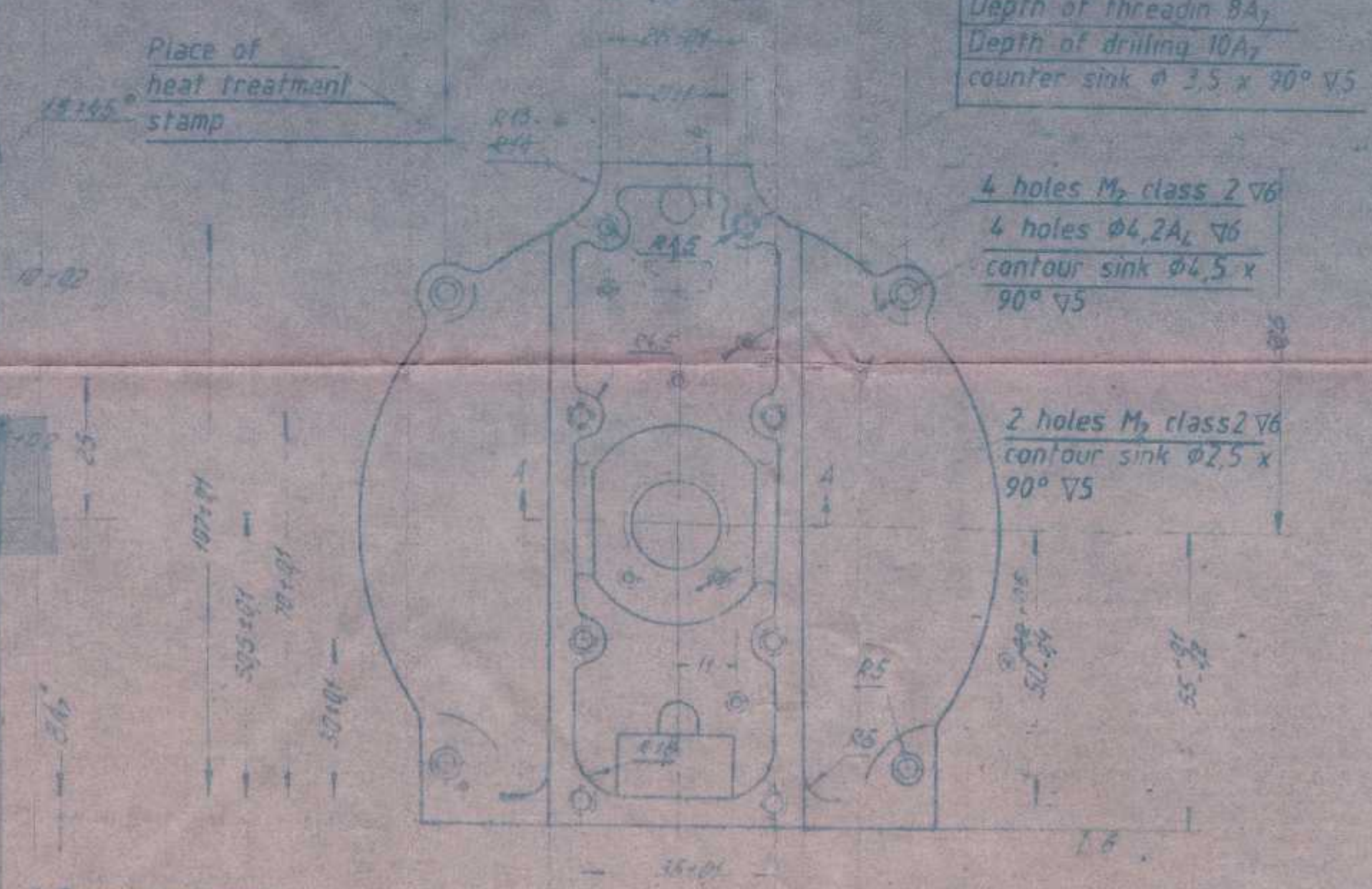
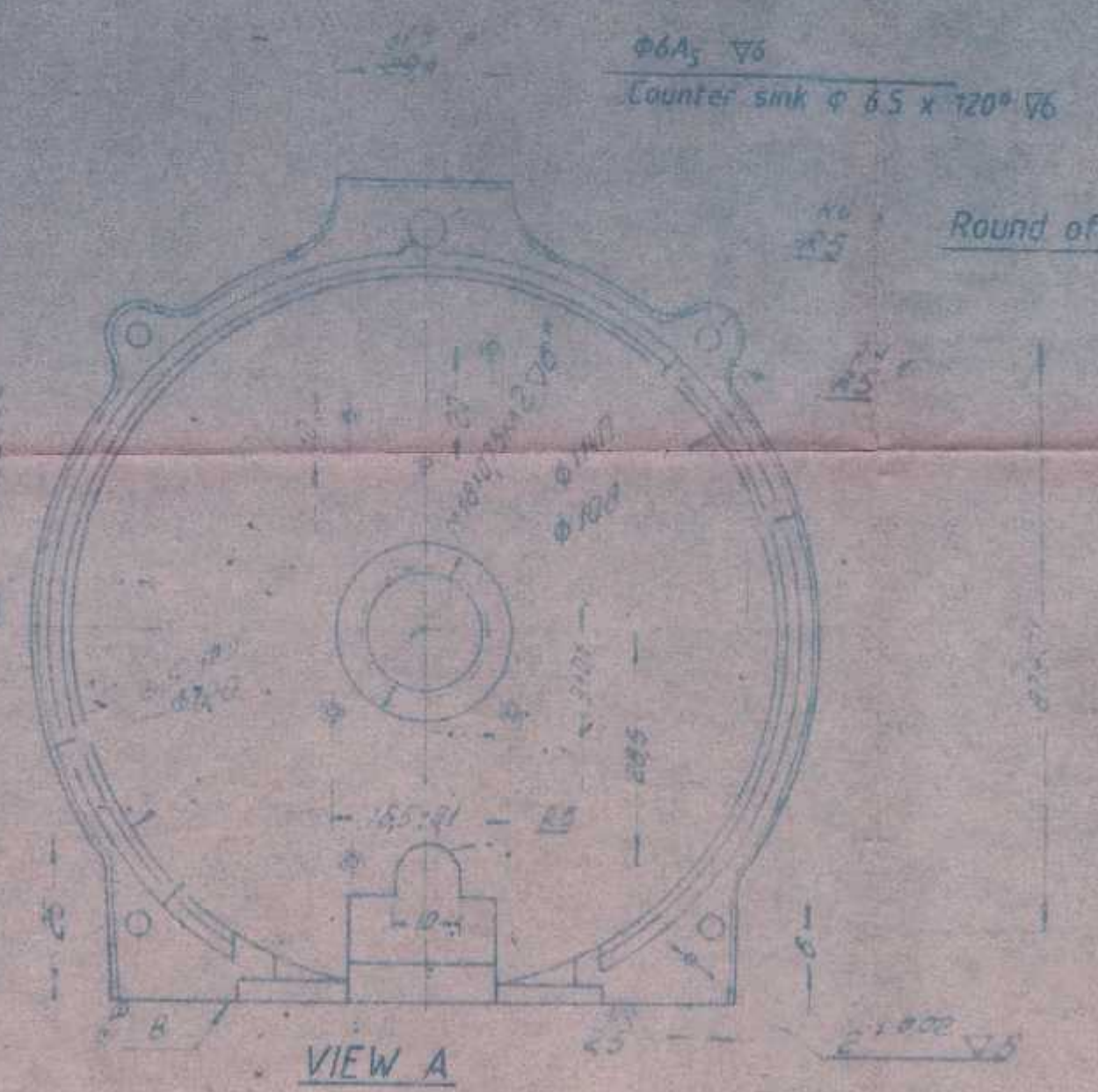
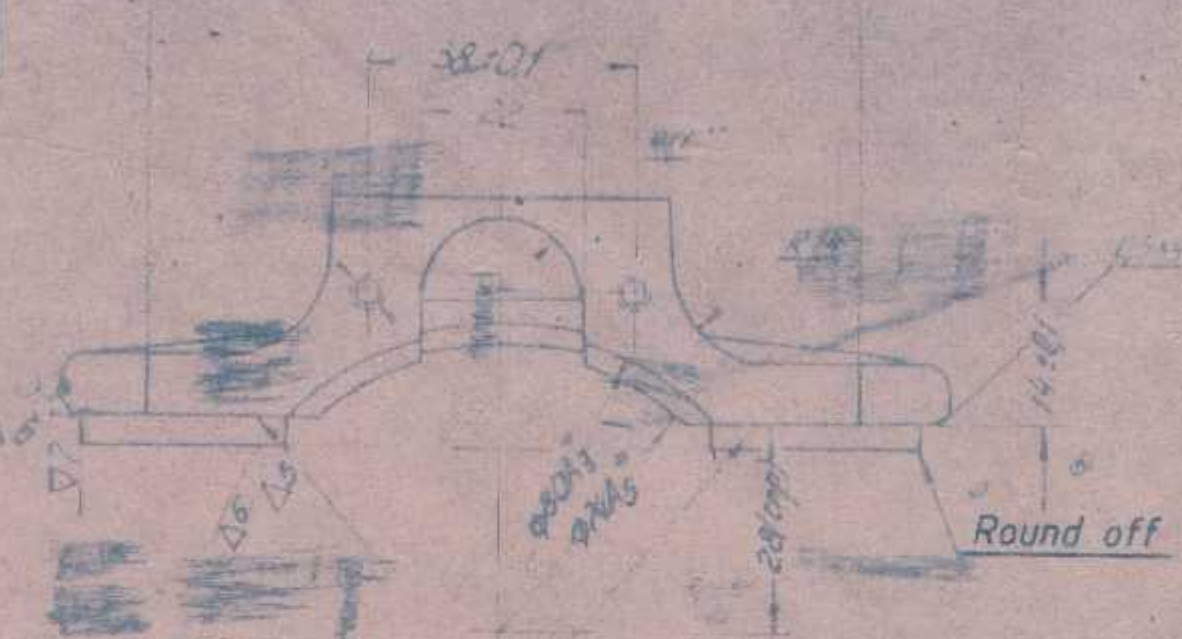


