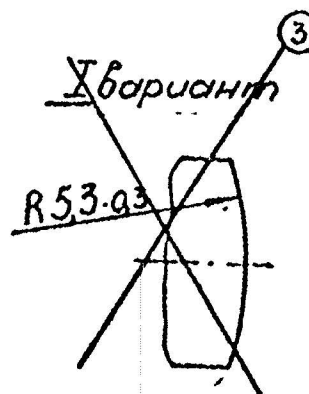
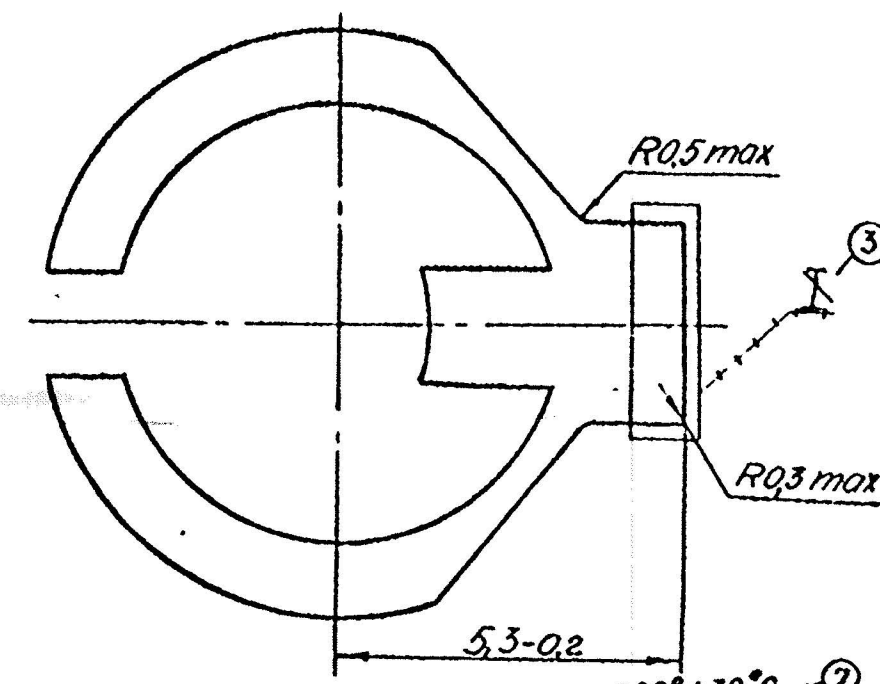
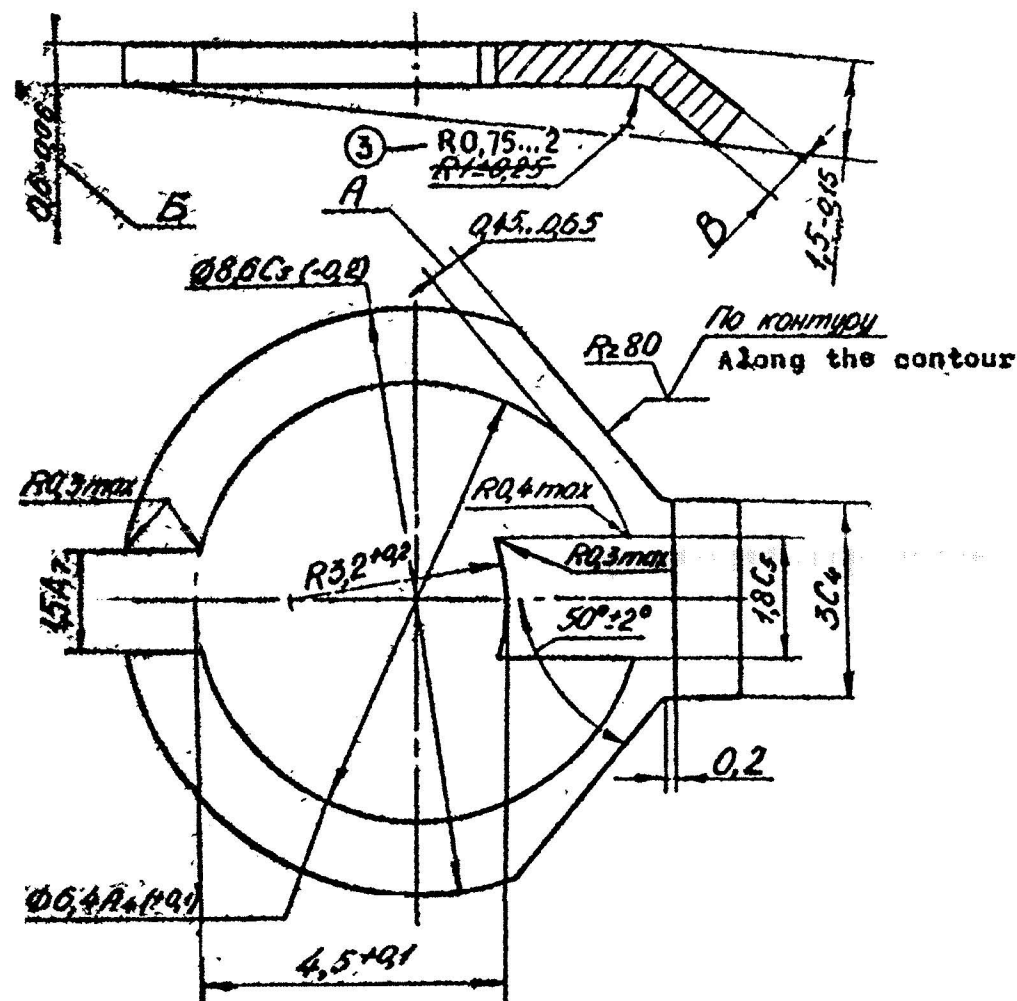




