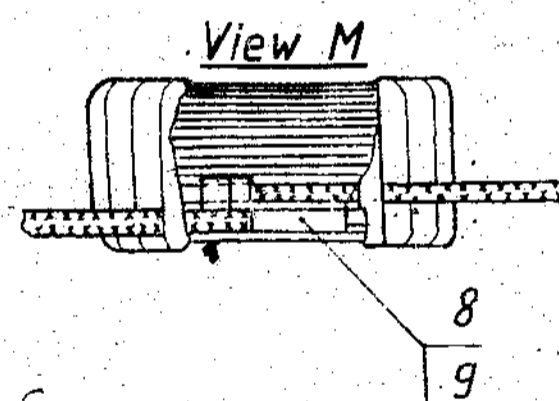
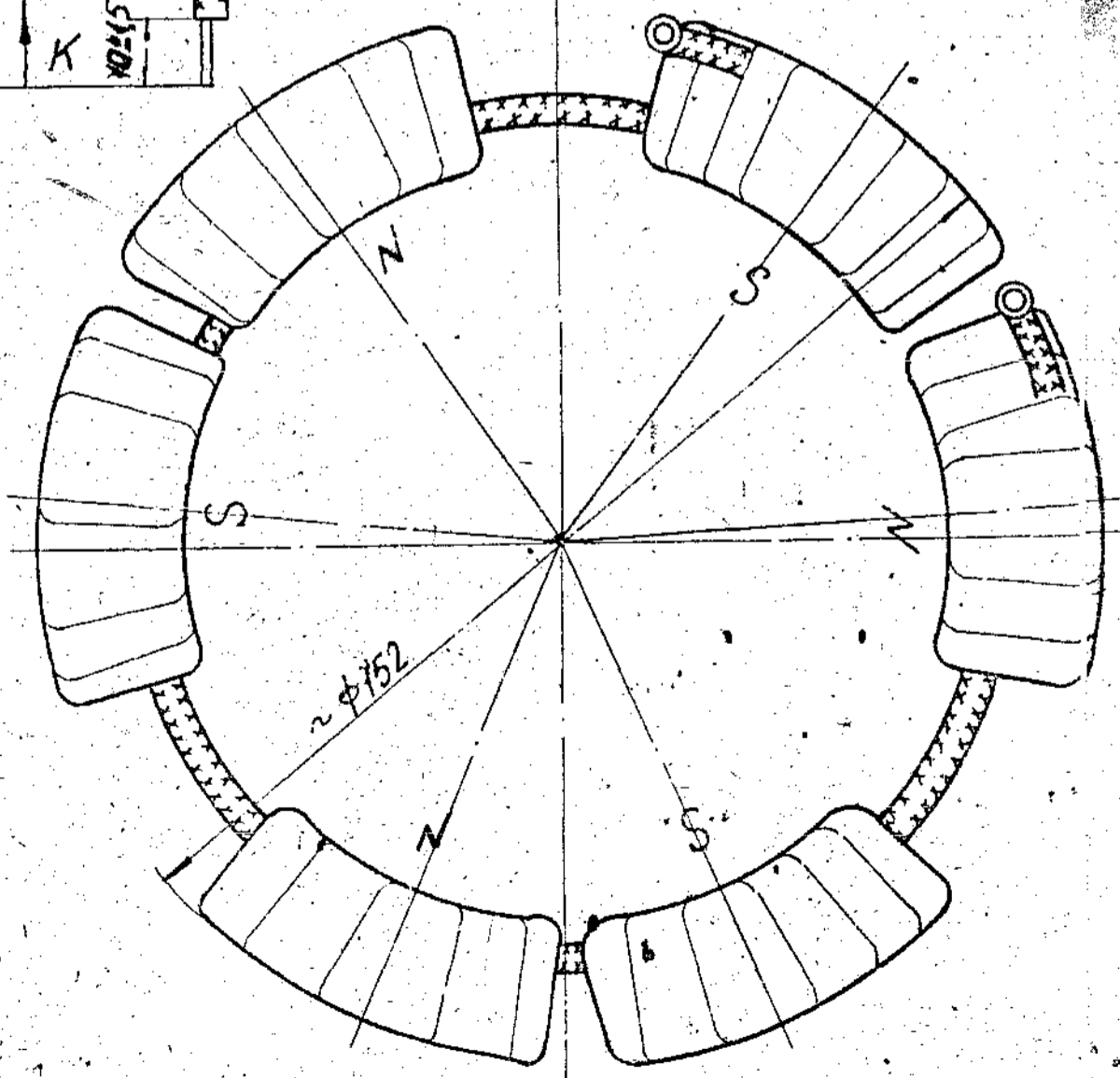
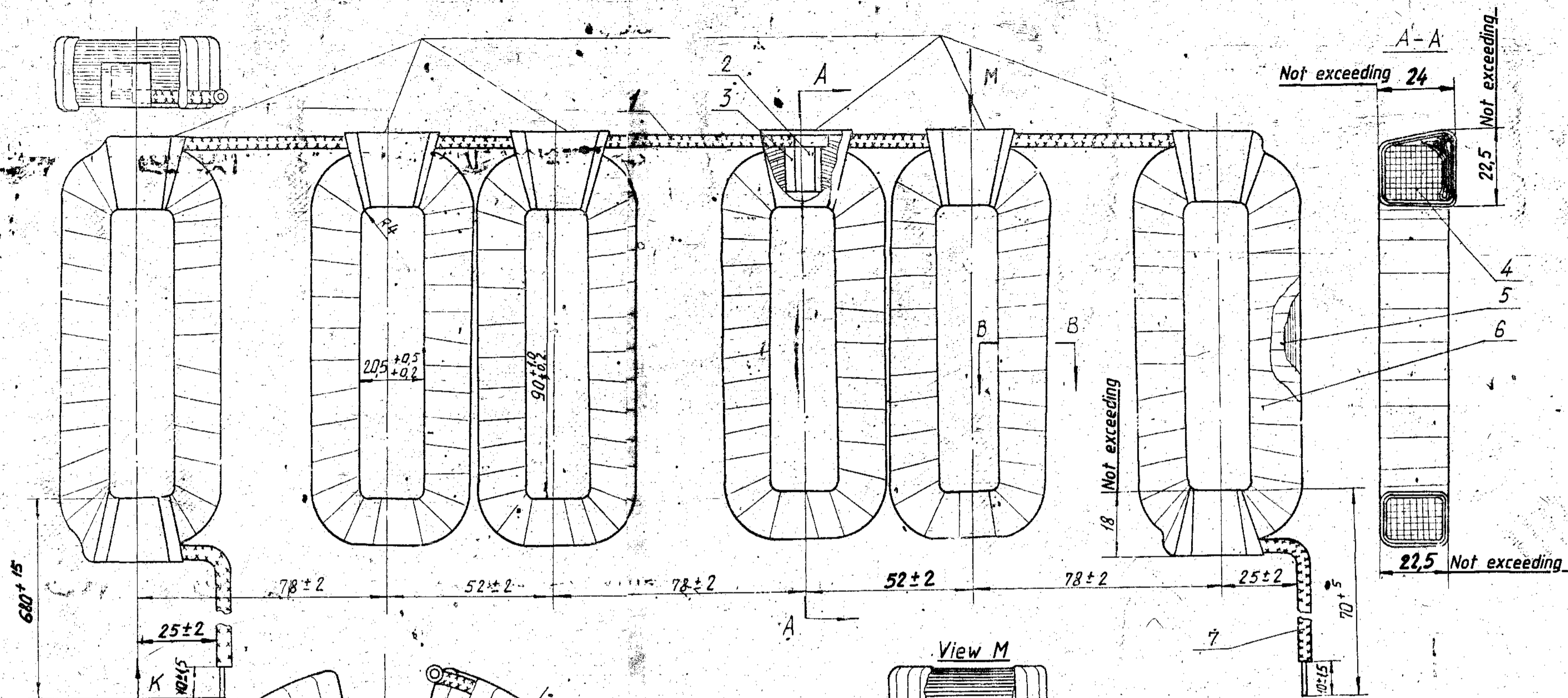
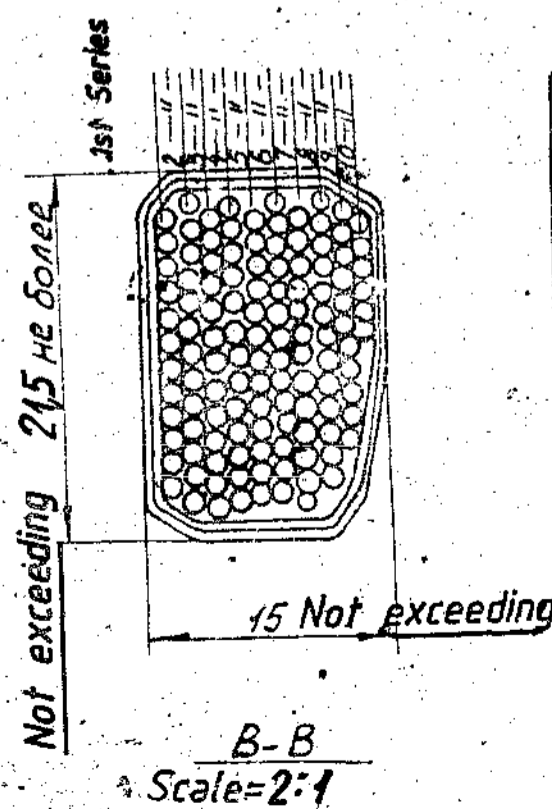


VIEW K

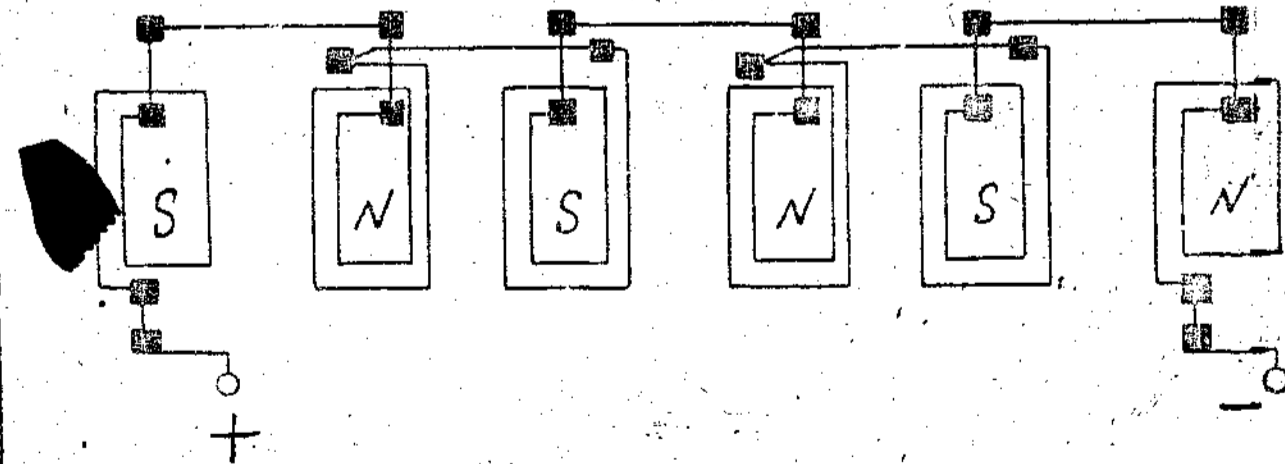
View of non-form wound coils
Sides of changes



Coil connection diagram
(Polarity of coils is shown from the side of pole boring)



SERIES	No. of Turns
1	12
2	13
3	13
4	13
5	13
6	13
7	13
8	13
9	11
10	6
Total = 120	



1. Insulate coils in onelayer half over lapping with ref. no. 5 and then in one layer half over lapping with ref. no. 6.
2. Solder the joints with tin 02.
3. Coils should be form wound as per external radius R 76 in its developed form.
4. Alternate material is 805.00H-5, copper M3M.
5. Place film, ref. no. 10 between the first, second and third series of turns.
6. Coat tape, ref. no 2.0,3 microns thick.

S.NO.	DESIGNATION	DESCRIPTION	QTY.	REMARKS
		Tin 02 GOST 860-75.		
10	805.005 H-10	Film ПЭТФ 0,01-0,02 ТУ 6-05-1597-72.	6	Without drawing
9	805.005 H-9	Electric grade cardboard ЭВ П 02 GOST 2824-75.	4	Without drawing
8	805.005 H-8	Varnished fabric А.В.М.С-105-0,06 GOST 2214-78.	12	Without drawing
7	805.005H-3	Wire МГЛW A 0 П 1,5 мм ² GOST 10349-75.	2	Without drawing
6	805.005 H-2	Cambric cotton tape Б-20-61 GOST 4514-78	16	—
5	805.005 H-2	Varnished fabric А.В.М.С-105-0,06 GOST 2214-78.	6	Without drawing
4	805.005 H-1	Wire ПЭВ - 2-14 GOST 7262-78.		Without drawing
3	805.005 H-4	Electric grade card-board "ЭВН" 0,2 GOST 2824-75.	8	—
2	805.005 H-5	Copper ММ 0,2 X 8 GOST 1173-77.	8	Without drawing
1	805.005 H-6	Wire МГЛW A 0 П 1,5 мм GOST 10349-75.	5	Without drawing

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

EST. MASS 3 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS LETTERS
ISSUE DATE	NATURE OF AMENDMENTS
DRN	SCALE: 1:1
CHD	DIMENSIONS IN mm
TEO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED
APPO	ALL THREADS COILFORM TO
DATE 9-9-87	

CONTROL RATE OF INSPECTION HEAVY VEHICLES (AVADI)

EXCITATION WINDING COILS

DRAWING NUMBER: 805-005 H

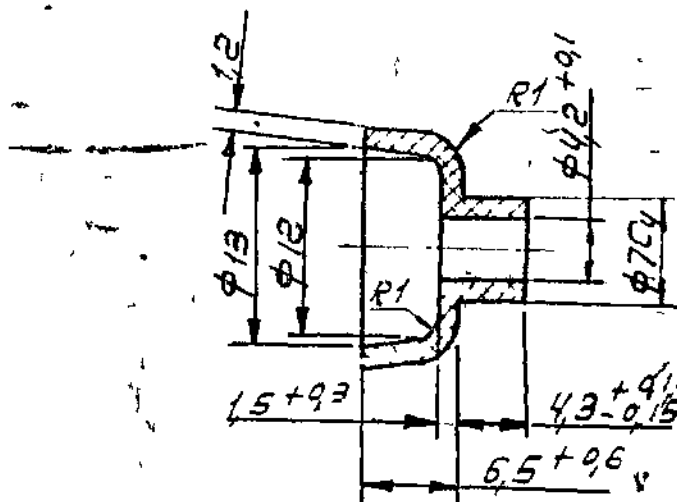
886 188 H 887 988
107

Provide dimensions with out tolerances as per accuracy class 7, OST 1010

(Rectification is not permitted)

Alternate material is glass fabric TB97-2

TY 16-503.059 75



100-256-H

D-83

PRESS MATERIAL AT-6 GOST 20437-75

117

PROT SAMPLE SHOULD BE APPROVED BY A.H.P BEFORE BULK PRODUCTION

			EST. MASS 0,001 Kg	TO BE STAMPED OR INDICATED (THIS #) LETTERS)
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNER TO HAVE R OUTSIDE R IN THE EQUIVALENT CHAIN RS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL:- * SEE ABOVE	USED ON:- 100 256 H
DRG		SCALE:- 2:1	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHKD		DIMENSIONS IN mm	TITLE: INSULATION BUSH	
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D'S CAT NUMBER	
APPD		ALL THREADS TO CONFORM TO	DRAWING NUMBER 886-188 H	
DATE	9-9-87			

889 012 H

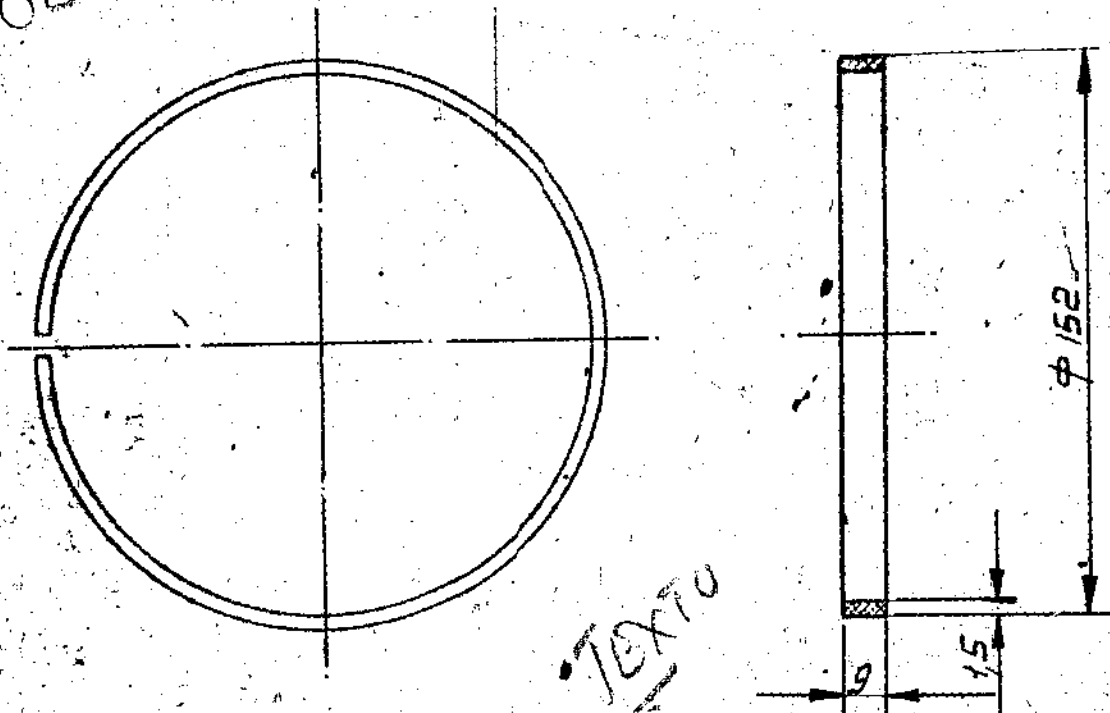
Tolerances for free dimensions are as per accuracy Class 7, OST 1010.

