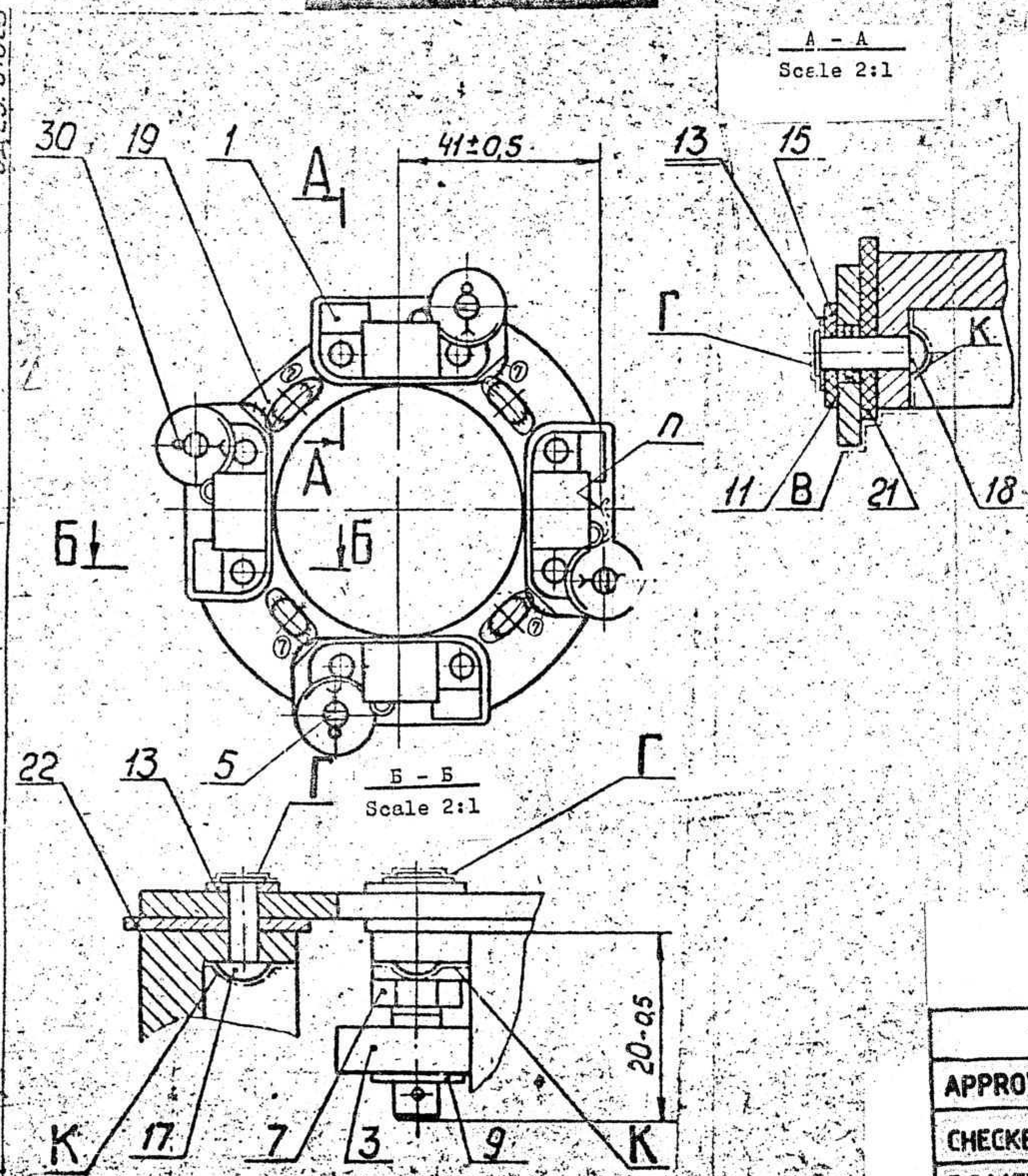


TECHNICAL CONDITIONS

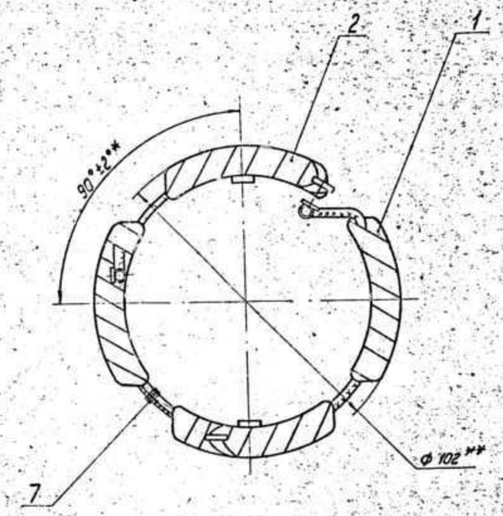
1. Set the pressure (550±25 g) of springs, Ref. No. 3, at points "П" by turning the *shaft*, Ref. No. 5. Lock the shaft with nut, Ref. No. 7.
2. Upon beading the rivets, coat surfaces K and B with enamel ГФ-92ХС, grey, ГОСТ 9151-75.
3. Parallel misalignment relative to windows of opposite brush holders is within 0.2 mm.
4. Use washers, Ref. No. 10 or Ref. No. 13, as may be required by the protruding length of rivets, Ref. No. 17 or Ref. No. 18.

20/D2073

APPROVED	ЭД25·050 СБ		
CHECKED		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION	CROSS BEAM ASSEMBLY DRAWING	0·16	1:1
FE [illegible] PUNE		SHT	SHTS 1

-4-

ЗД 25.100 СБ



TECHNICAL CONDITIONS

1. *The size is provided by the use of appropriate tools.
2. **Size for reference.
3. Attach the lead connecting the shunt coils, Ref. No. 1, to the jumper, connecting the series coils, Ref. No. 2, by means of threads, Ref. No. 7.
4. Coat the attachment points with varnish HЦ-286, black, ТУ6-10-1290-78. Site the knot using butvar-phenolic adhesive БФ-4 ГОСТ 12172-74.

APPROVED	ЭД 25·100 СБ	WEIGHT	SCALE	
CHECKED	SERIES AND SHUNT COILS	0.45	1:1	
		SHT	SHTS 1	

ЭД 25.100 С Б

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

ADHESIVE GRADE БФ-4 TO GOST 12172-74 IS A PHENOL-POLYVINYLACETAL GLUES WHICH ARE SOLUTIONS OF PHENOL - POLYVINYLACETAL AND RESOL PHENOL-FORMALDEHYDE RESINS IN ALCOHOL

