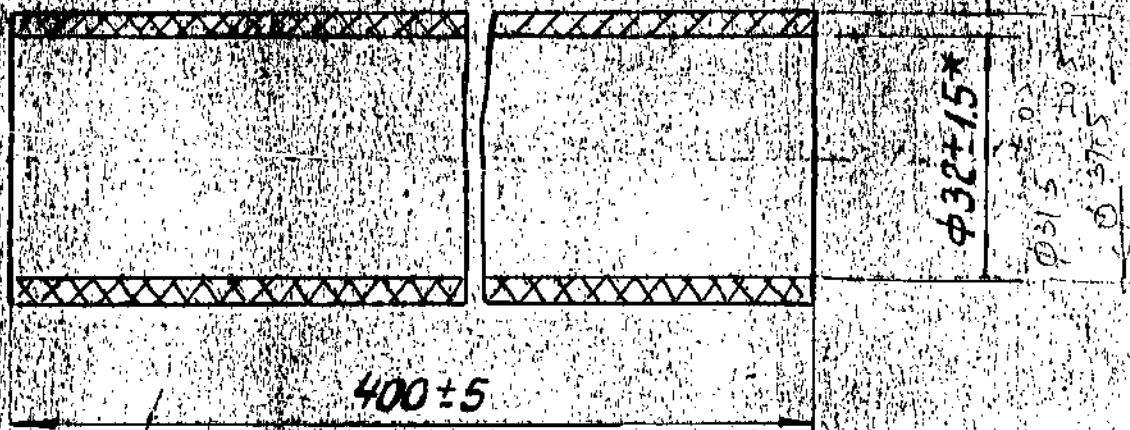




*Размеры для справок

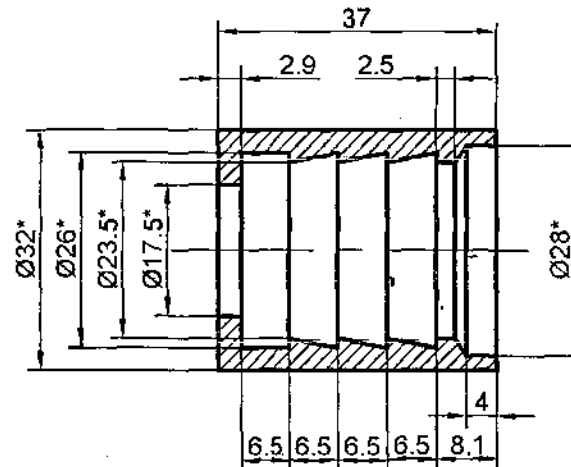
*DIMENSIONS FOR REFERENCE

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

		EST. MASS 0.153 Kg		TO BE STAMPED OR MARKED WHERE INDICATED THUS #	
				LETTERS I	
		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			
DRN		SCALE : 1 : 1		MATERIAL : BLANK 3320-406	
END		DIMENSIONS IN mm		USED ON : Cb-3320-398	
TCD		TOLERANCE ON DRWS UNLESS OTHERWISE STATED		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
APPD				TITLE : PIPE	
DATE 3/18/87		ALL THREADS TO CONFORM TO		D S CAT NUMBER DRAWING NUMBER 3320-394	

DRAWING NUMBER

CQA(HV)507705E

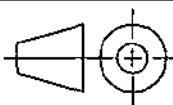


1. * DIMENSIONS AFTER CRIMPING. FOR REFERENCE ONLY

2. COATING :- Cd9, CHROMATIZING AS PER INSTRUCTION UQA-104
WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.

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

		EST. WT.	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.		
		MATERIAL :- STEEL 220M07 (EN-1A) TO BS:970 PT I-1983		USED ON :- CQA(HV)507700E CQA(HV)507706E CQA(HV) 507 718E
ISSUE	DATE	NATURE OF AMENDMENTS		
DRN		SCALE :- 1 : 1		
CHD		DIMENSIONS IN mm		
TCD		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS : 2102 - 69		
APPD		ALL THREADS TO CONFORM TO		
DATE	07.11.08.			
SIZE A4		D S CAT NUMBER		DRAWING NUMBER CQA(HV)507705E



