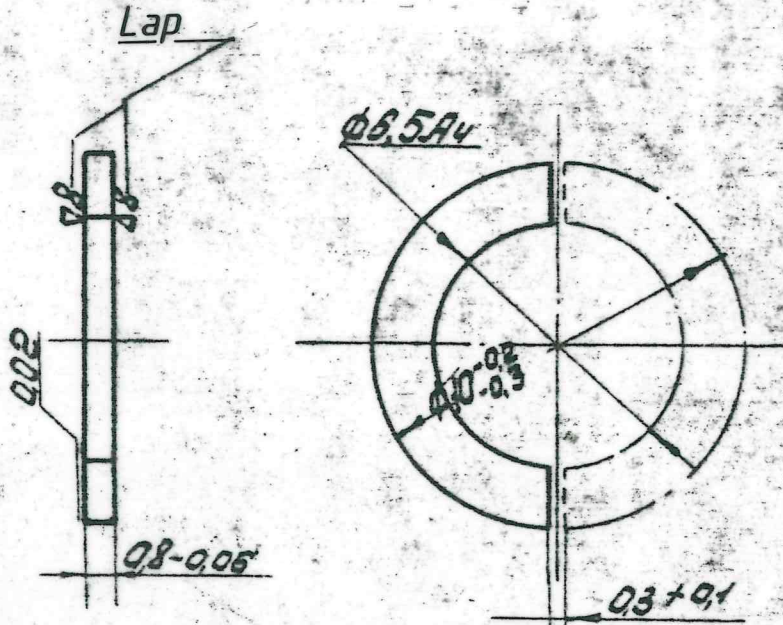


252-27

Unless otherwise specified



1) Flare upto 0,85 mm.

252-27

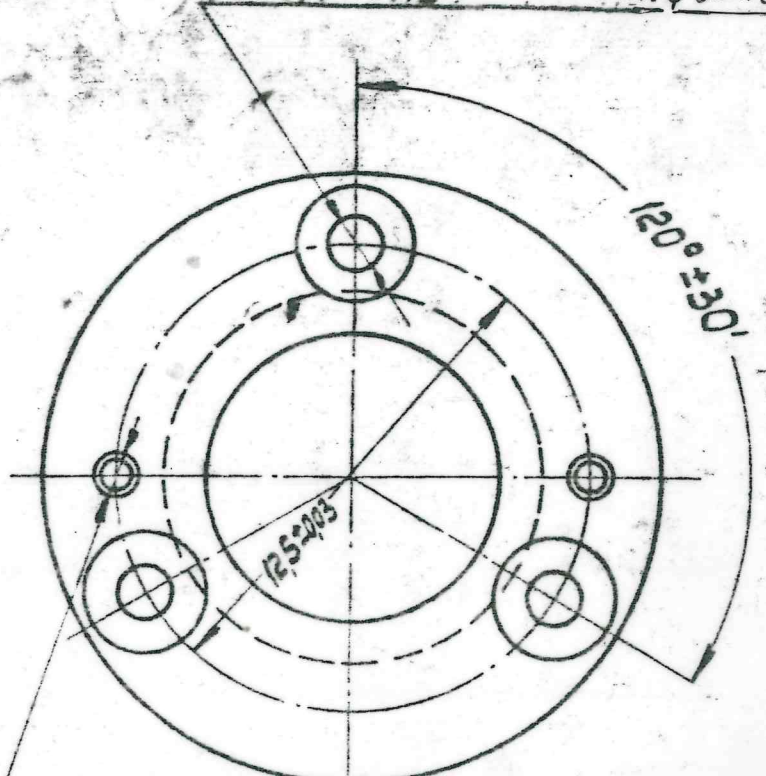
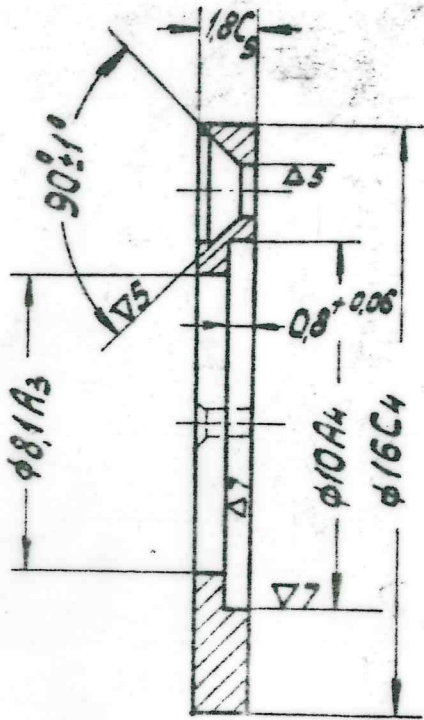
SNO	SHT	DOC NO	SIGN	DATE
DRAWN		Y.R.Ganesh		16.5.84
EDT	CHKD			
F/M, DC.		SHRAG	Sh	2/6
DIV.OFFR		D.A. RAM	Amr	2/6
		NAME	SIGN	DATE

