

D1301 87

FORM NO	ZONE	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
				PARTS		
11		1	9Д8.221.010.	BUSH	1	
				MATERIALS		
		2		ALUMINIUM ALLOY АЛ-2, GOST 2685-75.		
				ENAMEL ЭП-140, BLACK, ТУ6-10-599-79.		
				ENAMEL ТНПФ-851, WHITE, ТУ29-0.2-889-79.		

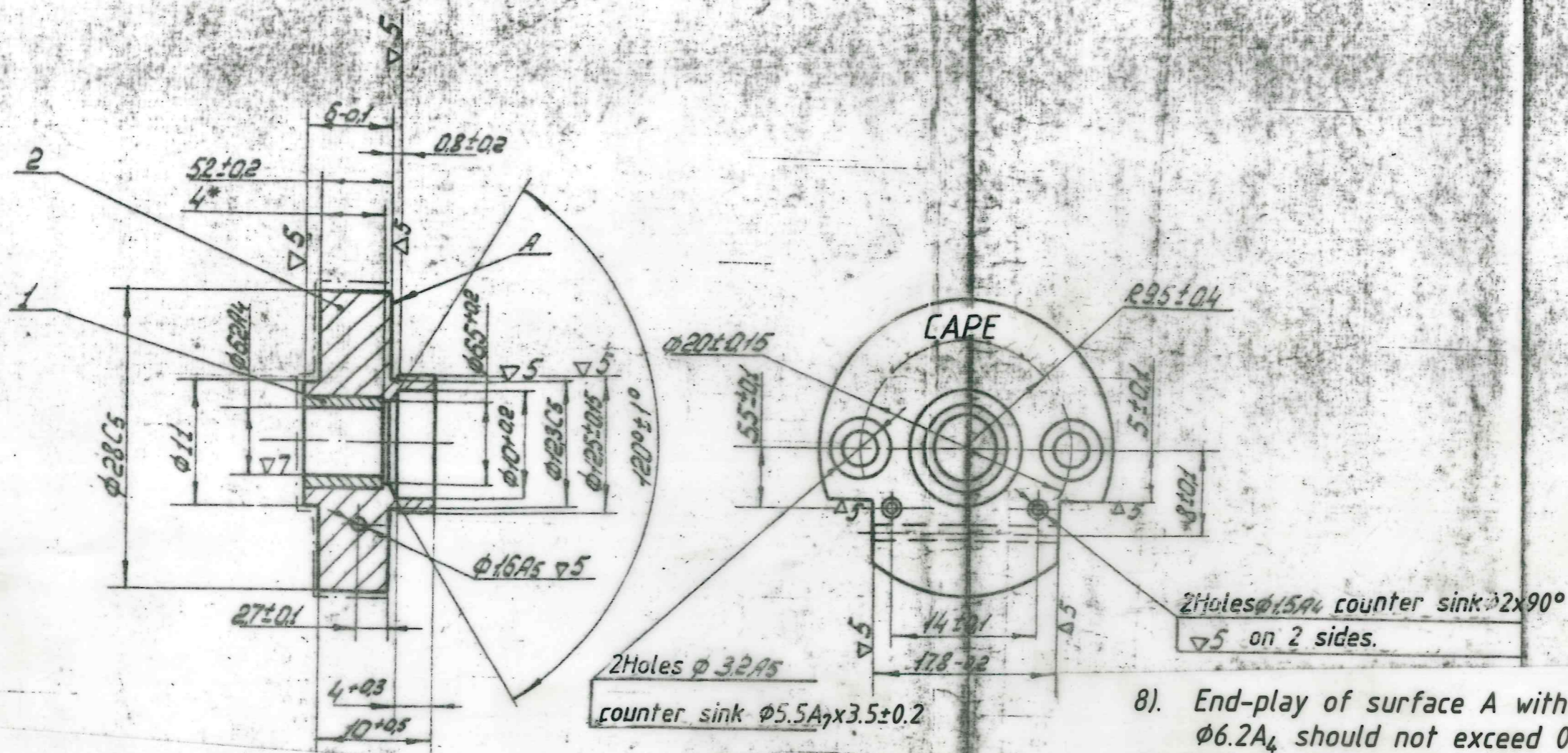
9Д6.115.001

S.NO	SHT	DOC.NO.	SIGN	DATE
	DRAWN	CH.V.RAO	<i>[Signature]</i>	22.5.87
	EDT&CHK	D.K. JAIN	<i>[Signature]</i>	24.5.87
	F/M.D.C.	S.H.RAO	<i>[Signature]</i>	3/6