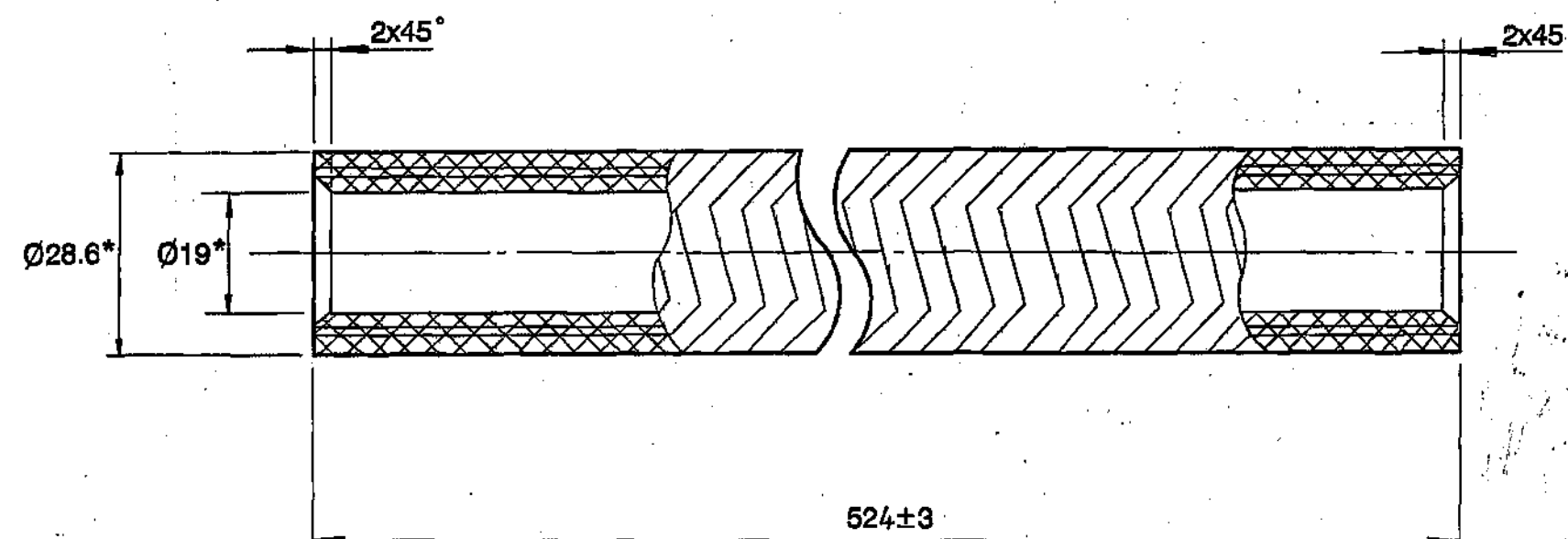
TITLE :-

COUPLING

DRAWING NUMBER

CQA(HV).507709E

SHEET No. 1 OF 1



1. *DIMENSIONS FOR REFERENCE.

MATERIAL PROPERTIES :-

- 1) I/D = 19.0 mm
- 2) O/D = 27.8 mm
- 3) TUBE: BLACK, OIL RESISTANT SYNTHETIC RUBBER (NITRILE)
- 4) REINFORCEMENT: ONE BRAID OF HIGH TENSILE-STEEL WIRE.
- 5) MINIMUM BEND RADIUS : 4.75" (120.65mm)
- 6) LENGTH CHANGE ALLOWED : 2% TO 4%
IN SUPPLY CONDITION
(TEST TO BE CONDUCTED AS
PER SAE J 343 d)

- 7) WORKING PRESSURE : 1250 Psi (86 bar)
- 8) PROOF PRESSURE : 2500 Psi (172 bar)
- 9) BURST PRESSURE : 5000 Psi (345 bar)
- 10) TEMPERATURE RANGE : -40°C TO +135°C
INTERMITTANT TEMP. : +149°C (UPTO 10% OF OPERATING TIME)
- 11) ADHESION IN COVER TO BRAID : 1.8 Kgf/cm (MIN)
- 12) IMPULSE TEST (TEST TO BE : 1,50,000 CYCLES (MIN)
CONDUCTED AS PER SAE J 343 d)

