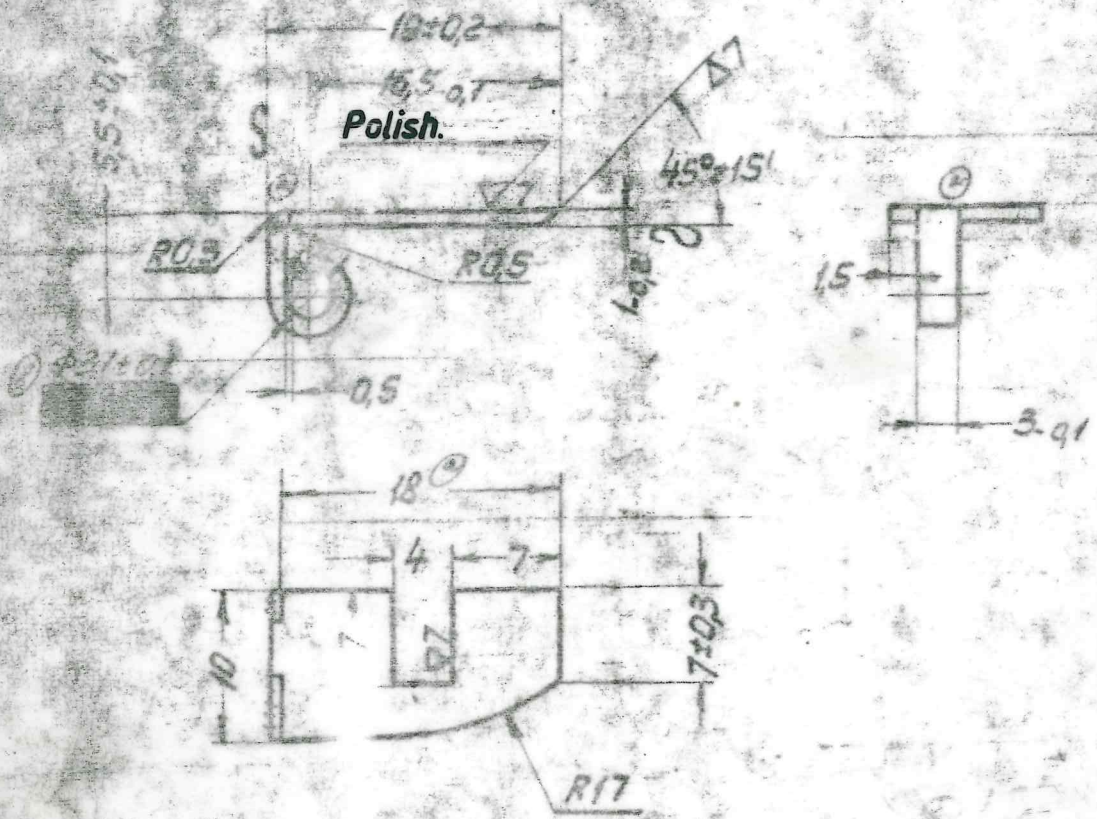


127-7

105

Unless otherwise specified.



1. Material: Band 20x13H4Г9-HT-1,0 GOST 4986-79.
2. Tolerance on free dimensions are as per 722AT.

Порядок

127-7

SN/SHY	DOC NO	SIGN	DATE
DRAWN	PR. BABU		14.5.86
EDT, CHKO	D.K. JAIN	<i>[Signature]</i>	18.5.87
F/M, DC	S. HRAO	<i>[Signature]</i>	4/2
DIV. OFFR	D.R. MOU	<i>[Signature]</i>	4/11
	NAME	SIGN	DATE

