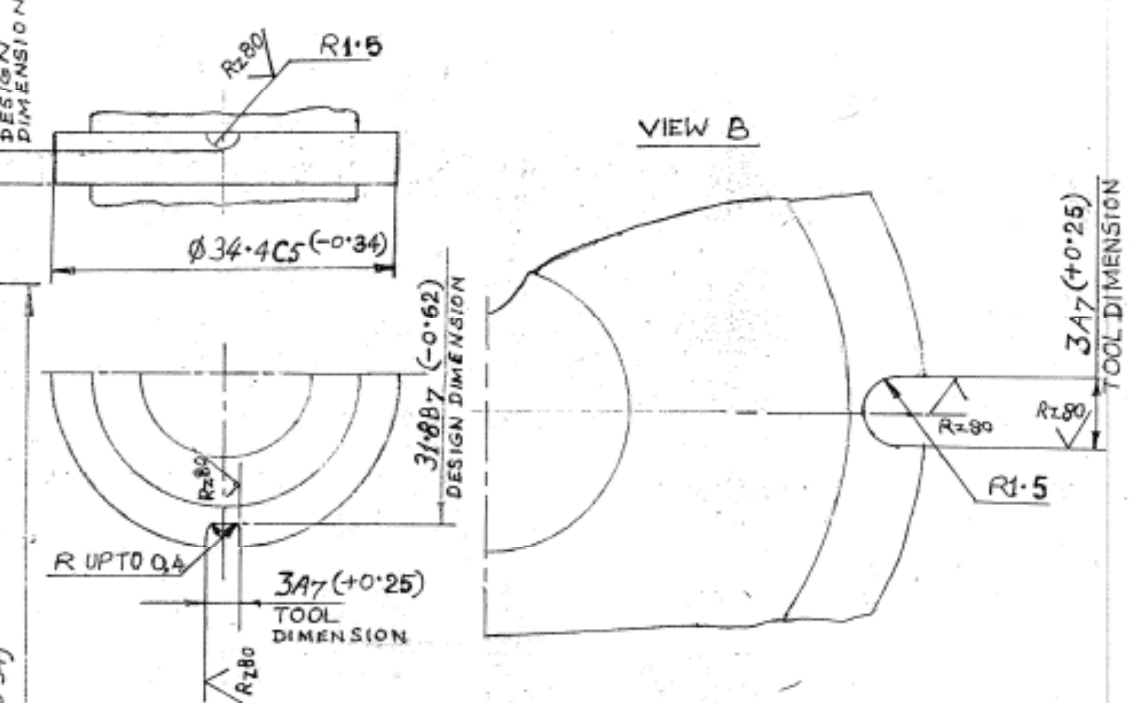
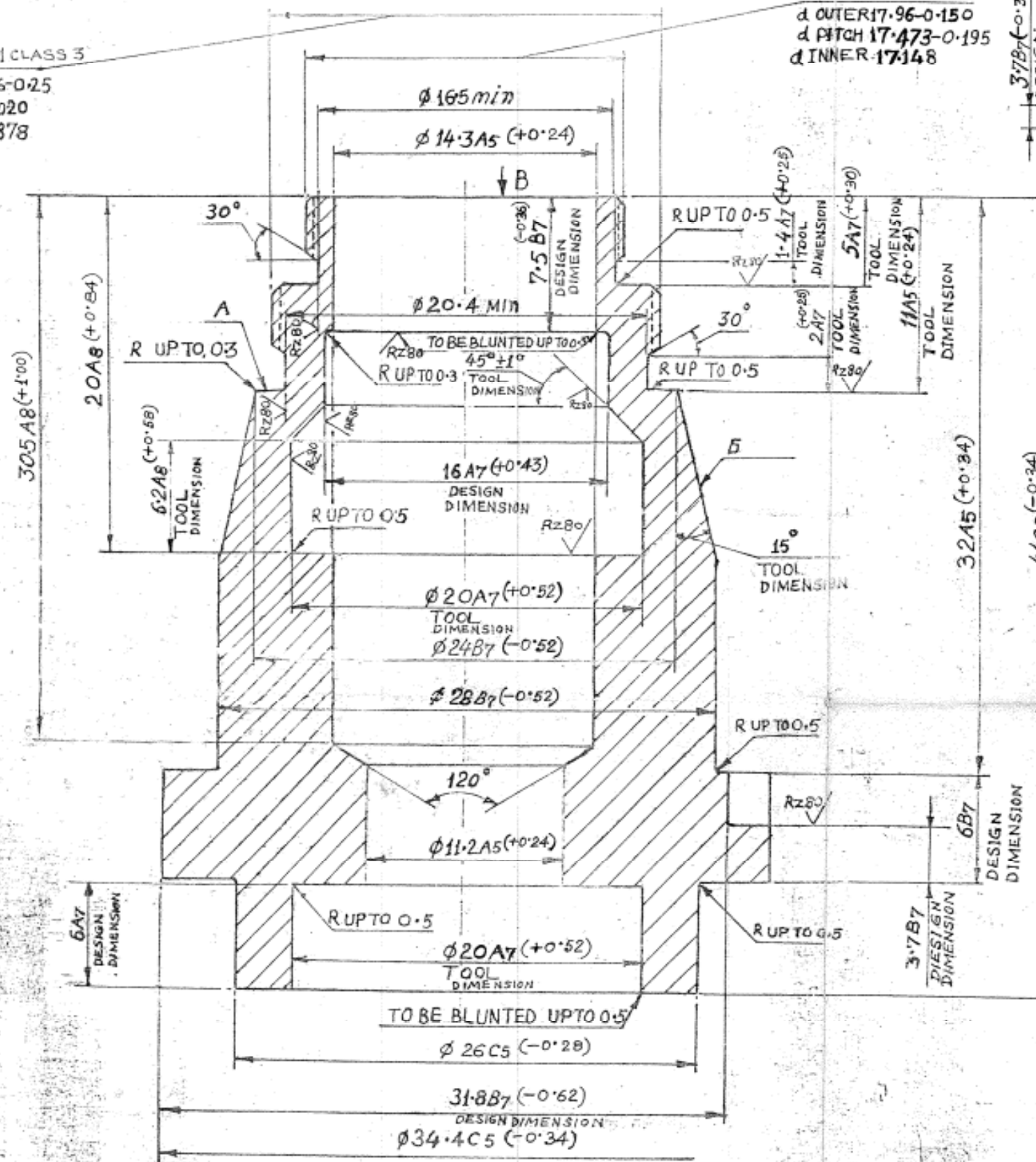


