

DRAWING NUMBER
20-29-18

R2401
(V)

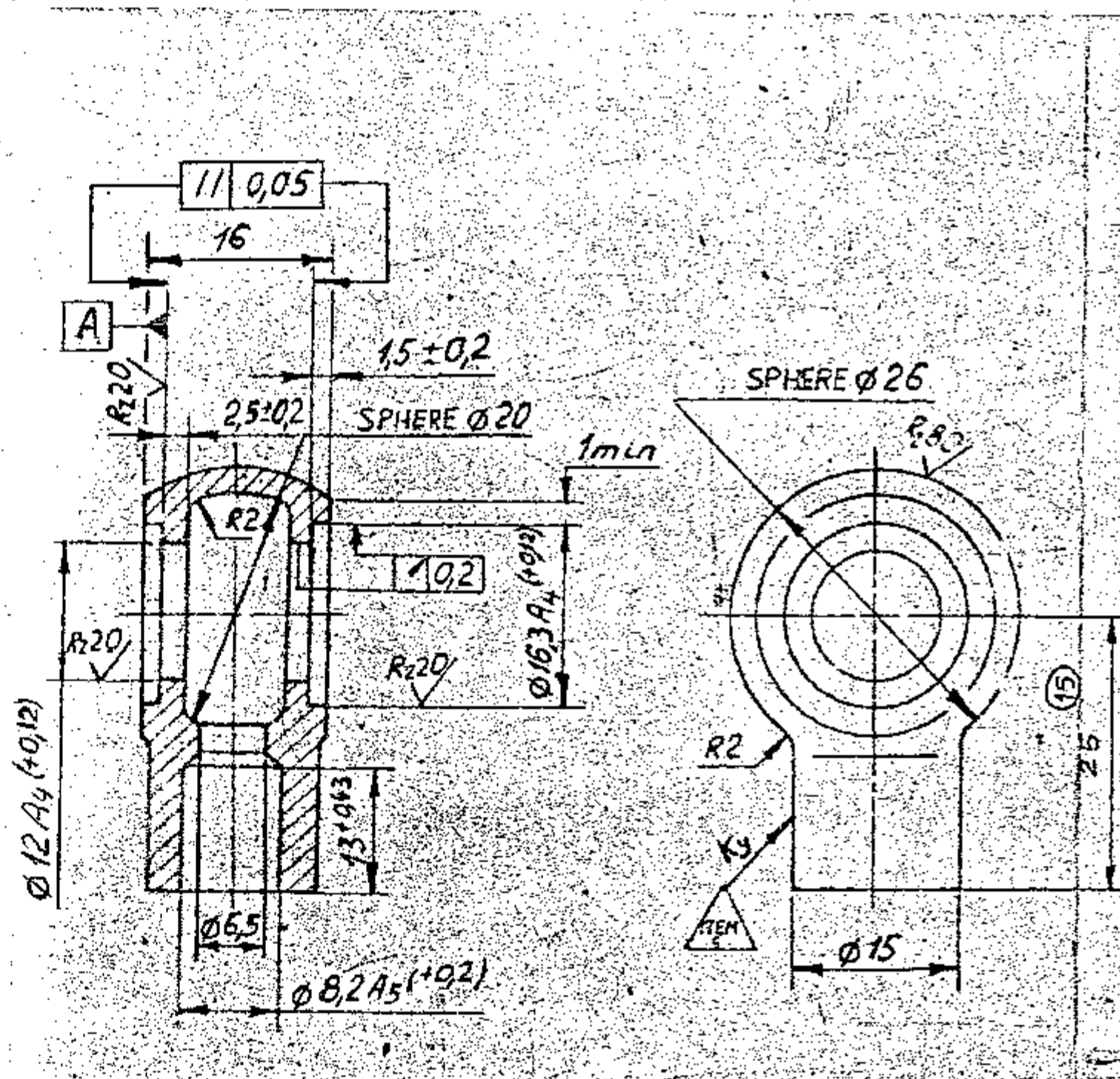
EXPLANATORY NOTE:

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.

