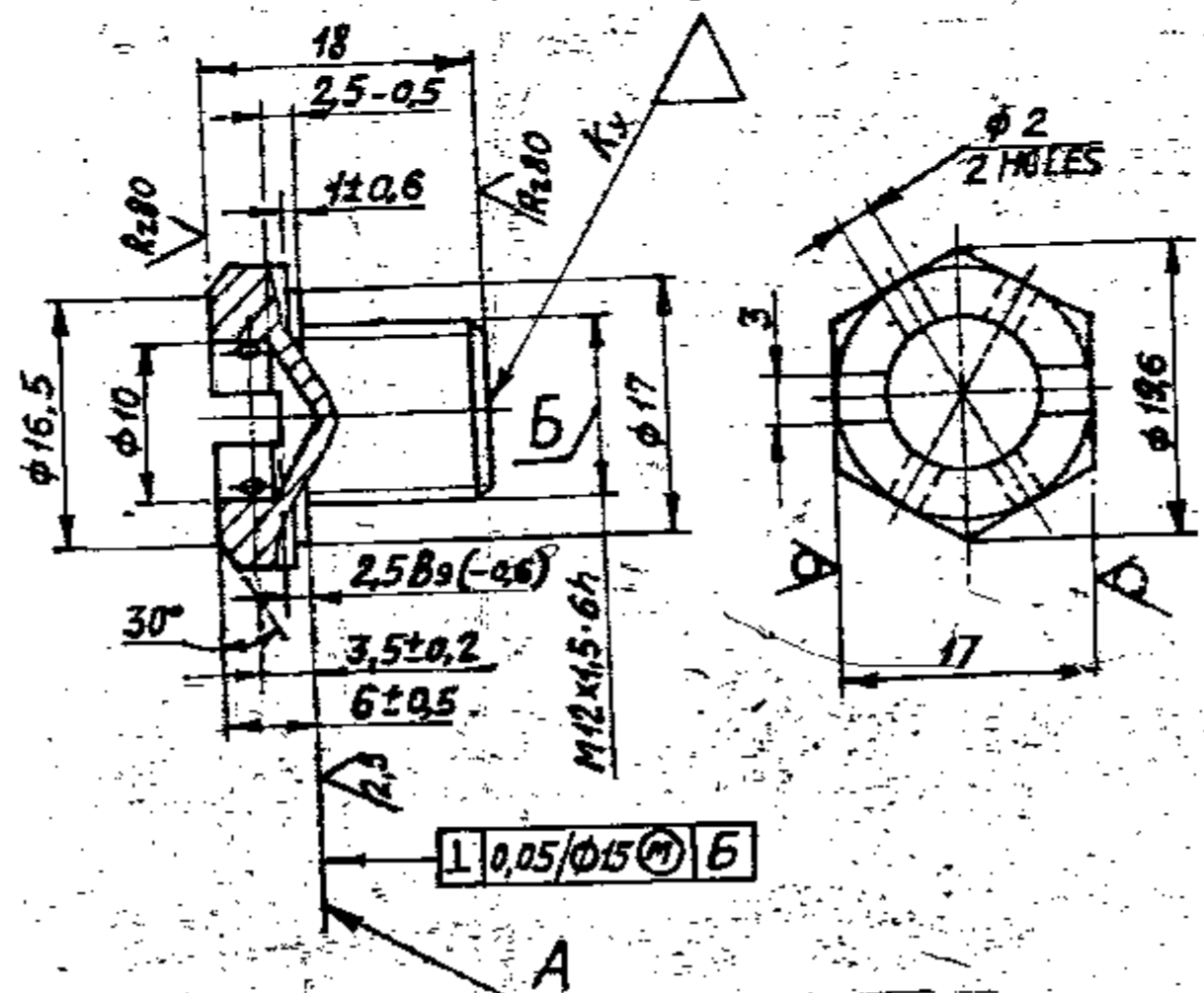


1. MATERIAL SUBSTITUTE IS ACC. TO 45 GOST 1050-74.
2. NON-INDICATED LIMIT DEVIATIONS OF DIMENSIONS ARE acc. TO H₁₄, h₁₄.
3. PARALLELISM ALLOWANCE OF "M" PLANES IN TWO MUTUALLY - PERPENDICULAR DIRECTIONS IS NO MORE THAN 0.1 mm.
4. REQUIREMENTS TO STAMPING ARE acc. TO OST 3.6343-79. STAMPING BEVEL IS ALLOWED TO 0.4 mm ON THE SIDE.
5. COATING IS U9 xp.
- 5.1 COATING IN TROPICAL VERSION IS K29 xp.

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

		EST. MASS - 0.016 Kg	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:- 65Г GOST 14959-79	USED ON:- Cb 20-29-00-8
SCALE	SCALE - 1:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD	DIMENSIONS IN mm	TITLE:- WASHER	
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	
APPO	ALL THREADS CONFORM TO	DRAWING NUMBER	
DATE	23.7.86	302-50	





1. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:-
FOR HOLES - AS PER A7,
SHAFTS - AS PER B7.
2. UNTHREADED SECTION OF PART SHOULD NOT EXCEED 3 MM.
3. THE HEXAHEDRON MAY BE MACHINED TO DIAMETER ϕ 19 MM.
4. WHILE CUTTING BUTT-END A THE SINGLE-POINTED TOOL MAY CUT CYLINDRICAL SURFACE UPTO 0.3 MM.
5. SLOT BASE OF R \approx 35 IS ALLOWED.
6. COATING: CADMIUM-PLATED, 9 MICRONS THICK, OILED. IT IS PERMITTED NOT TO APPLY COATING ON INTERNAL SURFACES AND THREADS.
7. ALTERNATE MATERIAL IS STEEL GRADES 40, 50, GOST 1050-74

EXPLANATORY NOTE :

8. MATERIAL QUOTED : 17-5 GOST 8560-78
45 GOST 1050-74
BRIGHT STEEL OF HEXAGONAL CROSS - SECTION, 17mm A/F ACCURACY CLASS 5 TO GOST 8560-78 AND STEEL GRADE 45 TO GOST 1050-74.
ALTERNATE MATERIAL QUOTED : GRADES 40 & 50 OF GOST 1050-74.

a) CHEMICAL COMPOSITION :

STEEL GRADE	CONTENT OF ELEMENTS %							
	C	Si	Mn	Cr	S	P	Cu	Ni
40	0.37 - 0.45	0.17 - 0.37	0.50 - 0.80	0.25	0.040	0.035	0.25	0.25
45	0.42 - 0.50	0.17 - 0.37	0.50 - 0.80	0.25	0.040	0.035	0.25	0.25
50	0.47 - 0.55	0.17 - 0.37	0.50 - 0.80	0.25	0.040	0.035	0.25	0.25

b) MECHANICAL PROPERTIES :

STEEL GRADE	YIELD POINT Kgf/mm ² (min)	ULTIMATE TENSILE STRENGTH Kgf/mm ² (min)	PERCENTAGE ELONGATION % (min)	REDUCTION OF AREA % (min)	IMPACT STRENGTH Kgf/cm ² (min)	HARDNESS B H N (without heat treatment) (min)
40	34	58	19	45	6	217
45	36	61	16	40	5	229
50	38	64	14	40	4	241

