

NUMBER..... I 2923

SHEET..... 1 OF 19

SUPERSEDES.. .

Ty 38-006-204-74

REV. (10/1)

ALBUM No. 1

TECHNICAL DOCUMENTS

AND

TECHNICAL SPECIFICATION ON SOLID

RUBBER STRIPS OF SIZES

600x140 AND 200x136

CONVENTIONAL INDEX

84/0848711-01-40148T

| | | | | |
|---------------|-----------------|--------------------|------|--|
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| | NAME | SIGN. | DATE | <i>[Signature]</i> |

Ordnance Factory
Project
Hyderabad.

NUMBER.....I-2923.....

SHEET.....2..... OF19.....

TY 38-004-204/14

SOLID RUBBER TYRES OF ADHESIVE BONDING
ON THE DISKS WITH LEADS.

TECHNICAL SPECIFICATIONS

BY 38004204 - 74.

TY38-004-204-74

Present technical specifications refer to solid-rubber tyres of adhesive attachment of rubber to the metal on the disks with beads intended for road wheels, idler wheels and support rollers of caterpillar vehicles for special purpose.

Purpose of tyre, conventional index, of vehicle on which the tyres are to be mounted, numbers of drawings for tyres and disks number of tyres on vehicle, load on tyre, speed & of movement of vehicle, guaranteed kilometers flow service and storage life of tyres are specified by appendixes as per form No.1 to present technical specifications.

1. TECHNICAL REQUIREMENTS.

1.1 Solid rubber tyres should correspond with the requirements of present technical specifications.

1.2 Solid rubber tyres represent solid rubber ring, vulcanized with the help of adhesive to surface of disk with leads to be rubberized.

1.3 Tyres are manufactured as per drawings and technological rule, approved in a set order. Change in the drawings of tyres and disks and technological rules are carried out in the order, specified in GOST 2.503-74 and GOST 2.902-68.

1.4 Tyres slits and cross-cuts of rubber mass should be monolith, should not have pores and cracks, bubbles and foreign inclusions visible to naked eye.

1.5 At the "metal-rubber" boundary the dispersal separate faulty-fusions of total area 4.0 cm^2 , are allowed if maximum area of each faulty does not exceed 1.0 cm^2 if area of each faulty fusion is in the limits of from 0.25 to 1.0 cm^2 , then, distance between them should be less ^{than} 15 cm . If the area of each faulty fusions is arranged with in the limits from 0.1 to 0.25 cm^2 , then the distance between them ^{should} be not less than 5 cm . Smaller non-group faulty fusions are allowed.

1.6 Permissible defects of appearance of tyre, having no effect on performance are specified with instructions on grading of solid rubber tyres by appearance.

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1.3. Rubber of tyres should correspond the standards, as per physio-mechanical characteristics shown in table 1.

TABLE 1

| Description of characteristics | Standards | Test procedures |
|---|--|---|
| 1. Conventional voltage at elongation of 100%, MPa (kgf/cm ²), min. | 5.9(80) | GOST 270-75 standard piece of type-I. |
| 2. Conventional strength at elongation MPa(kgf/cm ²), min. | 9.8(100) | GOST 270-75 standard piece of type-I. |
| 3. Elongation while break %, min. | 740 | GOST 270-75 standard piece of type-I. |
| 4. Residual elongation, % Max. | 10 | GOST 270-75 standard piece off type-I. |
| 5. Brittleness temperature, °C, Max. | Minus 60 | GOST 7912-74 |
| 6. Resistance to rubber separation from metal, KN/m (kgf/cm) | Specified in the appendix as per form No.1 to present technical specifications for each type of tyres and grades of alloy. | As per item 3.7 of present specifications. |
| 7. Hardness on the surface of tyres as per shore A hardness tester. | 74-84 | As per item 3.2 of present technical specification. |
| 8. Resistance to tear, KN/m (kgf/cm) min. | 25 | GOST 262-73 standard piece of type 5. |
| 9. Rubber characteristics after heat ageing for 24 hours 100°C±1°C. | | |
| 1. Conventional strength at tension, MPa(kgf/Cm ²)min. | 9.8(100) | GOST 9024-74 standard piece of type 1. |
| 10. Elongation while breaking, %, min. | 105 | GOST 9024-74 standard piece of type 1. |

Note: 1. Failure of rubber (tear) may be allowed provided present technical specifications of standards are observed.

