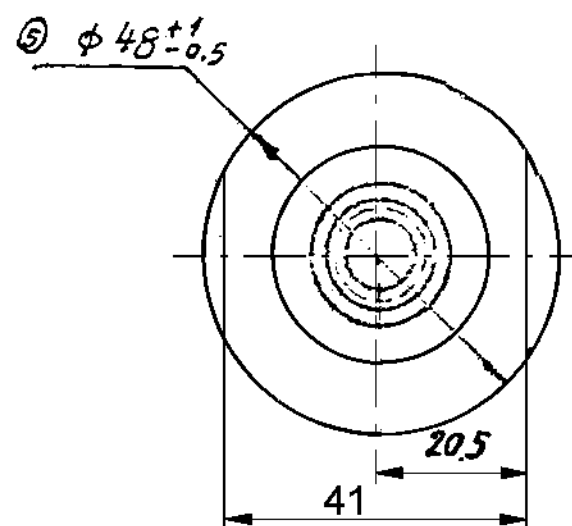
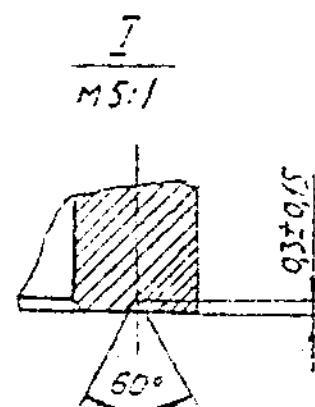
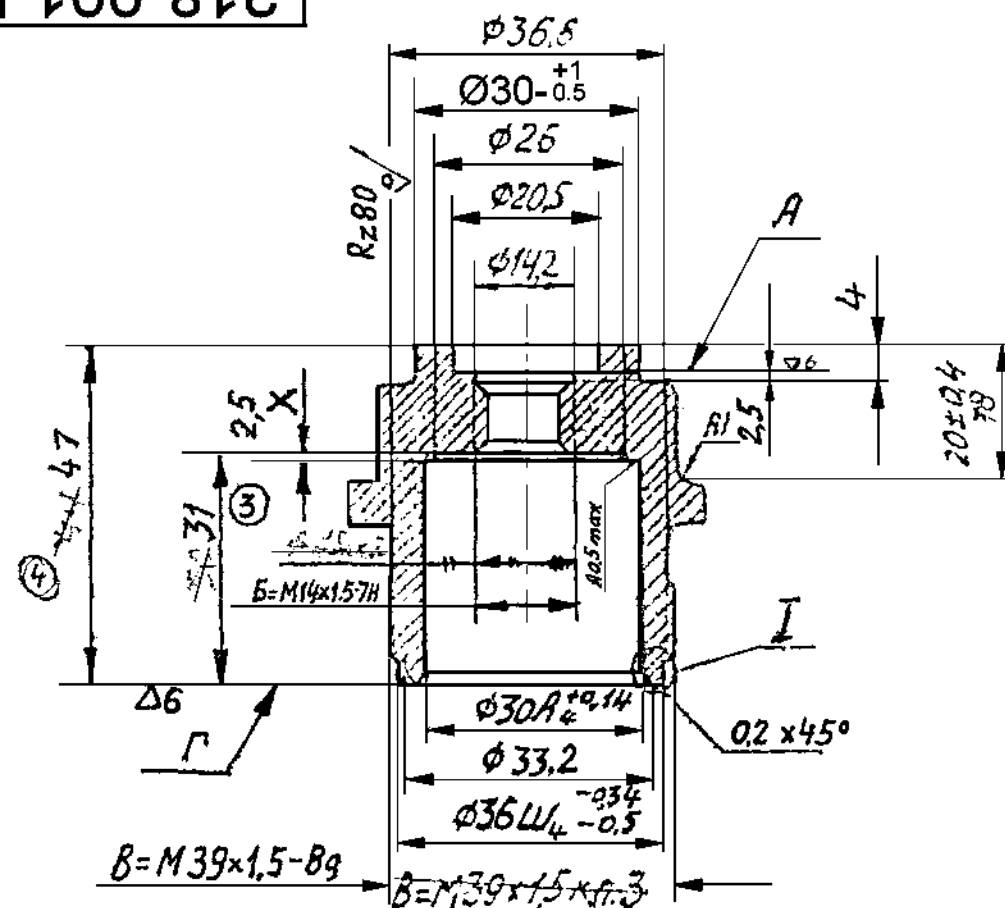


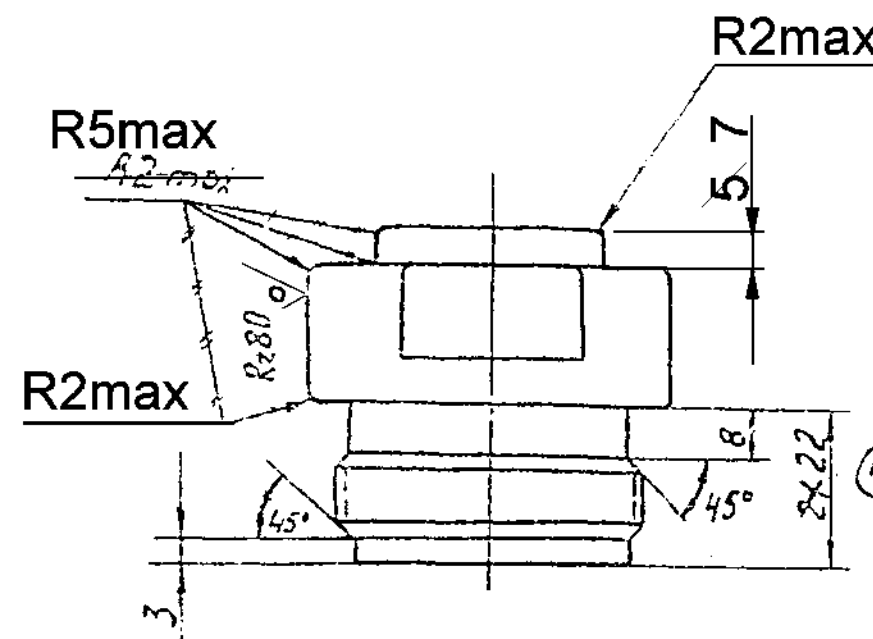
218-001-k

Восстановленный подлинник № 1



TECHNICAL CONDITIONS

1. Blunt sharp edges
2. Chamfer threaded hole up to outside diameter of thread at angle of 90°.
3. Maintain sizes without deviations against finish class 7 OCT 1010.
4. Misalignment of surface A relative to middle diameter of thread B should not exceed 0.05 mm.
5. Misalignment of surface F relative to middle diameter of thread B should not exceed 0.05 mm.



6. Coating: anodic oxidation with bichromate treatment. It is allowed to make chemical phosphatizing, blue.
7. Defects up to 0.3 mm on surfaces which are not machined are permissible.

(A) EQ. MATERIAL: AL. ALLOY FORGING GRADE 24534 (W) TO IS: 734-75

00940-ICV
22 JUL 02
DC(I)No.
& DATE

(A)

EQ. MATERIAL ADDED.

ISSUE

AMENDMENTS

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

218-001-k

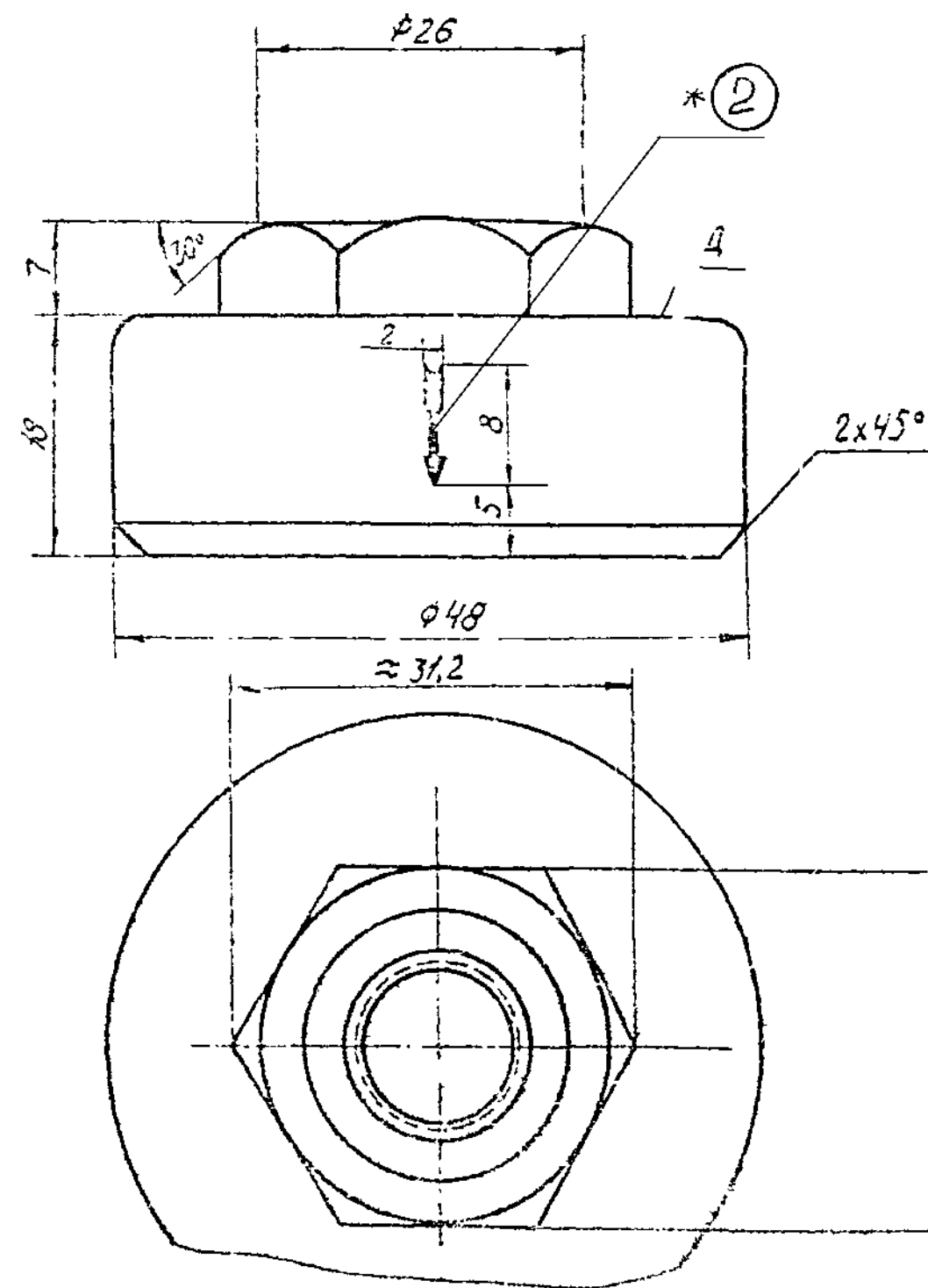
CASING

Д16 Т GOST 4784-74

WEIGHT SCALE

0.09 1:1

SHT SHTS

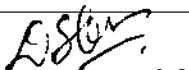


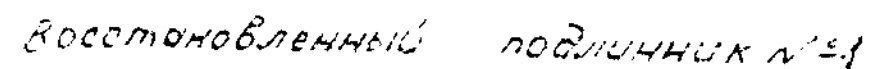
- * (1) 1. Blunt sharp edges.
- 2. Maintain sizes without deviations against finish class 7 OCT 1010.
- (1) 3. Misalignment of surface A relative to middle diameter of thread B should not exceed 0.05 mm.
- 4. Misalignment of surface B relative to middle diameter of thread T should not exceed 0.05 mm.
- 5. Cuts up to 0.3 mm, maximum, on surface A are permissible.
- 6. Coating: anodic oxidation with bichromate treatment.

It is allowed to make chemical phosphatizing, blue.

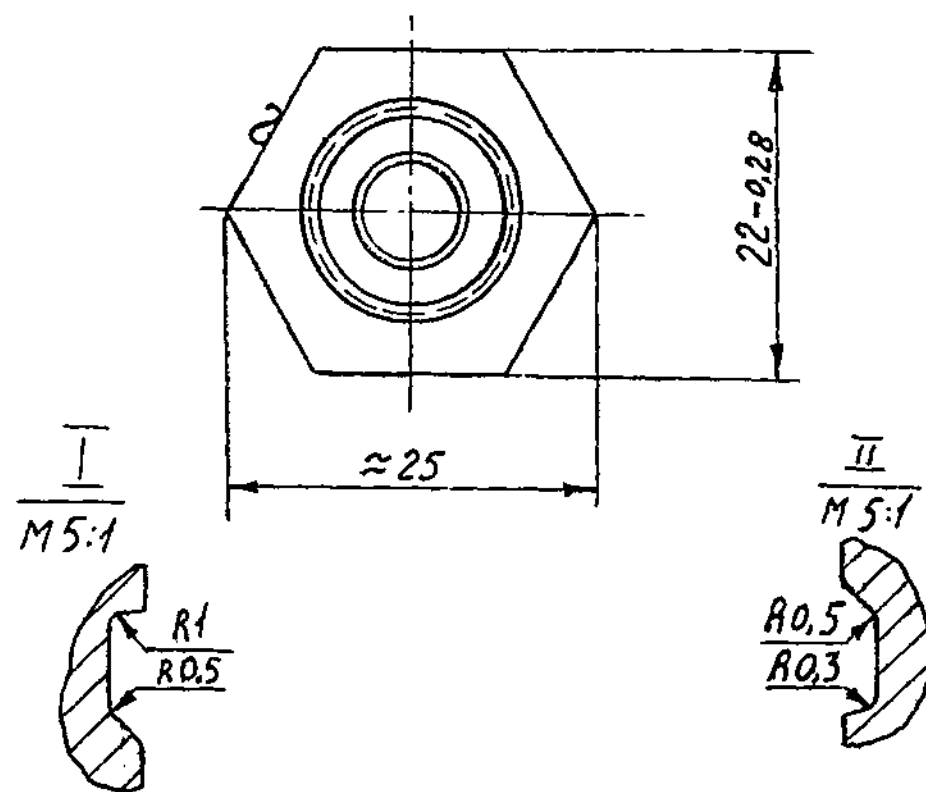
* (2) **Emboss** or engrave arrow to depth of 0.5 mm. It is allowed to stamp arrow at height of up to 1 mm above part body.

④ EQ. MATERIAL : ALUMINIUM ALLOY FORGING GRADE 24534 (W) TO IS: 734-75

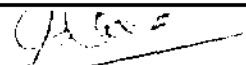
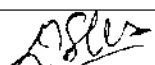
APPROVED		218-002A-K			
CHECKED		COVER		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				0.05	2:1
			SHT	SHTS	
		Д 16Т ГОСТ 4784-74			

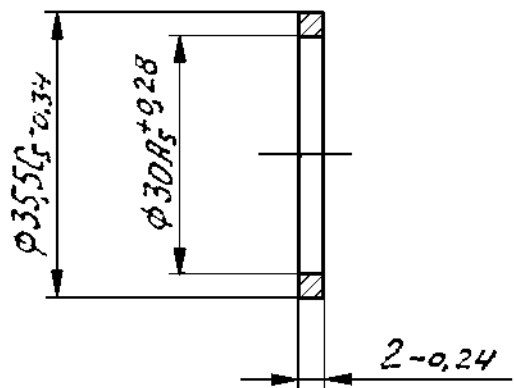


- ① EQ. MATERIAL : STEEL BLACK BAR GRADE C45 TO IS:2073-70



00940-ICV <i>Sh</i>	(A) <i>Bray</i>	EQ. MATERIAL ADDED.
270 JUL 02	DC(I) No. & DATE	AMENDMENTS

APPROVED		218-004A-K			
CHECKED		CONNECTION		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				0.035	2:1
			SHT SHTS		
		STEEL 45 GOST 1050-74			

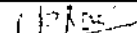


TECHNICAL CONDITIONS

1. Burrs are not permissible

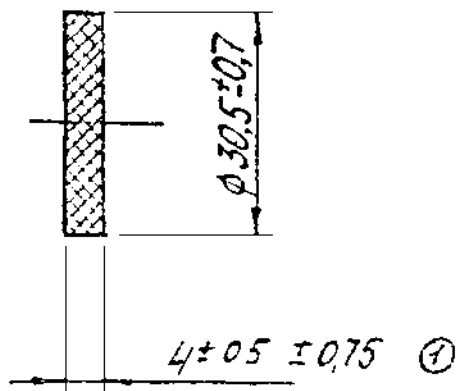
(A) EQ.MATERIAL : SHEET ALUMINIUM 2mm THICK (ANNEALED)
GRADE 19500 TO IS: 737-74.

00940-ICV <i>Shh</i> 22 JUL 02 DC(T)No. & DATE	(A) <i>Bozh</i> ISSUE	EQ. MATERIAL ADDED.
		AMENDMENTS

APPROVED		218-006-K			
CHECKED					
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		GASKET		WEIGHT	SCALE
				0.0013	1:1
			SHT	SHTS	

218-007-K

Восстановленный подлинник № 1



APPROVED

[Signature]

CHECKED

[Signature]

218-007-K

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

FILTER

WEIGHT

SCALE

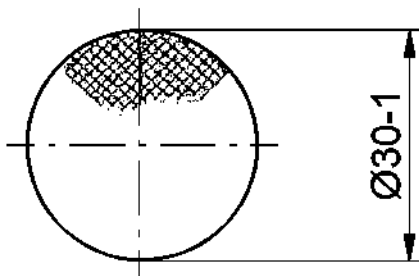
0.0025

1:1

SHT

SHTS

FELT TØ4 GOST 288-72



1 Допускается выпадение крайних элементов не более 1 шт. с каждой стороны.

TECHNICAL CONDITIONS

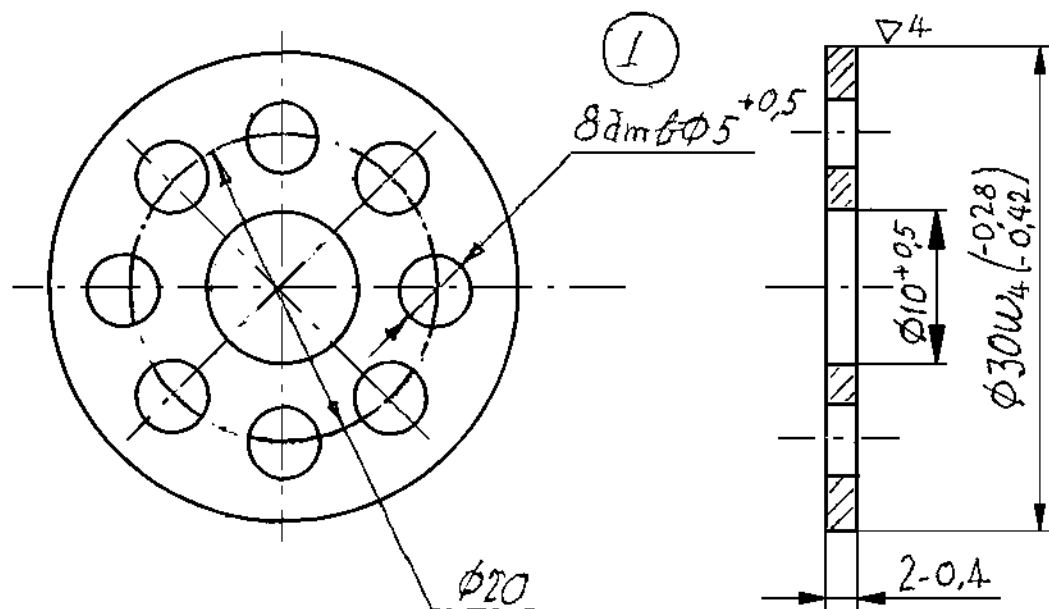
(1) Fall out of outer wires of not more than 1 pc from each side is allowed.

(A) EQ. MATERIAL : BRASS WIRE CLOTH Cu 70 Zn 30 TO IS:2405-80, WIRE ϕ 0.28mm APERTURE SIZE 0.71mm.

00940-ICV <i>File</i> 22 JUL 02 DC(I)No. & DATE	(A) <i>Barry</i> ISSUE	EQ. MATERIAL ADDED.
AMENDMENTS		

APPROVED	<i>[Signature]</i>	218-008-K		
CHECKED	<i>[Signature]</i>			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	STRAINER		WEIGHT	SCALE
			0.0035	1:1
		SHT	SHTS	
Low-brass net 07 GOST 6613-73				

218-009-K



* ②

TECHNICAL CONDITIONS

* (1) Eight holes, dia. $5^{+0.5}$

* (2) 1. Misalignment of axes of holes from nominal position should not exceed 0.5 mm.

2. Coating: anodic oxidation.

(A) EQ. MATERIAL: ALUMINIUM SHEET GRADE 55000 TO IS: 737-44
CLADED WITH ALUMINIUM AS PER IS: 8560.

