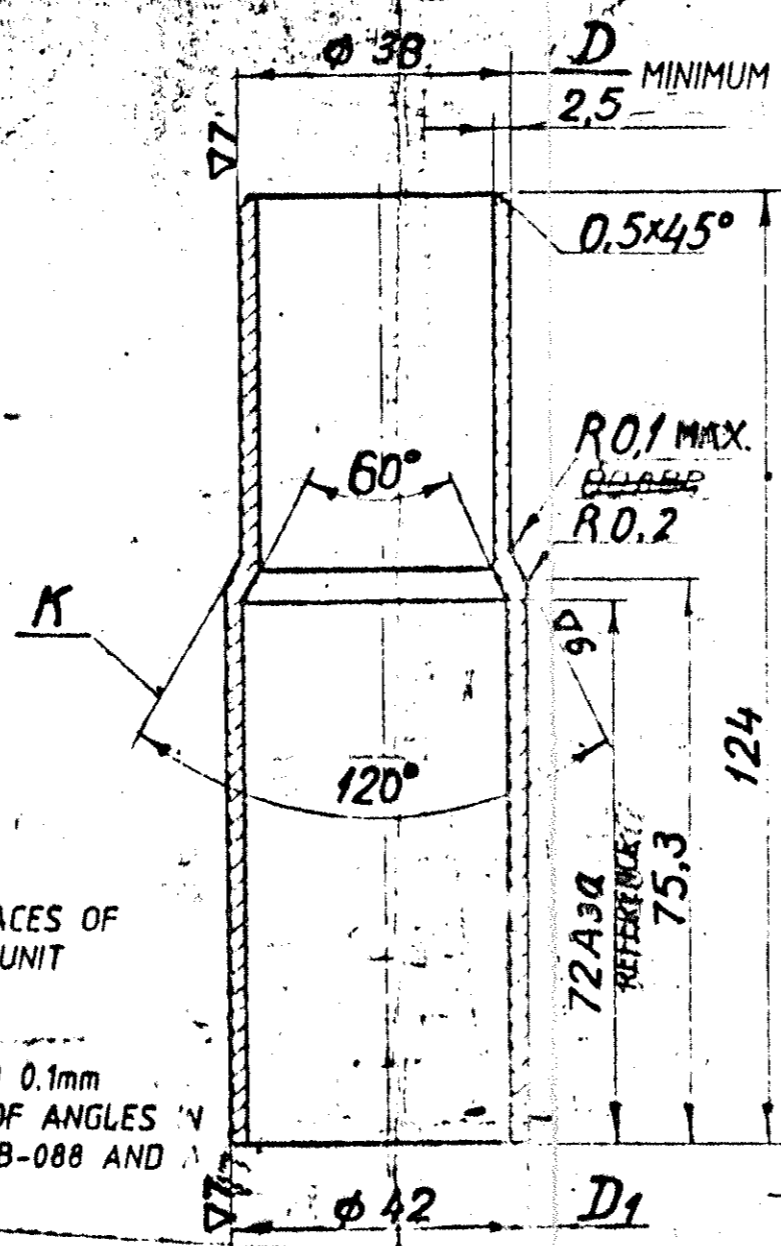


DRAWING NUMBER
AK 150 B - 088

UNLESS STATED OTHERWISE

TOLERANCES ON FREE DIMENSIONS ARE
AS PER 22AT52 CLASS 7.



FINISH SURFACES D AND D₁ AS PER CORRESPONDING SURFACES OF
PART AK150H-054 PROVIDING SPECIFIED INTERFERENCE IN UNIT
AK150H-15.

A GROOVE WITH WIDTH UPTO 1.0mm, DEPTH IN A DIA UPTO 0.1mm
IS ALLOWED ON SURFACE D AT THE TAPER. DIFFERENCE OF ANGLES
IN GAUGES USED FOR CHECKING TAPERS OF PARTS AK150B-088 AND
AK150H-054 SHOULD NOT EXCEED 20'.

CHECK SURFACE K BY BLUEING.

CLOSE FIT AS PER GAUGE SHOULD NOT BE LESS THAN 75%.

QUALITY AND TAPER OF SURFACES D AND D₁ SHOULD NOT
EXCEED 0.01 mm.

RUN OUT OF SURFACE D WITH RESPECT TO SURFACE D₁ SHOULD NOT
BE MORE THAN 0.02 mm.

MAINTAIN IN UNIT AK150H-15.

HRC 32 TO 38

ALT. MATL:-
STEEL 40Cr4Mo3 TO IS: 8517-78
OR En 19 TO BS: 970. HRC. 32-38.

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

EST. MASS. 316	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 OUT-
SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

ISSUE	DATE	NATURE OF AMENDMENTS

DRN *CPR*
 CHD *Bhattacharya*
 TCD *V.Ram*
 APPD *[Signature]*
 DATE 22.7.86
 SCALE - 2:1
 DIMENSIONS IN mm
 TOLERANCE ON DIMN
 UNLESS OTHERWISE
 STATED.
 ALL THREADS
 CONFORM TO.

MATERIAL:-
PIPE 4.5 x 6.5 - 38 X A
GOST 21729 - 76

USED ON:
AK 150H-15 C 5

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)
AVADI



TITLE:
SLEEVE CYLINDER
3rd STAGE

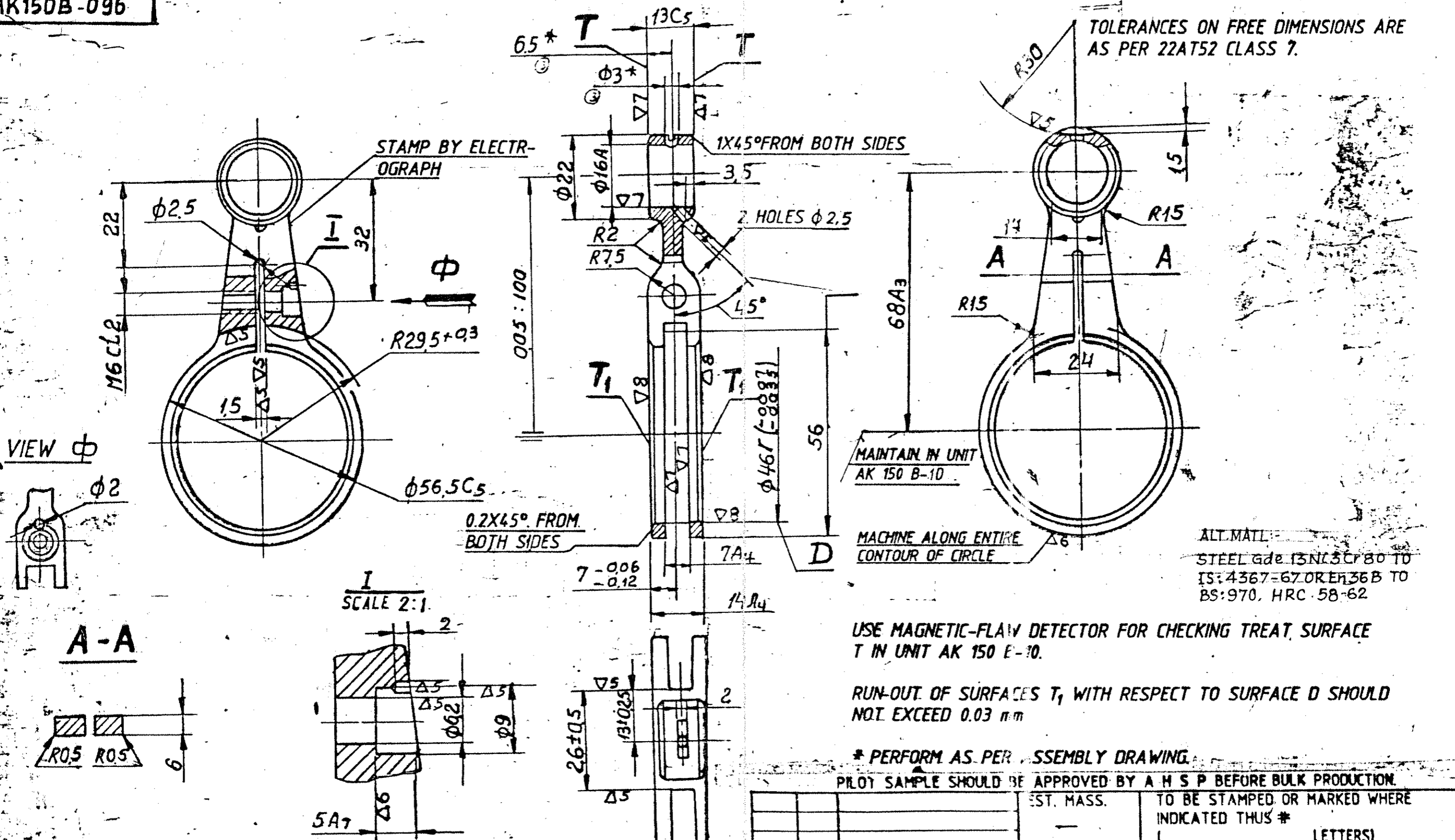
D S CAT NUMBER

DRAWING NUMBER
AK 150 B - 088

DRAWING NUMBER
AK150B-096

UNLESS STATED OTHERWISE

TOLERANCES ON FREE DIMENSIONS ARE AS PER 22AT52 CLASS 7.



MAINTAIN IN UNIT
AK 150 B-10

MACHINE ALONG ENTIRE
CONTOUR OF CIRCLE

ALT. MATL:-
STEEL gde. 13Ni2.3Cr80 TO
IS: 4367-67 OR EN36B TO
BS: 970, HRC 58-62

USE MAGNETIC-FLAW DETECTOR FOR CHECKING TREAT. SURFACE
T IN UNIT AK 150 E-10.

