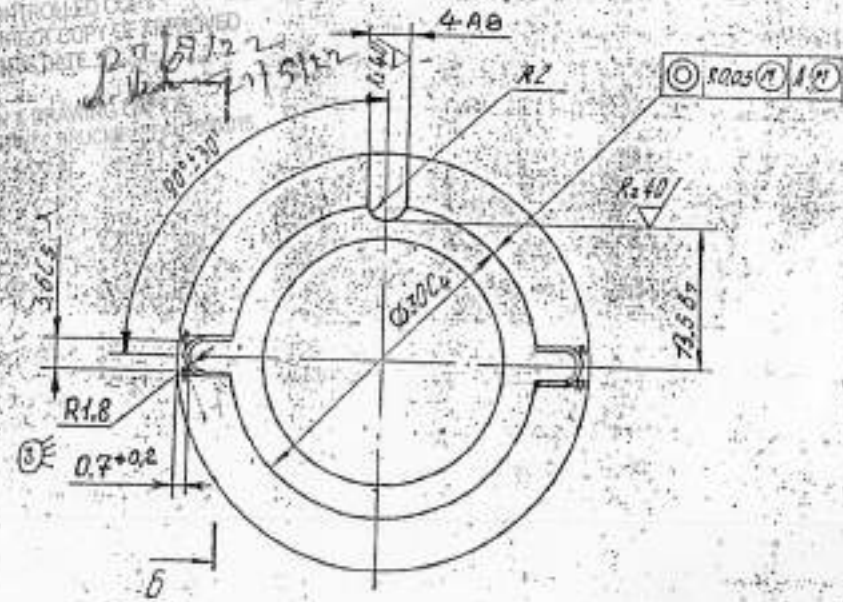
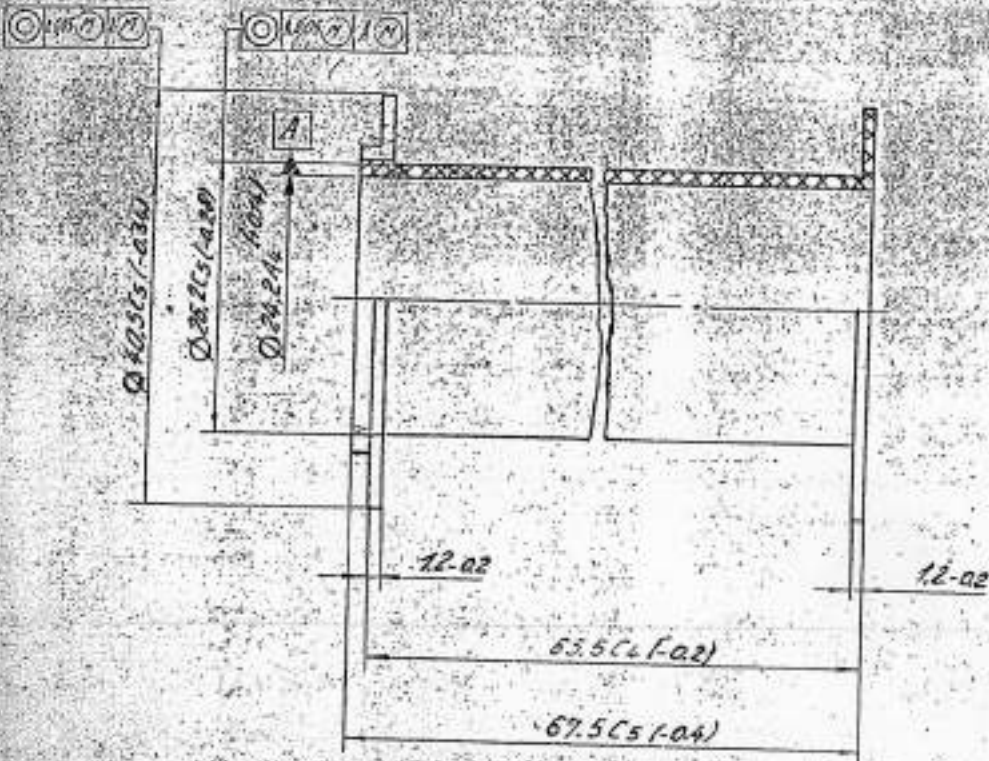


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DATE

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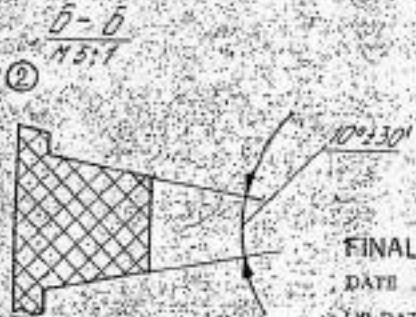


COIL FRAME
moulding material

Scale 2:1. Material: ECB-2-P-2M-0merik-0, FOOT 17478-72.

Mass: 0.115 moulding material

- (1) 1. Material substitute: ECB-2-P-2M-0merik-0, FOOT 17478-72
2. Inner corners R=0.4 mm
3. Blunt sharp edges to R=0.2 mm
4. Stamp K on the lot tag
5. Refer to OCT 4 FO.005.051 for the rest of technical requirements
- (2) Scale 5:1



FINAL DRG. FOR MFR. AT OFT
DATE 09-07-91

UP-DATED *[Signature]*
 CHECKED *[Signature]*
 F/M-PROJ *[Signature]*
 S.C.T. COPY VERIFIED: *[Signature]* Nos. 01
 DGM / PROJ *[Signature]* 26/8/91

4	986T-87	Aluminum
3	933T-86	Aluminum

2A42.06.001

Коркаса КОИЛ
КОМУШКИ FRAME

Авт.	Масштаб	Колумба
0	0.115	2:1
А.С.С.	А.С.С. 1	

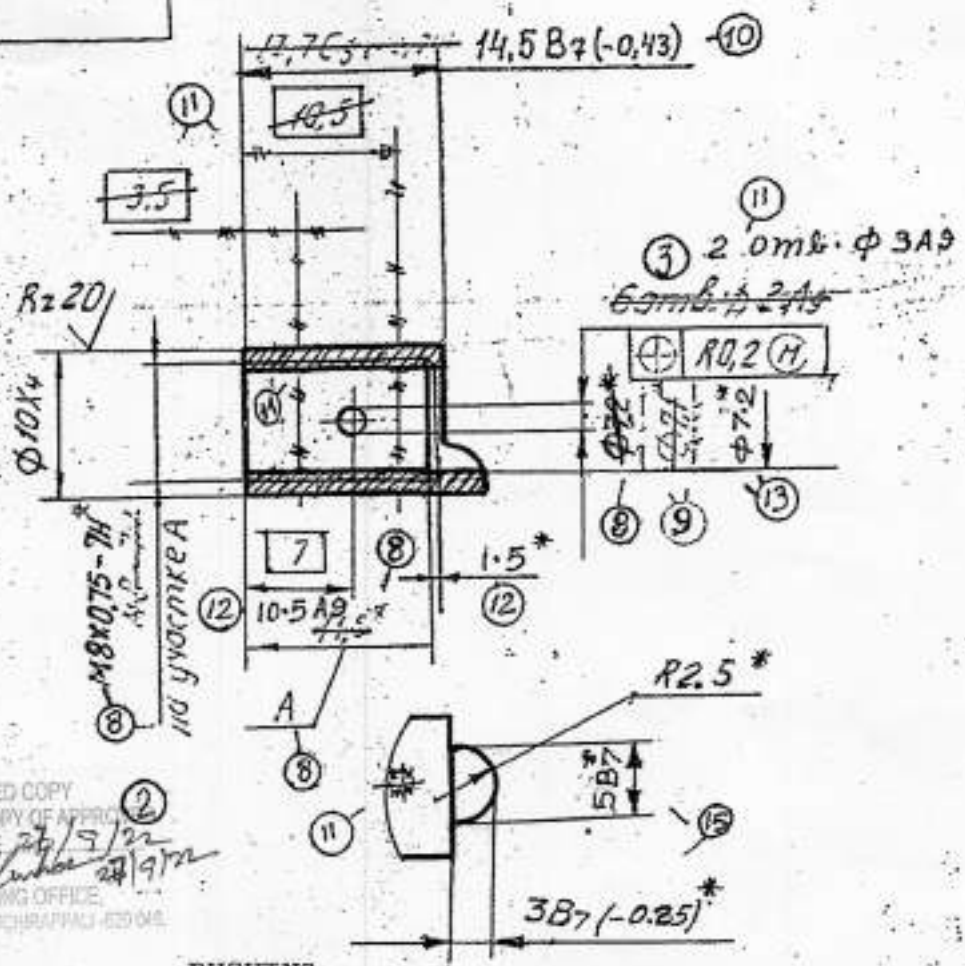
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41-367-84.5707-28714
 41343 570711 2018 18394

2A42.06.002

Rz 40 ✓

2A42.06.002



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 REGION & DRAWING OFFICE
 TRAVEL FACTORY TRUCHRAPPAJ-620048

BUSHING

- Scale 2:1. Material: steel 30XPA, OCT 3-98-80. Mass: 3 g
- (1) 1. HRC₃ 43.5 to 51.5. Test hardness on reference sample
 2. *Ensure sizes by tools
 3. Inner corners R=0.4 mm
 4. Blunt sharp edges to R=0.6 mm
 5. Coating: electroless phosphating, accelerated, with chromate treatment/impregnation with glueБФ-4, роСТ 12172-74 one layer
 6. Stamp K and M on the lot tag

(2) OVER SECTION, A
 (3) 2 HOLES

FINAL DRG FOR MFR. AT OFI

DATE 09-07-91

2A42

DATE 09-07-91
 CHECKED *Chuly*
 M-PROJ
 COPY VERIFIED: *140829*
 DGM / PROJ: *26/8/91*

2A42.06.002

BUSHING
ВТУЛКА

№	Масса	Кол-во
3		2:1

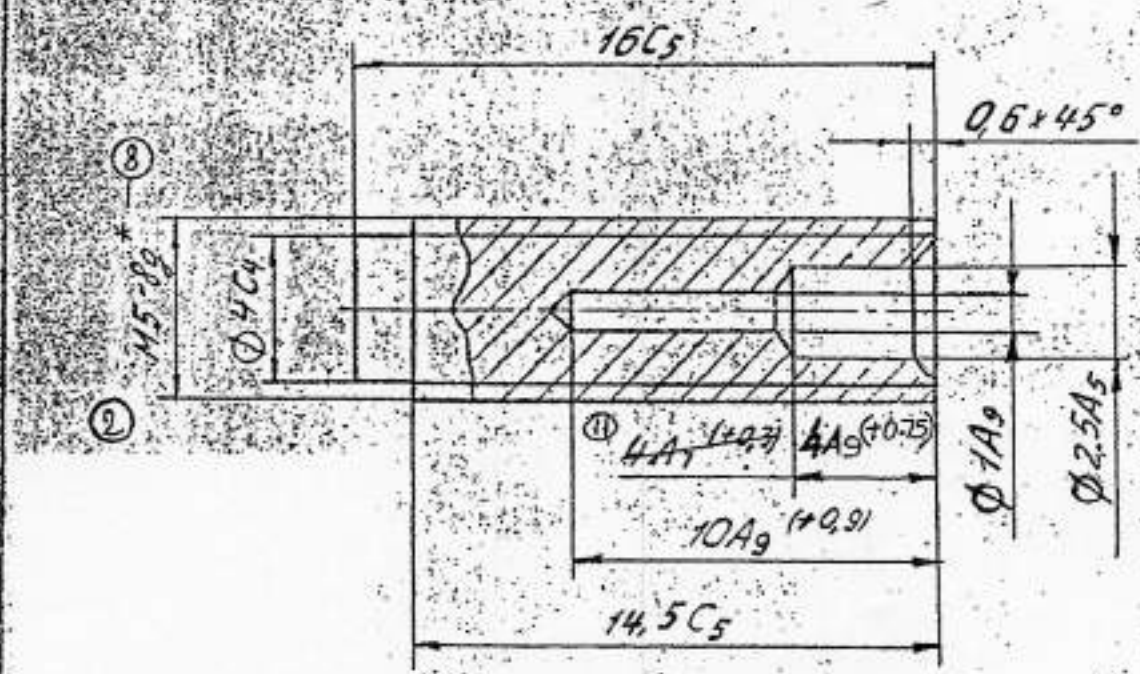
Итого: Итого: 1

15	112BT-86	SCT	11-04-91
13	732T-85	SCT	060182
12	711T-85	SCT	060183
11	648T-85	SCT	060183
10	552T-84	SCT	180859

Сталь 30XPA
OCT3-98-80

2A42.06.003

Rz 80



РОД
ДКРНП5НД ЛС59-1

Scale 5:1. Material: rod ЛС59 п.т.р. НТН 5, ГОСТ 2060-73.

Mass: 0.003

- (1) 1. Blunt sharp edges to R=0.6 mm
- 2. Inner corners R=0.4 mm
- 3. Stamp K on the lot tag
- 4. Ensure size by tools

(2) 115.89
M5-89

ALT.MATL: BS:2874-86 Design. CZ 115
Ref: Letter No. CQAM/QA-1/30mm, Dt.21 Feb.2012

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DRAWINGS AT THIS DATE 21/9/22
S. V. V. 20/9/22
DESIGN DRAWING OFFICE

Material: Rod ДКРНП5НД ЛС59-1 ГОСТ 2060-73
Материал: Род ДКРНП5НД ЛС59-1 ГОСТ 2060-73

FINAL DRG FOR MFR. AT OFF

2A42

DATE 09-07-91

DATE 09-07-91

CHECKED [Signature]

M-PROJ [Signature]

ST. COPY VERIFIED: [Signature] 10.02.91

DOM/PROJ [Signature]

2A42.06.003

Стержень

Unit	Mass	Scale
шт	0,003	5:1

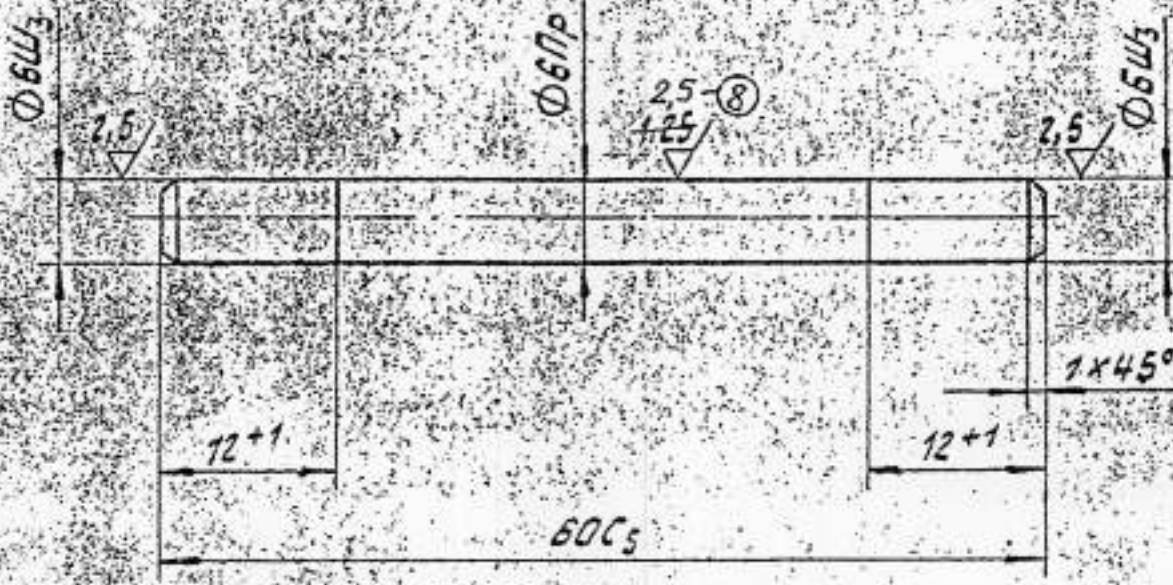
11	11377-89	СЕТ-16.04.91
9	8367-86	СЕТ-28.08.89

Род ДКРНП5НД ЛС59-1 ГОСТ 2060-73

21

2A42.06.004

Rz 40
Rz 250
8



PIN

Scale 2:1. Material: steel 40X ГОСТ 4543-71. Mass: 0.013

- (1) 1. HRC₃ ^{38.5 to 45.5} ~~43.5 to 51.5~~ Test hardness on reference sample
- 2. Blunt sharp edges to R≈0.6 mm
- 3. Coating: cadmium plating (3-μ layer), accelerated phosphating, with chromate treatment F≈0.12 dm²
- 4. Stamp K and M on the lot tag

ALT.MATL: IS:5517-1993, DESIGN, 40Cr4
Ref: Letter No. CQAM/QA-1/30mm, Dt.21 Feb.2012

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DRAWINGS AT THIS DATE 27/9/22
L. Venka 27/9/22
DESIGN & DRAWING OFFICE
OPTIMAX FACTORY TRICHYRAJAPUJ - 620 016.