Total length is 471 mm, bend it into ring as per ϕ 152 : 'insitu' in body.

Apply varnish coating and dry as per H8 AO. 028. 007.

X1141
108

250-78



TEXTOLITE

* TEXTOLITE OF GRADE "A" H
GOST 2910-74

0-83

118

PROT SAIZIB SHOULD BE APPROVED BY A HSP BEFORE OUR PRODUCTION

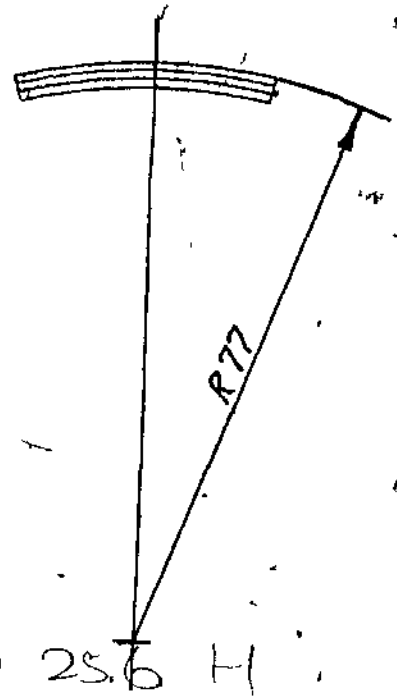
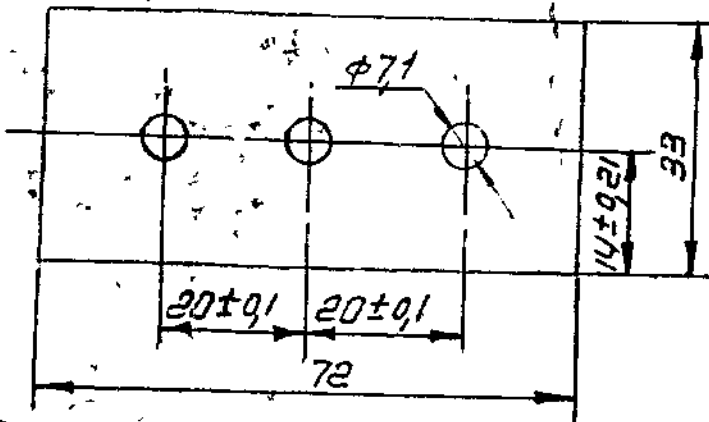
			EST. MASS : 0,011 Kg	TO BE STAMPED OR MARKED WHERE INDICATED (THIS # LETTERS)
				ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED FACED CORNERS TO HAVE R OUTSIDE R IN THE EQUIVALENT DIMENSIONS ARE PERMISSIBLE
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL : * SEE ABOVE	USED ON : 100 256 H
DRN		SCALE: 1:2	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD!	
CD		DIMENSIONS IN mm	INSULATION RING	
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D'S CAT NUMBER	
APPO		ALL THREADS CONFORM TO	889 012 H	

1. Tolerances for free dimensions are as per accuracy class 7, OST 1010.
2. Make of three layers of micanite of thickness 0,5 mm.
3. Coat edges of gasket with Гр 3П -076 Yellow, III - H8H0 050. 001-3.
4. Two-layer packing of micanite of thickness 0,8 mm is allowed,

86-00



Touch Bell



D-83

X 144

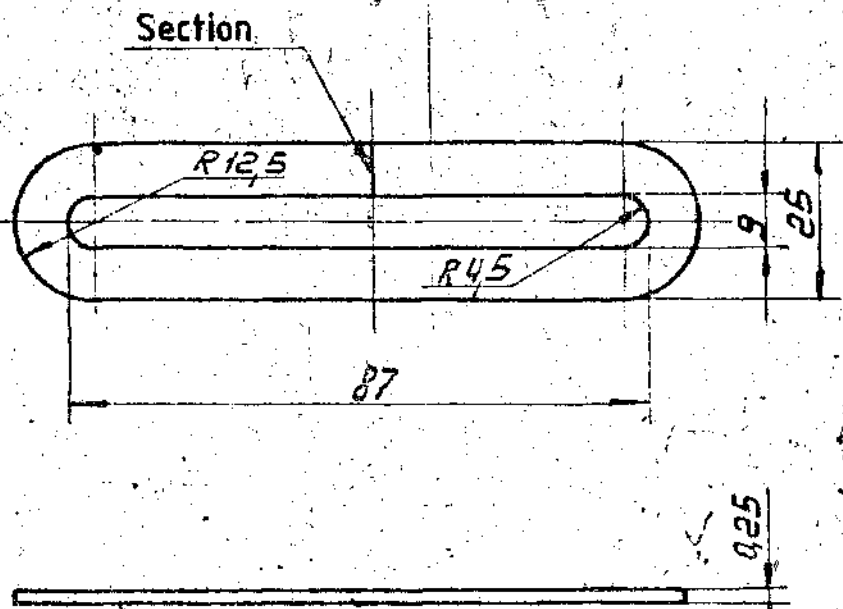
120

PILOT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

		EST. MASS 0-011 Kg	TO BE STAMPED OR INDICATED THIS # [] (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNER TO HAVE R OUTSIDE OR INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL - MICANITE K φ / GOST 2196 -75	USED ON - 100 256 H
DRN	SCALE - 1:1	CONTROL POINT OF INSPECTION (HEAVY VEHICLES' AVADI)	
CHD	DIMENSIONS IN mm	TITLE: INSULATION GASKET	
TEC	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	S CA NUMBER	
APPD	ALL THREADS TO CONFORM TO	DRAWING NUMBER 893 017 H	
DATE 9-9-87			

H542 E68

2



AMDT, NOTN, No: 0024-79 0024-79

Tolerances for free dimensions are as per accuracy class 7, GOST 1070.

X 121
111

805-003 + A

0-83

GLASS MICANITE 78
GOST 8727-F4C-TT-30-0,25

121

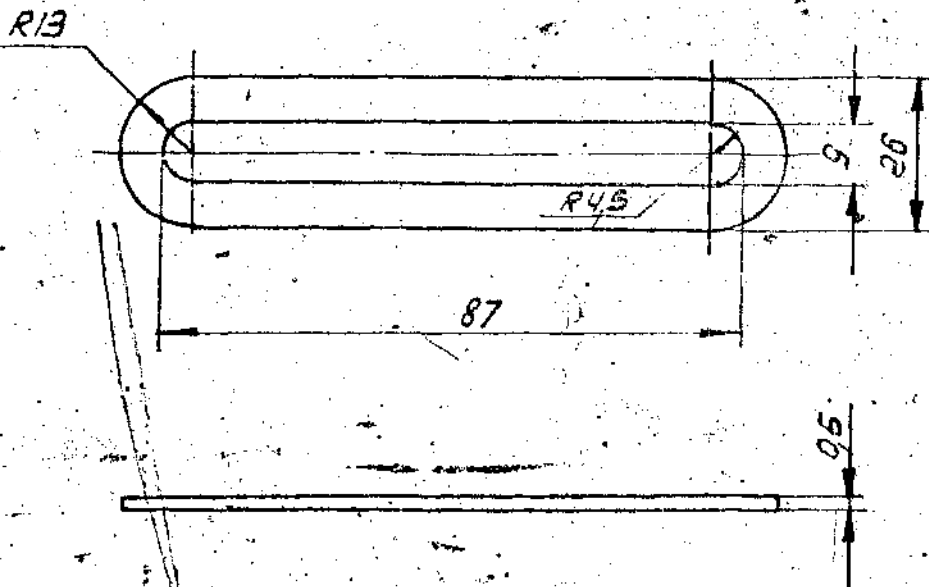
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

		EST. MASS 0,0005 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS # LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL * SEE ABOVE	QTY ON 805-003 H
DRN	SCALE: 1:1	CONTROLLER RATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CDR	DIMENSIONS IN mm	TITLE: INSULATION GASKET	
ICD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	
APPO	ALL THREADS CONFORM TO	DRAWING NUMBER 893-249 H	
DATE 9-9-87			

893 250 H

Tolerances for free dimensions are as per accuracy class 7, OST 1010.

(*) (e) |



AMDJ. NOTN. No: 250-76

D-83

805-003 H

X147
115

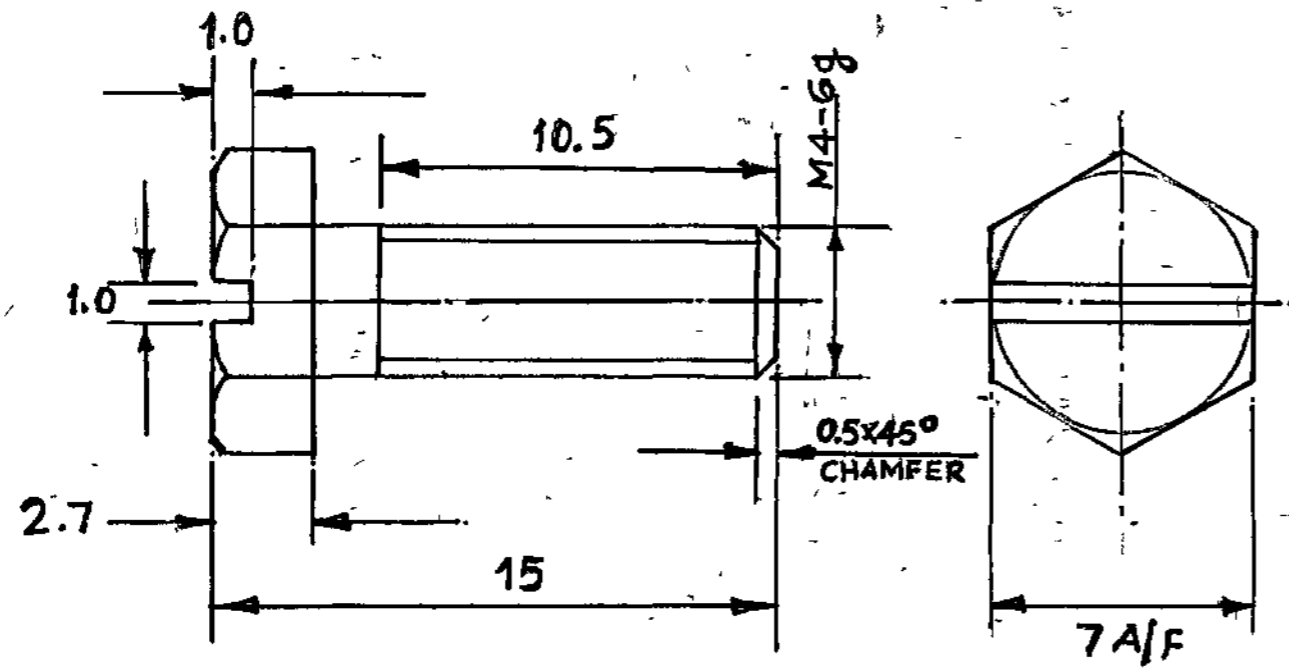
* GLASS TEXOTOLITE CT-1
GOST 12652-74

122

PROT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

EST. MASS 0,001 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS (P- LETTERS)
ALL CHAMP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R OTHERS EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENTS
DRN	SCALE: 1:1
CHD ^{SP} [Signature]	DIMENSIONS IN mm
TCO [Signature]	TOLERANCE ON DIMS UNLESS OTHERWISE STATED
APPD [Signature]	ALL THREADS CONFORM TO
DATE 9-9-87	
MATERIALS * SEE ABOVE	USED ON: 805-003 H
CONTROLLER RATE OF INSPECTION (HEAVY VEHICLES) AVADI	TITLE: INSULATION GASKET
D S CAT NUMBER	DRAWING NUMBER 893-250-H

DRAWING NUMBER
3240A-4-12KA



EXPLANATORY NOTE:-
MATERIAL QUOTED:- STEEL 40 GOST 1050-74
 40 = GRADE OF STEEL

CHEMICAL COMPOSITION%:
 CARBON = 0.37-0.45
 SILICON = 0.17-0.37
 MANGANESE = 0.50-0.80
 CHROMIUM = 0.25
 PHOSPHORUS = 0.035
 SULPHUR = 0.040 } MAX
 COPPER = 0.025
 NICKEL = 0.25

MECHANICAL PROPERTIES:
 ULTIMATE TENSILE STRENGTH $\text{kgf/mm}^2 = 58(\text{min})$
 YIELD POINT $\text{kgf/mm}^2 = 34(\text{min})$
 ELONGATION % = 19(min)
 REDUCTION IN AREA % = 45(min)
 IMPACT STRENGTH $\text{kgf/cm}^2 = 6(\text{min})$

1. COATING: ZINC PLATING, 6 MICRONS THICK, CHROMATISATION.

EXPLANATORY NOTE ADDED ON 27-3-92

G
132

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

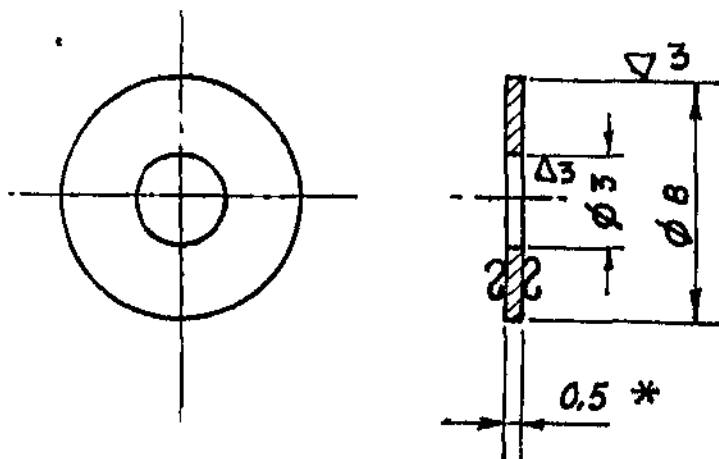
EST. WT. TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT SIDE INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

DRN	<i>Prudis</i>	MATERIAL:- STEEL 40	USED ON SPTA ITEM
CHK	<i>Prudis</i>	GOST 1050-74	100 - 256 H
TCO	<i>Prudis</i>	CONTROLLERATE OF QUALITY ASSURANCE(HEAVY VEHICLES)	
APPD	<i>Prudis</i>	AVADI	
DATE	17-12-90	TITLE	
SCALE:-	5:1	SCREW	
DIMENSIONS IN mm		D S CAT NUMBER	DRAWING NUMBER
TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS 2102-69			
ALL THREADS TO CONFORM TO		3240A-4-12 KA	
ISSUE DATE	NATURE OF AMENDMENTS		

SIZE - A3

DRAWING NUMBER
3402A-0.5-3-8Kd



NOTE:-

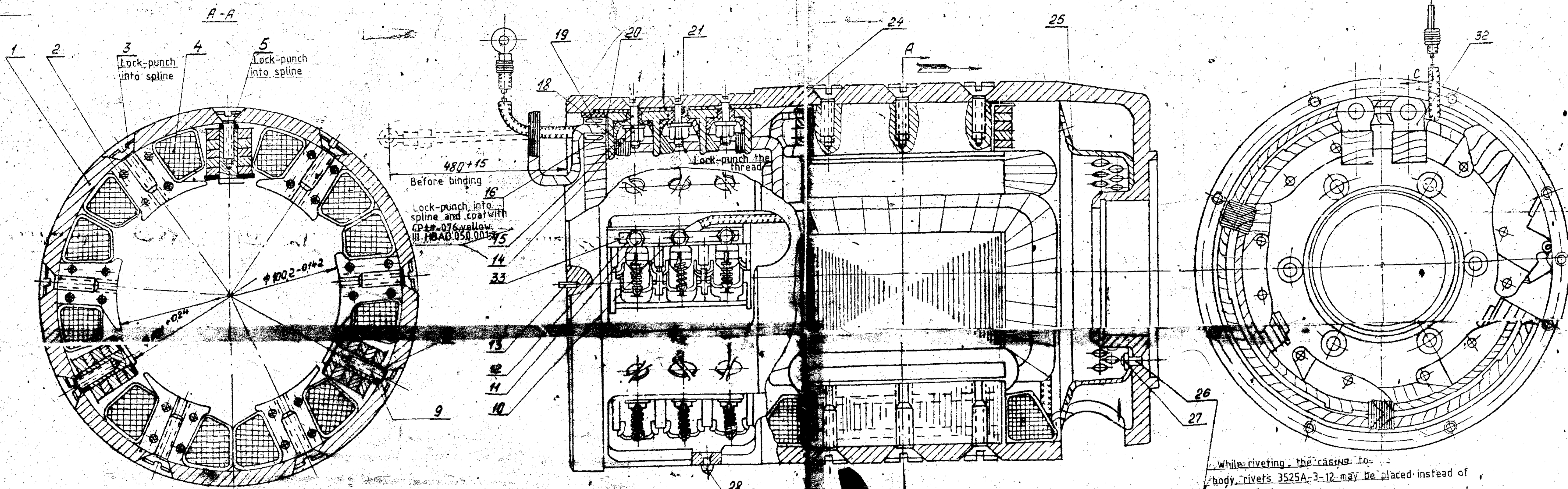
1. COATING : OXIDIZING .
2. * TOLERANCE ON THE DIMENSION IS EQUAL TO THE TOLERANCE ON THE THICKNESS OF DELIVERED MATERIAL .

