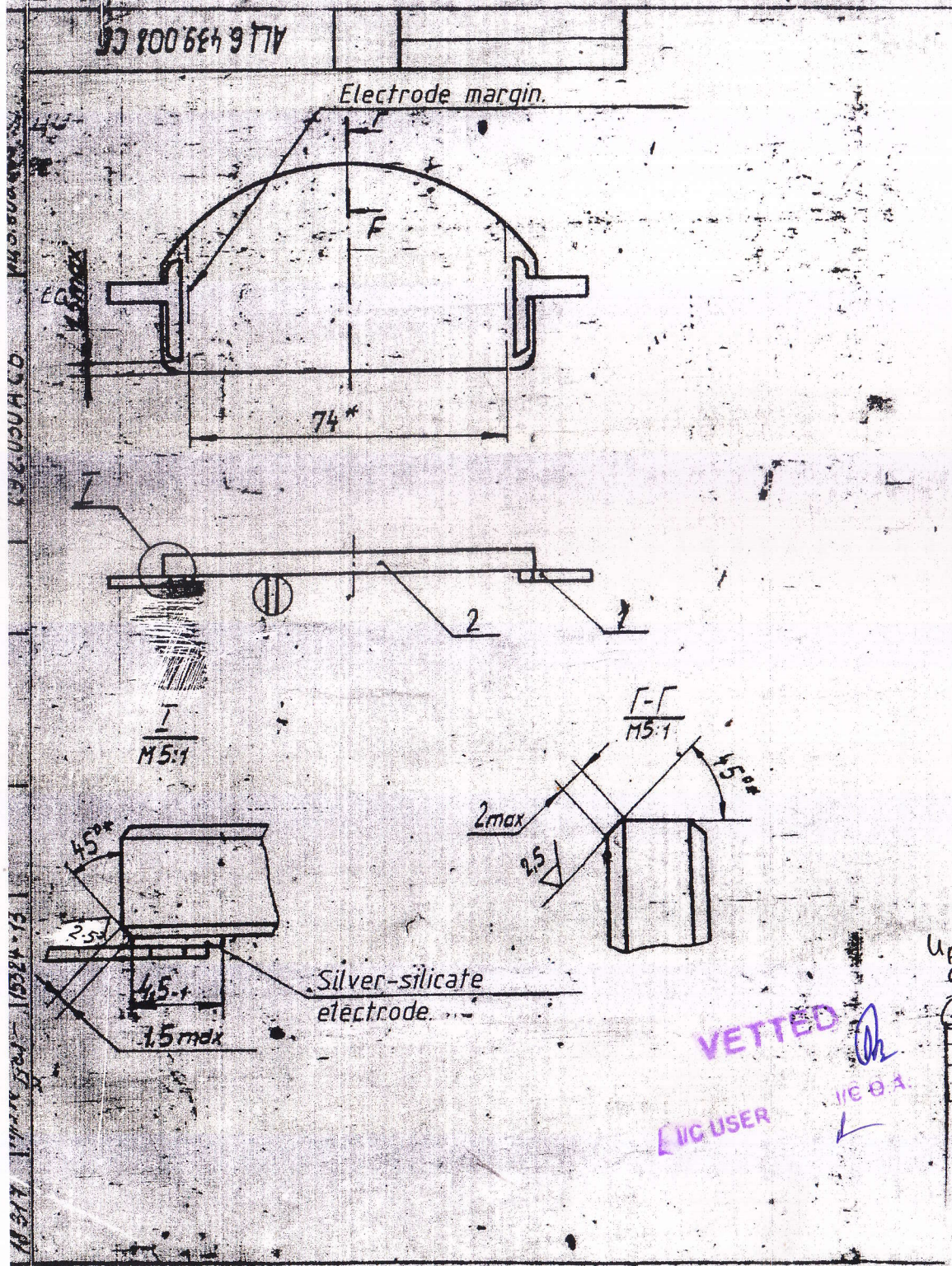


(11) 1oin OCT 3.1901-85 (14)

1. ~~Current conditing film SnO_2-x+F.~~

2. Apply silver-silicate electrodes, 0,02 to 0,05 mm thick, onto current-conducting coating along complete length.
3. Paste busbars, Ref.No.1, with adhesive БФ-2, GOST 12172-74, and then by heat tin-plated points of busbars till solder is melted. Busbars may be heated over the entire length. Do not apply adhesive o onto tin-plated points of busbars.
4. Resistance of current-conducting coating should be provided so that requirements specified in item 1 of drawing AU5.803.005 СБ are met.
5. Presence of solder not projecting beyond electrode margin is allowed on electrodes in area where busbars are tin-plated.
6. *Dimensions are given for reference.
7. Other technical requirements are as per Technical specifications TY 3-3834-78.