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2. Rupture is allowed in case of separation of strip of rubber from disks of light alloys along the surface of alloy with the transition of particles of alloy to separating rubber provided present technical specifications standards are observed.
3. Analysis of rubber for heat ageing and brittleness temperature are carried out once in a month on two tyres of one of the tyre dimensions, selected for analysis as per items 1 to 7 of tables.1

1.8 Metal disks are supplied to tyres manufacturing factory in accordance with the running drawings. Disks which are supplied for manufacturing of tyres, should have TID stamp, of disks manufacturer. Every batch of disks should be accompanied by documents, where the following are shown:-

- a) Description of disks manufacturing factory,
- b) Drawing number,
- c) Number of disks in batch,
- d) Stamp of technical inspection department
- e) Metal grade as per GOST or specification (TY),
- f) Date of dispatching, .

1.9 Corrosions, presence of passivating substances, acids, alkali, salts and oils and also etching shine are not allowed on the surface of the disks, supplied to tyres manufacturing factory and also in initiating production. Corrosion, appearing on surface of disks during transportation and storage, should be removed before rubberizing on tyres manufacturing factory.

1.10 It is allowed to rubberize the disks after removing the rubber mass from metal. After removing, the rubber disks should have geometrical dimensions which provide fabrication of tyres, satisfying the requirements of present technical specifications.

Method of rubber mass removing from the disks should be agreed between disks manufacturing factory and tyres manufacturing factory.

1.11 Tyres should be serviceable at an ambient temperature with in the limits of $\pm 55^{\circ}\text{C}$.

1.12 Tyres are furnished in batches. Number of tyres in

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the batch should not exceed 250 pieces. Every batch should be accompanied by the documents, characterizing corresponding of tyres within the requirements of present technical specifications (TY).

1.13 The following are to be shown clearly on every tyre:-

- a) Letter-index of manufacturing of tyre;
- b) Designation of tyre dimensions;
- c) year, month of manufacture and serial number;
- d) Stamp of technical inspection department of factory-manufacturer "Serviceable, TID",
- e) Stamp of customer's representative,
- f) Batch number.

Designation of dimension of tyres reapplied to lateral surface of tyres by the imprint of engraving on mould. Letter index of manufacturer of tyres, month, year and serial number are applied by the imprint of image from metal plate. Stamps of technical inspection department, member of batch and customer's representative are to be applied to lateral surface of tyres by indelible water paint.

1.14 It is allowed to apply letter index of manufacturer of tyre, month, year of manufacture and serial number by burning.

2. ACCEPTANCE RULES

2.1 The following types of inspections are used to check the quality of tyres and their correspondance to requirements of present technical specifications.

- a) Visual inspection, 100% of tyres;
- b) Hardness checking of rubber mass, 10% tyres;
- c) Checking of physio-mechanical characteristics of rubber (with the exception of sub-item 5,9,10 of table 1) and the quality of fastening, one tyre from a batch of max. 100 pieces; two tyres from batch of more than 100 pieces. For these tests types refused as per appearance defects may be used.

2.2 Selection of tyres for analysing is carried out as per the agreement with the customer's representative.

2.3 Technical-Inspection Department furnishes the batches with tyres, period after manufacturing of which doesn't exceed 3 months, which undergone 100% checking for appearance and all tests in scale specified by present technical specifications, with the exception of tests as per subitem 1.5 and 1.7.

2.4 All the tests are to be carried out not earlier than 2 hours after vulcanization of tyres.

2.5 Technical Inspection Department puts stamp "Serviceable" on each tyre, agreed with the requirements of present technical specifications.