CNM 21-96 X1 CLASS 3
 d OUTER 21-96-0-25
 d PITCH 21-31-0-20
 d INNER 20-878

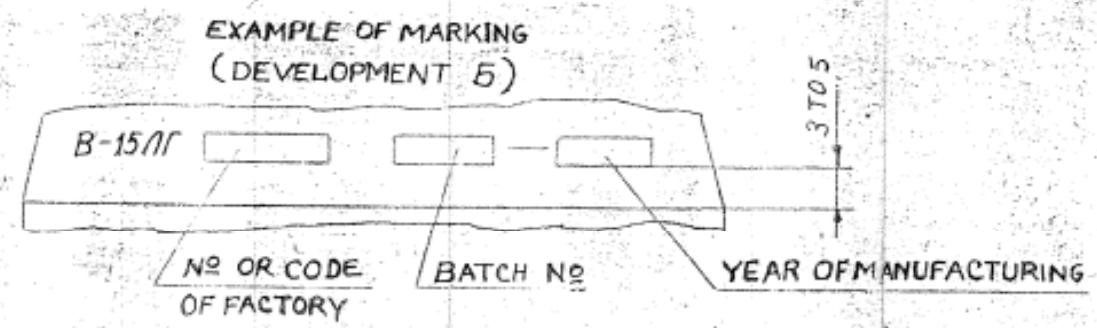
CNM 17-96 X0-75 CLASS 3
 d OUTER 17-96-0-150
 d PITCH 17-473-0-195
 d INNER 17-148

