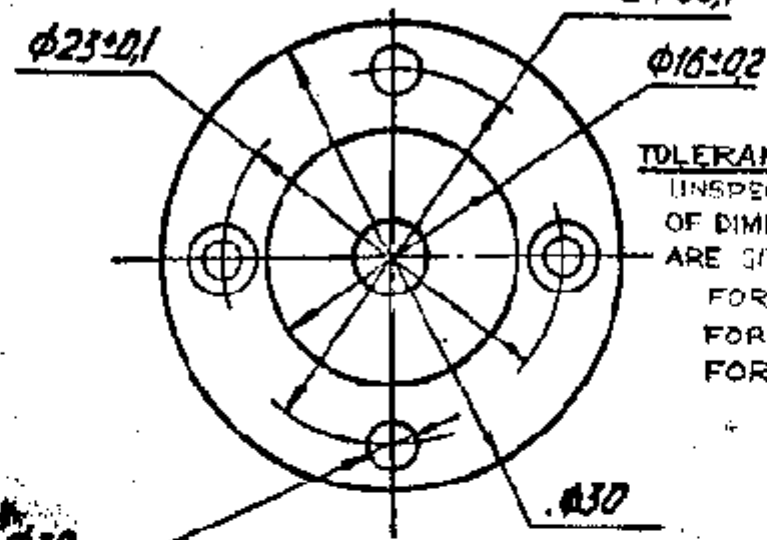
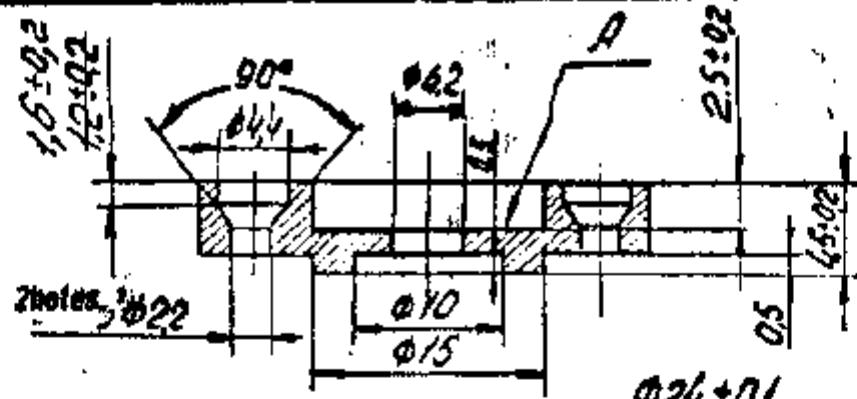


858 050 376

A-10

853 727 184

87 405 146



TOLERANCE
 UNSPECIFIED LIMIT DEVIATIONS
 OF DIMENSIONS OF A7, B7 & CM7
 ARE GIVEN BELDW
 FOR HOLES - A7 - H14
 FOR SHAFTS - B7 - h14
 FOR OTHERS CM7 - js14

GD
D-131

REFER TO DRG No 858.055.377 FOR EXPLANATORY NOTES.

1. Rounding-off radii are 0,3mm.
2. Coating: chemically oxidized, parkerized.
3. Appearance of casting should correspond to OST 470.021.192.
4. When some moulds are available, use distinctive indies, 0,5mm high, on surface A.
5. Unspecified limit deviations of dimensions are as follows for holes - as per A7, shafts - as per B7, others - as per CM7.

SURFACE FINISH - REPRESENTS SURFACE FINISH TO BE OBTAINED BY WITHOUT REMOVAL OF MATERIAL
 IN THE CASE OF DIMENSIONS IN THOSE SURFACES WHERE SURFACE FINISH IS SPECIFIED

Имя и фамилия
Подпись и дата
Имя и фамилия
Подпись и дата
Имя и фамилия
Подпись и дата
Имя и фамилия
Подпись и дата

СНО	СHEET	DOCNO	SIGN	DATE
DRAWN BY	P.R.BABU			13.4.58
EDITED AND CHECKED BY	P.K.SHN			14.4.58
FOREMAN OF DC	S.R.NAR			
DIVISIONAL OFFICER	A.K. RAMU			24.4.55
	NAME	SIGN	DATE	

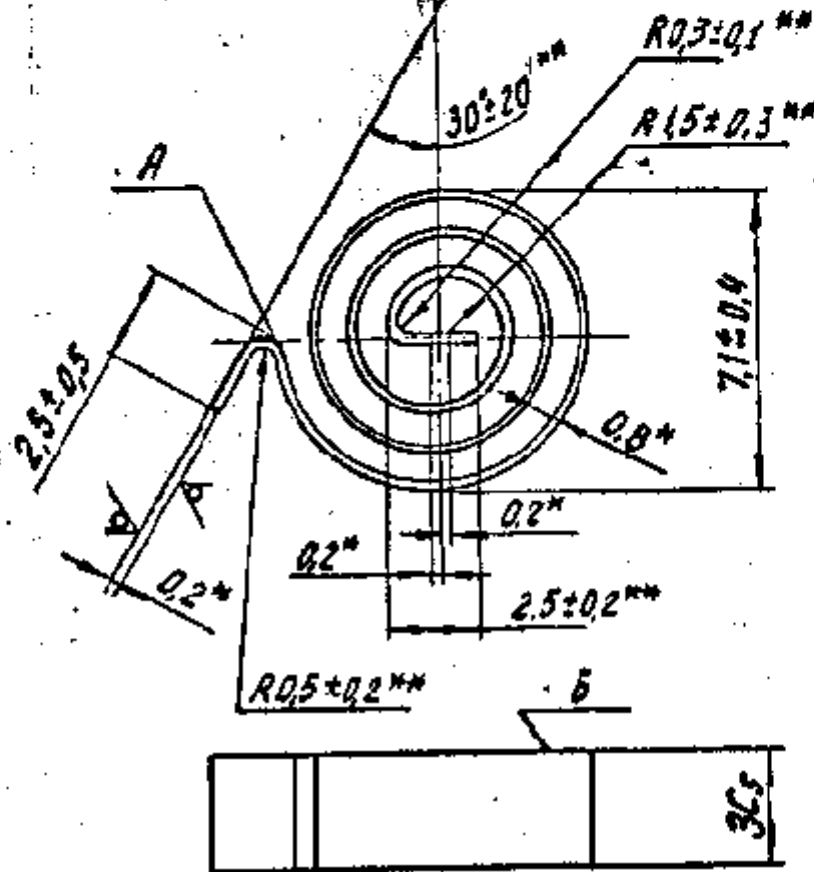
R. VEERARAGHAVAN
 858 050 376
COVER.
 SHEETS WEIGHT SCALE
 6 | 5,42 | 2:1
 TOTAL SHEETS
 Alloy A12
 GUST 2685-75.

3-1-A4

100'986'899

Rz40 (✓)

656.674.737



68
D-131

1. * Dimensions are given for reference.
2. ** Dimensions are provided with tools.
3. Number of coils of spring in free state - 3.
4. Deflection off end of spring A from axis may be within the limits of $\pm 30^\circ$.
5. Temper the spring ends over the length of 4mm to obtain strength group 1.
6. Projection of coils beyond plane B should not exceed 0.15mm.
7. Coating: Chemically parkerized, varnish K0.965, GOST15030-78

656.674.737

CIFE, PUNE

B58.386.001

SN	SH	DOC NO	SIGN	DATE
DRAWN		PRASAD		12.4.85
ED/CHKD		D. A. JAIN		19.4.85
F/M, DC		SR. NAIR		
DIV. OFFR		A. K. KUNDU		25.4.85
		NAME	SIGN	DATE

SPRING

Band Y9A-2 П-С-0.2
GOST 21996-76.

SHEET		WEIGHT	SCALE
5		0.212	5:1
TOTAL SHEETS			

3-1-A4

858.652.218

1:40
V(V)

Первич. проект
858.652.218

Справочный №

№

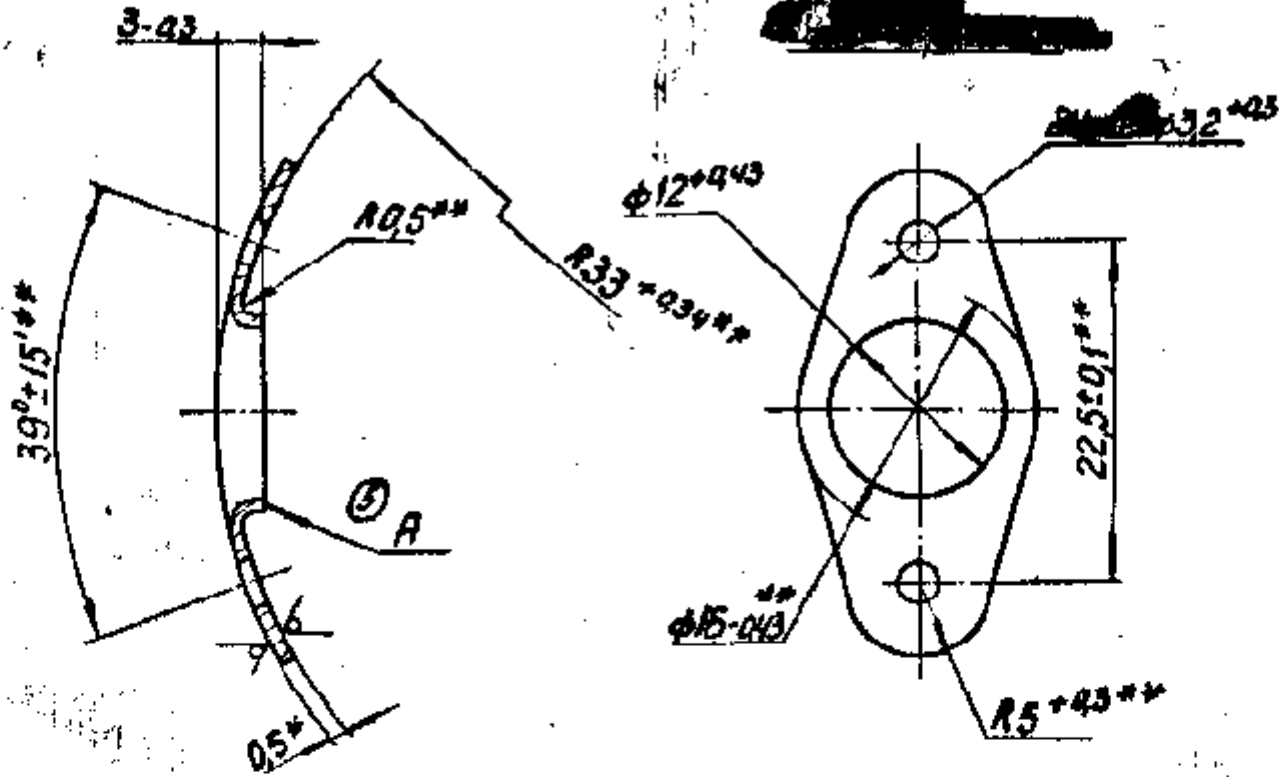
Коды и дата

№

№

№

№



70
D-131

1. ** Dimensions are provided with tools.
2. * Dimension is given for reference.
3. Coating: Copper-plated, 3microns thick, tin-bismuth (99.7) alloy-plated, 6microns thick.
4. Not more than 5 ruptures, not exceeding 2mm in length, are allowed on surface A.

FOR EXPLANATORY NOTES REFER TO DRG NO. 858-332-118

ECKA

(R VEERARAGHAVAN)
SIO II

GJEE, PUNE

RRR 652 218

SN	SHI	DOC NO	SIGN	DATE
DRAWN		PRASAD		12.4.85
EDT/CHKD		DK SHIN		18.9.85
F/M, DC		S.R. NAIR		
DIV. OFFR		A. K. KUNDU		26.4.85
		NAME	SIGN	DATE

UNION

SHEET	WEIGHT	SCALE
6	432	2:1
TOTAL SHEETS		

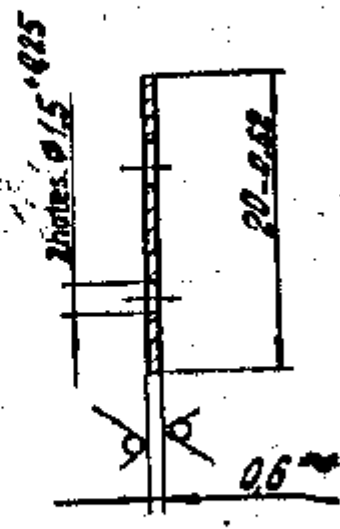
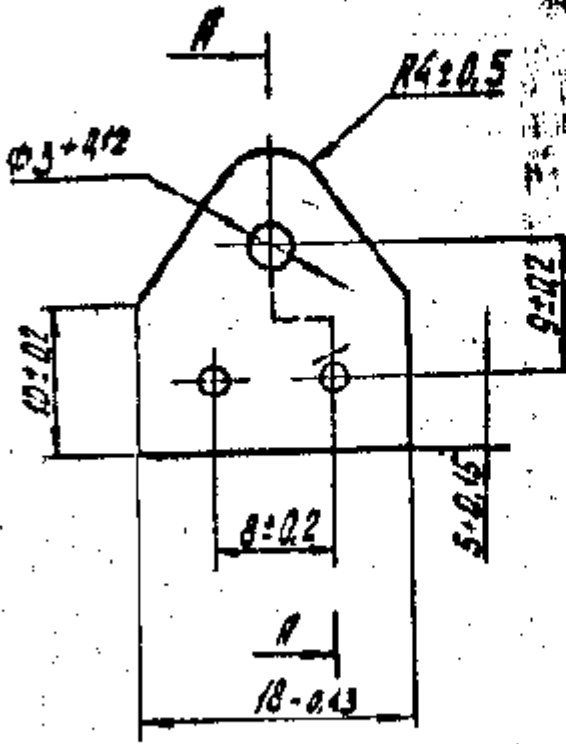
Sheet 5-ПН-0.5, GOST19904-74.
3-П-10Kn GOST16523-70.

Копировал

Формат 11

3-1-AA

858 669 103



1. *Dimension is given for reference.
2. Dimensions are provided with tools.
3. Coating: Zinc-plated, 6 microns thick, chromated.

"FOR EXPLANATORY NOTES REFER TO DRG NO. 858-332-118"

(Signature)
R VEERARAGHAVAN
=S0E

10S
D-131

ECKA

SINO	SHEET	DOCNO	SIGN	DATE
DRAWN BY		P.R.BABA		12.4.85
EDITED AND CHECKED BY		A.H. Srinivas		5.4.86
FOREMAN OF DC		S.R.NAR.		
DIVISIONAL OFFICER		AKKUNDA		16.4.85
NAME		SIGN	DATE	

LUG.

858.669.103

SHEETS	WEIGHT	ST
5	1.50	
TOTAL SH		

Sheet 6-TM-0.6 GOCT 19904-74.
• 3-II-10KII GOCT 16523-70.

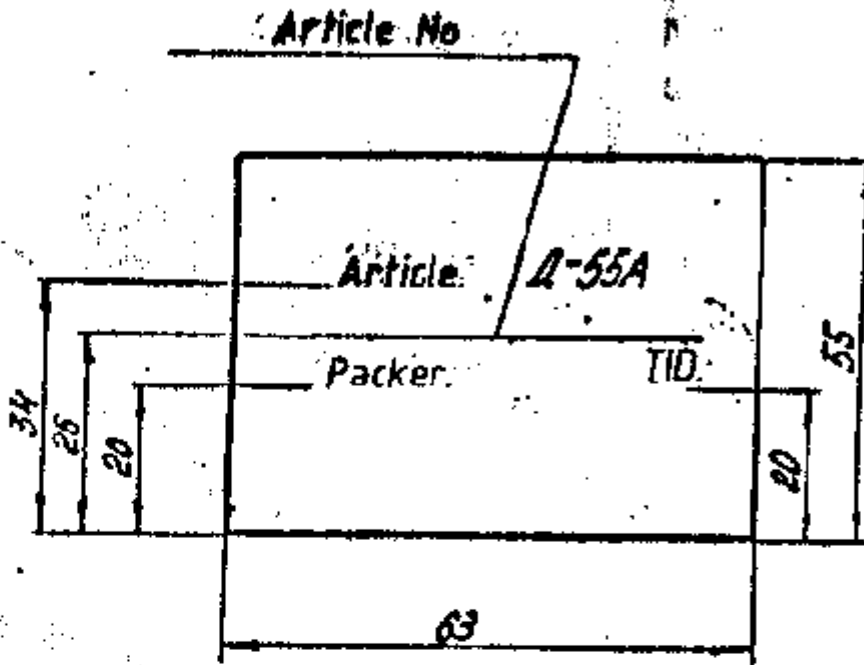
854.71.862

137721 15.05.79

3-1-A4

858.825.636

AB: 1-0-139



Tags may be made by photo-copying method on photographic paper 6 kop C, GOST 250-78.

110
D-131 **ECKD**

51	NO SHEET	DOCH	SIGN	DATE	TAG	858.825.636
	DRAWN BY	P.R.BABL		12.4.05		
	EDITED AND CHECKED BY	S.A. SLEKOV		12.4.05		
	FOREMAN OF DC	S.R.NAR.				
	DIVISIONAL OFFICER	A.K.KUNDU		11.4.05	Letter press paper GOST 21444-75.	SHEETS WEIGHT SCALE
		NAME	SIGN	DATE		5 0.03r 6.1
						TOTAL SHEETS

CITE PUNE

A-55A

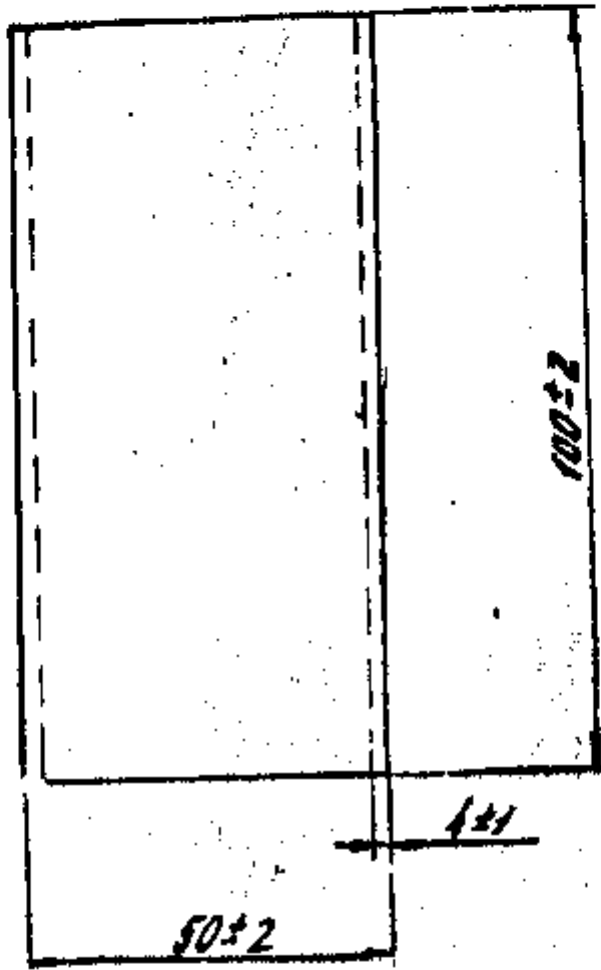
ГОСТ 250-78

Формат: 11

3-1-A4

858.840.041

Development 50x200



112
9-131

Seal seams by fusing.

FOR EXP. LABORATORY NOTES REFER TO DRG NO 858.840.037

(R VEERARAGHAVAN)
SC-1

S/NO	SHEET	OCNC	SIGN	DATE
DRAWN BY	R. BABU			12.4.85
EDITED AND CHECKED BY				
FOREMAN OF DC	R. NAIR			
DIVISIONAL OFFICER				
	NAME	SIGN	DATE	

COVER FOR BRUSHES.

Polyethylene
tape 0,06 GOST10354-78

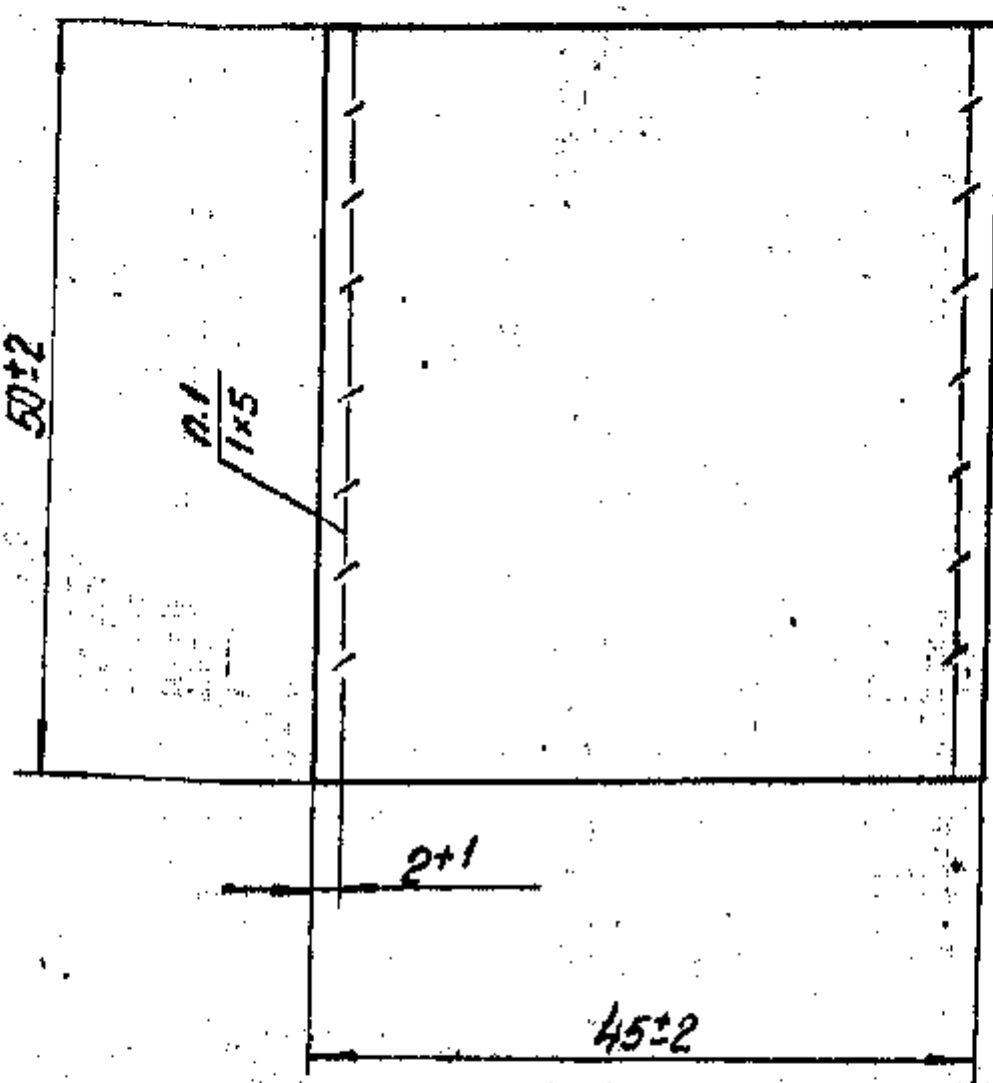
858.840.041

SHEETS	WEIGHT	SCALE
5	-	1:1
TOTAL SHEETS		

CIFE PUNE

100 898 898

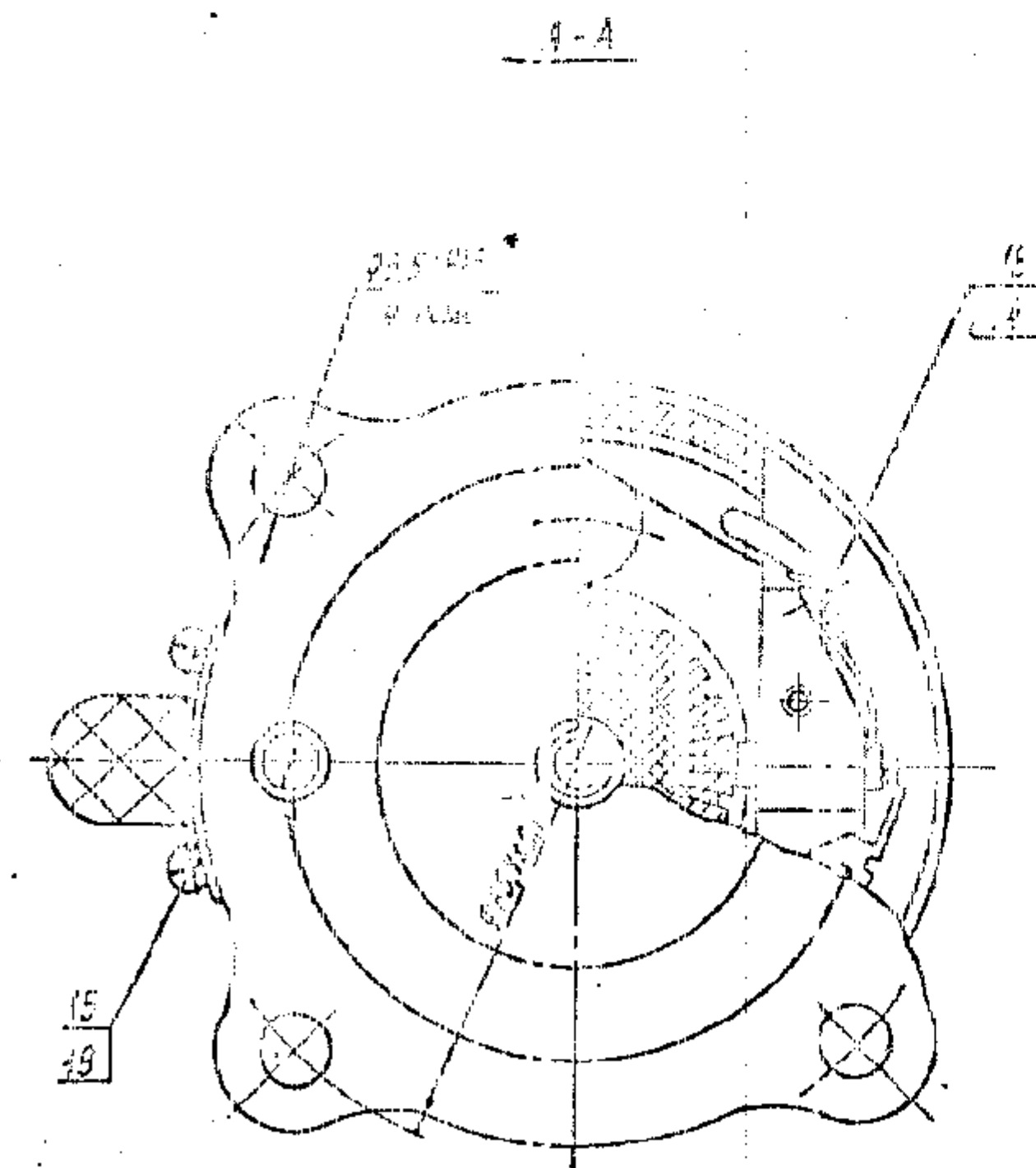
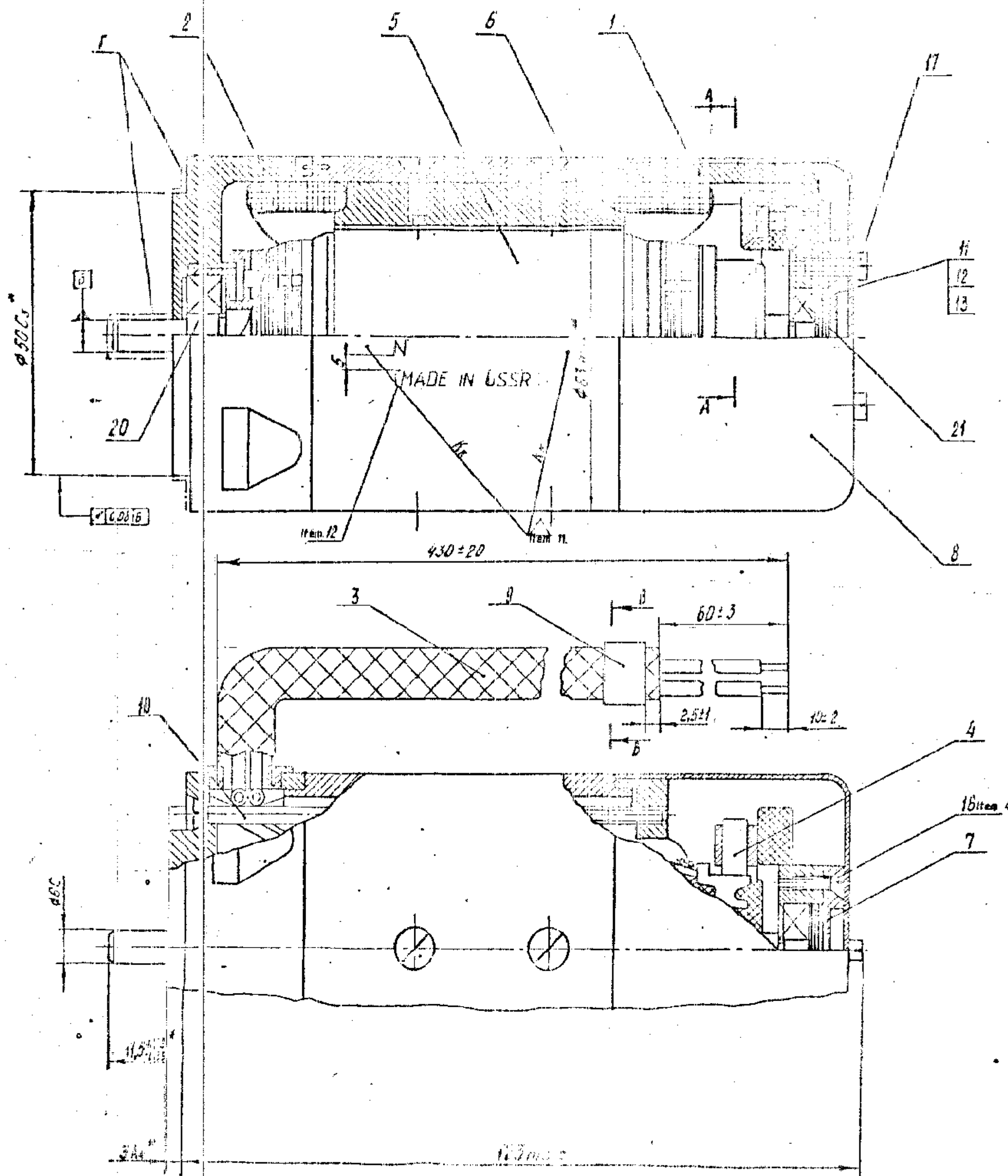
Development 45 x 100