2.6 Refused tyres should be marked with clearly visible stamp "Reject" and insulated from other tyres.

2.7 Technical Inspection Department presents complete batch of tyres to customer's representative in accompanying the following documents,

a) Notice about the presentation of batches of tyres (appendix-2);

b) Certificate of tests, conducted in accordance with the requirements of present technical specifications (Appendix-3);

c) Statement of acceptance of batch (appendix-4);

d) List of serial numbers of tyres for batches (appendix-5)

2.8 While accepting the tyres by customer's representative conducted in the ^{presence} ~~presence~~ of technical inspection department representative by appearance are to be checked at least 10% of tyres. Customer's representative makes simultaneously sampling inspection of hardness of rubber for race mass. In case of detecting during sampling inspection, the tyres which do not comply with the requirements of present technical specifications, batch of tyres should be re-graded. After re-grading by technical inspection department to the batch of tyres are presented to customer's representative with the corresponding marking in notice.

2.9 Stamp of customer's representative should be put on each tyre of batch accepted by customer's ^{re} representative. Rejected by customer's representative tyres are marked clearly by legible stamp "Reject" serial number or it is grinded away and its insulated from other tyres.

3. INSPECTION METHODS

3.1 Visual inspection of tyres is carried out in accordance with the instructions on grading of tyres as per appearance.

3.2 Hardness of rubber are checked by shore 'A' hardness tester immediately on the surface of mass. For result of tests is taken arithmerical mean of five measurements, conducted at one tyre. In case of obtaining unsatisfactory results, the hardness of rubber is to be checked on each tyre of batch.

3.3 To determine the conventional stress at 10% elongation as well as conventional tensile strength relative and residual elongation, atleast five plates of the length of 110mm and width of atleast 17mm should be cut from solid rubber tyre in the direction of calendering of rubber. Grinding of plates is allowed. Thickness of plates (among them grinded ones) should be 2.0 ± 0.3 mm. Standard pieces of type Ξ (GOST 270-75) are prepared from the plates by blanking.

Tests are carried out as per GOST 270-75.

3.4 To determine the quality of bonding of rubber mass to metal, the beads of ready tyres should be removed by grinding as per sketch, agreed with the customer's representative.

3.5 The quality of bonding of rubber to metal is determined by visual examination of surface condition at the rubber-metal boundary obtained after cutting the mass rubber on $\frac{4}{5}$ length of disk circumference. In this case for tyres fabricated on disk of light alloys the destruction of surface layer of metal with transition of metal particles to remove rubber is allowed. It is allowed also to present reference standard of appearance of surface layer..

3.6 Resistance to separation of rubber from metal is determined by separating of band of rubber from disk ~~of band of rubber from disk~~ and measurement of obtained force.

3.6.1 From the tyre, selected for testing, rubber mass along the arc equal to tyre's $\frac{1}{3}$ length should be cut and the uniform layer of rubber of thickness 8 to 10mm is to be left on metal therewith. Two slits reaching metal and situated at a distance 25 ± 1 mm of one from another should be made at mid part of remained on the disk rubber layer. The rubber beyond the strip formed by the slits and intended for separation should be cutoff. The remaining strip of rubber is to be cut partially at the rubber metal boundary along the section with the length of 50 to 100mm. The tyre is fixed and fastened on freely rotating chuck with part of strip which is cut partially secured in clamp of breaking machine. Cross-section paper is to be fixed on the cylinder of recording equipment.

3.6.2 Drive of breaking machine is to be turned on and separation of strip of rubber is to be performed at the section with the length of 50 to 80mm at speed of 100mm/minute.

Note: In case of separating of the strips of rubber there can be adhesion destruction (along the rubber-metal boundary) as well as cohesion destruction (destruction along rubber) while testing the recording equipment of breaking machine notes curve "load-versus-time". In case of cohesion of destruction of rubber strip testing is repeated cutting the same strip again at the rubber metal boundary.

3.6.3 Characteristic of resistance to separation of rubber from metal is calculated by dividing the average force by width of strip to be separated. In case of adhesion destruction, determining of average force is carried out by planimetry of corresponding area under curve "load-versus-time" and dividing it by length of corresponding basis. Accuracy of measurement of area is $\pm 1.5\%$, accuracy of measurement of base length is $\pm 0.5\text{mm}$.

Note: In this the obtained value of average force, related to the unit of width of separated rubber strip, characterizes the resistance of rubber to separation from metal.

