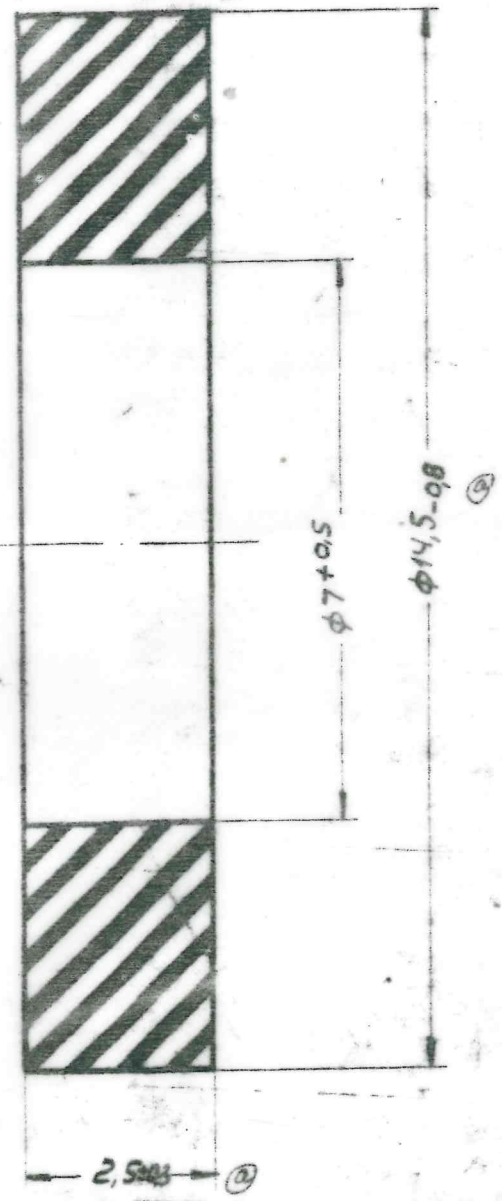


127-22

2



SLNO	SHEET	DOCNO	SIGN	DATE
DRAWN BY		BHUSHAN		11.5.84
EDITED AND CHECKED BY		B. B. Sarvesh	Reddy	14.5.84
FOREMAN OF DC		S.H. RAO	Er	3/6
DIVISIONAL OFFICER		<i>[Signature]</i>		4/6
		NAME	SIGN	DATE

GASKET.

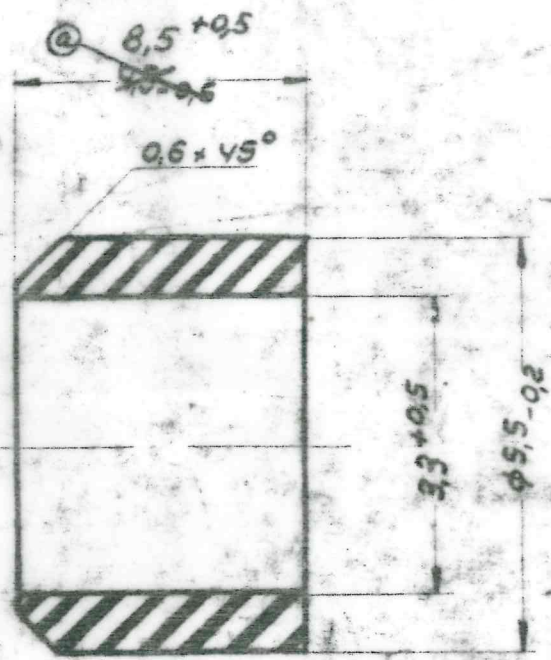
Rubbe H0.68.1 Ty38005-1166-73.

127-22

SHEETS	WEIGHT	SCALE
On A	0.36	10:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

127-24

2



S/NO	SHEET	DOC NO	SIGN	DATE
DRAWN BY	BHUSHAN			11.5.84
EDITED AND CHECKED BY	B. B. Sankar			14.5.84
FOREMAN OF DC	S.H.RAO			3/6
DIVISIONAL OFFICER	D.A.M.			4/6

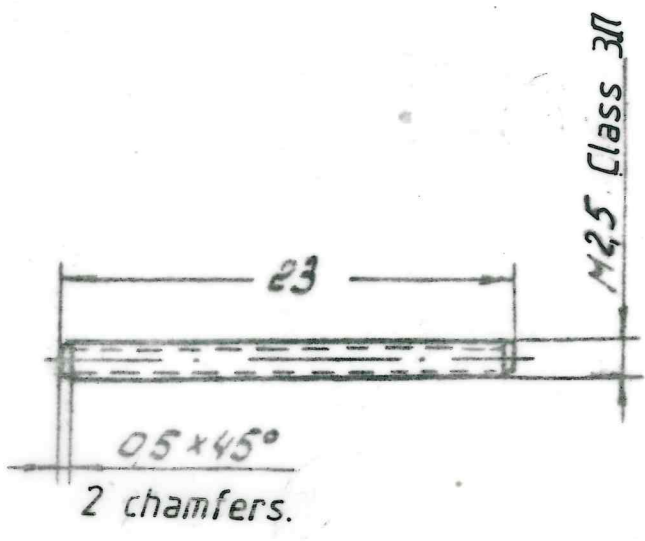
TUBE.

Rubber HO-68-1

127-24		
SHEETS	WEIGHT	SCALE
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT		

127-25

▽ 5 ALL OVER.



- 1). Tolerance on free dimensions are as per 722AT.
- 2). Thread before coating as per 214AT.
- 3). Coating: Cadmium 6 microns chromatised.

127-25

SN/SH	DOC NO	SIGN	DATE
DRAWN	BHUSHAN		11.5.84
EDT/CHKD	B. Sarwan	B. Sarwan	14.5.84
F/M, DC.	S.H. RAO	S.H. RAO	3/6
DIV. OFFR	D.A. Bhatt	D.A. Bhatt	4/6
	NAME	SIGN	DATE

STUD.

Cm A12 GOST 1414-75.