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

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

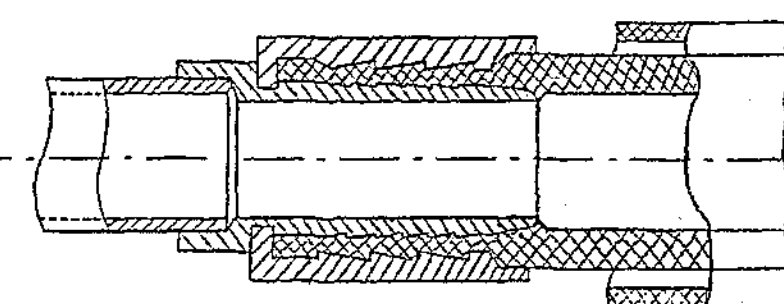
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS
OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-
SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	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
			07-11-08	1:1					CQA(HV).507709E
MATERIAL:- REFER ABOVE				USED ON:- CQA(HV).507706E. CQA(HV).507718E.					
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI				TITLE:- HOSE					
A				18-01-11		5 th Alt. Comm Meeting Minutes Point No.11			
ISSUE				DATE		NATURE OF AMENDMENTS			

SIZE A3



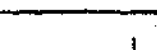
SCALE 1:1



1. END CONNECTION SHALL BE FIXED WITH HOSE BY CRIMPING SUITING TO HOSE AND END CONNECTION REQUIREMENT.
2. DURING ASSEMBLY OF HOSE, END PIECES, INNER SURFACES OF COUPLINGS AND MANDRAL OF FIXTURE SHOULD BE ABUNDANTLY LUBRICATED BY OIL WHICH IS USED FOR FILLING UP THE ARTICLE OIL SYSTEM.
3. BEFORE CRIMPING THE ACCESSORIES INTO THE HOSE, THE ENDS OF HOSE SHOULD BE STRAIGHTENED BY MANDRAL.
4. TO BE PRESSURE TESTED BY DIESEL FUEL AT A PRESSURE OF $2^{+0.2}_{-0.1}$ MPa (20^{+2}_{-1} Kg/cm²) FOR TWO MINUTES. DIESEL FUEL SHOULD BE DRAINED AND INTERNAL AND EXTERNAL SURFACES OF HOSE SHOULD BE BLOWN WITH COMPRESSED AIR.
5. DIMENSION 'A' WITH HOSE IN FREE POSITION.
6. *DIMENSIONS FOR REFERENCE.

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

EST. WT. (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.	

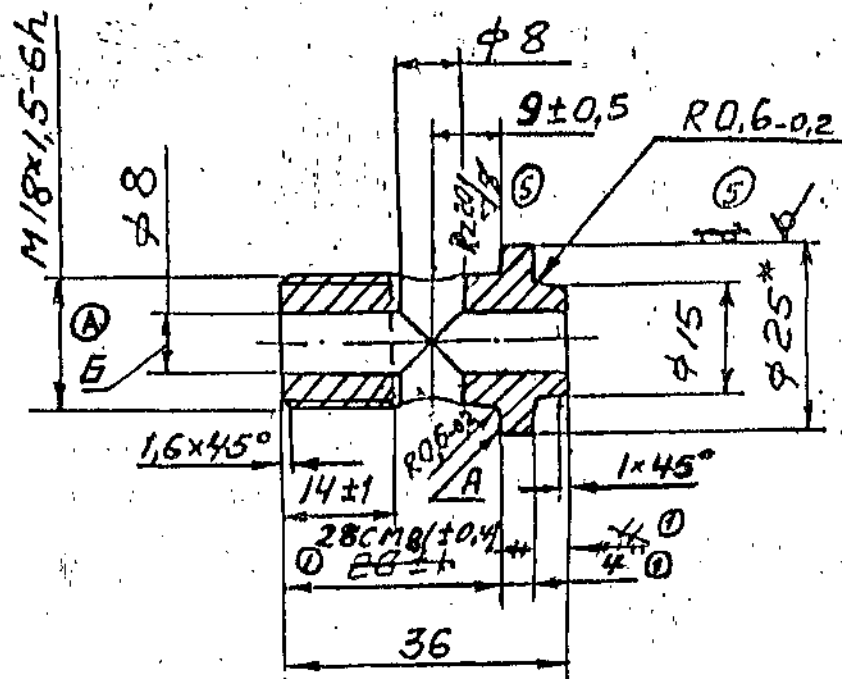
			DRN	<i>210</i>	MATERIAL :- _____	USED ON :- Cb 3320-00-43
			CHD	<i>210</i>		
			APFD	<i>210</i>	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
			DATE	29-11-08		
			SCALE:-	1 : 2	 TITLE :- TUBING FROM OIL FILTER TO MAIN OIL GALLERY	
			DIMENSIONS IN mm			
			TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69			
			ALL THREADS TO CONFORM TO			
ISSUE	DATE	NATURE OF AMENDMENTS			D S CAT NUMBER	DRAWING NUMBER CQA(HV)507718E

