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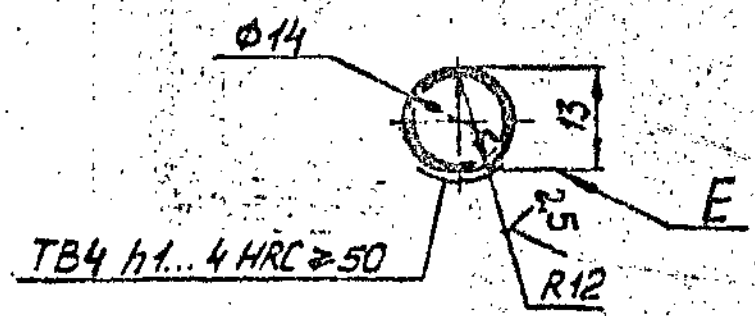
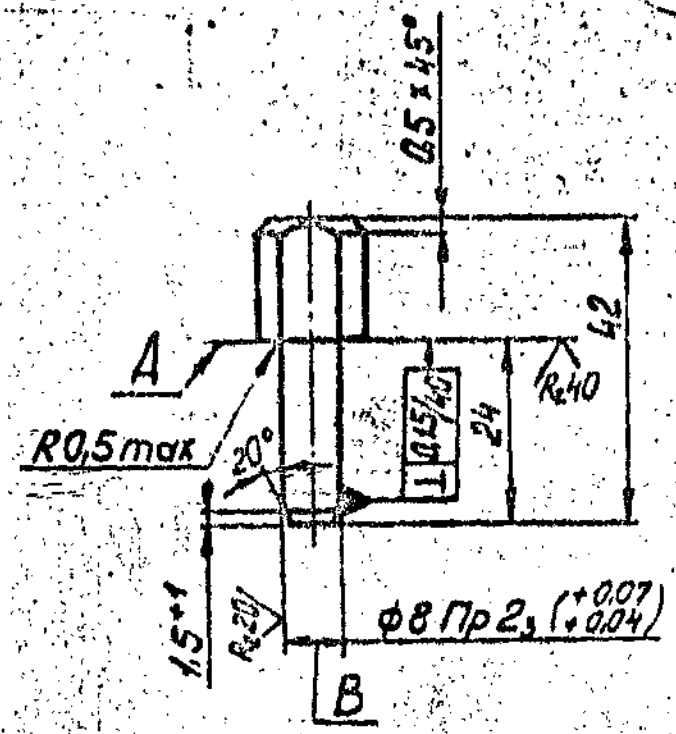
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489-51-02

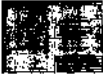
0.87
 (✓) (✓)



1. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS PER FOLLOWS: FOR SHAFTS- AS PER 107.
2. COATING : CHEMICALLY OXIDIZED, OILED.
3. SURFACE E MAY BE PROCESSED IN ASSY 20-15-665-5 OR ASSY 20-15-607-1.
4. WHEN SURFACE A IS FACED A SINGLE-POINT TOOL MAY CUT TO A DEPTH OF NOT MORE THAN 0.3mm AS PER DIAMETER B.
5. PERFORM HEAT-TREATMENT IN ASSY 20-15-607-1.

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

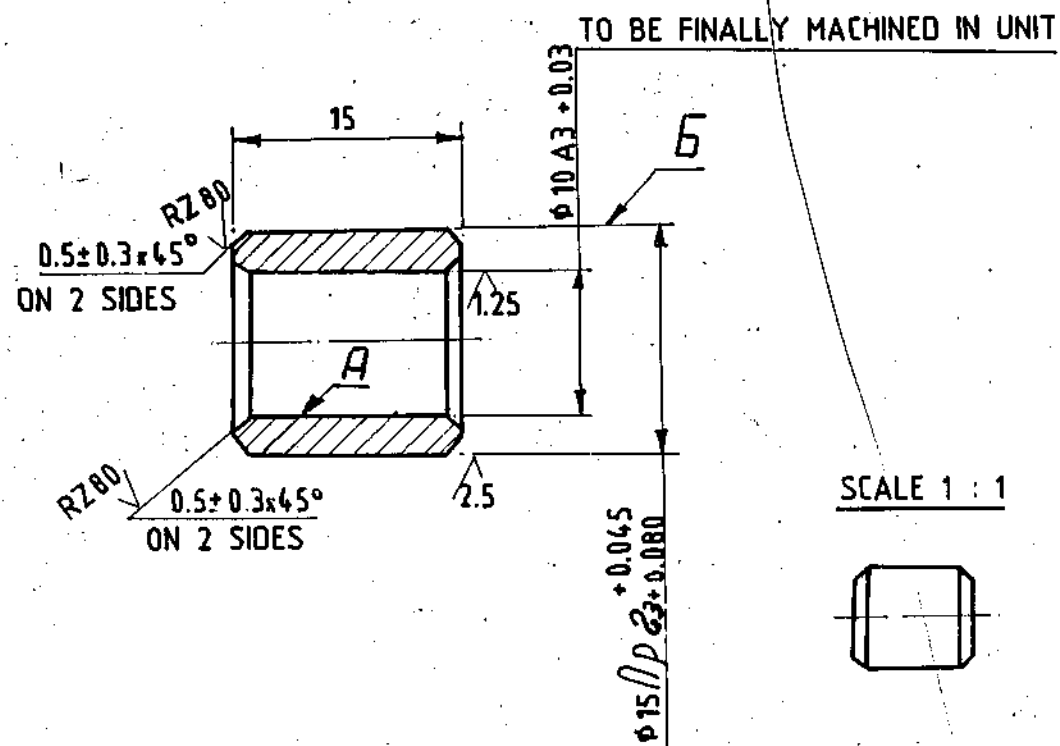
ISSUE	DATE	NATURE OF AMENDMENTS	EST. MASS 0,029 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS (in LETTERS)
DRN		SCALE - 1:1	MATERIAL - 45X GOST 4543-71	USED ON - CB 20-15-607-1
CHKD		DIMENSIONS IN mm	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
APPD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
DATE		ALL THREADS CONFORM TO	TITLE - STOP	D S CAT NUMBER
				DRAWING NUMBER 20-15-604



DRAWING NUMBER

315-636-1

Rz 20 (✓)



1. DIMENSIONS WITH UNSPECIFIED DEVIATIONS SHOULD BE OBTAINED AS PER ACCURACY CLASS 7 OST 1010.
2. RUN-OUT OF SURFACE B RELATIVE TO SURFACE A SHOULD NOT EXCEED 0.05mm.

EXPLANATORY NOTE:

MATERIAL QUOTED: AC 59-1 GOST 15527-70
AC 59-1 GRADE OF BRASS

CHEMICAL COMPOSITION (AS PER GOST 15527-70) %

COPPER : 57.0 - 60.0
LEAD : 0.8 - 1.5
ZINC : REMAINDER

ADMIXTURES

IRON : 0.5 (MAX) ANTIMONY : 0.010 (MAX)
BISMUTH : 0.003 (MAX) PHOSPHORUS : 0.02 (MAX)
TIN : 0.30 (MAX) TOTAL : 0.75 (MAX)

KVD No. 63490

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

EST WT 0.012 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)

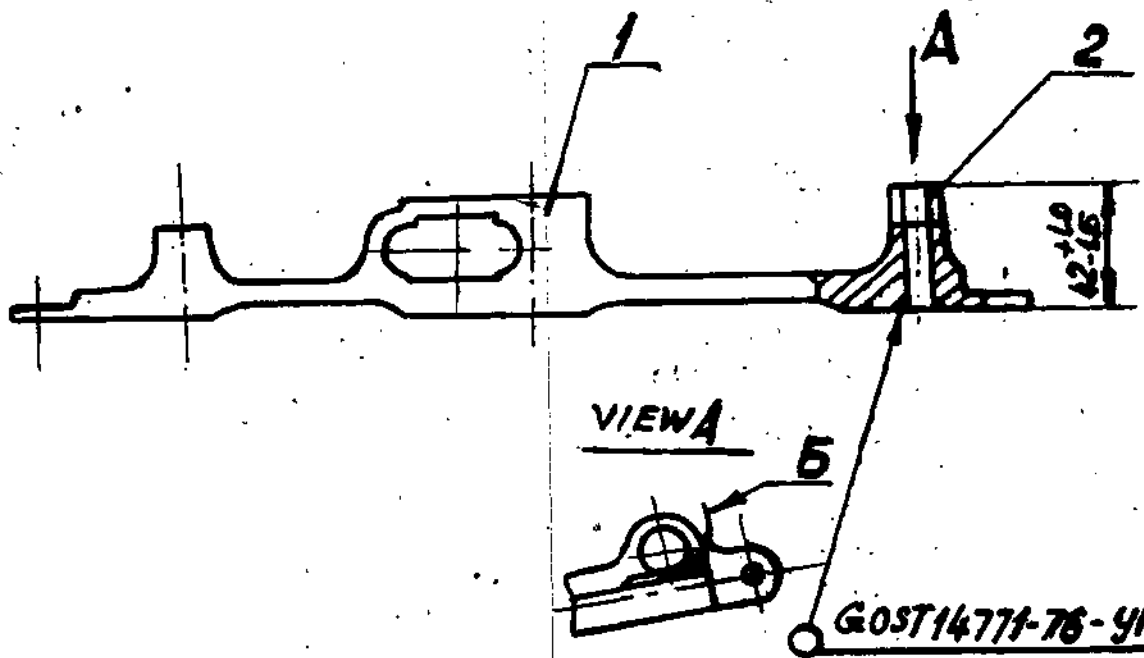
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

DRN	<i>hrc</i>	MATERIAL	BRASS AC 59-1 GOST 15527-70	USED ON: CB 20-15-665-5 CB 315-665
CHD	<i>hrc</i>	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
TCD	<i>hrc</i>			
APPD	<i>hrc</i>	TITLE VARIABLE SPEED GOVERNOR LEVER BUSHING		
DATE	08-5-'86			
SCALE 1 : 1		D S CAT NUMBER		
DIMENSIONS IN mm				
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED		DRAWING NUMBER 315-636-1		
ALL THREADS TO CONFORM TO				
ISSUE	DATE	NATURE OF AMENDMENTS		

A6
SIZE A3



1-109-51-0797



1. SURFACE 5 SHOULD BE LAID AS PER VIEW A.
2. PROJECTION OF THE WELD SHOULD NOT EXCEED 1 mm.
3. HARDNESS AS PER DRAWINGS 20-15-617-5, 20-15-684.

FORMAT	ZONE	REF. NO.	DESIGNATION	DESCRIPTION	QTY.	REMARKS
				PARTS		
		1	20-15-617-5	GOVERNOR LEVER	1	
		2	20-15-684	STOP	1	

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

EST. MASS
0,412 Kg.

