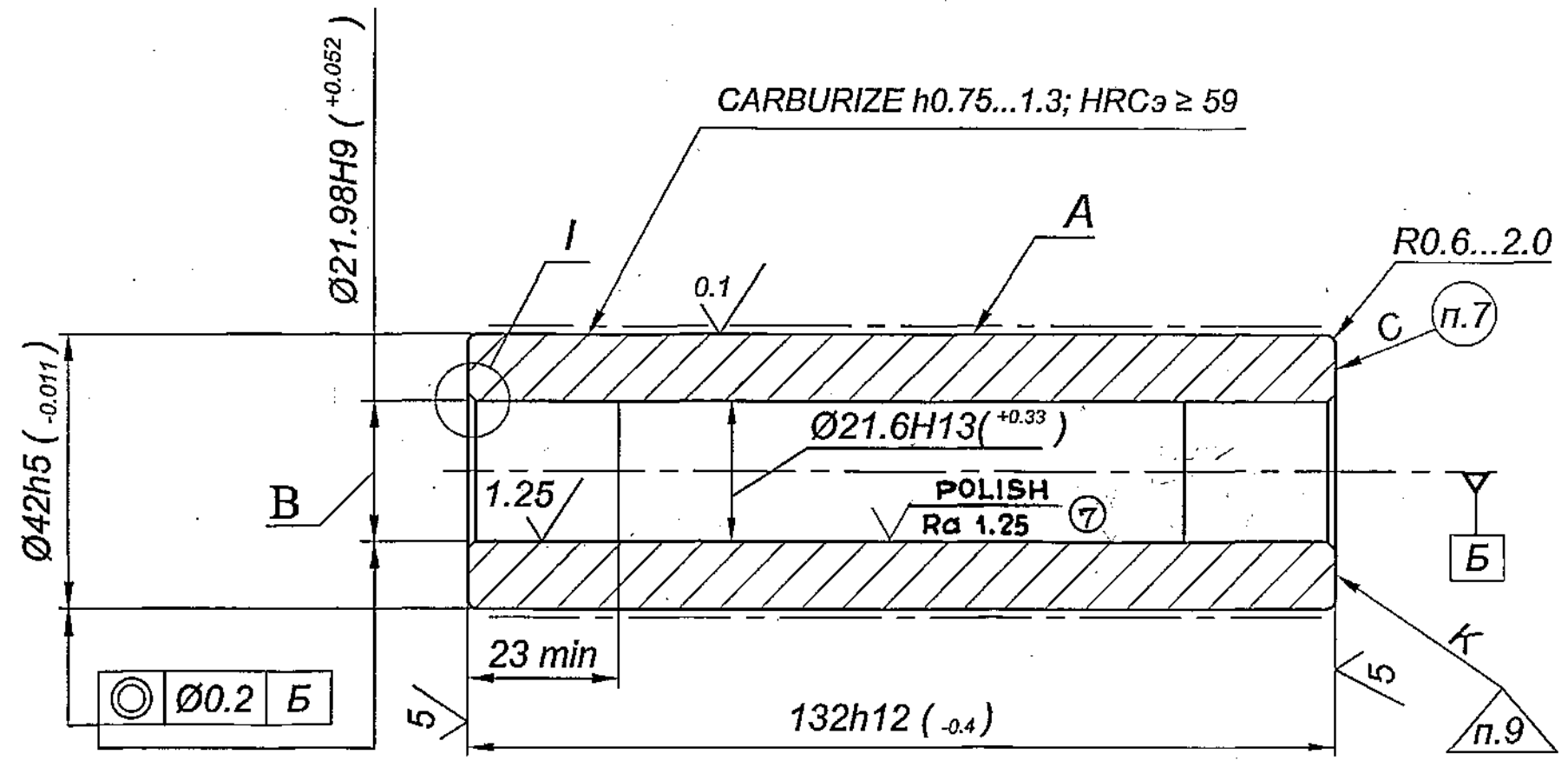


DRAWING NUMBER  
**304-10-5**

SHEET No. 1 OF 1

2.5 (✓)