Unless otherwise specified



2 holes M3 class 2 V6
 counter sink φ 3.5 x 10° V6
 Depth of drilling 7.5 A7
 Depth of threading 6 A7



1. Pressure die casting.
2. Class of accuracy AT-3 as per OST 14.1154-72.
3. Ageing is performed after casting at $t = +290^\circ - 4$ hours, and $t = 500^\circ - 2$ hours.
4. Tolerances on free dimensions are as per 722 AT (Except casting).
5. *Dimensions M18, φ 80 A3, φ 74 A5, 8 A7, 3A5, 55.8, 2 are obtained in assembly 127-Cb24.
6. Perform unspecified radii upto R3.
7. Part may be made from alloy Al-9, surface finish V5 is provided instead of V.
8. Deviation of symmetrically arranged elements from the axis of symmetry should be in the limits of tolerance on dimension.
9. Technical requirements are as per OST 1.80020.71 (2nd group).
10. Pattern draft for shaft - 30' towards decreased dimensions, for hole - 1° towards increased dimensions.
11. Nonflatness of surface A should be in the limits 0.05 mm.
12. Perform chamfer ** along perimeter, except Plane B.

Coating: See drawing 127-1624

S/N	SHEET	DOC NO	SIGN	DATE
DRAWN BY		PRBARU		19.5.84
EDITED AND CHECKED BY		J.K. JAIN		25.5.84
FOREMAN OF DC		S.H. CHA		26
DIVISIONAL OFFICER		D.A. CHA		26
		NAME	SIGN	DATE

COVER

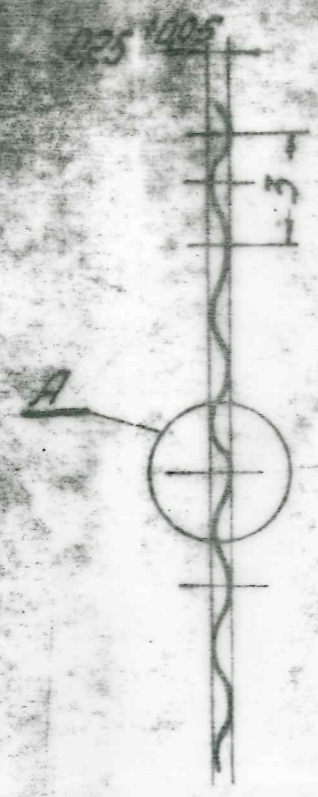
Aluminium, alloy Al-2
GOST 2685-75

127-30	
SHEETS	WEIGHT/SCALE
2160	1/1
TOTAL SHEETS	
ORDNANCE FACTORY PROJECT HYDERABAD	

Unless otherwise stated.

