B1-1
30

SIZE	ZONE	REF. IN	PART N°	NOMENCLATURE	Qty	REMARKS
				DOCUMENTS		
22			A45. 935. 058 CB	ASSEMBLY DRAWING		
				ASSEMBLY UNITS		
11		1	A45. 944. 010	HEATING SHEET		
				COMPONENTS		
22		4	A47. 200. 056	PRISM	1	
11		5	A47. 842. 049	ADHESIVE FILM	1	
11		6	A47. 842. 050	ADHESIVE FILM	1	
11		7	A47. 842. 051	ADHESIVE FILM	1	
11		8	A47. 842. 052-02	ADHESIVE FILM	2	
11		9	A48. 210. 013	CUP	1	
11		10	A48. 683. 234-01	GASKET	10	
		11	-02	GASKET	10	
		12	-03	GASKET	10	
		13	-04	GASKET	10	
		14	-05	GASKET	10	

D.C.(1):-1232-1(P), 5423-3.

SIGNATURE AND DATE

D.C(1)-5423-2. PT LIST SEALED — 5.10.90

D.C (1)-1232-1(P) PART LIST PROV. SEALED — 1.12.87

up dated up to 31/5/89 DD/DL

AH	Modification No.	No. OF DOCUMENT	SIGNATURE	DATE
DESIGNER				
CHECKED BY				
DRAWN BY				
INSPECTOR				
APPROVED				

A45. 935. 058.

HEATING PRISM

LETTER	SHEET	No. OF SHEET
	1	2

HEAVY VEHICLES FACTORY AVADI

(1.1)

SIZE	ZONE	REF. No.	PART No.	NOMENCLATURE	Qty	REMARKS
11		15	A48 684.121	GASKET	1	
		16	-02	GASKET	1	
				MISCELLANEOUS ITEMS		
		28		THERMISTOR		
				TOC-A		
				AB 4.681.025/028 TY	1	
						B-I

D.C.(I):-1232-I(P), 5423-I

SIGNATURE AND DATE

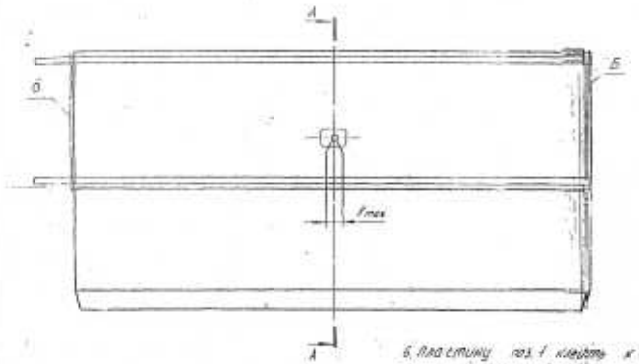
PURCHASE INVENTORY No.

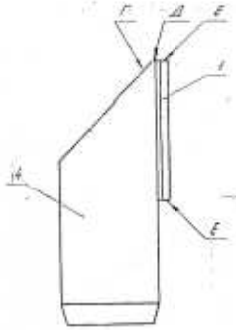
PURCHASE INVENTORY No.

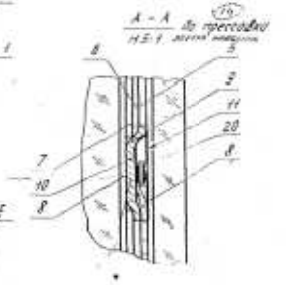
SIGNATURE AND DATE

D.C.(I)-5423-I. PT LIST SEALED			5.10.90	up dated up to 3/5/89 DC(O.L.P)
	D.C.(I)-1232-I(P) PART LIST PROV. SEALED		1.12.87	AU5.935.058
ALT	SHEET	No. OF DOCUMENT	SIGNATURE	DATE

SHEET 2







Температура, °С	18	20	21	22
Сопротивление, Ом	от 3435 до 3700	от 5000 до 3500	от 4465 до 3300	от 1750 до 1400

6. Пластину поз. 1 клеить к призме покрывающим покрытием внутрь, выступающие пластины за поверхность Д не более 1мм. Заподлицо на поверхности Д и выступание на поверхности Б не допускается.