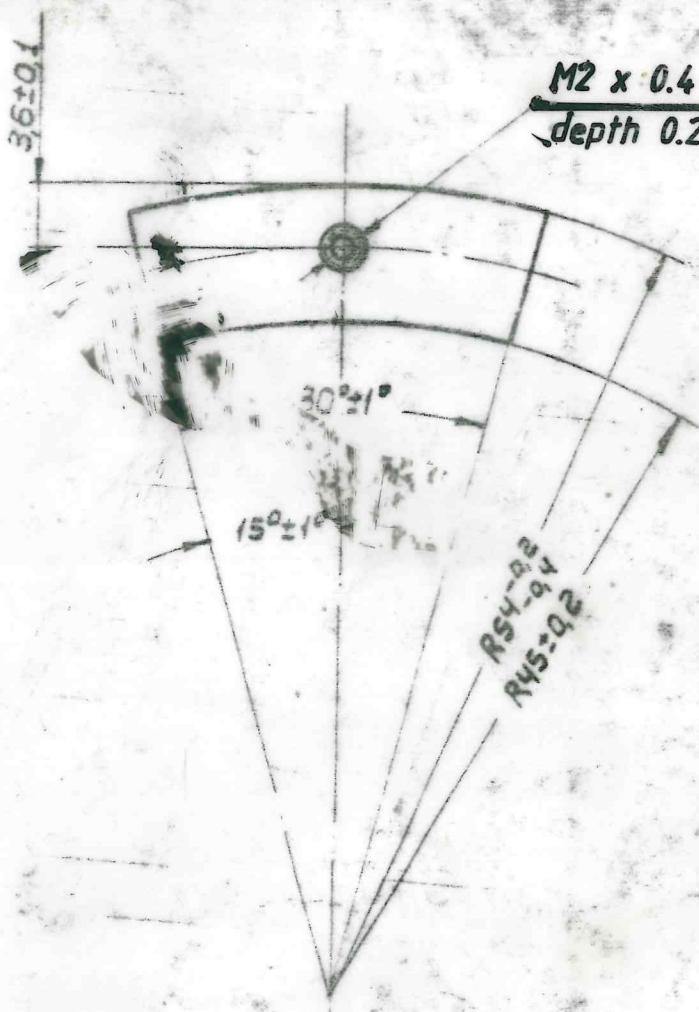
SHEET	WEIGHT	SCALE.
	0.662	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

127-39

R280/(V)

Coating: Cadmium, 9 microns, chromatised.

M2 x 0.4 Counter sink
depth 0.2 L 90°.



127-39

SNO	SHT	DOC NO	SIGN	DATE
	DRAWN	P.R.BABU		17.5.04
	EDT,CHKD	D.K.JAIN	<i>[Signature]</i>	18.5.04
	F/M,DC.	SHRAO	<i>[Signature]</i>	2/6
	DIV.OFFR	D.A. Ashu	<i>[Signature]</i>	<i>[Signature]</i>
	NAME	SIGN	DATE	

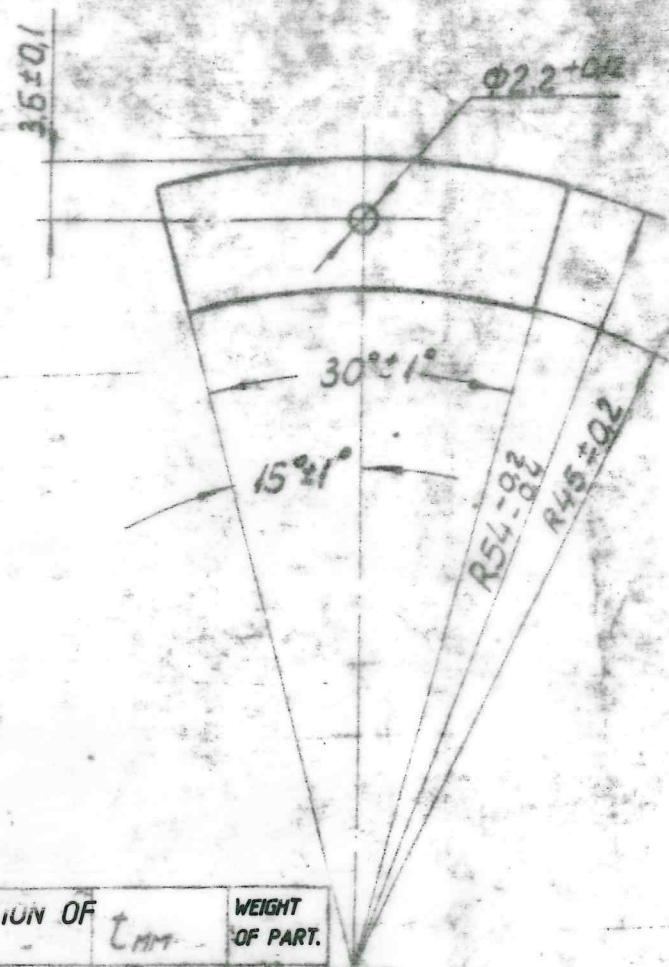
LOAD

Steel 20,
FOCT 16523-70.

SHEET WEIGHT SCALE.		
A	3.39g	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

127-40:43

R280/√(✓)



DESIGNATION OF PART.	t_{mm}	WEIGHT OF PART.
127-40	1	1,67 ₂
127-43	0.5	0,85 ₂

Coating: cadmium, 9 microns. chromatised.

