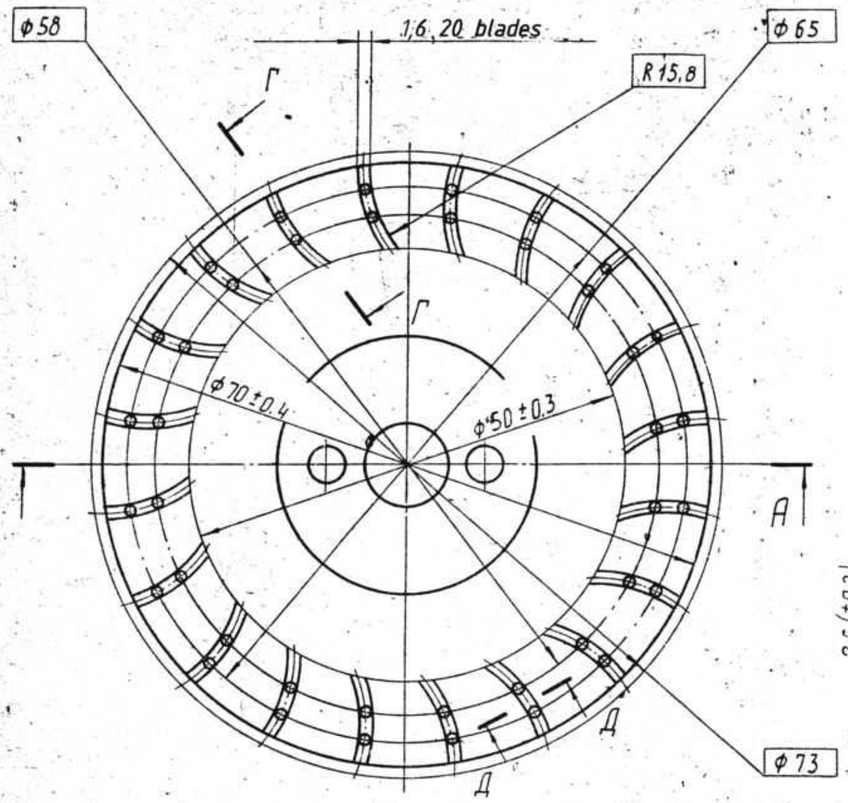
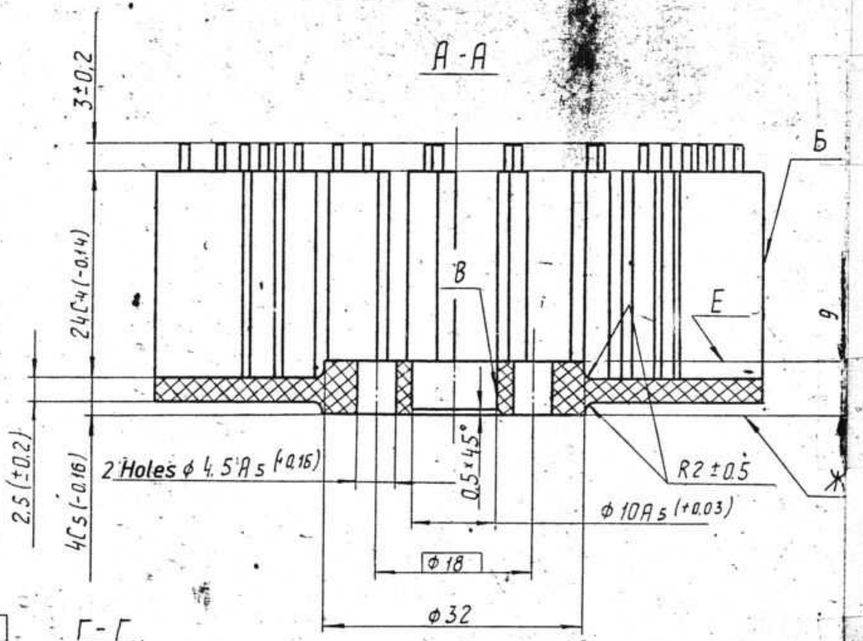
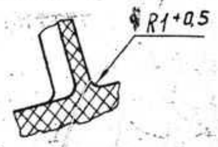
765-71-1525







ϕ 16 for 2 groups by 20 lugs in each.

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▽5

1) Unspecified limit deviations of dimensions for holes are as per B_7.

2) Unspecified radii are R 0,5 ± 0,1 mm.

3) Displacements of blades, holes axes and projections from true position should not exceed 0, 3 mm.

4) Run-out of surface Б with respect to axis of surface B should not exceed 0,5 mm.

5) Deformation of blades is not permitted.

6) Non-perpendicularity of blades to the plane of flange should not exceed 0,6mm over the length of blade,.

7) Dimension with (*) is for reference.

8) On surfaces E and Ж, shrinkage depression should not exceed 0,5 mm.

9) All dimensions are provided technologically.

ROTOR SHALL BE MANUFACTURED WITH THE MATERIAL POLYAMIDE -610 TO GOST-10589-73.

FOR DETAIL PROPERTIES OF POLYAMIDE -610 REFER DRAWING No. 765-71-cd 610 cd GAUGE.

2) SURFACE FINISH :-

▽5 :- REPRESENTS SURFACE ROUGHNESS IN Rz VALUE NOT TO EXCEED 20 MICRONS.

3) LIMIT DEVIATION FOR HOLE B7 = −250 MICRONS.