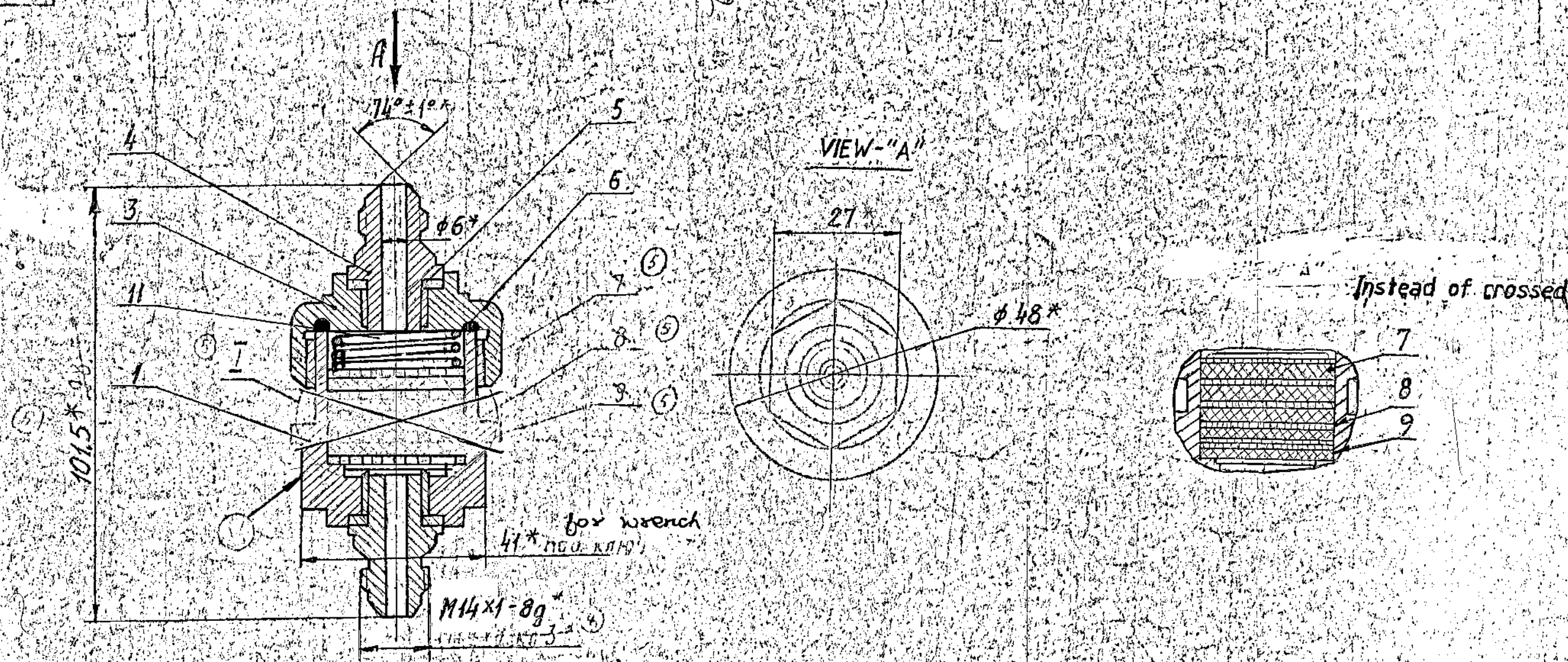
00940-ICV \$H	②	EQ. MATERIAL ADDED
22-07-02	BOA	
DC(1) No.	ISSUE	NATURE OF AMENDMENTS
DATE		

MATERIAL :- SHEET AMF-66M GOST-21631-76

ALL SHARP EDGES & CORNERS TO BE BOUNDED CP	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO.
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	MANUFACTURERS NAME & YEAR OF MFR.
SCALE :- 2:1		USED ON:-
DATE :- 19-06-95		
DRN. M. H. S.	WT :- (Kg)	
TCD. M. H. S.	0.003	
CHD. M. H. S.		
APD. M. H. S.		
	GRID	
	218-009-K	

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

218-K



1. Lubricate the threaded joints of parts 216-001-K, 218-004A-K & face of the part 218-006-K with lubricant ЦИАТИМ-201 GOST 6267-74 or similar as per TY38.YCCP 201-285-82.

2. Test the air filter for air tightness by blowing air from the side as indicated by the arrow at pressure $150 \pm 10 \text{ kg/cm}^2$ in the bath, containing 0.5% chromesolution, for two minutes. Air bubbles are not allowed. After testing, cover the pipe connections with plug 672-78-80.

3. Mark the conventional ordinal number & letter on filter. It is allowed to mark on the part 218-001-K. Letters are as per 2.5 GOST 2930-62.

4. Supply the filter in compliance with TECHNICAL SPECIFICATIONS TY 218-K.

5.*Dimensions are given for reference.

KVD
65900

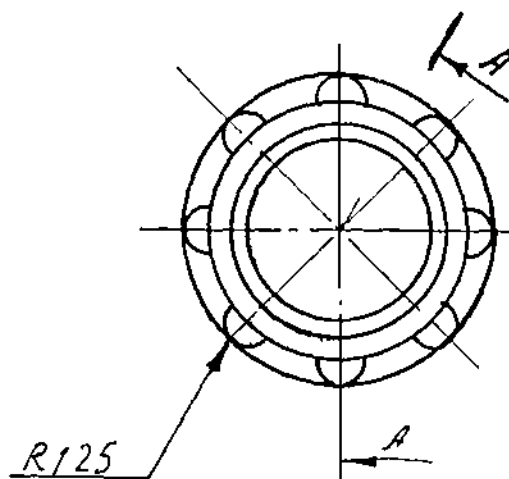
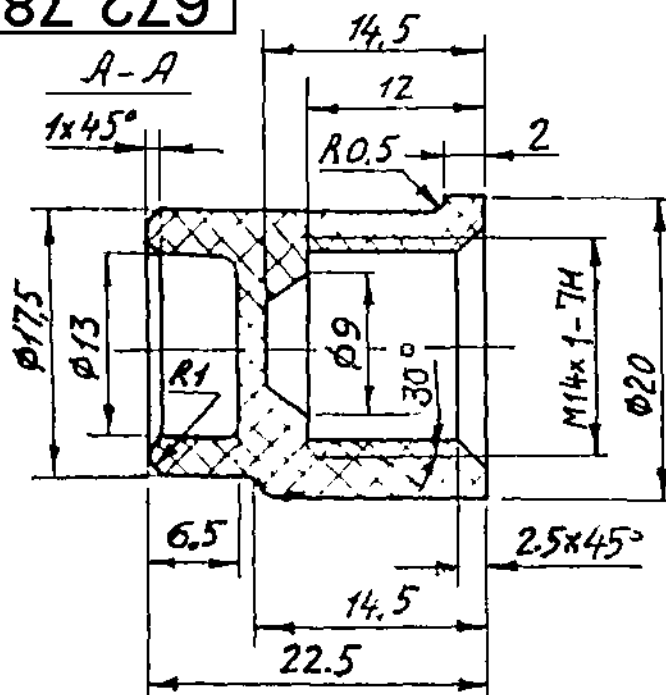
01023-ICV	(A)	DS CAT NO. ADDED AND NOMENCLATURE WAS 'AIR FILTER'
26-06-06		
DC(2) NO	ISSUE	NATURE OF AMENDMENT
DATE		

5	700-40-196	Gasket	2	
	672-78-80	Plug	2	While delivering unit
	LV2/ICVS. 3340 159767	STOPPER SPECIAL (-R&F, DC(2) NO. 01047-ICV)		for store
11	PC-2x29x18	Spring	1	Standard, 65 AH-72
10				
9	218-009-K	Grill	1	
8	218-008-K	STRAINER	6	
7	218-007-K	Filter	4	
6	218-006-K	Gasket	1	
4	218-004A-K	Pipe connections	2	
3	218-002A-K	Cover	1	
2				
1	218-001-K	CASING	1	
Ref. No.	Designation	Description	Qty.	Remarks

MATERIAL		
ALL SHARP EDGES & CORNERS TO BE BOUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-
SCALE :- 1		765-78-C66
DATE :- 20-6-95		
DRN. VDR	WT :- (Kg)	
TCD		
CHD. 100		
APD. 100		
	(A)	218-K
	DS CAT PART No. LV2/ICVS. 2940-003789	
	FILTER AIR INTAKE	AIR FILTER (A)

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

08-82-729



1. Shrinkage cavities, cavities, cold joint and short-runs are not allowed
2. Unspecified limit deviations of dimensions are as follows for holes-as per A7, for shafts-as per B7, for others as per $\pm 1/2$ of tolerance class B.
3. Unspecified radii should not exceed 2 mm.
4. Drafts should not exceed 2°
5. Fin, along the parting lines of mould should not exceed 0.3 mm.
6. Plug may be made from polyethylene of different colours, grades and secondary polyethylene.
7. Foreign inclusions and hue are allowed
8. Dimensions except for thread are given for tool.

01047-ICV

18-04-07

DC(I)No.
& DATE

(A)

ISSUE

DS CAT PART No. ADDED
AND NOMENCLATURE
WAS "PLUG".

AMENDMENTS

APPROVED

H VASU

CHECKED

ZSC

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

672-78-80

~~PLUG~~ (A)
STOPPER SPECIAL

POLYTHYLENE 21006-075
GRADE-i, GOST 16338-77

DS CAT PART No. (A)
LV2/ICVs 5340-159767

WEIGHT

SCALE

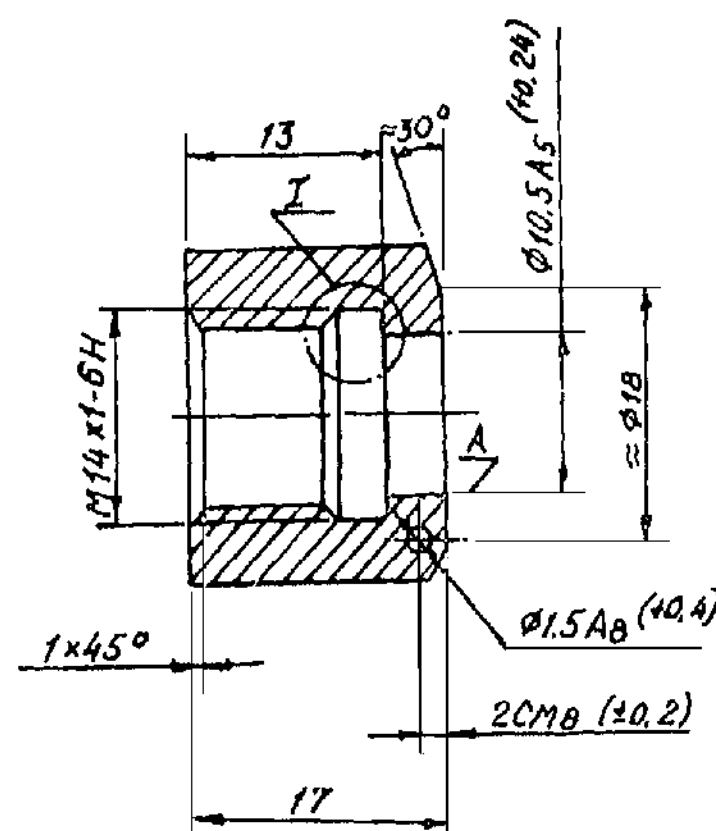
0.005

2:1

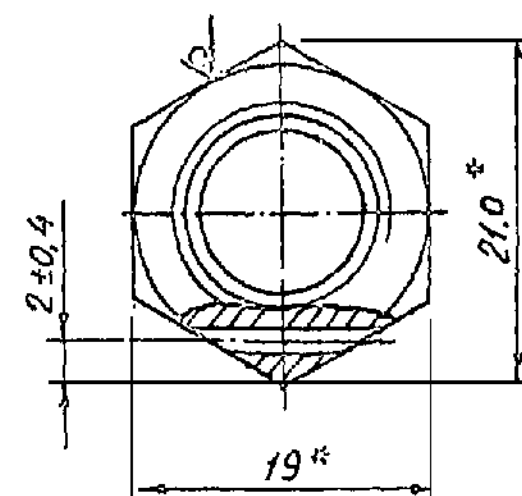
SHT 1 SHTS 1

TECHNICAL CONDITIONS

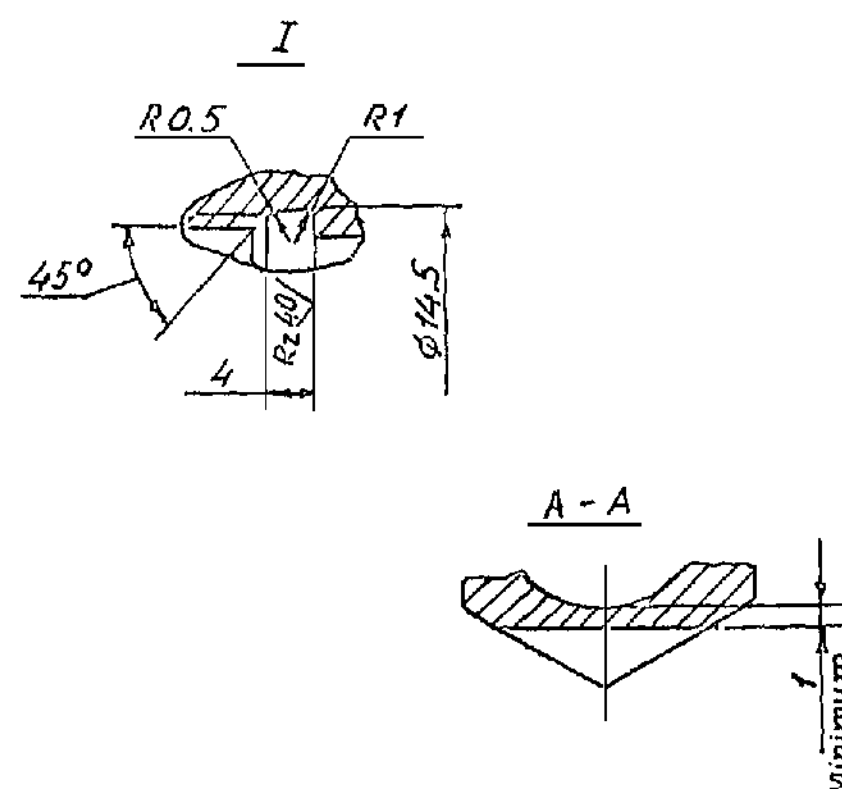
1. ALTERNATE MATERIAL IS STEEL 25, 30, 35 AND 40 GOST 1050 - 74
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS :
FOR HOLES - AS PER A7, FOR SHAFT - AS PER B7 AND FOR THE REST
AS PER CM7
3. DISPLACEMENT OF SURFACE 'A' WITH RESPECT TO THREAD SHOULD
NOT EXCEED 0.2 MM.
4. * DIMENSIONS ARE GIVEN FOR REFERENCE.
5. COATING ZINC - PLATED, 9 MICRONS THICK CHROMATIZED, REMOVE
HYDROGEN EMBRITTLEMENT COATING ON INTERNAL SURFACE NEED
NOT BE CHECKED.
6. ROD WITH MINIMUM DIAMETER OF 1 MM SHOULD PASS THROUGH
HOLE 5



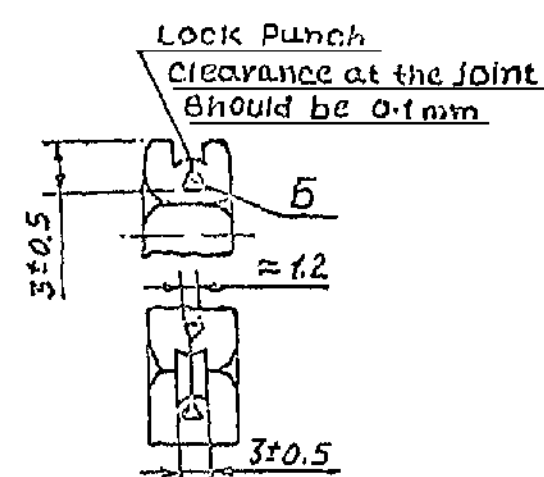
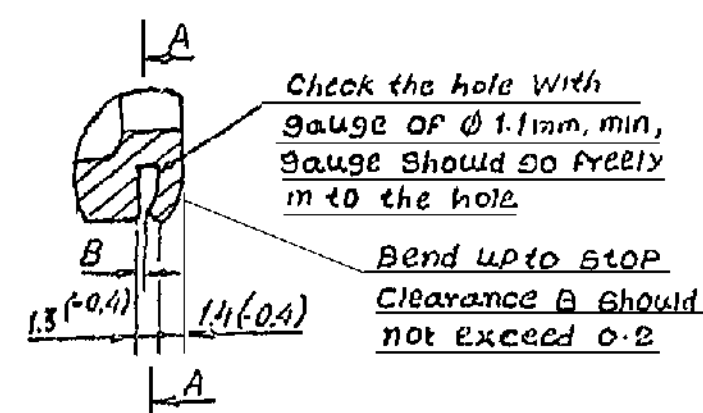
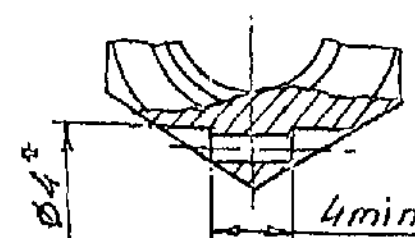
ALTERNATE-1



ALTERNATE-2



ALTERNATE-3

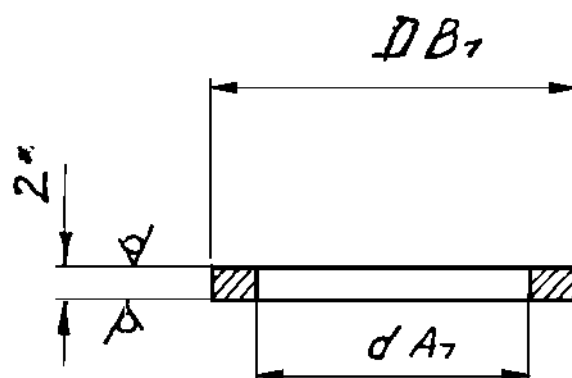


EQUIVALENT MATERIAL - IS 45 C8 Gr 2 to IS 9550 - 80

EQUIVALENT MATERIAL - CLASS 4 TO IS . 2004 - 78

EQUIVALENT MATERIAL :- (a) STEEL BAR C45 TO IS : 2073 - 70
OR EN 8 TO BS . 970 OR EN - 8 / EN 9.EQUIVALENT MATERIAL - CARBON STEEL C 50, C 40, C 30, C 25 TO
IS 1570 - 61

NEAREST EQ. MATERIAL		00951-JCV	④	DRAWING REVISED & RETRACED.
HEXAGON BAR 19.5, GOST 8560-78 45-B, GOST 1051-73		18-11-02 DC(I) No. & DATE		
ORGL MATERIAL:-		ISSUE	AMENDMENTS	
ALL SHARF EDGES & CORNERS TO BE ROUNDED OFF		ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART No. MANUFACTURER's NAME & YEAR OF MFR.	
DRG. NOT TO BE SCALED				
SCALE: 2:1		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:	
DATE : 18-11-02				
DRN. MS hds	WT :- (Kg)	700-30-241		
TCD. MS hds	0.023			
CHD. MS hds		UNION NUT		
APPD. MS hds				
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				



- 1) Notches and nicks are not allowed, on faces
- 2) * Dimensions are given for reference
- 3) Equivalent material: Aluminium alloy sheet
 - Ⓐ Grade 19500 condition O to IS 737-74.
 - Ⓒ EQ. MATERIAL: GRADE-19800 TO IS: 737-74.

00898-ICV 21 AUG 01 w.r. 24.1 Gur	Ⓒ	EQ. MATERIAL ADDED. FOR 700-40-196
00800-ICV 01 AUG 00 v. Ramo Gur	Ⓑ	DS CAT NUMBER ADDED.
00455-ICV 24 AUG 94 Bm Jr	Ⓐ	NOTE No.3 FOR EQUIVALENT MATERIAL ADDED.
DC(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED

M. VASU

CHECKED

A. RAO
DSKUMAR

700-40-196/203

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

GASKET

STEEL A4 1M
GOST 21631-76

WEIGHT

SCALE

SEE
TABLE

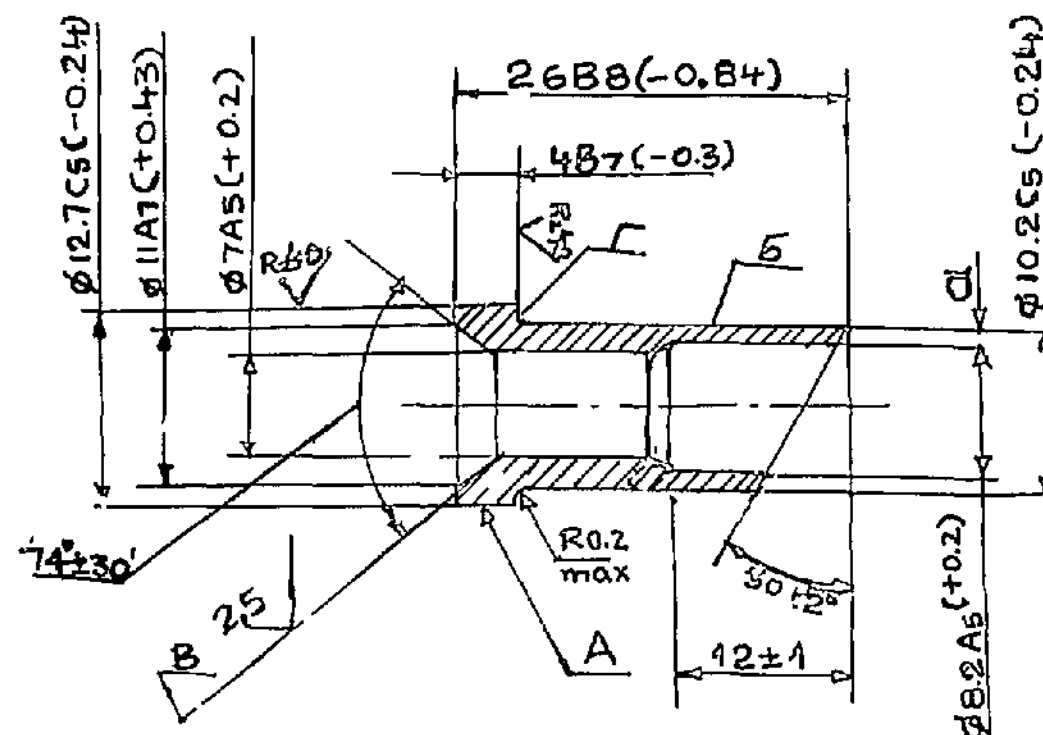
1:1

SHT

SHTS

700-57-403

Rz80 (✓)



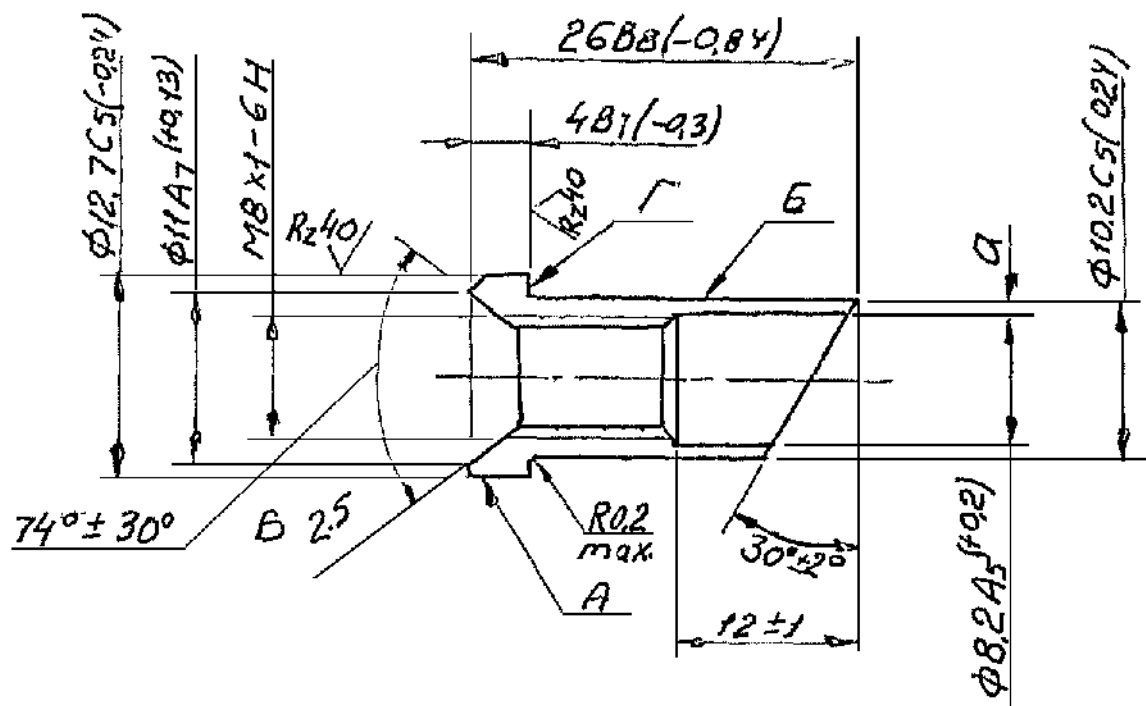
1. ALTERNATE MATERIAL IS STEEL 15, 20, 25 GOST 1050 -74 AND 15Г, 20Г GOST 4543 -71.
2. THE FOLLOWING ARE ALLOWED WITH RESPECT TO SURFACES A AND B MACHINED FROM ONE SETTING.
 - a). RADIAL RUN - OUT OF SURFACE B SHOULD NOT EXCEED 0.15 mm. (QUALIFIED TOLERANCE)
 - b). END - PLAY OF SURFACE 'Г' SHOULD NOT EXCEED 0.06 mm
3. DIFFERENCE IN MEASUREMENTS OF DIMENSIONS 'α' SHOULD NOT EXCEED 0.2 mm.

