

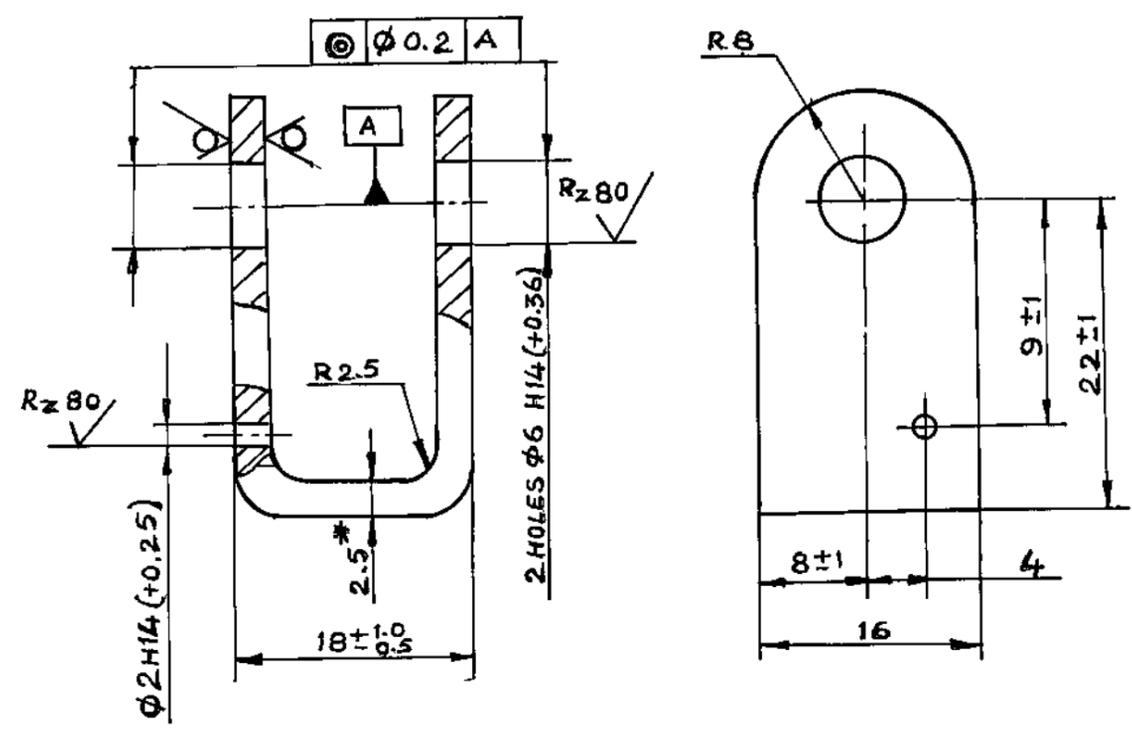
678-95-2

PH-061-84

TECHNICAL CONDITIONS

Rz160 (V)

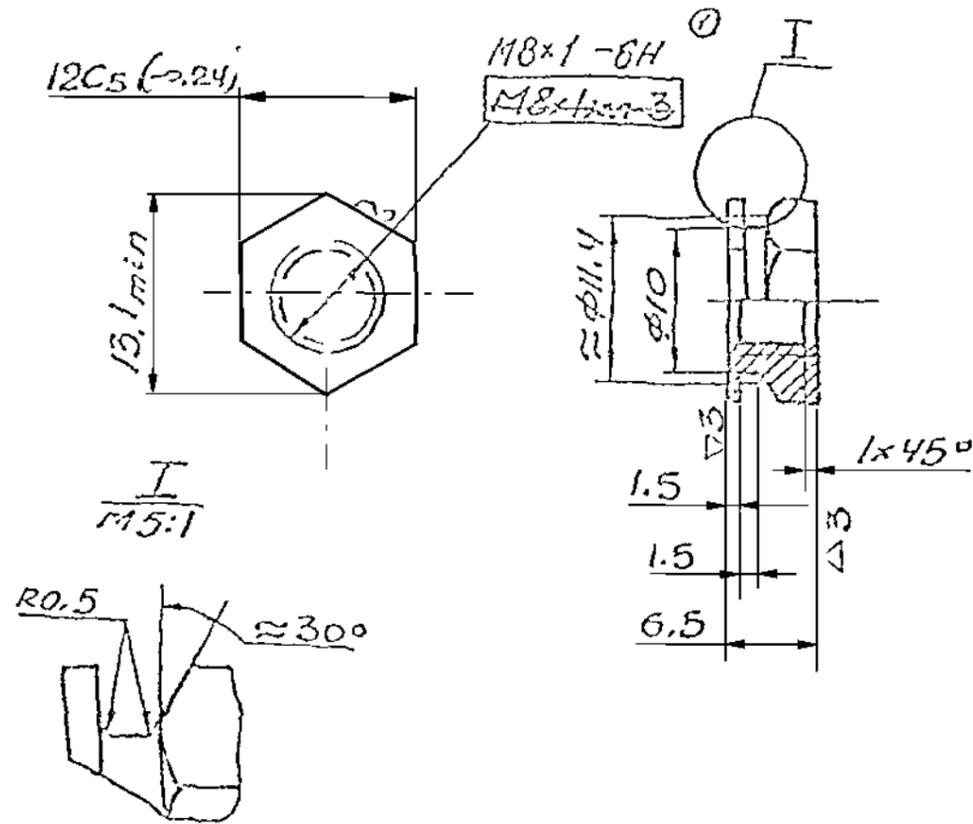
1. ALTERNATE MATERIAL IS SPL. STEEL 3C11 TO GOST 380-88
2. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSION ARE ± 0.5 MM.
3. * DIMENSION IS FOR REFERENCE.



DRAWING MATERIAL			
SHEET 5-ПГ-0-2.5 GOST 19903-74 5-II-Г-10 GOST 16523-70			
ORIG. MATERIAL	DCL. N & DATE	ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF. DRG. NOT TO BE SCALED	ALL THREADS TO CONFORM TO SPECIFICATION.		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.
SCALE:- 2:1	TOLERANCE DIMENSION UNLESS OTHERWISE SPECIFIED		USED ON:- 3 678-95-2 S 7
DATE :-			
DR. & APPROV. W. :- (L.S)	LUG		
ECO. 0.021			
DES. [Signature]	DRAWING NO. 678-95-2		PART NO
APP. [Signature]	CONTROLLED STATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)		

- NOTE:-
1. ALL DIMENSIONS ARE IN MM
 2. THE ABBREVIATIONS AND SYMBOLS ARE BASED ON RUSSIAN SPECIFICATIONS

2/5/21 [Signature]

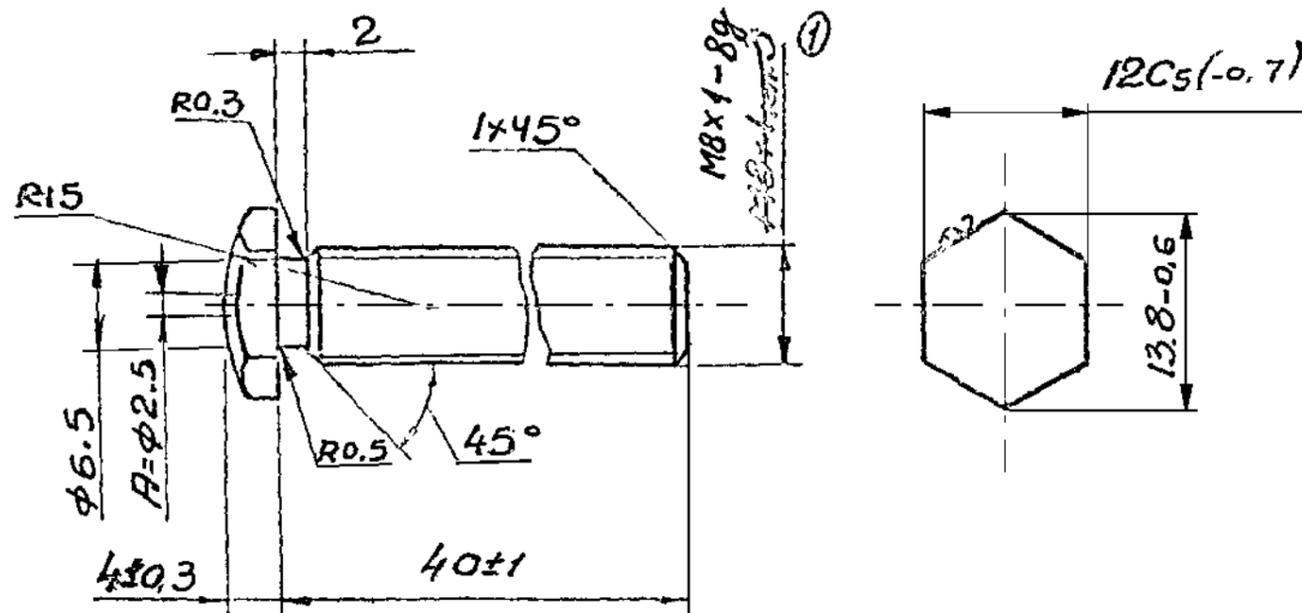


1. Alternate material is steel 5 GOST 380-71 and 25,30,35,40 GOST 1050-74.
2. H.B. 255 to 207 ($\phi 3,8$ to 4,2).
3. Unspecified limit deviations of dimensions are as follows: for holes-as per A7, shafts-as per B7.
4. Displacement of axis of hole from true position should not exceed 0,3mm.
5. Type of coating: Zinc plated, 9 microns thick, chromati-sation. Remove hydrogen embrittlement.

Ⓐ EQ. MATERIAL:- 45 C B TO IS: 5517-93 OR
 Ⓑ GRADE-C45 TO IS: 1570

00887-ICV <i>[Signature]</i> 05 JUL 01	Ⓑ	EQ. MATERIAL ADDED.
00722-ICV <i>[Signature]</i> 07 SEP 99	Ⓐ	EQ. MATERIAL ADDED.
DC(No. & DATE)	ISSUE	AMENDMENTS

APPROVED	<i>[Signature]</i> M.VASU	700-30-455	
CHECKED	H.M. Shaikh		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	NUT	WEIGHT	SCALE
		0.003	
		SHT	SHTS 1
	45 GOST 1050-74		



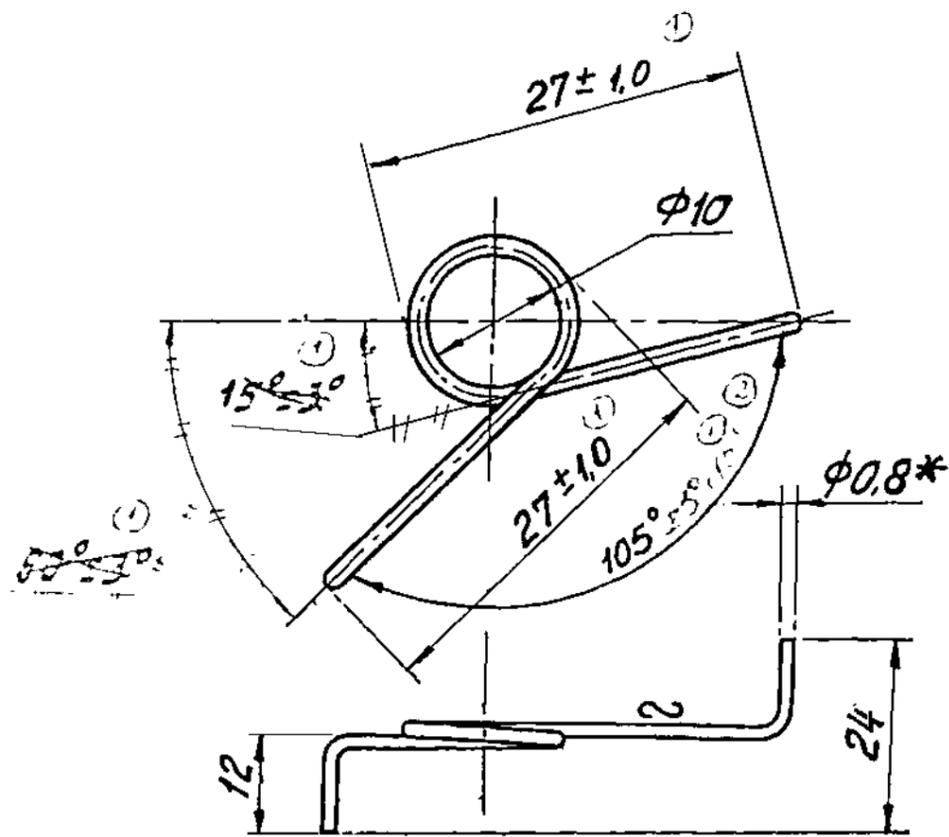
- 1) Alternate material is steel 40, GOST 1050-74.
 - 2) HB 255 to 207 (ϕ 3,8 to 4,2).
 - 3) Unspecified limit deviations of dimensions of holes are as per A7.
 - 4) Presence of area A is allowed on the face of sphere.
 - 5) Coating :- Zinc plated , 9 microns thick, chromated.
Remove hydrogen embrittlement
- (A) EQ. MATERIAL:- 45 C8 TO IS: 5517-93 OR
(B) GRADE-C45 TO IS:1570

00889-ICV 18 JUL 01 <i>[Signature]</i>	(B)	EQ.MATERIAL ADDED.
00722-ICV 07 SEP 99 <i>[Signature]</i>	(A)	EQ.MATERIAL ADDED.
DC(No. & DATE)	ISSUE	AMENDMENTS

APPROVED	<i>[Signature]</i> H VASU	700-35-408			
CHECKED	<i>[Signature]</i>				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		SCREW		WEIGHT	SCALE
		45, GOST 1050-74		0.02	2:1
		SHT	SHTS	1	