Material: steel
Материал: сталь 40X ГОСТ 4543-71. (10)

FINAL DRG. FOR MFR. AT OBT

DATE 09-07-91

UP-DATED V. P. [Signature]

CHECKED [Signature]

P/M-PROJ [Signature]

SET-COPY VERIFIED: [Signature] 14.02.91

DGM/PROJ [Signature]

2A42

2A42.06.004

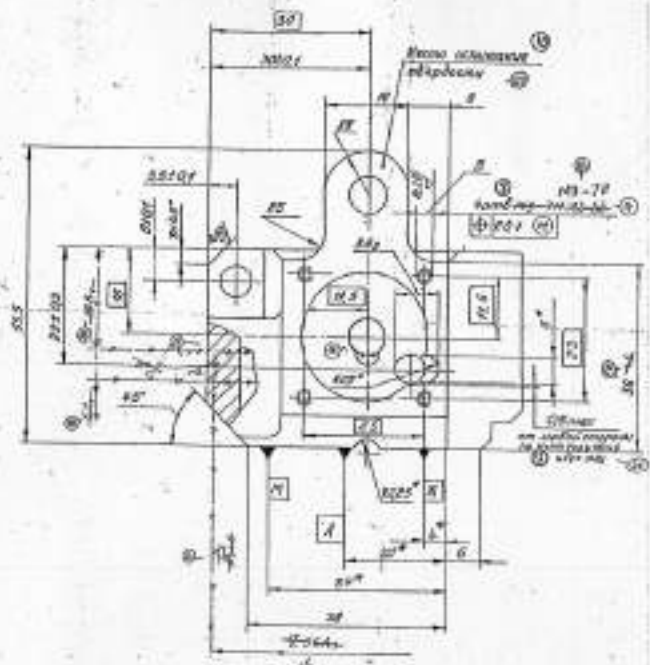
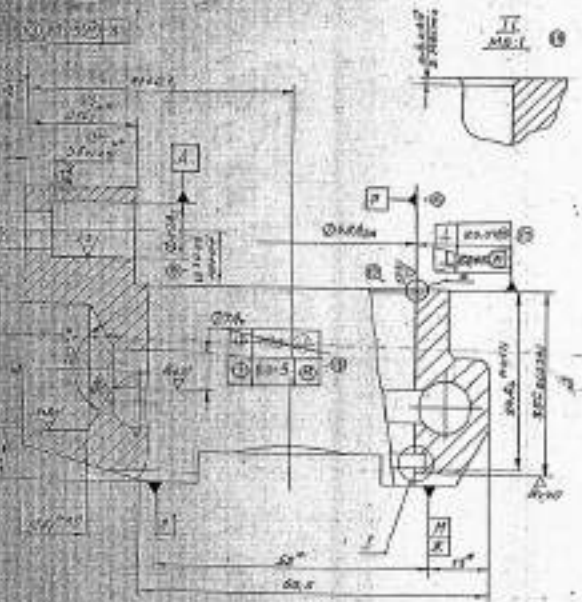
PIN		Масса	Качество
Псб		0,013	2:1
		Масса	Масса 1

~~Спецификация~~ * (10)
~~Список~~ (9)

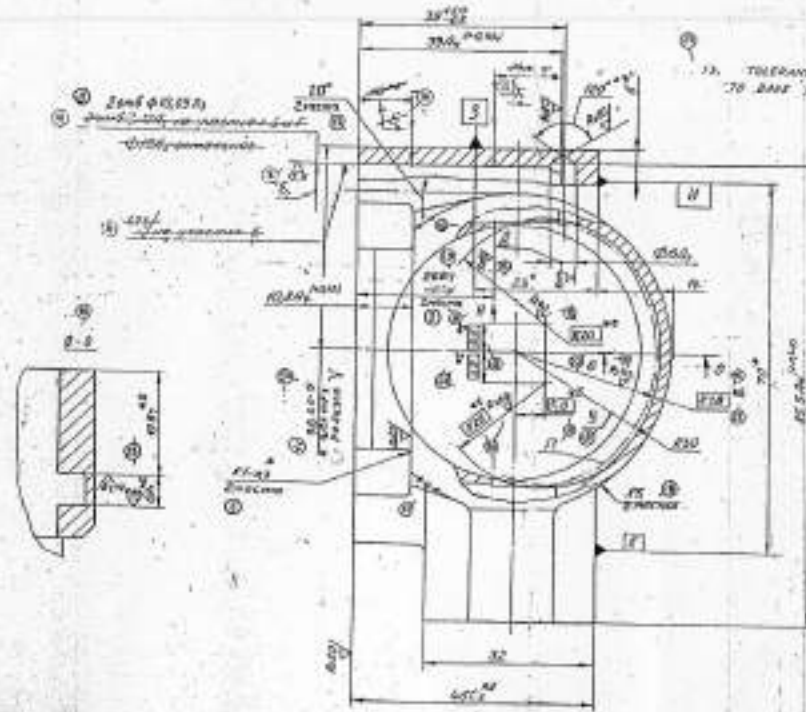
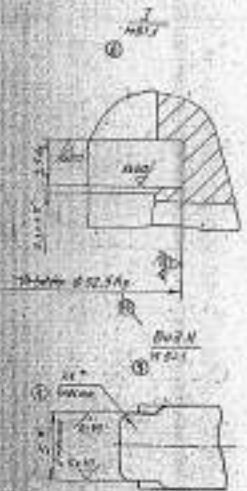
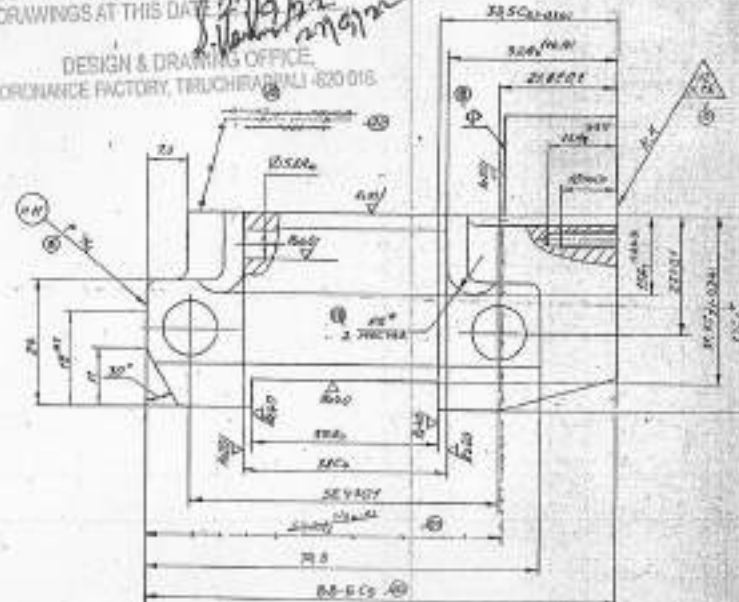
10 222T-84mm SET/040889

Копировать БУДУЩЕ

2022-09-11



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 DRAWINGS AT THIS DATE *27/10/20*
 DESIGN & DRAWING OFFICE,
 ORDNANCE FACTORY, TRICHYVAPULI 620 015



- 13. TOLERANCE CLASS CONTROL 'D' WITH RESPECT TO BASE DIMS & IS 0.25mm.
- 14. When machining surfaces of unhardened steels the surface finish shall be as specified.
- 15. The location of chamfers to be given when the chamfers after heat treatment is permitted.
- 16. The chamfers to be chamfered before heat treatment.

Scale: 1:1, Material: casting, II-0028-450-07, Sheet 2 of 2

- (1) 1. Specified casting grade as per IS 100
- 2. ISO 40.5 to 50.5
- 3. Additionally, compliance check for impact strength in accordance with Section 5, IS 100-100
- 4. Surface finish as per table
- 5. Size point for holes 3, 4, 5
- 6. Size point in relation to hole 3 and 4
- 7. Size point in relation to hole 2, 3, 4, 5, 6
- 8. Inner chamfer as per table
- 9. Heat treatment as per IS 100
- 10. Surface finish as per table
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- 100. Surface finish as per table

FINAL DDD FOR IFR AT DFT
 DATE: 08.12.21
 DRAWN: *[Signature]*
 CHECKED: *[Signature]*
 PROJECT: *[Signature]*
 REV. FOR: *[Signature]*
 REVISED: *[Signature]*

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CONTROL COPY
DIRECTOR OF RESEARCH
DATE 21.09.91
DESIGN
PROCESSED BY 220 011

1. Термообработка вакуумный штифт.
2. Размер обеспеч. инстр.
3. Внутренние углы R=0,4мм.
4. Р-С, ? притупить R=0,5мм.
5. Клейнить к/на бирке к партии.

42,5 C₀₁-0,171

INSERT

Scale 4:1. Material: rod 49K6, TV14-1-1185-75. Mass: 0.134

- (1) 1. Thermal treatment: annealing in vacuum
2. Ensure size by tools
3. Inner corners R=0.4 mm
4. Blunt sharp edges to R=0.6 mm
5. Stamp K on the lot tag
5. STAMP K AND N ON THE LOT TAG

(2) Electro polishing.

AMEND. NO. 57 (2A42-11.01-1-88)

8 934-86

FINAL DRG. FOR MFR. AT OFT

DATE 09-07-91

UP-DATED *V. Ponomarev*

CHECKED *Shubly*

F/M-PROJ *Shubly*

SCY-CORR. VERIFIED *Shubly*

DGM/PROJ *Shubly*

2A42

2A42.06.007

Вставка
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А.м	Масса	Кол-во шт
0,1	0,134	411
Литм	Ам-261	

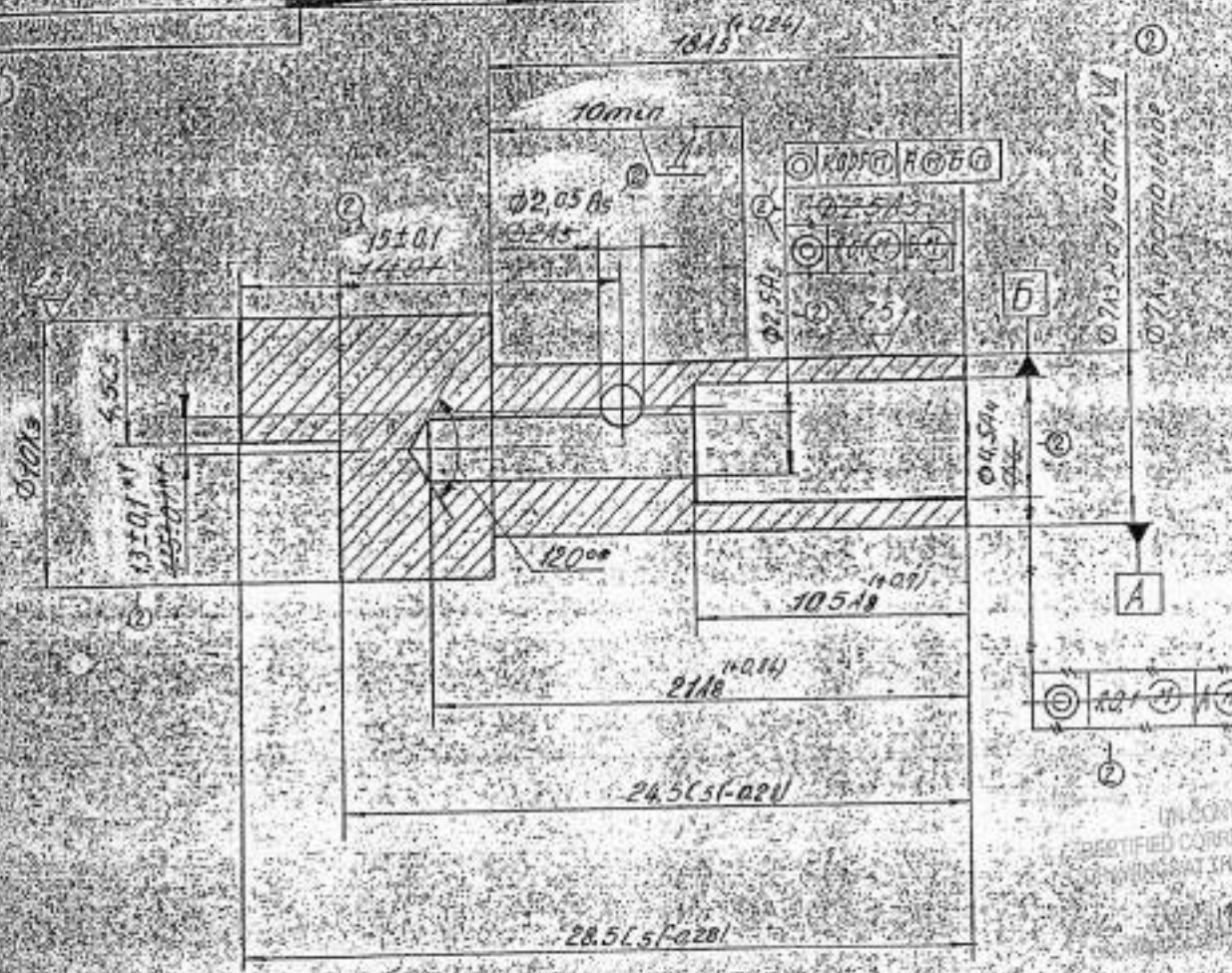
Кр. штифт 49K6
TV14-1-1185-75

GATEWAY

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8200 ✓

2A42.06.06.008



- Клеймить в бакенито — Клеймить в бакенито
1. HRC 43.5 - 51.5 Твердость испытать на образце-свидетеле
 2. Размер обдеслеч. инстр.
 3. Размер задан относительно оси поверхности А.
 4. Ребра притупить R=0.6 мм
 5. Внутренние углы R=0.4 мм
 6. Клеймить К, И на бирке к партии.

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 DRAWING
 22/01/22
 [Signature]
 DRAWING OFFICE
 2001/01/2001-2001/01/2001

FINAL DRG FOR MFR. AT OFF-
 DATE 09-07-91
 UP-DATED [Signature]
 CHECKED [Signature]
 F/M-P.S.
 SCT-COPY VERIFIED: [Signature]
 DGM / PROJ. 026/01

Scale 5:1. Material: steel 25X17H2B-W, TV-1-1062-74. Mass: 8 g
 Harden in vacuum.

- (1) 1. HRC 43.5 to 51.5. Harden in vacuum. Test hardness on reference sample
 2. Ensure size by tools
 3. Size preset in relation to axis of surface A
 4. Blunt sharp edges to R=0.6 mm
 5. Inner corners R=0.4 mm
 6. Stamp K and M on the lot tag
- (2) Ø7X3 on section A
 Ø7X4 unless otherwise specified

Approved 5/1/92 [Signature]
 Approved 5/1/92-12 [Signature]

b	Ø7X3-42 MW	Ø7X3-42 MW
α	Ø7X4-6 MW	Ø7X4-6 MW

2A42.06.06.008 2A42.06.008

PUSHER
ТОЛКАТЕЛЬ

Aut.	Mass	Volume
3	8	5.7
Aut.	Aut.	Aut.

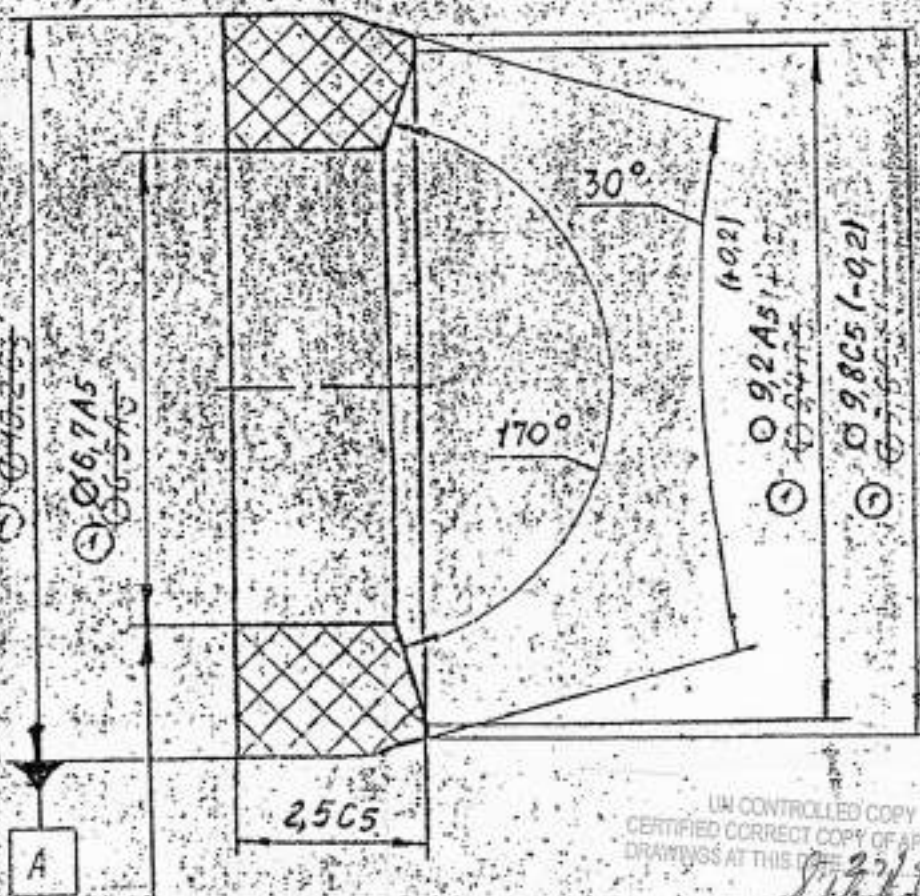
Материал 25X17H2B-W
 TV-1-1062-74

2A42.06.017 2A42.06.009



Склад № 1
2A42.06.060

2



© R0,1 M A M

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DRAWINGS AT THIS DATE 22/9/22
DESIGN & DRAWING
22/9/22

RING

Scale 10:1. Material: rod Ø-4, Ø15, TY 6-05-810-76. Mass: 0.001

(1) Stamp K on the lot tag

ALT-MATERIAL

SOFT IRON I TO MILWAU. SPECIFICATION IS ACCEPTED.
R0,1 M A M / 9/22/22 DR. 17-05-810

2

FINAL DRG. FOR MFR. AT OFT

DATE 09-07-91

APP-DATED

CHECKED

M-PROJ

CT-COPY VERIFIED: 22/9/22

SEM/PROJ

2A42.06.017 2A42.06.009

RING
КОЛЬЦО

Item	Masses	Masses
G	0,00%	10:1

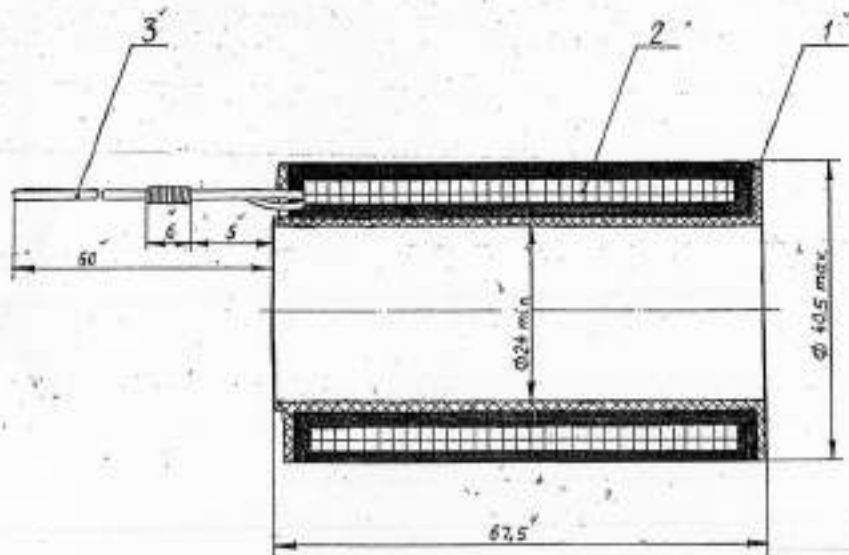
Стержень Ø-4 Ø 15
TY 6-05-810-76



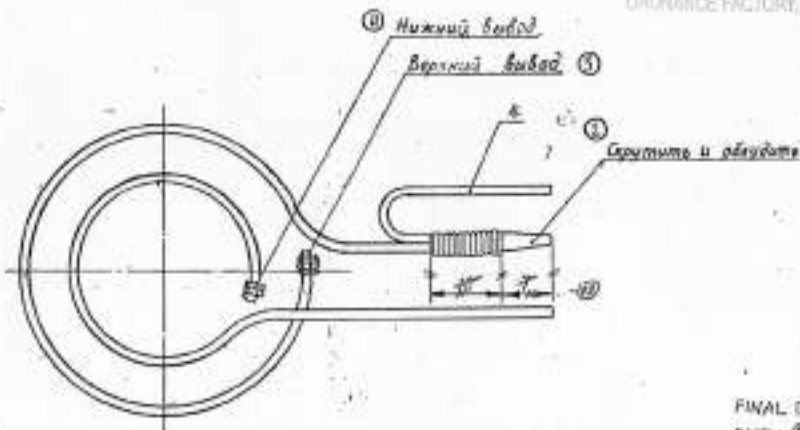
Склад № 1

Склад № 1

2442.06.010CSB



③ Схема раскладки проводов



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DRAWINGS AT THIS DATE

DESIGN & DRAWING OFFICE,
CRONANCE FACTORY, TIRUCHIRAPPALLI-620 018.

