

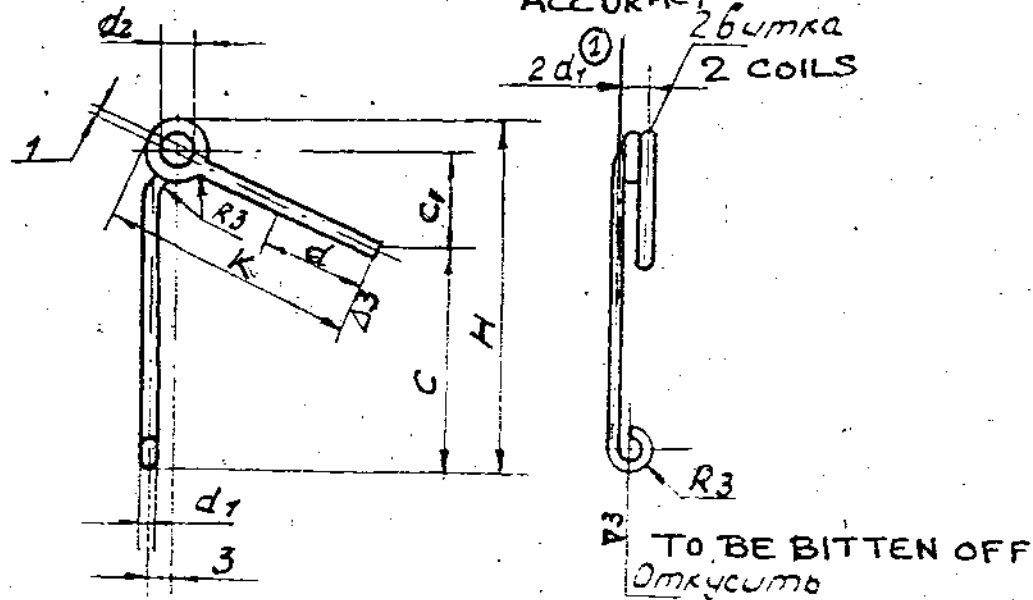
DRAWING NUMBER

92 1106 232

8901166

Допуски на свободные размеры по 7 кл. точности

TOLERANCE FOR FREE DIMENSIONS AS PER ACCURACY CLASS 7



COMPONENT DETAIL No.	TUBE No.		H	C	C _r	K	d _r	d ₂	Sec	Coils
	570	730								
8901166	INNER 73	OUTER 75	46	28,3	13,7	40 ⁺¹	2 ^{+0,04} -0,01	4		

TO BE ANNEALED ON LENGTH d = 13 - 14mm.

TO BE MARKED ON A TAG.

COATING: Cd 9, CHROMATIZING.

HEAT TREATMENT - TEMPERING.

EXPLANATORY NOTE:

1. REFERENCE MATERIAL QUOTED:

SPRING WIRE CATEGORY II 'A' HIGH MANUFACTURING ACCURACY

2 (±0.02) mm DIA TO GOST 9389-75 AND MANUFACTURED IN ACCORDANCE WITH QUALITY CARBON STRUCTURAL STEEL GRADE 70 TO GOST 1050-74

a) CHEMICAL COMPOSITION AS PER GOST 1050-74

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C	Si	Mn	Cr	S	P	Cu	Ni
70	0.67 0.75	0.17 0.37	0.50 0.80	0.25	0.040	0.035	0.25	0.25

b) MECHANICAL PROPERTIES OF CATEGORY II 'A' WIRE AS PER GOST 9389-75

TENSILE STRENGTH Kg/mm ²	No. OF BENDS Min (2d)	No. OF TWISTS Min
180 - 210	9	23

1A EQUIVALENT MATERIAL
Gr. SM/SH IS:4454-2001

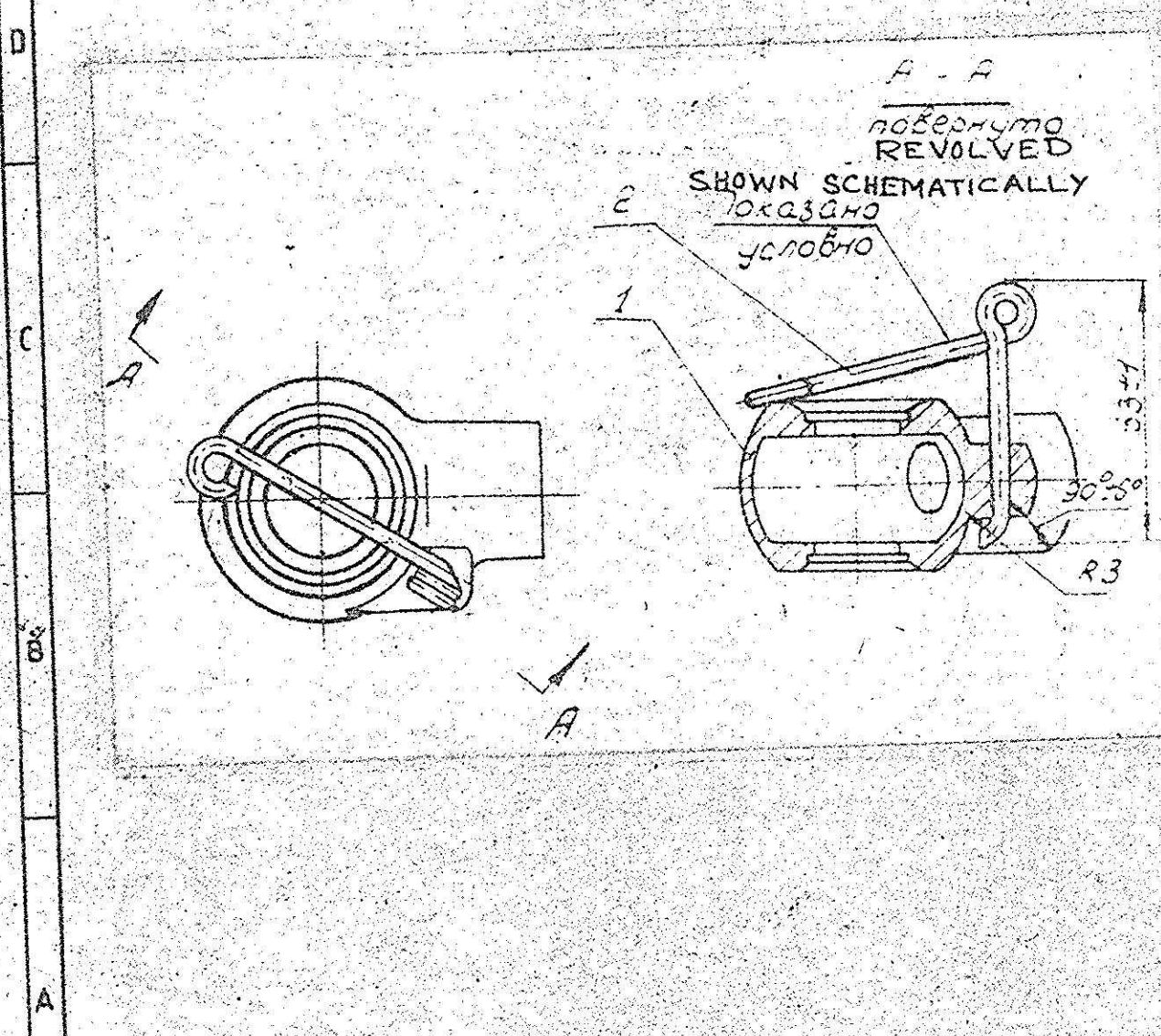
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

EST WT 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

DRN	CHD	TCD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	ALL THREADS TO CONFORM TO	MATERIAL:	USED ON:
									WIRE II A-2 GOST 9389-75	CB 3335-14-2, 92-1106 240 92 1106 230
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI								TITLE: LOCK SPRING		
D S CAT NUMBER								DRAWING NUMBER 92 1106 232		
ISSUE	DATE	NATURE OF AMENDMENTS								
1A	16-8-10	4 th Alt. Comm. Meeting Minutes Point No.13 Dt:26-10-09								
1	31-5-93	AUTHY. NOTI. NO. HTN 46-120-88								

DRAWING NUMBER
92 1106 240



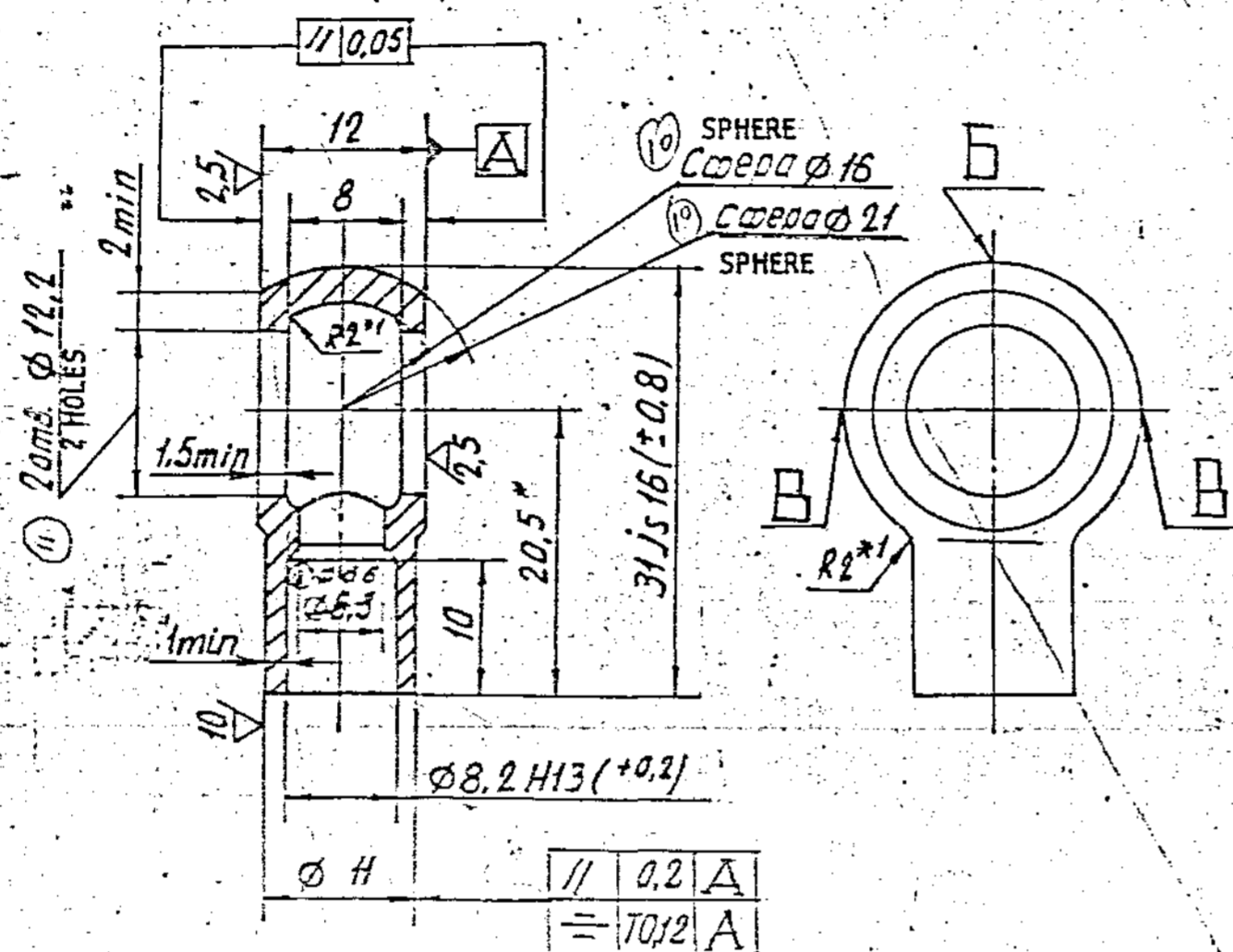
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

		EST WT 89 g	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	
		MATERIAL	USED ON 92 1106 010 CB
ISSUE DATE	NATURE OF AMENDMENTS	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
DRN	SCALE 1 : 1		
DIMENSIONS IN. mm		TITLE SUB ASSY SWIVEL NIPPLE	
TOLERANCE ON DIMNS. UNLESS OTHERWISE STATED			
APPD	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER 92 1106 240
DATE			
SIZE A4			

F12a

DRAWING NUMBER
322-18

20/ (✓)



1. Неуказанные предельные отклонения размеров отверстий по H14, валов по h14, остальных - ± IT14.

