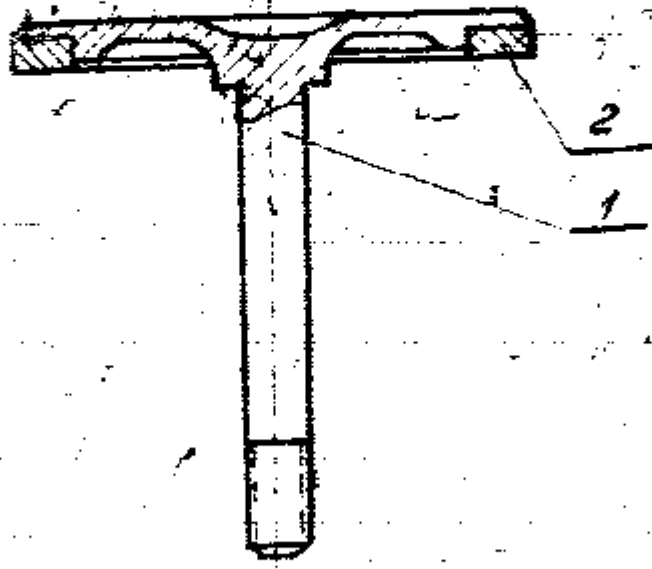




765-71-837

DCO	DATE	ZONE	NATURE	OFFICER SIGN
ES/KS/19/407/188			IN DESCRIPTION COLUMN FOR R.NO. 1 & 2 SOME MISC. MATURE WAS GASKET & VALVE RESPECTIVELY DRG NO. ADVANCED /A	



1) Gasket is glued with adhesive 88-Hn, TY 38-105540-73

REF NO.1 ADHESIVE 88-HN TY 38-105540-73 SEE SEPARATE SHEET ATTACHED.

R. VEERA RAGHAVAN  
SEC-III

R.No	Designation	Description	Qty	Remarks
2	765-71-817	Valve GASKET	1	
1	765-71-816	Gasket VALVE	1	

S/NO	SHEET	DOC NO	SIGN	DATE
DRAWN BY	Y.R. Ganesh			23.8.84
EDITED AND CHECKED BY	B. B. Saini			24.8.84
FOREMAN OF DC	S.R. NAIR			24.8.84
DIVISIONAL OFFICER	T. R. Dhanraj			24.8.84
	NAME	SIGN	DATE	

