

1. REQUIREMENTS FOR CASTING ACC. TO T T A/J 310-5-45
2. NON-INDICATED LIMIT DEVIATIONS OF CASTING DIMENSIONS ARE ACC. TO A OST 3.4565-80.
3. NON-INDICATED FOUNDRY SLOPES ARE TO 3° RADUSES ARE TO 3 mm.
4. TECHNOLOGICAL GRID BY OUTER AND INNER SURFACES ARE ALLOWED BY HEIGHT TO 1.0 mm, EXCEPT H AND K SURFACES.
5. MATERIAL IS A.15 SUBSTITUTE ACC. TO GOST 2685-75.
6. SHAPE BY WATER UNDER PRESSURE 0.1 ± 0.05 MPA (1 ± 0.5 Kgf/cm²) FOR 2 ± 1 MINUTES BEFORE BAKELITE COATING. WATER LEAKAGE IS NOT ALLOWED.
7. NON-INDICATED LIMIT DEVIATIONS OF DIMENSIONS ARE OF HOLES BY A, SHAFTS BY B, OTHERS BY CH.
8. MAKE H THREAD ACC. TO NORMAL Ø20-12, ISSUE 7.
9. CHECK COVER INNER CONTOUR BY ETALON.
10. CHECK COVER INNER HOLLOW BY PATTERN.
11. COATING OF OUTER AND INNER UNTREATED SURFACES IS BAKELITE LAQUER БС-1 ACC. TO GOST 901-78, П. 6/1 C1.
12. MARK LETTERS A/B BY TYPE ПД-7 ACC. TO GOST 2930-82.

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

EST. MASS 3.75 kg
TO BE STAMPED OR MARKED WHERE INDICATED THUS II LETTERS
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRM	TCO	APPD	DATE	SCALE	MATERIAL	USED ON
			17-7-87	1:2	A.15 GOST 2685-75	CE 20-06-09-2
					CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES)	A V A D I
					TITLE	CYLINDER HEAD LEFT COVER
					D S CAT NUMBER	DRAWING NUMBER
						20-06-94-3
ISSUE	DATE	NATURE OF AMENDMENTS				