BODY

SHT. NO	NO OF SHT
	1

ORDNANCE FACTORY
BHOJEST



- 1). Pressure Die casting. casting radii 0.5mm.
- 2). Tolerance on free dimensions is as per OST 141154x72 (class of accuracy IT-3 unless otherwise specified).
- 3). Pattern draft should not exceed 1° beyond tolerance towards increased dimensions.
- 4). Casting defects are not allowed on surfaces indicates with _____ Other surfaces are as per OCT 1 80020-71 (2nd group).
- 5). Make inscriptions as per 3.3.OST 100312-78 with depth 0.3 to 0.4mm, symmetrically with respect to the axis of symmetry.
- 6). Heat-treatment T2 as per OST 1 90088-73.
- 7). *Dimensions are for reference.

- 8). End-play of surface A with respect to axis of hole φ6.2A₄ should not exceed 0.1mm.
- 9). Hole φ1.6 A5 may be made after chemical oxidation.
- 10). Eccentricity of surfaces φ6.2A₄ and φ12.5 should not exceed 0.1mm.
- 11). Coating: chemical oxidation, coat surface indicated with _____ with enamel эн-140, black II A, coat inscriptions with enamel THnφ-851 'white'.

946115001

SNOSHT	DOC NO	SIGN	DATE
DRAWN	BHUSHAN		18.5.84
EDT,CHKD	J. K. JAIN	<i>[Signature]</i>	19.5.84
F/M,DC.	S.H.RAO	<i>[Signature]</i>	3/6
DIV.OFFR	D.A. BARUA	<i>[Signature]</i>	4/6
	NAME	SIGN	DATE

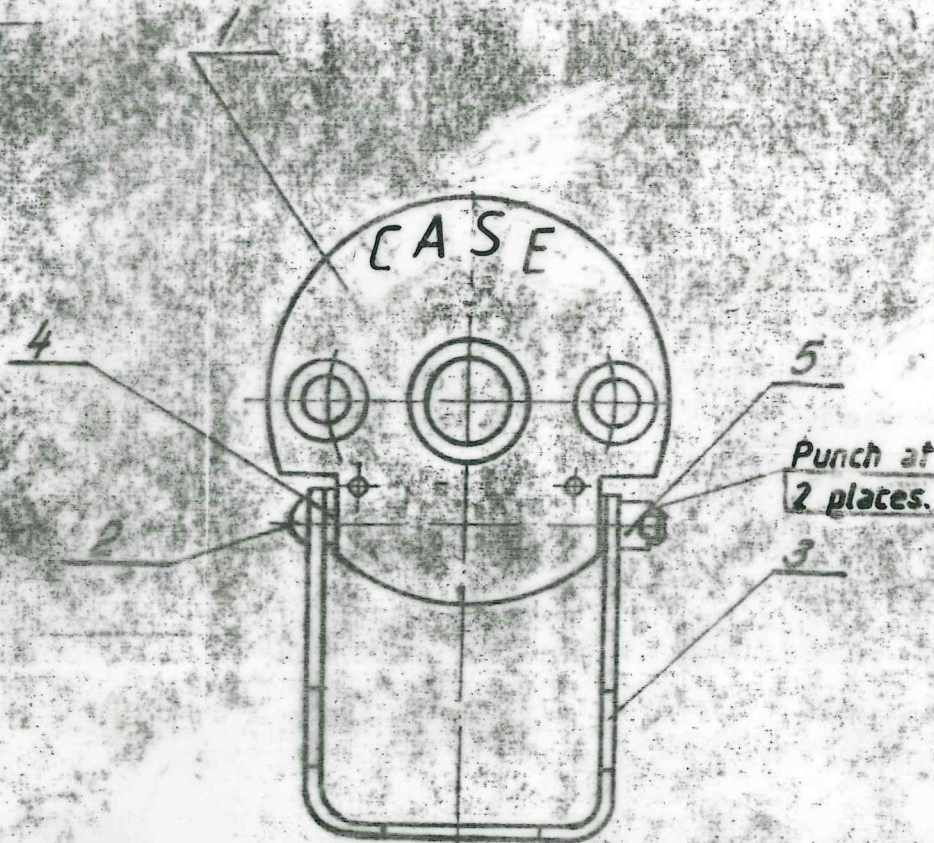
BODY.