700-38-1035

В (Δ)

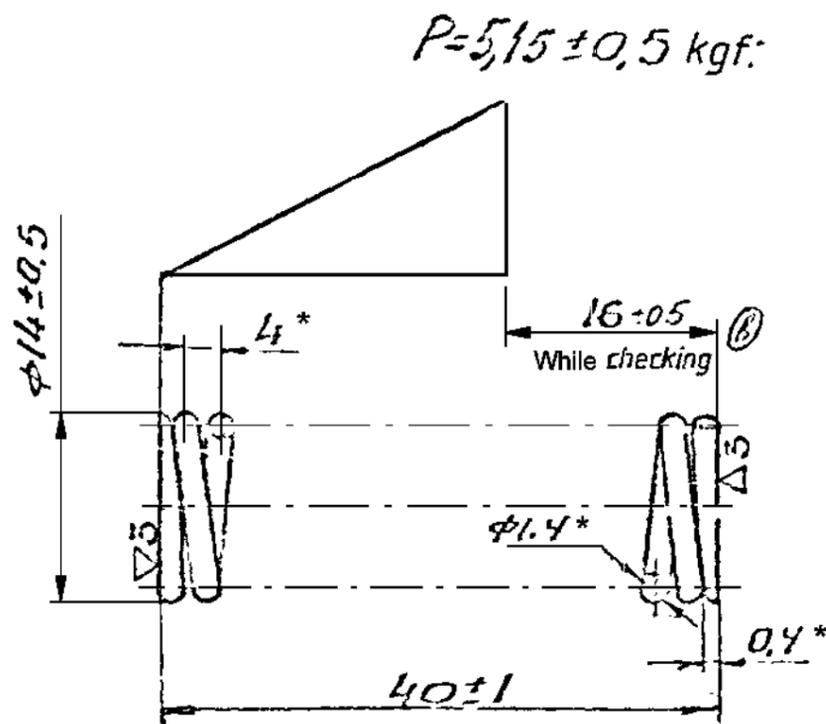
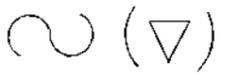


1. Alternate material is wire I, GOST 9389-75.
2. Unspecified limit deviations of dimensions are $\pm 0,5$ mm.
3. Total length of spring^{wire} is $L^* = 127$ mm.
4. Number of working coils is $n = 1$.
5. Direction of winding is left-hand.
6. *Dimensions are given for reference.

MATERIAL:- WIRE II-0.8, GOST 9389-75

ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF		ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART No. MANUFACTURER's NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:
SCALE:	2:1	700-38-1035	
DATE :	29 NOV 95	DS CAT No.	
DRN.	WT.:- (Kg)	SPRING	
TCD.	SEE TABLE		
CHD		CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)	
APPD			

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)



- 1) Shear modulus is $G^* \approx 8,10^3 \text{ kg/mm}^2$, max.
- 2) Tangential twisting stress. $\tau_3^* = 73 \text{ kg/mm}^2$, max.
- 3) Total length of spring is $L^* \approx 450 \text{ mm}$.
- 4) Number of working coils $n = 9$.
- 5) Complete number of coils is $m, = 11 \pm 0.5$.
- 6) Direction of winding is arbitrary.
- 7) *Dimensions are given for reference.
- 8) Coating : Chemically parkerized, chromotized, accelerated, impregnated with preservation oil k-17 GOST 10877-76 as per instructions 053,25289,00002 or with varnish k0-815 GOCT 11066-74.
- 8) Coating : chemically parkerized, chromotized, accelerated, impregnated with varnish k0-815, GOST 11066-74

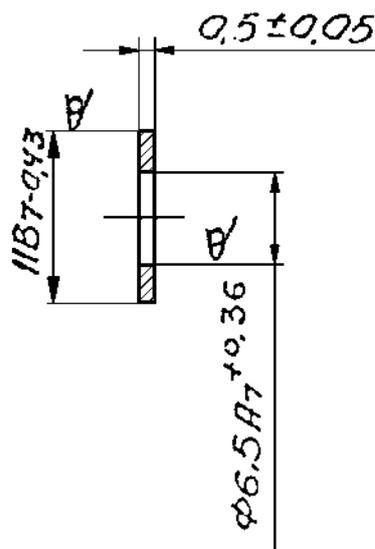
Ⓐ EQ.MATERIAL :- WIRE Gdc.3 TO IS: 4454 (PT-1)-81.

00597-ICV <i>[Signature]</i> 30 JAN 97	Ⓐ <i>[Signature]</i>	EQ.MATERIAL ADDED. (4/96 N OF A)
DC(1)No. & DATE	ISSUE	AMENDMENTS

APPROVED <i>[Signature]</i> H VASUJ	700-38-1495		
CHECKED <i>[Signature]</i>	SPRING	WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		0.0053	2:1
		SHT	SHTS
	WIRE-II-1.4, GOST 9389-75		

700-40-153

2 (Δ)



- 1). Alternate material is steel cm2, cm3, GOST 380-71 and steel 08nc,¹⁰₁ 10kn, 15, 15kn, 20, 25 and 30 GOST 1050-74.
- 2). Coating: Zinc-plated, 9 microns thick, chromatized. Remove hydrogen embrittlement.

(A) EQ. MATERIAL: -Gda 'D' (OR) 'DD' (OR) EDD TO IS: 1079-88 OR

(B) GRADE - 'D' TO IS: 513-86

00898-ICV <i>M. Vasu</i> 21 AUG 01	(B) Gum	EQ. MATERIAL ADDED.
00272-ICV <i>V. Rama</i> 07 SEP 99	(A) Gum	EQ. MATERIAL ADDED.
DC(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED **M.VASU**
CHECKED *A. S. S. SKUMAR*

700-40-153

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

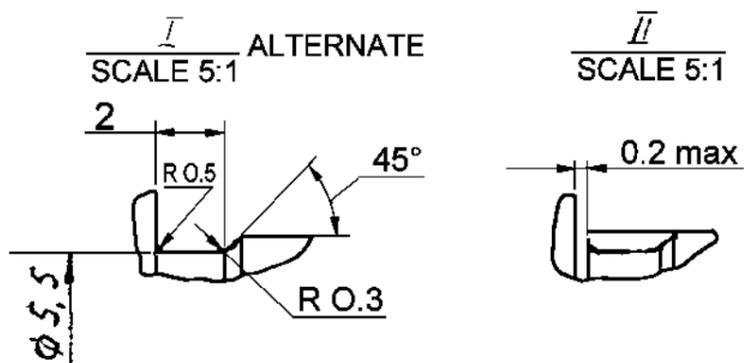
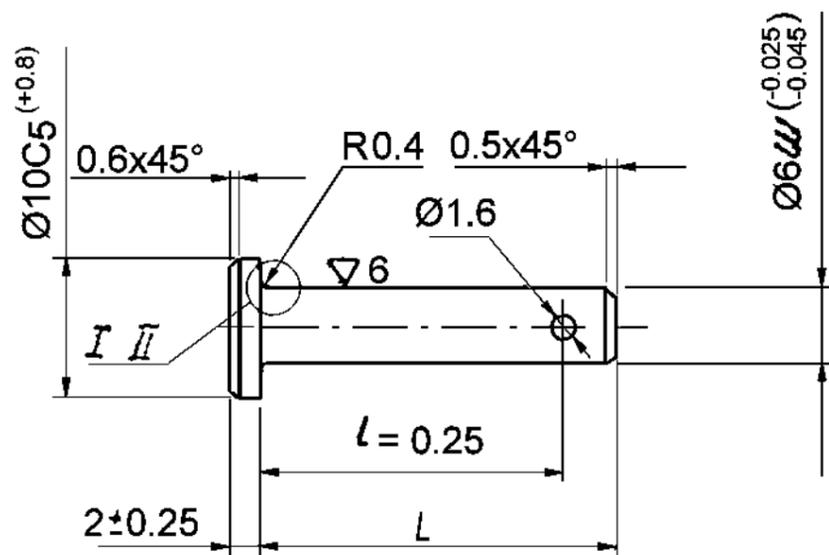
GASKET

WEIGHT SCALE

0.0003 2:1

SHT SHTS

08Kn GOST 1050-74



TECHNICAL CONDITIONS

1. HB 321 to 228 (Ø3.4 to 4.0).
2. Alternate material is 38XC, 40X, 40XC, 45X, GOST 4543-71.
3. Unspecified limit deviations of dimensions are as follows:
For holes -as per A₇ and
for shafts -as per B₇
4. Displacement of holes from axis of rod should not exceed 0.3mm
5. Coating: Zinc-plated, 9 microns thick, chromated
Remove hydrogen embrittlement.

- Ⓐ 6. Equivalent material is 40Cr4 Mo3 to IS:5517.
 Ⓑ EQ.MATERIAL:- 40 Cr 1 Mo 28 TO IS: 5517.

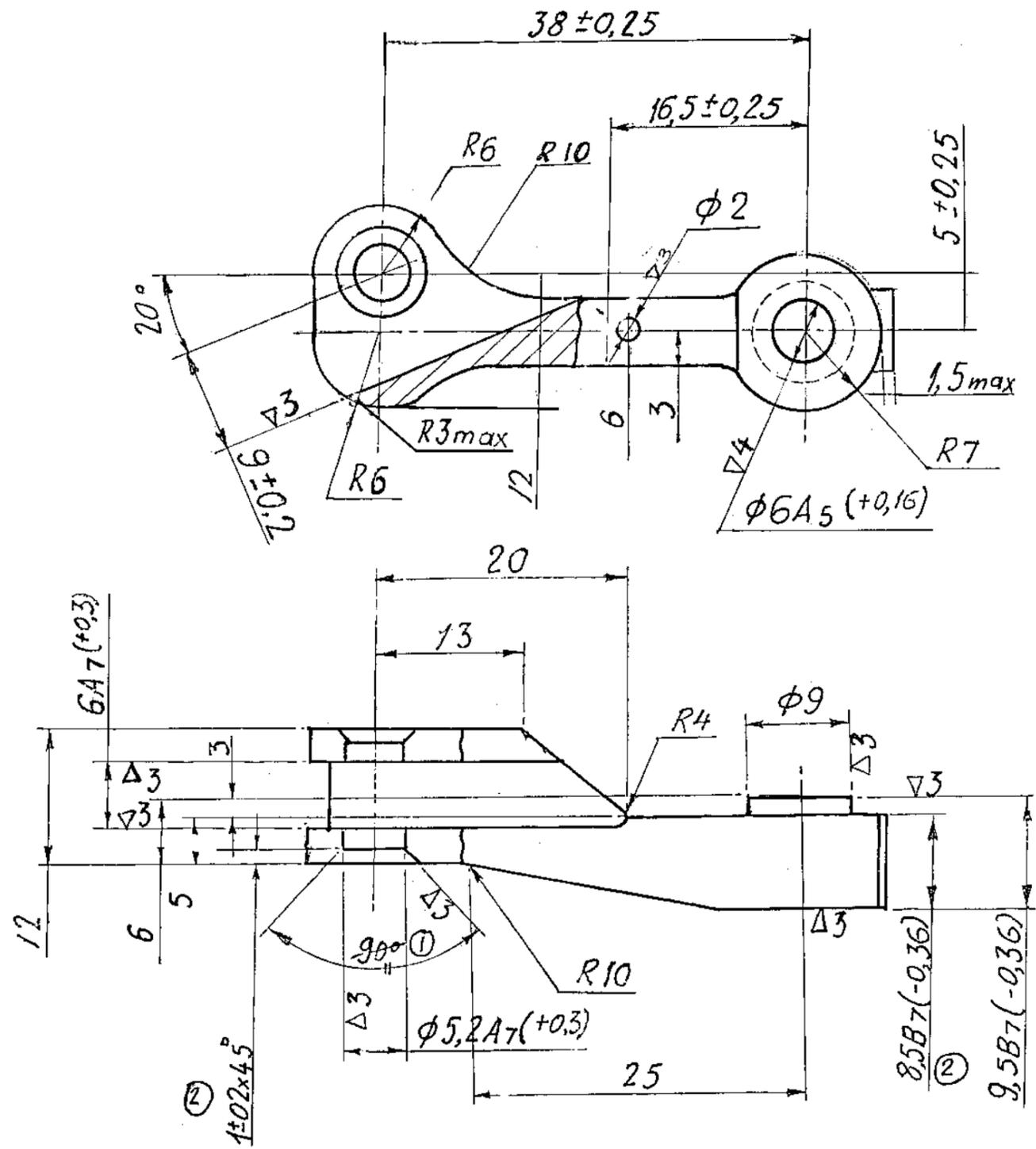
01065-ICV 8 OCT 09	Ⓒ	DS CAT No. LV2/ICVS 5315-0252278 ADDED & NOMENCLATURE 'AXLE' AMENDED AS PIN STRAIGHT HEADED AGAINST DRG No.700-47-358
00820-ICV 17 OCT 00	Ⓑ	EQ. MATERIAL ADDED.
00321-ICV 11 FEB 92	Ⓐ	NOTE FOR EQUIVALENT MATERIAL ADDED.
DC(No. & DATE)	ISSUE	AMENDMENTS

DESIGNATION	L ₁ MM	L ₂ MM	MASS,Kg.
700-47-358	14±0,43	10	0,0043
-01	16±0,43	12	0,0047
-02	20±0,52	16	0,0056
-03	25±0,52	21	0,0067
-04	35±0,62	30	0,010

© DS CAT No. LV2/ICVS-5315-0252278.

