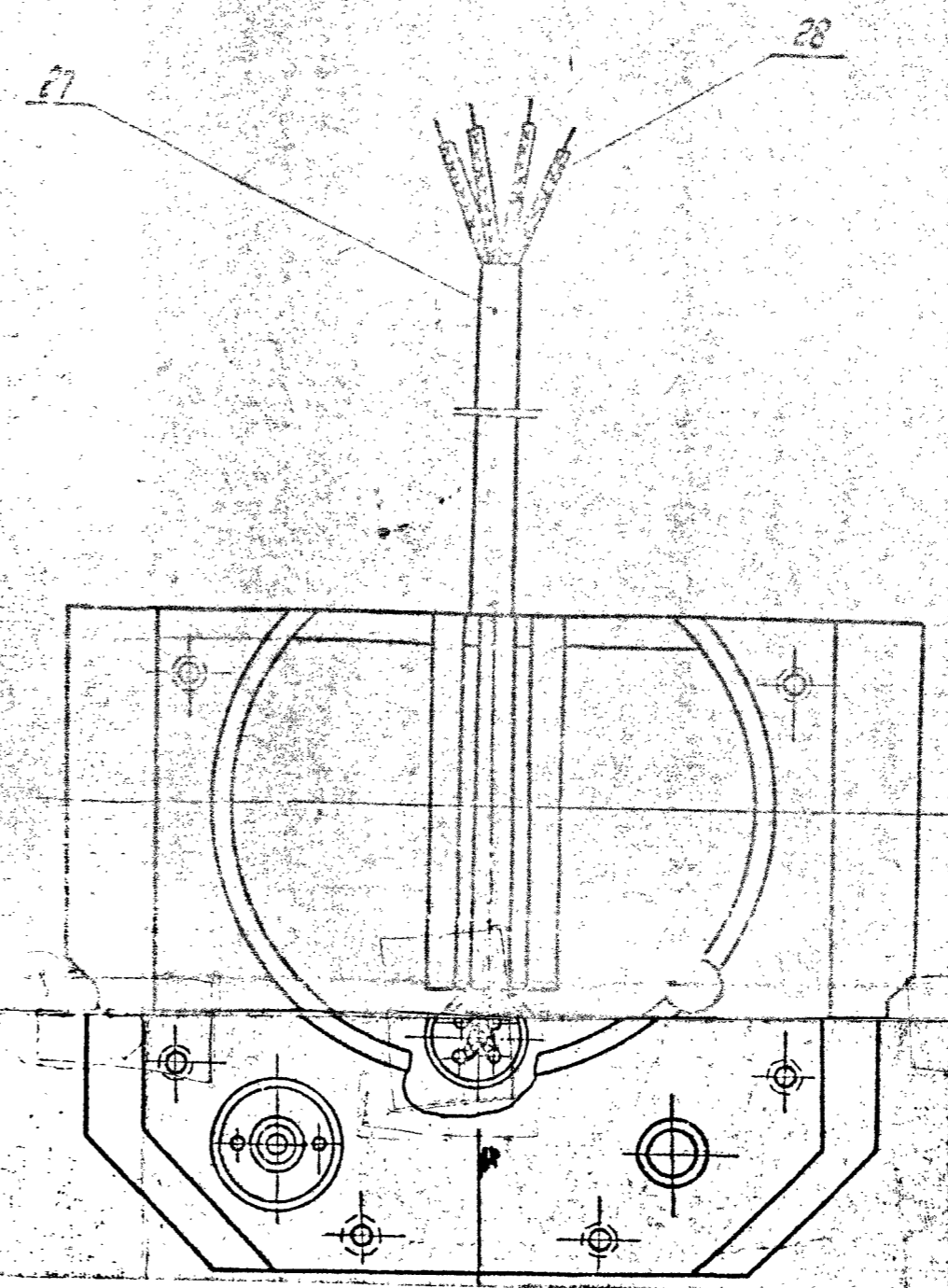


Drill 2holes $\phi 1.9^{+0.06}$ along part 127-11 and secure with pins,

- 14). For reliable caging it is allowed to bend part 9, 18-362.016 in situ.
- 15). Adjust the meshing of worm mechanism together with unit 127-cb5, Unit 127-cb5 is not shown for clarity.
- 16). Seal the soldered joints with varnish Ak-113 as per instructions 5T-33.



- 1). Lubricate with oil 132-20. before installing unit Ref. No.10 in device.
- 2). Frictional parts of cage are lubricant with oil 132-20.
- 3). Install studs Ref.No.23 on lubricant By GOST 7171-78. Instead of part Ref.No.23 part Ref.No.33 may be used.
- 4). Meshing of worm and part 2 over $\phi 32$ are lubricated with lubricant ok6-122-7.
- 5). Place washers Ref.No.6 and 7 if any for adjusting meshing.
- 6). Apply varnish yp-231 over screw heads.
- 7). Check as per Technical specification for unit 127-cb.
- 8). Solder conductors with noc-61 with flux π as per instructions β A.0443-003.
- 9). Conductor termination into the plug is carried out as per standard H.0.010.001.
- 10). Solder conductor Ref.No.28 to the first pin of plug.
- 11). Lock the screw Ref.No.29 with primer ϕ Л-086.
- 12). Tags Ref.No.31 and lugs Ref.No.32 on conductors, running from plug connector are not shown for clarity.
- 13). All external fasteners are coated with varnish yp-231 and internal fasteners are coated with primer ϕ Л-086 as per instructions 6 co-045-102.

27	Sleeve III	1	GOST 19034-73
34	3157A-3-10ka	1	
33	9, 18.927.001-2	2	
32	2046A-1-7	3	
31	Sleeve III-TB-40-230-2x	4	GOST 19034-73.
29	HK21.2124	1	
28	Conductor MГWB Red. S=0.35 L=305.	1	

Conductor MГWB S=0.14

26	l=245	3	Any colour.
25	3177A-5-9. K2	1	
24	25 36-192	2	
23	9, 18.927.001-1	2	
22	1-3-2-OCT110066-71	2	
21	4381A-2-1	1	
20	2PMГA1864W5E2	1	
19	127-74	1	
18	127-72	1	
17	252-cb11	1	
16	127-76	1	
15	160-196	2	
14	3402A-0,8-36ka	1	
13	Washer 30ST 111532-74.	5	
12	3157A-3-8-ka	4	
11	3481A-2C ₃ -8	2	
10	127-cb2	1	
9	160-208	3	
8	3436A-3	1	
7	3402A-0,1-6-14ka	1	
6	3402A-0,2-614ka	2	
5	3402A-0,5-6-14ka	1	
4	127-73	1	
3	127-cb4	1	
2	160-cb31	1	
1	127-34	1	
REF. NO.	Designation.	Description.	Qty Remarks.