RUN-OUT OF SURFACES T₁ WITH RESPECT TO SURFACE D SHOULD
NOT EXCEED 0.03 mm

* PERFORM AS PER ASSEMBLY DRAWING.

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

CARBURIZE SURFACE T₁ TO A DEPTH OF 0.3 TO 0.6 mm OVER LENGTH L
CARBURIZING OF SURFACES T IS ALLOWED.
HARDNESS OF CARBURIZED SURFACE IS HRC 58 TO 62.
HARDNESS OF CORE IS HRC 28 TO 42.

SURFACES, EXCEPT FOR SURFACES T AND T₁ ARE PARKERIZED WITH
OXIDATION. SURFACE D MAY NOT BE PARKERIZED.

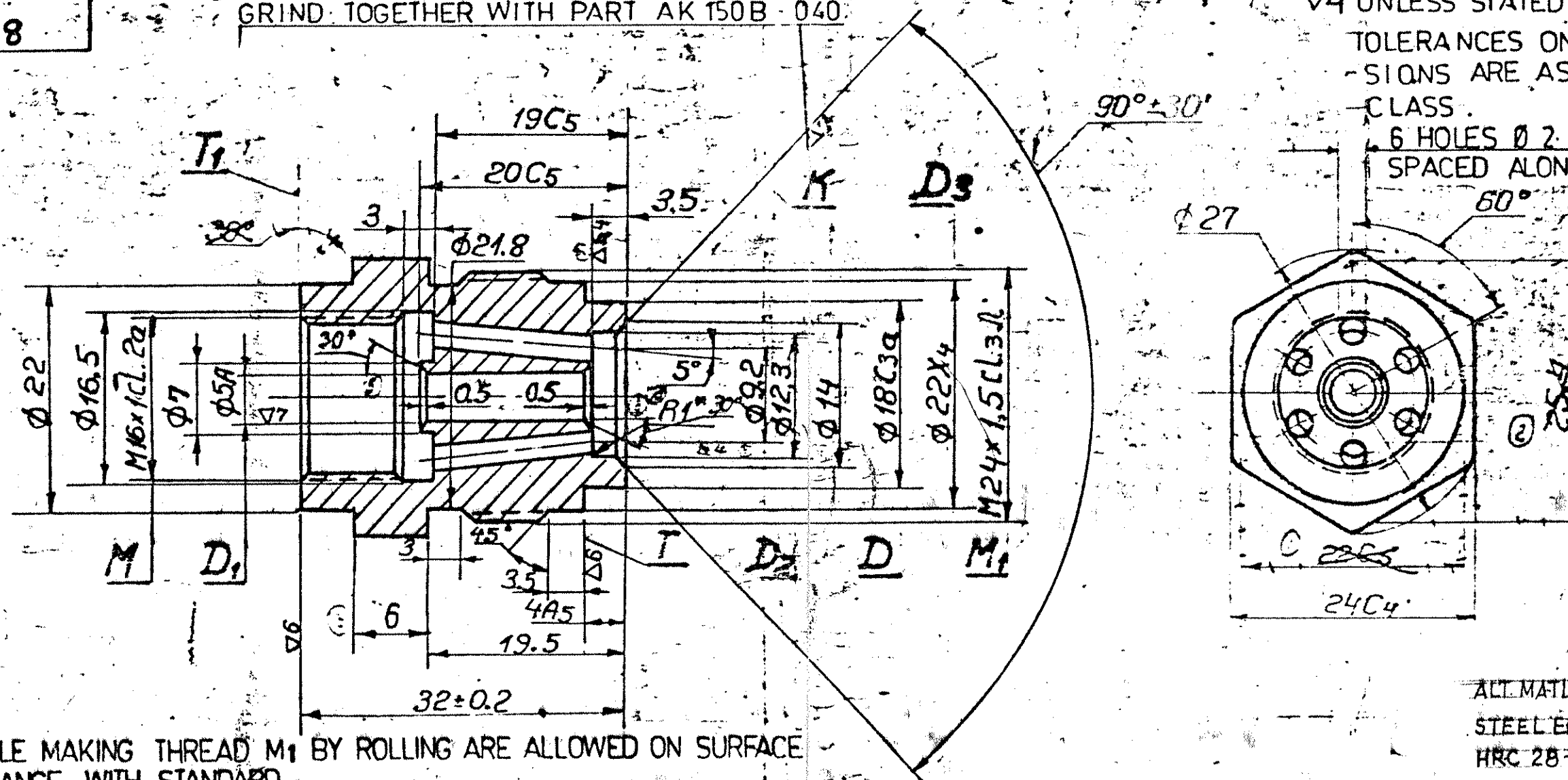
EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THUS *
(LETTERS)	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE FERMSSIBLE.	
ISSUE DATE	NATURE OF AMENDMENT:
DRN	SCALE - 1:1
CHO	DIMENSIONS IN mm
TCD	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.
APPD	ALL THREADS CONFORM TO
DATE	TO
22.7.86	
MATERIAL: STEEL 12XH3A USED ON:- AK 150B-10CB TY14-1-950-74	
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TITLE: MASTER CONNECTING ROD	
D S CAT NUMBER	DRAWING NUMBER
	AK 150B-096

101

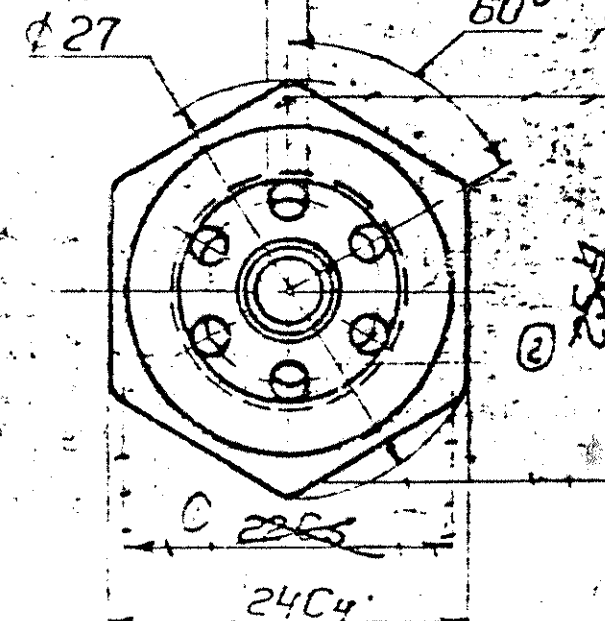
DRAWING NUMBER
AK150B-128

GRIND TOGETHER WITH PART AK150B-040

UNLESS STATED OTHERWISE.
TOLERANCES ON FREE DIMENSIONS ARE AS PER 22AT52-7 CLASS.



6 HOLES Ø 2.8 EQUALLY SPACED ALONG CIRCUMFERENCE



TOOL MARKS WHILE MAKING THREAD M1 BY ROLLING ARE ALLOWED ON SURFACE Ø A 3 IN COMPLIANCE WITH STANDARD.

- RUNOUT OF SURFACE D1 WITH RESPECT TO THE ANGLE DIAMETER OF THREAD M SHOULD NOT EXCEED 0.2.
- DRILL MARKS ARE ALLOWED ON SURFACE D2 AS A RESULT OF DRILLING OF HOLE Ø 2.8. CUTTING IN SURFACE K IS NOT ALLOWED.
- NONSQUARENESS OF SURFACE T1 WITH RESPECT TO ANGLE DIAMETER OF THREAD M SHOULD NOT EXCEED 0.08.
- RUNOUT OF SURFACES D, D3 AND T WITH RESPECT TO ANGLE DIAMETER OF THREAD M1 SHOULD NOT EXCEED 0.08.
- RUNOUT OF SURFACE D2 WITH RESPECT TO D1 SHOULD NOT EXCEED 0.1.
- RUNOUT OF SURFACE K WITH RESPECT TO D1 SHOULD BE CHECKED BY BLUEING; CLOSE FIT AS PER GAUGE IS NOT LESS THAN 75%.
- BROKEN BEARING PATTERN ON SURFACE K IS NOT ALLOWED.
- MAKE CHAMFERS TO THE DEPTH OF THREAD AT AN ANGLE OF 120°.
- ADJUST SURFACE K AGAINST SURFACE K OF VALVE AK150B-040 TO PROVIDE PROJECTION OF VALVE OVER THE VALVE BODY BUTT END OF 0.3.
- THREAD BEFORE COATING IS AS PER 214 AT (EXTERNAL THREAD) AS PER 257 AT (INTERNAL THREAD).

TURNING OF THREAD IS AS PER 299 AT. THREAD MAY BE MADE BY ROLLING.
*DIMENSIONS ARE PROVIDED WITH TOOL COATING: CADMIUM PLATING 9 TO 13 MICRONS THICK FOLLOWED BY OXIDATION EXCEPT SURFACES K AND D1.
HARDNESS HRC 28 TO 35.

