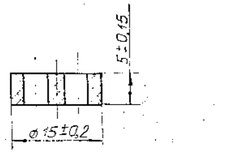
A

78
509



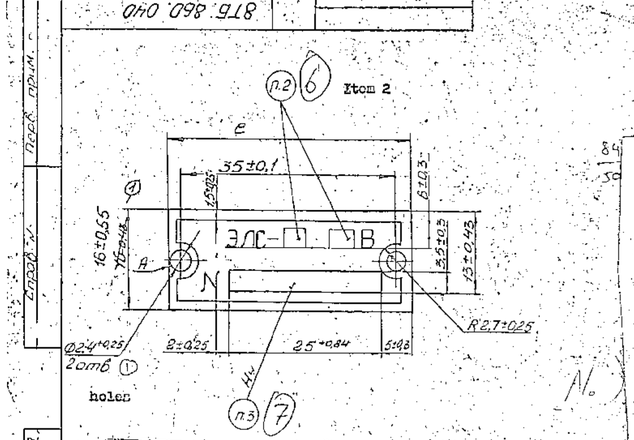
1. The Part may be made from phenolic plastic 9-2 -550-02.
1. Допускается изготовление из фенолпластма 32-330-02

2. Допускается снимать фаску 05×45° по торцу с обеих сторон

2. Chamfering 05x45° on both sides of the butt ends is allowed

SCK,D 07

MATERIAL :- PHENOLIC PLASTIC 03-010-02		
ALL SHARP EDGES & CORNERS TO BE ROUNDED	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED		
SCALE :- 2:1	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-
DATE :- 28-8-97		
DRN. WT :- (Kg) 0.001	816.710.137	
TCD.	WASHER	
CHD.		
APD.		
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)		SHEET NO OF 137



Designation	Type of article	Voltage	Dimensions
8ТБ. 860. 040			40±0,5 (1)
-01	ЭЛС-3	26	40-0,62

1. Displacement of holes A from true position should not exceed 0,1mm.
2. Mark "ЭЛС-3" case with type 2,5 arrange symmetrically with respect to sign ho.. use type H 2,5.
3. Mark the registration number of the part by striking method using type 2,5.
4. Coating: Anodic, Oxidation.
5. It is allowed to make by etching method to depth 0,1 to 0,15 mm.
   a) Back ground of the face surface should be dull black.
   b) Letters, Numerals, place for registration number, and framing should be in light colour.
6. ———
7.

SHEET A3 1M-0.8

DO NOT TO BE SCALED

SCALE 2:1

DATE 28-8-97

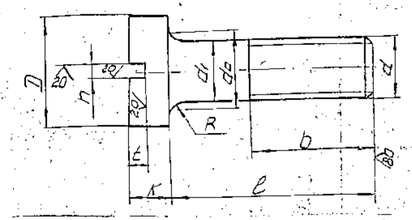
0.00119

8ТБ. 860.040

FACTORY NAME PLATE

CONTROL CERTIFICATE OF QUALITY ASSURANCE

OLO 005 978



1. Screws marked with sign 'x' should have threads to full length of rod.
2. ---
3. Untyreaded rod diameter d1 should be with in limits from major diameter to anglo diameter of thread.

Q'ty	Designation	Designation as per standard	ℓ	b	Dimensions in mm: da max	D	K	H	t	Min ℓ	Pitch of thread: Coarse	Fine	Tolerance for alignment of head with respect rod in diameter expression.	Tolerance for symmetry of slot with respect to rod in diameter expression	Weight of 100 pcs. Kg
(1)		(2)													
	8Т5.900.070	Винт А.М1-6gх2.58.013	2±0,2	X	1,4	2-0,10	0,7-0,14	0,31+0,14	0,3+0,14		0,25	-			Coating 0,024
	-01	Винт А.М1,6-6gх3.58.013	3±0,2	X											0,084
	-02	Винт А.М1,6-6gх4.58.013	4±0,24	X											0,096
	-03	Винт А.М1,6-6gх5.58.013	5±0,24	X	2	3-0,10	1,2-0,14	0,46+0,14	0,45+0,20	0,1	0,35	-	0,28	0,28	(13) L43 X 10 0,107
	-04	Винт А.М1,6-6gх12.58.013	12±0,36	X											Zinc plated 0,186
	-05	Винт А.М2-6gх3.58.013	3±0,2	X											3 microns thick. chromitized. 0,116
	-06	Винт А.М2-6gх4.58.013	4±0,24	X	2,6	3,8-0,12	1,3-0,14	0,56+0,14	0,6+0,25		0,4	-	0,36		0,178
	-07	Винт А.М2-6gх5.58.013	5±0,24	X											0,196

MATERIAL :-	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
ALL SHARP EDGES & CORNERS TO BE RECTIFIED		
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-
SCALE :-		
DATE :- 28-8-97		
DRN	WT :- (Kg) SEE TABLE	8Т5. 900.070
TCD		SCREW (1 of 3)
CHD		
APD		

CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES) 112 OF 137

0100058718

Dimensions

(1) Обозначение DESIGNATION	(2) Обозначение по стандарту STANDARD	(4) Размеры, мм l	b	d_a, не более	D	K	n	t	(5) R, не менее	FITCH OF THREAD (6) Допуск посадки резьбы крупный (7)	мелкий (8)	Допуск соосности головки относительно отверстия в диаметральном выражении head with respect to rod in diameter expression	Допуск перпендикулярности шлица относительно отверстия в диаметральном выражении to rod in diameter expression	(11) Покрытие COATING	(12) Масса шт., кг, 1000 шт. весят кг
8ТБ.900.070-08	Винт А.М2-6g х 6.58.013	6±0,24	X	max 2,6	3,8-0,12	1,3-0,14	$0,55^{+0,14}$	$0,6^{+0,025}$	min 0,1	Coarse 0,4	fine –	0,35	0,28	(13) L43.хр 2 nickel plating 3 micron thick, chromated COATING	0,214
-09	Винт А.М2-6g х 8.58.013	8±0,29	X												0,250
-10	Винт А.М2-6g х 10.58.013	10±0,29	X												0,286
-11	Винт А.М2-6g х 10 21 12 Х 18 Н 10 Т	10±0,29	X												0,286
-12															
-13	Винт 8.М2,5-6g х 4.58.013	4±0,38	X	3,1	4,5-0,3	$1,6_{-0,25}$	$0,65^{+0,14}$	$0,7^{+0,3}$		0,45	–				0,301
-14	Винт 8.М2,5-6g х 6.58.013	6±0,38	X												0,350
-15	Винт 8.М2,5-6g х 8.58.013	8±0,45	X												0,418
-16	Винт 8.М2,5-6g х 10.58.013	10±0,45	X												0,477
-17	Винт 8.М2,5-6g х 16.58.013	16±0,55	11												0,653
-18	Винт 8.М2,5-6g х 14.58.013	14±0,55	11												0,594
-19	Винт 8.М3-6g х 4.58.016	4±0,38	X	3,6	5,5-0,3	$2_{-0,25}$	$0,85^{+0,14}$	$1,1±0,2$		0,5	–	0,60	0,50		0,513
-20	Винт 8.М3-6g х 6.58.016	6±0,38	X												0,600
-21	Винт 8.М3-6g х 8.58.016	8±0,45	X												0,66
-22	Винт 8.М3-6g х 10.58.016	10±0,45	X											0,65 (15) L46.хр 2 nickel plating 3 micron thick, chromated	0,778
-23	Винт 8.М3-6g х 12.58.016	12±0,55	X												0,860
-24	Винт 8.М3-6g х 14.58.016	14±0,55	X												0,946
-25	Винт 8.М3-6g х 16.58.016	16±0,55	12												1,033
-26	Винт 8.М3-6g х 20.58.016	20±0,65	12												1,206

Screw

DC(1) NO DATE	ISSUE	NATURE OF AMENDMENTS	DC(1) NO DATE	ISSUE	NATURE OF AMENDMENTS
DRN		8ТБ. 900.070			DATE:- 28-8-97
TCD					USED ON
CHD		SCREW			SHEET 2 I SHEETS 3
APPD					113 OF 137

CONTROLLERATE OF QUALITY ASSURANCE (ICV)

010006 918																		
				Dimensions														
Обозначение DESIGNATION (11)	Обозначение ~~DESIGNATION~~ STANDARD (10)	Размеры, мм (4)								R, не менее (5)	Резьба (6)		Допуск соосности головки относительно резьбы диаметром	Допуск симметричности паза относительно отверстия диаметром	Покрытие	Масса 1000 шт., кг	
		l	b	d_0, не более (5)	D	K	n	t			крупная (7)	мелкая (8)					
8Т5.900.070-27	Винт В.М4-6g х 8.58.016	8±0,45	X	MAX						MIN	Coarse	fine	head axis to perpendicular to ref. to ref. in diameter opposite	to ref. in diameter opposite			
-28	Винт В.М4-6g х 14.58.016	14±0,55	X												COATING		1,328
-29	Винт В.М4-6g х 30.58.016	30±0,65	14														1,786
-30	Винт В.М4-6g х 45.58.016	45±0,80	14	4,7	7,035	$2,6_{0,25}$	$1,06^{+0,1}$	$1,4^{+0,2}$		0,2	0,7	–	0,72	0,60	(15) L.6.K.P		3,010
-31	Винт В.М4-6g х 55.58.016	55±0,95	14														4,251
-32	Винт В.М4-6g х 70.58.016	70±0,95	14														5,028
-33	Винт В.М4-6g х 38.58.016	38±0,80	14														6,194
-34	Винт АМ1,6х9.2.11Х18Н10Т	9±0,29	X	2	3,010	1,0-0,14	$0,46^{+0,1}$	$0,45^{+0,2}$		0,1	0,35	–	0,28	0,28	–		3,621
-35	~~Винт~~ Screw																0,152

87
609

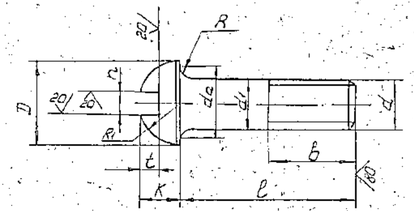
DC(1) NO DATE	ISSUE	NATURE OF AMENDMENTS	DC(1) NO DATE	ISSUE	NATURE OF AMENDMENTS
DRN		8Т5.900.070			DATE:- 28-8-97
TCD					USED ON
CHD		SCREW			SHEET 31 SHEETS 3
APPD					114 OF 137

CONTROLLERATE OF QUALITY ASSURANCE (ICV)

876.903.076

10.9 (V)

1. Screw marked with sign 'X' should have thread to full length of rod.
2. Unthreaded rod diameter d_1 should be with in limits from major diameter to angle diameter of thread.



(1) Обозначение Designation	(2) Обозначение по стандарту Designation as per standard	(4) Размеры Dimensions l	b	(5) da не более	R1 ≈	D	K	h	t	R	Шаг резьбы (6) крупный	мелкий	Допуск соосности (7) относительно стержня в диаметральном выражении	Допуск симметричности (8) относительно стержня в диаметральном выражении	Покрытие (10) coating	Масса (11) Weight of 1000 pcs.
876.903.076 (3)	Винт Screw В1.М25-6g×4.58.033	4±0.38	X	MAX							coarse	fine			Nickel plated 3 microns thick	0.232
-01	Винт В1.М25-6g×4.58.013	4±0.38	X	3.1	2.4	4.51 ±0.24				0.1	2.46		0.60	0.50	(9) Ц.3.хр	0.232
-02	Винт В1.М25-6g×4.32.11	4±0.38	X				1.7±0.2	0.65 +0.4	0.9 +0.4						(15) Ц.Имп.хр	0.232
-03	Винт В1.М25-6g×6.58.013	6±0.38	X												(14) Ц.3.хр	0.290
-04	Винт В1.М25-6g×8.58.013	8±0.45	X													0.349
-05	Винт В1.М25-6g×6.58.023	6±0.38	X												(13) Кд.3.хр	0.290

Cadium plated 3 microns

MATERIAL :-		
ALL SHARP EDGES & CORNERS TO BE BROKEN OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR
DRG. NOT TO BE SCALED		
SCALE :-	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-
DATE :- 28-8-97		
DRN. WT :- (Kg) see table	876.903.076	
TCG.		
CHD.	SCREW	1 OF 5
APD.		

CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)

84
150

① Обозначение DESIGNATION	② DESIGNATION AS PER STANDARD Обозначение по стандарту	④ Размеры DIMENSIONS IN MM									PITCH OF THREAD ⑥ Шаг резьбы		⑨	⑩	⑪	⑫ Weight Масса
		l	b	⑤ da не более	R1 ≈	D	K	h	t	R	⑦	⑧			Покрытие Coating	1000 шт
876.903.076-06	Винт ГОСТ Винт В1.М3-6g×6.58.016	6±0,38	X								coarse	fine	Tolerance for alignment of head with respect to rod in diameter expression	Tolerance for symmetry of head with respect to rod in diameter expression	⑭ 46.Хр	0,474
-07	Винт В1.М3-6g×8.58.046	8±0,45	X												⑭ 46.Хр	0,560
-08	Винт В1.М3-6g×8.58.026	8±0,45	X												⑪ К46.Хр	0,560
-09	Винт В1.М3-6g×10.58.016	10±0,45	X												⑰ 46.Хр	0,647
-10	Винт В1.М3-6g×12.58.016	12±0,55	X	3,6	2,9	5,5± 0,24	2,1±0,2	0,86 +0,14	1,01 +0,14	0,1	0,5		0,80	0,50		0,734
-11	Винт В1.М3-6g×12.58.026	12±0,55	X												⑮ К46.Хр	0,734
-12	Винт В1.М3-6g×16.58.016	16±0,55	12												⑯	0,907
-13	Винт В1.М3-6g×22.58.016	22±0,65	12												46.Хр	1,167
-16	Винт В1.М3-6g×6.32.033	6±0,38	X												⑬ Н3	0,916
-17	Винт В1.М4-6g×6.58.016	6±0,38	X	4,7	3,6	7±0,29	2,8±0,2			0,2	0,7	–	0,72	0,60	⑭ 46.Хр	0,916
-18	Винт В1.М4-6g×8.58.016	8±0,45	X													1,069
-19	Винт В1.М4-6g×8.58.026	8±0,45	X												⑰ К46.Хр	1,069
-20	Винт В1.М4-6g×8.32.036	8±0,45	X													1,069
-21	Винт В1.М4-6g×10.32.036	10±0,45	X					1,06 +0,14	1,6 +0,4						⑱ 46	1,222
-22	Винт В1.М4-6g×12.58.016	12±0,55	X												⑲ 46.Хр	1,375
-23	Винт В1.М4-6g×12.58.016	12±0,55	X												⑲ 46.Хр	1,375
-24	Винт В1.М4-6g×10.58.016	10±0,45	X												⑲ 46.Хр	1,222
-25	Винт В1.М4-6g×12.32.036	12±0,55	X												⑱ 46	1,375

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

Справ. №

Перв. примен.

Подпись и дата

Инв. № подл. | Подпись и дата | Взам. инв. №

ГОСТ 2.795-81

876.903.076

116 ЭТ 197

Лист 2

Обозначение	Обозначение по стандарту	(4) Размеры l	b	(5) Да ГОСТ 30.109	R1	D	K	n	t	R	(6) Допуск резьбы: средний	мелкий	(9) Допуск соосности относительно отверстия в дюймовой детали	(10) Допуск симметричности относительно отверстия в дюймовой детали	(11) Покрытие	(12) Масса
ВТ6.903.076-26	Винт В1.М4-6g×14.58.016	14±0,55	X								6g	6H	Толщина покрытий от общей толщины стенки в диаметральном выражении	Толщина покрытий от общей толщины стенки в диаметральном выражении	4,5 Хр	1,528
-27	Винт В1.М4-6g×14.32.036	14±0,55	X												4,5	1,528
-28	Винт В1.М4-6g×16.58.016	15±0,55	X													1,681
-29	Винт В1.М4-6g×18.58.016	18±0,55	14												4,6 Хр	1,834
-30	Винт В1.М4-6g×18.32.036	18±0,55	14	4,7	3,5	7±0,22	2,8±0,2			0,2	0,7	-	0,72	0,60	Н6	1,834
-31	Винт В1.М4-6g×22.58.016	22±0,65	14					1,05	4,4							2,139
-32	Винт В1.М4-6g×30.58.016	30±0,65	14						16						4,6 Хр	2,751
-33	Винт В1.М4-6g×40.58.016	40±0,20	14													3,516
-34	Винт В1.М4-6g×16.58.026	16±0,65	X												Кадмирование	1,681
-35	Винт В1.М2,5-6g×12.58.016	12±0,55	X	3,1	2,4	4,5±0,24	1,7±0,2	0,65	0,9	0,1	0,45		0,60	0,50	4,5 Хр	0,340
	SC REW															
-39	Винт В1.М5-6g×8.58.016	8±0,45	X	5,7	4,4	8,5±0,29	3,5±0,24			0,2	0,8	-	0,72	0,60	4,6 Хр	1,824
-40	Винт В1.М5-6g×10.58.016	10±0,45	X													2,068
-41	Винт В1.М5-6g×10.32.036	10±0,45	X					1,25	5						Н6	2,068
-42	Винт В1.М5-6g×12.58.016	12±0,55	X						2,1						4,6 Хр	2,313
-43	Винт В1.М5-6g×14.32.036	14±0,55	X												Н6	2,557
-44	Винт В1.М5-6g×16.58.016	16±0,55	X													2,802
-45	Винт В1.М5-6g×18.58.016	18±0,65	X												4,6 Хр	3,045

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

Изм. Лист № докум. Подп. Дата — ГОСТ 2.780-84

ВТ6.903.076

117 ОF 137

Лист 3

Инв. № подл. | Подпись и дата | Взам. инв. № | Инв. № дубл. | Подпись и дата

Обозначение	Обозначение стандарту	Розміри														Маса	
		ℓ	b	d_1	d_2	D	K	n	t	s							
8Т6903.076-46	Винт В1.М5-6g×18.32.033	18±0,55	X													43	3,046
-47	Винт В1.М5-6g×22.58.016	22±0,65	16														3,535
-48	Винт В1.М5-6g×22.32.033	22±0,65	16													Н3	3,535
-49	Винт В1.М5-6g×30.58.016	30±0,65	16					1,25±0,25									4,512
-50	Винт В1.М5-6g×50.58.016	50±0,80	16	5,7	5,4	3,5±0,25	3,5±0,24		2,1±0,24	0,2	0,8	–	0,72	0,60	(19)	46х0	6,956
-51	Винт В1.М5-6g×50.32.036	50±0,80	16													Н6	6,956
-52	Винт В1.М5-6g×25.58.016 -Д	25±0,65	16													14,5х0	3,901
-53																	
-54																	
-55	Винт В1.М5-6g×22.32.11	22±0,65	16													Н3	3,535
-56	Винт В1.М6-6g×14.58.016	14±0,55	X	6,8	6,4	4,0±0,25	4,2±0,24			0,25	1	–	0,72	0,60	(19)	45х0	3,865
-57	Винт В1.М6-8g×14.58.026	14±0,55	X													536х0	3,806
-58	Винт В1.М6-8g×20.58.016	20±0,65	X														4,814
-59	Винт В1.М6-8g×22.58.016	22±0,65	18					1,65±0,25	2,3±0,24							45хр	5,263
-60	Винт В1.М6-8g×22.58.025	22±0,65	16	6,8	6,4	4,0±0,25	4,2±0,24			0,25	1	–	0,72	0,60	(19)	536хр	5,263
-61	Винт В1.М6-8g×25.58.016	25±0,65	18													43хр	5,787
-62	Винт В1.М6-8g×30.58.016	30±0,65	18														6,650
-63	Винт В1.М6-8g×30.58.026	30±0,65	18													536х0	6,650
-64	Винт В1.М2,5-6g×16.58.016	16±0,55	X	3,1	2,4	4,5±0,24	1,7±0,2	0,66±0,14	0,9±0,24	0,1	0,45	–	0,60	0,50	(19)	46хр	0,583
-65	Винт В1.М1,6-6g×2.58.013	2±0,3	X	1,4	1,1	2,6±0,25	0,7±0,1	0,3±0,1	0,8±0,2	0,1	0,25	–	–	–	(14)	43х0	0,018

Notes- 9. Tolerance for alignment of head with respect to rod in diameter expression

10) Tolerance for symmetry of slot with respect to rod in diameter expression

13) Nickel plated, 3 microns

14. Zinc plated, 3microns thick.
16. Cadmium plated, 3microns thick, chromotized.
19. Zinc plated 6 microns thick, chromotized.
17. Cadmium plated, 6microns thick, chromitized.

87
509

(1) Обозначение DESIGNATION	(2) Обозначение по стандарту Designation as per standard	(3) Размеры Dimensions l	b	da не более Max	R1 ≈	D	K	n	t	R	Pitch of thread (4) Шаг резьбы P мелкий fine	P крупный coarse	(5) Tolerance for alignment of head with respect to rod in diameter expression	(6) Tolerance for symmetry of slot with respect to rod in diameter expression	(11) Coating	(12) Weight
8Т6 203 076 - 66	(7)															
-67	Винт А1.М12-6g х 3.58.013	3±0,3	X	16	13	23-0,25	8,8±0,30	0,36	0,25±0,3	0,1	0,25	–	–	–	14 Ц 3 Х.р	0,034
-68	Сорван															
-69	Винт А1.М2.6g х 6. 58.013	5±0,38	X	2,6	2,0	3,8-0,30	1,4±0,12	0,36	0,15±0,3	0,1	0,4	–	–	–	14 Ц 3 Х.р	0,175
-70	Винт А1 М2-6g х 10 58.013	10±0,45	X													0,247
-71	Винт В1.М3-6g х 6 58.026	6±0,38	X	3,6	2,9	5,5±0,24	2,1±0,2	0,36	1,0±0,4	0,1	0,5	–	0,60	0,50	(3) Ц 6.Х.р	0,474
-72	Винт В1 М3-6g х 10. 58.026	10±0,45	X													0,647
-73	Винт В1. М5-6g х 14. 58.016	14±0,55	X	5,7	4,4	8,5±0,29	3,5±0,24	1,05	2,1±0,4	0,2	0,8	–	0,72	0,60	(19) Ц 6.Х.р (17) Кд 6.Х.р	2,557
-74	Винт 31.М5-6g х 14 58.026	14±0,55	X													
-75	Винт В1.М3-6g х 16.32.033	15±0,55	12	3,6	2,9	5,5±0,24	2,1±0,2	0,36	1,0±0,4	0,1	0,5	–	0,60	0,50	(14) Н 3	0,907
-76	Винт В1. М4-6g х 25.58.016	25±0,65	14	4,7	3,6	7±0,29	2,8±0,2	1,2	1,6±0,4	0,2	0,7	–	0,72	0,60	(19) Ц 6.Х.р (17) Кд 6.Х.р	2,369
-77	Винт 31. М3-6g х 14. 58.016	14±0,55	X	3,6	2,9	5,5±0,24	2,1±0,2	0,36	1,0±0,4	0,1	0,5	–	0,60	0,50	(19) Ц 6.Х.р (17) Кд 6.Х.р	0,820
-78	Винт В1.М3-6g х 14. 58.026	14±0,55	X													
-79	Винт В1.М2,5-6g х 4.58.023	4±0,38	X	3,1	2,4	4,5-0,28	1,7	0,36	0,9±0,4	0,1	0,45	–	0,60	0,50	(19) Кд 3.Х.р	0,232
-80	Винт 31.М4-6g х 6. 58.026.	5±0,38	X	4,7	3,6	7±0,29	2,8±0,2	1,05	1,6±0,4	0,2	0,7	–	0,72	0,60	(17) Кд 6.Х.р	0,916
-81	Винт В1.М3-6g х 10 32.033	10±0,45	X	3,6	2,9	5,5±0,24	2,1±0,2	0,36	1,0±0,4	0,1	0,5	–	0,60	0,50	(14) Н 3	0,647
-82	Винт В1 М4-6g х 18. 58.026	18±0,55	14	4,7	3,6	7±0,29	2,8±0,2	1,05	1,6±0,4	0,2	0,7	–	0,72	0,60	(17) Кд 6.Х.р	1,834
-83	Винт В1.М3-6g х 12. 58.023	12±0,55	X	3,6	2,9	5,5±0,24	2,1±0,2	0,36	1,0±0,4	0,1	0,5	–	0,60	0,50	(17) Кд 6.Х.р	0,734
-84	Винт В1.М4-6g х 14. 58.023	14±0,55	X	4,7	3,6	7±0,29	2,8±0,2	1,05	1,6±0,4	0,2	0,7	–	0,72	0,60	(19) Кд 3.Х.р	1,528
-85	Винт В1.М2,5-6g х 10. 58.013	10±0,45	X	3,1	2,4	4,5-0,28	1,7	0,36	0,9±0,4	0,1	0,45	–	0,60	0,50	(14) Ц 3.Х.р	0,407
-86	Винт В1 М2,5-6g х 14. 58. 013	14±0,55	X												(17) Ц 3.Х.р	0,525