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

ISSUE DATE NATURE OF AMENDMENTS

DRN

SCALE 1:2

MATERIAL

USED ON - CB 20-15-665-5

CHKD

DIMENSIONS IN mm

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI

TCD

TOLERANCE ON DIMS
UNLESS OTHERWISE
STATED

TITLE

GOVERNOR LEVER

APPO

ALL THREADS CONFORM
TO

D S CAT NUMBER

DRAWING NUMBER

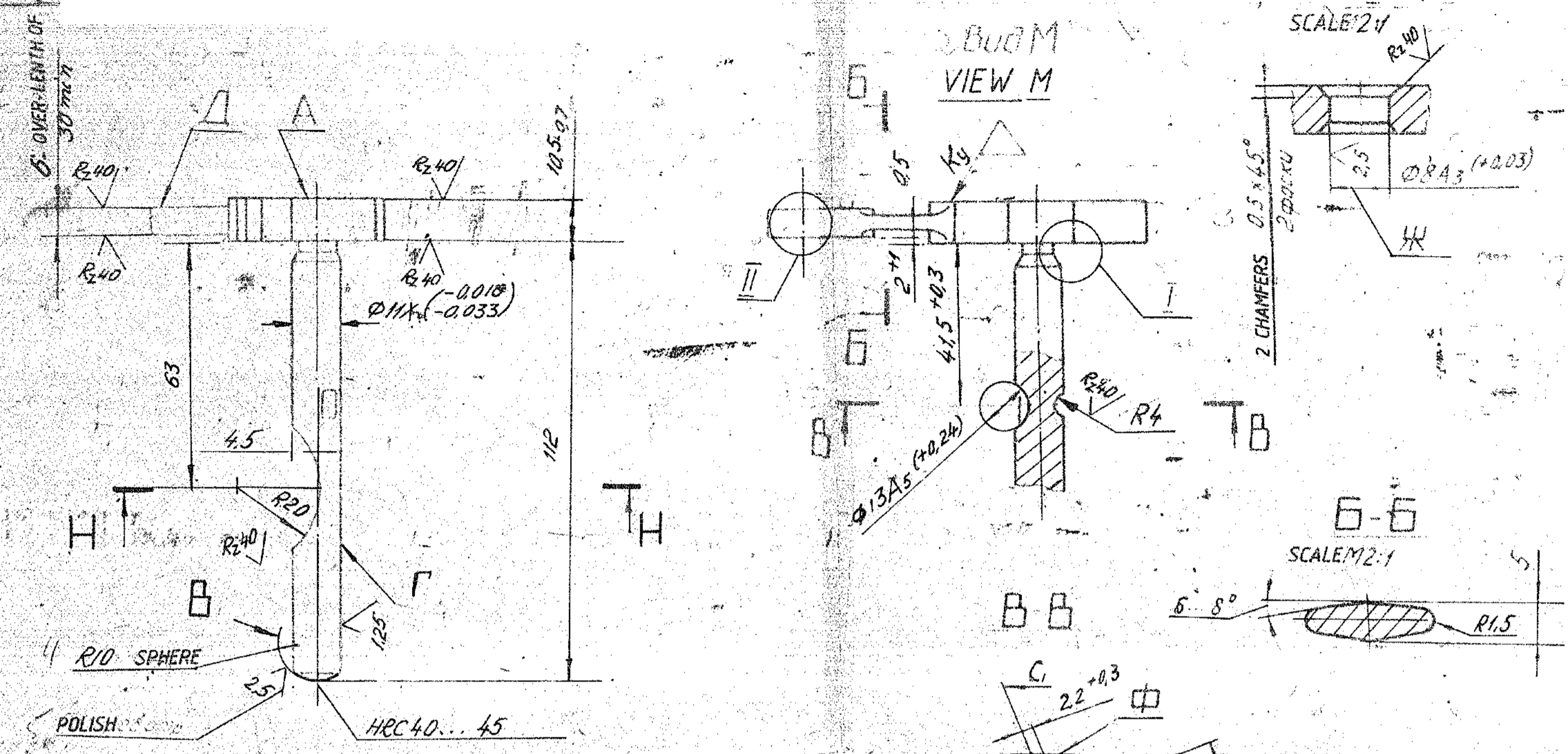
CB 20-15-607-1

DATE

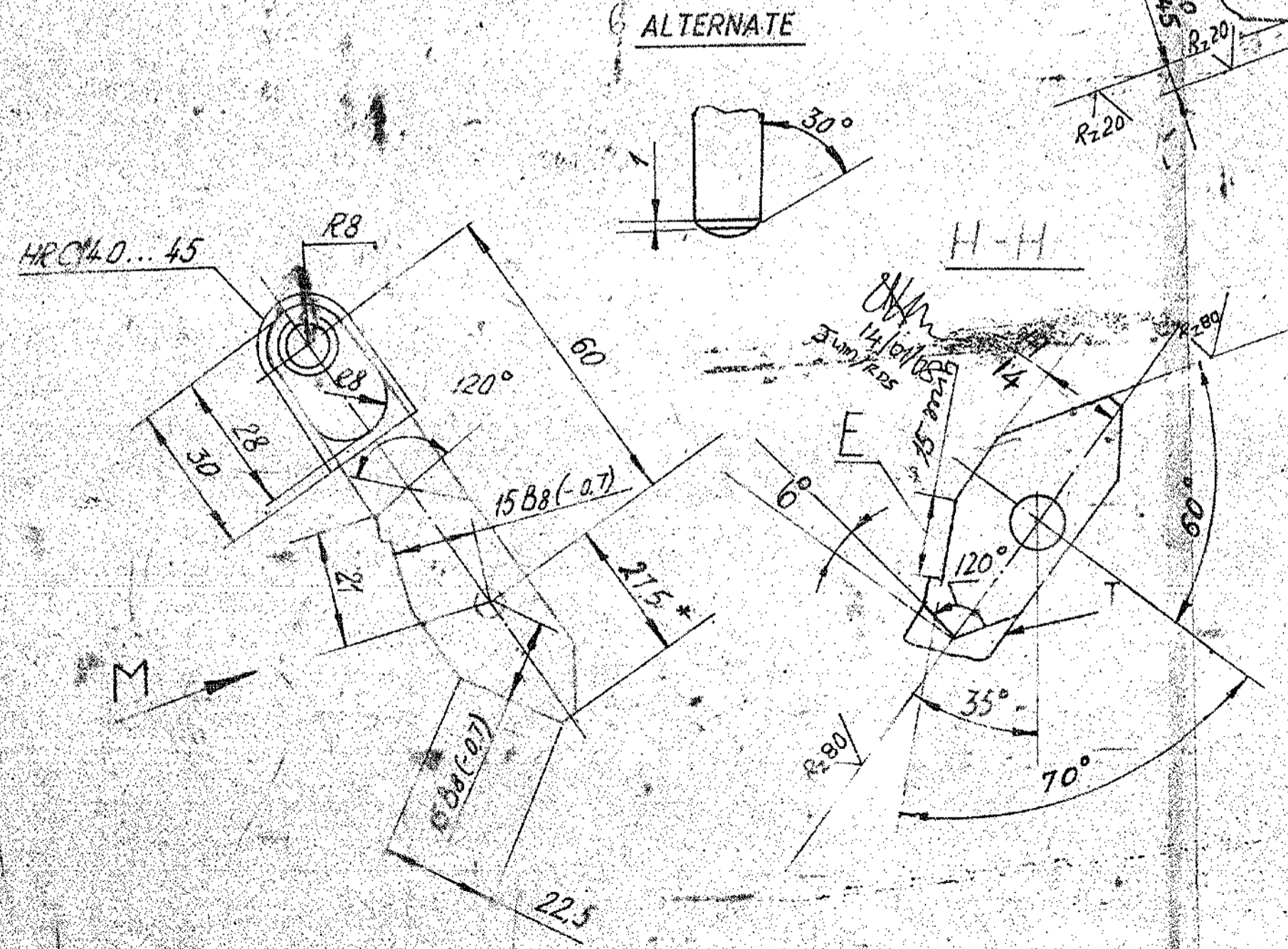
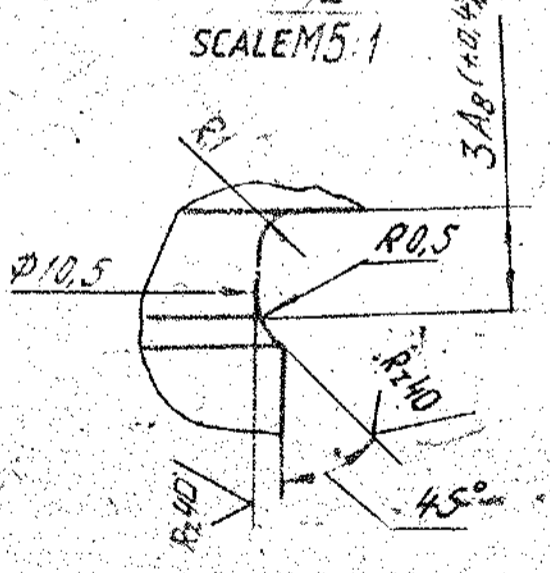
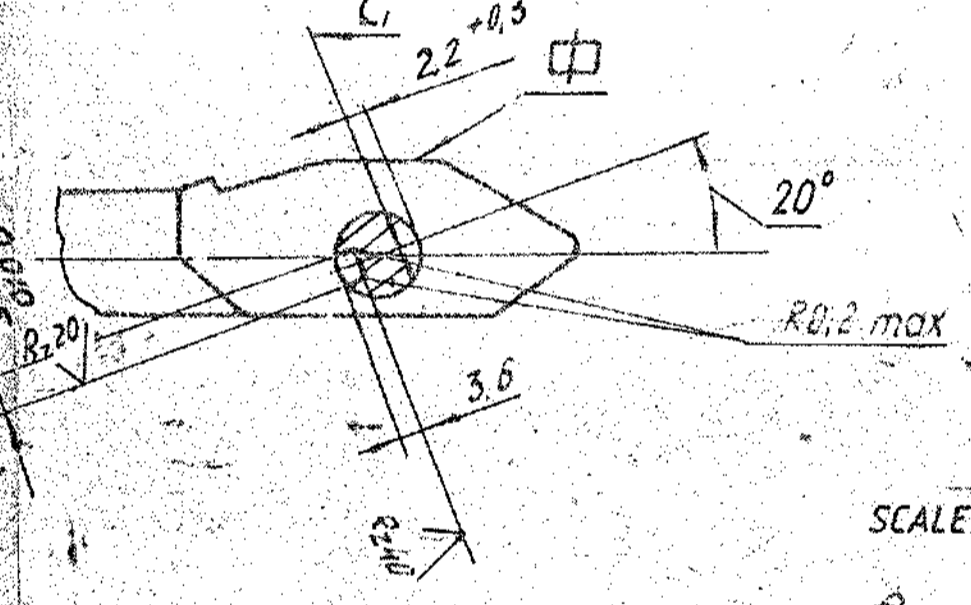
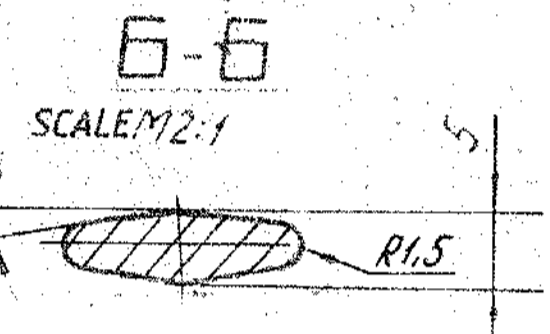
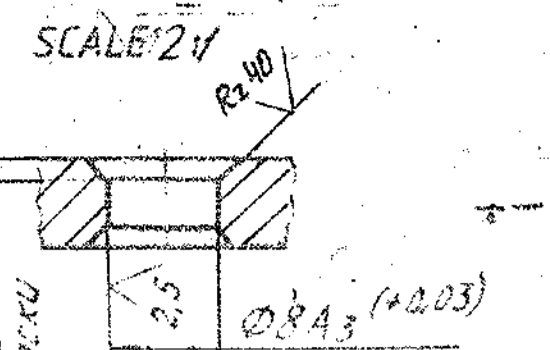
25-04-87







BOOM
VIEW M



ALTERNATE

1. INSPECTION GROUP IV AS PER TECHNICAL REQUIREMENTS TT-11.
2. H B 261 TO 285.
3. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS :-
FOR HOLES - AS PER A7,
SHAFTS - AS PER B7,
OTHERS - AS PER CM7.
4. REQUIREMENTS PLACED UPON STAMPING ARE AS PER GOST 7505-74 AND GOST 8479-70, ACCURACY CLASS 2. UNSPECIFIED STAMPING RADII ARE 1.0 TO 2.0 mm.
5. MISALIGNMENT OF KEYWAY K WITH RESPECT TO THE AXIS OF SURFACE T SHOULD NOT EXCEED 0.1mm (QUANTIFIED TOLERANCE).
6. SURFACE A MAY BE DRESSED AT A DISTANCE OF AT LEAST 8.0 mm FROM THE AXIS OF HOLE X.
7. BUTT-END A MAY HAVE CENTRE HOLE AS GOST 14034-74.
8. LEVER RIB SECTION B-B MAY HAVE THINNING OR THICKENING WITHIN THE LIMITS OF ±1.0 mm.
9. CUTTING INTO THE RIB IS NOT PERMITTED WHEN SURFACE E IS MACHINED.
10. COATING : ZINC-PLATED, 6 MICRONS THICK, GILD NO COATING SURFACES T AND X OF SPHERE B, K, T, C, IS PERMITTED. LOCAL DAMAGE TO THE COATING IS ALLOWED WHEN THE PART IS CLAMPED IN FIXTURES.