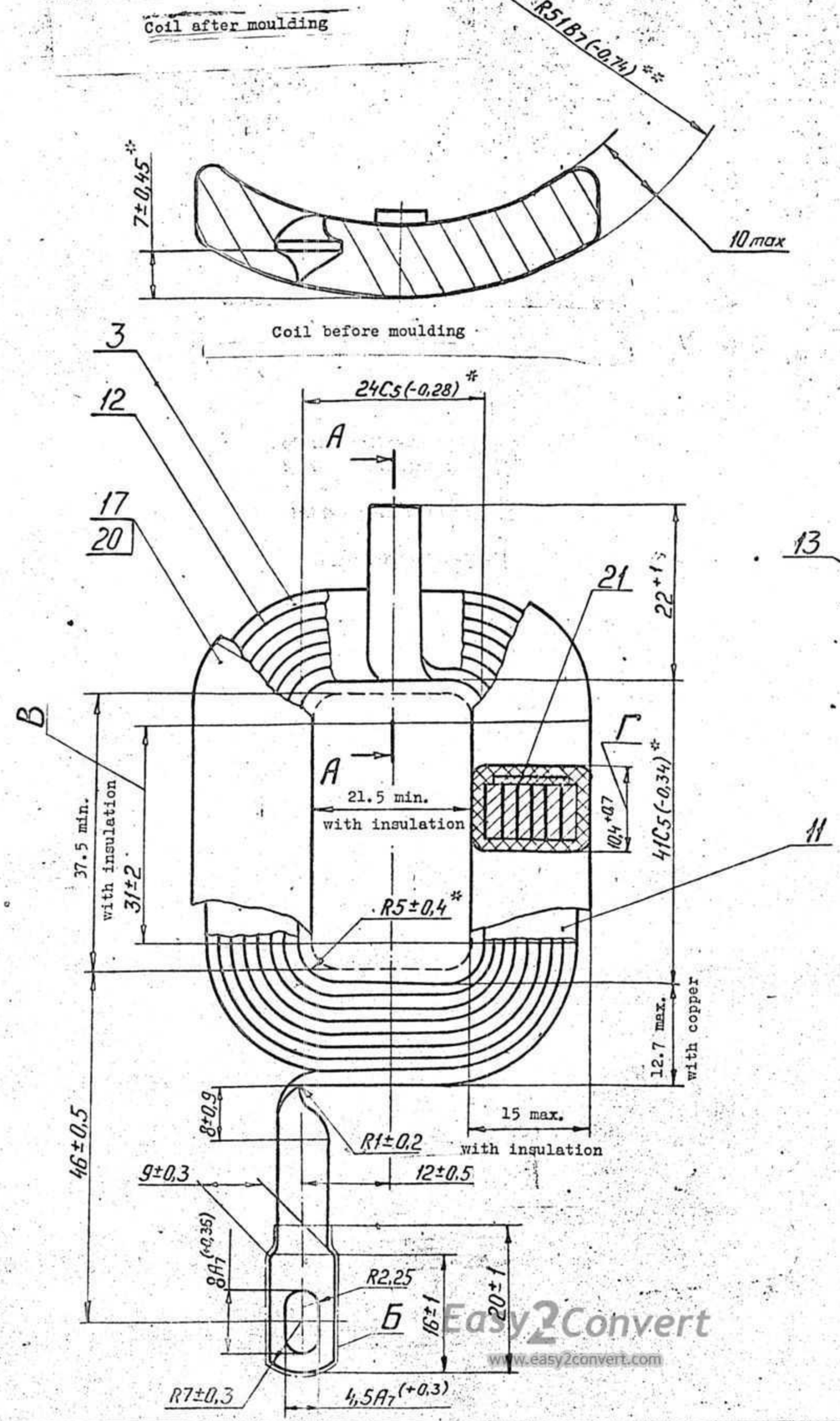
БФ-4	
PROPERTIES AS PER GOST 12172-74	
1) APPEARANCE	TRANSPARENT OR SLIGHTLY TURBID FLUID FROM LIGHT YELLOW UP TO REDDISH COLOUR
2) VISCOSITY AS PER VISCOMETER B3-1 (NOZZLE 54) AT 20°C	30 – 60 Sec.
3) CONTENT OF DRY RESIDUE %	10 – 13
4) SHEAR STRENGTH OF GLUED JOINT IN Kg/cm^2 NOT LESS THAN AT 20°C & 60°C	200 100
5) BENDING OF GLUE FILM AFTER SOLIDIFICATION & AGEING	1
6) HEAT RESISTANCE OF GLUE FILM AFTER SOLIDIFICATION AND AGEING	ABSENCE OF CRACKS
7) OPERATING TEMPERATURE FOR GLUE OF GRADE БФ-4 FROM -60 TO +60 °C	—

VARNISH HЦ-286, BLACK
AS PER TY 6-10-1290-78
PHYSICAL & CHEMICAL PROPERTIES GIVEN BELOW:

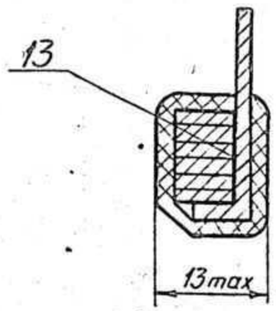
	DESCRIPTION OF THE INDICES	REQUIREMENTS
1)	APPEARANCES & COLOUR OF VARNISH.	HOMOGENEOUS LIQUID OF BLACK COLOUR WITHOUT FOREIGN INCLUSIONS A SLIGHTLY VIOLETE TINT IS ALLOWED
2)	APPEARANCES OF COAT OF VARNISH	AFTER DRYING THE COATING SHOULD BE UNIFORM & SMOOTH.
3)	CONVENTIONAL VISCOSITY AS PER VISCOMETER B3-4 AT 20° SEC.	30 – 60
4)	CONTENTS OF SUBSTANCES %	11 – 15
5)	ACID NUMBER OF AQUEOUS EXTRACT MG KOH MAX.	0·5
	TIME OF DRYING AT 20 ± 2°C	
	a) UP TO DEGREE 3	1
	b) UP TO DEGREE 4	48
6)	HARDNESS OF COATING AS PER PENDULUM DEVICE M-3 IN CONVENTIONAL UNITS IS MIN.	0·4
7)	BENDING OF COATING MAX.	1
8)	RESISTANCE OF COATING TO THE EFFECT OF BENZINE AT 20±2° MIN.	24
9)	RESISTANCE COATING TO THE EFFECT OF MINERAL OIL AT 20±2°C MIN.	24

						INSCRIBED	
						CHECKED	
						APPROVED	
						DATE	
	DCN	DT.	ZONE	BRIEF RECORD.	SIGN.	TOLERANCE UNLESS OTHERWISE SPECIFIED. GEN. DEC. ANG.	

DRG. NOT TO BE SCALED
ALL SHARP CORNERS & EDGES TO BE ROUNDED OFF
ALL DIMENSIONS ARE IN MM. UNLESS OTHERWISE SPECIFIED
PERTAINS TO
SERIES AND SHUNT COILS
ЭД 25·100 СБ
SCALE:-
CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT. PUNE



