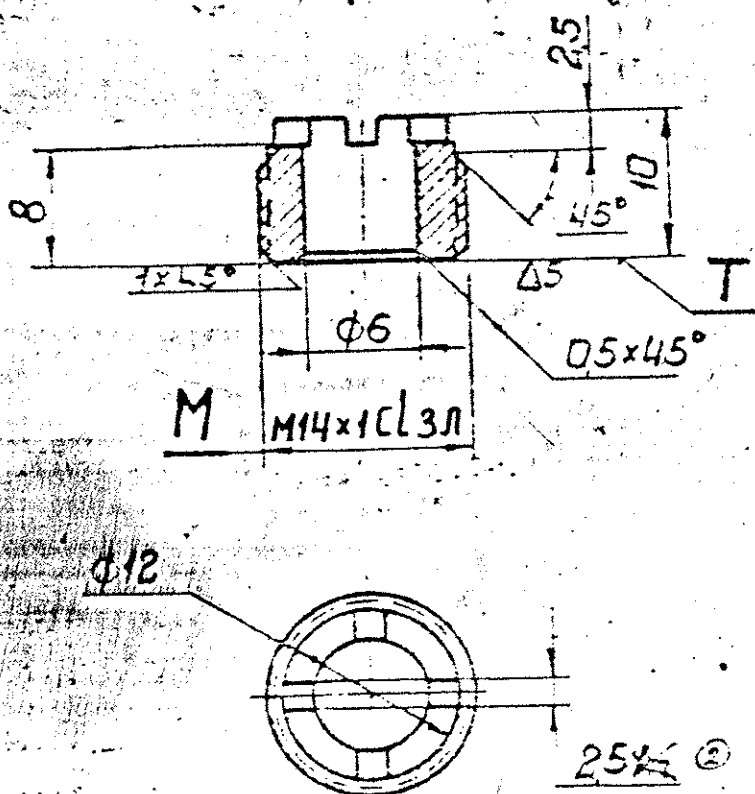


AK 150B-117

UNLESS SPECIFIED OTHERWISE
TOLERANCES ON FREE DIMENSIONS
ARE AS PER 22AT 52, CLASS 7.



NON SQUARENESS OF SURFACE 'T'
TO ANGLE DIAMETER OF THREAD 'M'
SHOULD NOT EXCEED 0,08.

ALT. MATL:
STEEL 40 Cr 4 Mo 3 TO IS: 5517-78
OR EN 19 TO BS: 970. HRC=30-36

THREAD BEFORE COATING IS AS
PER 214 AT.

HARDNESS: HRC 24 TO 30
CADMIUM PLATED, 9 TO 13
MICRONS THICK.

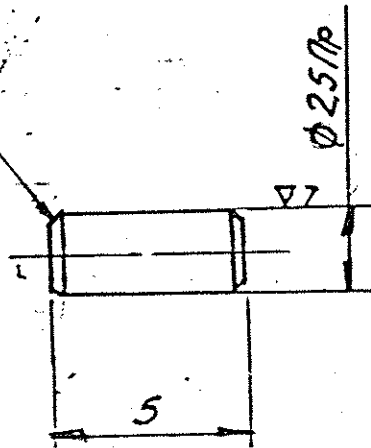
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

			EST. MASS. 8	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	MATERIAL:- STEEL 45 TY 14-1-151-72	USED ON:- AK 150C 19 CE
DRW h. h. w.		SCALE - - 2:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHK Bhattach		DIMENSIONS IN mm	TITLE: CLAMP	
TLD h. h. w.		TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	D S CAT NUMBER	DRAWING NUMBER AK 150B-117
APPD h. h. w.		ALL THREADS CONFORM TO		
DATE 22.7.86				

DRAWING NUMBER
AK150B-120

∇4 UNLESS SPECIFIED OTHERWISE
TOLERANCE FOR FREE DIMENS
-IONS ARE AS PER 22AT52.

0.3X45° FROM
BOTH ENDS.



147

HARDNESS: HRC 44 TO 50
COATING: PARKERIZING WITH
OXIDATION.

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

		EST. MASS. 0.2	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 0.1 SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL:- BRIGHT POLISHED USED ON:- CARBON TOOL STEEL AK150C-50CE Y10A GOST 14955-69	
DRN CP	SCALE:- 5:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD Bhatnagar	DIMENSIONS IN mm	TITLE: PIN	
TCD Sundar	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
APPD Vijay	ALL THREADS CONFORM TO	DRAWING NUMBER AK150B-120	
DATE 22.7.86			

236A

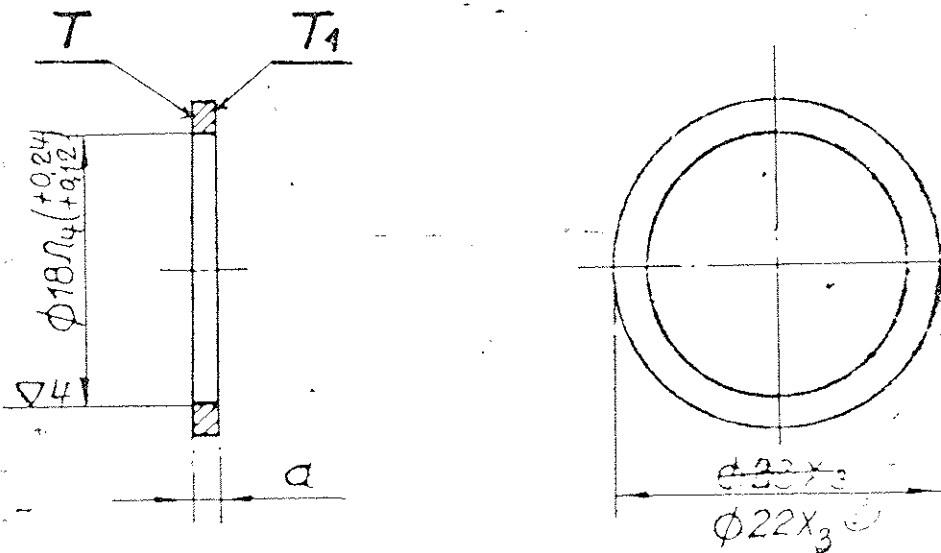
19

WA

122

DRAWING NUMBER
AK 150B_133

▽5 UNLESS OTHERWISE SPECIFIED.



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

d	QTY	WT.
1.1 ± 0.05	2	
1.2 ± 0.05	2	
1.4 ± 0.05	2	
1.3 ± 0.05	2	

ALT MATL:-

AL ALLOY 19000 'O' TO
IS: 737-86

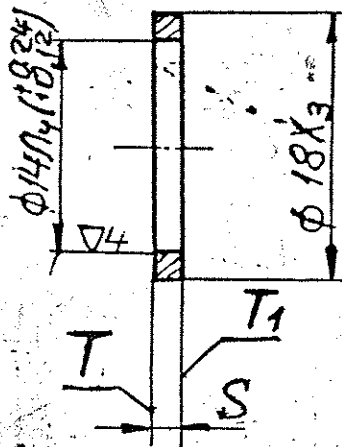
DRESS BURRS.
DEVIATION FROM PARALLELISM FACES
T AND T₁ SHOULD NOT EXCEED 0.05.

KVD 74803

			EST. MASS 0,5	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 :- ALUMINIUM ALLOY AM GOST 4783-68	USED OR :- AK 150C.01CS
DRG		SCALE - 2:1.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADK	
APPD		DIMENSIONS IN mm.	STYLE :-	RING SEALING
DATE		TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	B S CAT NUMBER	DRAWING NUMBER AK150B-133
		ALL THREADS CONFORM TO		

DRAWING NUMBER
AK 150B-134

▽5 UNLESS OTHERWISE SPECIFIED.



DRESS BURRS.
DEVIATION FROM PARALLELISM
OF BUTT-ENDS T AND T₁ SHOULD
NOT EXCEED 0,05mm.

ALT. MATL.:

AL ALLOY 19000 TO IS: 737-86

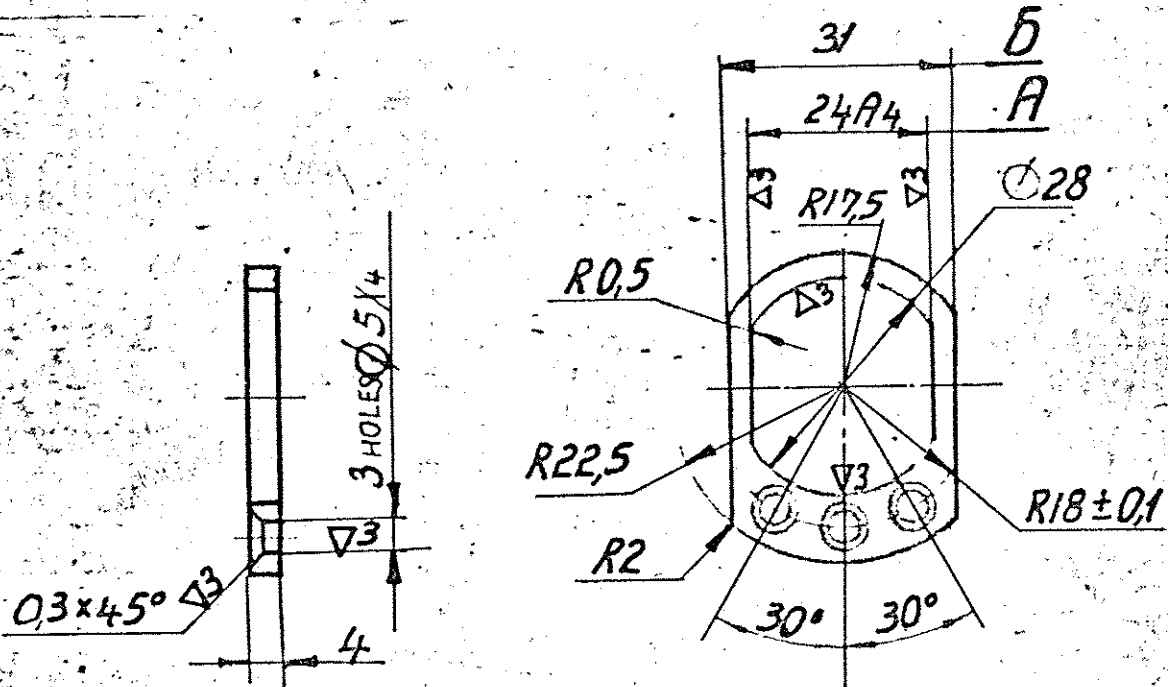
1,7±0,05	2
1,6±0,05	2
1,5±0,05	2
1,4±0,05	2
1,3±0,05	2
1,2±0,05	2
1±0,05	2
S	QTY

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

		EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THIS #
		0.36	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 AMENOMENTS	
DRM AK		SCALE - 2:1	MATERIAL:- ALUMINIUM ALLOY AM GOST 4783-68
CPD Bhattach		DIMENSIONS IN mm	USED ON:- AK 150B-33CB AK 150B-38CB AK 150C-01CB
TLD Sardha		TOLERANCE ON DRMS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD.
APPD K			TITLE: RING SEALING
DATE		ALL THREADS CONFORM TO	DRAWING NUMBER AK 150B-134
22.7.86			

DRAWING NUMBER
AK 150B.136

UNLESS SPECIFIED OTHERWISE
TOLERANCES ON FREE DIMNS
ARE AS PER 22AT 52.



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

DEVIATION FROM SYMMETRIC POSITION OF
SURFACE A WITH RESPECT TO SURFACE B
SHOULD NOT EXCEED 0,5mm.

ALT. MATL:-
STEEL En19/En24 TOBS:970

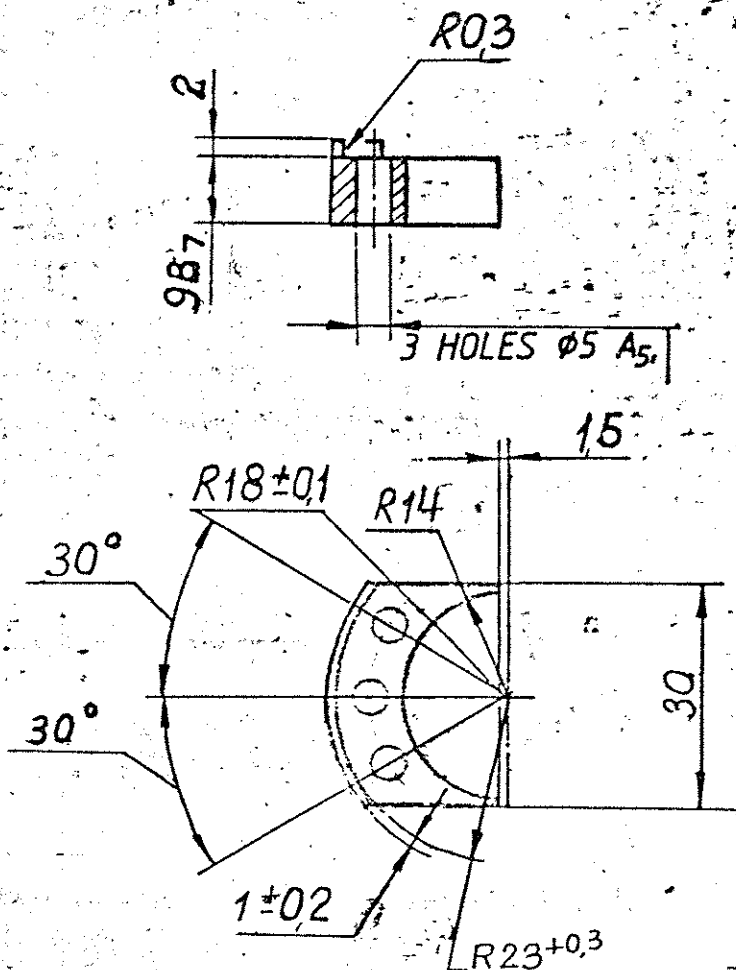
HARDNESS:-HRC 18 TO 24.
COATING:-CADMIUM-PLATED,
9 TO 13 MICRONS THICK.

