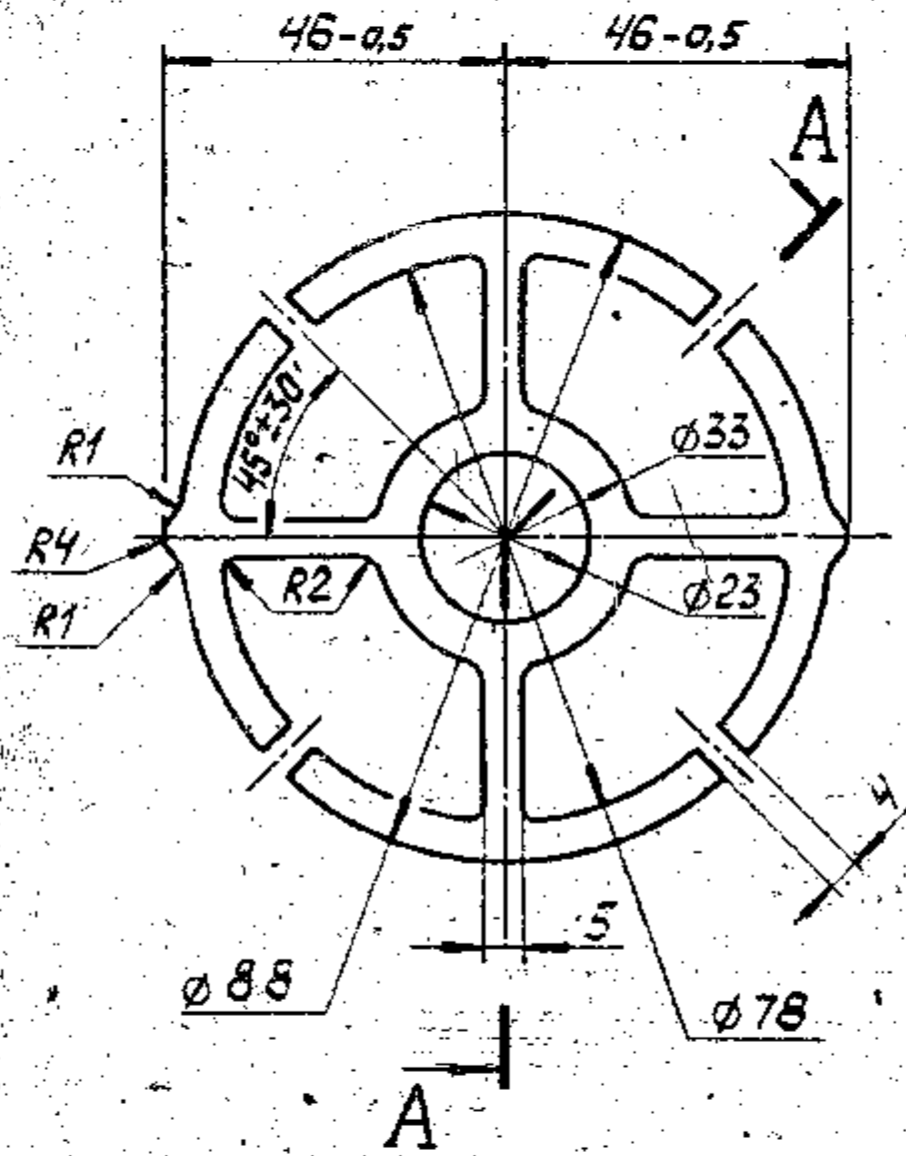


529-37A

0-10



A-A

1. ALL DIMENSIONS ARE PROVIDED WITH TOOL.
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:
FOR HOLES - AS PER A, FOR SHAFTS - AS PER B, OTHERS - AS PER CM.
3. STAMP FINAL ACCEPTANCE AND MARK DATE OF MANUFACTURE OF BATCH OF PARTS ON THE LABEL.
4. OTHER TECHNICAL REQUIREMENTS ARE AS PER OST 4 TO 005.051.
5. IT IS PERMITTED TO USE CAPRONE WASTES (GATES AND REJECTED PARTS) OF UPTO 30 PERCENT.

