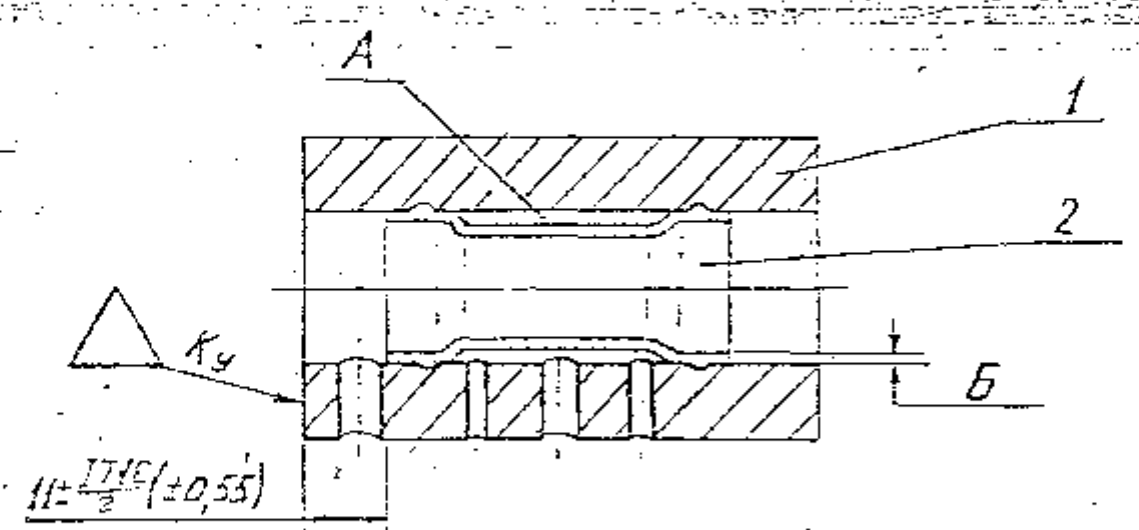


DRAWING NUMBER  
 СБ 304-04-1



1. CYLINDRICAL PORTIONS OF TUBE END ARE TO BE SEALED. DIMENSION 'Б' SHOULD BE NOT LESS THAN 0.6%.
2. SPACE 'A' IS TO BE MOULDED WITH MIXTURE CONSISTING OF 1 PART OF OIL AND 2 PARTS OF FUEL, USED FOR REFILLING WITH OIL AND FUEL SYSTEM OF ENGINE, AT A PRESSURE OF  $0.5 \pm 0.1$  Mpa ( $5 \pm 1$  Kgf/cm<sup>2</sup>) AND TEMPERATURE OF AREA SHOULD BE NOT LESS THAN 15°C FOR 1 min. SLIGHT DARKENING IS PERMISSIBLE.

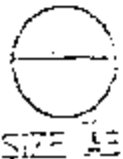
1. Концы трубки по цилиндрической части уплотнить; размер Б не менее 0,6 мм.

2. Полость А прессовать смесью состоящей из 1 части масла и 2х частей топлива, применяемых для заправки масляной и топливной систем двигателя, при давлении  $0,5 \pm 0,1$  МПа ( $5 \pm 1$  кгс/см<sup>2</sup>) и температуре помещения не ниже 15°C в течение 1 мин. Допускается незначительное потемнение.

7	К.С. 01-532	М.С. 10.12.84
М.С. 10.12.84	В.Р. 01.01.84	По Д.И. 1.2.84

DRG INDIANISED BASED ON RUSSIAN ORIGINAL, ISSUE No 7 (INC 01-532) KVD NO 78074

PLOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION		DRN	CHD	TED	APPO	DATE	SCALE	MATERIAL	USED ON
EST. WT.	TO BE STAMPED OR MARKED WHERE INDICATED THUS ( LETTERS)					123-3-84	1:1		СБ 3304-29-4
0.522 Kg									
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R. OUT SIDE R. INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		DIMENSIONS IN mm		TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS: 2102-69		ALL THREADS TO CONFORM TO		TITLE PIN OF ARTICULATED CONNECTING ROD ASSY.	
		ISSUE DATE		NATURE OF AMENDMENTS		D S CAT NUMBER		DRAWING NUMBER	
								СБ 304-04-1	