2. На поверхностях B допускаются черноты шириной 4 мм, не более.

3. В месте Б допускается площадки Ø 5мм, не более.

4. Покрытие Цб.хр по ИЦЛ-154 с удалением водородной хрупкости для деталей отпущаемых в зап. части и для укомплектования объектов по ИБ-40.

5. Покрытие КВЭ.хр по ИЦЛ-102 с удалением водородной хрупкости для деталей в тропическом исполнении. Допускается отсутствие покрытия на внутренних поверхностях.

6. Заменитель материала сталь марок 10, 20 ГОСТ 1050-74.

7. Клеить на бирке для партии детали с опломбированием окончательную пружинку.

8* Размер для справок.

9* Размеры обеспечить инструментом.

- 1) UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS OF HOLES AS PER H14, SHAFTS AS PER h14, OTHER DIMENSIONS - ± IT14.
- 2) BLOCK SPOTS NOT EXCEEDING 4mm WIDE ARE ALLOWED ON SURFACES B.
- 3) AREA Ø 5mm MAXIMUM IS ALLOWED ON PLACE Б.
- 4) COATING : Zn 6, CHROMATIZING AS PER ИЦЛ-154 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT. FOR COMPONENT TO BE DISPATCHED AS SPARES AND FOR COMPONENTS MAKING A COMPLETE SET OF ARTICLES AS PER ИБ-40.

- 5) COATING : C49, CHROMATIZING AS PER ИЦЛ-102 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT FOR COMPONENTS HAVING TROPICALIZED CONSTRUCTION INTERNAL SURFACES MAY HAVE NO COATING.
- 6) ALTERNATE MATERIAL : STEEL GRADES 10, 20 ГОСТ 1050-74.
- 7) FINAL ACCEPTANCE STAMP SHOULD BE MARKED ON A TAG FOR A BATCH OF COMPONENT AND SHOULD BE SEALED.
- 8) * DIMENSION FOR REFERENCE.
- 9) *1 DIMENSIONS TO BE ENSURED WITH TOOL.

ⓑ ALTERNATE MATERIAL: STEEL O80 M40 (EN8) TO BS:970 PL:1-1983 OR B5 C4 TO IS:1570

CB 322-01-4	CB 322-07-4
CB 322-02-4	CB 322-08-4
CB 322-03-4	CB 322-09-4 CB 20-35-12
CB 322-05-4	CB 322-10-4 CB 3335-00-30CB
CB 322-06-4	CB 322-11-4 CB 322-12-4

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

8	БК 83-265	В.С.	В.С.
7	А.А.С.И.И.	В.С.	В.С.
6	В.С.	В.С.	В.С.

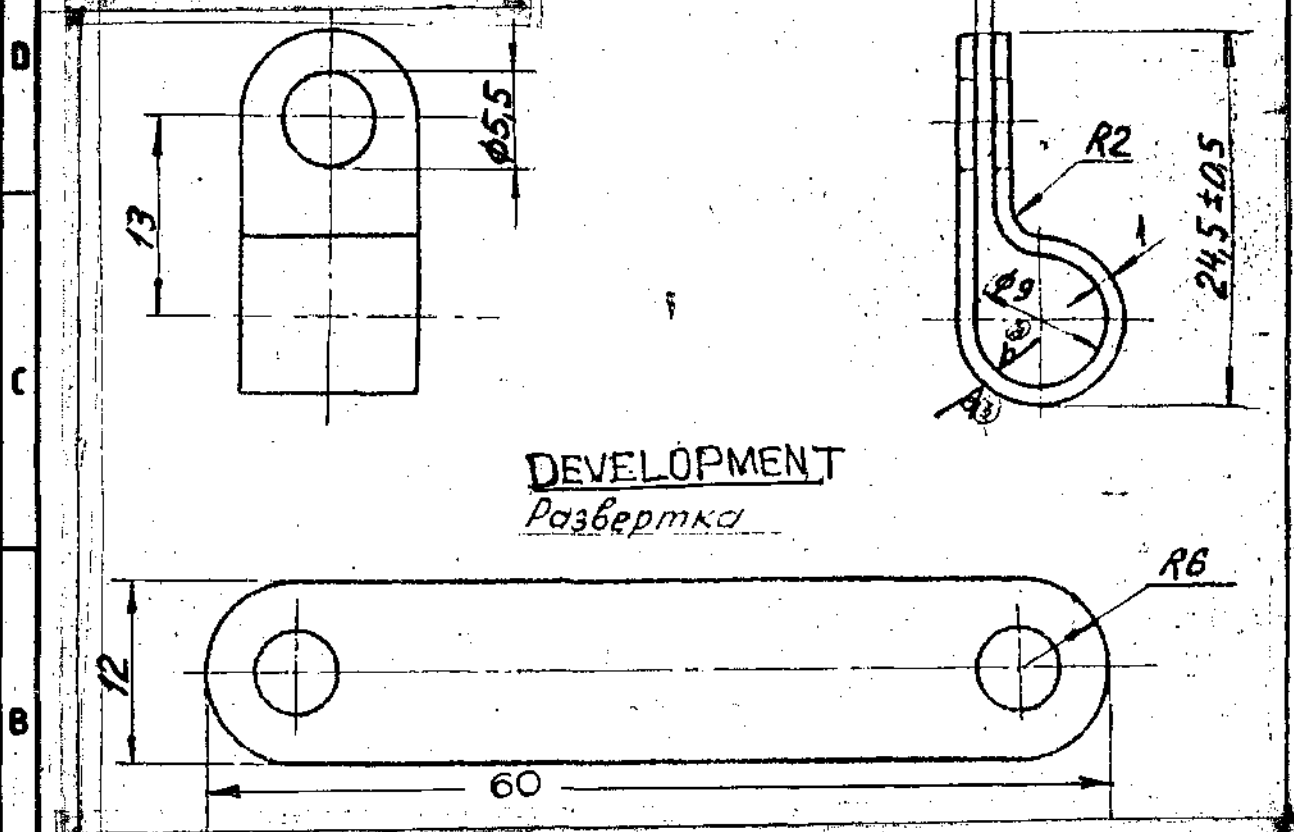
EST. WT. 0.018 Kg. TO BE STAMPED OR MARKED WHERE INDICATED THIS # LETTERS)

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

DRN	DATE	MATERIAL	USED ON
129-3-88	129-3-88	STEEL 35, GOST 1050-74	SEE ABOVE **
SCALE - 2:1	CONTROLLER OF QUALITY ASSURANCE (HEAVY VENTLES) AVADI		
TITLE	SWIVEL ELBOW		
3rd ALTERATION COMM. MINUTES	DATE	ISSUE	DRAWING NUMBER
11-7-09	27-2-09	11-2-97	322-18
11-2-97	11-2-97	11-2-97	11-2-97

DRG. INDICATED BASED ON RUSSIAN ORIGINAL ISSUE NO. 8 (DK-03-265)

DRAWING NUMBER
323-43-2



DEVELOPMENT
Развертка

- 2. DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE MAINTAINED WITH ACCURACY ± 0.3 mm
- 3. SHARP EDGES ARE NOT ALLOWED
- 5. COATING : Cd 9, CHROMATIZING IN ACCORDANCE WITH УУ 1-104-WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT, ALTERNATE MATERIAL : STEEL 08KП GOST 1050-74

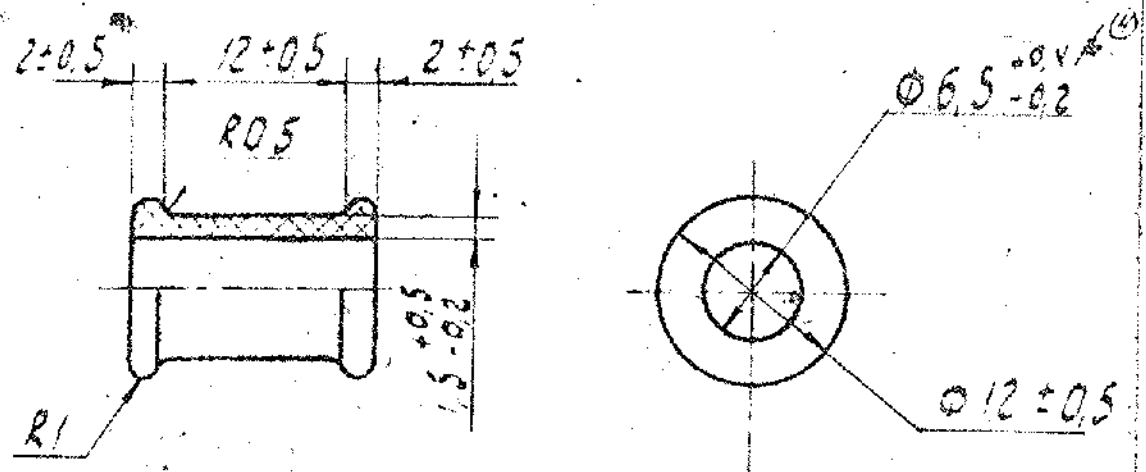
(B) EQUIVALENT MATERIAL
G.D.D IS:513-1994

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

A-7
223

		EST WT 0.005 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.	
B	11-2-10	4th ALTN. COMM. MEETING MINUTES POINT-1 DT. 26-10-09	MATERIAL STRIP 081C-M-2-1 GOST 503-74 81@
A	15 10 87	AUTHY. NOTN. NO- BK 03-126	USED ON C6 323-33-4 C6 C6 323-34-4 C6 323-35-4 C6 323-36-4
DRN		SCALE 2 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
CHD		DIMENSIONS IN mm	TITLE CLAMP
TCO		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	
APPD		ALL THREADS CONFORM TO	D S CAT NUMBER
DATE	18/6		DRAWING NUMBER 323-43-2
SIZE	A4		

323-44-2



1. DIMENSIONS SHOULD BE ENSURED WITH TOOL
2. TO BE MARKED ON A LABEL .
3. TO BE MANUFACTURED AS PER T III H 100 GOST 15,152-69.
4. THE REST OF THE REQUIREMENTS IN COMPLIANCE WITH SPECIFICATIONS TY 005216-75.
5. THE COMPONENT MAY BE CUT ON ONE SIDE ALONG THE LONGITUDINAL AXIS.