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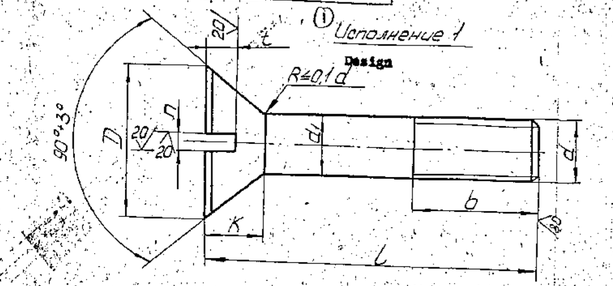

1. Screws marked with sign 'X' should have thread to full length of
2. Unthreaded rod diameter d1 should be with inllimits from major diameter to angle diameter of thread.

Designation	Designation as per standard	Dimensions in MM MAX		Pitch of thread Coarse	Fine	⑨	⑩	coating ⑫	Weight Масса 1000 шт 1 кг Pcs.
8Т6.904.006	⑬ Screw Винт А1.М12-6g х 358.013	3±0.2	X	23-0.25	0.72	0.38 +0.14	0.24 +0.11	0.25	–				0.028
⑭	ГОСТ 17475-80												
-01	Gost									0.28			
-02	Винт А1.М16-6g х 458.013	4±0.24	X	3-0.25	0.96	0.4 +0.14	0.32 +0.08	0.35	–		0.28		0.053
-03	Винт А1.М16-6g х 558.013	5±0.24	X										0.075
-04	Винт А1М2-6g х 4.58.013	4±0.24	X	38-0.3	1.2	0.5 +0.14	0.4 +0.12	0.4	–	0.36		⑭ Ц.3.Х.0	0.109
-05	Винт А1.М2-6g х 6.58.013	6±0.24	X										0.145
-06	Винт В1М2.5-6g х 458.013	4±0.38	X	47-0.3	1.5	0.65 +0.14	0.5 -0.23	0.45	–	0.60	0.50		0.186

MATERIAL		
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED		
SCALE :-	TOLERANCE ON DIMENSIONS UNLE -SS OTHERWISE SPECIFIED	USED ON:-
DATE :- 28-8-97		
DRN.	WT:- (Kg) See table	8Т6.904.006
TCD.		
CHD.		SCREW
APD.		

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

900 h08 918 | A883-71

Note: 7. Pitch of thread
8. Coarse
9. Frame
10. Tolerance for alignment of head with respect to rod, in diameter expression.
11. Tolerance for symmetry of slot with respect to rod in diameter expression.
12. Coating.
13. Weight of 1000 pcs, kg.
14. Zinc plated, 3 microns thick
15. Nickel plated, 3 microns thick.
16. Cadmium plated, 6 microns thick, chromotized.
17. Zinc plated, 6 microns thick

Обозначение Designation	Обозначение по стандарту Designation as per standard	Dimensions in mm l	b	D	K (6) из болта	n	t	Шаг резьбы крупный (9)	мелкий (10)	Допуск симметричности относительно стержня (11)	Допуск симметричности относительно оси отверстия (11)	Покрытие	Масса 1000 шт, кг
ВТ5.904006-07	Винт В1.М2,5-6g.55.801.3	5±0,38	X		Max								0,215
-08	Винт В1.М2,5-6g x 6.58.013	6±0,38	X	4,7-0,3	1,5	0,66+0,4	0,6+0,23	0,45	—	0,60	0,50 (14)	Ц.Хр	0,245
-09	Винт В1.М2,5-6g x 8.58.013	8±0,45	X										0,303
-10	Винт В1.М2,5-6g x 16.58.013	16±0,55	11										0,538
-11	Винт В1.М3-6g x 6.33.033	6±0,38	X									НЗ	0,362
-12	Винт В1.М3-6g x 6.58.026	6±0,38	X									Кд6.Хр	0,362
-13	Винт В1.М3-6g x 6.58.016	6±0,38	X									Ц6.Хр	0,362
-14	Винт В1.М3-6g x 8.58.016	8±0,45	X	5,6-0,3	1,65	0,85+0,4	0,6+0,23	0,5	—	0,60	0,50		0,443
-15	Винт В1.М3-6g x 8.58.026	8±0,45	X									Кд6.Хр	0,443
-16	Винт В1.М3-6g x 10.58.016	10±0,45	X									Ц6.Хр	0,536
-17	Винт В1.М3-6g x 10.58.026	10±0,45	X									Кд6.Хр	0,536
-18	Винт В1.М3-6g x 12.58.016	12±0,55	X									Ц6.Хр	0,622
-19	Винт В1.М3-6g x 14.58.026	14±0,55	X										0,709
-20	Винт В1.М3-6g x 16.58.026	16±0,55	X									Кд6.Хр	0,796
-21	Винт В1.М3-6g x 18.58.026	18±0,55	12										0,882
-22	Винт В1.М3-6g x 25.58.016	25±0,65	12									Ц6.Хр	1,186
-23	Винт В1.М3-6g x 30.58.26	30±0,65	12									Кд6.Хр	1,402
-24	Винт В1.М3-6g x 8,8.58.016	8,8±0,45	X										0,490
-25	Винт В1.М3-6g x 16.58.016	16±0,55	X									Ц6.Хр	0,796

SCREW.

CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)

5 ЗОМ ТЕ647-82 876.904.006 121 OF 137 2

Инв.№ подл. | Подпись и дата | Взам.инв.№ | Инв.№ дубл. | Подпись и дата

Format A3

900 h06 9.18 | A683-71

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Note: 10. Tolerance for alignment of head diametar expression. respect to rod in

11. Tolerance for symmetry of slot wit respect to rod in diameter expression.
16. Cadium plated, 6 microns thick.
17. Zinck plated, 6 microns thick, chromotized.
18. Nickal plated, 9 microns thick.
19. Zinc plated, 9 microns thick, chromotized.
pitch of thread

Обозначение DESIGNATION (2)	Обозначение по стандарту Designation as per standard (3)	Dimensions in mm (5) Размеры в мм: l	b	D	K не более (6)	n	t	Шаг резьбы: крупный (8)	мелкий (9)	Допуск биения головки относительно шлицев в заданном направлении (10)	Допуск симметричности шлица относительно стержня в заданном направлении (11)	Покрытие (12)	Масса 1000 шт. кг (15) Weight	
					MAX			Coarse	fine					
8Г6.904.006-26	Винт В1М4-6g х 8.58.016	8±0.45	X									(17) 46.Хр	0,854	
-27	Винт В1М4-6g х 10.58.016	10±0.45	X										1,007	
-28	Винт В1М4-6g х 10.58.026	10±0.45	X									(16) Кд 6Хр	1,007	
-29	Винт В1М4-6g х 10.32.039	10±0.45	X	$7^{-0.36}_{-0.76}$	2,2	$1,06^{+0.04}$	$0,8^{+0.3}$	0,7	–	0,12	0,60	(18) Н9	1,087	
-30	Винт В1М4-6g х 12.58.016	12±0.55	X										1,159	
-31	Винт В1М4-6g х 14.58.016	14±0.55	X									(17) 46.Хр	1,312	
-32	Винт В1М4-6g х 18.58.016	18±0.55	X										1,618	
-33	Винт В1М4-6g х 18.58.026	18±0.55	X									(16) Кд6.Хр	1,618	
-34	Винт В1М5-6g х 14.58.026	14±0.55	X									(16) Кд 6Хр	2,369	
-35	Винт В1М5-6g х 16.56.026	16±0.55	X										2,613	
-36	Винт В1М5-6g х 10.58.016	10±0.45	X										1,758	
-37	Винт В1М5-6g х 14.58.016	14±0.55	X										2,369	
-38	Винт В1М5-6g х 16.58.016	16±0.55	X	$9^{-0.36}_{-0.76}$	2,5	$1,25^{+0.25}$	$1^{+0.35}$	0,8	–	0,12	0,60	(17) 46.Хр	2,613	
-39	Винт В1М5-6g х 16.56.016	16±0.55	X										2,613	
-40	Винт В1М5-6g х 18.58.016	18±0.55	X										2,857	
-41	Винт В1М5-6g х 20.58.016	20±0.65	X										3,102	
(3) -42	Винт В1М5-6g х 35.58.016 (026)	35±0.8	X									(16) Кд6.Хр	5,057	
-43	Винт В1М6-8g х 14.58.016	14±0.55	X	$11^{-0.43}$	3,0	$1,66^{+0.25}$	$1,2^{+0.4}$	1	–	0,16	0,60	(17) 46.Цп	3,493	
-44	Винт В1М6-8g х 14.32.039	14±0.55	X									(18) Н9	3,773	

SCREW.

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

Изм.	Лист	№ докум.	Подпись	Дата	8Т6 904.006	Лист 3
3	1	76.858-82				
2	ЗОМ	ТС 547-82				

Перв. примен. | Справ. № | Подпись и дата | Инв. № подл. | Подпись и дата | Взам. инв. № | Инв. № дубл. | Подпись и дата

1220-137

900 h06 918 | A683-71

Note: 10. Tolerance for alignment of head with respect to rod in diameter expression.

10a. Tolerance for symmetry of slot with respect to rod in diameter expression.
16. Cadium plated, 6 microns thick.
17. Zinck plated, 6 microns thick, chromotized.
18. Nickel plated, 9 microns thick.
19. Zinc plated, 9 microns thick, chromotized.