7. После прессовки выступающую пленку обрезать по контуру пластины и призмы. Допускается слой пленки на _ толщиностями Г и Е и Б.

7. After pressing, cut down the protruding adhesive film of plate and prism under the edge of plate and surfaces Г, Е and Б. Allow thickness not more than 0.5 mm on surface Г.

8. More protection of wires see ВС-4.731.00.00-00.00.03 behind resistance on light zone should not be more than 1 mm.

9. Remaining technical requirements as per ТУ-3-0.0.0

10. Resistance of marking conducting coating (10-7) should be measured between the terminals of both ends. Resistance deviation between overall resistance of both ends should be 20 ohms for 22°C. Resistance between the resistance of thermistor at temperature should be 5 ohm. To one end of thermistor on the back side of the plate should correspond to the resistance in the table.

11. Thermistor should be soldered with tin-lead solder and a 0.05 mm thick insulation protection on upper side behind resistor on sleeve not more than 1 mm from edge.

12. Terminal of thermistor should be bended with a radius of at least 0.5 mm.

13. Plate No 1 should be thermistor on back side conducting coating on side protection of plate behind the surface Д should not be more than 1 mm. Should not be any behind the surface Г and 2000 ± 5 mm behind the surface Е.

18					
12					
11					
10					
9					
8					
7					
6					
5					
4					
3					
2					
1					

ORG. No. 2.115-056.068 С 1

Heater prism

Resistance detector

Material:

Sheet 1 Sheet 1 Scale 2:1

Copied and printed in Russia

A1-3/34

D.C.(I)-1232-I(P), 1462-I(P), 5423-I

SIZE	ZONE	REF. No	PART No	NOMENCLATURE	Qty	REMARKS
				DOCUMENTS		
13			A45. 944. 010 CB	ASSEMBLY DRAWING		
				COMPONENTS		
11		1	A47. 755. 032	BUS BAR	2	(A)
12		2	A48. 640. 107	PLATE	1	

SIGNATURE AND DATE

	D.C.(I)-5423-I. PT. LIST. SEALED.		5.10.90	
	(A) D.C.(I)-1462-I(P) REF No. 1 & 2 AMENDED		10.7.90	up dated up to 31/5/89 DO(O.L.)
	D.C.(I)-1232-I(P) PART LIST PROV. SEALED		1.12.87	A45. 944. 010
AII	Short Title OF DOCUMENT	SIGNATURE	DATE	

