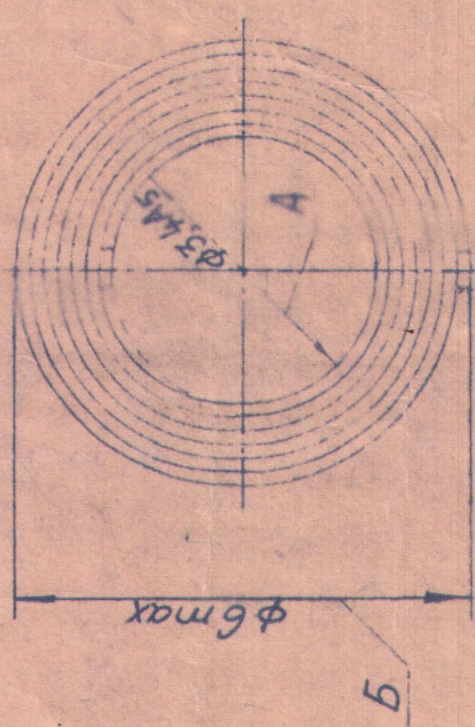
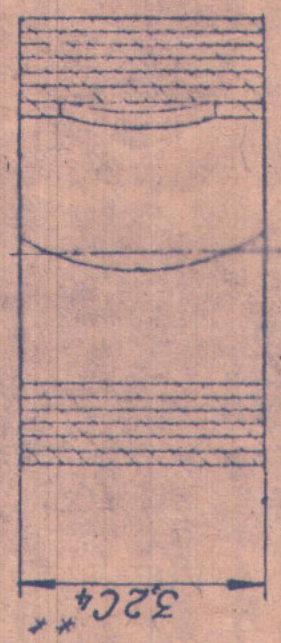


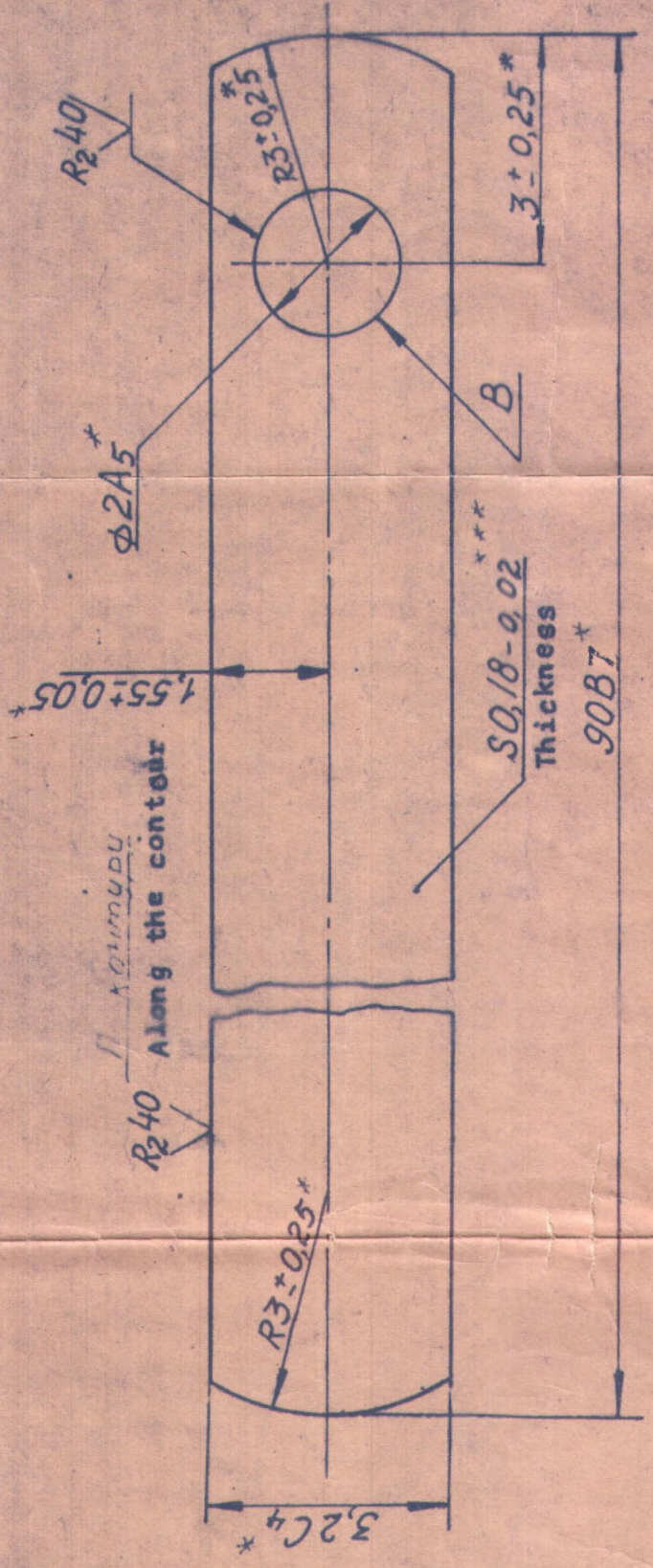
NOTE 10 : INDIGENOUS MATL : IS 14811 - 2000 CONDITION HD. MATERIAL SHOULD CONFORM TO GRADE CU CATH-2 TO SPECN. IS : 191-2007.