ALTERNATIVE
 SCALE 1:1



- * GRAIN GROWTH.
1. MARK WITH TYPE 2-5-3
 DEPTH OF THE MARKING SHOULD NOT EXCEED 0.5 mm.
 TRACES DUE TO ROLLING IN THE FORM OF SHORT DASHES IN QUANTITY NOT MORE THAN 5 PIECES WITH DEPTH 0.3 mm ARE ALLOWED
 YEAR OF MANUFACTURING IS APPLIED IN THE FORM OF TWO LAST DIGITS OF CURRENT YEAR.
 2. ON THE SURFACES $\phi 16.5_{min}$ AND $\phi 20.4_{min}$ TRACES DUE TO THREAD CUTTING TOOL ARE ALLOWED.
 3. DEVIATION FROM PERPENDICULARITY OF THREAD CNM 21-96 X1 CLASS 3 TO THE SURFACE A SHOULD NOT BE MORE THAN 0.08 mm.
 4. MACHINING OF OUTER SURFACE CAN BE CARRIED OUT IN ASSEMBLY C51-2.
 5. COATING: CHROMATE PASSIVATION AS PER DEF. 130
 6. MATERIAL ALLOWED: BAR A 16T KP GOST 21488-76.
 7. STAMPING IS ALLOWED TO BE CARRIED OUT IN ASSEMBLY C51-2
 8. IN CASE OF MANUFACTURING PART 1-2 WITH $\phi 8.6-0.15$ INSTEAD OF $\phi 11.2 A5$ $\phi 11.8 A5$ TO BE MANUFACTURED.
 9. SPANNER SLOT CAN BE PREPARED AS PER VARIANT.
- INDIGENOUS EQUIVALENT MATERIAL - ALUMINIUM ALLOY TO SPEC. IS 733 DESIGNATION 24345 IN 'W' CONDITION OR BS 1474 GRADE 2014A IN T4 CONDITION. (LATEST ISSUE) COMPONENT SHOULD BE FREE FROM PERIPHERAL *

REV	DATE	AUTHORITY	REVISION	ZONE	AHSP
1	19-9-94	D.C. 35811-A	INDIGENOUS EQUIVALENT MATERIAL ADDED		
2	13-12-95	DC 35634-A	NOTE-5 DELETED & AMENDED		
3	19-7-91	DC 35138-A	* SHOWN NEAR MARKINGS ON DRG. CONC. REGARDING * ADDED.		
4	9-4-87	D.C. 34107-A	IN SECTION VIEW, FLANGE THICKNESS 3.787 SHOWN CORRECTLY SECTIONED.		
5	28-10-85	D.C. 35383-A	DRG. SEALED PROV.		



REV	DATE	AUTHORITY	REVISION	ZONE	AHSP
1	26-8-97	DC 36325-A	INDIGENOUS EQUIVALENT MATERIAL COMPONENT - SRM GR. (MIL) ADDED		
2	1-3-96	DC 36095-A	NOTE NO. 5 AMENDED.		

* NOTE FOR MARKING ON INDIGENOUS PRODUCTION REFER DRG NO CQA(A)/AMN/2817 *

APPD.		3-024044	3B15
	FOR C.I. (A)	BODY	1-3
AHSP: CIA KIRKEE	OTE/PG/009	BAR A, 1T-KP	SCALE 5:1
		GOST 21488-76	

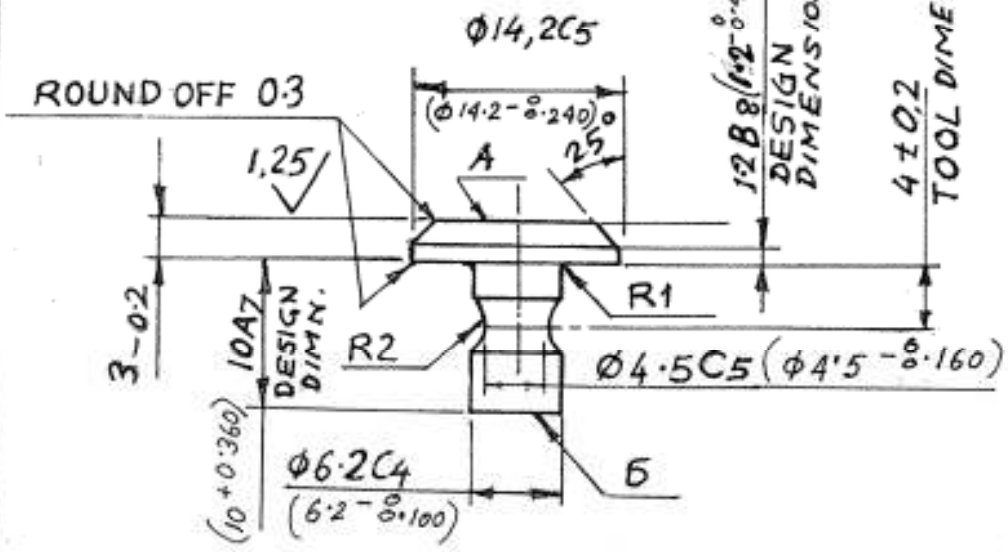
1-1

3-024044



R=80 ✓ (✓)