DT 25 FEB' 93

(A.B. PATWARDHAN)
SSO II

3	765 320-76		
SNO	SHT	DOC NO	SIGN	DATE
DRAWN		Y.R.Ganesh		23.8.84
EDT&CHKD		A.B.PATWARDHAN		19.9.84
F/M,DC.		S.R.NAIR		31.8.84
DIV.OFFR		T.K.BANERJEE		3.9.84
		NAME	SIGN	DATE

765-71-1525

ROTOR

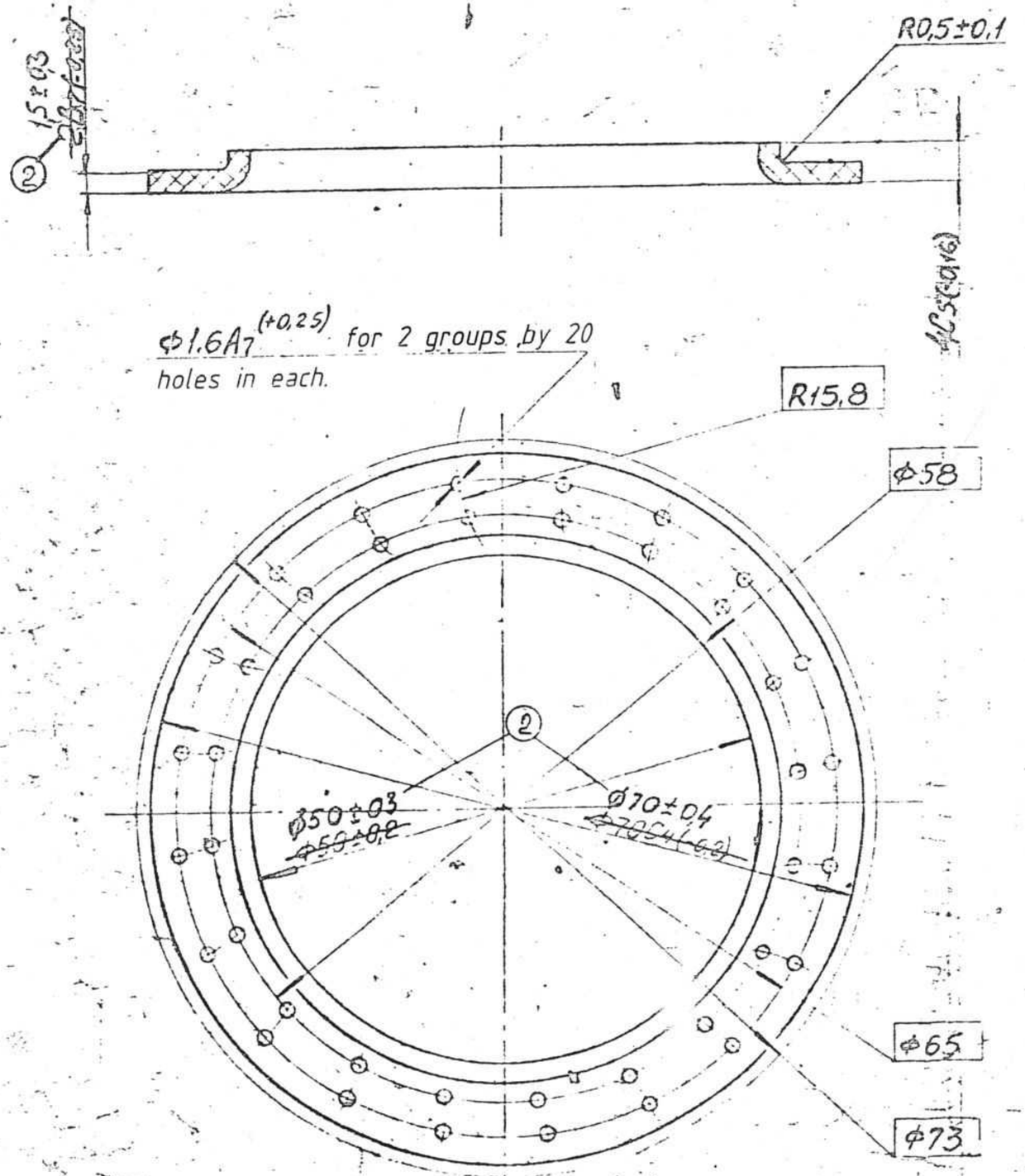
MOULDING-POLYAMIDE - 610
FOCT 10589 - 73.

SHEET	WEIGHT	SCALE
	0.025	2:1

TOTAL SHEETS

765-71-1527

▽5



1). Displacement of axes of holes from true position should not exceed 0.3 mm.

2). Dimensions are provided technologically.

FLANGE SHALL BE MANUFACTURED WITH THE MATERIAL POLYAMIDE-610 TO GOST 10589-73.
FOR DETAIL PROPERTIES OF POLYMIDE-610, REFER DRAWING No 765-71-GS 610 CS GAUGE.

2] SURFACE FINISH

▽5 :- REPRESENTS SURFACE ROUGHNESS IN Rz VALUE NOT TO EXCEED 20 MICRONS.

(A B PATWARDHAN)
SSO-II
DT. 25 FEB'93

765-71-1527

SR.NO/SHT	DOC NO	SIGN	DATE
DRAWN	BHUSHAN		26.7.84
EDT&CHKD	D.K. JAIN		30.7.84
F/M,DC.	S.R. NAIR		30.7.84
DIV.OFFR	T.K. BANERJEE		8.84
	NAME	SIGN	DATE