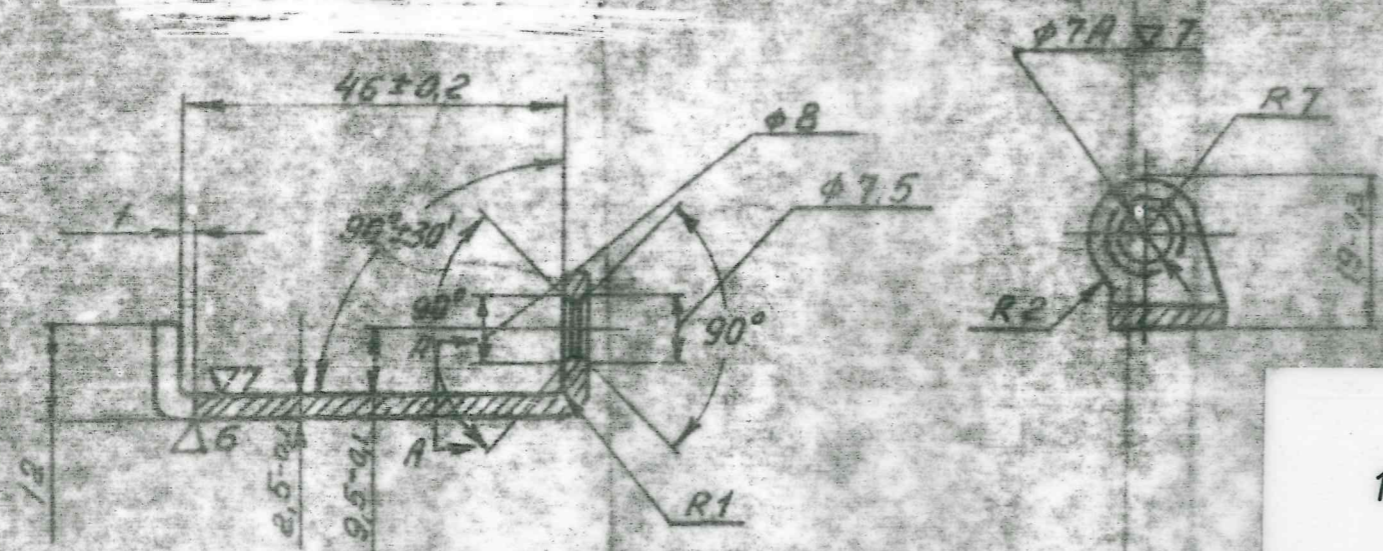
LATCH

SHEET	WEIGHT	SCALE
A	1.4g	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

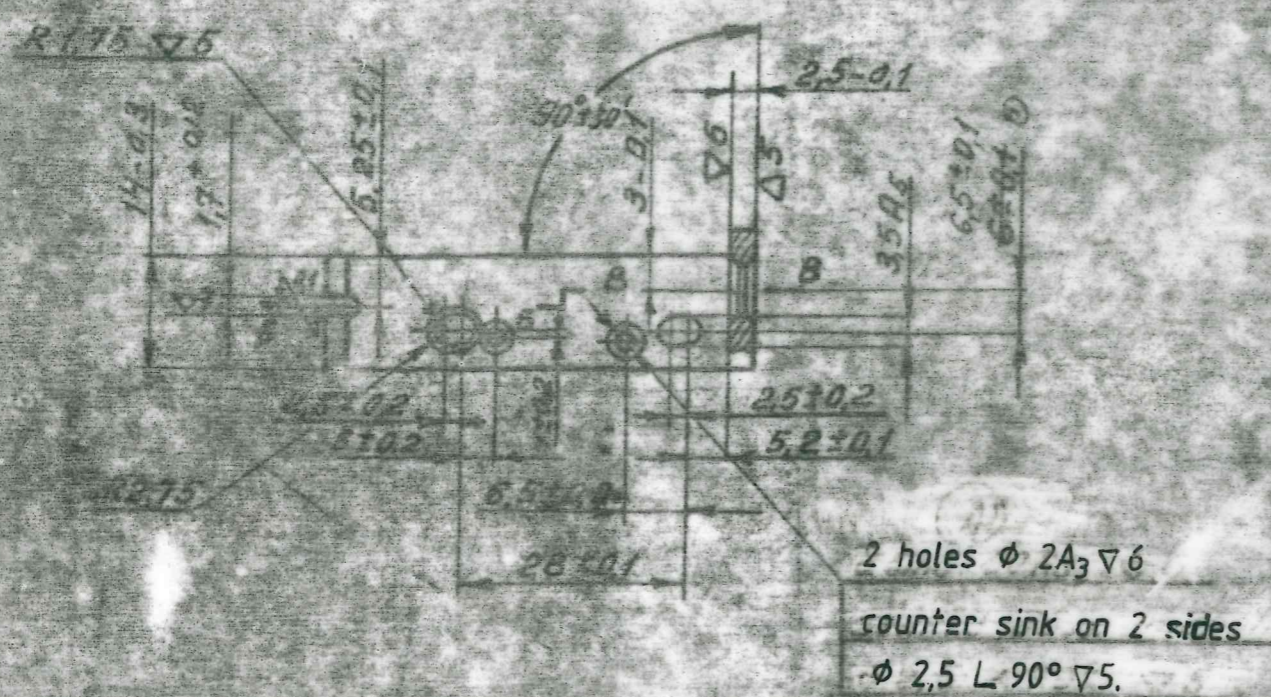
Unless otherwise specified

Section along A-A

Section along BB-BB



1) Tolerances on free dimensions are as per 722AT.