EQ. MATERIAL :-

- i) STEEL TO IS: 7283-74 (MATERIAL AS PER IS : 226-75)
- ii) MATERIAL 10 C4 TO IS: 9550-80 Gr I OR
- iii) CLASS I A GRADE 15 C8 TO IS, 2004 - 78 OR
- iv) STEEL BAR C10 OR C14 OR C15 Mn 75 OR C20 OR C25 Mn 75 OR C30 TO IS: 2073 - 70. OR
- v) STEEL BAR C14 TO IS: 2073 - 70. OR
- vi) STEEL BAR C15 Mn 75, C20 TO IS: 2073 - 70. OR
- vii) STEEL BAR C25 Mn 75, C30 TO IS: 2073 - 70

00883-ICV		DRAWING REVISED AND RETRACED	
01-06-2001		AMENDMENTS	
ORGL MATERIAL:- STEEL 10 GOST 1050-74		STAMP OR ETCH, PART No. MANUFACTURER's NAME & YEAR OF MFR.	
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	
DRG. NOT TO BE SCALED		USED ON: 765-78-Sb312, 765-10-Sb565, 765-08-Sb422, 765-05-Sb427, 675-04-Sb103, 675-05-Sb136, 675-10-Sb106	
SCALE: 2:1		NIPPLE	
DATE: 01-06-2001		700-57-403	
DRN. [Signature]		DS CAT No.	
TCD. [Signature]			
CHD. [Signature]			
APPD. [Signature]			
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)			

NOTE: ALL DIMENSIONS ARE IN mm



DECISION DATE	ISSUE	NATURE AMENDMENT
00635- V. 02000 01 8-98	(A)	STEEL TO IS: 7283-74 (MATERIAL AS PER IS: 226-75) [MATERIAL 10 C4 to IS: 9550-80Gr I] ADDED

1. Alternate material is steel 15,20,25 GOST 1050-74 and 15Г,20Г GOST 4543-71.
2. The following are allowed with respect to surfaces A and B machined from one setting:
 - a) radial run out of surface B should not exceed 0,15mm.
 - b) end play of surface Г should not exceed 0,06mm.
3. Difference in measurements of dimension "a" should, not exceed 0,2mm.

- (A) 4. EQ. MATERIAL: STEEL TO IS: 7283-74 (MATERIAL AS PER IS: 226-75)
II, MATERIAL 10 C4 to IS: 9550-80Gr I
- (B) EQ. MATERIAL - STEEL BAR C14 TO IS: 2073-70
ALT. MATERIAL - (i) STEEL BAR C15 Mн75, C20 TO IS: 2073-70
(ii) STEEL BAR C15 Mн75, C30 TO IS: 2073-70.

APPROVED

M. VASU

CHECKED

H. M. Sheela

700-57-404

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

NIPPLE

STEEL 10 GOST 1050-74

WEIGHT

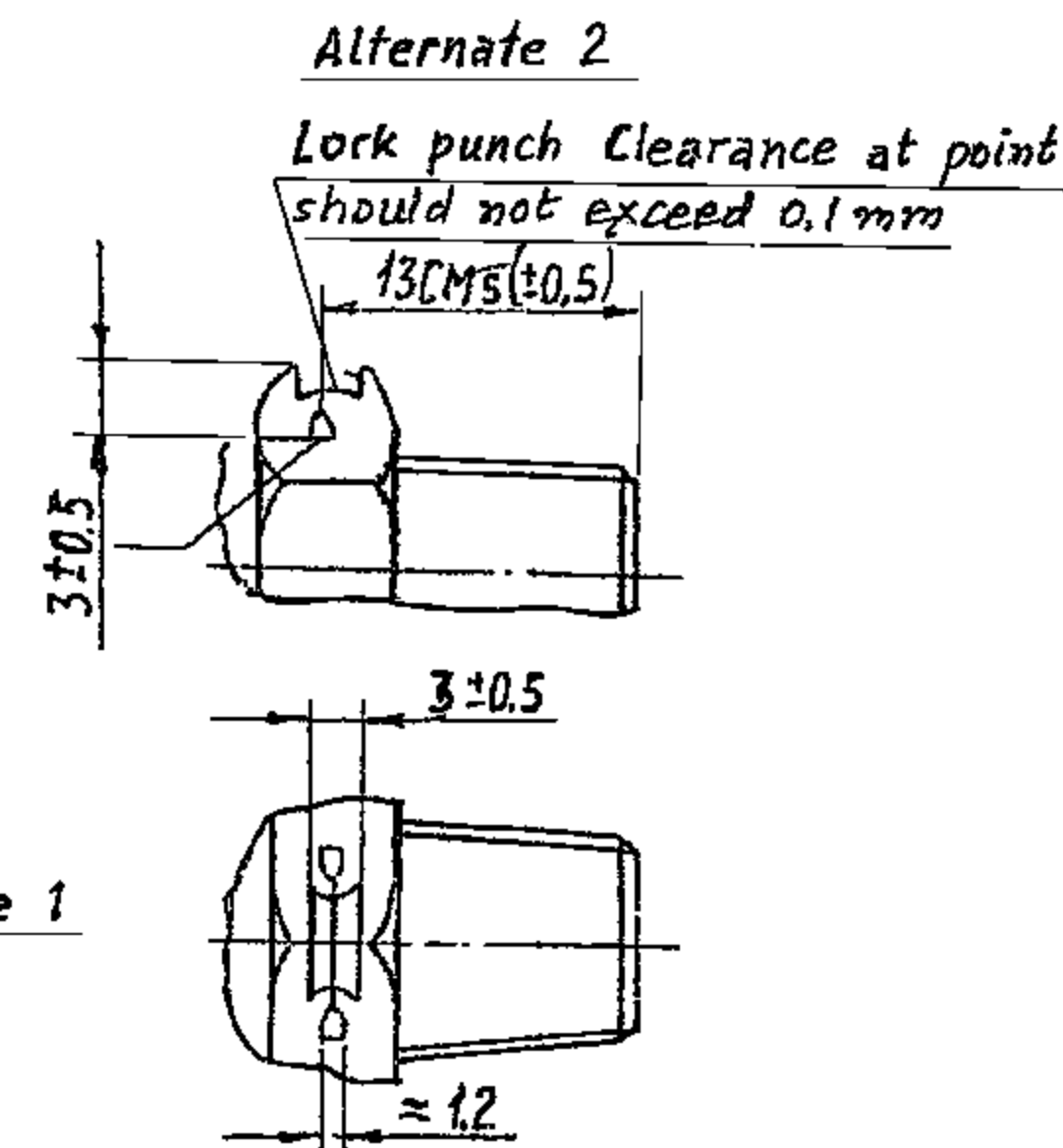
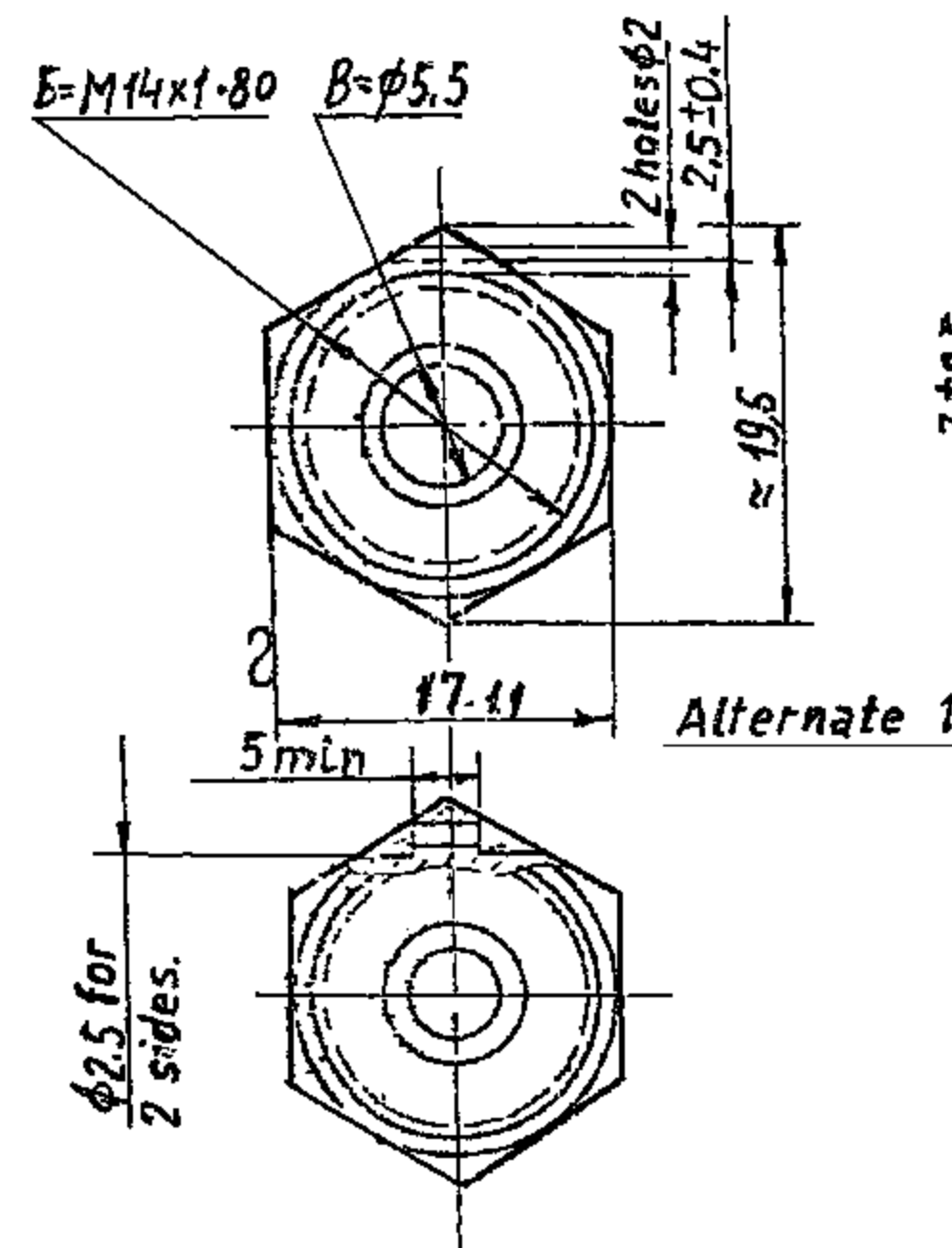
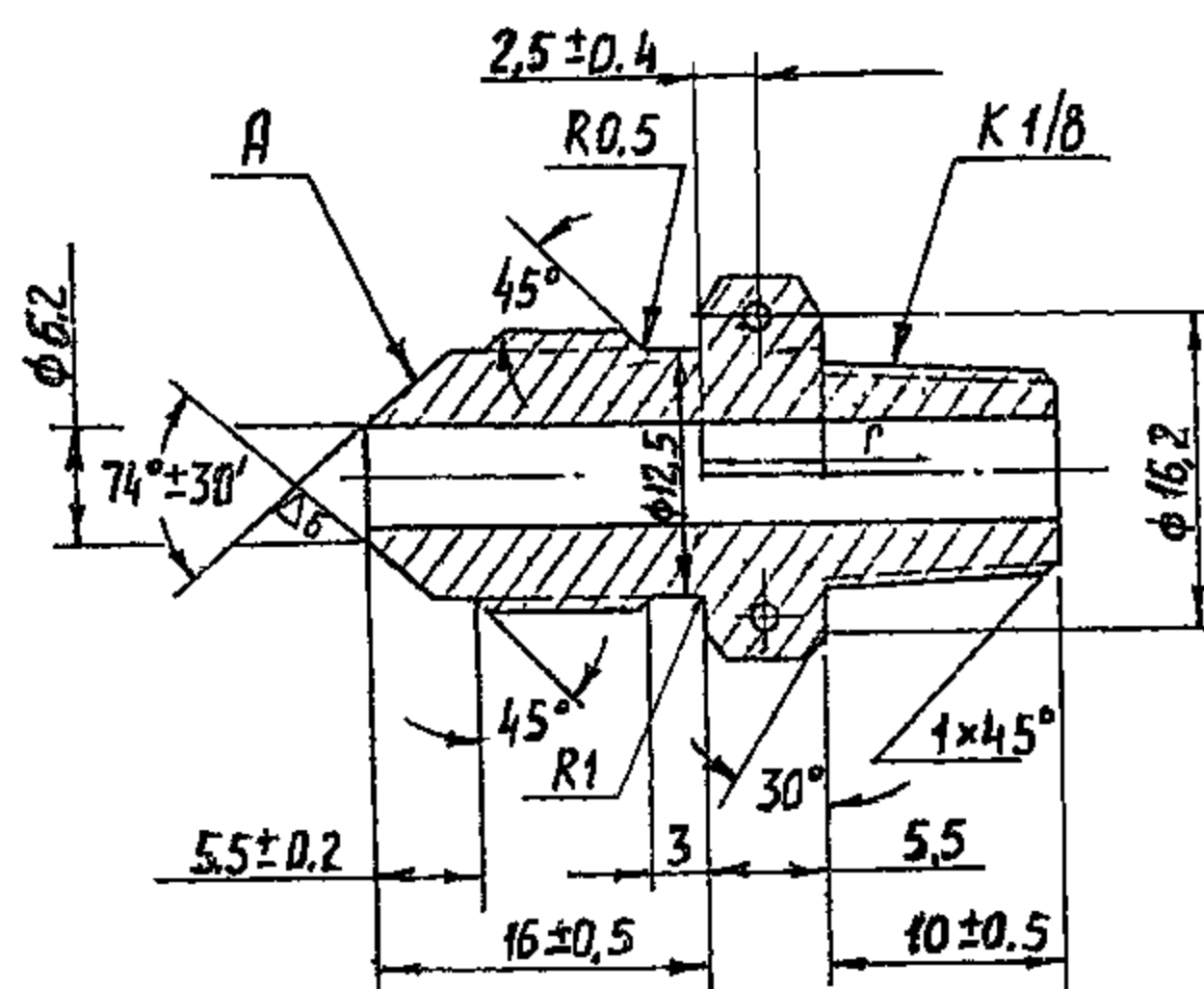
SCALE

0.007

2:1

SHT

SHTS



1. Blunt sharp edges.
2. Run out of surface A with respect to angle diameter of thread B should not exceed 0.05 mm.
3. Perform dimensions without deviations as per accuracy class 7, OST 1010.
4. Coating: Zinc-plated, 9 microns thick, chromated
Remove hydrogen embrittlement Do not check coating on inner surfaces.
5. Misalignment of axes not exceeding 0.5 mm is allowed on section F when hole B is machined on 2 sides.
6. Rod not less than 1 mm in diameter, should pass through hole A.

① EQ. MATERIAL CLASS4 (45 CB) 15. 2004-78

⑧ EQ. MATERIAL:- STEEL BAR Gr 3 TO IS: 9550-80

③ EQ. MATERIAL:- HEX. BAR C45 TO IS: 2073-70 OR

(D) C45 TO 15:1570.

01019-1CV <i>J. G. Brown</i> 24 APR 06	(E)	DS CAT PART NO. ADDED AND DESCRIPTION WAS UNION.
00905-1CV <i>N. J. Brown</i> 25-09-01	(D) <i>Curm</i>	EQ. MATERIAL ADDED.
00780-1CV <i>R. R. Brown</i> 26 4-2000	(C) <i>Curm</i>	EQ. MATERIAL ADDED
00717-1CV <i>J. G. Brown</i> 12-8-99	(B) <i>Curm</i>	EQ MATERIAL ADDED
00690-1CV <i>N. J. Brown</i> 16-02-99	(A) <i>Curm</i>	EQUIVALENT MATERIAL CLASS 4 (45 CB) IS: 2004-7B ADDED IN THE DRAWING
DC (I) No. DATE	ISSUE	AMENDMENTS

APPROVED	 M VASU	765-08-253	DS CAT PART No. (E) LV2/ICVs 4730-007419	
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		(E) UNION PIPE	WEIGHT	SCALE
			0.03	2:1
		45, GOST 1050-74	SHT 1	SHTS 1

99-87-997

R₂40/✓✓

Ⓑ EQ. MATERIAL:- WROUGHT ALLOYED STEEL BILLET/BAR
C45, C52 OR 40 Cr1 TO IS: 5517-69.

- 1) Unspecified limit deviations of dimensions are as follows:-
 for holes : as per A₇.
 for shafts : as per B₇.
 others : as per CM₇.
 for angular dimensions } $\pm 1^\circ$

2) Other requirements placed upon forging are as per class II
GOST 7505-74.

3) Coating: Zinc-plated, 9 microns thick, chromitized. Remove
Hydrogen embrittlement. Internal surfaces may be free from
coating.

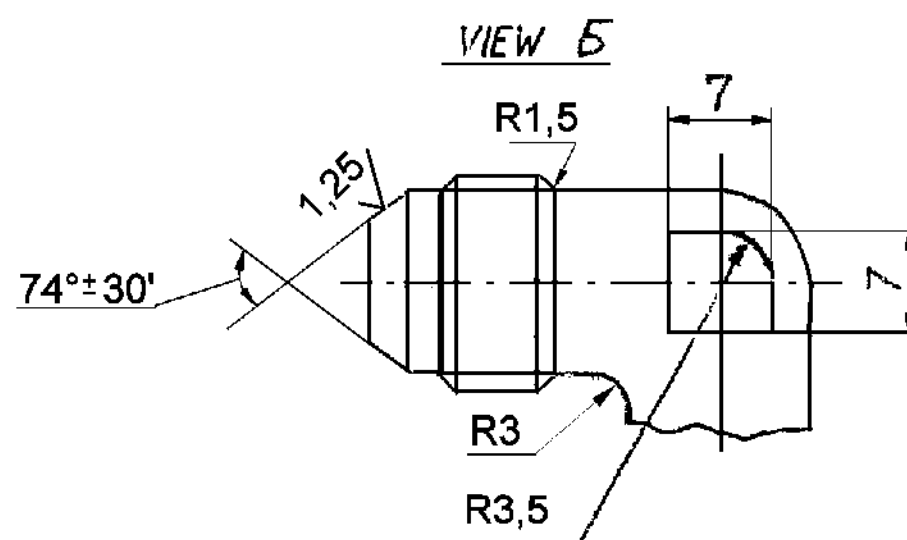
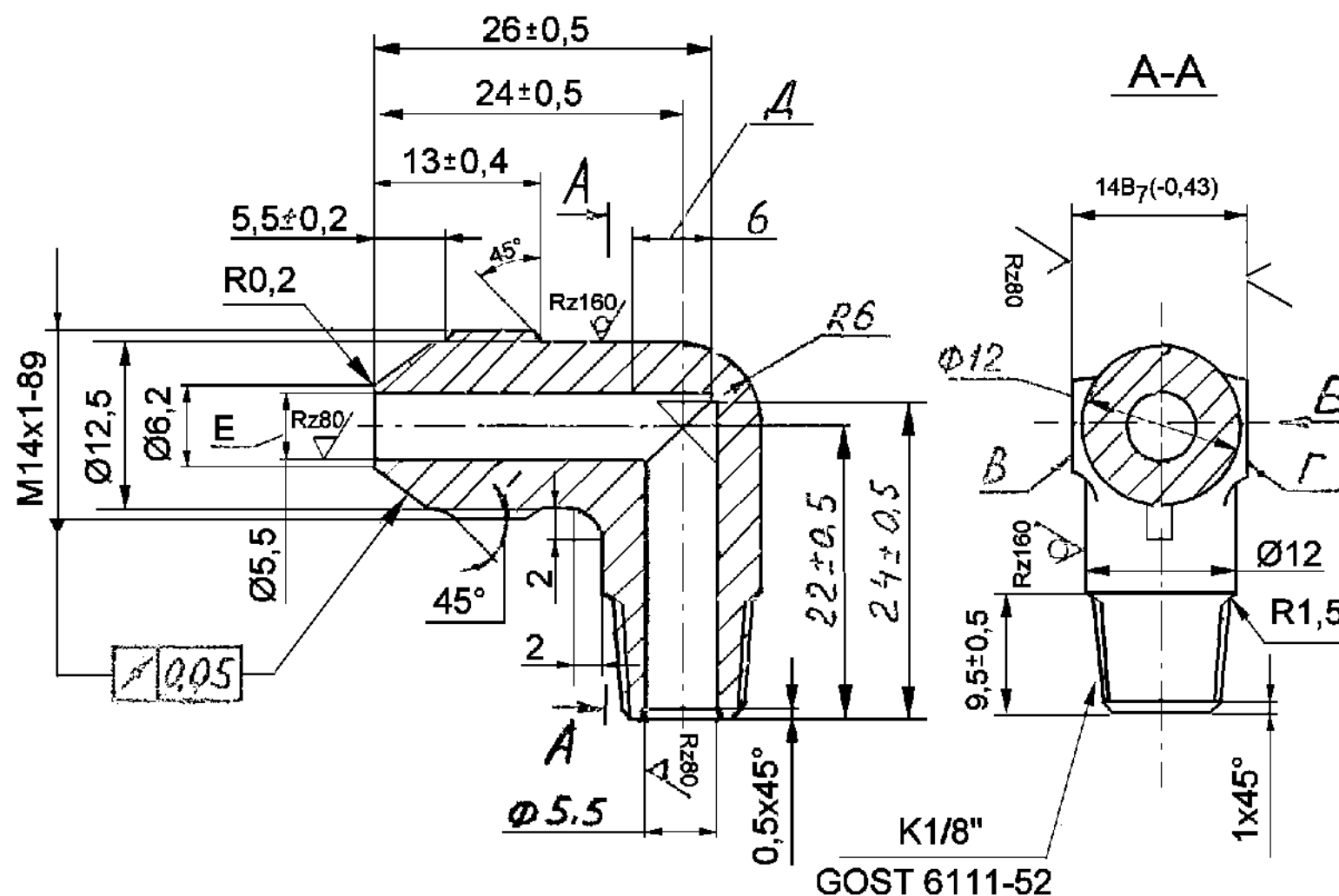
4) Surface defects to a depth not exceeding 0.7 mm are
allowed on unmachined surfaces.