** POLYAMID PA6-21 SECONDARY
OST 6-06-C4-79

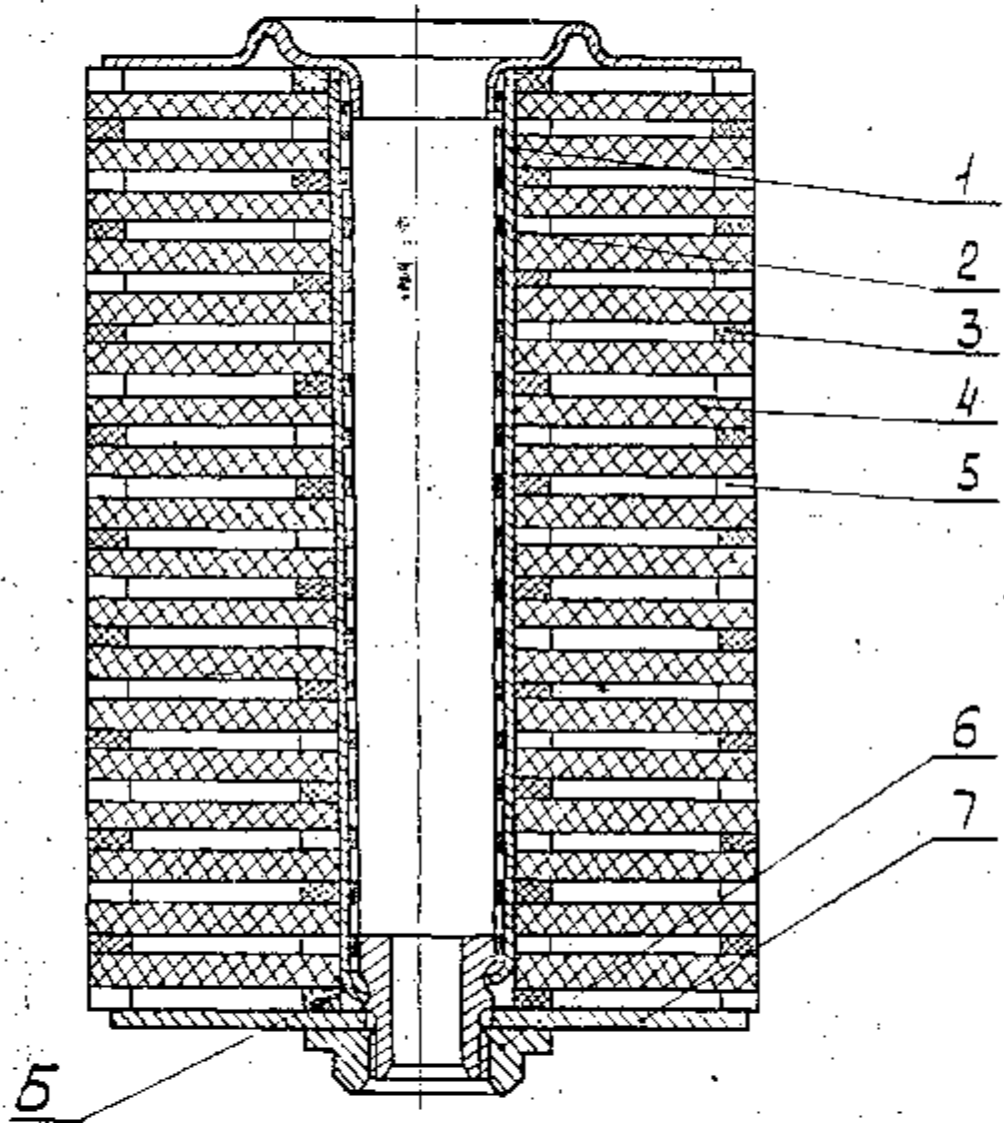
PILOT SAMPLE SHOULD BE APPROVED BY A.I.S.P BEFORE BULK PRODUCTION

EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)
0,005 Kg	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R-VALUE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
AUTHY LT No. 293087	USED CN. CB 329-05-1A CB 329-05
ISSUE DATE 29/08/79	MATERIAL: * SEE ABOVE
DRN [Signature]	SCALE: 1:1
CHO [Signature]	DIMENSIONS IN mm
TCD [Signature]	TOLERANCE ON DIMS UNLESS OTHERWISE STATED
APPD [Signature]	ALL UNITS TO
DATE 10/09/79	
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
TITLE	INLET SPACER
DWG NUMBER	529.37A
U.S.CAT NUMBER	

APPROVED BY

(D.K.)





1. WASH THOROUGHLY ALL THE PARTS OF FILTERING ELEMENT BEFORE ASSEMBLY. FELT PARTS AND FILTER BAG SHOULD BE WASHED IN FILTERED BENZINE OR KEROSENE.
2. PUT FILTER BAG ON THE GAUZE. TIGHTEN CORD IN GROOVE 6 TILL GROOVE INNER DIAMETER HAVING TIED IT BY SINGLE KNOT.
3. WIND KNOT END 1-2 TIMES ROUND THE GAUZE BY GROOVE, EVERY TIME TIEING THEM BY SINGLE KNOT.
4. ALTERNATION OF INLET AND EXHAUST INSERTIONS AND FELT DISCS SHOULD CORRESPOND TO THE DRAWING AND MOREOVER INLET INSERTION SHOULD BE THE FIRST.