Scale 2:1

Coating / Chemical passivation.

SNOSH	DOC NO	SIGN	DATE
DRAWN	Y.R.Ganesh	<i>[Signature]</i>	17.5.84
EDT,CHKD	D.K. JAIN	<i>[Signature]</i>	18.5.84
F/M,DC	S.H.RAO	<i>[Signature]</i>	3/6
DIV,OFFP	D.A. [Signature]	<i>[Signature]</i>	4/6
	NAME	SIGN	DATE

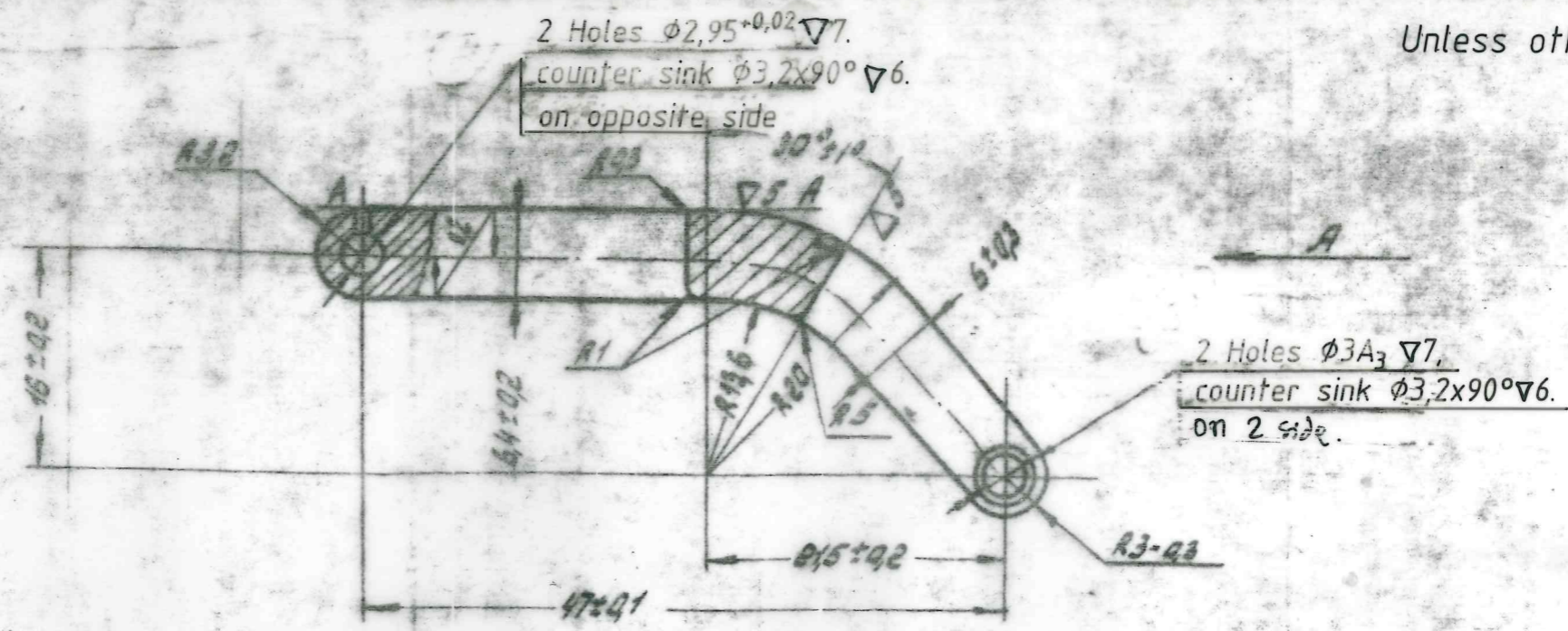
BRACKET

SHEET 01 P X П 3,0 Л 63
GOST 931-78.