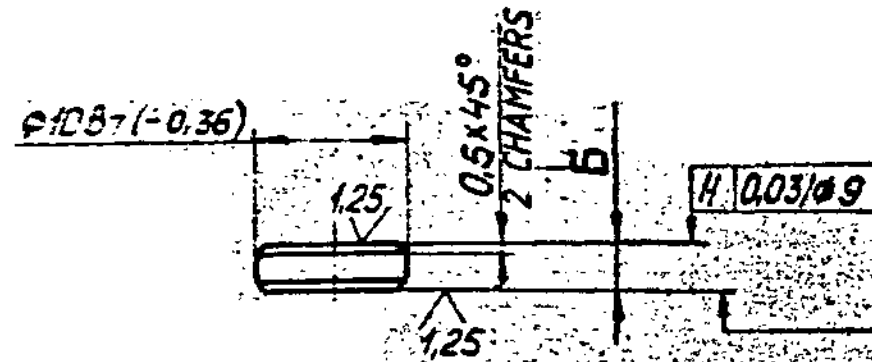
45X GOST 4543-71

PILOT SAMPLE SHOULD BE APPROVED BY THE CUSTOMER BEFORE BULK PRODUCTION			
EST. MASS	0.18 Kg	TO BE STAMPED OR MARKED WITH INDICATED THIS MASS	LETTERS:
ALL SHARP EDGES AND CORNERS TO BE PERKED UNLESS OTHERWISE STATED. CHAMFERED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.			
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL	USED ON
		* SEE ABOVE	CB 20-15-663-A
SCALE	1:1	CONTROLLER	DATE OF INSPECTION (HEAVY V. INDICES) (A. V. D.)
CHD	DIMENSIONS IN mm	TITLE	SHAFT WITH LEVER
TCD	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED	D'S CAT NUMBER	DRAWING NUMBER
APPD	ALL DIMENSIONS CONFORM TO GOST 20-15-640-1		

DRAWING NUMBER
20-15-649

Rz 40/11

SERIAL NO.	DIMENSION
1	15 ± 0.05
2	2 ± 0.05
3	2.5 ± 0.05
4	3 ± 0.05



EXPLANATORY NOTE:

Material Quoted: 45 X GOST 4543-71

45x: grade of steel.

Chemical composition:

C	Si	Mn	Cr	P	S	Cu	Ni
0.41-	0.17-	0.50-	0.80-	MAXIMUM			
0.49	0.37	0.80	1.10	0.035	0.035	0.30	0.30

Mechanical Properties:

yield point kgf/mm² (min) = 85

ultimate strength kgf/mm² (min) = 105

Relative elongation % (min) = 9

Relative reduction along cross section % (min) = 45

Impact strength kgf·m/cm² = 5

1. INSPECTION GROUP IV AS PER TECHNICAL REQUIREMENTS TT-11

2. HRC 33 TO 37

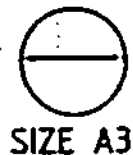
KVD NO 63459

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

EST. WT. 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 INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

DRN	<i>J. Denny</i>	MATERIAL:-	45 GOST 4543-71	USED ON	CB 20-15-663-4
CHD	<i>S. Denny</i>				
TCO	<i>G. N. D.</i>				
APPD	<i>S. F.</i>				
DATE	25.4.87	CONTROLLER OF QUALITY ASSURANCE (HEAVY VEHICLES)			
SCALE:-	2:1	AVADI			
DIMENSIONS IN mm		TITLE		SUPPORT	
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: 2102-69		D S CAT NUMBER		DRAWING NUMBER	
ALL THREADS TO CONFORM TO				20-15-649	
ISSUE DATE	NATURE OF AMENDMENTS				



SIZE A3

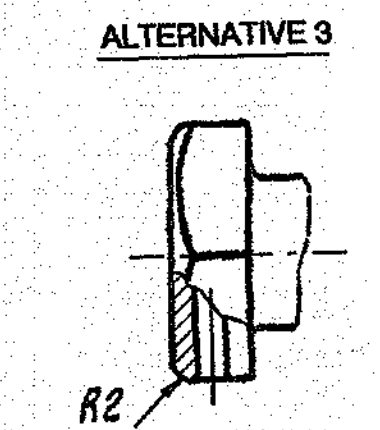
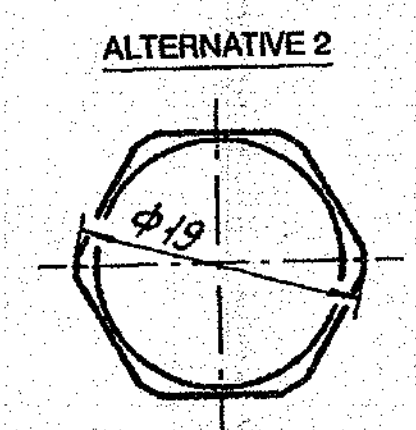
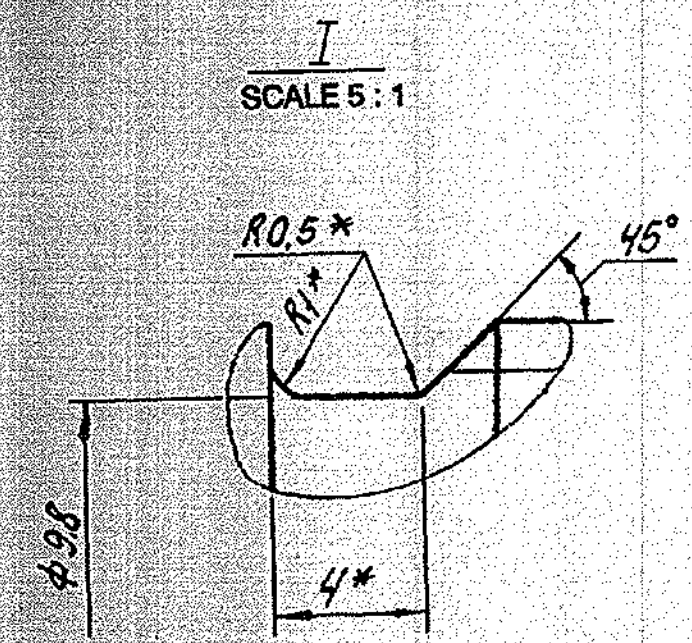
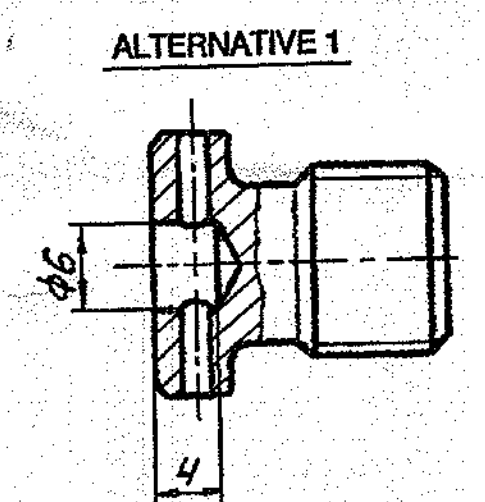
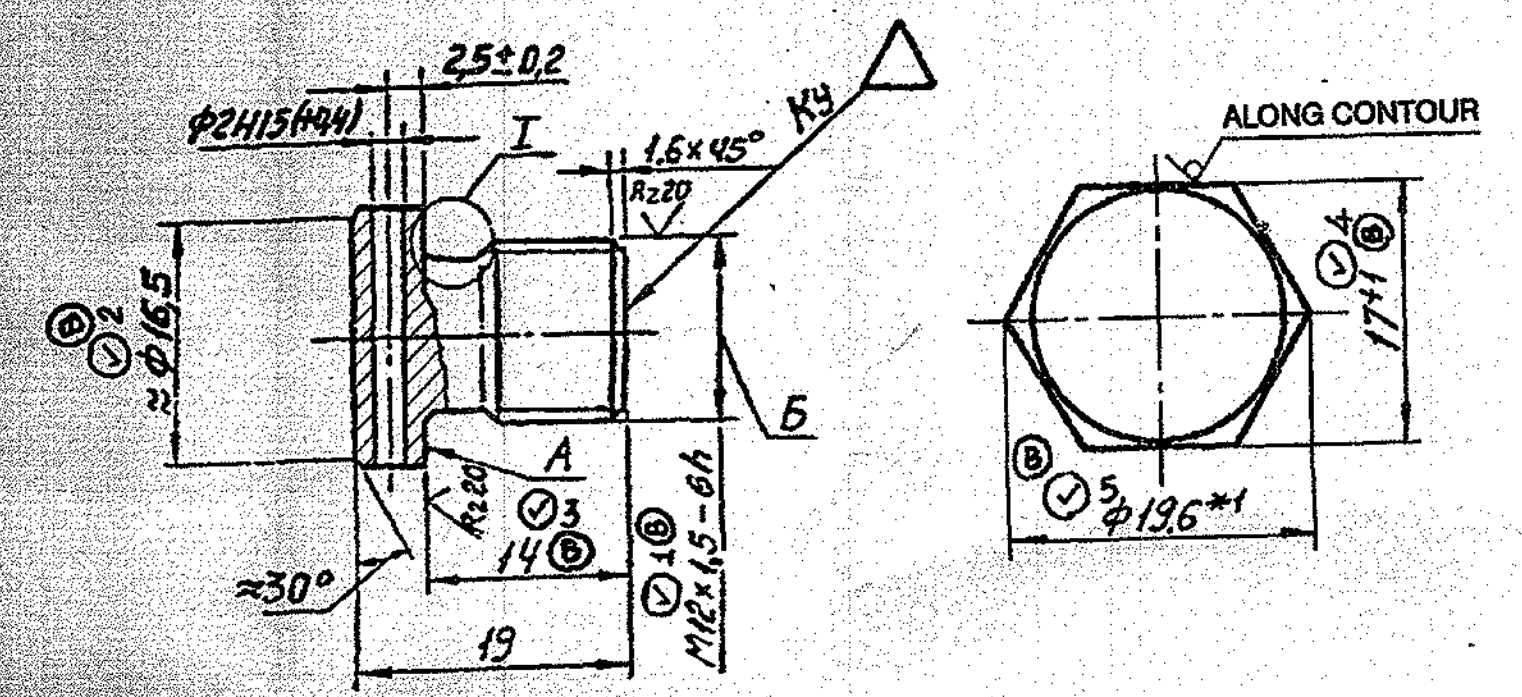


R280

DRAWING NUMBER
301-101

ECKD

N. SARAVANAN
SSC
Dt. 20 Jul 2019



EXPLANATORY NOTE:-

MATERIAL QUOTED:- HEXAGONAL BAR 17-5 GOST 8560-78.
45 GOST 1051-73.

ALTERNATE MATERIAL QUOTED:- 40 & 50 GOST 1050-74.