ALL MATL
STEEL EN36 TO BS970
HRC 28-35

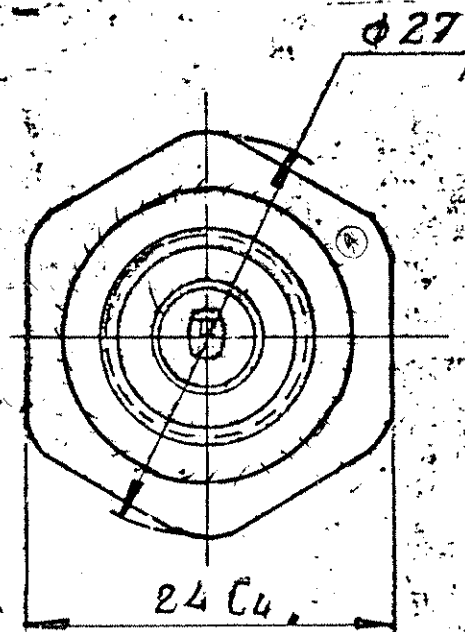
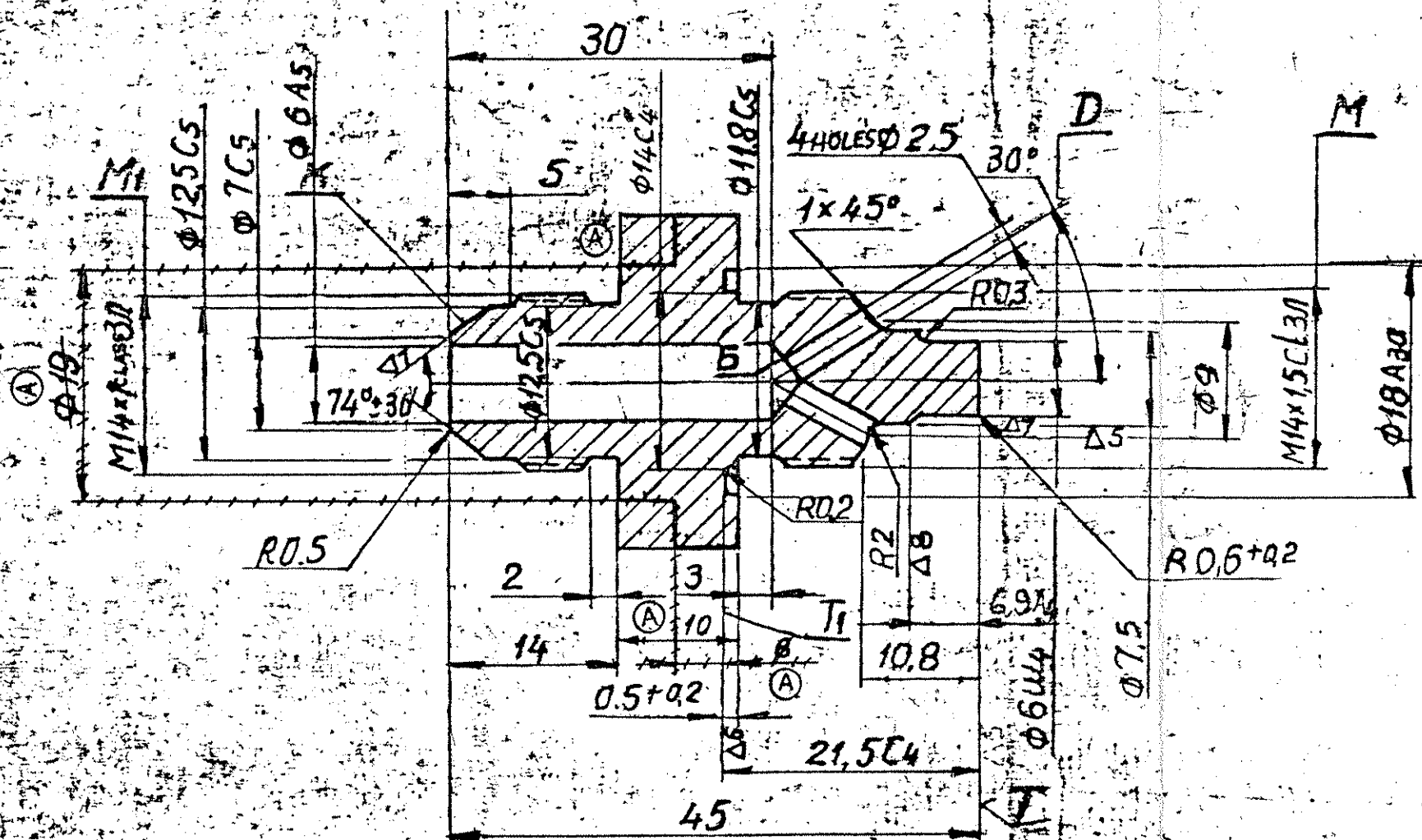
BY PARKERISING

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

EST. MASS.	69	TO BE STAMPED OR MARKED WHERE INDICATED THIS #	LETTERS)
ISSUE DATE	NATURE OF AMENDMENTS	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
DRN	SCALE - 2:1	MATERIAL:- STEEL 38xA	USED ON:-
LDH	DIMENSIONS IN mm	TY14-1-950-74.	AK150B-36CB
TCU	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APPD		TITLE: VALVE BODY	
DATE	ALL THREADS CONFORM TO	G S CAT NUMBER	DRAWING NUMBER
22.7.8			AK150B-128

DRAWING NUMBER
AK 150 B -130

UNLESS SPECIFIED OTHERWISE
TOLERANCE ON FREE DIMENSIONS
ARE AS PER 22AT52-7 CLASS.



- RUNOUT OF SURFACE T1 WITH RESPECT TO ANGLE DIAMETER OF THREAD M SHOULD NOT EXCEED 0.08mm.
- RUNOUT OF SURFACE D WITH RESPECT TO ANGLE DIAMETER OF THREAD M SHOULD NOT EXCEED 0.1mm.
- RUNOUT OF SURFACE T WITH RESPECT TO D SHOULD NOT EXCEED 0.03mm.
- RUNOUT OF SURFACE K WITH RESPECT TO ANGLE DIAMETER OF THE THREAD M SHOULD NOT EXCEED 0.05mm.
- DRESS BURRS AT EDGES B.
- THREAD MAY BE MADE BY ROLLING.
- CENTRAL SEAT A 0.7 GOST 14034-68 IS ALLOWED.
- THREAD BEFORE COATING IS AS PER 214 AT.
- THREAD TURNING IS AS PER 299 AT.

HRC 28 TO 35.
CADMIUM PLATING IS 9 TO 13
MICRONS THICK.

