

1. All bolts and nuts should be tightened upto the stop and locked where ever necessary.
2. Threaded joints should be smeared with thin layer of lubricant Lythol-24 GOST 21150-75 or lubricant MC-70 GOST 9762-76.

FOR EXPLANATORY NOTES OF LYTHOL-24 REFER TO DRG NO 675-71-c86c5

Shree
(R. VEERARAGHAVAN)
SSO II

REF. NO.	DESIGNATION	DESCRIPTION	QTY	REMARKS
20	672-31-71	Tab washer	8	
19				
18				
17	Nut M6.6.019 GOST 5927-70		8	
16				
15				
14	Bolt M6x20.46.019 GOST 7798-70.		4	
13				
12				
11				
10				
9	765-71-1429	Gasket	X2	2 off.
8				
7				
6				
5	765-71-c8519 or 765-71-1309-K	Reducer	1	
3	765-71-c8497	Blower	1	
2				
1	765-71-c8356	Box	1	

4	-	765.790-80	
3	-	765.222-80	
2	-	765.926-78	
1	-	765.450-77	
0.1	-	52-1164	

S/NO	SHEET	DOCNO	SIGN	DATE
		CH.V.RAD		30.7.80
		S.R. NAR		31.7.80
		S.R. NAR		30.7.80
		S.R. NAR		30.7.80
		S.R. NAR		30.7.80
		S.R. NAR		30.7.80

**BLOWER,
LEFT.**

CIFE, PUNE

765-71-c8545	
SHEETS	WEIGHT/SCALE
37	1/10
TOTAL SHEETS	

QTY	ZONE	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
				<u>Technical papers.</u>		
12			765-71-c8564c8.	Assembly drawing.		
				<u>Parts.</u>		
13 B	1		765-71-1525	Rotor	1	
12 B	2		765-71-1527	Flange	1	

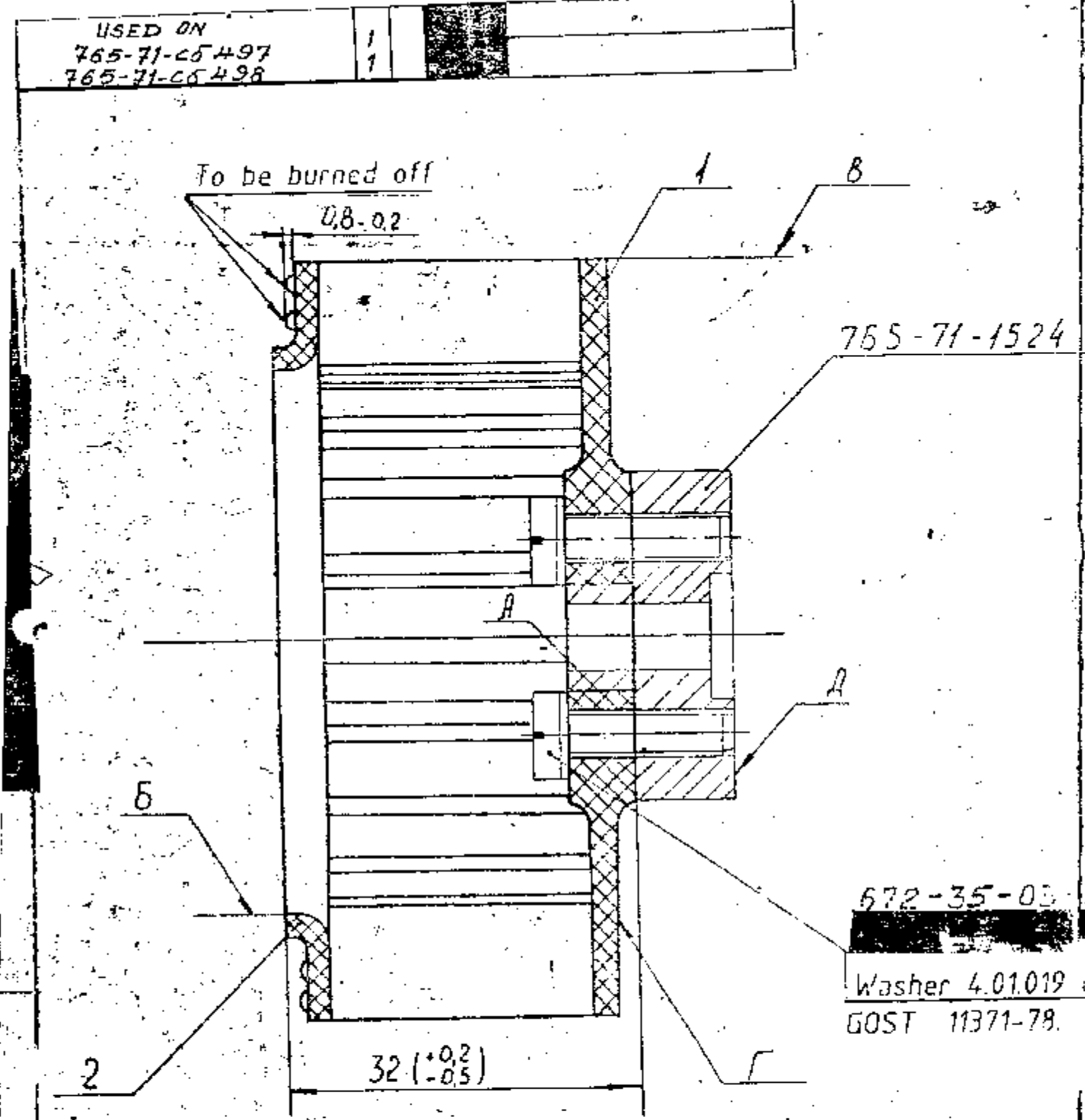
765-71-c8564.

S.NO	SHT	DOC.NO.	SIGN	DATE
	DRAWN	BHUSHAN		22.8.84
	EDT&CHK	ANURAG		22.8.84
	F/M.D.C.	S.R.NAIK		28.8.84
	APPROVED	T.K.BANERJEE		31.8.84
		NAME	SIGN	DATE

ROTOR.

SHT. NO.	NO. OF SHT.





1. Non-squareness of blades to the plane of flange should not exceed 0.6 mm over blade length. 19/11
2. Radial run-out of surfaces Γ and B with respect to axis of surface A should not exceed 0.16 mm.
3. After burning off projections loose fitting and shaking of blades and flange are not permitted.
4. Statically balance rotor together with carrier 765-71-1524, 672-35-3-02, with washers 4.01.019 or 4.02.019 GOST 11371-78. Static unbalance should not exceed 0.2 gram on 35 mm when balancing, it is permitted to drill holes 3 mm in diameter to a depth not exceeding 1 mm or radius R25 mm, between blades on surface Γ and holes 5 mm in diameter to a depth not exceeding 15 mm on surface A. In this case, balancing holes may not be brought beyond limits of contour of part 765-71-1524 and incision in thread is not permitted.
5. Make locating marks on rotor and carrier on each of screws and rotor, with enamel ПФ-223, Red, GOST 14923-78, after balancing.
6. Make the parts with same serial numbers and use them together.

765-71-0556465

SHEET				WEIGHT		SCALE	
NO.	DOC NO.	SIGN.	DATE	005 21		TOTAL SHEETS	
DRAWN	CHKD	EDT	F/M, DC				
ROTOR ASSEMBLY DRAWING				ORDANANCE FACTORY PROJECT HYDERABAD			
DIV. OFFR.	T. C. BANNERJEE	NAME	SIGN	DATE			

Ref. No.	Designation	Description	Qty	Remarks
		<u>Documents</u>		
	765-71-c66290E	Assembly drawing		
		<u>Parts</u>		
1	765-71-1752	Wall	1	
2	765-71-1753	Wall	1	

APPROVED *CPH*
 CHECKED *CPH*
 CONTROLLERATE
 OF
 INSPECTION

765-71-c6629

VOLUME

NUMERICAL

ENTR. ENTS

1-4-5

765-71-0662905

EXPLANATORY NOTES TO TECH. CONDITIONS.

COATING ANODIC OXIDATION WITH SUBSEQUENT SEALING IN BICHROMATE OR CHEMICALLY PHOSPHATIZED, BLUE EXTERNAL SURFACE SHALL BE APPLIED WITH PRIMER CONFORMING TO IS: 6660-1970. THEN SHALL BE PAINTED WITH PAINT CONFORMING TO IS: 2932-1974 SHADE No. 365 OF IS: 5-78 EXCEPT SURFACES A, E, B THREADS.

SURFACE FINISH :-

- 1) $Rz 20$:- THE Rz VALUE OF SURFACE FINISH TO BE OBTAINED BY THE REMOVAL OF MATERIAL LAYER IS NOT MORE THAN 20 MICRONS.
- 2) $Rz 40$:- THE Rz VALUE OF SURFACE FINISH TO BE OBTAINED BY THE REMOVAL OF MATERIAL LAYER IS NOT MORE THAN 40 MICRONS.
- 3) $Rz 80$:- THE Rz VALUE OF SURFACE FINISH TO BE OBTAINED BY THE REMOVAL OF MATERIAL LAYER IS NOT MORE THAN 80 MICRONS.

NOTE :-

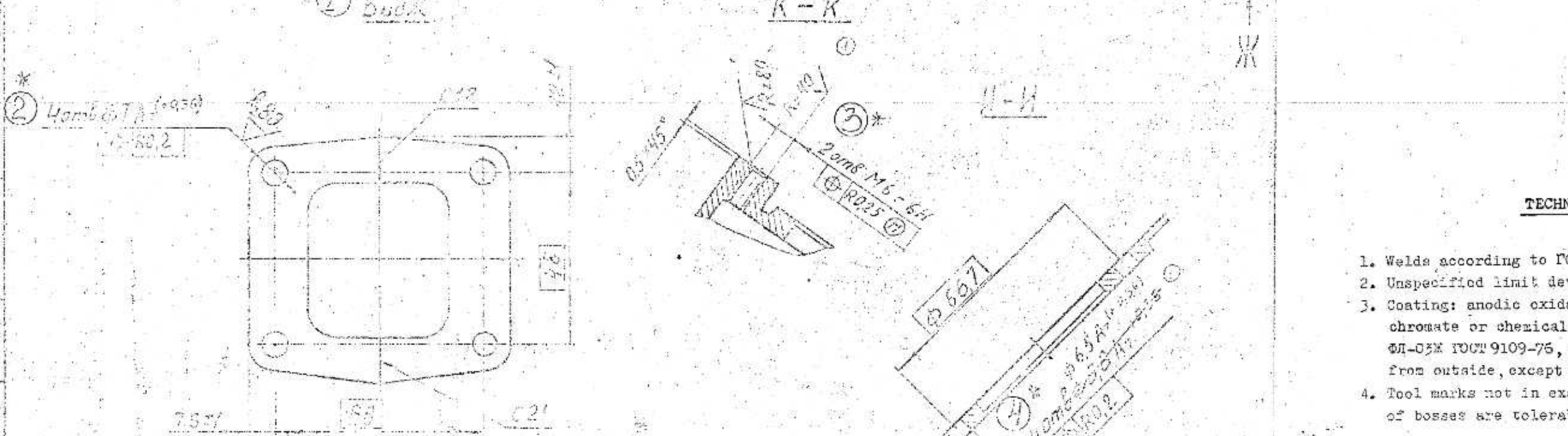
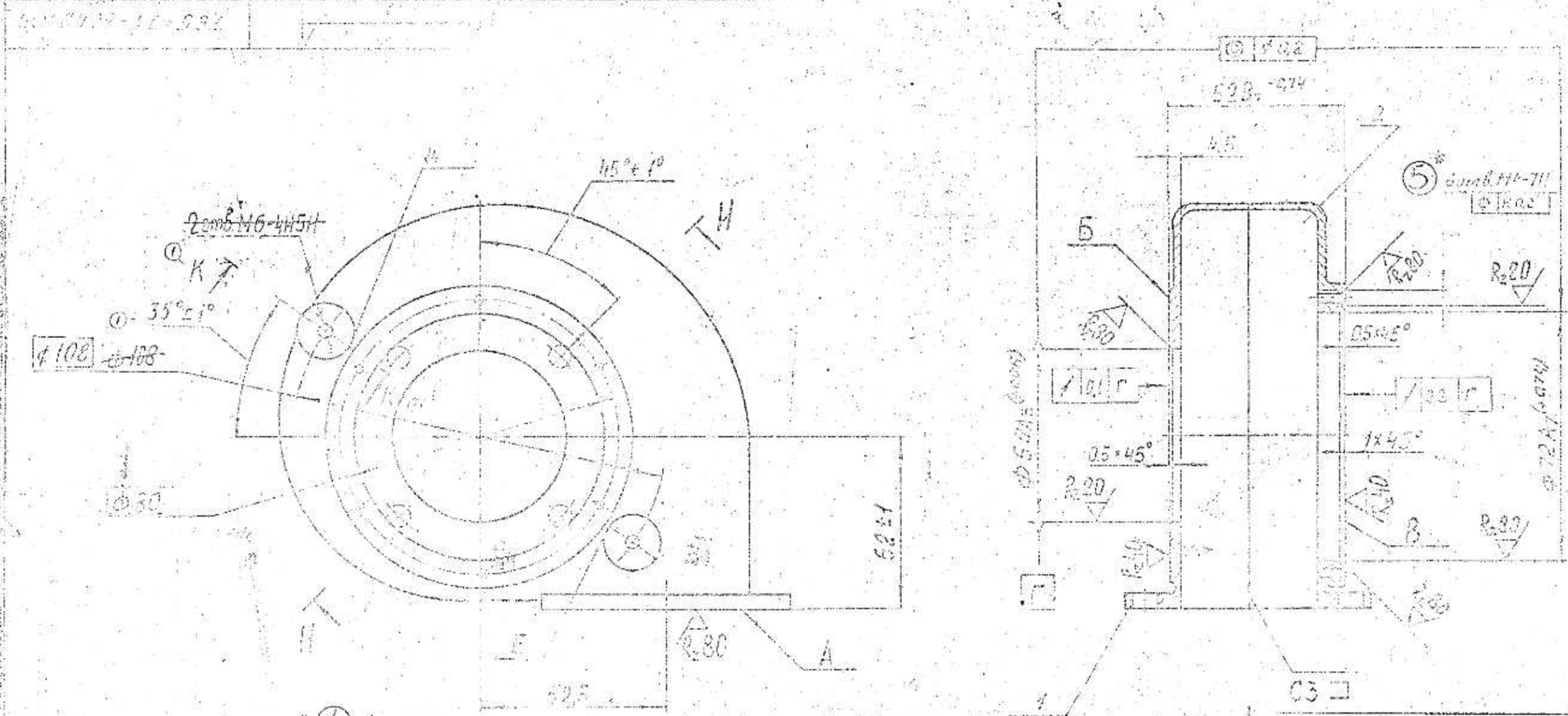
- 1) $\phi | R0.2$:- POSITIONAL TOLERANCE IS 0.2mm ON RADIUS.
- 2) $\phi | R0.25$:- POSITIONAL TOLERANCE IS 0.25 ON RADIUS AT MAXIMUM METAL CONDITION.
- 3) \square :- BASE IS \square
- 4) $\sqrt{0.1} \square$:- REPRESENTS RUN OUT OF INDICATED DIMENSION TO BE WITH IN 0.1mm TO THE BASE INDICATED AS 'r'
- 5) $\phi 80$:- DIMENSIONS GIVEN IN RECTANGLES THESE DIMENSIONS ARE NOT FREE DIMENSIONS BUT TOLERANCES IS NOT SPECIFIED.
- 6) \triangle :- ARROW INDICATED SURFACE \triangle
- 7) $\phi | \phi 0.2$:- CONCENTRICITY OF INDICATED HOLES IS 0.2 ON DIAMETER.
- 8) $\sqrt{0.2} \square$:- REPRESENTS RUNOUT OF INDICATED DIMENSION TO BE WITH IN 0.2mm FROM THE BASE INDICATED AS 'r'.

TECHNICAL CONDITIONS

1. Welds according to ISCT 14805-59.
2. Unspecified limit deviations of sizes - ± 0.5 mm.
3. Coating: anodic oxidation with subsequent sealing in bichromate or chemically phosphatized, blue, Cr. Primer 6A-05X ISCT 9109-75, enamel 115-223, white 1, ISCT 14923-78 from outside, except for surfaces A, B, E and threads.
4. Tool marks not in excess of 2 mm deep on surfaces A and E of bosses are tolerable.