~~It is~~ While binding the area, in case of adhesive destruction on curve "load-versus-time" there should be excluded the initial section, characterizing period of increase of load which is stipulated only by deformation of rubber strip without destruction of boundary of joint or mass of rubber; and the final section which is stipulated by possible further deformation of rubber strip and subsequent failure of rubber.

Maximum strength, is fixed at curve "load-versus-time" disregarding its form in case of cohesion failure. The mean value from two maximum forces obtained while cohesion failure in primary and repeated tests, related to the unit of width of separated rubber strip is taken as a final result.

Note: 1. In this ~~case~~ it is necessary to count that the resistance to separation of rubber from metal is above than the value specified in accordance with the given item.

2. Averaged force, related to the width of sample, should not be less than indicator of resistance to separating rubber from metal, specified by appendix as per form No. 1 to technical specifications.

3.6.4 Respective inscription is entered in the certificate of testing by solid-rubber types in item "resistance to separation in kgf/cm".

Mark In certificate mark "P/2" (destruction along rubber-metal boundary) in case of adhesion of destruction.

Mark In certificate mark "P/P₂" (destruction along rubber) in case of cohesion of destruction.

3.7 When obtaining unsatisfactory results of tests (or inspection) as per one of indicators, shown in sub-item 1.4, 1.5, 1.7 of present technical specifications.

The tests are repeated as per this indicator by doubling the number of tyres. When getting unsatisfactory results of repeated tests, batches of tyres are held for the following re-grading.

Regrading of tyres, rejected as per results of physio-mechanical tests of rubbers carried out by taking tyres apart as per cookings one tyre from each cooking, is tested except cooking on which ^{tests} already carried out tests.

Results of tyre tests from each cooking are considered final results. While obtaining unsatisfactory results of repeated tests because of reasons not depending on vulcanization, batch of tyre are divided in the group as per shifts.

From each group of shifts, with the exception of group or shift on which tests are already conducted, one tyre is to be tested.

Results of tests of tyres from group or shifts are considered final results.

3.8 Check tyres as per item 1.4 by visual examination of parts of rubber mass, obtained after tests as per sub-item 3.1, 3.5 and 3.6.

4. TRANSPORTATION AND STORAGE.

4.1 Transportation of solid rubber tyres is carried out in covered wagons, containers, automobiles, in the conditions, which are prevent tyres from mechanical damages, solar radiation and effect of oils, petrol acids, alkalines, salts and others damages able to ^{damage} and destruct rubber solutions. Insignificant corrosion of tyres ^x disks is allowed. Tyres are not to be packed.

4.2 Every completed batch of tyres should be sent with the accompanied documents in accordance with the item 2.7(b, c, d).

4.3 Tyres are ^{at 3/8 m} stored in conditions of dry storehouse, at a distance of at least 1.5^m from heaters at a temperature from minus 30°C upto plus 30°C in piles with the height not more than 1.5^m

5. DIRECTIONS FOR OPERATION (USAGE)

5.1 In manufacturing road wheels, idler wheels and support rollers, derating of tyre-quality index specified in present Technical specifications is not allowed.

Note: In order to provide the required quality of tyres, before starting the serial production of wheels, the commission including of representatives of organization which developed tyres, manufacturer of tyres, manufacturer of wheels and customer's representatives should carry out inspection of technological process and makes conclusion about observing of item 5.1 of present technical specifications. Then, any changings in technology of production of wheels, which may effect to the quality index of tyres, are carried out only as per decision of commission of above given staff.

5.2 Tyres should be used only in the conditions, which are shown in present technical specifications and appendixes to them for each dimensions of tyres.

5.3 It is necessary to replace the destroyed tyre by new tyre, as soon as possible to prevent failure of other tyres because of over loading.

5.4 Serial numbers of tyres of road wheels, fixed on the articles, are registered in the log-book of articles by showing the place of location.

- Example: 1. L(left) I (internal) - C y1781258
2. R(right)E (external) - C y1781259

6. SUPPLIER'S GUARANTEE

6.1 Tyres should be accepted by TID^{of} manufacturing factory.

6.2 Manufacturing factory guarantees the service period (of usage and storage also) and run, given in appendixes to present technical specifications, provided customer conditions of usage, transportation and storage, specified by present technical specifications and appendixes to them.