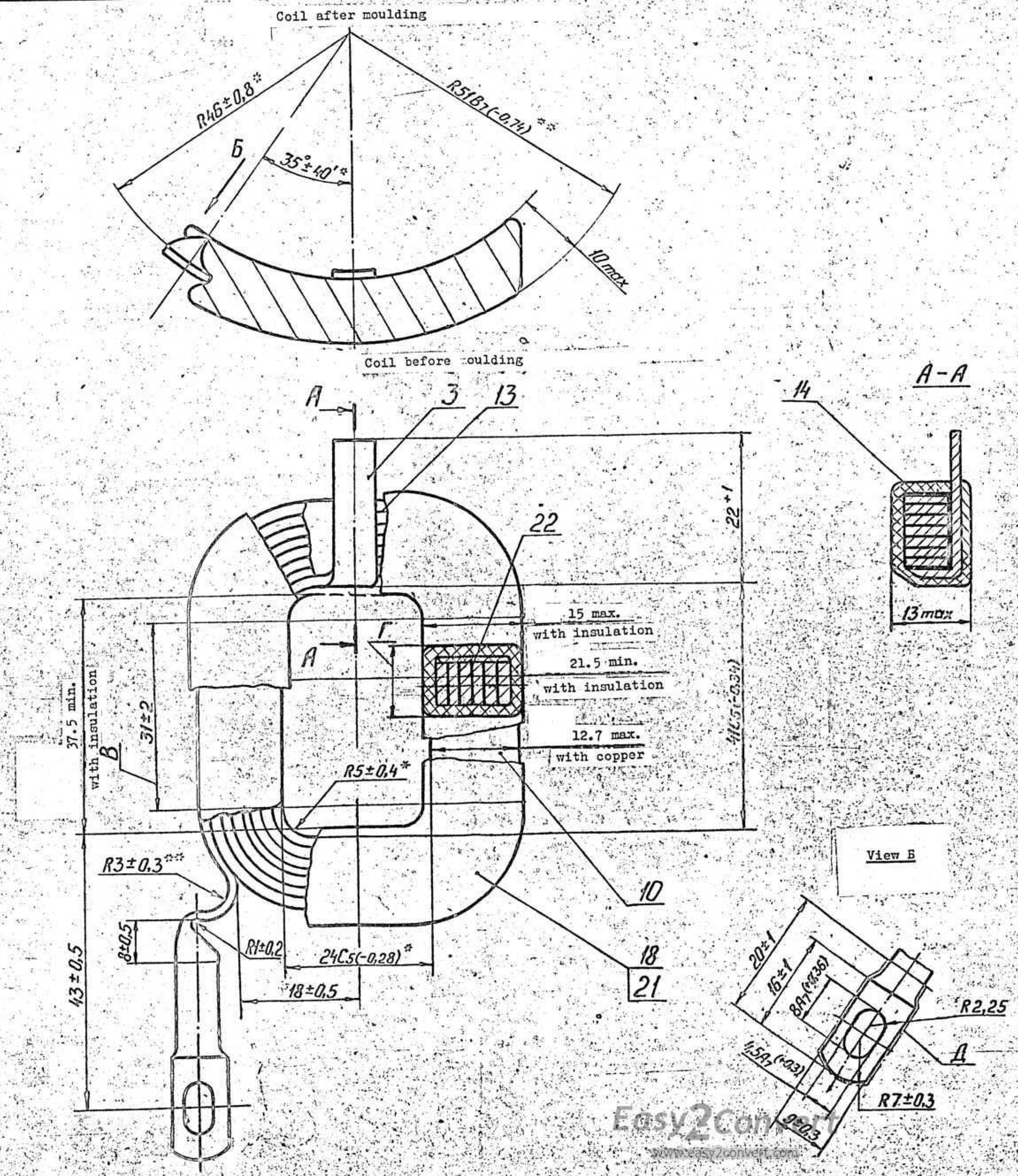
A-A



TECHNICAL CONDITIONS

(7) 1. *Size for gauge.
2. **The size is provided by means of appropriate tools.
3. Number of turns is 6.5.
4. Put electrical insulating board, Ref. No. 12, between the turns.
5. Coating of surface Б, .03.
6. The coil has half-lapped insulation with varnished cloth, Ref. No. 17. Then, it is insulated with cambric tape, Ref. No. 20. Seven or eight layers of insulation are allowed at some places.
7. Insulate the coil finish with hole separately. Start insulating from flatenned finish to the center of large side of the coil.
8. No turn-to-turn short circuit is allowed in the coil.
9. All sizes for insulation after impregnation.
10. Upon insulating and impregnating, the coil should have thickness Г at length B.
To ensure the above-mentioned size, it is allowed to put board, Ref. No. 21, or underwind cambric tape, Ref. No. 20.

APPROVED		ЭД25-110СБ	
CHECKED		SERIES COIL ASSEMBLY DRAWING	WEIGHT 0-11 · SCALE 2:1 · SHT · SHTS 1
CONTROLLERATE OF INSPECTION (I C V)			



TECHNICAL CONDITIONS

1. *Size for gauge.
2. **The size is provided by means of appropriate tools.
3. Number of turns is 6.5.
4. Put board, Ref. No. 13, between the turns.
5. Coating of surface Д, 0.3.
6. The coil is half-lapped with varnished cloth, Ref. No. 18, then, it is insulated with cambric tape, Ref. No. 21. Seven or eight layers of insulation are allowed at some places.
7. Insulate the coil finish with hole separately. Start insulating from flattened finish to the center of large side of the coil.
8. No turn-to-turn short-circuit is allowed in the coil.
9. All sizes for insulation after impregnation.
10. Upon insulating and impregnating, the coil should have thickness Г at length B.
    To ensure the above-mentioned size, it is allowed to put board, Ref. No. 22, or underwind cambric tape, Ref. No. 21.

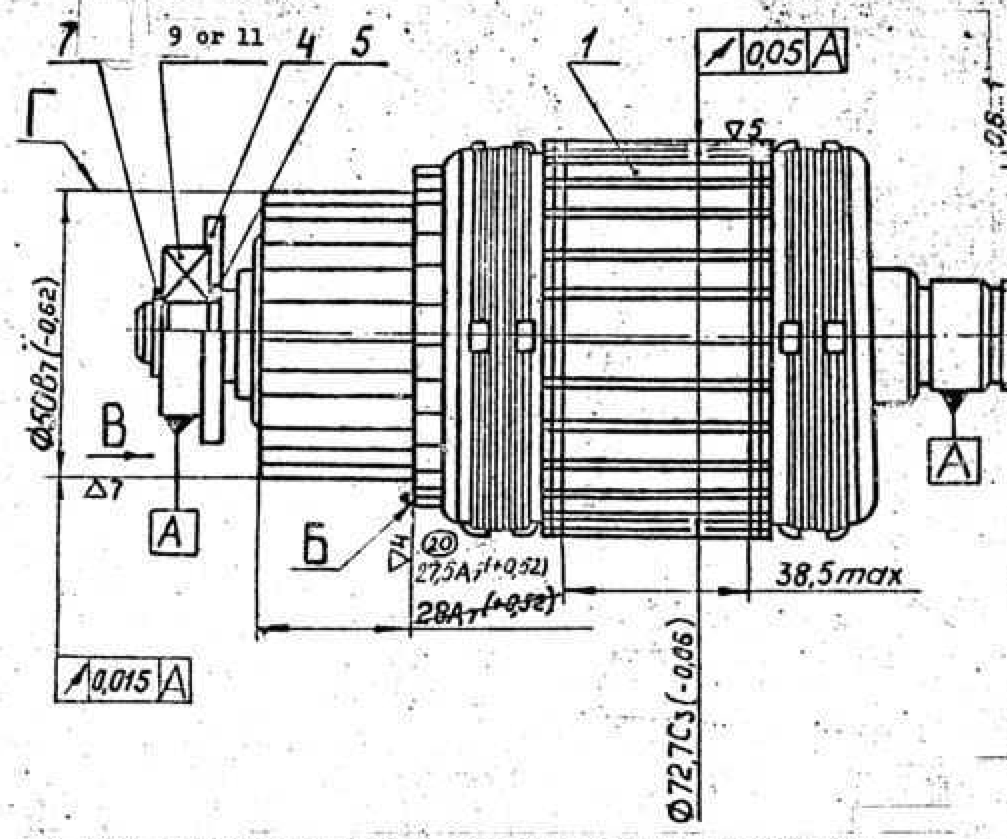
Восстановлен с подлинника

Справ. №	Перв. примен.
–	ЭД25.140СБ

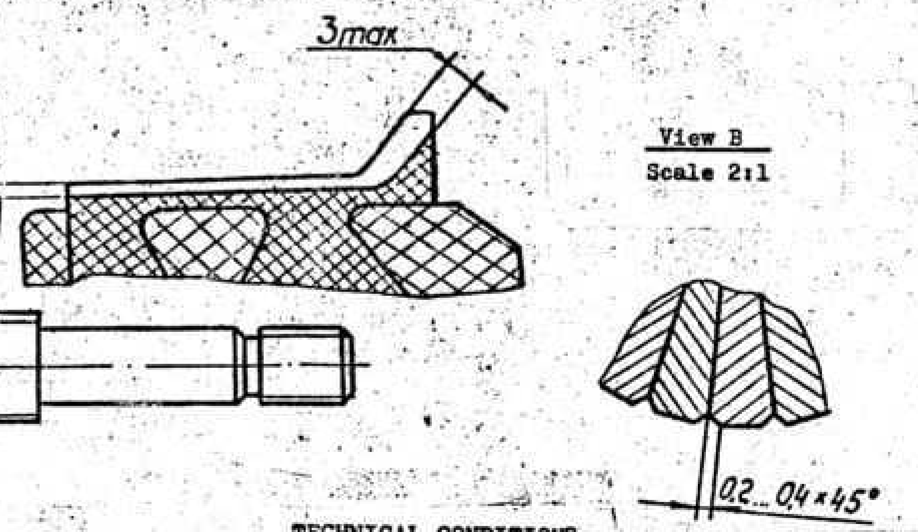
Инв. № подл.	Подп. и дата	Взам. инв. №	Инв. № дубл.	Подп. и дат
3691	(подп.) 17.4.72			

28/D2073

APPROVED	ЭД25·120СБ			
CHECKED		WEIGHT	SCALE	
CONTROLLERATE OF INSPECTION (I C V)	SERIES COIL ASSEMBLY DRAWING	0·11	2:1	
		SHT	SHTS 1	



Sketch for slotting the commutator



TECHNICAL CONDITIONS

1. Balance dynamically by soldering tin 03 ГОСТ 860-75 to the binding with an accuracy of 0.3 gcm. Protrusion of tin above the armature iron diameter is not allowed.
2. Test the armature for racing at n = 14,000 r/min for two minutes in a hot state. (Reheat temperature is 150±5 °C, holding time is 1 h). Protrusion of some bars of the commutator should not exceed 0.003 mm.
3. Slot the segment-to-segment insulation along the commutator length in compliance with the sketch. Upon slotting, the groove width should be 0.8 to 1.2 mm. The segment-to-segment insulation may be slotted at a length of at least 25 mm.
4. Machine the commutator using the diamond tool.
5. Use of emery paper for polishing is not allowed.
7. When machining surface Г, undercut of 3 mm, maximum, to plane Б is allowed.
8. Upon polishing, apply grey enamel ГФ-92ХС ГОСТ 9151-75 to the armature iron, commutator face and face parts.
9. Set washer, Ref. No. 4, upon setting washer, Ref. No. 5.
10. Test the armature for breakdown at an AC test voltage of 550 V for 1 second.
11. In cool state, the insulation resistance is at least 50 megohms.