BRIGHT STEEL HEXAGONAL FROM GRADES 40, 45 & 50 STEEL WITH ACROSS FLATS 17mm OF ACCURACY CLASS-5.

CHEMICAL COMPOSITION:-

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C	Si	Mn	Cr	P	S	Cu	Ni
40	0.37-0.45	0.17-0.37	0.50-0.80	0.25	0.035	0.040	0.25	0.25
45	0.42-0.50	0.17-0.37	0.50-0.80	0.25	0.035	0.040	0.25	0.25
50	0.47-0.55	0.17-0.37	0.50-0.80	0.25	0.035	0.040	0.25	0.25

MECHANICAL PROPERTIES:-

GRADE OF STEEL	TENSILE STRENGTH kgf/mm ²	YIELD POINT kgf/mm ²	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH kgf/cm ²
40	MINIMUM				
	58	34	19	45	6
45	61	36	16	40	5
50	64	38	14	40	4

REPAIR SIZE DIMENSIONS ARE ADDED WHERE INDICATED THUS

TABLE -1

Sl.No.	R	REMARKS
1	M14 X 1.5 - 6h	1. ALL OTHER CONDITIONS AS PER STD. DRG. 2. MARK REPAIR SIZE.
2	φ 18.5	
3	14 ± 0.1	
4	A/F 19 ^{-0.14}	
5	A/C φ 21	

- ALTERNATE MATERIAL : STEEL 40 AND 50 OF GOST 1050-74.
- UN SPECIFIED MAXIMUM DEVIATIONS OF DIMENSIONS : FOR HOLES - AS PER H 14, FOR SHAFTS AS PER h14, THE REMAINING ± IT 15/2
- END PLAY ON SURFACE 'A' RELATIVE TO THE AXIS OF THREAD 'B' SHOULD NOT EXCEED 0.1mm.
- COATING : Cd 9 Cr. AS PER I.I.I.I - 104 WITH HYDROGEN EMBRITTEMENT REMOVED.
- THREAD SHOULD BE FORMED BY ROLLING, IT MAY ALSO BE FORMED BY CUTTING.
- BOLT HEAD MAY BE MADE BY UPSETTING.
- MARKING MAY BE DONE ON A TAG FOR A BATCH OF COMPONENTS, WITH PACKING AND SEALING.
- * DIMENSIONS TO BE ENSURED BY TOOL.
- * 1 DIMENSIONS FOR REFERENCE.
- REPAIR SIZE DIMENSIONS ADDED BASED ON LETTER NO. 82847/OH/QAS/ED. DT.27 MAR 95 AS PER TABLE - 1.

COMMON TO LTD-20, V46-6 & V82S2 DRG. RE-INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - NIL

SIZE A3x3

CB 327-00-73
CB 327-00-47-01 (E)
COA(HV)5.06.607E (D)
Cb20-06-00-2
Cb 327-00-45
Cb 3329-00-11.13 (A)
Cb 3338-401-10

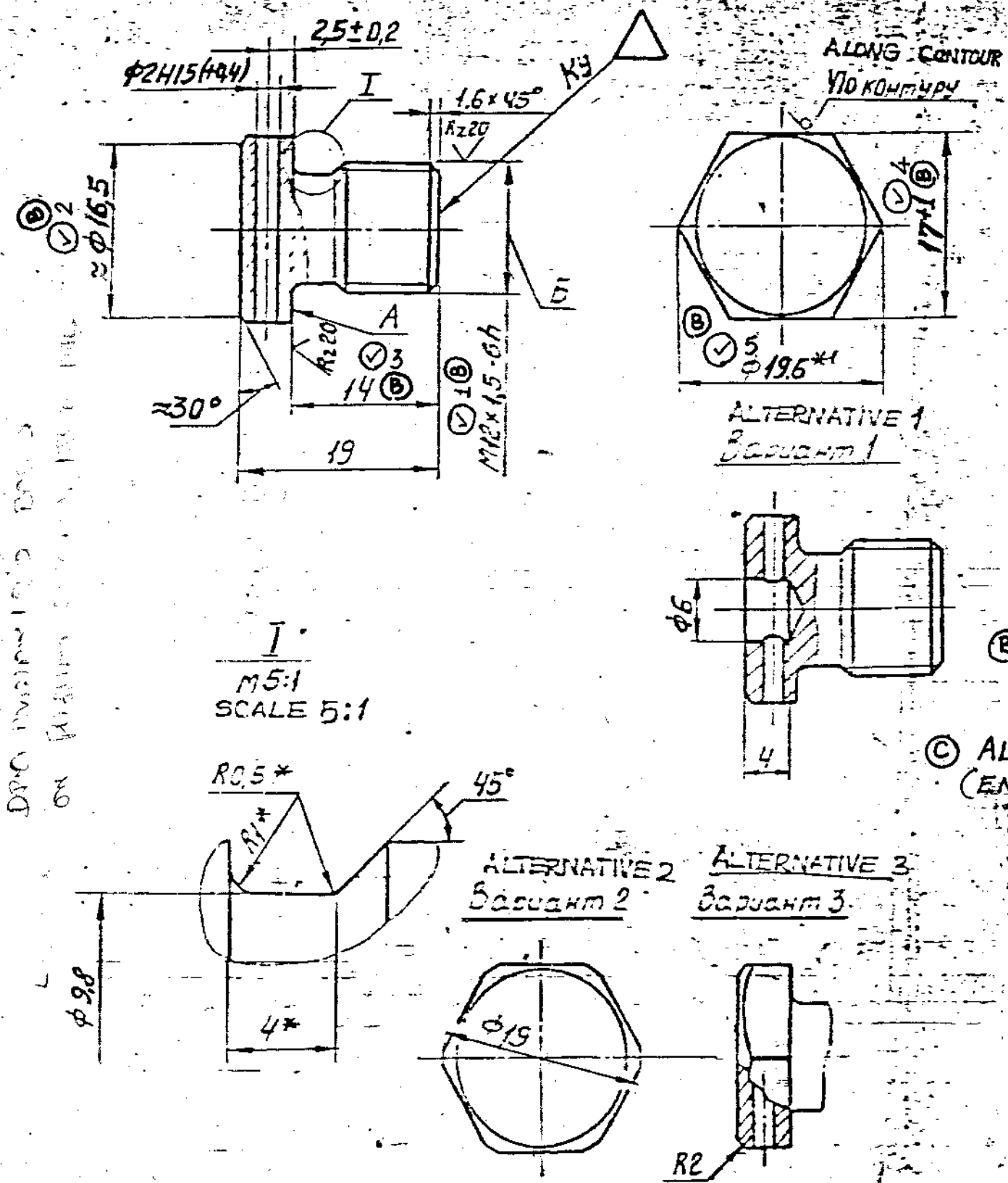
ALTERNATE MATERIAL : STEEL 080M40 (EN 8) TO BS : 970. P11 - 1983 OR 45C8 TO IS : 1570.

PILOT SAMPLE SHOULD BE APPROVED BEFORE BULK PRODUCTION.

EST. WT (kg)	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)
0.02 Kg	

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	Sd/-	MATERIAL:-	USED ON:-
CHD	Sd/-	17.5 GOST 8560-78	Cb 406-13-32
APPD	Sd/-	HEXAGON	CB 406-12-21 Cb 20-15-663-4
DATE	07.04.88	45 GOST 1051-73	
		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
E	27.19	SCALE:- 2:1	TITLE:- PLUG
D	15.7.15	USED ON NUMBER ADDED.	
C	09.6.09	PL11 of 7th Alt.Comm. Meeting Dt. 11-4-12.	
B	20.5.98	3 rd ALTN.COMM.MINUTES POINT 8. DT.27.2.09	
A	15.2.88	REPAIR SIZES ADDED AUTHY.No.BK.81-406	
ISSUE	DATE	NATURE OF AMENDMENTS	D S CAT NUMBER
			DRAWING NUMBER 301-101



1. ALTERNATE MATERIAL : STEEL 40 AND 50 OF GOST 1050-74.
2. UNSPECIFIED MAXIMUM DEVIATIONS OF DIMENSIONS :
FOR HOLES - AS PER H 14, FOR SHAFTS AS PER h 14, THE
REMAINING ± IT 15
2
3. END PLAY ON SURFACE 'A' RELATIVE TO THE AXIS OF THREAD B SHOULD NOT EXCEED 0.1 mm.
5. COATING : Cd 9 Cr. AS PER UG-104 WITH HYDROGEN EMBRITTEMENT REMOVED.
6. THREAD SHOULD BE FORMED BY ROLLING, IT MAY ALSO BE FORMED BY CUTTING.
7. BOLT HEAD MAY BE MADE BY UPSETTING.
8. MARKING MAY BE DONE ON A TAG FOR A BATCH OF COMPONENTS, WITH PACKING AND SEALING.
9. * DIMENSIONS TO BE ENSURED BY TOOL.
10. *1 DIMENSIONS FOR REFERENCE.
12. REPAIR-SIZE DIMENSIONS ADDED BASED ON LETTER NO. 82847/DH/QAS/ED DT. 27 MAR 95 AS PER TABLE -1.

*** HEXAGON 17-5 GOST 8560-78 CQA(HV)5.06.607E (D)
45 GOST 1051-73 CB20-06-00-2
CB 327-00-45
CB 3329-00-7K13 (A)
CB 3338-401-10
CB 20-06-00-2

(EN 8) TO BS: 970. Pt I-1983 OR 45CB TO IS: 1570

PLUG SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

D	15-7-85	Pl. 11 of 7th Alt. Comm. Meeting Dt. 11-4-12.	EST. MASS 0.02 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS * (LETTERS)
C	9/09	3 rd ALTN. COMM. MINUTES POINT @ DT 27-2-09		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R* OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE
B	20-5-96	REPAIR SIZES ADDED		
A	15-2-88	AUTHY. NO. BK. 81-406		
ISSUE DATE	NATURE OF AMENDMENTS		MATERIAL * SEE ABOVE	USED ON- CB 406-15-32 CB 406-17-71 CB 20-15-60-4
DRYD	SCALE: 2:1		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
CHKD	DIMENSIONS IN mm			
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED		TITLE PLUG	
APPD				
DATE 7-4-88	ALL THREADS TO CONFORM TO		D/S CAT NUMBER	DRAWING NUMBER 301-101

EXPLANATORY NOTE:-

MATERIAL QUOTED:- HEXAGONAL BAR 17-5 GOST 8560-78
45 GOST 1051-73.

ALTERNATE MATERIAL QUOTED:- 40 & 50 GOST 1050-74.

BRIGHT STEEL HEXAGONAL FROM GRADES 40, 45 & 50 STEEL WITH
ACROSS FLATS 17mm OF ACCURACY CLASS-5.