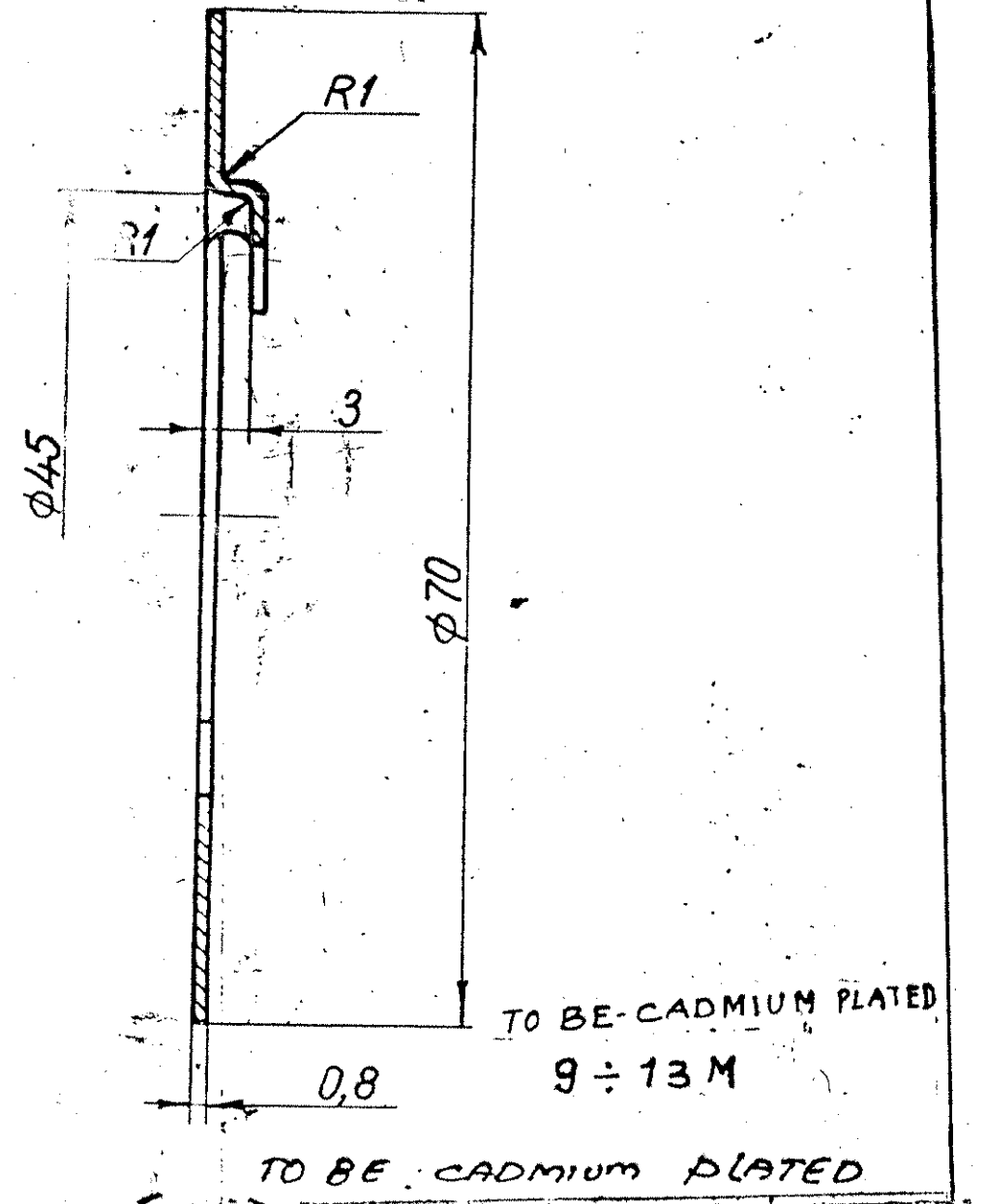
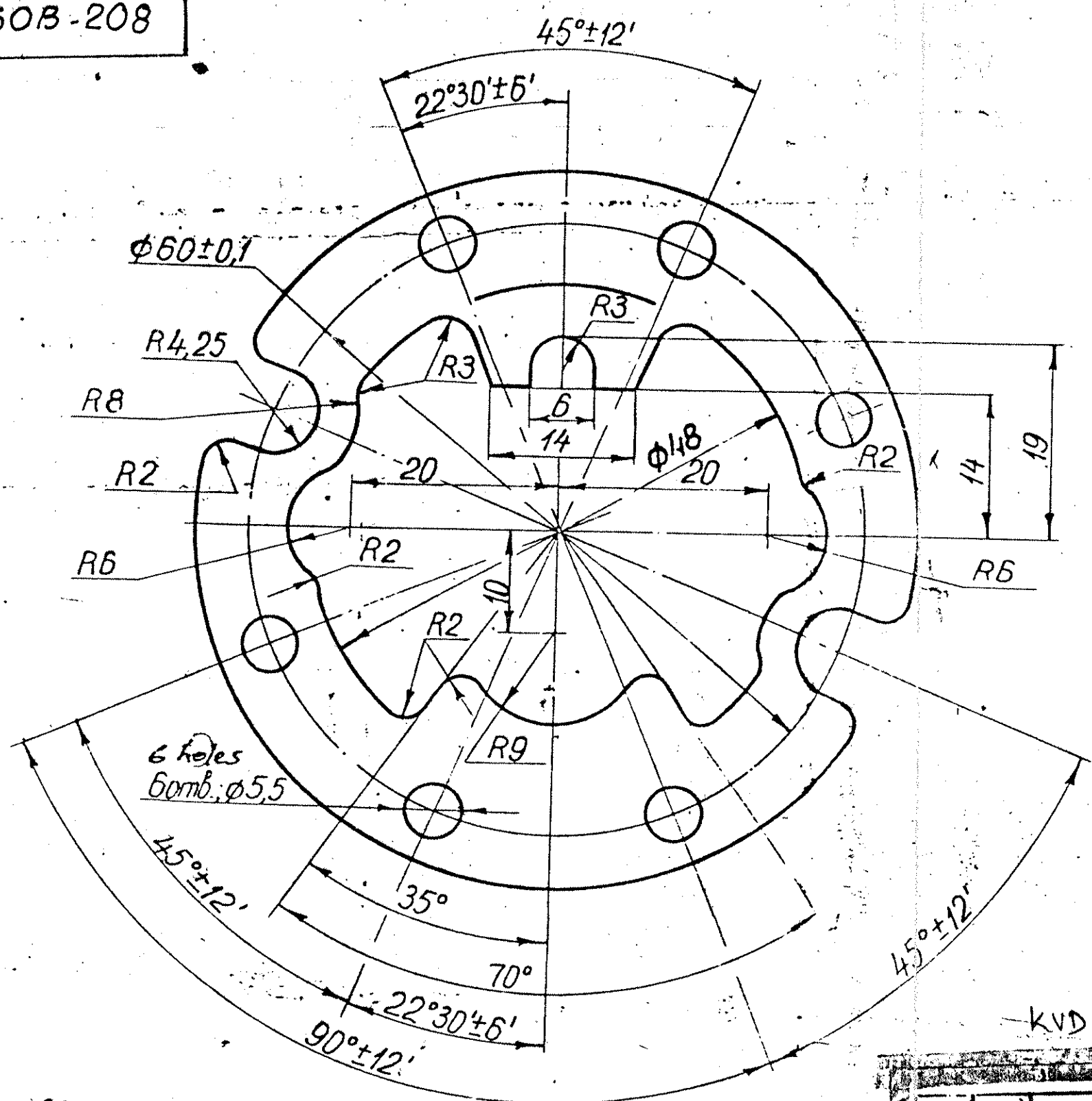
ALT. MATL:- STEEL 40Cr4Mo3 TO IS: 5517-78
OR EN 19 TO BS: 970-28-35 HRC

A 22-1-2001 NOFA No. CBA(HV) 145/006		PLOT SAMPLE SHOULD BE APPROVED BY A.H.S.P. BEFORE BULK PRODUCTION.	
ISSUE DATE	NATURE OF AMENDMENTS	EST. MASS.	TO BE STAMPED OR MARKED WHERE INDICATED THUS *
22.7.86		44	(LETTERS)
TURN	SCALE:- 2:1	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
CHD	DIMENSIONS IN mm	MATERIAL:-	USED ON:- AK150B-33CB
CD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	STEEL 38XA	
APPD	ALL THREADS CONFORM TO	Y 14-1-950-74	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
			TITLE: UNION
		D S CAT NUMBER	DRAWING NUMBER AK150B-130

124

DRAWING NUMBER
AK 150B-208

Допуски на свободные
размеры по 22AT52-7кл.
TOLERANCES ON FREE
DIMENSIONS AS PER 22AT
52-C.I.7.



BURRS SHOULD BE DRESSED
Зачистить заусеницы.

ALT. MATL.
STEEL GDE 'D' TO IS: 513-86

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

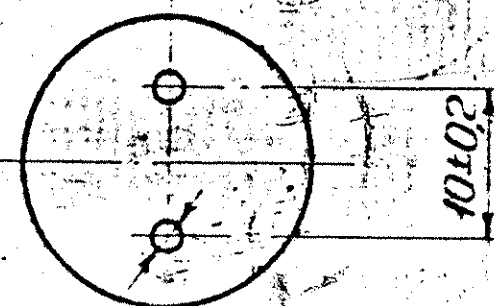
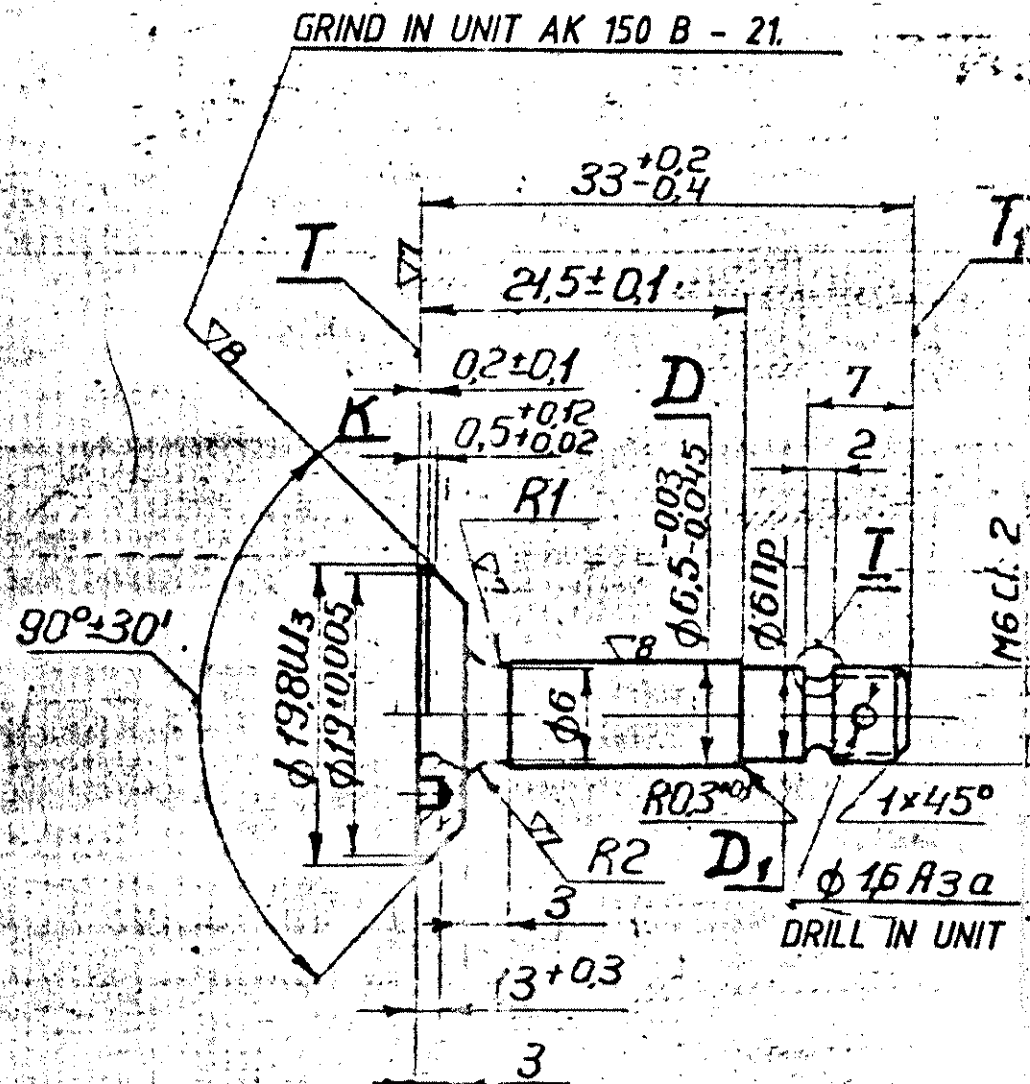
KVD-74805

ISSUE DATE		NATURE OF AMENDMENTS		E.T. MASS 14		TO BE STAMPED OR MARKED WHERE INDICATED	
DRN 2.5/28		SCALE - 2:1		MATERIAL - STEEL 10 GOST. 16523-70		USED ON: AK 150C-0106	
CND 2.5/28		DIMENSIONS IN mm.		CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADL		TITLE: GASKET	
TCD 2.5/28		TOLERANCE ON DIMS UNLESS OTHERWISE STATED.		S CAT NUMBER		DRAWING NUMBER AK150B-208	
APPR 2.5/28		ALL THREADS CONFORM TO					

137

DRAWING NUMBER
AK150B-213

▽ 4 UNLESS OTHERWISE SPECIFIED.
TOLERANCE FOR FREE DIMENSIONS ARE
AS PER 22AT52-7 CLASS.