ELECTROMAGNET COIL

Assembly Drawing

Scale 2:1. Mass: 0.24

- (1) 1. Wind the coil with wire, Ref. No. 2; turn-to-turn layer winding
2. Number of turns 500 ±30
3. Low-frequency resistance 2.4 ohms ±0.2 ohms
4. Make leadouts of winding of wire, Ref. Nos 3 and 4, according to diagram
5. Separate each layer of winding with insulator paper ECH-1-22, FGCT 1908-82
6. Impregnate winding with varnish MB-92, FGCT 15863-70. Impregnation with varnish MB-98, FGCT 12294-66 is allowed
- ② 7. ~~Remove outside of coil frame, Ref. No. 1, should be free of varnish. Wire, Ref. No. 2, and area of wire, Ref. No. 2, adjoining to the side surfaces of coil frame, Ref. No. 1, may bear drips and spots of varnish as on the reference sample.~~
8. Wrap the impregnated coil with two layers of varnished cloth MB-105-01, FGCT 2214-78, and also over with glue SA-4, FGCT 12122-74. Place paper tag, FGCT 12010-72, under the outer layer of varnished cloth. The tag should indicate the coil number, actual resistance and number of turns, mark and section of wire.
9. It is permissible to cooperate the first layer of winding with capacitor paper MB-1-30
10. Solder with solder SDC-61, FGCT 21931-76, with flux SDC, FGCT 033, MB-00470-028, 200-03
11. Insulate places of soldering with two layers of varnished paper MB-105-0.1
12. Wind wire, Ref. No. 3, over with one layer of min-plate ~~glue extra-strong thread-60, FGCT 6109-80 and coat with glue SA-4, FGCT 12122-74~~
13. Stamp X on the tag
14. Refer to No. 010, 001, item 3.2 for technical requirements to electric wiring

- (2) Twist and tin-plate
- (3) Upper leadout
- (4) Lower leadout
- (5) Soldering diagram

FINAL DWG FOR MFG. & CFT

DATE 9/85
UP DATED BY
CHECKED BY
P.T.H. 3801
SCT KONGA
QCM/PRG

№	WSPT-88	07.04.89
10	2242-88	2000
13	6237-88	2000

2442

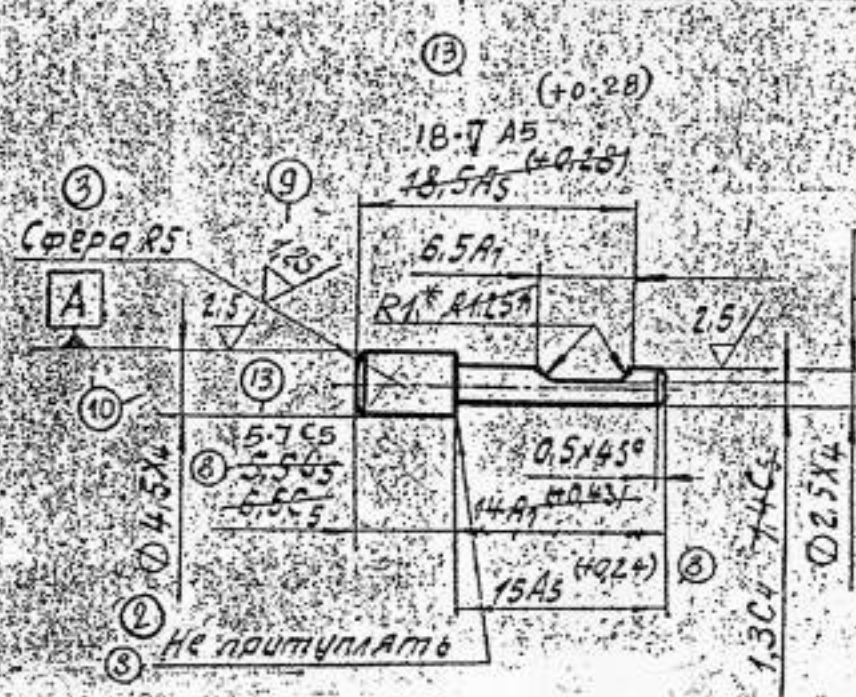
2442.06.010CSB

Катушка
электромагнита
Сборочный чертеж

№	Масса	Материал
-	0,24	2:1
Автом.	Зачисл.	

ADM/LVD

2A42.06.011



RB05 A

PLUNGER

Scale 2:1. Material: steel 25X17H2E-III, TV 14-1-1062-74.

Mass: 0.001

Harden in vacuum. (b)

- (1) 1. HRC₃ 43.5 to 51.5. Harden in vacuum. Test hardness on reference sample
- 2. Inner corners R ≈ 0.4 mm
- 3. Blunt sharp edges to R ≈ 0.6 mm
- 4. * Ensure size by tools
- 5. Coating: anodic with passivation and glazing
- 6. Stamp K and M on the lot tag

7. Center holes are impermissible

- (2) Do not blunt
- (3) Sphere R5

b	21-8	57/2A2-12 KH	010229
14		60TT-84	080100
13		552 1/2 T-84	080100
a		57/2A2-6 KH	020429

FINAL DRG FOR PR. AT OPT

DATE 09-07-91

UP-DATED

CHECKED

F/M-PROJ.

CT-COPY VERIFIED

DGM/PROJ.

2A42.06.011

PLUNGER
Плунжер

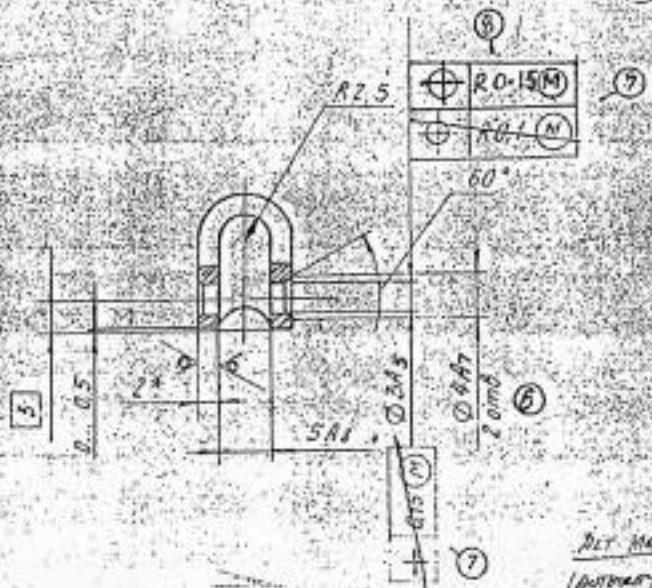
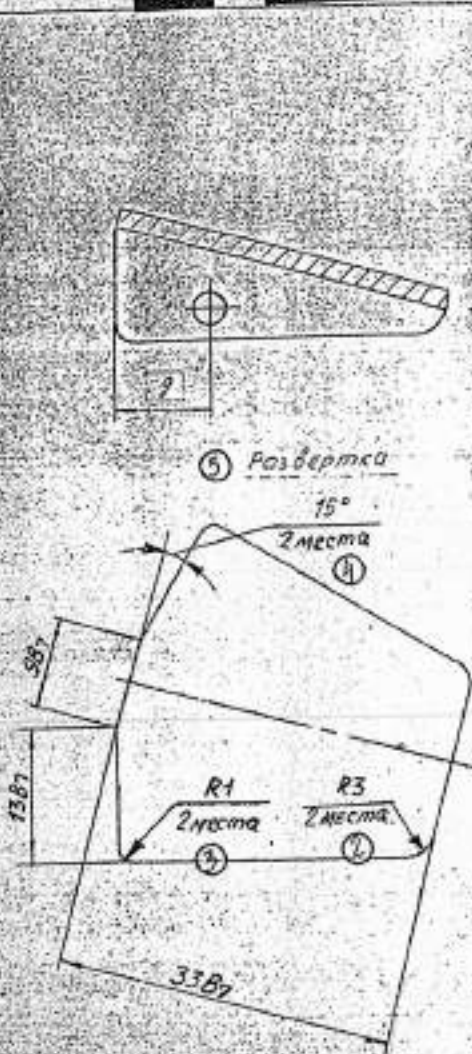
1:1	0.001	2:1
1:1	0.001	2:1

Смаго 25X17H2E-W
TY 14-1-1062-74

21

2A42.06.012

R: 20



5 Развертка

Дет. Металл. Геом. 55-26 АС-100. 15.2507.1975
 (Литература - 50232_560_СДМ(ЛНМ) дт 2/17.3.89)

LEVER
 B-III-O-2 ГОСТ 19904-74, Mass: 0.01
 4-III-50 ГОСТ 16523-70

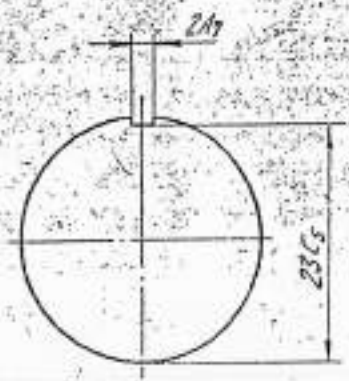
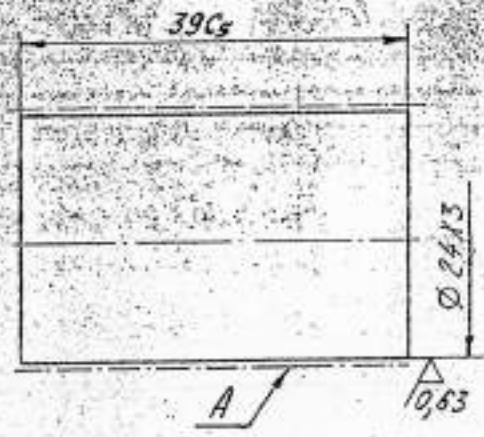
- 1 Scale 2:1. Material: sheet
- (1) 1. HRC₃ 38.5 to 45.5. Test hardness on reference sample
 2. Reference size
 3. Blunt sharp edges to R=0.6 mm
 4. Coating: accelerated phosphating electroless with chromate treatment/impregnation: adhesive EP-4, ГОСТ 12172-74, with nigrosine, mark A, ГОСТ 9307-78, one layer
 5. Stamp K and W on the lot tag
- (2) 2 points (3) 2 points
 (4) 2 points (5) Developed view
 (6) 2 holes

FINAL DRG. FOR MFR.-AT OF
 DATE 09-07-91
 UP-DATED
 CHECKED
 F/M-PROJ
 S C T - COPY VERIFIED
 DGM / PROJ

6077-84	2A42
2A42.06.012	
LEVER P61402	
Масса	0,01
Материал	4-III-50 ГОСТ 16523-70

2A42.06.014

8-20/ (✓)



22/9/22
 22/9/22

ARMATURE

Scale: 1:1. Material: rod 49K0, T9 14-1-1185-75. Mass: 0.13

- (1) 1. Thermal treatment - vacuum annealing
2. Inner corners R=0.4 mm
3. Blunt edges to R=0.6 mm
4. Polish surface A to be electro-polished.
5. Stamp K on the lot tag
6. Center holes are impermissible
5. STAMP K AND M ON THE LOT TAG. AMEND. NO. 57/2A42-11. D1. 1. 8. 88.

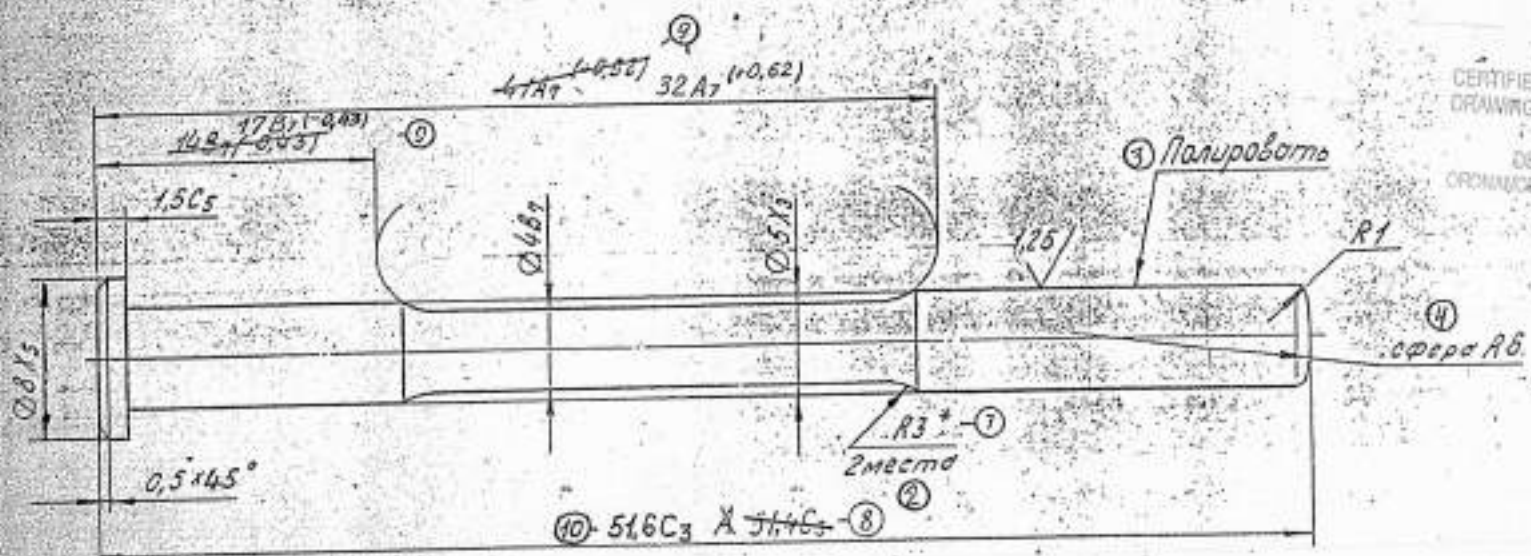
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FINAL DRG. FOR MFR. AT CFT
 DATE 09.07.91
 UP-DATED N. P. [signature]
 CHECKED [signature]
 F/M-PROJ. [signature]
 S.C.T. [signature]
 DGM/PROJ. [signature]

6	935r-86	2A42						
d	61242-11 NU	2A42						
2A42.06.014								
ЯКОРЬ ARMATURE		<table border="1"> <tr> <th>Ам</th> <th>Масса</th> <th>Кол-во</th> </tr> <tr> <td>14</td> <td>0.13</td> <td>219</td> </tr> </table>	Ам	Масса	Кол-во	14	0.13	219
Ам	Масса	Кол-во						
14	0.13	219						
Примак 50-F-49KФ T9 14-1-1185-75								

2A42.06.016

Rz20 ✓(✓)



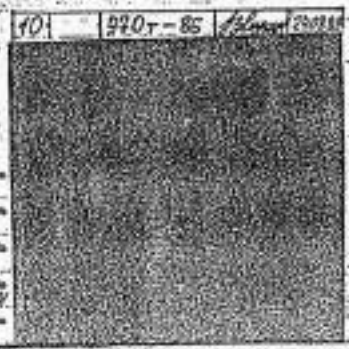
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 ORDNANCE FACTORY, TRICHURAPPALI-620 010

PUSHER

- Scale 2:1. Material: steel 25X17H26-II, TV14-1-1062-74. Mass: 8 g
1. HRC₃ 43.5 to 51.5. Test hardness on reference sample.
 2. Inner corners R≈0.4 mm.
 3. Blunt sharp edges to R≈0.6 mm.
 4. Center holes are impermissible.
 5. Stamp K and H on the lot tag.
 6. *Ensure size by tools
- (2) 2 points
 (3) Polish
 (4) Sphere R6

Обозначение	A, мм	Масса, г
2A42.06.016	52.9	
-01	52.1	
-02	52.2	
-03	52.3	
-04	52.4	
-05	52.5	
-06	52.6	

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 DATE 09.07.91
 UP-DATED
 CHECKED
 P/M-PROJ
 S C T
 DGM / PRO



2A42.06.016

PUSHER
 Толкатель

Вид	Масса	Материал
0.2	8.5.8	2:1
Изм	Изм	Изм

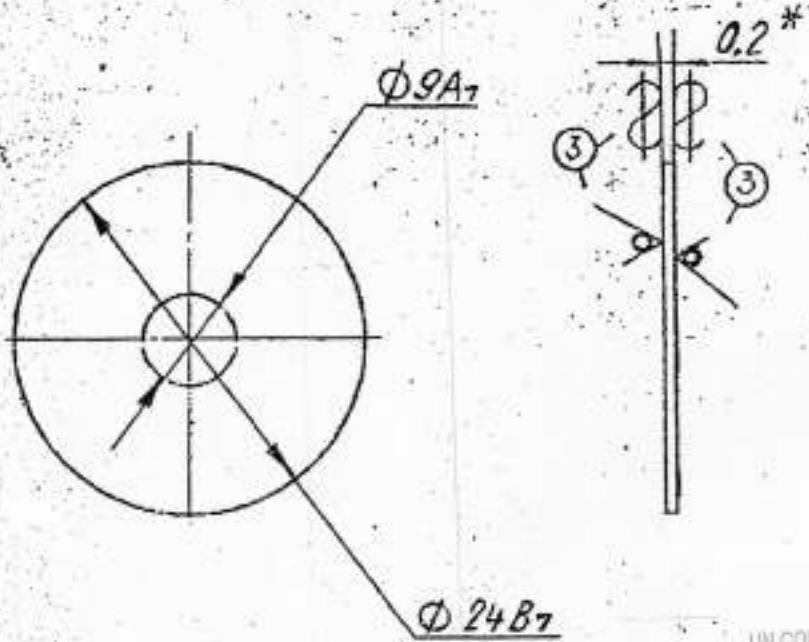
Сталь 25X17H26-II
 TV14-1-1062-74-EN Case

Vertical text on the left margin, including 'YAWHAG' and other technical specifications.

