

АЦ 3.895.045

Documents
Документация

13 АЦ 5.935.080 СБ

Assembly drawing
Сборочный
чертеж

Assembly units
СБОРОЧНЫЕ
ЕДИНИЦЫ

11 1 АЦ 6.439.034-01

Heating plate
Пластина
обогревная 1

Details parts

13 2 АЦ 7.200.068

Prism
Призма 1

12 3 АЦ 7.842.074

Adhesive tape
Пленка клеящая 2

14.09.81 47462-24a

UPDATED ON 19/10/08 JWM/DOC WMM/ASSY-I

VETTED
24.7.16
CCF QA/DRG. OFFICE

40021 KD AL-01

11 301 АЦ 426 878 уа - 1009.81

АЦ 5.935.080 ТНР 0-170

Heating prism
Призма
обогревная

A 1

NOCT 2/13-15

FORMAT	ZONE	REF. NO.	Designation.	Description.	Quantity per article:	REMARKS
					- 01	
				Technical papers.		
13			ALG. 439.034C6	Assembly drawing.	X X	
				Parts		
11		1	ALG. 755.084	Bus-bar.	2 2	
12		2	ALG. 8.640.130	Plate.	1 1	

Quantity per article: ALG 6.439.034

CODE LETTER

UPDATED UPON 4-12-92 WMP/DO
 updated upto 12-12-90 WMP/DO sub sp.

UPDATED UP TO 20-10-88 AWM/DO

DRAWN	PRBABU	8.8.84.
EDT&CHK	A. D. DAS	16.1.14
F/H. D.C.	SRINAIR	16.5.84
APPROVED	K. BANERJEE	22.9.84
NAME		SIGN

ALG 6.439.034

HEATING

PLATE

VETTED

OCF Q/DRG. OFFICE

28.11.16

TNP/DO

SHEET	WEIGHT	SCALE
4		

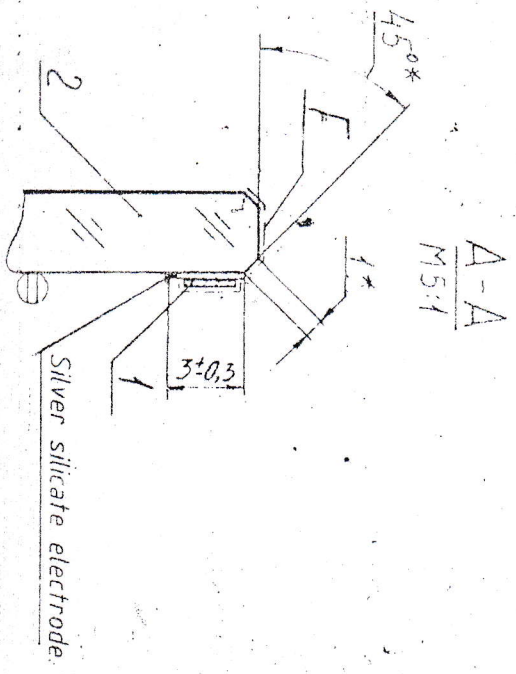
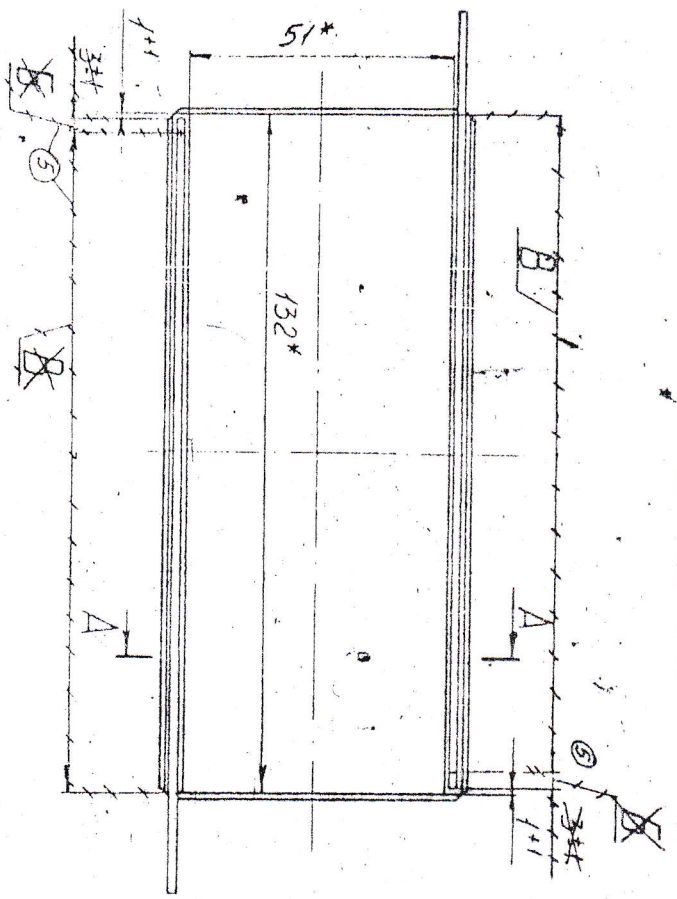
ORDINANCE FACTORY
 PROJECT
 HYDERABAD-500081

