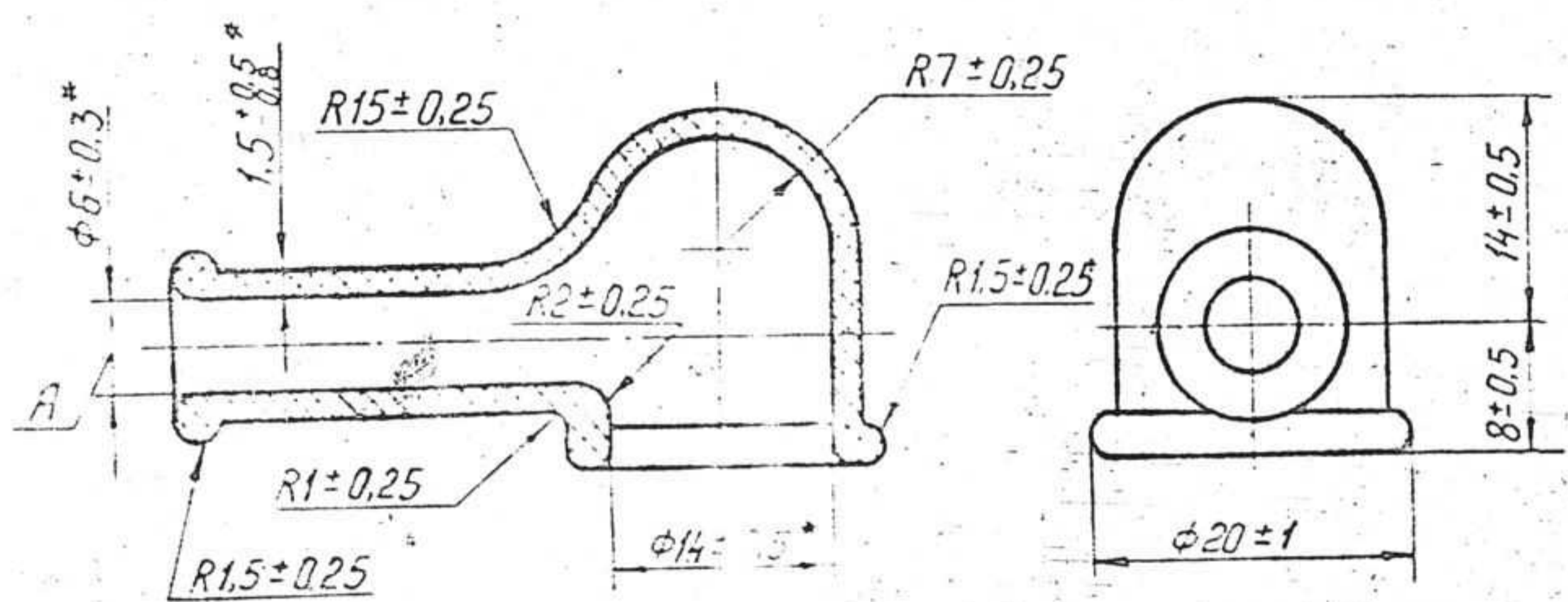
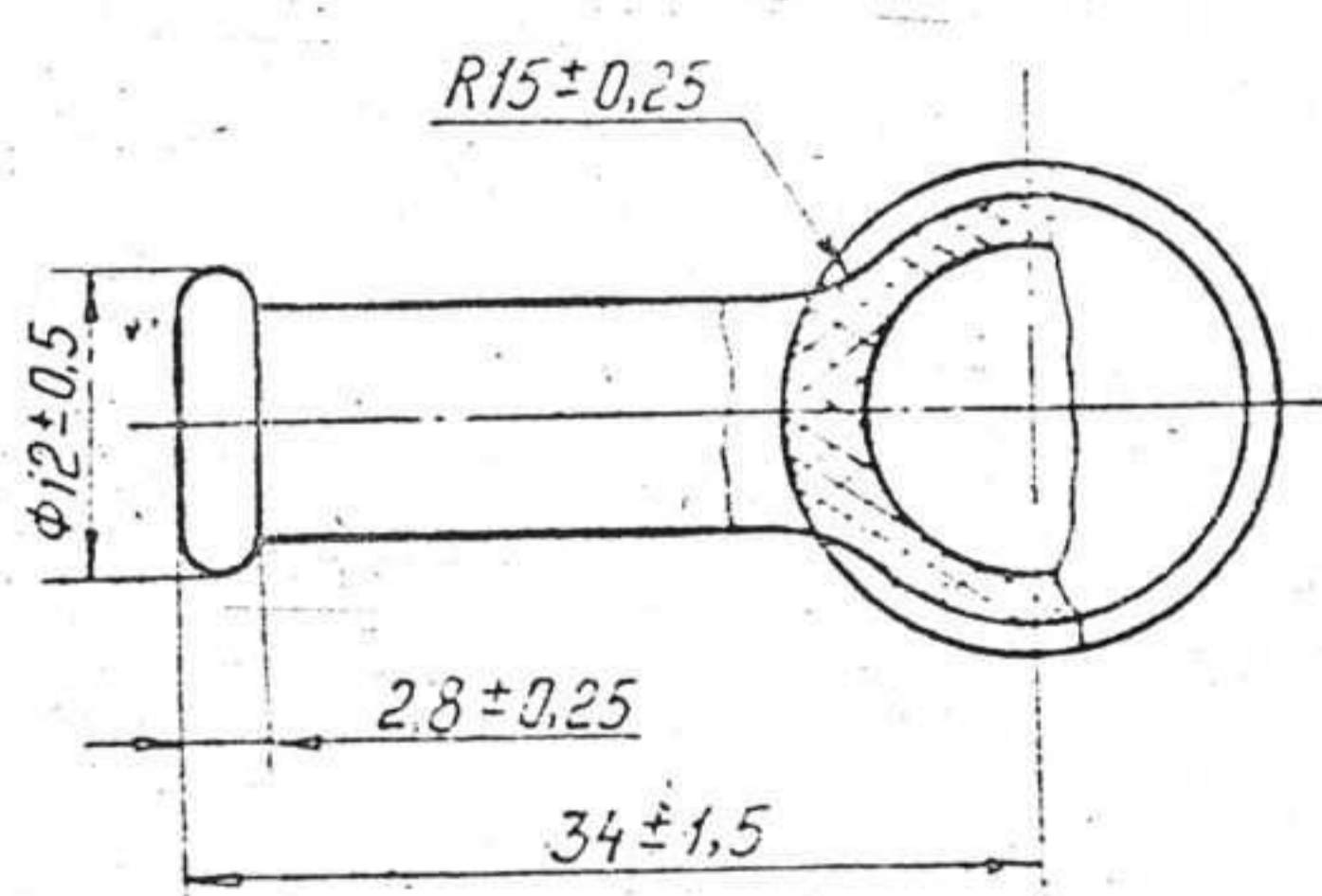


33-01-01

MH-1



1. Provide all dimensions, except dimensions having symbol * with tool, checked periodically once per quarter.
2. At the place of intersection of diameter A with $\phi 14 \pm 0.5$, it is allowed: sharp corner with burr up to 1mm, swelling at places of crossing of diameters, and tear outs to a depth not exceeding 1mm, with total length up to 1/3 of circumference.
3. Other technical requirements as per TY 105 431-77.



33/D-602 ECKD

CA-18-66

RUBBER CAP

SNOSHT	DOC NO	SIGN	DATE
DRAWN	S. Gopal		12/12
EDT, CHK	A. Kundu		13/12
F/M, DC	S. R. Nair		14/12/80
DIV. OFFR	A. K. KUNDU		20.85
	NAME	SIGN	DATE

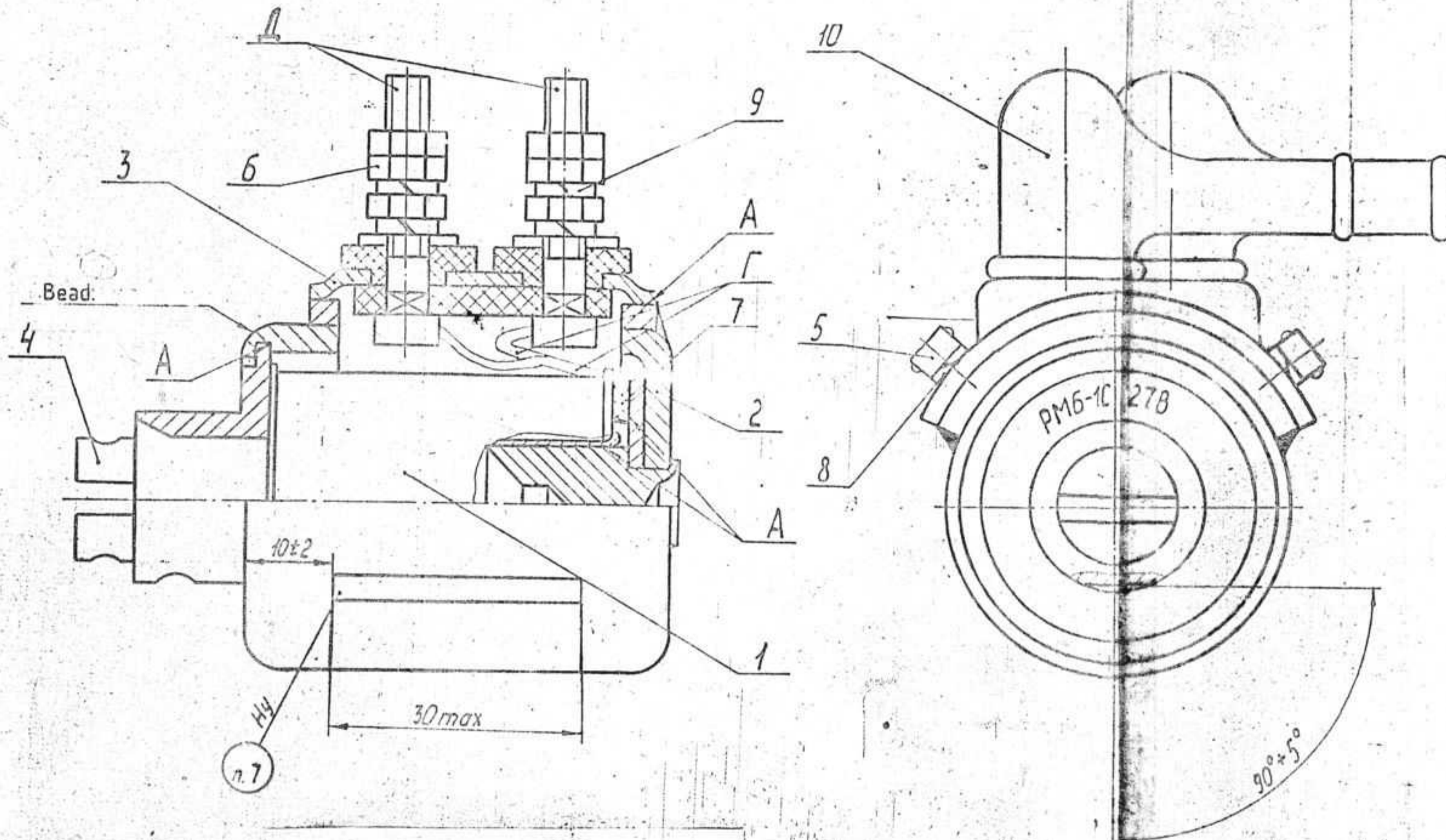
SHEET	WEIGHT	SCALE
5	4.52	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

Soft rubber.