VALVE  
CIFE, PUNE

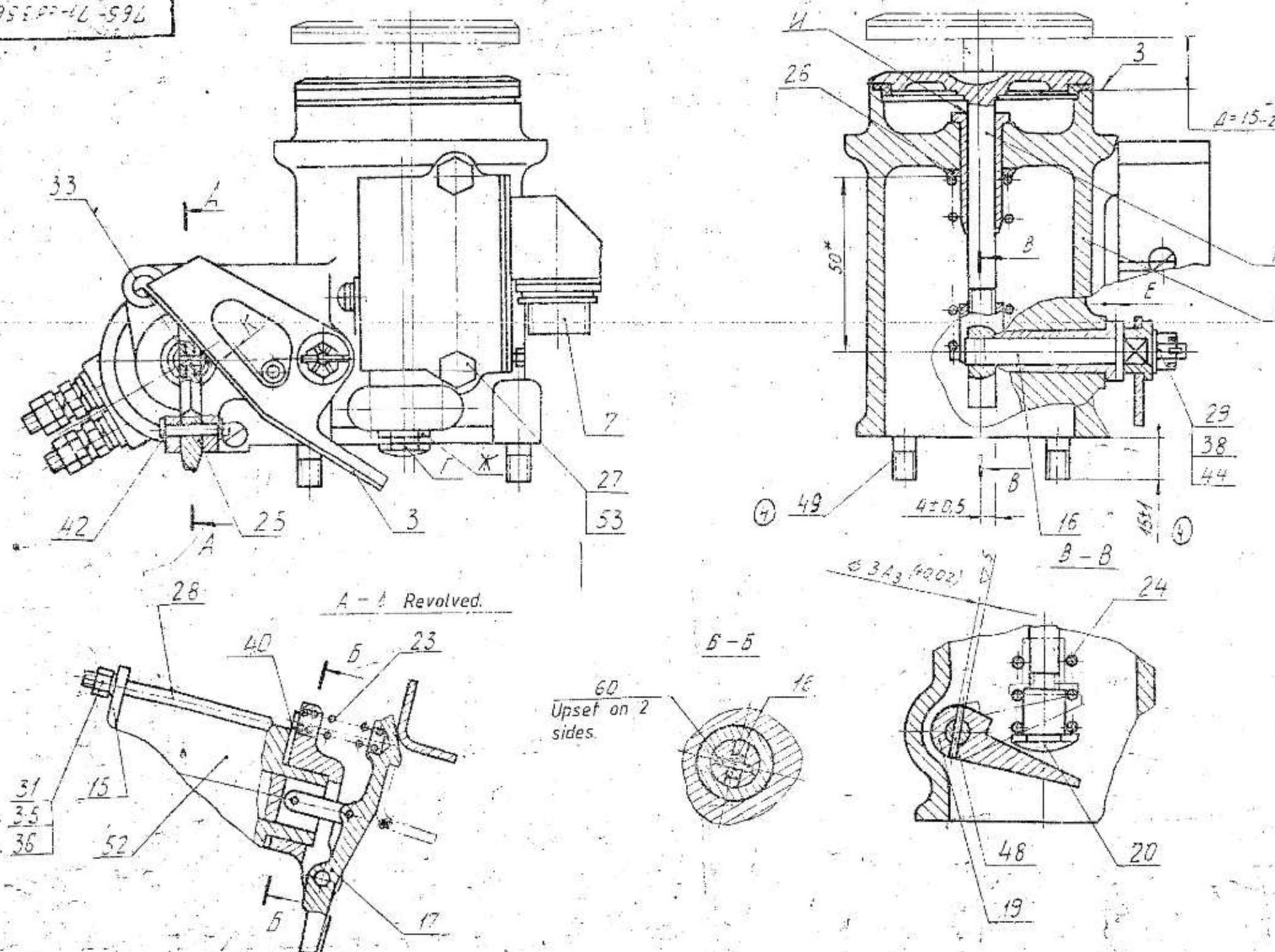
765-71-837/A		
SHEETS	WEIGHT	SCALE
1		
TOTAL SHEETS		
ORDNANCE FACTORY 9 - ROJEC HYDERABAD		

765-71-837

765-71-837

1-A4

765-71-356CB



- 1). \* Dimension is given for reference.
  - 2). With dimension A set along the contour of the valve, Ref.No.1, fit the lever, Ref.No.19 onto the shaft, so that the lever Ref.No.3 is locked by the retainer as it is shown conventionally in section A-A, there upon drill the lever fitted onto the shaft and secure it with lock pins, while axial play E of the shaft should not exceed 0.5 mm.
  - 3). In closed condition, the valve should tightly fit to the box along the entire perimeter, in this case distance K for motion of the lever, Ref.No.3, should be atleast 0.5mm.
  - 4). Crimp the free end of the rivet Ref.No.33, so that the clamp, Ref.No.18, is able to turn easily.
  - 5). In finally assembled unit the retainer should reliably keep the valve in the open position and under the relay action, at a voltage of 22-0.5 V, it should positively release the valve engagement lever, Ref.No.3, with the armature thrusting against the relay body, no more than 3 washers, Ref.No.40, may be placed.
  - 6). Lubricate all friction surfaces of the parts with lubricant lithol-24, GOST 21150-75, and wipe out the excessive lubricant from surface n.
  - 7). Check the inner space of box for tightness by pouring water upto the box full capacity for 3 mints. Leakage of water along the valve sealing is not allowed.
- Grinding of valve gasket and of surface 3, leakage along the shaft, ref.no.16, are allowed.  
After checking the box for tightness, dry the inner space of box for compressed air.

- 8). Adjust the limit switch by screw T and locknut X, so that when locking the lever, Ref.No.3, by the retainer, the switch rod is pressed by the lever, contacts 3 and 4 are closed, contacts 1 and 2, are opened, the switch rod free travel should be 2 to 3, mm. When the valve is closed the rod should be lowered, contacts 1 and 2 closed contacts 3 and 4 opened.
- 9). Check reliable locking of the valve, Ref.No.1, in the opened position by applying a static load of 5kg. acting along the axis of valve. Releasing of the lever Ref.No.3, from the retainer, Ref.No.17, is not allowed.
- 10). If necessary, the lever Ref.No.3, may be straightened
- 11). Before assembling lubricate the threaded joints with a thin layer of lubricant lithol-24, GOST 21150-75, or lubricant MC-70, GOST 9762-76, secure the pusher Ref.No.20, and studs, Ref.No.49, with the aid of iron minium, GOST 8866-76.
- 12). To provide for locking of the nut, Ref.No.29, with the cotter pin, Ref.No.44, no more than 2 washers, Ref.No.38, may be placed.
- 13). Under cut of the rivet Ref.No.33, not exceeding 2mm is allowed.

