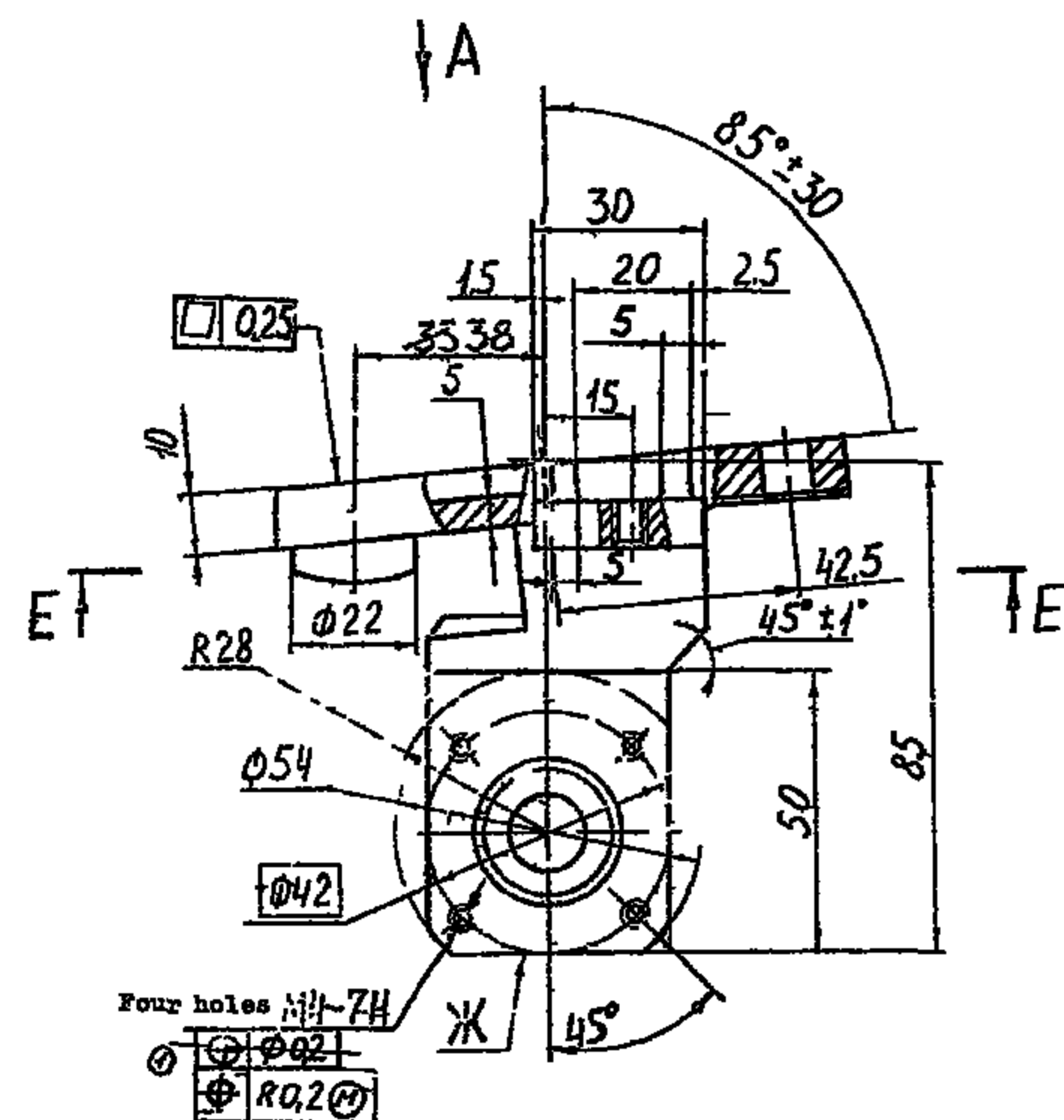
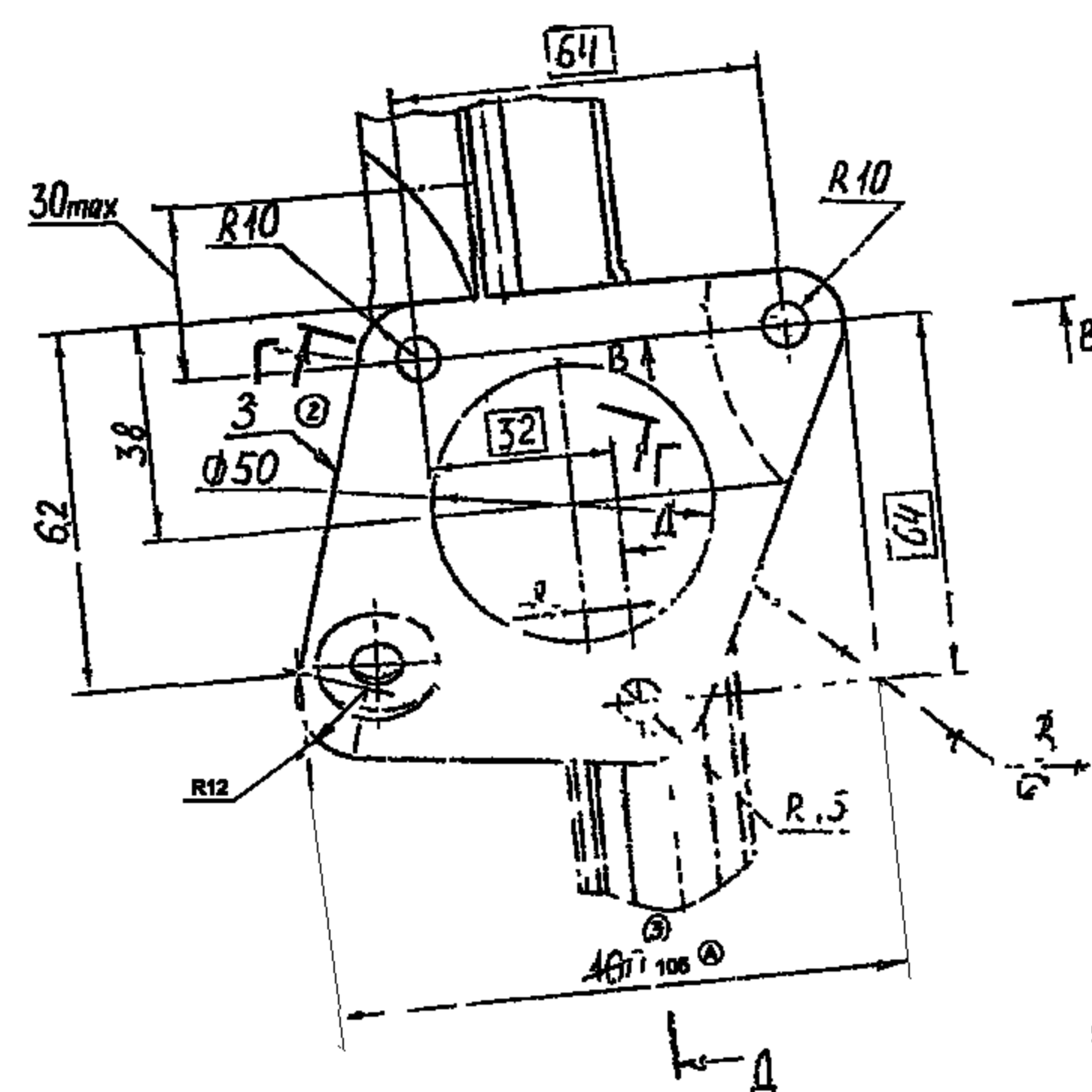
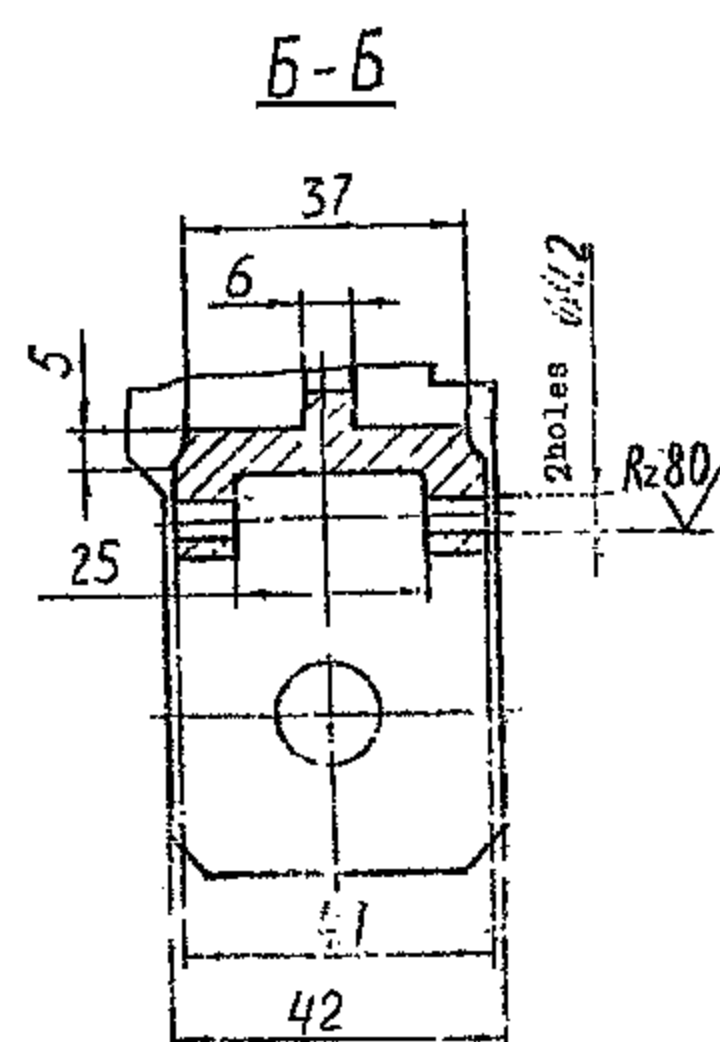




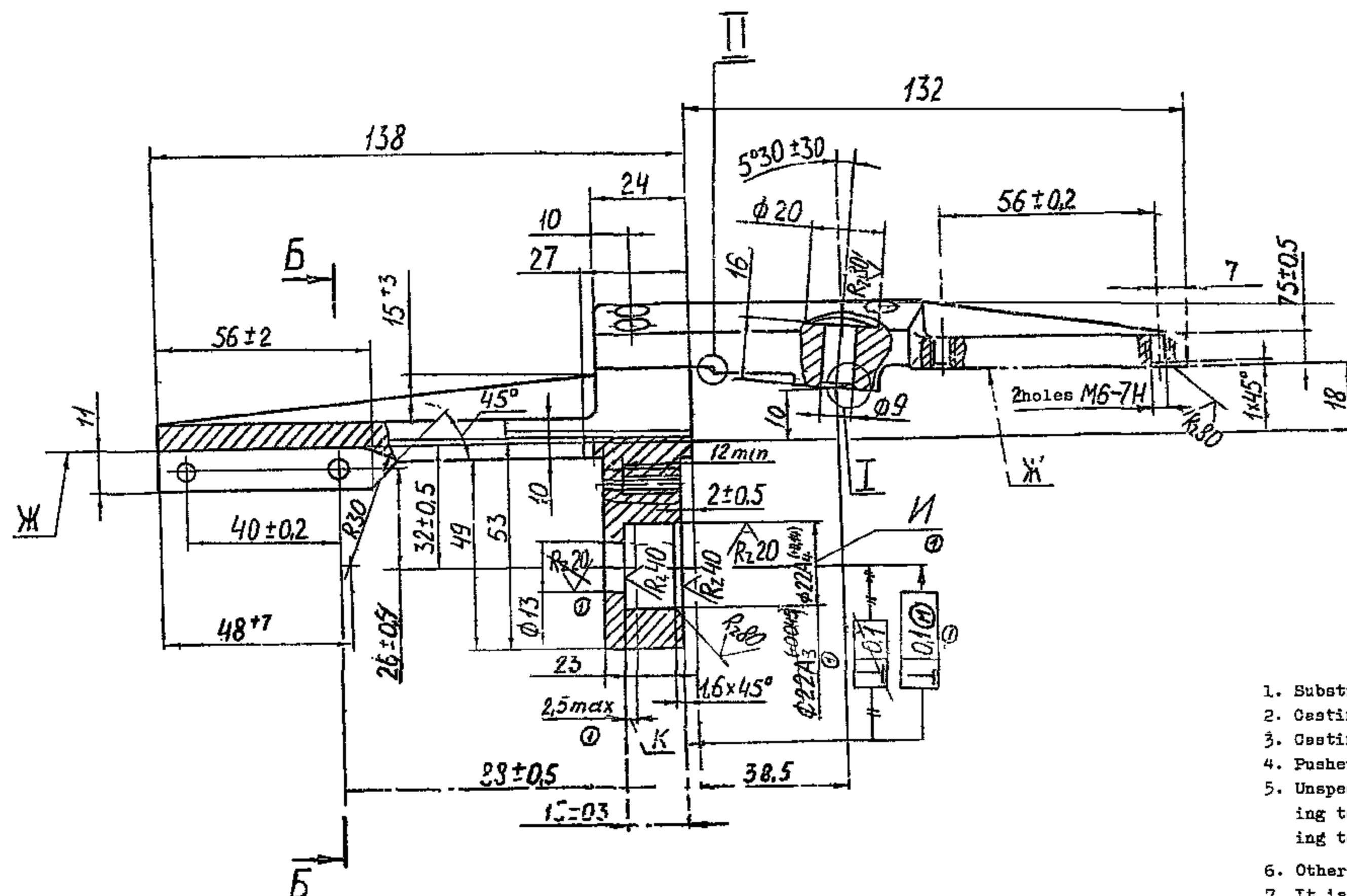
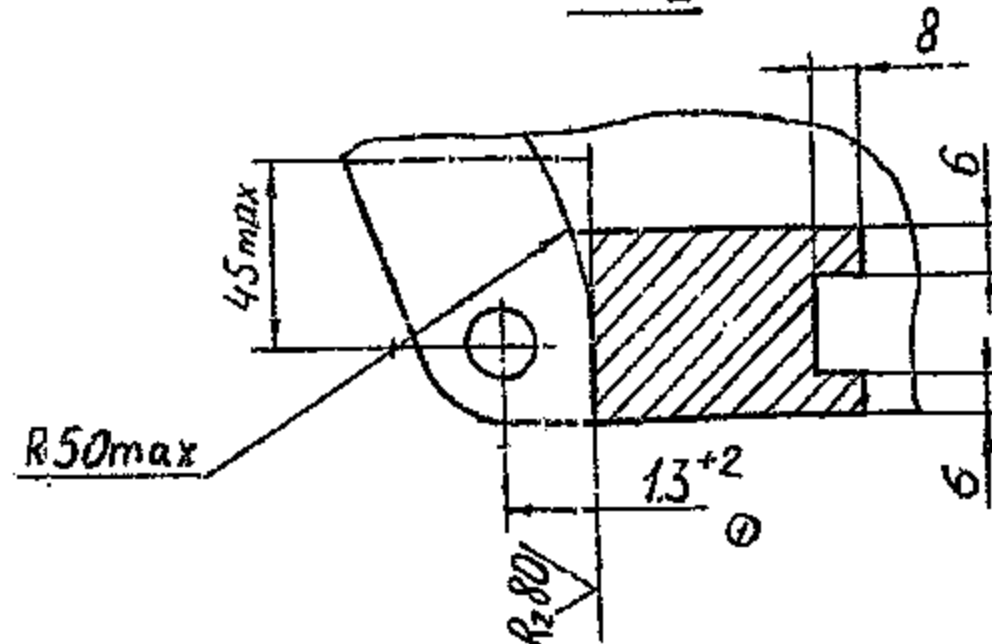
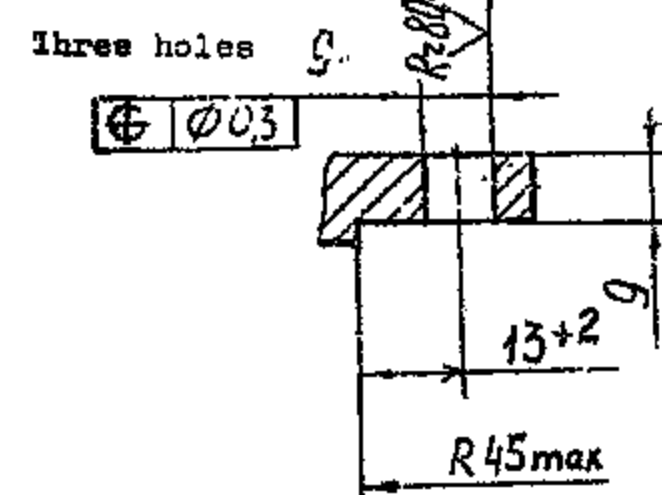
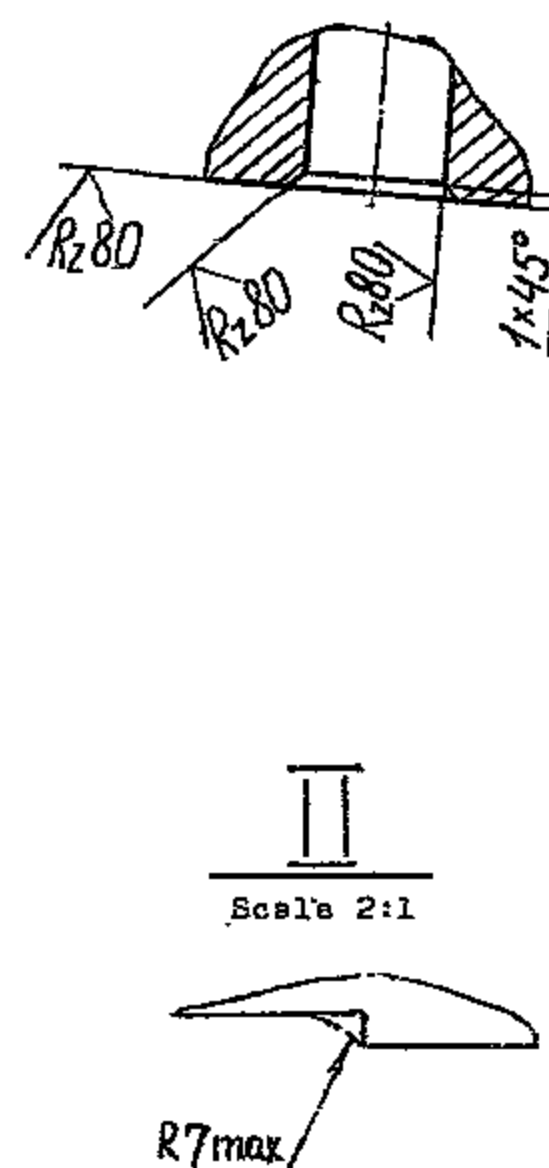
View A



View B



B-B

I-I
revolvedI
Scale 2:1II
Scale 2:1

- TECHNICAL CONDITIONS**
1. Substitute for material AN4 ГОСТ 2635-75.
 2. Casting drafts - 2°, maximum.
 3. Casting radii - 5 mm. maximum.
 4. Pusher traces up to 0.5 mm deep on surface 1 are tolerable.
 5. Unspecified limit deviations of sizes: for holes - according to A₇; for shafts - according to B₇; others - according to CN₈; castings - +1/-0.5 mm.
 6. Other requirements to casting - according to TTAL-436.
 7. It is allowed to manufacture according to thickened dash-dot line.
 8. Gate remainder not in excess of 2 mm high on surface 3 is tolerable.
 9. Reduction of size H along length K to Ø 21.5 mm is tolerable.

00571-ICV	IN VIEW 'A' DIMENSION
1-8-93	105 WAS 100,
ISSUE	(10-2028)
DATE	NATURE
AMENDMENTS	

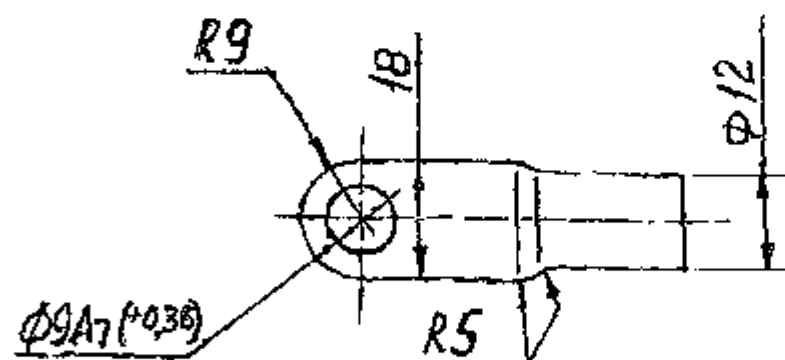
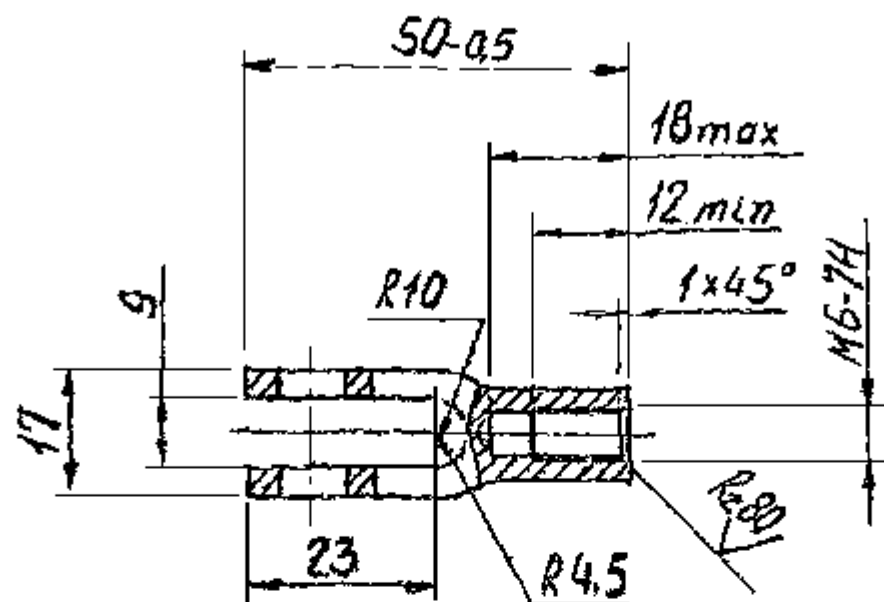
APPROVED	675-10-38
CHECKED	
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	BODY
	WEIGHT 0.35
	SCALE 1:1
	SHT SHTS. 1
	AN 9 GOST 2685-75

68-10-39

TECHNICAL CONDITIONS

Rz80
✓ (✓)

1. Substitute for material - steels 40Л, 45Л, 30Л ГОСТ 977-75.
 2. Unspecified casting radii - 2 mm, maximum.
 3. Casting drafts - 1°, maximum.
 4. Other requirements to casting - according to OCT 3-4365-79
 5. Coating: On. phosphatized, accelerated Cr impregnated with preservation oil ГОСТ 10877-76 in compliance with Instructions 53252890002 or with varnish 30-815 ГОСТ 11066-74.
- Ⓐ EQ.MATERIAL: GRADE 1C TO IS:10343-B9 "NORMALISED CONDITION."