6

2A42.06.018

▽ 3 (V)
② Rz80
▽ (M)



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GASKET

Scale 2:1. Material: band БрБ2-Т-0,2-Н, ГОСТ 1789-70. Mass: 0.001

- (1) 1. *Reference size.
- 2. Remove burrs.
- 3. Stamp K on the lot tag.
- 4. Ageing

Ⓞ Материал: Лента БрБ2-Т-0,2-Н
ГОСТ 1789-70

FINAL DRG. FOR MFR. AT OFT
DATE 09-07-91

UP-DATED *[Signature]*
 CHECKED *[Signature]*
 F/M PROJ. *[Signature]*
 S CT-COPY VERIFIED: *[Signature]* 10.02.91
 DGM / PROJ. *[Signature]* 28/6/91

2A42.06.018

GASKET
 Пирокладка
 Ас-инг-52.50-Н-1-4
 ГОСТ 1789-70

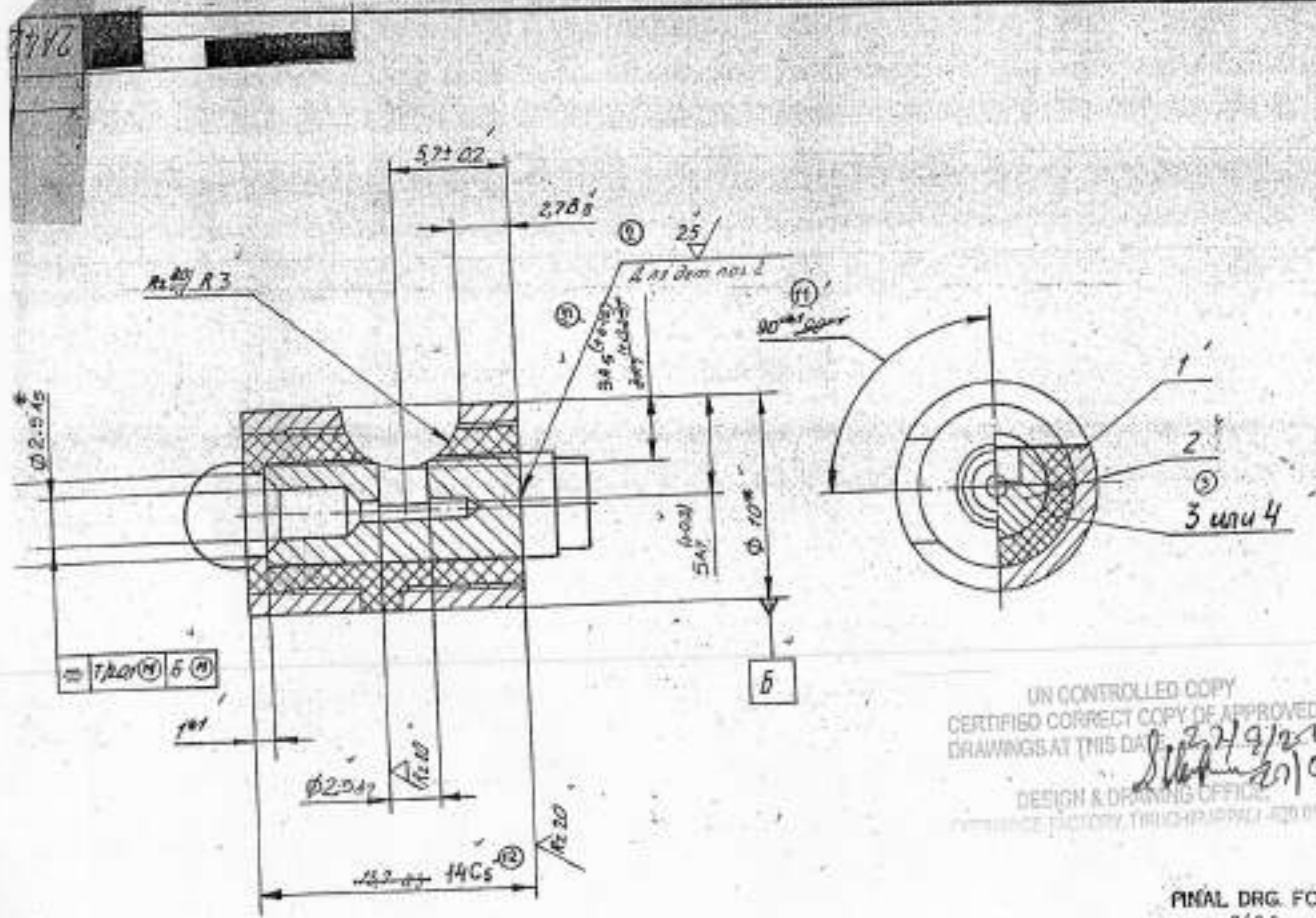
Авт.	ГОСТУ	Масштаб
0,01	0,001	2:1
10001	100001	

2A42



GATEWAY

GATEWAY



CONTACT

Assembly Drawing

Scale 5:1. Mass: 10 g

- (1) 1. Reference sizes
2. Ensure sizes by tools
3. Minimum insulation resistance is 20 megohms under normal climatic conditions. Take measurements by megohmmeter with a voltage of 500 V
4. Damage to coating is permissible
5. Stamp K on the lot tag
6. Refer to OCM, P. 005.051 for the rest of technical requirements

(2) For part, Ref. No. 2

(3) or 4

(13) ECCENTRICITY OF PART, REF NO. 2 WITH RESPECT TO PART NO. 1 SHOULD NOT BE MORE THAN 0.1 mm, AND IS ENFORCED BY ME

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PVT. ENTERPRISE "TRUCHRAPPA" JSC

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DATE 2/95
 BY DATED [Signature]
 CHECKED [Signature]
 P/M-PROJ [Signature]
 SGT. Kozlov [Signature]
 DESIGNED [Signature]

13	5077-84	1/1
12	5527-84	1/1

2462

2A42 06020C6

CONTACT
КОНТАКТ
ASSEMBLY DRAWING
Сборочный чертёж

10	10
11	10

КОН. ПОБ. 005.051

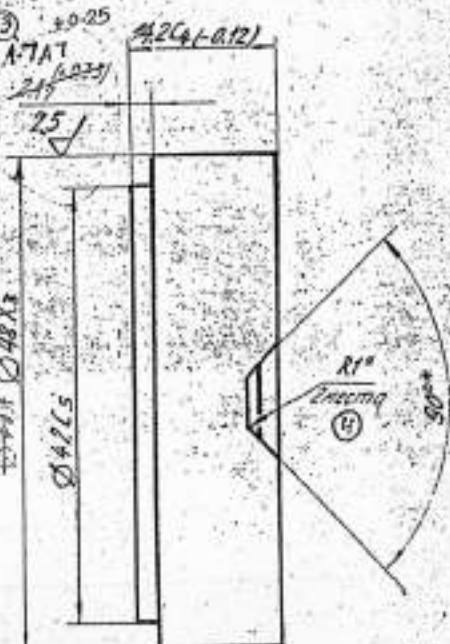
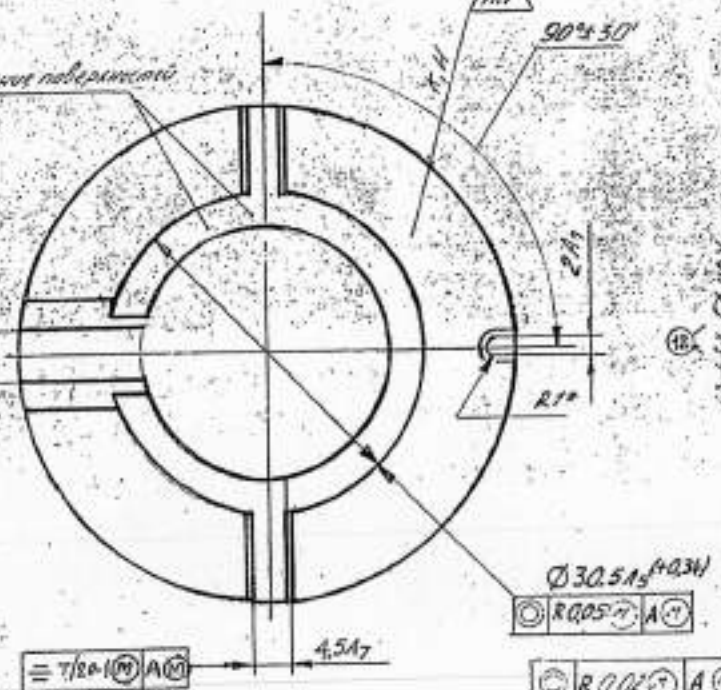
РБ. М. 0.1

2A42.06.021

R.10 ✓(✓)

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 DRAWING DATE 1989
 1989/12/22
 21/9/89

Допускается кесляная поверхность в пределах допуска



ALT. MAT'L: SOFT IRON I TO MIDHANI
 SPECIFICATION IS ACCEPTED
 (AUTHORITY: COAR/748151/d-17/8/89)

BUSHING
 10895 GOST 11036-75

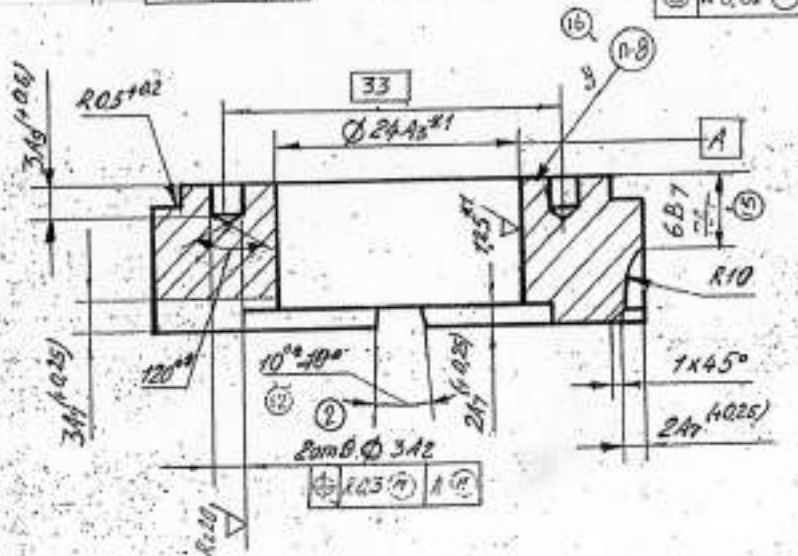
Scale 2:1. Material: steel 10895, PAGE 11036-75

- (1) 1. Material substitute: steel 10895, PAGE 11036-75
2. *Ensure sizes by tools
3. *¹Sizes and roughness after coating
4. Inner corners $R=0.4$ mm
5. Blunt sharp edges to $R=0.6$ mm
6. Coating: surface A - hard chromium plating (Layer of 9 to 30μ) $P = 0.09 \text{ dm}^2$; unless otherwise specified; accelerated electroless phosphating with chromate treatment

16	6647-82	10895
15	5917-84	10895
13	547-84	10895

* Материал: сталь 10895-ГОСТ 11036-75.

2A82



7. Stamp
- (2) 2 holes $\varnothing 3A_0$
- (3) KNT MARK IS PERMISSIBLE WITHIN ALLOWANCE LIMITS
- (10) D MARK SERIAL NO. OF PART WITH TYPE 10-3 GOST 2930-62

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 DATE 09-07-91
 UP-DATED
 CHECKED
 P/M-PROJ
 S.C.T. COPY VERIFIED
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2A42.06.021

BUSHING
 БИТУЛКА

№	Масса	Количество
01	2.135	211

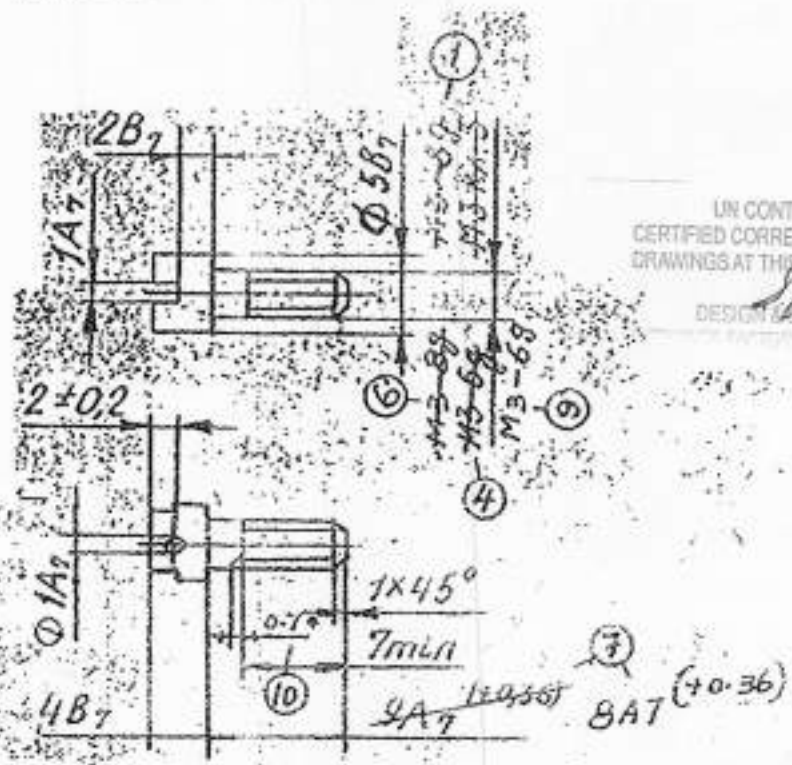
М.М. БУШИН

200 70 04 06

5	498T-84	Blues	06012
6	607T-84	Blues	93012
8	615T-84	Blues	06012
7	689T-85	Blues	06012
10	711T-85	Blues	06012
9	719T-85	Blues	06012
α	SKAVE-HHH	Blues	03012

▽4 (V)
Rz40 (V)

ALT.MATL: IS:5517-1993, DESIGN, 40Cr4
Ref: Letter No. CQAM/QA-1/30mm, Dt.21 Feb.2012



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P. PARTHIBALU, CHENNAI - 600 011

2A42.06.023

Sheet 34

⑥ HRA 65.5...70
SCREW
30X1CA 05T 3-98-80
Scale 2:1. Material: steel 40Cr4, Mass: 0.001

- (1) 1. HRC 38.5 to 45.5 Test hardness on reference sample
2. Inner corners R≈0.4 mm HRC 34...40.5. AMEND. NO. 57/2012-II DT.1.8.20
3. Round off sharp edges to R≈0.4 mm
4. Coating: cadmium plating (layer of 3 μ); accelerated phosphating with chromate treatment P = 0.02
5. Stamp K and H on the lot tag
6. *DIM. IS ENSURED BY TOOL

SH. NO. 13 OF 91 2A42

FINAL DRG. FOR MFR. AT OFT
DATE 09-07-91

UP-DATED: [Signature]
CHECKED: [Signature]
P/M PROJ: [Signature]
SCT-COPY VERIFIED: [Signature] 10.02.91
DOM/PROJ: [Signature] 28/07/91

