

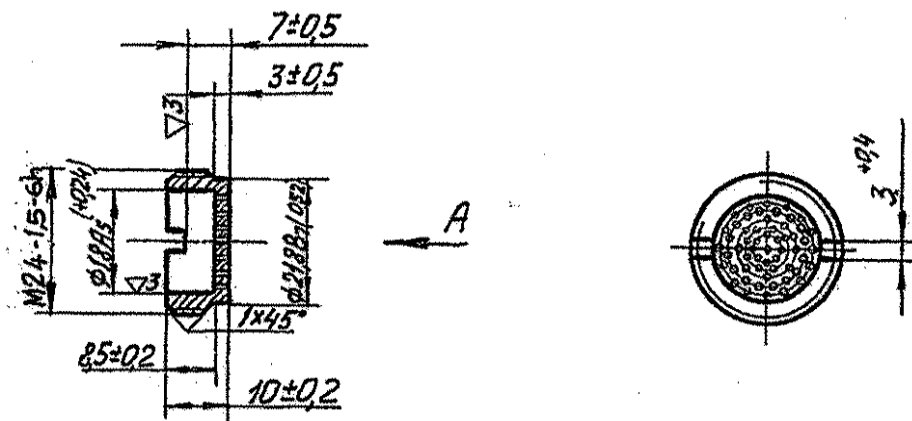
(B. JAYAVELU), JTO (ID)
 01-08-06

"COMMON TO T-90"
 DRG RE-INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 4

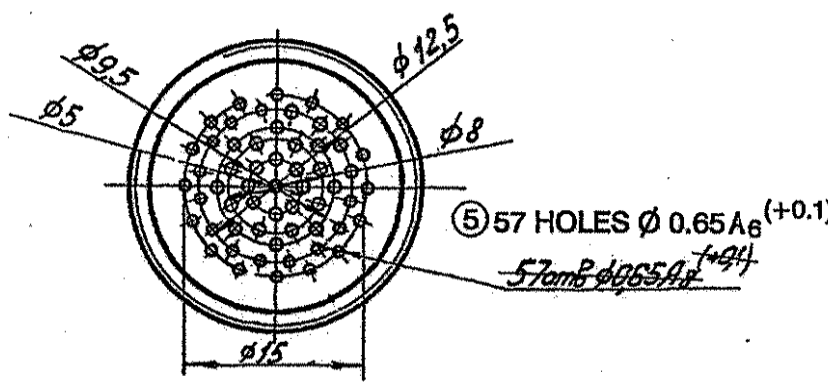
DRAWING NUMBER
172.45.284

SHEET No 1 OF 1

▽4 (▽)



VIEW - A
 SCALE 2:1



1. COMPONENT MAY BE MANUFACTURED FROM BRASS JI - 63, GOST 15527 - 70.
2. SHIFT OF AXIS OF HOLE $\phi 18$ RELATIVE TO THREAD M 24 x 1.5 SHOULD NOT EXCEED 0.5 mm.
3. TOOL MARKS ARE PERMITTED ON SURFACE $\phi 21.8$
4. RELATIVE POSITION OF HOLES $\phi 0.65$ NOT TO BE CHECKED. THE HOLES ARE TO BE COUNTERSUNK ON BOTH SIDES. DEPTH OF COUNTERSUNKING NOT TO BE CHECKED
5. THE COMPONENT DIFFERS FROM COMPONENT 155.38.246 IN THE NUMBER OF HOLES $\phi 0.65$
- ⑤ 6. IT IS ALLOWED TO REDUCE DIAMETER OF 57 HOLES $\phi 0.65$ UPTO 0.59 mm.

EXPLANATORY NOTE :-

7. a) REFERENCE MATERIAL QUOTED :- BRASS JIC 59 - 1 GOST 15527 - 70
 BRASS GRADE JIC 59 - 1 AND REFERENCE NOTE 1 ON ALTERNATIVE MATERIAL BRASS GRADE JI63, GOST 15527 - 70
- b) CHEMICAL COMPOSITION AS PER BRASS GRADES JI59 - 1 AND JI63 TO GOST 15527 - 70

GRADE OF BRASS	CONTENT OF % ELEMENTS			ADMIXTURES % (MAXIMUM)						
	Cu	Pb	Zn	Pb	Fe	Sb	Bi	P	Sn	TOTAL
JIC 59-1	57.0 60.0	0.8 1.5	REMAINING	-	0.5	0.010	0.003	0.02	0.30	0.75
JI 63	62.0 65.0	-	REMAINING	0.07	0.2	0.005	0.002	0.01	-	0.5

⑤C ALT. MATL :- BRASS TO IS : 531 - 81 / Cu Zn 39 Pb HALF HARD ⑤B 188.45.001cb-3Cb

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

EST. WT. (Kg) 0.03 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.

ISSUE	DATE	NATURE OF AMENDMENTS
5C	07.07.06	AUTHY. Lt. No. 80001/CQA(HV)/GEN/DL15.10.05
5B	25.10.04	N OF A No. CQA(HV)/T90/45/001
5A	12.7.04	N OF A No. CQA(HV)/T90/66/001
5	28.11.88	AMDT. LIST No. 6 / II, BOOK - 7.

DRN	Sd/=
CHD	Sd/=
APPD	Sd/=
DATE	22 - 02 - 92
SCALE:-	1 : 1
DIMENSIONS IN mm	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69	
ALL THREADS TO CONFORM TO IS : 4218 Pt. IV	

MATERIAL :- BRASS JIC 59 - 1 GOST 15527 - 70	USED ON :- 172.2M.66cbCb 172.45.060cbCb 188.66cb-3Cb (5A)
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
TITLE :- FILTER	
D S CAT NUMBER	DRAWING NUMBER 172.45.284

F - 86
 SIZE A3