			EST. MASS 13,5	TO BE STAMPED OR MARKED WHERE INDICATED THIS \neq 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:- STEEL 30X1CA GOST 11269-65	USED ON:- AK150C-01CB
CHKD S. Mohan		DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE:- LOCKING PLATE	
APPD 25/7/2		ALL THREADS CONFORM TO	B S CAT NUMBER	DRAWING NUMBER AK150B-136

NA

DRAWING NUMBER
AK 150B-140.

LIMIT DEVIATIONS OF CASTING
DIMENSIONS ARE AS PER
OST 1.41154-72.



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

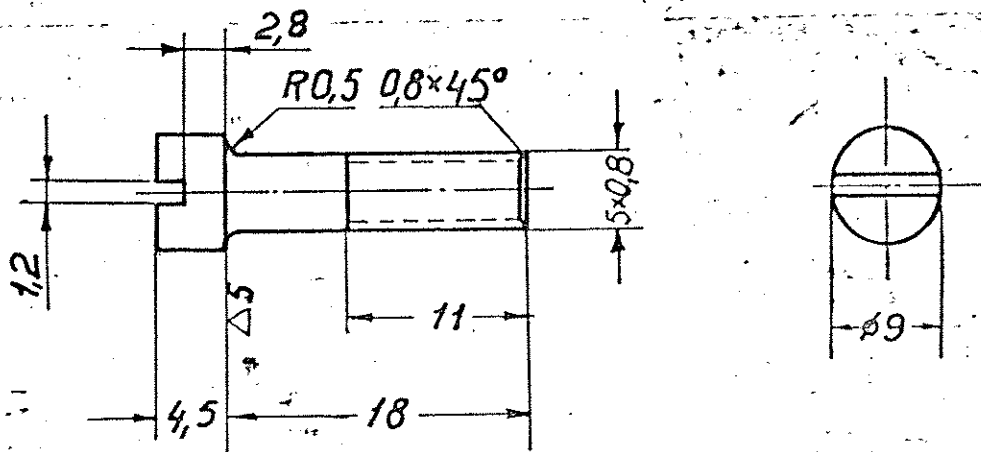
PRESSURE DIE CASTING
ACCURACY CLASS ΔT_3

ANODIZE

			EST. MASS 7.5	TO BE STAMPED OR MARKED WHERE INDICATED THIS \neq 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 - ALUMINIUM ALLOY AL-9 GOST-90021-71	USED ON:- AK 150C. 0105
CHKD <i>Shalaby</i>		DIMENSIONS IN mm	CONT. TOLLERATE OF INSPECTION (HEAVY VEHICLES) AVADL	
TEL <i>S. G. G.</i>		TOLERANCE ON DIM'S UNLESS OTHERWISE STATED	TITLE:- SUPPORT	
APPD <i>V. V.</i>		ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER AK 150B-140
DATE 25/7/16				

DRAWING NUMBER
AK 150 B-141

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



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

WHILE MAKING THREAD BY ROLLING,
BLANK AND CHAMFER ARE AS PER 163 MT.

THREAD BEFORE COATING - AS PER 214 AT.


ALT. MATL :-

STEEL 40Cr4Mo3 TO IS:5517-78
OR EN 19 TO BS:970. HRC 26-32

HARDNESS Rc = 24 TO 30.

COATING :- CADMIUM-PLATED,

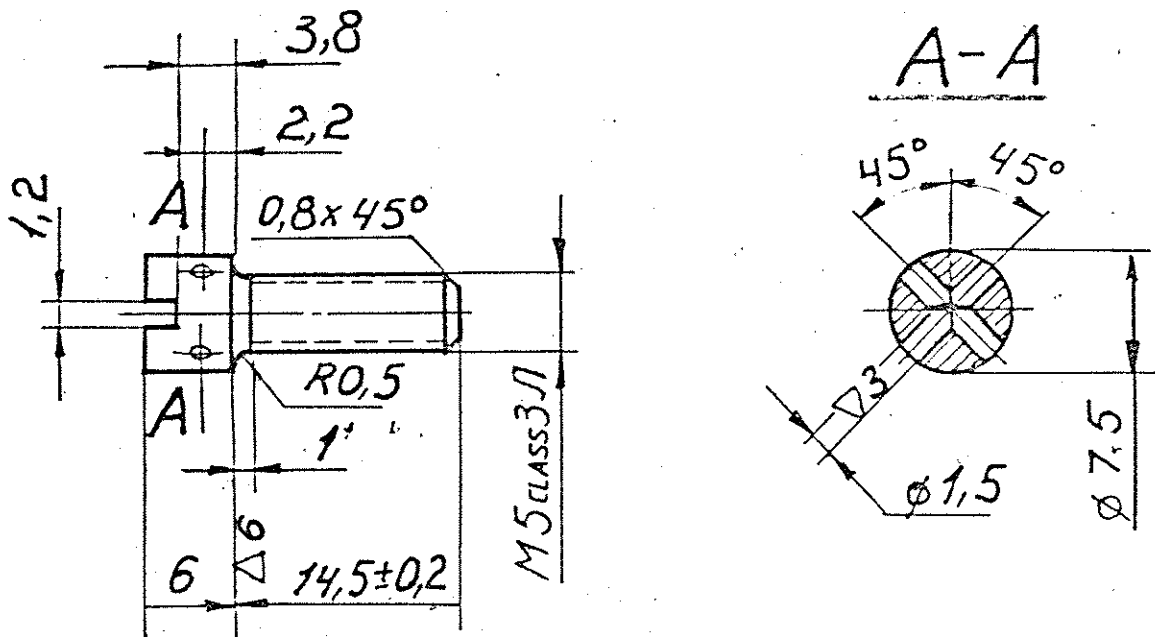
9 TO 13 MICRONS THICK.

		EST. MASS 4,2	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:- STEEL 38 X A TY 14-1-950-74	USED ON:- AK 150C-01 CB
DRN 28/11/74	SCALE - 2:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAIL	
CHD 28/11/74	DIMENSIONS IN mm	TITLE:- SCREW	
TCD 28/11/74	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	B S CAT NUMBER	
APPD 28/11/74	ALL THREADS CONFORM TO	DRAWING NUMBER AK 150B-141	

DRAWING NUMBER

AK 150 B.142

UNLESS OTHERWISE SPECIFIED
TOLERANCES FOR FREE DIMENSIONS ARE AS
PER 22AT52 - CLASS 7.



HARDNESS HRC 26 TO 32
CADMIUM PLATING, 9 TO 13 MICRONS THICK

ALT. MATL:-

STEEL 40Cr4Mo3 TO IS: 5517-78
OR EN 19 TO BS: 970. 26-32 HRC

THREAD MAY BE MADE BY ROLLING.
THREAD BEFORE COATING IS AS PER 214 AT.

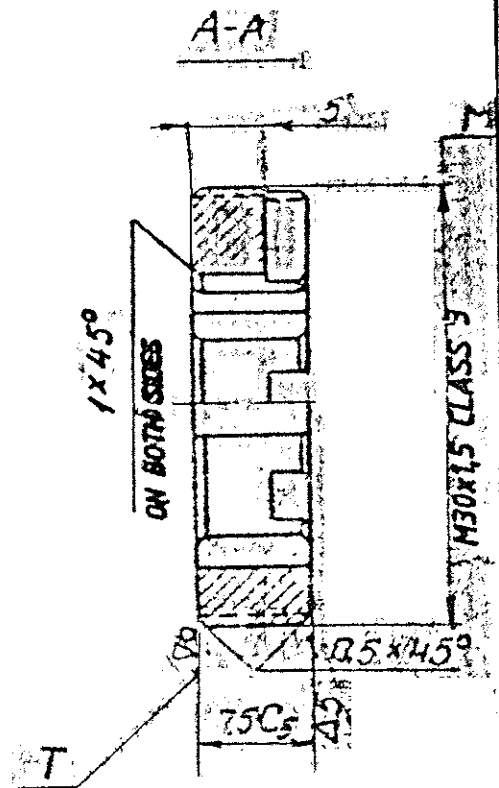
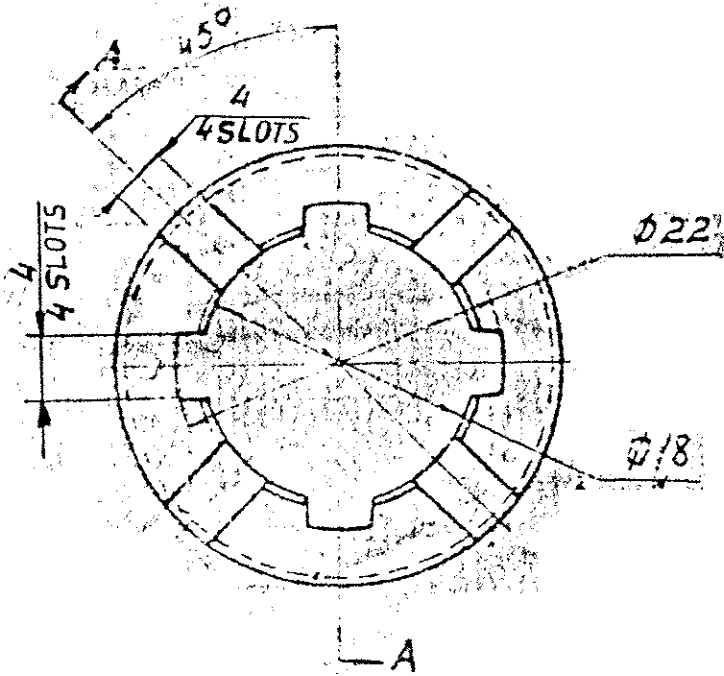
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

			EST. MASS 3,5	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	MATERIAL:- STEEL 38XA TY 14-1-950-74	USED ON:- AK150C-01CB
DRW C		SCALE - 2:1	CONTROLLEDATE OF INSPECTION (HEAVY VEHICLES) AVADL	
CHD Bhullal		DIMENSIONS IN mm	TITLE:- SCREW	
TEO J.M.S		TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
APPD Kry		ALL THREADS CONFORM TO	DRAWING NUMBER AK 150B-142	
DATE 25/7/70				

DRAWING NUMBER

AK150B-145

▽4 UNLESS OTHERWISE SPECIFIED.
TOLERANCES ON FREE DIMENSIONS ARE
AS PER 22AT52 CLASS 7.



RUN OUT OF SURFACE T WITH RESPECT TO
ANGLE DIAMETER OF THREAD M SHOULD
NOT EXCEED 0,08mm.

THREAD BEFORE COATING IS AS PER 214 AT.

ALL MATT

STEEL 40Cr4Mo3 TO IS: 5517-78
OR EN 19 TO BS: 970, HRC 28-35

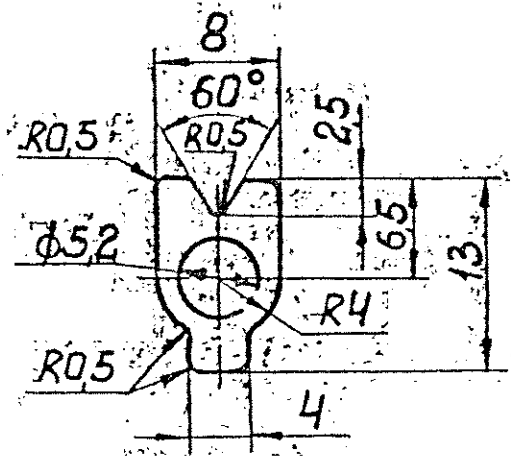
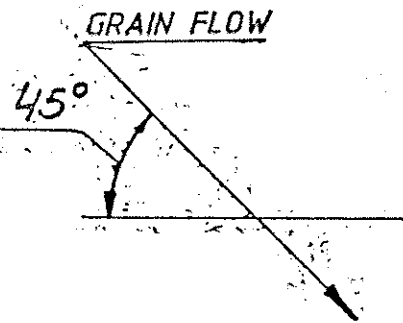
HARDNESS HRC = 28 TO 35.
CADMIUM PLATING 9 TO 13
MICRONS THICK.

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

		EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THUS #	
		15	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	MATERIAL:-	USED ON:-
DRN G.P. CPD		SCALE - 2:1	PIPE B-32x8 - 38xA GOST 21729 - 76	AK 150C 19 CB
		DIMENSIONS mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
		TOLERANCE ON DRWS UNLESS OTHERWISE STATED	TITLE:	NUT
		ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER AK150B-145
	22.7.86			

AK150B-197

TOLERANCES ON FREE DIMENSIONS ARE AS PER 22AT52.