73
0.31

1. Cotton thread 00, GOST 6309-73.

SLNO	SHEET	DOCNO	SIGN	DATE	BAG.	858. 863. 001		
DRAWN BY	P.R.DABU			27.4.85		SHEETS	WEIGHT	SCALE
EDITED AND CHECKED BY	A.B. Srinivas			54.11.85		5	-	21
FOREMAN OF DC	S.R.NAR.					TOTAL SHEETS		
DIVISIONAL OFFICER	A.K.KUNDU	AK		26.4.85				
	NAME	SIGN	DATE	Cotton coarse calico, GOST 11680-76.				
				GIFE, PURE				

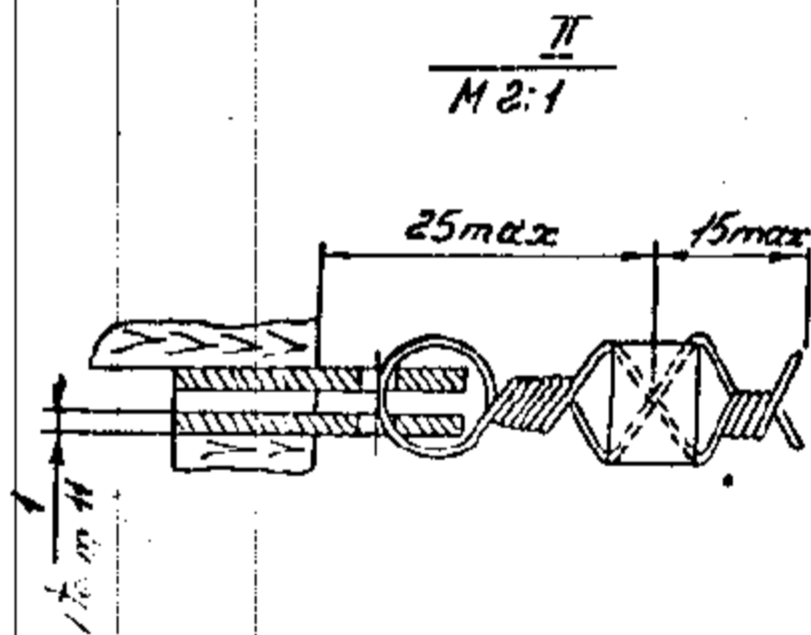
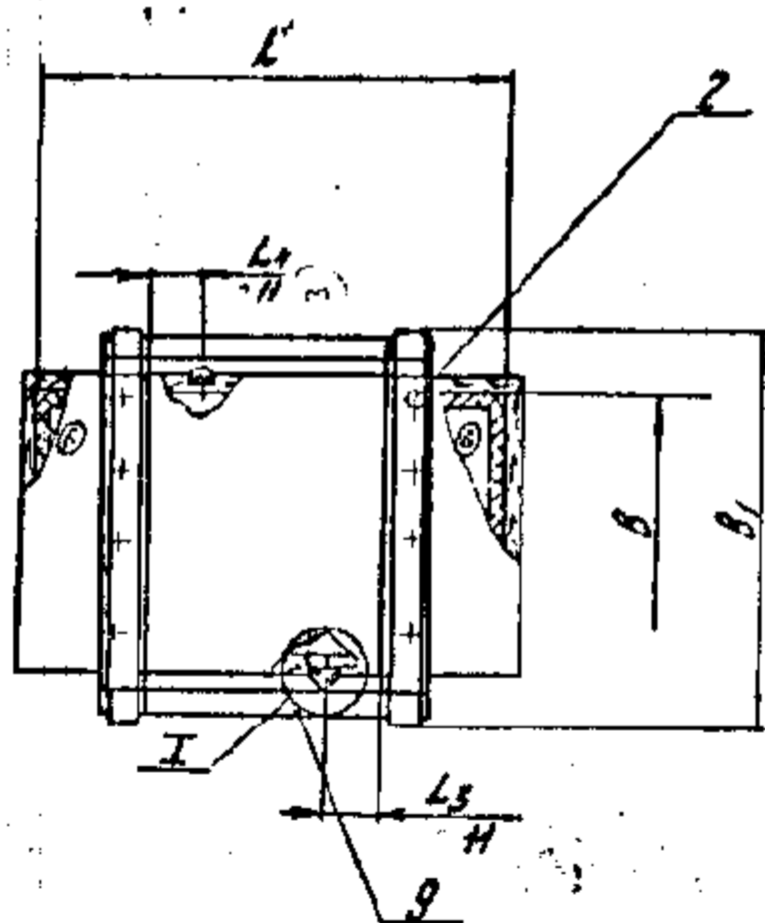
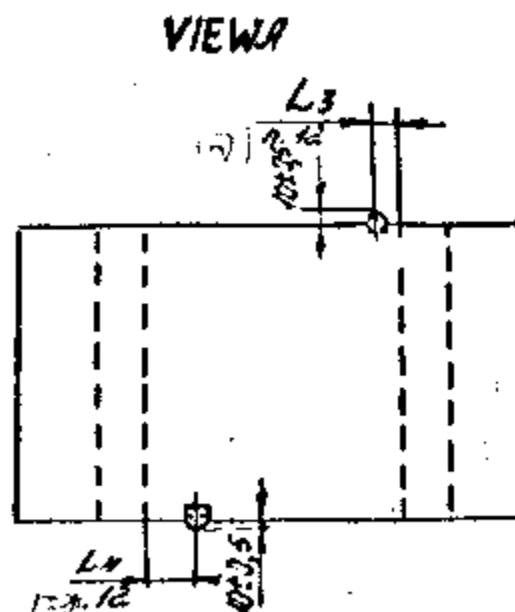
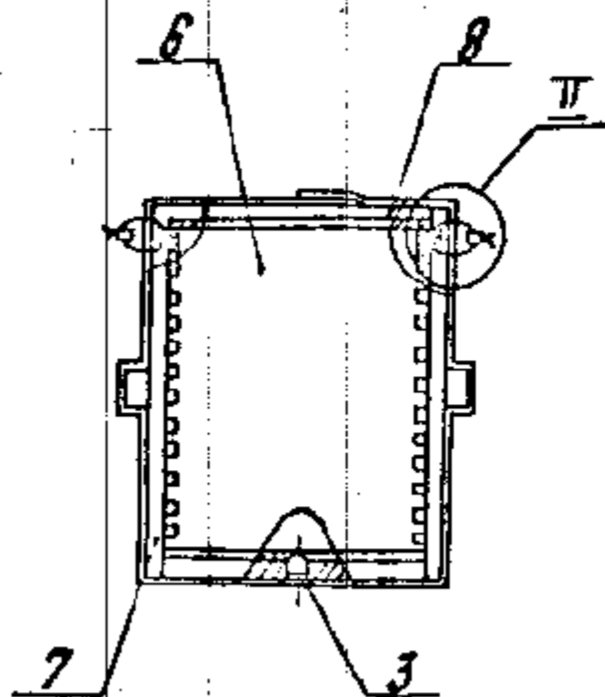
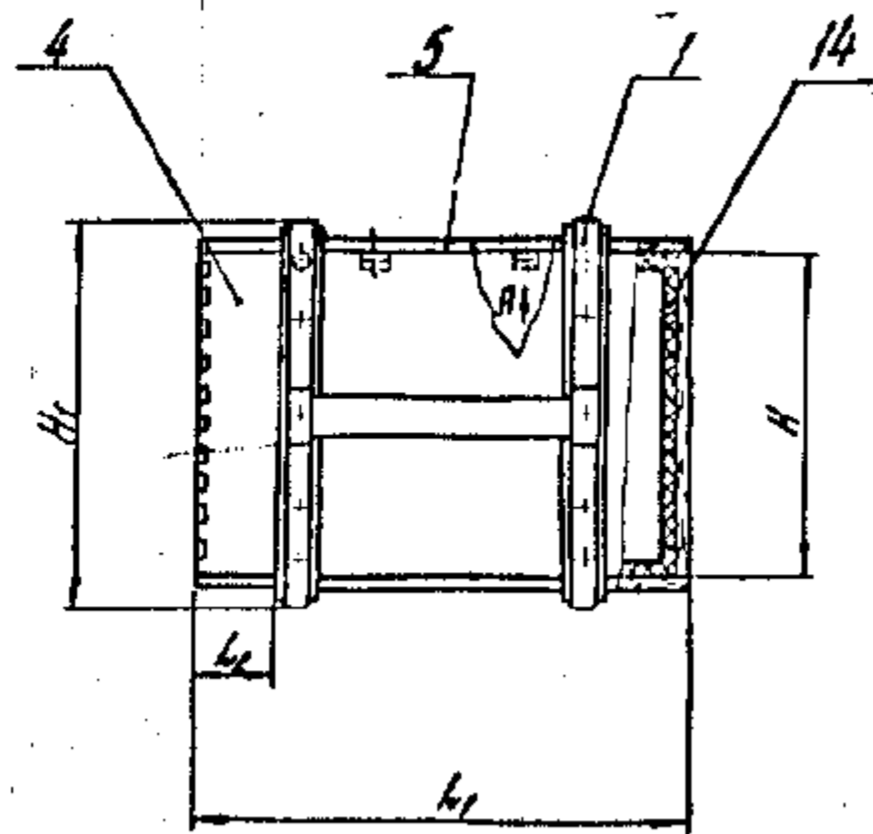


1. Dimensions are given for reference.
2. Pack bearings, Ref.No. 23, with grease (GOST 9433-60, in amounts of 0.17 to 0.18g, and bearing, Ref.No. 21 with grease in amounts of 0.572 to 0.658 g.
3. Coat the shaft with stator, Ref.No. 12 and stator, Ref.No. 6, with thin layer of grease (GOST 9433-60).
4. Secure the screws (Ref.No. 15) with green grease (GOST 9433-60, Ref.No. 21 with Ref.No. 15 - max 0.1g).
5. The drawing (Ref.No. 15) should be placed in the hole of head of screw (Ref.No. 15).
6. Contact of brush (Ref.No. 14) should be placed in the slot of brush holder.
7. Adjust arrestance and play with its limits of 0.1 to 0.2mm with washers, Ref.No. 11, 12, 13.
8. Coating of surface P1 grease (GOST 9433-60).
9. Electric-motor should supply with 353.121.121 TS.
10. Apply the serial number of the article with marking paint MK30, GOST 410.054.205, use type 40-3, GOST 2930-62.
11. Apply 10D stamp on the left side of article serial number and customer representative stamp on the right side of it with silver marking paint as per B00045.999 T-4.
12. Apply inscription made in USSR by off set printing method using marking paint 6M T929-02-05-72 and type 40-3, GOST 2930-62, arranging it symmetrically to article face only while manufacturing the article for export if the corresponding requirement is given in zakaz-namoz.
13. Do not apply customer representative stamp while manufacturing the article for export.

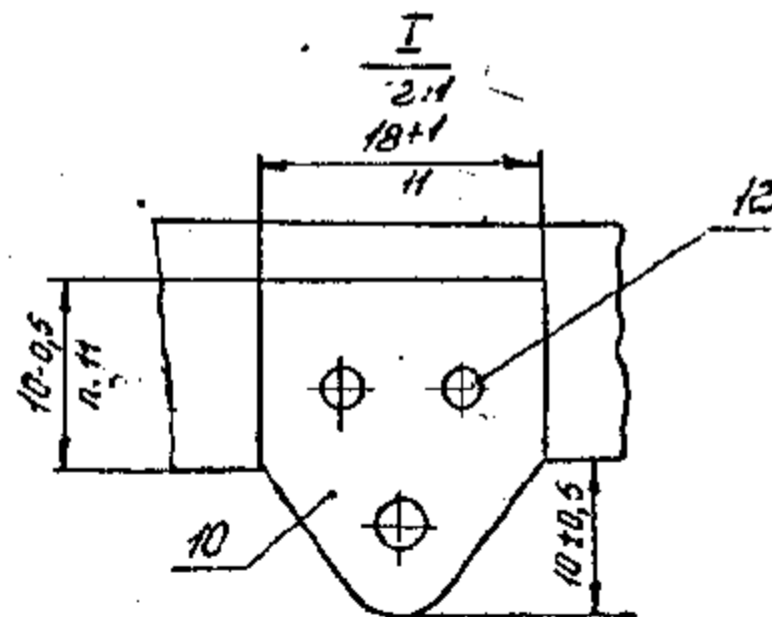
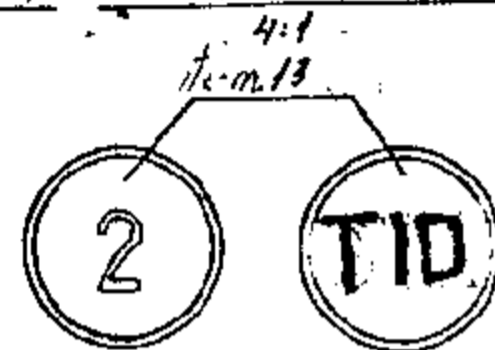
B-5



ДИП. ТЕХНИК. Ч. 1
 653 121.020
 Ч. 1
 653 121.020



Example of imprint on seal



- 1) Box should be made of soft wood, not worse than grade II plywood of grade K with a humidity not more than 15%.
- 2) Assemble the side walls using casein glue, of GOST 3056-74. Bottom and planks are to be secured with casein glue and nailed with nails, Ref. No. 2, at a spacing 25 ± 5 mm, in so doing, projecting ends of nails are to be bent into wood flush.
- 3) Parts should be planed. Roughness of processed wood should be at least R_z max. 320 R_a max. 200.
- 4) Unspecified limit deviations of dimensions are ± 1.0 mm.
- 5) Paint the box on the outside with enamel Hu 25, GOST 5406-73 in 2 layers and in 1 layer inside colour of paint used for external surfaces of container No. 1 is yellow and that for other containers is green.
- 6) Apply inscription onto the container in compliance with ~~GOST 14192-77~~ using indelible black paint MK-74, OST 4ГО.014.002 and type no-20, GOST 2930-62.
- 7) Packing box should be secured with steel band. Band is nailed with nails, Ref. No. 3.
- 8) Mark signs BHK, OX and bc as per GOST 14192-77. Sign No. 2 is used.
- 9) Warning signs should be placed at the left upper corner on two adjacent walls of the container.
- 10) Before assembling the box make recesses with dimensions as per drawing in parts, Ref. No. 4 (2pcs).
- 11) Secure rugs, Ref. No. 10, on box cover, Ref. No. 5, (1 piece), aligning them with lugs on the box.
- 12) Squeeze seals, Ref. No. 11 the following imprints should be present on the seal. On one side - "TID" on the other side - TID representative No. Use type no-25, GOST 2930-62. Profile $h = 0.3$ to 0.5 mm. Imprint on the seal is to be coated with varnish AK-113Ф, GOST 23832-79, two times.
- 13) Internal surfaces of the container is to be lined with packing paper, Ref. No. 14.

Designation	L	L1	L2	b	B1	H	H1	Box Marking	L3	L4
854.171.065	450	470	117	320	420	230	290	1	30	50
854.171.065-01	530	550	137	375	475	320	380	2	30	50

96 ECKD
D.134

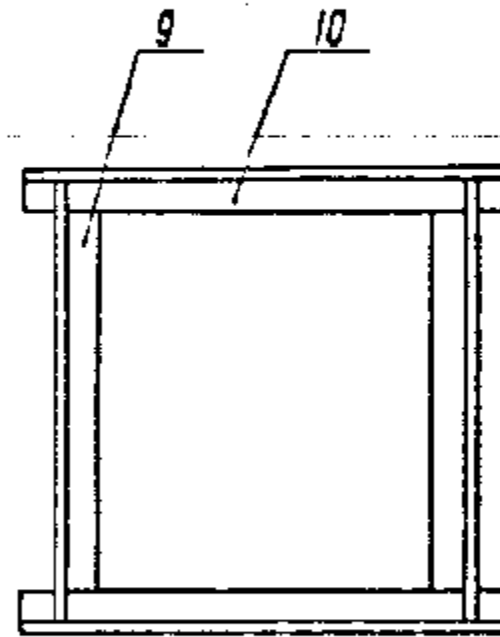
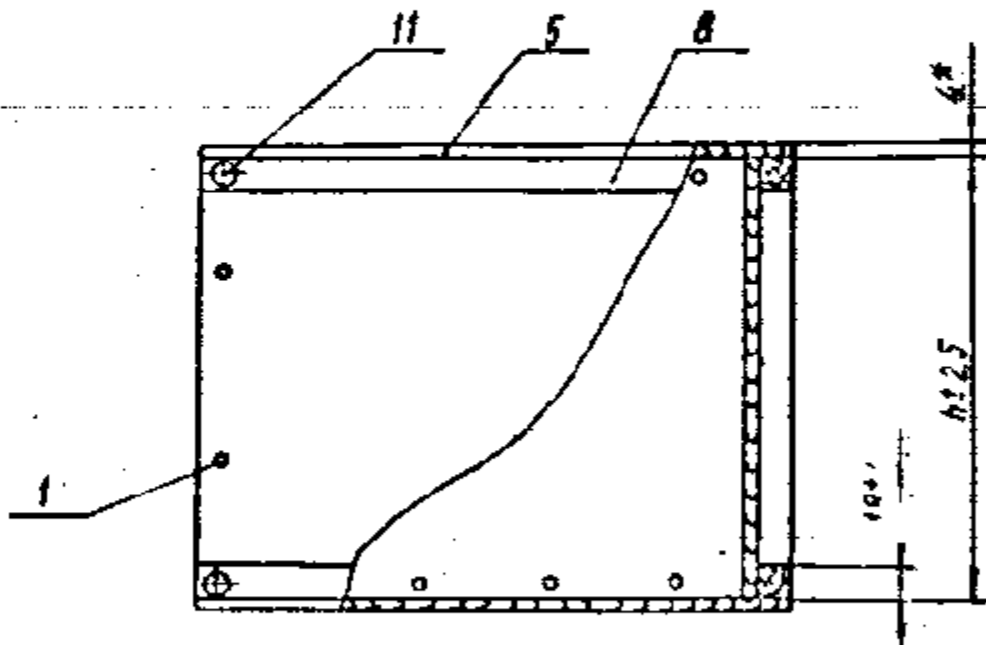
854 171 065 C6

DESIGNER	Y.R. Ganesh	DATE	
CHECKED		DATE	
APPROVED		DATE	
NAME		SIGN	
		DATE	

EXPORT WOODEN BOX
CONTAINER PACKAGE
(Assembly Drawing)
CIF, PUNE

SHEET	WEIGHT	SCALE
5		
TOTAL SHEETS		

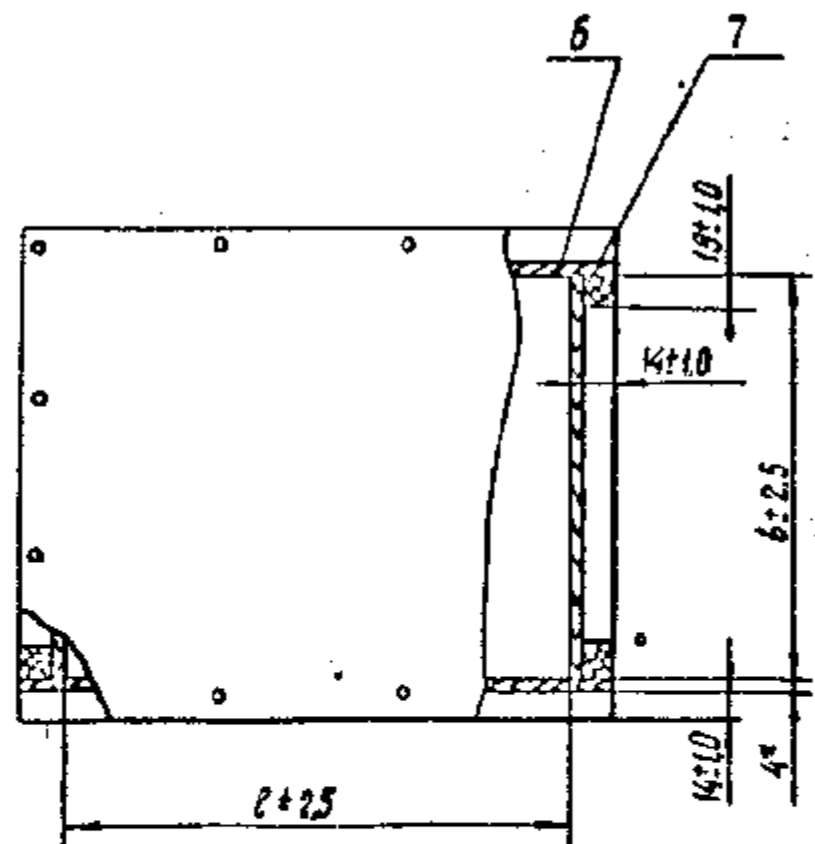
854.171.067



1. *Dimensions are given for reference.
2. **Dimension is provided by tools.
3. Absolute humidity of wood planks should not exceed 20% , and that of ply wood should not be more than 15%.
4. Roughness of plank surfaces should not be more than Rz max 800 , GOST 7016-75.
5. Limit deviations of dimensions are as follows:
For length of planks -2mm,
for length and width of plywood ± 2.5 mm.
6. Parts of the container are secured with nails, Ref.No.1, at a spacing of 40 to 60mm. in amounts of not more than 4 pieces on one side of the plank
7. Mark signs BHK- 1, OX-1, 6C-1 as per GOST 14192-77, the left upper corner of two adjacent side walls of the container using black enamel HLJ-25. GOST 5406-73.
8. Internal surfaces of the container are to be lined with packaging paper, Ref.No.3.
9. Install cover, Ref.No.5, while packing.
10. Projecting ends of the nails are to be bent into the plank in one plane.
11. Make-grooves in container ribs in compliance with drawings 1 and 2. Shape of groove arbitrary; dimensions are within the limits specified in removed element II.
12. Twine should enter the grooves when passing the container ribs. Twine should be tightly bound with knot, so that it can't be removed or shifted.
13. Binding ends with a length of 100mm, minimum, should come to the left lateral side of parcel with respect to the address.

See continuation of table on sheet 2.

Designation.	Dimensions, mm						Drawings.
	l	B	h	L	B	H	
854.171.067	204	160	110	240	198	118	1
-01	240	204	170	276	240	178	1
-02	300	230	300	336	266	308	2
-03	314	240	170	350	276	178	2
-04	320	320	100	356	256	108	2
-05	285	235	190	321	271	198	2
-06	445	255	164	481	291	172	2
-07	414	290	190	450	316	198	2
-08	420	210	205	456	246	213	2
-09	490	320	220	526	356	228	2
-10	440	345	190	476	381	198	2



14. The following imprints should be present on seal, Ref.No.2, on one side -"TID", on the other side-TID representative No. Use type П0-2.5, sign M-2.5, GOST 2930-62, concave profile, h=0,3 to 0,5mm.

15. Critical mass of the container with articles packed into it is 10 kgs, maximum.

104
D-131

SINO SHEET	DOCNO	SIGN	DATE	PARCEL POST CONTAINER. PACKAGES. Assembly drawing.	854.171.067 CB
DRAWN BY	P.R.BABU		14.6.85		
EDITED AND CHECKED BY					
FOREMAN OF DC	S.R.NAR.				
DIVISIONAL OFFICER	A.K.KONDU		20-7-85	CIFE, PUNE	
	NAME	SIGN	DATE		

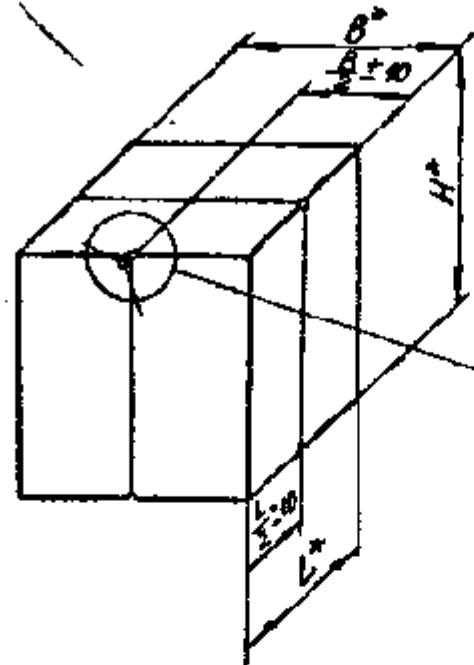
16 | 1 | - | 1
TOTAL SHEET

854.171.067.C5

854.171.067

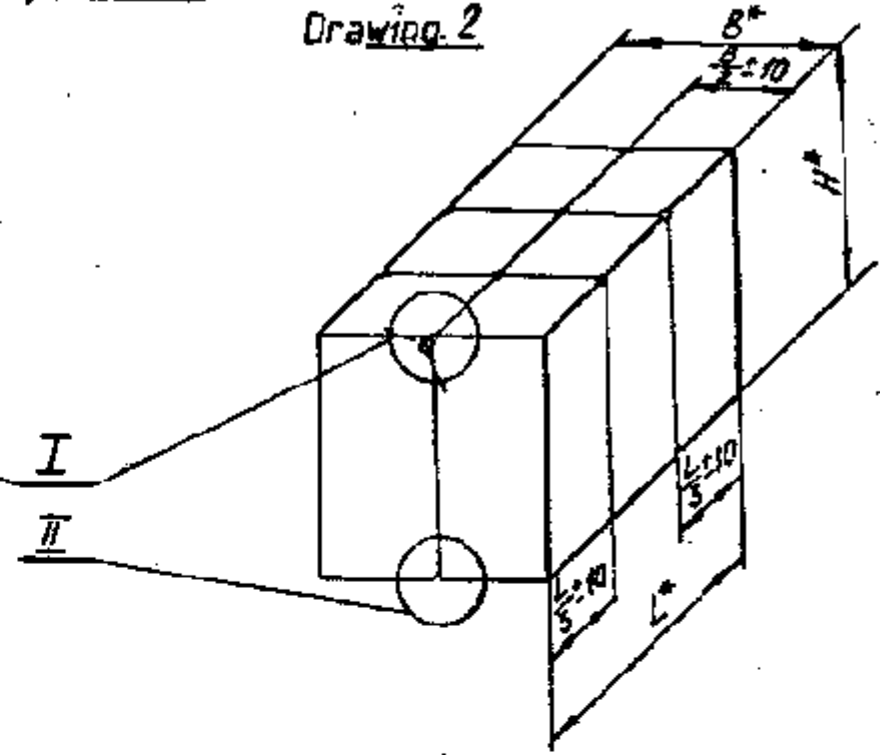
Binding method

Drawing 1



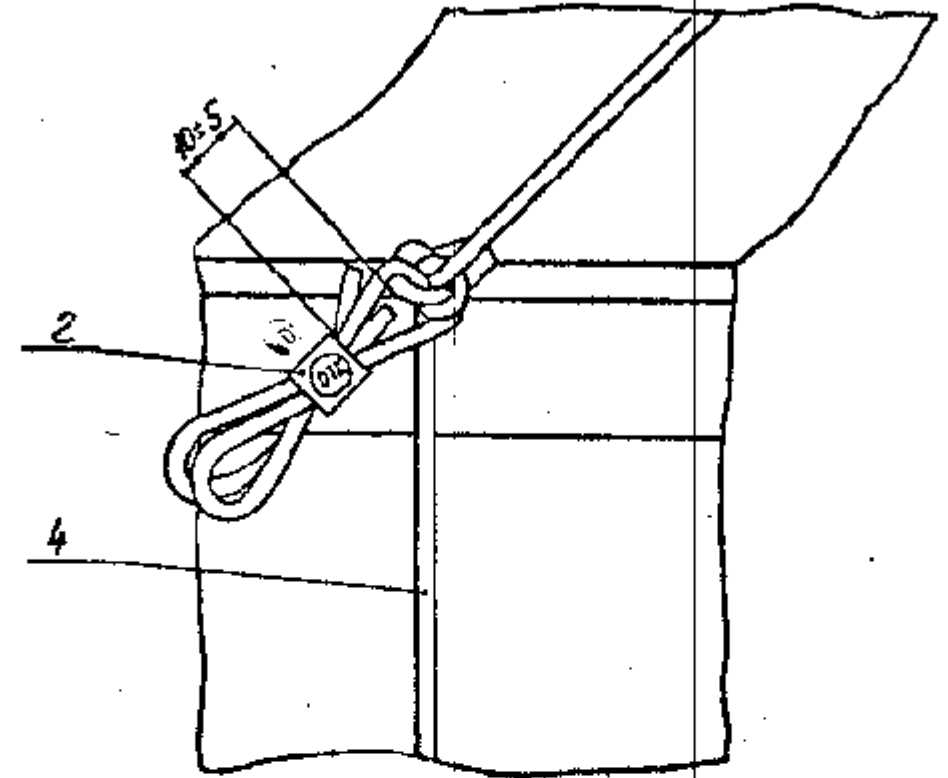
II
M 1:1

Drawing 2

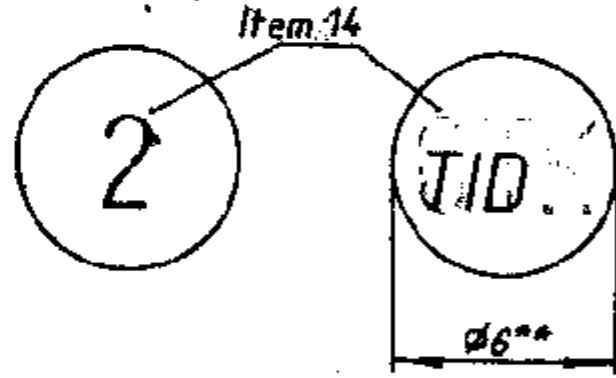
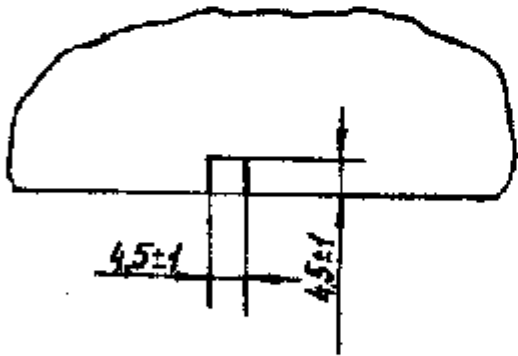


Example of imprint on seal

I
M 1:1



Before placing seal, Ref.No.2, twine ends should be folded as shown in view I.



