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DWG NO 064391A-01

SH 1

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SHEET REV RECORD

ALL SHEETS ARE THE SAME REVISION

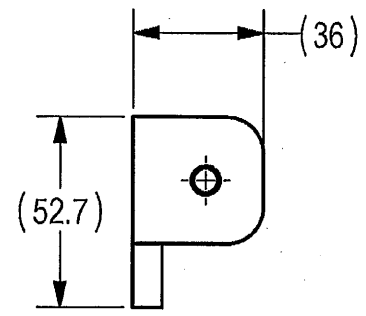
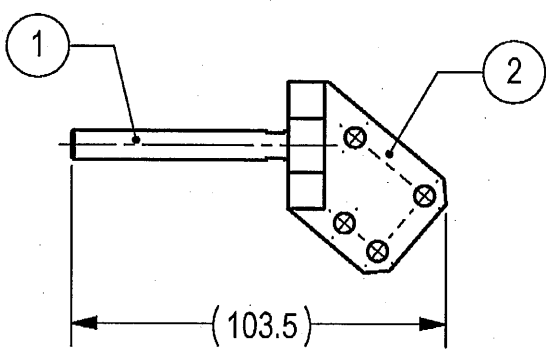
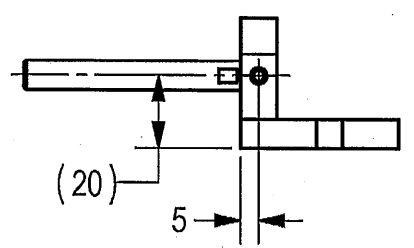
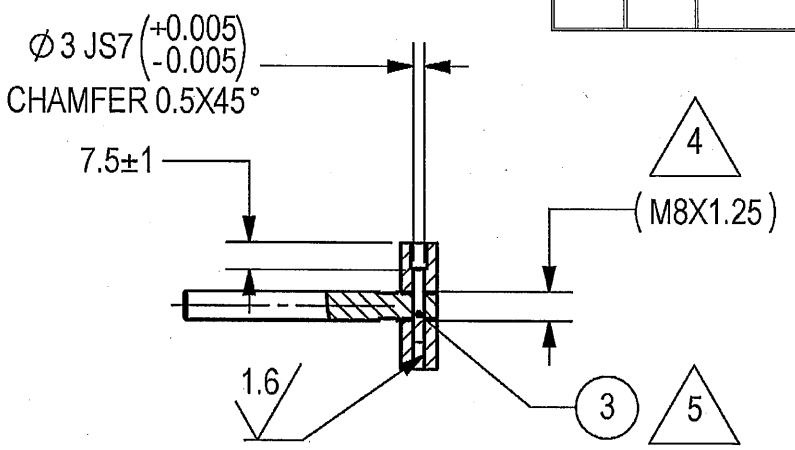
REVISION RECORD

REV	ECO	DESCRIPTION	DATE	APVD
--	ZR0936/00	Released	26-Feb-19	Z. Rabayev

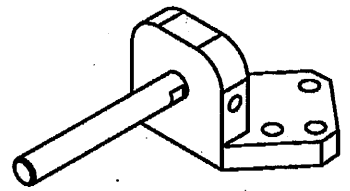
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NOTES :

- INTERPRET THIS DRAWING IAW ASME Y14.100M.
- MATERIAL: SEE FN 1 AND FN 2 (BASE MATERIAL: CRES BAR TYPE 17-4PH AND STEEL ALLOY BAR SAE 4130 OR SAE 4340).
- DEBURR AND REMOVE SHARP EDGES APPROX. 0.3X45°.
- F/N 1 AND F/N 2 SHALL BE ASSEMBLED TOGETHER (USING M8X1.25 THREAD), BEFORE MACHINING. TIGHTEN F/N 1 WITH TORQUE OF 20Nm ±5%.
- USE F/N 100 TO SECURE ASSEMBLY.
- QUALITY ASSURANCE PROVISIONS ANSI/ASQC Z1.4 ALL DIMENSIONS AND FINISH PER SQUEGLIA C=0 AQL 2.5% KEY DIMENSIONS 100% INSPECTION (MARKED BY FLAG KEY) VISUAL INSPECTION 100%.
- PARENTHETICAL FIGURES ARE FOR REFERENCE ONLY.
- PACKAGING AND PACKING: THE FINISHED PART SHALL BE PRESERVED AND PACKAGED IN ACCORDANCE WITH MANUFACTURER'S BEST COMMERCIAL PRACTICE.
- IDENTIFY PER MIL-STD-130 PARA 4.1.B, BY LABELING ITS CONTAINER WITH THE PART NUMBER. CHARACTERS MINIMUM TEXT HEIGHT 1.25 MM.