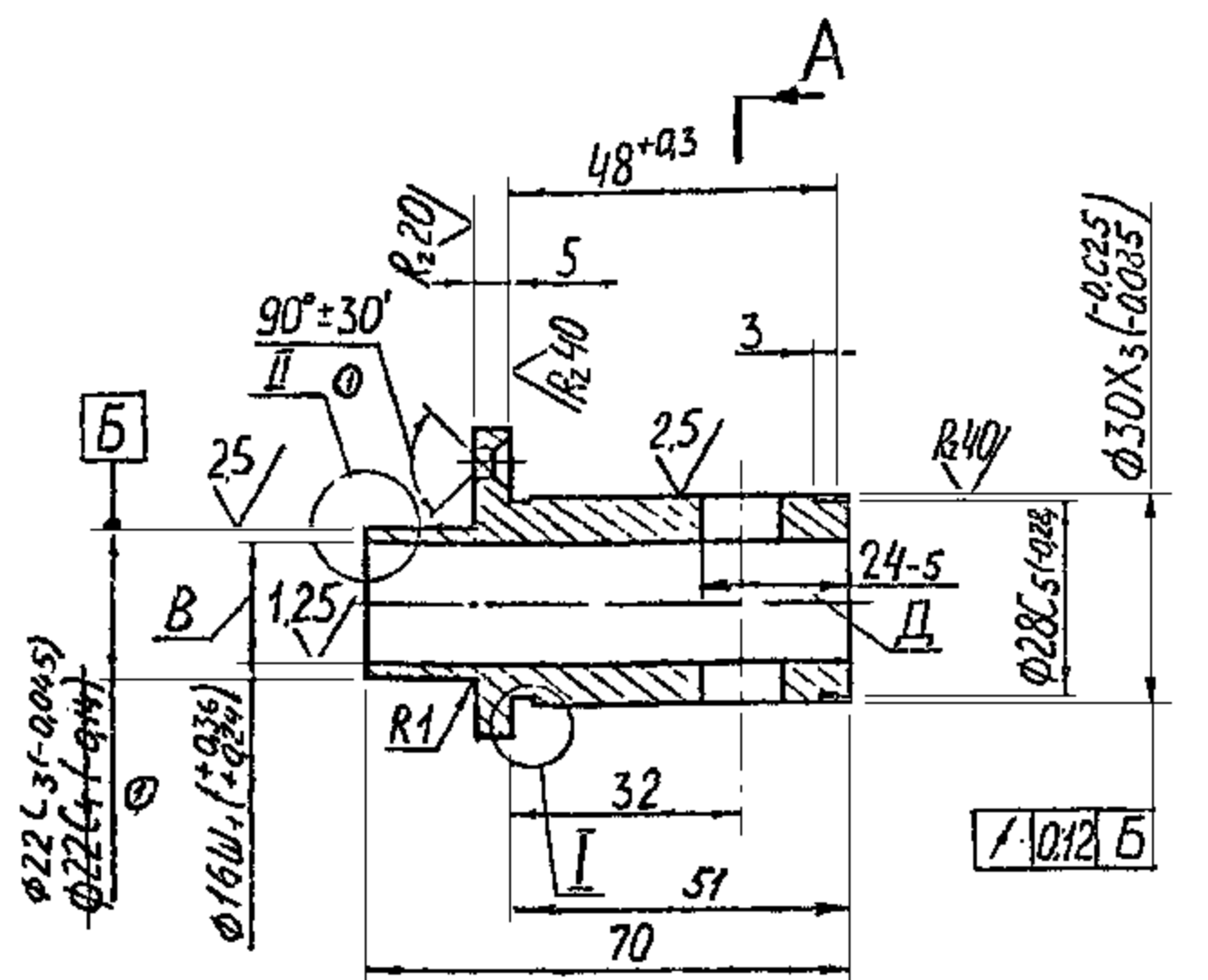
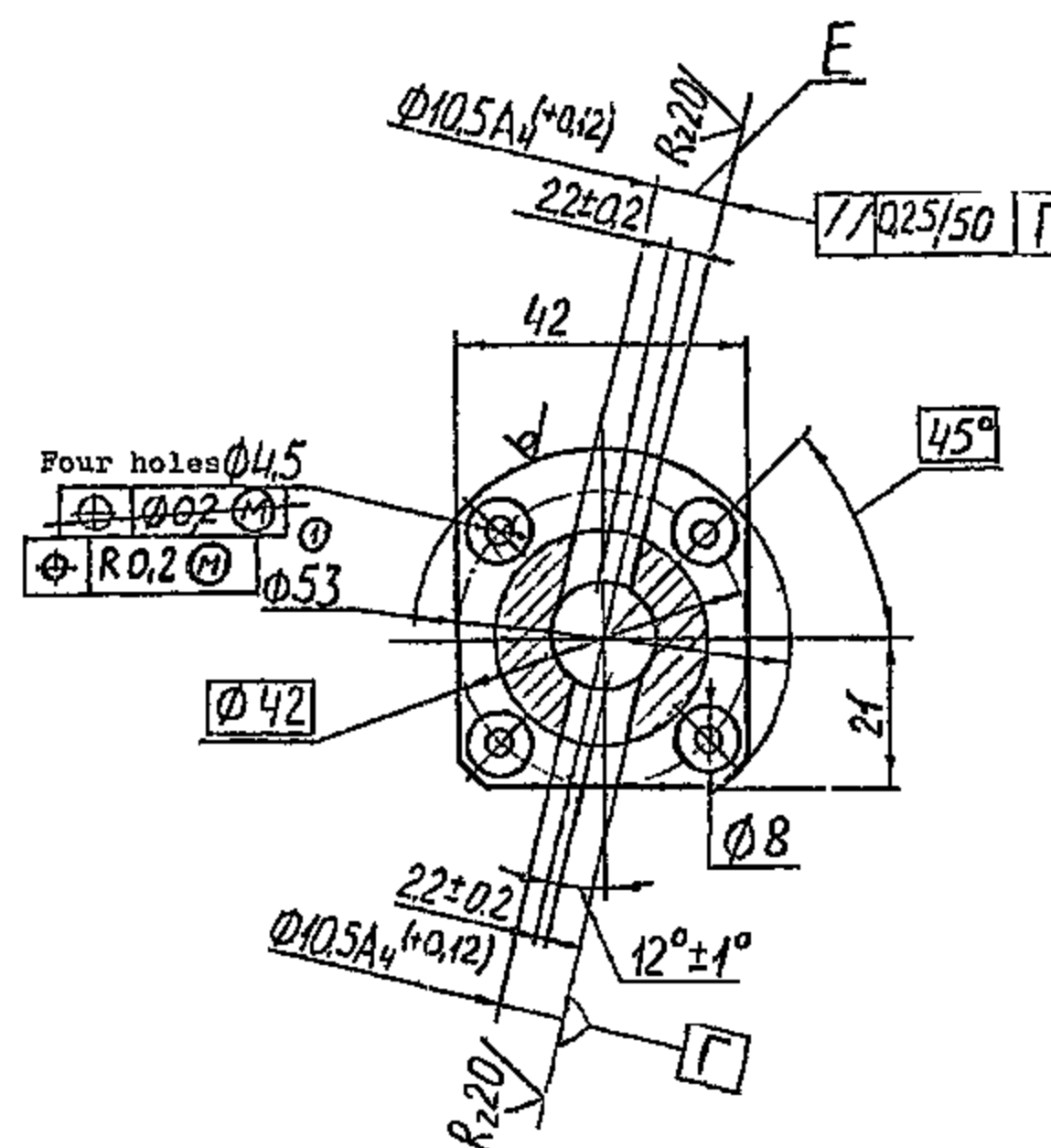
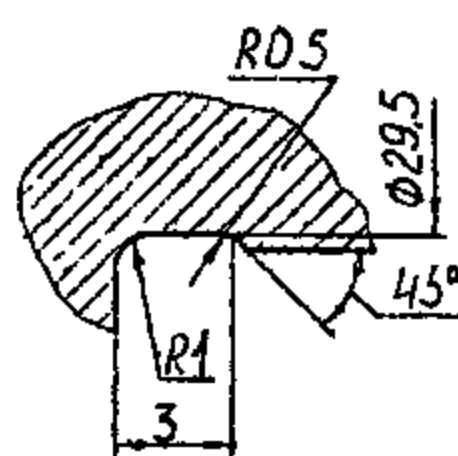
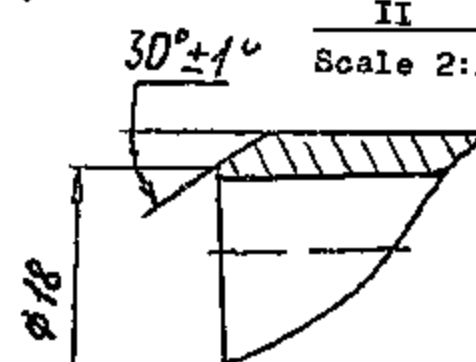
00852 -ICV	Ⓐ	EQ.MATERIAL ADDED.
Null 3/01/2001	Cur	
DC(1) No. & DATE	ISSUE	AMENDMENTS

APPROVED	675-10-39			
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	PLUG		WEIGHT	SCALE
			0.04	1:1
	CASTING		SHT	SHTS
		OCT 3-4365-79 35 Л ГОСТ 977-75		

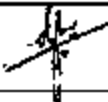
TECHNICAL CONDITIONS

1. HRC 37 to 48. Check hardness on end face by grinding deep to 0.2 mm, maximum.
 2. Substitute for material - steel 40XC ГОСТ 4543-71.
 3. Unspecified limit deviations of sizes: for holes - according to A₇; for shafts - according to B₇, others - according to CM₈.
 4. On section II slackening of size B by 0.1 mm above tolerance and roughness R_z $\frac{20}{\sqrt{}}$ are tolerable.
 5. Holes Γ and E should be in one and same plane; displacement of 0.1 mm, maximum, is tolerable.
 6. It is allowed to check location of holes Γ and E and Item 5 on position gauge with centering diameter of 30 mm for free passage of gauges Ø 10.2 mm.
- Ⓐ EQ. MATERIAL: 42 Cr4 M02 TO IS: 5517-93, 'U' or 'V' CONDITION WITH ISOTHERMAL HEAT TREATMENT.
2. CASE HARDENED TO 37 TO 41 HRC

A-A

I
Scale 5:1II
Scale 2:1

00852-ICV	Ⓐ	EQ. MATERIAL ADDED.
31-01-2001	ISSUE	AMENDMENTS

APPROVED		675-10-40				
CHECKED		BUSHING			WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				0.305	1:1	
	SHT SHTS					
ROUND BAR		B 53, GOST 2590-71				
		38xC, GOST 4543-71				

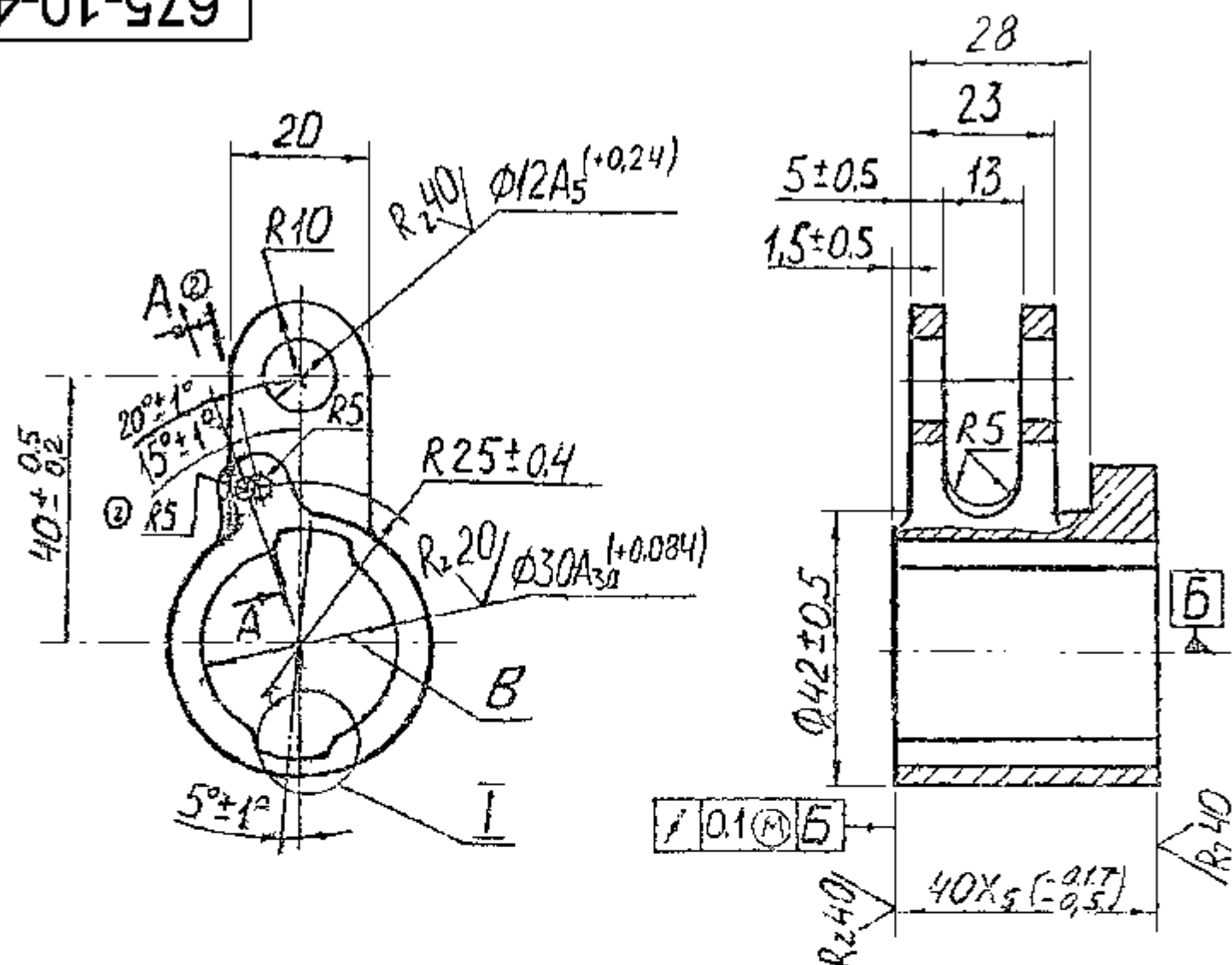
675-10-41

R_z80/ (✓)

TECHNICAL CONDITIONS

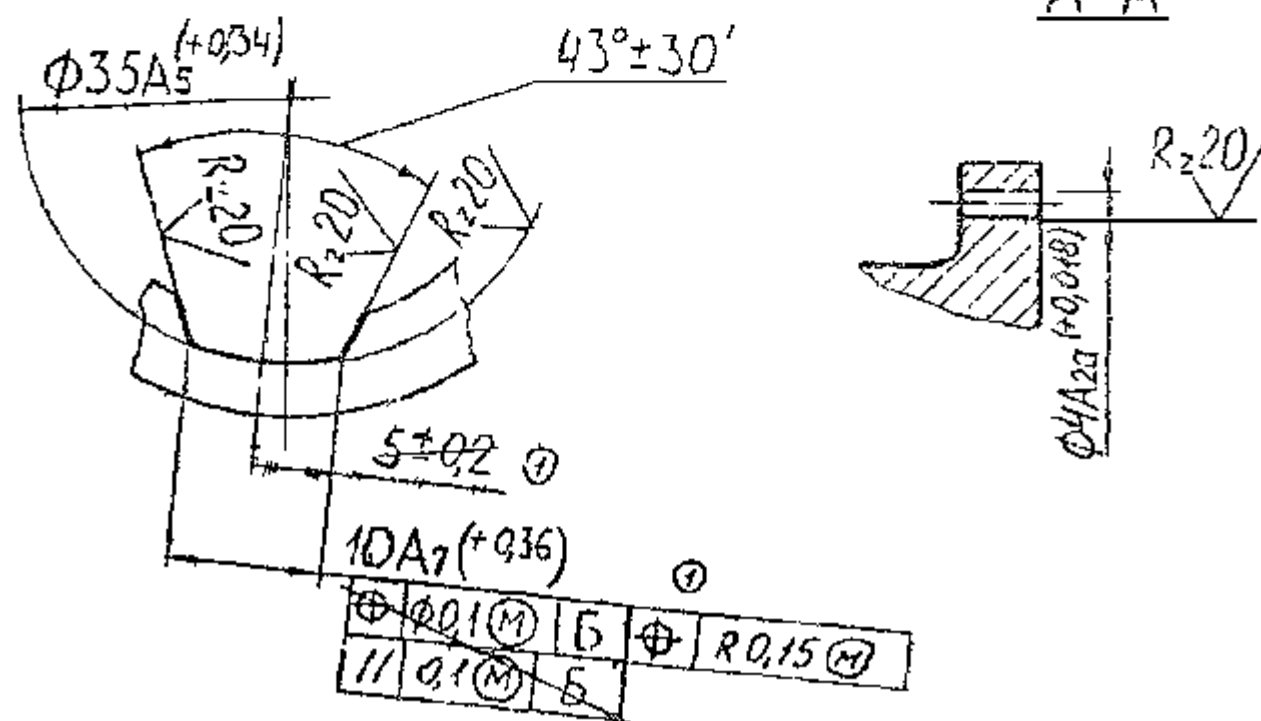
1. HB 444 to 321 (ϕ 2.9 to 3.4) or HRC 45 to 32.
2. Unspecified casting radii - 3 mm, maximum.
3. Casting drafts - 2° , maximum.
4. Other requirements to casting - according to OCT 3-4365-79.
5. Coating: zinc ^{plated, 9 micron thick} Cr. Remove hydrogen embrittlement.
6. It is allowed to check sizes before thermal treatment, except for size B.

Ⓐ EQ. MATERIAL: GRADE 4E/4D TO IS: 10343-88.



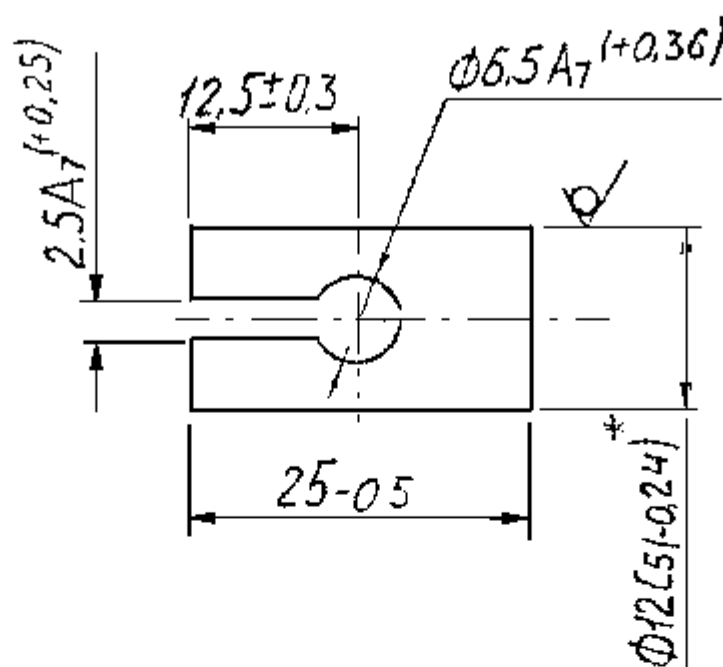
I
Scale 2:1

A-A



00852-ICV	Ⓐ	EQ. MATERIAL ADDED.
31-01-2001		
DC(I) No. & DATE	ISSUE	AMENDMENTS

APPROVED		675-10-41		
CHECKED	GPR			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		LEVER		
		WEIGHT	SCALE	
		0.2	1:1	
		SHT	SHTS	
		CASTING I- OCT-3-4365-79 35x rcl GOST 977-75		

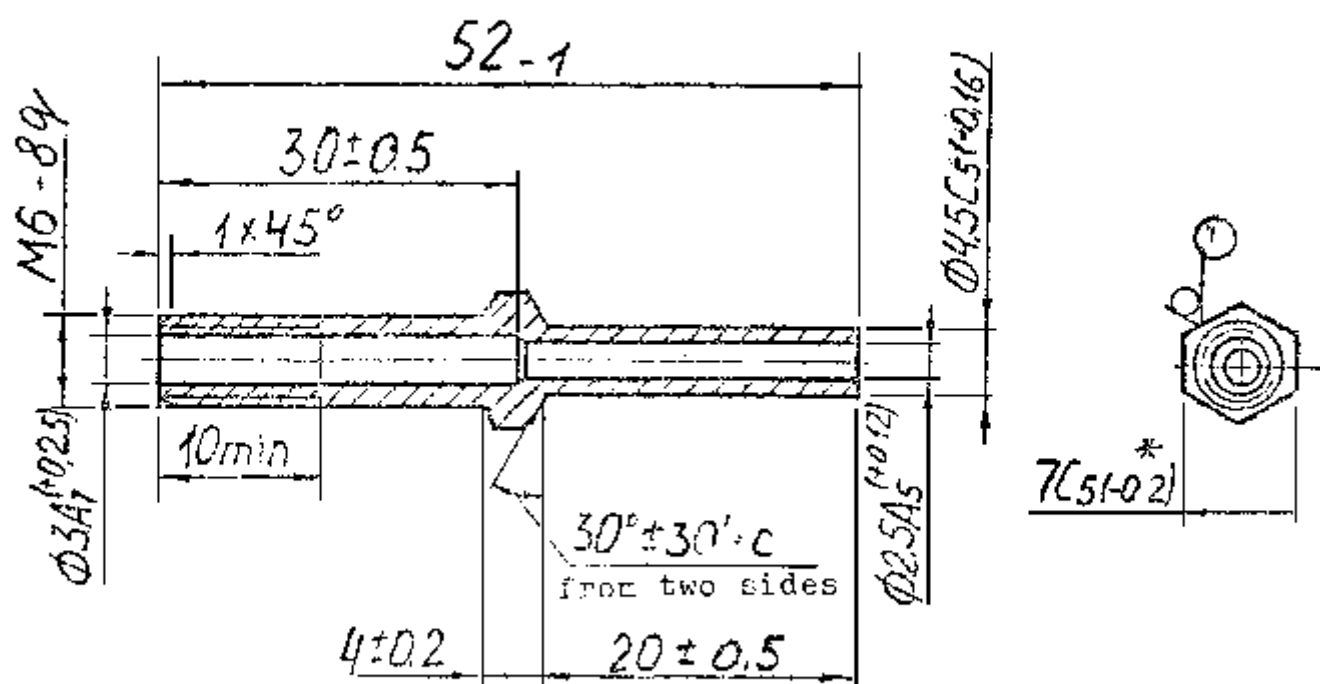


00892	ISSUE	NATURE OF AMENDMENTS
ICV	ICV	EQ. MATERIAL ADDED.
00892	ICV	EQ. MATERIAL ADDED.
00892	ICV	EQ. MATERIAL ADDED.

TECHNICAL CONDITIONS

1. Substitute for material - round bar 12-5 GOST 7417-75
 2. Coating: zinc $\rightarrow$ Cr. Absence of coating on inner surfaces is tolerable.
 3. *Size is given for reference.
- (A) EQ. MATERIAL: 1. CLASS 2 (20C8) TO IS: 2004-91
2. C 20 OR C 25 Mn75 TO IS: 2073-79

APPROVED		675-10-42			
CHECKED.		SHAFT		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				0.018	2:1
			SHT	SHTS.	
		ROUND BAR	<u>12-5 GOST 7417-75</u> 20-B GOST 1051-73		



TECHNICAL CONDITIONS

- Coating: zinc 9 Cr. Remove hydrogen embrittlement. Absence of coating in holes is tolerable.
- Size is given for reference.

Ⓐ EQ. MATERIAL - CLASS-4, 45CB TO IS: 2004-91 'N' CONDITION

00852-ICV	Ⓐ	EQ. MATERIAL ADDED
10.1.2001	10.1.2001	
DATE	ISSUE	NATURE OF AMENDMENTS

APPROVED

675-10-43

CHECKED C.P.R.

WEIGHT SCALE

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

LUG

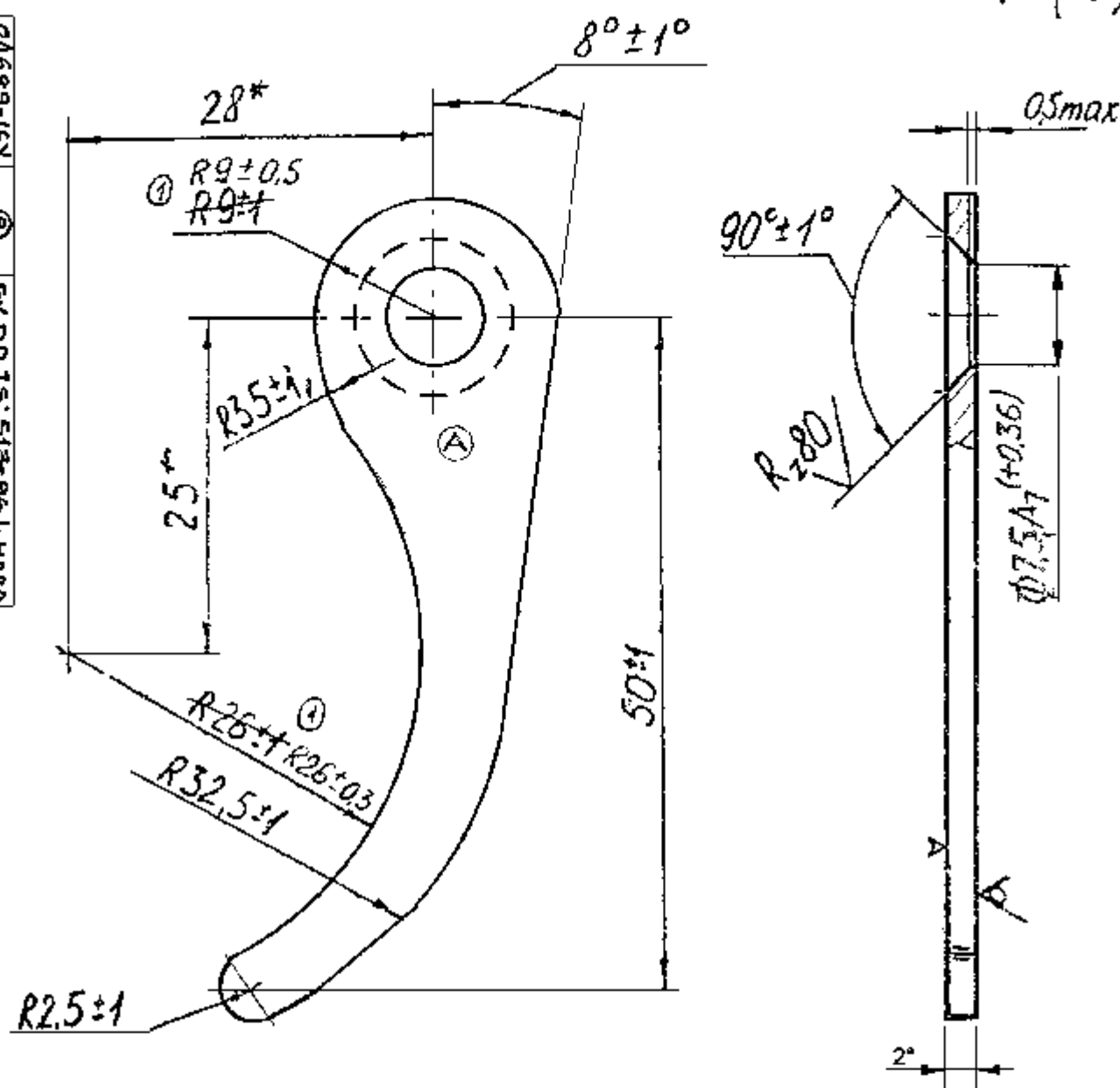
0.017 2:1

SHT SHTS

HEXAHEDRON 7-5 GOST 8560-78
45-B GOST 1051-73

675-10-44

R2160/ (✓)



1. Substitute for material - sheet B-NH-0-2 ГОСТ 19903-74
3-II-cr3cn ГОСТ 16523-70

2. *Size is given for reference.

