

6

ALL 3.835.045

Документы  
Документация

22. АЦ 5.935.132.СБ

Assembly drawing  
Сборочный  
чертеж

Assembly units  
Сборочные

единицы

11 1 АЦ 6.439.034

Heating plate  
Пластина  
обогреваемая 1

Детали parts

13 2 АЦ 7.200.068-01

prism  
Призма 1

12 3 АЦ 7.842.074-01

Adhesive tape  
Пленка клеящая 1

4 02

Пленка клеящая 2

11 5 АЦ 8.684.121

Proкладка  
гайка 1

Other items  
Прочие изделия

14

Thermistor  
Термистор ТЭС-ДТ  
АВ 4.681.025/028 ТУ 1

UPDATED ON 19 68 TO IWM/DOC WMASSY-I

TNPO-170A  
AL-1

VETTED

04.7.16

OCF QA/DRG. OFFICE

АЦ 5.935.132

Heating resistor

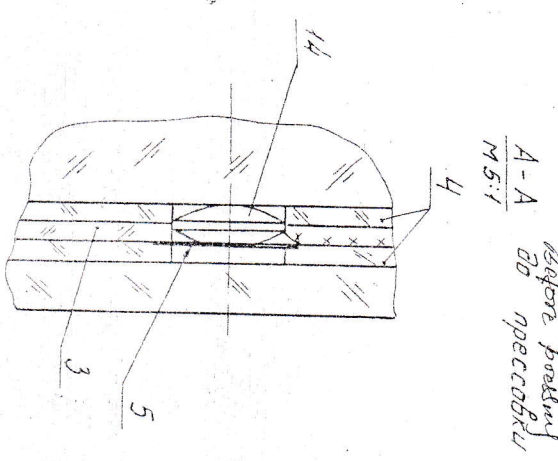
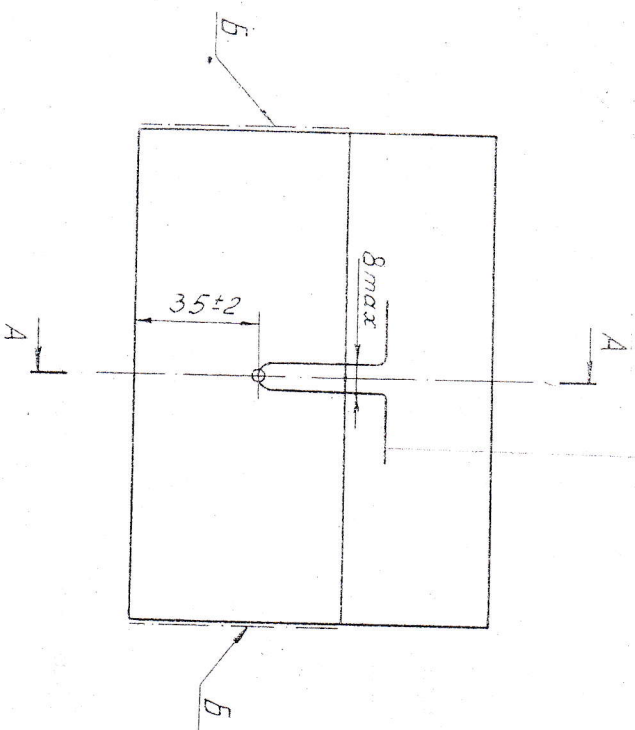
Призма

обогреваемая

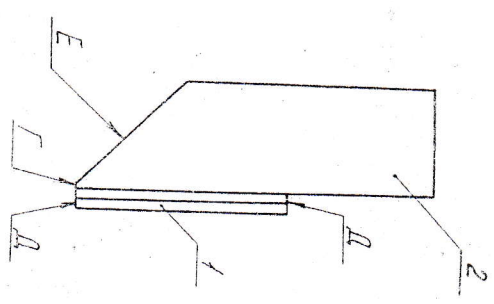
Удв. чина 4.201.290.87

Удв. чина 4.201.290.87

Удв. чина 4.201.290.87



9. Допускается использовать и адаптировать.  
 10. Остаются технические требования, как, например, по ТУ 3-3-834-78.