Pitch of thread

91
307

Dimensions in mm

Обозначение DESIGNATION (3)	Обозначение as per standard (3a)	L	b	D	K (4) не более MAX	n	t	Шаг резьбы (7) крупный Coarse	Шаг резьбы (7) мелкий Fine	Допуск значения до плоскости симметрии (10)	Допуск симметричности относительно оси (11)	Покрытие coating (12)	Масса 1000 шт kg (13)
8Т6 904 006-45	Винт 8I.M6-6g x 22.58.016	22±0,65	X	11-0,43	3,7	1,65 -0,25	1,2 +0,4	1	–	0,85	0,60	(17) Ц6.хр	5,064
-45	Винт 8I.M6-6g x 22.32.029	22±0,65	X									(18) Н9	5,469
-47	Винт 8I.M6-6g x 22.58.026	22±0,65	X									(20) К39.хр	5,034
-48	Винт 8I.M6-6g x 12.58.025	12±0,55	X										2,969
-49	Винт 8I.M6-6g x 42.58.025	42±0,8	18									(16) К06.хр	8,557
-50	Винт 8I.M3-6g x 58.016	14±0,55	X	5,5 -0,3	1,65	0,85 -0,14	0,6 +0,25	0,5	–	0,60	0,50	(17) Ц6.хр	0,709
-51	Винт 8I.M8-8g x 16A58.019	16±0,55	X									(19) Ц9.хр	7,293
-52	Винт 8I.M8-8g x 22.58.029	22±0,65	X	14,5 -0,4	4,0	2,06 +0,28	1,6 +0,5	1,25	1	0,86	0,72	(20) К39.хр	9,501
-53	Винт 8I.M8-8g x 25.58.029	25±0,65	X										10,447
-54													
-55													
-56	Винт 8I.M5-6g.140 58.026	40±0,80	16									(16) К06.хр	5,546
-57	Винт 8I.M5-6g x 10 58.026	10±0,45	X									(16) К06.хр	1,758
-58	Винт 8I.M5-6g x 30 58.016	30±0,65	16	9,2 0,36	2,5	1,26 +0,25	1 +0,35	0,8	–	0,72	0,60	(17) Ц6.хр	4,324
-59	Винт 8I.M5-6g x 25.58.016	25±0,65	16										3,835
-60	Винт 8I.M3-6g x 6 32.033	6±0,38	X	5,6 -0,3	1,65	0,85 -0,14	0,6 +0,25	0,5	–	0,60	0,50	(18) Н9	0,391
-61	Винт 8I.M4-6g x 16 58.023	16±0,55	X	7,4 -0,36	2,2	1,05 +0,14	0,8 +0,3	0,7	–	0,72	0,60		1,465
-62	Винт 8I.M5-6g x 30 58.026	30±0,65	16	9,2 -0,36	2,5	1,26 +0,25	1 +0,35	0,8	–	0,72	0,60	(16) К06.хр	4,324
-63	Винт 8I.M3-6g x 12 58.023	12±0,55	X	5,6 -0,3	1,65	0,85 +0,14	0,6 +0,25	0,5		0,60	0,50		0,622

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

Изм.	Лист	№ докум.	Подпись	Дата
6		ТЕ 6477-82		

8Т6.904.006

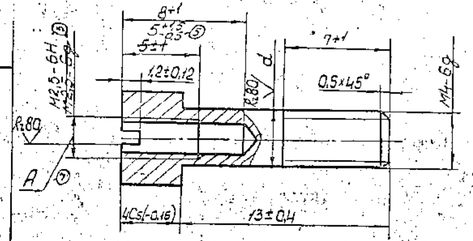
Лист 4

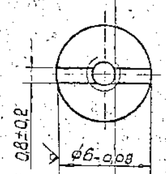
123 OF 137

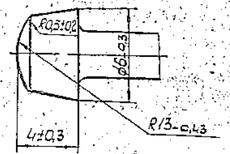
Инв. № подл. | Подпись и дата | Взам. инв. № | Инв. № дубл. | Подпись и дата

Восстанавливаемые поверхности

Q2/509 R1.40 (V)







1. Alternate material is Steel 25, Steel 10.
2. Screw head may be made by upsetting method.
3. Coating: Zinc plated, 6 microns thick, chromotized.
5. Displacement of Slot with respect to axis of head and rod should be within 0,3mm.
8. Increasing of hole 'A' up to dimension b is allowed (see table2)

Table 1 / Таблица 1

Threading process of M4-6g.	Диаметр d
By rolling	3.54-0.06 / 3.80-0.06
By cutting	4-0.14 / 4-0.15

Table 2 / Таблица 2

A	Б
M2.5-6H	M2.5-6G

MATERIAL :- STEEL 45			
ALL SHARP EDGES & CORNERS TO BE ROUNDED		ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED			
SCALE :- 5 : 1		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-
DATE :- 28-8-97			
DRN.	WT :- (Kg) 0.0016	8ТБ. 906. 022	
TCD.			
CHD			
APD		SCREW	

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

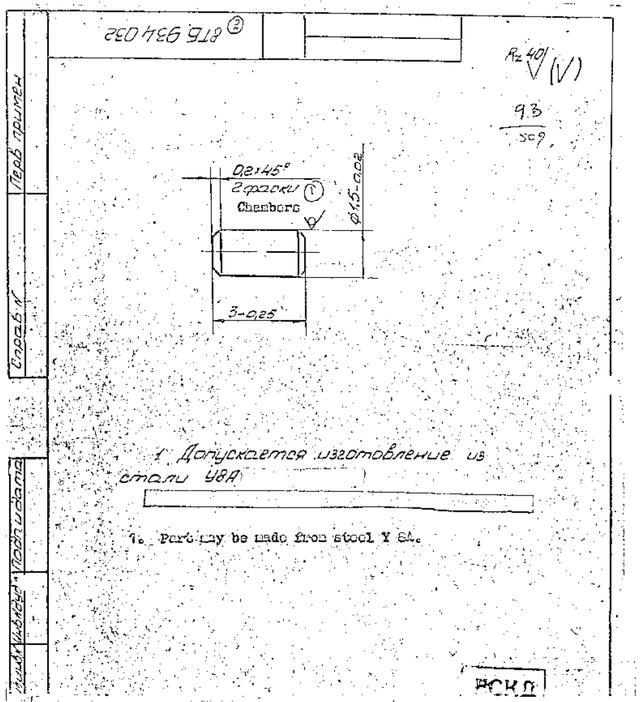
Перв. примен.

Справочный номер документа: 8Т6.906.022

Изм.	Лист	№ докум.	Подпись	Дата
Разраб.		14558		28.8.97
Пров.				
Т.контр.				
Н.контр.				
Утв.				

Инв. № подл. | Подпись и дата | Взам. инв. №

8Т6 906 022



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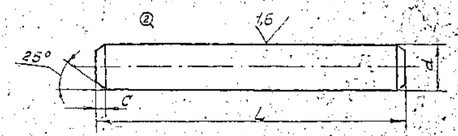
28-8-97

0.000035

8ТБ.934.032

PIN

8ТБ 934 035



R240 ✓(V)

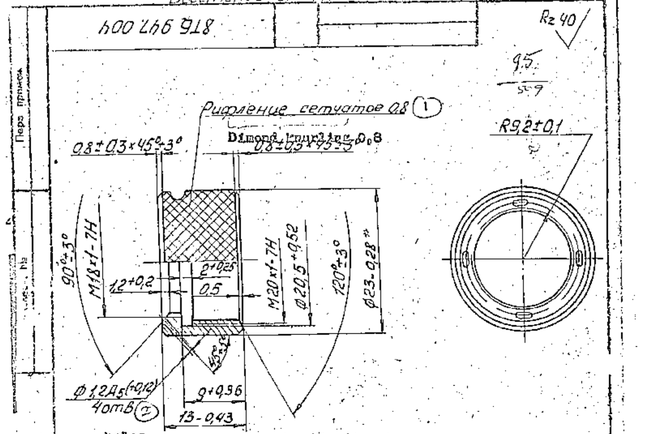
94
509

Designation Обозначение (1)	Designation Обозначение (1)	Material Материал (2)	Dimensions in mm Размеры в мм (3) l	d	c	(6) Покрытие	Weight in Kg Масса (7)	Remarks Примечание (8)
8ТБ 934 035 (9)	Штифт 3h8×20 pin (2)	Сталь 45 (4) Steel 45	20±0,2	3 -0,014	0,5±0,1	Coating —	0,001	Допускается Сталь А12 (9)
-01								Alternate is steel A12
-02								
-03								
-04								
-05								

MATERIAL :- SEE TABLE
ALL SHARP EDGES & CORNERS TO BE ROUNDED

DRG. NOT TO BE SCALED	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH. PART NO. MANUFACTURERS NAME & YEAR OF MFR.
SCALE :-	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-
DATE :- 28-8-97		
DRN [illegible] WT :- (Kg) See table	8ТБ. 934.035	
CHD [illegible]	PIN	
APD [illegible]		

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)



1* Размер до рифления.

2. Покрытие - Ан. Окс. хр

3. Технические требования к покрытию

1. Dimension before knurling.

2. Coating: Anode oxidation, chromotizying.

3. ---

MATERIAL :- Rod Ø 16 Tкр 24.П		
ALL SHARP EDGES & CORNERS TO BE REMOVED	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED		
SCALE :- 2 : 1	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-
DATE :- 28-9-97		
DRN. WT :- (Kg) 0.004	8ТБ.947.004	
CHD	NUT	
APD.		

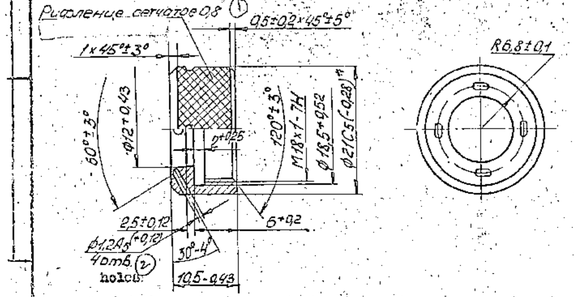
CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

Воспроизведен подлинник

876.947.005

96
509

Diamond knurling
Рифление сечение 0,8

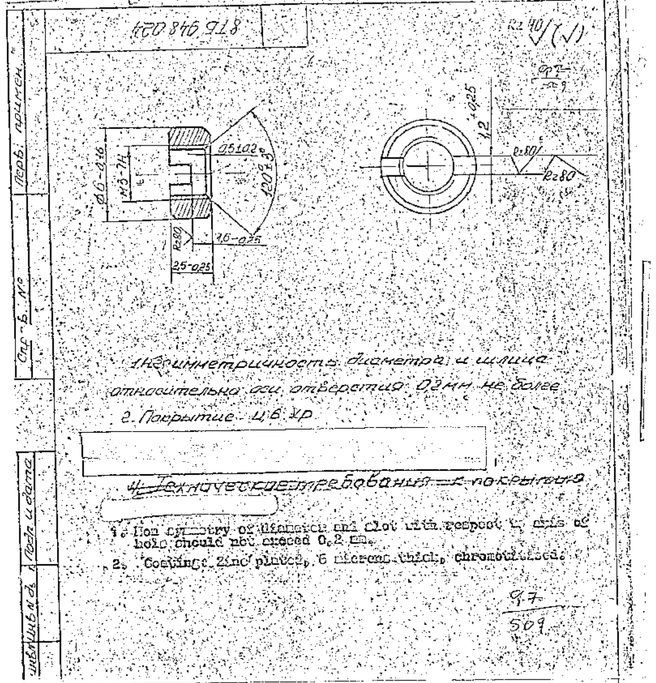


1* Размер до рифления
2. Покрытие Ан. Окс. хр.
~~3. Технические требования к покрытию~~

1. Dimension before knurling.
2. Coating: Anodic oxidation, chronotizing.

MATERIAL :- BAR Д16Т ГОСТ 21488-76			
ALL SHARP EDGES & CORNERS TO BE ROUNDED/CHF		ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED			
SCALE :- 2 : 1		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-
DATE :- 28 - 8 - 97			
DRN.	WT :- (Kg) 0.0038	876.947.005	
TCD.		NUT	
CHD.			
APD.			

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)



Инв.№ подл. | Подп. и дата | Взам. инв.№ | Инв.№ дубл. | Подп. и дата

Спр. № перв. примен.

КСО 846 918

Ra 40 (√)

9.7

509

Непринципиальность диаметра и шага относительно оси отверстия Ø2мм не более

2. Покрытие Ц6.хр

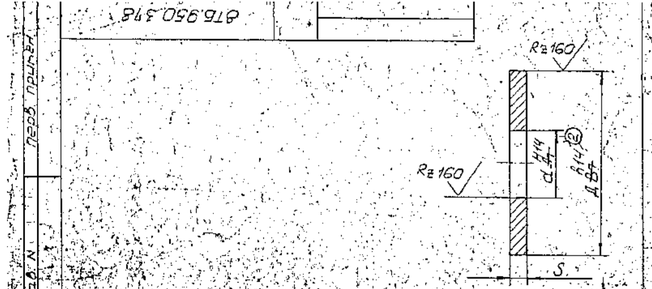
4. Технические требования к покрытию

1. Hydrogen embrittlement relief bake to be carried out within 4 hours of plating.

2. Coating: zinc plate, 6 microns thick, chromodized.

MATERIAL :- STEEL A12	
ALL SHARP EDGES & CORNERS TO BE ROUNDED	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED	
SCALE :- 6 : 1	USED ON:-
DATE :- 28-8-97	8ТБ 948 024
DRG.	NUT
TOL. (BSP) 0.01	
CHK	
APP.	