Српсб. №
Додн. уџава
УМБ. №

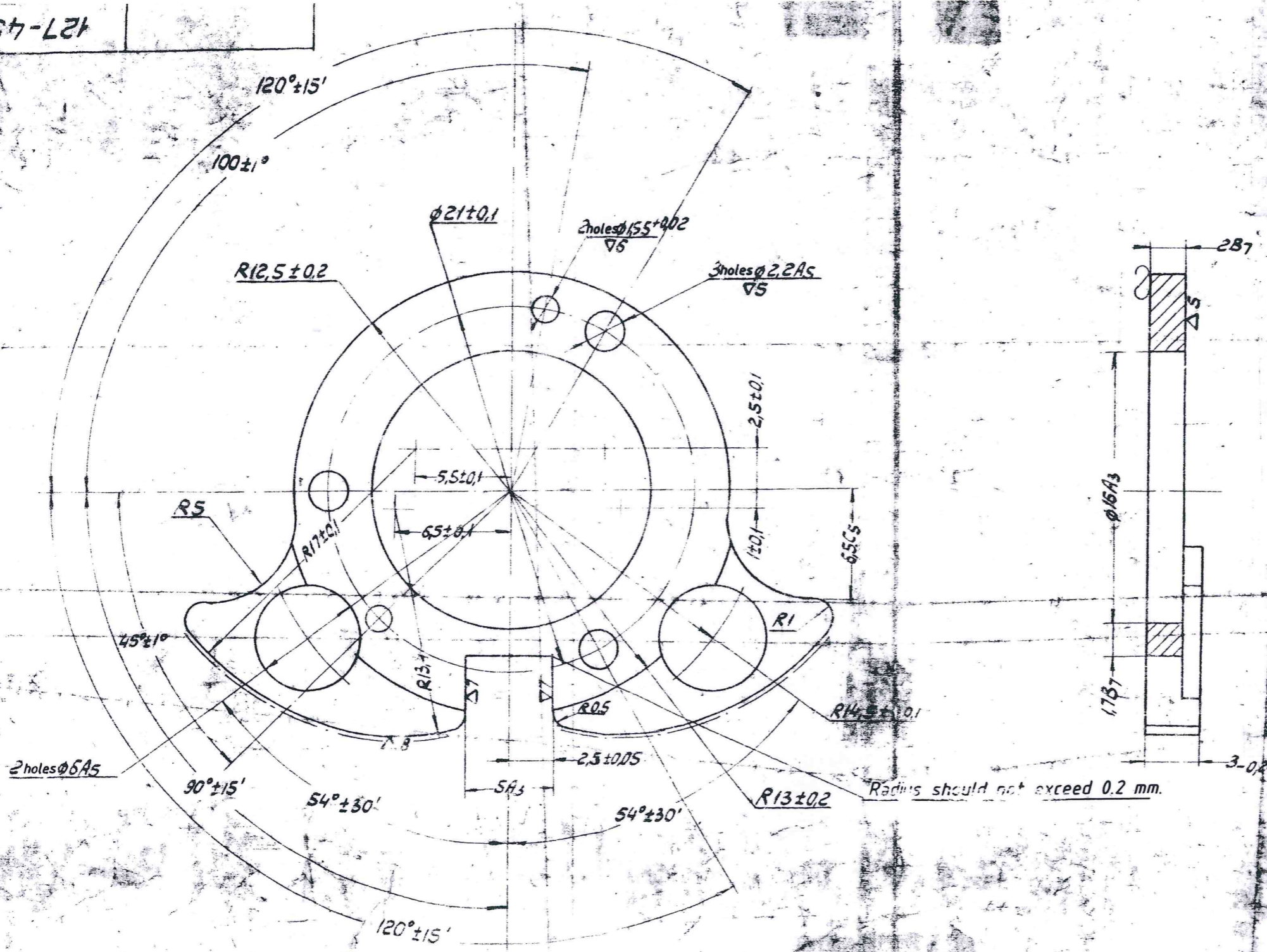
SINO	SHEET	DOCNO	SIGN	DATE
DRAWN BY		BHUSHAN		19.5.84
EDITED AND CHECKED BY		D.K. JAIN		24.5.84
FOREMAN OF DC		SARATHI		26
DIVISIONAL				

LOAD.

127-40:43		
SHEETS	WEIGHT	SCALE
A		2:1
TOTAL SHEETS		

127-45

▽4 Unless otherwise specified



1. Perform dimensions 5A₃ and φ 16 A₃ consist coating.
2. Polish surfaces indicated with _____ after coating. Cross sectional notches are r
3. Check profile of cam surface, indicated with _____ as per standard.
4. Blunt sharp faces by R 0.2 or with chamfe

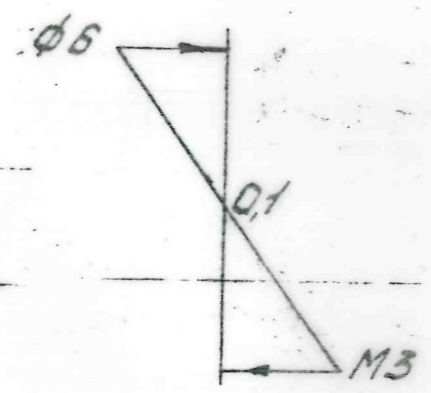
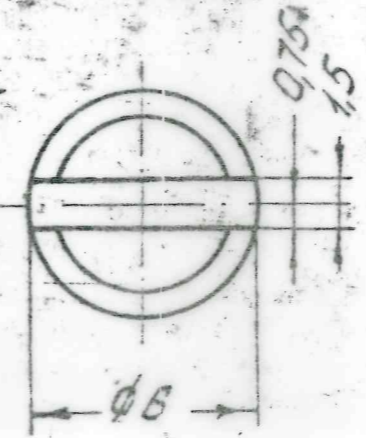
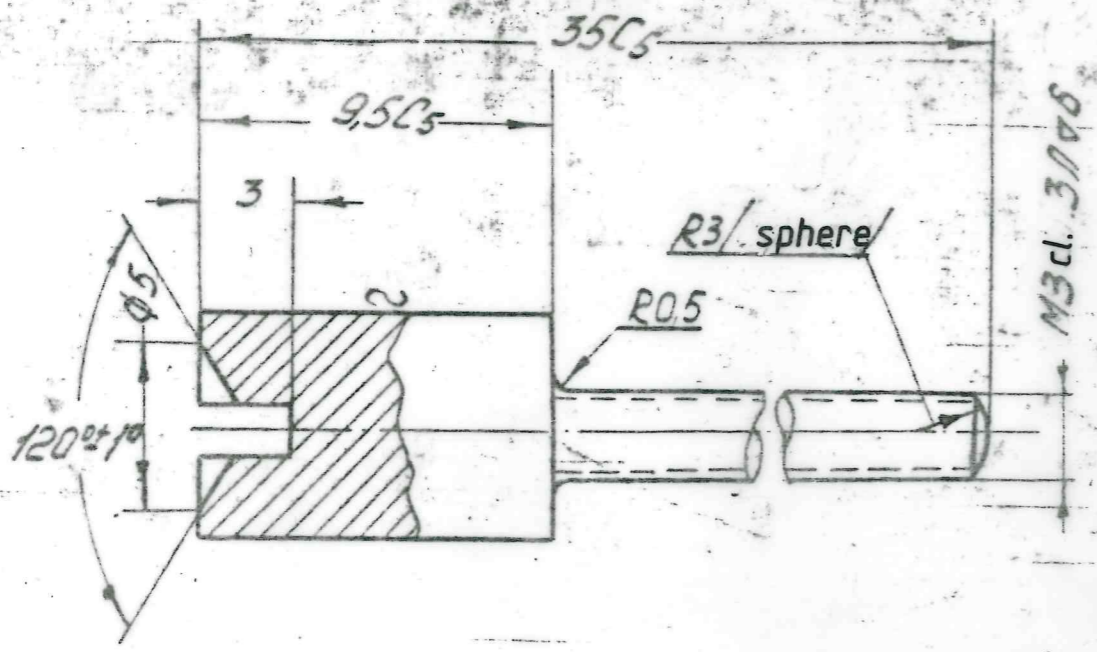
Coating: Chromium, 9 microns