130-59

BODY WITH COMPONENT

127-281

NO	SHEET	DOC. NO.	SIGN	DATE
DRAWN BY	BHUSHAN	25.5.80		
EDITED AND CHECKED BY	K. JAIN	26.5.80		
FOREMAN OF DC	A. K. B.	31/5		
DIVISIONAL OFFICER				

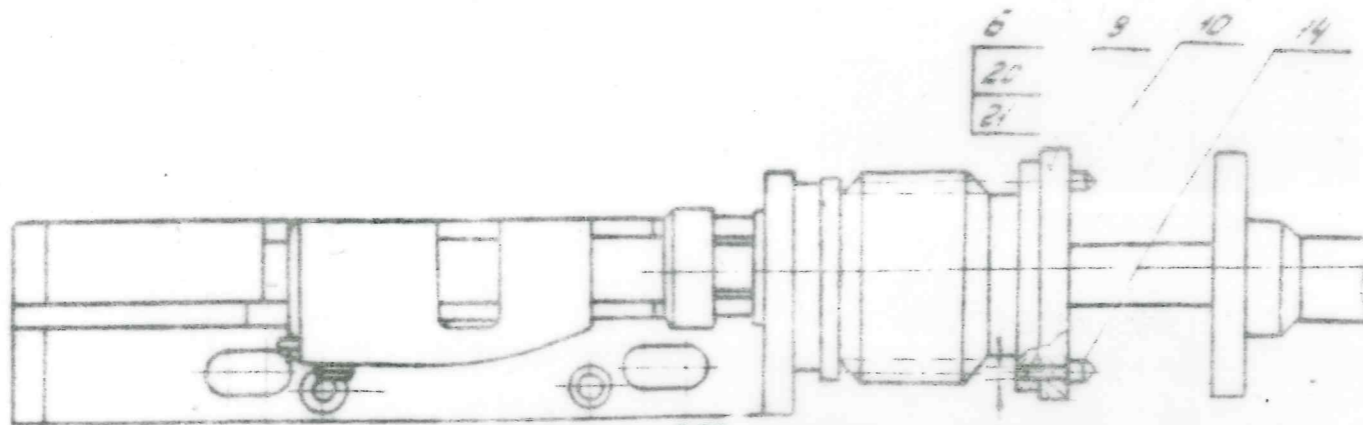
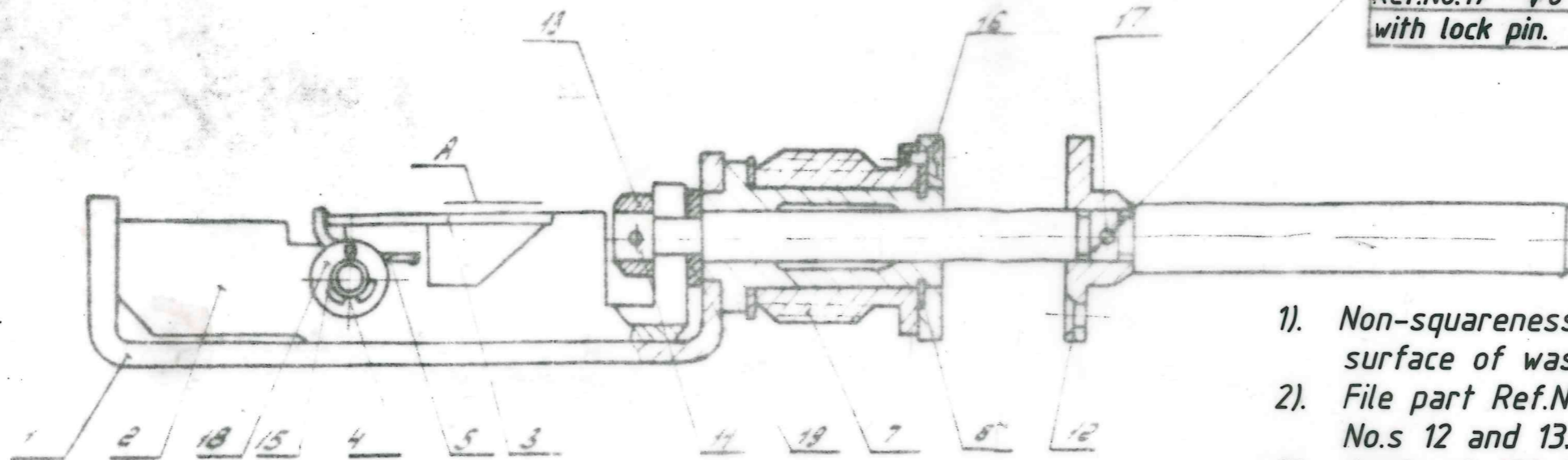
SHEETS TWENTY SCALE: 1:1

TOTAL SHEETS: 111

DRONANCE FACTORY PROJECT HYDRABAD

127-C82

Drill hole $\phi 0.95^{+0.06}$ ream for taper pin
 Ref.No.17 $\nabla 6$ and secure it
 with lock pin.



Drill 2Holes of $\phi 0.76^{+0.02}$ $\nabla 6$ along the hole
 in part Ref.No.9.

- 1). Non-squareness of pins, Ref.No.s 10 and 14 to the surface of washers Ref.No.9 should not exceed 0.1mm.
- 2). File part Ref.No.17 flush with surface of parts Ref. No.s 12 and 13.
- 3). Apply oil 132-20, Ty6-02-897-78.
- 4). Place parts Ref.No.20 and 21 as per requirement.
- 5). File plane A of latch Ref.No.3 to $\nabla 6$ flush with sliding block Ref.No.2.
- 6). Axial play of worm Ref.No.7 on bush 252-23 should be 0.02 to 0.05 mm.
- 7). Clearance between slide block Ref.No.3 and bush Ref. No.13 should not exceed 0.1mm.
- 8). Cut the ends of spring Ref.No.5 projecting from slide block.