Easy2Convert www.easy2convert.com

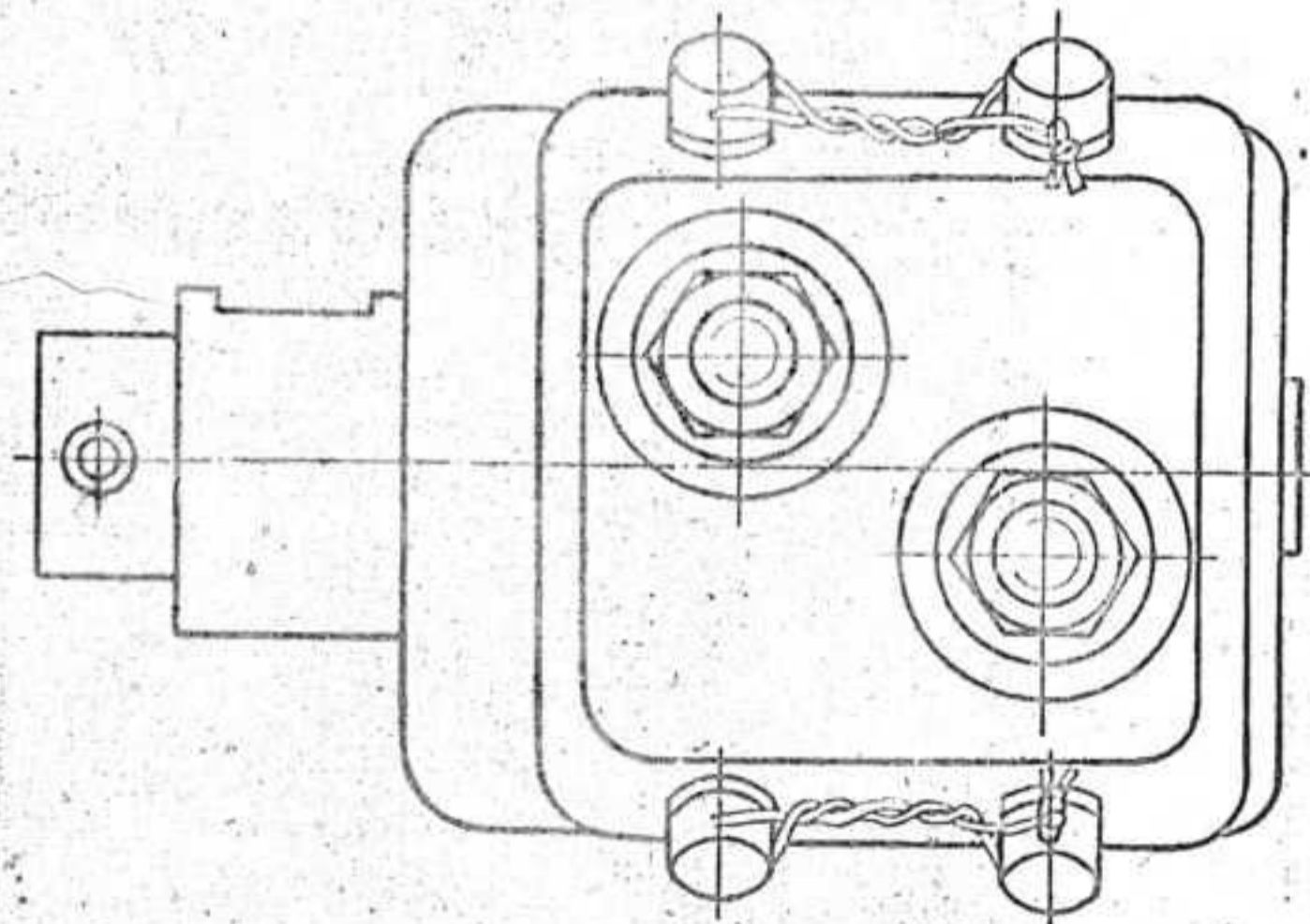
18813 (1700n) 11.5.75 4664

Rubber cups are not shown.



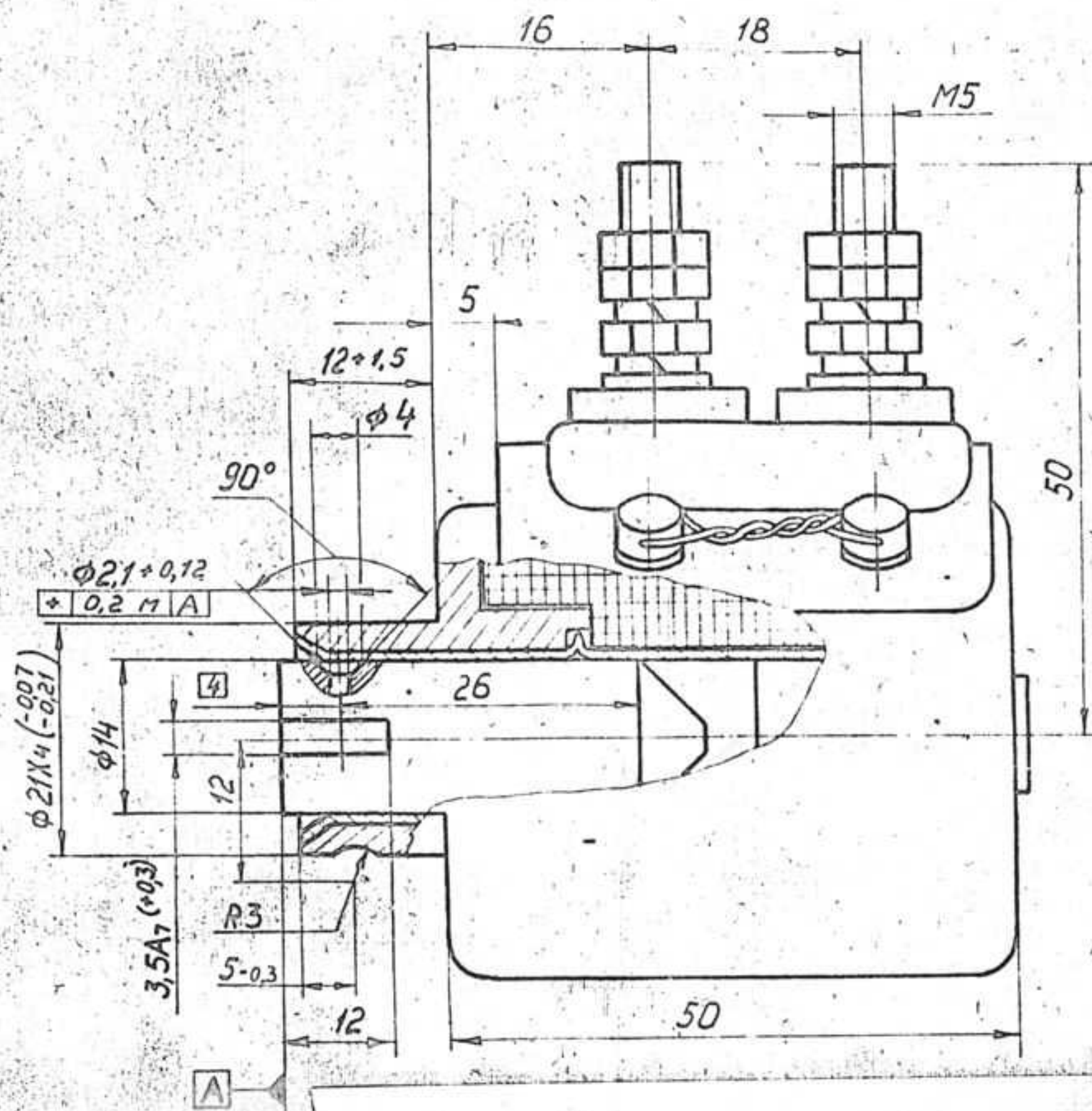
- 1 Before beading, punch casing with core, Ref 2., at places of bushing grooves of coil. Ref. 1. After punching through slots are not allowed.
- 2 Braze tap Г in-to slots of bolts Δ with solder ПОССУ40-2. GOST 21930-76 WITH flux ФКСn, OST 4. GO.033.000. Tap ends should not come out the limits of bolt head diameter.
- 3 Apply compound prepared as per instructions И-109-78 to places A.
- 4 Bind screws, Ref. 5. with wire, Ref 11, from each side.
- 5 Coat beaded places of painted parts with black enamel M17TY6-10-1012-78.
- 6 Coat with gray enamel XB-124, GOST 10144-74.
- 7 Mark without type 3 as per NO.010.007 to a depth of 0,5mm apply marking, prior to relay Assembly. Coat marking with varnish ИЦ-134. TY6-10-1291-77.
- 8 Traction relay should match PM6-1C.000TY
- 9 Coil should not have axial displacement, adjust by mounting a required number of rings, Ref. 7.

Rubber cups are not shown.

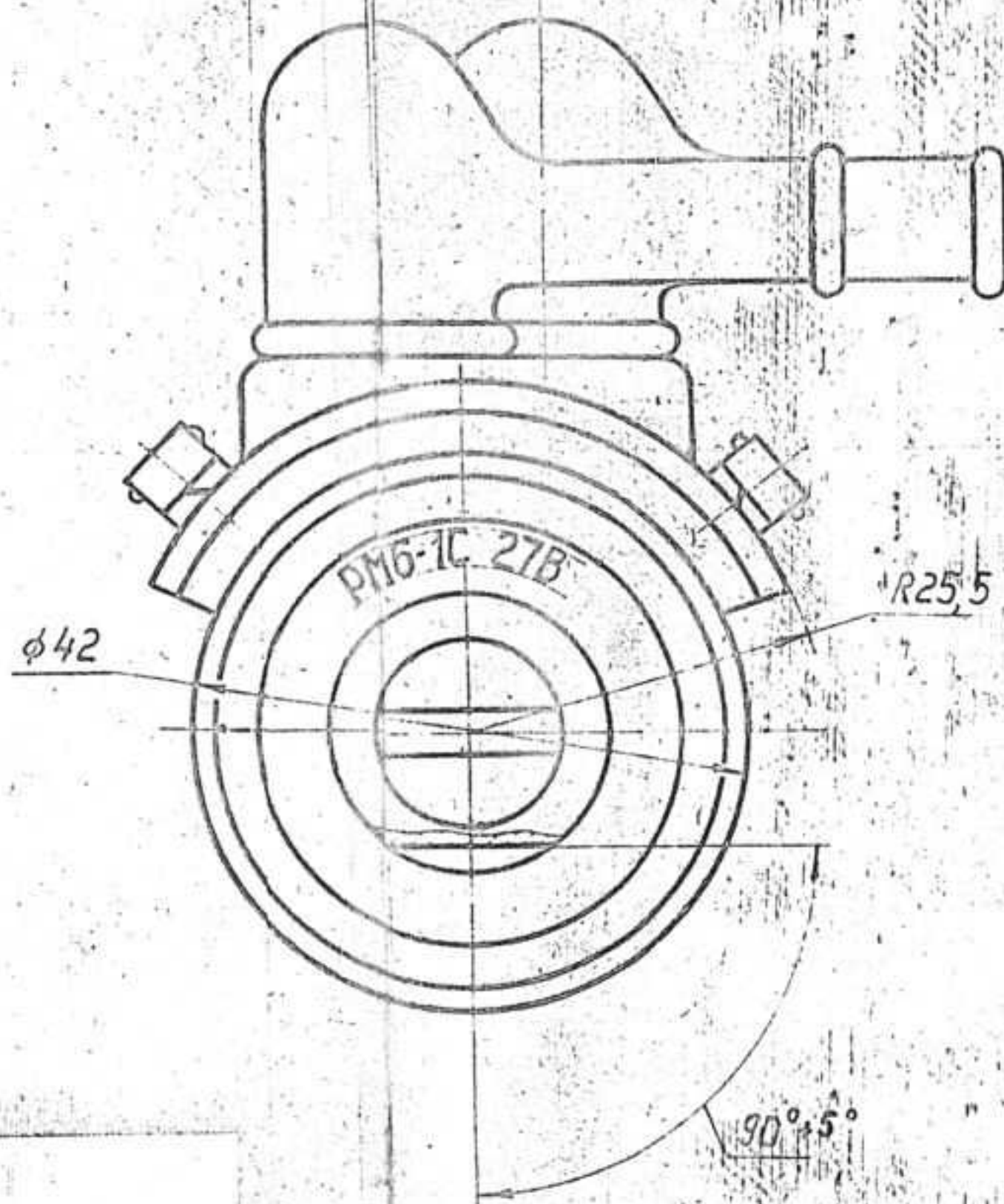
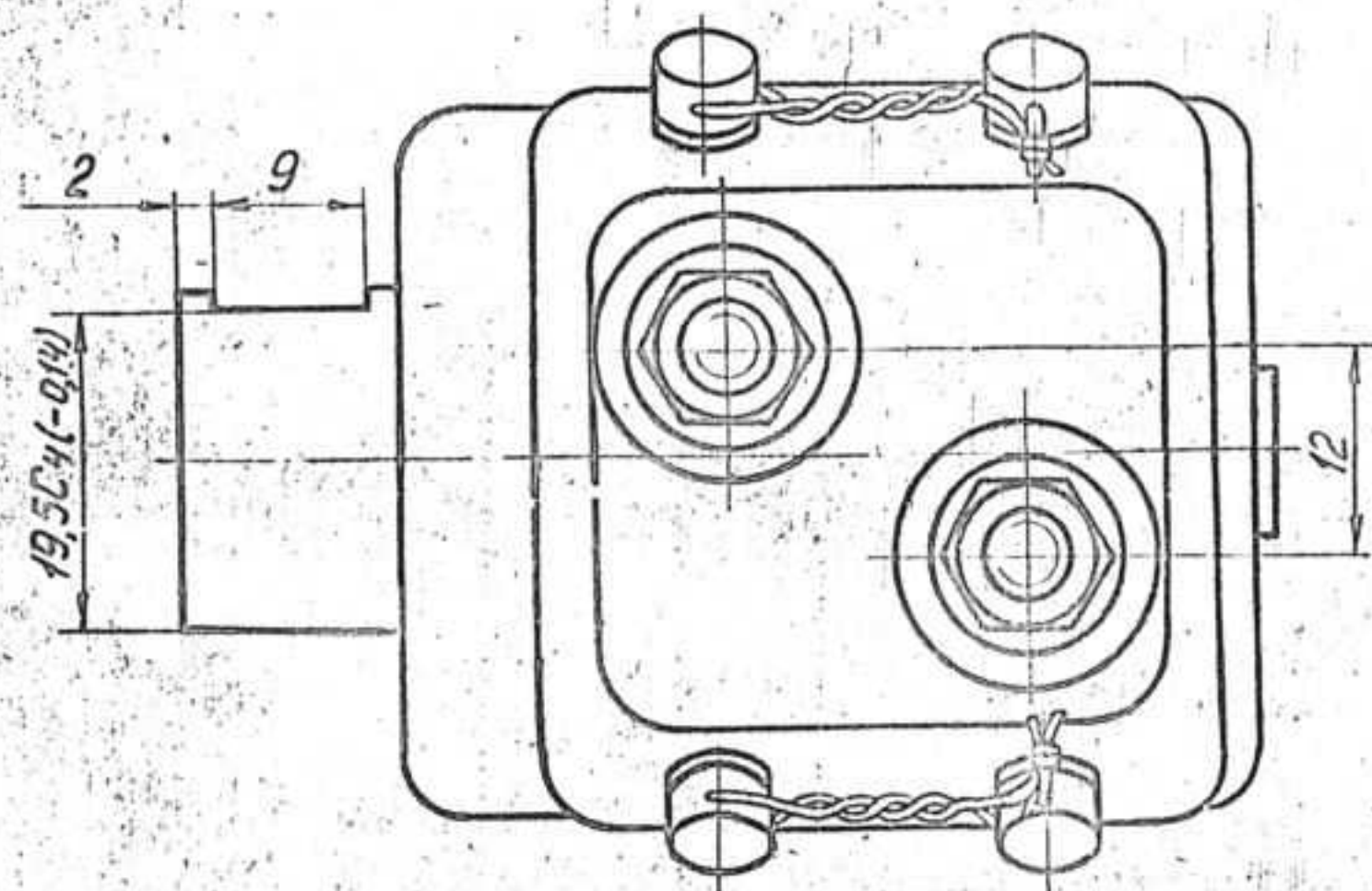