2A42.06.023
SCREW
BUHMI
30X1CA
EM1016-5-40X
00T3-98-35-80

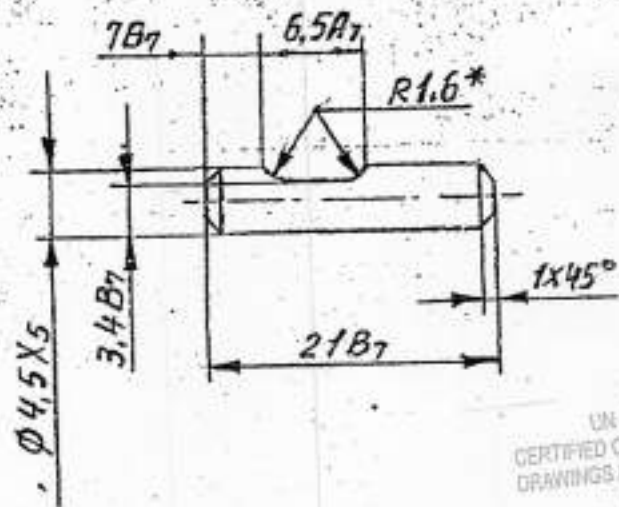
QTY	0.001	2:1
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2A42.06.025

Rz40



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 DESIGN & DRAWING OFF

ROD

Scale 2:1. Material: steel 30XPA, OCT 3-98-80. Mass: 0.002

- (1) 1. HRC₃ 43.5 to 51.5. Test hardness on reference sample
2. Round off sharp edges to $R \approx 0.5$ mm
3. *Ensure size by tools
4. Coating: cadmium plating (layer of 3μ) $F = 0.033$; accelerated phosphating with chromate treatment and impregnation with adhesive BQ-4, GOCT 12172-74, one layer
5. Stamp K and W on the lot tag

ALT.MATL: IS:4367-1991, DESIGN 25Cr13Mo6
 Ref: Letter No. CQAM/QA-1/30mm, Dt.21 Feb.2012

FINAL DRG FOR MER. AT OFT
 DATE 09-07-91
 UP-DATED
 CHECKED
 F/M-PROJ
 CT-COPY VERIFIED: 10.08.91
 DGM/PROJ: 26(8)91

2A42	
2A42.06.025	
ROD	
СТЕРЖЕНЬ	0,002 2:1
СТАЛЬ 30XPA	
OCT 3-98-80	

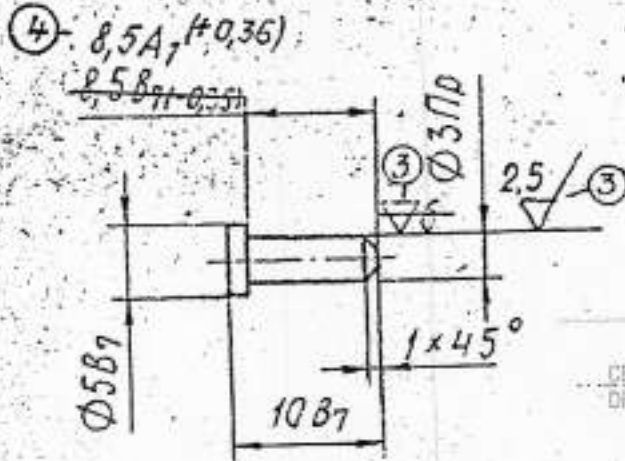
3000000. 704 с ПОДПИСИ НА... 842/11-888-84... 28.7.89

2A42.06.026

ALT.MATL: IS:5517-1993, DESIGN, 40Cr4

Ref: Letter No. CQAM/QA-1/30mm, Dt.21 Feb.2012

③ Rz40



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 ORDNANCE FACTORY, TIRUCHIRAPPALLI-620 016

LOCKPIN

Scale 2:1. Material: steel 40X, ГОСТ 4543-71. Mass: 0.003

- (1) 1. HRC₃ 38.5 to 45.5. Test hardness on reference sample
2. Inner corners R ≈ 0.4 mm
3. Round off sharp edges to R ≈ 0.6 mm
4. Coating: cadmium plating (layer of 3 μ); accelerated phosphating with chromate treatment
5. Stamp K and M on the lot tag

Material: steel

*Материал: Сталь 40X ГОСТ 4543-71. ④

FINAL DRG. FOR MFR. AT OFT

DATE 09-07-91

UP-DATED V. Rayan

CHECKED S. Srinivasan

F/M-PROJ.

SCT COPY VERIFIED: 19.08.91

DGM/PROJ. 2019/91

7 2117-B/M/SCT 040889

2A42

2A42.06.026

LOCK PIN
 Штифт

шт	Масса	Масштаб
1	0.003	2:1
№	1/СМ/01	

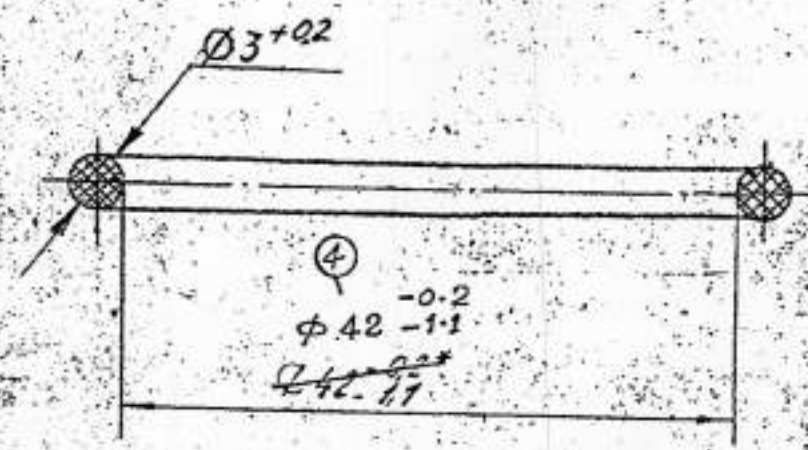
См. Визуэ 30.04.91 (5)
 5073 58 5859 (5)



31

2A42.06.027

№ 2
№ 2A42.06.000



RING

Scale 2:1. Material: rubber mixture HO-68-1, TY38.005.1166-73.
Mass: 5 g

- (1) 1. Roughness of form surfaces of mould should not be less than 0.63 ✓ (4)
- 2. Ensure sizes by tools
- 3. The part surface may bear elevations and depressions not exceeding 0.2 mm
- 4. Displacement is permissible over the mould joint within size allowance limits
- 5. Refer to ~~TY38.005.036-79~~ ^{TY 38.05.347-84} — (5) for the rest of technical requirements, surface quality according to group B1
- 6. Mark and stamp K on the lot tag

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 DESIGN & DRAWING OFFICE
 OVERSEAS FACTORY, TRICHYRAIPALLI-681045

FINAL DRG. FOR MFR. AT OFT

DATE 09-07-91

UP-DATED

CHECKED

R/M-PROJ.

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DGM/PROJ.

2A42.06.027

RING
КОЛЪЦО

№	Маса	Толщина
3	5g	2.7

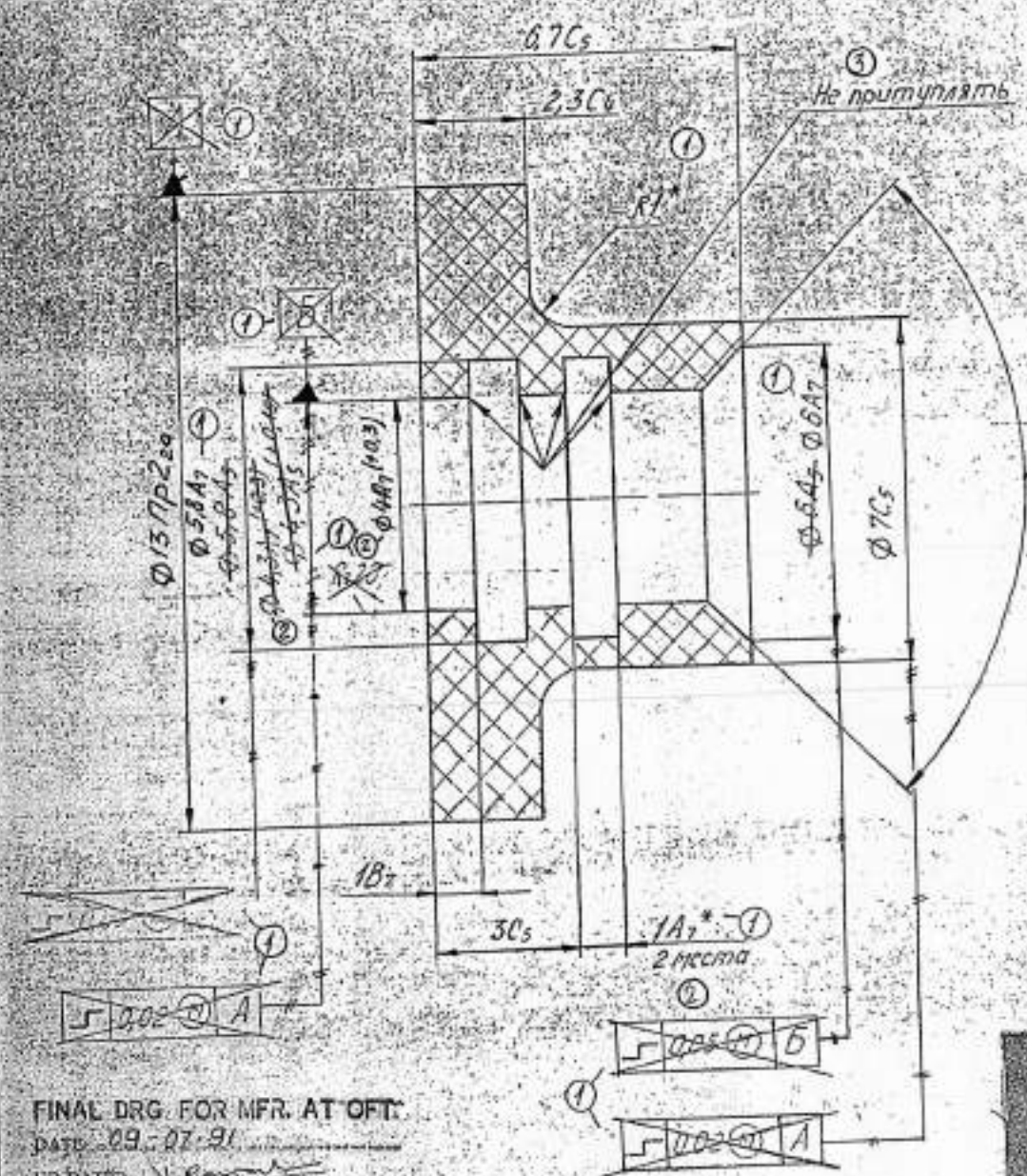
5	1014T-87	SCT	24.08.88
4	607T-87	SCT	08.01.98

Материал резини смеси HO-68-1,
 TY38.005.1166-73

2A42.06.027
 280889
 1113

R140/

2A42.06.028



COLLAR

Scale 10:1. Material: rod Φ -4 Φ 15, grade 1, T76-05-810-76.
Mass: 0.0004

- (1) 1. Ensure sizes by tools
- 2. Inner corners $R \approx 0.2$ mm
- 3. Blunt sharp edges to $R \approx 0.4$ mm
- 4. Stamp I on the lot tag
- (2) 2 points
- (3) Do not blunt

PL-MATL. DANITE-TVY-261 (THERMO-PLASTIC POLYESTER)
GOREL. EDGE REINFORCED INJECTION MOLDING (BASE)
(ANALOGY: CO22/14.810/1/1/20.7.87)

FINAL DRG. FOR MFR. AT OFT.
DATE 09-07-91
UP-DATED
CHECKED
P/M-PROJ.
SCT. CAPY. VERIFIED
D/A/PROJ.

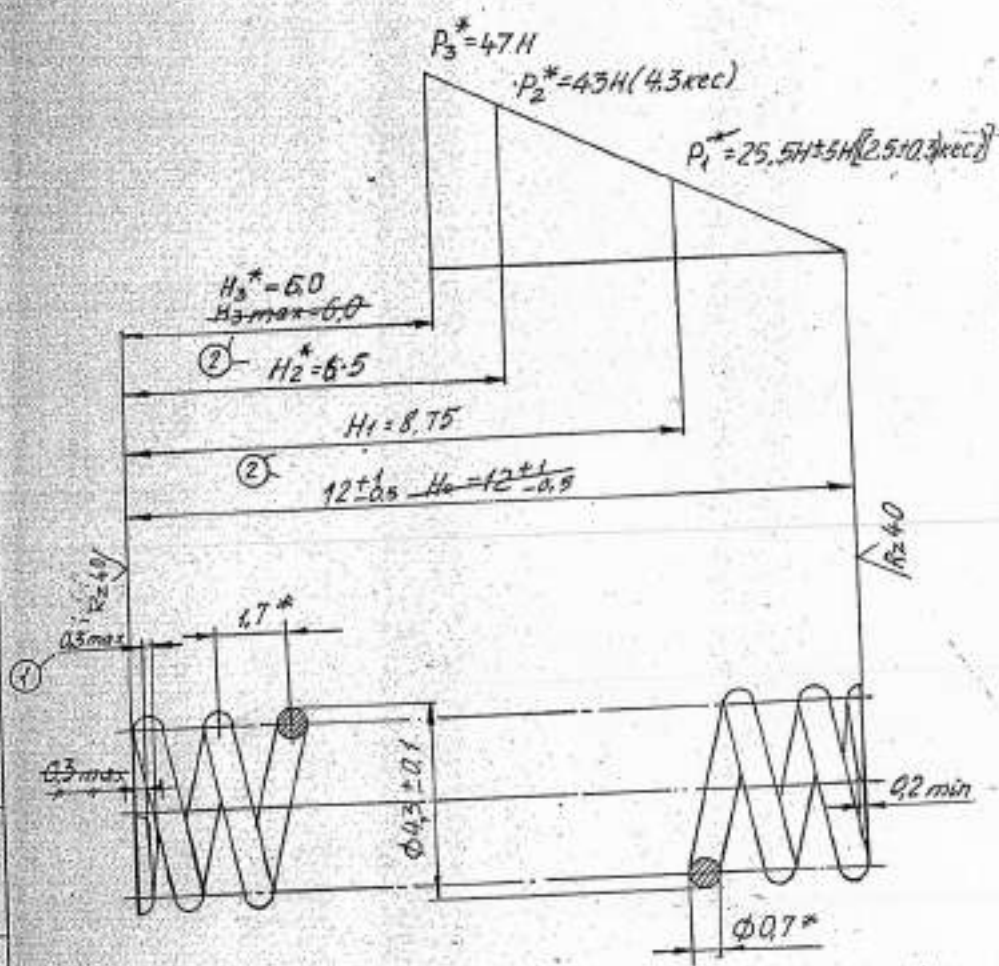
2A42			
2A42.06.028			
COLLAR Манжета	Кум	Масса	Масштаб
	3/01	0,0004	10:1
Спирже-ль 7-4 Φ 15, сорт 1			
175-05-810-76			

GATEWAY

1-2A42.03
20621
2A42.06.028

2A42.06.032

✓(✓)



SPRING

- Scale 1:1. Material: wire I 0.7, ГОСТ 9389-75. Mass: 0.002
1. $G^* = 78400 \text{ MPa}$ (8000 kgf/cm^2)
 2. $\tau_{2x}^* = 1617 \text{ MPa}$ (162 kgf/cm^2)
 3. Refer to ГОСТ 16118-70, 2nd acc.cl., for specifications of manufacture, test and acceptance of springs
 4. RH coiling
 5. $n = 6.5$
 6. $n_1 = 8.5_{-0.25}$
 7. Thermal treatment: tempering at 240 to 260°C
 8. $D_2 = 4.5A_5$
 9. *Sizes and parameters for reference
 10. Length of extended spring $L^* = 100 \text{ mm}$
 11. Time of scrapping of the compressed spring: 24 h
 12. Coating: accelerated electroless phosphating with chromate treatment and impregnation with adhesive EФ-4, ГОСТ 12172-74, one layer
 13. Stamp K and K on the lot tag

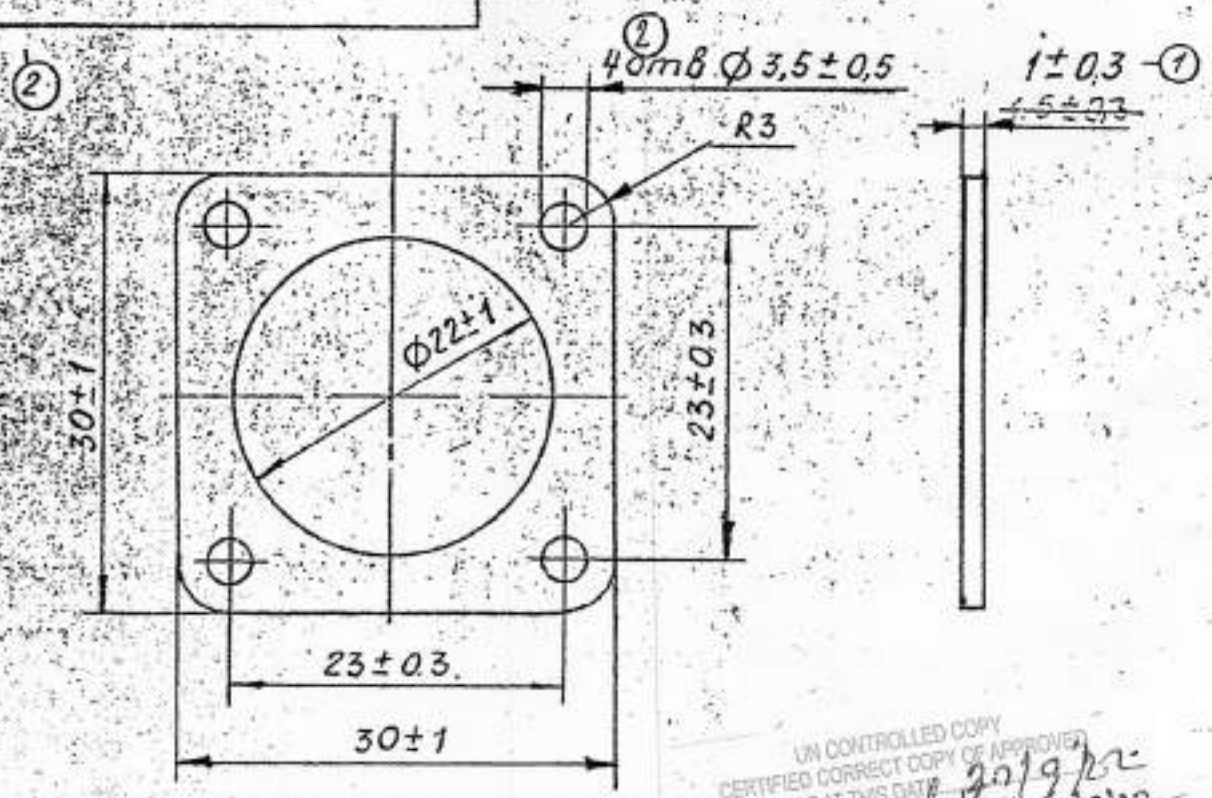
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 S. V. V. 27/9/22

