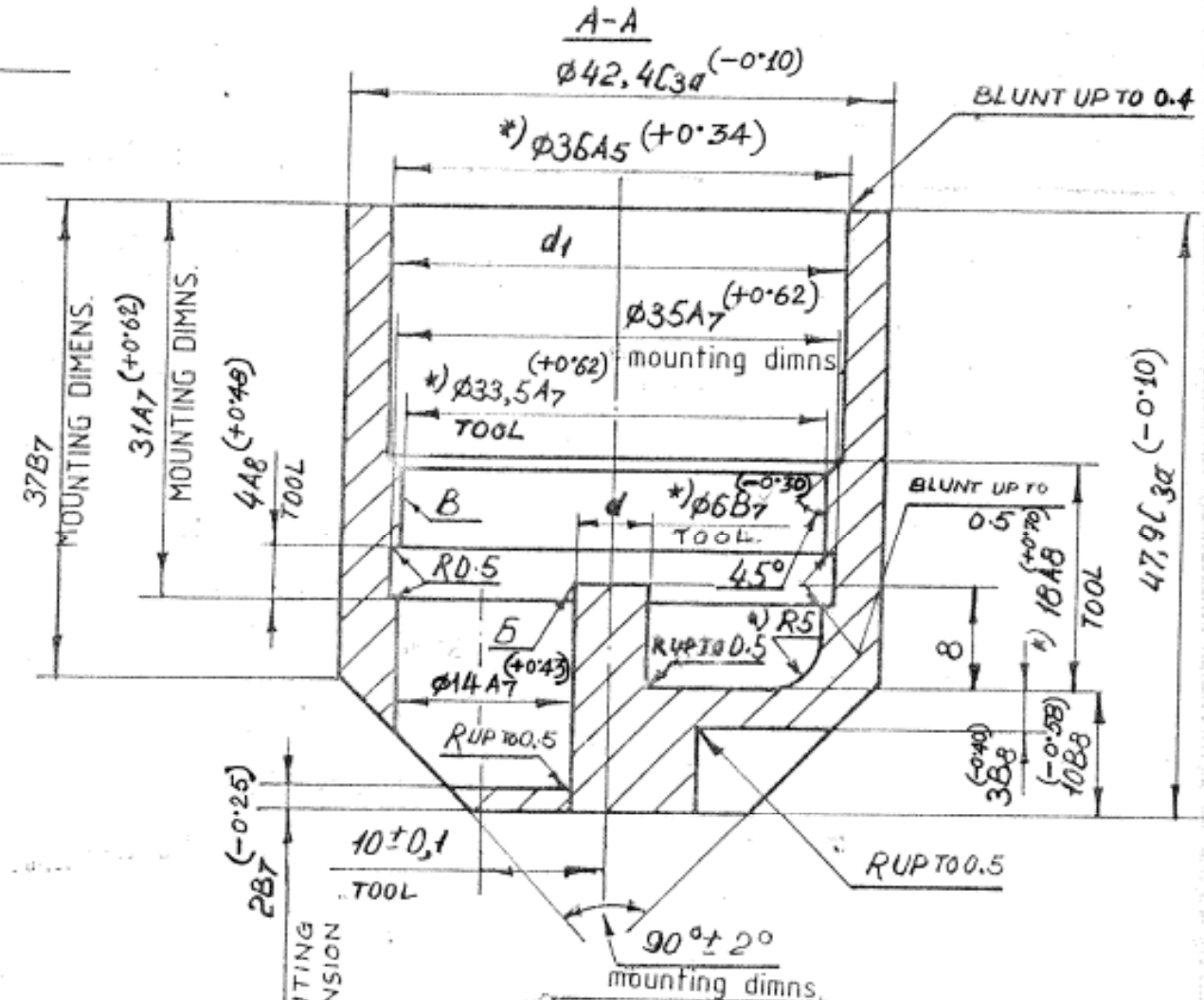
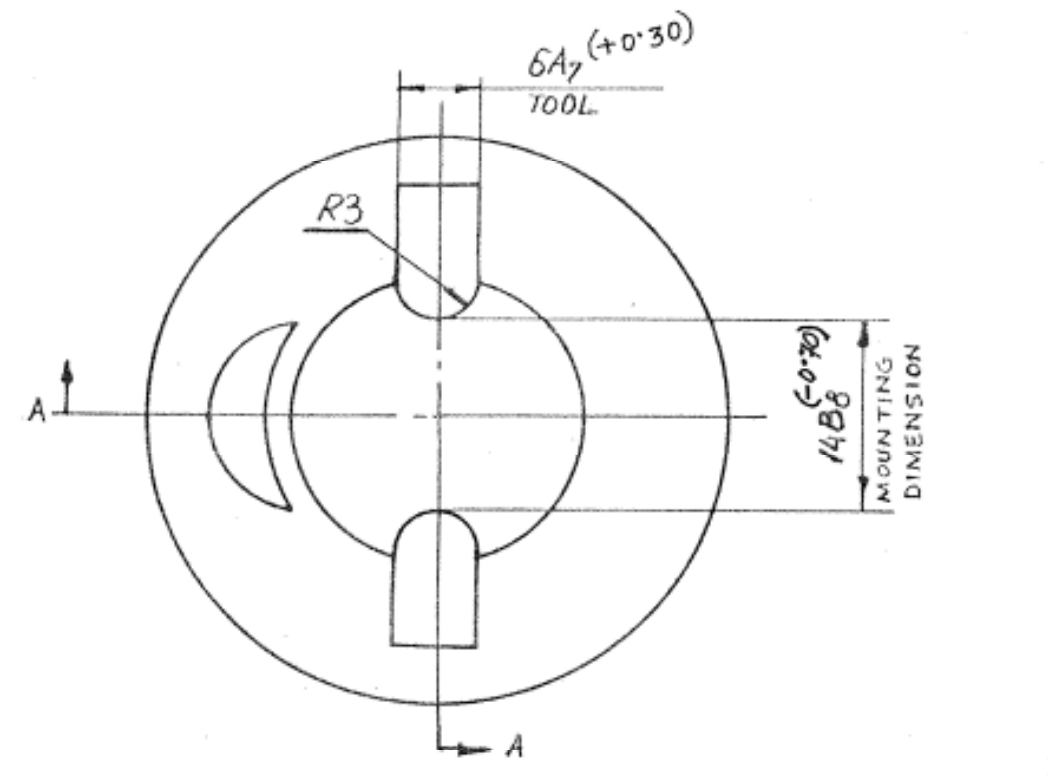
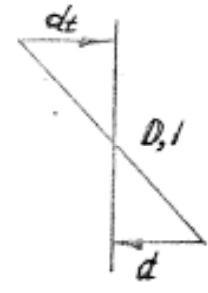