NO	SHEET	DOCNO	SIGN	DATE	CAGE CAM	SHE
DRAWN BY		P.R.BABU		19.5.84		
EDITED AND CHECKED BY		D.K. JAIN		24.5.84		
FOREMAN / DC		S.H.RAO		24.5		
VISIONAL OFFICER		D.A. GANESH		2/6		
NAME		SIGN	DATE	ГОСТ 931-78		ORDN
				Sheet ДПРП 163		

2700

▽ 5 Unless otherwise specified

127CN



- 1) Tolerances on free dimensions are as per 722AT.
- 2) Chamfer 0,3x45° may be provided instead of sphere-R₃.
- 3) Heat treatment upto MV = 234 to 268.
- 4) Threads before coating as per 214AT.

Coating / Cadmium, 9 microns,chromatized.

127-46

				SHEET	WEIGHT	SCALE
NO. SH	DOC NO	SIGN	DATE	4	2.8g	5:1
DRAWN	Y.R.Ganesh	<i>YRG</i>	17.5.84	SPECIAL SCREW Steel 45 TY 14-1-2330-77.		
EDT,CHKD	D.K.JAIN	<i>DKJ</i>	18.5.84			
F/M,DC.	S.H.RAO	<i>SHR</i>	1/6			
DIV.OFFR	D.A.	<i>DA</i>	2/6			
	NAME	SIGN	DATE	TOTAL SHEETS ORD NANCE FACTORY PROJECT HYDERABAD		

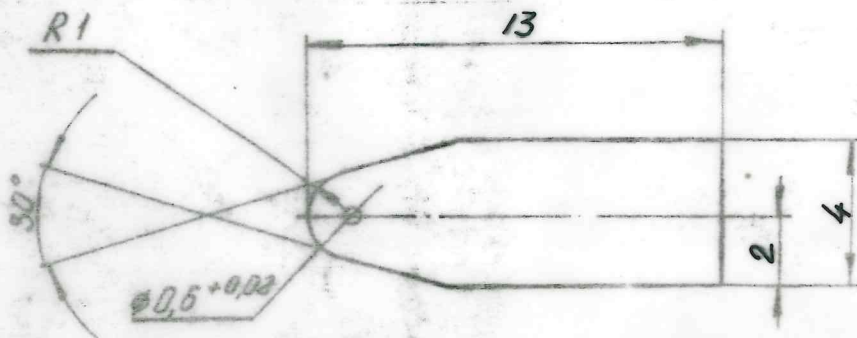
D130-121

87-171

55

Direction of rolling

$0.1^{+0.005}_{-0.01}$



- 1) Tolerances on free dimensions are as per 722AT.
- 2) Age-hardening, $H_v \geq 330$.
- 3) Part is made by rolling.

SLNO	SHEET	DOCNO	SIGN	DATE
DRAWN BY		Y.R.Ganesh		14.5.84
EDITED AND CHECKED BY		B. B. Sarkhel		17.5.84
FOREMAN OF DC		S.H.RAO		24/6
DIVISIONAL OFFICER		D.A. Sankar		18/01/86
		NAME	SIGN	DATE

CONTACT SPRING.

Bronze БрБ2-М ГОСТ 1789-70, Band 0.15x200-H

127-48

SHEETS	WEIGHT	SCALE
A	0.032	5:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

D/30-122

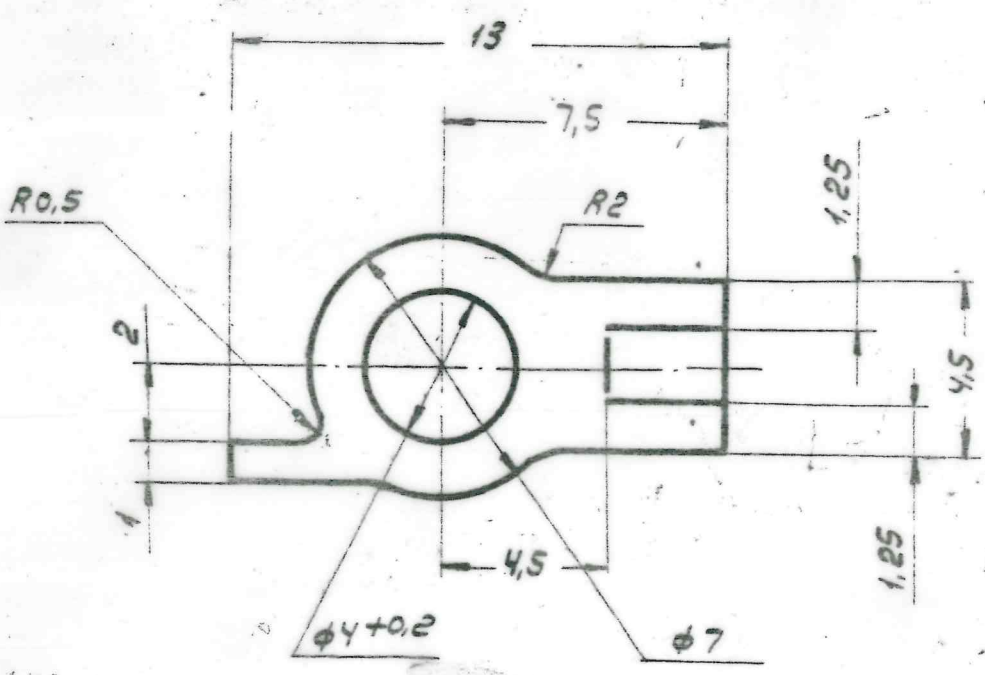
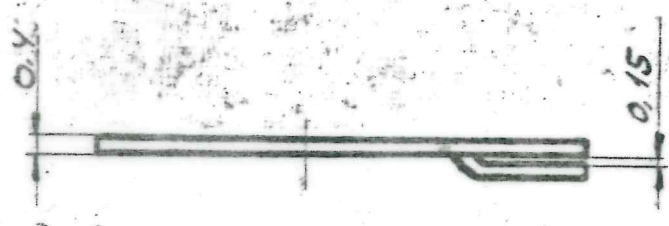
127-49

Part No. 127-49
Material

1:10
1:20
1:50

0-81198819

Unless otherwise specified



Tolerances on free dimensions are as per 722AT.