FLANGE

Moulding polyamide 610, GOST 10589-73

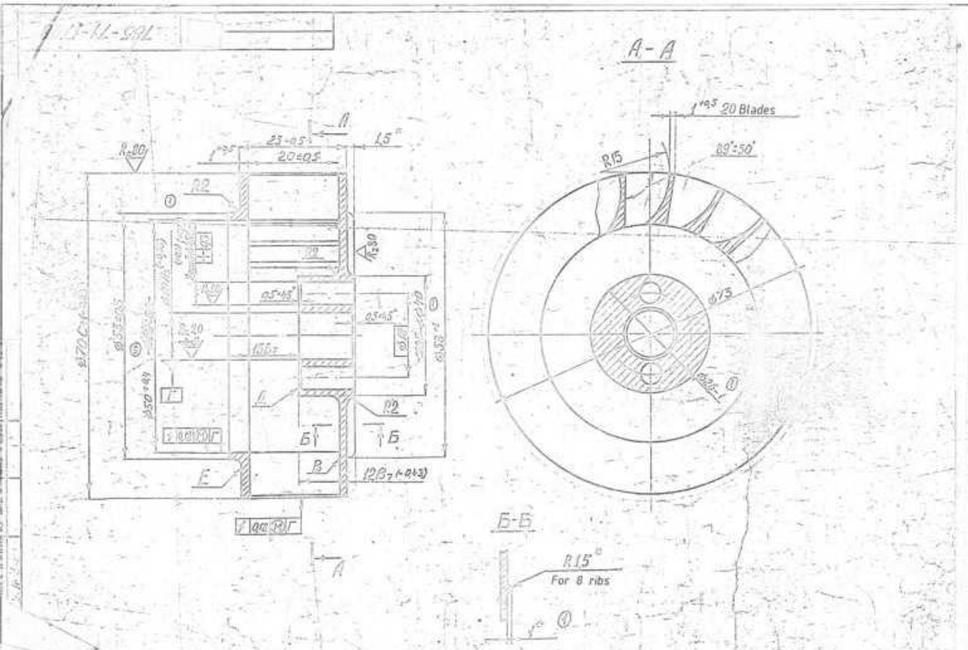
SHEET	WEIGHT	SCALE
1	0.003 0.015	2:1

TOTAL SHEETS

1-3-A3 1-3 2-2-3

www.easy2convert.com

765-71-1706



1. Type of casting - pressure-die casting.
2. Casting radius should not exceed 1 mm.
3. Pattern drafts should not exceed 2°.
4. Unspecified limit deviations of dimensions are ±1 mm.
5. Depth of pusher traces on surfaces Д, Е, В should not exceed 0.5 mm.
6. Rest of requirements are as per Technical Requirements ТТА/1-370.
7. Type of coating: Anodic oxidation chromatizing.
8. Non-perpendicularity of blades to surfaces В should not exceed 0.6 mm.
9. Step on surface В should not exceed 1 mm.
10. * Dimensions are given for reference.

WEIGHT	DOC. NO		SIGN	DATE	765-71-1706	SHEET	WEIGHT	SCALE
DRAWN	DIV.DAD							
EDITED					ROTOR	TOTAL SHEETS		
PASS. D.C.	S.E. HAME					Translated		
DIV. OFFR	T. CHAMBERLAIN				A/19 ГОСТ 2685-75	Checked		
	NAME		SIGN	DATE		Inscribed		

765-71-1706

EXPLANATORY NOTES TO TECHNICAL CONDITONS

1. ROTOR SHOULD BE MANUFACTURED FROM ALUMINIUM PRESSURE DIE-CASTING ALLOYS OF GRADE А19 OF GOST- 2685-75.
THE CHEMICAL COMPOSITION OF GRADE А19 OF GOST 2685-75 IS AS GIVEN BELOW:-

GROUP OF ALLOYS	GRADE OF ALLOYS	CHEMICAL COMPOSITIONS %			
		BASIC COMPONENTS			ADMIXTURE NOT MORE THAN
		ALUMINIUM	MAGNESIUM	SILICON	IRON Fe
ALLOY ON ALUMINIUM & SILICON BASE	А19	BASE	0·3-0·4	6·0-8·0	1·50

CHEMICAL COMPOSITION % ADMIXTURE NOT MORE THAN											
GRADE OF ALLOY	Mg	Si	Mn	Cu	Zn	Sn	Pb	Ni	Ti	BERILIUM	ZIRCONIUM	TOTAL CALCULATED ADMIXTURE
А19	-	-	0·50	0·20	0·30	0·01	0·05	-	-	0·10	0·15	2·0

2. MECHANICAL PROPERTIES —

PARTIAL RESISTANCE kgf / mm²	SPECIFIC ELONGATION %	HARDNESS AS PER BRINELL H.B.
NOT	MORE	THAN
17	1	50

3. SURFACE FINISH :-
▽(√) :- INDICATES SPECIFIED ROUGHNESS TO BE OBTAINED BY ANY PRODUCTION METHOD WITHOUT REMOVAL OF MATERIAL
$R_z 20$:- THE R_z VALUE OF SURFACE FINISH TO BE OBTAINED BY ANY PRODUCTION METHOD IS NOT MORE THAN 20 μ.
$R_z 80$:- THE R_z VALUE OF SURFACE FINISH TO BE OBTAINED BY ANY PRODUCTION METHOD IS NOT MORE THAN 80 MICRONS.
⌖ 0.18 Ⓜ Г :- REPRESENTS RUN OUT OF INDICATED DIMENSION TO BE WITHIN 0.18 mm FROM THE BASE INDICATED Г AT MAXIMUM METAL CONDITION.
Г :- INDICATES SURFACE Г
⌖ 0.4 Ⓢ A Ⓜ
+ 0.3 :- DISPLACEMENT OF HOLE ON AXES TO BE WITH IN 0.3 mm
NOTE :- FOR OTHER REQUIREMENTS AS PER ТТА/1-370 MAY BE REFFERED TO CIFE, DIGHI, PUNE-15

DO(U)	BT.	ZONE	BRIEF RECORD	SIGN.													

INSCRIBED		DRG. NOT TO BE SCALED.	PERTAINS TO
CHECKED		ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	
APPROVED		ALL DIMENSIONS ARE IN MM. UNLESS OTHER WISE SPECIFIED	
DATE		TOLERANCE UNLESS OTHER WISE SPECIFIED GEN. [DEC.] AND	ROTOR 765-71-1706
		SCALE :	CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT. PUNE