③ EQ. MATERIAL: - G. DD IS: 513-86
(1/4 HARD)

00459-1CV 3-2 AU G'94	(A)	DOTTED CIRCLE ADDED.
DC(I) No & DATE	ISSUE	NATURE
AMENDMENTS		

APPROVED

675-10-44

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

LEVER

WEIGHT SCALE

0.014 2:1

SHT SHTS

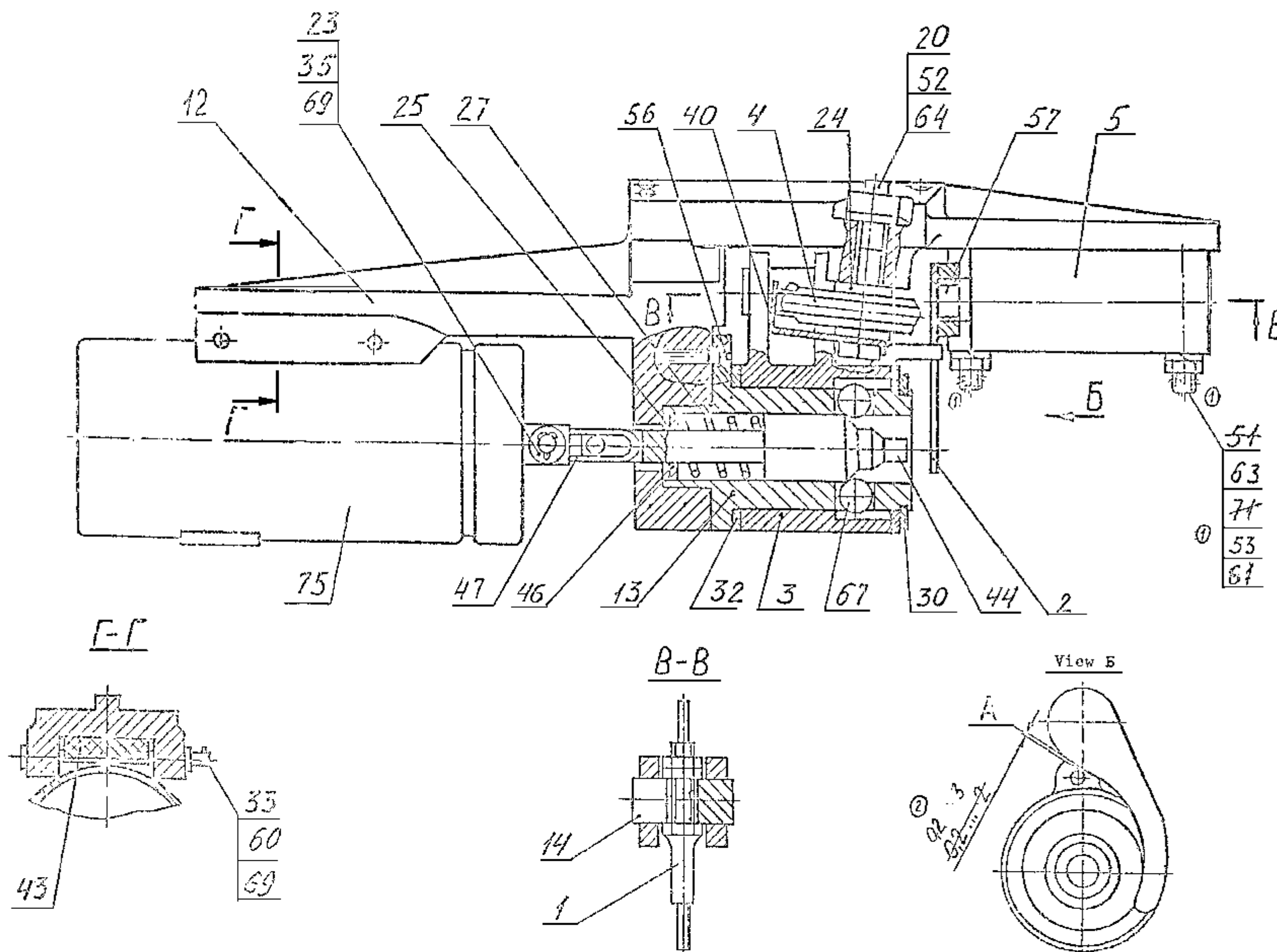
SHEET A-nY-0-2, GOST 19904-74
5-II-r-10, GOST 16523-70

Ref No.	Designation	Description	Qty	Remarks
1	675-10-c6114CE	<u>Documents</u>		
		Assembly drawing		
		<u>Assembly Units</u>		
		Cable	1	
		Lever	1	
2	675-10-c6116	Lever	1	
3	675-10-c6117	Lever	1	
4	765-08-c6211	Roller assembly	1	
5	765-96-c6163	Limit switch (rotary)	1	
12	675-10-38	<u>Parts</u>		
		Body	1	
		Bushing	1	
		Shaft	1	
		Bolt	1	
		Washer	2	
		Washer	2	
		Washer	1	
		Spring	1	
		Ring	1	
		Ring	2	
		Shaft with head		
		Pin Straight Headed		
		Shaft with head		
		PIN STRAIGHT HEADED		
		Limitter	1	
		Plate	1	
		Rod	1	
		Ring Sealing Toroidal	1	
		Shackle		

APPROVED	675-10-Sb114		
CHECKED	DETENT LOCK	WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)			
		SHT 1	SHTS 2

Ref. No.	Designation	Description	Qty	Remarks
		<u>Standard Items</u>		
52		Nuts FOCT 5927-70		
53		M8.6019	1	
		Bolt 3M6-8gx40.46.019	2	
		FOCT 7795-70		
56	COUNTERSUNK SCREW M4X16 TO IS:1365-4-8 PITCH 0.7 AS PER IS:4218 (PART-III)-76 ZINC PLATED 6 MICRONS THICK. COUNTERSUNK SCREW M6X16 TO IS:1365-4-8 PITCH 1mm AS PER IS:4218 (PART-III)-76 ZINC PLATED 9 MICRONS THICK.	Screws FOCT 17475-80		
57		B1.M4-8h6hx16.48.016	4	
		B1M6-8gx16.48.019	1	
		Washer FOCT 11371-78	2	
60		4.01.019 or 4.02.019		
61	EQ.MAT.C-30 TO IS:1570-79	6x1.01.019 or 6x1.02.019	2 (Ref.DC(t) 00337-ICV)	
		Washers FOCT 6402-70		
63		6T65FO6	2	
64		8T65FO6	1	
67		Ball B-10-100 FOCT 3722-81	2	
		and ETY 500		
69	SPLIT PIN 1.6X10 IS:549 ZINC PLATED 9-THICK	Cotter pin 1,6x10,019	4	
		FOCT 397-79		
		<u>Miscellaneous</u>		
75		Electric starter JNC-3	1	COMMERCIAL ITEM
		00381/ICV Bab J50 OCT 93 (C) REL com FOR REF.NO.46.D.S CAT. PT.NO. ADDED & NOMENCLA- TURE WAS 'OIL SEAL		
		00357 ICV Bab 21 APR 93 00352-ICV Bab 20-4-93 (B) MD (A) MD REF NO.6 56 AND 57 IS EQUIVALENT ADDED REF NO.691- IS EQUIVALENT ADDED		
		DC(t) No. DATE	ISSUE	NATURE
AMENDMENTS				

APPROVED	675-10-Sb114Sb			
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	DETENT LOCK		WEIGHT	SCALE
		SHT 2	SHTS 2	



TECHNICAL CONDITIONS

1. Lubricate working surfaces of parts with grease LITON-201 POCT 6267-74.
2. In presence of clearance between relay rod and rod Ref. No. 44 install shackle Ref. No. 47 with its long groove. If these rods are in contact, install shackle Ref. No. 47 with its short groove.
3. Ensure clearance A by resetting part Ref. No. 2 in slots of switch.
4. Apply voltage of (22 ± 0.5) V to check switching of magnet. With force of at least 40 kgf applied to cable Ref. No. 1, rod Ref. No. 44 should positively displace disconnecting lever Ref. No. 3 from bushing Ref. No. 13. When voltage is switched off and grooves of lever Ref. No. 3 are aligned with balls Ref. No. 67, rod Ref. No. 44 should positively return to initial position.
5. Install screw Ref. No. 57 on zinc white paste POCT 482-77.

APPROVED *[Signature]*
 CHECKED *GPR*
 CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

675-10-Sb114Sb

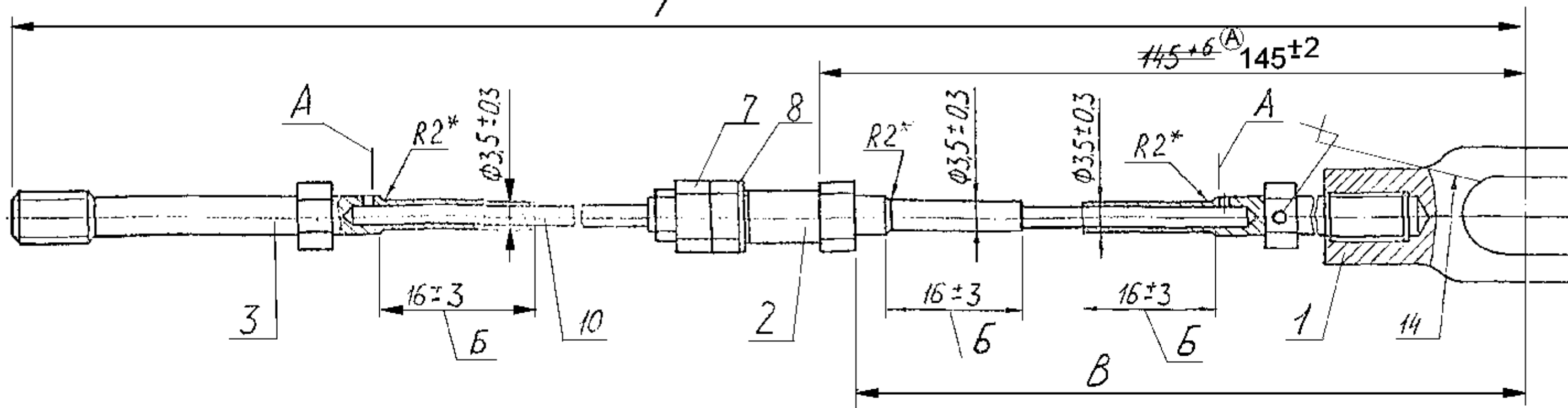
DETENT LOCK
 Assembly Drawing

WEIGHT	SCALE
2.8	1:1
SHT	SHTS

Ref. No.	Designation	Description	Qty	Remarks												
	675-10-c61150B	<u>Documents</u> Assembly drawing														
		<u>Parts</u>														
1	675-10-39	Plug	1													
2	675-10-43	Lug	1													
3	765-10-2170	End piece	2													
		<u>Standard Items</u>														
7		Nut M6.6.019 FOOT 5927-70	2													
8	EQ MAT.C-30 TO IS-1570-79	Washer 6x1.01.019 or 6x1.02.019 FOOT 11371-78	2	(Ref DCN) 00957-ICV)												
		<u>Materials</u>														
10		Cable 2.25 FOOT 2172-80, L = 600 mm	1													
14(A)	EQUIVALENT MATERIAL: MILD STEEL WIRE, GALVANISED 1mm DIA, 1/4 HARD TO IS 280-78 UTS 37 kgf/mm ² (min)	Wire EC FOOT 792-67, L = 220 mm	1													
<table><tr><td>00469-ICV</td><td>(A)</td><td>EQUIVALENT MATERIAL ADDED FOR REF NO 14</td></tr><tr><td>14 SEP '94</td><td></td><td></td></tr><tr><td>00469-ICV</td><td>ISSUE</td><td>NATURE</td></tr><tr><td colspan="3">AMENDMENTS</td></tr></table>					00469-ICV	(A)	EQUIVALENT MATERIAL ADDED FOR REF NO 14	14 SEP '94			00469-ICV	ISSUE	NATURE	AMENDMENTS		
00469-ICV	(A)	EQUIVALENT MATERIAL ADDED FOR REF NO 14														
14 SEP '94																
00469-ICV	ISSUE	NATURE														
AMENDMENTS																

APPROVED	675-10-Sb115		
CHECKED	CABLE	WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)			
		SHT	SHTS

675-10-Sb115Sb



TECHNICAL CONDITIONS

1. Crimp ends of parts Ref. Nos 2 and 3 at two points at sections E. After crimping, subject cable to stretching test with force of (130 ± 10) kgf for 2 min at sections B and F; cable getting out from check hole A is not tolerable and cable should have no broken wires.
2. Crimping fin of $(2_{-0.5})$ mm, maximum, from both sides is tolerable.
3. Sink marks not in excess of 0.3 mm on sections E are tolerable.
4. *Sizes are ensured by means of tools.

01084-ICV	(A)	DIMENSION 145 ± 2 WAS 145 ± 6
12-8-09		
DECISION & DATE	ISSUE	AMENDMENT

APPROVED		675-10-Sb115Sb		
CHECKED	GPR			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		CABLE		
			WEIGHT	SCALE
			0.084	2:1
			SHT	SHTS

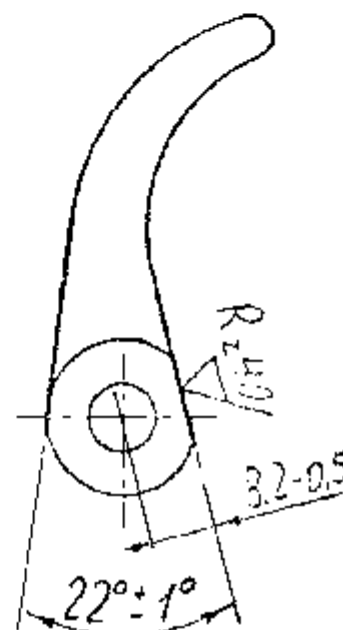
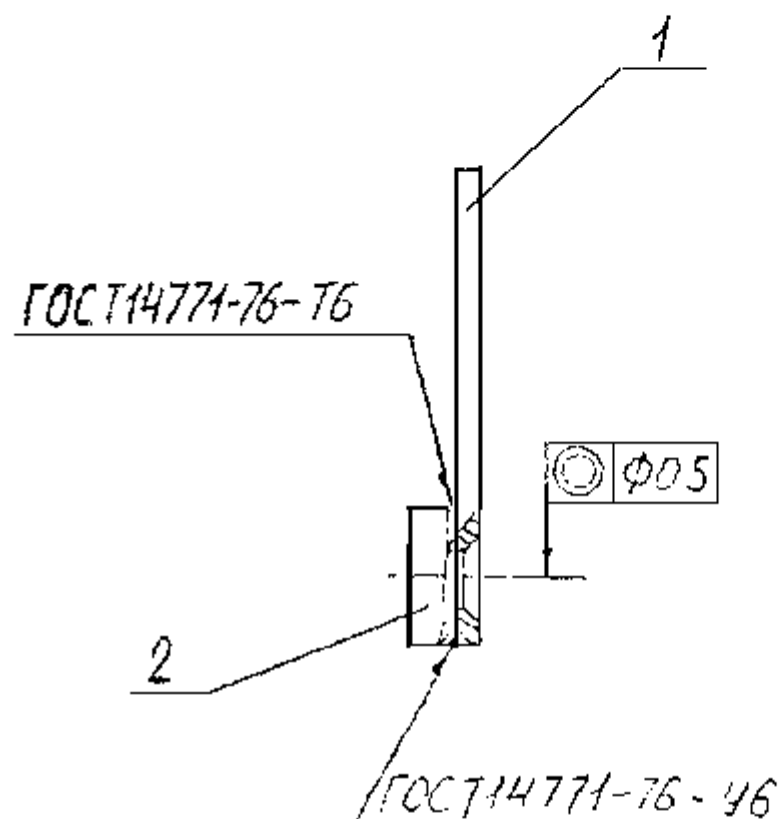
Ref. No.	Designation	Description	Qty	Remarks
	675-10-c6116CB	<u>Documents</u> Assembly drawing		
		<u>Parts</u> 		
1	675-10-44	Lever	1	
2	765-96-23	Bushing	1	

APPROVED	675-10-Sb116			
CHECKED <i>GPR</i>				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	LEVER		WEIGHT	SCALE
		SHT	SHTS	

675-10-Sb116Sb

TECHNICAL CONDITIONS

1. Filling wire $\text{св03Г20 ГОСТ 2246-70}$.
2. It is allowed to use brass $\text{Л-63 ГОСТ 15527-70}$ for soldering.
3. Requirements to quality of weld - according to OCT 3-4001-77 for off-design welded joints.
4. Coating: zinc 9-Cr . Remove hydrogen embrittlement.



APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

675-10-Sb116Sb

LEVER

WEIGHT SCALE

0.028 1:1

SHT SHTS

Pei. No.	Designation	Description	Qty	Remarks
	675-10-c6117CE	<u>Documents</u> Assembly drawing		
1	675-10-41	<u>Parts</u> Lever	1	
4		<u>Standard Items</u> Pin 4Пp2zax25 OCT 3-2234-80	1	

APPROVED

CHECKED GPR

675-10-Sb117

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

LEVER

matl

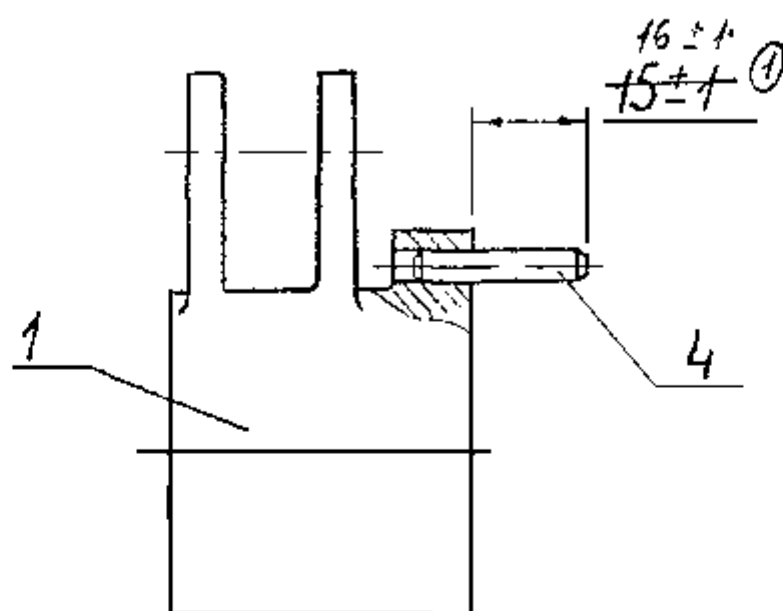
WEIGHT

SCALE

SHT

SHTS

675-10-Sb117Sb



APPROVED *[Signature]*
 CHECKED GPR
 CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

675-10-Sb117Sb

LEVER
 Assembly Drawing

	WEIGHT	SCALE
	0.21	1:1
SHT	SHTS	

700-28-470

010261CV

(C)

EQUIVALENT
MATERIAL ADDED.304 S 15 TO 89:
970

28-7-06

DC(I) No.

DATE

NATURE

AMENDMENT

00460-1CV

26-8-94

(A)

NOTE No. 8 FOR EQUI-
VALENT MATERIAL
NEWLY ADDED (D-1239)

DC(I) No. 2 DATE

ISSUE

NATURE

AMENDMENTS

30/

(B)

DESIGNATION
BOLT MACHINE

D.S. CAT No.

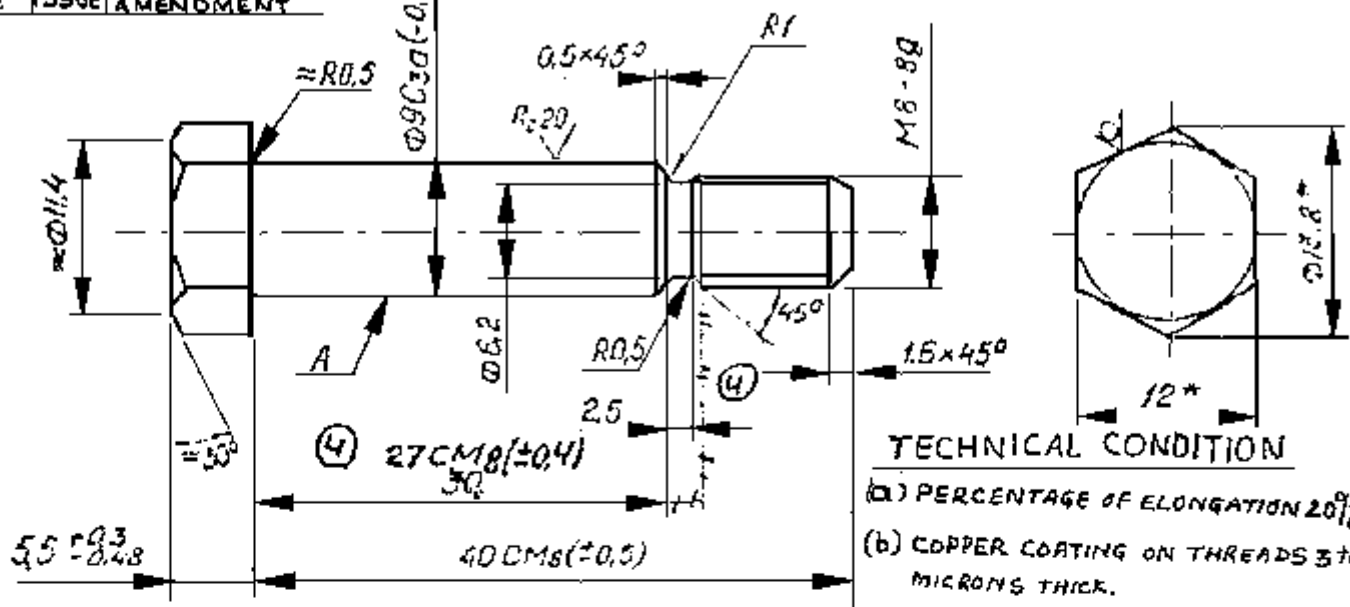
LV2/RVC 5306-010450

Полн. и дата

Изм. № и дата

Взам. № и дата

17-10-750



TECHNICAL CONDITION

- (a) PERCENTAGE OF ELONGATION 20% (MIN)
- (b) COPPER COATING ON THREADS 3 TO 5 MICRONS THICK.

- Alternate material is steel cm5, GOST 380-71 and Steel 35, 40, 50, GOST 1050-74.
- Unspecified limit deviations of dimensions are as follows. For holes - as per A₇, for shafts - as per B₇, for others - as per CM₇.
- Displacement of head with respect to the rod axis should not exceed 0.4 mm.
- Radial run-out of surface A with respect to the angle diameter of the thread should not exceed 0.2 mm.
- * Dimensions are given for reference.
- Coating. Zinc-plating, 9 microns thick, chromitized. Remove hydrogen embrittlement.
- Other technical specifications are as per GOST 1759-70, Section

D.S. CAT No. added and description added.	(B)	D.S. CAT No. added and description added.	NATURE OF AMENDMENT
00590-1CV	17-10-1996	17-10-1996	ISSUE
17-10-1996	17-10-1996	17-10-1996	DATE

APPROVED

19.11.94

CHECKED

B.M. MSREDDY

700-28-470

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

BOLT

WEIGHT SCALE

0.025 2:1

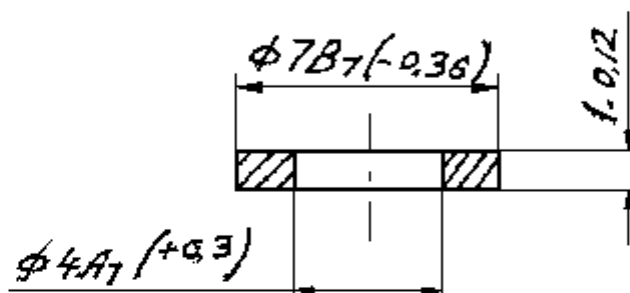
SHT SHTS

HEXAEDRON

12-5 GOST 8560-78
45-B GOST 1051-73

700-31-7

Ⓐ EQUIVALENT MATERIAL: Cu Zn 37.15:410-T1



00624-ICV

24 MAR 98

DC(I)No.

& DATE

Ⓐ

Gu

ISSUE

AMENDMENTS

MATERIAL Cu Zn 37.15:410-T1, ADDED AS EQUIVALENT MATERIAL.

APPROVED

M. VASO

CHECKED

20 MAR 98

700-31-7

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

WASHER

SHEET ДПРХМ-1НД Л63М
ГОСТ 931-76

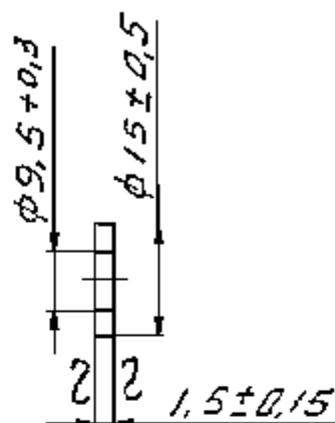
WEIGHT SCALE

0.002 5:1

SHT SHTS

700-31-267

V (V)



1. Alternate material is steel Cm2, Cm3, GOST 380-71 and 08kn 10,15,20,25, GOST 1050-74.
2. Coating. Zinc-plated, 9 microns thick, chromitized.

Ⓐ EQ. MATERIAL :- STEEL SHEET Gde. 'O' QUARTER HARD TO IS: 513-86 OR Fe 410-1079 TO IS: 1079-73.

Ⓑ EQ. MATERIAL :- COLD STEEL STRIP GRADE 'O' OR 'D' TO IS: 4030-73.

00814-ICV

03 OCT 00

00605-ICV

21 APR 97

DC(I)No.

& DATE

Ⓑ

Ⓐ

Ⓐ

ISSUE

AMENDMENTS

EQ. MATERIAL ADDED.

EQ. MATERIAL ADDED.
(2/97 N OF A)

APPROVED

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

700-31-267

WASHER

CT 3KN GOST 380-71

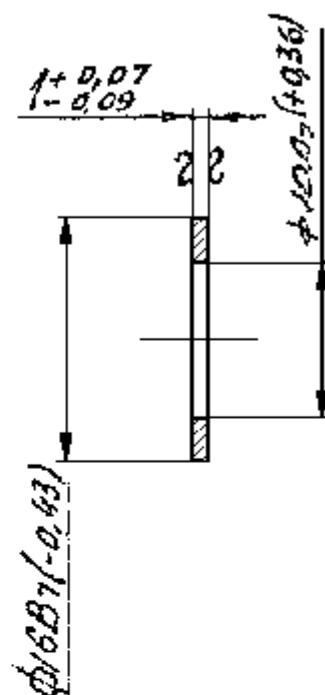
WEIGHT SCALE

0.003 1:1

SHT SHTS

700-31-835

✓(✓)



- 1) Alternate material is steel 08kn, GOST 1050-74, and steel 65Г, GOST 14959-79.
- 2) Non-symmetry of hole with respect to the contour should not exceed 0,25 mm.

