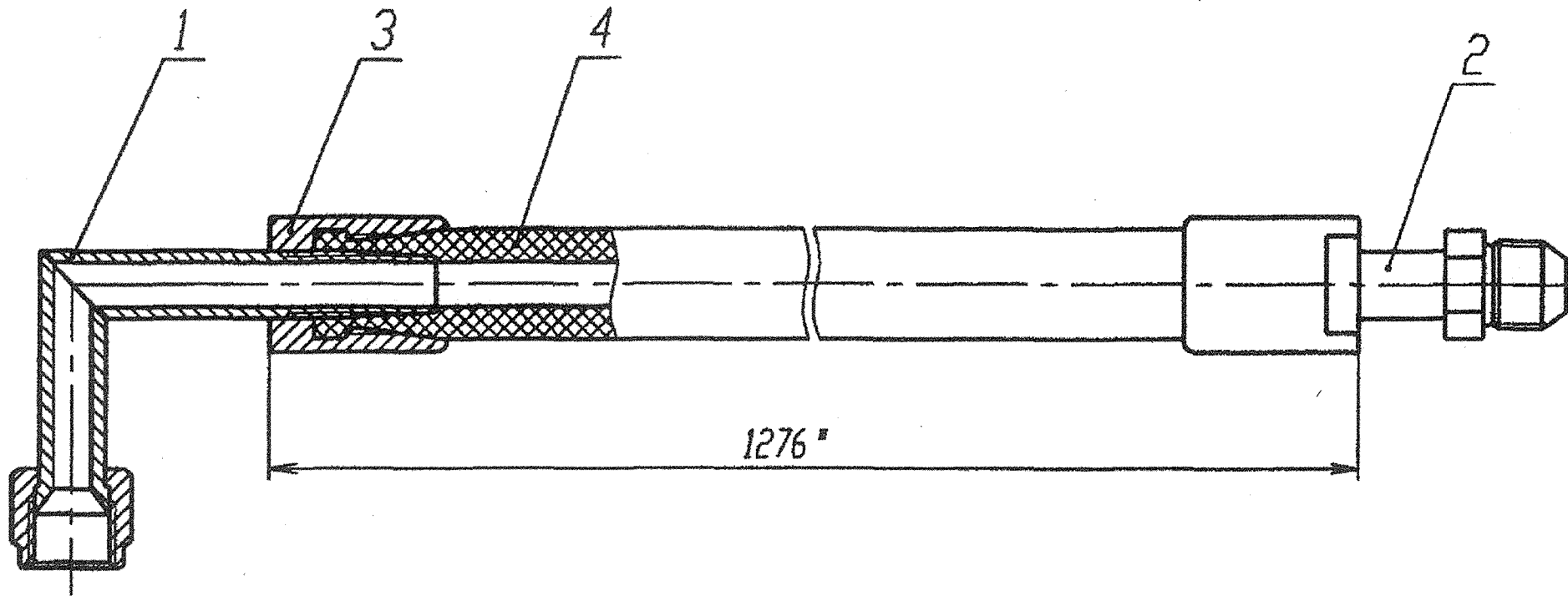


First use	Format	Zone	Pos.	Designation		Nomenclature		Qty.	Remarks
Reference No.						<u>Documents</u>			
	A3			AK-630 Sb 114-14 SB	Assembly drawing				
						<u>Assembly units</u>			
	A4		1	AK-630 Sb114-33	Elbow		1		
						<u>Components</u>			
	A3		2	AK-630 114-43	Nipple		1		
	A3		3	AK-630 114-91	Coupling		2		
						<u>Materials</u>			
			4		Hose 5U8-85		1	L=1260 mm	
					TU 38.005-1515-92				
Sign and Date									
Dupl. Inv. No.									
Alternate Inv. No.									
Sign and Date						AK-630 Sb 114-14			
	Amend.	Sheet	Doc. No.	Sign	Date				
Orig. Inv. No.	Developed by					Hose	Type	Sheet	Sheets
	Checked by						A		1
	Head of Q.C.D								
	Approved by								



