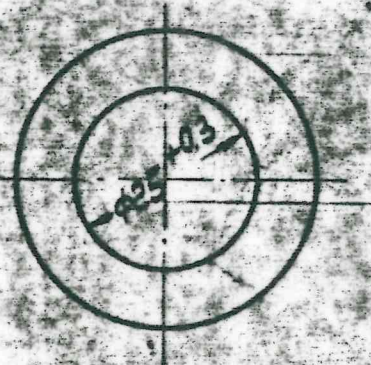


46-252

2



1). Tolerance are given for tooling.

SLNO	SHEET	DOCNO	SIGN	DATE
DRAWN BY	BHUSHAN			11.5.84
EDITED AND CHECKED BY	R.B. Sankar		Shree	14.5.84
FOREMAN OF DC	SHRAC		Sh	2/6
DIVISIONAL OFFICER				2/6
	NAME	SIGN	DATE	

ПОКРЫТИЕ

GASKET.

Textolite A, Sheet T = 0.5 2910-74

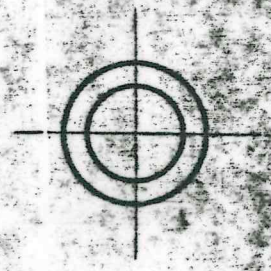
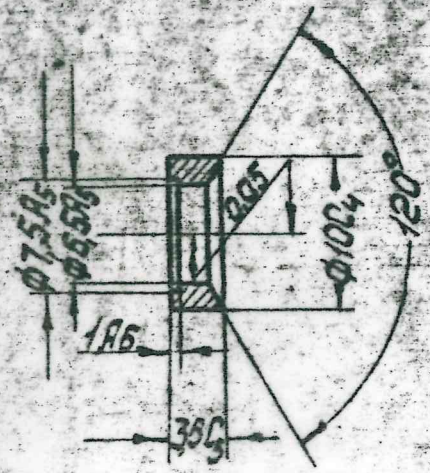
GOST

SHEETS	WEIGHT	SCALE
0	0.5 g ^m	1:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

252-94

252-97

76



Coating: Chemical passivation

252-97

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		BHUSHAN		11.5.84
EDT,CHKD		B. Sarma	B. Sarma	14.5.84
F/M,DC.		S.H. RAO	S.H. RAO	26
DIV.OFFR		S. Arora	S. Arora	26
		NAME	SIGN	DATE

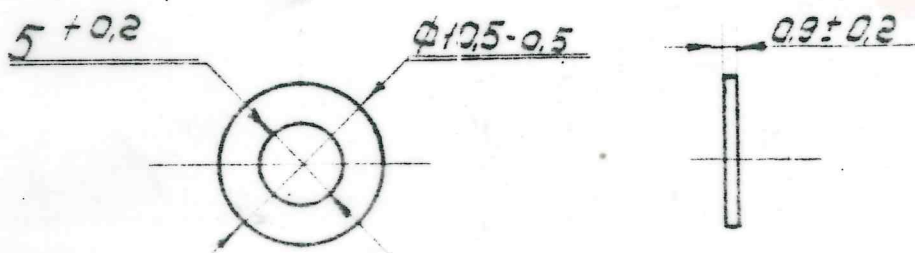
CLIP.

Bar AITKPN GOST
21488-76

SHEET	WEIGHT	SCALE
04	21	
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

ГОСТ 2.001-90

85-252



- 1) Tolerances are given for tool.
- 2) Impregnate with oil 132-20 TY-6-02-897-78 or oil 132-08 GOST 18375-73.