APPROVED		700-47-358	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	AXLE	WEIGHT	SCALE
		SEE TABLE	2:1
		SHT	SHTS
38xA GOST 4543-71			

765-41-150



1. Alternate material is casting from steel 40x 40 and 50 ГОСТ 977-75
2. Unspecified casting radii should not exceed 8mm
3. Lever may be made as per conventional dotted line
4. Unspecified limit deviations of dimensions of surfaces to be machined are as follows for shafts-as per B7 for holes-as per A7, others as per CM7.
5. Other requirements for casting are as per OST3-4365-79.

765-41-150

LEVER

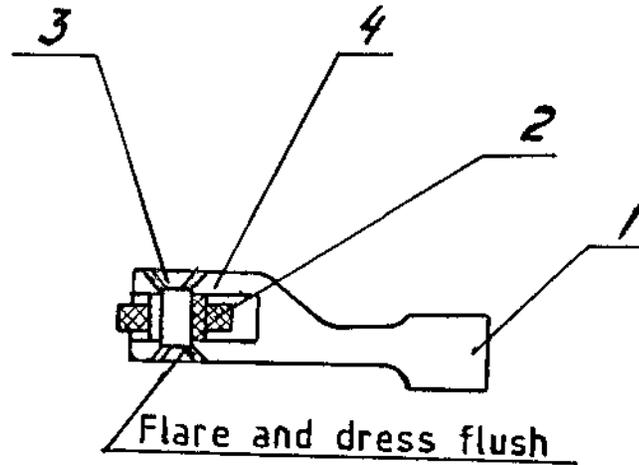
Casting I OCT3-4365-79
457-10CT 977-75

19.5.84

0 017 2-6

LIBRARY

PROJECT



- 1 Rotation of roller should be easy, without any jamming
- 2 Apply primer $\phi A-03K$, GOST 9109-76 on unmachined surfaces and paint with enamel $n\phi-223$ white-1, GOST 14923-78.

95-321UR

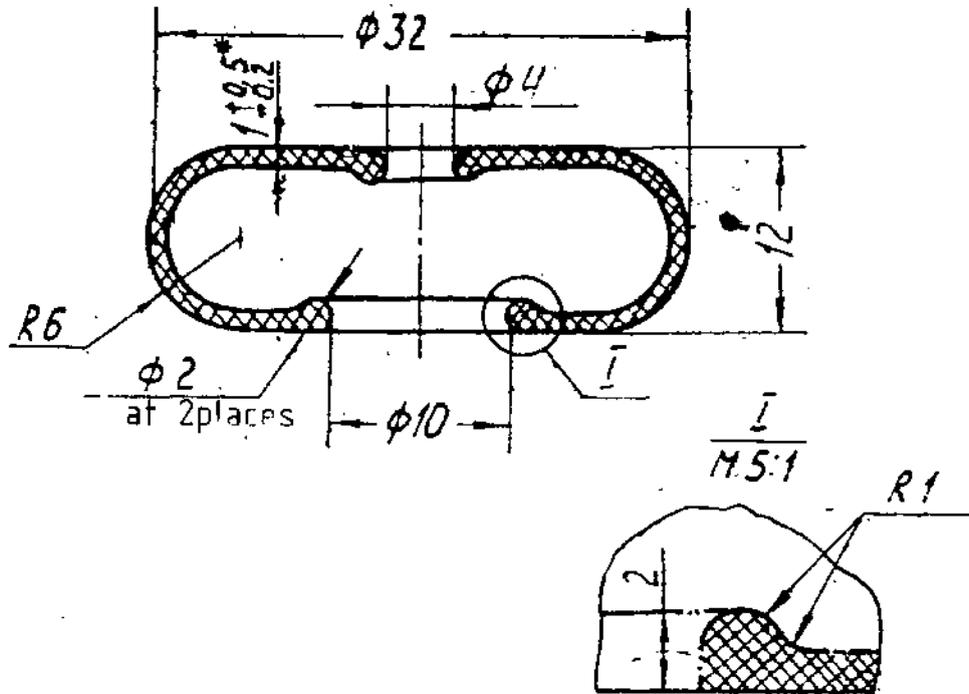
765-41-cb 131CB

NO	DOC. NO	SIGN	DATE
APPD.	A.K. Srinivas	[Signature]	20/5/84
CHKD	AK DORAY	[Signature]	26/5/84
TRACED	V JRAO		19/5/84
EDITED			
TRAND.			
	NAME	SIGN	LATE

LEVER
(Assembly drawing)

SHEETS	WEIGHT	SCALE
1	0023	1:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

664-7A-591

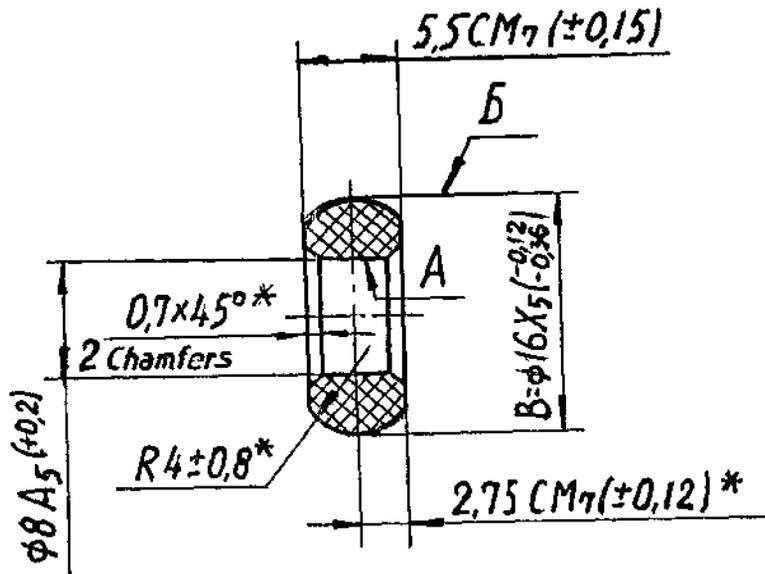


1. All dimensions except for those marked with * should be provided by tool.
2. Flash along the parting line of die to height and width 0,5mm is allowed.
3. Part may be made as per conventional dotted line.
4. Variation in wall thickness within the limits of tolerance is allowed.
5. Mark on tag.
6. Other requirements are to be as per technical specifications TY 005216-75. for articles, code 253151.

(A) EQ.MATERIAL :-TYPE 'A' GRADE 2, IS: 5192-75.

00948-ICV	00948-ICV	EQ.MATERIAL ADDED
9-10-82	9-10-82	AMENDMENTS
ISSUE	ISSUE	
AMENDMENTS	AMENDMENTS	

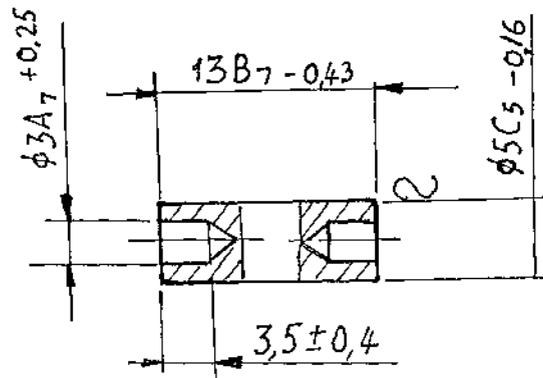
APPROVED	M YASU	765-64-499	161 of 188	
CHECKED	<i>[Signature]</i>		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)		CUP	0.0035	2:1
			SHT.	SHTS
		1847 TY005216-75		



1. Clean the burrs due to mould.
2. Run out of surface B with respect to axis of surface A should not exceed 0.2 mm.
3. *Dimensions are provided with mould.
4. Other requirements are as per Technical specifications TY 23.108-53-75 and as per supplement for part 765-65-162 to these specifications.

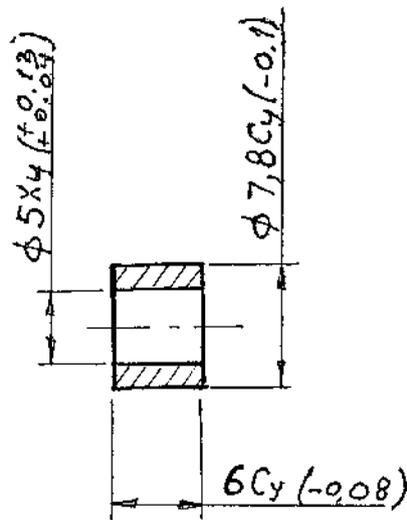
765-65-162

SHEET DOC NO				SIGN		DATE		SHEET	WEIGHT	SCALE
DRAWN				PRBABU		4 7 84		B	0.001	2:1
EDT,CHKD				AK KUNDU		24 10 84		TOTAL SHEETS		
F/M,DC.				S R NAIN		8 2		ORDNANCE FACTORY		
DIV.OFFR				AK KUNDU		13 2		PROJECT		
NAME				SIGN		DATE		HYDERABAD		
Polyamide 6, grade 1A6-210/310								OCT 6-06-c9-76, and OCT		
								B06-06-c9-76		



- 1) Remove sharp edges
- 2) Coating: Zinc-plated, 9 microns thick chromated.
Remove hydrogen embrittlement Internal surfaces may be free from coating
- 3) Alternate material is steel cm2, cm3, GOST 380-71 and steel 0,8, 15 GOST 1050-74

-765-65-197	
AXLE	SHEET WEIGHT SCALE
	0,0022 2:1
10 ГОСТ 1050-74	

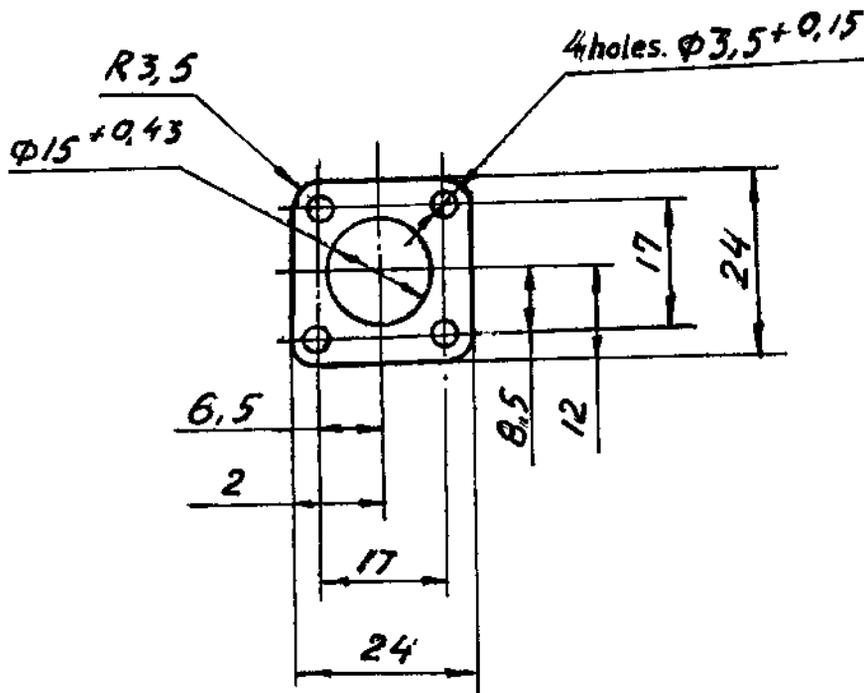


- 1) Blunt sharp edges
- 2) Coating zinc plated, 9 microns thick chromitized
Remove hydrogen embrittlement
- 3) Bushing may be made from cermet grade Xrp-0,5-
-6,5 Ty 3-624-76 in this case
 - a) HB 220 to 300
 - b) Surface finish ∇_4
 - c) Other requirements as per Technical specifications
Ty 3-624-76
- 4) Alternate material is steel 15,20, GOST 1050-74

ДОК. №			
ИЗМ.	№	Исполн.	Дата
1	1	М.А. 2/74	24.02.74
ИЗМ.	№	Исполн.	Дата
ИМЯ			

765-65-221	
BUSHING	
10 GOST 1050-74	2:1
ДИЗАЙНЕР П. П. П. П. ПРОЕКТОР СЫС. ИНЖ. П. П. П.	

51-96-99L



Thickness $1 \pm 0,1$.