- 1. * Reference dimension.
- 2. Test for strength with air pressure 80 atm. Carry out testing by loading three times and keeping for 10 minutes.
Disturbance of strength and tightness of joints is not permissible.
- 3. Check quality of joints on one hose from the batch consisting not less than 5 nos. by cutting the hose to not more than 50 mm from side of component pos.2, further use the shortened hose in article.
- 4. Mark Ш , Ч and stamp K on tag.

					AK-630 Sb 114-14 SB			
					Hose Assembly drawing			
Amend.	Sheet	Doc.No.	Sign	Date	A	0.500	1:1	
Developed by								
Checked by								
Head of Q.C.D								
Approved by								
					Sheet	Sheets 1		

First use

Reference No.

Sign and Date

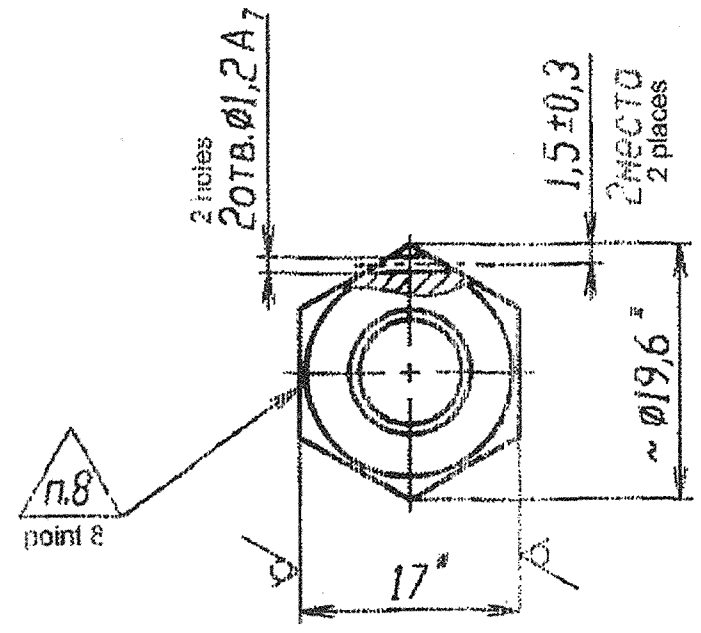
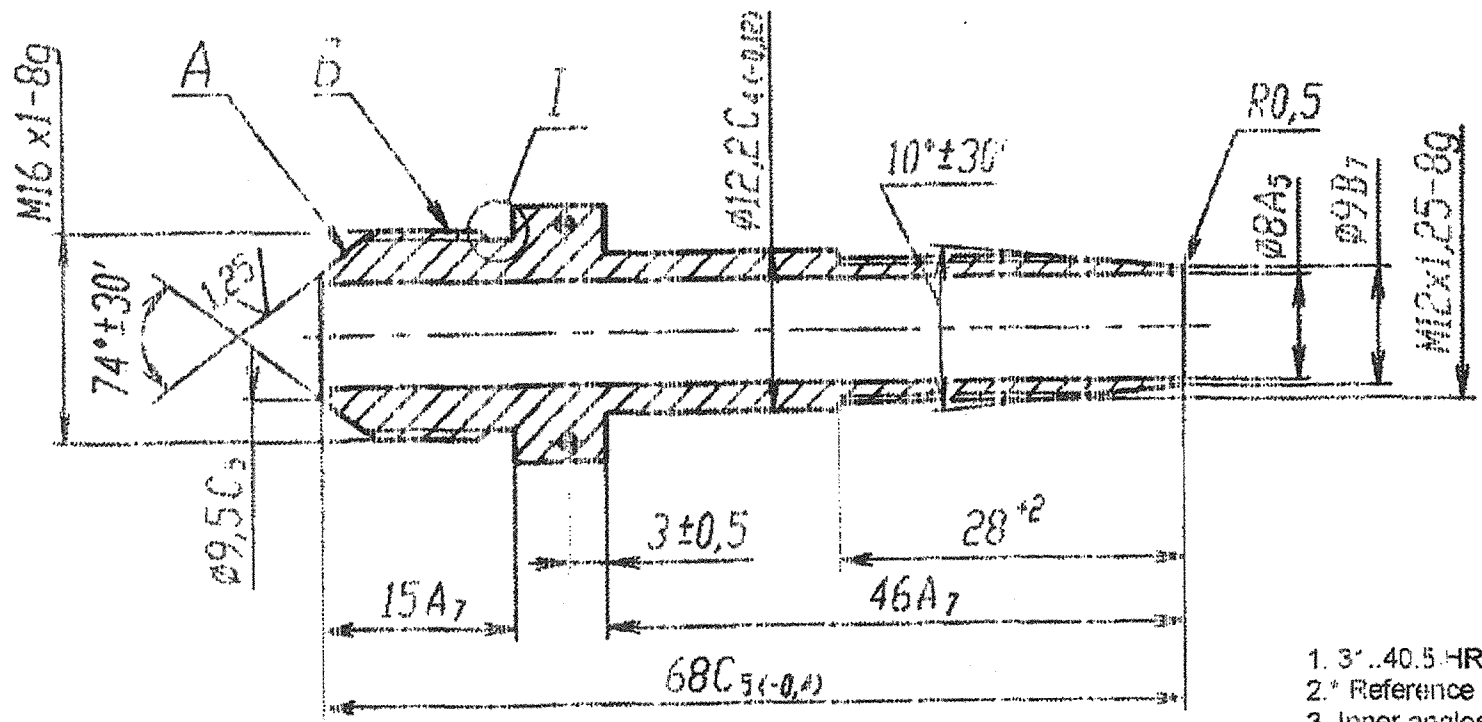
Duplicate Inv. No

