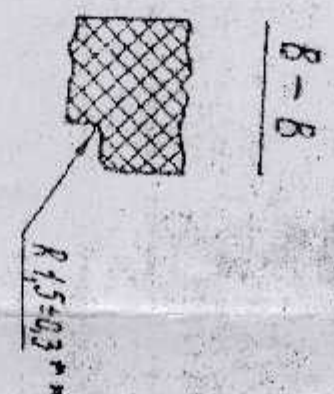


- 1 * Dimensions are given for reference.
- 2 ** Dimensions are provided with tools
- 3 Projection of surface I of stud beyond surface E is not allowed.
- 4 Other technical requirements are as per OSI410.005.051



$\frac{M1}{D-131}$

ECKD

656 670 003 06

ENOSHITDOCCNO	SIGN	DATE	BASE
EDITCHKO			ASSEMBLY DRAWING
P/M DC			CIFE, PUNE
DIVOPFR			
NAME	SIGN	DATE	

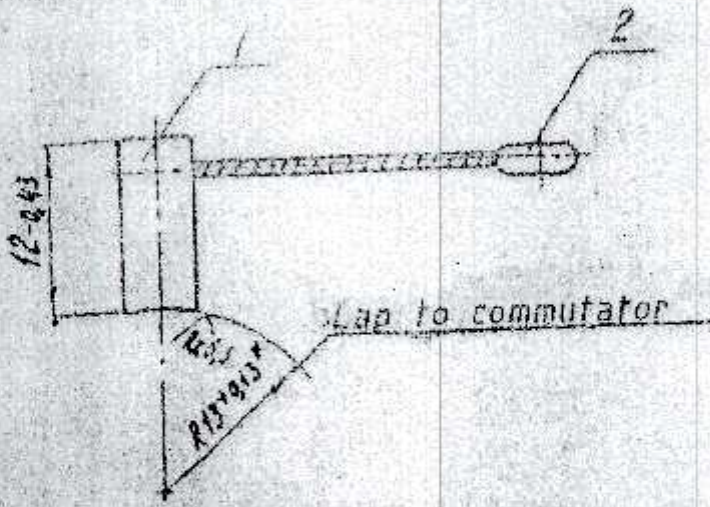
SHEETWEIGHT SCALE

16.5g 2:1

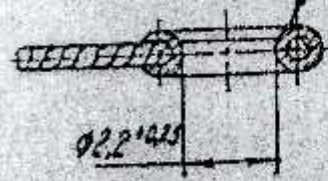
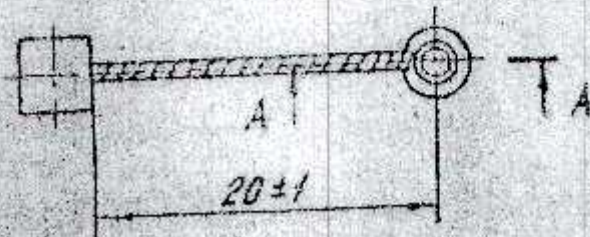
ROYAL SHEETS

66.677.219

42
0.31



A - A
M5:1
SQUARED
Lightly



1. * Dimension is provided with tools

2. Not more than 5 small ruptures of hollow rivet are allowed while expanding.

ECKD

Sl. No.	Designation	Description	Parts	Remarks
2	858.955.115	Hollow rivet	1	
1	68.662.203	Brush	1	

66.677.219

STRENGTH	DOC NO	SIGN	DATE
DRAWN	M. Y. SINGH		17.6.85
EDT/CHKD			
ENGR. IN CH.	S. B. NAR		
OFFR	A. K. RUDHU	AK	20.6.85
NAME		SIGN	DATE

BRUSH

CIFE, PUNE

SHEET	WEIGHT	SCALE
1	332	2:1
TOTAL SHEETS		

Sl. No.	Qty	Designation	Description	Remarks
			Documentation	
13		856.765.793 CE	Assembly drawing	
			Assembly units	
11	1	856.237.114	Labyrinth	1
12	2	856.617.103	Commutator	1
12	3	856.756.133	Armature without winding	1
			Parts	
11	4	857.883.041	Basket	2
11	5	858.667.211	Binding clamp	6
11	6	858.978.151	Wedge	11
11	7	858.918.151-01	Wedge	11

