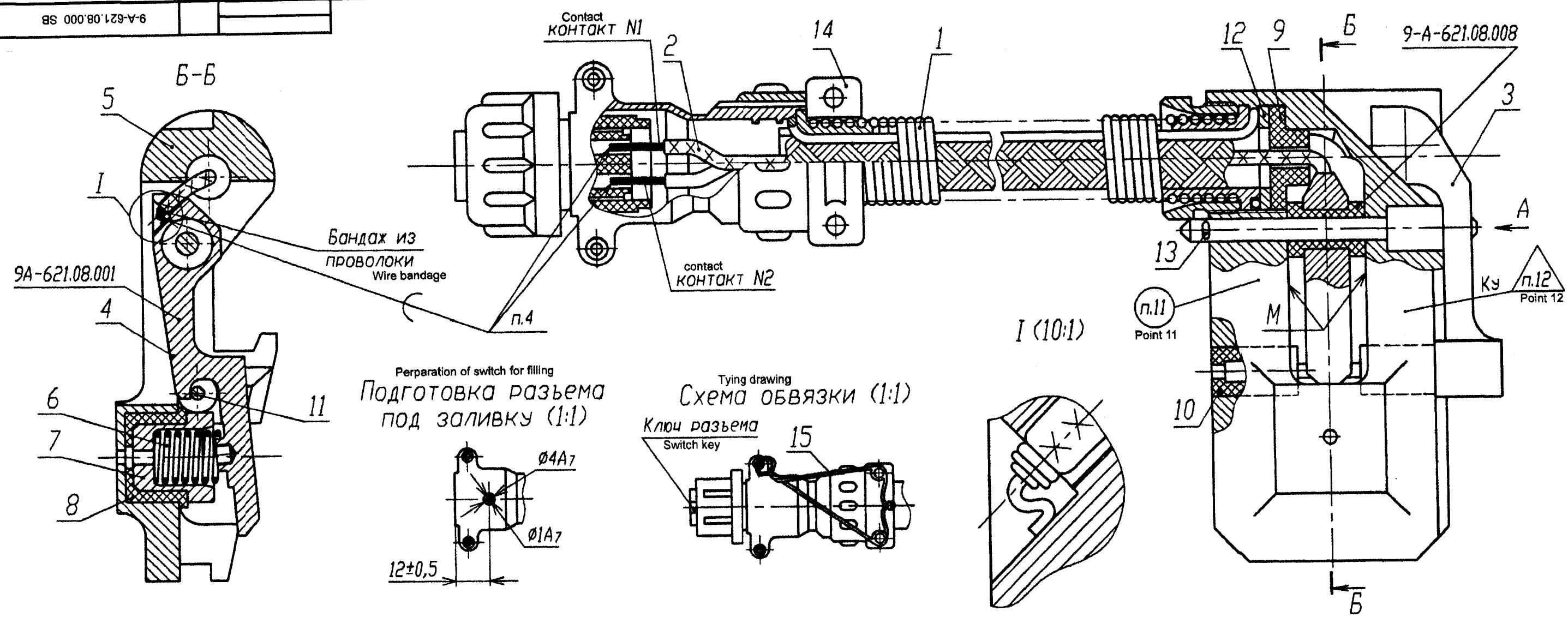


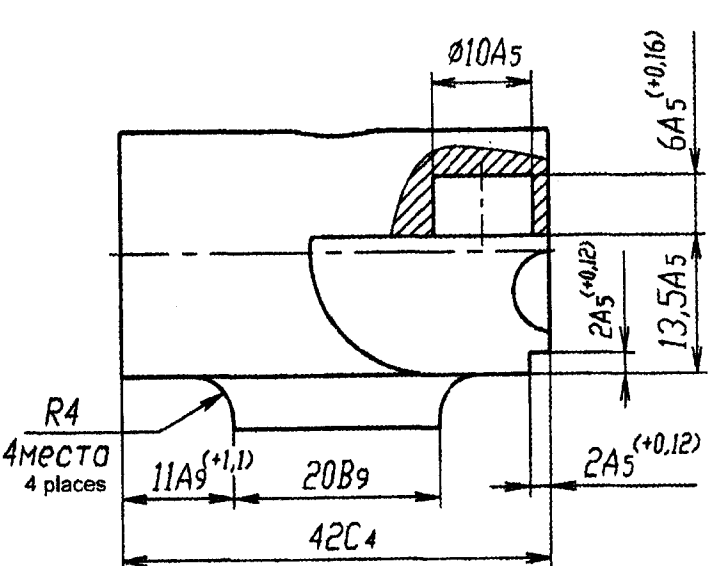
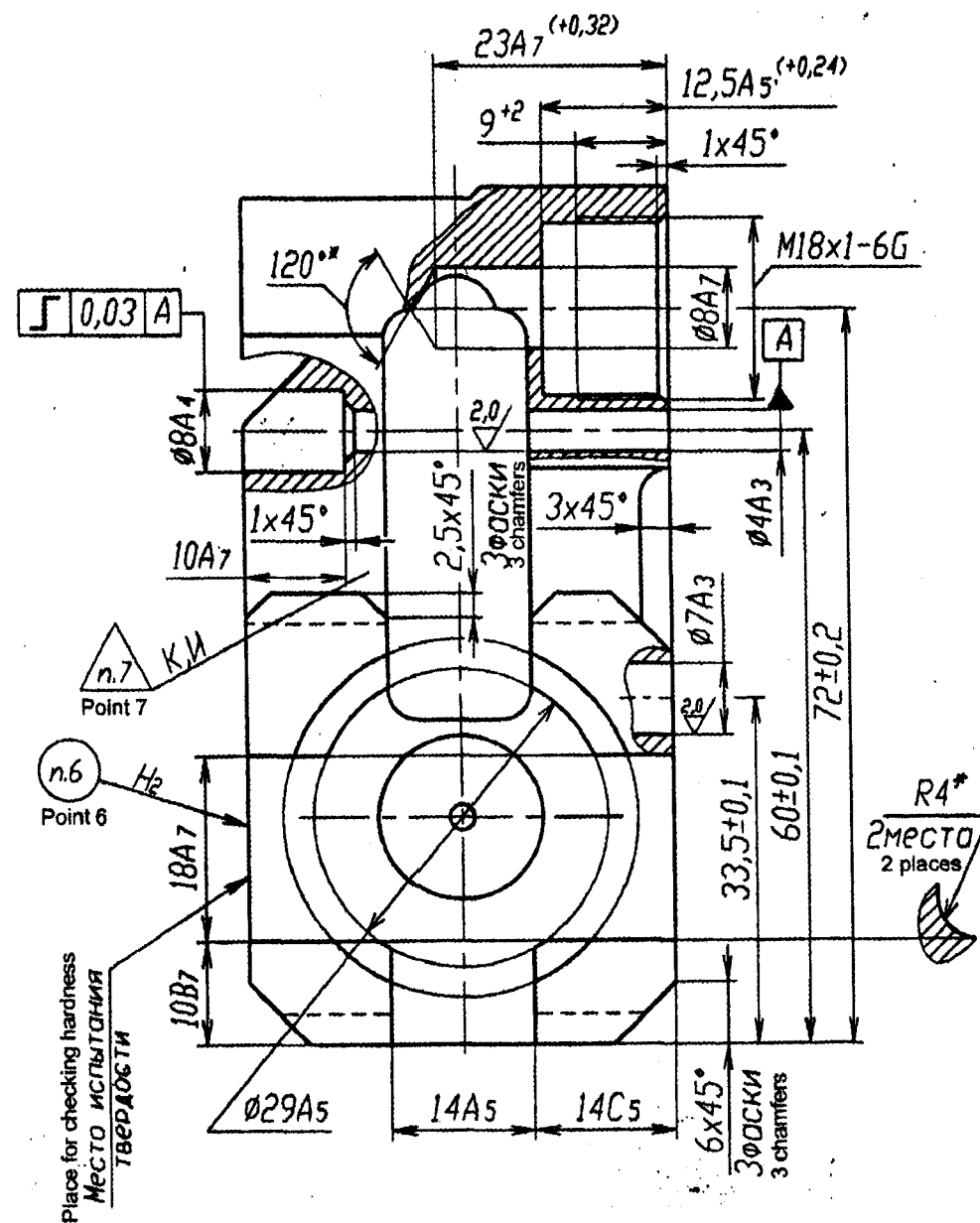
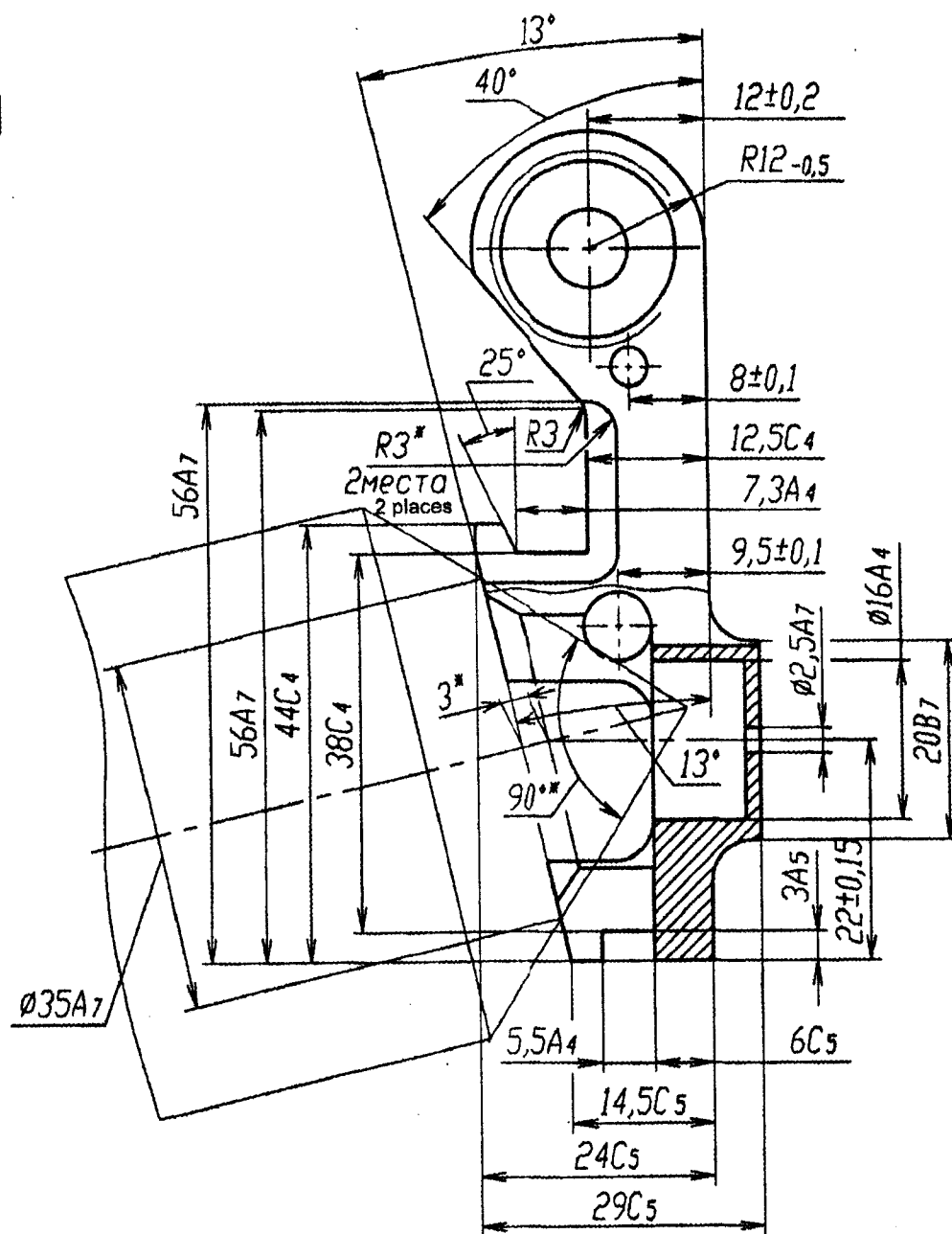
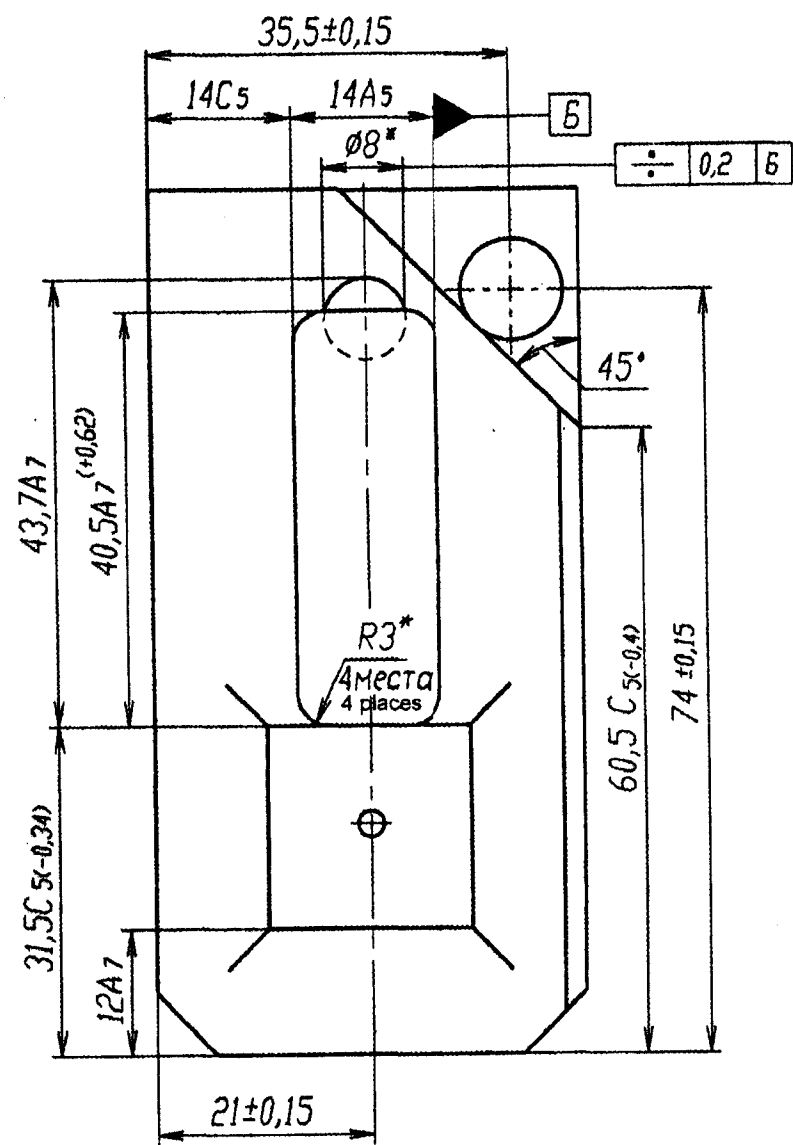
| Format | Zone | Position | Designation | Nomenclature | Qty. | Remarks | |
|---------------------------------|------|----------|-------------------|-----------------------------------|------|---------|--------|
| | | | | | | | |
| First use | | | | | | | |
| | | | | <u>Documents</u> | | | |
| A2 | | | 9-A-621.08.000 SB | Assembly drawing <i>b-2. 1/9</i> | | | |
| Reference No. | | | | | | | |
| | | | | <u>Assembly units</u> | | | |
| A4 | | 1 | 9-A-621.08.010 | Bunch of wires | 1 | | |
| A4 | | 2 | 9-A-621.08.020 | Rope | 1 | | |
| A4 | | 3 | 9-A-621.08.030 | Lock | 1 | | |
| A4 | | 4 | 9-A-621.08.040 | Contact | 1 | | |
| <u>Components</u> | | | | | | | |
| A2 | | 5 | 9-A-621.08.002 | Contact body <i>b-2. 1/9</i> | 1 | | |
| A3 | | 6 | 9-A-621.08.004 | Contact spring <i>b-2. 5/5</i> | 2 | | |