DIMENSION S.	QTY.
0.6	1
0.7	1

ALT. MATL:-
STEEL Gde 'D' TO IS: 513-86

COATING : CADMIUM PLATED, 9 TO 13 MICRONS THICK.

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

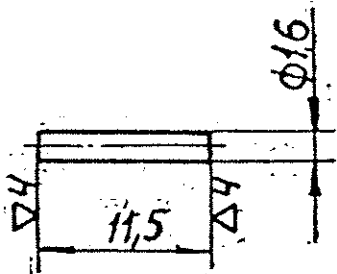
		EST. MASS. 0.3	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL:- STEEL 10 ISCT 16523-70	USED ON:- AK150B-36 CB
DRN <i>CPK</i>	SCALE - 2:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD <i>Chakraborty</i>	DIMENSIONS IN mm	TITLE: LOCK WASHER	
TCD <i>V. Ram</i>	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.		
APPD <i>[Signature]</i>	ALL THREADS CONFORM TO	D'S CAT NUMBER	DRAWING NUMBER AK150B-197
DATE 22.7.86			

DRAWING NUMBER

AK150B-200

UNLESS OTHERWISE SPECIFIED.

TOLERANCES ON FREE DIMENSIONS ARE AS PER 22AT52



ALT. MATL:-

MILD STEEL WIRE 1/4 HARD
TO IS: 280-78

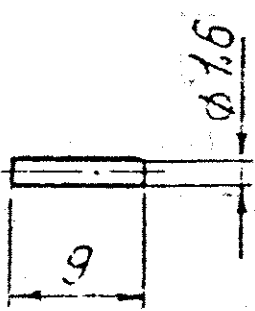
OXIDIZE

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

		EST. MASS. 0.183	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	MATERIAL:- WIRE 1.6-10 GOST 17305-71	USED ON:- AK 150B 60CB
DRN A. P. M.	SCALE:- 2:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD S. H. T.	DIMENSIONS IN mm	TITLE: COTTER PIN	
TCD A. P. M.	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	D S CAT NUMBER	DRAWING NUMBER AK 150B-200
APPD A. P. M.	ALL THREADS CONFORM TO		
DATE 22.7.86			

DRAWING NUMBER
AK150B - 201

~
TOLERANCES ON FREE DIMENSIONS ARE
PER 22AT52



ALT. MATL:-
MILD STEELWIRE 1/4 HARD
TO IS: 280-78.

DRESS BURRS.

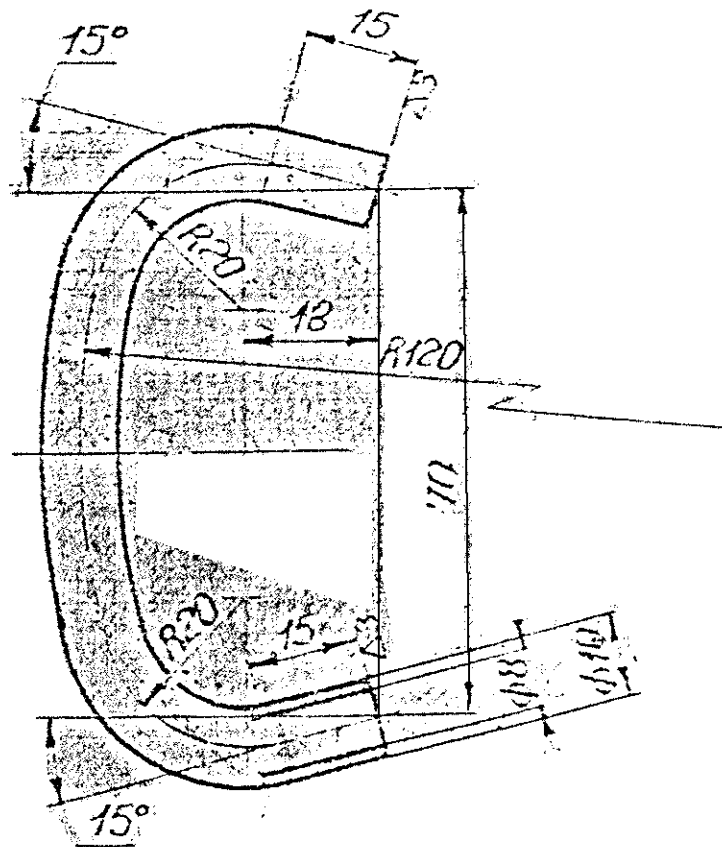
OXIDATION (COATING),

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

			EST. MASS. 0.13	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		MATERIAL:- WIRE 1.6 - 10	USED ON:-
DRN CPR	SCALE:- 2:1		GOST 17305-71.	AK 150B - 36CB
CHD Chakraborty	DIMENSIONS IN mm		CONTROLLER/TE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD V. Rev	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.		TITLE:	PIN
APPD K	ALL THREADS CONFORM TO		D S CAT NUMBER	DRAWING NUMBER AK150B - 201
DATE 22.7.86				

DRAWING NUMBER
AK150B-207

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



RUN OUT OF BUTT ENDS WITH RESPECT TO
SURFACE ϕ 10 (OVER LENGTH 15mm) SHOULD
NOT EXCEED 1,5mm.
OVALITY AT RADIAL BENDING SHOULD NOT EXCEED 1,3 MM.

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

		EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
		3.4	
		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:-	USED ON:-
DRN <i>CPL</i>	SCALE:- 1:1	COPPER M3	AK150B - 59CB
CHD <i>Chattachy</i>	DIMENSIONS IN mm	GOST 617-72.	
TCD <i>V. Ram</i>	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APPD <i>Vz</i>		TITLE:	PIPE
DATE	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
22.7.86			AK150B - 207

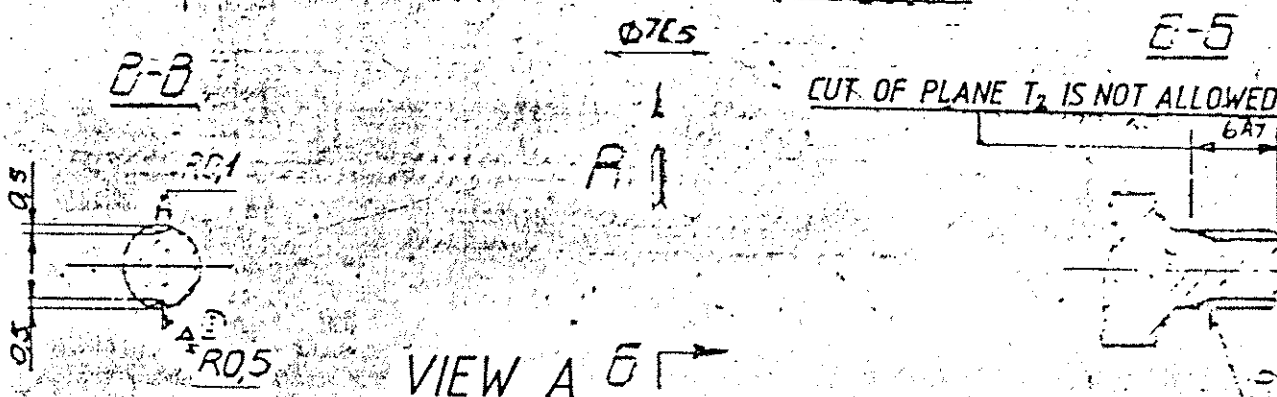
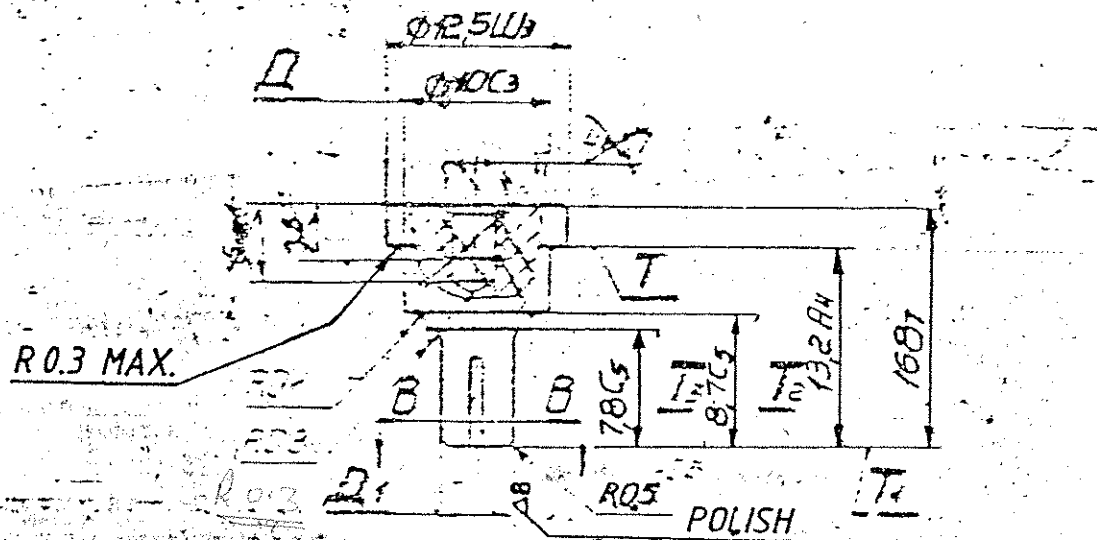
DRAWING NUMBER

AK 150B-210

√6 UNLESS OTHERWISE SPECIFIED.

164

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



VIEW A



ALT. MATL:-
STEEL 40 Cr 4 Mo 3 TO IS: 5517-78
OR EN 19 TO BS: 970. HRC - 30-36

CENTRE HOLE A0.8 GOST 14034-74 IS ALLOWED ON SURFACE T_1 .
RUN-OUT OF SURFACES T_1, T_2 AND A_1 WITH RESPECT TO A SHOULD NOT EXCEED 0.03.
CHAMFER TO A DEPTH OF THREAD AT $L 120^\circ$.
HARDNESS RC = 30 TO 36.
CADMIUM PLATED, 8 MICRONS THICK, EXCEPT SURFACES A_1, T_1 AND T_2 .

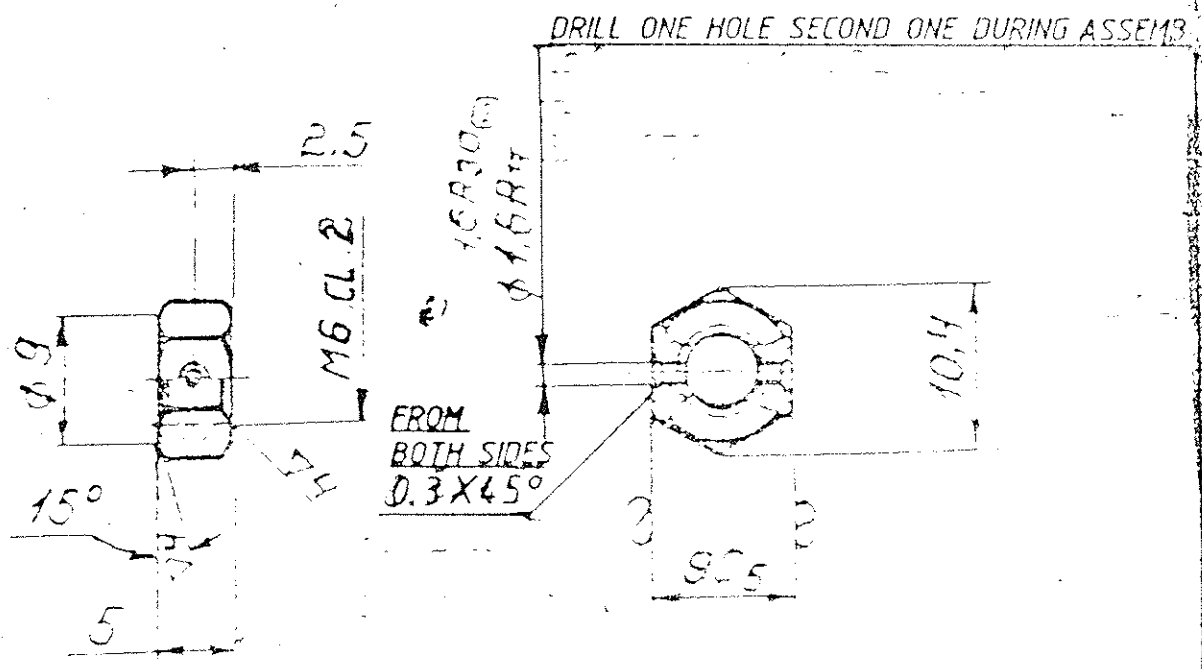
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

		EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THUS Φ	
		5.6	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	MATERIAL:-	USED ON:-
DRG		SCALE - 2:1	STEEL 38XA	AK 150C 19 C5
CHK		DIMENSIONS IN mm	TY 14-1-950-74	
TEL		TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APPD			TITLE: STOP	
DATE		ALL THREADS CONFORM TO	B'S CAT NUMBER	DRAWING NUMBER
22-7-82				AK 150B-210

DRAWING NUMBER
AK150B-216

▽6 UNLESS OTHERWISE SPECIFIED.