PM6-1C.000 C5				SHEET WEIGHT SCALE	
TRACTION RELAY				A	05
ASSEMBLY DRAWING.				TOTAL SHEETS	
ORDNANCE FACTORY PROJECT HYDERABAD					
NO	SHY	DOC NO	SIGN	DATE	
DRAWN	S. Gopal			11/12	
EDT/CHKD	A. K. KHANDE			13/12	
F/M, DC	S. R. N. BIR			14/12	
DIV/OFFR	A. K. KHANDE			14/12	
	NAME		SIGN	DATE	

Rubber cups are not shown.



Rubber cups are not shown.



1. During mounting and operation of relay at an object the user should ensure as follows.

- a) Protection from ingress of dust and water splashes at armature outlet
- b) Adjustment of armature movement
- c) Misalignment of armature
- d) Absence of armature displacement in axial direction when the relay is switched off under vibration impact loads.

8/12-602 ECKD

PM6-1C.000 Г4

NO.	UOC NO.	SIGN.	DATE
DRAWN	S. Gopal		11/72
EDT	CHIKD		11/72
F/W, DC.	S.R. NAIR	82	1-12-74
DIV. OFFR	A.K. KUNDU	12	4-12-74
	NAME	SIGN	DATE

SHEET WEIGHT SCALE		
A	0.5	2:1
TOTAL SHEET		
ORDNANCE FACTOR PROJECT		
HYDERABAD		

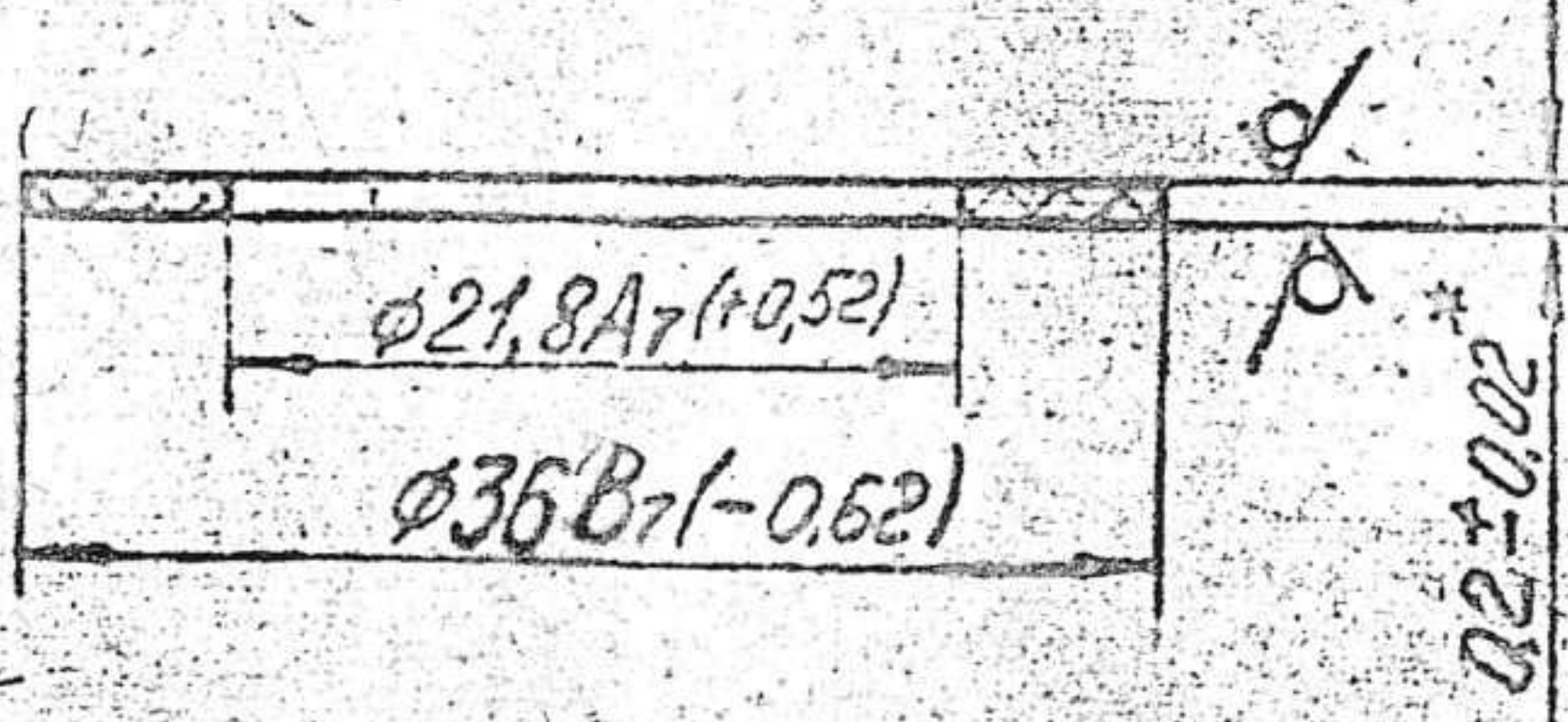
ATTRACTION RELAY

Out line drawing.

1-3-51/5

20001 JMC

PERD. NPLIN. P
PM6-1C.010



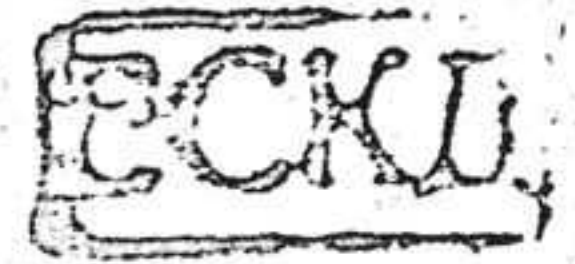
- 1,* Dimension is given for reference.
- 2. Bending of parts along roll are allowed.

Designation	Coating.
PM6-1C.003.	

304 UNDM INDM SIF. 7.007 U. 0.00

23
D-602

15



PM6-1C.003

SNO	SHT	DOC NO	SIGN	DATE
	DRAWN	s.gopal		11/12
	EDT & CHKD	A.K. DUBAY		13-12-80
	F/M, DC.	S.R.Nair,		14-12-80
	DIV. OFFR	A.K. KUNDU		3.01.85
		NAME	SIGN	DATE

WASHER

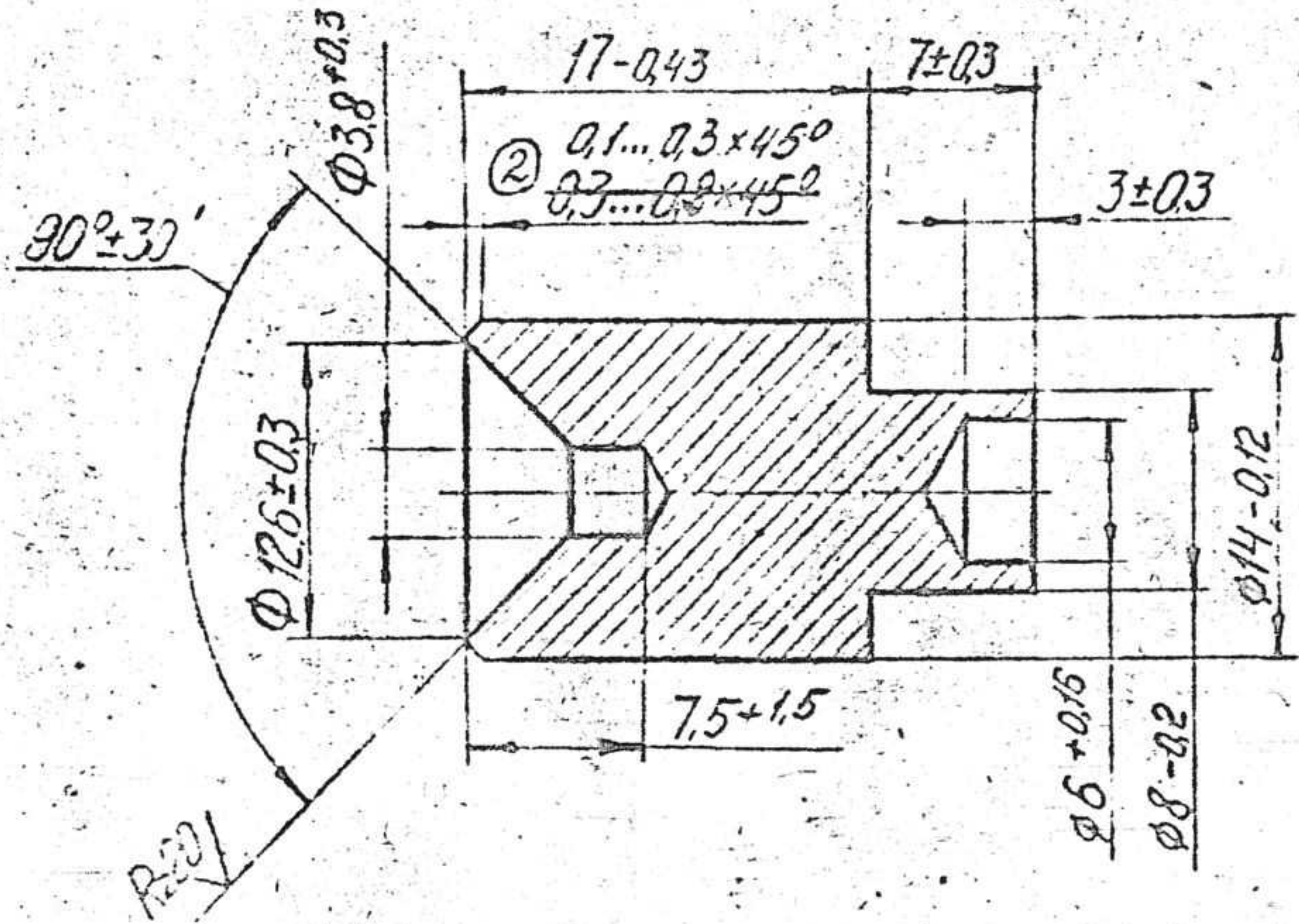
Paper board JB-0,2
GOST 2824-75.