| A4 | | 7 | 9-A-621.08.005 | Cup <i>b-2. 5/2</i> | 1 | | |
| A4 | | 8 | 9-A-621.08.006 | Insulation sleeve <i>b-2. 5/2</i> | 1 | | |
| A4 | | 9 | 9-A-621.08.009 | Gasket <i>b-2. 5/2</i> | 1 | | |
| A4 | | 10 | 9-A-621.08.011 | Minor bush <i>b-2. 5/2</i> | 2 | | |
| A4 | | 11 | 9-A-621.08.012 | Pin <i>b-2. 5/2</i> | 1 | | |
| A4 | | 12 | 9-A-621.08.016 | Washer <i>b-2. 6/2</i> | 1 | | |
| <u>Standard articles</u> | | | | | | | |
| | | 13 | | Cotter pin 1.6x12.026 | 1 | | |
| | | | | GOST 397-79 | | | |
| Alternate Inv. No. | | | | | | | |
| Dupl. Inv. No. | | | | | | | |
| Sign and Date | | | | | | | |
| 9-A-621.08.000 | | | | | | | |
| Amend. Sheet Doc. No. Sign Date | | | | | | | |
| Developed by | | | | | | | |
| Checked by | | | | | | | |
| Head of Q.C.D | | | | | | | |
| Approved by | | | | | | | |
| Orig. Inv. No. Sign and Date | | | | | | | |
| | | | | Contactor | Type | Sheet | Sheets |
| | | | | | 02 | 1 | 2 |



First remarks
Refer. No.
Duplicate Inv. No. Sign and Date
Inv. No.