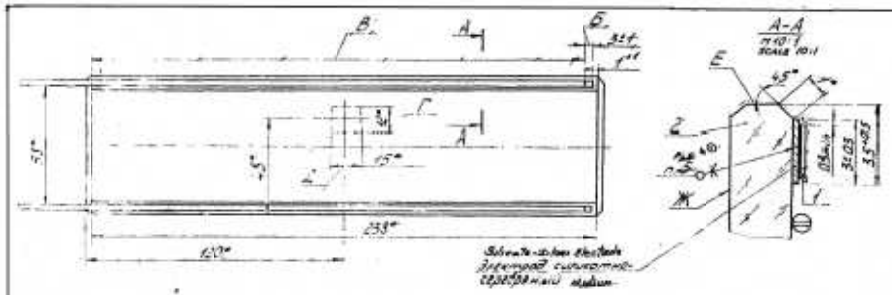
ORIGINAL INVENTOR SIGNATURE AND DATE

DESIGNER			
CHECKED BY			14/3/85
CHIEF OF DESIGN DEPARTMENT			
INSPECTOR			
APPROVED			27/3/85

HEATING SHEET

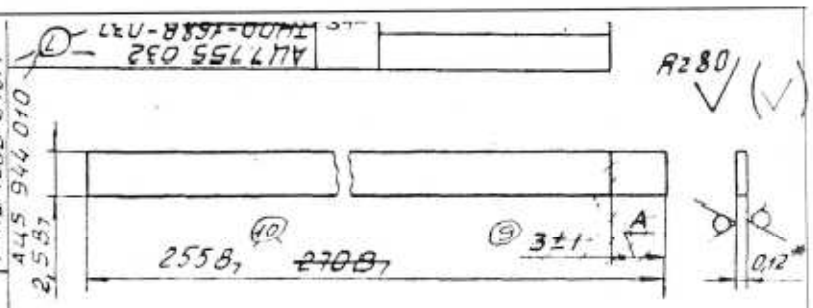
LETTER	SHEET	No. OF SHEET
	1	1

HEAVY VEHICLES FACTORY AVADI (15)



1. *Conducting coating should be made of semiconductor dioxide of tin with the addition of fluorine.
2. Silicate-silver electrodes should be applied over conducting coating along its full length. Thickness of electrodes should be [illegible]
3. Sheet with electrodes should be hardened. Hardening degree should be 0.7 N/cm min.
4. Tin 1 should be glued using conducting adhesive with nickel filler. [illegible]
5. Liquid sublayer ПС-4 [illegible] should be applied on surface "E" along the entire length of sheet.
6. Conducting coating resistance should ensure the fulfillment of point 1 of [illegible].
7. Heating rate of the sheet should be checked by the method of melting thin layer of paraffin wax Б1 Gost 23683-79 which is applied on surface "E" on sections specified by dimensions "C" and "A" [illegible] the temperature of sheet and the surrounding air of 23 ± 2° C. Melting time of the paraffin wax should be with in 45 to 65 sec from the moment the electric heating is switched on. The supply voltage of heating is to be 23 - 0.3 V, should be measured by voltmeter of accuracy class 1.5 having the scale from 0 to 30 V.
8. *Dimensions for reference.
9. Rest of the technical requirements are as per ТУ3-1.834-73.

			ALIS-944.00.00 CB	
			HEATING SHEET	



1. HEAT TREATMENT: VACUUM ANEALING DEGREE OF VACUUM ANEALING TO BE CHECKED AS PER GOST 1173-77, ON TWO SAMPLE HAVING DIMENSION 20X60 mm. FROM EACH LOT.

2. DEFORMATION AND BURRS ARE NOT PERMITTED.

3. BUS BAR TO BE PICKLED. MINIUM THICKNESS OF BUS BAR AFTER PICKLED SHOULD BE 0.09 mm.

5. LOCAL SWEATING AND FADING OF COLOUR IS NOT PERMITTED.

6* DIMENSION FOR REF.

5. Местные потемнения и цвета побежалости не допускаются.

6.* Размер для справок

D.C(1)- 5423-I DRG SEALED	5.10.90	
D.C(1)-1462-I(P), UPDATED DRG. PROV. SEALED IN SUPER SESSION OF EXISTING ONE.	10.7.90	
AMENDMENTS	DATE	SIG.

