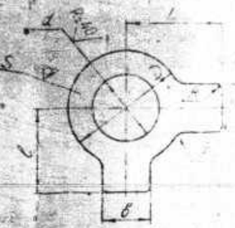
672-31-71

Rz 320




1. Alternate material is steel 08kp, 10kp, GOST 1050-74.
2. Unspecified limit deviations are ±0.5mm.
3. Misalignment of circumfarence D with respect to hole d and asymmetry of tabs with respect to axis of hole d should be 1mm.
4. Coating: Zinc-plated, 9 microns thick, chromatized. Remove hydrogen embrittlement.

| Designation | d, MM | D, MM | L, MM | l, MM | B, MM | S, MM | R, MM | Mass in kg |
|---|---|---|---|---|---|---|---|---|
| 672-31-71 | $6.4^{+0.36}$ | 14 | 15 | 10 | 6 | 1 | 2 | 0,002 |
| -01 | $8.4^{+0.36}$ | | 18 | 12 | 7 | | | 0,002 |
| -02 | $10.5^{+0.43}$ | 18 | 20 | 14 | 8 | | | 0,002 |
| -03 | $13^{+0.43}$ | 22 | 25 | 20 | 10 | 1,5 | | 0,005 |

672-31-71

| SIGN | DOC NO | SIGN | DATE |
|---|---|---|---|
| | | | |

NAME SIGN DATE

TAB WASHER

Steel

SHEET WEIGHT SCALE

For Table

TOTAL SHEETS

672-31-71

## EXPLANATORY NOTES TO TECH. CONDITIONS.

TAB WASHER SHOULD BE MANUFACTURED FROM CARBON STRUCTURAL HOT ROLLED STEEL OF GRADE 10 OR 08 Kp OR 10 Kp (Kp - RIMMED) TO GOST 1050 - 74.

## I CHEMICAL COMPOSITIONS.

| STEEL GRADE | CONTENTS OF ELEMENTS. % | | | |
|---|---|---|---|---|
| | CARBON | SILICON | MANGANESE | CHROMIUM. |
| 10 | 0·07 - 0·14 | 0·17 - 0·37 | 0·35 - 0·65 | 0·15 (MAX.) |
| 08 Kp | 0·05 - 0·11 | 0·03 (MAX.) | 0·25 - 0·50 | 0·10 (MAX.) |
| 10 Kp | 0·07 - 0·14 | 0·07 (MAX.) | 0·25 - 0·50 | 0·15 (MAX.) |

## II MECHANICAL PROPERTIES. STEEL GRADE.

| HEAT TREATMENT OF BLANK. | 08 NORMALISING. | 10 NORMALISING. |
|---|---|---|
| YIELD POINT Kgf / mm² (Min) | 20 | 21 |
| ULTIMATE TENSILE STRENGTH Kgf/mm² (Min) | 33 | 34 |
| PERCENTAGE ELONGATION. % (Min) | 33 | 31 |
| REDUCTION OF AREA. % (Min) | 60 | 55 |
| HARDNESS (WITHOUT HEAT TREATMENT BHN (MAX) | 131 | 143 |

131

## III SURFACE FINISH.

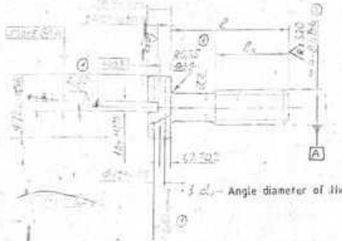
∇ REPRESENTS SURFACE FINISH TO BE OBTAINED WITHOUT REMOVEL OF MATERIAL.

Rz 320 ∇ REPRESENTS SURFACE FINISH TO BE OBTAINED BY MACHINING IN Rz VALUE

320 μ, MAX. ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.

| D.C(I) | DATE | ZONE | BRIEF RECORD | SIGN |
|---|---|---|---|---|
| | | | | |

| | | | |
|---|---|---|---|
| INSCRIBED | | DRG. NOT TO BE SCALED. ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF. ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED | PERTAINS TO |
| CHECKED | | | |
| APPROVED | | | 672-31-71 |
| DATE. | | TAB WASHER. | |
| TOLERANCE UNLESS OTHERWISE SPECIFIED. GEN., DEC., ANG. | | SCALE:- | |
| | | CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT. PUNE | |




1. Alternate material is steel 25,30,35,40 GOST 1050-74. When screws are made by cold upsetting, use steel 10, 10kn, 20, 20kn, GOST 1050-74.
2. Coating: Zinc-plated, 9 microns thick, chromatized. Remove hydrogen embrittlement.

| Designation | ℓ, MM | $\ell_0$ not less than | Mass, kg. |
|---|---|---|---|
| 672-35-3 | 12±0.5 | 10 | 0.0015 |
| -01 | 14±0.5 | 12 | 0.0016 |
| -02 | 16±0.5 | 16 | 0.0017 |
| -03 | 20±0.6 | 14 | 0.0023 |
| | | | |

672-35-3

| | | | | |
|---|---|---|---|---|
| [redacted] | SCREW | SHEET | WEIGHT | SCALE |
| | Steel 45 FOCT. 1050-74 | | | |
| NAME | SIGN | DATE | | |

672-35-3

# EXPLANATORY NOTES TO TECHNICAL CONDITIONS

SCREW SHOULD BE MANUFACTURED FROM STEEL GRADE 45 TO GOST 105075 OR FROM STEEL OF GRADES 10, 10 KP, 20, 20 KP, 25, 30, 35, 40 TO GOST 1050-74 ALSO.