1. Set component pos. 10 with epoxy compound Э5-1 OST B84-167-77. Apply varnish ЭП-730 brown GOST 20824-81 on projection of external surface of comp. Pos. 10.
2. Place assembly unit pos. 2 in assembly unit pos. 4 up to stop in wire bandage.
3. Technical requirements for electric wiring as per GOST 23588-79.
4. Solder contact no. 1 of socket pos. 14 to assembly unit pos. 4 by wire of assembly unit pos. 2. Tin plate contact 9-A-621.08.001 at the place of soldering with solder KP.80 pos. 40 GOST 21931-76 with flux Ф.Д.Ф.С. OST 4G0.033.200. Solder contact no. 2 of socket pos. 14 to wire БПВЛ1.0 of assembly unit pos. 1. Carry out soldering with wire kp.8.0 pos. 40 GOST 21931-76 as per OST 4G0.01.0.016.
5. Set switch socket plug pos. 14 in position indicated in drawing.
6. Assembly unit pos. 4 under the action of spring pos. 6 should energetically return to its initial position. Rubbing of comp. 9-A-621.08.008 on plane M is not permissible.
7. Fill the internal strips of socket pos. 14 by sealant VIKSINT - U-1-18 OST 38.03238-81.
8. Fix the nut socket plug pos. 14 by wire pos. 15 as per drawing.
9. Insulation resistance between contact no. 1 and body should not be less than 20 MΩ in standard climatic condition. Measure the resistance by megameter with voltage 500V.
10. Testing of insulation is not permissible. Carry out checking between contact no. 1 and body with A.C 500V (amplitude) with frequency 50hz for 1 min.
11. Mark complete number of article with letter size PO - 3 GOST 2930-62. Fill the inscriptions with enamel ПФ-115 white GOST 6465-76.
12. Stamp.

| | | | | | | | | |
|--------------------------|-------|----------|------|------|--------------------------------|----------------|----------|-------|
| | | | | | 9-A-621.08.000 SB | | | |
| Amend | Sheet | Doc. No. | Sign | Date | Contractor Assembly drawing | Type | Weight | Scale |
| Developed by | | | | | | О ₂ | 0.78 | 2:1 |
| Checked by Technician | | | | | | Sheet | Sheets 1 | |
| Head of QCD | | | | | | | | |
| Approved by | | | | | | | | |



1. HRSe 38.5 ... 45.5.
 2. * Dimensions are ensured by tool.
 3. Internal angle R ≈ 0.6 mm.
 4. Blunt edges R ≈ 0.6 mm.
 5. Coating : Chem. Phos. Accel. Cr/adhesive БФ-4, GOST 12172-74 with black dye grade A GOST 9307-78, 1 layer.
 6. Mark with letter size PO - 3 GOST 2930-62.
 7. Stamp.
- Substitute material : Steel 40Kh GOST 4543-71.

| |
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| First remarks |
| Refer. No. |
| Sign and Date |
| Alternate Inv. No. Duplicate Inv. No. Sign and Date |
| Inv. No. |

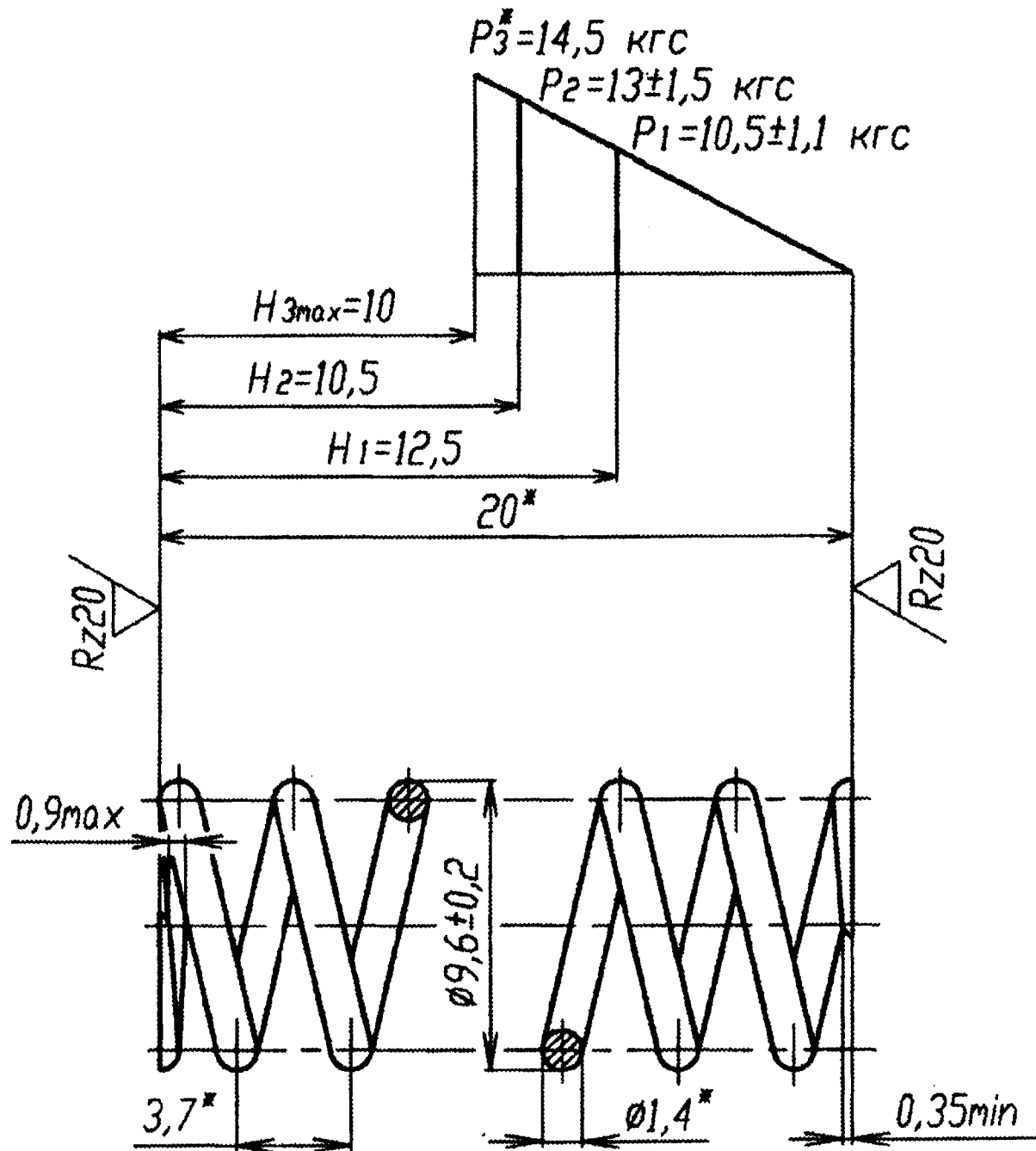
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| | | | | | 9-A-621.08.002 | | | |
| Amend | Sheet | Doc. No. | Sign | Date | Contractor body | Type | Weight | Scale |
| Developed by | Checked by | Technician | Head of bureau | Head of QCD | | Approved by | 0, | 0.25 |
| | | | | | | Sheet | Sheets 1 | |
| | | | | | | Steel 50A OST 3-98-80 | | |
| | | | | | | Format A2 | | |

9-A-621.08.004

First use

Reference No.

