

127471

ELECTRICAL DIRECTIONAL GYRO

ГПК-59

DATA OF ISSUE _____

PACKER NO. _____

CERTIFICATE NO. _____

PRESERVATION STAMPS

TERM OF STORING THE UNIT WITHOUT CHECKING IN STORE-HOUSE _____

- 1. Dimensions and manufacturing are as per standard HO-04.
- 2. Arrangement of inscriptions is as per sample.

SLNO	SHEET	DOCNO	SIGN	DATE
	DRAWN BY	P.R.BABU		25.5.84
	EDITED AND CHECKED BY	D.K.JAIN		26-5-84
	FOREMAN OF DC	S.HRAG		31/5
	DIVISIONAL OFFICER	S.HRAG		31/5
	NAME	SIGN	DATE	

LABEL

PAPER GOST 6290-74. OF ANY COLOUR.

127471

SHEETS WEIGHT SCALE

A

TOTAL SHEETS

ORDNANCE FACTORY PROJECT HYDERABAD

DESIGNATION	DESCRIPTION	REQUIRED FOR	QTY.	TOTAL	REMARKS	MARKING ABOUT CHANGE
	Phenolic plastic 01-030-02, Black, GOST 5689-79.					
	Phenolic plastic 03-010-02, Black, GOST 5689-79.					
	Aluminium alloy AЛ.2, GOST 2685-75.					
	Moulding material AГ-4B, GOST 20437-75.					
	Conductor MГШВ K TY16-505.437-73. S=0.35mm ² l=305mm.					
	Conductor MГШВ TY16-505.437-73 S=0.14mm ² l=735mm.				Any colour	
	Phosphor ФКП-03K TY6-09-768-77					
	Enamel AC-131 TY6-10-896-75.					
	Conductor ПЭ ШО 0.31, GOST 16507-80	9.26.613.001	0.13 m	0.39 m		

D130-26

127-Cn

APPD.	D.A. RAJU	Author	31/5
CHECKED.	S.H. RAO	En	21/5
TRACED.	CH.V. RAO	20%	23.5.84
ESTD.	D.K. JAIN	24.5.84	
	NAME	SIGN	DATE

ELECTRICAL
DIRECTIONAL
GYRO Г.ПК-59.

SHT. NO.	NO. OF SHTS
25	29
ORDNANCE FACTORY PROJECT HYDERABAD.	

DESIGNATION	DESCRIPTION	REQUIRED FOR	QTY.	TOTAL	REMARKS	MARKING ABOUT CHANGE
	Enamel ПФ-241М					
	Black, GOST5971-78.					
	Primer ФЛ-086					
	GOST 16302-79.					
	Varnish УР-231					
	TY6-10-863-76.					
	Nitro enamel НЦ-132,					
	Black, GOST6631-74,					
	Enamel ЭП-140					
	Black, TY6-10-599-79.					
	Moulding material					
	"Diflon" Grade 8,					
	TY6-05-1668-80.					

D130-20

127-Cn

APPD.	D.A. Babu	<i>[Signature]</i>	31/5
CHECKED.	S.H.RAO	<i>[Signature]</i>	31/5
TRACED	CH.V.RAO	<i>[Signature]</i>	23.5.84
EDITED	D.K. JAIN	<i>[Signature]</i>	24.5.84

ELECTRICAL
DIRECTIONAL
GYDQ ENK 50

SHT. NO.	NO. OF SHTS
27	29
ORDNANCE FACTORY PROJECT HYDERABAD	

DESIGNATION	DESCRIPTION	REQUIRED FOR	QTY.	TOTAL	REMARKS	MARKING ABOUT CHANGE
Commercial units and parts.						
359.00.00.000	Ejyro motor ГМА-4П					
	359.00.00.000TY	12 cδ18	1	1		
A23YM	Bearing					
	TY100/6 ВЧУПП	127-cδ14	2,5	2,5		
A6005K1	Bearing					
	TY100/6 ВЧУПП	127-cδ15	1,1	1,1		
A1000095KY	Bearing					
	TY 100/6 ВЧУПП	127-cδ15	1,1	1,1		
2PMГД18 БЧШ5E2	Plug ГЕО 364.141		1	1		
	TY	127-cδ1				
2PMД18KYЭ4Г5B1	Socket					
	ГЕО.364.126 TY	127-cδ	1	1		
MH-26-012-1	Miniature bulb					
	GOST 2204-80	127-cδ5	1,3	4,3		
127-6	Glass.					
	TY21-рсфср 234-79	127-cδ5	1,15	1,15		