REF. NO.	DESIGNATION	DESCRIPTION	QTY	REMARKS.
21	252B-141	Washer	2	
20	252B-140	Washer	1	
19	252-34	Special washer	1	
18	3402A-0,8-3-6-10	Washer	1	
17	3494A-1-8	Tapper pin	2	
16	3177A-14-3 ka	Screw.	3	
15		Cotter pin	1	GOST 397-79
14	252-299	Lock pin	1	
13	252-36	Thrust bush	1	
12	252-32	Disc	1	
11	252-31	Shaft	1	
10	252-30	Lock pin	1	
9	252-28	Special washer.	1	
8	252-27	Block.	2	

REF. NO.	DESIGNATION	DESCRIPTION	QTY	REMARKS.
7	252-26	Worm	1	
6	252-25	Washer	1	
5	127-15	Spring	1	
4	127-13	Pin	1	
3	127-7	Latch	1	
2	127-4	Slide block	1	
1	127-c83	Bracket with bush	1	

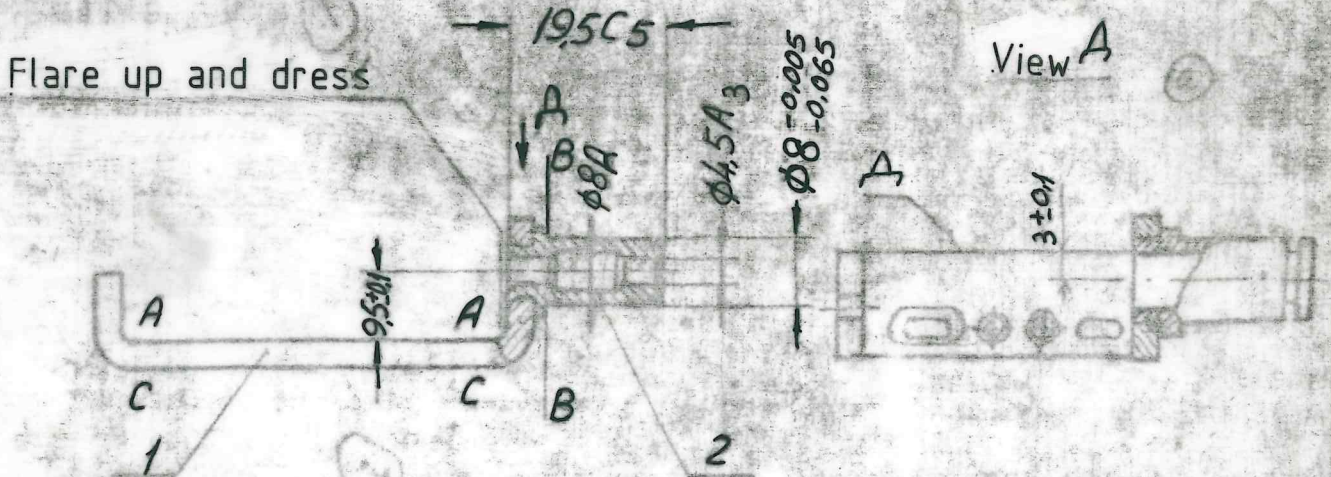
SNOSH/DOC NO	SIGN	DATE
DRAWN BHUSHAN		24.5.84
EDT,CHKD J.K. JAIN		26.5.84
F/M,DC. S/RAO		31/5
DIV.OFFR		21/5
NAME	SIGN	DATE

**BRACKET WITH
 SLIDE BLOCK.**

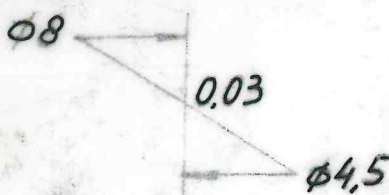
SHEET	WEIGHT	SCALE
A	55,552	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD 60		

127-C82

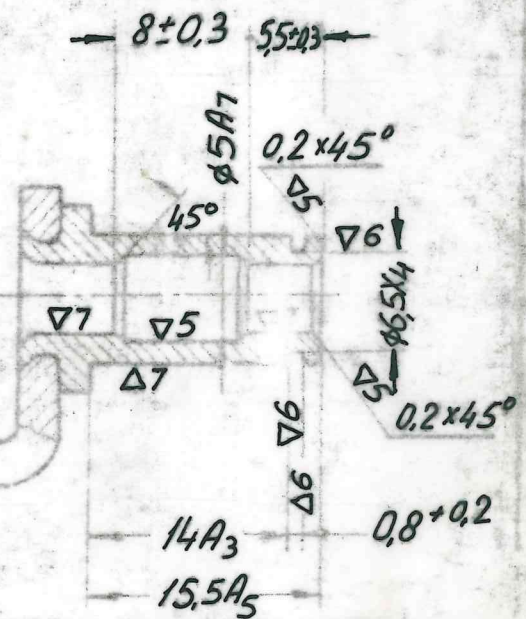
127-C83



Eccentricity



M2:1



1. Axis of hole $\phi 4,5$ A should be parallel to plane c-c, deviation over a length of 40mm should not exceed 0,05mm. (with respect to B.B- ± 20 mm) for the rest of the length should not exceed 0,1mm.
2. Run out of plane BB with respect to $\phi 8$ should not exceed 0,1mm.
3. Non parallelity of planes AA and CC should not exceed 0,05mm.
4. Non parallelity of axis of hole $\phi 4,5$ A and plane A should not exceed 0,15mm.

