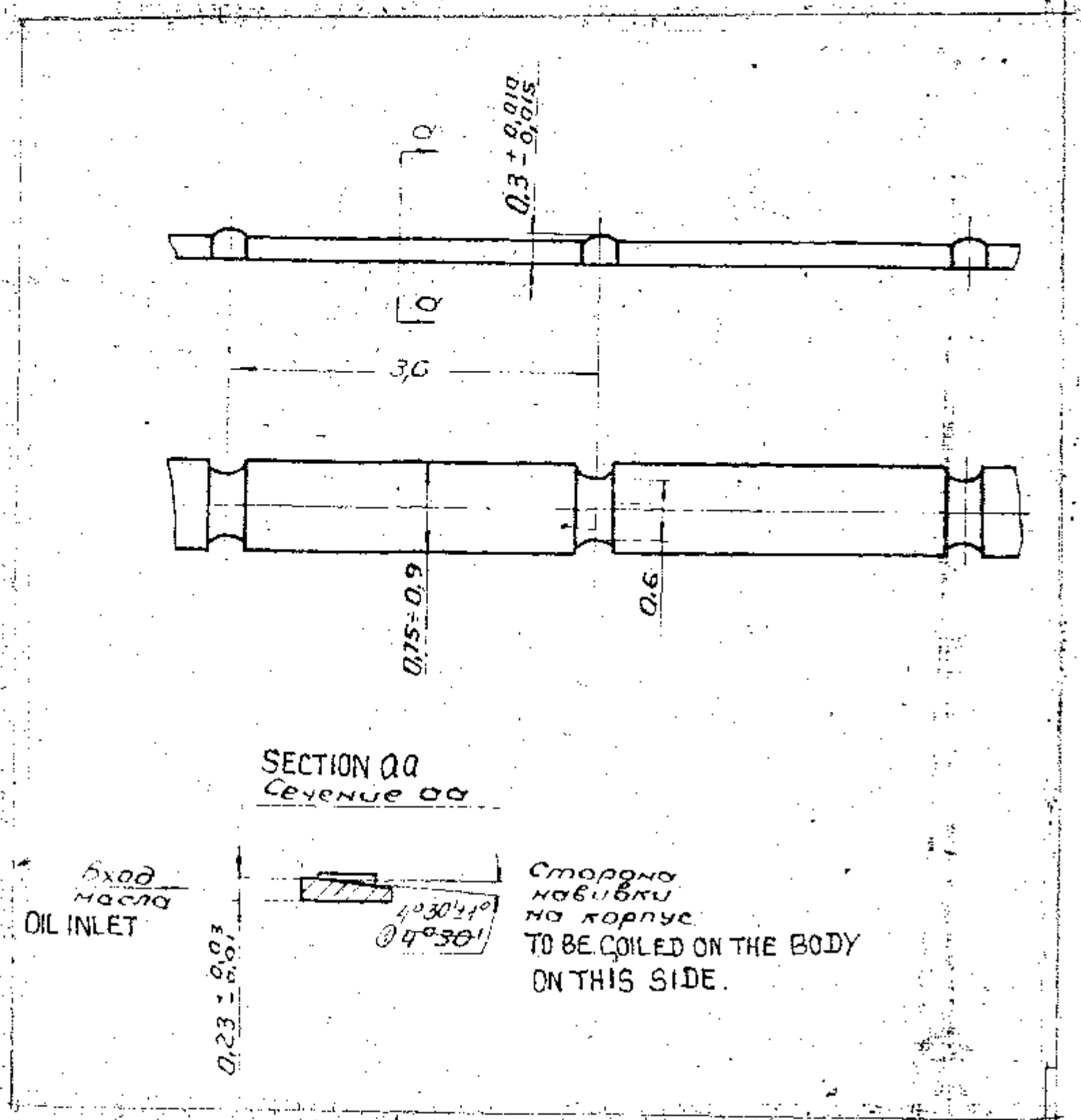


DRAWING NUMBER
313-47



REQUIREMENTS FOR STAMPING AS PER STANDARD 82050-16

NET WEIGHT	FOR ASSEMBLY	QUANTITY OF UNITS PER OBJECT
0.700	CB 313-03-3	1
0.640	CB 313-04-2	1
	CB 313-05-7	1
0.445	CB 3313-03-4	2
0.415	CB 413-04	1
0.330	CB 413-05	1
0.255	CB 413-06	1
0.640	CB 413-116	1

