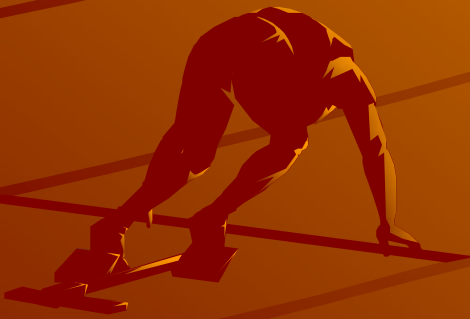


GUN & SHELL FACTORY COSSIPORE KOLKATA-700 002



◆ THESE DRAWINGS ARE EXCLUSIVE PROPERTY OF THE GENERAL MANAGER GUN AND SHELL FACTORY

◆ NO PART OF IT SHOULD BE COPIED , TRANSMITTED OR REPRODUCED WITHOUT HIS PRIOR PERMISSION

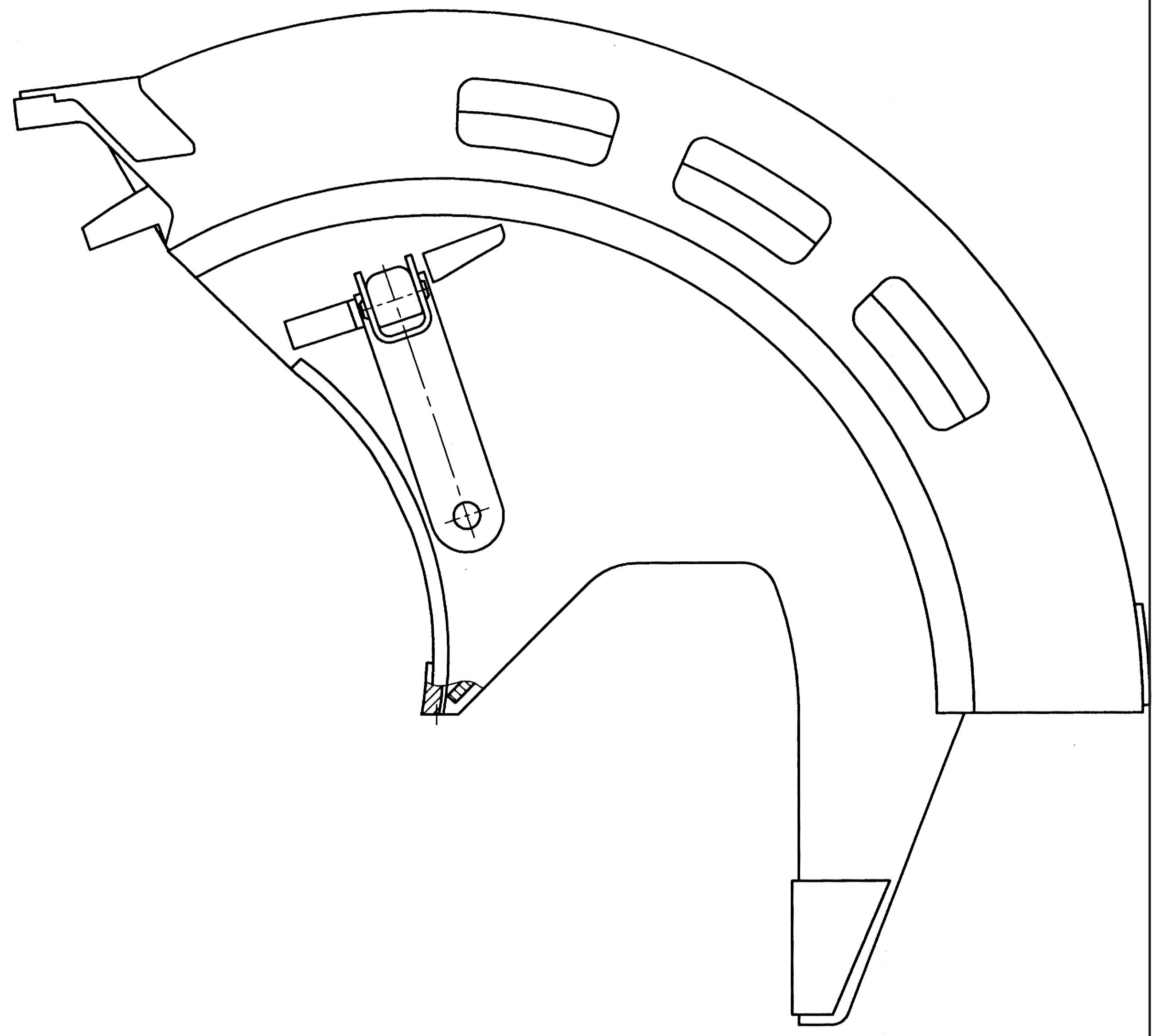
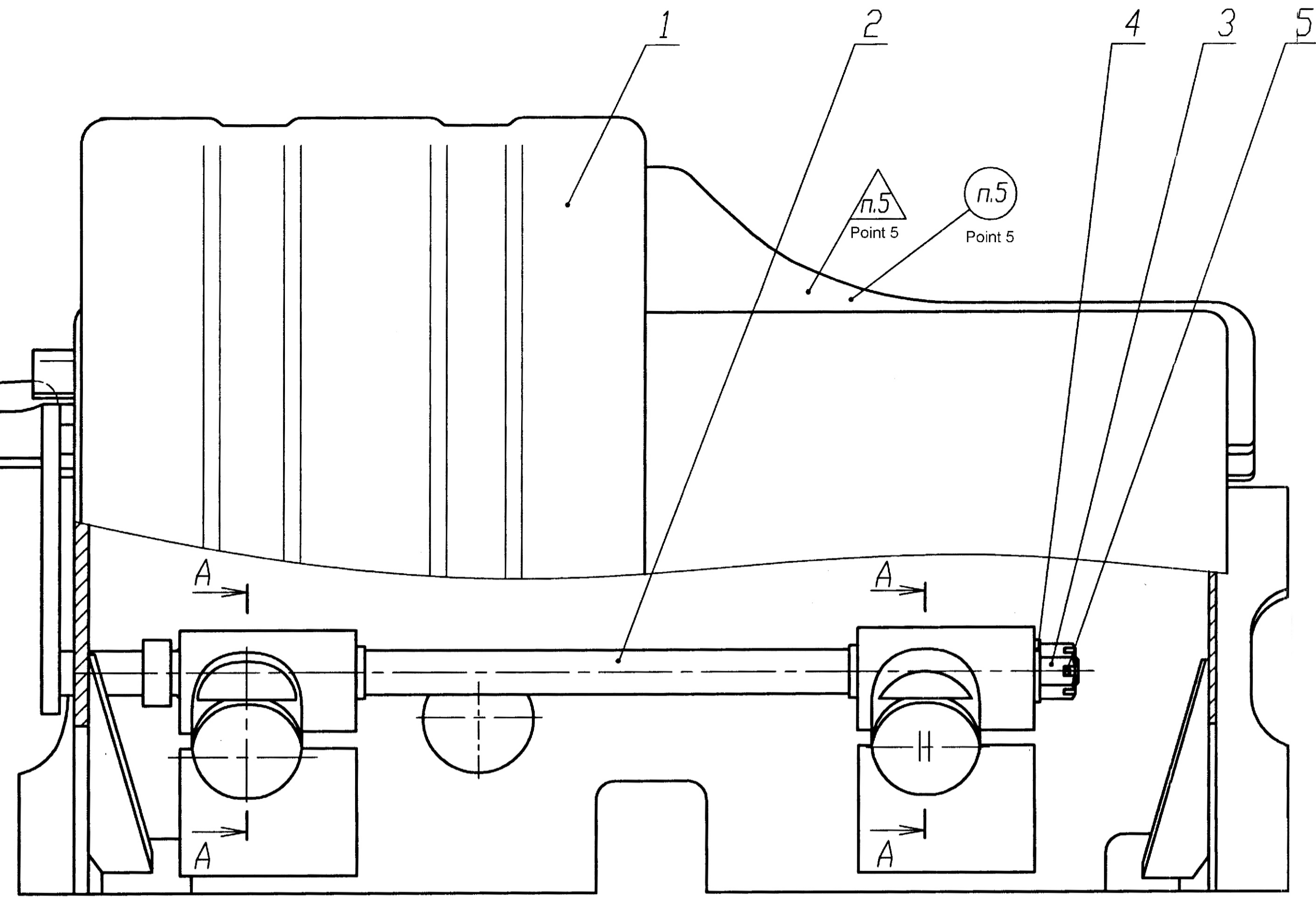
◆ THE CD SHOULD BE RETURNED TO THE GENERAL MANAGER GUN AND SHELL FACTORY AFTER USE

CASE AND LINK EJECTION CHUTE

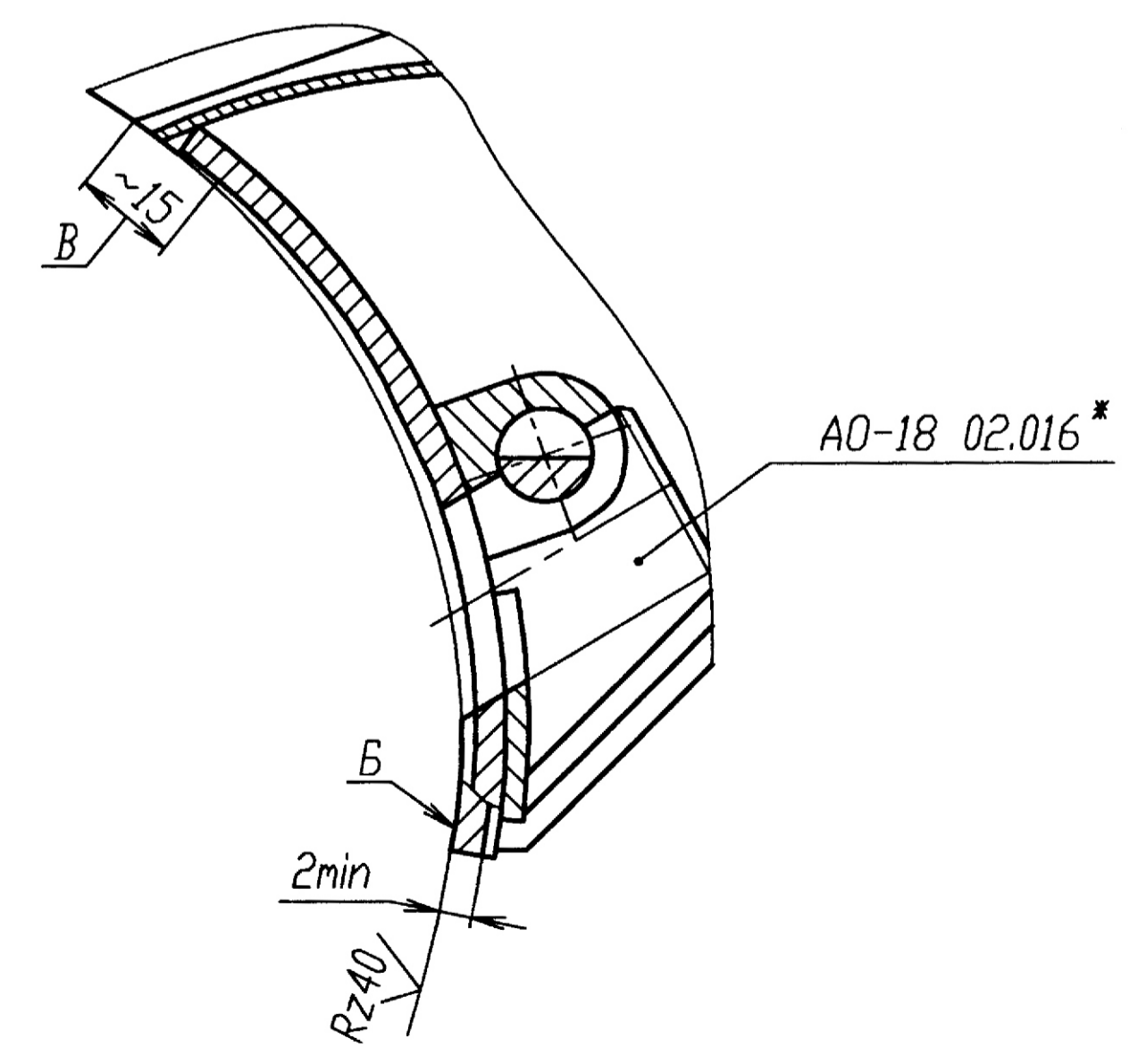


First use		Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks	
Reference No.						<u>Documents</u>			
	A1				AK-630 Sb 109 SB	Assembly drawing 3/2			
						<u>Assembly units</u>			
	A4	1			AK-630 Sb 109-1	Case and link ejection chute body	1		
	A4	2			AK-630 Sb 109-2	Locking pin	1		
						<u>Standard articles</u>			
				3		Nut M8 -6G.10.40X .029	1	31...39.5 HRC _E	
						GOST 5918 - 73			
				4		Washer A8 x1.5.25.029	1		
						GOST 11371 - 78			
			5		Cotter pin 2 x 20.029	1			
					GOST 397 - 79				
Orig. Inv. No.	Sign and Date	AK-630. Sb 109							
		Amend.	Sheet	Doc. No.	Sign	Date			
		Developed by					Type	Sheet	Sheets
		Checked by					A		1
		Head of Q.C.D					Case and link ejection chute		
		Approved by							

AK-630 109-17*



A-A



1. * Article for reference.
2. Locking roller pos. 2 should rotate freely with out jamming .
3. With application of force on article AO - 18 during closing of handle with recessed trigger, AK-630 109-17 should be 98...392N (10...40 kgf). Increase of force up to 490N (50 kgf) is permissible .
- Carry out checking of force with lubricated grooved bush AO-18 02.016 filling surface 5 (2 places) by ensuring with adjustment not less than 30% of surface (with closed handle) for ensuring force is permissible . During adjustment on gauge , imitating article AO-18, force during closing of handle with recess of trigger AK-630 109-17 should be 196...392N (20...40 kgf).
4. Lubricate friction surfaces with lubricant MS - 70 GOST 9762-76.
5. Mark Ш, Ч, H Ha and stamp K as per AK-630, AK-630M TU 1.
- Ha - Technical aggregate number of assembly .
6. Inspect adjustment of surface Б and surface in zone B as per gauge with minimum radii R 106 mm as per paint area of adjustment of surface Б not less than 50% adjustment in zone B sections 50-60 mm along whole length.

Inv. No.	Sign & Date	Alternate Inv. No.	Duplicate Inv. No. Sign & Date	Refer No.	First remarks

AK - 630 SB 109 SB					
Amend	Sheet	Doc. No.	Sign	Date	Type Weight Scale
					Case and link ejection chute Assembly drawing A 9.220 1:1
					Sheet Sheets 1

First use		Format	Zone	Position	Designation	Nomenclature	Qty.	Remarks	
						<u>Documents</u>			
Reference No.		A0			AK-630 Sb 109-1 SB	Assembly drawing 3/2			
						<u>Assembly units</u>			
		A4	1		AK-630 Sb 109-3	Cover plate	1		
		A4	2		AK-630 Sb 109-5	Cover	1		
						<u>Components</u>			
Sign and Date		A3	3		AK-630 109-1	Rear side - frame 7/7	1		
		A3	4		AK-630 109-2	Front side - frame 7/7	1		
		A3	5		AK-630 109-3	Upper guide 7/7	1		
		*)	6		AK-630 109-4	Lower guide 7/7	1	*) A4x3	
Duplicate Inv. No.		*)	7		AK-630 109-5	Rear slide arm 7/7	1	*) A4x3	
		A4	8		AK-630 109-6	Front slide arm 5/5	1		
		A4	9		AK-630 109-8	Gusset plate 7/5	4		
		A4	10		AK-630 109-9	Rib 5/6	1		
Alternate Inv. No.		A4	11		AK-630 109-10	Stop 5/6	2		
		A4	12		AK-630 109-11	Gusset plate 5/6	2		
Sign and Date		AK-630. Sb 109 - 1							
Orig. Inv. No.		Amend.	Sheet	Doc. No.	Sign	Date			
		Developed by					Type	Sheet	Sheets
		Checked by					A	1	2
		Head of Q.C.D					Case and link ejection chute housing		
		Approved by							

AK-630 109-1

First use

Reference No.