Designation.	Dimensions, mm.						Drawing.
	L	B	H	L	B	H	
854.171.067 - 11	395	385	155	431	421	163	2

ECKA

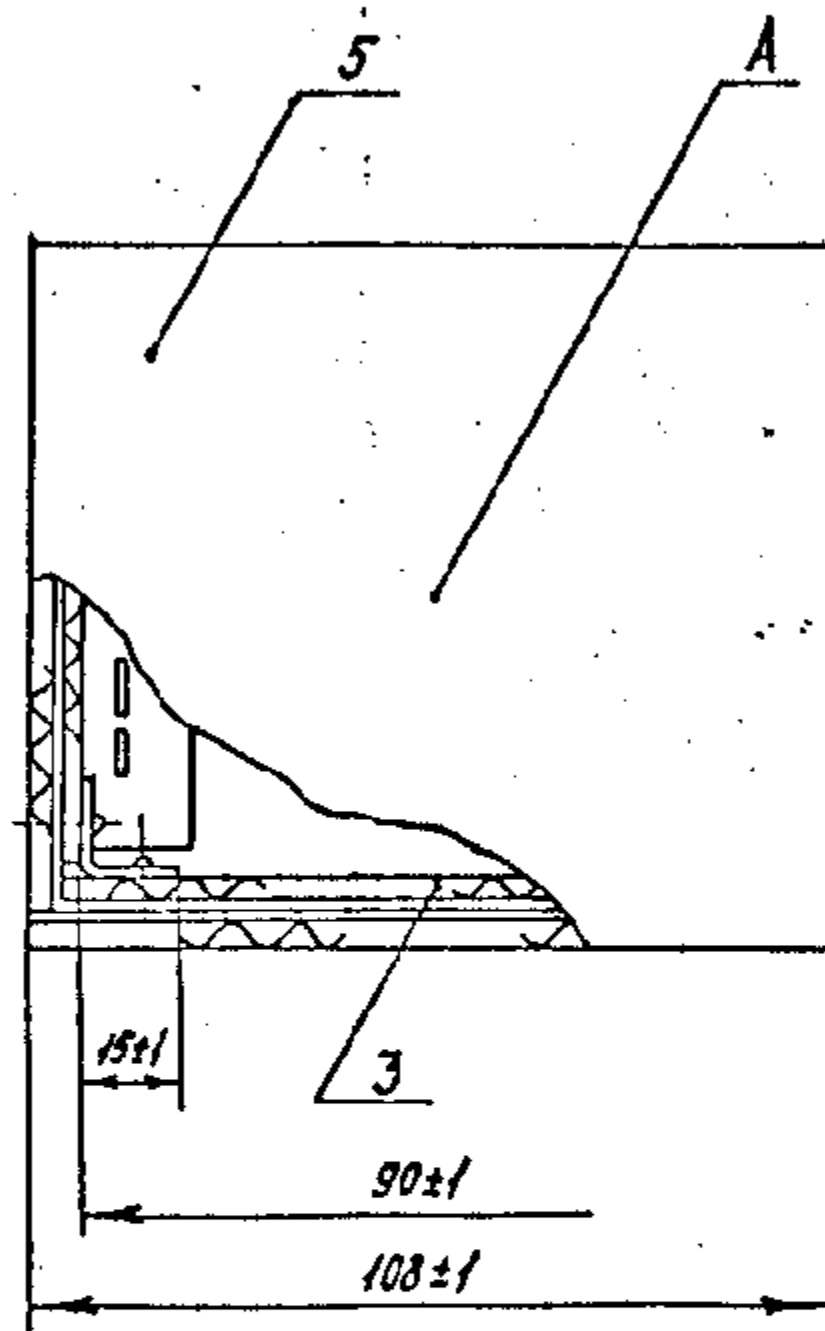
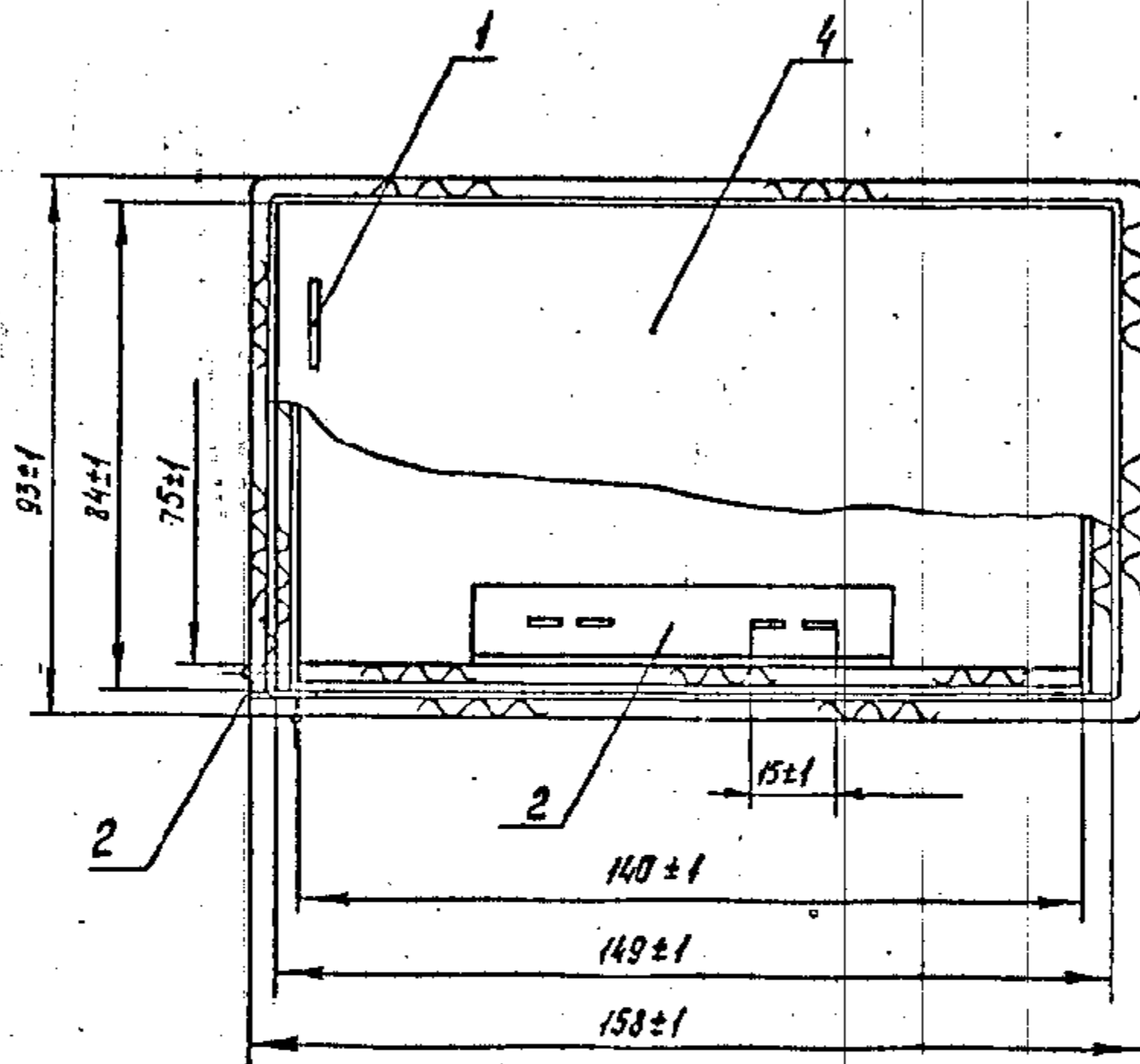
105
D-134

SHEET NO.	DRAWN BY	DATE
	PR.BARE	12.6.55
EDITED AND CHECKED BY		
FOREMAN OF DC		
DIVISIONAL OFFICER		
NAME	SIGN	DATE

PARCEL POST
CONTAINER
PACKAGES
Assembly drawing
CIFE, PUNE

854.171.067.C5	
SHEETS	
TOTAL SHEETS	

1/50798



1. Shape parts, Ref.Nos 3,4,5 by bending at right-angle as per dimensions specified in the drawing.
2. Bend board, Ref.Nos.2, at right angle in the middle of the width and secure with edges of parts Ref.Nos 3,4,5 at four points using wire, Ref.No.1.
3. Stitch board, Ref.No.2, to parts Ref.Nos.3,4,5 at a distance of not less than 5mm from butt -ends of part Ref.No.2, at a spacing of (25 ± 2) mm.
4. After stitching the board bend wire ends.
5. Stick the tag to surface 'A' with starch gum, GOST 6034-74.

107
D-131

ECKA

854.180.139CB

SLNO	SHEET	DOCNO	SIGN	DATE
DRAWN BY		P.R.BABU		12.4.85
EDITED AND CHECKED BY				
FOREMAN OF DC		S.R.NAIR		
DIVISIONAL OFFICER		A.K.KUNDU		12.4.85
	NAME	SIGN	DATE	

UNIT PACK.

Assembly drawing.

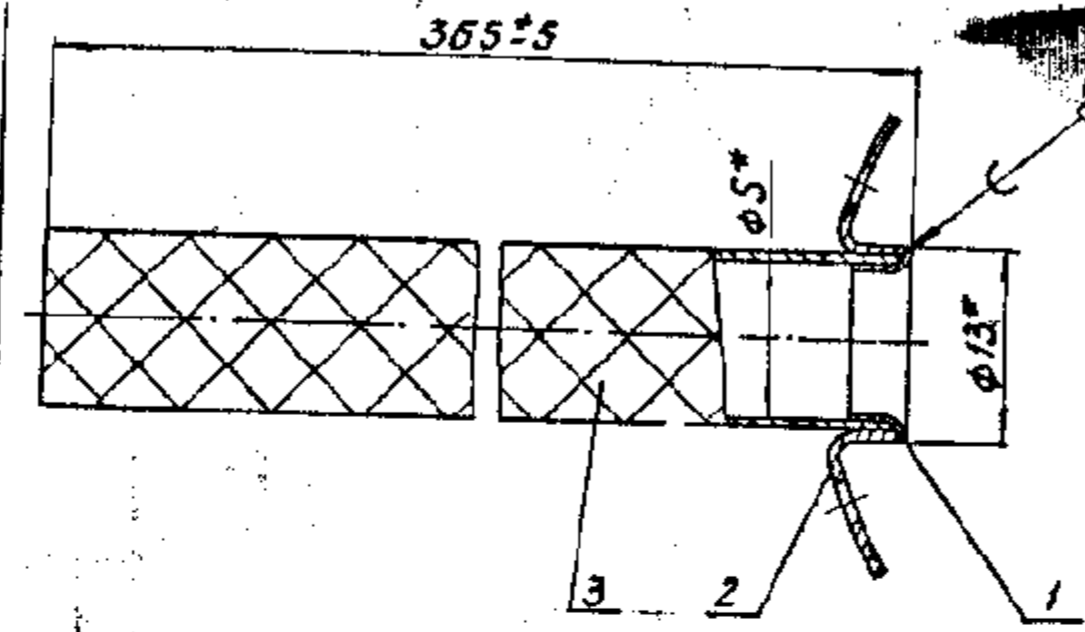
CIFE, PUNE

SHEETS	WEIGHT	SCALE
15		1:1

(TOTAL SHEETS)

866 430 232CB

ПОУКАЗ. ПРИМЕР



1.*Dimensions are given for reference.

2. Coat the soldered joints with varnish Ak-113φ, GOST 23832-79 by tinting them with rhodamine TY6-14-1088-74.

3. noc-40, GOST 21931-76

29/1131

ECKA

866.430.232CB

ИЗМ. № ДОКА.	ИЗМЕН. № ДОКА.	ИЗМЕН. № ДОКА.	ИЗМЕН. № ДОКА.
1	1	1	1
2	2	2	2
3	3	3	3

ИЗМ. № ДОКА.	ИЗМЕН. № ДОКА.	ИЗМЕН. № ДОКА.	ИЗМЕН. № ДОКА.
1	1	1	1
2	2	2	2
3	3	3	3

СHEET/WEIGHT/SCALE	6	25:	2:1
ТОТАЛ SHEETS			

SCREEN ASSEMBLY DRAWING

866 430 232CB

EXPLANATORY NOTES TO TECH. CONDITIONS

I) COAT THE SOLDERED JOINTS WITH VARNISH AK-113φ (GOST 23832-79). VARNISH AK 113φ REPRESENTS SOLUTION OF POLYACRYLIC MELAMINE FORMALDEHYDE RESIN IN MIXTURE OF ORGANIC SOLVENTS WITH ADDITION OF PLASTICIZERS.

II) THE PHYSICO-MECHANICAL PROPERTIES:

DESCRIPTION	NORMS FOR VARNISH	DESCRIPTION	NORMS FOR VARNISH
	AK 113φ - OKT 23-1331-0200-05		AK 113φ - OKT 23-1331-0200-05
1) VARNISH APPEARANCE	TRANSPARENT HOMOGENOUS LIQUID WITHOUT MECHANICAL INCLUSIONS, LIGHT REFRACTION IS PERMITTED	6) VARNISH DRYING TIME HRJ NOT MORE THAN a) UP TO 1ST DEGREE AT 20±2°C b) UP TO 3RD DEGREE AT 80±12°C	05 4
2) VARNISH COLOUR ON INDOOMETRIC SCALE Mq IODINE NOT DARKER THAN	5	7) VARNISH FILM APPEARANCE	SMOOTH COLOURLESS HOMOGENOUS SURFACE WITHOUT PMS AND MECHANICAL INCLUSIONS
3) VARNISH RELATIVE VISCOSITY AC PER VISCOMETER 03-A AT 20±0.5°C	14-22	8) VARNISH FILM HARDNESS AS PER PENDULUM INSTRUMENT M3 STANDARD UNITS, NOT LESS THAN	0-55
4) MASS FRACTION OF NON-VOLATILE SUBSTANCES %, NOT LESS THAN	9-13	9) FILM BENDING NOT MORE THAN	1
5) AQUEOUS EXTRACT ACID NUMBER Mq KOH, NOT LESS THAN	0.1	10) FILM RESISTANCE TO WATER ACTION AT 20±2°C HRS NOT LESS THAN	4
		11) FILM RESISTANCE TO PETROL ACTION AT 20±2°C NOT LESS THAN	1

III) RHODAMIN "C" (SPECN TY6-14-1088-74)

RHODAMIN "C" IS A ORGANIC DYE RHODAMIN "C" AS PER TECHNICAL PROPERTIES, BELONG TO THE GROUP OF BASIC DYES, AS PER ITS CHEMICAL STRUCTURE - TO THE XANTHENE DYE GROUP AND IS DERIVED BY CONDENSATION OF DIETHYLAMINOPHENOL WITH PHTHALIC ANHYDRIDES (FORMULA (C₂₀H₁₆N₂O₃), MOLECULAR WT 344.02)

IV) TINT THE SOLDERED JOINTS WITH RHODAMIN "C" OF TY 6-14-1088-74

PHYSICAL & CHEMICAL PROPERTIES:

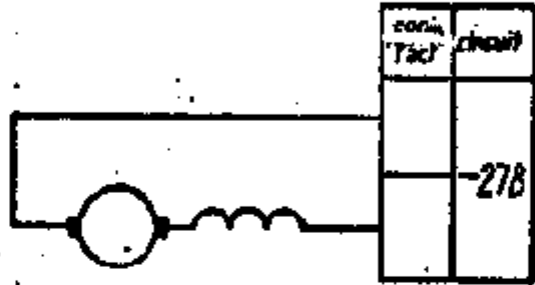
NAME OF THE PROPERTIES	STANDARDS
1) EXTERNAL APPEARANCE	UNIFORMLY CRYSTALLINE DARK RED POWDER A GREENISH SHADE IS PERMISSIBLE
2) CONCENTRATION IN RELATION TO THE STANDARD SAMPLE	100%
3) SHADE	CORRESPONDS TO STANDARD SAMPLES
4) CONTENT OF IMPURITIES INSOLUBLE IN WATER % NOT LESS THAN	1
5) SOLUBILITY IN WATER	5 POINTS
6) RESIDUE AFTER STRAINING THROUGH A FINE WITH GAUGE NO 056K GOST 3584-53 % NOT MORE THAN	5
7) STEADINESS OF COLOUR ON PAPER IN RELATION TO THE ACTION OF LIGHT	CORRESPONDS TO THE STEADINESS OF COLOUR REGULATED BY THE DYE OF STANDARD SAMPLE

V ITEM NO-3 INDICATES SOLDERING ALL ROUND WITH SOLVENTS CI 00-41) GRADE SAHO TO IS 113-82 MENTIONED AT NOTE 3

INSCRIBED	DATE	ORG NOT TO BE SCALED	PERTAINS TO
CHECKED	12.11.85	ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	
APPROVED	12.11.85	ALL DIMENSIONS ARE IN MM. UNLESS OTHERWISE SPECIFIED	
DATE	12.11.85		
TOLERANCE UNLESS OTHERWISE SPECIFIED		SCREEN	866-430-232CB
GEN'L DEC	ANG	SCALE	
D-CO/DY	ZONE	CONTROL DATE OF INSPECTION	FIRE FIGHTING EQUIPMENT

853121020 33

Справочный №
853.21.020



11
D-131

ЕКД

853121020 33

Изм. № 1
11.06.85

Изм. № 2
11.06.85

Изм. № 3
11.06.85

Изм. № 4
11.06.85

Изм. № 5
11.06.85

Изм. № 6
11.06.85

Изм. № 7
11.06.85

Изм. № 8
11.06.85

Изм. № 9
11.06.85

Изм. № 10
11.06.85

NO	SH	DOC NO	SIGN	DATE
0	1	1	N. Yashin	12.6.85
1	1	1	EDT,CHKD	12.6.85
2	1	1	F/M,DC	
3	1	1	DIV.OFFER	
			NAME	SIGN DATE

D.C. ELECTRIC MOTOR.

SCHEMATIC CIRCUIT DIAGRAM

CIFE PUNE

SHEET	WEIGHT	SCALE
1	-	-
TOTAL SHEETS		

856.237.114C6

Исрания, изменения

Серийный №

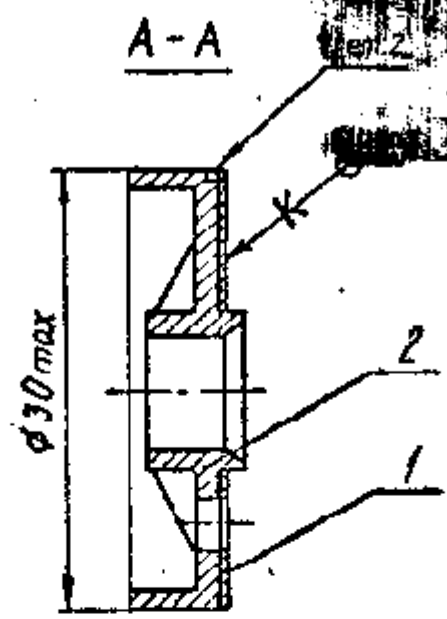
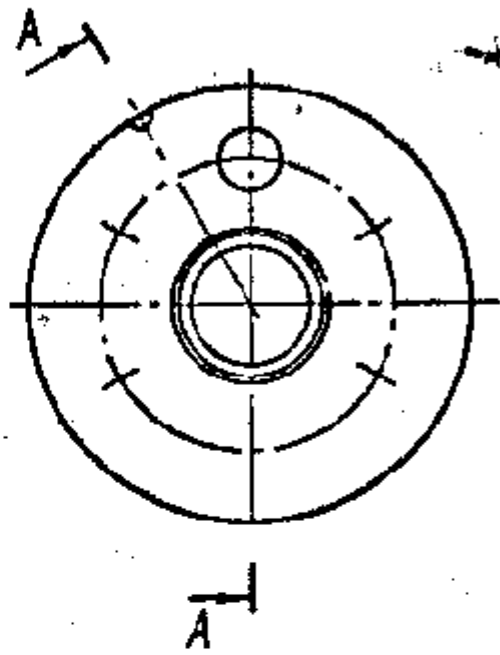
Получено в завод

Иван. X. ydyz

Иван. X. ydyz

Иван. X. ydyz

Иван. X. ydyz



1. Adhesive БФ-4, grade 1, GOST 12172-74.
2. Align the craters.

21
D-131

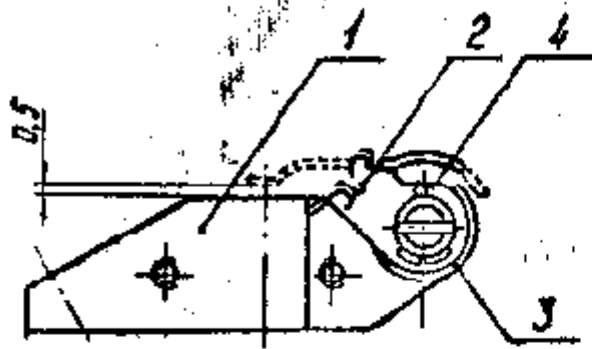
856.237.114C6

№ SHEET	DOC NO	SIGN	DATE
DRAWN	K. G. G. G.		1945
EDT, CHK	D. K. D. M.		1948
F/M, DC	S. R. K. H.		
DIV. OFFR	A. K. K. O. N. D. U.		2045
	NAME	SIGN	DATE

LABYRINTH
 ASSEMBLY DRAWING
 CIFE PUNE

SHEET	WEIGHT	SCALE
5	52	2:1
TOTAL SHEETS		

866.624.037C6



1. Adjust the force of spring, Ref.No.3 by turning the bush holder pin upto the value of $190 \pm 1 \text{ vgf}$ when the clip is set to the position specified with dotted line
2. After adjusting the pin, should be expanded finally and soldered by solder noc-40, GOST 21931-76. Soldered joints should be ground and coated with green enamel k0-822, TY6-10-848-75.

ECKD

35
D.131

866.624.037C6

ENGLISH	DOC NO	SIGN	DATE
DRAWN	A. Yasudas		12.6.85
EDT,CHKD	A. K. Kundu		
F/M,DC	S.R. Nair		
DIV.OFFR	A.K.KUNDU	AKK	24-6-85
	NAME	SIGN	DATE

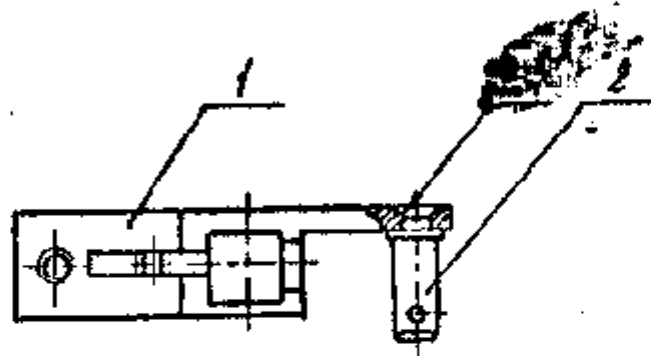
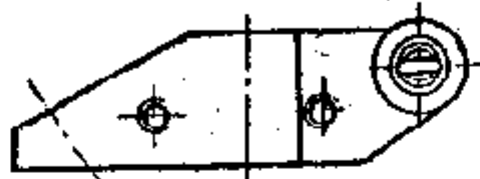
SHEET WEIGHT		SCALE
6.90	2:1	
TOTAL SHEETS		

BRUSH HOLDER
ASSEMBLY DRAWING
CIFE, P11117

3-1-A4-ASSY

856.624.038

856.624.037



36
D.G

1. Expand to provide hard rotation

Ref. No.	Designation	Description	Qty.	Remarks
2	B58.327.261	Pin	1	
1	B67.736.009	Bush-holder	1	

856.624.038

856.624.038

NO	SHI	DOC NO	SIGN	DATE
DRAWN				12.6.85
EDT,CHKD		B. Srinivas	B. Srinivas	12.4.85
F/M,DC		S.R. Nair		
DIV.OFFR		A.K. KUNDU	AK	21.4.85
		NAME	SIGN	DATE

B
BUSH HOLDER
CIFE, PUNE

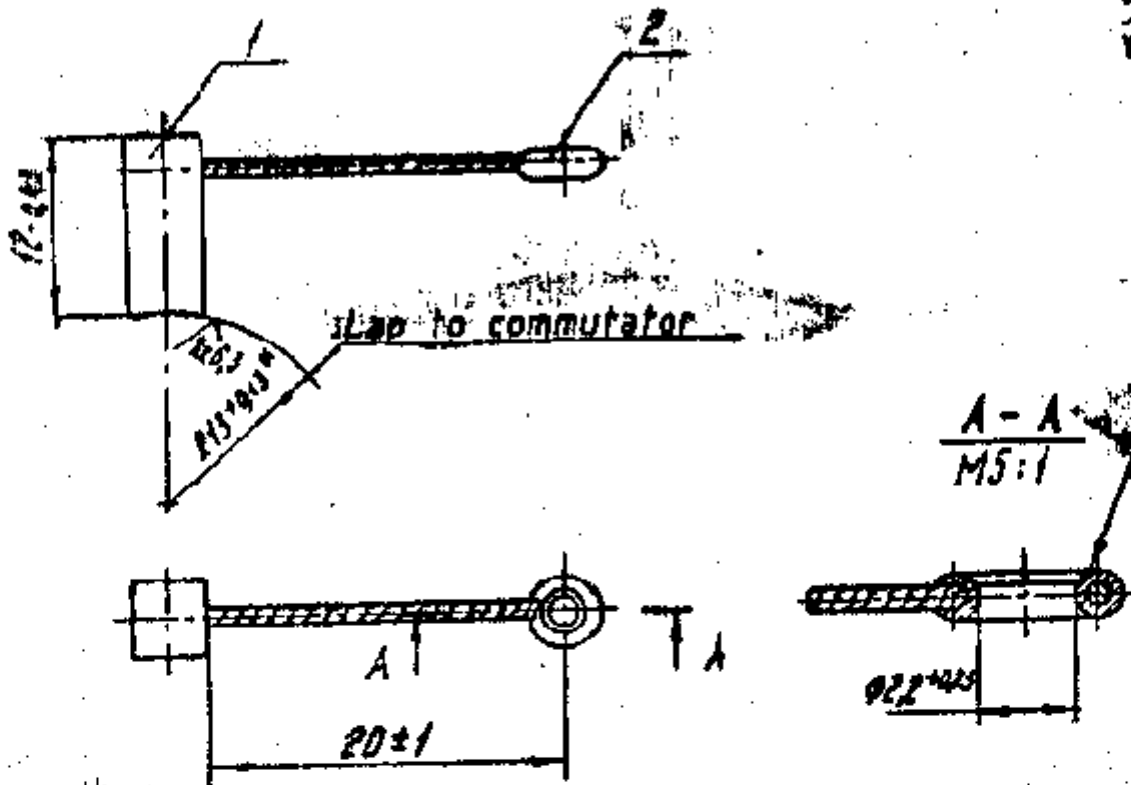
SHEET	WEIGHT	SCALE
	5.8g	2:1
TOTAL SHEET		

3-1-A4-ASSY

66.677.219

42
D-31

653.121.18V



1. * Dimension is provided with tools
2. Not more than 5 small ruptures of hollow rivet are allowed while expanding.