**I/L SUPERSEDES Cb 3320 - 398 - 2 I/L
AUTHY:- 1st Alteration Committee Meeting
Minutes Point No.1 Dt.29.9.2004**

[illegible]

107-0222

ЕСКД



⑥ STEP UP TO 0.5 mm IN HOLE 'E' IS ALLOWED TOWARDS INCREASE OF THE HOLE IN EXCESS OF TOLERANCE.

1. -
2. TOLERANCES UNLESS OTHERWISE STATED FOR HOLES AS PER A7; FOR SHAFTS AS PER B7 FOR THE REST OF THE DIMENSIONS AS PER CM7.
3. NON SQUARENESS OF SURFACE A RELATIVE TO THE AXIS OF THREAD SHOULD NOT EXCEED 0.1mm (MMC)
4. *DIMENSION FOR REFERENCE.
5. DURING FACING END FACE A, CUTTING-IN AND STEP NOT EXCEEDING 0.3mm ARE PERMISSIBLE ON CYLINDRICAL SURFACE.

* * ROUND BAR 25.5-GOST 7417-75
20 GOST 1051-73

PILOT SAMPLE SHOULD BE APPROVED BY A IIS P BEFORE BULK PRODUCTION

EST. MASS 0.050Kg		TO BE STAMPED OR MARKED WHERE INDICATED THIS IN LETTERS	
A 07.4.89 AUTHY. BK 64-480		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
DRN	DATE	SCALE: 1:1	USED ON: CB 3320-400
CHD	DATE	DIMENSIONS IN mm	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI
TCD	DATE	TOLERANCE ON DIMMS UNLESS OTHERWISE STATED	UNION
APPD	DATE	ALL THREADS TO CONFORM TO	D S CAT NUMBER
DATE 8.12.85		DRAWING NUMBER 3320-401	

A-7
90

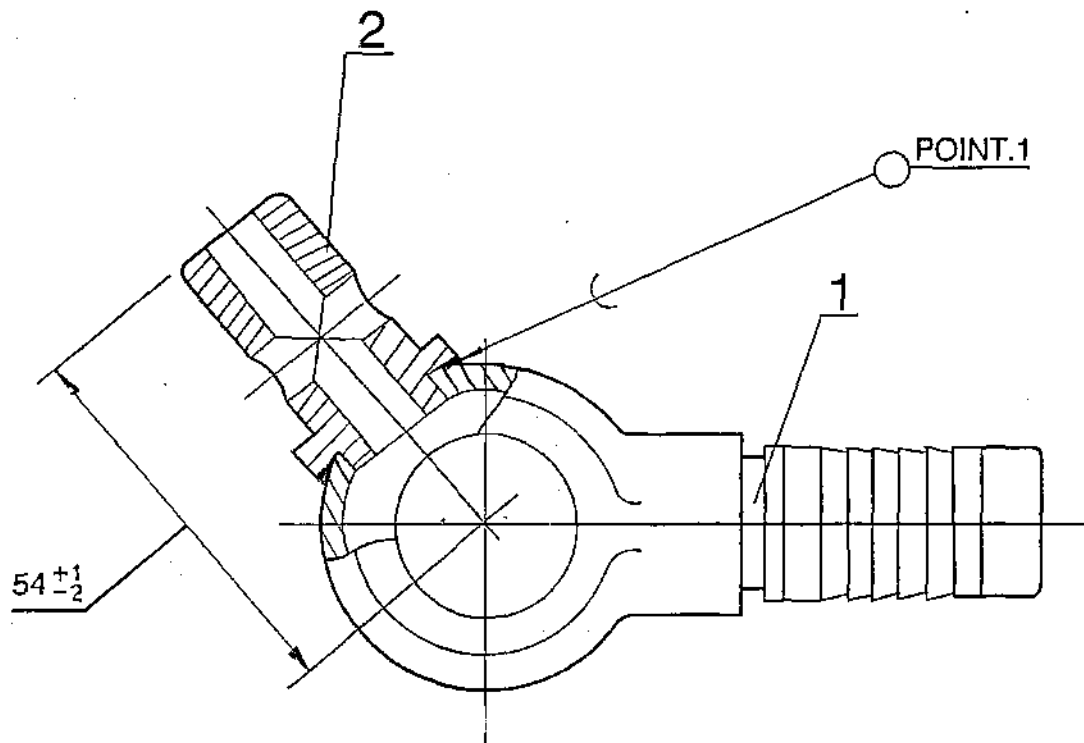
INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 3

