SIZE	ZONE	REF	PART No	NOMENCLATURE	Qty	REMARKS
				DOCUMENTS		
22			A45.935.057C5	ASSEMBLY DRAWING		
				ASSEMBLY UNITS		
11		1	(a) A45.944 016(5620-000114)	GLASS ~~HEATING~~ SHEET	2	
				COMPONENTS		
22		3	A47 200.040	PRISM	1	
11		4	A47.842.052	ADHESIVE FILM	2	
		5	-01	ADHESIVE FILM	4	
12		6	A48.640.066	PLATE	2	
11		7	A48.683.087	GASKET	1	
11		8	A48.683.234-01	GASKET	10	SELECTION
		9	-02	GASKET	10	SELECTION
		10	-03	GASKET	10	SELECTION
		11	-04	GASKET	10	SELECTION
		12	-05	GASKET	10	SELECTION

D.C.(I):-1232-I(P), 1392-I(P), 1462-I(P), 5423-I

VETTED

I/C USER I/C Q.A.

Alt	Sheet	No. of Document	Signature	Date
		D.C(I):-5423-I PT. LIST SEALED		5.10.90
		(B) D.C.(I):-1462-I(P) PLATE WAS SHEET.		10.7.90
		(a) D.C.(I):-1392-I(P) NOMS AMENDED & CAT/PT.Nos ADDED		7.2.90
		D.C.(I):-1232-I(P) PART LIST PROV. SEALED		1.12.87

CAT/PART No (a) 6650-001011

up dated up to 31/5/89 DO(OL.F)