(A) EQUIVALENT MATERIAL:
STEEL 080M40(EN8) TO BS: 970 OR
45 CB TO IS: 1570

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

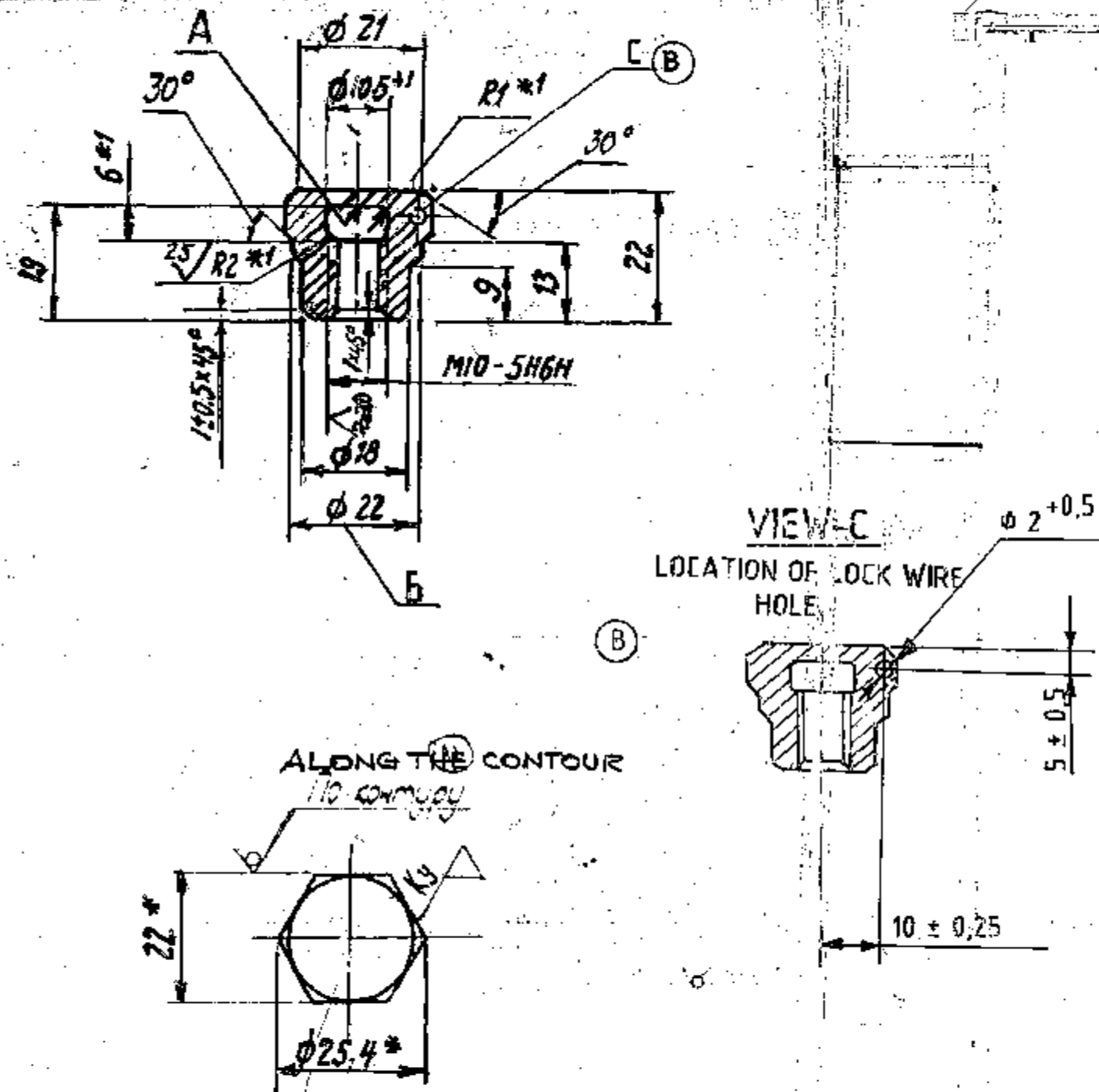
EST. WT 0.015 Kg	TO BE SPECIFIED OR MARKED WHERE APPLICABLE
	LETTERS
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MACHINED CORNERS TO HAVE R. OUTSIDE R. INSIDE EDG. ALL DIMENSIONS ARE PERMISSIBLE.	

DRN CHD TCD APPD DATE SCALE DIMENSIONS IN mm TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2002-88	MATERIAL 17-5 GOST 8560-78 45 GOST 1050-74	USED ON :- CQA (HV) 15.06.001E CB 20-27-00-4 CB 20-29-00-8	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A D I
B 18-03-15 A 10-7-10	PL. 11 of 7th All. Comm. Meeting 01.11-4-12 4th ALT. COMM. MTR. MINUTES POINT No 7 DT. 26-10-09	ALL THREADS TO CONFORM TO	TITLE PLUG
ISSUE DATE	NATURE OF AMENDMENTS	D S CAT NUMBER	DRAWING NUMBER 315-648



DRAWING NUMBER
329-29

Rz 80 (✓)



EXPLANATORY NOTE

- 1) REFERENCE MATERIAL QUOTED
GAUGED HEXAGONAL STEEL BAR CLASS OF ACCURACY 4, 22.0(-0.14) mm A/F TO GOST 8560-78 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
- 2) REFERENCE NOTE 1 ON ALTERNATE MATERIAL : QUALITY CARBON STRUCTURAL STEEL GRADES 40 AND 50 TO GOST 1050-74
- 3) 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

4) 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 MAX	REMARKS
45	61	36	16	40	5	229	REF MATL
40	58	34	19	45	6	217	ALT MATL
50	64	38	14	40	6	241	ALT MATL

- 1. ALTERNATE MATERIAL : STEEL, 40 AND 50, GOST 1050-74.
- 2. ROLLED STOCK, CLASS 4, GROUP 'B' GOST 1051-73 MAY BE USED. TO ENSURE HIGH QUALITY OF COATING, IT IS ALLOWED TO RECTIFY THE SURFACE THE SURFACE DEFECTS OF ROLLED STOCK WITH REDUCTION OF ITS SIZE AS PER ACCURACY CLASS 5.
- 3. UNSPECIFIED TOLERANCE OF DIMENSIONS FOR HOLES AS PER H14, FOR SHAFTS AS PER h 14 AND THE REST OF THE $\pm \frac{IT 14}{2}$
- 4. DRILL MARK NOT EXCEEDING 3mm IS PERMITTED ON SURFACE A.
- 5. THERE MAY BE NO COATING ON INNER SURFACES.
- 6. COATING Zn 3 Cr AS PER U.A. 404 U.A. 483-82 WITH RELIEVING OF HYDROGEN EMBRITTLEMENT.

- 7. COATING Cd 9, CHROMATIZING IN ACCORDANCE WITH U.A. 569-84 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
- 8. FLATS FROM HEXAHEDRON UP TO 2 mm WIDE ARE ALLOWED AT $\phi 6$
- 9. *DIMENSIONS FOR REFERENCE.
- 10. *DIMENSIONS SHOULD BE ENSURED BY TOOL.

