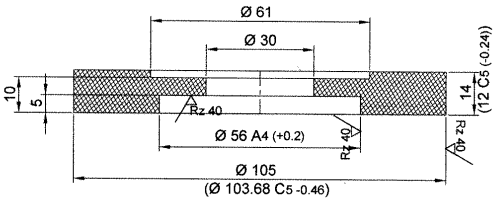
PHYSICAL MECHANICAL THERMAL AND ELECTRICAL QUALITY PARAMETERS OF TEXTOLITE	NORMS FOR GRADES OF TEXTOLITE PTK 'FIRST SORT'	NORMS FOR GRADES OF TEXTOLITE PT 'FIRST SORT'
1.TENSILE ELASTICTY MODULUS,MPa(Kgf/cm^2)	(3.9-6.4) -10^3 (40-65) -10^3	(3.9-6.4) -10^3 (40-65) -10^3
2.RELATIVE ELONGATION AT RUPTURE, %	1	1
3.COEFFICIENT OF FRICTION WITHOUT LUBRICATION WITH(OIL)LUBRICATION	 0.32 0.02	 0.32 0.02
4.SHEAR STRESS AT RUPTURE FOR SHEET OF THICKNESS FROM 2 TO 9 mm.MPa (Kgf/cm^2)	137 (1400)	117 (1200)
5.TENSILE STRESS AT RUPTURE,MPa(Kgf.cm/cm^2) FOR SHEETS OF THICKNESS FROM 1 TO 2 mm MORE THAN 2 mm	 39.0 (400) 93.0 (950)	 39.0 (400) 66.0 (680)
6.IMPACT STRENGTH k.J/m^2 (Kgf.cm/cm^2) FROM 5 TO 8mm FROM 8 TO 9 mm	19.5 (20) 24.5 (25)	14.5 (15) 19.6 (20)
7.ULTIMATE SHEAR STRENGTH,MPa (Kgf/cm^2) PARALLEL TO THE LAYERS PERPENDICULAR TO THE LAYERS	100.0 (1020) 108.0 (1404)	100.0 (1020) 93.0 (956)
8.TENSILE STRESS AT RUPTURE,MPa(Kgf/cm^2) ALONG WEFT	49.0 (500)	40.0 (410)
9.SPLITTING RESISTANCE kN/m (Kgf/cm^2) OF NOTCHED SPECIMENS	19.6 (20)	19.0 (19.5)
10.SHEAR STRESS AT RUPTURE,MPa(Kgf/cm^2) ALONG WEFT	95.0 (970)	90.0 (918)
11.COEFFICIENT OF THERMAL LINEAR DEGREE -1 (AT 20-100°C)	(2.0-4.1) -10^3	(2.0-4.1) -10^3
12.COEFFICIENT OF HEAT CONDUCTIVITY W/m.K(k.cal/hour.m.degree)		0.23 - 0.34 (0.20 - 0.29)
13.SPECIFIC THERMAL CAPACITY,J/Kg.K (k.cal/Kg.DEGREE) WATER ABSORPTION, % FOR SHEETS OF THICKNESS 1.0- 1.8 2.0 - 3.5 4.0 - 5.0 6.0 - 7.0 8.0 - 9.0	1.4654-1.5072 (0.35-0.36) 8 7 4 3 2	1.4654-1.5072 (0.35-0.36) 8 7 4 3 2
14.OIL STABILITY AT 20°C FOR A SOAKING TIME OF 24 HOURS %	0.06-0.08	0.08-0.018
15.STABILITY IN PETROL AT 20°C FOR A SOAKING TIME OF 24 HOURS,%	0.02	0.02
16.SPECIFIC SURFACE RESISTIVITY,Ohms	1.10^{10} - 1.10^{12}	1.10^{10} - 1.10^{12}
17.SPECIFIC VOLUME RESISTIVITY Ohm.cm	1.10^{10} - 1.10^{12}	1.10^{10} - 1.10^{12}
18.COEFFICIENT OF DIELECTRIC LOSSES AT 10^6Hz	0.02-0.08	0.02-0.08
19.DIELECTRIC CONSTANT AT 10^6Hz	5.7	5.7
20.DIELECTRIC STRENGTH AT 20±5°C,kV/mm	2 - 5	2 - 5
21.RESISTANCE TO CHEMICAL MEDIA (WITH REGARD TO CHANGE IN WEIGHT) % CONENTRATED SULPHURIC ACID 3% SULPHURIC ACID 10 % ALKALI 1 % ALKALI	 2.40 1.15 2.39 1.43	 1.20 0.94 1.68 1.08
22.OPERATING TEMPERATURE,°C	FROM -40 UPTO+105	FROM -40 UPTO+105

