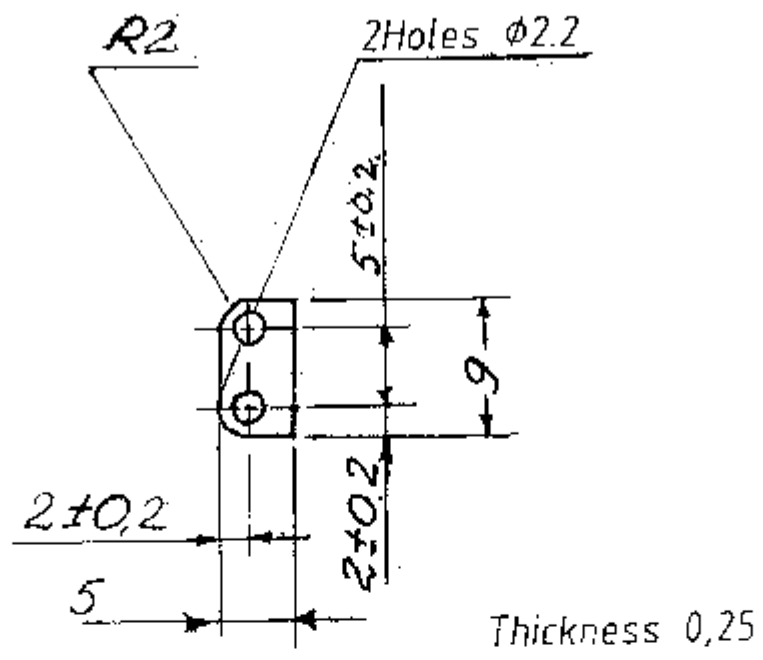


765-96-121

2



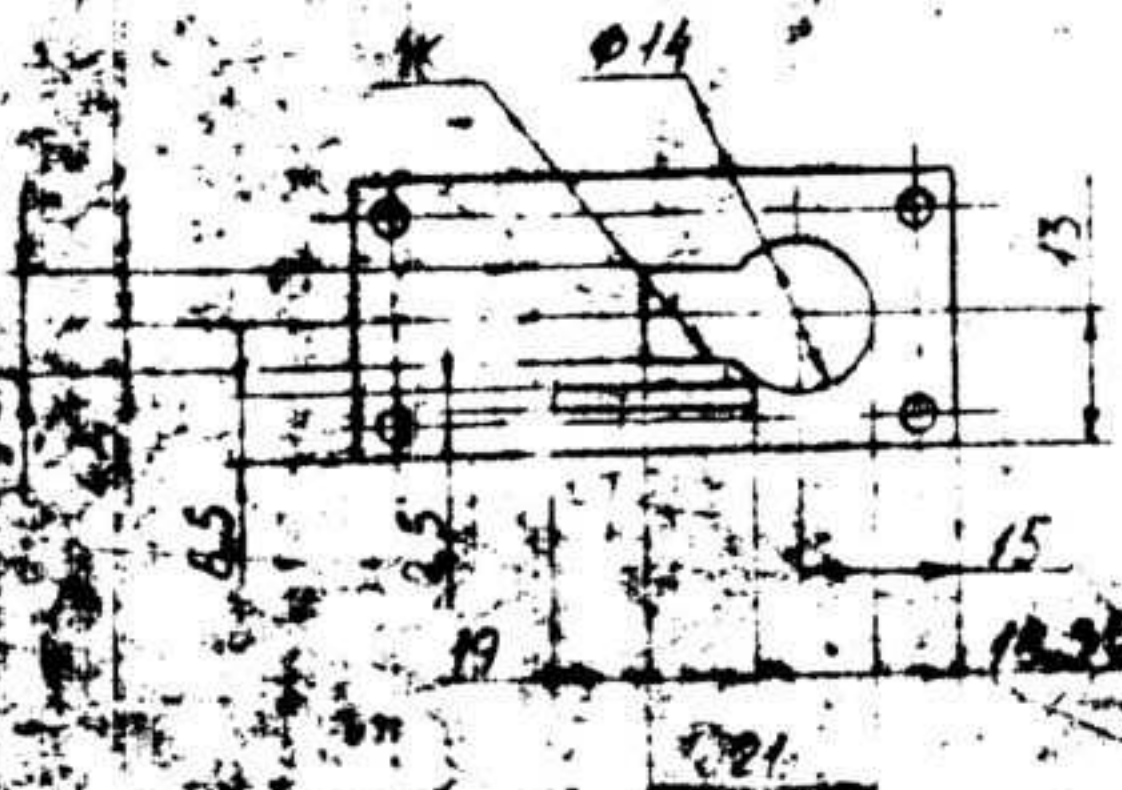
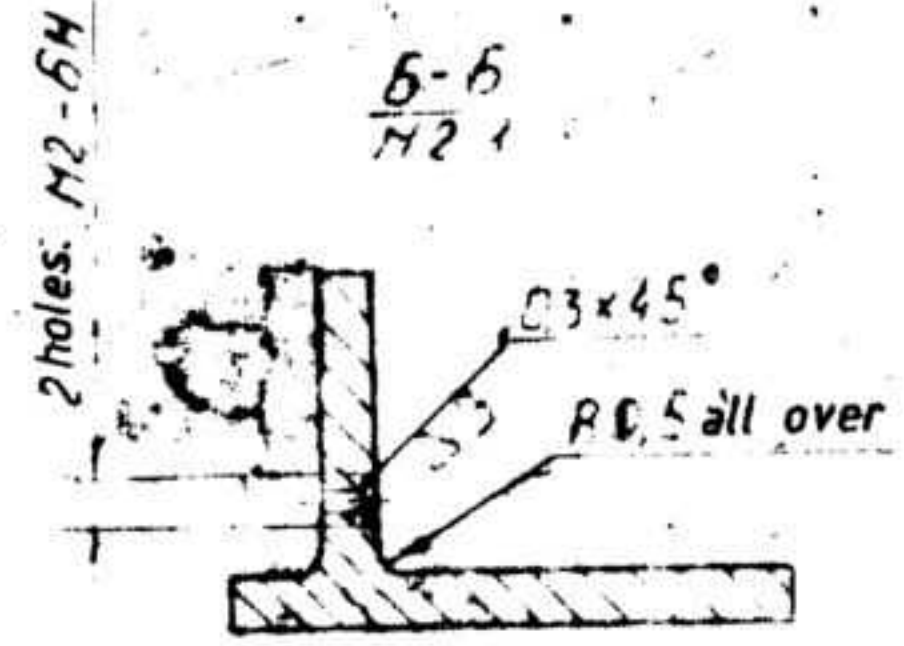