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

		EST. WT.	TO BE STAMPED OR MARKED WHERE INDICATED THUS # (LETTERS)	
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.		
		MATERIAL:- STEEL	USED ON.	
		GDE 10 TO GOST 1050-74	GENERATOR, UTD-20 002-145H	
ISSUE DATE	NATURE OF AMENDMENTS			
DRN <i>Alkash</i>	SCALE:- 4:1	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)		
CHD <i>Alkash</i>	DIMENSIONS IN mm	AVADI.		
TCD <i>Alkash</i>	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS 2102 -69		TITLE	
APPD <i>Alkash</i>	ALL THREADS CONFORM TO			WASHER
DATE		D S CAT, NUMBER		DRAWING NUMBER
26-11-88				3402A-0.5-3-8Kd
SIZE A4				

G
139

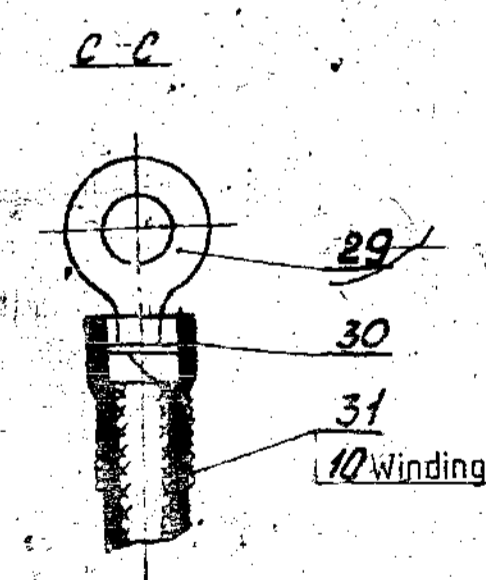
В.И.М. Инв. № 3566
 Восстановление
 с подвижного Ветро
 Д.В.Р.В.С.



1. Impregnate coils together with the body as per HBA 0028001 Section 3 B and coat with enamel П-952 ТУ 6-10-1303-77. The coils from the commutator side inter-coils connections, terminals, rings of additional coils except for the flexibles. Lead brush holder boxes with out units, pipes, ref. nos 30 and 29 and cable tips.
2. Enamel may be present on the inner part of single block. Except for the locating places for brush holder box.
3. Apply varnish in the body as per instruction ТИ-68.
4. Coat upset part of rivets, ref. no 26 with П-076 yellow, III-H 8A0.050.001-3.
5. Play of $\phi 100,2^{+0,142}$ with respect to the locating side for shield and locating place for ball bearing should not exceed 0,2mm.
6. Protect the coil terminal before impregnation as per ТИ11-27
7. Coat the damaged external surfaces of screw heads which secure the poles and places of their lockpunch, with П-076 yellow, III HBA0.050.001-3.
8. Before upsetting the rivets, they may be shortened by 2to3 mm in length as required.
9. Bolts drg. 466.252 H may be placed instead of screws ref. no 11.
10. Put on pipe, ref. no 30 on to the shunt terminal along the whole length.
11. Rivets from brass rod 163, T.KPH M-3 GOST 201-73 may be applied instead of rivets 3525 A-3-12 from copper of grade M2.
12. Solder the cable lugs with tin 02.

Upset and draw in case if the pin is placed after impregnation. Coat the upset part with П-076 yellow III HBA0.050.001-3.

While riveting, the casing to body rivets 3525A-3-12 may be placed instead of B 525A-3-14.



*1 Additional coating - zinc plating, 9 microns thick, chromatization standard.
 *2 Additional coating - zinc plating, 9 microns thick, chromatization standard.

No	Designation	Description	Qty	Remarks	No	Designation	Description	Qty	Remarks
19	889.012H	Insulating ring	1		19	889.012H	Insulating ring	1	
33	483-157	Stop washer	6		28	100.256H-9	Coarse liner threads	1	Without drawing
		Tin 02 GOST 860-75.			16		Screw 2 M4 GOST 14960-76	18	
32	725039H	Interbrush connection	1		15		Washer 340A-1.5-4-10-K2	18	STANDARD
31	100256H-4	Coarse line threads 14,5/6 GOST 14960-76	3	Without drawing	14	474.106H	Nut	18	STANDARD
30	100256H-4	Pipe AB 35 GOST 9614-75	3	Without drawing	13		Pin 3480A-6 P223-16	1	STANDARD
29	712.198H	Cable lug	1		12		Washer 3402A-0.5-4-7K	18	*2
28	491.087H	Pin	1		11	324.0A-4-12K	Screw	18	See Tech. 74 from no. 12.5
27	3402A-0.5-3-8-K07	Washer	6		10	AH9-3-4	Cable lug	1	Standard
26	1526A-3-12	Rivet	6	*1	9	805.003H	Interpole coils	1	
25	157048H	Casing	1		8	388.413H	Gasket	3	
24	550044H	Brush holder	6		5	462.328H	Screw	9	
23					4	805.005H	Excitation winding coils	1	
22					3	462.328H	Screw	18	
21	886.188H	Insulating bush	18		2	560.051H	Pole Assy	6	
20	893.077H	Insulating gasket	6		1	103.270H	Body	1	

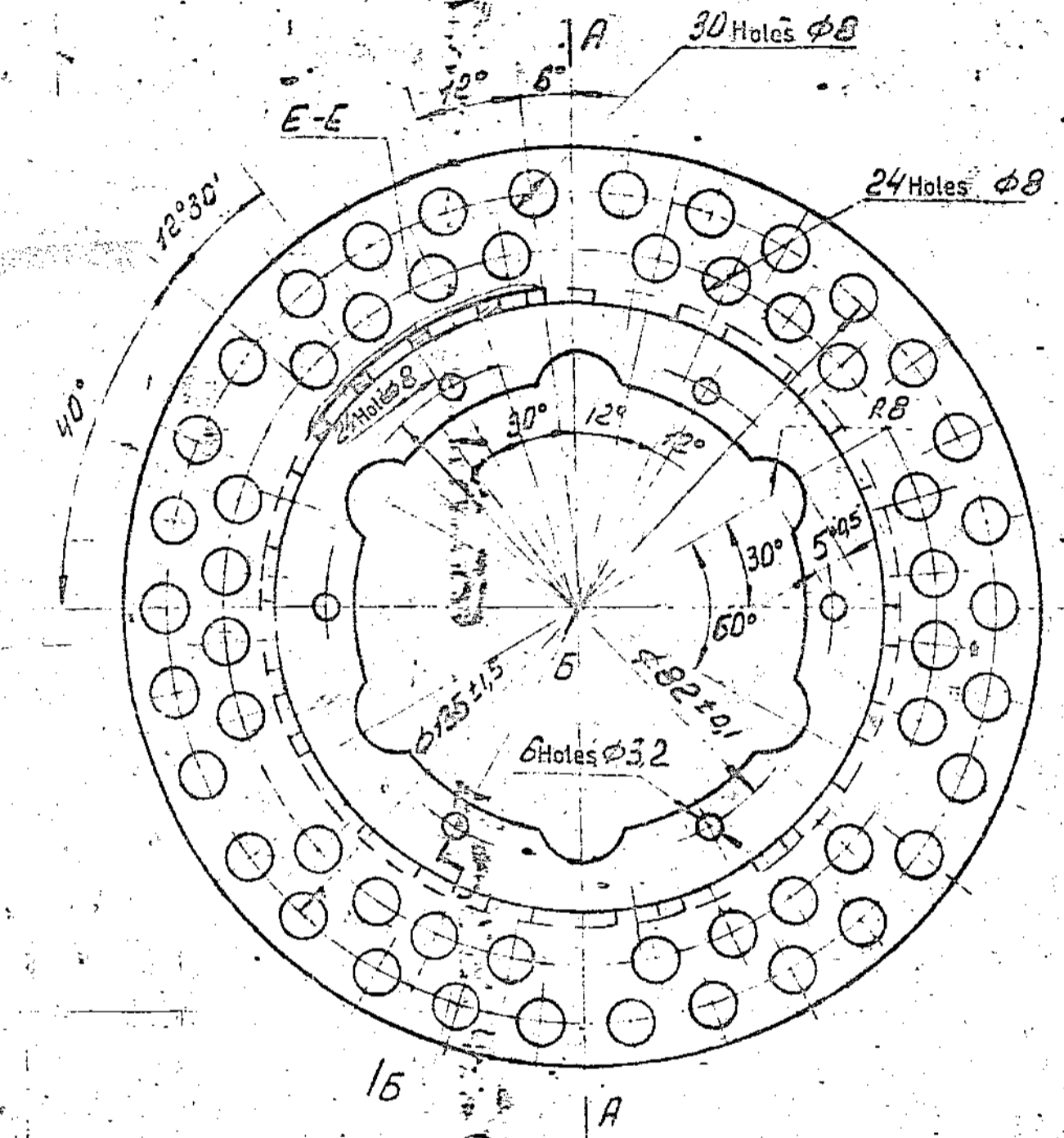
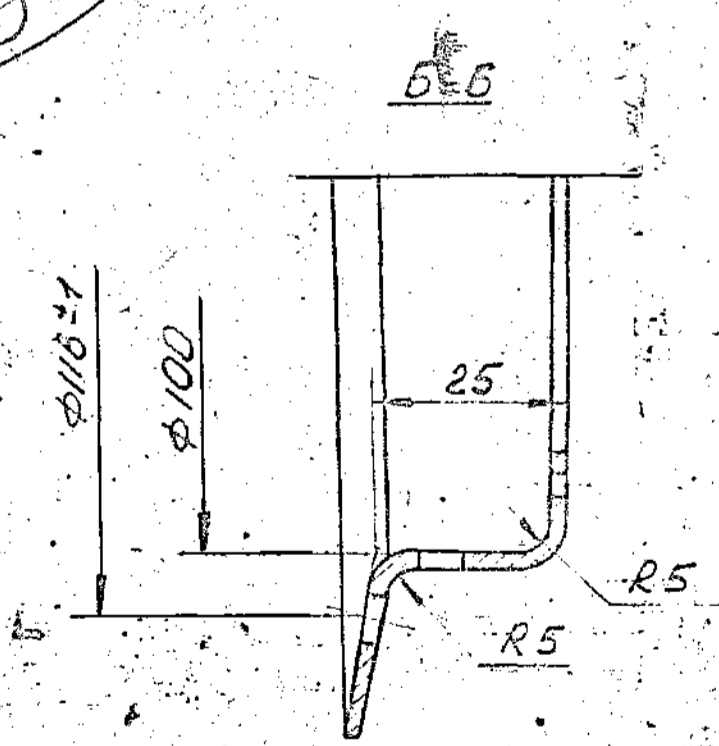
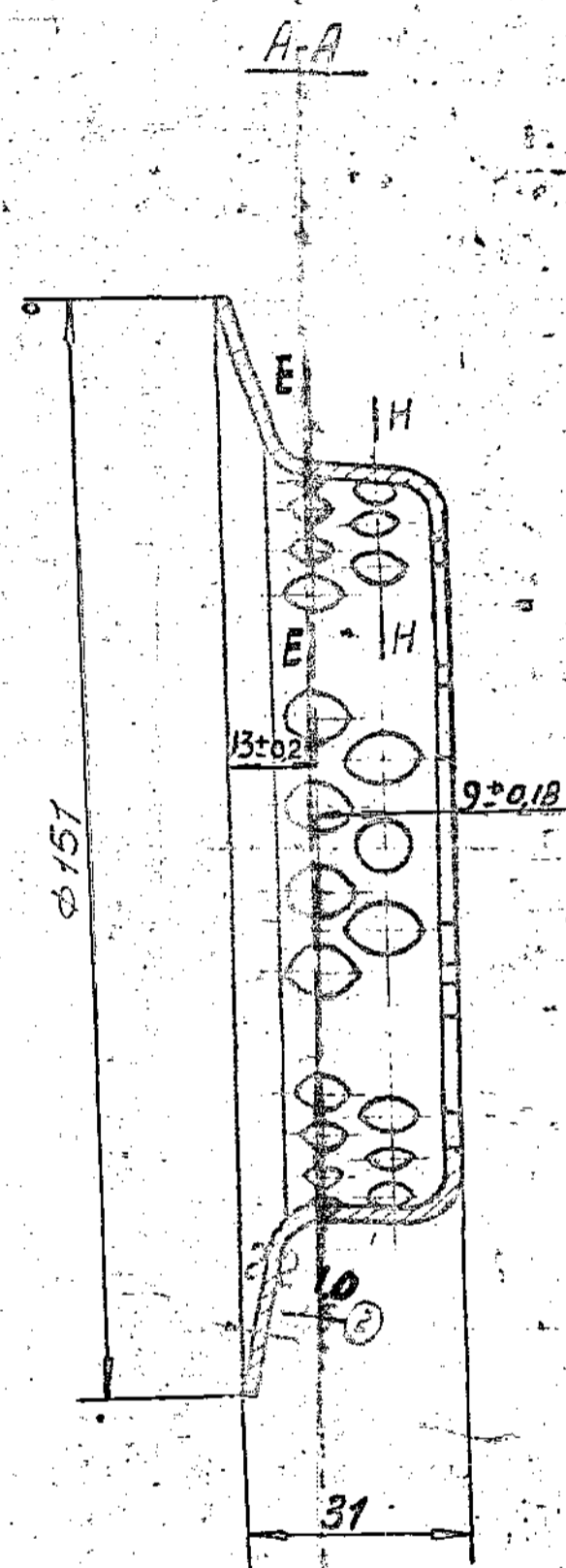
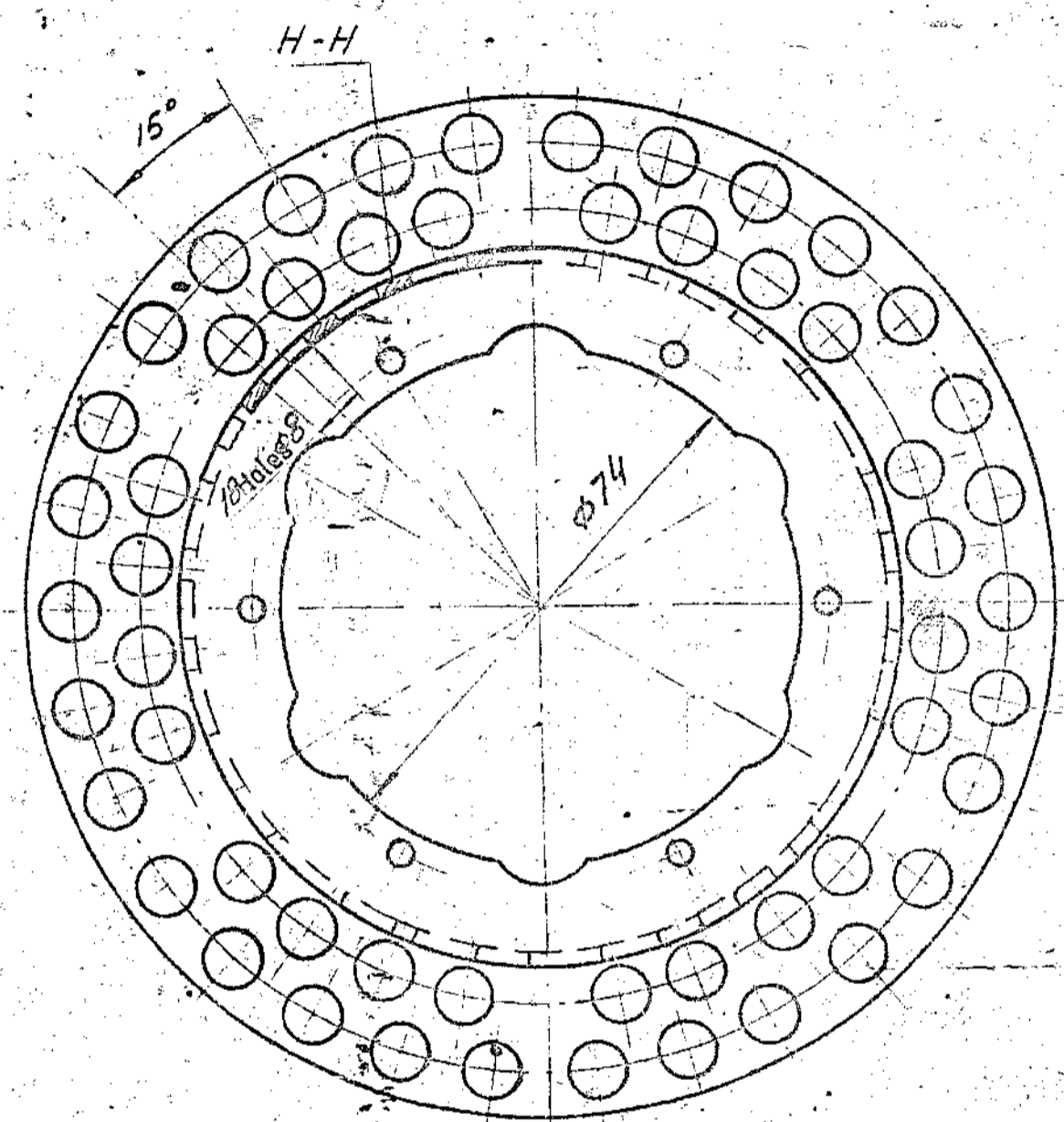
PLOT SAMPLE SHOULD BE APPROVED BY A.H.S.P. BEFORE BULK PRODUCTION

EST. MASS	12.2 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS *
ISSUE DATE		(LETTERS)
NATURE OF AMENDMENTS		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MACHINED CORNER TO HAVE R OUTSIDE R ISIZE EQUIVALENT CHAMFERS ARE PERMISSIBLE
SCALE	1	MATERIAL
DRN		USED ON - 002 145H
DIMENSIONS IN mm		CONTROL LATE OF INSPECTION (HEAVY VEHICLES) AVADI
TOLERANCE ON DIMS UNLESS OTHERWISE STATED		TITLE
ALL THREADS TO CONFORM TO		D-CAT NUMBER
		100-256 H

157.048H

Unless otherwise specified.

1. Tolerances for free dimensions are to be as per accuracy class 7, GOST 1910.
2. Coating: Zinc-plated, 21 microns thick, chromated.
3. Six holes, $\phi 3.2$ may be positioned arbitrarily with respect to the flange of casing and cylindrical part of casing.