1) CHEMICAL COMPOSITION OF ABOVE STEEL GRADES GIVEN AS BELOWS

| S. No. | CONTENT OF ELEMENTS. | STEEL GRADES 10 | STEEL GRADES 10 KP | STEEL GRADES 20 | STEEL GRADES 20 KP. | STEEL GRADES 25 | STEEL GRADES 30 | STEEL GRADES 35 | STEEL GRADES 40 | STEEL GRADES 45 |
|---|---|---|---|---|---|---|---|---|---|---|
| 1 | CARBON | 0·07-0·14 | 0·07-0·14 | 0·17-0·24 | 0·17-0·24 | 0·22-0·30 | 0·27-0·35 | 0·32-0·40 | 0·37-0·45 | 0·42-0·50 |
| 2 | SILICON | 0·17-0·37 | MAX. 0·07 | 0·17-0·37 | MAX. 0·07 | 0·17-0·37 | 0·17-0·37 | 0·17-0·37 | 0·17-0·37 | 0·17-0·37 |
| 3 | MANGANESE | 0·35-0·65 | 0·25-0·50 | 0·35-0·65 | 0·25-0·5 | 0·50-0·80 | 0·50-0·80 | 0·50-0·80 | 0·50-0·80 | 0·50-0·80 |
| 4 | CHROMIUM MAX. | 0·15 | 0·15 | 0·25 | 0·25 | 0·25 | 0·25 | 0·25 | 0·25 | 0·25 |

2) MECHANICAL PROPERTIES OF STEEL GRADS 10, 20, 25, 30, 35, 40, 45

| S.L No. | PROPERTIES | STEEL GRADES 10 | STEEL GRADES 20 | STEEL GRADES 25 | STEEL GRADES 30 | STEEL GRADES 35 | STEEL GRADES 40 | STEEL GRADES 45 |
|---|---|---|---|---|---|---|---|---|
| 1 | HEAT TREATMENT OF BLANKS | NORMALISING | NORMALISING | NORMALISING | NORMALISING | NORMALISING | NORMALISING | NORMALISING |
| 2 | YIELD POINT MINIMUM KGF/MM² | 21 | 25 | 28 | 30 | 32 | 34 | 36 |
| 3 | ULTIMATE TENSILE MIN. STRENGTH KGF/MM² | 34 | 42 | 46 | 50 | 54 | 58 | 61 |
| 4 | PERCENTAGE ELONGATION MINIMUM % | 31 | 25 | 23 | 21 | 20 | 19 | 16 |
| 5 | REDUCTION OF AREA MINIMUM % | 55 | 55 | 50 | 50 | 45 | 45 | 40 |
| 6 | IMPACT STRENGTH MINIMUM KGM/CM² | – | – | 9 | 8 | 7 | 6 | 5 |

3) HARDNESS :-

| STEEL GRADE | 10 | 20 | 25 | 30 | 35 | 40 | 45 |
|---|---|---|---|---|---|---|---|
| BHN. MAX. | 143 | 163 | 170 | 179 | 207 | 217 | 229 |

| HEATING TEMPERATUR GRADE | | (NORMALISING) |
|---|---|---|
| 10 | — | 920 °C |
| 20 | — | 900 °C |
| 25 | — | 890 °C |
| 30 | — | 880 °C |
| 35 | — | 880 °C |
| 40 | — | 870 °C |
| 45 | — | 860 °C |

NOTE :- IN CASE OF NORMALISING OR HARDENING 30 MINUTES

4) SURFACE FINISH :-

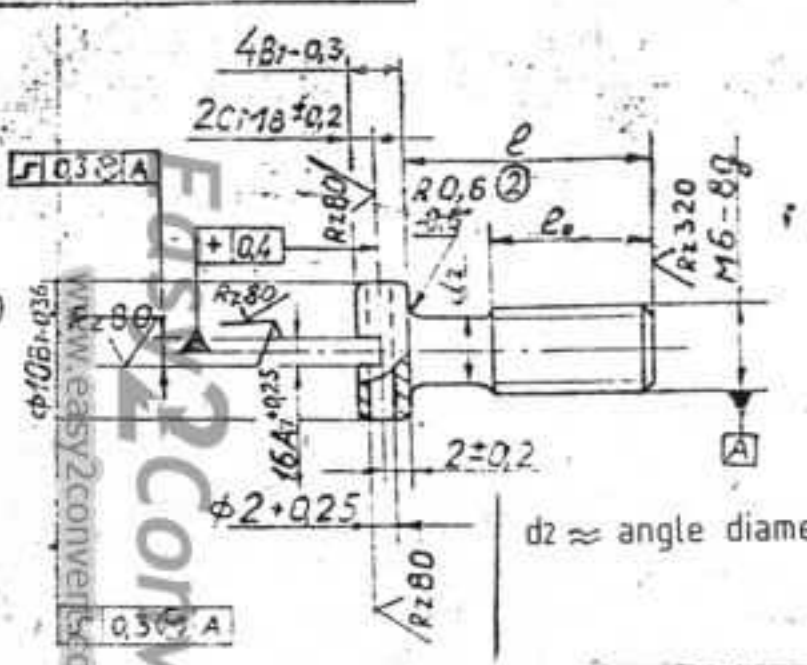
1) $\sqrt{R_z 80}$ :- INDICATES SURFACE FINISH $R_z$ VALUE 80 MICRONS.
2) $\sqrt{320}$ ($R_z$) :- INDICATES SURFACE FINISH $R_z$ VALUE 320 MICRONS.
3) ⌐ 0·3 Ⓜ A :- DISPLACEMENT OF THE INDICATED AXIS FROM THE BASE 'A' TO BE WITH-IN 0·3 MM AT MAX. METAL CONDITIONS.
4) $\sqrt{R_z 40}$ (V) :- INDICATES SURFACES FINISH $R_z$ VALUE -40 MICRONS ON THOSE SURFACES WHERE SURFACE FINISH ARE NOT SPECIFIED.

| | | | | | | | |
|---|---|---|---|---|---|---|---|
| | | | | INSCRIBED | | DRG NOT TO BE SCALED | PERTAINS TO |
| | | | | CHECKED | [redacted] | ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF. | |
| | | | | APPROVED | [redacted] | ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE SPECIFIED | |
| | | | | DATE | 30.1.76 | SCREW. | 672-35-3 |
| | | | | TOLERANCE UNLESS OTHERWISE SPECIFIED | | SCALE :- | |
| DC(1) | DATE | ZONE | BRIEF RECORD | SIGN | GEN ± DEC ± ANG | CONTROLLERATE OF INSPECTION FIRE FIGHTING EQUIPMENT | |