1-3-AB

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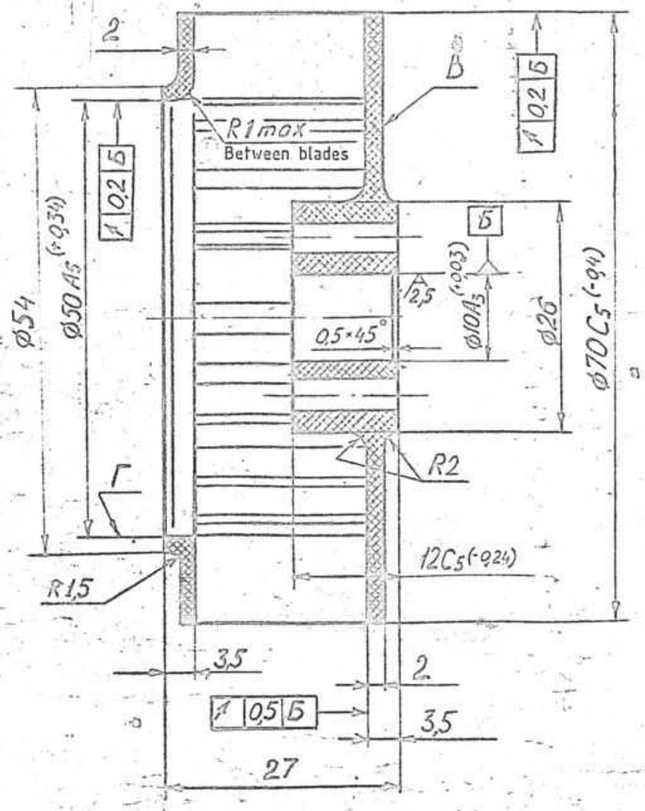
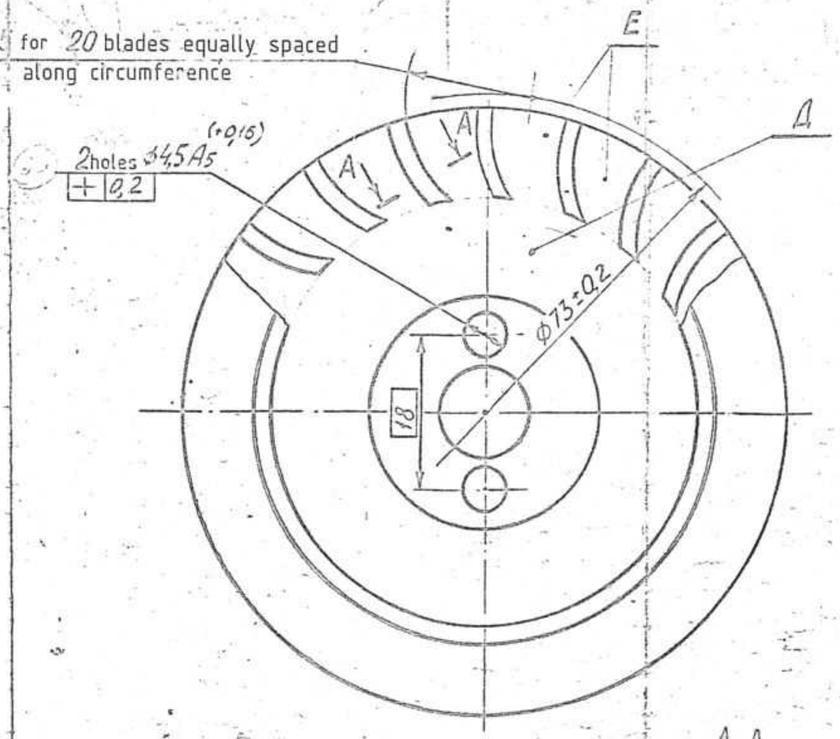
765-71-1710





2. Pattern draft should not exceed 1°.
3. Unspecified radii should not exceed 0,5mm.
4. Unspecified limit deviations of dimensions are as per CM7.
5. Nonperpendicularity of blade with respect to surface B should not exceed 0,5mm over blade length.
6. Displacement of blades fron true position should not exceed 0,2mm.
7. Sinking or pojecting of blade with respect to surface F should not exceed 0,5mm.
8. Projecting of surfaces E with respect to surface A should not exceed 0,5mm.
9. Rest of requirements are as per OCT 4Г0.005.051.

REFER TO DRG No 765-71-1711 FOR EXPLANATORY NOTES REGARDING POLYAMIDE 610,

SYMBOLS

18 ON THE DIMENSIONS 18 TOLERANCE IS NOT SPECIFIED BUT IT IS NOT A "FREE DIMENSION"

⌀ 0·5 Б REPRESENTS RUN OUT OF INDICATED DIMENSION TO BE WITHIN 0·5mm FROM THE BASE INDICATED AS Б

⌀ 0·2 Б REPRESENTS RUN OUT OF INDICATED DIMENSION TO BE WITHIN 0·2mm FROM THE BASE INDICATED AS Б

Б BASE IS Б

+ 0·2 DISPLACEMENT OF HOLES ON AXES TO BE WITHIN 0·2mm

SURFACE FINISH

2·5 REPRESENTS SURFACE FINISH TO BE OBTAINED BY MACHINING IN Ra VALUE 2·5μ max

CIFE PUNE (R.VEERARAGHAVAN)

765-71-1710

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		V.J.RAO		25.8.84
EDT. CHKD		M.MOORTHY		29-8-84
S/M, DC		S.R.NAIR		29.8.84
DIV.OFFR.		T.C.BANERJEE		1.9.84
		NAME	SIGN	DATE

ROTOR

Polyamide 610, moulding, ГОСТ 10589-73

SHEET	WEIGHT	SCALE
	0,020	2:1

TOTAL SHEETS

TRANSLATED

CHECKED

INSCRIBED

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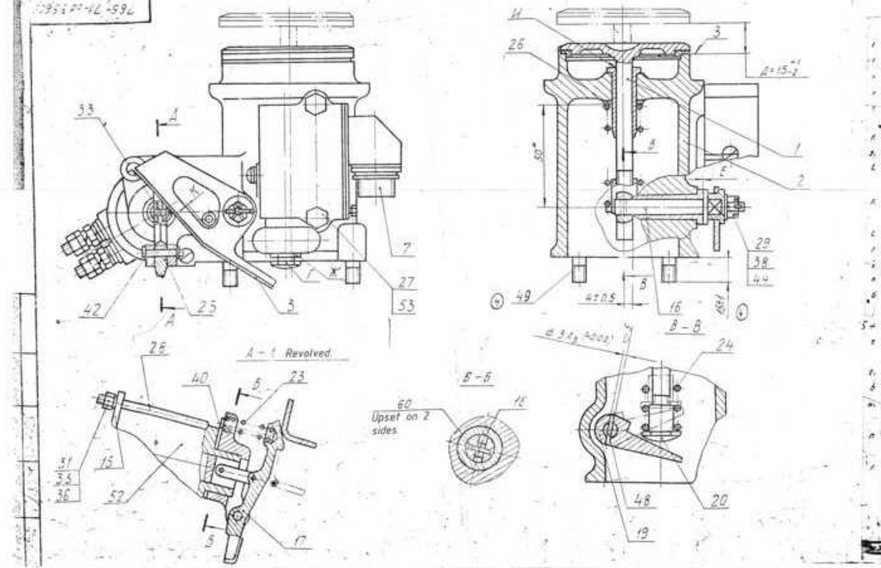

1) * Dimension is given for reference.