ECKD

Ref. No.	Designation	Description	Qty	Remarks
2	858.955.115	Hollow rivet	1	
1	68.662.203	Brush	1	

66.677.219

NO	SHEET	DOC NO	SIGN	DATE
1	1			12.4.85

BRUSH
CIFE, PUNE

SHEET	WEIGHT	SCALE
1	43g	2:1
TOTAL SHEETS		

3-1-A4-ASSY

867842163

8280
V(V)

Исполн. проект
866.765.076

Справочный №

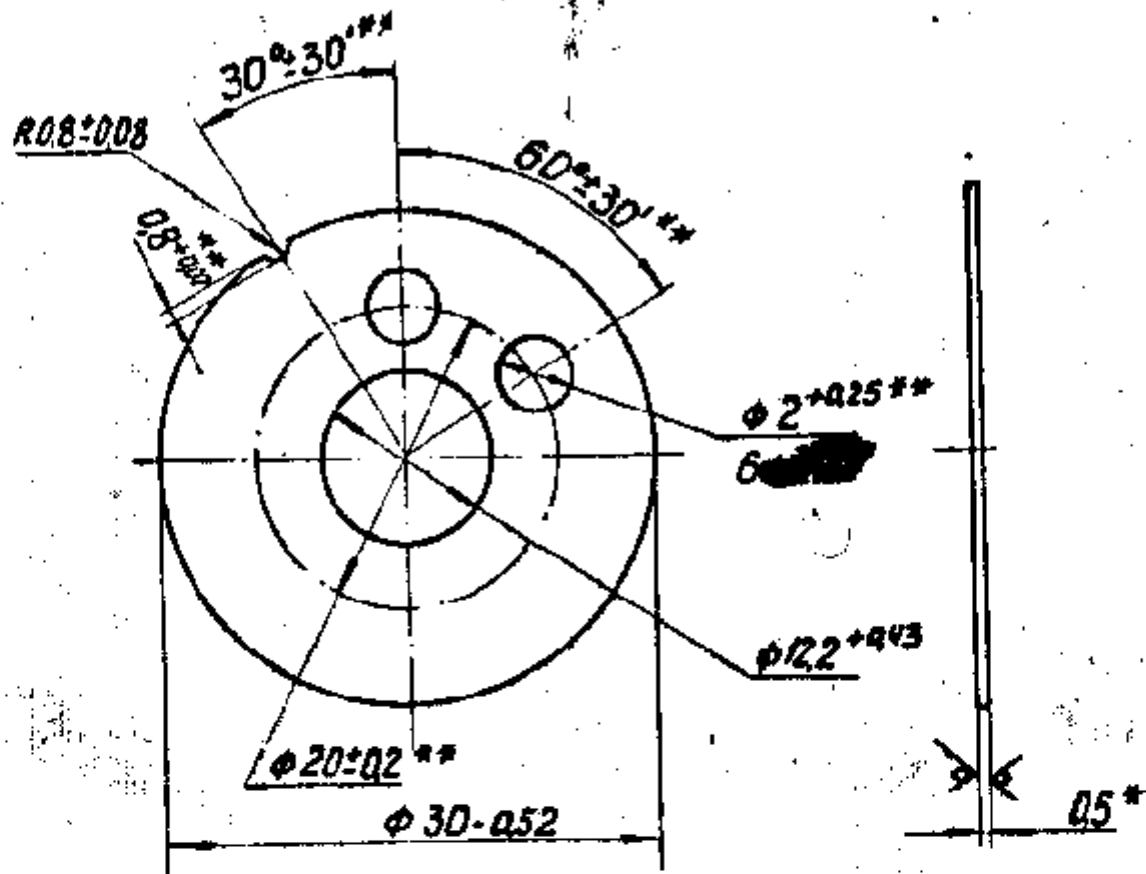
Исполн. в штаб

Имя № докум

Взв. № №

Исполн. в штаб

Имя № докум



1. * Dimension is given for reference.

2. ** Dimensions are provided with tools.

FOR EXPLANATORY NOTES REFER TO DRG NO. 86 7-844-289

55
D-131

(R. VEERARASHAYAN)

ECKD

CIFE, PUNE

867.842.163

NO	SHR	DOC NO	SIGN	DATE
DRAWN		PRASAD		12.4.85
EDT,CHKD		D.K. SAH		18.4.85
F/M,DC		S.R.NAIR		
DIV.OFFR		A.K.KUNDU		26.4.85
		NAME	SIGN	DATE

WASHER

Fiber glass laminate
CT 3 φ-1 0.5.GOST12652-74.

SHEET WEIGHT SCALE

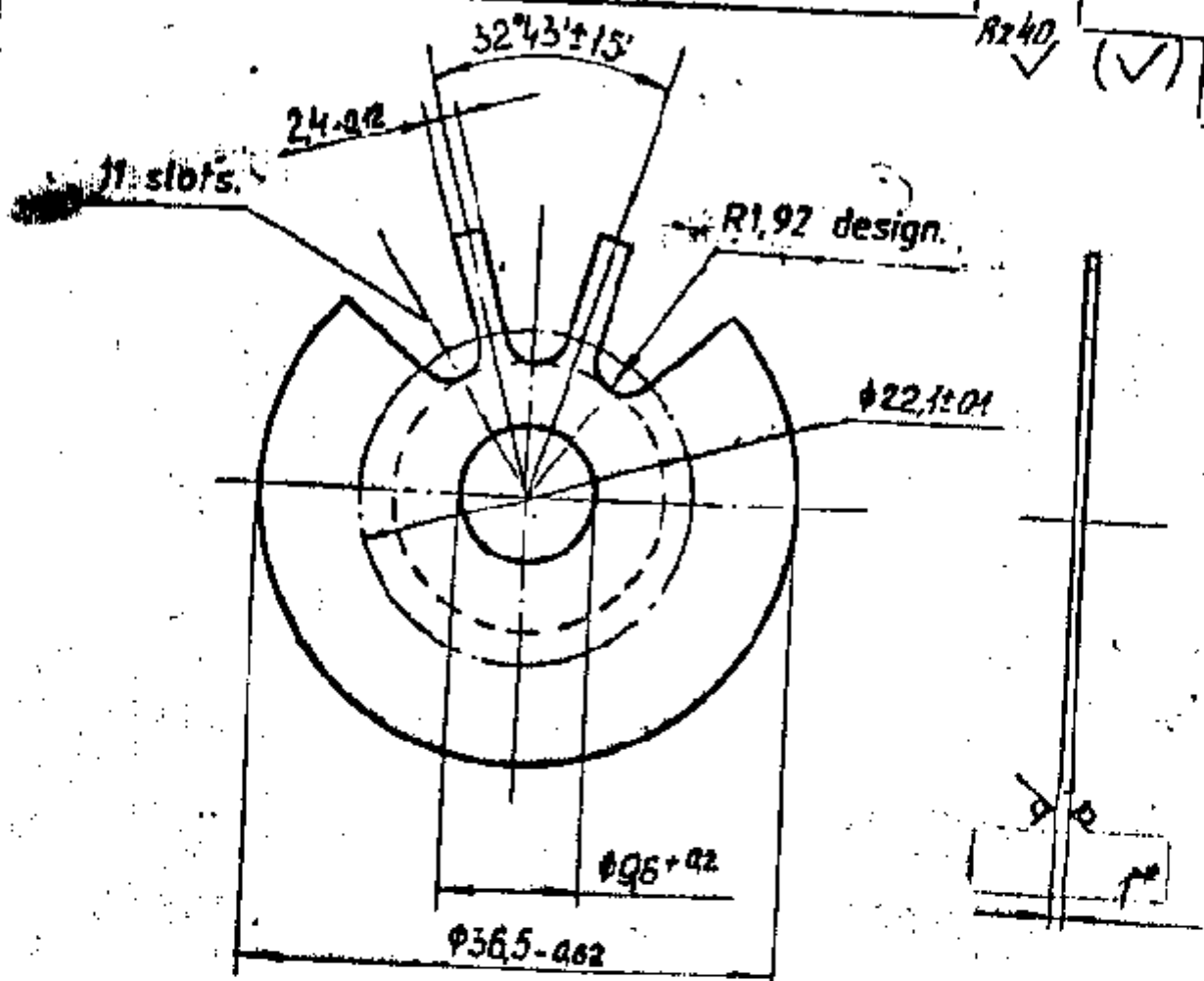
6	0.2	21
---	-----	----

TOTAL SHEETS

Контрпозд

3-1-A4-

052'448'290



1. *Dimensions are given for reference.
2. Limit deviation between any slots is ±15'.
3. FOR EXPLANATORY NOTES REFER TO DRGNO B57.844.289

(R. VEERARAGHAVAN)
57 500-1
D-131

ECKD

B57.844.290

SNO	DRG NO	SIGN	DATE
DRAWN	PRABHU		
EDT/CHKD	S.K. JAIN		11.4.65
FM, DC	S.R. KAR		
DIV. OFFR	A.K. KONDU		22.4.65
	NAME	SIGN	DATE

INSULATING ARMATURE LAMINATION.

SHEET	WEIGHT	SCALE
5	0.62	2:1
TOTAL SHEETS		

Fiber glass laminate
CT 30-1
Thickness 1 GOST 18852-76

13487
 23.4.65
 11.4.65
 22.4.65

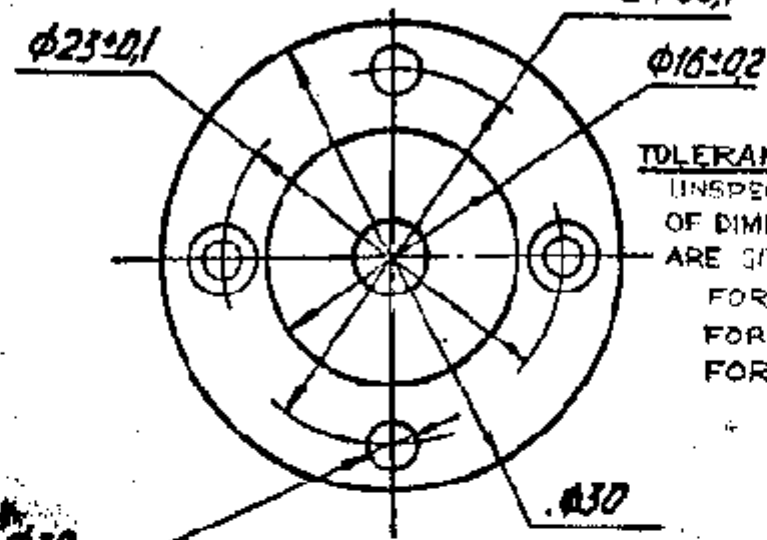
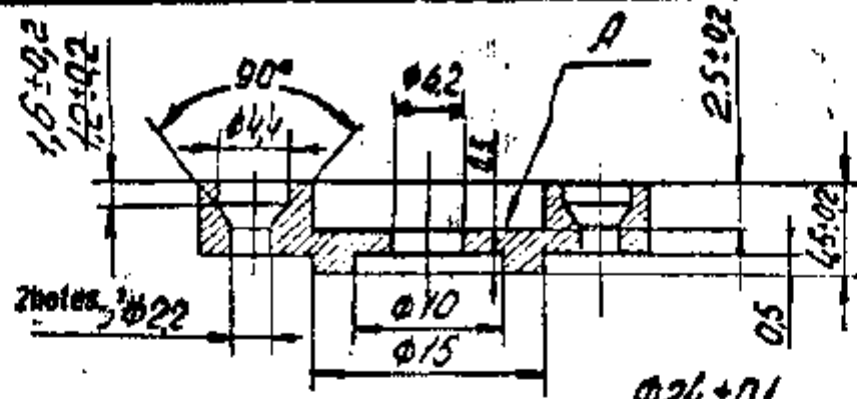
3-1-84

858 050 376

A-10

853 727 184

87 406 146



TOLERANCE
 UNSPECIFIED LIMIT DEVIATIONS
 OF DIMENSIONS OF A7, B7 & CM7
 ARE GIVEN BELDW
 FOR HOLES - A7 - H14
 FOR SHAFTS - B7 - h14
 FOR OTHERS CM7 - js14

GD
 2-131

REFER TO DRG No 858.055.377 FOR EXPLANATORY NOTES.

1. Rounding-off radii are 0,3mm.
2. Coating: chemically oxidized, parkerized.
3. Appearance of casting should correspond to OST 470.021.192.
4. When some moulds are available, use distinctive indies, 0,5mm high, on surface A.
5. Unspecified limit deviations of dimensions are as follows for holes - as per A7, shafts - as per B7, others - as per CM7.

SURFACE FINISH - REPRESENTS SURFACE FINISH TO BE OBTAINED BY WITHOUT REMOVAL OF MATERIAL
 IN THE CASE OF 40 AND 40 IN THOSE SURFACES WHERE SURFACE FINISH

Имя и фамилия
 Подпись и дата
 21.09.78
 137.095

NO	SHEET	DOCNO	SIGN	DATE
	DRAWN BY	P.R.BABU		13.4.58
	EDITED AND CHECKED BY	P.K.SHN		14.4.58
	FOREMAN OF DC	S.R.NAR		
	DIVISIONAL OFFICER	A.K. RAMU		24.4.55
	NAME	SIGN	DATE	

COVER.

Alloy A12
 GUST 2685-75.

858 050 376

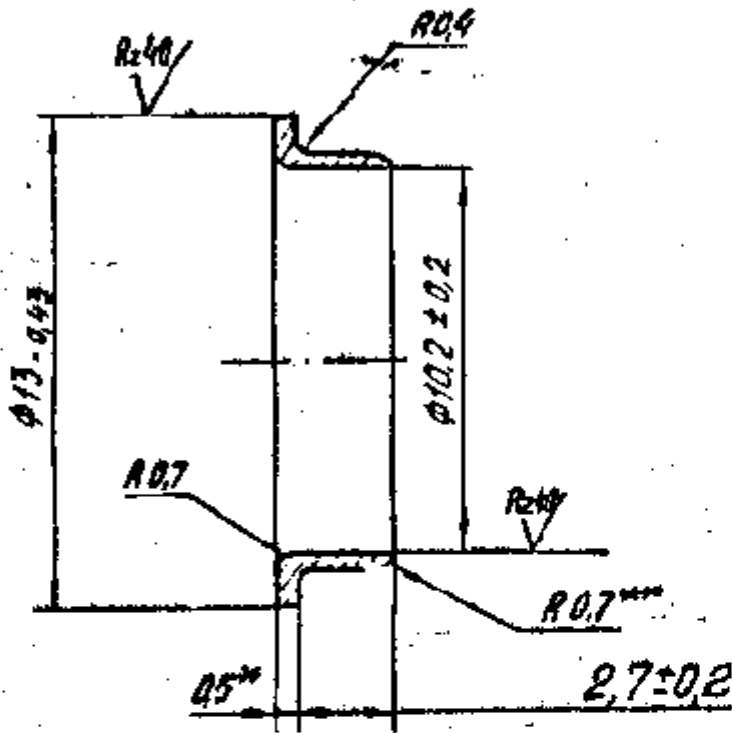
SHEETS	WEIGHT	SCALE
6	5,42	2:1
TOTAL SHEETS		

3-1-A4

858.220.424

(V) (V)

858.220.424



1. *Dimension is given for reference.
2. **Dimension is provided with tools.
3. Coating: Copper-plated, 3 microns thick, tin-besmuht (99,7) alloy-plated, 6 microns thick.

FOR EXPLANATORY NOTES REFER TO DRG No. 858-312-118

(R VEERARAGHAVAN)
SS011

63
D-131

ECKD

858.220.424

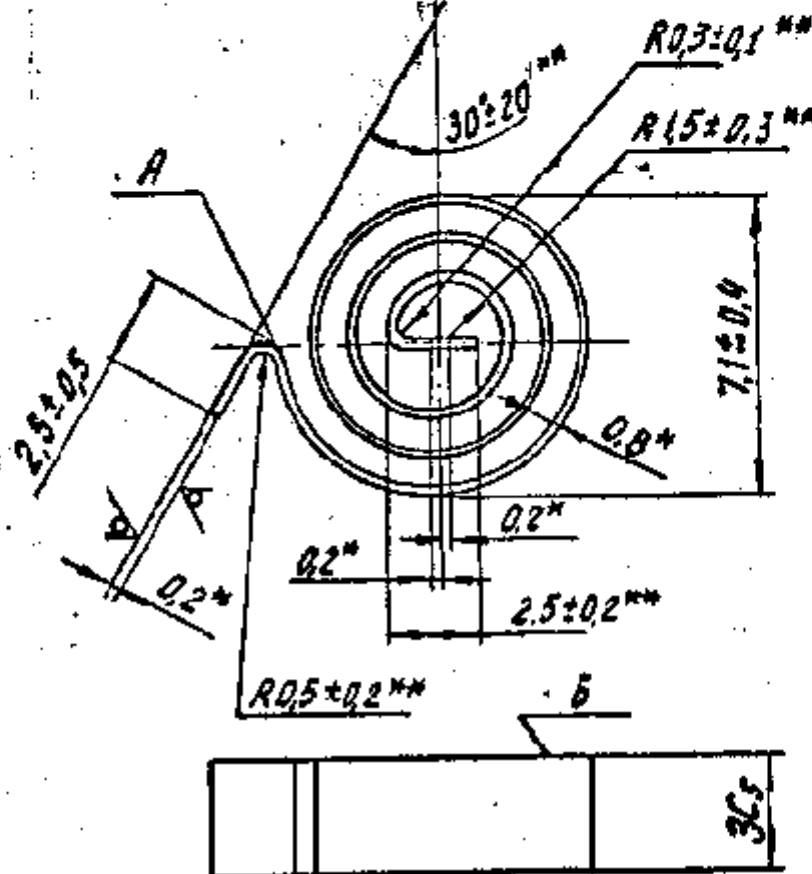
NO	SHEET	DOCNO	SIGN	DATE	BUSHING.	858.220.424
DRAWN BY	P.RABAU			13.1.85		
EDITED AND CHECKED BY	D.R. JAIN			9.4.85		
FOREMAN OF DC	S.R. NAR					
CIVISIONAL OFFICER					Plate 5-111-0.5 GOST 19904-74	SHEETS WEIGHT SCALE
					3-11 1-10K1 GOST 16523-70	5 122 5:1

3-1-AH

100'986'899

Rz40 / (✓)

656.674.737



68
D-131

1. * Dimensions are given for reference.
2. ** Dimensions are provided with tools.
3. Number of coils of spring in free state - 3.
4. Deflection off end of spring A from axis may be within the limits of $\pm 30^\circ$.
5. Temper the spring ends over the length of 4mm to obtain strength group 1.
6. Projection of coils beyond plane B should not exceed 0.15mm.
7. Coating: Chemically parkerized, varnish K0.965, GOST15030-78

656.674.737

CIFE, PUNE

B58.386.001

SN	SH	DOC NO	SIGN	DATE
DRAWN		PRASAD		12.4.85
ED/CHKD		D. R. JAIN		19.4.85
F/M, DC		SR. NAIR		
DIV. OFFR		A. K. KUNDU		25.4.85
		NAME	SIGN	DATE

SPRING

SHEET WEIGHT SCALE.

5	0.212	5:1
---	-------	-----

Band Y9A-2 П-C-0.2
GOST 21996-76.

3-1-A4

858.652.218

1:40
V(V)

Первич. проект
858.652.218

Справочный №

№

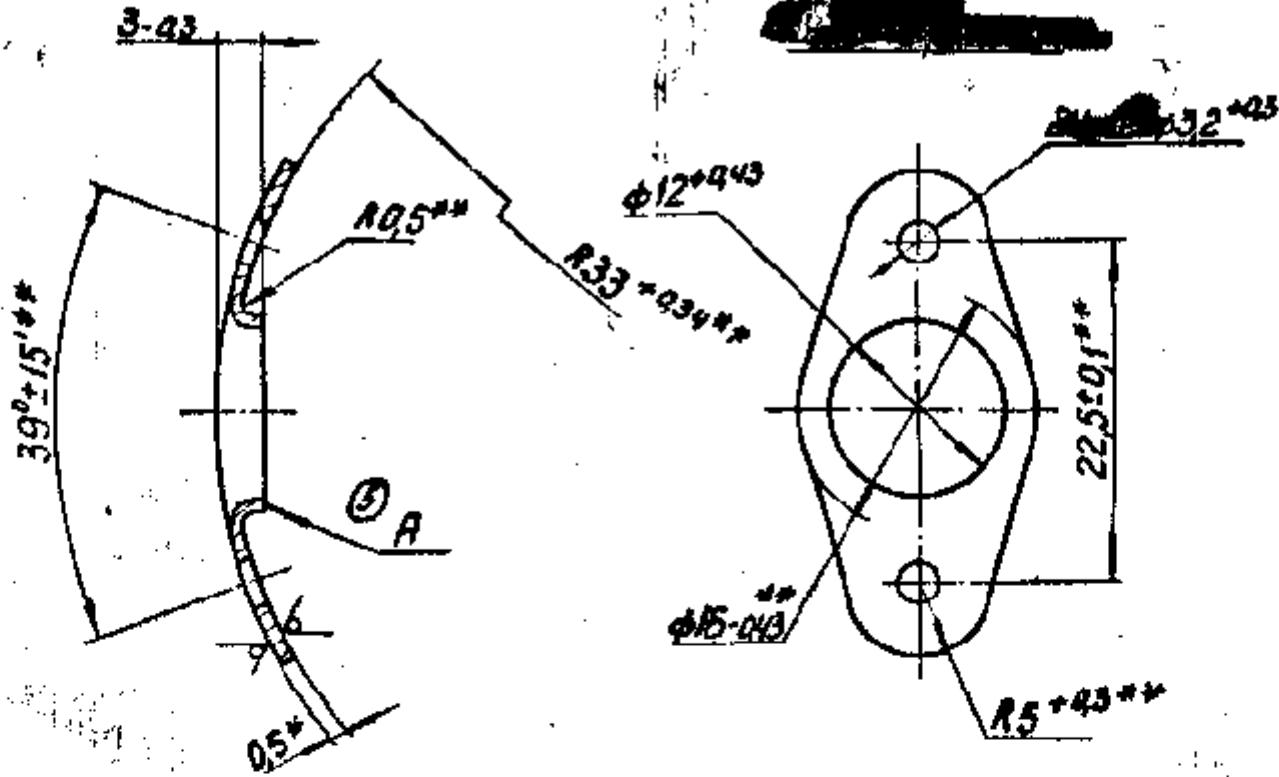
Коды и дата

№

№

№

№



70
D-131

1. ** Dimensions are provided with tools.
2. * Dimension is given for reference.
3. Coating: Copper-plated, 3microns thick, tin-bismuth (99.7) alloy-plated, 6microns thick.
4. Not more than 5 ruptures, not exceeding 2mm in length, are allowed on surface A.

FOR EXPLANATORY NOTES REFER TO DRG NO. 858-332-118

ECKA

(R VEERARAGHAVAN)
SIO II

GJEE, PUNE RRR 652 218

GJEE, PUNE RRR 652 218

SN	SHI	DOC NO	SIGN	DATE
DRAWN		PRASAD		12.4.85
EDT/CHKD		DK SHIN		18.9.85
F/M, DC		S.R. NAIR		
DIV. OFFR		A. K. KUNDU		26.4.85
		NAME	SIGN	DATE

UNION

SHEET	WEIGHT	SCALE
6	432	2:1
TOTAL SHEETS		

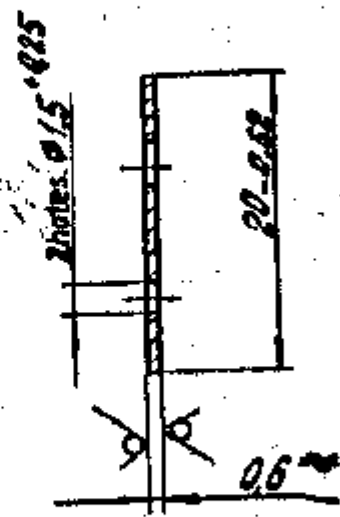
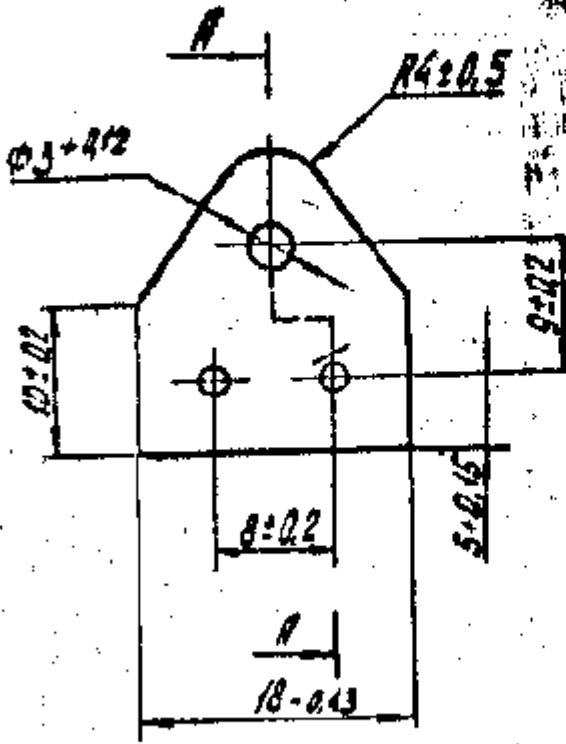
Sheet 5-ПН-0.5, GOST19904-74.
3-П-10Kn GOST16523-70.

Копировал

Формат 11

3-1-AA

858 669 103



1. *Dimension is given for reference.
2. Dimensions are provided with tools.
3. Coating: Zinc-plated, 6 microns thick, chromated.

"FOR EXPLANATORY NOTES REFER TO DRG NO. 858-332-118"

J. Veeraraghavan
(R VEERARAGHAVAN)
=S0E

105
D-131

ECKA

SINO	SHEET	DOCNO	SIGN	DATE
DRAWN BY		P.R.BABA		12.4.85
EDITED AND CHECKED BY		A.H. Srinivas		5.4.86
FOREMAN OF DC		S.R.NAR.		
DIVISIONAL OFFICER		AKKUNDA		16.4.85
NAME		SIGN	DATE	

LUG.

858.669.103

SHEETS		WEIGHT	
5	1.5		
TOTAL SH			

Sheet 6-TM-0.6 GOCT 19904-74.
• 3-II-10KII GOCT 16523-70.

854.71.862

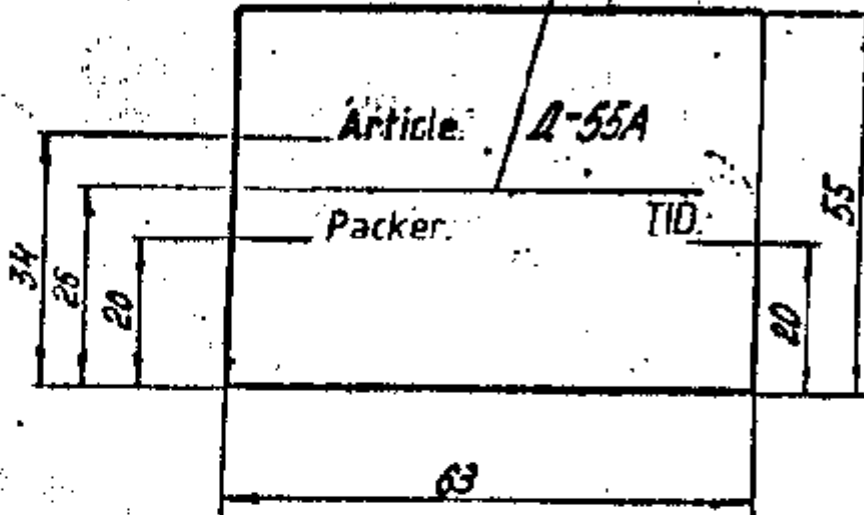
137721 15.05.79

DIFF PINE
3-1-A4

858.825.636

AB: 1-0-139

Article No



Tags may be made by photo-copying method on photographic paper 6 kop C, GOST 250-78.