2 HOLES φ2

SCALE 10:1

THREAD MAY BE FREE FROM OXIDIZED LAY
H R C 32 TO 38.
TO BE OXIDIZED EXCEPT FOR SURFACES
K AND D
REDUCE HARDNESS OF THREAD TO HRC ≤ 32

ALT. MATL.:
STEEL EN36 TO BS:970

GROUP NO.	DIMENSION D _i
I	φ 6,015 ^{+0,004}
II	φ 6,019 ^{+0,004}

CHECK RUN-OUT OF SURFACE K WITH RESPECT TO SURFACE D
WITH GAUGE BY BLUING BREAKS IN IMPRINT CIRCLE ARE NOT
ALLOWED.

CENTRE SEAT A 0.7 OST 3725, IS ALLOWED ON BUTT-END T.

DRILL MARK HAVING DIAMETER AND DEPTH OF U TO 1 MM
IS ALLOWED ON BUTT-END T₁.
THREAD MAY BE MADE BY ROLLING.

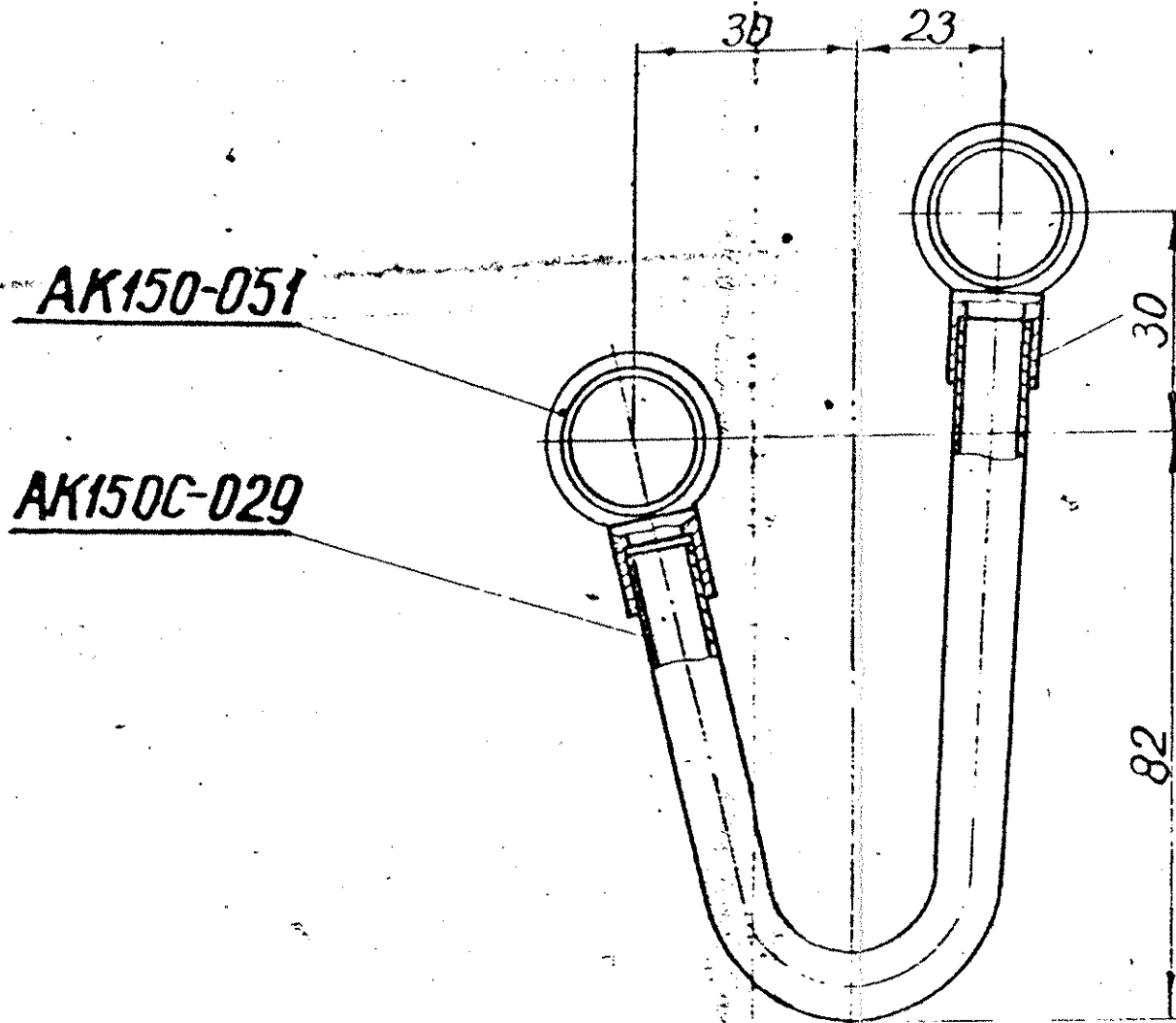
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. MASS.	13	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 OUT- SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		
ISSUE DATE	NATURE OF AMENDMENTS	USED ON:-
DRN h. Pr...	SCALE - 2:1	AK 150B 60 C5
CHD Ad...	DIMENSIONS IN MM	MATERIAL:- STEEL 40xHMA TY14-1-950-74.
TCD h. Pr...	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPD h. Pr...	ALL THREADS CONFORM TO	TITLE: VALVE SUCTION
DATE	D S CAT NUMBER	DRAWING NUMBER AK 150B 213

6776

6754

AK 150 C - 15 CB



PRIOR TO BRAZING WITH SILVER SOLDER,
 Перед пайкой серебряным
 припоем подобрать зазор 0,05±0,025
 TAKE UP CLEARANCE WITHIN 0.05-0.025

Кадмировать 15-21 м.
 Внутренние поверхности раз-
 решается не кадмировать.

1. BRAZE THE PLACES OF CONNECTIONS ALONG THE ENTIRE SURFACE OF CONNECTION WITH SOLDER ncp45 OR BRASS SOLDER. SCALES AND OTHER FOREIGN SUBJECTS ARE NOT ALLOWED ON THE INNER SURFACE. SUBJECT THE INNER SPACE TO PRESSURE TEST FOR 3 MINUTES UNDER THE PRESSURE OF 10 kg/cm². CHECK THE HOUSING FOR TIGHTNESS UNDER THE AIR PRESSURE OF 7 kg/cm². ADJUST POSITION OF SURFACES OF PIPE UNIONS USING DUMMY. DURING ASSEMBLY FITTING, OVALITY IN THE PLACES OF RADIUS BENDING SHOULD NOT EXCEED 1.5, COATING: Cd 15 to 21. THE INNER SURFACES MAY NOT BE CADMIUM PLATED.

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

EST. MASS.		TO BE STAMPED OR MARKED WHERE INDICATED THUS * (LETTERS)	
64			
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	MATERIAL:-	USED ON:-
DRN CPE	SCALE - 1:1		AK 150 C - 01 CB
CHD	DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE: PIPE LINE FIRST STAGE ASSY	
APPD	ALL THREADS CONFOR TO	D S CAT. NUMBER	DRAWING NUMBER
DATE 22.7.86			AK 150 C - 15 CB