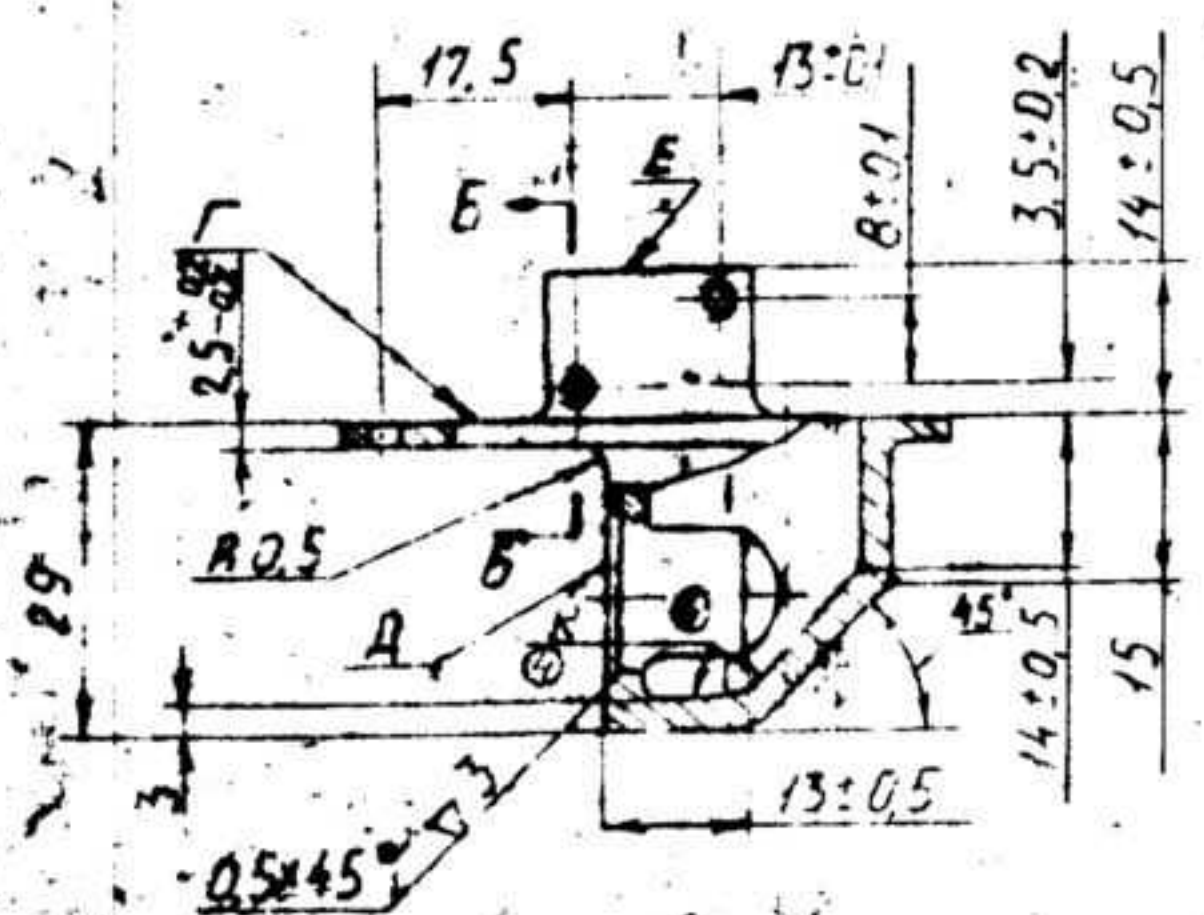
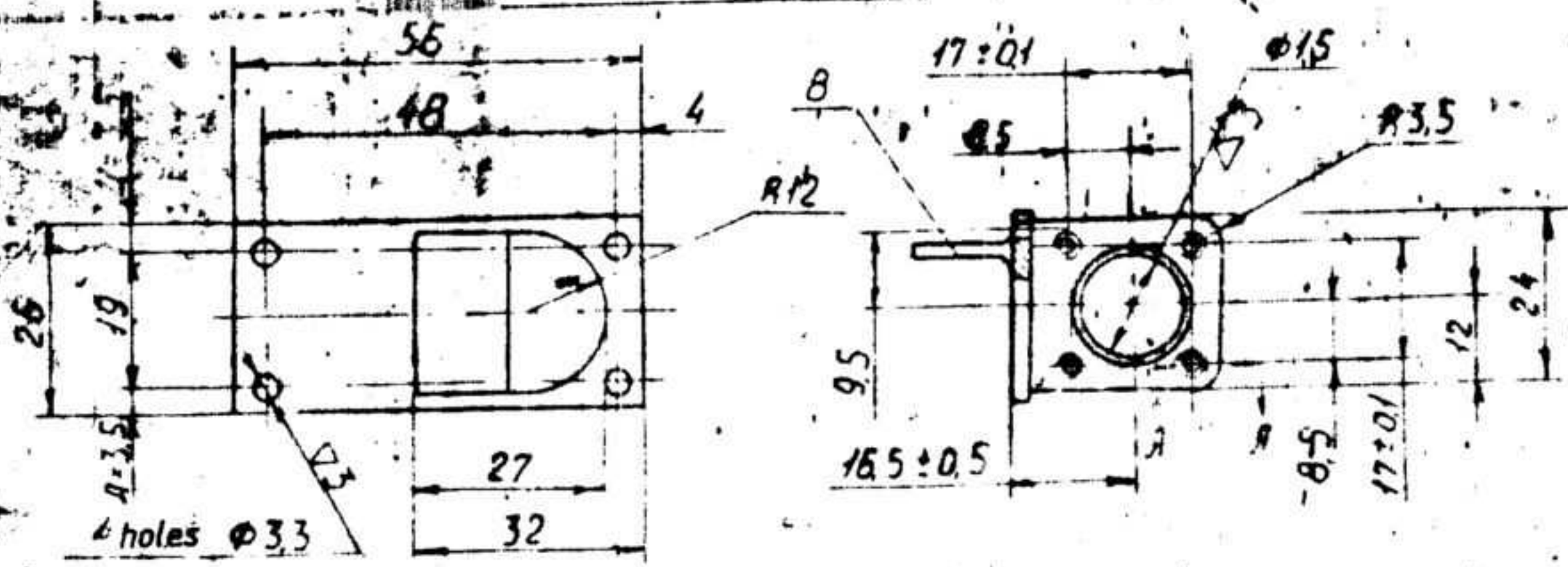
1. Blunt sharp edges.
 2. Perform dimensions without deviations with accuracy class 7, OST 1010.
- Ⓐ EQ. MATERIAL - CB 101 TO BS:2870-68 W(H) CONDITION