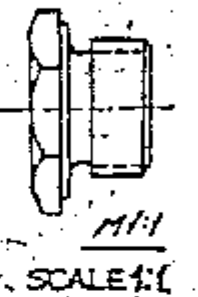
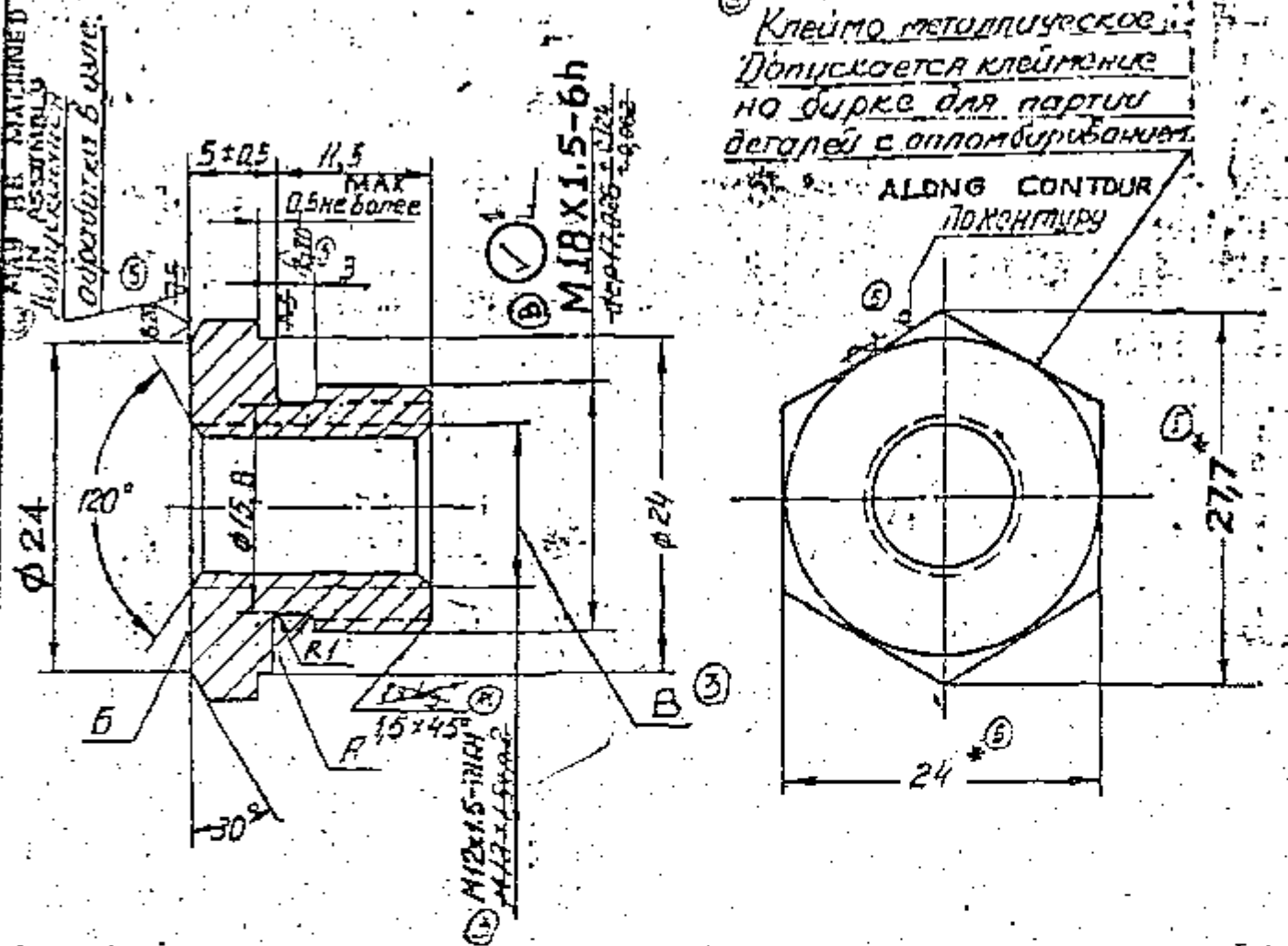


1-901-10E

TO BE PUNCHED, MARKING ON TAG FOR A BATCH OF COMPONENTS WITH PACKING AND SEALING IS PERMISSIBLE.

Клеймо металлическое
Допускается клеймение
но бирке для партии
деталей с опломбированием

Взвешивание



Inspection group V
Tolerance on free dimensions are as per class 7 accuracy of OST 1010.
Tech. Requirements for thread are as per standard 82021-00.
End play on surface A relative to the axis of external thread should not exceed 0.1 mm on $\varnothing 23$. End play on surface B relative to the axis of internal thread should not exceed 0.15 mm on $\varnothing 23$. Thread dimensions are to be checked before coating, internal thread may not be coated. Sharp edges should be blunted, turning of face on $\varnothing 26$ C5 is permissible.
Coating is Cd 9 Cr as per ~~U.S. 569-86~~ with hydrogen embrittlement removed.
Alternate material-steel grades 40 and 50, Gost 1050-74

*Dimensions for reference.

ALTERNATE MATERIAL: STEEL 080M40 (EN B)
TO BS: 970 Pt. I-1983 OR 45 CB 70 15 :1570

COA(HV)5.07.50ZE Cb 306-01-36 * CB-20-29-08-2
COA(HV)5.07.504E Cb 306-02-36 CB-3329-01-11
Cb 337-120 CB-3301-15-44
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

D	9-6-09	3 rd ALTN. COMM. MINUTES POINT B. DT 27-2-09	EST. MASS 0,022 Kg	TO BE STAMPED ON MARKED WHERE INDICATED THUS #
C	9-9-08	USED ON NUMBER ADDED		
B	20-5-98	REPAIR SIZES ADDED		
G		BK 82-207		
A	25.12.08	AUTHY BK 65-141		
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL 24-5 GOST 8560-78 HEXAGON 45 GOST 1051-73	USED ON- CB 3301-15-30 *
DRN	1/2	SCALE: 2:1	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
CHD	3/11	DIMENSIONS IN mm	TITLE: BUSH	
TCO	4	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	U.S. CAT NUMBER	
APPD		ALL TOLERANCES TO COMPLY TO	DRAWING NUMBER 301-106-1	
ISSUE	DATE	NATURE OF AMENDMENTS		
E	5.3.14	Authy. Point No.11 of 7 th Alt. Comm. Meeting at EFA.		