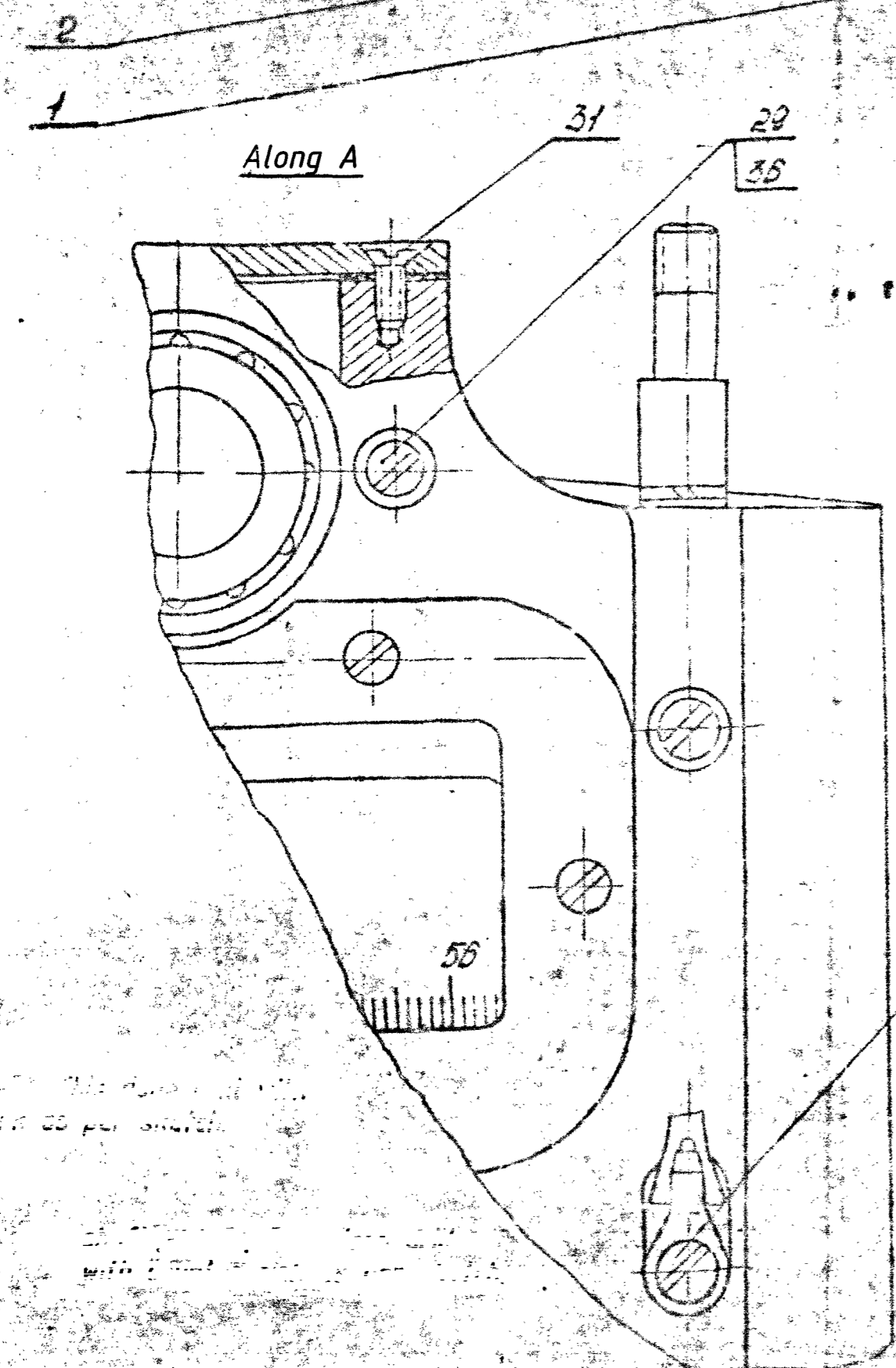