(Assembly drawing)

SHEET	WEIGHT	SCALE
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

906.115.002

90



1. Coat the place of punching with varnish YP-231, TY 6-10-863-76 as per instructions SCO.045.102.

5	3370A-1,6кд	Nut	1	
4	9D8.942.009. ✓	Washer.	2	
3	9D8.362.016. ✓	Retainer.	1	
2	9D8.300.005 ✓	Axle.	1	
1	9D6.115.001. ✓	Body.	1	✓
REF. NO.	Designation.	Description	qty	Remarks.

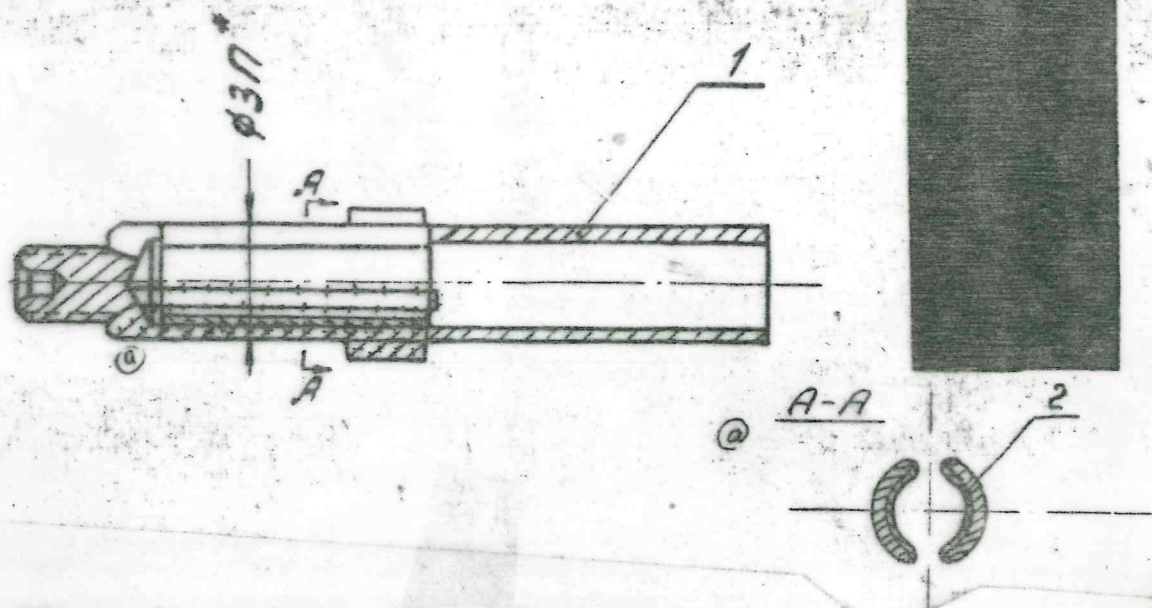
906.115.002

SN/SH.	DOC NO	SIGN	DATE
DRAWN	P.R.BABU.		14.5.84.
EDT,CHKD	D.K. JAIN	<i>[Signature]</i>	17.5.84
F/M,DC.	S.H.RAO	<i>[Signature]</i>	3/6
DIV.OFFR	D.A. [Signature]	<i>[Signature]</i>	4/6
	NAME	SIGN	DATE

BODY

SHEET WEIGHT SCALE.		
A	117g	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

127-CS



1. *Dimension is given for reference.
2. Cement gasket Ref, No.2 to internal walls of collector axle Ref.No.1 with adhesive БФ-4.
3. Cut projected parts of gaskets flush with φ30.

