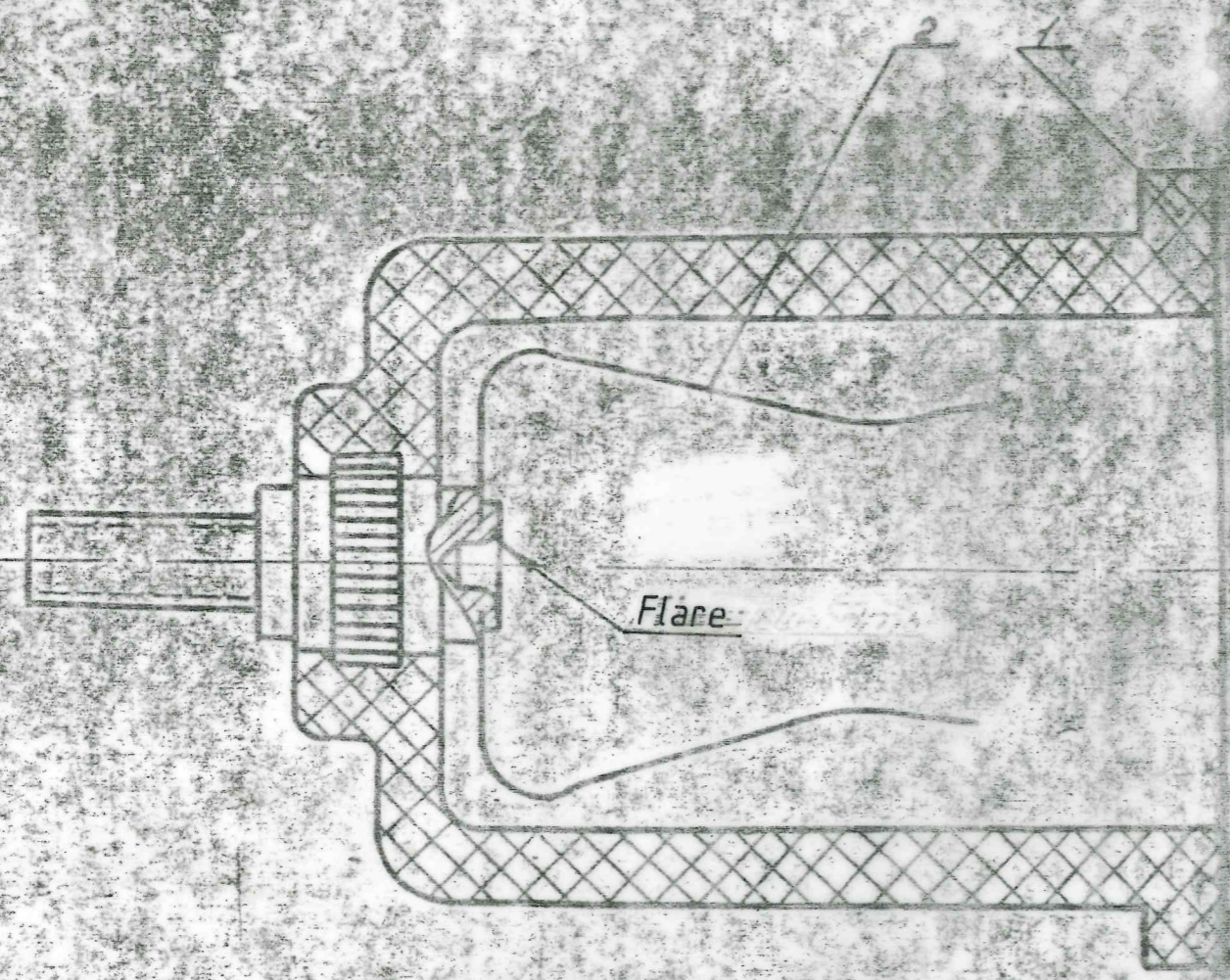


9A6430.019



- 1) Ruptures are not allowed at the place of flaring.
- 2) Coat flared place with primer $\phi N-086$ as per instructions 6C0,045,102.

