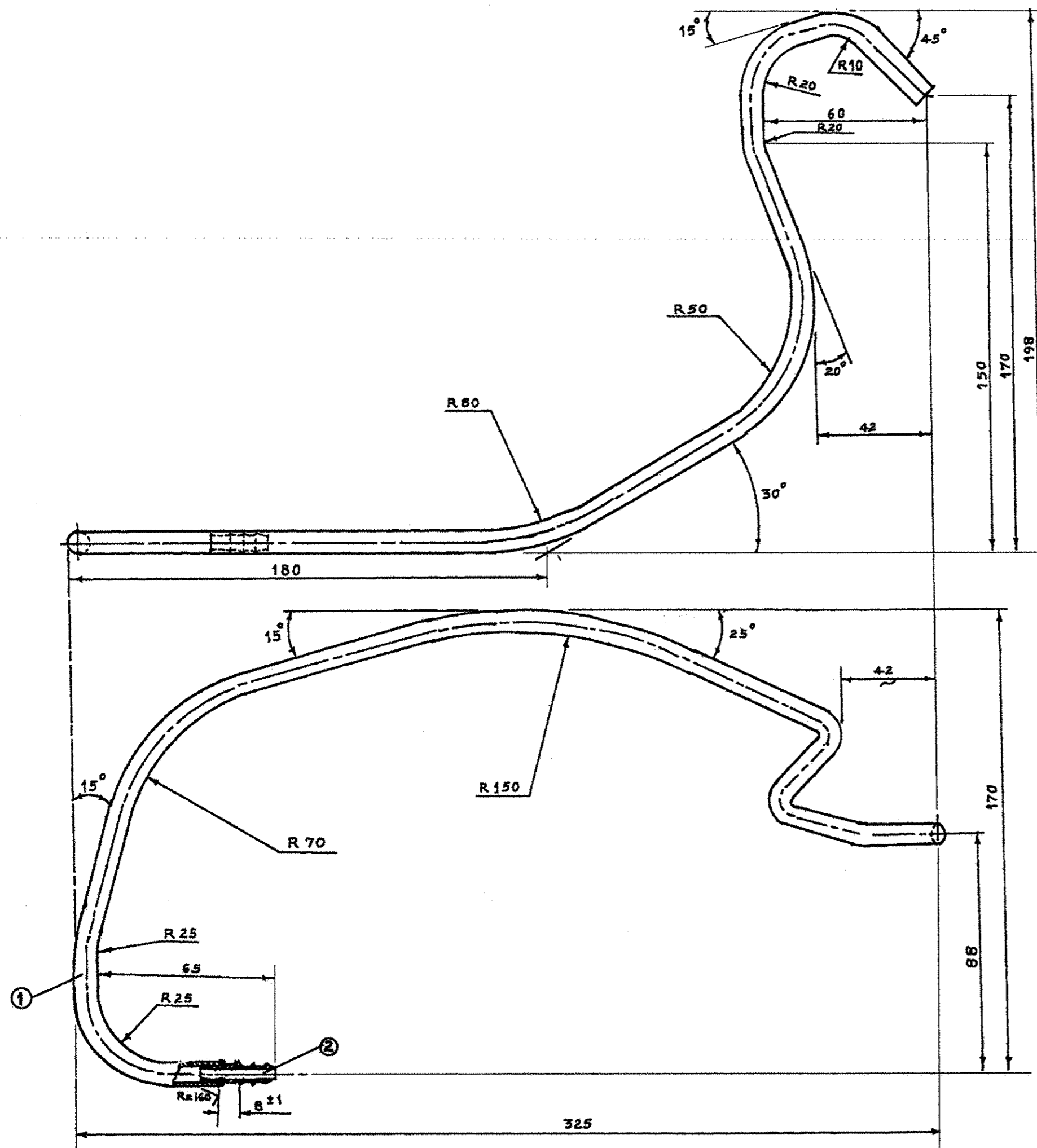


675-38-Sb106Sb



TECHNICAL CONDITIONS

1. Bend pipe and determine length against standard made to suit job requirement.
2. At points of pipe bending ovality not in excess 1.5 mm and corrugations not in excess of 1mm are tolerable.
3. Soldering with solder 34-A prepared in compliance with Instructions 052.25012.00007. Projection of soldered seam above outer diameter of pipe Ref. No.1 - 1.5 mm, maximum, it is allowed to dress seam after soldering.
4. Coating, anodic oxidation with subsequent sealing in bichromate or chemically phosphatized, blue.
5. Coating of outer surfaces; primer 40/1-03 ЖЭВ 9109-81 and enamel 40-223, dark grey, cost 14923-78.
6. Perform leakage test with compressed air in water bath at pressure of (1 ± 0.5) kgf/cm² for at least 3 min. Air leakage is not tolerable. It is allowed to perform test by rubbing with chalk and filling with burning kerosene gas 4753-68. Kerosene traces on chalked area in 3 min are not tolerable.
7. * Sizes are given for reference.
8. Developed length of pipe 655 (Appx.)
9. EQUIVALENT MATERIAL:- Gr 52000 to IS:1285-75 FOR DRG. No.675-38-7 (Ref.No.1)