INDIGENOUS EQUIVALENT MATERIAL:- STEEL TO SPEC IS6603.
 GRADE 30 C₂ 13 OR 40 C₂ 13 H&T TO HARDNESS HRC 40-45.
 (LATEST ISSUE)



1. Harden HRC 40 To 45
2. Concavity or Convexity on the surface A up to 0.03 mm.
3. Checking of hardness is carried out on the surface **B**
4. Material Allowed :

Round bar GOST 7417 - 75
 30 x 13. 40 x 13-T-B Gost 5949-75

5. Material ; Round bar GOST 7417 - 75
 95 x 18-T-B GOST 5949 - 75

1	9.4.87	D.C.34107-A	DIMM. 1-28g DESIGN WAS 1-28g DESIGN		
	28.10.85	D.C.1.33853-A	DRG. SEALED PROV.		
RNO	DATE	AUTHORITY	REVISION	ZONE	AHSP D.O. SIG

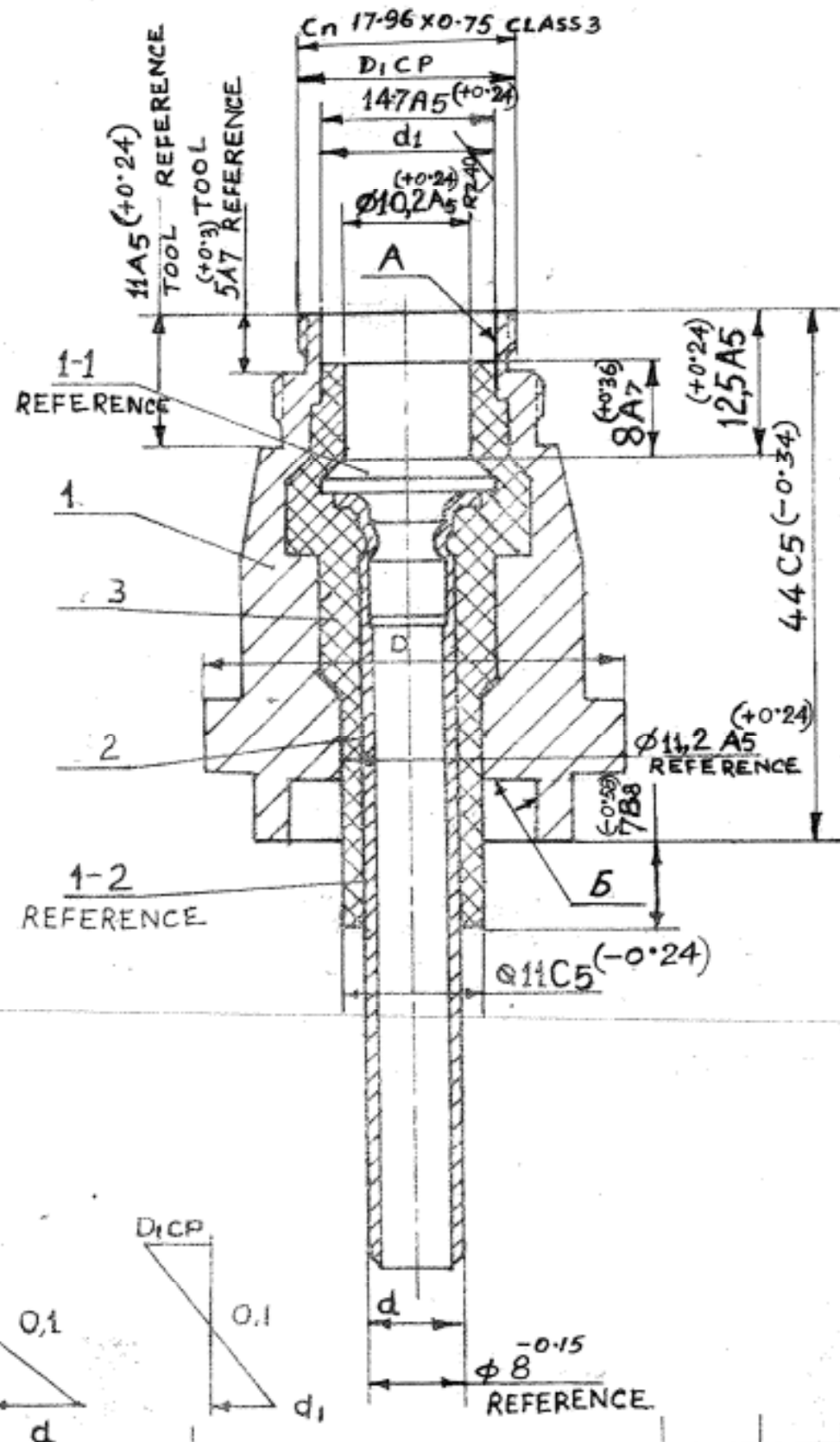
APPD. FOR C.I. (A)	3-024044		3815	
	Contact		1-1	
AHSP = CIA KIRKEE	See above		SCALE 2:1	