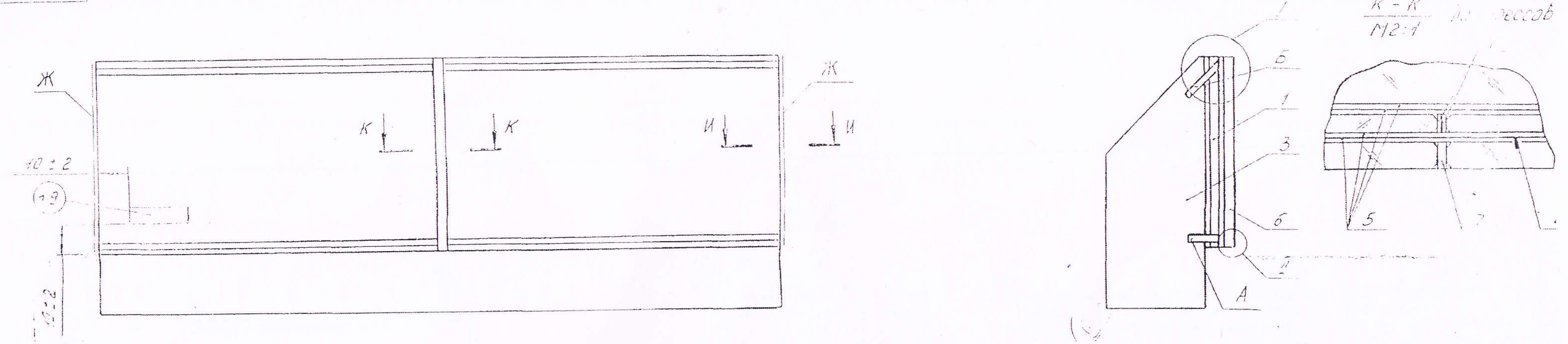
A45.935.057

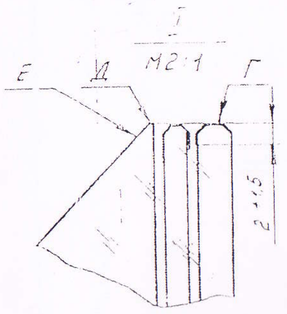
DESIGNER		
CHECKED BY		16.10.86

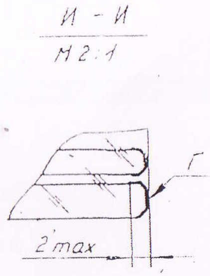
PRISM ASSEMBLY
~~HEATING PRISM~~

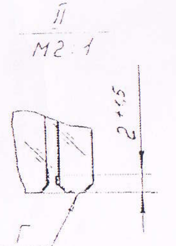
LETTER	SHEET	No. OF SHEET
	1	1

HEAVY VEHICLES FACTORY









1. RESISTANCE OF CURRENT CONDUCTING COATING (18 9-1 ... SHOULD BE MEASURED BETWEEN THE TERMINALS BUS BAR A.B
2. INSULATION RESISTANCE BETWEEN CURRENT COND. AND VARNISH COATED PRISM AT LEAST 100 MEGH...
3. PLATE POS.1 SHOULD BE CEMENTED ON PRISM 3 ... CURRENT CONDUCTING COATING ON OUTERSIDE AND ... -PROTECTING SUB COATING ON END FACES TO EACH ...
4. PROJECTION OF PLATE/STRIP OUT OF THE SURF... SHOULD NOT BE MORE THEN 2 mm AND SINKING ... NOT BE MORE THAN 0.5 mm. PROJECTION OF STRIPS BEY... THE SURFACE Ж IS NOT ALLOWED.
5. AFTER PRESSING RESULTANT FILM SHOULD BE CUT ALONG THE PROFILE OF PLATE AND PRISM LAYER OF ... ON SURFACES Д, Е, Г AND Ж HAVING THICKNESS N... THAN 0.5 mm SO THAT ON SURFACE Е THE TOTA... SHOULD NOT BE MORE THAN 10/cm².
6. END FACE Г OF PLATES ITEM 6 SHOULD BE COATE... LIQUID UNDER COAT OF ПС-4-ТУ6-05-04...305-8...
7. LOCAL PROJECTION OF UNDER COAT ... BEHIND TH... ELECTRODES ON THE LIGHT ZONE OF PRISM SH... NOT BE MORE THAN 1 mm.

8. PLATE NO 6 SHOULD NOT BREAK OUT BY THE IMPACT OF STEEL BALL WEIGHING 55 ± 1 GR FALLING FREELY FROM A HEIGHT OF 90 CM. TWO PLATES FROM THE TOUGHENED LOT ARE CHECK CEMENTED ON PRISM. FOR TESTING PRISMS WITH DEVIATIONS WHICH DOES NOT EFFECT THE RESULT MAY BE USED.
9. TECHNOLOGICAL MARKING IS MADE ON SURFACE В WITH BLACK INK ТУ-6-15-458-76
10. REMAINING TECHNICAL REQUIREMENT AS PER ТУ3-3.834-78

~~9. Технологическую маркировку~~ наносить на поверхность В тушью черной ТУ6-15-458-76.
10. Остальные технические требования по ТУ3-3.834-78.

SIG	DATE	AMENDMENTS
	5.10.90	D.C(I)-5423-I. DRG. SEALED.
	10.7.90	D.C(I)-1462-I(P). UPDATED DRG. PROV. SEALED IN SUPERSESSION OF EXISTING ONE.

18		АЦ5.56-86		
17	Зам.	АЦ686-83		
Изм.	Кол.	N докум.	Подп.	Дата
Разраб.		Протасов		
Пров.		Удачин		
Т. контр.		Трещева		
Н. контр.		Гонникова		