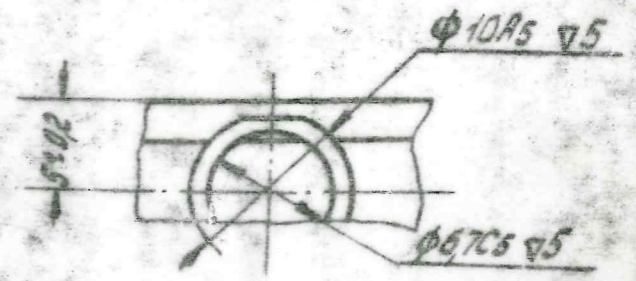
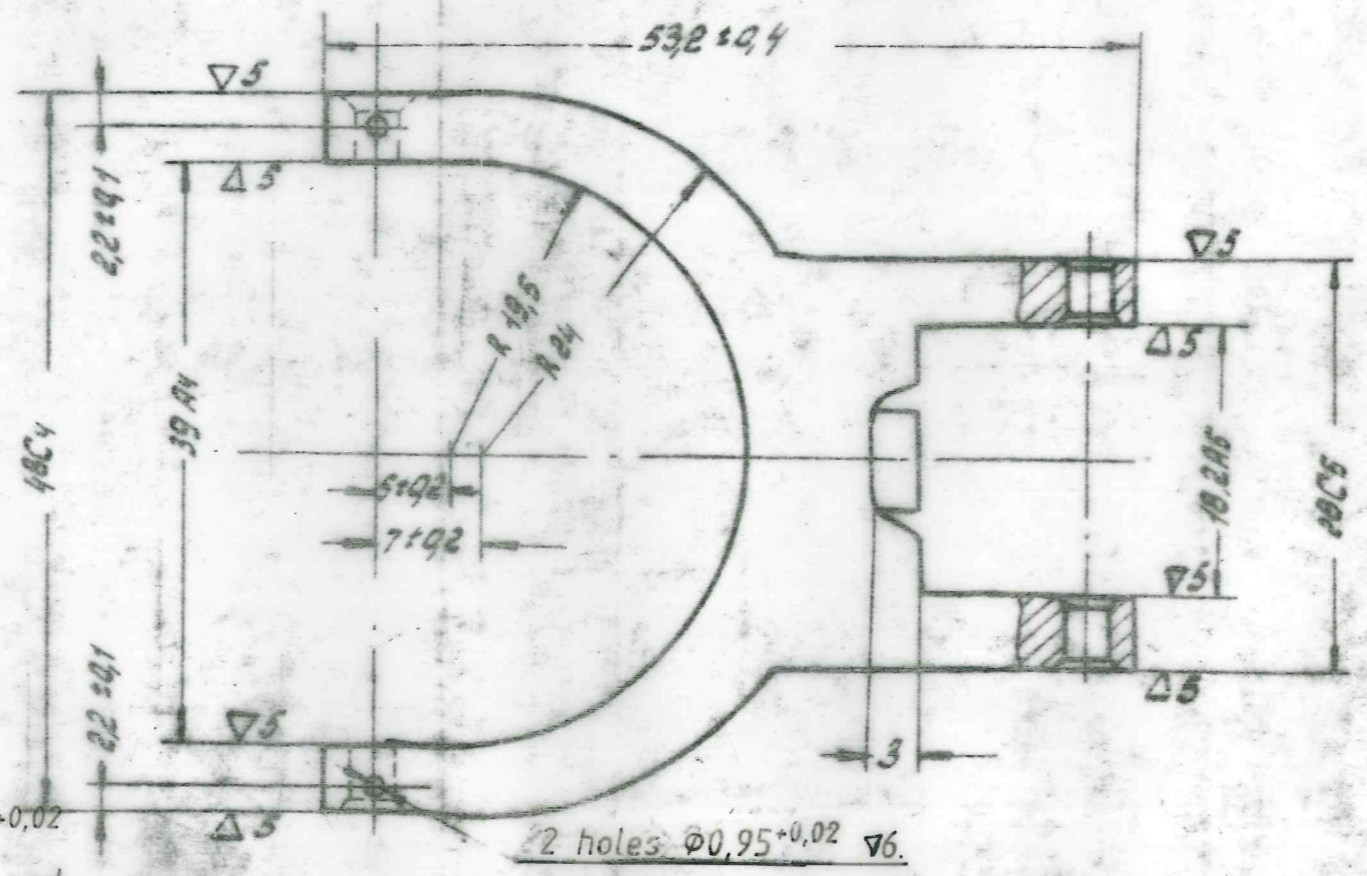
127-11		
SHEET	WEIGHT	SCALE
A		1:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

127-12

Unless otherwise specified 107



VIEW A



1) Part is made by casting, class of accuracy **IT4** as per OST 1,41154-72.