APPROVED		3Д25·180 СБ		
CHECKED		ARMATURE ASSEMBLY DRAWING	WEIGHT	SCALE 1:1
			SHT	SHTS. 1

37/D2-73

ЭЯ25·180СБ

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

1) TIN GRADE 03 (GOST 860-75) CHEMICAL COMPOSITION:-

MAIN ELEMENT	IMPURITIES NOT MORE THAN %							
TIN (MIN) %	ARSENIC	IRON	COPPER	LEAD	BISMUTH	ANTIMONY	SULPHER	TOTAL DETERMINABLE IMPURITIES
98-49	0·03	0·02	0·10	1·0	0·06	0·3	0·02	1·51

2) COATING
UPON POLISHING APPLY ENAMEL DOVE GREY CONFORMING TO IS: 2932-74 (SHADE No 694 OF IS: 5-78).

3) SURFACE FINISH

∇7:- INDICATES SURFACE FINISH OF Ra VALUE 1·25 MICRONS.

∇4:- INDICATES SURFACE FINISH Ra VALUE 10 MICRONS.

∇5 :- INDICATES SURFACE FINISH Ra VALUE 5 MICRONS.

↗ 0·05 A :- RUNOUT OF INDICATED DIMENSIONS TO BE WITHIN 0·05 MM WITH RESPECT TO BASE 'A'

↗ 0·015 A :- RUNOUT OF INDICATED DIMENSIONS TO BE WITHIN 0·015 MM WITH RESPECT TO BASE 'A'

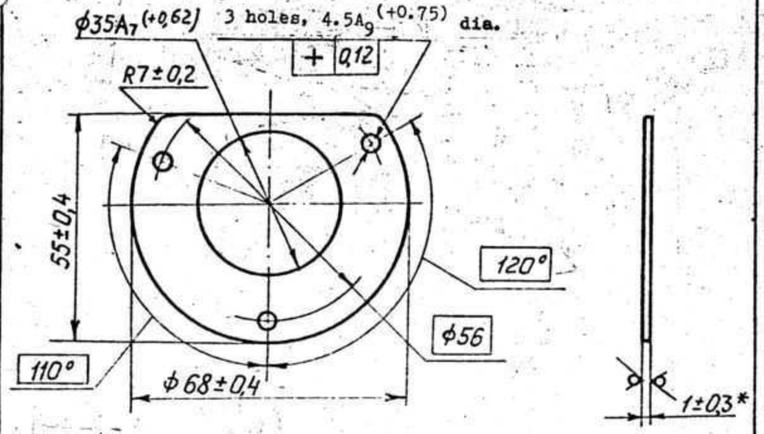
[A] :- INDICATED BASE "A"

PILOT SAMPLE :- THREE SAMPLES SHOULD BE SUBMITTED TO CIFE PUNE FOR HIS TEST AND APPROVAL BEFORE COMMENCEMENT OF BULK SUPPLY

D·CU	D·T	ZONE	BRIEF RECORD	SIGN	INSCRIBED		DRG NOT TO BE SCALED	PERTAINS TO.
					CHECKED		ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	
					APPROVED		ALL DIMENSION ARE IN mm UNLESS OTHERWISE SPECIFIED	
					DATE	17-11-86	ARMATURE ASSEMBLY DRAWING	ЭЯ25·180СБ
					TOLERANCE UNLESS OTHERWISE SPECIFIED GEN. DEC. ANG.		SCALE:	

CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT PUNE

ЭД 25-035



TECHNICAL CONDITIONS

1. Provide for sizes by appropriate tools which are to be checked at least once quarterly.
2. Fissures and scabs are not allowed.
3. Rubber 7-98-1-25 1231 TV005.216-75 may be also used.

65/D2073

APPROVED MVASU	ЭД 25-035		
CHECKED		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (I C V)	GASKET		1:1
		SHT	SHTS 1
	PLATE 254311-1 TY005216-75 RUBBER 4326-1		

ЭД 25-035

EXPLANATORY NOTES TO TECHNICAL CONDITION

① GASKET SHOULD BE MANUFACTURED FROM RUBBER PLATE CODE NO 254311 — ROLLED TECHNICAL PLATE WITH OUT CLOTH LINERS) THICKNESS OF RUBBER PLATE 1 mm, RUBBER GRADE 4326-1 OF TY-005216-75

② PHYSICAL, MECHANICAL AND TECHNOLOGICAL PROPERTIES OF RUBBER GRADE 4326-1 TO TY-0052-16-75 ARE GIVEN BELOW

1) TYPE OF RAW RUBBER	—	CKH-18
2) MODE OF VULCANIZATION AND THERMOSTATING	① TEMP °C —	143 ± 3
	② TIME MINUTES —	20
3) ULTIMATE STRENGTH DURING BREAKAGE kgF/cm² (MINIMUM)	—	80
4) RELATIVE ELONGATION DURING BREAKAGE % (MINIMUM)	—	170
5) RELATIVE RESIDUAL ELONGATION AFTER BREAKAGE (MAXIMUM)	—	12
6) SHORE HARDNESS	—	65 - 80
7) BRITLENESS TEMP WHILE FREEZING °C MINIMUM	—	(MIN) -50
8) HEAT AGEING IN AIR — ① TEMP °C	—	70
② TIME HOUR	—	144
③ AGEING COEFFICIENT AS PER RELATIVE ELONGATION (MINIMUM)	—	0.65

9) CHANGE OF MASS ON EXPOSURE OF — ① 75 PARTS BY WEIGHT - 35 OF RUBBER SOLVENT +25 PARTS BY WEIGHT
MEDIA %, MAXIMUM

10) DENSITY, g/cm³ (WITH LIMIT DERIVATION OF ±0.05 — 1.26

NOTE :-

i) DIMENSIONS GIVEN IN RECTANGLES, ARE THE TOLERANCE ARE NOT MENTIONED BUT THESE ARE NOT A "FREE DIMENSIONS"

