

QTY	ZONE	REF NO	DESIGNATION	DESCRIPTION	QTY	REMARKS
				<u>Technical papers.</u>		
12			765-71-c0564c0	Assembly drawing.		
				<u>Parts.</u>		
13 B	1		765-71-1525	Rotor	1	
12 B	2		765-71-1527	Flange	1	

765-71-c0564.

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

ROTOR.

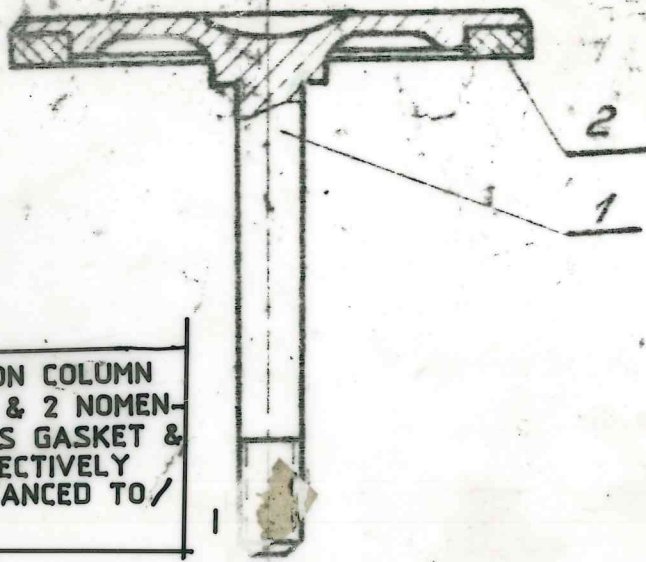
Easy2Convert
www.easy2convert.com

SHT. NO. 1 OF 1

USED ON
765-71-8535 1 3

USED ON
765-71-8535 1 2

52/11



ES/K7 /168	IN DESCRIPTION COLUMN FOR R. No. 1 & 2 NOMEN- CLATURE WAS GASKET & VALVE RESPECTIVELY DRG No ADVANCED TO/ A
19-4-02 /A.	
Lr.No.DT	AMENDME

1) Gasket is glued with adhesive 88-Hn, TY 38-105540-73
TECH. NOTES ADDED IN THE DRG. BASED ON AUTHENTICATED DRG
RECEIVED FROM CQAFE PUNE. Lr.No. CQAFE/IND-II/4503/GEN
DT. 13-12-04.

REF. No. 1 ADHESIVE 88 - Hn TY 38-105540-73 SEE SEPARATE SHEET
ATTACHED.

SD/-
(R. VEERARAGHAVAN)
SSO-II.

138/11 cr16

R.No	Designation	Description	Qty	Remarks
2	765-71-817	Valve GASKET	1	
1	765-71-816	Gasket VALVE	1	

PLEASE SEE OVERLEAF SKETCH

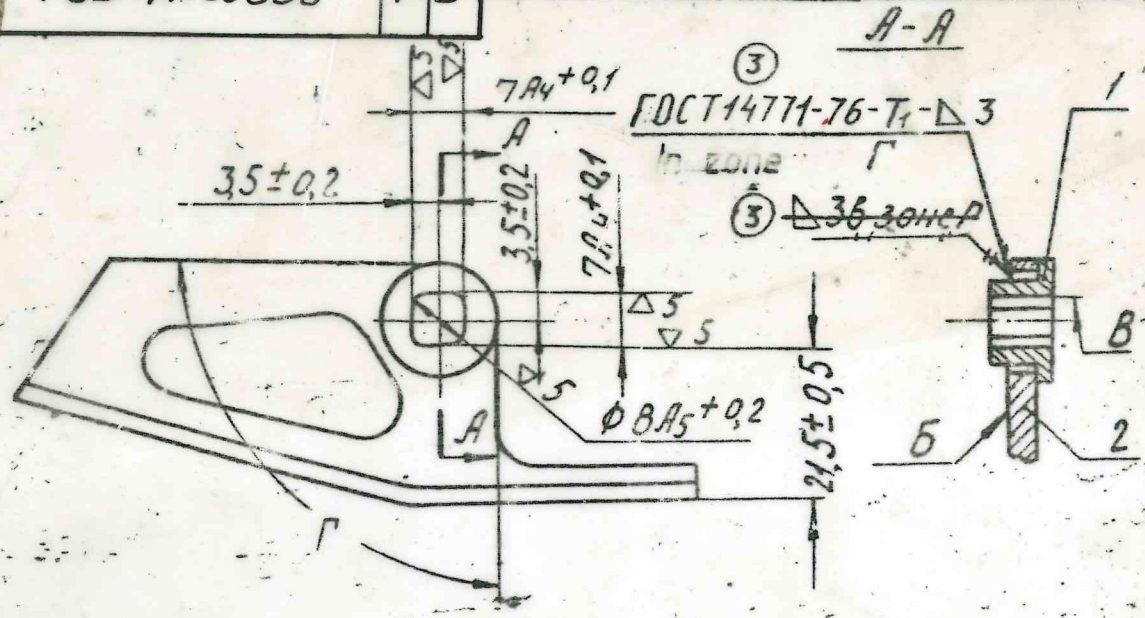
VALVE

765-71-8535
SHEETS WEIGHT SCALE
138 11
TOTAL SHEETS

SLNO SHEET DOCNO SIGN DATE
DRAWN BY Y.R.Ganesh 23.8.04
EDITED AND X B
CHECKED BY
OFFICER OF DC S.R.NAIR
DIVISIONAL OFFICER

USED ON
765-71-08356 1 3

USED ON
765-71-08356 1 2



- 1) Non-squareness of axis of surface B with respect to B is 0,8 max. over length 50 (Qualified tolerance).
- 2) Coating : Zinc-plated, 9 microns thick, chromated.
- 3) Hole B may be free From coating.
- 4) Welding may be done as per GOST 5264 .
- 5) Fused edes of bushing Ref. No. 1, to no more than 2,0 mm are allowed.

TECH. NOTES ADDED IN THE DRG. BASED ON AUTHENTICATED DRG
 RECEIVED FROM COAFE PUNE. Lr.No. COAFE/IND-II/4503/GEN
 DT. 13-12-04.

SURFACE FINISH:- ∇_5 - REFERSENTS SURFACE FINISH TO BE OBTAINED IN Ra VALUE 5 μ (max).

142
11/11/06

SD7-
(R. VEERARAGHAVAN)
SS0-II.

SR No	Designation	Description	Qty	Remarks.
2	765-71-820	Lever	1	
1	765-71-391	Bushing	1	