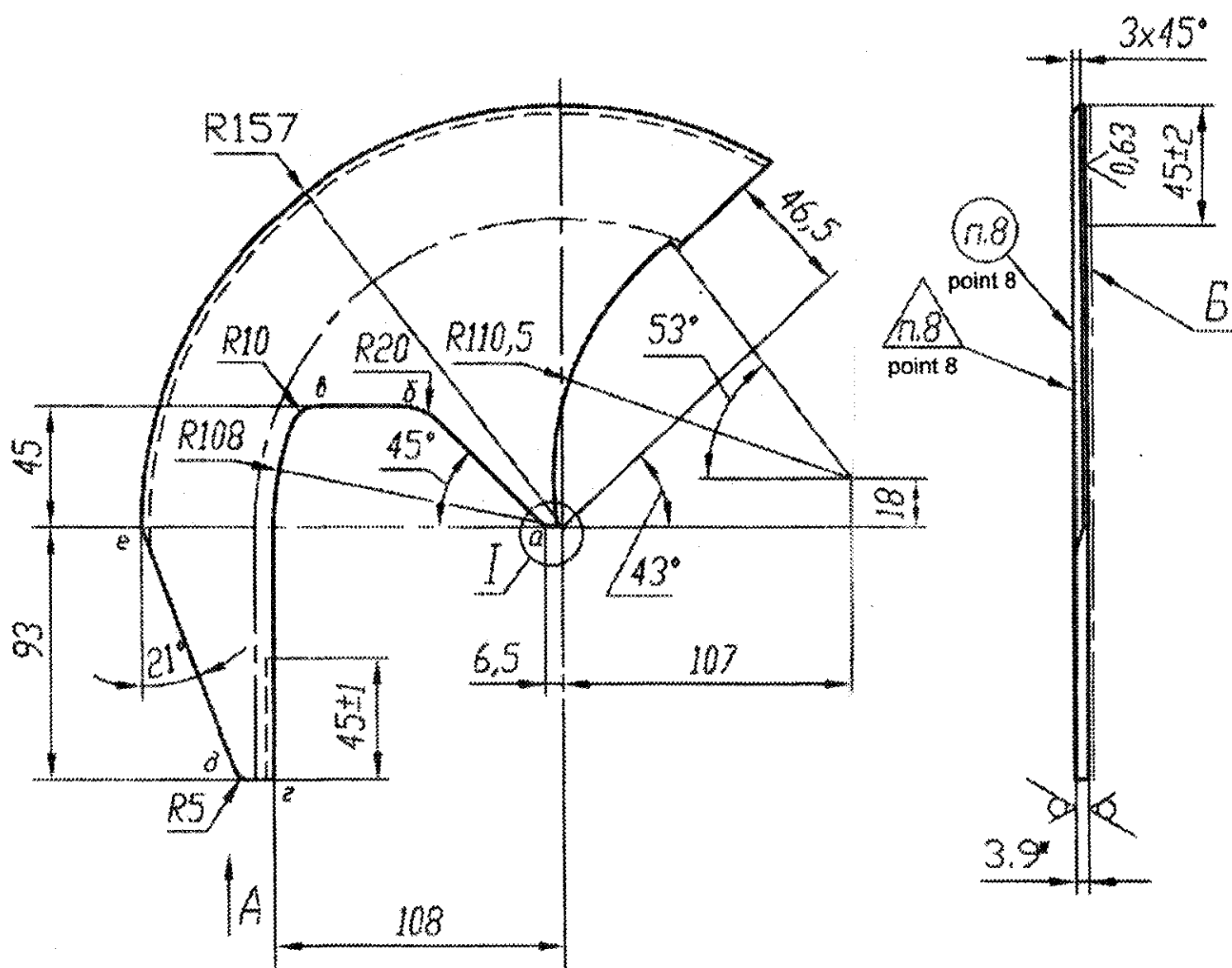
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

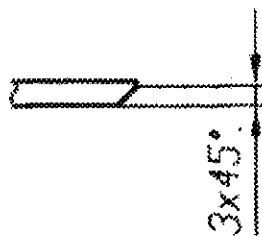
Orig. inv. no.



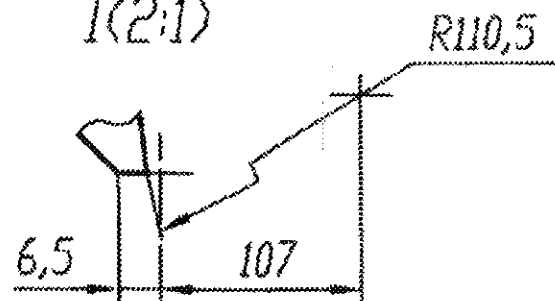
Rz80 ✓(✓)

- 1.* Reference dimension.
2. Dimensions and maximum deviations ensured by tool.
3. Inner angles R~0.4 mm.
4. Blunt sharp edges ~0.2 mm.
5. Tolerance for contour 0.3 mm.
Tolerance for contour "абвгде" 1 mm.
6. Polish surface Б before and after chrome plating.
7. Coating of surface Б- X hard 24.
8. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

A(1:1)



I(2:1)



AK-630 109-1

					AK-630 109-1			
					Type	Weight	Scale	
Amend.	Sheet	Doc.No.	Sign	Date	Rear side plate	A	0.546	1:2
Developed by						Sheet	Sheets 1	
Checked by								
Head of Q.C.D					Sheet <u>B - PN - 03.9 GOST 19903 - 74</u>			
Approved by					K 490V 4 - III - 35 GOST 16523 - 97			

AK-630 109-3

First use

Reference No.

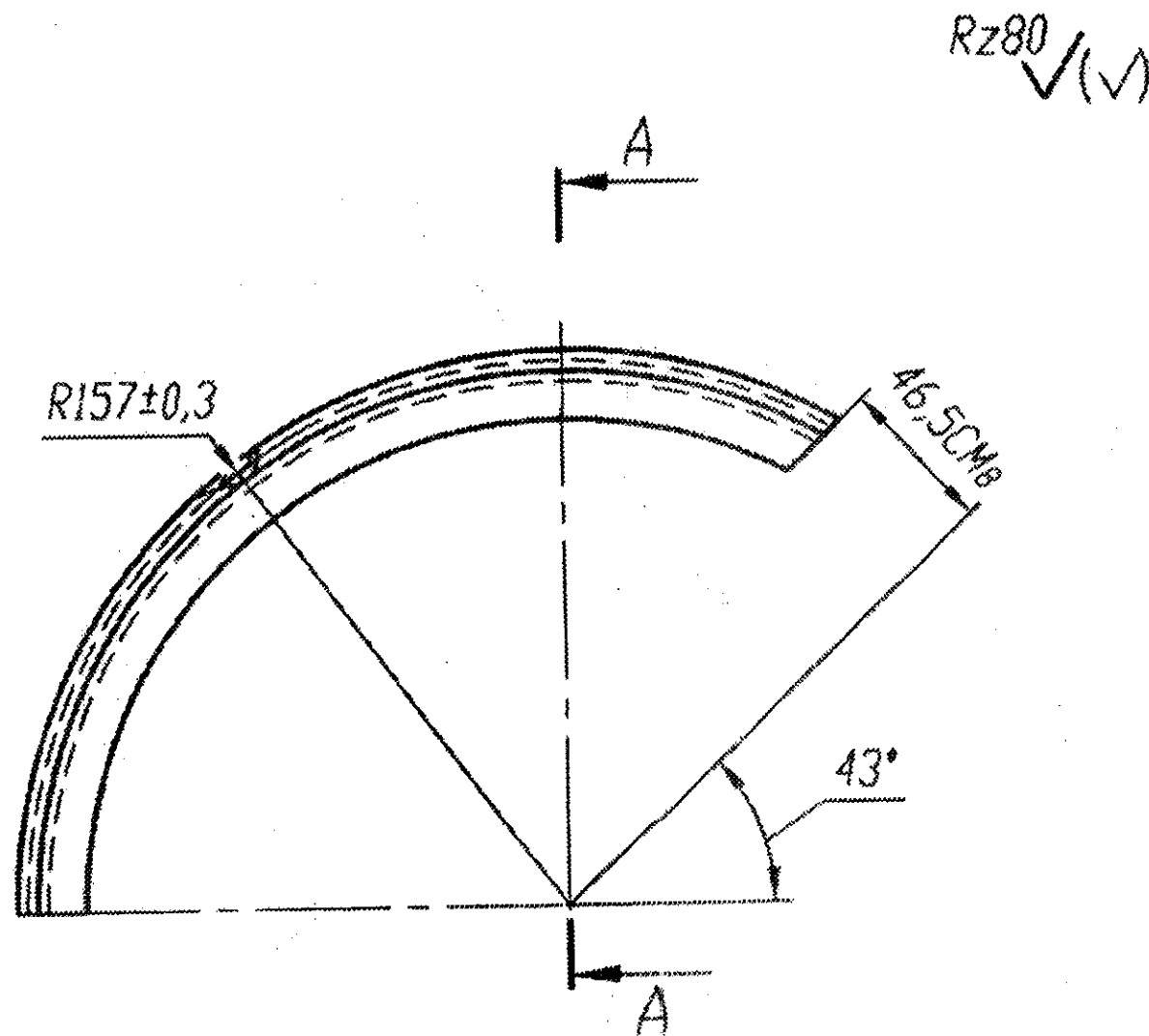
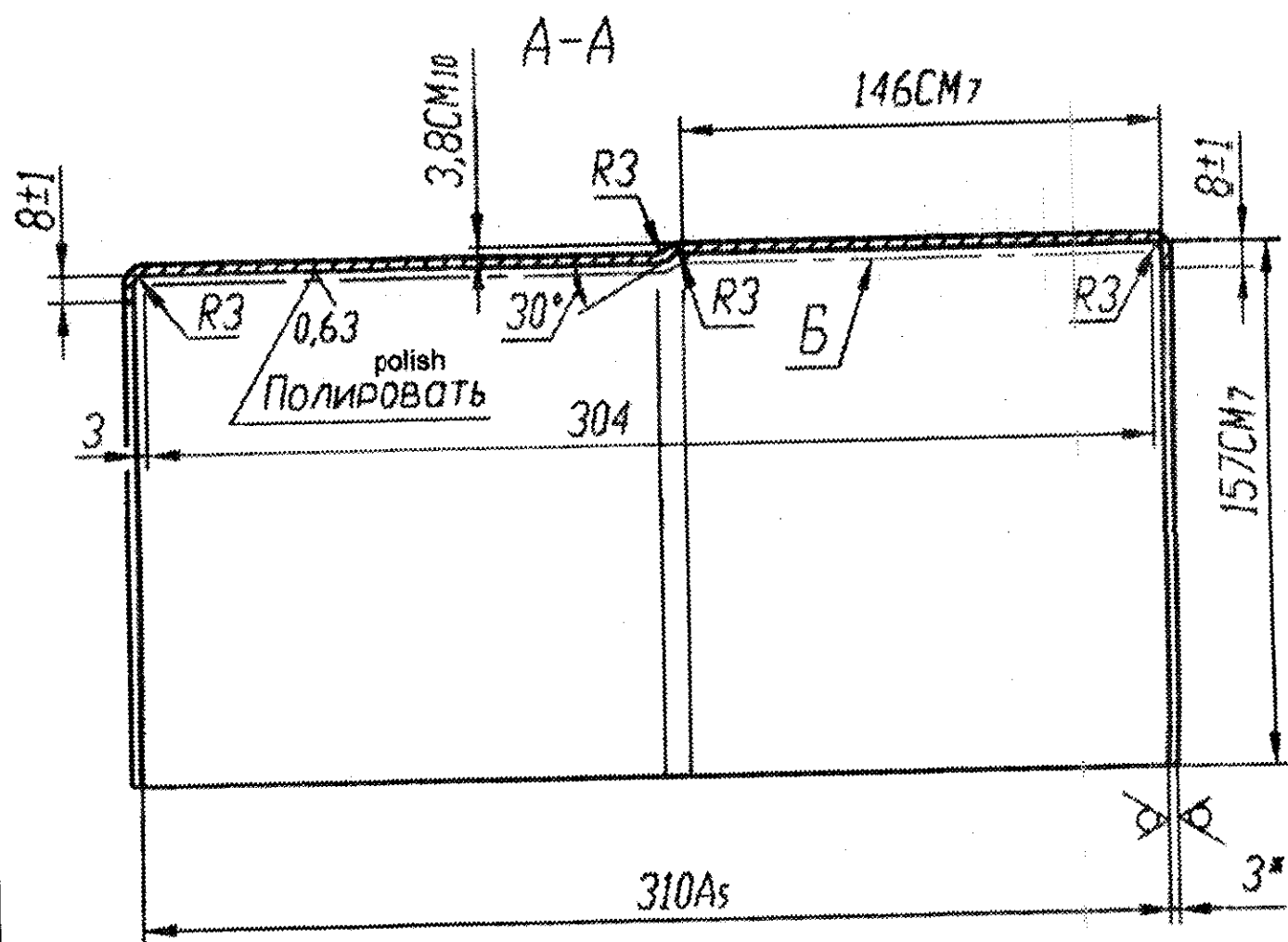
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



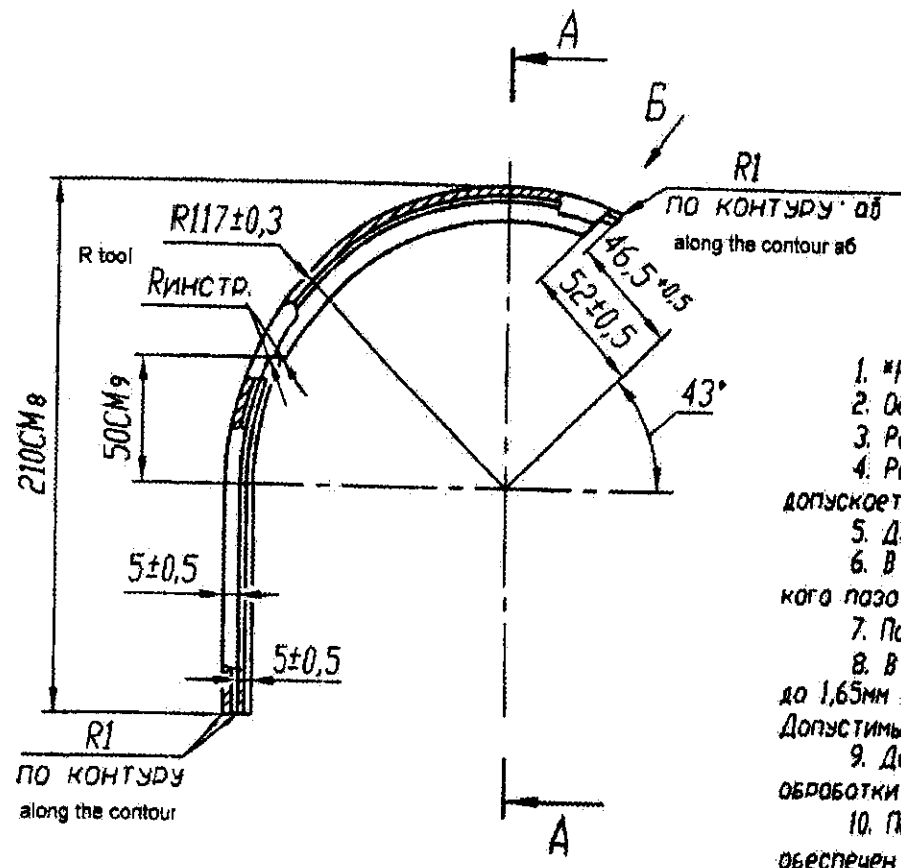
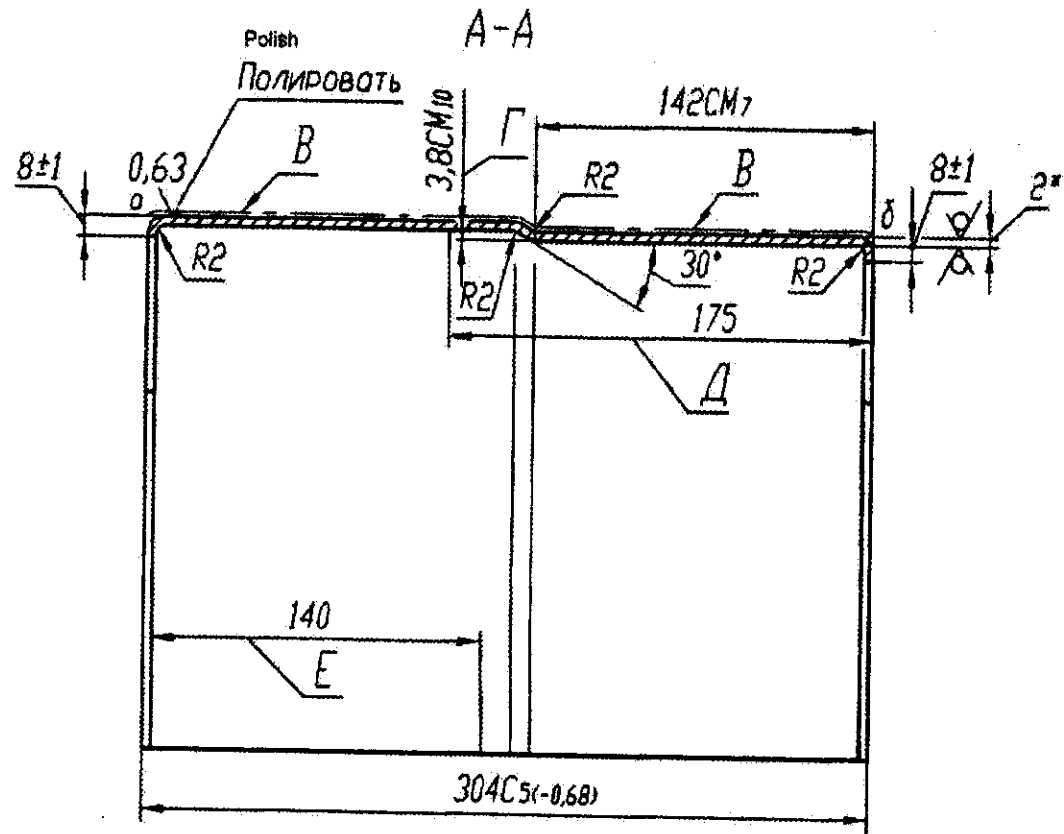
- 1.* Reference dimension.
2. Blunt sharp edges ~0.2 mm.
3. Dimensions and maximum deviations ensured by tool.
4. Coating of surface Б- Xhard24.
5. Decrease in thickness up to 2.65 mm and increase in radii up to 5 mm are permissible at places of polishing after polishing. Permissible defects as per test specimen.
6. Electro-chemical polishing with surface finish as per specimen is permissible.
7. Mark Ш, Ч and stamp K on batch tag.