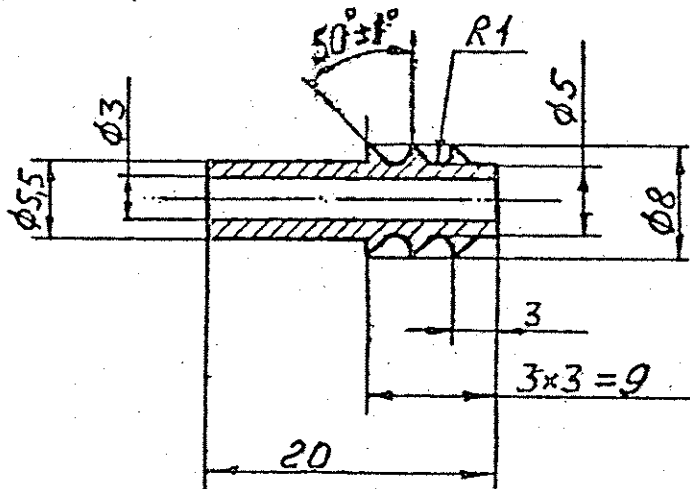
NOTE :-

- 1) ALL DIMENSIONS IN mm.
- 2) THIS IS PROVISIONAL DRAWING. PILOT SAMPLE SHOULD BE GOT APPROVED FROM ANSP (CQA-ICV) BEFORE BULK PRODUCTION.

NEAREST EQ. MATERIAL		01064-1CV. 12-9-95 0258-NOV	NOTE No ② EQUIVALENT MATERIAL ADDED FOR DRG No. 675-38-7 (Ref. No 1)
ORGL MATERIAL:-		14-11-95 DCI/NO. & DATE	DRAWING PREPARED BASED ON APPROVAL OF 4/84 N OF A
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF		ISSUE	AMENDMENTS
DRG. NOT TO BE SCALED		STAMP OR ETCH, PART No. MANUFACTURER'S NAME & YEAR OF MFR.	
SCALE: 1:1		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	
DATE: 03-11-95		USED ON: 675-38-Sb3	
DRN. <i>[Signature]</i>	WT. (Kg)	675-38-Sb106Sb	
TCD.		PIPE	
CHD. <i>[Signature]</i>		DS CAT No.	
APPD. <i>[Signature]</i>		CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)	

765-38-213

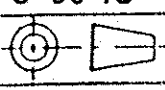
Rz80 ✓



1. Alternate material is AMF5 GOST 4784-74.
2. Unspecified limit deviations of dimensions are for holes as per A7 for shafts as per B7.
3. EQ. MATERIAL:- ALUMINIUM Gdc. 24534 TO IS: 733-83.

DCCI No. & DATE	ISSUE	NATURE
01013-1CV <i>[Signature]</i> 12-01-06	Ⓑ	DS CAT PART NO ADDED AND DESCRIPTION "ADOPTOR UNION PIPE" WAS UNION
00533-1CV <i>[Signature]</i> 14-11-95	Ⓐ	DRG AMENDED BASED ON APPROVAL OF 4/94 N OF

AMENDMENTS

MATERIAL :- AMF6 GOST 4784-74.	
ALL SHARP EDGES & CORNERS TO BE ROUNDED BY	ALL THREADS TO CONFORM TO SPECIFICATION
DRG. NOT TO BE SCALED	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
SCALE :- 2:1	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED
DATE :- 26-10-95	USED ON:- 675-38-C8106
DRN: <i>[Signature]</i>	Ⓑ UNION ADOPTOR UNION PIPE
TCD: <i>[Signature]</i>	
CHD: <i>[Signature]</i>	Ⓑ 765-38-213 DS CAT PART NO. LV2/ICVS 4730-063891
APD: <i>[Signature]</i>	
	
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)	

REF NO	DESIGNATION	DESCRIPTION	DS CAT NUMBER	IS EQUIVALENT	Qty	REMARKS
		DOCUMENTS				
	675-38-Sb106Sb	ASSEMBLY DRAWING				
		PARTS				
1	675-38-7 <small>Ref.DC(I) 01064-ICV</small>	PIPE		by 52000 TO IS: 285-75.	1	WITHOUT DRG.
		PIPE 8x1 AMr 2M		ALUMINIUM PIPE		
		GOST 18475-73		Gde. 52000 TO		
		L=655 mm (Approx)		IS : 738-77		
2	765-38-213	ADOPTOR UNION PIPE	LV2/ICVs 4730-063891		1	Ref.DC(I) No. 01013-ICV
00533-ICV						
<i>Anilw</i> <i>VR</i>						
14-11-95						
DC(I)No. & DATE						
ISSUE						
AMENDMENTS						
DRN. TCD. CHD APPD DATE :						
<i>Kathak</i> <i>Kathak</i> <i>HA</i> <i>Anilw</i> 3-11-95						
675-38-Sb106						DS CAT No.
PIPE						SHT SHTS
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)						