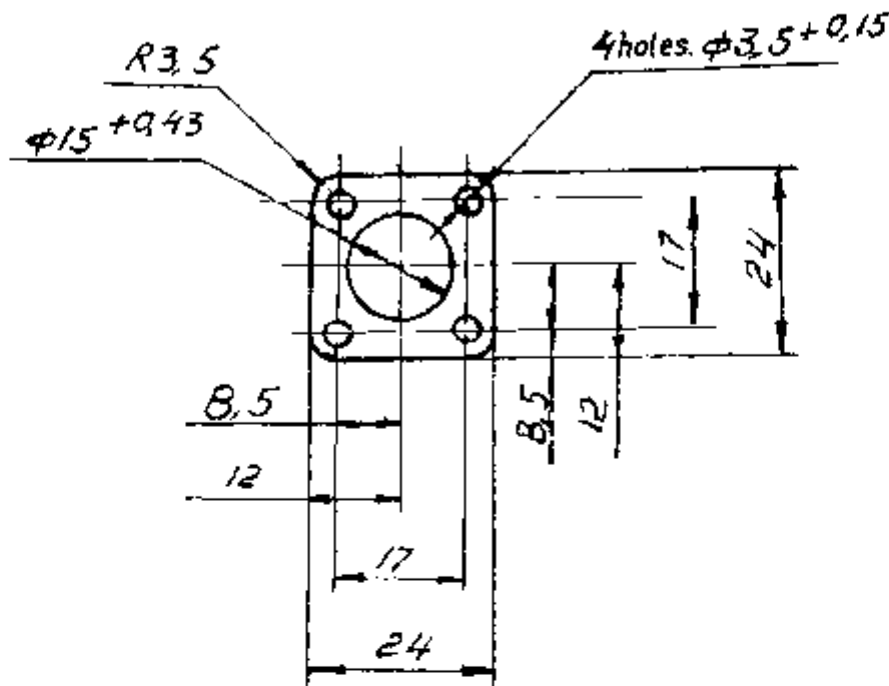
APPROVED		765-71-0662905	WEIGHT	SCALE
CHECKED	P.K. SETHI		0.39	1:1
CONTROLLER OF INSPECTION		VOLUTE	SHT	SHTS

DRN	--sd--	DRG NOT TO BE SCALED.	PERTAINS TO
TCD	--	ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.	
CHD	--sd--		
PSD	--sd--	ALL DIMENSIONS ARE IN mm. UNLESS OTHERWISE SPECIFIED.	
APPD	--sd--		
DATE	14 OCT 86		
TOLERANCE UNLESS OTHERWISE SPECIFIED			
GEN	DEC	ANG	
SCALE	VOLUTE		
	765-71-0662905		
	CQA (FE), AUNDH CAMP, PUNE-27.		



AUTHENTICATION T.C.D. CHD. PSD. DATE. DRG. BASED ON. W.P. No. CQA/FE/1-1-A2

765-96-15





Thickness 1 ± 0.1 .

Ⓐ 3. EQUIVALENT MATERIAL IS JSS 5640 OR B15 OR B10 TO IS:2712

1. Perform dimensions without deviations with accuracy ± 0.5 mm.
2. Deviation of centres of holes should not exceed 0.1 mm for $\phi 3.5$; 0.25 mm for $\phi 15$ from their true position.

01041-ICV 18-7-07	Ⓐ	DS CAT NO ADDED
DEVS NO DATE	ISSUE	NATURE OF AMENDMENT

APPROVED
 M. VASU
 CHECKED


765-96-15 Ⓐ
 DS CAT NO: LV2/ICVS 5330-366528

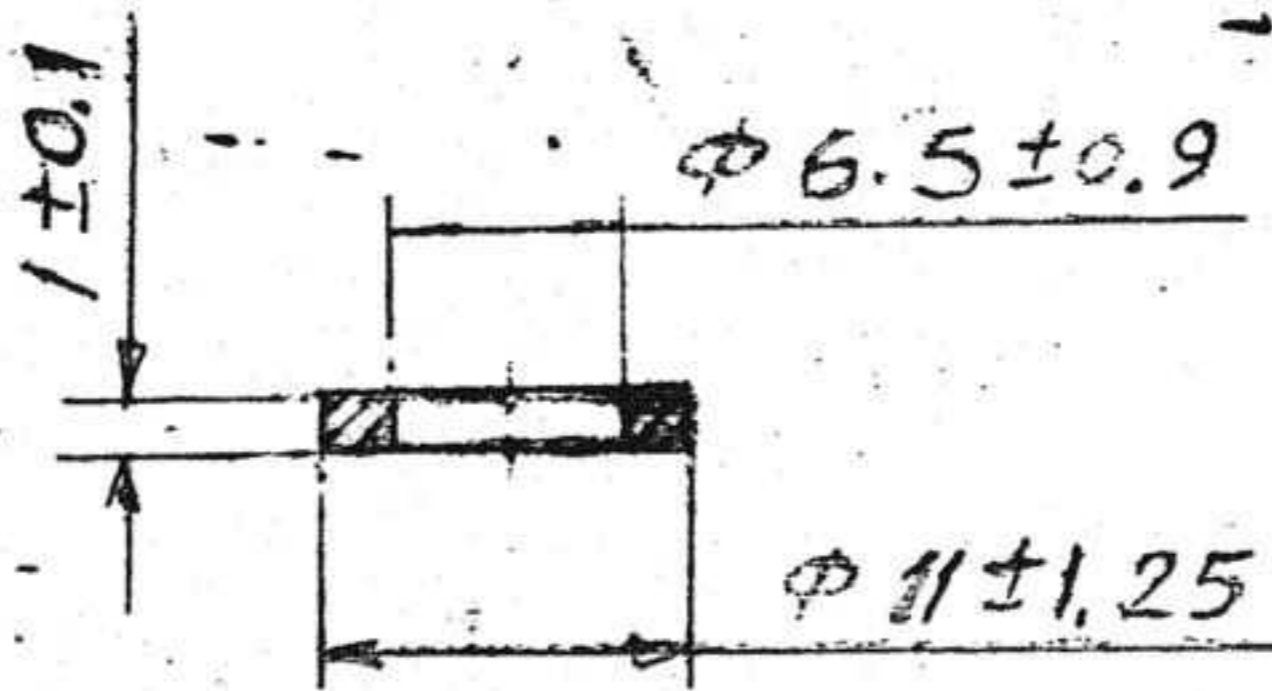
CONTROLLERATE
 OF
 QUALITY ASSURANCE
 (ICV)

GASKET
 Paronite non 1.0 (DCT-481-80)

	WEIGHT	SCALE
	0.0007	1:1
SHT	SHTS	

765-96-16

All over,



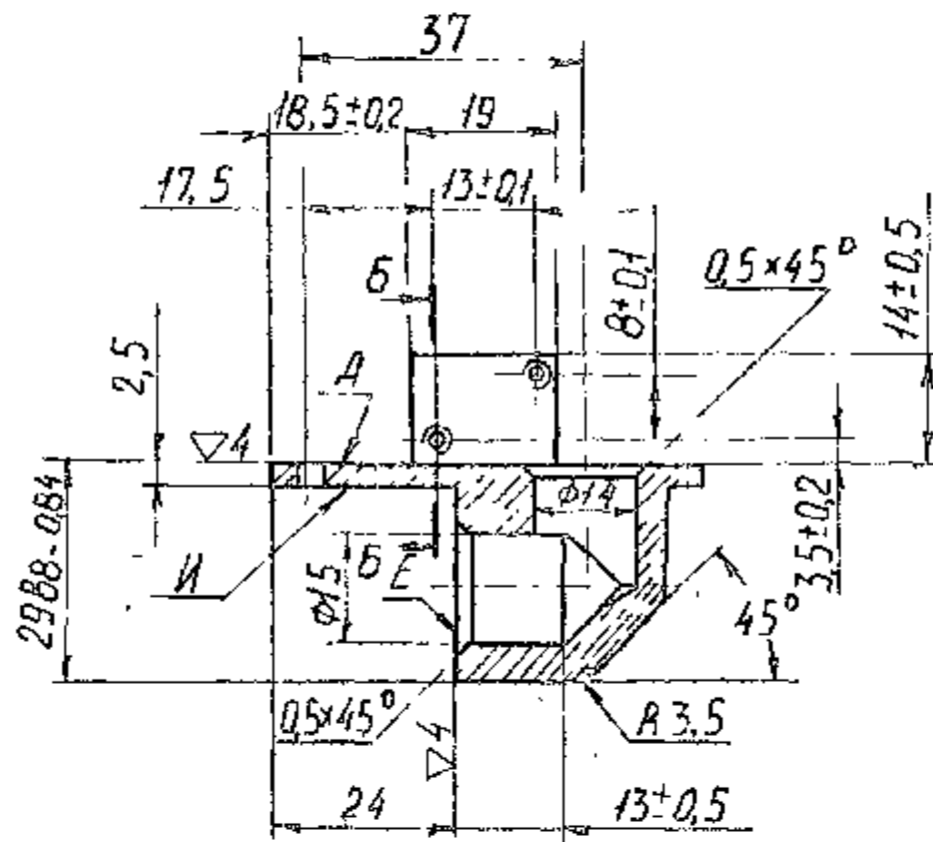
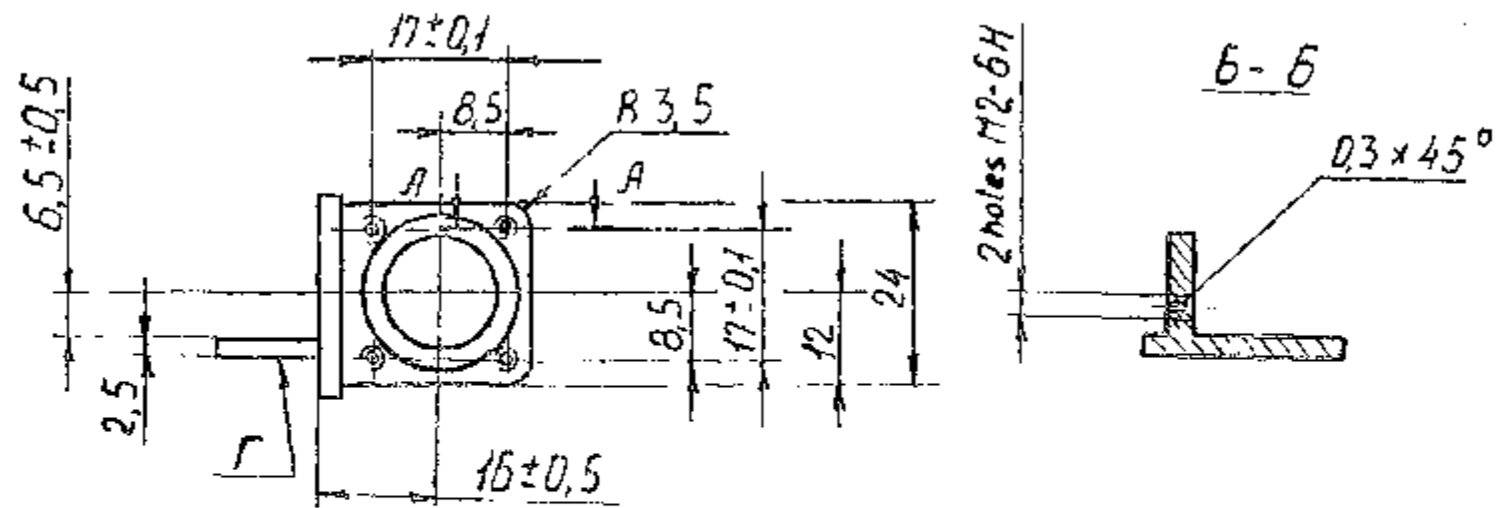
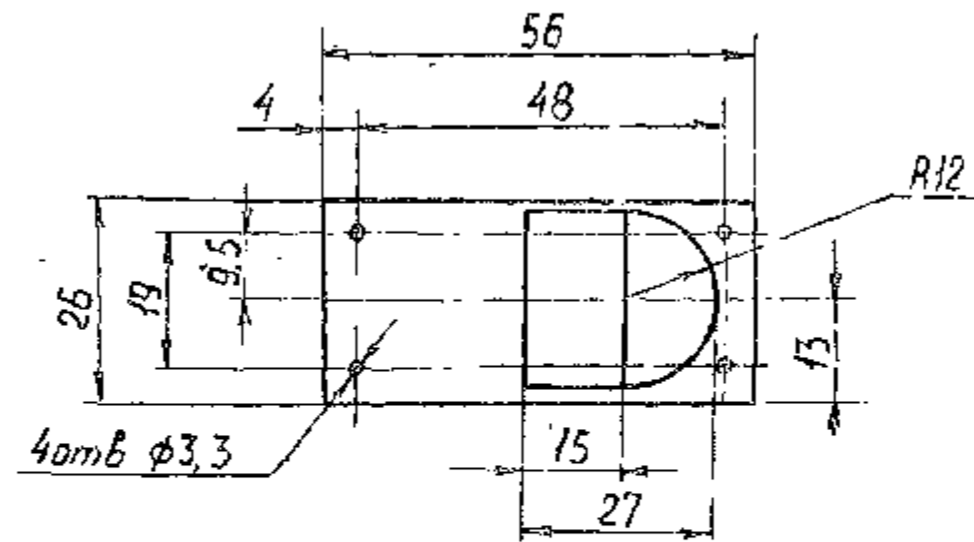
SN	SHT	DOC NO	SIGN	DATE
DRAWN		P.R.BABU.		11.7.84.
EDT,CHKD		AK DUDEY	<i>(Signature)</i>	12/1/84
F/M,DC.		S.R.NAIR	<i>(Signature)</i>	12.7.84
DIV.OFFR				
		NAME	SIGN	DATE

GASKET

Rubberised asbestos fabric
MOH-10
GOCT 481-80.

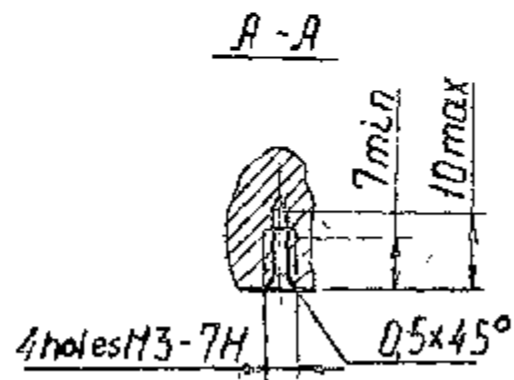
SHEET	WEIGHT	SCALE
765-96-16		
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

765-96-16



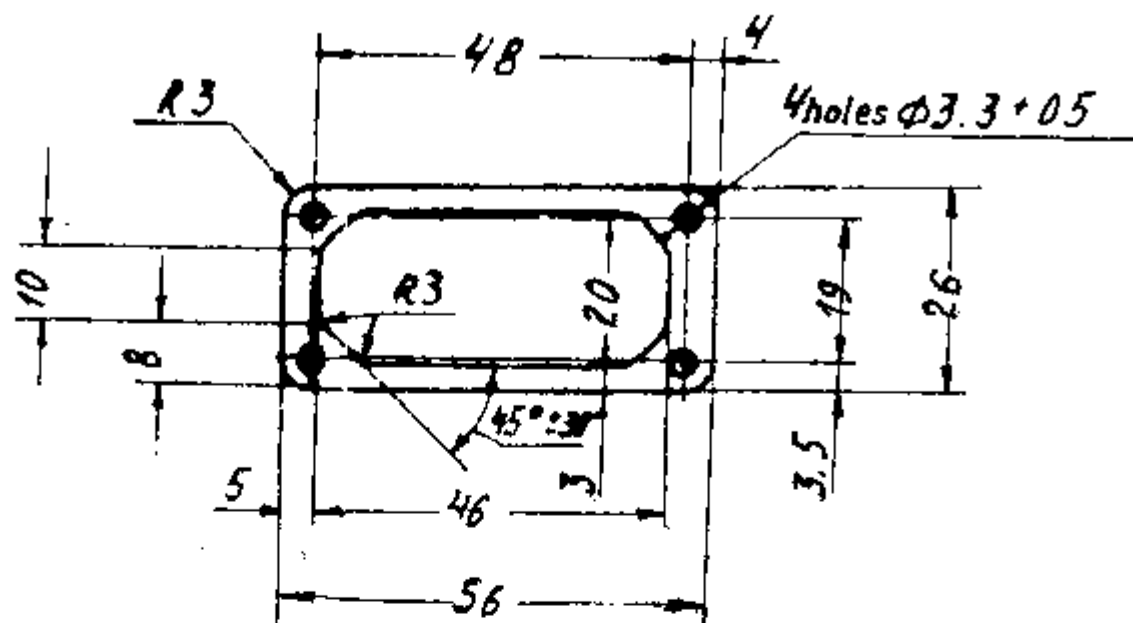
1. Blunt sharp edges.
2. Displacement of hole centres from true position should not exceed 0,2 mm.
3. Provide dimensions without deviations as per accuracy class 7, OST 1010.
4. Alternate material are A16 and AK4 GOST 4784-74
5. Coating: Anodically oxidized, chromated or chemically parkerized blue, chromated.
6. Apply primer ФЛ-03 №, GOST 9109-81 all over, except holes jaw Г and surfaces А, and Е and paint with enamel ПФ-223, dark grey, GOST 14923-78 or enamel МЛ-12Н, grey, GOST 9754-76 and enamel МЛ-165, silver, GOST 12034-77.
7. Steps with in the limits of tolerance are allowed on surface U.
8. Partial paint coating is allowed on surface E

Ⓐ EQ. MATERIAL :- AL. ALLOY Gde.2285, CONDITION 'WP' TO IS: 617.