**YETED**  
 2016  
**OCF SAIDRG. OFFICE**

Устройство в соответствии с требованиями  
 1. Согласно требованиям к материалу изготовления  
 2. Согласно требованиям к материалу изготовления  
 3. Перед началом работы необходимо проверить  
 4. Проверка материала изготовления  
 5. Проверка материала изготовления  
 6. Проверка материала изготовления  
 7. Проверка материала изготовления  
 8. Проверка материала изготовления

Температура, °C	19°	20	21	22
Температура, °C	19°	20	21	22
Скорость, м/мин	5000-7500	4865-7300	4730-7100	

8. Местное выделение тепла  
 ТУ 6-05-011-805-83  
 9. Местное выделение тепла  
 ТУ 6-05-011-805-83

УДАЛЕНА НА 19.07.2016

№	Имя	Фамилия	Должность	Дата
1	Иванов	Иван	Инженер	19.07.2016
2	Петров	Петр	Инженер	19.07.2016
3	Сидоров	Сидор	Инженер	19.07.2016
4	Куликов	Кулик	Инженер	19.07.2016
5	Лебедев	Лебед	Инженер	19.07.2016
6	Зиничев	Зинич	Инженер	19.07.2016
7	Березин	Берез	Инженер	19.07.2016
8	Рябенко	Рябен	Инженер	19.07.2016
9	Григорьев	Григор	Инженер	19.07.2016
10	Федотов	Федот	Инженер	19.07.2016

FOCT 2.113-75

FORMAT	ZONE	REF. NO.	Designation	Description	Quantity per article	AUG 6. 439. 034																	
					01																		
				Technical papers.	X	X																	
			AUG. 439. 034 C6	Assembly drawing.																			
				Parts																			
				Bus-bar.	2	2																	
			AUG 7. 755. 084																				
				Plate.	1	1																	
			AUG 8. 640. 130																				

UPDATED ON 19 08  
 SWM/Doc  
 WMP/ASST

CODE	LETTER
2	

UPDATED UP TO 4-12-92 COMBO  
 updated upto 12-12-90 WMP/DO  
 HOOD RD A-1-1  
 TWP/DO