127-C83

2	252-23	Bush	1	
1	127-11	Bracket	1	
Ref No	Designation	Description	Qty	Remarks

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		V.J.RAO		14.5.84
EDT, CHKD		B.B. Sankar		17.5.84
F/M, DC		S.H.RAO		31/5
DIV. OFFR.		D.A. B. Rao		31/5
		NAME	SIGN	DATE

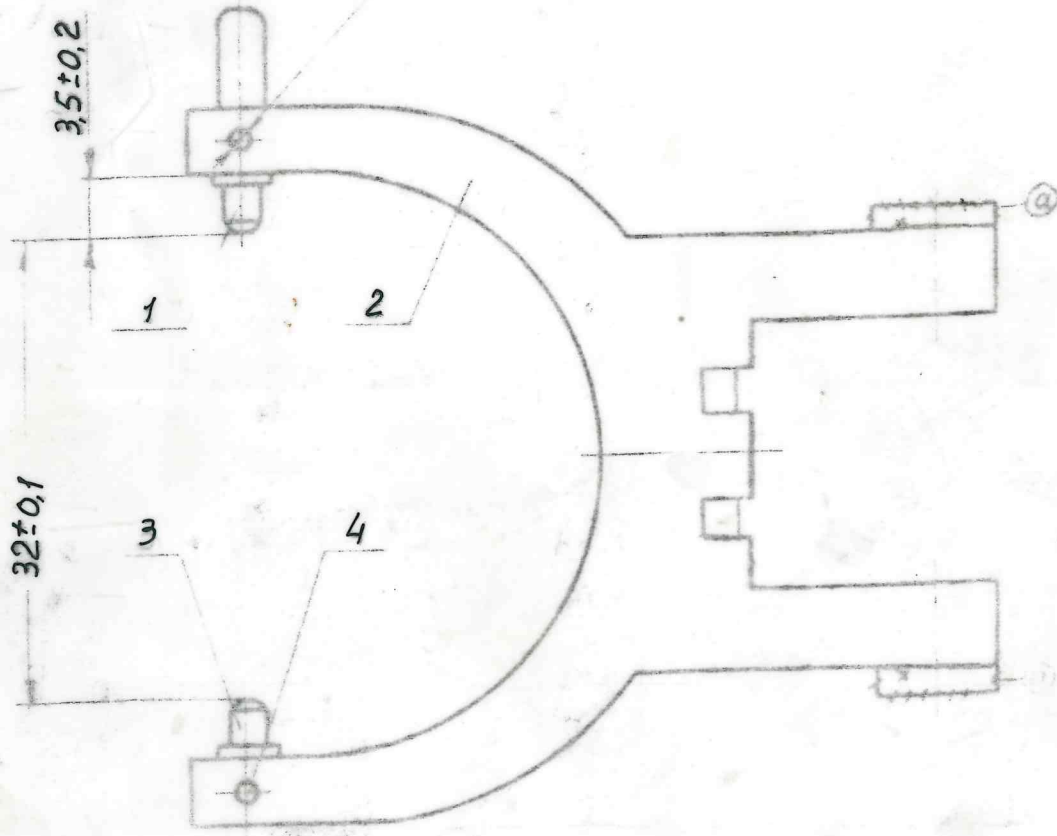
BRACKET WITH BUSH

127-C83.

SHEET	WEIGHT	SCALE
A		1:1
TOTAL SHEETS 1		
ORDANANCE FACTORY PROJECT HYDERABAD		

127-C64

Drill and ream two holes of $\phi 0,95^{+0,06}$ $\nabla 6$ for taper pin ref.4 and secure it with lock pin.



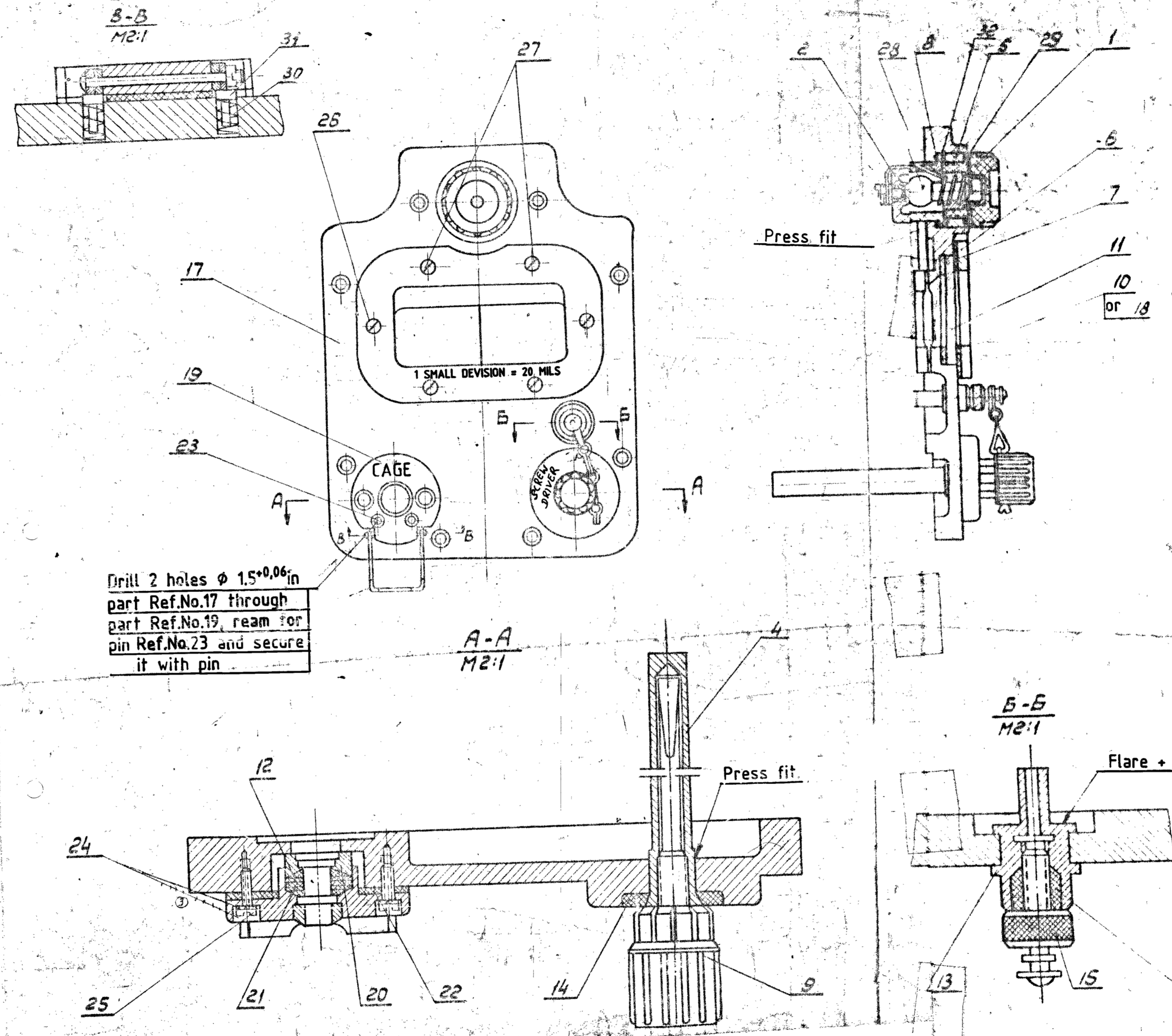
4		Taper pin	2	
3	160-128	Carrier II	1	
2	127-12	Cage fork	1	
1	9 8.314.004	Carrier	1	
Ref No	Designation	Description	Qty	Rema