DATE	28-9-97	AUTHORITY	DC. 36325-A
REVISION	UNDER INDIGENOUS EQUIVALENT MATERIAL COMPONENT - GRAIN GROWTH ADDED		



ECCENTRICITY



1. The dimensions, marked by asterisk, should be obtained by spinning method.
2. Technical dimensions 42.4C 3a and 47.9C3a.
3. While boring the hole of $\phi 14A7$ cuts on the surfaces of the B and B are permitted.
4. The use of the following material is permitted:

Rod A 16T.KP, GOST 21488-76.

INDIGENOUS EQUIVALENT MATERIAL
 ALUMINIUM ALLOY TO SPEC. IS 733 DESIGNATION 24345 IN 'W' CONDITION OR BS 1474 GRADE 2014 A IN T4 CONDITION. (LATEST ISSUE)
 COMPONENT SHOULD BE FREE FROM PERIPHERAL GRAIN GROWTH.
 ***) Rod A 1TKP, GOST 21488-76.

R.Nº	DATE	AUTHORITY	REVISION	ZONE	AHSP	D.O.
	19-9-94	DC. 35811-A	INDIGENOUS EQUIVALENT MATERIAL ADDED			
	28-10-85	DCI. 33853-A	DRG. SEALED PROJ.			

	3-024045	3 B 15
APPD. <i>Saxena</i>	BODY BLANK	2 - 1
FOR CI(A)		Scale 2:1
AHSP. CI(A) KIRKEE	***)	for matl see

OTF/DD/009

*) Two last figures of the current year.