29/12/85

DRAWING NUMBER

CQA(HV).507708E

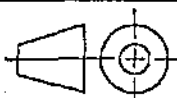
SHEET No. 1 OF 1



1. TO BE BRAZED WITH BRASS J63 GOST 15527-70.
2. EXTERNAL COATING: GLYPTAL VARNISH ГФ95 GOST 8018-70 IN ACCORDANCE WITH UJ-09-73.

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

		EST. WT. (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.	
		MATERIAL :-	USED ON :- CQA(HV).507706E. CQA(HV).507718E.
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE :- 1 : 1	
CHD		DIMENSIONS IN mm	
APPD		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS : 2102 - 69	
DATE		ALL THREADS TO CONFORM TO	
07-11-08		D S CAT NUMBER	DRAWING NUMBER CQA(HV).507708E
SIZE A4			



TITLE :-

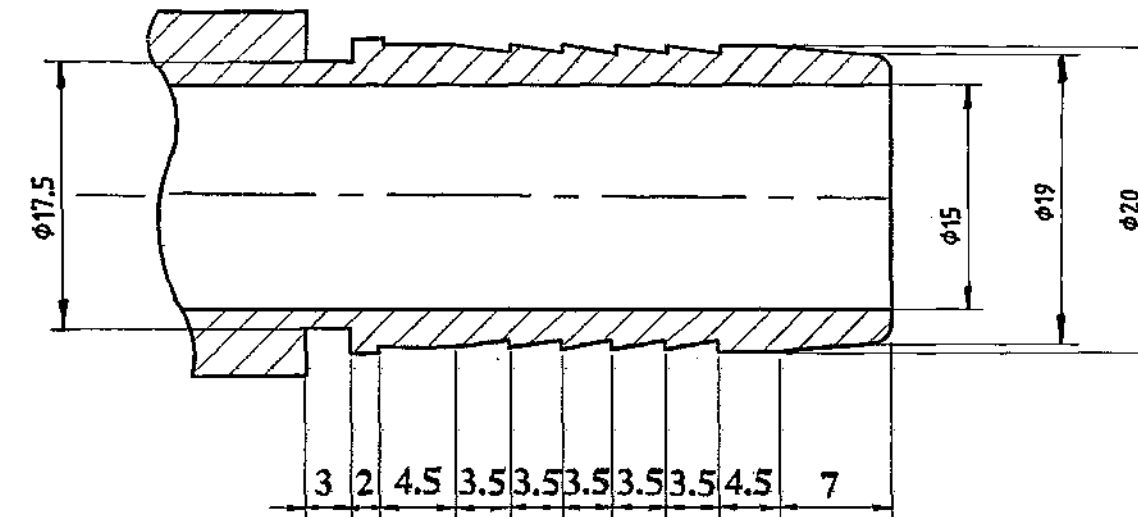
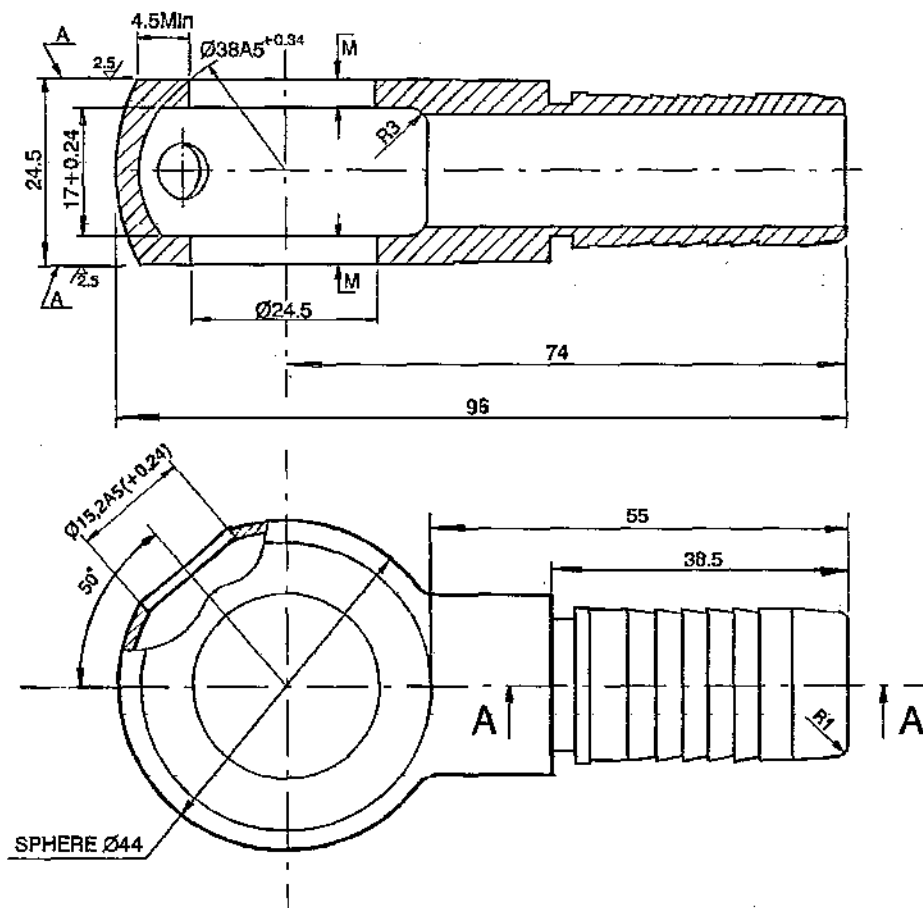
SWIVEL ELBOW ASSY.

DRAWING NUMBER
CQA(HV)507711E

SHEET No. 1 OF 1

SECTION A-A

SCALE 2:1



1. REQUIREMENTS FOR STAMPING AS PER GOST 7505-74.
2. NON - PARALLELISM OF SURFACE 'A' SHOULD NOT EXCEED 0.1mm.