✓(✓)



1. $G^* = 8000 \text{ kgf/mm}^2$; $J_3^* = 138 \text{ kgf/mm}^2$
2. Tempering $240^\circ\text{-}260^\circ\text{C}$
3. Coiling direction- right.
4. $n = 5$
5. $n_1 = 7 \pm 0.25$
6. $D_g = 10 \text{ mm}$.
7. Roll over length of spring 188 mm^* .
8. Pre deformation time before contact of turns- 24 hours at temperature $80..100^\circ\text{C}$.
9. Coating Chem. phos. accel.Cr./ adhesive BF-4, GOST 9307-78, single coat.
11. Stamp K, И on batch tag.
12. Other technical requirements as per GOST 16118-70 for springs of II group of accuracy.

Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

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|---------------|-------|---------|------|------|---------------------------|----------------|--------|-------|
| | | | | | 9-A-621.08.004 | | | |
| Amend. | Sheet | Doc.No. | Sign | Date | Contact Spring | Type | Weight | Scale |
| Developed by | | | | | | O ₂ | 0.0015 | 5:1 |
| Checked by | | | | | | Sheet | Sheets | 1 |
| Head of Q.C.D | | | | | Wire V-1-1.4 GOST 9389-75 | | | |
| Approved by | | | | | | | | |

9-A-621.08.011

First use

Approved by shop
Reference No.

Approved KTONI

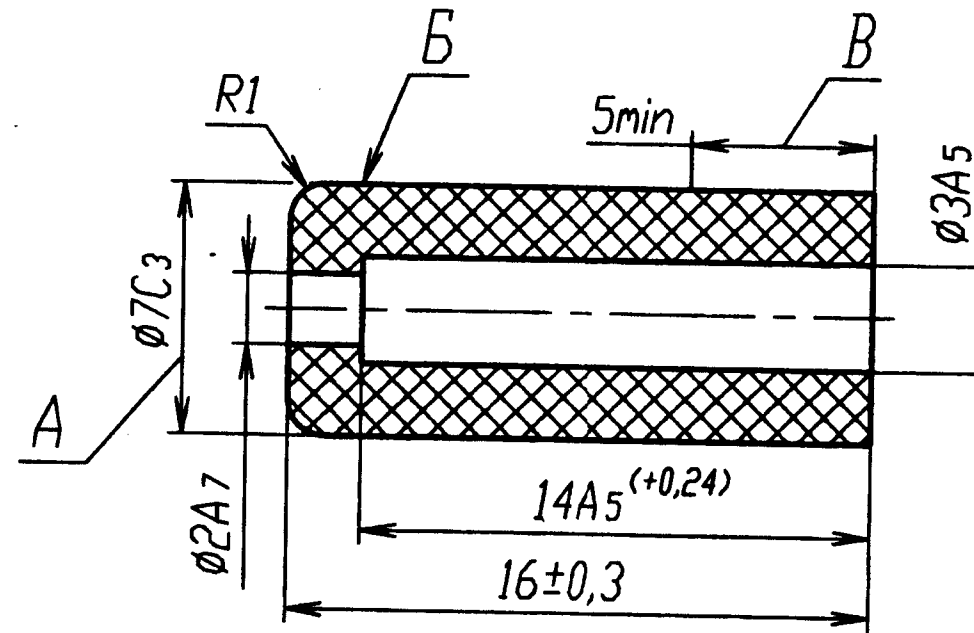
Sign and Date

Dupl. Inv. No.

Approved TOsb
Alternate Inv. No.

Sign and Date

Approved OGMet
Orig. Inv. No.



Fiber direction of band from
НАПРАВЛЕНИЕ ВОЛОКОН
ЛЕНТЫ ИЗ АГ-4С

1. Surface finish of formation surfaces of press mould $0.5\sqrt{}$.
2. Inner angles $R \sim 0.4$ mm.
3. Stamp K on batch tag.
4. Other technical requirements as per OST4.GO 005.051.
5. While pressing section B from internal side, reinforce with band, length 200-250mm, width 0.5..1.5 mm made of moulding material AG-4S GOST 20437-75.
6. Carry out machining of surface B at dimension A above 7 mm but not more than 7.2 mm, obtained by pressing. Surface finish $Rz40\sqrt{}$.

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9-A-621.08.011

Minor bush

| Type | Weight | Scale |
|----------------|--------|-------|
| O ₂ | 0.005 | 5:1 |

Sheet Sheets 1

Moulding material DSV-4-0
GOST 17478-95

Copied by

Format A4

| First use | | Format | Zone | Position | Designation | Nomenclature | Qty. | Remarks | |
|--------------------|----|--------|----------|----------|-------------------|--|------|---------|--------|
| Reference No. | | | | | | <u>Documents</u> | | | |
| | A3 | | | | 9-A-621.08.010 SB | Assembly drawing <i>b-2, 5/5</i> | | | |
| Reference No. | | | | | | <u>Components</u> | | | |
| | A3 | 1 | | | 9-A-621.08.013 | End cap <i>b-2, 5/5</i> | 2 | | |
| | A4 | 2 | | | 9-A-621.08.014 | Hose <i>b-2, 3/2</i> | 1 | | |
| | A4 | 3 | | | 9-A-621.08.015 | Threaded bush <i>b-2, 6/2</i> | 1 | | |
| Reference No. | | | | | | <u>Materials</u> | | | |
| | | 4 | | | | Rope 1-G-I-S-N-1960 (200) GOST 3062-80 | 960 | mm | |
| | | 6 | | | | Wire BPVL 1.0 TU 16-505.911-76 | 1100 | mm | |
| | | 5 | | | | Braid PML 6x10 T2 TU 4833-002-08558606-95 | 1030 | mm | |
| Sign and Date | | | | | | | | | |
| Dupl. Inv. No. | | | | | | | | | |
| Alternate Inv. No. | | | | | | | | | |
| Sign and Date | | | | | | | | | |
| Orig. Inv. No. | | | | | | | | | |
| Amend. | | Sheet | Doc. No. | Sign | Date | 9-A-621.08.010 | | | |
| Developed by | | | | | | Bunch of wires | Type | Sheet | Sheets |
| Checked by | | | | | | | O2 | | 1 |
| Head of Q.C.D | | | | | | | | | |
| Approved by | | | | | | | | | |

9-A-621.08.010 SB

First use

Reference No.