00757-12V VERIFIED 17-1-2000	Ⓐ Am	EQ. MATERIAL IS ADDED IN THE DRAWING
DCU/NO DATE	ISSUE	NATURE OF AMENDMENTS

APPROVED	M. YASU	765-96-121		
CHECKED	DSKUMAR			
CONTROLLERATE OF INSPECTION (ICV)	GASKET		WEIGHT	SCALE
			0.00006	2:1
			SHT	SHTS
	BAND 0.25 - EPB 2T FOCT 1789-70	10	371 of 413	

765-96-59L

Unless otherwise specified.



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 A19. GOST 2685-75.
8. Coating: Anodically oxidized, chromated or chemical parkerized, blue.
9. Apply primer Ф1-03 Ж, GOST 9109-76, all over; except holes of jaw B and surfaces Г and А, paint with enamel M1-12, grey GOST 9754-76, and enamel M1-165 (former M1-25) 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.

765-96-143

DRAWN		SIGN		DATE	
EDT.CHKD		SIGN		DATE	
F/M,DC		SIGN		DATE	
DIV.OFFR		SIGN		DATE	
NAME		SIGN		DATE	

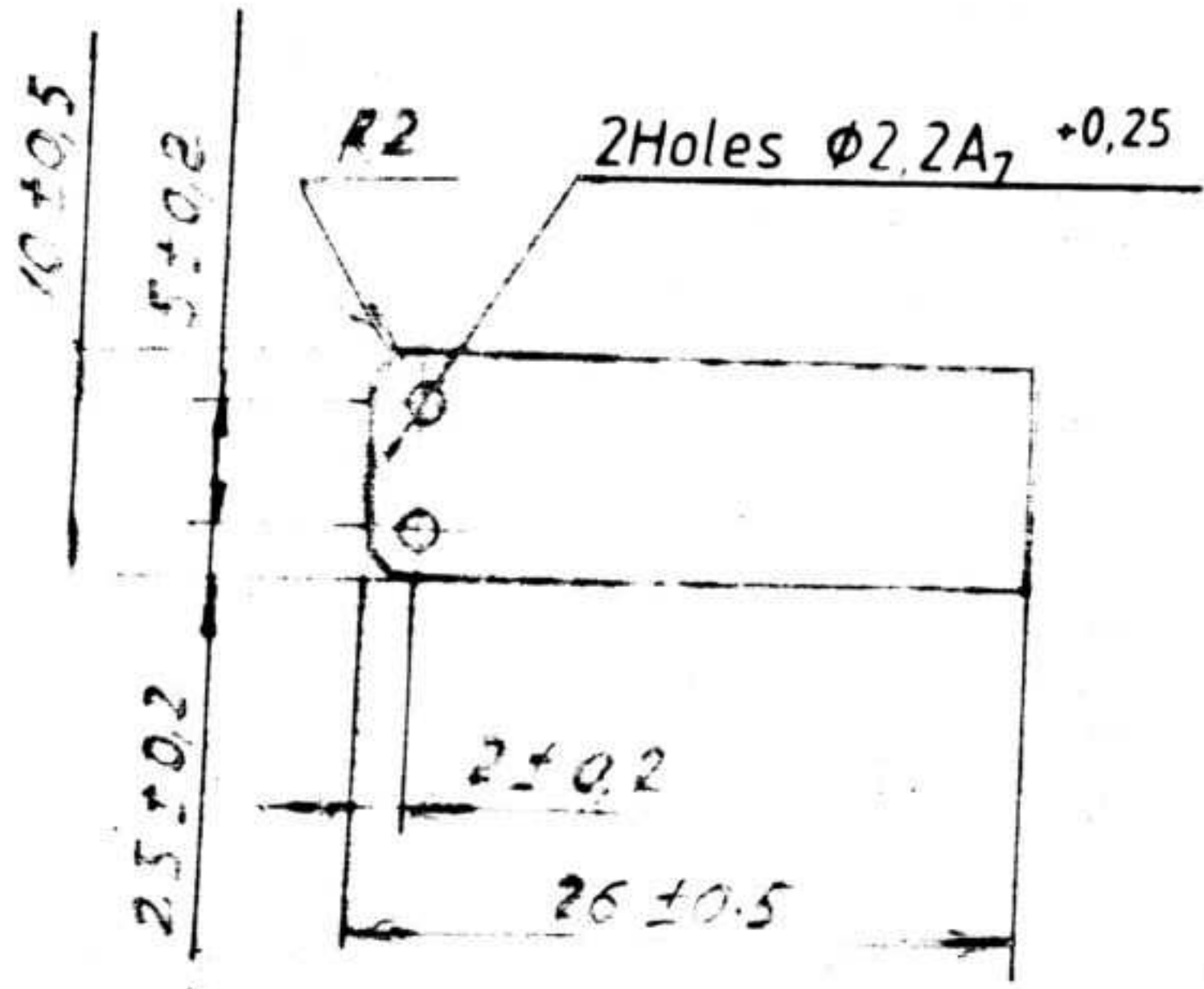
COVER

AA2 GOCT 2685-75

SHEET WEIGH SCALE

TOTAL SHEETS

151-96-991



Thickness 0.25

1. Blunt sharp edges.
2. Hardness as per Vicker is 350.

765-96-151

SNOSHT	DOC NO	SIGN	DATE
DRAWN	CHV.RAB	<i>[Signature]</i>	11.7.84
EDT,CHKD	A.R. DUBEY	<i>[Signature]</i>	12.7.84
F/M,DC.	S.R. NAIN	<i>[Signature]</i>	12.7.84
DEV.OFFR	T.K. BANERJEE	<i>[Signature]</i>	12.7.84
	NAME	SIGN	DATE

<h1>PLATE</h1>	SHEET	WEIGHT	SCALE
TOTAL SHEETS			
ORDNANCE FACTORY PROJECT HYDERABAD			

BAND 0.25 - БрБ2-Т,
ГОСТ 1789-70

765-90-152

2Holes $\phi 2.2A_7^{+0.25}$



Thickness 0.25

- 1, Blunt sharp edges.
- 2, Hardness as per Vicker test is 350 min.