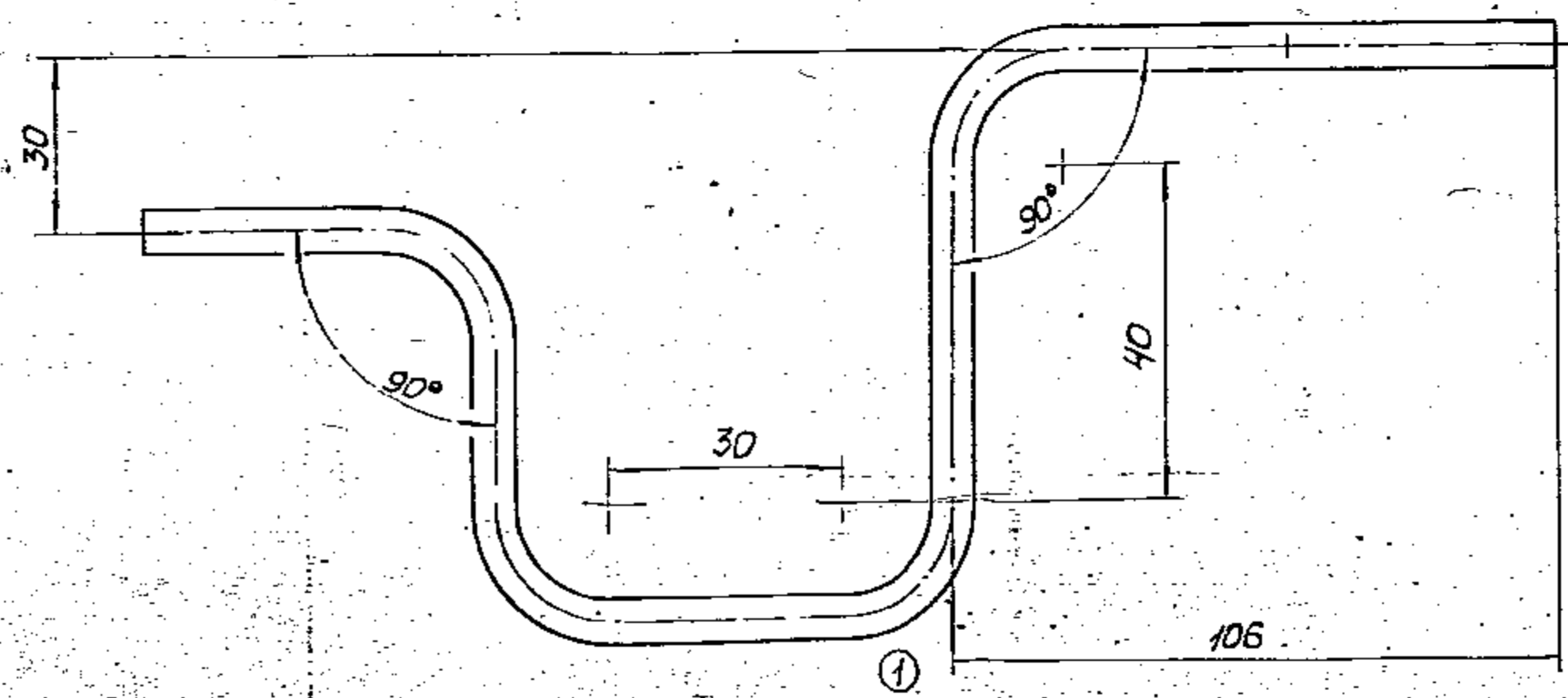
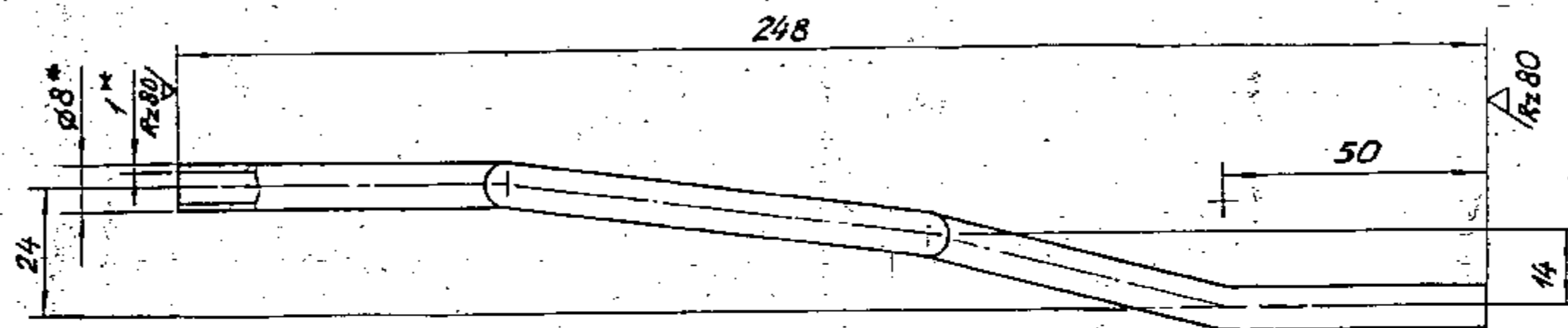
DRN	APPROVED	MATERIAL :-	USED ON :-
CHKD		35 GOST 1050-74	* *
TED		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
APPD		A V A D I	
DATE	6-3-87	TITLE	
SCALE	2:1	SWIVEL ELBOW	
DIMENSIONS IN mm		TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69	
15A	9-6-09	3 RD ALTN. COMM. MINUTES	D S CAT NUMBER
15	25-7-89	POINT 6. DATE 27-2-09	DRAWING NUMBER
ISSUE	DATE	NATA NO. 1357-63	20-29-18
		NATURE OF AMENDMENTS	





