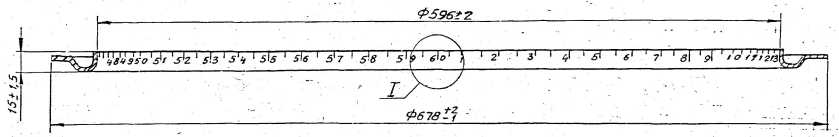
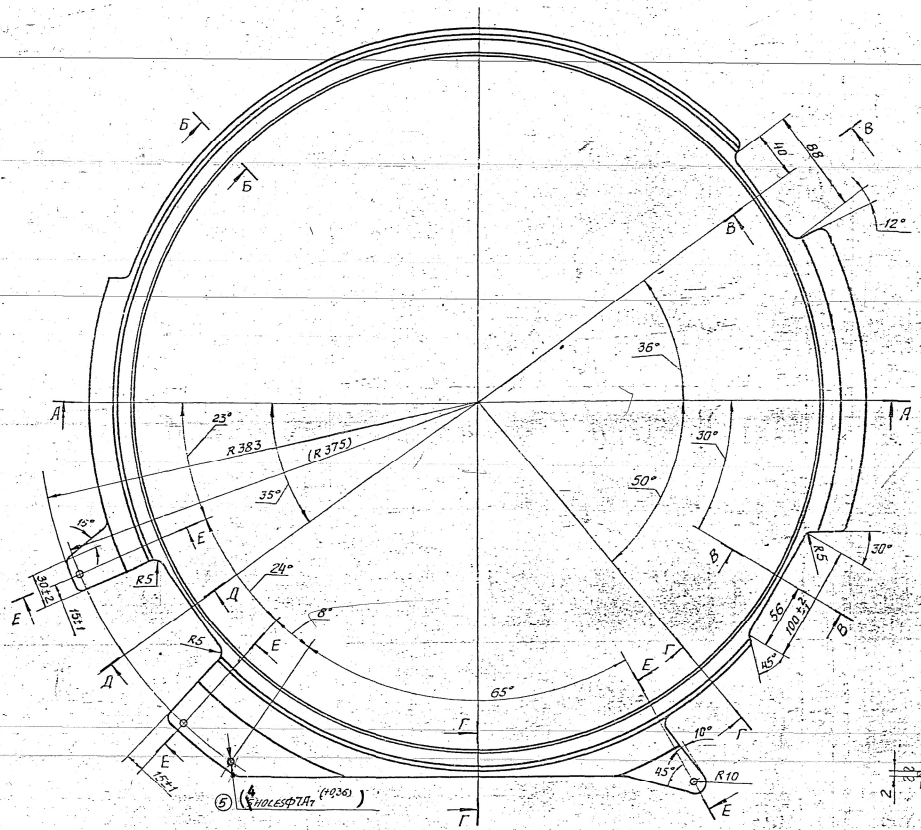
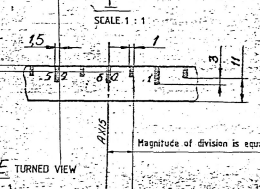
DRAWING NUMBER
172 11 074-1

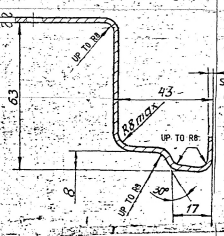
V1 (▽)