EXPLANATORY NOTE:

REFERENCE MATERIAL QUOTED: BRASS WIRE COLD DRAWN 'A' SQUARE ROUND SECTION 'KP' NORMAL MANUFACTURING ACCURACY 'H' SOFT CONDITION 'M', DIA 0.5 (±0.040)mm, GRADE Л63 TO GOST 1066-80 AND MANUFACTURED IN ACCORDANCE WITH BRASS GRADE Л63 TO GOST 15527-70.

a) CHEMICAL COMPOSITION AS PER GOST 15527-70

BRASS GRADE	CONTENT OF ELEMENTS %							
	BASIC ELEMENTS		ADMIXTURES MAXIMUM					
	Cu	Zn	Pb	Fe	Sb	Bi	P	TOTAL
Л63	62.0-65.0	REMAINDER	0.07	0.2	0.005	0.002	0.01	0.5

b) MECHANICAL PROPERTIES AS PER GOST 1066-80

BRASS GRADE	CONDITION	ULTIMATE TENSILE STRENGTH KgF/mm ² MIN	RELATIVE ELONGATION % MIN
Л63	SOFT	35	20

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

EST. MASS 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	<i>[Signature]</i>	MATERIAL - WIRE AKPHM 0.5	USED ON
CHD	<i>[Signature]</i>	BRASS Л63 GOST 1066-80	CB 413-04-1 CB
TCD	<i>[Signature]</i>		CB 413-05-1 CB
APPD	<i>[Signature]</i>		CB 413-06-1 CB
DATE	19-5-86	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES AVADI)	
SCALE	20:1	TITLE:-	
DIMENSIONS IN mm.		STRIP FILTERING	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.		D S CAT NUMBER-	
ALL THREADS CONFORM TO		DRAWING NUMBER	
ISSUE	DATE	313-47	
NATURE OF AMENDMENTS			