SEE ATTACHED MEDIA  
SEE SEPARATE PARTS LIST



UNLESS OTHERWISE SPECIFIED		SIGNATURE	DATE	ORDNANCE FACTORY TIRUCHIRAPPALLI	
PROFILE:  N/A	DRAWN	<i>[Signature]</i>	21/12/20	TITLE	
TOLERANCES LINEAR ISO-2768-c	CHECKED			FOR: BELLEVILLE WASHER	
ANGULAR ISO-2768-c	HOS/DDO	<i>P. Tam</i>	21/12/20	OF: 12.7MM SRCG	
1st. ANGLE PROJECTION	OFFICER/PRODN			SIZE	CAGE CODE
	OFFICER/QC			B	2291A
PROJECT OFFICER <i>[Signature]</i>	OFFICER/DDO	<i>Dinesh</i>	21/12/20	DWG NO	064391A-01
Approximate Weight: 0.194 [Kg]	SURFACE TEXTURE IN Micro Meter		SCALE 1:2	AUTOMATED DRAWING (SW)	SHEET 1 OF 1

PLM Control

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ASSEMBLY PARTS LIST

Assembly Parts List For: 064391A-01

Rev: -

Status: Released

Description: BRACKET ASSY 1

FN	CMD	PART NUM	ECO	DESCRIPTION	MB	QTY	U/M	REF. DES./REMARKS	MFG. PN / CUSTOMER	LA	LI
1	MP	062341A-00		SHAFT, BELLEVILLE	M	1	Each				
2	MP	062339A-00		BRACKET, BELLEVILLE	M	1	Each				
3	HO	00111359N		PIN DOWEL ST 3X20MM	P	1	Each		53113-DIN 6325-3M6X20		
100	YR	99962365M	ZR0936	ADHESIVE RETAINING	P	10.000	GM		52122-LOCTITE 635		

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DWG NO 062341A-00

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SHEET REV RECORD

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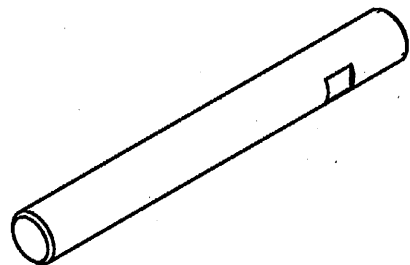
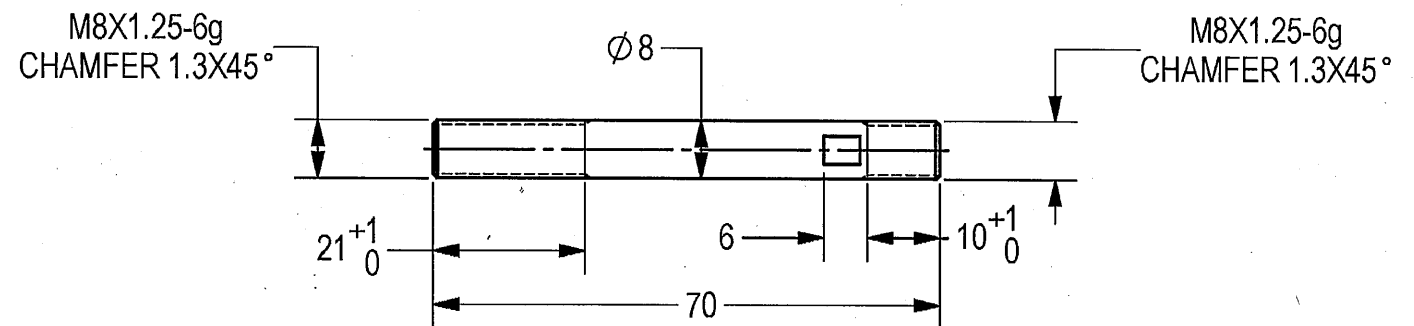
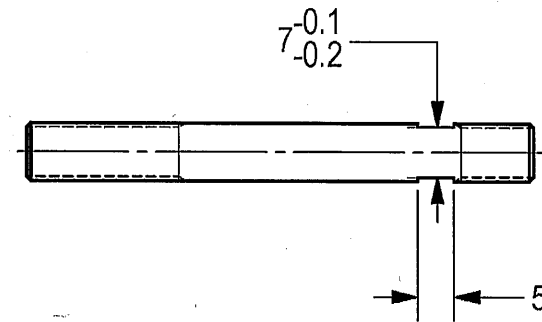
REVISION RECORD