S.NO.	DESIGNATION	DESCRIPTION	Qty.	Remarks.
2	9A7, 732,009	Contact	1	
1	9A6,430,018	Cap	1	

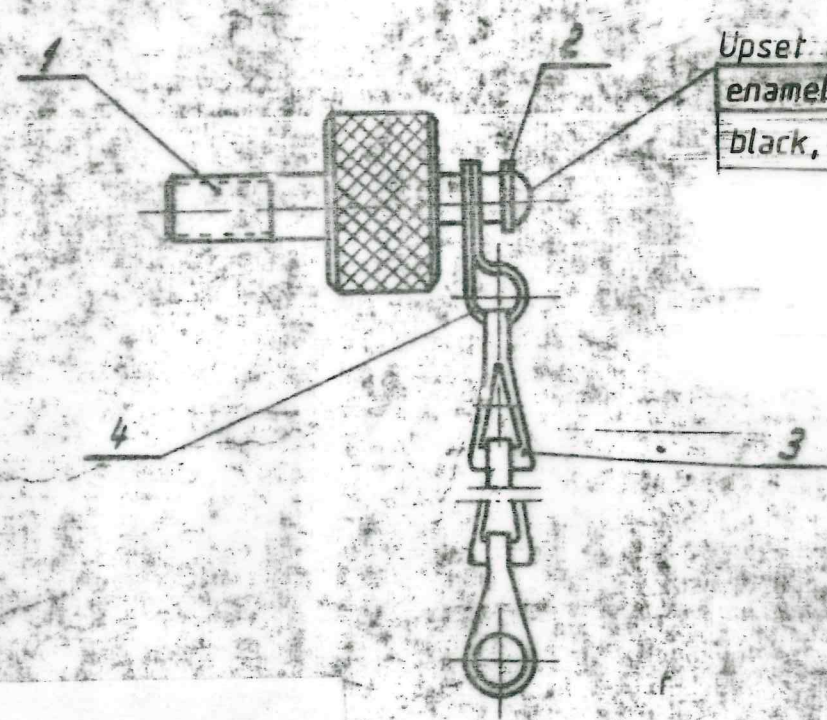
9A6 430.019

EN/SHY	DOC NO	SIGN	DATE
DRAWN	Y.R.Ganesh		19.5.86
EDT/CHKD	D.K.JAIN		24.5.87
F/M,DC	S.H.RAG		3/6
DIV.OFFR	D.P.RAGU		4/6
NAME	SIGN	DATE	

CAP

SHEET	WEIGHT	SCALE.
1	46	5:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

906 433 001



Upset and coat with enamel Zn-140, black, TY6-10-599-79.

127 CA
 Dept. of Ordnance
 Ordnance Factory
 Bangalore
 India

4	9D 8-689-002	Loop	2	
3	1803c 50-63-kd	chain	1	
2	chemically oxidised	Washer	1	
2	3408A-0.5-2-5		1	
1	9A 8.632.005	Plug	1	
S.No	DESIGNATION	DESCRIPTION	Qty.	REMARKS

906 433 001

SNOSH	DOC NO	SIGN	DATE
DRAWN	Y.R.Ganesh		18.5.84
EDT,CHKD	D.K.JAIN	<i>[Signature]</i>	19.5.84
F/M,DC	S.H.RAO	<i>[Signature]</i>	3/6

PLUG

SHEET	WEIGHT	SCALE
	5,550g	2:1
ROYAL SHEETS		
ORDNANCE FACTORY		

FORMAT	ZONE.	REF. NO.	DESIGNATION.	DESCRIPTION.	QTY	REMARKS
				<u>Technical papers.</u>		
			9 Д 6. 613. 001. сБ	Assembly drawing		
				<u>Parts.</u>		
		1	9 Д 7. 722. 000	Ring	1	
				<u>Materials.</u>		
		2		Wire n 3 wo-0.31		
				GOST 16507-80	0.13M	

9Д6. 613. 001.

S.NO	SHT	DOC.NO.	SIGN.	DATE
		BHUSHAN		19.5.84
		D.K. JAIN		24.5.84
		S.H.RAO.		3/6
		D.A. AMBA		4/6
		NAME	SIGN	DATE

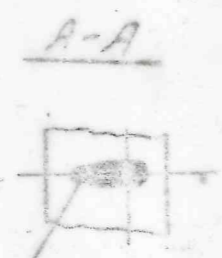
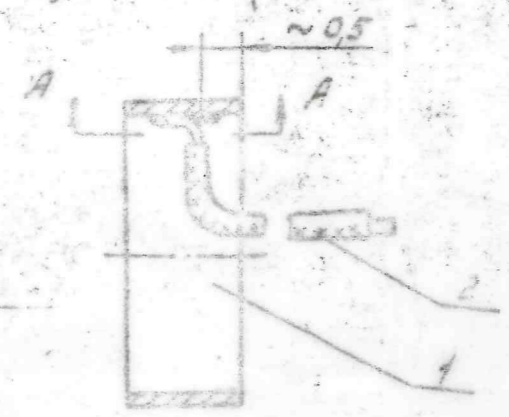
RING.