X141
32

0-10 DST 19904-76
11-B-0.6 K-GOST 9045-80

47

PILOT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

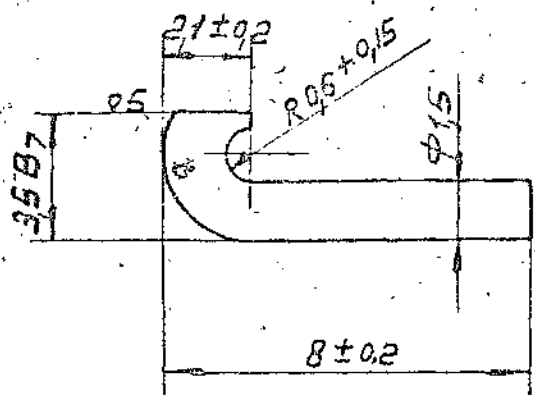
EST. MASS		TO BE STAMPED OR MARKED WHERE INDICATED THUS: (LETTERS)	
0,044 Kg			
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT. CHANGERS ARE PERMISSIBLE			
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL	USED ON: 100 256 H
DRN	SCALE: 1:1	* SEE ABOVE	
CHD	DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADIF	
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: CASING	
APPD	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
DATE 9-9-87			157-048 H

D85

242 032 H

Утвержден.

Unless otherwise specified,



AMDT. NOTN. No: 0057-82
0057-82
0024-79

* WIRE 15-10 GOST 5663-79

60

D-83

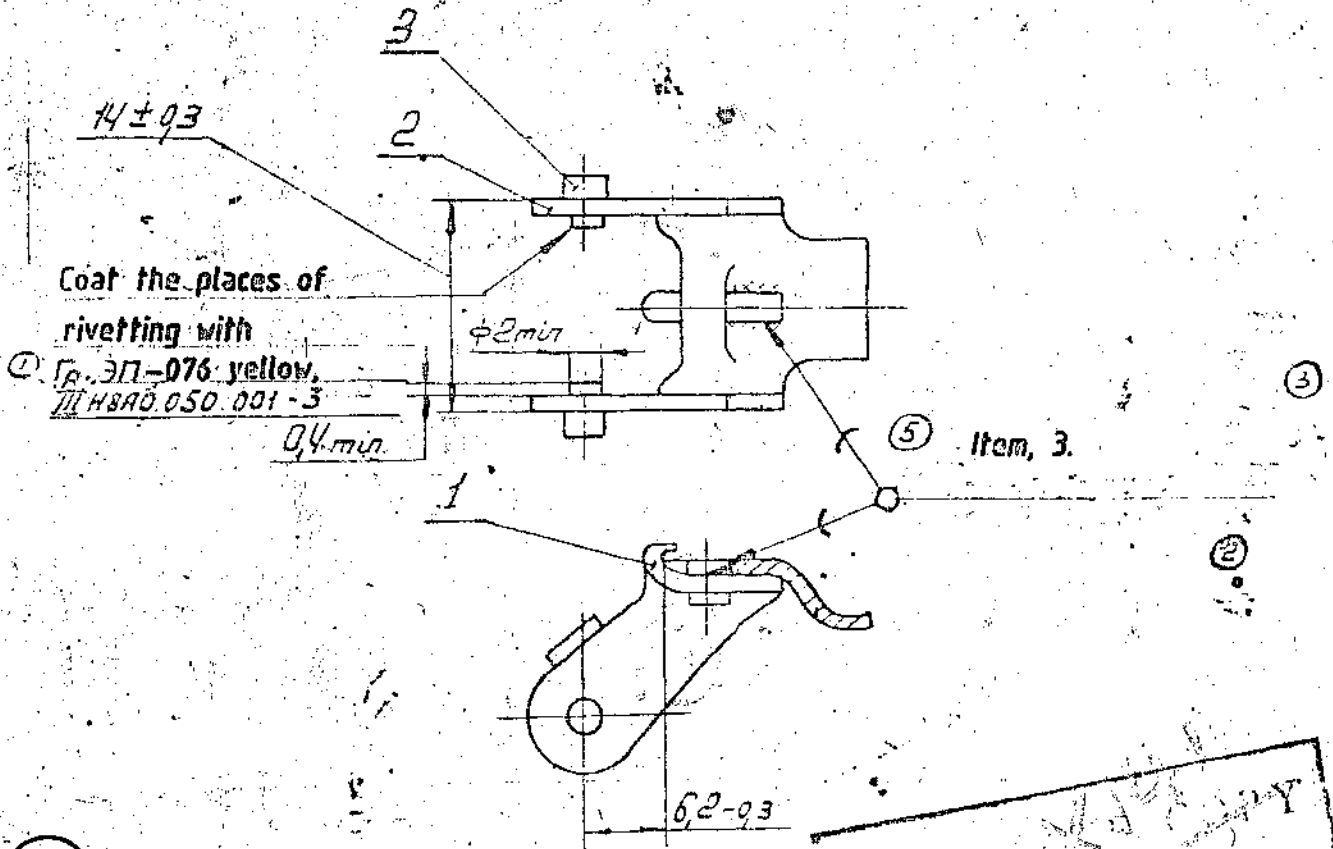
PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

		EST. MASS 0,00015 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL SEE ABOVE	USED DN: 255 026 H
DRN	SCALE: 5:1	CONTROL RATE OF INSPECTION (HEAVY VEHICLES:) AVADI	
END	DIMENSIONS IN mm	HOLDER	
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	
APPO	ALL THREADS CONFORM TO	DRAWING NUMBER 242 032 H	
DATE 9-9-87			

255 026H

Устройство

- 1 Displacement of axes of pins should not exceed 0,15 mm
- 2 Coating:- zinc-plated, 21 microns thick, chromated, except for pins, ref,no,3.
- 3 Braze with brass Л63 GOST 1066-75.



Coat the places of rivetting with
 ① ГР.ЭП-076 yellow,
 ПН880.050.001-3

0,4 min.

Item, 3.

6,2-0.3

0-03

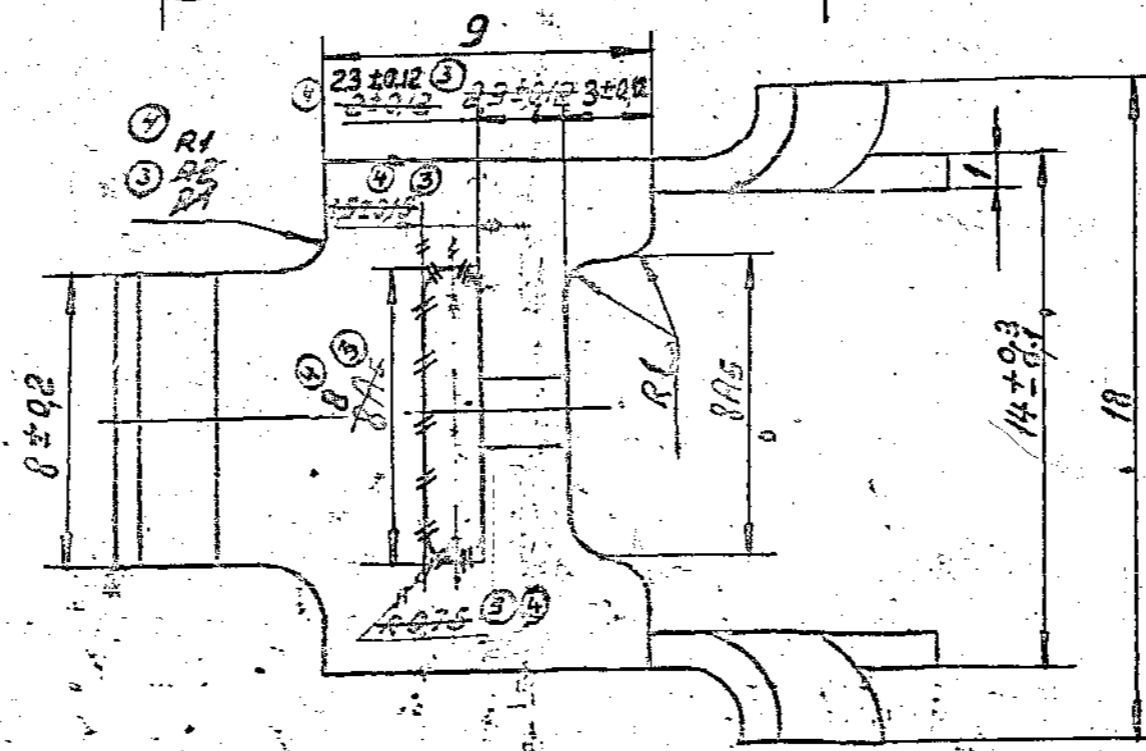
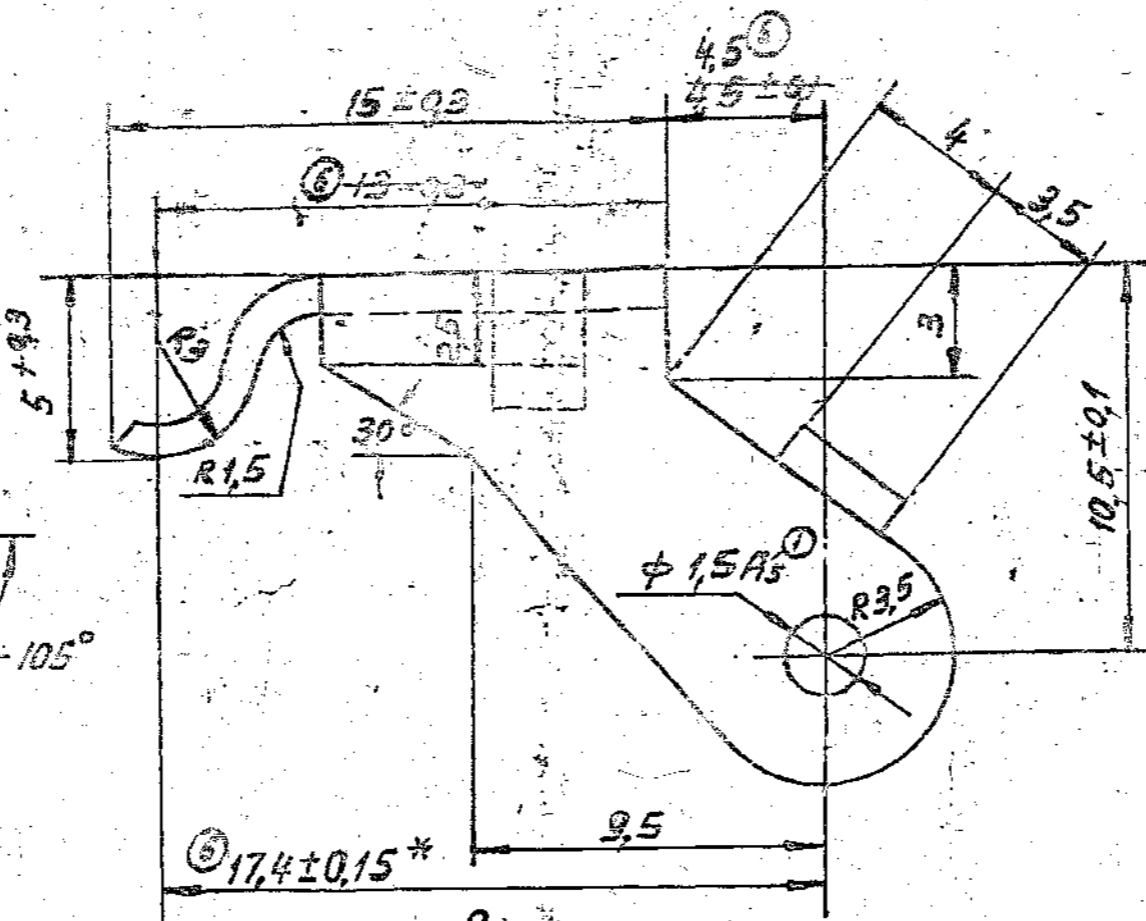
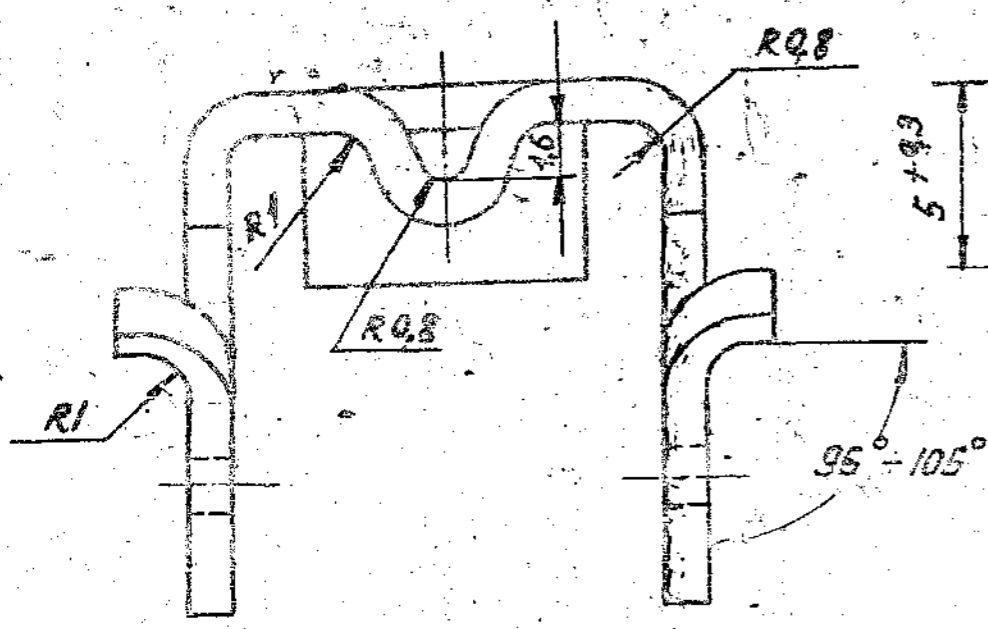
3	491. 220H	✓	Pin	2
2	256. 030H	✓	Lever	1
1	242. 032H	✓	Holder	1

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

25

ISSUE DATE	NATURE OF AMENDMENTS	EST. MASS 0.004 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS IS (LETTERS)
DRN	SCALE:- 2:1	MATERIAL:-	USED ON:- 550 044 H
CHD	DIMENSIONS IN P.S.L.	CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI	
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	④ ⊖ T.T.F.	LEVER
APPO	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER 255 026 H
DATE 9-9-07			

ИДЕНТИФИКАЦИОННЫЙ № 255



Tolerances for free dimensions are as per accuracy class 7, OST 1010.

Привести * Dimension with tool

* PLATE 5-GOST 18904-74
II - Г 10 GOST 13523-70

PROT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

61

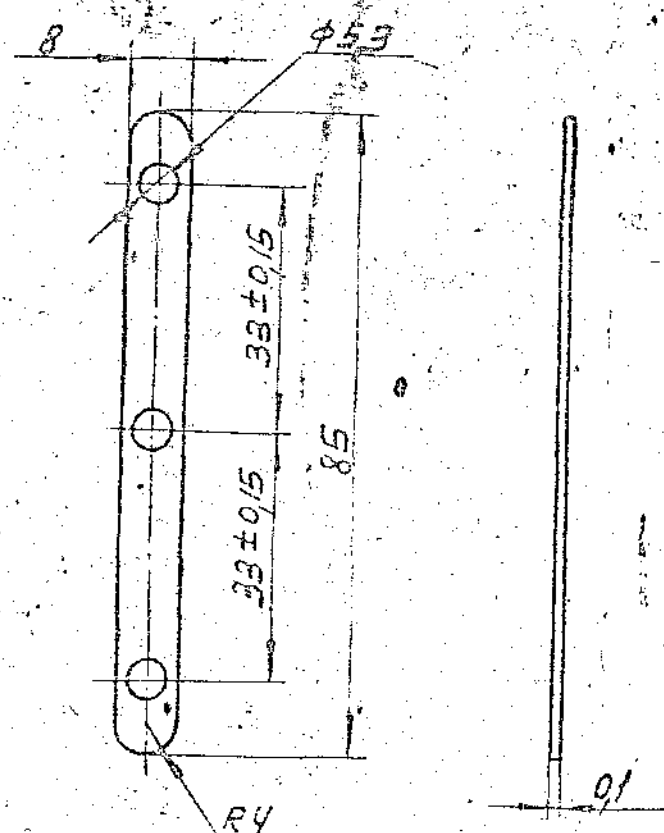
ISSUE	DATE	NATURE OF AMENDMENTS	EST. MASS 0,003 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)
ORN		SCALE: 5:1	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MAXIMUM CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT (CHAMFERS ARE PERMISSIBLE)	
CHD.		DIMENSIONS IN mm	MATERIAL SEE ABOVE	USED ON: 255 026H
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI	
APPD.		ALL THREADS CONFORM TO	TITLE: LEVER	DRAWING NUMBER 256-030 H
DATE	9-9-87		D S CAT NUMBER	