ENGINE FACTORY, AVADI

# PROCESS SCHEDULE

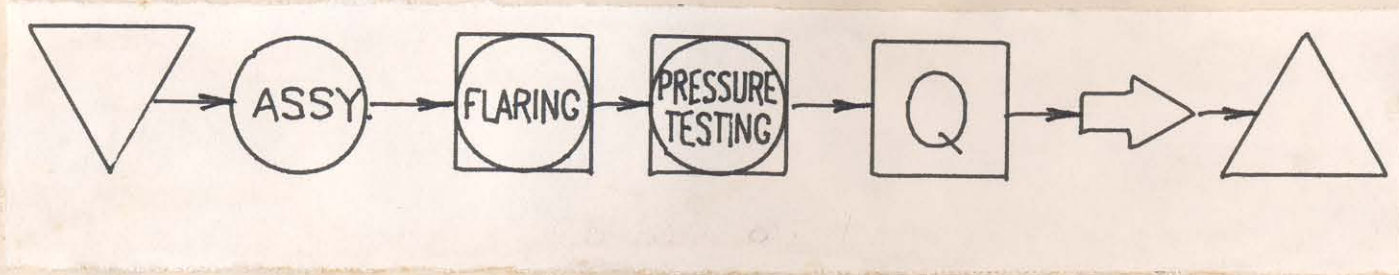
DESCRIPTION :- *PIN for ARTICULATED CON-ROD ASSY.*

COMPT. No :- *..... C5 304-04-1 .....*

MFG. SHOP :- *..... SPS .....*

# FLOW PROCESS CHART

STORE : PIN for ARTICULATED CONROD ASSY. DRG. NO.: C5304-04-1 END STORE: V46-6 ENGINE ASSY.



HT = HEAT TREATMENT	TUR = TURNING	ML = MILLING	DRL = DRILLING	TRL = THREAD ROLLING	
EP = ELECTRO PLATING	EG = EXT. GRINDING	IG = INT. GRINDING	SG = SURFACE GRINDING	HC = HACKSAW CUTTING	
LEGEND			APPROVAL		SECTION
TEMP. STORAGE	▽	TRANSPORTATION	➔	SIGNATURE & DATE	
OPERATION	○	INSPECTION BY QC	Q	PREPARED BY	MGE
OPERATION CUM INSPECTION	◻	INSPECTION BY SQAE/CQA(ME) Etc.	I	APPROVED BY	QC
100 % INSPN. BY MFG. SEC.	□	STORAGE	△	AUTHORISED FOR ISSUE	
				ENGINE FACTORY, AVADI, MADRAS-54	

SPS

NO. OF SHEETS

SHEET NO.

*SWAR*

*[Signature]*

*Make 24/10/96*

1  
1



# ENGINE FACTORY AVADI

FORM No :EFA/P-038

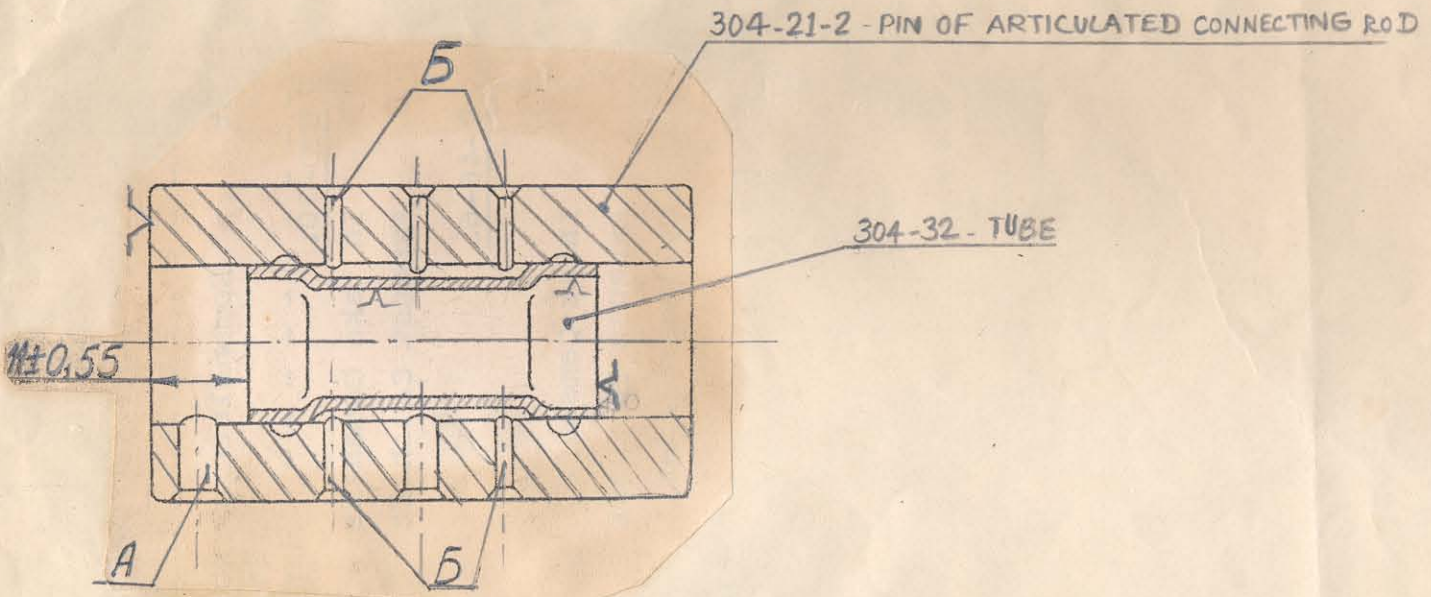
PROCESS SCHEDULE	NOMENCLATURE : <u>PIN OF ARTICULATED CON-ROD ASSY.</u>
	DRAWING No : <u>05 304-04-1</u>
	MATL SPECIFICATION : .....