252-98

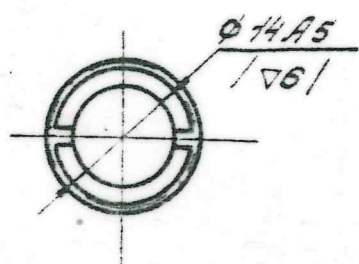
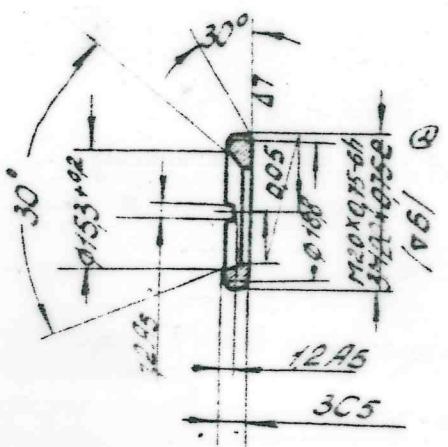
SHEET				DOC NO		SIGN		DATE		SHEET WEIGHT		SCALE	
DRAWN				R. Gajesh				18.5.84		0.05		2:1	
EDT & CHKD				D.K. JAIN		<i>[Signature]</i>		24.5.84				TOTAL SHEETS	
				24.08		2.16						ORDNANCE FACTORY PROJECT	

PACKING

ORDNANCE FACTORY PROJECT

Unless otherwise specified

252-114

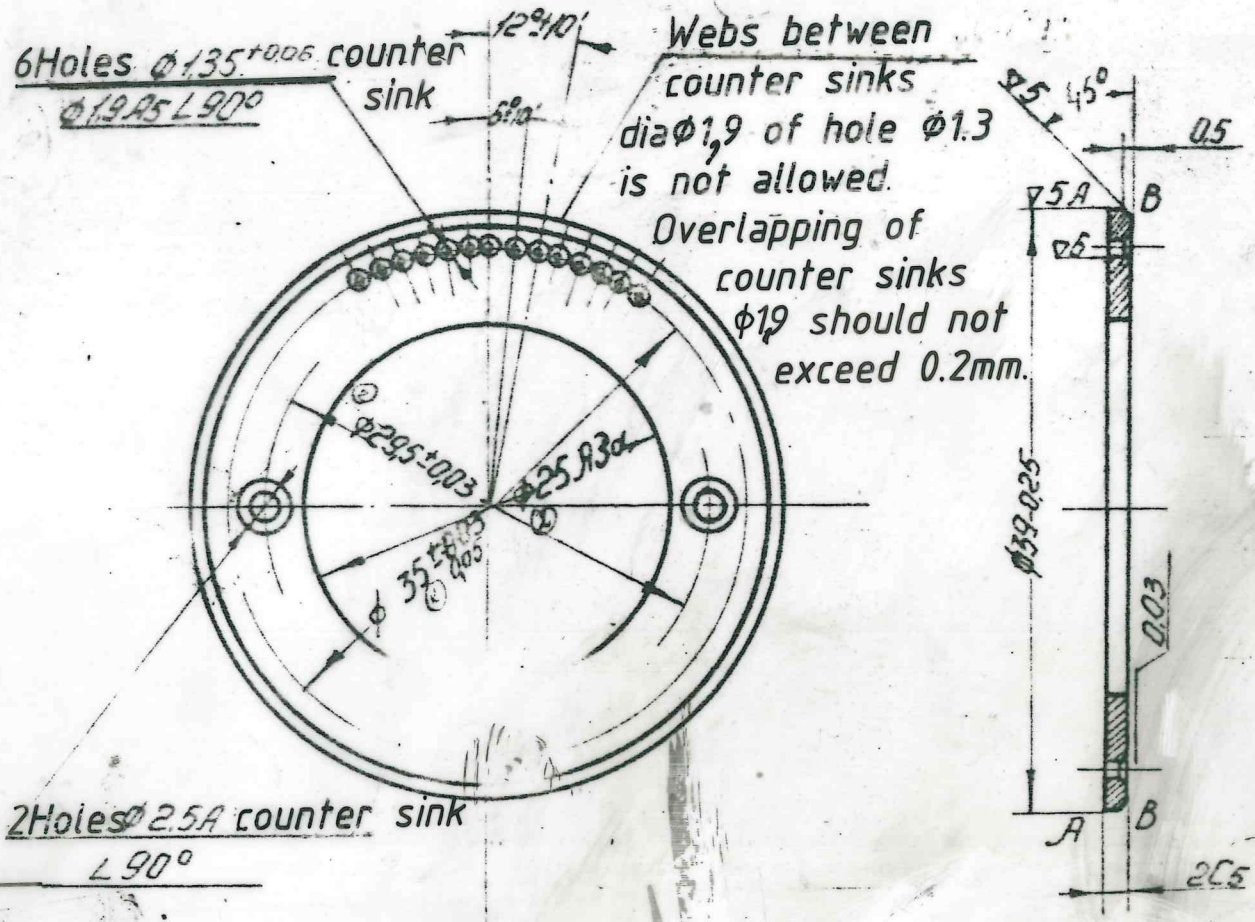


Coating :- Chemical oxidation.