765.806-80
765.761-80

765-71-08359

NO. 101
7/26/07
STEEL
OFFICE

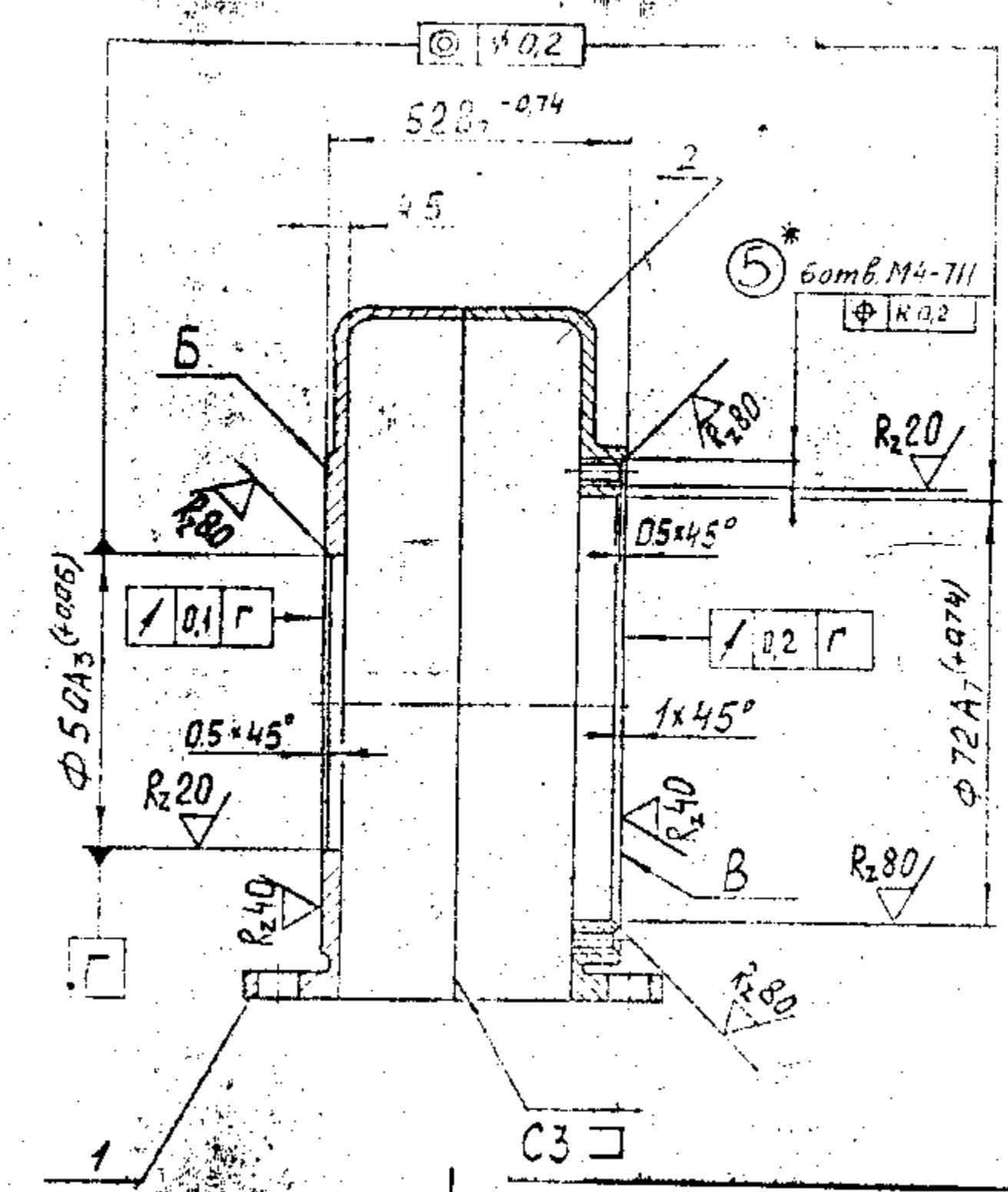
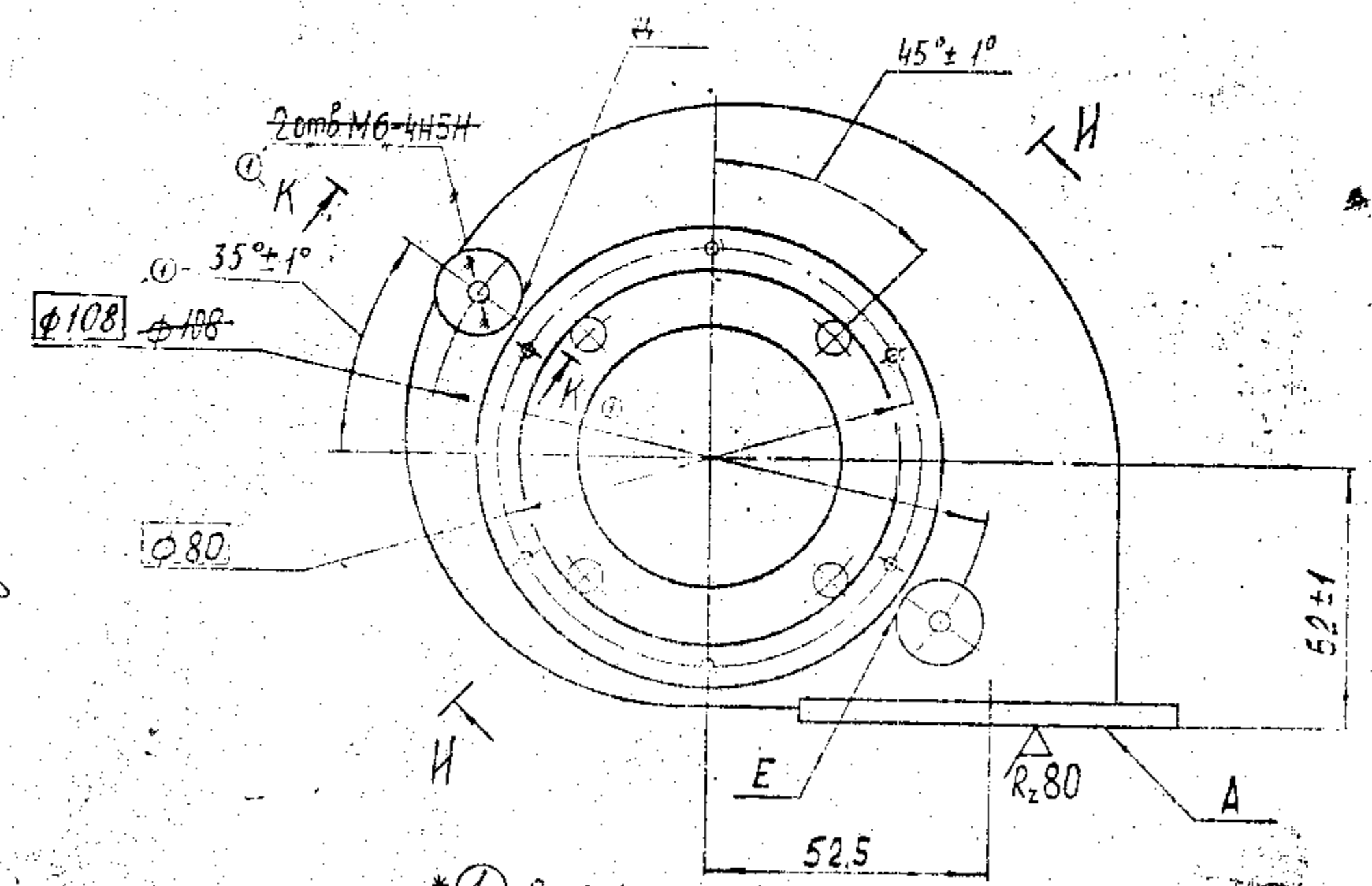
LEVER