REF. NO.	Designation.	Description.	qty	Remarks.
1	DA-77-01	Gasket.	2	
2	9D8.310.002	Axle of collector.	1	

770

SLNO	SHEET	DOCNO	SIGN	DATE
DRAWN BY		P.R.BABU		16.5.84
EDITED AND CHECKED BY		D.K.JAIN		17.5.84
FOREMAN OF DC		SHRAGU		3/6
DIVISIONAL OFFICER		D.A. ...		4/6
		NAME	SIGN	DATE

AXLE

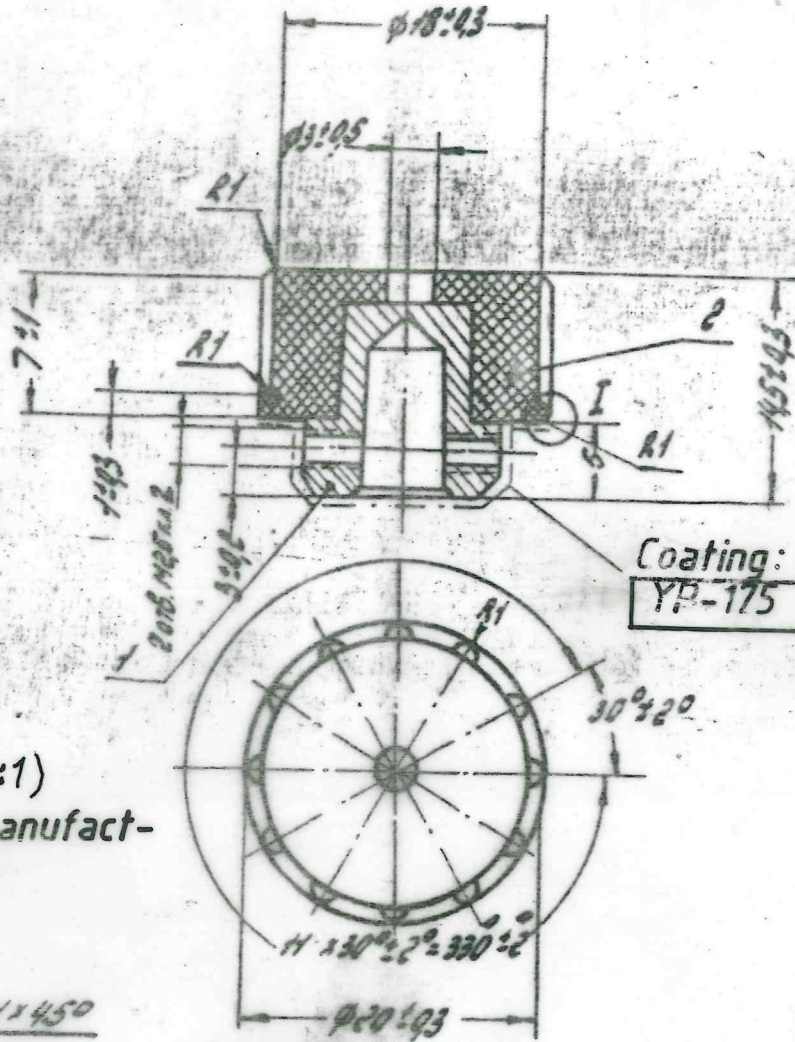
9D6.306.000		
SHEETS	WEIGHT	SCALE
		5:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

120-89

100 456 906

▽7 for moulding material surface

91



Coating: Black enamel
YP-175

I (M2:1)
Alternate manufacturing.



*Dimensions are given for reference.

1. Technical requirements are as per OST 1.80063-73.
2. Part maybe made from phenolic plastic 03-010-02 GOST 5689-79.
3. It is allowed to use 3M.3П-140, black, instead of 3M-YP-175.

