. SURFACES MARKED D₁, T₁, T₂ & THREAD 'M' SHALL BE MACHINED AT ONE SET UP ONLY.
3. ECCENTRICITY OF HOLES MARKED 'D₁' & 'T₂' SHALL NOT EXCEED 0.1mm.
4. ECCENTRICITY OF HOLES MARKED 'D₂' & 'D₃' SHALL NOT EXCEED 0.03mm.
5. PARTS ADY2-073 AND ADY3-019 SHALL BE SECURED WITH LEAD LITHARGE.
6. HOLE 'D₂' MAY BE INCREASED UP TO 3.15A, PROVIDED THE ECCENTRICITY OF HOLES 'D₁' & 'D₂' DOES NOT EXCEED 0.01mm.
7. SURFACES 'D₄' & 'T₃' MAY BE SPOT FACED AS SHOWN IN SECTION 'I' WITH REFERENCE TO THE SURFACE 'D₁'.
8. BODY SHALL BE CHECKED FOR AIR TIGHTNESS AT A PRESSURE 130 atm.(Mpa) FOR 2 MINUTES. NO AIR LEAKAGE SHALL BE PERMITTED.

NOTE:-

1. ALL DIMENSIONS ARE IN MILLIMETRES.
 2. VALUE OF SURFACE ROUGHNESS AND TOLERANCES ON DIMENSION SHALL BE AS GIVEN BELOW:-
- | | | |
|-------------|--------|----------|
| V4 = Rz 40 | 44 CA | = -0.170 |
| V5 = Rz 20 | 40 A3a | = +0.100 |
| V6 = Ra 3.5 | 29 A5 | = +0.280 |
| | φ3A | = +0.010 |

| REF NO | DESIGNATION | DESCRIPTION | QTY | REMARKS |
|--------|-------------|-------------|-----|---------|
| 3 | ADY2-073 | BODY | 1 | |
| 2 | ADY3-019 | UNION | 1 | |
| 1 | ADY3-008 | SEAT | 1 | |
| REF NO | | WASHER | | |

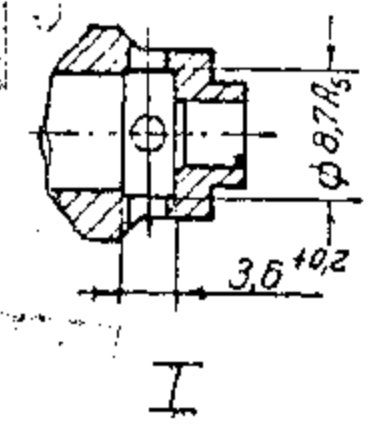
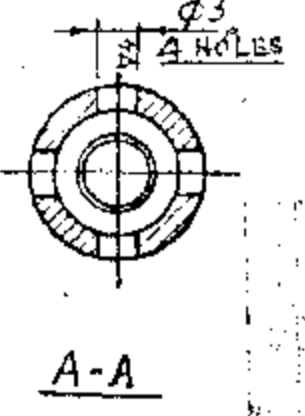
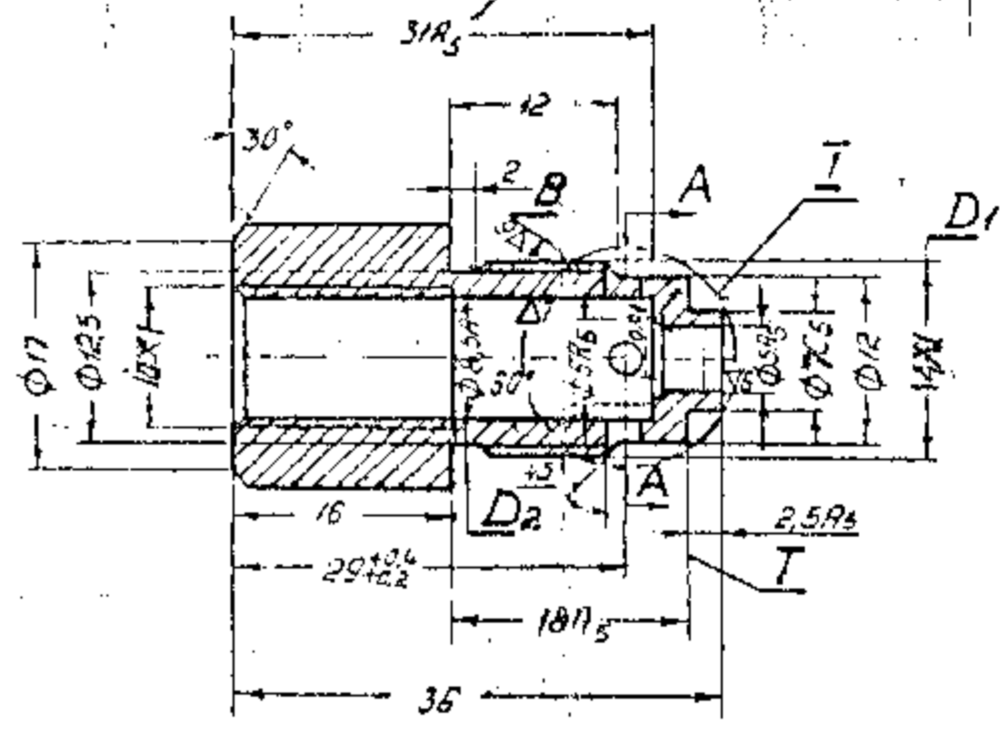
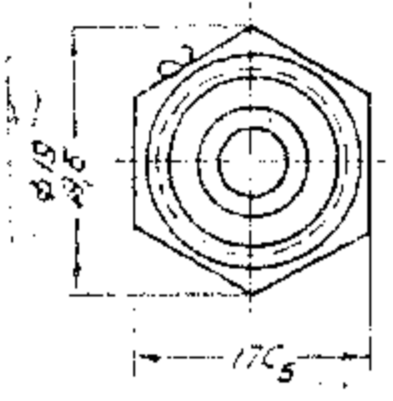
| | | | |
|--|--|--|------------|
| ORGL MATERIAL | | ISSUE | AMENDMENTS |
| ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF. | | ALL THREADS TO CONFORM TO SPECIFICATION. | |
| DRG. NOT TO BE SCALED | | STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR. | |
| SCALE:- 1:1 | | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | |
| DATE :- 1-03-91 | | USED ON:- | |
| DRN. [Signature] WT:-(Kg) | | BODY(UNIT) | |
| TCD. [Signature] 435 | | | |
| APD. [Signature] | | ADY3-03 | |
| CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) | | | |

AA3-005

TECHNICAL CONDITIONS

- BODY SHALL BE MACHINED FROM ALUMINIUM BRONZE BAR HAVING CHEMICAL COMPOSITION AS GRADE 1 TO IS: 305-61.
- UNSPECIFIED TOLERANCES ON MACHINED DIMENSIONS SHALL BE AS PER IS: 919-63 AS GIVEN BELOW:-
 HOLES ----- H 14
 SHAFTS ----- h 14
 LINEAR DIMENSIONS -- Js 14
- VALUES OF TOLERANCES AND SURFACE ROUGHNESS SPECIFIED ARE GIVEN BELOW:-

| | | | |
|---------|-----|-------------|------------------------------|
| 5 A 5 | 5 | ± 0.160 | $\nabla 4 \rightarrow Rz 40$ |
| 6 A 5 | 6 | ± 0.160 | $\nabla 5 \rightarrow Rz 20$ |
| 7 C 5 | 7 | -0.200 | $\nabla 6 \rightarrow 2.5$ |
| 8.5 A | 8.5 | ± 0.016 | $\nabla 7 \rightarrow 1.25$ |
| 8.7 A 5 | 8.7 | ± 0.200 | |
| 17 C 5 | 17 | -0.020 | |
| 18 A 5 | 18 | ± 0.240 | |
| 31 A 5 | 31 | ± 0.340 | |
- RUN OUT OF SURFACE 'B' WITH RESPECT TO SURFACE 'D₂' SHALL NOT EXCEED 0.01 mm.
- SURFACE 'B' SHALL BE LAPPED WITH MATTING PART AA43-003.
- NON-SQUARENESS OF SURFACE 'T' WITH RESPECT TO D₁ (DIAMETER OF THREAD) SHALL NOT EXCEED 0.1 mm.
- GROOVE $\phi 8.7 A 5 \times 3.5$ mm SHALL BE PROVIDED AS SHOWN IN VIEW 'I'.
- THREAD SHALL CONFORM TO ORIGINAL SPECIFICATION 299 AT.



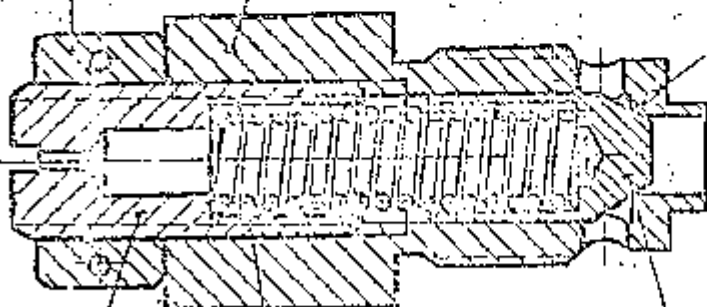
| | | | | |
|----------------------------------|--|--|--|--|
| BRONZE SPAXH10 - 4 AGOST 1628-72 | | DCIUN A DATE | ISSUE | AMENDMENTS |
| ORGL MATERIAL | ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF. | ALL THREADS TO CONFORM TO SPECIFICATION. | | STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR. |
| DWG. NOT TO BE SCALED | SCALE:- 2:1 | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | | USED ON:- |
| DATE :- 28.2.71 | DRN. [Signature] | WT :- (Kg) | BODY OF REDUCING VALVE | |
| | TCD [Signature] | 29 | AA3-005 | |
| | APP. [Signature] | | CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) | |

ALL DIMENSIONS IN mm

K1114

A Y3-005

LAP JOINTLY



A Y2-074

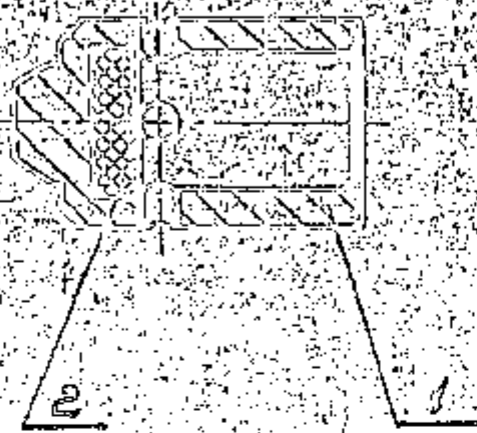
A Y-035

A Y3-003

| REF. NO | DESIGNATION | DESCRIPTION | QTY | REMARKS |
|---------|-------------|------------------------|-----|---------|
| 1 | AAY3-003 | VALVE | 1 | |
| 2 | AAY3-005 | BODY OF REDUCING VALVE | 1 | |
| 3 | AAY2-074 | ADJUSTING SCREW | 1 | |
| 4 | AAY-035 | SPRING | 1 | |
| 5 | K1114 | NUT | 1 | |

| | | | |
|---|---|---|--|
| MATERIAL | | STAMP OR ETCH, DATE '96, MANUFACTURER'S MARK & YEAR | |
| ALL SURFACES TO CONFORM TO SPECIFICATION | ALL THREADS TO CONFORM TO SPECIFICATION | 765-78-256 | |
| DRG. NOT TO BE SCALD | SCALE 1- | TOLERANCE OF DIMENSIONS UNLESS OTHERWISE SPECIFIED | |
| DATE 1-10-08-1995 | DATE 1-10-08-1995 | 765-78-256 | |
| DRN <i>Wald</i> | VT 1- (K9) | REDUCING VALVE (UNIT) | |
| FCN <i>Wald</i> | | | |
| END <i>Wald</i> | | AAY3-05 | |
| APD <i>Wald</i> | | | |
| CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) | | 45/107 | |

90-6674



GLUE GASKET 2 TO PART 1 BY ADHESIVE
 KP5-18 (TY 105 107876)

| REF ID | DESIGNATION | DESCRIPTION | QTY | REMARKS |
|--------|-------------|-------------|-----|---------|
| ✓ 1 | AAY3-020 | GASKET | 1 | |
| ✓ 2 | AAY3-021 | VALVE BODY | 1 | |

MATERIAL: _____
 QUANTITY: _____
 DATE: 9-8-95
 BY: *Spec*
Spec
7/8
vc

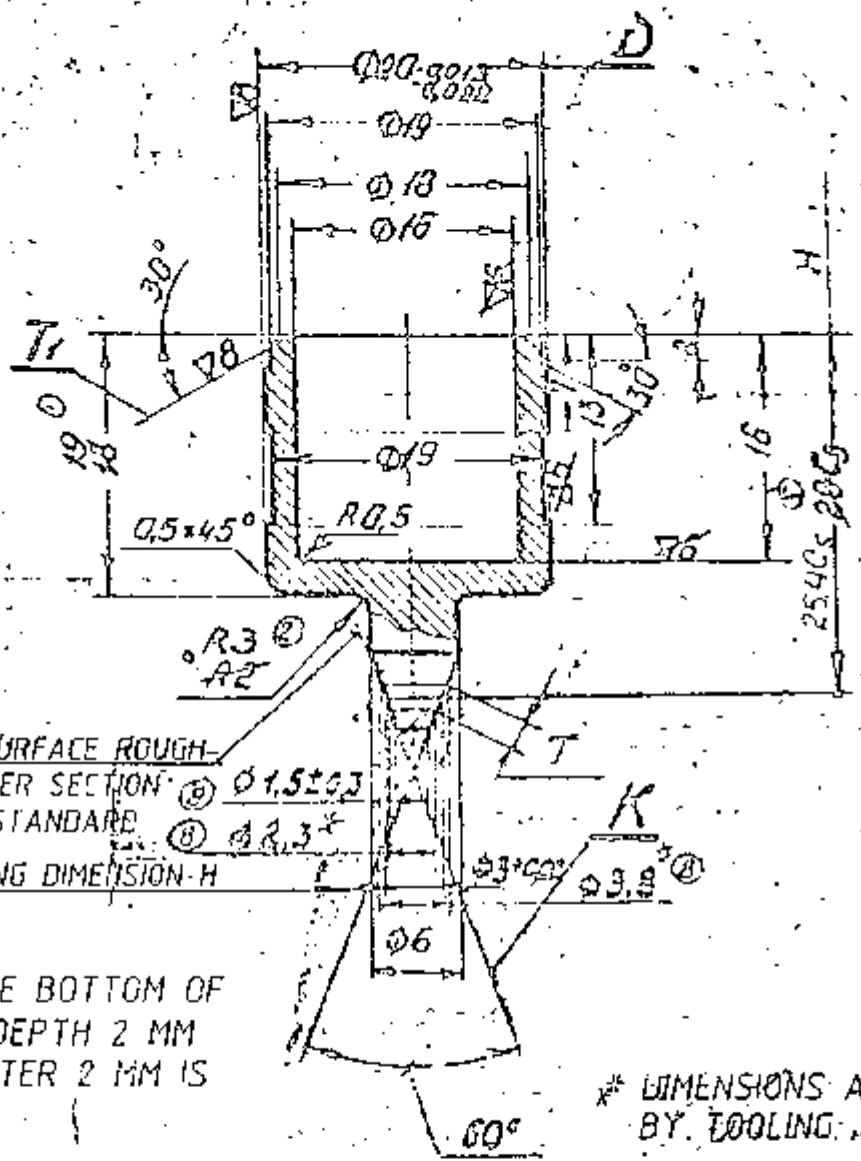
VALVE (UNIT)
 AAY3-06

46/107

ADY3-007

UNLESS OTHERWISE SPECIFIED

TOLERANCE ON FREE DIMENSIONS ARE AS PER 22 AT 52



MAINTAIN SURFACE ROUGHNESS R_3 OVER SECTION $\text{Ø} 1.52 \pm 0.03$ T AS PER STANDARD $\text{Ø} 2.3 \pm$ FOR CHECKING DIMENSION-H

DRILLING THE BOTTOM OF VALVE TO DEPTH 2 MM UPTO DIAMETER 2 MM IS ALLOWED.