127-1-2-3

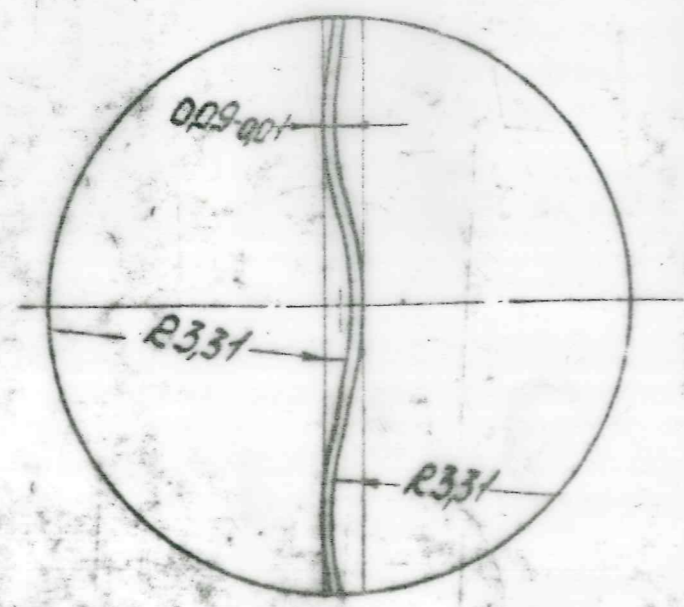
1270



Designation of part	A MM	B MM	Weight of part in g
127-1	48	4.8	0.14
127-2	30	3.8	0.08
127-3	39	3.8	0.1

- 1). Roll upto thickness 0.09 to 0.01 mm.
- 2). Heat treatment and stabiliation is as per instruction 5T-64.
- 3). Tolerance on free dimensions is as per 722AT.
- 4). Perform drilling.

A
M20:1



COATING IMPREGNATE WITH OIL MC-20

127-1-2-3

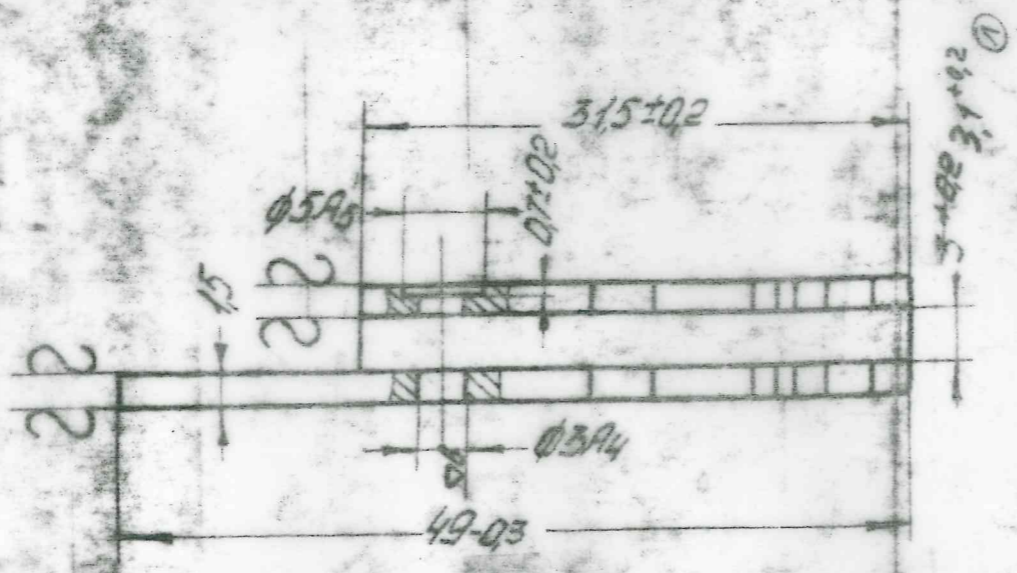
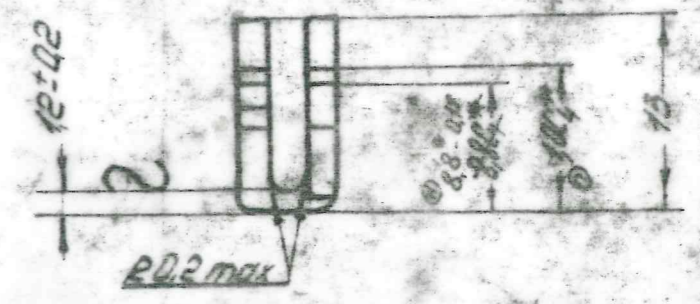
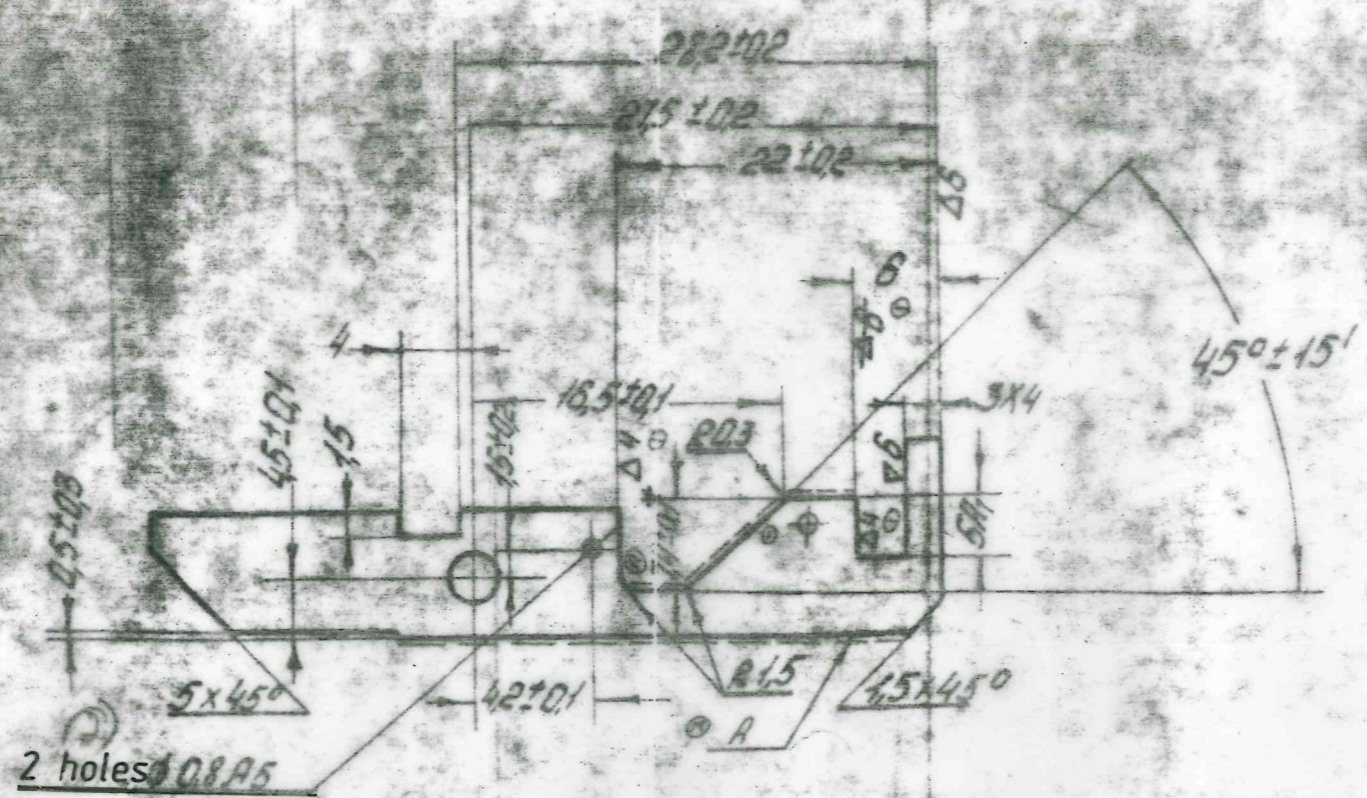
SNOSHT	DOC NO	SIGN	DATE
DRAWN	BHUSHAN		18.5.84
EDT,CHKD	D.K.JAIN		19.5.84
F/M,DC	S.HRAG		3/6
DIV,OFFR	D.A.		1/16
	NAME	SIGN	DATE

