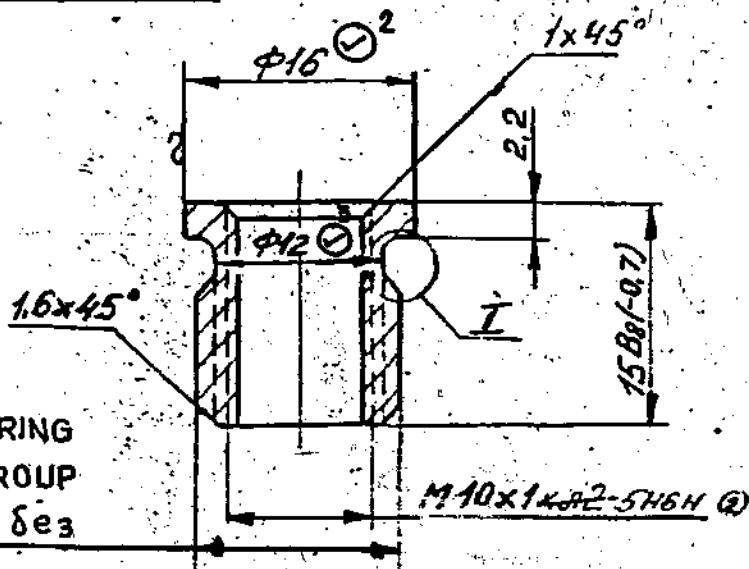


L-57-902

(Δ) 4 (Δ)

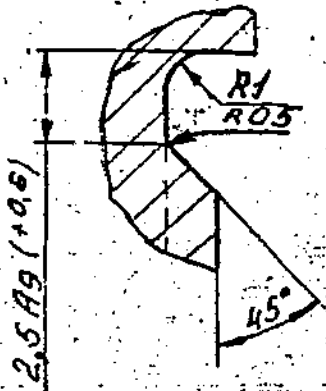


NOT CONSIDERING
 ACCURACY GROUP
 1 M14 X1.5 T1 2 δe3

Scale 5:1

REPAIR SIZE DIMENSIONS ARE ADDED WHERE INDICATED THUS Ⓢ BASED ON Lt. NO. 82847/OH/QAD/ED DT. 13-1-95

S.No	R1	R2	REMARKS
1	M16x1.5T1 2δ23 +0.124 φ 15.026 +0.062 (MEAN)	M18x1.5T1 2δ23 +0.124 φ 17.026 +0.062 (MEAN)	1. MARK REPAIR SIZE CATEGORY R1, R2. 2. ALL OTHER SIZES SURFACE FINISH, MATERIAL AND TECHNICAL REQUIREMENTS ARE SAME.
2	φ 18	φ 20	
3	φ 13.8	φ 15.8	



- TECHNICAL REQUIREMENTS FOR THREAD SHOULD IN ACCORD WITH STANDARD 82021-00.
- DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE MAINTAINED AS PER ACCURACY CLASS 7 OST 1010.
- SHARP EDGES SHOULD BE BLUNTED.
- COATING : Zn 3, CHROMATIZING IN ACCORDANCE WITH UA 483-82.

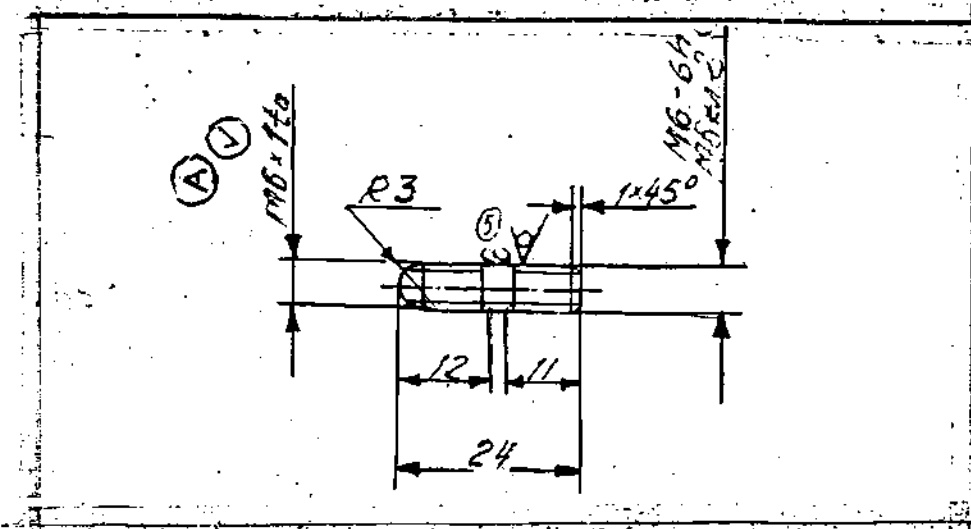
ALTERNATE MATERIAL: STEEL 080 M40 (EN 8) TO BS: 970
 PL-1-1983 OR 45 CB TO IS: 1570