EXPLANATORY NOTE:-

MATERIAL QUOTED :- HEXAGONAL BAR 24-5 GOST 8560-78
45- GOST 1051-73.

ALTERNATE MATERIAL QUOTED :- 40 AND 50 GOST 1050-74.

BRIGHT STEEL HEXAGONAL FROM GRADE 45 STEEL WITH WIDTH ACCROSS FLATS 24 mm; OF ACCURACY CLASS - 5 AS PER GOST 1051-73.

CHEMICAL COMPOSITION:-

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C	Si	Mn	Cr	P	S	Cu	Ni
40	0.37-0.45	0.17-0.37	0.50-0.80	0.25	0.035	0.040	0.25	0.25
45	0.42-0.50	0.17-0.37	0.50-0.80	0.25	0.035	0.040	0.25	0.25
50	0.47-0.55	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 IN AREA	IMPACT STRENGTH
	kgf/cm ²	kgf/mm ²	%	%	kgf.m/cm ²
40	58	34	19	45	6
45	61	36	16	40	5
50	64	38	14	40	4

REPAIR SIZE DIMENSIONS ARE ADDED BASED ON LETTER NO:

82847/OH/GAS/ED. DT: 27 MAR 95 AS FOLLOWS:

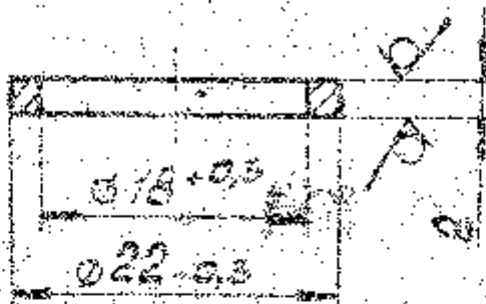
REPAIR SIZE DIMENSION ADDED WHERE INDICATED THUS: (B)

S/N	R	REMARKS
1	M20x1.5-6h	ALL OTHER CONDITIONS AS PER STD DRG. MARK REPAIR SIZE

COMMON TO V-92S2 & UTD-20 ENGINES

A-2





1. ALTERNATE MATERIAL IS COPPER M2 AND, M3, GOST 859-79.

2. ANNEAL.

USED ON
* CE20-29-08-8

2
40

TEST SAMPLE SHOWN BY APPROXIMATELY A 1/2" P. SCALE. THIS IS FOR INFORMATION.

