



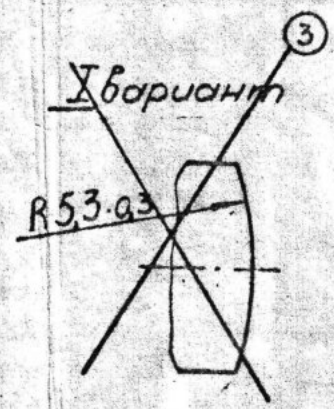


БЛВ.388.004

9-04092

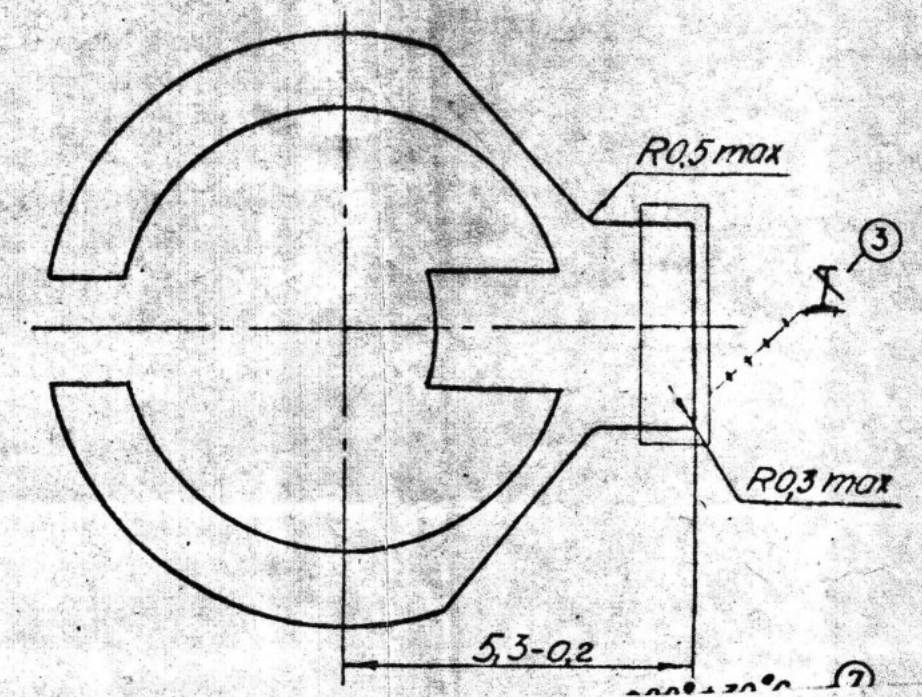
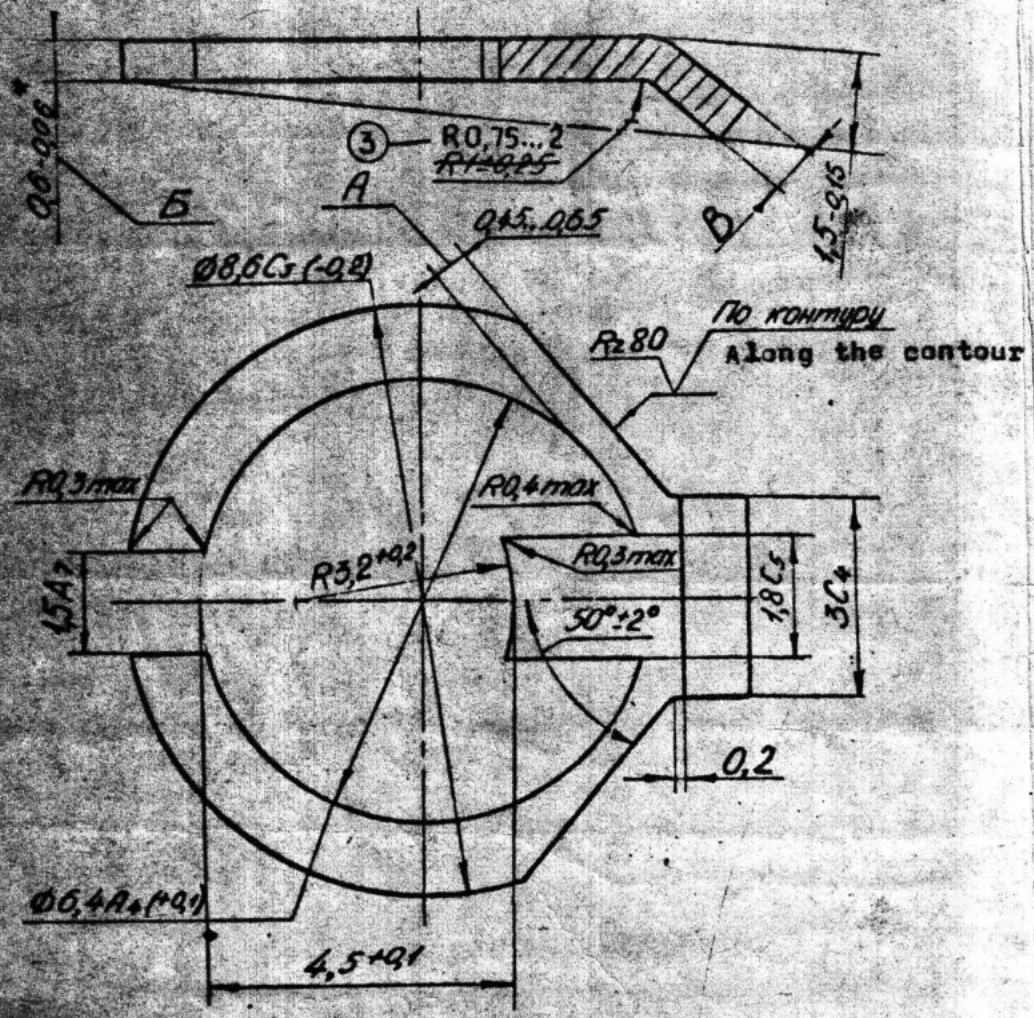
2040/42