DOWEL

Band Бр АМЛ49-2-Т-1.0  
GOST 1595-71.

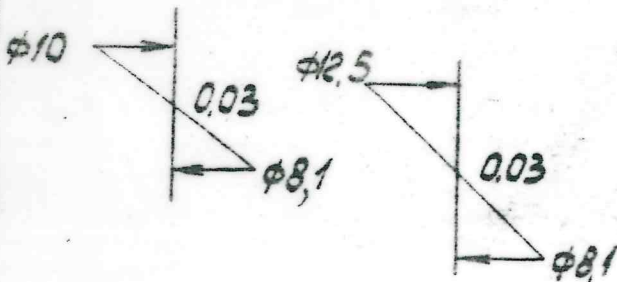
SHEET	WEIGHT	SCALE.
	0.4	5:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

▽6 Unless otherwise specified  
3 holes  $\phi 1.6A5$  counter sink  $\phi 3.2A5$



2 holes  $\phi 0.75 \pm 0.03$  counter-sink  $\phi 1 \times 90^\circ$

Eccentricity



1) Breakage due to counter sinking is allowed.

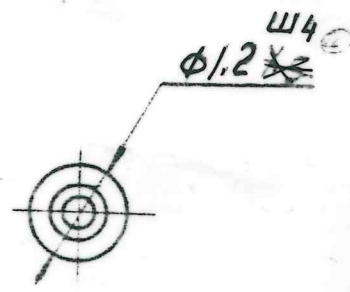
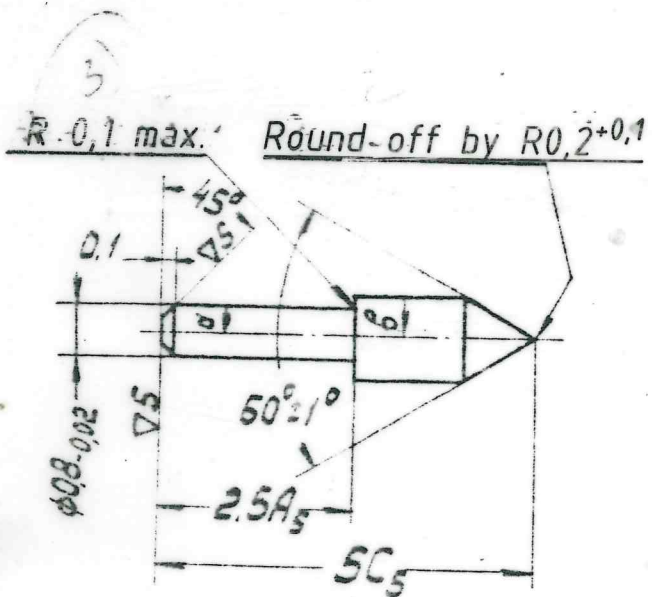
S/NO	SHEET	DOCNO	SIGN	DATE
DRAWN BY	Y.R.Ganesh			14.5.84
EDITED AND CHECKED BY	B.B. Sarikur			17.5.84
FOREMAN OF DC	S.H.RAO			2/6
DIVISIONAL OFFICER	D.A.			2/6
	NAME	SIGN	DATE	

