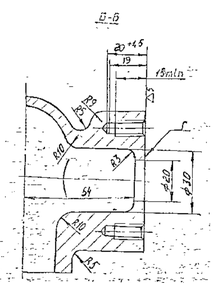
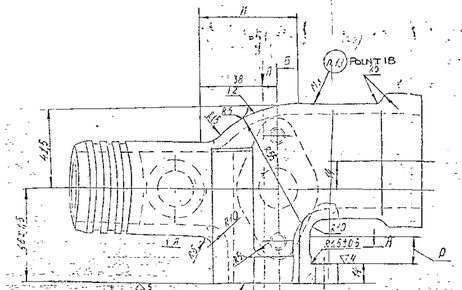
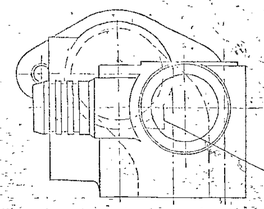
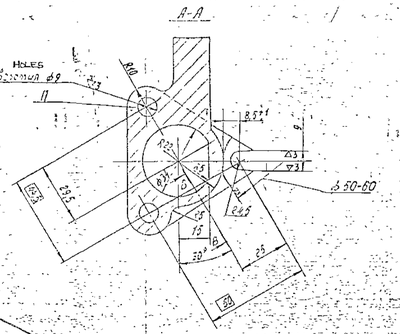
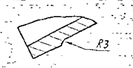
406-30-11A





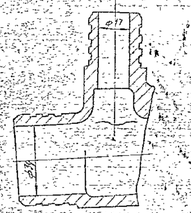


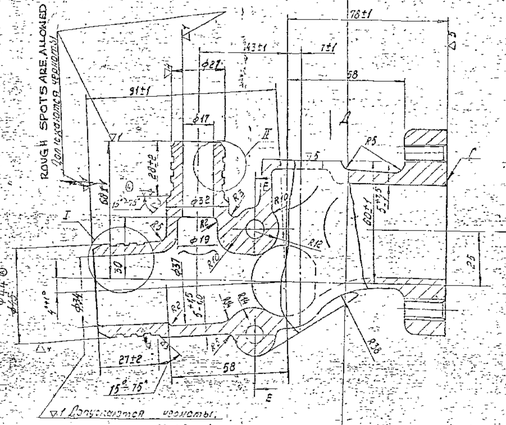


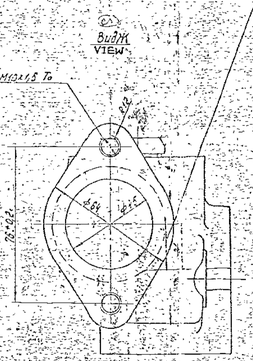


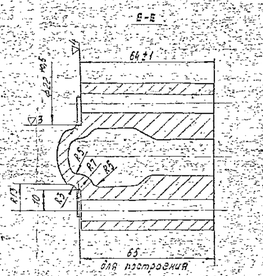
Допускается отливать по условному контуру

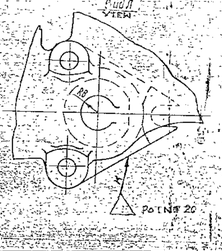
MAY BE CAST ALONG THE CONVENTIONAL PROFILE

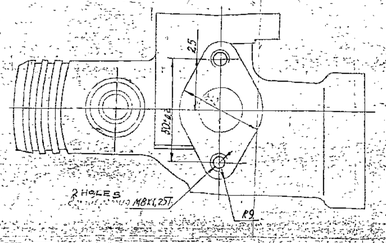


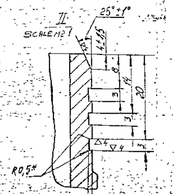


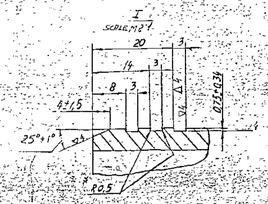












1. Requirements for casting should be in accordance with ITM - 65 - 70
2. Casting tolerances on diametrical and linear dimensions (for surfaces which are not to be machined) should be as follows-
   - Upto 100 mm, $^{+1.5}_{-1.0}$ mm
   - Above 100 mm, $^{+2}_{-1}$ mm
   - For radii upto 10 mm, $^{+1.5}_{-1.0}$ mm
   - Above 10 to 30 mm, - ± 1.5 mm
   - Above 30 m, - + 2.0 -1.5 mm
3. The draft should be 2° beyond the tolerance on casting dimensions.
4. Unspecified maximum tolerance from on dimensions for machining of holes: as per A7, that of shaft: as per B7, others, ± 1/2 the tolerance, accuracy of class 8
5. Local thinning of cast wall upto 3 mm is allowed on an area not more than 5% of entire surface.
6. Technical requirements for threads should be according to standard 82021-00
7. The component should be subjected to a pressure test with hot water at a temperature of 60°-80° under pressure 2.5 - 3 Kgf/cm² for 2 minutes. Leakage of water is not permitted.
8. Component may be subjected to a pressure test with air under a pressure not less than 4 Kgf/cm² in water bath for 1.2 min.
9. Unmachined surfaces and machined ends of branch pipes are to be coated with phend-formaldehyde lacquer in accordance with МЛ-10.73.
10. Machined ends of the branch pipes may not be coated with phend-formaldehyde lacquer on the inside and outside.
11. Permissible on the outer cylindrical surfaces of branch pipe ends is cutting-in of the tool or shoulder on the machined cylindrical surfaces over the unmachined surfaces with subsequent dressing of sharp edges. Maximum thickness of branch pipe wall at the places of machining is 3 mm
12. When dressing the places of transition of machined surfaces of branch pipe into unmachined surfaces local damage (Removal) of coating on unmachined surface of the entire area may not exceed 3 cm²
13. Sharp edges are not allowed.
14. Buckling of surfaces should not exceed 0.1 mm.
15. On section И, radius R 18.5 smoothly merges in radius R 22.5.
16. *Dimension for tool.
17. Dimensions 8, 14 and 25, specified on enlarged drawings I an II may be implemented with tolerance ± 1 mm, provided the width between the grooves is 2 mm, minimum.
18. Material grade is to be marked in casting. Marking by punching is allowed.
19. Shift of axes of holes П from the true position should not exceed 0.2 mm (MMC)
20. To be marked by punching.
21. Milling cutter marks at height P= 12 mm is allowed. Minimum wall thickness should be 3 mm
22. Alternate material АЛ 5 Gost 2685-75.

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

EST MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS ⊲ (LETTERS)
0.83 Kg	

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

ISSUE	DATE	NATURE OF CHANGES
A	26-11-87	AUTHORITY 86-220

DRN		MATERIAL:- АЛ9 GOST 2685-75
CHD		
TCD		
APPD		
DATE	26.11.87	
SCALE = 1:1		
DIMENSIONS IN mm		
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.		
ALL THREADS CONFORM TO		

USED ON - C6406-05-3

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI

TITLE: OUTLET R.H

DRAWING NUMBER: 406-30-11A