Updated on 15.7.92 wm/DO SOV. SP SE. 2P

UPDATED UPTO 15-12-92 wm/DO

(14) AU4.69-86 7.7.86.

A00021 KD ALAI 1459 (20)

AU 6.439.008 СБ

UP DATED UPTO 15-11-90 wm/DO

UPDATED UP TO 20.10.88 AWM/DO

SRO	SHT	DOC NO	SIGN	DATE
DRAWN		P.R.BABU.		26.7.84.
TECHD		D.K.JAIN		2.8.84
F/M, DC		S.R.NAIR		3.8.84
DIV.OFFR		T.K.BANERJEE		3.8.84

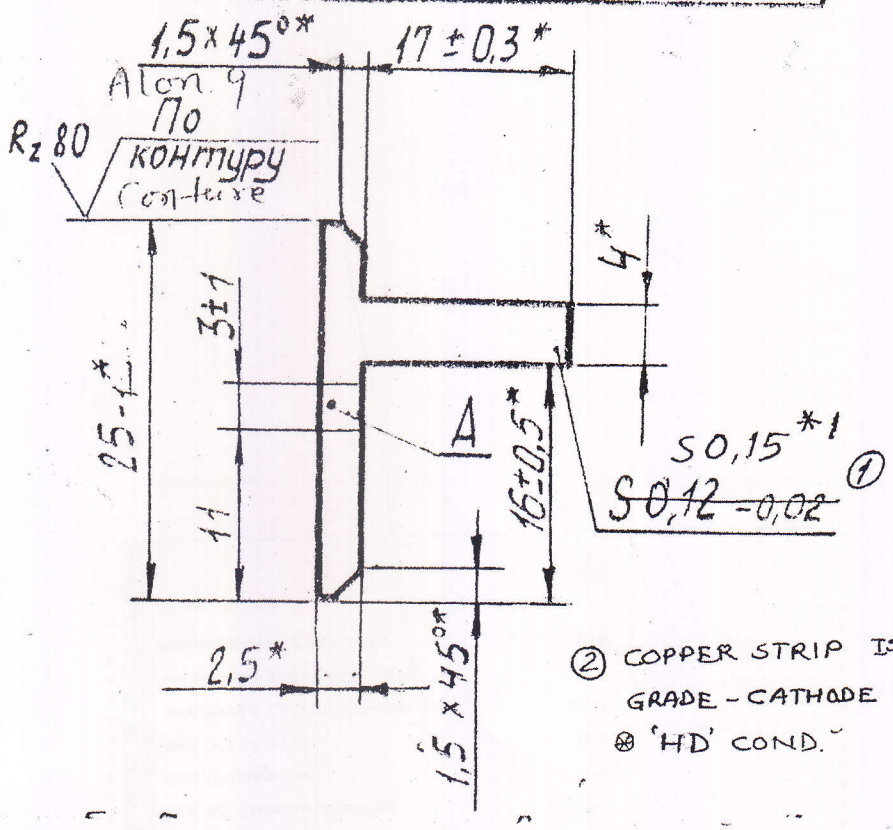
HEATING PLATE

Assembly drawing.

SHEET	WEIGHT	SC
	0,0405	1:

TOTAL SI

ORDNANCE FAC
PROJECT
HYDERABA



(V)

② COPPER STRIP IS: 1897
GRADE - CATHODE COPPER IS: 191 (Pt-IV)
⊛ 'HD' COND.

1. Heat treatment : Vaccum anealing degree of annealing is checked in accordance with GOST 1173-77 on two samples of dimensions 20X60mm from each batch.

2. Surface A is tin plated with solder ПОС 61 GOST21931-76 on side adjacent to the electrode.

   Thickness of tin plating should not exceed 0.06mm. The waste of flux should be removed.