* DIMENSIONS ARE PROVIDED BY TOOLING

RUN-OUT OF SURFACES K AND T, WITH RESPECT TO SURFACE D SHOULD NOT EXCEED 0.01. BEARING PATTERN OF SURFACES K AND T, ON THE GAUGES ALONG THE CIRCUMFERENCE SHOULD BE CONTINUOUS WITHOUT INTERRUPTIONS. LAP SURFACE T, TOGETHER WITH PART ADY3-007 WHEN ASSEMBLING.

CONDUCT ELECTROPOLISHING, EXCEPT SURFACES-K, D, AND T.

276

| | | |
|----------|--------|-------------------------|
| MATERIAL | STEEL | 17x13 H 3 TV14-1-378-72 |
| DRG. NO. | | |
| SCALE | 2:1 | |
| DATE | 9-8-95 | |
| DRN | SJK | |
| TCD | SJK | |
| CHK | SK | |
| APP | SK | |

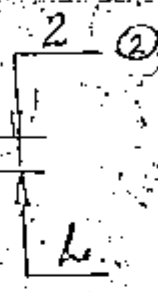
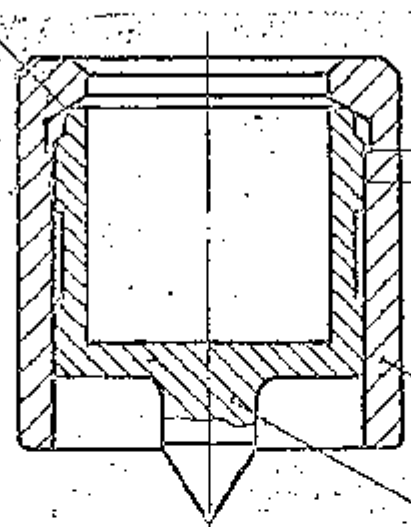
VALVE
ADY3-007

COMP. FILED

54/107

ADY3-08

LAP TO OBTAIN A BELT TYPE BEARING PATTERN
OVER THE CONES OF A WIDTH NOT LESS THAN 0.2
WITHOUT BREAKS ALONG WITH CIRCUMFERENCE.



ADY3-002

ADY3-007

1. AN INCREASE OF CLEARANCE BETWEEN THE PARTS
ADY3-007 AND ADY3-002 OVER SECTION L UPTO 0.055 IS ALLOWED.

| REF'D | DESIGNATION | DESCRIPTION | QTY | REMARKS |
|-------|-------------|-------------|-----|---------|
| ✓ 1 | ADY3-002 | BUSH | 1 | |
| ✓ 2 | ADY3-007 | VALVE | 1 | |

INTERNAL —

ALL DIMENSIONS TO CONFORM TO SPECIFICATION

SCALE: 2:1

DATE: 9-8-95

DRG. NOT TO BE REUSED

DATE OF ISSUE: 9-8-95

MANUFACTURERS HAVE A YEAR WARRANTY

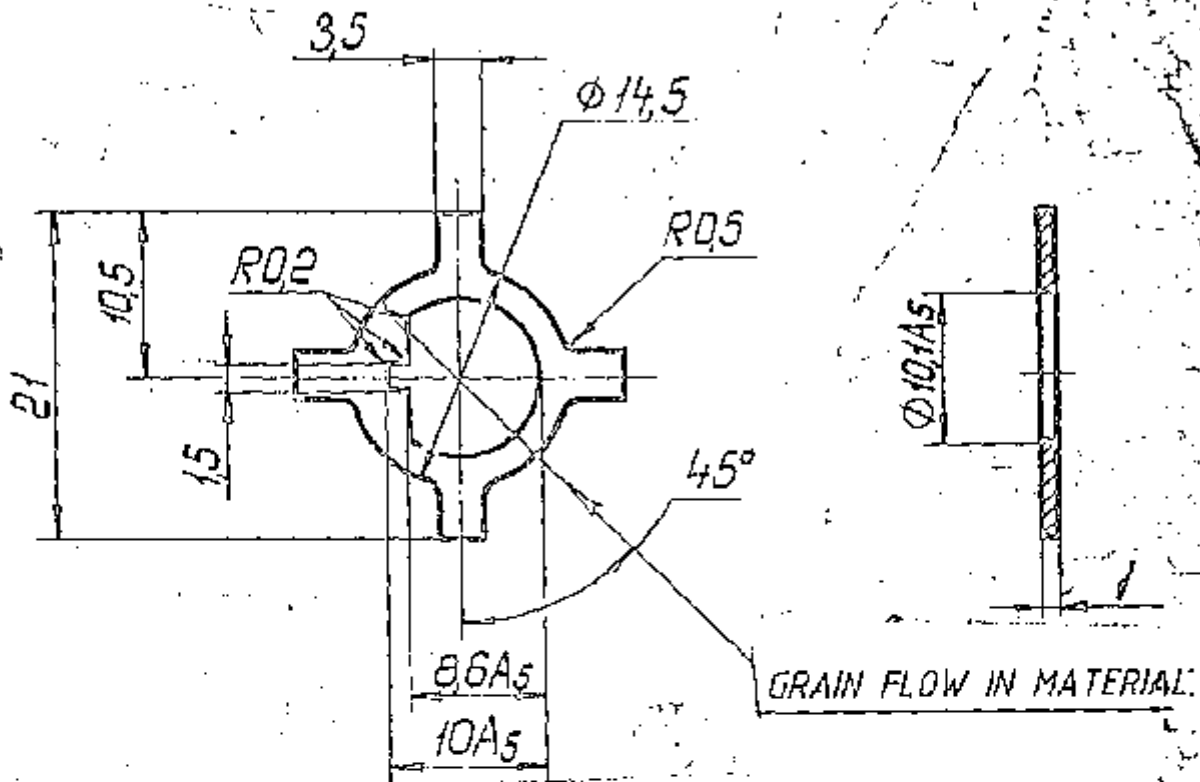
VALVE (UNIT)

ADY3-08

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY CENTER VEHICLES)

47/107

TOLERANCE ON FREE DIMENSIONS
ARE AS PER 22AT52.



SUBJECT PART TO HEAT TREATMENT TO
REMOVE COLD HARDENED LAYER.

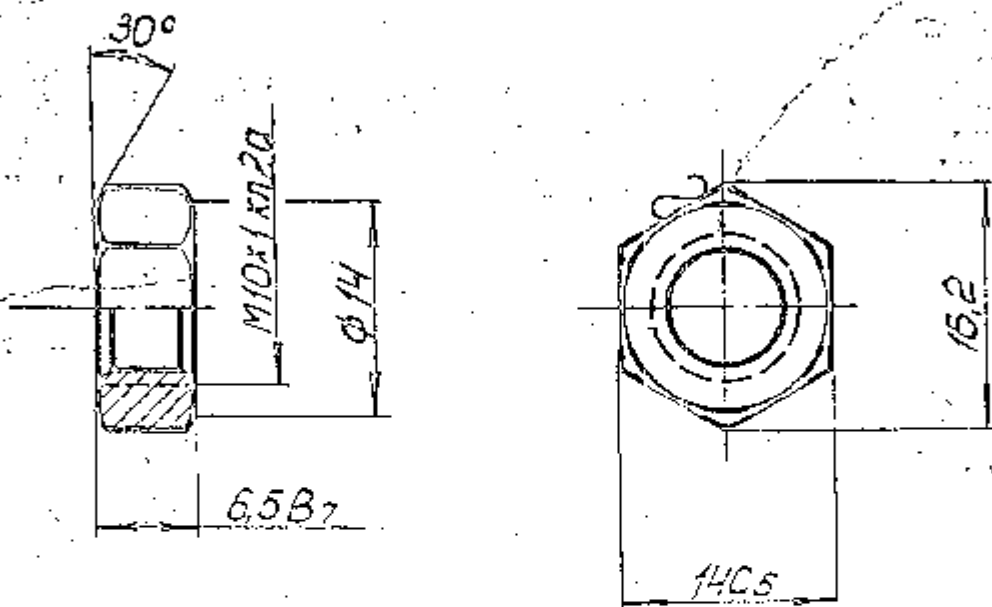
STEEL 5 12 X 18 H 10T-M BAND 1
GOST 4986-70.

| ORGL MATERIAL | NO OF PAGES | AMOUNTS |
|--|--|---|
| ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF. | ALL THREADS TO CONFORM TO SPECIFICATION. | STAMP ON EACH PART NO. MANUFACTURER'S NAME & YEAR OF MFR. |
| DRG. NOT TO BE SCALED | | |
| SCALE:- 2:1 | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | USED ON:- |
| DATE :- 9-8-95 | | |
| DRN. <i>SK</i> | WT :- (Kg) | LOCK |
| TCD. <i>SK</i> | | |
| CHD. <i>SK</i> | DRAWING NO | PART NO |
| APD. <i>SK</i> | AA 93-009 | |

CONTROL DEPARTMENT OF QUALITY ASSURANCE
MANUFACTURER COMPANY (M/S) 55/107

▽ 4 UNLESS OTHERWISE SPECIFIED.

TOLERANCE ON FREE DIMENSIONS ARE AS PER 22AT52.



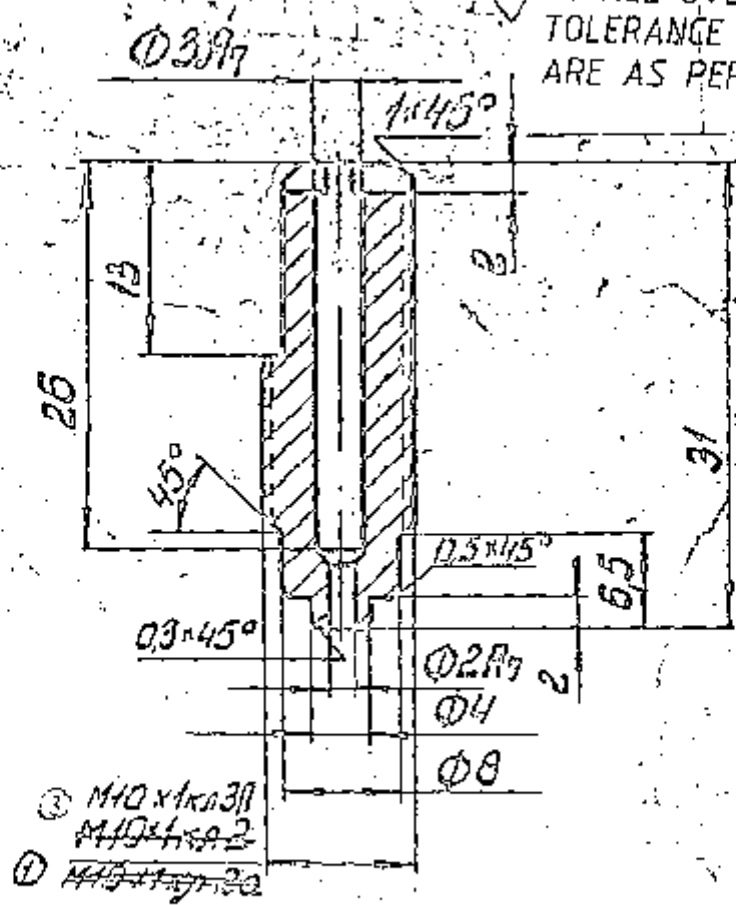
CHAMFERS FOR THREAD ARE MADE IN BLANKS OF NUTS AT AN ANGLE OF 45° DEPTH OF THREAD AND THEY ARE NOT CHECKED ON READYMADE NUTS..

| | | | |
|--|------------|--|---------|
| BRASS A C59-1-A-T GOST 2060-73 | | | |
| ORGL MATERIAL | | DCGING & DATE | ISSUE |
| 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:- | | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | |
| DATE :- 9-8-95 | | USED ON:- | |
| DRN. <i>SK</i> | WT :- (Kg) | NUT | |
| TCD. <i>SK</i> | | | |
| CHD. <i>SK</i> | | DRAWING NO | PART NO |
| APD. <i>SK</i> | | AA 43 - 010 | |

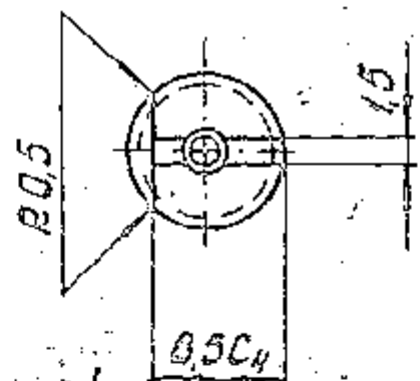
CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES) 57/107

VED-ENOV

▽ 4 ALL OVER
TOLERANCE ON FREE DIMENSIONS
ARE AS PER 22A752.



- ③ M40 x 1 x 0.311
- M40 x 1 x 0.2
- ① M40 x 1 x 0.2



POSITION OF FLAT WITH RESPECT
TO SLOT IS ARBITRARY.
THREAD MAY BE MADE BY ROLLING.

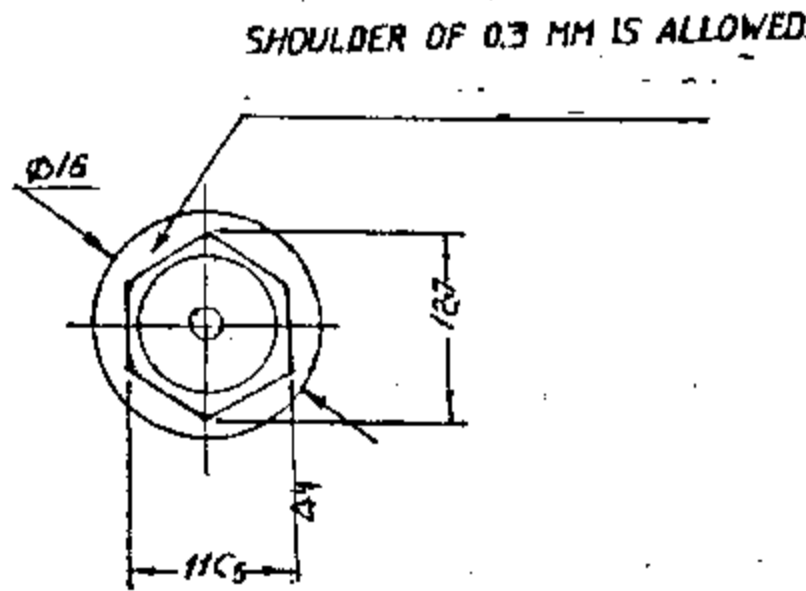
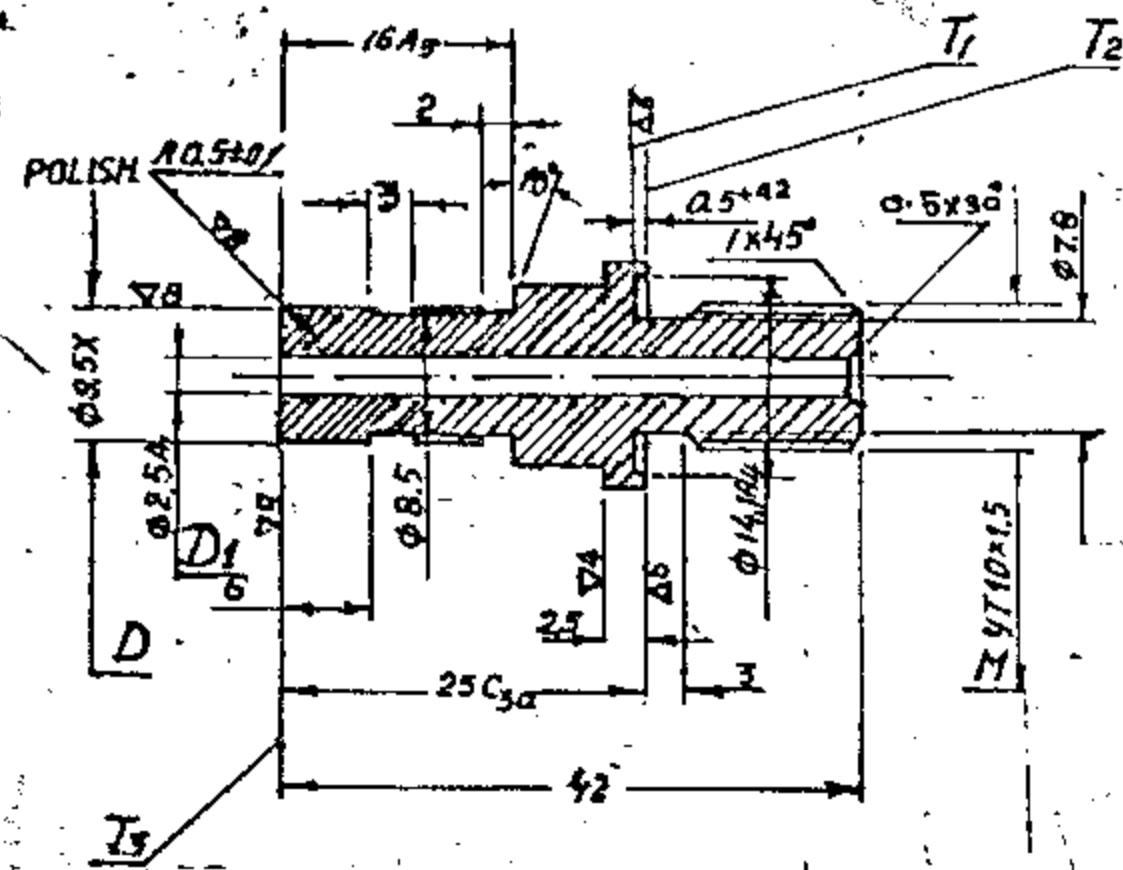
HARDNESS HRC 18 TO 26.
CADMIUM PLATING, 3 TO 6 MICRONS
THICK.

