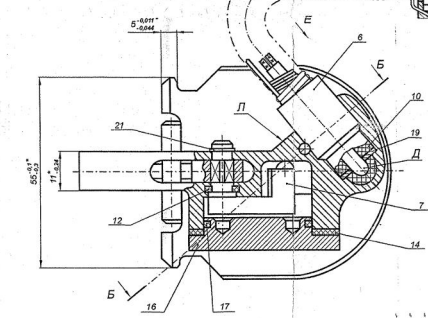
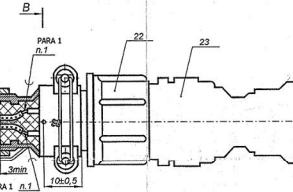
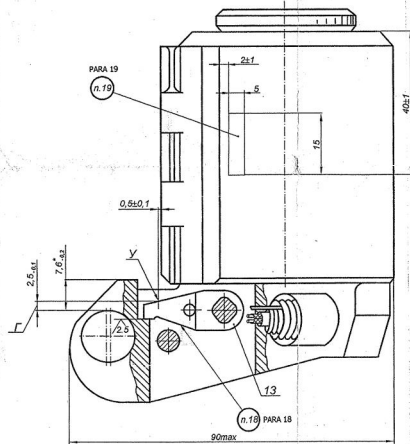


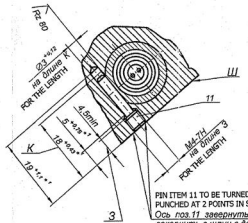
LENGTH OF SHIELDED HOSE WITH PLUG ITEM 22 FROM PLANE П TO POINT MAX
Длина бронешланга с вилкой поз.22 от плоскости П до точки макс



SETTING OF INITIAL POSITION OF OUTER LEVER
Установка исходного положения рычага наружного

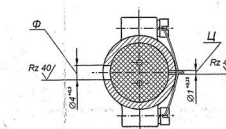


Б-Б

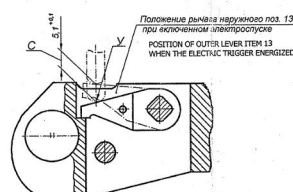


PIN ITEM 11 TO BE TURNED UP TO THE STOP AND PUNCHED AT 2 POINTS IN SLOT
Соп. поз.11 заворачивать до упора и заворачивать в слот в двух точках

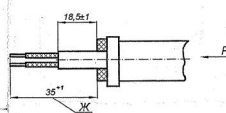
В-В



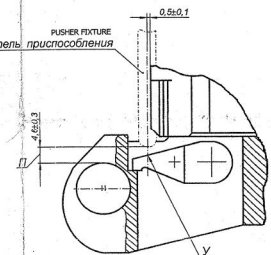
SETTING OF OUTER LEVER MOVEMENT
Установка хода рычага наружного



TERMINATION OF WIRE LEADS
Разделка выводных проводов



ПУШКАРЬ ПРИСПОСОБЛЕНИЯ
Толкатель приспособления



- Soldering should be carried out with solder type KP1.5 ГОСТ 21931-76, with flux ФПСn ГОСТ 470 033.000. It is allowed to use other grade as per ГОСТ 21931-76.
- Dimension for reference.
- Dimensions from plane III.
- Before laying coil item 2, surface "after" of body item 8 and flange item 1 are to be degreased with naphras C 50/170 ГОСТ 8505-80 and to be dried. Surface II of body and surface II of flange are to be lubricated with compound 35-2c OBT B 94-167-90. Lay the coil, while tightening wire leads, damage of tube II is not allowed at the inner side of body.
- Flange item 1 is to be set in body item 8, placing its filling hole H at 120° ±15° relative to hole M. Flare out the flange. Flay of flange is not allowed. Excess compound is to be removed.
- Heat the electric starter to temperature 313K±5K(40°C±5°C). Set it at an angle of 45° with hole on upward. Fill the compound 35-2c through hole H gently till the compound is visible in hole M, after which holes M and H are to be closed with technological plug. It is allowed to fill the electric starter before filament of cover item 5.
- Lead wire should be inserted in to reinforced hose item 6 and fit the funnel of shielded hose in to the body item 8. Drilling of hole for pin item 11 should be carried out when the turner is present along pointer E maximum.
- Inner cavity of plug item 22 should be filled with sealant Vksin Y-1-18 TY38.303.04-04-90 through hole Ф till the sealant is visible through hole II.
- To the length X termination of wires should be carried out when pressing along pointer P to the rope of shielded hose item 6. Residual wires after soldering plug to fork item 22 should be arranged to shielded hose.
- Sealing ring item 12 before setting lever item 7 be lubricated with thin layer of lubricant MC-70 ГОСТ 9762-76.
- Dimension C is to be ensured by machining plane T of pusher item 3. To be checked in fixture П-004.
- Before setting the cover of body item 16 gasket item 17 to be lubricated with thin layer of lubricant MC-70 ГОСТ 9762-76. Presence of local tears and damage of gaskets are not allowed.
- Before setting cover item 5, threads of cover and flange are to be degreased with naphras C 50/170 ГОСТ 8505-80 and to be dried. Threads of flange is to be lubricated with thin layer of compound 35-2c and rotate the cover by hand fully.
- Screw item 18 should be locked by putty 0Н-00-10 ГОСТ 28379-89 along threaded parts and from the side of bolt head.
- Finally assembled electric trigger should be heat treated at a temperature 333K±10K(60°±10°) for 8 hours. After which cool it to normal climate conditions.
- Traction force of electric trigger measured in point Y at voltage 24V±10% on contacts of plug connector should be not less than 352.0N (36 Kgf). Checking should be carried out when setting the pusher of fixture П-0003 along dimension П1. Value of shifting of weight need not to be checked.
- Continuous operating time of electric trigger when operating along Point II,16 should not exceed 1 minute.
- Dimension Γ should be ensured by machining outer lever item 13. After machining mark serial no. of electric trigger by type 3-П3 ГОСТ 28.009-85 by punching. Coating of lever - Cr12, inner surface - Chemical, phosphating and accelerated oil finishing.
- Mark the serial no. of electric trigger by punching method by type 4-П3 ГОСТ 28.009-85.
- Other technical requirement should be as per 8415 TY.

CERTIFIED CORRECT COPY OF APPROVED DRAWINGS AT THIS DATE
09.10.2020
Designed in Drawing Office Ordanovsk Factory, Irkutskregion-Ill-620038
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8415 c6 CB		Doc Code	Form No.	Blot
ELECTRIC TRIGGER ASSEMBLY DRAWING		U-05-1-4	14	12
SCALE SHEET	REFERENCE	Weight (kg)	Scale	
APPROVED		1.878	2:1	
CHECKED		Page	Page total	
DRAWN			1	
HEAVY VEHICLES FACTORY AND				