3. Deformation and burrs are not allowed.

4. Unspecified deviation limits of dimensions.

   of holes - as per H 14
   of shafts - as per h 14
   of remaining - as per $\pm \frac{JT15}{2}$

5. Dimensions are ensured by tool.

6. Remaining technical requirements are according to OST3-4343-79.

VETTED

⊛ UPDATED ON 20-03 JWM/DO DGM/TS
(HD COND. INTRODUCED)

② DAY-38-99 DT 4 10/99 JWM/DO DGM/DO

WM/DO SDV. SPL.

UP DATED UPTO 15.11.90
40021 KD AL4

① *1 DIMENSION FOR REFERENCE

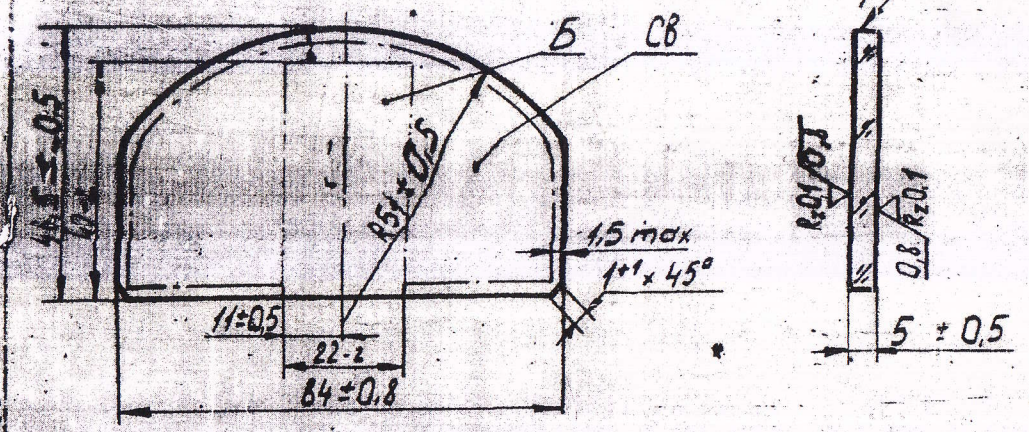
AL4 7.755.023
BUS BAR
Лента ДПРНТ 0,12 Н.Д. М1
ГОСТ 1173-77 ② SEE ABOVE

1(2) AL32 ON Updated 15-12-92

WM/DO

Т. контр. Сергеева
Н. контр. Царькова

АЦ 8.640.034



2,5 ▽ 8,0 (V)

Δne	5
Δ(nF'-nC')	5
HOMOGENEITY.	5
DOUBLE REFRACTION.	4
ALTERNATION.	6
NON-STRIATION.	*
BLISTERNESS.	7E
N	-
ΔN	-
P	V
θ	*:

1. Depth of occurence of defects (fumes, wrinkles, dents) outside light zone is not standardized.
2. Edge chamfers should not exceed 0,5 x 45°.
3. Wedge shape ** of plate should be provided so that collimating ray is deviated with stack consisting of plate АЦ8.640.033 and two plates АЦ8.640.034 by not more than 2'.
4. Absolute difference of values of angular deviation in area Б should not exceed 1'.
5. Surface А along perimeter of plate may not be machined surface finish is provided by moulding.
6. Non-striation * and other technical requirements are as per Technical specifications ТУ 3-3.834-78.

VETTED
IIC USER
IIC Q.A.

Updated on 15.12.92 WM/DO
ACD 21 KD AL 4 14 5.9
SE-2P

АЦ 8.640.034

UPDATED UPTO 15-11-90 WM/DO, SDV. SP.

UPDATED UPTO 20.10.88 AWM/DO

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		P.R.BABU.		30.7.84
EDT/CHKD		A.K. DUBEY		2.8.84
F/M,DC.		S.R.NAIR		2.8.84
DIV.OFFR		T.K.BANERJEE		3.8.84
		NAME	SIGN	DATE

PLATE

GLASS ЛК 105
ГОСТ 3514-76.

SHEET	WEIGHT	SCA
A	0,04	1

TOTAL SHE

ORDNANCE FACT
PROJECT
HYDERABAD