90605-15V	Ⓐ	EQ. MATERIAL ADDED.
21-4-97	Am	(2/97 N OF A)
DC (I) NO. & DATE	ISSUE	NATURE
AMENDMENTS		

APPROVED	BY	765-96-73	325 of 342
DESIGNED	H.M. Sh... ..		
CONTROLLERATE OF INSPECTION (REV)		COVER	SCALE 0.035 1:1
		A1 GOCT 4784-74	SHTS 114



Thickness 0.5 ± 0.05

1. Deviation of centres of holes from their true position should not exceed 0.2 mm.
2. Perform dimensions without deviations with accuracy ± 0.5 mm.

DD42:ICV
FEB 84
ISSUE NO
DATE

(A) D.S.CAT. PART NO. ADDED
AMENDMENT

APPROVED: M. V. S. R.
CHECKED: P. V. S. R.

765-96-74

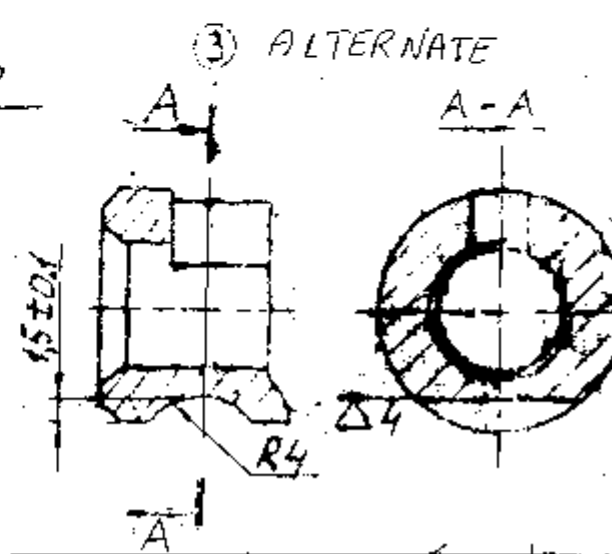
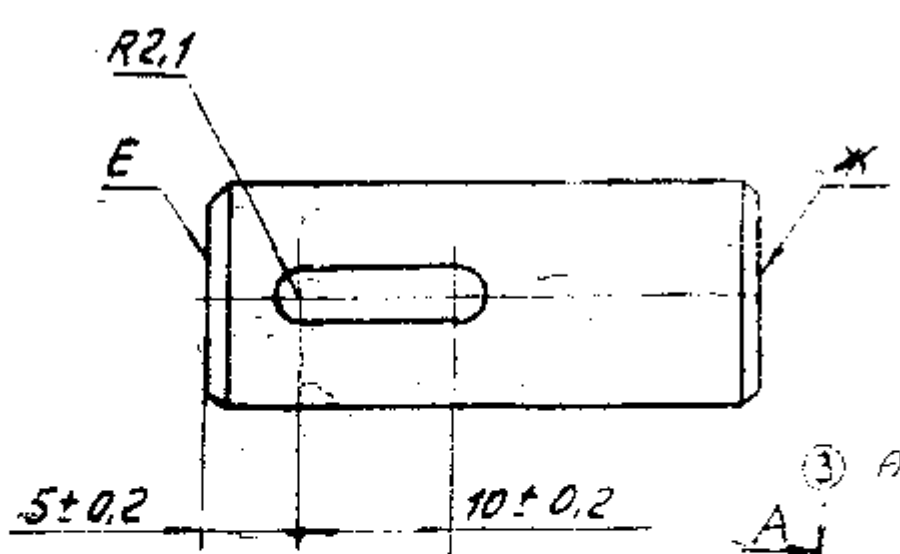
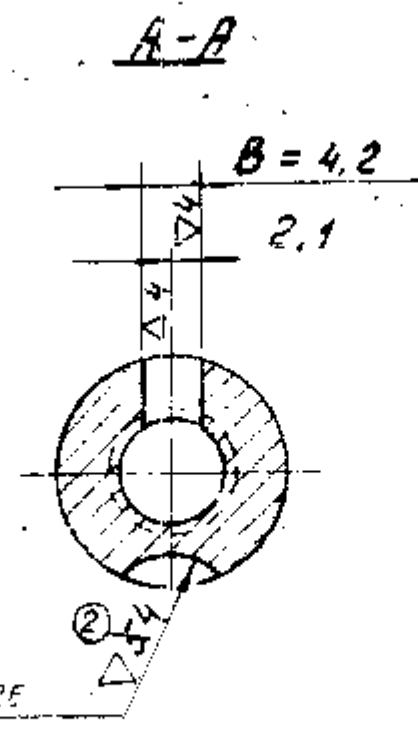
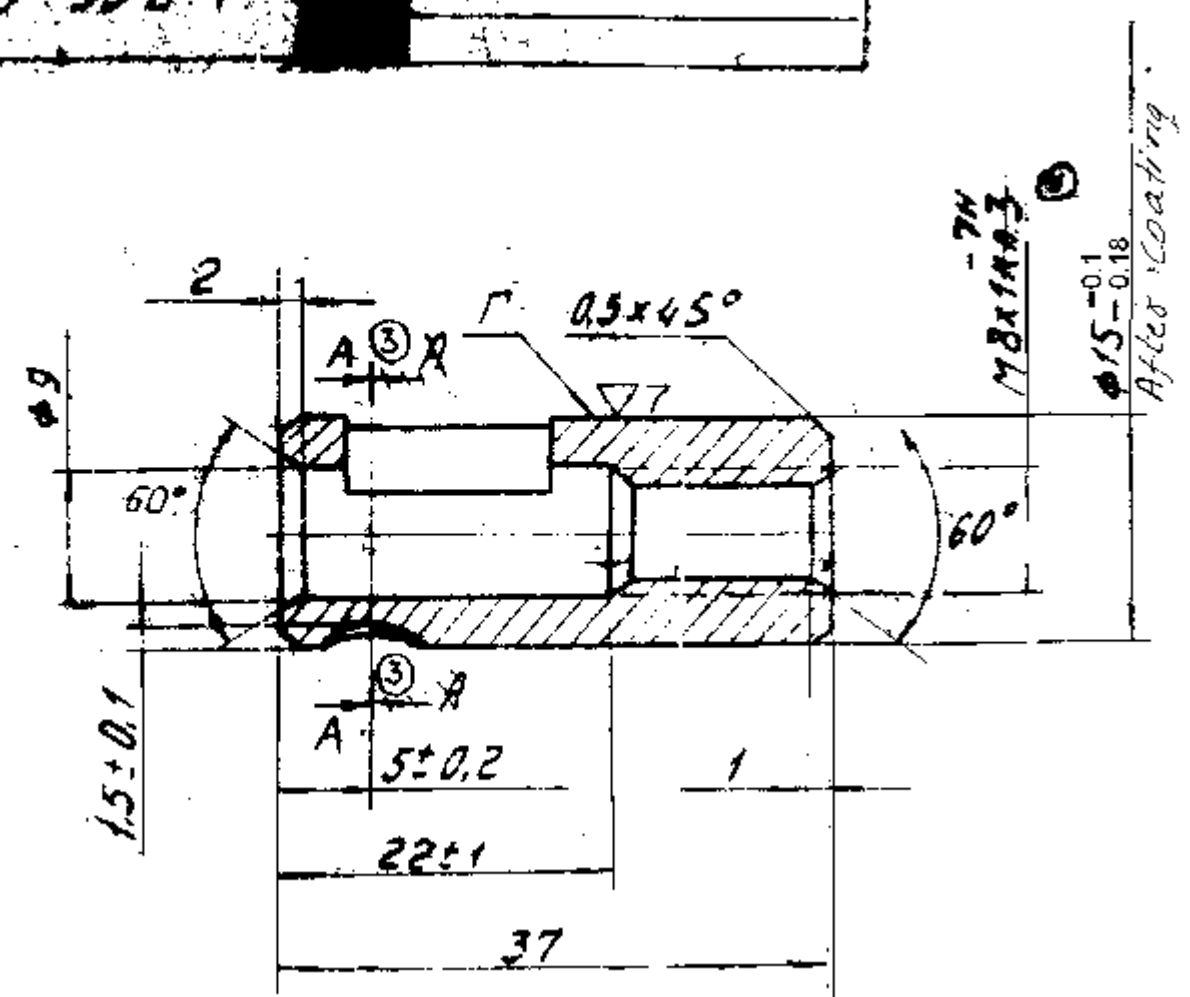
LV2/RLV. (A)
5330.009541

CONTROLLERATE
OF
INSPECTION
(ICV)

GASKET
Electric insulation board
grade 3B GOCT 2824-75

WEIGHT	SCALE
0.0007	7:1
SMT	SMTS

Unless otherwise specified.



1. Blunt sharp edges.
2. Provide dimensions without deviations as per accuracy class 7, OST 1010.
3. Brinell hardness is 302 to 255 (φ3,5 to 3,8).
4. Eccentricity of crescent B and slot B should not exceed 0,1mm (qualified tolerance).
5. Coating of surfaces B, F, E, X, and chamfers 0,5 is chrome-plating 18 to 24^{whit} hard. Other surfaces may be free of chrome-plating. Protect the thread from coating.
6. Check the dimensions of slot B after coating. Steps are not allowed.
7. Displacement of crescent B and slot B with respect to the axis of surface F should not exceed 0,1mm (qualified tolerance).

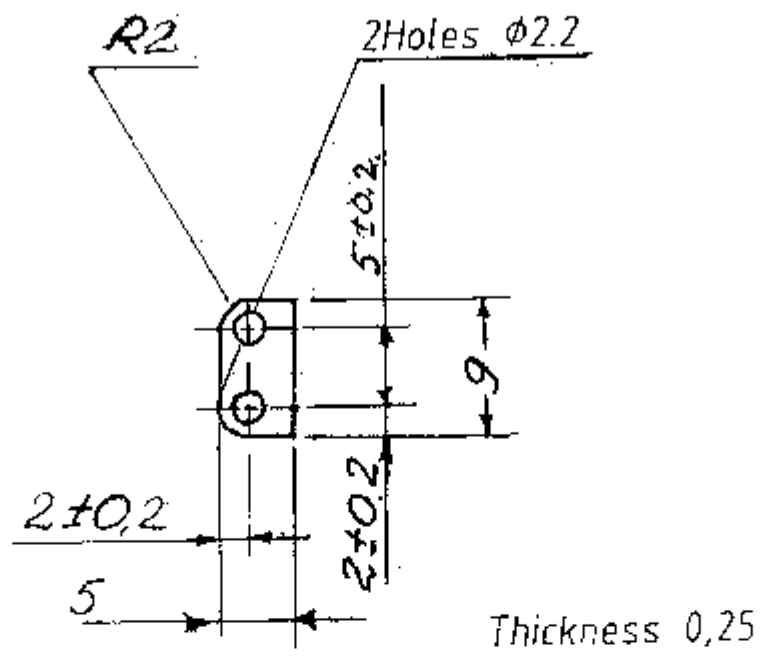
- Ⓐ EQ. MATERIAL:- STEEL GRADE 42C4 TO IS: 5517-93
- Ⓑ EQ. MATERIAL:- STEEL GRADE 42C4 M02 TO IS: 5517-95

00757-10V	Ⓑ	STEEL GRADE 42C4 M02 TO IS: 5517-95 ADDED AS EQ. MATERIAL
00643-1CV	Ⓐ	STEEL GRADE 42C4 TO IS: 5517-93 ADDED AS EQ. MATERIAL
13-7-98	ISSUE	NATURE
DATE		AMENDMENT

APPROVED	AS VISU	765-96-119	167 of 180
CHECKED	V. K. Jeyaraj	ROD	WEIGHT SCALE
CONTROLLERATE OF INSPECTION (ICU)		45X GOST 4543-71	0.032 2:1
			SMT SMTS

765-96-121

2



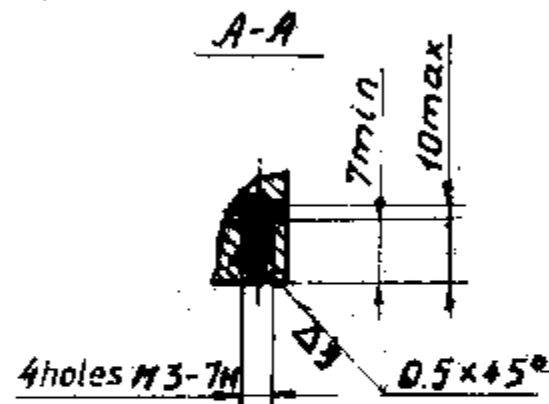
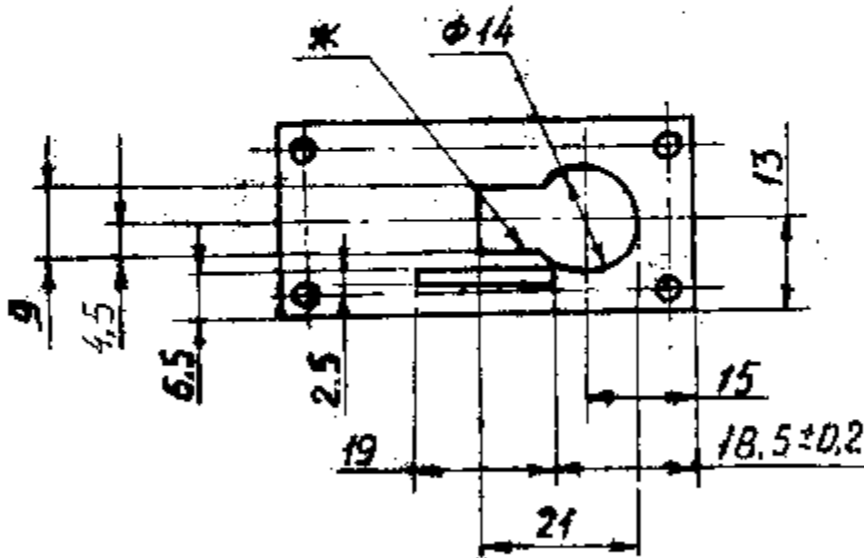
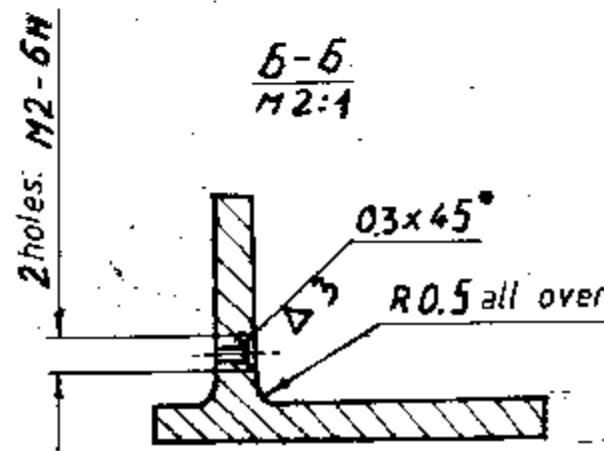
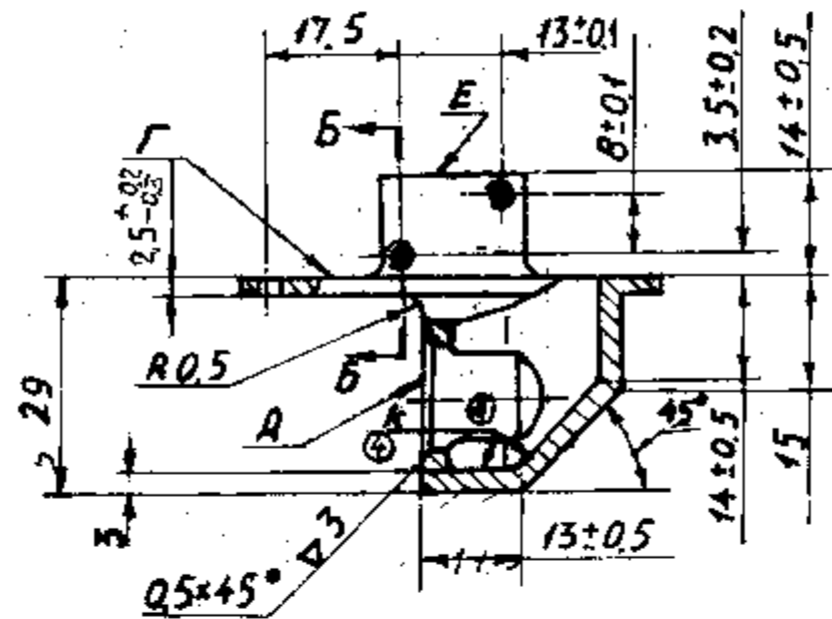
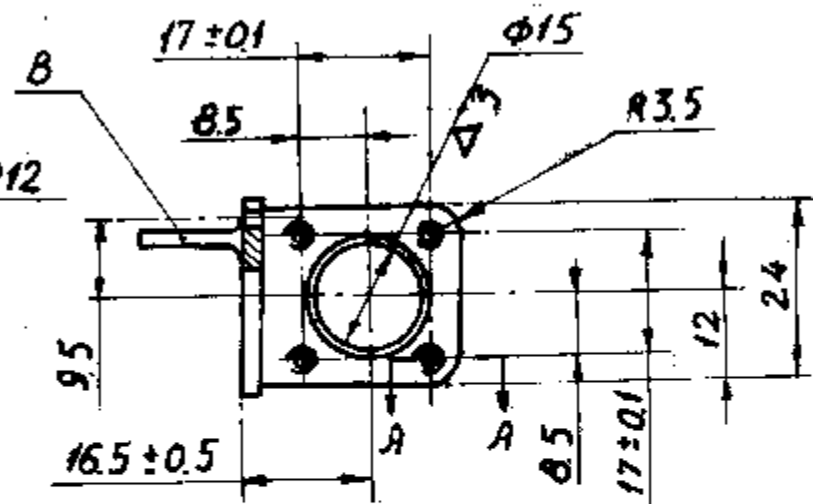
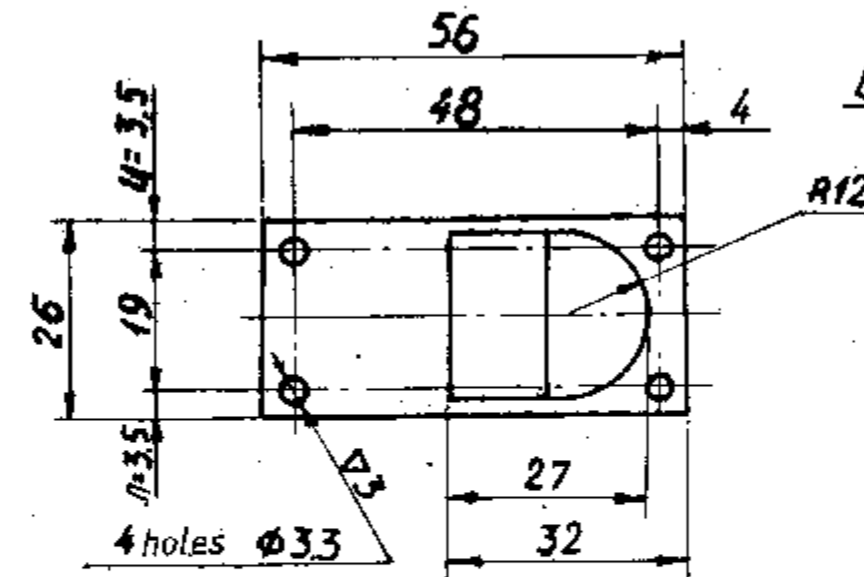
1. Blunt sharp edges.
 2. Perform dimensions without deviations with accuracy class 7, OST 1010.
- Ⓐ EQ. MATERIAL - CB 101 TO BS:2870-68 W(H) CONDITION

