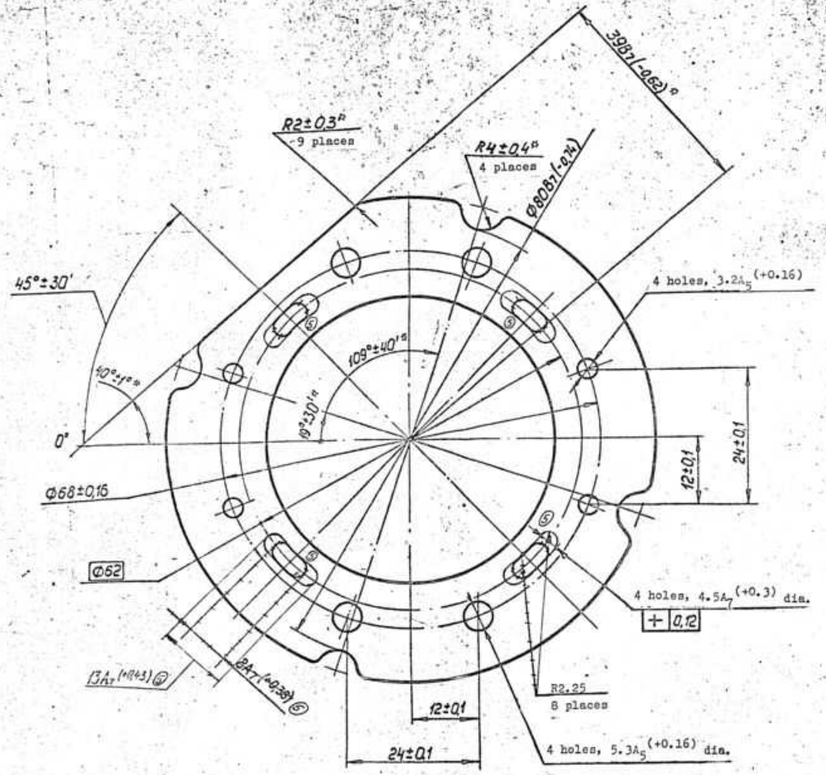
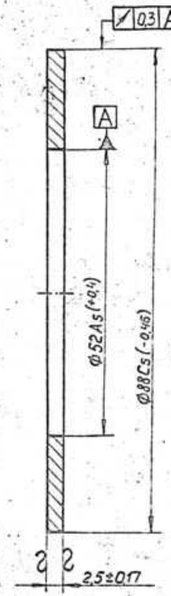
ЭД 25.005





TECHNICAL CONDITIONS

1. [illegible] zinc plating 15 followed by chromate treatment.
3. *Provide for sizes by appropriate tools which are to be checked at least once quarterly.

[redacted]

APPROVED		50 10 2073	
CHECKED		ЭД 25·005	
	CROSS BEAM	WEIGHT 0·066	SCALE 2:1
		SHT	SHTS. 1
SHEET	6-2·5 ГОСТ 19904-74 2-(I-10 ГОСТ 16523-76		

ЭД 25·005

EXPLANATORY NOTES TO TECH. CONDITIONS

1. CROSS BEAM SHOULD BE MANUFACTURED FROM COLD ROLLED QUALITY CARBON STEEL OF GRADE 10, SHEET 2·5 mm THK. WITH STANDARD ROLLING ACCURACY (B) CATEGORY 4 & HIGH SURFACE FINISH (II) HAVING THE DIMENSION OF SHEET AS PER GOST 19904-74 AND CHEMICAL COMPOSITIONS & MECHANICAL PROPERTIES CONFORM TO GOST 16523-78 & GOST 1050-74.

b) CHEMICAL COMPOSITION (GOST 1050-74)

CONTENTS OF ELEMENTS %			
CARBON	SILICON	MANGANESE	CHROMIUM.
0·07-0·14	0·17-0·37	0·35-0·65	0·15 (MAX.)

c) MECHANICAL PROPERTIES :-

a) TENSILE STRENGTH —— 30-42 Kgf/mm²
b) RELATIVE ELONGATION —— 28 %

d) ⌖ 0·3 A :- REPRESENTS THE RUN OUT OF INDICATED DIMENSION TO BE WITHIN 0·3 mm FROM THE BASE INDICATED AS 'A'

e) A :- INDICATES BASE DIMENSION IS 'A'

f) DIMENSIONS SHOWN IN RECTANGLES ARE WITHOUT TOLERANCES BUT THOSE ARE NOT A FREE DIMENSIONS.

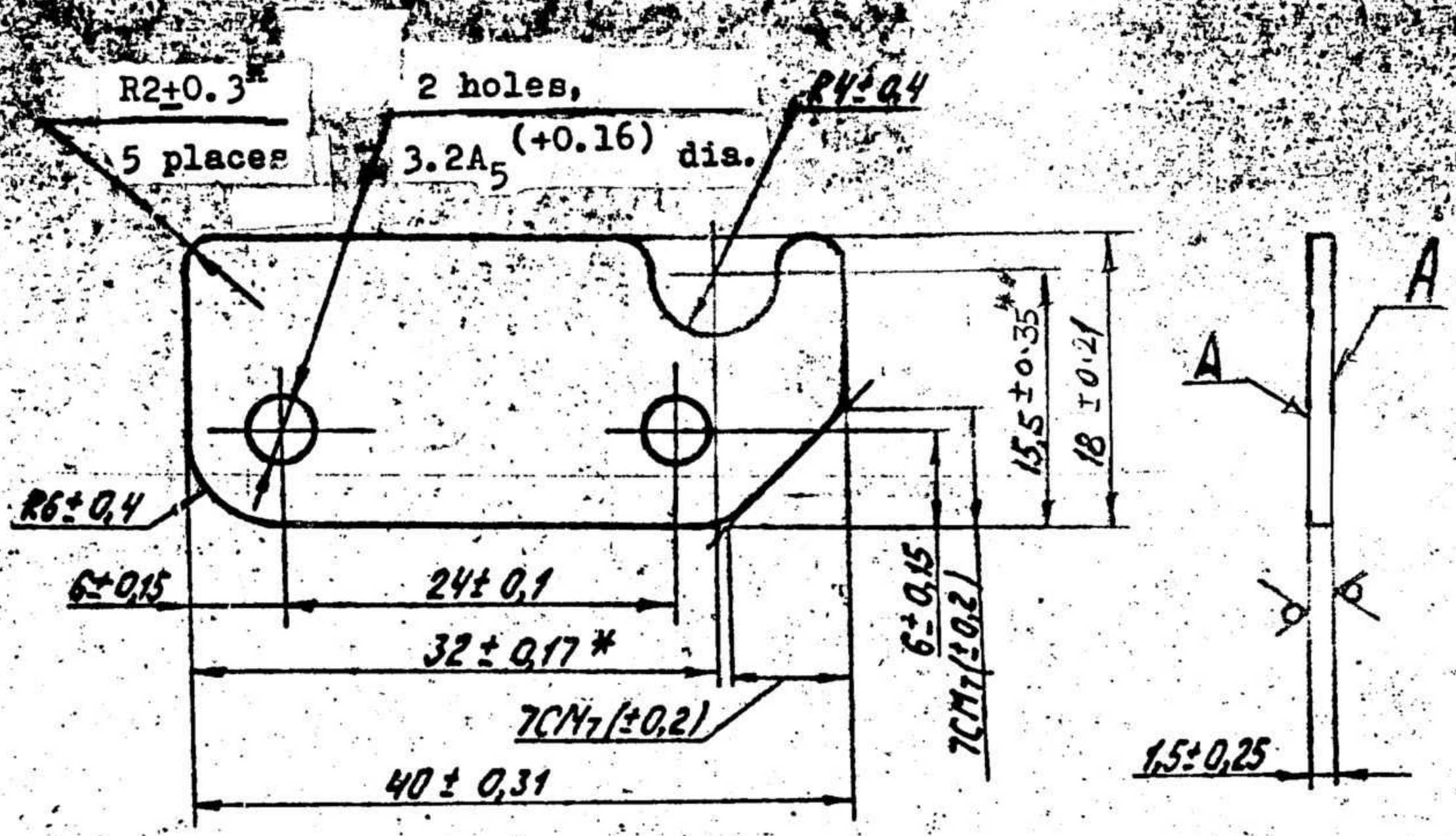
2. SURFACE FINISH :-

∇3 - REPRESENTS SURFACE FINISH TO BE OBTAINED IN Ra VALUE OF 50 μ ON BOTH SIDE OF THE JOB.

∇3(▽) - REPRESENTS SURFACE FINISH TO BE OBTAINED IN Ra VALUE OF 20 μ ON THOSE SURFACES WHERE SURFACE FINEN IS NOT SPECIFIED.

⌖ 0·12 DISPLACEMENT OF HOLE EXES TO BE WITHIN 0·12 mm FROM ITS THROUGH POSITION

											INSCRIBED		DRG. NOT TO BE SCALED.	PERTAINS TO
											CHECKED		ALL SHARP EDGES & CORNERS ARE TO BE ROUNDED OFF.	
											APPROVED		ALL DIMENSIONS ARE IN MM. UNLESS OTHERWISE SPECIFIED.	
											DATE	17-11-86	CROSS BEAM	ЭД 25.005
											TOLERANCE UNLESS OTHERWISE SPECIFIED.			
DC(I)	DT.	ZONE	BRIEF RECORD							SIGN.	GEN	ERC	ANG.	SCALE :-
														CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT. PUNE.