252-114

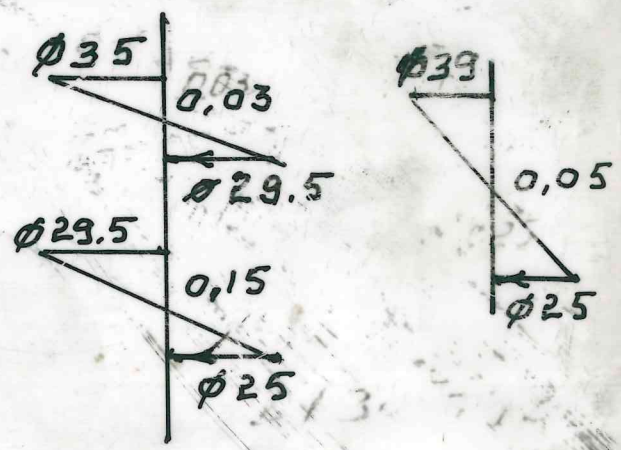
252-190

▽7 Unless otherwise specified.



- 1). Carry out aging after stamping at $t = +350 \pm 15^\circ\text{C}$ for 2 hours.
- 2). Non-parallelity of planes A-A BB should not exceed 0.02mm.
- 3). Coating: Chemical passivation.

Eccentricity



252-190

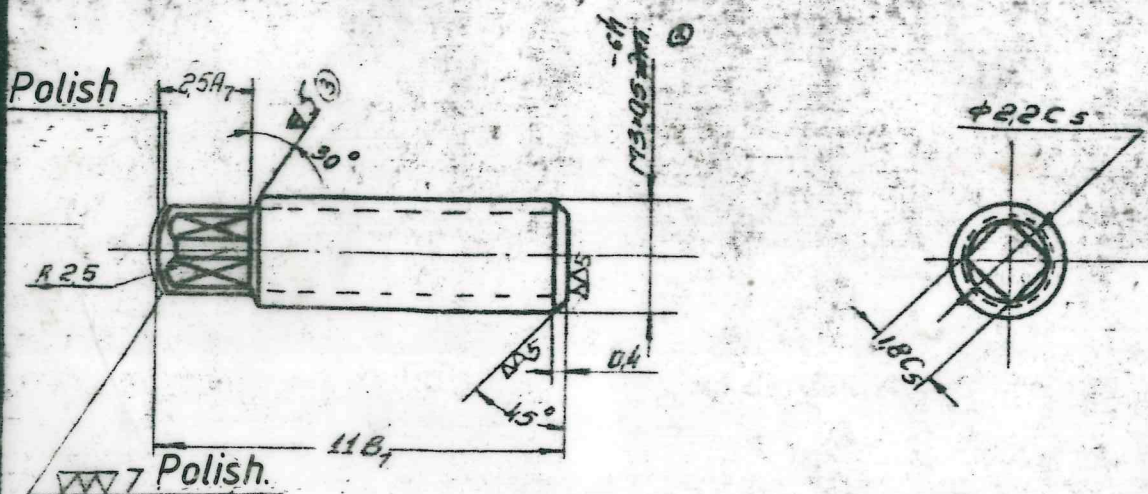
SNO	SHT	DOC NO	SIGN	DATE
DRAWN		BHUSHAN		
EDT, CHKD		D.K. JAIN	<i>[Signature]</i>	19.5.89
F/M, DC		S.HRAO	<i>[Signature]</i>	2/6
DIV.OFFR.		D.A. [Signature]	<i>[Signature]</i>	2/6
		NAME	SIGN	DATE

CAGE RING.

Bronze bp AM4 9-2-T
Sheet 7.3.15 GOST 1595-71.