43
0-131

S/N	SHEET	DOC NO	SIGN	DATE
DRAWN BY		N. Yasudas		12.5.85
EDITED AND CHECKED BY		A. K. Jha		
FOREMAN OF DC		S. R. Nair		
DIVISIONAL OFFICER		A. K. Jha	AK	15.4.85

56.765.793

ARMATURE

SHEETS	WEIGHT	SCALE
5	1	2
TOTAL SHEETS		

CIFE PUNE

Former Zone	Ref. No.	Designation	Description	Qty	Remarks
			Materials		
	8		Wire n3BT9-1 0.56 TY 16-505.446 77	100	
	9		Wire M-0.5 GOST 9175-59	2m	
	10		Calico band, grade 1, GOST 4514-78 0.22 x16 x1000	2	
	11		0.22 x16 x1150	1	
	12		Cotton thread 00 GOST 6309-80	2m	

44
D-131

505.785-13

1-2-1

Имя, № поля, Подпись к дате, Взам. инв. №, Кол-во в бр., Проект, Дата

Имя, Ин, № докум, Испол, Дата

FORMA T.	ZONE	REF. NO.	Designation.	Description.	Qty	Remarks
				Documentation.		
	12		858.766.133 C5	Assembly drawing.		
				Parts.		
	11	1	857.775.452	Armature lamination.	117	
	11	2	857.844.289	Insulating armature lamination.	1	
	11	3	857.844.290	Insulating armature lamination.	1	
	11	4	868.310.845	Shaft.	1	

16
0-131

SIND SHEET	DOCNO	SIGN	DATE
DRAWN BY	P.R.BABU		16.6.05
EDITED AND CHECKED BY	S.K. JAIN		16/05
BY			

ARMATURE WITH- 858.766.133
OUT WINDING.

SHEETS	WEIGHT	SCALE
1		1:1

858.766.133

Copper M.

Welding & Joints

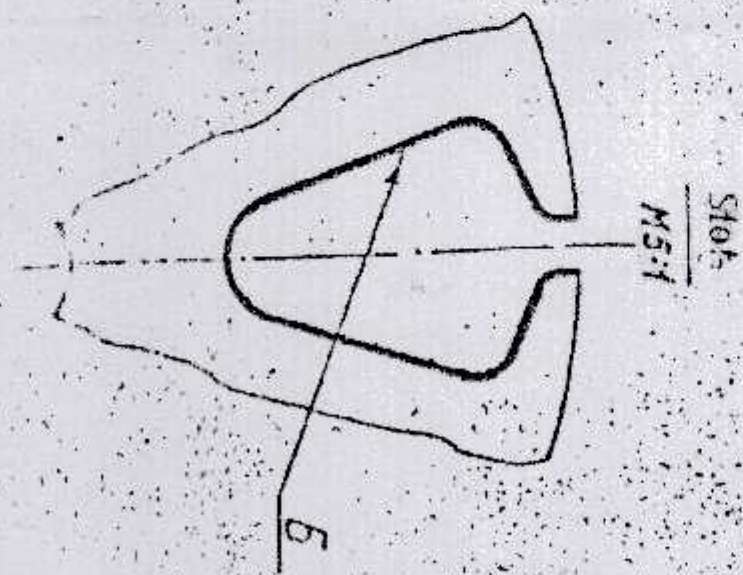
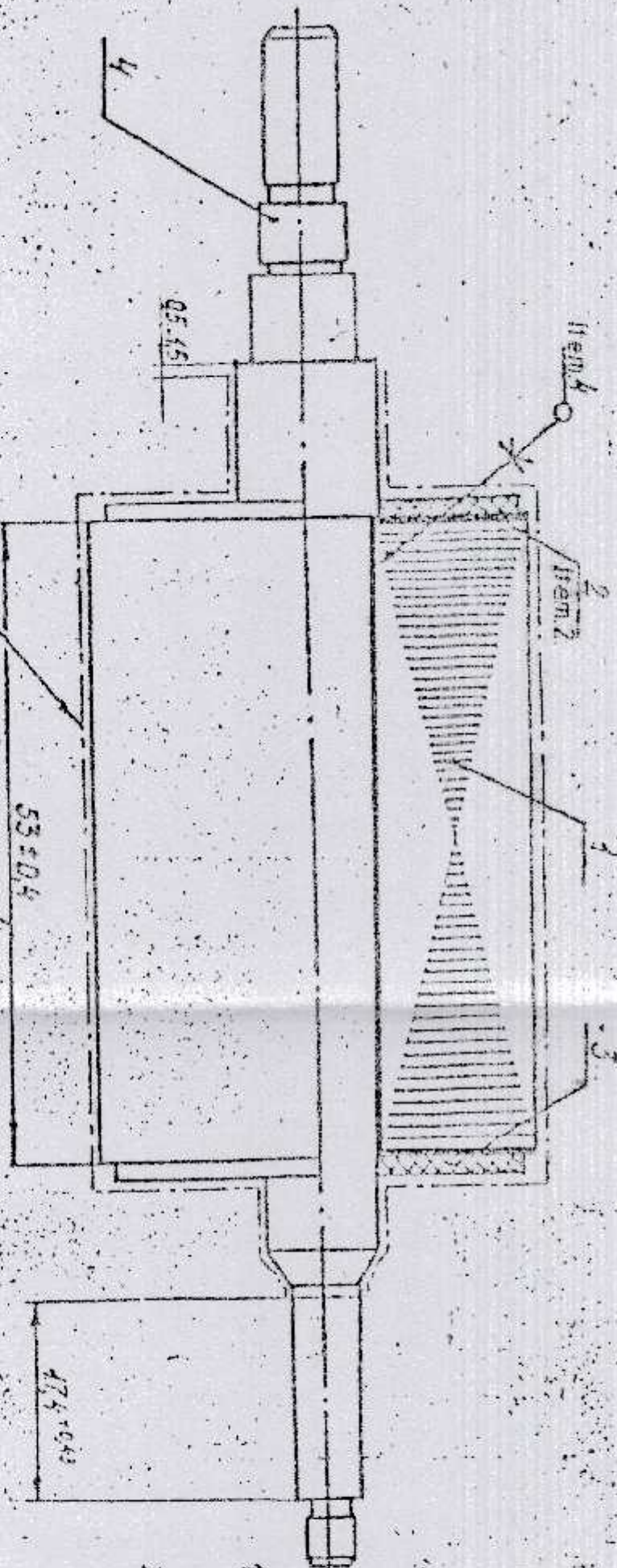
Mater. M. Syst.