5. PROTRUSIONS ON THE INSERTIONS SHOULD BE IN ONE PLANE.
6. WHEN ASSEMBLING FILTERING ELEMENT, EXTREME INLET INSERTIONS 529-37 A SHOULD ADJOIN TO FELT DISCS BY SIDES HAVING TRACES FROM PRESSMOULD.

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

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS
		0.470 Kg	LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE - 1:1	MATERIAL - USED ON: CB 20-29-00-8
CHK		DIMENSIONS IN MM	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVACH
TCD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE - ASSY FILTERING ELEMENT
APPR		ALL THREADS CONFORM TO	D S CAT NUMBER SHEET 1 OF 2
DATE	23.9.86		DRAWING NUMBER CB 329-05



USED ON

CB 20-29-00-g

ITEM	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	QTY	
					UTD
	CB 329-05		ASSY FILTERING ELEMENT		
	& ITEM LIST				
			<u>ASSEMBLY UNITS</u>		
1	CB 329-07-2		FILTER BAG ASSY	1	
	& ITEM LIST				
2	CB 329-02-3		FILTER GAUZE ASSY	1	
	& ITEM LIST				
			<u>PARTS</u>		
3	529-34-1 A		EXHAUST INSERTION	9	
4	329-25-1		RING CT88-24-5 GOST 288-72	18	
5	529-37 A		INLET INSERTION	10	
6	329-38-1		NUT	1	
7	329-36-3 A		CLAMPING PLATE	1	