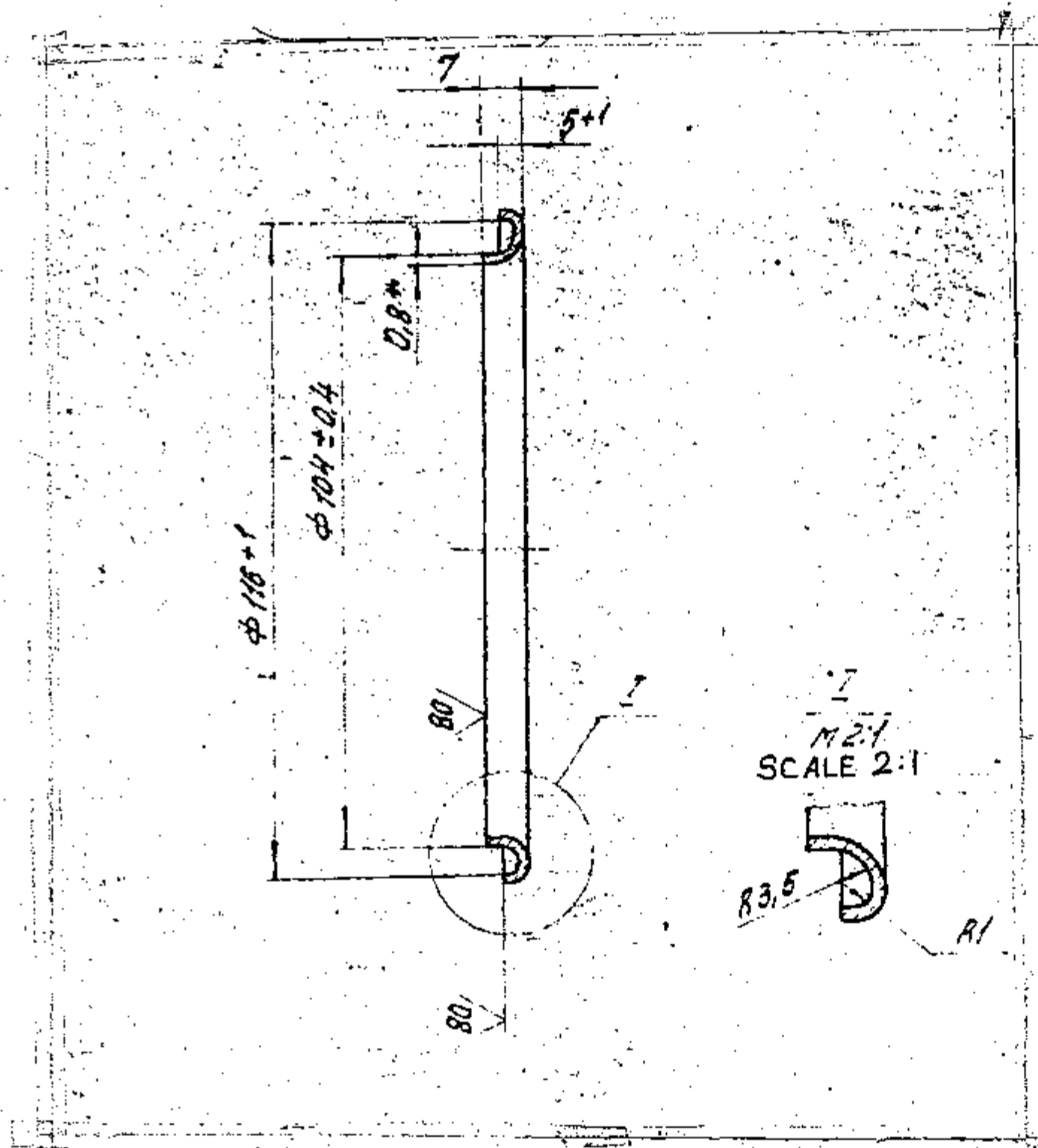
(A-6)

SIZE A2



DRAWING NUMBER

3313 166



1. ALTERNATE MATERIAL: BRASS 63 GOST 15527-70 STEEL 087C, 10, 10Kn GOST 1050-74 WITHOUT COATING.
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ±0.5mm.
3. COATING: Sn 9
4. PERMITTED COATING: ZN 6, CHROMATIZING AS PER INSTRUCTIONS LIT -483-82
5. * DIMENSION FOR REFERENCE.

EXPLANATORY NOTE :

6. REFERENCE MATERIAL QUOTED: COLD ROLLED SHEET, STEEL, ON HIGH ACCURACY ON ROLLING 'A', 0.8mm THICK TO GOST 19904-74, AND HIGH SURFACE FINISH 'T', EXTREMELY DEEP DRAWING 'B1' AND MANUFACTURED IN ACCORDANCE WITH COLD-ROLLED THIN SHEET STEEL Gde. 08kn TO GOST 9045-80.
 a) CHEMICAL COMPOSITION AS PER GOST 9045-80.

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C MAX	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

b) MECHANICAL PROPERTIES:

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

REFERENCE NOTE '1' ON ALTERNATE MATERIAL QUALITY CARBON STEEL FOLD ROLLED GRADES 08nc, 10 AND 10kn TO GOST 16523-70 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL STEEL 1050-74.

a) CHEMICAL COMPOSITION AS PER GOST 1050-74

GRADE OF STEEL	CONTENT OF ELEMENTS %					
	C	Si	Mn	Cr	S	P
08nc	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 UPTO 0.25% AS REGARDS LOWER LIMIT, IS ALLOWED IN THE STEEL OF GRADE 08nc MEANT FOR PRODUCTION OF SHEET STEEL FOR COLD STAMPING.

b) MECHANICAL PROPERTIES AS PER GOST 16523-70.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	ELONGATION % min
08nc	28-40	25
10	30-42	25
10kn	28-40	25

7. b) REFERENCE NOTE '1' ON ALTERNATE MATERIAL: BRASS 63 TO GOST 15527-70.