GROUP No. 41315 RD

DRG. No. АЦ5.935.057 СБ

PRISM ASSEMBLY
OPTICAL INSTRUMENT

MATERIAL

CAT/PT. NO 6650-0010

FOLDER/SHEET

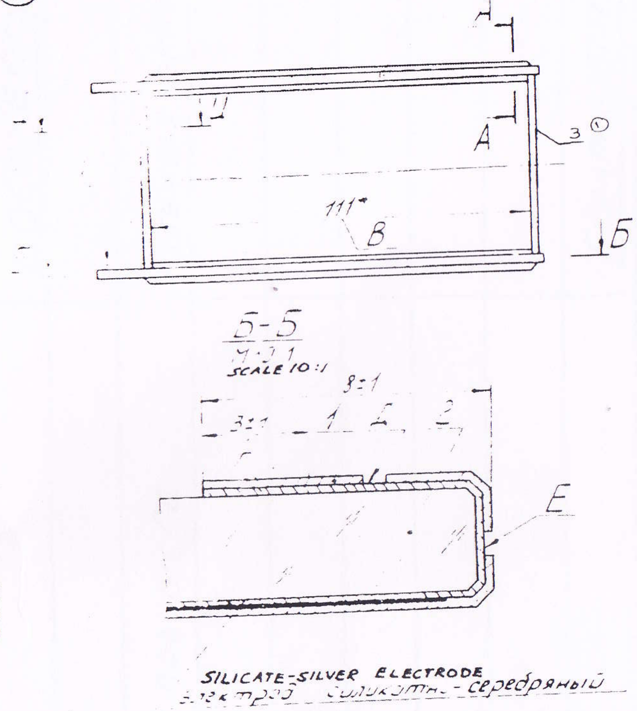
SHEET | WEIGHT

OPTO ELECTRON... DEHRA...

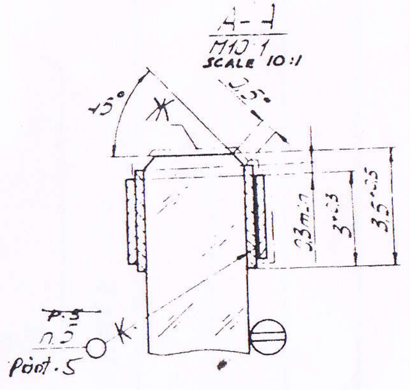
AU5.944.016 LD

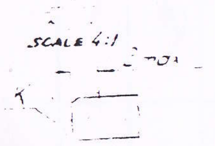
(Alb-1 / 37)

D.C.(I):-1232-I(P), 1392-I(P), 5423-I.



SILICATE-SILVER ELECTRODE
электрод силикатно-серебряный





1. ⓘ Conducting coating should be made of semiconductor dioxide of tin with the addition of fluorine.
2. Slicate-silver electrodes should be applied over conducto coating along it full length, over face "Б" and surface "Д". Thickness of electrodes should be 0.[illegible]
3. Sheet with electrodes should be hardened. Hardening degree should be 0.7 N/cm minimum.
4. Tie 1 on lenght "B" should be glued using conducting adhesive with silver filler and on length "B" soldered without using additional solder.
5. Conducting adhesive is not allowed on face "E" and surface "Д"
6. Liquid sublayer ПC-4 ~~TY6-05-1163-75~~ TY6-05-041-805-83 ① should be applied on surface "Ж", and on face "K".
7. Conducting coating resistance should ensure the fulfilment of point 1 of AU5.935.057c5.
8. *Dimensions for reference.
9. Rest of the technical requirements as per TY3-3.834-~~73~~ ① 78
① 10. The Presence of current conducting coating on surface 3 is allowed.

up dated up to 31/5/89 DO(O.L.F)

			CAT/PART No. 5620-000114	41315 KD AL-1		
	5.10.90	D.C(I)-5423-I DRG. SEALED.	AU5.944.016 LD			
	7.2.90	(A) D.C.(I):-1392-I(P) NOM. AMENDED & CAT/PT. No. ADDED.	GLASS SHEET / ASSEMBLY DRAWING	SHEET	MASS	SCALE
M	1.12.87	D.C.(I):-1232-I(P) DRG. PROV. SEALED.		1 of 1	0.048	1:1
1	23.6.87	AU683-85				
ISSUE	DATE	REFERENCE				
APPROVED		21/3/85	MATERIAL:	HEAVY VEHICLES FACTORY AVADI		
CHECKED		21/3/85				
DRAWN		5/3/85				

A/T
36

SIZE	ZONE	REF.	PART No	NOMENCLATURE	Qty	REMARKS
				DOCUMENTS		
13			A45 944. 016CB	ASSEMBLY DRAWING		
				COMPONENTS		
11		1	A47 755. 033	TIE	2	
12		2	A48. 640. 065	PLATE	1	