AK-630 109-3

Amend.	Sheet	Doc.No.	Sign	Date	Type	Weight	Scale
					Upper guide	2.370	1:2
Developed by					Sheet	Sheets 1	
Checked by							
Head of Q.C.D							
Approved by					Sheet $\frac{BT - PN - 03 \text{ GOST}19904 - 90}{K490V 4 - III - 40 \text{ GOST}16523 - 97}$		

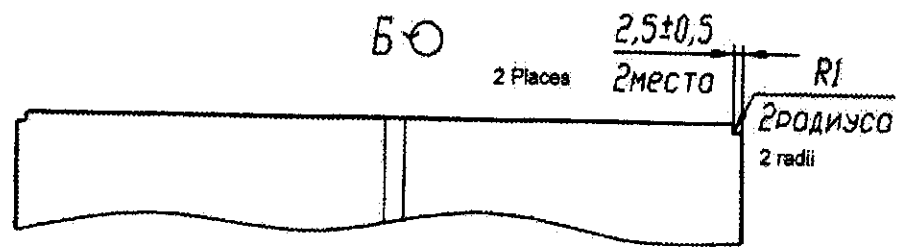
AK-630-109-4
AK-630-109-4

Rz80 ✓(✓)



1. * - Dimension for reference.
2. Blunt the sharp edges - 0.2 mm.
3. Dimensions and limiting deviations are ensured by tool.
4. Make dimension Γ on length D , the increase of tolerance from ± 0.6 to ± 1.0 mm is permitted on the remaining length.
5. The tolerance of rectilinearity with surface B is not more than 0.6 mm.
6. The presence of technological groove having dimension of 26x22mm is permitted in the area E on surface B.
7. Coating of surface B - Hard Chrome 24.
8. At the places of polishing, the reduction of thickness up to 1.65 mm and the increase of radiuses up to 4 mm after polishing is permitted. Permissible defects are as per test specimen.

1. *Размер для справок.
2. Острые ребра притупить $\approx 0,2$ мм.
3. Размеры и пред. откл. обеспеч. инстр.
4. Размер Γ выполнять по длине D , на остальной длине допускается увеличение допуска от $\pm 0,6$ до $\pm 1,0$ мм.
5. Допуск прямолинейности поверхностей B не более 0,6 мм.
6. В зоне E на поверхности B допускается наличие технологического паза с размерами 26x22 мм.
7. Покрытие поверхности B - Хгв24.
8. В местах полирования допускается уменьшение толщины до 1,65 мм и увеличение радиусов до 4 мм после полирования. Допустимые дефекты по контрольному образцу.
9. Допускается электрохимическое полирование с чистотой обработки по эталону.
10. После полирования между поверхностями B должен быть обеспечен размер Γ .
11. Маркировать Ш, Ч и клеймить К на бирке к партии.



9. Electrochemical polishing with finishing as per standard is permitted.
10. After polishing, the dimension Γ should be ensured between surfaces B.
11. Mark Ш, Ч and stamp K on the tag for batch.

AK - 630 - 109 - 4

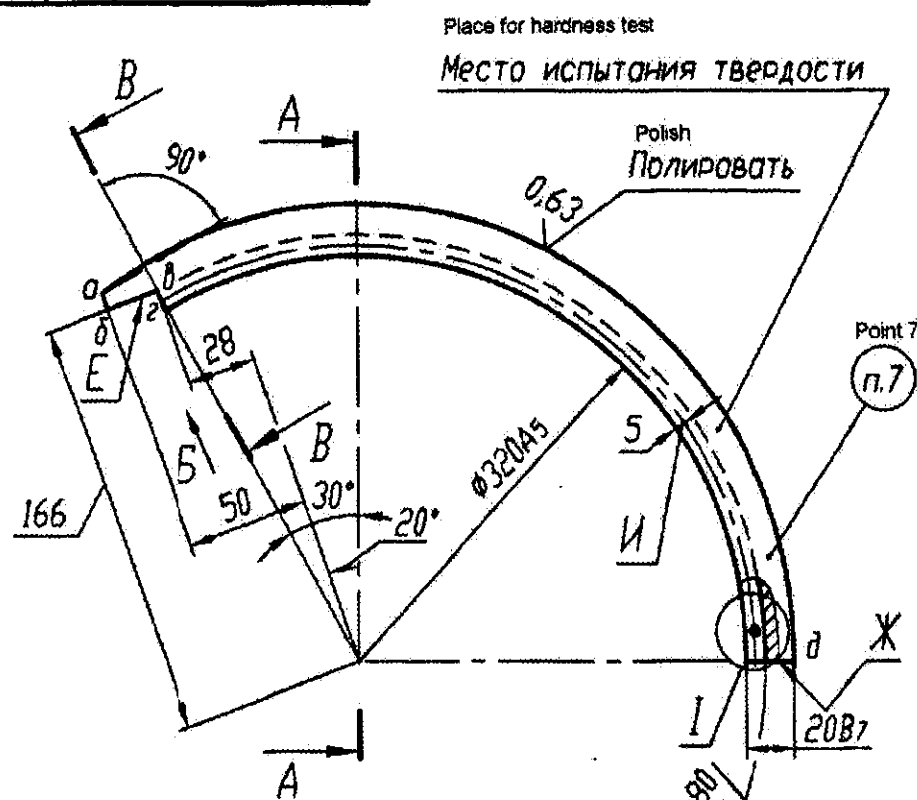
AK-630 109-4

		AK-630 109-4		
		Лит.	Масса	Scale
Изм.	Лист	№ докум.	Подп.	Дата
Разр.	Пров.	Т.контр.	Н.контр.	Утв.
		Lower Guide		Лист
		Ноправляющая нижняя		Листов 1
		BT-PN-02 GOST 19904-90		Sheet
		sheet BT-PN-02 GOST 19904-90		Total Sheets 1
		K 490V A-11-40 GOST 16523-97		
		K 490V A-11-40 GOST 16523-97		

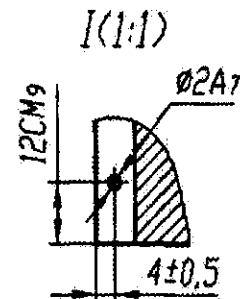
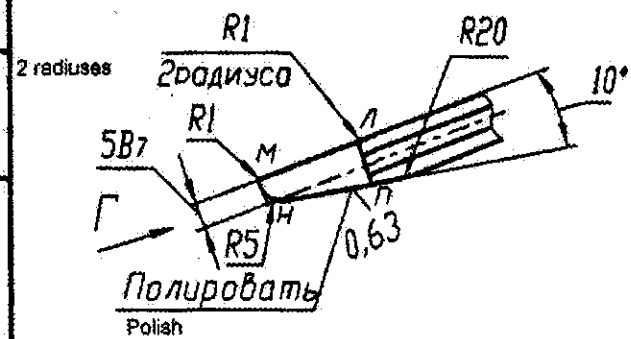
Bag 8 container 2

Оформ. А.С.

5-601 089-Ж



В(1:1)

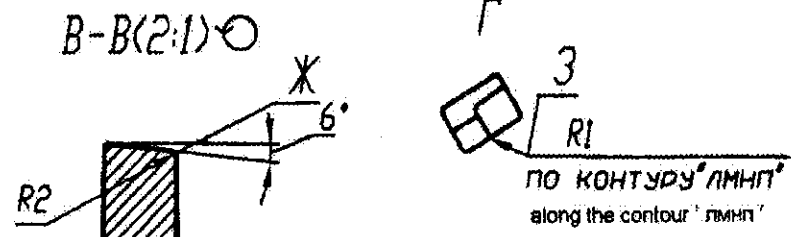
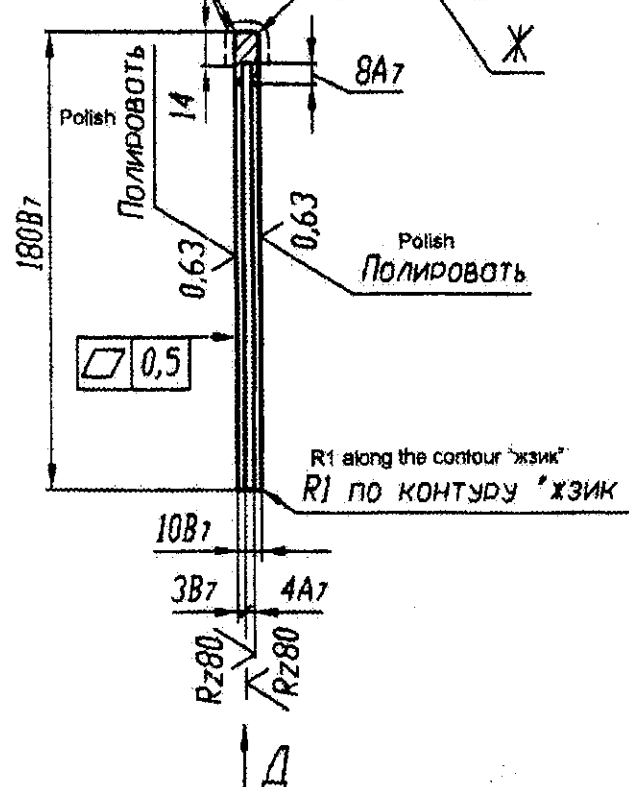


Д(1:1)



- Internal angles $R \sim 1$ mm.
- Blunt the sharp ribs ~ 0.6 mm.
- Tolerance along the contour 'абер' is 0.5 mm.
- Coating of polished surfaces with hard chrome 24 except section И from both sides.
Case hardening of planes E and Ж is permitted.
- During polishing, the increase in dimension Ж by not more than 3 mm and the dimension 3 by not more than 1.5 mm is permitted.
- Mark Ш, Ч and stamp К on the batch tag.
- Before heat treatment, mark TN. TN - Technological Number.
Issue a certificate for heat treatment with TN.

A-A
Case harden along the contour "ад" h 0.5...0.8. 53.0...59 HRCэ
Цементировать по контуру "ад"
h 0.5...0.8; 53.0...59 HRCэ
R2 along the contour "ад"
R2 по контуру "ад"



Rz40 ✓(✓)

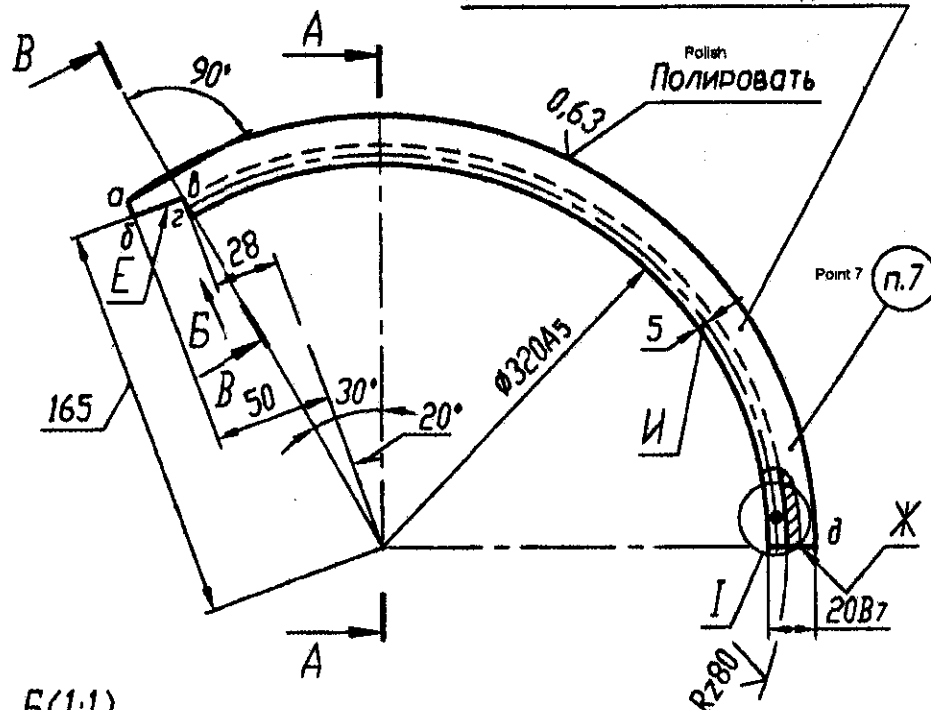
- Внутренние углы $R \sim 1$ мм.
- Острые ребра притупить ~ 0.6 мм.
- Допуск по контуру "абер" 0.5 мм.
- Покрытие полированных поверхностей ХТВ24 кроме участка И с двух сторон.
Допускается цементация плоскостей E и Ж.
- При полировании допускается увеличение размера Ж не более 3 мм и размера 3 не более 1.5 мм.
- Маркировать Ш, Ч и клеймить К на бирке к партии.
- Маркировать НТ до термообработки.
НТ-технологический номер.
За термообработку выписывать аттестат с указанием НТ.

				AK-630 109-5		
				Lit Wt. Scale		
				Rear Strip		
				Полозок задняя		
				Lit. Масса Масштаб		
				A 3,600 1:2		
				Lit. / листов 1		
				Sheet Total Sheets 1		
				Steel 20 GOST 1050-88		
				Сталь 20 ГОСТ 1050-88		
				Lit. / листов 1		
				Sheet Total Sheets 1		

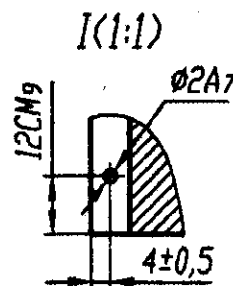
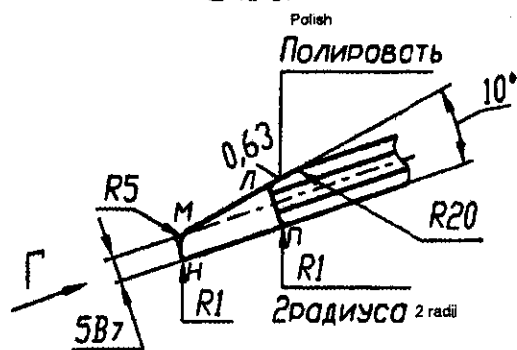
9-601 009-ЖВ

9-601 009-ЖВ

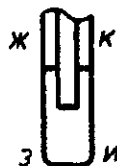
Place for hardness test
Место испытания твердости



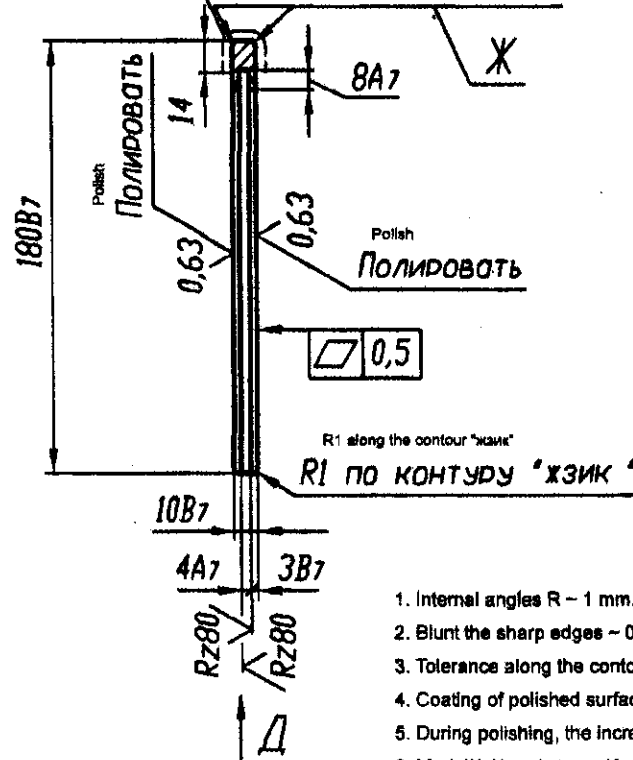
B(1:1)



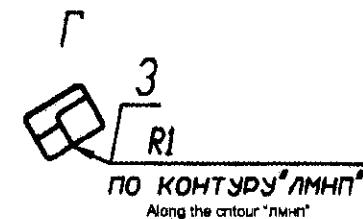
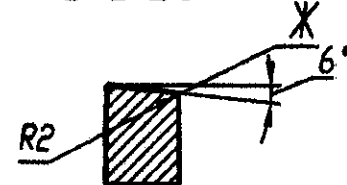
Д(1:1)



A-A
Case harden along the contour "ab"
Цементировать по контуру "ab"
h0,5...0,8; 53,0...59 HRCэ
R2 Along the contour "ab"
R2 по контуру "ab"



B-B(2:1) O



Rz40 ✓(✓)

1. Внутренние углы R = 1 мм.
2. Острые ребра притупить ~ 0,6 мм.
3. Допуск по контуру "ab" 0,5 мм.
4. Покрытие полированных поверхностей Хтв24 кроме участка И с двух сторон. Допускается цементация плоскостей E и Ж.
5. При полировании допускается увеличение размера Ж - не более 3 мм и размера 3 - не более 1,5 мм.
6. Маркировать Ш, Ч и клеймить К на бирке к партии.
7. Маркировать Нт до термообработки. Нт - технологический номер. За термообработку выписывать аттестат с указанием Нт.