UPDATED UP TO 30.10.88 RWP/DO

DRAWN P.R.BABU 8884

EDT/CHK A.K.D. 08/84 16.1.84

F/M D.C. SRINAIR 16.5.84

APPROVED T.K.BANERJEE 22.8.84

HEATING  
 PLATE

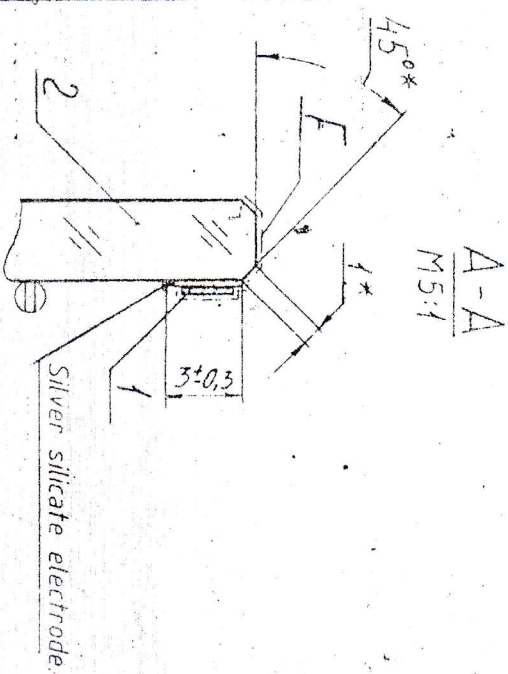
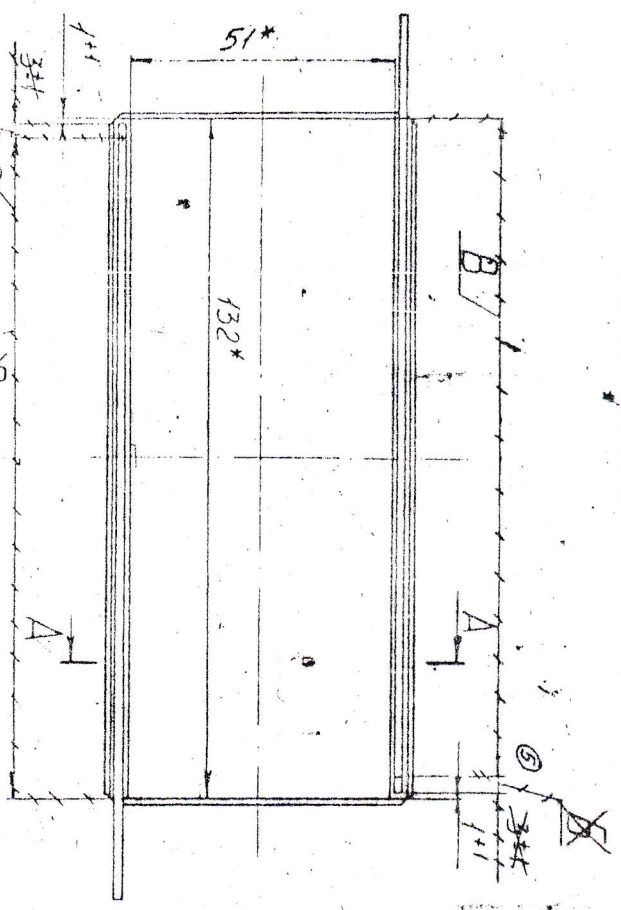
VETTED  
 PROJECT  
 HYDERABAD-500001

5

97450.624.917A

Справочный №	№ОР МАТЕРИАЛ
ТНП-170А-080 СБ	АУ5.935.079

№ и год	№ и год	ВЗДМ №	№ и год	№ и год
17702-28	140.5.79	17356-29		



1(2) } UPDATED  
 AL-35 } upto 4-12-92  
 Wmido

1. 102NAS PER OST 3.1901-85 ①
- ① Current conducting film SnO<sub>2</sub> 4-5 0.01 to 0.03 mm thick on to the current-conducting coating along the total length.
3. Harden plate with electrodes. Degree of hardening should not be less than 0.7 N/cm.
4. Paste the bus-bar using current-conducting adhesive with nickel filler. 041-80S-83
5. Apply precoat NC-4, TY 6-05-1163-75, on surface F along the total length of plate.
6. \*Dimensions are given for reference.
7. Other technical requirements are as per Technical Specifications TY 3-3.834-78.

**VERTED**  
 24.7.16  
**OCF QA/DRG. OFFICE**

Designation.	Resistance of current-conducting coating Ohm.
AUG.439.034 CB	Ensure requirement specified in Item-1, drawing AU5.935.079-65.132 CB ①
-01CB	Ensure requirement specified in Item-1, drawing AU5.935.080 CB

UPDATED UPTO 01.09.08  
 JMW/DOE/VMM/SS-I

updated upto 12-12-92 Wmido

UPDATED UPTO 20-10-88 Wmido

DESIGN DOC NO	SIGN	DATE
R.RABAU		8.8.84
EDICHO		14.9.86
F.M.D.C.	S. R. NAIR	11.8.93
DIV/DR	T. K. BANNERJEE	20.8.07

HEATING PLATE  
 (ASSEMBLY DRAWING)