CHEMICAL COMPOSITION:-

GRADE OF STEEL	CONTENT OF ELEMENTS %							
	C	Si	Mn	Cr	P	S	Cu	Ni
	MAXIMUM							
40	0.37-0.45	0.17-0.37	0.50-0.80	0.25	0.035	0.040	0.25	0.25
45	0.42-0.50	0.17-0.37	0.50-0.80	0.25	0.035	0.040	0.25	0.25
50	0.47-0.55	0.17-0.37	0.50-0.80	0.25	0.035	0.040	0.25	0.25

MECHANICAL PROPERTIES:-

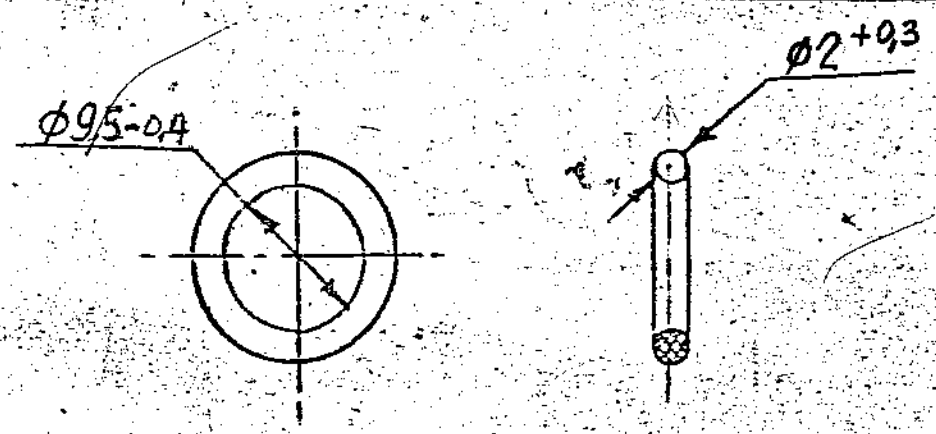
GRADE OF STEEL	TENSILE STRENGTH Kgf/mm ²	YIELD POINT Kgf/mm ²	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH Kgf/cm ²
	MINIMUM				
40	58	34	19	45	6
45	61	36	16	40	5
50	64	38	14	40	4

REPAIR SIZE DIMENSIONS ARE ADDED WHERE INDICATED THIS (D)
TABLE -1

SL. NO.	R	REMARKS
(D) 1	M14 X 1.5 - 6h	1. ALL OTHER CONDITIONS AS PER STD. DRG. 2. MARK REPAIR SIZE.
(D) 2	φ 18.5	
(D) 3	14 ± 0.1	
(D) 4	A/F 19 - 0.14	
(D) 5	A/C φ 21	



DRAWING NUMBER
301-161 A



1. * DIMENSIONS ARE PROVIDED WITH TOLS.
2. APPLY MARKING ONTO THE LABEL
3. FOR TROPICAL VERSION - T III H 100 GOST 15152-59
4. OTHER REQUIREMENTS ARE AS PER TECHNICAL SPECIFICATIONS
TY 005216-75 FOR ARTIC-LES CODE 253111 HPI

EXPLANATORY NOTE :-

5. MATERIAL QUOTED : RUBBER B14 TY 005 216-75.
B14 = RUBBER GRADE.
PHYSICAL AND MECHANICAL PROPERTIES :
 1. RUPTURE STRENGTH Kgf/cm^2 (min) = 90
 2. ELONGATION OF RUPTURE % (min) = 160
 3. RESIDUAL ELONGATION AFTER RUPTURE % max = 8
 4. HARDNESS ACCORDING TYP DEVICE (min) ARBITRARY UNIT % = 70 - 80
 5. CO-EFFICIENT OF POST RESISTANCE ACCORDING TO THE } TEMPERATURE °C = -45
PLASTICITY RESTORATION (min) } TIME MINUTES = 0.15
 6. BRITTLENESS TEMPERATURE AT FREEZING °C (max) = -50
 7. CO-EFFICIENT OF HEAT AGEING IN THE OPEN AIR (min)
TEMPERATURE °C = 90 - 70
TIME IN MINUTES = 95 - 144
AS PER ELONGATION = 60
 8. TECHNICAL PROPERTIES OF RUBBER MIX (Ref) = MOULDING EXTRUSION

KVD NO. 66792 COMMON TO V-92S2 & UTD-20 ENGINES

(A) ALT. MATL.: RUBBER GRADE N3 TO SPECN. CQA(HV)/NBR

Cb 3308-00-23
Cb 3301-00-44
* Cb 312-03-2 (B)
Cb 20-08-00-7

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

EST. WT. TO BE STAMPED OR MARKED WHERE 50 WM PIECES INDICATED THIS \equiv (LETTERS)
0.005 Kg

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

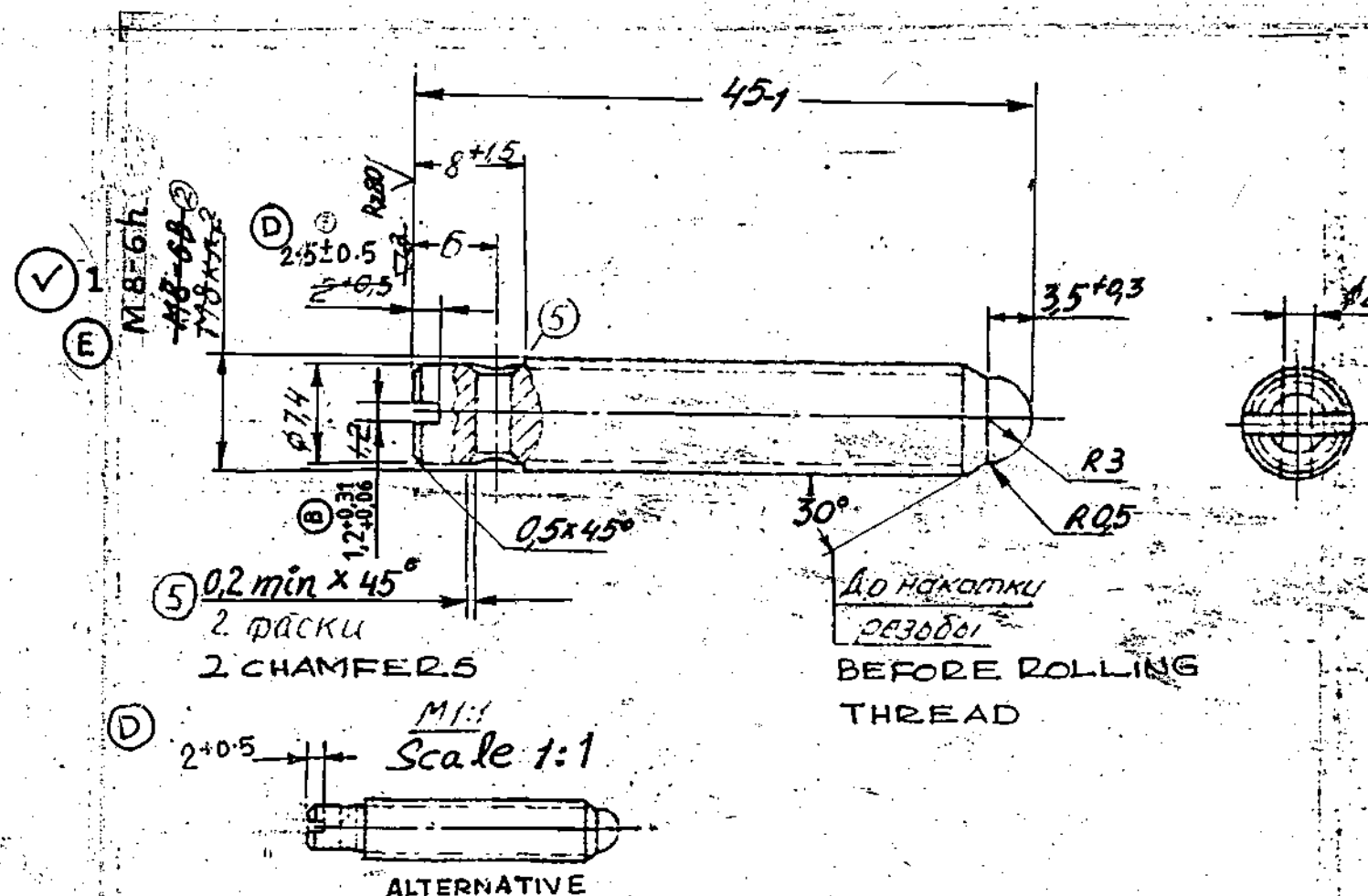
DRN	1 KYP	MATERIAL:-RUBBER B-14	USED ON Cb 312-03-5
DES	15	TY 005-216-75	Cb 3301-00-37
ITD	10/08/90		Cb 20-13-00-9 *
IAPPD		CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES)	
IDATE	9-1-90		
ISCALE	2:1		
DIMENSIONS IN mm			
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS:2102-59			
B 19-9-08	USED ON NUMBER ADDED		
A 22.05.08	Lt. No. TC/GEN/IND-III Dt. 02.04.08		
ISSUE DATE	NATURE OF AMENDMENTS		

TITLE
RING

D S CAT NUMBER
DRAWING NUMBER
301-161 A

(A2)
SIZE A3





1. Inspection group III, TT-11
2. Casehardening by cyaniding to a depth of 0.10 to 0.25 mm. HRC ≥ 40 ; to be checked with hardness-test file.
3. Dimensions with unspecified tolerances should be made as per accuracy class 7 OST 1010.
4. Technical requirements for thread as per standard 82021-00
5. During cutting the slot for screwdriver, radius $R \geq 25$ mm. from cutter is allowed.
6. There may be no coating on the internal surfaces. Coating Zn-3Cr should be as per instruction УЛ 483-82.
Coating: Cd 9 chromating as per instructions УЛ 563-84
УЛ 104 with elimination of hydrogen embrittlement.
7. Dimensions are to be calibrated before coating.

1. Группа контроля III по ТТ-11
2. Цианировать на глубину 0,10-0,25 мм. HRC ≥ 40 , проверить твердостью
3. Размеры без допусков выполнять по 7 классу точности OST 1010.
4. Технические требования на резьбу выполнять по нормам 82021-00.
5. При прорезке паза под отвертку допускается оставление радиуса фрезы $R \geq 25$ мм.
6. Цинковать и пассивировать по УЛ 154. Толщина слоя покрытия 0,003-0,006 мм. На внутренних поверхностях допускается отсутствие покрытия.
7. Размеры контролировать до покрытия.
8. Покрытие Zn-3Cr по УЛ 483-82.
9. В технологическом исполнении покрытие Cd 9 хр. по УЛ 563-84 с удалением водородной хрупкости.

EXPLANATORY NOTE :-

8. MATERIAL QUOTED : STEEL 10-GOST 1050-74.
STEEL 10 = GRADE OF STEEL.

a) CHEMICAL COMPOSITION :

CARBON = 0.07 - 0.14
SILICON = 0.17 - 0.37
MANGANESE = 0.35 - 0.65
CHROMIUM = 0.15 (max)
PHOSPHORUS = 0.035 (max)
SULPHUR = 0.040 (max)
COPPER = 0.25 (max)
NICKEL = 0.25 (max)

b) MECHANICAL PROPERTIES :

TENSILE STRENGTH Kgf/mm² (min) = 34
YIELD POINT Kgf/mm² (min) = 21
% ELONGATION = 31 (min)
% REDUCTION IN AREA = 55 (min)

9. REPAIR SIZE DIMENSION ARE ADDED BASED ON LETTER NO: 22347/01/QAS/ED DT 27 MAR 95, WHERE INDICATED THUS \odot AS FOLLOWS.