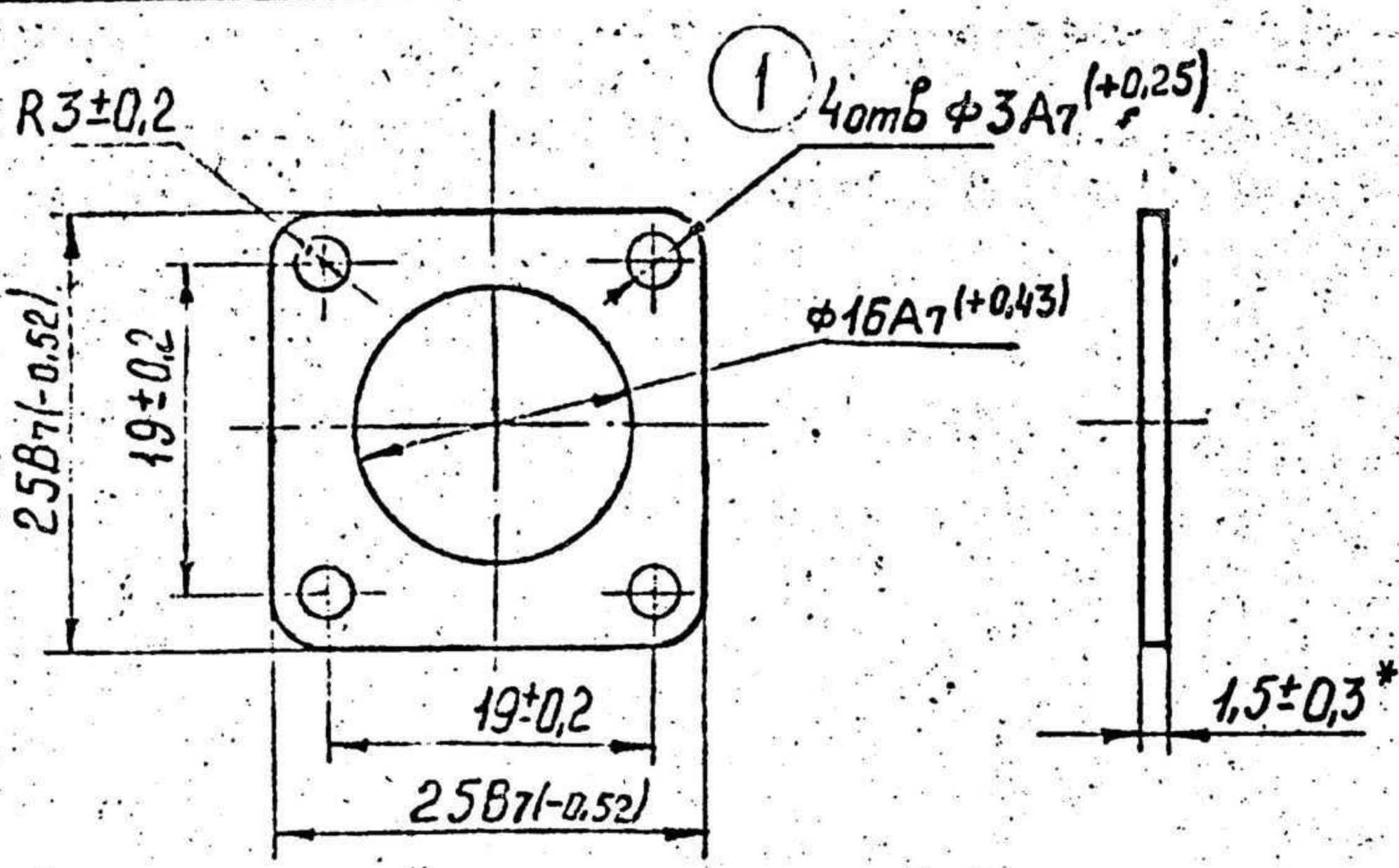
ii) ±0.12 : DISPLACEMENT OF HOLES ON AXES TO BE WITH IN 0.12 mm.

						INSCRIBED		DRG NOT TO BE SCALED
						CHECKED		ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF
						APPROVED		ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPEUFIED
						DATE	17-11-76	GASKET
DCN	D-T	ZONE	BRIEF RECORD		SIGN	TOLERANCE UNLESS OTHERWISE SPECIFIED GEN. DEC. ANG.		SCALE :-

PERTAINS TO ЭД 25-035

CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT PUNE

КРП2.105



TECHNICAL CONDITIONS

1. *Size for reference: other sizes are provided by appropriate tools.
3. Other technical requirements as per ТУ005.216-75.

"REFER TO DRG NO 3M 25.035 FOR EXPLANATORY NOTES"

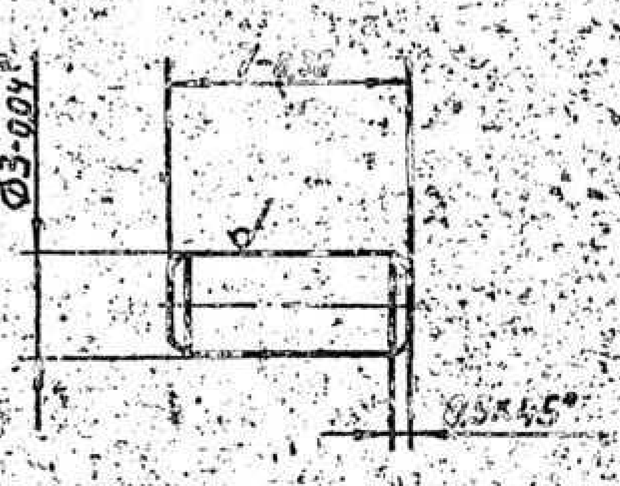
(R. VEERARAGHAVAN)
SSO-II

76/02073

APPROVED	КРП 2·105		
CHECKED		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION FE (I C V) PUNE	GASKET	0·001	2:1
		SHT	SHTS 1
	PLATE 254311-1-5 / RUBBER 4326-I — ТУ005·216-75		1-4-4

M11-40975

Rz80 (√)



Designation	Coating
M11-40975	Zinc plating 6 followed by chromate treatment

1. *Size for reference.

APPROVED	M11-40975	WEIGHT	SCALE
CHECKED	PIN		5:1
CONTROLLERATE OF INSPECTION	WIRE 3-П-10 ГОСТ 5663-79	SHT	SHTS 1

M11-40975

EXPLANATORY NOTES TO TECH· CONDITIONS.

PIN SHOULD BE MANUFACTURED FROM COLD DRAWN WIRE OF DIAMETER 3 MM· WITH INCREASED MANUFACTURING ACCURACY (П) MADE OUT OF GRADE 10 STEEL CONFORMING TO GOST 5663-79

CHEMICAL COMPOSITION

CHEMICAL COMPOSITION OF STEEL GRADE 10 CONFORMING TO GOST 1050-74 (AS REFERED IN GOST 5663-79) IS AS FOLLOWS·

1) CARBON – 0·07 – 0·14 %
2) SILICON – 0·17 – 0·37 %
3) MANGANESE – 0·35 – 0·65 %
4) CHROMIUM – 0·15 % (MAX.)

MECHANICAL PROPERTIES -

MECHANICAL PROPERTIES TO GOST -5663-74 ARE AS FOLLOWS:

1) ULTIMATE TENSILE STRENGTH· – 60 Kgf/mm² (MAX·)
2) RELATIVE CONTRACTION – 55 % (MIN·)

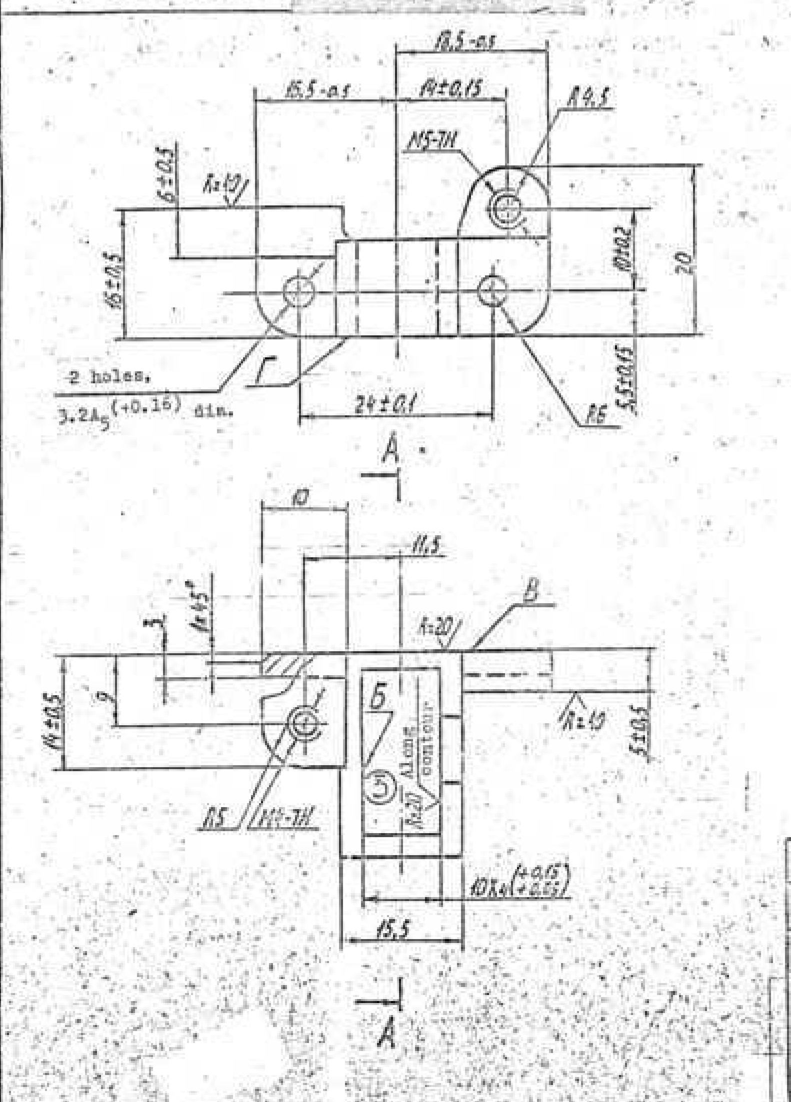
SURFACE ROUGHNESS

Rz 80 (√) = INDICATES SURFACE FINISH VALUE Rz= 80 MICRONS· ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.