E EQUIVALENT MATERIAL STEEL
45C8 TO IS:1570

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

EST WT 0.045 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

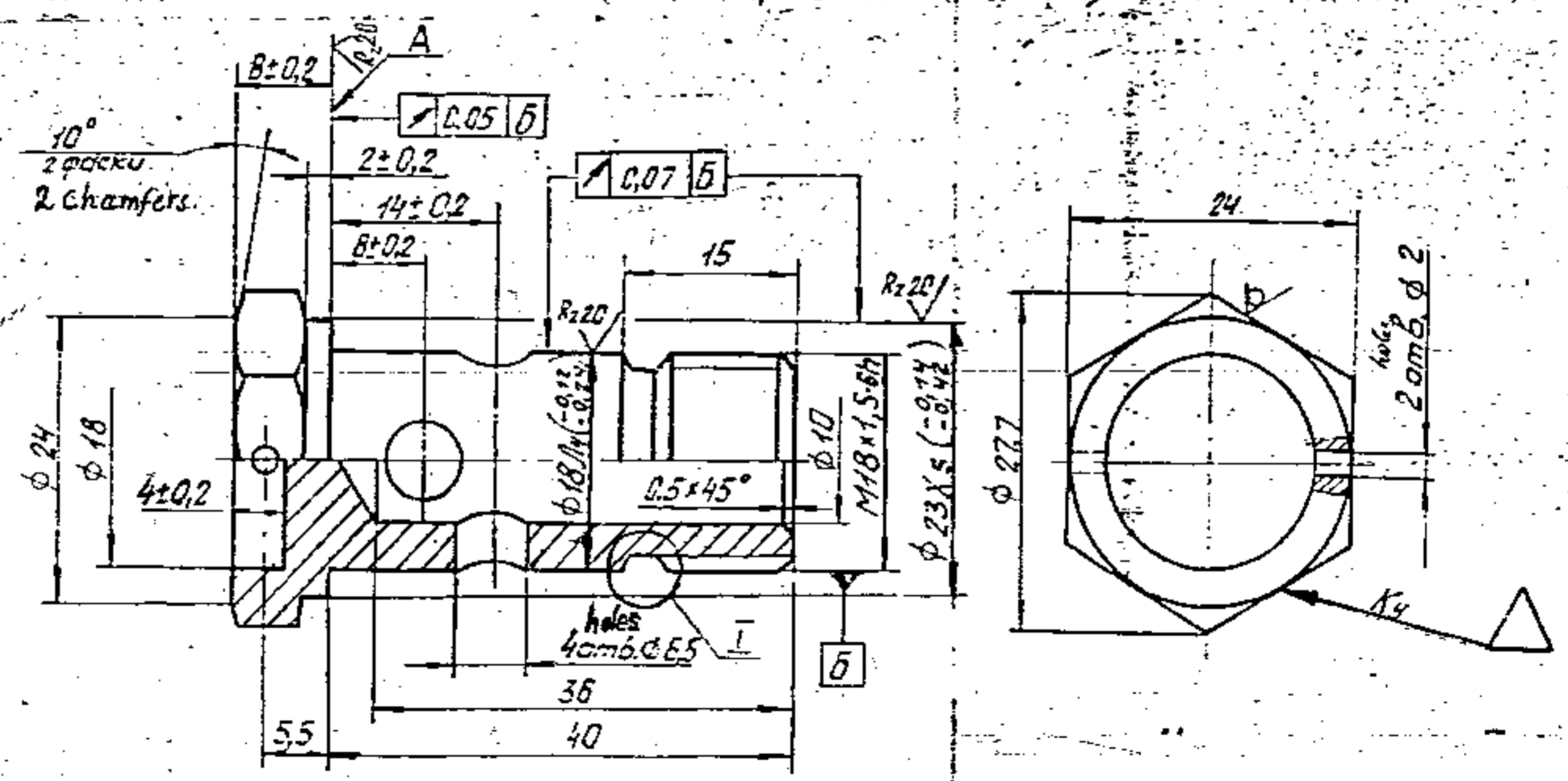
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	TCO	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69	ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
				28-5-86	1:1					329-29
MATERIAL: HEXAGON BAR 22.4 GOST 8560-74 45-6 GOST 1051-73					USED ON: CE 20-29-00-8 CE 3329 00 44		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI			
12-8-10 4th Alt. Comm. Meeting Minutes Point No.11 Dt: 26-10-09					TITLE: CLAMPING NUT					
06.4.88 AUTHY NOTN No BK 82-207										
06.4.88 AUTHY NOTN No. BK 85-141										
06.4.88 AUTHY NOTN NO BK 84-676										
15-2-88 AUTHY. NOTN. NO. BK 91-1406										
ISSUE	DATE	NATURE OF AMENDMENTS								

SIZE A2



DRAWING NUMBER
20-27-112



EXPLANATORY NOTE:-

MATERIAL QUOTED: 24-5 GOST 8560-78
45 GOST 1050-74.

BRIGHT STEEL-HEX. FROM GRADE 45 STEEL
ACROSS FLATS 24mm, ACCURACY CLASS 5.

CHEMICAL COMPOSITION %

- CARBON = 0.42-0.50
 - SILICON = 0.17-0.37
 - MANGANESE = 0.50-0.80
 - CHROMIUM = 0.25
 - PHOSPHORUS = 0.035
 - SULPHUR = 0.040
 - COPPER = 0.25
 - NICKEL = 0.25
- } MAXIMUM

MECHANICAL PROPERTIES:

- TENSILE STRENGTH $Kgf/mm^2 = 61$ (MIN)
- YIELD POINT $Kgf/mm^2 = 36$ (MIN)
- % ELONGATION = 16 (MIN)
- % REDUCTION IN AREA = 40 (MIN)
- IMPACT STRENGTH $Kgf/cm^2 = 5$

1. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:

- FOR HOLES : AS PER A7
 - FOR SHAFTS - AS PER B7
 - FOR OTHERS - AS PER CM7
- 2. DISPLACEMENT OF HEAD AXIS WITH RESPECT TO THREAD AXIS SHOULD NOT EXCEED 0.5mm.**
- 3. CRACKS, BURRS, NOTCHES DENTS AND OTHER MECHANICAL DAMAGES ARE NOT ALLOWED.**
- 4. THREAD SHOULD BE CLEAN AND FREE FROM BURRS, STRIPPING AND DENTS.**
- 5. WHEN FACING BUTT END A SINGLE POINT TOOL MAY CUT ALONG THE CYLINDRICAL SURFACE TO A DEPTH AS NOT MORE THAN 0.3mm.**
- 6. COATING :- CADMIUM-PLATED 9 MICRONS THICK, OILED INTERNAL SURFACES MAY HAVE NO COATING.**
- 7. THREAD MAY BE CHECKED BEFORE APPLYING COATING.**
- 8. PERMITTED IS EDGE ROUNDING TO A DIAMETER OF 27mm.**
- 9. Alt. Mat. IS STEEL 40, 50 GOST 1050-74.**

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

EST. WT. 0.062 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.	

(12A) EQUIVALENT MATERIAL
STEEL 080 M40 (EN8) TO BS: 970 OR
45 CB TO IS: 1570

DRN	CHK	MATERIAL :- 24-5 GOST 8560-78 45 GOST 1050-74	USED ON :- c82a-29-00-8 CB 20-27-00-4
CHD	not		
TCD	not		
APPD	not	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	17-3-90	AYADI	
SCALE	2:1		
DIMENSIONS IN mm.			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69		TITLE CONNECTOR	
12A	10-7-10	4th ALT. COMM. MTD. MINUTES POINT No. 7 DT. 26-10-09	
12		1289-01	
ISSUE	DATE	NATURE OF AMENDMENTS	D S CAT NUMBER DRAWING NUMBER 20-27-112

EXPLANATORY NOTE ADDED ON 20-7-92

KVD No. 63431





DRAWING NUMBER
20-29-09-9

EXPLANATORY NOTE:-

MATERIAL QUOTED:- A1 GOST 4784-74.

A1 = GRADE OF ALUMINIUM ALLOY.

CHEMICAL COMPOSITION:- %

Al = BASE CONSTITUENT.