CORRUGATED STRIP

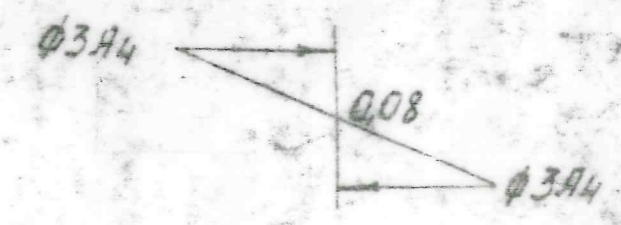
Strip 65Γ-Tw-01,GOST 2283-79.

SHEET	WEIGHT	SCALE
9	0.12	
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

Unless otherwise specified



Eccentricity



Coating :- / Chrome, 9 microns, wear resistant.

- 1) Polish surfaces indicated with ----- to $\nabla 8$ before coating. Polish surface A after coating.
- 2) Difference in dimensions, indicated with any asterisk, for both the flanges should not exceed 0,1 mm.
- 3) Dimension $1,2 \pm 0,2$ is given after polishing.
- 4) Tolerances for free dimensions are as per 722AT.

SN/SH	DOC NO	SIGN	DATE
DRAWN	Y.R.Ganesh		14.5.84
EDT,CHKD	D.K.JAIN		17.5.84
F/M,DC	SH.RAO		3/6
DIV.OFFR	D.A.		1/11
	NAME	SIGN	DATE

127-4

SLIDE BLOCK

Steel 20_n GOST 16523-70

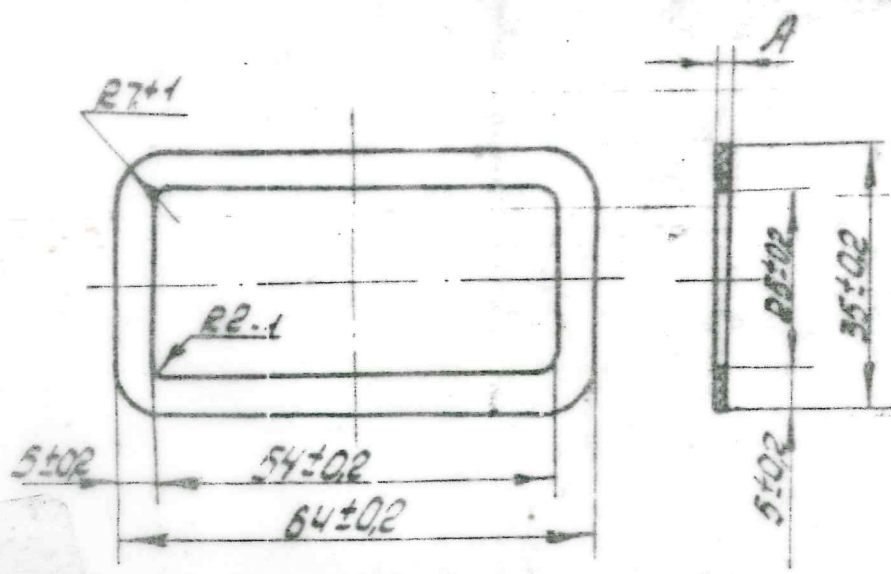
SHEET	WEIGHT	SCALE
1	73g	1:1

TOTAL SHEETS

ORDNANCE FACTORY
PROJECT
HYDERABAD

127-5/31

2



DRG.NO	AMM	WEIGHT OF PART.
127-5	1±0.1	1g
127-31	1,5±0,2	1,54g.