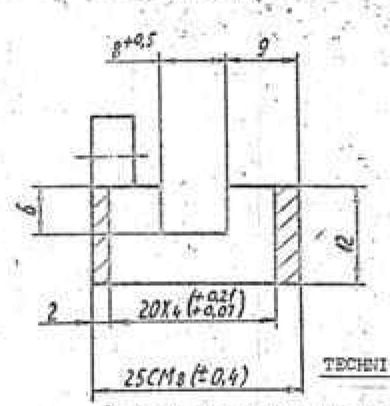
⌀ = INDICATES SURFACE FINISH TO BE OBTAINED BY WITHOUT REMOVAL OF MATERIAL·

INSCRIBED		DRG NOT TO BE SCALED	PERTAINS TO-
CHECKED·		ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.	
APPROVED·		ALL DIMENSIONS ARE IN m·m· UNLESS OTHERWISE SPECIFIED.	
DATE	30.01.86	PIN.	M-11-40975
TOLERANCE UNLESS OTHERWISE SPECIFIED GEN | DEC. | ANG·		SCALE -	
DC(I) DATE ZONE BRIEF RECORD SIGN·		CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT. PUNE	

MB67.035



A-A



TECHNICAL CONDITIONS

1. Material substitute: Casting $\frac{\text{I-OCT3-4227-79}}{\text{АЛ9 КТ5 ГОСТ 2685 75}}$
- Tolerable deviations of sizes are within ±0.25 mm, angular deviations, within ±30' unless otherwise specified.
5. Casting slope gradients are 2 in increasing order of outer sizes and in decreasing order of inner sizes.
6. Casting radii are within 3 mm.
7. Round off sharp edges to R = 0.3 mm.
8. Squareness tolerance of axis of window Б relative to surface is within 0.3 mm.
9. Markings may be omitted.
10. Tolerable sinks left by the pushers on surface Г, should be within 0.5 mm deep.

APPROVED		MB67·035	
CHECKED		BRUSH HOLDER	WEIGHT / SCALE
		CASTING $\frac{\text{I-OCT5-4227-79}}{\text{АЛ2 Д ГОСТ 2685-75}}$	SHT / SHTS

MB67·035

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

BRUSH HOLDER SHOULD BE MANUFACTURED FROM ALUMINIUM PRESSURE DIE CASTING ALLOYS OF GRADES AL2 OR AL9 OF GOST 2685-75. THE METHOD OF CASTING FOR AL2 IS PRESSURE DIE CASTINGS (Д) AND FOR AL9 CHILL MOULD CASTING (K)

CHEMICAL COMPOSITION

GRADE OF ALLOYS	BASIC COMPONENTS %				ADMIXTURE % (MAX)												
	ALUMINIUM	MAGNESIUM	SILICON	MANGANESE	IRON K	IRON Д	MAGNESIUM	MANGANESE	COPPER	ZINC	TIN	LEAD	TITANIUM	BERILIUM	ZIRCONIUM	TOTAL OF CALCULATED ADMIXTURES K	TOTAL OF CALCULATED ADMIXTURES Д
AL2	BASE	-	10·0-13·0	-	-	1·50	0·10	0·50	0·60	0·30	-	-	0·10	-	0·10	-	2·70
AL9	BASE	0·2-0·4	6·0-8·0	-	1·00	-	-	0·50	0·20	0·30	0·01	0·05	-	0·10	0·15	1·50	-

II) MECHANICAL PROPERTIES OF GRADE AL2 Д AND GRADE AL9 KT5 IS AS GIVEN BELOW.

GROUP OF ALLOYS	GRADE OF ALLOYS	PARTIAL RESISTANCE kg/mm²	SPECIFIC ELONGATION %	HARDNESS AS PER BRINELL HB
		NOT LESS THAN		
I	AL2 Д	16	1	50
I	AL9 K	21	2	60

T5 HARDENING AND SHORT TIME (INCOMPLETE) ARTIFICIAL AGEING.

SURFACE FINISH

Rz 80/(√) :- REPRESENTS THE SURFACE FINISH OF Rz VALUE 80 MICRONS ON THOSE SURFACES BY ANY PRODUCTION METHOD WHERE THE SURFACE FINISH IS NOT SPECIFIED

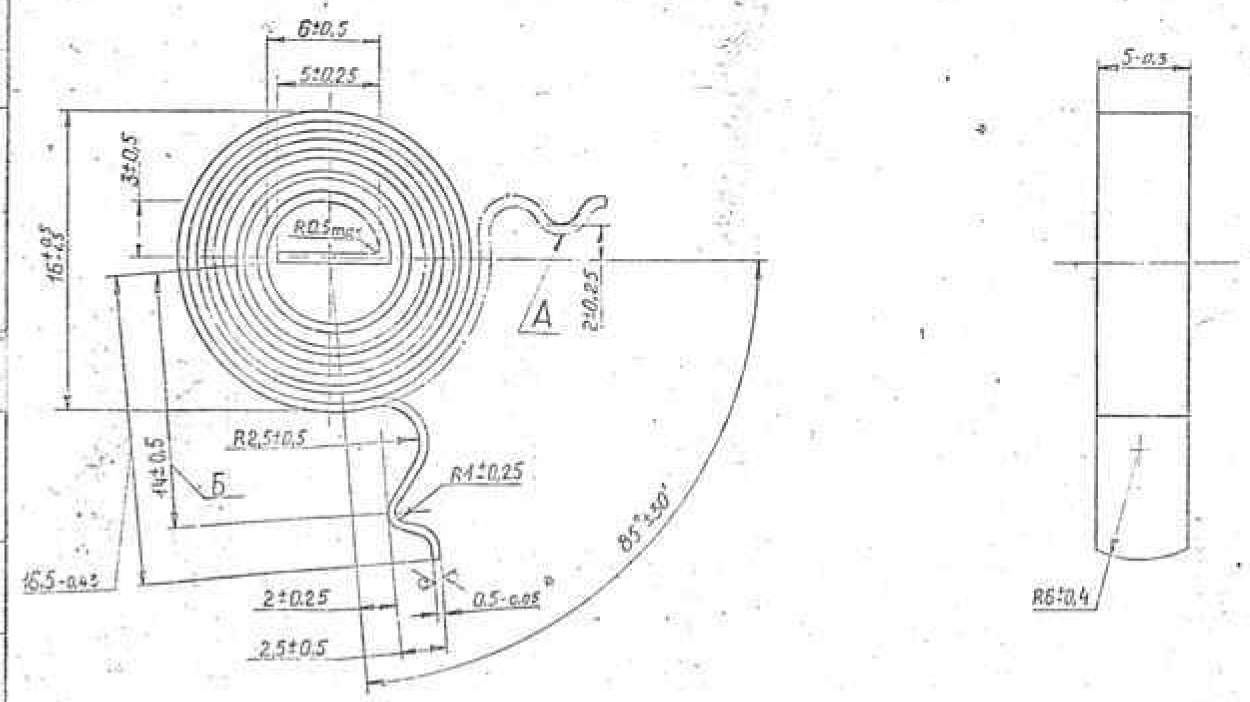
Rz 40/ :- REPRESENTS THE SURFACE FINISH OF Rz VALUE OF 40 MICRONS