VETTED
UC Q.A
UC USER

D.C.(I):-1232-I(P), 1392-I(P), 1462-I(P), 5423-I

D C(I):-5423-I. PT LIST SEALED.		5.10 90
(B) D.C.(I):-1462-I (P) PLATE WAS SHEET.		10.7.90
(a) D C (I):-1392-I(P). NOM AMENDED & CAT/PT No ADDED		7.2.90
D.C.(I):-1232-I(P) PART LIST PROV. SEALED		1.12 87
Alt / Sheet / No. OF DOCUMENT	SIGNATURE	DATE

CAT/PAT No (a) 5620-000114

41315

Up dated up to 31/5/89 DO(O.L.F)

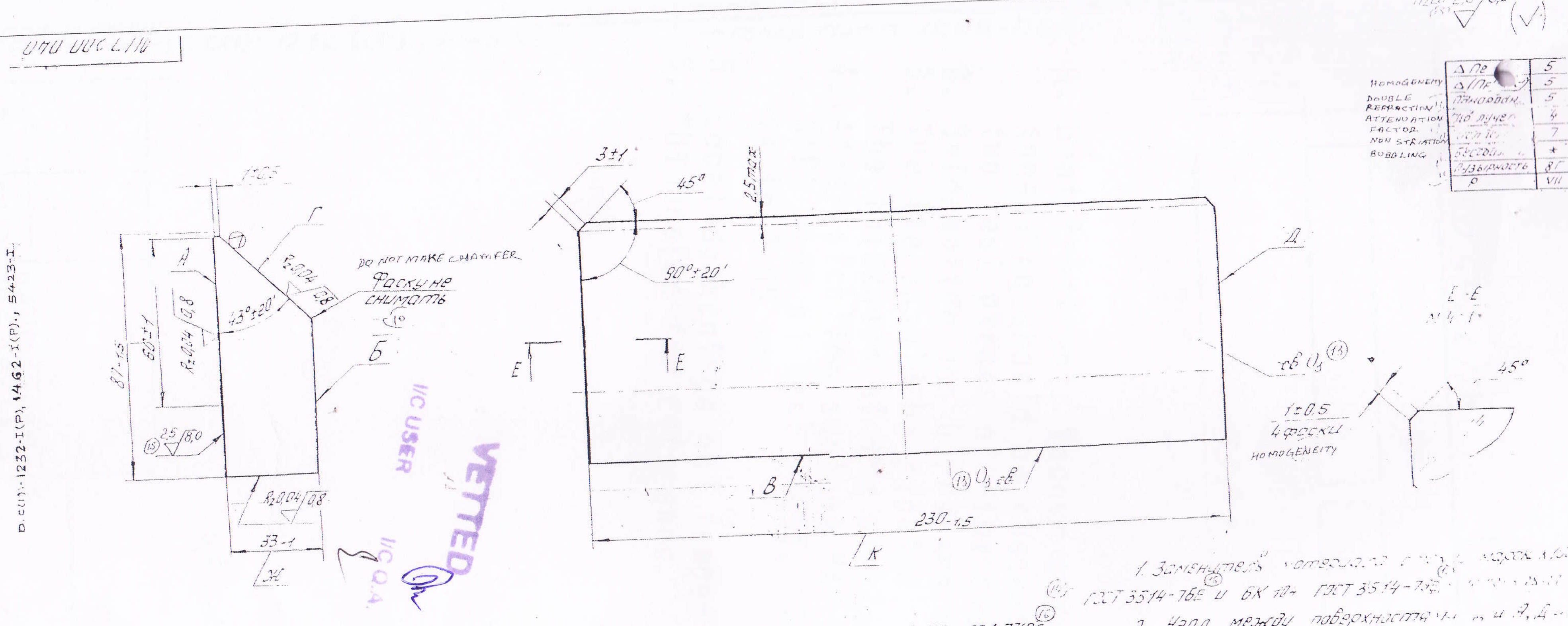
A45. 944.016

DESIGNER		
CHECKED BY		16/3/
CHIEF OF DEPARTMENT		
INSPECTOR		

GLASS SHEET

LETTER	SHEET	No. OF SHEETS
	1	1

HEAVY VEHICLES FACTORY
AVADI



HOMOGENEITY	Δ Пе	5
	Δ (Пf - Пc)	5
DOUBLE REFRACTION	Двулучепр.	5
ATTENUATION FACTOR	Показат. ослабл.	4
NON STRIATION	Свильность	7
BUBBLING	Пузырность	*
		8Г
	Р	VII

1. Заменитель материала стекло марки К100 ГОСТ 3514-76Е и БК 10 ГОСТ 3514-76Е.
2. Угол между поверхностями Д и А, Д и Б, Д и В, Д и Г равен 90°±20'.
3. Фаски на ребрах 1+1×45°, кроме мест указанных особо. Фаски на углах 2+1×45°.
4. Клиновидность по размерам Ж и К в пределах половины допуска на размер.
5. Рабочая зона на поверхностях А, В, Г ограничивается фасками и заданными размерами.
6. Ⓐ - зеркальн. 25Р.3Е.72П по ОСТ3-1901-73-85
7. Покрытие серебряной и матовой поверхностей - лак бакелитовый ЛБС-1 сорт 1 по ГОСТ 901-78 с наполнителями: углеродом техническим марки П803 ГОСТ 7885-77Е и тальком ТРПН ГОСТ 19729-74, затем - лак бакелитовый ЛБС-1 сорт 1 с наполнителями: двуокисью титана по ГОСТ 9808-84 и тальком.