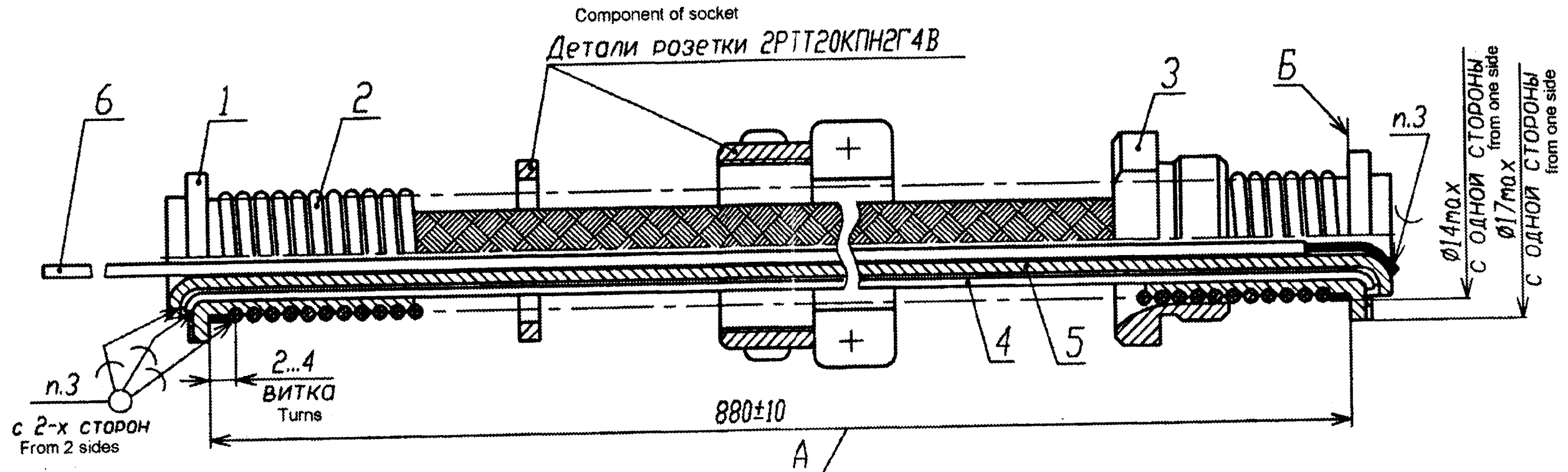
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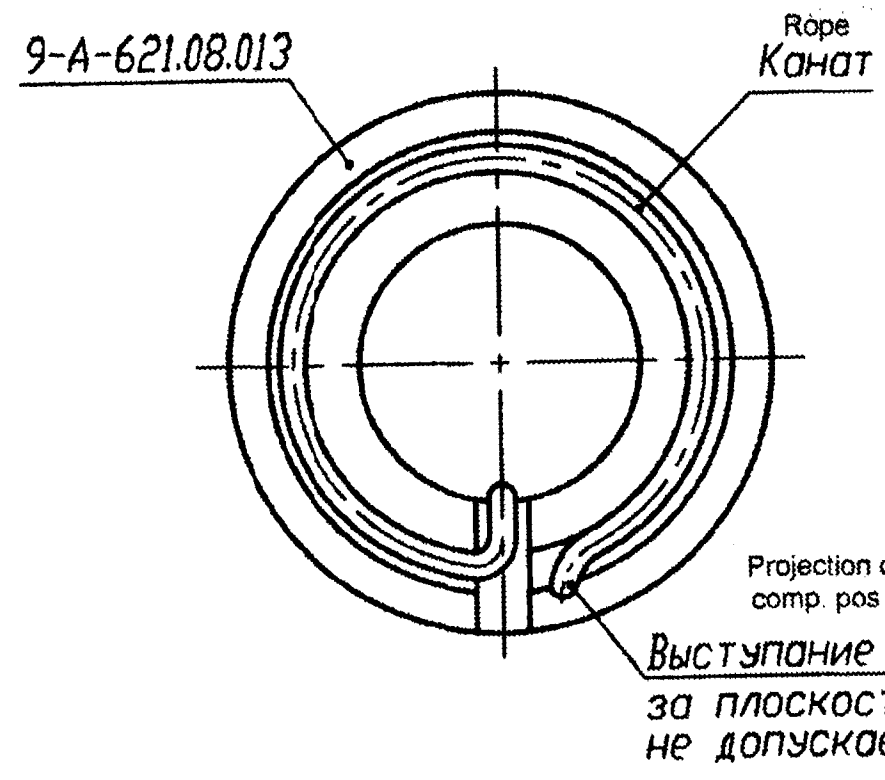
Alternate Inv. No

Sign and Date

Orig. inv. no.



Termination diagram for rope ends
Схема заделки концов каната (2:1)



1. Technical requirements for electric wiring as per GOST 23588-79.
2. Check dimension A in tense position of rope pos.4.
3. Solder with POS 61 GOST 21931-76 and flux FDF_s OST 4GO.033.200.
4. Bunch of wires should be wound around rod with diameter 150 mm.
5. Stamp K on tag.
6. Coat wire bunch ends including faces of component pos.1 to length 20..25 mm with primer AK-070 (2) GOST 25718-83.

| | | | | | | | | |
|---------------|-------|---------|------|------|------------------------------------|----------------|--------|-------|
| | | | | | 9-A-621.08.010 SB | | | |
| Amend. | Sheet | Doc.No. | Sign | Date | Bunch of wires Assembly drawing | Type | Weight | Scale |
| Developed by | | | | | | O ₂ | 0.308 | 2:1 |
| Checked by | | | | | | Sheet | Sheets | 1 |
| Head of Q.C.D | | | | | | | | |
| Approved by | | | | | | | | |

9-A-621.08.013

First use

Reference No.

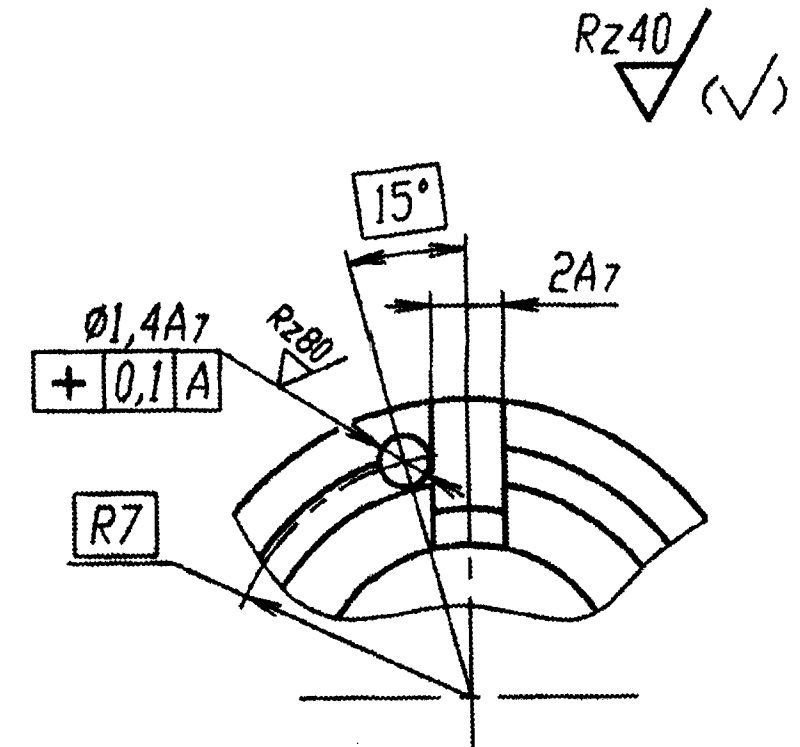
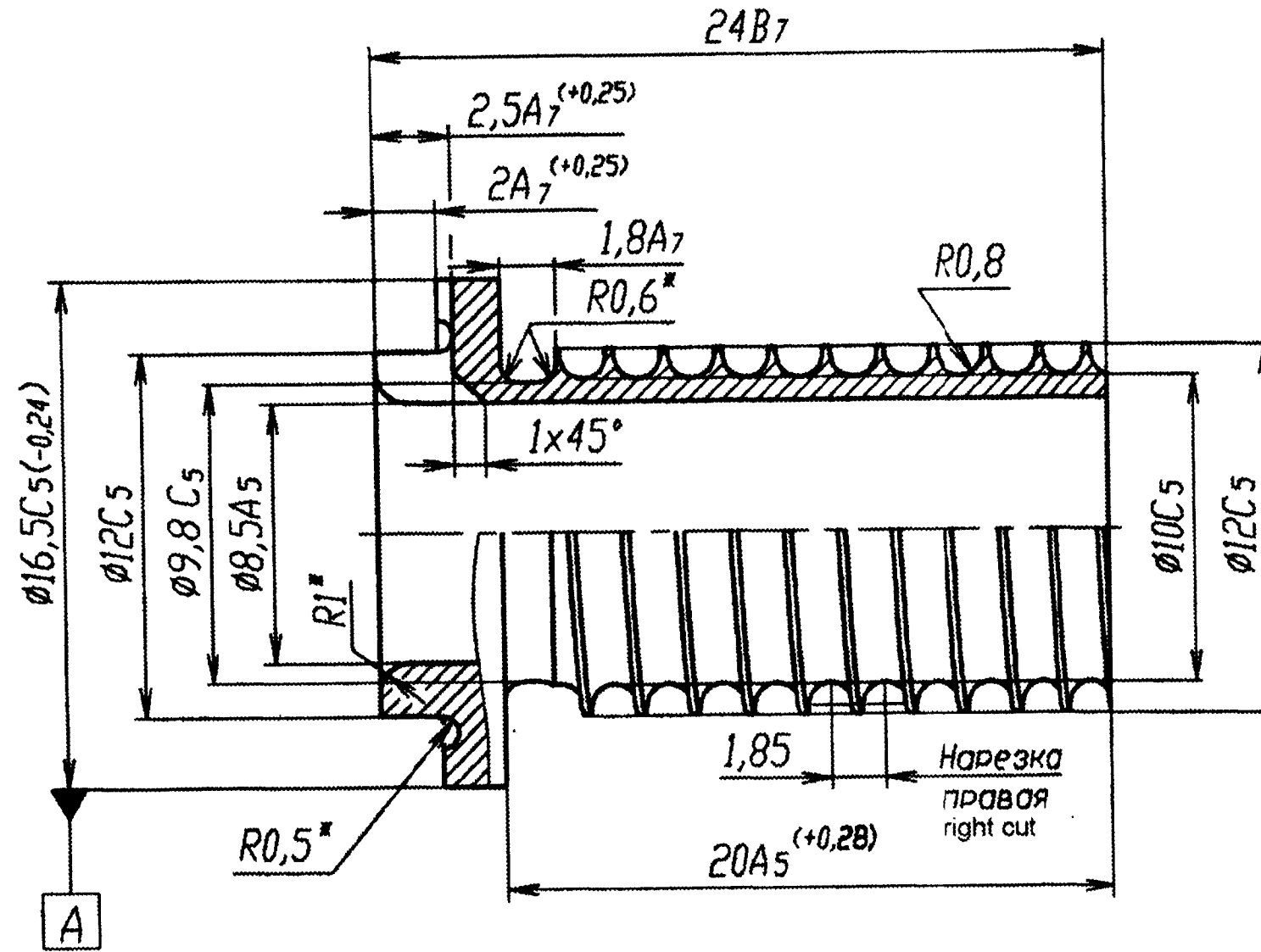
Sign and Date