SLNO	SHEET	DOCNO	SIGN	DATE
DRAWN BY	Y.R.Ganesh			14.5.84
EDITED AND CHECKED BY				
FOREMAN OF DC	S.H.A.C. Sr			1/6
DIVISIONAL OFFICER	P.A. Srinivas			9/6
NAME	SIGN	DATE		

CONTACT

Band d, npHT 0,4 n 63
GOST 2208-75

127-49

SHEETS WEIGHT SCALE

0,145g 5:1

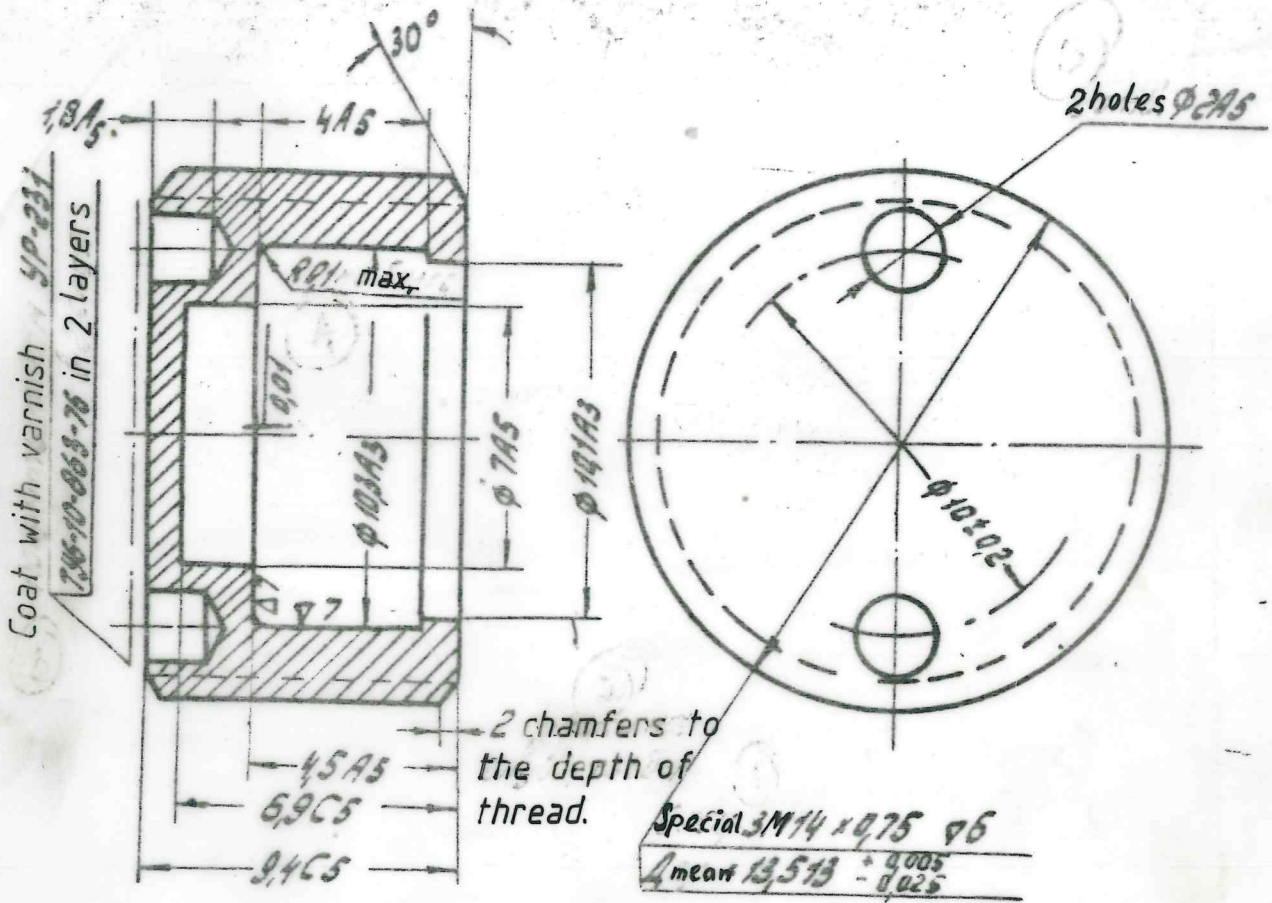
TOTAL SHEETS

ORDNANCE FACTORY PROJECT
HYDERABAD

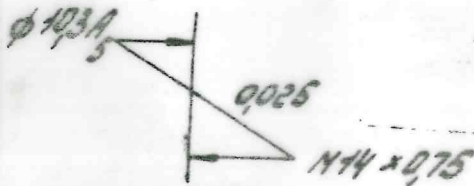
127-50

▽5

Unless otherwise specified

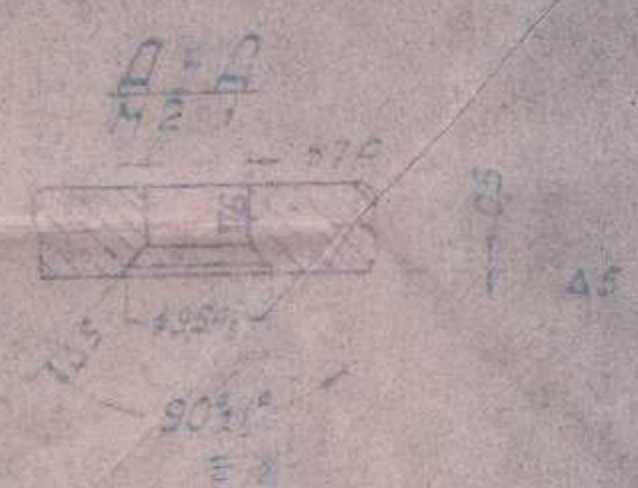


Protect 2 holes φ 2.45 from varnish YP-231.