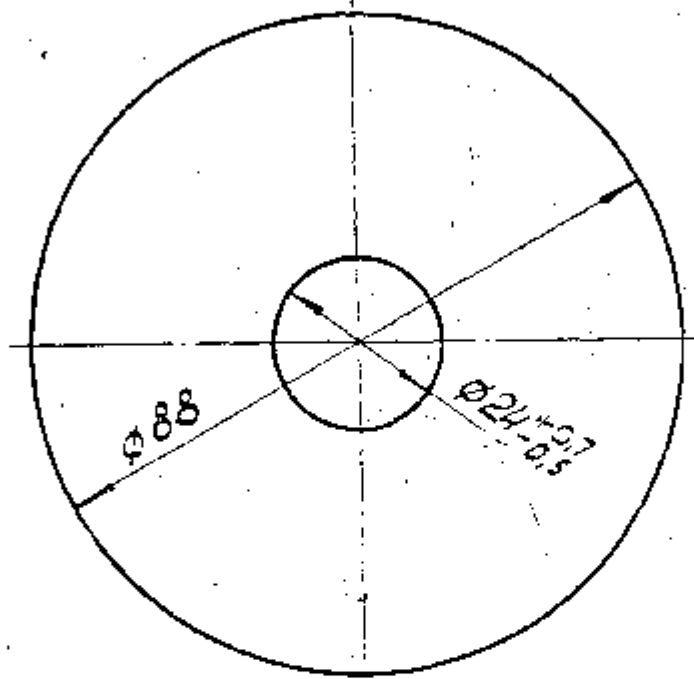
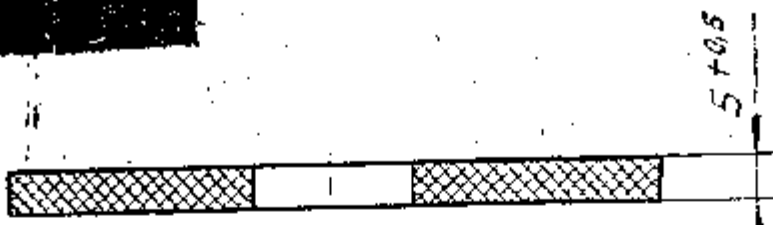
ISSUE DATE	NATURE OF AMENDMENTS	ISSUE DATE	NATURE OF AMENDMENTS
DRN		CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI	
CHD	<i>VGA</i> <i>P. J. ...</i>	TITLE: ASSY FILTERING ELEMENT	
TCO	<i>A. Changanay</i>	D S CAT NUMBER	ITEM LIST FOR
APPD	<i>...</i>		CB 329-05
DATE	23.9.86	SHT. No OF	

UTD



F-90-602

Верно: Нач бюро, от Давыдов В. Н.



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

1. VOLUME MASS IS $0.38 \pm \begin{matrix} 0.02 \\ 0.01 \end{matrix} \text{ g/cm}^3$

RING NPT 88-24-5 GOST 288-72 IS ALLOWED

VOLUME MASS IS $0.38 \pm \begin{matrix} 0.02 \\ 0.01 \end{matrix} \text{ g/cm}^3$

MAKE THE PART acc TO GOST 15159-76 FOR THE TROPICS.

* Кольцо

CT88-24-5 GOST 288-72

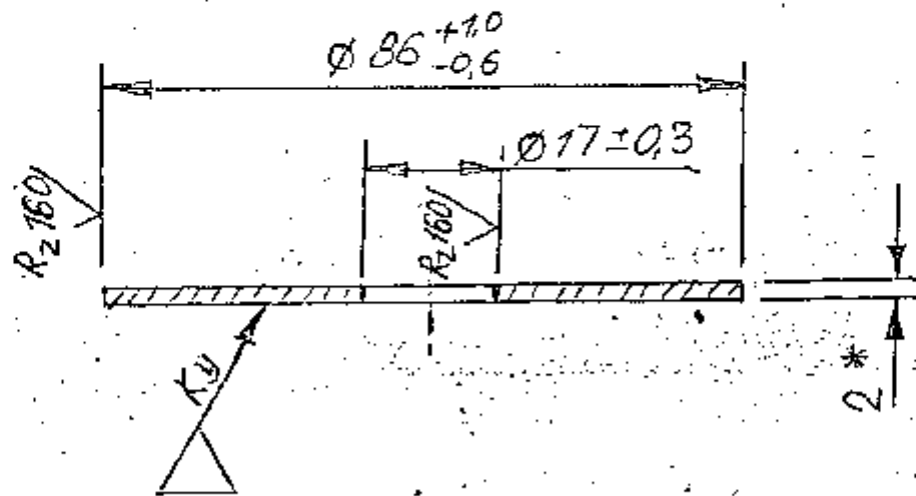
		EST. MASS 0.011 kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS (LETTERS)
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL: - * SEE ABOVE	USED ON: - CB 329-05
CHD	SCALE - 1 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD	
TEC	DIMENSIONS IN mm	TITLE: - RING	
APPO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	
DATE	ALL THREADS CONFORM TO	DRAWING NUMBER 329-25-1	

Г. У. В. А. М. А.

