



- 1 INSPECTION GROUP III AS PER TECHNICAL REQUIREMENTS TT-11
- 2 EXCEPT FOR SURFACE H, CYANIDE TO A DEPTH OF 0.35 TO 0.45 mm. SURFACE B AND F, TO A DEPTH OF AT LEAST 0.2 mm. SURFACE K MAY HAVE NO CYANIDE LAYER.
- 3 HARDNESS OF SURFACE F SHOULD BE HR 15N±0.9. CHECK MAY BE PERFORMED WITH CALIBRATED FILE.
- 4 UNSPECIFIED LIMIT DEVIATIONS OF DIMENSIONS ARE AS FOLLOWS :-
 FOR HOLES - AS PER A7,
 SHAFTS - AS PER B7,
 OTHERS - AS PER C47.
- 5 MISALIGNMENT AND SHIFT OF SLOT A WITH RESPECT TO DIAMETRICAL PLANE OF SURFACE F WHICH IS PERPENDICULAR TO THE AXIS OF SURFACE B SHOULD NOT EXCEED 0.04 mm (1 QUALIFIED TOLERANCE).
- 6 MISALIGNMENT OF THE AXIS OF SURFACE B WITH RESPECT TO THE DIAMETRICAL PLANE OF SURFACE F SHOULD NOT EXCEED 0.5 mm.
- 7 NON-SQUARENESS OF SURFACE H TO AXIS B SHOULD BE CHECKED BY TURNING THE ROLLER, 20.8 mm IN DIAMETER, WHICH IS MADE AS PER TOLERANCES OF GAUGES ON PIN 13 mm IN DIAMETER ROLLER HAVING DIMENSIONS 20.8x15.9 AND CHAMFER 12x60° MAY BE USED FOR CHECKING.
- 8 SURFACE D MAY HAVE NOTCHES AND TRACES OF PRELIMINARY MACHINING AS PER STANDARD.
- 9 SURFACE E MAY HAVE CUTTINGS IN WHICH ARE CAUSED BY MACHINING OF RADI R2 AND ARE NOT BROUGHT ONTO SURFACE *.
- 10 THE PART SHOULD BE CHECKED BY USING THE MAGNETIC FLAW DETECTOR AS PER INSTRUCTIONS US 20-17.
- 11 COATING - CHEMICALLY OXIDIZED, OILED.

EXPLANATORY NOTE :

MATERIAL QUOTED : OPEN HEARTH STEEL 10 GOST 1050-74.

a) CHEMICAL COMPOSITION :

| GRADE | CONTENT OF ELEMENTS % | | | | | | | |
|-------|-----------------------|-----------|-----------|------|-------|-------|------|------|
| | 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 |

b) MECHANICAL PROPERTIES :

| GRADE | TENSILE STRENGTH | YIELD POINT | ELONGATION | REDUCTION |
|-------|---------------------|---------------------|------------|-----------|
| | Kgf/mm ² | Kgf/mm ² | % | IN AREA % |
| 10 | 34 | 21 | 31 | 55 |

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

EST. MASS 0.102 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 | 9 | MATERIAL :- | 10 GOST 1050-74 | USED ON :- | CS 20-27-15-1 |
| CHD | | CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) | | | |
| TCD | | A V A D I | | | |
| APPD | | TITLE | | | TAPPET BODY |
| DATE | 06-03-87 | D S CAT NUMBER | | | |
| SCALE | 2 : 1 | DRAWING NUMBER | | | 20-27-91-1 |
| DIMENSIONS IN mm. | | TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69 | | | |
| ALL THREADS TO CONFORM TO | | NATURE OF AMENDMENTS | | | |