

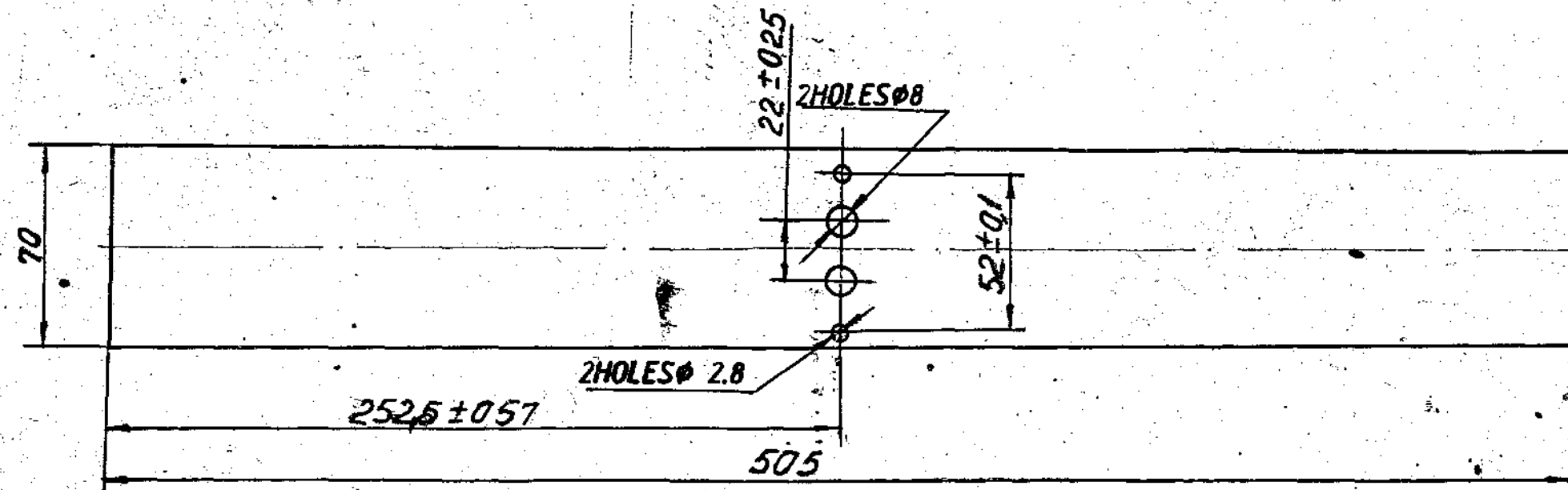
893.252H

Результ. №  
Утвердил

2

1. Tolerances for free dimensions are as per accuracy class 7, ost 1010.

2. Alternate material is glass textolite CT-II GOST 12652 -74.



\* GLASS TEXTOLITE OF GRADE CT-1  
GOST -12652-74

123

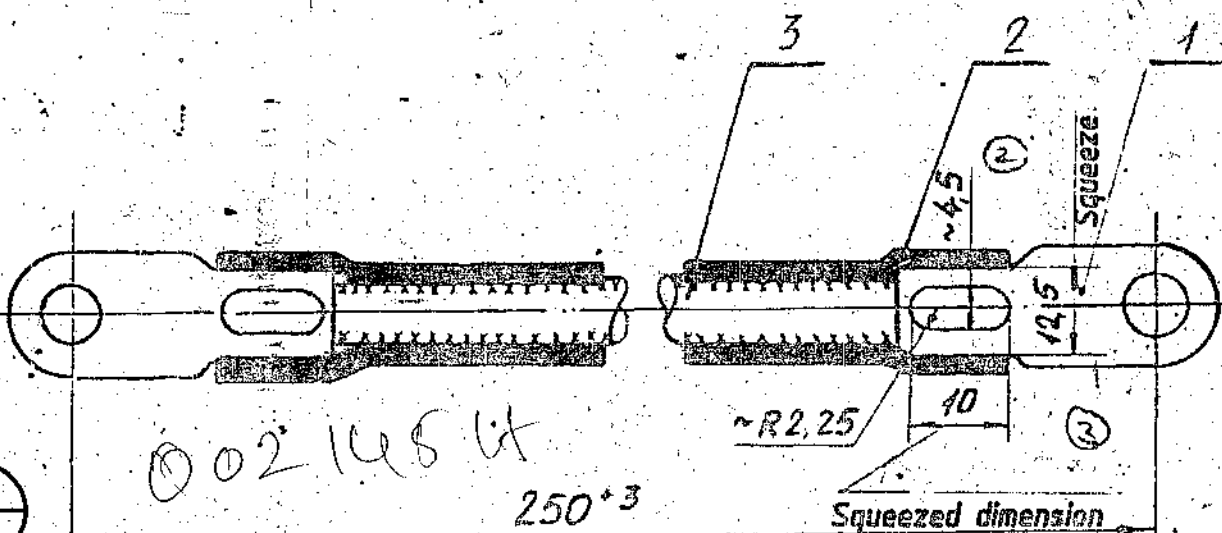
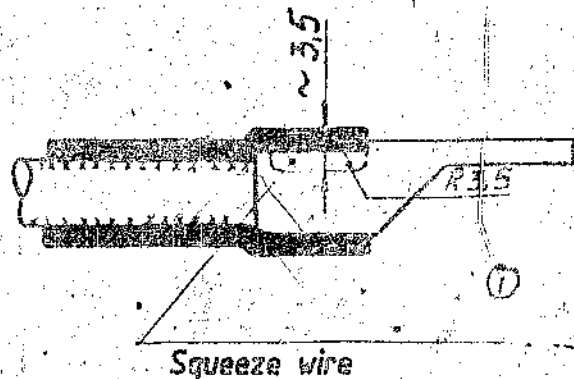
PILOT SAMPLE SHOULD BE APPROVED BY A.I.S.P. BEFORE BULK PRODUCTION