DRAWING NUMBER
AK150C-19C5

AK150B-210

AK150B-117

AK150B-145

AK150B-60

AK150B-085

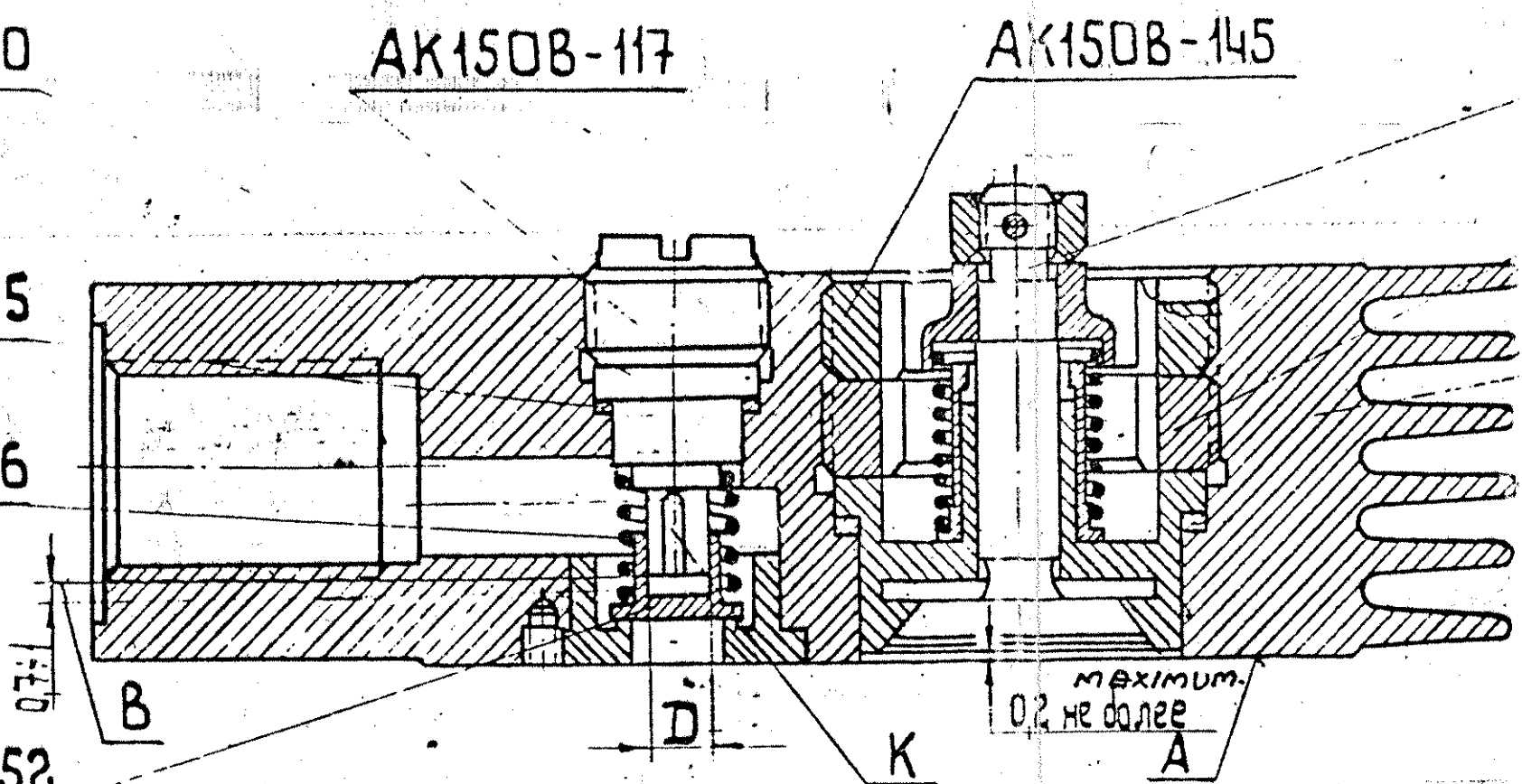
AK150B-079

AK150B-116

AK150C-40

AK150B-050

AK150B-052



SEPARATE LAPPING OF
Допускается раздельная
притирка поверхностей
SURFACES IS ALLOWED

MAXIMUM
0.02 мм

Valve Guide
1st Stage Ass.

1. ENSURE VALVE STROKE WITHIN 0.7 TO 1 BY SELECTING WASHERS AK 150B-085 OF THE REQUIRED THICKNESS.
2. FILING OF SURFACE B IS ALLOWED
3. NON SQUARENESS OF SURFACE B RELATIVE TO SURFACE D SHOULD NOT EXCEED 0.1.
4. SURFACE A MAY BE LAPPED WITH SURFACE FINISH SIGN AT LEAST V7.
5. CONVEXITY OF SURFACE A SHOULD NOT EXCEED 0.02.
6. PROTRUDING OF VALVE AK150B-60 BEYOND SURFACE A IS NOT ALLOWED
7. LOCATION OF GROOVE K SHOULD CORRESPOND TO THE DRAWING.
8. CHECK VALVES FOR TIGHTNESS UNDER AIR PRESSURE OF 8kg/cm² (CHECK DURING ASSEMBLY)
9. AIR SEEPAGE THROUGH EACH VALVE MAY BE ⁴⁰ 80 BUBBLES PER MINUTE MAX
10. TIGHTNESS CHECK MAY BE CARRIED OUT WITH THE HELP OF SPECIAL DEVICE AS PER STANDARD.

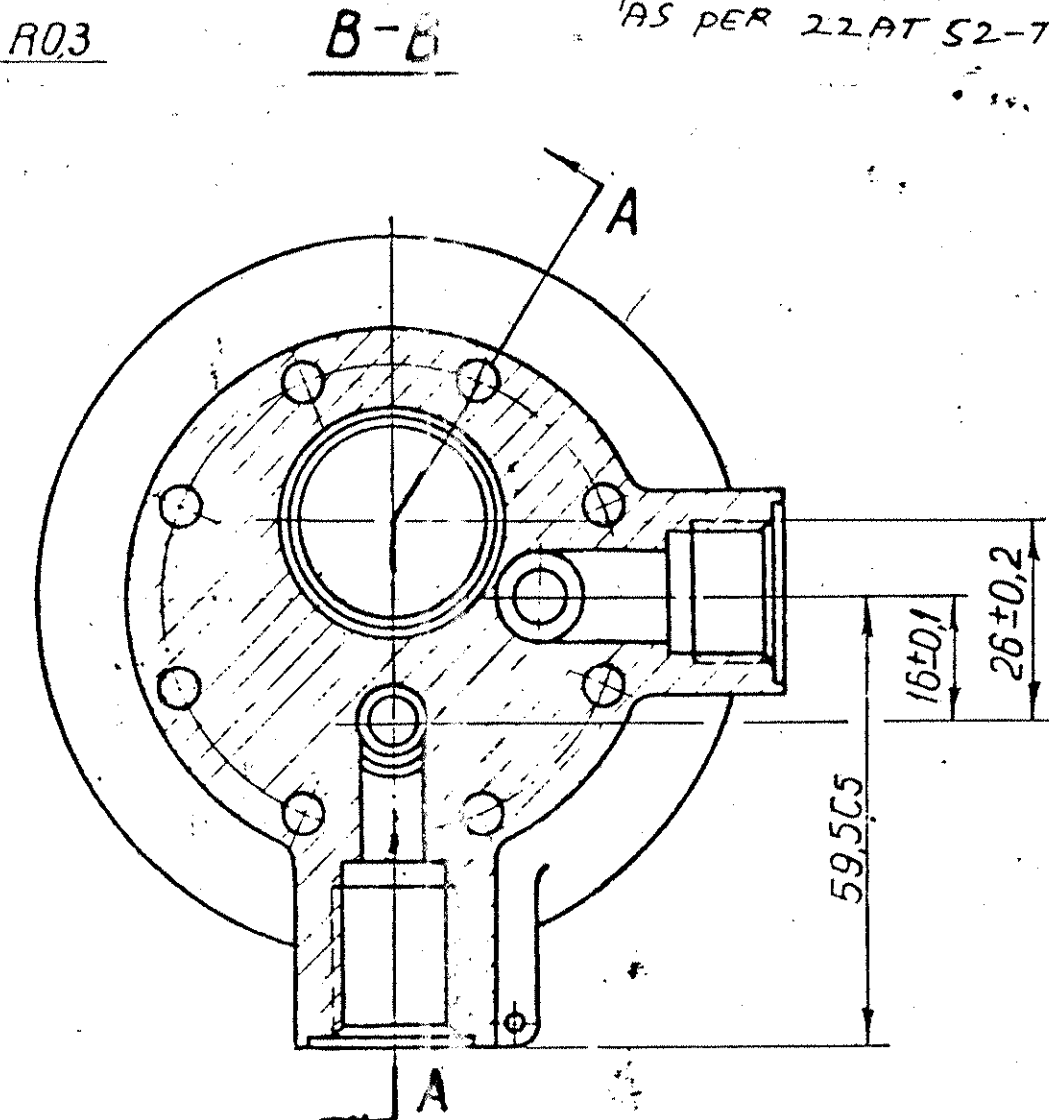
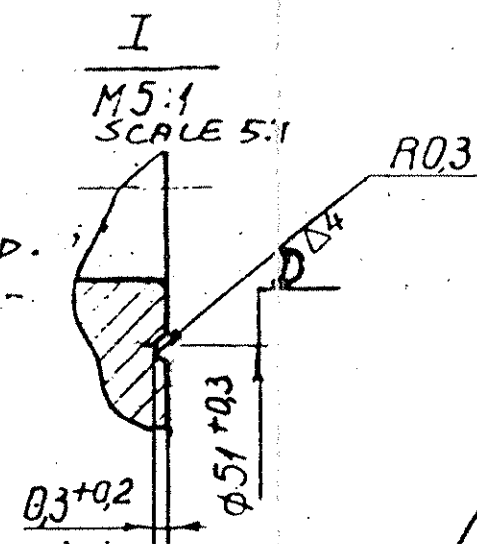
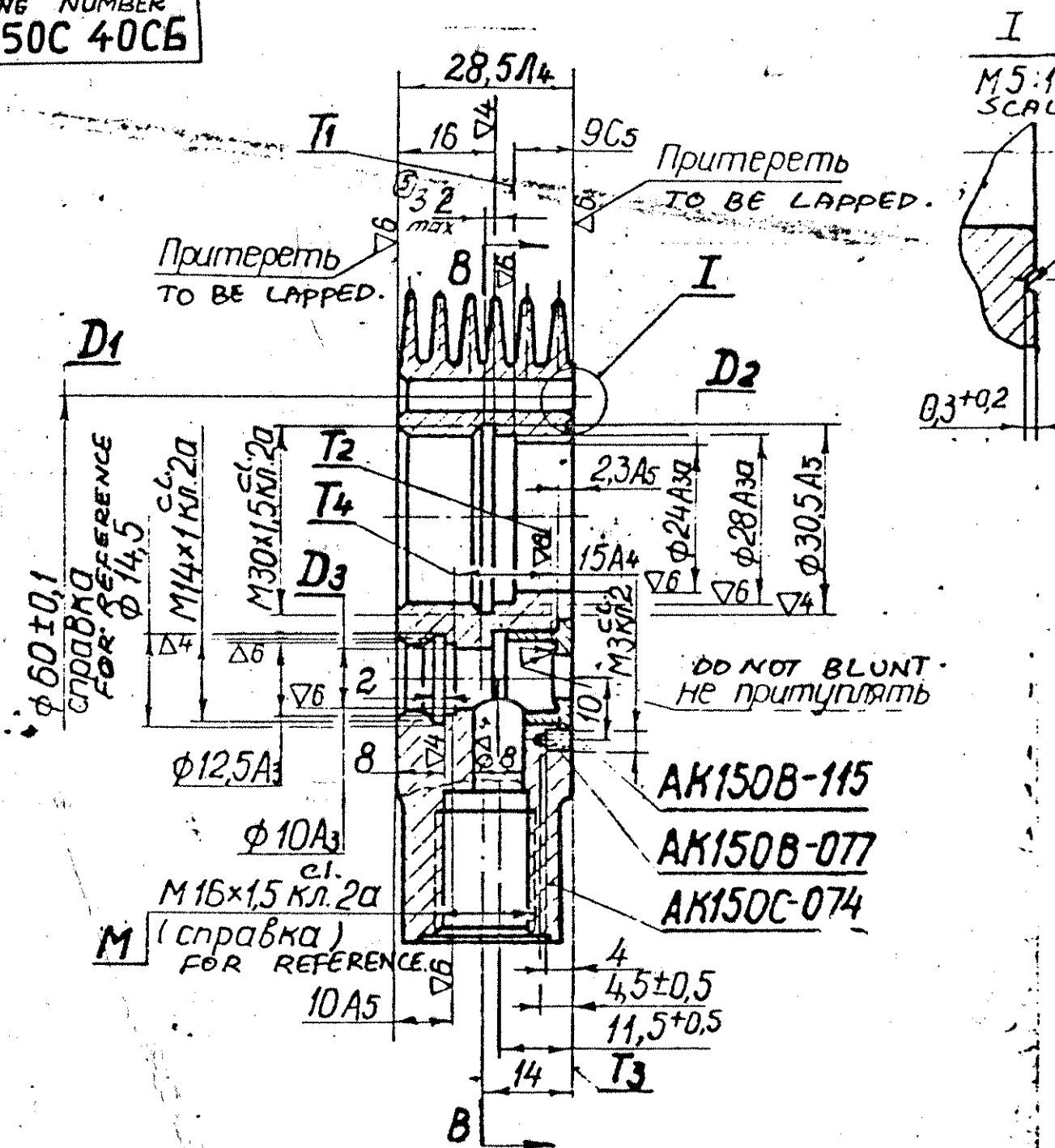
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. MASS.		TO BE STAMPED OR MARKED WHERE INDICATED THUS * LETTERS:	
475		()	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.			
MATERIAL:-		USED ON:-	
-		AK 150C 01 C5	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.		CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
DATE		TITLE: HEAD ASSY.	
22.7.86		D S CAT NUMBER	
ALL THREADS CONFORM TO		DRAWING NUMBER AK150C-19C5	