SHEET WEIGHT 3045
TOTAL SHEETS

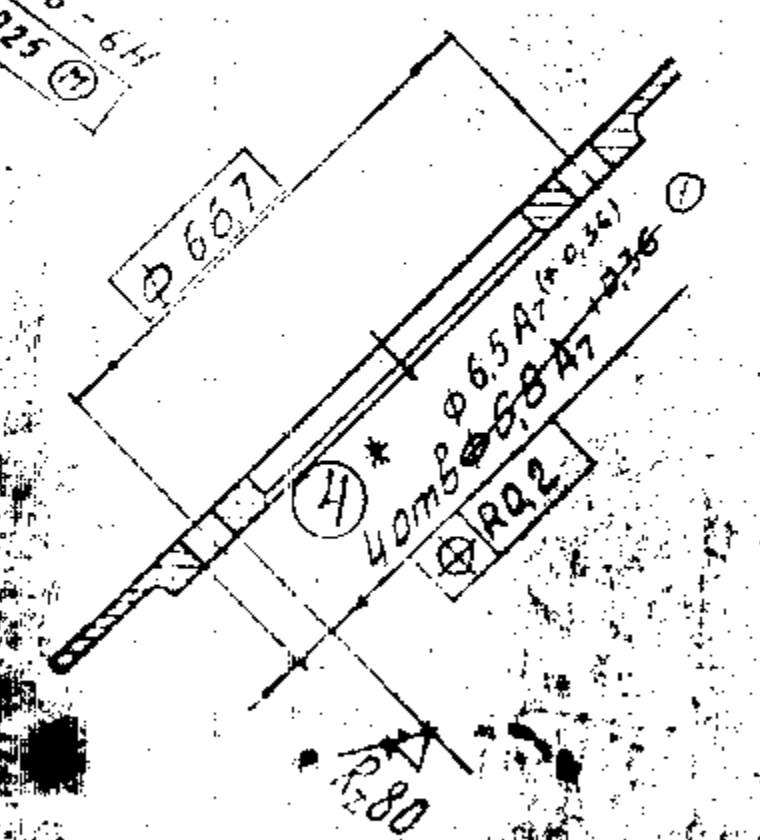
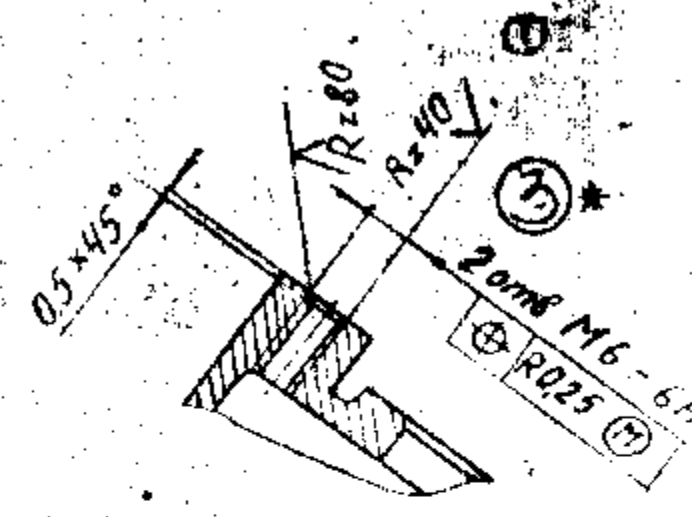
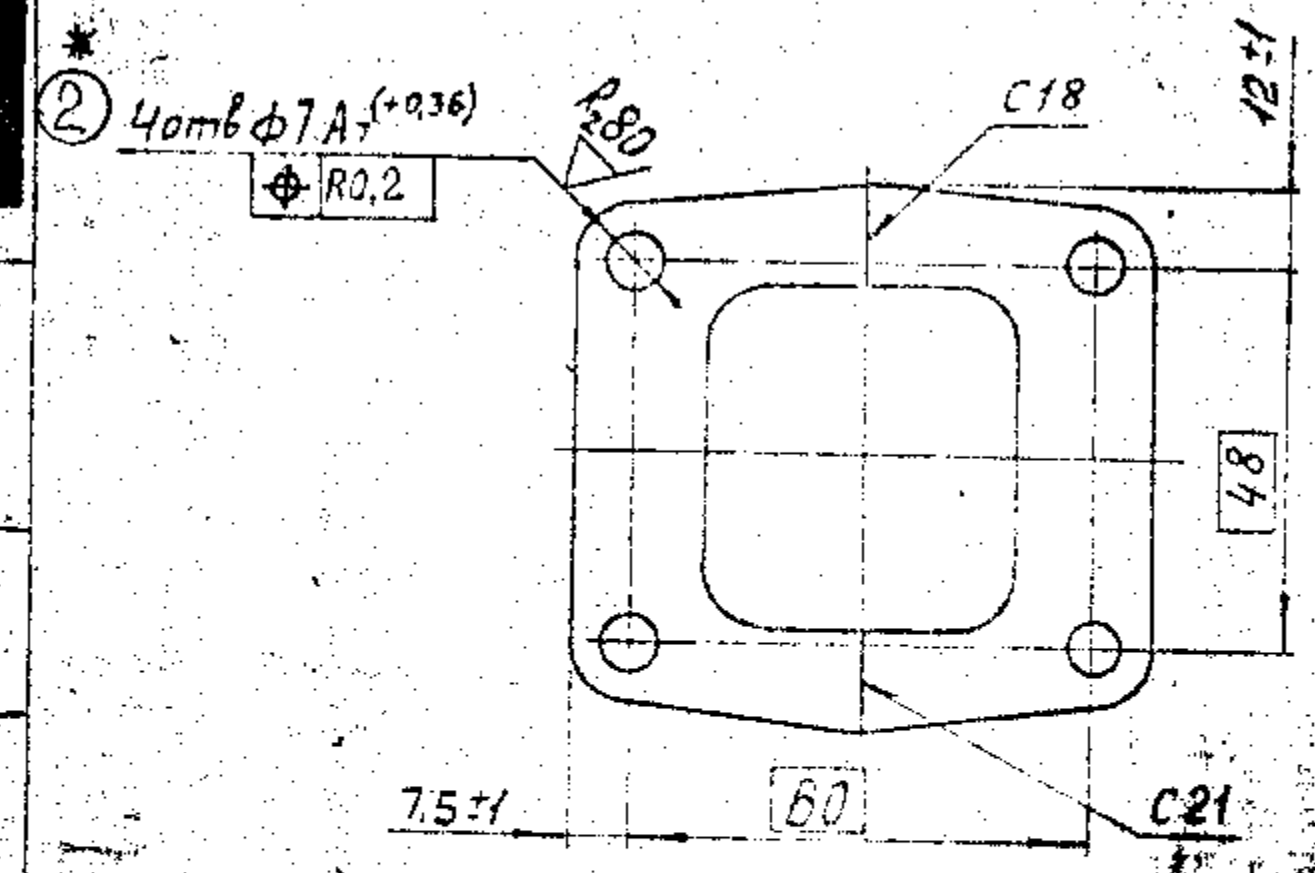
ORDNANCE FACTORY
PROJ
MODEL

Ref. No.	Designation	Description	Qty	Remarks
	765-71-c6629CB	<u>Documents</u> Assembly drawing		
		<u>Parts</u>		
1	765-71-1752	Wall	1	
2	765-71-1753	Wall	1	

APPROVED	<i>CPH</i>	765-71-c6629	
CHECKED	<i>SP</i>		WEIGHT SCALE
CONTROLLERATE OF INSPECTION (ICV)	VOLUTE	SHT	SHTS
			132



- * ① View K
- * ② Four holes
- * ③ Two holes
- * ④ Four holes
- * ⑤ Six holes



TECHNICAL CONDITIONS

1. Welds according to ГОСТ 14806-69.
2. Unspecified limit deviations of sizes - ±0.5 mm.
3. Coating: anodic oxidation with subsequent sealing in bichromate or chemically phosphatized, blue, Cr. Primer 6Л-03X ГОСТ 9109-76, enamel ИЭ-223, white 1, ГОСТ 14923-78 from outside, except for surfaces A, B, B and threads.
4. Tool marks not in excess of 2 mm deep on surfaces A and B of bosses are tolerable.

APPROVED		765-71-c6629CB	
CHECKED	P.K. BETH.	VOLUTE	WEIGHT SCALE
CONTROLLERATE OF INSPECTION (ICV)			0.39
			SHT
			132
			133

765-71-00491

1) Non intersection of axis of surface A and axis of surface B should not exceed 0,3 mm.

2) Non-squareness of surfaces A and B should not exceed 0,25 mm over a length of 25,0 mm.

3) Cut the common braid of conductors to electric motor over a length of 45 from its housing and remove the common PVC tube.

4) Cut the conductors running from motor, one over a length of 250 mm in 765-82-cb 283 and over 305 mm in 765-82-cb284.
 L from motor another over a length of 250 mm

5) Braid conductor 250 mm in length running from motor to 3 pins of connector and conductor "+" to 4 pins.
 Splice conductors as per PN 40/2 before brazing conductors to the connector, that is remove shield over length of 60 mm and dress core over a length of 7,0 mm.

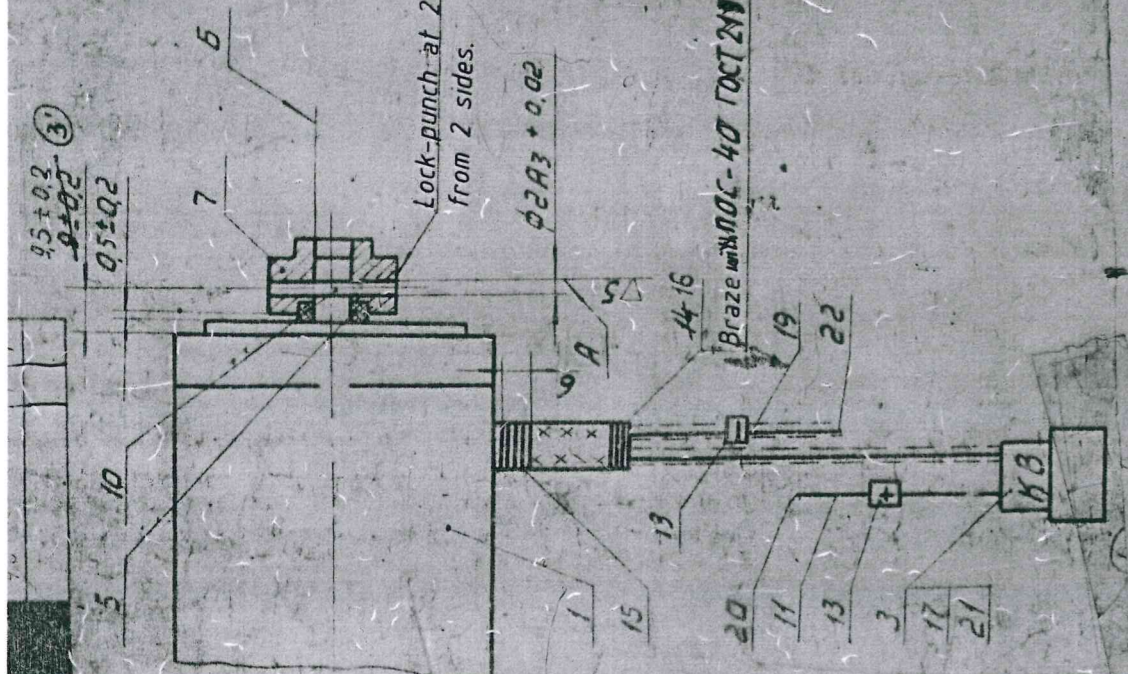
6) Perform splicing of conductors, brazing, and assembling of socket connector as per 700-88-TT2.