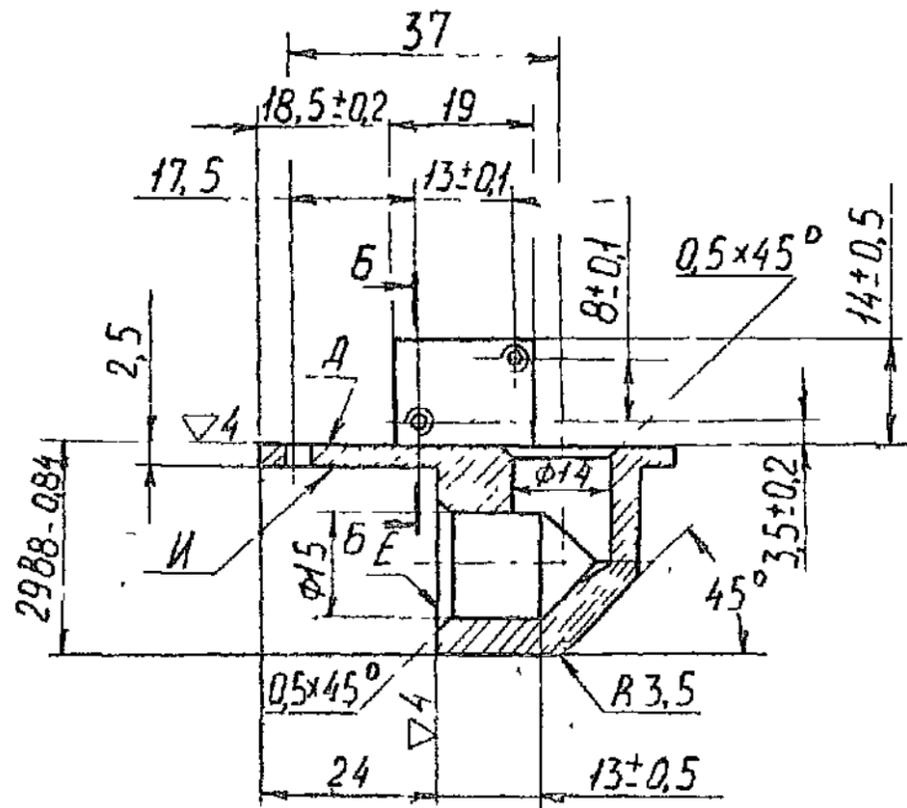
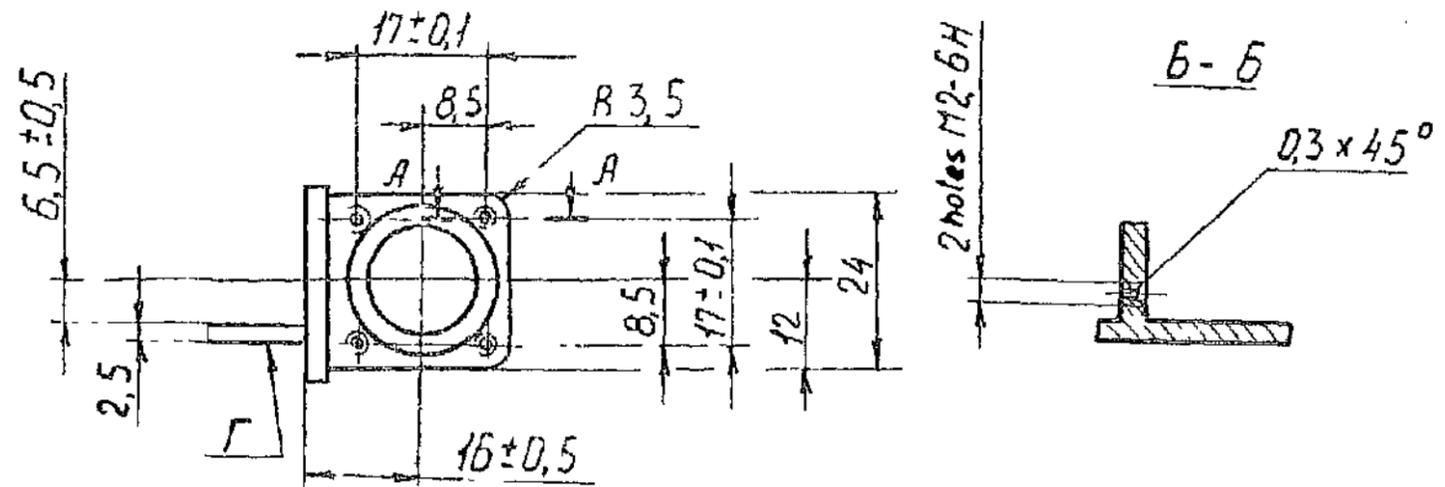
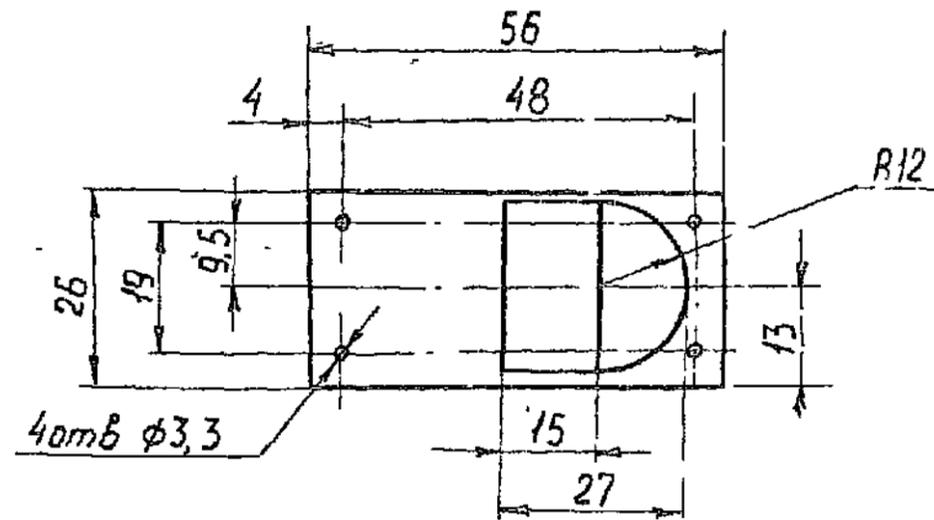
④ 3. EQUIVALENT MATERIAL IS JSS 5640 OR B15 OR B10 TO IS:2712

1. Perform dimensions without deviations with accuracy $\pm 0,5$ mm.

2. Deviation of centres of holes should not exceed 0,1 mm for $\phi 3,5$; 0,25 mm for $\phi 15$ from their true position.

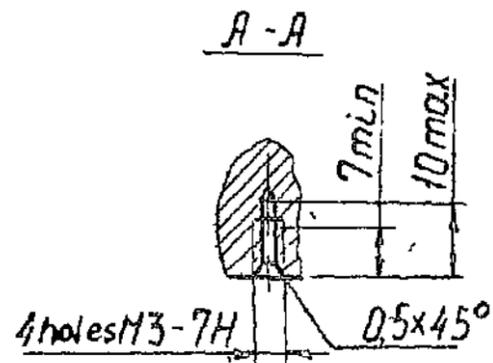
00326 - ICV 14 MAY 92	④ NO CHM	NOTE FOR EQUIVALENT MATERIAL ADDED
DC(1) No. & DATE	ISSUE	NATURE
AMENDMENT		

APPROVED	M. VASU	765-96-15		
CHECKED	H. M. S. K. S. I. C.	GASKET	WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)			0.0007	1:1
		SHT	SHTS	364 of 413
		Paronite non 1.0 606T-401-80		



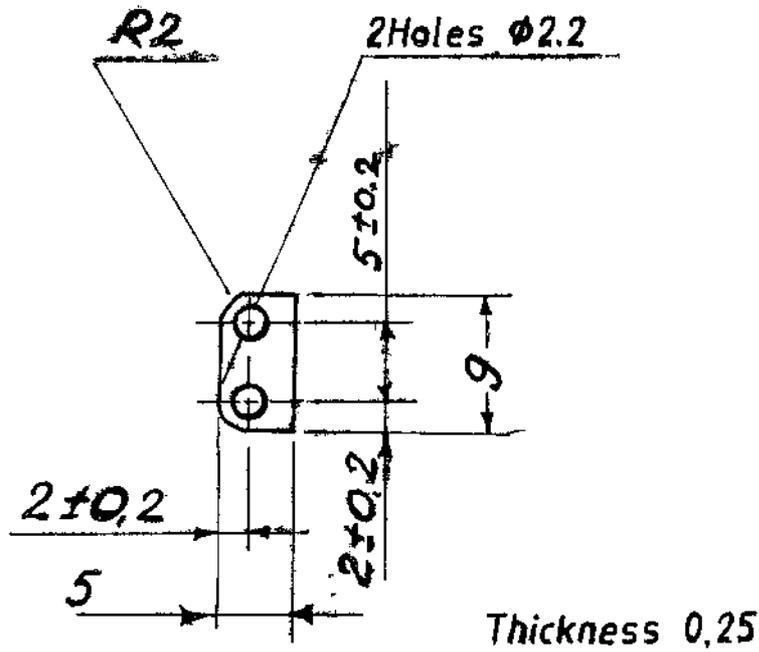
1. Blunt sharp edges.
2. Displacement of hole centres from true position should not exceed 0,2 mm.
3. Provide dimensions without deviations as per accuracy class 7, OST 1010.
4. Alternate material are A16 and AK4 GOST 4784-74
5. Coating: Anodically oxidized, chromitized or chemically parkerized blue, chromitized.
6. Apply primer ФА -03 №, GOST 9109-81 all over, except holes jaw Г and surfaces А, and Е and paint with enamel ПФ -223, dark grey, GOST 14923-78 or enamel МА -12Н, grey, GOST 9754-76 and enamel МА -155, silver, GOST 12034-77.
7. Steps with in the limits of tolerance are allowed on surface U.
8. Partial paint coating is allowed on surface E

Ⓐ EQ. MATERIAL :- AL. ALLOY Gde.2285, CONDITION 'WP' TO IS: 617.



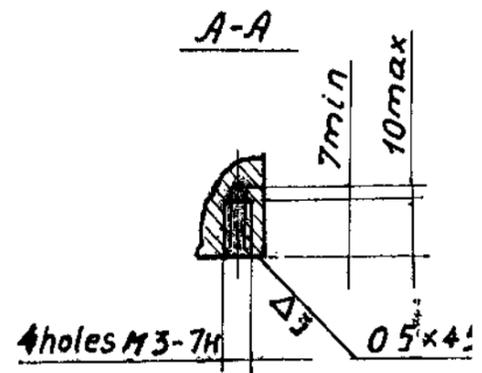
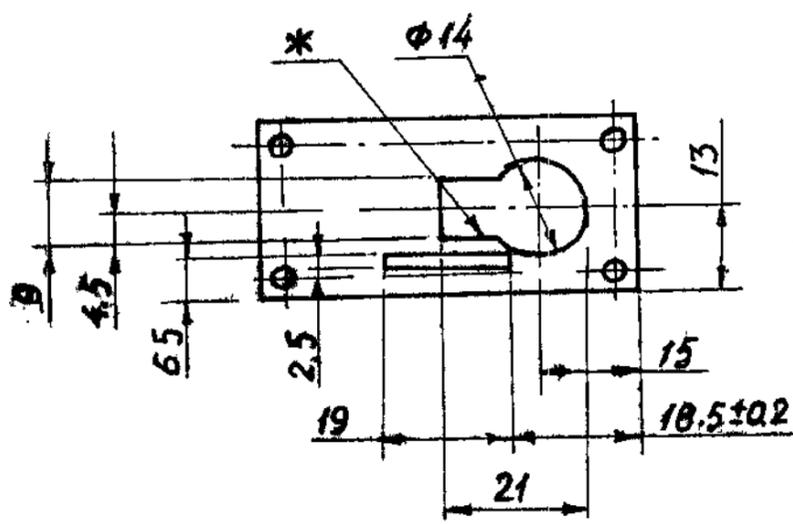
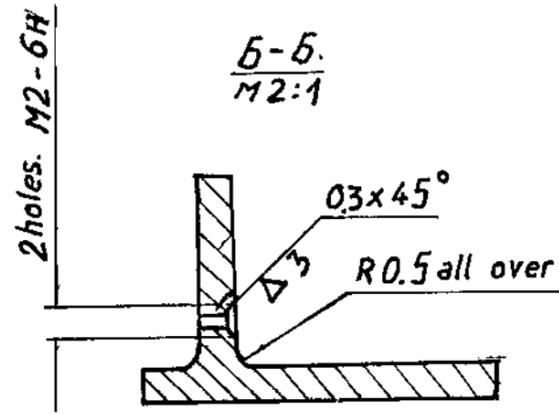
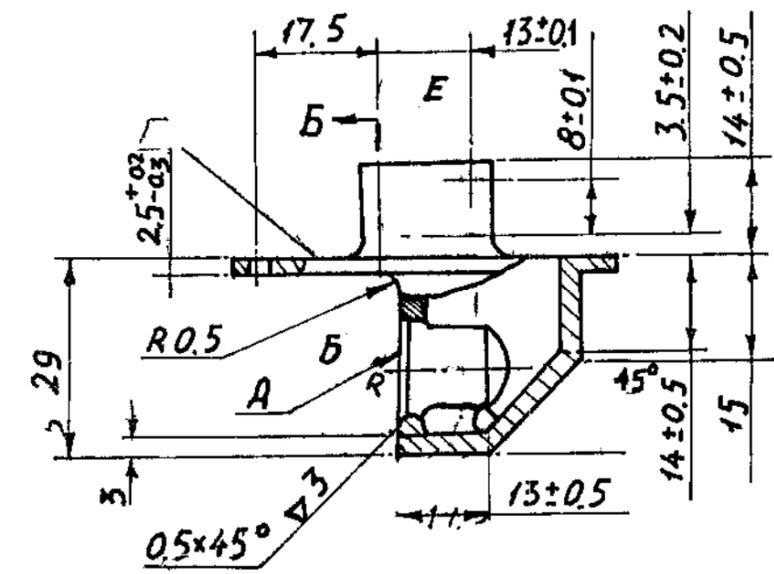
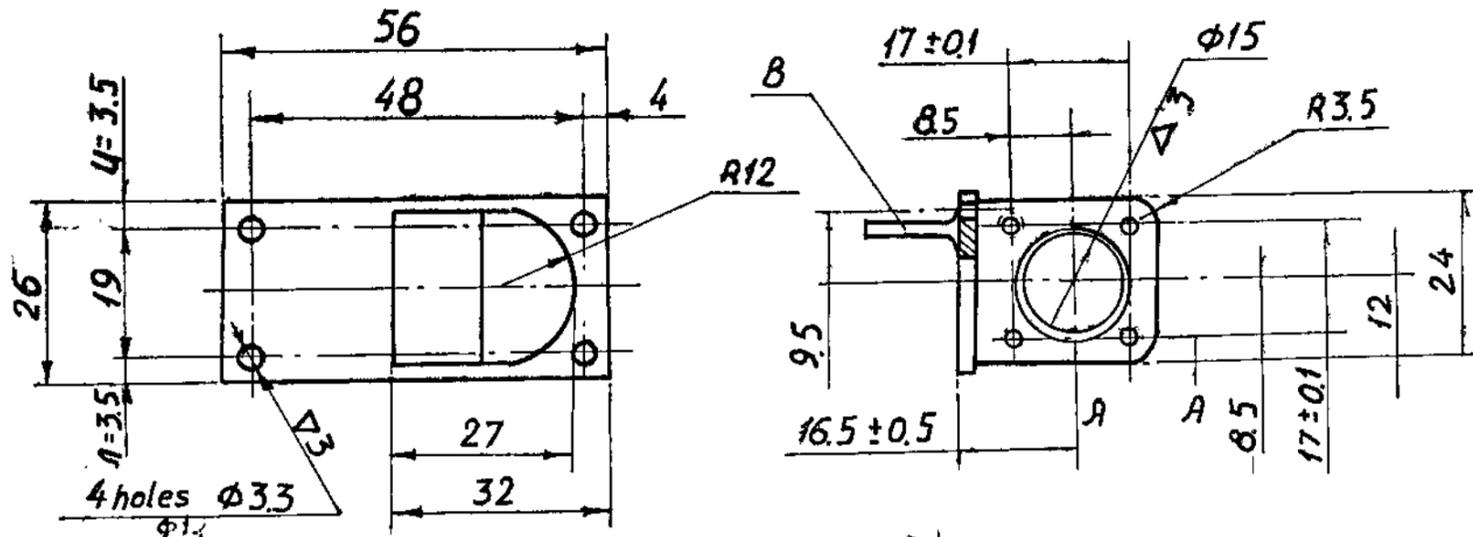
00605-15V 21-4-97	Ⓐ	EQ. MATERIAL ADDED. (2/97 N OF A)
DC (I) NO & DATE	ISSUE	NATURE
AMENDMENTS		