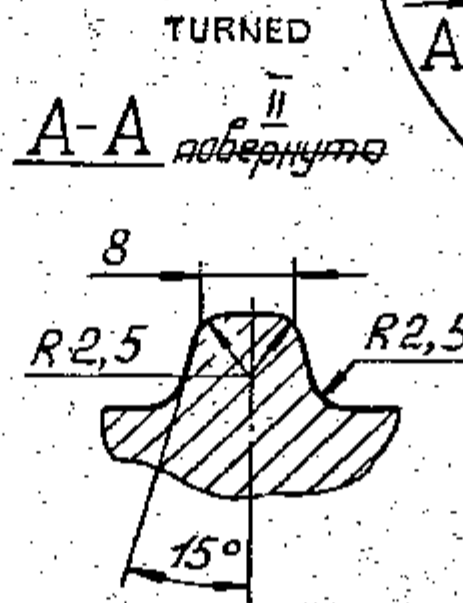
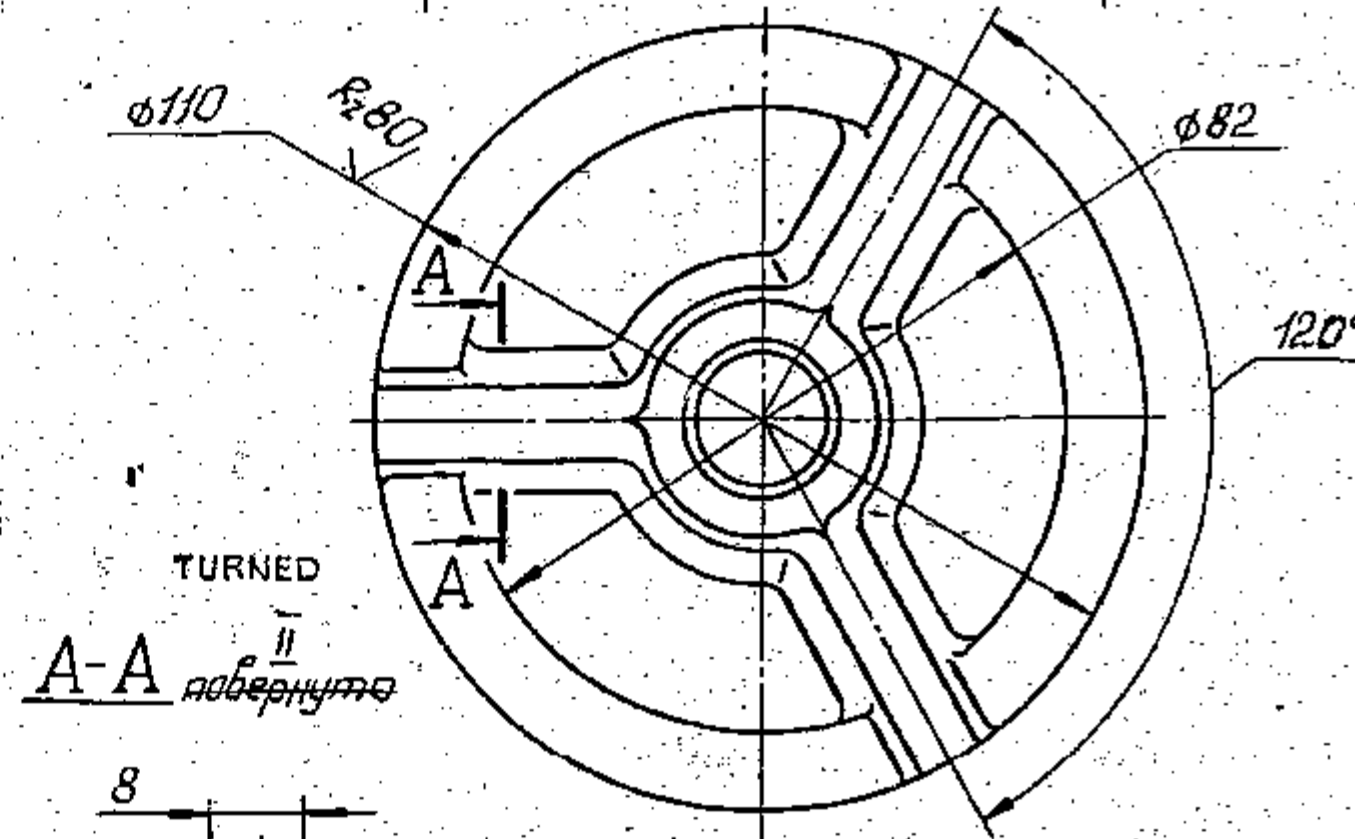
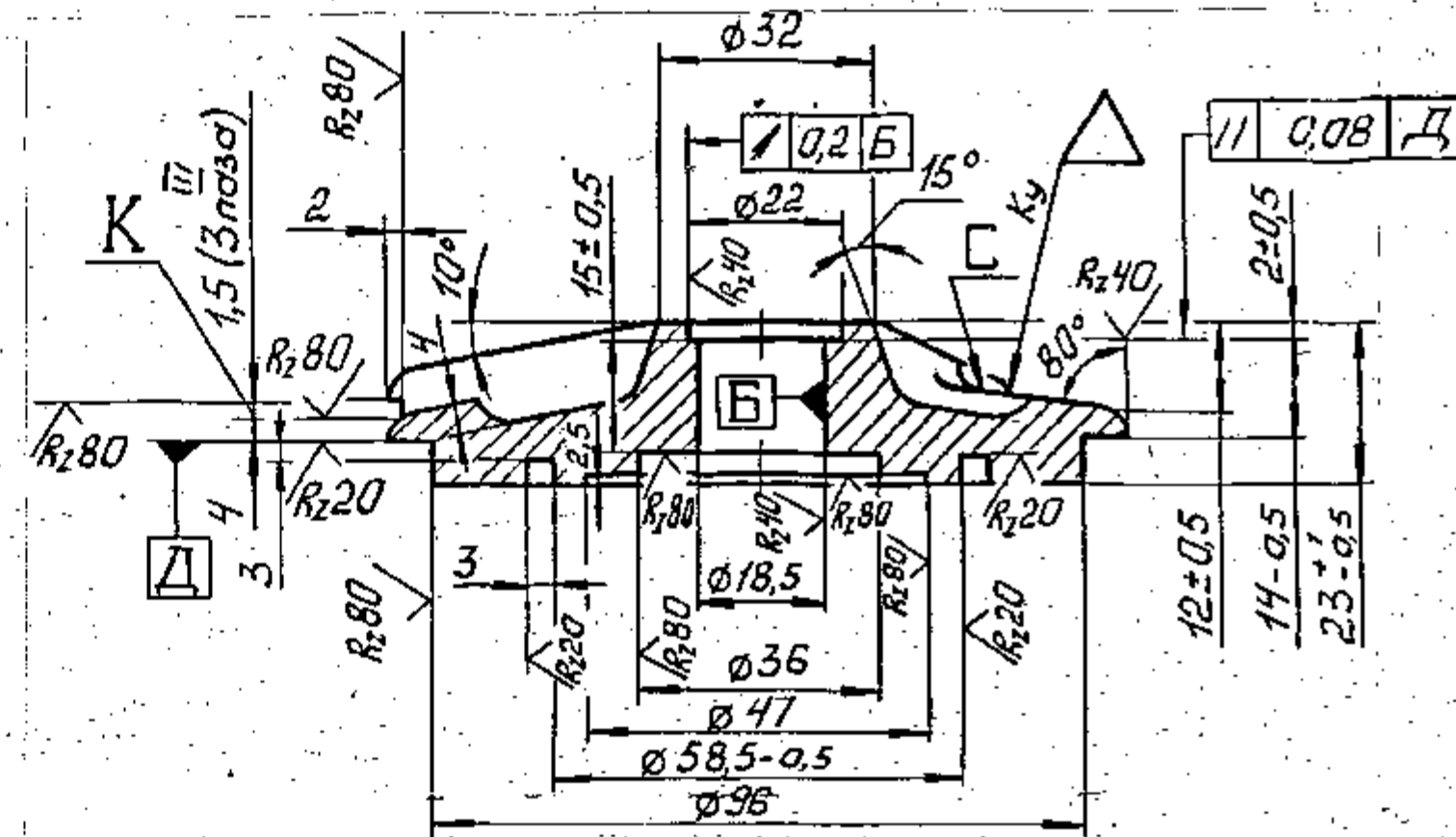
Cu = 3.8-4.8; Mg = 0.4-0.8; Mn = 0.4-0.8;

IMPURITIES (MAX) %

Fe = 0.7, Si = 0.7, Ni = 0.1, Zn = 0.3, Ti = 0.1,

OTHER IMPURITIES EACH INDIVIDUALLY = 0.05.