Sl.No	R	REMARKS
1	M 10 x 6 h	ALL OTHER CONDITIONS AS PER STD DRG. MARK REPAIR SIZE

KVD No. 78511

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

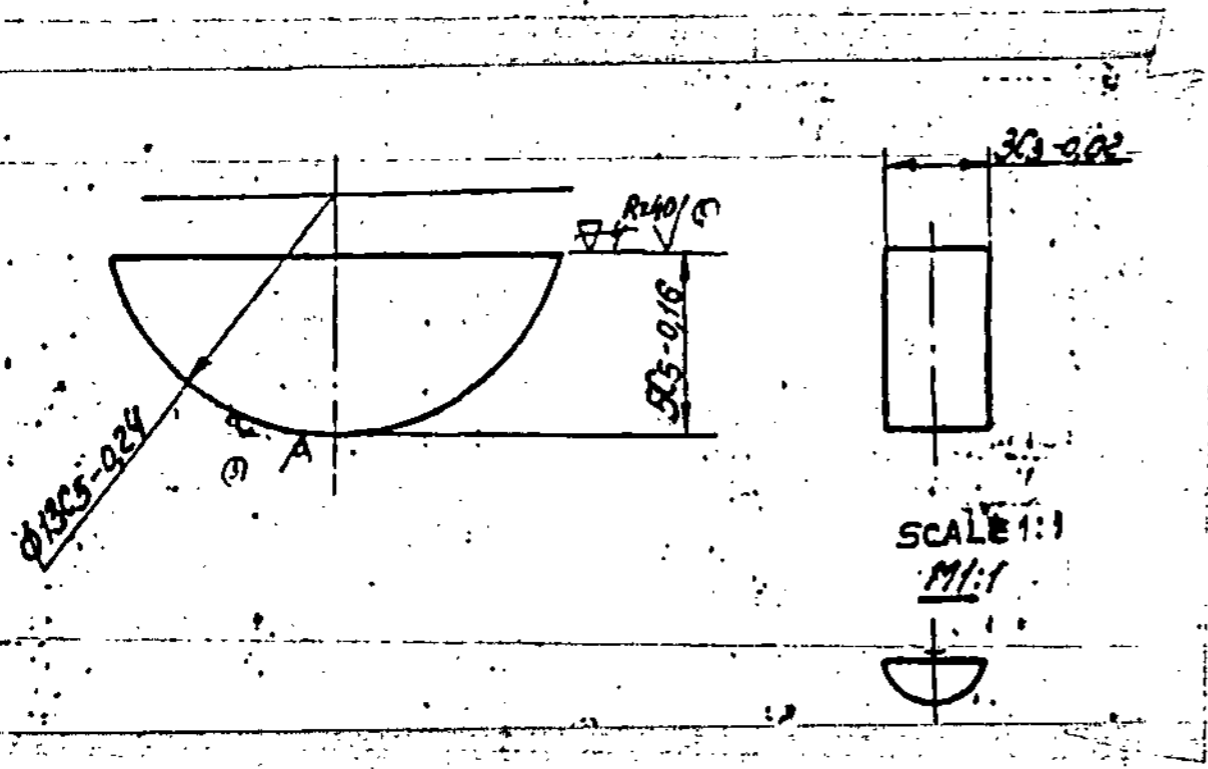
EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)
0.012 Kg	

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.	DRN	MATERIAL :-	USED ON:-
				09-5-86	2:1				STEEL 10 GOST 1050-74	CB 315 663 21 CB 20-15-663-4
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI								TITLE:-		
								LIMITER SCREW		
D S CAT NUMBER								DRAWING NUMBER		
								315 49		
ISSUE	DATE	NATURE OF AMENDMENTS								



DRAWING NUMBER
315-64



EXPLANATORY NOTE :-

MATERIAL QUOTED : 13-4 GOST 7417-75
45 GOST 1051-73

SIZED COLD DRAWN STEEL

13 = DIAMETER IN mm.

4 = CLASS OF ACCURACY (-0.120)

45 = SIZED STEEL GRADE AS PER GOST 1051-73

a) CHEMICAL COMPOSITION : (AS PER GOST 1050-74.)

CARBON = 0.42 - 0.50

SILICON = 0.17 - 0.37

MANGANESE = 0.50 - 0.80

CHROMIUM = 0.25 (max)

SULPHUR = 0.040 (max)

PHOSPHORUS = 0.035 (max)

COPPER = 0.25 (max)

NICKEL = 0.25 (max)

b) MECHANICAL PROPERTIES :

TENSILE STRENGTH Kgf/mm² = 61 (min)

YIELD POINT Kgf/mm² = 36 (min)

ELONGATION % = 16 (min)

REDUCTION IN AREA % = 40 (min)

1. INSPECTION GROUP IV TT-11.
2. ~~HRC 20-28~~ HRC 26-32
3. COATING : COATING OXIDIZING OIL FINISHING.
4. SHARP EDGES ARE NOT ALLOWED.

KVD NO 78512 & 63484

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

EST. WT. 0.001 Kg 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:- 1:5	DIMENSIONS IN mm	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS:2102-69	ALL THREADS TO CONFORM TO	MATERIAL:- ROUND BAR 13-4 GOST 7417-75 45 GOST 1051-73	USED ON: C6 20-15-663-4 C6 315-663-21
									CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES) AVADI	
TITLE SEMI CIRCULAR KEY 3X5								D S CAT NUMBER		DRAWING NUMBER 315-64
A		23-11-87		AUTHY BK-82-394.		ISSUE DATE		NATURE OF AMENDMENTS		

A-6
SIZE A3



DRAWING NUMBER

315-639-1

EXPLANATORY NOTE:-

MATERIAL QUOTED : 10-BH-2-HO-15 GOST 503 - 71. STEEL STRIP

ALT. MATERIAL QUOTED : STEEL A 15 GOST 19904-74
II - BF - 08KП GOST 9045-80.

LOW CARBON STEEL, COLD ROLLED STRIPS.

- 10 = GRADE OF MATERIAL TO GOST 1050-74.
- BH = HIGHLY COLD WORKED.
- 2 = SURFACE QUALITY GROUP TO GOST 503 - 71.
- HO = UN-TRIMMED EDGES.
- 15 = THICKNESS IN mm.
- A = HIGH ACCURACY OF ROLLING TO GOST 19904-74.
- II = HIGH SURFACE FINISH TO GOST 9045-80.
- BF = EXTREMELY DEEP DRAWN.
- 08KП = GRADE OF MATERIAL TO GOST 9045-80.

a) CHEMICAL COMPOSITION % AS PER GOST 1050-74.

GRADE	C	Si	Mn	Cr	P		S		Cu	Ni
				M	A	X	I	M	U	M
10	0.07 - 0.14	0.17 - 0.37	0.35 - 0.65	0.15	0.035		0.040		0.25	0.25

b) MECHANICAL PROPERTIES.

GRADE	ULTIMATE TENSILE STRENGTH Kg f/m ² (Min)	YIELD POINT Kgf/mm ² (Min)	PERCENTAGE ELONGATION % (Min)	HARDNESS B H N (Max)
10	35	21	24	137

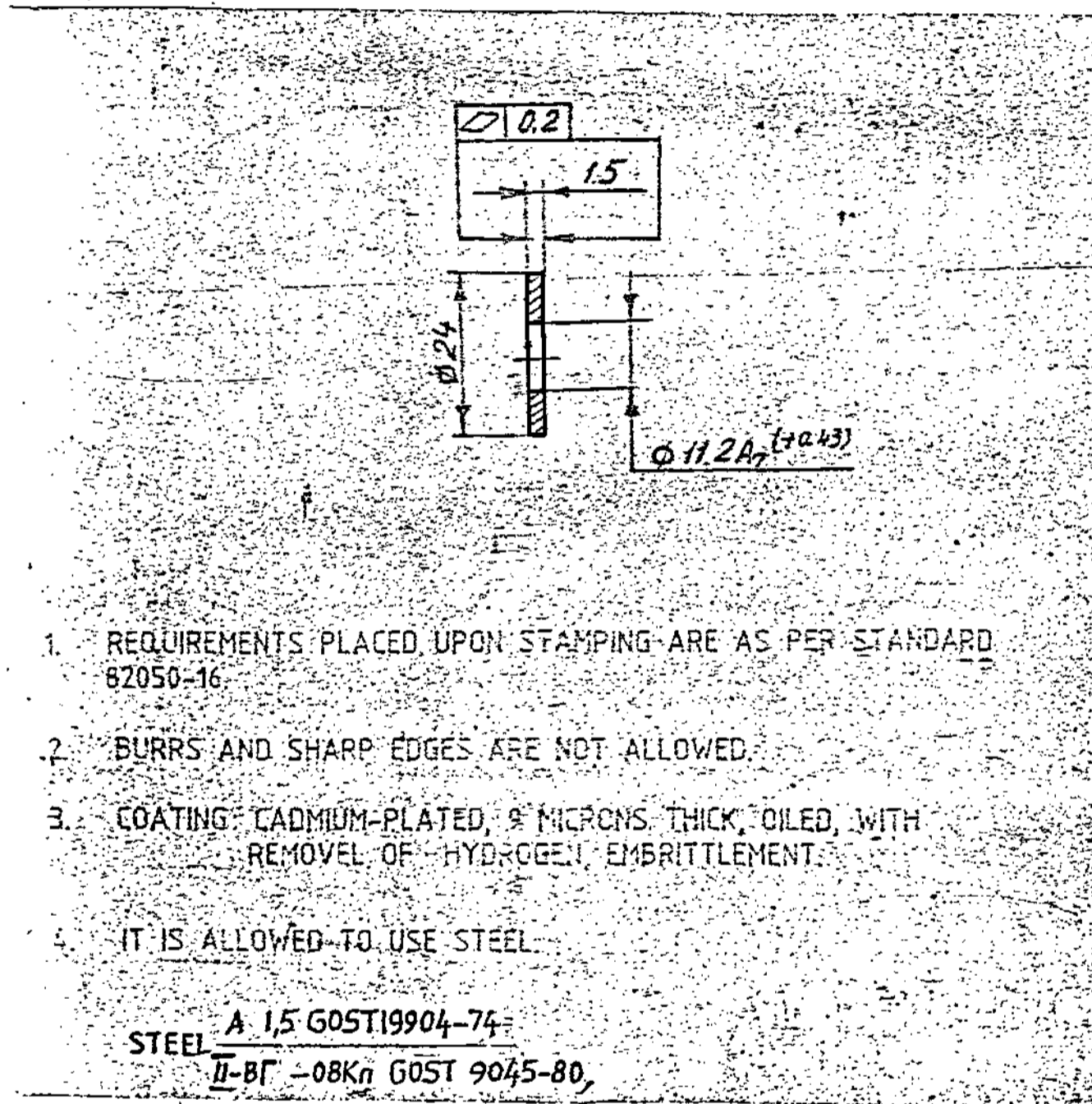
c) CHEMICAL COMPOSITION % AS PER GOST 9045 - 80

GRADE	C (Max)	Mn	S	P	Si	Cr	Ni	Cu	ARSENIC	NITROGEN
						M				
08KП	0.10	0.20 - 0.40	0.030	0.025	0.03	0.10	0.10	0.15	0.08	0.008

d) MECHANICAL PROPERTIES

GRADE	ULTIMATE TENSILE STRENGTH Kgf / mm ²	RELATIVE ELONGATION % (Min)
08KП	26 - 37	28

Ⓐ EQUIVALENT MATERIAL
Gr. 0 IS:513-1994



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

EST. WT. 0.004 Kg 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.