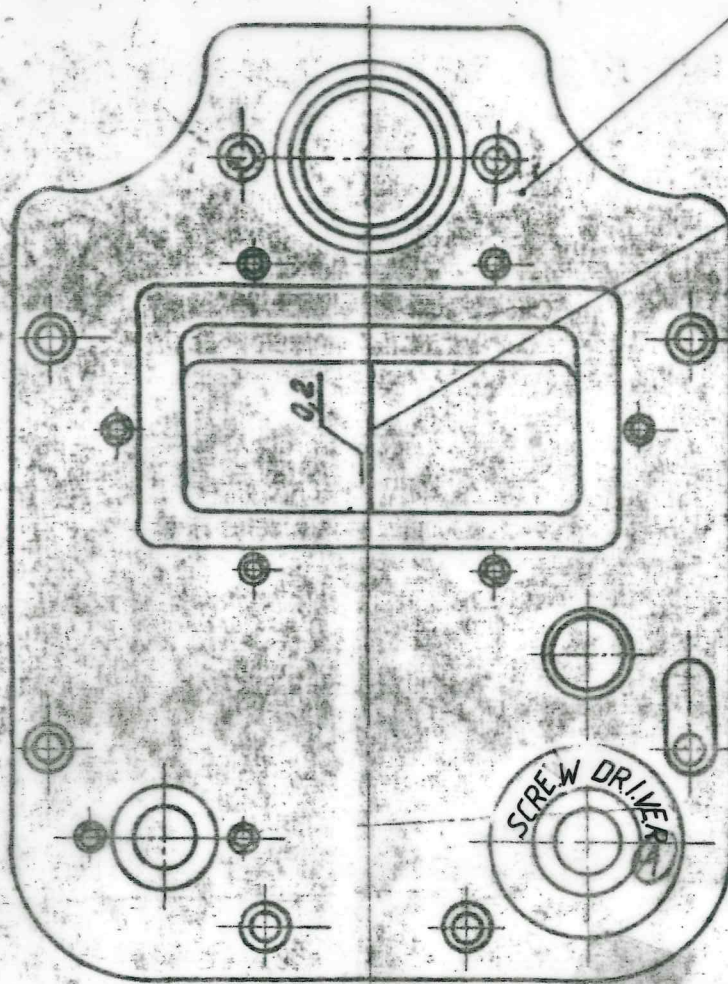
REF. NO.	Designation.	Description.	Qty	Remarks.
1	9D8.227.024.	Bush.	1	
		Phenolic plastic 01-030-02.	2	GOST 5689-79.

906.354.001

SN	SHT	DOC NO	SIGN	DATE
DRAWN		P.R.BABU		16.5.84.
EDT,CHKD		D.K.JAIN		17.5.84
F/M,DC		S.HRAO		2/6
DIV.OFFR		P.A.		
		NAME	SIGN	DATE

CONTROL BUTTON A

SHEET	WEIGHT	SCALE
	11g	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		



1). Install index ref.no. with adhesive K-115 as per instructions, coat with white enamel all over, and phosphor on the face side of front wall as per instructions koy-32.072.