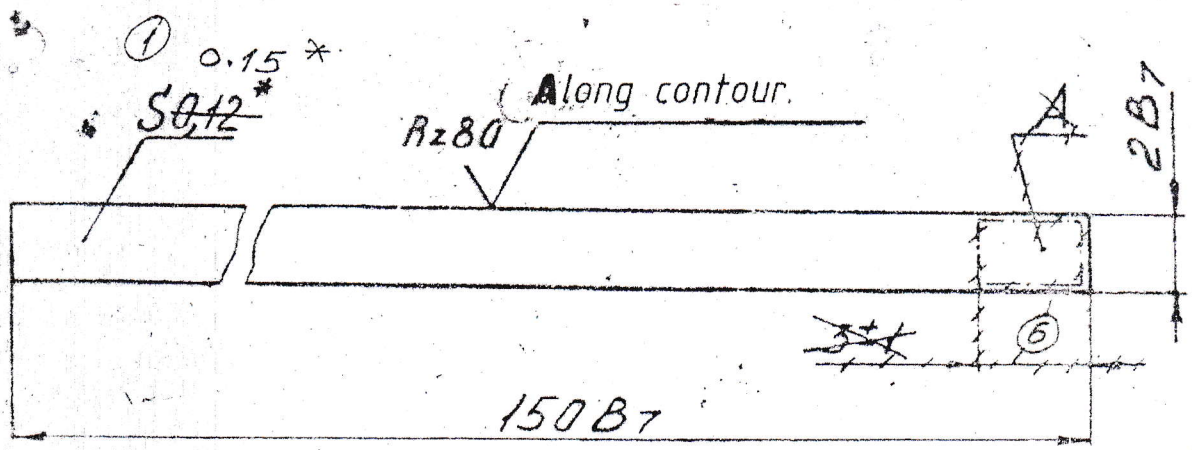
SHEET/WEIGHT/SCALE

4	0076	1:1
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ROYAL SHEETS  
 ORDNANCE FACTORY  
 PROJECT  
 HYDERABAD

40021KD AL-1

4 (✓)



17355-31  
 17762-30  
 17355-31  
 17762-30  
 17355-31  
 17762-30

1. Perform vacuum annealing for heat treatment. Check the degree of annealing on samples with dimensions 20 x 60 mm, as per GOST 1173-77 taking 2. pieces from each batch.

2. Deformation and burrs are not allowed.

3. \*Dimension is given for reference. PICKLING

① 4. Etch. Minimum thickness, after [etching] is 0.09 mm.

