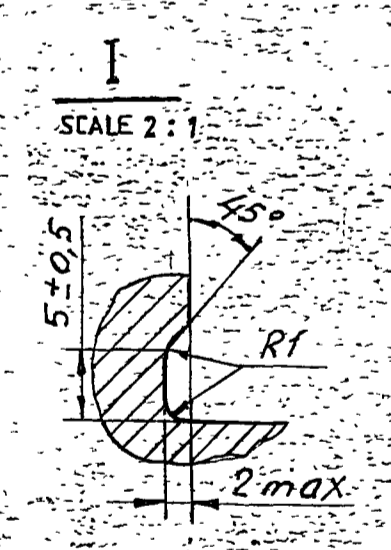
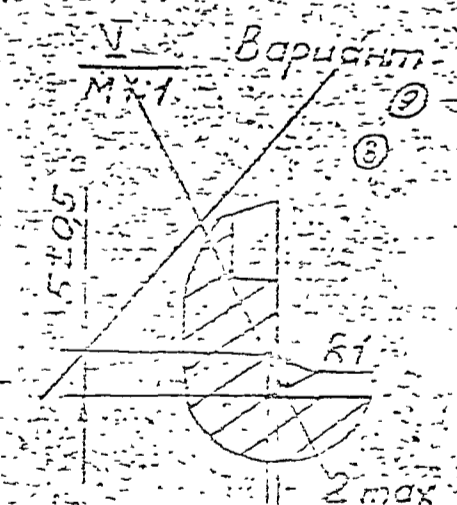
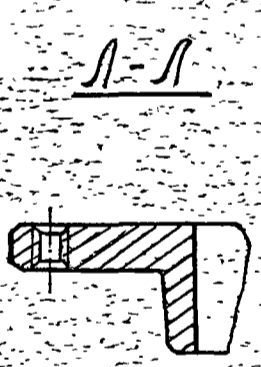
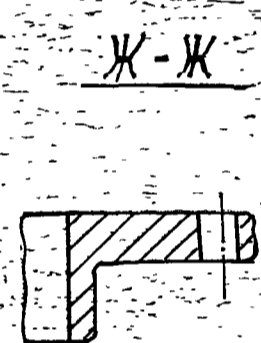