APPROVED	BY VASO	765-96-73	325 of 342
CHECKED	H.M. Sh... ..		
CONTROLLERATE OF INSPECTION (15V)		COVER	SCALE 0.035 1:1
		Δ1 GOCT 4784-74	SHTS 14



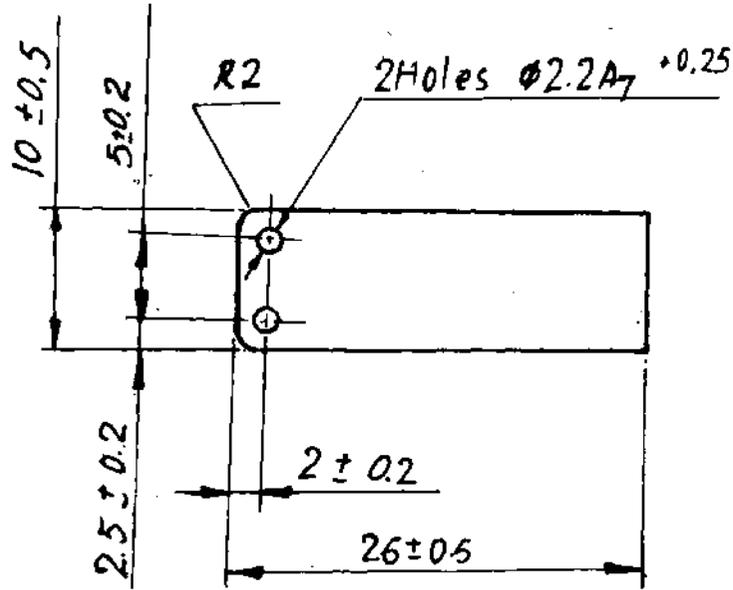
- 1, Blunt sharp edges
- 2, Perform dimensions without deviations with accuracy class 7, OST 1010

APPROVED	M. VASU	765-96-121	
CHECKED	<i>[Signature]</i> DSKUMAR		
CONTROLLERATE OF INSPECTION (ICV)		GASKET	
		BAND 0,25 - ВРБ 27. ГОСТ 1789-70	
		WEIGHT	SCALE
		0,00006	2:1
		SHT	SHTS
		10	371 of 413



1. Unspecified casting radii should not exceed 1,5 mm.
2. Pattern drafts should not exceed 1° towards the body increase beyond tolerance.
3. Blunt sharp edges.
4. Provide dimensions without deviations as per accuracy class 7, OST 1010.
5. Displacement of axes of holes from true position should not exceed 0,2 mm
6. Other requirements for casting are as per Technical requirements TT A1-370.
7. Alternate material is A1 9. GOST 2685-75
8. Coating: Anodically oxidized, chromated or chemical parkerized, blue
9. Apply primer ФЛ-03 Ж, GOST 9109-81, all over, except holes of jaw B and surfaces Г and А, paint with enamel МЛ-12, grey GOST 9754-76, and enamel МЛ-165 (former МЛ-25) silver, GOST 12034-77.
10. Knock-out traces of depth upto 0,5 mm are allowed on surfaces Г and E and on surfaces Г at least 2mm from edges.
11. Drafts not exceeding 3° may be provided on surfaces of hole Ж.
12. Dimension А may be provided instead of dimension U.
13. Bulging of surface Г should not exceed 0,25 mm.
14. Partial paint coating is allowed on surface А.
15. Knurling to a height not exceeding 0,2 mm is allowed on surface K.

APPROVED	M. VASU	765-96-143	
CHECKED	И. М. Ш. - К. К.	COVER	WEIGHT
CONTROLLERATE OF INSPECTION (ICV)			0.035
		A12 ГОСТ 2685-75	368 of 413



Thickness 0.25

1. Blunt sharp edges
 2. Hardness as per Vicker is 350
- (A) EQ. MATERIAL:- CB 101 TO BS: 2870-68 W(H) CONDITION

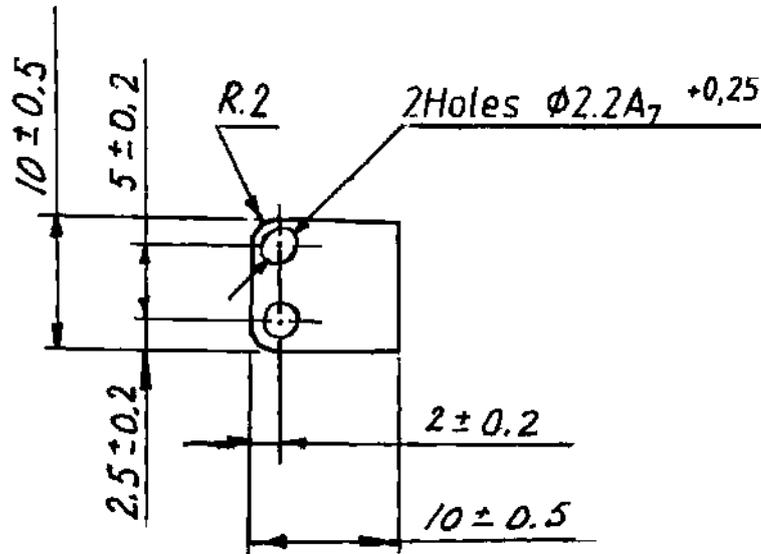
00757-101 V. Ramesh 17-1-2000	(A) G.M.	EQ. MATERIAL IS ADDED IN THE DRAWING
DC(1)NO DATE	ISSUE	NATURE OF AMENDMENTS

317 of 332

APPROVED	M. VASU	765-96-151	330 of 342
CHECKED			
CONTROLLERATE OF INSPECTION (IC V)	PLATE		WEIGHT SCALE 0.0004mm. 2:1
	BAND 0.25 - EPB 2.7 FOCT 1789-73		500 500

765-96-152

∞



Thickness 0.25

- 1. Blunt sharp edges.
- 2. Hardness as per Vicker test is 350 min.
- Ⓐ EQ.MATERIAL:- CB 101 TO BS:2870-68 W(H) CONDITION

20757- ICV v Rom 17 1-2000 DCT/NO DATE	Ⓐ Cur	EQ.MATERIAL IS ADDED IN THE DRAWING
DCT/NO DATE	ISSUE	NATURE OF AMENDMENT

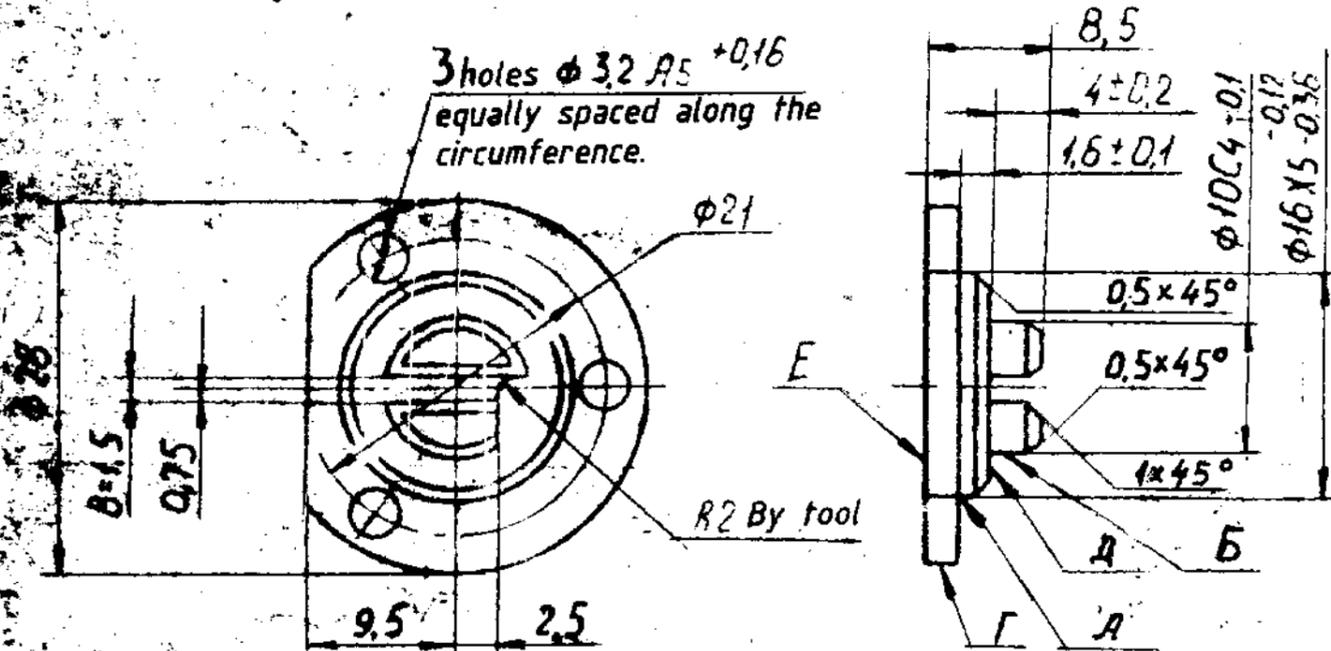
APPROVED *[Signature]* M VASU
 CHECKED *[Signature]* DSKUMAR

765-96-152

CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

PLATE
 STRIP 0.25 - 6pE 2.T
 GOCT 1789-70

	WEIGHT	SCALE
	0.00013	2:1
	SHT 1	SHTS 1

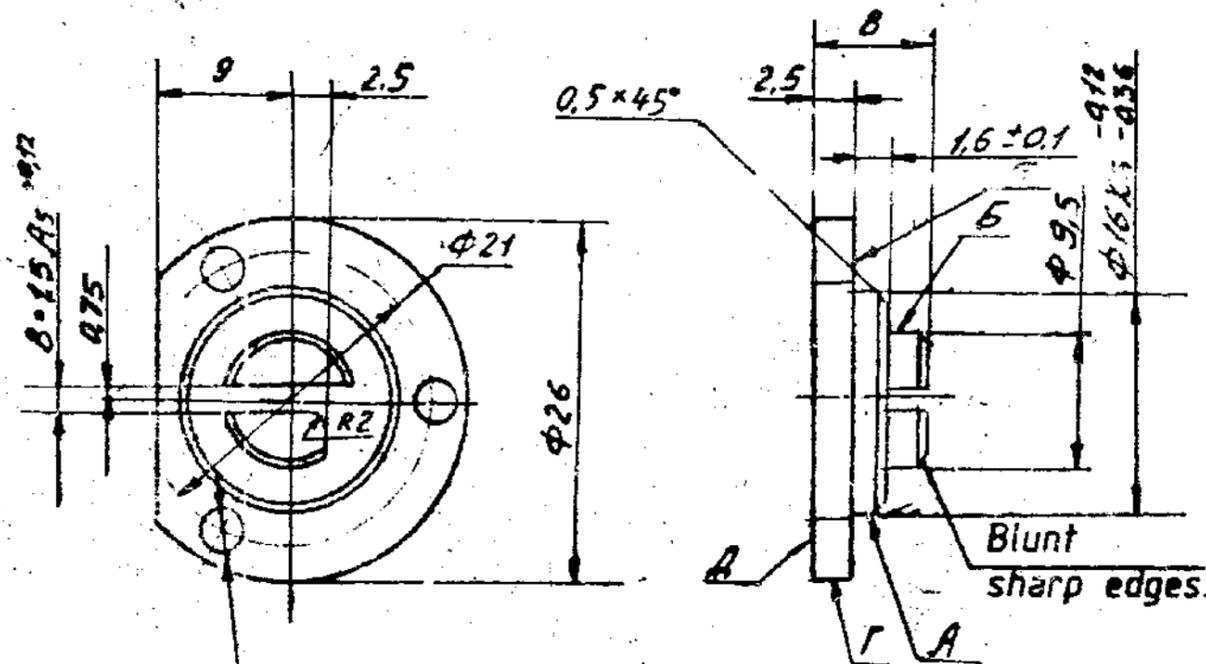


1. Blunt sharp edges.
 2. Displacement of axes of holes from true position should not exceed 0,2 mm.
 3. Provide dimensions without deviations as per accuracy class 7, OST 1010.
 4. Eccentricity of surfaces A with respect to surface B should not exceed 0,1 mm,
 5. Displacement of axis of slot B with respect to axis of surfaces B should not exceed 0,1 mm (qualified-tolerance).
 6. Steps not exceeding 0,2 mm are allowed on surface A.
 7. Coating: Anodically oxidized, chromated.
 8. Apply primer ФЛ-03Ж, GOST 9109-81 on surfaces E and F and paint with enamel -17Ф-223, dark-grey, GOST 14923-78
 9. Unspecified rounding-off radii should not exceed R 0.5
 10. Alternate material is round bar А16Т, GOST 21488-76.
- Ⓐ EQ.MATERIAL-GRADE 24345 TO 16:733-83 'W' CONDITION.