PILOT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

EST. MASS 0.009 Kg		TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)	
A	18/09	3 rd ALTN. COMM. MIN POINTS DT. 27-2-09	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL:- 16.5GOST 7417-75	USED ON:- Cb 306-08-8
DIW	SCALE: 2:1	RD BAR 45 GOST 1051-73	Cb 306-09-10
CHD	DIMENSIONS IN mm	CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A U	
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: BUSH	
APPO	ALL THREADS TO CONFORM TO	D'S CAT NUMBER	DRAWING NUMBER 306-157
DATE 28-1-88			

DRAWING NUMBER

350 03



① EQUIVALENT MATERIAL STEEL
45C8 TO IS:1570

- DELETED.
- TECHNICAL REQUIREMENTS FOR THREADS AS PER STANDARD 82021-00.
- DIMENSIONS WITH UNSPECIFIED TOLERANCES AND THE REST OF THE TECHNICAL REQUIREMENTS AS PER STANDARD 82052-00.
- COATING: CADMIUM 3, CHROMATIZING AS PER UL-104 WITH SUBSEQUENT ELIMINATION OF HYDROGEN EMBRITTLEMENT.
- THE THREAD MAY BE MADE BY ROLLING WITH DIAMETER OF UN-THREADED PORTION WITH IN THE PITCH DIAMETER OF THREAD.
- MECHANICAL DAMAGES OF THE CADMIUM COATING SUCH AS SCRATCHES, NICKS AND DENTS ARE ALLOWED ON ASSEMBLY UNITS, PROVIDED THE STEEL IS NOT EXPOSED.

7. ALTERNATE MATERIAL: STEEL GRADES 40 & 50 GOST 1050-74.

8. HARDNESS:- 27-32 HRC.

* ALT MATERIAL:-

STEEL 709 M40 (EN-19) TO
BS:- 970 PT.-1- 1983

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

EST WT
0.004 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

EXPLANATORY NOTE:

8. REFERENCE MATERIAL QUOTED:

COLD DRAWN SIZED ROUND BAR, 6.0 (-0.025)mm DIA TO GOST 7417-75 FROM HIGH GRADE SIZED STEEL NORMAL SURFACE QUALITY TO GOST 1051-73 AND MANUFACTURED IN ACCORDANCE WITH QUALITY CARBON STRUCTURAL STEEL GRADE 45 TO GOST 1050-74.

REFERENCE NOTE '7' ON ALTERNATE MATERIAL: QUALITY CARBON STRUCTURAL STEEL GRADE 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 Kgf/mm ²	YIELD POINT Kgf/mm ²	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH Kgf/cm ²	HARDNESS B H N M A X	REMARKS
45	61	36	16	40	5	207	Ref,Matl
40	58	34	19	45	6	197	Alt,Matl
50	64	38	14	40	4	217	Alt,Matl

9. REPAIR SIZE DIMENSIONS ARE ADDED WHERE INDICATED THUS ② BASED ON OVERHAUL SPECIFICATIONS PART III REPAIR DRAWINGS.

Sl.No.	R	REMARKS
1	M6 x 1.25 to	ALL OTHER CONDITIONS AS PER STD. DRG.
2	PCD = 7.188 ± 0.022	

Cb 306-08-8, Cb 306-09-10,
Cb 401-03-6, Cb 3301-15-30,
Cb 306-08-13, Cb 306-09-13,
Cb 3308-04-24