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



CHAMFER TO DEPTH OF THREAD AT AN ANGLE OF 90° TO 120°.

THREAD BEFORE COATING- AS PER 257AT.

ALT. MATL:-
 STEEL 40Cr4Mo3 TO IS: 5517-78
 OR EN19 TO BS: 970. HRC. 28-35

CADMIUM PLATING, 6 TO 9 MICRONS THICK.

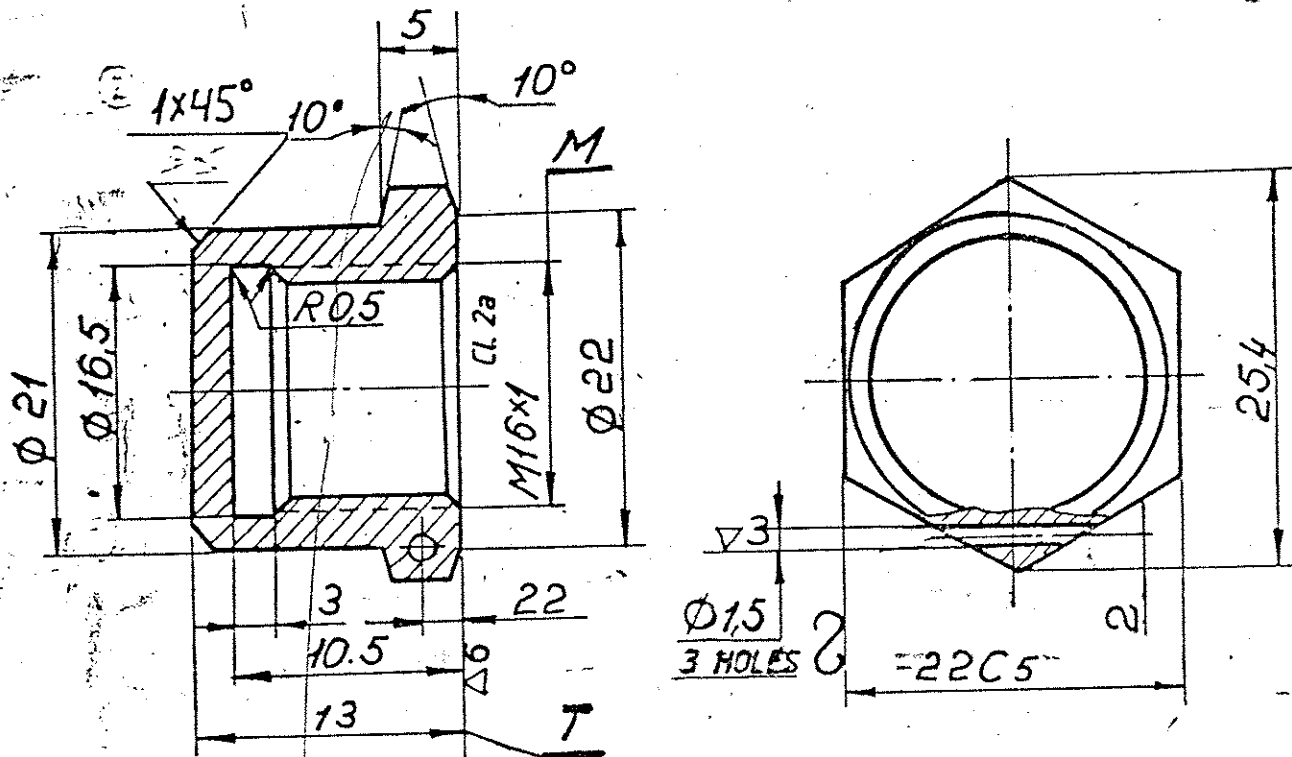
THIS SAMPLE SHOULD BE APPROVED BY A. M. S. BEFORE BULK PRODUCTION.

		EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THIS * (LETTERS)
		1.3	
		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	
DRG G.P.M.		SCALE - 2:1	MATERIAL:-
CRJ S. S. S.		DIMENSIONS IN mm	USED ON:-
APPD S. S. S.		TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	STEEL 38 X ATY 14-1-950-74
			AK 150B 060 CG
			CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD
			TITLE: NUT
DATE		ALL THREADS CONFORM TO	DRAWING NUMBER: AK150B-216
22.7.86			

DRAWING NUMBER
AK 150 B .219

▽4 UNLESS OTHERWISE SPECIFIED.

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



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

COATING - CADMIUM - PLATED, 9 TO 13 MICRONS THICK

RUN-OUT OF SURFACE T WITH RESPECT TO ANGLE DIAMETER OF THREAD
M SHOULD NOT EXCEED 0.1 mm.

MAKE CHAMFERS TO A DEPTH OF THREAD AT AN ANGLE OF 90° TO 120°

LOCKING HOLES MAY BE STOP-DRILLED AS PER 182AT.

THREAD BEFORE COATING IS AS PER 257AT.

HARDNESS HRC 28 TO 35

ALTMATL:-

STEEL 40Cr4Mo3 TO IS:5517-

78 OR En19 TO BS:970.

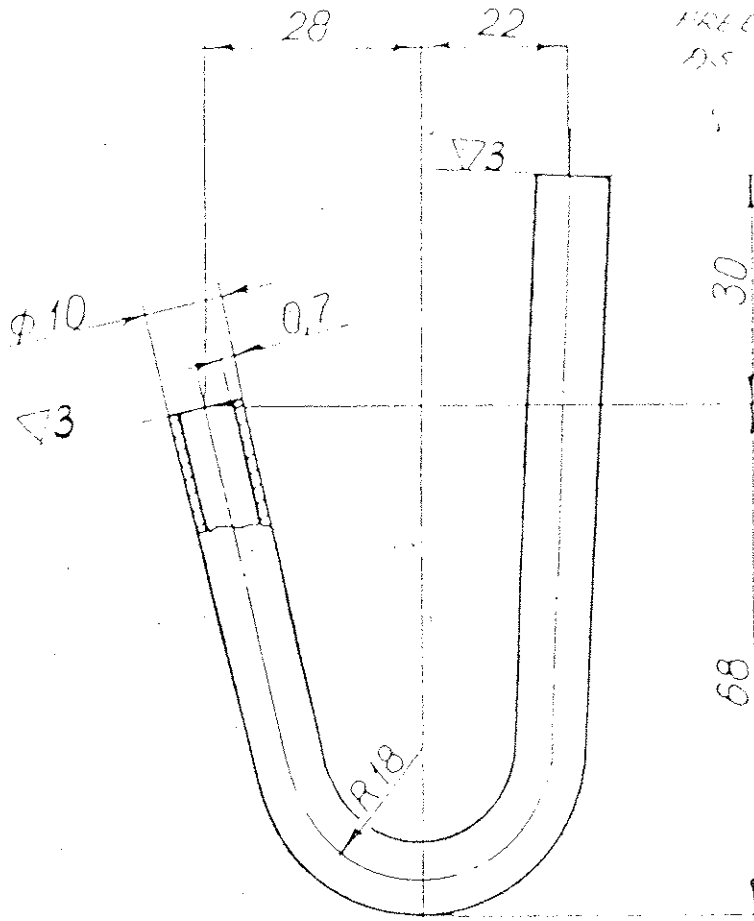
28-35 HRC

RVD 74808

			EST. MASS 19	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	MATERIAL - STEEL 38XA TY 14 -1 - 950 -74	USED ON:- AK150 C-01 C6
DRN	2/1/74	SCALE - 2:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD	
CHD	2/1/74	DIMENSIONS IN mm.	TITLE:- NUT	
TCD	2/1/74	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
APPD	2/1/74	ALL THREADS CONFORM TO	DRAWING NUMBER AK150B-219	

DRAWING NUMBER
AK 150 C - 029

допускаются по ГОСТ
иные размеры по 22А752-76
ТКЛ
TOLERANCES ON
FREE DIMENSIONS
AS PER 22А752-76



ALT. MATL:-
COPPER BRAZED STEEL TUBE
TO IS: 8119-76.

Овальность в местах радиусной гибки не более 1,3.
Заусенцы зачистить.

Ovality in the places of radius bending
should not exceed 1.3.

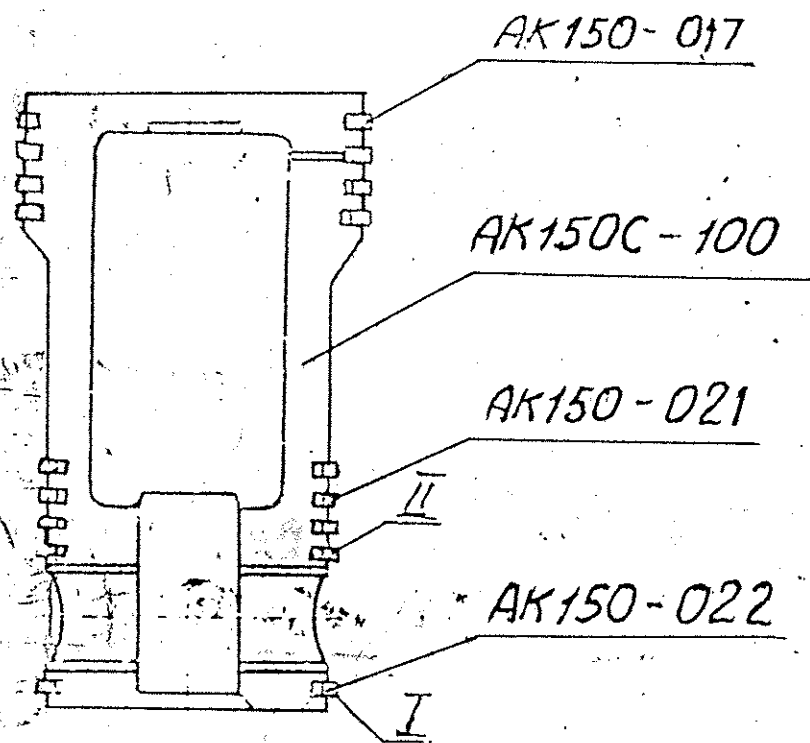
DRESS THE BURRS.

A-1

			EST. MASS 44	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 OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL - STEEL TUBE 10x0.7 GOST 11249-65	USED ON:- AK 150 C - 15 C5
CP R		SCALE - 1:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAIL	
CHD Vkhaltadly	DIMENSIONS IN mm		TITLE - PIPE	
TCD V.V.	TOLERANCE ON DIMS UNLESS OTHERWISE STATED		DRAWING NUMBER AK 150 C - 029	
APPO K	ALL THREADS CONFORM TO		D & CAT NUMBER	
DATE 22.7.86				

AK150C-45 CB

DESIGNATION	NR. OF COMPONENTS AND
AK150C-45	AK150-017
AK150C-100	AK150-021
AK150C-022	AK150-022
AK150C-121	AK150-121



1. POSITION THE PISTON RING ENDS AT AN ANGLE OF 180° RELATIVE TO EACH OTHER.
2. TO OBTAIN THE OPTIMUM VALUE OF THE OIL EJECTION FROM COMPRESSOR INSTALL RINGS AK150-022 (POSITIONS I AND II) WITH BEVEL DOWN. REPLACE RING AK-150-022 (POSITION II) BY RING AK150-121.

ISSUE - NIL

KND 74767

EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS # LETTERS)
A 10-12-98 1/2 AMENDED	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED SURFACES TO HAVE R OUTSIDE & INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.
ISSUE DATE NATURE OF AMENDMENTS	MATERIAL USED ON: AK150C-01 CB
SCALE - 3:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVA
DIMENSIONS IN mm	TITLE: PISTON FIRST STAGE ASSY
TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D 3 CAT NUMBER DRAWING NUMBER
ALL THREADS CONFORM TO	AK150C-45 CB

20

DRAWING NUMBER

AK 150C -51 C6

RIVETING, DRESSING IS NOT MANDATORY.

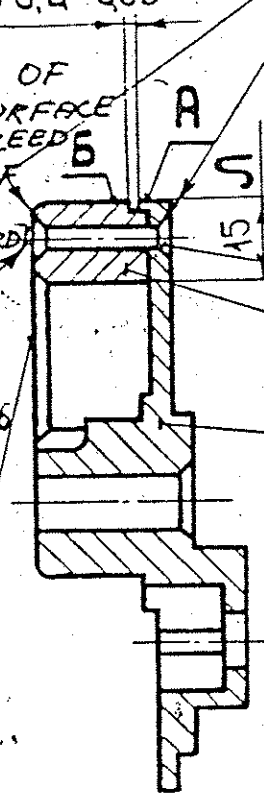
После расклейки по поверхности заклепок зачистить. При чистой машинкой клепке зачистка не обязательна.

CLEARANCE. Зазор $0,2 \pm 0,05$

PROTRUSION OF HEADS OF RIVETS RELATIVE TO SURFACE OF WEB SHOULD NOT EXCEED 0.6 AND TO SURFACE OF COUNTER WEIGHT - 0.2 CHECK AGAINST STANDARD

выступание головок заклепок относительно поверхностей: щеки не более 0,6 и противовеса не более 0,2 проверить по эталону

STAMP BY Клеимить ударным клеймом. PUNCHING



3537A-4-22
AK 150B-026
AK 150C-040
AK 150B-006

OXIDE FILM MAY BE REMOVED FROM CIRCULAR SURFACE J.