UPDATED ON 19/08

WMP/DO
WMP/DO

07460.634.017A
AU6.439.034CB

(5)



1(2) } UPDATED
AL-35 } UPTO 4-12-92
WMD

1. 102NAS PER OST 3.1901-85 (1)
2. Current conducting film SnO₂ 0.01 to 0.03
3. Apply silver silicate electrodes, 0.02 to 0.04 mm thick on to the current-conducting coating along the total length.
4. Harden plate with electrodes. Degree of hardening should not be less than 0.7 N/cm.
5. Paste the bus-bar using current-conducting adhesive with nickel filler. 0.4-805-83
6. Apply precoat NC-4, TY 6-05-463-75, on surface F along the total length of plate.
7. *Dimensions are given for reference.
8. Other technical requirements are as per Technical Specifications TY 3-3.834-78.

VETTED
CCT CAIDRG. OFFICE
20.7.16

Designation.	AU6439.034 CB	Resistance of current-conducting coating. Ohm.
	-01CB	Ensure requirement specified in Item-1 drawing AU5.935.079-EB. 132 CB (1)
		Ensure requirement specified in Item-1 drawing AU5.935.080 CB

UPDATED UPTO 04/12/92 WMD
updated upto 12-12-92 WMD
I 1456-392
40021 R-1

SNOSHIDOCNO	PKRABU	SIGN	DATE	8886
EDICHO	01-0084			11-89
P/M, DC	S-R NAIN			11-89
DIVOFFR	T.K. SENERE			12-88

HEATING PLATE (ASSEMBLY DRAWING)

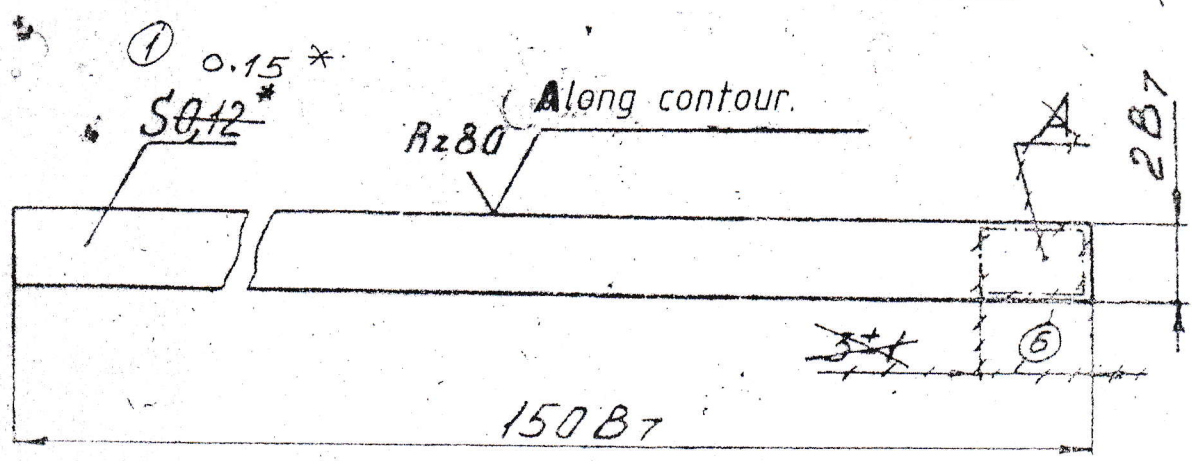
SHEETWEIGHTSCALE	4	0076	1:1
ORDNANCEFACTORY PROJECT HYDERABAD			

Унар. н. номер	Подп. и дата	Взлом. н.р. №	Унар. н. номер	Подп. и дата
17762-28	14.05.79	17356-29		

Справочный №	номер проекта
ТНП-170А-060 СБ	АУ5.935.079

40021KD AL-1

4
D (V)



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~~ ^{PICKLING} 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
24.7.16
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I 1456-3A

UPDATED UPTO Dt 11/02/92 JWM/DO HGM/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 Sol. Exp.