6.3 Claims to the quality of tyres are presented by customer only with the limits of guarantee run or time of using and storage, specified by present technical specifications.

Dhruva Factory
Project
Hyderabad.

TY 38-004-201-74

NUMBER.....I-2923.....

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Form No.1

A P P E N D I X No. _____
to Technical specifications _____ for solid rubber
tyres of dimensions.....

1. Type, conventional index of vehicle
2. Maximum speed movement of vehicleKM/hours.
3. Operating characteristic of tyres:

| Size of tyre | Purpose | Number of tyres on vehicle. | Digression | Guarantee period of use and storage. | Additional requirements and conditions Tyres Disks |
|--------------|---------|-----------------------------|------------|--------------------------------------|---|
| 600x140 | | 12. | | 1210 | |

4. Guarantee Kilometres.
5. Guarantee period of usage and storage..
6. Additional requirements and conditions..
-
-

Integral part of present appendix are drawings No. No.....
..... insheets.

Approved:

Deputy director of branch institute,
Scientific Works.

Chief-engineer of consuming factory:

Customer's representative
of manufacturing factory.

Customer's representative
of consuming factory.

Chief Engineer of manu-
facturing factory.

Ordnance Factory
Project
Hydrabad.

Ty30-004.204-74

NUMBER.....I-2923.....

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Form No. 2

Description of manufacturing factory

NOTICE NO: _____

about the presentation of batch of solid-rubber tyres.

For acceptances presented the batch of solid-rubber tyres No. _____ in the quantity of _____ pieces produced on _____ 19 _____ having dimensions of _____ and fabricated in complete accordance with the approved technological regulation No. _____ and Technical Specifications.

The following are enclosed to the batch.

1. Approved act.
2. Testing certificate
3. List of serial numbers.

Managing Director (Chief Engineer) of the factory

Chief of TID.

Lodhna Factory
Project
Hyderabad.

TY32-004-204-74

NUMBER.....I-2923.....

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FORM NO.3

DESCRIPTION OF MANUFACTURING FACTORY

C E R T I F I C A T E

of testing solid-rubber tyres

Test of solid rubber tyre from batch No. _____ serial
number _____ produced on _____ 19____.

I. Physio-mechanical indicators of rubber:-

- | | |
|--|-------|
| a) Conventional stress at elongation 100%, MPa (kgf/cm ²) | ----- |
| b) Conventional strength in tension, MPa (kgf/cm ²) | ----- |
| c) Elongation while breaking in % | ----- |
| d) Permanent elongation, % | ----- |
| e) Hardness, conventional units | ----- |
| f) Resistance to tearing, KN/M | ----- |
| g) Temperature of brittleness, °C | ----- |
| h) Conventional strength in elongation after ageing, MPa (kgf/cm ²) | ----- |
| i) Elongation while breaking after ageing, % | ----- |
| 2) Resistance to separating from metal KN/M (kgf/cm ²) of tyres | ----- |
| 3. Characteristics/as per item 1.4 | ----- |
| 4. Characteristics as per item 1.5 | ----- |

Chief of main laboratory,
Chief of physio-mechanical testing sector.
Decision of technical inspection department.
Inspection Department Staff Chief.

Ordnance Factory
Project
Hyderabad.

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NUMBER.....I-2923.....

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FORM NO: 4

Description of manufacturing factory

S T A T E M E N T
on delivery and acceptance

Present statement is made out to confirm that batch No. _____
of solid rubber tyres of dimension _____ is fabricated
in complete accordance with technological regulation No. _____
meets requirements of technological specifications and drawing
No. _____.

| Quantity | Date of manufacture | Date of testing | Remarks |
|----------|---------------------|-----------------|---------|
|----------|---------------------|-----------------|---------|

Managing Director of factory(Chief Engineer).

Inspection Department Chief.

Decision of customer's representative.

Batch of solid-rubber tyres No. _____ is checked at random, found
corresponding with technical specifications and accepted to the
number of _____ pieces.