| | | |
|--------------------------------------|------------------|----------------------------|
| MATERIAL: STEEL 12x13 TY 14-I-378-72 | | STAMP OR MARK, PART NO. |
| DRAWN TO BE CHECKED | | MANUFACTURED WITHIN 1 YEAR |
| SCALE: 1-2-1 | DATE: 9-8-95 | |
| DRN: <i>free</i> | TCO: <i>free</i> | |
| CHK: <i>1d</i> | APR: <i>W</i> | |
| ADJUSTIN SCREW | | |
| AA43-013A | | |

CONTROL SERVICE OF QUALITY ASSURANCE
INDIANAPOLIS, INDIANA

58/107

AY 3-019



TECHNICAL CONDITIONS-INDIANISED

- UNION SHALL BE MACHINED FROM STAINLESS STEEL 12Cr13 TO IS 1470 T2 (PT V)
- HARDNESS OF UNION SHALL BE 18-26 HRC.
- PERPENDICULARITY OF SURFACE T₁ AND T₂ WITH RESPECT TO PITCH DIAMETER OF THREAD M (YT 10X15) SHALL NOT EXCEED 0.05mm
- SURFACE T₃ SHALL BE PERPENDICULAR TO SURFACE 'D' WITHIN 0.03mm
- CONCENTRICITY OF CYLINDRICAL SURFACE 'D' WITH RESPECT TO THREAD M SHALL NOT EXCEED 0.3mm

6. UNSPECIFIED TOLERANCES ON DIMENSIONS SHALL BE AS PER ORIGINAL SPECIFICATION 22 AT 52. VALUES OF OTHER TOLERANCES SHALL BE AS UNDER :-

| | | |
|-------------|-------|------------------------|
| 6.1 11C5 | ----- | 11 ^{+0.240} |
| 6.2 25C3a | ----- | 25 ^{+0.484} |
| 6.3 16A5 | ----- | 16 ^{+0.150} |
| 6.4 25 | ----- | 25 ^{+0.150} |
| 6.5 14.1 R4 | ----- | 14.1 ^{+0.013} |
| 6.6 16A5 | ----- | 16 ^{+0.240} |

7. UNION SHALL BE ELECTROPOLISHED EXCEPT ON SURFACE 'D' AND T₃

VALUE OF SURFACE ROUGHNESS SHALL BE AS UNDER :-

| | | | |
|--------|--|--------|-------------|
| 2.1 V4 | --- R _z 50 | 2.4 V8 | --- 0.63 mm |
| 2.2 V6 | --- R _z 25 | 2.5 V9 | --- 0.32 mm |
| 2.3 V6 | --- 2.5 mm UNLESS OTHERWISE SPECIFIED. | | |

RUN-OUT OF SURFACE D, T₁ AND T₂ WITH RESPECT TO MEAN DIAMETER OF THREAD M SHOULD NOT EXCEED 0.05 MM (TO BE PROVIDED TECHNOLOGICALLY)

NON-SQUARENESS OF SURFACE T₃ WITH RESPECT TO SURFACE D SHOULD NOT EXCEED 0.03 MM

RUN-OFF HOLE D₁ SHOULD NOT EXCEED 0.3 MM FROM THE SIDE OF THREAD. M

| | | | | |
|---|--|--|------------|--|
| STEEL 12X13MnTY TY 2362-49, TY 14-1-378-T2 | | DATE | ISSUE | AMENDMENTS |
| ORIG. MATERIAL | DATE | ISSUE | AMENDMENTS | |
| ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF. ING. NOT TO BE SCALED | ALL THREADS TO CONFORM TO SPECIFICATION. | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | | STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR. |
| SCALE:- 2:1 | DATE - 18-2-91 | WT:-(Kg) | | USED GHT:- |
| DHR. [Signature] | TCR. [Signature] | UNION AY 3-019 | | |
| GID. [Signature] | APD. [Signature] | | | |
| CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) 60/107 | | | | |

ALL DIMENSIONS IN mm

1 AN53-020

3.3

TOLERANCE ON FREE DIMENSIONS ARE AS PER 121 ATY.

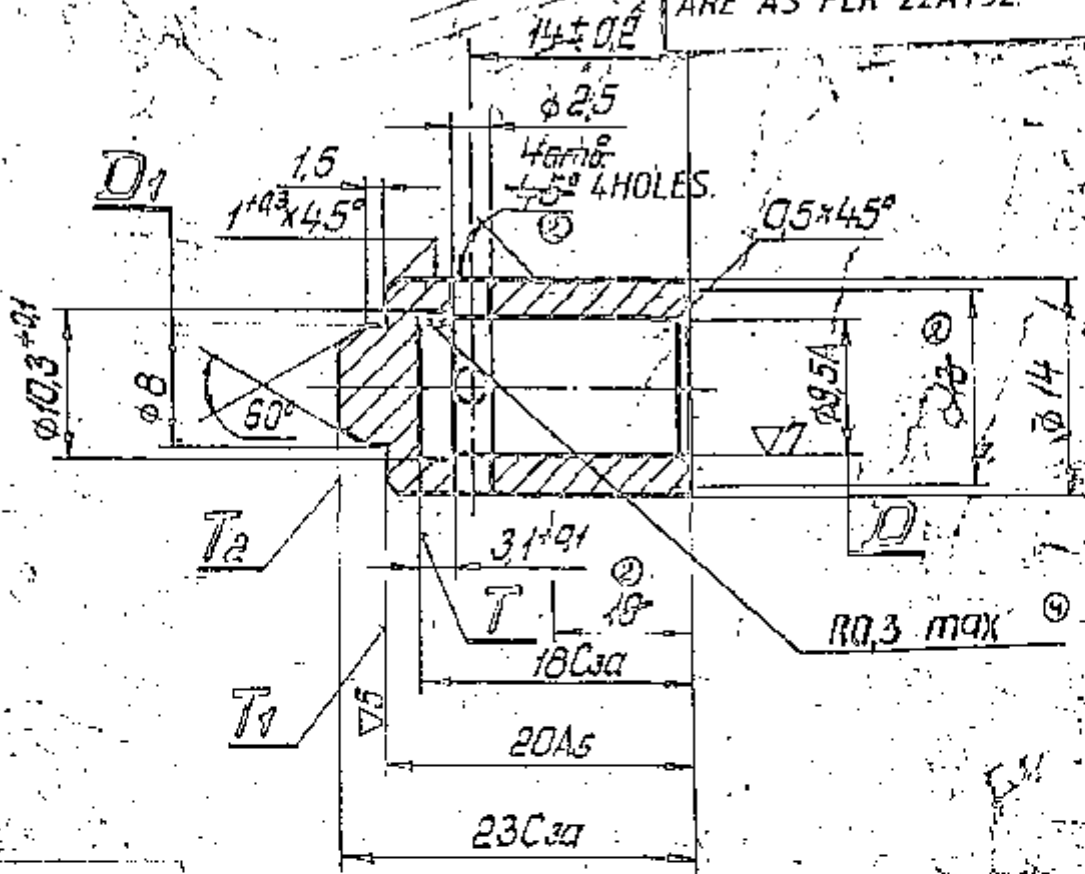


MATERIAL :- RUBBER 3825 TY 38005 -1166-73.

| | | |
|---|--|---|
| ALL SHARP EDGES & CORNERS TO BE CHAMFERED | ALL THREADS TO CONFORM TO SPECIFICATION | STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFG. |
| DRG. NOT TO BE SCALED | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | USED ONLY |
| SCALE :- 2:1 | | |
| DATE :- 9-8-95 | | |
| DRN. <u>SK</u> | 1:1 - 1:1 | GASKET A.4 Y3-020 |
| TCO. <u>SK</u> | | |
| CHD. <u>SK</u> | | |
| APP. <u>SK</u> | | |

CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) 61/107

4 UNLESS OTHERWISE SPECIFIED.
TOLERANCE ON FREE DIMENSIONS ARE AS PER 22AT52.



DEVIATION FROM PERPENDICULARITY OF SURFACE T_1 AND T_2 TO SURFACE D SHOULD NOT EXCEED 0.1 MM.

RUN-OUT OF SURFACE D_1 WITH RESPECT TO SURFACE D SHOULD NOT EXCEED 0.1 MM.

DEVIATIONS FROM PERPENDICULARITY OF SURFACE T TO SURFACE D SHOULD NOT EXCEED 0.05 MM (TO BE PROVIDED TECHNOLOGI-CALLY).

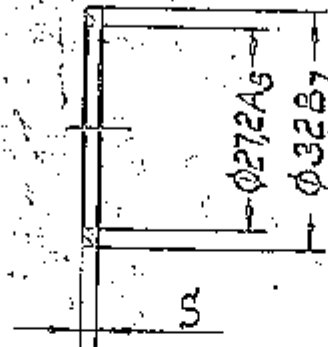
| | | | | |
|---------------------|------------|--|--|---|
| GENERAL 1 - | | ALL THREADS TO CONFORM TO SPECIFICATION | | STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFG. |
| DRG NOT TO BE SCALE | | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | | USED ON:- |
| SCALE - 2:1 | | VALVE BODY AA 93 - 021 | | |
| DATE - 9-8-95 | | | | |
| DRG. SK | (1) - (10) | | | |
| TO. SK | | | | |
| CHK. RB | | | | |
| APP. [Signature] | | | | |

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

62/107

ADY3-027

2



| S | QTY | WEIGHT |
|-----|-----|--------|
| 1,5 | 1 | |
| 1,8 | 1 | |
| 2 | 1 | |
| 2,5 | 1 | |

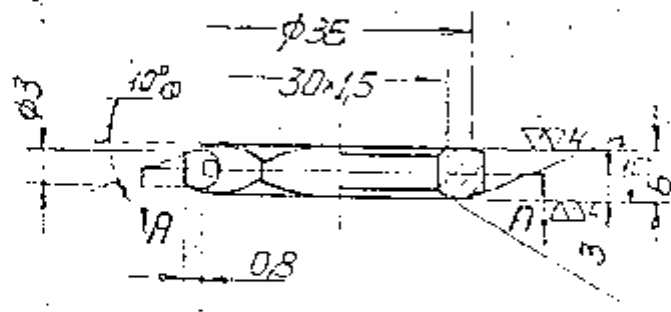
TOLERANCE ON DIMENSION S EQUAL TO TOLERANCE ON THICKNESS OF MATERIAL IN THE AS-DELIVERED CONDITION.

DRESS THE BURRS.

| | | | |
|--|------------|---|------------|
| MATERIAL: — ALUMINIUM AA-M GOST 21631-76 | | STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFG. | |
| DRG. NOT TO BE SCALED | | ALL THREADS TO CONFORM TO SPECIFICATION | USED FOR — |
| SCALE: — 1:1 | | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | |
| DATE: — 9-8-95 | | <p>WASHER</p> <p>ADY3-027</p> | |
| DRG. <i>SK</i> | WT: — (kg) | | |
| TCO. <i>SK</i> | | | |
| CHG. <i>SK</i> | | | |
| APP. <i>SK</i> | | | |
| <p>CONTROLLERATE OF QUALITY ASSURANCE</p> <p>(INFANTRY COMBAT VEHICLES)</p> <p style="text-align: right;">64/107</p> | | | |

400-004

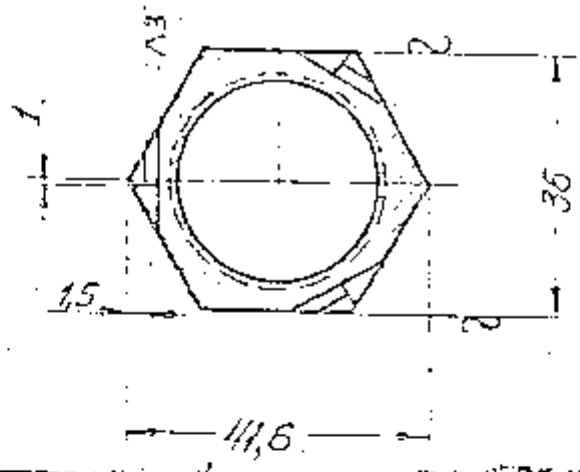
UNLESS SPECIFIED OTHERWISE,
TOLERANCES ON FREE DIMENSIONS
ARE AS PER 22AT52.



AS PER A. A.

CHAMFER 90 TO 120° UP TO
 $\phi 30$ ON BOTH SIDES.

3 HOLES. $\phi 15$



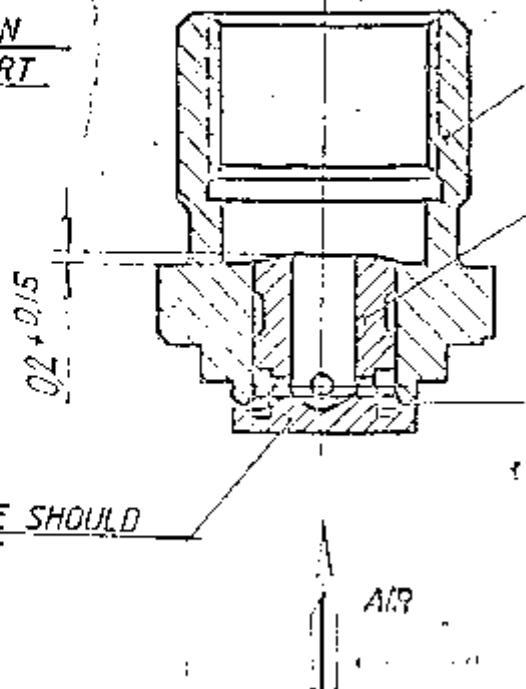
CADMIUM PLATED, 9 TO 13
MICRONS THICK.

| | | |
|--|--|---|
| MATERIAL :- STEEL 38XA TY 14-1-950-74. | | |
| ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF. | ALL THREADS TO CONFORM TO SPECIFICATION | STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR. |
| DWG. NOT TO BE SCALED | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | USED ON:- 765-78-056 |
| SCALE :- 1:1 | DATE :- 10-08-1995 | |
| ENL. <i>Koyal</i> | MT :- (K7) | LOCKING NUT |
| DES. <i>Koyal</i> | 19.7 | |
| CHE. <i>K</i> | | AAY-004 |
| APP. <i>Koyal</i> | | |

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

73/107

PROVIDE DIMENSION
BY SELECTING PART
ADY-028A,



ADY-058A

ADY-028A

MOTION OF VALVE SHOULD
BE FREE WITHOUT
JAMMINGS

LAP JOINTLY.