0757-12V VERIFIED 17-1-2000	Ⓐ Am	EQ. MATERIAL IS ADDED IN THE DRAWING
DCU/NO DATE	ISSUE	NATURE OF AMENDMENTS

APPROVED	M. YASU	765-96-121	
CHECKED	DSKUMAR		
CONTROLLERATE OF INSPECTION (ICV)	GASKET	WEIGHT	SCALE
		0.00006	2:1
		SHT	SHTS
	BAND 0.25 - EPB 2T FOCT 1789-70	10	371 of 413

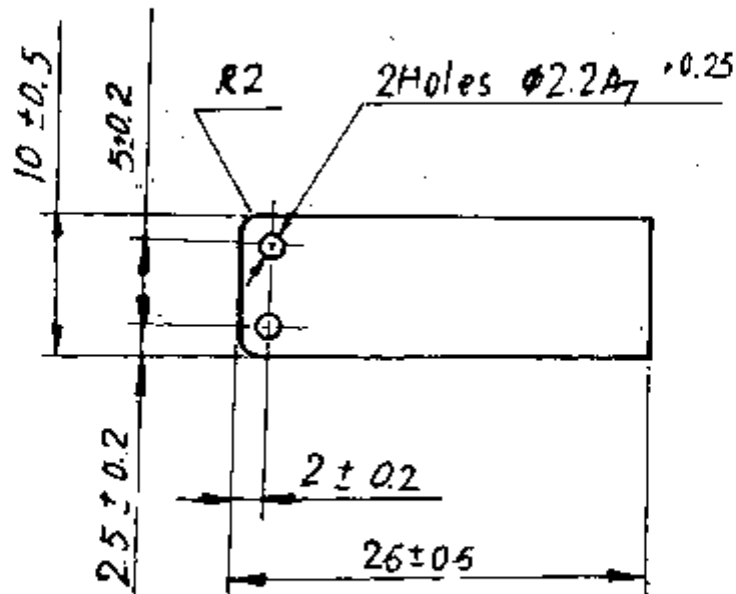
765-96-143

Unless otherwise specified.



1. Unspecified casting radii should not exceed 1,5 mm.
2. Pattern drafts should not exceed 1° towards the body increase beyond tolerance.
3. Blunt sharp edges.
4. Provide dimensions without deviations as per accuracy class 7, OST 1010.
5. Displacement of axes of holes from true position should not exceed 0,2 mm.
6. Other requirements for casting are as per Technical requirements TT A1-370.
7. Alternate material is AA 9. GOST 2685-75.
8. Coating: Anodically oxidized, chromated or chemical parkerized, blue.
9. Apply primer ФЛ-03 Ж, GOST 9109-81, all over, except holes of jaw B and surfaces Г and А, paint with enamel МЛ-12, grey GOST 9754-76, and enamel МЛ-165 (former МЛ-25) silver, GOST 12034-77.
10. Knock-out traces of depth upto 0,5 mm are allowed on surfaces Г and Е and on surfaces Г atleast 2mm from edges.
11. Drafts not exceeding 3° may be provided on surfaces of hole Ж.
12. Dimension А may be provided instead of dimension U.
13. Bulging of surface Г should not exceed 0,25 mm.
14. Partial paint coating is allowed on surface А.
15. Knurling to a height not exceeding 0,2 mm is allowed on surface К.

APPROVED	M. VASU	765-96-143	
CHECKED	Mish-ich	WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (IC V)		COVER	0.035 1:1
		AA2 GOST 2685-75	SHT SHTS
		10	368 of 413



Thickness 0.25

1. Blunt sharp edges

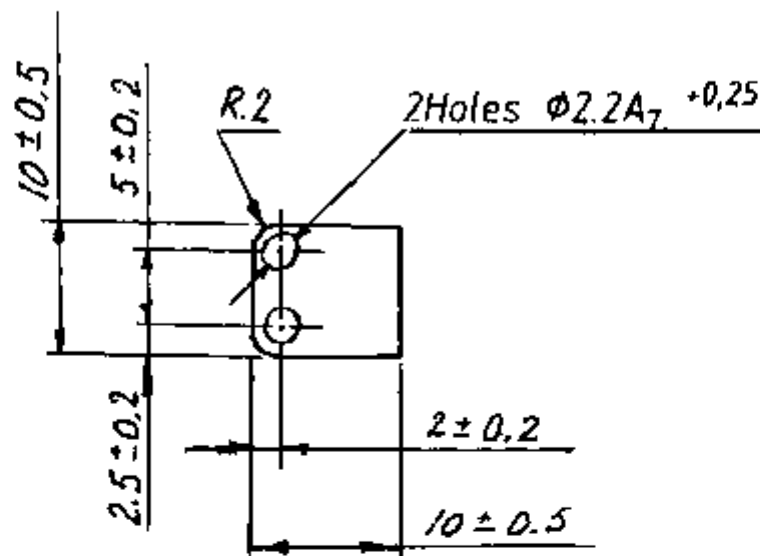
2. Hardness as per Vicker is 350

(A) EQ. MATERIAL:- CB 101 TO B9: 2870-68 W(H) CONDITION

00757-101 V. R. ... 17-2-2006	(A) G.M.	EQ. MATERIAL IS ADDED IN THE DRAWING
DEC 10 NO DATE	ISSUE	NATURE OF AMENDMENTS

317 of 332

APPROVED	M. VASU	765-96-151	330 of 342
CHECKED			
CONTROLLERATE OF INSPECTION (ICV)		PLATE	WEIGHT SCALE 0.0004gms. 2:1
		BAND 0.25 - EpB2.T FOCT 1789-78	SHT SH



Thickness 0.25

- 1. Blunt sharp edges.
- 2. Hardness as per Vicker test is 350 min.
- Ⓐ EQ.MATERIAL:- CB 101 TO BS:2870-68 W(H) CONDITION

30757- ICV v Rom 17 1-2000	Ⓐ Gur	EQ.MATERIAL IS ADDED IN THE DRAWING
DATE	ISSUE	NATURE OF AMENDMENT

APPROVED *M VASU*
CHECKED *ESKUM*

765-96-152

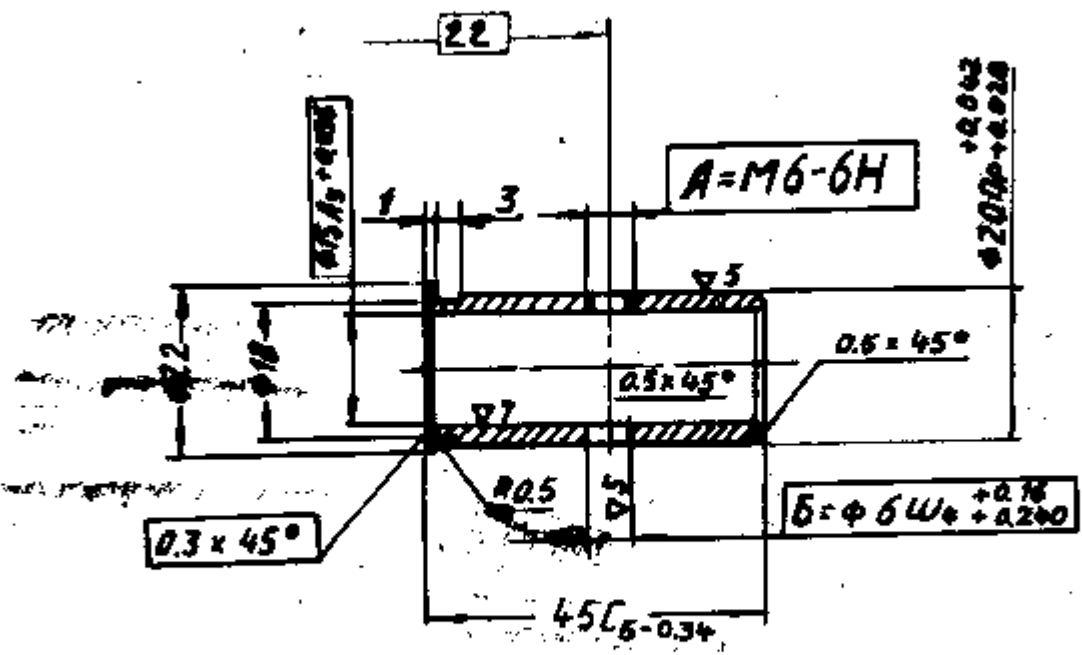
CONTROLLERATE
OF
QUALITY ASSURANCE
(ICV)

PLATE

STRIP 0.25-EPG 2.7
FOCT 1789-70

WEIGHT	SCALE
0.00013	2:1
SHT 1	SHTS 1

DESIGN NO	17-1-2000
DATE	17-1-2000
ISSUE	(A)
NATURE OF AMENDMENTS	EQ MATERIAL IS ADDED.