8. Сопротивление изоляции лакового покрытия относительно слоя меди не менее ... МОм
9.* Бессвильность и остальные технические требования по ТУ3-3.834-78.

1. ALTERNATE MATERIAL - GLASS K-100 GOST 3514-76E AND БК-104 GOST 3514-76E. K 110 GOST 3-28-77
2. ANGLE BETWEEN THE SURFACES Д AND А, Д AND Б, Д AND В, Д AND Г SHOULD BE EQUAL TO 90°±20'.
3. CHAMFERS AT EDGES 1+1×45° EXCEPT THE PLACES INDICATED FOR SPECIAL CHAMFER AT ANGLE 2+1×45°.
4. TAPER ON DIMENSION Ж AND К WITHIN 1/2 LIMIT OF TOLERANCE FOR DIMENSIONS.
5. WORKING ZONES ON SURFACES А, В, Г ARE LIMITED BY CHAMFERS AND SPECIFICAL DIMENSION.
6. Ⓐ 25P3E 72II.72.П AS PER OST 73-1901-85.
7. SILVER COATING AND ON DULL SURFACES - BAKALITE VARNISH ЛБС GRADE I AS PER GOST 901-78 WITH FILLER INDUSTRIAL CARBON GRADE П 803 GOST 7885-77E AND TALC ТРПН GOST 19729-74, THERE AFTER BAKALITE VARNISH ЛБС-1 GRADE-I WITH FILLER. TITANIUM DIOXIDE AS PER GOST 9808-84 AND TALC.
8. INSULATION RESISTANCE OF VARNISH COATING IN RELATION TO COPPER LAYER SHOULD NOT BE LESS THAN 20. MEGHA OHM.
9. NON STRIATION AND OTHER REQUIREMENT AS TY-3-834-78.

5.10.90	D.C(I):- 5423-I DRG. SEALED	
10.7.90	D.C(I):-1462-I(P). UPDATED DRG. PROV. SEALED IN SUPERSESSION OF EXISTING ONE.	
DATE		AMENDMENTS

Изм.	Лист	№ докум.	Подп.	Дата
16		АЦ 856-86		
15		АЦ 450-86		
14	1	АЦ 764-83		
13	4	АЦ 288-83		
12	2	АЦ 485-82		
Разраб.		Колмыкова		
Пров.		Шашкина		
Т. контр.		Заробнятных		
Н. контр.				