110
D-131

ЕКД

51	NO	SHEET	DO	NO	SIGN	DATE	TAG	858.825.636			
	DRAWN BY	P.R.BABL				12.4.05			SHEETS	WEIGHT	SCALE
	EDITED AND CHECKED BY	S.A.				25.5			5	0.03r	1:1
	FOREMAN OF DC	S.R.NAR.							TOTAL SHEETS		
	DIVISIONAL OFFICER	A.K.KUNDU				24.4.05	Letter press paper				
							GOST 21444-75.				

СІМЕ ПУМЕ

A-55A

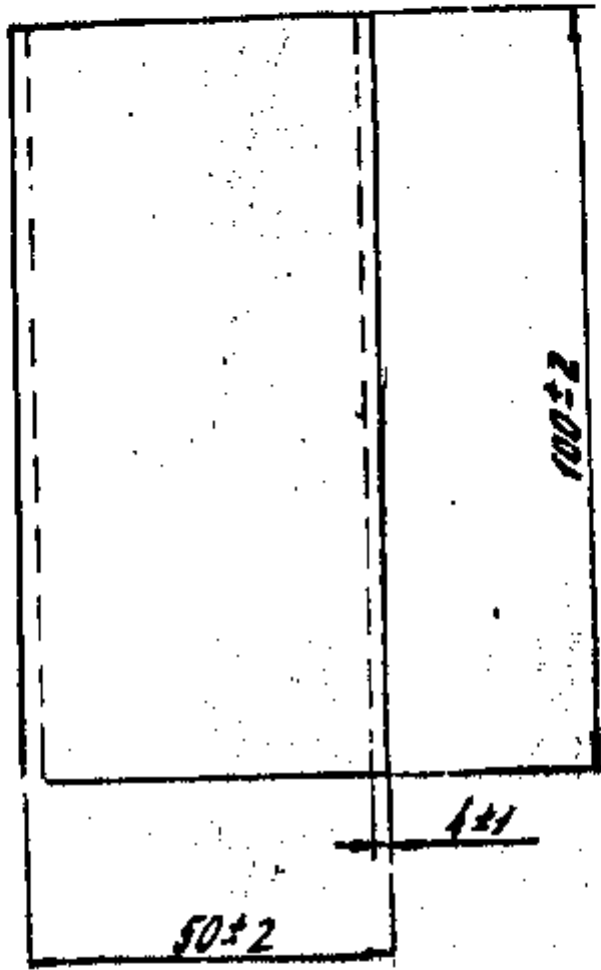
ГОСТ 250-78

Формат: 11

3-1-A4

858.840.041

Development 50x200



112
9-131

Seal seams by fusing.

FOR EXP. LABORATORY NOTES REFER TO DRG NO 858.840.037

(R VEERARAGHAVAN)
SC-1

S/NO	SHEET	OCNC	SIGN	DATE
DRAWN BY	R. BABU			12.4.85
EDITED AND CHECKED BY				
FOREMAN OF DC	R. NAIR			
DIVISIONAL OFFICER				
	NAME	SIGN	DATE	

COVER FOR BRUSHES.

Polyethylene
tape 0,06 GOST10354-78

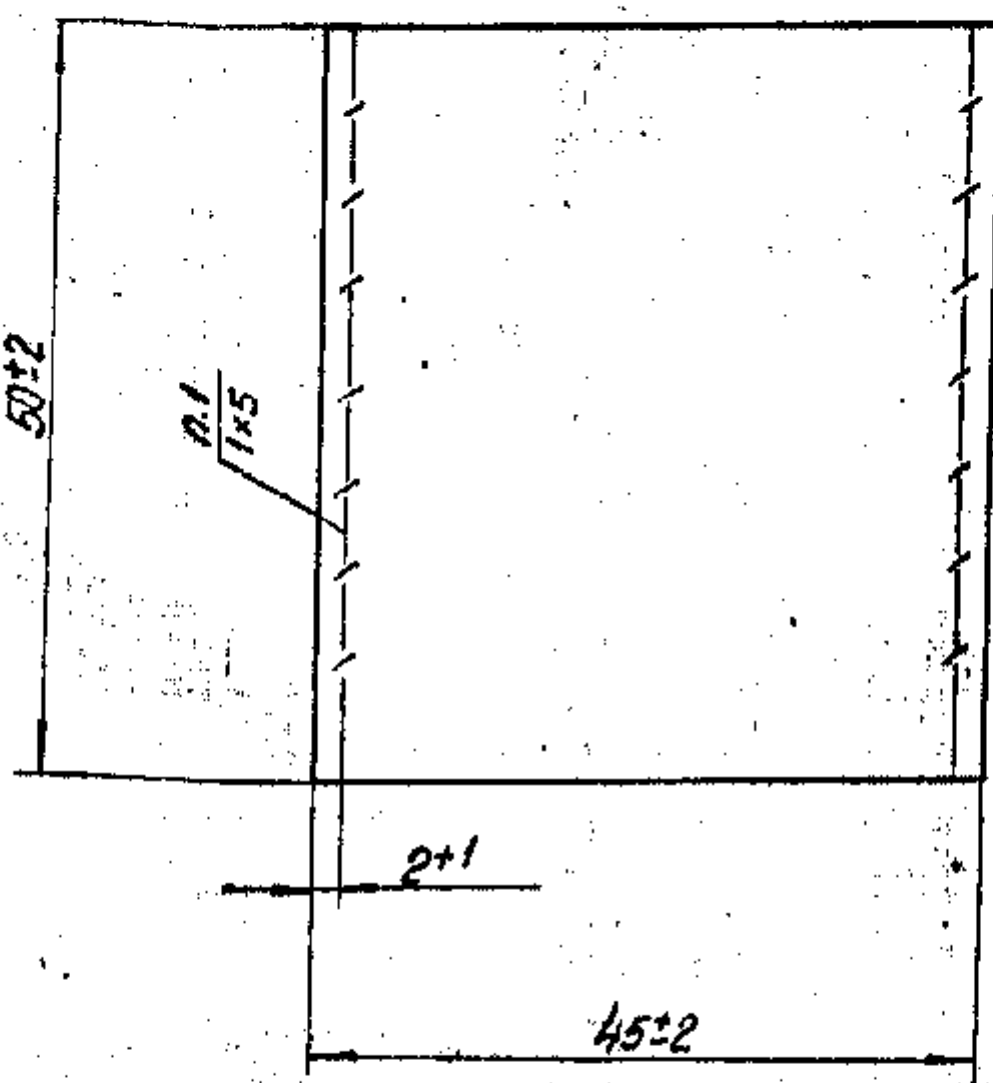
858.840.041

SHEETS	WEIGHT	SCALE
5	-	1:1
TOTAL SHEETS		

CIFE PUNE

858.863.001

Development 45x100



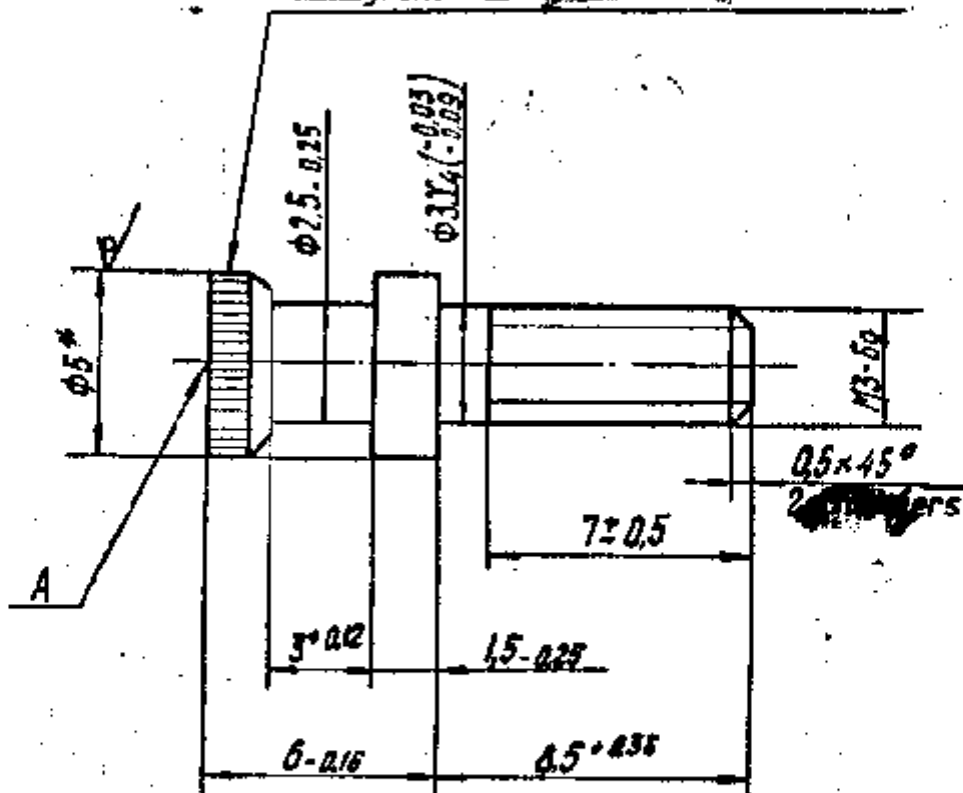
73
0.31

1. Cotton thread 00, GOST 6309-73.

SLNO	SHEET	DOCNO	SIGN	DATE	BAG.	858.863.001		
DRAWN BY	P.R.DABU			27.4.85		SHEETS	WEIGHT	SCALE
EDITED AND CHECKED BY	A.B. Srinivas			5.4.85		5	-	21
FOREMAN OF DC	S.R.NAR.					TOTAL SHEETS		
DIVISIONAL OFFICER	A.K.KUNDU	AK		26.4.85				
	NAME	SIGN	DATE	Cotton coarse calico, GOST 11680-76.				
					GIFE, PURE			

R120/ (V)

21474-75



FOR EXPLANATORY NOTES REFER DRG NO. 858.903-040
 STRAIGHT KNURLING (GOST 21474-75) - α) KNURLING PITCH, P = 0.6
 б) KNURLING HEIGHT, h = 0.25P TO 0.70P C) ANGLE α = 70°
 * Dimension is given for reference.

1. Projection not exceeding 0.2mm is allowed in the centre of surface A.
2. Coating: Zinc-plated, 6microns thick, chromated.

(R VEERARAGHAYAN) SSM

75
D-131

ECKD

ПОДГОТОВИЛ И ВЫПЕЧАТОВАЛ: 133002
 ЧЕРТЕЖНИК: 133002
 ПРОЕКТИРОВЩИК: 133002
 КОМПЬЮТЕРНОЕ ВЕКТОРИЗОВАНИЕ: 133002

CIFE, PUNE

858.927.122

STUD

SHEET WEIGHT SCALE

5 1.012 5:1

TOTAL SHEETS

NO	DOC NO	SIGN	DATE
DRAWN	PRASAD		22.4.89
EDT,CHKD	A.K.KUNDU		18.4.89
F/M,DC	S.R.NAIR		
QIV,OFFR	A.K.KUNDU	AK	26.4.89
	NAME	SIGN	DATE

Round bar 5-4 GOST 7417-75
 A12 GOST 1414-75

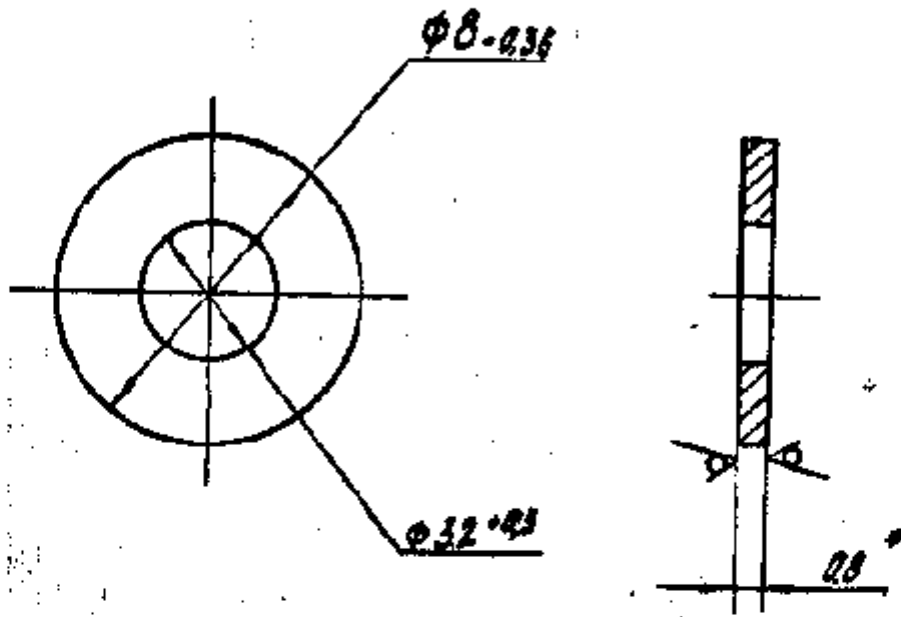
Копировал ААК

Формат II

3-1-A4

858.942.556

Az160/1



1. * Dimension is given for reference.
2. Coating: Cadmium-plated, 6microns thick, chromated.

FOR EXPLANATORY NOTES REFER TO DRG No. BE 8-332-118

[Signature]
 (R VEERARAGHAVAN)
 SSOE

77
 D-131

CIFE, PUNE

858.942556

ENGLISH	DOC NO	SIGN	DATE
DRAWN	PRASAD		12.4.85
EDT/CHKD	A.K. KUNDU	<i>[Signature]</i>	16.4.85
F/M, D.C.	S.R. NAIR		
DIV. OFFR	A.K. KUNDU	<i>[Signature]</i>	24.4.85
	NAME	SIGN	DATE

WASHER

SHEET	WEIGHT	SCALE
5	1000mm 224kg	5:1
TOTAL SHEETS		

Cold-rolled
 Sheet 60.8, GOST 18904-74.
 3015-10K71 GOST 16523-70.

3-1244

Sheet 11

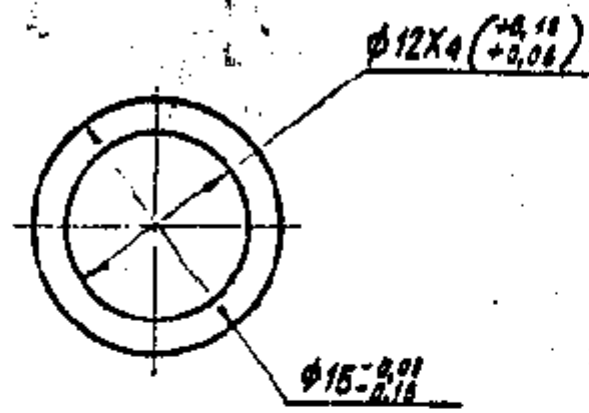
858.942.639

R240

V(V)

11900.00000
858.121.020

11900.00000



Coating: Cadmium-plated, 12microns thick, chromated.

Designation	S	Material	
858.942.639	0,05	108H-NT-2-0,05 503-71	342
-01	0,3	10H-NT-2-0,3 503-71	2062

FOR EXPLANATORY NOTES REFER TO DRG NO. 858-942-544

(R. VEERARAGHAVAN)
SS0K

79
D-131

ECKD

G.I.F.E., PUNE 858.942.639

SN	SHY	DOC	NO	SIGN	DATE
DRAWN	PRASAD				12.4.85
EDT. CHKD	D.K. SINDHU				18.4.85
F/M, DC	S.R. NAIR				
DIV. OFFR	A.K. KUNDU				26.4.85
	NAME			SIGN	DATE

WASHER
See table.

SHEET	WEIGHT	SCALE
6	Specs to l/c	2:1
TOTAL SHEETS		

3-1-A4

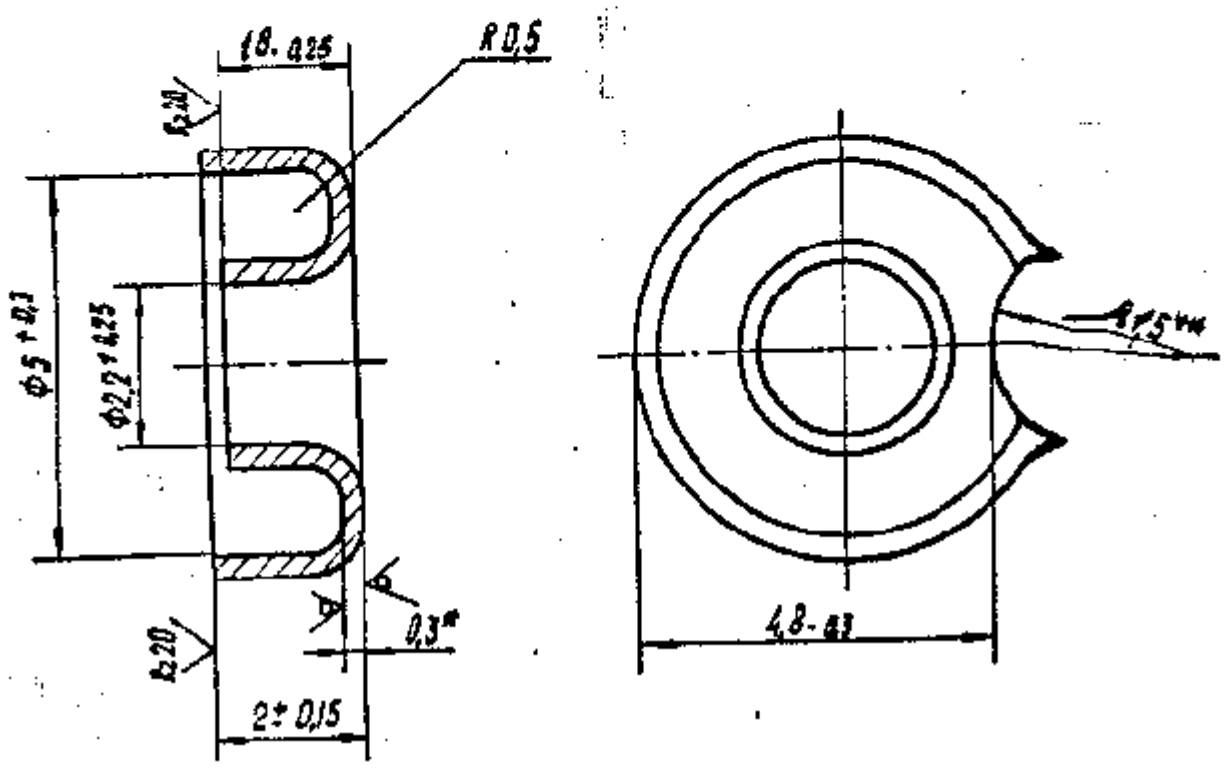
13.5.07

858 955 115

(✓) (✓)

Сред. размер: 55. 277 219

Сред. N



* Dimension is given or reference.

** Dimensionns are provided with tools.

1. Coating: Copper-plated, 3microns thick, tin-bismuth (99. 7) alloy-plated, 6microns thick.

2. Not more than 5rupture with a depth of not more than 0.4mm are allowed at butt end $\phi 2.2 \pm 0.25$.

FOR EXPLANATORY NOTES REFER TO DRG No 857-750-480

(R. VEERARAGHAYAN)
SSMT

80
2131

ECKA

CIFE, PUNE

858 955.115

NO	DOC NO	SIGN	DATE
DRAWN	PRASAD		12.4.85
EDT,CHKD			
P/M,DC	S.RNAR		
DIV.OFFR	A.KRINDU	AK	24/4/85
	NAME	SIGN	DATE

HOLLOW RIVET

PHM 0.3 HD 63.
GOST2208-75.

SHEET NO / WEIGHT / SCALE

6 / Q12 / 10:1

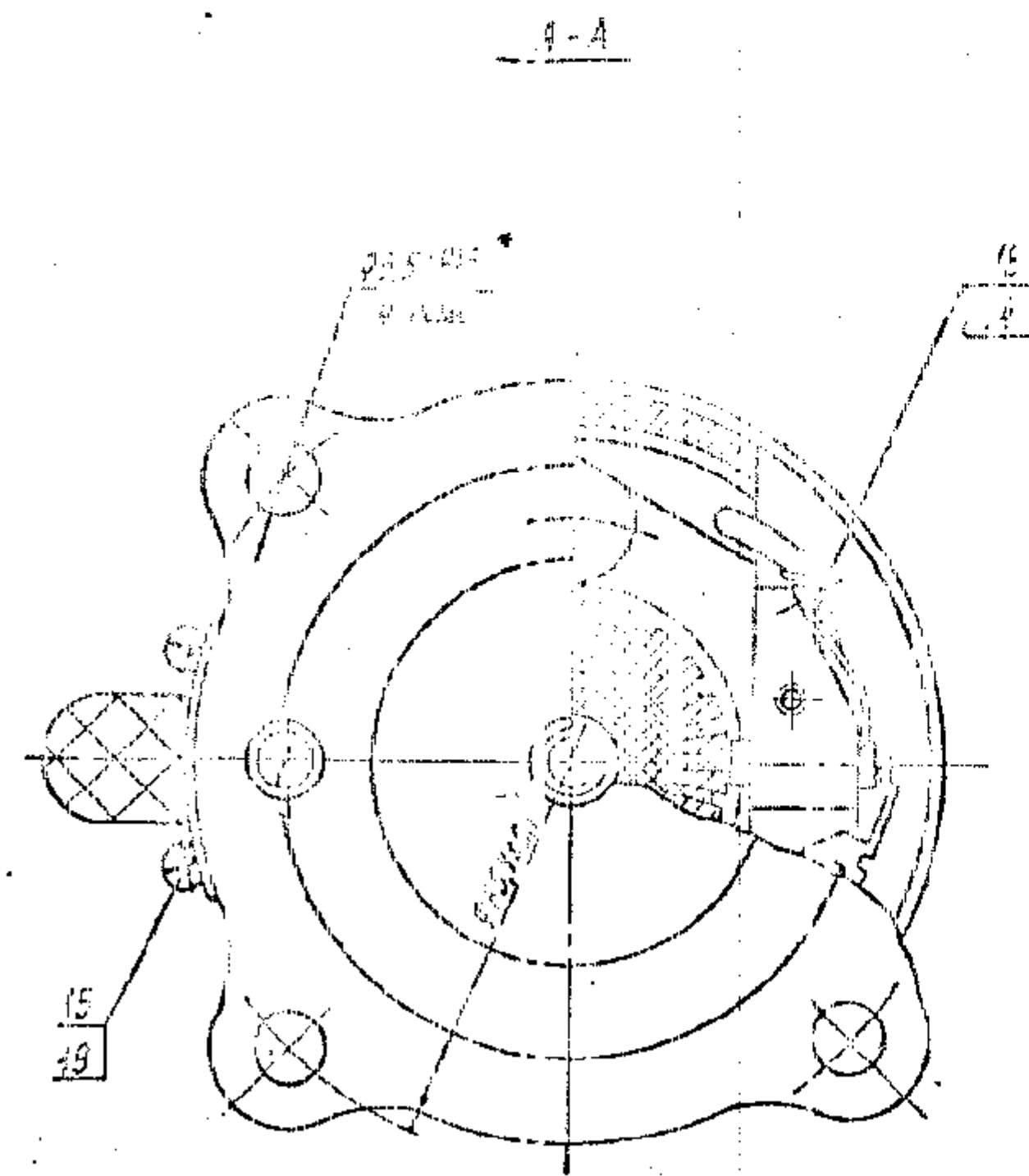
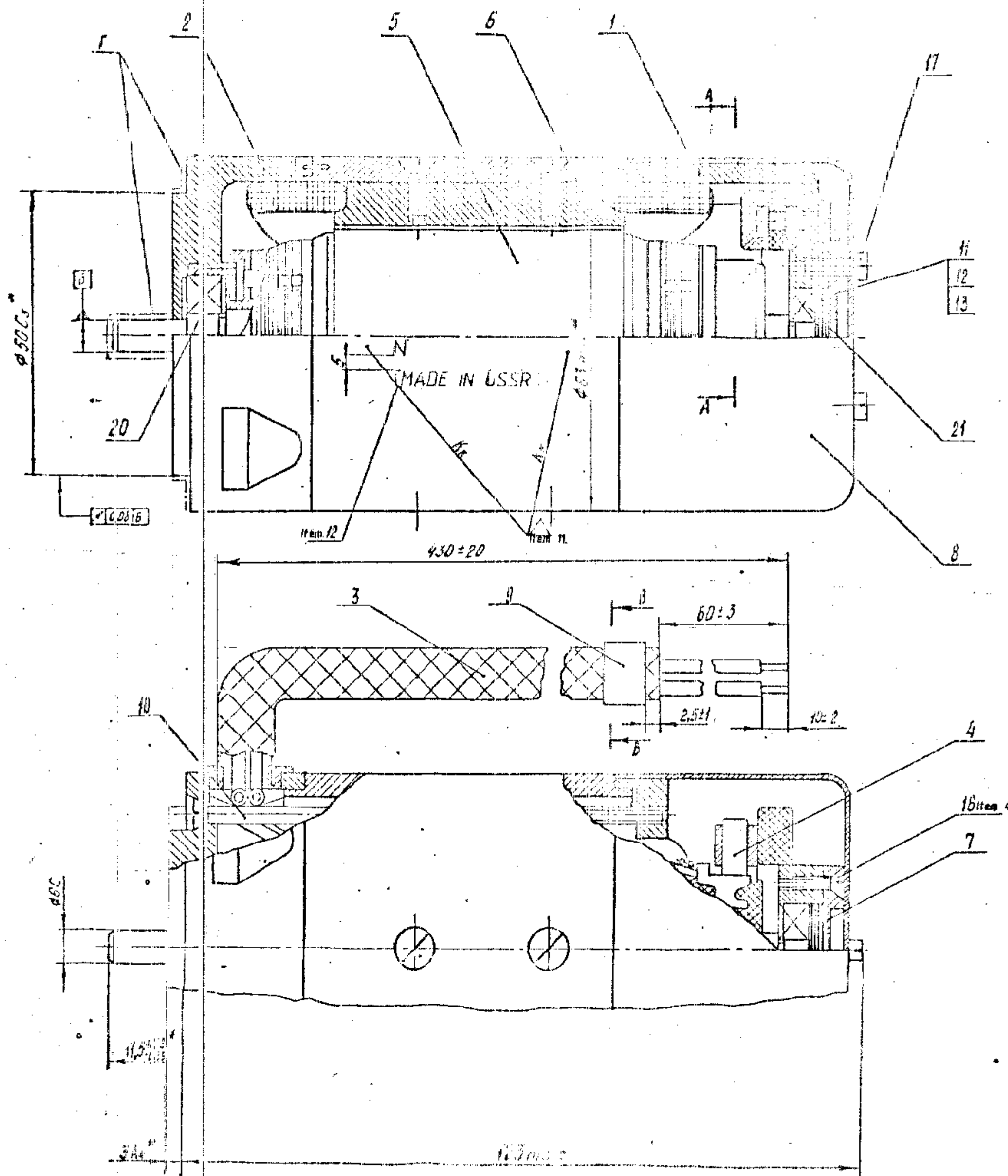
TOTAL SHEETS

21H-1

Корпусная АД

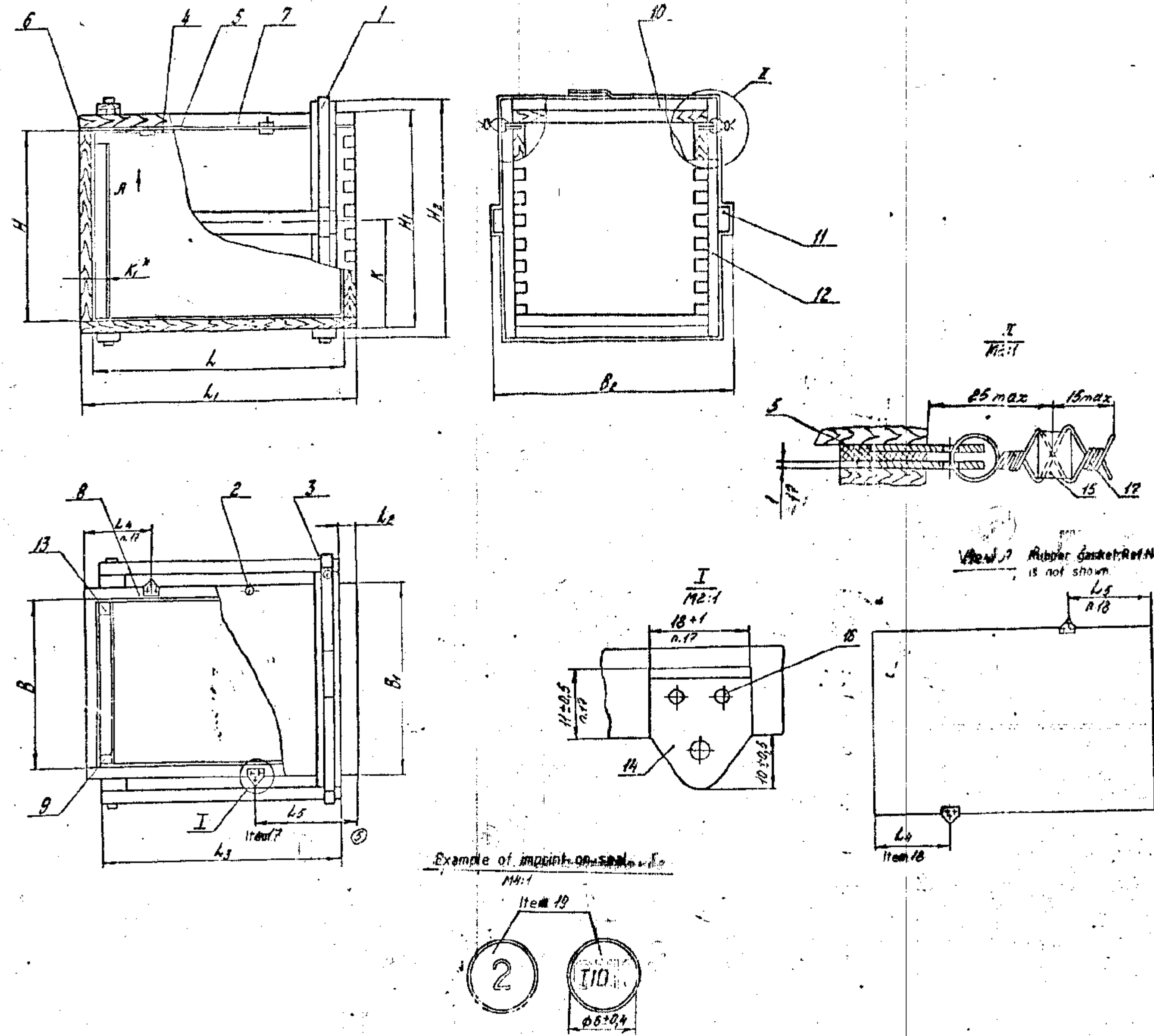
1-4-1

3-1-AA



1. Dimensions are given for reference.
2. Pack bearings, Ref.No. 20, with grease (Lubrit-22), GOST 9433-60, in amounts of 0.17 to 0.18g, and bearing, Ref.No.21 with grease in amounts of 0.572 to 0.658 g.
3. Coat the shaft with stator, Ref.No. 12 and stator, Ref.No.6, with thin layer of grease (Lubrit-22).
4. Secure the screws with lock washers, Ref.No. 11, with green grease KD-12, Ref.No.11 - max 2 Ref.No.15 - max 1.
5. The drawing holes on the left side of the article should be located in the hole of head of screw Ref.No. 11.
6. Traces of brush, Ref.No.14, should be placed in the slot of brush holder.
7. Adjust clearance and play with its limits of 0.1 to 0.05mm with washers, Ref.No. 11, 12, 13.
8. Coating of surface P1 grease (4A 114-22).
9. Electric-motor should supply with 353.121.121 TS.
10. Apply the serial number of the article with marking paint MK30, GOST 410.054.205, use type 10-3, GOST 2930-62.
11. Apply 10D stamp on the left side of article serial number and customer representative stamp on the right side of it with silver marking paint as per B00045.999 T-4.
12. Apply inscription made in USSR by off set printing method using marking paint 6M T929-12-05-72 and type 10-3, GOST 2930-62, arranging it symmetrically to article face only while manufacturing the article for export if the corresponding requirement is given in zakaz-namoz.
13. Do not apply customer representative stamp while manufacturing the article for export.