**SPECIAL WASHER**  
Round bar: 18-4 OCT 7417-75  
40x13 Ty 14-1-378-72

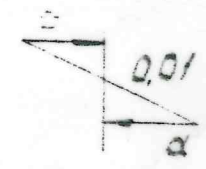
252-28		
SHEETS	WEIGHT	SCALE
9	1.4 gm	5:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

252-30

▽ Unless otherwise specified



Eccentricity



- 1) Check radius of sphere as per standard.
- 2) Harden 45 to 48 RC.

SLNO	SHEET	DOCNO	SIGN	DATE	<b>LOCK PIN I</b>	<b>252-30</b>		
DRAWN BY	Y.R.Ganesh			14,5,84		SHEETS	WEIGHT	SCALE
EDITED AND CHECKED BY	B. Sankar			12.5.84		A	0,0252	10:1
FOREMAN OF DC	SHRAO			246		TOTAL SHEETS		
DIVISIONAL OFFICER	D.A. Rao			24		ORDNANCE FACTORY PROJECT HYDERABAD		
	NAME	SIGN	DATE		Carbon tool steel	25-3GOST14955-69	25x13H2 Ty-721-73	

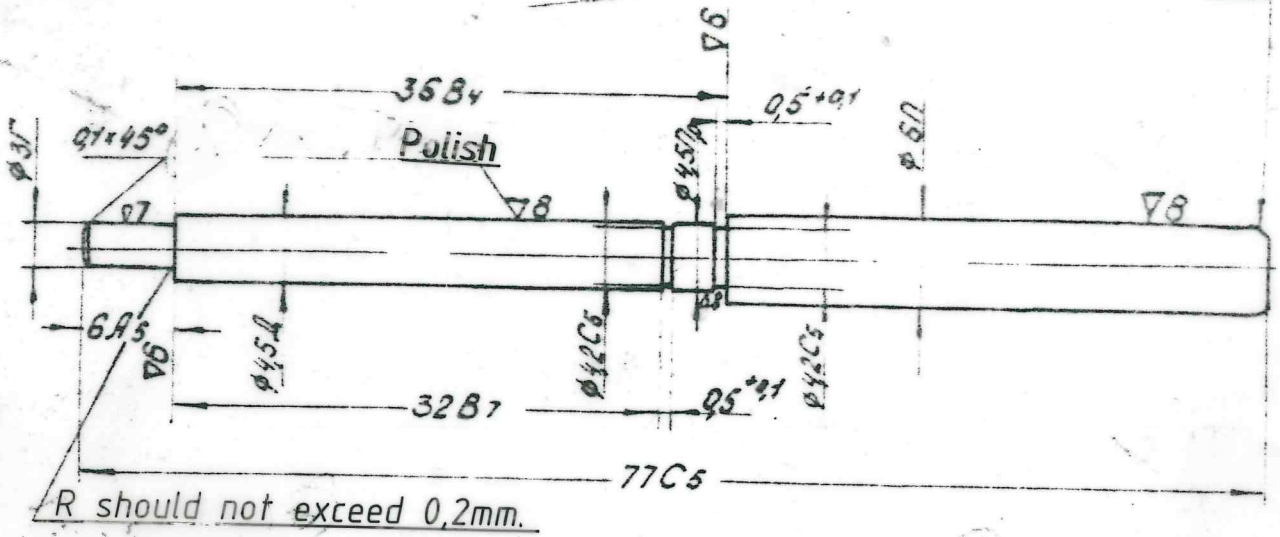
D/30-185

252-31

186

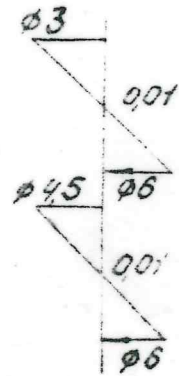
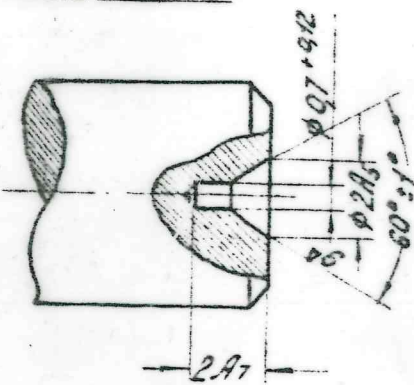
∇5 Unless otherwise specified