REF. NO.	DESIGNATION	DESCRIPTION	QTY	REMARKS
2	9 27. 027. 001	INDEX	1	
1	127-26	Front wall	1	

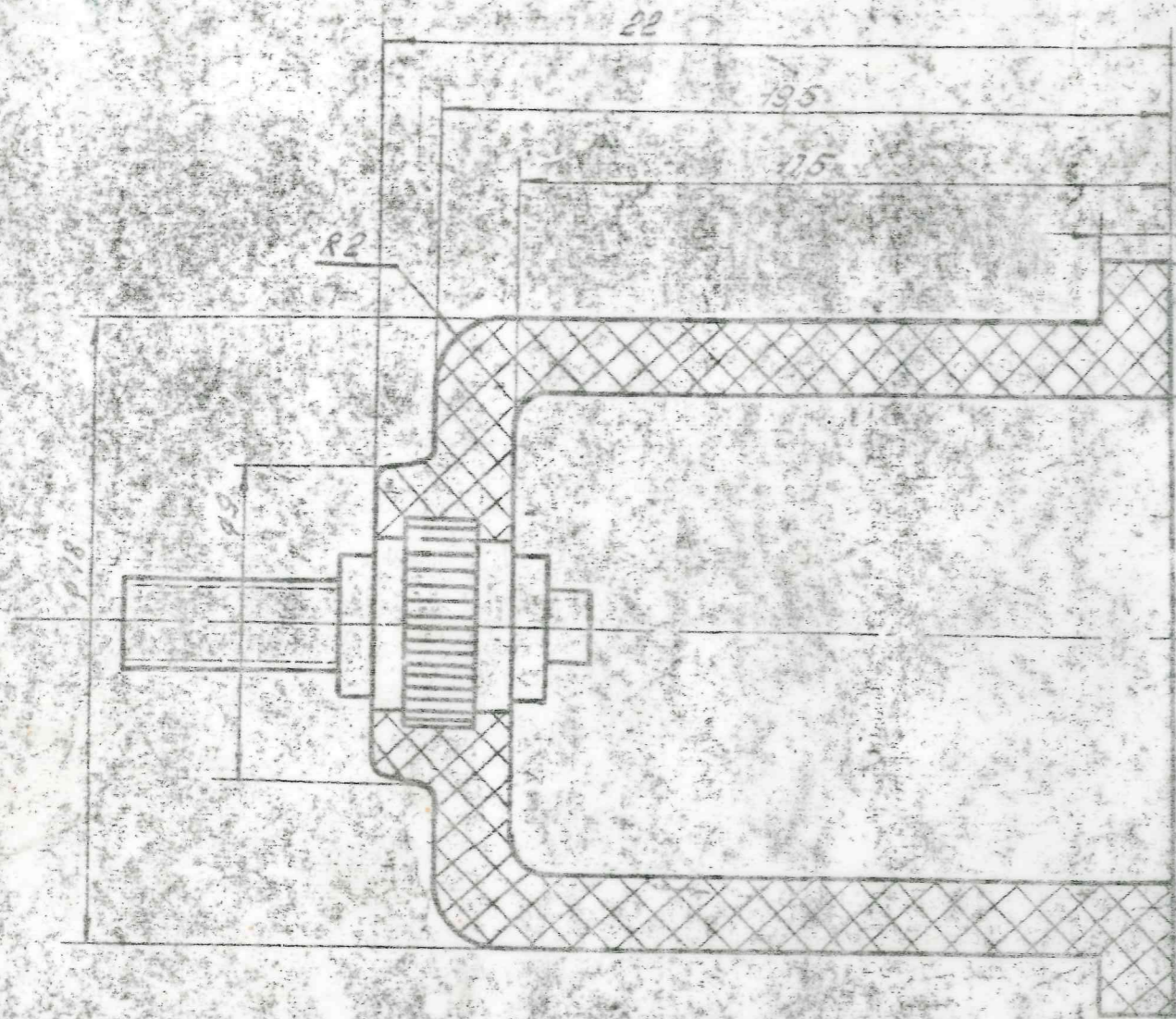
SLNO	SHEET	DOCNO	SIGN	DATE
DRAWN BY		BHUSHAN		19.5.84
EDITED AND CHECKED BY		D.K. JAIN		24.5.84
FOREMAN OF DC		S.H.RAO		3/6
DIVISIONAL OFFICER		D.A. P. RAO		4/6
		NAME	SIGN	DATE

FRONT WALL.

926.424.000		
SHEETS	WEIGHT	SCALE
A		
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

D130-92

926.430.018



- 1). Technical requirements are as per OST 1.80063-73.
- 2). Provide dimensions without tolerances; Holes- as per A7, shafts-as per B7.
- 3). Perform unspecified radii as R1.
- 4). Pattern drafts should not exceed 1°30' along external contour-towards increased dimensions, along the internal side towards reduced dimension. Drafts along $\phi 18$ are within the limits of tolerance.
- 5). At any places of cap material, presence of upto two blow holes, diameter up to 2mm is allowed.
- 6). External view should correspond to the approved standard.
- 7). Dull surface scuffing of surface should not exceed 30% of total area.
- 8). It is allowed to manufacture from poly carbonete, Grade 7 nk-5 Ty N6-05-1668-80.

2		Ty N6.05.1668-80		
		Poly carbonate nk-6		
1	927.734.002	Stud	1	
REF. NO.	DESIGNATION	DESCRIPTION	QTY	REMARKS.

926.430.018

SKETCH	DOC NO	SIGN	DATE
DRAWN	BHUSHAN		24.5.84
EDT/CHKD	P.K. JAIN		25.5.84
F/M, DC	S.H. RAO		3/2
DIV. OFFR	D.A. RAO		4/2
	NAME	SIGN	DATE

CAP.

SHEET	WEIGHT	SCALE
A	43g	5:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		