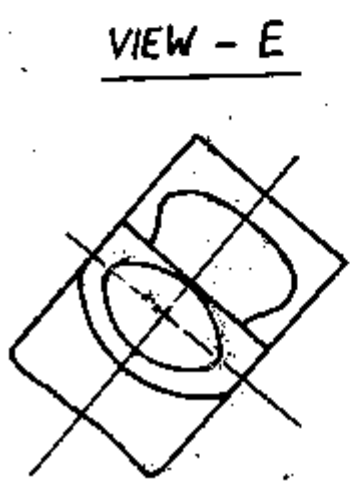
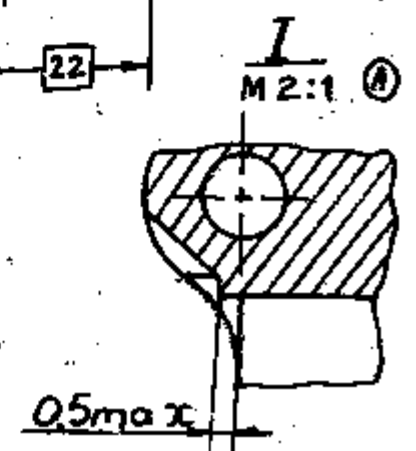
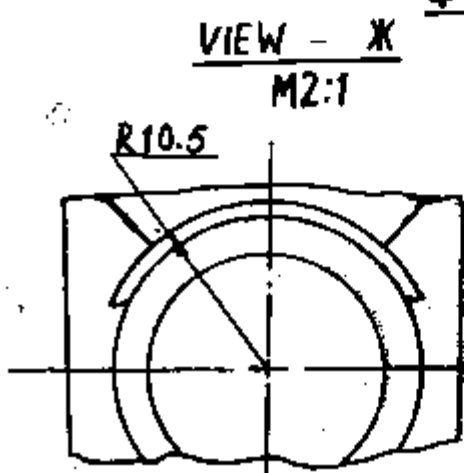
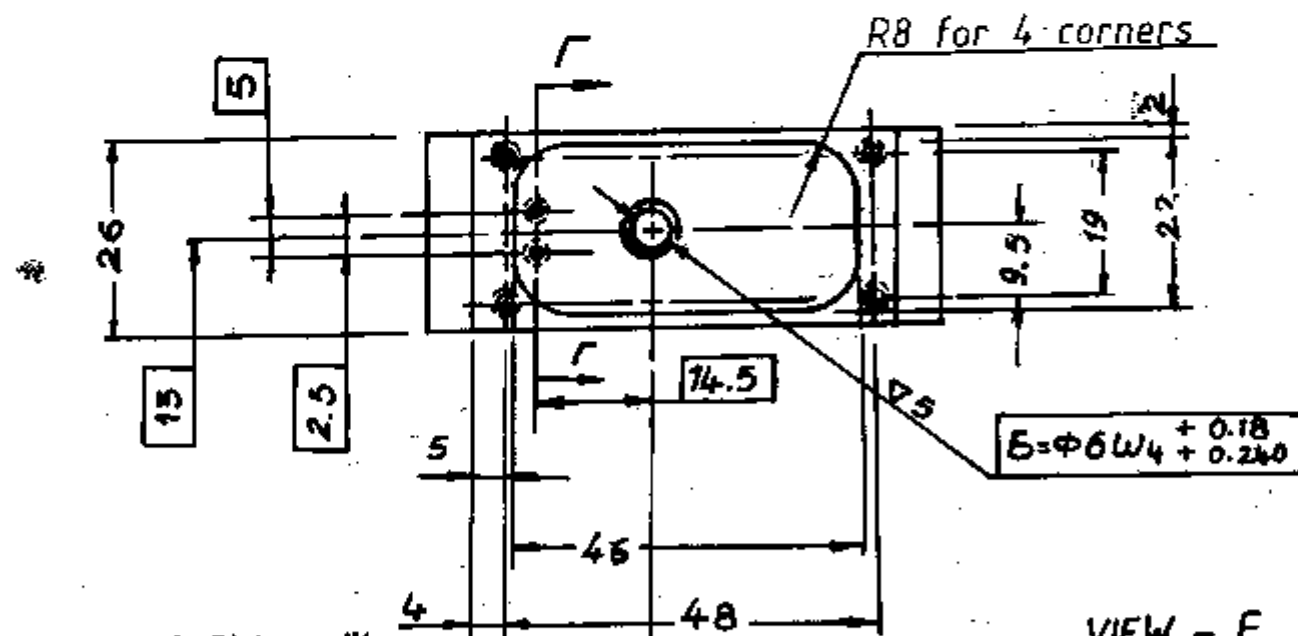
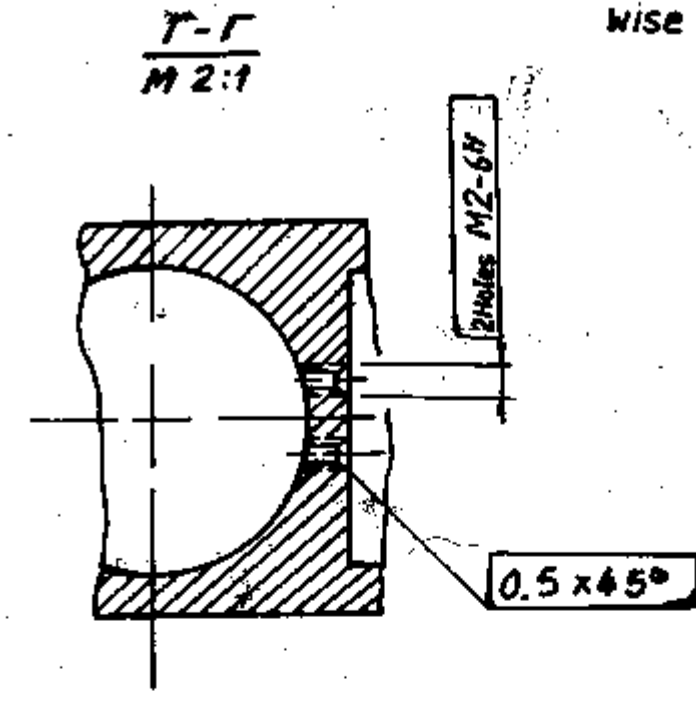
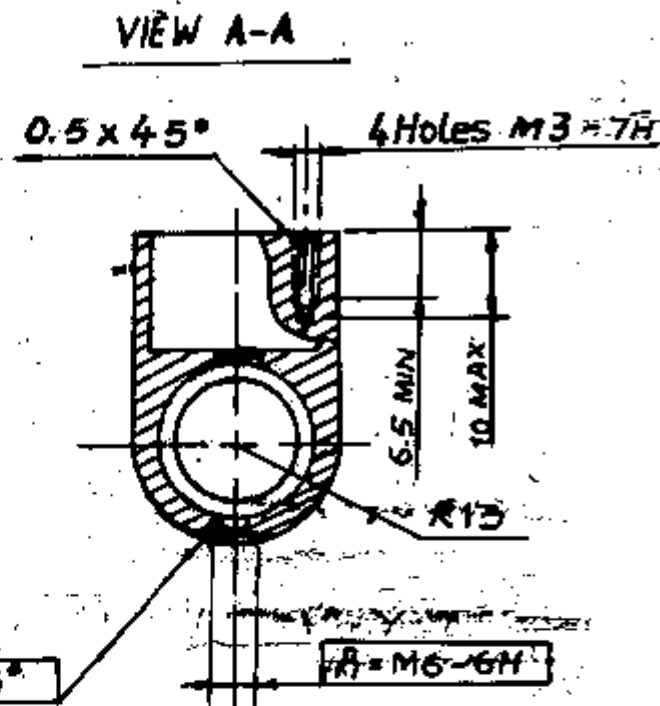
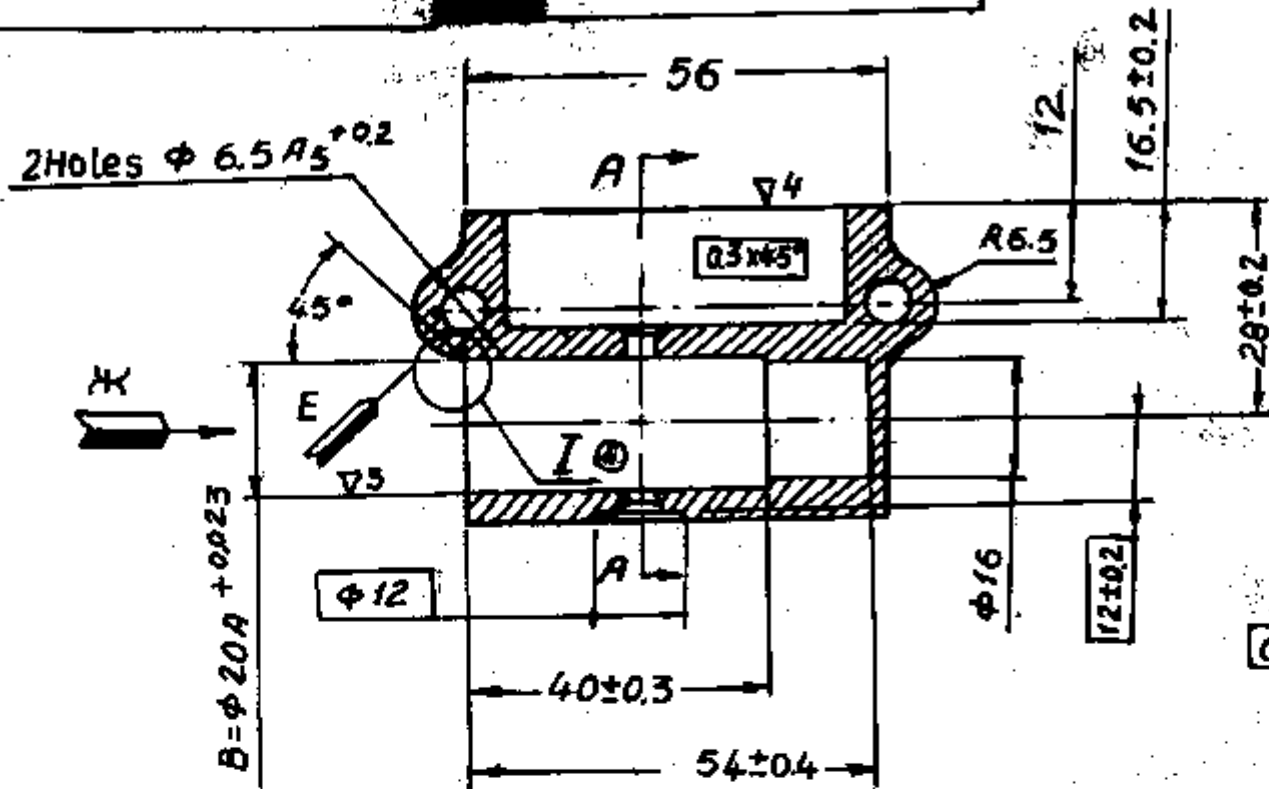


1. Blunt sharp edges.
 2. Perform dimensions without deviations with accuracy class 7, OST 1010.
 3. Machine to dimensions and item given in in assembly.
 4. Misalignment of holes A and B should not exceed 0.1 max. (Qualified tolerance).
 5. Alternate material is Sp. AMU 9-2, GOST 18175-78.
- (A) EQ MATERIAL:- AL BRONZE GRADE AB1 TO IS:305-81

APPROVED	<i>[Signature]</i>	765-96-161	171 of 180	
CHECKED	<i>[Signature]</i>		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)		BUSHING	0.056	1:1
		Sp. AX9-4 GOST 18175-78	ENT	SHTS

591-96-99

Unless otherwise specified

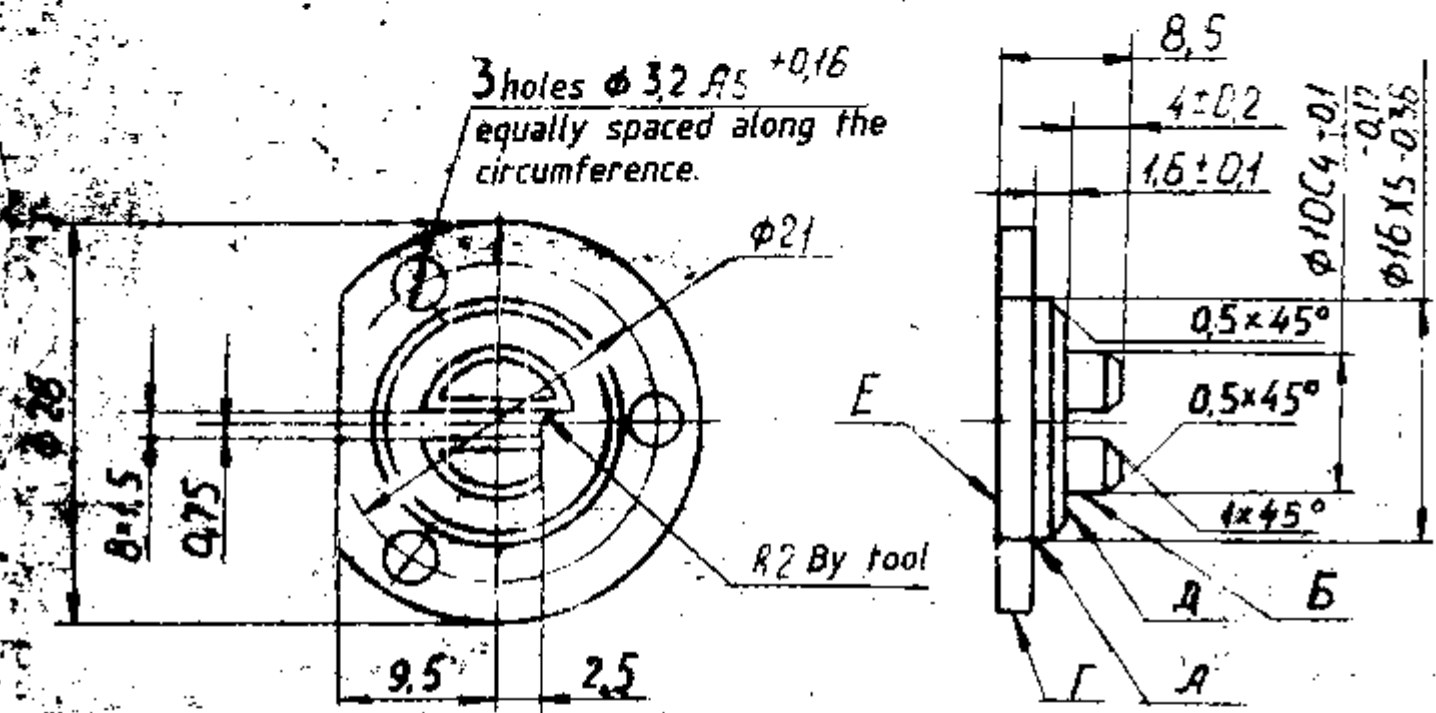


- (A) EQ. MATERIAL:- GY 24345, 'W' CONDITION TO IS: 733-74.
1. Blunt sharp edges.
 2. Provide dimensions without deviations as per accuracy class 7, OST 1010.
 3. Unspecified radii are R5.
 4. Displacement of axis of hole B with respect to axis of hole A should not exceed 0.1 mm.
 5. Eccentricity of holes B and A should not exceed 0.1 mm (Qualified tolerance).
 6. Unspecified displacement of axes of holes from true position should not exceed 0.2 mm.
 7. Non-squareness of axis of hole B with respect to axis of hole A should not exceed 0.1 mm.
 8. Machine to dimensions and per items given in in assembly.
 9. Perform heat treatment upto condition T.
 10. Coating: Anodically oxidized, chromated.
 11. Alternate material is AK4 GOST 4784-74.

EQ. MATERIAL ADDED.
(A) <i>[Signature]</i>
00728-14
15.09.99
DATE
ISSUE
NATURE OF AMENDMENTS

APPROVED	<i>[Signature]</i> M VASU	765-96-165	1/2 of 100
CHECKED	<i>[Signature]</i>	BODY	
CONTROLLERATE OF INSPECTION (ICV)			
A1 GOST 4784-74		WEIGHT	SCALE
		0.086	1:1
		SMT	SHTS

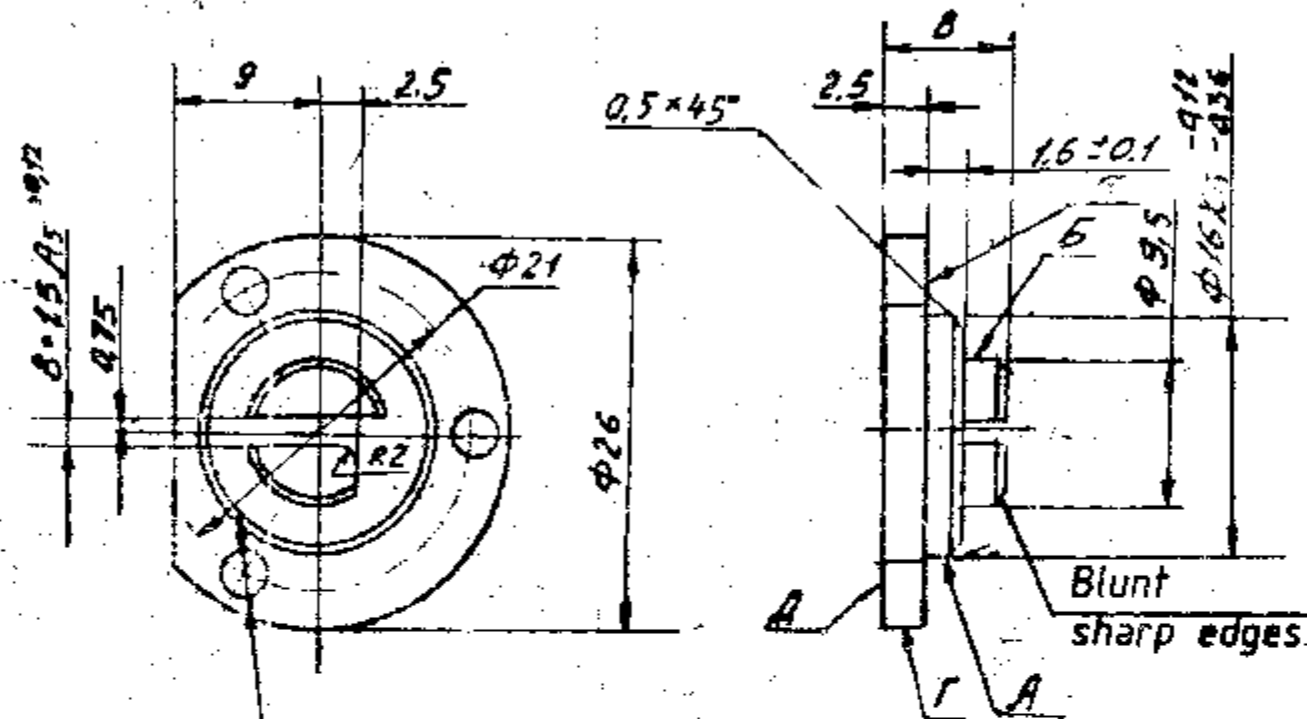
X20
32



1. Blunt sharp edges.
 2. Displacement of axes of holes from true position should not exceed 0,2 mm.
 3. Provide dimensions without deviations as per accuracy class 7, OST 1010.
 4. Eccentricity of surfaces A with respect to surface B should not exceed 0,1 mm,
 5. Displacement of axis of slot B with respect to axis of surfaces B should not exceed 0,1 mm (qualified tolerance).
 6. Steps not exceeding 0,2 mm are allowed on surface A.
 7. Coating: Anodically oxidized, chromated.
 8. Apply primer $\phi \eta -03 \times$, GOST 9109-81 on surfaces E and F and paint with enamel -17 ϕ -223, dark-grey, GOST 14923-78
 9. Unspecified rounding-off radii should not exceed R 0.5
 10. Alternate material is round bar A16T, GOST 21488-76.
- Ⓐ EQ.MATERIAL: GRADE 24345 TO 16:733-83 'W' CONDITION.