TECHNICAL CONDITIONS

1. Impregnate with varnish ГФ-95 ГОСТ 8018-70.
2. Local tears of 0.5 mm, max., deep are allowed on the part contour without chipping of surfaces A.
3. * Provide for sizes by appropriate tools which are to be checked at least once quarterly.
4. *1 Size for reference.

REFER TO DRG No ЭД.25.003 FOR EXPLANATORY NOTES

SURFACE FINISH

▽ REPRESENTS THE REMOVAL OF MATERIAL IS NOT PERMITTED ON BOTH SIDES OF THE JOB.

(R VEERARAGHAVAN)
SSO-II

51/D2073

APPROVED

CHECKED M. Balachandra

CONTROLLERATE OF INSPECTION
FE [redacted] PUNE

ЭД 25·006

GASKET

GLASS-CLOTH-BASE LAMINATE CT-I-1·5, ГОСТ 12652-74

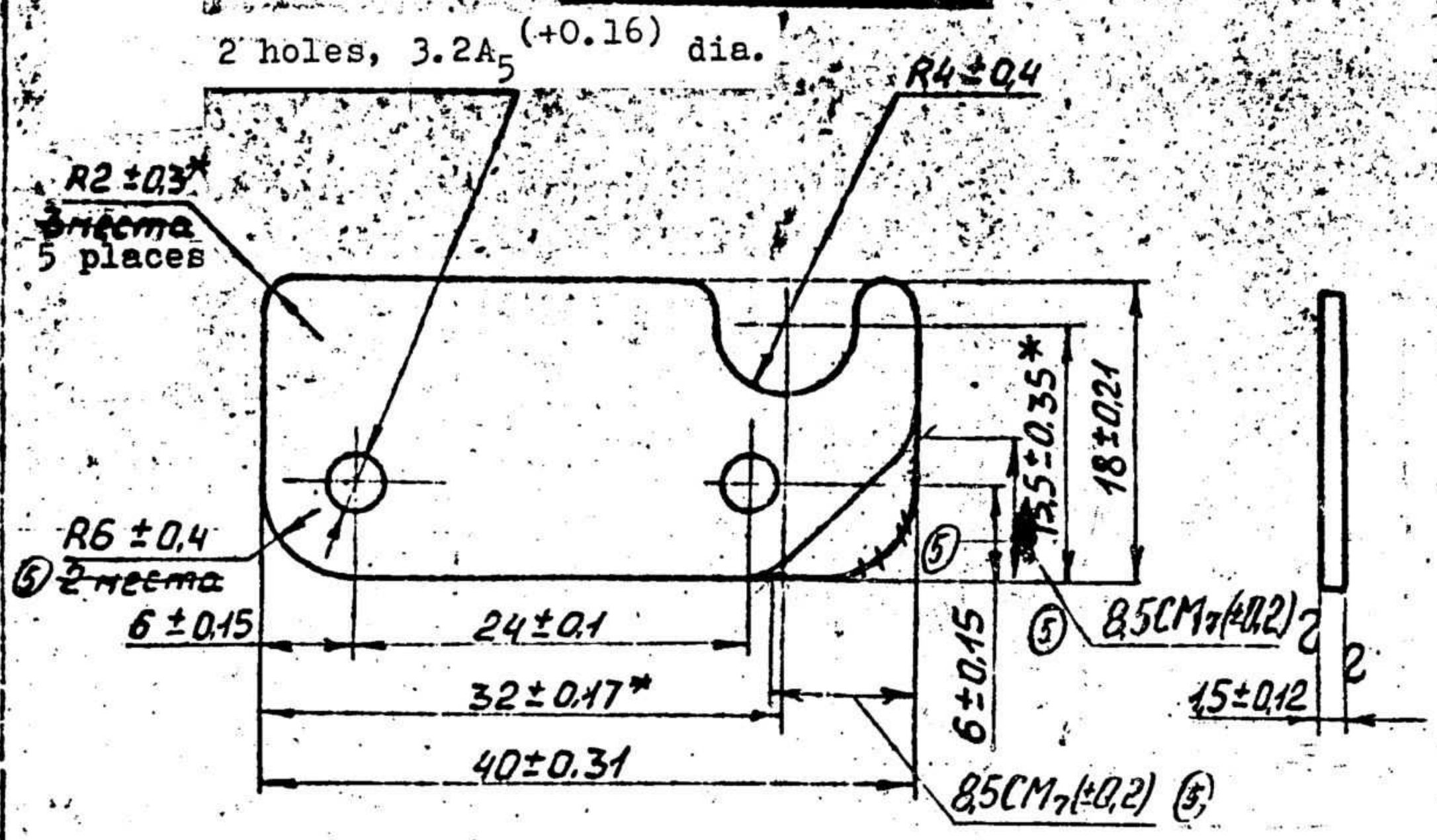
	WEIGHT	SCALE
	0·028	2:1

SHT SHTS 1

1-4-4

LOOSCUE [redacted]

▽3(▽)



"REFER TO DRG No ЭА 25.005 FOR EXPLANATORY NOTES"

SURFACE FINISH

▽|▽ – REPRESENTS SURFACE FINISH TO BE OBTAINED IN Ra VALUE 80 μ MAX; ON BOTH SIDE OF THE JOB

▽3(▽) REPRESENTS SURFACE FINISH TO BE OBTAINED IN Ra VALUE 20 μ MAX. ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.

R V VEERARAGHAVAN
SSOII

TECHNICAL CONDITIONS

1. Coating: zinc plating 15 followed by chromate treatment.
2. Provide for size by appropriate tools which are to be checked at least once quarterly.

[redacted]

52102973

APPROVED MVABV	ЭП 25·007		
CHECKED		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION FE (I C V) PUNE	GASKET	0·008	2:1
		SHT	SHTS 1
	SHEET Б 1·5 ГОСТ 19904-74 / 4-П-10 ГОСТ 16523-70		1-4-4

Инв. № подлинника | Подпись и дата | Взам. инв. № | Инв. № дубл. | Подпись и дата | Инв. № подлинника

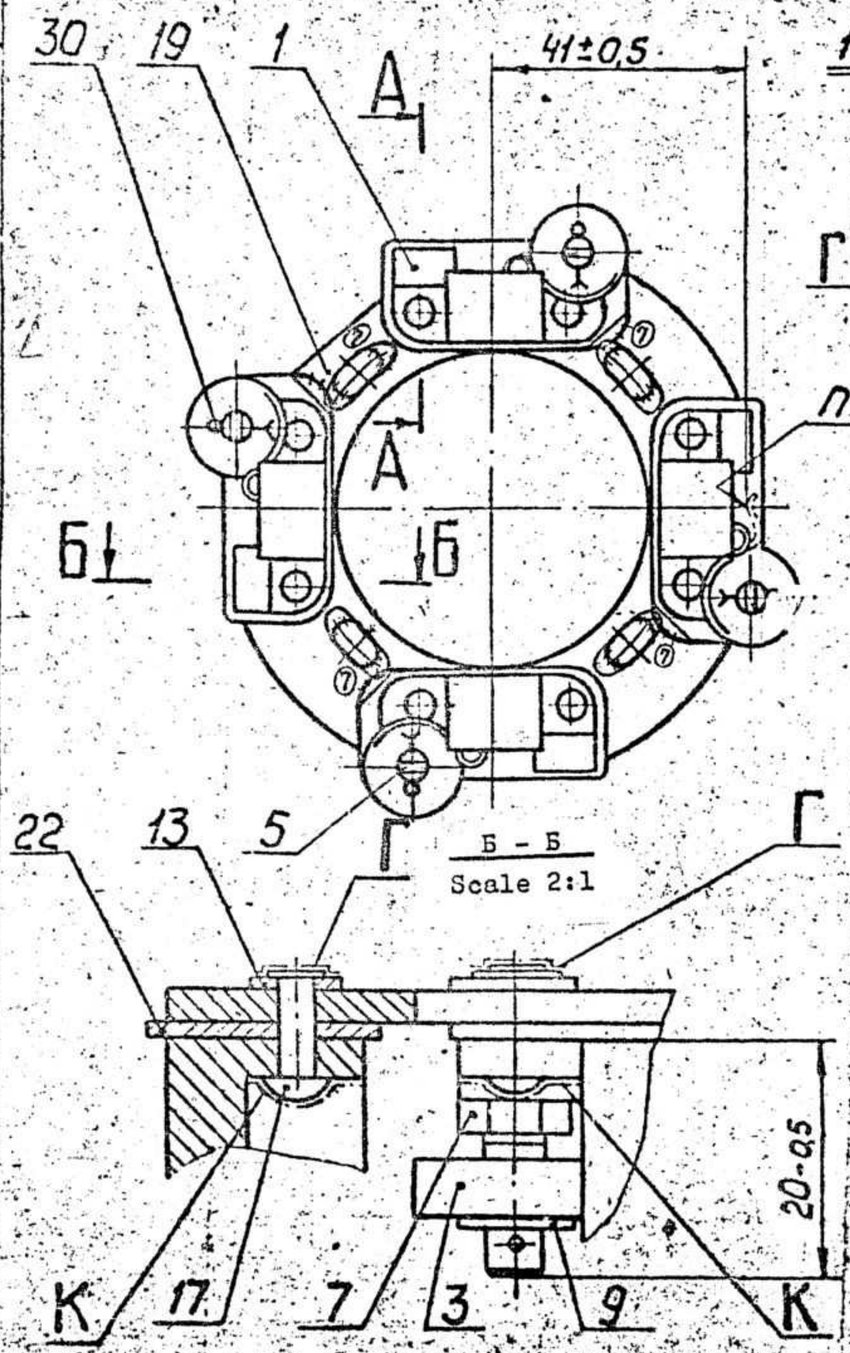
No.	Designation	Description	Qnty	Remark
		Documentation		
	ЭД25.050 СБ	Assembly drawing		
		Parts		
1	МВ67.035	Brush holder	4	
3	МВ67.110	Spring	4	
5	МВ67.111	Shaft	4	
7	Х2-43-92	Nut	4	
9	Х3-10323	Washer	4	
10	Х3-10482	Washer 3.01.016 ГОСТ 10450-78	8	Maximum number
11	Х5-29-48-01	Insulating washer	16	
13	Х3-9675	Washer	8	
15	Х5-114-53-01	Washer	4	
17	8Х-525	Rivet	4	
18	8Х-4191	Rivet	4	
19	ЭД25.005	Cross beam	1	
21	ЭД25.006	Gasket	2	
22	ЭД25.007	Gasket	2	
		Standard Items		
30		Pin 1.6x12.016 ГОСТ 397-79	4	