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY & ALLIED VEHICLES)



1. Part may be made from sheet 6S / 4-III-H-2D

Обозначение (1) Designation	Обозначение по стандарту (2) Designation as per standard	d	пред. откл.	A	пред. откл.	S	пред. радиальное биение	Материал (7) Material	Теорет. масса 1000 шт. кг ≈
8ТБ.950.378 (9)	Шайба 1,8×0,5.01.016	1,7		4		0,5		(6) Лист 6S / 4-III-H-10	0,031
-01	Шайба 16.01.016					0,3			
-02	washer		+0,25		-0,3		0,48		
-03									
-04								(6) Лист 6S / 4-III-H-10	
-05	Шайба 2×0,5.01.016	2,2		5		0,5			0,078
-06	Шайба 2×0,8.01.016					0,8	(2)		0,123
-07									
-08									
-09	Шайба 25.01.016	2,7		6,5	-0,36	0,5	0,58	(6) Лист 6S / 4-III-H-10	0,108
-10									
-11									

MATERIAL — SEE TABLE		
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO., MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED		
SCALE :-	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-
DATE :- 26-8-97		
DRN. WT :- (Kg) see table	8ТБ.950.378	
CHD.	WASHER	
APD.		

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

Designation Обозначение	Наименование по стандарту Designation as per standard	d	Пред откл. Limits of deviation	Д	Пред откл. Limits of deviation	S	Пред рад биение Limits radial run out	Материал Material	Теорет масса 1000 шт. кг Theoritical weight of th 1000 pcs. in kg approx.
8ТБ.950378-12	Шайба 2,5.32.033	2,7	+0,25	6,5	-0,36	0,5	0,58	Латунь Л63 Brass	
-13	Шайба 2,5.32.036					0,5		Латунь Л63	0,127
-14	Шайба 2,5.32.0312					0,5			0,119
-15	Шайба 2,5.32.11					0,8		Brass Б.Б Лист 4-III-Н-Т0	0,191
-16	Шайба 3.32.11	3,2	+0,3	7	-0,36	0,5	0,58		0,119
-17	Шайба 3.01.046					0,5		Sheet	0,119
-18	Шайба 3х0,8.01.016					1.			0,238
-19	Шайба 3.01.016					0,8			0,191
-20	Шайба 3.01.026								0,308
-21	Шайба 3х1.01.016					0,8		Латунь Л63	0,333
-22	Шайба 3х0,8.01.026							Brass Латунь Л63	0,413
-23	Шайба 4.01.0115	4,5	+0,3	9	-0,36	1.		Brass Б.Б Лист 4-III-Н-Т0	0,333
-24	Шайба 4.01.016							Sheet Латунь Л63	0,308
-25	Шайба 4.01.026					0,8		Brass Б.Б Лист 4-III-Н-Т0	0,333
-26	Шайба 4.32.033							Sheet Латунь Л63	0,402
-27	Шайба 4х1.32.036					1.		Brass Б.Б Лист 4-III-Н-Т0	0,4113
-28	Шайба 4.32.036							Sheet	0,48
-29	Шайба 4.32.0312					0,8		Латунь Л63	0,96
-30	Шайба 4.01.016							Brass Б.Б Лист 4-III-Н-Т0	0,336
-31	Шайба 4.32.11							Sheet Латунь Л63	0,576
-32	Шайба 4х1.0112					1.		Brass	
-33	Шайба 5.01.016	5,3		10	-0,36				
-34	Шайба 5.01.0112					2			
-35	Шайба 5.32.033								
-36	Шайба 5х2.32.033					1,2			
-37	Шайба 5х2.01.016								
-38	Шайба 5х1,2.32.33								

Washer

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

8ТБ.950.378

Инв. № подл. | Подп. и дата | Взам. инв. № | Инв. № дубл. | Подп. и дата

5660

① Обозначение Designation	② Обозначение по стандарту Designation as per standard	d	③ Пред. откл. Limits of deviation	D	③ Пред. откл. Limits of deviation	S	④ Пред. рад. биение Limits of radial runout	Материал ⑤ Material	Теорет. масса 1000 шт. кг. ~ Theoretical weight of 1000 pcs. in approx.
БТБ.950.378-39									
-40									
-41									
-42	WASHER							⑥	
-43	Шайба 6 х 1.01.016	6,4	+0,36	12,5	-0,43	1	0,7	Лист 6 S 4-Ш-Н10	0,683
-44	Шайба 6х1.32.033					1		② Sheet Латунь Л63	0,739
-45								⑤ Brass	
-46									
-47	Шайба 8х1,5.01.016							⑥ Лист 6 S 4-Ш-Н-10	2,32
-48	Шайба 8х1,5.32.033	8,4	+0,36	17	-0,43	1,5		⑤ Sheet Латунь Л63	2,65
-49	Шайба 8х1,5.01.016							⑦ Лист 6 S 4-Ш-Н-10	2,159
-50									
-51									
-52									
-53	Шайба 10.01.016	10,5	+0,43	21	-0,52	2	0,84	⑥ Лист 6 S 4-Ш-Н-10	4,06
-54								②	
-55									
-56									
-57									
-58									
-59									
-60	Шайба 12.32.033	13	+0,43	24	-0,52	2,5	0,84	⑤ Латунь Л63	7,795
-61								② Вилу	
-62									

3 OF 4

Инв.№ подл. | Подп. и дата | Взам. инв.№ | Инв.№ дубл. | Подп. и дата

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

① Обозначение Designation	② Обозначение по стандарту Designation as per standard	d	③ Пред. откл. Limits of deviation	Δ	③ Пред. откл. Limits of Deviation	S	④ Пред. рад. биение Limits of radial runout	Материал ⑦ material	⑤ Теорет. масса, кг Theoretical weight of
8ТБ.950.378-63	~~ВАЗНЕ~~								
-64	Шайба 16×3.01.016							Лист 5 5 4-II-Н-10	1000. Ecs. APPROX.
-65	Шайба 16×3.32.033	17	+0.43	30	-0.52	3	0.34	② Латунь Л63 Brass	12,1
-66	Шайба 16×3.32.039								
-67									
-68									
-69									
-70									
-71									
-72									
-73									
-74									
-75									
-76									
-77									
-78									
-79									
-80									

4 OF 4

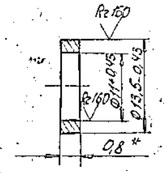
Инв.№ подл. | Подпись и дата | Взам.инв.№ | Инв.№ дубл. | Подпись и дата

15660

Восстановленный подлинник №1

876.950.386

А(М)



1Ст

1. Покрытие Хим. Окс. ФОС.
2. Технические требования по ГОСТ 9.
3 * Размер для справок.

[redacted]

1. Coatings Chemical oxidation, Phosphatization
3. *Dimensions are given for reference.

MATERIAL :- SHEET AL 16AT-0.8			
ALL SHARP EDGES & CORNERS TO BE BREAKED OFF		ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR.
DRG. NOT TO BE SCALED			
SCALE :- 2 : 1		TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-
DATE :- 28-8-97			
DRN.	WT :- (Kg) 0.0065	8TB. 950.386	
TCD.			
CHD.		WASHER	
APD.			
CONTROLLERATE OF QUALITY ASSURANCE (INFANTRY COMBAT VEHICLES)			134 OF 137

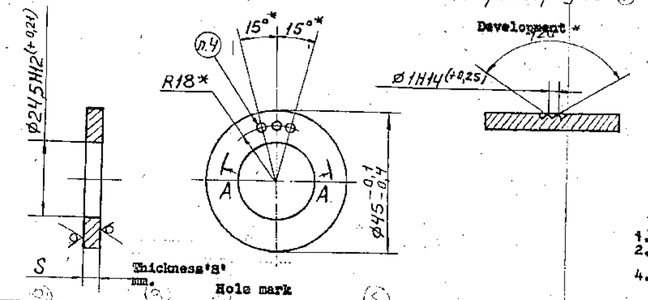
818 950 388

Перв. примен.

Справ. №

Инв.№ подл. | Подп. и дата | Взам. инв.№ | Инв.№ дубл. | Подп. и дата

A - A
развернуто ①
Development



Обозначение Designation	Толщина S, мм	Марки-ровка отв.	Материал MATERIAL
816550388	0,4-0,03	—	Лента 10-Н-2-0,4 Band
-01	0,6-0,04	1	Лента 10-Н-2-0,6 Band 2
-02	0,8-0,05	2	Лента 10-Н-2-0,8
-03	1-0,05	3	Лента 10-Н-2-1

Rz80 V (V)

103
509

1. Dimensions are given for reference
2. Coating: Zinc plated 15 microns thick, chromotized.
4. Mark the number of holes as stated in the table.

Продолжение
Continuation

Материал Material	Масса Kg Weight kg
Лента 08КП-Н-2-0,4	0,0035
Лента 08КП-Н-2-0,6	0,0057
Лист Sheet Б-ПУ-0,8 Ч-III-Н-10	0,0077
Лист Б-ПУ-1 Ч-III-Н-10	0,0085

MATERIAL :- SEE TABLE		
ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFR
DRG. NOT TO BE SCALED		
SCALE :- 1:1	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-
DATE :- 28-8-97		
DRN.	WT :- (Kg) SEE TABLE	8Т5.950.388
TOL.		WASHER
CHD.		
APD.		

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

875.953.105

Note:-4. Rod diameter of fastening part.
5. dimensions in MM.
6. Limits of deviation
7. Nominal
9. Coating
10 Theoritical weight of 1000 Pcs. kg. approx.
12. Chemical oxidation oiled.

105
302

Обозначение (1) Designation	Обозначение по стандарту (2) Designation as per Standard	Диаметр стержня крепежной детали (6)	(3) Размеры в мм d (4)	пред. откл.	S=B ном. (5)	пред. откл. (5)	Покрытие (9)	Теорет. масса 1000 шт кг ≈ (10)
875.953.105 - 20	(3) Washer Шайба 4.65Г.029	4	4,1	+0,3	1,2	±0,125		0,189
-21	Шайба 5.65Г.029	5	5,1		1,4			0,315
-22	Шайба 5.65Г.016	5	5,1	+0,3	1,4	±0,125		0,315
-23	Шайба 4.65Г.016	4	4,1		1,2			0,189
-24	Шайба 3.65Г.016	3	3,1	+0,3	0,8	±0,008		0,08
-25	Шайба 2,565Г.	2,5	2,6	+0,25	0,6	±0,07	(12) Хим. Окс. прм.	0,028

Инв. № подл. | Подпись и дата | Взам. инв. № | Инв. № дубл. | Подпись и дата

137 OF 137

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

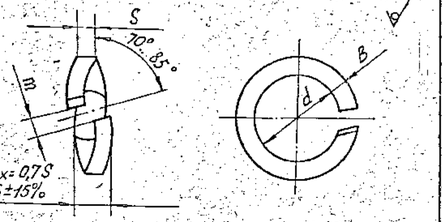
875.953.105

Лист 2

Note: 4. Diameter of fastening part.
5. Dimensions,
6. Limits of deviation

10. Theoritical weight of 1000 pcs. Kg. Approx.
11. Chemically phosphated enamel ПФ 163 IV 2 Times.
12. Chemical oxidation, oiled.