SHEET	WEIGHT	SCALE
A	0,22	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

700 JF-JWU

1.20
✓ (M)

11000 DRAWING
PM6-1C.004



1. Anneal for improving magnetic properties.

Designation	Coating
PM6-1C.004.	Zinc plated, 6 microns, chromated composition of solutions for chromating as per U-252-78

25
D-602

(17)

11000

5	2	ABU 181-81	1981
11	2

PM6-1C.004

SNO	SHT	DOC NO	SIGN	DATE
	DRAWN	S. Gopal		11/12
	EDT, CHKD	A. R. DUBEY	...	13.12.84
	F/M, DC.	S. R. Nair.	...	14.12.84
	DIV. OFFR	A. K. KUNDU	...	3.01.85
		NAME	SIGN	DATE

CORE

Steel 10
GOST 1050-74

SHEET	WEIGHT	SCALE
8A	22.42	25:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

Лист № 000
PM6-1C.000

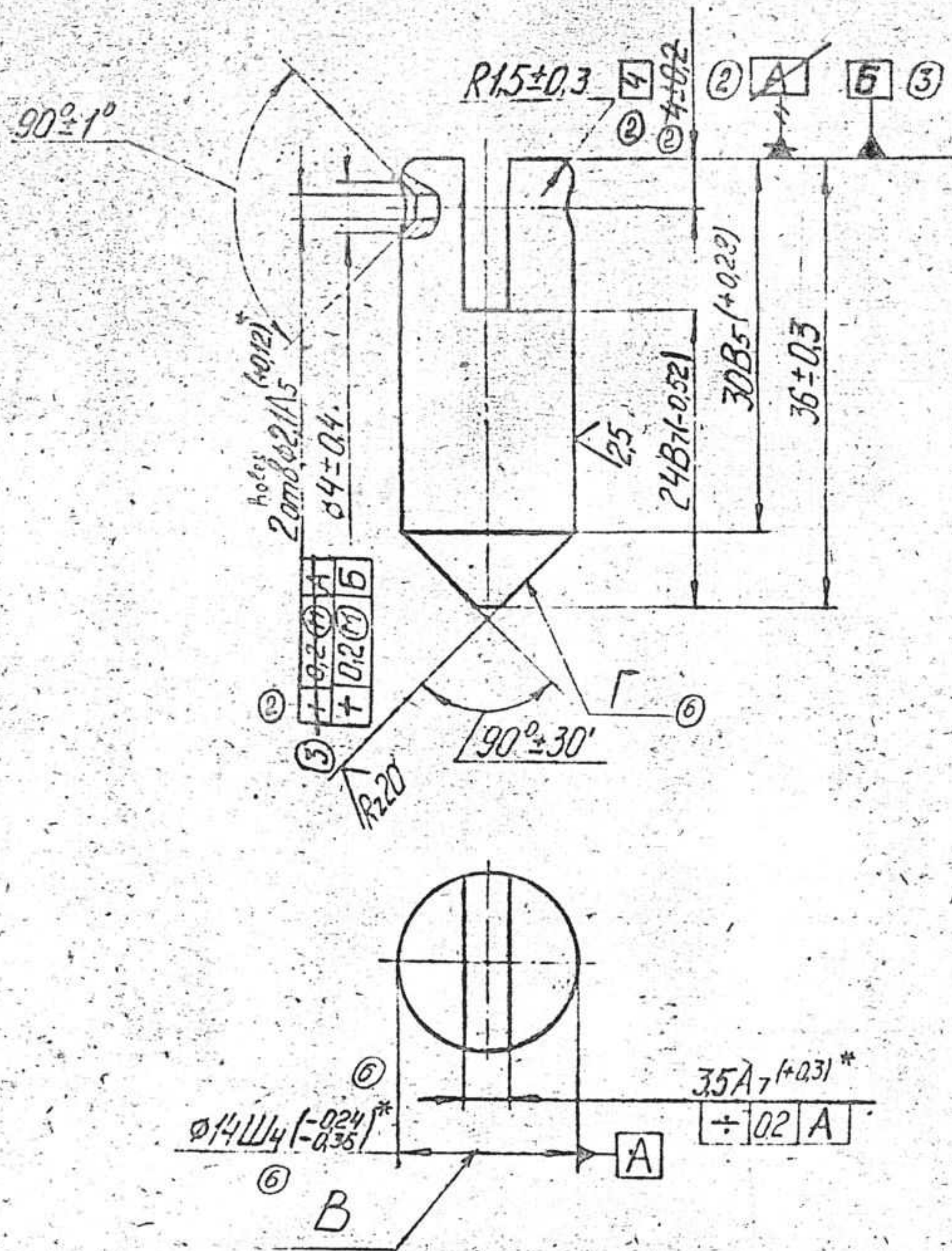
Лист № N

Лист № N

Лист № N

Лист № N

22849



1. Anneal for improvement of magnetic properties.
- 3.* Dimensions after coating.
4. Stamping KK on packing seal.

Designation.	Coating.
PM6-1C.005.	(Zinc 21 microns) composition of solution for chromating. along 1,252-78.

6	5	10.1.131-81	19.81
5	2	10.1.1276/2-79	28.12.79

PM6-1C.005

NO	SHT	DOC NO	SIGN	DATE
DRAWN		S.Gopal.		13/12
EDT,CHKD		A.K. DUDLEY		13.12.81
F/M,DC.		S.R.Nair.		14.12.81
DIV.OFFER		A.K. KURDU		3.01.85
		NAME	SIGN	DATE

ARMATURE

steel 10
GOST 1050-74.

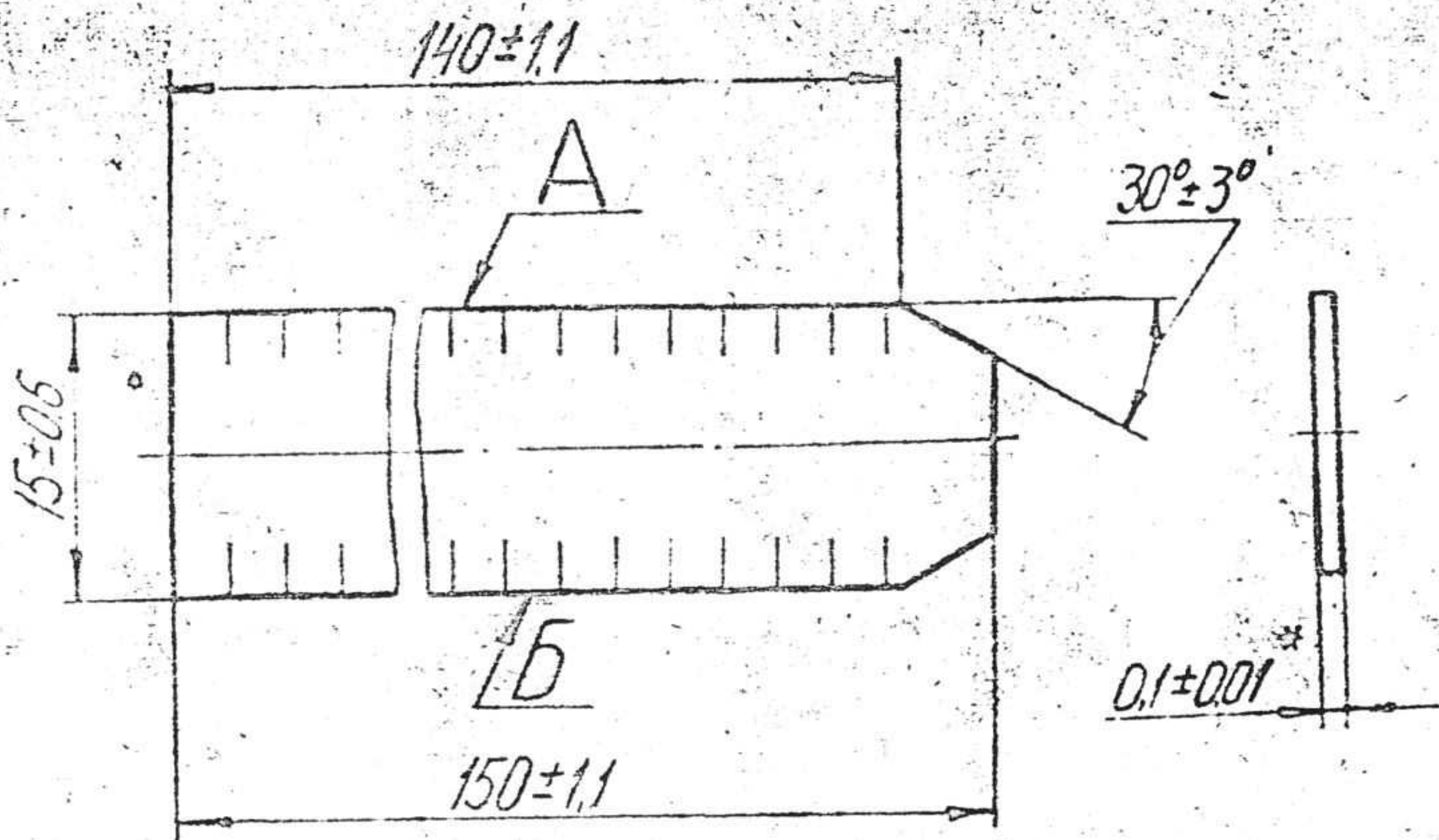
SHEET	WEIGHT	SCALE
18A	38g	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

Easy2Convert
www.easy2convert.com

1200
V(V)

3-5-A3 1-5-1798

PM6-1C.020



1. * Dimension. is given for reference.
2. Make 35 cuts to a depth of 3mm equally spaced on surfaces, A and B
- 3.

Designation	Material.
PM6-1C.006	Varnished fabric $\text{NW}105-01$ GOST2214-78.

27
D-602

PM6-1C.006

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		S.Gopal		12/12
EDT,CHKD		AKOUSBY		13.12.85
F/M,DC		S.R.Nair		14.12.85
DIV.OFFR		A.K.KONDU		3.01.85
		NAME	SIGN	DATE

GASKET

See table.

