



- JUMPER TO BE MADE FROM 22-25 STRIPS OF COPPER BAND WITH THICKNESS 0.2 mm.
- MANUFACTURING FROM BAND HM 0.3 M3, GOST 1173-77 IS ALLOWED.
- ENDS OF BAND SHOULD BE HOT TINNED WITH ΓΠOC 40 OR ΓΠOC 61 SOLDER USING ACID FREE FLUX IN THIS CASE, THE ENDS SOLDERED TOGETHER SHOULD NOT HAVE THICKNESS MORE THAN THAT OF SET AS PER ABOVE MENTIONED TOLERANCE.
- ROUNDING OFF OF CORNERS ACCORDING TO CONVENTIONAL DOTTED LINE R11 IS ALLOWED INSTEAD OF MAKING CHAMFERS 5 x 45°

**VETTED**  
I/C USER  
I/C Q.A.

**EXPLANATORY NOTE:-**  
THE COMPONENT SHOULD BE PRODUCED FROM GENERAL PURPOSE COLD ROLLED COPPER STRIP OF 0.2-0.00mm THICK NORMAL ROLLING ACCURACY SOFT 'M' OF GRADE M3 TO GOST 1173-77 CHEMICAL COMPOSITION IS AS PER GOST 859-78.

CHEMICAL PROPERTIES : AS PER GOST 859-78

MANUFACTURING METHOD	GRADE	Cu + Ag NOT LESS THAN	IMPURITIES (NOT MORE THAN)								
			Bi	Sb	As	Fe	Ni	Pb	Sn	Su	O
FIRE REFINED	M3	99.5	0.003	0.05	0.01	0.05	0.20	0.05	0.05	0.01	0.08

MECHANICAL PROPERTIES : AS PER GOST 1173-77.

MATERIAL CONDITION	TENSILE STRENGTH, σ <sub>0.2</sub>		ELONGATION %
	kgf/mm <sup>2</sup>	Mpa	
SOFT	20	190	30

(A) ALT. MATL. TYPE 1 TO IS 319-89

DRN	Sd/=	MATERIAL:-	USED ON:-
CID	Sd/=	COPPER BAND HM 0.2 M3	175.70.163abCb
APD	Sd/=	GOST 1173-77.	
DATE	16.10.88	CONTROLGRATE OF QUALITY ASSURANCE (HEAVY VEHICLES)	
SCALE	1:1	AVADI	
DIMENSIONS IN mm			
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS: H02-09			
ALL THROUGHS TO CONFORM TO			
4A	31/07/88	AUTHY:No.88007(CM/PM/SES dt. 21.10.88	D S CAT NUMBER
ISSUE DATE		NATURE OF AMENDMENTS	DRAWING NUMBER
			175.70.420

PILOT SAMPLE SHOULD BE APPROVED BY A. H. S. P BEFORE BULK PRODUCTION.

EST. WT. (kg) TO BE STAMPED OR MARKED WHERE INDICATED THIS # ( LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS SPECIFIED OTHERWISE. DIMENSIONS HAVE R TO OUT-SIDE R. INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

TITLE:-  
**JUMPER**

D S CAT NUMBER  
DRAWING NUMBER  
175.70.420