DRAWING NUMBER
20-35-75-10

(✓)



EXPLANATORY NOTE:-

MATERIAL QUOTED : PIPE 8x1- 20A TY 14-3-480-76
HIGH PRESSURE SEAMLESS STEEL PIPE
GRADE 20A FOR FUEL PIPES
8 = OUTER DIAMETER
1 = WALL THICKNESS

CHEMICAL COMPOSITION :-

CARBON = 0.15-0.25
SILICON = 0.17-0.37
MANGANESE = 0.35-0.65
CHROMIUM = 0.30
PHOSPHORUS = 0.035
SULPHUR = 0.035
NICKEL = 0.30

MAXIMUM.

MECHANICAL PROPERTIES :

ULTIMATE RUPTURE STRENGTH $Kgf/mm^2 = 40$ (MIN)
RELATIVE ELONGATION = 21 (MIN)

SUPERSEDES THE DRG No. 20-35-75-9 AUTHY ON 86

1. NON-INDICATED LIMIT DEVIATIONS OF DIMENSIONS ARE ± 1 mm.
2. RADIUS OF PIPE BENDING ARE 25 ± 3 mm.
3. PIPE LENGTH IN THE STRAIGHTENED CONDITION IS $L \approx 365$ mm.
4. BEFORE BENDING CLEAN THE PIPE INNER SURFACE FROM SCALE.
5. PIPE OVALITY IN BENDING PLACES IS WITHIN 1.5 mm.
6. FORMATION OF FOLDS IS ALLOWED ON INNER PART OF BENDING BY HEIGHT 0.25 mm MAX.
7. * DIMENSIONS FOR INFORMATION.

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

EST. WT. 0.063 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.

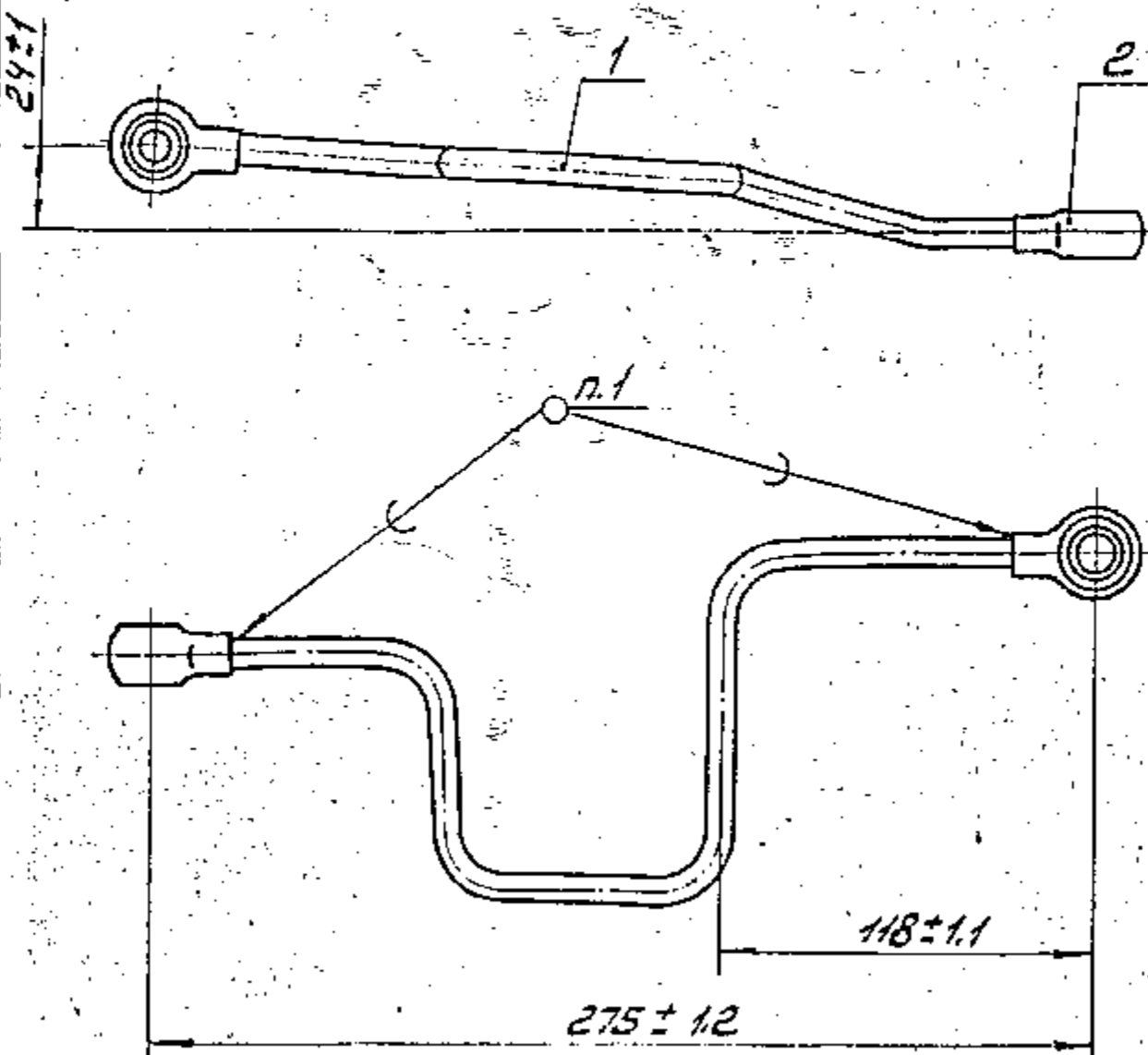
DRN	<i>Prin</i>	MATERIAL :- PIPE	USED ON :- 12
CHD	<i>Prin</i>	8x1- 20A	CS 20-35-10-11
TCD	<i>Prin</i>	TY 14-3-480-76	
APPD	<i>V. Ramana</i>	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	28-1-92	A V A D I	
SCALE	1:1	TITLE PIPE	
DIMENSIONS IN mm.		D S CAT NUMBER	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69		DRAWING NUMBER 20-35-75-10	
ISSUE	DATE	NATURE OF AMENDMENTS	