SHT.NO.	TO.NO.OF.SHT
1	1

ORDNANCE FACTORY
PROJECT HYDERABAD.

926 613 001 CS

926 617 000



Solder using noc-61 with Zinc chloride as per instructions A-0443-003 and rinse as per instructions U-153.356.

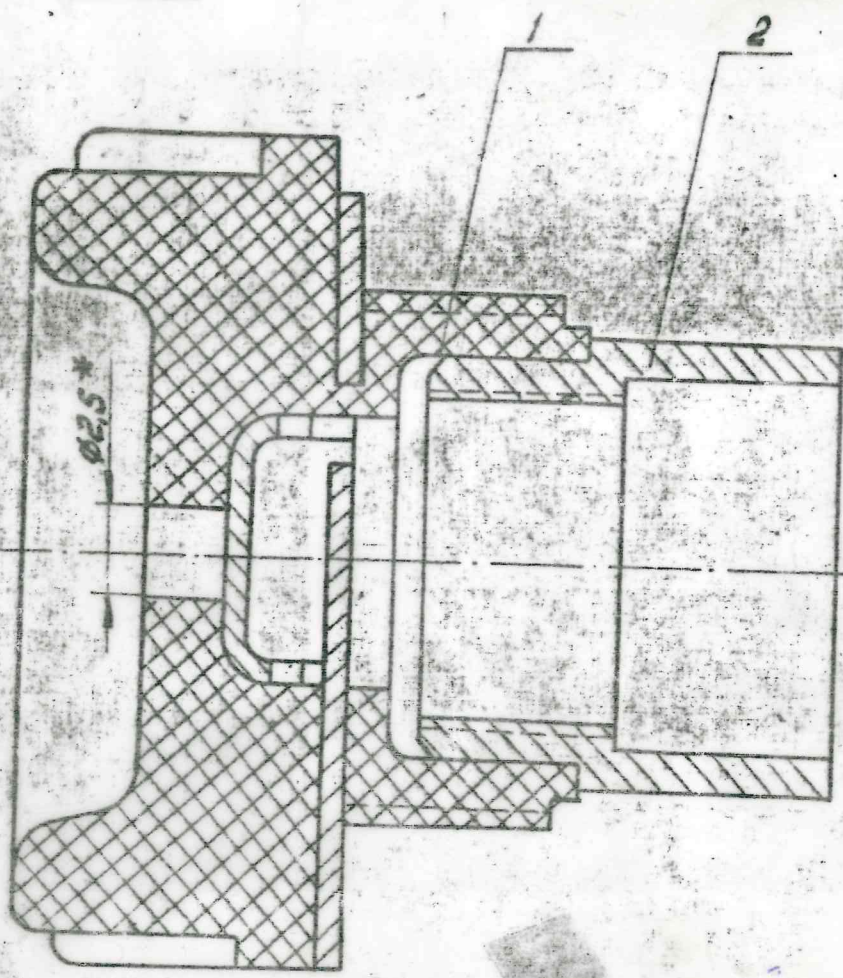
- 1). Saturate conductor Ref.No.2 as per instructions 680.054.247.
- 2). Remove insulation from ends and tin with solder noc-61 with Rosin as per instructions A-0443.003.
- 3). External surface of stip ring should not have nicks, dents and scratches.
- 4). Clean the place of soldering from Tin runs, coat with varnish AK-113 as per instructions bT-33.

926.613.001CS

SMOHT	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>	3/6
DIV/OFFR	D.A. [Signature]	<i>[Signature]</i>	4/6
	NAME	SIGN	DATE

RING
(Assembly drawing)

SHEET	WEIGHT	SCALE
		10-1
TOTAL SHEETS		
ORDNANCE FACTORY		
PROJECT		
HYDERABAD		



- 1). Install part ref.no.2 on adhesive K-115 without filler as per instructions on 909-70.
- 2). Apply enamel ЭМ ЭП-140 black, Ty6-10-599-79, in hole $\phi 2.5$
- 3). Insulation resistance between cap ref.no.2 and slip ring of holder base ref.no.1 should not be less than 80 megohm in normal climatic conditions.