Alternate Inv. No

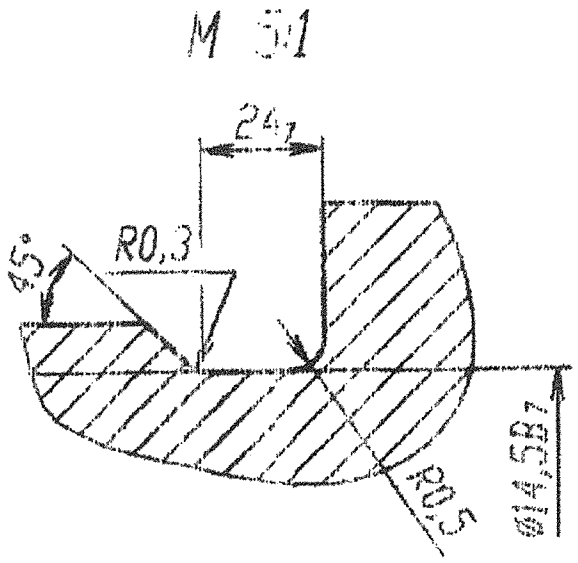
Sign and Date

Orig. inv. no.

Rz40
✓ (✓)



1. 3*..40.5 HRC. Check 2% , but not less than 3 nos. from batch.
- 2.* Reference dimensions.
3. Inner angles F:-0.4 mm.
4. Eliminate sharp edges -0.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.05 mm.
6. Coating Cd6.phos.Oil.
- It is permissible to avoid cadmium plating of inner surfaces
7. Mark Ш 4 and stamp K on tag.
8. Stamp M as per AK-630, AK-630M TU I.