SHEET	WEIGHT	SCALE
9		2:1
TOTAL SHEETS		
ORDANANCE FACTORY PROJECT HYDERABAD		

∇6 Unless otherwise specified



1). Unspecified limit deviations of dimensions are as per 722AT.

SCALE INDEX OF PART = PART NO.
 5:1 252 193

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		BHUSHAN		18.5.84
EDT,CHKD		D.K. JAIN	<i>[Signature]</i>	19.5.84
F/M,DC.		S.H.RAO	<i>[Signature]</i>	2/6
DIV.OFFR		D.A. SANKAR	<i>[Signature]</i>	2/6
		NAME	SIGN	DATE

THRUST SCREW.

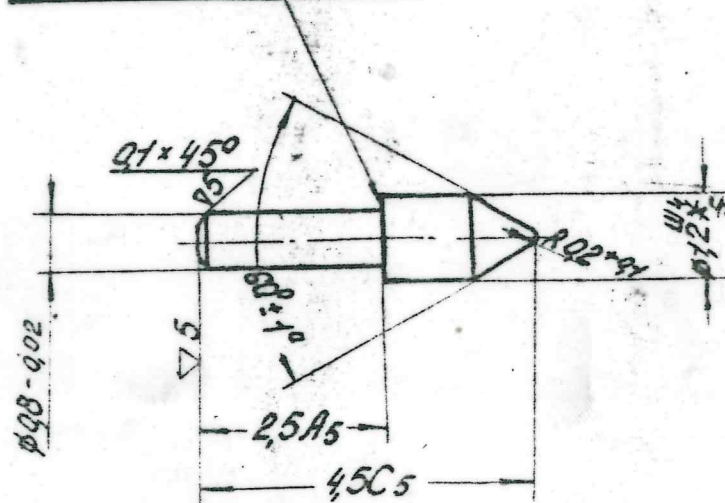
Steel 40x13 GOST 14955-77

SHEET WEIGHT	SCALE.
0.43	5:1
TOTAL SHEETS	
ORDNANCE FACTORY PROJECT HYDERABAD	

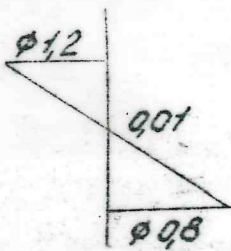
252-299

▽ 7 Unless otherwise specified.

R should not exceed 0.1.



ECCENTRICITY



Check correctness of radius of sphere against the screen.

252-299

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		CH.V.RAO	<i>[Signature]</i>	18.5.84
EDT,CHKD		D.K.JAIN	<i>[Signature]</i>	19.5.84
F/M,DC.		S.H.RAO	<i>[Signature]</i>	2/6
DIV.OFFR		D.A. [Signature]	<i>[Signature]</i>	8/2
		NAME	SIGN	DATE

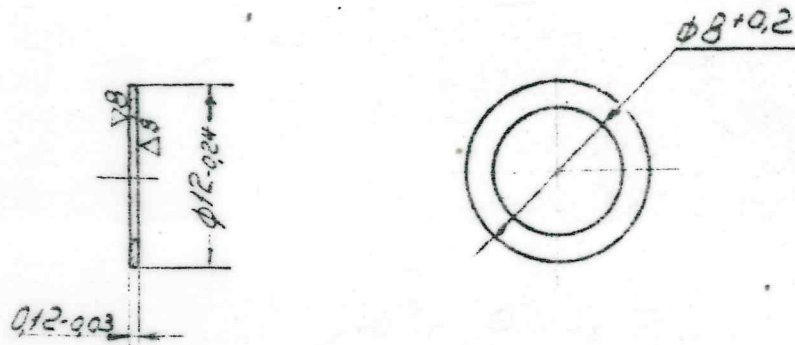
LOCK PIN

BRIGHT CARBON TOOL STEEL
 1.5-6-3 GOCT 14955-77
 25X13M2 TY14-1-721-73.

SHEET	WEIGHT	SCALE
8		10:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

252B-140

~ ALL OVER



1) Non parallelity of 0,01 is allowed.