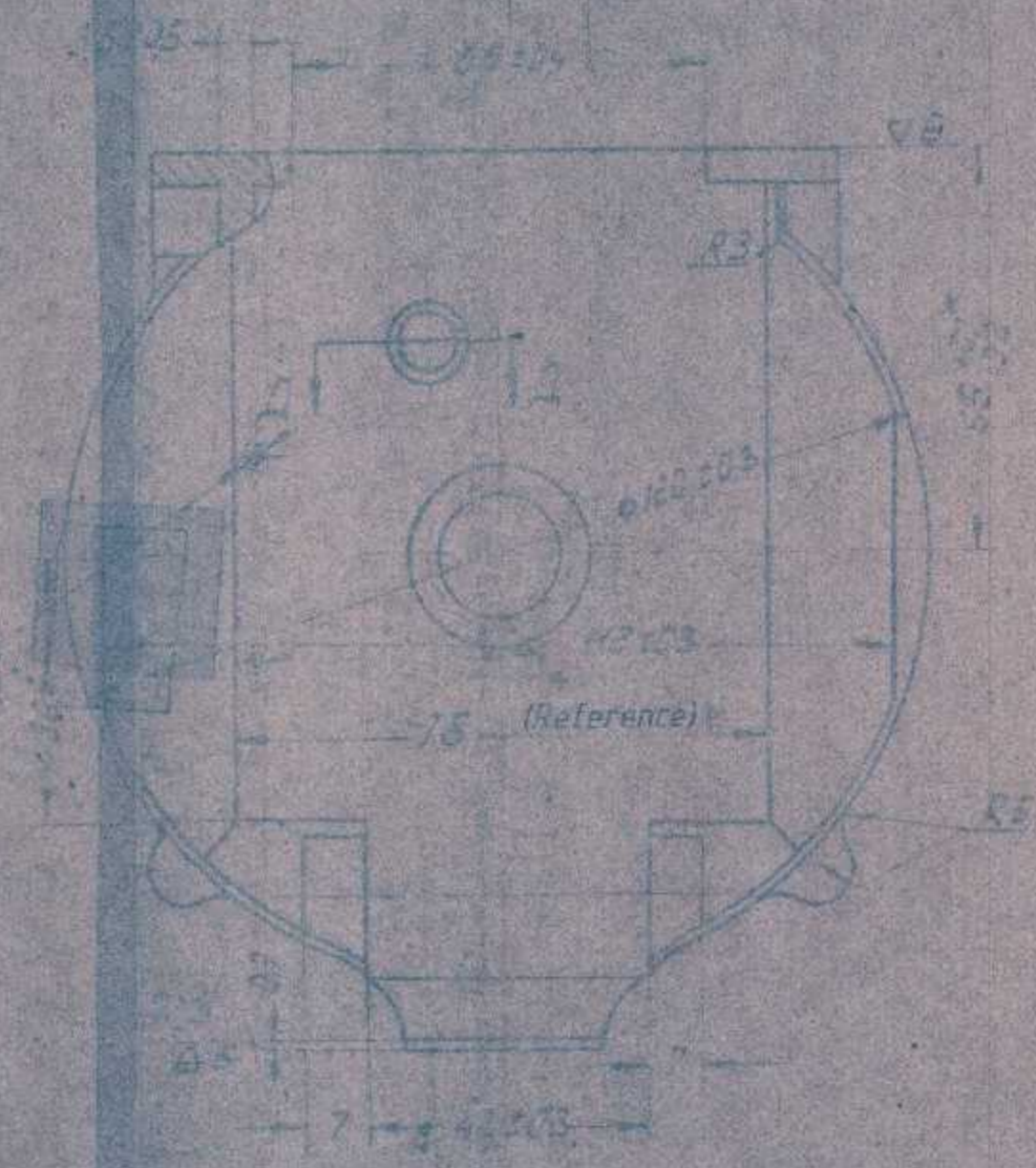


				Coating	Anodically oxidised, chromatised.												
SLNO	SHEET	DOCNO	SIGN	DATE	<p>127-50</p> <p>BUSH</p>												
DRAWN BY	Y.R.Ganesh			16.5.84													
EDITED AND CHECKED BY	D.K.JAIN			17.5.84													
FOREMAN OF DC	S.H.RAO			1/6													
DIVISIONAL OFFICER	D. Srinivasulu Reddy																
				BAR BIT GOST.21488-76.	<table border="1"> <tr> <th>SHEETS</th> <th>WEIGHT</th> <th>SCALE</th> </tr> <tr> <td>A</td> <td>289</td> <td>3:1</td> </tr> <tr> <td colspan="3" style="text-align: center;">TOTAL SHEETS</td> </tr> <tr> <td colspan="3" style="text-align: center;">ORDNANCE FACTORY PROJECT HYDERABAD</td> </tr> </table>	SHEETS	WEIGHT	SCALE	A	289	3:1	TOTAL SHEETS			ORDNANCE FACTORY PROJECT HYDERABAD		
SHEETS	WEIGHT	SCALE															
A	289	3:1															
TOTAL SHEETS																	
ORDNANCE FACTORY PROJECT HYDERABAD																	