7) Purchase standard parts and materials necessary for splicing as per PN.

8) Slip braiding, 170 mm in length over conductor length of 250 mm, braid braiding of length of 80 mm to connector ring. Use braiding removed from conductors to electric motor.

9) Before mounting the oil seal Ref. No. 5 impregnate it with graphite lubricant (Ka 2/6 Г3, GOST 3333-80 as per Instructions 053,25289,00001.

10) Insulation resistance of current carrying parts of electric motor (in cold condition) measured by megohmmeter set at 100 V, should be not less than 20 megohms at ambient temperature of $20 \pm 5^\circ \text{C}$.
 Resistance measurements are carried out between pins (3,4) of socket connector and elector motor body.



DESIGNATION	REF. NO.	WEIGHT	REF. NO.
765-82-cb283	11	1,55	19
765-82-cb285	11	1,54	19
765-82-cb284	11		19

765-71-00497
765-71-00498

DESIGNATION	DESCRIPTION	Qty	Remarks
1	Electric motor A-55A, B 53, 121,020, TY.	1	Commercial.
3	Socket 2PM 14 КПЭ4ПВ1 ГЕ0.364.126 TY	1	Commercial
5	765-71-552	1	
7	765-71-872 or 765-71-1524		1 pc. when using 765-71-cb 425) 1 pc. when using 765-71-cb 564.
10	Lock pin 2 np 2 _{2a} x14	1	HB 255 to 207. ϕ 3,8 to 4,2 l.
11	See table		Conductor Е П В Л Э 0,5 TY 16-505,911-76.
13	MЖ A-25	2	Cup Standard 95.
15	Wire AKPHM 0,50 163, GOST 1066-75 l = 200		Coating 0,9.
16	Wire AKPHM 0,50 163, GOST 1066-75 l = 600		Coating 0,9
17	Tube III TB-50-355 - 3x0,4 unpainted GOST 19034-73., l = 15	2	
19	See Table		Braiding ПМЛ. 6x10 Ty 22-3708-76
20	See table		conductor splicing
21	ПН-56/1		as per 700-88-TT2
22	ПН-76/2		

225
71 cno

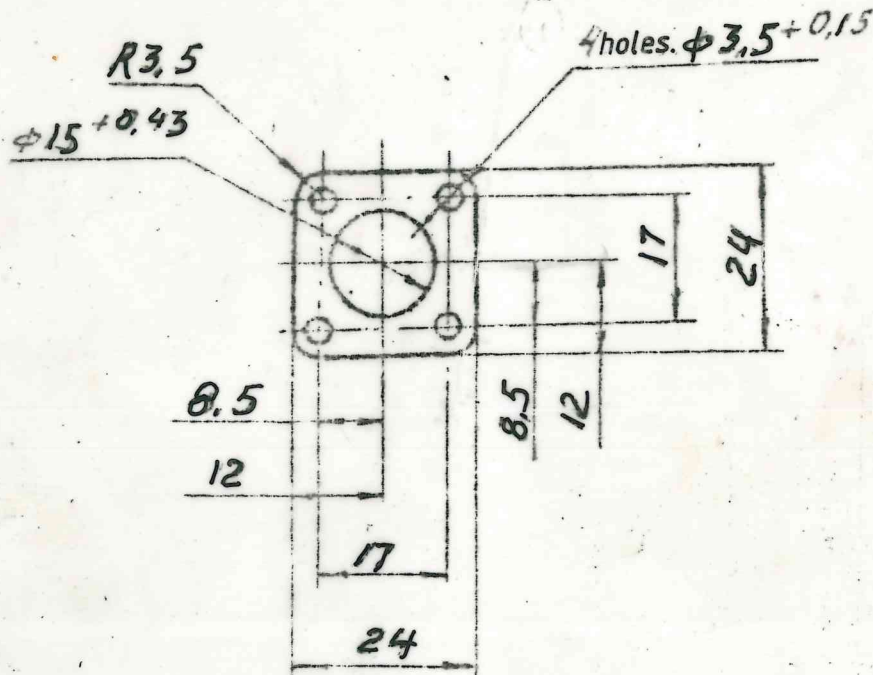
765-82-cb283/cb285

ELECTRIC MOTOR
MODIFICATION
(Table drawing)

SHEET WEIGHT SCALE
TOTAL SHEETS

USED ON
765-96-08143 1/2

H6
96



Thickness 1 ± 0.1 .

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.

D69

765-96-15

SNO	SHT	DOC NO	SIGN	DATE
DRAWN		P.R.BABU.		11.7.84.
EDT, CHKD		A. R. DUBEY	Am	12.7.84
F/M, DC		S. R. NAIR	br	12.7.84
DIV. OFFR.				
NAME				

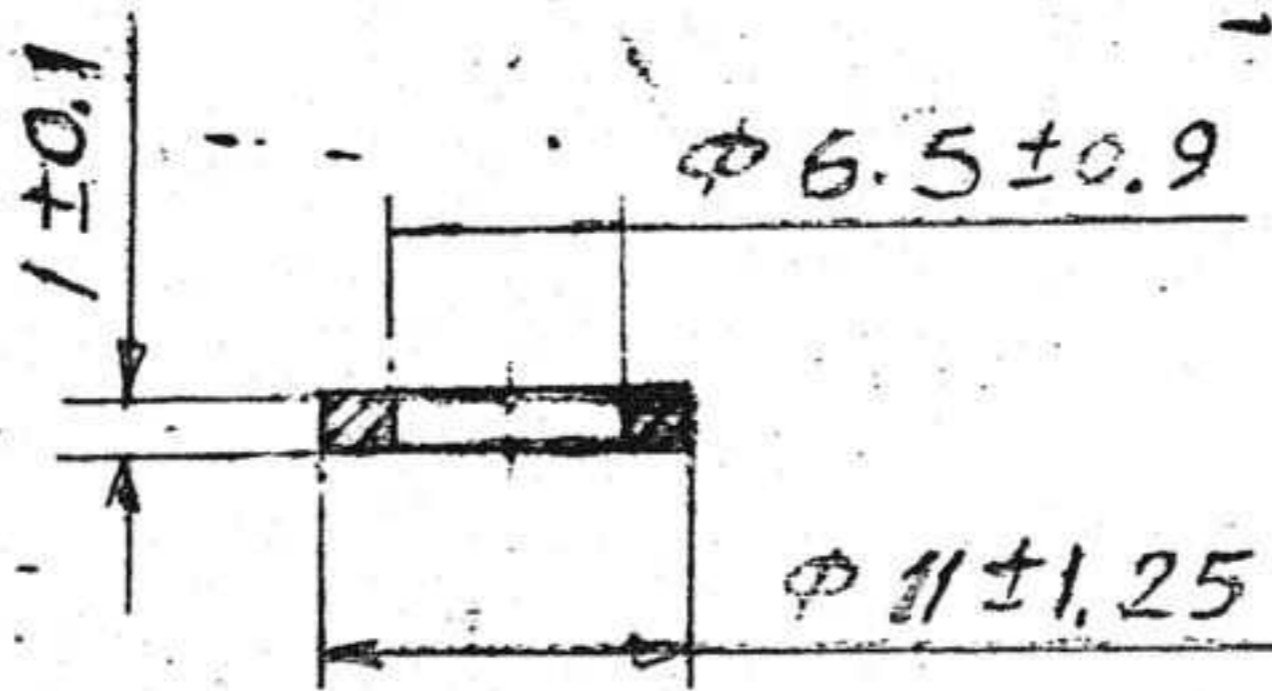
GASKET

Paronite NOH 1.0
FOCT 481-80.