(A-B)

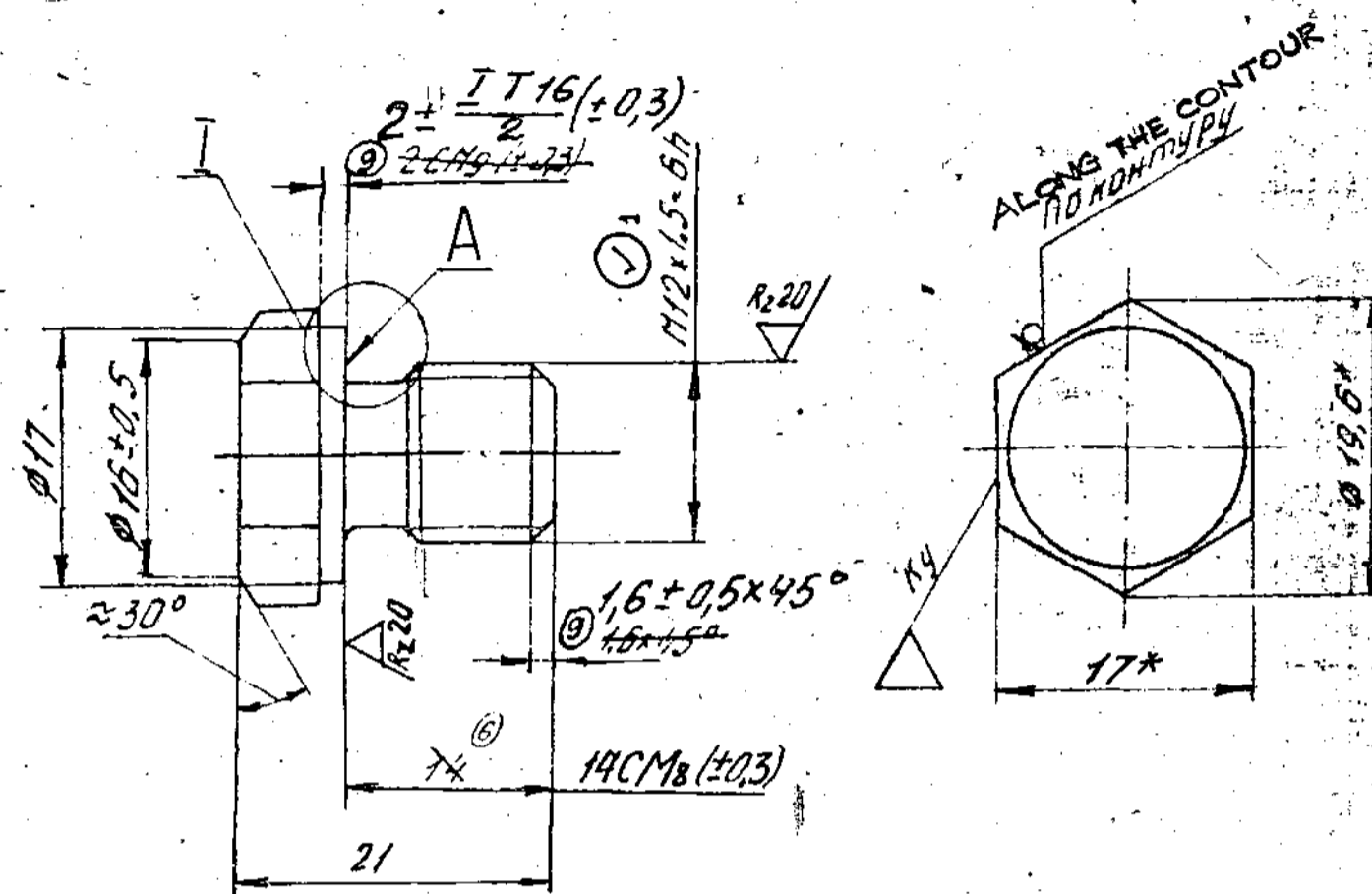
(A)

ALT. MATL.: RUBBER GRADE N3 TO SPEEN. CQ(A(HV))/NBR
 PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

		EST WT	TO BE STAMPED OR MARKED WHERE
		0.001 Kg	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.	
		MATERIAL RUBBER 783-2	USED ON CS 323-33-4 CS
		TY. 005216-75	CS 323-34-4
A.	18-6-08	AUTHY: LT. No. TC/GEN/IND-III DT. 02-04-02	CS 323-35-4
ISSUE DATE	NATURE OF AMENDMENTS		CS 323-36-4
DRN	SCALE : 2 : 1		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
CHD	DIMENSIONS IN mm		
TCO	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED		TITLE
APPD	ALL THREADS CONFORM TO		GROMMET
DATE	D S CAT NUMBER		DRAWING NUMBER
SIZE A4			323-44-2

DRAWING NUMBER
329 50 1

Rz 80 (✓)



- UNSPECIFIED TOLERANCES OF DIMENSIONS FOR HOLES AS PER H 14, FOR SHAFTS AS PER h 14, FOR THE REST OF THE PARTS $\pm \frac{IT 14}{2}$
- NON-SQUARENESS OF SURFACE A RELATIVE TO THE AXIS OF THREAD SHOULD NOT EXCEED 0.1 mm (MMC).
- THREAD MAY BE FORMED BY ROLLING WITH DIAMETER OF NON-THREADED PORTION WITHIN PITCH DIAMETER OF THREAD.
- COATING : Cd 9, CHROMATIZING IN ACCORDANCE WITH ~~444-134~~ ^{4A 569-84} WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
- BOLT HEAD MAY BE MADE BY HEADING.
- * DIMENSIONS FOR REFERENCE.
- *1 DIMENSIONS SHOULD BE ENSURED BY TOOL.

EXPLANATORY NOTE :

- REFERENCE MATERIAL QUOTED GAUGED HEXAGONAL STEEL BAR CLASS OF ACCURACY 5, 17.0(0.24)mm A/F TO GOST 8560-78 HIGH GRADE STEEL 45 NORMAL SURFACE QUALITY TO GOST 1051-73 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL GRADE 45 TO GOST 1050-74.
 - CHEMICAL COMPOSITION AS PER GOST 1050-74

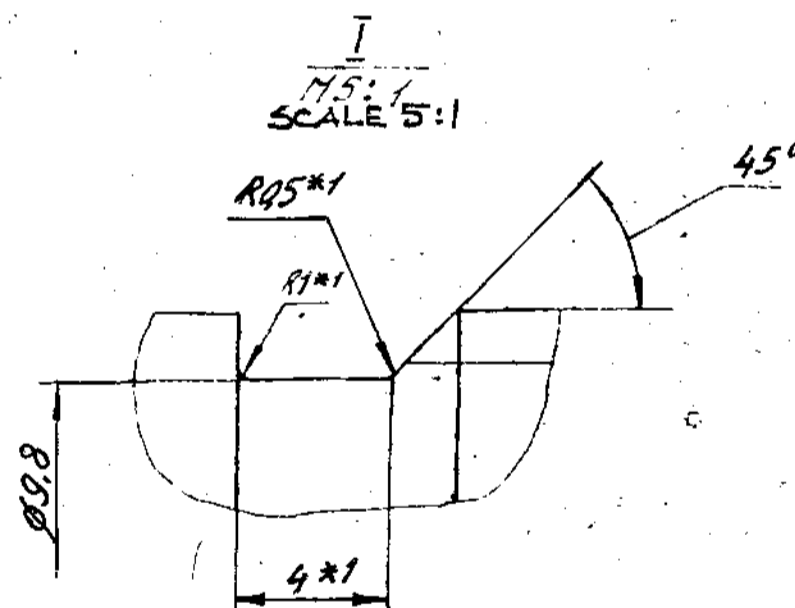
GRADE OF STEEL	CONTENT OF ELEMENTS %					
	C	Si	Mn	S	P	MAXIMUM
45	0.42-0.50	0.17-0.37	0.50-0.80	0.25	0.040	0.035

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH
b) MECHANICAL PROPERTIES UNDER NORMALISED CONDITION AS PER GOST 1050-74.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	YIELD POINT Kgf/mm ²	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH Kgm/cm ²	HARDNESS BHN MAX
45	61	36	16	40	5	207

- REPAIR SIZE DIMENSION ADDED BASED ON LT. NO. 82847/OH/GAS/ED DT 27 MAR '95. WHERE INDICATED THUS (✓) AS FOLLOWS:

SL. NO.	R	REMARKS
(✓) 1	M14x1.5-6h	1. ALL OTHER CONDITIONS AS PER STD. DRG. 2. MARK REPAIR SIZE.



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

EST. MASS 0.02 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	MATERIAL	USED BY
CHD	17-5, GOST 8560-78	(Signature)
TCD	45 GOST 1051-73	(Signature)
APPD	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)	
DATE	AVADI	
SCALE	2:1	
DIMENSIONS IN mm	TITLE: PLUG	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
B 6-4-88 AUTHY. BK 85-141	DRAWING NUMBER	
A 15-2-88 AUTHY. NOTN. NO. BK 81-406	329 50 1	
ISSUE DATE NATURE OF AMENDMENTS		

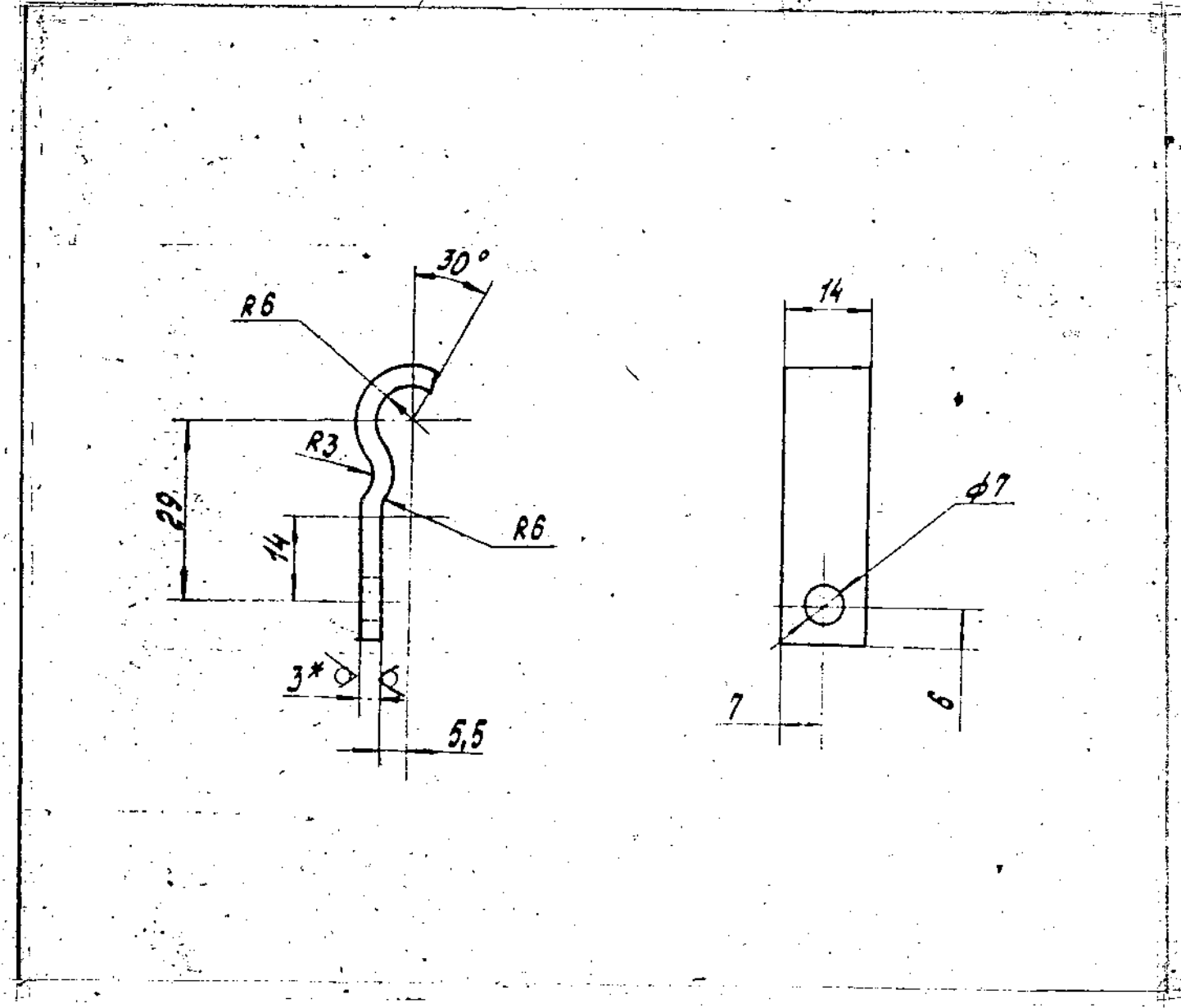
A-8

SIZE A2

DRAWING NUMBER

335 15 1

Rz200/ ✓



EXPLANATORY NOTE:

6. REFERENCE MATERIAL QUOTED:
 HOT ROLLED SHEET STEEL HIGH ACCURACY ON ROLLING "A" 3mm THICK
 TO GOST 19903-74, SUPERIOR FINISH III GOST 16523-70 AND MANUFACTURED
 IN ACCORDANCE WITH CARBON STRUCTURAL STEEL GRADE 10Kn (RIMMING)
 TO GOST 1050-74, AND REFERENCE NOTE 5 ON ALTERNATE MATERIAL CARBON
 STRUCTURAL STEEL GRADE 10 TO GOST 1050-74.

a) CHEMICAL COMPOSITION AS PER GOST 1050-74:

GRADE OF STEEL	CONTENT OF ELEMENTS %						REMARKS
	C	Si	Mn	Cr	S	P	
	M A X I M U M						
10Kn	0.07 - 0.14	0.07 - max	0.25 - 0.50	0.15	0.040	0.035	Ref,Matl.
10	0.07 - 0.14	0.17 - 0.37	0.35 - 0.65	0.15	0.040	0.035	Alt,Matl

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

b) MECHANICAL PROPERTIES AS PER GOST 16523-70:

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kg/mm ²	ELONGATION % min	REMARKS
10Kn	28 - 40	25	Ref,Matl
10	30 - 42	25	Alt,Matl

Ⓐ EQUIVALENT MATERIAL
 Gr. D' IS:513-1994.

