

DRAWING NUMBER
413-33-2

Rz 20/ (✓)

EXPLANATORY NOTE:

REFERENCE MATERIAL QUOTED:

6. CARBON STRUCTURAL, HOT ROLLED STEEL, GRADE 15 AND REFERENCE NOTE 1 ON ALTERNATE MATERIAL STEEL GRADE 20 TO GOST 1050-74.

a) CHEMICAL COMPOSITION:

GRADE OF STEEL	CONTENT OF ELEMENTS %						REMARKS
	C	Si	Mn	Cr	S	P	
15	0.12	0.17	0.35	0.25	0.040	0.035	REF. MATL
	0.19	0.37	0.65				
20	0.17	0.17	0.35	0.25	0.040	0.035	ALT. MATL
	0.24	0.37	0.65				

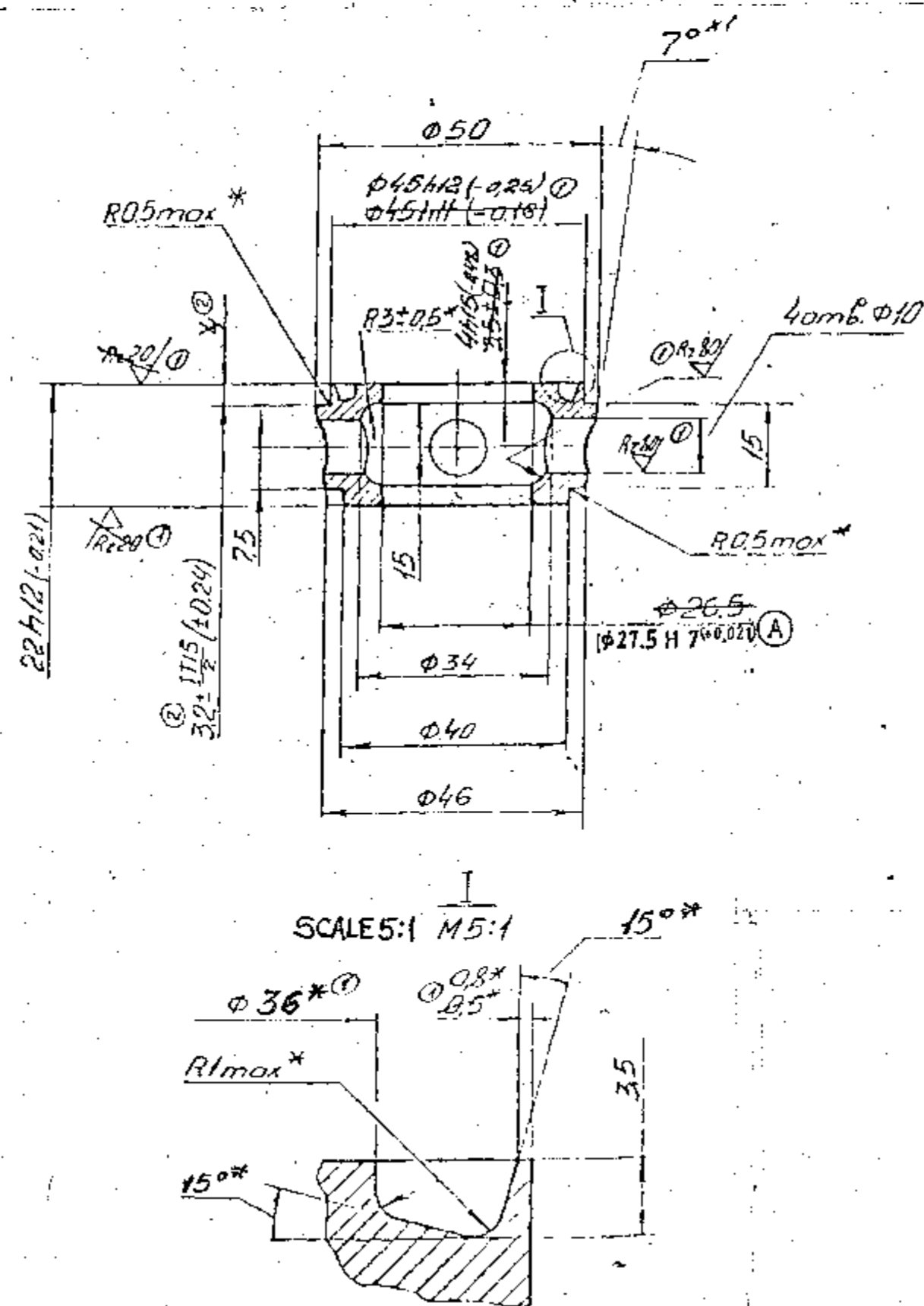
RESIDUAL CONTENTS OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH.