CHEMICAL COMPOSITION:

GRADE OF BRASS	CONTENT OF ELEMENTS %							
	BASIC ELEMENTS				ADMIXTURES MAXIMUM			
	Cu	Zn	Pb	Fe	Sb	Bi	P	TOTAL
63	62.0-65.0	REMAINDER	0.07	0.2	0.005	0.002	0.01	0.5

Ⓐ EQUIVALENT MATERIAL
Gr. D IS: 513-1994

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

EST. WT. 0.041 Kg
 TO BE STAMPED OR MARKED WHERE INDICATED THUS: [] (LETTERS)

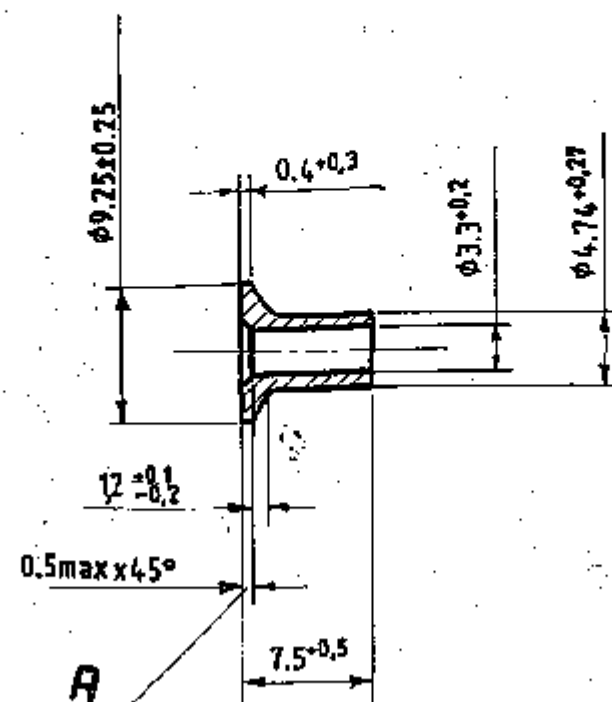
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

DRN	CHD	TCD	APPO	DATE	MATERIAL: SHEET AD.8 GOST 19904-74 II - BT-08Kn GOST 9045-80	USED ON: CB 413 05 1CB CB 413 06 1CB
				26-5-86	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
					SCALE: 1:1 DIMENSIONS IN mm	TITLE: RING
					TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	
					ALL THREADS TO CONFORM TO	D S CAT NUMBER
					ISSUE DATE	DRAWING NUMBER
					18.03.10 4 th AIF Comm. Mt. Minutes Pt. No. 101.26.10.09	3313 166
					NATURE OF AMENDMENTS	



DRAWING NUMBER:

3313 174



1. MAY BE ANNEALED.
2. SHIFT OF HOLE AXIS RELATIVE TO THE BAR AXIS SHOULD NOT EXCEED 0.2mm
3. SHIFT OF HEAD AXIS RELATIVE TO THE BAR AXIS SHOULD NOT EXCEED 0.3mm
4. CHAMFER A MAY NOT BE DONE.
5. MACHINING OF HOLE AND CHAMFER A TO SURFACE ROUGHNESS $R_z 6.3$ IS ALLOWED.

EXPLANATORY NOTE

6. REFERENCE MATERIAL QUOTED:

BRASS $\Lambda 63$ TO GOST 15527-70.

GRADE OF BRASS	CONTENT OF ELEMENTS %							
	BASIC ELEMENTS		ADMIXTURES MAXIMUM					
	Cu	Zn	Pb	Fe	Sb	Bi	P	TOTAL
$\Lambda 63$	62.0-65.0	REMAINDER	0.07	0.2	0.005	0.002	0.01	0.5