- 1 COATING : Cd 9, CHROMATIZING.
- 2 UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ± 0.5mm.
- 3 DRAFT 0.25mm.
- 4 DIMENSION FOR REFERENCE.
- 5 ALTERNATE MATERIAL : STEEL 10 GOST 1050-74.

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.		DRN	CHD	TCD	APPD	DATE	SCALE - 1 : 1	MATERIAL - SHEET A3 GOST 19903-74 III - 10Kn GOST 16523-70	USED ON:- CB 3335 00 30/24
		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI							
EST. MASS 0.015 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.		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.		ALL THREADS CONFORM TO		D S CAT NUMBER	DRAWING NUMBER 335 15 1
A 19-5-10		6 th Alt. Comm. Mt. Minutes Pt.No.2 Dt.26.10.09		ISSUE DATE		NATURE OF AMENDMENTS			

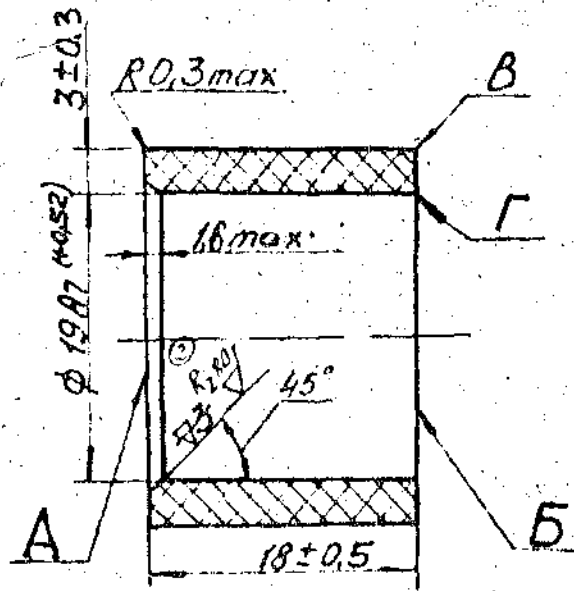
KVD No.-78317

Ⓐ-9
 SIZE A2



ECKA

10/17



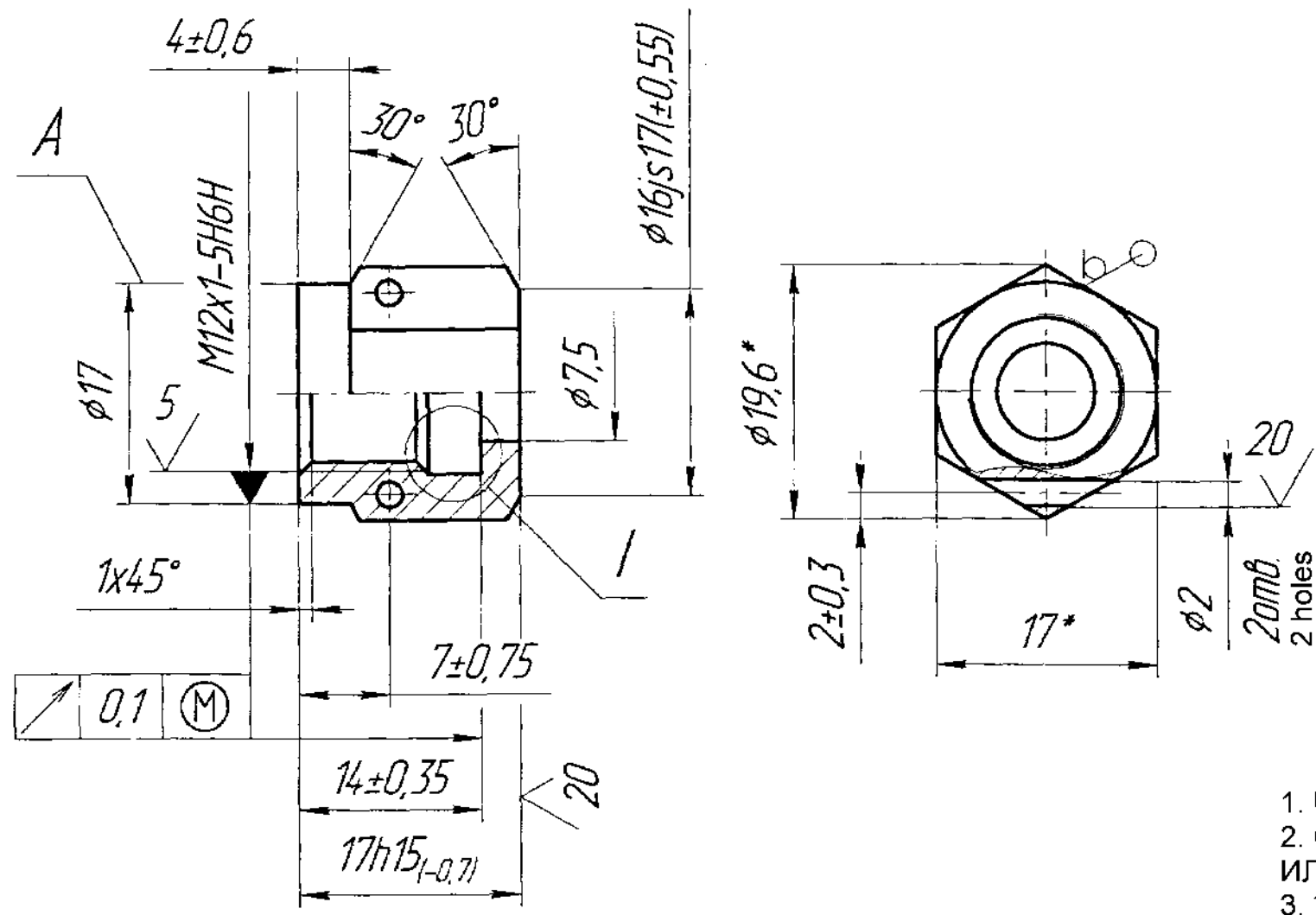
1. PROTECTIVE BUSHING TAPER WITHIN A TOLERANCE LIMIT IS PERMITTED.
2. NON PARALLELISM OF SURFACES A AND 5 SHOULD BE 0.1 mm MAXIMUM; IT IS ENSURED BY TOOL..
3. MATERIAL MAY BE SUBSTITUTED BY PHENOLIC PLASTIC OF GRADES 01-040-02, 01-030-02, GOST 5689-79.
4. 0.5 x 0.5 mm CHIPPINGS ALL AROUND THE EDGES "B" AND "Γ" ARE PERMITTED.
5. OTHER TECHNICAL REQUIREMENTS AS PER TY 6-05-1538-77.
6. THE PART IN TROPICAL VERSION SHOULD BE MADE FROM PHENOLIC PLASTIC B x I - 090 - 34 OR B x 3 - 090 - 14 GOST 5089-79 AND BE MARKED WITH "T" LETTER OR WITH YELLOW OR WHITE SPOT.
PILOT SAMPLE SHOULD BE APPROVED A H.S.P BEFORE BULK PRODUCTION

1001

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS *
		0.0052 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	
DRW	9-1-87	SCALE - 2:1	MATERIAL: PHENOLIC PLASTIC USED ON:- CB 3335-00-24 03-010-02 GOST 5689-79 CB 447-00-1 CB 327-00-45
CHD		DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
TCD		TOLERANCE ON DIM'S UNLESS OTHERWISE STATED.	TITLE:- PROTECTIVE BUSHING
APOD		ALL THREADS CONFORM TO	D S CAT NUMBER
DATE	9-1-87		DRAWING NUMBER 340-237

345-21

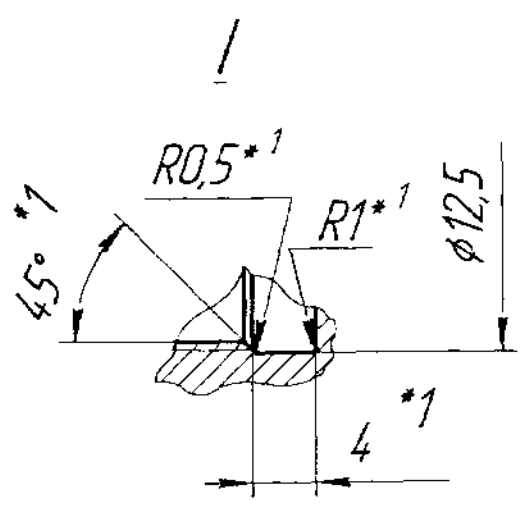
10 (✓)



1. Неуказанные предельные отклонения размеров: H14, h14.
2. Покрытие Ц 6.хр по ИЛ-749-88. Допускается отсутствие покрытия на внутренних поверхностях.
3. * Размеры для справок.
4. *¹ Размеры обеспеч. инструментом.
5. Клеймить окончательную приемку на бирке.
6. На поверхности А допускаются необработанные участки.
7. В тропическом исполнении покрытие Кд 9.хр по ИЛ-569-84 с удалением водородной хрупкости.

1. Unspecified limit deviations of dimensions are H14, h14.
2. Coating zinc coating followed by chrome plating having thickness 6 micron as per ИЛ-749-88. Absence of coating on internal surfaces is permitted.
3. *Dimensions for reference.
4. *¹ Dimensions are ensured by tool.
5. Put final acceptance stamp on tag.
6. Unmachined sections are allowed on surface A.
7. In tropical version of coating cadmium plating followed by chrome plating having thickness 9 micron as per ИЛ-569-84 with removal of acid brittleness.