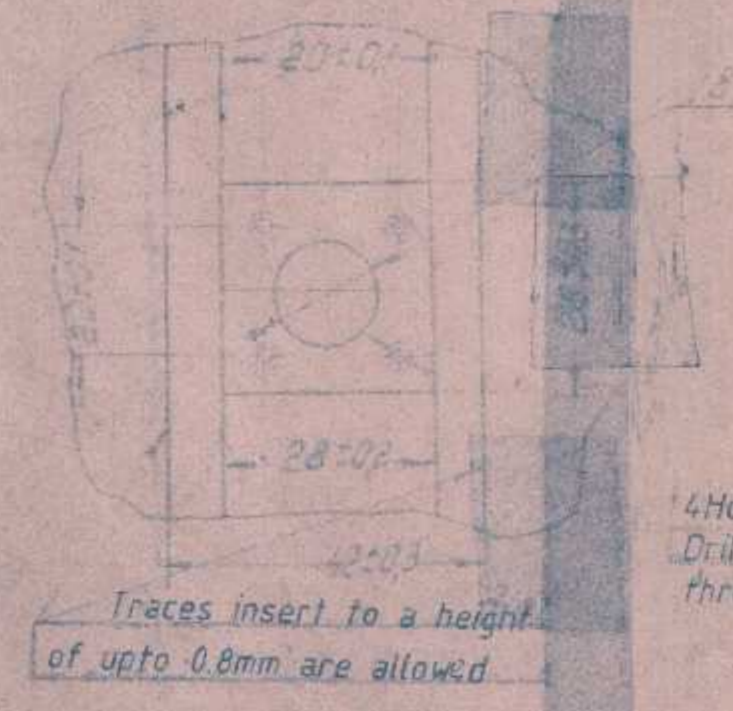
D130-124



2 Holes M3 cl 2 V6 counter sink $\phi 3.3 \angle 120^\circ \nabla 5$ on opposite side

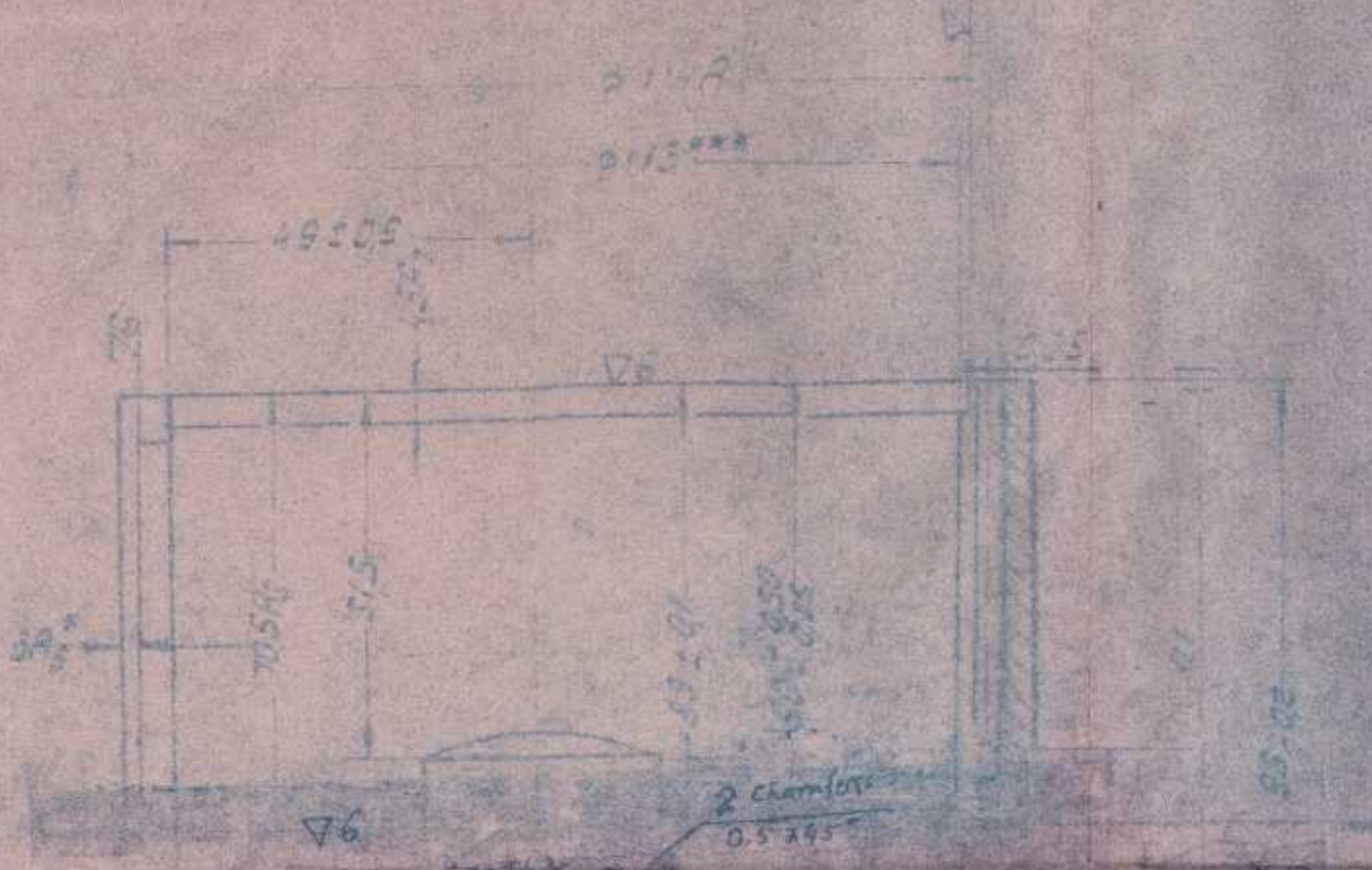


View - 2



4 Holes M3 cl 2 counter sink $\phi 3.3 \nabla 6$ Drill to a depth of 6.5A, Depth of threading 5A, $\nabla 5$

Traces insert to a height of upto 0.8mm are allowed



Loose sharp edges (with out burrs)