④ 3. Equivalent material is DD or D to IS:1079 or IS:513.

00330-ICV

Buloy

23 JUN 92

DC(I)No.
& DATE

④

NOTE FOR EQUIVALENT
MATERIAL ADDED.

ISSUE

AMENDMENTS

APPROVED

H. VASU

CHECKED

B. S. VARK

700-31-835

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

WASHER

10 GOST 1050-74

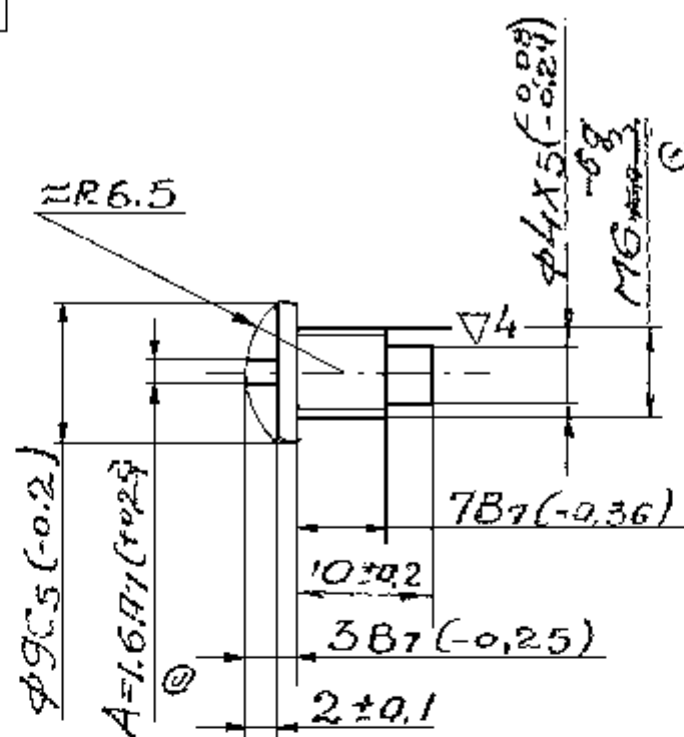
WEIGHT SCALE

0.001 2:1

SHT 1 SHTS 1

89E-9E-007

V3(V)



1. Alternate material is steel cm5, GOST 380-71, steel 40: 50, GOST 1050-74, and steel 40Г, GOST 4543-71.
 2. HB 255 to 207 ($\phi 3,8$ to 4,2).
 3. Incomplete thread should not exceed 2 mm.
 4. Displacement of slot with respect to axis of rod should not exceed 0,4 mm,
 5. coating: MH 9.
 6. It is allowed to perform dimension A equal to $16^{+0.25}_{-0.08}$
- (A) EQ. MATERIAL:- 45 CB TO IS: 5517-93

00722-ICV

V. Rame

07 SEP 99

DC(I)No.
& DATE

(A)

Cur

EQ. MATERIAL ADDED.

ISSUE

AMENDMENT'S

APPROVED

M. V. 2023

CHECKED

D. SKUMAR

700-35-368

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

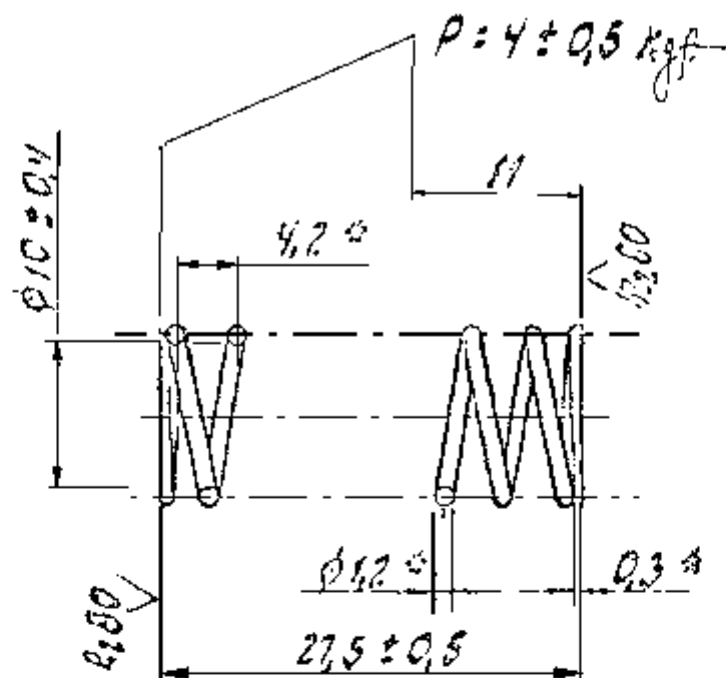
SCREW

45, GOST 1050-74

WEIGHT SCALE

0.0028 2:1

SHT 1 SHTS 1



- 1). Shear modulus is $G^* = 8000 \text{ kgf/mm}^2$.
- 2). Tangential twisting stress (maximum) is $\tau_3^* = 81 \text{ kgf/mm}^2$.
- 3). Total length of spring is $L^* = 320 \text{ mm}$.
- 4). Number of working coils is $n=6$.
- 5). Total number of coils $n_1 = 8 \pm 0.5$
- 6). Direction of winding-left hand.
- 7). * Reference dimensions.
- 8). Coating: Chemically parkerized, accelerated, chromatized, impregnated with preservation oil K-17 GOST 10877-76 as per Instructions 053.25289.00002 or with varnish KO-815 GOST 11066-74.

Ⓐ EQ. MATERIAL:- WIRE Gde.3 TO IS: 4454 (PT.-I)- 81.

00597-ICV

30 JAN 97

DC(I)No.
& DATE

Ⓐ

SP

ISSUE

EQ. MATERIAL ADDED.
(4/96 N OF A)

AMENDMENTS

APPROVED

H VAS

CHECKED

D. SKUMIR

700-38-799

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

SPRING

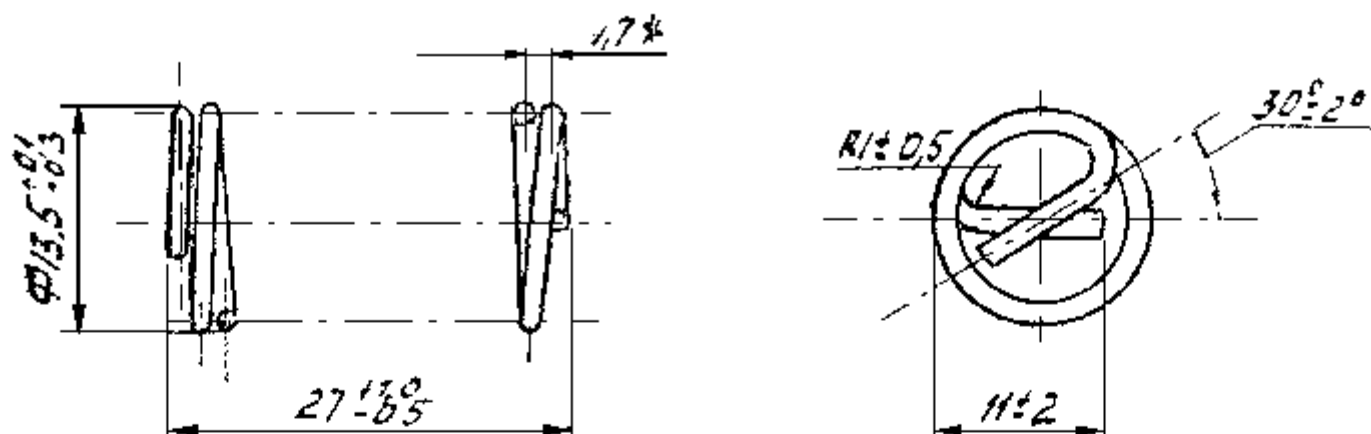
WEIGHT SCALE

0.008 2:1

SHT SHTS

WIRE II-1.2 GOST 9389-75

700-38-1805



- 1). Coating: Zinc-plating, 9 microns thick, chromated. Remove hydrogen embrittlement.
- 2). Test by twisting, through 195° . Deformation is not allowed.
- 3). Total length of spring^{wire} is $L^* - 600$ mm.
- 4). Number of working coils is $n=15.5$
- 5). Direction of winding is left-hand.
- 6). Displacement of the axes of the spring ends with respect to the spring axis is ± 0.5 mm.
- 7). * Dimensions are given for reference.

EQ MATERIAL - GRADE-3 TO IS 14454-81.

00852-ICV

31 JAN 01

DC(I) No.

& DATE

④

Issue

ISSUE

AMENDMENTS

EQ. MATERIAL ADDED.

APPROVED

H. VAGU

CHECKED

700-38-1805

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

SPRING

WIRE II - 1.4, GOST 9389-75

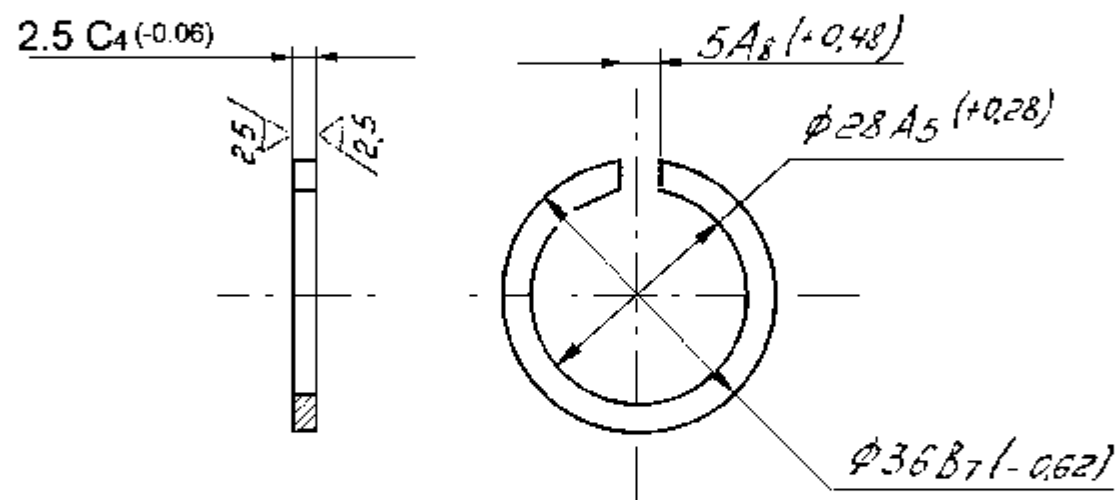
WEIGHT SCALE

0.0073 2:1

SHT SHTS

998-68-002

Rz80
(✓)



1. HRC 37 to 48.
2. Slot may be made by stamping. In this case, stamping draft should not exceed 0.3 mm towards the slot increase. Roughness of slot sides is ✓
3. Coating: Chemically parkerized, accelerated, chromatizing, oiled.
4. Temper colours are allowed. Decrease in hardness of the part should not exceed 3 units HRC on sections with length not more than 6 mm from the slot butt ends.
5. Carryout checking of diametral dimensions before heat - treatment and cutting
Ready made ring, put on the shaft $\phi 28.5$ mm, should be closely fitted.

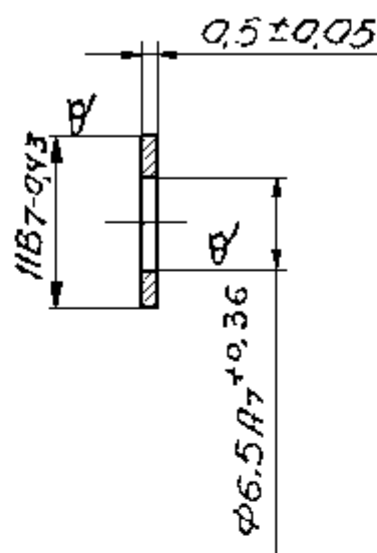
Ⓐ EQ. MATERIAL:- STEEL Gde.3 65 C TO IS: 2507-75.

00587-ICV 28 OCT 96	Ⓐ	EQ. MATERIAL ADDED. (3/96 N OF A)
DCI)No. & DATE	ISSUE	AMENDMENTS

APPROVED	M.VASU	700-39-365			
CHECKED	AMISHA	RING		WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)				0.008	1:1
			SHT SHTS		
		STEEL 65r GOST 14959-79			

700-40-153

2 (A)



- 1). Alternate material is steel cm2, cm3, GOST 380-71 and steel 08nc,¹⁰₄ 10kn, 15, 15kn, 20, 25 and 30 GOST 1050-74.
- 2). Coating: Zinc-plated, 9 microns thick, chromitized. Remove hydrogen embrittlement.

(A) EQ. MATERIAL: - Gdr 'D' (OR) 'DD' (OR) EDD TO IS: 1079-88 OR

(B) GRADE - 'D' TO IS: 513-86

00898-ICV

(B)

Handwritten signature
21 AUG 01

00272-ICV

(A)

Handwritten signature
07 SEP 99

DC(I)No.

& DATE

ISSUE

EQ. MATERIAL ADDED.

EQ. MATERIAL ADDED.

AMENDMENTS

APPROVED

M. VASRI

CHECKED

Handwritten signature
DSKUMAR

700-40-153

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

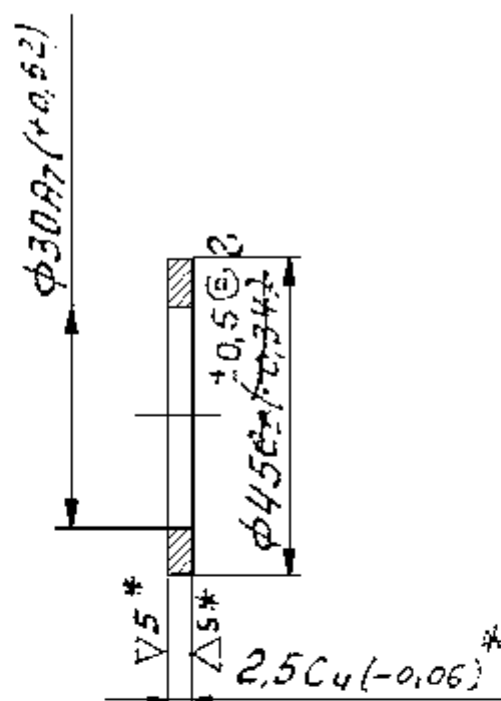
GASKET

08Kn GOST 1050-74

WEIGHT SCALE

0.0003 2:1

SHT SHTS



Ⓐ EQ. MATERIAL :- 40 Cr 4 Mo 3 TO IS: 5517-78.

- 1) H R C 37 to 48.
Isothermal hardening is allowed
- 2) Asymmetry of hole with respect to contour should not exceed 0.5 mm.
- 3) * Dimensions and roughness of surfaces are after heat-treatment

00612-ICV

25 JUN 97

DC(I)No.
& DATE

Ⓐ

EQ. MATERIAL ADDED.
(3/97 N OF A)

ISSUE

AMENDMENTS

APPROVED

M. VAŞU

CHECKED

700-42-188

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

RING

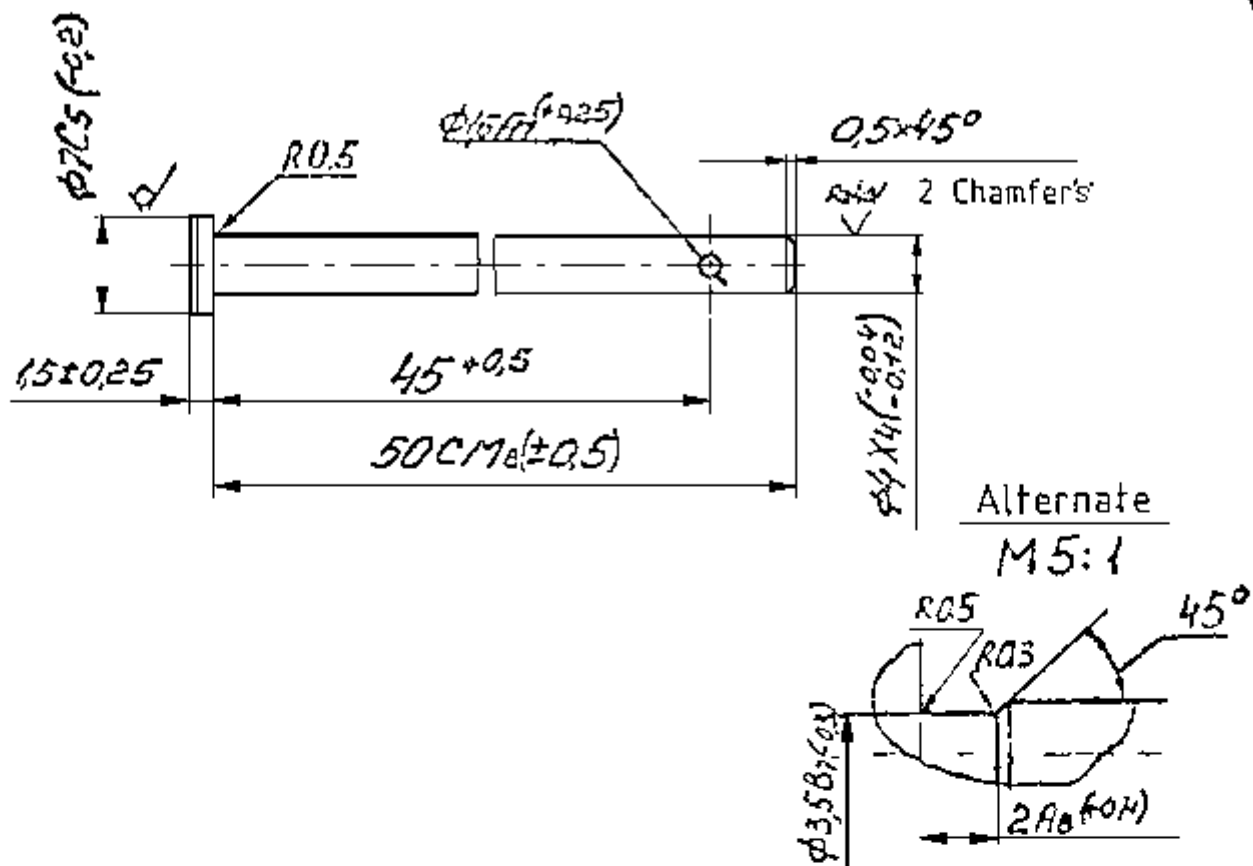
WEIGHT SCALE

0.01 1:1

SHT SHTS

38 x C GOST 4543-71

700-47-124

GTS
✓(✓)

1. HB 302 to 255 ($\phi 3.5$ to 3.8).
 2. Alternate material is steel 40x, 40xC, GOST 4543-71.
 3. Coating: Zinc-plated, 9 microns thick, chromatized.
Remove hydrogen embrittlement
- Ⓐ EQ MATERIAL: 40 CY1 TO IS: 4367-67.

00971-ICV

30 JUN 04

00852-ICV

31 JAN 01

DC(I) No.
& DATE

Ⓑ

C

DS CAT No. ADDED. AND
DESCRIPTION WAS
"SHAFT WITH HEAD"

Ⓐ

G

EQ. MATERIAL ADDED.

ISSUE

AMENDMENTS

APPROVED

H VAGU

700-47-124

DS CAT PART No. Ⓑ[Ⓐ]
LV2/ICVS 5315-009593

CHECKED

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)PIN STRAIGHT HEADED Ⓑ[Ⓐ]
SHAFT WITH HEAD

WEIGHT SCALE

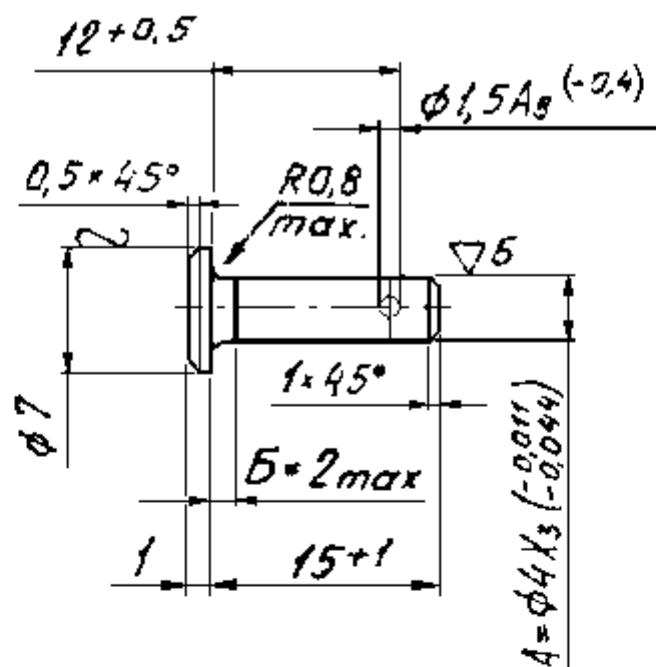
0.005 2:1

SHT SHTS

ROUND BAR 7-5 GOST 7417-75
45x GOST 4543-71

700-47-272

▽3(▽)



1. HB 302 to 255 (ϕ 3,5 to 3,8).
2. Alternate material is 40x, 40xC, 38xA GOST 4543-71.
3. Coating: chromium plated, hard, 18 to 42, impregnated with preservation oil K-17 GOST 10877-76 as per instructions 053.25289.00002 or varnish KO-815 GOST 11066-74. Check dimension A after coating. Quality of coating need not be checked on section 'B'. Absence of coating is allowed on hole and buttends.
4. Unspecified limit deviations of dimensions for holes are as per A7, and for shafts as per B7.

01013-ICV <i>[Signature]</i> 19 JAN 06 00321-ICV <i>[Signature]</i> 11 FEB 92 DC(I)No. & DATE	⑧	DS CAT PART NO ADDED AND DESCRIPTION "PIN STRAIGHT HEADED" WAS "SHAFT WITH HEAD"
	⑧	NOTE FOR EQUIVALENT MATERIAL ADDED.
ISSUE		AMENDMENTS

APPROVED
CHECKED

H VASU

700-47-272

DS CAT PART No : ⑧
LV2/ICVS 5315-030879

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

~~SHAFT WITH HEAD~~
⑧ PIN STRAIGHT HEADED

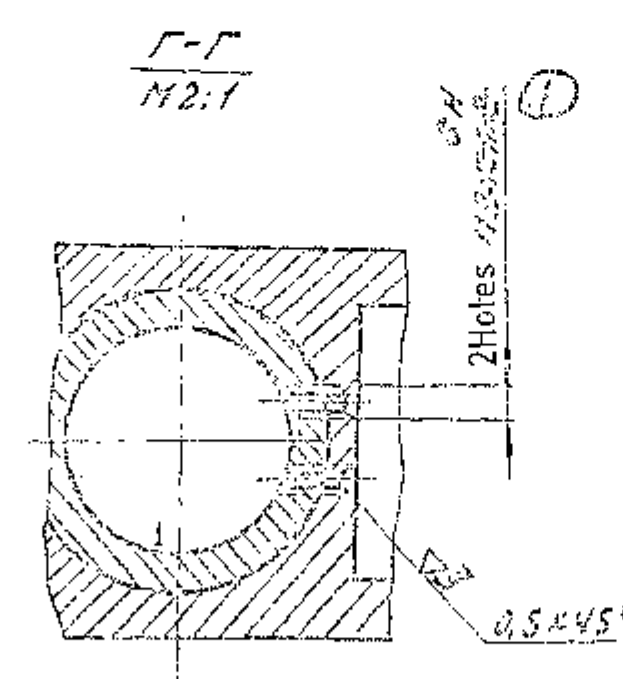
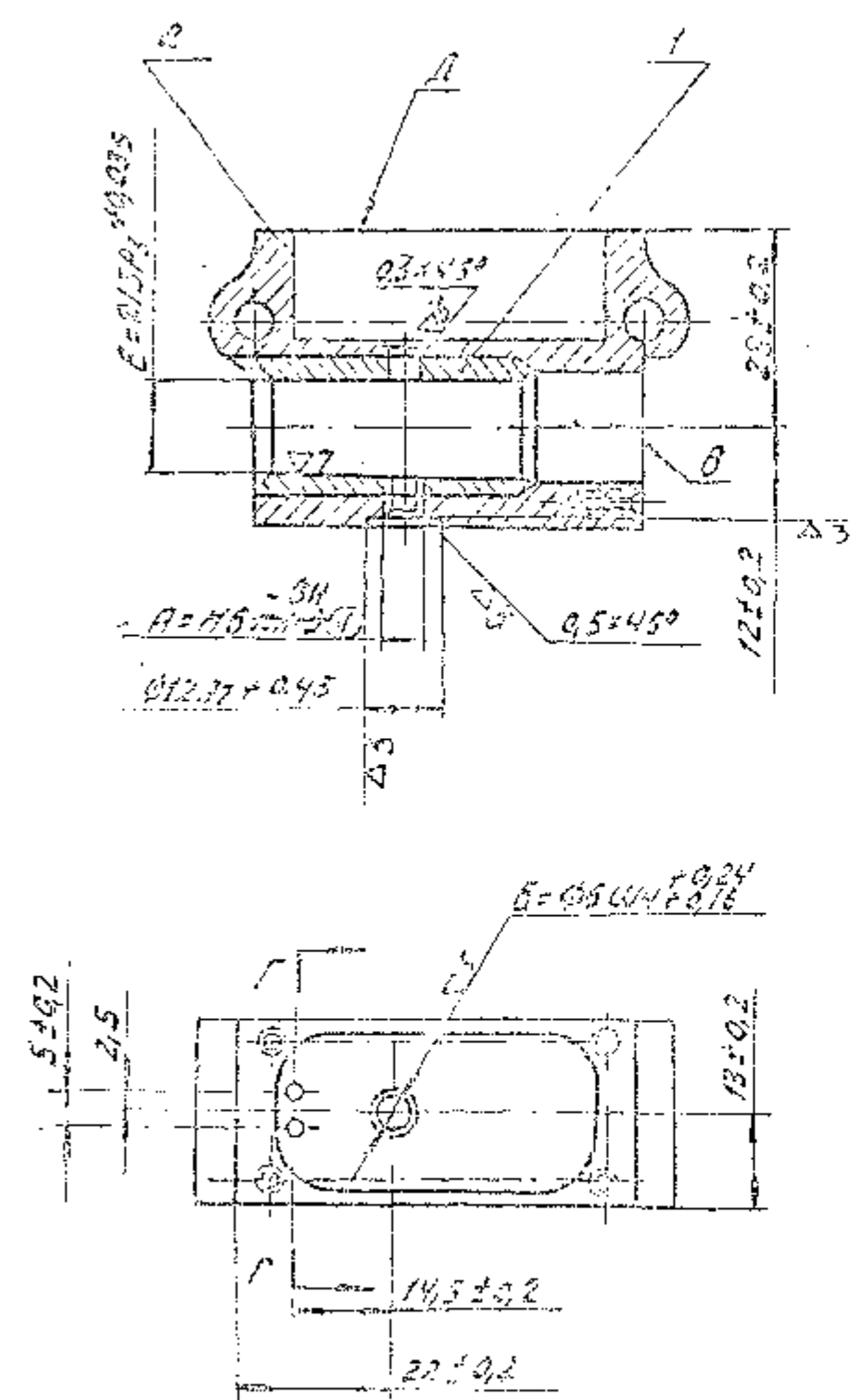
45 GOST 4543-71