GROUP No. 41315 KD — FOLDER/SHEET No. 32

DRG. No. АЛ 7.200.040

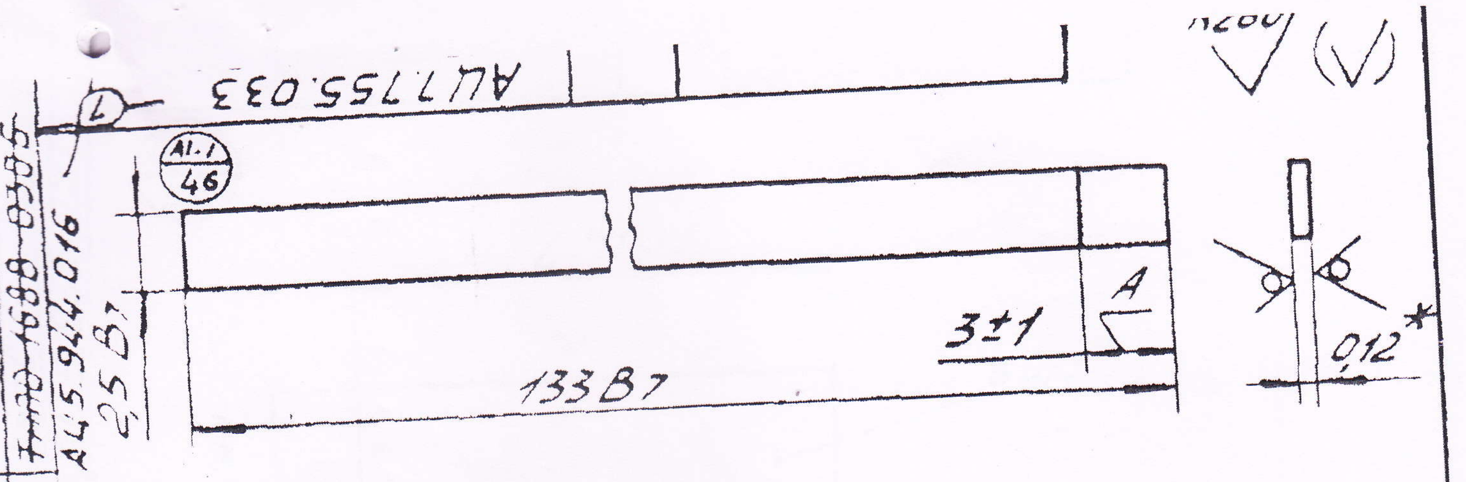
PRISM

SHEET	WEIGHT	SCALE
	1.326	1:1

MATERIAL: GLASS K108 GOST 3514-76E

OPTO ELECTRONICS FACTORY DEHRADUN

VETTED — I/C USER — I/C Q.A.



1. Heat treatment: Vacuum annealing.
   Annealing should be checked as per Gost 1173-77 through two test pieces of dimension 20 X 60 mm from each batch
2. Deformation and burrs are not allowed.
3. The tie should be pickled.
   The thickness of the pickled tie should be 0.09 mm min.
4. After pickling surface "A" should tined with solder ПР2 ПОС 61 Gost 21931. Thickness of soldering layer is to 0.05 mm.
5. Local darkenings and temper colours are not allowed.
6. *Dimension for reference.

VETTED
I/C Q.A.
I/C USER

up dated up to 31/5/89 DO (O.L.F.)

D.C.(I):-1232-I(P),5423-I

АЦ7.755.033

	5.10.90	D.C.(I):-5423-I DRG. SEALED	TIE	
	1.12.87	D.C.(I):-1232-I(P). DRG. PROV. SEALED.		
ISSUE	DATE	REFERENCE		
APPROVED		2/3/85	MATERIAL: COPPER STRIP M1T-HT	

SHEET	MASS	SCALE
1/1	0.0003	4:1

HEAVY VEHICLES FACTO