TOTAL = 0.1.



NOTE:-

- CONTROL GROUP IS OCC. TO TT-11.
HB ≥ 90
- NON-INDICATED LIMIT DEVIATIONS OF DIMENSIONS ARE: H14, h14, $\pm \frac{IT14}{2}$
- REQUIREMENTS TO STAMPING acc. TO CTN 264-77.
- TRACE FROM K GROOVE TREATMENT IS ALLOWED ON C SURFACE.

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

EST. WT. 0.33 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.

DRN	CHO	TCD	APPD.	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	ALL THREADS TO CONFORM TO
				23-9-86	1:1			
MATERIAL - A1 GOST 4784-74					USED ON C.6 20-29-00-8			
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)					A V A D I			
TITLE: FILTER COVER							D'S CAT NUMBER	
DRAWING NUMBER 20-29-09-9							ISSUE DATE NATURE OF AMENDMENTS	

AUTHY. NOTN. NO. 010-86

EXPLANATORY NOTE ADDED ON 20-3-92

(V)

SIZE A2



DRAWING NUMBER
20-29-18

R2401
(V)

EXPLANATORY NOTE:

6. MATERIAL QUOTED: 35 GOST 1050-74.
ALTERNATE MATERIAL QUOTED:- 30 AND 40 GOST 1050-74.

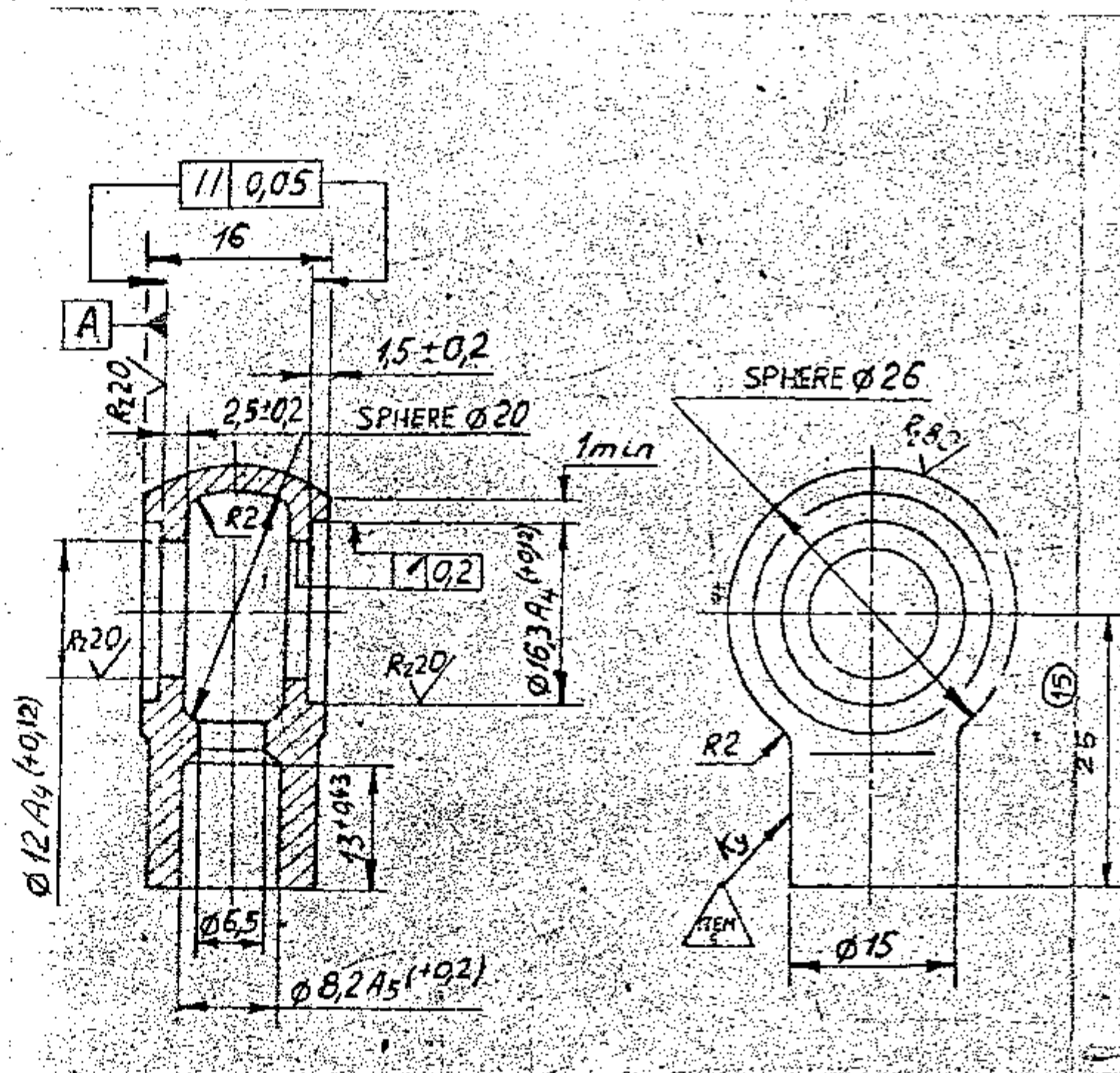
30, 35 & 40 = GRADES OF STEEL.

CHEMICAL COMPOSITION:-

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C	Si	Mn	Cr	P	S	Cu	Ni
	MAXIMUM.							
30	0.27-0.35	0.17-0.37	0.50-0.80	0.25	0.035	0.040	0.25	0.25
35	0.32-0.40	0.17-0.37	0.50-0.80	0.25	0.035	0.040	0.25	0.25
40	0.37-0.45	0.17-0.37	0.50-0.80	0.25	0.035	0.040	0.25	0.25

MECHANICAL PROPERTIES:-

GRADE OF STEEL	TENSILE STRENGTH	YIELD POINT	ELONGATION	REDUCTION	IMPACT
	Kgf/mm ²	Kgf/mm ²	%	IN AREA %	STRENGTH Kgf.m/cm ²
	MINIMUM				
30	50	30	21	50	8
35	54	32	20	45	7
40	58	34	19	45	6



- ALTERNATE MATERIAL IS STEEL 30, 40 AS PER GOST 1050-74.
- UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:
FOR HOLES - AS PER A7,
SHAFTS - AS PER B7,
OTHERS - AS PER CM7.
- TOTAL TOLERANCE FOR ALIGNMENT AND INTERSECTION OF THE AXIS OF CYLINDRICAL SHANK WITH RESPECT TO THE AXIS OF PLANES A IS 0.3mm ALONG THE LENGTH OF THE CYLINDRICAL PORTION.
- THE PARTS WHICH ARE MEANT FOR SPARE PARTS ARE CADMIUM-PLATED, 9 MICRONS, OILED.
ABSENCE OF COATING ON THE INTERNAL SURFACES IS PERMITTED.
- STAMPING ON THE TAG (PART 540-551) FOR BATCH OF PARTS AND SEALING ARE ALLOWED.

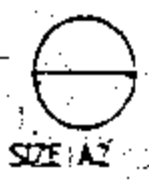
(15A) ALTERNATE MATERIAL: STEEL 080M40 (EN 8)
TOBS: 970-PL-I-1983 OR 35 C4 TO 15 1570

- S6 20-29-00-8
- ** S6 20-20-00-10
- S6 20-20-03-7
- S6 20-27-17-5
- S6 20-22-03-7
- S6 20-35-10-12

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

EST. WT. 0.040 kg
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.