6. Local darkening and temper colours are not allowed.

① 4. ETCHING IS ALLOWED. MINIMUM THICKNESS AFTER ETCHING 0.12 mm. NECESSITY FOR ETCHING IS DETERMINED BY TECH PROCESS

② MAT. - COPPER STRIP IS: 1897 OF MATERIAL CATHOD COPPER OF IS: 191 PL.(IV) - HD CONDITION

**VETTED**

04-7-16

**COE CADRG. OFFICE**

I 1456-3A

UPDATED UPTO Dt 11/02 JWM/DO DGM/MCP

1(4)AL.35

UPDATED UPTO 4-12-92 WM/DO

② DA-4-36-99 Dt 13/99 JWM/DO WM/TS

updated upto 12-12-90 WM/DO

40021KD AL-1  
 AL7.755.084 T.M.P.O. 170A

**BUSBAR**

SHEET WEIGHT SCALE

4 0.0004 5:1

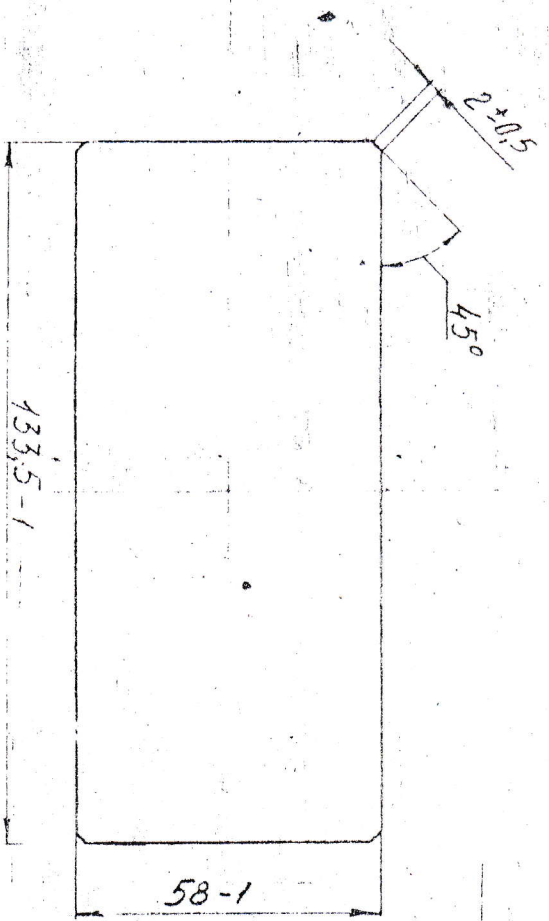
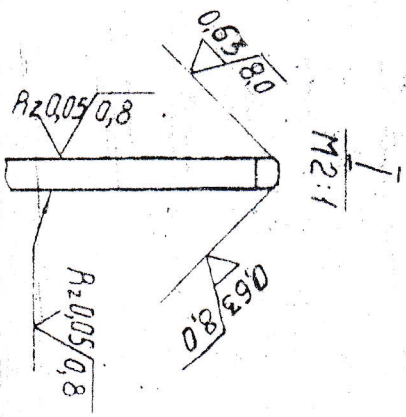
OSHI/DOC NO	SIGN	DATE
AWN P.R.BABU		3.8.84
CHKD A.R. DUDGAT		14.8.84
F/M, DC. S.R. NAIR		14.8.84
DIV. OFFR T.K. BANERJEE		22.8.84
NAME	SIGN	DATE

BAND AL-9, SPHT 0.15  
 ② FOCT 1173-77. H.A.M.1  
 IS-1897 Cathode Cu ①

TOTAL SHEET  
 ORDNANCE FACTORY  
 PROJECT  
 HYDERABAD

№ подл.	№ документа	ВЗМ. №	УКВ. №	№ документа
17752-38	17752-38	17356-39		

Сред. документ №	№ документа
ТНТО-170А-015	АЛС.439.054



1. Rib chamfers should be equal to  $0,3 + 0,5 \times 45^\circ$  except specified places.
2. Non-striation and other technical requirements are as per Technical specifications TY 3-3834.78.

$\Delta n_e$	5
$\Delta(n_e - n_c)$	5
Homogeneity	5
Double refraction	-4
Attenuation	8
Non-striation	*
Bisterness	7E
P	VII