Rz 20/ :- REPRESENTS THE SURFACE FINISH OF Rz VALUE OF 20 MICRONS

INSCRIBED		DRG NOT TO BE SCALED	PERTAINS TO	
CHECKED		ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF		
APPROVED		ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE SPECIFIED		
DATE	17-11-81	BRUSH HOLDER	MB67·035	
TOLERANCE UNLESS OTHERWISE SPECIFIED GEN ± DEC ± ANG		SCALE		
		CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT PUNE		

DCN | D-T | ZONE | BRIEF RECORD | SIGN

MB67-110



1. HRA 72 to 75.
2. Dimensions given with symbol (*) is given for reference.
3. Number of working turns 5.
4. Increase in the width of spring upto 6mm due to face projection of [illegible] as well as deviation from the face [illegible] over dimension Б are allowed.
5. Torque [illegible] changed depending on heat treatment [illegible] material during the coiling of springs.
6. Touching of [illegible] after heat treatment is not [illegible]
7. Pressure of spring [illegible] at point 'A' should be [illegible]
8. Coating [illegible] varnish ГФ-95, GOST 8018-[illegible]

SN. SHT	DOC. NO	SIGN	DATE
DRAWN			
EDT. CHKD			
F/M, DC			
DIV. OFFR			
	NAME	SIGN	DATE

MB67-110

SPRING

Band Y8A-[illegible]
GOST 2283-[illegible]

SHEET	WEIGHT	SCALE
	3.72	[illegible]

TOTAL SHEET

MB 67-110

EXPLANATORY NOTES TO TECH. CONDITIONS.

SPRING SHOULD BE MANUFACTURED FROM COLD-DRAWN SPRING STEEL BAND WITH RESPECT TO THE SURFACE INTO LIGHT- IN DARK (C) WITH THICKNESS 0.5 MM OF GRADE Y8A AS PER GOST 2283-69

CHEMICAL COMPOSITION AS PER GOST 1435-74 (AS REFFERED IN GOST 2283-69)

1) CARBON % — 0.75 - 0.84
2) MANGNESE % — 0.15 - 0.30
3) SILICON % — 0.15 - 0.38
4) SULPHOR % — 0.020 MAX.
5) PHOSPHORUS % — 0.030 MAX.

MECHANICAL PROPERTIES AS PER GOST 2283-69

1) ULTIMATE TENSILE STRENGTH Kgf/mm^2 — 76 TO 120
2) THE TOTAL DEPTH OF SINGLE-SIDE DECARBONISING OF THE SHEET MUST NOT EXCED — 0.02 m.m.

COATING ÷ PHYSICO - CHEMICAL AND ELECTRICAL PROPERTIES OF THE VARNISH ГФ-95 (ELECTRO-INSULATING, IMPREGNATING) OF GOST-8018-70 ARE GIVEN BELOW.

PROPERTIES	NORMS
1 PRESENCE OF MECHANICAL INCLUSIONS IN VARNISH	NIL
2 APPEARANCE OF VARNISH FILM	AFTER DRYING THE VARNISH SHOULD FORM A GLOSSY, HOMOGENEOUS AND SMOOTH FILM
3 VISCOSITY BY VISCOMETER B3-4 AT 20°C, IN SECS.	30 → 50
4 DRY RESIDUE CONTENT IN % NOT LESS THAN	45
5 ACID NUMBER IN Mg OF KOH, NOT EXCEEDING	12
6 DRYING TIME AT 105 - 110°C IN HOURS NOT EXCEEDING.	2
7 THERMOELASTICITY OF FILM AT 150°C IN HOURS NOT LESS THAN	48
8 HARDNESS OF FILM BY PENDULUM TESTER AT 20±2°C NOT LESS THAN	0.40
9 OIL RESISTANCE OF FILM IN Kg NOT LESS THAN	6
10 ELECTRICAL STRENGTH OF FILM IN kv/mm NOT LESS THAN	
AT 20 ± 2°C	70
AT 120 ± 2°C	40
AFTER ACTION OF WATER FOR 24 HRS. AT 20 ± 2°C	20
11 VOLUME RESISTIVITY OF FILM IN OHM CM NOT LESS THAN	
AT 20 ± 2°C	$1 \cdot 10^{14}$
AFTER ACTION OF WATER FOR 24 hrs. AT 20 ± 2°C	$1 \cdot 10^{12}$

SURFACE FINISH

1) ◊||◊ SPECIFIED ROUGHNESS TO BE OBTAINED BY WITHOUT REMOVAL AT MATERIAL ON BOTH SIDE OF THE JOB

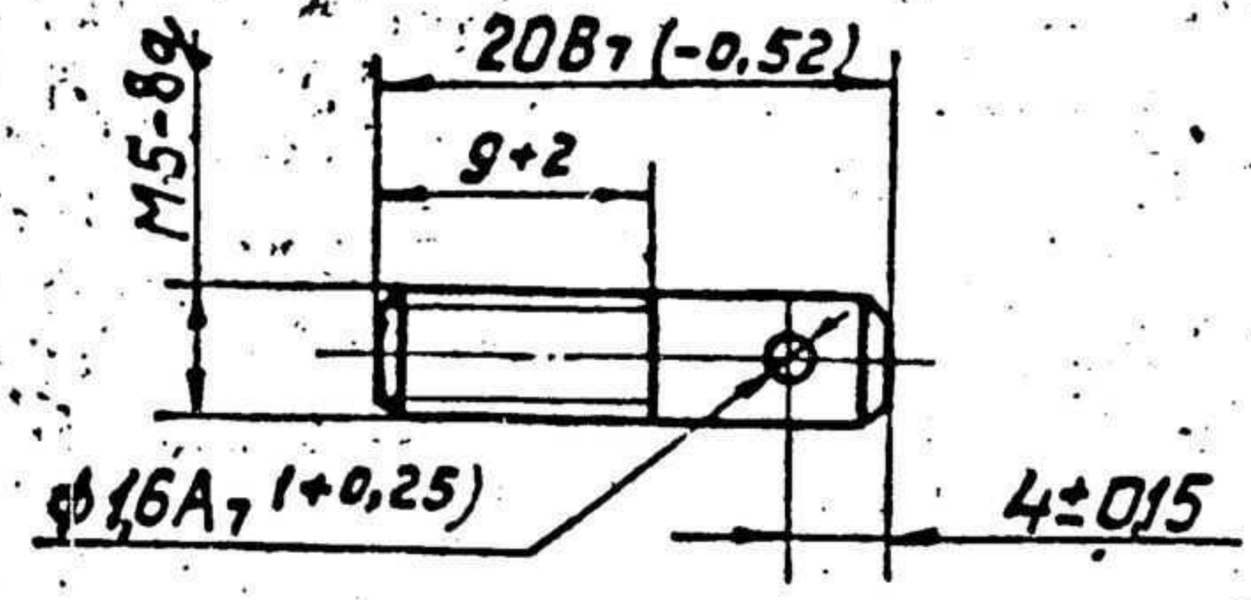
2) Rz80 (✓) REPRESENTS SURFACE FINISH VALUE Rz 80 MICRONS. ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.