DRN	CHD	TCD	APPD	DATE	MATERIAL ROUND BAR GOST 7417-75 45 GOST 1051-73	USED ON Cb 3301-15-44 Cb 3338-402-4 Cb 3329-01-11
				30-5-86		
SCALE 1 : 1					CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI	
DIMENSIONS IN mm					TITLE: STUD M6 x 24	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED					D S CAT NUMBER	
ALL THREADS TO CONFORM TO					DRAWING NUMBER 350 03	
ISSUE	DATE	NATURE OF AMENDMENTS				
D	12-8-10	4 th Alt. Comm. Meeting Minutes Point No.11 Dt: 26-10-09				
C	25.8.08	USED ON NUMBERS ADDED AUTHY:- MIN. OF ALT. COM. MEET.				
B	11.01.08	POINT No.-2.12 Dt.- 07-02-07				
A	6.9.95	REPAIR SIZE DIMENSION ADDED				

COMMON TO V-92S2 ENGINE

A-11

SIZE A3

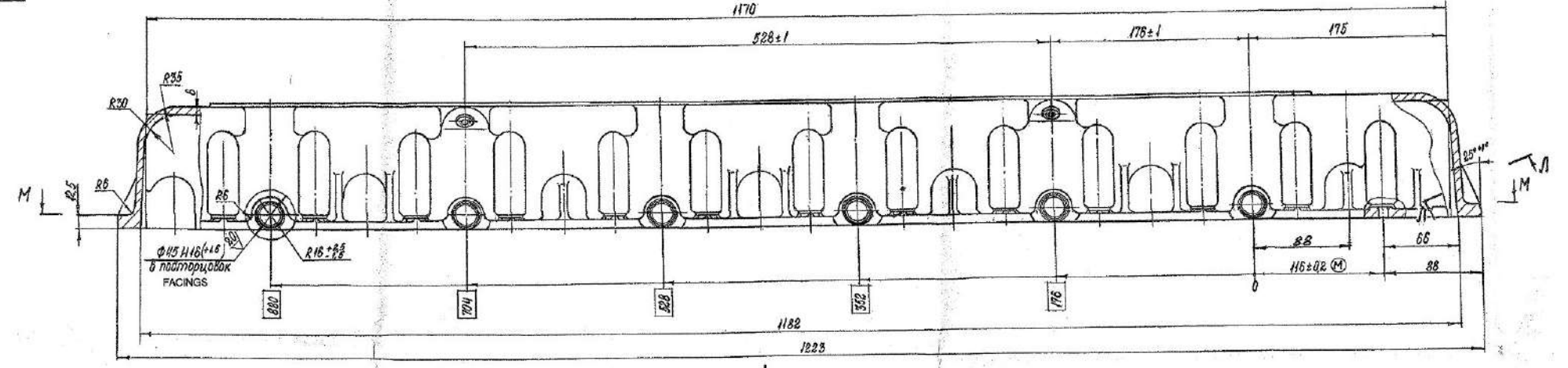


DRG. INTENDED AND REVISED FOR USE IN THE USSR. DRG. INDICATED BASED ON RUSSIAN ORIGINAL ISSUE. N.L.

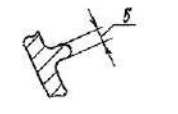
SIZE A3x5

DRAWING NUMBER
406-93-14

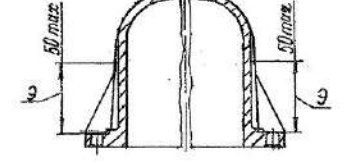
SHEET No. 1 OF 1



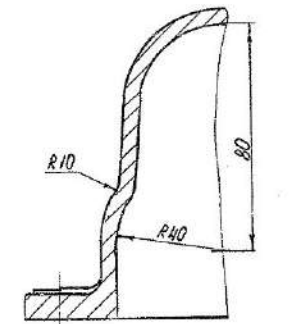
Л-Л (1:1)