Customer's representative.

| | | |
|---|-----------------|----------------------------|
| Ordnance Factory Project Hyderabad. | TY38-004-204-74 | NUMBER...I-2923..... |
| | | SHEET...16.. OF ...19..... |

FORM NO.5

Description of manufacturing factory

L I S T

of serial numbers of solid rubber tyres of batch No. _____

| Item No. | Serial Number | Item No. | Serial Number | Item No. | Serial Number |
|----------|---------------|----------|---------------|----------|---------------|
| 1. | | 101. | | 201. | |
| 2. | | 202 . | | 202. | |
| 3. | | 103. | | 203. | |

| | |
|-------|--------|
| Total | Pieces |
|-------|--------|

Foreman of Technical Inspection Department.

Ordnance Factory
Project
Hyderabad.

TY38-004-204-74

NUMBER.....I-2923.....

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SOLID RUBBER TYPES OF ADHESIVE
BONDING ON DISK WITH BEADS.

I N S T R U C T I O N
ON GRADING ACCORDING TO APPEARANCE.

Vulcanized tyres are subjected to grading after cutting releases and grinding of butt ends of disks from runs of rubber. 100% of tyres are subjected to grading. Not more than 5 various defects are allowed simultaneously at one tyre.

The dimensions of external defects and the depth of their finishing are determined visually and if necessary by measuring the dimension of defects.

Put ~~strong~~^{Stamp} serviceable TID on the tyres on which the inspection was carried out for appearance which comply with the technical requirements of Technical Specifications(TY).

Tyres, unsatisfactory ^{visually} the above given requirements, are marked with clearly visible ~~strong~~^{Stamp} "Rejects".

1. While grading the tyres, it necessary to observe the following:-

| Description of defects of tyres | Dimensions of external defects permissible without grinding on rubber mass, max. |
|--|---|
| 1.1 Cracks on the surfaces of solid rubber. | a) Depth 1mm b) If length of tyres with diameter: upto 500mm; depth is 15mm; above than 500mm, depth is 25mm. |
| 1.2 Cavities, wrinkles, traces of bubbles and removed foreign inclusions sponge rubber, mechanical damages and other defects on the surface of mass. | c) Depth is 3mm. d) Area of every defect for tyres with dimension; Upto 500mm. is 50mm ² , Above than 500mm is 100mm ² . |
| 1.3 Lack of rubber tape end | Depth is 1mm. Length is 100mm. |

2. The following are allowed on solid rubber tyres:-

2.1 Step due to shift of half forms should not exceed 2mm.

2.2 Complete round faulty fusion to the surface of touches of bead with rubber.

2.3 Grinded surface defects on rubber mass in a depth should not exceed 3mm. Area of grinding is not specified.

2.4 ~~Complete round~~

Dents on disks from both sides of tyres, with the length of not more than 50mm, depth not more than 2mm, which are at a distance between dent and weld of not more than 25mm, is allowed if their number at one disk does not exceed 3.

3. The following are not allowed on solid rubber tyres:-

3.1 Separation of rubber mass.

3.2 Inclusions of foreign subjects to solid rubbers.

3.3 Incomplete moulding of rubber mass.

3.4 Incut release of rubber.

3.5 Deformation and damage of disks, preventing mounting of tyres.

4. While detecting defects on tyres, which are not covered by present instructions, question of their allowance ~~maximum~~ for use is decided as per the agreement between tyres manufacturing factory, tyres consuming factory and customer's representatives on these factories.

Appendix No: _____ to
 Ty 380 CH 11-77 for Solid rubber
 Tyre 200 x 136

Form No: 1.

Secret

Sketch No: 2.

1. Type, Conventional index of vehicle: Infantry Combat Vehicle
 (BNIP-I), cat. 765.

2. Maximum speed of the vehicle: 65 km/h.

3. Operational characteristics of tyre:

| Tyre dimensions | Purpose | No. of tyres per vehicle | Max. static load/tyr | Sequence | Org. No. | |
|-----------------|----------------|--------------------------|----------------------|------------|------------------|---------------------|
| | | | | | Type | Disc |
| 300 x 136 | Support roller | 6 | 65 | Single row | 765-34 CS 102 | 765- 3406 105 |

4. Guaranteed mileage: 8000 km in compliance with
 items 6.3 & 6.4.

5. Guaranteed period of operation & storage: 5 years.

In case of breakdown of tyres during guaranteed mileage after 5 years replacement is carried out by manufacturing plant of main article as per the technical act compiled at Army headquarters, in the presence of factory representative, specifying condition of complaint.