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

EST WT.
0.0008 Kg

TO BE STAMPED OR MARKED WHERE INDICATED THUS II (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

DRS

CHD

TCB

APRD

DATE

SCALE: 2 : 1

DIMENSIONS IN mm

TOLERANCE ON DIMN
UNLESS OTHERWISE
STATED

ALL THREADS TO
CONFORM TO

MATERIAL: BRASS $\Lambda 63$
GOST 15527-70 STAMPING

USED ON: CB 413 04 1 CB
CB 413 05 1 CB
CB 413 06 1 CB

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES)
AVADI

TITLE

RIVET TUBULAR

D S CAT NUMBER

DRAWING NUMBER

3313 174

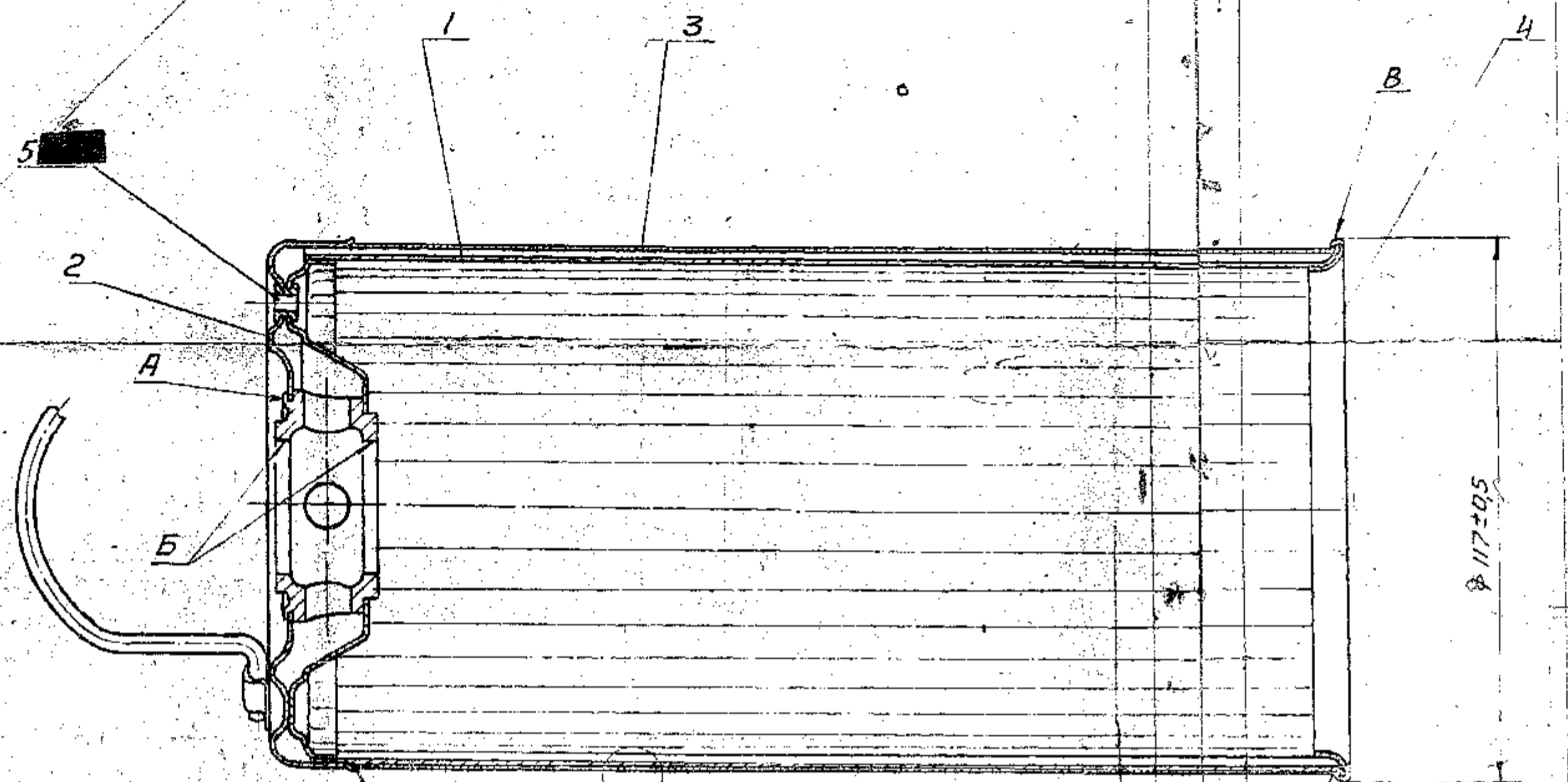
ISSUE	DATE	NATURE OF AMENDMENTS

A-6

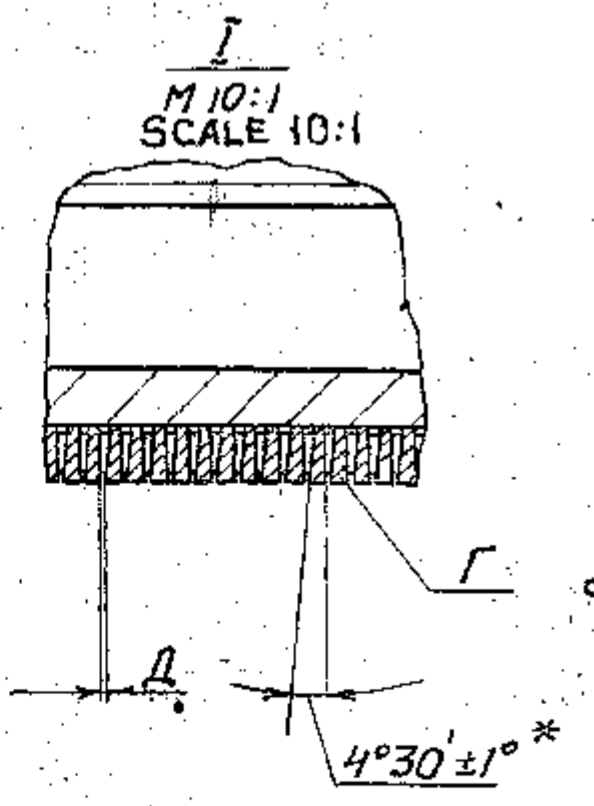
SIZE A3



DRAWING NUMBER
 СБ 413 05 1 СБ



1. SOLDER П К8 П0С С3 30-0.5 GOST 21931-76 TO BE SOLDERED AS PER INSTRUCTIONS UM 439-80.
2. IN EXCEPTIONAL CASES RUPTURES ON FILTERING STRIP ARE ALLOWED UP TO 4 SOLDERED PLACES WITH TOTAL AREA NOT EXCEEDING 2cm² ARE ALLOWED CLEARANCE IN THE PLACE OF SOLDERING SHOULD NOT EXCEED 0.1mm. TO BE CHECKED WITH MICROSCOPE ACCURACY OF MEASUREMENT 0.01mm.