					AK-630 114-43				
					Nipple		Type	Weight	Scale
							A	0.035	2:1
							Sheet	Sheets	1
					Hexagon				
							17 - 5GOST3560 - 78 40Kh - T - VG:ST:05... - 73		
Amend.	Sheet	Doc.No.	Sign	Date					
Developed by									
Checked by									
Head of C.C.D									
Approved by									

First use

Reference No.

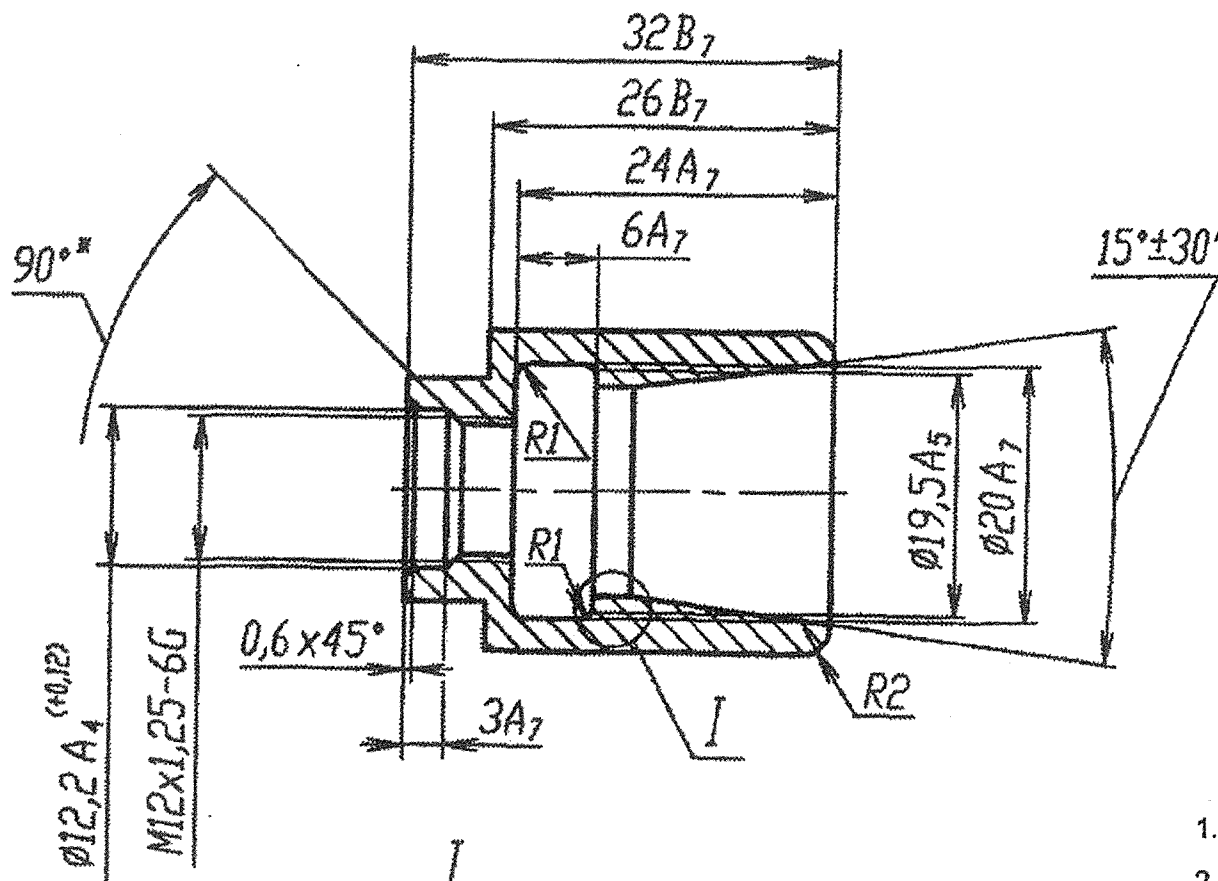
Sign and Date

Duplicate Inv. No

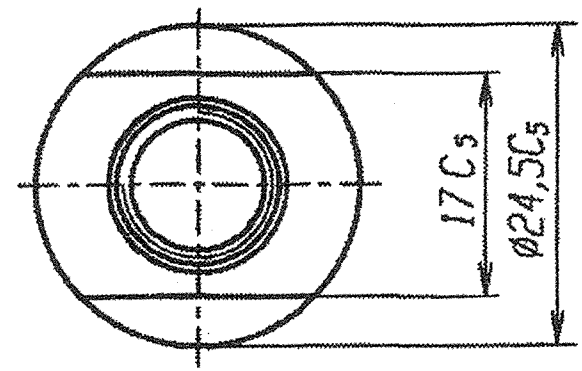
Alternate Inv. No

Sign and Date

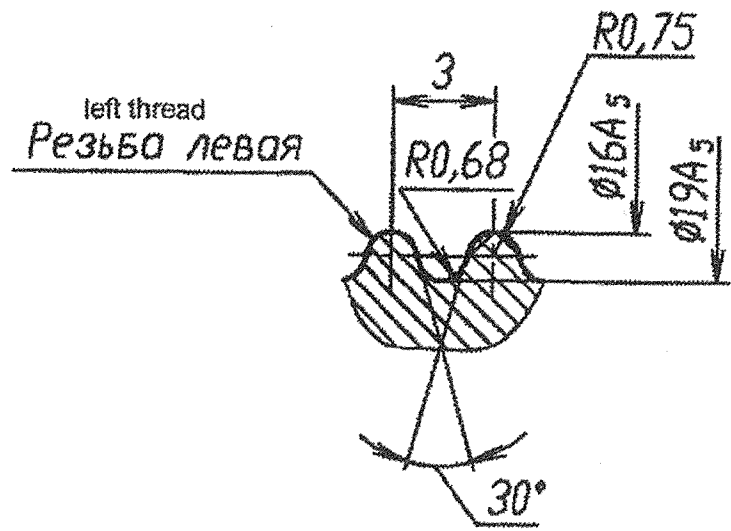
Orig. inv. no.



Rz40 ✓ (✓)



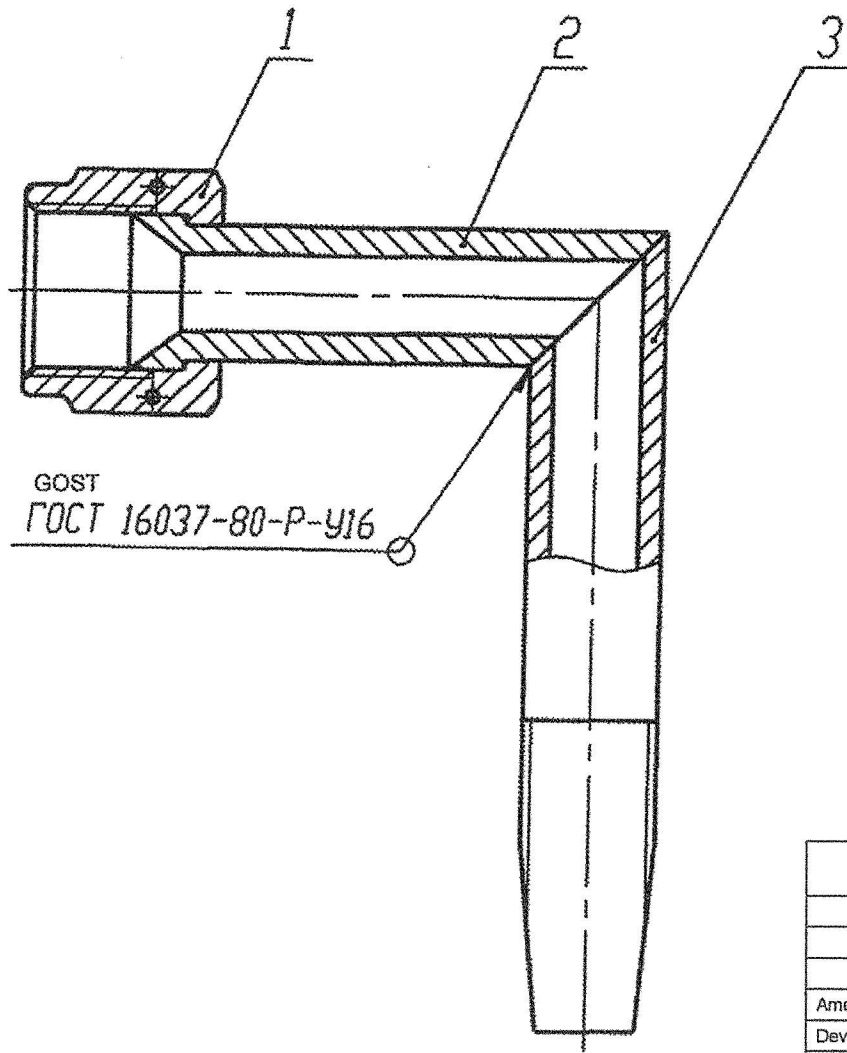
I
M(5:1)