ЕСКД



NOTE II: INDIGENOUS MATL.:  
 "BS EN 1652: 1998 DESIGN  
 CUZn37 MATERIAL CONDM.  
 R550 WITH UTS 55-65  
 Kg/mm<sup>2</sup> & ELONGATION=4%  
 MIN."

Развертка  
 Development



I. Annual clip at a temperature of 290° ± 30°C for two hours in case of vacuum case.

Spread of temperature ensured the fulfillment of requirement ref. No. 6 for one batch of parts not to exceed 30%.

Обозначение по единому классификатору	APPROVED
	<i>[Signature]</i> FOR CI(A)
9-04092	AHSP: - CI(A) KIRKEE
	9-K-715

БЛВ.388.004	Sheet No	No of Sheets
	1	2

SNC/SHT/DOC NO	SIGN	DATE
DRAWN		
EDT/CHKD		
F/M, DC		
DIV/OFFR		
NAME	SIGN	DATE

Clip	SHEET WEIGHT SCALE	
	X/A	0,11g 10x1
Brass Band 0.6 НДЛ63 ГОСТ 2208-75	TOTAL SHEETS	
	ORDNANCE FACTORY PROJECT HYDERABAD	

08/11/00	37271-A	NOTE II FOR ALTERNATIVE MATL ADDED	
24-9-87	34241-A	DRG PROV. SEALED	<i>[Signature]</i>
DATE	AUTHORITY	REVISION	SIG AHSP SIG DO

22174  
 2040/42  
 БЛВ.388.004  
 9-04092  
 9-K-715  
 1/2  
 0,11g 10x1  
 0,6 НДЛ63  
 ГОСТ 2208-75  
 HYDERABAD

ДПРНО 0.6 НДЛ 63

10. Clamps can be checked, while accepting the parts, as a part of assembly unit БШ 6.042.512 with using part 6W 9.116.044 without preliminary impact on impact tester "Masset".

- 2. Alternate material is bar ~~ДПРНО 0.6~~ ГОСТ 931-78.
- 3. \*Dimensions for reference, Other dimensions ensured by tools.
- 4. Dimension A deviation not to exceed 0.1 MM in one batch of parts.
- 5. Coating - chemical passivation/varnish Ш-4(1) OST B 84-811-73.
- 6. Clip, which is preliminarily tested on impact tester 'Masset' by impacts from the 23rd tooth as a part of assembled unit БШ 6.042.512 with cap downwards in fixture, imitating the position of assembly unit in item, should hold the slider БШ 8.264.006 at 30000 r/min. and should release it at 55000 r/min. The accuracy of measuring rotational frequency should be  $\pm 600$  r/min.