Обозначение (1) Designation	Обозначение по стандарту (2) Designation as per standard	Диаметр стержня крепежной детали (4)	Размеры в мм (5) d (6)	S-B Пред. откл.	Нат. (7)	Пред. откл. (8)	Покрытие (9) COATING	Теорет. масса 1000шт кг≈
8ТБ.953.105	(3) Шайба 2,5.65Г	2,5	2,6	+0,25	0,6	±0,007	(11) Хим. фос. Эм.ПФ163.IV.Т°150Т. 2х кратное	0,028
-01	Шайба 2,5.65Г.022							
-02	Шайба 3.65Г	3	3,1		0,8	±0,008	(11) Хим. Фос. Эм.ПФ 163.IV.Т°150Т. 2х кратное; (12) Хим. Окс. прм.	0,06
-03	Шайба 3.65Г.							
-04	Шайба 3.65Г.026							
-05	Шайба 3.65Г.0221							
-06	Шайба 4.65Г	4	4,1	+0,3	1,2		(11) Хим. фос. Эм.ПФ.163.IV.Т°150Т. 2х кратное	0,189
-07	Шайба 4.65Г.022							
-08	Шайба 4.65Г						(12) Хим. Окс. прм.	
-09	Шайба 5.65Г	5	5,1		1,4	±0,125	(11) Хим. фос. Эм.ПФ. 163.IV.Т°150Т. 2х кратное	0,315
-10	Шайба 5.65Г.0221							
-11	Шайба 5.65Г						(12) Хим. Окс. прм.	
-12	Шайба 6.65Г	6	6,1	+0,58	1,6		(11) Хим. фос. Эм.ПФ. 163.IV.Т° 150Т. 2х кратное	0,487
-13	Шайба 6.65Г.0221							
-14	Шайба 6.65Г						(12) Хим. Окс. прм.	
-15	Шайба 8.65Г	8	8,1		2		(11) Хим. фос. Эм.ПФ.163.IV.Т°150Т.2х кратное	0,998
-16	Шайба 8.65Г.0221							
-17	Шайба 6.65Г.029	6	6,1	+0,58	1,6	±0,126		0,487
-18	Шайба 16.65Г	16	16,3	+0,70	4	±0,15	(11) Хим. Фос. Эм. ПФ. 163.IV.Т°150Т. 2х кратное	8,022
-19	Шайба 2,5Т.65Г	2,5	2,6	0,25	0,8	±0,08	(11) Хим.фос. Эм. ПФ. 163.IV Т°150Т.2х кратное	-



2. Enamel ПФ -163

MATERIAL :- STEEL 65Г		
ALL SHARP EDGES & CORNERS TO BE BROKEN OFF	ALL THREADS TO CONFORM TO SPECIFICATION	STAMP OR ETCH, PART NO. MANUFACTURERS NAME & YEAR OF MFG.
DRG. NOT TO BE SCALED	TOLERANCE ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	USED ON:-
SCALE :-		
DATE :- 28-8-97		
DRN. WT :- (Kg)		8ТБ. 953. 105
TCD. See table		
CHD.		WASHERS SPRING
APD.		

CONTROLLERATE OF QUALITY ASSURANCE
(INFANTRY COMBAT VEHICLES)

Ordnance Factory Project Hyderabad.		NUMBER D. 509
		SHEET 1 OF 2

ELECTRIC TRIGER ЭЛ С-2
(Nomenclature, article code)

CERTIFICATE

3 Т Б .013.011-01 п С
(designation)

For article No._____

370F 137

ELECTRIC TRIGGER DAC-3

Technical description and instruction for operation

Edition 1

Checked by
DESP.
21-11-85
G. SEBASTIAN

GENERAL CONDITIONS

Prepare certificate form by printing, electrographic method or by photocoyping on paper, ensuring clarity of ints. All notes in certificates should be made clearly without corrections (pencil writing is not allowed) Date, month and and year should be written in arabic figures.

When making certificate by printing met.od it should have four sheets including cover.

Certificate size is 143x165 mm use of other sizes is not allowed. Certificate should have margin of 10mm width.

Pages of certificate should be numbered serially and bound with clips. It is permitted to paste the internal sheets of certificate while making by printing. Prepare certificate by printing on offset paper, white writing paper No.1, white label type paper of grade A and B. Printing paper is allowed if the certificate is made by printing method.

1. BASIC TECHNICAL DATA.

PARAMETERS	CHARACTERISTIC
Working voltage, V	26 + 10%
Current to be utilized at voltage 26 V and temperature 20°C while Connecting of first winding, max,	12,5
and second winding, max	2,2 A
Tractive force at temperature 20°C and voltage 26 B, min	7,5 Kgf.
Armature travel	13± 0.5 mm
Mass, max	1,3 Kg.

1. Purpose and Technical data Purpose.

The electric trigger (relay ЭМС-3 is anelectromagnetic p-power relay designed actuate the pluged of automatic valve of the fire fighting equipment.

TECHNICAL DATA.

1. Power is supplied from 36-V, D.C. mains.
2. Intensity of current at voltage 26 V should not exceed 12,5A at the time of switching on and should not exceed 2,2A during operation of the device.
3. Tractive force at voltage 26V should not be less than 7,5 Kg.
4. Elasticity of return spring should be 0,4 to 1.0 Kg.
5. Movement of Armature should be 13±0,5 mm.

II PRINCIPLE OF OPERATION

Electric trigger (relay ЭМС-3) operation is based on the plunger type relay principle.

In order to start by means of ЭМС-3, it is necessary to press the push button which closes the circuit of Electromanet. It causes the current in the circuit to pass through the coils as a result of which the armature under the action of Electromagnetic field of coil is pulled into it at the end of its movement the armature disconnects the contact system and the current starts passing through auxiliary winding and in this case the consumption of electrical energy is reduced for the full period of operation of the device. In the same position the armature remains untill the push button is depressed.

By releasing push button the supply in the circuit to the coil is diconnected, and t e armature is returned back in its initial position by the return spring.

2. Deliverky Set

Electric trigger.

Certificate.

3. Acceptance Certificate.

Electric trigger 2M C-3.
(Nomenclature and code of a rticle)

No_____ is manufactured serial No. of article.

and accepted in complience with technical papers and found it for service

Chief of T I D

_____
(Signature)

Date:

39 OF 137

WINDING PARAMETERS

Winding data	Main winding	Auxiliary winding
Wire diameter, mm	0.83	0,5
Wire length, m	75	≈4,8
No. of turns	670-40	16 +2
No. of rows.	10	1
Wire grade	ПЭВ-1	ПЭШОММ
Resistance, Ом	2,24 2,5	10

III CONSTRUCTION

Electric trigger consists of Body 21, coil 3, Armature 22 and contact system 4 and 5.

Coil 3 consists of two windings.

Winding ends are brought out to the plastic block 1, on which the contact system consisting of two brass springs with contacts is installed.

The voltage of 26V is applied across contacts and winding coils thrength plug connector 6.

Armature 22. moves freely inside the coil. The axle is secured in armature with help of pin. Fiten the axle is return spring 24 whose one end bears against shoulder on axle and other end bears up against the stop. Axle is terminated with fibre pin with the help of which the Armature presses the contact system.

The pin prevents rotation the guiding bush from. notation

IV ASSEMBLY OF DEVICE.

The electric trigger (relay РС-3) is mounted on verticle at any place and in any attitude, in doing so, ensure free access to the plug connector.

After installation of electric trigger check the travel of the armature. The travel of armature should be with i

Ordnance Factory Project Hyderabad.		NUMBER D-309
		SHEET 4 OF 4

4. LIFE, SERVICE LIFE AND STORAGE LIFE.

Life of electric trigger before disposing is 3000 cycles (switching on) storage life of article it it is preserved (in manufacturers package) is 1.5 years.

5. DATA FOR PRESERVATION (PACKING) AND DE-PRESERVATION

Date	Name of operation	Effective for	Signature of preservation incharge
	Preservation	2-years.	

Grease UUATUM - 201

Note:- 1. Check the condition of preservation and note the result in the certificate after one year of storage in the store house.

2. Sleeve, body, and plug connector nut should be subjected to preservation.

6. SERVICE RECORD OF ARTICLE.

Installed on object, system and unit.		Date of Removal	No. of working hours from the starting of operation	Reason for Removal	Signature of the person who installed or removed article
Date	Code and No. of object				
1	2	3	4	5	6

in the limits of 13 ± 0·5 m-m without fail. If this requirement is not met the main coil is get over heated, because the coils are not switched over to series connection.

Check the travel of armature with standard measuring tool having accuracy up to 0,1 mm. Carry out the checking in the following way. Measure the projecting shaft at its initial position and at the pulled in position of armature. The difference reading is the actual travel of the armature.

Over all dimensions of electric trigger 9 AC 3 is refferd in drawing 5 TD 013 01174.

V-BRIEF DESCRIPTION OF ASSEMBLY AND DISASSEMBLY OF DEVICE.

Insert the coil together with stopin to body. Mount the terminal block a d solder the ends of winding to the contact system. Insert insulating pin into armature axle and fix it. Put spring on t e armature axle. Place washer at the end of coild a d insert the assembled armature with spring into the coil, set ring on washer and put guide bush in to the ring, screw up the cover on the device body and fasten bush with pin preliminarily. Fasten cover with two screws, out of which one can be used for seal. Put cover on terminal block and fasten with three screws out of which are can be used for seal.

Device should be disassembled in reverse sequence..

VI POSSIBLE DEFECTS IN DEVICE AND METHODS OF THEIR ELIMINATION.

Type of defect	Method of elimination
1. Falling of insulating pin	1. Insert insulating pin in to armature axle and fix it.
2. Wearing of insulatingpin.	2. Change insulating pin.
3. Jamming of spring shoulder of armature axle (armature gets Jam)	3. Take out armature, remove spring and make diameter of turns Proper or change it by new one, see that the two tightly pressed turns are available at the ends of spring so as to ensure tight pressing of spring to the shoulder of armature axle and prevent it from jumping over the shoulder.
4. Burning of contacts due to low speed of armature with slide bar.	4. Thoroughly clean the surfaces of contacts and adjust armature travel.
5. While pressing button device is inoperative.	5. a) check mains for voltage. b) Check whether any breakage is in the supply wires. If voltage and wire are in order, then winding of the device is burned out. In this case change the device by new one.

Appendix: 1 drawing . 3T 6013.0110 6
drawing 3T 6013.0113
drawing 3T 6013.011 [illegible]

NUMBER 1.2451

SHEET 1 OF 24

SUPERSEDES ,

ELECTRIC TRIGGER

(RELAY BAC-3)

UNIFIED TECHNICAL SPECIFICATIONS

1969

TRANSLATED	V.B.Sharma			Ordnance Factory Project Hyderabad.
AUTHENTICATED				
TYPED	L.Devi		7/8/65	
EDITED	V.S.Sharma			APPROVED 5
	NAME	SIGN	DATE	

I. INTRODUCTION

1.1 The given technical specifications deal with electric trigger prelay ЭЛС-3) used for actuating automatic valve plunger.

1.2 The given technical specifications together with the drawing of item the article in question and other technical documents, indicated in ЗТБ.013.011-01 are the basic documents on manufacture and acceptance of electric triggers ЭЛС -3

Overall mounting and connecting dimensions should meet the requirements of drawing ЗТБ.013.011 -01 Ч. Electric circuit should conform to the requirements of drawing ЗТБ 013.011 Э 3.

1.3 Programm and procedure for testing electric trigger at the manufacturer's end as well as technological limit of parameters tolerances are not a subjects of approval of the users. They may be revised by the master copy holding plant during a period the technical specifications are in force.

2. TECHNICAL REQUIREMENTS

2.1 General requirements

2.1.1 In the absence of instructions in drawingsee as to the value of radii of change from one section to theother they are to be performed with a radius, which is equal to the blun-

equal to theblunting radius of the ~~blank~~ finish upto 0.2 mm.

2.1.2 In the absence of instructions in drawing as to the value of bending radii, bending is to be performed with a radius not exceeding 2/3 thickness of the material

2.1.3 Burrs are not allowed on the components of the article.

2.1.4 The sharp edges of the component of the articles if it is not specified in the drawing should be blunted with a chamfer upto 0.2-0.5x45° or with radius of 0.2-0.5 mm. Shape of blunting is to be indicated in process sheet for parts having thickness less than 0.4 mm. Blunting of sharp edges and chamfers during production with a radius not exceeding 0.2 mm if not other radius is specified in the drawing should be specified in process sheet and provided. ~~Burring~~ all the chamfers and blunting radii of inner angles and outer sharp edges upto 2 mm specified in the drawings, can be made with a tolerance of ± 30% as to rating.