503

ИДЕНТИФИКАЦИОННЫЙ № 255

388 413 H

2



100 256 H

AMDT, NOTN, No: 0026-79

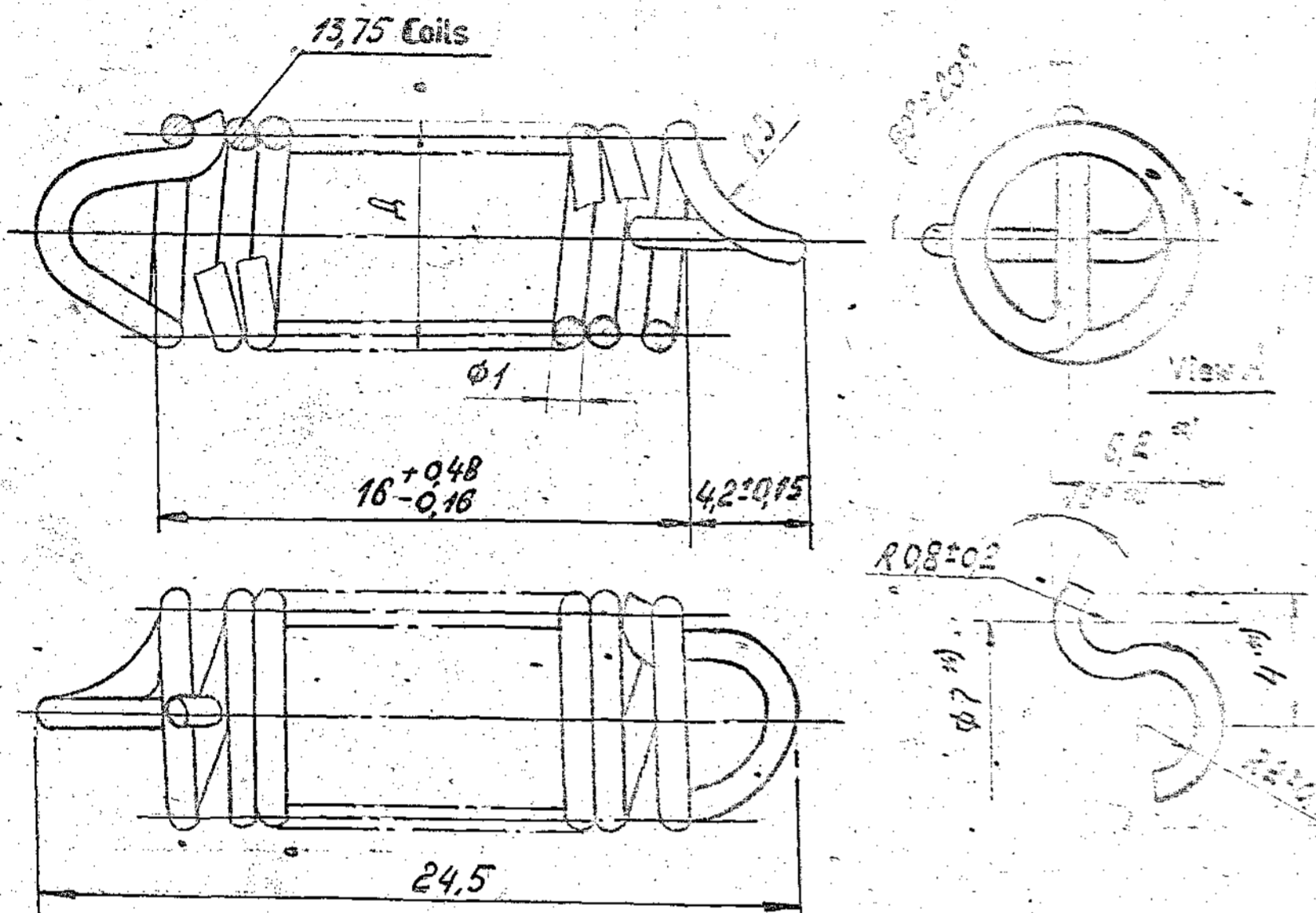
Tolerance for free dimensions are as per accuracy Class 5 (OST 1015 A₅, C₅) Gasket may be made from Brass Л63 GOST 2208-75.

0-83

PILOT SAMPLE SHOULD BE APPROVED BY A IIS P BEFORE BULK PRODUCTION

67

			EST. MASS 0-00052 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS W/ (LETTERS)
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R RISKIE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL - BRASS ПС 59-1 GOST 2200 -75	USED ON - 100 256 H
DRN		SCALE - 1:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CTD		DIMENSIONS IN mm	TITLE: GASKET	
TCD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	
APPO		ALL THREADS CONFORM TO	DRAWING NUMBER 388 413 H	
DATE	9-9-07			



1. Tolerance for free dimensions to be as per IS 2 AT
2. Carry-out heat treatment as per IS 2-13. Hardness should be 42 to 80.
3. Pitch between the two ends of the eye may be obtained by their stretching.
4. Diameter of end coils may be as per tables 1 and 2.1.
5. Dimensions marked as * are given for the construction of drawing.
6. Permissible displacement of R 11.04 of the eye with respect to the spring axis should not exceed 0.2 mm.
7. Permissible displacement of eyes with respect to the spring axis should not exceed 0.4 mm.
8. Undercutting and mechanical damage are not allowed at eye bands over R 3mm.
9. Force by load of 3.5 Kg for 24 hours.
10. Spring length may be increased by 0.5 mm after forcing by load.
11. Spring dimensions are given without considering the coating.
12. To obtain the given strength characteristic the external spring diameter A may be increased upto 0.2 mm for the values specified in tables.
13. Carry-out heat treatment after cadmium coating for two hours and at $t = 180^{\circ}$ to 200° c.
14. Springs should be made from the wire having the depth of surface decarburization not exceeding 0.01 mm (for each side).

TABLE NO-1

Wire Dia.	Spring Dia, A
0.99	7.87-0.1
1	8.0 -0.1
1.01	8.07 -0.1
1.02	8.17 -0.1
1.03	8.28 -0.1

TABLE NO-2

Wire Dia.	Spring Dia, A

WIRE 51*4A
TYAEX 266-76

141
56

Spring designation	Developed strength of spring when it is stretched upto the dimension 3/4 mm(Kgf).	Coating	Dependence of spring diameter A on wire diameter (Considering tolerance).	Remarks
443-353H-1	1.85-2.1	Chemical oxidation. Coat with varnish KP-965 GOCT 15030-70	Table no:1	

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

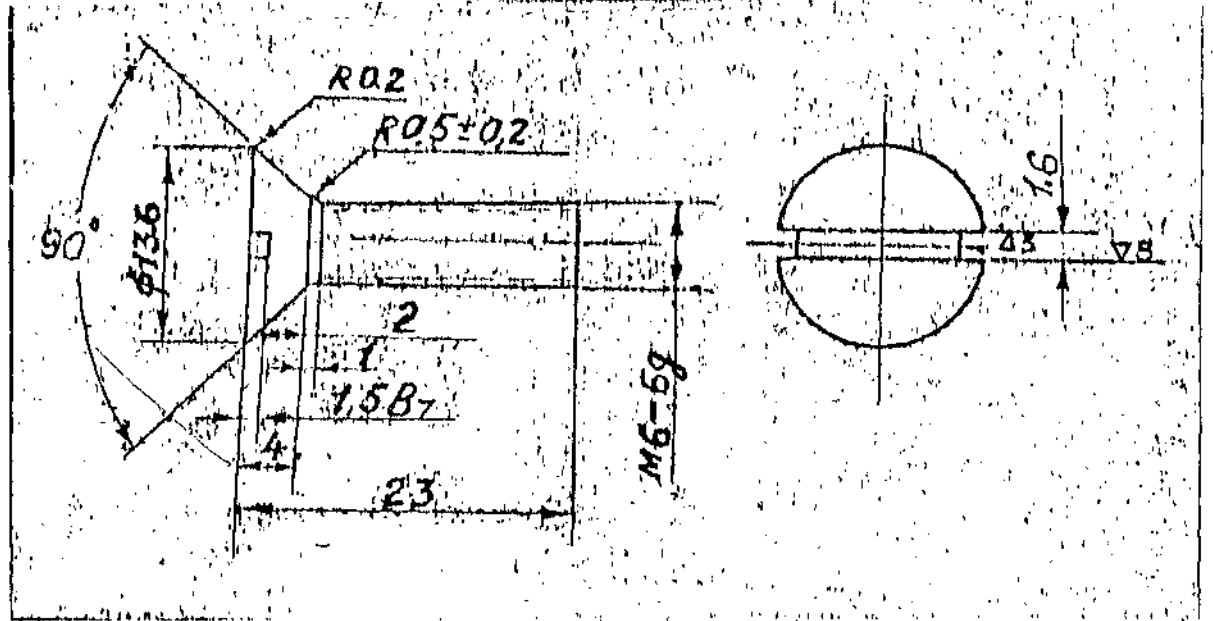
EST. MASS 0.002 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS: (LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MACHINED CORNERS TO HAVE R 0.05 ± 0.02	
ISSUE DATE	NATURE OF AMENDMENTS
DRW	SCALE: 1:1
CHKD	DIMENSIONS IN mm
YCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED
APPROV	ALL THREADS CONFORM TO
DATE 9-9-87	
MATERIAL: * SEE ABOVE	
USED ON: 550 044 H	
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TITLE: SPRING	
D S CAT NUMBER	DRAWING NUMBER 443-353 H

69

DRAWING NUMBER
462 328H

UNLESS OTHERWISE SPECIFIED

DRAWING CREATED BASED ON RUSSIAN ORIGINAL ISSUE :- 5



1. PROVIDE DIMENSIONS WITHOUT DEVIATIONS AS PER ACCURACY CLASS 7, OST 1010.
2. MAKE SCREW BY HEADING METHOD WITH THREAD ROLLING.
3. CARRYOUT HEAT TREATMENT HRC 30 TO 34.
4. COATING : ZINC-PLATING 6 MICRONS THICK, CHROMATIZATION.
5. ALTERNATE MATERIAL IS STEEL 16 x CH TY 14-4-385-73.

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

EST. WT.
0.006

TO BE STAMPED OR MARKED WHERE INDICATED THUS \neq (LETTERS)

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT-SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.

MATERIAL:-
WIRE 30XFEA
TY 14-4-385-73

USED ON
002-145H

ISSUE DATE NATURE OF AMENDMENTS

DRN *[Signature]* SCALE:- 2:1
DIMENSIONS IN mm

CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES)
AVADL

CHD *[Signature]*
TCD *[Signature]*
APPD *[Signature]*
TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED IS 2102 -69

TITLE
SCREW

DATE 15 DEC 89
CONFORM TO

D · S CAT NUMBER

DRAWING NUMBER

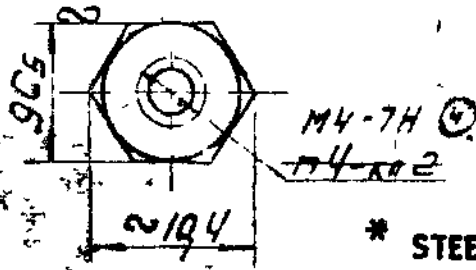
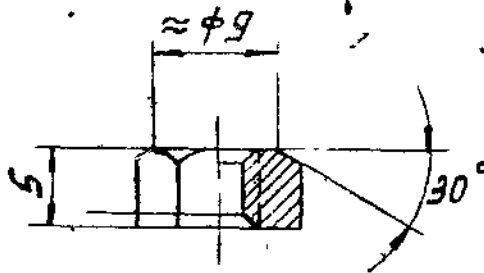
462 328H

SIZE A4

H901 HLH

UNLESS OTHERWISE SPECIFIED

1. TOLERANCES FOR FREE DIMENSIONS ARE AS PER ACCURACY CLASS 7 OST 1010.
2. COATING: ZINC-PLATING, 6 MICRONS THICK, CHROMATIZATION. DEHYDROGENATE.
3. THREAD CHAMFERS SHOULD BE AS PER GOST 10549-63.



100 256 H

* STEEL 45 GOST 1560-78

AMDT, NOTN, No: 0189-80

0-83

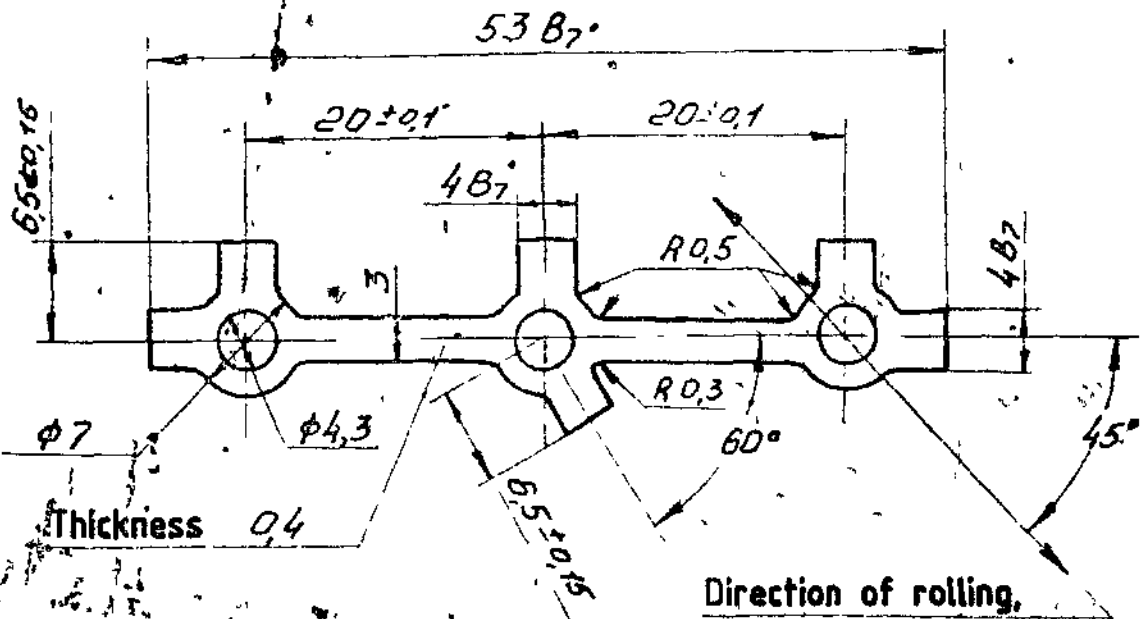
PROT SAMPLE SHOULD BE APPROVED BY ANSP BEFORE BULK PRODUCTION

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THUS Φ LETTERS)	(82)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE		
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL	USED ON	100 256 H
DRN	SCALE	* SEE ABOVE	CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI	
CHKD	DIMENSIONS IN mm	TITLE		NUT
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER		DRAWING NUMBER
APPD	ALL THREADS CONFORM TO			474 106 H
DATE 9-9-87				

483-157H

X14-1
78

Tolerance for free dimensions are as per 22 AT 52



COATING: ZINC-PLATING 9 MICRONS THICK, CHROMATISATION
DEHYDROGENATE

** SOFT STEEL 10 GOST 503-71

X14-1
78

128

PROT SAMPLE SHOULD BE APPROVED BY A.I.P. BEFORE ANY FURTHER

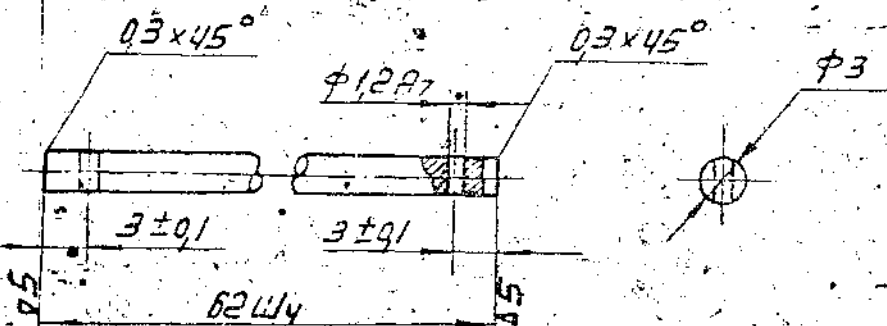
EST NAME	TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTERS)
ISSUE	DATE
NATURE OF AMENDMENTS	SCALE - 2.1
DIMENSIONS IN mm	MATERIAL - ** SEE ABOVE
TOLERANCE ON DIMENSIONS UNLESS OTHERWISE STATED	USED ON - 100 256H
ALL THREADS TO CONFORM TO	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI
	TITLE LOCK WASHER
	DRAWING NUMBER 483-157 H

H800 16h

Unless otherwise Specified

Dehydrogenate

141
80



Coating : Zinc-plated, 9 microns thick, chromitized

D-83

PLOT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

		EST. MASS 0.0005 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS IS (LETTERS)	(92)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE		
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL :- WIRE 3-10 GOST 5663 -79	USED ON :-	550 044 H
DRN	SCALE:- 2:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		
CHD	DIMENSIONS IN mm	⊕ □	TITLE	PIN
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	DRAWING NUMBER	
APPO	ALL THREADS CONFORM TO		491 008 H	
DATE 9-9-87				

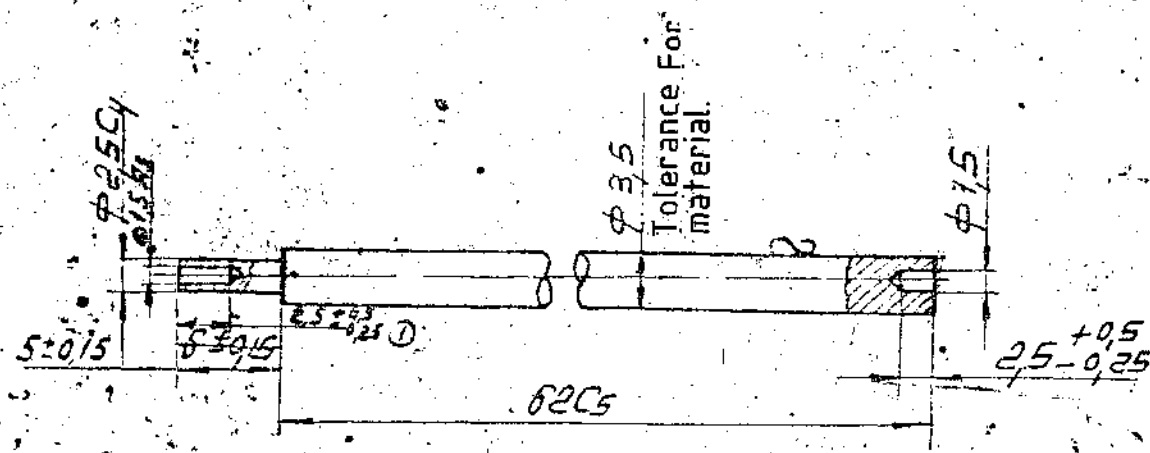
① M60016h

IND

95 - Unless otherwise specified.

- 1. Tolerances for free dimensions are as per accuracy class 7: OST 1010.
- 2. Dehydrogenate.