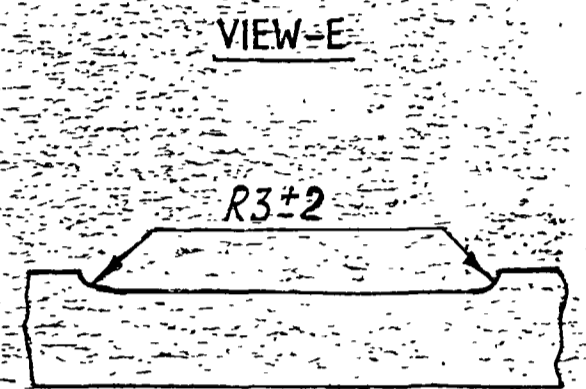
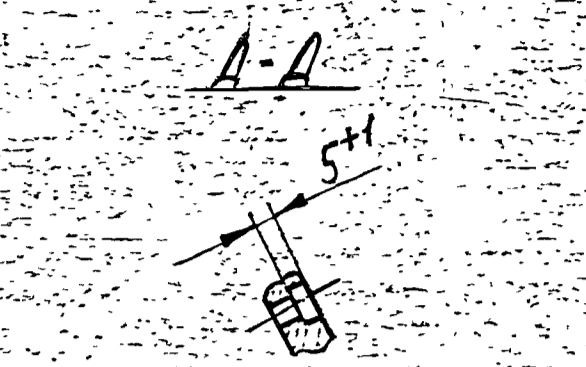
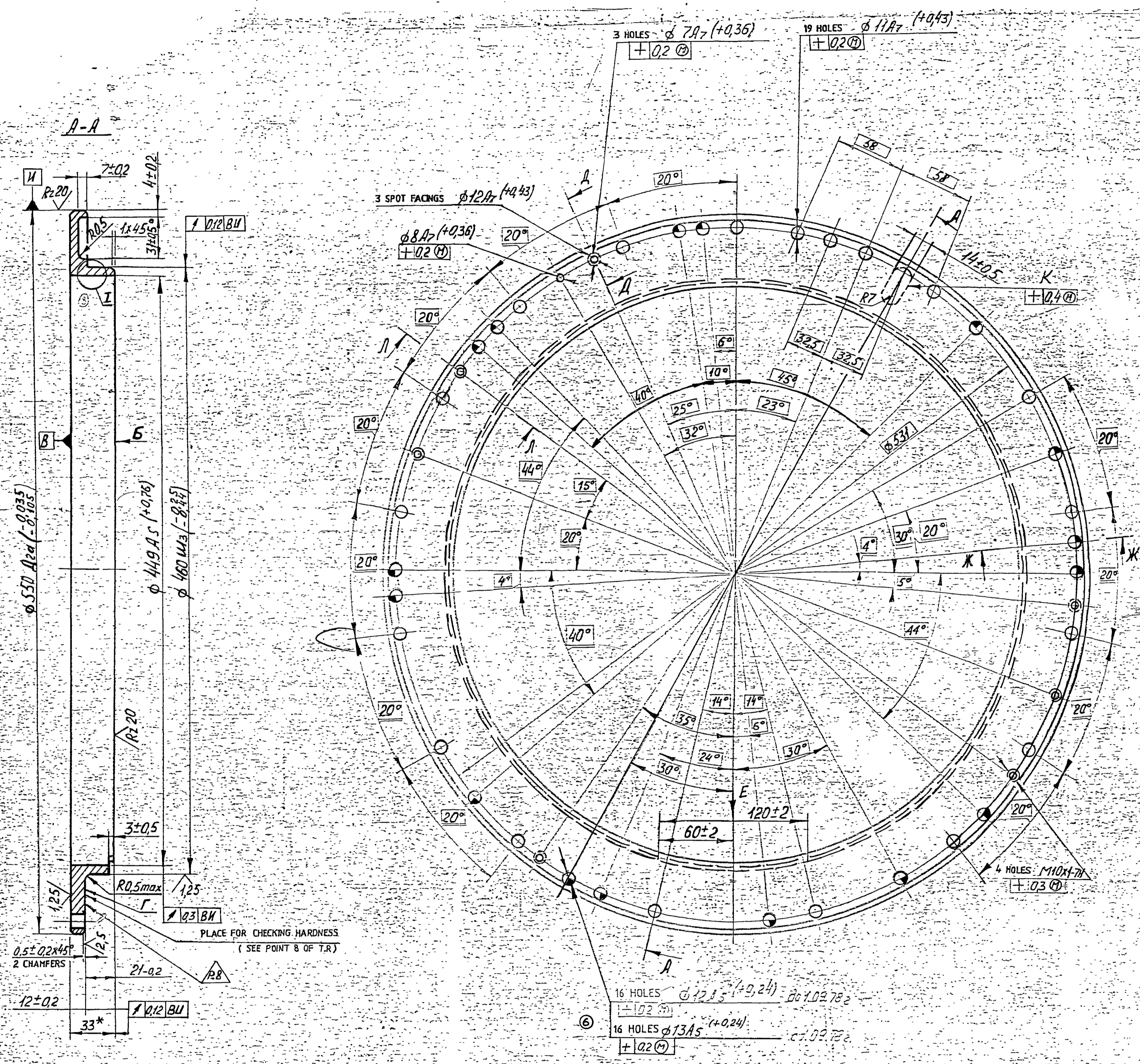