GROUP No. 41315 KD FOLDER/SHEET No. 39/44

DRG. No. AU 7755.032

BUS BAR

SHEET	WEIGHT	SCALE
	0.0006	4:1

MATERIAL COPPER STRIP MIT-HT GOST 1173-77

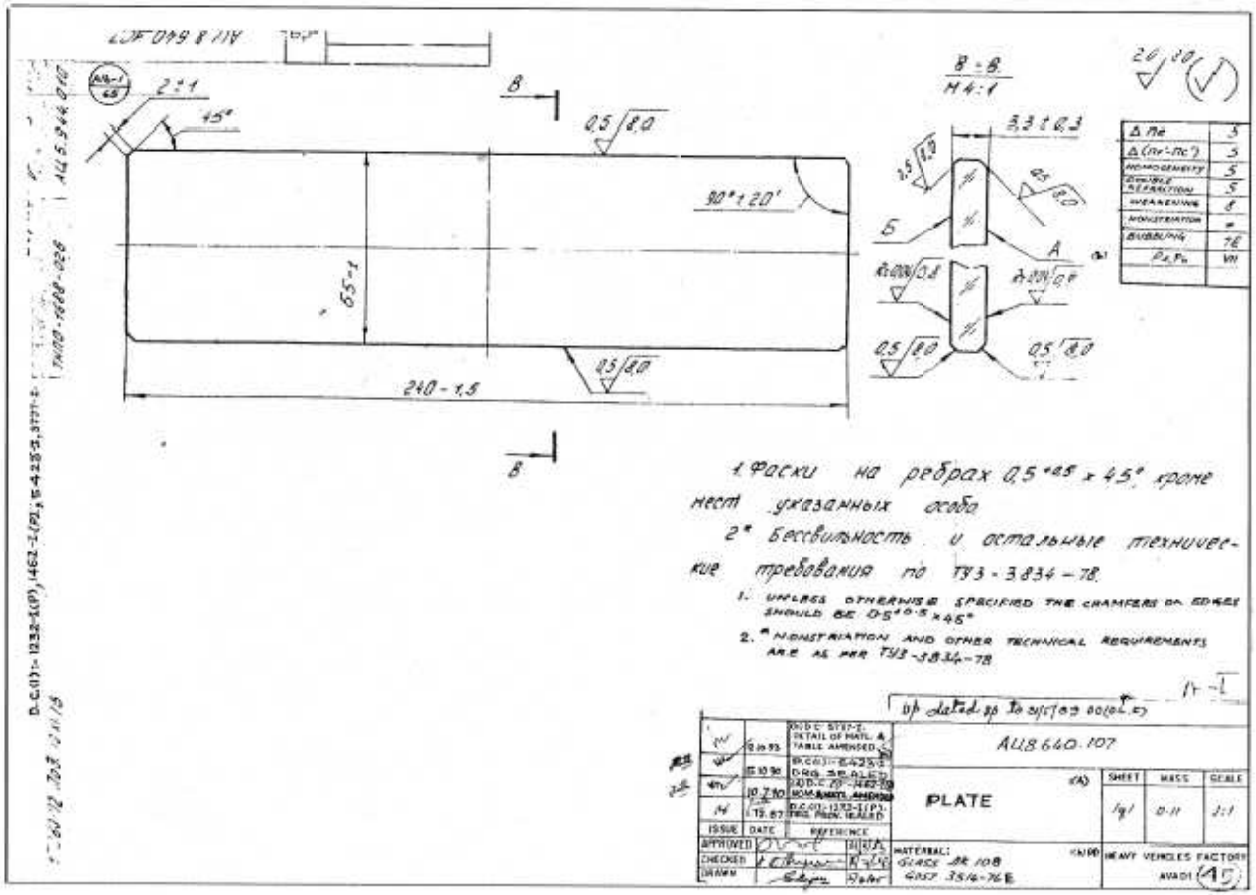
OPTO ELECTRONICS FACTORY DEHRADUN

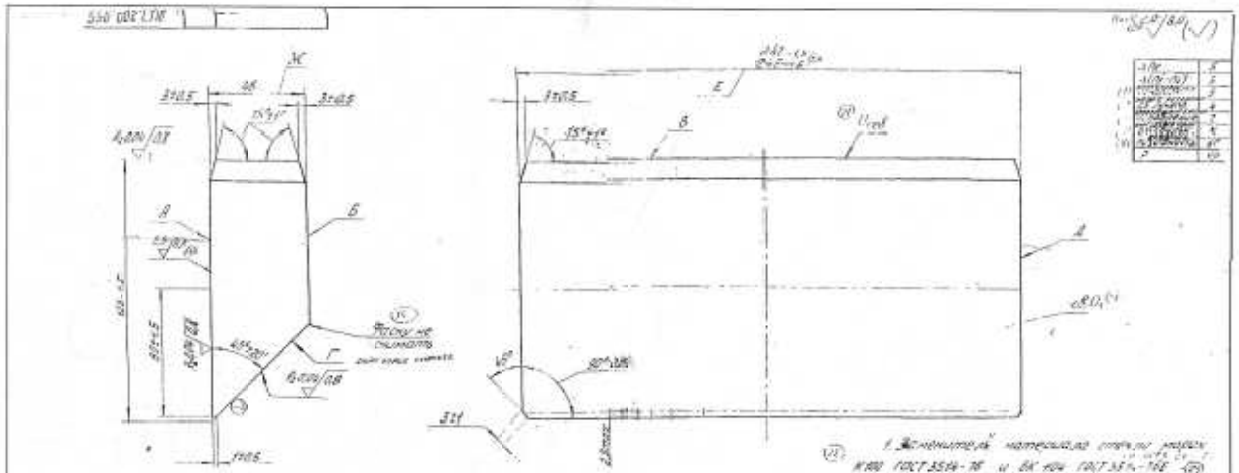
10		АЦ6Ч-87		
9	2	814-79		4.11
8		744-78		20/2
7	3	765-76		9/5
6	Замн.	396-76		20/2

Калыкова
Удовиченко
Дрогоненко
Царькова

Перв. примененіе
Справочный №
Подп. и дата
Инв. № дубл.
Взам. инв. №
Подп. и дата
Инв. № подл.

D.C(1)-1232-I(P), 1462-I(P), 5423-I


2:1
45°
B
0,5 / 8,0
90°±20'
65-1
240-1,5
B
В-В
М4:1
3,2 / 0,3
Б
А
0,5 / 8,0
0,5 / 8,0
1. Фаски на ребрах 0,5+0,5 x 45° кроме мест указанных особо
2* Бесвильность и остальные технические требования по ТУ3-3834-78.
1. UNLESS OTHERWISE SPECIFIED THE CHAMFERS ON EDGES SHOULD BE 0,5+0,5 x 45°
2.* NONSTRIATION AND OTHER TECHNICAL REQUIREMENTS ARE AS PER TУ3-3834-78
АЦ8.640.107
PLATE
SHEET
MASS
SCALE
1/1
0.11
1:1
MATERIAL:
GRADE 08 108
GOST 3616-76E