0.1 (M)



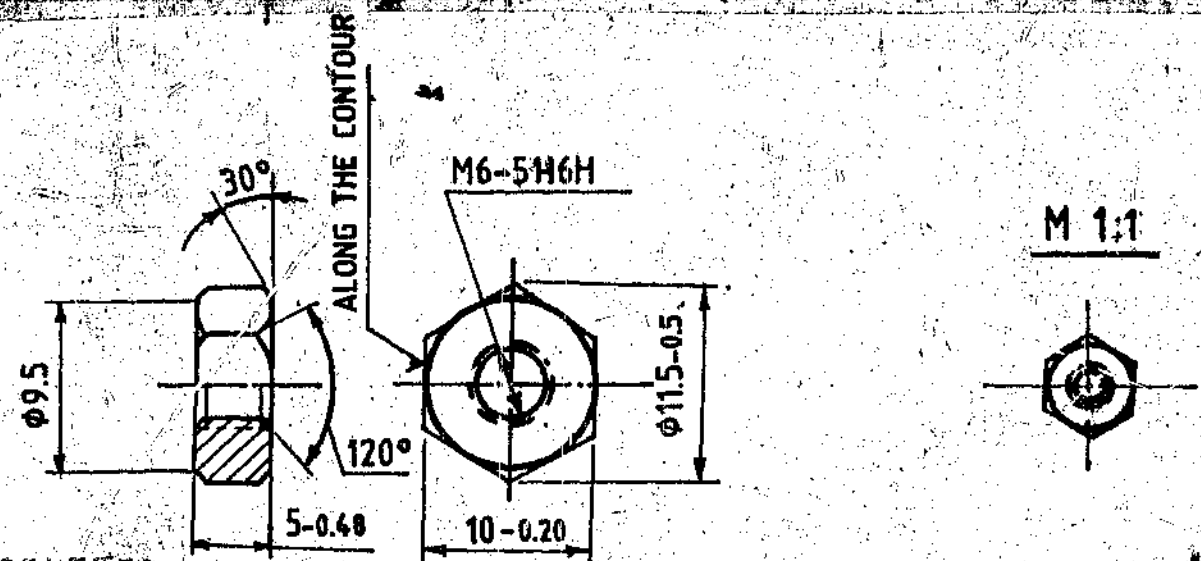
Идв № подл. 44 778
 Подп. и дата
 Взам. инв. № Инв. № докл.
 Подп. и дата

				345-21		
10	-	90-625				
Изм.	Лист	№ докум.	Подп.	Дата	UNION NUT	Лит.
Trans. & Ckd. by: M/s SWYAZ				Гайка накладная		Масса
Authenticated by:				Hexagon GOST		Масштаб
Approved by:				Шести-17-н11 ГОСТ 8560-78		Scale
Engine Factory, Avadi				гранник 45-Б ГОСТ 1051-73		1
					Лист	Листов
					Sheet	6 Sheets
					90	

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NIL
 COMMON TO V-92S2 & UTD - 20 ENGINES
 KUC No. 78016

DRAWING NUMBER
351-06

EXPLANATORY NOTE



- 1. } DELETED.
- 2. } DELETED.
- 3. THE THREAD MAY BE CHECKED BEFORE COATING.
- 4. } DELETED.
- 5. COATING: Cd9, CHROMATIZING, AS PER ЦУЛН-104 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
- 6. THE REST OF THE TECHNICAL REQUIREMENTS AS PER STANDARD B2052-00.
- 7. ALTERNATE MATERIAL: STEEL GRADES 40 AND 50 GOST 1050-74. ROLLED STOCK OF GROUP 'B' CLASS 4, GOST 1051-73 MAY BE USED.
- 8. TO ENSURE HIGH QUALITY OF COATING, IT IS ALLOWED TO ELIMINATE SURFACE DEFECTS OF ROLLED STOCK WITH DECREASE OF DIMENSION AS PER ACCURACY CLASS 5.

Ⓢ MATERIAL: STEEL 709 M40 (EN 19)
TO BS: 970 - Pt-I-1983

Cb 20-05-47-4, Cb 20-01-00-8, Cb 20-06-12-6, Cb 20-06-13-6, Cb 20-09-07, Cb 20-11-01-9, Cb 20-12-01-13
Cb 20-22-00-7, Cb 20-23-33-6, Cb 20-23-34-6, Cb 20-32-00-4, Cb 20-08-00-7

Cb 3301-00-37, Cb 406-12-44, Cb 406-13-44, Cb 3308-00-17, Cb 3320-00-33, Cb 407-7, Cb 401-10

Cb 3301-00-44, Cb 406-12-75, Cb 406-13-75, Cb 3308-00-23, Cb 3308-15-2, Cb 310-00-14, Cb 3320-00-43, Cb 315-606-12, Cb 327-00-73, Cb 315-777-2, Cb 3334-00-47, Cb 3335-00-9, Cb 337-100

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

EST WT 0.0025 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 OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

6. REFERENCE MATERIAL QUOTED:
BRIGHT STEEL HEXAGON BAR 10 mm A/F CLASS OF ACCURACY 4 (+0,000) TO GOST 8560-78, FROM HIGH GRADE SIZED STEEL 45, SURFACE QUALITY B TO GOST 1051-73 AND MANUFACTURED IN ACCORDANCE WITH QUALITY CARBON STRUCTURAL STEEL GRADE 45 AND REFERENCE NOTE 4, ON ALTERNATE MATERIALS STEEL GRADES 40 AND 50 TO GOST 1050-74.

a) CHEMICAL COMPOSITION AS PER GRADES 45, 40 & 50 TO GOST 1050-74.

GRADE OF STEEL	CONTENT OF ELEMENTS %						REMARKS
	C	Si	Mn	Cr	S	P	
45	0.42-0.50	0.17-0.37	0.50-0.80	0.25	0.040	0.035	Ref, Matl
40	0.37-0.45	0.17-0.37	0.50-0.80	0.25	0.040	0.035	Alt, Matl
50	0.47-0.55	0.17-0.37	0.50-0.80	0.25	0.040	0.035	Alt, Matl

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH

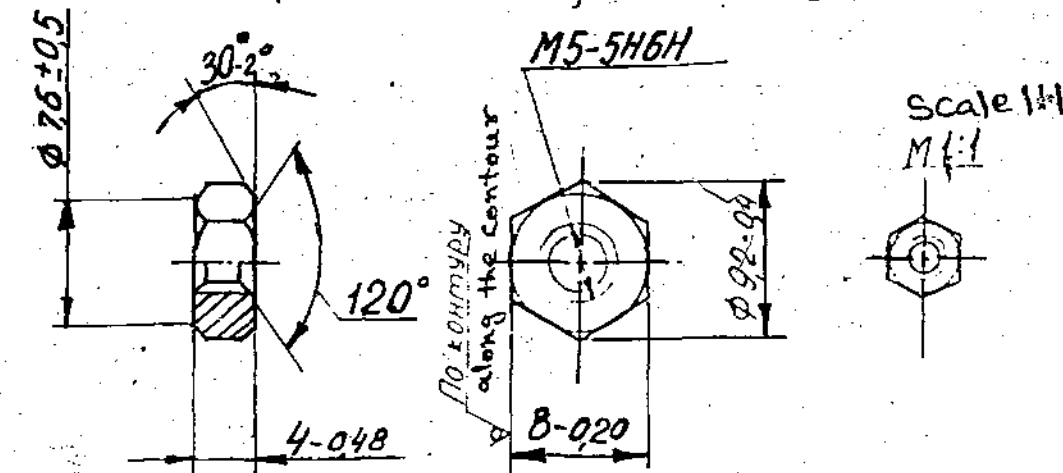
b) MECHANICAL PROPERTIES UNDER NORMALISED CONDITION:

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	YIELD POINT Kgf/mm ²	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH Kgm/cm	HARDNESS BHN MAX	RE-MARKS
45	61	36	16	40	5	289	Ref, Matl
40	58	34	19	45	6	217	Alt, Matl
50	64	38	14	40	4	241	Alt, Matl

Ⓐ Cb 20-27-00-4, Cb 3338-00-16, Cb 3338-401-10, Cb 447-00-1, Cb 3338-404-7, Cb 3335-00-30

DRN	CHD	TCD	APPD	DATE	SCALE: 2:1	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69	ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
				09-4-86						351 06
MATERIAL: HEXAGON BAR 10-4 GOST 8560-78 45-B GOST 1051-73					USED ON: Cb 3342-188-3 Cb 315-606 Cb 327-00-45 Cb 402-93-1					
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI					TITLE: NUT M6					
EST WT 0.0025 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 OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE										
ISSUE	DATE	NATURE OF AMENDMENTS								
	9-6-09	3 rd ALTN. COMM. MINUTES POINT 5 DATE 27-2-09								
	25.8.08	USED ON NUMBER ADDED								
	5-9-92	EFA LT. 07263/ENG/PDO/395-4 dt 24.8.92								

rolled stock of group B class 4 GOST 1051-73 may be used. To ensure high quality of coating, it is allowed to eliminate surface defects of rolled stock with decrease of dimension as per accuracy class - 5.



- The component may be manufactured from steel GOST 1050-74.
- Chamfer 120° should be made up to the major diameter of thread.
- Shift of hole axis up to 0.25 mm. is permitted.
- The thread may be checked before coating.
- Coating :- Cd 9, Chromating as per u 2/1-104 with elimination of Hydrogen embrittlement.
- The rest of the technical requirements as per standard 82052-00.
- ~~Alternate material: Steel grades 40 and 50 GOST 1050-74.~~

EXPLANATORY NOTE

9. i) REFERENCE MATERIAL QUOTED:
GAUGED HEXAGONAL STEEL BAR CLASS OF ACCURACY 4, 0.01-0.100mm A/F TO GOST 8560-78 FROM HIGH GRADE SIZED STEEL SURFACE QUALITY 'B' TO GOST 1051-73 AND MANUFACTURED IN ACCORDANCE WITH QUALITY CARBON STRUCTURAL STEEL GRADE 45 TO GOST 1050-74
- ii) REFERENCE NOTE ON ALTERNATE MATERIAL : QUALITY CARBON STRUCTURAL STEEL GRADES 40 AND 50 TO GOST 1050-74
- a) CHEMICAL COMPOSITION : AS PER GOST 1050-74

GRADE OF STEEL	CONTENT OF ELEMENTS %						REMARKS
	C	Si	Mn	Cr	S	P	
45	0.42-0.50	0.17-0.37	0.50-0.80	0.25	0.040	0.035	REF MATL
40	0.37-0.45	0.17-0.37	0.50-0.80	0.25	0.040	0.035	ALT MATL
50	0.47-0.55	0.17-0.37	0.50-0.80	0.25	0.040	0.035	ALT MATL

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH

b) MECHANICAL PROPERTIES : AS PER GOST 1050-74

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kg/mm ²	YIELD POINT Kg/mm ²	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH Kgfm/cm ²	HARDNESS B H N MAX	REMARKS
45	61	36	16	40	5	229	REF MATL
40	58	34	19	45	6	217	ALT MATL
50	64	38	14	40	4	241	ALT MATL

Material: STEEL 709M40 (EN-19) TO BS-970 Pt-1-1983

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

EST. MASS 0.0012 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)

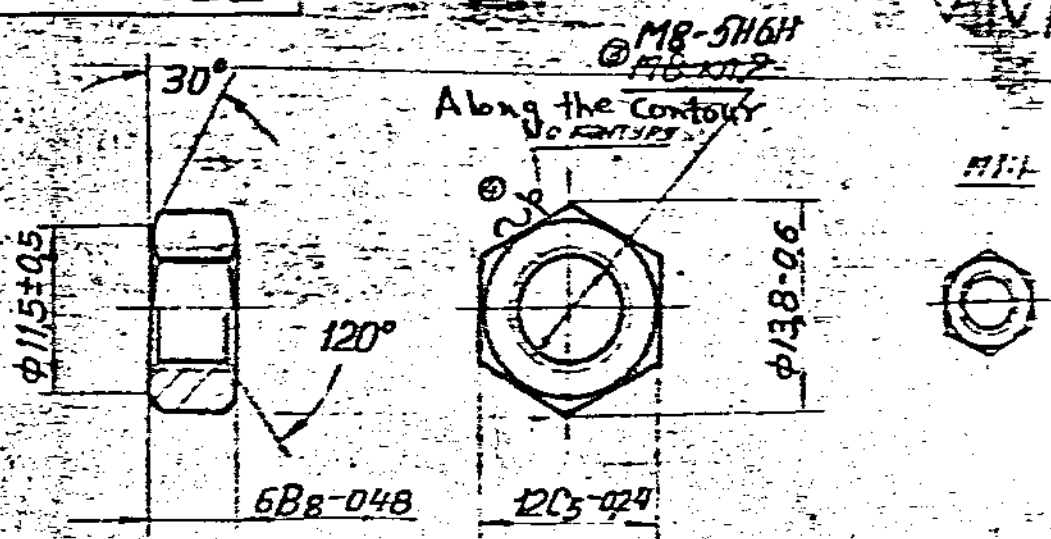
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	TCD	APPD	DATE	SCALE - 2 : 1	MATERIAL: HEXAGON BAR 45 GOST 8560-78 45 GOST 1051-73	USED ON: C5-20-35-00-5 CB 3335 00 24
					CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
					DIMENSIONS IN mm. TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.		TITLE:- NUT M5
ISSUE	DATE	NATURE OF AMENDMENTS	ALL THREADS CONFORM TO		D S CAT NUMBER		DRAWING NUMBER 351 13

A-11

A-2

351-67



EXPLANATORY NOTE:

Material Quoted: Hexagon bar 12-5 GOST 8560-78
45 GOST 1051-73

Bright steel Hexagon bar from grade 45 to GOST 1050-74 with across flats 12 mm, of accuracy class 5.