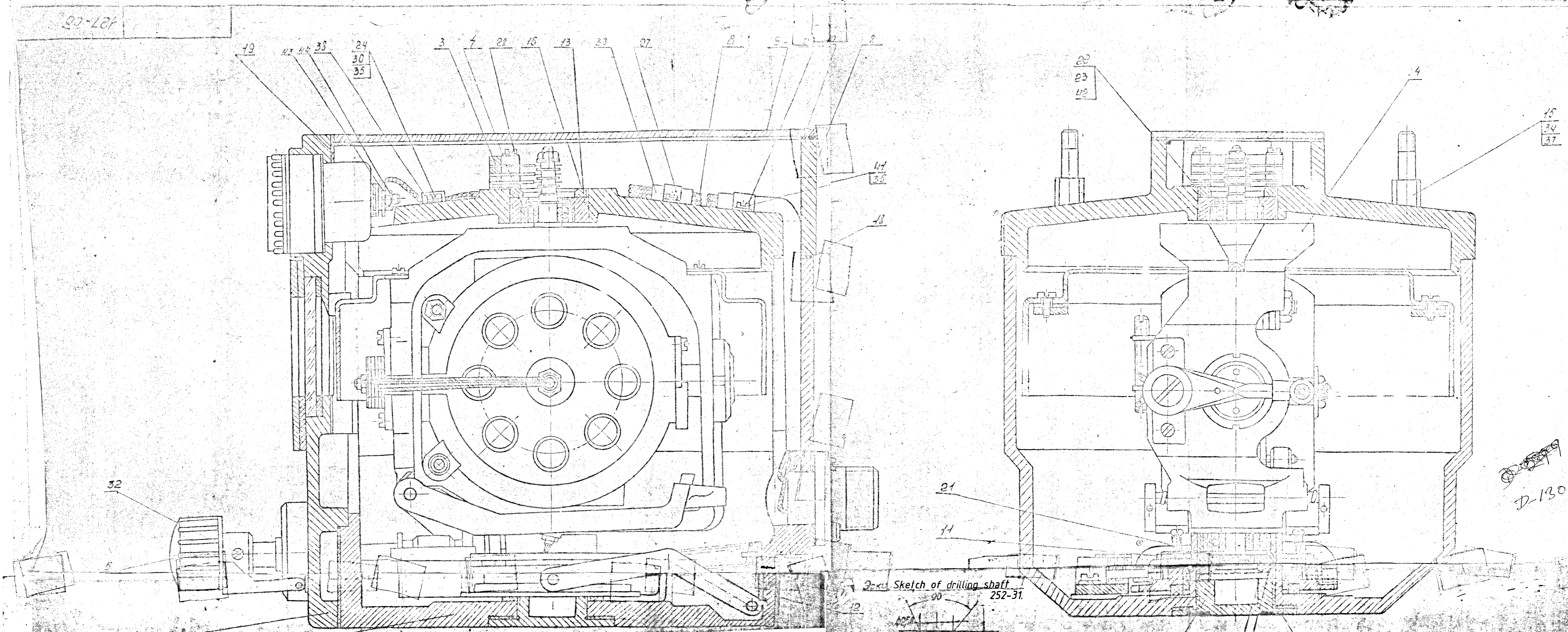
D130-29