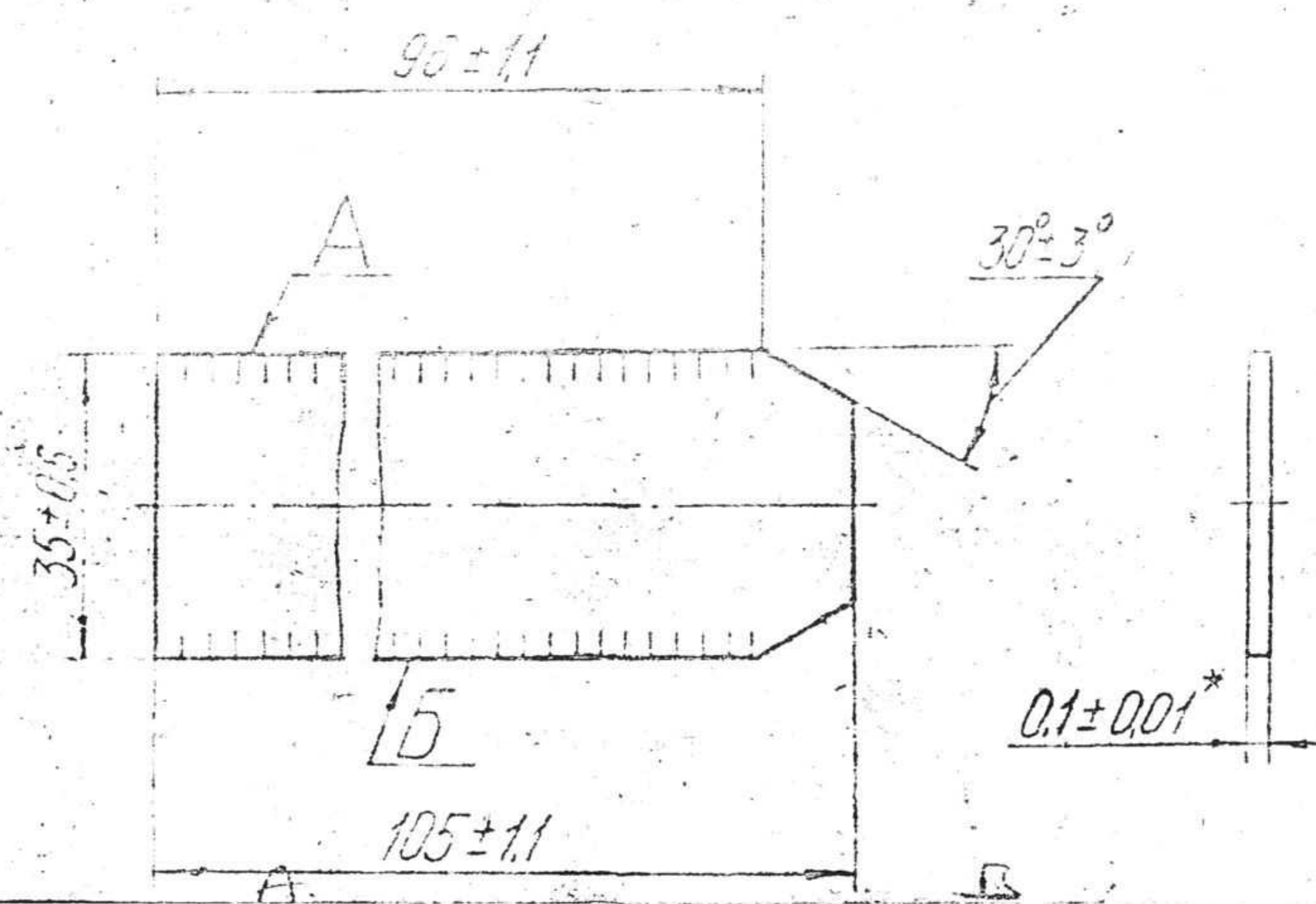
SHEET	WEIGHT	SCALE
18/1	1/2	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

1-5-1/110

55-5-A4

12071 0711

PM6-1C.007



Designation	Material.
PM6-1C.007.	Varnished fabric M.105-01 GOST2214-78.

- *1.Dimension is given for reference.
- 2.Make 32 cuts to a depth of 3mm equally spaced on surfaces A and B.

28
D-602

PM6-1C.007

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		S.Gopal,		12/12
EDT, CHKD		A.A. DV 169	homon	13.12.85
F/M, DC		S.R.Nair	sr	14.12.85
DIV.OFFR.		A.K. KUNDU	AK	3.01.85
		NAME	SIGN	DATE

GASKET

See table.

Easy2Convert

SHEET	WEIGHT	SCALE
24	12	1:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

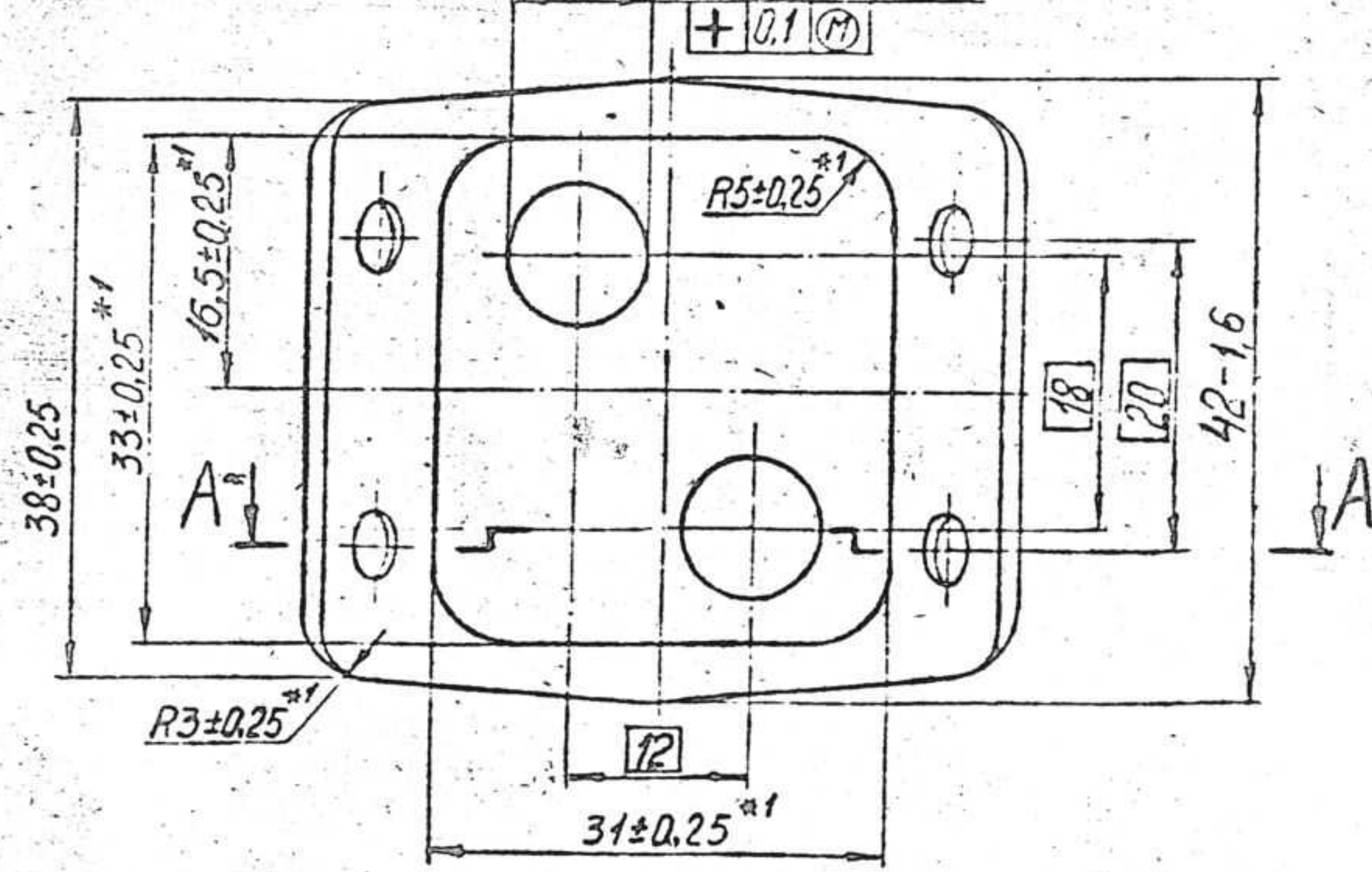
800 71 9Wd

Rz100
V(V)

Перв. пример. D
PM6-1C.040

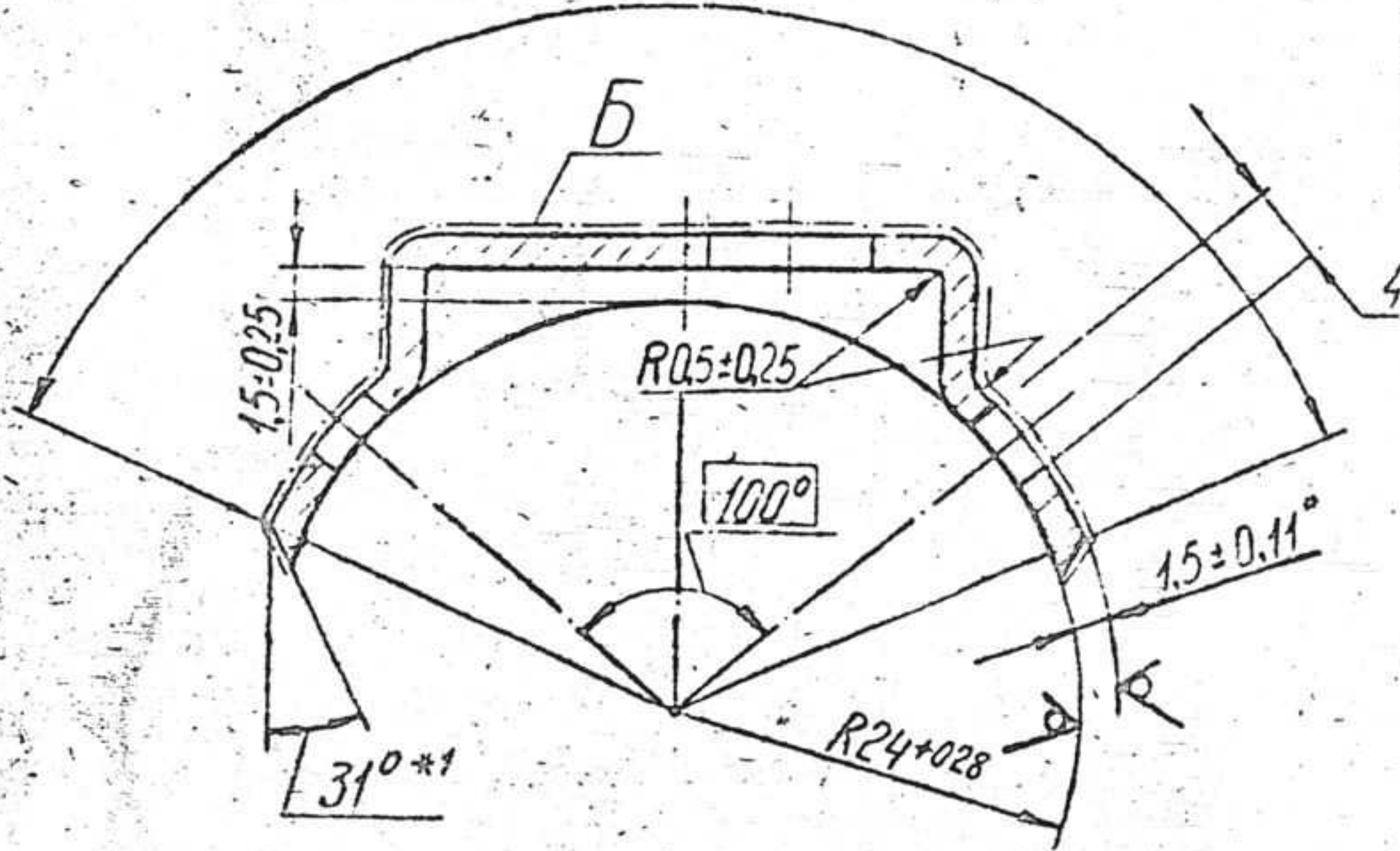
22848

2 Holes $\phi 9.2 A5^{(+0.2)}$
2 Holes $\phi 9.45^{(+0.2)}$ ②



- 1.* Dimension is given for reference.
2. Dimensions are provided with tool, checked at least once in a quarter.
3. Deviation from symmetrical arrangement of dimensions with respect to axes should not exceed 0.5mm.
4. Coating of surface B with black enamel MA-12, GOST9754-76. V, X, Y
5. Select the process of applying varnish and plain coating in accordance with OST B-1928-73.

A-A
 $132^{\circ}-50^{\circ}$



Designation	Coating.
PM6-1C.008	Zinc-plated, 24 microns chromated) composition of solution for chromating as per 4252-78.

PM6-1C.008

SNOISHT	DOC NO	SIGN	DATE
DRAWN	S.Gopal.		12/12
EDT, CHKD	A.KOUSAY	AK	12.12.12
S/M, DC	S.R.Nair.	SR	14.12.12
DIV.OFFR.	A.KRISHNA	AK	3.01.88
	NAME	SIGN	DATE

COVER.