SLNO	SHEET	DOCNO	SIGN	DATE
DRAWN BY		V.J.RAO		14.5.84
EDITED AND CHECKED BY		B.A. Sarin		17.5.84
FOREMAN OF DC		S.H.RAO		31/5
DIVISIONAL OFFICER				21/5

CAGE FORK WITH CARRIERS

127-C64		
SHEETS	WEIGHT	SCALE
A		2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

127-C85



Drill 2 holes $\phi 1.5^{+0.06}$ in part Ref.No.17 through part Ref.No.19, ream for pin Ref.No.23 and secure it with pin

1. Screws Ref.No.26 and 27 are secured with primer $\phi 1-086$.
2. Place bush Ref.No.13 on adhesive $\phi 4-4$ and flare after adjusting the meshing of screw driver with balancing screws in 127 C5. Flared place is coated with primer $\phi 1-086$. GOST 16302-79.

3. Glass Ref.No.11 should be tightly pressed with the cover Ref.No.6.
4. 1 to 3 parts Ref.No.21 may be installed.
5. Whenever necessary place glass Ref.No.11 on compounded Y-20A; TY 38-105.357-76.
6. Coat face of socket Ref.No.4 with ^{enamel} ЭП-140 black, TY 6-10-599-79 on the side of the front wall.
7. Lubricate gasket ref.No.22 on both sides with lubricant Б) GOST 7171-78.
8. Install packings Ref.Nos.12 and 21 on lubricant ЦИАТИМ-201, GOST 6267-74.
9. Install gaskets Ref.Nos 29, 8 and 14 on adhesive 88НП.

32	948.683.037	✓	Gasket	1	
31	948.352.002	✓	Pusher	2	
30	948.383.015	✓	Spring	2	
29	948.683.031	✓	Gasket	1	
28	MH-26-012-1		Bulb GOST 2204-80.	1	
27	3177A-2-6-kd		Screw	2	
26	3177A-2-8-kd		Screw	4	
25	3157A-3-7-kd		Screw	2	
24			Washer 3 OCT 1.11532-74.	2	
23	3481A-16C3-10		Pin	2	
22	948.683.029	✓	Gasket	1	
21	252-98	✓	Packing	3	
20	252-97	✓	Crimp	1	
19	946.115.002	✓	Body of packing gland	1	
18	127-31	✓	Gasket	1	
17	946.424.000	✓	Front wall	1	
16	127-24	✓	Pipe	1	
15	946.433.001	✓	Plug with chains	1	
14	127-22	✓	Gasket	1	
13	127-20	✓	Bush	1	
12	127-17	✓	Packing	1	
11	127-6	✓	Glass	1	
10	127-5	✓	Gasket	1	
9	127-C86	✓	Screw driver	1	
8	948.683.008	✓	Gasket	1	
7	948.683.007	✓	Gasket	1	
6	948.604.001	✓	Cover plate	1	
5	948.229.001	✓	Threaded bush	1	
4	947.326.000	✓	Socket	1	
3					
2	946.430.019	✓	Cap	1	
1	946.615.003	✓	Holder	1	
Sl.No.	Designation	Description	qty	Remarks	

SLNO	SHEET	DOCNO	SIGN	DATE
DRAWN BY		P.R.BABU		19.5.84
EDITED AND CHECKED BY		P.K.JAIN		21.5.84
FOREMAN OF DC		S.H.RAO		21/5
DIVISIONAL OFFICER		D.S. RAJESH		21/5
NAME		SIGN	DATE	

FRONT WALL WITH COMPONENTS.