SHEET	WEIGHT	SCALE
	0.0007	1:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT		

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

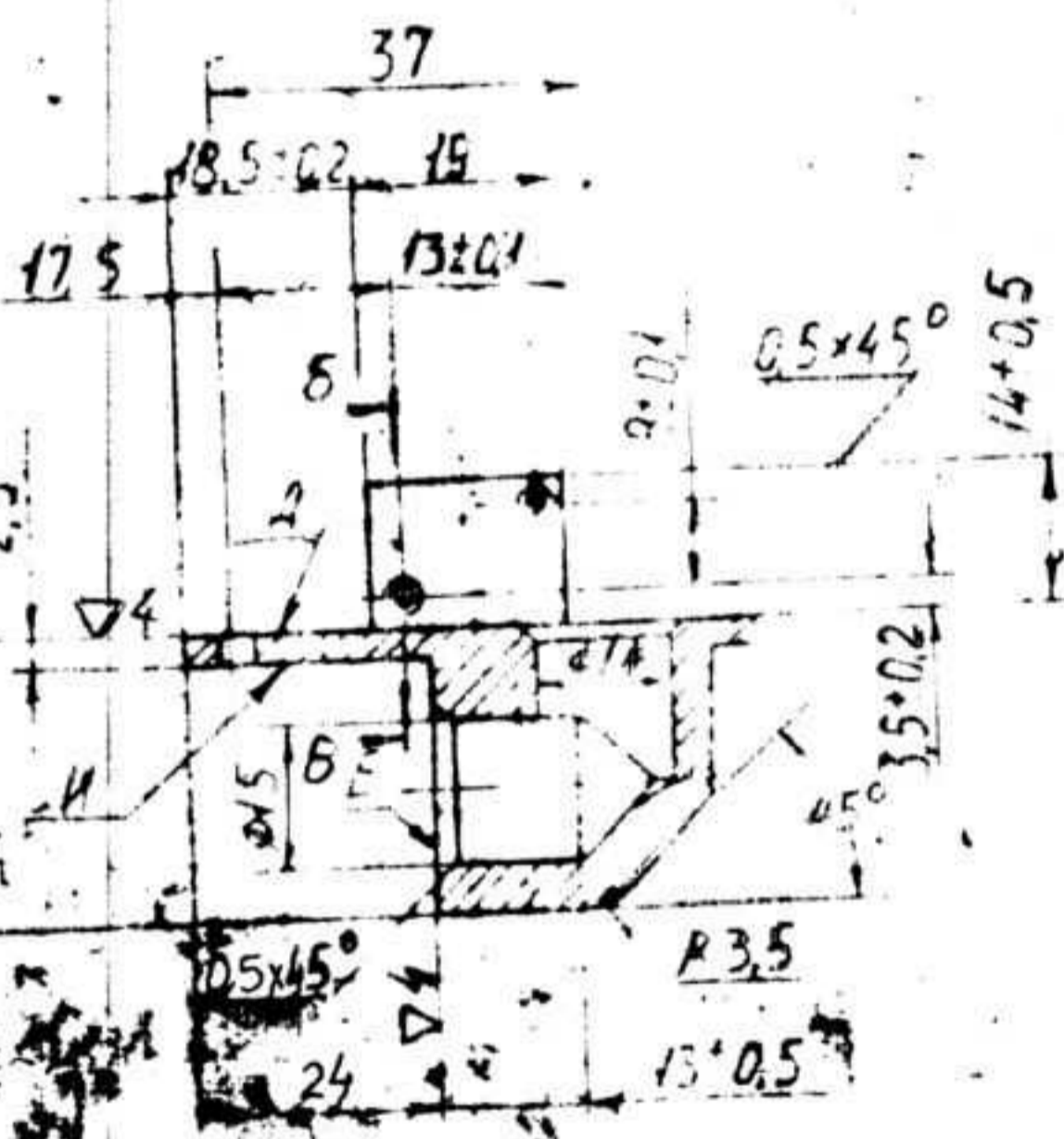
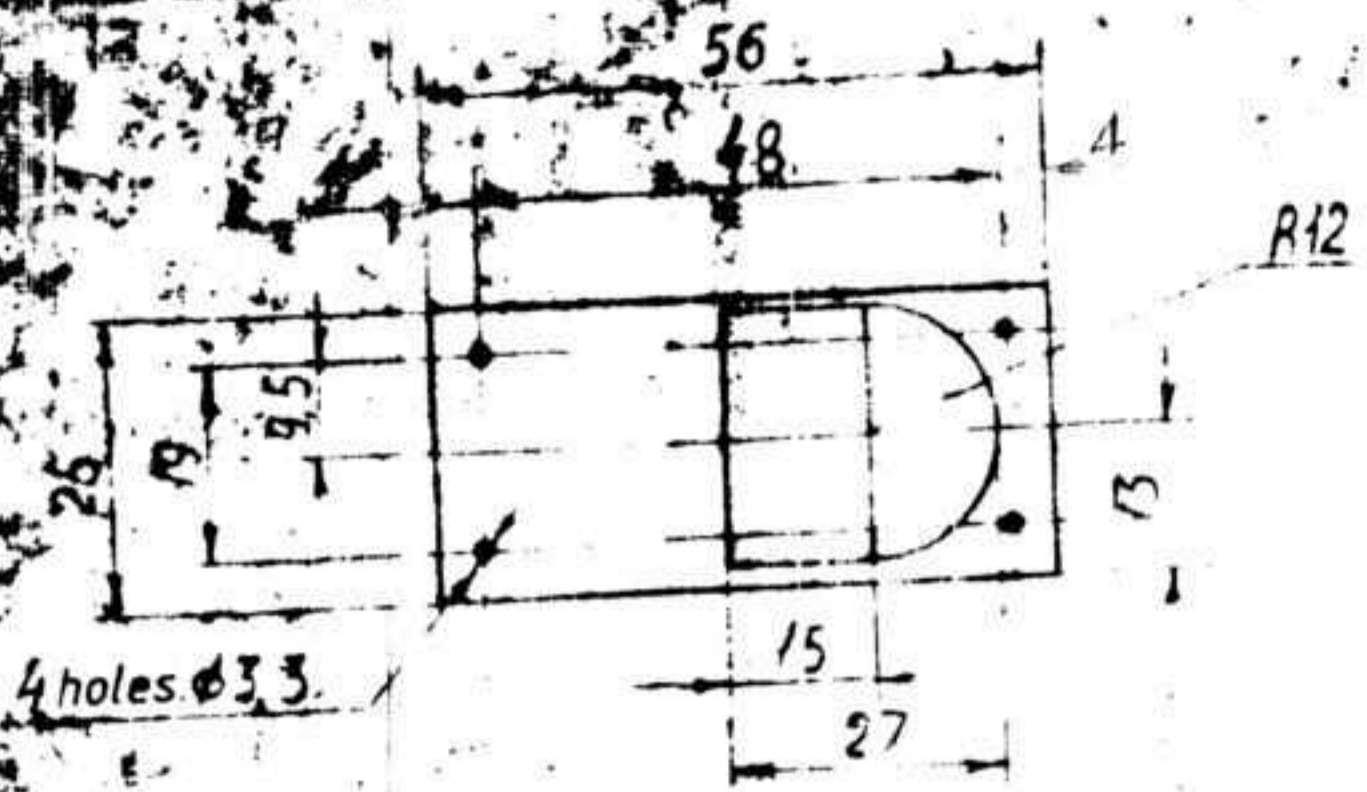
GASKET

Rubberised asbestos fabric
MOH-10
GOCT 481-80.