19/02073

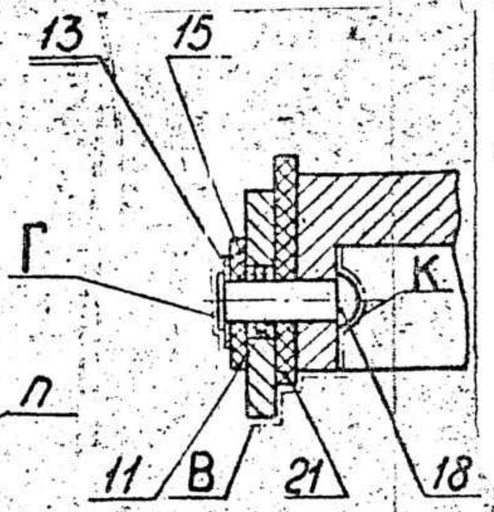
APPROVED		ЭД25.050		
CHECKED	OPRA			
CONTROLLERATE OF INSPECTION FE (ICV) PUNE		CROSS BEAM	WEIGHT	SCALE
			SHT	SHTS

1-4-4

3425.050СБ



А - А
Scale 2:1



Б - Б
Scale 2:1

TECHNICAL CONDITIONS

1. Set the pressure (550±25 g) of springs, Ref. No. 3, at points "П" by turning the shaft, Ref. No. 5. Lock the shaft with nut, Ref. No. 7.
2. Upon beading the rivets, coat surfaces К and В with enamel ГФ-92ХС, grey, ГОСТ 9151-75.
3. Parallel misalignment relative to windows of opposite brush holders is within 0.2 mm.
4. Use washers, Ref. No. 10 or Ref. No. 13, as may be required by the protruding length of rivets, Ref. No. 17 or Ref. No. 18.

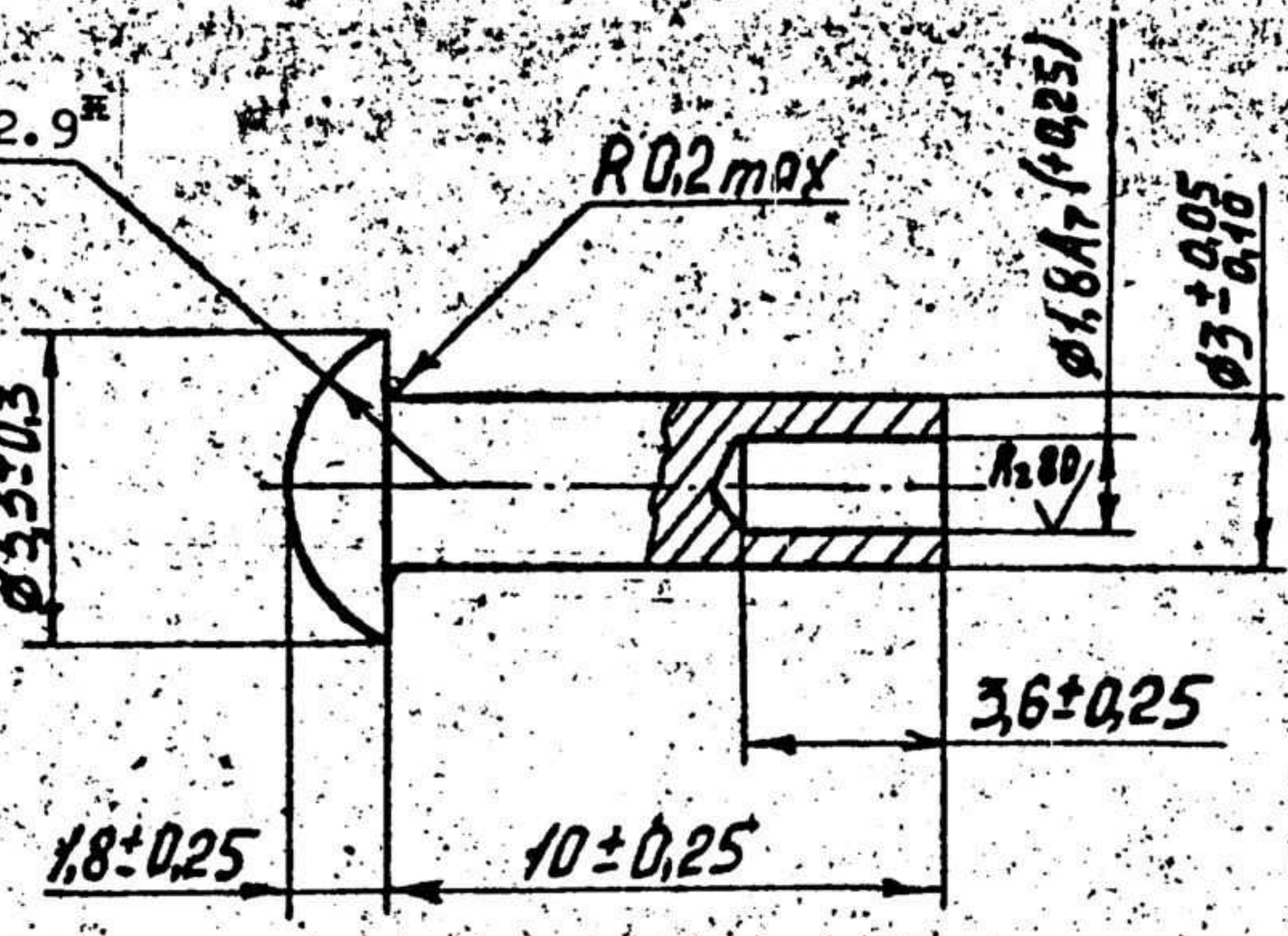
20/D2075

APPROVED	ЭД25-050 СБ		
CHECKED		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION	CROSS BEAM ASSEMBLY DRAWING	0·16	1:1
FE (I C PUNE		SHT	SHTS 1

3425.01005
Инв.№ подл. | Подп. и дата | Взам.инв.№ | Инв.№ дубл. | Подп. и дата

8X-525 [redacted]

$R_z 40$ / (V)



REFER DRG No X2-4392 FOR MATERIAL

Designation	Coating
8X-525	Zinc plating 6 followed by chromate treatment

HARDNESS
BHN (143 MAXIMUM)

TECHNICAL CONDITIONS

1. *Size for reference.
2. Tolerable displacement relative to the rod axis:
   head axis - 0.2 mm, hole axis - within 0.1 mm.
3. Other technical requirements as per ГОСТ 12644-80.

SURFACE FINISH

Rz 80/ :- REPRESENTS SURFACE FINISH TO BE OBTAINED BY ANY PRODUCTION METHOD IN Rz VALUE 80 µ MAX.

Rz 40/ (V) :- REPRESENTS SURFACE FINISH TO BE OBTAINED BY ANY PRODUCTION METHOD IN Rz VALUE 40 µ MAX ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.

CR VEERARAGHAVAN SSO II | PI | D2073

APPROVED

CHECKED

CONTROLLERATE OF INSPECTION
FE (I C V) PUNE

8X-525

RIVET

STEEL 10 ГОСТ1050-74

	WEIGHT	SCALE
	0.68	5:1

SHT SHTS 1

1-4-4

Инв. № подл. | Подпись и дата | Взам. инв. №

Copied with changes

Перв. примен.