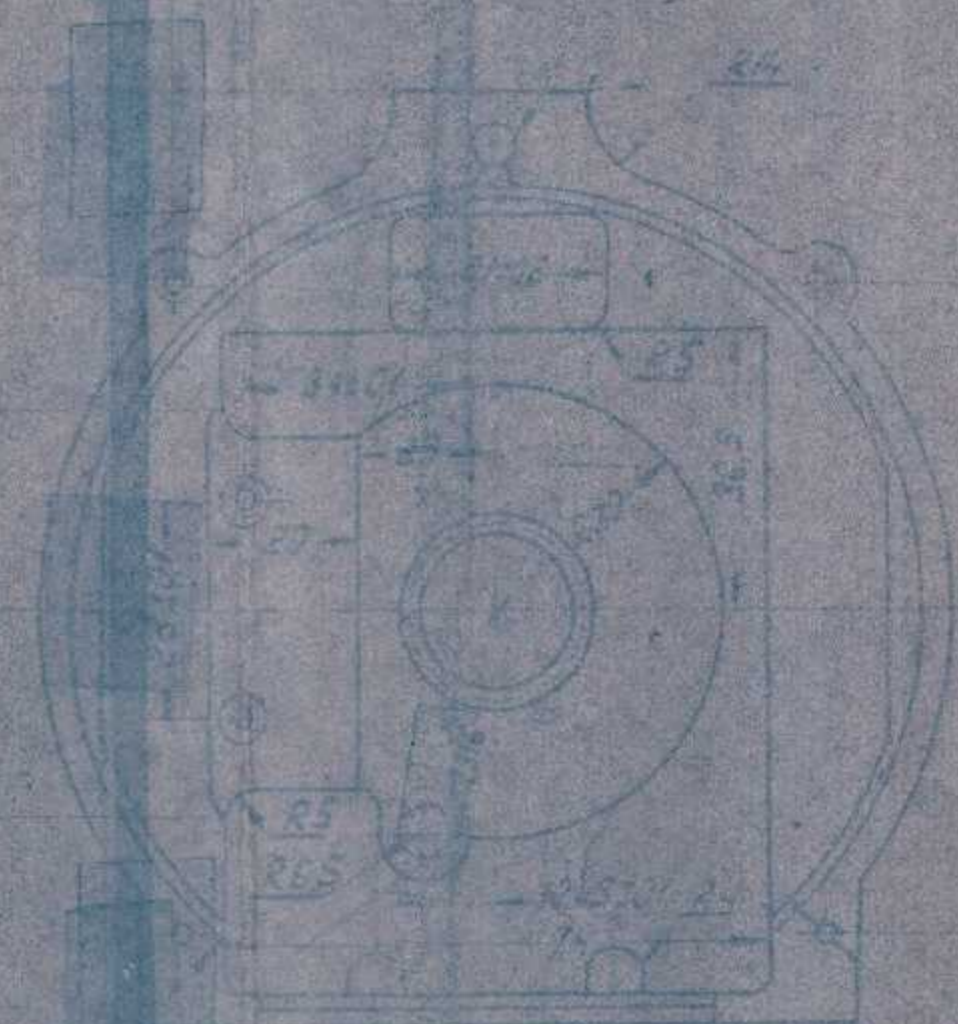
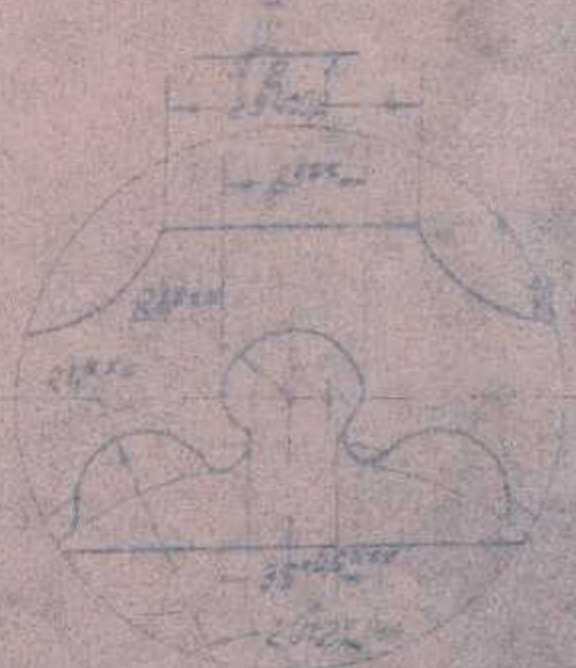
2 Holes M3 cl 2 V6 counter sink $\phi 3.3 \angle 120^\circ \nabla 5$

2 Holes $\phi 1.8 \nabla 6$

4 Holes M3 cl 2 V6 counter sink $\phi 3.3 \angle 120^\circ \nabla 5$ Drill to a depth of 6.5A, Threading depth 6.5A

2 Holes counter sink $\phi 7 \angle 120^\circ$

Remove sharp edges



4 Holes M4 cl 2 V6 Counter sink $\phi 4.3 \angle 120^\circ \nabla 5$ Drill to a depth of 10.5A, Threading depth 7.05

Step not exceeding 0.05mm is allowed

- 14) Grind surface A
- 15) Machining of 2 holes - $\phi 18 \pm 0.1$, R5 with dimensions 29.5 ± 0.2 , 10 Holes - M3, hole $\phi 18.5A_5$ and surface r are carried out during assembly 127-cb24.

- 1) Pressure die casting class of accuracy IT-3 is as per OST 141154
- 2) Sand blasting
- 3) Pattern drafts is 30' along the external contour towards decreased dimensions, 45' along the internal counter towards increased dimensions
- 4) Perform unspecified casting radii by a radius not exceeding R2
- 5) Tolerance on free casting radii are ± 1 when R is upto 4, ± 1.2 when R is above 4.
- 6) Ageing is performed after at $t=290 \pm 10^\circ c$ for 4hrs, and at $t=60^\circ c$ for 2hrs.
- 7) *Machining of $\phi 80A3, \phi 74A5, \phi 39A5, 3A5, 55^{+0.1}_{-0.05}, \phi 24, \phi 67 \pm 0.1, 3A5$, and $M20 \times 0.75$ is carried out in assembly.
- 8) Tolerances on free dimensions are as per 722 AT.
- 9) Deviation of symmetrically arranged elements with respect to axis of symmetry should be in the limits of tolerance on dimensions.
- 10) Part may be made from A/J -9 with surface finish $\nabla 5$ instead of $\nabla 6$
- 11) Technical requirements are as per OST 180020-71 (2nd group) and according to standard.
- 12) ** Difference in dimensions for two holes by M6 should not exceed 0.05mm.
- 13) *** Pattern drafts of dimensions at 45' towards decreased dimensions.

SHEET NO.	DOC NO.	SIGN.	DATE
1		BHISHAN	23.5.86
DRAWN BY			
EDITED AND CHECKED BY			
FOREMAN OF DC			
DIVISIONAL OFFICER			
Alu Alloy A/J2 GOST 2685-75			

127-34

BODY

SHEETS WEIGHT SCALE

TOTAL SHEETS

GEORGE FACTORY, PROJECT HYDERABAD