12

DRAWING NUMBER
AK 150C 40CB

TOLERANCES ON FREE DIMENSIONS
Допуски на свободные размеры по 22AT52-7кл.
AS PER 22AT52-7CL.



1. RUN OUT OF SURFACE D RELATIVE TO SURFACE D1 SHOULD NOT EXCEED 0.3 (TO BE ENSURED TECHNOLOGICALLY).
2. RUN OUT OF SURFACES T1 AND T3 RELATIVE TO SURFACE D2 SHOULD NOT EXCEED 0.1.
3. RUN OUT OF SURFACES T2 AND T4 RELATIVE TO SURFACE D3 SHOULD NOT EXCEED 0.02. (TO BE ENSURED TECHNOLOGICALLY)
4. TIGHTNESS OF THE HOUSING LIMITED BY SURFACES T2, T1 AND THREAD M SHOULD BE CHECKED UNDER THE AIR PRESSURE OF 8kg/cm²
5. AIR SEEPAGE THROUGH CASTING AND COMPONENT AK 15013-115 OUTSIDE THE HOUSING IS NOT ALLOWED.
6. CHAMFERS AND THREAD RUNOUTS SHOULD BE AS PER 299 AT.
7. FACE T2 TO BE FINISHED TO 8 MAY BE FINALLY FINISHED IN ASSEMBLY DURING VALVE SETTING.

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

EST. MASS.		TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTERS)	
ISSUE DATE		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	
DATE	NATURE OF AMENDMENTS	MATERIAL:-	USED ON:-
2.2.7.80	SCALE - 1:1	-	AK 150C 19 CB
DATE	TOLERANCE ON DIMS UNLESS OTHERWISE STATED.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
2.2.7.80	ALL THREADS CONFORM TO	TITLE: HEAD WITH BUSH ASSY	
D S CAT NUMBER		DRAWING NUMBER	
		AK 150C -40CB	

DRAWING NUMBER
AK150C-50C6

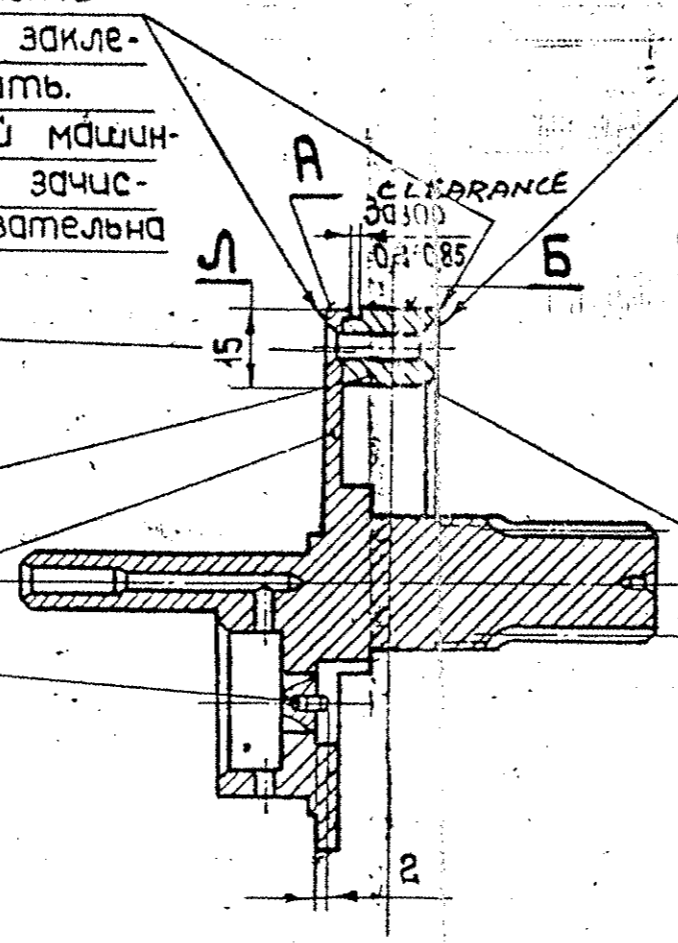
AFTER RIVETING
DRESS THE SURFACES
OF RIVETS. IN CASE OF
CLEAN MACHINE RIVETS
THE a/m DRESSING IS
OPTIONAL.

После расклепки
поверхности закле-
пок зачистить.
При чистой машин-
ной клепке зачис-
тка не обязательна

Выступание го-
ловки заклепок
относительно
поверхности;
эксцентрика не более 0,6
и противоседа не
более 0,2 про-
верить по эта-
лону).

PROTRUSION OF HEADS
OF RIVETS RELATIVE
TO SURFACES OF.
a) ECCENTRIC SHOULD
NOT EXCEED 0.6.
b) COUNTERWEIGHT 0.2
[CHECK AS PER THE
STANDARD].

- AK150B-026
- ① 3537A-4-22
- AK150C-040
- AK150B-005
- AK150B-120



STAMP BY PUNCHING.
Клеимит ударным клеймом.

Допускается снятие оксид-
ной пленки на кольцевой
поверхности λ
OXIDE FILM MAY BE
REMOVED ALONG CIRCULAR
SURFACE λ

MISALIGNMENT OF SURFACE 'A' RELATIVE
1. Смещение поверхности А относи-
тельно Б не более 0,4.
TO SURFACE 'B' SHOULD BE NOT EXCEED 0.4.

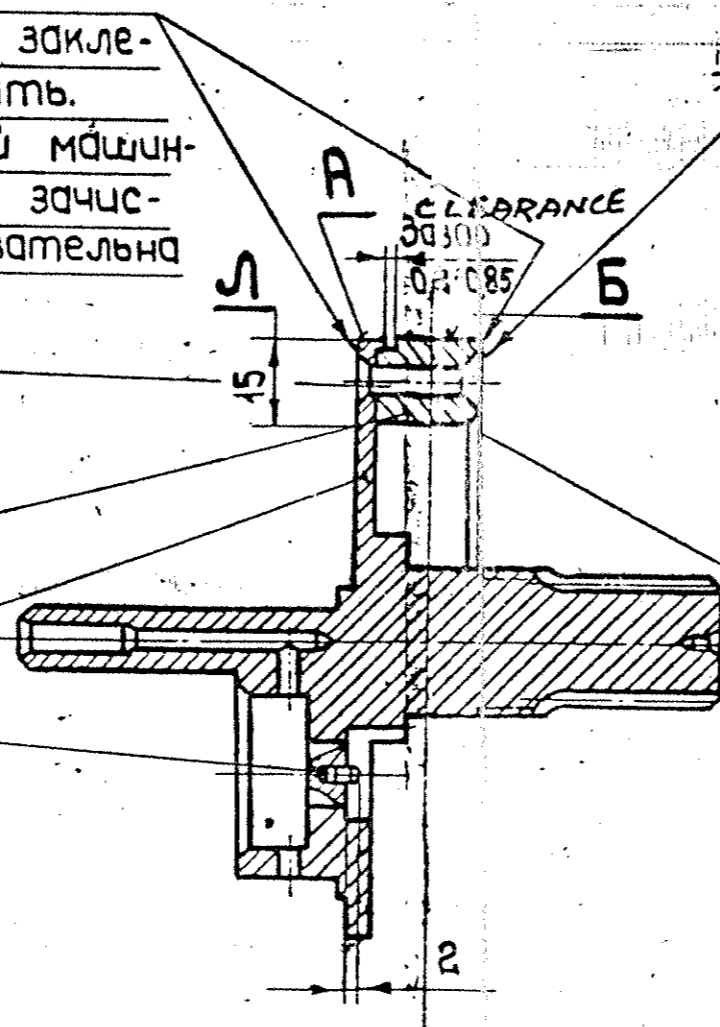
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.		DRN	CHD	TCD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	ALL THREADS CONFORM TO	MATERIAL:-	USED ON: AK150C-52C6
EST. MASS. 433.2	TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTERS)					22.7.86	1:1					
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		CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI			TITLE: ECCENTRIC ASSY			
					D S CAT NUMBER			DRAWING NUMBER AK150C-50C6				

DRAWING NUMBER
AK150C-50CB

AFTER RIVETING
DRESS THE SURFACES
OF RIVETS. IN CASE OF
CLEAN MACHINE RIVETS
THE a/m DRESSING IS
OPTIONAL.