1-4-AB

672-35-4




1. Alternate mateial is steel 25,30,35,40 GOST 1050-74. When screws are made by cold upsetting, use steel 10, 10kn,20,20kn, GOST 1050-74.
2. Coating: Zinc-plated, 9 microns thick, chromatized. Remove hydrogen embrittlement.

| Designation | l, MM | $l_0$ not less than | Mass, kg |
|---|---|---|---|
| 672-35-4 | 10±0,5 | 10 | 0,0039 |
| ✓ -01 | 22±0,6 | 18 | 0,0060 |
| -02 | 6±0,5 | 6 | 0,0027 |

| SIGHT | DOC NO | SIGN | DATE |
|---|---|---|---|
| DRAWN | V.J.RAO | | 20.7.84 |
| EDT/CHKD | B. Sawant | | 21.7.84 |
| F/M, DC | S.R.NAIR | | 22.7.84 |
| DIV.OFFR | P.C.GAIKWAD | | 27.7.84 |
| | NAME | SIGN | DATE |

672-35-4

SCREW

| SHEET | WEIGHT | SCALE |
|---|---|---|
| 1 | See Table | 2:1 |

TOTAL SHEETS

Steel 45 FOCT 1050-74

672-35-4

## EXPLANATORY NOTES TO TECHNICAL CONDITIONS.

1. SCREW SHOULD BE MANUFACTURED FROM STEEL GRADE 45 TO GOST-1050-75 AND ALTERNATIVE MATERIAL OF STEEL GRADES 10, 10KP, 20, 20KP, 25, 30, 35, 40 TO GOST-1050-74.

2. CHEMICAL COMPOSION OF ABOVE STEEL GRADE GIVEN AS BELOW:-

| No. | CONTENT OF ELEMENTS | STEEL GRADE 10 | STEEL GRADE 10 KP. | STEEL GRADE 20. | STEEL GRADE 20 KP. | STEEL GRADE 25 | STEEL GRADE 30 | STEEL GRADE 35 | STEEL GRADE 40 | STEEL GRADE 45 |
|---|---|---|---|---|---|---|---|---|---|---|
| 1 | CARBON. | 0·07 - 0·14 | 0·07-0·14 | 0·17- 0·24 | 0·17 - 0·24 | 0·22 - 0·30 | 0·27- 0·35 | [illegible] - 0·40 | 0·37 - 0·45 | 0·42 - 0·50 |
| 2 | SILICON. | 0·17 - 0·37 | MAX. 0·07 | 0·17 - 0·37 | MAX - 0·07 | 0·17 - 0·37 | 0·17 - 0·37 | 0·17 - 0·37 | 0·17 - 0·37 | 0·17 - 0·37 |
| 3 | MANGANESE | 0·35 - 0·65 | 0·25 - 0·50 | 0·35 - 0·65 | 0·25 - 0·50 | 0·50 - 0·80 | 0·50 - 0·80 | 0·50 - 0·80 | 0·50 - 0·80 | 0·50 - 0·80 |
| 4 | CHROMIUM. MAX. | 0·15 | 0·15 | 0·25 | 0·25 | 0·25 | 0·25 | 0·25 | 0·25 | 0·25 |

3. MECHANICAL PROPERTIES OF STEEL GRADE - 10, 20, 25, 30, 35, 40, 45 AS PER GOST-1050-74.

| NO. | PROPERTIES | STEEL GRADE 10 | STEEL GRADE 20 | STEEL GRADE 25 | STEEL GRADE 30 | STEEL GRADE 35 | STEEL GRADE 40 | STEEL GRADE 45 |
|---|---|---|---|---|---|---|---|---|
| 1. | HEAT TREATMENT OF BLANKS | NORMALISING | NORMALISING | NORMALISING | NORMALISING. | NORMALISING | NORMALISING | NORMALISING. |
| 2. | YIELD POINT MIN. $kgf/mm^2$ | 21 | 25 | 28 | 30 | 32 | 34 | 36 |
| 3. | ULTIMATE TENSILE STRENGTH $kgf/mm^2$. MIN. | 34 | 42 | 46 | 50 | 54 | 58 | 61 |
| 4. | PERCENTAGE ELONGATION % MIN. | 31 | 25 | 23 | 21 | 20 | 19 | 16 |
| 5. | REDUCTION OF AREA % MIN | 55 | 55 | 50 | 50 | 45 | 45 | 40 |
| 6. | IMPACT STRENGTH $kgf/cm^2$ MIN. | — | — | 9 | 8 | 7 | 6 | 5 |

4. HARDNESS :-

| STEEL GRADE | 10 | 20 | 25 | 30 | 35 | 40 | 45 |
|---|---|---|---|---|---|---|---|
| B.H.N. MAX. | 143 | 163 | 170 | 179 | 207 | 217 | 229 |

HEATING TEMPERATURE °C (NORMALISING.)

| GRADE. | | |
|---|---|---|
| 10 | 920 | RECOMENDED MIN. HOLDING PERIOD: |
| 20 | 900 | NOTE: IN CASE OF NORMALISING OR |
| 25 | 890 | HARDENING 30 MINUTES. |
| 30 | 880 | |
| 35 | 880 | |
| 40 | 870 | |
| 45 | 860 | |

5. SURFACE FINISH :-

1) Rz80 :- INDICATES SURFACE FINISH Rz VALUE 80 MICRONS.
2) Rz320 :- INDICATES SURFACE FINISH Rz VALUE 320 MICRONS.
3) ⌖ 0·3 M A :- DISPLACEMENT OF THE INDICATED AXIS FROM BASE A TO BE WITHIN 0·3 MM AT THE MAX METAL CONDITIONS.
4) Rz40 (V) :- INDICATES SURFACE FINISH Rz VALUE 40 MICRONS ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.