127-Сп

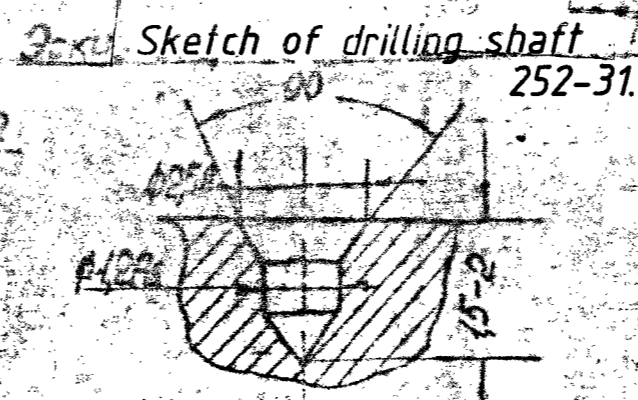
S.NO	SHT	DOC.NO.	SIGN.	DATE
APPD.		D.A. BABU	[Signature]	8/1/8
CHECKED.		S. H RAO	[Signature]	2/1/8
TRACED.		BHUSHAN	[Signature]	26.5.84
EDITED		D.K. JAIN	[Signature]	26.5.84
		NAME	SIGN	DATE

SHT. NO.	NO. OF SHTS
28	29

ORDNANCE FACTORY
PROJECT. HYDERABAD.