SHEET WEIGHT	SCALE
275g	2:1
TOTAL SHEETS	
ORDANANCE FACTORY PROJECT HYDERABAD	

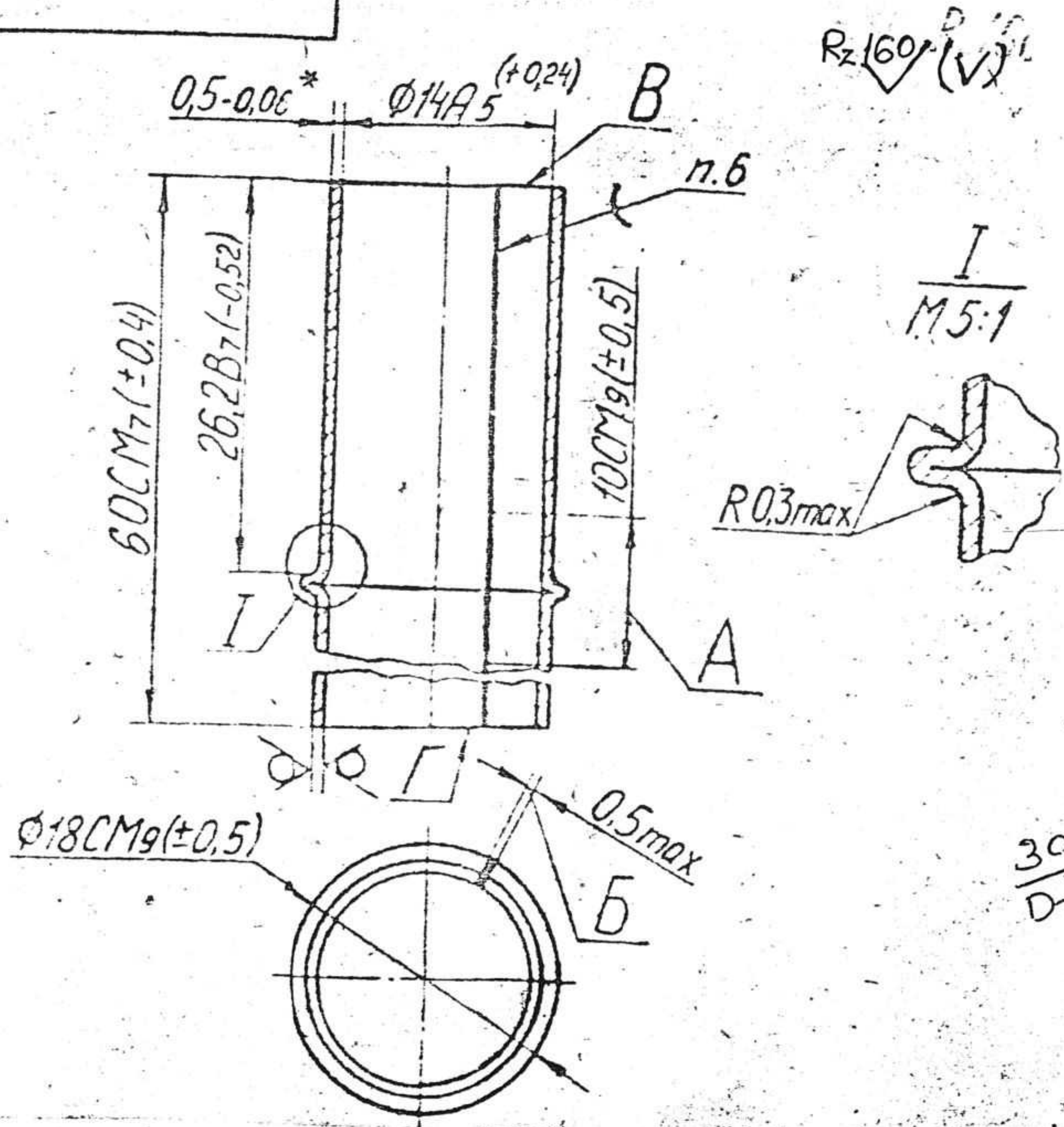
Sheet B1.5 GOST 19904-74

IBF-08KII GOST 9045-70.

29
D-602

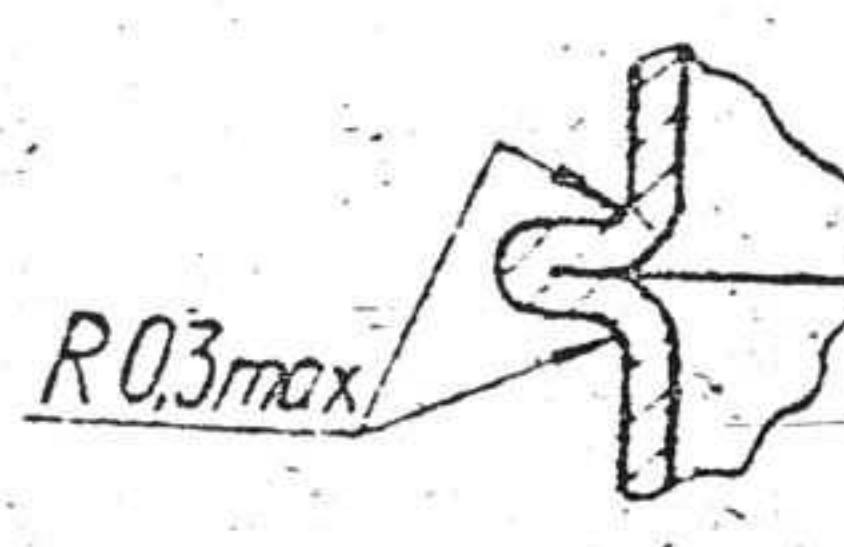
000 11-3100

П.С.С. П.П.И.М.Е.Н.
PM6-1C.050



Rz 160 (V)

I
M 5:1



30
D-6

289972
11.5.1000

1. Alternate material-band А ППМ 0,5 / 63 GOST 2208-75.
2. It is allowed to increase dimensions Б by 1mm maximum at collar place over the length of А.
3. Non parallelism of surfaces Б and Г should not exceed 0,6mm
4. * Dimension is given for reference.
5. Solder ПОССУ HO-2. GOST 21930-76. Flux ФКЧ, OST 4 CO.033.000. Dress after soldering.
6. Coating: Chemically, passivated.

PM6-1C.009

30
D-602

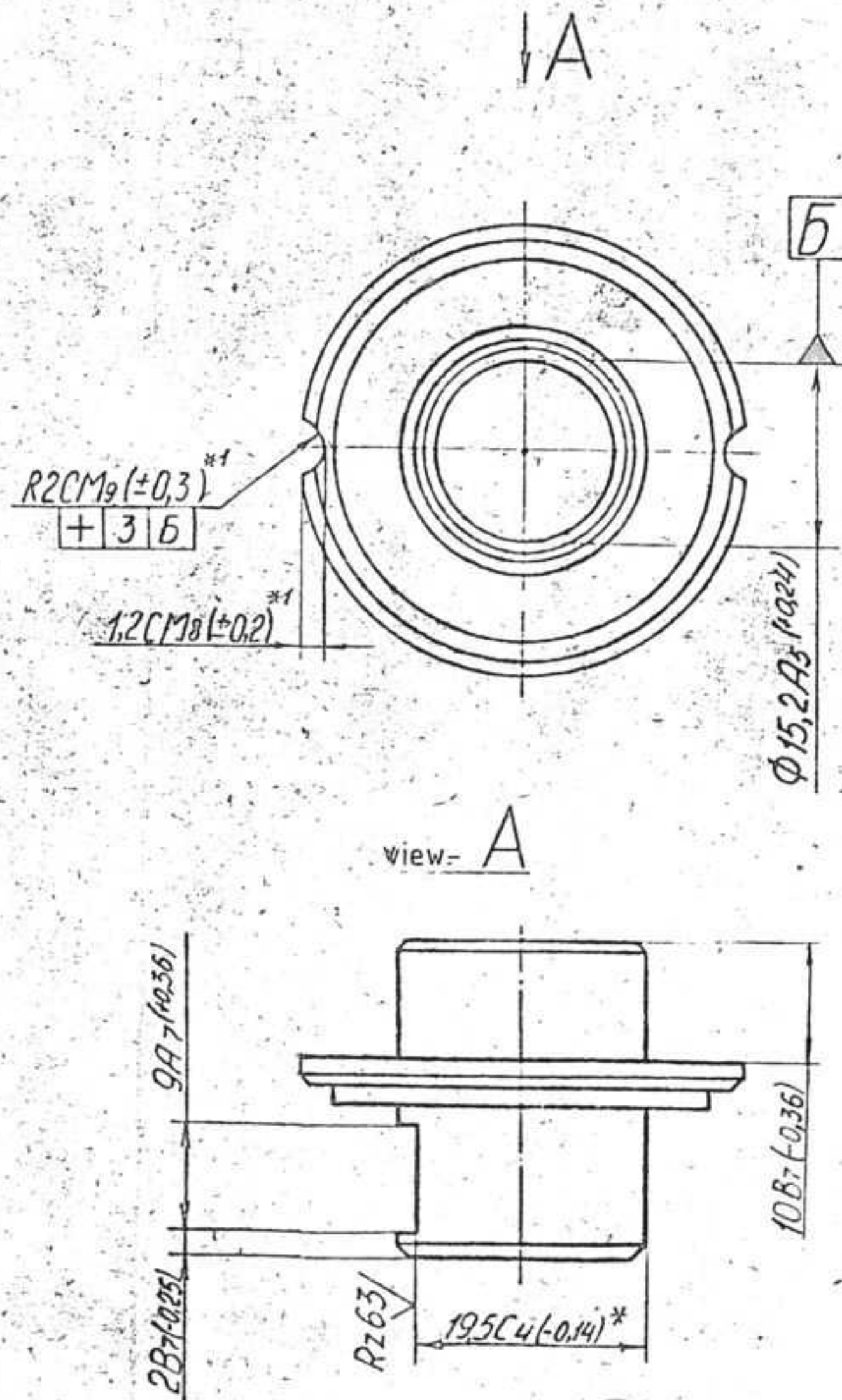
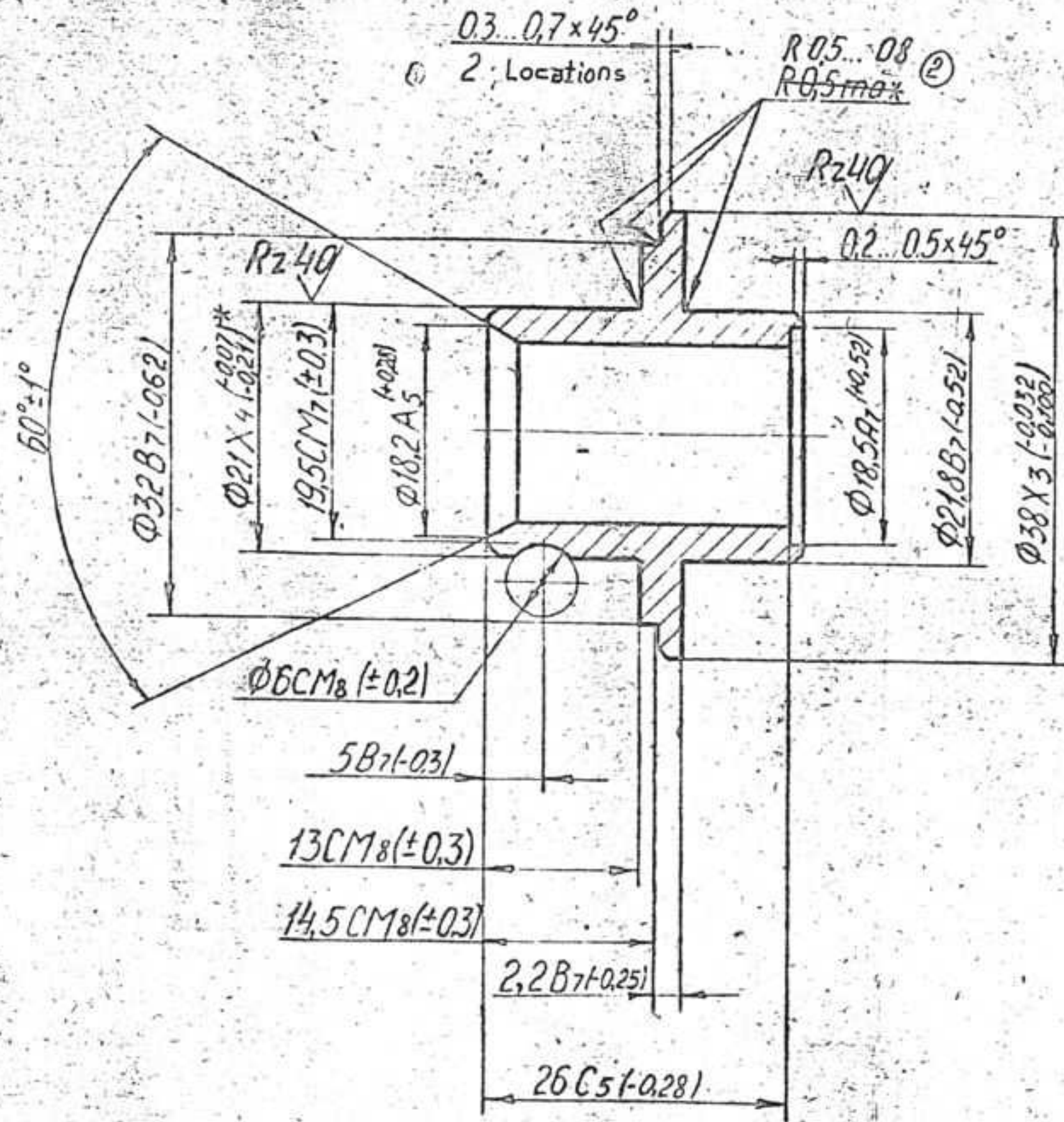
SNOSHT	DOC NO	SIGN	DATE
DRAWN	S.Gopal		12/12
EDT,CHKD	A.K. KUNDU	AK	13/12/12
F/M,DC	S.R.Nair.	SR	14/12/80
DIV.OFFR	A.K. KUNDU	AK	3.01.85
	NAME	SIGN	DATE