Test the clamps in rotating conditions as a part of assembly unit БШ 6.042.512 with by using part 6W 9.116.044.

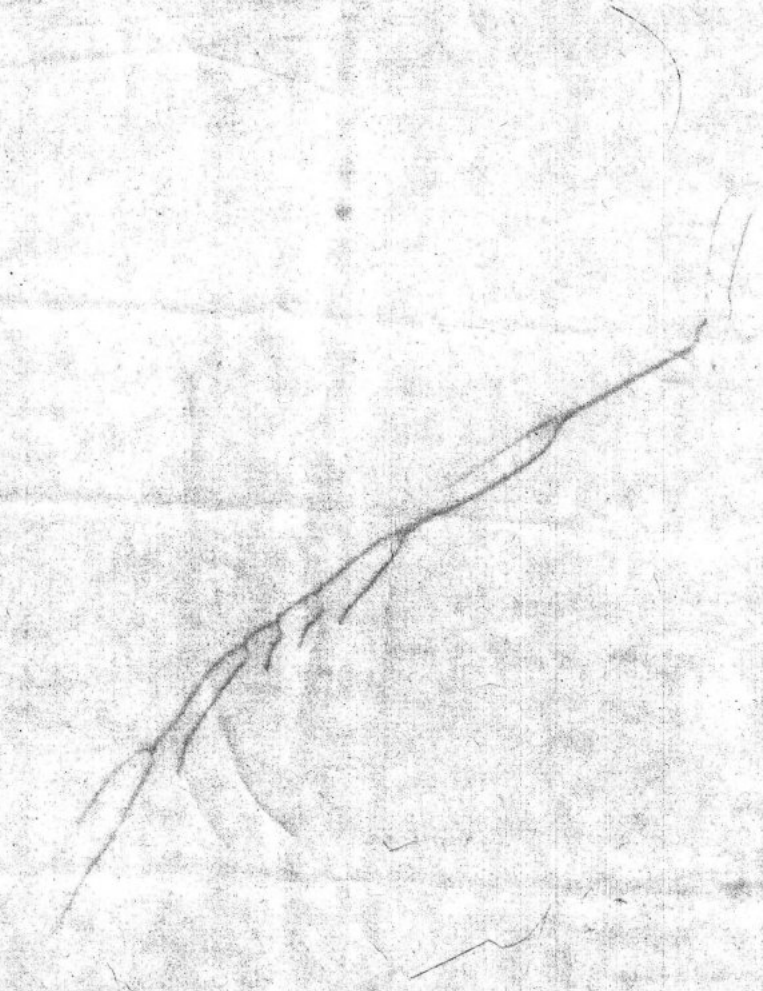
Cap БШ 8.635.085 can be replaced.

Spot checking. Each batch of parts subjected to checking.

7. Presence of burrs on the edges of parts is allowed provided the dimension Б should not exceed 0,67 MM and dimension B should not exceed 0,9 MM.

8. The volume of batch and volume of spot checking according to Ref. No. 6 is set by manufacture and is agreed with customer representative at manufacturing plant.

9. Other requirements are as per OST B 84-264-81.



9- 04092

9 - K 715

6W 8.388.004		
	No. of Sheet No. 2	No of Shts 2
Clip		

APPROVED.  
*[Signature]*  
 FOR CI(A).  
 AHSP:- CI(A) KIRKEE.

17-4-89	DC 34584-A	INNOTE NO.6, 55000r/min WAS 35000 r/min		
24.9.87	DCI 34241-A	DRG. PROV. SEALED		
DATE	AUTHORITY	REVISION		

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D-2040/39

F o r m a t	Z o n e	R e f e r e n c e	Designation	Description	Q u a n t i t y	R e m a r k s
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Documentation

12			GW 6.042.512 C6	Assembly drawing		9-04092
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Parts

11	12	1	GW 8.264.006	Slider	1	9-04092
12		2	GW 8.388.004	Clip	1	9-04092
12		3	GW 8.635.085	Cap	1	9-04092
12		4	GW 9.116.042	Safety plug	1	9-04092