2) Eccentricity of two holes $\phi 2,95^{+0,02}$ should not exceed 0,03 and two holes $\phi 3A_3$ should not exceed 0,05.

3) Non-parallelity of axes of holes $\phi 2,95^{+0,02}$ and $\phi 3A_3$ with respect to each other and also with respect to plane AA- should not exceed 0,1.

4) Non symmetrical of symmetrically arranged elements with respect to axis of symmetric should not exceed 0,1.

5) Tolerances on free dimensions are as per 722AT.

6) Pattern drafts should not exceed 30' towards increased casting body.

7) Casting radii should not exceed R1,5 mm.

8) Perform heat treatment as follows:- Heating to 400 to 450°C, treatment time is 1 to 1,5 hrs, cooling in furnace to 200°C with subsequent cooling in air.

NO	SHT	DOC NO	SIGN	DATE
DRAWN		Y.R.Ganesh		19.5.84
EDT,CHKD		D.K.JAIN		24.5.84
F/M,DC		S.H.RAO		3/6
DIV.OFFR		D.A. RAU		4/6
		NAME	SIGN	DATE

CAGE FORK

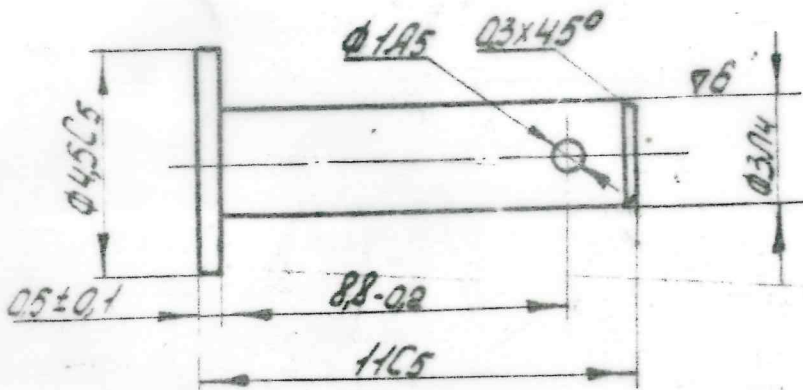
Copper zinc alloy $\sigma C59-102$
FOCT 17711-80.

127-12

SHEET	WEIGHT	SCALE
1	3562	2:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

127-13

∇5 Unless otherwise specified.



Coating: Cadmium 9 micron, chromatised

127-13

SNOSHT	DOC NO	SIGN	DATE
DRAWN	P.R.BABU		14.5.84.
EDT,CHKD	B. Sarkhel	B.Khil	17.5.84
F/M,DC	S.HRAO	SR	3/8
DIV.OFFR	D.A. 2004	18/20	6/11