00848-104	Ⓐ	EQ.MATERIAL ADDED
DATE	ISSUE	NATURE OF AMENDMENT

APPROVED	BY NAME	765-96-168	
CHECKED	H.M. She...kh	RETAINER	
CONTROLLERATE OF INSPECTION (ICV)		WEIGHT	SCALE
		0.005	2:1
A1T GOCT 4784-74		114	



3 Holes $\phi 3.2 A_7^{+0.16}$
Equally spaced along
the circumference.

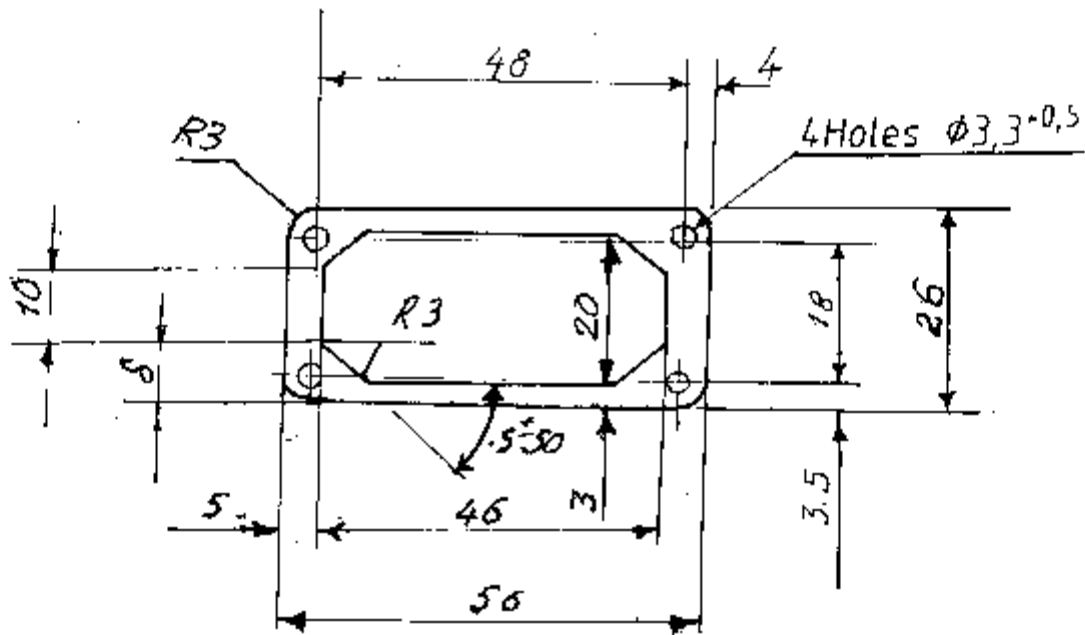
Alternate
M1:1



00848-10 N.V.S. 11.1.2001	(B)	EQ.MATERIAL ADDED
00735-10 V. R. P. M. S. 23.9.99	(A)	EQ.MATERIAL ADDED IN THE DRAWING
DCU/NO DATE:	ISSUE	NATURE OF AMENDMENT

1. Displacement of axes of holes from true position should not exceed 0.25 mm.
 2. Provide dimensions without deviations as per accuracy class 7, OST 1010.
 3. Eccentricity of surfaces A with respect to surfaces B should not exceed 0.1 mm.
 4. Displacement of slot axis B with respect to the part axis should not exceed 0.1 mm.
 5. Pattern drafts should not exceed 1° towards the increase of the body.
 6. Other requirements for casting are as per Technical requirements TTA/370.
 7. Alternate material is A/10B GOST 2685-75.
 8. Coating: Anodically oxidized, chromated or chemically parkerized blue, chromated.
 9. Apply primer $\phi N-03K$ GOST 9109-76 onto surfaces Γ and δ and paint with grey enamel M/12, GOST 9754-76 and silver enamel M/165, GOST 12034-77.
 10. Partial paint coating on surface E is allowed.
- (A) EQ.MATERIAL (i) Gy: 4600 IS: 6M-75 OR
(ii) Gy: 4600A IS: 6M-75
(B) (ii) Gy: 4600A TO IS: 6M-75.

APPROVED	N.V.S.	765-96-176	
CHECKED	M.M. S.		
CONTROLLERATE OF INSPECTION (ICV)		RETAINER	
		WEIGHT	SCALE
		0.005	2:1
		SHT	SHTS
		A/12 GOST 2685-75	

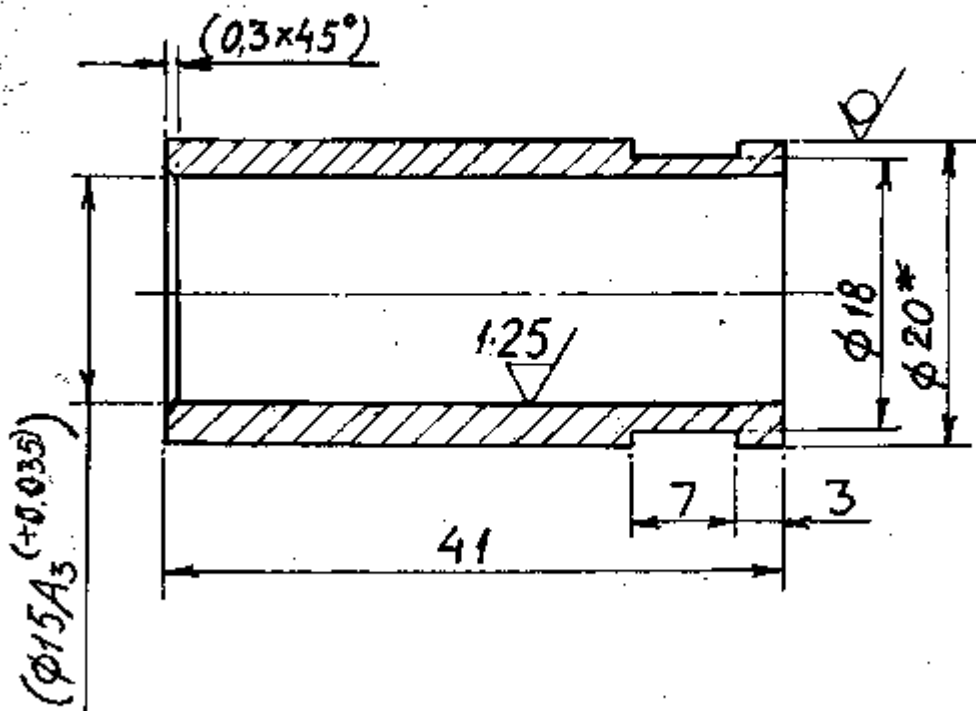


Thickness 0.3 ± 0.05

1. Deviation of centres of holes from their true position should not exceed 0.2 mm.
2. Perform dimensions without deviations with accuracy ± 0.5 mm.
3. Alternate material is packing board of grade 6, GOST 9347-74.

APPROVED	M. YASU	765-96-195		
CHECKED	DSKUMAR			
CONTROLLERATE OF INSPECTION (ICV)	GASKET		WEIGHT	SCALE
			0.0006	1-1
			SHT	SHTS
ELECTRICAL INSULATION BOARD		378 of 413		
FOCT 2524-75		10		

R=80

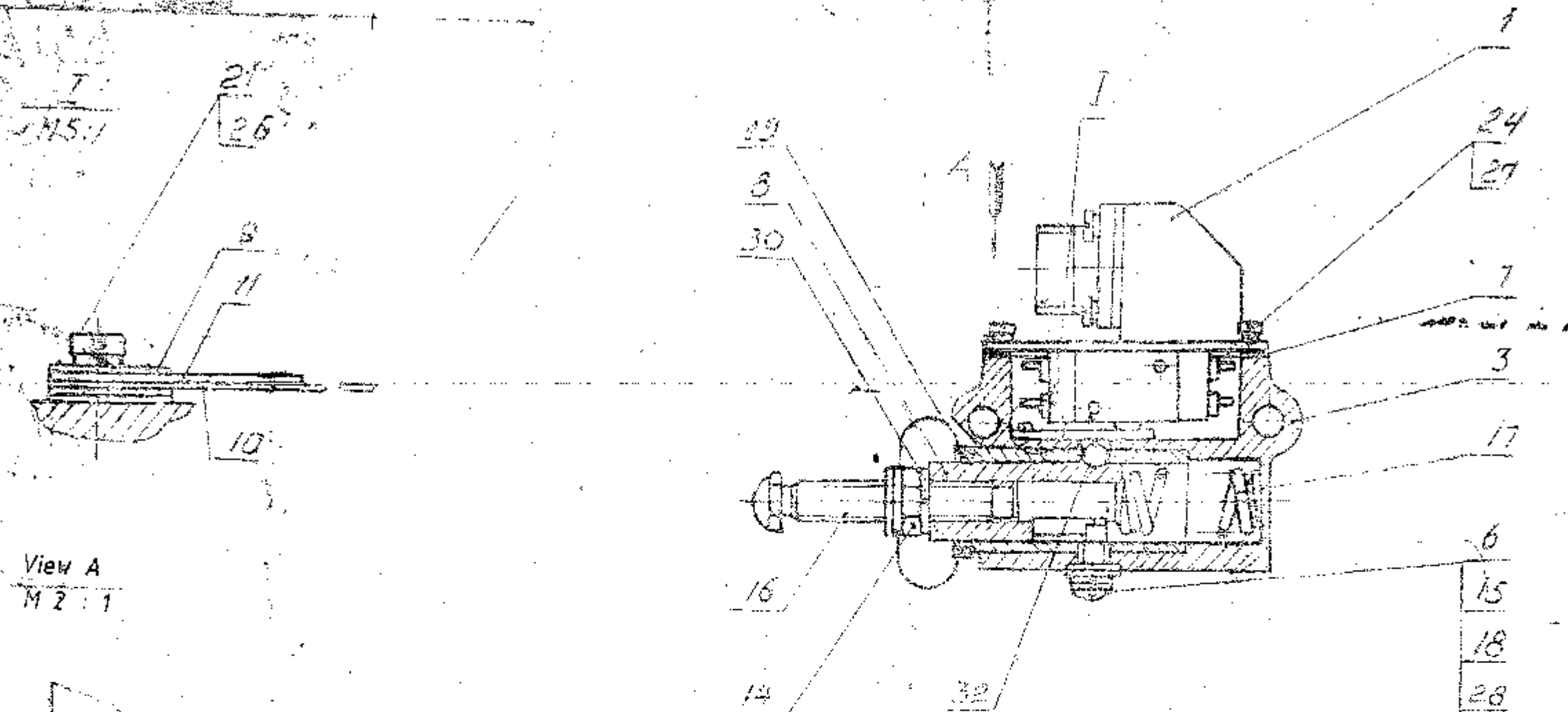


00755-14 V. R. RAO	EA. MATERIAL ADDED	
25-01-2000	ISSUE	NATURE OF AMENDMENTS

1. Alternate material is Ep. (Bronze) AX9-4 GOST 18175-78.
 2. Unspecified limit deviations of dimensions are :
for holes -as per A₇ and
for shafts -as per B₇.
 3. Dimensions given in brackets are after assembly.
 4. * Dimension is given for reference.
- (A) EQ. MATERIAL: AL. BRONZE GRADE AB₁ To IS: 305-81

APPROVED		765-96-351	
CHECKED		BUSHING	WEIGHT
CONTROLLERATE OF INSPECTION (ICV)			SCALE
		9045	2:1
ROUND BAR AKPHN 20-0HP Ep. AMU 9-2, GOST 1628-78		SHT	SHTS
			82

99/22-96-59L



1. Rod should move smoothly without jamming.
2. Set plate, Ref. No. 10, in such a way that ball in depressed position does not deform the plate. Adjust with gasket Ref. No. 9.
3. When the rod travels to a distance of 2.5 ± 0.5 microswitch contacts 1 & 2 should be opened and 3 & 4 closed. When the rod returns to initial position, micro-switch contacts 1 and 2 should be closed, 3 and 4 should be open. Adjust with gaskets, Ref. No. 7.
4. Lubricant and foreign particles on the parts of limit switch are not allowed. If necessary, wash the metal parts in hydrolisis alcohol.
5. After final assembly and adjustment of limit switch coat screws of cover, Ref. No. 1 and screw, Ref. No. 15, with red enamel PF-223 , Gost 14923-78 according to view A.
6. Other requirements are as per 765-96-TT101.
7. Before assembling, lubricate thread connections with a thin layer of lubricant AMC-3, GOST 2712-75 or MC-70, GOST 9762-76.
8. In case the screws, Ref. No. 21, project into cavity of bushing, mount required number of gaskets, Ref. No. 9 on plate, Ref. No. 11.

REF. NO.	DESIGNATION	DESCRIPTION	QNTY	REMARKS
1.	765-96-C6 143	Cover	1	
2.				
3.	765-96-C6 162	Body	1	
4.				
5.				
6.	765-96-16	Gasket	1	
7.	765-96-74	Gasket		4 max.
8.	765-96-119	Rod	1	
9.	765-96-121	Gasket	1	1 min, 6 max.
10.	765-96-151	Plate	1	
11.	765-96-152	Plate	1	
12.				
13.				
14.	700-30-455	Nut	1	
15.	700-35-368	Screw	1	
16.	700-35-408	Screw	1	
17.	700-38-1495	Sprig	1	
18.	700-40-153	Gasket	1	

19.	765-64-499	Cup	1	
20.				
22.				
23.				
21.	Screw M 2.6g x 6.48 .016 GOST 17473-72		2	
24.	Screw M 3.8h,6h x 8.48.016 GOST 17473-72 OR M 3.8h.6h. x 8.66.016 GOST 1491-72.		4	
26.	Washer 2T 65Г 05, GOST 6402-70		2	
27.	Washer 3T 65Г 05, GOST 6402-70		4	
28.	Washer .6T 65Г 06, GOST 6402-70		1	
32.	Ball- E-6mm φ , GOST 3722-60 and ETY 500-65		1	Commercial
30.	Washer 8H 65 Г 06, GOST 6402-70		1	

NO.	DATE	NAME	SIGN	DATE
1	17.10.84	R.H. Prasad		
2	18.10.84	Rajamohan		
3	19.10.84	S.R. Nair		
4	19.10.84	K. Banerjee		

765-96-C6 166

LIMIT SWITCH
(PUSH TYPE)

CIFE PUNE

SHEET	WEIGHT	SCALE
1		
TOTAL SHEETS	44	

Wires and plug connectors are conventionally not shown.

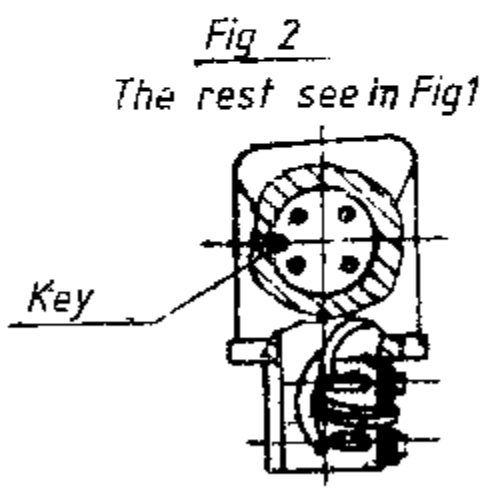
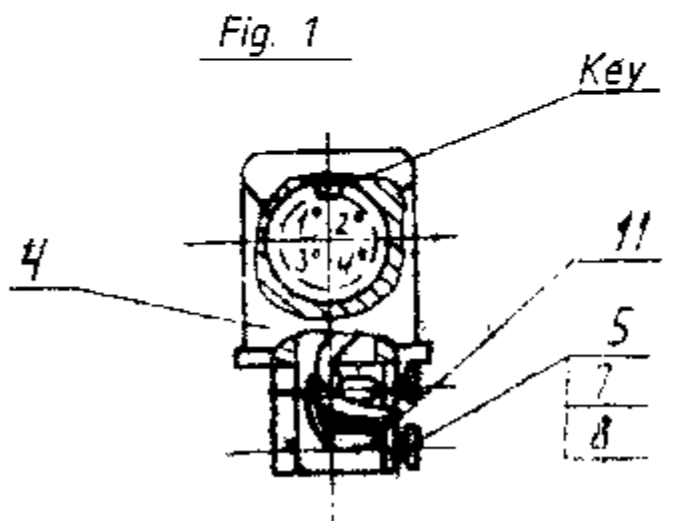
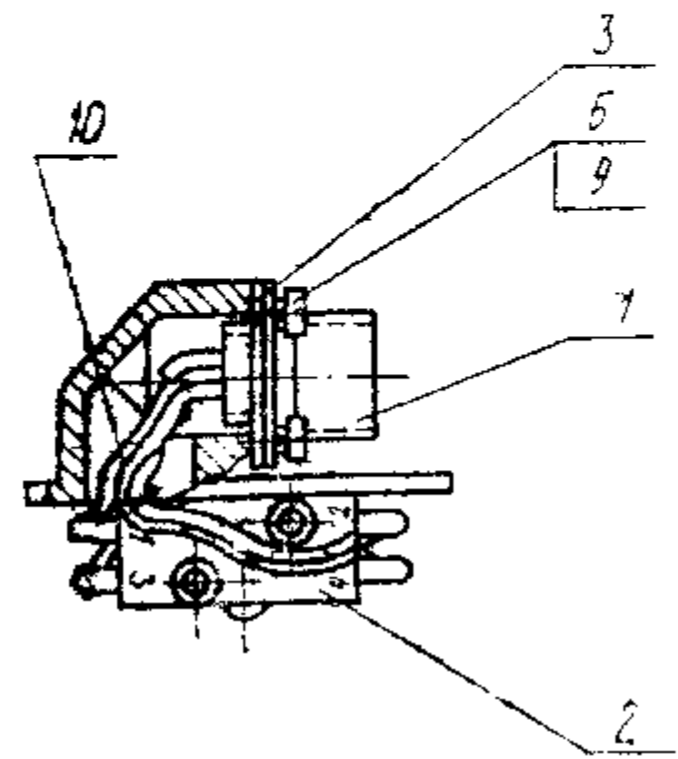
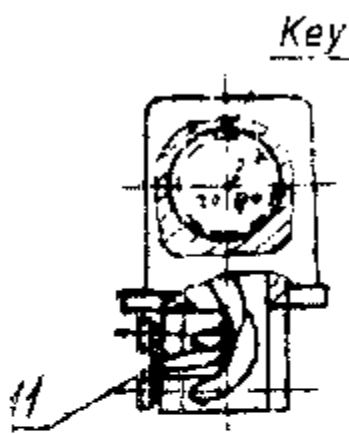


Table for soldering conductors:

Micro-switch.	Plug connector.
1	1
2	2
3	3
4	4

Fig 1 Alternate.