Справ. №

Подпись и дата

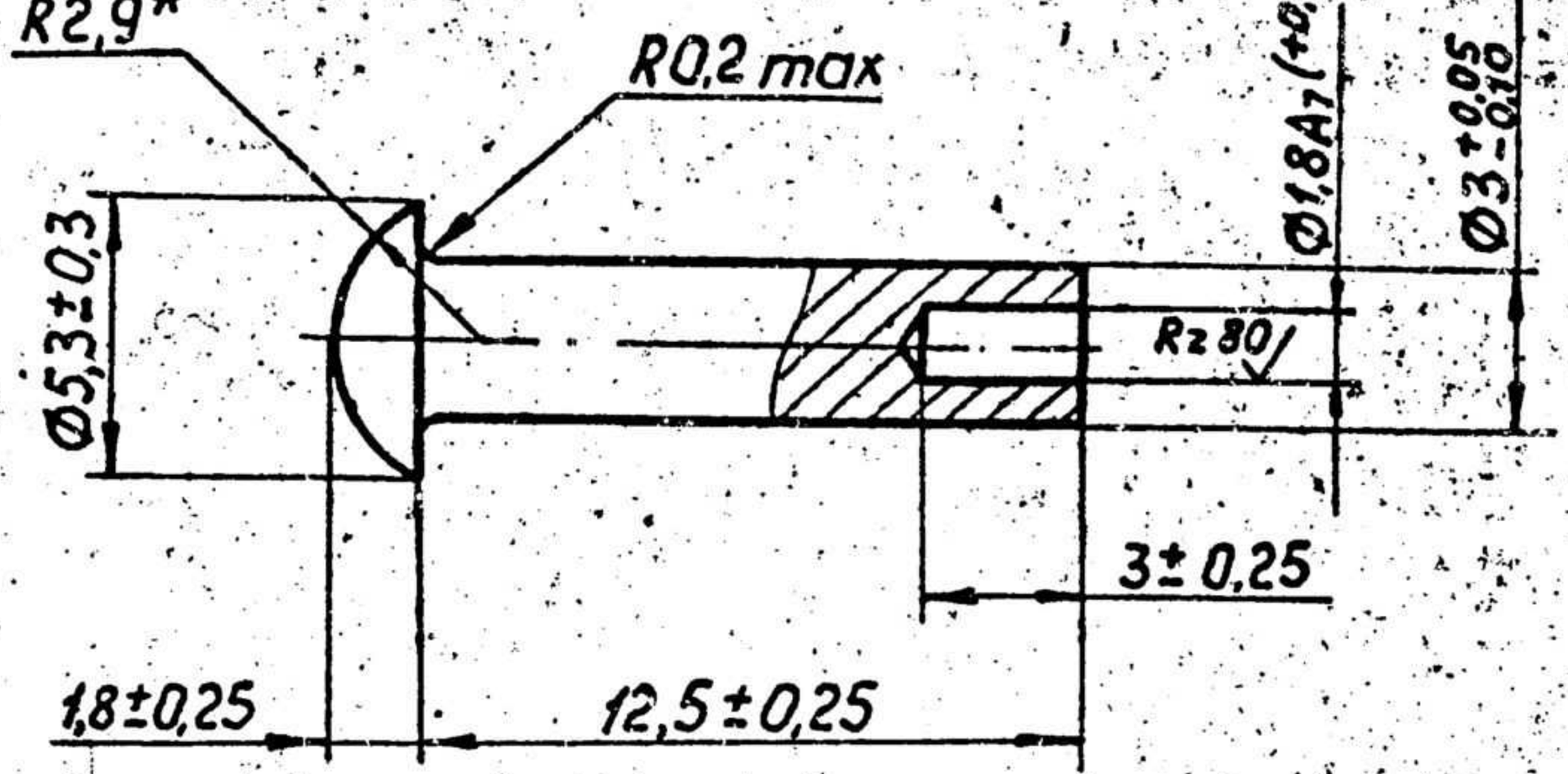
Инв. № дубл.

Взам. инв. №

214

8X-4191

Rz 40 / (V)



HARDNESS-BHN 143(MAXIMUM)

Designation	Coating
8X-4191	Zinc plating 6 followed by chromate treatment

Rz 80 / : REPRESENTS SURFACE FINISH TO BE OBTAINED BY ANY PRODUCTION METHOD IN RZ VAVUE 80 μ MAX.

TECHNICAL CONDITIONS

"REFER DRG NO X2-4392 FOR MATERIAL"

1. *Size for reference.
2. Tolerable displacement relative to the rod axis:
   head axis - 0.2 mm; hole axis - 0.1 mm.
3. Other technical requirements as per ГОСТ 12644-80.

SURFACE FINISH

Rz 40 / (V) REPRESENTS SURFACE FINISH TO BE OBTAINED BY ANY PRODUCTION METHOD. IN Rz VALUE 40 μ MAX. ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.

(R VEERARAGHAVAN) 85/D2073
SSOTE

APPROVED MTASV

CHECKED. A. Balakrishna

CONTROLLERATE OF INSPECTION

FE (I C V) PUNE

8X-4191

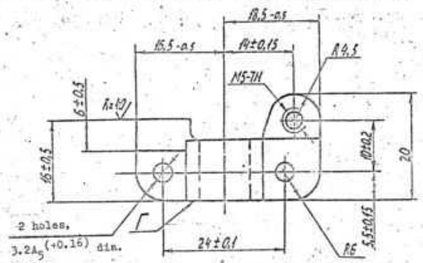
SPECIAL RIVET

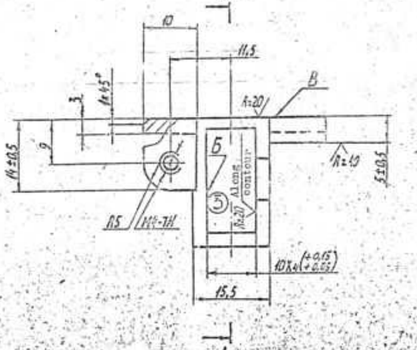
	WEIGHT	SCALE
	0.85g	5:1
SHT	SHTS. 1	

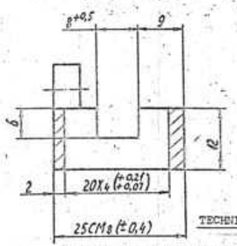
STEEL 10 ГОСТ 1050-74

1-4-4

MB67.035







TECHNICAL CONDITIONS

1. Material substitute: Casting I-OCT3-4227-79 AL9 KT5 ГОСТ 2685 75
2. Tolerable deviations of sizes are within ±0.25 mm, angular deviations, within ±30' unless otherwise specified.
5. Casting slope gradients are 2° in increasing order of outer sizes and in decreasing order of inner sizes.
6. Casting radii are within 3 mm.
7. Round off sharp edges to R ≈ 0.3 mm.
8. Squareness tolerance of axis of window B relative to surface is within 0.3 mm.
9. Markings may be omitted.
10. Tolerable sinks left by the pushers on surface Г, should be within 0.5 mm deep.

APPROVED		MB67·035	
CHECKED		BRUSH HOLDER	WEIGHT 1.8 kg / SCALE 2
			SHT / SHTS
		CASTING I-OCT5-4227-79 AL2 Д ГОСТ 2685-75	

Easy2Convert
www.easy2convert.com

MB67·035

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

BRUSH HOLDER SHOULD BE MANUFACTURED FROM ALUMINIUM PRESSURE DIE CASTING ALLOYS OF GRADES AL2 OR AL9 OF GOST 2685-75 THE METHOD OF CASTING FOR AL2 IS PRESSURE DIE CASTINGS (Д) AND FOR AL9 CHILL MOULD CASTING (К)

CHEMICAL COMPOSITION

GRADE OF ALLOYS	BASIC COMPONENTS %						ADMIXTURE % (MAX)									
	ALUMINIUM	MAGNESIUM	SILICON	MANGANESE	IRON К	IRON Д	MAGNESIUM	MANGANESE	COPPER	ZINC	TIN	LEAD	TITANIUM	BERILLIUM	ZIRCONIUM	TOTAL OF CALCULATED ADMIXTURES К / Д
AL2	BASE	–	10·0-13·0	–	–	1·50	0·10	0·50	0·60	0·30	–	–	0·15	–	0·10	– / 2·20
AL9	BASE	0·2-0·4	6·0-8·0	–	1·00	–	–	0·50	0·20	0·30	0·01	0·05	–	0·10	0·15	1·50 / –

III MECHANICAL PROPERTIES OF GRADE AL2 Д AND GRADE AL9 КТ5 IS AS GIVEN BELOW

GROUP OF ALLOYS	GRADE OF ALLOYS	PARTIAL RESISTANCE kg/mm² (NOT LESS THAN)	SPECIFIC ELONGATION % (NOT LESS THAN)	HARDNESS AS PER BRINELL MB
I	AL2 Д	16	1	50
I	AL9 К	21	2	60

TB HARDENING AND SHORT TIME (INCOMPLETE) ARTIFICIAL AGEING

SURFACE FINISH

Rz 80 (▽) :- REPRESENTS THE SURFACE FINISH OF Rz VALUE 80 MICRONS ON THOSE SURFACES BY ANY PRODUCTION METHOD WHERE THE SURFACE FINISH IS NOT SPECIFIED

Rz 40 :- REPRESENTS THE SURFACE FINISH OF Rz VALUE OF 40 MICRONS

Rz 20 :- REPRESENTS THE SURFACE FINISH OF Rz VALUE OF 20 MICRONS

										INSCRIBED	
										CHECKED	
										APPROVED	
DCN	D·T	ZONE	BRIEF RECORD	SIGN						DATE	13-11-79
										TOLERANCE UNLESS OTHERWISE SPECIFIED GEN. DEC. ± ANG.	