NET MASS
0.0029 Kg

M1, GOST 859-78

ES 20-06-09-2 *
ES 20-29-00-8

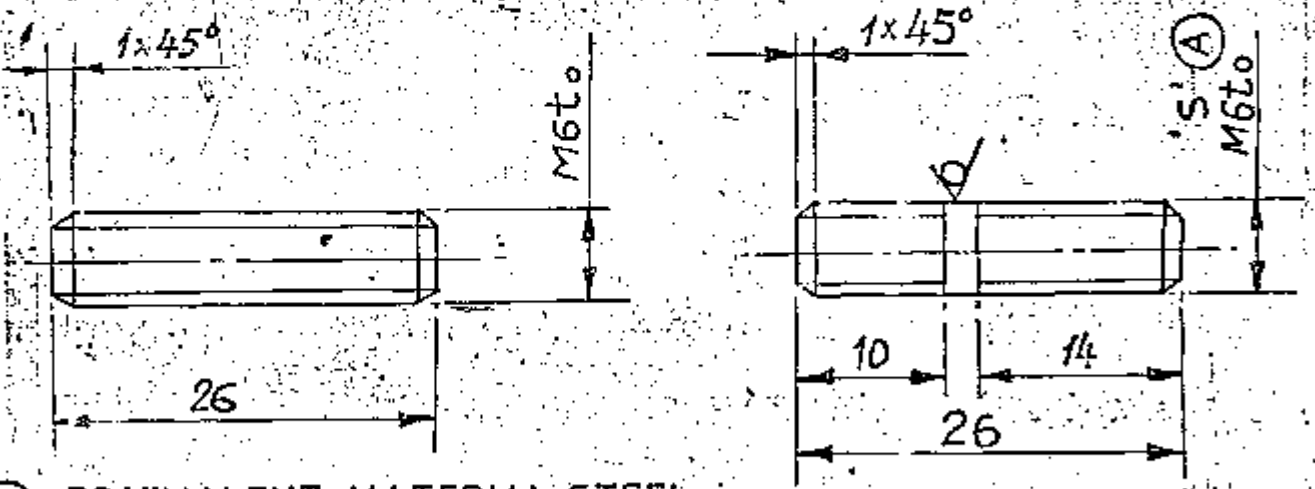
GASKET

329-30

Handwritten notes and signatures on the left side of the page, including a date '10/19/87'.

R2.80/ (✓)

WORKING NUMBER
550-101



(C) EQUIVALENT MATERIAL STEEL
45C8 TO IS:1570

1. ALTERNATE MATERIAL IS STEEL 40, 50 GOST 1050-74
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS:
FOR SHAFTS - AS PER B7
FOR OTHERS - AS PER CM7.
3. CUT THREAD AS PER STANDARD 82020-12, ISSUE 7.
4. COATING: CADMIUM-PLATED 3 MICRONS THICK, OILED
5. TECHNICAL REQUIREMENTS ARE AS PER GOST 1759-70.
6. UNTHREADED PORTION OF THE ROD MAY BE MADE WITH IN THE LIMITS OF THE ANGLE DIAMETER OF THE THREAD.
7. MECHANICAL DAMAGE TO COATING SUCH AS SCRATCHES, NOTCHES AND DENTS WHICH DO NOT EXPOSE STEEL ARE PERMITTED IN ASSY. UNITS.

(B) 8. HARDNESS:- 27-32 HRC.

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

EST. WT. TO BE STAMPED OR MARKED WHERE INDICATED THIS # 1 LETTERS]
0.004 kg.

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

EXPLANATORY NOTE

MATERIAL QUOTED : STEEL 45 GOST 1050-74.

45 = GRADE OF MATERIAL

CHEMICAL COMPOSITION : (AS PER GOST 1050-74)

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C	Si	Mn	Cr	P	S	Cu	Ni
45	0.42-	0.17-	0.50%	0.25	0.035	0.040	0.25	0.25
	0.50	0.37	0.80					

MECHANICAL PROPERTIES :

TENSILE STRENGTH Kgf/mm² = 61 (min)

YIELD POINT Kgf/mm² = 36 (min)

ELONGATION % = 16 (min)

REDUCTION IN AREA % = 40 (min)

(A) REPAIR SIZE DIMENSIONS

CATEGORY	DESIGNATION OF SIZE	SIZE ACCORDING TO WORKING DRG	REPAIR SIZE DIMENSION 'S'
550-101 R1	DIAMETER	M6 x 1 to	M8 x 1.25 to
	DIAMETRAL PITCH		+0.152 7.188 + 0.082

All other details as per working drg.
(B) * ALT. MATERIAL:- STEEL 709 M40 (EN-19) TO BS:970 PT.-1- 1983.

USED ON CB 20-04-07
CB 20-08-11,
CB 20-09-6,
CB 20-01-02-9,
CB 20-06-09-2,
CB 20-06-08-2,
CB 20-27-05-4,
CB 20-11-02-9.