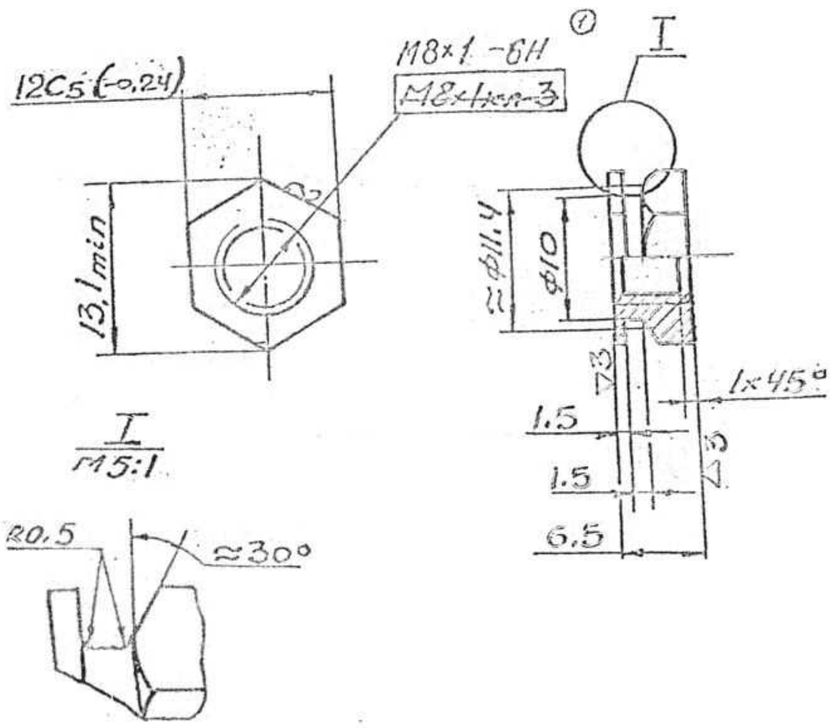
| DC(1) | DT. | ZONE | BRIEF RECORD | SIGN. |
|---|---|---|---|---|
| | | | | |

| | | | |
|---|---|---|---|
| INSCRIBED | | DRG. NOT TO BE SCALED. | PERTAINS TO |
| CHECKED | M.H. / [illegible] | ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF. | |
| APPROVED. | [illegible] | ALL DIMENSIONS ARE IN MM. UNLESS OTHERWISE SPECIFIED. | |
| DATE | 16 OCT 86 | SCREW | 672-35-4 |
| TOLERANCE UNLESS OTHERWISE SPECIFIED. GEN \| DEC. \| ANG. | | SCALE : CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT. PUNE. | |

1-4-41

700-30-455

▽4(▽)




1. Alternate material is steel 5 GOST 380-71 and 25,30,35,40 GOST 1050-74.
2. H.B. 255 to 207 (φ3,8 to 4,2).
3. Unspecified limit deviations of dimensions are as follows: for holes-as per A7, shafts-as per B7.
4. Displacement of axis of hole from true position should not exceed 0,3mm.
5. Type of coating: Zinc plated, 9 microns thick, chromatisation. Remove hydrogen embrittlement.

700-30-455

| SNO | SHT | DOC NO | SIGN | DATE |
|---|---|---|---|---|
| DRAWN | | V.J.RAO | | 10.8.84 |
| EDT & CHKD | | D.K.JAIN | | 29.8.84 |
| F/M, DC | | S.R.NAIR | | 31.8.84 |
| DIV.OFFR. | | T.K.BANERJEE | | 1.9.84 |
| | | NAME | SIGN | DATE |