765-90-152

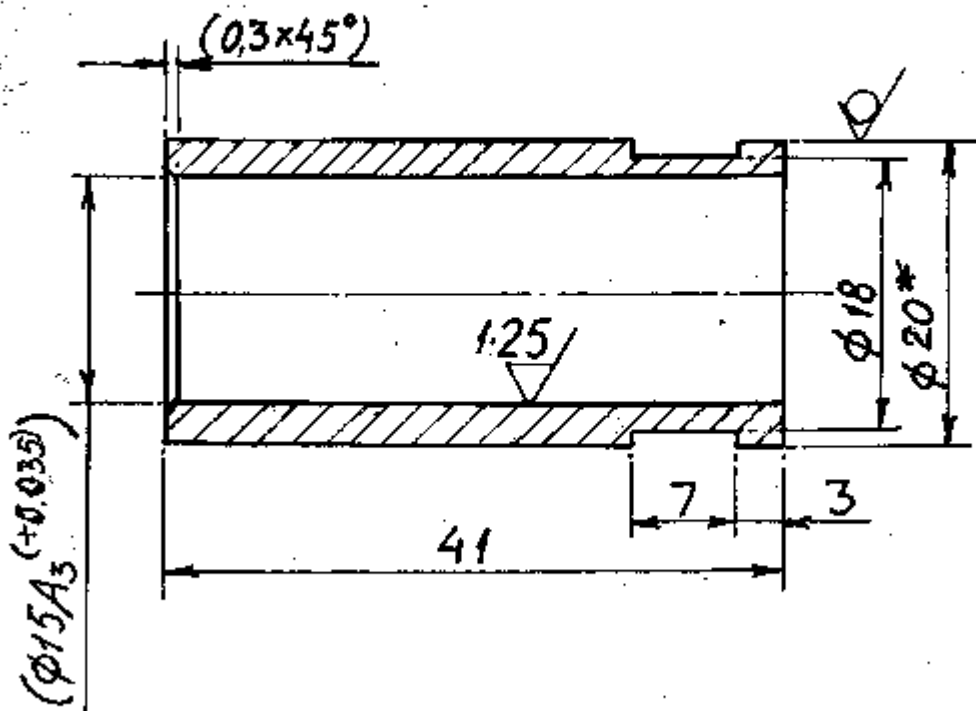
PLATE

BAND 0.25-БрБ2-Т,
ГОСТ 1789-70.

HYDRAHAD

SNOSH	DOC NO	SIGN	DATE
DRAWN	CH.V.RAO	<i>Ch.V.Rao</i>	11.7.84
EDT,CHKD	M.K.DUBEY	<i>M.K.Dubey</i>	12.7.84
F/M,DC	S.R.NAIR	<i>S.R.Nair</i>	12.7.84
DIV.OFFR			
	NAME	S.R.NAIR	

R=80



00755-14 V. R. RAO 25-01-2000	EA. MATERIAL ADDED C. M. N.	NATURE OF AMENDMENTS
DECISION DATE	ISSUE	

1. Alternate material is Ep. (Bronze) AK9-4 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.
- (A) EQ. MATERIAL: AL BRONZE GRADE AB₁ To IS: 305-81

APPROVED		765-96-351	
CHECKED		BUSHING	WEIGHT
CONTROLLERATE OF INSPECTION (ICV)			SCALE
		9045	2:1
ROUND BAR AKPHN 20-0HP Ep. AMU 9-2, GOST 1628-78		SHT	SHTS
			82

1130-96-1996

Wires and plug connectors are conventionally not shown.

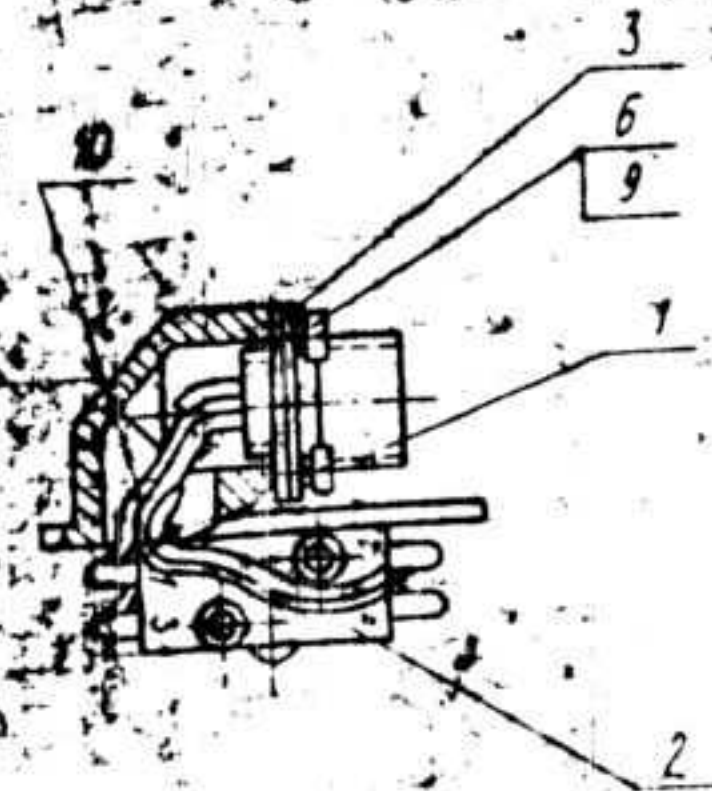
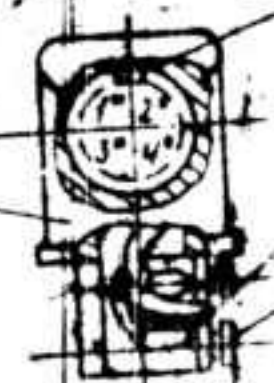