CHECK VALVE FOR TIGHTNESS BY AIR AT P = 10Kg/cm².

AIR LEAKAGE SHOULD NOT EXCEED 60 BUBBLES PER MINUTE.

THIS CHECK MAY BE PERFORMED DURING TRAIL OF UNIT.

| | | | | |
|----|-------------|-------------|-----|---------|
| 2 | A. Y - 028A | VALVE | 1 | |
| 1 | A. Y - 058A | COVER | 1 | |
| NO | DESIGNATION | DESCRIPTION | QTY | REMARKS |

NOTE: 10.8.55

COVER WITH VALVE (UNIT)

ADY-04A

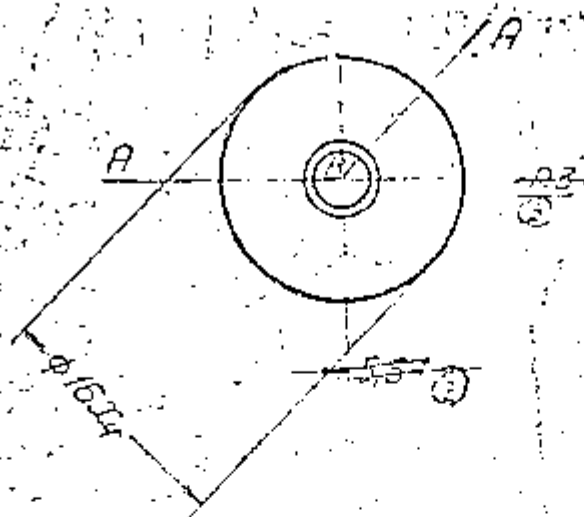
ADY-04

765-78-C25

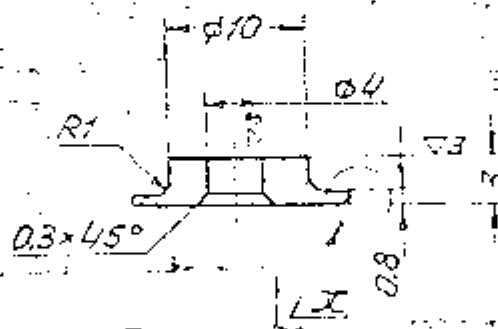
007-AY

3/6/96

TOLERANCE ON FREE DIMENSIONS ARE AS PER 22AT52-CLASS 7.



AS PER - A-A-A



SECTION "X"

BLUNT SHARP EDGES,
R 0,5

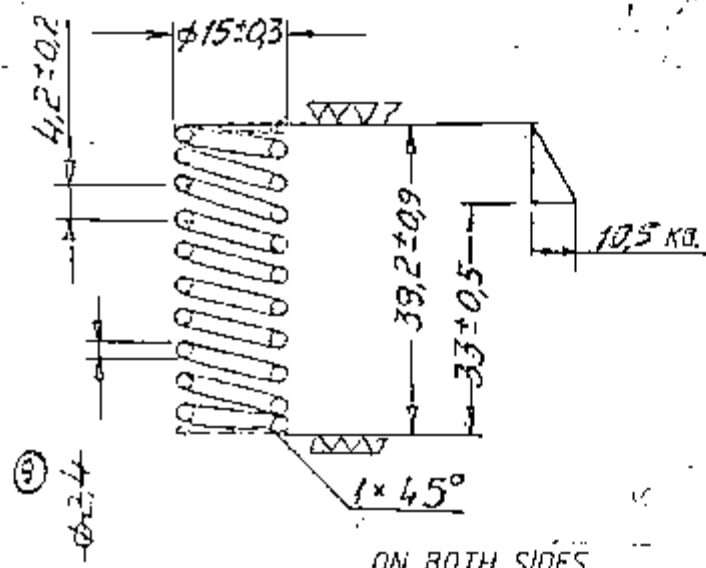
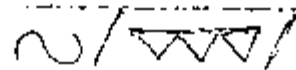
PERFORM HEAT TREATMENT
TO OBTAIN HARDNESS,
HB ≥ 148.
ELECTROPOLISHING.

| | | |
|--|--|---|
| MATERIAL - STEEL 17X18H9 TY 14-1-378-72. | | |
| ALL SHARP EDGES & CORNERS TO BE ROUNDED | ALL THREADS TO CONFORM TO SPECIFICATION | STAMP OR ETCH, PART NO. MANUFACTURERS HAVE 1 YEAR OF W.M. |
| DRG. NOT TO BE SCALED | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | USED ON - 765-78-066 |
| SCALE - 2:1 | | |
| DATE - 10-08-1995 | | |
| DRY <i>K. K. K.</i> | WT - (KG) | <p>WASHER</p> <p>A4Y-007</p> |
| ECO <i>K. K. K.</i> | | |
| FIG <i>20</i> | | |
| APP <i>002</i> | | |

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

74/107

800-504



| | |
|-----------------------|------|
| TOTAL NUMBER OF TURNS | 10,5 |
| NO. OF WORKING TURNS | 8,5 |

ELECTROPOLISHING.

RH OR LH WINDING.
 BEND THE ENDS AND GRIND THEM PERPENDICULAR TO THE AXIS OF SPRING TO 3/4 OF THE TURN.

NON-SQUARENESS OF BUTT ENDS WITH RESPECT TO AXIS OF SPRING SHOULD NOT EXCEED 0.6 MM.

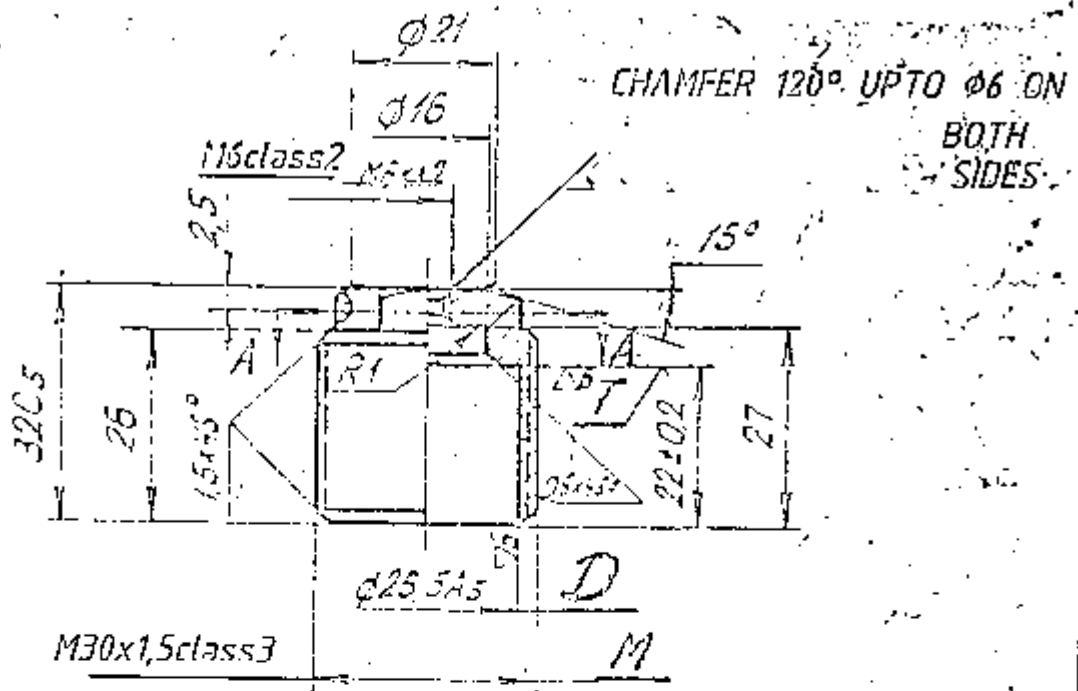
IT IS ALLOWED TO REMOVE A LAYER OF METAL IN THE LIMITS OF TOLERANCE FOR WIRE DIAMETER BY ELECTROPOLISHING TO OBTAIN THE REQUIRED CHARACTERISTIC.

DIMENSIONS ARE GIVEN FOR MANUFACTURED SPRING AFTER TIGHTENING IT ON ROD TO A LENGTH OF 32 ± 0.15 AND KEEPING IT IN COMPRESSED CONDITION FOR 12 HOURS AT A TEMPERATURE OF $160 \pm 20^\circ\text{C}$.

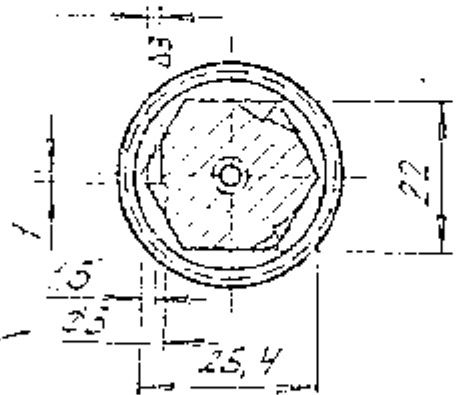
| | | |
|--|---|---|
| MATERIAL :- BRIGHT POLISHED CARBON TOOL STEEL 2.4-B-12X18H9,79 | | 14130151 |
| ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF | ALL DIMENSIONS TO BE GIVEN IN MILLIMETERS | STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFG. |
| DRG. NOT TO BE SCALED | TOLERANCES ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | 765-78-056 |
| SCALE :- 1:1 | | |
| DATE :- 10-08-1995 | | |
| DRG. <i>Khand</i> | WT :- 1Kg | |
| TCO. <i>Khand</i> | | |
| CHU <i>[Signature]</i> | | |
| APD <i>[Signature]</i> | | |
| SPRING | | |
| ADY-008 | | |

CONTROLLERATE OF QUALITY ASSURANCE
 (INFANTRY COMBAT VEHICLES) 75/107

UNLESS STATED OTHERWISE
 TOLERANCES ON FREE DIMENSIONS ARE
 AS PER 22AT52 CLASS 7.



3 holes $\phi 1.5$ A-A



NON-SQUARENESS OF ANGLE DIA OF THREAD M
 WITH RESPECT TO PLANE T SHOULD NOT
 EXCEED 0,08. RUN OUT OF SURFACE D WITH RESPECT
 TO ANGLE DIA. OF THREAD M SHOULD NOT EXCEED
 0,05. (ENSURED TECHNOLOGICALLY).
 LOCKING HOLES MAY BE STOP DRILLED.

HARDNESS
 HRC = 18 TO 26.
 ELECTRO POLISH.

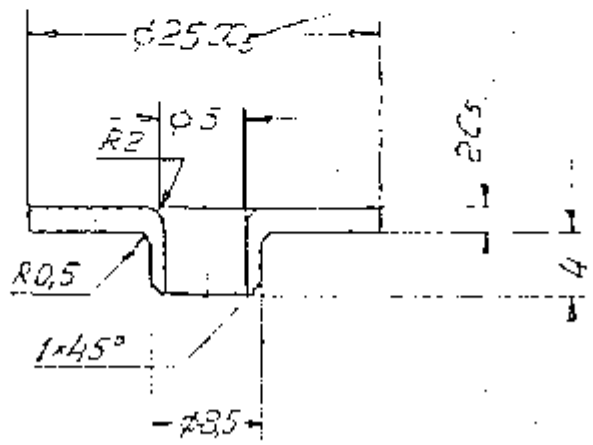
STEEL 12 X 13 TY 14-1-377-72

| | |
|-------|--------|
| FILED | |
| DRG. | |
| SCALE | 1:1 |
| DATE | 9-8-95 |
| DRN | SK |
| TCO | SK |
| CHY | KP |
| POB | |

NUT
 AA 9-019 A

RAY-022

TOLERANCE ON FREE DIMENSIONS
AS PER 22AT52-CLASS 7.



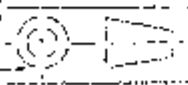
ELECTROPOLISHING
IT IS ALLOWED TO PERFORM HEAT
-TREATMENT OF PART TO OBTAIN
HARDNESS Rc 16 TO 26.

BLUNT SHARP EDGES, R 0.3.
PART MAY BE MADE BY STAMPING
FROM BAND 12x13-11-H-0,2x100.

| | | |
|----------------------------|-----------------|------------|
| STEEL 12x13 TY14-1-377-72. | MANUFACTURED BY | 765-78-056 |
| 10-08-1995 | DATE | |

BUSH
RAY-022

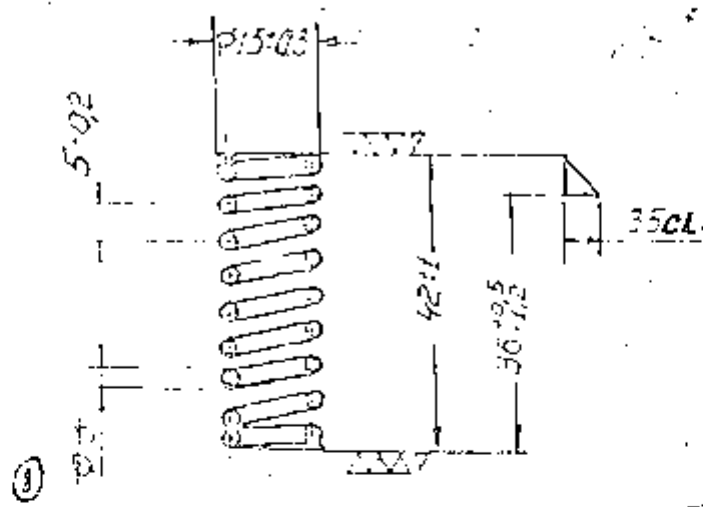
Handwritten initials/signature



77/107

A44-023

2 / 12/11/77



ELECTROPOLISH

| | |
|-----------------------|-----|
| TOTAL NUMBER OF TURNS | 9,5 |
| NO. OF WORKING TURNS | 7,5 |

LH WINDING

BEND THE ENDS AND GRIND THEM PERPENDICULAR TO THE AXIS OF SPRING TO 3/4 OF A TURN.

NON-SQUARENESS OF BUTT-ENDS TO ^{THE} AXIS OF SPRING SHOULD NOT EXCEED 0.6 MM.

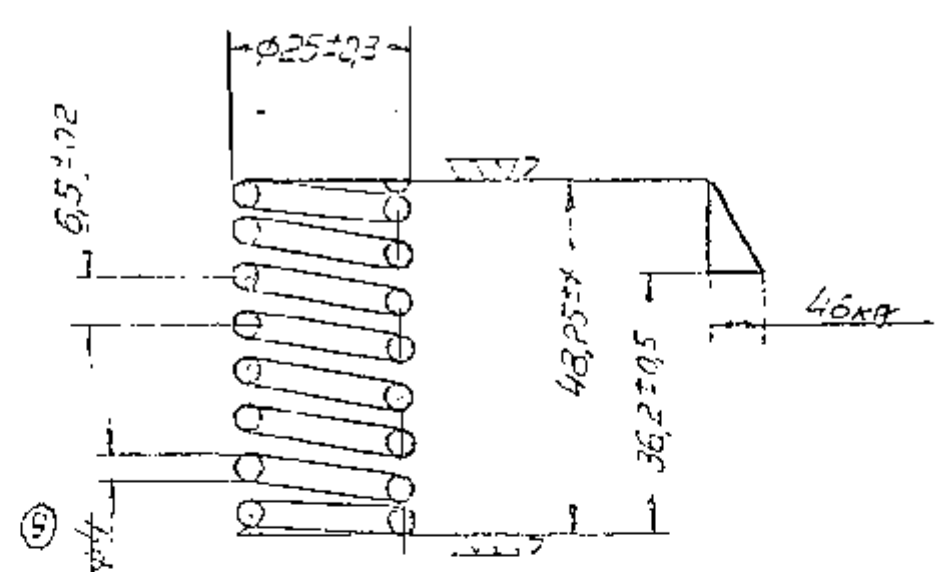
IT IS ALLOWED TO REMOVE A LAYER OF METAL WITHIN THE LIMITS OF TOLERANCE FROM WIRE DIAMETER BY ELECTROPOLISHING TO OBTAIN THE REQUIRED CHARACTERISTIC.