WEIGHT SCALE

0.0017 2:1

SHT SHTS

765-96-166



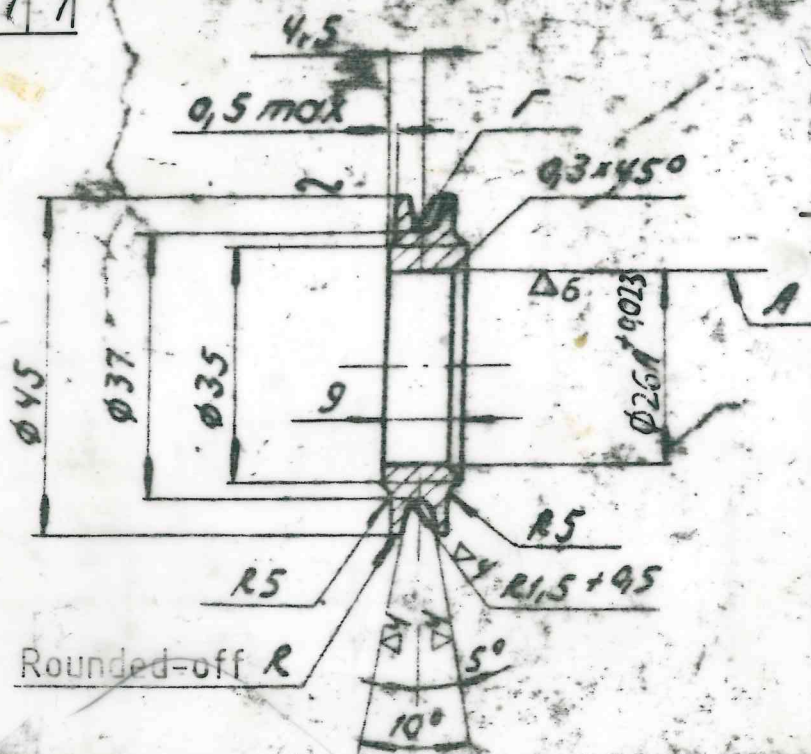
1. Blunt sharp edges.
2. Eccentricity of holes A and B should not exceed 0.1 mm (Qualified tolerance).
3. Displacement of axis of hole B with respect to axis of hole E should not exceed 0.1 mm.
4. Non-squareness of axis of hole B with respect to axis of hole E should not exceed 0.1 mm.
5. Press in bushing upto the stop.
6. Coat external surface except holes and planes B and D with primer ФА-03-Ж, GOST 9109-81 and paint with grey enamel МЛ-12, GOST 9754-76 and silver enamel МЛ-165, GOST 12034-77.
7. It is allowed to cool bushing in liquid nitrogen before pressing.
8. Surface D may be free from anodic layer.

2	765-96-166	Body	1	
1	765-96-115	Bushing	1	
REF. No.	DESIGNATION	DESCRIPTION	QTY.	REMARKS
APPROVED	M. VASU	765-96-c0164		
CHECKED	DSKUMAR			
CONTROLLERATE OF INSPECTION (ICV)		BODY	WEIGHT	SCALE
			0.128	1:1
			SHT	SHTS
		125 of 413		

USED ON
765-08-C6211

Unless stated
otherwise.

USED ON
765-08-C6211



209
08

1. With respect to axis of surface A: runout of surface F should not exceed 0,15mm.
2. Perform dimensions without deviations as per accuracy class 7, OST 1010.
3. Blunt sharp edges.
4. Coating: Anodic oxidation, chromating.

(A) EQ.MATERIAL:- AL. ALLOY BAR GRADE 24534 TO IS:733-83.

(B) EQ.MATERIAL:-2. 45 DIA. BAR, GRADE 24345 TO IS:1285-75, 'WP' CONDITION.

00826-ICV	(A)	EQ.MATERIAL ADDED.
09-11-2000	ISSUE	AMENDMENTS
DC(I)No.DT		

273
08

765-08-363

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		V.J.RAO		27.4.84
EDT	CHKD	AK DUBOY	Lin Duboy	20.4.04
F/M,DC.		S A NAIR	SA	28.4.84
DIV.OFFR		V.H.IYER	VH	25/5
		NAME	SIGN	DATE

ROLLER

Pipe A 1T 45x12,5xHA
FOCT 18482-79

SHEET WEIGHT SCALE

TOTAL SHEETS

ORDNANCE FACTORY
PROJECT
HYDERABAD

765-08-c8-211

Lock punch at
8th point from
both sides.

0.5



1. The roller must rotate freely on the bearing.

00001-10V	(A)	DS/CAT NO.
09-08-2000	1000	ADDED IN THE
00001-10V	1000	DRAWING IN REP NO.2.
00001-10V	1000	ISSUE NATURE
00001-10V	1000	AMENDMENTS

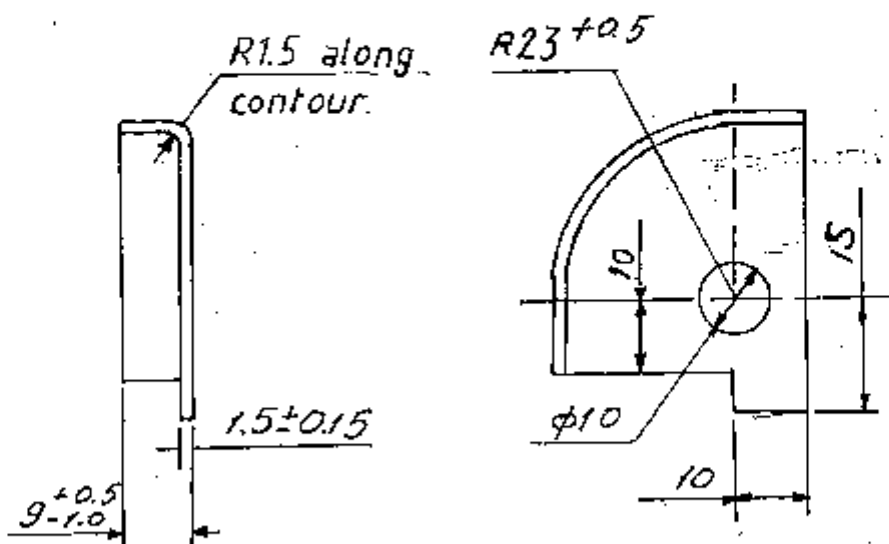
2	(A) DS CAT NO.	Bearing 6-80029	
	LYG/MT7-3110-00000	GOST 7242-70 and	To be purchased
		ETY 500	1
1	765-08-365	Roller	1
Ref No	Designation	Description	Qty Remarks

APPROVED	<i>[Signature]</i>	765-08-c8 211	
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF INSPECTION (12 V)		ROLLER ASSEMBLY	
		WEIGHT	SCALE
		10.036	1:1
		SHT	1SHTS

① EQ. MATL:- HOT ROLLED CARBON STEEL STRIP GRADE 'D', 'DD' OR
St-34 TO IS: 1079-73.

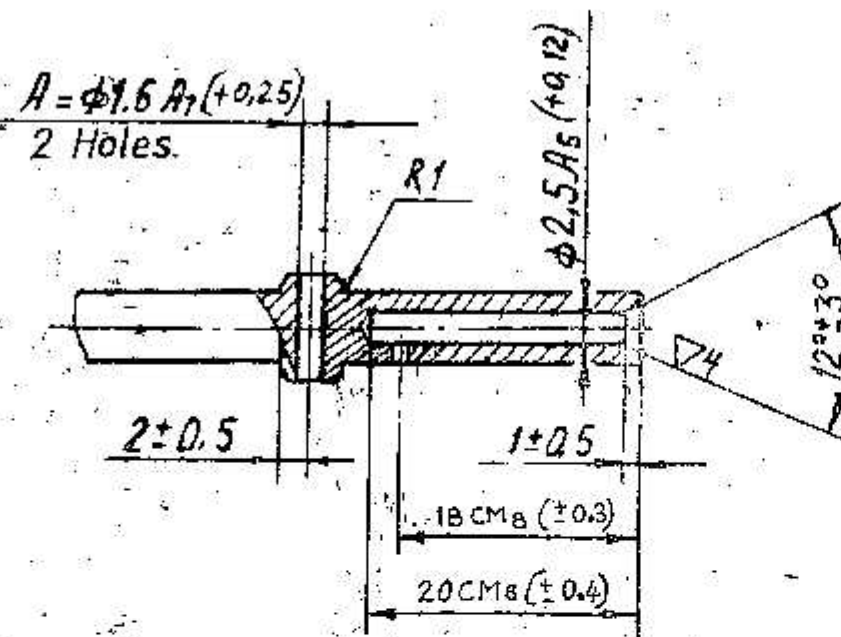
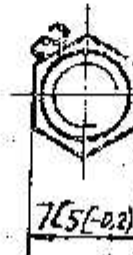
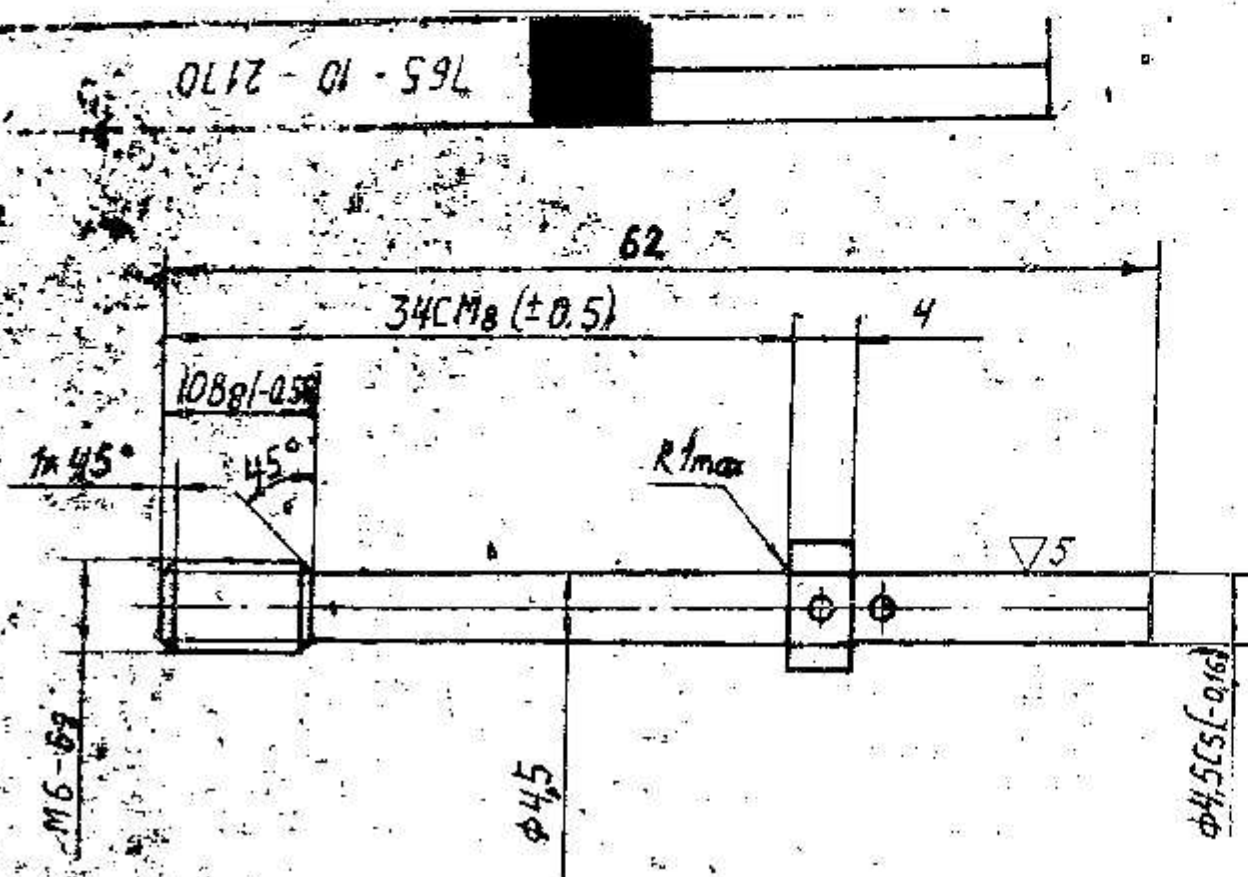
- 1). Blunt sharp edges.
- 2). Perform dimensions without deviations with
an accuracy of ± 0.5 mm.
- 3). Alternate material is steel 08Kn and 08nc,
GOST 1050-74.
- 4). Coating: Chemically-parkerized, accelerated, chromitized,
oiled with preservation oil K-17, GOST 10877-76, as
per instructions 053.25289.00002. or with varnish
Ko-815, GOST 11066-74.

② EQ. MATERIAL:- CRS TO IS: 513-86 (D' CONDITION)



APPROVED	 M. VASO	765-10-445		349 of 379		
CHECKED	ESB DSKV mHA	LIMITER		WEIGHT	SCALE	
CONTROLLERATE OF INSPECTION (ICV)					0.016	1:1
				-SHT	SHTS	
		10 FOOT 1050-74		08		

765-10-2170

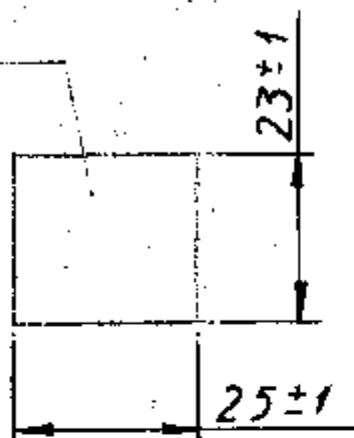


- 1). Coating: Zinc-plating, 9 microns thick, chromating. Remove hydrogen embrittlement. Absence of coating in holes is allowed.
 - 2). Unspecified limit deviations of dimensions for shafts are as per B₇.
 - 3). Position of holes A is arbitrary.
- Ⓐ EQ MATERIAL: CLASS 4, HSCB TO IS: 2004-91 'N' CONDITION.

00852-1CV	Ⓐ	EQ MATERIAL ADDED
41.01.2001	QW	
DC(S) No & DATE	ISSUE	NATURE
AMENDMENTS		

APPROVED	N. V. S. S.	765-10-2170		303 * 342
CHECKED	R. S. S.	END PIECE		WEIGHT SCALE
CONTROLLERATE OF INSPECTION (IC V)		45 OCT-1950-74		001 2.1
				SHT SHTS

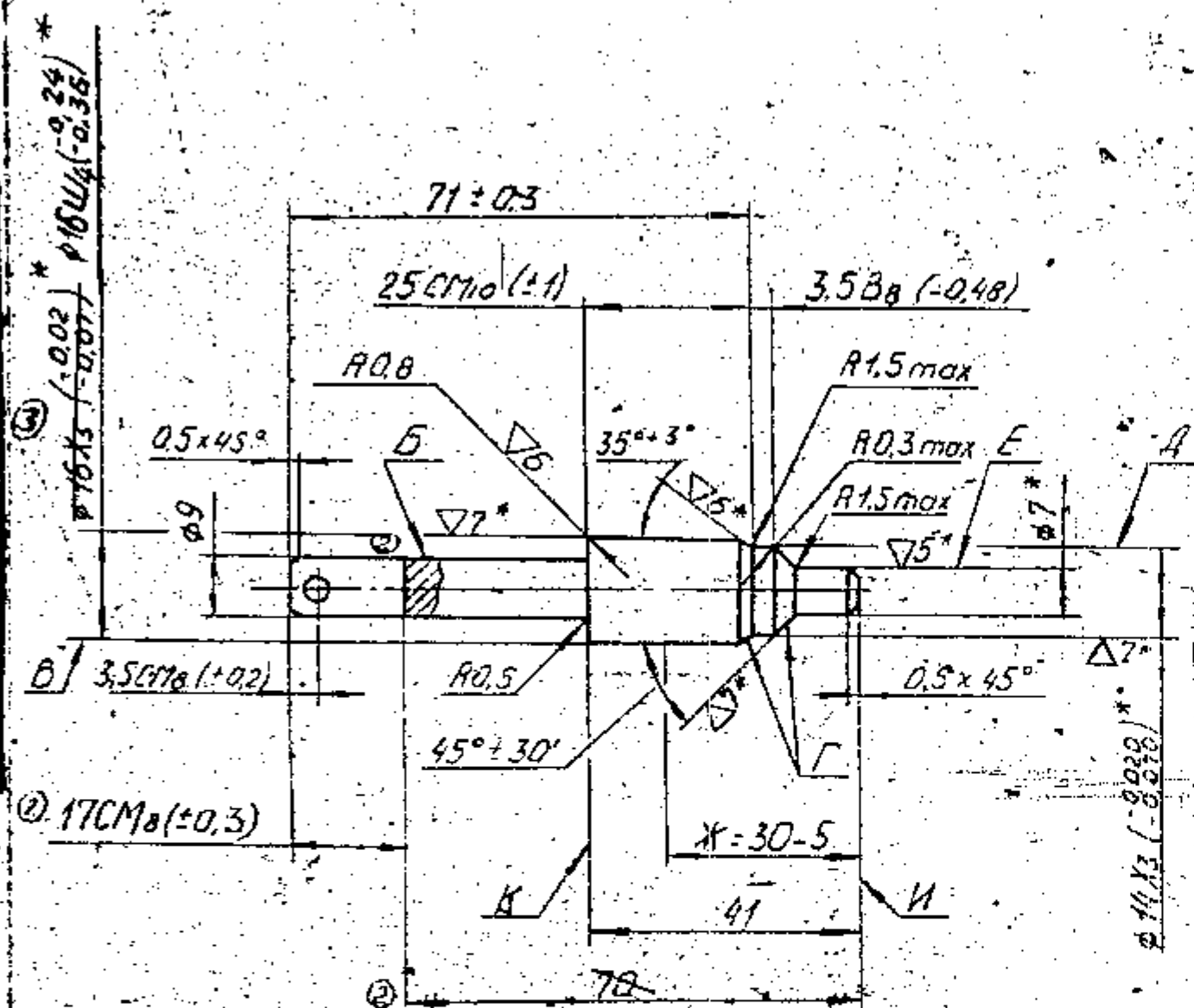
S 8*



2 Other requirements are as per Technical specification Ty 005216-75 for article code 25.4311.

3 *Dimension is given for reference.

APPROVED	AS VASD	765-17-438		316 of 342	
CHECKED	M. W. Shaukh	PLATE		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)				0.009	1:1
		Plate 25 4311-8 Rubber 10643		SHT SHTS	
		Ty 005216-75			



1. TB4 (HFC treatment) should be at least 1 mm; HRC 40 to 49 over length X. Test for hardness on surface B, in this case the grinding of flats not exceeding a depth of 0.5 mm is allowed.
2. Alternate material is 40 X C GOST 4543-71.
3. Unspecified limit deviations of dimensions are as follows: -for holes as per A₇; for shafts as per B₇.
4. With respect to the surface B, the following are allowed:
 - a) Radial run out of tapers Γ should not exceed 0.1 mm.
 - b) Radial run out of surface A should not exceed 0.05 mm.
 - c) Radial run out of surface B and E should not exceed 0.2 mm.
5. Displacement of symmetrical plane of slot A, with respect to the axis of surface B should not exceed 0.15 mm.
6. Coating: Hard chrome plated, 18 to 100 microns thickness from ^{incorporated} with protective oil k-17 GOST 10877-76 as per INSTRUCTIONS 053.25289.00002 or varnish Ko-815 GOST 11066-74. Surfaces A and B should be protected from coating.

Dimensions and surface finish after coating.
7. On surface A centre hole A, 1.6 GOST-1484-74 is allowed.
8. Absence of coating is allowed on the surfaces V and K.
9. Equivalent material is 40Cr4 Mo3 to IS:5517.

DD 34	ICV	NOTE FOR EQUIVALENT MATERIAL ADDED
FEB 92	(A)	
DCI) No. & DATE	ISSUE	NATURE
AMENDMENTS		

6	765.771-81	765.771-81
9	765.825-71	765.825-71

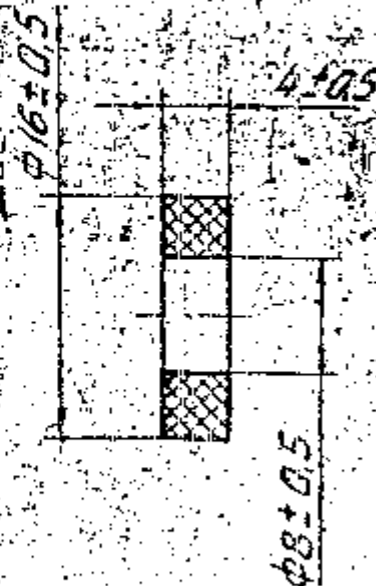
APPROVED
CHECKED

CONTROLLERATE
OF
INSPECTION
(ICV)

765-17-486		400 of 503	
ROD		WEIGHT	SCALE
38XC GOST 4543-71		0.07	1:1
		SHT	SHTS

304

765-17-492



0537-10V 30-1-97	EQ. MATERIAL ADDED (4/96 N.D.F.A)	ISSUE A	AMENDMENT
00381-10V 10-1-97	P.S. CAT. PART NO. ADDED DESCRIPTION WAS "OIL SEAL"	DATE OCT 93	

- 1) The specified weight for finished part is $0.37 \pm_{0.01}^{0.02} \text{ g/cm}^3$
- 2) The oil seal should be soaked in graphite oil CK a 2/6-ГЗ GOST 3333-80 as per instructions 053-25289.0000 before installation.

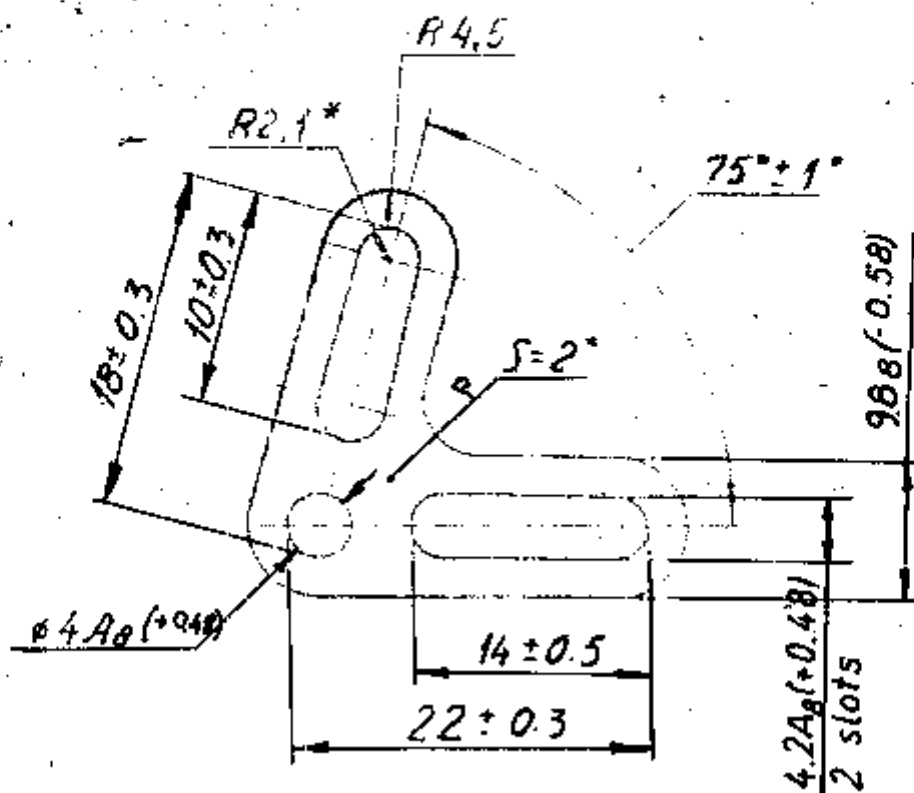
X175
311

- 3) Other requirements are as per GOST 288-72.
- ② FELT Gde3, EXTRA FIRM 890/3W TO BS: 4060

APPROVED	M. VASO	765-17-492/B	LV2/RCV- ①	
CHECKED	M. N. She: (a)		5330-017229	
CONTROLLERATE OF INSPECTION (HCV)		SEAL PLAIN ①	WEIGHT	SCALE
			0.0017	2:1
		FELT TC GOCT 288-72	SHT	5-18

765-17-533

00589-ICV	①	EQ. MATERIAL ADDED.
5-11-96	Gr-m	(5/96 N OF A)
DECID NO.	ISSUE	NATURE
DATE		
AMENDMENTS		



- 1) Alternate material is steel 08 Kn and 10 Kn GOST 1552-74
- 2) Stamping draft not exceeding 0.2 mm is allowed.
- 3) *Dimensions are given for reference.
- 4) Coating:- Zinc-plated, 9 microns thick, chromated.
Remove Hydrogen embrittlement.