1. Internal angles R = 1 mm.
 2. Blunt the sharp edges ~ 0.6 mm.
 3. Tolerance along the contour "ab" is 0.5 mm.
 4. Coating of polished surfaces - hard chrome 24 except the section И from two sides. Case hardening of planes E and Ж is permitted.
 5. During polishing, the increase of dimension Ж - for not more than 3 mm and the dimension 3 - for not more than 1.5 mm, is permitted.
 6. Mark Ш, Ч and stamp К on the tag for the lot.
 7. Before the heat-treatment, mark Нт.
- Ht - technological number.
Make the certificate for heat-treatment with indication Ht.

AK-630 109-6

				AK-630 109-6		
				Type	Mass	Scale
				Front slider		
Изм/Лист	№ докум.	Подп.	Дата	Лит.	Масса	Масштаб
Разроб.				A	3,600	1:2
Испол.				Лист	Листов 1	
				Сталь 20 ГОСТ 1050-88		
				Sheet	Total Sheets	
				Steel 20 GOST 1050-88		
				Sheet		

Формы А4.2

AK-630 109-9

Approved by shop Reference No.		Approved KTONI Sign and Date		Approved TOsb Dupl. Inv. No.		Approved OGMet Orig. Inv. No.	
First use							
<p>AK-630 109-9-01</p> <p>Остальное см. AK-630 109-9 <small>remaining refer</small></p> <p>1.* Reference dimension. 2. Dimensions and maximum deviations ensured by tool. 3. Blunt sharp edges R~0.6 mm. 4. Mark Ш, Ч on batch tag. 5. Stamp K as per AK-630, AK-630M TU I.</p>							
AK-630 109-9							
				Type			
				Weight		Scale	
				A		0.100 1:1	
				Sheet		Sheets 1	
				Sheet <u>BT - PN - 3 GOST 19903 - 74</u>			
				<u>K 490V 4 - III - 25 GOST 16523 - 97</u>			

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Format A4

AK-630 109-10

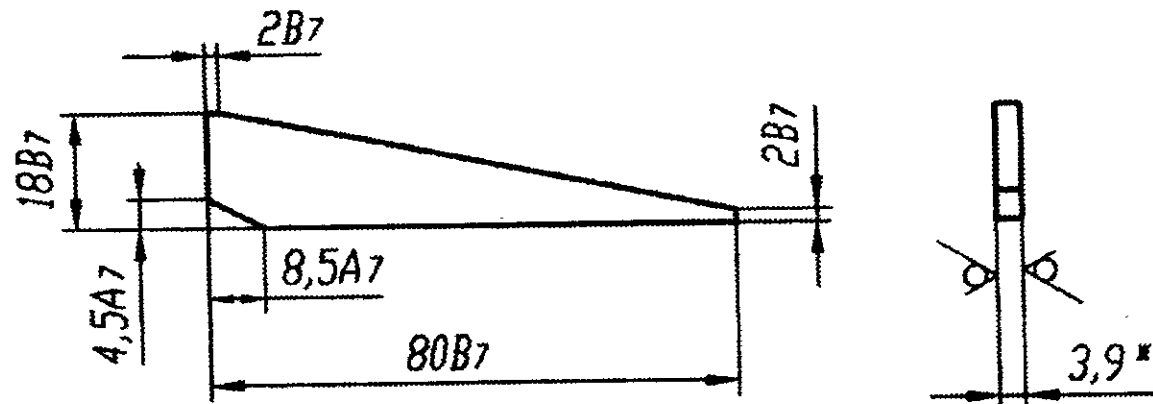
Approved OGMet Orig. Inv. No.	Sign and Date	Approved TOsb Alternate Inv. No.	Dupl. Inv. No.	Sign and Date	Approved KTONI	Reference No.	Approved by shop	First use																																					
<p>1. Blunt sharp edges R~0.6 mm. 2. Mark Ш, 4 on batch tag. 3. Stamp K as per AK-630, AK-630M TU I.</p>																																													
AK-630 109-10																																													
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th>Amend.</th> <th>Sheet</th> <th>Doc. No.</th> <th>Sign</th> <th>Date</th> </tr> </thead> <tbody> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td></tr> </tbody> </table>					Amend.	Sheet	Doc. No.	Sign	Date																					<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="2">Type</th> <th>Weight</th> <th>Scale</th> </tr> <tr> <td colspan="2" style="text-align: center;">A</td> <td style="text-align: center;">0.012</td> <td style="text-align: center;">2:1</td> </tr> <tr> <td colspan="2">Sheet</td> <td colspan="2">Sheets 1</td> </tr> </table>				Type		Weight	Scale	A		0.012	2:1	Sheet		Sheets 1	
Amend.	Sheet	Doc. No.	Sign	Date																																									
Type		Weight	Scale																																										
A		0.012	2:1																																										
Sheet		Sheets 1																																											
Developed by Checked by Head of Q.C.D. Design bureau chief Head of Q.C.D. Approved by					Stop Steel 25 GOST 1050-88																																								

Copied by

Format A4

AK-630 109-11

Rz160
√(√)



- 1.* Reference dimension.
- 2. Blunt sharp edges R~0.6 mm.
- 3. Mark Ш, Ч and stamp K on batch tag.

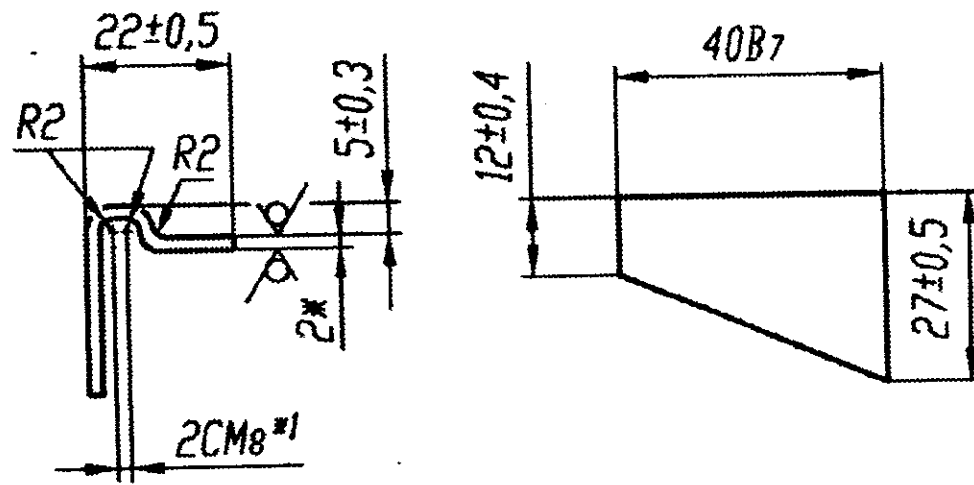
AK-630 109-11		AK-630 109-11	
Approved OGMet	Approved TOsb	Approved KTONI	First use
Orig. Inv. No.	Alternate Inv. No.	Dupl. Inv. No.	Reference No.
Sign and Date	Sign and Date	Sign and Date	
Amend.	Sheet	Doc. No.	Sign
Developed by	Checked by	Head of Q.C.D	Date
Design bureau chief	Head of Q.C.D	Approved by	
Gusset plate		Type	Weight
Sheet		A	0.005
Scale		1:1	
Sheet		Sheets 1	
Sheet <u>B - PN - 0 3.9 GOST 19903 - 74</u> <u>K490V 4 - III - 35 GOST16523 - 97</u>			

Copied by

Format A4

AK-630 109-12

Rz160 ✓(✓)

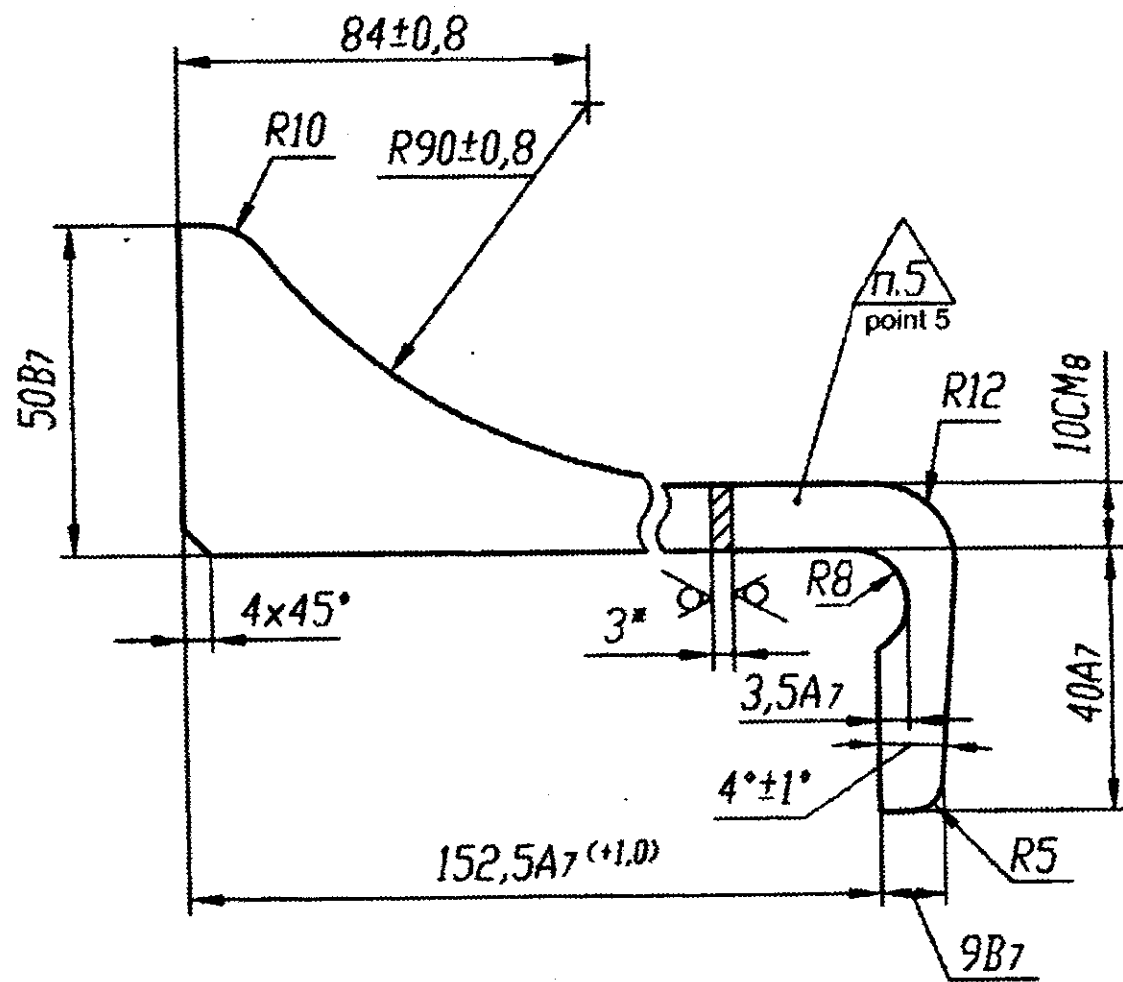


- 1.* Reference dimension.
- 2.*1 Dimension ensured by tool.
- 2. Blunt sharp edges R~0.4 mm.
- 3. Mark Ш, Ч and stamp K on batch tag.

AK-630 109-12		AK-630 109-12	
Approved OGMet Orig. Inv. No.	Approved TOsb Alternate Inv. No.	Approved KTONI Sign and Date	Approved by shop Reference No.
First use			
Sign and Date	Sign and Date	Sign and Date	Sign and Date
Amend.	Sheet	Doc. No.	Sign
Developed by			
Checked by			
Head of Q.C.D.			
Design bureau chief			
Head of Q.C.D.			
Approved by			
Rear back plate		Type A	Weight 0.023
Sheet		Scale 1:1	Sheets 1
Sheet <u>BT - PN - 02 GOST 19904 - 90</u> <u>K 490V 4 - III - 35 GOST 16523 - 97</u>			
Copied by		Format A4	

AK-630 109-14

Rz160 ✓(✓)



- 1.* Reference dimension.
- 2. Dimensions and maximum deviations ensured by tool.
- 3. Blunt sharp edges R~0.6 mm.
- 4. Mark Ш, Ч on batch tag.
- 5. Stamp K as per AK-630, AK-630M TU I.

Approved by shop	Reference No.	Approved KTONI	Sign and Date	Dupl. Inv. No.	Approved TOeb	Sign and Date	Alternate Inv. No.	Approved OGMet	Orig. Inv. No.	Sign and Date	Sign	Date	Sign	Date	Sign	Date	Sign	Date	
										AK-630 109-14									
										Rib									
										Type Weight Scale									
										A 0.055 1:1									
										Sheet Sheets 1									
										Sheet <i>BT - PN - 3GOST19903 - 74</i>									
										<i>K490V 4 - III - 25GOST16523 - 97</i>									
										Approved by									

Copied by

Format A4

AK-630 109-31

First use

Reference No.

Sign and Date

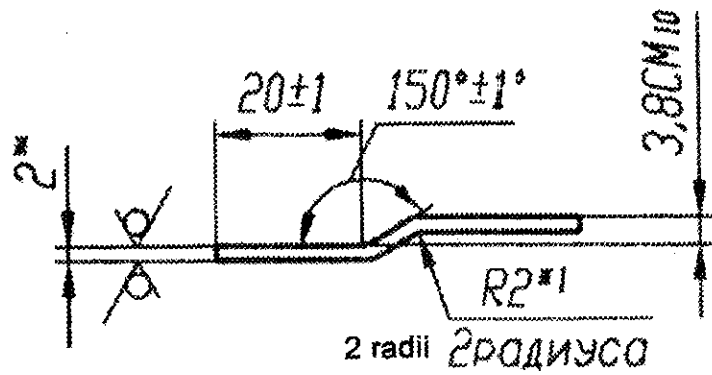
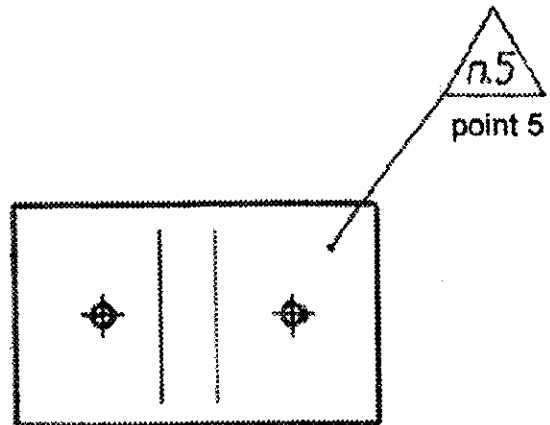
Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

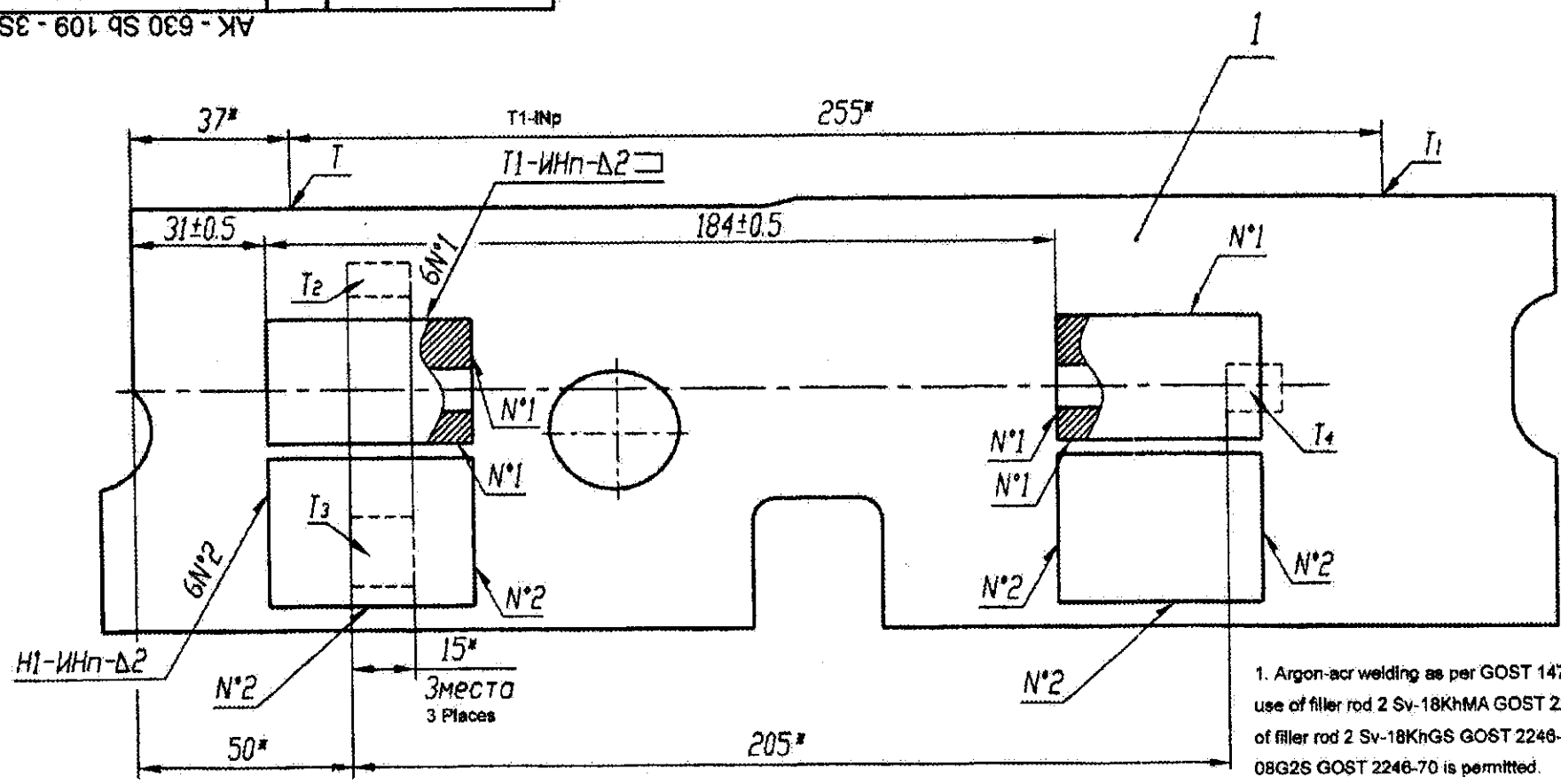
- 1.* Reference dimension.
- 2.*1 Dimension ensured by tool.
- 3. Blunt sharp edges ~0.2 mm.
- 4. Mark Ш, Ч on batch tag.
- 5. Stamp K as per AK-630, AK-630M TU I.