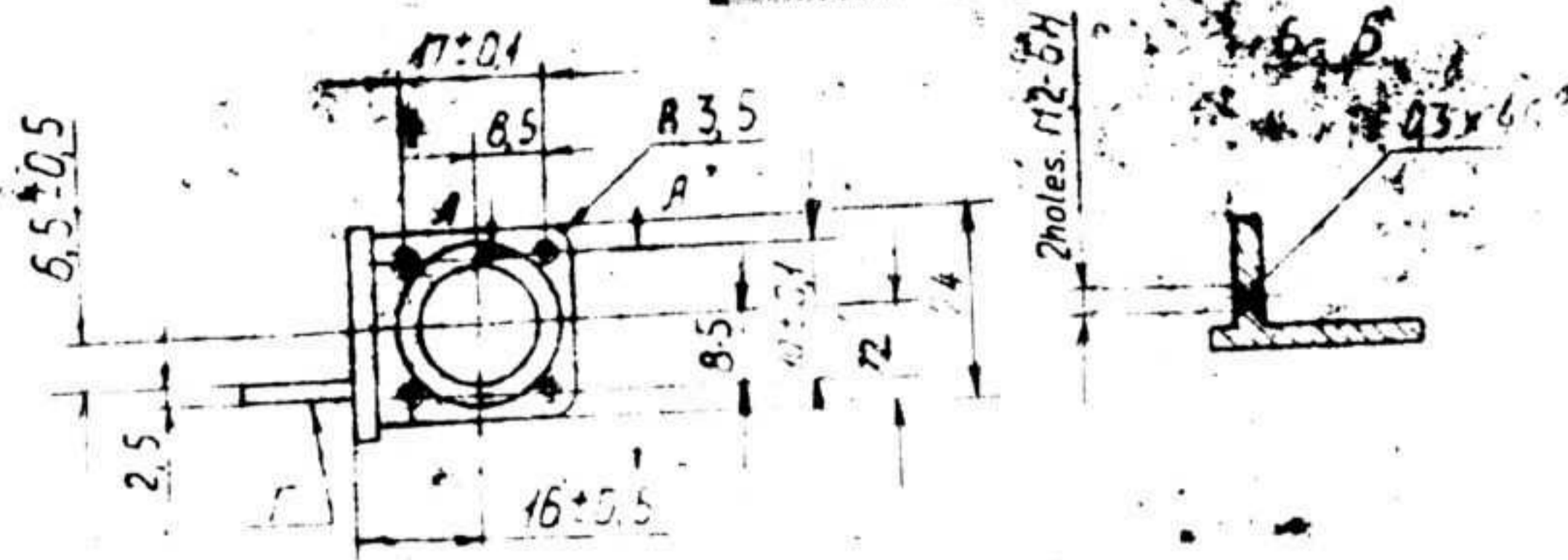
SHEET	WEIGHT	SCALE
765-96-16		
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

765-96-16

96-99



Unless otherwise specified.



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 $\Phi 1 - 03 \text{ K}$, GOST 9109-76 all over, except holes jaw Γ and surfaces A and E and paint with enamel $\Pi\Phi - 223$, dark grey, GOST 14923-78 or enamel $M\Lambda - 12H$, grey, GOST 9754-76 and enamel $M\Lambda - 165$, 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

SN	DOC NO	SIGN	DATE
DRAWN	P.R.BABU		11.7.84
EDT/CHKD	A.K. DODDAPATI		
F/M, D.C.	S.R. NAIR		12.7.85
DIV. OFFH			
	NAME	SIGN	DATE

765-96-73

COVER

A1 GOST 4784-74

SHEET WEIGHT, SCALE

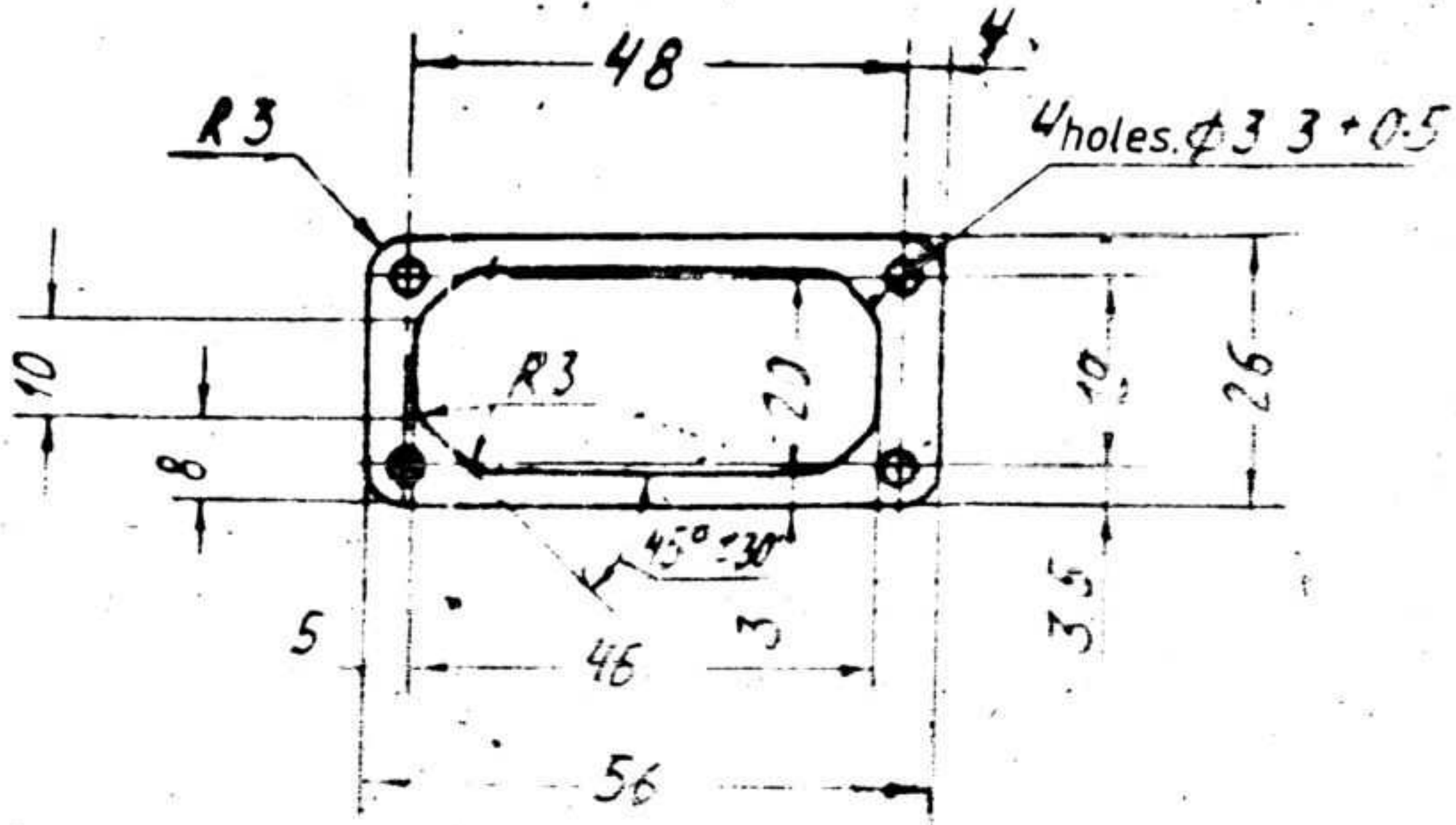
TOTAL SHEETS

ORDNANCE FACTORY PROJECT HYDERABAD

1-5-2/2

765-96-59L

2

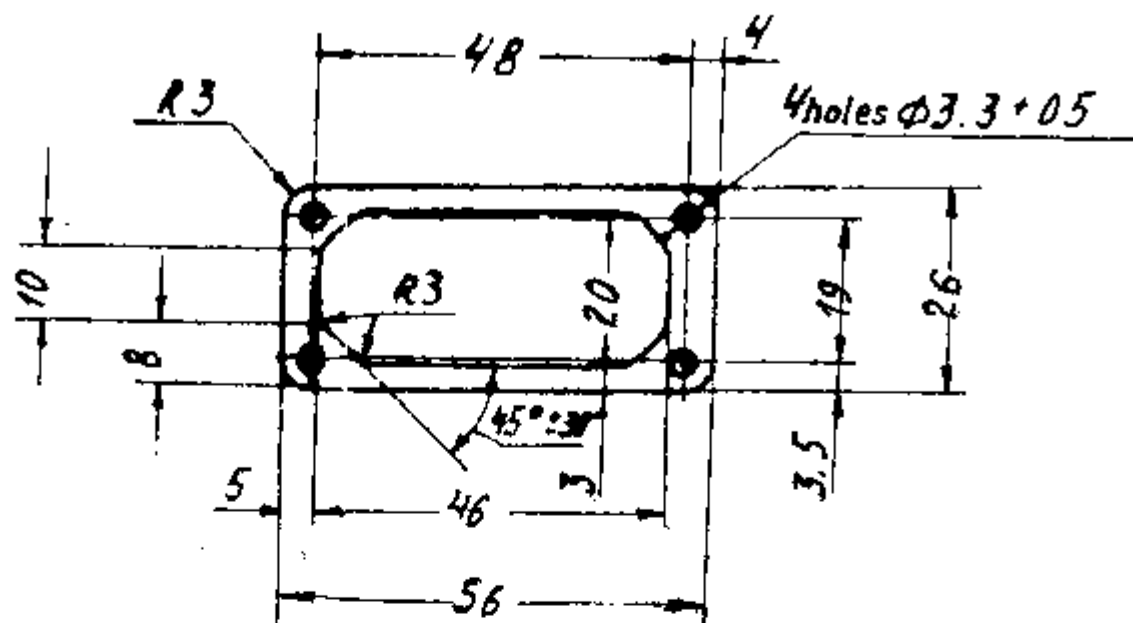


Thickness 0.5 ± 0.05

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

765-96-59L

SN	SHY	DOC NO	SIGN	DATE	GASKET	SHEET	WEIGHT	SCALE
		P.R.BABU.		11.7.86.			0.0007	1:1
		AK OUBAY	AK OUBAY	12.7.86.	Electric insulation board, grade 3B FOCT 2824-75.	TOTAL SHEETS		
		S.R. NAIR	82	12.7.86.		ORDNANCE FACTORY PROJECT HYDERABAD		