2. Size of marking symbols should be of 2.5 - 3. Depth of the marking should not exceed 0.5 mm. The year of manufacture should be marked as *).
3. The traces on surface B left by the thread cutting tool are permitted.
4. Sags of plastic on the surfaces B and B₁ are permitted.
5. Check the dielectric strength of insulation of Cδ2-1 with dummy Cδ2-9 non-contacting with the body of Cδ2-1.

Carry out the checking with DC instrument of type УПГ-1Н for 3 sec., by the voltage of 3500 v. Leakage of current should not be more than 0.02 milliamperes symbol "√" of the power source should be connected to the body.

6. Check the unit for air tightness at the pressure of 1-2 atm. or vacuume of 0.8 atm for 1 minute.
7. Check mounting dimensions 25 B7 and 4A8 before cutting of thread.
8. It is allowed to increase the dimensions of slots B3A7 (tool) in the blank of item 1 upto 6.55 on half length along the base of the slot from outer contour of the part.
9. It is allowed to manufacture the thread CNM41.96 X1.5 class 3 (left) by thread milling cutter with in-process run-out beveling of the entering threads at constant number of working threads - not less than 13 (as per medium diameter of a thread).

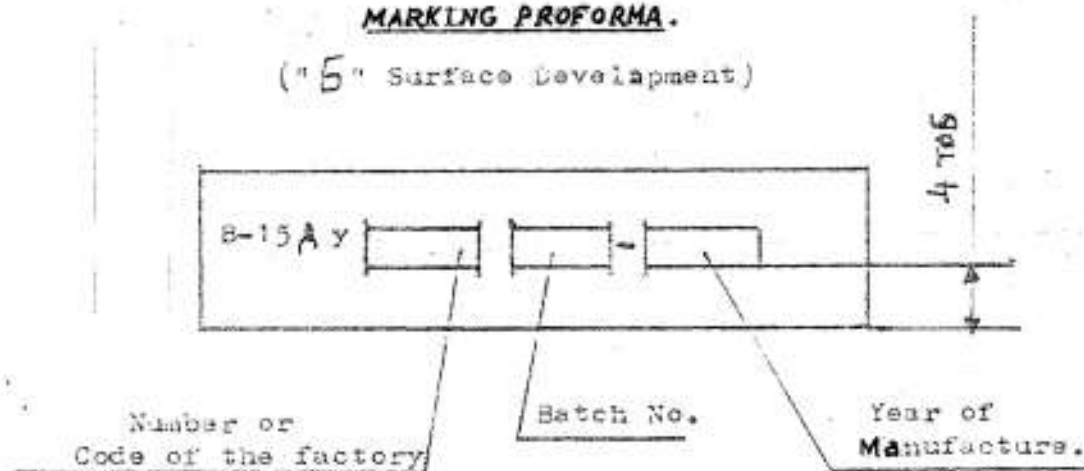
10. The following is acceptable as per the standards selected by the agreement with the customer's representative :

- a) Chipping out of the first turn of the thread M33 x 1 class 3;
- b) Local separation of plastic from metal at the dia. of 39.7B7.

INDIGENOUS EQUIVALENT MATERIAL - MOULDING MATERIAL TO SPEC. IND/ME/951 (PROY) GRADE A. (LATEST ISSUE)

MARKING PROFORMA.

("B" Surface Development)