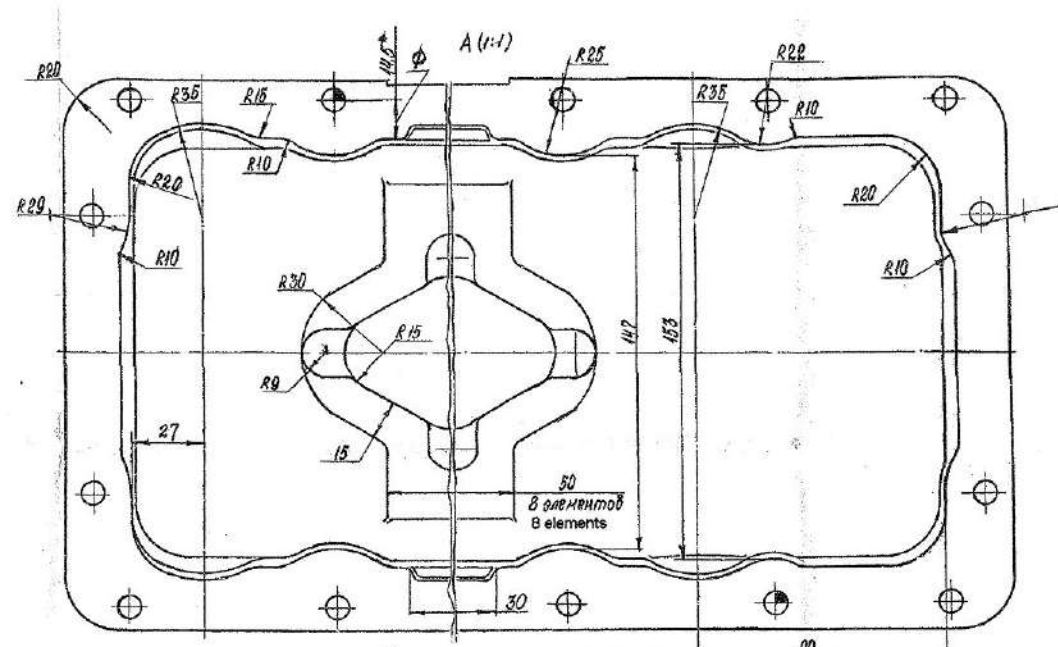
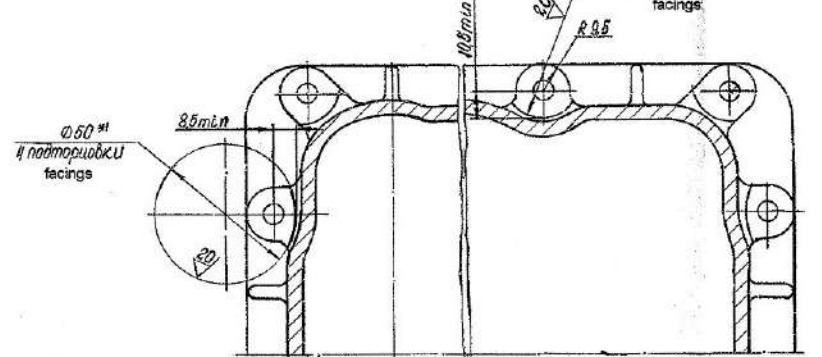
У-У (1:1)



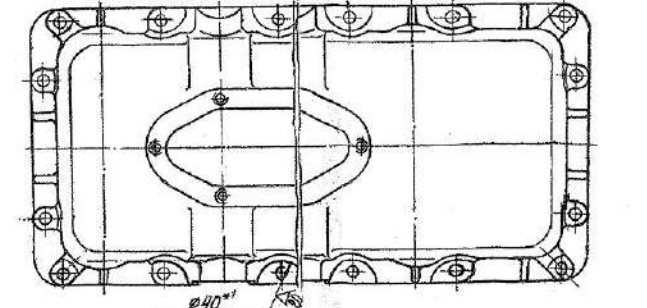
3-3 (1:1)