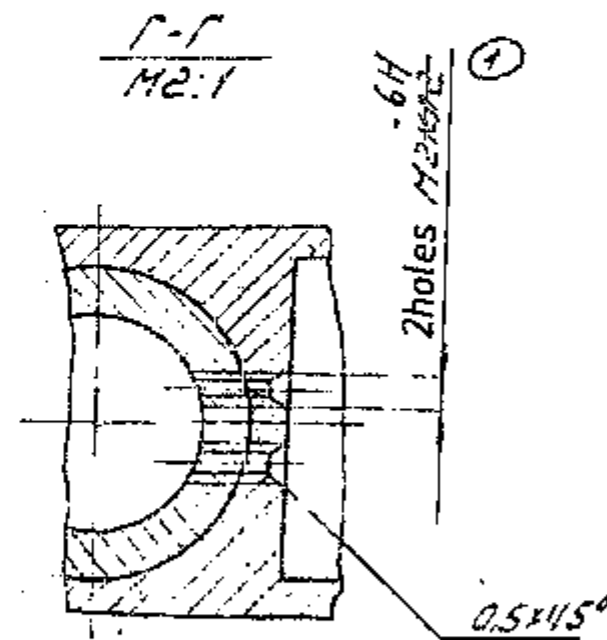
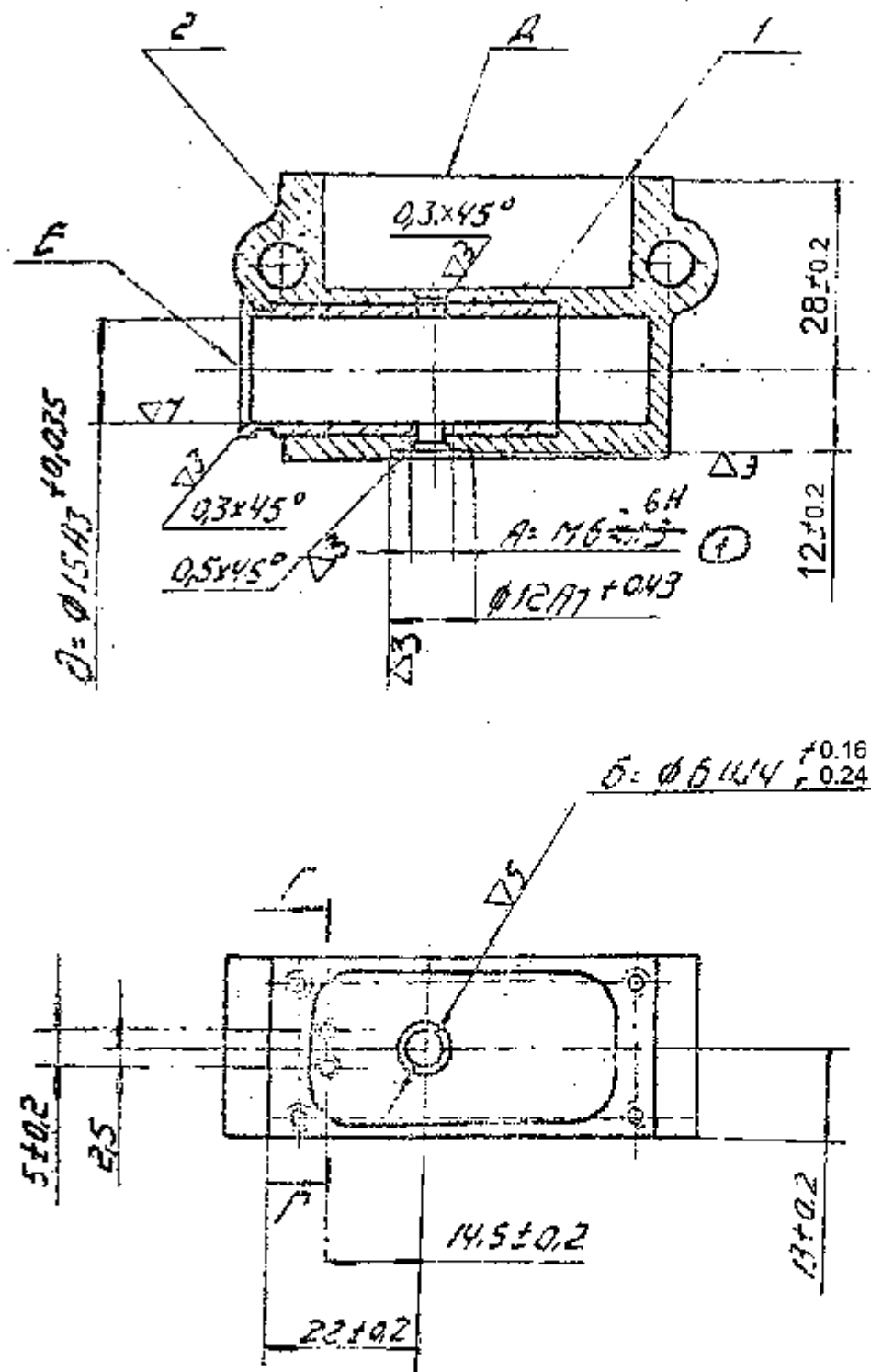


1. Termination of wires is as per PИ 700-88-TT2.
2. Braze using solder ПOC 61, ПРЗ, GOST 21931-76.
3. Slip PVC sleeves Ref. No. 13 over wire ends to micro-switch and sleeves Ref. No. 12 over wire ends to plug connector.
4. Secure sleeves with bakelite varnish of grade АБС-1, GOST 901-78.

Designation	Fig. No.
765-96-с0143	1
-01	2

REF. NO.	Designation.	Description	Qty.	Remarks
		Bakelite varnish of grade АБС-1, GOST 901-78		
13	Sleeve III TB-50-355-3.5, colourless GOST 19034-73. l=8		4	
12	Sleeve III TB-50-355-2.5, colourless GOST 19034-73. l=20		4	
7	Washer 2x1 01.019. or 2x1.02.019 GOST 11371-78.		2	
6	Screw M3.8h6hx8.48.016 GOST 17473-72 or M3.8h6hx8.66.016 GOST 1491-72.		4	
8	Washer 2T 65 F 05, GOST 6402-70.		2	
		Solder ПРЗ ПOC-61 GOST 21931-76.		
2	Micro switch А-703 HO.360.011.		1	Commercial
14	ПИ 42/1		8	
11	Wire MFWB-0.35 mm ² TY 16-505.437-73 l=90		2	
10	Wire MFWB-0.35 mm ² TY 16-505.437-73 l=60		2	
9	Washer 3T65F 05 GOST 6402-70.		4	
5	Screw M2. 6gx18.48.016 GOST 17473-72 or M2. 6gx18.66.016 GOST 1491-72.		2	
1	Plug 2PM 14 Б 441B1 FED.364.126TY		1	Commercial
4	765-96-73 or 765-96-143.	Cover	1	
3	765-96-15	Gasket	1	

765-96-с0143	
DESIGNER: DSKOMAR	SCALE: 1:1
CHECKER: [Signature]	DATE: [Blank]
COVER	
123 of 413	



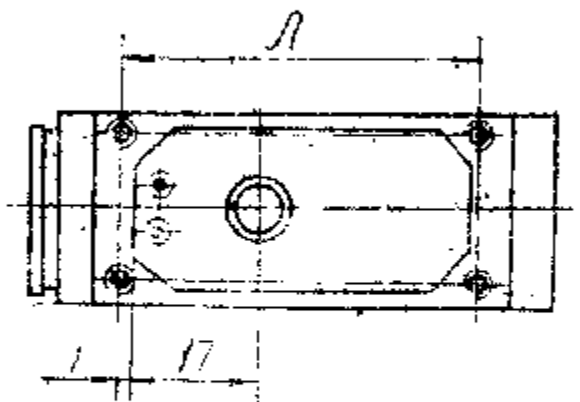
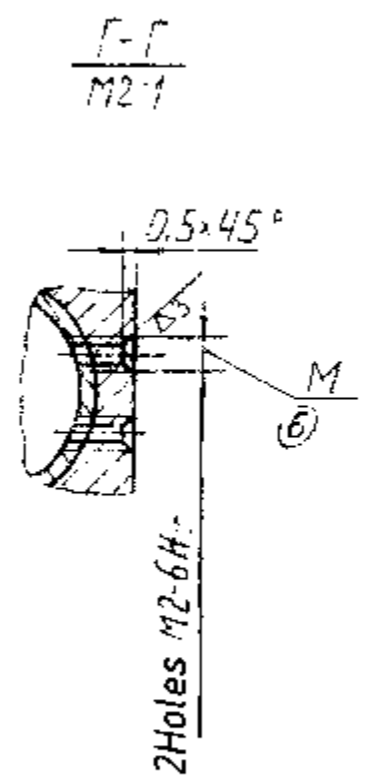
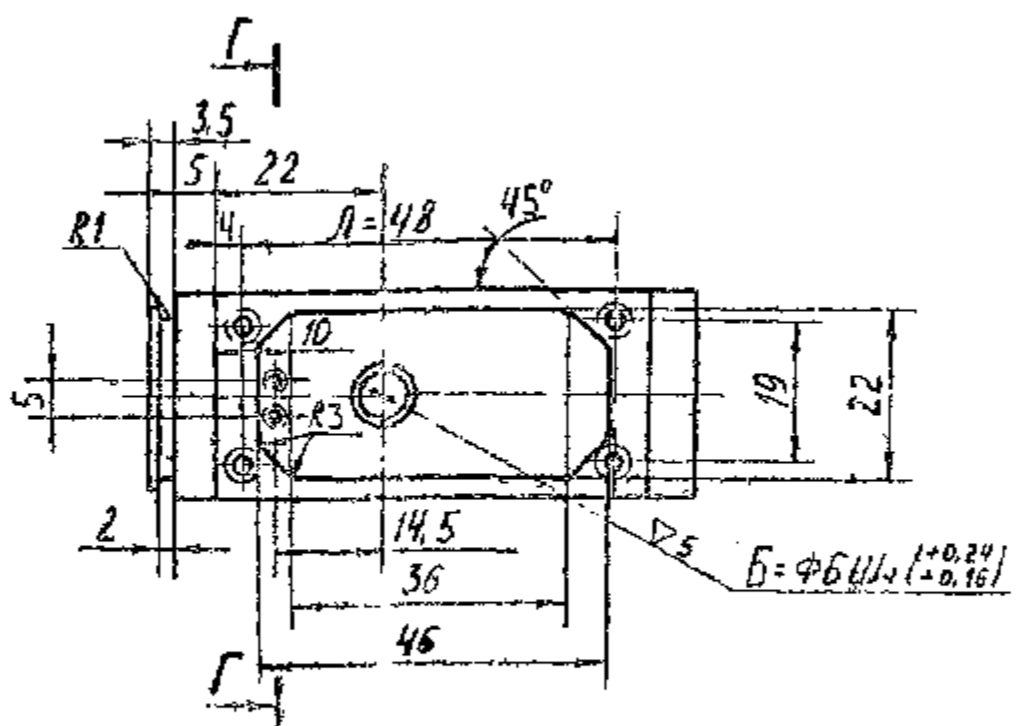
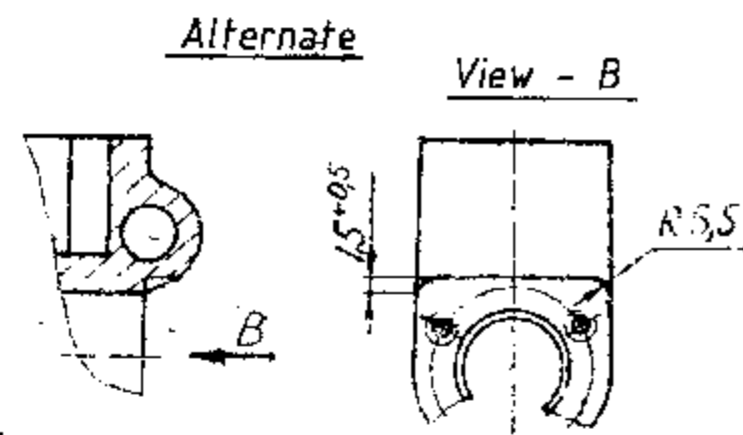
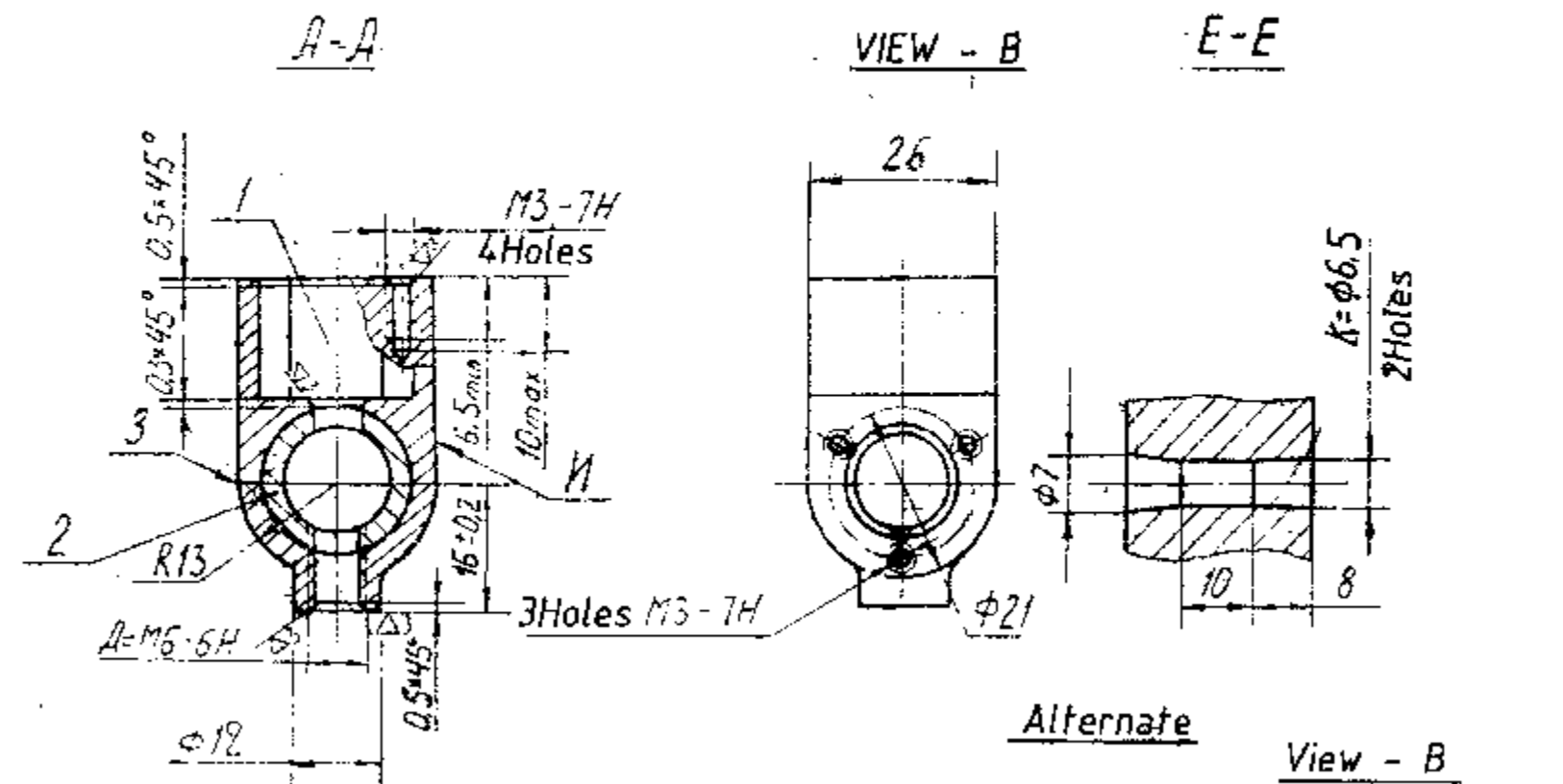
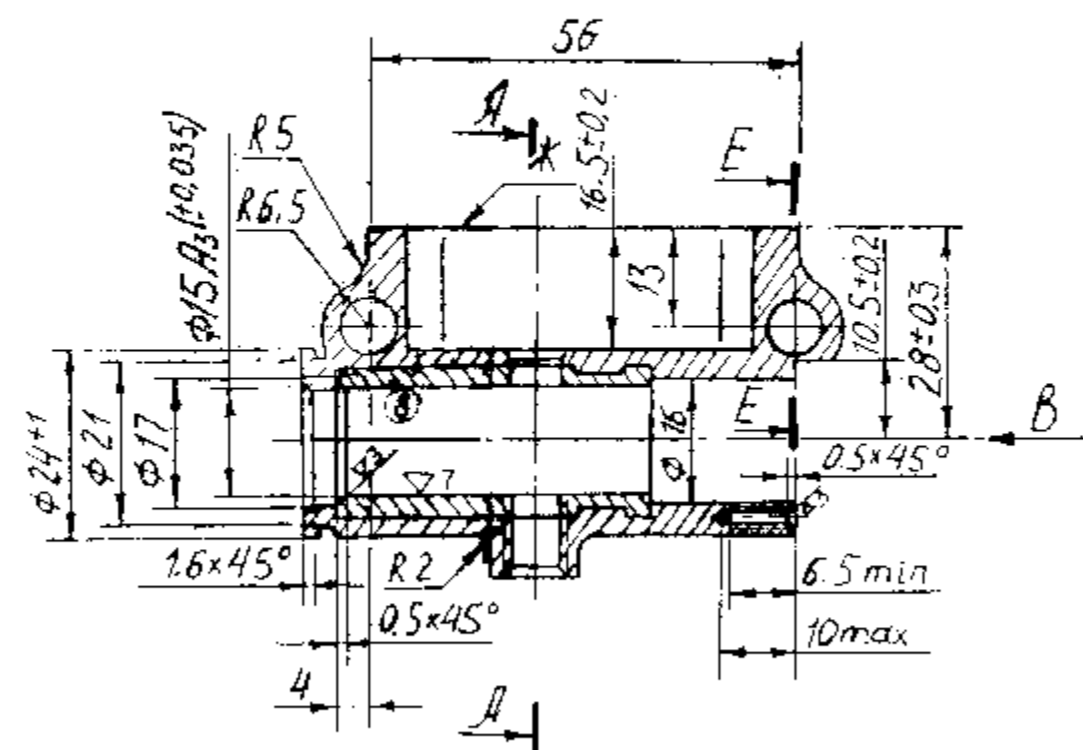
1. Blunt sharp edges.
2. Eccentricity of holes A and B should not exceed 0.1mm (Qualified tolerance).
3. Displacement of axis of hole B with respect to axis of hole A should not exceed 0.1mm.
4. Non-squareness of axis of hole B with respect to axis of hole A should not exceed 0.1mm.
5. Press-in the bushing upto the stop.
6. Coat the external surface except holes and plane D with Primer ФА-03-Ж, GOST 9109-76, paint with grey enamel МЛ-12 GOST 9754-76 and with silver enamel МЛ-165 GOST 12034-77.
7. Bushing may be cooled in liquid nitrogen before pressing.
8. Protect surface E from paint.
9. Surface D may be free from Anodized layer.