SIZE A2



DRAWING NUMBER
C8 20-35-10-12



- I
1. Припой А63 ГОСТ 15527-70.
 2. Внутренний диаметр трубы и места пайки поворотных угольников очистить от окалины и ржавчины.
 3. После окончательной подгонки по макету трубу промыть профильтрованным дизельным топливом при давлении на входе не менее 0,1 МПа (1 кгс/см²) в течение 2* минут; во время промывки для удаления оставшейся окалины трубу обдувать.
 4. Трубу проверить на герметичность дизельным топливом под давлением 0,5 МПа (5 кгс/см²) в течение 2* минут; просачивание топлива не допускается. Контролю подлежат 10% узлов, но не менее 3* штук от партии.
 5. Допускаются единичные не сквозные поры по месту пайки, обнаруженные после цинкования при условии обеспечения герметичности.
 6. Покрытие: Ц 15хр. Допускается отсутствие покрытия на внутренних поверхностях.
 7. Концы трубы предохранить от загрязнения.
 8. Маркировать номер узла и клеймить окончательную приемку на бирке (деталь 540-551) для партии узлов с опломбированием.

1. Solder according to А 63 GOST 15527-70.
2. Clean from scale and rust the pipe inside diameter and soldering places of rotatable angles.
3. After finish matching by pattern wash the pipe by filtered diesel fuel at an inlet under pressure no less than 0.1 MPa (1 kgf/cm²) for two minutes. Beat the pipe during washing for removal of resting scale.
4. Check the pipe tightness by means of the diesel fuel under pressure of 0.5 MPa (5 kgf/cm²) for two minutes. Fuel seepage is not allowed. Check 10% units but no less than three of a set.
5. Single blind pores discovered after zinc plating are allowed on soldering places on condition of providing the tightness.
6. Coating: Ц 15хр. Coating absence is allowed on inside surfaces.
7. Prevent pipe ends from contamination.
8. Mark the unit number and stamp the final acceptance on a tag (540-551 part) for a set of units with sealing.

SUPERSEDES Cb 20-35-10-11 VIDE NOTN. No. 912-87

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE-NIL (912-87)

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

EST. WT. 0.143 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		MATERIAL :-	USED ON :-
CHD			C8 20-35-00-5
TCD			
APPO		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DATE	02 AUG 89	A V A D I	
SCALE	1 : 2	TITLE	PIPE
DIMENSIONS IN mm.		D S CAT NUMBER	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69		DRAWING NUMBER	C8 20-35-10-12
ALL THREADS TO CONFORM TO			
ISSUE	DATE	NATURE OF AMENDMENTS	