REV	ECO	DESCRIPTION	DATE	APVD
01		Freeze	14-Jun-12	
02		Freeze	23-Nov-12	
03		Freeze	05-Jun-13	
04		Restricted	24-Dec-13	
--	T00064	Identical To Previous Released	09-Apr-18	L. Goldshtein

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NOTES:

1. INTERPRET THIS DRAWING IAW ASME Y14.100M.
2. MATERIAL: CRES BAR TYPE 17-4PH PER AMS 5643. (EQUIVALENT STEEL IS PERMITTED AFTER ELBIT APPROVAL).
3. HEAT TREATMENT TO H1150 PER MIL-H-6875 CLASS D.
4. DEBUR AND REMOVE SHARP EDGES APPROX. 0.3X45°.
5. PASSIVATION TREATMENT PER AMS-2700 METHOD 1 TYPE 8.
6. BAKE PART AFTER PLATING WITHIN 3 HOURS PER AMS-2759/9 TABLE 1 FOR 3 HOURS MINIMUM AT 191 °C.
7. QUALITY ASSURANCE PROVISIONS:  
7.1 QUALITY ASSURANCE PROVISIONS FOR THIS ITEM PER RDMQD00012P.
8. PACKAGING AND PACKING:  
THE FINISHED PART SHALL BE PRESERVED AND PACKAGED IN ACCORDANCE WITH COMMERCIAL PRACTICE.
9. IDENTIFY PER MIL-STD-130 PARA 4.1.B, BY LABELING ITS CONTAINER WITH THE PART NUMBER. CHARACTERS MINIMUM TEXT HEIGHT 1.25 MM.



(WEIGHT APPROX.: 0.033 Kg.)

SEE ATTACHED MEDIA

UNLESS OTHERWISE SPECIFIED		SIGNATURE	DATE	<b>ORDNANCE FACTORY TIRUCHIRAPPALLI</b>	
DIMENSIONS ARE IN MM PER ASME Y14.5M -1994		DRAWN	21/12		
TOLERANCES		CHECKED		TITLE	
LINEAR	ANGULAR	HOS/DDO	21/12	SHAFT, BELLEVILLE	
± 0.2	± 0.5°	OFFICER/PRODN		FOR: BRACKET ASSY 1 & 2	
1st ANGLE PROJECTION		OFFICER/QC		OF: 12.7MM SRCG	
SURFACE TEXTURE IN Micro M		OFFICER/DDO	21/12	SIZE	CAGE CODE
3.2/				B	2291A
				DWG NO	062341A-00
				SCALE	1:1
				AUTOMATED DRAWING (SW)	
				SHEET 1 OF 1	

PROJECT OFFICER  
*[Signature]*

PLM Control

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Designation	Description	Permissible deviations for basic size range							
		0.5 UP TO 3	over 3 UP TO 6	over 6 UP TO 30	over 30 UP TO 120	over 120 UP TO 400	over 400 UP TO 1000	over 1000 UP TO 2000	over 2000 UP TO 4000
f	fine	±0.05	±0.05	±0.1	±0.15	±0.2	±0.3	±0.5	--
m	medium	±0.1	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2
c	coarse	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	±4
v	very coarse	--	±0.5	±1	±1.5	±2.5	±4	±6	±8

For nominal sizes below 0.5 mm, the deviations shall be indicated adjacent to the relevant size(s)