ДИП. ТЕХНИК. Ч. 1
 653 121.020
 Ч. 1
 653 121.020



1. *Dimension is given for reference.
2. Box should be made of soft wood not worse than grade II Plywood of grade PK, not worse than grade B with a humidity not more than 12%.
3. Blanks (planks, ply wood) should be subjected to preservation treatment as per GOST 15755-79.
4. Assemble the side walls using tenon joint and adhesive BΦ-4, grade 1, GOST 12172-74. Bottom and planks should be secured with adhesive BΦ-4 and fastened with nails, Ref.No.2, at a spacing of 25±5mm; in so doing, projecting ends of nails should be bent flush with the wood.
5. Parts should be planed. During making they should be thoroughly fitted to ensure deep joints and absence of gaps, roughness of processed wood should be at least 32.
6. Deviation of dimensions, specified in the drawings are to be made with an accuracy of ±1mm.
7. Rubber gasket, Ref.No.5, is to be made with a width of 13 to 15mm and stuck to the cover along the entire perimeter without projection beyond cover butt-ends, using cement 88H TY 38-105.1011.76.
8. Paint the box on the outside with perchlorovinyl enamel XB-124, GOST 10144-74, in 2 layers and in 1 layer inside.
9. Paint allowed to use enamel XB-1100, GOST 6993-70, of yellow and green colours for painting.
9. Packing box should be secured with band preliminarily painted with enamel XB-124. Band is fastened with nails Ref.No.3, coated with adhesive BΦ-4, with the nail heads being subsequently painted with green and yellow enamel XB-1100.
10. Apply inscription onto the box in compliance with zakaz-nariad using indelible white paint and type П0-10, GOST 2930-62, enlarged by two times.
11. Apply a sign of tropical packing onto two faces of box using a paint. Signs and figures are encircled by paint of red colour, height of sign "T" is 50mm, and height of figures is 25mm.
12. Before putting the articles, lay paper, Ref.No.4, which is not damaged, inside the container.
13. Colour of the paint used for external surfaces of box and presence of pocket, Ref.No.9, should be specified in zakaz-nariad.
14. Apply marking No of box on its bottom from outside using marking paint MK-36, GOST 4.0054.205, and type П0-10, GOST 2930-62, enlarged by two times.
15. Mark symbols BHK-2, OX-2, EC-2, as per GOST 14192-77.
16. Warning signs should be placed at the left upper corner on two adjacent walls of the container.
17. Before assembling the box, make recesses with dimensions as per drawing in planks, Ref.No.8 (2pcs.).
18. Secure lugs, Ref.No.14, on box cover. Ref.No.7 (1 piece), aligning them with lugs on the box.
19. Squeeze seals, Ref.No.15. The following imprints should be present on the seals.
On one side - "T10", on the other side T10 representative No.
Use type П0-25, GOST 2930-62, concave profile, h=0,3 to 0,5mm.
Imprint on seal is to be coated with varnish AK-113Φ GOST 23832-79, for four times.

Decimal No. of drawing	L	L ₁	L ₂	L ₃	H	H ₁	H ₂	B	B ₁	B ₂	K	K ₁	Marking	L ₄	L ₅
B64.171.062	210	240	—	—	180	210	—	150	130	—	—	—	1	45	65
B64.171.062-01	230	260	—	—	185	215	—	155	135	—	—	—	2	45	65
B64.171.062-02	255	285	—	—	170	200	—	155	135	—	—	—	3	45	65
B64.171.062-03	350	380	—	—	260	290	—	165	145	—	—	—	4	45	65
B64.171.062-04	420	450	45	360	310	340	380	230	200	340	170	30	5	105	125
B64.171.062-05	430	460	50	350	280	310	350	225	255	315	155	30	6	110	130
B64.171.062-06	460	490	55	360	350	380	420	310	340	400	170	30	7	130	150
B64.171.062-07	480	510	75	360	310	440	480	330	420	500	220	30	8	140	160
B64.171.062-08	500	530	85	360	310	340	380	280	290	370	170	30	9	150	170
B64.171.062-09	530	560	100	360	320	350	390	360	440	500	175	30	10	160	180

WOODEN BOX CONTAINER FOR TROPICAL AND SEAWORTHY PACKING.
Assembly drawing.

B64.171.062.05

DESIGNED	DATE	SIGNATURE
DRAWN	DATE	SIGNATURE
CHECKED	DATE	SIGNATURE
APPROVED	DATE	SIGNATURE
DATE		
TOLERANCE UNLESS OTHERWISE SPECIFIED		
GEN. L.D.C.		

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

ASSEMBLE THE SIDE WALLS USING TENON JOINT AND REHEGIVE BΦ-4, GRADE 1 OF GOST 12172-74. PHENOL-POLYVINYLACETATE GLUES MUST CONFORM TO THE NORMS SPECIFIED IN TABLE BELOW IN RESPECT OF PHYSICAL, MECHANICAL AND CHEMICAL PARAMETERS.

PARAMETER	NORMS FOR GRADES		PARAMETER	NORMS FOR GRADES	
	HIGHEST GRADE	FIRST GRADE		HIGHEST GRADE	FIRST GRADE
EXTERNAL APPEARANCE	TRANSPARENT OR SLIGHTLY TURBID, LIQUID LIGHT TO REDDISH IN	SLIGHTLY TURBID, LIQUID LIGHT TO REDDISH IN	CURVATURE IN FILM OF GLUE AFTER SOLIDIFICATION (mm NOT MORE THAN)	1	1
VISCO-SITY (Sec)	30-60	30-60	THERMAL STABILITY OF FILM OF GLUE AFTER SOLIDIFICATION AND AGEING	NOT DETERMINED	NO CRACKS
DRY SUBSTANCE CONTENT BY WEIGHT	10-13	10-13			
ULTIMATE SHEAR STRENGTH OF GLUED JOINT (kgf/cm ² NOT LESS THAN)	At 293K (20°C) 10-4 (200)	At 293K (20°C) 10-4 (200)			
	At 333K (60°C) 9-3 (100)	At 333K (60°C) 9-3 (100)			

PAINT THE BOX USING ENAMEL OF XB-1100 OF GOST 6993-70 AS PER IS 5-78 SHADE NO 356 GOLDEN YELLOW AND SHADE NO 277 OLIVE GREEN.

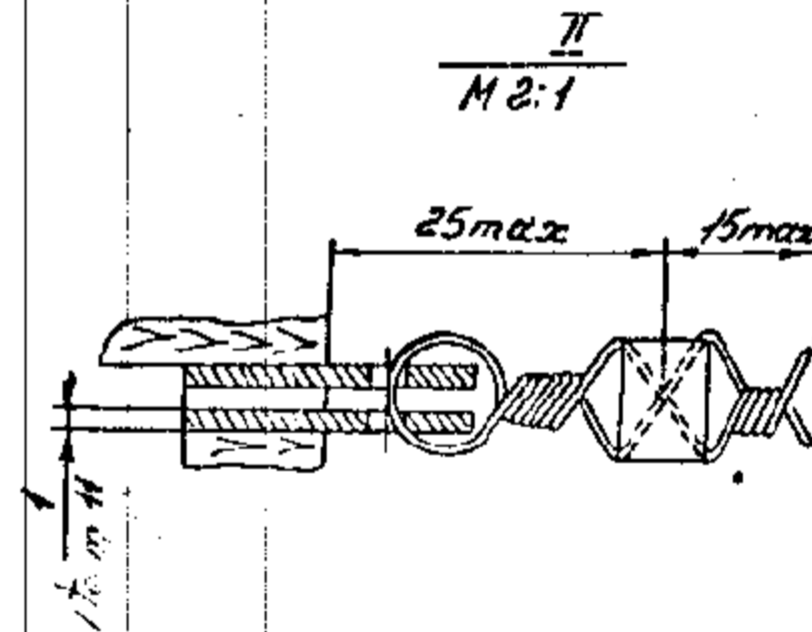
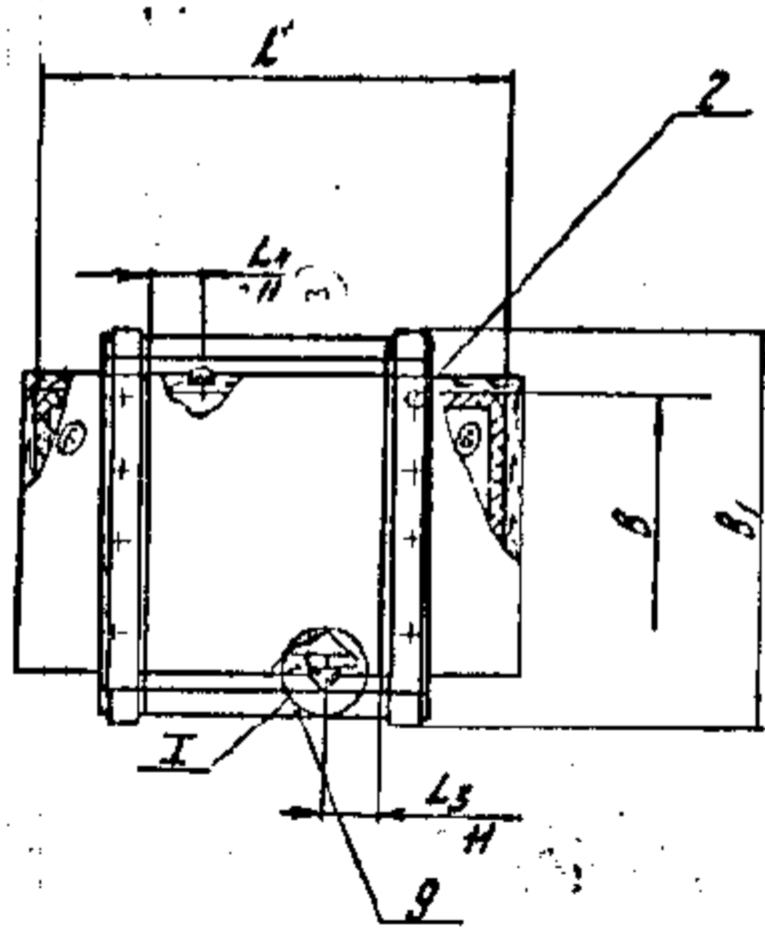
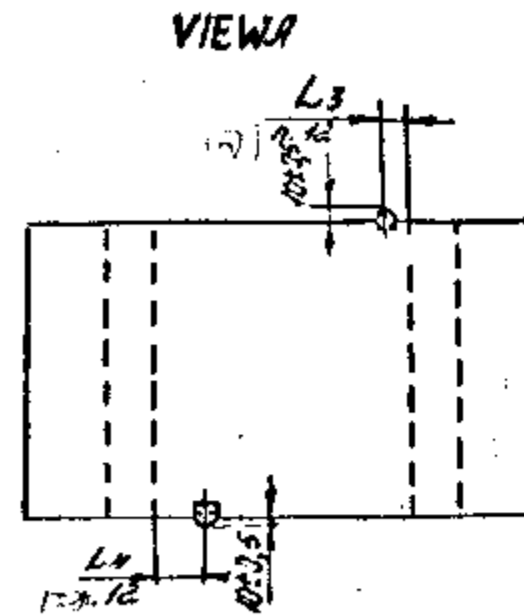
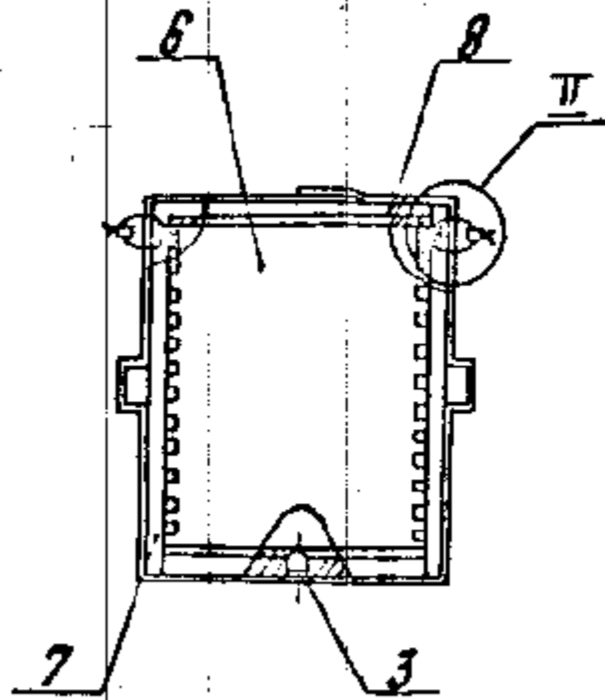
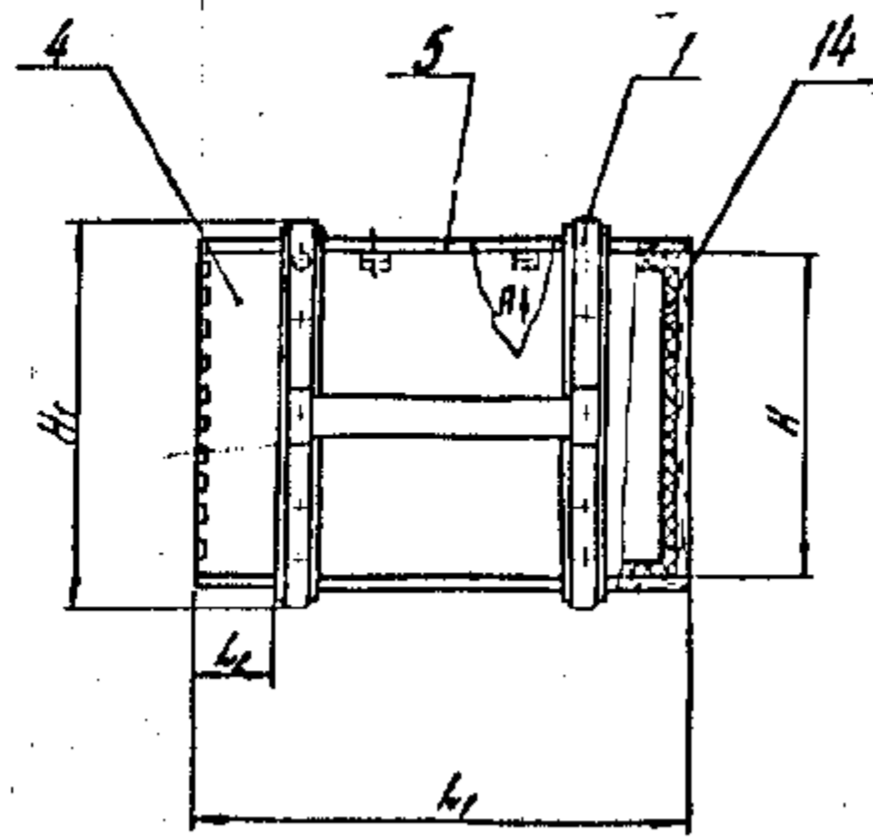
IMPRINT ON SEAL IS TO BE COATED WITH VARNISH AK-113Φ GOST 23832-79 VARNISH AK-113Φ REPRESENTS SOLUTION OF POLYACRYLIC MELAMINE FORMALDEHYDE RESINS IN MIXTURE OF ORGANIC SOLVENTS WITH ADDITIVES PLASTICIZERS. VARNISHES MUST CONFORM TO THE NORMS SPECIFIED IN TABLE BELOW ON PHYSICO-MECHANICAL PROPERTIES.

DESCRIPTION	NORM FOR VARNISH AK-113Φ GOST 23832-79	DESCRIPTION	NORM FOR VARNISH AK-113Φ GOST 23832-79
VARNISH APPEARANCE	TRANSPARENT, HOMOGENEOUS, WITHOUT MECHANICAL INCLUSIONS, LIGHT COLOURS ARE PERMITTED	FILM BENDING (mm), NOT MORE THAN	1
VARNISH COLOUR ON 100 METRIC SCALE, (mg 100IVE, NOT DARKER THAN)	5	FILM RESISTANCE TO WATER ACTION AT 20±2°C (HRS NOT LESS THAN)	4
VARNISH RELATIVE VISCOSITY (AS PER VISCOMETER BS-4 AT 20.0 ± 0.5°C)	14-22	FILM RESISTANCE TO PETROL ACTION AT 20±2°C (MIN NOT LESS THAN)	1
MASS FRACTION OF NON-VOLATILE SUBSTANCES, % (NOT LESS THAN)	9-13		
AQUEOUS EXTRACT AND NUMBER (mg KPH, NOT MORE THAN)	0-1		
VARNISH DRYING TIME (HRS NOT MORE THAN)			
UP TO 1ST DEGREE AT 20±2°C	0-5		
UP TO 3RD DEGREE AT 20±2°C	—		
UP TO 3RD DEGREE AT 30±2°C	4		
VARNISH FILM APPEARANCE	SMOOTH, COLOUR-LESS, HOMOGENEOUS SURFACE (WITHOUT DITS AND MECHANICAL INCLUSIONS)		
VARNISH FILM HARDNESS AS PER PENDULUM INSTRUMENTS (3 STANDARD UNITS, NOT LESS THAN)	0-55		

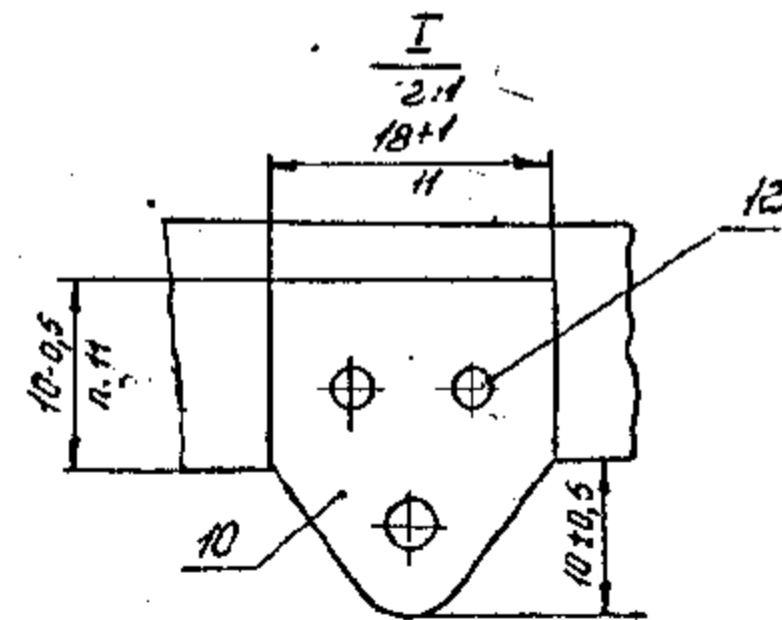
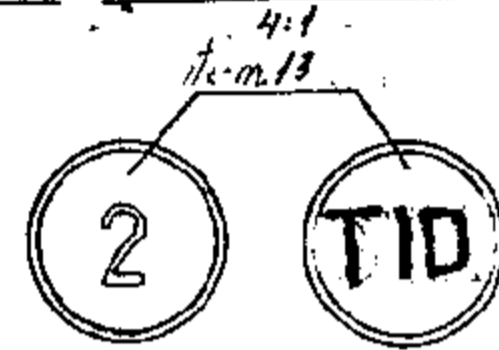
PILOT SAMPLE: THREE SAMPLES SHALL BE SUBMITTED TO CIFE PUNE FOR THEIR TEST AND APPROVAL BEFORE THE COMMENCEMENT OF BULK SUPPLY.

B64.171.062.05

INSCRIBED	DRG NOT TO BE SCALED	PERTAINS TO
CHECKED	ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	
APPROVED	ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE SPECIFIED	
DATE	WOODEN BOX CONTAINER FOR TROPICAL AND SEAWORTHY PACKING	B64.171.062.05
TOLERANCE UNLESS OTHERWISE SPECIFIED	SCALE:	
GEN. L.D.C.	CONTROL RATE OF INSPECTION	FIRE FIGHTING EQUIPMENT



Example of imprint on seal



- 1) Box should be made of soft wood, not worse than grade II plywood of grade K with a humidity not more than 15%.
- 2) Assemble the side walls using casein glue, of GOST 3056-74. Bottom and planks are to be secured with casein glue and nailed with nails, Ref. No. 2, at a spacing 25 ± 5 mm, in so doing, projecting ends of nails are to be bent into wood flush.
- 3) Parts should be planed. Roughness of processed wood should be at least R_z max. 320 R_a max. 200.
- 4) Unspecified limit deviations of dimensions are ± 1.0 mm.
- 5) Paint the box on the outside with enamel Hu 25, GOST 5406-73 in 2 layers and in 1 layer inside colour of paint used for external surfaces of container No. 1 is yellow and that for other containers is green.
- 6) Apply inscription onto the container in compliance with ~~GOST 14192-77~~ using indelible black paint MK-74, OST 4ГО.014.002 and type no-20, GOST 2930-62.
- 7) Packing box should be secured with steel band. Band is nailed with nails, Ref. No. 3.
- 8) Mark signs BHK, OX and bc as per GOST 14192-77. Sign No. 2 is used.
- 9) Warning signs should be placed at the left upper corner on two adjacent walls of the container.
- 10) Before assembling the box make recesses with dimensions as per drawing in parts, Ref. No. 4 (2pcs).
- 11) Secure rugs, Ref. No. 10, on box cover, Ref. No. 5, (1 piece), aligning them with lugs on the box.
- 12) Squeeze seals, Ref. No. 11 the following imprints should be present on the seal. On one side - "TID" on the other side - TID representative No. Use type no-25, GOST 2930-62. Profile $h = 0.3$ to 0.5 mm. Imprint on the seal is to be coated with varnish AK-113Ф, GOST 23832-79, two times.
- 13) Internal surfaces of the container is to be lined with packing paper, Ref. No. 14.

Designation	L	L1	L2	b	B1	H	H1	Box Marking	L3	L4
854.171.065	450	470	117	320	420	230	290	1	30	50
854.171.065-01	530	550	137	375	475	320	380	2	30	50

96 ECKD
D.134

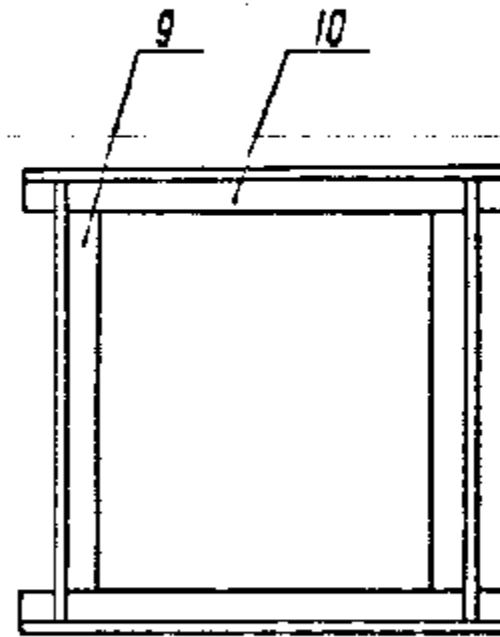
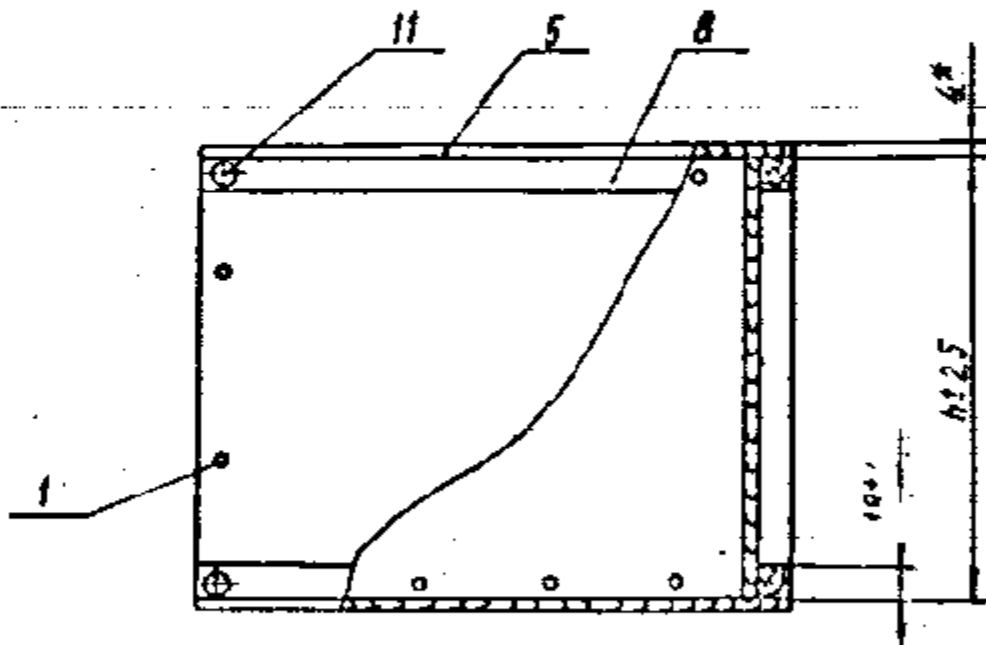
854 171 065 C6

DESIGNER	Y.R. Ganesh
CHECKED	
DATE	
NAME	
SIGN	
DATE	

EXPORT WOODEN BOX
CONTAINER PACKAGE
(Assembly Drawing)
CIF, PUNE

SHEET NO	5
TOTAL SHEETS	

854.171.067



1. *Dimensions are given for reference.
2. **Dimension is provided by tools.
3. Absolute humidity of wood planks should not exceed 20% , and that of ply wood should not be more than 15%.
4. Roughness of plank surfaces should not be more than Rz max 800 , GOST 7016-75.
5. Limit deviations of dimensions are as follows:
For length of planks -2mm,
for length and width of plywood ± 2.5 mm.
6. Parts of the container are secured with nails, Ref.No.1, at a spacing of 40 to 60mm. in amounts of not more than 4 pieces on one side of the plank
7. Mark signs BHK- 1, OX-1, 6C-1 as per GOST 14192-77, the left upper corner of two adjacent side walls of the container using black enamel HLJ-25. GOST 5406-73.
8. Internal surfaces of the container are to be lined with packaging paper, Ref.No.3.
9. Install cover, Ref.No.5, while packing.
10. Projecting ends of the nails are to be bent into the plank in one plane.
11. Make-grooves in container ribs in compliance with drawings 1 and 2. Shape of groove arbitrary; dimensions are within the limits specified in removed element II.
12. Twine should enter the grooves when passing the container ribs. Twine should be tightly bound with knot, so that it can't be removed or shifted.
13. Binding ends with a length of 100mm, minimum, should come to the left lateral side of parcel with respect to the address.