① EQ. MATERIAL :- SHEET Gde DD TO IS: 513-86.

APPROVED	M. VASU	765-17-533	319 of 342
CHECKED			
CONTROLLERATE OF INSPECTION (ICV)		LINK	WEIGHT SCALE
			0.005 21
		SHEET X/K B2 GOST 19904-74 5-II Г 10 GOST 16523-70	INT SHTS

Technical drawing of a mechanical part with the following dimensions and labels:

- Top left corner: $R3,5$
- Top right corner: 4holes. $\phi 3,5 + 0,15$
- Left side hole: $\phi 15 + 0,43$
- Top horizontal distance: 8,5
- Top vertical distance: 17
- Right side vertical distance: 24
- Bottom horizontal distance: 12
- Bottom vertical distance: 8,5
- Bottom horizontal distance: 17
- Bottom horizontal distance: 24

③ 3. EQUIVALENT MATERIAL IS JSS 5640 OR B15 OR B10 TO IS:2712

1. Perform dimensions without deviations with accuracy $\pm 0,5$ mm.
2. Deviation of centres of holes should not exceed 0,1 mm for $\phi 3,5$; 0,25 mm for $\phi 15$ from their true position.

01041-101 1980 15-7-07	(A)	DS CAT NO ADDED
DECL NO DATE	ISSUE	NATURE OF AMENDMENT

 M. VASU

عہدہ کے لئے منتخب ہوئے۔

A

DS CAT NO: LV2/ICVS 5330-366528

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

GASKET

Резонанс по Н 1.0 ГОСТ-451-80

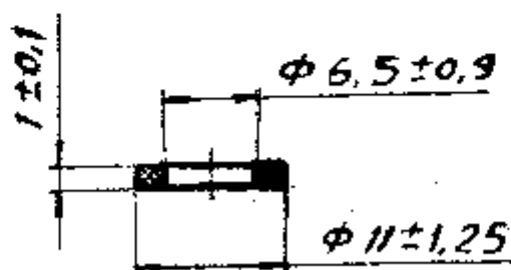
WEIGHT SCALE

0.0007 1:1

SHT SHTS

91-96-59L

All over,

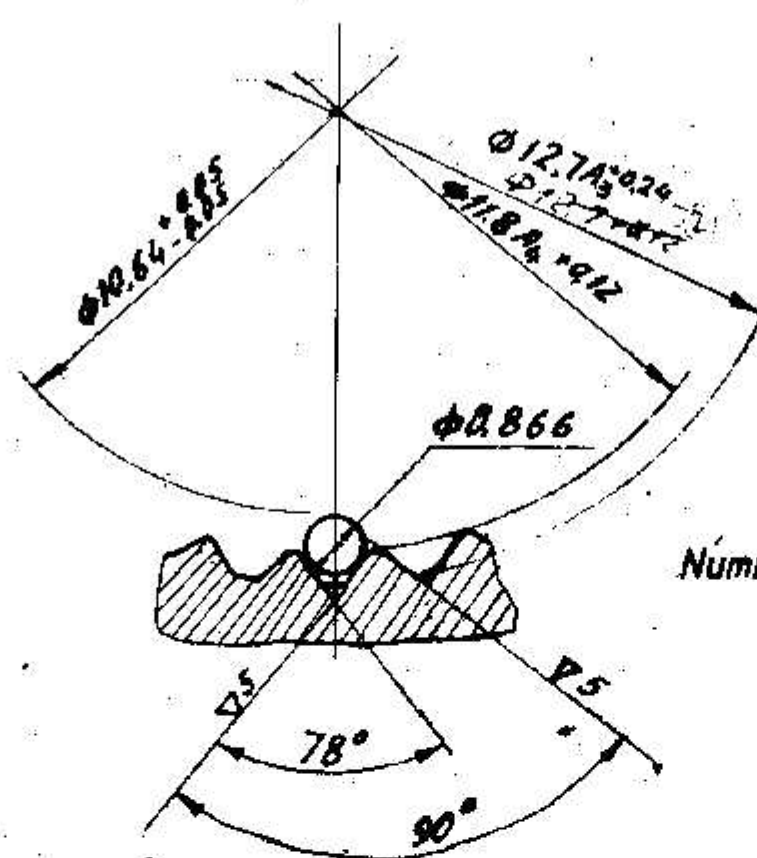
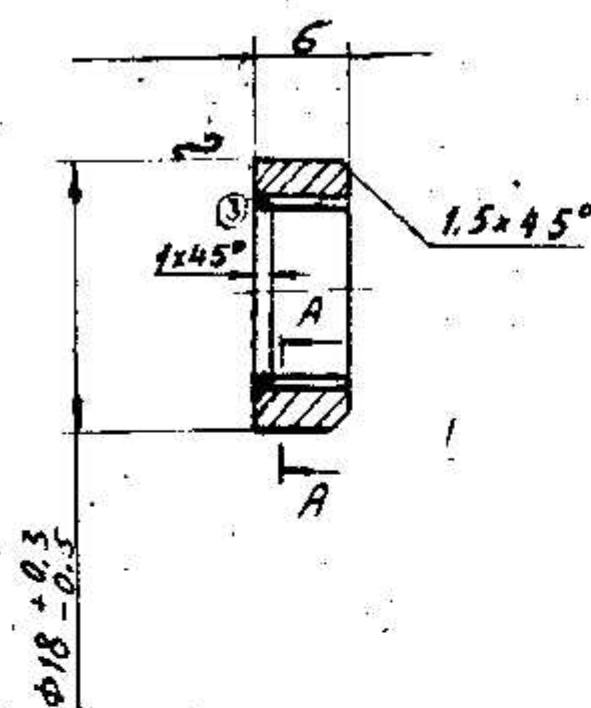


(A) EQ MATERIAL - GRADE Q/A TO IS : 2112-71

00757-104	(A)	EQ MATERIAL IS ADDED IN THE DRAWING
VR 1-2000	Cur	
DCU NO DATE	ISSUE	NATURE OF AMENDMENTS

APPROVED	M. VASU	765-96-16	323 of 342
CHECKED	H.M. Shinde		WEIGHT SCALE
CONTROLLERATE OF INSPECTION (IC V)	GASKET		0.001 2:1
		SHT	SHTS
		Rubberised asbestos fabric non 60 TOCT 481-80	

A-A
M10-1



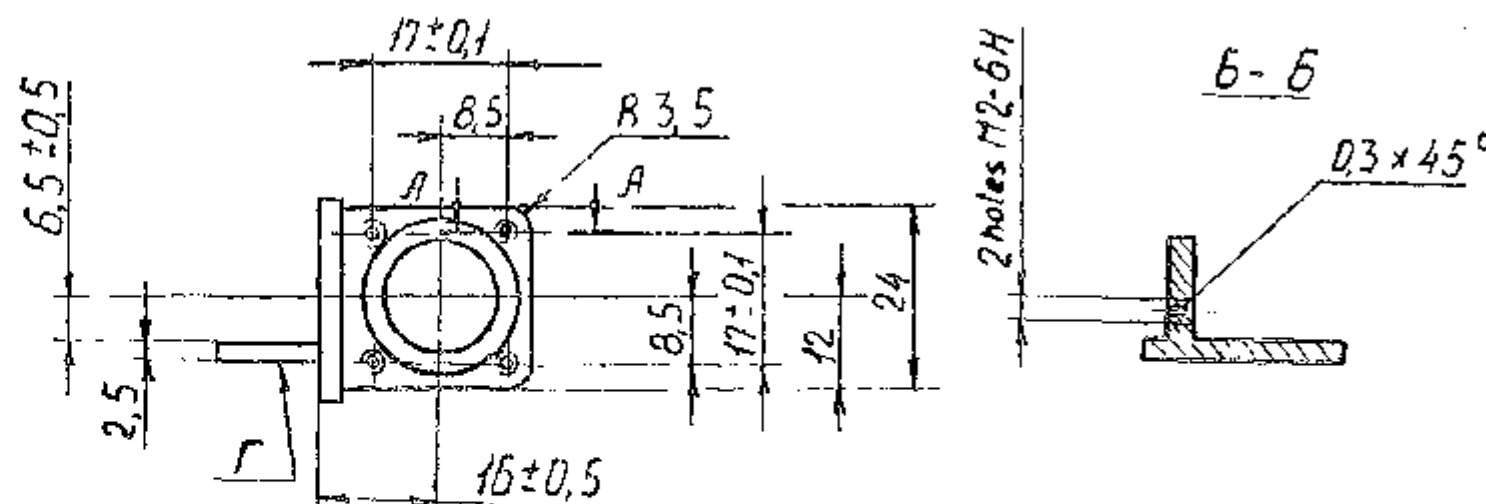
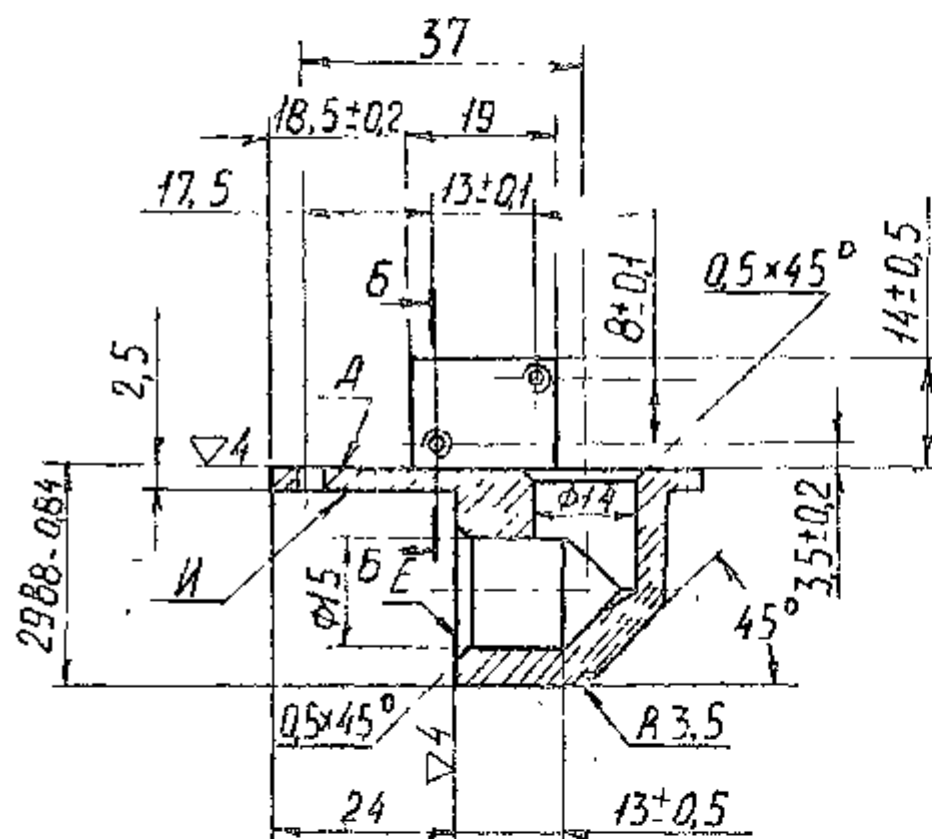
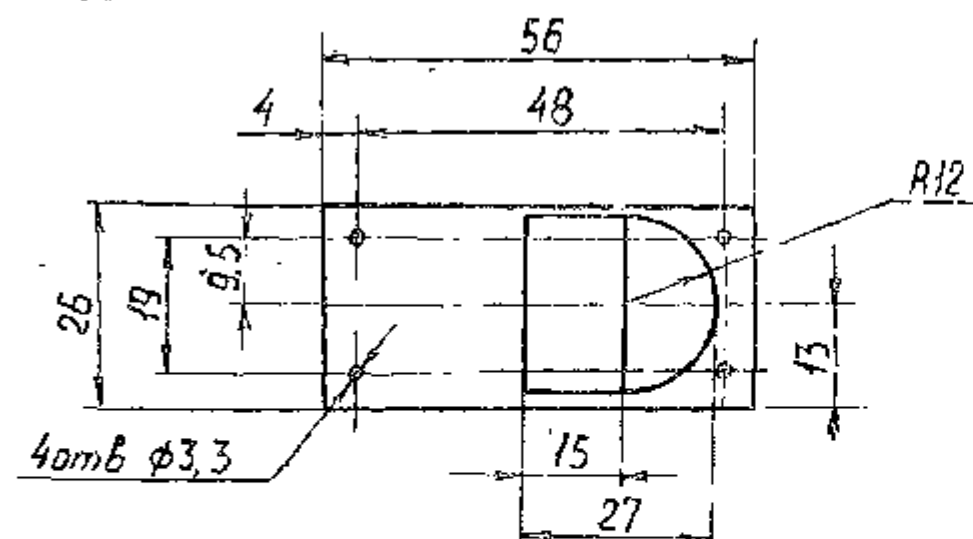
Number of splines 31.

1. Blunt sharp edges.
2. Provide dimensions without deviations as per accuracy class 8, OST 1010.
3. Alternate material is Cm 3 cn, GOST 380-71 and steel 10, 15, 25, GOST 1050-74, and steel 15F and 20F GOST 4543-71.

- (A) EQ. MATL: 1. STEEL BAR C10, C20, C30 Mn 75 TO IS: 2073
(B) 2(a) CLASS 2 (20C8) TO IS: 2004-91.
(b) C 20 OR C 25 Mn 75 TO IS: 2073-79.

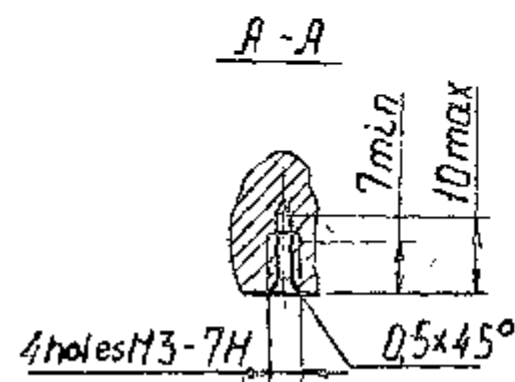
00852 -ICV N-41 31.1.2001	(B)	EQ. MATERIAL ADDED.
00769-ICV YR 03.2001 DC (1) NO DATE	(A)	EQ. MATERIAL ADDED.
ISSUE	NATURE OF AMENDMENTS	

APPROVED	M. VASU	765-96-23	324 of 342
CHECKED	H. M. S.		
CONTROLLERATE OF INSPECTION (ICV)	BUSHING	WEIGHT	SCALE
		0.0012	2:1
	steel 20 GOST 1050-74	SHT	SHTS
			1:4



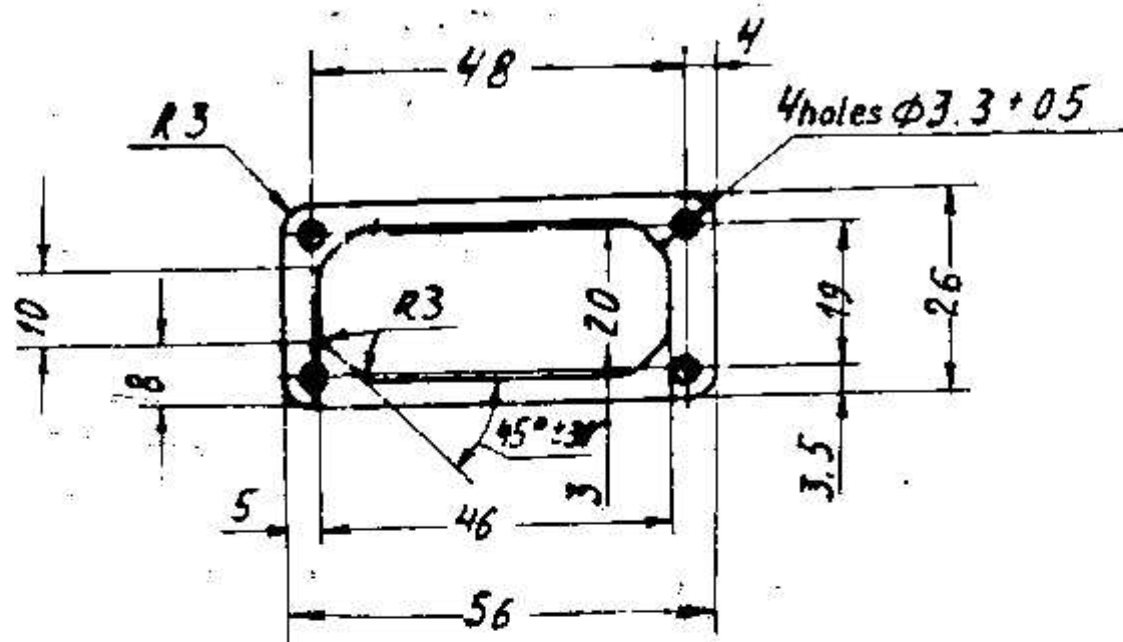
1. Blunt sharp edges.
2. Displacement of hole centres from true position should not exceed 0.2 mm.
3. Provide dimensions without deviations as per accuracy class 7, OST 1010.
4. Alternate material are A16 and AK4 GOST 4784-74
5. Coating: Anodically oxidized, chromated or chemically parkerized blue, chromated.
6. Apply primer П-03, GOST 9109-81 all over, except holes jaw Г and surfaces А and Е and paint with enamel Пб-223, dark grey, GOST 14923-78 or enamel МЛ-12Н, grey, GOST 9754-76 and enamel МЛ-165, silver, GOST 12034-77.
7. Steps with in the limits of tolerance are allowed on surface U.
8. Partial paint coating is allowed on surface E

Ⓐ EQ. MATERIAL :- AL. ALLOY Gde. 2285, CONDITION 'WP' TO IS: 617.



90603-15V	Ⓐ	EQ. MATERIAL ADDED.
21-4-97	Grm	(2/97 N OF A)
DC (I) NO. & DATE	ISSUE	NATURE
AMENDMENTS		

APPROVED	BY	765-96-73	325 of 342
CHIEF	H.M. Sh...		
CONTROLLERATE OF INSPECTION (REV)		COVER	0.035 1:1
		AI GOST 4784-74	114

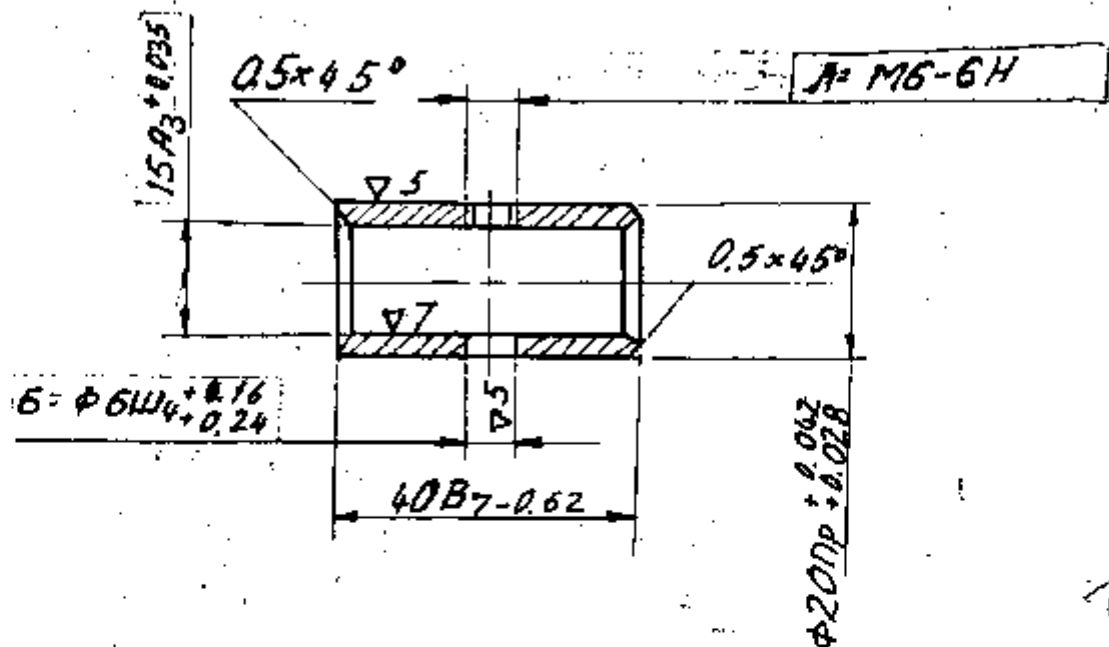


Thickness 0.5 ± 0.05

1. Deviation of centres of holes from their true position should not exceed 0.2 mm.
2. Perform dimensions without deviations with accuracy ± 0.5 mm.

0042HCV FEB 84		① D.S.CAT PART No. ADDED	
ISSUE		AMENDMENT	
APPROVED	M. V. 91	765-96-74	
CHECKED	M. V. 91	LV2/REV ① 5330.009541	
CONTROLLERATE OF INSPECTION (ICV)		GASKET	
		Electric insulation board Grade 3B Foct 2824-75	
		WEIGHT SCALE 0.0007 7:1 SMT SMTS	

▽3 Unless otherwise specified.



1. Blunt sharp edges.
2. Machine to dimensions given in in assembly.
3. Eccentricity of holes A and B should not exceed 0.1 mm.