BUSHING.

SHEET	WEIGHT	SCALE
A	0,012	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

Plate А ППМ 0,5 / 63 GOST 931-78.

3-5-A4



- 1.* Dimensions after coating.
2. Dimensions provided with tool, checked at least once per quarter.
3. Coating: Cadmium plated, 24 microns, chromated.

SNO	SHT	DOC NO	SIGN	DATE
DRAWN	S.Gopal			12/12
EDT,CHKD	A.K.KUNDU			13/12/12
F/IN,DC	S.R.Nair			11/12/12
DIV.OFFR	A.K.KUNDU			3/01/15
	NAME	SIGN	DATE	

BUSHING

Steel10
GOST1050-74

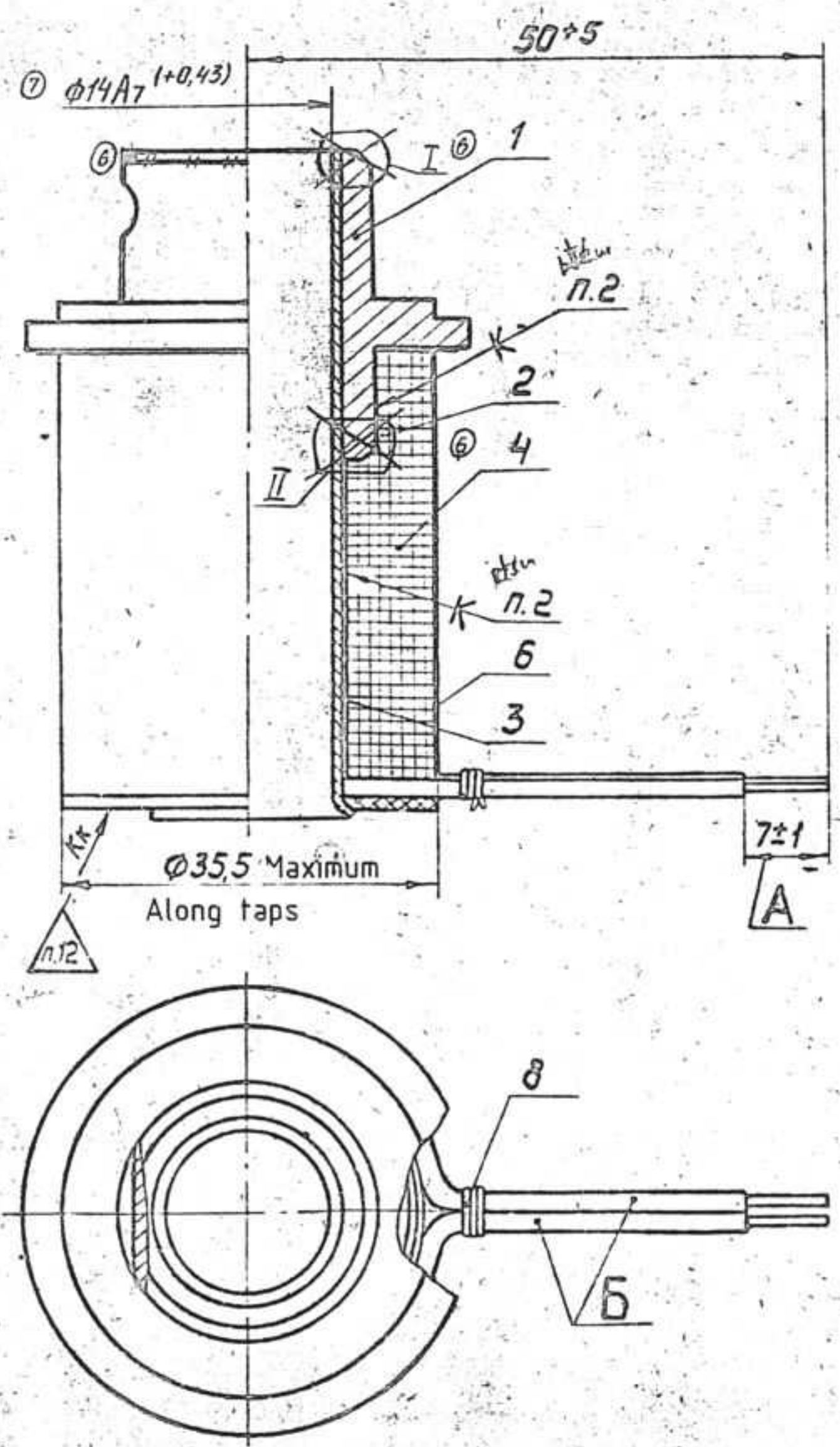
SHEET	WEIGHT	SCALE
A	0.057	2:1
TOTAL SHEET		
ORDNANCE FAC TOR PROJECT HYDERABAD		

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(23) 30/12/2012 ECKA

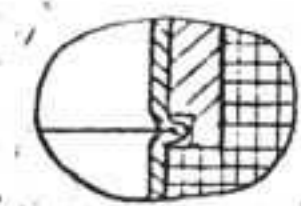
PMB-1C.011



I @
Instead of striken out



II @
Instead of striken out.



1. Layer by layer winding.
2. Wind frame, RefNo.1, with gaskets of varnished fabric RefNo.2, and 3. Bend gasket ends with glue 5P-4 GOST12172-74
3. Carry out winding with wire RefNo.4, Number of coils 970-4 resistance of coils at 20°C is 5,9, to 6,9 ohm
4. Braze to the begining of winding with solder ПОССУ-40-2 GOST21930-76. A piece of wire RefNo.9, 120cm, $\phi \pm 1,7$ mm in length tap put pipe, Ref, No10, of a length of 100±1,7mm.
5. Wrap one layer of paper, Ref, No5. after layers 6, 10, 14 of winding, Fillup depressions with same papers.
6. Braze to end of winding with solder ПОССУ-40-2 GOST21930-76. Wire, Ref No, 9, of length 80±1,5mm over tap, put pipe, refNo, 10, of length 50±1,2mm.
7. Secure the end of winding with varnished fabric, Ref No6 having dimensions (16x40)mm².
8. Insulate the coil from out side with varnished fabric, Ref, No, 6, having dimensions (18±0,5x500±3)mm², over laping by 1/2 width of taps, paste the last turns of varnished fabric with adhesive 5P-4, GOST12172-74.
9. Bind the begining and the end of winding with thread, Ref No, 8. ends of wire over length A
10. Dress and coat with hot solder ПОССУ-40-2 GOST21930-76
11. Check winding for turn-to-turn short circuiting and electrical strength by 500V 50Hz for one minute, minimum power of source 0,5KVA.
12. Apply marking.
14. Deviation of taps 6 from axial line should not exceed 20° to-wards any side.

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www.easy2convert.com

NO	SHY	DOC NO	SIGN	DATE
DRAWN	S. Gopal			11/12
EDT, CHKD	A. K. Rindhu			11/12
F/M, DC	S. R. Nair			11/12
DIV. OFFR	A. K. Rindhu			4.06.83
	NAME	SIGN	DATE	

COIL
Assembly drawing.