See continuation of table on sheet 2.

Designation.	Dimensions, mm						Drawings.
	l	B	h	L	B	H	
854.171.067	204	160	110	240	198	118	1
-01	240	204	170	276	240	178	1
-02	300	230	300	336	266	308	2
-03	314	240	170	350	276	178	2
-04	320	320	100	356	256	108	2
-05	285	235	190	321	271	198	2
-06	445	255	164	481	291	172	2
-07	414	290	190	450	316	198	2
-08	420	210	205	456	246	213	2
-09	490	320	220	526	356	228	2
-10	440	345	190	476	381	198	2

14. The following imprints should be present on seal, Ref.No.2, on one side -"TID", on the other side-TID representative No. Use type П0-2,5, sign M-2,5, GOST 2930-62, concave profile, h=0,3 to 0,5mm.

15. Critical mass of the container with articles packed into it is 10 kgs, maximum.

104
17-131

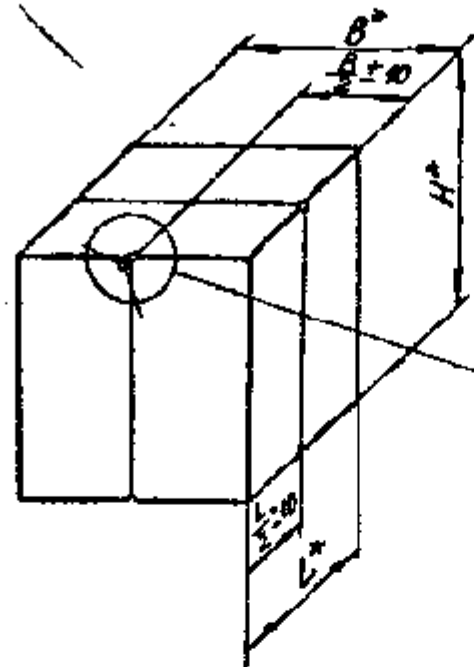
SINO SHEET	DOCNO	SIGN	DATE	PARCEL POST CONTAINER. PACKAGES. Assembly drawing.	854.171.067 CB	
DRAWN BY	P.R.BABU		14.6.85		SHEETS	WEIGHT/SCALE
EDITED AND CHECKED BY					6	-
FOREMAN OF DC	S.R.NAR				TOTAL SHEET	
DIVISIONAL OFFICER	A.K.KONDU		20-7-85	CIFE, PUNE		
	NAME	SIGN	DATE			

854.171.067.C5

854.171.067

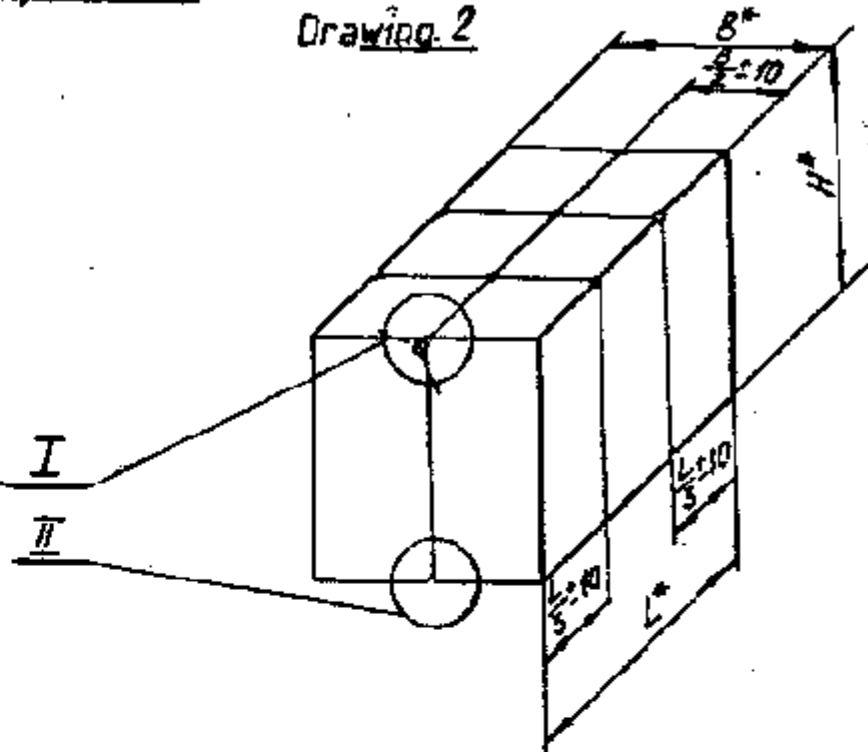
Binding method

Drawing 1



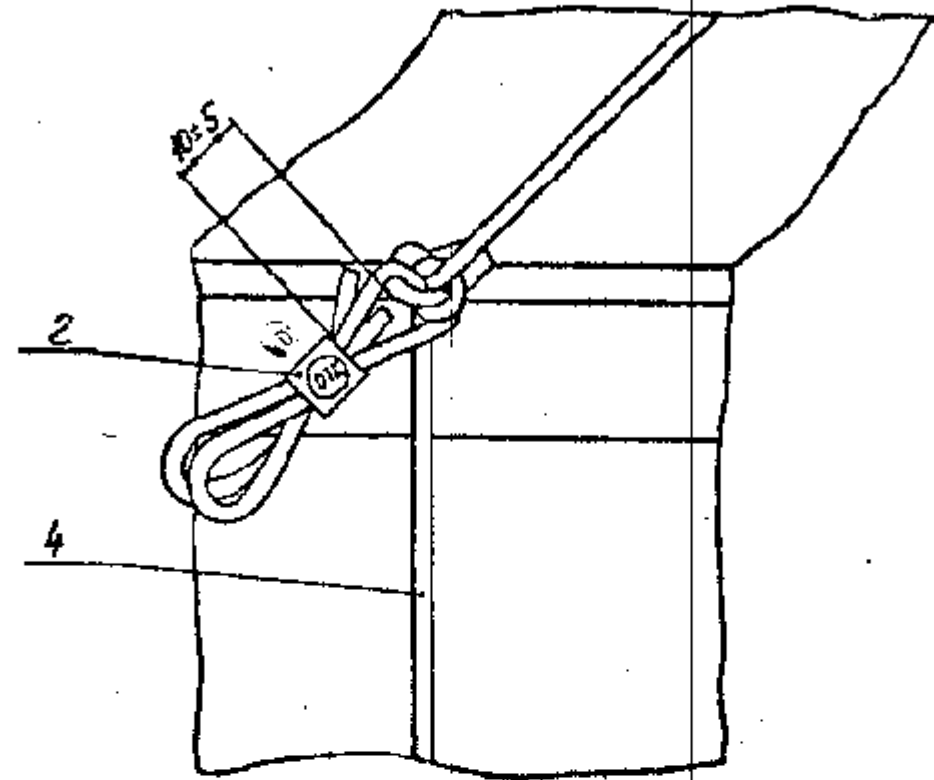
II
M 1:1

Drawing 2

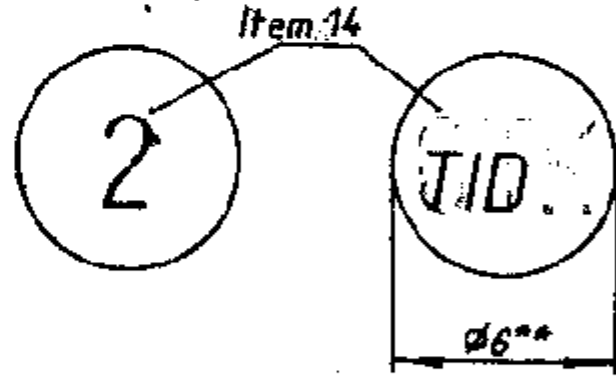
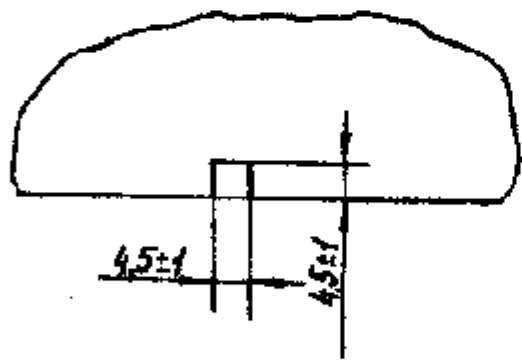


Example of imprint on seal

I
M 1:1



Before placing seal, Ref.No.2, twine ends should be folded as shown in view I.



Designation.	Dimensions, mm.						Drawing.
	L	B	H	L	B	H	
854.171.067 - 11	395	385	155	431	421	163	2

ECKA

105
D-134

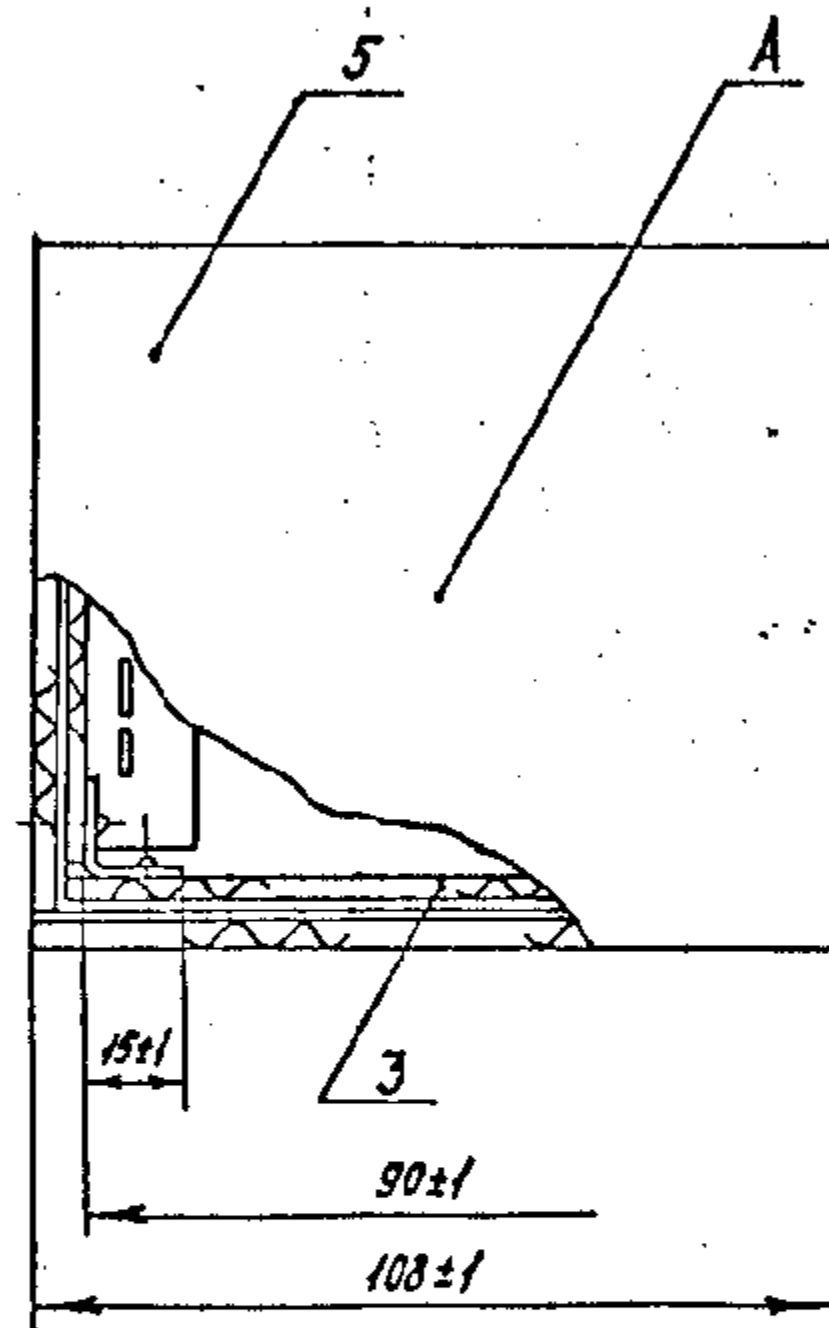
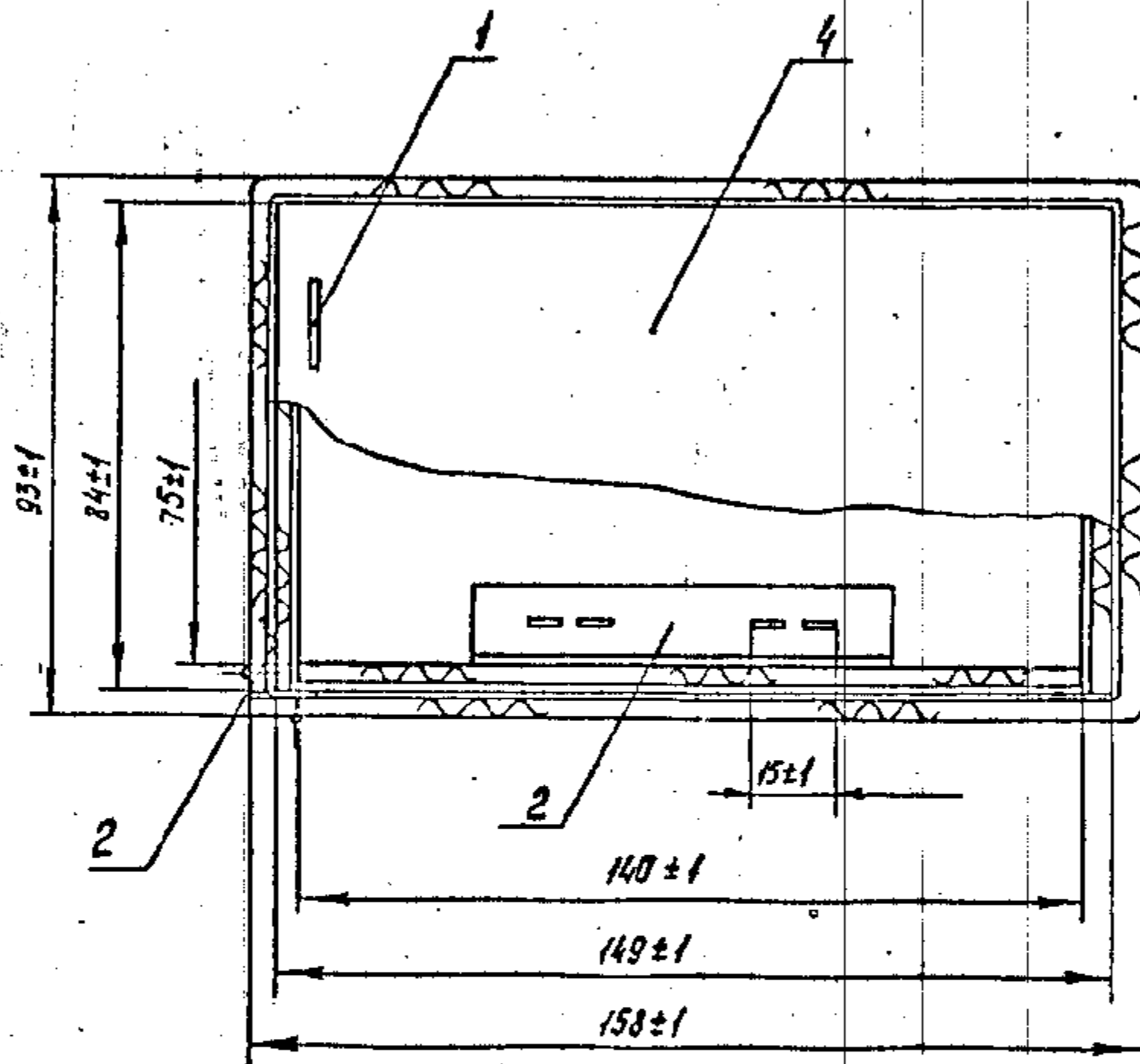
SHEET NO.	DRAWN BY	DATE
	PR.BARE	12.6.55
EDITED AND CHECKED BY		
FOREMAN OF DC		
DIVISIONAL OFFICER		
NAME	SIGN	DATE

PARCEL POST
CONTAINER
PACKAGES.
Assembly drawing.
CIFE, PUNE

854.171.067.C5

SHEETS			
TOTAL SHEETS			

150798



1. Shape parts, Ref.Nos 3,4,5 by bending at right-angle as per dimensions specified in the drawing.
2. Bend board, Ref.Nos.2, at right angle in the middle of the width and secure with edges of parts Ref.Nos 3,4,5 at four points using wire, Ref.No.1.
3. Stitch board, Ref.No.2, to parts Ref.Nos.3,4,5 at a distance of not less than 5mm from butt -ends of part Ref.No.2, at a spacing of (25 ± 2) mm.
4. After stitching the board bend wire ends.
5. Stick the tag to surface 'A' with starch gum, GOST 6034-74.

107
D-131

ECKA

854.180.139CB

SLNO	SHEET	DOCNO	SIGN	DATE
DRAWN BY		P.R.BABU		12.4.85
EDITED AND CHECKED BY				
FOREMAN OF DC		S.R.NAIR		
DIVISIONAL OFFICER		A.K.KUNDU		16.7.85
	NAME	SIGN	DATE	

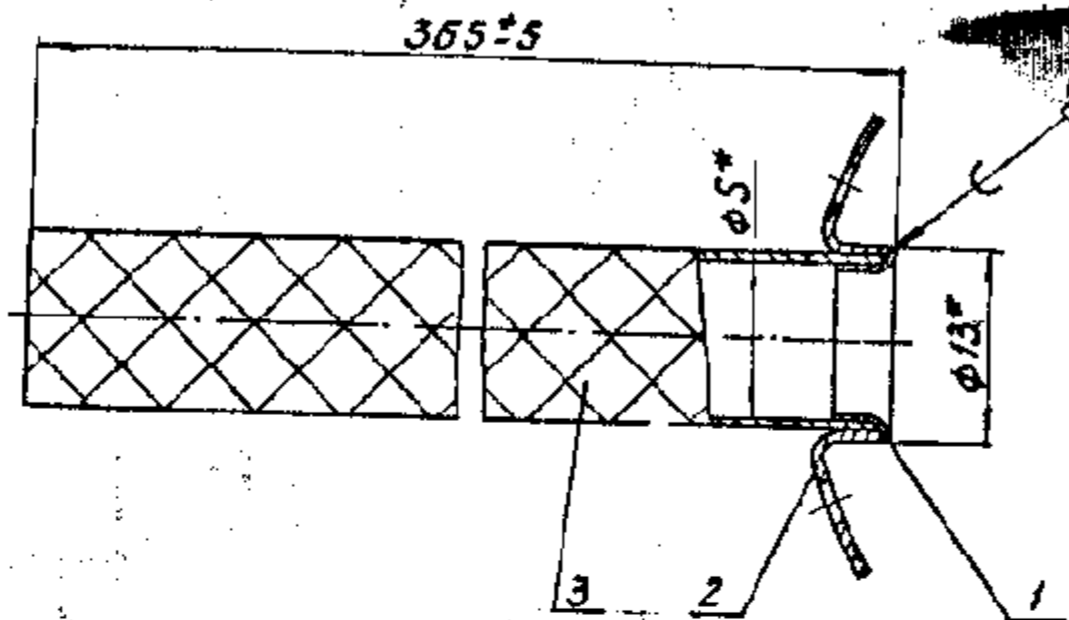
UNIT PACK.
Assembly drawing.

SHEETS	WEIGHT	SCALE
15		1:1
TOTAL SHEETS		

CIFE, PUNE

866 430 232CB

ПОУКАЗ. ПРИМЕР



1. *Dimensions are given for reference.

2. Coat the soldered joints with varnish Ak-113φ, GOST 23832-79 by tinting them with rhodaminee TY6-14-1088-74.

3. noc-40, GOST 21931-76

29
D-131

ECKA

866.430.232CB

SHEET	WEIGHT	SCALE
6	25g	2:1
TOTAL SHEETS		

SCREEN
ASSEMBLY DRAWING

NO. IN POS.	NO. IN POS.	NO. IN POS.	NO. IN POS.
1	1	1	1
2	2	2	2
3	3	3	3
4	4	4	4
5	5	5	5
6	6	6	6
7	7	7	7
8	8	8	8
9	9	9	9
10	10	10	10

866 430 232CB

EXPLANATORY NOTES TO TECH. CONDITIONS

I) COAT THE SOLDERED JOINTS WITH VARNISH AK-113φ (GOST 23832-79). VARNISH AK 113φ REPRESENTS SOLUTION OF POLYACRYLIC MELAMINE FORMALDEHYDE RESIN IN MIXTURE OF ORGANIC SOLVENTS WITH ADDITION OF PLASTICIZERS.

II) THE PHYSICO-MECHANICAL PROPERTIES:

DESCRIPTION	NORMS FOR VARNISH	DESCRIPTION	NORMS FOR VARNISH
	AK 113φ - OK 77 23-1331-0200-05		AK 113φ - OK 77 23-1331-0200-05
1) VARNISH APPEARANCE	TRANSPARENT HOMOGENOUS LIQUID WITHOUT MECHANICAL IN- CLUSIONS, LIGHT OPALESCENCE IS PERMITTED	6) VARNISH DRYING TIME HRJ NOT MORE THAN a) UP TO 1ST DEGREE AT 20±2°C b) UP TO 3RD DEGREE AT 80±12°C	0.5 4
2) VARNISH COLOUR ON INDOOMETRIC SCALE Mq IODINE NOT DARKER THAN	5	7) VARNISH FILM APPEARANCE	SMOOTH COLOURLESS HOMOGENOUS SURFACE WITHOUT PMS AND MECHAN- ICAL INCLUSIONS
3) VARNISH RELATIVE VISCOSITY AC- CORD PER VISCOSIMETER 03-A AT 20±0.5°C	14-22	8) VARNISH FILM HARDNESS AS PER PENDULUM INSTRUMENT M3 STAND- ARD UNITS, NOT LESS THAN	0-55
4) MASS FRACTION OF NON-VOLATILE SUBSTANCES %, NOT LESS THAN	9-13	9) FILM BENDING NOT MORE THAN	1
5) AQUEOUS EXTRACT ACID NUMBER Mg KOH, NOT LESS THAN	0.1	10) FILM RESISTANCE TO WATER ACTION AT 20±2°C HRS NOT LESS THAN	4
		11) FILM RESISTANCE TO PETROL ACTION AT 20±2°C NOT NOT LESS THAN	1

III) RHODAMIN "C" (SPECN TY6-14-1088-74)

RHODAMIN "C" IS A ORGANIC DYE RHODAMIN "C" AS PER TECHNICAL PROPERTIES, BELONG TO THE GROUP OF BASIC DYES, AS PER ITS CHEMICAL STRUCTURE - TO THE XANTHENE DYE GROUPS AND IS DERIVED BY CONDENSATION OF DIETHYLAMINOPHENOL WITH PHTHALIC ANHYDRIDES (FORMULA (C₂₀H₁₆N₂O₃·N₂Cl) MOLECULAR WT 419.02)

IV) TINT THE SOLDERED JOINTS WITH RHODAMIN "C" OF TY 6-14-1088-74

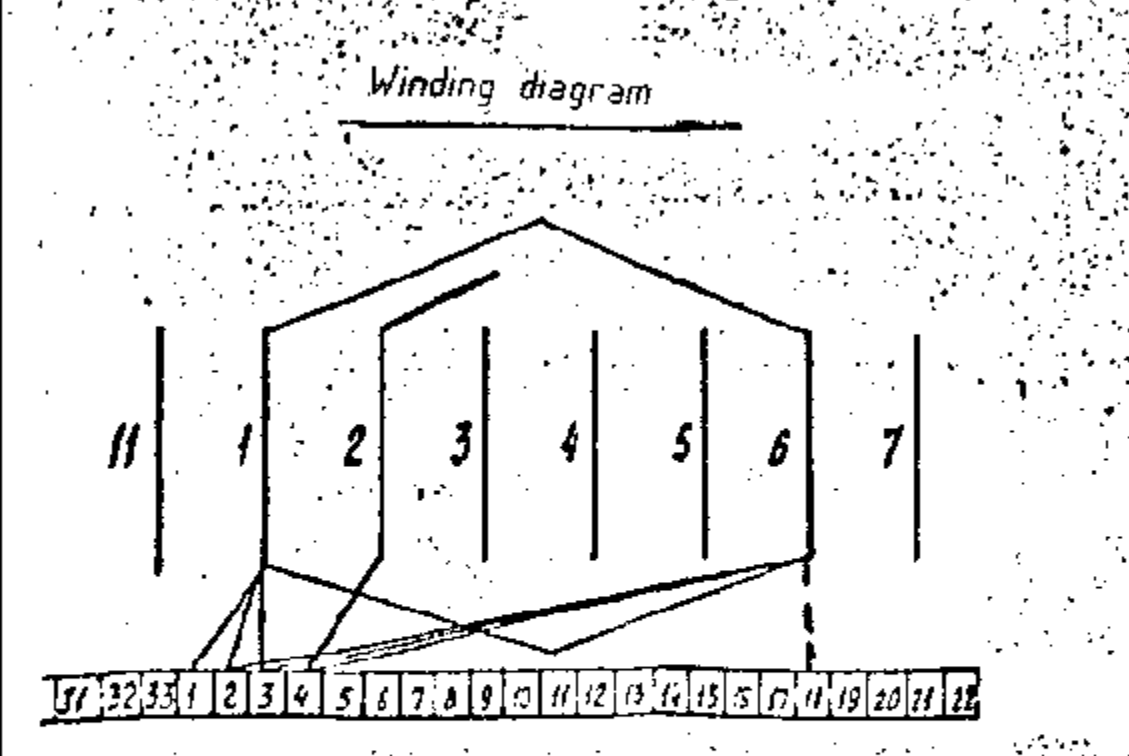
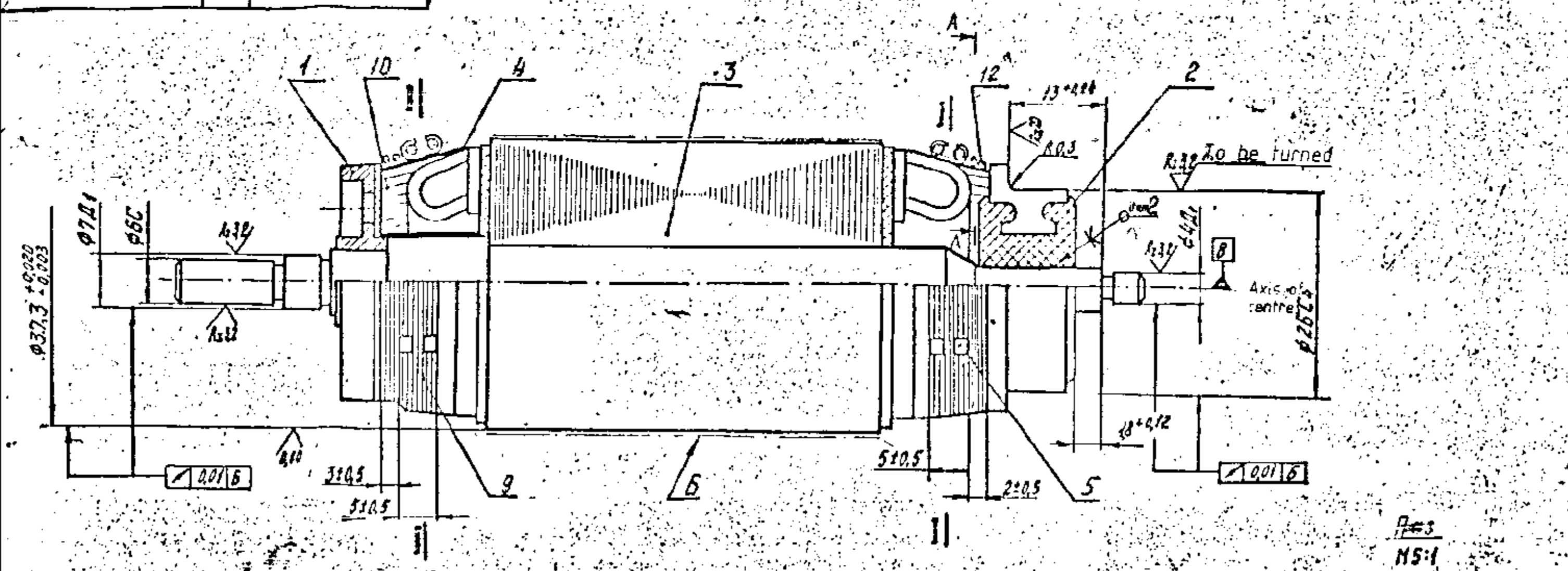
PHYSICAL & CHEMICAL PROPERTIES:

NAME OF THE PROPERTIES	STANDARDS
1) EXTERNAL APPEARANCE	UNIFORMLY CRYSTALLINE DARK RED POWDER A GREENISH SHADE IS PERMISSIBLE
2) CONCENTRATION IN RELATION TO THE STANDARD SAMPLE	100%
3) SHADE	CORRESPONDS TO STANDARD SAMPLES
4) CONTENT OF IMPURITIES INSOLUBLE IN WATER % NOT LESS THAN	1
5) SOLUBILITY IN WATER	5 POINTS
6) RESIDUE AFTER STRAINING THROUGH A FINE WITH GAUGE NO 056K GOST 3584-53 % NOT MORE THAN	5
7) STEADINESS OF COLOUR ON PAPER IN RELATION TO THE ACTION OF LIGHT	CORRESPONDS TO THE STEADINESS OF COLOUR REGULATED BY THE DYE OF STANDARD SAMPLE

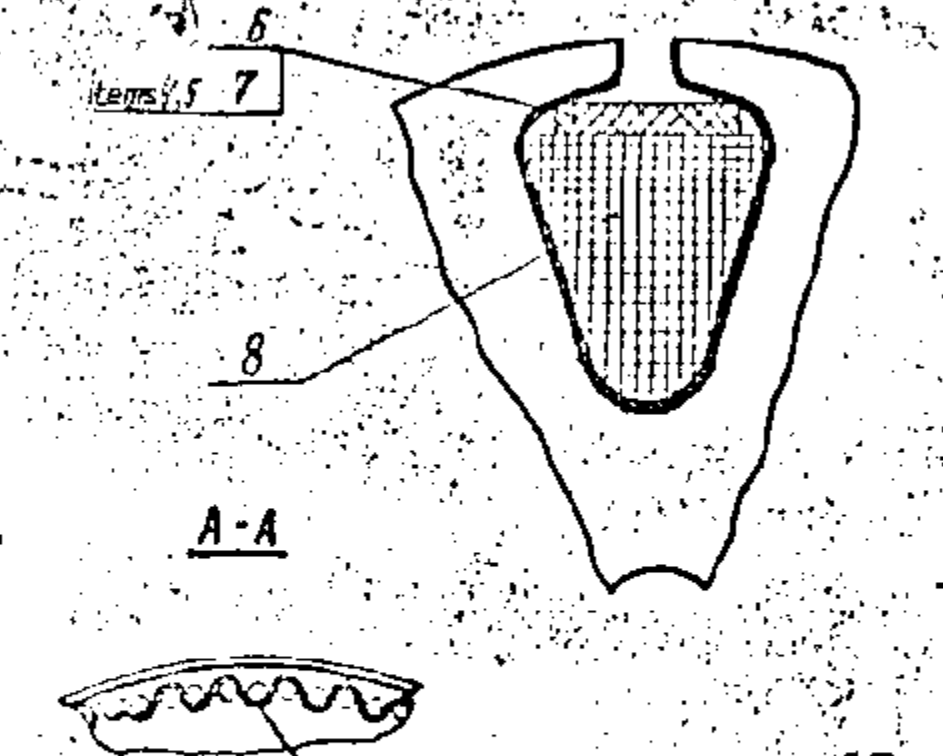
V ITEM NO-3 INDICATES SOLDERING ALL ROUND WITH SOLVENTS CI 00-41) GRADE SAHO TO IS 113-82 MENTIONED AT NOTE 3

INSCRIBED	ORIG NOT TO BE SCALED	PERTAINS TO
CHECKED	ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	
APPROVED	ALL DIMENSIONS ARE IN MM. UNLESS OTHERWISE SPECIFIED	
DATE	SCREEN	866-430-232CB
TOLERANCE UNLESS OTHERWISE SPECIFIED	SCALE	
GEN'L DEC		

856.765.793 C6



Winding data			
Number of turns in section	Section sides in slot	Number of conductors in slot	Resistance of armature winding at 293K(20°) ohm
7, 8, 9	6	44	0.85 ± 0.01



1. Make labyrinth, Ref.No.1, a press fit upto the stop
2. Use phenol-formaldehyde lacquer 76C-2 GOST 901-78.
3. Set commutator so that the commutator segment is arranged along the slot axis with a deviation of $\pm 1^\circ$
4. Depending on wire filling of slot of armature, set wedges, Ref.Nos.6, 7. Set wedges, Ref.Nos.6, 7 if necessary. Projection of wedges beyond the stack should not exceed 1 mm to each side.
5. If it is impossible to set wedges, Ref.Nos.6, 7, it is allowed to install auxiliary sleeves - 4.1 1.5x0.3, GOST 22056-76, in slots when the armature is made.
6. Insulate the ends of wires of armature-winding with calico band, Ref.No.11, and solder them to commutator risers 03. GOST 860-75.
7. Bind wire Ref.No.9, by applying a force of 5 to 7kgf and solder using solder noc-40. GOST 21931-76.
8. Use solder noc-40 for soldering clamps, Ref.No.5.
9. Check armature for permeance as per 9b0 045.342.
10. Impregnate the armature with varnish M-92, GOST 15865-70.
11. Correct the disbalance of armature in correcting I-I and II-II by soldering up solder noc-40 onto binding wires, Ref.No.9, and clamps, Ref.No.5. Permissible residual disbalance in each correction plane is 1.5g.mm.
12. Coating of surface B: Primer F-021 TY6-10-1642-77. Thickness of a coating is 0.01 to 0.02mm.
13. Blunt the sharp edges of commutator segments with chamfers 0.1x45° max.

ЕСКД

856.765.793 C6

DATE	12.4.95
SCALE	1:1
TOTAL SHEETS	1
ARMATURE ASSEMBLY DRAWING	

856.765.793 C6

EXPLANATORY NOTES TO TECH. CONDITIONS

- 1) PHENOL-FORMALDEHYDE LACQUER GRADE II. 6C-2 RESONANT TYPE OF GOST 901-78 HAVING THE FOLLOWING PHYSICO-CHEMICAL AND MECHANICAL PROPERTIES AS PER GOST 901-78.
- 2) EXTERNAL APPEARANCE - FROM REDDISH TO BROWN BROWN COLOR NOT CONTAINING SUSPENDED PARTICLES
- 3) WEIGHT FRACTION OF RESIN % - 60 - 75
- 4) VISCOSITY DYNAMIC MAX. 5000
- 5) WEIGHT FRACTION OF FREE PHENOL % MAX. 11.5
- 6) TIME OF GELATINATION SEC. - 50 - 120
- 7) SOLDER GRADE 03 OF GOST 860-75:
 - 1) TIN (NOT LESS THAN) - 98.4%
 - 2) AS - 0.03%
 - 3) FE - 0.02%
 - 4) CU - 0.10%
 - 5) PB - 1.0%
 - 6) BI - 0.06%
 - 7) SB - 0.3%
 - 8) S - 0.02%
 - 9) OTHER - 1.5%
- 8) PERMISSIBLE IMPURITIES SOLDER GRADE 110C-40 OF GOST 21931-76 AS PER GRADE SN 40 OF IS: 193-82

VARNISH M-92 OF GOST 15865-70

- 1) PROPERTIES OF ELECTRICAL INSULATING VARNISH M-92 AS PER GOST 15865-70.
- 2) PRESENCE OF MECHANICAL IMPURITIES - ABSENT IN VARNISH
- 3) EXTERNAL APPEARANCE OF FILM - AFTER DRYING THE VARNISH SHOULD FORM A GLOSSY SMOOTH PLANE FILM FORM LIGHT BROWN TO DARK BROWN COLOUR.
- 4) VISCOSITY AS PER VISCOMETER B3-4 AT 20°C IN SEC. (MIN.) - 25
- 5) CONTENT OF DRY-RESIDUE IN % - 50 - 55
- 6) ACID NO. mg OF KOH(MAX) - 10
- 7) CONTENT OF SEPARATE FORMALDEHYDE IN % (MAX) - 0.6
- 8) TIME OF BUBBLING AT 105-110°C IN HRS. (MAX.) - 0.1
- 9) DRYING CAPACITY OF VARNISH IN THICK LAYER AT 115-120°C IN HRS.(MAX.) - 16
- 10) THERMO ELASTICITY AT LAYER AT 150°C IN HRS. (MIN.) - 48
- 11) HARDNESS OF LAYER AS PER PENDULUM-INSTRUMENT AT 20±1°C (MIN) - 0.40
- 12) OIL RESISTANCE OF FILM IN HRS (MIN) - 8
- 13) ELECTRICAL STRENGTH OF FILM IN KV/CM - 65
- 14) AFTER THE ACTION OF WATER FOR A PERIOD OF 24 HOURS AT 20±2°C

- 15) SPECIFIC-VOLUMETRIC ELECTRIC-RESISTANCE OF A FILM IN CM (MIN) AT 20±2°C
- 16) AFTER THE ACTION OF WATER FOR A PERIOD OF 24 HRS AT 20±2°C

TOLERANCE

- 1) $\phi 7 A1 = \phi 7 -0.005 -0.011$
- 2) $\phi 6 C = \phi 6 -0.0 -0.008$
- 3) $\phi 26 C4 = \phi 26 -0.0 -0.14$

COATING ON SURFACE B: PRIMER CONFORMING TO IS: 5660-70

SURFACE ROUGHNESS

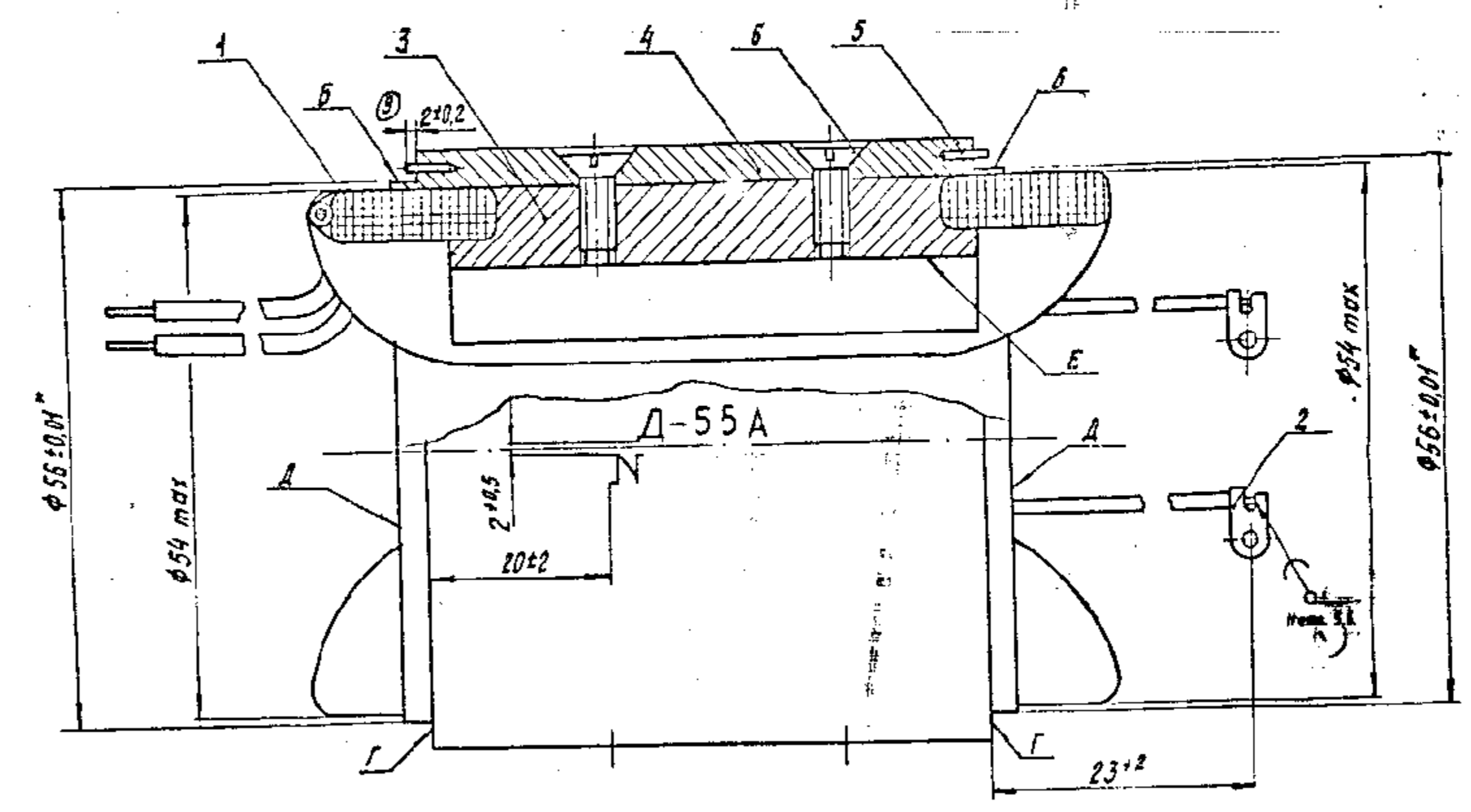
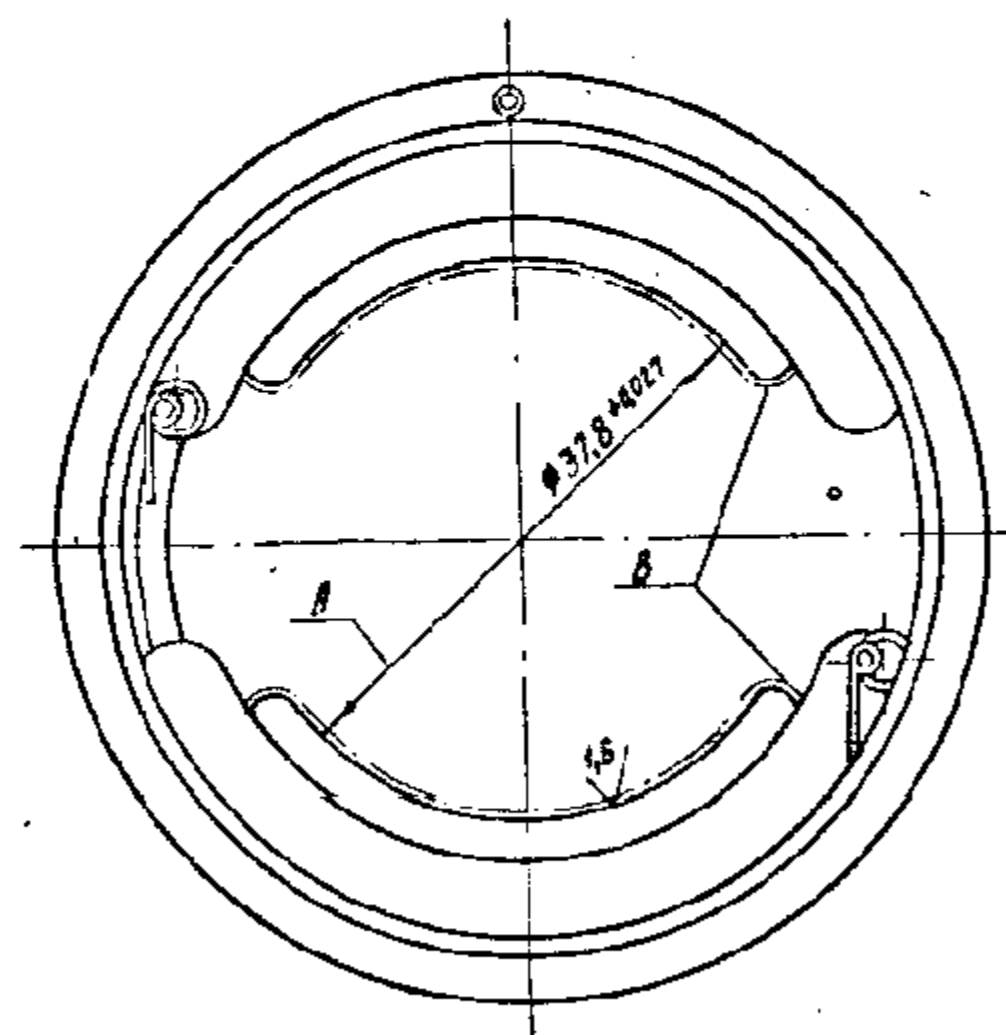
- 1) $Ra 32$ - INDICATE SURFACE FINISH Ra VALUE 32 MICRO
- 2) $Ra 20$ - INDICATE SURFACE FINISH Ra VALUE 20 MICRONS
- 3) $Ra 10$ - INDICATE SURFACE FINISH TO BE OBTAINED BY MACHINING OF Ra VALUE 10-14

B - BASE IS B

$\sqrt{0.01} B$ - REPRESENT RUNOUT OF INDICATED DIMENSION TO WITHIN 0.01 mm FROM THE BASE INDICATED AS B

\curvearrowright - INDICATE SOLDERING ALL ROUND.

INSCRIBED		DRG. NOT TO BE SCALED.	PERTAINS TO
CHECKED	<i>[Signature]</i>	ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.	
APPROVED	<i>[Signature]</i>	ALL DIMENSIONS ARE IN MM. UNLESS OTHERWISE SPECIFIED.	
DATE	17.11.86		
TOLERANCE UNLESS OTHERWISE SPECIFIED - GEN. DEC. ANG.		ARMATURE ASSEMBLY DRAWING	B56.76 5.793 C6
SCALE		CONTROLLER RATE OF INSPECTION FIRE FIGHTING OPTIM	



1. *Dimensions are given for reference.
2. Rounding-off radii should not be more than 0,2mm.
3. Unmachined bands should be uniform along the edges of poles as per dimension A. Tolerance on non-uniformity is checked by dimension of ground chord (29±1) mm.
4. Impregnate the stator with varnish Mf-92, GOST15865-70.
5. Install end pieces, Ref.No.2, after impregnating and polishing the poles. Squeeze tightly. Use solder ПOC-40, GOST 21931-76.
6. Coat soldered joints with varnish AK-113Ф, GOST 23832-79, by tiating with rhodamine 'C' TY6-14-1088-74.
7. Coating of external surface of frame Ref.No.4, except surfaces Г and Д; black enamel ПФ-241 M TY6-10-1676-78. II. X₃ Respraying of black enamel is allowed on surface Г and output leads.

8. Coating of surface B: primer ГФ-021, TY6-10-1642-77. Thickness of coating is 0,01 to 0,02mm.
9. Check the stator permeance as per B60.045.342.
10. Code and number sign should be applied by offset printing with marking paint БМ TY29-02-405-72. Use type П0-3 for letters and figures, and type M-3, GOST 2930-62 for the sign.
11. Eccentricity of surface B with respect to surface E, should not exceed 0,04 mm (qualified tolerance).
12. Secure screws, Ref.No.6, as per B60.045.602 T4, view-2, with black enamel ЭП-274.

NO	DOC NO	SIGN	DATE
DRAWN	ARBAKU		11.10
ED. CHECK	OK		
PM DC	SINAR		
DIV OFFR	AK KANDU		
	NAME	SIGN	DATE

866.767.135 C6

SHEET WEIGHT/SCALE

0,608 2:1

TOTAL SHEETS

ARMATURE WITHOUT WINDING

Assembly Drawing

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

REF NO.4 - TECHNICAL REQUIREMENT OF ELECTRICAL INSULATING VARNISH GRADE Mf-92 AS PER GOST 15865-70 IS GIVEN BELOW

- 1) EXTERNAL APPEARANCE OF FILM OF VARNISH AFTER DRYING, THE VARNISH SHOULD FORM A GLOSSY SMOOTH PLANE FILM FROM LIGHT BROWN TO DARK BROWN COLOUR
- 2) VISCOSITY AS PER VISCOMETER B3-4 AT 20°C IN SEC, NOT LESS THAN 25
- 3) CONTENT OF DRY RESIDUE 18% — 50-55
- 4) ACID NO 181 MG OF KOH, NOT MORE THAN 10
- 5) CONTENT OF SEPARATE FORMALDEHYDE IN % NOT MORE THAN 0.6
- 6) TIME OF DISTICATION AT 105-110°C IN HRS, NOT MORE THAN 1
- 7) DRYING CAPACITY OF VARNISH IN THICK LAYER AT 115-120°C IN HRS, MAX 16
- 8) THERMOELASTICITY OF LAYER AT 150°C IN HRS 48 (MIN)
- 9) HARDNESS OF LAYER AS PER PENDULUM INSTRUMENT AT 20±1°C 0.40 (MIN)
- 10) OIL RESISTANCE OF FILM IN KG 8 (MIN)
- 11) ELECTRICAL STRENGTH OF FILM 5kV/mm AT 20±2°C 65 (MIN)
- AFTER THE ACTION OF WATER FOR A PERIOD OF 24 HRS AT 20±2°C 30
- 12) SPECIFIC VOLUMETRIC ELECTRIC RESISTANCE OF FILM IN OHM·CM AT 20±2°C 1·10¹⁴ (MIN)
- AFTER THE ACTION OF WATER FOR A PERIOD OF 24 HRS AT 20±2°C 5·10¹²

REF NO.5 USE SOLDER GRADE ПOC AD, EQUIVALENT IS 193-82 GRADE SN-40

1) VARNISH APPEARANCE — TRANSPARENT HOMOGENOUS LIQUID WITHOUT MECHANICAL INCLUSIONS LIGHT APPEARANCE IS PERMITTED

- 2) VARNISH COLOUR ON 100MM METRE SCALE IN 100MM, NOT DARKNESS THAN 5
- 3) VARNISH RELATIVE VISCOSITY AS PER VISCOMETER B3-4 AT 20±0.1°C 14-22
- 4) MASS FRACTION OF NON-VOLATILE SUBSTANCE (MIN) 9-13%
- 5) AQUEOUS EXTRACT ACID NUMBER MG - KOH 0.1 (MAX)
- 6) VARNISH DRYING TIME HRS (MAX)
 - a) UP TO 1ST DEGREE AT 20±2°C 0.5
 - b) UP TO 3RD DEGREE AT 80±2°C 4
- 7) VARNISH FILM HARDNESS AS PER PENDULUM INSTRUMENT M3 STANDARD UNITS 0.65 (MINIMUM)

- 8) FILM BENDING (MM) — 10MM (MAXIMUM)
- 9) FILM RESISTANCE TO WATER ACTION AT 20±2°C HRS 4 (MINIMUM)
- 10) FILM RESISTANCE TO PETROL ACTION AT 20±2°C MIN 1 (MINIMUM)

REF NO.6 MELAMINE VARNISH AK-113Ф REPRESENTS SOLUTION OF POLYACRYLIC FORMALDEHYDE RESINS IN MIXTURE OF ORGANIC SOLVENTS WITH ADDITION OF PLASTICIZERS

REF NO.7 RHOAMIN TO TO TY6-14-1088-74 IS A BASIC DYE HAVING EMPIRICAL FORMULA (C₂₈H₃₁O₃N₅Cl) (MOLECULAR WT. 479.02) DERIVED BY CONDENSATION OF DIETHYL METAMIN PHENOL WITH PHTHALE ANHYDRIDE.

SURFACE FINISH:

1) SURFACE FINISH OF RA VALUE 4-6

2) SOLDER, ALL ROUND AS PER ITEMS 5-6

INSCRIBED	CHECKED	APPROVED	DATE	DATE	SCALE
				21.10	
				DRAFT NOT TO BE SCALED	
				ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	
				ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE SPECIFIED	
				ARMATURE WITHOUT WINDING	
				ASSEMBLY DRAWING	
				SCALE: 1:1	
				OTHERWISE SPECIFIED	
				GEN. REC. ONE	
				CONTROLLEER OF INSPECTION FIRE FIGHTING SQPT PUNE	

888 825 001

13E05

5:05



ЛИСТ УПАКОВОЧНЫЙ
ИЗДЕЛИЕ ТИП _____

КОЛИЧЕСТВО _____ ШТ
ДАТА КОНСЕРВАЦИИ _____
УПАКОВЩИК _____
ОТК _____
ДАТА УПАКОВКИ _____

74±1

66±1

97±1

105±1

*(1) PACKING LIST
ARTICLE, TYPE _____
QUANTITY _____ PGS
DATE OF PRESERVATION _____
PACKED BY _____
QCD _____
DATE OF PACKING _____

for printing, use type 03-8 GOST 3489.10-71. To print the inscription "packing list", use type 63-16 GOST 3489.7-71

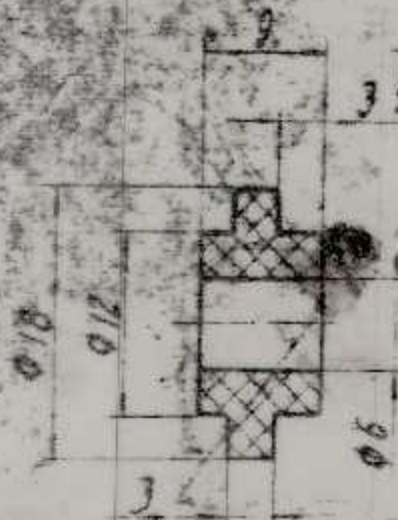
8/ D209/

APPROVED	<i>[Signature]</i>	ВЛ8.825.001	
CHECKED	<i>[Signature]</i>	DATA SHEET	WEIGHT SCALE
CONTROLLERATE OF INSPECTION (ICV)			0.0004
		PAPER NO. 1, A MACHINED FINISHED, SORT 1.	

Used on
765-71-CD 574 2 2

USED ON
675-71-CD 200 2 2

127
7/11



1. Moulding radii should not exceed 1 mm.
2. Unspecified limit deviations of dimensions are:
For holes -as per A₇ and for shafts -as per B₇.
3. Rest of requirements are as per OST 4ГО.005.51.
4. Alternate material is Poliamide КПС-30 grade 1,
ГОСТ 17648-72.

MSY
13/11
CMB

765-71-1507

NO	SHT	DOC NO	SIGN	DATE
DRAWN		CH.V.RAO.	<i>[Signature]</i>	25.7.86
EDT,CHKD		D.K.JAIN	<i>[Signature]</i>	28.7.87
F/M,DC.		S.R.NAIK	<i>[Signature]</i>	30.7.88
DIV.OFFR		T.K.BANERJEE	<i>[Signature]</i>	31.7.84
		NAME	SIGN	DATE

INSULATOR

POLIAMIDE П68С-30,
Grade I ГОСТ 17648-72.

SHEET	WEIGHT	SCALE
	0.003	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

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6851/2011

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Armature
Armature without winding
Stator

855.755.133
855.755.133
855.755.133

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13
0.131

№	Designation	Description
1		
2		Branch document
3		
4	OCT4 10.021.192	Casting of non-ferrous alloys General technical specifications
5		
6		
7	OCT4 10.005.051	Plastic articles General technical specifications
8		
9		
10	OCT4 10.054.205	Marking paint MK 35
11		
12	OCT16 O. 505.001-80	Copper wires of circular section with enamel insulation M31B
13		
14		
15	TY6-10-848-75	Enamels KO-822
16		
17	TY6-10-1039-75	Enamels gray and black 3A-274.
18	TY6-10-1676-78	Black enamel ПФ-241 М
19	TY6-14-1088-74	Organic, basic dyes Rhodamine Г
20		
21		
22	TY16-505-324-80	Hook-up wires, grades MГТФ/А and MГТФ/Б
23		
24		
25	TY29-02-405-72	Special marking paints "BM", "KM", "CM", "JM", "EM", "DM"
26		
27		
28	TY6-10-1642-77	Primer ГФ-021.
29		

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