OTF/PG/008

CS-1-2

3 024044

INDIGENOUS EQUIVALENT MATERIAL - Moulding Material TO SPEC. IND/ME/351 (PROV) GRADE 'A' (LATEST ISSUE)



1. Dimensions $\phi 10$, 2A5, 8A7, and 12, 5A5 are subjected to final inspection. The remaining dimensions to be ensured by tool.
2. The flow of moulding material on the surfaces A and B is allowed.
3. Check the assembly on breakdown, feeding voltage 4000 V on the body 1 and contact 2. During this, leakage of current should not be more than 0.02 milliampere.
4. Check the continuity of the circuit between part 1-1 and 1-2 in the assembly.
5. After pressing the units are to be checked for 1 minute for airtightness under the pressure of 1.2 absolute atmosphere or vacuum of 0.8 absolute atmosphere.
6. After grinding, the moulding dimensions are permitted : $\phi 8^{-0.15}$ part 1-2 upto $\phi 8^{-0.23}$ and dimension 44 C 5 part 1-3 up to 44 B7
7. Shoulder on the surface A up to 0.5 high from the surface of the plastic mass is allowed.
8. It is permitted to obtain dimension $\phi 8^{-0.15}$ in the unit CS 1-2 : in this case part 1-2 must be with dimension $\phi 8^{-0.15}$ instead of $\phi 8-0$, and part 1-3 with $\phi 11.8 A5$ instead of $\phi 11.2 A5$.
9. Decrease of dimensions 5A7 tool, and 11A5 tool on the part 1-3 up to 4.9 mm and 10.9 mm respectively is allowed after pressing the unit.

Sl. No.	Code	Nomenclature	Qty.	Note
1.	1-3	BODY	1	OTF/PG/009
2.	CS 1-1	Contact with tube	1	OTF/PG/010
3.		Moulding Material AF-4 B GOST 20437-75		

OTF/PG/011 3 - 024044 3 B 15

R No	DATE	AUTHORITY	REVISION	ZONE	AHSP	D.O.
	19-9-54	DC 35811-A	INDIGENOUS EQUIVALENT MATERIAL ADDED.			
	28-10-85	D.C.I. 35853-A	DRG. SEALED PROV.			