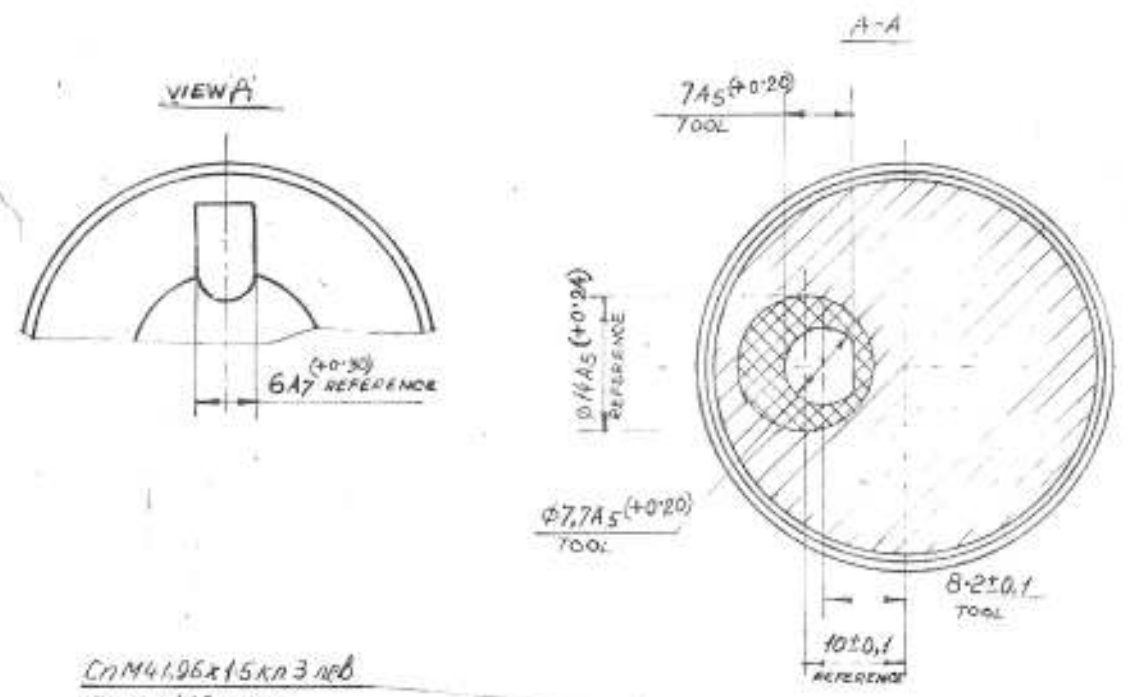


Sl. No.	Code/Designation	Nomenclature	Qty.	Remarks
1.	2-1	Body blank	1	OTF/DD/009
2.		MOULDING MATERIAL -4B GOST 20437-75		

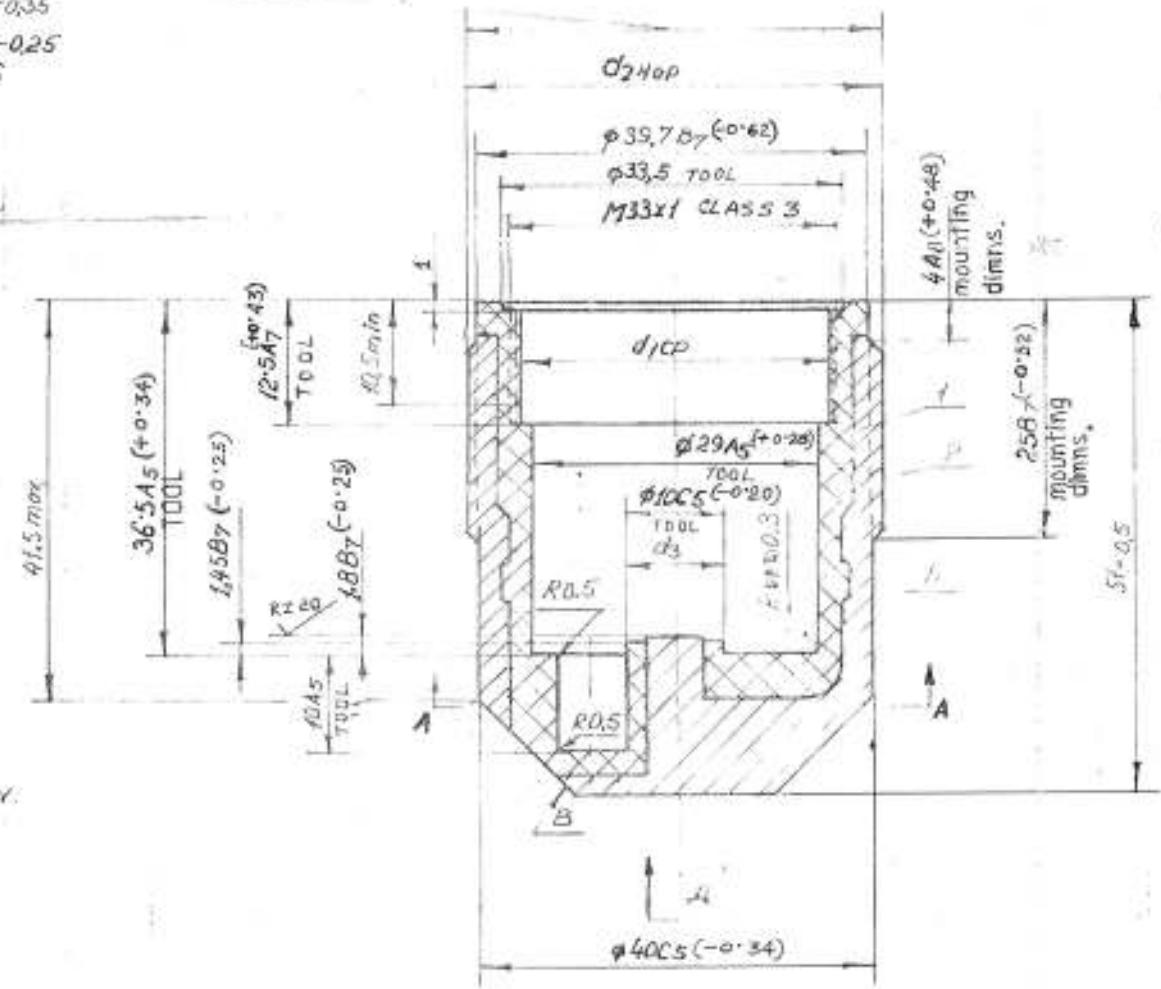
R. NO.	DATE	AUTHORITY	REVISION	ZONE	AHSP. SIGN.	D.O.
	19-9-94	D.C. 33811-A	INDIGENOUS EQUIVALENT MATERIAL ADDED.			
	28-10-85	DCI. 33853-A	DRG. SEALED PROJ.			