FINAL DRG. FOR MFR. AT OFT
 DATE 09.07.91
 UP-DATED V. B. 10/10/91
 CHECKED O. K. 10/10/91
 FIM-PROJ. ✓
 SCT. GEN. MANAGER: S. V. V. 12.02.91
 DOM/PROJ. 26/8/91

2A42			
2A42.06.032			
SPRING	01	0.002	1/1
Пружина			

2A42.06.035.033

ЧУПЕ: 46
2A42.06.000



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 GEOMINERVA, TRACHYRAPPAH-432 015

GASKET

Scale 2:1. Material: rubber mixture B-14, TV38.005.1166-73.
 Mass: 3 g

- (1) 1. Roughness of form surface of mould - no less than 0.63 ✓
2. It is permissible to cut it out of rubber mixture sheet B-14 TY 38-005-1166-73, surface roughness at places of cutting is R_z320 ✓
3. Ensure all sizes and limit deviations by tools
4. Stamp K on the lot tag
5. Refer to TV38-005.838-70 for the rest of technical requirements surface quality in accordance with group B
- (2) 4 holes $\varnothing 3.5 \pm 0.5$

2A42

FINAL DRS. APPROVED AT OFF
 DATE 09-07-91

2A42.06.035.2A42.06.033

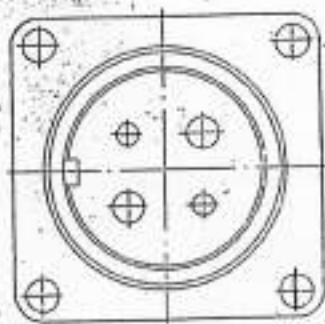
DESIGNED BY: *[Signature]*
 CHECKED BY: *[Signature]*
 SGT COPY VERIFIED: *[Signature]*
 PROJ: *[Signature]*
 3 7737-85 SGT 210889

GASKET
 Прокладка

№	МАТЕРИАЛ	КОЛ-ВО
3	32	2:1

Смесь резиновая В-14
 ТУ38.005 1166-73

2442.06.034



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DRAWN AS AT THIS DATE

376/20
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FEDERAL BUREAU OF INVESTIGATION

PLUG

Scale 2:1. Material: blank plug 2PH22B4H3E2E TEO.364.140 TV.
Mass: 38 g

- (1) 1. Blank of plug 2PH22B4H3E2, TEO.364.140 TV is Permissible.
2. *Sizes ensured by tools
3. Stamp K on the lot tag

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F/M-PROJ. [Signature]

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DGM / PROJ. [Signature]

2442

2442.06.034

PLUG	Тем.	Масса	Масштаб
БУЛКА	2	38г	2:1

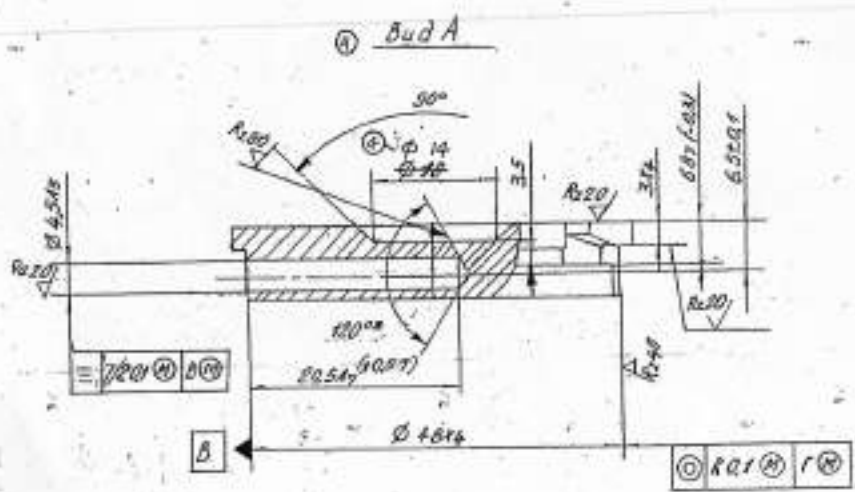
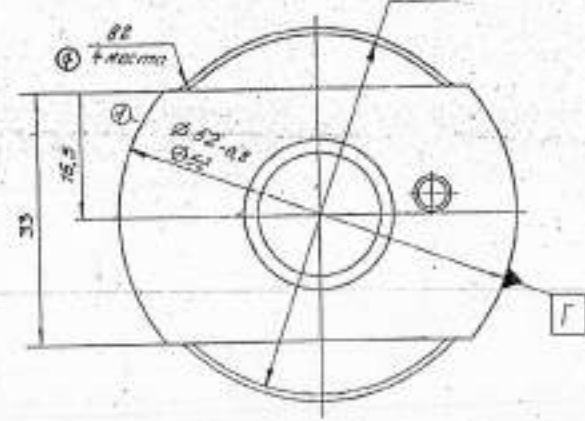
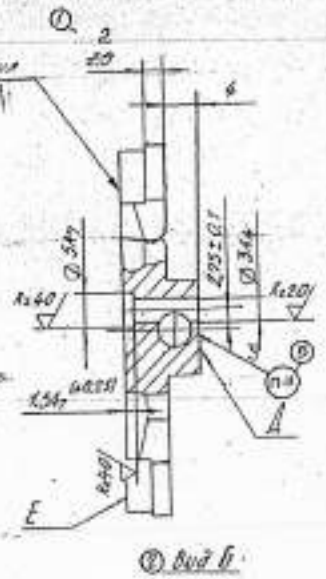
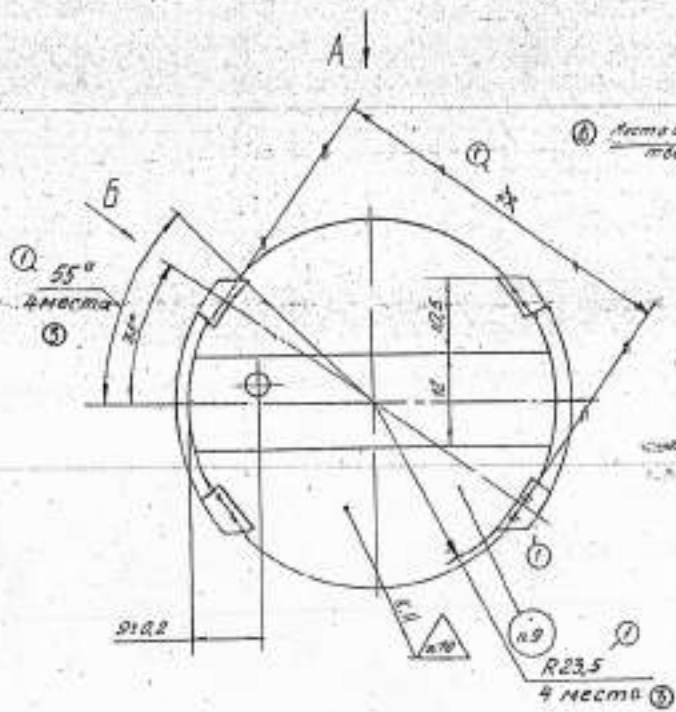
Заготовка булка 2PH22B4H3E2E
TEO.364.140TV

2442.06.034

3306
 2442.06.034
 2442.06.034
 2442.06.034

- (2) View B
- (3) 4 points
- (4) View A
- (5) 4 points
- (6) Hardness test point
- (7) 4 points

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 COGNATE FACTORY, THIRUCHIRAPPALI-620 016.



Scale 2:1. Material: casting II GOST-4365-79, Mass: 0.1
 25X090000 TPAK116-78

- (1) 1. Unspecified casting radii are R = 1.6 mm
2. Remainder of gate 0.3 mm high, max., is permissible on surface I. MAX. FINISHING Ra 2.5 - (3)
3. Casting defects on finished surfaces are permissible, as on reference sample
4. HRC, 41.5 to 51.5
5. Additionally accomplish check for impact strength in accordance with section 3, ГОСТ 977-75
6. *Easiness size by tools
7. Blunt sharp edges to R = 0.6 mm
8. Coating: cadmium plating (layer of 3 μ); accelerated phosphating with chromate treatment and impregnation with adhesive IS-4, ГОСТ 12172-74, and nigrizine, mark A, ГОСТ 9307-78, one layer. Do not coat surface E with adhesive and nigrizine. Oil non-painted sections.

2. Mark by ordinal number of mould, number of mould cell and type NO-3, cast 2330-62.
 10. STAMP
 11. MAKE SERIAL NO. OF THE PART WITH TYPE NO-3, cast 2330-62

4	687-25	10	1000
5	664-25	10	1000
7	697-25	10	1000

FINAL DRG. FOR MFR. AT OFF
 DATE 09-07-91
 UP-DATED
 CHECKED
 P.J.M.-PROJ.
 S.C. TO CORRY. VERIFIED: L. S. S. S.
 DGM / POOL: 206/2791

2A42 06.035 2A42 06.035

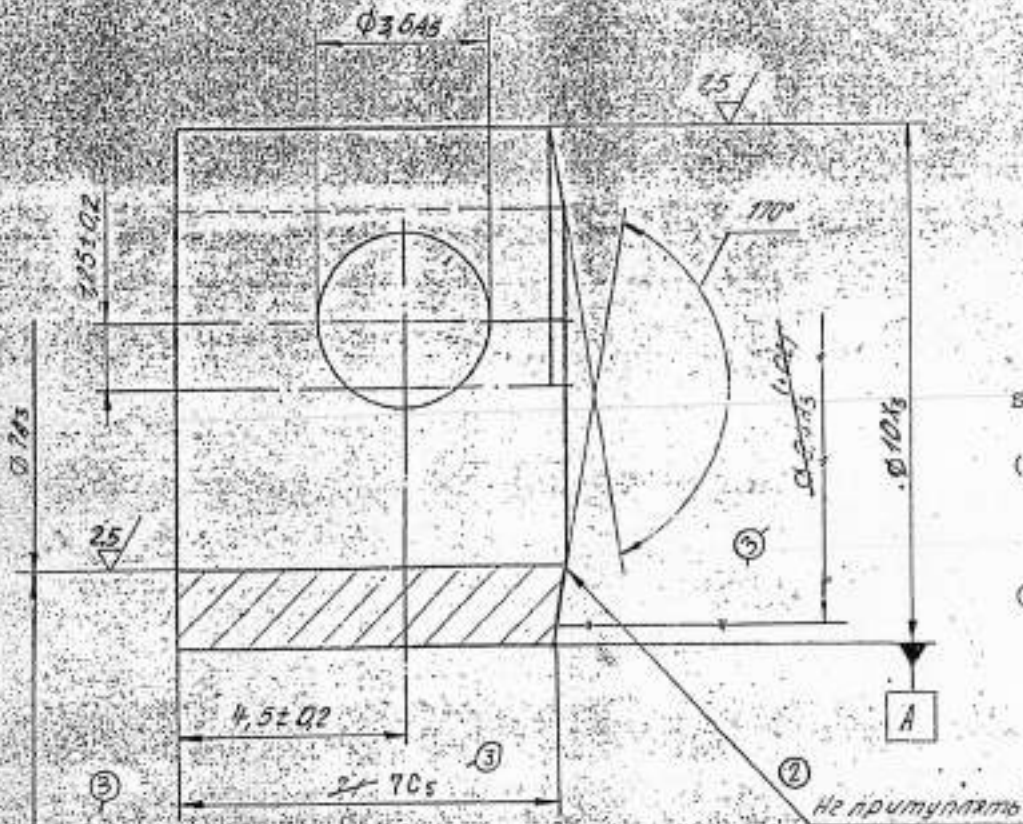
KPBIWKO 23

2073-233-79

NO.	DATE	BY
1	01	21

1:20 (✓)

2A42.06.015.036



①	R0.05	M	A	M
②	12.5	μm		
③	12.5	μm		

BUSHING

Scale 10:1. Material: steel 25X17H2E-W, ТУ14-1-1062-74.

Mass: 2 g

- (1) 1. HRC₂ 43.5 to 51.5. *To be hardened in vacuum.* Harden in vacuum. Test hardness on reference sample
 2. Blunt sharp edges to R = 0.6 mm
 3. Stamp K and M on the lot tag
- (2) Do not blunt

b	570002-12 MW	12/02/91
3	2167-B4	12/02/91
α	570002-5 MW	12/02/91

FINAL DRG. FOR MFR. AT OFT
 DATE 09-07-91
 UP-DATED V. [Signature]
 CHECKED [Signature]
 F/M-PROJ [Signature]
 S.C.T. [Signature]
 DQM / PROJ. [Signature]

2A42.06.015 2A42.06.036

BUSHING
 Втулка

Num	Mass	Accuracy
1	2g	10:1
Actual		

Сталь 25X17H2E-W
 ТУ14-1-1062-74

11-24-91 09:48-11

1	1800
2	1800
3	1800
4	1800
5	1800
6	1800
7	1800
8	1800
9	1800
10	1800
11	1800
12	1800
13	1800
14	1800
15	1800
16	1800
17	1800
18	1800
19	1800
20	1800

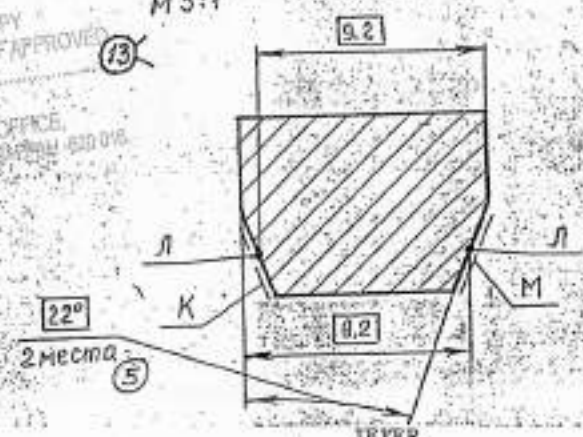
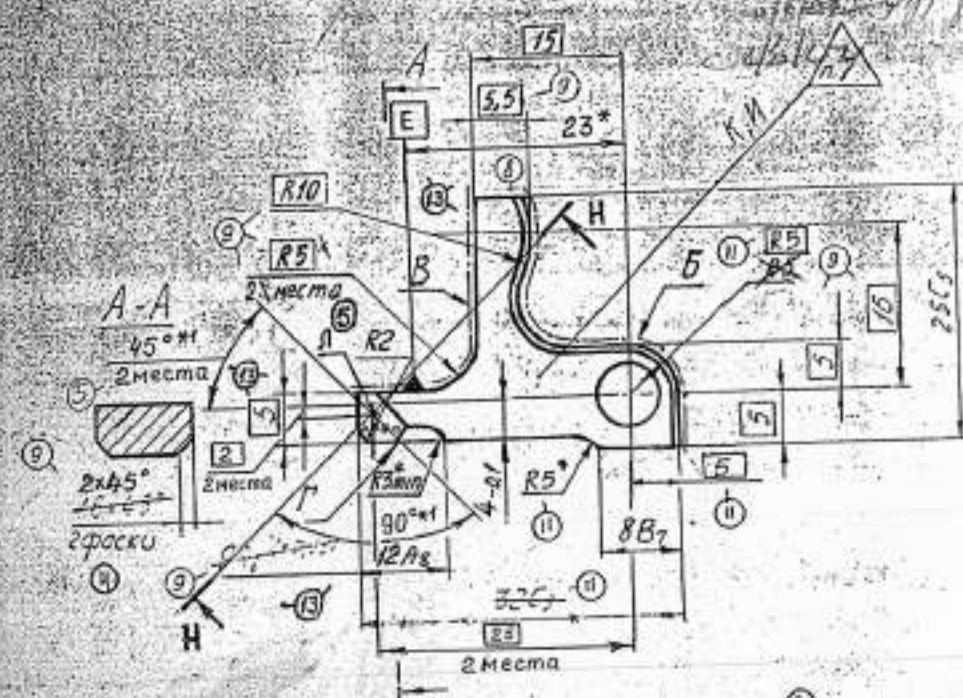
2A42.06.029.037

H-H
M 5:1

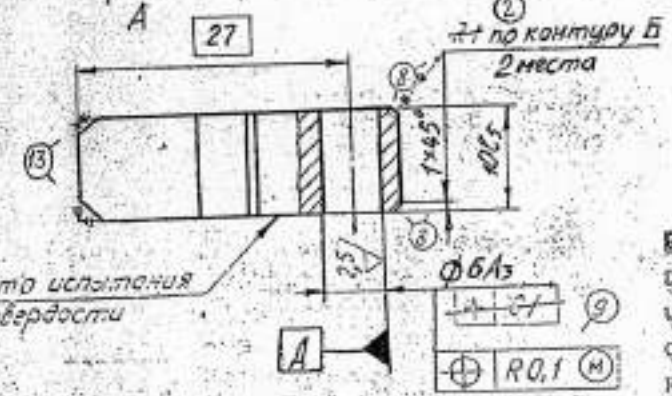
Повёрнуто.
Revolved

A₂20 (✓)

