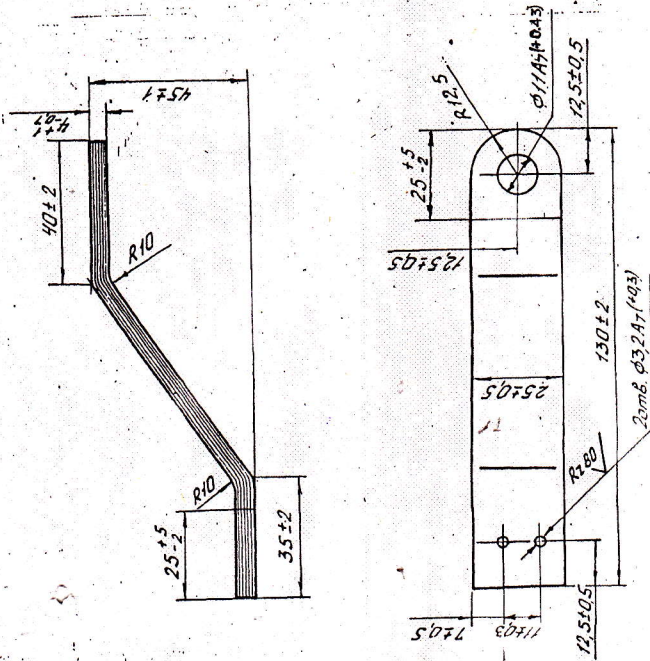


DRAWING NUMBER

172 70 528



1. JUMPER SHOULD BE MADE FROM 18...20 STRIP OF BAND HM 0.2 M3 GOST 1173-77.
2. ROUNDING OFF WITH R12.5 MAY BE REPLACED BY CHAMFERING 5x45° ON TWO SIDES.
3. DIMENSION 4.5 IN THE BENDING PLACE SHOULD NOT BE CHECKED.
4. COATING OF STRIP ENDS ALONG DIMENSIONS 25 ± 0.5 HOT TINNING WITH POC-40 GOST 21930-76 OR GOST 21934-76. IN THIS CASE THICKNESS OF SET OF STRIPS AFTER COATING SHOULD NOT FALL OUTSIDE THE LIMITS OF DIMENSIONS.
5. ABSENCE OF COATING IN HOLES IS ALLOWED.
6. REST OF REQUIREMENTS AS PER SZO TT 1.

EXPLANATORY NOTE:-

THE COMPONENT SHOULD BE MANUFACTURED FROM COLD-ROLLED COPPER STRIP OF THICKNESS 0.2-0.3 mm WITH NORMAL ACCURACY-H, SOFT CONDITION-HY OF GRADE M3 TO GOST 1173-77. CHEMICAL COMPOSITIONS % AS PER GOST 859-78 AND MECHANICAL PROPERTIES AS PER GOST 1173-77 ARE AS UNDER.

CHEMICAL COMPOSITIONS %

MANUFACTURING METHOD	Cu+Ag GRADE NOT LESS THAN	IMPURITIES (NOT MORE THAN)									
		Bi	Sb	As	Fe	Ni	Pb	Sn	S	O	
FIRE REFINED	M3	99.5	0.003	0.05	0.01	0.05	0.20	0.05	0.05	0.01	0.08

MECHANICAL PROPERTIES :-

MATERIAL CONDITION	TENSILE STRENGTH, σ_u		ELONGATION % δ
	Kgf/mm ²	Mpa	
SOFT	20	196	30

VETTED

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ERN	QED	TDU	APPD	DATE	SCALE	EXPLANATIONS IN RUS	TOLERANCE ON DIMS UNLESS OTHERWISE STATED IS 20:02-69	ALL THREADS TO CONFORM TO	ISSUE	DATE	NATURE OF AMENDMENTS

EST. WT. 0.115 kg.
 ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R SIZE R. INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

PLOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

TO BE STAMPED OR MARKED WHERE INDICATED THIS # LETTERS)

JUMPER

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