3. CLEARANCE Δ=0.025 TO 0.09mm IS TO BE ENSURED BY TOOL DURING COILING OF STRIP Γ ON THE CUP.
4. IN PLACE 'A' TIGHT FITTING OF MATING COMPONENT SHOULD BE ENSURED CAULKING OF COMPONENT '2' IS ALLOWED.
5. COMPONENT '4' IS TO BE FLANGED BEFORE COILING OF STRIP Γ.
6. THERE MAY BE NO COATING AT PLACES OF FLANGING AND COATING.
7. MISALIGNMENT OF SURFACES 'B' AND 'B' SHOULD NOT EXCEED 0.2mm (MMC)
8. ASSEMBLY UNIT IS TO BE SUBJECTED TO ANTICORROSIVE TREATMENT.
9. * DIMENSION FOR REFERENCE.



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

EST WT 1.13 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	DIMENSIONS IN mm	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	ALL THREADS TO CONFORM TO	ISSUE	DATE	NATURE OF AMENDMENTS
				19-5-86	1:1						
MATERIAL:					CONTROLLERATE OF INSPECTION (HEAVY VEHICLES AVADI)			TITLE: SUB ASSY SECOND SLOT TYPE FILTERING SECTION			
USED ON					D'S CAT NUMBER			DRAWING NUMBER			
СБ 413 00 12								СБ 413 05 1 СБ			

DRG. INDIAISED BASED ON RUSSIAN ORIGINAL ISSUE - 2

А-6

СБ А2