7	765 599 50	21.10.86	
6	765 224 79	21.10.86	
5	765 326 78	21.10.86	
4	765 187 78	21.10.86	
3	765 450 77	21.10.86	

765-71-356CB

BOX (Assembly drawing)

SHEET WEIGHT SCALE

166

TOTAL SHEETS

18-175222-80

765-71-356CB

### EXPLANATORY NOTES TO TECH. CONDITIONS.

i) REFER NOTE No. 6 AND 11

a) LUBRICANT LITHOL 24 (GOST 21150-75)  
LITHOL 24 GREASE IS MADE BY THICKENING MINERAL OIL WITH LITHIUM SOAPS OF 12-OXYSTEARIC ACID AND ADDING AN ANTIOXIDISING OR A VISCOUS DOPE.

b) LUBRICANT MC-70 (GOST 9762-76)  
GREASE MC-70 IS MANUFACTURED BY THICKENING MBT (MVP) GRADE INSTRUMENT OIL WITH BARIUM AND ALUMINIUM STEARIC ACID SOAP AND ADDING GRADE 80 CERESINE AND POLYISOBUTYLENE OF GRADES P-200 N, P-200 P-155 N AND P-155.

REFER NOTE No. 11

IRON MINIMUM  
IRON MINIMUM IS A SUSPENSION OF PIGMENT (IRON OXIDE) GROUND WITH DRYING OIL WITH OR WITHOUT ADDITIVES.

ii) PILOT SAMPLE  
THREE SAMPLES SHALL BE SUBMITTED TO CQAF, PUNE FOR THEIR TEST AND APPROVAL BEFORE THE COMMENCEMENT OF BULK SUPPLY.

DRN	---	DRG NOT TO BE SCALED.	PERTAINS TO
TCD	---	ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.	
CHD	---	ALL DIMENSIONS ARE IN MM, UNLESS OTHERWISE SPECIFIED.	
PBD	---		
APPD	---		
DATE	13 OCT '86		
TOLERANCE UNLESS OTHERWISE SPECIFIED.			
GEN	DEC	ANG.	
SCALE:-			
CQA (FE), AUNDH CAMP. PUNE - 27.			

AUTHORIZATION: TCD, CHD, PBD, APPD, DATE, DRG BASED ON, W/O No., JOB No., 1-1-AB

FORM	ZONE	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
				Technical papers		
12			765-71-c8358CB	Assembly drawing		
				Parts		
16	1		765-71-818	Body	1	
11	2		765-71-819	Bushing	1	
11	3		765-71-819-01	Bushing	1	
				Standard units		
	7			Lock-pin		
				5Пp2 <sub>2a</sub> x28		HB 255 to 207
				OCT3-2234-80	1	(φ3.8 to 4.2)

765-71-c8358

S.NO	SHT	DOC.NO.	SIGN	DATE
	DRAWN	CH.V.RAO.		26.7.84
	EDT&CHK	D.K. JAIN		28.7.84
	F/M.D.C.	S.R.NAIR		30.7.84
	DIV.OFFR.	T.K.BANERJEE		31.7.84
		NAME	SIGN	DATE