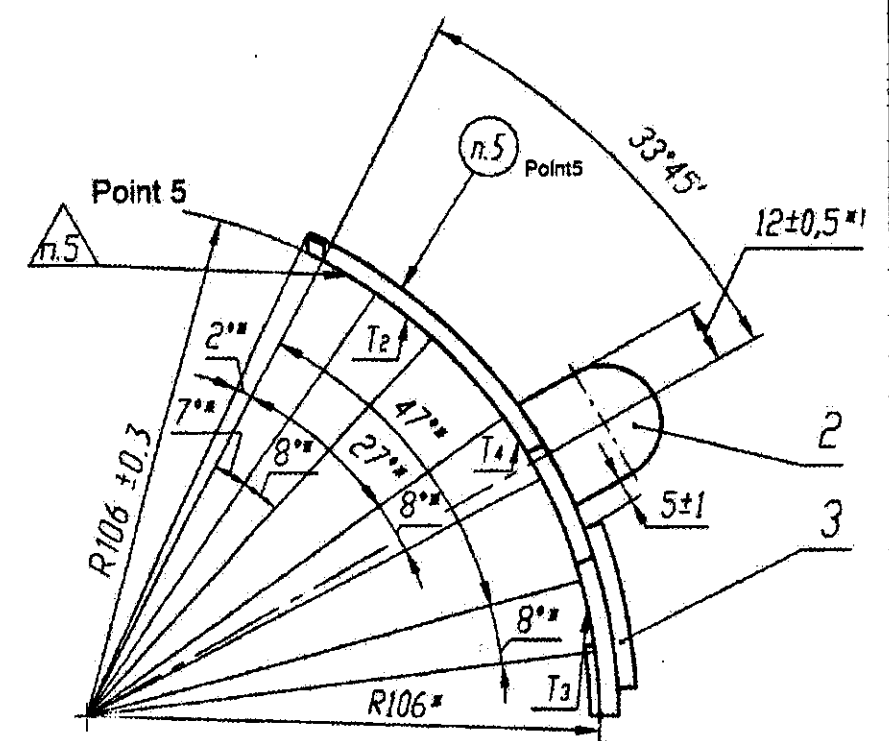
					AK-630 109-31				
					Cover plate		Type	Weight	Scale
							A	0.023	1:1
Amend.	Sheet	Doc.No.	Sign	Date			Sheet	Sheets	1
Developed by									
Checked by									
Head of Q.C.D									
Approved by							Blank component AK-630 109-30		

First use		Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
						<u>Documents</u>		
Reference No.	*)			✓	AK-630 Sb109-3 SB	Assembly drawing 8/2		*)A4 x 3
	*)			✓	AK-630 109-21	Cover plate 8/2	1	*)A4 x 3
	A4			2	AK-630 109-22	Boss 5/6	2	
	A4			3	AK-630 109-23	Cover plate 5/6	2	
Sign and Date								
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date					AK-630 Sb 109-3			
Orig. Inv. No.		Amend.	Sheet	Doc. No.	Sign	Date		
		Developed by				Type	Sheet	Sheets
		Checked by				A		1
		Head of Q.C.D				Cover plate		
		Approved by						

AK-630 СБ109-ЗСБ
AK-630 Sb 109 - 3SB



1. Argon-arc welding as per GOST 14771-76 with the use of filler rod 2 Sv-18KhMA GOST 2246-70. The use of filler rod 2 Sv-18KhGS GOST 2246-70 or rod 1.2 Sv-08G2S GOST 2246-70 is permitted.
2. * - Dimensions are ensured by tool.
3. *1 - Dimension is given in respect of base surfaces T, T1, T2, T3, T4.
4. Straightening is permitted.
5. Mark Ш, Ч and stamp К as per AK-630, AK-630M TU I.



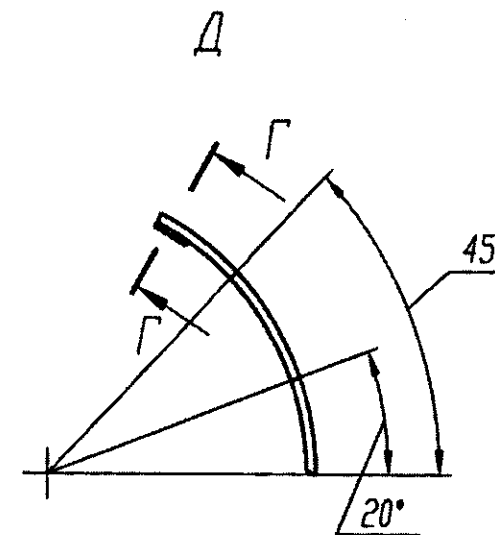
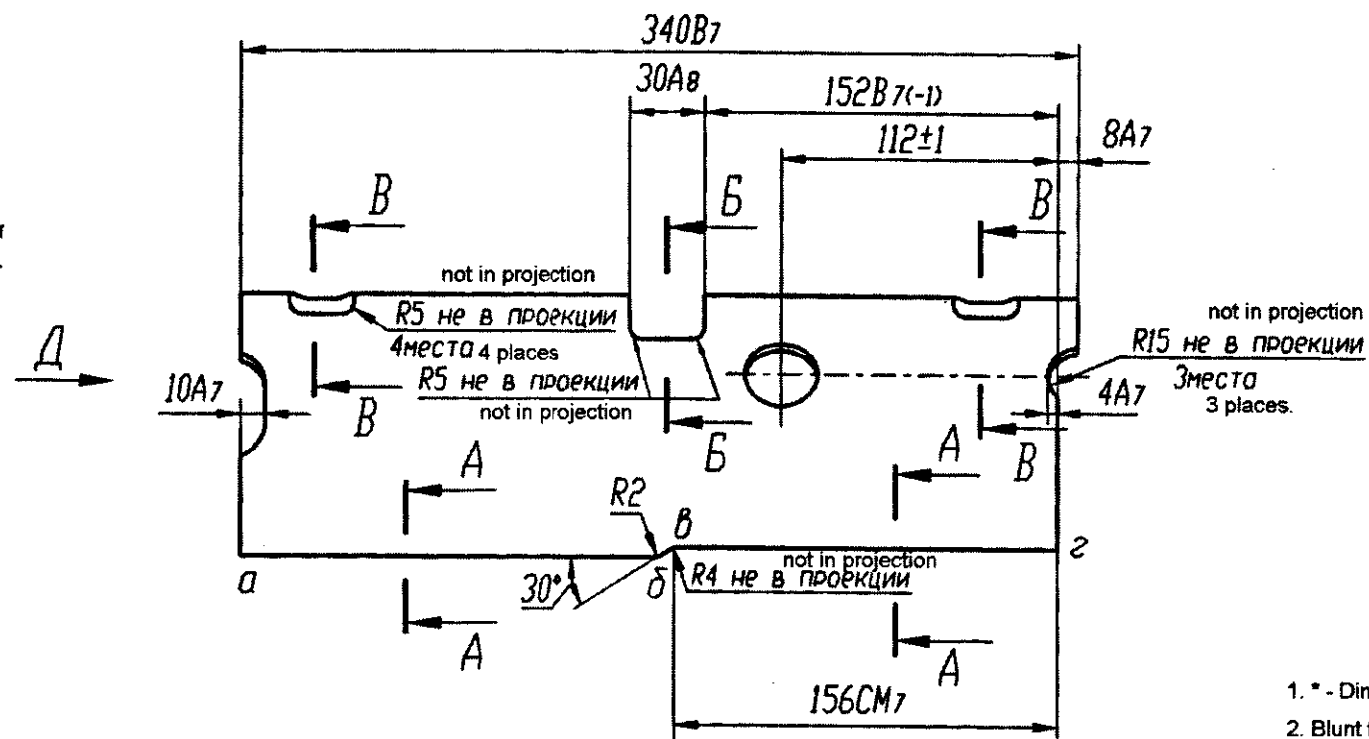
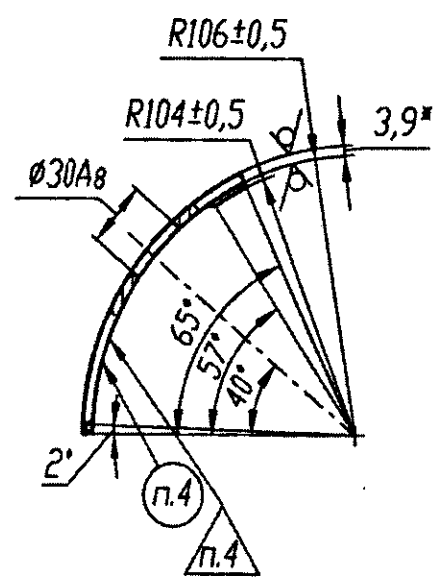
1. Сварка аргоно-дуговая по ГОСТ 14771-76 с применением присадочной проволоки 2 Св-18ХМА ГОСТ 2246-70. Допускается применение проволоки 2 Св-18ХГС ГОСТ 2246-70 или проволока 1,2 Св-08Г2С ГОСТ 2246-70.
2. *Размеры обеспеч. инстр.
3. *1Размер задан относительно базовых поверхностей T, T1, T2, T3, T4.
4. Допускается правка.
5. Маркировать Ш, Ч и клеймить К по АК-630, АК-630М ТУ I. АК-630 Sb 109 - 3SB

				AK-630 СБ109-ЗСБ		
				Type	Mass	Scale
				Cover Plate.	Лит.	Масса
				Лит.	Масса	Масштаб
				Накладка		
				Сборочный чертёж		
				Assembly Drawing		
				Лист	Листов	
				Sheet	Total Sheets 1	

12-601 039-ЖВ

AK 630 109-21

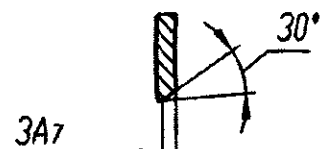
Rz80 ✓(✓)



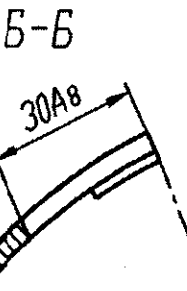
1. * - Dimension for reference.
2. Blunt the sharp edges ~ 0.6 mm.
3. Dimensions and limiting deviations are ensured by tool.
4. Mark Ш, Ч and stamp K as per AK - 630, AK - 630 M TU I.

1. *Размер для справок.
2. Острые ребра притупить ~ 0,6мм.
3. Размеры и пред. откл. обесп. инстр.
4. Маркировать Ш,Ч и клеймить К по АК-630, АК-630М ТУ I.

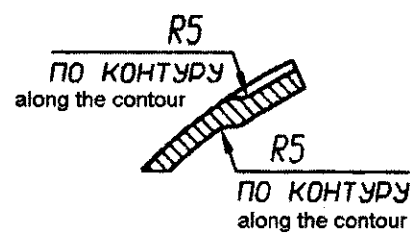
A-A(1:1)



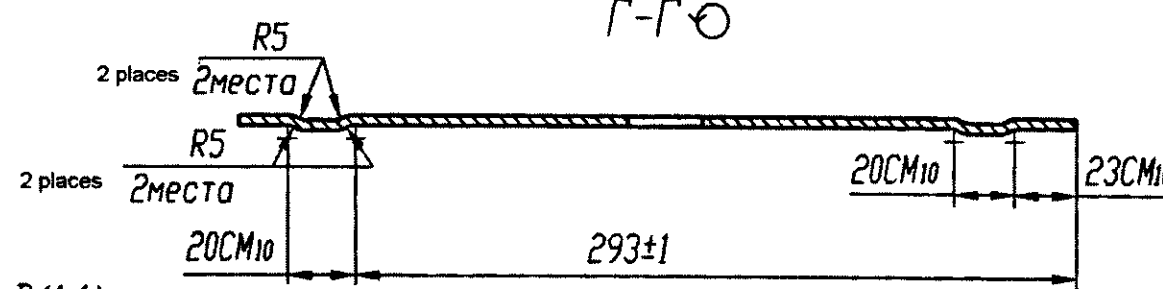
по контуру "абвг" along the contour "абвг"



B-B(1:1)



Г-Г



Bale 8 _ Container 3

AK - 630 109 - 21

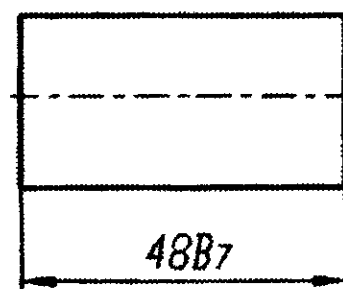
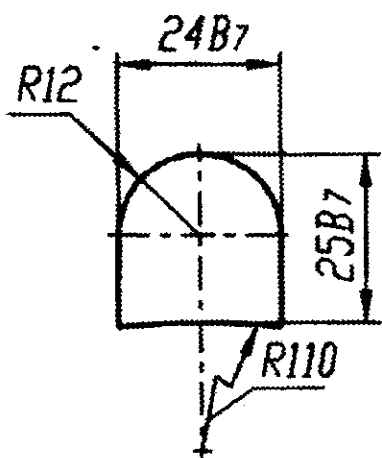
AK-630 109-21 mass scale

				AK-630 109-21 mass scale		
				Лит.	Масса	Масштаб
Cover plate Накладко				A	1.140	1:2
Изм/Лист	№ докум.	Подп.	Дата	Sheet B-PN-0-3.9 GOST 19903-74 Лист Листов 1		
Разроб.				Лист Б-ПН-0-3,9 ГОСТ 19903-74		
Т.контр.				К490В 4-III-40 ГОСТ 16523-97 sheet total sheets		
И.контр.						
Утв.						

К 490В 4 - III - 40 GOST 16523-97

AK-630 109-22

Rz40 ✓



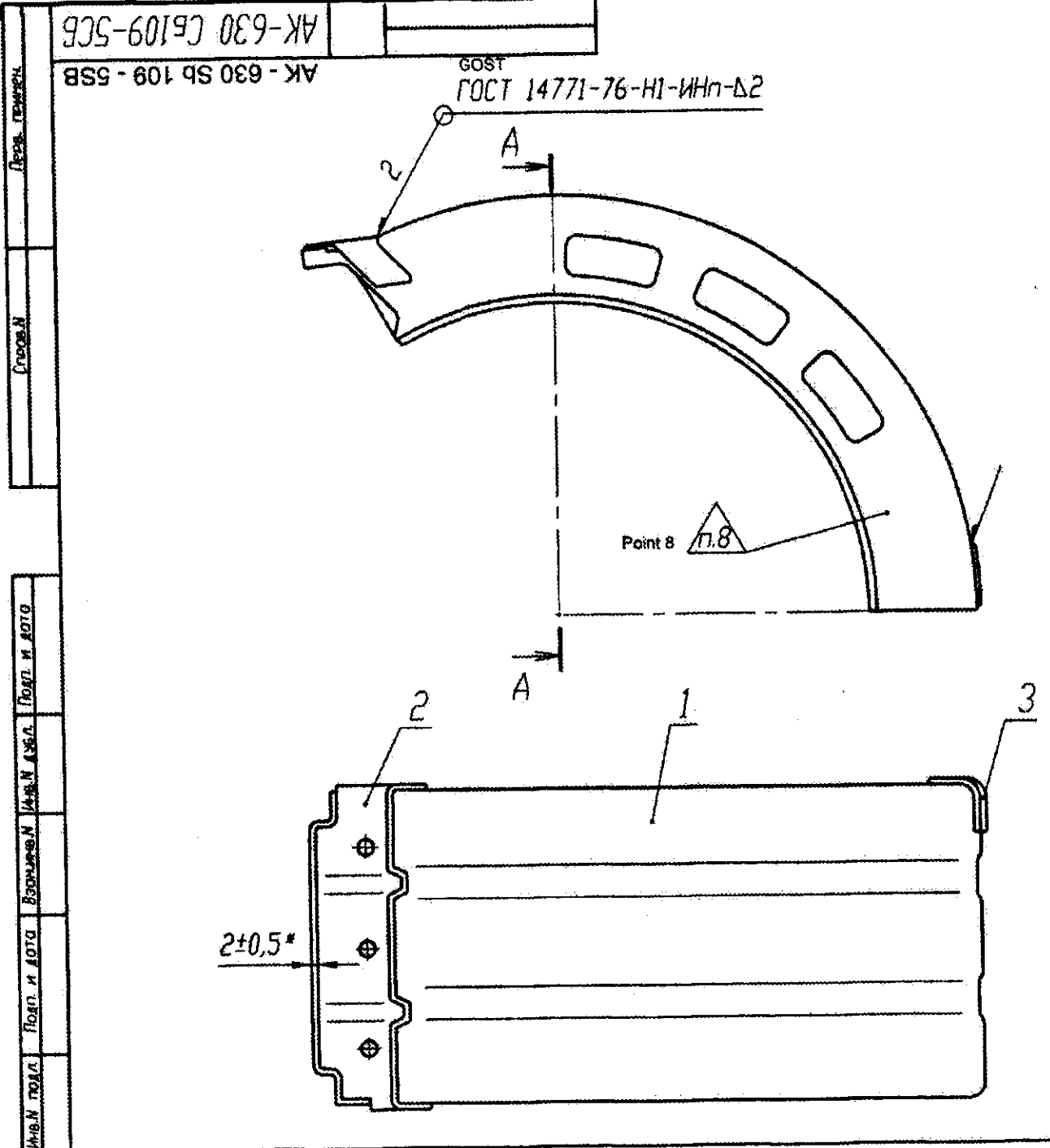
1. Blunt sharp edges R~0.6 mm.
2. Mark Ш, Ч and stamp K on batch tag.