b) MECHANICAL PROPERTIES AS PER NORMALISED CONDITION.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kg/mm ²	YIELD POINT Kg/mm ²	ELONGATION %	REDUCTION IN AREA %	HARDNESS B H N	REMARKS
15	38	23	27	55	149	Ref, Matl
20	42	25	25	55	163	Alt, Matl

1. Заменитель материала сталь 20 ГОСТ 1050-74.
 2. Неуказанные предельные отклонения размеров отверстий по H14, валов по h14, остальных по IT14.
 3. Клеить окончательную приемку на бирке для партии деталей.
 4. * Размеры обеспечиваются инструментом.
 5. * Размер для справок.

1. ALTERNATE MATERIAL: STEEL 20 GOST 1050-74.
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS OF HOLES AS PER H14, OF SHAFTS AS PER h14, OF THE REST OF DIMENSION $\pm IT 14$.
3. MARK OF FINAL ACCEPTANCE SHOULD BE PUT ON TAG FOR BATCH OF COMPONENTS.
4. * DIMENSIONS ARE TO BE ENSURED BY TOOL.
5. *1 DIMENSION FOR REFERENCE.
6. * DIMENSION PUT IN BRACKETS AFTER ASSEMBLY.



SCALE 5:1 M5:1

ORG. (UN)ANISED BASED ON RUSSIAN ORIGINAL ISSUE - 3

A 6
SIZE A2

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

EST. MASS 0.14 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

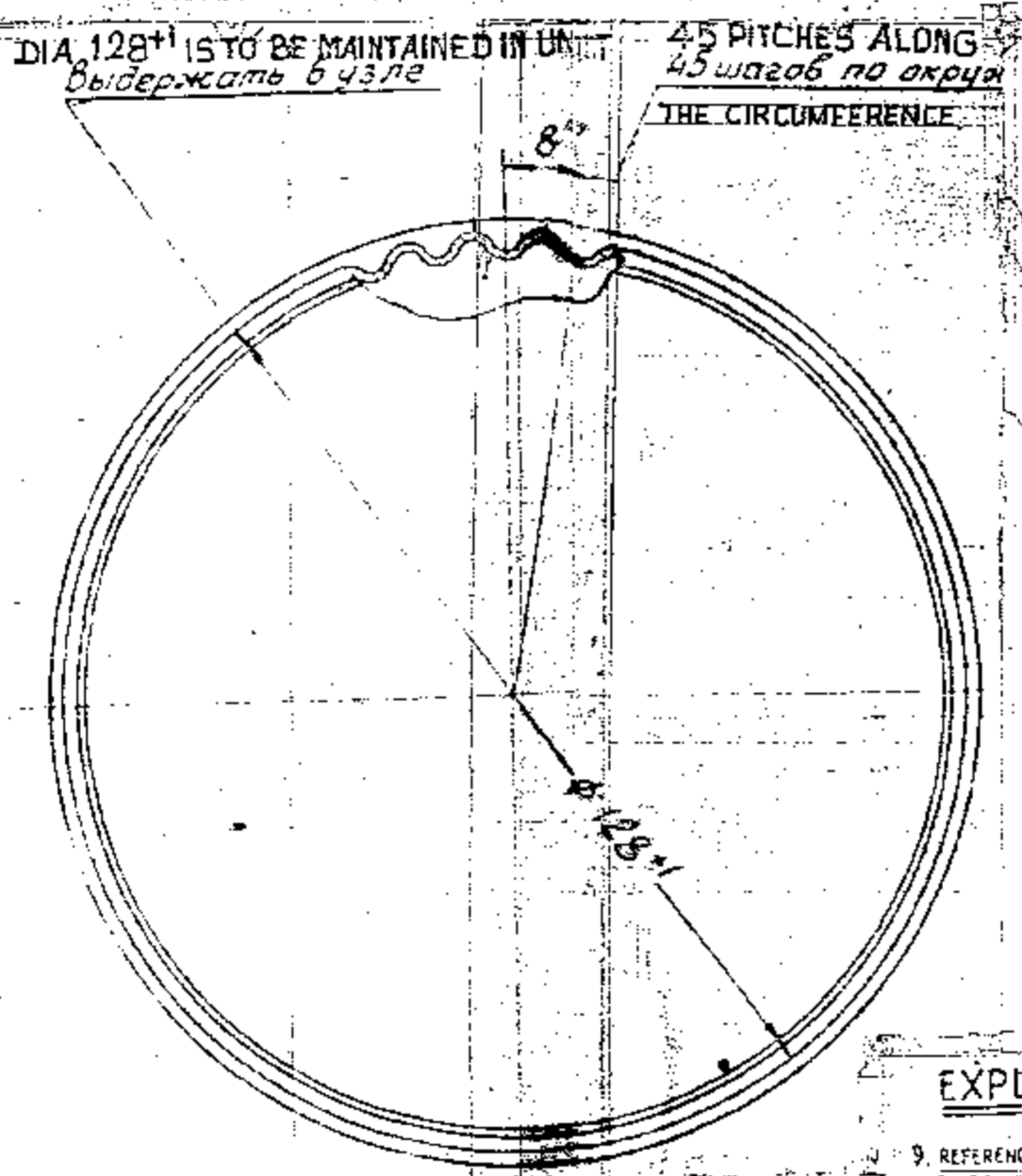
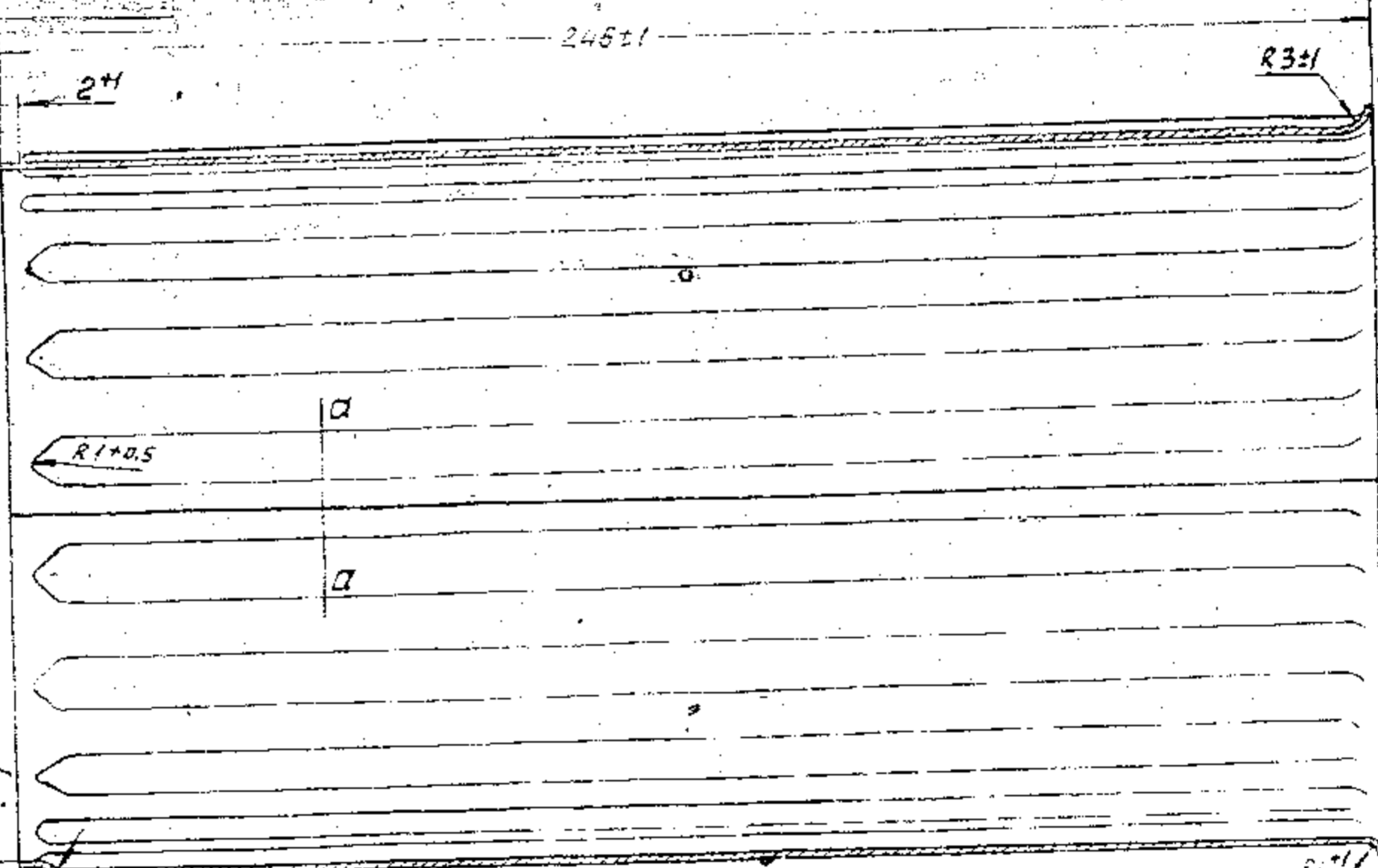
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	TCD	APPD	DATE	SCALE - 1:1	MATERIAL -	USED ON -
				19-5-86		STEEL 15 GOST 1050-74	CG 413-8-1 CG 413-11-1 CG 413-12-1
DIMENSIONS IN mm.						CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.						TITLE -	
ALL THREADS CONFORM TO						SEALING BUSH	
A 20.9.89 AUTHY. BK 84-802.						D S CAT NUMBER	
ISSUE DATE NATURE OF AMENDMENTS						DRAWING NUMBER	
						413-33-2	