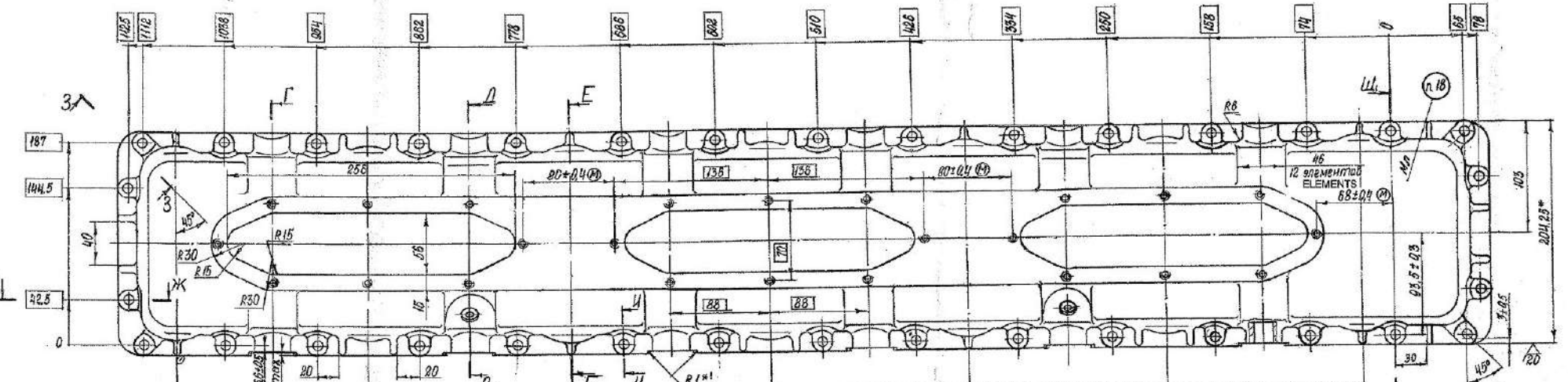
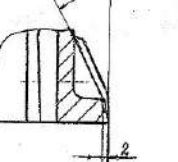
М-М (1:1)



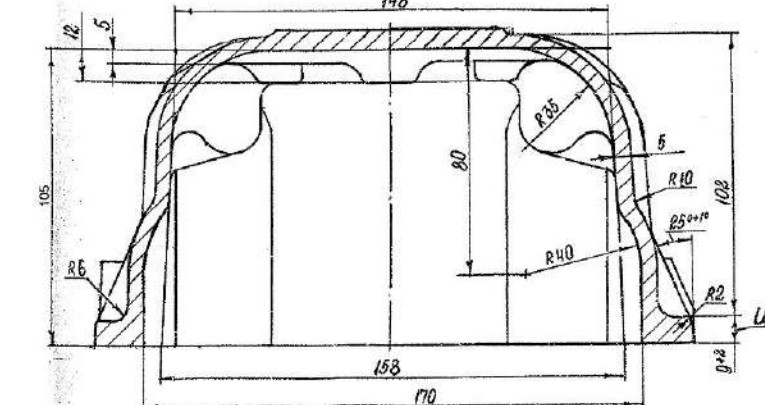
Variant
Вариант



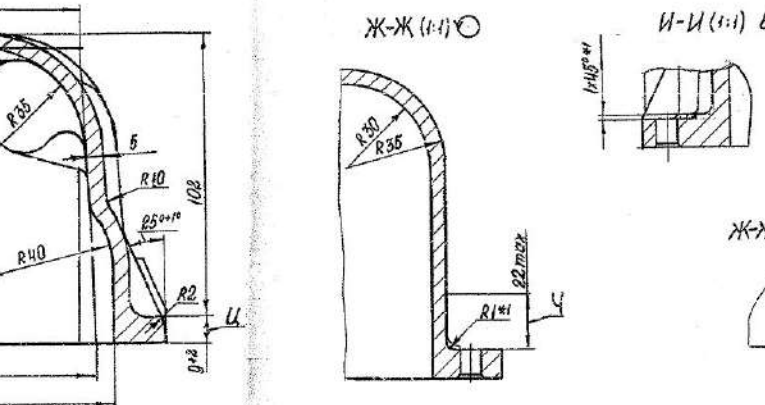
Variant
E-E (1:1) Вариант



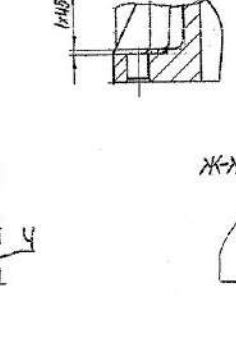
И-И (1:1)