Chemical composition

Carbon = 0.42-0.50 Chromium = 0.25 max.
 Silicon = 0.17-0.37 Sulphur = 0.040 max.
 Manganese = 0.50-0.80 Phosphorus = 0.035 max.
 Copper = 0.25 max. Nickel = 0.25 max.

Mechanical Properties:

yield point kgf/mm² = 36 (min)
 ultimate tensile strength = 61 (min)
 Elongation % = 16 (min)
 Reduction in area % = 40 (min)
 Impact strength kgf/cm² = 5 (min)

4. The thread may be checked before coating.
5. The rest of the technical requirements as per standard 82052-00.
6. Coating: - Cadmium & Chromating as per 434-104 with elimination of hydrogen embrittlement.

HEXAGON BAR 12-5 GOST 8560-78
45 GOST 1051-73

Ⓐ EQUIVALENT MATERIAL STEEL
 45C8 TO IS:1570

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

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS #
		0.004 Kg	(LETTERS)
A	13.8.10	4 th All. Com. Meeting Minute Point No.11 Dt: 26-10-09	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE: 2:1	MATERIAL: * SEE ABOVE
CHD		DIMENSIONS IN mm	USED ON: C53338-401-10
TCB		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AYAD
APPROV		ALL THREADS CONFORM TO	TITLE: NUT M8
DATE	15/57		D/S CAT NUMBER: DRAWING NUMBER: 351-67



353 23

EXPLANATORY NOTE

3. REFERENCE MATERIAL QUOTED

SPRING WASHER, NOMINAL THREAD DIA 6mm, HEAVY WASHER 'T' PARKERISED AND OILED '0,6' AND REFERENCE NOTE 'Z' ON ALTERNATE MATERIAL ZINC PLATED '09' TO GOST 6402-70 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL HOT ROLLED STEEL GRADE 65 G TO GOST 1050-74.

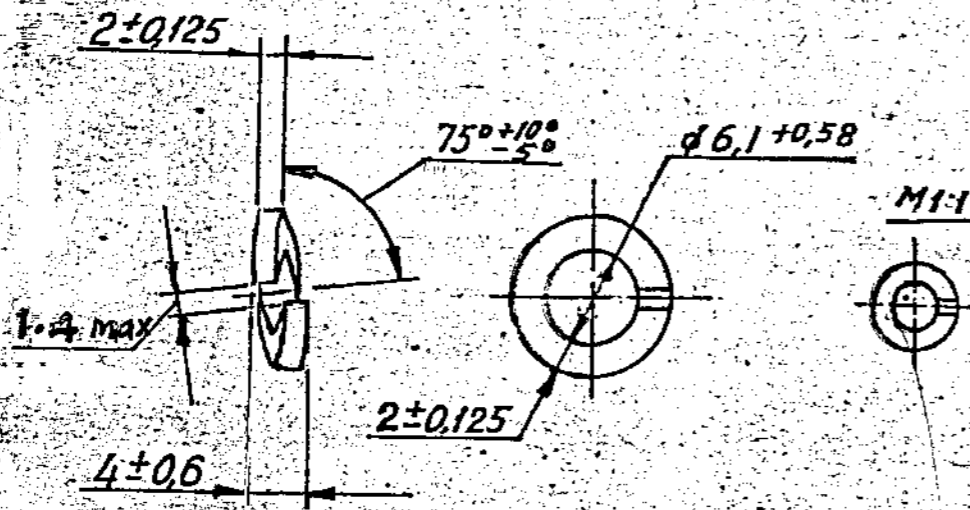
a) CHEMICAL COMPOSITION:

GRADE OF STEEL	CONTENT OF ELEMENTS %					
	C	SI	Mn	Cr	S	P
65G	0,62 - 0,70	0,17 - 0,37	0,90 - 1,20	0,25	0,040	0,35

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0,25% EACH

b) MECHANICAL PROPERTIES UNDER NORMALISED CONDITION: AS PER GRADE 65G, 1050-74.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	YIELD POINT Kgf/mm ²	ELONGATION %	HARDNESS		
				B	H	N
65G	75	44	9	285		



- 1. COATING: CADMIUM CHROMATIZING AS PER Ч 3,1 104 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
- 2. WASHER 6T.65G 09 GOST 6402-70 MAY BE USED.

B EQUIVALENT MATERIAL
75 C6 TO IS:2507/EN42 J BS:970

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

EST. WT 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 OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

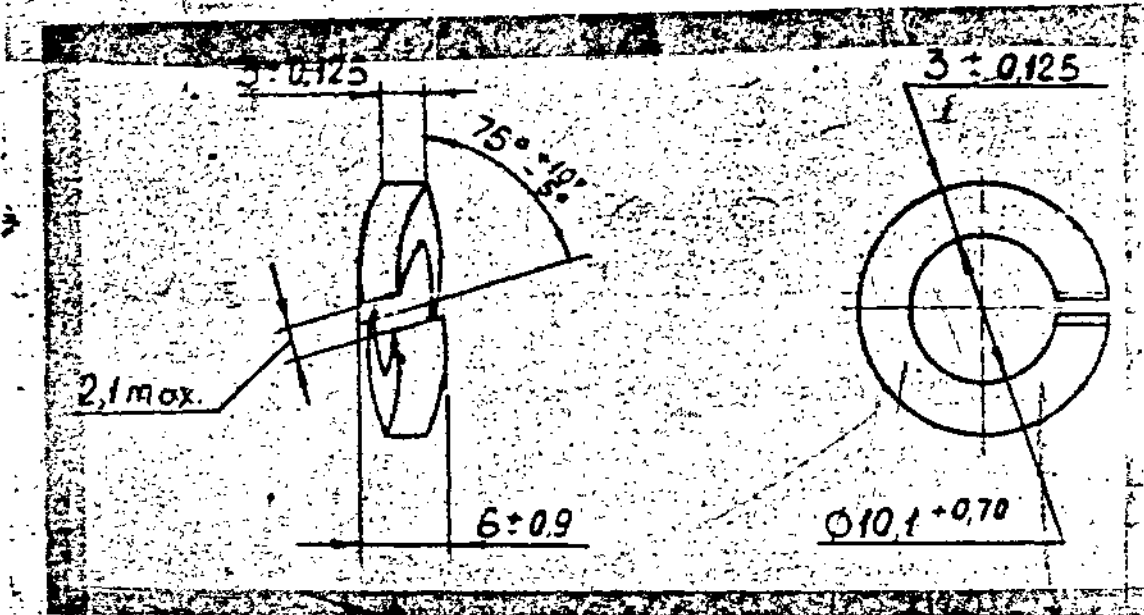
- A** Cb 327-00-73, Cb 3334-00-47, Cb 3335-00-9, Cb 337-100
- Cb 3301-00-44, Eb 406-12-75, Cb 406-13-75, Cb 3308-15-2, Cb 310-00-14, Cb 411-00-56, Cb 3320-00-43, Cb 315-606-12, Cb 3335-00-24
- Cb 406-12-44, Cb 406-13-44, Cb 3300-00-27 CX, Cb 3301-00-37, Cb 3308-00-17, Cb 3320-00-33

USED ON *
Cb 3338-00-16
Cb 3338-401-10
Cb 3338-406-7
Cb 3342-00-805
Cb 3342-188-7 Cb 3315-606
Cb 327-00-45 Cb 411-00-41
Cb 407-00-1 Cb 602-93-1

ISSN		MATERIAL	65G 06
CHD		GOST 6402-70	
TCO		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)	AVADI
APPD		SCALE: 2:1	
DATE	25-3-86	DIMENSIONS IN mm	
		TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS : 2102-69	TITLE
			WASHER 6T
B	16-08-10 4 th Alt. Comm. Meeting Minutes	ALL THREADS TO CONFORM TO	D S CAT NUMBER
A	28.8.08 USED ON NUMBER ADDED		DRAWING NUMBER
ISSUE	DATE	NATURE OF AMENDMENTS	353 23

* CB 20-01-00-8 CB 20-06-13-6 CB 20-23-34-86
 CB 20-06-00-2 CB 20-15-671
 CB 20-06-12-6 CB 20-22-00-7
 CB 20-15-663-4 CB 20-23-83-6
 COMMON TO V-92S2 & UTD-20 ENGINES
 SVD NO 63632
 SIZE A3

DRAWING NUMBER
353-26



1. Washer 10 TO 65Г 06 GOST 6402-70
may be used.

EXPLANATORY NOTE:

Material Quoted: 65Г 06 GOST 6402-70

Alternate material quoted: washer 10 TO 65Г 06 GOST 6402-70

65Г : Spring (lock) washers (Heavy washer) manufactured from
Steel grade of 65Г to GOST 1050-74.

06 : Parkerising followed by oiling

washer 10: oxy-anodizing followed by chromate passivation.

Chemical Composition: as per GOST 1050-74

C	Si	Mn.	Cr	S	P	Cu	Ni
			MAXIMUM				
0.62-0.70	0.17-0.37	0.70-1.00	0.25	0.040	0.035	0.25	0.25

(i) General Properties: as per GOST 6402-70.

1. Theoretical weight of 1000 washers in kg \approx 2.914

2. Estimated resilience of washers from steel of
grade 65 G in kg \approx } = 87.0

(ii) Mechanical Properties: for 65Г, as per GOST 1050-74

1. yield point kgf/mm^2 (min) = 44

2. ultimate tensile strength kgf/mm^2 (min) = 75

3. Elongation % (min) = 9

4. Hardness BHN (max) = 229

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

EST. WT. 1000 PIECES 2.914 kg
TO BE STAMPED OR MARKED WHERE INDICATED THUS # 1 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	<i>Subraha</i>	MATERIAL:-	USED ON C53338-00-16
CHD	<i>see P/number</i>	65Г.06 GOST 6402-70	CE 20-09-01-6
TCD	<i>Devendra</i>		
APPD	<i>S.E.</i>	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	20-4-89	AVADI	
SCALE:-	2:1	TITLE	
DIMENSIONS IN mm		WASHER 10T	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69		D S CAT NUMBER	
ALL THREADS TO CONFORM TO		DRAWING NUMBER	
ISSUE DATE		353-26	
NATURE OF AMENDMENTS			

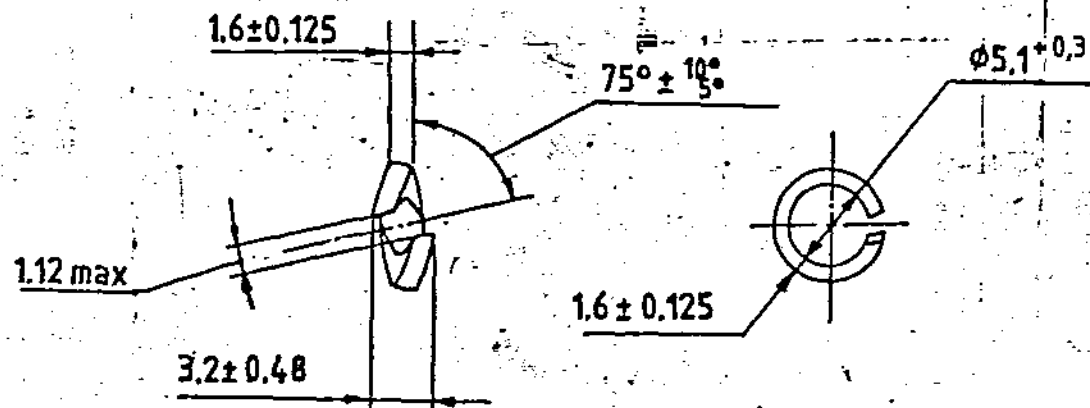
KVD No. 78687
(V-46)

KVD No. 63634
(UTD)

SIZE A3

KVD.No. 78696

DRAWING NUMBER
353-93-1



1. IN TROPICAL MANUFACTURE, COATING Cd 9 Cr AS PER UCL-104 WITH REMOVAL OF HYDROGEN EMBRITTLEMENT.
2. WASHER ST65Γ09 GOST 6402-70 MAY BE USED, IN VISUAL AND TROPICAL MANUFACTURE.