OPN No	DESCRIPTION OF OPERATION	SHT No	WORK CENTRE	SET UP TIME	OPN TIME	REMARKS
010	DRAWAL FROM STORES D 304-21-2 PIN QTY. 1 no. 2) 304-32 TUBE " 1 no.	-	.			
020	WASHING (wash the parts)	-	BENCH			
030	ASSEMBLY	2	HYDRAULIC PRESS			
040	FLARING	3	CENTRE LATHE			
050	PRESSURE TESTING	4	BENCH			
060	WASHING	-	- DO -			
070	FINAL - INSPECTION	5	- DO -			
080	PRESERVATION	6	- DO -			

PREPARED BY		CHECKED BY		APPROVED BY		AUTHORISED BY						SHT. No
SIGN	<u>DHR</u>	SIGN	<u>[Signature]</u>	SIGN	<u>[Signature]</u>	<u>[Signature]</u>						1 OF 6
DATE	10.10.96	DATE	28.10.96	DATE	28.10.96	21/10/96						
c/m J /PDO		c/m a n 2 /PDO		HOS/PDO		DO/PDO		PDO REF	ISSUE	DATE	SIGN	

MACHINE:  
HYDRAULIC PRESS

STD. TOOLS & GAUGES



TECHNICAL REQUIREMENTS

1. SCALE IS NOT ALLOWED ON THE SURFACE OF TUBE 304-32.
2. OVER LAPPING OF HOLES "A" AND "B" BY TUBE 304-32 IN PIN 304-21-2 IS NOT ALLOWED.
3. DO NOT TOUCH THE PARTS WITH BARE HANDS. USE HAND GLOVES AND CLOTH.

SPECIAL TOOLS & GAUGES

ASSY FIXTURE 401305

PLANNING SHEET - P & T / LEP

MV	<i>[Signature]</i>	<i>[Signature]</i>
PREP	CHD	APPD

NOMENCLATURE

PIN OF ARTICULATED CONNECTING ROD ASSY.

DRAWING No.

CD 304-04-1

ISSUE

OPN. No.  
040

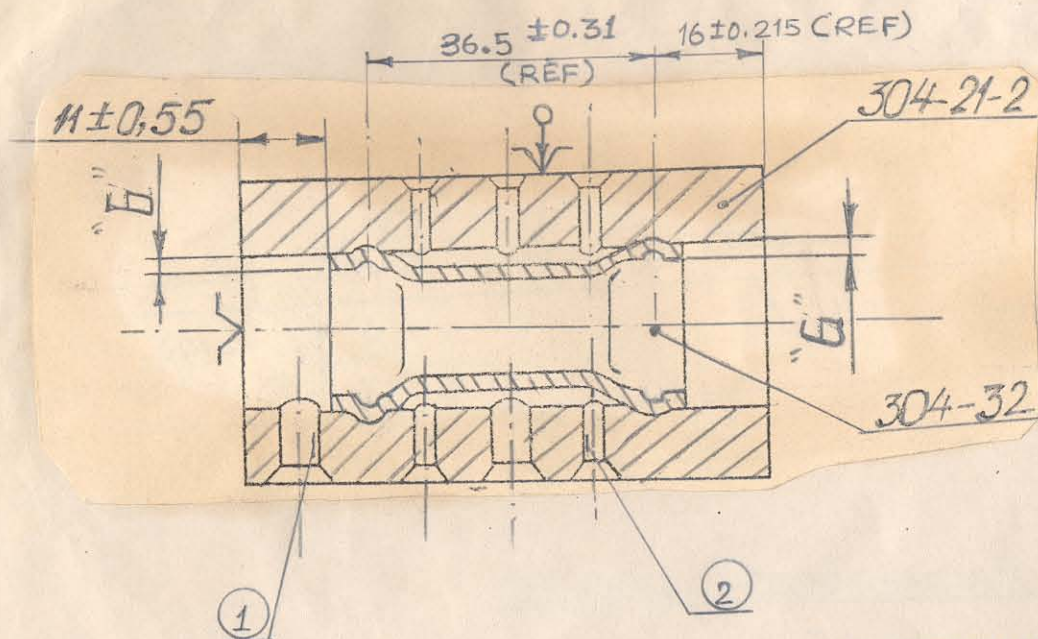
OPERATION  
FLARING

MACHINE:

CENTRE LATHE

HMT-NH22/1200

STD. TOOLS & GAUGES



TECHNICAL REQUIREMENTS

- ① OVER LAPPING OF HOLES ① & ② BY TUBE - 304-32 IS NOT ALLOWED.
- ② SIZE "B" SHOULD NOT BE LESS THAN 0.6 MM.
- ③ COMPTS. SHOULD BE PACKED IN A SPECIAL CONTAINER.
- ④ DURING THE OPERATION THE SURFACES OF PIN AND TUBE SHOULD BE CLEANED.

NOTE

① DO NOT TOUCH THE PART WITH BARE HANDS, USE GLOVES, CLOTH OR PARAFFINED PAPER.

SPECIAL TOOLS & GAUGES

- SOFT JAWS
  - FLARING TOOL
  - SPECIAL CONTAINER
  - SPECIAL CONTAINER
- 402146 (ROLLER TYPE)  
402158 (SOLID TYPE)  
ALTERNATE

PLANNING SHEET - P & IE / LEP

MV	DB	13.29
PREP	CHK	APPD

MACHINE:

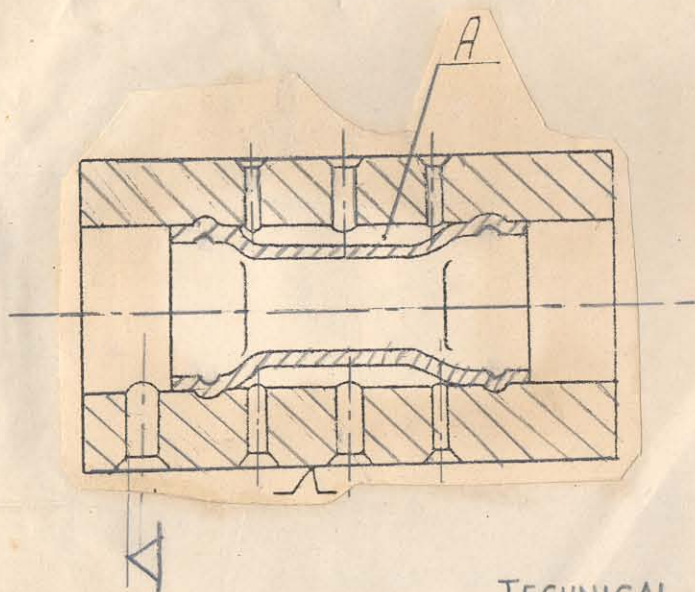
BENCH

STD. TOOLS & GAUGES

SPECIAL TOOLS & GAUGES

PRESSURE TESTING FIXTURE

40/308

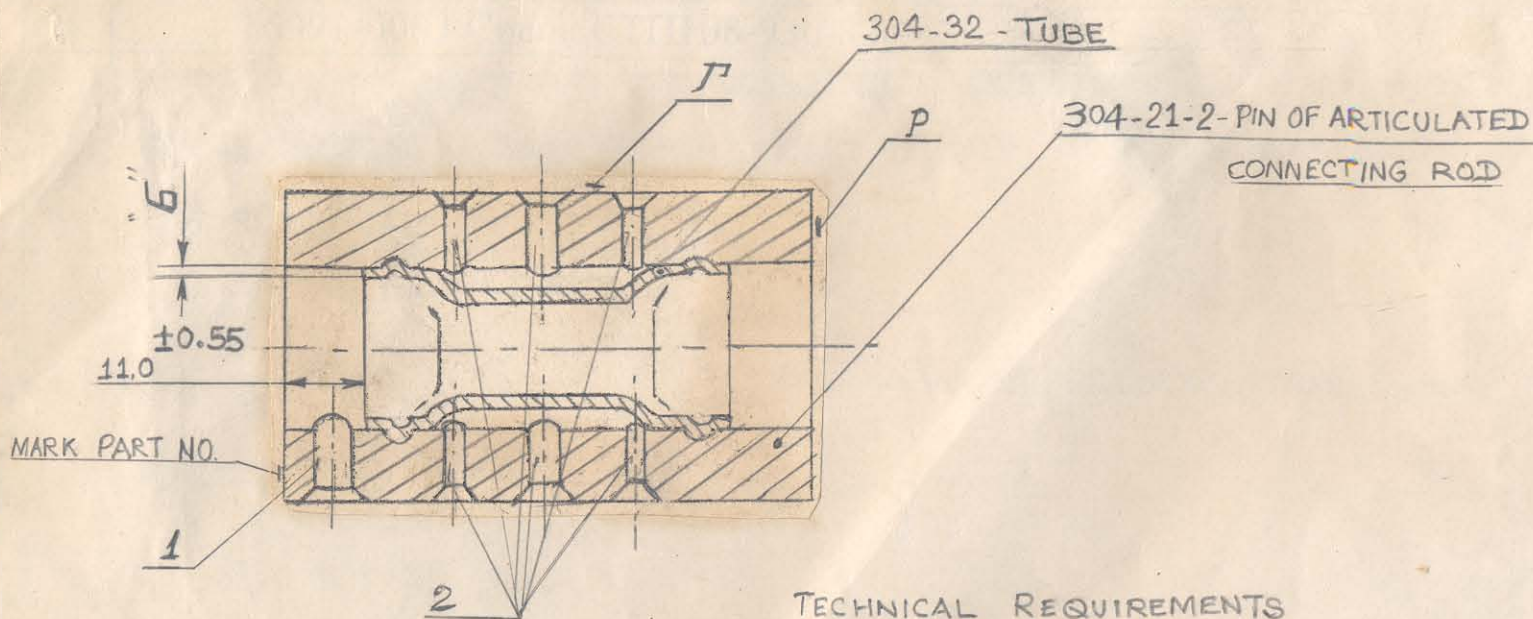


TECHNICAL REQUIREMENTS

1. PRESSURE TEST SPACE "A" WITH MIXTURE COMPOSED OF 1 PART OF OIL, USED FOR FILLING OIL SYSTEM OF ENGINE AND 2 PARTS OF FUEL FOR FAST RUNNING DIESEL ENGINES (REF. GOST 4749-73) AT A PRESSURE OF  $5 \pm 1 \text{ kgf/cm}^2$  AND AT A TEMPERATURE OF THE PREMISES NOT LESS THAN  $15^\circ\text{C}$  FOR 1 MINUTE.
2. OIL LEAKAGE IS NOT ALLOWED WHILE PRESSURE TESTING.