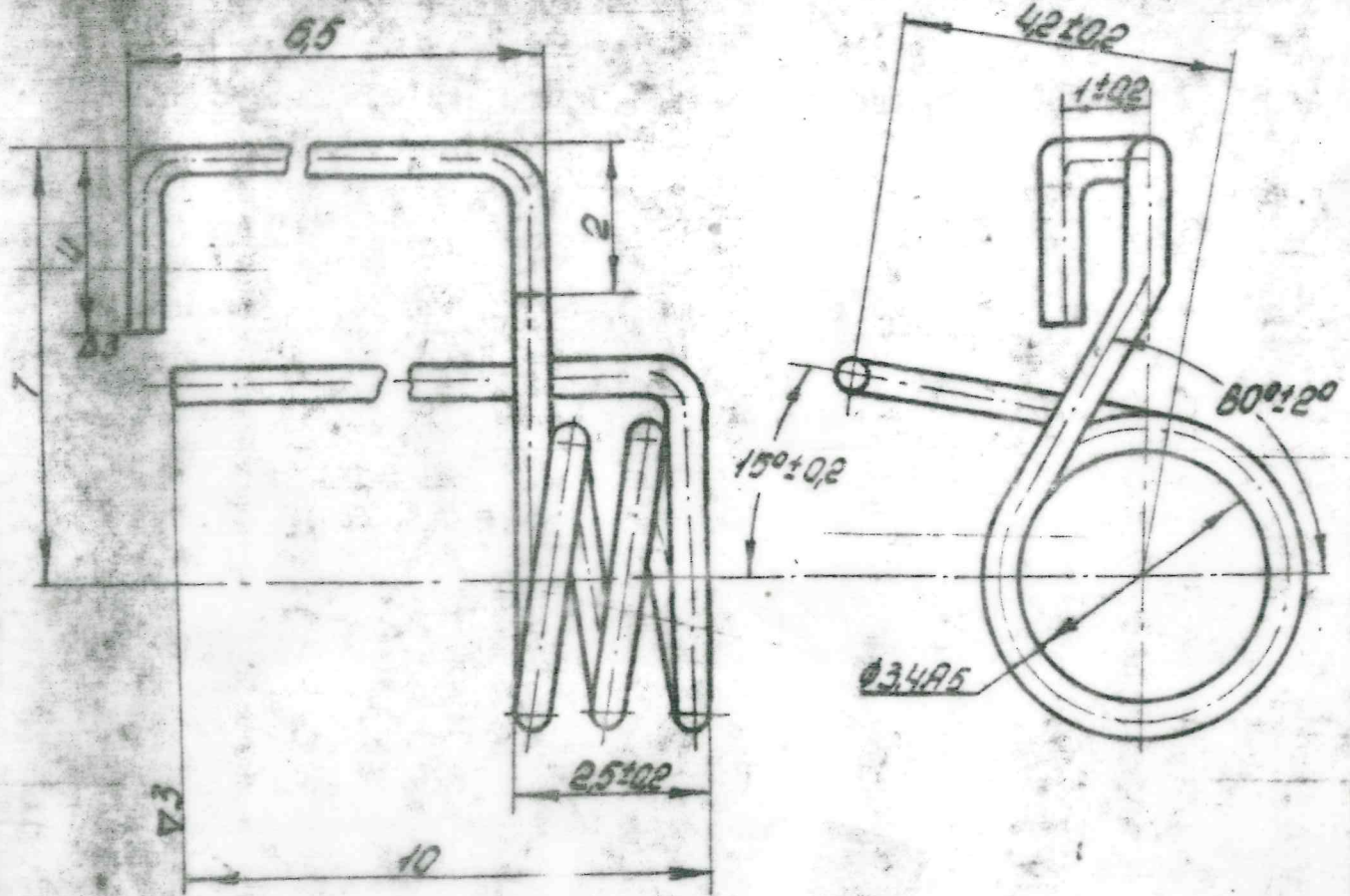
PIN

STEEL 20

SHEET	WEIGHT	SCALE
1	0.58 gm	5:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT		

127-15

Unless otherwise stated. 109



- 1). Bending radius should not exceed 0.8mm.
- 2). Tolerances on free dimensions are as per A₇, B₇.
- 3). Tempering as per instructions μ A.0442.012.

Coating: Cadmium 6 microns, chromated.

127-15

SNOSHT	DOC NO	SIGN	DATE
DRAWN	BHUSHAN		19.5.84
EDT,CHKD	D.K.JAIN	<i>[Signature]</i>	24.5.84
F/M,DC	S.H.RAO	<i>[Signature]</i>	3/6
DIV,OFFR	D.A....	<i>[Signature]</i>	4/6
	NAME	SIGN	DATE

SPRING.

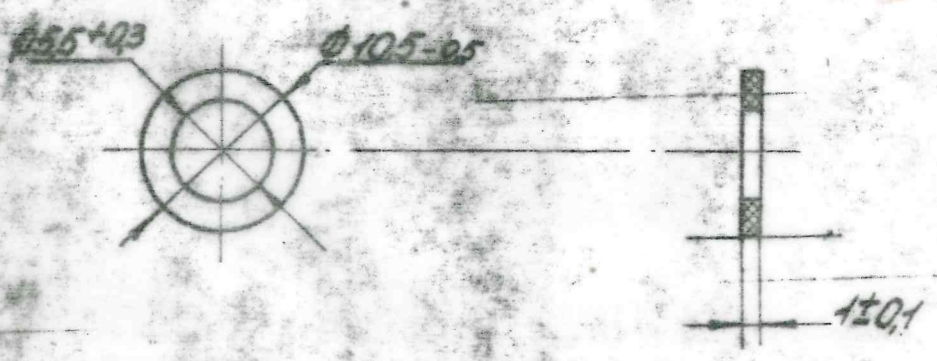
Wire 0.5mm GOST9389-75.