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

		EST. WT. ¹⁰⁰⁰ / _{Pcs} 0.424 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS \oplus (LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.			
A	16.8.10	1 st Alt. Comm. Meeting Minutes Point No.12 Dt: 26-10-09	MATERIAL:- ST 65 Γ 06 GOST 6402-70
ISSUE DATE		NATURE OF AMENDMENTS	USED ON Cb 311-10-4 Cb 311-10-4
DRN	<i>Ughle</i>	SCALE:- 2 : 1 DIMENSIONS IN mm	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.
CHOC	<i>S. S. S.</i>	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS 2102 -69	TITLE WASHER
APPO	<i>S. S. S.</i>	ALL THREADS CONFORM TO	D S CAT NUMBER
DATE	<i>28.5.01</i>		DRAWING NUMBER 353-93-1
SIZE A4			

EXPLANATORY NOTE:

MATERIAL QUOTED: WASHER 5T, 65Γ, 06 GOST 6402-70.

CORRESPONDS DESIGN AND DIMENSIONS OF SPRING (LOCK) WASHERS.

06 = CONVENTIONAL SYMBOL OF FINISH. (PARKERISING FOLLOWED

5 = NOMINAL THREAD DIA OF BOLT OR SCREW BY OILING).

T = HEAVY ; 65Γ = GRADE OF STEEL AS PER GOST 1050-74.
(65G)

CHEMICAL COMPOSITION: AS PER GOST 1050-74.

CONTENT OF ELEMENTS %							
C	Si	Mn	Cr	S	P	Cu	Ni
MAXIMUM							
0.62-0.70	0.17-0.37	0.90-1.20	0.25	0.040	0.035	0.25	0.25

WEIGHT OF STEEL WASHERS AND THEIR RESILIENCE PROPERTIES AS PER GOST 6402-70.

THEORITICAL WEIGHT OF 1000 STEEL WASHERS IN kg = 0.424.

ESTIMATED RESILIENCE OF WASHERS FROM STEEL GRADE 65G = 28.7.
IN kg

MECHANICAL PROPERTIES: AS PER GRADE 65G GOST 1050-74.

YIELD POINT kgf/mm² (MIN) = 44

ULTIMATE TENSILE STRENGTH (MIN) = 75
kgf/mm².

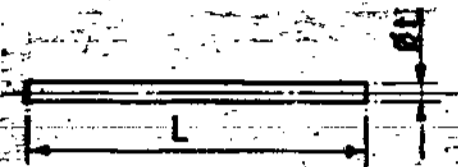
ELONGATION % (MIN) = 9

REFERENCE NOTE: 09 = ZINC PLATING (CONVENTIONAL SYMBOLOF FINISH)

Ⓐ EQUIVALENT MATERIAL
75 C6 TO IS: 2507/EN 42 J BS: 970



DRAWING NUMBER
354-22



KVD NO	L mm	LIMIT DEVIATIONS mm	USED ON
	150	±1.5	
78705	60	±1.5	CS 3338-401-10 CS 530-200
78706	80	±2	CS 3334-00-37 CS 327-00-45
78707	100	±2	CS 3338-00-16 CS 327-00-45 CS 3335-00-24 CS 3342-00-8CS CS 20-22-00-7
78708 (C)	120	±2	CS 419-00-4, CS 310-00-7 CS 322-00-4CS
78709	160	±2	CS 327-00-45 CS 3335-00-24 CS 3334-00-27
78710	200	±2	CS 327-00-45 CS 3334-00-27
78711 (A)	260	±3	CS 3334-00-27 CS 20-29-00-8
78712	350	±3	CS 3338-407-4 CS 3329-00-13
78713	420	±3	CS 411-00-41
78714	560	±3	CS 327 00 45
	600	±3.5	
	800	±5	

ADDITIONAL REQUIREMENTS

- FOR MANUFACTURE OF LOCK WIRE AS PER DRAWING 354-22
1. THE WIRE SHOULD BE PROVIDED WITH ZINC COATING. DIAMETER OF WIRE AFTER COATING SHOULD BE 1.18 mm
 2. QUALITY OF WIRE SHOULD NOT EXCEED HALF OF THE TOLERANCE ON DIAMETER
 3. THE WIRE SHOULD BE MANUFACTURED FROM LOW CARBON ROLLED STEEL AS PER GOST 1050-74
 4. ULTIMATE RUPTURE STRENGTH OF ZINC PLATED WIRE SHOULD NOT BE LESS THAN 1700 (37 Kgf/mm²)
 5. THE WIRE SHOULD WITHSTAND NOT LESS THAN 7 BENDINGS THROUGH 180° AND NOT LESS THAN 25 TWISTINGS THROUGH 360°
 6. THE SURFACE OF WIRE SHOULD NOT HAVE BLOW HOLES, CRACKS, MARKS, BLACK FINES, OXIDE SPOTS, BURS AND RUST. THERE SHOULD NOT BE ANY UNCOATED AREAS ON THE WIRE.
 7. ON WIRE FRACTURE, THERE SHOULD NOT BE ANY CRACKS, BLACK FINES, FISSURES, BLISTERS, AND SHRINKAGE CAVITIES
 8. WIRE ZINC COATING SHOULD BE BOUND TO THE STEEL WHEN WOUND ON CYLINDER WITH DIAMETER EQUAL TO WIRE FIVE FOLD DIAMETER, THE WIRE SHOULD NOT HAVE ANY PEELINGS AND FISSURINGS OF ZINC COATING.

EXPLANATORY NOTE:-

REFERENCE MATERIAL QUOTED:- LOW CARBON STEEL
To GOST 1050-74.

CHEMICAL COMPOSITION %

GRADE	C	Si	Mn	MAXIMUM				
				Cr	P	S	Cu	Ni
15	0.12-0.19	0.17-0.37	0.35-0.65	0.25	0.035	0.040	0.25	0.25

MECHANICAL PROPERTIES

1. ULTIMATE TENSILE STRENGTH Kgf/mm² (min) = 38
2. YIELD POINT Kgf/mm² (min) = 23
3. PERCENTAGE ELONGATION % (min) = 27
4. REDUCTION IN AREA % (min) = 55
5. HARDNESS BHN (MAX) = 149

COMMON TO V-92S2 & UTD-20 ENGINES

(E) EQUIVALENT MATERIAL
IS: 549.

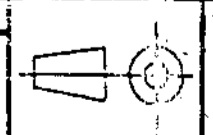
(D) ** ITEM USED IN VARIOUS LENGTHS ON VARIOUS ASSEMBLIES OF V46-6, V92-S2, & UTD-20. ENGINE.

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

EST. WT. 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	Hydralia	MATERIAL	CS 20-06-00-2
CHD	Hydralia	USED ON	CS 20-35-00-5
TCB	Hydralia		CS 3338-402-4 CS
APPD	Hydralia		SEE TABLE **
DATE	18-3-86	CONTROL RATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE		AVADI	
E	8-7-10	4.5 ALT. COMM. Mtg. MINUTES	
D	28.8.08	POINT No. 3 DT. 26-10-09	
C	30.6.01	USED ON NUMBER ADDED	
B	15.1.02	AUTHY 90211/AHSP/ED dt 27.3.01	
A	15-2-88	AUTHY LE No. 1100267/IND-11/7	
ISSUE	DATE	NATURE OF AMENDMENTS	



LOCK WIRE

DRAWING NUMBER
354-22

THE
MAGAZINE
OF THE
AMERICAN
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OF
MUSIC

Volume 10
Number 1
Spring 1978

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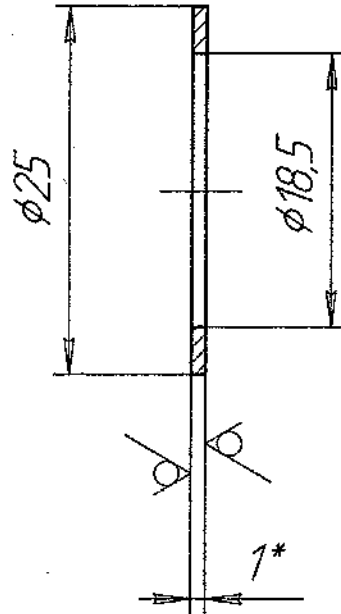
Volume 10
Number 1
Spring 1978

THE
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OF THE
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SOCIETY
OF
MUSIC

Volume 10
Number 1
Spring 1978

1-80-556

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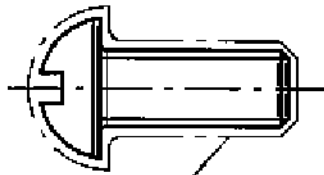
1. Replace the material of strip ДПРНМ1 x 45НДМ3 GOST 1173 - 93.
2. Requirement, presented for stamping, as per standard 82050-16.
3. Anneal. Scaling is not permitted.
4. Parameter of surface finish of machined surface is ensured with tool.
5. * Dimension for reference.

1. Заменитель материала Лента ДПРНМ1x45НДМ3 ГОСТ 1173-93.
2. Требования, предъявляемые к штамповке, по нормам 82050-16.
3. Отжечь. Отслаивающаяся окалина не допускается.
4. Параметр шероховатости обрабатываемых поверхностей обеспечивается инструментом.
5. * Размер для справок.

Подп. и дата
 Инв. № дробл.
 Взам. инв. №
 Подп. и дата
 Инв. № подл.
 46100

		355-08-1		
A 495-04 Dt. 23-09-08		RING		Weight Scale
Trans. & Ckd. By: M/s Swyaz Authenticated By:		КОЛЬЦО	Лист	Масса Масштаб
Approved By: Engine Factory, Adavi		0,1	0,001	2:1
Sheet GOST		Лист		Листов 1
Лист ДПРНМ 1,0М1 ГОСТ 495-9\2		Sheet		Sheets

356-22-2



Coating Zinc 6 microns, chromium 1 micron as per ИЛ-749-88 with removal hydrogen embrittlement.

Покрытие Цб. хр по ИЛ-749-88

с удалением водородной хрупкости

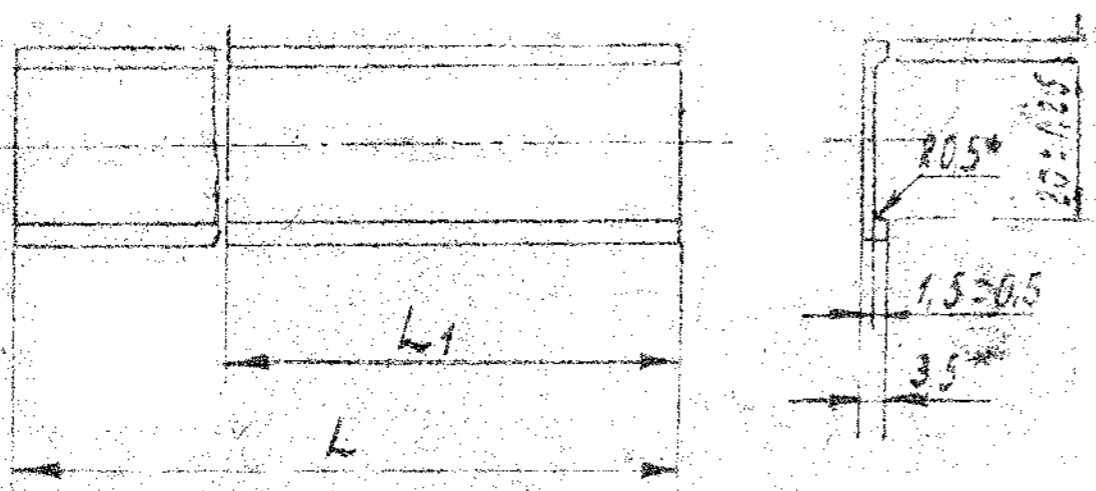
1. В тропическом исполнении покрытие Кд 9, хр по ИЛ-569-84 с удалением водородной хрупкости.