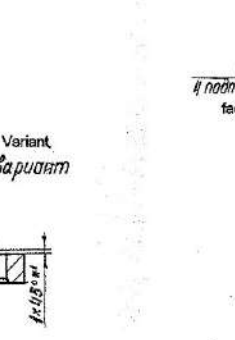
E-E (1:1)



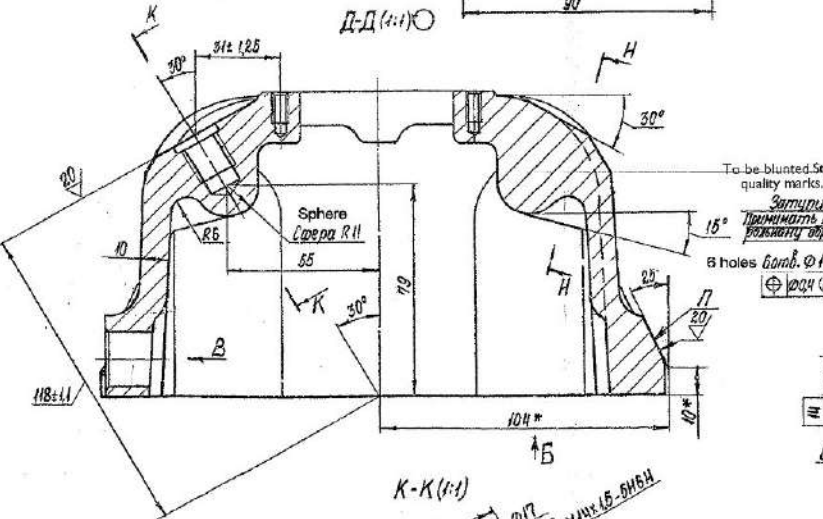
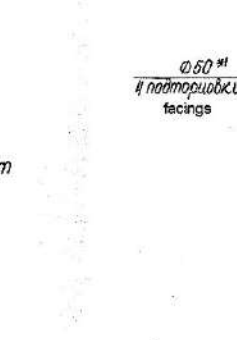
Ж-Ж (1:1)



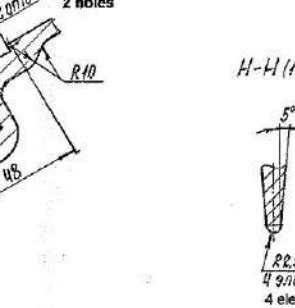
Variant
И-И (1:1) Вариант



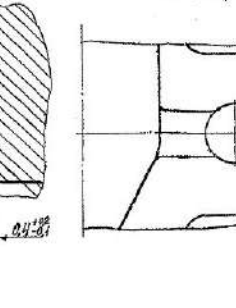
Variant
Ж-Ж (1:1) Вариант



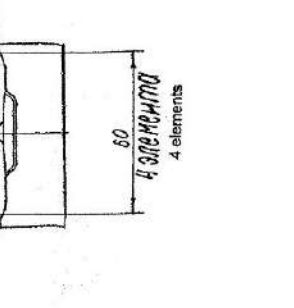
K-K (1:1)



Variant
У-У (1:1)



Variant
Б (1:1)



To be blunted Stamp quality marks.

Затупить
Промаркировать по качеству

8 holes 8 отверстий

8 holes 8 отверстий

PILOT SAMPLE SHOULD BE APPROVED BEFORE BULK PRODUCTION.