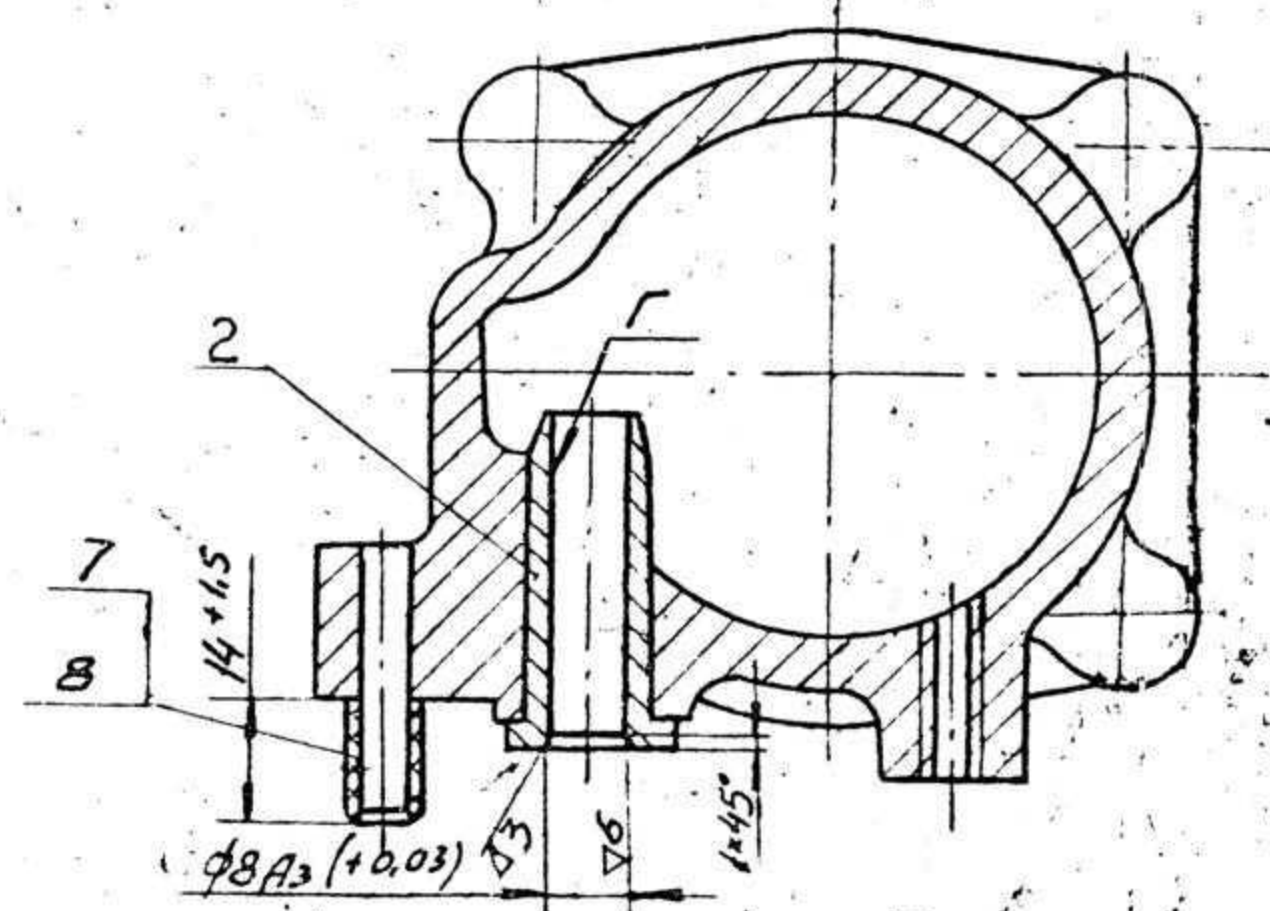
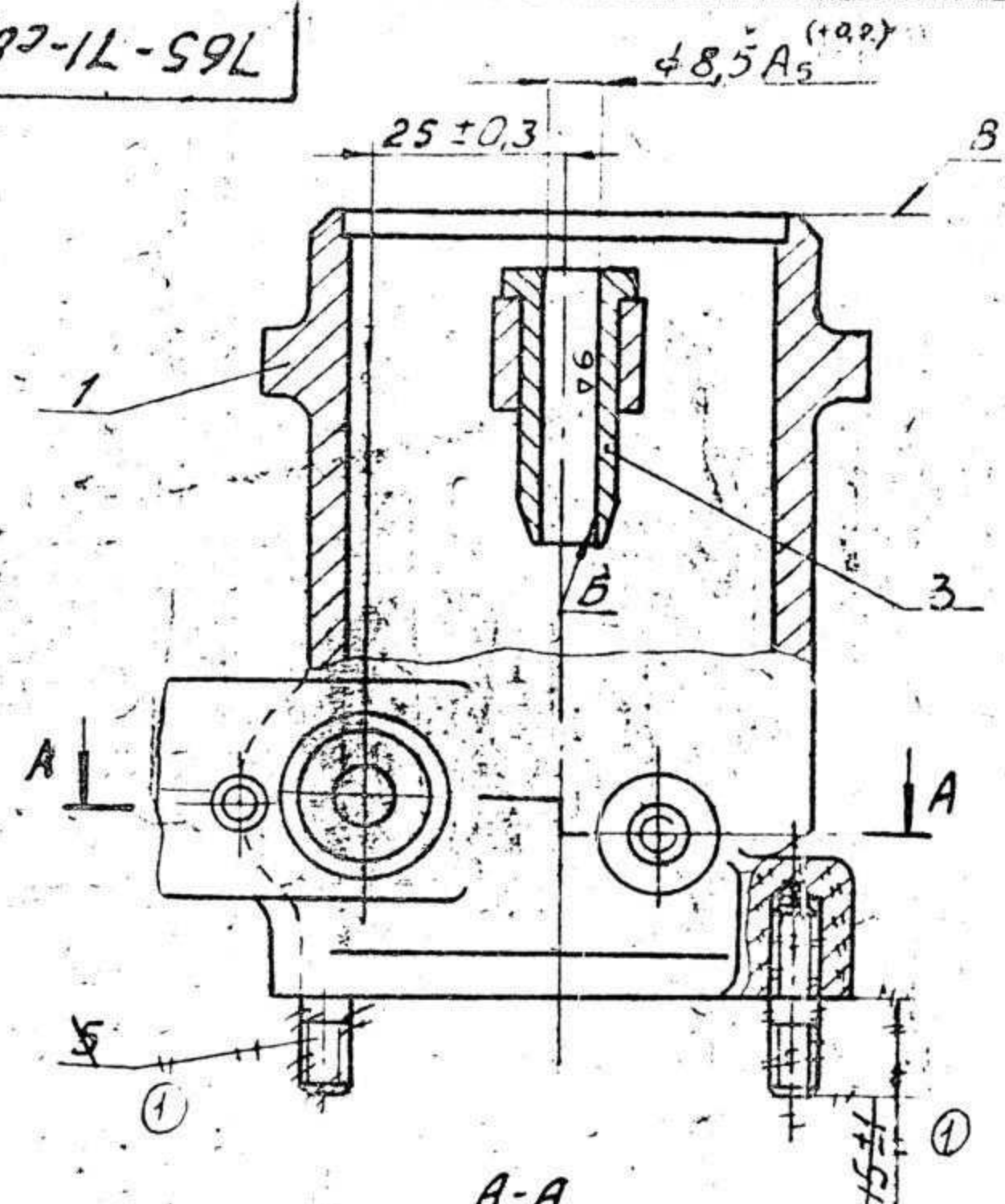
Easy2Convert  
BODY