DRG NOT TO BE SCALED
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF
ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED

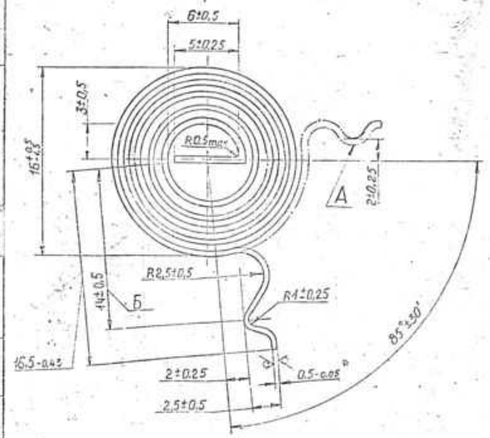
PERTAINS TO

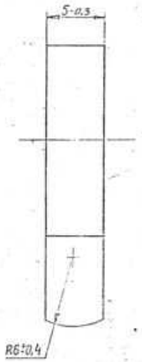
BRUSH HOLDER MB67-035

SCALE :-

CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT PUNE

MB67-110





1. HRA 72 to 75.
2. Dimensions given with symbol (R) is given for reference.
3. Number of working turns 5.
4. Increase in the width of spring upto 6mm due to face projections/ burrs as well as deviation from the face plane/axis for measuring over dimension B are allowed.
5. Tangle angle due to changed depending on heat treatment and material during the coiling of springs.
6. Touching of turns after heat treatment is not allowed.
7. Pressure of spring 'A' at point 'A' should be 81 +100 -50 gf
8. Coating shall be applied of varnish ГФ-95, GOST 8018-...

								MB67-110	
DRAWN	DOC. NO	SIGN	DATE					SHEET WEIGHT	SCALE
EDITED BY								0 3.7g	1:1
P/N, DC				SPRING				TOTAL SHEET	
DIV.OFFR									
	NAME	SIGN	DATE	Band: YBA-1-H-0.5 IOCT 21567-76					

MB 67-110

EXPLANATORY NOTES TO TECH. CONDITIONS.

SPRING SHOULD BE MANUFACTURED FROM COLD-DRAWN SPRING STEEL BRAND WITH RESPECT TO THE SURFACE INTO LIGHT- IN DARK (C) WITH THICKNESS 0.5MM OF GRADE YBA AS PER GOST 2283-69

CHEMICAL COMPOSITION AS PER GOST 1435-74 (AS REFFERED IN GOST 2283-69)

1) CARBON % — 0.75 - 0.84
2) MANGNESE % - 0.15 - 0.30
3) SILICON % - 0.15 - 0.38
4) SULPHUR % — 0.020 MAX.
5) PHOSPHORUS % — 0.030 MAX.

MECHANICAL PROPERTIES AS PER GOST 2283-69

1) ULTIMATE TENSILE STRENGTH Kgf/mm² — 76 TO 120
2) THE TOTAL DEPTH OF SINGLE-SIDE DECARBONISING OF THE SHEET MUST NOT EXCED — 0.02 m.m.

COATING : PHYSICO - CHEMICAL AND ELECTRICAL PROPERTIES OF THE VARNISH ГФ-95 (ELECTRO-INSULATING, IMPREGNATING) OF GOST-8018-70 ARE GIVEN BELOW.

PROPERTIES	NORMS
1 PRESENCE OF MECHANICAL INCLUSIONS IN VARNISH 2 APPEARANCE OF VARNISH FILM	NIL AFTER DRYING THE VARNISH SHOULD FORM A GLOSSY, HOMOGENEOUS AND SMOOTH FILM
3 VISCOSITY BY VISCOSIMETER B3-4 AT 20°C, IN SECS.	30 → 50
4 DRY RESIDUE CONTENT IN % NOT LESS THAN	45
5 ACID NUMBER IN Mg OF KOH, NOT EXCEEDING	12

PROPERTIES	NORMS
6 DRYING TIME AT 105 - 110°C IN HOURS NOT EXCEEDING	2
7 THERMOELASTICITY OF FILM AT 150°C IN HOURS NOT LESS THAN	48
8 HARDNESS OF FILM BY PENDULUM TESTER AT 20 ± 2°C NOT LESS THAN	0.40
9 OIL RESISTANCE OF FILM IN Kg NOT LESS THAN	6
10 ELECTRICAL STRENGTH OF FILM IN kv/mm NOT LESS THAN AT 20 ± 2°C AT 120 ± 2°C AFTER ACTION OF WATER FOR 24 HRS. AT 20 ± 2°C	90 40 20
11 VOLUME RESITIVITY OF FILM IN OHM Cm NOT LESS THAN AT 20 ± 2°C AFTER ACTION OF WATER FOR 24 hrs. AT 20 ± 2°C	$1 \cdot 10^{14}$ $1 \cdot 10^{12}$

SURFACE FINISH

1) ⌀ specified roughness to be obtained by without removal at material on both side of the job.
2) $R_z 80$ (▽) represents surface finish value Rz 80 microns. On those surfaces where surface finish is not specified.

								INSCRIBED	
								CHECKED	
								APPROVED	
								DATE	23-11-87
								TOLERANCE UNLESS OTHERWISE SPECIFIED GEN ; DEC ; ANG	
DCN	D-T	ZONE	BRIEF RECORD				SIGN		

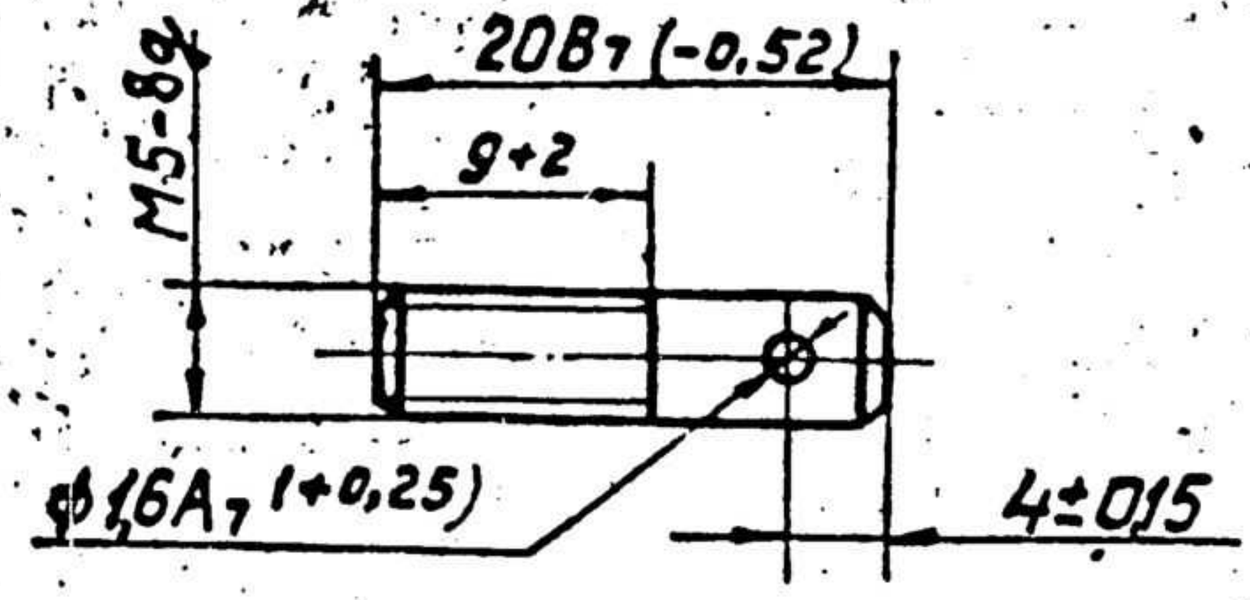
DRG NOT TO BE SCALED
ALL SHARP EDGE & CORNERS TO BE ROUNDED OFF
ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE SPECIFIED