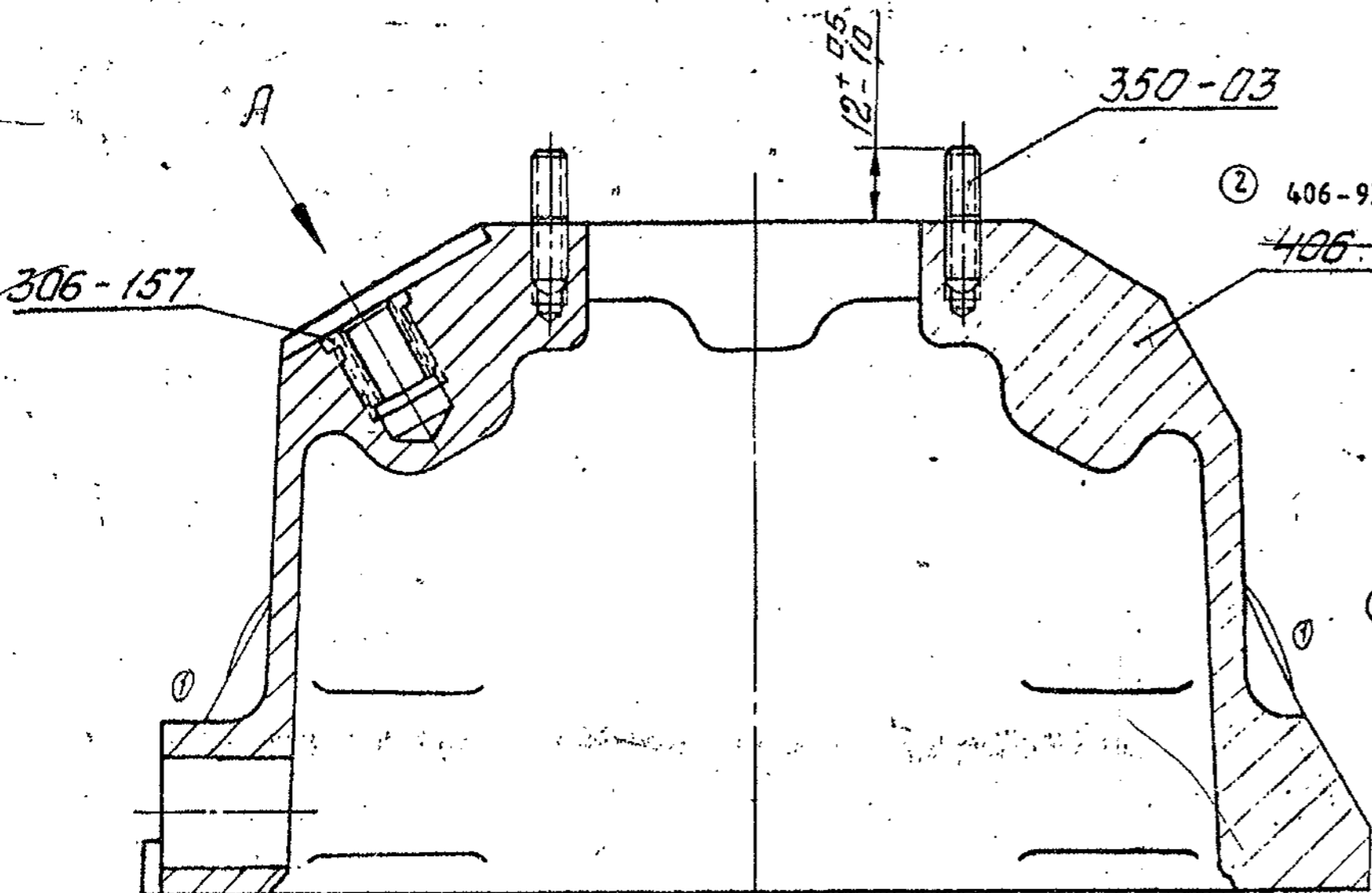
EST. WT. (kg) TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)