2) With dimension A set along the contour of the valve, Ref.No.1, fit the lever, Ref.No.19 onto the shaft so that the lever Ref.No.3 is locked by the retainer as it is shown conventionally in section A-A, there upon drill the lever fitted onto the shaft and secure it with lock pins, while axial play E of the shaft should not exceed 0.5 mm.

3) In closed condition, the valve should tightly fit to the box along the entire perimeter, in this case distance K for motion of the lever, Ref.No.3, should be atleast 0.5mm.

4) Crimp the free end of the rivet Ref.No.33, so that the clamp, Ref.No.18, is able to turn easily.

5) In finally assembled unit the retainer should reliably keep the valve in the open position and under the relay action, at a voltage of 22-0.5 V, it should positively release the valve engagement lever, Ref.No.3, with the armature thrusting against the relay body, no more than 3 washers, Ref.No.40, may be placed.

6) Lubricate all friction surfaces of the parts with lubricant Ithol-24, GOST 21150-75, and wipe out the excessive lubricant from surface H.

7) Check the inner space of box for tightness by pouring water upto the box full capacity for 3 mints. Leakage of water along the valve sealing is not allowed.

Grinding of valve gasket and of surface 3, leakage along the shaft, ref.no.16, are allowed. After checking the box for tightness, dry the inner space of box for compressed air.

8) Adjust the limit switch by screw 7 and locknut 8, so that when locking the lever, Ref.No.3, by the retainer, the switch rod is pressed by the lever, contacts 3 and 4 are closed, contacts 1 and 2 are opened, the switch rod free travel should be 2 to 3 mm. When the valve is closed the rod should be lowered, contacts 1 and 2 closed contacts 3 and 4 opened.

9) Check reliable locking of the valve, Ref.No.1, in the opened position by applying a static load of 5kg. acting along the axis of valve. Releasing of the lever Ref.No.3, from the retainer, Ref.No.17, is not allowed.

10) If necessary, the lever Ref.No.3, may be straightened.

11) Before assembling, lubricate the threaded joints with a thin layer of lubricant Ithol-24, GOST21150-75, or lubricant MC-70, GOST 9762-76, secure the pusher Ref.No.20, and studs, Ref.No.49, with the aid of iron minium, GOST 8866-76.

12) To provide for locking of the nut, Ref.No.29, with the cotter pin, Ref.No.44, no more than 2 washers, Ref.No.38, may be placed.

13) Under cut of the rivet Ref.No.33, not exceeding 2mm is allowed.

7	146199-90				
6	9232-78				
5	145604-78				
4	9521-72				
3	9545450-77				
DES	TOOL NO.	SIGN	DATE	765-71cd3566B	
DRAWN	BRIGHAM		12.84		
CHKD	SAMPLE			BOX (Assembly drawing)	SHEET WEIGHT SCALE 1.66 1:1
APPD					TOTAL SHEETS
DR/OFFR					
NAME	SIGN	DATE			

765-71cd3566B

EXPLANATORY NOTES TO TECH. CONDITIONS.

1) REFER NOTE No. 6 AND 11

a) LUBRICANT LITHOL 24 (GOST 21150-75)

LITHOL 24 GREASE IS MADE BY THICKENING MINERAL OIL WITH LITHIUM SOAPS OF 12-OXYSTEARIC ACID AND ADDING AN ANTIOXIDISING OR A VISCOUS DOPE.

b) LUBRICANT MC-70 (GOST 9762-76)

GREASE MC-70 IS MANUFACTURED BY THICKENING MBTI (MVP) GRADE INSTRUMENT OIL WITH BARIUM AND ALUMINIUM STEARIC ACID SOAP AND ADDING GRADE BO CERESINE AND POLYISOBUTYLENE OF GRADES P-200 N, P-200 P-155 N AND P-155.

REFER NOTE No.11

IRON MINIMUM

IRON MINIMUM IS A SUSPENSION OF PIGMENT (IRON OXIDE) GROUND WITH DRYING OIL WITH OR WITHOUT ADDITIVES.

2) PILOT SAMPLE

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

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				DRN	DRG. NOT TO BE SCALED
				TCD	ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.
				CHD	ALL DIMENSIONS ARE IN mm, UNLESS OTHERWISE SPECIFIED
				PBD	
				APPD	
		EXPLANATORY NOTES RETRACED.		DATE	13 OCT 86
				TOLERANCE UNLESS OTHERWISE SPECIFIED	
DR	DATE	BRIEF RECORD	SIGN	BEN	DEC AND

PERTAINS TO

BOX (ASSY. DRG.) 765-71cd3566B

SCALE:-

CQA (FE), AUNDH CAMP, PUNE-27.

M/P No. | DRG RAISED ON | DATE | PBD | APPD | CHD | TCD | DRN | AUTHENTICATED | JOB No.

1.1.AB

ITEM	ZONE	REF	DESIGNATION	DESCRIPTION	QTY	REMARKS
				Technical papers.		
14			765-71-cδ356cδ	Assembly drawing.		
				Assembly units.		
11		1	765-71-cδ357	Valve	1	
12		2	765-71-cδ358	Body.	1	
11		3	765-71-cδ359	Lever.	1	
13		7	765-96-cδ166	Limit switch		
			or	(Spring-return switch)	1	
13			765-96-cδ178-01			

S.NO SHT	DOC.NO.	SIGN	DATE
DRAWN	BHUSHAN		22.8.84
CHD & CHK	A.K. BURJEE		28/8/84
I/M I/C	S.P. NAIR		28.8.84
APPROVED	K. BANERJEE		31.8.84
	NAME	SIGN	DATE

765-71-cδ356,

BOX.