После расклепки
поверхности закле-
пок зачистить.
При чистой машин-
ной клепке зачис-
тка не обязательна

- AK150B-026
- ① 3537A-4-22
- AK150C-040
- AK150B-005
- AK150B-120



Выступание го-
ловки заклепок
относительно
поверхности:
эксцентрика не более 0,6
и противобеса не
более 0,2 (про-
верить по эталону).

PROTRUSION OF HEADS
OF RIVETS, RELATIVE
TO SURFACES OF:
a) ECCENTRIC SHOULD
NOT EXCEED 0.6.
b) COUNTERWEIGHT-02
[CHECK AS PER THE
STANDARD].

STAMP BY PUNCHING.
Клепать ударным клепком.

Допускается снятие оксид-
ной пленки на кольцевой
поверхности λ
OXIDE FILM MAY BE
REMOVED ALONG CIRCULAR
SURFACE λ

MISALIGNMENT OF SURFACE 'A' RELATIVE
1. Смещение поверхности А относи-
тельно Б не более 0,4.
TO SURFACE 'B' SHOULD BE NOT EXCEED 0.4.

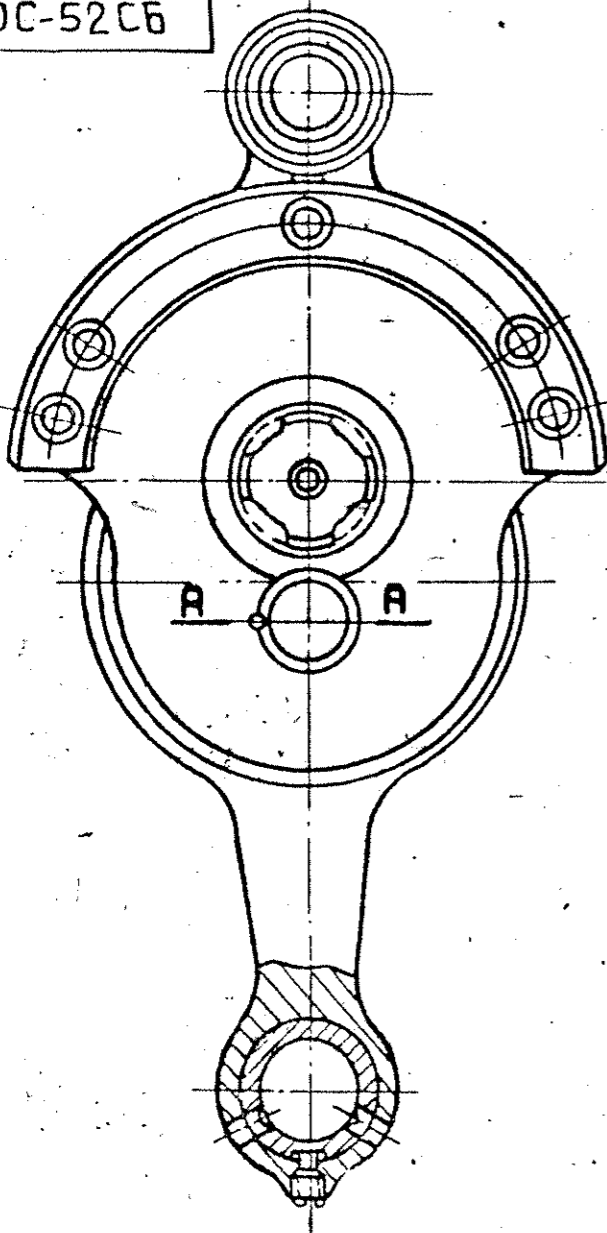
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE
BULK PRODUCTION.

EST. MASS. 433.2 TO BE STAMPED OR MARKED WHERE
INDICATED THIS (LETTERS)

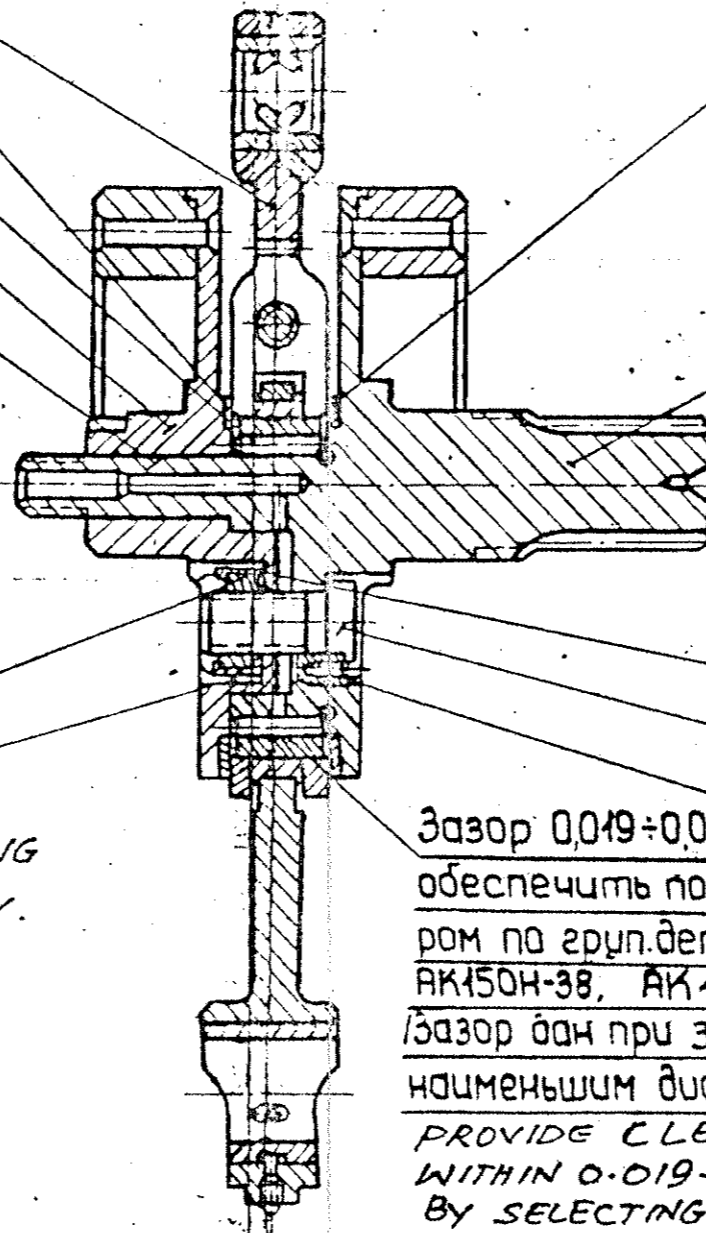
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS
OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-
SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	CHD	TCD	APPD	DATE	SCALE	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	ALL THREADS CONFORM TO	MATERIAL:-	USED ON: AK150C-52CB	CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI	TITLE: ECCENTRIC ASSY	D S CAT NUMBER	DRAWING NUMBER AK150C-50CB
				22.7.86	1:1									
ISSUE	DATE	NATURE OF AMENDMENTS												

DRAWING NUMBER
AK 150C-52C6



AK150H-38
AK150B-033
AK150-046
AK150C-51
AK150C-50



AK150B-107
Законтривать
при сборке
LOCK DURING
ASSEMBLY.

BY SELECTING OF COMPONENT
обеспечить под-
борку дем. AK150B-033.

AK150B-033

AK150B-005

(заправка)
FOR REFERENCE

AK150B-106

AK150B-034

CROSS SECTION AS PER
Сечение по А-А

Зазор 0.019 ± 0.065
обеспечить подбо-
ром по груп. дем. AK150B-005,
AK150H-38, AK150-046
Зазор дан при замере по
наименьшим диаметрам
PROVIDE CLEARANCE
WITHIN $0.019-0.065$
BY SELECTING OF
COMPONENTS AK 150B-
005; AK 150H-38;
AK 150-046 [CLEARANCE
IS GIVEN WHEN
MEASURING ALONG
THE MINIMUM
DIAMETER]

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

EST. MASS.
1061.4

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 OUT-
SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

ISSUE	DATE	NATURE OF AMENDMENTS
A	19.2.2002	Item List Amended

AK-150C-52C6

DRN	264
CHD	Challachy
TCD	SSD
APPD	MS
DATE	
SCALE	1:1
DIMENSIONS IN	mm
TOLERANCE ON DIMNS	UNLESS OTHERWISE STATED.
ALL THREADS	CONFORM TO

MATERIAL:-	USED ON: AK150C-01C6
CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI	
TITLE: ECCENTRIC WITH CONNECTING RODS ASSY.	
D S CAT NUMBER	DRAWING NUMBER AK 150C - 52 C6