SHT. NO	NO OF SHT
1	2

GEORGE FACTORY



765-71-08358CB



1. Non-squareness of axis of surface  $\Gamma$  to surface B should not exceed 0.3 mm over the length of bush (Qualified tolerance)
2. Non-squareness of axis of surface  $\Gamma$  to the axis of surface B should not exceed 0.7 mm over a length 100 mm
3. Apply primer  $\Phi$ Л-03Ж, GOST 9109-76 and enamel ПФ-223, White-1, GOST 14923-78 on the external surfaces except locating surfaces
4. Bushing, Ref.nos: 2 and 3, may be cooled in liquid nitrogen.

**COATING**

EXTERNAL SURFACE OF THE BODY SHALL BE APPLIED WITH PRIMER CONFORMING TO IS: 5060-70 & PAINT WITH ENAMEL CONFORMING TO IS: 2062-74 (SHADE NO 365 OF IS: 5-78) EXCEPT LOCATING SURFACES.

**SURFACE FINISH**

$\nabla 3$ :- REPRESENTS SURFACE FINISH TO BE OBTAINED IN Ra VALUE 20  $\mu$ l MAX.

$\nabla 6$ :- REPRESENTS SURFACE FINISH TO BE OBTAINED IN Ra VALUE 2.5  $\mu$ l MAX.

**PILOT SAMPLE**

THREE SAMPLES SHALL BE SUBMITTED FOR TESTING PURPOSE FOR THEIR TEST AND APPROVAL BEFORE COMMENCEMENT OF BULK SUPPLY.