Handwritten: 1/4
81



AMDT, NOTN, No 0057-02

Coating: Zinc - plated, 9microns thick chromated.

① 0-83

① 93

PROT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

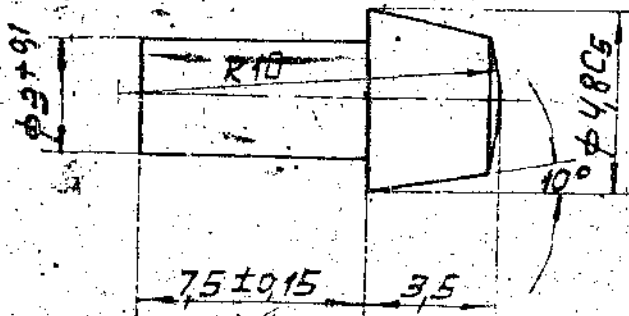
		EST. MASS 0.006 Kg	TO BE STAMPED OR MARKED WHERE DEDICATED THIS IS (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE: - 2:1	MATERIAL: WIRE 3-5-10 GOST 5663-79 USED ON: 550 044 H
CHKD		DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: * PIN
APPD		ALL THREADS CONFORM TO	D S CAT NUMBER
DATE 9-9-87			DRAWING NUMBER 491 009 H

1180 167

IND

05.

1. Tolerances for free dimensions are as per accuracy class 7 OST 1010.
2. Coating" Zinc-plated, 9 microns thick, chromatised.
3. Pin may be made from wire 3-10 GOCT 5663-79.



100: 256 H

* STEEL 10
GOST 1051-73 GOST 7417-75

AMDT, NOTN, No: 0051-82

Q-83

PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

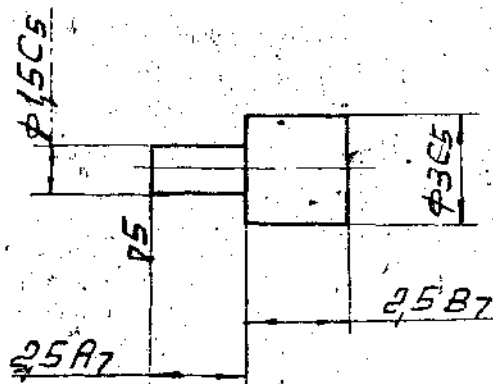
9.4

EST. MASS 0,001 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS & LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R HIGH EQUIVALENT CHAMFERS ARE PERMISSIBLE	
MATERIAL * SEE ABOVE	USED ON :- 100 256 H
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TITLE: PIN	
D S CAT NUMBER	DRAWING NUMBER 491-087 H

ISSUE DATE	NATURE OF AMENDMENTS
DIRN	SCALE:- 5 : 1
END	DIMENSIONS IN mm
TCO	TOLERANCE ON DRHS UNLESS OTHERWISE STATED
APPO	ALL THREADS CONFORM TO
DATE 9-9-87	

491.220H

Ø6 Unless otherwise specified



Coating: Chemical passivation

Alternate material is steel 2x 13 TY 14-1-378-72.

0-63

* STEEL 1x13 TY 14-1-378-72

144

95

PROT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

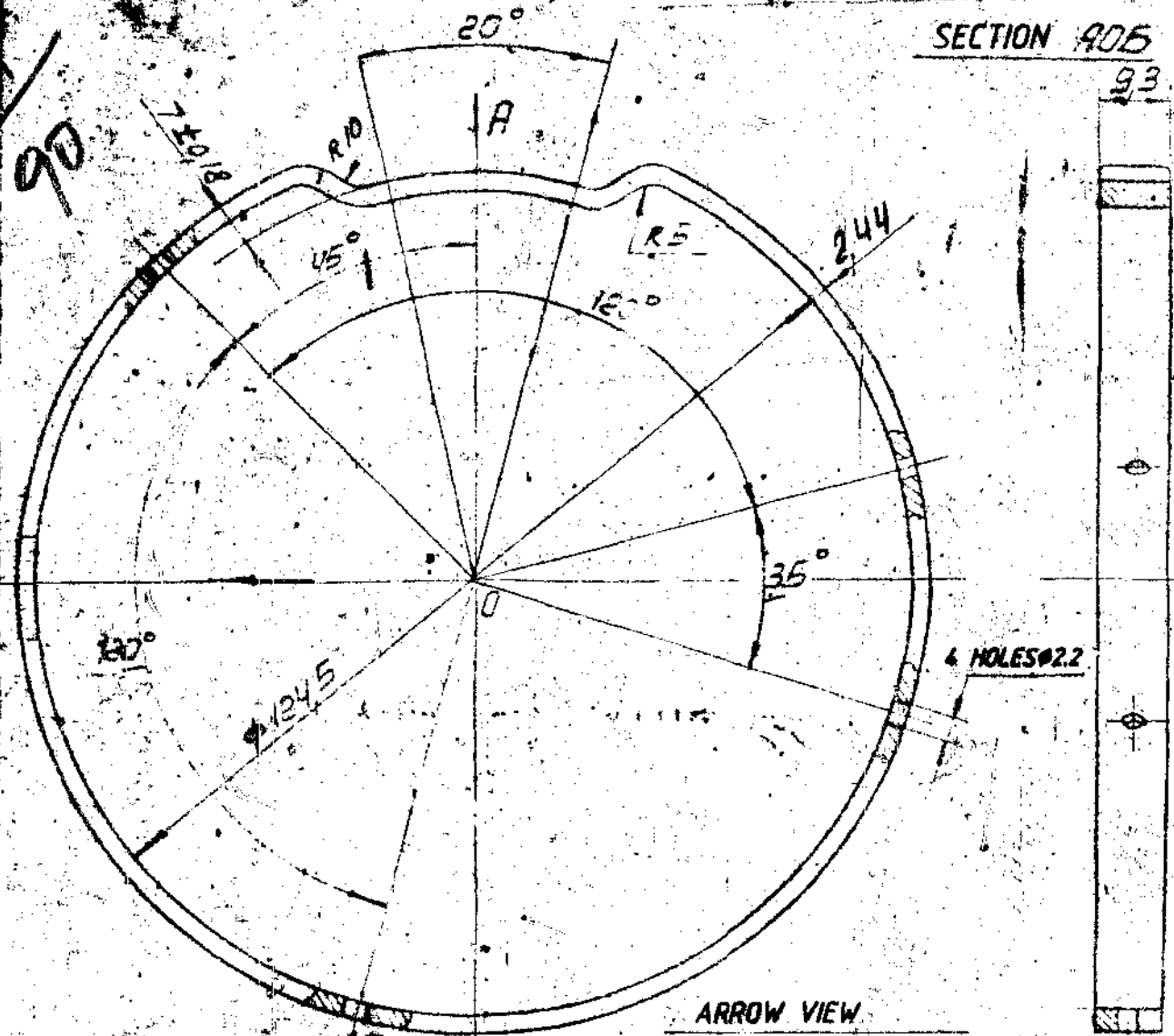
		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL	USED ON: 255 026H
DATE	SCALE: 5:1	* SEE ABOVE	
CHKD	DIMENSIONS IN MM	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAIA	
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	PIN	
APPD	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
DATE 9-87			491-220 H

HOID 165

TOLERANCES FOR FREE DIMENSIONS ARE AS PER ACCURACY CLASS 7, OST 1010.

RING MAY BE MADE OF COPPER M1 WITH THICKNESS 2.5mm.

SECTION 905



BRAZE THOROUGHLY WITH BRASS A 63

OST 019-47
GOST 15527-70

D-83

MM24.4x9.3
GOST 43-70

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

EST. MASS
0,1 Kg

TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)

101

ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE

SS JE DATE NATURE OF AMENDMENTS

ORIN SCALE: 1:1

CMD DIMENSIONS IN mm

TCD TOLERANCE ON DRILLS UNLESS OTHERWISE STATED

APPO DATE 9-9-87 ALL THREADS CONFORM TO

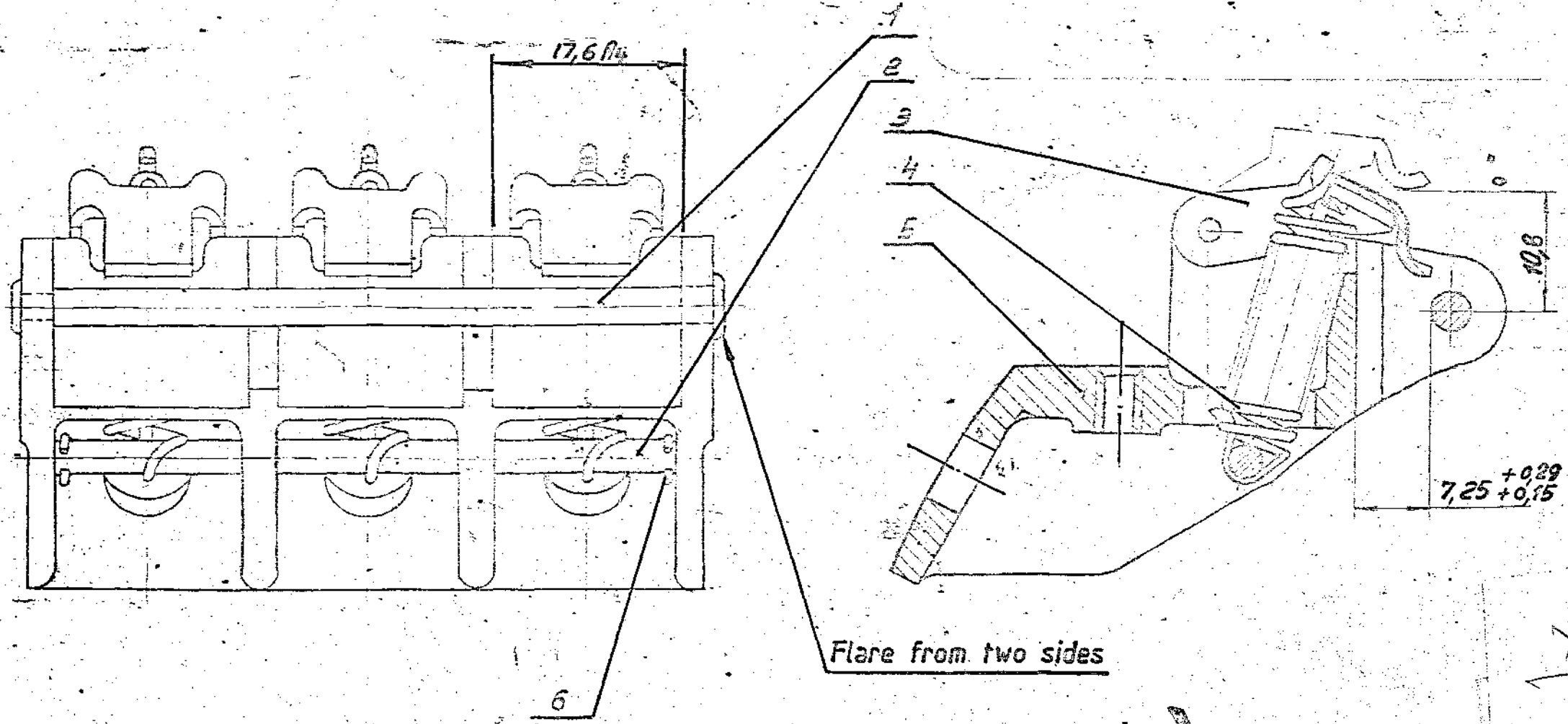
MATERIAL: * SEE ABOVE USED ON: 805 003 H

CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI

TITLE: CONTACT RING

D S CAT NUMBER

DRAWING NUMBER
531-010 H



1. Pressure on lever should be 575 to 700 gms for specified dimension 10,8 mm

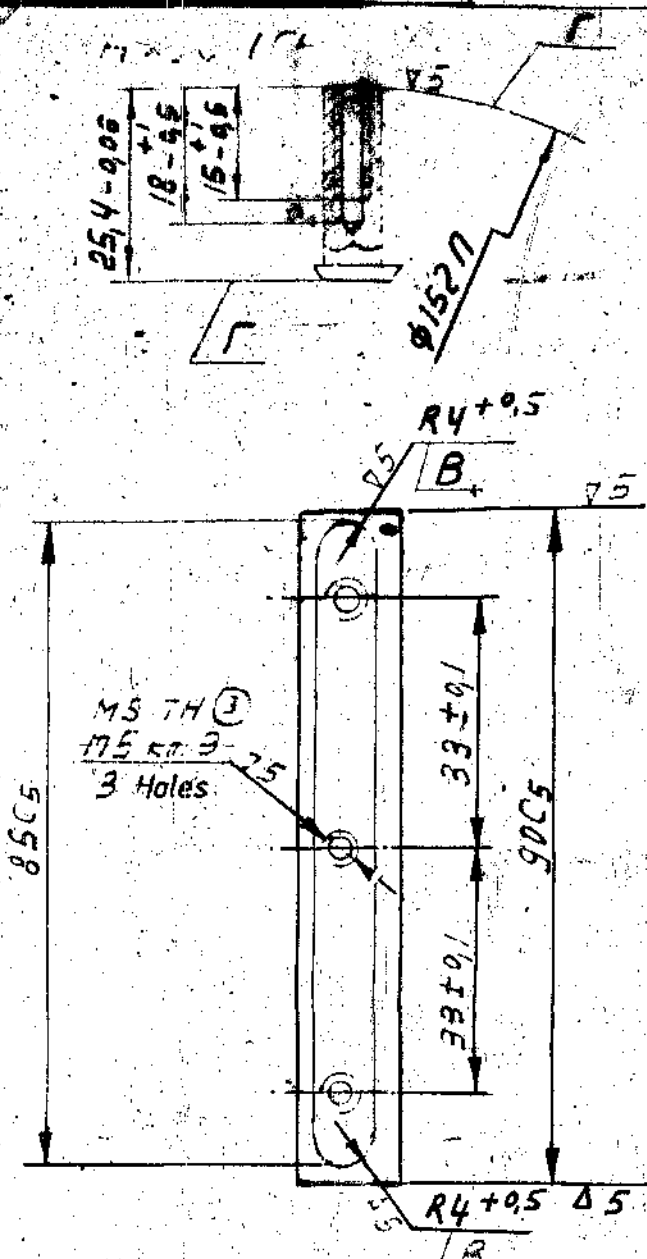
S.No	DESIGNATION	DESCRIPTION	QTY.	REMARKS
6		Cotter pin 1x6,019 GOST 397-79	2	
5	551.015 H	Brush Holder	1	
4	443.353 H-1	Spring	3	
3	255.026 H	Lever <i>Asfy</i>	3	
2	491.008 H	Pin	1	
1	491.009 H	Pin	1	

PILOT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

		EST MASS 0,077Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS (32)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHANGERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL: - USED ON: - 100-256 H
DRN		SCALE: - 2:1	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI
CHD		DIMENSIONS IN mm	TITLE: BRUSH HOLDER ASSY
YCD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER
APPD		ALL THREADS CONFORM TO	DRAWING NUMBER 550-044 H
DATE	9-9-07		

563 021H

2/10/1



* BLANK: PROFILE AS PER DRG No 456

805-003 H

0-83

1. Round off pole backs with $R 0.6 \pm 0.3$ mm along contour of radii B,
2. Provide complete mating of radii B with lateral surfaces.
3. Threaded chamfers are as per OST 1:00010.71.
4. Coat with Varnish K0-965 as per H8A0.028.004 except for surface F.

Handwritten signature and initials

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

109

EST. MASS 0,135 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS # LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R HIGH R EQUIVALENT CHAMFERS ARE PERMISSIBLE	
DATE	NATURE OF AMENDMENTS
DRN	SCALE: 1:1
CHKD	DIMENSIONS IN mm
YCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED
APPO	ALL THREADS CONFORM TO
0249-9-87	
MATERIAL: * SEE ABOVE	USED ON: 805 003 H
CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TITLE: INTER POLE	
D S CAT NUMBER	DRAWING NUMBER 563 021H

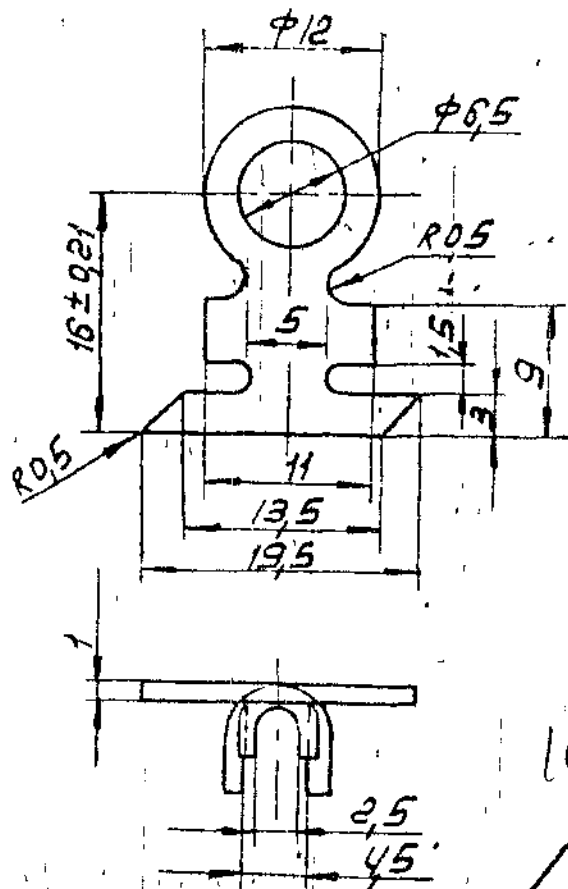
712 198 H

2

1. Tolerances for free dimensions are as per accuracy Class 7, OST 1010.
2. Coating:- 0,3 microns thick with fusion or 0,9 microns thick.