I  
M 10:1



B	GROUP NO:
21.98 <sup>+0.052</sup> / <sub>+0.034</sub>	1
21.98 <sup>+0.034</sup> / <sub>+0.017</sub>	2
21.98 <sup>+0.017</sup>	3

1. Inspection group III as per TT-11.
2. 28...42 HRC<sub>э</sub>, except in places mentioned as important.
- ⑥ 3. Polish or superfinish the surface 'A' as per instruction И О Т Т - 29 - 77.
4. Allowance of ovality and taper of surface 'A' should be 0.003mm (semi-difference of dimensions), cuts - 0.002 mm.
- ⑥ 5. Notches and Dents are not allowed on surfaces of pin.
6. All components are to be checked by magnetic flaw detector and carry out the acceptance as per TT И Б - 17. Defects are not allowed.
7. To be marked group No.
8. The components which are intended for spare, are not to be marked group.
9. Stamp and mark by electro-chemical method or by engraving. Letter type П О - 2.5 as per GOST 2930-62 may be used.
10. \*Dimensions are ensured by tool.
- ⑥ 11. Machine surface A by diamond ironing/pressing method, use for presence of prime graduation line on master sample installed as per instruction И - О Г Т - 29 - 77.

⑦A EQUIVALENT MATERIAL  
EN 36B TO BS: 970 /  
13 Ni 13 Cr 3 TO IS: 4432-1988

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

EST. WT. (Kg) 1.04	TO BE STAMPED OR MARKED WHERE INDICATED THUS # ( LETTERS) F. 33
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	CHD	APPD	DATE	SCALE: 1:1	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69	ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
			02/2/09						304-10-5
				MATERIAL: STEEL 12XH3A TY 14-1-381-72		USED ON: CB 304-07-5		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
				TITLE: PISTON PIN					
				7A 15-7-10 4 1/2 ALT. COMM. MEETING MINUTES POINT No 9 DT 26-10-09		7 10-12-08 NOTN. No. 197-02 (F-158)		6 29.11.08 NOTN. No. 421-04 (F-158)	
				ISSUE		DATE		NATURE OF AMENDMENTS	