"COMMON TO BLT"

INDIANISED DRG. PREPARED BASED ON ISSUE -9

SIZE A1



1. BHN 341 TO 285 (DIA OF INDENTATION 3.3 TO 3.6)
2. SURFACE $\phi 460$ AND FACE B MAY BE MACHINED TO OBTAIN SURFACE FINISH OF 2.5 PROVIDED SUBSEQUENT LAPPING WITH BY EMERY AND OIL IS PERFORMED.
3. DIAMETER OF ONE HOLE M10x1-7H MAY BE INCREASED BY 0.1 mm TO BE CHECKED WITH SMOOTH PLUG GAUGE.
4. CHAMFER 1x45° MAY BE DONE IN SLOT 'K' INSTEAD OF RADIUS R0.5
5. MAXIMUM DISTORTION OF B IS 0.2 mm (WHEN CHECKED ON PLATE 0.2 mm FEELER GAUGE SHOULD BIND)
6. INSTEAD OF CHECKING RUN OUT OF $\phi 460$ $\phi 449$ AS AND FACES 'b' AND 'f' IT IS ALLOWED TO CHECK VARIATION IN THICKNESS WHICH SHOULD NOT BE MORE THAN 0.12 mm, BETWEEN THE SURFACES OF $\phi 550$ AND $\phi 460$ AND NOT MORE THAN 0.3 mm BETWEEN SURFACES OF $\phi 550$ AND $\phi 449$ AND TO CHECK VARIATION IN HEIGHT WHICH SHOULD NOT BE MORE THAN 0.15mm BETWEEN SURFACES 'b' AND 'f' AND NOT MORE THAN 0.2 mm BETWEEN SURFACES 'b' AND 'b'
7. COATING: CHEMICAL OXIDIZING PHOSPHATED OIL FINISH OR CHEMICAL OXIDIZING OIL FINISH.
8. MARKING AND CHECKING OF HARDNESS SHOULD BE PERFORMED ON AREA OPPOSITE TO SLOT 'K' ON DIAMETER OF NOT MORE THAN 508 mm.
9. DIMENSION MARKED WITH ASTERISK (*) IS GIVEN FOR REFERENCE.
10. REDUCTION OF HOLE $\phi 13$ AS BY 0.1 mm IS ALLOWED.
11. WHILE MANUFACTURING COMPONENTS ACCORDING TO VERSION 1, SURFACE FINISH OF R2.5/15 IS TO BE ENSURED AT LENGTH 21 -0.2 AND SURFACE FINISH OF R2.5/REMAINING LENGTH IS ALLOWED. 0.3 mm SHOULDER IS PERMISSIBLE IN THE PLACE WHERE SURFACE $\phi 460$ $\phi 449$ TERMINATES IN FACE GROOVE.
12. DIAMETERS NOT MORE THAN FOUR OF NINETEEN HOLES $\phi 11$ A1 MAY BE INCREASED UP TO $\phi 11.7$ mm PROVIDED THESE HOLES ARE NOT ADJACENT.
13. INSTEAD OF RADIUS R3±2 (VIEW E), IT IS ALLOWED TO MAKE R1±0.5 OR CHAMFER 1x45°

EXPLANATORY NOTE

14. Reference material quoted:
structural Chromium silicon alloy good Quality
Grade 38XC Gost 4543-71
- a) Chemical Composition: As per steel grade 38XC Gost 4543-71

CONTENT OF ELEMENTS					
C	Si	Mn	Cr	S	P
0.34-0.42	1.0-1.4	0.30-0.60	1.30-1.60	0.035	0.035
				MAX	MAX

Residual content of Copper and nickel should not exceed 0.30% EACH

- b) Mechanical properties: As per steel grade 38XC Gost 4543-71

Tensile strength kgf/mm ²	yield point kgf/mm ²	Elongation %	Reduction in Area %	IMPACT Strength kgm/cm
95 min	75 min	12 min	50 min	7 min

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

EST. MASS 7.85 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	DIMENSIONS IN mm.	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69	CONFORM TO
				15-09-88	1:2			
MATERIAL: STEEL 38XC GOST 4543-71								USED ON: 172 40 021 Cb
CONTROLLERATE OF QUALITY ASSURANCE (HEA/TY VEHICLES)								A V A D I
TITLE								BOOSTER BODY RIGHT
D S CAT NUMBER								CRAWLING NUMBER
								175 40 052
ISSUE	DATE	NATURE OF AMENDMENTS						
10A	28-11-98	Russian Spits. decision on 23-10-98						
10	22-11-88	Amdt. List 6/ii, Book 2.						