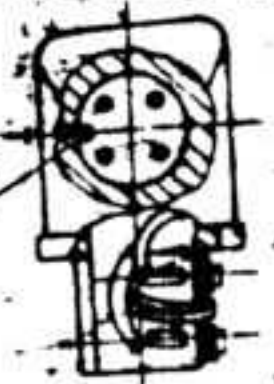
Fig. 1



Key

Fig. 2

The rest see in Fig. 1



Key

Table for soldering conductors.

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

Fig 1 Alternate.

Key



1. Termination of wires is as per PП 700-88-ТТ2.
2. Braze using solder ПOC 61, ПП3, 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 АБС-1, GOST 901-78.

Designation	Fig. No.
765-96-c5143	1
-01	2

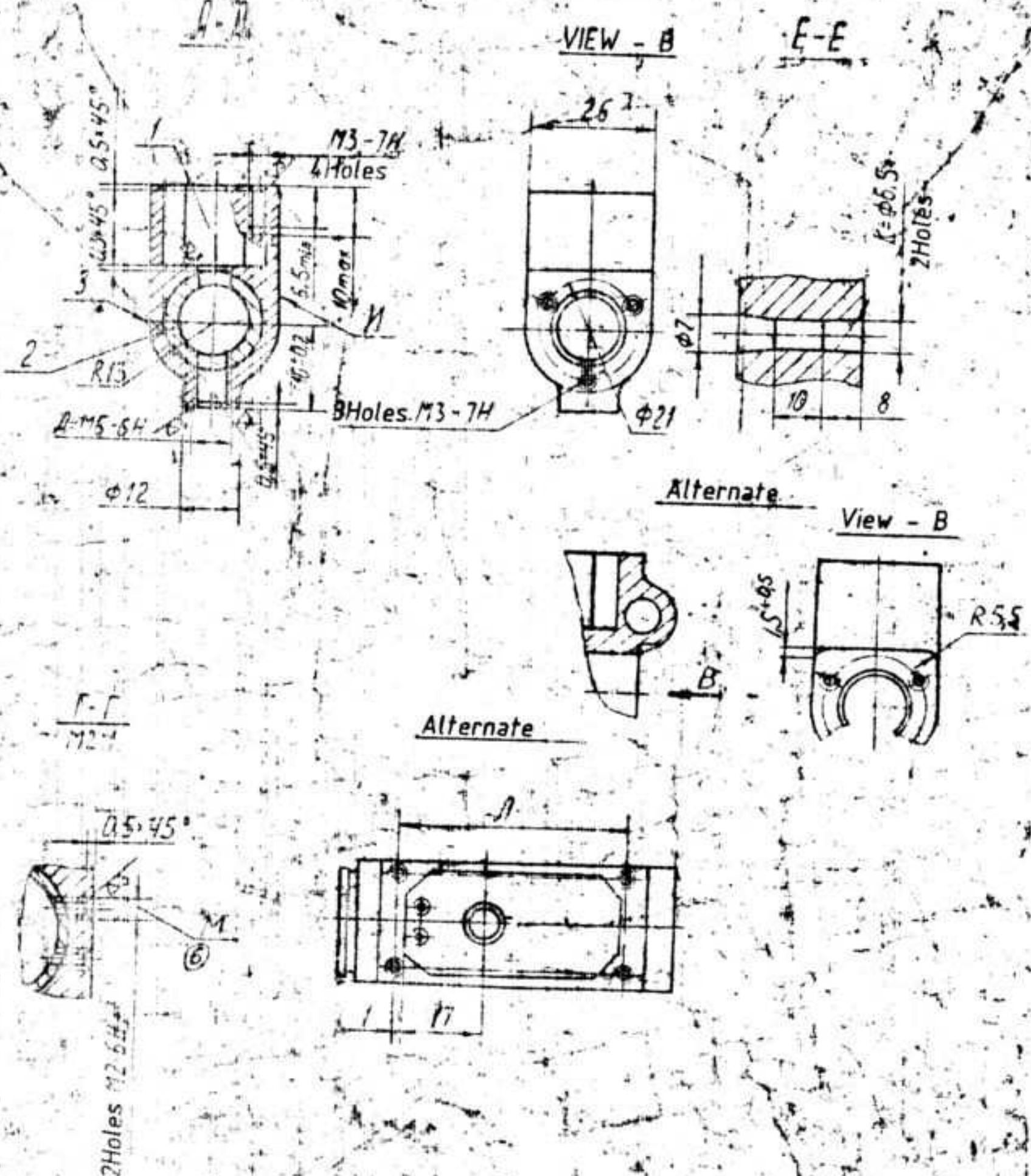
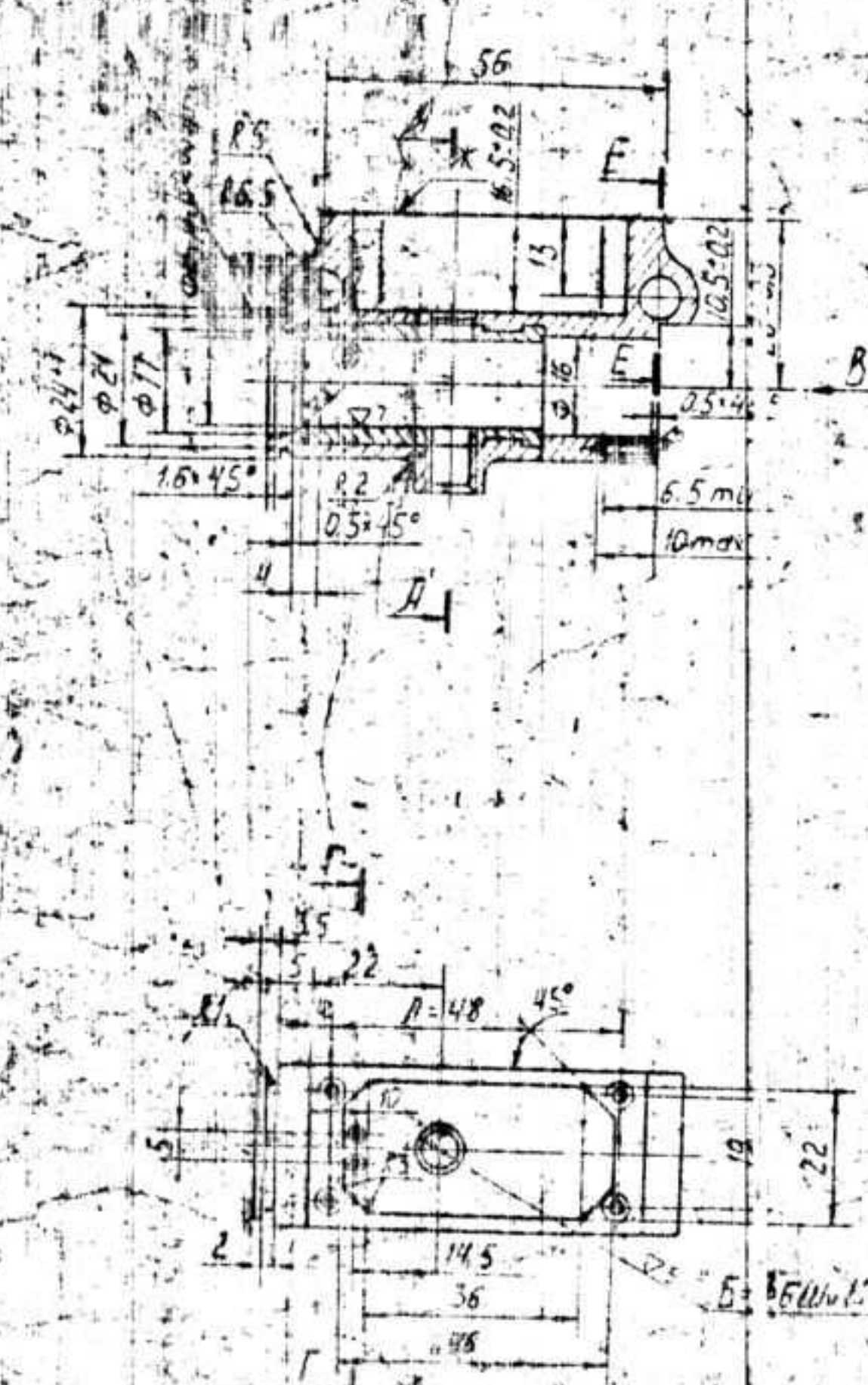
REF. NO.	Designation.	Description	qty.	Remarks
		Bakelite varnish of grade АБС-1, GOST 901-78		
13	Sleeve III TB-50-355-3.5, colourless	GOST 19034-73. l=8	4	
12	Sleeve III TB-50-355-2.5, colourless	GOST. 19034-73. l=20	4	
7	Washer 2x1 0,1.019 or 2x1.02.019	GOST, П1371-78.	2	
6	Screw M3.8h6hx8.48.016 GOST 17473-72	or M3.8h6hx8.66.016 GOST 1491-72.	4	
8	Washer 2T 65 F 05, GOST 6402-70.		2	
		Solder ПП3 ПOC-61 GOST 21931-76.		
2	Micro switch А-703 HO.360.011.		1	Commercial
14	ПП 42/1		8	
11	Wire МГWB-0.35 mm ² TY 16-505.437-73	l=90	2	
10	Wire МГWB-0.35 mm ² TY 16-505.437-73	l=60	2	
9	Washer 3T65F 05 GOST 6402-70.		4	
5	Screw M2. 6qx18.48.016 GOST 17473-72 or	M2. 6qx18.66.016 GOST 1491-72.	2	
1	Plug 2PM 14 Б 4ч 1B1	ГЕД.364.126TY	1	Commercial
4	765-96-73 or	Cover	1	
	765-96-143.			
3	765-96-15	Gasket	1	