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DATE: _____
OFFICE: _____
NO. _____



- Scale 2:1. Material: steel 30ХРА, OCT 3-98-80. Mass: 0.02
1. HRC₃ 43.5 to 51.5
 2. Ensure sizes by tools
 3. Blunt sharp edges to R=0.6 mm
 4. Coating: cadmium plating (layer of 3 μ); accelerated phosphating with chromate treatment; P = 0.5 dm²
 5. TOLERANCE ALONG CONTOUR E AND B WITH RESPECT TO BASE A AND F IS 0.2 mm
 6. TOLERANCE ALONG CONTOUR K, M IS 0.2 mm RELATIVE TO DATUM A AND E
 7. Stamp
 8. OVER CONTOUR B - 2 POINTS
 9. HARDNESS TEST POINT
 10. 2 CHAMFERS
 11. 2 POINTS



FINAL DRG FOR MFR. AT OFT
DATE 09-07-91
UPDATED _____
CHECKED _____
R/M-PROJ _____
SCT-COPY VERIFIED _____
DGM/PROJ _____

2A42
2A42.06.029-2A42.06.037

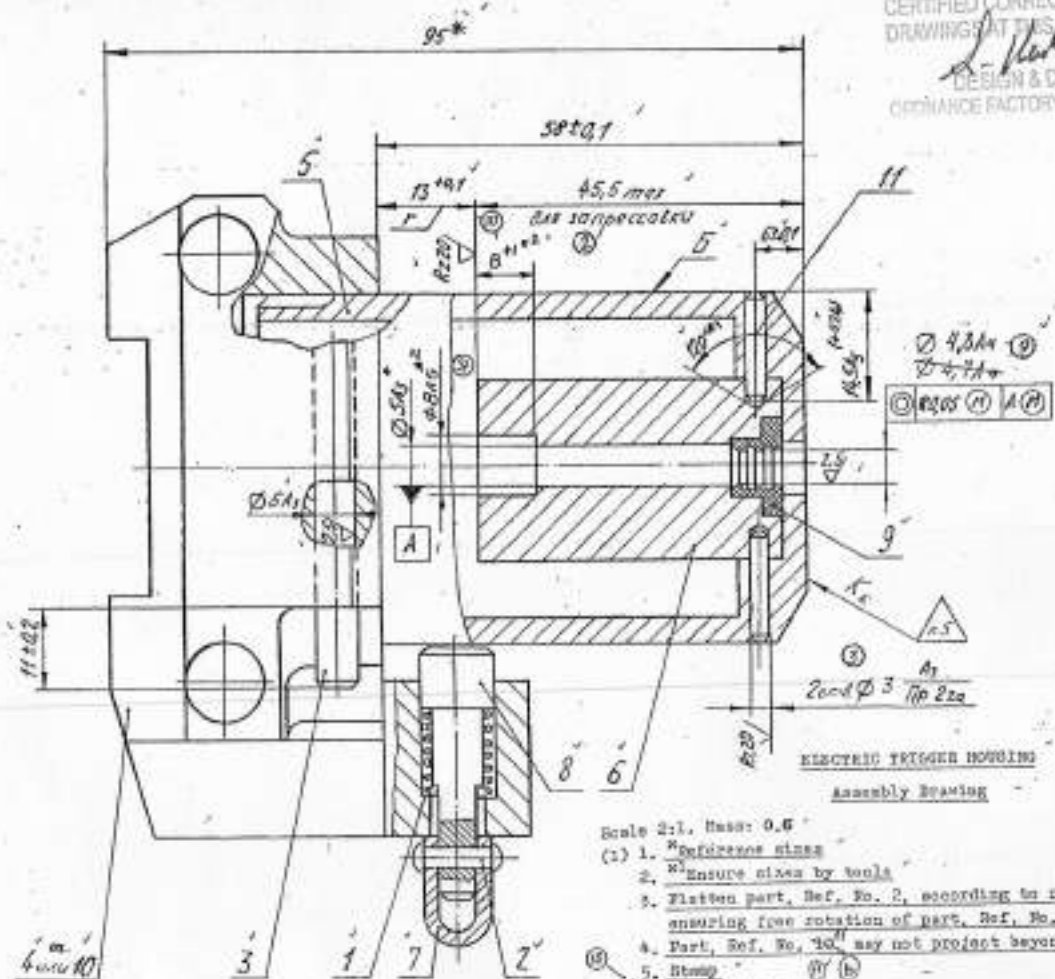
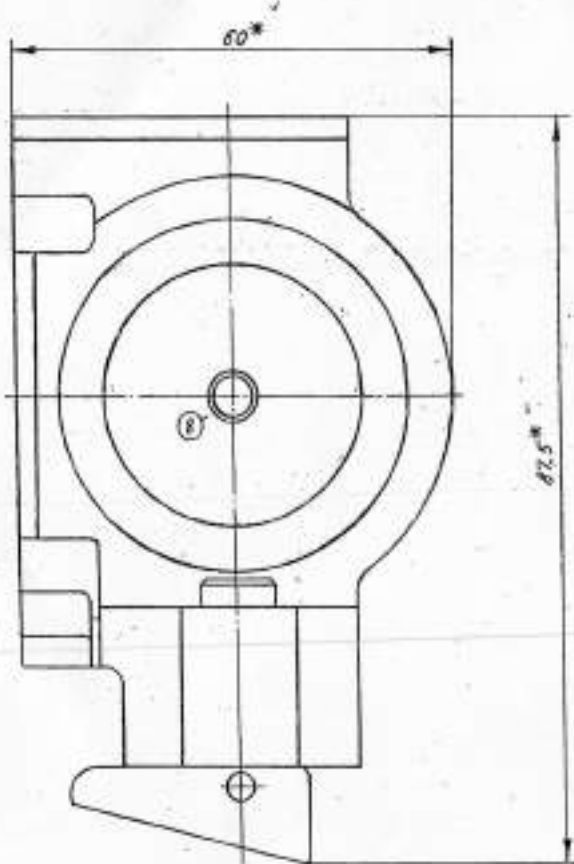
LEVER Рычаг		
Item	Mass	Amount
1	0.02	2:1

13	364Т-81М	SCT	07-02-91
12	691Т-85	SCT	06-11-90
11	677Т-84	SCT	02-01-90

Сталь 30ХРА
OCT 3-98-80-80

2A42.06.040CB

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CONFORMANCE FACTORY, TRUCHIRAPPALU - 620 016



ELECTRIC TRIGGER HOUSING
Assembly Drawing

Scale 2:1. Mass: 0.6

- (1) 1. ^RReference sizes
- 2. ^REnsure sizes by tools
- 3. Flatten part, Ref. No. 2, according to reference sample ensuring free rotation of part, Ref. No. Y.7.
- 4. Part, Ref. No. 10, may not project beyond surface 3.
- 5. Stamp
- (2) for press-fitting
- (3) 2 holes $\frac{A_2}{H_7/g_6}$

6. CHECK THE DIMS. AFTER ENSURING THE Dim. 1

11	95	±0.1
6	58	±0.1
13	13	±0.1
5	45.5	max

FINAL DRG FOR MFR. AT OFT

DATE 2/93

UP DATED

DRAWN

ECT. CHECK

DATE 15.02.92

2A42

2A42.06.040CB

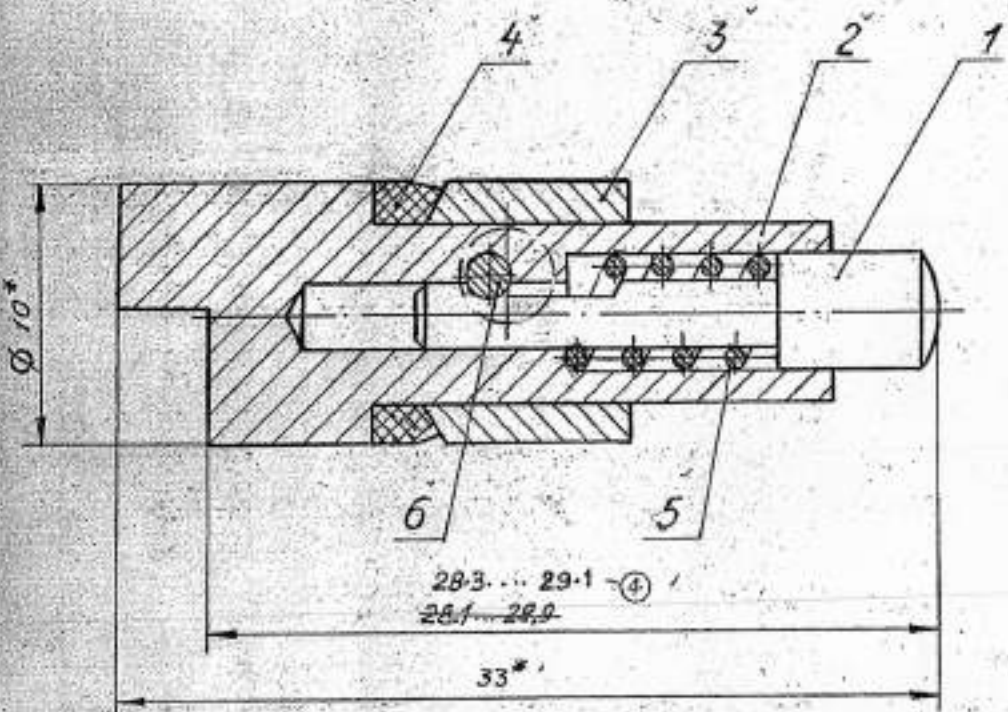
Код	Масса	Штук
2	4,6	219
Контроль качества		

Vertical text on the left margin: 2A42.06.040CB, 15.02.92, 219, 4,6, 2

2A42.06.060CB

2A42.06.000

2A42.06.000



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 ORDNANCE FACTORY, TRICHYRAIPALLI-620 016

PLUNGER
 Assembly Drawing

Scale 5:1. Mass: 13 g
 (1) 1. *Reference sizes
 2. Stamp K on the lot tag

FINAL DRG. FOR MFR. AT OFT

DATE 15.12.93
 UP-DATED [Signature]
 CHECKED [Signature]
 F/M-PROJ [Signature]
 BCT. [Signature] 15.12.93
 DGM / PROJ [Signature]

4	552 1/2-80	100	100
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2A42

2A42 06 060CB

PLUNGER
 ПЛУНЖЕР
 ASSEMBLY DRAWING
 Сборочный чертёж

Лист	Масса	Масштаб
01	13g	5:1
Листов 1		

2A42.06.000
ELECTRIC TRIGGER

Sheet 1 of 3

No.	Designation	Description	Qty	Remark
		<u>Documentation</u>		
	2A42.06.000 CB	Assembly drawing		
	2A42.06.000 TV	Specifications		
	2A42.06.000 IC	Certificate		
		<u>Assembly Units</u>		
1	2A42.06.010	Electromagnet coil	1	
2	2A42.06.030	Contact	2	
3	2A42.06.040	Electric trigger housing	1	
4	2A42.06.050	Cover	1	
5	2A42.06.060	Plunger	2	
		<u>Parts</u>		
6	2A42.01.044	Spring	2	(20)
	588 T - 84		19.08.89	

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15/2/93

No.	Designation	Description	Qty	Remark
7	2A42.01.088	Spring	1	
8	2A42.06.014	Armature	1	
9	2A42.06.016	Pusher	1	
10	2A42.06.018	Gasket	1	
11	2A42.06.021	Bushing	1	
12	2A42.06.023	Screw	4	
13	2A42.06.027	Ring	1	
14	2A42.06.037	Lever	2	May be re- placed by Ref. No. 15
15	2A42.06.029	Lever	2	May be re- placed by Ref. No. 14
16	2A42.06.034	Plug Plug 2PMT22E403E2E TEO.364.140 TY Blank for part 2A42.06.034	1 1	
17	2A42.06.033	Gasket	1	May be re- placed by Ref. No. 20
<u>Standard Articles</u>				
18		Washer 3.65T.029 FOOT 6402-1/4	4	
20		Gasket B22x30- -MPH3012 OCT3-4038-78	1	May be re- placed by Ref. No. 17
19		Lockpin 2C ₃ x1040XKd 6xp OCT3-2234-80	1	HRC, 38.5-45.5

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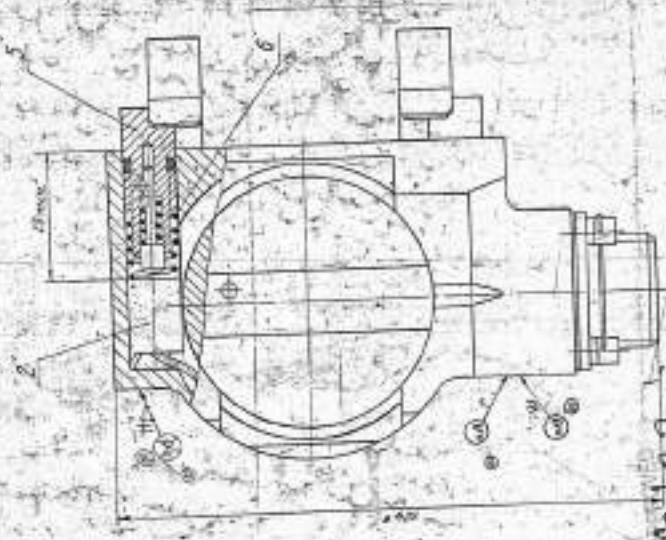
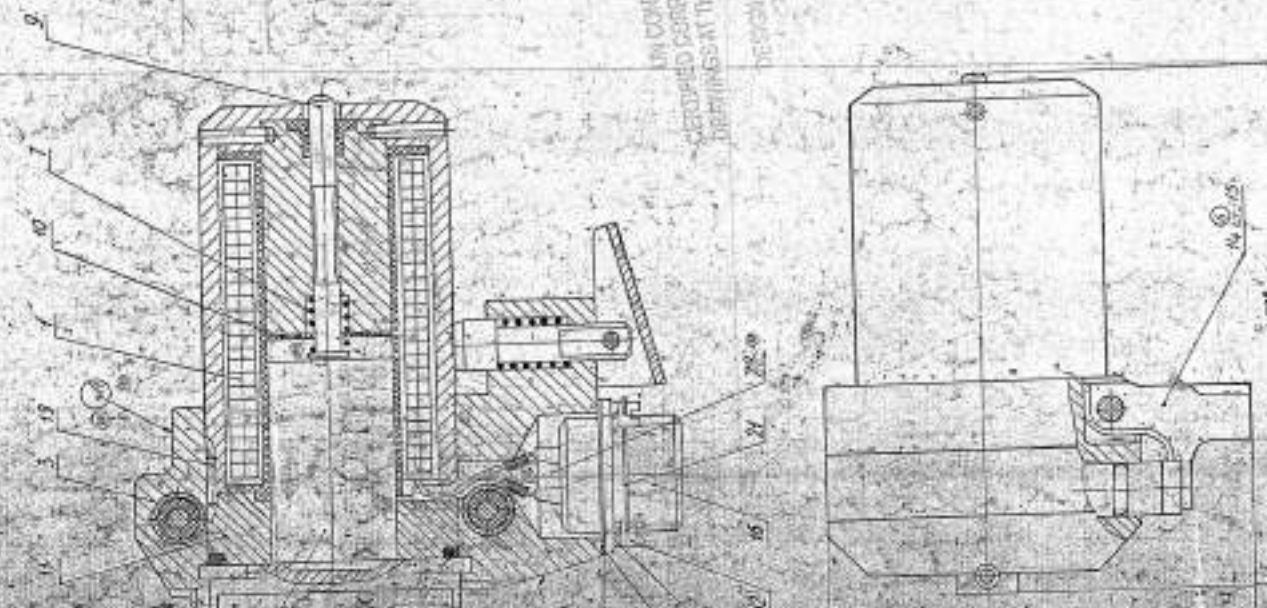
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ORDNANCE FACTORY, TRICHIRAPPALI-620 016.

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15/2/93

No.	Designation	Description	Qty	Remark
21		<u>Materials</u> Wire KO 0.5 ROCT 792-67	0.15 m	

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 ORDNANCE FACTORY, TIRUCHIRAPPALLI

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 10/2/93



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 12-19-67
 DESIGN & DRAWING DEPARTMENT
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② Copy as shown

1	1	1	1
2	2	2	2
3	3	3	3
4	4	4	4
5	5	5	5
6	6	6	6

③ Copy as shown
 ④ Copy as shown
 ⑤ Copy as shown
 ⑥ Copy as shown



REF: 6000

① Проверка деталей...
 ② Проверка деталей...
 ③ Проверка деталей...
 ④ Проверка деталей...
 ⑤ Проверка деталей...
 ⑥ Проверка деталей...

2442 05 000 05
 2442 05 000 05
 2442 05 000 05

① Проверка деталей...
 ② Проверка деталей...
 ③ Проверка деталей...
 ④ Проверка деталей...
 ⑤ Проверка деталей...
 ⑥ Проверка деталей...

① Проверка деталей...
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 ⑥ Проверка деталей...

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 ⑤ Проверка деталей...
 ⑥ Проверка деталей...

① Проверка деталей...
 ② Проверка деталей...
 ③ Проверка деталей...
 ④ Проверка деталей...
 ⑤ Проверка деталей...
 ⑥ Проверка деталей...