PHYSICAL AND CHEMICAL PARAMETERS OF TEXTOLITE GOST-5-78

PARAMETERS	NORMS FOR GRADES OF TEXTOLITE PTK 'FIRST SORT'	NORMS FOR GRADES OF TEXTOLITE PT 'FIRST SORT'
1. EXTERNAL APPEARANCE AND COLOUR	EVEN,SMOOTH SURFACE WITHOUT FOREIGN INCLUSIONS FROM LIGHT YELLOW TO DARK BROWN WITH DIFFERENT TINTS	EVEN,SMOOTH SURFACE WITHOUT FOREIGN INCLUSIONS FROM LIGHT YELLOW TO DARK BROWN WITH DIFFERENT TINTS
2. SAG,mm/m NOT MORE THAN	4	4
3. DEMSITY,g/cm^3	1.3 - 1.4	1.3 - 1.4
4. SHEARING STRESS AT RUPTURE MPa(Kgf/cm^2).NOT LESS THAN	147(1500)	142(1450)
5. TENSILE STRENGTH AT RUPTURE,MPa(Kgf/cm^2).NOT LESS THAN	98 (1000)	88 (900)
6. COMPRESSION STRESS AT RUPTURE MPa(Kgf/cm^2),NOT LESS THAN a)PARALLEL TO THE LAYER b)PERPENDICULAR TO THE LAYER	 152 (1550) 250 (2550)	 137 (1400) 235 (2400)
7. IMPACT STRENGTH kJ/m^2(Kgf,cm/cm^2) NOT LESS THAN	36 (37)	36 (37)
8. RESISTANCE TO SPLLITING ALONG THE THREAD OF THE WRAP kN/m(Kgf/cm),NOT LESS THAN ON UNNOTCHED SPECIMENS	195 (200)	183 (187)
9. MARTENSE HEAT STABILITY °C NOT LESS THAN	140	140
10. WATER ABSORPTION,% NOT MORE THAN	0.70	0.70



TECH. CONDITIONS

1. SUBSTITUTE FOR MATERIAL - TEXTOLITE ЛТК, GRADE 1, GOST 5-78
2. UNSPECIFIED LIMIT DEVIATIONS OF SIZES: FOR HOLES - ACCORDING TO A7, FOR SHAFTS - ACCORDING TO B7, OTHERS - ACCORDING TO CM7
3. ARRANGEMENT OF MATERIAL LAYERS - PERPENDICULAR TO PART AXIS.
4. BOIL CROWN IN OIL ACCORDING TO INSTRUCTIONS ИЛ-313-78
5. SIZES IN BRACKETS - AFTER ASSEMBLY.

(a)(c) EQUIVALENT MATERIAL
Grade F-3 IS: 2036-74

* TEXTOLITE ЛТ GRADE 1 GOST 5-78

(a)(b) AUTHY.: CQA(ICV) (letter no. 9006/ICV/IPD/V80116/MTPF/Q10 dated 17.11.09

VETTED
21 APR 2010
INSPECTION CELL

संख्या NO.OFF	विवरण DESCRIPTION	पुर्जा क्र. PART NO.	पदार्थ MATERIAL	मानक STANDARD	परिमाप DIMENSIONS	अभ्यक्ति REMARKS
			*			

	(c) AUTHY. LETTER NO. VQAWA/16/1/CEC Dt. 11-8-2010 (ADEG-01-15-2-1)	(a)	Equivalent material granted only for ord.fy, Mrdnk, IPD nos. OFMK/PC/43/V80118 dtd. 08.08.08 & OFMK/PC/43/W80058 dtd. 29.03.09 (Superseded)		04/11/09
		(b)	AUTHY.: LETTER NO. 02239/CQA (ICV) / PPD / ALT. COMM dated - 29/07/2010		17/11/09

सामान्य सहिष्णुता GENERAL TOLERANCE	
रेखिक परिमाप LINEAR DIMENSION	
0-6	±0.1
6-30	±0.2
30-120	±0.3
120-315	±0.5
315-1000	±0.8
1000-2000	±1.2
कोणिक परिमाप ANGULAR DIMENSION	
1-10	±1°
10-50	±30'
50-100	±20'
>100	±10'
मापांक 'न्यू एम' में VALUE IN "um"	
~	>25
▽	6-25
▽▽	1.6-6
▽▽▽	0.025-1.6
▽▽▽▽	<0.025

संख्या NO.OFF	संबंधित पुर्जोंका आरेखण क्र. DRG. NO. OF ASSOCIATED PART	सूचक INDEX	संशोधन ALTERATION	2008	दिनांक DATE	नाम NAME
				मापमान SCALE: NTS	आरेखित DRAWN: 25-03-08	Y.D.K.
					जाँचा CHECKED: 21/4	
					अनुमोदित APPROVED:	A.K.N.
					द्वारा बदला REPLACED BY	
					हेतु बदला REPLACED FOR	

CROWN (BLANK)

CODE-62

मशीनी औजार आदिरूप फैक्टरी, अम्बरनाथ
MACHINE TOOL PROTOTYPE FACTORY, AMBERNATH

कार्यालय OFFICE: D.O.

आरेखण क्र. DRAWING NO. 675-62-49-10

इन आरेखणो तथा इसके साथ की सम्पूर्ण सामग्री का स्वत्वाधिकार भारत सरकार रक्षा मंत्रालय की भारतीय आयुध निर्माणियों के पास है। भारतीय आयुध निर्माणियों के महानिदेशक की लिखित अनुमति के बिना इनकी नकल या किसी भी रूप में इनके उद्धरण या इनमें समाहित सूचना किसी अनधिकृत व्यक्ति को उपलब्ध नही कराई जानी चाहिए ।

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मूलमाप व अन्यायोजन NOMINAL SIZE & FIT | विचलन DEVIATION

UPTO DATED AS PER OLD VETTED DRG

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