127-5/31

SNOSHT	DOC NO	SIGN	DATE
DRAWN	P.R.BABU		14.5.84
EDT,CHKD	D.K.JAIN	<i>[Signature]</i>	17.5.84
F/W,DC	S.H.RAO	<i>[Signature]</i>	3/6
DIV,OF R	D.A. [unclear]	<i>[Signature]</i>	4/6
NAME		SIGN	DATE

GASKET

Rubber 1847
Tech. Spe (TY) 38.005.838.70.

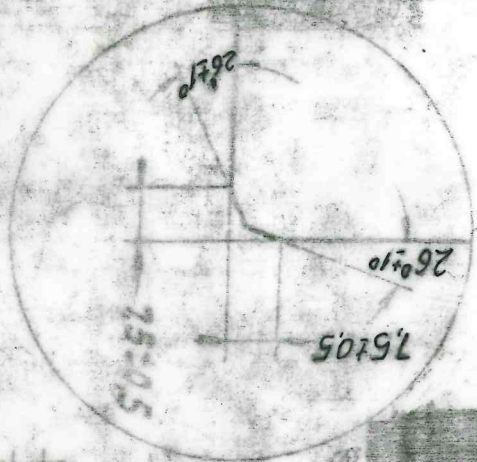
SHEET	WEIGHT	SCALE
A		1:1
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD		

HYDRABAD		GLASS
ORDNANCE FACTORY PROJECT		
TOTAL SHEETS		
16.150g	2:1	
SHEET WEIGHT SCALE		

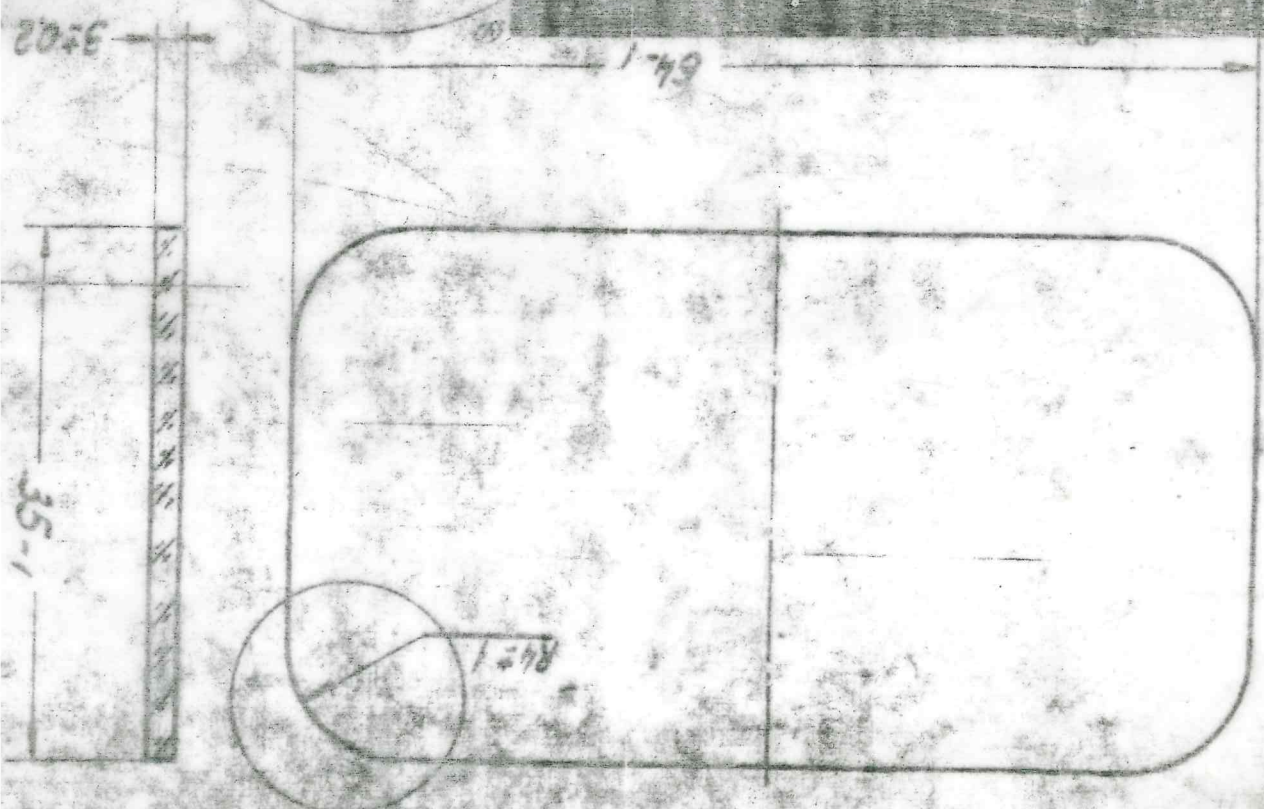
DATE	SIGN	NAME
4/16	[Signature]	D. B. KHAN
3/6	[Signature]	S. H. RAO
24.5.81	[Signature]	D. K. JAIN
16.5.81		P. RABU
DATE	SIGN	NO