SHEET	WEIGHT	SCALE
	0.12	10:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

127-17

∞ All over

110



COATING

SLNO	SHEET	DOCNO	SIGN	DATE
DRAWN BY		P.R.BABU		16.5.84
EDITED AND CHECKED BY		D.K.JAIN	<i>[Signature]</i>	17.5.84
FOREMAN OF DC		S.H.RAO	<i>[Signature]</i>	3/6
DIVISIONAL OFFICER		D.A.SAA	<i>[Signature]</i>	4/6
	NAME	SIGN	DATE	

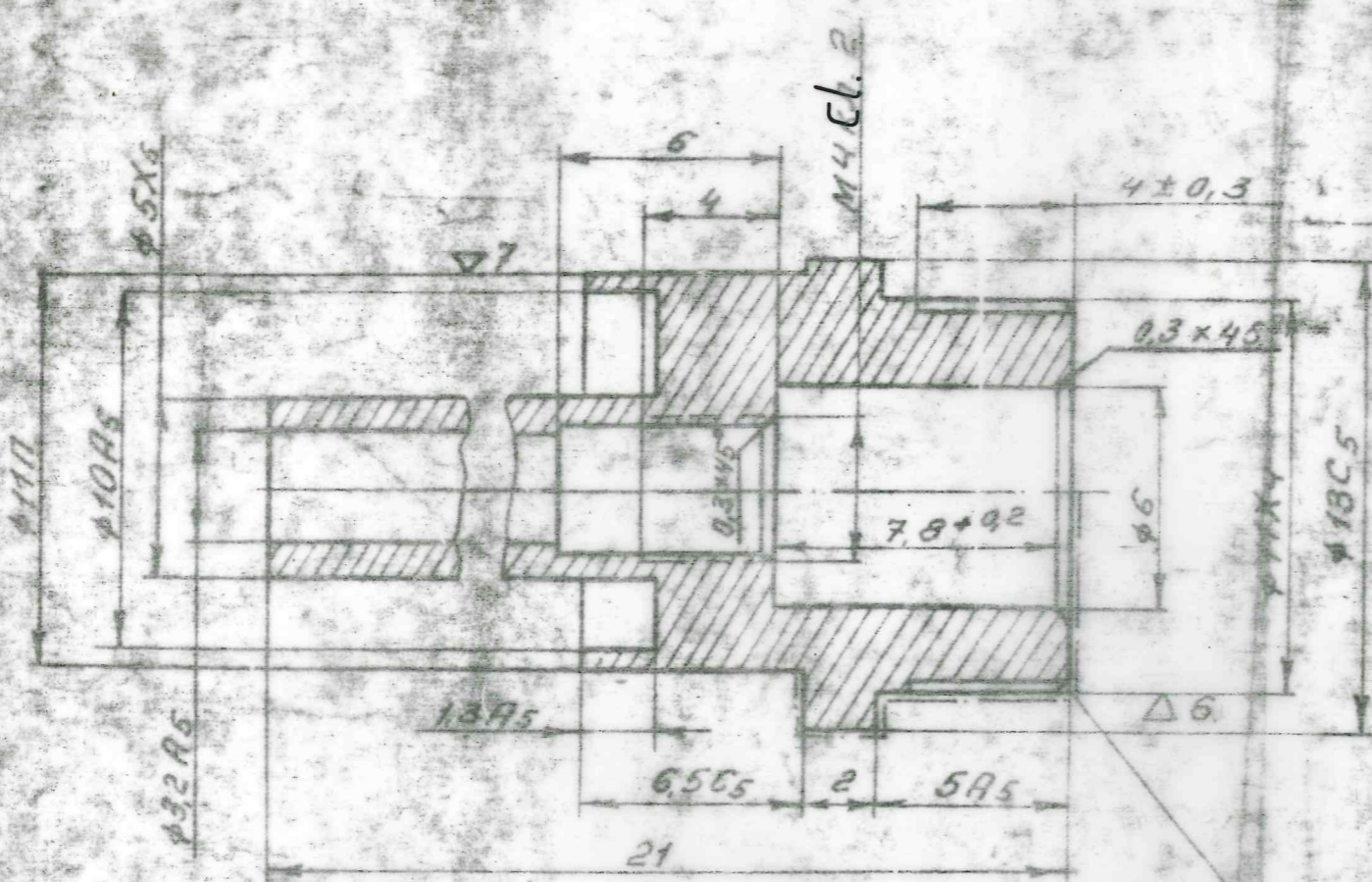
PACKING

Rubber H.O.68-1"
TY 38.005.838-70.