Смещение поверхности A относительно B не более 0,4. MISALIGNMENT OF SURFACE A' RELATIVE TO SURFACE B SHOULD NOT EXCEED 0.4.

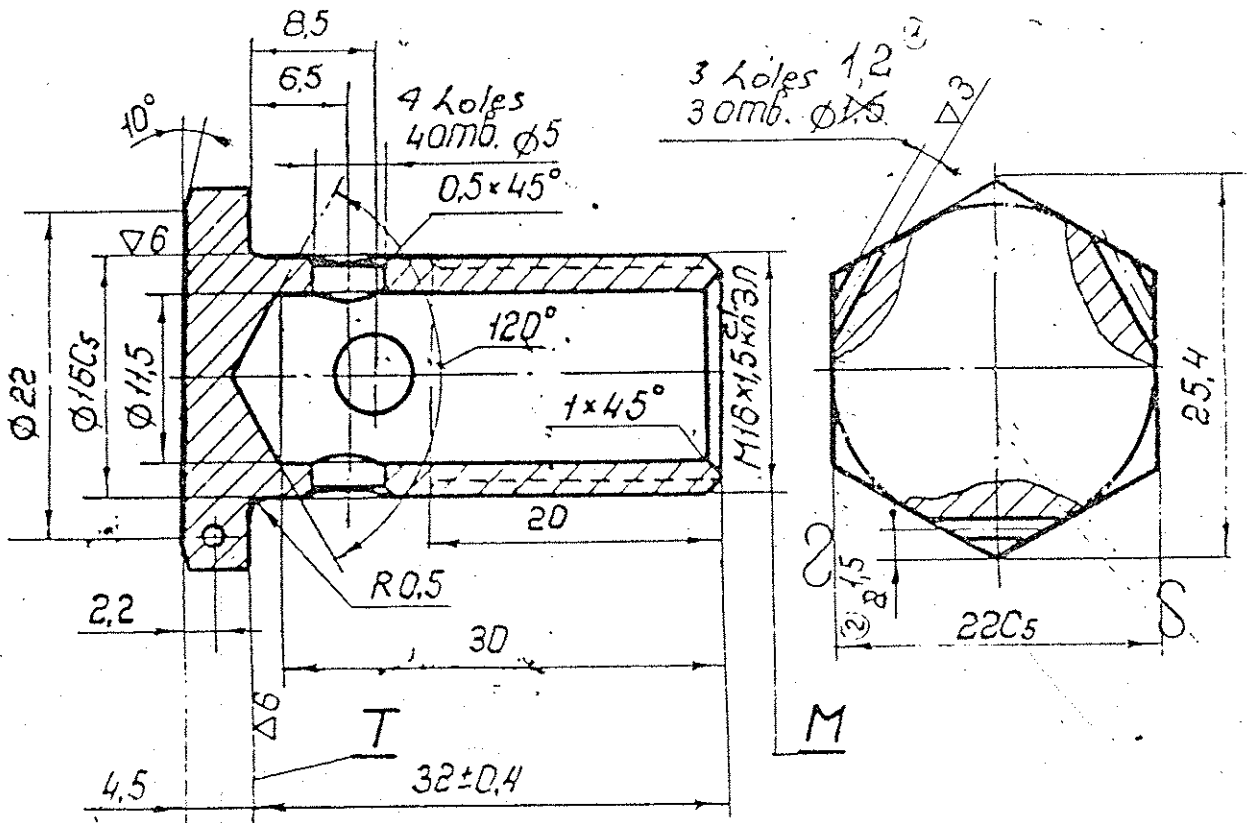
Допускается снятие оксидной пленки на кольцевой поверхности J

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

		EST. MASS. 287	TO BE STAMPED OR MARKED WHERE INDICATED THIS # LETTERS)
ISSUE	DATE	NATURE OF AMENDMENTS	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.
DRW cel		SCALE - 1:1	MATERIAL:-
CHK Bhatnagar		DIMENSIONS IN mm	USED ON:- AK 150C -52 C6
TCD S.S. Reddy		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPD V		ALL THREADS CONFORM TO	TITLE: WEB ASSY
DATE 22.7.80		D'S CAT NUMBER	DRAWING NUMBER AK 150C -51 C6

DRAWING NUMBER
AK 150C-079

TOLERANCES ON FREE DIMENSIONS AS PER 22 AT 2-70



ALT. MATL:-
STEEL 40Cr4Mo3 TO IS:5517-78
OR En 19 TO BS:970. 26-32 HRC

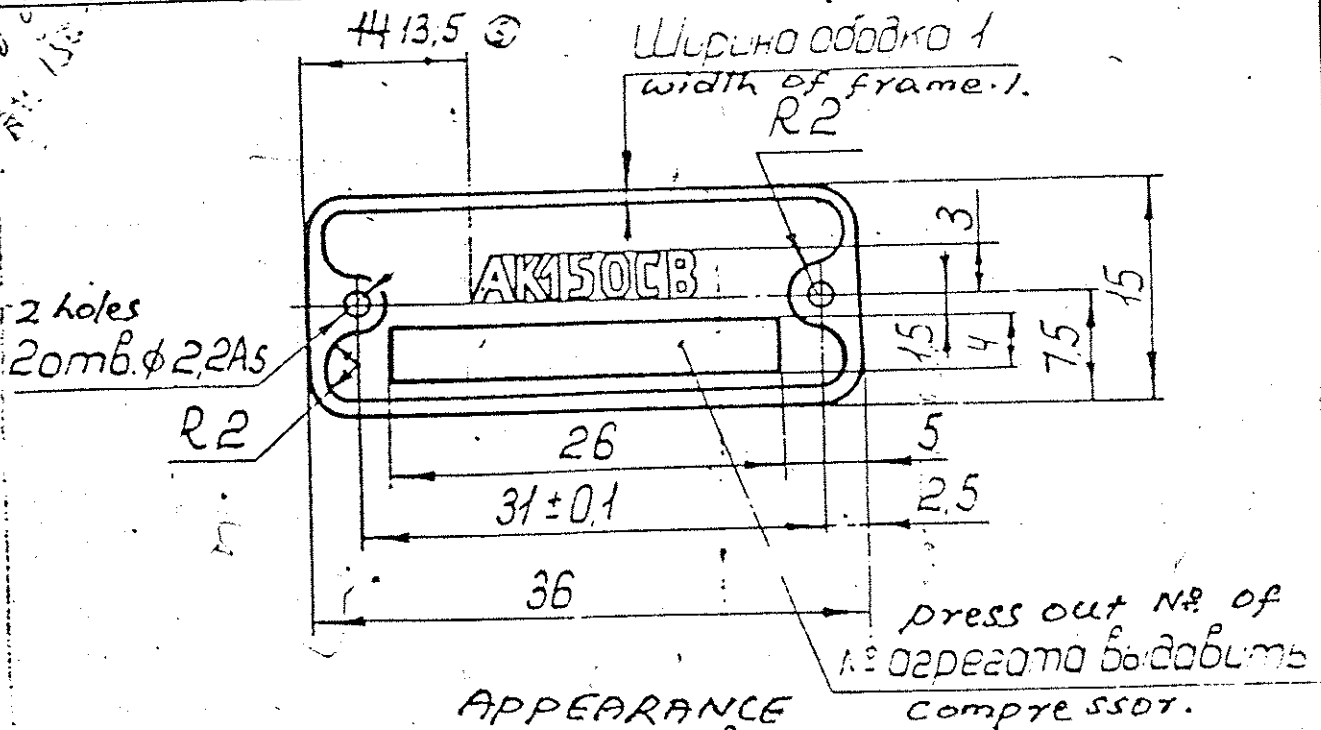
1. THREAD BEFORE COATING AS PER 214 AT.
2. NON SQUARENESS OF SURFACE T TO PITCH DIAMETER OF THREAD M SHOULD NOT EXCEED 0.1.
3. DRILLING OF COTTER HOLES MAY BE AS PER 182 AT.
4. RUN OUT AND CHAMFER OF THREAD AS PER 299 AT.
5. HARDNESS HRC = 26 - 32.
6. COATING: Cd 9 - 13 m.

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

			EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS \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.	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL :- STEEL 38xA 4 MTU-1-950-70	USED ON:- AK 150C-01 C6
DRN		SCALE - 2:1.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADL	
CHK		DIMENSIONS IN mm	TITLE:- BOLT CLAMPING	
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	B S CAT NUMBER	
APPD		ALL THREADS CONFORM TO	DRAWING NUMBER AK150C-079	
DATE	25/78			

DRAWING NUMBER
AK 150 C .081

РАЗМЕРЫ ПОСЛЕДИК
DIMENSIONS AS PER
22AT 52.



APPEARANCE
ВНЕШНИЙ ВУД.

M 1:1
SCALE 1:1

Colour of
Цвет алюминия
Бого листа
ALUMINIUM SHEET.

MATERIAL

ALUMINIUM ALLOY
АЛЮМ. SHEET 0.5
GOST 21631-76

ЧЕРНЬ И ЦВЕТ
BLACK COLOUR.



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

④ Толщина этикетки 0,5-0,7
Шрифт букв и цифр
по-3 ГОСТ 2930-62
Type of letters and
figures should be
по-3 GOST 2930-62.

Coat the tag with one
layer of Lacquer A101130
as per TY 6-10-1296-75.

ALL MATERIALS AL ALLOY 19000 H2 TO
ENIS 737-86-88 AK
TY 6-10-1296-75

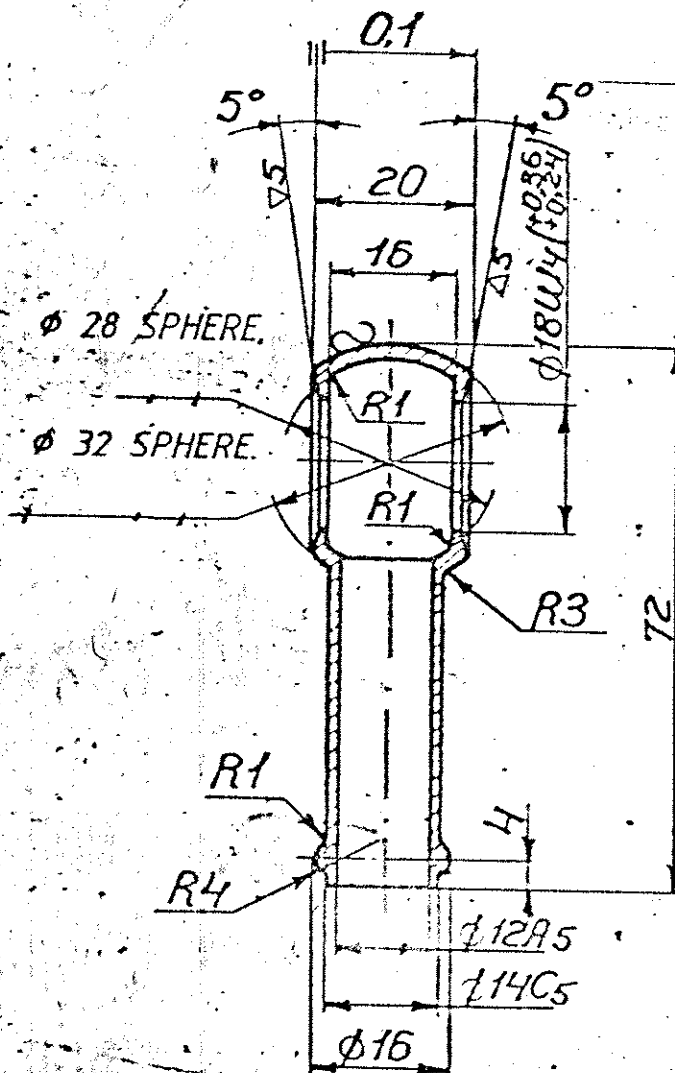
		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS #	
			LETTERS)	
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL	USED ON:- AK 150 C .01 C B
DRN		SCALE - 2:1	SEE ABOVE	
CHK		DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	TITLE:- TAG	
APPD		ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
DATE	25/7/62			AK150C-081

DRAWING NUMBER

AK 150 H-009

▽ 4 UNLESS OTHERWISE SPECIFIED.

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



ALT. MATL:-

STEEL EN 8.0R EN 9 TO BS:970

CADMIUM - PLATED, 9 TO 13 MICRONS THICK.