APPD. <i>Lakshmi</i> FOR CI(A)	3-024045	3 B 15
AHSP. <i>KIRKEE</i> CI(A) KIRKEE	<u>BODY WITH INSULATION.</u>	2 SHTS Cδ2-1 SHT-2
		OTF/DD/023 (Sht-2)

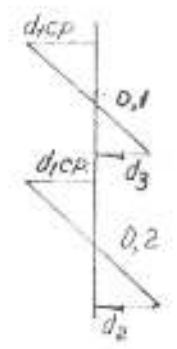
1-293 3-024045



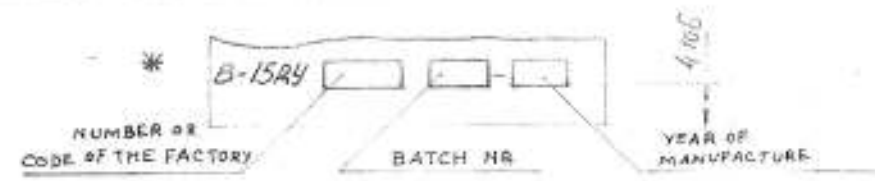
CM 41.96x15x0.3 RD
 d_{HOP} = 41.96 - 0.35
 d_{CP} = 40.986 - 0.25
 d_{BM} = 40.336



ECCENTRICITY:



FOR MARKING PROFORMA—
 SEE SHEET NO ----Contd sheet 17.



* NOTE:- FOR MARKING ON INDIGENOUS PRODUCTION
 REFER DRNG CQA (A)/AMV/2819.

13-7-91	UC 15054	* 2000-08-28 DRAWINGS ON DRG. & JOE REPAIRING W ADDED							
28-10-85	UC 15054	DRG. SEALED PROV							
13-7-91	UC 15054	DRG. SEALED PROV							
28-10-85	UC 15054	DRG. SEALED PROV							
13-7-91	UC 15054	DRG. SEALED PROV							
28-10-85	UC 15054	DRG. SEALED PROV							
13-7-91	UC 15054	DRG. SEALED PROV							
28-10-85	UC 15054	DRG. SEALED PROV							
13-7-91	UC 15054	DRG. SEALED PROV							
28-10-85	UC 15054	DRG. SEALED PROV							

3-024045	3B15
BODY	2 SHTS
WITH INSULATION	SHT-I
	SCALE
	2:1

OTF/DD/023
 SHT. 1/2