SHEETS	WEIGHT	SCALE
127-17	008	2.1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

▽5. Unless otherwise specified

- 1) Blunt sharp edges by R 0,3 or chamfer 0,3x45.
- 2) Free dimensions are as per standard 722AT.
- 3) Displacement of axis of $\phi 11 \Pi$ and $\phi 10 A_5$ with respect to axis $\phi 3,2 A_5$ should be 0,5-0,1.
- 4) Make 4 grooves of $L = 4$ mm, depth 0,3 to 0,4 mm and width 0,3 mm on cylindrical surface of $\phi 11 \times 4$ at $90 \pm 2^\circ$. Position of groove with respect to eccentricity is arbitrary.
- 5) Paint grooves with enamel THn ϕ -851, white.
- 6) It is allowed to use enamel $\exists n$ -140, black, instead of $\exists M$ YP-175.



Coat with enamel $\exists M$ -Yp-175
black colour

D130-171

127-20

SN	SHT	DOC NO	SIGN	DATE
DRAWN		Y.R.Ganesh		17.5.84
EDT,CHKD		D.K.JAIN		18.5.84
F/M,DC		S.HRAO		4/6
DIV.OFFR				4/6
		NAME	SIGN	DATE

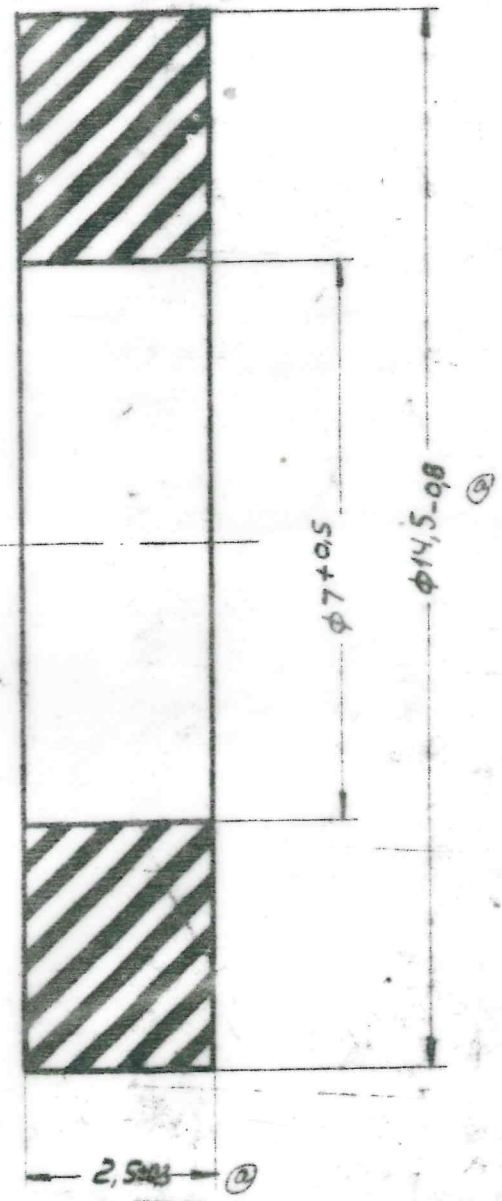
BUSHING

ROD NC 59 - T.Kp.H.M
ROCT 2060-73

SHEET	WEIGHT	SCALE
A	8.6g	5:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

127-22

2



SLNO	SHEET	DOCNO	SIGN	DATE
DRAWN BY		BHUSHAN		11.5.84
EDITED AND CHECKED BY		B. B. Sarvesh	Reddy	14.5.84
FOREMAN OF DC		S.H. RAO	Er	3/6
DIVISIONAL OFFICER		<i>[Signature]</i>		4/6
		NAME	SIGN	DATE

GASKET.

Rubbe H0.68.1 Ty38005-1166-73.

127-22

SHEETS	WEIGHT	SCALE
On A	0.36	10:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		