23-9-86



DRAWING NUMBER
329-36-3A



1. ALTERNATE MATERIAL IS SHEET 15 GOST 19904-74 AND ALLOYS 163, GOST 931-70, A16ATH, A16AM, GOST 21631-76 AND A16YM TY-1-4, -23-72
2. IT IS ALLOWED TO APPLY STAMP ON THE TAG (PART 540-551) FOR BATCH OF PARTS AND SEAL
3. * DIMENSION IS GIVEN FOR REFERENCE.

EXPLANATORY NOTE:-

MATERIAL QUOTED:- SHEET A16AT-2 GOST 21631-76

A16 = GRADE OF ALUMINIUM ALLOY.

A = CLADDED; T = HARDENED AND NATURALLY AGED.

2 = THICKNESS.

CHEMICAL COMPOSITION:- %

A D M I X T U R E S									
AL	IRON	Si	Cu	Mn	Zn	Ti	Mg	OTHER ADMIXTURES EACH SEPARATELY	TOTAL
99.50 (MIN)	MAXIMUM							0.02	0.70
	0.30	0.30	0.02	0.025	0.10	0.15	0.05		

MECHANICAL PROPERTIES:-

TENSILE STRENGTH Kgf/mm^2 = 15.0-23.0

% ELONGATION = 10

**
Cb 329-05-1
A Cb 329-05-1
Cb 329-05

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

EST. WT. TO BE STAMPED OR MARKED WHERE INDICATED THUS $\frac{1}{2}$ LETTERS!
0.031 kg

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

DRN	APPROVED	MATERIAL:- SHEET A16AT -2 GOST 21631-76	USED ON
CHD	Jana.		** SEE ABOVE
TCD			
APPD			
DATE	22.12.83	CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
SCALE:-	1:1		
DIMENSIONS IN mm TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS:2102-69		TITLE PRESSURE PLATE	
ALL THREADS TO CONFORM TO		D S CAT NUMBER	DRAWING NUMBER
A	27.10.97 AUTHY LTN. 90215/AHSP/ED/AL dt 17.10.97		329-36-3A
ISSUE DATE	NATURE OF AMENDMENTS		



SIZE A3



EXPLANATORY NOTE :-

4. MATERIAL COATED : ROUND BAR 25-4 GOST 7417-75
45-B GOST 1050-74

25 = EXTERNAL DIAMETER , CLASS OF ACCURACY = 4

6 = GROUP OF SURFACE QUALITY , 45 = GRADE OF STEEL.

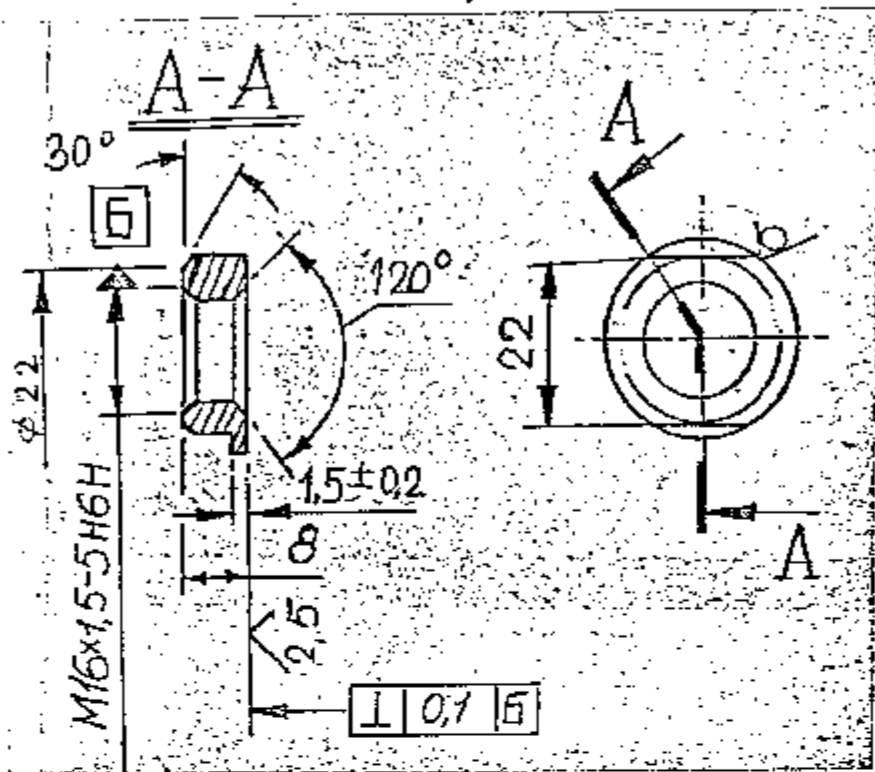
a) CHEMICAL COMPOSITION : (AS PER GOST 1050-74)