3. PARTS SHOULD BE PACKED IN SPECIAL CONTAINER AFTER FINISHING OPERATION.

PLANNING SHEET - P & T / LEP

MV	<i>[Signature]</i>	<i>[Signature]</i>
PRED.	CHD.	APPD



TECHNICAL REQUIREMENTS

1. OVER LAPPING OF HOLES ① AND ② BY TUBE 304-32 IS NOT ALLOWED.
2. DINTS, NOTCHES, DENTS AND OTHER DAMAGES ON SURFACES "J" ARE NOT ALLOWED.
3. CYLINDRICAL PORTIONS OF TUBE END ARE TO BE SEALED. DIMENSION "B" SHOULD NOT BE NOT LESS THAN 0.6 mm.

NOTE:

1. DO NOT TOUCH THE PARTS WITH BARE HANDS. USE COTTON GLOVES OR CLOTH OR PARAFFINED PAPER.
2. PARTS SHOULD BE PACKED IN A SPECIAL CONTAINER AFTER FINISHING OPERATION.

MACHINE:

STD. TOOLS & GAUGES

SPECIAL TOOLS & GAUGES

SPECIAL CONTAINER

MV	PP	APPD
PRED.	CHD.	APPD

MACHINE:

### PRESERVATION

STD. TOOLS & GAUGES

1. PRESERVATION SHOULD BE CARRIED OUT IN ACCORDANCE WITH THE INSTRUCTIONS UUL-352-78.

2. DO NOT TOUCH THE PARTS PREPARED FOR PRESERVATION WITH BARE HANDS. USE HAND GLOVES.

3. PRESERVATION WITH CORROSION TRACES ARE NOT ALLOWED.

SPECIAL TOOLS & GAUGES

4. PRESERVATION OF PARTS IS TO BE CARRIED OUT ON THE CLEAN BENCH PLATED WITH ALUMINIUM.

5. ANTI-CORROSIVE SHOULD BE TAKEN TO PREVENT CORROSION.

PLANNING SHEET - P & IE / LEP

MV	<i>[Signature]</i>	<i>[Signature]</i>
PRED.	CHD.	APPD