DIMENSIONS ARE GIVEN FOR MANUFACTURED SPRING AFTER TIGHTENING IT ON ROD OVER LENGTH 35 ± 0.5 AND KEEPING IT IN COMPRESSED POSITION FOR 12 HOURS AT A TEMPERATURE OF $160 \pm 20^\circ C$.

| | | |
|--|-------------------------|------------------|
| MATERIAL: BRIGHT POLISHED CARBON TOOL STEEL 3-B-12 X 18 H9 T914 130-15 | | |
| ALL DIMENSIONS OF CONFORM TO SPECIFICATION | DESIGNED BY: [REDACTED] | DATE: [REDACTED] |
| 10-08-1995 | 765-78-056 | |
| SPRING | | |
| A44-023 | | |

420 - 504

2 | 7777



| | |
|----------------------|----|
| TOTAL NO. OF TURNS | 85 |
| NO. OF WORKING TURNS | 85 |

ELECTRO POLISHING (S)

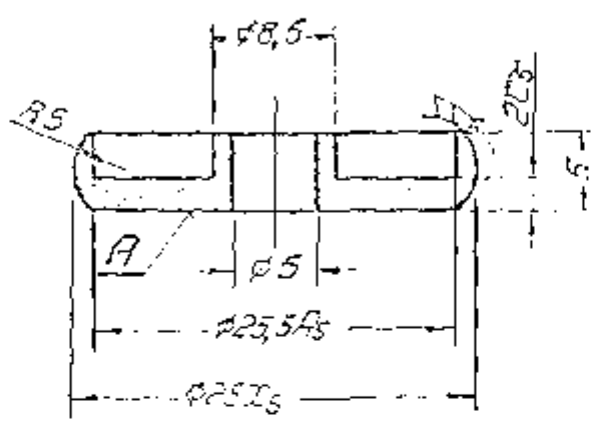
RH WINDING
 BEND THE ENDS AND GRIND THEM PERPENDICULAR TO THE AXIS OF TURN
 NONSQUARENESS OF BUTT ENDS WITH RESPECT TO AXIS OF SPRING SHOULD NOT EXCEED 0.6mm
 IT IS ALLOWED TO REMOVE A LAYER OF METAL WITH THE LIMIT OF TOLERANCE FOR WIRE DIAMETER TO OBTAIN THE CHARACTERISTIC
 DIMENSIONS ARE GIVEN FOR MANUFACTURED SPRING AFTER TIGHTENING IT ON A RCD OVER LENGTH 34.5±0.5mm AND KEEPING IT IN COMPRESSED POSITION FOR 12 HOURS AT A TEMPERATURE OF 16c±20c

| | | |
|---|------------------------------|-----------------|
| MATERIAL - BRIGHT-POLISHED CARBON TOOL STEEL 48 12X18H9, 14-130-151 | | -76 |
| DRG NOT TO BE COILED | ALL DIMENSIONS TO CONFORM TO | INDUSTRIAL TECH |
| SCALE - 1:1 | TOLERANCE | INDUSTRIAL TECH |
| DATE - 10-08-1995 | 35 DETAIL | 765-78-C66 |
| DESIGNED TCD CHD VPD | SPRING AAY-024 | |
| CONTROL SHEET OF THE PRODUCT (INFORMATION ONLY) | | 79/107 |

920-5TH

▽ 3 {▽ 6}

TOLERANCE ON FREE DIMENSIONS ARE AS PER 22AT52, CL-7.



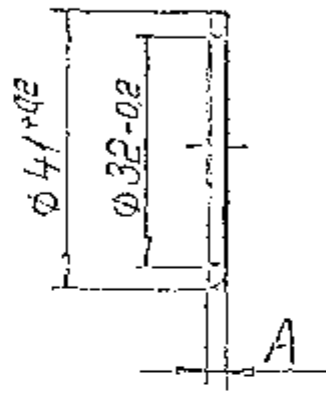
BLUNT SHARP EDGES R 0.3
 CONCAVITY OF SURFACE A IS NOT ALLOWED.
 CONVEXITY SHOULD NOT EXCEED 0.1.
 PERFORM HEAT TREATMENT UPTO HRC 50 TO 56.

ELECTROPOLISHING.

| | | | |
|--|---|-------------------------|--|
| MATERIAL :- STEEL 40X13, TV14-1-377-72 | | DRAWN BY: [Signature] | |
| DRG. NOT TO BE SCALED | | CHECKED BY: [Signature] | |
| SCALE :- 2:1 | TOLERANCE IN DIMENSIONS UNLESS OTHERWISE SPECIFIED | USED QTY: 765-78-666 | |
| DATE :- 10-08-1995 | <p style="text-align: center;">BUSH AAY-026</p> | | |
| DRG. [Signature] | | | |
| ICD. [Signature] | | | |
| CHD. [Signature] | | | |
| APD. [Signature] | <p style="text-align: center;">CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) 80/107</p> | | |

ADY-027

2



| DIMENSION A | QNTY | No. OF PARTS |
|-----------------|--------|--------------|
| $0,35 \pm 0,05$ | 1 TO 2 | ADY-027-1 |
| $0,7 \pm 0,1$ | 1 TO 2 | ADY-027-2 |
| $0,4 \pm 0,1$ | 1 TO 2 | ADY-027-3 |

TOLERANCES ARE GIVEN FOR TOOL.

| | | |
|------------------------|------------|----------------------|
| DIAPHRAGM SHEET GROUPS | | TY 38005 206/6018-74 |
| DATE - 10-08-1995 | 765-78-056 | |
| GASKET | | |
| ADY-027 | | |

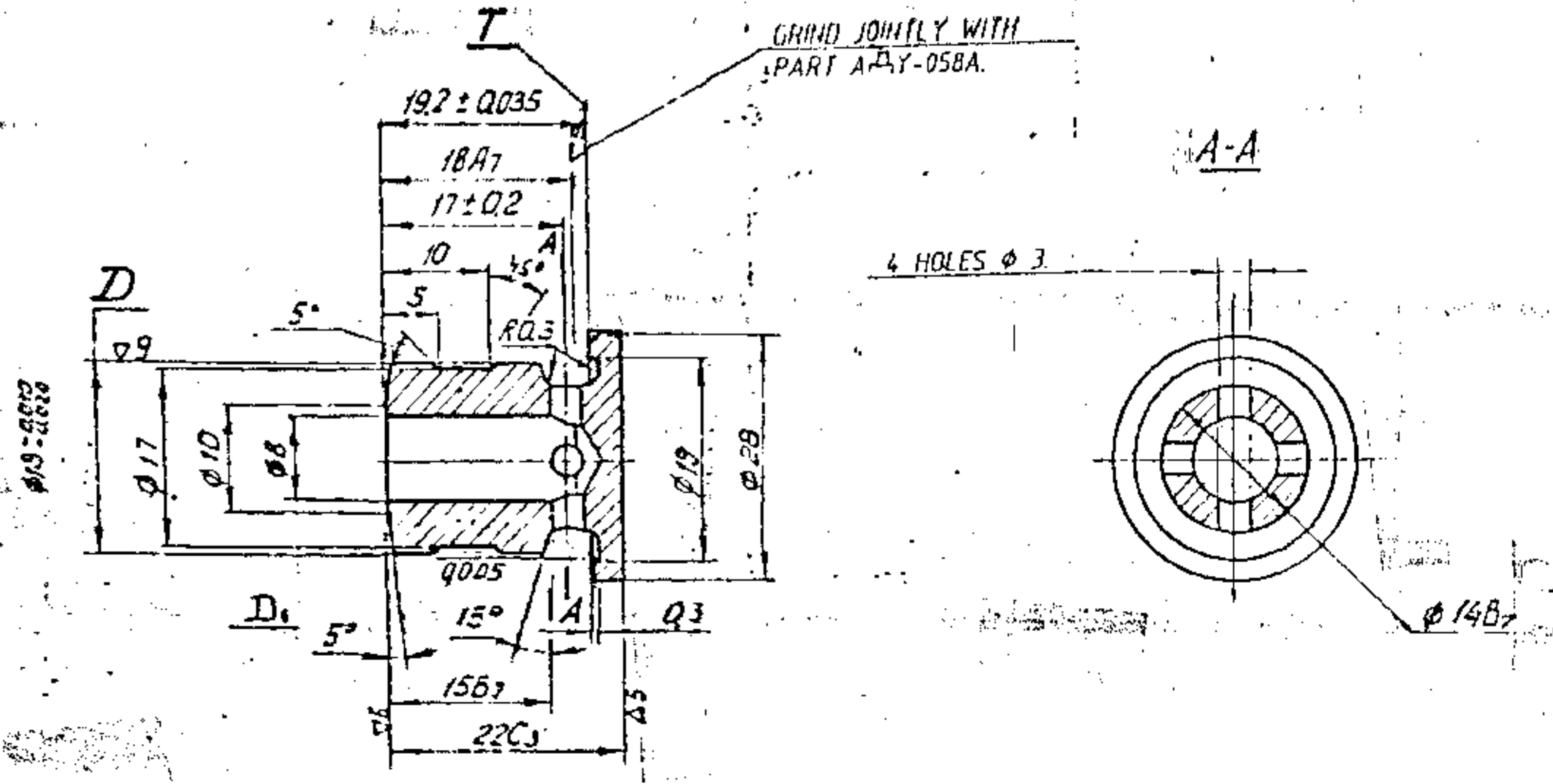
CONTROLLERATE OF QUALITY ASSURANCE 81/107
 (INFANTRY COMBAT VEHICLES)

ADU-028A

TECHNICAL CONDITIONS

1. VALVE SHALL BE MACHINED FROM STAINLESS STEEL 105 Cr 18 Mo 5 TO IS : 1510-72 (PT V)
2. VALVE SHALL BE THROUGH HARDENED AND TEMPERED TO 55 TO 60 HRC AND SHALL BE SUBJECTED TO SUB ZERO TREATMENT TO STABILIZE THE DIMENSIONS
3. UNSPECIFIED TOLERANCES ON DIMENSIONS SHALL BE AS PER ORIGINAL SPECIFICATION 22 AT 52. VALUES OF OTHER TOLERANCES SHALL BE AS UNDER:-

| | | |
|---------------------|-------|-----------------------------|
| 3.1 18 A7 | ----- | 18 ^{+0.430} |
| 3.2 $\phi 14 \pm 7$ | ----- | $\phi 14$ ^{+0.430} |
| 3.3 15 B7 | ----- | 15 ^{+0.430} |
| 3.4 22 C3 | ----- | 22 ^{+0.045} |
4. DENTS AND SCRATCHES ON BUTT END 'T' ARE NOT ACCEPTABLE.
5. SURFACE 'D', 'D₁' AND 'T' SHALL BE ELECTROPOLISHED. SURFACE 'T' SHALL BE POLISHED ALONG WITH PT. ADY-058A



1. ALL DIMENSIONS ARE IN MILLIMETRES.
2. VALUES OF SURFACE ROUGHNESS SHALL BE AS UNDER:-

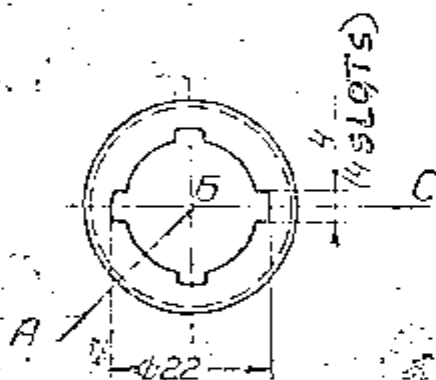
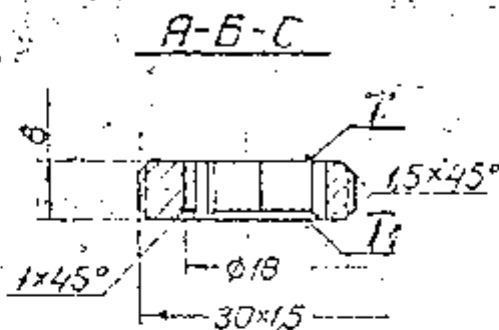
| | | |
|--------|-------|---|
| 21 ∇ 4 | ----- | R _z 40 UNLESS OTHERWISE SPECIFIED. |
| 22 ∇ 5 | ----- | R _z 20 |
| 23 ∇ 6 | ----- | 2.5 μm |
| 24 ∇ 8 | ----- | 0.32 μm |

| | | | |
|--|--|---|-------------|
| STEEL 25x18 TY 14-1-377-72 | | ISSUE | AMENDMENTS |
| ORIG. MATERIAL | DATE | ISSUE | AMENDMENTS |
| ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF. | ALL THREADS TO CONFORM TO SPECIFICATION. | DRAWN OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFG. | |
| DWG. NOT TO BE SCALED | SCALE:- 2:1 | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | ISSUED ON:- |
| DATE :- 23-2-71 | WT :- (KG) | VALVE | |
| DRN. [Signature] | TCD. [Signature] | ADU-028A | |
| CHK. [Signature] | APD. [Signature] | CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) | |

HAU-029A

▽4 ALL OVER.

TOLERANCE ON FREE DIMENSIONS ARE AS PER 22ATS2, CLASS 7.



RUN-OUT OF SURFACES T AND T₁ WITH RESPECT TO ANGLE DIAMETER OF THREAD SHOULD NOT EXCEED 0.05.

ELECTROPOLISH.
HEAT TREATMENT IS ALLOWED UPTO Rc = 16 TO 26.

| | | |
|---------------------------------------|--|---|
| INTERNAL STEEL 12 X 15 TY 14-1-377-72 | | |
| DRG. NOT TO BE SCALE | ALL DIMENSIONS TO BE IN MILLIMETERS UNLESS OTHERWISE SPECIFIED | STAMP OR ETCH ON THE DRG. MANUFACTURERS NAME AND NUMBER |
| SCALE - 1:1 | TOLERANCE ON DIMENSIONS TO BE AS PER 22ATS2, CLASS 7 | 765-78-066 |
| DATE - 10-08-1995 | APPROVED BY | |
| DRG. HAU | | |
| ICD. HAU | | |
| CHD. HAU | | |
| SPR. HAU | | |

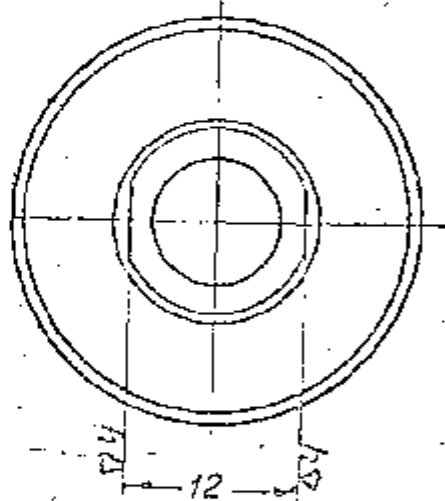
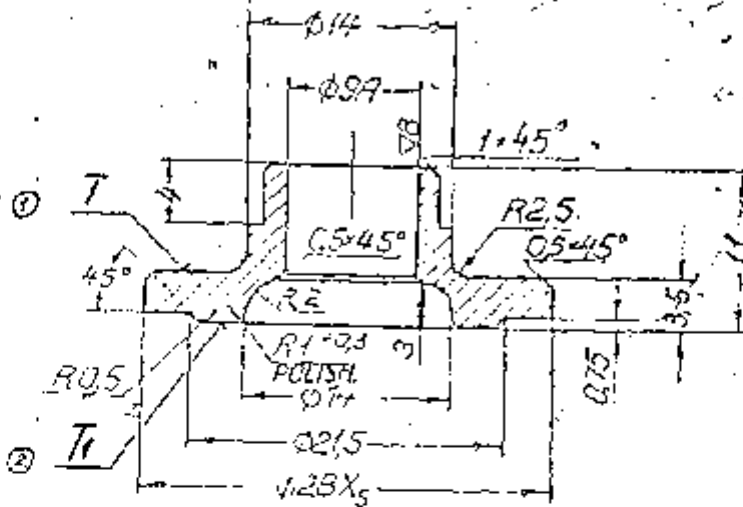
NUT
A-44-029A

FOR A COMPLETE RANGE OF QUALITY ASSURANCE SOLUTIONS CONTACT US AT (020) 2777 7777

63/107

ADY-030A

▽6 UNLESS OTHERWISE SPECIFIED.
TOLERANCE ON FREE DIMENSIONS
ARE AS PER 22AT52.