SHT. NO. 1 OF SHT. 6

CIFT

FACTORY

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FIG NO	ZONE	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
				Parts.		
11		15	765-71-364	Flange	1	
12		16	765-71-810	Shaft	1	
13		17	765-71-812	Retainer	1	
11		18	765-71-813	Clamp	2	
12		19	765-71-814	Lever	1	
11		20	765-71-815	Pusher	1	
		21				
11		23	700-38-1123	Spring	1	
11		24	700-38-1577	Spring	1	
11		26	700-40-73	Gasket.	1	
12		25	672-47-5-01	Axle	1	
12		53	672-31-71	Tab washer	2	

S.NO	SHT	DOC.NO.	SIGN	DATE
DRAWN		BHUSHAN		22.8.84
EDT&CHK		ANDUREY		28-11-84
F/M.D.C.		S.R.NAIR		28.8.84
APPROVED		K.BANERJEE		31.8.84
		NAME	SIGN	DAT

765-71-CD356.

BOX.

SHT. NO	NO OF SHTS
2	6

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FORMAT	ZONE	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
				Standard Items.		
		27		Bolt M6x40.46.019		
				GOST 7795-70	2	
		28		Screw M4.8h.6hx70.66.		
				016 GOST 1491-72	2	
		29.		Nut M5.6.016		
				GOST 5932-73	1	
		31		Nut M4.6.016		
				GOST 5927-70	2	
		33		Rivet 2x10.32		
				GOST 10299-80	1	
		35		Washer 4T65Г 05		
				GOST 6402-70.	2	

S.NO	SHT	DOC.NO.	SIGN	DATE
DRAWN		BHUSHAN		22.8.84
EDT&CHK		[illegible]		28.8.84
F/M.D.C.		S.R.NAIR		28-8-84
APPROVED		T.K.BANERJEE		31.8.84
		NAME	SIGN	DATE

765-71-CD356

BOX.

SHT. NO	[illegible]
3	6

Easy2Convert
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ITEM NO	SHT NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
	36		Washer 4.01.019 or 4.02.019 GOST 11371-78	2	
	38		Washer 5.01.019 or 5.02.019 GOST 11371-78	2	Max,Qty.
	40		Washer 24x1,5.35 GOST 11371-78	3	Max,Qty.
	42		Cotter pin 1x12.019 GOST 397-79	1	
	44		Cotter pin 16x10..019 GOST 397-79	1	
	48		Lock-pin Зпр22а x12 OST 3-2234-80	1	HB255...207 (Ø3,8 to 4,2)
	49		Stud M6 $\frac{5g2}{6g}$ x.16.66.019 GOST 22036-76 or 29363	4	Without dividing in to groups.

S.NO	SHT	DOC.NO	SIGN	DATE
DRAWN		BHUSHAN		22.8.84
EDT & CHK		[illegible]	[illegible]	28.8.84
F/M.D.C.		S.R.NAIR	SR	28884
APPROVED		T. K. BANERJEE	[illegible]	31.8.84
		NAME	SIGN	DATE

765-71-cδ356.

BOX.

SHT. NO 4 | MAXIMUM SHT. 6

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FOR COLUMN	ZONE	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
				Other Items.		
		52		Relay PM6-1C		
				PM6-1C 000TY	1	
				Materials		
		60		Wire K02		
				GOST 792-67, l=15	1	

S.NO	SHT	DOC.NO.	SIGN	DATE
DRAWN		BHUSHAN.		22.8.84
EDT&CHK		ANURAG		28/8/84
F/M.D.C.		S.R.NAIR		28884
APPROVED		T.K.BANERJEE		31.8.84
		NAME	SIGN	DATE

765-71-CD356,

BOX.

SHT. NO.	NO. OF SHTS.
5	6

easy2convert
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FORMAT	ZONE	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS

S.NO	SHT	DOC.NO.	SIGN	DATE
DRAWN		BHUSHAN		22.8.84
EDT&CHK				
F/M.D.C.		S.R.NAIR		
APPROVED				
		NAME	SIGN	DATE

765-71-C0356.

BOX.

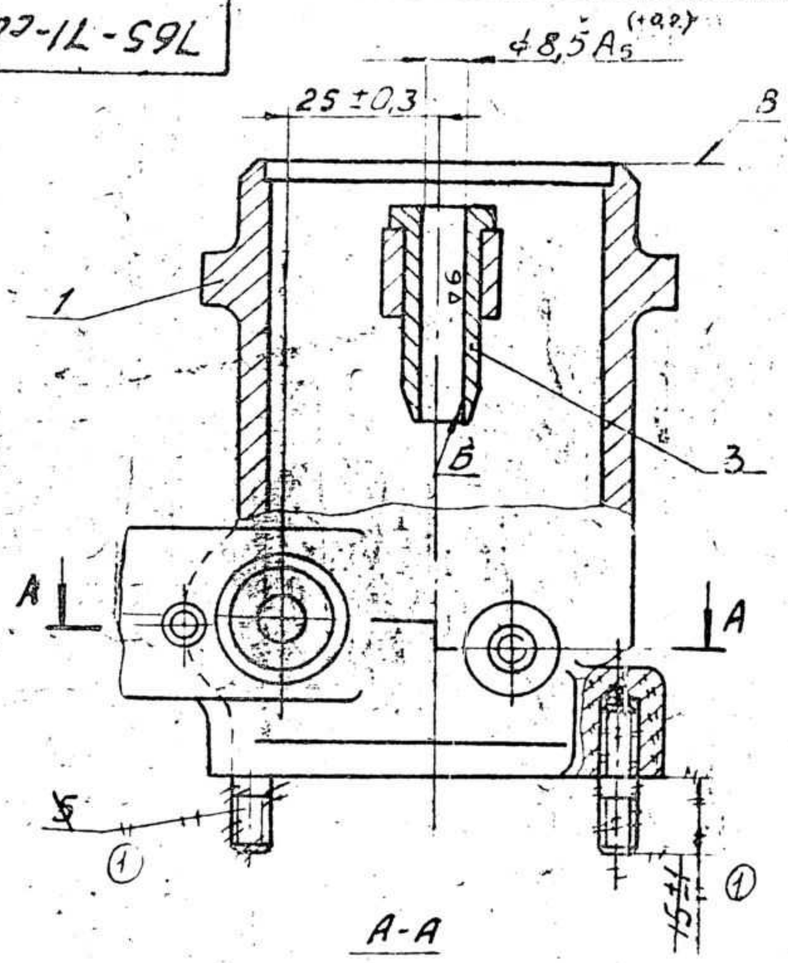
SHT. NO.	NO. OF SHT.
6	6

CIFE, [illegible]