NUT

45 FOCT 1050-74

| SHEET | WEIGHT | SCALE |
|---|---|---|
| 1 | 0,003 | 1/1 |

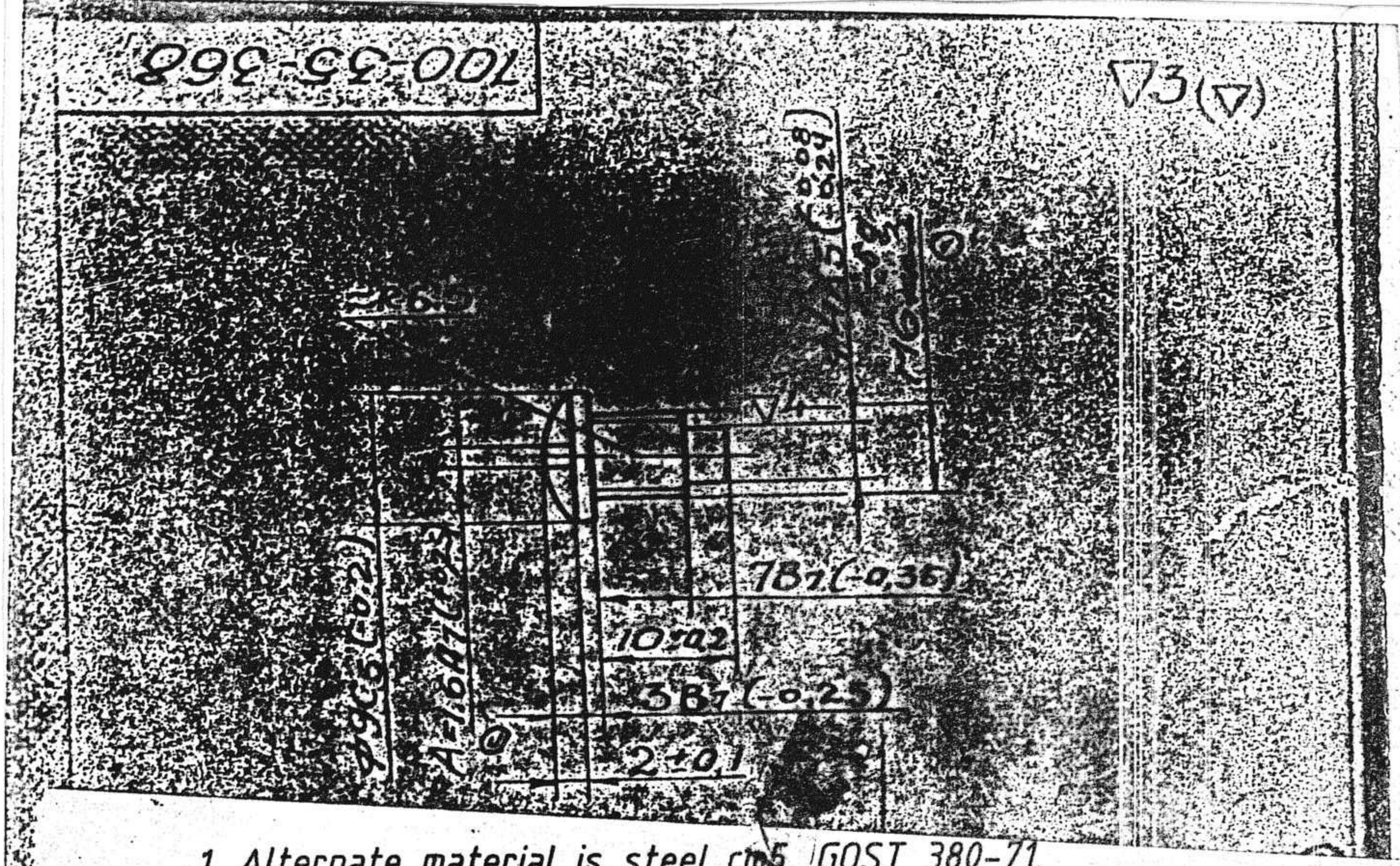
TOTAL SHEETS

ORDANANCE FACTORY
PROJECT
HYDERABAD

D82

Инв. № подл. | Подп. и дата | Взам. инв. № | Инв. № дубл. | Подп. и дата

700-35-368




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 (Ø3,8 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 $16^{+0,25}_{-0,08}$.

| | | | |
|---|---|---|---|
| 2 | | 65A252-06 | |
| 1 | | 45 | |
| | | | |

700-3 368

| SNO SHT | DOC NO | SIGN | DATE |
|---|---|---|---|
| DRAWN | P.R.BABU | | 2.7.84. |
| EDT CHKD | A ROOSEY | | 4.7.84 |
| F/M D.C. | S.R.NAIR | | 4.7.84 |
| DIV.OFFR | A.K.KUNDU | | 11.7.84 |
| | NAME | SIGN | DATE |

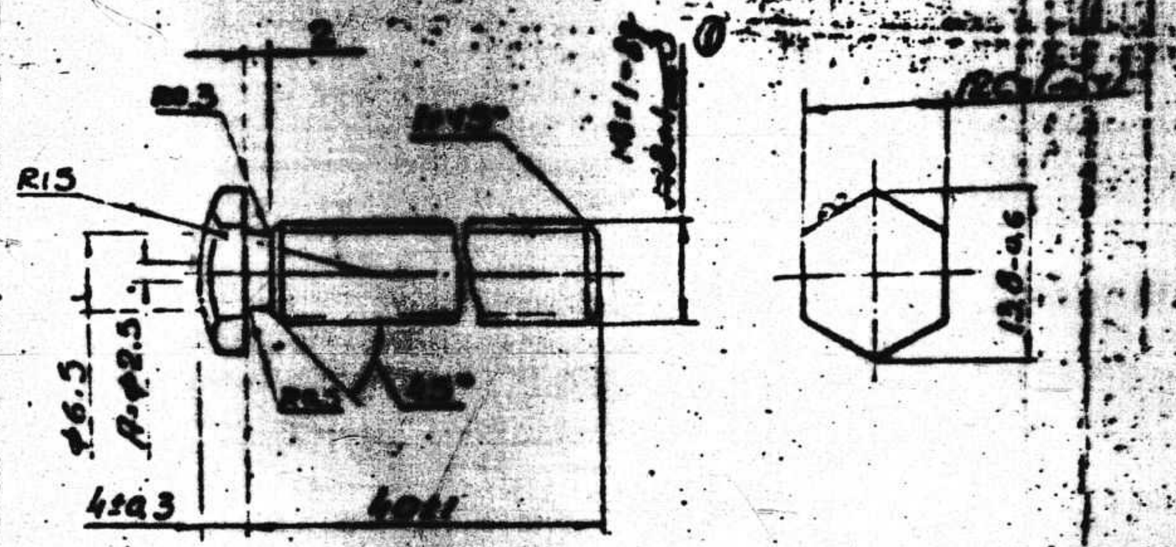
SCREW

1050-6874 (2)

| SHEET | WEIGHT | SCALE |
|---|---|---|
| | 0.025 | 2/1 |

TOTAL SHEETS

ORDINANCE FACTORY
PROJECT
HYDERABAD




1) Alternate material is steel 40 GOST 1050-74.

2) HB 255 to 207 ( ≈ 3,8 to 4,2 ).

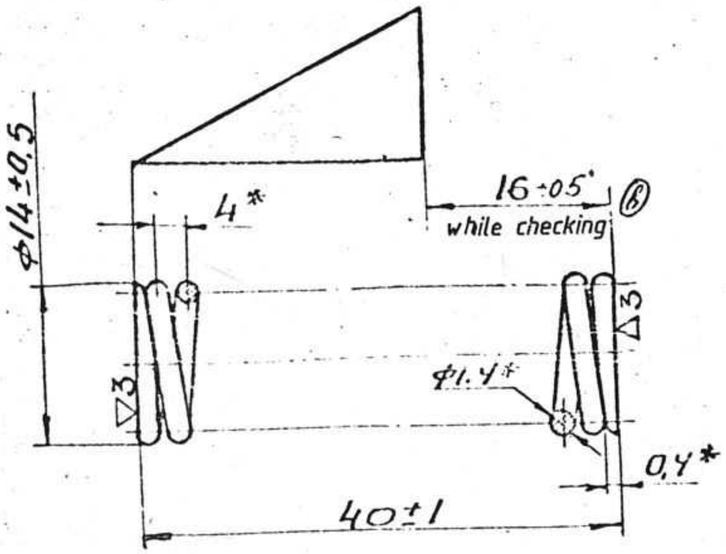
3) Unspecified limit deviations of dimensions of holes are as per $A_7$.

4) Presence of area A is allowed on the face of sphere

5) Coating :- Zinc plated , 9 microns thick, chromatized. Remove hydrogen embrittlement.