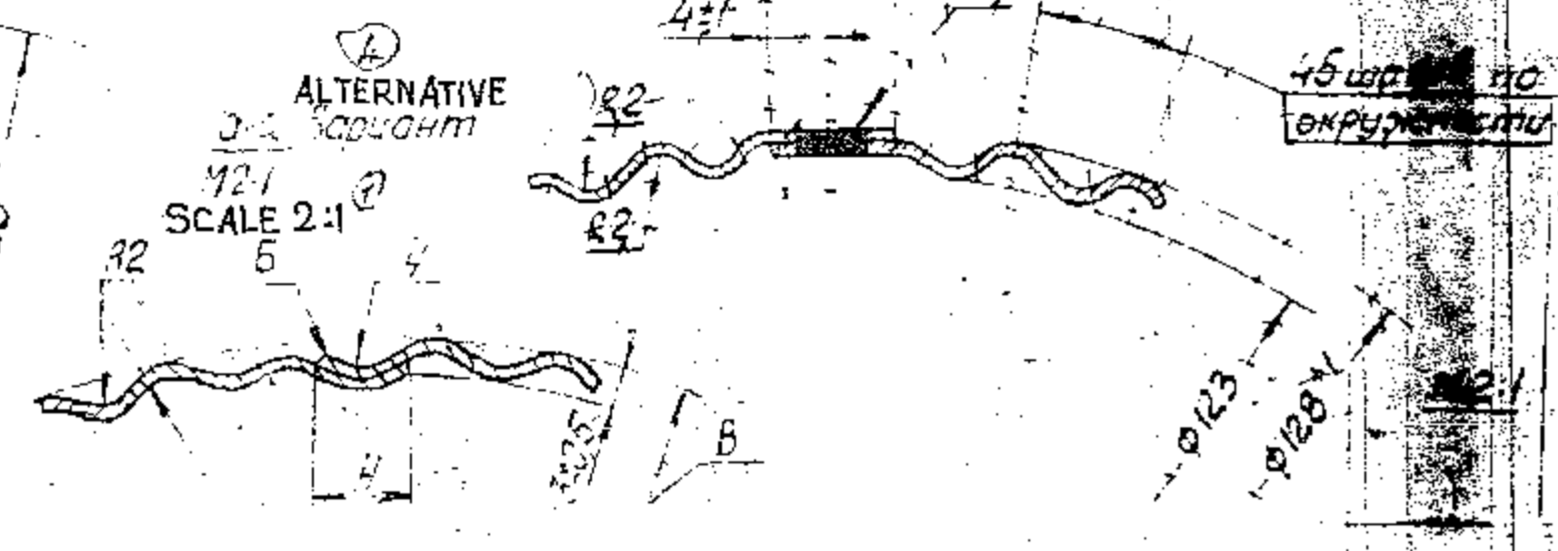
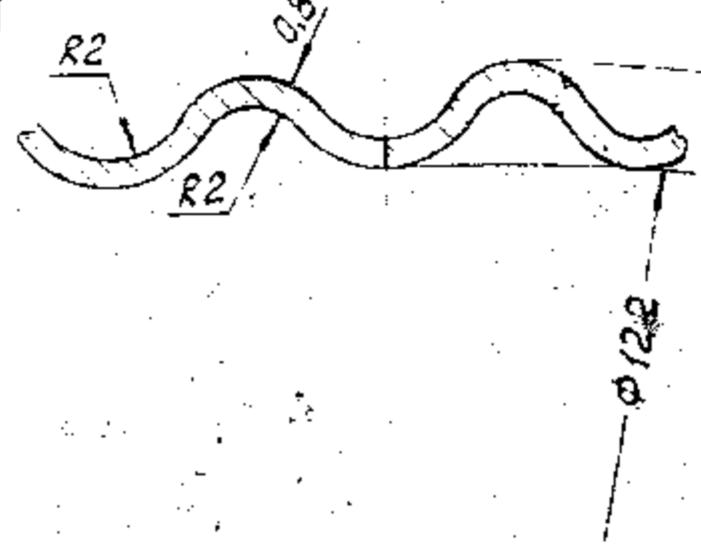