HEAVY VEHICLES FACTORY
AVADI



SUBSTITUTE MATERIAL GLASS GRADE K-110 GOST 3519-76 AND EV 100 GOST 3519-76.

2. ANGLE BETWEEN THE SURFACE OF Д AND А Д Б, Д AND А AND Д AND Г SHOULD BE FROM 90°±20'

3. CHAMFERS ON GLASS SHOULD SHARP BE UNCLEAR GRADE CHAMFER ON CORNER 2×1×45.

4. TOLERANCES ON DIMENSIONS E AND Ж SHOULD BE 1/2 OF TOLERANCE GIVEN FOR DIMENSION.

5. WORKING ZONE ON SURFACE А Б AND Г IS LIMITED BY CHAMFERS AND GIVEN DIMENSIONS.

6. Ø 35Н 3Е-12Л ВХ PER ОСТ 3-1861-85

7. SILVER COATING AND DULL SURFACES BAKELITE VARNISH 3 GRADE-Е ВХ PER ГОСТ 901-78 WITH SILVER BRONZE CARBON GRADE ВСМ5 ГОСТ 7884-74Е THE TOP ON ГОСТ 9573-70, THEN AFTER BAKELITE VARNISH АЛС GRADE 3 WITH FILLER ТИТАНОВЫЙ ДИОКСИД ВХ 103 ГОСТ 7885-84 AND TITAN.

8. RESISTANCE INSULATION OF VARNISH COATING* AS REGARD TO СЕРЕБРЯНЫЙ LAYER SHOULD NOT BE LESS THAN 20 m OHM.

9. ВЫ ДОЛЖНЫ ЗАЩИТИТЬ ЧАСТИ ОТ ВЛАГИ ТЕМПЕРАТУРЫ ВЫШЕ 100 ГУЗ-3834-70

Выполнить покрытия по технологии по ГОСТ 9038-78 V группам.