700-35-408

| | | | | | |
|---|---|---|---|---|---|
| | HYDOC NO | SIGN | DATE | SCREW | SHEET 1 OF 1 |
| DRAWN | Y.R.Ganesh | | 27.8 | | SIZE A3 |
| EDT,CHKD | K.SHIV | | 27.8 | | SCALE 4:1 |
| APPR.DC | S.R.MAIR | | 27.8 | 45 FOCT 1050-74 | ORDNANCE FACTORY HYDERABAD |
| DIV.OFFR | | | | | |
| | NAME | SIGN | DATE | | |




1) Shear modulus is $G^* = 8,10^3$ kg/mm², max.

2) Tangential twisting stress. $\tau_3^* = 73$ kg/mm², max.

3) Total length of spring is $L^* \approx 450$ mm.

4) Number of working coils $n = 9$.

5) Complete number of coils is $n_1 = 11 \pm 0.5$.

6) Direction of winding is arbitrary.

7) *Dimensions are given for reference.

8k) Coating : Chemically parkerized, chromatized, accelerated, oiled, with preservation oil k-17 GOST 10877-76 as per instructions 053,25289,00002 or with varnish k0-815 ГОСТ 11066-74.

8) Coating : chemically parkerized, chromatized, accelerated, oiled with varnish K0-815, GOST 11066-74.

| | | | | |
|---|---|---|---|---|
| 1' | - | 765237-82 | Чертеж | 21.4.82 |
| 1 | - | 765.2168-76 | Чертеж | 11.5.82 |
| 2 | 1 | 765415-75 | Чертеж | 5.2.75 |
| 3 | 1 | 654166 | " | 21.2.66 |
| 4 | | 653/373 | " | 13.2.81 |

| STN | SHT | DOC NO | SIGN | DATE |
|---|---|---|---|---|
| DRAWN | | Y.R.Ganesh | | 2.7.84 |
| EDT.CHKD | | D.K. JAIN | | 4.7.84 |
| F/M, DC | | S.R.NAIR | | 4.7.84 |
| C.V.OFFR. | | | | |
| | | NAME | SIGN | DATE |