00848-1CV	Ⓐ	EQ.MATERIAL ADDED
DATE	ISSUE	NATURE OF AMENDMENT

APPROVED	765-96-168
CHECKED	
CONTROLLERATE OF INSPECTION (ICV)	RETAINER
	А1Т ГОСТ 4784-74
WEIGHT	SCALE
0.005	2:1
	114

911-96-59L



3 Holes $\phi 3.2 A_7^{+0.16}$
Equally spaced along
the circumference.

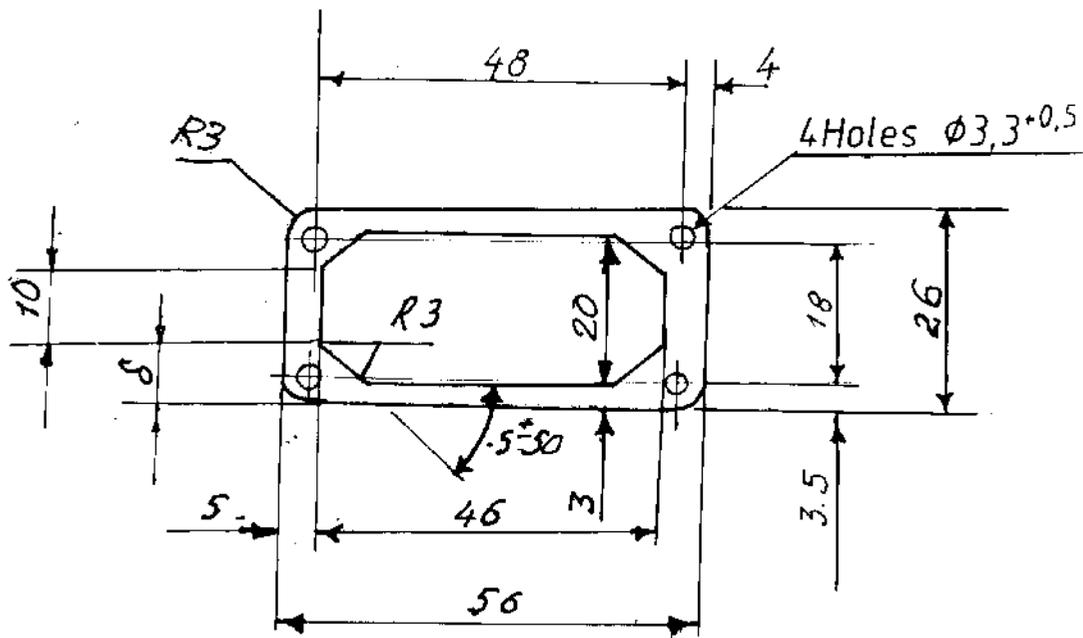
Alternate
M1:1



00848-10 N.V.S. 11.1.2001	(B)	EQ.MATERIAL ADDED
00735-10 V. Romanov 23.9.99	(A)	EQ.MATERIAL ADDED IN THE DRAWING.
DC(1) NO. DATE:	ISSUE	NATURE OF AMENDMENT

1. Displacement of axes of holes from true position should not exceed 0.25 mm.
 2. Provide dimensions without deviations as per accuracy class 7, OST 1010.
 3. Eccentricity of surfaces A with respect to surfaces B should not exceed 0.1 mm.
 4. Displacement of slot axis B with respect to the part axis should not exceed 0.1 mm.
 5. Pattern drafts should not exceed 1° towards the increase of the body.
 6. Other requirements for casting are as per Technical requirements TTA/370.
 7. Alternate material is A/10B GOST 2685-75.
 8. Coating: Anodically oxidized, chromated or chemically parkerized blue, chromated.
 9. Apply primer $\phi\Lambda-03\text{X}$ GOST 9109-76 onto surfaces Γ and δ and paint with grey enamel M/12, GOST 9754-76 and silver enamel M/165, GOST 12034-77.
 10. Partial paint coating on surface E is allowed.
- (A) EQ.MATERIAL (i) Gy: 4600 IS: G17-75 OR,
(ii) Gy: 4600A IS: G17-75
(B) (iii) Gy: 4600A TO IS: G17-94.

APPROVED	N.V.S.	765-96-176	
CHECKED	P.M. St. v. k.		
CONTROLLERATE OF INSPECTION (ICV)		RETAINER	
		WEIGHT	SCALE
		0.005	2:1
		SHT	SHTS
		A/12 GOST 2685-75	



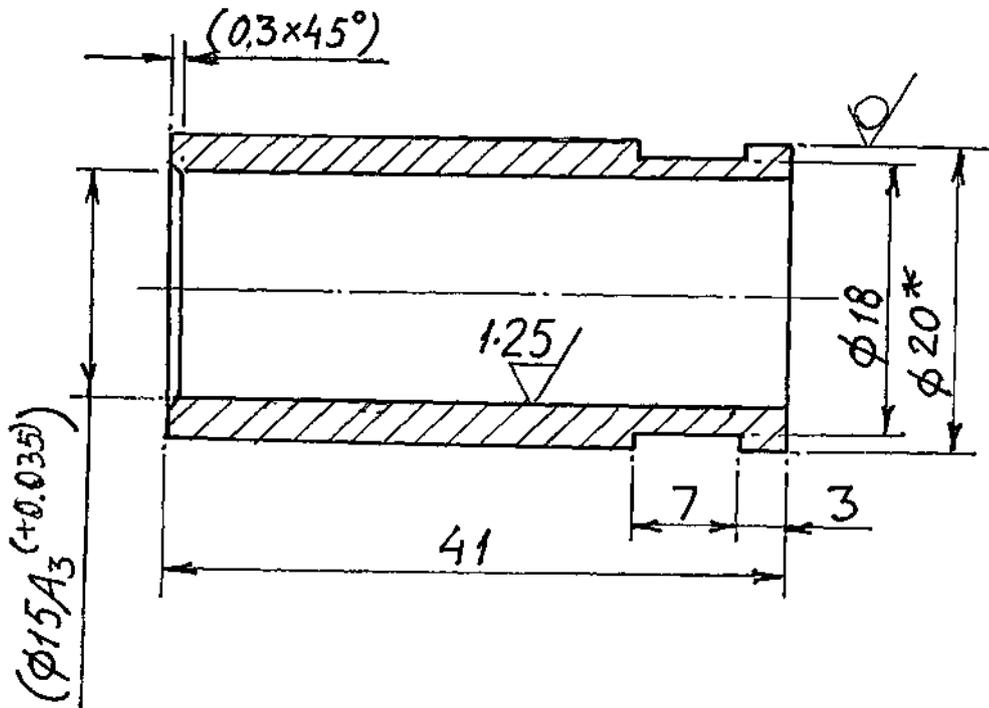
Thickness 0.3 ± 0.05

1. Deviation of centres of holes from their true position should not exceed 0.2 mm.
2. Perform dimensions without deviations with accuracy ± 0.5 mm.
3. Alternate material is packing board of grade B, GOST9347-74.

APPROVED	M. YASU	765 - 96 - 195	
CHECKED	DSKUMAR		
CONTROLLERATE OF INSPECTION (ICV)	GASKET		WEIGHT SCALE
			0.0006 1.1
			SHT SHTS
ELECTRICAL INSULATION BOARD GRADE B ГОСТ 2824-75		10	378 of 413

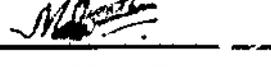
152-96-351

Rz80/



- 1 Alternate material is Бр. (Bronze) АЖ9-4 GOST 18175-78.
2. Unspecified limit deviations of dimensions are
for holes -as per A₇ and
for shafts -as per B₇
3. Dimensions given in brackets are after assembly.
- 4 * Dimension is given for reference.

327 of 332

APPROVED		765-96-351	
CHECKED		BUSHING	
CONTROLLERATE OF INSPECTION (IC V)			
		9045	2:1
ROUND BAR АКРН 20-04 Бр. АМц 9-2, GOST 1628-78		SMT	SHTS
			82

Wires and plug connectors are conventionally not shown.

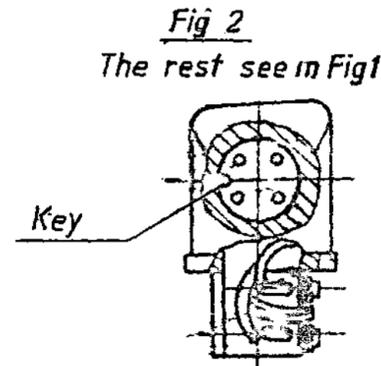
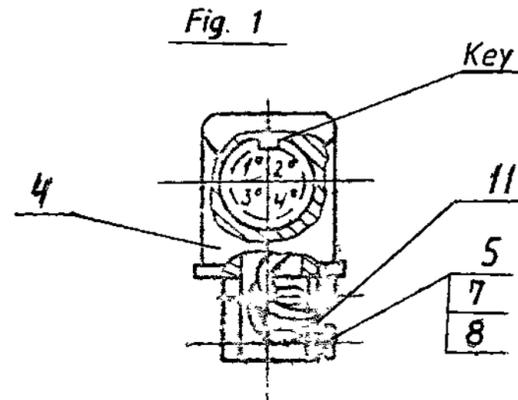
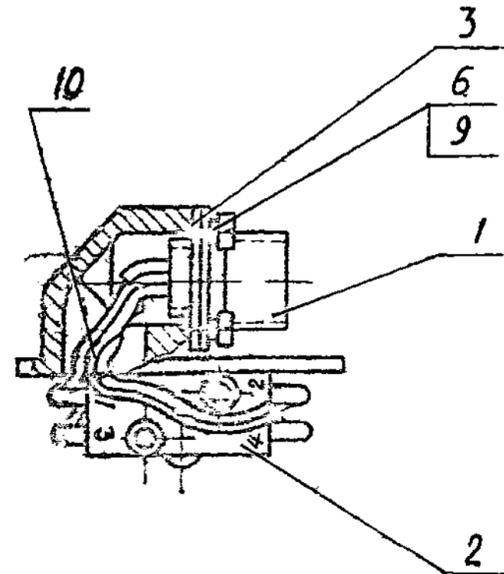
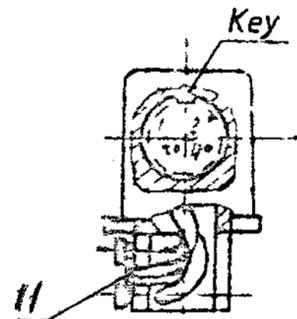


Fig 2
The rest see in Fig 1

Table for soldering conductors.

Micro-switch.	Plug connector
1	1
2	2
3	3
4	4

Fig 1 Alternate.



1. Termination of wires is as per PD 700-88-TT2.
2. Braze using solder ПOC 61, ПРЗ, GOST 21931-76.
3. Slip PVC sleeves Ref. No. 13 over wire ends to micro-switch and sleeves Ref. No. 12 over wire ends to plug connector.
4. Secure sleeves with bakelite varnish of grade ABC-1, GOST 901-78.

Designation	Fig. No.
765-96-сб143	1
-01	2

	Bakelite varnish of grade ABC-1, GOST 901-78		
13	Sleeve III TB-50-355-3.5, colourless GOST 19034-73. l=8	4	
12	Sleeve III TB-50-355-2.5, colourless GOST 19034-73. l=20	4	
7	Washer 2x1 01.019 or 2x1.02.019 GOST 11371-78.	2	
6	Screw M3.8h6hx8.48.016 GOST 17473-72 or M3.8h6hx8.66.016 GOST 1491-72.	4	
8	Washer 2T 65 F 05, GOST 6402-70.	2	
	Solder ПРЗ ПOC-61 GOST 21931-76.		
2	Micro switch А-703 HO.360.011.	1	Commercial
14	ПН 42/1	8	
11	Wire МГЛБ-0.35 mm ² TY 16-505.437-73 l=90	2	
10	Wire МГЛБ-0.35 mm ² TY 16-505.437-73 l=60	2	
9	Washer 3T65Г 05 GOST 6402-70.	4	
5	Screw M2. 6gx18.48.016 GOST 17473-72 or M2. 6gx18.66.016 GOST 1491-72.	2	
1	Plug 2PM 14 Б 4ш 1B1 FED.364.126TY	1	Commercial
4	765-96-73 or 765-96-143	1	Cover
3	765-96-15	1	Gasket
REF. NO.	Designation.	Description	Qty Remarks

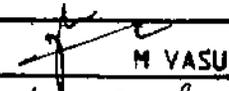
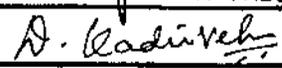
765-96-сб143

DS KUMAR

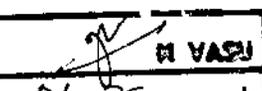
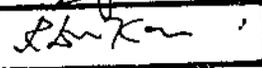
COVER

SCALE
0.065 1:1

DESIGNATION	DESCRIPTION	QTY	REMARKS
	Technical papers		
13 765-96-c8177CB	Assembly drawing		
	Parts		
1 765-96-202 -NR	Body	1	NR
2 765-96-351	Bush	1	
	Materials		
3	Primer ФА-03-Ж GOST 9109-76		
4	Enamel МА-12 Grey. GOST 9754-76		
5	Enamel МА-165 Silver, GOST 12034-77		

APPROVED	 M VASU	765-96-C8177	
CHECKED	 D. Radivchev	BODY	
CONTROLLERATE OF INSPECTION (ICV)		WEIGHT	SCALE
		SHT	SHTS
		(7)	

NO.	ZONE	QTY	DESIGNATION	DESCRIPTION	QTY	REMARKS
				Technical papers		
13			765-96-c8178C6	Assembly drawing		
			765-96-TT101	Technical requirements for mounting and checking of limit switches		
				Assembly units		
12	1		765-96-c8143	Cover	1	
13	2		765-96-c8177	Body	1	
				Parts		
(A)	5		765-96-74	LV2/RCV- 5330-009541	3	Max. qty
12	6		765-96-119	Rod	1	
	7		765-96-121	Gasket	5	Max. qty.