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

OSHT/DOC NO	SIGN	DATE
AWN	P.R.BABU	3.8.84
TECH/KD	A.R. DUDGA	14.8.84
F/M, DC.	S.R. NAIR	14.8.84
DIV. OFFR	T.K. BANERJEE	22.8.84
NAME	SIGN	DATE

BUSBAR
BAND ~~AL~~ ^{AL} PHT 0.15
FOCT 1173-77. HSN 77
IS: 1897 Cathode Cu ①

SHEET	WEIGHT	SCALE
4	0.0004	5:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

Справочный №
ТН 170-170А-316

11.419

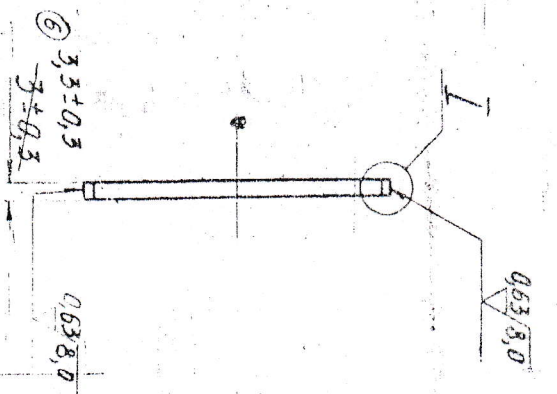
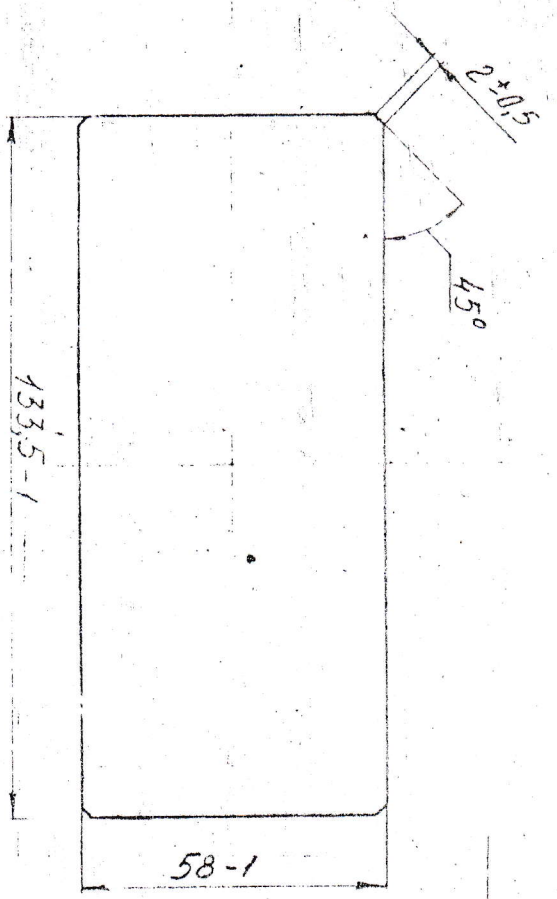
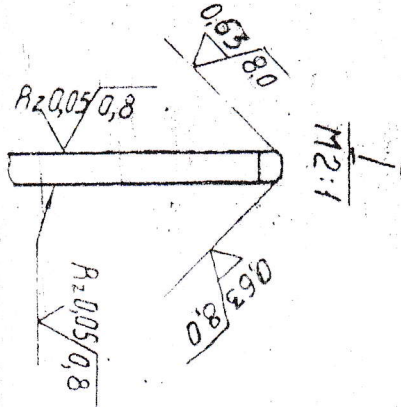
17356-31

17762-30

УКВ № докум.	Родн. и дата	Знач. УКВ №	УКВ № докум.	Родн. и дата
17762-38	01.04.48	17356-39		

Стр. документа №	Листов
ТН170-170А-015	АЦВ.439.034

3



Δn _e	5
Δ(n _e ² -n _o ²)	5
Homogeneity	5
Double refraction	4
Attenuation	8
Non-stratification	*
Blisterness	7E
P	VII

1. Rib chamfers should be equal to 0,3 + 0,5 x 45° except specified places.
2. Non-stratification and other technical requirements are as per Technical specifications TY 3-3834.78.