1. Substitute material- wheel $\frac{25 - h11GOST7417 - 75}{12Cr18Ni10Ti - VTU14 - 1 - 3957 - 85}$
2. * Dimensions ensured by tool.
3. Inner angles R~0.4 mm.
4. Blunt sharp edges ~0.6 mm.
5. Coating Ep.
- External view of component as per test specimen.
6. Mark Ш, Ч and stamp K on tag.

AK-630 114-91

					AK-630 114-91			
Amend.	Sheet	Doc.No.	Sign	Date	Coupling	Type	Weight	Scale
Developed by						A	0.050	2:1
Checked by						Sheet	Sheets 1	
Head of Q.C.D								
Approved by					Wheel	$\frac{25 - VGOST2590 - 88}{12Cr18Ni9Ti - B - TGOST5949 - 75}$		



1. Welding rod TsL-11-3.0-2 GOST 9466-75.
2. Use of argon-arc welding is permissible. Filler wire 2 Sv -0.6 Cr19Ni9Ti GOST 2246-70.
3. Coating of external surface Chem. phos. Lacquer BF-4 with Nigrozene , 2 layers, made as per OST3-4123-78, IV, OM2, remaining Chem.phos.
4. Mark Ш , 4 and stamp K on tag.

First use

Reference No.

Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

					AK-630 Sb114-33 SB					
Amend.	Sheet	Doc.No.	Sign	Date	Angle piece Assembly drawing			Type	Weight	Scale
Developed by								A	0.050	2:1
Checked by								Sheet	Sheets	1
Head of Q.C.D										
Approved by										

AK-630 114-32

First use

Reference No.

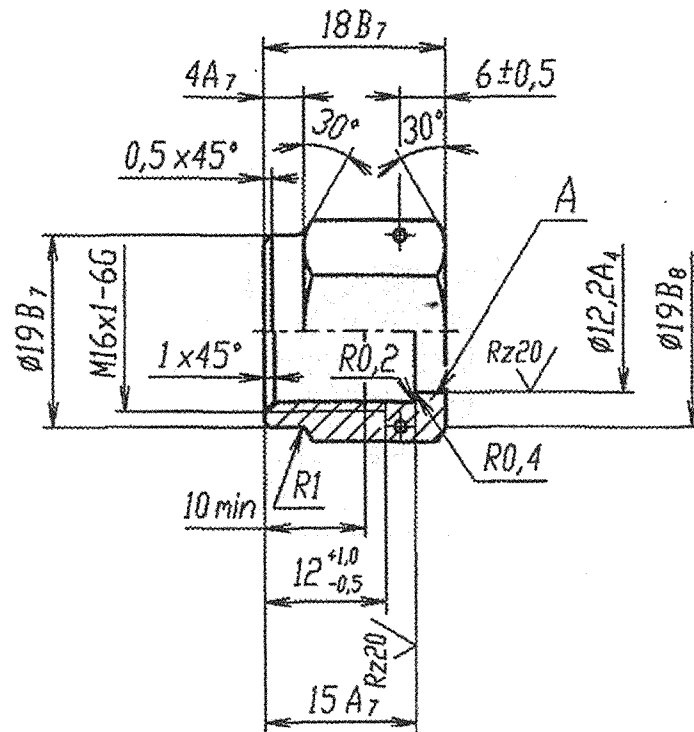
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