700-38-1495

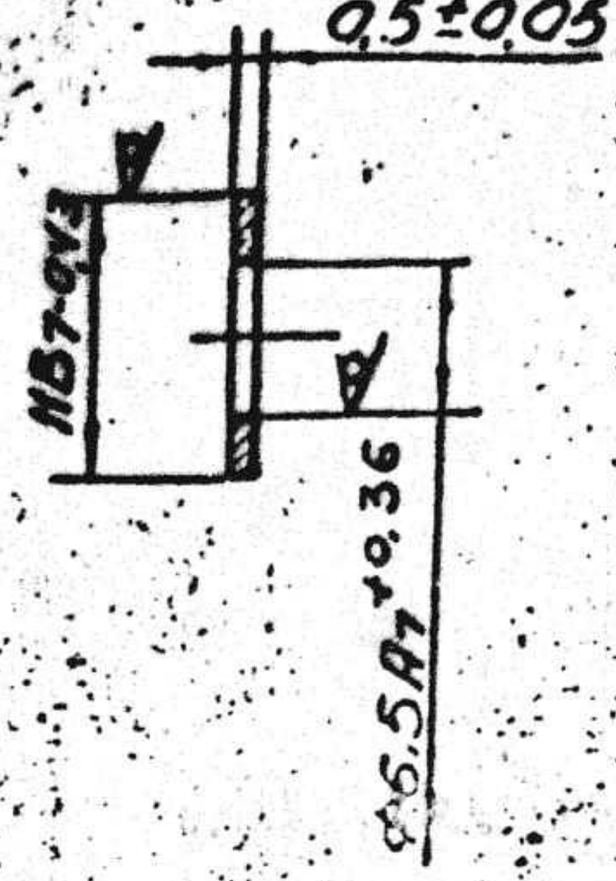
# SPRING

WIRE II. -1,4 ГОСТ 9389-75

| SHEET | WEIGHT | SCALE |
|---|---|---|
| | 0,0053 | 2:1 |

TOTAL SHEETS

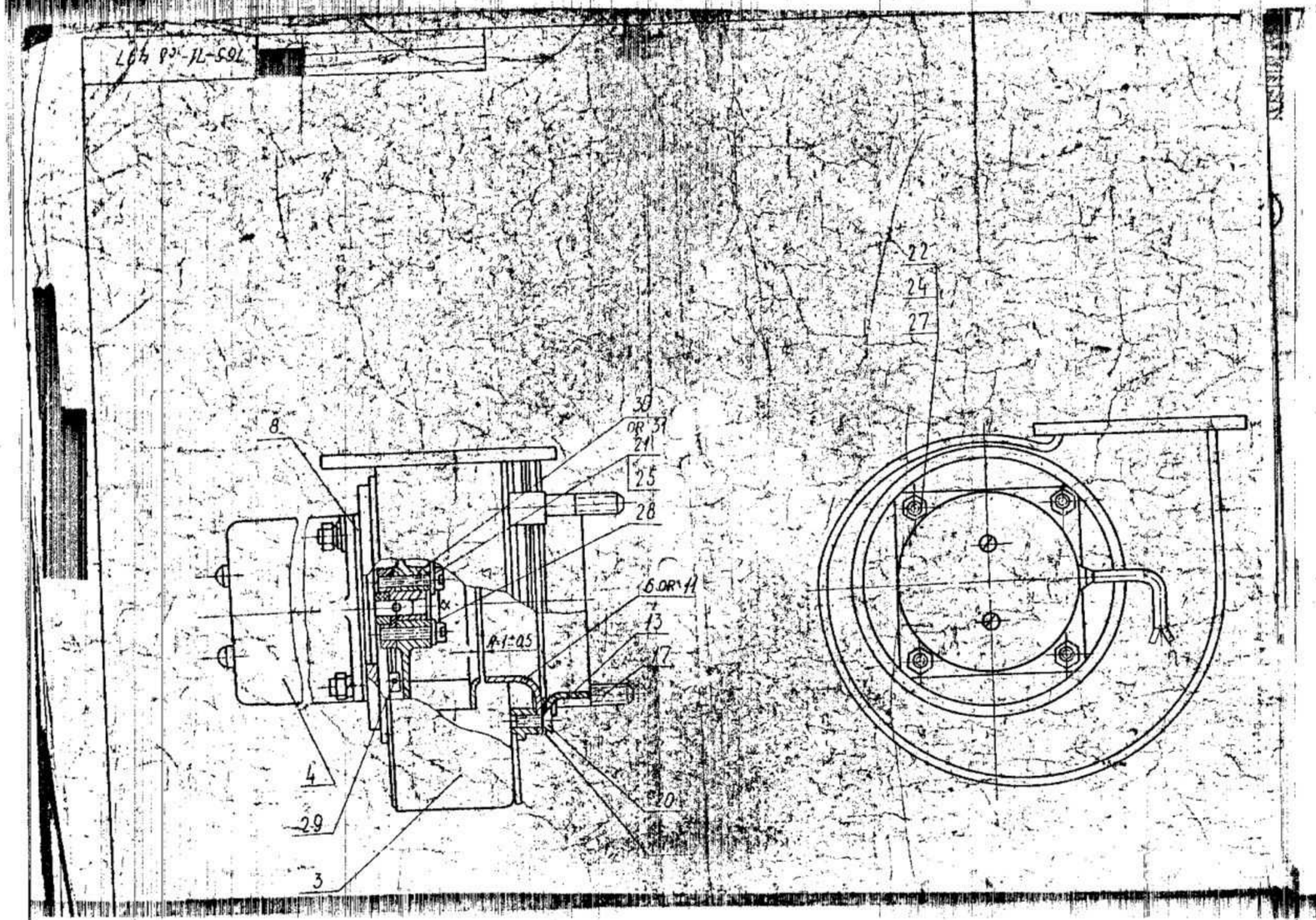
ORDNANCE FACTORY PROJECT HYDERABAD




1). Alternate material is steel cm2, cm3, GOST 380-71 and steel 08nc, 10, 10kn, 15, 15kn, 20, 25 and 30 GOST 1050-74.

2). Coating: Zinc-plated, 9 microns thick, chromatized. Remove hydrogen embrittlement.

| | | | |
|---|---|---|---|
| | | 700-40-153 | |
| SNO SH | | | |
| DRAWN | GASKET. | SHEET WEIGHT SCALE | |
| | | 70003 | 2:1 |
| | | TOTAL SHEETS | |
| | | ORDNANCE FACTORY | |
| | | PROJECT | |




| | | | | |
|---|---|---|---|---|
| 21 | 672-35-3-02 | Screw | | 2 Pieces when 765-71-CB428 and 765-71-1706 is used. |
| | Or | | | |
| | 672-35-3-03 | Screw | | 2 Pieces when 765-71-CB564 is used. |
| 22 | 672-35-4-01 | Screw | 4 | |
| | Thick iron minium. | | | |
| 17 | 700-29-621 | Stud | 2 | |
| 24 | Nut M6.6.019 GOST 5927-70 | | 4 | |
| 25 | Washer 4.01.019 or 4.02.019 GOST 11371-78 | | 2 | |
| 29 | Wire K01 GOST 792-67 ℓ-320 | | 1 | |
| 28 | Wire K01 GOST 792-67 ℓ= 60 | | 1 | |
| 27 | Washer 6 T 65Г06 GOST 6402-70 | | 4 | |
| 31 | 765-71-CB564 | Rotor | | 1 Piece in set with parts 765-71-1507, 672-35-3-02 may be 765-71-CB425 or 765-71-1706 or 765-71-1710 in set |
| 30 | 765-71-CB425 or 765-71-1706 or 765-71-1710. | Rotor | | 1 Piece in set with parts 765-71-359, 672-35-3-03 is permitted to replace by 765-71-CB564 in set with part 765-71-1507. |
| 20 | Screw M4.8h6h x 10.48.016 GOST 17475-72 | | 6 | |
| 13 | 765-71-1089 | Flange | 1 | |
| 6 | 765-71-359 | Flange. | | 1 Piece when 765-71-CB425 or 765-71-1706 or 765-71-1710 is used. |
| 11 | 765-71-1507 | Flange | | 1 Piece when 765-71-CB564 is used. |
| 8 | 765-71-551 | Spacers. | 1 | |
| 7 | 765-71-362 | Spacers | | 5 max. |
| 4 | 765-82-CB283 | Electric motor A-55A (Modification) | 1 | |
| ~~2~~ | ~~765-71-CB456~~ | ~~Body~~ | 1 | |
| 3 | 765-71-CB629 | BODY | | |
| REF NO. | Designation. | Description. | QNT. | Remarks. |

1. All bolted joints should be tightened and locked.
2. Rotor should be freely rotated without jamming.
3. Clearance 'A' is to be adjusted by selecting spacers Ref.7.
4. Install studs on iron minium GOST 8866-76.
5. Blower should be tested at a voltage of 27 ± 0,5 V for three minutes. Current consumption is 4A max. Rotor should not catch with the non-moving parts.
6. Threaded joints should be smeared with lubricant LITOL-24 GOST 21150-75 or MC-70 GOST 9762-76 before the unit is assembled.
7. Requirements for power supply of the test stand are as per 765-CB4, TY-2.

REFER NOTE 6
LUBRICANT LITHOL-24 (GOST 21150-75)
REFER TO DRG. NO. 675-71-CB6 CD
REFER NOTE 7
COPY OF 765-CB4, TY-2 ENCLOSED.
NOTE :- IRON MINIUM
IRON MINIUM IS A SUSPENSION OF PIGMENT (IRON OXIDE) GROUND WITH DRYING OIL WITH OR WITHOUT ADDITIVES.
PILOT SAMPLE
THREE SAMPLES SHALL BE SUBMITTED TO CIFE, PUNE, FOR THEIR TEST AND APPROVAL BEFORE COMMENCEMENT OF BULK SUPPLY.