DRAWING NUMBER
413-35

DIA 122 IS TO BE MAINTAINED ON LENGTH OF 244 mm. DIA 122 IS TO BE MAINTAINED ON LENGTH OF 244 mm. DIA 122 IS TO BE ADJUSTED TO SUIT THE DIAMETER OF THE COVER. DIA 122 IS TO BE MAINTAINED ON LENGTH OF 244 mm.



SECTIONAL VIEW
Сеченье по АА
M 5:1
SCALE 5:1



EXPLANATORY NOTE

9. REFERENCE MATERIAL QUOTED COLD ROLLED SHEET STEEL, HIGH ACCURACY ROLLING 4.0mm THICK TO GOST 19904-74, AND HIGH SURFACE FINISH TYPE EXTREMELY DEEP DRAWING TYPE AND MANUFACTURED IN ACCORDANCE WITH COLD-ROLLED THIN SHEET STEEL JIS G3033 TO GOST 9045-80

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C	Mn	S	P	Si	Cr	Ni	Cu
08kn	0.10	0.20-0.40	0.030	0.025	0.03	0.10	0.10	0.15

CATEGORY	GRADE OF STEEL	MECHANICAL PROPERTIES	
		ULTIMATE TENSILE STRENGTH Kgf/mm ²	ELONGATION % min.
BT	08kn	26-37	28

10. REFERENCE NOTE 6 ON ALTERNATE MATERIAL QUALITY CARBON STEEL COLD ROLLED GRADES 08kn, 10 AND 10kn TO GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL 1050-74.