Easy2Convert www.easy2convert.com

V 1-4-314

765-71-63587B



1. Non-squareness of axis of surface Б to surface B should not exceed 0.3 mm over the length of bush (Qualified tolerance).

2. Non-squareness of axis of surface Г to the axis of surface Б should not exceed 0,7 mm over a length 100 mm

3. Apply primer ФЛ-03Ж, GOST 9109-76 and enamel ПФ-223, White-1, GOST 14923-78 on the external surfaces except locating surfaces

4. Bushing, Ref.nos: 2 and 3, may be cooled in liquid nitrogen.

COATING

EXTERNAL SURFACE OF THE BODY SHALL BE APPLIED WITH PRIMER CONFORMING TO IS: 5660-70 & PAINTED WITH ENAMEL CONFORMING TO IS: 2932-74 (SHADE NO 365 OF IS: 5-78) EXCEPT LOCATING SURFACES.

SURFACE FINISH

▽3 :- REPRESENTS SURFACE FINISH TO BE OBTAINED IN Ra VALUE 2.0 μ MAX.

▽6 : REPRESENTS SURFACE FINISH TO BE OBTAINED IN Ra VALUE 2.5 μ MAX.

PILOT SAMPLE

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

(R. VEERARAGHAVA...)

4	-	765.772-79		15.10.79
3	-	765.224-79		28.5.79
2		765.610-78		23.5.78
1	-	765.797-78		19.5.78

765-71-63587B

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		CH.V.RAO.		26.7.84
EDT & CHKD		A.R.OOSLEY		3-8-84
F/M, DC		S.R.NAIR		30.7.84
DIV.OFFR.		T.K.BANERJEE		1.8.84
		NAME	SIGN	DATE

BODY
ASSEMBLY DRAWING

CTE, PUNE

SHEET	WEIGHT	SCALE
	0.49	

TOTAL SHEETS

ORDANANCE FACTORY PROJECT HYDERABAD

Инв.№ подл.	Подп. и дата	Взам.инв.№	Инв.№ дубл.	Подп. и дата
94 4670	14/8/84	95-310993		

Easy2Convert
www.easy2convert.com

FOR MAKE	ZONE	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
				Technical papers		
12			765-71-cδ358CB	Assembly drawing		
				Parts		
16		1	765-71-818	Body	1	
11		2	765-71-819	Bushing	1	
11		3	765-71-819-01	Bushing	1	
				Standard units		
		7		Lock-pin		
				$5Пр2_{2а}$ x28		HB 255 to 207
				ОСТ3-2234-80	1	(Ø3.8 to 4.2)

S.NO	SHT	DOC.NO.	SIGN	DATE
DRAWN		CH.V.RAO.		26.7.84
EDT&CHK		D.K. JAIN		28.7.84
F/M.D.C.		S.R.NAIR		30.7.84
DIV.OFFR.		T.K.BANERJEE		31.7.84
		NAME	SIGN	DATE

765-71-cδ358

BODY

SHT. NO	NO OF SHTS
1	2

ORDNANCE FACTORY

Easy2Convert
www.easy2convert.com

ZONE	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
			Materials		
	8		Sleeve IIITB-50-355-4.5		
			Non-coloured,		
			GOST 19034-73 l=14	1	

S.NO	SHT	DOC.NO.	SIGN	DATE
DRAWN		CH.V.RAO.		26.7.84
EDT&CHK		D.K. JAIN		28.7.84
F/M.D.C.		S.R.NAIR		30.7.84
DIV.OFFR.		T.K BANERJEE		31.7.84
		NAME	SIGN	DATE

765-71-CD358

1-1-3

SHT. NO	NO. OF SHTS
2	2

BODY

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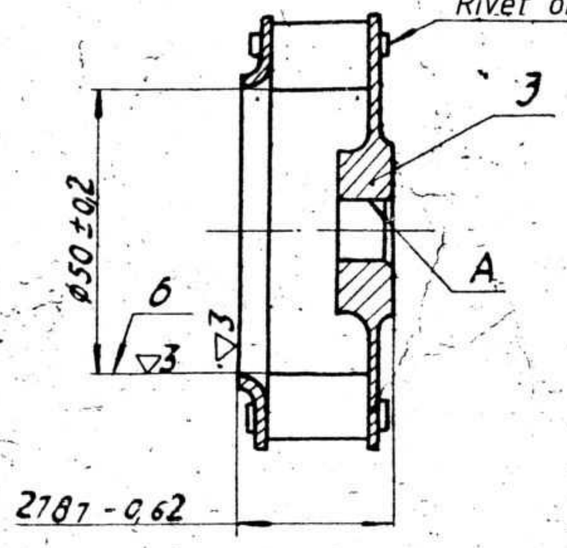
765-71-C6425



1) Non-squareness of blades to plane of flange is 0,6 max. over length of blade.

2) Run-out of surfaces Б and B with respect to axis of surface 'A' is 0,18 max. (Qualified tolerance).

3) After rivetting and machining of blades, looseness and rocking of blades are not permitted.

4) Under cut of blades on surfaces 'Б' upto 1 is allowed.