252B-140

SN	SHT	DOC NO	SIGN	DATE
DRAWN		Y.R. Ganesh		16.5.84
EDT,CHKD		D.K. JAIN	<i>[Signature]</i>	17.5.84
F/M,DC		S. HRAO	<i>[Signature]</i>	2/6
DIV.OFFR		D.A. [Signature]	<i>[Signature]</i>	2/6
		NAME	SIGN	DATE

WASHER

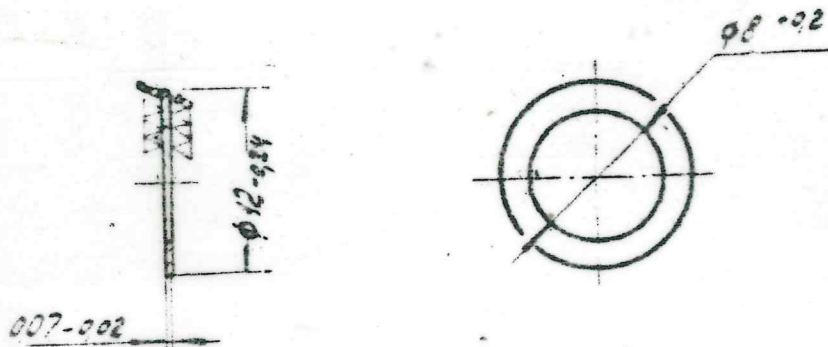
Bronze Bp KM 4 3-1" T"

GOST 4748-70

SHEET	WEIGHT	SCALE
	0.07	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT		

252B-141

Unless otherwise specified



1) Non parallelity of 0,01 is allowed.

252B-141

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		Y.R. Ganesh		16.5.84
EDT & CHKD		D.K. JAIN	<i>[Signature]</i>	17.5.84
F/M, DC.		S.H. Rao	<i>[Signature]</i>	2/6
DIV. OFFR		D.A. [Signature]	<i>[Signature]</i>	2/6
		NAME	SIGN	DATE

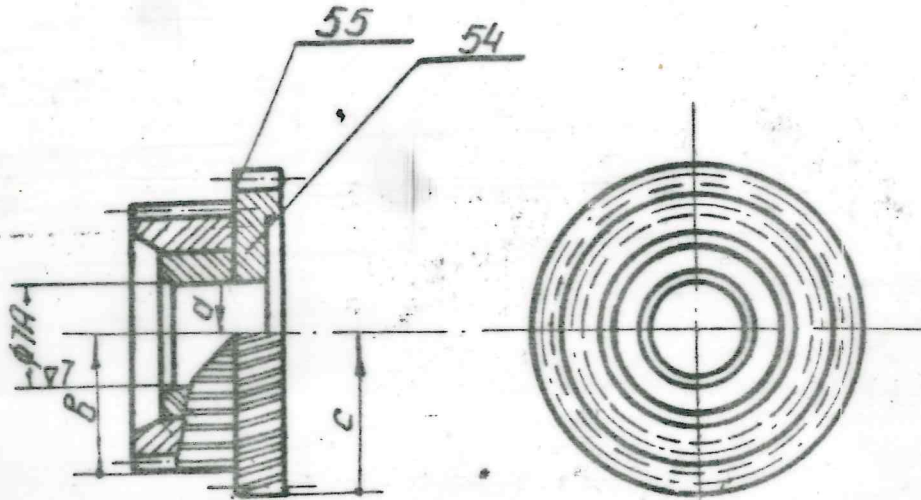
WASHER

BRONZE Бр КМЦ 3-1-"Т"
GOST 4748-70.

SHEET	WEIGHT	SCALE.
	0,035	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

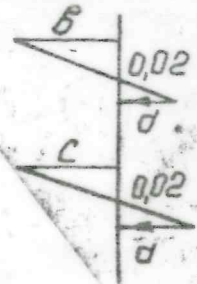
252-252

86



1. Part 54 should not rotate with a torque of 25kg.cm.

ECCENTRICITY



PART. NO.	QNTY	Description	NO. OF SHEETS	Remarks
54	1	Gear Z=30	40	
55	1	Gear Z=25	41	