UPDATED UPTO DTG 08  
 UPDATED UPTO DTG 10  
 UPDATED UPTO DTG 12

Updated upto 12-12-90

EDIC/KD	PR/ABU	SIGN	DATE
PR/DC	SR/ABU	SIGN	DATE
DIV/OFFR	TK/ABU	SIGN	DATE

**VERIFIED**  
 OCF Q/DRG. OFFICE

U0021KD AL1  
 448.640.130

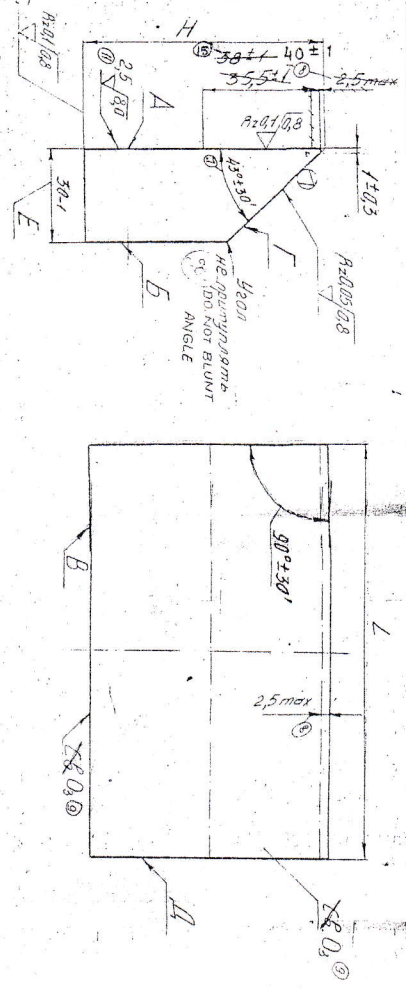
PLATE

CLASS JK-105  
 FOCT 3514-76

SHEET WEIGHT	SCALE
0,06	1:1

ORDNANCE FACTORY  
 PROJECT  
 HYDERABAD

890 002 277A



DESIGNATION	H.M.M. (in)		L.M.M.		Machined Weight
	NOMINAL	LIMIT DEVIATION	NOMINAL	LIMIT DEVIATION	
ALLI-200 058	78	-4.5	135	-1.0	0.85
	99		134.5		

6. COATING OF SILVERED CHAMFER SURFACES BAKELITE VARNISH JBC-1, GRADE 7, GOST 901-78 WITH FILERS: INDUSTRIAL CARBON OF GRADE П 805, GOST 7885-77E, AND TALC TP7H, GOST 1928-74 AND AFTER THAT - BAKELITE VARNISH JBC-1 GRADE 1 WITH FILERS: TITANIUM DI-OXIDE P-02 OR A-1 GOST 9808-84 AND TALC TP7H.

- ALTERNATE MATERIAL - GLASS K100 GOST 3514-76
- ANGLE BETWEEN SURFACES A AND D, B AND D, F AND A -  $90^\circ \pm 30'$
- CHAMFERS ON EDGES 14.05 X45° EXCEPT PLACES INDICATED SPECIALLY CHAMFER ON ANGLES  $2^\circ 10' X45^\circ$
- EDGE ALONG DIMENSIONS LAND E SHOULD BE WITHIN LIMIT OF HALF THE TOLERANCE ON DIMENSIONS.
- $\phi 25$  P. 3E 72 П GOST 3-1901 85
- COATING OF SILVERED AND ROUND SURFACES BY BAKELITE VARNISH JBC-1 GRADE 1 GOST 901-78 WITH FILERS: INDUSTRIAL CARBON GRADE П 805 - GOST 7885-77E.
- AFTER THIS BAKELITE VARNISH-TITANIUM DIOXIDE P-02 OR A-1 GOST 9808-84 AND TALC TP7H.
- INSULATION RESISTENCE OF VARNISH COATING IN RELATION TO COPPER LAYER SHOULD BE NOT LESS THAN 20 MEGA OHM.
- NONSTRIATION AND THE REST TECHNICAL REQUIREMENTS AS PER TS 5-3834-78.

Q	4	ALL 282-91-28	2.612	40021 KD	AL-1	INR0-170
1	2	75-80	2.612	DRG. No. AU 7200 058		
2	4	95-100	2.612			
3	6	30M 350-78	2.612			
4	8	30M 350-78	2.612			
5	10	30M 350-78	2.612			
6	12	30M 350-78	2.612			
7	14	30M 350-78	2.612			
8	16	30M 350-78	2.612			
9	18	30M 350-78	2.612			
10	20	30M 350-78	2.612			
11	22	30M 350-78	2.612			
12	24	30M 350-78	2.612			
13	26	30M 350-78	2.612			
14	28	30M 350-78	2.612			
15	30	30M 350-78	2.612			