314g332

266

x162

765-96-115

328 of 342

H.M. Sh

CONTROLLERATE
OF
INSPECTION

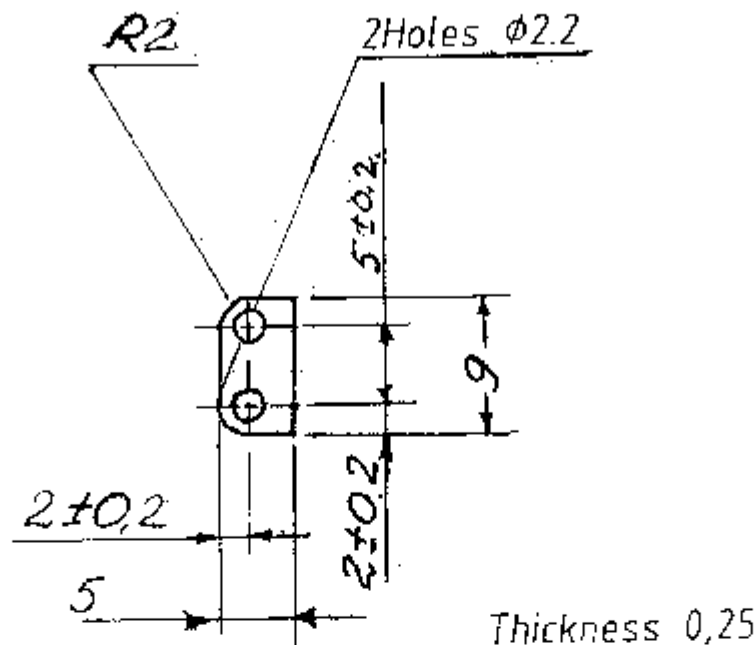
BUSHING

0.048 1:1

Бр АХ9-4 ГОСТ-18175-78

765-96-121

2



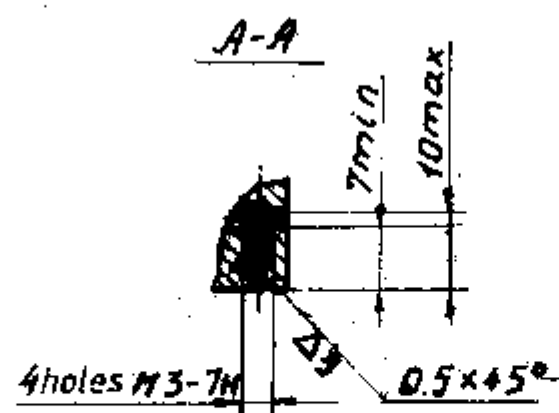
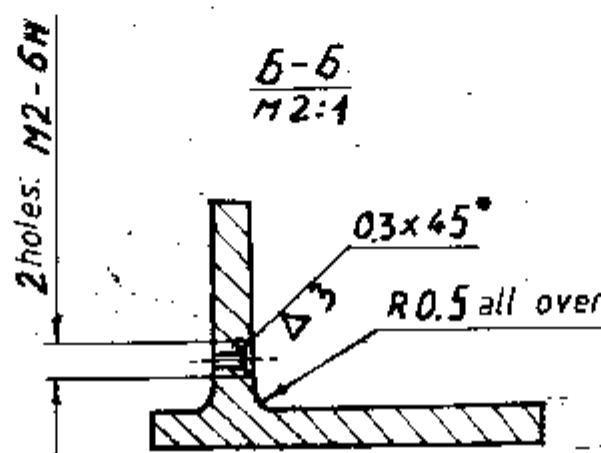
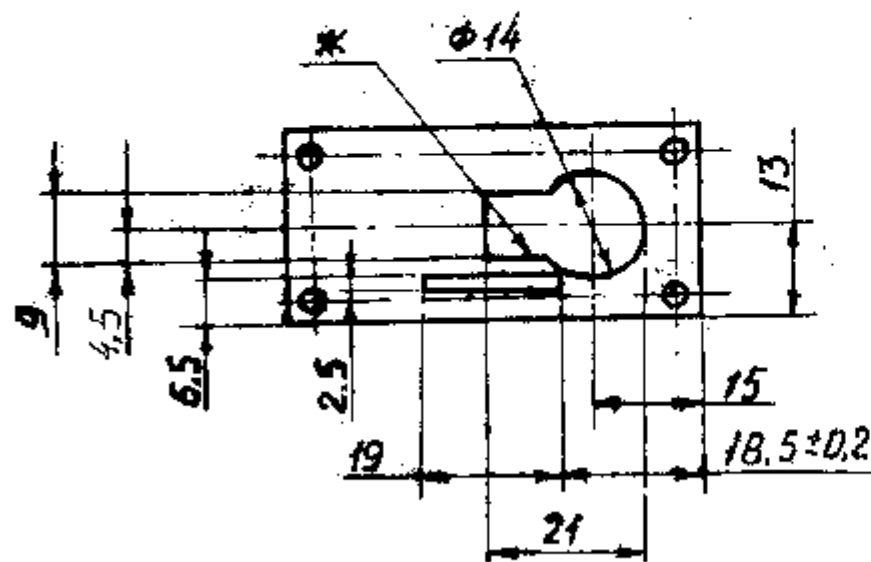
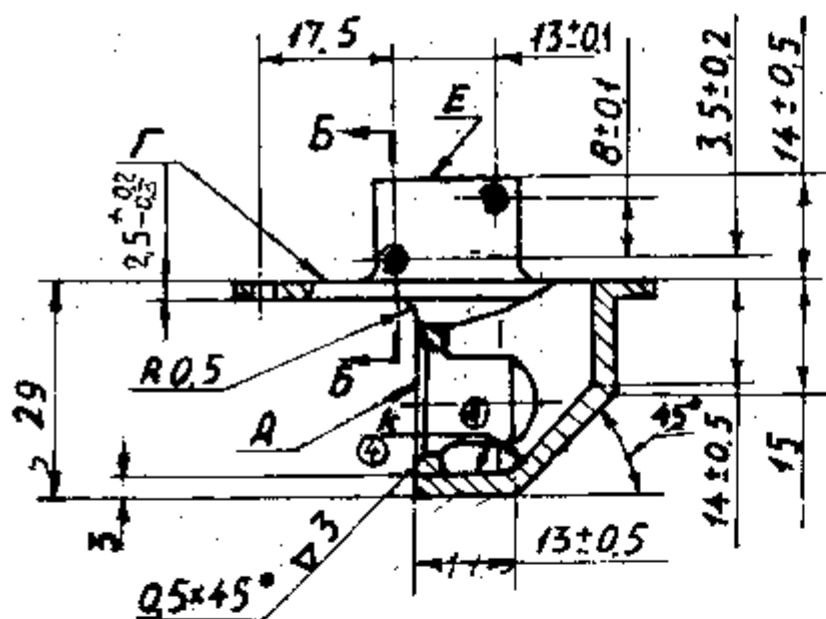
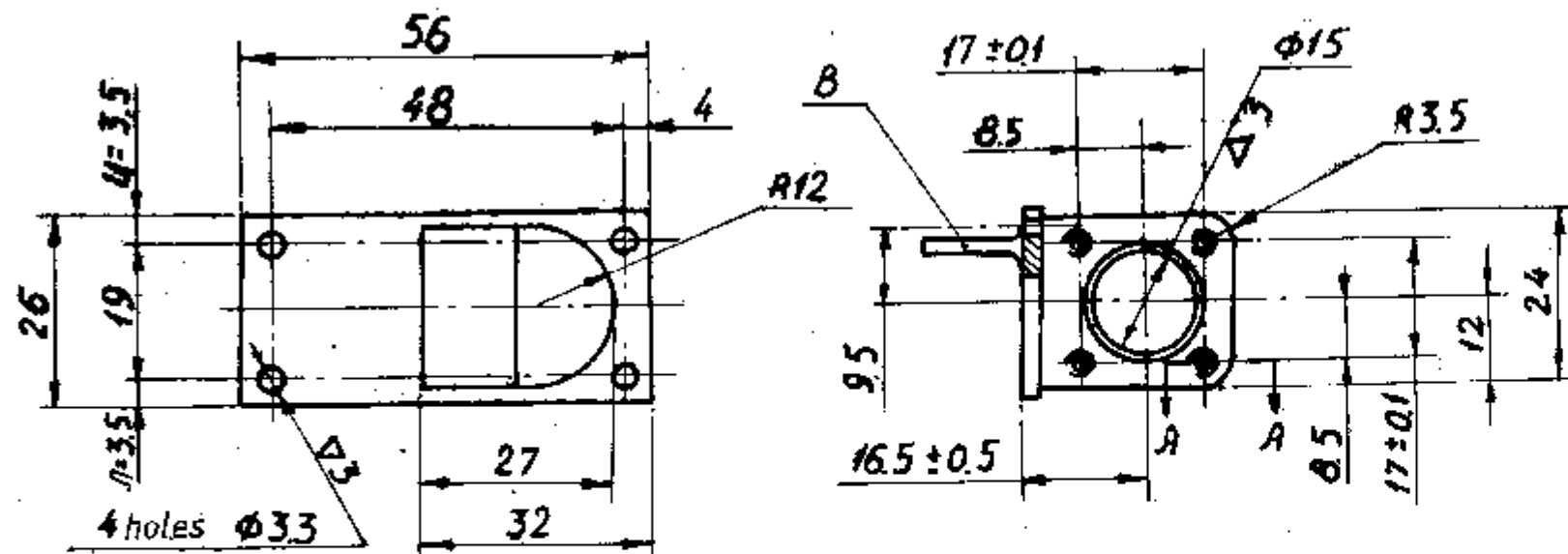
1, Blunt sharp edges.

2, Perform dimensions without deviations with accuracy class 7, OST 1010.

Ⓐ EQ. MATERIAL - CB 101 TO BS:2870-68 W(H) CONDITION

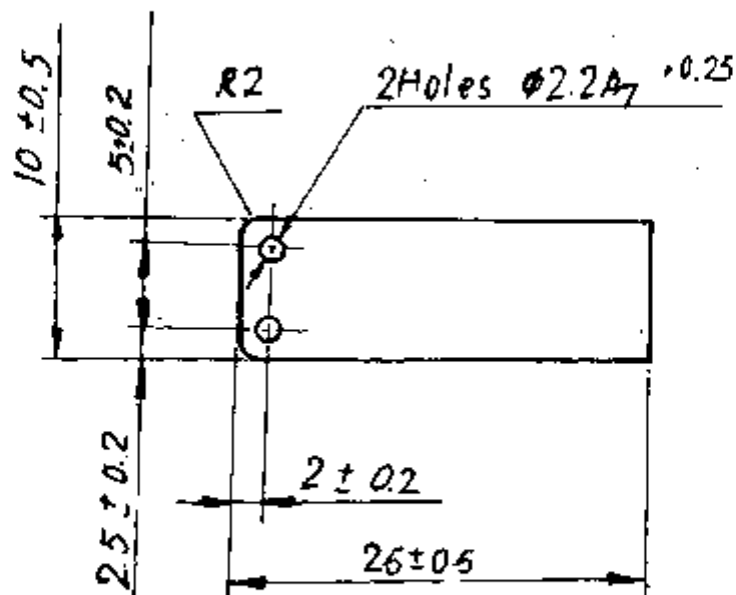
00757-12V V.R. 0008 17-1-2000	Ⓐ Am	EQ. MATERIAL IS ADDED IN THE DRAWING
DCU/NO DATE	ISSUE	NATURE OF AMENDMENTS

APPROVED	M. YASU	765-96-121
CHECKED	DSKUMAR	
CONTROLLERATE OF INSPECTION (ICV)		GASKET
		BAND 0.25-BPB 2T FOCT 1789-70
		WEIGHT 0.00006 SCALE 2:1 SHT 10 SHTS 371 of 413



1. Unspecified casting radii should not exceed 1,5 mm.
2. Pattern drafts should not exceed 1° towards the body increase beyond tolerance.
3. Blunt sharp edges.
4. Provide dimensions without deviations as per accuracy class 7, OST 1010.
5. Displacement of axes of holes from true position should not exceed 0,2 mm.
6. Other requirements for casting are as per Technical requirements TT A4-370.
7. Alternate material is A4 9. GOST 2685-75.
8. Coating: Anodically oxidized, chromated or chemical parkerized, blue.
9. Apply primer ФЛ-03 Ж, GOST 9109-81, all over, except holes of jaw B and surfaces Г and А, paint with enamel МЛ-12, grey GOST 9754-76, and enamel МЛ-165 (former МЛ-25) silver, GOST 12034-77.
10. Knock-out traces of depth upto 0,5 mm are allowed on surfaces Г and Е and on surfaces Г atleast 2mm from edges.
11. Drafts not exceeding 3° may be provided on surfaces of hole Ж.
12. Dimension А may be provided instead of dimension U.
13. Bulging of surface Г should not exceed 0,25 mm.
14. Partial paint coating is allowed on surface А.
15. Knurling to a height not exceeding 0,2 mm is allowed on surface К.

APPROVED	M. VASU	765-96-143	
CHECKED	И. М. Ш. - 143	COVER	
CONTROLLERATE OF INSPECTION (IC V)		WEIGHT	SCALE
		0.035	1:1
		SHT	SHTS
		10	368 20 413
		A4 2 ГОСТ 2685-75	



Thickness 0.25

1. Blunt sharp edges

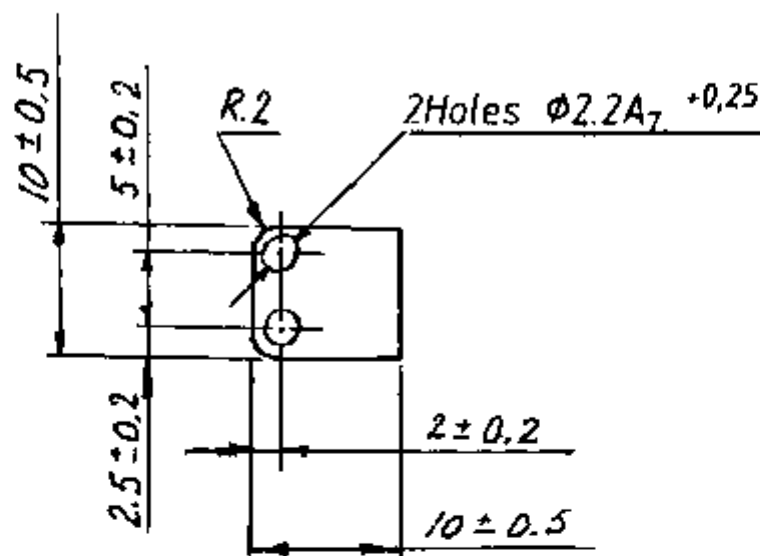
2. Hardness as per Vicker is 350

(A) EQ. MATERIAL:- CB 101 TO B9: 2870-68 W(H) CONDITION

00757-101	(A)	EQ. MATERIAL IS ADDED IN THE DRAWING
17-1-2006	Grm	
DEC 10 NO	ISSUE	NATURE OF AMENDMENTS
DATE		

317 of 332

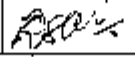
APPROVED	M. VASU	765-96-151	330 of 342
CHECKED			
CONTROLLERATE OF INSPECTION (ICV)		PLATE	WEIGHT SCALE
		BAND 0.25 - EpE2.T	0.0004 - 2 : 1
		FOCT 1789-78	



Thickness 0.25

1. Blunt sharp edges.
 2. Hardness as per Vicker test is 350 min.
- (A) EQ MATERIAL: - CB 101 TO BS: 2870-68 W(H) CONDITION

30757- ICV v Rom 17 1-2000	(A) Gm	EQ MATERIAL IS ADDED IN THE DRAWING
DATE	ISSUE	NATURE OF AMENDMENT

APPROVED  M. VASU
CHECKED  DSKUMAR

765-96-152

CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

PLATE

STRIP 0.25-EPG 2.7
FOCT 1789-70

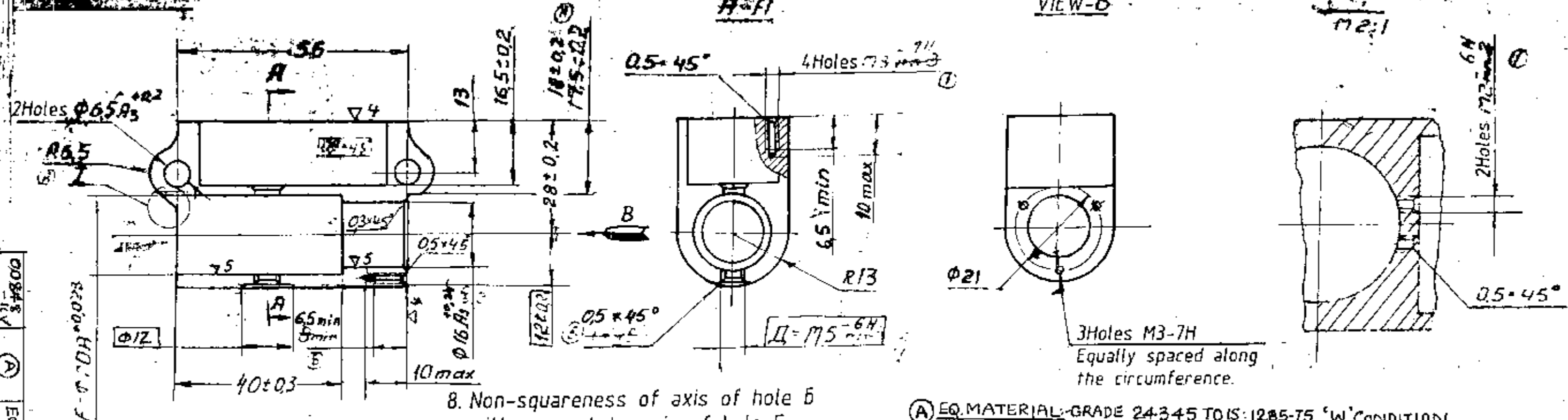
WEIGHT SCALE

0.00013 2:1

SHT 1 SHTS 1

VIEW-B

A-1



8. Non-squareness of axis of hole B with respect to axis of hole E should not exceed 0.1 mm.

9. Alternate material is AK4 GOST4784-74.

10. Perform heat treatment upto condition T.

11. Coating: Anodically oxidized, chromated.

1. EQ. MATERIAL GRADE 24345 TO IS: 1285-75 'W' CONDITION
Blunt, sharp edges

1. Blunt sharp edges.

2. Provide dimensions without deviations as per accuracy class 7, OST 1010.

3. Displacement of axes of holes from true position should not exceed 0.2 mm.

4. Unspecified radii should not exceed R5.

5. Machine to dimensions given in in assembly.

6. Displacement of axis of hole B with respect to axis of hole E should not exceed 0.1 mm.

7. Eccentricity of holes 5 and 11 should not exceed 0.1 mm
(Qualified tolerance). 321 g 3

321 g 332

765-96-166

332 of 342

CONTROLLERATE

BODY

INSPECTION
(ICV)

Д1 ГОСТ 4784-74

32

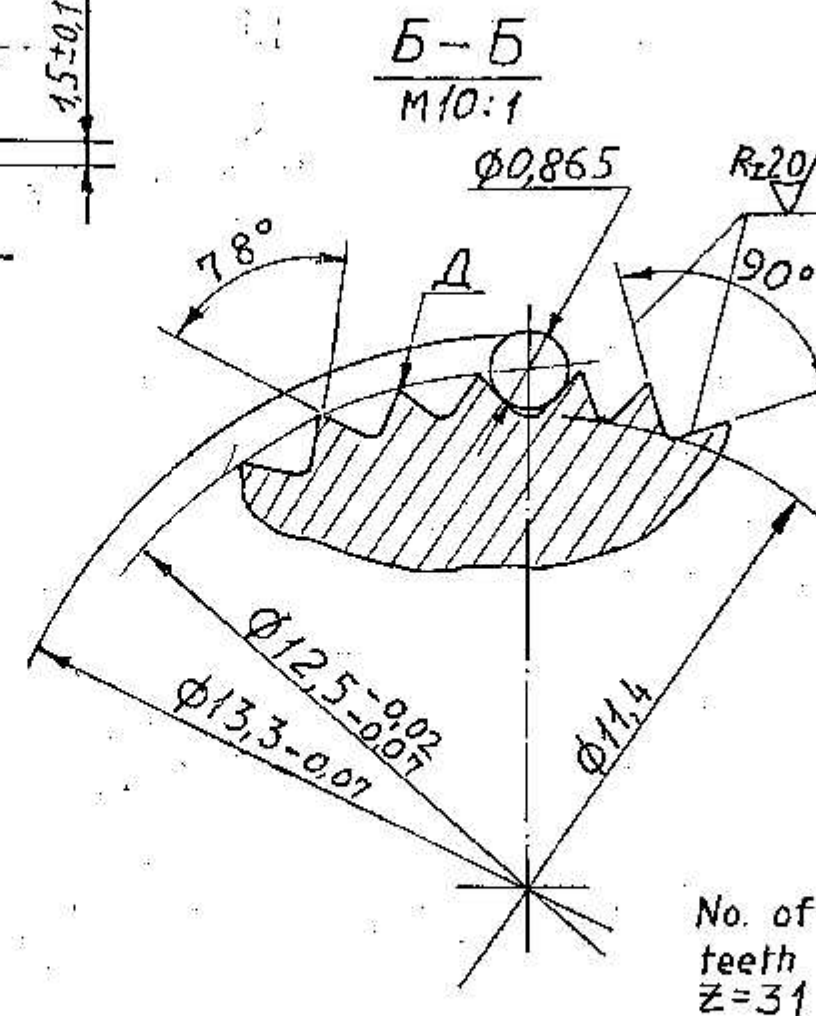
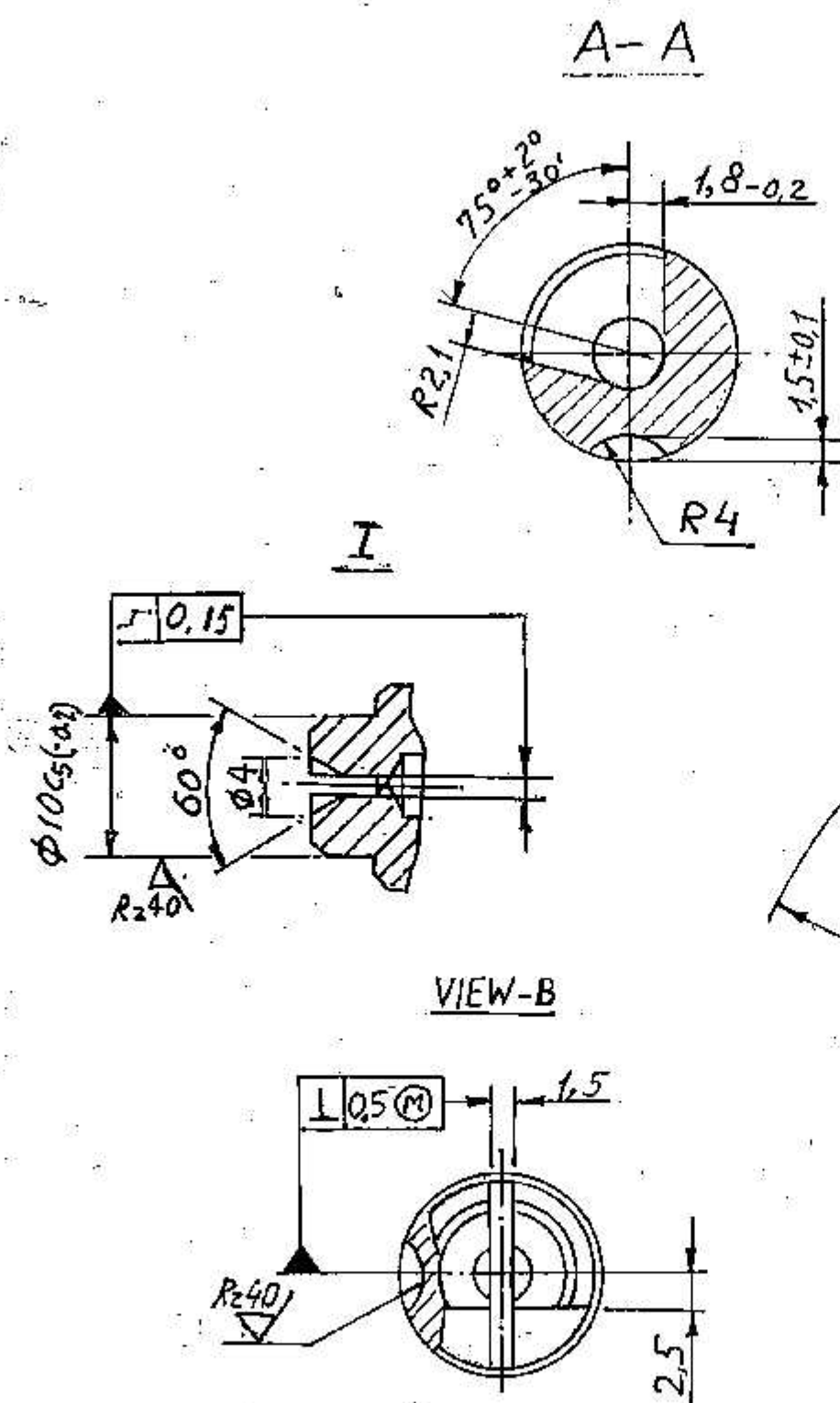
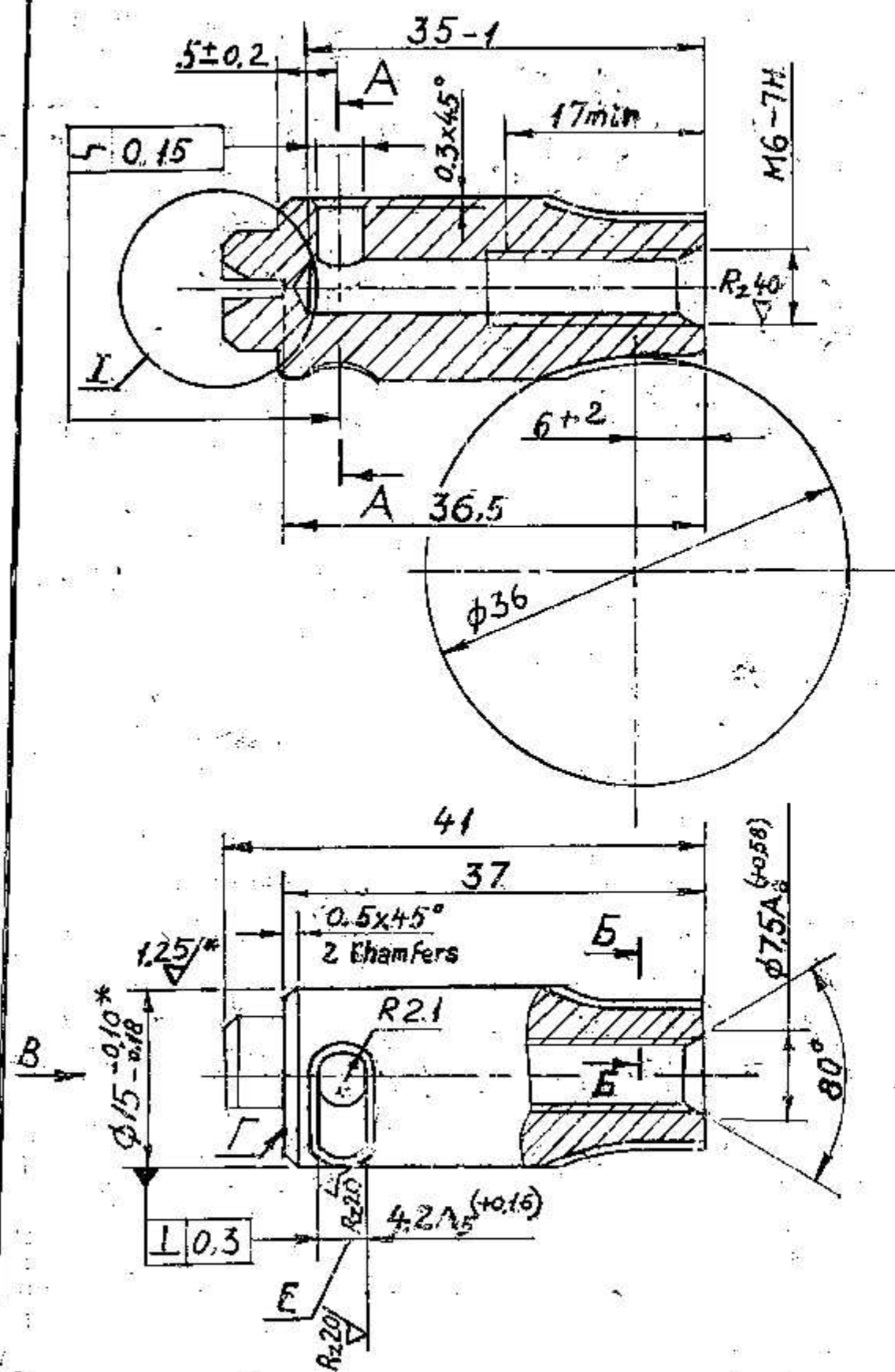
00848 -REV	(A)	EQ MATERIAL ADDED
11-12-01	Comm	
DECLD DATE	ISSUE	NATURE OF AMENDMENTS