ERN	APPD	MATERIAL :-	USED ON :-
CHD	DATE 24-6-86	STRIP 10-BH-2-HO-15 GOST 503-71	CE 20-39-00-3 CE 20-15-663-6 CE 315-639-21
SCALE :- 1 : 1		CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
DIMENSIONS IN mm		A V A D I	
TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 2102-69		TITLE	
A 1-7-10 4 th ALT. COMM. Mtg. MINUTES POINT No 2 DATE 26-10-09		WASHER 11	
ISSUE	DATE	D S CAT NUMBER	DRAWING NUMBER
	NATURE OF AMENDMENTS		315-639-1



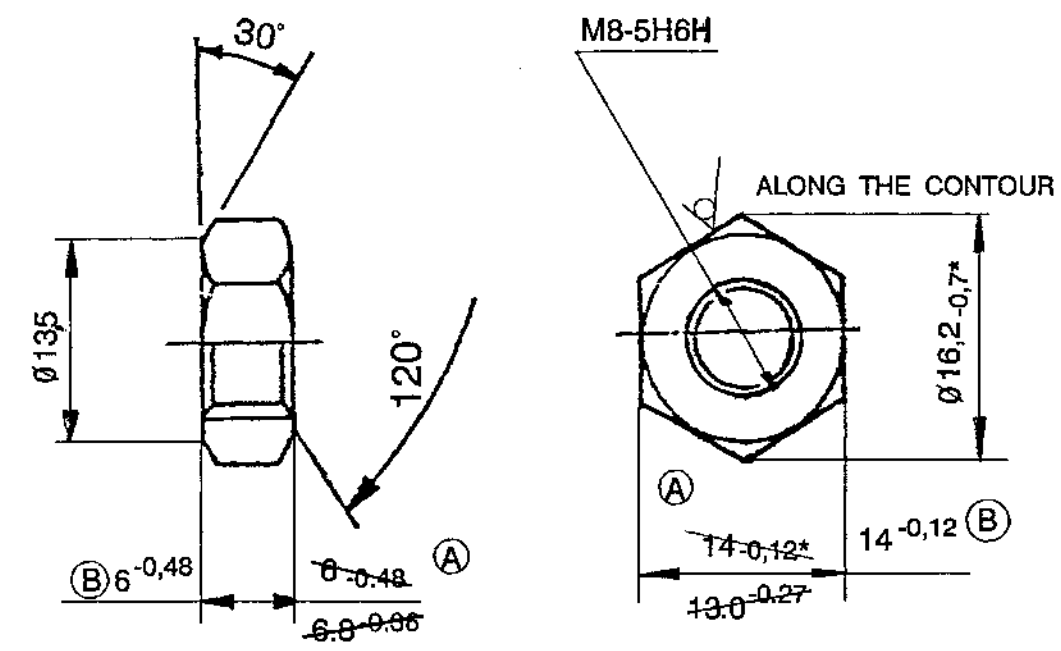
THE
LIFE OF
SAMUEL JOHNSON
BY
BIOGRAPHICAL MEMOIRS
BY
JAMES BOSWELL

THE
LIFE OF
SAMUEL JOHNSON
BY
BIOGRAPHICAL MEMOIRS
BY
JAMES BOSWELL

COMMON TO V-92S2 & UTD-20 ENGINES
DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - N/IL
JTO (D)
(B. JAYAVELU)

DRAWING NUMBER
351 - 02

Rz40 ✓ (✓)



EXPLANATORY NOTE :

7. MATERIAL QUOTED :- HEXAGON BAR $\frac{14-4 \text{ GOST } 8560-78}{45-5 \text{ GOST } 1051-73}$

BRIGHT STEEL OF HEXAGONAL CROSS SECTION 14mm ACROSS FLAT, ACCURACY CLASS - 4 TO GOST 8560-78. AND MANUFACTURED FROM COLD DRAWN SIZED STEEL OF GROUP B SURFACE QUALITY TO GOST 1051-73.

ALTERNATE MATERIAL QUOTED - STEEL GRADE 40 & 50 TO GOST 1050-74.

CHEMICAL COMPOSITION :

STEEL GRADE	C O N T E N T O F E L E M E N T S %							
	C	Si	Mn	Cr(max)	S	P	H	Cu
40	0.37-0.45	0.17-0.37	0.50-0.80	0.25	0.040	0.035	0.10	0.15
45	0.42-0.50	0.17-0.37	0.50-0.80	0.25	0.040	0.035	0.10	0.15
50	0.47-0.55	0.17-0.37	0.50-0.80	0.25	0.040	0.035	0.10	0.15

MECHANICAL PROPERTIES :

STEEL GRADE	YIELD POINT Kgf/mm ² (min)	ULTIMATE TENSILE STRENGTH Kgf/mm ² (min)	PERCENTAGE ELONGATION (min)	REDUCTION OF AREA % (min)	IMPACT STRENGTH KJm/cm ² (min)
40	34	58	19	45	6
45	36	61	16	40	5
50	38	64	14	40	4

- ROLLED STOCK OF GROUP B CLASS 4 GOST 1051-73 MAY BE USED TO ENSURE HIGH QUALITY OF COATING, IT IS ALLOWED TO ELIMINATE SURFACE DEFECTS OF ROLLED STOCK WITH DECREASE OF DIMENSIONS AS PER ACCURACY CLASS 5.
- ALTERNATE MATERIAL :- STEEL GRADES 40 AND 50 GOST 1050 - 74.
- THE REST OF THE TECHNICAL REQUIREMENTS AS PER STANDARD 82052 - 00.
- COATING :- Cd 3, CHROMATIZING AS PER UJL-104 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
- *DIMENSIONS FOR REFERENCE.

Material: STEEL 709M40 (EN-19) TO BS-970 Pt-1-1983

CQA(HV)5.06.606E
CQA(HV)5.06.610E

USED ON:- **
Cb 406-12-44
Cb 406-13-44
Cb 20-27-00-4
Cb 20-15-663-4
Cb 3342-00-8cb
Cb 334-73-1
Cb 3334-02-3
Cb 327-145-10
Cb 327-145-15
Cb 315-663-21

DRN	Sd/=	MATERIAL :-
CHD	Sd/=	14-4 GOST 8560-78
TCD	Sd/=	45-5 GOST 1051-73
APPD	Sd/=	

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

EST. WT. 0,0055 Kg TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

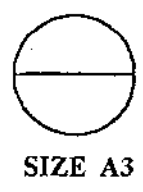
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

ISSUE	DATE	NATURE OF AMENDMENTS
E	15.7.15	Pt. 11, 7 th Alt. Comm. Meeting Dt. 11.4.12
D	18.5.09	Authy: Third Alt. Comm. Minutes Point 5 Dated 27-02-2009.
C	25.8.08	USED ON NUMBER ADDED
B	24-12-07	ALT. COMMITTEE MEETING MINUTES. POINT No. 2.18 Dt. 18-12-2007.
A	15-03-04	AUTHY. Lt. No.110094/IND-III /577, Dt. 19-02-04.

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)
AVADI

TITLE:-
NUT M8

D S CAT NUMBER
DRAWING NUMBER
351 - 02

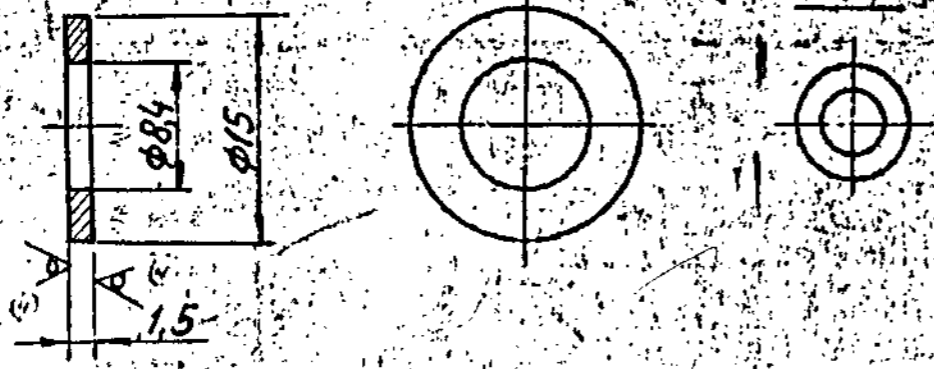


SIZE A3



353-05-1

V(V)



2. DIMENSIONS WITH UNSPECIFIED TOLERANCES AS PER STANDARD B2050-16
3. AFTER STAMPING THE COMPONENT SHOULD BE STRAIGHTENED BURRS ARE NOT ALLOWED
4. THE COMPONENT MAY BE MANUFACTURED FROM SHEET GOST 19904-74
6. COATING: CADMIUM 9, CHROMATIZING AS PER 1247-104 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
8. ALTERNATE MATERIAL: STEEL, GRADE 15, GOST 1050 74
9. REQUIRED FINISHING OF SURFACES BEING STAMPED SHOULD BE ENSURED BY TOOL

ⓑ EQUIVALENT MATERIAL
Gr. 0 IS 513-1994

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

EXPLANATORY NOTE :-

10. MATERIAL QUOTED : STRIP 10-BH-2-15
GOST 503-81

ALTERNATE MATERIAL QUOTED : STEEL GRADE 15 TO GOST 1050-74.
STRIP = COLD ROLLED STRIP (LOW CARBON) WITH TRIMMED EDGES.

10 & 15 = GRADE OF STEEL.

B H = HIGHLY COLD WORKED.

2 = GROUP OF SURFACE QUALITY. 15 = THICKNESS.

a) CHEMICAL COMPOSITION :-

GRADE OF STEEL	C O N T E N T O F E L E M E N T S %							
	C	Si	Mn	Cr	P	S	Cu	Ni
10	0.07-0.14	0.17-0.37	0.35-0.65	0.15	0.035	0.040	0.25	0.25
15	0.12-0.19	0.17-0.37	0.35-0.65	0.15	0.035	0.040	0.25	0.25

b) MECHANICAL PROPERTIES :- TO GRADE 10 AS PER GOST 503-81

ULTIMATE TENSILE STRENGT Kg/mm² (min) = 55

c) MECHANICAL PROPERTIES :- TO GRADE 15 AS PER GOST 1050-74.

TENSILE STRENGTH Kgf/mm ²	YIELD POINT Kgf/mm ²	ELONGATION %	REDUCTION IN AREA %	IMPACT STRENGTH Kgf/cm ²
M I N I M U M				
38	23	27	55	-

UTD-20	V-46-6	V-92S2
Cb 20-01-00-8 Cb 20-13-01-8 Cb 20-15-663-4 Cb 20-22-00-7 Cb 20-27-00-4	Cb 3301-00-37, Cb 3305-03-15 Cb 406-12-44, Cb 406-13-44, Cb 3312-90-9, Cb 3338-401-10, Cb 3342-00-8, Cb 303-00-16, Cb 3301-15-30, Cb 3308-00-17, Cb 3334-00-27	Cb 3301-00-44, Cb 3301-15-44 Cb 3305-03-15, Cb 406-12-75, Cb 406-13-75, Cb 3308-15-2, Cb 3312-90-14, Cb 3321-00-26, Cb 3334-00-47, Cb 3336-00-11, Cb 340-16-22, Cb 345-00-4

COMMON TO V-92S2 & UTD-20 ENGINES

4-11

EST WT	TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)
0.0015 kg	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
18-03-15	Pl. 11 of 7th Alt. Comm. Meeting Dt. 11-4-12
19.5.10	6 th Alt. Comm. Meet. Minutes
25-8-08	Point No. 2, Dt: 26-10-09
ISSUE DATE	NATURE OF AMENDMENTS
DRW	SCALE : 2 : 1
CHO	DIMENSIONS IN mm
APD	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED
DATE	ALL THREADS CONFORM TO
SIZE A6	