NON-PARALLELITY OF SURFACES
T AND T₁ SHOULD NOT EXCEED 0.03.
MAINTAIN AREA WITH A WIDTH OF
1 TO 1.5 MM ON BUT-END T₁.

HARDNESS Rc 24 TO 37
ELECTROPOLISH THE PART.
PASSIVATE THE PART.

| | | |
|---------------------------------------|--|---|
| MATERIAL - STEEL 12X13 TY 14-1-377-72 | | |
| ALL DIMENSIONS GIVEN IN MILLIMETERS | ALL SURFACES TO CONFORM TO SPECIFICATION | STAMP OR SEAL PART NO. MANUFACTURER'S NAME & YEAR OF MFG. |
| DRG NOT TO BE RECALC'D | TOLERANCE ON DIMENSIONS WILL BE AS OTHERWISE SPECIFIED | USED ON- |
| SCALE 2:1 | | |
| DATE 10-08-1995 | | |
| DRN <i>[Signature]</i> | | |
| TCD | BUSH | |
| CHK <i>[Signature]</i> | ADY-030A | |

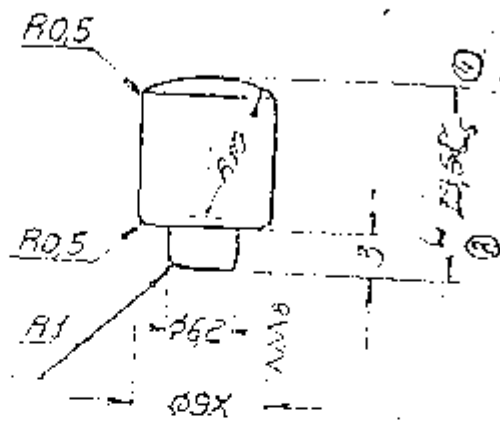
CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

84/107

EEO-ADH

VV6/ VV8

TOLERANCES ON FREE DIMENSIONS ARE AS PER 2.2AT 52 - CLASS 7.



POLISH

PASSIVATE

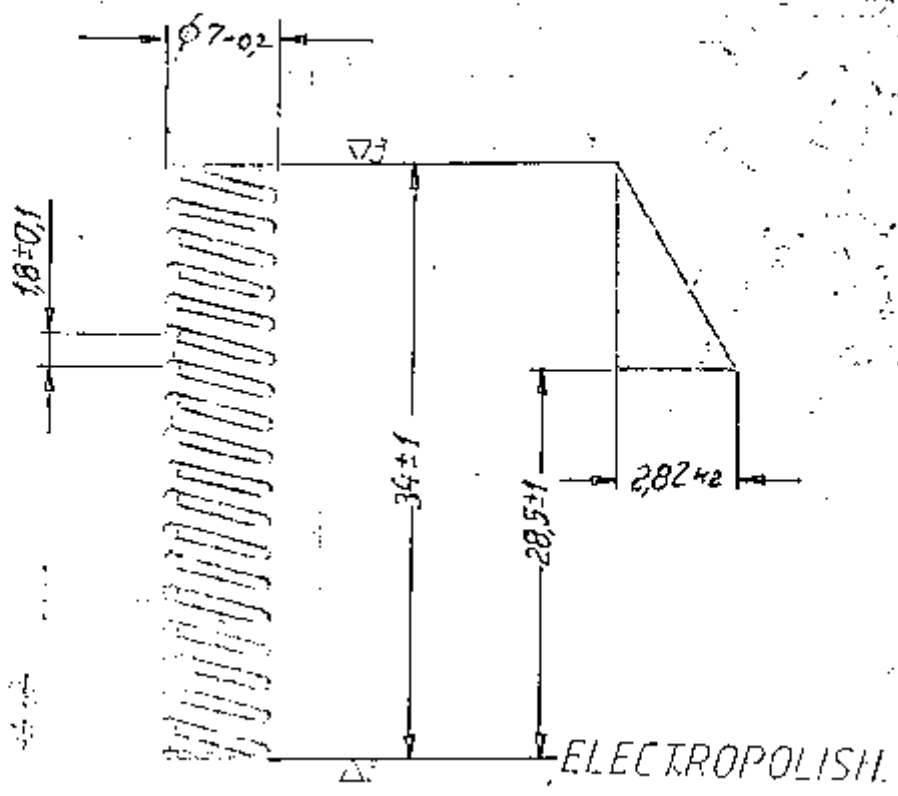
| DIMENSION | QNTY. |
|------------|-------|
| 14,0 ± 0,1 | 1 |
| 13,8 ± 0,1 | 1 |
| 13,6 ± 0,1 | 1 |
| 13,4 ± 0,1 | 1 |
| 13,2 ± 0,1 | 1 |

| | | |
|--|--|---|
| MATERIAL - BRASS A63-T GOCT 2060-80 | | |
| ALL SHARP EDGES & CORNERS TO BE CHAMFERED | ALL THREADS TO CONFORM TO SPECIFICATION | STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR. |
| DRG. NOT TO BE SCALED | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | USED CH:- |
| SCALE - 2:1 | | |
| DATE - 10-08-1995 | | |
| DRN. TO: [Signature] | MT - (36) | <h1>LOCK PIN</h1> <h2>ADY-033</h2> |
| END [Signature] | | |
| CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) | | |
| | | 208A-033 |

85/107

500-1700

1731



| | |
|-----------------------|----|
| TOTAL NUMBER OF TURNS | 20 |
| NU. OF WORKING TURNS | 18 |

DIRECTION OF COILING IS RIGHT-HAND OR LEFT-HAND. BEND THE ENDS AND GRIND THEM PERPENDICULAR TO AXIS OF SPRING BY 3/4 OF TURN. DEVIATION FROM SQUARENESS OF ENDS TO AXIS OF SPRING SHOULD NOT EXCEED 0.5 MM.

DIMENSIONS ARE GIVEN FOR READY-MADE SPRING AFTER COMPRESSING IT ON ROD UP TO LENGTH OF 27 ± 1 MM AND KEEPING SPRING COMPRESSED CONDITION FOR 12 HOURS AT A TEMPERATURE OF $160 \pm 20^\circ\text{C}$.

FOR OBTAINING CHARACTERISTICS METAL LAYER MAY BE REMOVED BY ELECTROPOLISHING WITHIN LIMITS OF TOLERANCE FOR WIRE DIAMETER.

MATERIAL-BRIGHT POLISHED CARBON TOOL STEEL

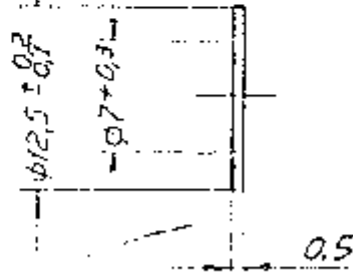
| | |
|---|------------------------------------|
| MATERIAL - 1.2-B-12x18H9 TY 14-130-151-76 | |
| DATE 10-08-1995 | STAMP OR SIGNATURE OF MANUFACTURER |
| QTY 18 | REVISION |
| CHKD [Signature] | APD [Signature] |
| SPRING | |
| RAY-035 | |

CONTROLLED AND QUALITY ASSURANCE
(INFORMED BY THE NEW RULES) 208A-035

86/107

ADY-037

2



| | | | |
|---------------------------------------|--|----------------------------|--|
| MATERIAL - PARONITE NM5-T GOST 481-71 | | STAMP OR ETCH, PART NO. | |
| NO DIMENSIONS NOTED TO BE SEVERE | ALL DIMENSIONS TO CONFORM TO SPECIFICATION | MANUFACTURERS WARR 1 YEAR | |
| ORIG. NOT TO BE SEALED | | OF 1997 | |
| SCALE - 2:1 | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | UNLESS OTHERWISE SPECIFIED | |
| DATE - 10-08-1995 | GASKET | | |
| DRN <i>[Signature]</i> | | | |
| ITD | | | |
| CHD <i>[Signature]</i> | | | |
| APR <i>[Signature]</i> | ADY-037 | | |

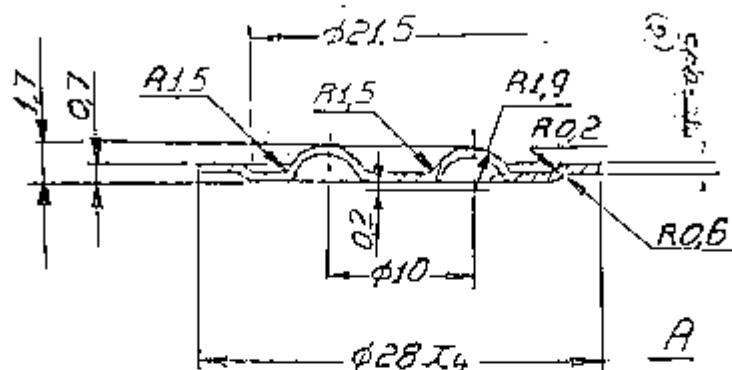
5

CONTROLLERATE OF QUALITY ASSURANCE
 (INFANTRY COMBAT VEHICLES) 208A-037

07/107

040-AYH

TOLERANCES ON FREE DIMENSIONS ARE AS PER ACCURACY CLASS 5.



LOCAL REDUCTION OF SURFACE OF DIAMETER A TO 0.05 OVER THE ARCS, CORRESPONDING TO THE TOTAL CENTRAL ANGLE OF NO MORE THAN 90° IS ALLOWED.

STAMP TOGETHER WITH PART AAY-041.

RUN-OUT OF SURFACES OF CORPUGATION Ø10, WITH RESPECT TO SURFACE A SHOULD NOT EXCEED 0.1 ENSURE TECHNOLOGICALLY.

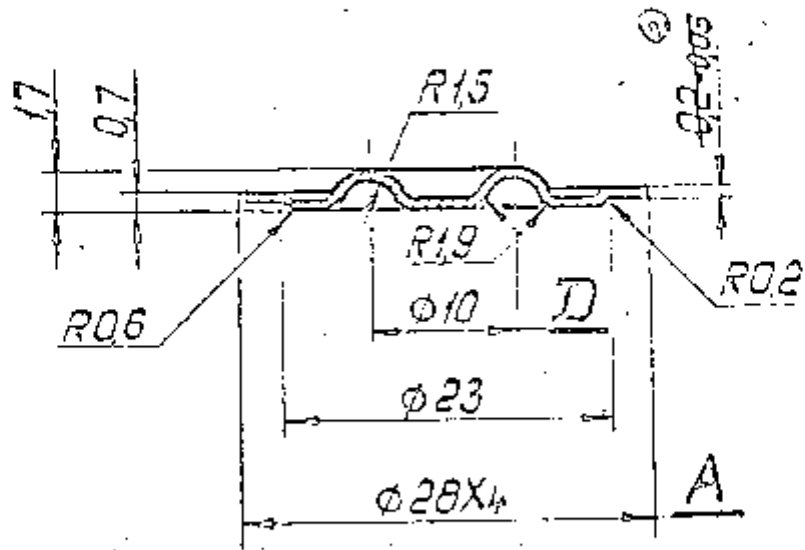
HARDNESS H = 300 TO 380

| | | |
|---|--|---|
| MATERIAL - BRONZE Bp B 2M-02-H ГОСТ 1789-70 | | |
| ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF | ALL THREADS TO CONFORM TO SPECIFICATION | STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFG. |
| DRG. NOT TO BE SCALED | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | USED ON- |
| SCALE - 2:1 | | |
| DATE - | | |
| DRW. K.N.R. | WT - (KG) | <h1>UPPER DIAPHRAM</h1> <h2>AAY-040</h2> |
| TCD. | | |
| CIID. <i>KS</i> | | |
| APD. <i>etc</i> | | |
| CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) 208A-042 | | |

89/107

L70-60V

TOLERANCE ON FREE DIMENSIONS ARE AS PER ACCURACY CLASS.5



LOCAL DECREASE OF SURFACE OF DIA. A TO 0.06 OVER THE ARCS CORRESPONDING TO THE TOTAL CENTRAL ANGLE. OF NO MORE THAN 90° IS ALLOWED

STAMP TOGETHER WITH PART. AAY -040

RUN-OUT OF CORRUGATED SURFACES D WITH RESPECT TO SURFACE A SHOULD NOT EXCEED 0.1 (Ensured Technologically)

TOLERANCE ON FREE DIMENSIONS ARE AS PER ACCURACY CLASS.5.

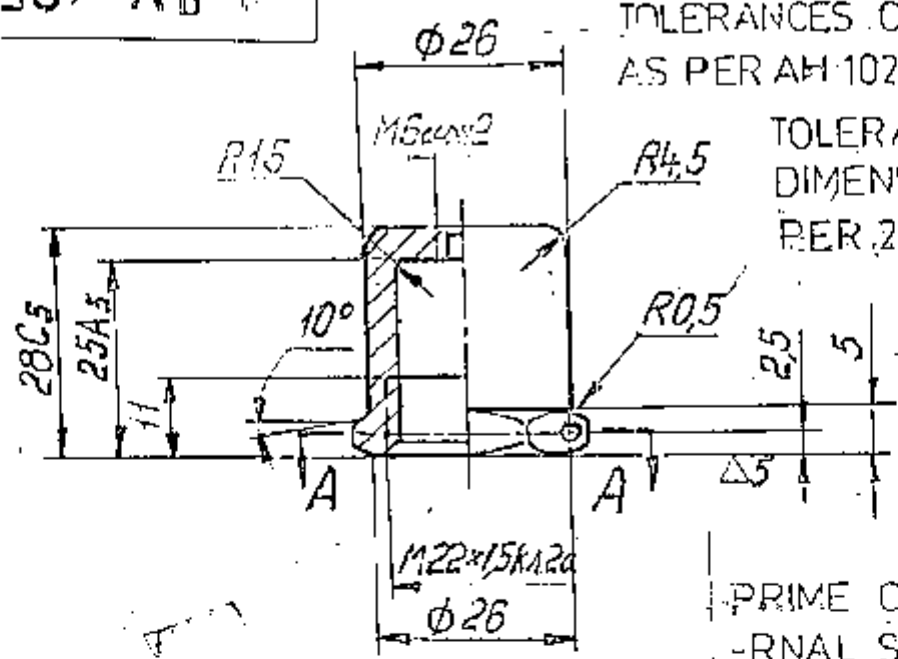
| | | |
|--|---|---|
| MATERIAL - BRONZE BPS 2M-0.2H GOST 1789-70 | | |
| ALL SHARP EDGES & CORNERS TO BE ROUNDED D.G. NOT TO BE COILED | ALL THREADS TO CONFORM TO SPECIFICATION | STAMP OR ETCH, PART NO. MANUFACTURERS HAVE A YEAR OF LIFE |
| SCALE - 2:1 | TOLERANCE ON DIMENSIONS IS UNLESS OTHERWISE SPECIFIED | USED NR- 76S-78-C06 |
| DATE - 10.8.95 | <h2>LOWER DIAPHRAGM</h2> <h3>AAY-041</h3> | |
| DRY <i>Am</i> | | |
| TED <i>Am</i> | | |
| END <i>Am</i> | | |
| APP. <i>Am</i> | 208A-041 | |

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

89/107

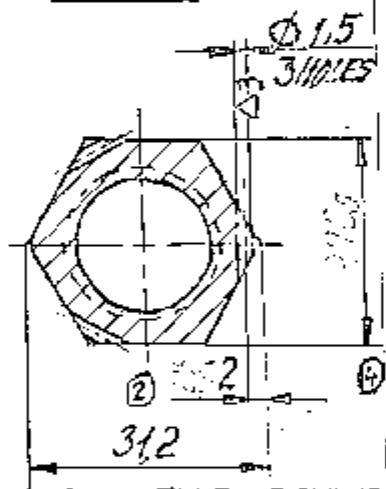
AY-057

UNLESS SPECIFIED, OTHERWISE TOLERANCES ON CASTING ARE AS PER AM-1026-55 (56-15)



TOLERANCES ON FREE DIMENSIONS ARE AS PER 22 AT 52-CLASS 7.