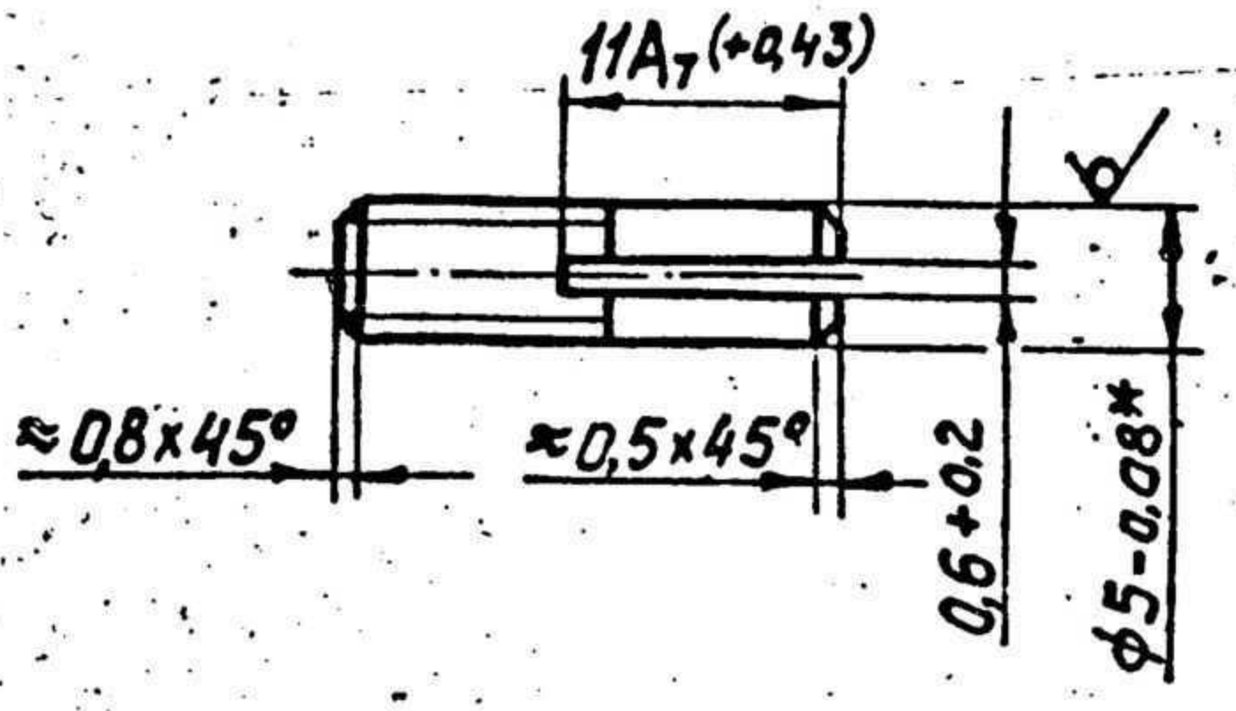
INSCRIBED		DRG NOT TO BE SCALED	PERTAINS TO
CHECKED		ALL SHARP EDGE & CORNERS TO BE ROUNDED OFF	
APPROVED		ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE SPECIFIED	MB67 - 110
DATE	13.11.87	SPRING	
TOLERANCE UNLESS OTHERWISE SPECIFIED		SCALE-	
GEN | DEC | ANG		CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT PUNE	

D-C(I)	O-T	ZONE	BRIEF RECORD	SIGN

MB67-111

Rz40 √ (√)





Designation	Coating
MB67-111	Zinc plating 6 followed by chromate treatment

TECHNICAL CONDITIONS

1. Size for reference.
2. The slot displacement relative to the axis should be within 0.4 mm.
3. Round off sharp edges: chamfer ≈0.3 mm x 45° or radius ≈ ≈0.3 mm.

"REFER TO DRG NO ЭА25.038 FOR EXPLANATORY NOTES"

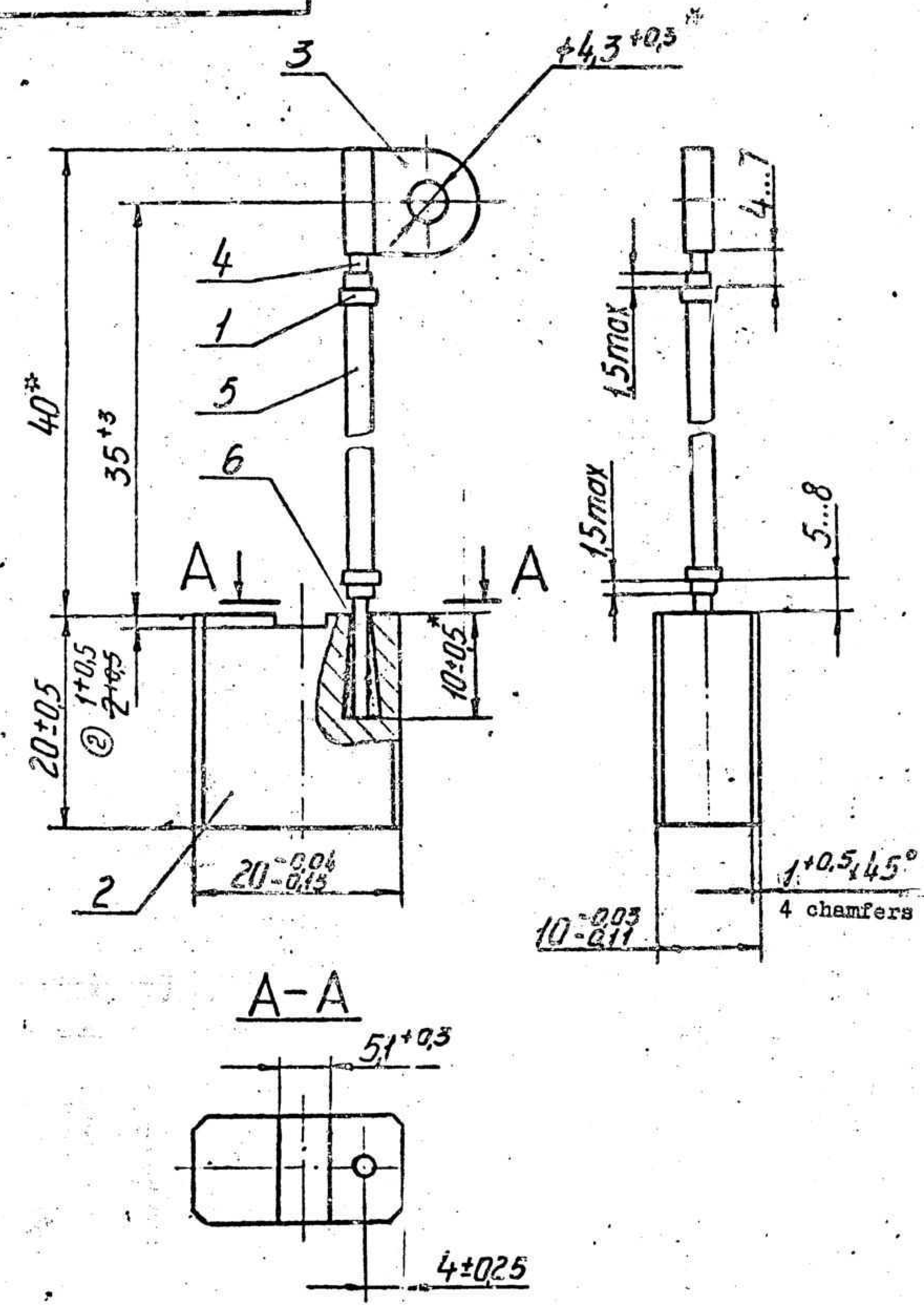
(R. VEERARAGHAVAN)
SSO-II

78/D2073

APPROVED	MB67-111		
CHECKED.		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION PUNE	SHAFT	3.18	2:1
		SHT	SHTS. 1
	ROUND BAR 5-4 IOCT7417-75 / A-12-H B IOCT1414-75		1-4-4

Инв. № дубл. | Подпись и дата | Инв. № подл. 7853

МВ67.140 СБ



TECHNICAL CONDITIONS

1. *Sizes for reference.
2. Attach the wire to the brush by caulking.
3. The electric contact resistance between the brush and the wire should not exceed 2.5 megohms.
4. The force to be applied to break the wire away is at least 7 kgf.
5. Solder end piece, Ref. No. 3, with solder ПОС-40 ГОСТ 21930-76.
6. Mark at any side.

REFER NOTE NO 5

SOLDER END PIECE WITH SOLDER GRADE Sn 40 To IS: 193-82

PILOT SAMPLE

THREE SAMPLES SHALL BE SUBMITTED TO CIFE, PUNE FOR THEIR TEST AND APPROVAL BEFORE COMMENCEMENT OF BULK SUPPLY.

(R. VEERA RAGHAVAN)
SSO-II

46/D2079

APPROVED M V ABU	MB 67. 140 СБ			
CHECKED	BRUSH ASSEMBLY DRAWING		WEIGHT	SCAL
CONTROLLERATE OF INSPECTION (I C V)			11.1g	2:1
		SHT -	SHTS 1	