E-E TURNED VIEW
SCALE 1 : 1

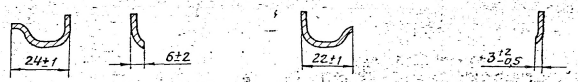


Б-Б TURNED VIEW
SCALE 1 : 1

В-В TURNED VIEW
SCALE 1 : 1

Г-Г TURNED VIEW
SCALE 1 : 1

Д-Д TURNED VIEW
SCALE 1 : 1



1. SURFACE RUPTURES, CRACKS AND BURRS ARE NOT ALLOWED.
2. THICKNESS AT PLACES OF BENDING AND PROFILE OF BULGES AFTER BENDING NOT TO BE CHECKED.
3. UNSPECIFIED RADII OF CUTS IN THE GUARD ARE TO BE 4 mm.
4. CIRCUMFERENCE Ø 596 IS TO BE DIVIDED TO 120 EQUAL DIVISIONS. DIGITS TO BE PUNCH MARKED WITH 5-6 mm HIGH TYPE DEPTH OF MARKS AND DIGITS SHOULD BE 0.3 mm MIN.
5. RAISED TRACES OF MARKS NOT EXCEEDING 0.5 mm IN HEIGHT ARE ALLOWED ON SURFACE, OPPOSITE TO LOCATION OF THE MARKS.
6. SHIFT OF MARKS FROM TRUE POSITION SHOULD NOT EXCEED 0.3 mm. THIS IS TO BE ENSURED BY STAMPING. IN ONE PLACE VARIATION OF PITCH OF TWO ADJACENT DIVISIONS MAY BE UP TO 1 mm.
7. MANUFACTURE FROM SHEETS АМГ 6М GOST 21631-76 IS ALLOWED.
8. BENDING CONTOUR OF COMPONENT IS TO BE CHECKED BY TEMPLATE, MADE TO NOMINAL DIMENSIONS. DEVIATION FROM THE TEMPLET UP TO 1.5 mm IS ALLOWED.
9. MARKS, SCORES AND TRACES FROM TOOL ON COMPONENT SURFACE ARE ALLOWED.
10. ABSENCE OF ROUNDING OFF RADII OF PROFILE CORNERS AND UNEVENNESS OF EDGES OF CUT IN SLOTS ARE ALLOWED WITHIN THE LIMITS OF TOLERANCE ON DIMENSIONS.
11. UNEVENNESS OF SHOULDER ALONG Ø 596 ± 2 SHOULD BE WITHIN THE TOLERANCE LIMITS.
12. THE DIMENSIONS IN BRACKETS MAY BE CARRIED OUT AS PER DRAWING 172.11.026 СБ-1
13. LOCAL SHIFT OF DIGITS (NOT MORE THAN 7) TO THE EDGE OF THE COMPONENT IS ALLOWED, BUT THE DIGITS MUST BE PRINTED IN FULL.

(Li) 14. EXPLANATORY NOTE:-

a) REFERENCE MATERIAL QUOTED:- SHEET АМГ 6БМ-2 GOST 21631-76 SHEET MADE FROM ALUMINIUM ALLOY OF GRADE АМГ 6 WITH TECHNOLOGICAL CLADDING (Б) AND ANNEALED CONDITION (М) NORMAL ACCURACY ON THICKNESS $2.0^{-0.15}$ GOST 21631-76.

b) REFERENCE NOTE 7 ON ALTERNATIVE MATERIAL:- SHEET АМГ6М GOST 21631-76 SHEET MADE FROM ALUMINIUM ALLOY OF GRADE АМГ6 ANNEALED CONDITION (М) OF NORMAL ACCURACY ON THICKNESS $2.0^{-0.15}$ GOST 21631-76.

CHEMICAL COMPOSITION OF GRADES АМГ6Б & АМГ6 AS PER GOST 21631-76

GRADE	ALLOY ELEMENTS		ADMIXTURES % MAXIMUM								
	Al	Zn	Fe	Si	Cu	Mn	Zn	Ti	Mg	OTHER ADMIXTURE EACH	TOTAL
АМГ6Б & АМГ6	89.30 MIN	—	0.30	0.30	0.02	0.025	0.1	0.15	0.05	0.02	0.70

MECHANICAL PROPERTIES OF GRADES АМГ6Б & АМГ6 AS PER GOST 21631-76

GRADE	TENSILE STRENGTH Kgf/mm²	YIELD POINT Kgf/mm²	ELONGATION %
	MINIMUM		
АМГ6Б & АМГ6	32.0	16.0	15.0

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

EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS ⊕ (LETTERS)
0.442 Kg	

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
5	20.8.90	Noin.172M.5521.88, A.L.11/Bk.1
Li	9-9-99	EXPLANATORY NOTE ADDED

DRN	[illegible]
CHD	[illegible]
TCD	[illegible]
APPD	[illegible]
DATE	14-12-67
SCALE - 1 : 2	
DIMENSIONS IN mm.	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69	
ALL THREADS TO CONFORM TO	

MATERIAL :- SHEET АМГ 6БМ-2 GOST 21631-76.

USED ON :- 172 11 026 Сб-1

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) A V A D I

TITLE: GUARD

D S CAT NUMBER

DRAWING NUMBER 172 11 074-1

DRAWING INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 4.

COMMON TO BLT

F-32 3

SIZE A1.