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

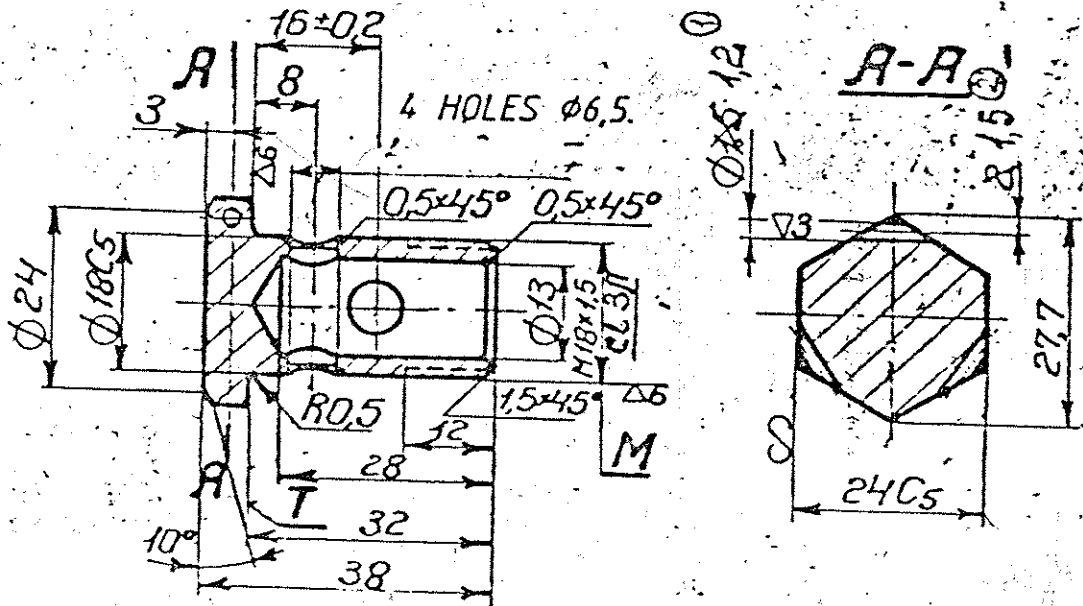
ISSUE NO. 1

		EST. MASS 39.4	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 & INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL:- STEEL 45 TY 14 - 1-151-72	USED ON:- AK 150 C-01 C5
DRN R/C	SCALE - 1:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADN.	
CHD Shullash	DIMENSIONS IN mm.	TITLE:- SWIVEL ELBOW	
TSD S. Mohan	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	D S CAT NUMBER	DRAWING NUMBER AK 150 H-009
APPO V	ALL THREADS CONFORM TO		
DATE 25/7/00			

DRAWING NUMBER
AK 150H-010

▽ 4 UNLESS OTHERWISE SPECIFIED.

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



NON-SQUARENESS OF SURFACE T WITH RESPECT TO MEAN DIAMETER OF THREAD M SHOULD NOT EXCEED 0.1 MM.

IT IS ALLOWED TO STOP DRILL LOCKING HOLES AS PER 182 AT.

THREAD BEFORE COATING IS AS PER 214 AT.

ALT. MATL:-

STEEL 40Cr4Mo3 TO IS:5517-78
OR En 19 TO BS: 970, 20-30 HRC.

HARDNESS HRC = 20 TO 30.
CADMIUM PLATING, 9 TO 13
MICRONS THICK.

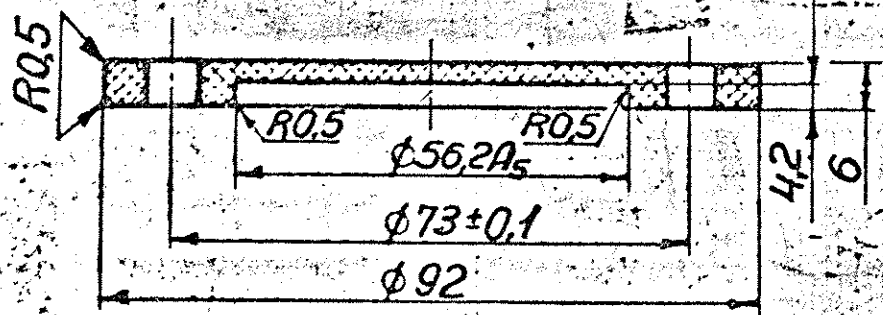
KVD: 74811

PROF SAMPLE SHOULD BE APPROVED BY A N S P BEFORE BULK PRODUCTION

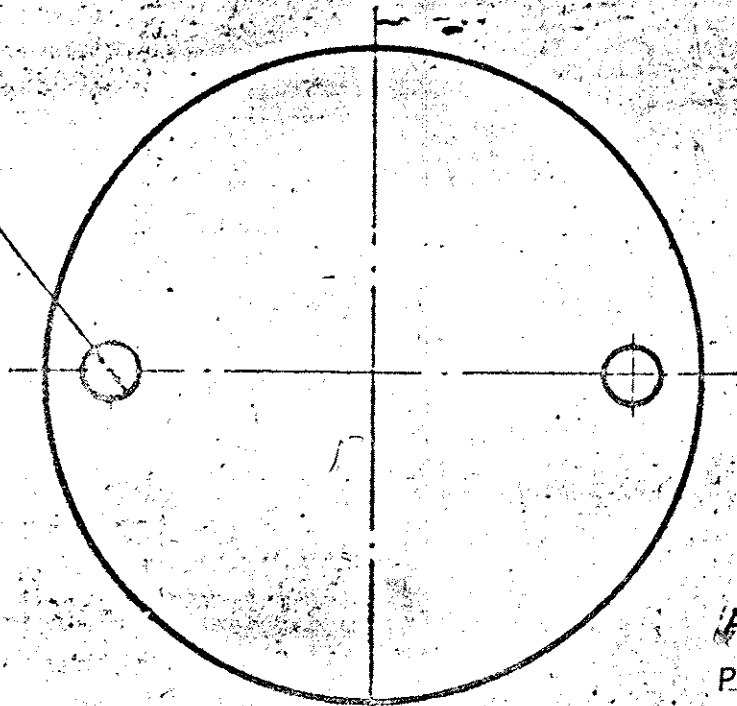
			EST. MASS 47,5	TO BE STAMPED OR MARKED WHERE INDICATED THIS Φ LETTERS)
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT- SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL:- STEEL 45 TY 14-1-151-72	USED ON:- AK150C-01C6
		SCALE - 1:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAGE	
		DISPOSITIONS IN mm	TITLE: CLAMP	
		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	
		ALL THREADS CONFORM TO	DRAWING NUMBER AK150H-010	
	DATE 25/7/89			

DRAWING NUMBER
AK 150 H-016

TOLERANCES ON FREE DIMENSIONS ARE
AS PER 22AT52-CL:7



Ø5.5
2 HOLES



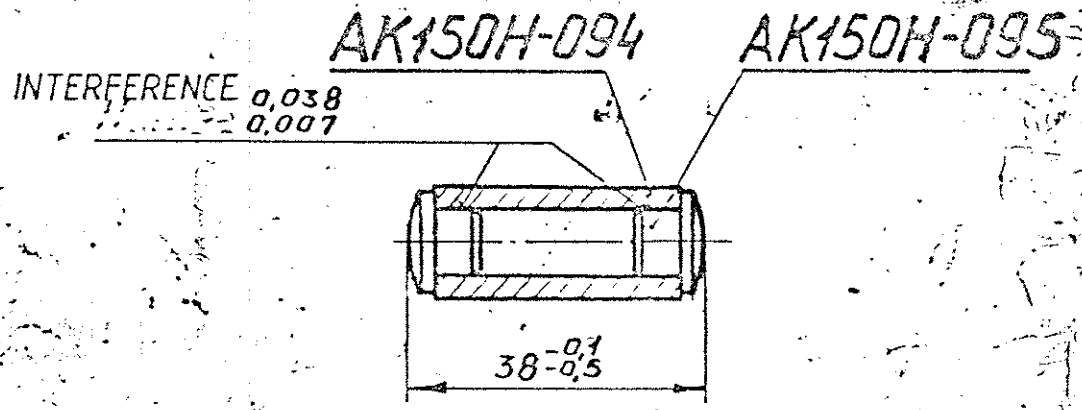
ALT. MATL:
PHENOLIC MOULDING
GDE 1 TO IS: 1300-94

TECHNICAL REQUIREMENTS ARE AS PER OCT1. 80063-73.
ON THE EXTERNAL SURFACE OF PART, STIFFENING RIBS OF
A HEIGHT AND WIDTH UPTO 3MM, ARE ALLOWED.

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

		EST. MASS. 38.3	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 CRIT- SIZE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.
ISSUE DATE	REATURE OF AMENDMENTS	MATERIAL:- PHENOLIC PLASTIC 03-010-02 GOST 5689-79	USED ON:- AK150C-01CB
DESIGN A. Mahabadi	SCALE - 1:1		
CHKD Bhattacharya	DIMENSIONS IN mm.		
TCW A. Mahabadi	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD	
APPR A. Mahabadi		TITLE: TRANSPORTATION PLUG	
DATE 25/7/82	ALL THREADS CONFORM IS	DRAWING NUMBER AK150H-016	

DRAWING NUMBER
AK 150H-36 C5

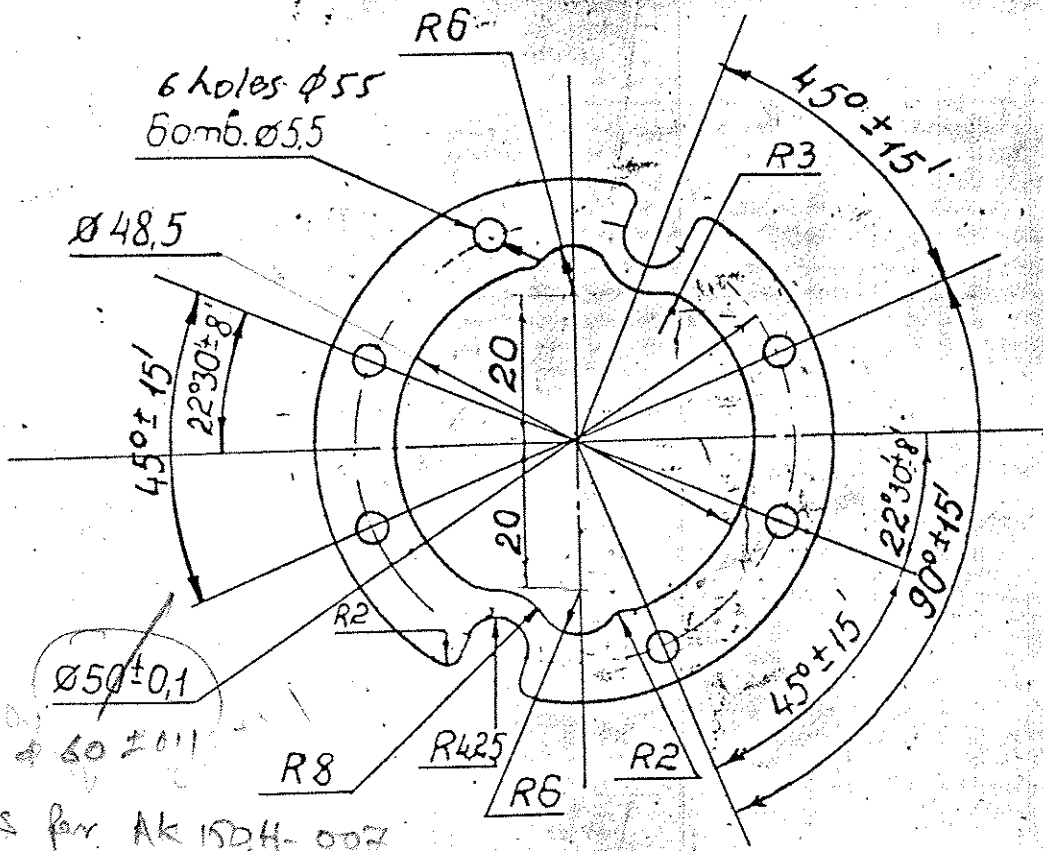


		EST. MASS	TO BE STAMPED OR MARKED WHERE
		26	LOCATED THIS ϕ
			LETTERS!
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED SURFACES TO HAVE R OUTSIDE & INSIDE EQUIVALENT CHARACTERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENTS	SCALE - 1:1	ISSUED BY - AK 150 C-01 C5
CHK	DIMENSIONS IN MM	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVAD.	
TCD	TOLERANCE ON EDGES UNLESS OTHERWISE STATED	TITLE - PISTON PIN ASSY.	
APPD	ALL THREADS CONFORM TO	R S CAT 11.200.	DRAWING NUMBER AK 150H-36 C5
DATE 25/7-			

155

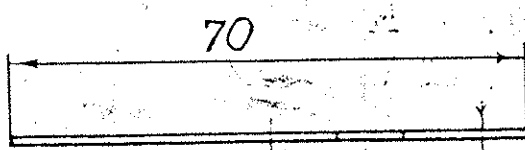
DRAWING NUMBER
AK150H-041

TOLERANCES ON FREE
Допуски на свободные
размеры по 121 АТУ
DIMENSIONS AS PER
121 АТУ



As per AK150H-007
G. K. S.
15/14

ALT. MATL:-
COMPRESSED ASBESTOS FIBRE
JOINING Gde A/O TO IS:2712-79



TOLERANCES ON DIMENSIONS
ARE GIVEN FOR A PRESS TOOL.
Допуски на размеры
даны для штампа