Approved OGMet	Orig. Inv. No.	Sign and Date	Alternate Inv. No.	Approved TOsb	Dupl. Inv. No.	Sign and Date	Approved KTONI	Reference No.	Approved by shop	First use
AK-630 109-22										
<div style="display: flex; justify-content: space-around; align-items: center;"> </div> <p>1. Blunt sharp edges R~0.6 mm. 2. Mark Ш, Ч and stamp K on batch tag.</p>										
AK-630 109-22										
					Type			Weight		Scale
					A			0.170		1:1
					Sheet			Sheets 1		
					Boss					
					Steel 35 GOST 1050-88					

Copied by

Format A4

First use		Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
		<u>Documents</u>						
Reference No.	*)		✓		AK-630 Sb109-5 SB	Assembly drawing 8/2		*)A4 x 3
	<u>Components</u>							
	*)	✓	1		AK-630 109-7	Cover 8/2	1	*)A4 x 3
	A2	✓	2		AK-630 109-15	Cover strap 8/2	1	
	A3		3		AK-630 109-30	Cover plate 7/7	1	
Sign and Date								
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date		AK-630 Sb 109-5						
Orig. Inv. No.	Amend.	Sheet	Doc. No.	Sign	Date			
	Developed by					Type	Sheet	Sheets
	Checked by					A		1
	Head of Q.C.D					Cover		
	Approved by							



1. Argon-arc welding with the use of filler rod 2.0 Sv-18KhMA GOST 2246-70. It is permitted to use filler rod 2.0 Sv-18KhGS GOST 2246-70.
2. * - Dimension for welding along the contour of the cover plate of cover position 2.
3. Projection of welding joint for the contour of cover position 1 and for the surface of cover plate of cover is not permitted. Finishing of welding joint with surface finish Rz 40 is permitted.
4. Polish the surface Б - 0.63 V. Permissible defects are as per test-specimen.
5. Electrochemical polishing with surface finish as per standard is permitted.
6. Coating of surface Б - Hard Chrome 24.
7. Mark Ш, Ч on the tag for batch.
8. Stamp K as per AK-630, AK-630M TU 1.
9. The reduction of thickness up to 1.65 mm on the places of polishing and the increase of radiuses up to 4 mm after polishing is permitted.

1. Сварка аргоно-дуговая с применением присадочной проволоки 2,0 Св-18ХМА ГОСТ 2246-70. Допускается применение проволоки 2,0 Св-18ХГС ГОСТ 2246-70.
2. *Размер под сварку по контуру накладке крышки поз.2.
3. Выступание сварного шва за контур крышки поз.1 и за поверхности накладке крышки не допускается. Допускается зачистка сварного шва Rz40.
4. Поверхность Б полировать 0,63. Допустимые дефекты по контрольному образцу.
5. Допускается электрохимическое полирование с чистотой обработки по эталону.
6. Покрытие поверхности Б-Хтв24.
7. Маркировать Ш,Ч на бирке к партии.
8. Клеить К по АК-630, АК-630М ТУ 1.
9. Допускается уменьшение толщины до 1,65мм в местах полирования и увеличение радиусов до 4мм после полирования.

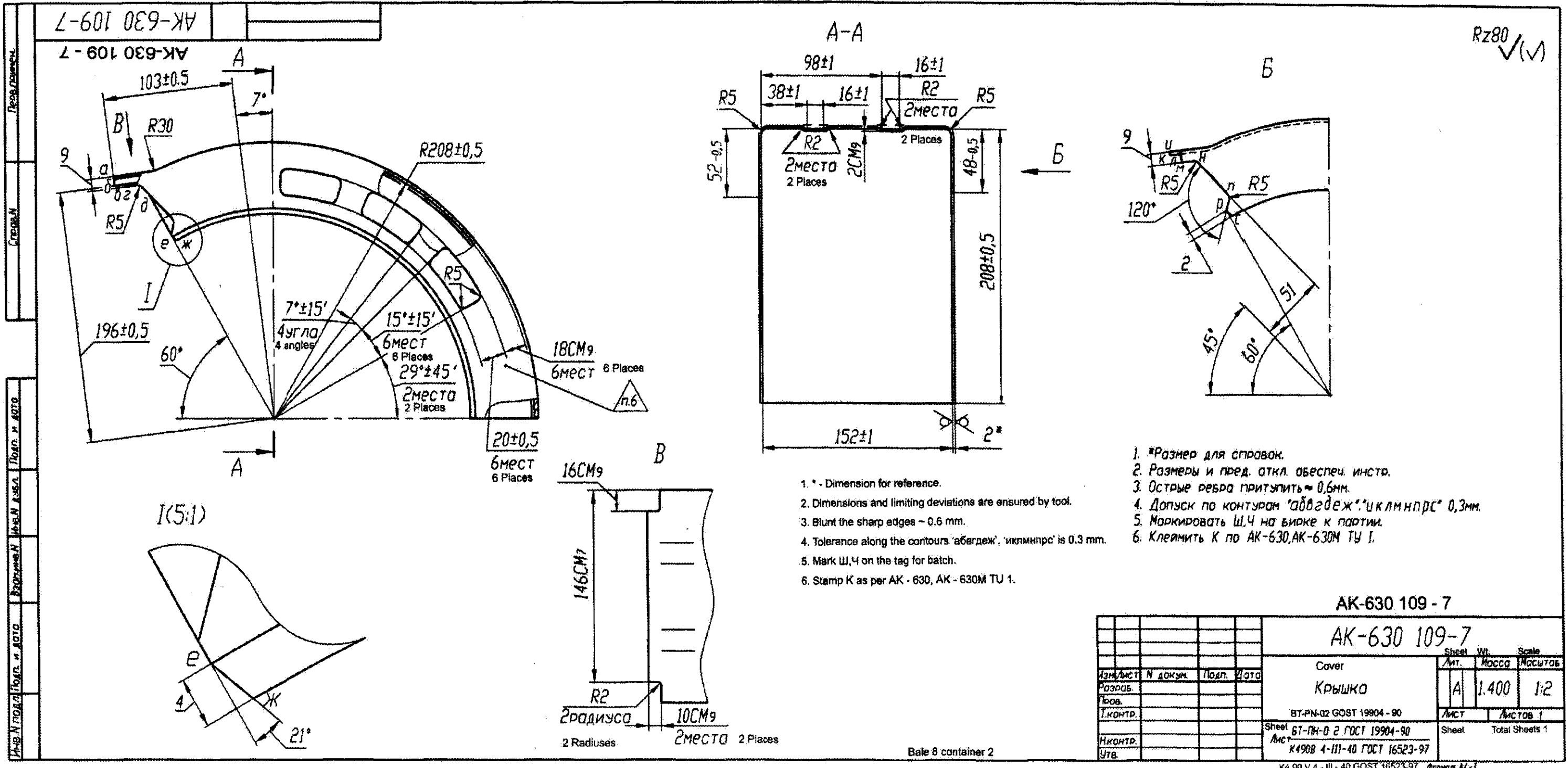
AK - 630 Sb 109 - 5SB

AK-630 СБ109-5СБ

				Scale		
				Лит.	Масса	Масштаб
Изм.	Лист	№ докум.	Подп.	Дата	А	1:2
Разраб.						
Проб.						
Т.контр.						
И.контр.						
УТВ.						
				Лист	Листов	
				Sheet	Sheets 1	

Вале 8 container 2

Формат А4х3



Rz80 ✓(✓)

- 1. * - Dimension for reference.
- 2. Dimensions and limiting deviations are ensured by tool.
- 3. Blunt the sharp edges - 0.6 mm.
- 4. Tolerance along the contours 'абвгдеж', 'иклмнпрс' is 0.3 mm.
- 5. Mark Ш,Ч on the tag for batch.
- 6. Stamp K as per AK - 630, AK - 630M TU 1.

- 1. *Размер для справок.
- 2. Размеры и пред. откл. обеспеч. инстру.
- 3. Острые ребра притупить ~ 0,6мм.
- 4. Допуск по контурам 'абвгдеж', 'иклмнпрс' 0,3мм.
- 5. Маркировать Ш,Ч на бирке к партии.
- 6. Клеянить К по АК-630, АК-630М ТУ 1.

AK-630 109 - 7

AK-630 109-7

Лист		Масштаб	
Лит.	Масса	Листов	Листов
A	1.400	1	1

Контр.	Дата	Подп.	Имя
Контр.	Дата	Подп.	Имя

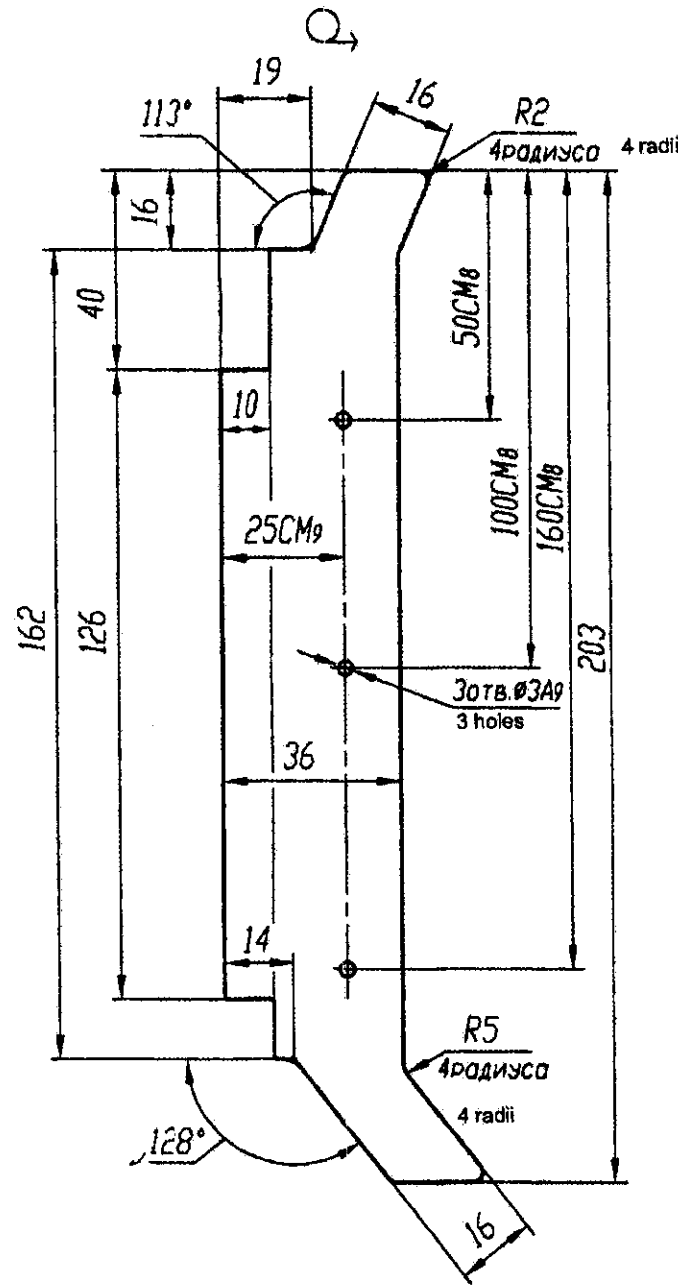
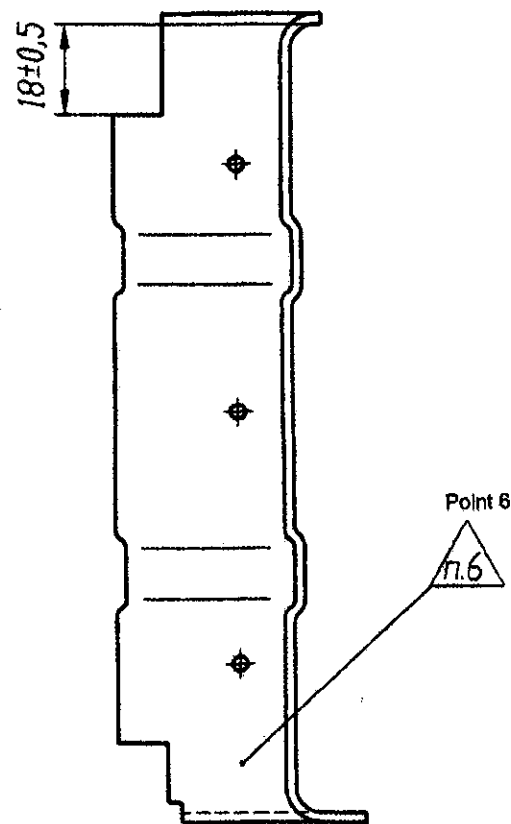
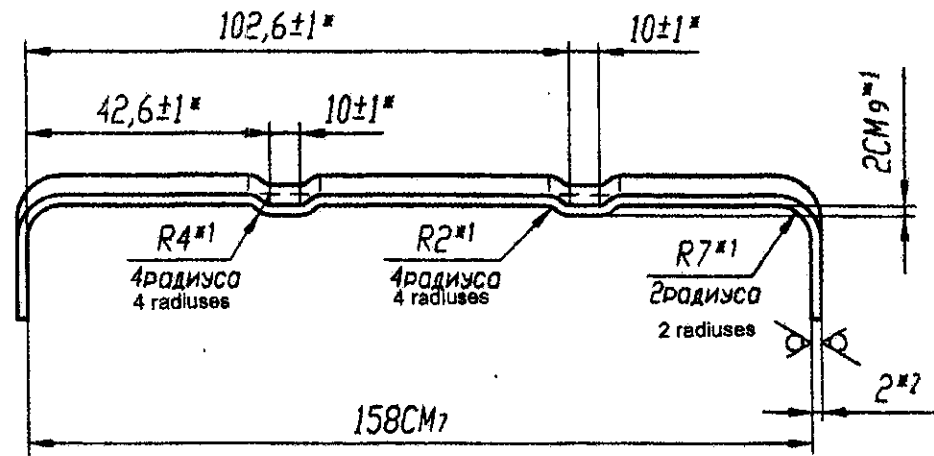
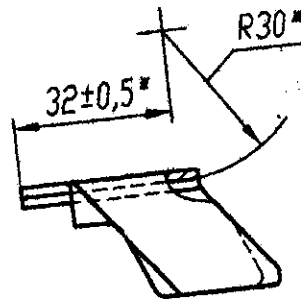
Лит.	Масса	Листов	Листов
A	1.400	1	1

К4 90 V 4 - III - 40 GOST 16523-97 Фирма АКЗ

Bale 8 container 2

AK-630 109-15

Rz160 (✓)



1. Tolerance along the contour of reamer is 0.5 mm.
2. * - Dimensions are ensured by the tool.
3. *1 - Dimensions are not given in projection.
4. *2 - Dimension for reference.
5. Mark Ш, Ч on the tag for batch.
6. Stamp K as per AK - 630, AK-630M TU 1.

1. Допуск по контуру развертки -0,5мм.
2. *Размеры обеспеч. инстр.
3. *1Размеры заданы не в проекции.
4. *2Размер для справок.
5. Маркировать Ш,Ч на бирке к партии.
6. Клеймить К по АК-630, АК-630М ТУ 1.

				AK-630 109-15 _{Lt} Wt. Scale		
Изм/Лист	№ докум.	Подп.	Дата	Контр.	Лист	Листов
Разраб.					A	1/1
Пров.					Листов 1	
И.контр.					Total sheets 1	
Утв.					Лист 1	
				Cover plate of cover Накладка крышки		
				Лист ВТ-ПН-0 2 ГОСТ 19904-90		
				Лист К490В 4-III-35 ГОСТ 16523-97		

Инв. № подл./Подп. и дата
 Изм. № вкл./Подп. и дата
 Дата
 Подп.