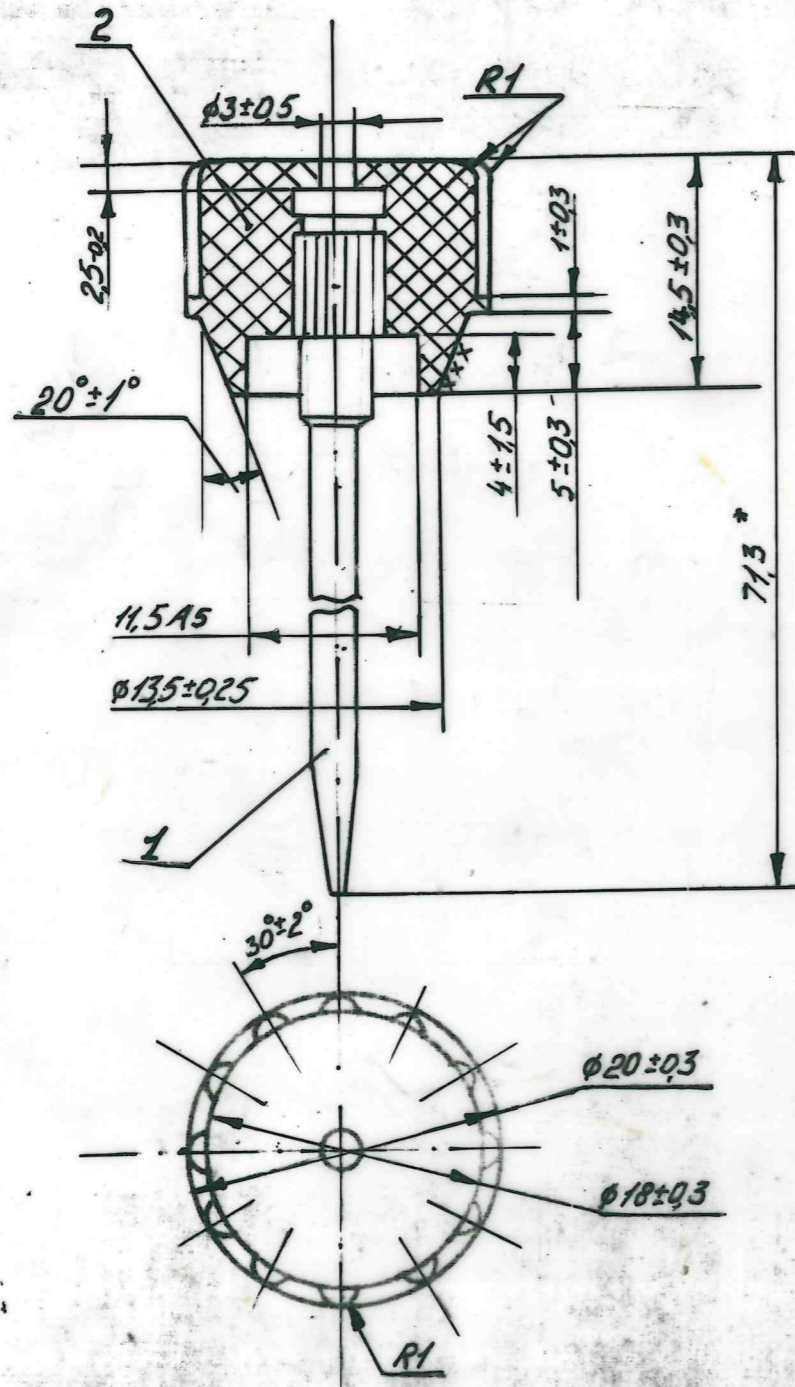
127-C85

SHEETS	WEIGHT	SCALE
7	264.5	1/1
TOTAL SHEETS		
ORINANCE FACTORY PROJECT HYDERABAD		

130-63

127-c86

127Cn



D-130

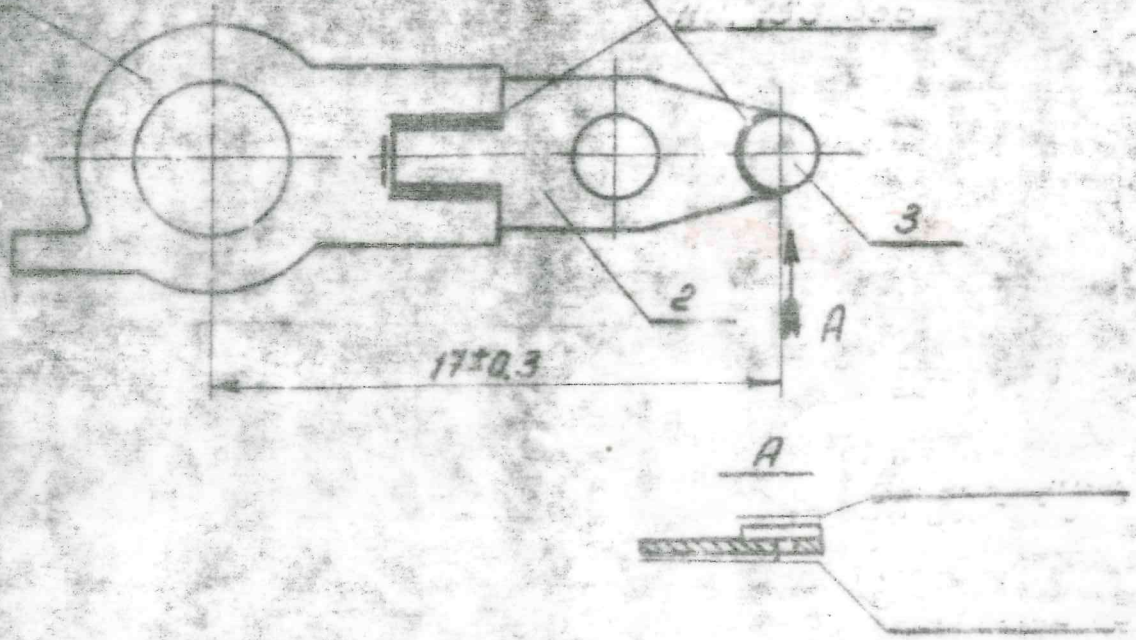
USED ON
127-c8 (ARTFMK-59
(675-82-c84)

- 1 Technical requirements are as per ost.180063-73
- 2 Ten notches are provided uniformly along the periphery on the surface marked with xxx with a width of 0.3 to 0.6, depth of 0.4 ± 0.1 and length of 3.5mm.
- 3 Dimensions is for reference
- 4 It is allowed to manufacture from 03-010-02 Gost 5689-79.
- 5 Pattern draft is 1° beyond tolerance
- 6 Coat ten notches with THNΦ-851 white, TY29-02 889-79
- 7 Surface finish of moulding material is $\nabla 7$

2		PHENOPLAST.01-030-02	4.32	GOST 5689-79
1	9A8. 126. 004	ROD	1	
SNO.	DESIGNATION	NOMENCLATURE	QTY	REMARKS
APPROVED		127-c86		
CHECKED				
CONTROLLERATE OF INSPECTION. (ICV)		SCREWDRIVER		WEIGHT
				9.1g
				SCALE
		SHEET		TL SHTS.
				1

127-657

Solder with noc-61, GOST 21931-76
with zinc chloride flux as per inst-
ructions, D, A-0443-003. and rinse
as per instructions NO. 153, 356.