A-1
64

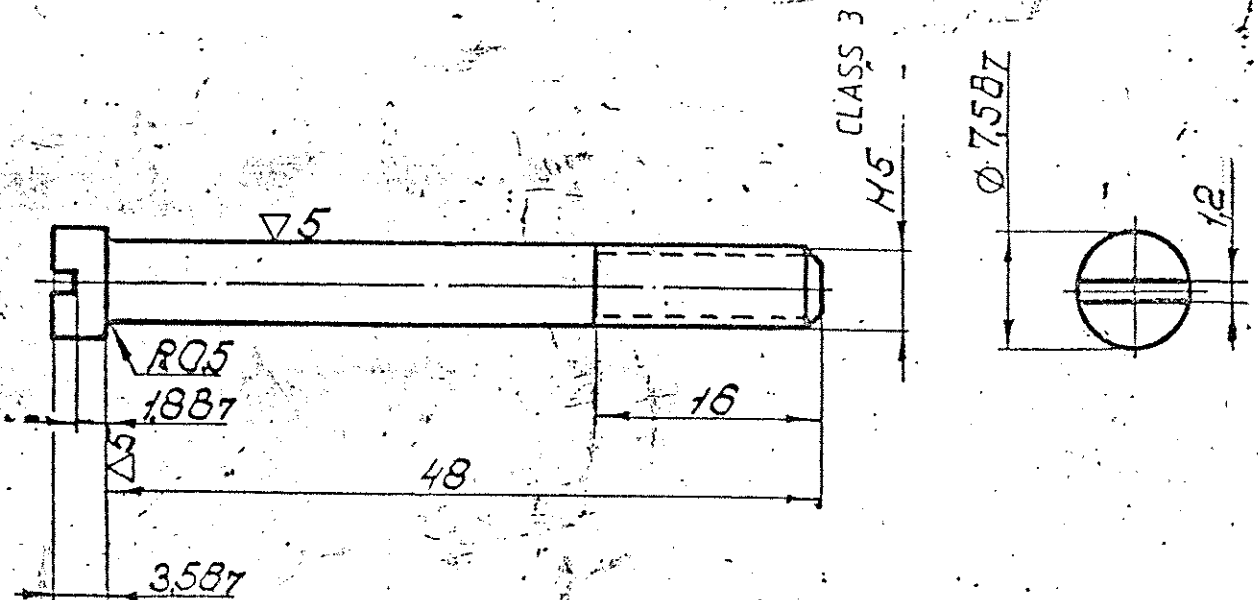
PROT SAMPLE SHOULD BE APPROVED BY A M S P BEFORE BULK PRODUCTION

		EST. MASS. 1g	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	MATERIAL:- PRONITE ЛМБ-Т ГОСТ - 481-71	USED ON:- AK 150 C-01 C B
SCALE - 1:1	DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TOLERANCE ON DIMS UNLESS OTHERWISE STATED		TITLE: GASKET	
DATE 25/7/14	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER AK 150 H 041

DRAWING NUMBER
AK 150H-063

▽4 UNLESS OTHERWISE SPECIFIED

TOLERANCE AND FREE DIMENSIONS
ARE AS PER 22 AT 52.



THREAD BEFORE COATING IS AS PER 214 AT.
RUN-OUT AND CHAMFER OF THREAD ARE AS PER 299 AT.
THREAD MAY BE MADE BY ROLLING.
HARDNESS HRC 26 TO 32.
CADMIUM PLATING, 9 TO 13 MICRONS THICK.

ALT. MATL:-

STEEL 40Cr4Mo3 TO IS:5517-78
OR En 19 TO BS:970. HRC=26-32.

PROT. SAMPLE SHOULD BE APPROVED BY A N.S.P BEFORE BULK PRODUCTION

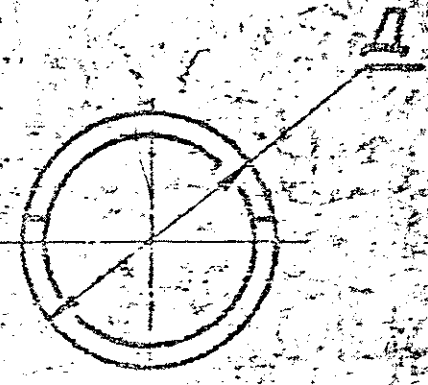
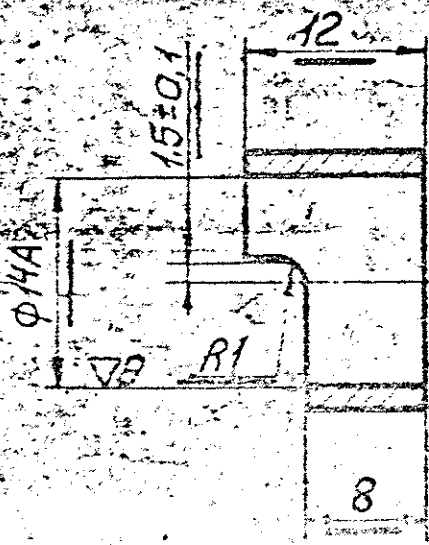
ISSUE DATE	NATURE OF AMENDMENTS	ESP. HASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS IS
DRW <i>M/S</i>	SCALE:- 2:1	8	LETTERS
CHK <i>Chattucky</i>	DIMENSIONS IN mm	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
TCD <i>S. Mohan</i>	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	MATERIAL:-	USED ON:-
APPD <i>M/S</i>	ALL THREADS CONFORM TO	STEEL 38 X A TY 14-F-950-74.	AK 150 C 01 C 6
DATE 28/7/8		CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVAL	
		TITLE: SCREW	
		G'S CAT NUMBER	DRAWING NUMBER AK 150 H-063

DRAWING NUMBER

AK 150H-089

UNLESS OTHERWISE STATED.

TOLERANCES ON FREE DIMENSIONS ARE AS PER 22A752.



DIMENSION	GROUP
<u>Ø17 GP</u>	I
<u>Ø17.1 GP</u>	II
<u>Ø17.2 GP</u>	III

ALT. MATL:-

COPPER AND COPPER ALLOY
Gde CA 104 TO BS: 2874-86

DIMENSIONS WHICH ARE UNDERLINED - ARE MAINTAINED IN UNIT.

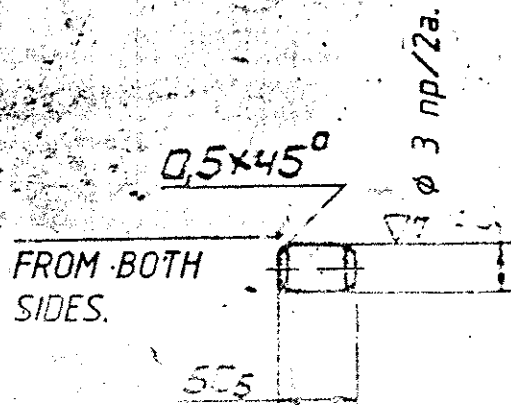
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

			EST. MASS. 6	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		
6.Pm		SCALE - 2:1	MATERIAL:- BRONZE БРАЖ H 10-14 GOST 1628-72	USED ON:- AK 150H - 31 C6
6.Pm		DIMENSIONS IN mm		
6.Pm		TOLERANCE ON DIMS UNLESS OTHERWISE STATED		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
6.Pm		ALL THREADS CONFORM TO	TITLE: PISTON BUSH 3RD STAGE	
DATE			D.S CAT NUMBER	DRAWING NUMBER AK 150H-089
22.7.86				

DRAWING NUMBER

AK 150H-090



UNLESS OTHERWISE SPECIFIED
TOLERANCE ON FREE DIMENSIONS
ARE AS PER 22 AT 52.



ALT. MATL:-

Cu AND Cu ALLOY Gde CA 104
TO BS : 2874 - 86

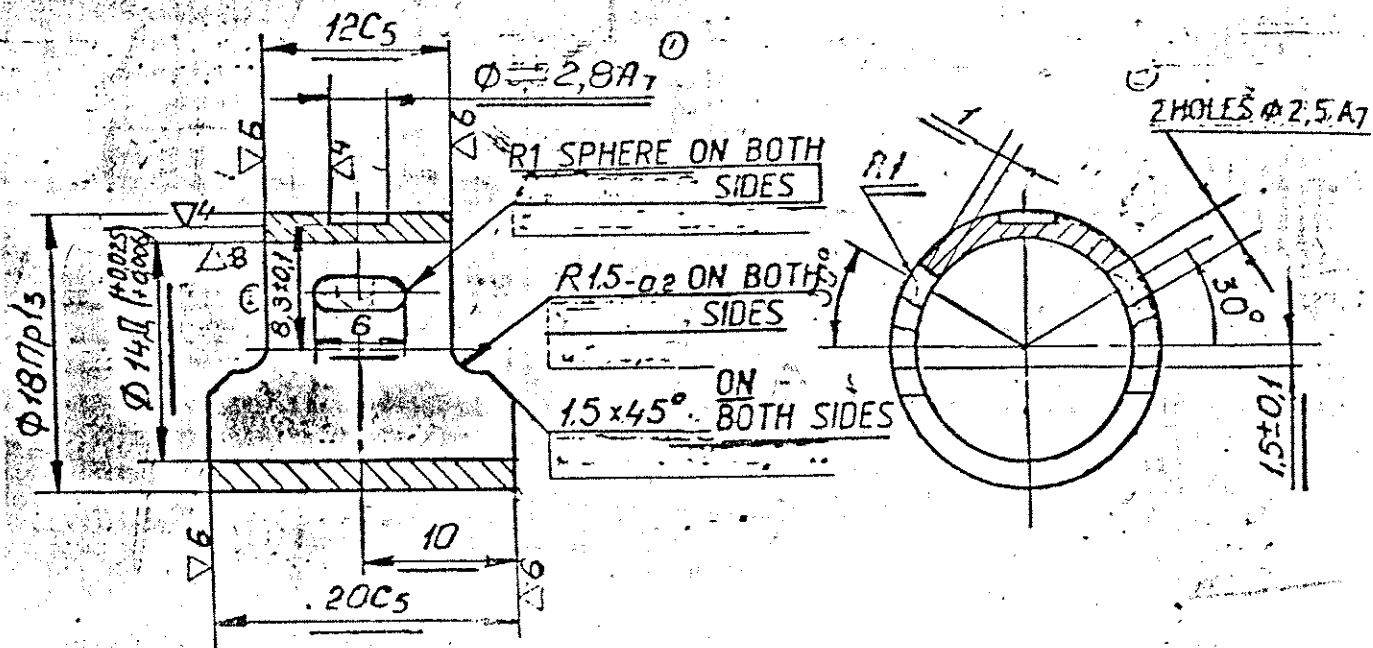
PILOT SAMPLE SHOULD BE APPROVED BY A N S P BEFORE BULK PRODUCTION

		EST. MASS. 3	TO BE STAMPED ON MARKED WHERE INDICATED THUS 
			LETTERS)
DATE	NATURE OF AMENDMENTS	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
5.10.70	SCALE - 2 : 1	MATERIAL:- BRASS C 59-1 GOST	USED ON:- AK 150H - 31 CB
12.10.70	DIMENSIONS IN mm	2060 - 73	
12.10.70	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD	
DATE	ALL THREADS CONFORM TO	 TITLE: LOCK PIN	
22.7.70		E S CAT NUMBER	DRAWN BY: AK 150H - 090

DRAWING NUMBER
AK 150H-093

▽ 6 UNLESS OTHERWISE STATED

TOLERANCES ON FREE DIMENSIONS ARE
AS PER 22 AT 52



MAINTAIN DIMENSIONS UNDER LINED BY Δ IN UNIT AK150H-35.

ALT. MATL: -

COPPER & COPPER ALLOY. Gde CA104
TO.B5:2874-86

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

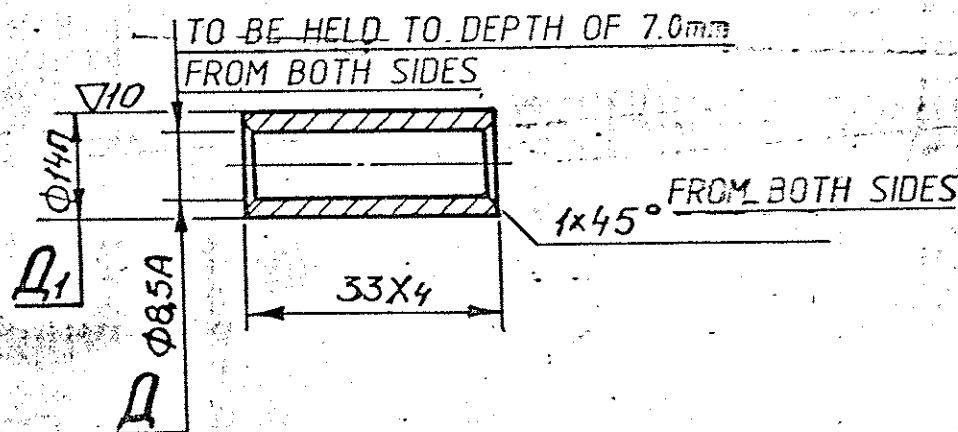
		EST. MASS. 13	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT- SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL:- BRONZE БрАЖ10-4 ГОСТ 1628-72	USED ON:- AK 150H-35C6
DRN [Signature]	SCALE:- 2:2	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD	
CHD [Signature]	DIMENSIONS IN mm	TITLE: BUSH	
TCD [Signature]	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	D S CAT NUMBER	
APPD [Signature]	ALL THREADS CONFORM TO	DRAWING NUMBER AK 150H-093	
DATE 22.7.86.			