127-6

Alternate manufacturing method of gla



1. Technical requirements are as per TY 21-PCCP-234-79.
 2. Material - glass GOST 111-78.



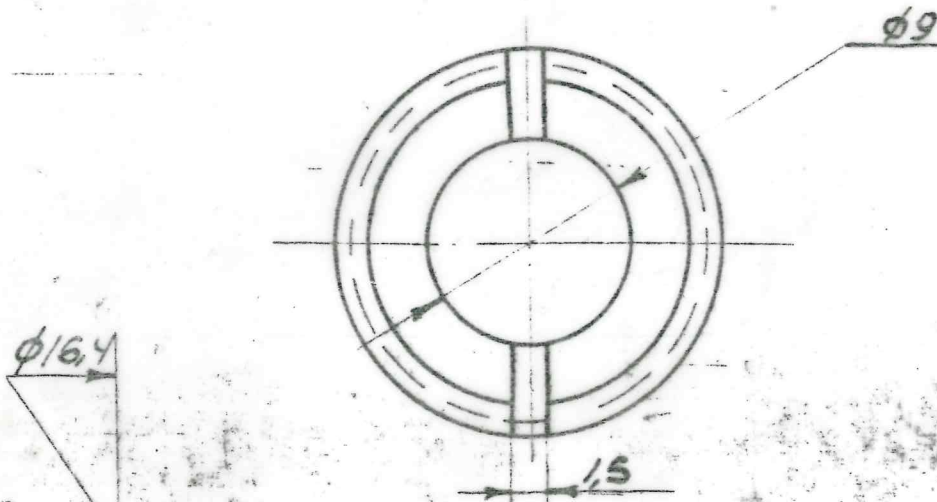
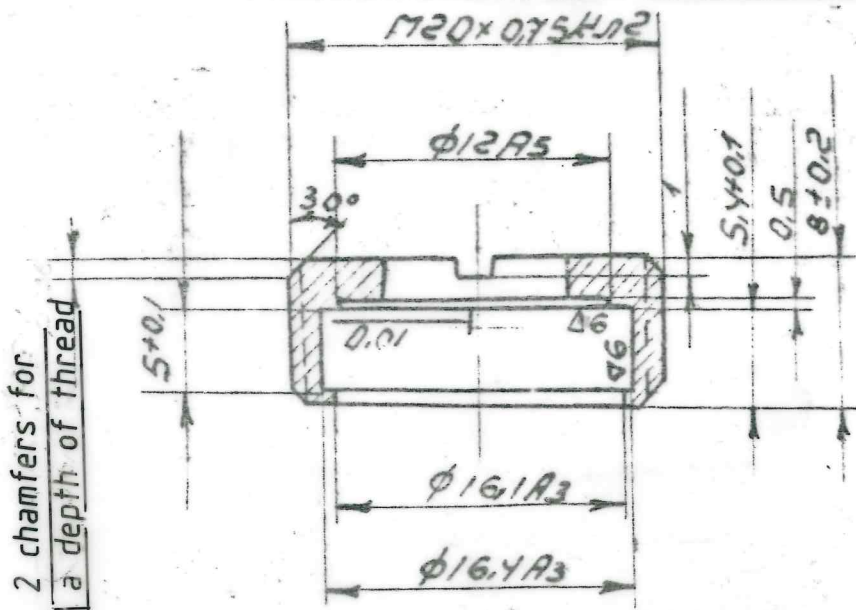
2

127-6

127-64

▽5 Unless otherwise specified

Coating : Anodically oxidised chromated.



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

SNOSHT	DOC NO	SIGN	DATE
DRAWN	Y.R.Ganesh		14,5,84
EDT,CHKD			
F/M,DC	S.H.RAO	Dr	1/6
DIV.OFFR	D.A. Rao	John	2/6
	NAME	SIGN	DATE

THREADED PLUG

Rod $\phi 1T$ GOST 21488-76.

127-64

SHEET WEIGHT SCALE.

A 287g 2:1

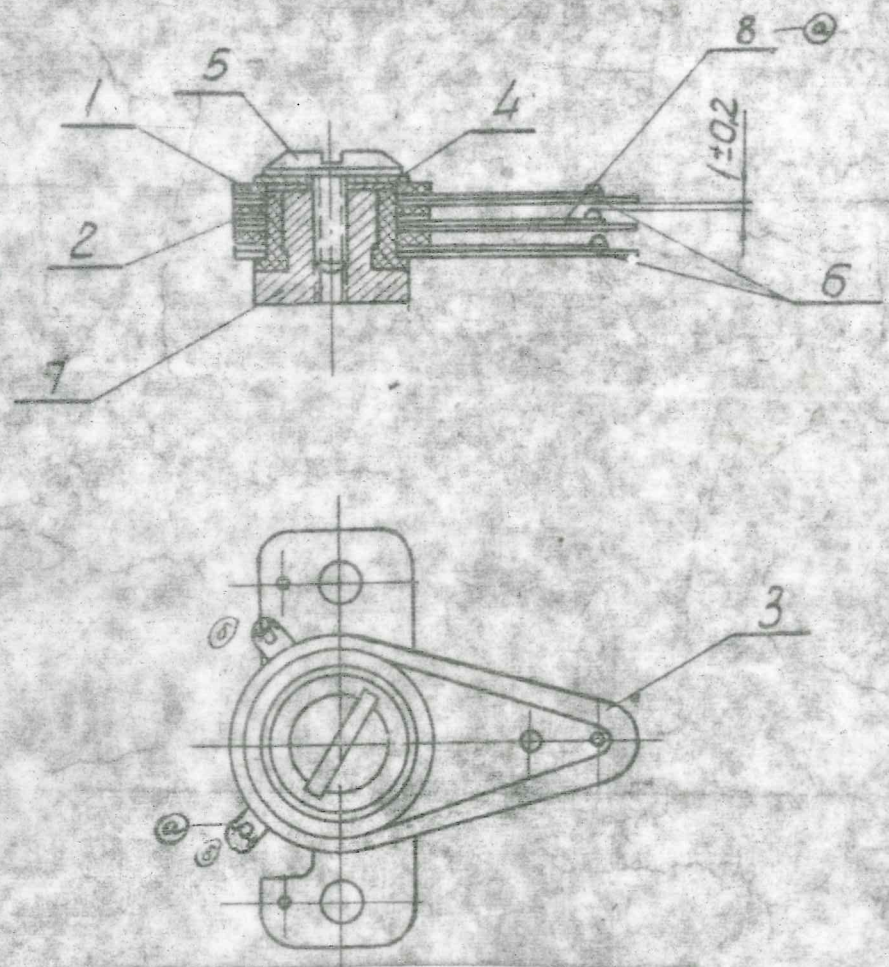
TOTAL SHEETS

ORDNANCE FACTORY
PROJECT
HYDERABAD

D-130-131

127-C622

Perusap. No. _____
 Yasaqat: _____
 Hetafa nomerleri: _____
 No putye: _____



Adjust dimension $1^{+0.2}$ with washers part Ref. No. 2.
 Insulation resistance should not be less than 80 megohms.