(RIVEERARAGHAYAN)

4	-	765.772-79	15.10.79
3	-	765.224-79	28.5.79
2	-	765.510-78	23.6.78
1	-	765.797-78	19.5.78

765-71-08358CB

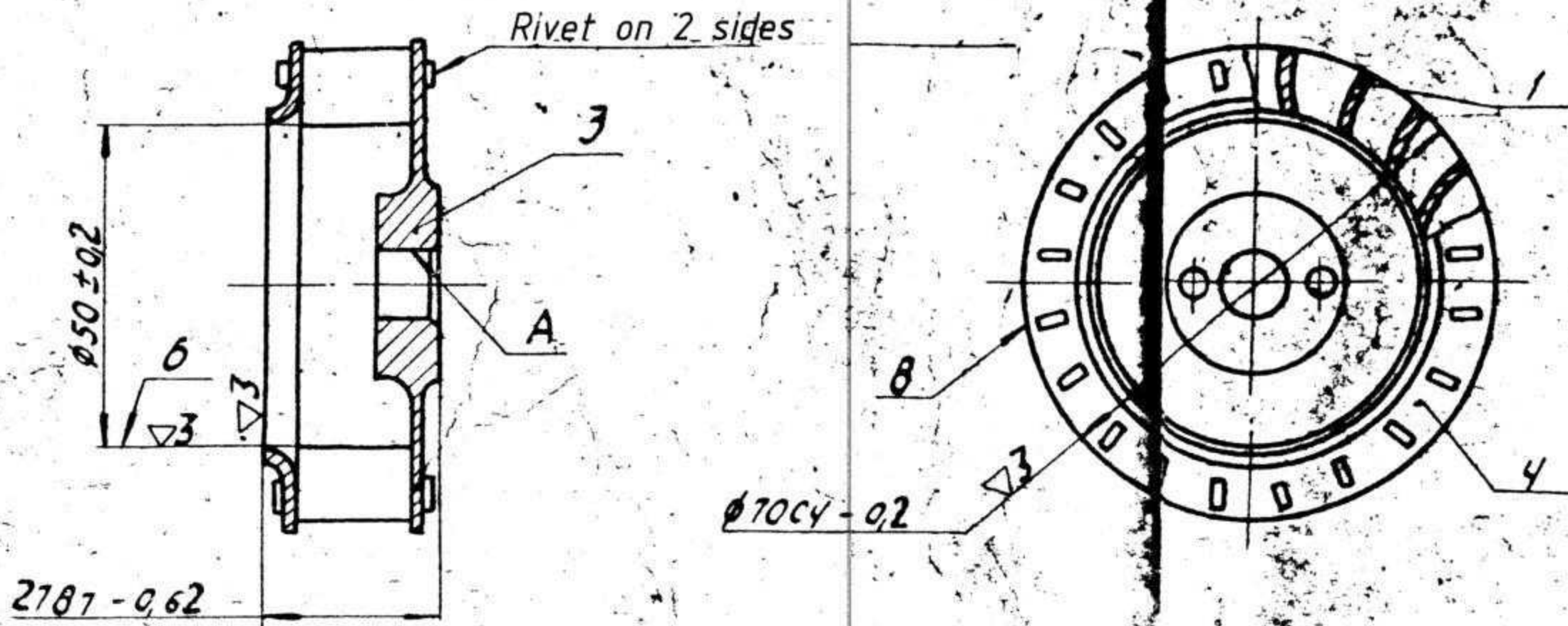
SNO	SHT	DOC NO	SIGN	DATE
DRAWN		CH.V.RAO.	Val	26.7.84
EDT, CHKD		A.ROOSEY	km	30.2.84
F/M, DC		S.R.NAIN	br	30.7.84
DIV.OFFR.		T.K.BANERJEE	Br	1.8.84
		NAME	SIGN	DATE

**BODY**  
**ASSEMBLY DRAWING**

SHEET WEIGHT SCALE	
0.49	
TOTAL SHEETS	
ORDANANCE FA PROJECT HYDERAB	

Ш.в. № подл. 08.4510  
 Подп. и дата 18/08/84  
 Взам. инв. № 95.31093  
 Инв. № подл.  
 Подп. и дата

765-71-11-591  
765-71-66425



- 1) Non-squareness of blades to plane of flange is 0,6 max. over length of blade.
- 2) Run-out of surfaces B and B with respect to axis of surface 'A' is 0,18 max (Qualified tolerance).
- 3) After rivetting and machining of blades, looseness and rocking of blades are not permitted.
- 4) Under cut of blades on surfaces 'B' upto 1 is allowed.