5) Dents to a depth not exceeding 0.3 mm are allowed
on unmachined surfaces B and F.

6) It is allowed to make the angle as per thickened dash
dotted line.

7) Dimension E may be decreased by not more than 0.3 mm
above tolerance on dimension A.

Ⓐ EQ. MATERIAL:- CLASS 4,4SC8 TO IS:2004-78

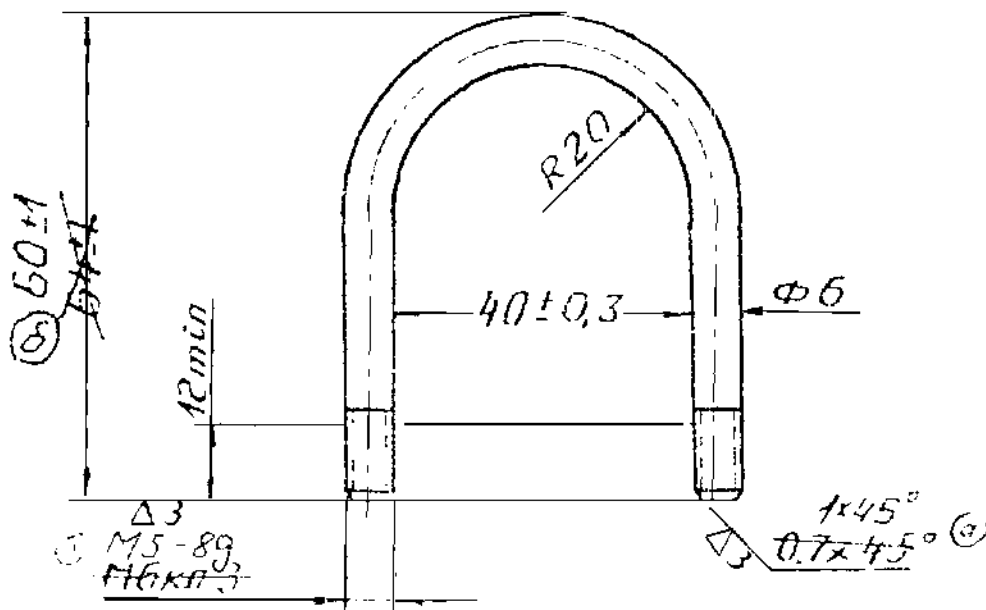


00837-ICV 4 OCT	Ⓑ	EQ. MATERIAL ADDED.
00651-ICV 29 OCT 98	Ⓐ	CLASS 4,4 SC8 TO IS:2004-78 ADDED AS EQ. MATERIAL
DC(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED	M. VASU	765-78-65			
CHECKED	H. M. S. L. S. L. S. L.	ANGLE		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				0.033	2:1
			SHT 1 SHTS 1		
		STEEL 45, GOST 1050-74			

815-81-591

~ Unless stated otherwise.



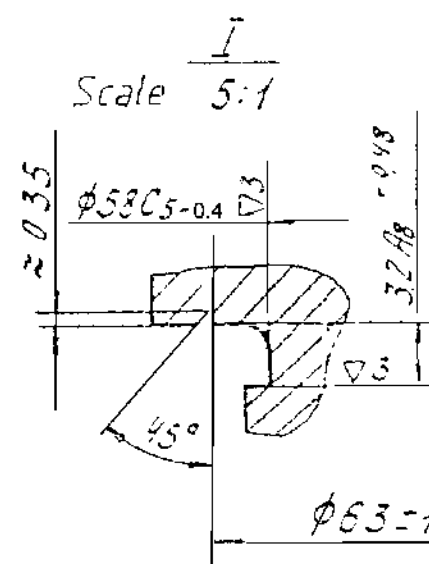
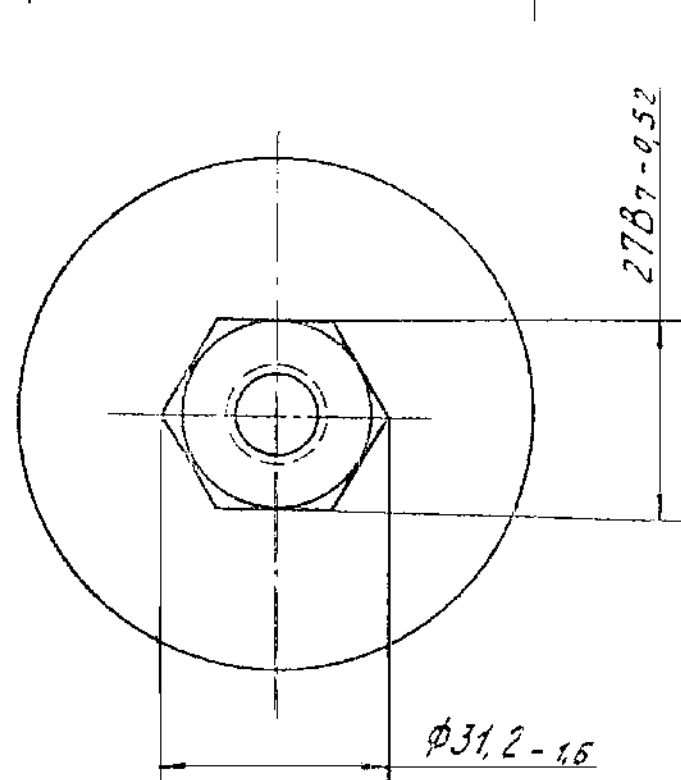
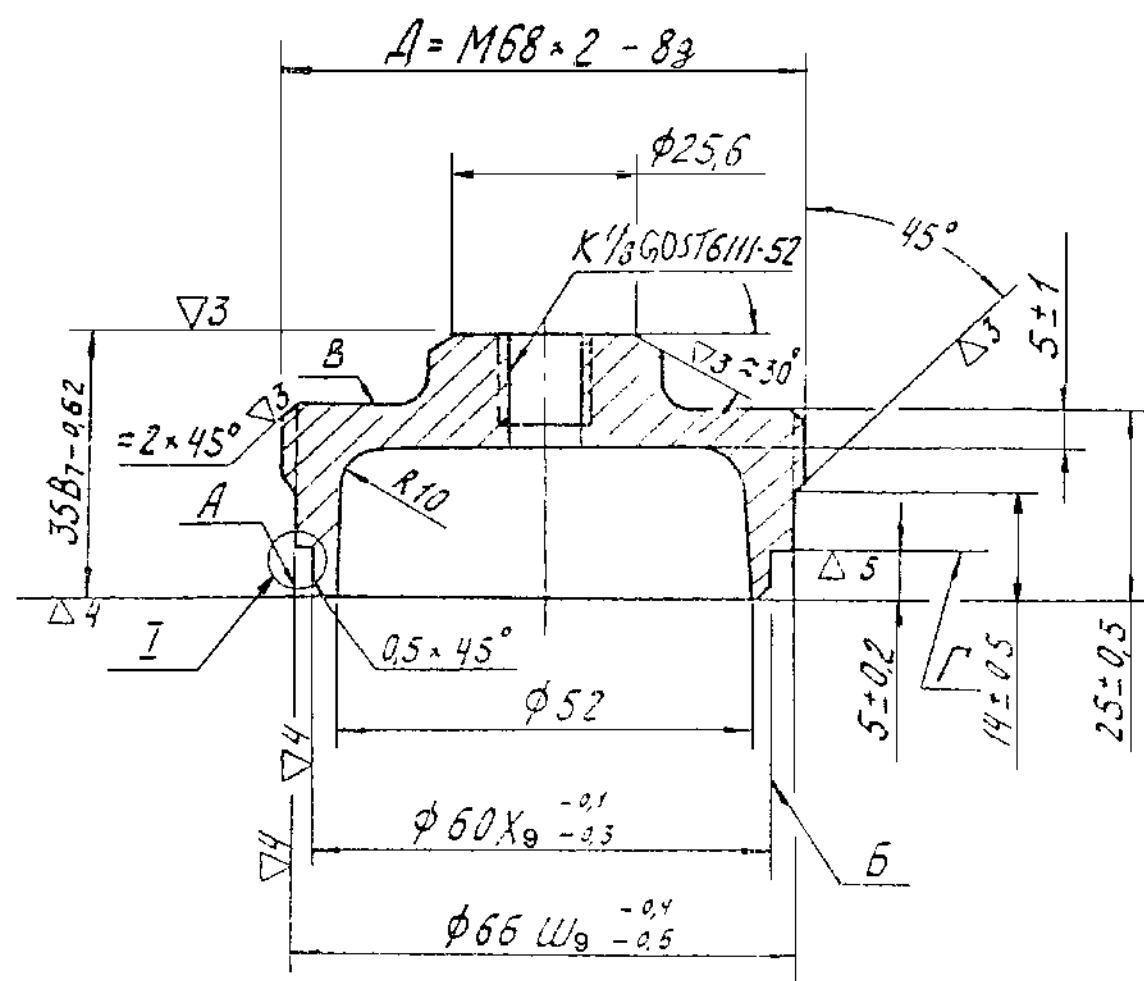
1. Coating: Zinc-plated, 9 microns thick, chromated.
Check dimensions before coating.

ORGL MATERIAL-WIRE 6.0-C-I GOST 3282-74		DC(II) No A DATE	ISSUE	AMENDMENTS
ALL SHARP EDGES & COR- NERS TO BE ROUNDED (R).		ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED				
SCALE:- 1:1		TOLERANCE ON DIMENSIO- NS UNLESS OTHERWISE SPECIFIED		USED ON:- 765-78-533
DATE :- 19-06-95				
DRN. M. M. T. (Kg)		CLAMP		
TCO. 0,033				
CHD. 985		765-78-578		
APD. B. B.				
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				

KVD-65919

0821-8L-59L

Unless
otherwise specified.



- 1) Blunt sharp edges.
- 2) Other requirements placed upon forging are as per class II GOST 7505-74
- 3) Recesses to a depth of not exceeding 0,7mm are allowed on unmachined surfaces.
- 4) With respect to axis of angle diameter of thread A , the following is allowed:
 - a) Run out of surfaces A and B should not exceed 0,1mm (qualified tolerance),
 - b) Run out of surface I should not exceed 0,06mm (qualified tolerance)
- 5) Brinell hardness is 341 to 285 ($\phi 3,3$ to 3,6).
- 6) Thread may be brought to surface $\phi 66 W_4$.
- 7) Alternate material is 20x13 GOST 5632-72.
- 8) Milling cutter traces to a depth not exceeding 0,5mm on surface B are allowed. Dimension $R1$ or chamfer $1 \times 45^\circ$ is allowed at a change from surface B hexahedron.

30x13 GOST 5632-72		DC(I) No & DATE	ISSUE	AMENDMENTS
ORGL MATERIAL				
ALL SHARP EDGES & COR- NERS TO BE ROUNDED OFF.		ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED				
SCALE:- 1:1		TOLERANCE ON DIMENSIO- NS UNLESS OTHERWISE SPECIFIED		USED ON:-
DATE :- 20-06-95				
DRN. <i>SPR</i>	WT: (Kg)	PLUG		
TCD.	0.37			
CHD. <i>27</i>		765-78-1230		
APD. <i>Bar</i>				
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				

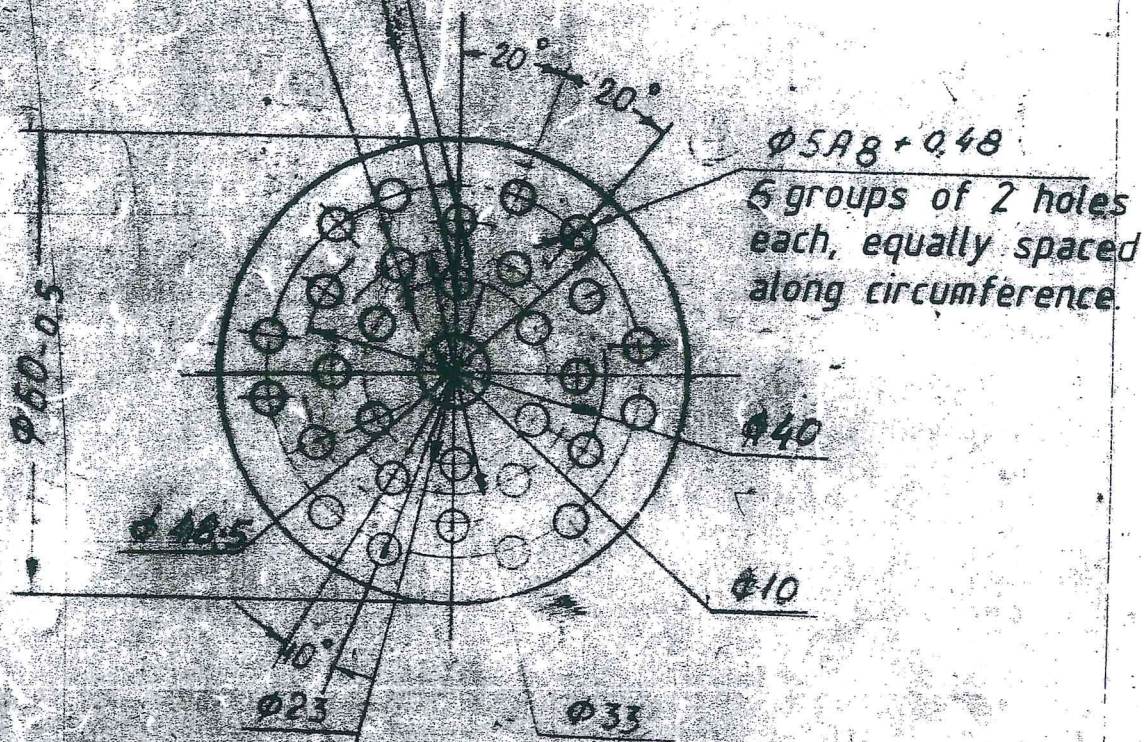
765-78-1233

5 holes A = $\phi 5A8 + 0.48$

THICKNESS 1 ± 0.1

6 holes B = $\phi 5A8 + 0.48$

5 holes B = $\phi 5A8 + 0.48$



- 1) Webs between holes should be atleast 2.5 mm.
- 2) Holes of groups A B and B should be equally spaced along circumference.
- 3) Burrs are not allowed.
- 4) Provide dimensions without deviations with accuracy of ± 0.5 mm.
- 5) Alternate material is 12x18 H9T GOST 5632-72.

MATERIAL : - 12 x 18 H 10 T GOST 5632-72

ALL SHARP EDGES & CORNERS TO BE BOUNDED OFF

ALL THREADS TO CONFORM TO SPECIFICATION

STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.

DWG. NOT TO BE SCALED

TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED

USED ON:- 765-78-05533

SCALE :- 1:1

DATE :- 20-06-95

DRN. M.H.-2

WT :- (Kg)

TCO. M.H.-2

0.018

CHD.

APD.

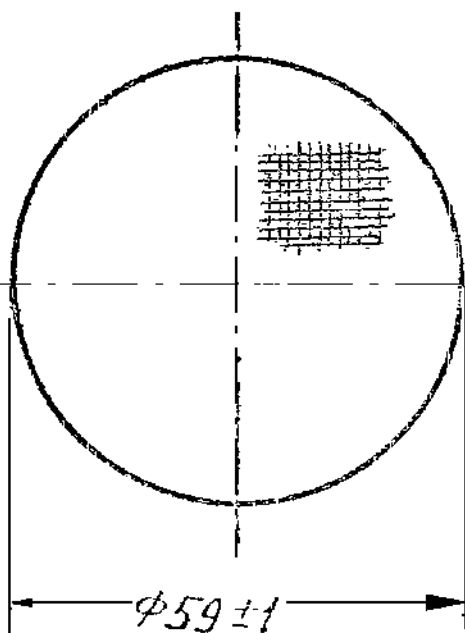


GRATE

765-78-1233

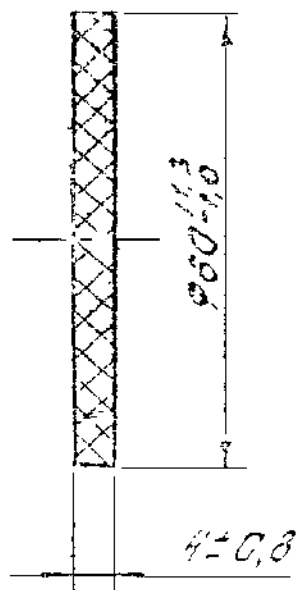
CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

765-78-1234



① ALTERNATE MATERIAL:- STEEL Gde X07 Cr 18 Ni 9 TO IS: 6527-95

		00970-101	① ALTERNATE MATERIAL ADDED
		17 MAY 04	
ORGL MATERIAL:- LOW BRASS GAUZE 07 GOST 6613-73.		DC(1) No & DATE	ISSUE
ALL SHARP EDGES & COR- NERS TO BE ROUNDED OFF.		ALL THREADS TO CONFORM TO SPECIFICATION.	
DRG. NOT TO BE SCALED		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.	
SCALE:- 1:1		TOLERANCE ON DIMENSIO- NS UNLESS OTHERWISE SPECIFIED	
DATE :- 20-06-95		USED ON:- 765-78-cd 533	
DRN. <i>M. L. H.</i>	WT:-(Kg)	GAUZE	
TCD. <i>M. L. H.</i>	0,007		
CHD. <i>Q. K.</i>		765-78-1234	
APD. <i>B. S.</i>			
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)			



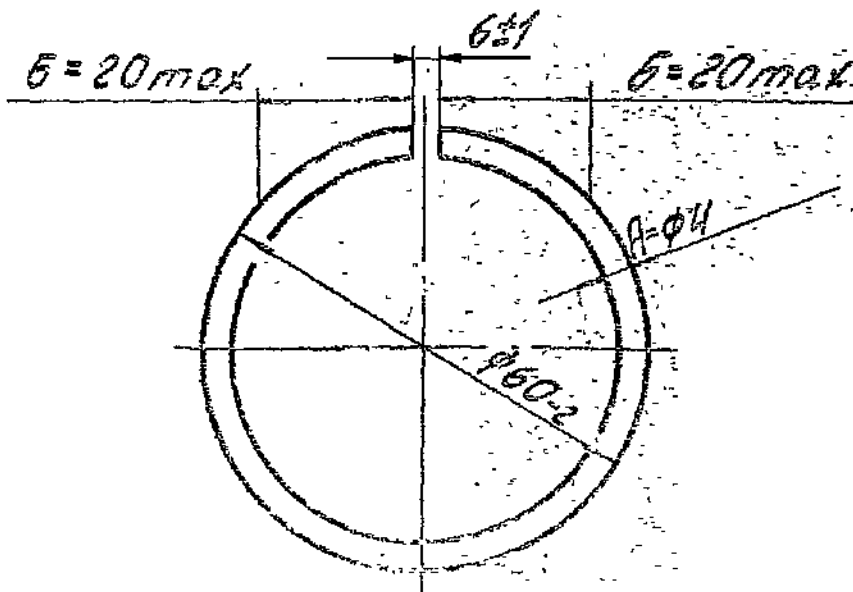
1) For ready-made part

Volume weight is $0.25 \pm 0.02 \text{ Gr/Cm}^3$.