(R.VEERARAGHAVAN)
ESO-II

| ISSUE | DATE | REFERENCE |
|---|---|---|
| 1 | 25/07/91 | OFFM/8683 4/8888/ PDO / DESIGN dt. 27-1-88 |

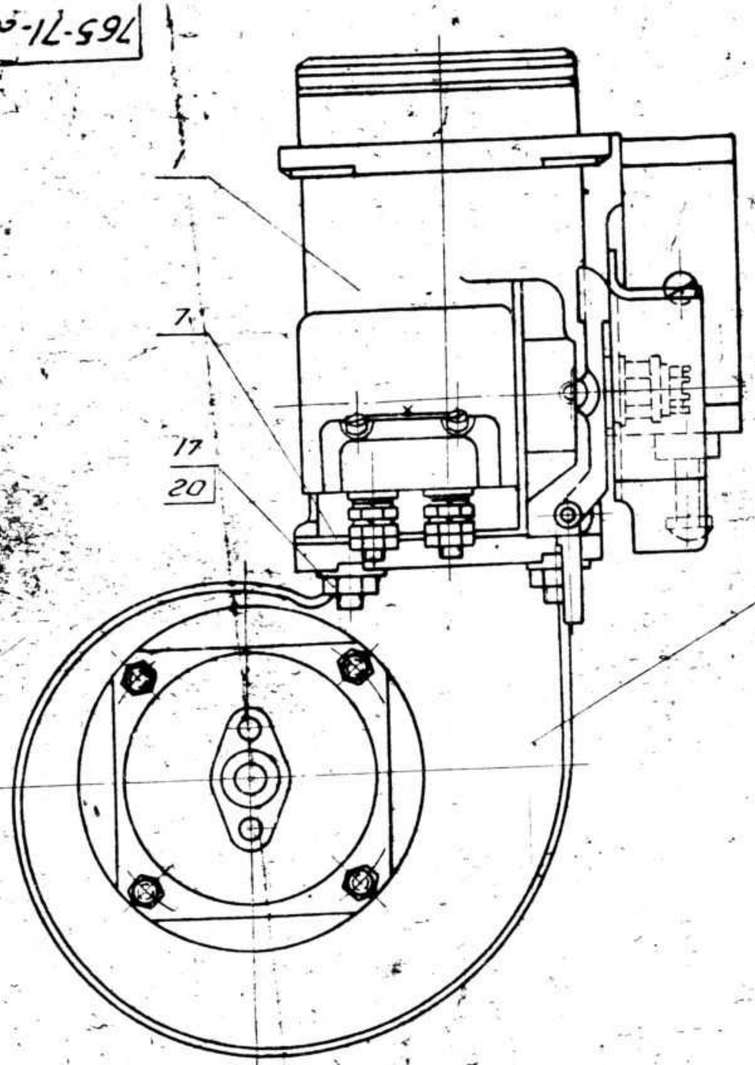
765-71-CB497

| SNO | SHT | DOC NO. | SIGN | DATE |
|---|---|---|---|---|
| DRAWN | | P.R.BABU | | 25.8.84 |
| EDT & CHKD | | | | |
| F/M, DC | | S.R.NAIR | | 31.8.84 |
| DIV.OFFR. | | T.K.BANERJEE | | 3.9.84 |
| | | NAME | SIGN | DATE |

BLOWER

SHEET | WEIGHT | SCALE

765-71-c6 54




1. All bolts and nuts should be tightened fully and locked where ever mentioned.

2. Threaded joints should be smeared with this layer of lubricant Lythol-24, GOST 21150-75 or MC-70 GOST 9762-76, before the unit is assembled.

REFER NOTE NO 2 :-

LUBRICANT LYTHOL-24, (GOST 21150-75) OR MC-70 (GOST 9762-76): GREASE LYTHOL-24 IS MADE BY THICKENING MINERAL OIL WITH LITHIUM SOAPS OF 12-OXYSTEARIC ACID AND ADDING AN ANTIOXIDISING OR A VISCOUS DOPE.

GREASE MC-70:- GREASE MC-70 IS MANUFACTURED BY THICKENING MBT (MVP) GRADE INSTRUMENT OIL WITH BARIUM AND ALUMINIUM STEARIC ACID SOUPS AND ADDING GRADE 80 CERESINE AND POLYISOBUTYLENE OF GRADES P-200N, P-200, P 155 N AND P-155.

PILOT SAMPLE

THREE SAMPLES SHALL BE SUBMITTED TO CIFE, PUNE, FOR THEIR TEST AND APPROVAL, BEFORE COMMENCEMENT OF BULK SUPPLY.

(R VEERARAGHAVAN)
SSO II

| REF. NO. | DESIGNATION | DESCRIPTION | QTY | REMARKS |
|---|---|---|---|---|
| 20 | 672-31-71 | Tab washer | 4 | |
| 19 | | | | |
| 18 | | | | |
| 17 | Nut M6.6.019 GOST 5927-70 | | 4 | |
| 16 | | | | |
| 15 | | | | |
| 14 | | | | |
| 13 | | | | |
| 12 | | | | |
| 11 | | | | |
| 10 | | | | |
| 9 | | | | |
| 8 | | | | |
| 7 | 765-71-1429 | Gasket | 1 | |
| 6 | | | | |
| 5 | | | | |
| 4 | | | | |
| 3 | 765-71-c6497 | Blower | 1 | |
| 2 | | | | |
| 1 | 765-71-c6356 | Box | 1 | |

| SL NO | SHEET | DOC NO | SIGN | DATE |
|---|---|---|---|---|
| DRAWN BY | CH.V.RAO | | | 30.7.84 |
| EDITED AND CHECKED BY | D.K.JHA | | | 31.7.84 |
| FOREMAN OF DC | S.K.NAIK | | | 31.7.84 |
| DIVISIONAL OFFICER | BANERJEE | | | 1.8.84 |
| | NAME | | SIGN | DATE |

BLOWER, RIGHT

CIFE, PUNE

765-71-c6 54

| SHEETS | WEIGHT | SCALE |
|---|---|---|
| 3,5 | | 1:1 |

TOTAL SHEETS

| | | | |
|---|---|---|---|
| 4 | - | 765-71-80 | |
| 3 | - | 765-222-80 | |
| 2 | - | 765-326-80 | |



1-1-A2

1-1-A2