R2



scale = 5:1

Eccentricity



- Centre hole is allowed only at the end of φ6n coating : chemically passivation.

252-31

D 150-186

SNOSHT	DOC NO	SIGN	DATE
DRAWN	Y.R.Ganesh		1.5.84
EDT,CHKD	D.K.JAIN		17.5.84
F/M,DC.	SHRAO		2/6
DIV.OFFR	D.A. Ganesh		2/6
	NAME	SIGN	DATE

SHAFT

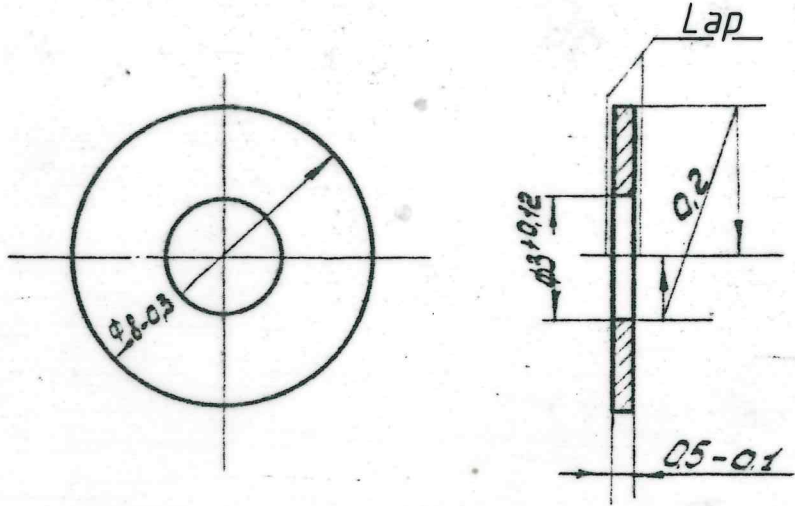
BAR 3 KPI 7.0 5P AM 4 9-2  
10CT 1628-78