Development

Развертка



0-83

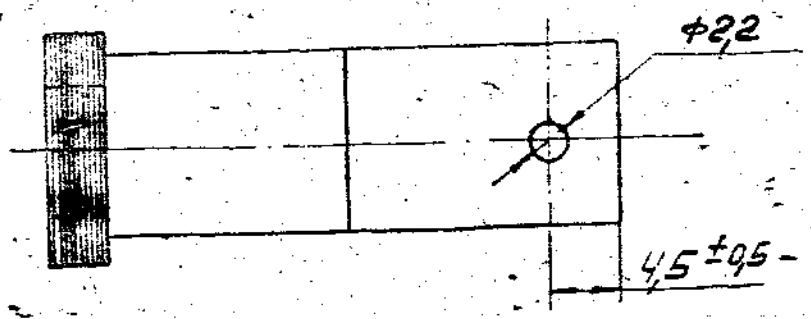
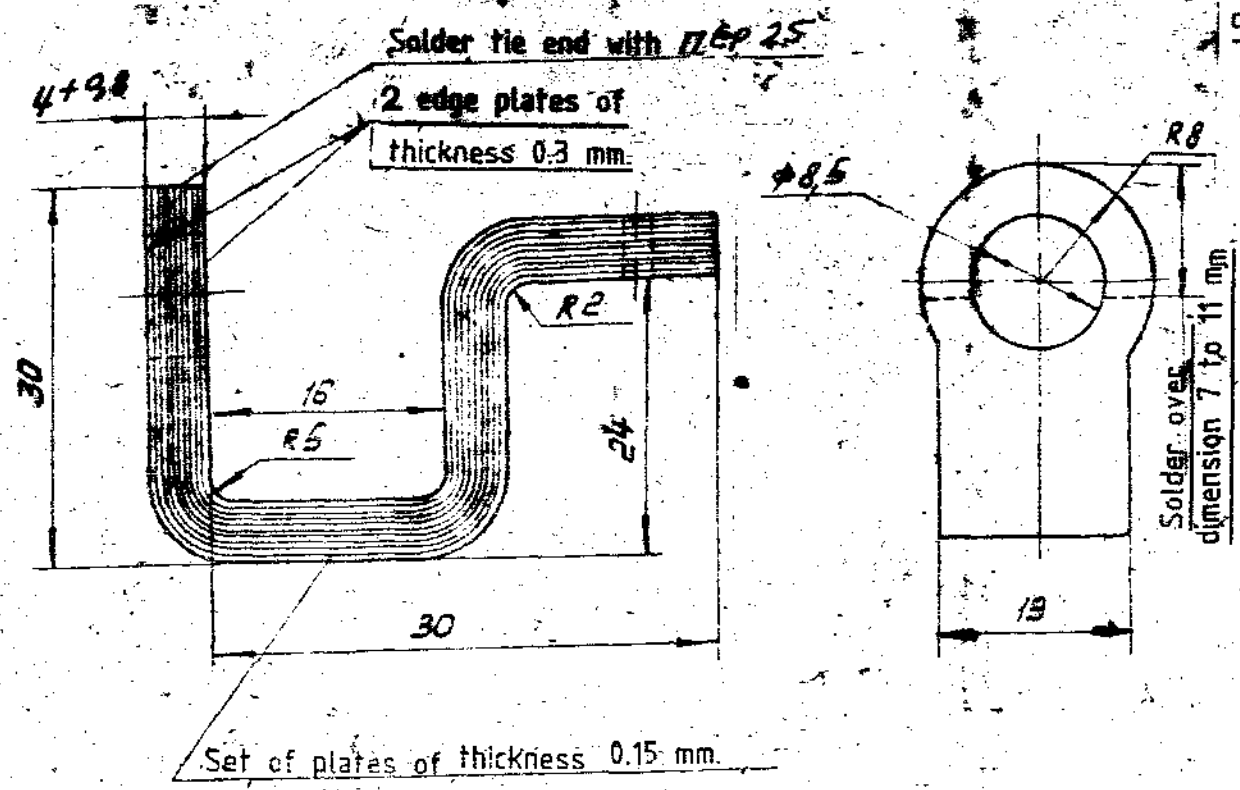
SHEET 1, IPHM1863
GOST 15527-70, GOST 931-78

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

110

EST. MASS 0,002 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS # (LETTERS)
ISSUE DATE	NATURE OF AMENDMENTS
DRN	SCALE 2:1
CHD	DIMENSIONS IN mm
ICD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED
APPO	ALL DIMENSIONS CONFORM TO
DATE 9-9-87	TO
MATERIAL * SEE ABOVE	USED IN - 100 256 H
CONTROL DATE	FOR HEAVY VEHICLES; AVADI
CABLE LUG	
712 198 H	

1. Tolerances for free dimensions as per accuracy class 7, OST 1010.
2. Permissible non-parallelity of contact surfaces should not exceed 0.3 mm.
3. Splicing of unsoldered end and spring properties release are allowed as per dimensions 24: 30 and 16.
4. Dress and degrease blanks.
5. Alternate material is copper M3M GOST 1173-77.



2	0024-01	2. R 2	Поры
1	220-18	2.2.2.15	
2	72-130		

ЛИСТЫ ДИТАЦИОННОГО СИГНАЛА

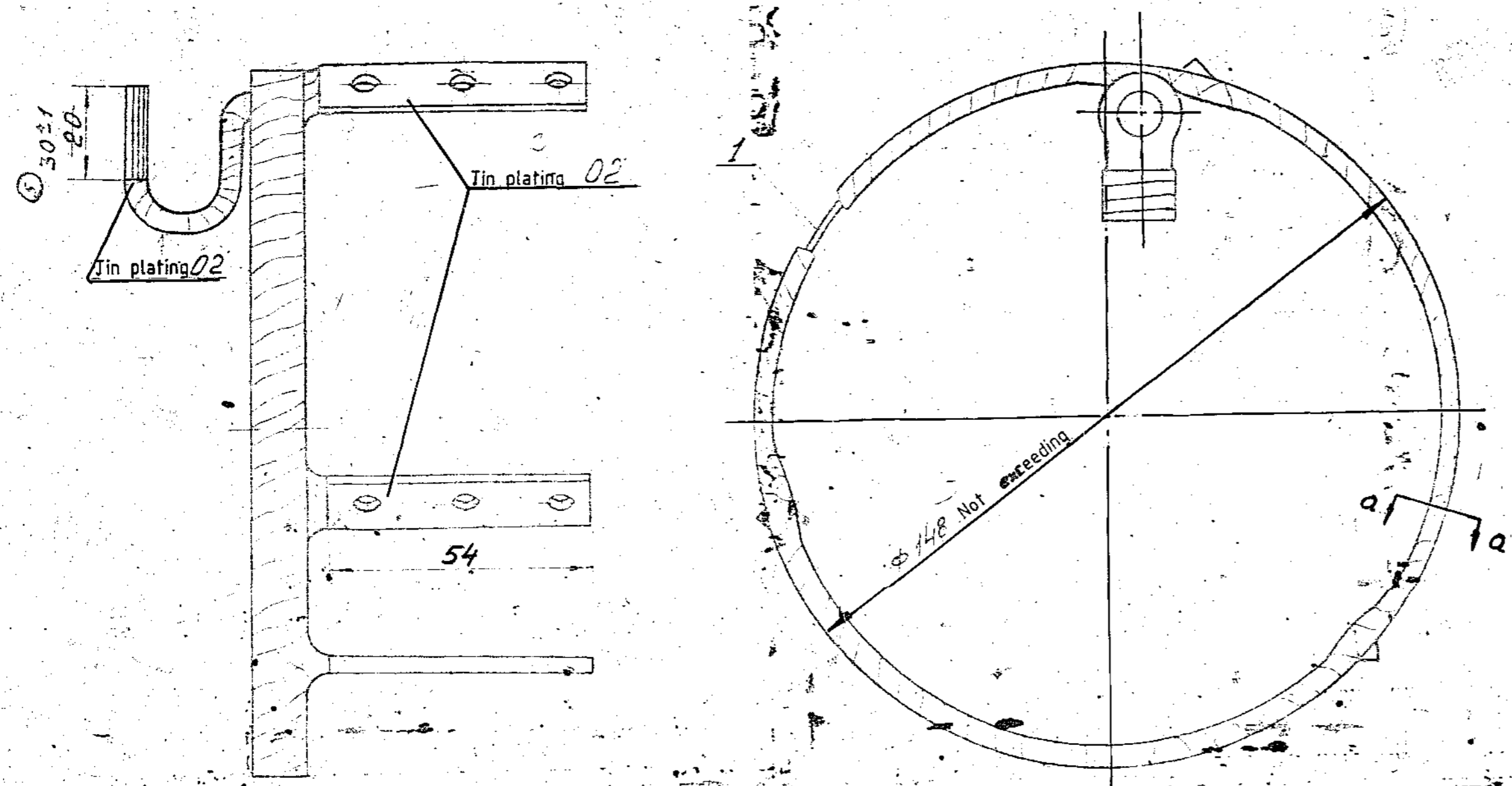
* COPPER M3M GOST 1173-77

PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

EST. MASS	0,033 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS IN LETTERS)
ISSUE	DATE	NATURE OF AMENDMENTS
DRN		SCALE: 2:1
CD		DIMENSIONS IN mm
APPD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED
DATE	9-9-87	ALL THREADS TO CONFORM TO
MATERIAL	* SEE ABOVE	USED ON - 805 003 H
CONTROLERATE OF INSPECTION (HEAVY VEHICLES) AVADI		TITLE: TIE
D S CAT NUMBER		DRAWING NUMBER 721-130 H

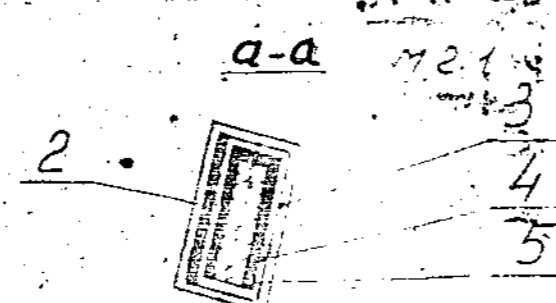
112

725.039H



1. Lay electric-grade card board, ref.no. 5, in a box-shape manner from the contact plate side after which insulate them with varnished silk, ref.NO.4, in one layer half-over lapping.
2. Lay the electric-grade card-board from inner side along the whole circumference of ring. Then insulate them with cotton band,ref.no.3 in one layer half over lapping.
3. Impregnate as per H8A 0028001 (Section 3 "A") and coat the insulated part of connection with enamel ϕ -952 TY 6-10. 1303-77, except the flexible bar and dry as per the section 3:5", item 3.20.
4. Insulated part of bar in the body unit may be coated with enamel ϕ -952 TY 6-10-1303-77.

S.No.	Designation	Description	Qty.	Remarks
		Tin 02 GOST 860-75		
5	725.039H-4	Electric grade-card-board. 3BT 02	1	"
		GOST 2824-74.		
4	725.039H-2	Varnished fabric АУМС-105-006	1	"
		GOST 2214-78.		
3	725.039H-3	Cotton batiste(lawn) tape	1	"
		5-20-61 GOST 4514-78.		
2	725.039H-5	Electric-grade card-board	1	"
		3BT 0.4 GOST 2824-75.		Without drawing
1	725.040H-	Interbrush connection	1	



PILOT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

EST. MASS	0.19 kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS: (LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MACHINE CORNER TO HAVE R OUTSIDE. IN HOUSE EQUIVALENT CHARACTERS ARE PERMISSIBLE.		
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL: USED ON - 100 256H
DRW	SCALE: 1:1	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVAD
CHKD	DIMENSIONS IN mm	TITLE: INTER BRUSH CONNECTION
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER
APPR	ALL THREADS TO CONFORM TO	DRAWING NUMBER
DATE 9-9-87		725 039 H

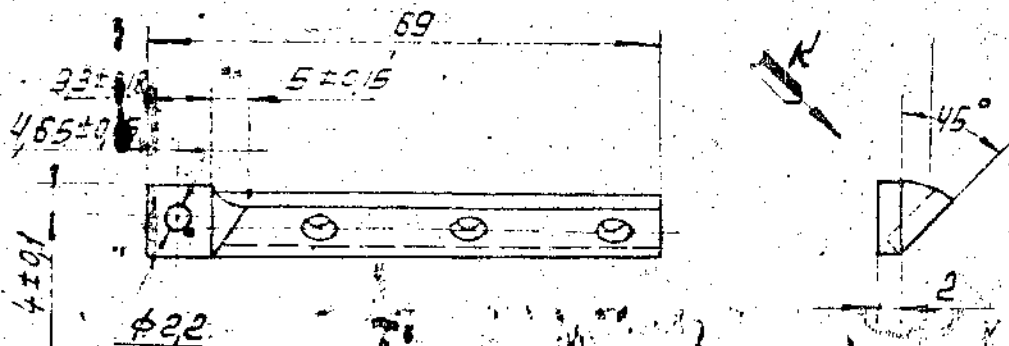
36

- 6 - 0057-82
- 5 - 0053-82
- 4 - 0020-81
- 3 - 0024-79
- 2 - 220-78
- 1 - 150-78

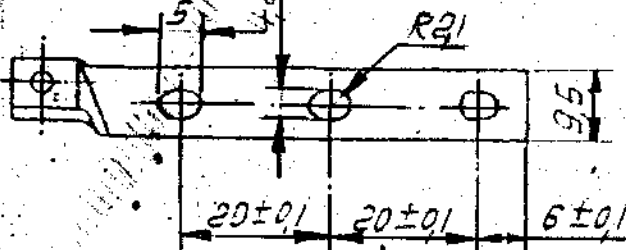
D83

751 115 H

1. Tolerances for free dimensions are as per accuracy class OST 1010.
2. Alternate material is sheet Д17РНММ 3 Gost 495-77.



View along arrow K



805-003 H

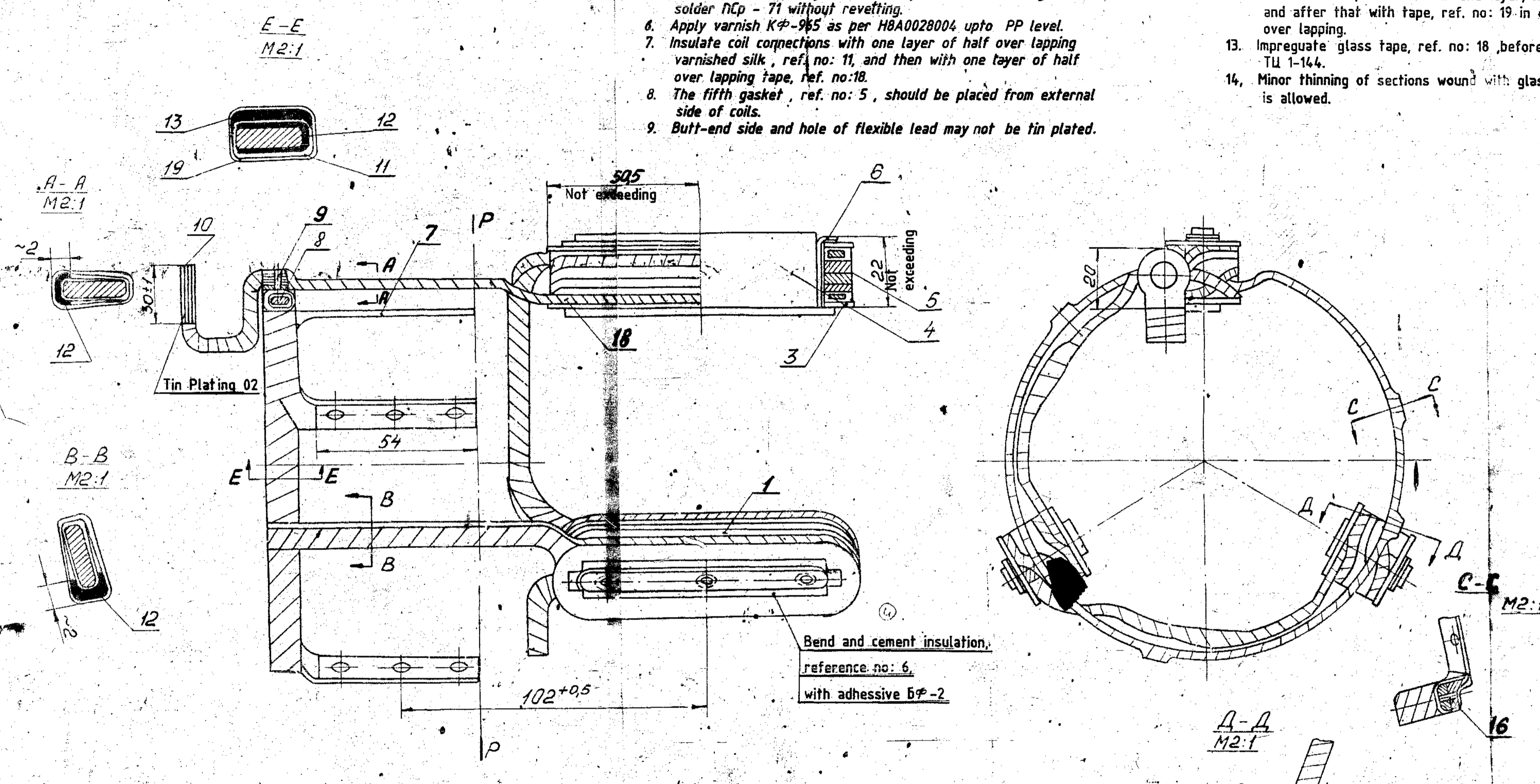
D-83

SHEET Д. ПРММ М1 ГОСТ 495-77

PROT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

		EST. MASS 0,013 Kg	TO BE STAMPED OR INDICATED THUS: 114
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNER TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	(LETTERS)
DRW		SCALE: - 1:1	USED ON: - 805 003 H
CHD		DIMENSIONS IN mm	
TCD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLER/DATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPO		ALL THREADS TO CONFORM TO	TITLE: CONTACT PLATE
DATE 9-9-87			D'S CAT NUMBER
			DRAWING NUMBER 751 115 H

H800300



1. Braze riveted places and connections with NCp-25 .
2. File the rivet heads after brazing.
3. Insulate pole with film card-board ref. no 6.
4. Insulate the whole surface of ring all round additionally with electric-grade card-board, ref. no: 13 before insulating it with tape, ref. no: 19.
5. Part, ref. no: 7 may be brazed by resistance brazing with solder NCp-71 without revetting.
6. Apply varnish $K\phi-9\phi 5$ as per H8A0028004 upto PP level.
7. Insulate coil connections with one layer of half over lapping varnished silk, ref. no: 11, and then with one layer of half over lapping tape, ref. no: 18.
8. The fifth gasket, ref. no: 5, should be placed from external side of coils.
9. Butt-end side and hole of flexible lead may not be tin plated.