C = 0.42 - 0.50 , Si = 0.17 - 0.37 , Mn = 0.50 - 0.80

Cr = 0.25
 P = 0.035
 Cu = 0.25
 S = 0.040
 Ni = 0.25 } maximum

b) MECHANICAL PROPERTIES : (AS PER GOST 1050-74)

TENSILE STRENGTH Kgf/mm² (min) = 61
 YIELD POINT Kgf/mm² (min) = 36
 % ELONGATION (min) = 16
 % REDUCTION IN AREA (min) = 40
 IMPACT STRENGTH Kgf.m/cm² = 5 (min)



1. UNSPECIFIED LIMIT DEVIATIONS ARE AS FOLLOWS :-

FOR HOLES - AS PER A7.
 FOR SHAFTS - AS PER B7.
 FOR OTHERS - AS PER C7.

2. COATING : ZINC PLATED, 9 MICRONS THICK OILED WITH DEHYDROGENATION.
 NO COATING ON THREAD IS PERMITTED.

3. CHECK DIMENSIONS BEFORE APPLYING COATING.

KVD No: 63522

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

EST. WT. 0.016 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS $\frac{1}{2}$ (LETTERS)

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

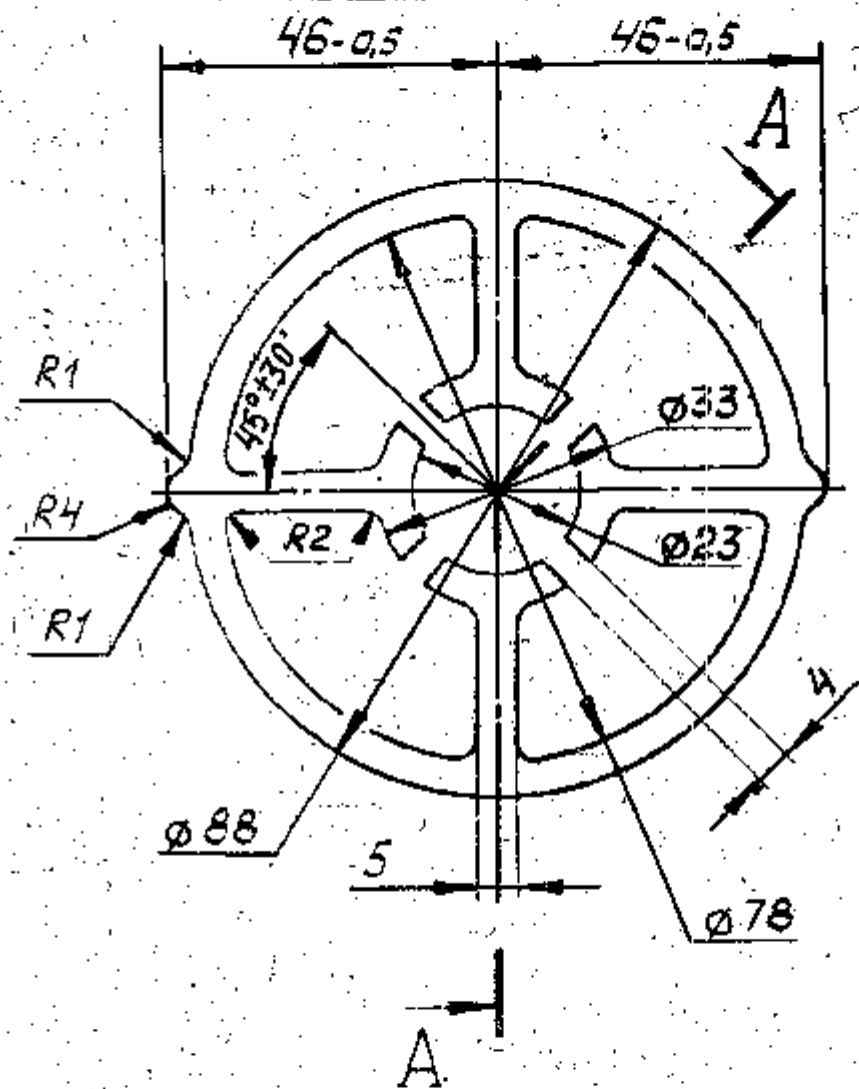
DRN	dy	MATERIAL:-	USED ON:
ED	dy	ROUND BAR 25-4 GOST 7417-75	ED 329-05-1 (A)
TEO	dy	45-B GOST 1050-74	CB 329-05
APPD	dy	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	7.10.83	AVADI	
SCALE:- 1 : 1		TITLE	
DIMENSIONS IN mm		NUT M 16	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS:2102-63		D S CAT NUMBER	
ALL THREADS TO CONFORM TO		DRAWING NUMBER	
A 29.10.97/AUTHY LT.No.90215/AHSP/ED/AL ^{dy} 27.10.97		329-38-1	
ISSUE DATE	NATURE OF AMENDMENTS		