24-9-87	DCI.34241-A	DRG. PROV. SEALED.		<i>[Signature]</i>	<i>[Signature]</i>
DATE	AUTHORITY	REVISION		SIG. AHSP.	SIG. D.O.
APPROVED.			9-04092	9-K-715	
<i>[Signature]</i> FOR CI(A)			GW 6.042.512		
AHSP :- CI(A) KIRKEE.			Safety lock ... List of documents		



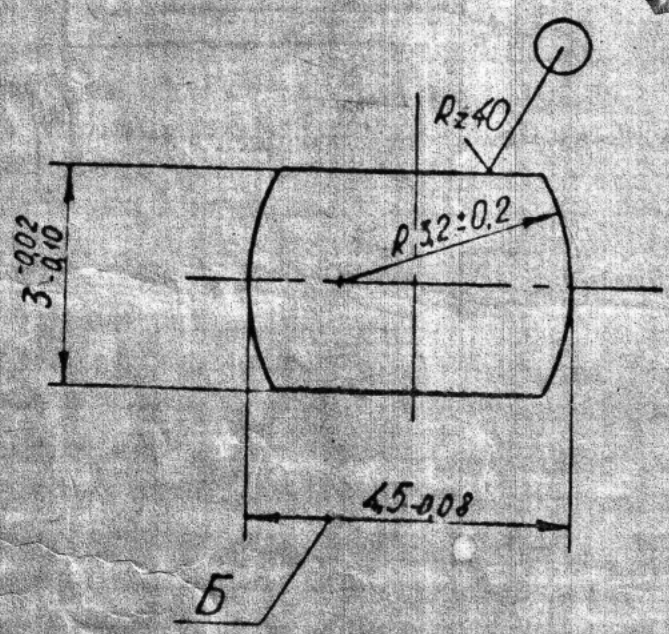
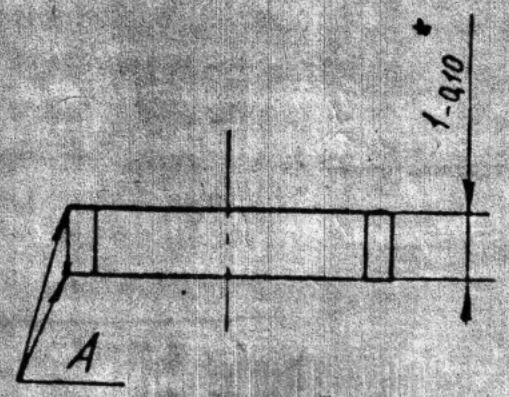
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ЭШ 8.264.006

9-04092

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 2040



1. Alternate materials :
  - a) Hard Band extra hard of any grade GOST 2208-75;
  - b) Hard Band extra hard of any grade GOST 931-78.
2. \*Dimensions for reference, other dimensions ensured by tools.
3. Coating : chemical passivation/varnish -  $\Pi$  BT 2(1) OST B 84-1010-74 and coating - chemical passivation/varnish AW-4(1) OST B 84-811-73 is also allowed.
4. Other requirements are as per OST B 84-264-81.
5. INDIGENOUS MATL: "BS EN 1652:1998 DESIGN, CUZn39PB2 MATERIAL CONDITION R420 WITH UTS = 42-50 kgf/mm<sup>2</sup> & Elong = 18% MIN."

APPROVED.  
 FOR CI(A)  
 AHSP:-CI(A)KIRKEE

08.11.10	37271-A	NOTE 5 FOR INDIGENOUS MATL ADDED		
24.9.87	34241-A	DRG PROV. SEALED		
DATE	AUTHORITY	REVISION	SIG AHSP	SIG DO.

Designation	Edge A	Requirements
БWB.264.006	Sharp	Requirement "Sharp" is allowed to produce only to part of edge A, having dimension <b>Б</b>
-01	—	—

9-04092 9-K-715

Б 8.264.006

ES-DOO... DATE	
NAME	
CHKD	
DATE	
U.V.OFFR	
NAME	SGN
DATE	

Slider

SCALE  
 A 0.1g 10:1  
 BRASS STRIP : 08ДП С59-1  
 1mm  
 GOST 931-78  
 ORDNANCE FACTORY  
 PROJECT  
 HYDERABAD  
 WDMST 12

Точка - 0.01 мм. 08.11.10. 08.06.10.  
 23850 2494 21694