APPROVED	 H VASU	765-96-c8178		57 of 180
CHECKED		LIMIT SWITCH (PUSH TYPE)		WEIGHT SCALE
CONTROLLERATE OF INSPECTION (ICV)				SMT 1 SMTS 3

QTY	REMARKS	DESCRIPTION	DESIGNATION	UNIT	POST	ZONE	SECTION
1		Plate	765-96-151	8			
1		Plate	765-96-152	9			
1		Retainer	765-96-168 or 765-96-176	10	12		
1		Gasket	765-96-195	11			
1		Nut	700-30-455	13			
1		Screw	765-96-350	14			
1		Screw	700-35-408	15			
1		Spring	700-38-1495	16			
1		Gasket	700-40-153	17			
1		Cup	765-64-499	19			

37/31

Ref. No. 21 & 22 1st Year of Specifications GOST 17473 & GOST 1491 WAS 72

00299-1CV
19 NOV. 91
DEC. No. & DATE

NATURE
ISSUE
AMENDMENT

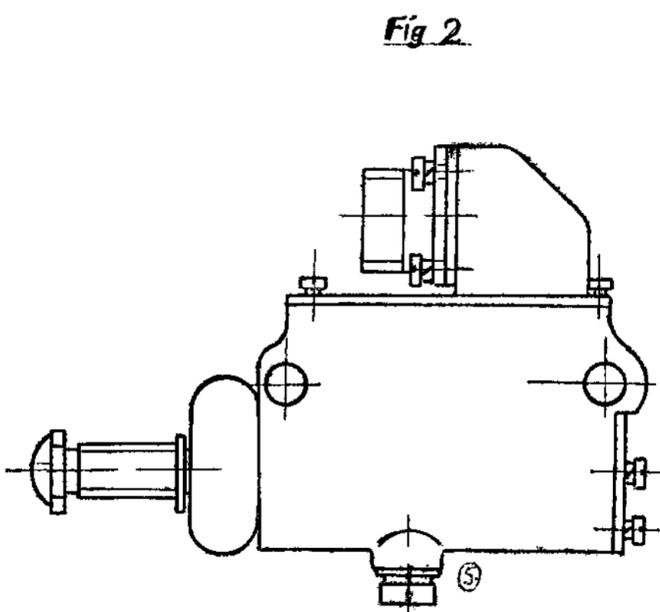
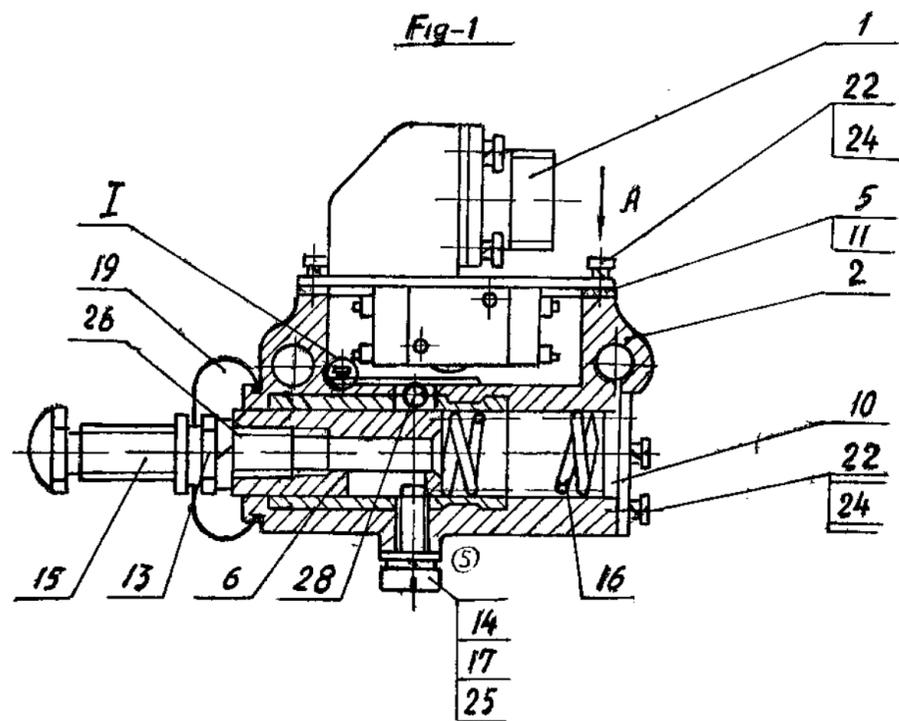
Standard items

21	(A)	Screw M26g x 6.48.016 GOST. 17473-80	2
22	(A)	Screw M38h6h x 8.48.016 GOST. 17473-80 Or M38h6h x 866016 GOST. 1491-80	7 2 off

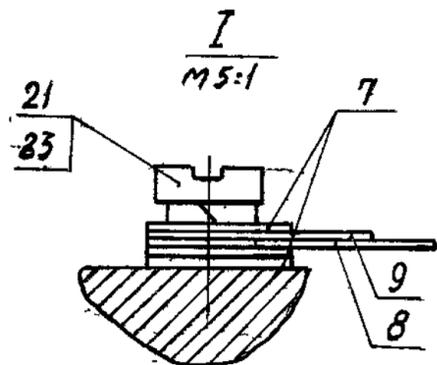
APPROVED	<i>[Signature]</i> H VASU	765-96-CB178 / 58 of 180		
CHECKED	<i>[Signature]</i>	LIMIT SWITCH (PUSH TYPE)	WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)			SHT 2	SHTS 3

ZONE	DESIGNATION	DESCRIPTION	QTY	REMARKS
		Washers as per		
		GOST 6402-70		
23		2T65Г05	2	
24		3T65Г05	7	2 Off
25		6T65Г06	1	
26		8T65Г06	1	
		<u>Other items</u>		
28		Ball B V 6 mm H		Commercial
		GOST 3722-60 and		
		ETY 500-65	1	
Difference in execution of 765-96-c8178CB and 765-96-c8178CB-01 are in accordance with Assembly drawing				
		DDA21-ICV <i>Bob</i> FEB 94	(A) <i>Bob</i>	PART LIST REF. NO. 5, D S CAT PART NO LV2/RCV. 5330-009541 ADDED
		DCCU NO P. DATE	ISSUE	AMENDMENT

APPROVED	<i>[Signature]</i> H VASU	765-96-c8178-	59 of 180		
CHECKED	<i>[Signature]</i>				
CONTROLLERATE OF INSPECTION (ICV)		LIMIT SWITCH (PUSH TYPE)		WEIGHT	SCALE
				DIT 3	SHTS 3



- 1) The rod should move smoothly without jamming
- 2) Set plate, Ref No 8, in such a way so that the ball in depressed position does not deform it Adjust using washers Ref No 7
- 3) Set required number of gaskets, Ref No 7 on plate, Ref No 9, in case screws, Ref No 21, project into the cavity of bush
- 4) Micro switch contacts 1 and 2 should be open while 3 and 4 closed during movement of rod by $2.5 \pm 0.5 \text{ mm}$ When the rod restores to the initial position micro-switch contacts 1 and 2 should be closed and 3 and 4 disconnected Adjust with gaskets, Ref No 5 and Ref No 11.
- 5) Lubricant and foreign bodies are not allowed on the parts of limit switch
- 6) After final assembly and adjustment of limit switch coat the cover screws, Ref No 1 and screw, Ref No 14 with red enamel $\rho\phi-223$, GOST 14923-78, in compliance with view A
- 7) Other requirements are as per technical requirements 765-96-TT101



View-A
M2:1

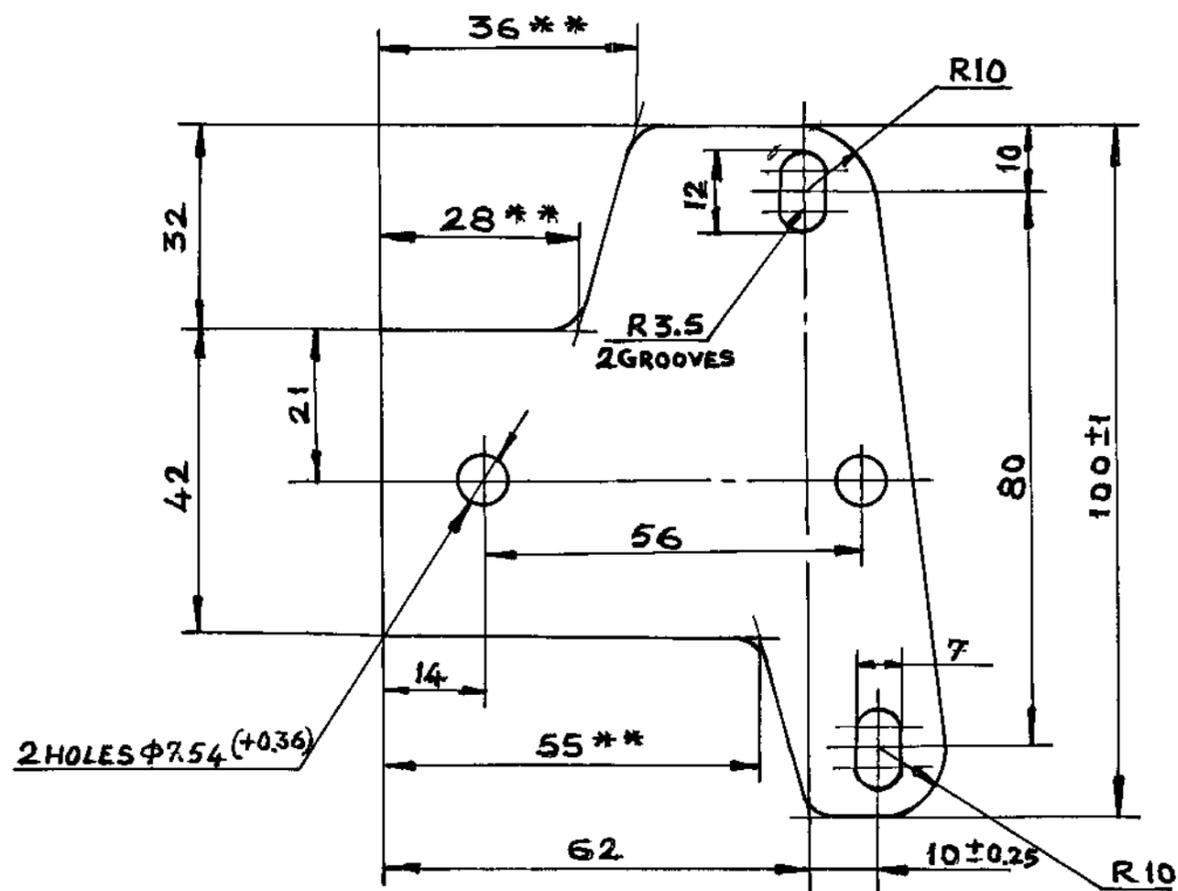


765-96-c6178CB	Fig 1
-01	Fig 2

APPROVED		765-96-C6178CB		60 of 100
CHECKED	<i>[Signature]</i>			
CONTROLLERATE OF INSPECT JN (ICV)		LIMIT SWITCH(PUSH TYPE) ASSEMBLY DRG.		WEIGHT 0-275
				SCALE 1:1
		SHT	SHTS	

Л-56-819Е

R_z150 (✓) (✓)

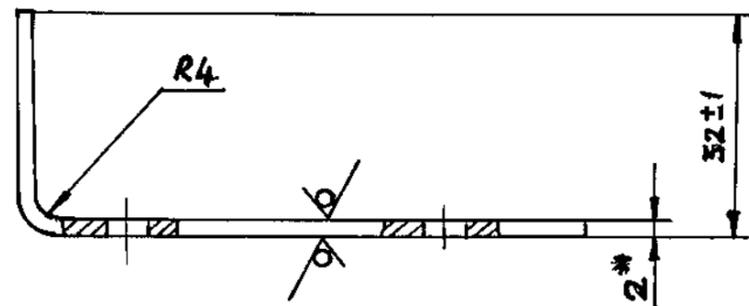


TECHNICAL CONDITIONS

1. ALTERNATE MATERIAL IS STEEL 20 GOST 1050-74
- 2 * DIMENSION IS FOR REFERENCE.
- 3 ** DIMENSIONS ARE PROVIDED WITH TOOLS
4. UNSPECIFIED LIMIT DEVIATIONS OF DIMENSION ARE ±0.5 MM.
- 5 UNSPECIFIED RADII ARE 5MM.
6. OTHER TECHNICAL REQUIREMENTS ARE AS PER OST 3.4343-79