8. Сопротивление изоляции лаковой покрытия отдельно слоя меди не менее 20 мОм.

9.* Бесшумность и остальные технические требования по ТУ3-3.384-70.

1. Применить материал стекло по разделу К100 ГОСТ 3519-76 и ВК 100 ГОСТ 3519-76.

2. Угол между поверхностями Д и А, Д и Б, Д и Г равен 90°±20'.

3. На ребрах 1×45°, кроме него осевого. Фаски на диаметрах 2×45°.

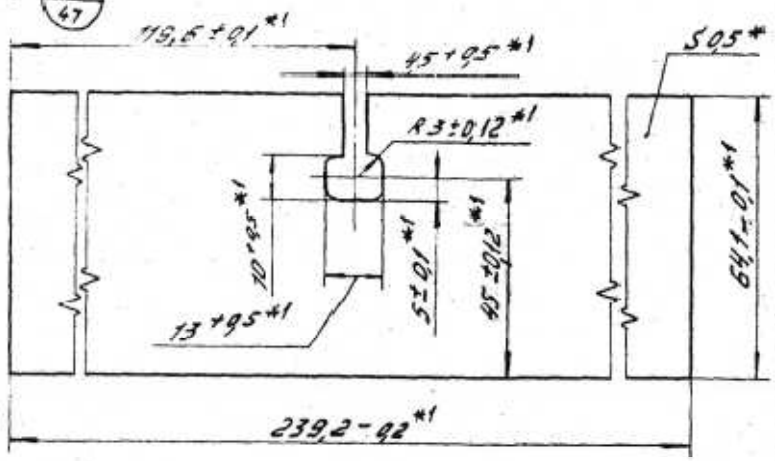
4. Допуск по размерам Е и Ж в половины допуска на размер.

5. Рабочая зона на поверхностях А, Б и Г ограничивается фасками и заданными размерами.

6. ○ - заклепки 25Р.3Е.12П по ОСТ 3-1891-85

АЦ7.842.049

АЦ5.935.058



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

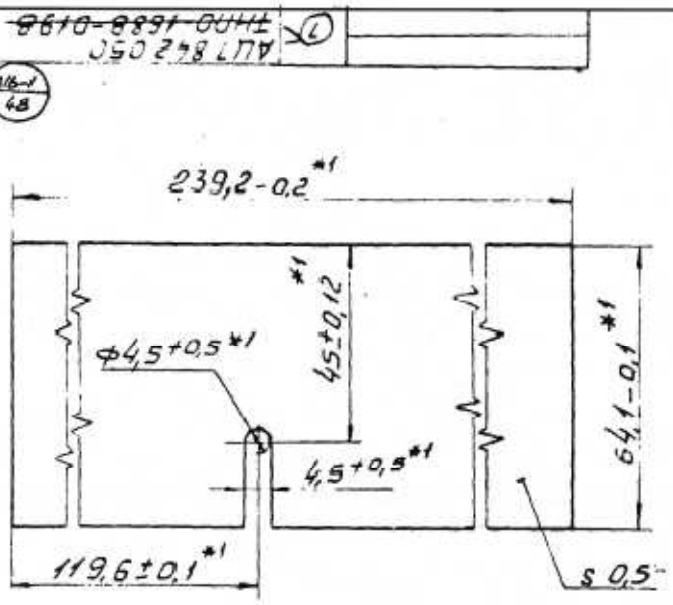
1.* Размер для справок.
2.*1 Размеры обеспечиваются инструментом.

up dated up to 31/5/89 DO(SL.F)