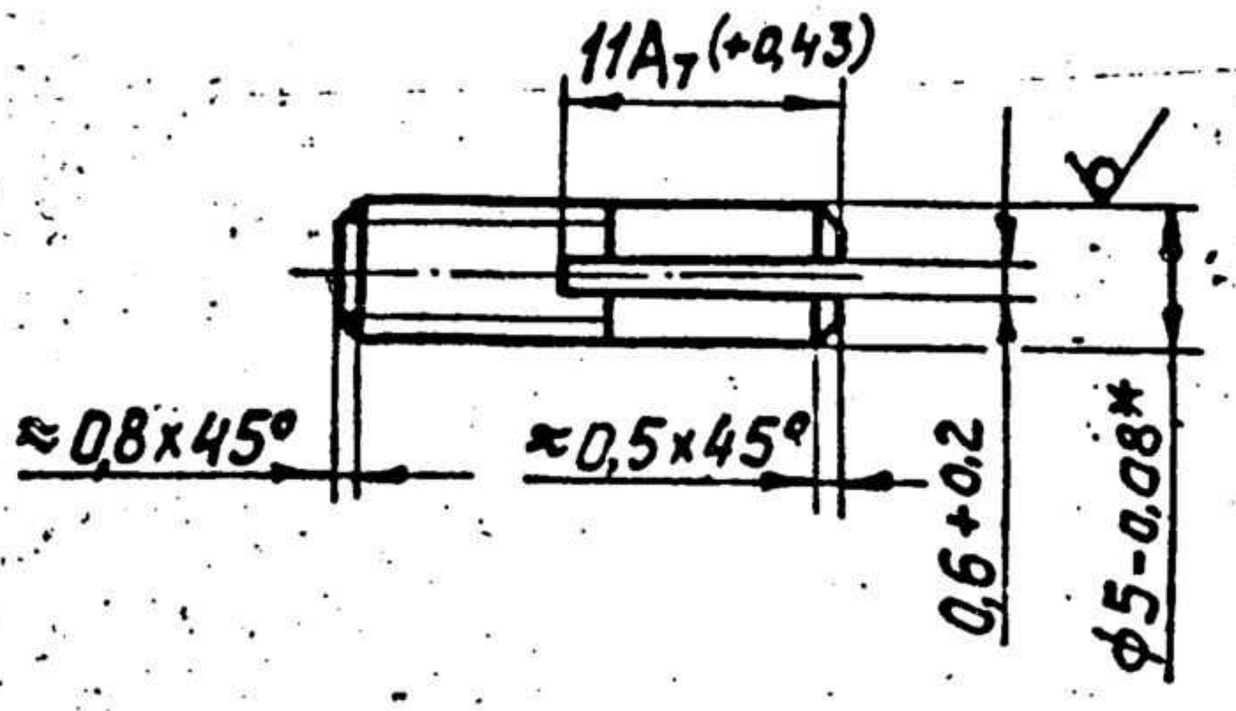
PERTAINS TO
MB67 - 110
SPRING

SCALE -
CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT PUNE

MB67-111

Rz40 √ (√)





Designation	Coating
MB67-111	Zinc plating 6 followed by chromate treatment

TECHNICAL CONDITIONS

1. Size for reference.
2. The slot displacement relative to the axis should be within 0.4 mm.
3. Round off sharp edges: chamfer ≈0.3 mm x 45° or radius ≈ ≈0.3 mm.

"REFER TO DRG NO ЭА25.038 FOR EXPLANATORY NOTES"

(R. VEERARAGHAVAN)
SSO-II

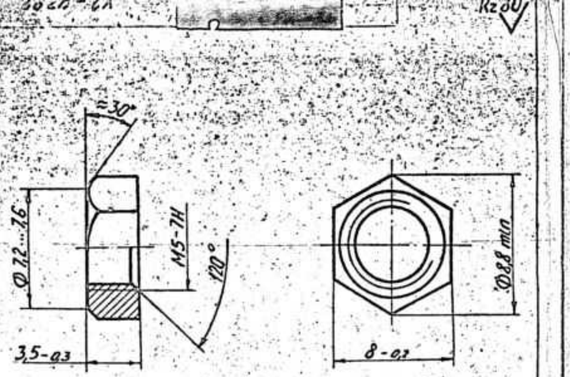
78/D2073

APPROVED	MB67-111		
CHECKED.		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION	SHAFT	3·18	2:1
		SHT	SHTS. 1
	ROUND BAR 5-4 IOCT7417-75 / A-12-H B IOCT1414-75		

1-4-4

Инв. № дубл. | Подпись и дата | Инв. № подл. | Справ. №

M853



Designation	Coating
X2-4392	Zinc plating 6 followed by chromate treatment

TECHNICAL CONDITIONS

1. Tolerable displacement of hole axis relative to edges is within 0.4 mm.
2. Technical requirements as per ГОСТ 1759-70.

06/D2073

APPROVED	X2-4392		
CHECKED		WEIGHT	SCALE
	NUT	0.9g	5:1
		SHT	SHTS 1
	STEEL 10 ГОСТ 1050-74		

X2-4392

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

(I) NUT, ~~SCREW~~, ~~RIVET~~ SHOULD BE MANUFACTURED FROM CARBON STRUCTURAL HOT ROLLED STEEL OF GRADE 10, OF GOST 1050-74. ~~B~~ HAVING THE FOLLOWING CHEMICAL COMPOSITION.

STEEL OF GRADE	CONTENT OF ELEMENT%			
	CARBON	SILICON	MANGANESE	CHROMIUM (MAX)
10	0·07-0·14	0·17-0·37	0·35-0·65	0·15

(II) MECHANICAL PROPERTIES OF STEEL GRADE 10, OF GOST 1050-74 IS GIVEN BELOW.

HEAT TREATMENT OF BLANKS	NORMALISING
YIELD POINT	21 kgf/mm² (MIN)
ULTIMATE TENSILE STRENGTH	34 kgf/mm² (MIN)
PERCENTAGE ELONGATION	31% (MIN)
REDUCTION OF AREA	55% (MIN)

(III) THE RECOMMENDED HEATING TEMPERATURE DURING HEAT TREATMENT OF BLANKS. CARRYING OUT THE TESTS OF MECHANICAL PROPERTIES OF STEEL GRADE IS GIVEN BELOW.

STEEL GRADE	NORMALISING
10	920°C

RECOMMENDED MINIMUM HOLDING PERIOD IN NORMALISING — 30 MINUTES

(IV) SURFACE FINISH

Rz 80 REPRESENTS SURFACE FINISH TO BE OBTAINED BY ANY PRODUCTION METHOD IN Rz VALUE 80 μ MAX. ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.

DC(I)	DATE	ZONE	BRIEF RECORD	SIGN

INSCRIBED	Amul	DRG NOT TO BE SCALED
CHECKED	[illegible]	ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.
APPROVED	[illegible]	ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED
DATE	5.7.80	NUT
TOLERANCE UNLESS OTHERWISE SPECIFIED	GEN ; DEC ; ANG	SCALE:- —

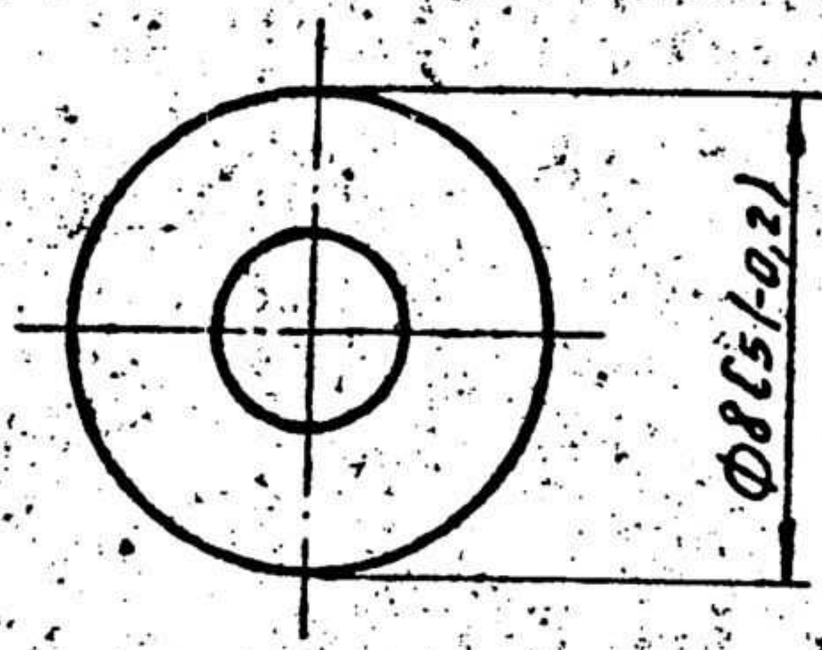
PERTAINS TO X2-4392

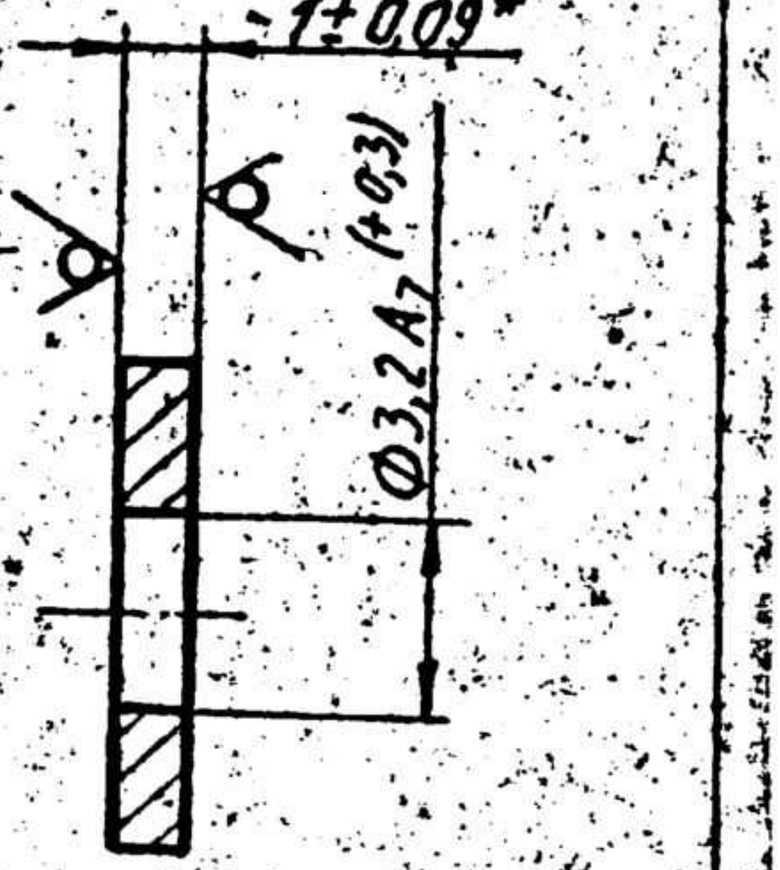
CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT PUNE

X3-9675

[redacted]

Rz 80 √(V)





Designation	Coating
X3-9675	Zinc plating 6 followed by chromate treatment

1. *Size for reference.