Draw. and M.

Dossack & Co

1-4-1

855.766.133



1. Maintain dimension A by means of middle armature laminations, Ref.No 1, minimum number of laminations is -93.
2. Stick armature lamination Ref.No 2, with two extreme armature laminations Ref.No 1, using adhesive Bφ-4, grade 1
3. Press the armature stack up to the stop.
4. Use adhesive Bφ-4, grade 1 EOST 12172-74.
5. Coating of surface B: epoxy powder compound 3T-49 A/11796-05-1420-75. Thickness of coating is 0,20 to 0,25mm.

Lot 20-48 4/2

ECKL

855.766.133 CS

ARMATURE WITHOUT WINDING

Assembly drawing

DESIGN NO	SIGN	DATE
100000		12/75
EDICHO		1975
DIVISION	GR	DATE
NAME	SIGN	DATE

SHEET NUMBER	SCALE
4/38	2:1
TOTAL SHEETS	

FORMS	ZONE	REF NO	Designation	Description	Qty	Remarks
22			856.757.135 CB	Documentation		
				Assembly drawing		
				Assembly units		
	1		856.643.123	Coils.	1	
				Parts		
	2		857.750.480	Right end-piece	2	
	3		857.773.330	Pole.	2	
	4		858.034.680	Frame.	1	
	5		858.950.050	Lock pin	2	
				Standard articles.		
				Screw B1.M4-6gx10.36.016.		
				GOST 17475-80.	4	
			48 D-131			

№ п/п. Подпись к дата
 Справ. №
 № п/п. Подпись к дата
 № п/п. Подпись к дата
 № п/п. Подпись к дата
 № п/п. Подпись к дата

SUNO	SHEET	DOCNO	SIGN	DATE
DRAWN BY	P.R.BABL			16.4.85
EDITED AND CHECKED BY	P. IS. JAIN			14.4.85
FOREMAN OF DC	S.R.A.R			
DIVISIONAL OFFICER				
NAME	SIGN	DATE		