6. Additional Requirements & Conditions:

a) Resistance to separation of rubber from metal for alloy AK-8, KN/m, ~~at least~~ should be atleast 3.7;

b) regional non-fusion, detected when checking on crimping tool, depth not exceeding 3mm of any length from both sides is allowed.

Inherent parts of this annexure are drawings
 Nos: 765-3406-102 & 765-34-08-105 (not secret)

I-2923

Секретно
экз. 12

22/22

Rate of Consumption of materials for Solid run
ЦОРА РАСХОДА
С kg · 1000 pcs

материалов на массивные шины
(кг. на 1000 штук)

| наименование материалов Title of materials | Size of type Размер шины | |
|--|-----------------------------|---------|
| | 600x140 | 200x136 |
| Резиновая смесь З4ри-14 Rubber mix I2204 | | 2603 |
| СКМС-1СК 6574 | | 1402 |
| Техуглерод ПМ-15 Tech. carbon 4990 | | 1054 |
| Бензин Benzene 46 | | 46 |
| Дипенилгуанидин (ДПГ) Diphenylguanidine 1799 | | 17 |
| Дихлорэтан Dichloroethane 30 | | 30 |
| Дробь чугунная ДЧК 13, 15, 18 Iron shot 10 | | 200 |
| Канифоль Colophony 56 | | 14 |
| Краска штемпельная желтая stamp yellow paint 1 | | 1 |
| Краска нитроэмалевая красная Red nitro enamel paint 1 | | 1 |
| Клей "лейконат" Adhesive leuconate 20 | | 20 |
| Магnezия жженая Calcined magnesia 57 | | 14 |
| Мыло 50% Soap 4 | | 4 |
| Пленка полиэтиленовая polyethylene film as 4 | | 4 |
| ГОСТ 10354-73 per GOST 10354-73 134 | | 134 |
| Неозон Д Neozone 131 | | 28 |
| Сера Sulphur 265 | | 57 |
| Стеарин Stearin 131 | | 28 |
| Сухой лед Dry ice 12 | | 12 |
| Жидкость полиметилсилоксановая polymethylsiloxane liquid 2 | | 2 |
| Тальк Talc 187 | | 11 |
| Этилацетат Ethylacetate 3 | | 3 |
| Эмульгатор ОП-7 или "Лотос" 0,1 | | 0,1 |
| Emulsifier OP-7 or "lotus" | | |

ур. 363

Appendix to TY 380012011-74 for
Solid rubber tyre 600 x 140

- 1. Type, Conventional index of the vehicle: Infantry
Combat Vehicle
(BNIP-I),
est. 765
- 2. Maximum speed of the vehicle: 65 km/h
- 3. Operational Characteristics of tyre:

| Tyre dimensions | Purpose | No. Tyres per vehicle | Max. static load kgf | Sequence | Req. No Tyre Disc |
|-----------------|-----------------------------------|-----------------------|----------------------|----------------|--|
| 600 x 140 | Support- alter- Track wheel | 12 | 1210 | Single- dow | 765- 3308 10205 765- 3308 10205 |

4. Guaranteed mileage: 8000 km in compliance with items 6.2 & 6.3 TY 380012011-74.

5. Guaranteed period of operation & storage: 5 years
In case of breakdown of tyres during guaranteed mileage after 5 years replacement is carried out by manufacturing plant of main article as per the technical act, compiled at Army headquarters in the presence of customer plant (factory) representative ~~and~~ ~~period specified in~~ specifying condition of complaint.

6. Additional requirements & conditions:

6.1. Resistance to separation of rubber from metal, KN/m, should be atleast 4.0.

Inherent parts of this annexure are drawings Nos: 765-3308/10105 & 765-3308/10205 (net-sec set)