2) Alternate material is semi rough woolen felt, GOST

6308-71. Volume weight for ready-made part is $0.24 \pm 0.02 \text{ Gr/Cm}^3$

ORGL MATERIAL:- FELT T ϕ GOST 288-72		DC(1) No A DATE	ISSUE	AMENDMENTS
A) L SHARP EDGES & COR- NERS TO BE ROUNDED OFF.		ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED				
SCALE:- 1:1		TOLERANCE ON DIMENSIO- NS UNLESS OTHERWISE SPECIFIED		USED ON:- 765-78-c5533
DATE :- 20-6-95				
DRN. <i>Mh</i>	WT:-(kg)	FILTER		
TCD. <i>Mh</i>	0,005			
CHD. <i>g</i>		765-78-1235		
APD. <i>Bol</i>				
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				
3	2	1		



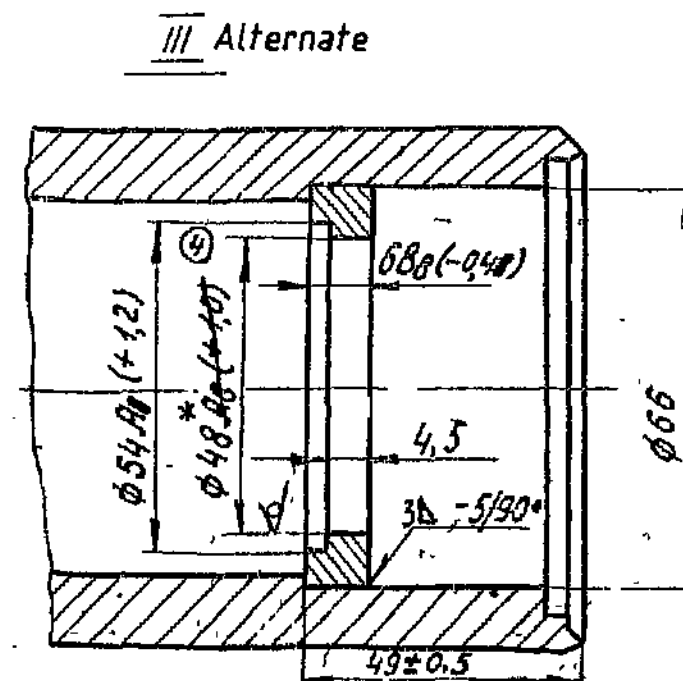
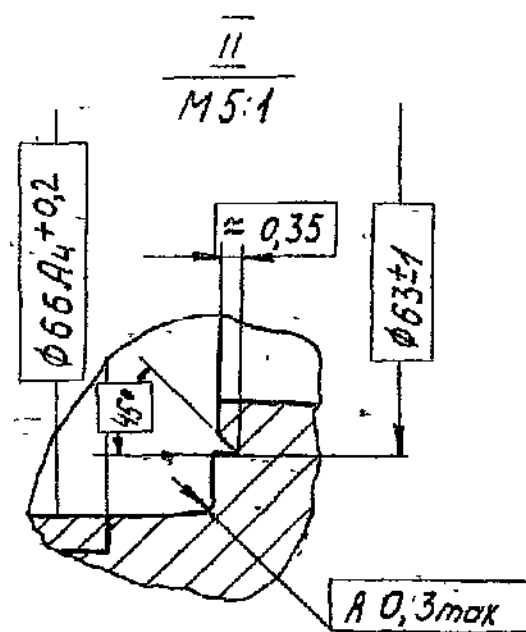
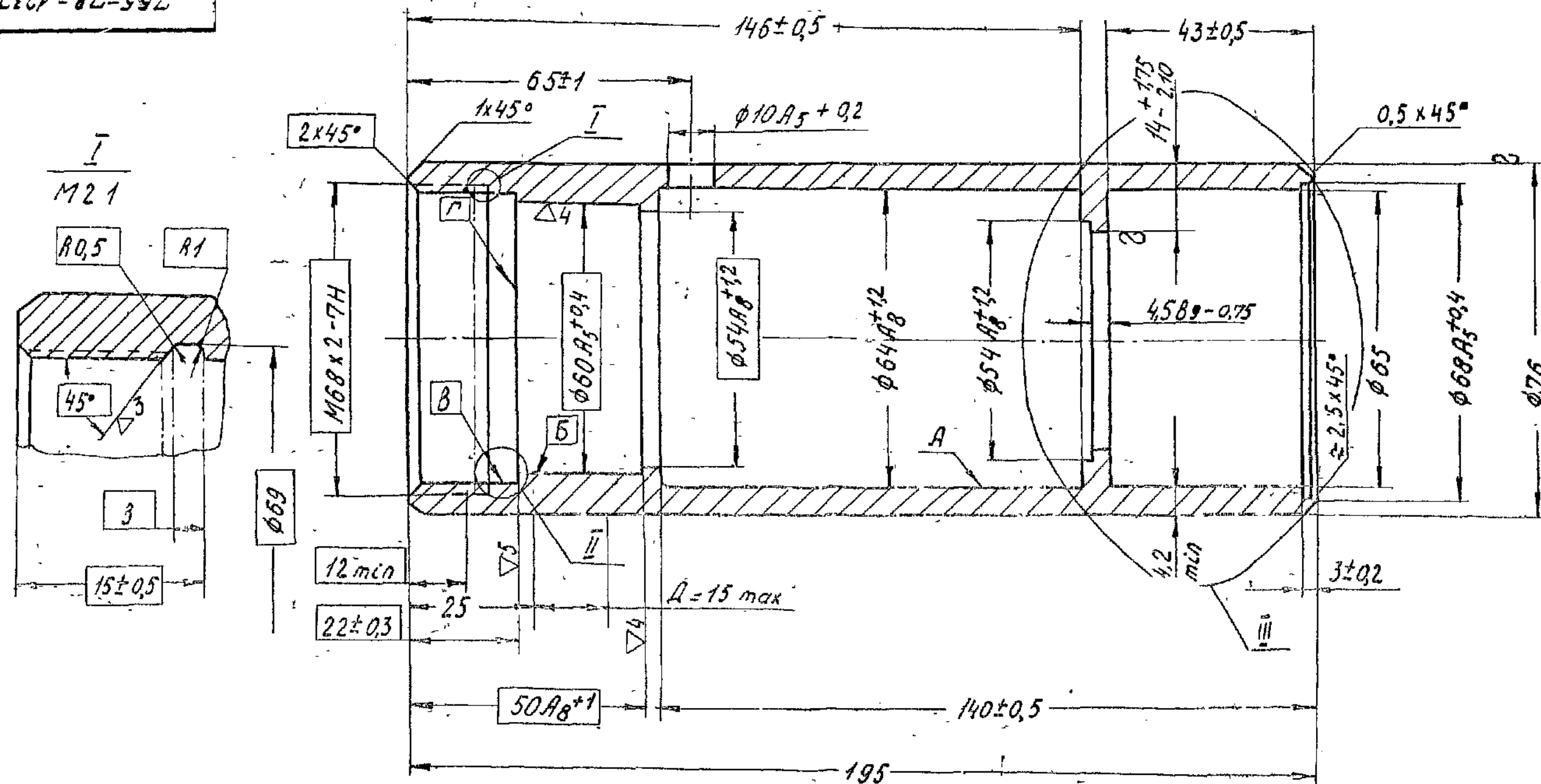
EQ. MATERIAL ADDED		AMENDMENTS	
009537	(A)	ISSUE	
31-5348		DC(I) No.	
		R DATE	

1) Distortion of profile on dimensions A is allowed within the limits of not more than ± 0.5 mm.

2) Bevel cut and rounding of edges should not exceed 3 mm on buttends.

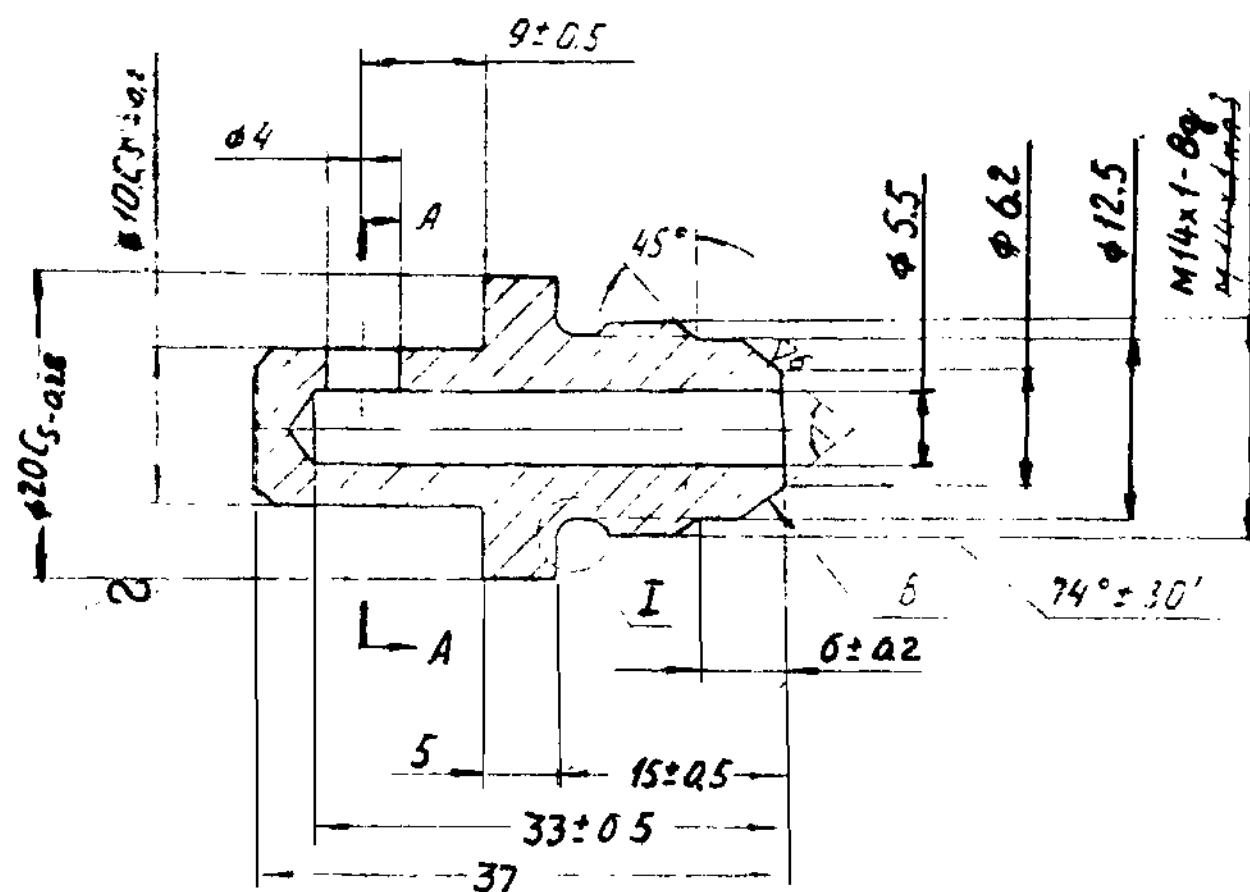
(A) EQ. MAT. : GR.19500 TO IS: 739-77 WITH HEAT TREATMENT AS O' CONDITION.

ORGL MATERIAL: AR1 4 GOST 14838-78		DC(I) No.	ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.		ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON:- 765-78-05 533
SCALE:- 1:1		RING		
DATE :- 19-06-95				
DRN. <i>M. L. G.</i>	WT: (K3)	765-78-1236		
TCD. <i>M. L. G.</i>	0,005			
CHD. <i>W.</i>		CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)		
APD. <i>B. B.</i>				

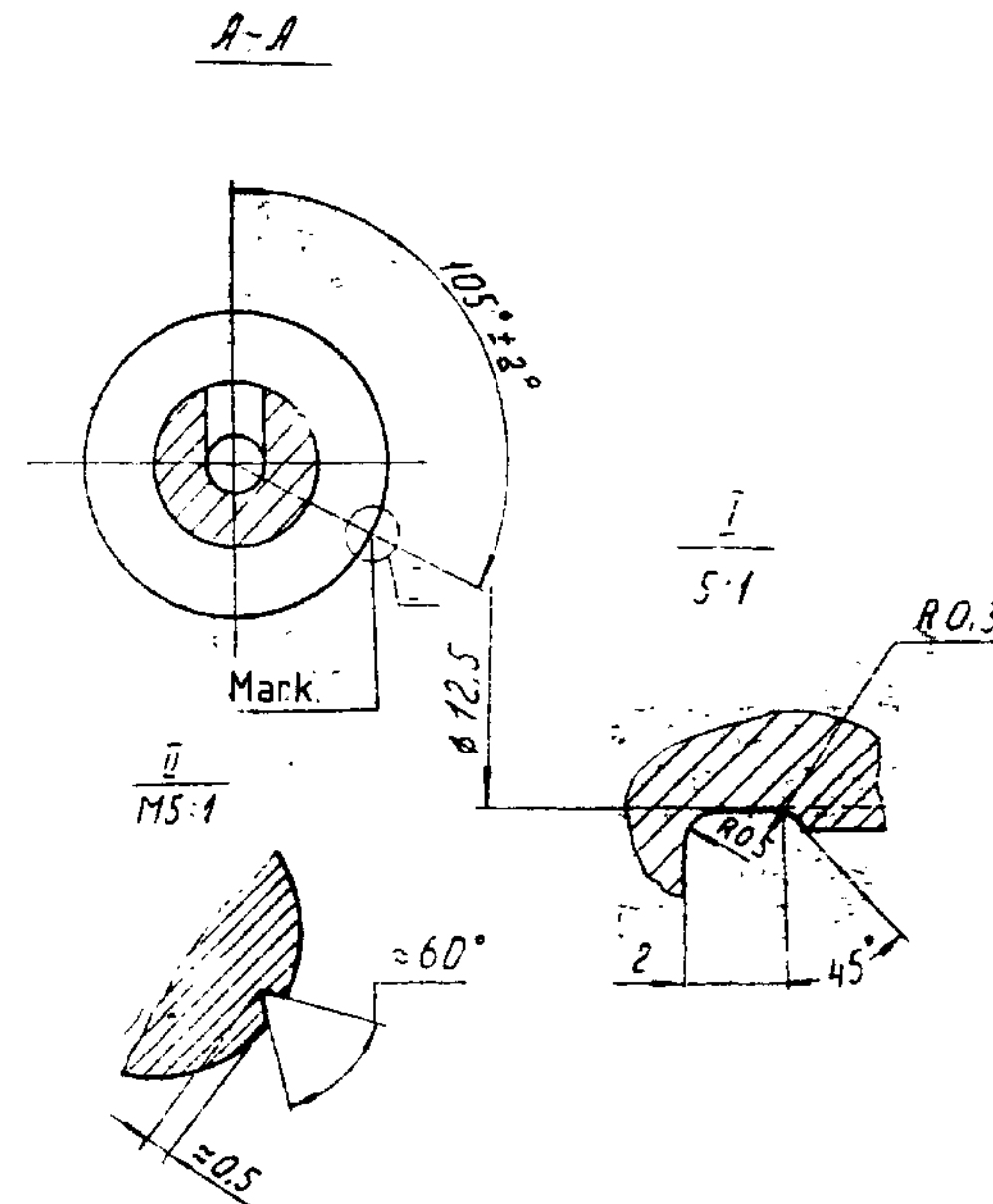


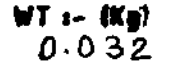
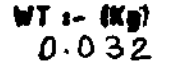
1. Blunt sharp edges.
2. Make dimensions without deviations as per accuracy class 7, OST 1010.
3. With respect to the axis of angle thread diameter, the following is allowed:
a) Runout of surfaces B and B should not exceed 0.1 mm (Qualified tolerance).
b) Runout of surface Γ should not exceed 0.06 mm.
4. Perform heat treatment, HB 302 to 255 (Φ3.5 to 3.8).
5. It is allowed to make the part along the conventional dotted line.
6. Machine in assembly along dimension and dotted line in .
7. Step of not exceeding 0.5 on surface A is allowed.
8. For checking hardness on section II it is allowed flatness to a depth not exceeding 0.5 mm.
9. * Dimensions are given for reference.

MATERIAL TUBE 76X14 GOST 8732-78		
630XΓCA GOST 8731-74		
ALL SHARP EDGES & CORNERS TO BE BOUNDED OF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:- 765-78-C6534
SCALE:- 1:1	DATE:- 20-6-95	765-78-1237
DRN. Khatkhat	Wt. (Kg) 1.9	BODY
TCD.	CHD. 0.2	CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)
APP. 0.2		



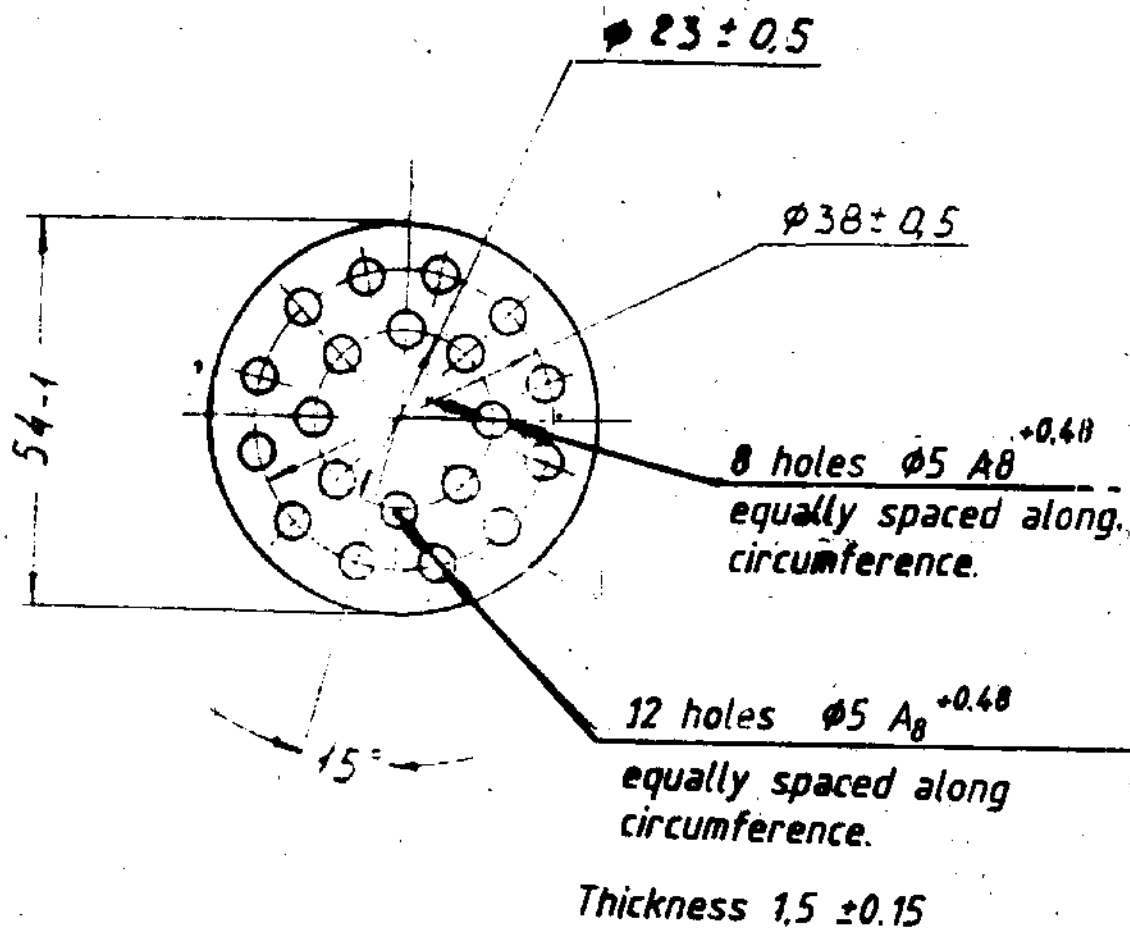
- 1) Blunt sharp edges.
- 2) Provide dimensions without deviations as per accuracy class 7, OST 1010.
- 3) Alternate material is 40 GOST 1050-74
- 4) Run out of surface with respect to the angle diameter of thread should not exceed 0,05mm.



MATERIAL :- 20 GOST 1050-74		
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED		
SCALE :- 2:1	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-
DATE :- 20-06-95		
DRN. <i>SPR 0004</i>	 UNION	 765-78-1238
TCD. <i>1.2</i>		
CHD. <i>1.2</i>		
APD. <i>1.2</i>		
		
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)		

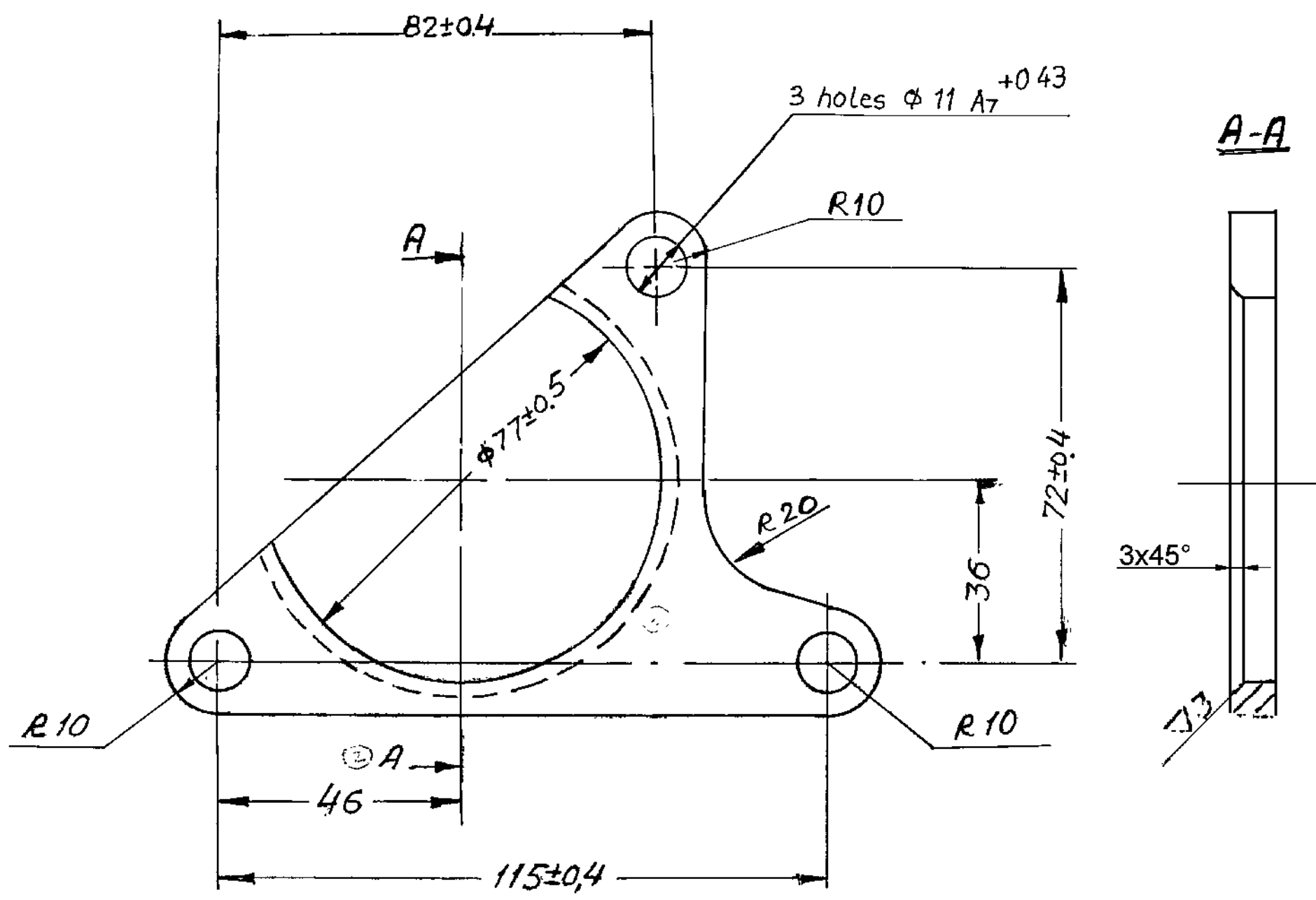
765-78-1240

2

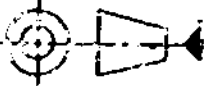


- 1) Burrs are not allowed.
- 2) Alternate material is steel cm3 cn, GOST 380-71, and steel 10, GOST 1050-74.