UNE	5
A(MF-NC)	5
HOMOGENEITY	5
DOUBLESIGHT	5
ATTENUATION	7
NONSTRIATION	*
BUBBLING	3T
P	3T

**VETTED**  
 04.7.16  
 OCF QA/DRG. OFFICE

440 2482.7A

FIGURE NO.1

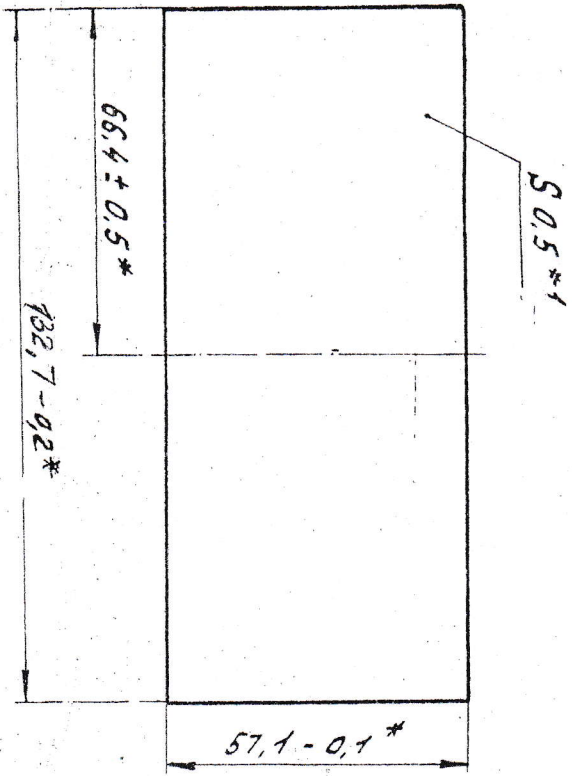


FIGURE NO.2

THE REST SEE FIG. 1

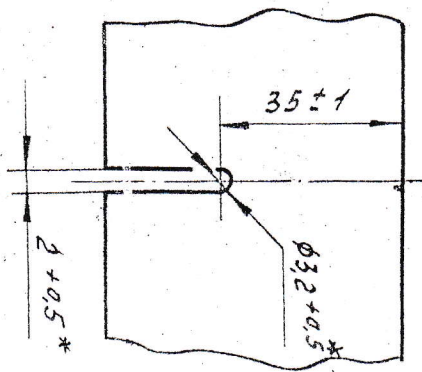
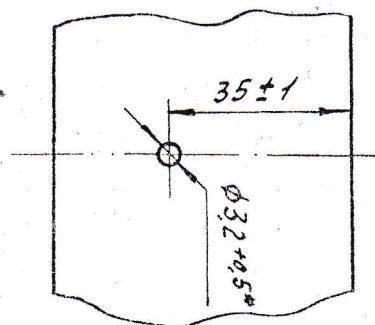


FIGURE NO.3

THE REST SEE IN FIG.1



- 1. \* DIMENSIONS SHOULD BE ENSURED BY TOOL.
- 2. \*1 DIMENSION FOR REFERENCE.

**VETTED**

OCF QA/DRG. OFFICE

DESIGNATION	FIGURE	WEIGHT
AU 7.842.074	1	0.0046
-01	2	
-02	3	0.0045

UPDATED UPTO DT1978  
 \* (MATERIAL)  
 UPDATED UPTO 4-12-92 W/M/D  
 Updated up to 12-12-90 W/M/D

7	ALL 598-86	10/24/78
6	Jan 20/87-85	10/24/78
5	10/24/78	10/24/78
4	10/24/78	10/24/78
3	10/24/78	10/24/78
2	10/24/78	10/24/78
1	10/24/78	10/24/78

GROUP No. 40021KD FOLDER/SHEET No. 18/27

DRG. No. AU 7.842.074

ADHESIVE FILM

IS: 7078-78g Rv B.

17% Dibutyl Sebracate

FILM A-170.5 X1000

MATERIAL GOST 9438-85

SHEET WEIGHT SCALE

OPTO ELECTRONICS FACTORY DEPRADUM

24085 12.03.85