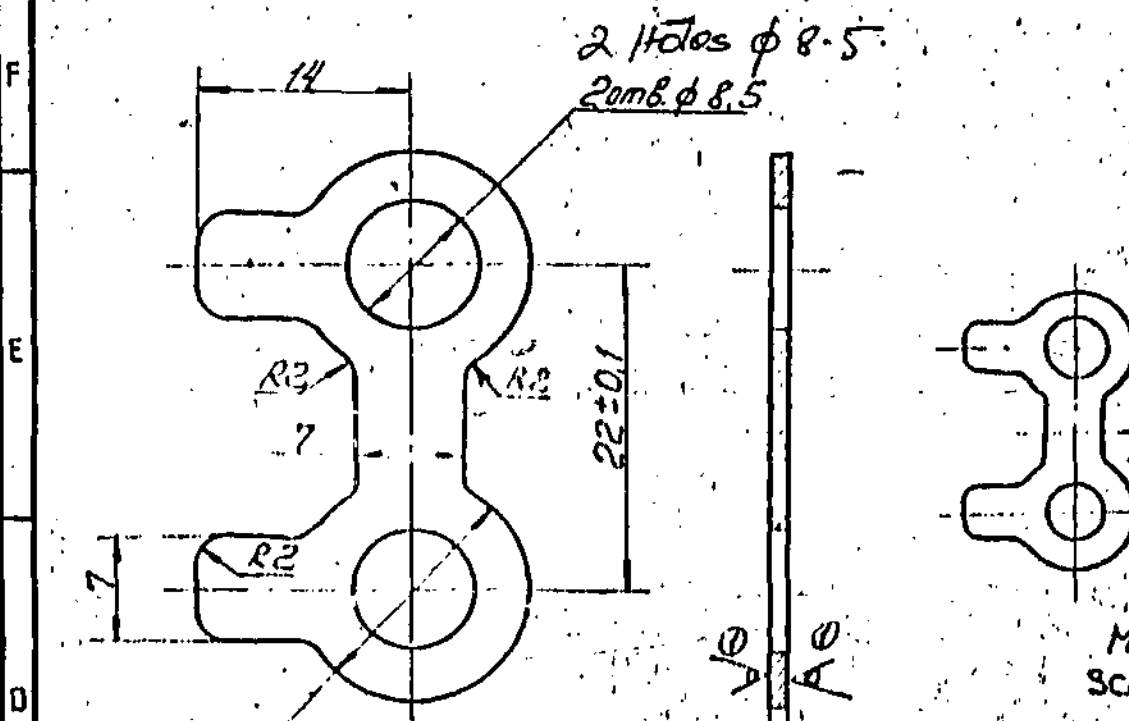
MATERIAL	USED ON
STRIP 10-BH-2-15	SEE TABLE **
GOST 503-81	CQA(HV)5.06.001E (C)
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TITLE	WASHER BRIGHT 8
D S CAT NUMBER	DRAWING NUMBER
	353-05-1



DRAWING NUMBER

353-12

Rz80 ✓ (10)



Ⓐ EQUIVALENT MATERIAL
Gr.O IS:513-1994

2. Requirements for stamping - as per standard 28050-16.
3. The Component should be straightened after stamping.
4. Burrs are not allowed.
6. Coating: - cd 9, chromating as per 460-104 with elimination of hydrogen embrittlement.
7. Required finishing of surfaces being stamped should be ensured by tool.

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

A-11
63

EST. WT.
0.0026 kg

TO BE STAMPED OR MARKED WHERE INDICATED THUS ≡ I (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.

MATERIAL:-
STRIP 0.800-M-2-1
G067 303-71 *deleted*

USED ON
CB 20-18-663
CB 20-06-03-1
CB 306-03-3
CB 20-15-43-4

A 17.03.10 4th Alt. Comm. Meet. Minutes
Point No.1 Dt:26-10-09.

ISSUE DATE NATURE OF AMENDMENTS

DRN SCALE:- 2:1
DIMENSIONS IN mm

CHD
TCO
APPD
DATE 15-2-89
SIZE A4

TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS 2102 -69
ALL THREADS CONFORM TO

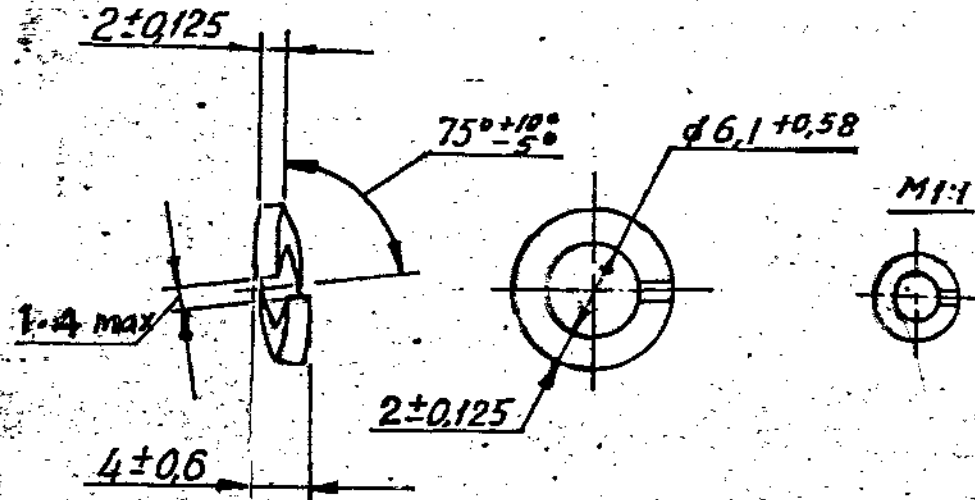
CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI.

TITLE
LOCK WASHER 8

D S CAI NUMBER DRAWING NUMBER
353-12



353 23



EXPLANATORY NOTE

3. REFERENCE MATERIAL QUOTED:

SPRING WASHER, NOMINAL THREAD DIA 6mm, HEAVY WASHER 'T' PARKERISED AND OILED '0,6' AND REFERENCE NOTE 'Z' ON ALTERNATE MATERIAL ZINC PLATED '09' TO GOST 6402-70 AND MANUFACTURED IN ACCORDANCE WITH CARBON STRUCTURAL HOT ROLLED STEEL GRADE 65 G TO GOST 1050-74.

a) CHEMICAL COMPOSITION:

GRADE OF STEEL	CONTENT OF ELEMENTS %					
	C	SI	Mn	Cr	S	P
65G	0,62 - 0,70	0,17 - 0,37	0,90 - 1,20	0,25	0,040	0,35

RESIDUAL CONTENT OF COPPER AND NICKEL SHOULD NOT EXCEED 0,25% EACH

b) MECHANICAL PROPERTIES UNDER NORMALISED CONDITION: AS PER GRADE 65G, 1050-74.

GRADE OF STEEL	ULTIMATE TENSILE STRENGTH Kgf/mm ²	YIELD POINT Kgf/mm ²	ELONGATION %	HARDNESS		
				B	H	N
65G	75	44	9	M	A	X

1. COATING: CADMIUM CHROMATIZING AS PER ЧЗЛ 104 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
2. WASHER 6T, 65G 09 GOST 6402-70 MAY BE USED.

B EQUIVALENT MATERIAL
75 C6 TO IS:2507/EN42 J BS:970

- A** Cb 327-00-73, Cb 3301-00-44, Eb 406-12-75, Cb 406-12-44, Cb 406-13-44, Cb 3334-00-47, Cb 406-13-75, Cb 3308-15-2, Cb 3300-00-27 CX, Cb 3301-00-37, Cb 3335-00-9, Cb 310-00-14, Cb 411-00-56, Cb 3308-00-17, Cb 3320-00-33, Cb 337-100, Cb 3320-00-43, Cb 315-606-12, Cb 3335-00-24, COA(HV)5.06.607E **D**

USED ON
Cb 3338-00-16*
Cb 3338-401-10
Cb 3338-406-7
Cb 3342-00-00B
Cb 3342-188-7 Cb 3315-606
Cb 337-00-45 Cb 411-00-41
Cb 407-00-1 Cb 407-93-1

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

EST WT 0,001 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 OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	

DATE	15-7-15	Pl. 11 of 7th Alt. Comm. Meeting Dt. 11-4-12	SCALE: 2:1	MATERIAL 65G 06 GOST 6402-70	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AYAD
DATE	18-3-15	Pl. 11 of 7th Alt. Comm. Meeting Dt. 11-4-12	DIMENSIONS IN mm		
DATE	16-08-10	4 th Alt. Comm. Meeting Minutes Point No.12 Dt:26-10-09	TOLERANCE BY DIMS UNLESS OTHERWISE STATED IS : 2:102-69	TITLE WASHER 6T	DRAWING NUMBER 353 23
DATE	28.8.08	USED ON NUMBER ADDED	ALL THREADS TO CONFORM TO		
ISSUE	DATE	NATURE OF AMENDMENTS			

* COMMON TO V-92S2 & UTD-20 ENGINES
 KVD NO 63632
 CB 20-01-00-B CB 20-06-13-6 CB 20-23-34-36
 CB 20-06-00-2 CB 20-15-671
 CB 20-06-12-6 CB 20-22-00-7
 CB 20-15-663-4 CB 20-23-33-6

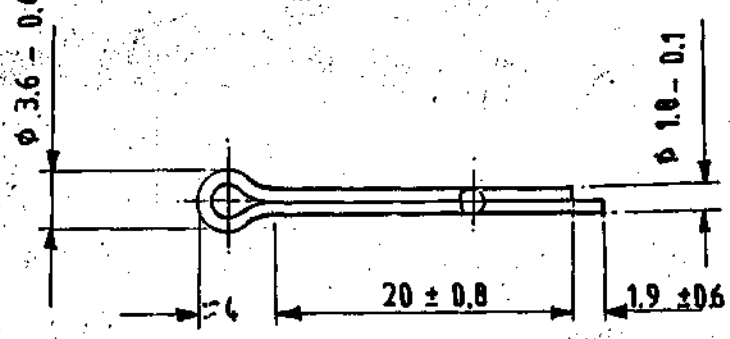
SIZE A3



DRAWING NUMBER
354-12 SHT 1 OF 2



F
E
D
C



SCALE 1:1

1. TO BE ANNEALED.
2. COATING CADMIUM 3. CHROMATIZING AS PER Udel-104 WITH ELIMINATION OF HYDROGEN ENBRITTEMENT.

(A) EQUIVALENT MATERIAL
IS: 549

* *
Cb 20-01-00-8
Cb 20-15-663-4
Cb 20-27-00-4
Cb 20-34-12
CQA (HV) 5.06.001E (B)

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

			EST. WT 1000 PIECES 0.479 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	
B	18-03-15	Pt. 11 of 7th Alt. Comm. Meeting Dt. 11-4-12	MATERIAL	USED ON Cb 334-73-1
A	8-7-10	4th ALT. COMM. Mtg. MINUTES POINT No. 3 DT. 26-10-09		Cb 315-662-3 Cb 315-663-21
ISSUE	DATE	NATURE OF AMENDMENTS		** SEE ABOVE
DRN		SCALE 2 : 1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD		DIMENSION IN mm	TITLE COTTER PIN 2 X 20	
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED		
APPD		ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER 354-12 SHT 1 OF 2
DATE	1-5-82			

SIZE A4



DRAWING NUMBER
354-12 SHT 2 OF 2

ADDITIONAL REQUIREMENTS FOR COMPONENT NUMBERS:- 354-09, 354-09A, 354-12, 354-16, 354-15, 354-17, 354-18, 354-19, 354-28

1. SPLIT PIN MUST BE MANUFACTURED FROM LOW CARBON STEEL WITH MAXIMUM CARBON CONTENT 0.20% ON GOST 1050-74
2. BURRS, CRACKS, RUST ARE NOT ALLOWED ON THE SURFACE OF THE PIN & SHARP CUT ON THE BENDED HEAD ARE ALSO NOT ALLOWED.
3. PINS OF DIAMETER UPTO 5mm MUST WITHSTAND 3 BENDS WITHOUT ANY SIGN OF BREAKING.

(A) EQUIVALENT MATERIAL
IS: 549

* *
Cb 20-01-00 8
Cb 20-15-663-4
Cb 20-27-00-4
Cb 20-34-12
(B) CQA (HV) 5.06.001E

(A-11)

		EST. WT	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	
B	19-03-15	Pl. 11 of 7th Alt. Comm. Meeting Dt. 11-4-12	MATERIAL USED ON ** SEE ABOVE Cb 315-663-3 Cb 315-663-27 Cb 334-73-1
A	8-7-10	4 th ALT. COMM. MEET. MINUTES	
		POINT No 3 DT. 26-10-09	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
CHD		DIMENSIONS IN mm	TITLE COTTER PIN 2x20
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	
APPD		ALL THREAD CONFORM TO	D.S CAT NUMBER
DATE	11-5-06		DRAWING NUMBER 354-12 SHT 2 OF 2
SIZE A4			