2A42.06.010
ELECTROMAGNET COIL

No.	Designation	Description	Qty	Remark
	2A42.06.010 CB	<u>Documents</u> Assembly drawing		
		<u>Parts</u>		
1	2A42.06.001	Coil frame	1	
		<u>Materials</u>		
2		Wire ПЗТБ 0.75 OCT 16.0.505.001-80	60 m	
3		Wire MC 36-11 0.35 TV 16-505.195-80	0.5 m	
4		Wire MC 36-11 0.35 TV 16-505.195-80	0.06 m	
	10	972 T-86	24.08.89	

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TRINCHMAPPAL JESSUR

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15/2/93

2A42.06.020

CONTACT

No.	Designation	Description	Qty	Remark
		<u>Documents</u>		
	2A42.06.020 CB	Assembly drawing		
		<u>Parts</u>		
1	2A42.06.002	Bushing	1	
2	2A42.06.003	Rod	1	
		<u>Materials</u>		
3		<i>Moulding material</i> ICB-2-P-2M-O. mark O,	12 g	Substitution by item 4 is permissible
4		ГОСТ 17478-72 <i>MOULDING material</i> ACB-4-P-2M-O ГОСТ 17478-72	12g	Substitution by item 3 is permissible
5	985T-87	24.08.89		

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INDIAN RAILWAYS FACTORY TIRUCHIRAPPALI-620 003

U...
15/2/83

2A42.06.030

CONTACT

No.	Designation	Description	Qty.	Remark
		<u>Documents</u>		
	2A42.06.030 CB	Assembly drawing.		
		<u>Assembly Units</u>		
1	2A42.06.020	Contact	1	
		<u>Materials</u>		
2		Wire MC 36-11 0.35 TV16-505.195-80	0.15 m	

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 PERFORMANCE FACTORY, TRUCHIRAPPALI-522 016 *[Signature]*

[Signature]
 13/12

2A42.06.040

sheet 1 of 2.

ELECTRIC TRIGGER HOUSING

No.	Designation	Description	Qty	Remark
		<u>Documents</u>		
	2A42.06.040 CB	Assembly drawing		
		<u>Parts</u>		
1	2A42.01.044	Spring	1	
2	2A42.01.047	Pin	1	
3	2A42.06.004	Pin	1	
4	2A42.06.005	Housing	1	May be re- placed by Ref. No.10
5	2A42.06.006	Foot	1	
6	2A42.06.007	Insert	1	
7	2A42.06.012	Lever	1	
8	2A42.06.019	Detent	1	
9	2A42.06.028	Collar	1	
10	2A42.06.031	Housing		One pc may be replaced by Ref. No. 4

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Handwritten signature
15/2/23

No.	Designation	Description	Qty	Remark
11.		<u>Standard Articles</u> Lockpin 3Pp2 _{2a} x14.40X electroless phos- phating, oiling, OCT3-2234-80	2	HRC ₃ 38.5 - 45.5

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2A42.06.050

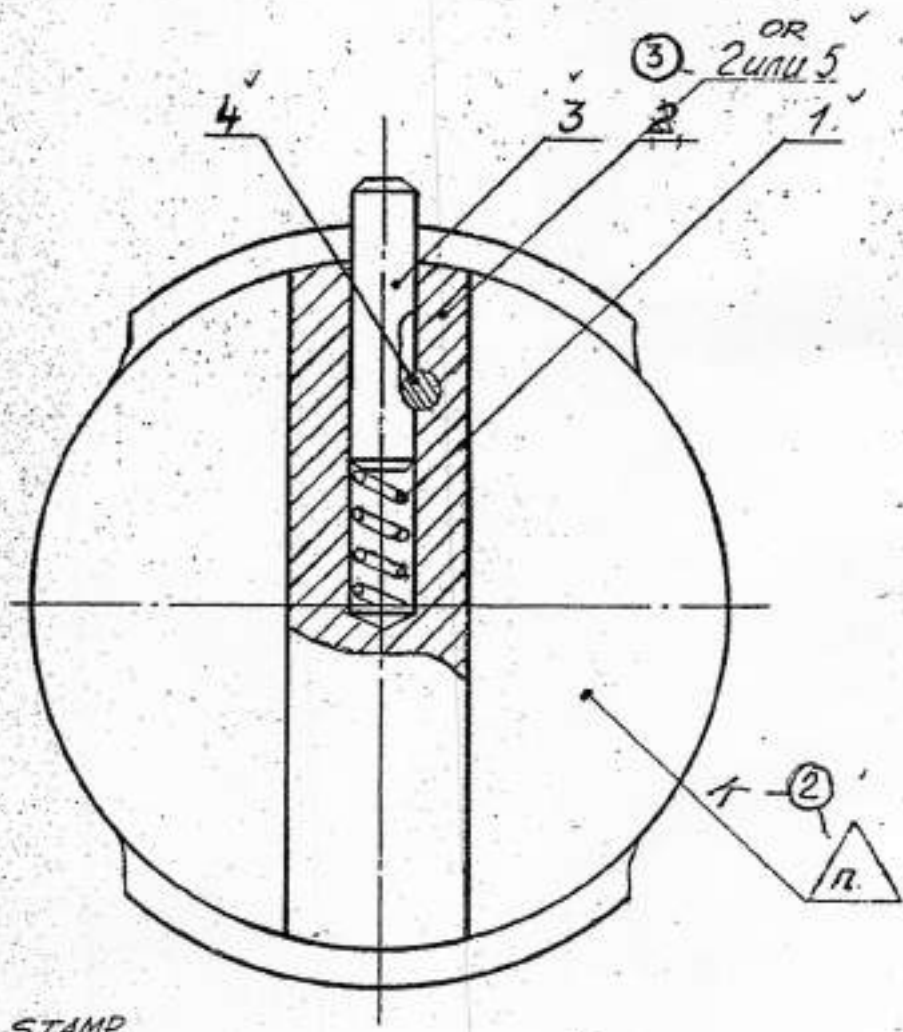
COVER

No.	Designation	Description	Qty	Remark
		<u>Documents</u>		
	2A42.06.050 CE	Assembly drawing		
		<u>Parts</u>		
1	2A42.06.032	Spring	1	
3	2A42.06.025	Rod	1	
4	2A42.06.026	Lockpin	1	
2	2A42.06.024	Cover	1	One pc may be replaced by Ref. No. 5
5	2A42.06.035	Cover		One pc may be replaced by Ref. No. 2

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Madu
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2A42.06.050CB



STAMP.

COVER
Assembly Drawing

Scale 2:1. Mass: 0.11

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DATE 15/2/93

UP DATED *[Signature]*

CHECKED *[Signature]*

FIM-PROJ 15/2/93

SCT *[Signature]*

DCM/PROJ *[Signature]* 15.02.93

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100, TRICHYRAIPAL - 601 004

2A42.06.050CB

COVER
КРЫШКА
ASSEMBLY DRAWING
СОБОРНЫЙ ЧЕРТЕЖ

ИТМ.	НОМЕР	ВИД ЧЕРТ.
202	0.11	2:1
АУСТ	АУСТ	

2-2042.0519-09/1000-0.02
 2A42.06.050CB
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 15.02.93

2A42.06.060

PLUNGER

No.	Designation	Description	Qty	Remark
		<u>Documents</u>		
	2A42.06.060 CE	Assembly drawing		
		<u>Parts</u>		
1	2A42.06.011	Plunger	1	
2	2A42.06.008	Pusher	1	
3	2A42.06.036	Bushing	1	
4	2A42.06.009	Ring	1	
5	2A42.06.032	Spring	1	
		<u>Standard Articles</u>		
6		Lockpin 2C ₃ x8.40X electroless phos- phating, oiling, OCT3-2234-80	1	HRC ₃ 38.5-45.5

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P. J. P. / 22
L. Vender
2/19/93

Uwe
15/2/93

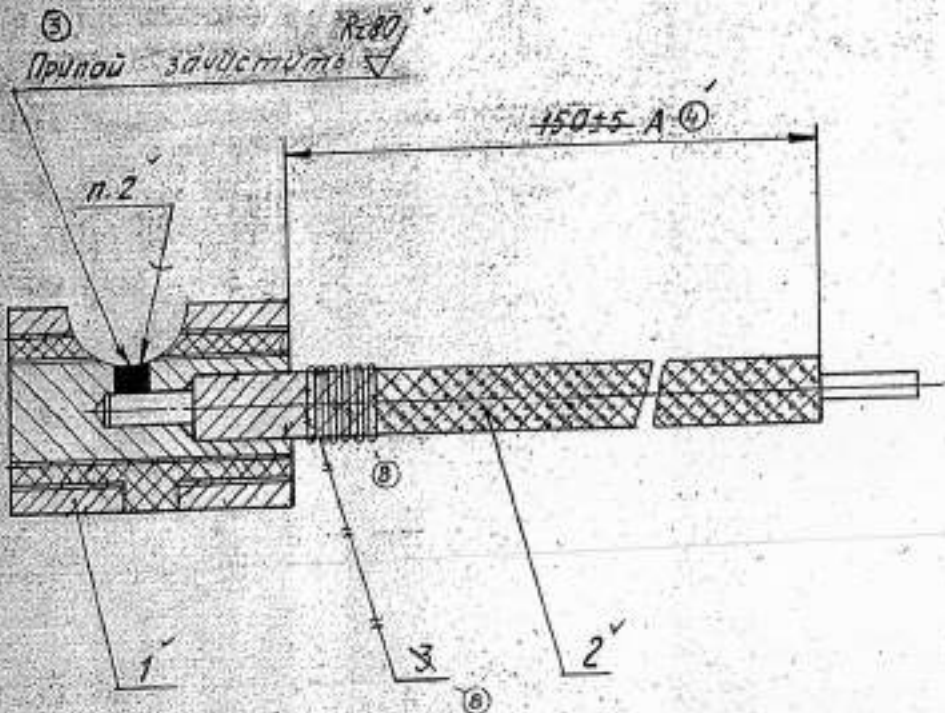
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CONTACT

Assembly Drawing



Scale 1:1. Mass: 0.01

- (1) 2. Solder with solder НОС-61, ГОСТ 21931-76, with flux РТМ-120, ТУ-84-406-73
3. Check for electric strength by a voltage of 500 V 50 Hz AC for 1 min
4. Insulation resistance should be 20 megohms, min., under normal climatic conditions. Measure resistance by megohmmeter with a voltage of 500 V
5. Stamp K on the lot tag
1. Refer to ГОСТ 23587-79 for technical requirements to construction of wire soldering and attachment of their conductors. Solder the wire according to variant 1.1, ГОСТ 23587-79

	Size A, mm
For upper feeding	110 ±10
For lower feeding	60 ±10

(3) Dress the solder

	Размер А, мм
Для верхней подачи	110 ±10
Для нижней подачи	60 ±10

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 YFGM-PROJ [Signature]
 S CT Корна Верна 15.02.93
 DGM/PROJ [Signature]

2A42

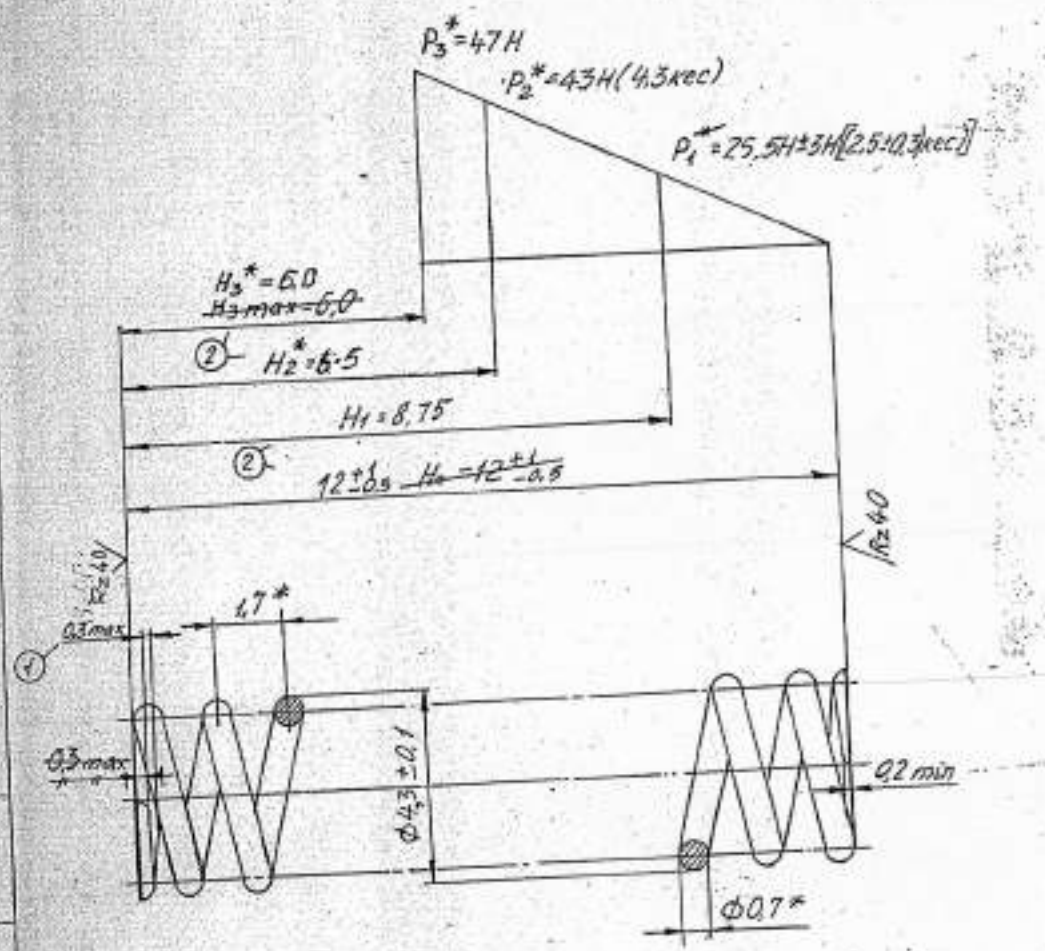
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CONTACT
 КОНТАКТ
 ASSEMBLY DRAWING
 Сборочный чертёж

Конт.	Масштаб	Контраст
0	0.01	1:1
Лист	Листов 1	

2A42.06.032

✓(✓)



SPRING

Scale 1:1. Material: wire I 0.7, ГОСТ 9389-75. Mass: 0.002

- (1) 1. $\sigma^x = 78400 \text{ MPa}$ (8000 kgf/cm^2)
2. $\tau_{3x} = 1617 \text{ MPa}$ (162 kgf/cm^2)
3. Refer to ГОСТ 16118-70, 2nd acc.cl., for specifications of manufacture, test and acceptance of springs
4. RH coiling
5. $n = 6.5$
6. $n_1 = 8.5_{-0.25}$
7. Thermal treatment: tempering at 240 to 260°C
8. $D_2 = 4.5A_5$
9. *Sizes and parameters for reference
10. Length of extended spring $L^x = 100 \text{ mm}$
11. Time of scrapping of the compressed spring: 24 h
12. Coating: accelerated electroless phosphating with chromate treatment and impregnation with adhesive 59-9, ГОСТ 12172-74, one layer
13. Stamp K and N on the let tag

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 27/9/91
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GATEWAY

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 CHECKED *[Signature]*
 P/M-PROJ. *[Signature]*
 S.C.T. COPY VERIFIED: *[Signature]* 12.08.91
 DGM/PROJ. *[Signature]* 26/8/91

2A42				
2A42.06.032				
SPRING				
Пружина		0,1	0,002	1:1

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 Gram: ASSURMET, ICHAPUR
 FAX No.: 2561-8395/ 8243
 e/mail: cqametichapur-dgqa@nic.in
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 To



Government of India
 Ministry of Defence (DGQA)
 Controllerate of Quality Assurance (Metals)
 PO-Ichapur-Nawabganj-743144
 24-Parganas(North), W.B
 Dated 21 Feb 2012

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Addl. GME	CFB
Jt. GW/	
1061	01/03/12

The Controller
 CQA (W)
 JABALPUR - 482011

SUGGESTION OF ALTERNATE INDIGENOUS MATERIAL

Ref: OFy, Tirchi letter No. 4850/D&DO/Ext dt 26.12.2011 (Copy enclosed)

2. On study of drawings of the items in question, the following nearest equivalent / indigenous alternate material for 7 Nos. of components are suggested subject to achievement of end use as well as OEM drg. and specification requirements.:

Sl No	Nomenclature /Drawing No	OEM specification and Grade	Comments / suggestion by CQA(Met)
1.	ROD / 2A42.06.003	OCT 2060-73 дКРН5НдЛС59-1	BS 2874-86 Desgn CZ 115
2.	PIN / 2A42.06.004	GOST 4543-71, 40X	IS 5517-93 Desgn 40Cr4
3.	DETENT / 2A42.06.019	OCT 3-98-80, 30XPA	IS 4367-91 Desgn 25Cr13Mo6
4.	SCREW / 2A42.06.023	OCT 3-98-80, 30X	IS 5517-93 Desgn 40Cr4
5.	ROD / 2A42.06.025	OCT 3-98-80, 30XPA	IS 4367-91 Desgn 25Cr13Mo6
6.	LOCK PIN / 2A42.06.026	GOST 4543-71, 40X	IS 5517-93 Desgn 40Cr4
7.	LEVER / 2A42.06.037	OCT 3-98-80, 30XPA	IS 4367-91 Desgn 25Cr13Mo6

3. For the components PUSHER (2A42.06.008), PLUNGER (2A42.06.011), PUSHER (2A42.06.016) and BUSHING (2A42.06.036) suitable indigenous equivalent alternate material not found, however OFT may be advised to manufacture the items as per OEM specifications.

4. Equivalent / alternate material suggestion for the rest components will be forwarded in due course.

Encl :As above (01 Sheet)

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 ORDNANCE FACTORY, TIRUCHIRAPPALLI - 620016

(S ROYCHOWDHURY)
 Asstt. Controller
 For Controller

Copy to :

- The SQAO
 SQAE(A)
 TIRUCHIRAPPALLI- 620016
- The General Manager
 Ordnance Factory
 TIRUCHIRAPPALLI- 620016

E mail : oft_ofb@nic.in

* ---It is intimated that such cases may be forwarded through the end store AHSP / resident SQAE.
 * ---Indigenous alternate material will be incorporated by the end store AHSP after satisfactory performance / feedback.

160
 4/3

OIC/DDO

Sm. DT

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3/3/12