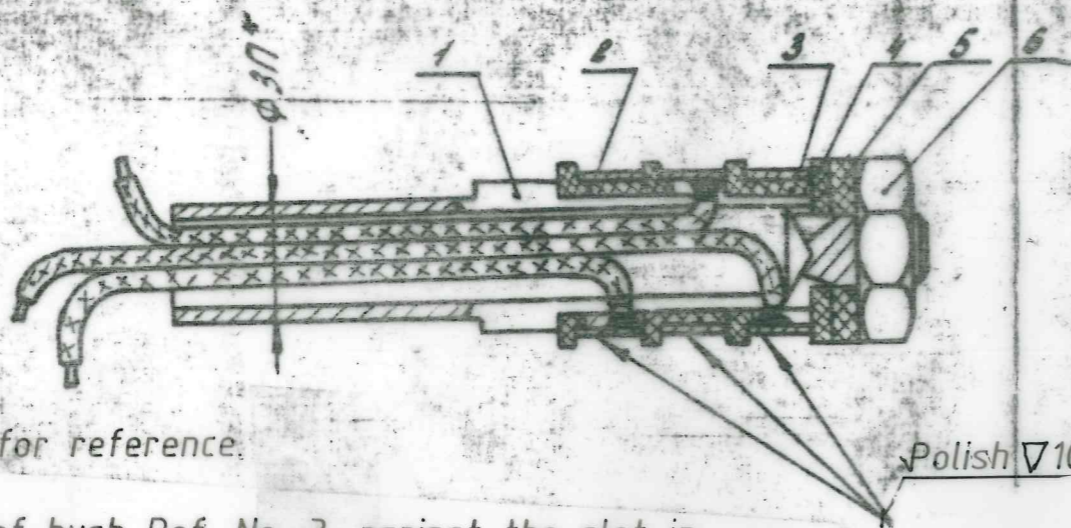
REF. NO.	Designation.	Description	Qty	Remarks.
2	9 Д 6.671.002 ✓	Holder base	1	
1	9 Д 7.747.006 ✓	Cap	1	

926.615.003

SN/SH	DOC NO	SIGN	DATE
DRAWN	BHUSHAN		19.5.84
EDT/CHK	D.K. JAIN	<i>[Signature]</i>	24.5.84
F/M, DC	S. HRAO	<i>[Signature]</i>	3/6
DIV. OFFR	D. R. [Signature]	<i>[Signature]</i>	4/6
	NAME	SIGN	DATE

HOLDER.

SHEET	WEIGHT	SCALE
A	7.120	5:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		



* Dimension is for reference.

- 1) Arrange slot of bush Ref. No. 3, against the slot in axle Ref. No. 1, by shifting each subsequent bushes by 180° with respect to the previous one.
- 2) Run out of external diameters of ring Ref. No. 2 with respect to $\phi 30$ should not exceed 0,2 mm.
- 3) Apply bakelite varnish ЛБс-1, GOST 901-78 on the internal plane of axle, and allow to dry as per instructions K0-4-34-028.
- 4) Insulation resistance between rings Ref. No. 2, and axle Ref. No. 1, should not be less than 80 megohm in normal conditions.
- 5) Secure nut Ref. No.6, with primer $\phi 1-086$.
- 6) Insulation between rings Ref. No. 2, and axle Ref. No.1, in normal conditions should withstand 500v with a source power of not less than 0,5 kw.
- 7) Place adjusting washers Ref. No. 4, if necessary.