SHEET	WEIGHT	SCALE
13		2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		



252-34

2 188

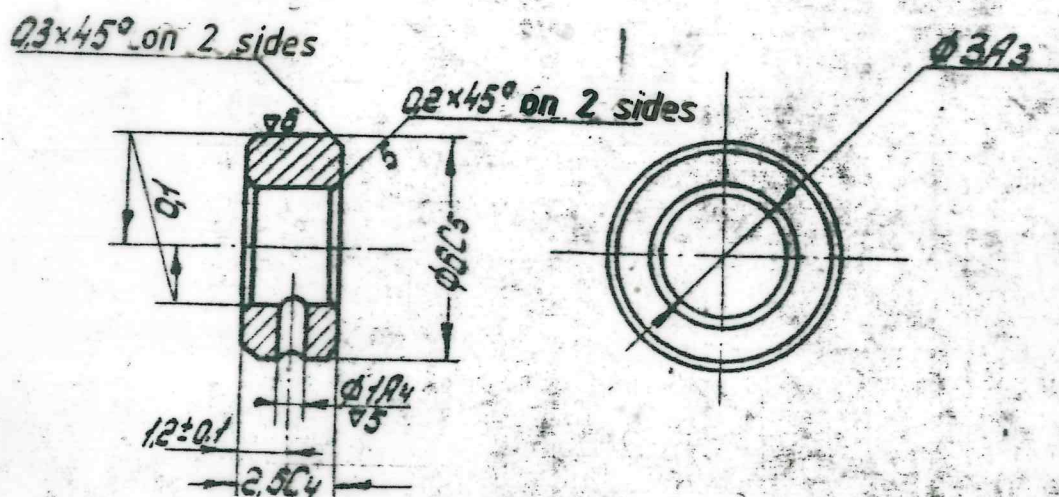


252-34

				SHEET	WEIGHT	SCALE
SNO	SHT	DOC NO	SIGN	DATE	018	5:1
DRAWN		Y.R.Ganesh		18.5.84		
EDT	CHKD	D.K. JAIN	<i>[Signature]</i>	19.5.84	TOTAL SHEETS	
F/M, DC.		S.H. RAO	<i>[Signature]</i>	2/6	ORDNANCE FACTORY	
DIV. OFFR		D.A. [Signature]	<i>[Signature]</i>	2/6	PROJECT	
		NAME	SIGN	DATE	HYDERABAD	
				SPECIAL WASHER		
				Band Бр KML43-1-T-0,5H		
				ГОСТ 4748-70.		

252-36

Unless otherwise specified



Coating / Chemical passivation

2130-189

252-36

NO	SHT	DOC NO	SIGN	DATE
DRAWN		Y.R. Ganesh		18.5.84
EDT, CHKD		D.K. JAIN		19.5.84
F/M, DC		S.H. RAO		26
DIV. OFFR		V.H. IYER		26
		NAME	SIGN	DATE

THRUST BUSHING

Вар. д. крп 7,0 Бр. АМЦ  
9-2 ГОСТ 1628-78.