GRADE OF STEEL	CONTENT OF ELEMENTS %					
	C	Si	Mn	Cr	S	P
08kn	0.05-0.11	0.05-0.17	0.35-0.65	0.10	0.040	0.035
10	0.07-0.14	0.17-0.37	0.35-0.65	0.15	0.040	0.035
10kn	0.07-0.14	0.07 max	0.25-0.50	0.15	0.040	0.035

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0.25% EACH. MANGANESE CONTENT UP TO 0.25% AS REGARDS LOWER LIMIT, IS ALLOWED IN THE STEEL OF GRADE 08kn MEANT FOR PRODUCTION OF SHEET STEEL FOR COILING.

GRADE OF STEEL	MECHANICAL PROPERTIES AS PER GOST 16523-70	
	ULTIMATE TENSILE STRENGTH Kgf/mm ²	ELONGATION % min.
08kn	28-40	25
10	30-42	25
10kn	28-40	25

- DIMENSIONS WITH UNSPECIFIED TOLERANCES SHOULD BE OBTAINED WITH AN ACCURACY OF ±0.5mm.
- UNSPECIFIED RADII DURING STAMPING SHOULD BE R1±0.5mm.
- COMPONENT SURFACES SHOULD BE CLEAN AND SMOOTH, THE EDGES SHOULD BE FREE FROM FISSURES AND BURRS.
- CRACKS ARE NOT ALLOWED.
- CORRUGATION MAY BE DONE ALONG THE ENTIRE LENGTH OF THE CUP.
- ALTERNATE MATERIAL: STEEL, GRADES 08kn, 10 AND 10kn (RIMMING) GOST 1050-74.
- PROJECTION OF EDGES B BEYOND DIAMETER B IS NOT ALLOWED.
- SEAM RESISTANCE WELDING.

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

EST WT 0.6 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	CHD	TCD	APPD	DATE	SCALE 1:1	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	ALL THREADS CONFORM TO	ISSUE	DATE	NATURE OF AMENDMENTS
				21-5-82							
MATERIAL: SHEET A-0.8 GOST 19904-74						USED ON 06 413-10-1					
IF B 08kn GOST 9045-80											
CONTROLLER RATE OF INSPECTION (HEAVY VEHICLES) AVADI						TITLE					
						BODY CUP FIRST SECTION					
						D S CAT NUMBER		DRAWING NUMBER 413-35			

