



1. Заменитель материала для детали поз. 1 сталь 10 ГОСТ 1050-74.
 2. Шероховатость, подготовку поверхности втулки под заливку и заливку свинцовой бронзы производить по ТТМ 43-77.
 3. Толщина слоя свинцовой бронзы после сборки $0,7 \pm 0,2$ мм.
 4. Допуск размера Δ в пределах одной детали не более 0,2 мм.
 5. Размеры в скобках - после сборки.
 6. Размер для справок.
 7. Клеймить по ИЛ 15-75 расторопн №1 или №3

1. ALTERNATE MATERIAL FOR COMPONENT 1 STEEL 10 GOST 1050-74.
2. ROUGHNESS PREPARATION OF BUSH SURFACE FOR CASTING AND CASTING OF LEADED BRONZE MAY BE CARRIED OUT AS PER TTM 43-77.
3. LEADED BRONZE LAYER THICKNESS AFTER ASSEMBLY $0,7 \text{ mm} \pm 0,2 \text{ mm}$.
4. TOLERANCE ON DIMENSION "A" WITHIN ONE COMPONENT 0,2 mm MAXIMUM.
5. DIMENSIONS IN BRACKETS - AFTER ASSEMBLY.
6. * DIMENSION FOR REFERENCE.
7. ^(A) TO BE STAMPED AS PER ИЛ 16-73 WITH A SOLUTION No. 1 OR No. 3.
^(A) TO MARK BY COMPOUND NTOR N5 AS PER УК-581-85 OR ELECTROCHEMICAL METHOD.
^(B) OIL GROOVE AND OIL HOLES TO BE MACHINED DURING ASSEMBLY

EXPLANATORY NOTE:
MATERIAL QUOTED: STEEL 15 GOST 1050-74 FOR COMPONENT-1.
ALTERNATE MATERIAL QUOTED: STEEL 10 GOST 1050-74 FOR COMPONENT-1.
MATERIAL QUOTED: BRONZE BPC-30 GOST 493-79 FOR COMPONENT-2.
 STEEL 10 & 15 = GRADE OF STEEL
 BPC-30 = GRADE OF BRONZE AS PER GOST 493-79.

a) CHEMICAL COMPOSITION

GRADE OF STEEL	CONTENT OF ELEMENTS %								
	C	Si	Mn	Cr	P	S	Cu	Ni	
10	0.07-0.14	0.17-0.37	0.35-0.65		0.15	0.035	0.040	0.25	0.25
15	0.12-0.19	0.17-0.37	0.35-0.65	0.25	0.035	0.040	0.25	0.25	

b) MECHANICAL PROPERTIES

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ² (min)	YIELDPOINT Kgf/mm ² (min)	% ELONGATION (min)	% REDUCTION IN AREA (MIN)
10	34	21	31	55
15	38	23	27	55

Chemical composition (as per BPC-30 GOST 493-79)
Main component:
 Lead = 270-340
Impurities (maximum)
 copper = remainder silicon = 0.02
 Arsenic = 0.1 nickel = 0.5
 Antimony = 0.3 Phosphorus = 0.1
 Tin = 0.1 iron = 0.25
 Zinc = 0.1 total = 0.9
Mechanical Properties:
 ultimate strength Kgf/mm² = 6 (min)
 Relative elongation % = 4 (min)
 Brinell hardness HB = 245 (min)

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

EST. MASS 0.21 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	TCO	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69	DRN	USED ON
				22-8-88	1:1				MATERIAL: 15 GOST 1050-74, AND BPC-30 GOST 493-79
CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI								TITLE: GEAR UNIT BUSH ASSY	
ALTERATION COMMITTEE MEETING MINUTES POINT No. 4, DATE: 11.04.2012. AUTHY BK 88-226								DRAWING NO. CB-3338-449-1 CB	
ISSUE DATE NATURE OF AMENDMENTS								D.S. CAT NUMBER	