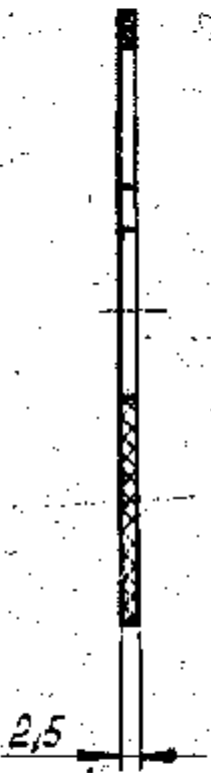


529-34-1A

Вспомогательная техническая чертёж
 Версия: 01/10/87



A-A



1. ALL DIMENSIONS ARE PROVIDED WITH TOOLS.
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:-
 FOR HOLES - AS PER A7,
 SHAFTS - AS PER B7,
 OTHERS - AS PER CM7.
3. STAMP FINAL ACCEPTANCE AND MARK DATE OF MANUFACTURE OF BATCH OF PARTS ON THE LABEL.
4. OTHER TECHNICAL REQUIREMENTS ARE AS PER OST 4 005.051.
5. IT IS PERMITTED TO USE CAPRONE WASTES (GATES AND REJECTED PARTS) OF UP TO 30 PER CENT.

** POLYAMIDE ПA6-21 SECONDARY
 SET 606-C4-79

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

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS IN LETTERS I
		0,005 Kg	
A	29.10.97	AUTHY LT.No. 902157	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED FLIPPED CORNERS TO HAVE R. OUTSIDE
ISSUE	DATE	AHSP/ED/AL 17.10.97	IF INSIDE EQUIPMENT CHANGERS ARE PERMISSIBLE
DRN	SCALE	1:1	MATERIAL - SEE ABOVE
CMO	DRAWING IN	mm	USED ON - 6329-05 (A) 6329-05
TCO	TOLERANCE ON DIMS	UNLESS OTHERWISE SPECIFIED	CONTROL RATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVA 91
APPR	DATE	30-12-87	OUTLET SPACER
		DRAWING NUMBER	DRAWING NUMBER
		529-34-1A	529-34-1A

Вспомогательная техническая чертёж
 Версия: 01/10/87