A-A



PRIME COAT THE EXTERNAL SURFACE, EXCEPT PLACES WHICH ARE MACHINED, WITH YELLOW PRIMER FCP-031 WITH 50% ALLUMINIUM POWDER PAW4 APPLY ONE LAYER OF ENAMEL I 820 ANODIZE.

PRESSURE DIE CASTING ACCURACY CLASS AT 3.

IT IS ALLOWED TO STOP DRILL THE LOCKING HOLES. MAKE CHAMBERS TO A DEPTH OF THREAD AT AN ANGLE 90° TO 120°

| | | |
|------------------------------|------------------------------------|---------------------------|
| MATERIAL | ALUMINIUM ALLOY A99 OST 1900 21-71 | |
| ALL DIMENSIONS ARE IN INCHES | ALL DIMENSIONS TO CONFORM TO | STAMP OR STOR. PART NO. |
| DWG NOT TO BE REPROD. | AS SHOWN | MANUFACTURERS MAKE 1 YEAR |
| SCALE: | 1:1 | OF 1982 |
| DATE: 10.8.95 | DESIGNED BY: [Signature] | USED NO- 765-78-C86 |
| DRW: [Signature] | CHKD BY: [Signature] | |
| TOP: [Signature] | | |
| ENG: [Signature] | | |

CAP

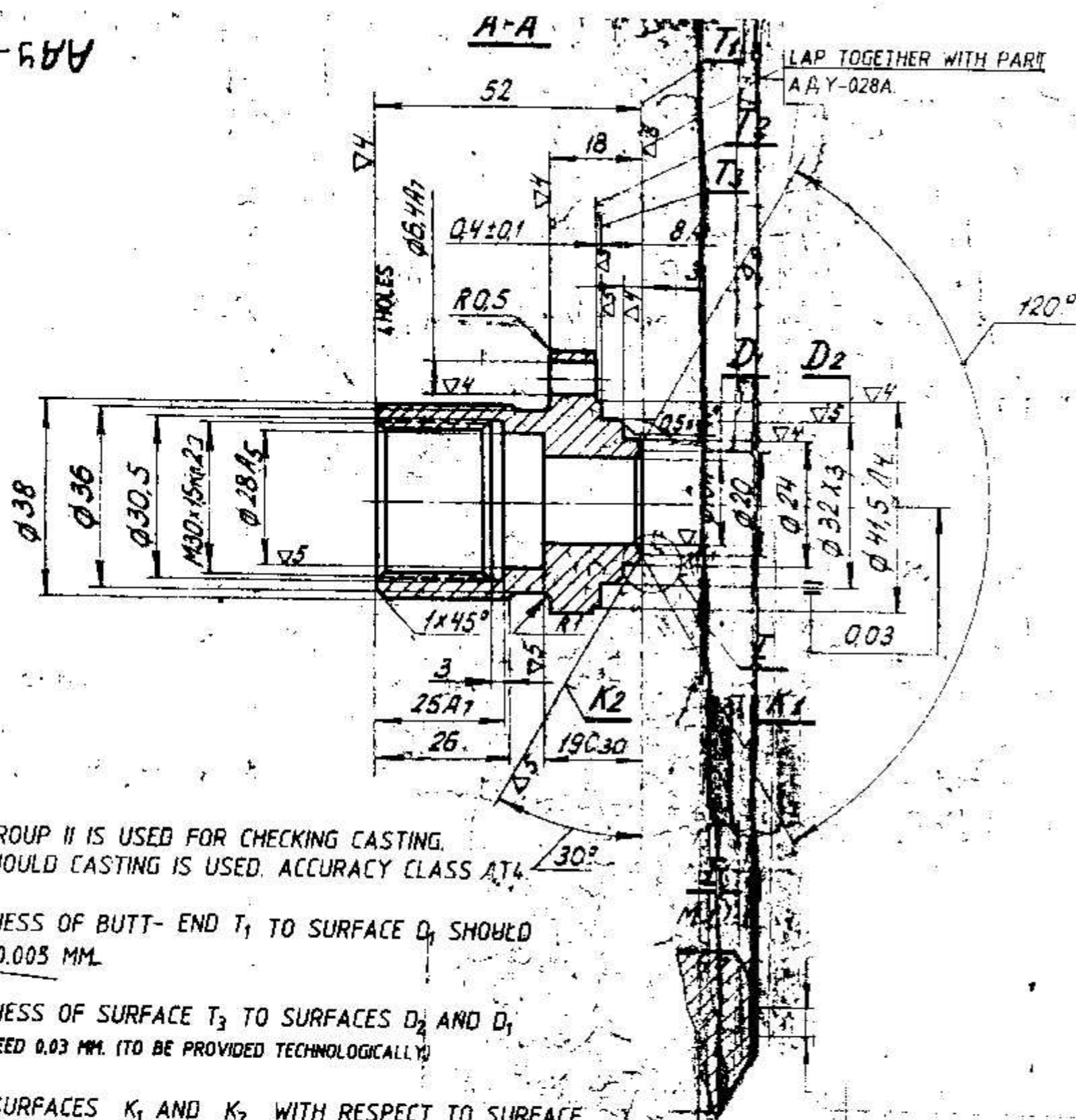
AY-057

AY-005

CONTROLLED BY QUALITY ASSURANCE (INVENTORY CONTROL VEHICLES)

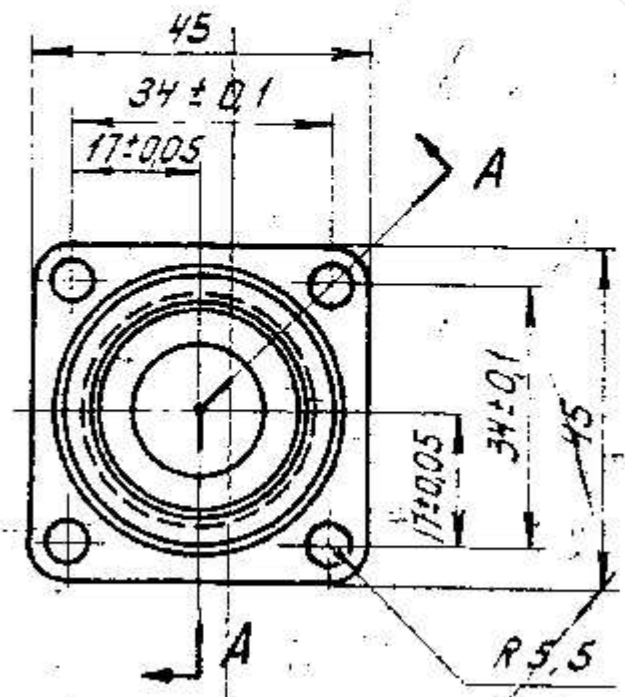
90/107

AA5-058A



LAP TOGETHER WITH PART
AA5-028A.

UNLESS OTHERWISE SPECIFIED
TOLERANCE ON FREE DIMENSIONS ARE AS
PER 22 AT 52 - C1, 7.
TOLERANCE ON CASTING ARE AS PER
AA1026 - 55/56 - 15Z.



HARDNESS HB ≥ 70
ANODIZE, EXCEPT SURFACE T₁, T₂, T₃, D₁, D₂, K₁, K₂.
HOLE MACHINING PROVIDE CIRCULAR AREA 0.3 TO 0.5 mm WIDE.
DENTS AND SCRATCHES ARE NOT ALLOWED.
PRIME EXTERNAL SURFACES, EXCEPT FOR PLACES TO BE MACHINED,
BY YELLOW PRIMER FØ-031 CONTAINING 5% OF ALUMINIUM POWDER
AA2, GOST 5494-71, AND PAINT IT WITH LAYER OF ENAMEL FØ-820.

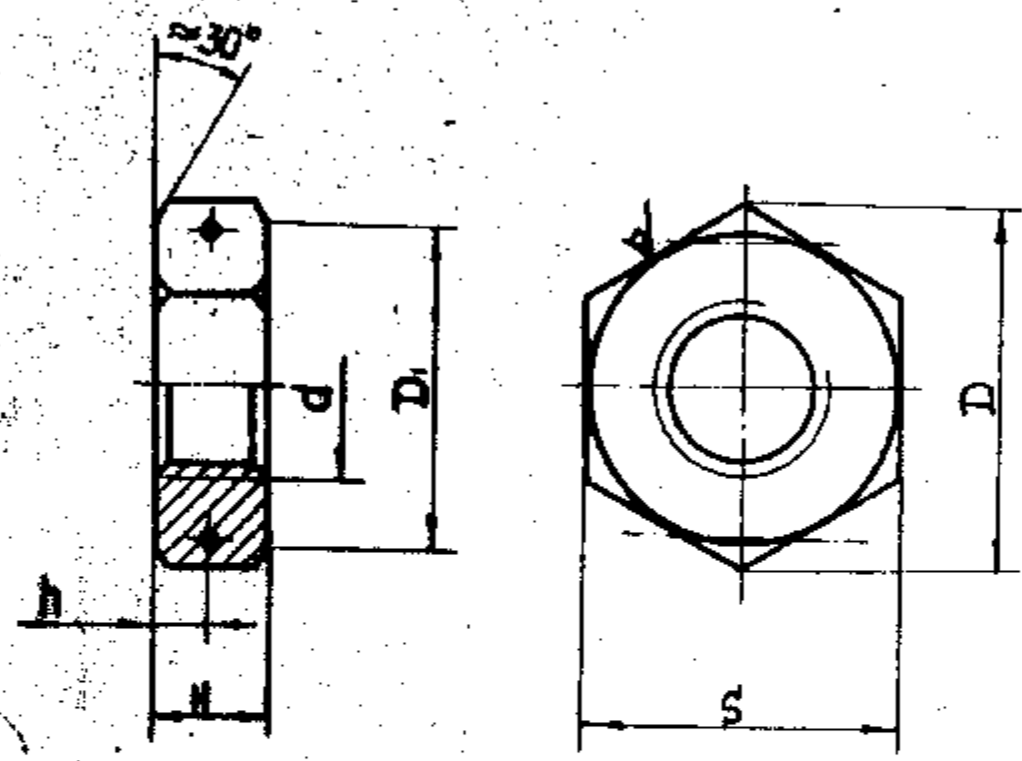
INSPECTION GROUP II IS USED FOR CHECKING CASTING.
PERMANENT MOULD CASTING IS USED. ACCURACY CLASS AT4.
NON SQUARENESS OF BUTT- END T₁ TO SURFACE D₁ SHOULD
NOT EXCEED 0.005 MM.
NON SQUARENESS OF SURFACE T₃ TO SURFACES D₂ AND D₁
SHOULD NOT EXCEED 0.03 MM. (TO BE PROVIDED TECHNOLOGICALLY)
RUN OUT OF SURFACES K₁ AND K₂ WITH RESPECT TO SURFACE
D₁ SHOULD NOT EXCEED 0.05 MM (TO BE PROVIDED TECHNOLOGICALLY)

| | | |
|--|--|---|
| MATERIAL: ALUMINIUM ALLOY AA5 GOST 190021-71 | | |
| ALL SHARP EDGES & CORNERS TO BE ROUNDED BY | ALL THREADS TO CONFORM TO SPECIFICATION | STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR. |
| DRG. NOT TO BE SCALED | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | USED ON:- |
| SCALE: 1:1 | | |
| DATE: 10-08-1995 | | |
| DRN: [Signature] | WT: (Kg) | |
| TCD: | | |
| CHD: [Signature] | | |
| APD: [Signature] | | |
| COVER | | |
| AA5-058A | | |
| CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) AA5-058 | | |

91/107

HN

R240
V(V)

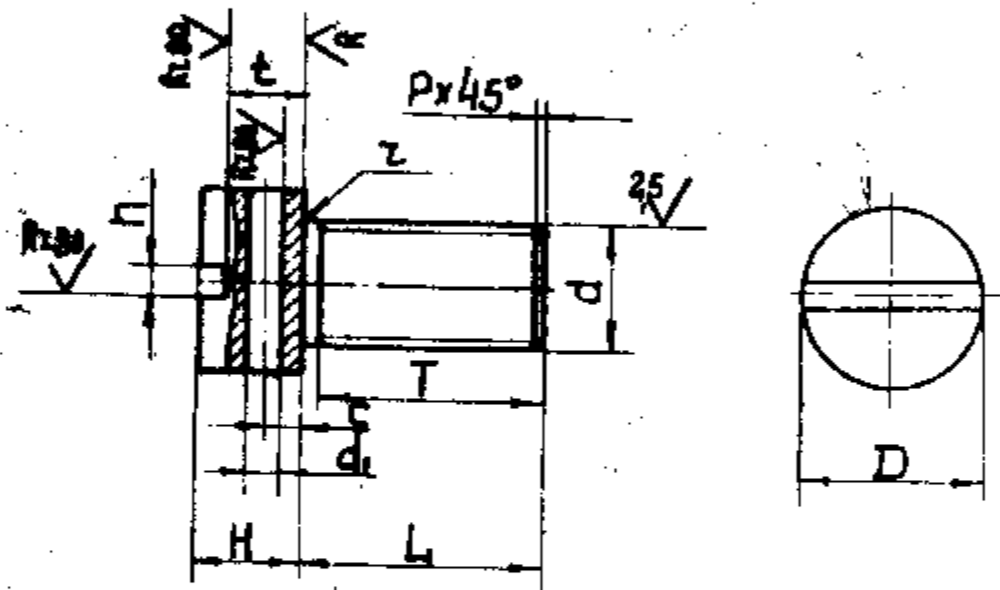


| DESIGNATION | THREAD d | S | $D \approx$ | H PERMISSIBLE DEVIATION AS PER BY | h | MATERIAL | HARDNESS | COATING | WEIGHT IN GRAMS |
|-------------|---------------|-----|-------------|--|-----|-----------------|----------|---------------------------|--------------------|
| K1114 | M10X1-5H16H | 14 | 16,2 | 8,5 | 3 | BRASS AC59-1 | | CHEMICALLY PASSIVATED. | |

1. MATERIAL: ROD AC 59-1 T.W.HNT-14 STEEL 30XGCA.
2. BRASS AC59-1 MAY BE REPLACED BY BRASS A63.
3. THREAD RUN-OUTS CHAMFERS AND RECESSES ARE AS PER OST 100010-71.
4. TECHNICAL SPECIFICATIONS ARE AS PER 102 ATY.
5. PERFORM TWO LOCKING HOLES.
6. $D_1 \approx S$

| | | | |
|--|--|-----------------------------------|--|
| MATERIAL | | STAMP OR ETCH, PART NO. | |
| ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF | ALL THREADS TO CONFORM TO SPECIFICATION | MANUFACTURERS NAME & YEAR OF MFG. | |
| DRG. NOT TO BE SEALED | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | USED ON:- | |
| SCALE 1:- | DATE 12-08-1995 | HEXAGON NUT K1114 | |
| WT 1:- 0.40 | | | |
| CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) | | | |