Duplicate Inv. No.

Alternate Inv. No.

Sign and Date

Orig. inv. no.



- 1.* Dimension ensured by tool.
- 2. Inner angles R~0.4 mm.
- 3. Blunt sharp edges ~0.6 mm.
- 4. Coating Ep
- 5. Stamp K on batch tag.

| | | | | | | | | |
|---------------|-------|---------|------|------|------------------------------------|----------------|--------|-------|
| | | | | | 9-A-621.08.013 | | | |
| Amend. | Sheet | Doc.No. | Sign | Date | End cap | Type | Weight | Scale |
| Developed by | | | | | | O ₂ | 0.1 | 5:1 |
| Checked by | | | | | | Sheet | Sheets | 1 |
| Head of Q.C.D | | | | | Steel 12Cr18Ni10Ti GOST 5632-72 | | | |
| Approved by | | | | | | | | |

9-A-621.08.014

| | | | | |
|-----------------|--------------------|----------------|------------------|-----------|
| Approved OGMet. | Approved TOsb | Approved KTONI | Approved by shop | First use |
| Orig. Inv. No. | Alternate Inv. No. | Dupl. Inv. No. | Reference No. | |
| Sign and Date | Sign and Date | | | |

Technical drawing of a hose with the following dimensions and specifications:

- Total length: 860 ± 10
- Outer diameter: $\varnothing 13,6 \pm 0,2$
- Pitch: $1,61^*$
- Surface roughness: $Rz20$ (left and right ends), $Rz80$ (top right)
- Minimum thickness: $0,4 \text{ min}$

1. Tempering $450..470^{\circ}\text{C}$.
2. *Reference dimension.
3. Coiling direction-right.
4. Coating E_p
5. Stamp K, И on batch tag.

| | | | | |
|---------------------|-------|----------|------|------|
| 9-A-621.08.014 | | | | |
| Amend. | Sheet | Doc. No. | Sign | Date |
| Developed by | | | | |
| Checked by | | | | |
| Head of Q.C.D | | | | |
| Design bureau chief | | | | |
| Head of Q.C.D | | | | |
| Approved by | | | | |

| | | | |
|--|----------------|----------|-------|
| 9-A-621.08.014 | | | |
| Hose | Type | Weight | Scale |
| | O ₂ | 0.36 | 4:1 |
| Sheet | | Sheets 1 | |
| Wire V-1.61 12Cr18Ni10T TU3-1002-77 | | | |

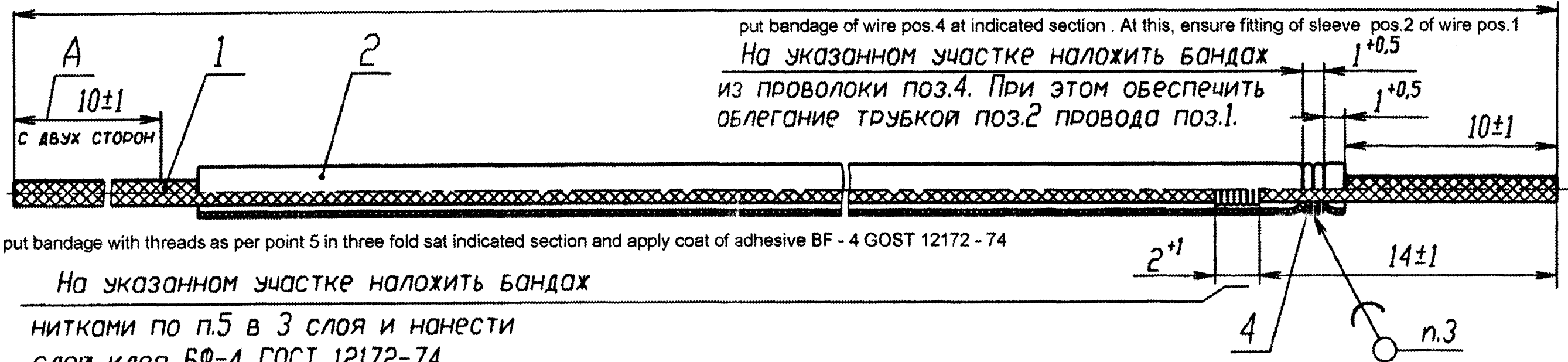
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Format A4

First use

Reference No.

1100±5



Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.

- Wire pos.1 is winded in rope as per diagram 1+6+12 in opposite directions with further double coiling with silk insulation threads as per point 5 and impregnation of external surface with adhesive BF-4 GOST 12172-74, except section A.
- It is permissible to wind by twisting 18 wires in any direction in 80 ± 5 turns in tense position and further coiling and impregnation as per point 1. Inspection of external view as per test specimen. It is permissible to carry out winding of rope pos.1 with 10 wires VEB-2.0.14 TU 16-505.517-80.
- Solder with KR8.0 POS40 GOST 21931-76 and flux LTI-120 TU 84-406-73.
- Stamp K on batch tag.
- Silk insulation threads are winded in 8 folding from threads 10, 24 teks GOST 1086-74.

| | | | | | | | | |
|---------------|-------|---------|------|------|--------------------------|----------------|--------|-------|
| | | | | | 9-A-621.08.020 SB | | | |
| Amend. | Sheet | Doc.No. | Sign | Date | Rope Assembly drawing | Type | Weight | Scale |
| Developed by | | | | | | O ₂ | 0.070 | 5:1 |
| Checked by | | | | | | Sheet | Sheets | 1 |
| Head of Q.C.D | | | | | | | | |
| Approved by | | | | | | | | |

9-A-621.08.003

First use

Reference No.