Size of chamfer on cylindrical surfaces should be ~~checked~~ checked on the cylinder generatrix.

2.1.5 If permissible non-symmetry for location of an article component with respect to the axis of symmetry is not specified in the drawing, then in such cases non-symmetry is allowed with in limits of 1/2 of the biggest tolerance in the dimensional chain in question.

Contd..4

7 OF

2.1.6 In case of there is an instruction in the drawing "check during machining", the method of checking is to be stated in technological documents.

Measurement may be done by "go" side of the gauge of a higher class of accuracy, than specified in the manufacturing process and instructions chart.

2.1.7 Components of the article machined by grinding on magnetic tables, should not be magnetized after finishing.

2.1.8 Anti-corrosion coatings specified in the drawings should ensure reliable protection of articles and their components from corrosion.

2,1.9 All the components, units and articles should conform to the drawings, The components and unit articles should be inter changeable. Adjustments provided for by the drawings are allowed.

2.1.10 Traces of pouring gates, mould pushers (ejectors), traces of trimming of parting line of a mould and machining of pouring gates, pattern drafts etc. on non-mating surfaces of the components of articles should not go beyond the limit of tolerances for dimensions of the part, if no specific instructions are given in the drawing.

Contd...6

8.10F

-5 11

2.1.11 All the parts and units, going into an assembly, should conform to the drawings and bear the required stamps, also they should be thoroughly cleaned from contaminations (dust, chips). Components of the products with traces of corrosion shouldnot be allowed for assembly.

2.1.12 During assembly, riveting and adjustment, partial disruption of passivated film of the components is allowed at the places where they come into contact with assembling tool(screw driver, wrench, hammer, fixture or any other tool).

2.1.13 Selection and adjustment of components of the article during assembly and mounting are permitted only in the case, necessary instructions are in the drawing

2.1.4 Fitting of industrial holders and fasteners(screws, nuts, bolts etc.) should not be a cause of stripping of slots, thread, or rounding off the hexagonal heads. slight buckling of metal in the slots of screws is allowed.

2.1.5 During assembly the fasteners should be tightened upto stop with a normal tool, specified for production method or with a special tool, if the drawing specifies a force to be applied during mounting.

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-3 TY

2.1.16 Componenets of the articles should be reliably ~~reliability~~ tightened; self- unscrewing of screws and nuts, is not allowed; when paint, putty etc are used to prevent the self-unscrewing of threaded joints, it is required to take measures to exclude the possibility of paint, putties etc, getting inside the article.

2.1.17 Componenets of the articles, fastened with nuts, should not turn over.

2.1.18 Counter sunk heads of screws and rivets as well as locking screw ends after being set at their places, should not project above the components of ~~should~~ the articles if there is no specific instructions stated in the drawings.

2.1.19 All the inscriptions on articles or components, excuted by engraving, stamping, photocopying and etching should be legible and easy to read. places of inscriptions, executed by engraving or by punch should be coated with anti-corrosion colourless varnish (for increasing legibility of inscriptions, anticorrosion colour varnishes and enameles may be used as well)

2.1.20 Polish working contact surfaces of contacts to metallic lustre, if no other specific instructions are stated ~~and~~ in drawings.

Methods of polishing and materials to be used should be

contd... 7

specified in the process sheets.

2.2 Basic parameters.

2.2.1 The electric trigger should work trouble-free at an ambient temperature of - 50 to + 70°c.

2.2.2 Supply voltage of electric voltage is 26 V ± 15% DC

2.2.3 Strength of current, consumed by electric trigger at the rated voltage and temperature (+ 20 ± 5°C) should not exceed :

~~a) for switch~~

a) 12.5 A for switching on one coil

b) 22 A for switching on two coils

2.2.4 Insulation resistance of electric circuits ~~are to be~~ as the body should be not less than:

a) 20 Mohm at (+20 + 5°)°C and relative humidity upto 80%.

b) 2 M ohm at (+20 ± 5)°c and relative humidity from 95 to 98%.

2.2.5 Insulation of electric circuits of electric trigger reletiviy to the body should with stand and voltage of 500 AC of effective valve with frequency 50hz for a period of 1 minute at a relative humdity of 80% without break down and spark over.

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2.2.6 The electric trig er compon nets should withstand vibrations parallel to the axis at any of the frequencies from 20 to 80 Hz with over load 4g for a period of 50 hrs.

2.2.7 The electric trigger should withstand minimum 3000 triggerings at a supply voltage of 26V ± 10% and load of 7.5 kgf on the armature.

2.2.8 The electric trigger aramture should move freely without jerks and jemming under the action of magnetic field of the coil and opposing spring. In withdrawn position, the armature should not touch a stop.

2.2.9 Travel of electric trigger armature should be (13 ± 0.5)mm

2.2.10 Maximum pull developed by the electric trigger at an ambient temperature of + 20 ± 5°c and supply voltage 26 + 1 V, should not be less than 10.5 kgf.

2.2.11 The electric trigger should function reliably at least 50 times wang with 7.5 kgf load at supply voltage 22 ± 1 V and ambient temperature + 20 ± 5°c

222.12 Electric trigger should reliably function 3 or 4 times at a supply voltage of (22 + 1) V with 7.5 kgf load on armature and ambient temperature (-50 + 1) o - 5 C.

Contd...9

2.2.13 Electric trigger should withstand 50 successive triggerings at (22 + 1)V supply voltage, temperature (+ 20 ± 5)°C and 5.5 Kgf load on armature

2.2.14 Opposing force of spring should ensure return of armature upto stop.

2.2.15 Plug lead-ing of electric triggers should be splash-proof

2.2.16 Contact resistance between the contacts of plug and receptacle should not exceed 0.01 ohm after 200 switchings-in.

2.2.17 Mass of electric trigger with plug should not exceed 1.3 Kg.

Remark: Class of devices, required for measuring current and voltage is to be above 1 and for measuring ~~full~~ pull is to be above 2.

2.2.18 Electric triggers should be dust-proof.

2.2.19 Pull of electric trigger at the end of armature travel at + 20 ± 5°c ambient temperature and supply voltage (24±1)V should be not less than 18 kgf.

2.3 Completness.the following items comprise the delivery set.

2.3.1 Electric trigger.

2.3.2 Certificate.

Remark: Articles to be exported are accompanied by operating, technical and accompanying documents as per instructions on design, execution and sending of

13 OC

Contd...10

operating technical and accompanying documentation on articles to be shipped for export.

2.4 Marking.

2.4.1 The electric trigger body should have a plate, containing the following:

a) index of article

b) supply voltage

c) factory No of article.

2.4.2 Stamps, confirming acceptance of electric trigger by TID are to be put in paint at the places, specified in the assembly drawing.

2.5 PACKING

2.5.1 Electric triggers should be packed in boxes lined with moisture proof inter-layer, specified by the technial documents, weight of packed box should not exceed 50 kg.

2.5.2 Before packing in boxes, the electric triggers are to be arranged in a container specified by the technical document. Packing should prevent displacement of article.

Remark: The container and packing of products, being exported, are to be made as per the requirements of production order.

Contd...11

-3 TY

3 ACCEPTANCE RULES

3.1 The articles are to be submitted to the customer representative in batches as per the submitting document, signed by the director or factory chief engineer and chief of TID, with the statement on specif special tests log book of prescribed form along with the TID test results.

Volume of batch is to be fixed by the manufacturer in the size not exceeding monthly programme.

Presentation of a batch can be done in parts, as a rule not less then 10 articles in each with a report of the size of the batch at first presentation.
Quantity of submitted articles per batch may be reduced the as well at duplicate presentation at the expense of rejection.

In case of samll batch production presentation of a batch may be carried out in parts of not less than 5 articles. Acceptance includes disassembly of 1 to 2 articles from a set up batch, which is to be conducted by TID

3.2 Approval tests are to be conducted by TID as per the programme and procedure specified in the present technical specifications.

3.2.1 The test results are deemed satisfactory if:

Contd..12

15 6E

3.6 Submittance of one and the same article of one and the same batch of articles should not be repeated more than twice.

3.7 Periodic tests are to be conducted by TID of manufacturing firm on articles which are selected from the submitted batch.

3.8 Periodic tests are to be conducted as per the programme specified in the present technical specifications.

3.9 Periodic tests are conducted once in 1/2 year. Three electric triggers are to be selected for test from the subsequent batch submitted for acceptance.

3.10 The articles which have undergone periodic tests, may be disassembled with the aim to improve the accuracy of the test results and check for compliance of the articles to the technical papers. During disjointing of preliminarily painted surfaces, transfer of joint from one surface to the other is allowed.

Decision as to the results of periodic tests is to be taken after conducting the control disassembly.

3.11 During periodic tests even if a single article ~~cleared~~ CEASED not satisfy the requirements for even one of the items of the present technical specifications, then the tests are to be ~~cleared~~ CEASED till the causes of defects are detected and removed.

Contd...14

3.6 Submittance of one and the same article of one and the same batch of articles should not be repeated more then twice.

3.7 Periodic tests are to be conducted by TID of manufacturing firm on articles which are selected from the submitted batch.

3.8 Periodic tests are to be conducted as per the programme specified in the present technical specifications.

3.9 Periodic tests are conducted once in 1/2 year. Three electric triggers are to be selected for test from the subsequent batch submitted for acceptance.

3.10 The articles which have undergone periodic tests, may be disassembled with the aim to improve the accuracy of the test results and check for compliance of the articles to the technical papers. During disjointing of preliminarily painted surfaces, transfer of joint from one surface to the other is allowed.

Decision as to the results of periodic tests is to be taken after conducting the control disassembly.

3.11 During periodic tests even if a single article fails not satisfy the requirements for even one of the items of the present technical specifications, then the tests are to be CEASED ~~ceased~~ till the causes of defects are detected and removed.

Contd...14 16 OF

3.12 Duplicate periodic tests are to be conducted on doubled quantity of articles, tests are to be conducted after detecting and removing the causes of defects and ~~clearing the~~ clearing the defects .

3.14 If during duplicate periodic tests even a single article is found not to meet the requirements of present technical specifications then the whole batch of articles is to be rejected and returned to the manufacturer.

At the same time further acceptance and delivery are to be ~~cleared~~ CEASED till causes of defects are detected and rectified.

After removing of causes of defect and resuming of acceptance, the periodic tests are to be conducted on two subsequent batches. In case of positive, results of the above mentioned periodic tests, further tests are to be carried out in the established order.

3.15 Packed and sealed articles ~~with~~ which ~~and~~ have under gone approval and periodic tests as a part of a given batch are considered finally accepted and ready for delivery in case of positon results. The articles which have under gone approval tests and in case of obtaining positive results, the periodic tests are considered finally accepted and ready for delivery as well.

3.16 Approval tests.

3.16.1 Approval tests are carried out as per the programme and in sequence stated in table 2.

Contd..15

Table No 2

Description of tests	Requirements of Technical Specifications	Procedure as per Technical specifications	Remarks
Visual inspection and measure of armature travell	1.2 2.2.9	4.8 4.1	
Smoothness of armature travell	2.2.8	4.2	
Opposing force of spring	2.2.14		
Maximum pull at ambient temperature (+20±5)°C and supply voltage (26±1) V	2.2.10	4.3	
Power of consumed current	2.2.3	4.4	
Reliability of triggering at supply voltage (22 + 1) V and ambient temperature (+20±5)°C with load 7.5 kg	2.2.11	4.5	
Checking of insulation electric strength.	2.2.5	4.7	
Checking of insulation resistance.	2.2.4 a)	4.6	

Remarks: 1. The percentage of articles to be checked to be sample from the total number of submitted electric triggers.