K 35

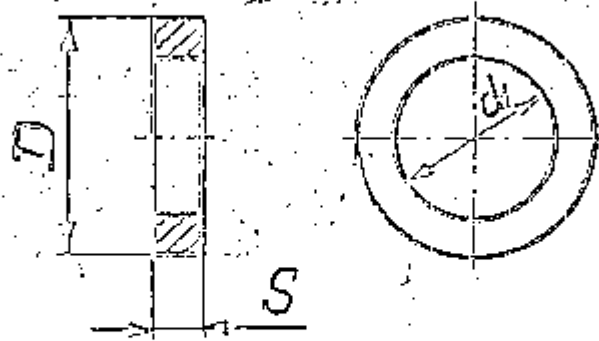


| DESIGNATION | THREAD d | D PERMISSIBLE DEVIATION IS AS PER B ₁ | PERMISSIBLE DEVIATION IS AS PER B ₂ | L | T REFERENCE | n PERMISSIBLE DEVIATION IS AS PER A ₁ | f PERMISSIBLE DEVIATION IS AS PER B ₂ | Z PERMISSIBLE DEVIATION ± 0.2 | d ₁ | C PERMISSIBLE DEVIATION IS AS PER B-7 | P | MATERIAL | HARDNESS | COATING | WEIGHT IN GRS |
|-------------|-------------|---|--|--------|----------------|---|---|----------------------------------|----------------|--|-----|---------------|----------|-----------------------------|---------------|
| K3515 | M6-be | 9 | 5,5 | 24±0,3 | 15 | 1,5 | 3 | 0,5 | 1,5 | 1,6 | 0,7 | STEEL 30XA | HRC 37 | ZINC PHOSPHATE FINISH | 6,8 |

1. MATERIAL: STEEL 30A, TECHNICAL SPECIFICATIONS TY 14-1-950-74.
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS PER 22A T 22
3. TECHNICAL SPECIFICATIONS ARE AS PER 101 ATY
4. STEEL 30XA MAY BE REPLACED BY ALTERNATE STEEL 30XPCA IS AS PER TECHNICAL SPECIFICATIONS TY14-1-950-74 IS ALLOWED.

| | | | | | | | |
|--|--|--|--|--|--|---|--|
| MATERIAL : — | | ALL SHARP EDGES & CORNERS TO BE BOUNDED BY | | ALL THREADS TO CONFORM TO SPECIFICATION | | STAMP ON STEEL PART NO. MANUFACTURING NAME & YEAR OF MFG. | |
| DRG. NOT TO BE SCALED | | SCALE 1:- | | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | | USED ON:- | |
| DATE 10-08-1995 | | DRN [Signature] | | WT (kg) | | SCREW WITH CYLINDRICAL HEAD | |
| TCD | | CHD [Signature] | | APD [Signature] | | FOR METAL | |
| | | | | | | K 3515 | |
| CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) 97/107 | | | | | | | |

K72



| DESIGNATION | NOMINAL DIAMETER OF ROD | d1 PERMISSIBLE DEVIATION AS PER | D PERMISSIBLE DEVIATION AS PER | S | WEIGHT |
|-------------|-------------------------|---------------------------------|--------------------------------|-----|--------|
| | | AS | B7 | | |
| K7213 | 6 | 6,4 | 9 | 0,5 | 0,4 |
| | | | | | |

1. COATING: ZINC-PLATED, 9 TO 18 MICRONS THICK.
2. TECHNICAL SPECIFICATIONS ARE AS PER 103 AT 9.
3. STEEL 20, MAY BE REPLACED WITH STEEL 30XГСА, GOST 11268-76.

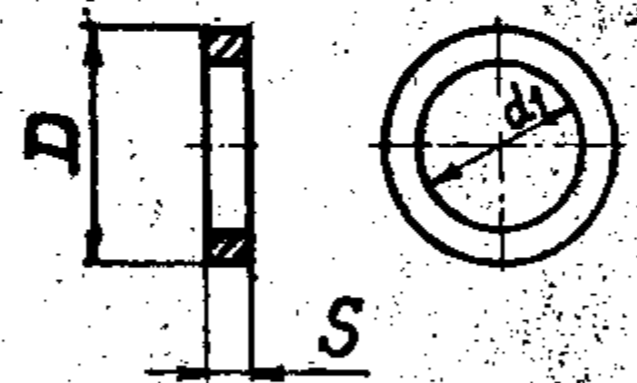
Справ. № _____
Конт. № _____
Мат. № _____
Склад. № _____

| | | |
|---|---------|--------------------------------------|
| MATERIAL SHEET ^{STEEL 20} 6 05 ГОСТ 16523-70 | | GROUP OR ETCH, PART NO. |
| ALL DIMENSIONS TO BE DIMENSIONED TO CENTER UNLESS OTHERWISE SPECIFIED | | MANUFACTURERS NAME & YEAR OF MFG. |
| SCALE: 1:1 | | USED ON: 765-78-C86 |
| DATE: 10.8.95 | | |
| APP. <i>[Signature]</i> | MT: K81 | <h1>STEL WASHER</h1> <h2>K 7213</h2> |
| TCO. <i>[Signature]</i> | | |
| CHD. <i>[Signature]</i> | | |
| W.D. <i>[Signature]</i> | | |

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

99/107

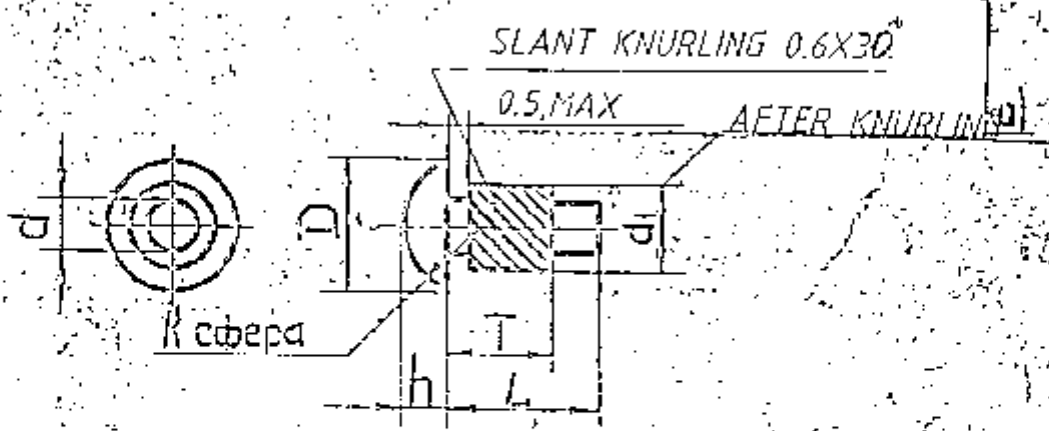
K73



| DESIGNATION | STANDARD DIAMETER OF ROD | BY PERMISSIBLE DEVIATION ± IS AS PER AS | D | S | MATERIAL | COATING | WEIGHT IN GRAMS |
|-------------|--------------------------|---|------|-----|----------------|---------|-----------------|
| K7309 | 6 | 6,4 | 12B7 | 1,5 | ALUMINIUM AP1M | | 0,3 |

1. MATERIAL: ALLUMINIUM AP1M AND ALLUMINIUM ALLONG AP1AM, GOST 21831-76.
2. TOLERANCE FOR DIMENSIONS S IS EQUAL TO TOLERANCE FOR THICKNESS OF MATERIAL DELIVERED.

| | | | | | | | |
|-----------------------|----------------|---|-----------------|--|--|--|--|
| MATERIAL : — | | ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF | | ALL THREADS TO CONFORM TO SPECIFICATION | | STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFG. | |
| DRG: NOT TO BE SCALED | | SCALE 1:- | | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | | USED ON:- | |
| DATE 1-10-00-1995 | | WT (KG) | | FINISHED FROM NON-FERROUS | | K7309 | |
| DRN. [Signature] | VD [Signature] | CHD [Signature] | APD [Signature] | | | CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) 100/107 | |



| PART DESIGNATION | d_1 | d | L | h | T | R | NUMBER OF THREADS | DIAMETER OF HOLE FOR RIVET | DEPTH OF HOLE FOR RIVET | THEORETICAL HEIGHT OF IPC |
|------------------|-------|-----------------|----------------|-----|-----|-----|-------------------|----------------------------|-------------------------|---------------------------|
| K4001 | 2.2 | 1.88 ± 0.02 | 3.7 ± 0.15 | 1.5 | 4.5 | 3.5 | 2 | 1.9 A ₁ | 4.5 ± 0.5 | 0.185 |

1. IT IS ALLOWED TO MAKE RIVETS FROM STEEL, GRADE 10 OR 15. GOST 1051-73
2. UNPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS PER 22AT52.
3. COATING: ZINC-PLATED, 12 TO 18 MICRONS THICK.

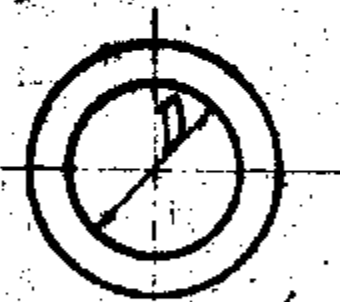
| | | | |
|---|-------------------------|--|------------------|
| MATERIAL: STEEL 20 GOST 1051-73 | | STAMP OR ETCH, PART NO. MANUFACTURERS PLANE 3 YEAR OF 1987 | |
| HEAD TYPE: 10-8-95 | SCALE: 5:1 | ALL THREADS TO CONFORM TO SPECIFICATION | USED: 765-78-056 |
| DRY: <i>[Signature]</i> | CHK: <i>[Signature]</i> | TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED | |
| SCREW RIVET | | | |
| H4001 | | | |
| CONTROL STATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) | | 98/107 | |

FROM BRANCH AND FACTORY STANDARDS.

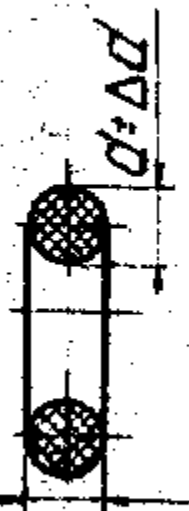
HA 80

ROUND-SECTION SEALING RINGS SUMMARY TABLE.

SEALING RING



$d \pm \Delta d_1$



MATERIAL : RUBBER MIX. 3034;
 B-14: 98-1: 3465-M-4: 3025-4326-1: 4327-AS PER
 TECHNICAL SPECIFICATIONS TY 38005.1166-73.
 UPn 1078-
 UPn 1078-
 TECHNICAL SPECIFICATIONS.

| PART DESIGNATION. | | D | d±Δd | d± Δ d ₁ | MATERIAL. | WEIGHT. |
|-------------------|---------------|-----------|-------------------------------------|---------------------|--------------|---------|
| STANDARD. | FACTORY CODE. | | | | | |
| | HU 40-017 | 24±0,15 | 2,5±0,1 | | RUBBER 3825 | |
| | Γ A77-115 | 24,6±0,15 | 27±0,1 | | RUBBER 98-1 | |
| %2619C52-25-2-A % | * | 25-0,4 | 2 ^{+0,2} _{-0,1} | | RUBBER 3825. | |
| %2619C52-25-3-Γ % | | 25-0,4 | 3 ^{+0,25} _{-0,15} | | RUBBER 4327. | |
| %2609C52-25-3-Γ % | | 25 -0,4 | 3 ^{+0,25} _{-0,15} | | RUBBER 4327. | |

CONTROLLERATE OF QUALITY ASSURANCE
 (INFANTRY COMBAT VEHICLES)

ANGLE OF PARTING OF MOULD FOR RINGS TO BE MADE
 AS PER STANDARD 2619C52 IS 45°.

| | | |
|-------|------|---------|
| NAME | AD | 10/8/98 |
| GROUP | 14 | A |
| T.C. | 80 | |
| NAME | SIGN | DATE |

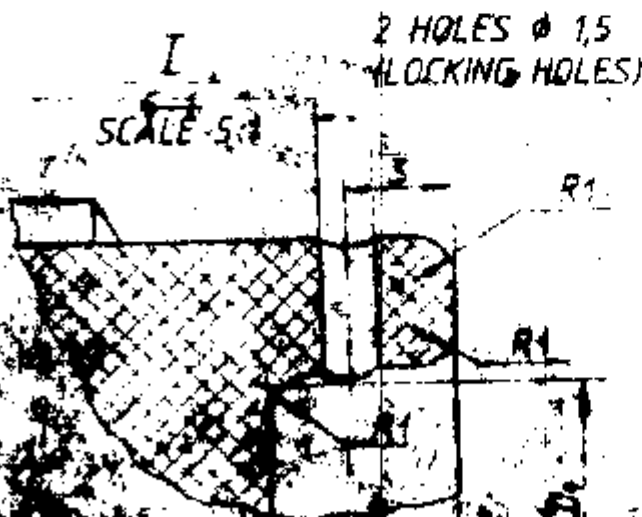
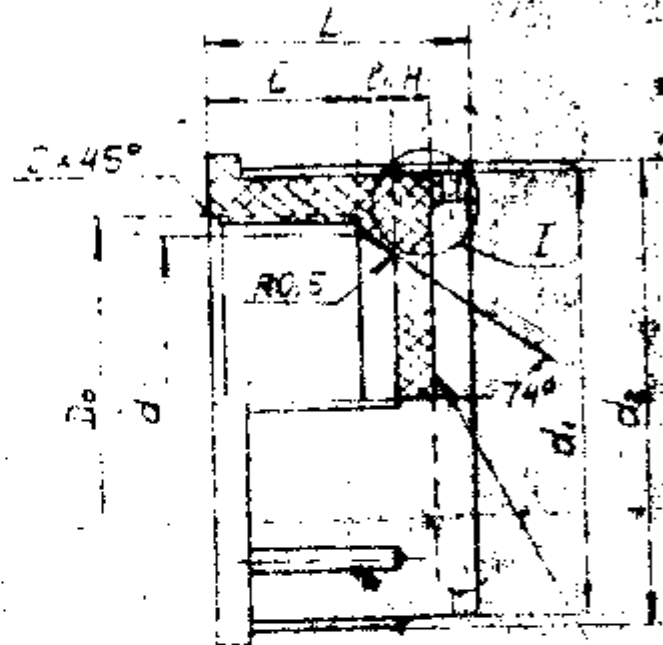
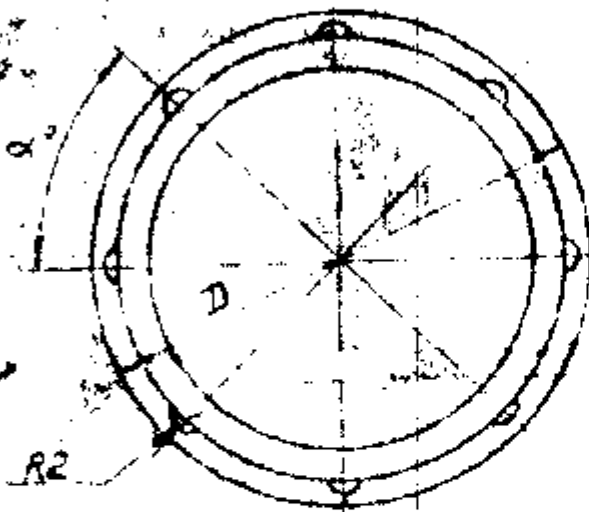
41/107

Beepo NUC133 / NUC1N 24

HBT 226.

PROTECTIVE CAPS.

PROTECTIVE CAPS ARE USED FOR PROTECTING THE UNITS AND PIPE LINES FROM CLOGGING AND ALSO FOR PROTECTING THREADS OF PARTS FROM DAMAGE DURING TRANSPORTATION AND STORAGE.



MARK DIA AND PITCH, THREAD
EX. 12x1.5
TYPE no-2.5 TO 5, GOST 2930-62,
HEIGHT OF EMBOSSED MARK IS
0.2 TO 0.4 MM.

EXAMPLE OF CAP DESIGNATION WITH THREAD M12x1.5
HBT 226 - M12x1.5

93/107