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

- Requirement for casting should be as per TTM-27-87.
- Alternative material AK74 (A179) as per GOST 1583-80.
- Unspecified limit deviations of casting dimensions:
 - Upto 100 mm (from -1.0 to +1.5) mm;
 - Above 100 upto 200 mm (from -1.5 to +2.0) mm;
 - Above 200 mm (from -2.0 to 3.0) mm;
 - For radii above 3 upto 10 mm ±1 mm;
 - Above 10 upto 30 mm ±1.5 mm;
 - Above 30 mm (from -1.5 to +2.0) mm.
- Limit deviations of wall thickness (from -1.0 to +1.5) mm.
- Unspecified wall thickness 5 mm.
- Unspecified casting radii 2..5 mm.
- Casting draft angle 2° above tolerances.
- Unspecified limit deviations of dimensions for machining: H14; h14; ±IT14.
- At the places of basing, dimension 'L' should be (9.5±0.3) mm.
- It is permitted to make dimension exceeding 1 mm is not permitted on the surfaces.
- Notches, dents with diameter exceeding 1 mm, notches and dents with depth not exceeding 0.05 mm, non intersecting of flange with depth not exceeding 0.1 mm, exceeding from the internal profile by 7 mm minimum is permitted.
- Reduction of wall thickness at machining places upto 3mm minimum is allowed.
- Check the inner profile of cover by ensure with checked tooling.
- Check the inner cavity of cover as per dummy.
- Difference in dimension should be ±0.1 mm maximum.
- Technical requirements for thread as per standard GOST 26021-00.
- Absence of machining is permitted on surface 'C'.
- Test the casting for air-tightness with water under pressure minimum 0.3 MPa (3 kgf/cm²) for 2 minutes. Leakage of water is not permitted. It is permitted to carry out air tightness test with air in water pressure minimum 0.1MPa (1 kgf/cm²). Leakage of air is not permitted.
- Mark the grade of material as per GOST 2171-90, letter size 10 - Пp3 GOST 26.008-86.
- Projection of surfaces П over the plane of rib should not exceed 1 mm with the maximum linear dimensions of cover.
- Traces of Tools are permitted on the length '4' and '5'.
- *Dimensions are given for reference.
- **Dimensions are ensured by Tool.
- Notches, Burrs, Fragmentations over thrust metals are not allowed on the surface 'C'.

DRN	AK 94 (A14) GOST 1583-80	USED ON:	CS08-09-B
CHD			
APPD			
DATE	11 FEB 2016	CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE	1:2	AVAD	
DIMENSIONS IN mm		TITLE:	R.H.HEAD COVER
TOLERANCE ON DIMS		D S CAT NUMBER	
UNLESS OTHERWISE STATED IS 2862-89		DRAWING NUMBER:	406-93-14
ALL THREADS TO CONFORM TO IS:4218.PART-4		ISSUE DATE	
		NATURE OF AMENDMENTS	

8-8U-30230



① Остальная графика и технические условия по чертежу СБ 406-08.
 OTHER SKETCHES AND SPECIFICATIONS ARE AS PER DRAWING СБ 406-08.

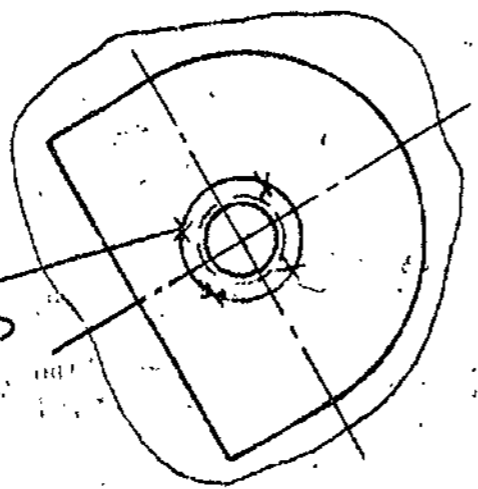
① SET THE BUSH ITEM 2 ON SEALING COMPOUND ANAEROBIC ANATERM-5МАУ 2257-339-00208947-2000 AS PER ИЛ-652-86.

② * СБ 406-12-77

VIEW A
 ВУДА

8-8U-30230
 43
 28.1.98

② Рокерный
 TO BE PUNCH-LOCKED



②	1	406-93-14	CYLINDER HEAD COVER RH	1	
	3	350-03	Шпилька М6×24	24	
	2	306-157	Втулка BUSH	2	
	1	406-93-7	Крышка головки пробы	1	
ITEM NO		PART NO	NOMENCLATURE	QTY	REMARKS
		Обозначение	Наименование	Кол.	Примечание

* PILOT SAMPLE SHOULD BE APPROVED BY A IIS P BEFORE BULK PRODUCTION

EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS IS
	(LETTERS)
2 9.9.15	Wide Notn No. 196-09(F-164)
1 7.2.99	NOTN. No. 05-07. F 158
ISSUE DATE	NATURE OF AMENDMENTS
DATE	SCALE: 1:1
CDI	DIMENSIONS IN mm
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED
APPD	ALL DIMENSIONS TO CONFORM TO
DATE 28.1.98	
	USED ON: *СБ 406-12-77
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVA II	
TITLE	CYLINDER HEAD COVER, R.H.
D'S CAT NUMBER	DRAWING NUMBER
	СБ 306-08-8