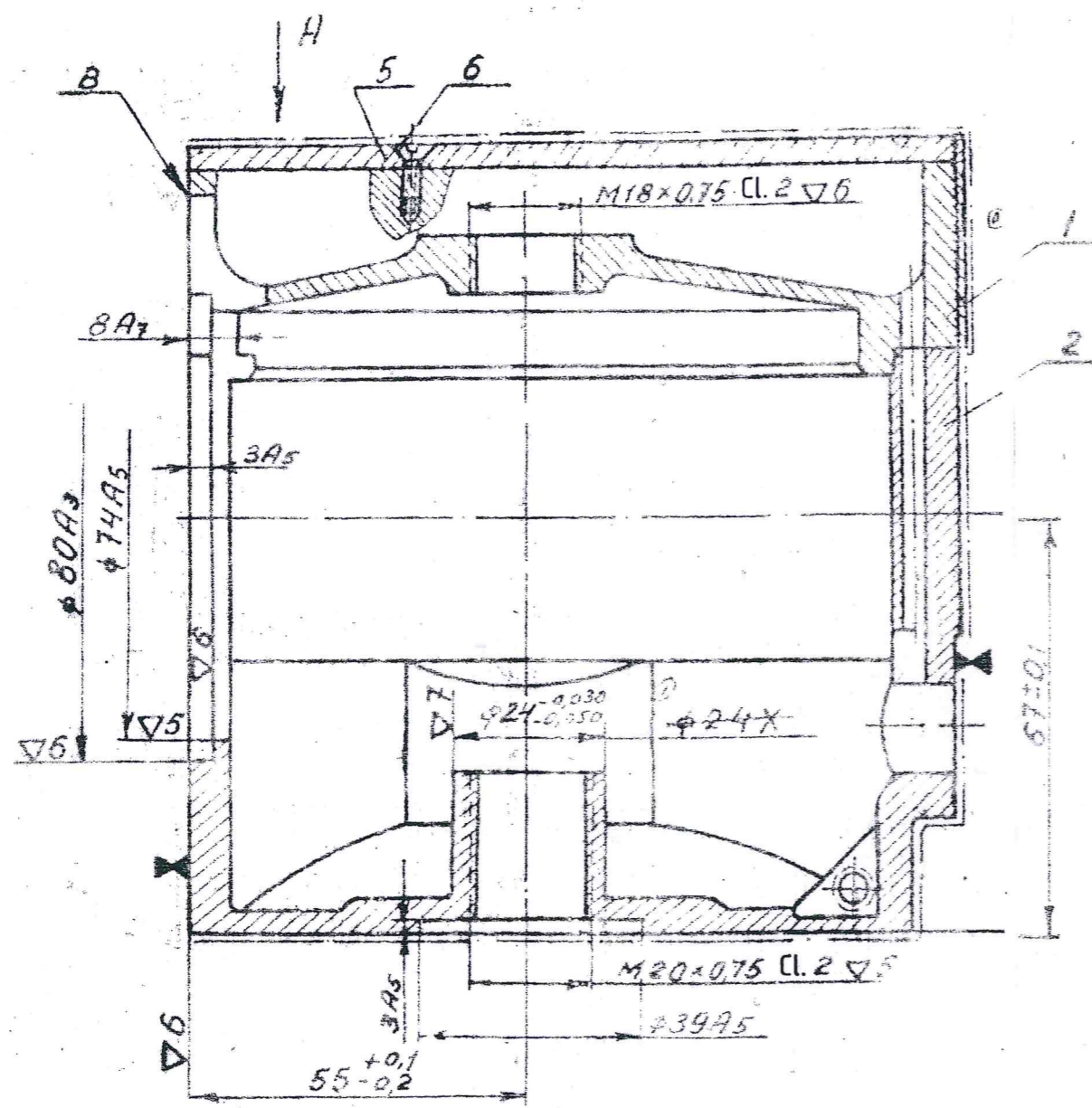
8	127-cb12	Contact	1	
7	160-cb71	Contact support	1	
6	160-cb22	Contact	3	
5	160-86	Screw	1	
4	160-85	Washer	1	
3	160-39	Gasket	3	
2	160-34	Washer	5	
1	160-33	Insulation washer	3	
S.No.	DESIGNATION	DESCRIPTION	Qty	Remarks.

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

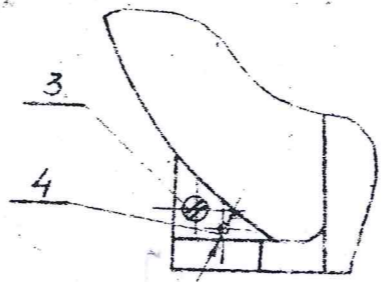
CONTACT UNIT

SHEET/WEIGHT/SCALE
127-C622
TOTAL SHEETS
ORDNANCE FACTORY PROJECT HYDERABAD

127-62 24



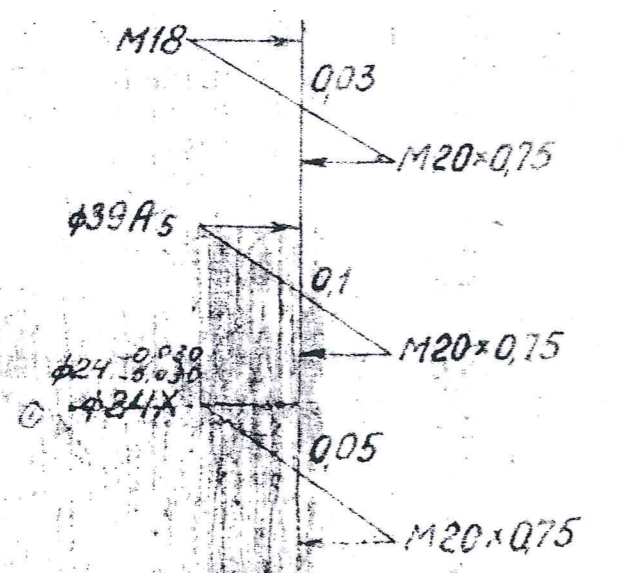
VIEW-A



Drill and ram hole $\phi 19^{+0.06} \nabla_6$ in part 2 through part 1 to 3 depth 12A7 and secure it with pin.