SURFACE FINISH

▽3 – REPRESENTS SURFACE FINISH TO BE OBTAINED IN Ra VALUE 20 μ MAXIMUM

PILOT SAMPLE

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

(R VEERARAGHAVAN)
SSO II

P.No.	Designation	Description	Qty	Remarks
4	765-71-1446	Ring	1	
2				
3	765-71-1090	Flange	1	
1	765-71-349	Blade	20	

765-71-C6425

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		Y.R.Ganesh		22.8.84
EDT, CHKD				29.8.84
F/M, DC		S.R.NAIR		31.8.84
DIV.OFFR.		T.K.BANERJEE		3.9.84
		NAME	SIGN	DATE

ROTOR

CIFE, PUNE

SHEET	WEIGHT	SCALE
	0.0 kg	1:1

TOTAL SHEETS

A3

Инв. № подл. | 95-35405 | Подп. и дата | Взам. инв. № | Инв. № дубл. | Подп. и дата

Easy2Convert
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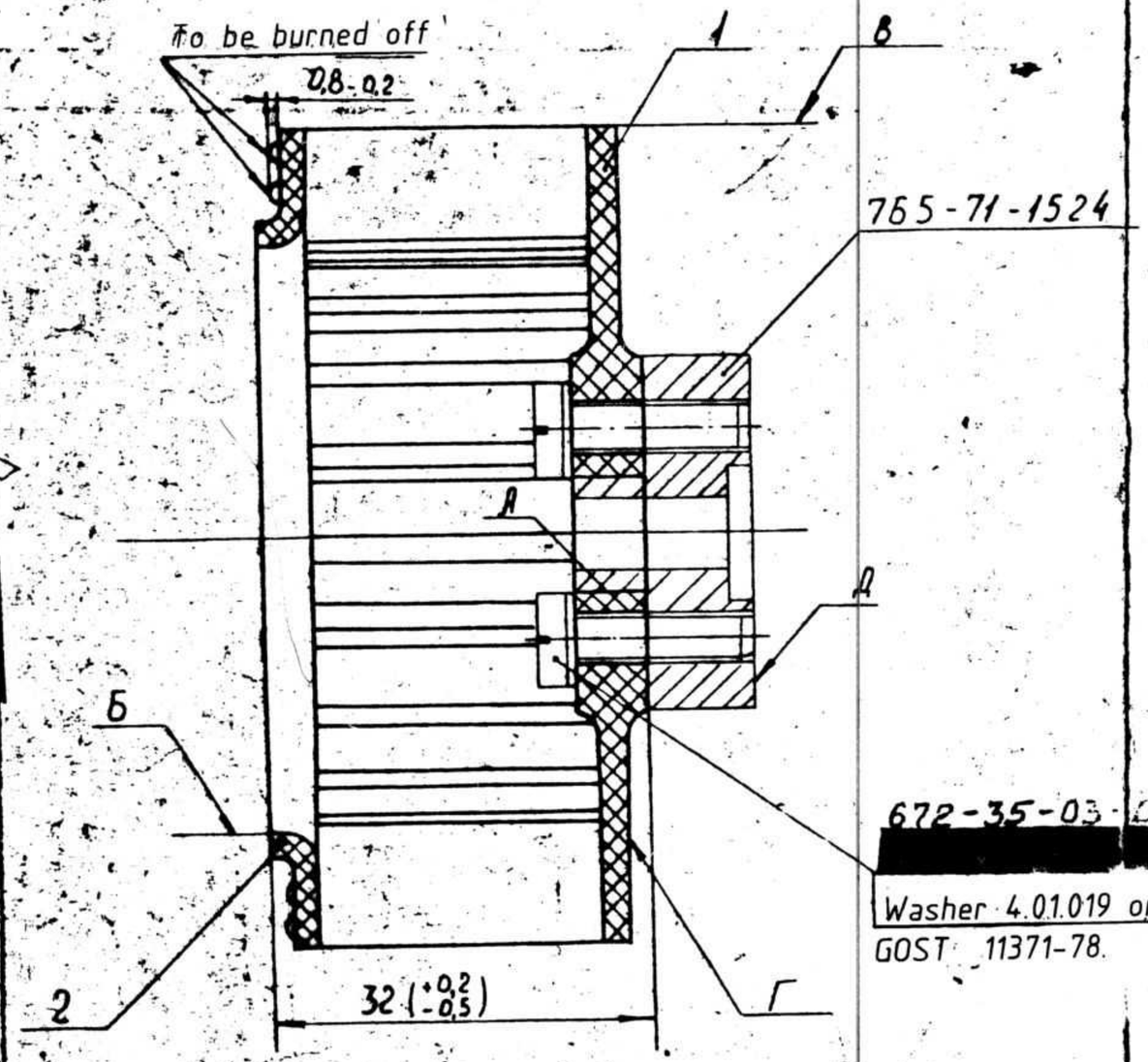
765-71-c856466



1. Non-squareness of blades to the plane of flange should not exceed 0.6 mm over blade length.

2. Radial run-out of surfaces Б and В with respect to axis of surface А should not exceed 0,16 mm.

3. After burning off projections loose fitting and shaking of blades and flange are not permitted.

4. Statically balance rotor together with carrier 765-71-1524, 672-35-3-02, with washers 4.01.019 or 4.02.019 GOST 11371-78. Static unbalance should not exceed 0.2 gram on 35 mm when balancing, it is permitted to drill holes 3 mm in diameter to a depth not exceeding 1 mm on radius R25 mm, between blades on surface Г and holes 5 mm in diameter to a depth not exceeding 15 mm on surface Д. In this case, balancing holes may not be brought beyond limits of contour of part 765-71-1524 and incision in thread is not permitted.

5. Make locating marks on rotor and carrier on each of screws and rotor, with enamel ПФ-223, Red, GOST 14923-78, after balancing.

6. Make the parts with same serial numbers and use them together.

765-71-c856466

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		CH.V.RAO.		27.7.84
EDT, CHKD				30.7.84
F/M, DC		S.R.NAIR		30.7.84
DIV.OFFR.		T.K.BANERJEE		1.8.84
		NAME	SIGN	DATE

ROTOR

ASSEMBLY DRAWING

SHEET	WEIGHT	SCALE
	0.05	2:1
TOTAL SHEETS		

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1-1-A3