Rz40 ✓ (✓)

1. Substitute material- hexagon $\frac{19 - 5GOST8560 - 78}{40GOST1051 - 73}$
2. 31..40.5 HRC_E. Check 3..5% , but not less than 3 nos. from batch.
- 3.* Reference dimensions.
4. Blunt sharp edges ~0.2 mm.
5. Run out of surface A with respect to mean diameter of thread is not more than 0.01 mm.
6. Mark Ш, Ч and stamp К, И on tag.

Designation	Coating
AK-630 114-32	Cd6.phos.
AK-630-01	Without coating

AK-630 114-32							
Amend	Sheet	Doc.No.	Sign	Date			
Coupling nut					Type	Weight	Scale
					A	0.025	2:1
Hexagon $\frac{19 - 5GOST8560 - 78}{40Kh - T - VGOST1051 - 73}$					Sheet	Sheets	1
Head of Q.C.D							
Approved by							

AK-630 114-72

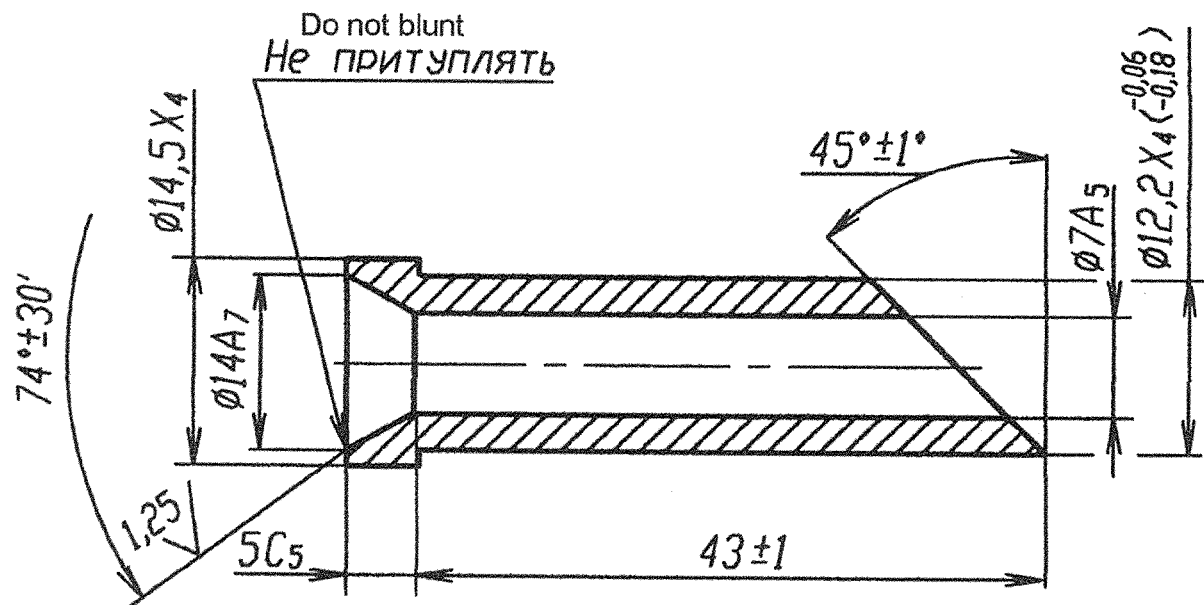
Approved by shop
Reference No.

