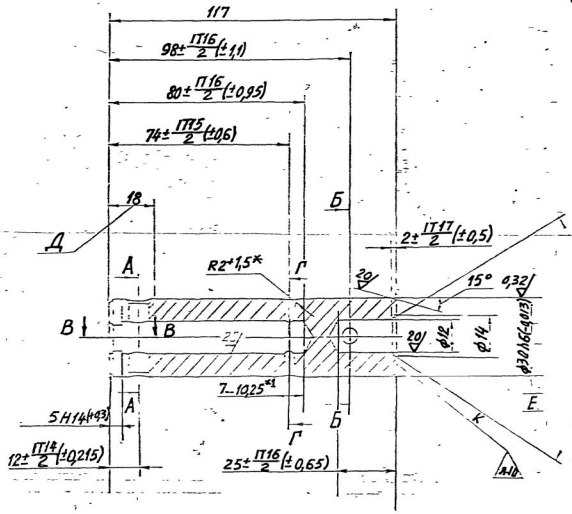
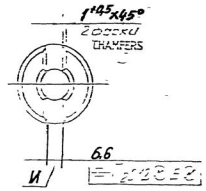
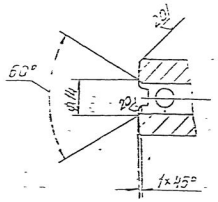
3338-440

ЕСКД

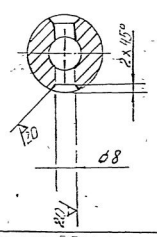




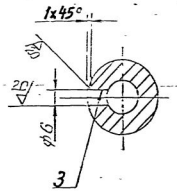
Б-Б



А-А

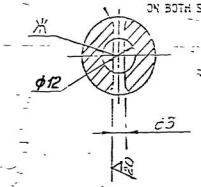


Б*Б



Г-Г

TO BE POLISHED ALONG PROFILE
Полировать по контуру
ВСЕ СЛОЖНО
ON BOTH SIDES



TECHNICAL REQUIREMENTS IN RUSSIAN

1 Группа контроля III по ТТ-11.
2 Поверхность Е цементировать h 0,5...1,0мм; 57 HRCэ не менее; на длине Д допускается отсутствие цементации.
Допускается цементировать кругом.
3. 20...41HRCэ нецементированной зоны; допускается проверять выборочно от партии.
4. Неуказанные предельные отклонения размеров: h14; h14.
5. Допускается уменьшение размера И до 6,5мм.
6. Допускается уменьшение размера Ж до 11,8мм.
7. Деталь проверять на магнитном дефектоскопе по ТТ 15-17.
8.* Размер обеспечить инструментом.
9.*1 Размер для справок.
10. Клеймить электроискровым или электрохимическим способом.
11. Расположение отверстия 3 безразлично.

TECHNICAL REQUIREMENTS - TRANSLATED

1. INSPECTION GROUP III AS PER TT - 11.
2. SURFACE E IS TO BE CARBURIZED TO h 0.5.....1.0mm, 57 HRC$_3$ min; ON LENGTH Д CARBURIZING IS NOT ALLOWED. TO BE CARBURIZED ALL OVER.
3. HARDNESS OF NON-CARBURIZED ZONE 20....41 HRC$_3$ MAY BE CHECKED AT RANDOM
4. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS H14; h 14.
5. DIMENSION И MAY BE DECREASED TO 6.5 mm.
6. DIMENSION Ж MAY BE REDUCED TO 11.8 mm.
7. COMPONENT IS TO BE CHECKED FOR DEFECTS WITH MAGNETIC FIELD FLAW DETECTOR AS PER TT UB - 17.
8. * DIMENSIONS SHOULD BE ENSURED WITH TOOL.
9. *1 DIMENSION FOR REFERENCE.
10. TO BE MARKED BY ELECTRIC SPARK METHOD or ELECTRO-CHEMICAL METHOD.
11. POSITION OF HOLE 3 IS OPTIONAL.

EXPLANATORY NOTE :

MATERIAL QUOTED STEEL 20X GOST 4543-71

STRUCTURAL CHROMIUM ALLOY QUALITY STEEL TO GRADE 20X AS PER GOST 4543-71.

a) CHEMICAL COMPOSITION :- %

C O N T E N T O F E L E M E N T S %							
C	Si	Mn	Cr	P	S	Cu	Ni
				M A X		I M U M	
0 17-0.23	0 17-0.37	0.50-0.80	0 70-1.00	0 035	0 035	0.30	0.30

b) MECHANICAL PROPERTIES :

YIELD POINT Kgf/mm²	ULTIMATE STRENGTH Kgf/mm²	RELATIVE ELONGATION %	RELATIVE REDUCTION ALONG CROSS SECTION %	IMPACT STRENGTH Kgfm/cm²
m i n i m u m				
65	80	11	40	6

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

EST. MASS 0.46 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.

ISSUE	DATE	NATURE OF AMENDMENTS

DRN
CHD
TCD
APPD
DATE 12-7-88
SCALE - 1 : 1
DIMENSIONS IN mm
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.
ALL THREADS CONFORM TO

MATERIAL :- STEEL 20 X GOST 4543-71

USED ON - Cb 3338-401-10

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A D I

TITLE :- IDLE GEAR AXLE

D S CAT NUMBER

DRAWING NUMBER 3338-440