			АЦ7.842.049		
	5.10.90	D.C.(1)-5423-I DRG SEALED	ADHESIVE FILM	SHEET	MASS	SCALE
	10.7.90	(A)D.C.(1)-1462-I(P) MATL. AMENDED		1of1	0.0091	1:1
	1.12.87	D.C.(1)-1232-I(P). DRG. PROV. SEALED				
ISSUE	DATE	REFERENCE				
APPROVED		31/3/85	MATERIAL: TAPE A-17 0.5×1000 (A) GOST 9438-85	HEAVY VEHICLES FACTORY AVADI		
CHECKED		14/2/85				
DRAWN		9/2/85				

Инв.№подл. | Подп. и дата | Взам. инв.№ | Инв.№дубл. | Подп. и дата | Справочный № ТИПО-1688-041 | Перв. примен. ТИПО-1688-050

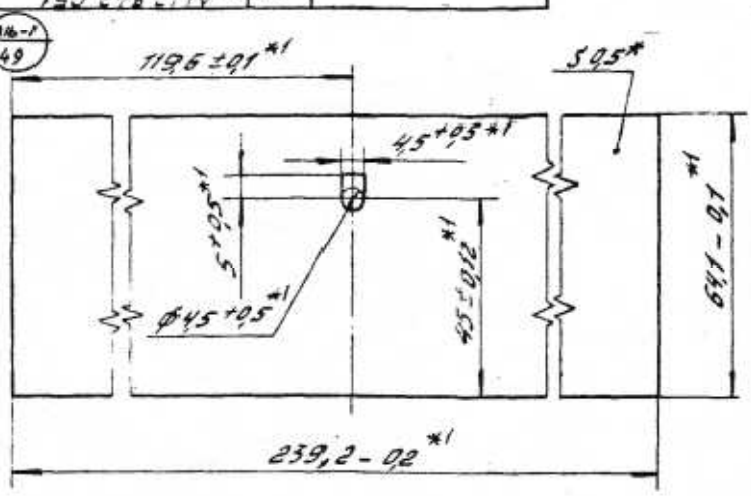
D.C.(1)-1232-I(P), 1462-I(P), 5423-I



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

1. * Размер для справок.
2. *1 Размеры обеспечиваются инструментом

			АЦ7.842.050		
	5.10.90	D.C.(1):-5423-I DRG. SEALED.	ADHESIVE FILM	SHEET	MASS	SCALE
	10.7.90	(A)D.C.(1):-1462-I(P) MATL. AMENDED.		1 of 1	0.0091	1:1
	1.12.87	D.C.(1):-1232-I(P) DRG PROV. SEALED				
ISSUE	DATE	REFERENCE				
APPROVED			MATERIAL: TAPE A-17, 0.5×1000 GOST 9438-88	HEAVY VEHICLES FACTORY AVADI	
CHECKED					
DRAWN					



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

1. * Размер для справок.
2. *1 Размеры обеспечиваются инструментом.

up dated up to 31/5/89 DD(D.L.)

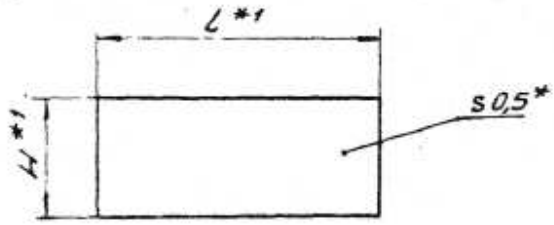
			A47.842.051			
	5.10.90	D.C.(1):-5423-I. DRG. SEALED	ADHESIVE FILM	SHEET	MASS	SCALE
	18.7.90	(A) D.C.(1)-1462-I(P) MAT. AMENDED		1 of 1	0.0092	1:1
	1.12.87	D.C.(1):-1252-I(P). DRG. PROV. SEALED				
ISSUE	DATE	REFERENCE				
APPROVED		24/3/86	MATERIAL: T1,2L-A-17, 0,5×1000 GOST 9438-85 (A)	HEAVY VEHICLES FACTORY AVADI		
CHECKED		24/3/86				
DRAWN		27/3/86				

D.C.(1):-1252-I(P), 1462-I(P), 5423-I.