SHEET REV RECORD

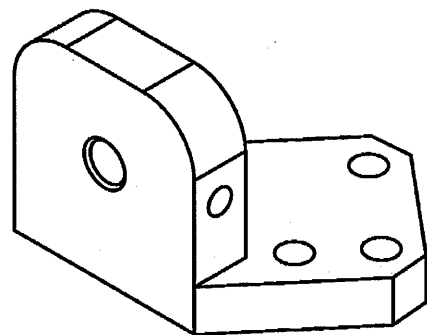
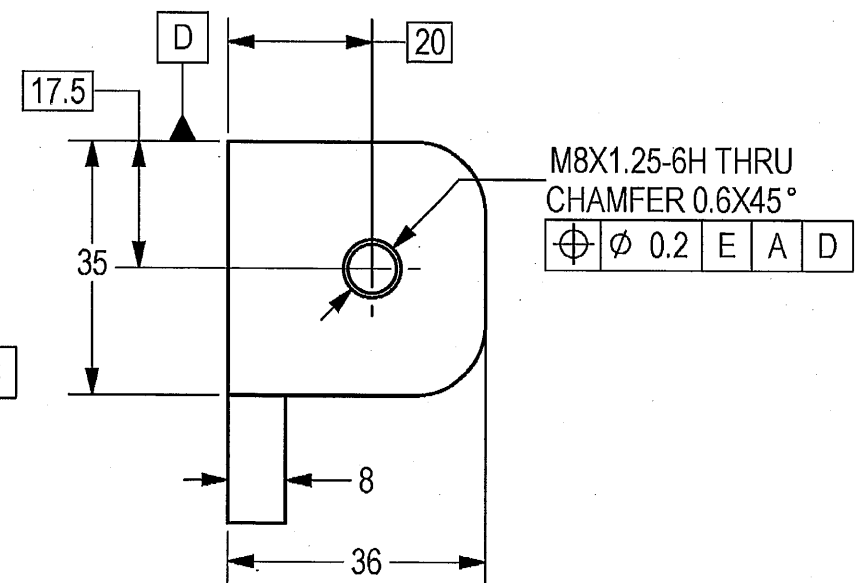
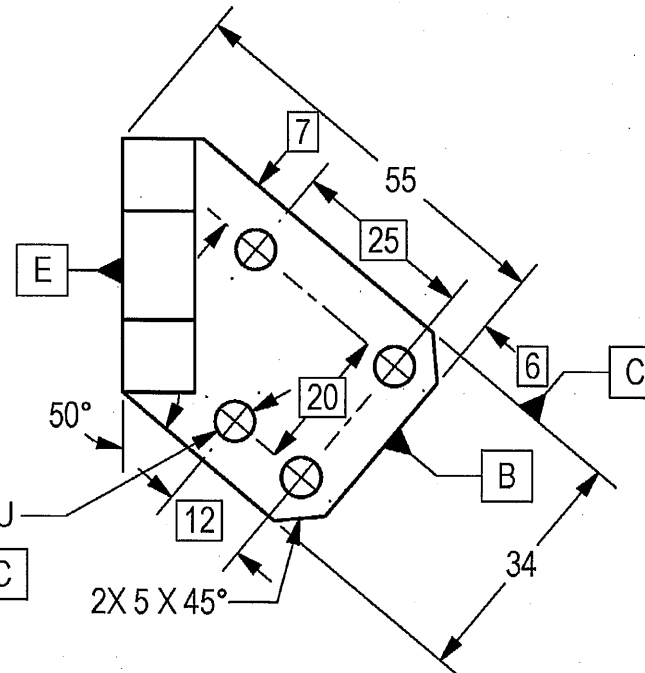
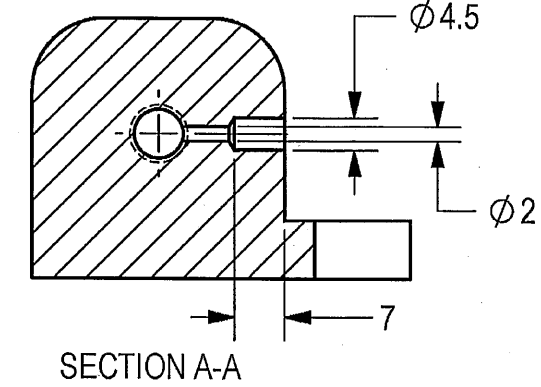
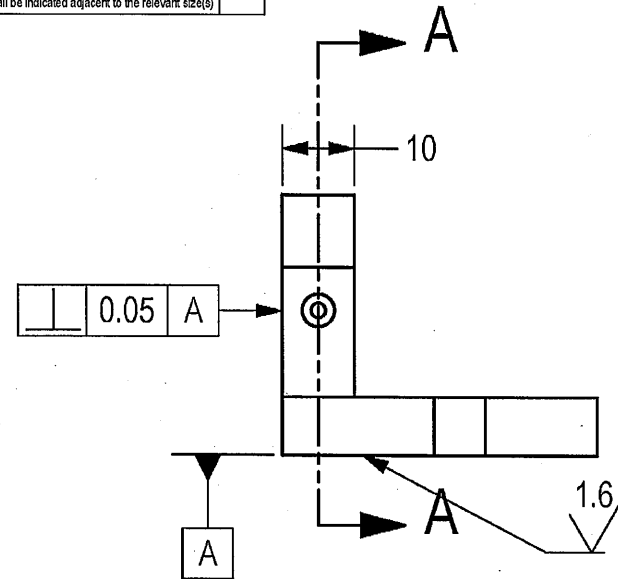
ALL SHEETS ARE THE SAME REVISION