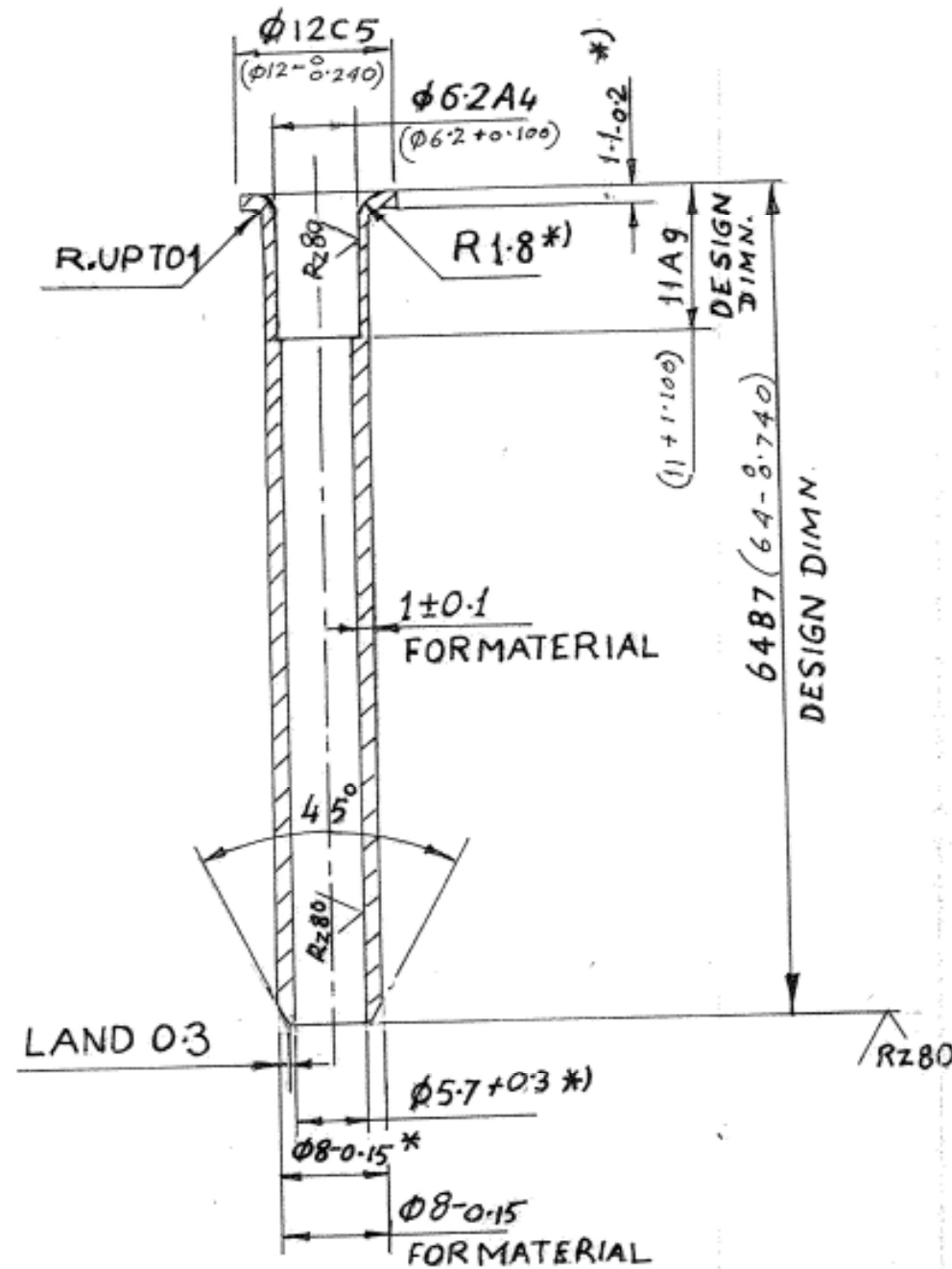
APPD
FOR CI (A)
AHSP: CIA KIRKEE
Body with Contact,
CS 1-2
SCALE 2:1

2:1

3 024044 E



R240 ✓ (✓)



1. Land 0.3 and angle 45° are allowed to be manufactured in the unit C 6 1-1
2. Sizes $\phi 8-0.15$, $1.1 - 0.2$, $R 1.8$, $\phi 5.7 + 0.3$ marked by asterisk are given additionally when Manufacturing the parts out of bar, size 1 ± 0.1 material is given for manufacturing the Parts out of tubes.
3. Material allowed: Bar ϕ IT KP GOST 21488-76.
4. Size $\phi 8-0.15$ can be obtained in the units C 6 1-2, in this case instead of $\phi 8-0.15$, $\phi 8.6-0.25$ to be manufactured.

In this case increase of $\phi 5.7 + 0.3$ upto size $\phi 6.25$ on a length of 40 mm from the lower end is allowed.

Circular tube $8 \times 1 \phi$ IT GOST 18475.73.

INDIGENOUS EQUIVALENT MATERIAL: ALUMINIUM ALLOY DRAWN TUBE TO SPEC IS 738, GRADE 24345 IN 'W' CONDITION. (LATEST ISSUE)

OR

AL ALLOY BAR TO SPECIFICATION IS : 733 GR. 24345 IN 'W' CONDITION

RNO	DATE	AUTHORITY	REVISION	ZONE	AHSP	D.O.	SIG
	14.11.07	D.C.37147-A	INDIGENOUS EQUIVALENT MATERIAL ADDED				
	19-9-94	D.C.35811-A	INDIGENOUS EQUIVALENT MATERIAL ADDED.				JW
1	9.4.87	D.C.34107-A	UNDER NOTE NO 4 $\phi 8-0.15$ WAS $\phi 3-0.15$ & DIMN. $5.7+0.3$ WAS 5.7 ± 0.3				BL
	28-10-85	D.C.133853A	DRG. SEALED PROJ.				JL

APPD.

AHSP: CIA KIRKEE

FOR C.1 (A)

3 - 024044		3 B 15	
TUBE		1 - 2	
		SCALE 2:1	
MATERIAL :- SEE ABOVE			

OTF/PG/004

YAWMAG

YAWMAG