166

DRAWING NUMBER
AK 150H-094

▽6 UNLESS OTHERWISE SPECIFIED

TOLERANCE ON FREE DIMENSIONS
ARE AS PER 22 AT 52.



COATING : PARKERISED WITH OXIDATION, EXCEPT SURFACE A₁
RUN-OUT OF SURFACE A₁ WITH RESPECT TO SURFACE A₁ SHOULD NOT
EXCEED 0.2 mm.

OVALITY AND TAPER OF SURFACE A₁ SHOULD NOT EXCEED 0.003 mm.

CARBURIZE SURFACE A₁

DEPTH OF CARBURIZED LAYER AFTER MACHINING SHOULD BE
0.5 TO 0.8 mm.

ALT. MATL:-

STEEL 13N23Cr80T0

CARBURIZED SURFACE HARDNESS RC = 58 TO 62. IS:4367-67 OR EN36B TO

BS: 970. HRC. 58-62.

CORE HARDNESS RC = 28 TO 39.

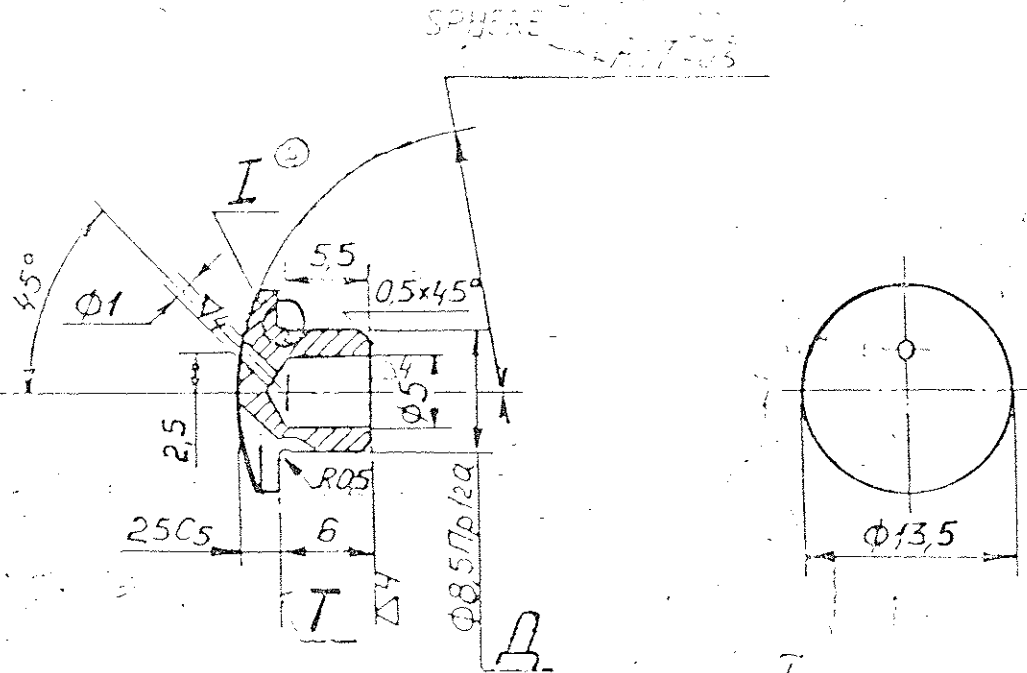
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

			EST. MASS. 24.6	TO BE STAMPED OR MARKED WHERE INDICATED BY US # (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	MATERIAL:- STEEL 12XH3A TY 14-J. 950-74	USED ON:- AK 150 H-35 C5
DRW		SCALE - 1:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AYADI	
CHKD		DIMENSIONS IN mm	TITLE: PISTON PIN	
APPD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	
	DATE 25/7/86	ALL THREADS CONFORM TO	DRAWING NUMBER AK 150H-094	

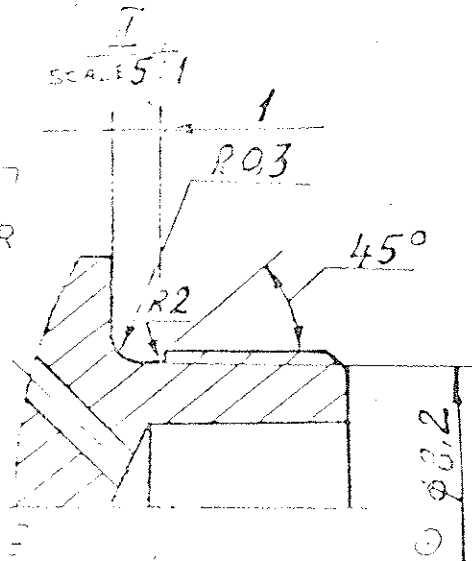
DRAWING NUMBER

AK 150H-095

UNLESS SPECIFIED OTHERWISE



NON-SQUARENESS OF T
 RESPECT TO T SHOULD BE WITHIN 0.5
 IT IS ALLOWED TO PROVIDE GROOVE AS PER SECTION I.



MATERIAL

ALUMINIUM ALLOY A1-T 2.038-76 AK 150-044

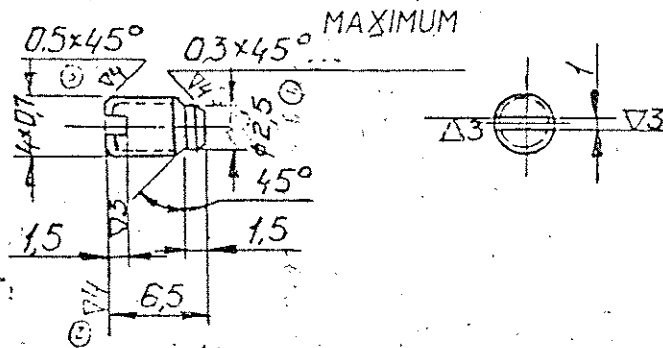
ALT. MATL:- AL ALLOY Gde 24345 W(HE15W) TO IS:733-83

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

EST. MASS.	7.5	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	MATERIAL -	USED ON -
20/8/86	SCALE:- 2:1	SEE ABOVE	AK 150H-36CB
20/8/86	DIMENSIONS IN mm	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AYADK	
20/8/86	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	PLUG	
DATE	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
25/7/86			AK 150H-095

DRAWING NUMBER
AK 150H -096

▽6 UNLESS STATED OTHERWISE
TOLERANCES ON FREE DIMENSIONS
ARE AS PER 22-AT 52.



HARDNESS RC = 26 TO 32.

OXIDIZE.

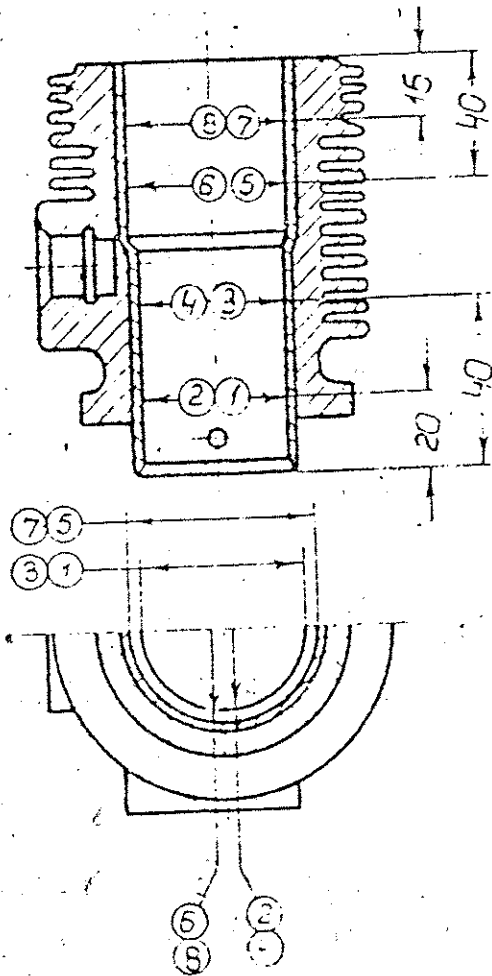
ALT. MATL :-
STEEL EN19 TO BS:970

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

			EST. MASS. 3	TO BE STAMPED OR MARKED WHERE INDICATED THUS (FF 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		
DRG <i>Ch</i>		SCALE - 2:1	MATERIAL:- STEEL 38XB TY 14-1-950-74	USED GR:- AK 150H -35 C8
CHK <i>Bhattachary</i>		DIMENSIONS IN MM	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD.	
TCD <i>Sudha</i>		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED		TITLE: SCREW
APPD <i>Pr</i>		ALL THREADS CONFORM TO	D S CAT. NUMBER	DRAWING NUMBER AK 150H -096
	22.7.86			

Designation and description of units sketch with indication of measuring places

Цилиндр 1 ступ.
AK150C-18 перу/узел.
First stage cylinder



Indication of measuring place	Designation according to drawing	Actual dimensions			Note
		Before test	After test	Wear out	
1					
2					
3	$\phi 38.9^{+0.027}$				
4					
5					
6	$\phi 46.9^{+0.027}$				
7					
8					

SHEET 1 OF 3

			EST. MASS	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 :-	USED ON:- AK150C -01CB
DRN cel		SCALE -		
CHD Bhattacharya		DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADL	
ICD Sardar		TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	TITLE:- AIR COMPRESSOR TABLE OF MICRO MEASUREMENTS.	
APPD K		ALL THREADS CONFORM TO	B S CAT NUMBER	DRAWING NUMBER
DATE 25/7/80				AK 1508 TM-AK 1508-01

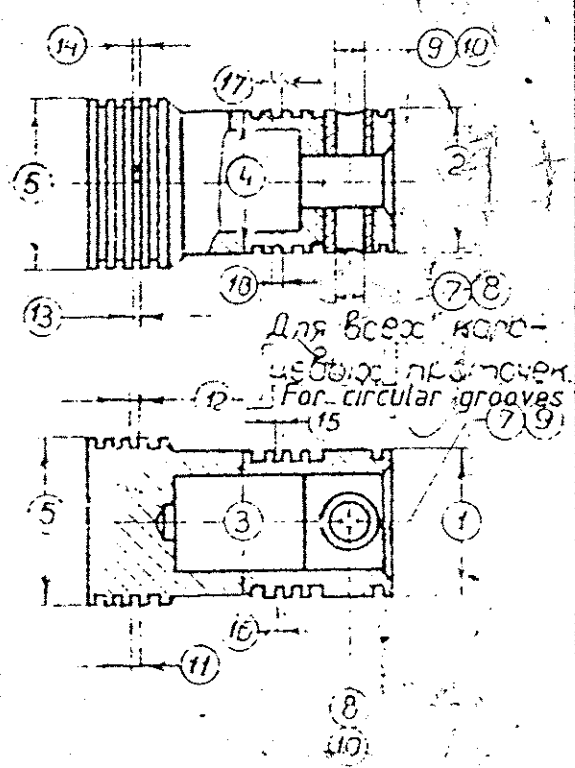
Designation and description of units sketch with indication of measuring places	Indication of measuring places	Designation according to drawing	Actual dimensions			
			Before test	After test	Wear out	note
③ АК150-27 собранный Assembled position pin 	1	φ12mm(+0.006)				
	2					
	3					
	4					
② АК150И-36 собранный Assembled position pin 	1	φ14mm(+0.005)				
	2					
	3					
	4					

СHEET 013

EST. MASS		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:-	USED ON:-
DRN <i>CP/LS</i>	SCALE -		AK 150C-01CB
CHD <i>Chhatrakh</i>	DIMENSIONS IN mm	CONTROLLER OF INSPECTION (HEAVY VEHICLES) AVADL	
TCD <i>25/7/80</i>	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	TITLE:- AIR COMPRESSOR TABLE OF MICRO MEASUREMENTS.	
WFO <i>✓</i>	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
DATE 25/7/80	TG		AK 1508 TM— AK 1508-01

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① ③	Designation and description of units sketch with indication of measuring places	Indication of measuring place	Dimension according to drawing	Actual dimension			
				Before test	After test	Wear out	Note
	Поршень со втулками и узел, Position with bushings (Units)						
		2					
		3	$0.38^{+0.15}_{-0.17}$	②			
		4					
		5	$0.45^{+0.2}_{-0.25}$				
		6					
		7					
		8					
		9	$0.12^{+0.02}$				
		10					
		11					
		12	$15^{+0.06}$				
		13	$15^{+0.02}$				
		14					
		15					
		16					
		17					
		18					



SHEET 2 OF 3

EST. MASS		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	
DRM		SCALE -	MATERIAL :-
			USED ON :- AK 150C-01CB
CHD		DIMENSIONS IN mm.	CONTROLLER OF INSPECTION (HEAVY VEHICLES) AVADI
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE :- AIR COMPRESSOR TABLE OF MICRO MEASUREMENTS.
APPD		ALL THREADS CONFORM TO	D S CAT NUMBER
DATE	25/1/80		DRAWING NUMBER
			AK 1508 TM — AK 1508-01