S.No	DESIGNATION	DESCRIPTION	Qty.	REMARKS
3	160 - 30	Contact I.	1	
2	127 - 48	Contact spring	1	
1	127 - 49	Contact	1	

127-667

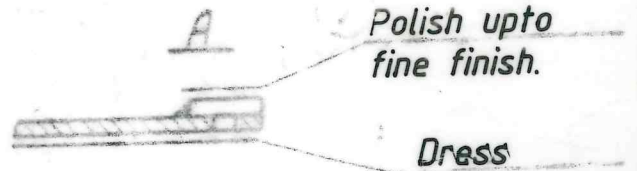
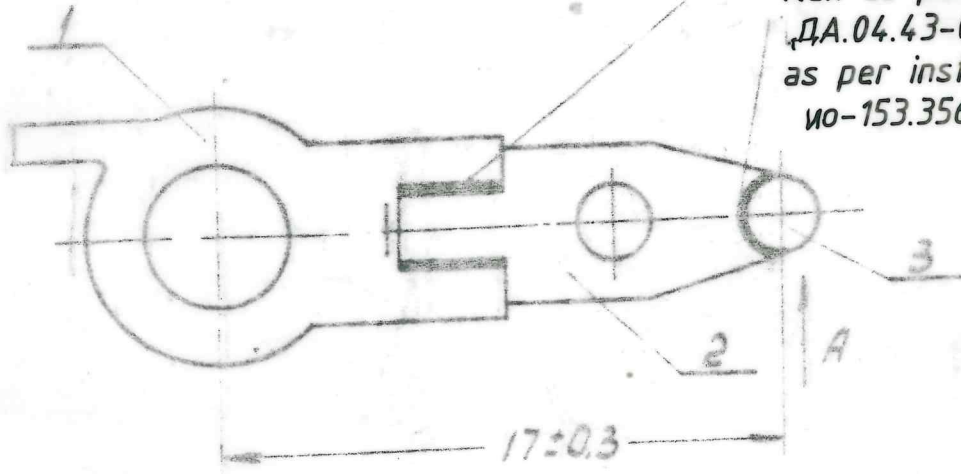
SNOSHT	DOC NO	SIGN	DATE
DRAWN	Y.R.Ganesh		18.5.84
EDT,CHKD	D.K.JAIN		19.5.84
F/M,DC	S.H.RAO		31.5
DIV.OFFR	D.A.		21.1

CONTACT

SHEET	WEIGHT	SCALE
0213	5.7	
TOTAL SHEETS		
ORDNANCE FACTORY		

127-C68

Solder with noc-61, GOST 21931-76, with zinc chloride flux as per instructions DA.04.43-003 and wash as per instructions no-153.356.