SHEET WEIGHT SCALE

036 5:1

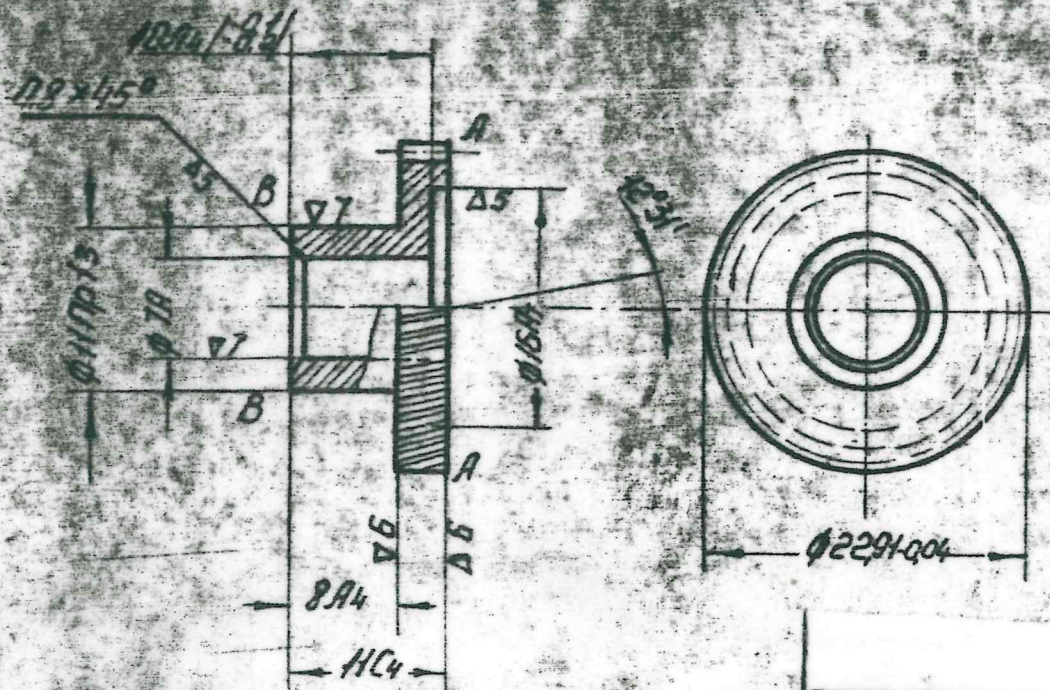
TOTAL SHEETS

ORDNANCE FACTORY  
PROJECT  
HYDERABAD

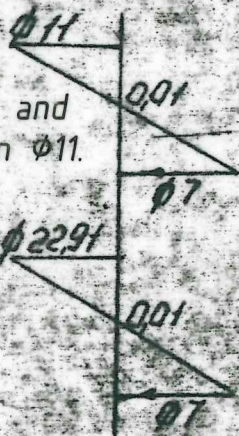
252-54

190

▽7 Unless otherwise specified



Eccentricity



- 1) Non parallelity of planes A-A and B-B should not exceed 0,05 on φ11.
- 2) Part is meshed with part 26.
- 3) Coating : Chemical passivation.

Module	m	0,7
Number of teeth	Z	30
Spiral angle	β	12°31'
Addendum modification coefficient	ε	0
Direction of teeth		
Degree of accuracy as per GOST 9178-59		7-7-84
Dimensions over pins when φ of pin is 1,441	M	23,962±0,05
Parameters to be checked as per H0,841,000		
Pitch circle diameter	d	21,51
Angle of profile	α	20°

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		Y.R.Ganesh	[Signature]	18.5.84
EDT,CHKD		D.K.JAIN	[Signature]	19.5.84
F/M,DC.		S.H.RAO	[Signature]	21.6
DIV.OFFR		D.A. [Signature]	[Signature]	21.6

GEAR Z=30

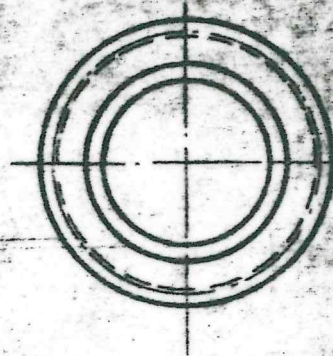
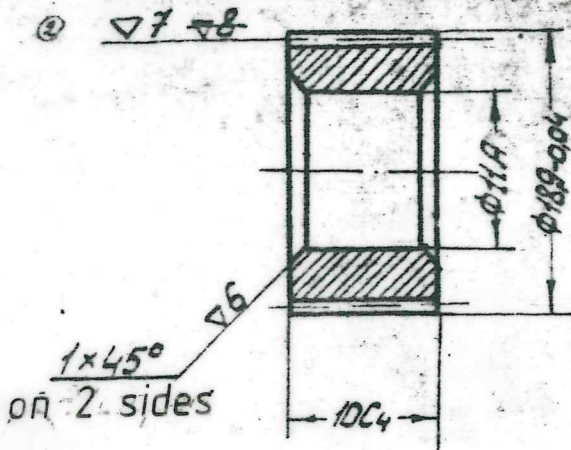
Вар.д.Крп 25,0 Бр АМ4

SHEET	WEIGHT	SCALE
10	9	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT		
HYDERABAD		

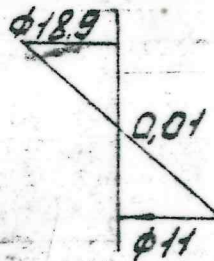


252-55

▽ 7 Unless otherwise specified



Eccentricity



Coating chemical passivation.  
To be meshed with part 43.

Module	m	0.7
Number of teeth	Z	25
Addendum modification coefficient		
Degree of accuracy as per GOST 9178-59		7-7-8A
Distance over pins when $\phi$ of pin is 1,441	M	19.89-0.045
Parameters to be checked as per		Ho, 841,000
Pitch circle dia.	d <sub>a</sub>	17.5
Angle of profile	$\alpha$	20°

252-55

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		Y.R.Ganesh		18.5.84
EDT,CHKD				
F/M,DC.		SHRAO		2/6
DIV.OFFR		D.A.		2/6
		NAME	SIGN	DATE

GEAR Z = 25

Род д,кпр 20,0 Бр АМ4  
9.2 ГОСТ 1628-78.

SHEET	WEIGHT	SCALE.
10.1	2.1	
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		