"REFER TO DRG NO 3M 25.005 FOR EXPLANATORY NOTES."

SURFACE FINISH

✓ REPRESENTS SURFACE FINISH TO BE OBTAINED BY WITHOUT REMOVAL OF MATERIAL ON BOTH SIDES OF THE JOB

Rz 80 √(V) REPRESENTS SURFACE FINISH TO BE OBTAINED BY ANY PRODUCTION METHOD IN RZ VALUE 80 μ Max, ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.

(R. VEERARAGHAVAN) SSO-II

87/D2073

APPROVED [signature]

CHECKED [signature]

CONTROLLERATE OF INSPECTION

FE [redacted] PUNE

X3-9675

WASHER

	WEIGHT	SCALE
	0.6g	5:1
SHT	SH'TS 1.	

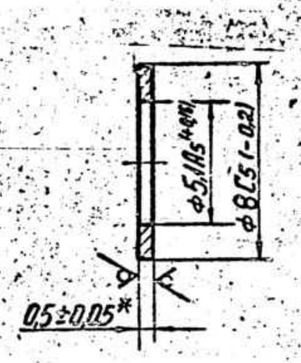
SHEET 4-II-10 БІ ГОСТ 19904-74 / ГОСТ 16523-70

1-4-4

X3-10323

Rz 80/(V)

Designation	Coating
X3-10323	Zinc plating 6 followed by chromate treatment



1. Material substitute: Band 10-M-HT-2-0,5 ГОСТ 503-71.
2. *Size for reference.

D.CO	DT.	ZONE	BRIEF RECORD	SIGN			

APPROVED	MWASL	X3-10323	
CHECKED			
		WEIGHT	SCALE
	WASHER	0.15g	5:1
		SHT	SHTS. 1
SHEET	⌀0.5 ГОСТ 19904-74 / 4-П-10 ГОСТ 16523-70		

91/D2073

X3-10323

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

WASHER SHOULD BE MANUFACTURED FROM COLD ROLLED QUALITY CARBON STEEL TO GRADE 10 OF SHEET 0·5 mm THICK WITH STANDARED ROLLING ACCURACY (B) CATAGORY A) HIGH SURFACE FINISH (II) OR SHOULD BE MANUFACTURED FROM COLD ROLLED LOW CARBON STEEL BAND OF GRADE 10 SOFT (m), COLD WORKED WITH INCREASED MANUFACTURING ACCURACY IN THICKNESS (NT) AND SECOND GROUP SURFACE QUALITY WITH TRIMMED EDGE HAVING THE DIMENSIONS OF SIZE CHEMICAL COMPOSITIONS AND MECHANICAL PROPERTIES CONFORMING TO GOST 19904-74, GOST-16523-70, GOST-503-81 AND GOST 1050-74 AS GIVEN BELOW

(I) CHEMICAL COMPOSITION TO GOST 1050-74 (AS REFFERED IN GOST 16523-70 AND GOST 503-71)

CHEMICAL ELEMENTS %			
CARBON	SILICON	MANGANESE	CHROMIUM
0·07 – 0·14	0·17 - 037	0·35 – 0·65	0·15 (MAX)

(II) MECHANICAL PROPERTIES TO GOST 16523-70 AND GOST 503-71

GOST NO	TENSILE STRENGTH	RELATIVE ELONGATION
GOST 16523-70	30-42 kgf/mm²	28 % (MIN)
GOST 503 – 71	32-45 kgf/mm²	17% (MIN)

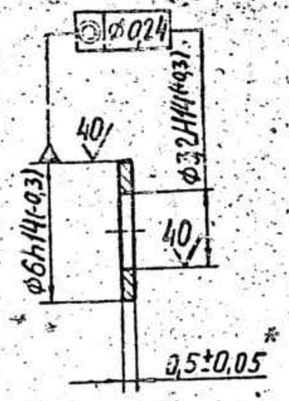
SURFACE FINISH

▽|▽ :- REPRESENTS SURFACE FINISH TO BE OBTAINED WITHOUT REMOVEL OF MATERIAL ON THOSE BOTH SIDE OF JOB.

Rz 80/(V) :- REPRESENTS SURFACE FINISH TO BE OBTAINED BY RAW PRODUCTION METHOD IN Rz VALUE OF 80 μ ON THOSE SURFACE WHERE SURFACE FINISH IS NOT SPECIFIED.

INSCRIBED		DRG NOT TO BE SCALED	PERTAINS TO
CHECKED	MW / [illegible]	ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.	
APPROVED	[illegible]	ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED	
DATE	17.11.88	WASHER	X3-10323
TOLERANCE UNLESS OTHERWISE SPECIFIED GEN I DEC I ANG		SCALE:-	
		CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT PUNE	

X3-10482



Designation	*	Coating
X3-10482	016	Zinc plating 6 followed by chromate treatment

TECHNICAL CONDITIONS

1. Material substitute: Band 08-М-НТ-2-0,5 ГОСТ 503-71
2. *Size for reference.
4. Other technical requirements as per ГОСТ 18123-72.

92/D2073

APPROVED	X3-10482		
CHECKED	WASHER 3-01* ГОСТ 10450-78	WEIGHT 0.079	SCALE 5:1
		SHT	SHTS 1
	SHEET Б0-5 ГОСТ 19904-74 / П-ВГ-0-8КП 9045-80		

X3-10482

EXPLANATORY NOTES TO TECH CONDITIONS

WASHER SHOULD BE MANUFACTURED FROM COLD ROLLED THIN SHEET OUT OF LOW CARBON ALLOY STEEL OF HIGH SURFACE FINISH, EXTREMELY DEEP DRAWN OF GRADE 08 КП TO GOST 9045-80.

(I) CHEMICAL COMPOSITION

CONTENT OF ELEMENTS %							
CARBON	MANGANESE	SULPHUR	PHOSPHORUS	SILICON	CHROMIUM	NICKEL	COPPER
0.10 (Max)	0.20 – 0.40	0.030 (Max)	0.025 (Max)	0.03 (Max)	0.10 (Max)	0.10 (Max)	0.15 (Max)

(II) MECHANICAL PROPERTIES

ULTIMATE STRENGTH, kgf/mm²	RELATIVE ELONGATION %
26 – 37	28

(III) DEEP DRAWING TEST
DEPTH OF SPHERICAL INDENTATION NOT LESS THAN 9.0 mm.

(IV) SYMBOL
⌖ Ø0.24 CONCENTRICITY OF HOLE DIA 3.2 H14 TO BE WITHIN 0.24 mm WITH REFERENCE TO BASE DIA 6 h 14

(V) SURFACE FINISH
40 – REPRESENTS SURFACE FINISH TO BE OBTAINED BY ANY PRODUCTION METHOD IN Ra VALUE 40 μ MAXIMUM
∅(√) – REPRESENTS SURFACE FINISH TO BE OBTAINED WITHOUT REMOVAL OF MATERIAL, ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED