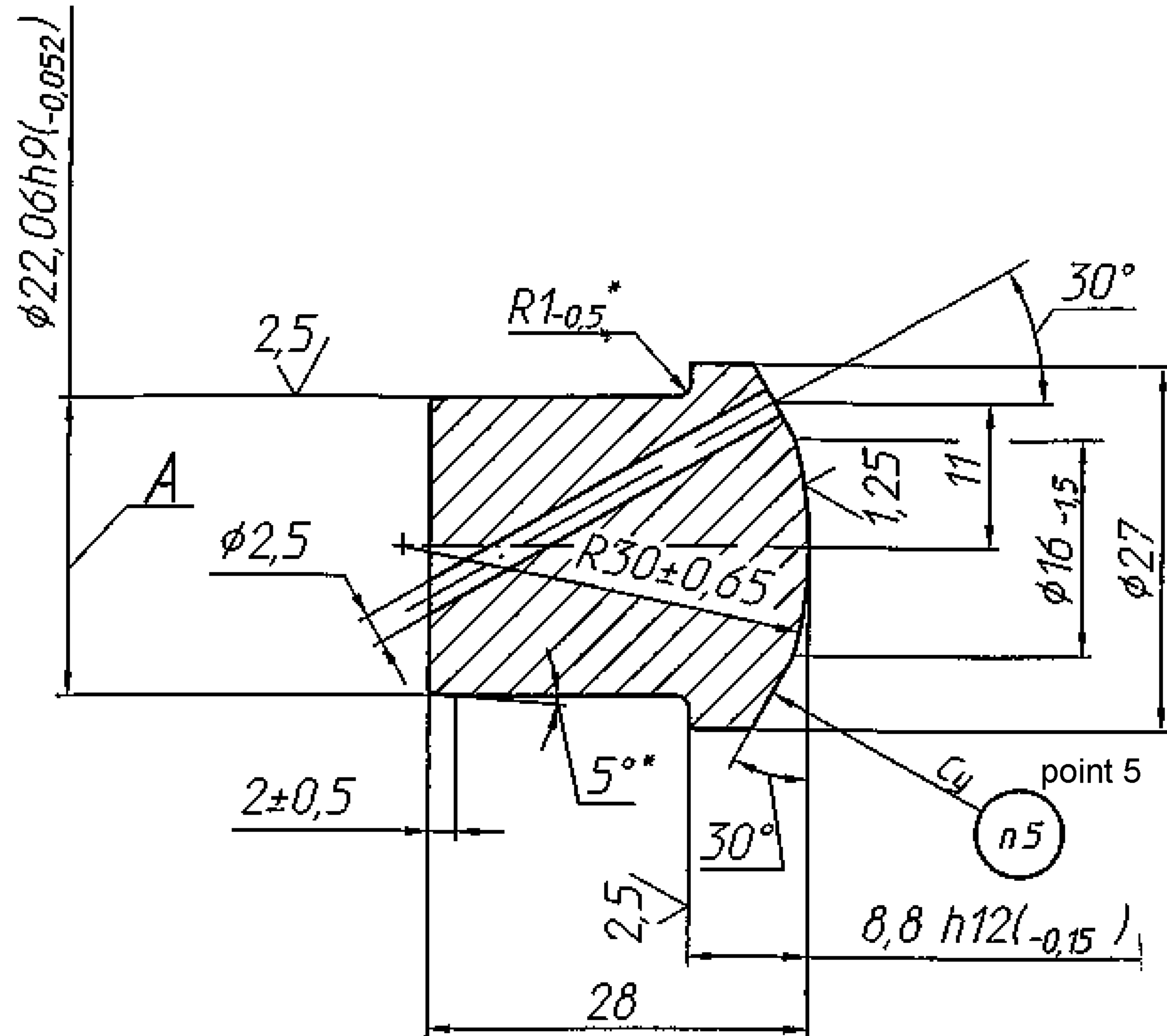
DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 5  
DRG. REPLACES 304-10-3 VIDE BK NO: 99-164

COMMON TO V-46-6

F-3  
46  
768  
SIZE A2

01-11-405

10  
✓ (✓)



- 1 Группа контроля IV по ТТ-11
- 2 Твердость ≥ 90 НВ
- 3 H14, h14,  $\pm \frac{IT_{14}}{2}$
- 4 \*Размеры обеспеч инстр
- 5 Маркировать № группы Шрифт 2,5-Пр3 ГОСТ 26 008-85
- 6 Клеймо окончательной приемки наносить на бирке для партии деталей
- 7 На деталях, отправляемых в запчасти, маркировку групп не производить

1. Inspection group IV as per technical requirements (ТТ) -11.
2. Hardness  $\geq 90$  HB.
3. H14, h14,  $\pm IT_{14}/2$ .
4. \* Dimensions are ensured by tool.  
Tolerance of ovality and conicity of surface A should be 0.003 mm (semi difference in diameters), cuts - 0.002 mm.
5. Mark groups No. Letter size 2.5 Пр3 GOST 26.008-85.
6. Put stamp of final acceptance on tag for batch of parts.
7. Parts, which are sent in spare parts, should not have marking groups.

№ подл. Подп. и дата  
 44385  
 Взам инд № Инд. № докум Подп. и дата

Group No

A, мм	№ группы
22,06 -0,017	1
22,06 $\begin{matrix} -0,017 \\ -0,034 \end{matrix}$	2
22,06 $\begin{matrix} -0,034 \\ -0,052 \end{matrix}$	3

PISTON PIN PLUG		304-11-10	
		Letter weight scale	
6 - 2000-183		Лит.	Масса
Изм. Лист № докум	Подп. Дата	0,029	21
Trans. & Ckd. by: M/s SWYAZ		Лист 1 / Листов 1	
Authenticated by:		Sheet 3 / Sheets 47	
Approved by:		Bar GOST 21488-76	
Engine Factory, Avadi		Формат А3	

Заглушка поршневого пальца

Bar GOST 21488-76

Формат А3