SURFACE FINISH

$\nabla_3$  - REPRESENTS SURFACE FINISH TO BE OBTAINED IN R<sub>a</sub> VALUE 20  $\mu$  MAXIMUM.

PILOT SAMPLE

THREE SAMPLES SHALL BE SUBMITTED TO CIFE PUNE FOR THEIR TEST AND APPROVAL BEFORE THE COMMENCEMENT OF BULK SUPPLY.

*(Signature)*  
( R VEERARAGHAVAN )  
SS0II

4	765-71-1446	Ring	20	
2				
3	765-71-1090	Flange	1	
1	765-71-349	Blade	20	
5	RNo.	Designation	Description	Qty
				Remarks

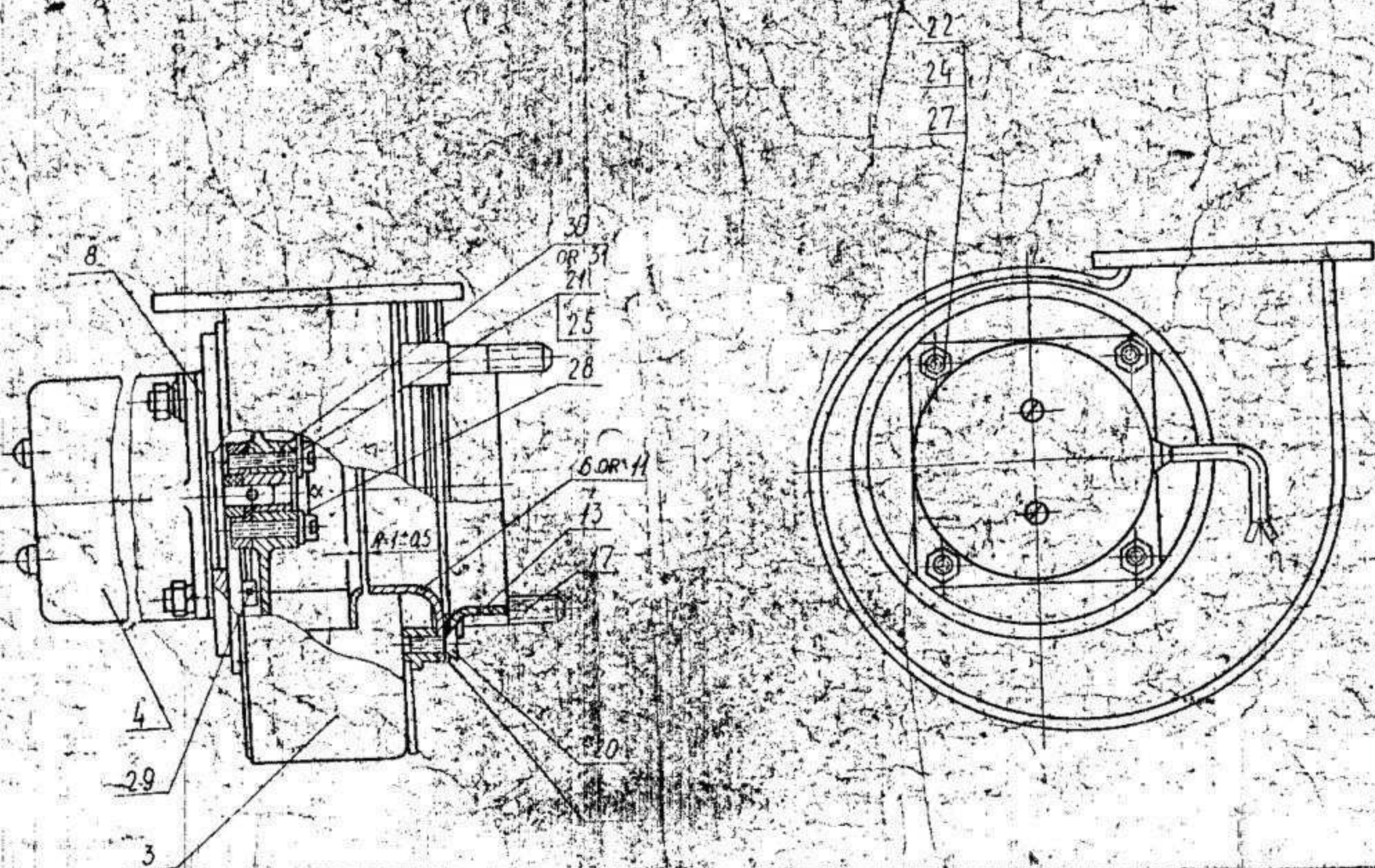
765-71-66425

SNO	ISHT	DOC NO	SIGN	DATE
DRAWN		Y.R.Ganesh	<i>(Signature)</i>	22.8.84
EDT, CHKD		<i>(Signature)</i>	<i>(Signature)</i>	29.8.84
F/M, DC		S.R.BAIR	<i>(Signature)</i>	31.8.84
DIV.OFFR.		T.K.BANERJEE	<i>(Signature)</i>	3.9.84
		NAME	SIGN	DATE

ROTOR

SHEET	WEIGHT	SCALE
1	0,050	1:1
TOTAL SHEETS		

95-35403  
 Изм. № дубл. Подп. и дата  
 Подп. и дата



1. All bolted joints should be tightened and locked.
2. Rotor should be freely rotated without jamming.
3. Clearance 'A' is to be adjusted by selecting spacers Ref.7.
4. Install studs on iron minimum GOST 8866-76.
5. Blower should be tested at a voltage of  $27 \pm 0.5$  V for three minutes. Current consumption is 4A max. Rotor should not catch with the non-moving parts.
6. Threaded joints should be smeared with lubricant LITOL-24 GOST 21150-75 or MC-70 GOST 9762-76 before the unit is assembled.
7. Requirements for power supply of the test stand are as per 765-C64, TY-2.

REFER NOTE 6  
 LUBRICANT LITHOL-24 (GOST 21150-75)  
 REFER TO DRG. NO. 675-71-C6 6 CD  
 REFER NOTE 7  
 COPY OF 765-C64, TY-2 ENCLOSED.  
 NOTE :- IRON MINIMUM  