DRN	APPROVED	MATERIAL :-	USED ON :-
CD		35 GOST 1050-74	**
TD		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
APPO		A V A D I	
DATE	6-3-87	TITLE	
SCALE	2:1	SWIVEL ELBOW	
DIMENSIONS IN mm		D S CAT NUMBER	
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69		DRAWING NUMBER	
15A	9-6-09	20-29-18	
15	25-7-89		
ISSUE	DATE	NATURE OF AMENDMENTS	

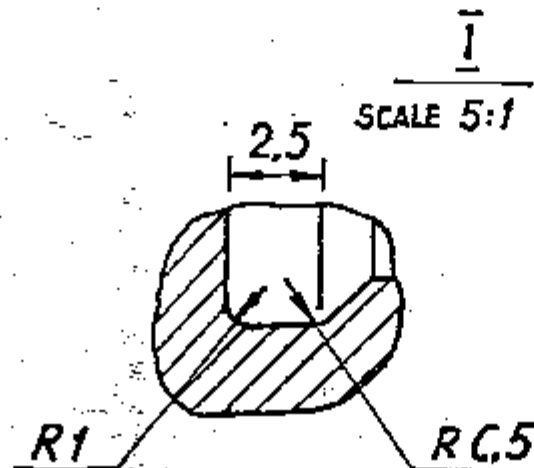
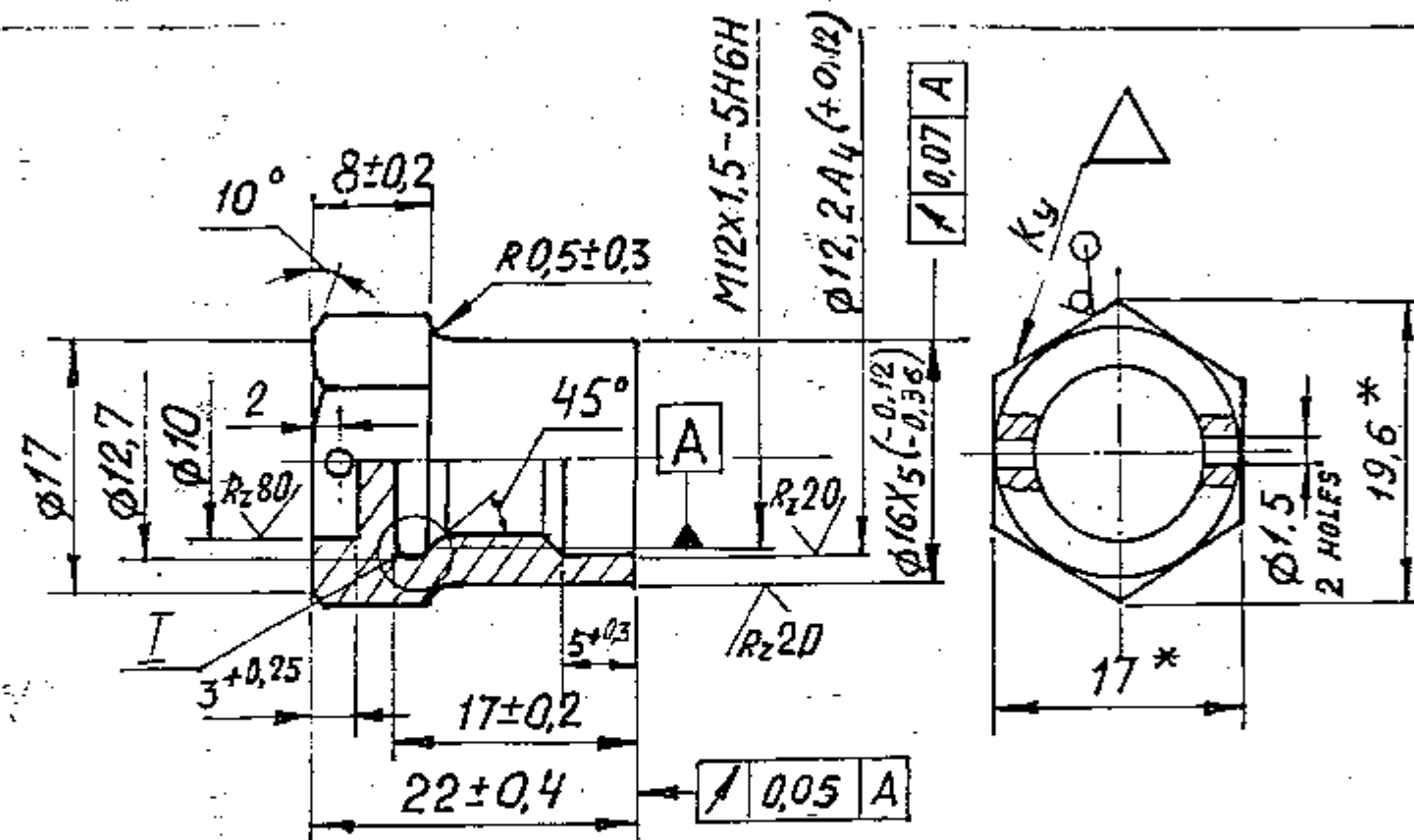




DRAWING NUMBER

20-29-21-1

Rz 40 ✓/✓



- Alt Matl IS STEEL 40, 50 GOST 1050-74.
- UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:
FOR HOLES - AS PER A7
FOR SHAFTS - AS PER B7
FOR OTHERS - AS PER CM7
- ROUNDING OF FACES UP TO ϕ 19mm IS PERMITTED.
- COATING: CADMIUM-PLATED 9 MICRONS THICK OILED
ABSENCE OF THE COATING ON THE INTERNAL SURFACES IS PERMITTED.
- * DIMENSIONS ARE GIVEN FOR REFERENCE.

EXPLANATORY NOTE :-

Ref. Matl. Quoted: BRIGHT STEEL HEX BAR CLASS OF ACCURACY 5 (A/F 17) TO GOST 8560-78 AND MATERIAL SPECN GOST 1050-74 GRADE 45.

ALT Matl Quoted: STEEL GRADE 40, 50, GOST 1050-74.

(a) CHEMICAL COMPOSITION :

GRADE OF STEEL	CONTENT OF ELEMENTS %						REMARKS	
	C	Si	Mn	Cr	NI	S		P
M A X I M U M								
40	0.37,0.45	0.17,0.37	0.50,0.80	0.25	0.25	0.04	0.035	Alt Matl
45	0.42,0.50	0.17,0.37	0.50,0.80	0.25	0.25	0.04	0.035	---
50	0.47,0.55	0.17,0.37	0.50,0.80	0.25	0.25	0.04	0.035	Alt Matl

(b) MECHANICAL PROPERTIES :

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/cm ²	% ELONGATION	REDUCTION OF AREA %	IMPACT STRENGTH Kgm/cm ²	HARDNESS B H N (MAX)	REMARKS
40	58	19	45	6	241	Alt Matl
45	61	16	40	5	241	---
50	64	14	40	4	255	Alt Matl

Ⓐ EQUIVALENT MATERIAL STEEL:
45C8 TO IS:1570

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

EST. WT. 0.019 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.