10. Coat contact plates, ref. no: 7, and ring, ref. no: 8, 0.6 microns thick.
11. Insulate coils with all windings together in one layer of half-over lapping glass tape, ref. no: 18, (Insulation is not shown in the drawings).
12. Insulate coil ring and leads upto intercoil connections with varnished silk, ref. no: 11 in one layer, half over lapping and after that with tape, ref. no: 19 in one layer, half over lapping.
13. Impreguate glass tape, ref. no: 18, before insulation as per TU 1-144.
14. Minor thinning of sections wound with glass tape, ref. no: 18, is allowed.

S.NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
		ADHESIVE $B\phi-2$		GOST 12172-74
		SOLDER NCp-71		GOST 19738-74
		SOLDER NCp-25		GOST 19738-74
18.		GLASS TAPE $\text{J}\Omega\text{C-0.1}$	3	
16.		RIVET 3525A-2-6	3	STANDARD
15.		RIVET 3525A-2-8	1	STANDARD
14.	805 . 003 H-6	CAMBRIC-COTTON TAPE	6	GOST 4514-71
		0.8 x 20		
13.	805 . 003 H-9	ELECTIC-GRADE CARD-BOA-		
		RD "3B" 0.5 GOST 2824-75	1	
12.	805 . 003 H-8	ELECTRIC-GRADE CARD-BOA-		
		RD "3B1" 0.1 GOST 2824-75	3	
11.	805 . 003 H-5	VARNISHED FABRIC $\text{J}\Omega\text{WMC}$		
		-105-0.06 GOST 2214-78.	6	
10.	721 . 130 H	TIE	1	
9.	3525A - 2 - 10	RIVET	1	STANDARD
8.	531 . 010 H	CONTACT RING	1	
7.	751 . 115 H	Contact plate	3	
6.	805 . 003 H-3	$\text{H}\Omega\text{K 0.17 TY 16-503.138-74}$	3	
5.	893 . 249 H	Insulation gasket	15	
4.	563 . 021 H	Inter pole	3	
3.	893 . 250 H	Insulation gasket	6	
1.	805 . 004 H	Inter pole coil	1	

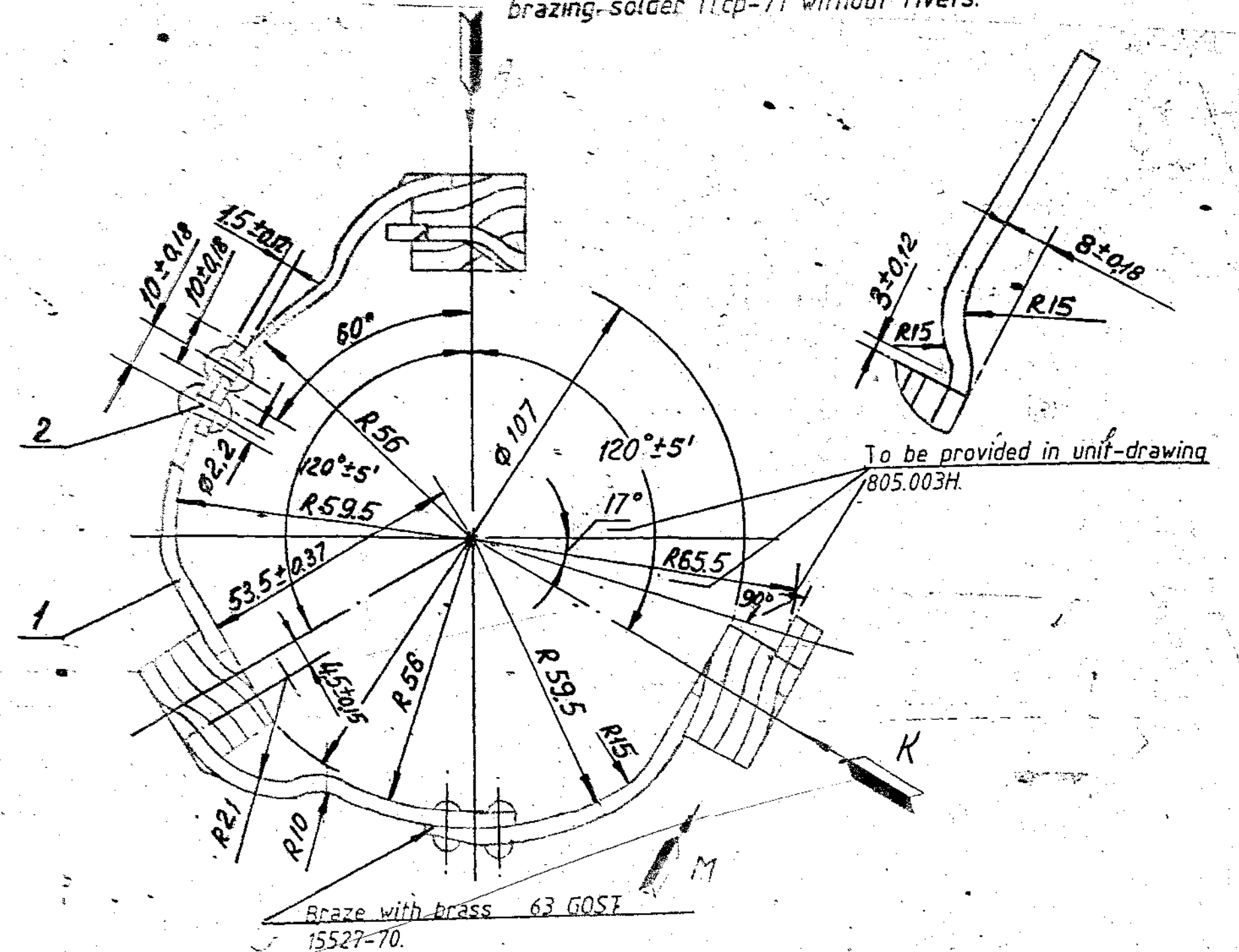
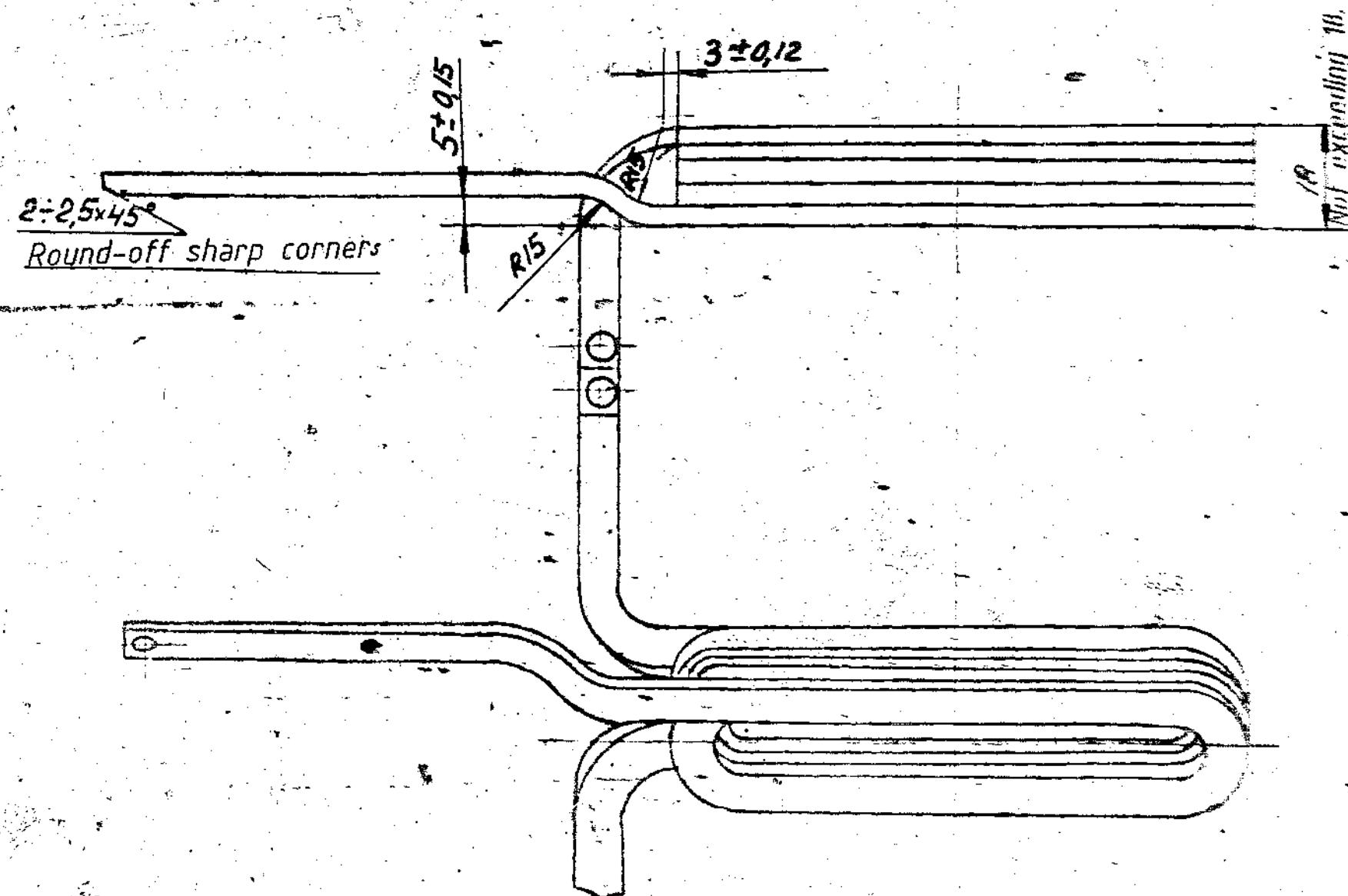
PROT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

EST. MASS	1.4 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS IN LETTERS
ISSUE DATE		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNER TO HAVE R OUTSIDE R UNSIZE EQUIVALENT CHAMFERS ARE PERMISSIBLE
ORAN	SCALE: 1:1	MATERIAL: USED ON: 100 256 H
CDR	DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVAD
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: INTERPOLE COILS
APPO	ALL THREADS TO CONFORM TO	D S. CAT NUMBER
DATE 9-5-87		DRAWING NUMBER 805-003 H

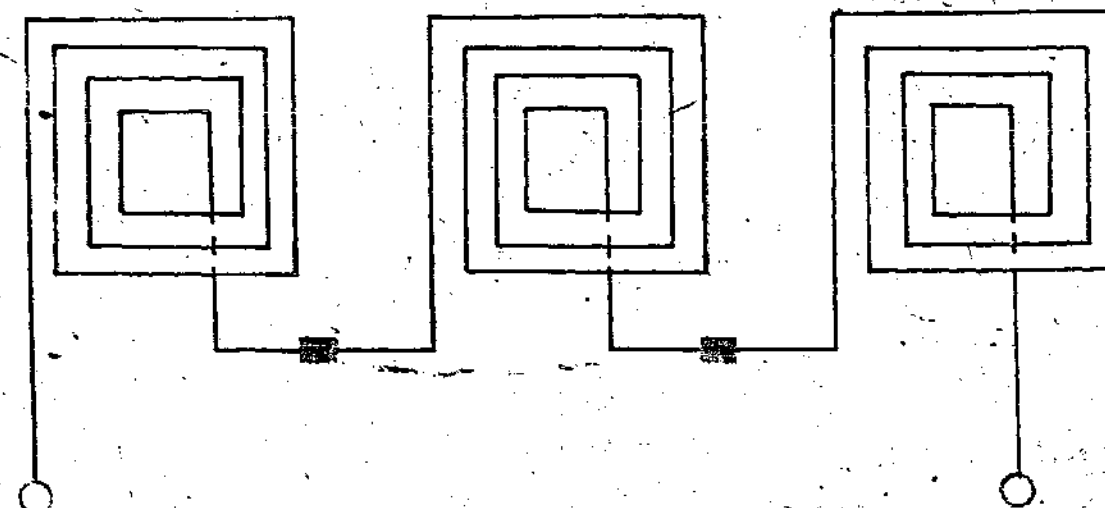
40

X141
25

1. Tolerances for free dimensions are to be as per accuracy class 7, OST 1010
2. Carry-out winding of all three coils with one continuous bus without connecting joints. (Coils may be made separately as per the drawing).
3. Bus joint may be brazed by resistance brazing using brazing-solder Пср-71 without rivets.

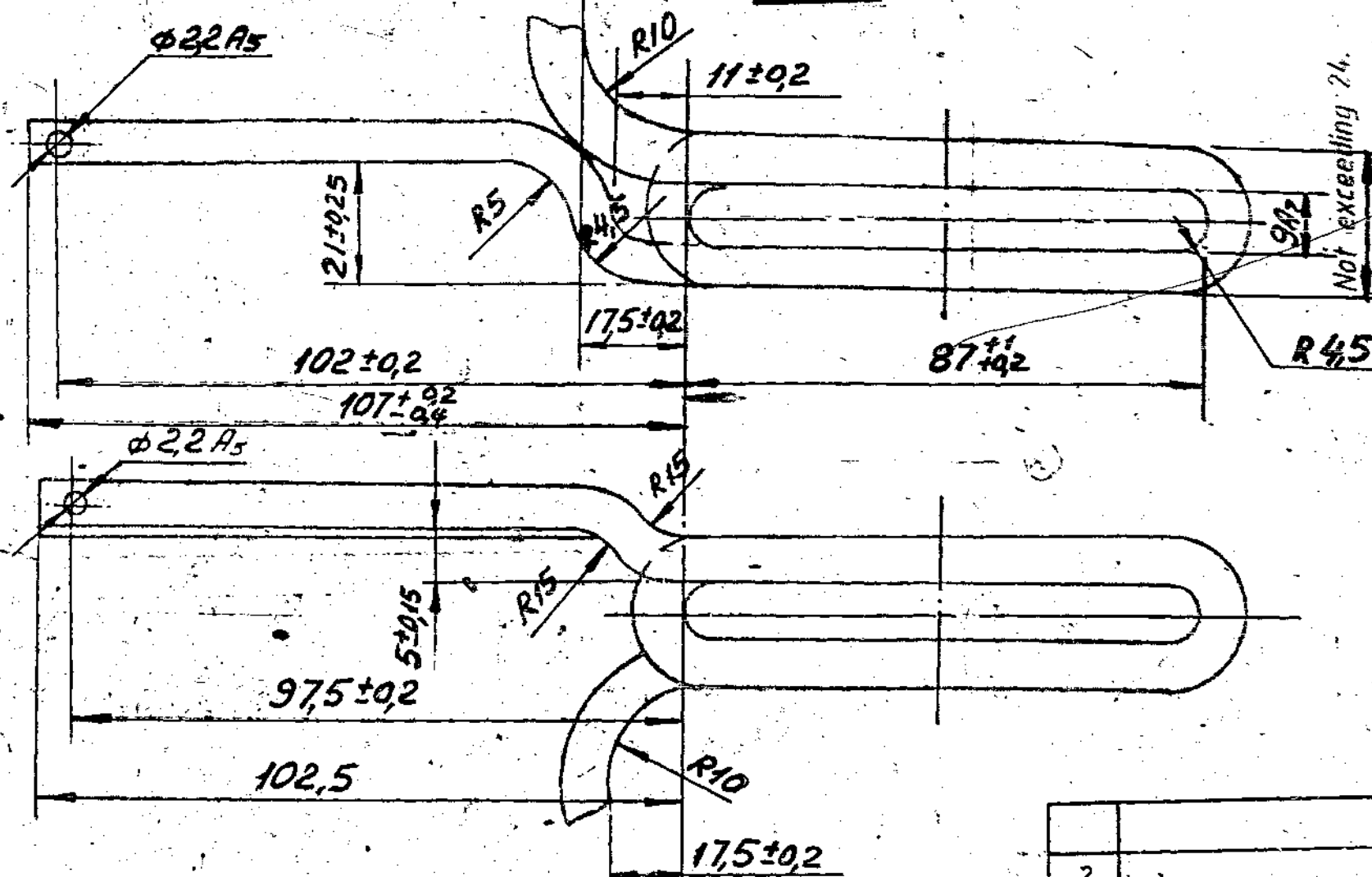


Connection diagram.



X/141
26
41

VIEW-A



2		Brazing solder ncp-71	STANDARD
		GOST 19738-74.	4
1	805.0044-1	Rivet 3525A-2-8.	WITHOUT DRG
S.no.	Designation	Description	By REMARKS

PROT SAMPLE SHOULD BE APPROVED BY A.I.S.P BEFORE BULK PRODUCTION

ISSUE DATE	NATURE OF AMENDMENTS	1ST. MASS	TO BE STAMPED ON MARKED WHERE INDICATED THIS →
URN	SCALE: 1:1	0,78 Kg	(LETTERS)
END.	DIMENSIONS REVISION		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED LOUVERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMBERS ARE PERMISSIBLE
TCO	TOLERANCE ON DIMS UNLESS OTHERWISE STATED		MATERIAL: — USED ON: 805 003 H
APPD.	ALL THREADS CONFORM TO		CONT. TOLERANCE OF INSPEC. ON HEAVY VEHICLES (AVADI)
DATE 9-9-87			INTERPOLES COILS
			GOST NUMBER DRAWING NUMBER 805-004 H