R8 for 4
corners

$$\delta = \phi \delta W_4 = \frac{0.24}{0.16}$$

VIEW-XX ⑦
721

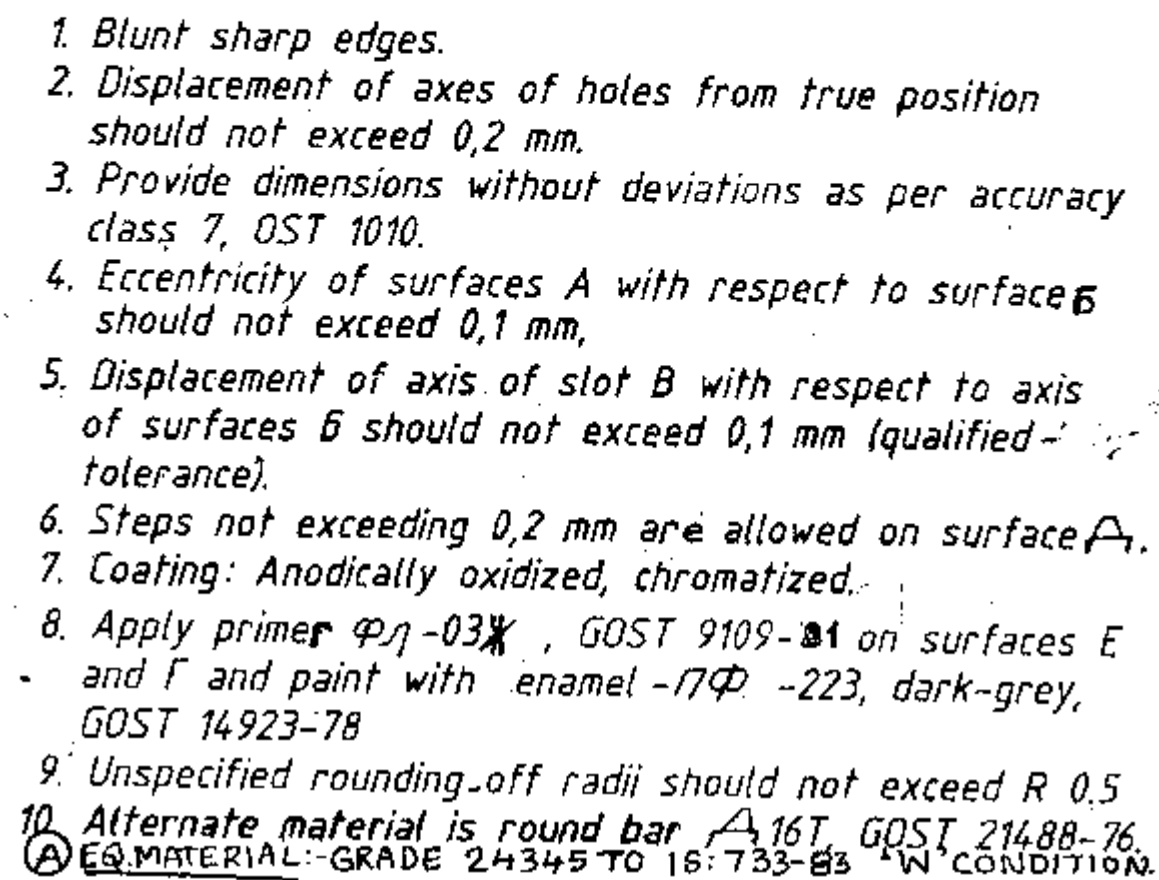
I
m. 2:1



1. HB 302 to 255 (φ3.5 to 3.8).
2. Coating: Chrome-plated, hard, 18 microns thick, white. Protect thread from coating. Surface of slot E may be free from coating.
3. A, through hole after centre-drilling φ2 mm is allowed.
4. Unspecified limit deviations of dimensions are as follows:
for holes -as per A₇,
for shafts -as per B₇ and
for others -as per CM₇.
5. Tool cuts within tolerance limits are allowed on surface F.
6. Steps, not exceeding 0.15 mm are allowed on surface D over change to radius (Qualified tolerance).
7. * Dimension and roughness of surface are after coating.
(A) EQ. MATERIAL - 40 CY1 TO IS: 4367-67

00852	(A)	EQ. MATERIAL ADDED.
31-1-2001	DATE	ISSUE
DATE	ISSUE	NATURE OF AMENDMENTS

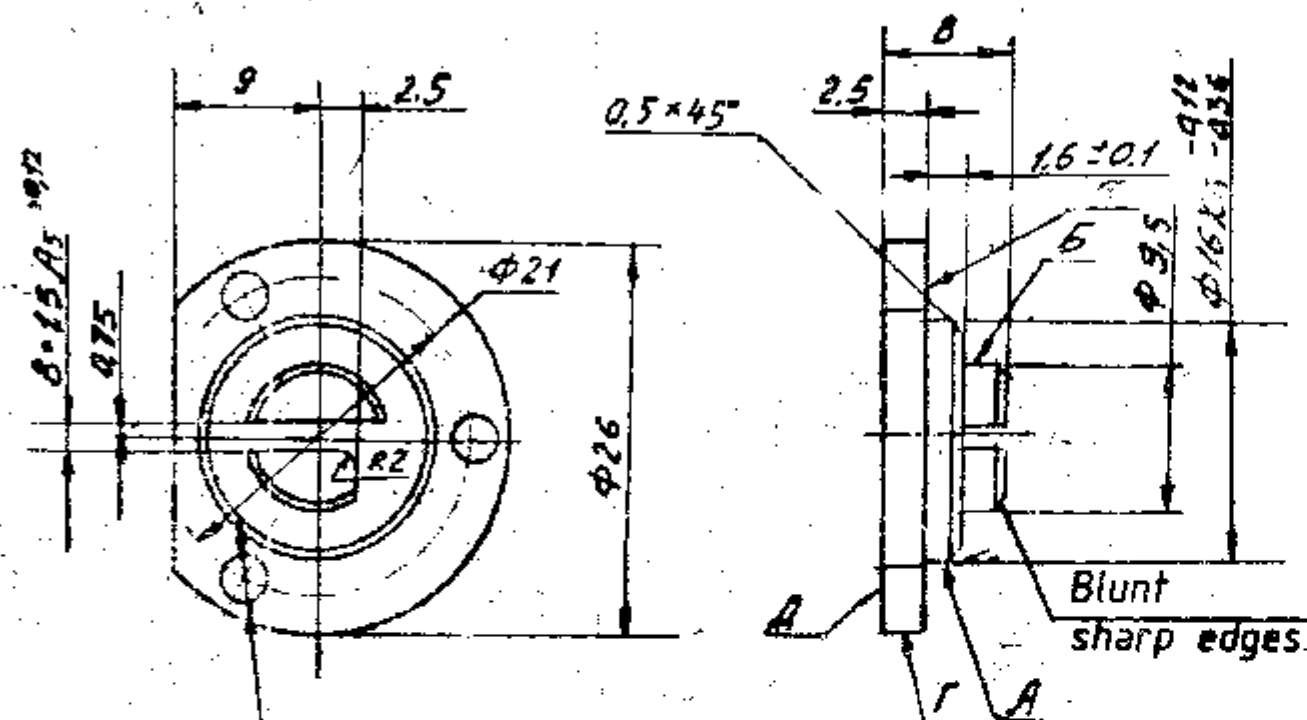
APPROVED	M. V. S. S. S.	765-96-167	WEIGHT	SCALE
CHECKED	D. S. K. S. S.	SPRING LOADED PLUNGER	0.056	2:1
CONTROLLERATE OF INSPECTION (ICV)	45 X OCT 4543-71	SHT	SHTS	375 OF 413
		10		10



00848-1CV N.Y.S. JUL 1 1964 JUL 1 1964 JUL 1 1964	(A)	EQ. MATERIAL ADDED
ISSUE	NATURE OF AMENDMENT	

APPROVED	NO VAS	765-96-168		
CHECKED	M.M. S. C. L. C.		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)		RETAINER	0.005	2:1
		AIT FOOT 4784-74		114

911-96-591



3 Holes $\phi 3.2A_7 \pm 0.16$
Equally spaced along
the circumference.

Alternate
M1:1

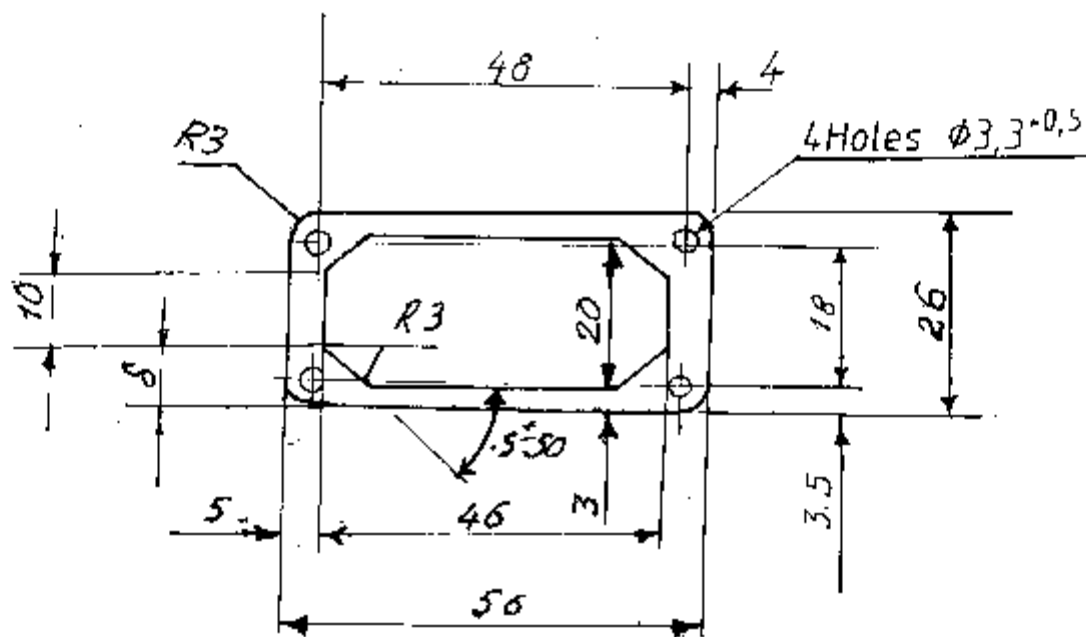


00848-10	(B)	EQ. MATERIAL ADDED
N. 451		
11.1.2001		
00735-10	(A)	EQ. MATERIAL ADDED IN THE DRAWING
V. R. P. 0002		
23.9.99		
DCU/NO	ISSUE	NATURE OF AMENDMENT
DATE:		

1. Displacement of axes of holes from true position should not exceed 0.25 mm.
2. Provide dimensions without deviations as per accuracy class 7, OST 1010.
3. Eccentricity of surfaces A with respect to surfaces B should not exceed 0.1 mm.
4. Displacement of slot axis B with respect to the part axis should not exceed 0.1 mm.
5. Pattern drafts should not exceed 1° towards the increase of the body.
6. Other requirements for casting are as per Technical requirements TTA/370.
7. Alternate material is A/10B GOST 2685-75.
8. Coating: Anodically oxidized, chromated or chemically parkerized blue, chromated.
9. Apply primer $\phi N-03X$ GOST 9109-76 onto surfaces C and D and paint with grey enamel MN-12, GOST 9754-76 and silver enamel MN-165, GOST 12034-77.
10. Partial paint coating on surface E is allowed.

- (A) EQ. MATERIAL (i) Gy: 4600 IS: 617-75 OR,
(ii) Gy: 4600A IS: 617-75
(B) (iii) Gy: 4600A TO IS: 617-94.

APPROVED	N. VAS	765-96-176	
CHECKED	P. M. SL. L. L.		
CONTROLLERATE OF INSPECTION (ICV)		RETAINER	
		HEIGHT	SCALE
		0.005	2:1
		SHT	SHTS
		A/12 GOST 2685-75	

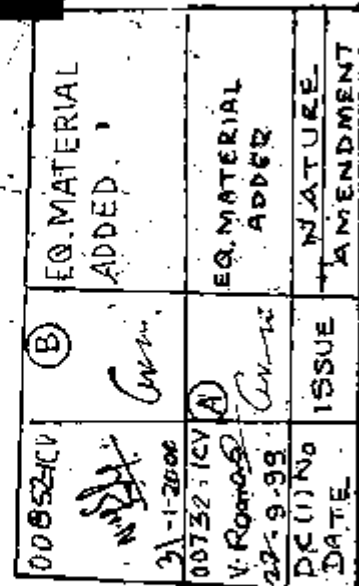


Thickness 0.3 ± 0.05

1. Deviation of centres of holes from their true position should not exceed 0.2 mm.
2. Perform dimensions without deviations with accuracy ± 0.5 mm.
3. Alternate material is packing board of grade 6, GOST 9347-74.

APPROVED	M. YASU	765-96-195		
CHECKED	DSKUMAR			
CONTROLLERATE OF INSPECTION (ICV)	GASKET		WEIGHT	SCALE
			0.0006	1.1
			SHT	SHTS
	ELECTRICAL INSULATION BOARD GRADE 6 GOST 2824-75		10	378 of 413

R285



- | | | |
|---------------|---------------|---------------|
| 110, 111, 112 | 110, 111, 112 | 110, 111, 112 |
|---------------|---------------|---------------|

APPROVED	M VASU	765-96-350		337 of 342	
ENTERED	NM 2-106	SCREW		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (REV)				0.0035	2:1
		ROUNDBAR 9-5 FOCT 74-17-75 45 B FOCT 1051-73		SHT	SHTS

Wires and plug connectors are conventionally not shown.

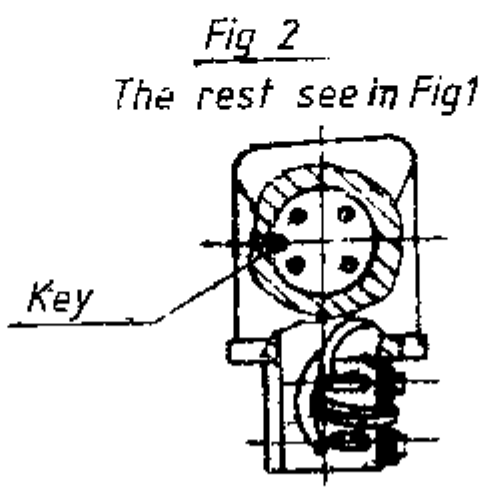
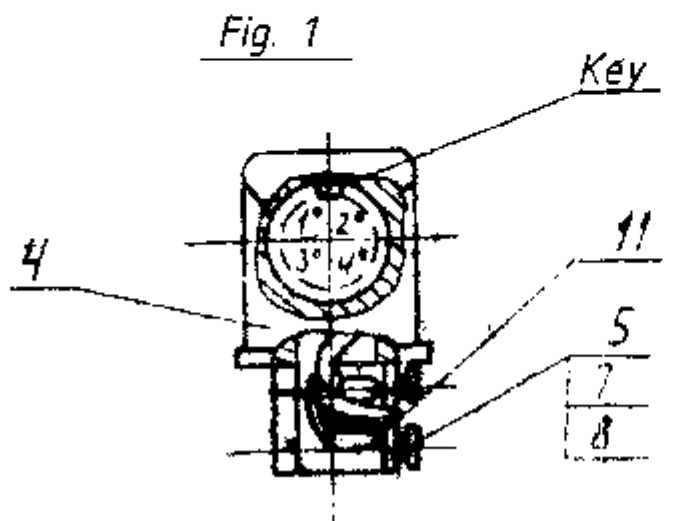
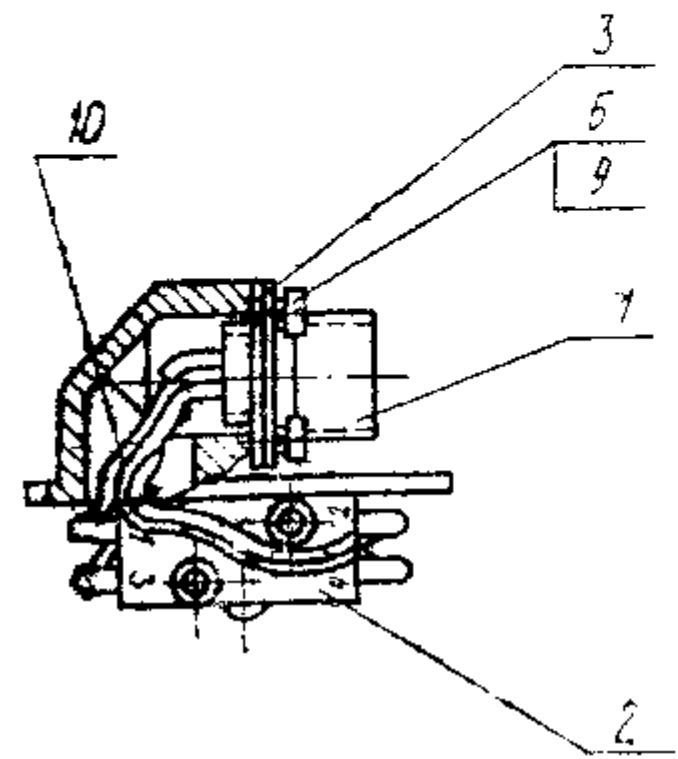
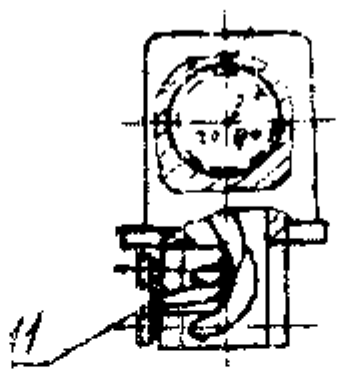


Fig. 2
The rest see in Fig 1

Table for soldering conductors.

Micro-switch.	Plug connector.
1	1
2	2
3	3
4	4

Fig 1 Alternate.
Key

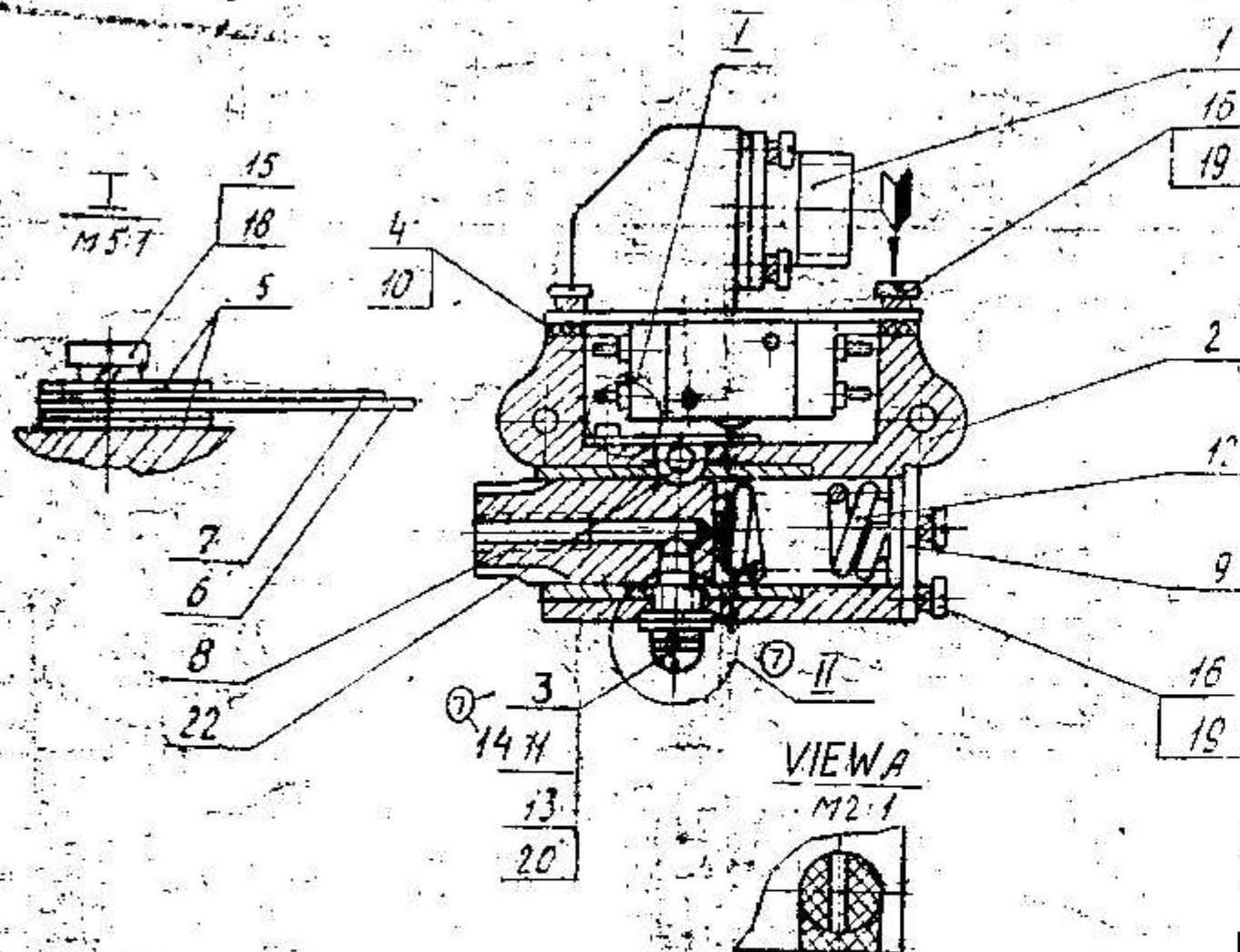


1. Termination of wires is as per P 700-88-TT2.
2. Braze using solder NOC 61, NP3, GOST 21931-76.
3. Slip PVC sleeves Ref. No. 13 over wire ends to micro-switch and sleeves Ref. No. 12 over wire ends to plug connector.
4. Secure sleeves with bakelite varnish of grade ABC-1, GOST 901-78.

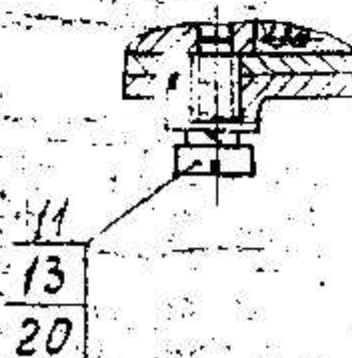
Designation	Fig. No.
765-96-c0143	1
-01	2

	Bakelite varnish of grade ABC-1, GOST 901-78		
13	Sleeve III TB-50-355-3.5, colourless GOST 19034-73. L=8	4	
12	Sleeve III TB-50-355-2.5, colourless GOST 19034-73. L=20	4	
7	Washer 2x1 01.019. or 2x1.02.019 GOST 11371-78.	2	
6	Screw M3.8h6hx8.48.016 GOST 17473-72 or M3.8h6hx8.66.016 GOST 1491-72.	4	
8	Washer 2T 65 F 05, GOST 6402-70.	2	
	Solder NP3 NOC-61 GOST 21931-76.		
2	Micro switch A-703 HO.360.011.	1	Commercial
14	PN 42/1	8	
11	Wire MFWB-0.35 mm ² TY 16-505.437-73 L=90	2	
10	Wire MFWB-0.35 mm ² TY 16-505.437-73 L=60	2	
9	Washer 3T65F 05 GOST 6402-70.	4	
5	Screw M2. 6gx18.48.016 GOST 17473-72 or M2. 6gx18.66.016 GOST 1491-72.	2	
1	Plug 2PM 14 B 44 1B1 FED.364.126TY	1	Commercial
4	765-96-73 or 765-96-143.	1	Cover
3	765-96-15	1	Gasket
REF. NO.	Designation.	Description	Qty. Remarks

765-96-c0143	
DESIGNER	SCALE
0.065	1:1
COVER	
123 of 413	



① II Alternate.



1. Place spring in such a way that its preliminary angle of twist is 120°.
2. Spring loaded plunger should rotate smoothly without jamming.
3. Place plate, Ref.No.6, in such a way that the ball in its depressed position does not deform it. Adjust with gaskets, Ref. No. 5.
4. If screws Ref, No. 15 project into cavity of bush, place a required quantity of gaskets, Ref.No.5 on plate, Ref.No.7.
5. While rotating the spring loaded plunger clockwise through angle 10 to 15°. Microswitch contacts 1 and 2 should be open and contacts 3 and 4 are closed. When the spring loaded plunger resets in its initial position. Microswitch contacts 1 and 2 should be closed and contacts 3 and 4 should be open. Adjust with gaskets Ref.Nos. 4 and 10.
6. Lubricant and foreign bodies on parts of limit switch are not allowed
If necessary, wash metal parts in hydrolysis alcohol.
7. After final assembly and adjustment of limit switch. screws of cover, Ref. No.1 and screw, Ref. No. 11, are coated with red enamel ПЧ-223, GOST 14923-78 as per view A.
8. Other requirements are as per 765-96-TT101.

22	Ball 5 V. 6 mmH, GOST 3722-60 and ETY 500-65;	1	Commercial
20	Washer 6T 65F 06. GOST 6402-70	1	
19	Washer 3T 65F 0.5 GOST 6402-70.	7	2 OFF.
18	Washer 2T 65F 05. GOST 6402-70.	2	
16	Screw M3.8h6hx8.48.016 GOST 17473-72 or M3.8h6hx8.66.016 GOST 1491-72.	7	2 OFF.
15	Screw M2.6gx6.48.016 GOST 17473-72.	2	
14	700-35-368 Screw	1	When 765-96-c5164 is used
13	700-40-153 Gasket	1	
12	700-38-1805 Spring	1	
11	765-96-350 Screw	1	When 765-96-c5155 is used.
10	765-96-195 Gasket	1	1 MAX.
9	765-96-168 or 765-96-176 Retainer	1	
8	765-96-167 Spring loaded plunger.	1	
7	765-96-152 Plate	1	
6	765-96-151 Plate	1	
5	765-96-121 Gasket	1	1 MIN. 5 MAX.
4	765-96-74 Gasket	1	3 MAX.
3	765-96-16 Gasket	7	When 765-96-c5164 is used
2	765-96-c5164 or 765-96-c5155 Body	1	
1	765-96-c5143 Cover	1	

REF. No.	Designations	Description	Qty	Remarks
----------	--------------	-------------	-----	---------

APPROVED	765-96-c5163	126
CHECKED	8 MSREDDY	342
CONTROLLERATE OF INSPECTION (IC V)	LIMIT SWITCH (Rotary type)	WEIGHT 0.26 SCALE 1:1
		SHT 1 SHTS

PD 421-1CV	①	PART LIST REF. NO. 4, D.S. CAT. PART No. LV2/RCV 5330-009541 ADDED
FEB 94	ISSUE	AMENDMENT