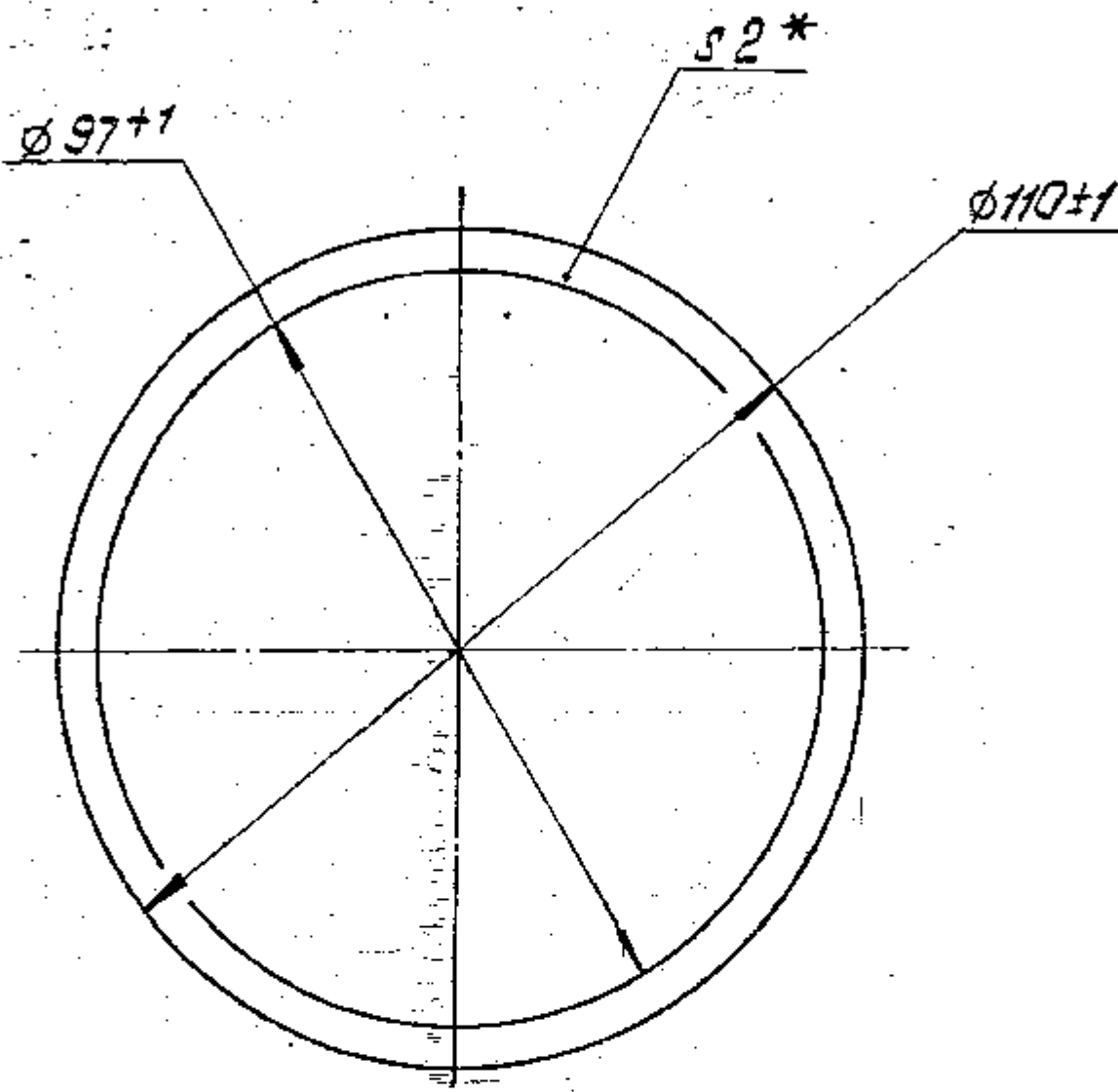
DRN	CHKD	MATERIAL	USED ON
TCO	APPO	17-5 GOST 8560-78	C8 20-29-00-8
DATE	DATE	45 GOST 1050-74	C8 20-27-00-4
SCALE :- 2 : 1	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)		
DIMENSIONS IN mm.	A V A D I		
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	TITLE		
ALL THREADS TO CONFORM TO	NUT M12		
ISSUE	DATE	D S CAT NUMBER	DRAWING NUMBER
			20-29-21-1

KVD No: 63356

SIZE-A2



DRAWING NUMBER
20--29-28-1



EXPLANATORY NOTE:-

MATERIAL QUOTED:- BP-1 Ty 38-11463-78.

BP-1 - GRADE OF GASKET MATERIAL.

PHYSIO-CHEMICAL PROPERTIES:-

1. DENSITY (g/cm³) = 1.8 - 2.2
2. ULTIMATE BREAKING STRENGTH (kgf/cm²)
 - (i) IN LONGITUDINAL DIRECTION = 100 (MIN)
 - (ii) IN TRANSVERSE DIRECTION = 45 (MIN)
3. SWELLING IN KEROSENE % (MAX) FOR GASKET = 2.0
4. CHANGE IN WEIGHT AFTER THE EFFECT OF OIL "MS" %
 - = FROM -2.0
 - TO +2.0
5. TOTAL SHRINKAGE UNDER COMPRESSION
 - PRESSURE 250 kgf/cm² % = 20-38
6. ELASTIC SHRINKAGE UNDER COMPRESSION
 - PRESSURE 250 kgf/cm², % = 12-35

1. DIMENSIONS EXCEPT FOR THAT MARKED WITH ASTERISK (*) ARE PROVIDED WITH TOOLS.

2. OTHER REQUIREMENTS ARE AS PER TECHNICAL SPECIFICATIONS TY-38. 11463-78.

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

EST. WT. 0.085 Kg 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 OUT SIDE INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

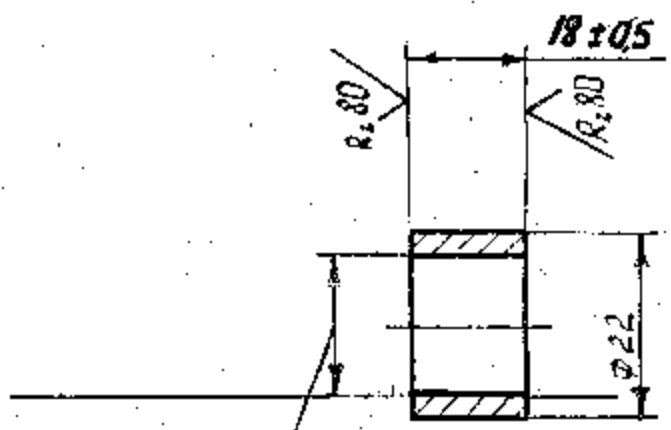
DRN	<i>Chopra</i>	MATERIAL:-	USED ON
CHK	<i>W. S.</i>	6p-1 TY 38. 11463-78	SB 20-29-00-8
TED	<i>M. P.</i>		
APPD	<i>W. S.</i>		
DATE	17-3-96	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE	1:1	AVAD	
DIMENSIONS IN mm		TITLE	GASKET
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69			
ALL THREADS TO CONFORM TO		D S (A) NUMBER	DRAWING NUMBER
ISSUE DATE			20-29-28-1
NATURE OF AMENDMENTS			



20-40-141



136. N 1437-78



Сверлить до $\phi 18.5$
DRILL TO 18.5 DIA.

1. COATING OF MAKE $\gamma.349 \cdot xp$.
2. COATING OF MAKE T: K ϕ 9. xp. WITH NEXT ELIMINATION OF HYDROGEN EMBRITTLEMENT.
3. IT IS ALLOWED MAKING FROM PIPE ACCORDING TO GOST 10704-76.
4. COATING ABSENCE IS ALLOWED ON INNER SURFACE.