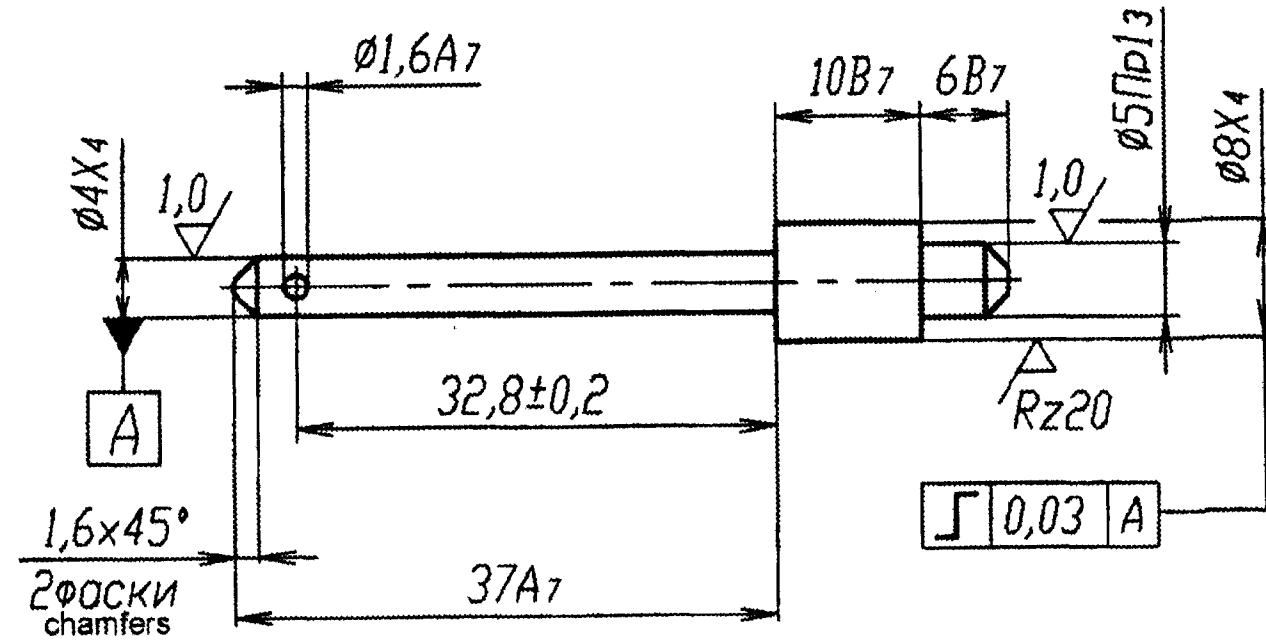
Sign and Date

Duplicate Inv. No

Alternate Inv. No

Sign and Date

Orig. inv. no.



$Rz40$ (✓)

1. $HRC_E 43.5..51.5$
2. Inner angles $R \sim 0.4$ mm.
3. Blunt edges $R \sim 0.6$ mm.
4. Check hardness on 3-5% of the batch, but not less than 3 nos.
5. Coating: chem..phos.accel.Cr./impregnation with adhesive BF-4 GOST 12172-74 with Nigrozene grade A GOST 9307-78, single coat.
6. Stamp K, И on batch tag.

| | | | | | | | | |
|---------------|-------|---------|------|------|----------------------------------|----------------|--------|-------|
| | | | | | 9-A-621.08.003 | | | |
| Amend. | Sheet | Doc.No. | Sign | Date | Contact pin | Type | Weight | Scale |
| Developed by | | | | | | O ₂ | 0.006 | 2:1 |
| Checked by | | | | | | Sheet | Sheets | 1 |
| Head of Q.C.D | | | | | Steel 30 KhN2MFA GOST 4543-71 | | | |
| Approved by | | | | | | | | |

9-A-621.08.007

First use

Reference No.

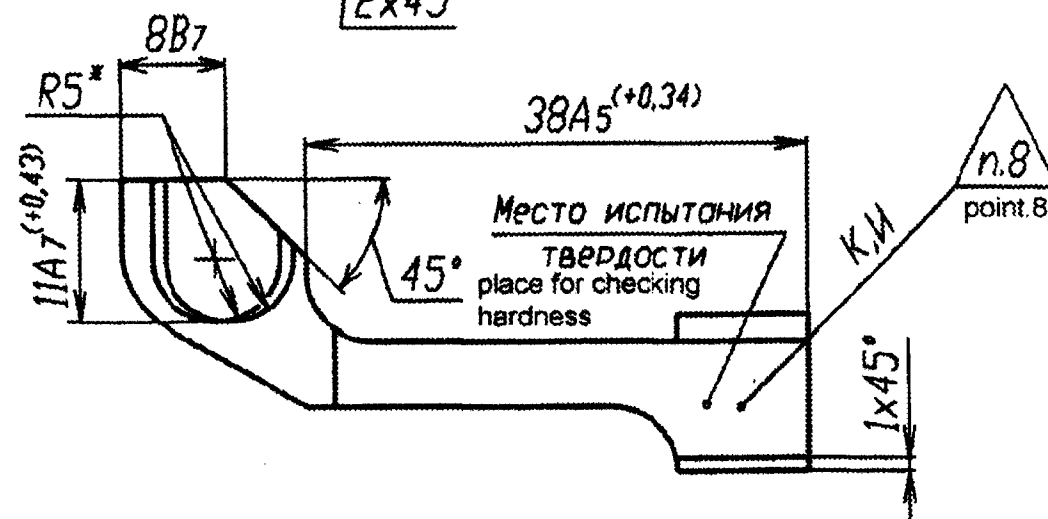
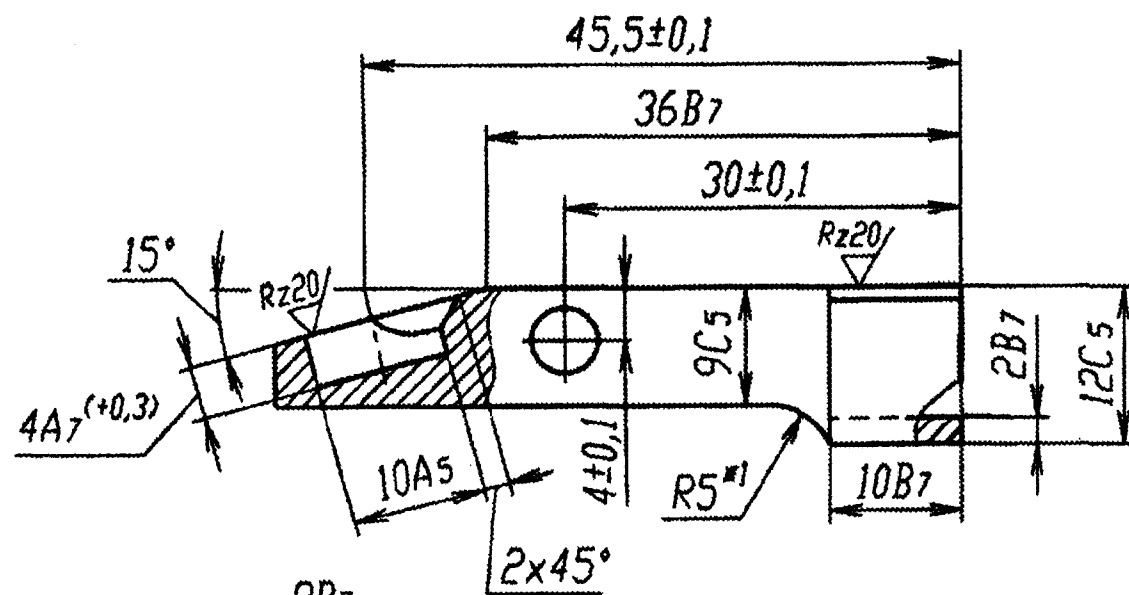
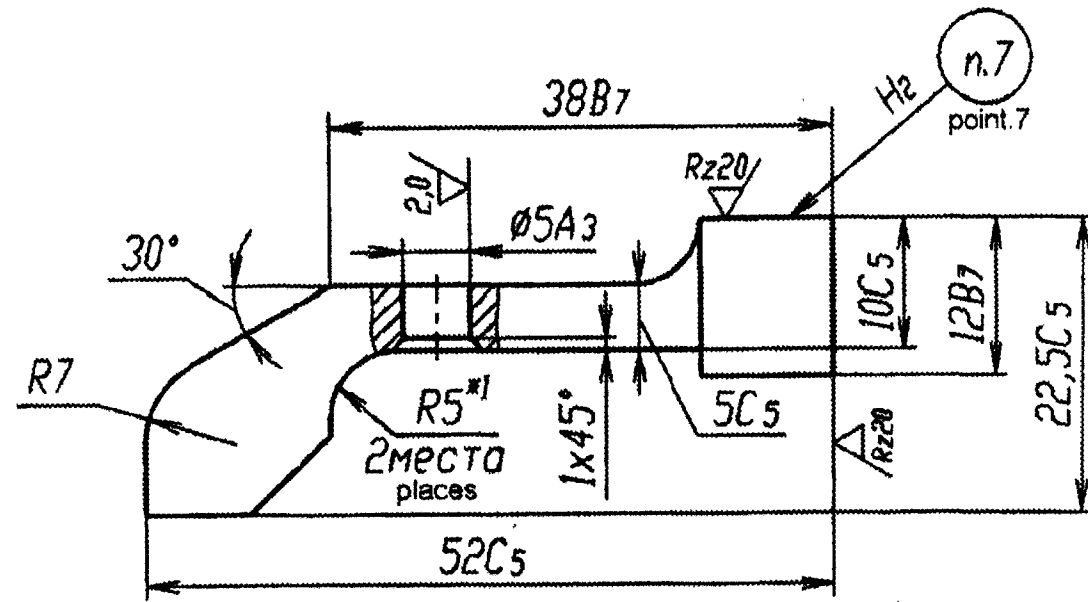
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Alternate Inv. No