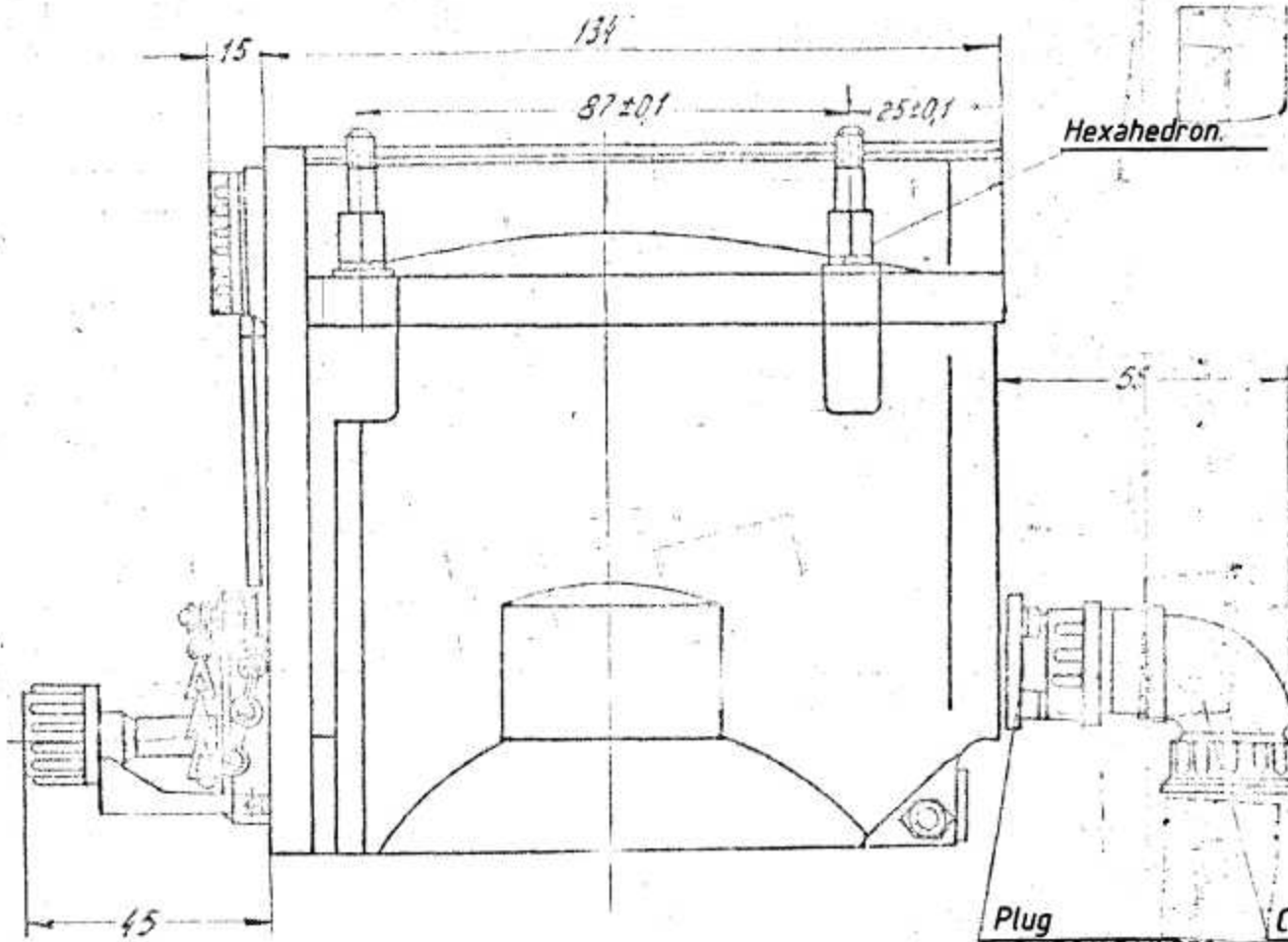


- 1). Check the part as per Technical Specifications on unit cb127.
- 2). Apply lubricant by GOST 7171-78 on both sides of gasket Ref.No.14 before its installation.
- 3). Stick factory mark with adhesive 88Hn.
- 4). Pour sealing compound 2 as per OSTI 10066-71 over both screws ref.No.29,31, two holes on part ref.no.17 and on one screw which is fastened with cover plate 9A8604-001.
- 5). Wiring conductors Ref.No.8 welded on cover with an allowance of at least 40mm.
- 6). Solder using noc-51 with flux 170 as per instructions p.A-0443-003.
- 7). Secure the screws without spring washer with sealing compound $\phi 1-086$. Dry it at a temperature $t^{60 \pm 5^\circ c}$ for 3 1/2 hrs.
- 8). Clearance between pins of cage coupling and ring 160cb14 should not be less than 0.3mm.
- 9). Clearance between card and body should be at least 0.4mm, clearance is checked with auxiliary covers.
- 10). Cut gasket Ref.No.18 flush with unit Ref.No.10, part Ref.No.8, on the sides of front wall.
- 11). To ensure airtightness it is allowed to apply adhesive 50-4 over screw Ref.No.29.
- 12). Coat external fasteners with varnish yp-231 as per instructions 6co-045.102.
- 13). Parts Ref.Nos. 25 and 40 are not shown for clarity.
- 14). Control button Ref.No.5 should be mounted with due regard to the requirements of Item 6.21 of the Tech.specifications.
- 15). Adjust contact pressure of brush unit Ref.No.3 by bending the brushes.
- 16). Centre punch over the 2nd hole of part Ref.No.5 after adjusting the cage with out removing auxiliary screw of shaft 252-31. This done with control ring as per sketch.
- 17). Seal the soldered joints with varnish Ak 113 as per instructions 67-33.
- 18). Lay wire as per standard HO.010.001.