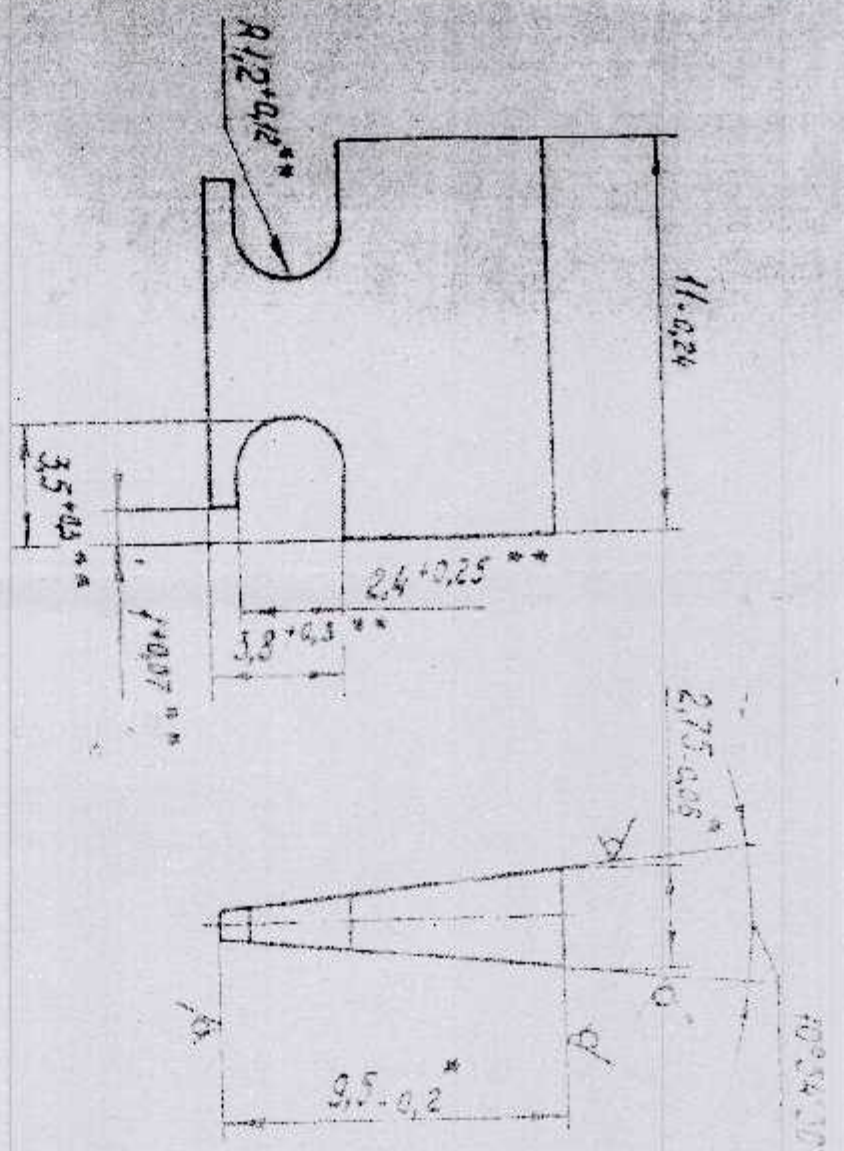
STATOR

CIFE BUNE

856.757.135

SHEETS	WEIGHT	SCALE
6		
TOTAL SHEETS		

857.927.298



RELO/M

1. *Dimensions are given for reference.
2. **Dimensions are provided with tools.
3. Laps of edges upto 0.5mm are allowed.

СНЕТТ ДОСНО	СИГН	ДАТА
ДРАУВН	ПРРАВУ	02.86
ДИСЧНО	СРНАВ	
ДИВЕРС		

COMPUTATOR
SEGMENT

857.726.259

СHEETWEIGHT SCALE	6	443	5:1
TOTAL SHEETS			

FACTORY NOTES TO TECHNICAL CONDITIONS

FOR SEGMENT SHOULD BE MANUFACTURED FROM COLD DEFORMED
 TRAPEZOIDAL CROSS-SECTION (TP) WITH
 SURFACE OF PRODUCTION (HD) HARD (T) WITH DIMENSIONS 2.75X0.5MM
 OF TRANSVERSAL CROSS-SECTION 10° 5A' 30", PRESENT ARE LISTED
 OF THE KAI CONFORMS TO GOST A134-75 HAVING CHEMICAL
 ANALYSIS FOLLOWING:

SEGMENT IMPREGATION (GOST A134-75)	
MINIMUM COMPOSITION %	
ADMITTANCE (MAX.)	0.35
BALANCE	

MINIMUM HARDNESS: 95 HB (MIN)