AK-630 109-30

First use

Reference No.

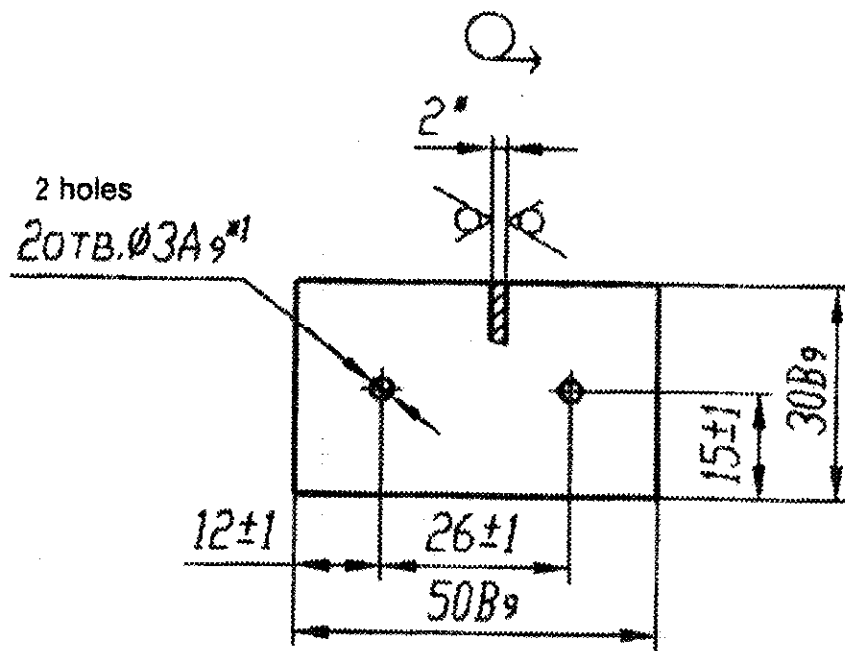
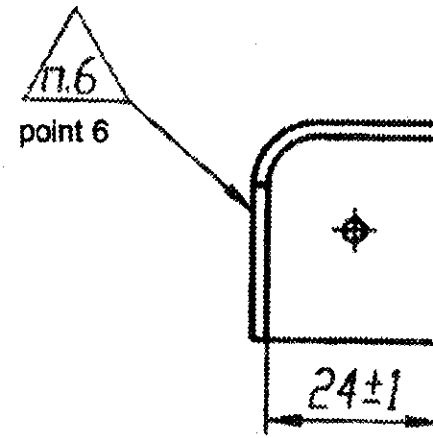
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



1. Bending radius R7 mm, ensured by tool.
2. * Reference dimension.
3. *1 Dimension ensured by tool.
4. Blunt sharp edges ~0.2 mm.
5. Mark Ш, Ч on batch tag.
6. Stamp K as per AK-630, AK-630M TU I.

					AK-630 109-30					
					Cover plate					
									Type	Weight
Amend.	Sheet	Doc.No.	Sign	Date	A		0.023		1:1	
Developed by										
Checked by					Sheet		Sheets 1			
Head of Q.C.D										
Approved by					Sheet <u>BT - PN - 0 2 GOST19904 - 90</u> K490V 4 - III - 40 GOST16523 - 97					

First use		Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks
						<u>Documents</u>		
Reference No.		A3			AK-630 Sb109-2 SB	Assembly drawing 7/7		
						<u>Assembly units</u>		
		A4		1	AK-630 Sb109-4	Locking pin.	1	
						<u>Components</u>		
		A3		2	AK-630 109-17	Catch 7/7	1	
		A3		3	AK-630 109-18	Spring 7/7	1	
		A4		4	AK-630 109-19	Pin 5/6	1	
Sign and Date								
Dupl. Inv. No.								
Alternate Inv. No.								
Sign and Date								
Orig. Inv. No.								
		Amend.	Sheet	Doc. No.	Sign	Date	AK-630 Sb 109-2	
		Developed by				Type	Sheet	Sheets
		Checked by				A		1
		Head of Q.C.D				Assembled Locking pin		
		Approved by						

AK-630 Sb109-2 SB

First use

Reference No.

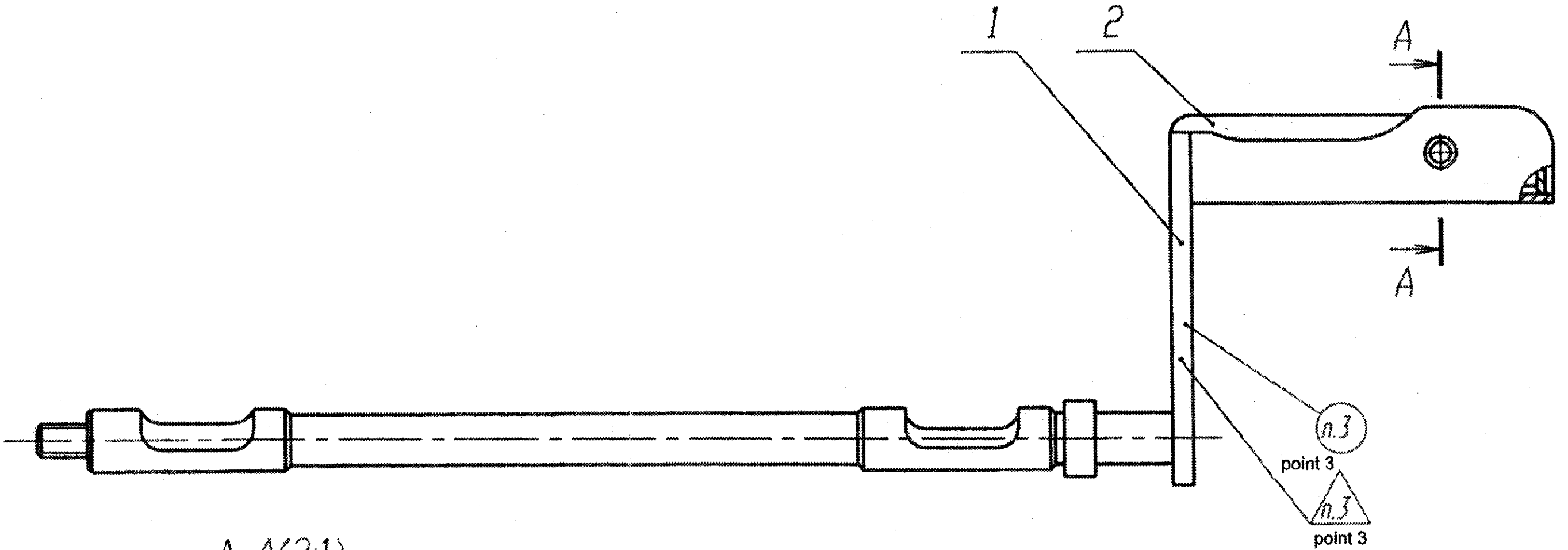
Sign and Date

Duplicate Inv. No

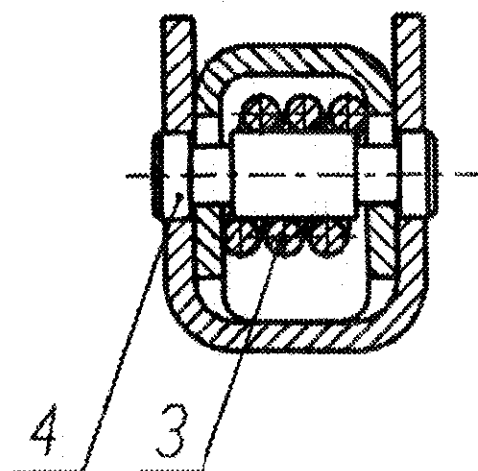
Alternate Inv. No

Sign and Date

Orig. inv. no.



A-A(2:1)



1. Catch pos.2 should rotate around axis pos.4 and swiftly return to initial position with help of spring pos.3.
2. Lubricate rubbing surfaces with lubricant MS-70 GOST 9762-76.
3. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

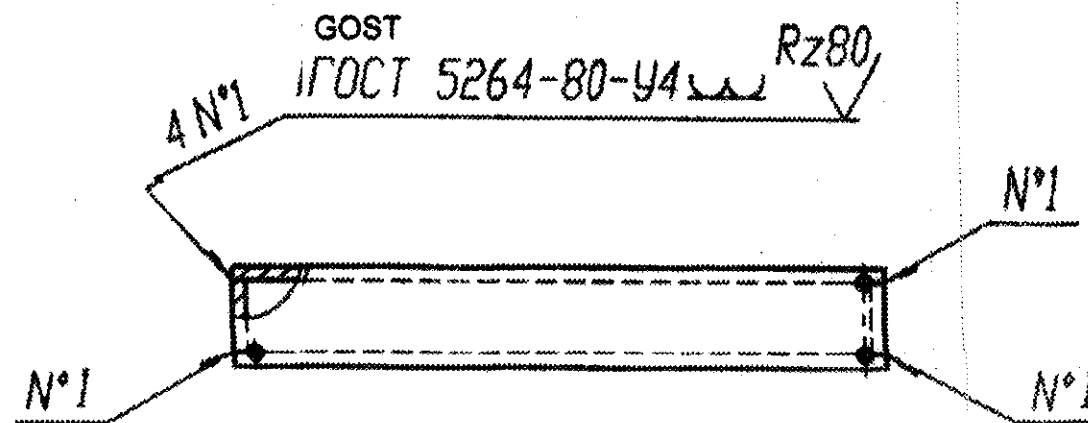
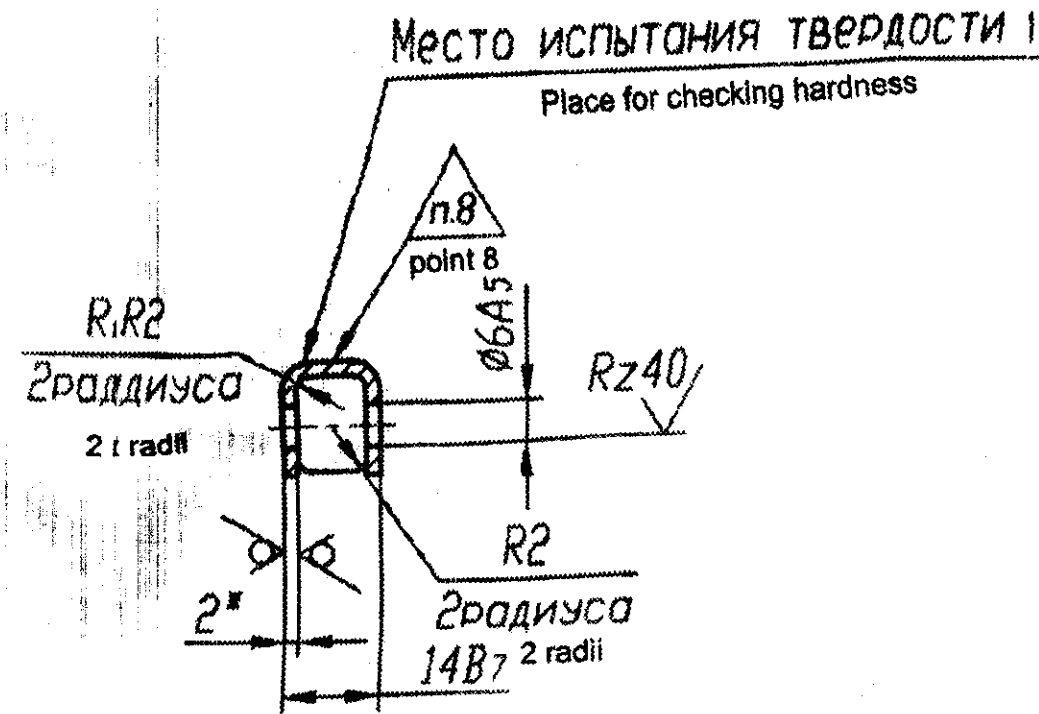
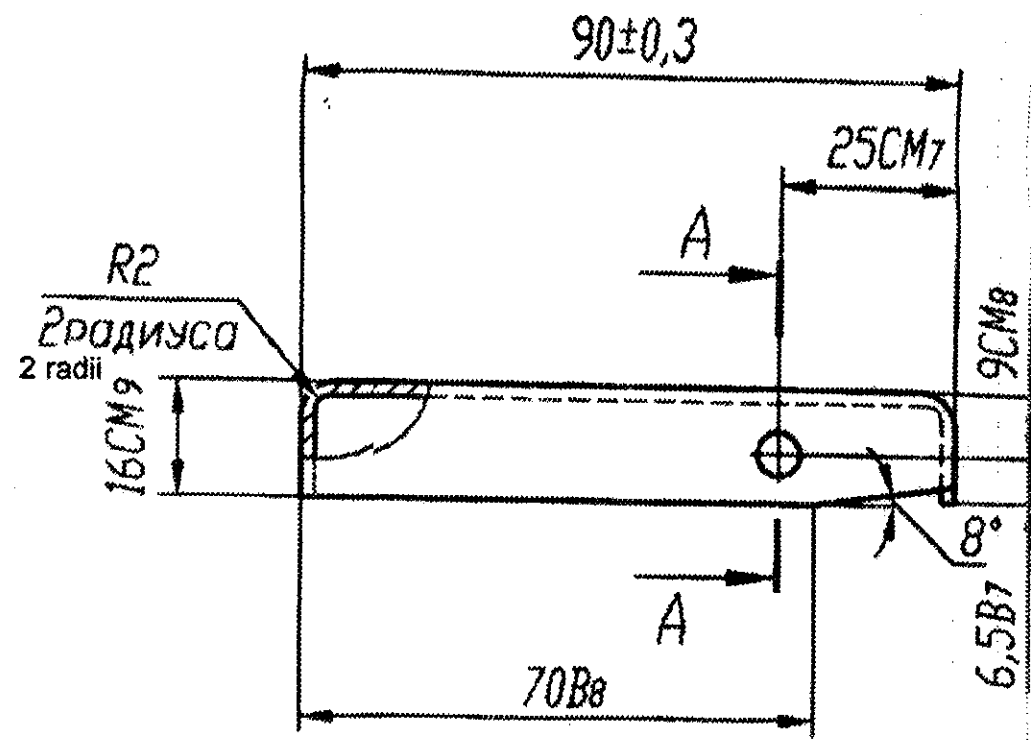
AK-630 Sb109-2 SB

					AK-630 Sb109-2 SB			
					Type	Weight	Scale	
Amend.	Sheet	Doc.No.	Sign	Date	Assembled Locking pin Assembly drawing	A	0.345	1:1
Developed by						Sheet	Sheets 1	
Checked by								
Head of Q.C.D								
Approved by								

AK-630 109-17

Rz80 ✓(✓)

A-A



1. Welding rod UONII- 13/45 -3.0-3 GOST 9466-75.
2. 67.0...70.0 HRA, check 3-5% of the batch but not less than 3 nos.
- 3.* Reference dimension.
4. Blunt sharp edges ~0.6 mm.
5. Drilling of hole with Ø3A₇ not more is permissible at places of double bend.
6. Coating Cd12.phos.impregnation with lacquer BF-4 with Nigrosine, two coats, made as per OST 3-4123-78, IV, OM2.
7. Mark Ш, Ч and stamp И on batch tag.
8. Stamp K as per AK-630, AK-630M TU I.
9. Argon-arc welding by using filler wire 1.2 Sv-18 KhGS GOST 2246-70 or 1.2 Sv-18 KhMA GOST 2246-70 is permissible.

					AK-630 109-17				
							Type	Weight	Scale
					Catch		A	0.063	1:1
							Sheet	Sheets 1	
					Sheet <u>BT - PN - 0 2 GOST19904 - 90</u> <u>K 490V 4 - III - 40 GOST16523 - 97</u>				
Amend.	Sheet	Doc.No.	Sign	Date					
Developed by									
Checked by									
Head of Q.C.D									
Approved by									

First use

Reference No.

Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

AK-630 109-18

First use

Reference No.