3. WALL THICKNESS 'M' NOT LESS THAN 3mm.
4. COATING : Cd9 CHROMATIZING AS PER INSTRUCTIONS U UJ-104 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.

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

EST. WT. (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.

SIZE A3

			DRN	108	MATERIAL :-	USED ON :- CQA(HV)507708E
			CHD	Shm	STEEL 220M07(EN 1A)	
			APPD	R. D. S. D. S. D. S.	TO BS:970 PT 1.1983.	
			DATE	07-11-08	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
			SCALE:-	1:1	AVADI	
			DIMENSIONS IN mm		TITLE :-	
			TOLERANCE ON DIMNS		SWIVEL ELBOW	
			UNLESS OTHERWISE			
			STATED IS : 2102 - 69			
			ALL THREADS TO		D S CAT NUMBER	DRAWING NUMBER
			CONFORM TO			CQA(HV)507711E
ISSUE	DATE	NATURE OF AMENDMENTS				

USED ON CQA9HV) 507706E	ZONE	ITEM NO	DRAWING NUMBER	D S CAT NUMBER	DESCRIPTION	QTY	REMARKS
			CQA(HV) 507708E & ITEM LIST		SWIVEL ELBOW ASSY.		
		1	CQA(HV) 507711E		SWIVEL ELBOW	1	
		2	3320-401		UNION	1	
						</	