2	765-96-165 ✓	Body	1	
1	765-96-161 ✓	Bushing	1	
REF. No	DESIGNATION	DESCRIPTION	QTY.	REMARKS

APPROVED	<i>[Signature]</i>	765-96-СБ 162		61 of 180
CHECKED	<i>[Signature]</i>	BODY		
CONTROLLERATE OF INSPECTION ИСВ		WEIGHT	SCALE	
		0.148	1:1	
		SHT	SHTS	

DESIGNATION		DESCRIPTION	QTY	REMARKS
		Technical papers		
13	765-96-c8177CB	Assembly drawing		
		Parts		
64	1	765-96-202	1	W/O DRG.
11	2	765-96-351	1	
		Materials		
	3	Primer ФЛ-03-Ж GOST 9109-76		
	4	Enamel МЛ-12, Grey. GOST 9754-76		
	5	Enamel МЛ-165, Silver, GOST 12034-77		

APPROVED	<i>[Signature]</i> N VASU	765-96-C8177	WEIGHT	SCALE
CHECKED	<i>[Signature]</i>			
CONTROLLERATE OF INSPECTION (ICV)		BODY	SHT	SHTS
				(77)



- 1) Body Ref.no:1 should be made of material A/1-2 GOST 2685-75, Mass 0.14, in this case:
 - a) Alternate material for body, Ref.no:1, A/1-9 and A/1-9B, GOST 2685-75.
 - b) Coating: Anodically, oxidized, chromated or chemically parkerized, chromated, blue except part, Ref.no:2.
- 2) Coat external surface except holes and surface X with primer, Ref.no:3, and enamels, Ref.no:4 and Ref.no:5.
- 3) Unspecified limit deviations of dimensions are as follows: For holes -as per A₇ and for shafts -as per B₇.
- 4) Unspecified casting radii should not exceed 0.5 mm.
- 5) Pattern drafts should not exceed 1° towards the increase of body beyond tolerance.
- 6) Other requirements for casting are as per Technical requirements TTA/1-370.
- 7) Displacement of axes of holes K from true position should not exceed 0.25mm. of other holes, it should not exceed 0.2 mm.
- 8) Misalignment of holes B and D with respect to common axis should not exceed 0.1mm (qualified tolerance).
- 9) Knock-out traces not exceeding 1mm, in depth are allowed on surfaces 3 and M.
- 10) For holes M it is allowed to screw-in a no-go gauge upto bushing, Ref.No.2.

APPROVED	YASU	765-96-CB 177CB	
CHECKED		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (IEV)	BODY ASSEMBLY DRAWING	0.156	1:1
		SHT	SHTS

QUANTITY	ZONE	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
				<u>Technical papers</u>		
13			765-96-c8178CB	Assembly drawing		
			765-96-TT101	Technical requirements for mounting and checking of limit switches		
				<u>Assembly units</u>		
12	1		765-96-c8143	Cover	1	
13	2		765-96-c8177	Body	1	
				<u>Parts</u>		
(A)	5	765-96-74	LV2 RCV- 5330-009541	Gasket	3	Max qty
12	6	765-96-119		Rod	1	
	7	765-96-121		Gasket	5	Max qty.

APPROVED	<i>[Signature]</i>	H VARI	765-96-c8178 ^{57 of 180}	
CHECKED	<i>[Signature]</i>		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)			LIMIT SWITCH (PUSH TYPE)	
			SHT 1	SHTS 3

NO	SIGNATURE	DESCRIPTION	QTY	REMARKS
		Washers as per		
		GOST 6402-70		
23		2T65Г05	2	
24		3T65Г05	7	2 Off
25		6T65Г06	1	
26		8T65Г06	1	
		Other items		
28		Ball 5 $\sqrt{6}$ mm H		Commercial
		GOST 3722-60 and		
		ETY 500-65	1	

Difference in execution of 765-96-c6178CB and 765-96-c6178CB-01 are in accordance with Assembly drawing.

00421-ICV

But

FEB 94

D.C.C. NO.

DATE

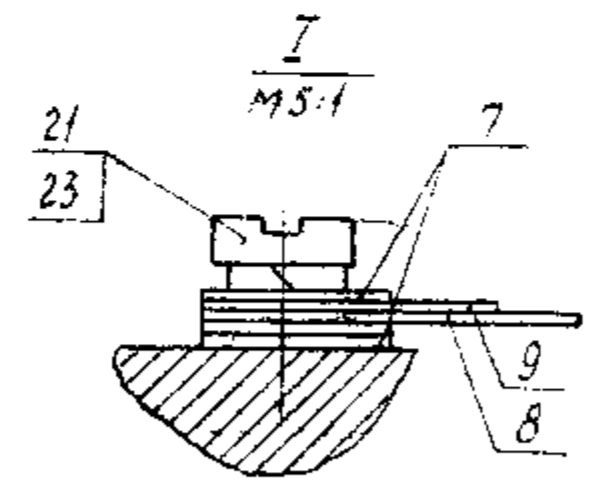
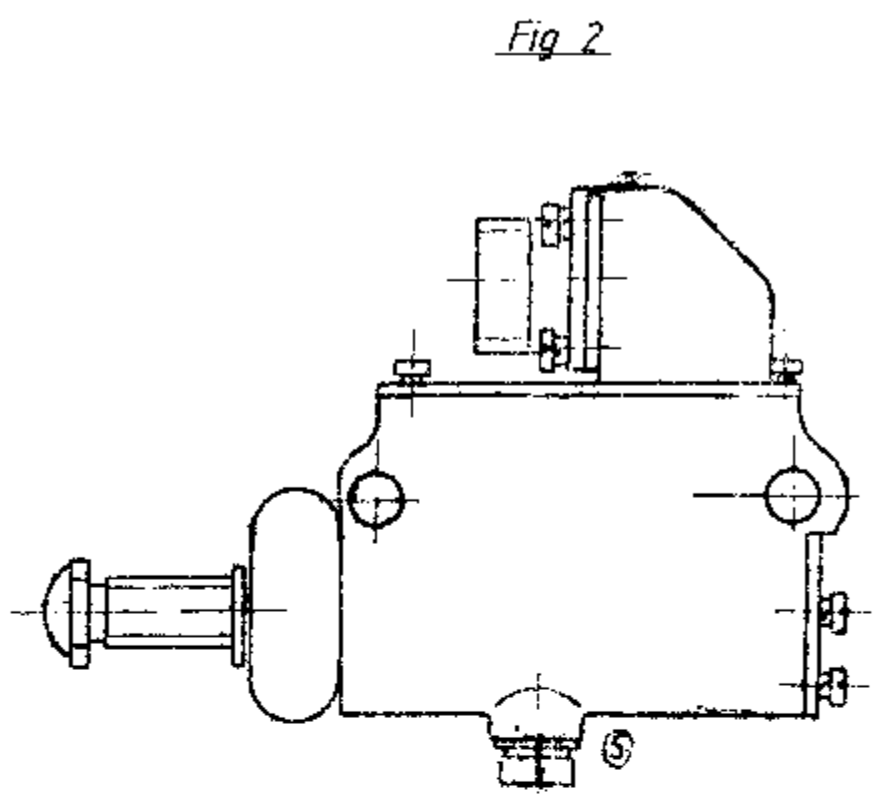
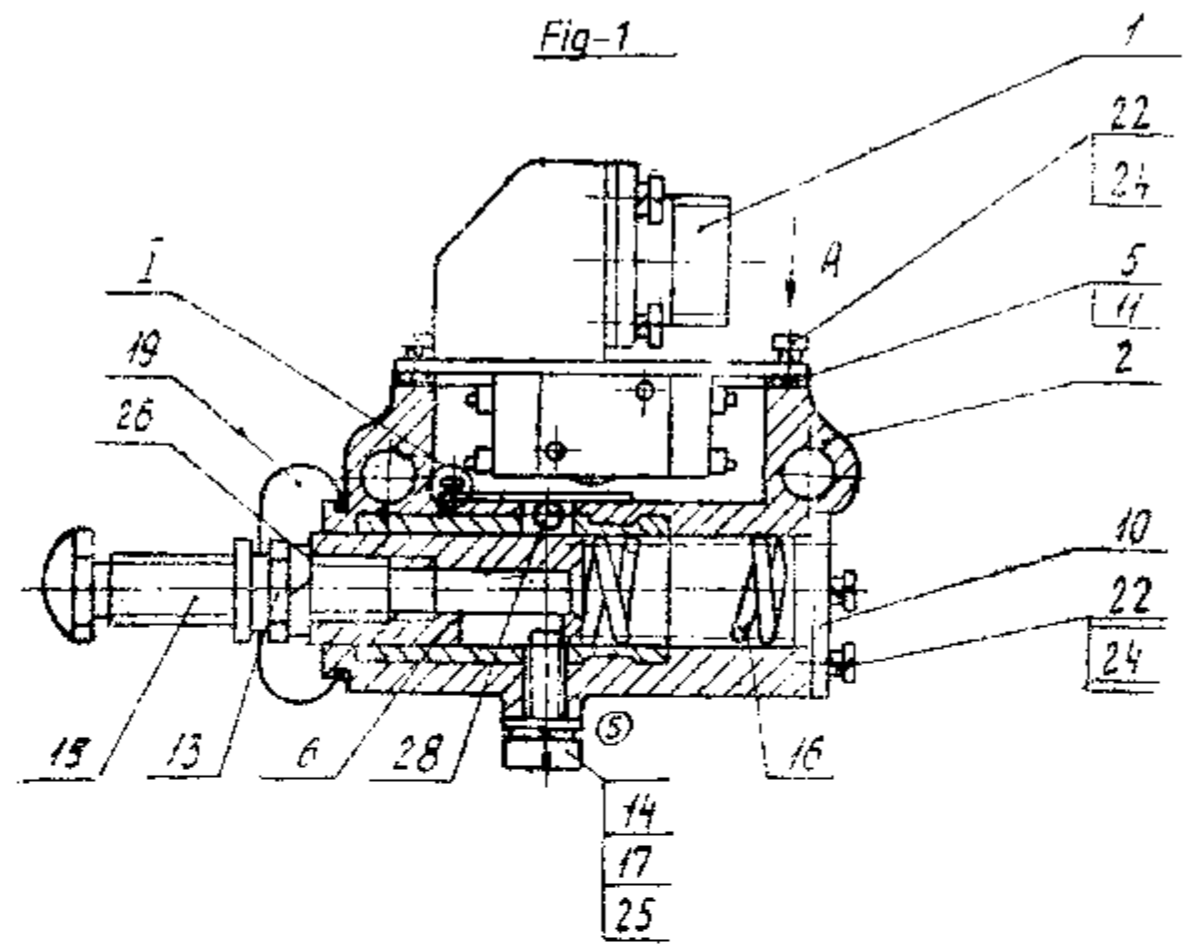
(A)

PART LIST REF. NO. 5, D.S. CAT PART NO. LV2/RCV/5330-009541 ADDED

ISSUE

AMENDMENT

APPROVED	<i>M VAGU</i>	765-96-c6178	59 of 180	
CHECKED	<i>R. K. Kan</i>		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)		LIMIT SWITCH (PUSH TYPE)	SHT 3 SHTS 3	



View-A.
M2:1



765-96-6178 C5	Fig 1
-01	Fig 2

- 1) The rod should move smoothly without jamming.
- 2) Set plate, Ref.No.8, in such a way so that the ball in depressed position does not deform it. Adjust using washers Ref.No 7
- 3) Set required number of gaskets, Ref.No 7 on plate, Ref.No.9, in case screws, Ref.No.21, project into the cavity of bush
- 4) Micro switch contacts 1 and 2 should be open while 3 and 4 closed during movement of rod by 2.5 ± 0.5 mm. When the rod restores to the initial position micro-switch contacts 1 and 2 should be closed and 3 and 4 disconnected. Adjust with gaskets, Ref.No.5 and Ref.No 11.
- 5) Lubricant and foreign bodies are not allowed on the parts of limit switch.
- 6) After final assembly and adjustment of limit switch, coat the cover screws, Ref.No.1 and screw, Ref.No.14 with red enamel $\eta\phi$ -223, GOST 14923-78, in compliance with view A.
- 7) Other requirements are as per technical requirements 765-96-TT101

APPROVED	<i>[Signature]</i> H VASU	765-96-6178C5	
CHECKED	<i>[Signature]</i>	LIMIT SWITCH(PUSH TYPE) ASSEMBLY DRG.	WEIGHT
CONTROLLERATE OF INSPECTION (ICV)			0.275
		SHT	SHTS