DESIGN	DOC NO	SIGN	DATE
DRAWN	P.R.BABU		12.7.86
EDT/CHKD	S.R. NAIR		12.7.86
F/M, DC	S.R. NAIR		12.7.86
DIV. OFFR	T. R. BANERJEE		12.7.86
	NAME	SIGN	DATE

COVER

SHEETWEIGHT SCALE

Easy2copy



- 1) Body Ref.no:1 should be made of material A/1-2, GOST 2685-75, Mass 0.14, In this case:
 - a) Alternate material for body, Ref.no:1, A/1-9 and A/1-9B, GOST 2685-75.
 - b) Coating: Anodically, oxidized, chromitized or chemically parkerized, chromitized, blue except part, Ref.no:2.
- 2) Coat external surface except holes and surface X with primer, Ref.no:3, and enamels, Ref.no:4 and Ref.no:5.
- 3) Unspecified limit deviations of dimensions are as follows: For holes -as per A₇ and for shafts -as per B₇.
- 4) Unspecified casting radii should not exceed 0.5 mm.
- 5) Pattern drafts should not exceed 1° towards the increase of body beyond tolerance.
- 6) Other requirements for casting are as per Technical requirements ITA/1-370.
- 7) Displacement of axes of holes K from true position should not exceed 0.25mm of other holes, it should not exceed 0.2 mm.
- 8) Misalignment of holes B and D with respect to common axis should not exceed 0.1mm (qualified tolerance).
- 9) Knock-out traces not exceeding 1mm, in depth are allowed on surfaces 3 and 11.
- 10) For holes M it is allowed to screw-in a no-go gauge upto bushing, Ref.No.2.

NO	DOC NO	SIGN	DATE
DRAWN	BHUSHAN		16.8.84
EIT/CHKD	ADARSH		18.3.85
F/M,DC	S.R.NAIR		2.8.85
DIV.OFFR	T.R.BANERJEE		25.8.84
	NAME	SIGN	DATE

BODY
ASSEMBLY DRAWING

SHEET	WEIGHT	SCALE
1	0.14	1:1
ORDNANCE FACTORY PROJECT HYDERABAD		

FCIN/ST	ZONE	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
				Technical papers		
13			765-96-c8177CB	Assembly drawing		
				Parts		
54	1		765-96-202	Body	1	
11	2		765-96-351	Bush	1	
				Materials		
		3		Primer ФЛ-03-Ж GOST 9109-76		
		4		Enamel МЛ-12, Grey, GOST 9754-76		
		5		Enamel МЛ-165, Silver, GOST 12034-77		

765-96-c8177

S.NO	SHT	DOC.NO	SIGN	DATE
DRAWN		CH.V.RAO		14.8.84
EDT&CHK		JK JAIN		12.8.84
F/M.D.C.		S.R.NAIK		26.8.84
APPROVED		T.K.BANERJEE		25.8.84
		NAME	SIGN	DATE

BODY

IN SIGNATURE 1

DESCRIPTION

QTY REQUIRED

Washers as per

GOST 6402-70

2

2165F05

2 2 Off

3165F05

1

6165F06

1

8165F06

26

25

24

23

Other items

Commercial

Ball 6 V 6 mm H

28

GOST 3722-60 and

ETV 500-65

1

Difference in execution of 765-96-c8178CB and 765-96-c8178CB-01 are in accordance with Assembly drawing.

765-96-c8178

LIMIT SWITCH

(DISH TYPE)

S.N. SHT DOC. NO. SIGN DATE 14.8.84

DIAGN CH VRAO 16.8.84

EDT&CHK P.K. JAIN 16.8.84

F/M.D.C. S.R. NAIR 16.8.84

NAME SIGN UNIT

ORDINANCE FACTORY

PROJECT MODEL NO. 100