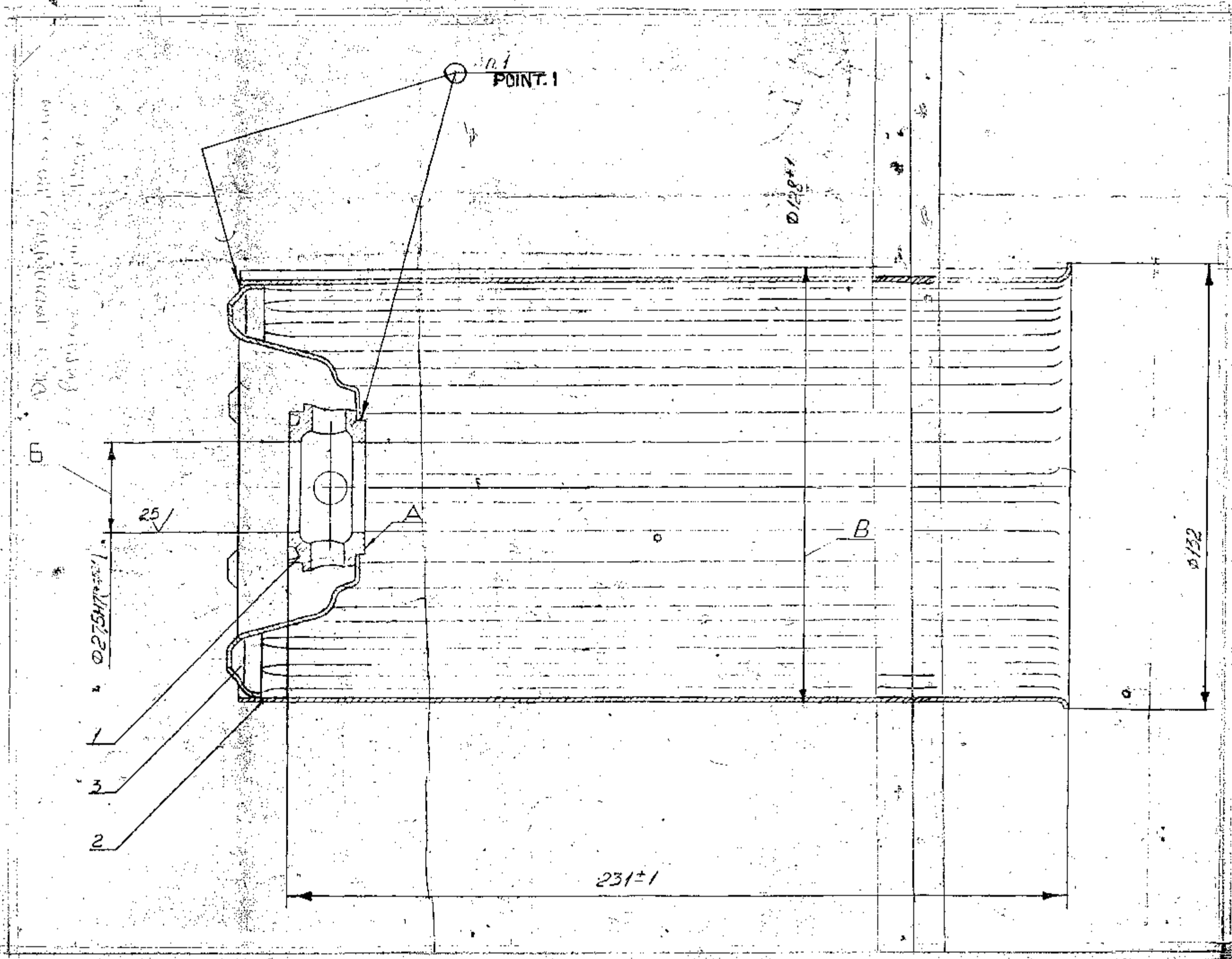
A6

ZE A2





DRAWING NUMBER
 C6 413 10 1C6



1. BRASS 63 GOST 15527-70.
2. COATING: Zn 6. CHROMATIZING AS PER INSTRUCTIONS U.S. 483-82. ASSEMBLY MAY BE PLATED ALONG WITH COMPONENT 313-29 AFTER ITS FLANGING.
3. TRACES FROM DRESSING AS BRAZING ARE ALLOWED ON SURFACE 'A'.
4. LOCAL BUBBLES ARE ALLOWED ALONG LONGITUDINAL SEAM IN THE INNER PART OF THE CUP.
5. LOCAL ABSENCE OF COATING IS ALLOWED IN PLACES OF BRAZING AT BOTTOM AND BODY JOINTS, IN THE DEPRESSION OF CUP BOTTOM ON THE INTERNAL AND EXTERNAL SURFACES.
6. HOLE 'B' SHOULD BE FINALLY TAPPED. THERE MAY BE NO COATING ON THE TAPPED SURFACE.
7. MISALIGNMENT OF HOLE 'B' AND DIAMETER 'B' SHOULD NOT EXCEED 0.2mm (MMC).

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

EST. MASS 0.85 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS # 1 LETTERS)
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ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRW	END	TCB	APPO	DATE	SCALE	TOLERANCE UNLESS OTHERWISE STATED	ALL THREADS CONFORM TO
ISSUE	DATE	NATURE OF AMENDMENTS		D S CAT NUMBER		C6 413 10 1C6	
						TITLE: SUB ASSY FIRST SLOT TYPE FILTERING SECTION	