REVISION RECORD

REV	ECO	DESCRIPTION	DATE	APVD
01		Freeze	14-Jun-12	
02		Restricted	30-Oct-13	
--	T00064	Identical To Previous Released	09-Apr-18	L. Goldshtein

NOTES:

- INTERPRET THIS DRAWING IAW ASME Y14.100M.
- MATERIAL: STEEL ALLOY BAR SAE 4130 PER SAE-AMS-S-6758 OR SAE 4340 PER SAE-AMS-S-5000. (EQUIVALENT MATERIAL IS PERMITTED AFTER ELBIT APPROVAL).
- HEAT TREATMENT: QUENCH AND TEMPER ENTIRE PART; HARDNESS 35±4 HRC.
- DEBURR AND REMOVE SHARP EDGES APPROX. 0.3X45°.
- GENERAL TOLERANCES ACCORDING TO ISO 2768-m.
- PHOSPHATE COATING TYPE M, CLASS 2, 0.005-0.010 MM THICK PER MIL-DTL-16232.
- THE DIMENSIONS ARE BEFORE COATING.
- QUALITY ASSURANCE PROVISIONS: 8.1 QUALITY ASSURANCE PROVISIONS FOR THIS ITEM PER RDMQD00012P.
- PACKAGING AND PACKING: THE FINISHED PART SHALL BE PRESERVED AND PACKAGED IN ACCORDANCE WITH COMMERCIAL PRACTICE.
- IDENTIFY PER MIL-STD-130 PARA 4.1.B, BY LABELING ITS CONTAINER WITH THE PART NUMBER. CHARACTERS MINIMUM TEXT HEIGHT 1.25 MM.



(WEIGHT APPROX.: 0.160 Kg.)

SEE ATTACHED MEDIA

UNLESS OTHERWISE SPECIFIED		SIGNATURE	DATE	ORDNANCE FACTORY TIRUCHIRAPPALLI	
DIMENSIONS ARE IN MM PER ASME Y14.5M-1994		DRAWN	21/12/11	FOR: BRACKET ASSY 1	
TOLERANCES		CHECKED		TITLE BRACKET, BELLEVILLE	
LINEAR	ANGULAR	HOS/DDO	21/12/11	OF: 12.7MM SRGG	
SEE NOTE 5	SEE NOTE 5	OFFICER/PRODN		SIZE	CAGE CODE
1st ANGLE PROJECTION		OFFICER/QC		B	2291A
SURFACE TEXTURE IN Micro INCH		OFFICER/DDO	Dinesh	DWG NO	062339A-00
PROJECT OFFICER			21/12/11	SCALE	1:1
				AUTOMATED DRAWING (SW)	
				SHEET 1 OF 1	

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