6	3323A-2	Nut	1	
5	2,2-5-0,8-OCT1,10565-72	Insulated washer	1	
4	ДA-76	Adjusting washer	3	
3	ДA-72	Bush for ring	3	
2	9Д6,613,001	Ring		
1	9Д6,306,000	Axle		
S.No	DESIGNATION	DESCRIPTION	Qty.	REMARKS

906.617.000

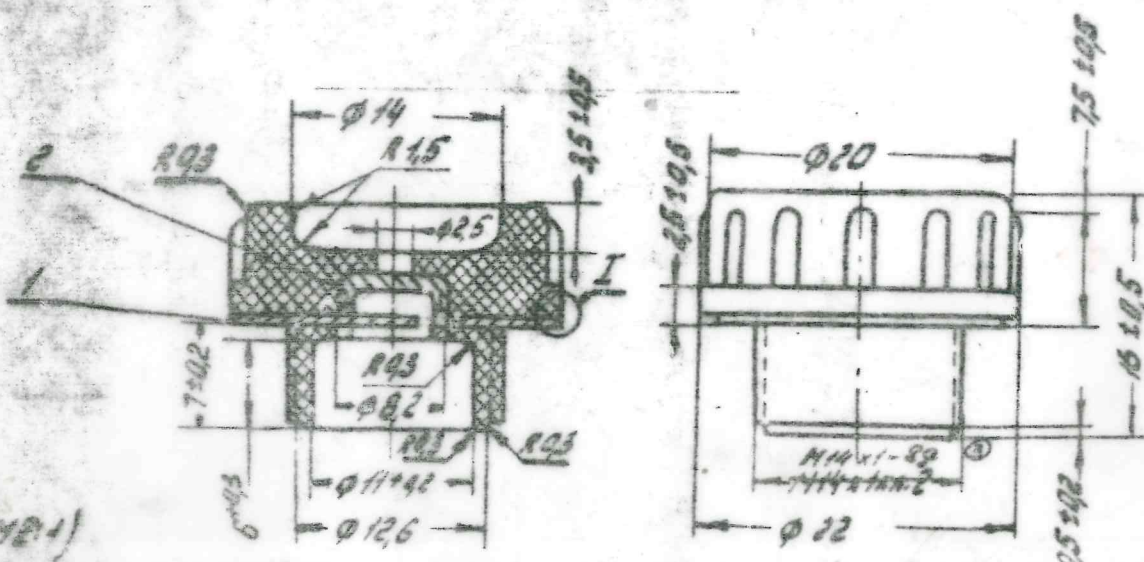
DESIGNER	Y.R.Ganesh	SIGN	DATE
DRAWN	Y.R.Ganesh		9.5.84
EDT,CHKD	D.K.JAIN		24.5.84
F/M,DC	S.H.RAO		
DIV.OFFR	S.H.RAO		
NAME		SIGN	DATE

COLLECTOR

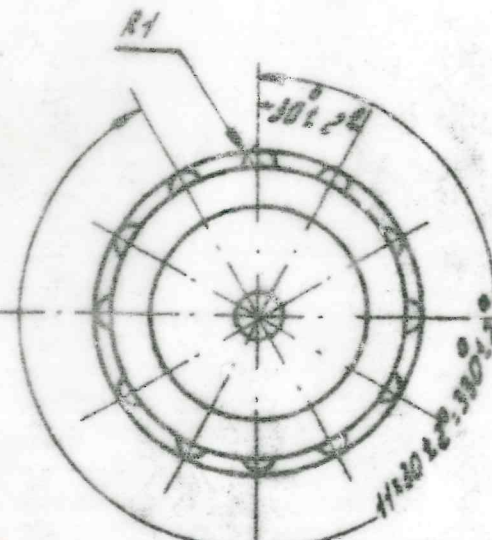
SHEET	WEIGHT	SCALE
A	1270	5:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

926.674.002

Surface of moulding material



I (M21)



- 1). Technical requirements are as per OST 1.80063-79.
- 2). Tolerance on free dimensions are $\pm 1/2$ tolerance of 7th class.
- 3). Clearance between the surface of contact ref.no.1 and plastic should not exceed 0.2mm.

		Phenolic plastic 03.010.2 GOST 5683-79		Black colour
2	9 4 7.742.001	Cap	1	
1	9 4 7.732.003	Contact	1	
REF. NO.	DESIGNATION	DESCRIPTION	QTY	REMARKS.

926.674.002

SN	SHY	DOC NO	SIGN	DATE
DRAWN		BHUSHAN		19.5.84
EDT,CHKD		D.K. JAIN		24.5.84
F/M,DC.		S.H.RAO		31/6
DIV,OFFR		D.A. Bhatt		1/6
		NAME	SIGN	DATE

HOLDER BASE.

SHEET	WEIGHT	SCALE
1	470	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		