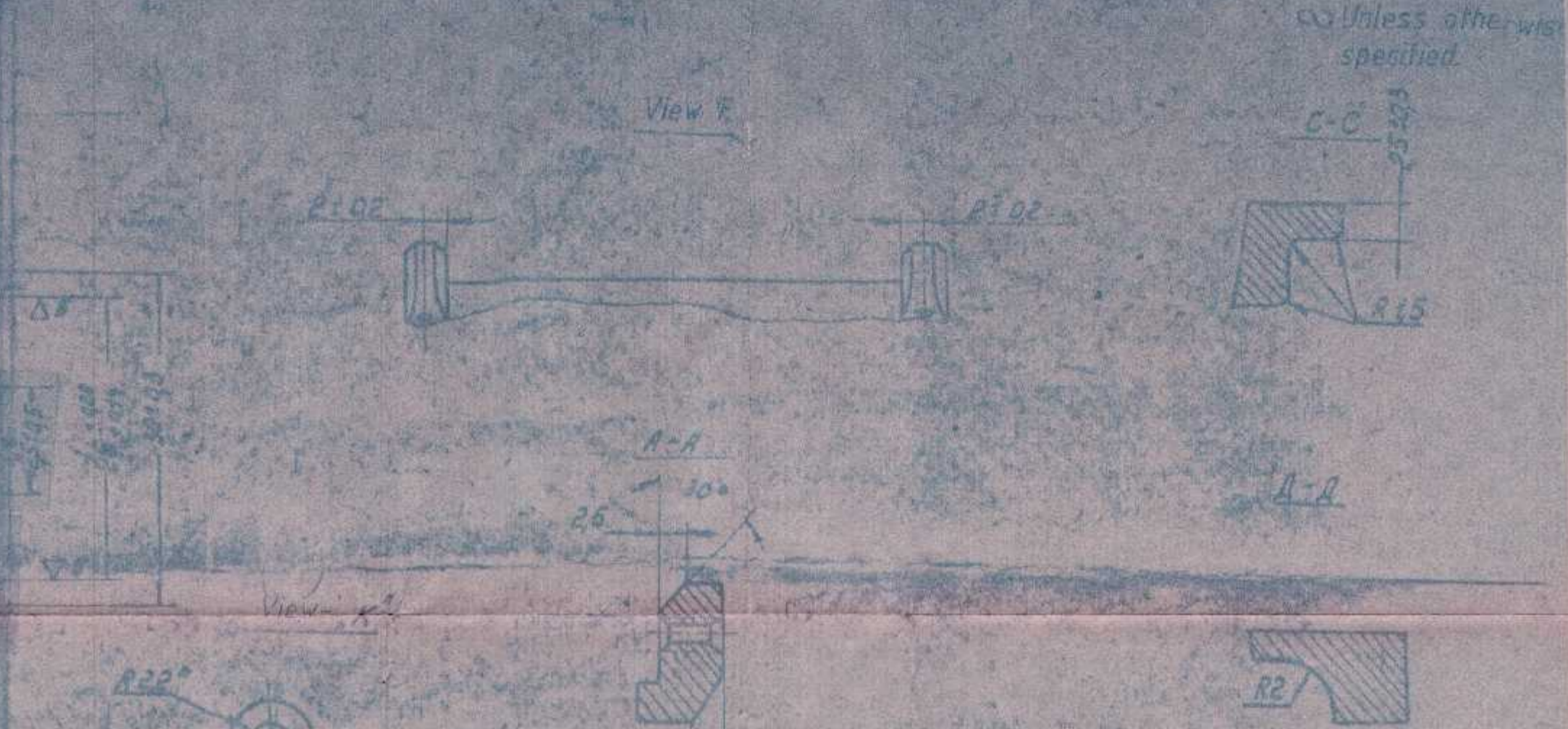
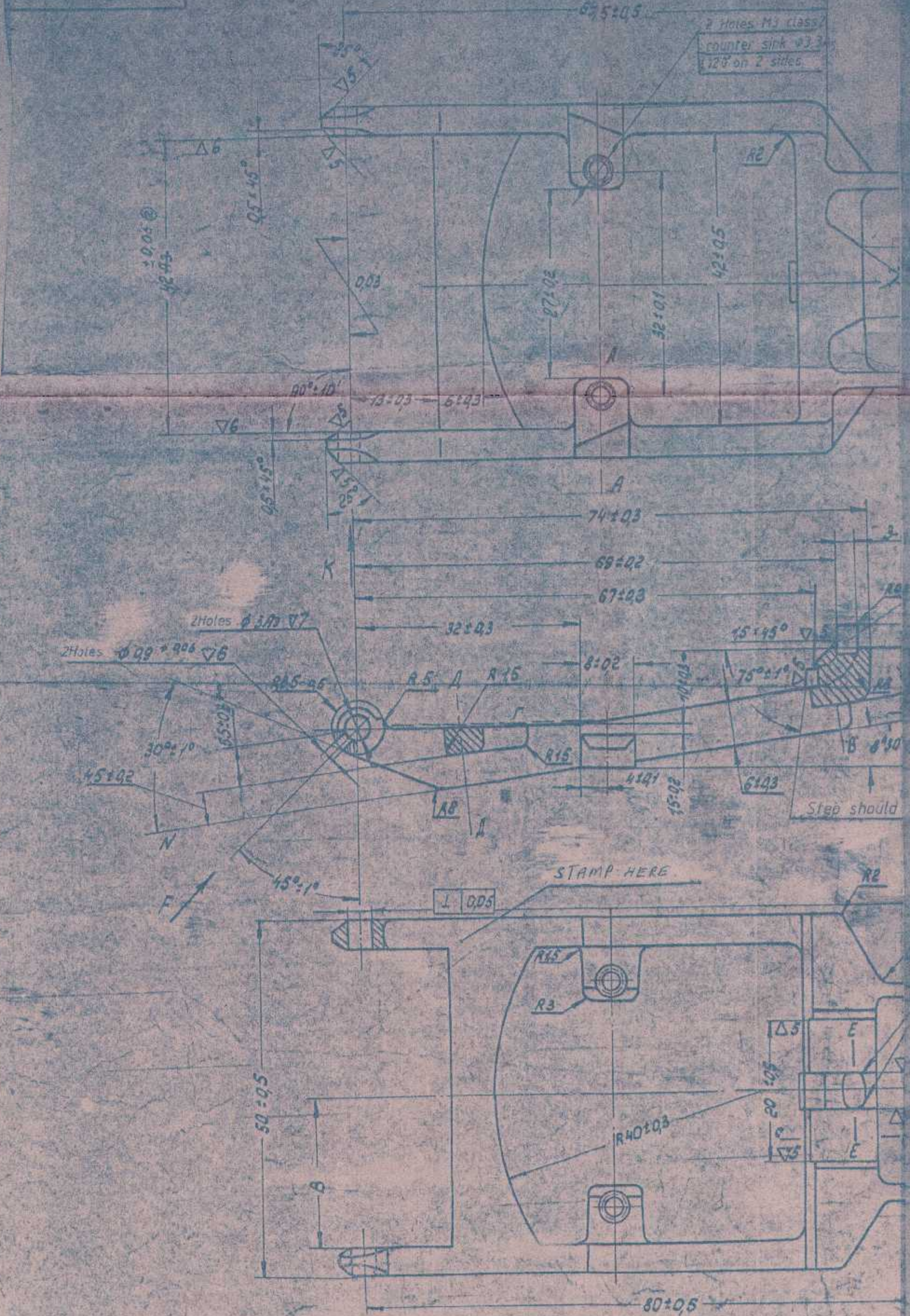
REF. NO.	Designation	Description	Qty	Remarks.
3	160-30	Contact I	1	
2	127-48	Spring contact	1	
1	127-51	Contact	1	

S/NO	SHEET	DOCNO	SIGN	DATE
			BHUSHAN	19.5.84
			D.K. JAIN	24.5.84
			S.H.RAO	31/5
			D.A. SINGH	31/5

CONTACT.

SHEETS	WEIGHT	SCALE
1	120g	5:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT		
HYDERABAD		

127-C828



- 1) Pressure die casting
- 2) Perform unspecified radii with R 1
- 3) Ageing is performed after casting at $t=290^{\circ}\pm 10^{\circ}$ for 4 hrs and $t=-50^{\circ}$ to -60° for 2 hrs
- 4) Coating: chemical oxidation
- 5) Polish external surface of tooth
- 6) Angle between chamfers $25\times 45^{\circ}$ and $1\times 45^{\circ}$ and plane NN- 90°
- 7) Axial displacement of a with respect to 'B' should not exceed 0.05 and 'C' with respect to 'B' should not exceed 0.1
- 8) Tolerances on free dimensions are as per OST 180020-71
- 10) Technical Requirements are as per 180020-71 (2nd group)
- 9) Displacement of hole $\phi 3A_3$ with respect to Γ should be in the limits of ± 0.2
- 11) *Roll chamfers at an angle 25° over hole $\phi 3A_3$ till mating with surface M and P.

88. УИВ. № УИВ. № 127-С828. Подпись. Дата. № 127-С828.

1	160-258	ALUMINIUM ALLOY AN-2	WGST 2685-75
DESIGNATION	CAGE FRAME TOOTH	Qty	Remarks

NO. SHEET	DOC NO	SIGN	DATE
DRAWN	BHUSHAN		23.5.84
EDT/CHKD	D. K. JAIN		25.5.84
E/M, DC	SHRAO		3/1
DIV/OFFR	D. A. JAIN		4/1
NAME	SIGN	DATE	

FRAME WITH TOOTH.		SHEET WEIGHT	SCALE
A	1782	2:1	
TOTAL SHEETS		ORDNANCE FACTORY PROJECT HYDERABAD	