АЦ7.842.052

Перв. примен. АЦ5.935.057

Справочный № ТМ02-1688-035А



PART No Обозначение	DIMENSIONS Размеры, мм		MASS Масса, кг
	L	H	
АЦ7.842.052	60С5	3С5	0,00011
-01	227,2-0,2	59,6-0,1	0,008
-02	239,2-0,2	64,1-0,1	0,009

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

1. * Размер для справок.
2. *1 Обеспеч. инстр.

up dated up to 31/5/89 DO(B.L.B)

D.C.(1)-1232-I(P), 1462-I(P), 5423-I.

5048-95

АЦ7.842.052.

ADHESIVE FILM

ISSUE	DATE	REFERENCE
	5.10.90	D.C.(1)-5423-I DRG. SEALED.
	10.7.90	(A) D.C.(1)-1462-I(P) MATL. AMENDED
	1.12.87	D.C.(1)-1232-I(P). DRG. PROV. SEALED

APPROVED		24/3/89
CHECKED		16/6/89
DRAWN		17/3/89

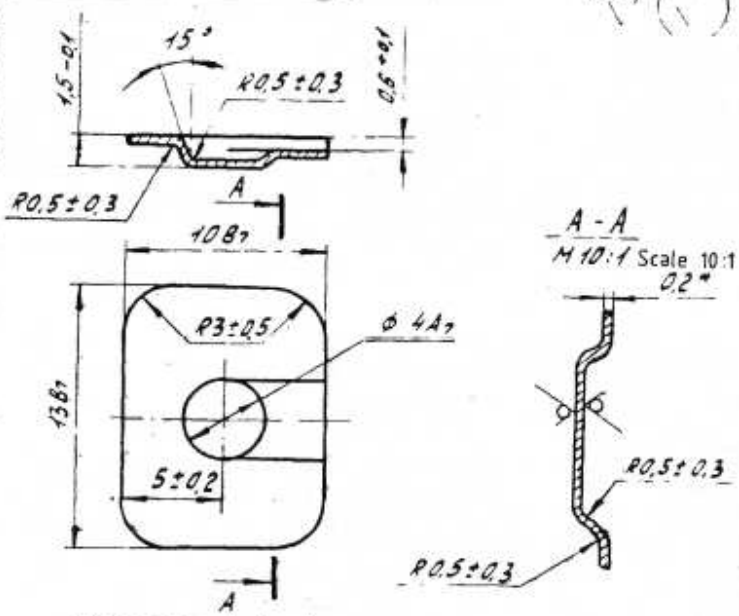
MATERIAL: TAPE A-17, 0.5×1000 GOST 9438-85

SHEET	MASS	SCALE
1 of 1	SEE TABLE	–

(A) HEAVY VEHICLES FACTORY AVADI (31)

АЦ8.210.013

Fz 80,



1. Burrs are not allowed.
2. *Dimension for reference.

1. Заусенцы не допускаются
2. * Размер для справок.

G/No413/5

CAT/PT. No. 5905-020255

up dated up to 31/5/89 DO (DLF)

			АЦ8.210.013.	A2 / 64	
	(4) 27.4.92	D.C.(1)-5562-I. NOW AMENDED & CAT/PT. No. ADDED.	COVER, THERMAL RESISTOR. (4)	SHEET	MASS.	SCALE
	5.10.90	D.C(1)-5421-I. DRG. SEALED.		1 OF 1	0.0002	5:1
	1.12.87.	D.C(D)-1231-I(P). DRG-PROV-SEALED.				
ISSUE	DATE	REFERENCE				
APPROVED			MATERIAL: COPPER MI GOST 1173-77.	HEAVY VEHICLES FACTORY AVADI	
CHECKED		24.5.85			
DRAWN		13/5/85			

D.C(D)-1231-I(P), 5421-I, 5562-I.

Восстановлен с подлинника. Верно:

АЦ5.935.058

Тип-1688-042

(2)