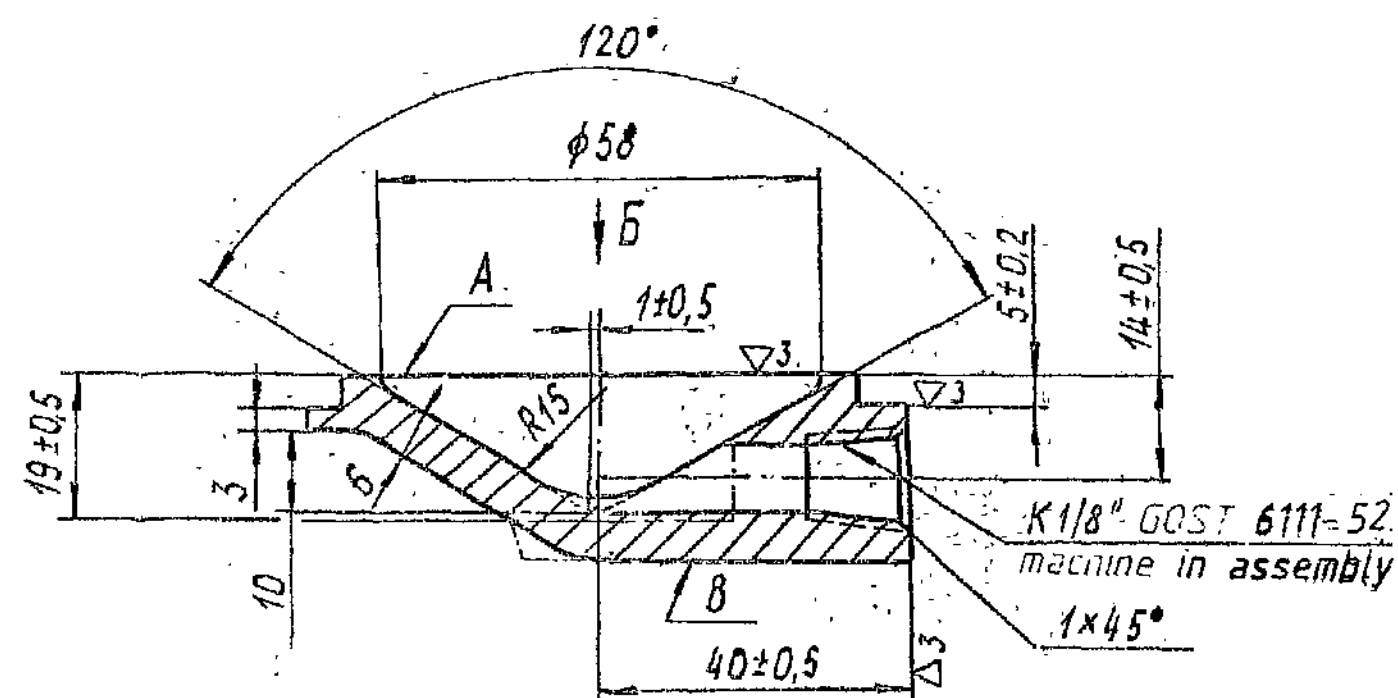
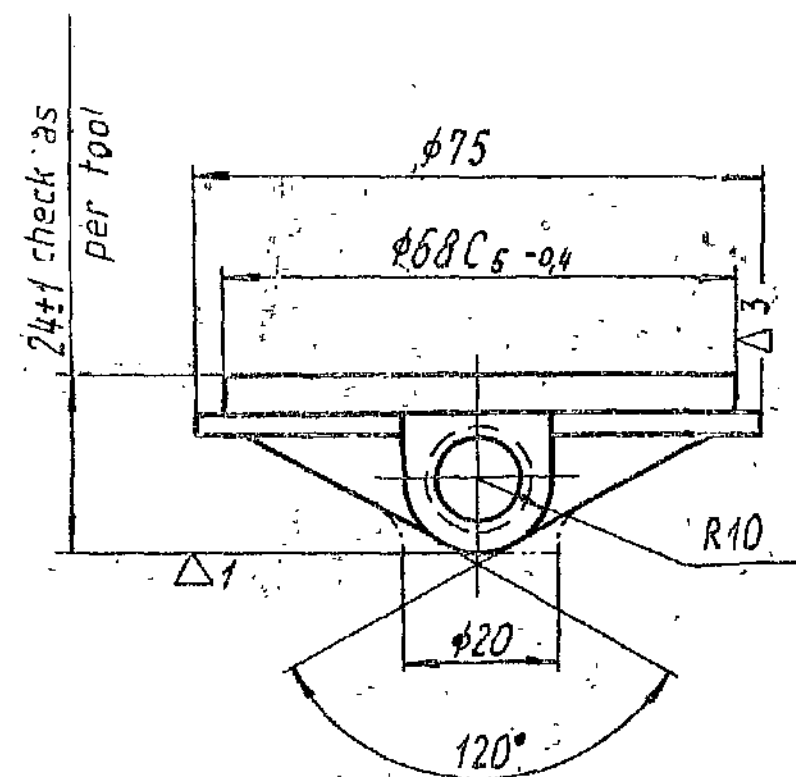
MATERIAL : - STEEL CM3 KИ GOST 380-71		
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON: -765-78-CD 534
SCALE : - 1:1		
DATE : - 20-06-95		
DRN. <i>M. G. L.</i>	WT : - (Kg)	GRATE
TCD. <i>M. G. L.</i>	0,022	
CHD. <i>ps</i>		765-78-1240
APD. <i>ps</i>		
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)		



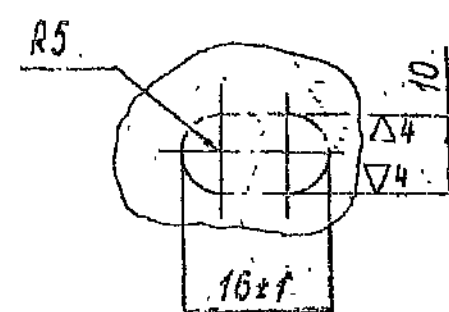
- 1) Burrs are not allowed.
- 2) Provide dimensions without deviations with an accuracy of ± 0.5 mm.
- 3) Alternate material is steel 10, 25, 30 GOST 1050-74.
- 4) Stamping drafts should not exceed 0.6 mm.

ORCL MATERIAL-STEEL 20-GOST 1050-74		DC(1) No & DATE	ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.		ALL THREADS TO CONFORM TO SPECIFICATION.		STATE OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED				
SCALE:- 1:1		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON:-
DATE :- 20-06-95				
DRN. 882204	WT (Kg)	FLANGE		
TCD.				
CHD.				
APD. 10/1				
		765-78-1241		
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				

Unless otherwise specified



VIEW 6



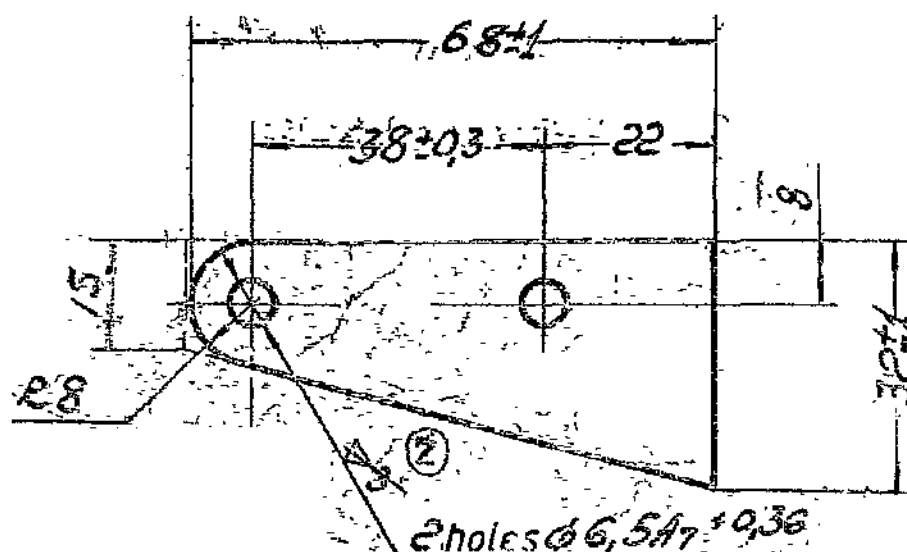
- 1) Blunt sharp edges.
- 2) Other requirements for forging are as per class II GOST 7505-74.
- 3) Single irregularities to a depth of no more than 0.7 mm are allowed on unmachined surfaces.
- 4) Non-parallelity of axis of thread with respect to plane A should not exceed 0.5 mm.
- 5) Bottom may be made as per conventional dotted line.
- 6) Dark spots of any size are allowed on surface.
- 7) Brinell hardness is 302 to 255 (φ3.5 to 3.7).

38XC GOST 4543-71				
ORGL MATERIAL		DC(I) No A DATE	ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.		ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP OR ETCH, PART NO., MANUFACTURER'S NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED				
SCALE:- 1:1		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON:-
DATE :- 20-06-95				
DRN. <i>SPR</i>	WT: (Kg)	BOTTOM		
TCD.	0.265			
CHD. <i>✓</i>		765-78-1242		
APD. <i>Br</i>				
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES,				

65-78-1243

② 65-78-1243

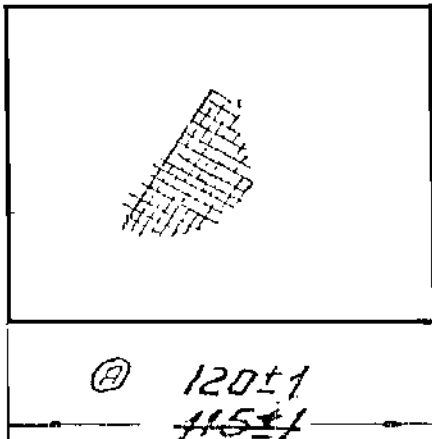
R.2160/

Thickness 5 ± 0.5 .

- 1) Burrs are not allowed.
- 2) Provide dimensions without deviations with an accuracy of ± 0.5 mm.
- 3) Alternate material is steel cm 3cn, GOST 380.-71 and steel 10, 15, 25, GOST 1050-74, steel 15F and 20F, GOST 4543-71.
- 4) Stamping draft not exceeding 0.5 mm is allowed.
- 5) Strap may be made as per conventional dotted line.

MATERIAL :- 20 GOST 1050 - 74		
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFG.
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-765-78-05534
SCALE :- 1:1		
DATE :- 19-06-95		
DRX. <i>M. L. L.</i>	WT :- (Kg) 0.054	STRAP
TEL. <i>M. L. L.</i>		
CHL. <i>M. L. L.</i>		765-78-1243
APD. <i>M. L. L.</i>		
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)		

765-78-1244

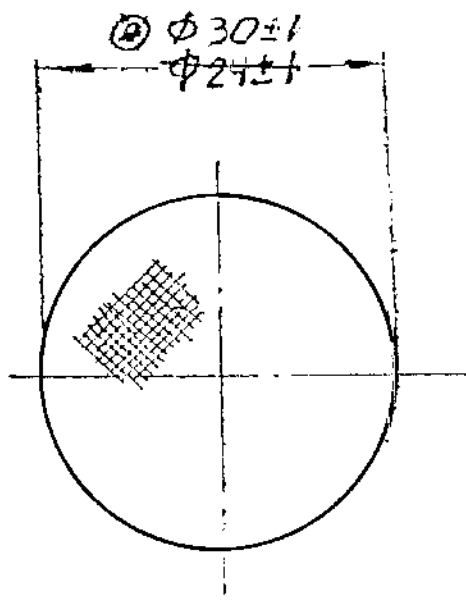


82±10
84±10
86±10

8

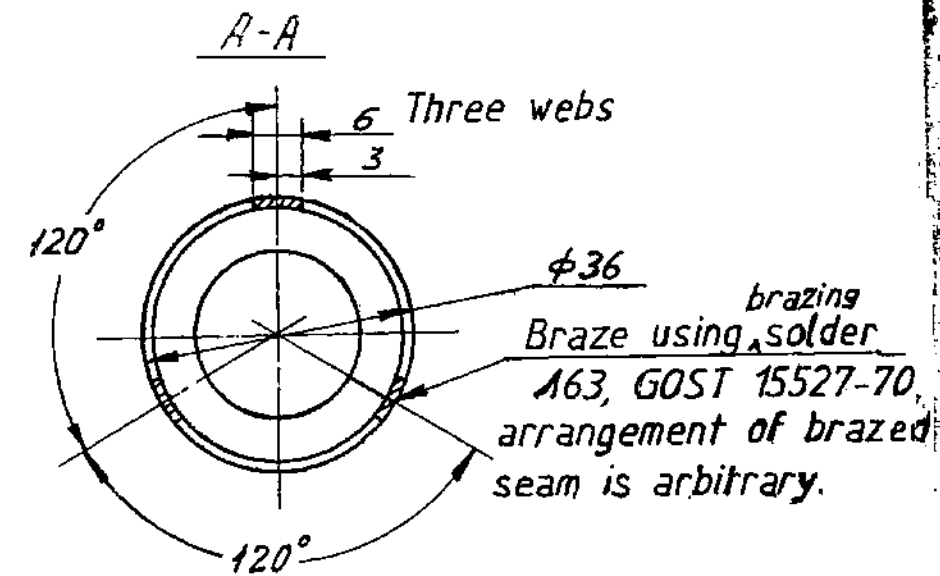
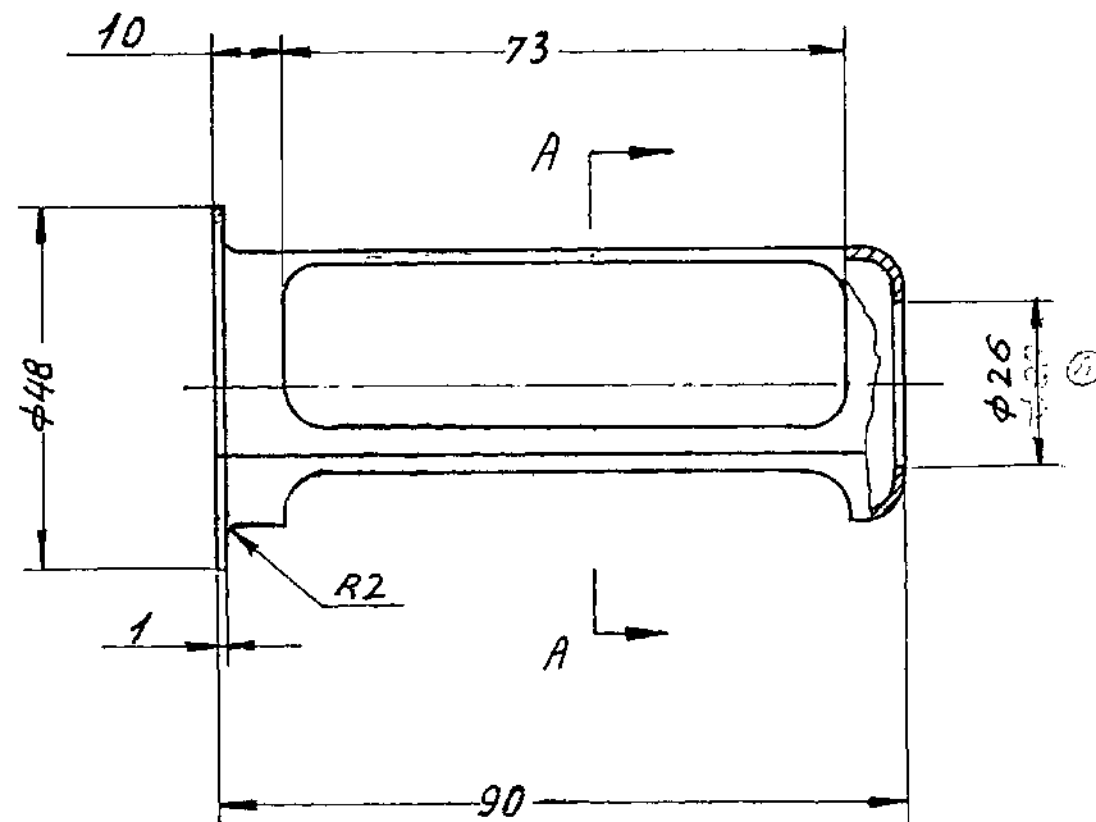
ORGL MATERIAL: GAUZE, SEMITOMBAG 025 GOST 6613-73		DC(II) No A DATE	ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.		ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP OR ETCH. PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		
SCALE:- 1:2		DATE :- 20-06-95		USED ON:- 765-78-05535
DRN. <i>M. L.</i>	WT: (Kg) 0,006	GAUZE		
TCD. <i>M. L.</i>				
CHD. <i>123</i>		765-78-1244		
APD. <i>B. S.</i>				
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				

765-78-1245



ORCL MATERIAL: GAUZE, SEMITOMBAC 025 GOST 6613-73.		DC (T) No DATE	ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.		ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED		TOLERANCE IN DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON:- 765-78-05535
SCALE:- 2:1				
DATE :- 20-06-95				
DRN. <i>M. K. - 1</i>	WT: (Kg)	GAUZE		
TCD. <i>M. K. - 1</i>	0,002			
CHD. <i>OK</i>		765-78-1245		
APD. <i>Boh</i>				
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				

765-78-1246

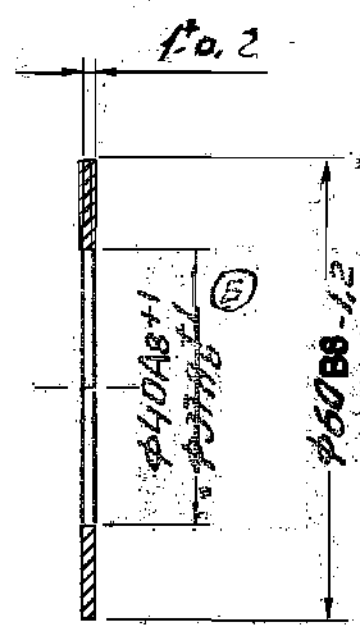


- 1) Burrs are not allowed.
- 2) Provide dimensions without deviations with an accuracy of ± 1 mm.
- 3) Unspecified radii should not exceed R5.
- 4) Body may be made from 3 parts with subsequent brazing and dressing of brazed seams.
- 5) Alternate material is sheet A1 PXM 1.2 A63. GOST 931-78.

NEAREST EQVT MATERIAL			
SHEET A1 PXM 1 A63, GOST 931-78		DRG. REVISED AND RE-TRACED	
ORGL MATERIAL	DC(I) No & DATE	ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.	ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON:-
SCALE:- 1:1			765-78-C6535
DATE :- 24.10-03			
DRN. MY	WT: (Kg)	765-78-1246	
TCD. MY	0.012		
CHD. MY		PART NO	
APD. MY		BODY	
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)			

765-78-1247

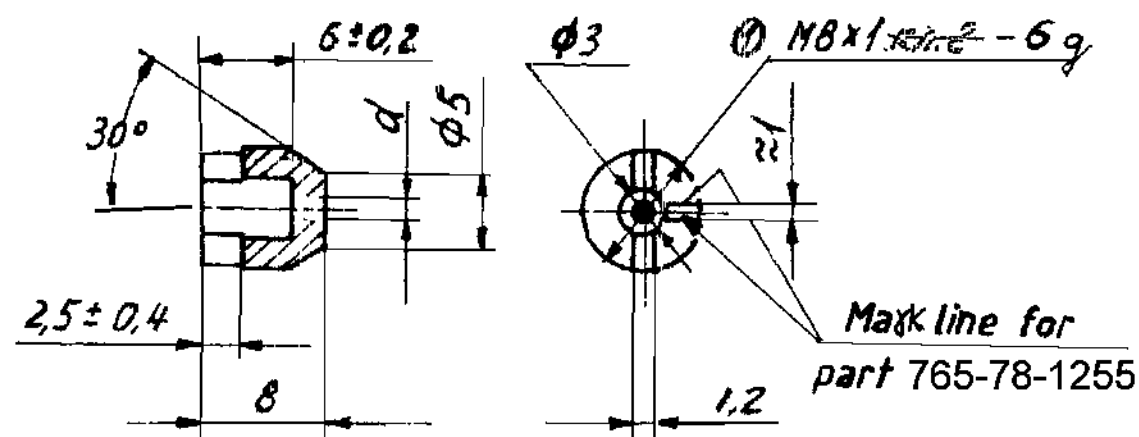
② - some other



- 1) Burrs are not allowed.
- 2) Non-flat ness should not exceed 0,5 mm.
- 3) Alternate material is steel 12x18 H9T GOST 5632-72.

MATERIAL : - 12 x 18 H 10T GOST 5632-72		
ALL SHARP EDGES & CORNERS TO BE BOUNDED BY	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON: -765-78-05533
SCALE :- 1 : 1	RING	
DATE :- 19-06-95	765-78-1247	
DRN :- M.L.H. - 2	WT :- (Kg) 0,013	
TCD :- M.L.H. - 2		
CHD		
APP. B.M.		
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)		

765-78-1254/1258



TECHNICAL CONDITIONS

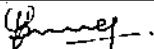
- 1) Blunt sharp edges.
- 2) Make mark lines to a depth of approximately 0.5 mm on the butt-end in compliance with table arrangement of mark lines with respect to the slot is arbitrary.
- 3) Provide dimensions without deviations as per accuracy class 7, GOST 1010.
- 4) Displacement of slot with respect to the axis should not exceed 0.4 mm.
- 5) Alternate material is 5p A7S MU -10-3-15, GOST 18175-78.

Ⓐ EQ. MATERIAL: Gde I, HB-CONDITION TO IS: 319-81.

Ⓑ EQ MATERIAL:-BRASS BARS OF CU ZN 39 PB2 TO IS: 531-81.