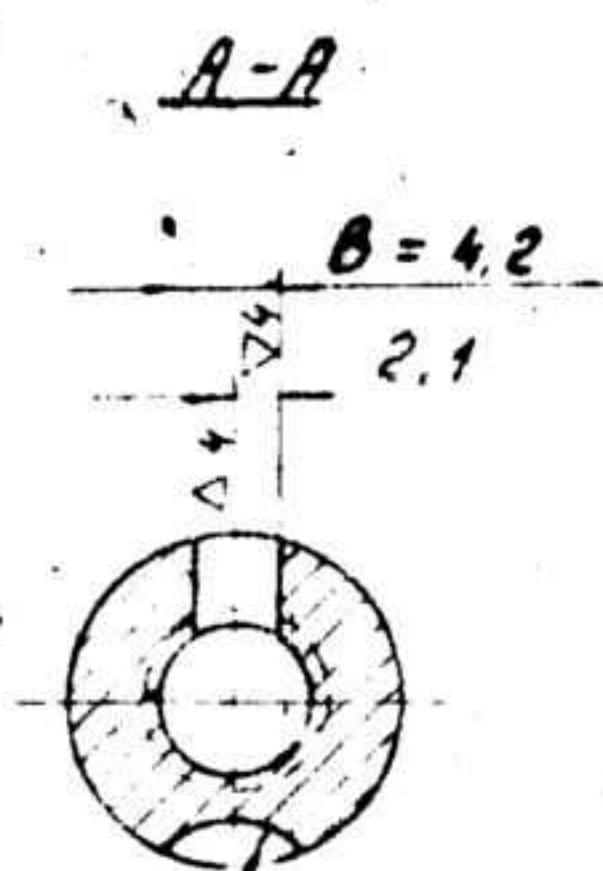
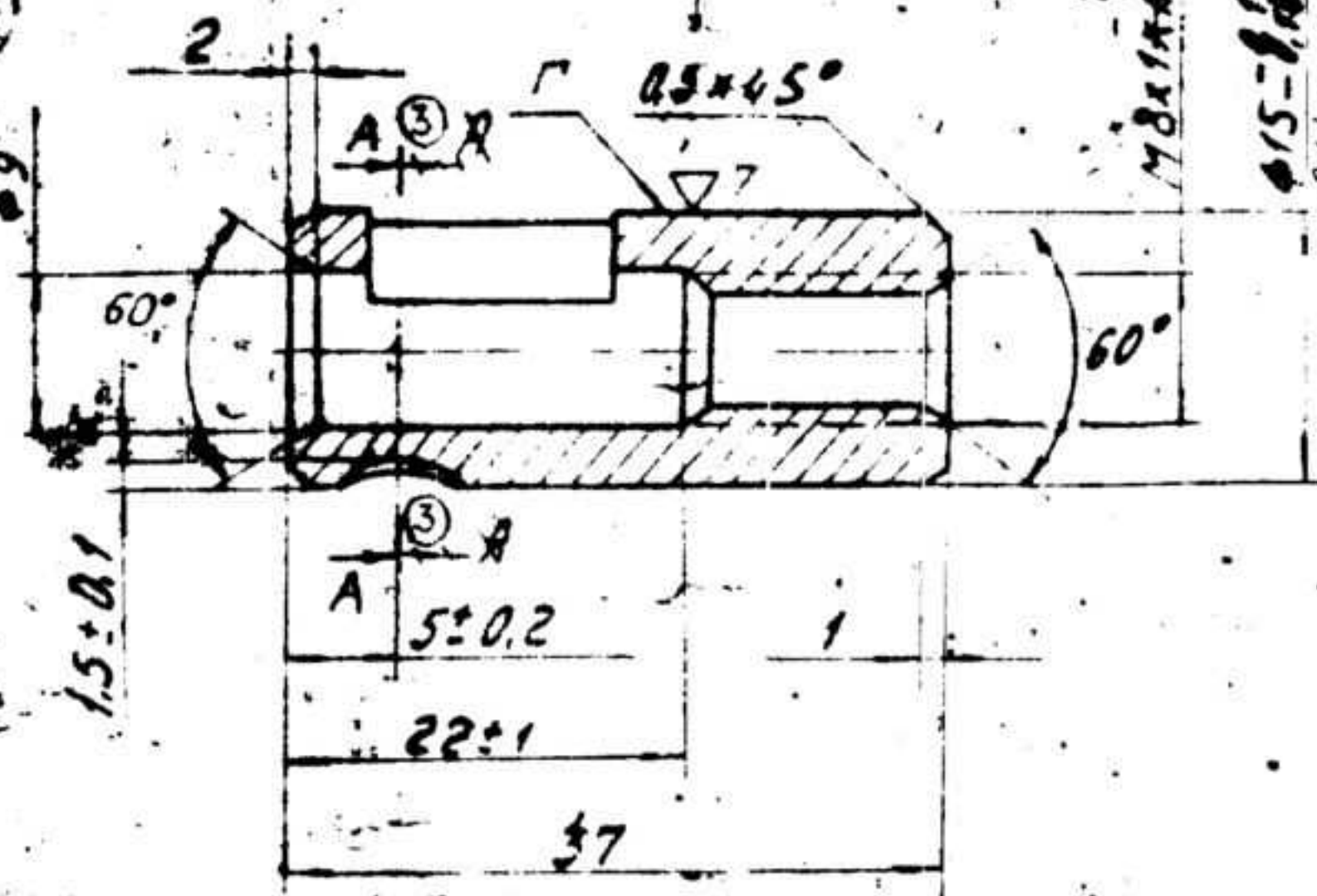
Thickness 0.5 ± 0.05

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.