DRN	<i>Srinivas</i>	MATERIAL:- *	45 GOST 1050-74
CHKD	<i>Shanmug</i>		
TCD	<i>S. Parthasarathy</i>		
APPD	<i>V. Ramaswami</i>		
DATE	3-6-91	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE:-	2:1	AYADI	
DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS:2102-69	TITLE	
		STUD M6X26	
ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER	
		550-101	

ISSUE DATE | NATURE OF AMENDMENTS

ISSUE: 1761-81

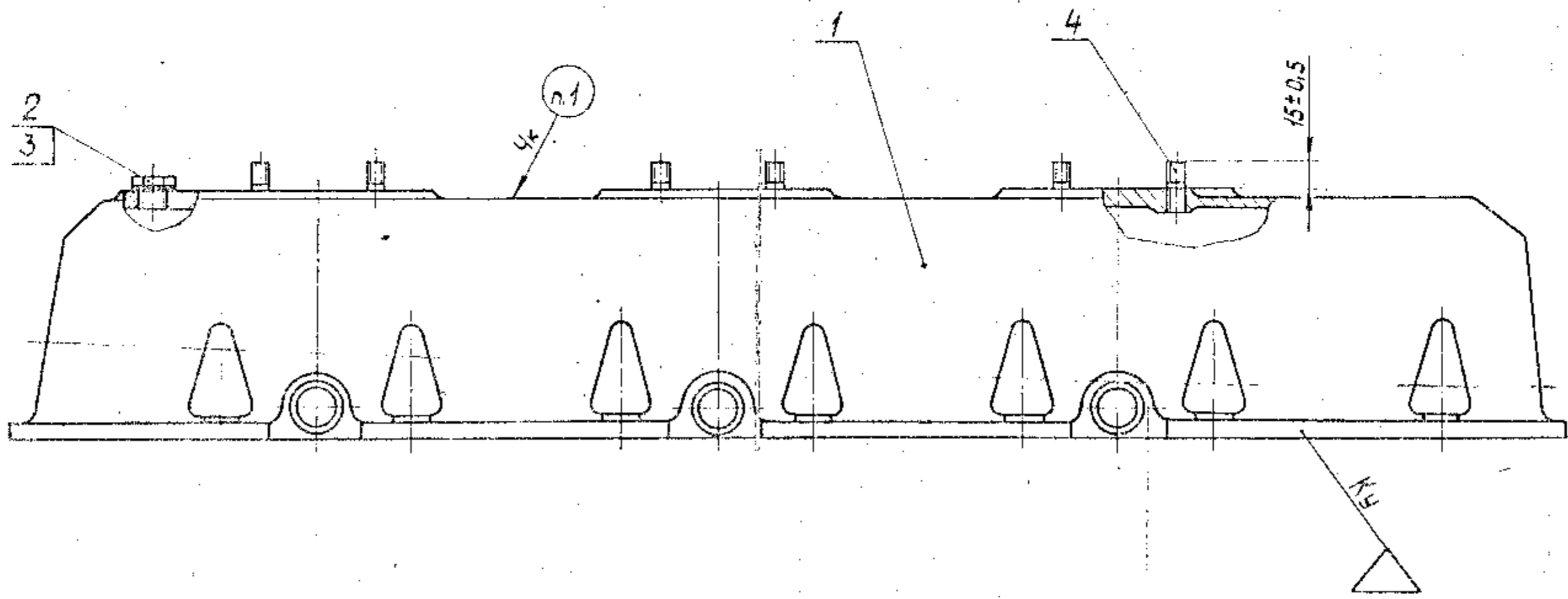


SIZE A3



2-60-90-02 90

ISSUE 1986-86 VIDE AUTHY. NOTE No. 61



1 Маркировать при отправке в запасные части. MARK WHEN DELIVERING AS SPARE PARTS.

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

7/7	7	109-76	Ред	014.12
12		1986-51		
12		1987-17		
			не вкл.	Автом
			n/n	
			n/n	
			n/n	
			n/n	

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

		EST MASS 3,8 kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)
A	15-7-15	Pl. 11 of 7th All. Comm. Meeting Dt. 11-4-12.	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: 1:2	MATERIAL: —	USED ON: C6 20-06-00-2 CQAIHVJS.06.607E (A)
CHKD <i>[Signature]</i>	DIMENSIONS IN: mm		
TCD <i>[Signature]</i>	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	CONTROLLER OF INSPECTION (HEAVY VEHICLES) AVADI	
APPL <i>[Signature]</i>		TITLE: ASSY. LEFT CYLINDER HEAD COVER	
DATE 07.9.87	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER C6 20-06-09-2