600 * 290 * 8/11

ЕСКД



Blank



3-0105875

Sheet No.	No. of sheets	
2	2	
SHEET WEIGHT SCALE		
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		
SNC'S	DOC NO	SIGN DATE
DRAWN		
EDITING		
F/M, DC		
DIV. OFFR		
NAME	SIGN	DATE
		11/3-77

APPROVED	SIGNATURE	FOR C/A
AHSP. - C1(A) KIRKEE	SIG. D.O.	SIG. D.O.
NOTE 10 FOR INDEGENOUS MATL. ADDED		
37271-A		
08-11-10		
22-2-91	DC-35030-A	DIMENSION 90 B7 WAS 90B2
24-9-87	DCI. 34241-A	DRG. PROV. SEALED.
DATE	AUTHORITY	REVISION

8367.009

Spiral

Copper band

1. Alternate material is band *ХПРПТ* 0.18 *НДМ*
 ГОСТ 1173-77 and band *ХПРПТ* 0.18 x 22 *НДТ*
 46-21-529-82.

2. Blank should be annealed before coating at a temperature of 620 ... 660°C with holding it at this temperature for 20 minutes. The spread of temperatures for one batch of blanks should be within 30°C. There should not be clearly marked ^{heat tint} after annealing.

3. Thickness of the blank after pickling should be 0,18-0,023 MM.

4. Dimensions ensured by tool.

5. ** Dimensions subjected to total checking.

6. *** Dimensions for reference.

7. Coating of blank: Sn 1μ

8. The following is allowed:

a) Deviation of thickness of blank material in different points before coating and after the pickling at a section not exceeding 15 MM of ±0,005 MM.

b) The thickness of blanks coating at least 0,5 MKM;
 c) Coating of blanks is chemical passivation/varnish *СМ-7-4* OST B 84-811-73.
 d) Cross mark and dent on one - two coils as against the standard sample, established by manufacture and agreed with customer representative at manufacturing plant;
 e) Deviation of external and internal coils within the limits of dimension A and ~~5~~ 6
 f) Scuffing of coating Sn on inner coil on the faces of part and in hole B without uncovering of copper.
 9. Other requirements are as per OST B 84-264-81.

Sheet No.	No of Sheets
1	2

3-0105875

A3-BT -032T

648.367.009

Spiral

APPROVED

[Signature]

FOR C I(A)

AHSP:- C I(A) KIRKEE.

SIG. *[Signature]*
 AHSP. D. O.

REVISION

DCI. 34241-A DRG. PROV. SEALED.

24-9-87
 DATE AUTHORITY