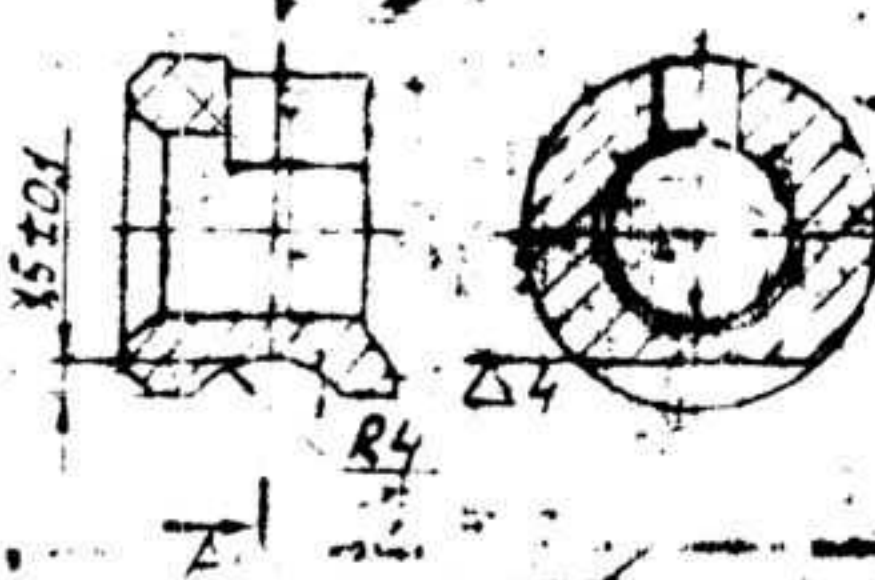
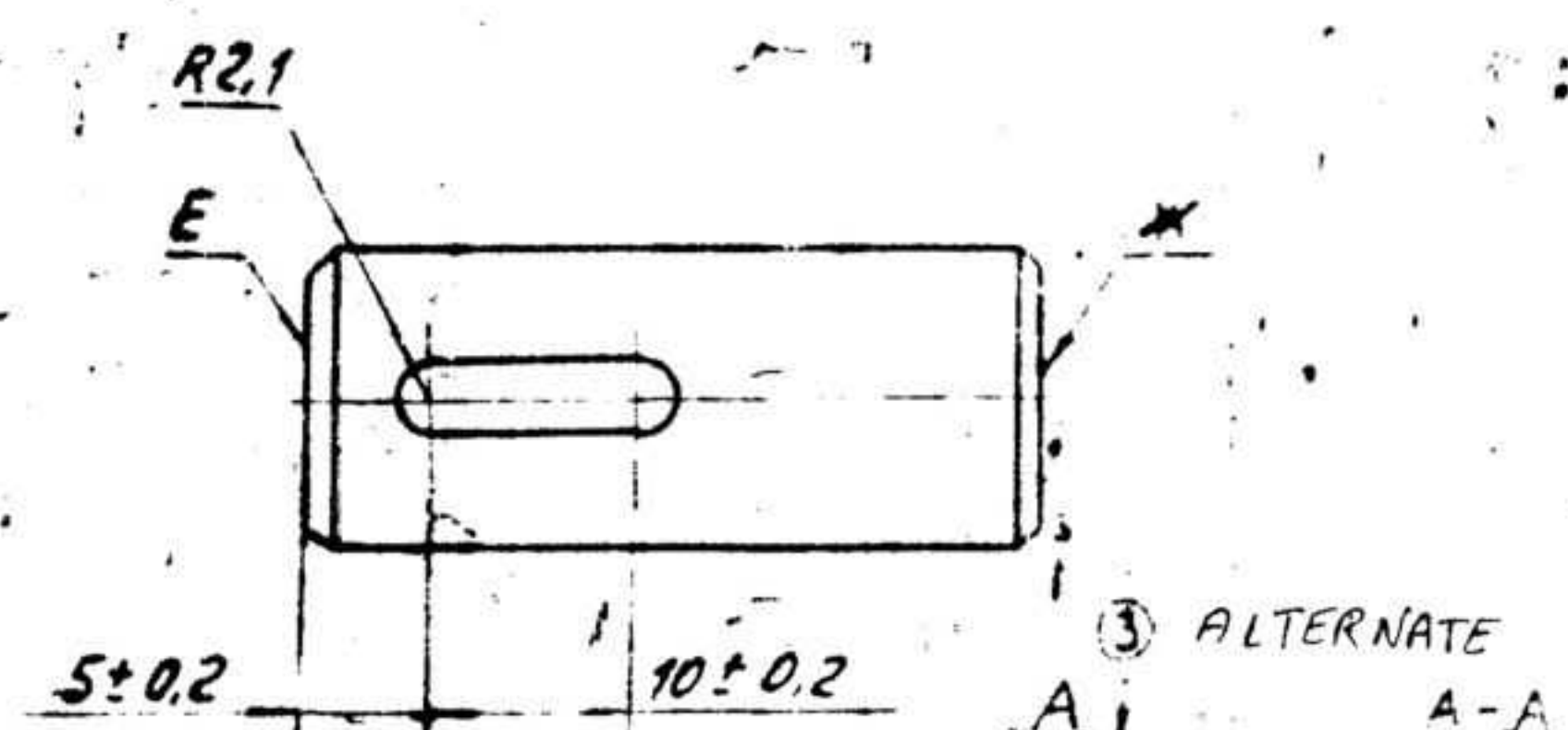
DD421-ICV Feb FEB 84	(A)	D.S.CAT. PART NO. ADDED
ISSUE NO DATE	ISSUE	AMENDMENT

APPROVED	M. V. S. S. L.	765-96-74	LV2/RLV. (A)	
CHECKED	R. V. S. S. L.	GASKET	5330.009541	
CONTROLLERATE OF INSPECTION (ICV)		Electric insulation board grade 3B GOCT 2824-75	WEIGHT	SCALE
			0.0007	7:1
			SMT	SMTS

Unless otherwise specified.



B = R4 SPHERE



1. Blunt sharp edges.
2. Provide dimensions without deviations as per accuracy class 7, OST 1010.
3. Brinell hardness is 302 to 255 ($\phi 3,5$ to 3,8).
4. Eccentricity of crescent B and slot B should not exceed 0,1mm (qualified tolerance).
5. Coating of surfaces B, Γ , E, χ and chamfers 0,5 is chrome-plating 18 to 24^{with} 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 Γ should not exceed 0,1mm (qualified tolerance).

5-222CY mod 10/25/0111

DATE: 255-96-419

SN/SHI	DOC NO	SIGN	DATE
DRAWN	V.J.RAO		31.8.84
EDT,CHKD	D.K.JAIN		1.9.84
F/M,DC	S.R.NAIR		1.9.84
DIV.OFFR	K.BHARGAVA		3.9.84
	NAME	SIGN	DATE

ROD

45X GOCT, 4543-71

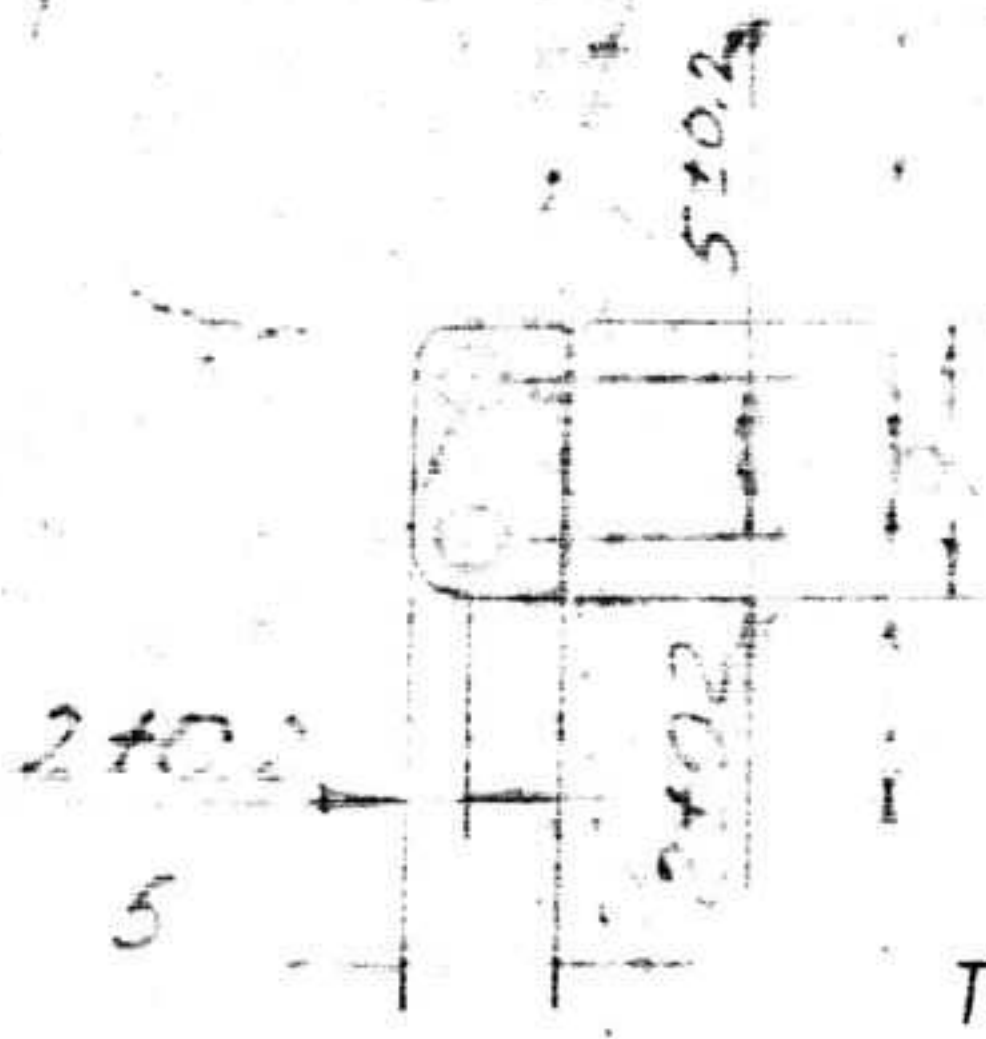
SHEET WEIGHT, SCALE
0032 71
TOTAL SHEETS

765-96-121

2

R1

2Holes $\phi 2.2$



Thickness 0.25

1. Blunt sharp edges.
2. Perform dimensions without deviations with accuracy class 7, OST 1010.

DESIGNED	JONASIA	DATE	
DRAWN BY	CH.V.RAO	11.7.84	
EDITED AND CHECKED BY:	AK VADY	11.7.84	
FOREMAN OF DC	S.R.NAIR	12.7.84	
DIVISIONAL OFFICER			

GASKET

BAND 0.25-BpB2T, FIGET 17A9-70

765-96-121

HYDRAULIC FACTORY PROJECT
HYDERABAD