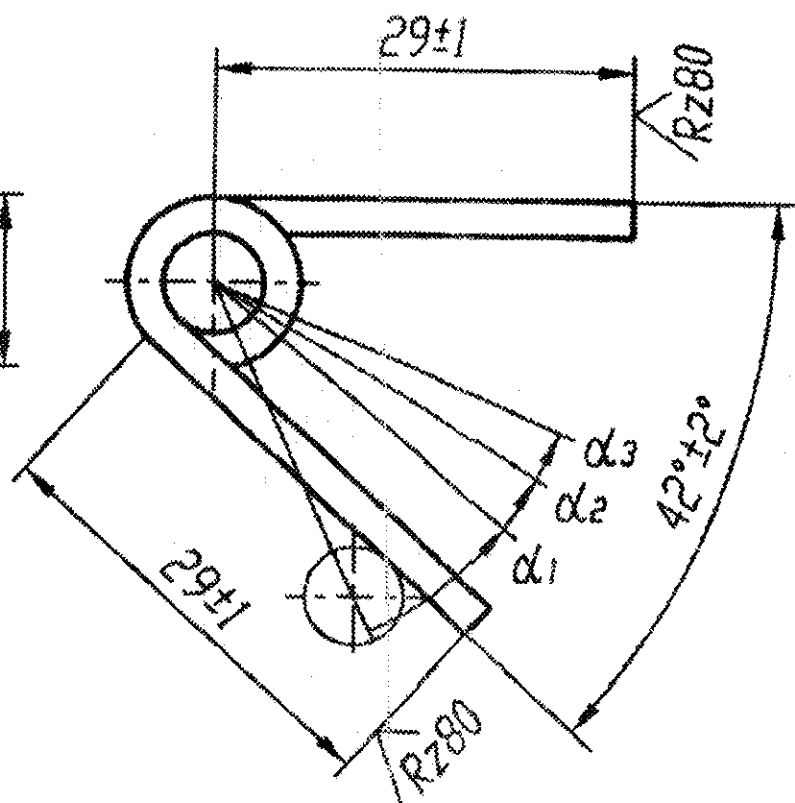
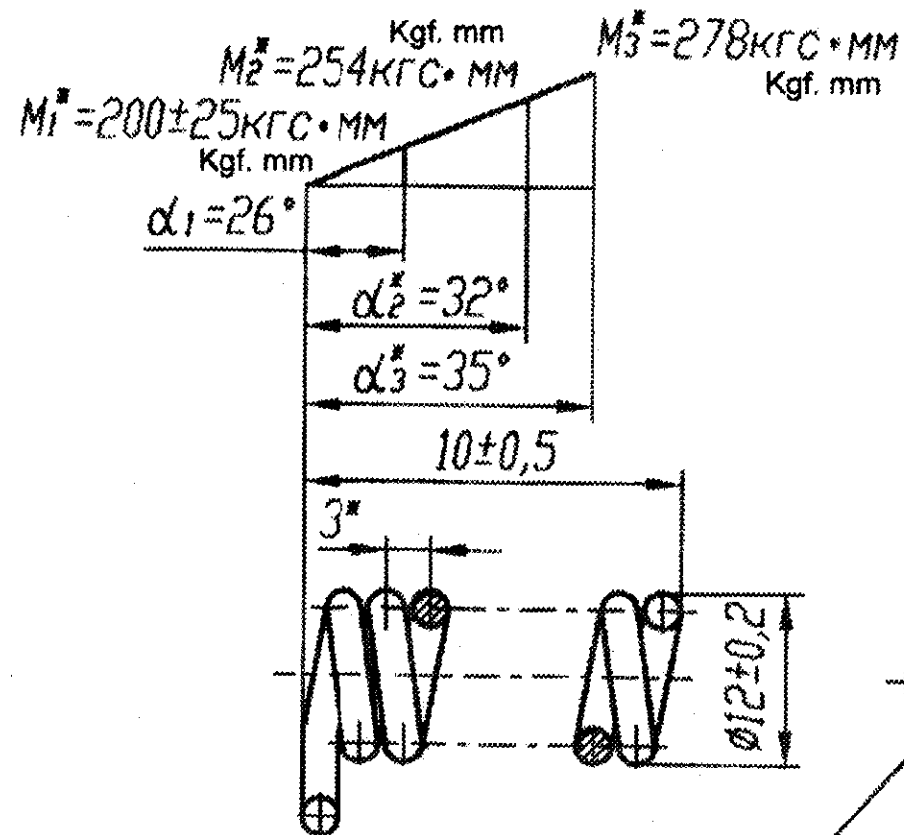
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



✓(✓)

1. Group II.
2. $E^* = 21000 \text{ kgf/mm}^2$; $\sigma^*_z = 205 \text{ kgf/mm}^2$.
3. Length of uncoiled spring $L^* = 160 \text{ mm}$.
4. Coiling direction- right.
5. $n = 2.5$
6. Heat treatment : Tempering $240^\circ - 260^\circ$.
7. Pre deformation time (at α_2) -24 hours
8. $D_s = 6 C_s$.
9. Coating: Chem.Phos.
Lacquer BF-4 with Nigrosine, 2 coats, made as per OST 3-4123-78, IV, OM2.
- 10.* Dimensions and parameters for reference.
11. Mark Ш, Ч and stamp K, И on batch tag.
12. Other technical requirements as per OST 3-2561-91

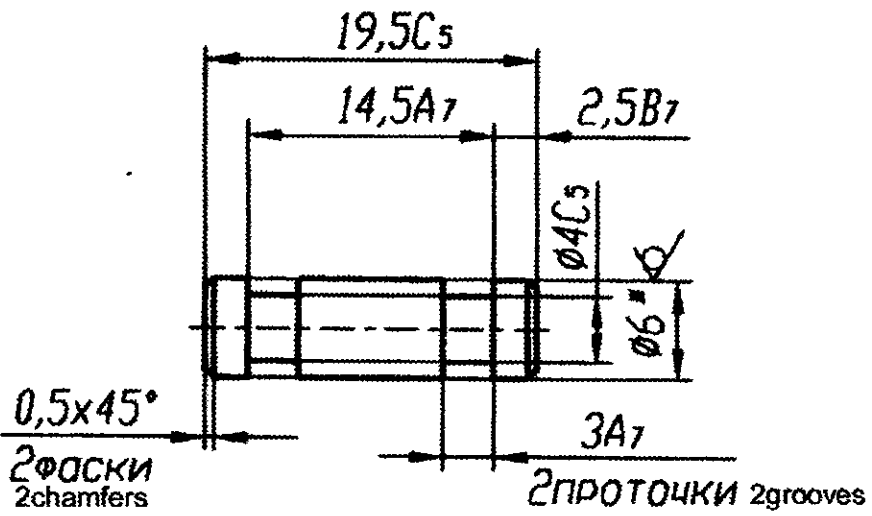
AK-630 109-18

Amend.	Sheet	Doc.No.	Sign	Date	Spring	Type	Weight	Scale	
							A	0.006	2:1
							Sheet	Sheets	1
					Wire V-1-2.5 GOST 9389-75				

AK-630 109-19

Approved OGMet	Approved TOsb	Approved KTONI	Approved by shop	First use	
Orig. Inv. No.	Alternate Inv. No.	Sign and Date	Reference No.		
Dupl. Inv. No.	Sign and Date				

Rz40 ✓(✓)



1. 38.5...44.5 HRC_E, check on specimen.
 2. * Reference dimension.
 3. Inner angles R~0.4 mm.
 4. Blunt sharp edges R~0.4 mm.
 5. Coating: Cd12.Phos.Impregnation with lacquer BF-4 with Nigrosine , single coat, made as per OST 3-4123-78.IV.OM2.
 6. Mark Ш, Ч and stamp K, И on batch tag.

AK-630 109-19					
Amend.	Sheet	Doc. No.	Sign	Date	
Developed by					Type
Checked by					A
Head of Q.C.D					Weight
Design bureau chief					0.005
Head of Q.C.D					Scale
Approved by					2.5:1
					Sheet
					Sheets 1
					Pin
					Wheel
					6 - 5 GOST 7417 - 75
					50 - T - V GOST1051 - 73

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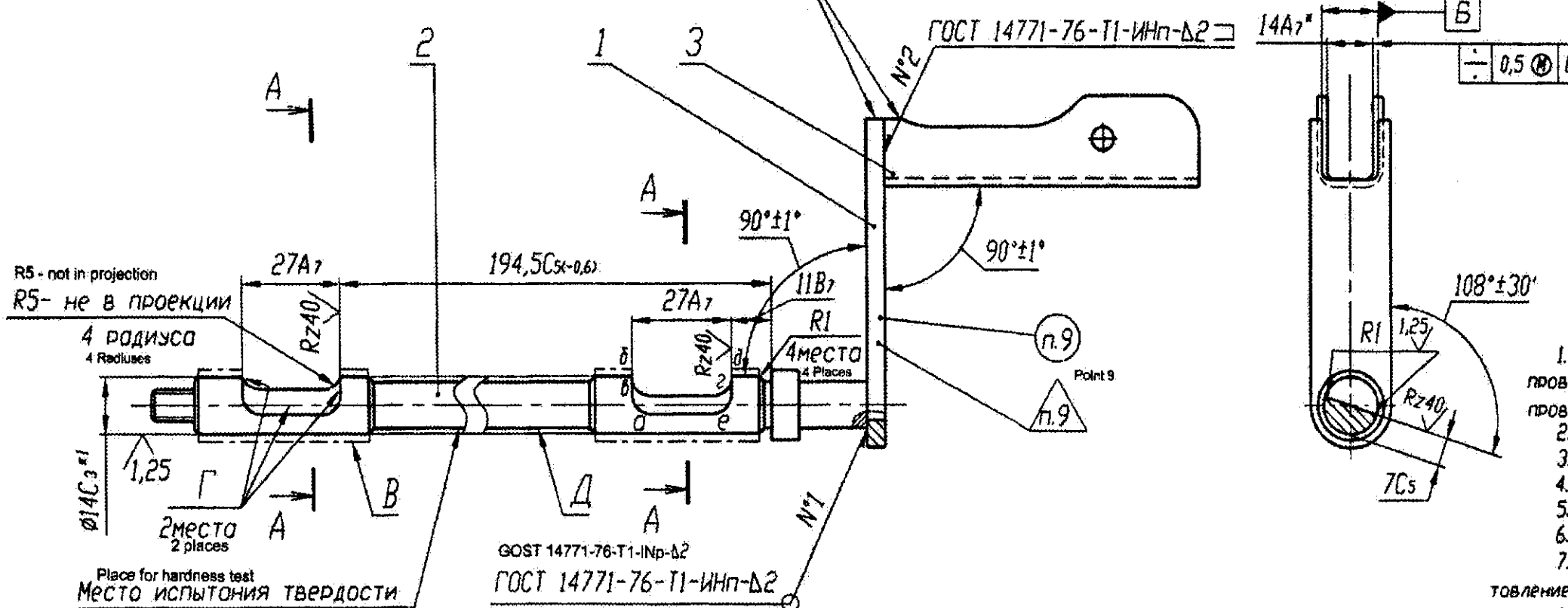
Format A4

First use		Format	Zone	Pos.	Designation	Nomenclature	Qty.	Remarks	
		<u>Documents</u>							
Reference No.	*)				AK-630 Sb109-4 SB	Assembly drawing 8/2		*)A4x3	
	<u>Components</u>								
	A4	1			AK-630 109-125	Lever 5/6	1		
	A4	2			AK-630 109-26	Pin 5/6	1		
	A4	3			AK-630 109-27	Handle 5/6	1		
Sign and Date									
Dupl. Inv. No.									
Alternate Inv. No.									
Sign and Date		AK-630 Sb 109-4							
Orig. Inv. No.		Amend.	Sheet	Doc. No.	Sign	Date			
		Developed by					Type	Sheet	Sheets
		Checked by					A		1
		Head of Q.C.D					Locking pin		
		Approved by							

AK-630 Sb 109-4SB
AK-630 Sb 109-4SB

Set afflushed (abuffed). Projection or sinking in for not more than 0.3 mm is permitted

Установить заподлицо. Допускается выступание или утопание не более 0,3 мм



1. Argon-arc welding as per GOST 14771-76 with the use of filler rod 2 Sv-18KhMA GOST 2246-70. The use of filler rod 2 Sv-18KhGS GOST 2246-70 is permitted.
2. 34...39.5 HRCs.
3. * - Dimensions for reference.
4. *1 - Dimension after coating.
5. Blunt the sharp edges ~ 0.6 mm.
6. Along the contour a б в and г д e R1, the roughness of surface is Rz40.
7. Coating Kad 12. phos. followed by oil treatment. Varnish BF-4 with nigrogin, 1 layer, preparation as per OST3-4123-78, IV.OM2. Coating of surface B - X. mol 21.
8. Presence of chrome on surfaces Г and Д is permitted.
9. Mark Ш, Ч and К, И as per AK-630, AK-630M TU I.

1. Сварка аргоно-дуговая с применением присадочной проволоки 2 Св-18ХМА ГОСТ 2246-70. Допускается применение проволоки 2 Св-18ХГС ГОСТ 2246-70.
2. 34...39,5 HRCs.
3. * Размеры для справок.
4. *1 Размер после покрытия.
5. Острые ребра притупить ~ 0,6 мм.
6. По контурам а б в и г д e R1, шероховатость поверхности - Rz40.
7. Покрытие Kad 12. фос. прп. Лак БФ-4 с нигрозином, 1 слой, приготовление по OST3-4123-78, IV.OM2. Покрытие поверхности B-X. мол 21.
8. Допускается наличие хрома на поверхностях Г и Д.
9. Маркировать Ш, Ч и клеймить К, И по АК-630, АК-630М ТУ I.

AK - 630 Sb 109 - 4SB

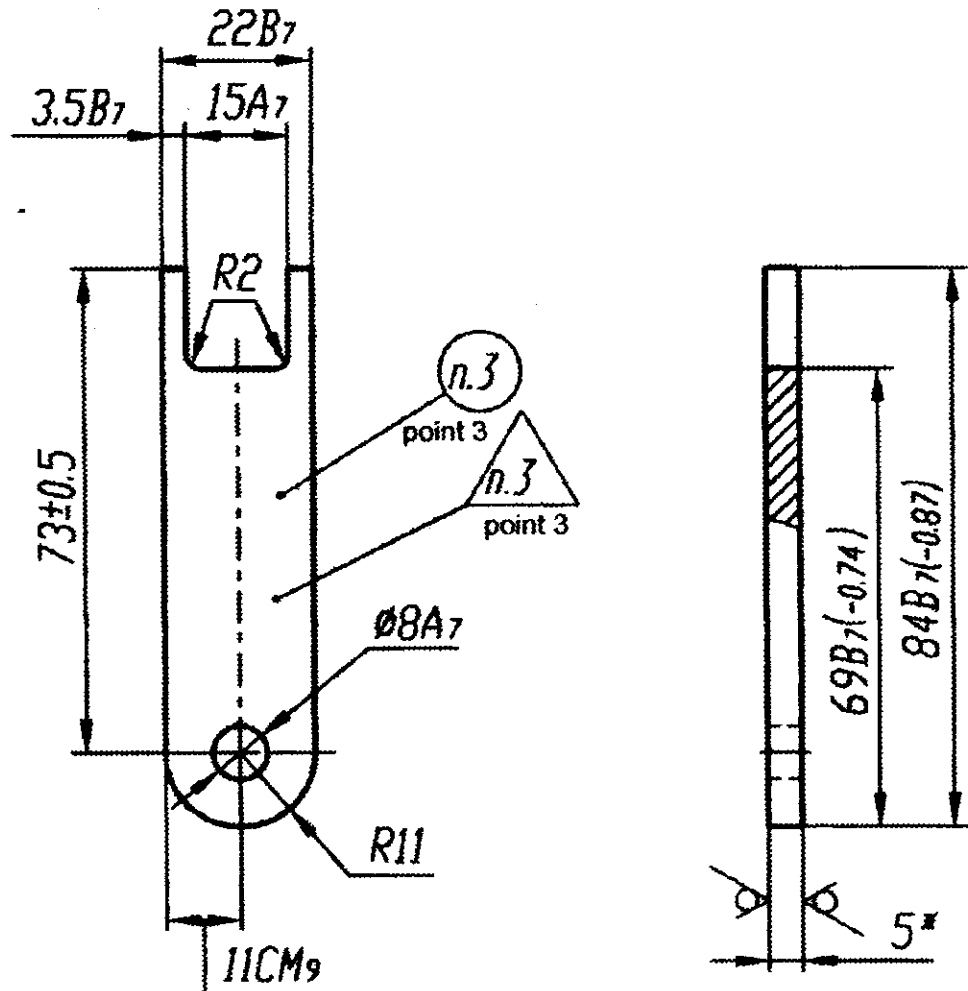
AK-630 Sb 109-4SB

		Type	Mass	Scale
		Лит.	Масса	Масштаб
Изм/Ист. и докум.	Подп. Дата	Валик запирающий	A	0.230 1:1
Разраб.		Сборочный чертёж	Лист	Листов 1
Проб.			Sheet	Total Sheets 1
Т.контр.				
И.контр.				
Утв.				

Bale 8 container 2

AK-630 109-25

Rz80 (✓) (✓)



- 1.* Reference dimension.
- 2. Blunt sharp edges $R \sim 0.6$ mm.
- 3. Mark Ш, Ч and stamp K as per AK-630, AK-630M TU I.

Approved OGMet	Approved TOsb	Approved KTONI	Approved by shop	
Orig. Inv. No.	Alternate Inv. No.	Sign and Date	Reference No.	First use
Dupl. Inv. No.	Sign and Date			
Amend.	Sheet	Doc. No.	Sign	Date
AK-630 109-25				
Lever				
		Type	Weight	Scale
		A	0.050	1:1
			Sheet	Sheets 1
Sheet $B - PN - 5 GOST 19903 - 74$				
35 - 2GOST 1577 - 93				
Approved by				

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AK-630 109-27

Approved OGMet Orig. Inv. No.	Sign and Date	Approved TOsb Alternate Inv. No.	Dupl. Inv. No.	Sign and Date	Approved KTONI	Reference No.	Approved by shop	First use	
<p>1.* Reference dimension. 2. Blunt sharp edges ~0.6 mm. 3. Mark III, 4 and stamp K as per AK-630, AK-630M TU I.</p>									
					AK-630 109-27				
					Handle				
					Type		Weight		Scale
					A		0.060		1:1
					Sheet			Sheets 1	
					Sheet <i>BT - PN - 0 2 GOST 19904 - 90</i>				
					K490V - 4 - III - 35 GOST16523 - 97				

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