Approved KTONI
Sign and Date

Approved TOSb
Dupl. Inv. No.

Approved OGMet
Orig. Inv. No.
Sign and Date

Rz40
✓(✓)



1. Inner angles R~0.4 mm.
2. Blunt sharp edges R~0.2 mm.
3. Mark Ш, Ч and stamp K on tag.

AK-630 114-72

Nipple

Steel 12Cr18Ni9Ti
GOST 5632-72

Type	Weigh	Scale
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A	0.015	2:1
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Sheets 1

AK-630 114-84

First use

Reference No.

Sign and Date

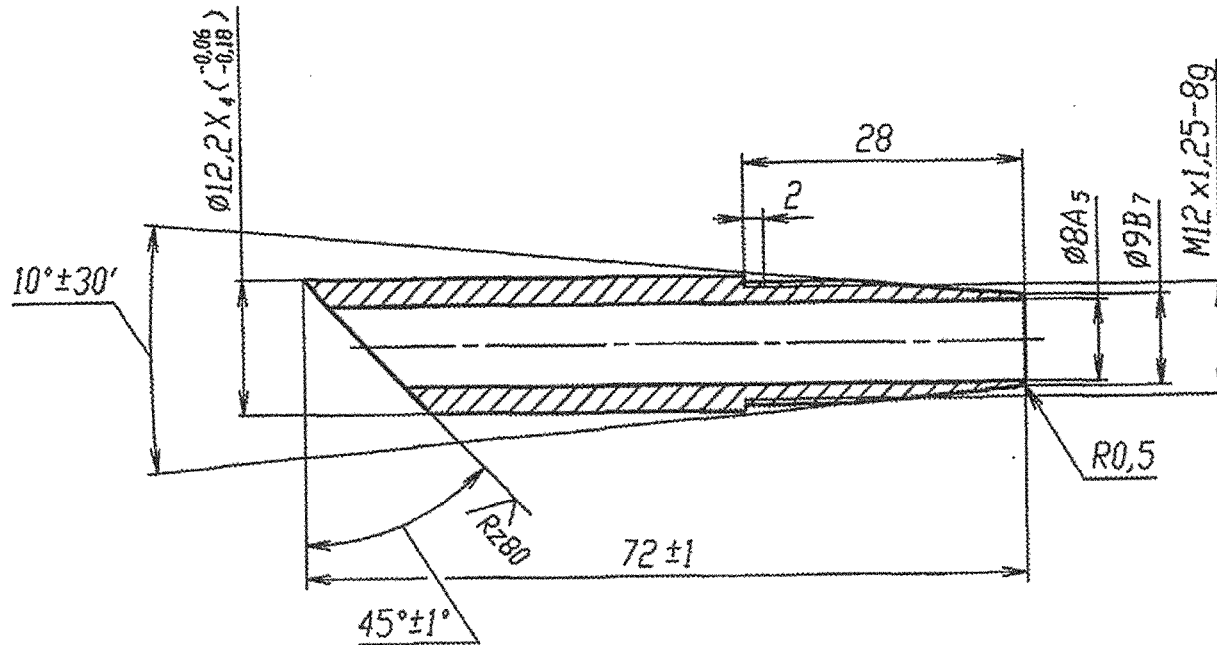
Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

Rz40 ✓ (✓)



1. Blunt sharp edges ~0.4 mm.
2. Mark Ш, Ч and stamp K on tag..

					AK-630 114-84			
Amend.	Sheet	Doc.No.	Sign	Date	End cap	Type	Weight	Scale
Developed by						A	0.030	2:1
Checked by						Sheet	Sheets	1
Head of Q.C.D					Steel 12Cr18Ni9Ti			
Approved by					GOST 5632-72			