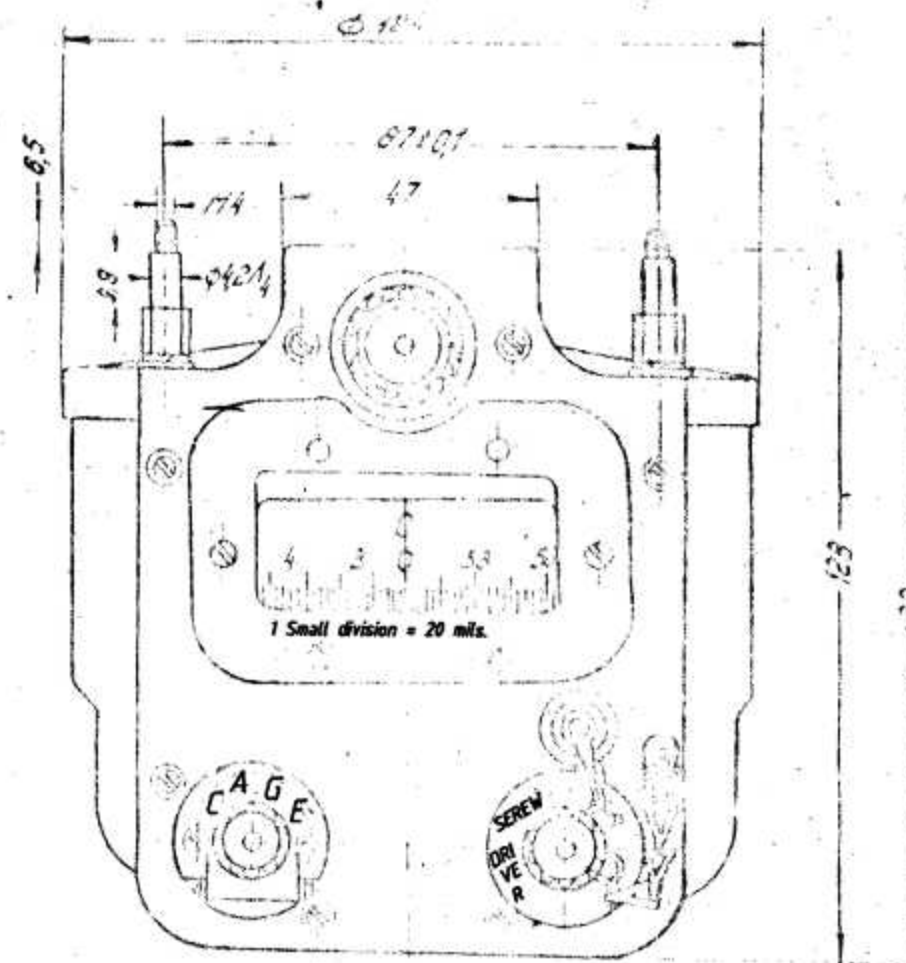


REF. NO.	DESIGNATION	DESCRIPTION	QTY	REMARKS
20	252-114	Nut-II	1	
19	9D8.683.012	Gasket	1	
18	9D8.683.011	Gasket	1	
17	9D8.632.00	Plug	1	
16	127-101	Nut	1	
15	127-100	Stud	1	
14	127-94	Gasket	1	
13	127-85	Upper plug.	1	
12	127-70	Factory mark.	1	
11	127-64	Treaded plug.	1	
10	127-63	Gasket	1	
9	127-62	Cover	1	
8	127-30	Cover.	1	
7	127-3	Corrugated band	1	
6	127-1	Corrugated band	1	
5	9D 6.354.001	Control button	1	
4	127-cb14	Cardau assembly unit	1	
3	127-cb10	Contact assembly unit	1	
2	127-cb5	Front wall with components	1	
1	127-cb1	Body with components	1	
44	3320A-2.5 ka	Nut.	1	
43	3402A-0.5-25-55 ka	Washer	1	
42	352-1000002	Gasket	1	
41	3159A-2-6	Screw	1	
40		PVC Sleeve int. $\phi 0.3mm$ l=15.	1	
39		PVC Sleeve internal $\phi 2.5mm$ l=15mm.	1	
38		PVC Sleeve internal $\phi 2mm$ l=15mm.	1	
37		Washer 40CT 1.11532-74.	4	
36		Washer 30CT 1.11532-74.	8	
35		Washer 20CT 1.11533-74.	4	
34	3402A-08-4-8ka	Washer	4	
33	3402A-0,8-3-6ka	Washer	1	
32	3220A-2.5-5ka	Adjustable screw	2	
31	3177A-3-8-ka	Screw	8	
30	3159A-2-4	Screw	3	
29	3157A-3-10-ka	Screw	8	
28	3157A-2-14-Ka	Screw	2	
27	1628A-2	Clamp	2	
26	2274A-4-I	Clip	1	
25				
24	1629A-1	Clamp	1	
23	352.10.00.003	Gasket	1	
22	352.00.00.034	Gasket	1	
21	075.00.00 .0007	Spring washer	1	
REF. NO.	DESIGNATION	DESCRIPTION	QTY	REMARKS

SHEET NO.	DOCSIGN	DATE	ELECTRICAL DIRECTIONAL GYRO.	127-0
DRAWN BY	BHUSHAN	24.5.64		
EDITED AND CHECKED BY	K. J. J. J.	25.5.64	SHEETS WEIGHT SCALE	
FOREMAN OF DC	S. H. R. S.	2/5	TOTAL SHEETS	
DIVISIONAL OFFICER	D. M. S. S.		ORDNANCE FACTORY PROJECT	
NAME	SIGNATURE	DATE	HYDERABAD	



Plug
 2PMI D1854W5E2 - Cable socket
 2PMD18K934T581.



1. Dimensions without tolerances are the maximum axes.
2. Dimension 87 ± 0.1 is given over the holes on the unit cover.

SLNO	SHEET	DOCNO	SIGN	DATE
DRAWN BY		P.R.BABU		10.5.84
EDITED AND CHECKED BY		D.V. SHAN		17.5.87
FOREMAN OF DC		S.H. RAO		21.5
DIVISIONAL OFFICER		D.A. RAO		24.5
		NAME	SIGN	DATE

OVERALL VIEW

127-200

SHEETS	WEIGHT	SCALE
1	2200	1:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		