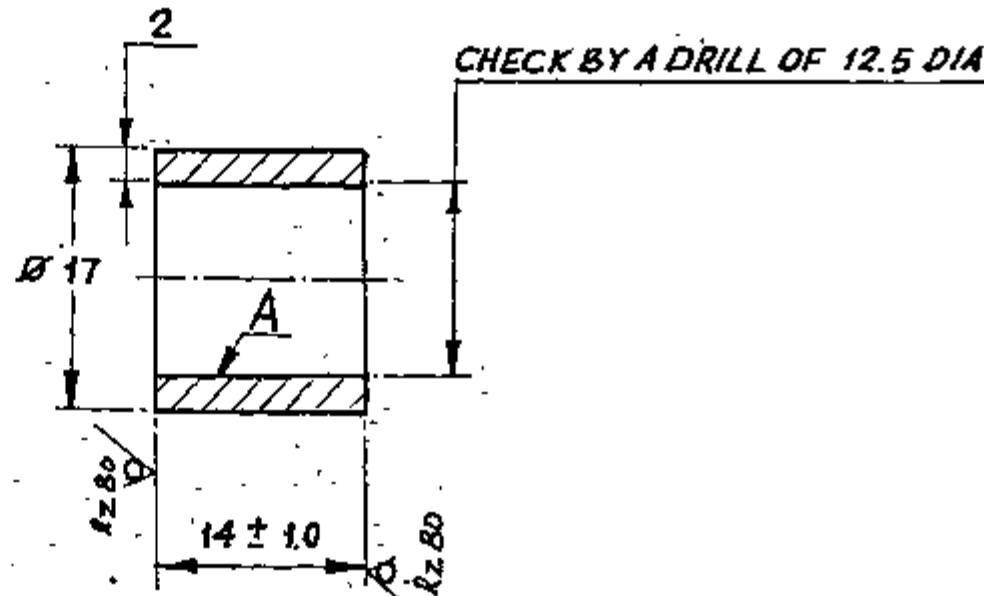
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

* 22 X 2 GOST 8734-75
20 GOST 8733-74

			EST. MASS 0.010 Kg	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 * SEE ABOVE	USED ON:- 1. CB 20-29-00-7 2. CB 20-27-00-6
DRN		SCALE - 1:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD	
CHD		DIMENSIONS IN mm.	TITLE:- PROTECTION SLEEVE	
TEO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	
APPD		ALL THREADS CONFORM TO	DRAWING NUMBER 20 - 40 - 141	
DATE	25.9.86			



DRAWING NUMBER
20-40-142



1. COATING OF MAKE Y. 3. 4. 9. xp
2. COATING OF MAKE T: K 29 xp WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
3. SCALE IS NOT ALLOWED ON 'A' SURFACE.
4. IT IS ALLOWED TO MANUFACTURE FROM BAR.
5. IT IS ALLOWED TO MANUFACTURE FROM PIPE OF 18 mm DIA, ACCORDING TO GOST 10704-76
6. COATING ABSENCE IS ALLOWED ON THE INNER SURFACE.

EXPLANATORY NOTE:

MATERIAL QUOTED: $\frac{17 \times 2 \text{ GOST } 8734-75}{10 \text{ GOST } 8733-74}$

17 = OUTER DIAMETER ; 2 = THICKNESS ;
10 = GRADE OF MATERIAL AS PER GOST 1050-74 (SEAMLESS STEEL TUBE COLD AND DEFORMED)

CHEMICAL COMPOSITION %

CARBON = 0.7-0.14
SILICON = 0.17-0.37
MANGANESE = 0.35-0.65
CHROMIUM = 0.15
COPPER = 0.25
NICKEL = 0.25
SULPHUR = 0.040
PHOSPHORUS = 0.035

} MAXIMUM

MECHANICAL PROPERTIES (AS PER GOST 8733-74)

ULTIMATE TENSILE STRENGTH $\text{Kgf/mm}^2 = 35 \text{ (MIN)}$
YIELD POINT $\text{Kgf/mm}^2 = 21 \text{ (MIN)}$
ELONGATION % = 24 (MIN)

EXPLANATORY NOTE ADDED ON 18-6-92

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

EST. WT. 0.015 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.

DRN		MATERIAL:-	USED ON
CHD		17x2 GOST 8734-75	CB 20-29-00-7
TCD		10 GOST 8733-74	CB 20-27-00-4
APPD		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	25-9-88	AVADI.	
SCALE:-	2:1	TITLE	
DIMENSIONS IN mm		PROTECTION SLEEVE	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102-69.		D S CAT NUMBER	
ALL THREADS TO CONFORM TO		DRAWING NUMBER	
		20-40-142	
ISSUE	DATE	NATURE OF AMENDMENTS	

SIZE A3

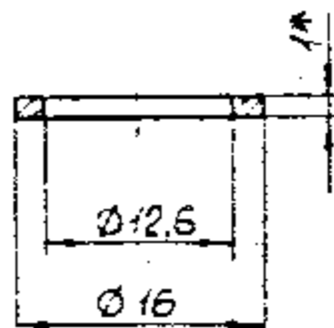


1950

1950

DRAWING NUMBER

20-55-066



1. Alt. Matl. IS STRIP OF A А, П, М-1, GOST 13726-78.
2. REQUIREMENTS PLACED UPON STAMPING ARE AS PER STANDARD 82050-16.
3. MINUTE DENTS AND STAMPING TOOLS TRACES ARE ALLOWED, IF THEY DO NOT EXCEED 1/2 OF THE PERMISSIBLE DEVIATIONS OF DIMENSIONS.
4. * DIMENSION IS GIVEN FOR REFERENCE.

**
 C6 20-06-002
 C6 20-20-0010
 C6 20-27-004
 C6 20-29-007
 CQA(HV)5.06.607E(B)

(A) ALTERNATE MATERIAL: 19000 TO IS 737

KVD No. 63645

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

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

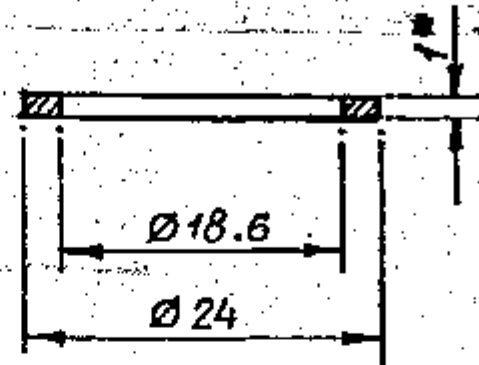
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

GRV	Y. K. K.	MATERIAL	A, П, М-1 GOST 21631-76	USED ON	** SEE ABOVE
APPD		DATE	17-3-90	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES)	
SCALE	2:1	AVAD			
DIMENSIONS IN mm		TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 2102-69		TITLE	
				SEALING RING	
ISSUE		DATE		NATURE OF AMENDMENTS	
B		15.7.15		Pt. 11 of 7th Alt. Comm. Meeting Dt. 11-4-12	
A		9-6-09		3 rd ALTN. COMM. MINUTES POINT 7 DATE 27-2-09	
D S		CAT NUMBER		DRAWING NUMBER	
				20-55-066	





DRAWING NUMBER
20-55-085



1. Alternate material is strip A Д1М-1, GOST 13726-78.
2. Requirements placed upon stamping are as per standard 82050-16.
3. Minute dents and stamping tools traces are allowed, if they do not exceed 1/2 of the permissible deviations of dimensions.
4. * Dimension is given for reference.

Ⓐ ALTERNATE MATERIAL : 19000 TO IS 737

PLOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION		DRN	<i>S. N. V. 3/4</i>	MATERIAL :- AA1M-1	USED ON
EST. WT.	TO BE STAMPED OR MARKED WHERE INDICATED THIS ≡ LETTERS	CHD	<i>24</i>	GOST 21631-76	CS 20-01-02-9 CS 20-27-00-4 CS 20-29-00-7
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SEE INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		TCD	<i>10mm</i>	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES) AVAD!	
A		APPD	<i>[Signature]</i>	SCALE :- 2:1	
A		DATE	21-3-90	TITLE SEALING RING	
A		SCALE :-	2:1	D S CAT NUMBER	
A		DIMENSIONS IN	mm	DRAWING NUMBER	
A		TOLERANCE ON DIMS	UNLESS OTHERWISE STATED IS 2102-69	20-55-085	
A		ALL THREADS TO CONFORM TO			
A		ISSUE DATE	9-6-09		
A		NATURE OF AMENDMENTS	3 rd ALTN. COMM. MINUTES POINT 7 DATE 27-2-09		



SIZE A3