DESIGNATION	d(A5)		Number of notches
	Nominal	Deviation	
765-78-1254	0.4		1
765-78-1255	1.5	+0.12	2
765-78-1256	2.2	+0.12	3
765-78-1257	1	+0.12	4
765-78-1258	0.6	+0.06	5

00818-11V N 4/11 11.10.2008 V. Ramaswami BCL 00640 -12V 19.6.99 BCL No. 6	Ⓑ Am	EQ. MATERIAL ADDED FC 765-78-1257.
	Ⓐ Am	EQ. MATERIAL ADDED.
	ISSUE	NATURE
	AMENDMENT	

APPROVED		 M VASU		765-78-1254/1258				
CHECKED				JET (TABLE DRAWING)			WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)			0.002			2:1		
		SHT 1 SHTS 1						
				ЖС59-1, GOST 15527-70				

USED ON

765-78-1406

3 ± 0.3

$\phi 64 \pm 1$

$\phi 57 \pm 1$

1) Mark on tag.

2) Other requirements are as per Technical Specifications
TY 005216-75 for articles, code 253113

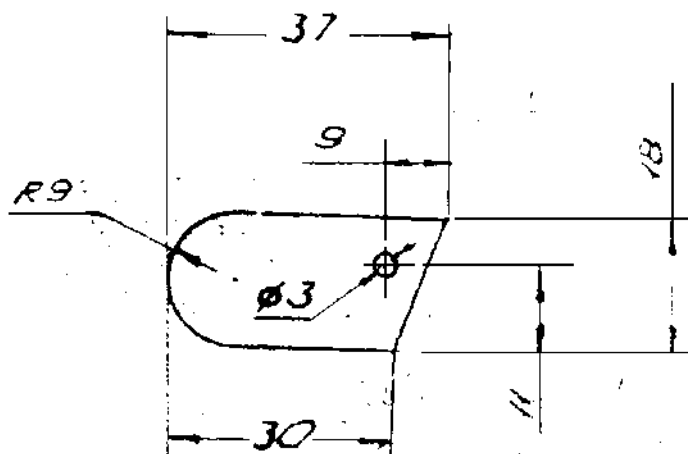
6783-18 220V SEALING CANCELLED
24 6-89

16508-18 220V SEALING CANCELLED
25-8

D101

APPROVED	<i>[Signature]</i> H VASU	765 - 78 - 1406		
CHECKED	<i>[Signature]</i>			
CONTROLLERATE OF INSPECTION (ICV)		SEALING RING	WEIGHT	SCALE
			0,002	1:1
		RUBBER 3825 TY 005216-75	SHT	S ITS

765-78-1437



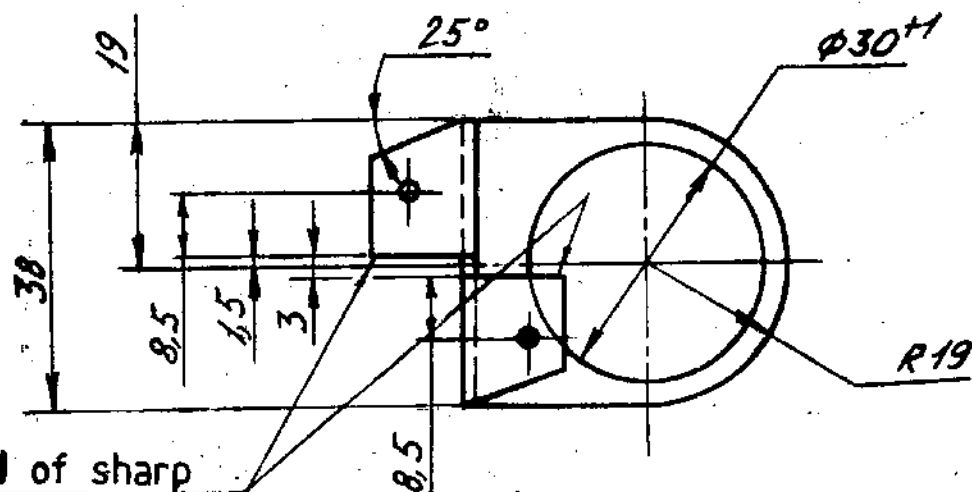
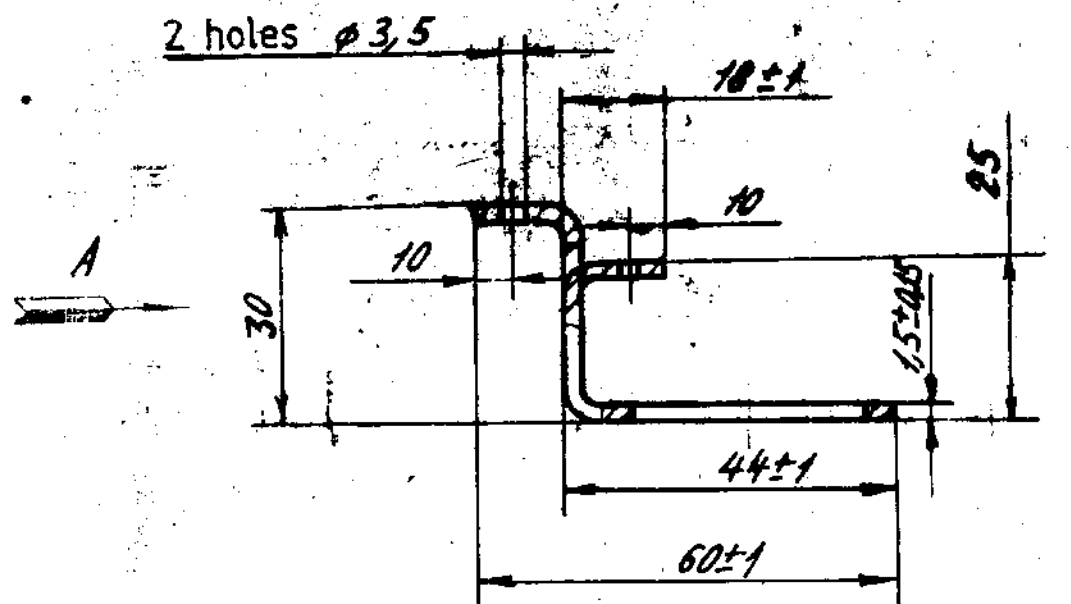
Thickness is 1.5 ± 0.3 .

- 1) Alternate material is rubber plate 1 roll, ПМБ-С-1.5, GOST 7338-77.
- 2) Other requirements are as per Technical Specifications TY 005216-75.

ORGL. MATERIAL: PLATE 254311-15 RUBBE 637 OR 632 TY 005216-75		DATE	ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.		ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON:- 765-78-05533
SCALE:- 1:1				
DATE :- 20-06-95				
DRN. M.L.H.	WT: (kg) 0.005	VALVE		
TCD. M.L.H.				
CHD. 82		765-78-1437		
APD. B.S.				
CONTROLLED BY QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				

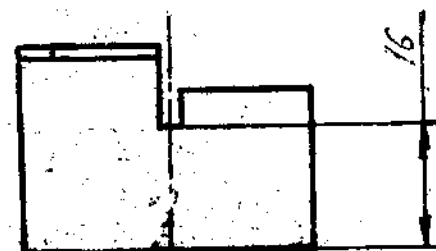
8541-86-596

2



Round of sharp edges with $\approx R 1,5$

View A

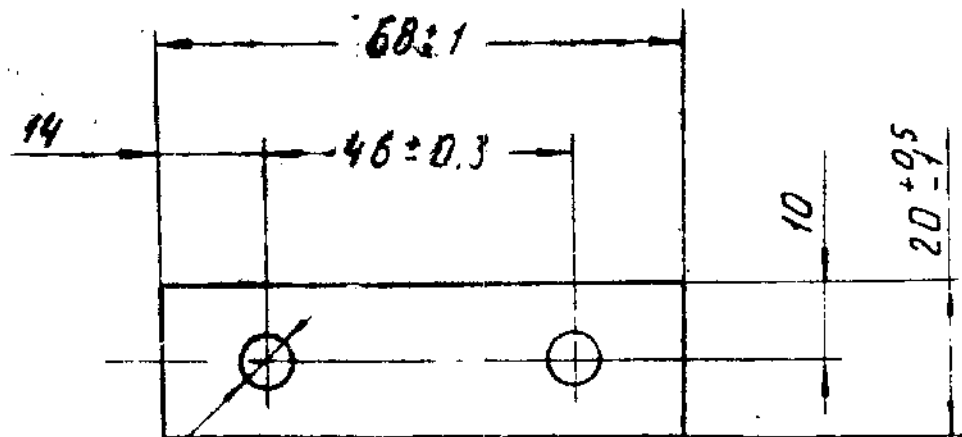


- 1) Blunt sharp edges.
- 2) Provide dimensions without deviations with accuracy of $\pm 0,5\text{mm}$.
- 3) Alternate material is steel 08nc and 08Kn, GOST 9045-80.
- 4) Coating: zink-plated, 24 microns thick, chromotized. Remove hydrogen embrittlement.
- 5) Unspecified radii should not exceed R3.

NEAREST EQVT MATERIAL			
STEEL 10 GOST 1050-74		DRG. REVISED AND RE-TRACED.	
DRGL MATERIAL	DC(I) No & DATE	ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.	ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED			
SCALE:- 1: 1	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON:-
DATE :- 24-10-03			765-78-Cb533
DRN. <i>WV</i>	WT :-(Kg)	765-78-1438	
TCD. <i>WV</i>	0.02		
CHD. <i>WV</i>		BRACKET	
AFD. <i>WV</i>			
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)			

8951-82-591

8

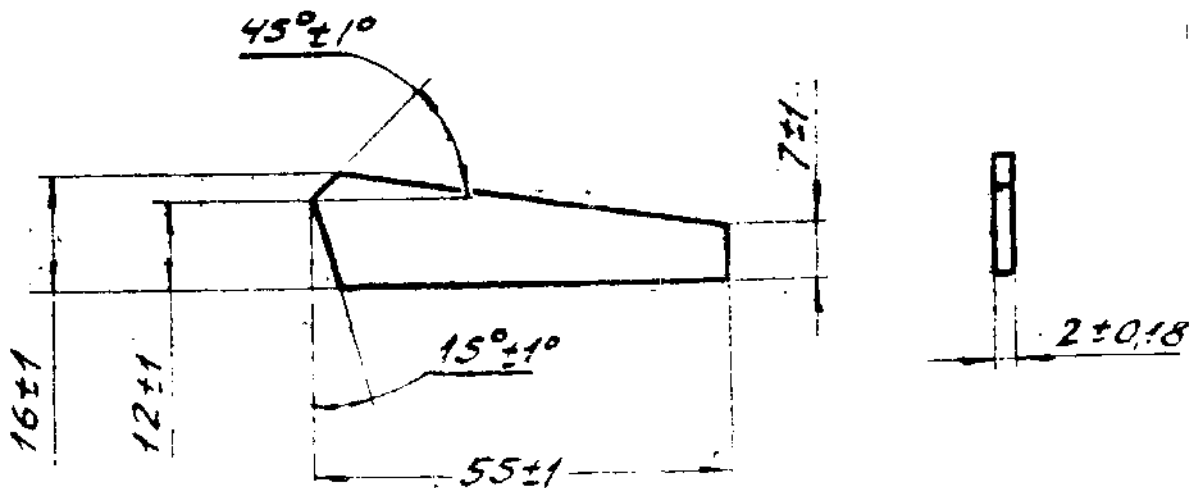
2 holes $\phi 6.3 A7 \pm 0.36$ Thickness = $4 \begin{smallmatrix} +0.4 \\ -0.5 \end{smallmatrix}$

- 1) Burr is not allowed.
- 2) Provide dimensions specified without deviations as per accuracy ± 0.5 .
- 3) Alternate material is steel cm 3cn GOST 380-71 and 10 kn GOST 1050-74.
- 4) Stamping drafts should not exceed 0.4 mm.

ORGL MATERIAL - 20 GOST 1050-74		DC (I) No & DATE	ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.		ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED				
SCALE: - 1:1		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON: - 765-78-534
DATE: - 20-06-95				
DRN. <i>M. M. M.</i>	WT: (Kg) 0.043	STRAP 765-78-1568		
TCD. <i>M. M. M.</i>				
CHD. <i>E. E.</i>				
APD. <i>B. B.</i>				
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				

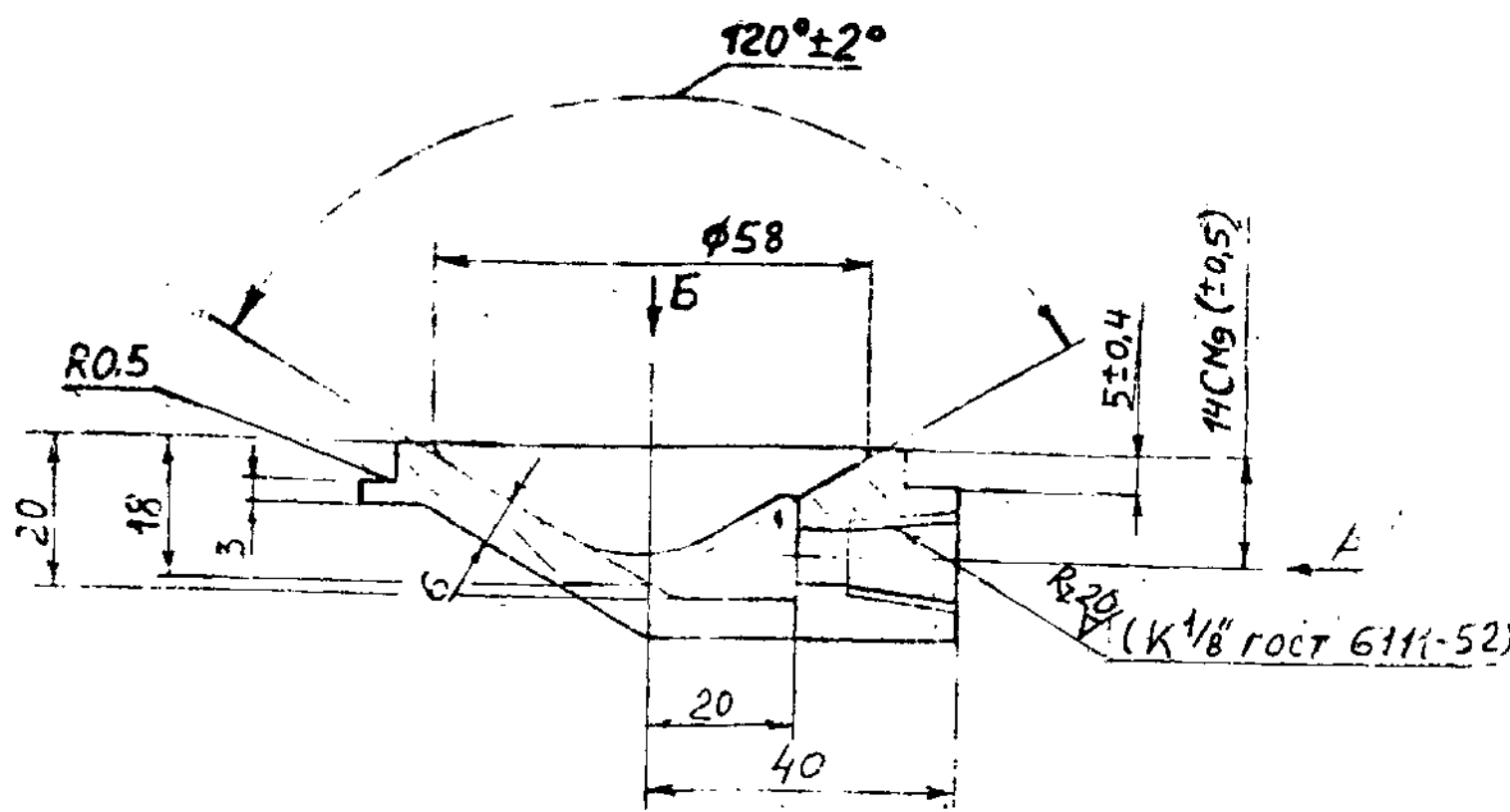
765-78-1579

2

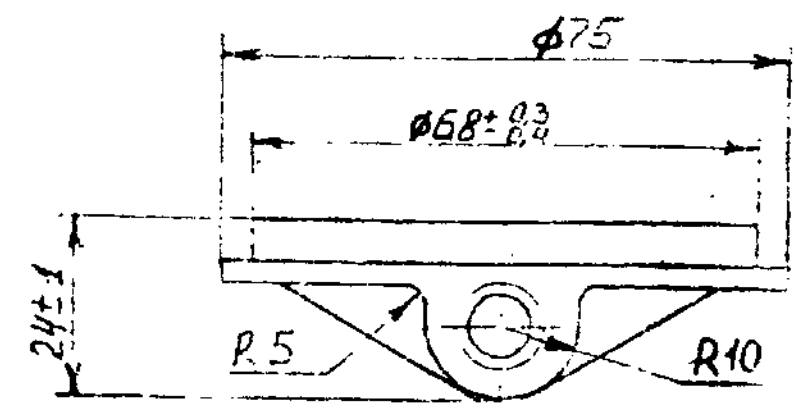


- 1) Burrs are not allowed.
- 2) Alternate material is steel Cm2, GOST 380-71 and 08ПC, 08КП, 10КП GOST 1050-74.

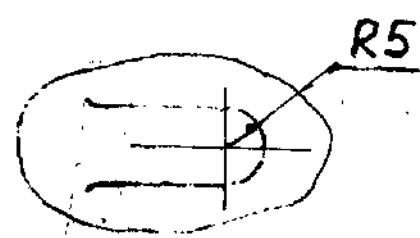
ORGL MATERIAL 10 GOST 1050-74		ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.		ALL THREADS TO CONFORM TO SPECIFICATION.	STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-765-78-0534
SCALE:- 1:1			
DATE :- 19.06.95			
DRN. <i>MLG</i> - <i>R</i> WT: (Kg)		CORNER PLATE	
TCD. <i>MLG</i> - <i>R</i> 0.010			
CHD. <i>92</i>		765-78-1579	
APD. <i>80</i>			
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)			