NOTE:-

1. ALL DIMENSION ARE IN MM
- 2 THE ABBRIVIATIONS AND SYMBOLS ARE BASED ON RUSSIAN SPECIFICATION



SHEET 5-119-0-2 GOST 19903-74 5-III-Г-10 GOST 16523-70		DC (D) No & DATE	ISSUE	AMENDMENTS
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF. DRG. N I TO BE SCALED SCALE:- 1:1 DATE :-		ALL THREADS TO CONFORM TO SPECIFICATION. TOLERANCE ON DIMENSION UNLESS OTHERWISE SPECIFIED		STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR. USED ON:- 3678-95-С87
D.S. APPROVED	WT :-(KG) 0.06	BRACKET		
DATE	0.06			
DRAWING NO 3-678-95-7		PART NO		
CONTROLLER/TE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)				

06/07/2005

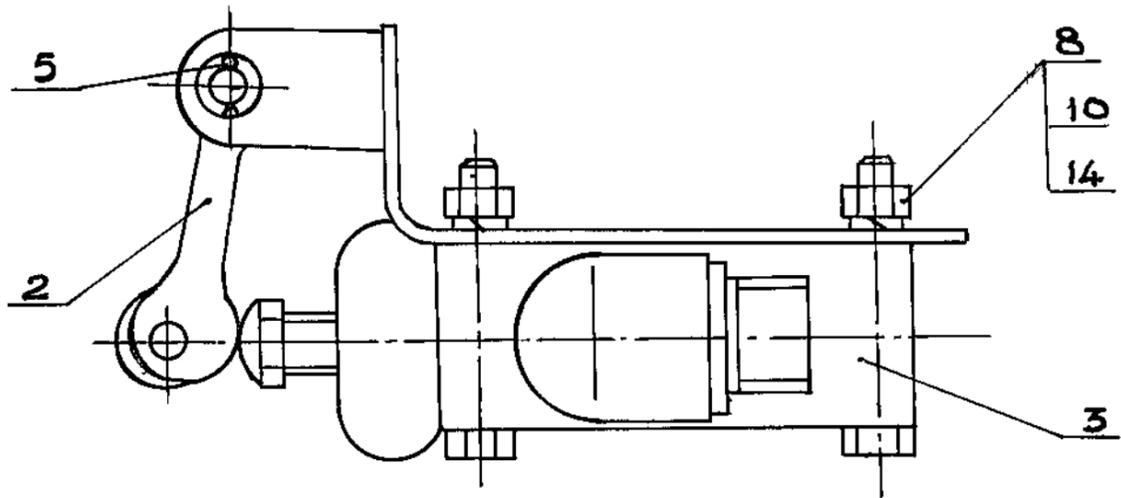
REF. NO.	DESIGNATION	DESCRIPTION	DS CAT NUMBER	I.S. EQUIVALENT	QTY	REMARKS
		<u>TECHNICAL REQUIREMENTS</u>				
	3678-95-cd6c5	ASSEMBLY DRAWING				
		<u>ASSEMBLY UNITS</u>				
1	3678-95-cd7	BRACKET			1	
2	765-41-cd131	LEVER			1	
3	765-96-cd178	LIMIT SWITCH (PRESSING)			1	
		<u>PARTS</u>				
5	700-38-1035	SPRING			1	
6	700-47-358-03	AXLE			1	
		<u>BOLT M6X40-46.019</u>				
		GOST 7795-70			2	
		<u>NUT M6-7H.6.019</u>				
		GOST 5927-70			2	

DOC. NO. DATE		ISSUE	NATURE		
AMENDMENTS					
DRN	TCD	CHD	APD	DATE	
		4/2	0/1		
DRG. No.			DS CAT No.		
3678-95-cd6					
LIMIT SWITCH				SHT	SHTS
				1	2
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)					

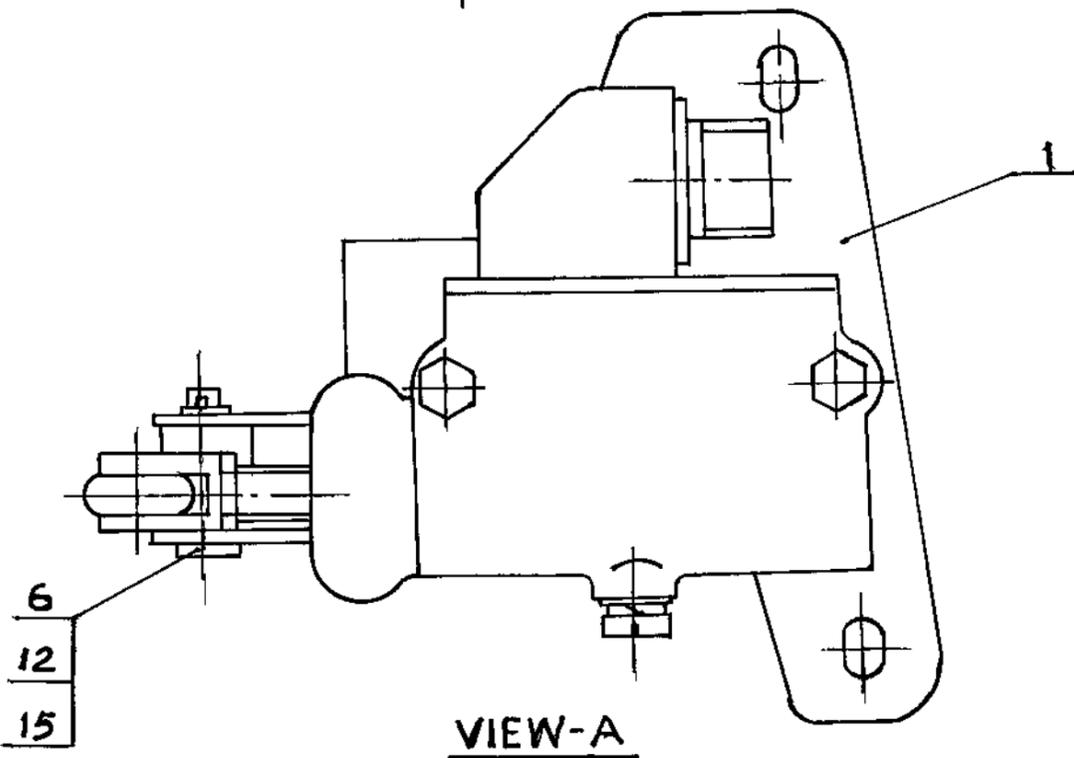
OLD REF.

18 12/26

3678-95-cf6c5



A ↑



VIEW-A

NOTE;-

1. ALL DIMENSIONS ARE IN MM
2. THE ABBREVIATIONS AND SYMBOLS ARE BASED ON RUSSIAN SPECIFICATIONS

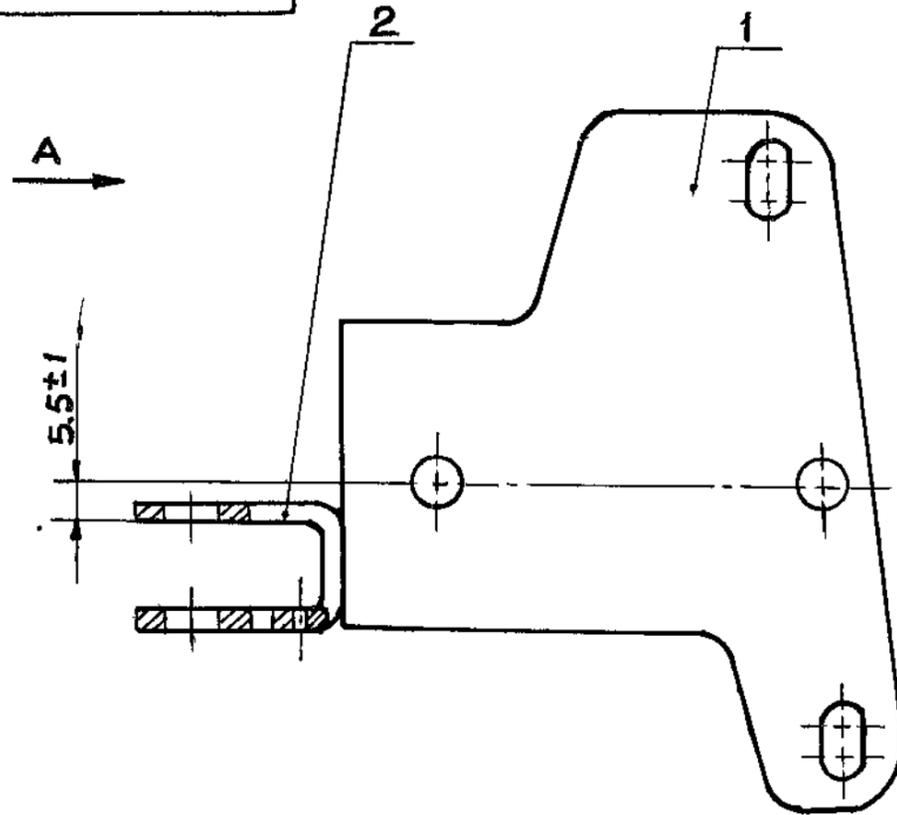
TECHNICAL CONDITIONS

1. BEFORE PUTTING THE SPRING REF.5 LEVER REF.2 SHOULD SHAKE EASILY WITHOUT JAMMING
2. LEVER REF.2 AFTER PUTTING SPRING SHOULD BE CLAMPED TO ROD OF LIMIT SWITCH REF 3 FOR WHICH SPRING REF.5 SHOULD WIND TWICE AROUND THE AXIS REF.6.
3. AFTER PUTTING THE SPRING REF.5 THE ENDS OF THE SPRING SHOULD BE BEND.

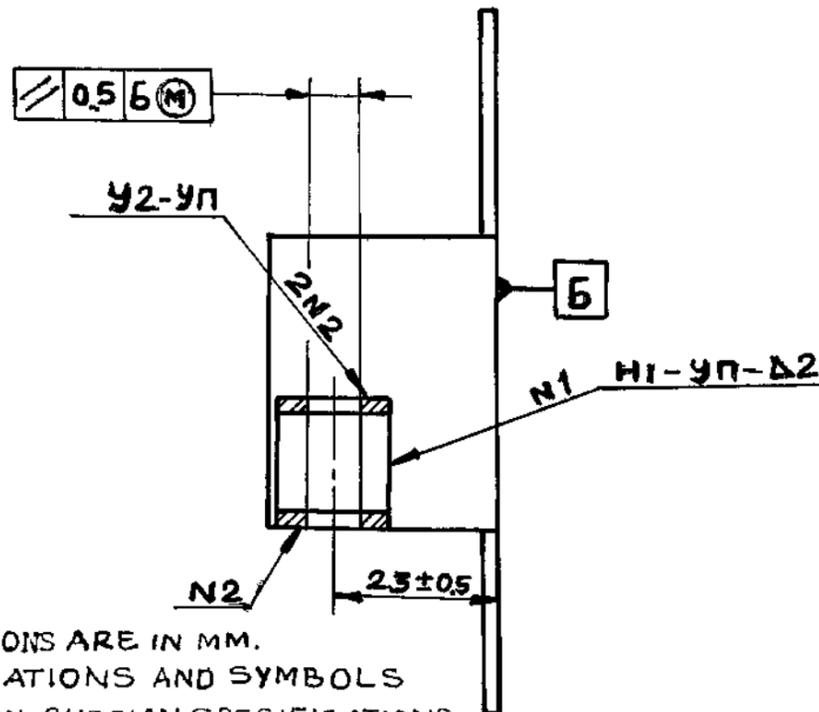
NEAREST EQVT MATERIAL			
O GL MATERIAL		DCUIN. A DATE	ISSUE
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.	ALL THREADS TO CONFORM TO SPECIFICATION.	STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.	
DRG. NOT TO BE SCALED		USED O':- 3678-95-285	
SCALE:- 1:1	TOLERANCE ON DIMENSION UNLESS OTHERWISE SPECIFIED		
DATE :-			
DRN. <i>SPR</i>	WT :-(KG)	LIMIT SWITCH	
TCD.	0.425		
CHD. <i>je</i>		DRG No.	DS CAT No
APD. <i>je</i>		3678-95-cf6c5	
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)			

570 0x1070

3678-95-CD7CB



VIEW A



NOTE;-

1. ALL DIMENSIONS ARE IN MM.
2. THE ABBRIVIATIONS AND SYMBOLS ARE BASED ON RUSSIAN SPECIFICATIONS.

TECHNICAL CONDITIONS

1. WELDS ARE AS PER GOST 14771-76, WELDING WIRE CB.08Г2C TO GOST 2246-70
2. REQUIREMENTS FOR THE QUALITY OF WELDS ARE AS PER OST 3-4001-77 FOR UNESTIMATED WELDING JOINTS
3. COATING PRIMER φА-05K TO GOST 9109-81 ENAMEL ПФ-223 WHITE-1 GOST 14923-78

NEAREST EQVT MATERIAL			
ORGL MATERIAL		DC(D)No & DATE	ISSUE
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.	ALL THREADS TO CONFORM TO SPECIFICATION.	AMENDMENTS	
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	STAMP OR ETCH, PART NO. MANUFACTURER'S NAME & YEAR OF MFR.	
SCALE:- 1:1		USED ON:- 3678-95-CD5	
DATE :-			
DRN. APPROVED	WT :-(Kg)	BRACKET	
TCD.	0.085		
CHD.		DRAWING NO	PART NO
APD.		3678-95-CD7CB	
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)			

Handwritten signature or initials at the bottom right corner.