 IRON MINIMUM IS A SUSPENSION OF PIGMENT (IRON OXIDE) GROUND WITH DRYING OIL WITH OR WITHOUT ADDITIVES.  
 PILOT SAMPLE

THREE SAMPLES SHALL BE SUBMITTED TO CIFE, PUNE, FOR THEIR TEST AND APPROVAL BEFORE COMMENCEMENT OF BULK SUPPLY.

(R. VEERARAGHAVAN)  
 ERO-II

REF. NO.	Designation	Description	QNT.	Remarks
21	672-35-3-02	Screw	2	Pieces when 765-71-C6425 and 765-71-1706 is used.
	Or			1706 is used.
	672-35-3-03	Screw	2	Pieces when 765-71-C6425 is used.
22	672-35-4-01	Screw	4	
		Thick iron minimum.		
17	700-29-621	Stud	2	
24	Nut M6.6 019 GOST 5927-70		4	
25	Washer 4.01.019 or 4.02.019 GOST 11371-78		2	
29	Wire K01 GOST 792-67 $\phi=320$		1	
28	Wire K01 GOST 792-67 $\phi=60$		1	
27	Washer 6 T 65F06 GOST 6402-70		4	
31	765-71-C6564	Rotor	1	1 Piece in set with parts 765-71-1507, 672-35-3-02 may be replaced by 765-71-C6425 or 765-71-1706 or 765-71-1710 in set.
30	765-71-C6425 or 765-71-1706 or 765-71-1710	Rotor	1	1 Piece in set with parts 765-71-359, 672-35-3-03. It is permitted to replace by 765-71-C6564 in set with part 765-71-1507.
20	Screw M4.8h6h x10.48.016 GOST 17475-72		6	
13	765-71-1089	Flange	1	1 Piece when 765-71-C6425 or 765-71-1706 or 765-71-1710 is used.
6	765-71-359	Flange	1	
11	765-71-1507	Flange	1	1 Piece when 765-71-C6564 is used.
8	765-71-551	Spacers	1	
7	765-71-362	Spacers	5	5 max.
4	765-82-C6283	Electric motor A-SSA (Modification)	1	
2	765-71-C6455	Body	1	
3	765-71-C6627	BODY	1	

765-71-C6497

**BLOWER**

DESIGNED BY	P.R. BABU	DATE	25.8.84
EDT. CHKD	P. R. NAIR	DATE	25.8.84
DIV. OFF. R.	P. R. NAIR	DATE	25.8.84
NAME	SIGN	DATE	

SHEET WEIGHT SCALE