SHEET	WEIGHT	SCALE
2	170g	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

PM5-1C.020C5

14/11/2012

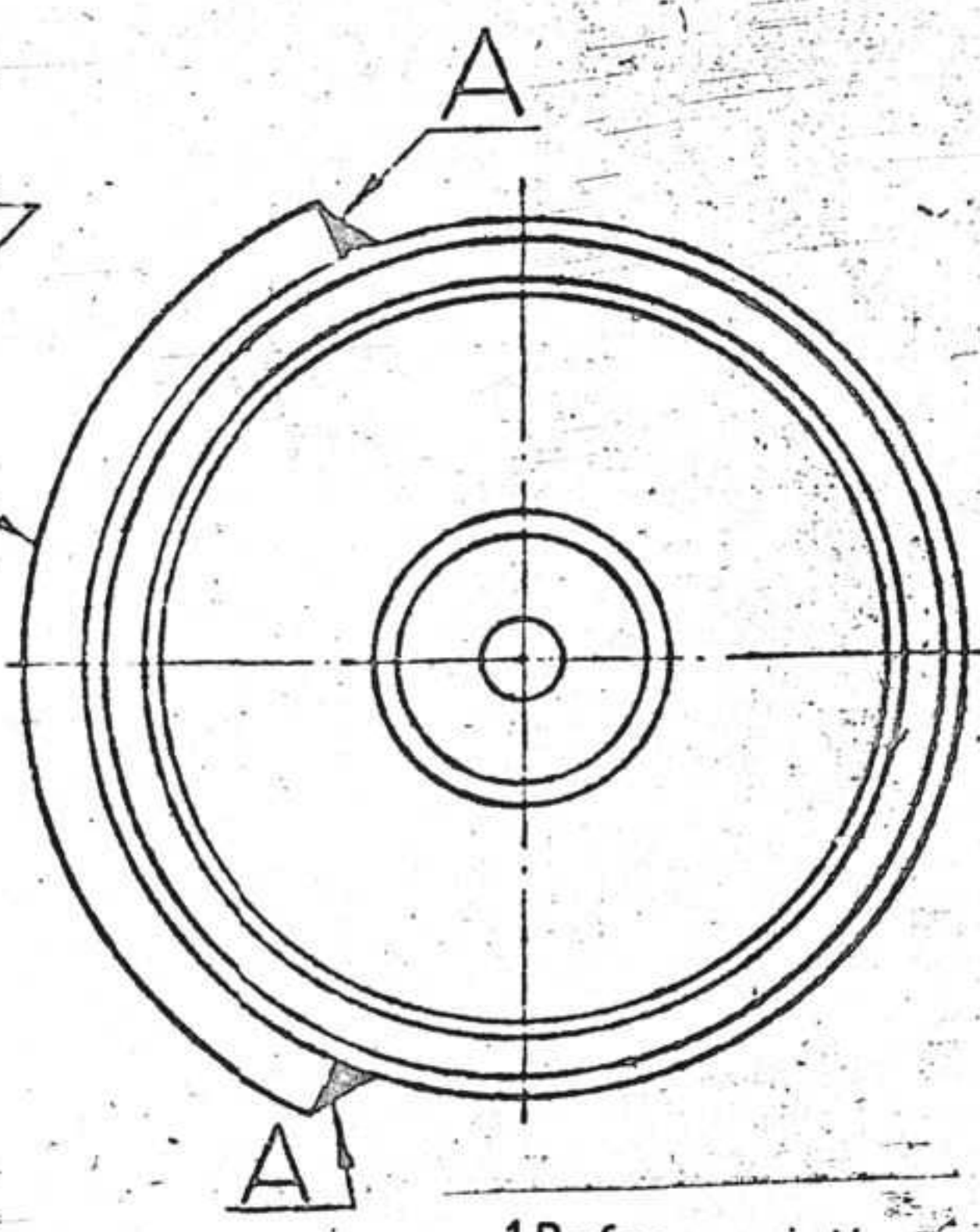
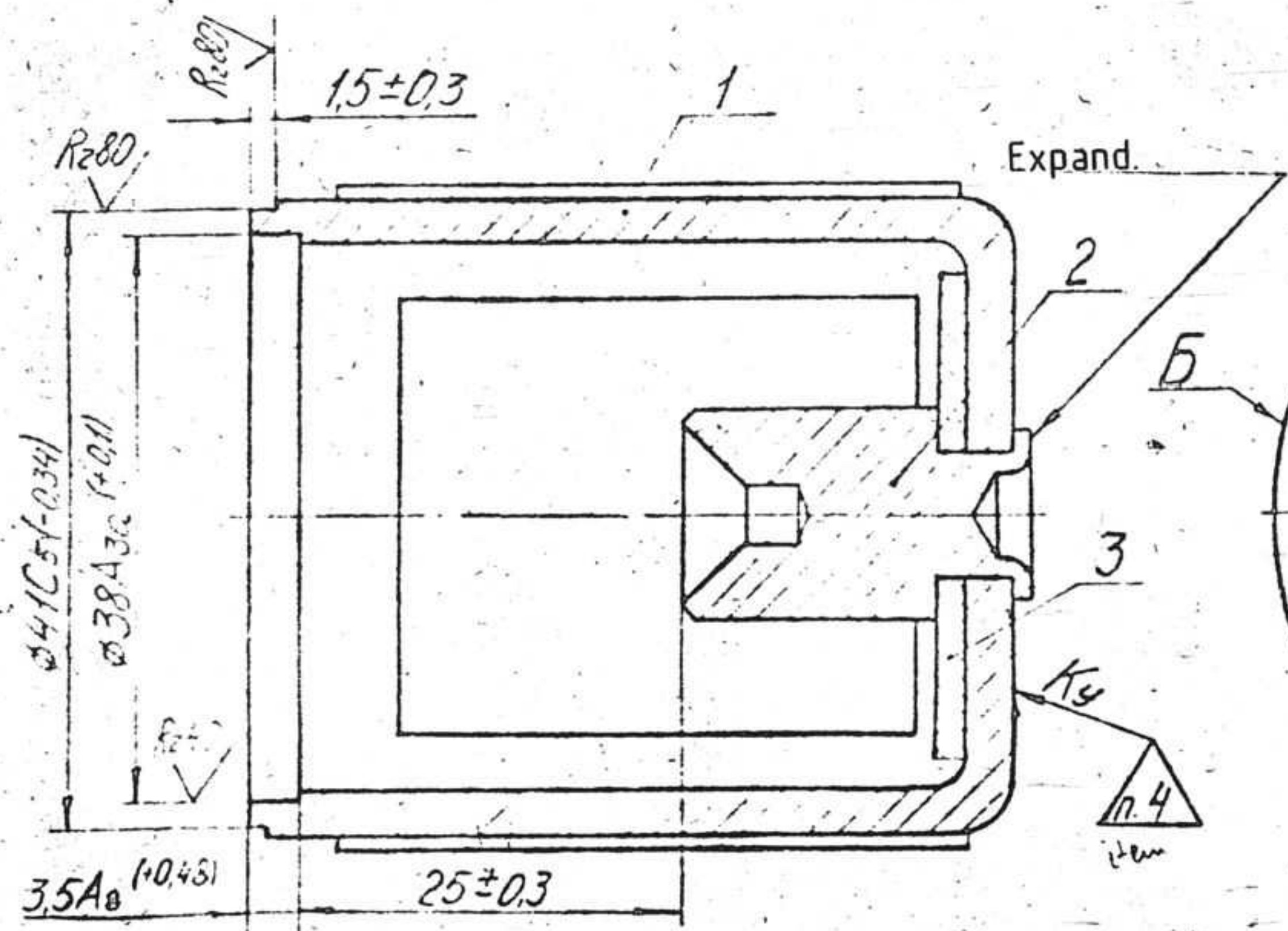
ECK

PM6-1C.030

22852

22852

50020 51 030



1. Before painting coat places A if necessary, with compound prepared as per instructions 4-109-78.
2. From out side coat with black enamel M-12 GOST9754-76 IV #1 except surface 5.
3. Select the process of applying paint and varnish in accordance with OST3-1978-73.
4. Apply stamping.

16
D-602

PM6-1C.030C5

NO	SHT	DOC NO	SIGN	DATE
1	DRAWN	S.Gopal		11/12
2	EDT,CHK	A.K. QUBAN		12-11-82
3	P/M,DC	S.R.Nair		14-12-82
4	DIV.OFFR	A.K. QUBAN		3.01.85
		NAME	SIGN	DATE

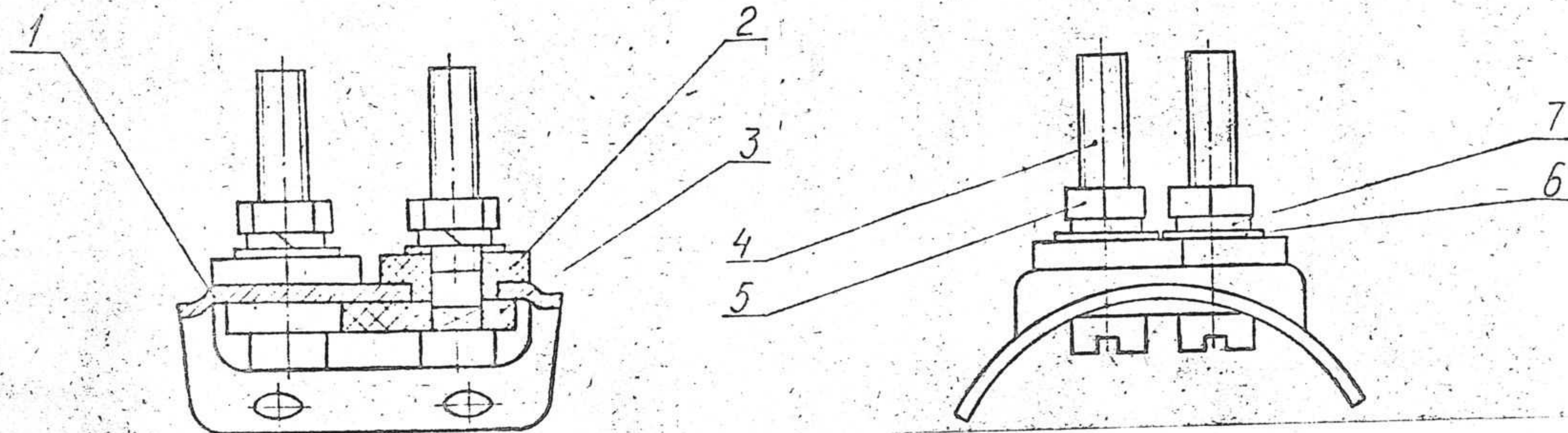
CASE WITH CORE
Assembly drawing.

SHEET	WEIGHT	SCALE
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

Easy2Convert

PM6-1C.040C5

11/03/12 PM6-1C.040C5



Punch nuts, Ref, No5, in three places.

18
12-602

PM6-1C.040C5

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		S.Gopal		11/12
EDT,CHKD		A.K.KUNDU	AKK	15/12
F/M,DC		S.R.Nair	S.R.	14/12/09
DIV.OFFR		A.K.KUNDU	AKK	3.01.09
		NAME	SIGN	DATE

COVER
Assembly drawing

SHEET	WEIGHT	SCALE
01	42.52	2:1

Easy2Convert

www.easy2convert.com

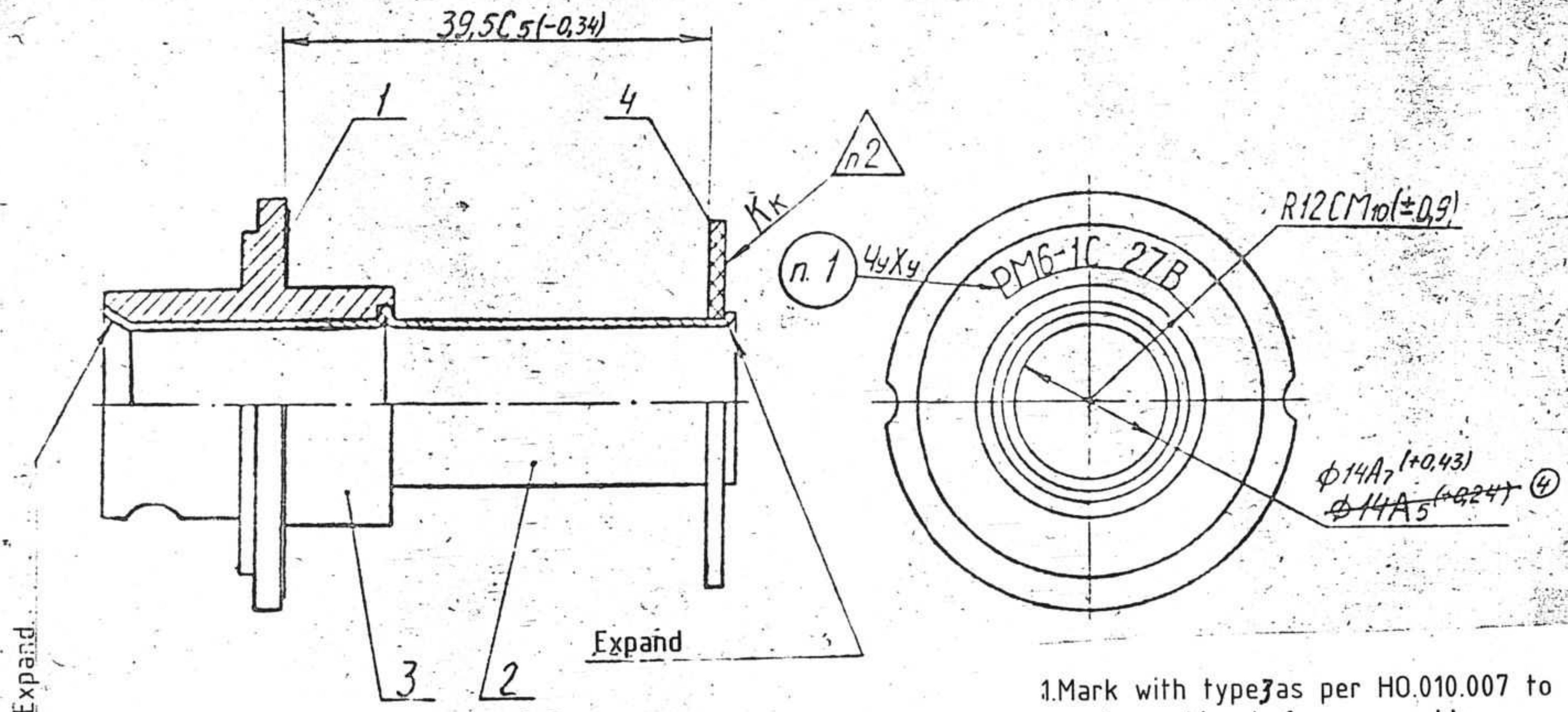
TOTAL SHEETS
ORDNANCE FACTORY
PROJECT
HYDERABAD

3-5-A3 00PMD/12

22841

DMR-105005

PM6-1C.050



1. Mark with type 3 as per HO.010.007 to a depth of 0.5mm apply marking before assembly
2. Stamp.
3. While flooring out the bushing, Ref. 2. Breakage of soldering over a length not exceeding 10mm is allowed from each end.

DMR-105005

28967

20
D-602

4	1	DMR-105005	11/12
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PM6-1C.05005

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		S.Gopal		11/12
EDT,CHKD		A.K. DUDLEY	know	13/12/12
F/M,DC.		S.R.Nair	82	14-12-80
DIV.OFFR		A.K. KUNDU	AK	3.01.80
		NAME	SIGN	DATE

FRAME.
Assembly drawing.

SHEET	WEIGHT	SCALE.
A	0.07	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

Easy2Convert