DCC(I)	DATE	ZONE	BRIEF RECORD	SIGN

INSCRIBED	
CHECKED	
APPROVED	
DATE	5 MAY 86
TOLERANCE UNLESS OTHERWISE SPECIFIED GEN / DEC / ANG	

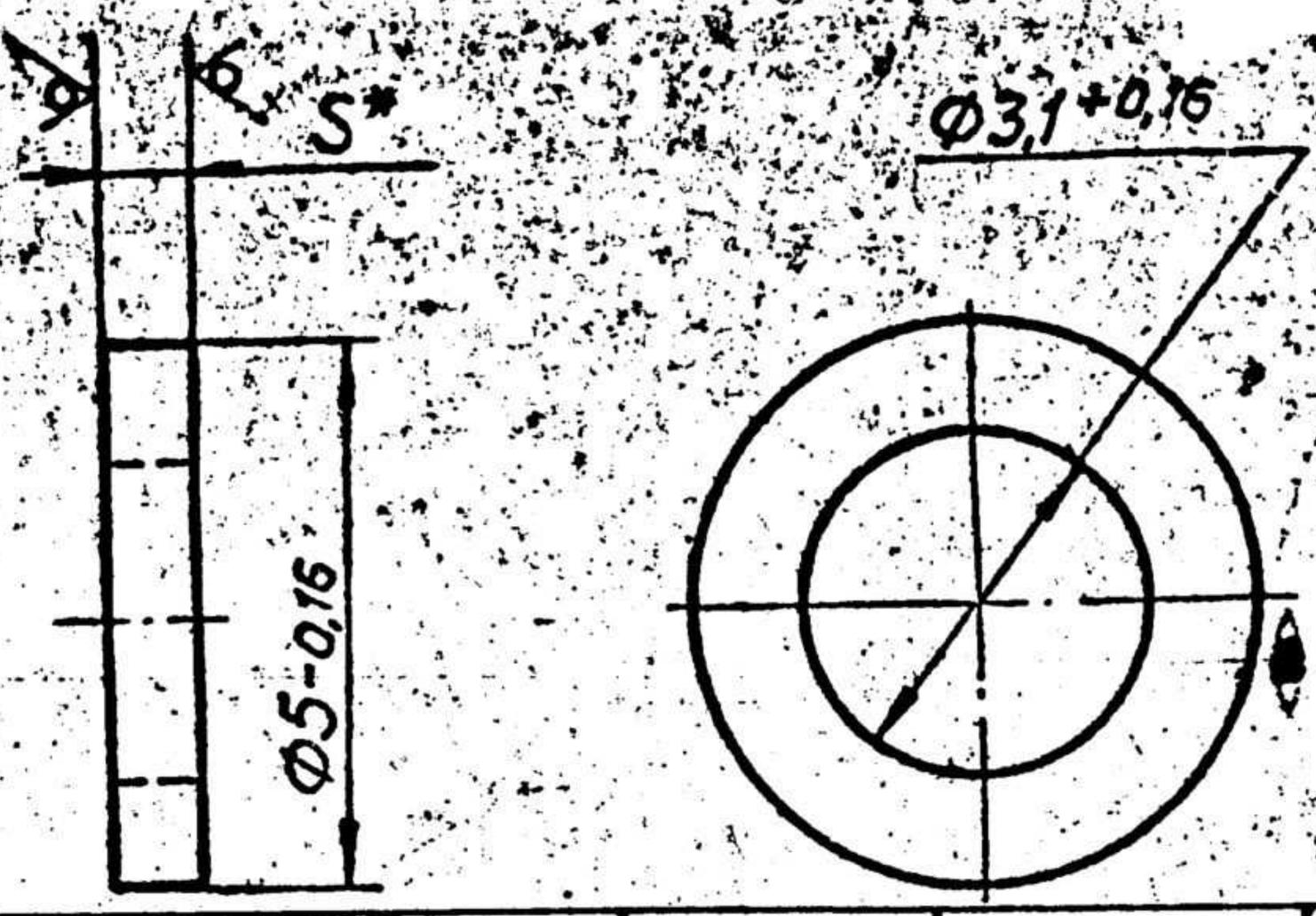
DRG NOT TO BE SCALED
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.
ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED
WASHER 3-01 GOST 10450-78
SCALE :-

PERTAINS TO
X3-10482

CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT PUNE.

X5-29-48

See table



Designation	S*	Material	Coating	Material substitute	Mass, kg	Rz
X5-29-48						
X5-29-48-01	0.5±0.15	Glass-cloth base laminate СТ-I-0,5 ГОСТ 12652-74	Varnish ГФ-95(1) ГОСТ 8018-70	Glass-cloth-base laminate СТЭФ-1-0,5 ГОСТ 12652-74	0.01	320

TECHNICAL CONDITIONS

(3) 1. *Size for reference.

2. Varnish МЛ-92(1) ГОСТ 15865-70 may be also used.

REFER TO DRG NO ЭЯ 25·003 FOR EXPLANATORY NOTES

SURFACE FINISH

9/6 INDICATES REMOVAL OF MATERIAL IS NOT PERMITTED ON BOTH SIDE OF THE JOB

(R. VEERARAGHAVAN)
SSO-II

Перепечатано с подлинника

Подпись и дата

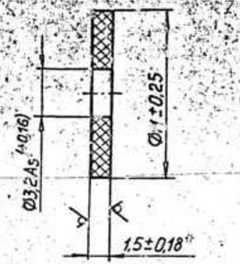
Инв. № дубл.

Инв. № подл. 7143

84/D2073

APPROVED	X5-29-48		
CHECKED.		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION FE (PUNE	INSULATING WASHER	SEE TABLE	10:1
		SHT	SHTS. 1
	SEE TABLE		1-4-4

X5-114-53-01 Rz80/ √(√)



Designation	Material	Material substitute	Coating
X5-114-53-01	Glass-cloth-base laminate CT-1-1,5 ГОСТ 12652-74		

TECHNICAL CONDITIONS

1. *Size for reference.
2. Varnish МЛ-92(1) ГОСТ 15865-70 may be also used.

96/D2073

APPROVED MVBR	X5-114-53		
CHECKED	WASHER	WEIGHT 0.17g	SCALE 5:1
		SHT	SHTS. 1
	SEE TABLE		

X5 114 53

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

(1) WASHER SHOULD BE MADE FROM GLASS TEXTOLITE OF GRADE CT-1- OF THICKNESS 1.5 M·M AS PER GOST 12652-74. HAVING THE TECHNICAL REQUIRMENTS AS ARE AS FOLLOWS.

1) ELECTRICAL QUALITY TEXTOLITE SHEET IS A PRESSED MATERIAL CONSISTING OF TWO OR MORE LAYERS OF GLASS FIBRE CLOTH IMPREGNATED WITH THERMOACTIVE RESIN.

2) GLASS TEXTOLITE OF THICKNESS UP TO 2.0 M·M IN THE HEATED CONDITION MUST BE SUITABLE FOR STAMPING OPERATION.

(11) GLASS TEXTOLITE OF GRADE CT-1-1·5 HAVING THE PHYSICAL, MECHANICAL AND ELECTRICAL REQUIREMENTS AS PER GOST 12652-74.

1) DENSITY — 1·60 – 1·90 g/cm³

2) RESISTANCE TO SHORT-DURATION HEATING — 200 OHM (MINIMUM)

3) RESISTANCE TO ACTION OF OIL — IN TRANSFORMER OIL FOR 4 HOURS AT NOT LESS THAN 130°C

4) WATER ABSORPTION NOT MORE THAN-1%

5) SURFACE RESISTIVITY, OHMS. NOT LESS THAN 1×10^3 AT RELATIVE HUMIDITY 45 TO 75% AND 15 TO 35°C

6) 1×10^{12} AFTER SOAKING FOR 24 HOURS IN A HUMIDITY CHAMBER AT RELATIVE HUMIDITY OF 95 ± 2% AND 20 ± 2°C

7) VOLUME RESISTIVITY, OHM. CM NOT LESS THAN 1×10^3 AT RELATIVE HUMIDITY OF 45 TO 75% AND 15 TO 35°C

8) 1×10^{12} AFTER SOAKING FOR 24 HOURS IN A HUMIDITY CHAMBER AT RELATIVE HUMIDITY OF 95 ± 2% AND 20 ± 2°C.

9) DISSIPATION FACTOR AT 50 Hz A RELATIVE HUMIDITY 45 TO 75% AND 15 TO 35°C – 0·03 (MAXIMUM)

10) DIELECTRIC STRENGTH PEPENDICULAR TO THE LAYERS AT 50 Hz IN TRANSFORMER OIL AT 90 + 7°C – 27 KVEFT (MINIMUM)

REF NO·2

(111) PHYSICO – CHEMICAL PROPERTIES OF THE VARNISH GRADE МЛ-92 AS PER GOST 15865-70 AS ARE AS FOLLOWS

1) VISCOSITY AS PER VISCOSIMETER B3-4 AT 20°C IN SEC } 25 MINIMUM

2) CONTENT OF DRY-RESIDUE IN % – 50 – 55

3) ACID NO IS MG OF KOH – 10 (MAXIMUM)

4) CONTENT OF SEPERATE FORMALDEHYDE IN % } 0·6 (MAXIMUM)

5) TIME OF DESICCATION AT 105–110°C IN HRS } – 1 (MAXIMUM)

6) DRYING – CAPACITY OF VARNISH IN THICK-LAYER AT 115 –120°C IN HRS } – 16 (MAXIMUM)

7) THERMO ELASTICITY OF LAYER AT 150°C IN HRS } – 48 (MINIMUM)

8) HARDNESS OF LAYER AS PER PENDULUM INSTRUMENT AT 20±1°C } – 0·40 (MINIMUM)

9) OIL-RESISTANCE OF FILM IN kg – 8 (MINIMUM)

10) ELECTRICAL STRENGTH OF FILM IN K VOLT/MIN AT 20± 2°C } – 65 MINIMUM
AFTER THE ACTION OF WATER FOR A PERIOD OF 24 HRS AT 20± 2°C } – 30

11) SPECIFIC – VOLUMERIC ELECTRIC RESISTANCE OF FILM IN CM } $1 \cdot 10^{14}$ (MINIMUM)

12) AFTER THE ACTION OF WATER FOR A PERIOD OF 24 HRS AT 20 ± 2°C } $5 \cdot 10^{12}$

SURFACE FINISH

▽ :- REPRESENT SURFACE FINISH TO BE OBTAINED BY WITHOUT REMOVAL OF MATERIA ON BOTH SIDE OF JOB.

Rz 80/(√) :- REPRESENTS Rz VALUE OF SURFACE FINISH OF 80 MICRONS ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED

D·CS	D·T	ZONE	BRIEF RECORD	SIGN

INSCRIBED		DRG NOT TO BE SCALED	PERTAINS TO
CHECKED		ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	
APPROVED		ALL DIMENSION ARE IN m·m UNLESS OTHERWISE SPECIFIED	
DATE	17.11.84	WASHER	X5-114-53
TOLERANCE OTHERWISE GENI DES	UNLESS SPECIFIED ANG	SCALE :-	
		CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT PUNE	

1-4-4