Sign and Date

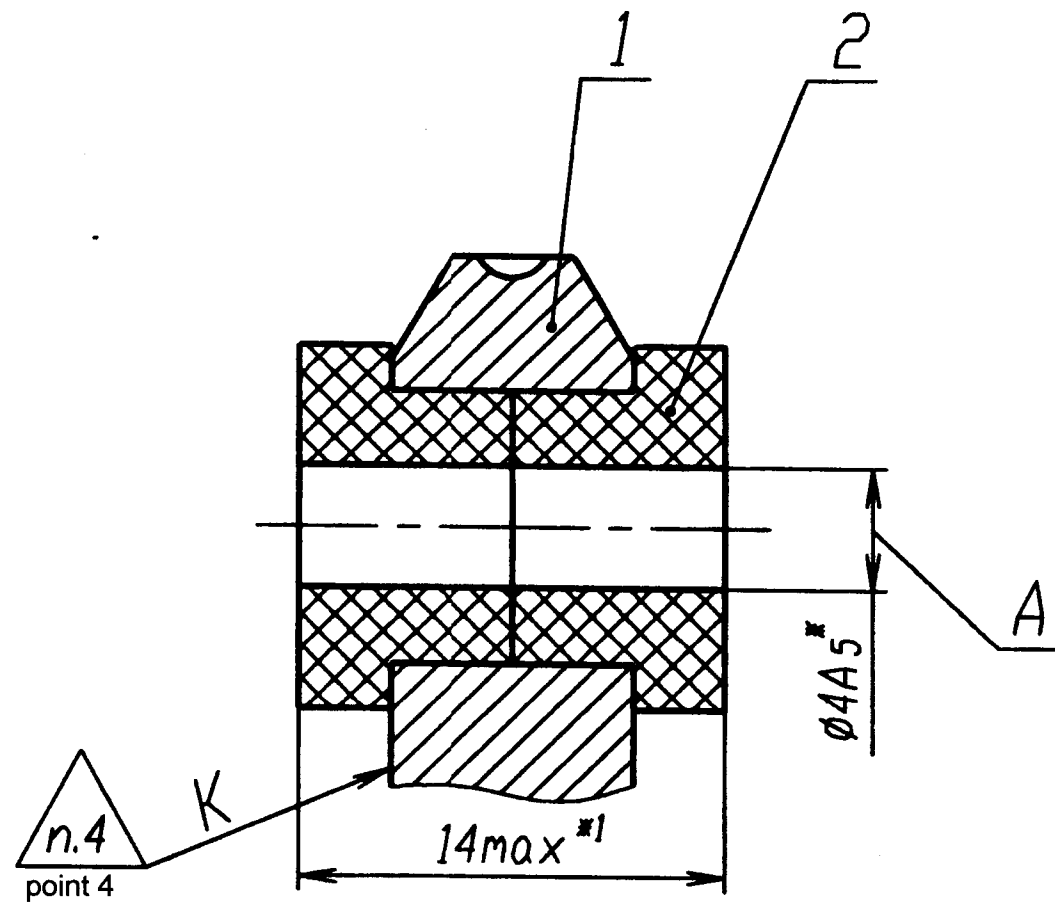
Orig. inv. no.



1. 43.5..51.5 HRC_E.
2. * Dimension not in projection.
3. *1 Dimension ensured by tool.
4. Inner angles R~0.4 mm.
5. Blunt edges R~0.6 mm.
6. Coating: Chem.phos.accel. Cr./adhesive BF-4, GOST 12172-74 with Nigrozene grade A GOST 9307-78, single coat.
7. Mark in letter size PO-3 GOST 2930-62.
8. Stamp.

| | | | | | | | | |
|---------------|-------|---------|------|------|---------------------------|----------------|--------|-------|
| | | | | | 9-A-621.08.007 | | | |
| Amend. | Sheet | Doc.No. | Sign | Date | Contact locator | Type | Weight | Scale |
| Developed by | | | | | | O ₂ | 0.025 | 2:1 |
| Checked by | | | | | | Sheet | Sheets | 1 |
| Head of Q.C.D | | | | | Steel 30 KhRA OST 3-98-80 | | | |
| Approved by | | | | | | | | |

9-A-621.08.040 SB



- 1.* Reference dimension.
- 2.*1 Dimension for inspection.
- 3. Secure comp. pos.2 with epoxy compound E5-2K OST V 84-167-77, its leakage into hole A at this not permissible.
- 4. Stamp.

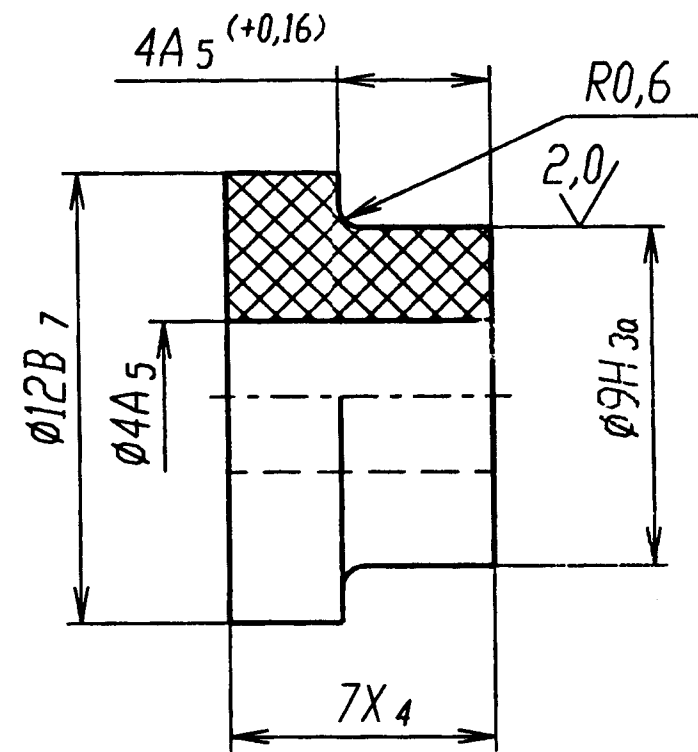
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| 9-A-621.08.040 SB | | 9-A-621.08.040 SB | |
| Approved OGMet | Approved TOsb | Approved KTONI | Approved by shop |
| Orig. Inv. No. | Alternate Inv. No. | Dupl. Inv. No. | Reference No. |
| Sign and Date | Sign and Date | Sign and Date | First use |
| Amend. | Sheet | Doc. No. | Sign |
| Developed by | Checked by | Head of Q.C.D | Date |
| Design bureau chief | Head of Q.C.D | Approved by | |
| Contact Assembly drawing | | Type | Weight |
| O ₂ | | Scale | 4:1 |
| Sheet | | Sheets 1 | |

Copied by

Format A4

9-A-621.08.008

| | | | | | | | | | |
|----------------|----------------|---------------|--------------------|----------------|---------------|----------------|---------------|------------------|-----------|
| Approved OGMet | Orig. Inv. No. | Sign and Date | Alternate Inv. No. | Dupl. Inv. No. | Sign and Date | Approved KTONI | Reference No. | Approved by shop | First use |
| | Sign and Date | | | | | | | Sign and Date | |



1. Substitute material- moulding material DSV-4-0 GOST 17478-95.
2. Surface finish of formation surfaces of press mould $0,5 \sqrt{\lambda}$.
3. Blunt edges $R \sim 0,6$ mm.
4. Stamp K on batch tag.
5. Other technical requirements as per OST 4.GO.005.051.

| | | | | |
|---------------------|-------|----------|------|------|
| Amend. | Sheet | Doc. No. | Sign | Date |
| Developed by | | | | |
| Checked by | | | | |
| Head of Q.C.D | | | | |
| Design bureau chief | | | | |
| Head of Q.C.D | | | | |
| Approved by | | | | |

| | | | |
|---|----------------|--------|----------|
| 9-A-621.08.008 | | | |
| Bush | Type | Weight | Scale |
| | O ₂ | 0.001 | 5:1 |
| Moulding material AG-4 V GOST 20437-75 | | Sheet | Sheets 1 |

Copied by

Format A4