2. Заготовка должна соответствовать требованиям ГОСТ 1759.0-87 для класса точности В.

1. In tropical make, plating cadmium 9 microns, chromium 1 micron as per ИЛ-569-84 with removal hydrogen embrittlement.

2. Blank should correspond with requirement GOST 1759.0-87 for class of accuracy B.

Инд. № подл. 44982	Подп. и дата	Взам. инв. №	Инд. № докл.	Подп. и дата	356-22-2			
					Letter	Weight	Scale	
Изм.	Лист	№ докум.	Подп.	Дата	SCREW			
7	-	2000-73			Лит.	Масса	Масштаб	
Trans. & Ckd. by: M/s SWYAZ						Б	0,003	2:1
Authenticated by:						Лист	Листов	
Approved by:						Sheet	Sheets	
Engine Factory, Avadi					Заготовка Blank			
					Screw Винт М5-6d×12,58			
					ГОСТ ГОСТ 17473-80			



EXPLANATORY NOTE:

6. REFERENCE MATERIAL QUOTED :
UNVULCANISED OIL AND PETROL RESISTANT RUBBER CODE OF CLASSIFIER
IS - 1231, RUBBER GRADE HO- 68-1 TO TY DRS-216-75.

7. MECHANICAL PARAMETERS :
- i) RUPTURE STRENGTH Kgf/cm² - - - - - 90 Min.
 - ii) ELONGATION OF RUPTURE % - - - - - 250 Min.
 - iii) RESIDUAL ELONGATION AFTER RUPTURE % - - - - - 12 Max.
 - iv) HARDNESS No DP TO TM P DEVI E ARBITORY - - - - - 55 - 70
7. LIKELY EQUIVALENT GRADE / SPECIFICATION FOR NITRILE CHLOROPRENE
BASE TO BA 60 BS 2751-82 AND C 60 BS 2752-82.

KVD-No	PART NO	L ₁ - mm	MASS Kg	USED ON
78558	420-149-1	37±2	0.0026	CB 3335 00 2+30
78234	420-149-2	42±2	0.0029	CB 3335 00 10 CB3342-00-8 CB
78235	420-149-3	60±2	0.0042	
②	420-149-4	104±2		
78236	420-149-5	135±2	0.01	CB 3342-00-8 CB

1. *DIMENSIONS SHOULD BE ENSURED WITH TOOL.
2. LENGTH OF STRIP L₁ BEING SUPPLIED SHOULD NOT BE LESS THAN 1000 mm.
3. TO BE MANUFACTURED AS PER -T III H:100 GOST 15152-59
4. CO 420-149-1 SHOULD BE MARKED ON LABEL OF GASKETS BEING DELIVERED.
5. THE REST OF THE REQUIREMENTS AS PER SPECIFICATIONS 005216-75.

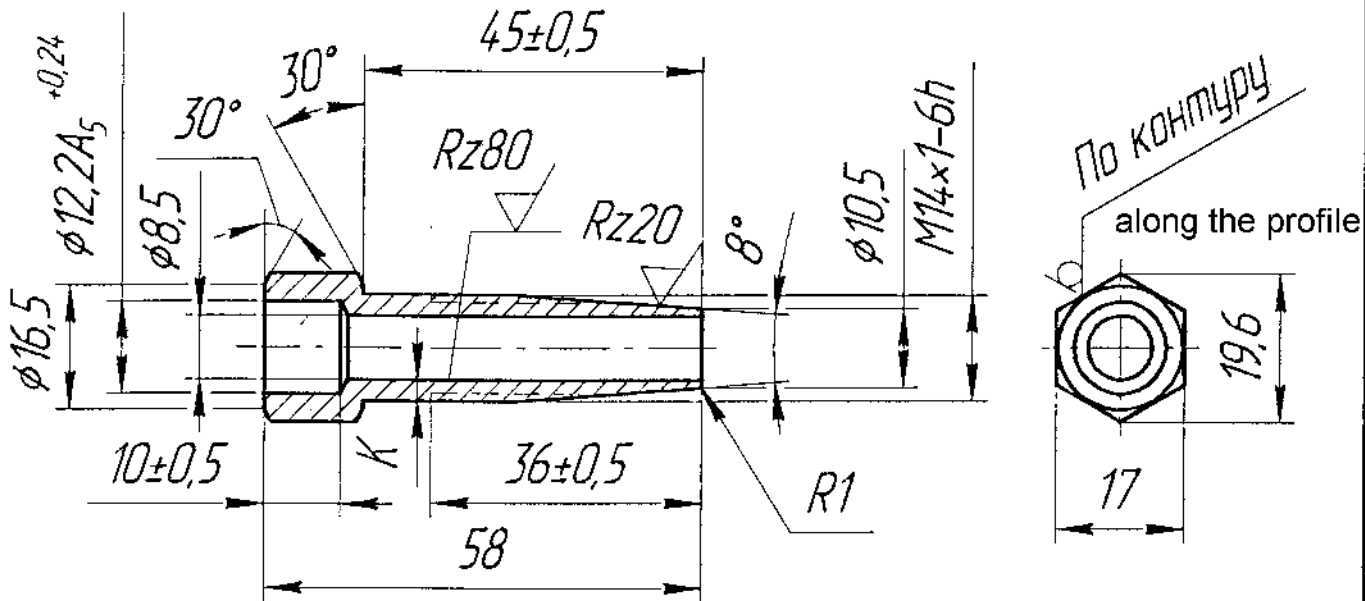
PILOT SAMPLE SHOULD BE APPROVED BY A M S P BEFORE BULK PRODUCTION.

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

DRW	CHK	TCD	APPL	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	ALL THREADS CONFORM TO	ISSUE	DATE	NATURE OF AMENDMENTS
					1:1						
MATERIAL - RUBBER HO-68-1 SPECIFICATIONS 005216-75								USED ON - SEE ABOVE			
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI								TITLE - GASKET			
D'S CAT NUMBER								DRAWING NUMBER 420-149-1 TO 5			

3320-246

Rz40 (✓)



2. Dimensions without tolerances are made with 7th class of accuracy OST 1010.
3. technical requirements for threads are carried out a per standard 82021-00.
4. Difference in wall thickness on dimension K should not exceed 0.5 mm.
5. Round off the sharp edges.

2. Размеры без допусков выполнять по 7 классу точности OST 1010.

3. Технические требования на резьбу выполнять по нормали 82021-00.

4. Разностенность по размеру K не более 0,5 мм.

5. Острые кромки затупить.

Подп и дата

Взам инв № Инв. № дробл

Подп и дата

Подп и дата

Инв. № подл. 44492

3320-246

10	-	87-74		
Изм	Лист	№ докцм.	Подп.	Дата
Trans. & Ckd. by: M/s SWYAZ				
Authenticated by:				
Approved by:				
Engine Factory, Avadi				

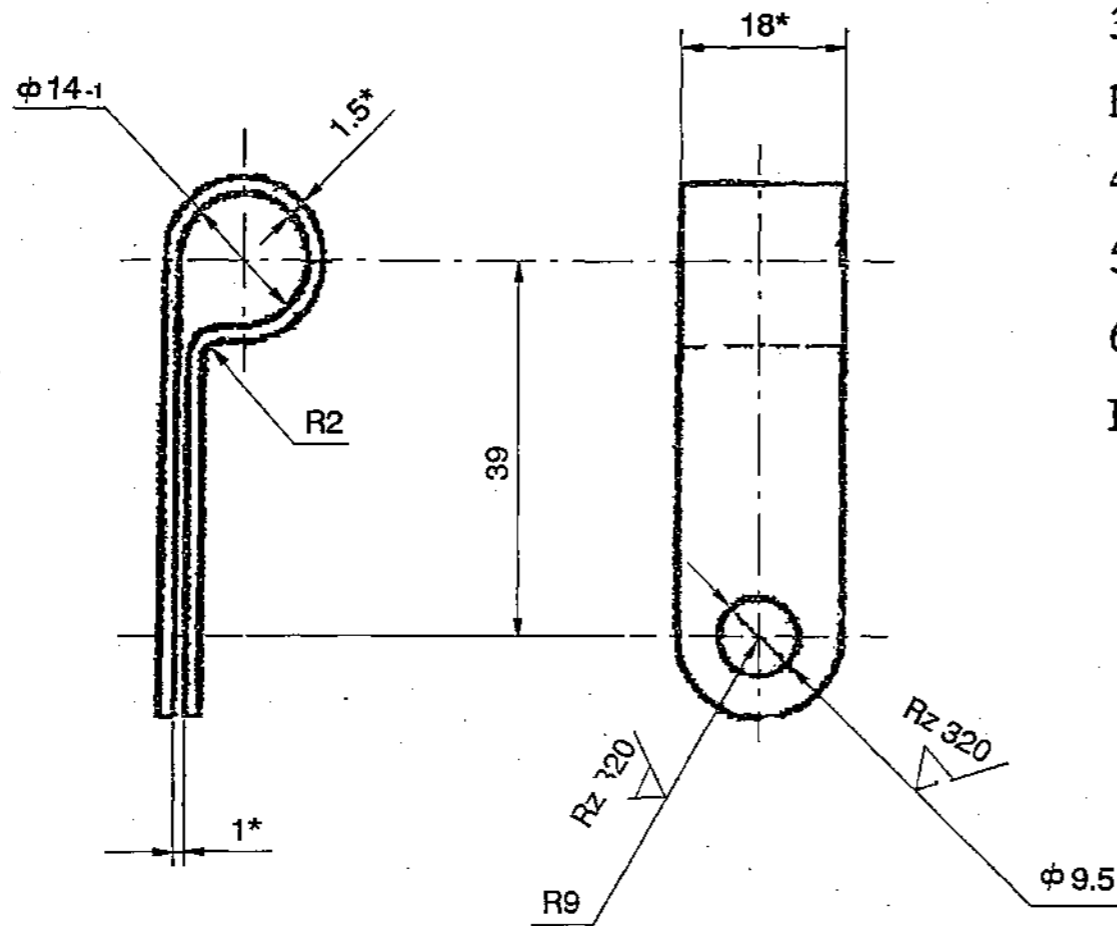
TIP			Лист	Масса	Масштаб
Накречник			A	0,045	1:1
Hexagon GOST			Лист	Листов	1
Шести-гранник			Sheet	Sheets	
17-н11 ГОСТ 8560-78					
45-Б ГОСТ 1051-73					

P. Janardhanan
 (P. JANARDHANAN)
 Dt. 15 Nov '10 JTO (D)

DRG. REINDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NIL

DRAWING NUMBER
3320-270

SHEET No. 1 OF 1



- 1) Developed length of the clamp = 129mm.
- 2) Unspecified limit deviations of dimensions are ± 0.5 .
- 3) Coating: zinc 6, chromating as per instructions ИЛ 749-88 with subsequent removal of hydrogen embrittlement, absence of coating on the inner surface of eyelet is allowed.
- 4) Varnish coating ГФ-95, GOST 8018-70 is allowed as per instructions ИЛ 628-86.
- 5) * Dimensions for reference.
- 6) In the tropical usage the coating should be cadmium 9, chromium as per instructions ИЛ 569-84 with subsequent removal of hydrogen embrittlement.

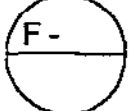
Ⓐ EQUIVALENT MATERIAL Gr. DD
 IS : 513 - 1994

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

EST. WT. (Kg) TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
 0.027

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

			DRN	Sd/=	MATERIAL :-	USED ON :- Cb 3335-00-9
			CHD	Sd/=	STRIP 08nc M2-1.5x18	
			APPD	Sd/=		
			DATE	Nov 2010	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
			SCALE:- 1 : 1			
			DIMENSIONS IN mm		TITLE :- CLAMP	
			TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69			
A	13.11.10	4 th Alt. Comm. Mfg. Minutes Point No.1 Dated 26.10.09	ALL THREADS TO CONFORM TO IS : 4218,PART-4.		D S CAT NUMBER	DRAWING NUMBER 3320-270
ISSUE	DATE	NATURE OF AMENDMENTS				



SIZE A3