UPDATED UPTO 01/9/10
 08 JWM/DOC
 W/M/ASSY-I

UPDATED UPTO 4/12/92
 348-11 JWM/DOC

Updated upto 12/12/90

UPDATED UPTO 20.10.88
 8884

EDICHECKED	DATE	SIGN	DATE
DRAWN	DATE	SIGN	DATE
F/M, DC	DATE	SIGN	DATE
DIVOFFER	DATE	SIGN	DATE

VETTED
 24.7.16
OCF Q/DRG. OFFICE

U0021KD AL1
 448.640130
 TNP013018
 (4A)

SHEETWEIGHT SCALE	
A	0,06
TOTAL SHEETS	
1/1	
GLASS JK-105	
FOCT 3514-76	
ORDNANCE FACTORY PROJECT HYDERABAD	

031 0492110

0,63/8,0

4LD 2482.7A

FIGURE NO.1

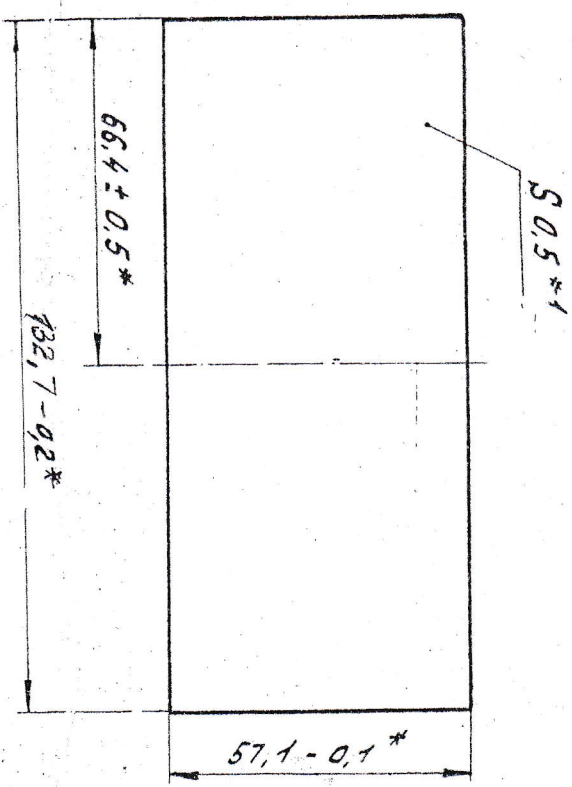


FIGURE NO.2
THE REST SEE FIG. 1

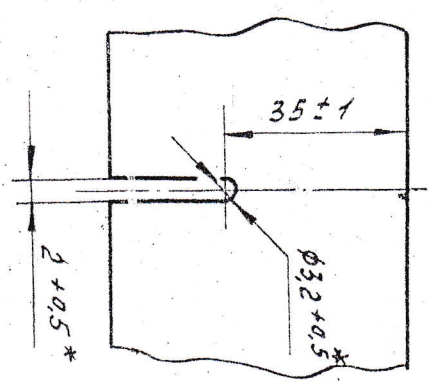
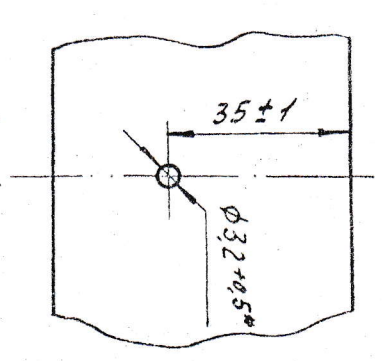


FIGURE NO.3
THE REST SEE IN FIG.1



DESIGNATION	FIGURE	WEIGHT
AU 7.842.074	1	0.0046
	2	
	3	0.0045

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

VETTED

OCF CAD/DRG OFFICE

UPDATED UP TO DT19 10⁰⁸
 * (MATH. OLC)
 UPDATED UP TO 4.12.92 km/100

40021KD AU-1
 GROUP No. 40021KD FOLDER/SHEET No. 18/27

24085 12.03.85. P. B. B. B.

7	МЛ 590-86	280x120x10
6	Сам. 100187-85	3x10x10
5	Полоска 9.0x0.5x10	
4	Полоска 9.0x0.5x10	
3	Полоска 9.0x0.5x10	
2	Полоска 9.0x0.5x10	
1	Полоска 9.0x0.5x10	

IS: 7078-82a P.V.B.	
* 17% отбыл Sabracate	
FILM A-1705 X1000	
MATERIAL 60ST 9438-85	
OPTO ELECTRONICS FACTORY	
GEPRADUN	