1. Lap plane B.
3. Coating: Part 127-30 and 127-34 are chemically oxidized. Part 127-62 is anodically oxidized, chromated. Surfaces indicated with ----- are coated with enamel M/1-165, Silver. Internal surfaces, surfaces indicated with X and holes on parts 127-34 and 127-62 are not coated with enamel 3M. M/1-165.

REF. NO.	DESIGNATION	DESCRIPTION	QTY.	REMARKS
6	3177A-3-8-kd	Screw	1	Auxiliary
5	127-62	Cover	1	
4	3484A-2C3-12	Pin	1	Auxiliary
3	3169A-4-14	Screw	4	Auxiliary
2	127-34	Body	1	
1	127-30	Cover	1	



SLNO	SHEET	DOCNO	SIGN	DATE
DRAWN BY		CH.V.RAO		18.5.84
EDITED AND CHECKED BY		D.K.JAN		19.5.84
FOREMAN OF DC		S.H.RAO		4/6
DIVISIONAL OFFICER				4/6
		NAME	SIGN	DATE

BODY WITH COVER

127-62 24

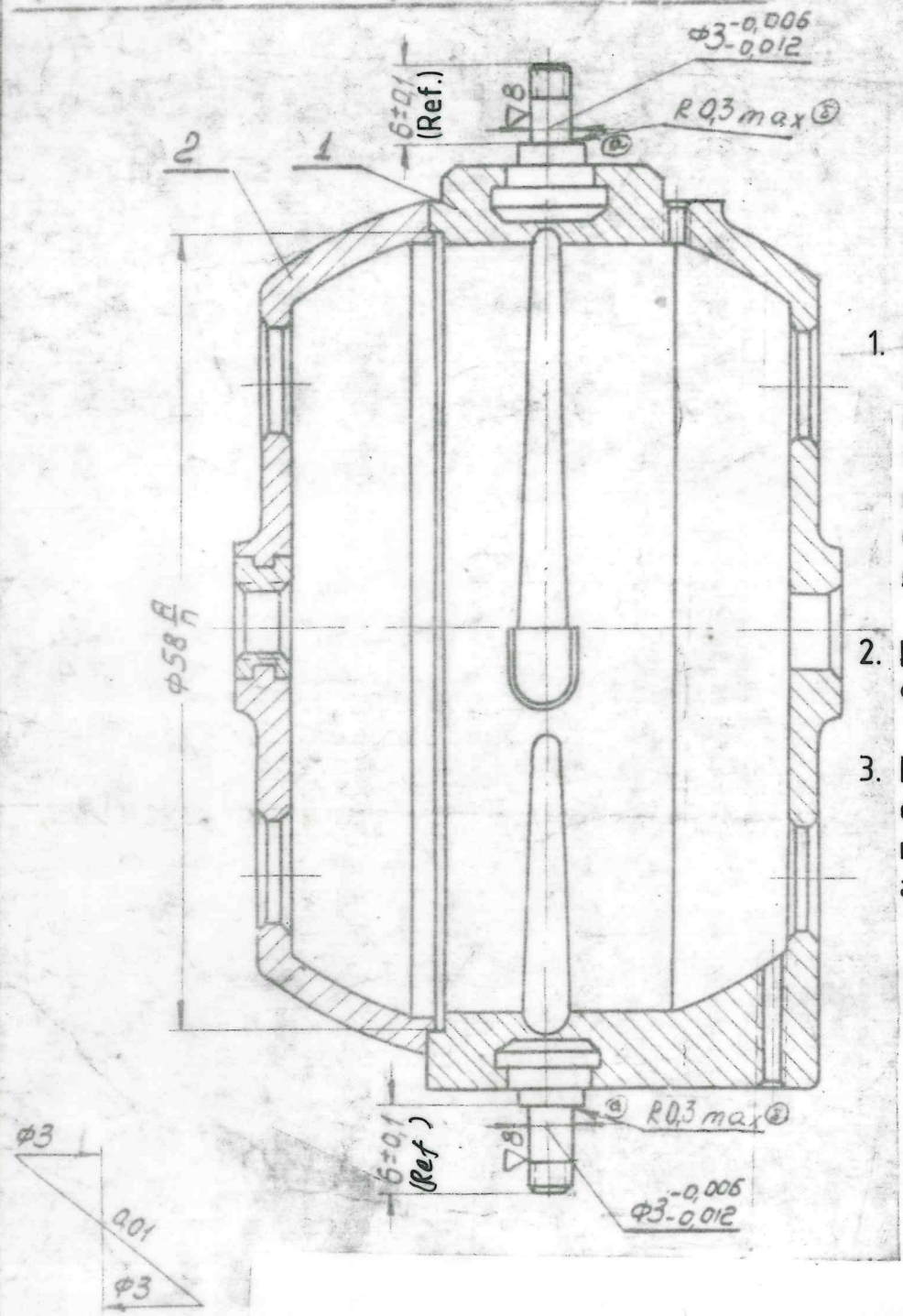
SHEETS	WEIGHT	SC

TOTAL SHEETS

ORDNANCE FACTORY PROJE HYDERABAD

D130-77

127-0526



1. Make body, Ref. No.1, and cover, Ref. No.2, into a set in such a way that the difference of deformation under load of 25Kg, should not exceed 0.002 mm.
2. Blunting of thread upto $\phi 3 \begin{matrix} -0.06 \\ -0.012 \end{matrix}$ is allowed.
3. Local damage of scuffing of coating by tool should not exceed that of the adopted standard.

2	127-c520	Gyro unit cover	1	
1	127-c519	Gyromotor body with nozzles and axles	1	
REF. NO:	DESIGNATION	DESCRIPTION	QTY	REMARKS

SN	SHT	DOC NO	SIGN	DATE
DRAWN		CH.V.RAO	<i>Ch.V.</i>	18.5.84
EDT	CHKD	D.K.JAIN	<i>D.K.J.</i>	19.5.84
F/M, DC.		S.H.RAO	<i>S.H.R.</i>	3/6
DIV. OFFR		D.A. RAJU	<i>D.A.R.</i>	4/6
		NAME	SIGN	DATE

GYROMOTOR BODY WITH COVER

SHEET WEIGHT	SCALE
127-0526	
TOTAL SHEETS	
ORDNANCE FACTORY PROJECT HYDERABAD	