252-252

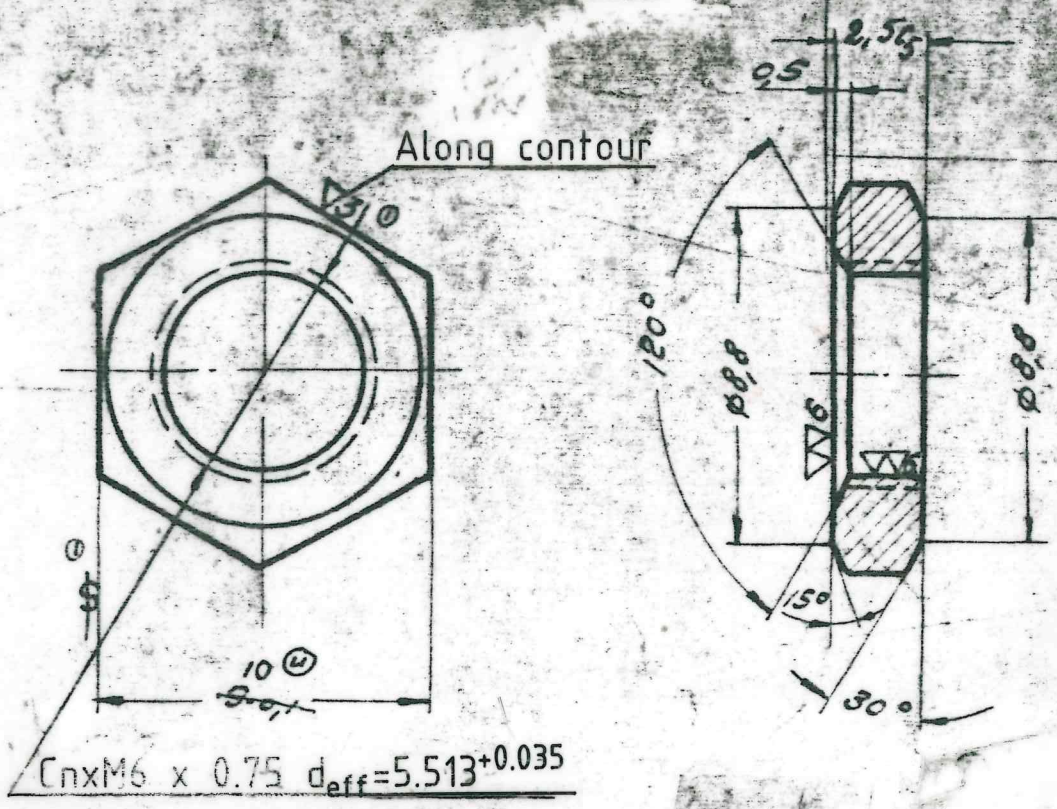
SN	SH	DOC NO	SIGN	DATE
DRAWN		P.R.BABU		17.5.86
EDT,CHKD		D.K.JAIN		18.5.84
F/M,DC		S.H.RAO		3/6
DIV.OFFR		D.A.BABU		4/6

STEPPED GEAR

SHEET	WEIGHT	SCALE
90	191	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

Play of butt-end
with respect to thread
should not exceed 0.04.

▽5 Unless
otherwise
specified.



1. Thread dimension is given with regard to coating.
2. Coating: Zinc, 6 microns, chromated.
3. Part may be manufactured from bar ПС 59-1Т.Ш.Н.Т-10, GOST 2060-73 with alternate surface finish ω is to be provided instead of ∇_3 .

D130-201

INDEX OF PART 253 B		PART NO 192	
LOCK PIN		SHEET	SCALE
		0.84	5:1
BAR ПС 59-1Т.кр.П.П.Т.-11 ГОСТ 2060-73.		TOTAL SHEETS	
		ORDNANCE FACTORY PROJECT HYDERABAD	

SNO	SHT	DOC NO	SIGN	DATE
	DRAWN	CH.V.RAO	<i>[Signature]</i>	18.5.84
	EDT,CHKD			
	F/M,DC.	S.H.RAO	<i>[Signature]</i>	
	DIV.OFFR	D.P. [Signature]	<i>[Signature]</i>	2/6
	NAME	SIGN	DATE	