ЕКА



Развертка
~~Development~~



1. Anneal clip at a temperature of $290^{\circ} \pm 30^{\circ}\text{C}$ for two hours in ~~case of~~ vacuum case.

Instead of temperature, ^{to} ensured the fulfillment of requirement No. 6 for one batch of parts not to exceed 30%.

Обозначение по единому классификатору	APPROVED <i>[Signature]</i> FOR CI(A)
	AHSP- CI(A) KIRK EE
9-04092	9-K-715

EIB.388.004	Sheet No	No of Sheet
	1	2

SNC/SRI: DOC NO	SIGN	DATE
DRAWN		
EDT/CHKD		
F/M, DC		
OIV.OFFR		
	NAME	SIGN DATE

SHEET WEIGHT SCALE
X A 0.119 10:1
TOTAL SHEETS
ORDNANCE FACTORY
PROJECT
HYDERABAD

	DEI 3-24-71-A	DRG. PROV. SEALED	<i>lyf...</i>	<i>62</i>
	AUTHORITY	REVISION	SIG AHSP	SIG DO.



АПРНО 0.6 НАА 63

2. Alternate material is bar ~~АПРНА 63~~ GOST 931-78.
 3. *Dimensions for reference, Other dimensions ensured by tools.
 4. Dimension A deviation not to exceed 0.1 MM in one batch of parts.
 5. Coating - chemical passivation/varnish AW-4(1) OST B 84-811-73.
 6. Clip, which is preliminarily tested on impact tester 'Masset' by impacts from the 23rd tooth as a part of assembled unit БУ 6.042.512 with cap downwards in fixture, imitating the position of assembly unit in item, should hold the slider БУ 8.264.006 at 30000 r/min. and should release it at 55000 r/min. The accuracy of measuring rotational frequency should be ± 600 r/min.
- Test the clamps in rotating conditions as a part of assembly unit БУ 6.042.512 with by using part БУ 9.116.044.
- Cap БУ 8.635.085 can be replaced.
- Spot checking. Each batch of parts subjected to checking.
7. Presence of burrs on the edges of parts is allowed provided the dimension Б should not exceed 0,67 MM and dimension B should not exceed 0,9 MM.
 8. The volume of batch and volume of spot checking according to Ref. No. 6 is set by manufacture and is agreed with customer representative at manufacturing plant.
 9. Other requirements are as per OST B 84-264-81.
 10. Clamps can be checked, while accepting the parts, as a part of assembly unit БУ 6.042.512 with using part БУ 9.116.044 without preliminary impact on impact tester "Masset".
 11. BSEN 1652: 1998 DESIGN Cu Zn 37 MATERIAL CONDITION R.550 WITH UTS = 55-65 kgf/mm² & ELON = 4% min.

9- 04092

9 - K 715

БУ 8.388.004		
	No. of Sheet	No. of Shts
	2	2
Clip		

05-01-2011	DGQA S.O. Sec. I Chap 10 para 40	Drg. scan, clean & edit without change & m/c replaced in supersession of existing dilapidated copy of same No.			
08-11-10	DC. 37271-A	INDIGENOUS MATL ADDED AS NOTE NO 11			APPROVED.
17-4-89	DC. 34584-A	INNOTE NO. 6, 55000 r/min WAS 35000 r/min			FOR CQA(A)
24-9-87	34241-A	DRG. PROV. SEALED.			
DATE	AUTHORITY	REVISION	SIG AHSP	SIG DO.	AHSP:- CQA(A) KIRKEE