VIEW A

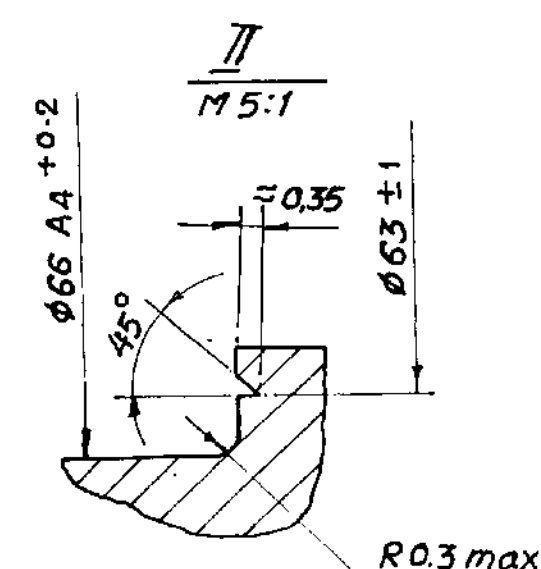
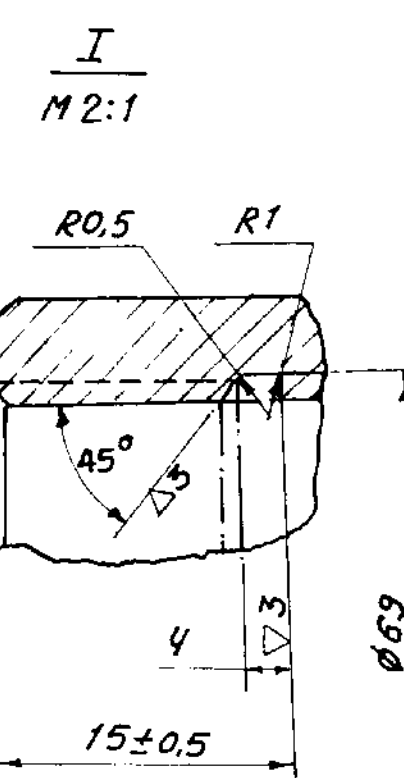
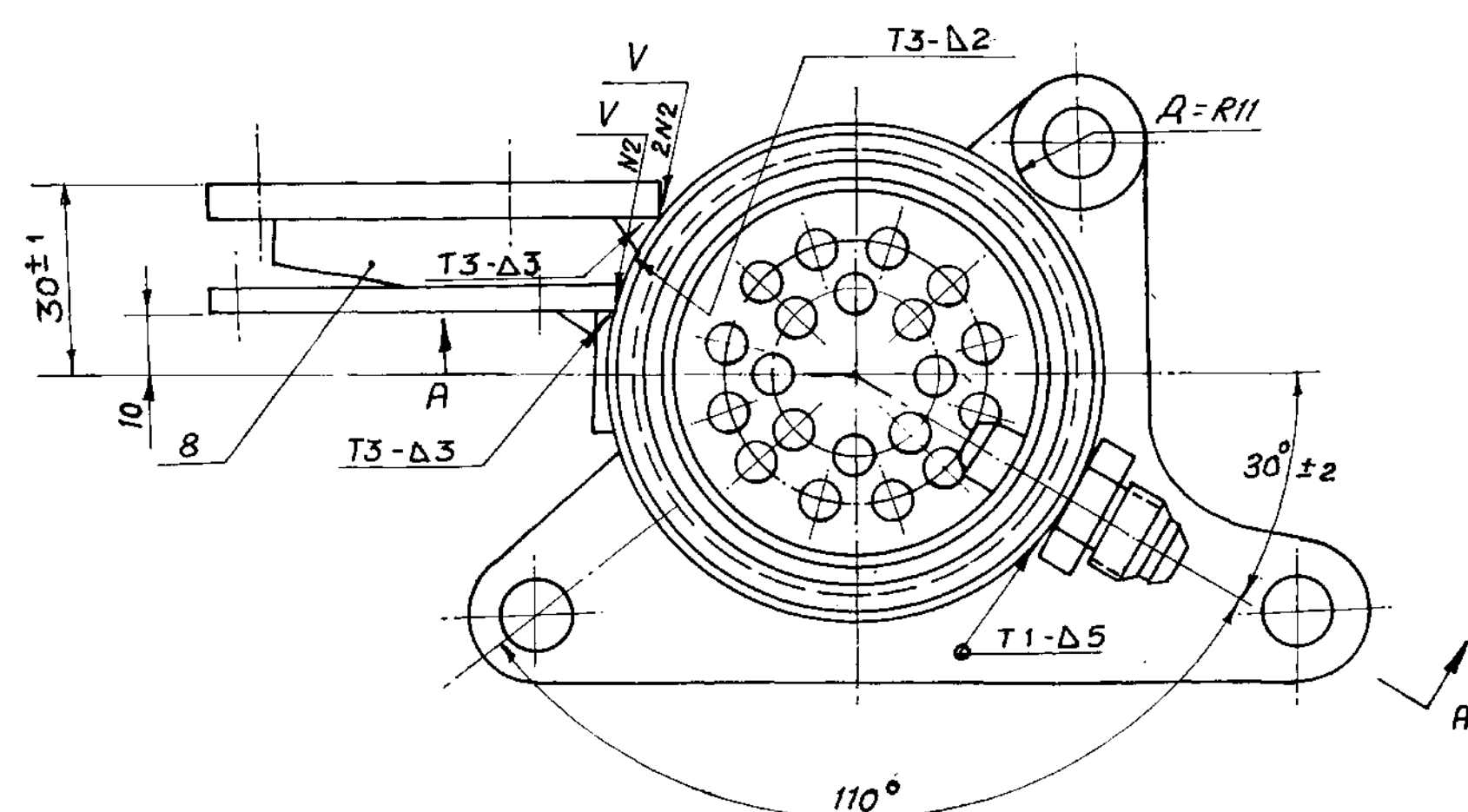
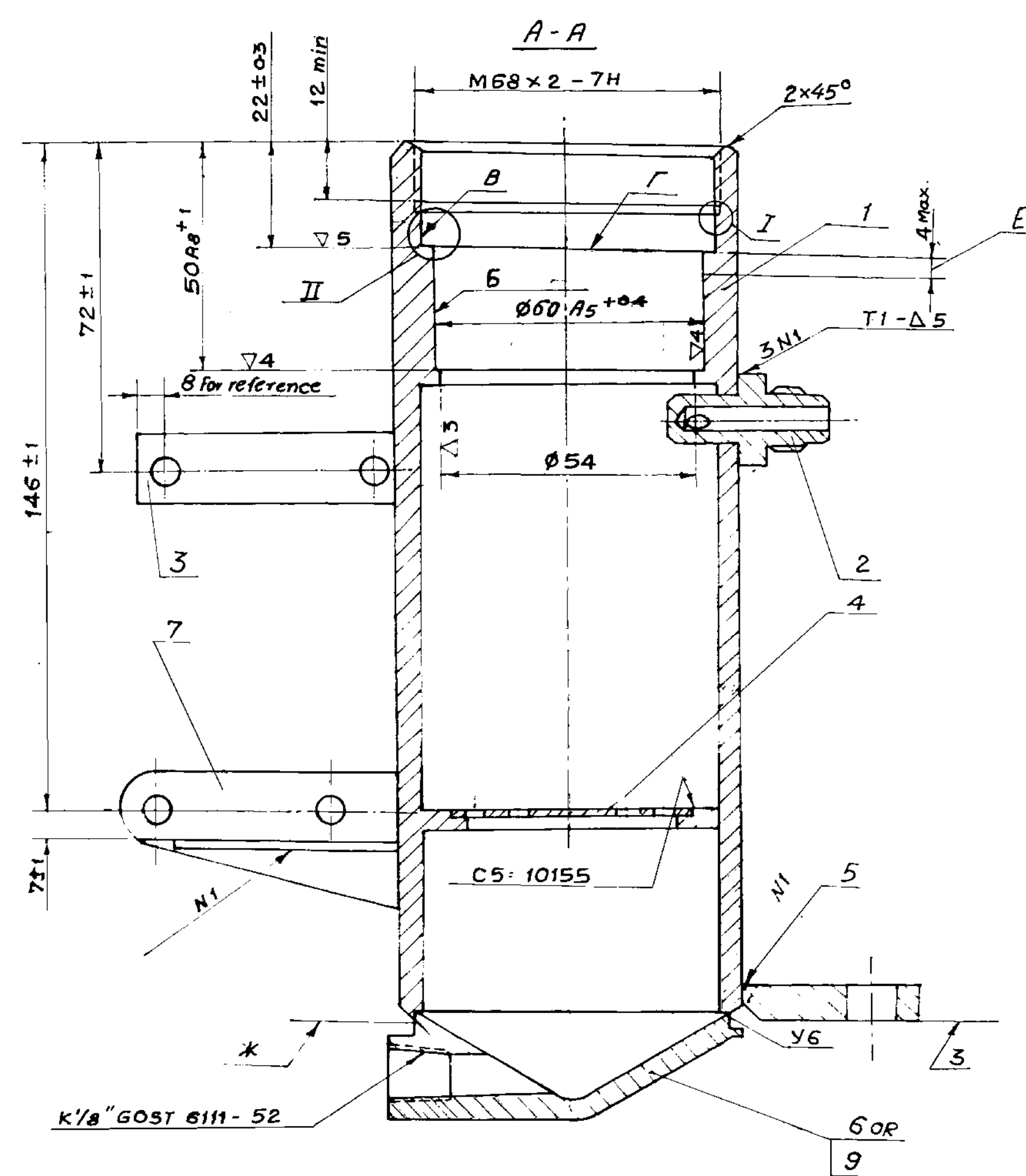


VIEW B



- 1), HB 255 to 302 (φ3.8 to 3.5)
- 2) Unspecified pattern drafts should not exceed 2°
- 3) Unspecified casting radii should not exceed 2 mm.
- 4) Dimensions given in brackets are after assembly.
- 5) Test for air tightness with air at a pressure of 160±10 Kgf/Cm² for 0.5 minute. Leakage of air is not allowed. Test may be performed in assembly

NEAREST EQVT MATERIAL			
CASTING I-OST 3-4365-79			
35x ГСЛ - GOST 977-75			
DRGL MATERIAL	DC(I)No & DATE	ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.	ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		USED ON:-
SCALE:- 1:1			765-78-C5534
DATE :- 21-8-2K			
DRN. <i>[Signature]</i>	WT :- (Kg)	BOTTOM	
TCD. <i>[Signature]</i>	0.265		
CHD. <i>[Signature]</i>		765-78-1712	
APD. <i>[Signature]</i>			
PART NO			
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)			



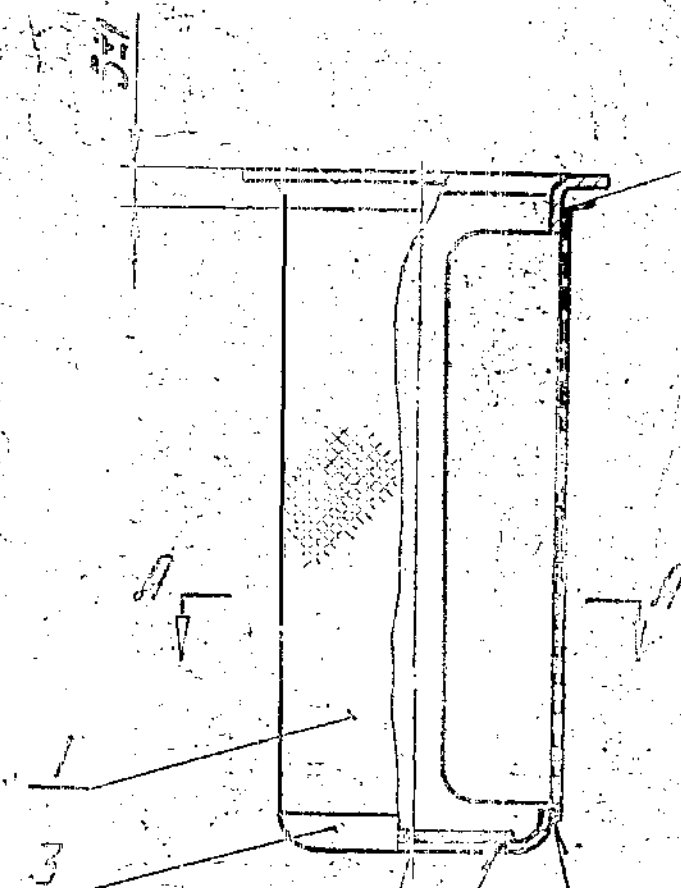
TECHNICAL CONDITION

- 1 BEFORE ASSEMBLING THE PARTS CLEAN THE INTERNAL CAVITIES FROM RUST AND OTHER SURFACE DEFECTS.
2. WELDS SHOULD BE STRONG SOLID WITHOUT CRACKS, BLISTERS AND OTHER DEFECTS.
3. DRESS WELDS, BLUNT SHARP EDGES
4. PROTECT THREADED SURFACE OF UNION FROM METAL DRIPPLES DURING WELDING.
- 5 AFTER WELDING REMOVE STRESS, SAND BLAST THE INTERNAL SPACE AND COAT WITH THE BAKELITE VARNISH 115C-1 GOST 901-78 AS PER INSTRUCTIONS 053, 25273.00010 EXCEPT SURFACE B, Г AND THREADS. IT IS ALLOWED TO BAKELITE ALL OVER, IN THIS CASE PROTECT THREADED AND LOCATING SURFACES.
- 6 TEST FOR LEAK PROOFNESS WITH WINTER FUEL 3-0.5 OR SUMMER FUEL 11-0.5 GOST 305-73 AT A PRESSURE OF $225 \pm 5 \text{ kgf/cm}^2$ FOR 5 MINUTES. LEAKAGE AND SWEATING IS NOT ALLOWED.
- 7 PRIME THE EXTERNAL SURFACE EXCEPT THREADED SURFACES WITH PRIMER 07-223, DARK GRAY GOST 14923-78
- 8 MARK ON PART REF. No. 2 SHOULD BE TURNED UPWARDS DEVIATIONS FROM VERTICAL LINE SHOULD NOT EXCEED 2mm TO ANY SIDE.
- 9 WHILE TACKING REF. No. 3, 4 BURNING THROUGH IS ALLOWED.
- 10 WITH RESPECT TO THE ANGULAR DIAMETER OF THREAD THE FOLLOWING IS ALLOWED
 - a) RUN-OUT OF SURFACE B AND B SHOULD NOT EXCEED 0.1mm (QUALIFIED TOLERANCE)
 - b) RUN-OUT OF SURFACE Г SHOULD NOT EXCEED 0.06mm.
11. WELD IS NOT ALLOWED ON TOP AND BOTTOM ON SECTION, LIMITED BY RADIUS R
13. IT IS ALLOWED TO MAKE THE SETTLER ALONG THE CONVENTIONAL DOTTED LINE.
15. DEVIATIONS OF SURFACES 11 AND 3 FROM THE COMMON MATING PLANE SHOULD NOT EXCEED 1mm.
16. ABSENCE OF BAKELITE ON SECTION E OF SURFACE B IS ALLOWED.
17. MAKE WELDS AS PER GOST 14771-76.

6	765-78-1242	BOTTOM		one Piece may be replaced by Ref.No3
9	765-78-1712	BOTTOM		one Piece may be replaced by Ref.No6
8	765-78-1579	CORNER PLATE	1	
		ENAMEL nØ-223 DARK GREY		
		PRIMER Øn-03K		
		BAKELITE VARNISH		
7	765-78-1243	STRAP	1	
3	765-78-1568	STRAP	1	
5	765-78-1241	FLANGE	1	
4	765-78-1240	GRID	1	
2	765-78-1238	UNION	1	
1	765-78-1237	BODY	1	
Ref. No.	Designation	description	Qty	Remarks

MATERIAL		ISSUING DATE	ISSUES	AMENXMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.		ALL THREADS TO CONFORM TO SPECIFICATION.	STAMP OR ETCH, PART NO., MANUFACTURER'S NAME & YEAR OF MFR.	
DRG. NOT TO BE SCALED				
SCALE:- 1:1		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-	
DATE :- 22-03-2004			765-78-C6 533	
DRN. <i>As made</i>	WT. :-(Kg)	(A) <i>DS CAT No. LV2/ICVS 2340-000397</i> 765-78-C6 534		
TCD. <i>As made</i>	2.47			
CHD. <i>As made</i>				
APD. <i>As made</i>				
		SETTLER		
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				

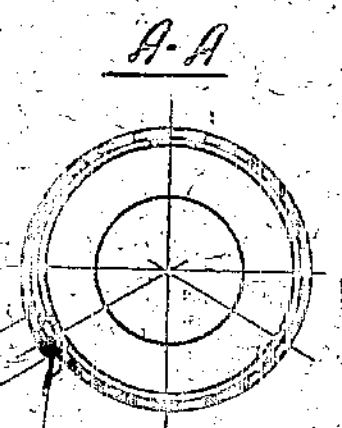
765-78-08.535



SOLDER WITH
ПОССУ 30-2

1. SOLDERD SEAM SHOULD BE LOCATED OPPOSITE TO ONE OF THE
WEBS OF BODY.

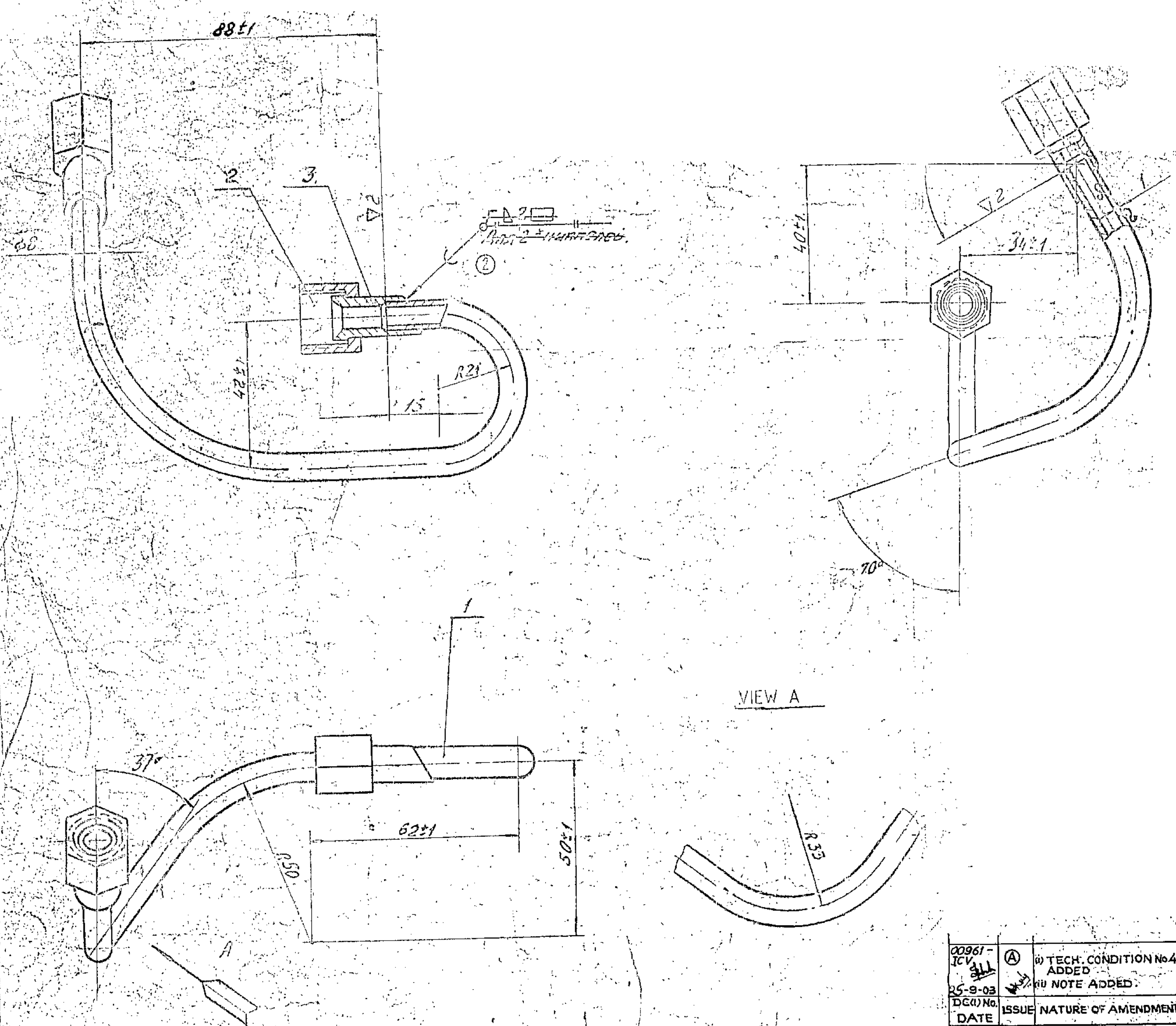
SOLDER WITH
ПОССУ 30-2



SOLDE WITH
ПОССУ 30-2

		SOLDER	ПОССУ30-2	
			ГОСТ 21931-76	
3	765-78-1246	BODY	1	
12	765-78-1245	GAUZE	1	
1	765-78-1244	GAUZE	1	
REF	DESIGNATION	DESCRIPTION	QTY	REMARKS

MATERIAL : —		ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF			
DRG. NOT TO BE SCALED		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:—
SCALE :- 1:1			
DATE :- 20-06-95		FILTER	
DRN: SP. 20-06-95	WT :- (Kg) 0.045		
TCD		765-78-C8535	
CHD			
APD		QUALITY ASSURANCE	



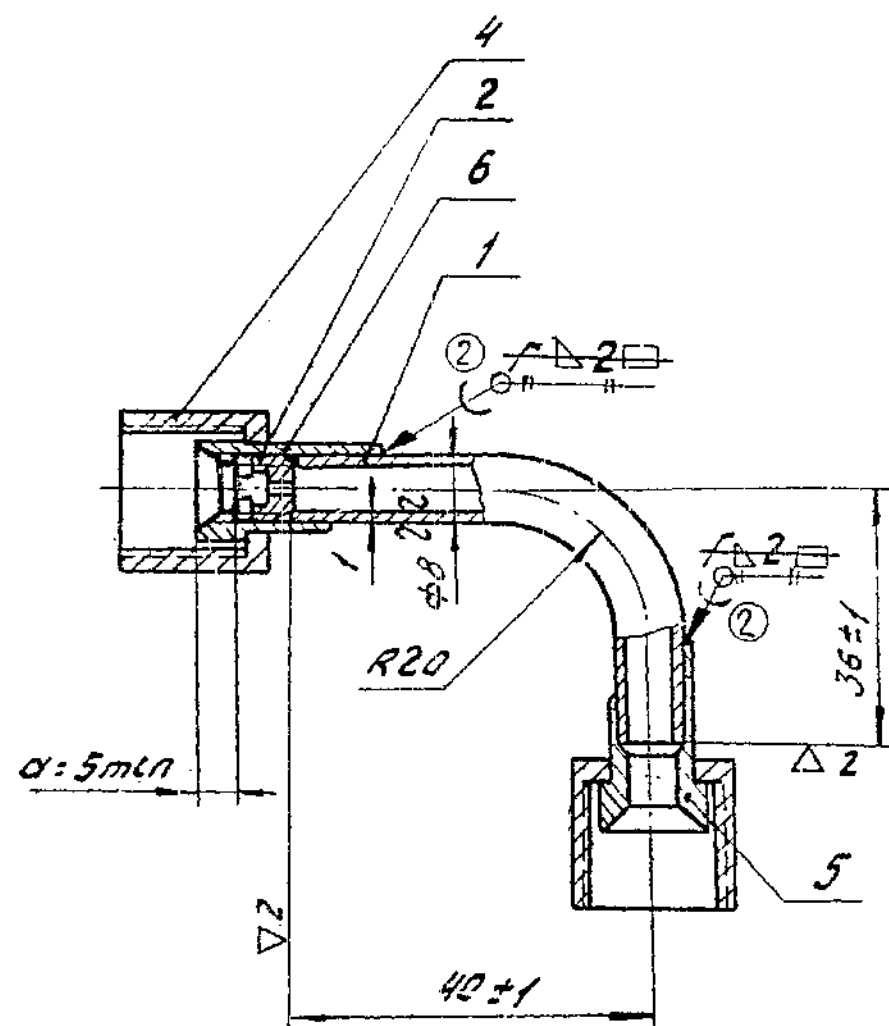
- 1) Make part Ref.No. 1 from pipe 8x1 -20-A, GOST19277-73
Weight is 0.019.
 - 2) Test pipe for leakproofness with air in water bath at
a pressure of $160 \pm 10 \text{ kg/cm}^2$ for one minute. Appearance
of air bubbles are not allowed.
 - 3) Other requirements are as per 765-78-101 TT.
- (A) 4) ITEM No.1, PIPE DEVELOPED LENGTH IS $255 \pm 3 \text{ mm}$.**

(A) NOTE: OFMK WILL PROVIDE SEALED SAMPLES TO THE SUPPLIER FOR GUIDENCE DURING MANUFACTURING OF THE ITEM.

		Enamel ПФ-223		
		Blue		
		Primer ФП-03-K		
		Varnish ГФ-95		
3	700-57-403	Nipple	2	
2	700-30-241	Union nut	2	
1	765-78-1248	Pipe	1	Without drawing
Ref. No.	Designation	Description	Qty	Remarks

MATERIAL : —		ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH. PART NO.
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF			MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-
SCALE :- 1:1			765-78-C0533
DATE :- 20-6-95		765-78-C0533	
DRG. <i>Pathak</i>	WT :- (Kg) 0-068		
REL. <i>DR</i>		PIPE	
CHL			
APP. <i>Path</i>			

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)



1. Make part, Ref.No.1; from pipe 8x1 20A GOST 19277-73, weight is 0,015.
2. Test pipe for leak proofness with air in water bath at a pressure of $160 \pm 10 \text{ Kg/Cm}^2$ for 1 minute. Appearance of air bubbles is not allowed.
3. Screw the jet into nipple as far as it will go so that dimension "a" is provided.
4. Other requirements are as per 765-78-101TT.

		PRIMER ϕ 03 K		
		ENAMEL $\Gamma \phi$ -223		
		BLUE		
		VARNISH $\Gamma \phi$ -95.		
6	700-57-404	NIPPLE	1	
5	700-57-403	NIPPLE	1	
4	700-30-241	UNION NUT	2	
2	765-78-1257	JET	1	
1	765-78-1249	PIPE	1	With out drg

28-1-03	(A)	D.O. CORRECTION
DC(1) No DATE	ISSUE	NATURE OF AMENDMENT

MATERIAL:-			DATE: _____		
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF		ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.		
DRG. NOT TO BE SCALED					
SCALE: 1:1		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON: 765-78-Sb533		
DATE:- 20-6-95					
DRN.	Wathani	WEIGHT: (Kg.)	765-78-Sb537		
TCD.		0.065			
CHD.	See				
APD.	1500				
PIPE					
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)					