2. The selected articles meant for random tests should not be replaced with others during acceptance.

Contd...16

3. - 3 TY

3.22.1 Periodic tests.

3.22.2 Periodic tests are to be carried out as per the programme and order specified in table 3.

Description of tests	Requirement of Technical Specifiee cations	Requirement as per Technical Specifi cations	Remarks
(1)	(2)	(3)	(4)
Approval tests	1.2,2.2.9	4.1,4.2	
	2.2.14	4.3,4.4	
	2.2.10	4,5,4.6	
	2.2.3		
	2.2.11		
	2.2.4		
Checking for pull at lower temperature	2.2.12	4.9	
Checking for put at higher temperature	2.2.13	4.10	
Tests at high humidity	2.2.4 B)	4.11	
Checking for splash proofness of plug leading lead-ins	2.2.15	4.12	
Tests for vibration strength	2.2.6	4.14	
Tests for service life	2.2.7	4.15	
Checking for mass	2.2.17	4.16	

Contd...17

1	2	3
Checking of pull of electric trigger at the end of armature travel	2. 19	4.19
Checking for dust proofness	2. 18	4.18
Checking of value of contact resistance between the plug contacts and receptacle.	2. 16	4.13
Test for transportation	-	4.20
Checki disassembly	1.2	4.8,4.17

4 TESTS PROCEDURE

4.1 Armature travel is checked by measure with measuring t l having an accuracy of 0.1 mm.

The projecting part of aramtu e shank is measured first in OFF position and then in pull d-in position of aramatu The differential of the measured values is armature travel, it should be with in limits of (13± 0.5) mm.

4.2 Smoothness of armature travel and opposing force of spring are to be checked by putting weights on the armature shank in its vertical position. Jerks and jammings should not occur during armature movement. Opposing force spring should be with in limits of 0.4 to 1 kg.

Contd...18

4.3 Checking for maximum pull at (+ 20 ± 5)°c temperature and supply voltage (26 + 1) V is to be carried out by to 2 to 3 triggerings of the electric trigger mounted on a special stand.

The electric triggef is considered serviceable, if it functions with a load of 10.5 kgf.

4.4 Check for strength of current, consumed by the electric ~~tr~~ trigger is carried out simultaneously with the test as per item No. 4.3 of the given procedure, at the last ~~a~~ triggering of electric trigger.

Strength of current, consumed by the electric trigger should not exceed 12.5 A when one coil is switched on and 2.2.A when two coils are switched on .

Further tests of electric triggers are to be carried out after keeping them for 1 hour at ~~the~~ temperature (+20 ±5)°c.

4.5 Reliability of triggering at a supply of voltage of (22+1) V and ambient temperature (+ 20 ±5)°c with 7.5 kgf load is to be checked on a special stand. The electric trigger is switched on 50 times in succession. Duration of each switching should not exceed 18 Ms. Internals between to successive switchings should be 1 ± 10% . When the electric trigger is in operation jamming ~~jointing~~ of armature and its sticking to stop should not occure.

Contd..19 22 OF

4.6 Insulation resistance is to be checked at (+20 ± 5)C temperature by means of megohmmeter of a rated voltage of 500 V. The check is carried out between the current conducting circuits and body. The test is conducted at a relative humidity of 80%. The insulation resistance should not be less than 20 M ohm.

4.7 Insulation electric strength between any terminal of the coil and the body i s to be checked on a special unit having a power supply source of 0.5 kv.A at a rated voltage of 500 V and frequency 50 Hz .

Voltage is to be fed gradually up to the rated value and similarly gradually reduced after keeping the voltage at this level for 1 min. The test is carried out at (+ 20 ± 5)°c temperature and relative humidity upto 80%. Duration of test can be reduced to 1 sec. provided the testing voltage is increased by 25%.

4.8 Overall, mounting and connecting dimensions of electric triggers are checked in 10% of the submitted batch. One electric trigger is to be subjected to a check disassembly, reliability of assembly, tightening and locking of screws as well as compliance of basic dimensions to drawing are chekced.

External appearance is checked for compliance with requirements of drawings. During testing of appearance of electric triggers, check marking and filling of submitting

contd..20

documents as well as confirmity of date of manufacture, time of submittance and numbers of electric triggers indicated on the factory inscription plate and in certificate. Time interval between date of manufacture and time of submittance for acceptance should not exceed one month.

4.9 Pull at a low temperature of - (50° ± 1.5)°C is to be checked at a supply voltage of (22 + 1)v on a special stand.

To do this the electric triggers are to be preliminarily kept in cold chamber for 2 hrs from the moment the required temperature is obtained. The check is to be carried out not later than three minutes after the electric triggers are taken out of the chamber. The electric trigger should operate with a load of 7.5 kgf for 3 to 4 times.

4.10 Checking of pull at a high temperature of (+70±5)°C is carried out on a special stand after keeping in heat chamber for 2 hrs from the moment the required temperature is obtained. The check is to be carried out not later than three mingtes after the electric triggers are taken out of the chamber. The electric trigger should withstand 50 successive triggerings with 5.5 kgf load, during which there should be no jamming of aramture or sticking of armature to stop.

Contd..21

4.11 The test for moisture resistance in moist chamber at a relative humidity of 95 + 3% and ambient temperature of + 20° ± 5°c for 48 hrs. Insulation resistance of electric circuits as to body is measured with megohmmeter of rated voltage 500 V at the time removal triggers out of the chambef (but not later than 3 minutes after the removal) The resistance should be not less than 2 M ohm.

Corrosion should not be on the components of devices.

4.12 Splash-proofness of plug lead-ins is to bechecked on a special unit, which ensures an artificial rain ~~in~~ with an intensity of 5 mm per min at 45 ± 10° angle to the horizon for a period of one hour. Water temperature should be below the temperature of the article by (5 to 10)°c. After test the plug connectors are to be wiped and opened. Absence of traces of water on contacts under the rubber pad confirms splash proofness of plug connector.

Remarks: A plug connector wired with a standard with PVC insulation 1x1.5 is to be taken for the check. The top nut of plug connector should be drawn up tightly.

Contd...22

-3 TY

When testing plug lead-ins in electric triggering, the bottom nut should be sealed along its perimeter with plasticine or with any other comparable material.

4.13 The contact resistance value between the contacts of plug and receptacle is to be checked on a special unit, which permits to carry thorugh the contacts currents with a strength of 5A ± 10% - and voltage 36 V ± 10% for a period of 3 hrs. There after 200 successive insertings of plug into receptacle are performed, then contact resistance value is measured between each contact of plug and receptacle. The plug and receptacle should be de-energized during insertings.

Remarks: Contact resistance of plug lead-ins contacts is to be checked separately in plug lead-in, taken from the article under the test after completion of type tests. The test set up is rheostatic.

4.14 Test for vibration resistance is to be carried out at any of the frequencies ranging from 20 to 8 Hz with 4 g overaload on two electric triggers for a period of 50 hrs. After every 10 hrs of exposure to vibrations the check for reliability of triggering as per the procedure, specified in item No.1 and the check for value of armature travel as per the procedure, specified in item No.1 should be conducted.

Contd...23

4.15 The electric triggers should withstand 3000 triggerings at 26 V ± 10% supply voltage and 7.5 kgf load on armature. The tests are carried out in series, each series consists of 10 cycles. Each cycle consists of 30 triggerings for (15 ± 5) . The time interval between cycles is to be not less than 1 hr .

4.16 The mass is to be checked by weighing ~~for~~ on 4 kg industrial balances with weighing limit upto 5 kg

4.17 During a check disassembly the electric triggers, are checked for compliances with design by visual inspection and by measuring geometrical dimensions of components and units. List of components and units, which should be measured and checked for compliance of mateial is to be established for each approval test by the customer.

4.18 During the test ~~of~~ for dust-proofness, the electric triggers are placed in a cubic box of 1 m^3, containing 4 kg of cement poder. The test lasts for 5 hrs during which the cement is stirred up with a current of air every 15 min . on completion of test the electric triggers are wiped ~~le~~ clean from dust on the outside and disassembled. The electric triggers are considered to have passed the tests if the amount of dust penetrated inside the the electric triggers is not visible to the naked eye.

Contd..24

4.19 Pull on of electric trigger at the end of armature travel is determined by switching twice on thrice on a special stand (at the temperature of 20 ± 5°c). The electric trigger is considered serviceable, if it with holds in switched state at (22 + 1) V supply voltage a load of 18 kgf and at (24 + 1) V supply voltage a load of 20 kgf.

4.20 Transportation test are conducted on impact test stands in packing, specified in the technical documents in de-energized state of articles, in position perpendicular to the axis of electric trigger. With frequency 40 to 75 impacts per minute there should 15000 impacts ~~it be~~ should be done at accelration 10 g + 2 g and 5000 impact at accelration 15 g ± 2.

Transportation tests may be carried out using articles selected for periodic tests. In this case check the article before and after transportation as per programme for approval tests and then conduct periodic tests.

Transportation test is conducted with the first three batches of articles as well as in case of changes in design, production process, basic materials of components and assembly units of the article or change in the packing design provided they may affect transportability of article.

The chief engineer of master copies holder plant decides if it is necessary to conduct tests in each of the cases.

Contd..25

The test necessity, as this takes places should be stated in release for change as well as a quantity of batches to be used for the test.

5 TRANSPORTATION AND STORAGE

5.1 The electric trigger should ~~meant~~ meet the requirements of the present techniol specifications after transportation by any means of transport to any distances at any speed in assembled article or packing of manufacturer.

5.2 Electric triggers, packed in boxes before delivering to the ~~considignee~~ consignee are to be stored in closed premises. This premises should be free from cheemical ~~resquest~~ reagents which may harmfully affect manufactured articles.

5.3 Storage with electric triggers should be stored in the stock rooms on special racks, preventing any damage. Temperature in a stock room should be maintained from ~~at~~ range + 5 to + 35°c at relative humidity of 80%.

6. LIST OF APPENDICES

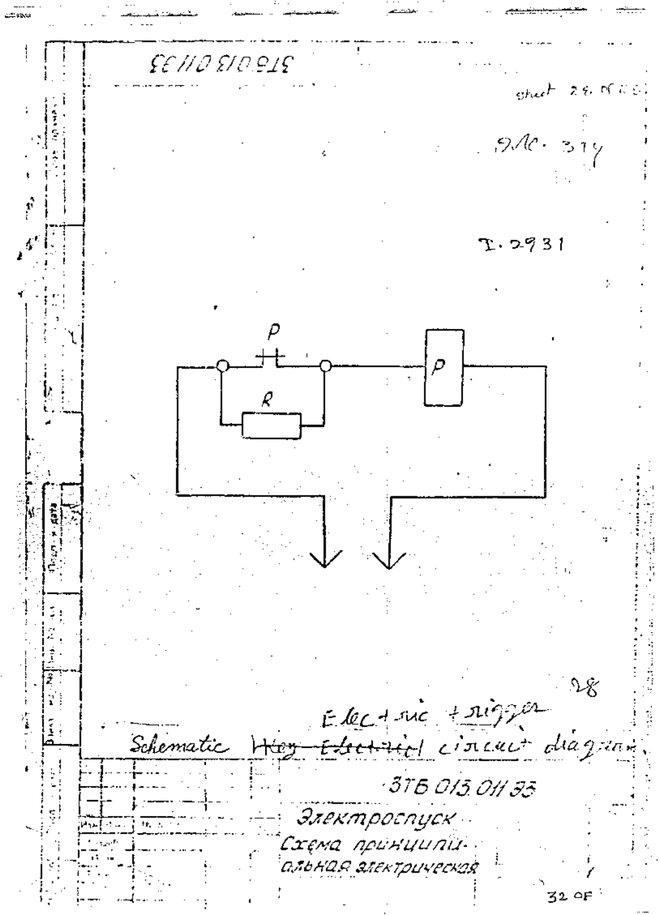
6.1 General drawing 3TF .013.0016F

6.2 Outline drawing 3TF.013.011 [illegible]4

6.3 Circuit diagram 3TF.013.011-93

29 OF

Contd....26



28

Electric trigger circuit diagram

Schematic ~~Key Electric~~ circuit diagram

3ТБ 013 011 33

Электроспуск

Схема принципиальная электрическая

32 OF