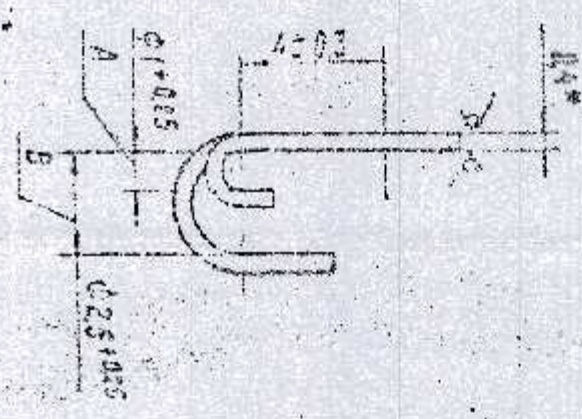
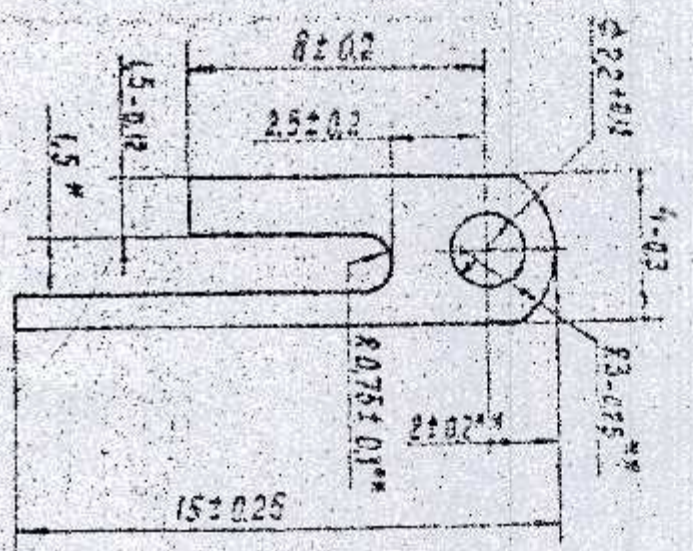
THE FINISH IS
 THE DIFFERENTS SURFACE FINISH R_a VALUE 40 MICRONS IN THOSE
 SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED BY ANY
 PRODUCTION METHOD.
 THE SPOTS SURFACE FINISH TO BE OBTAINED WITHOUT
 REMOVAL OF MATERIAL.

DRG. NOT TO BE SCALD.
 ALL DIMENSIONS ARE IN MM.
 UNLESS OTHERWISE SPECIFIED.

Profile A1PH1 2.75x9.5x
 GOST 9004-75 (HARDENED)

084096179

0.50
✓ (V)



- 1 *Dimension is given for reference.
- 2 **Dimension is provided with leads.
- 3 Coating: Copper-plated, 3 microns thick, tin-dismuth-alloy (99.7)-plated, 6 microns thick.
4. Non-Parallelism of surfaces as per dimensions A and B should not exceed 15° (towards increase).

SNIGHT DOC NO	SIGN	DATE
ORA WIN	PRABHU	12.1.85
EDICHIK
M.D.C.
DIYADFR

RIGHT END PIECE

857750480

SHEET WEIGHT	5	0.22
TOTALS		

Band ALPHA 0.40 MM AG301
GOST 2208-75

EXPLANATION

TECHNICAL CONDITIONS

MANUFACTURED FROM ROLLED ...
INDUSTRIAL ...
GOST 2208-75 ...
GOST 2208-75 ...

CHEMICAL COMPOSITION %					
ADMITTIVE % (MAX)					
GROUP	IRON	MANGANESE	ESSENTH	PHOSPHORUS	TOTAL
0.1	0.2	0.005	0.002	0.01	0.5

SURFACE FINISH

PREPARED SURFACE FINISH TO BE OBTAINED WITHOUT REMOVAL OF MATERIAL ON BOTH SIDES OF JOB.
REPRESENTS GENERAL FINISH TO BE OBTAINED BY ANY PRODUCTION METHOD IN AS YARN AND MACHINING THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.

INCH/READ

DO NOT TO BE SCALED PERFORM TO

CHECKED

ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF ALL DIMENSION LINE IN MM UNLESS OTHERWISE SPECIFIED

RIGHT END PIECE

857750480