EST. MASS	0.025 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS & LETTERS
ISSUE DATE	NATURE OF AMENDMENTS	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE
DRILL	SCALE: 1:2	MATERIAL * SEE ABOVE
CHKD	DIMENSIONS IN mm	USED ON: 27Q.034.H
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLER (E.G. INSPECTION (MAY VEHICLES) AVADI)
APPD	ALL THREADS CONFORM TO	INSULATION GASKET
DATE 9-9-87		D'S CAT NUMBER
		DRAWING NUMBER 893.252 H

D83

700 042H

14  
20



002145 H

250<sup>+3</sup>

AMDT. NOTN. NO: 220-70 8

03

Sl. no	Designation	Description	QTY	Remarks
3	700.042H-1	Conductor bNB 50mm <sup>2</sup>		
	TY 16.505.911-76		1	Without drawing
2	700.042H-2	Sleeve III-TB-40-230-14-105		
	GOST 19034-73		2	Without drawing
1	712, 199H ✓	Cable lug	2	

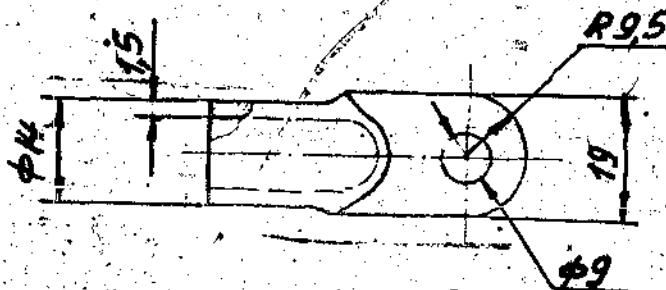
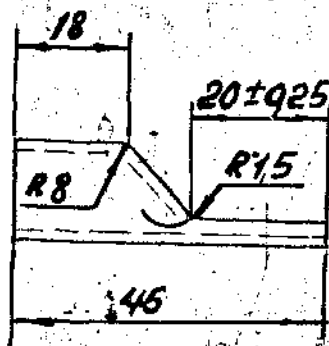
PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

EST. MASS		TO BE STAMPED OR MARKED WHERE INDICATED THUS ( LETTERS )	
0.155 Kg		(35)	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE			
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL :-	USED ON :- 002-145 H
DRN	SCALE:- 1:1	CONTROLLERATE OF INSPECTION(HEAVY VEHICLES) AVADI	
CHD	DIMENSIONS IN mm	TITLE: LEAD.	
TCO	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	D S CAT NUMBER	
APPO	ALL THREADS CONFORM TO	DRAWING NUMBER	
DATE 9-9-87		700 042 H	

712/199H

2

1. Tolerances for free dimensions are as per accuracy class 7, OST 1010.
2. Part may be trimmed along dimension 19, permissible displacement of hole centre of  $\phi 9$  mm should not exceed  $\pm 0,2$  mm.
3. Coating: 0,3 microns thick with fusion or 0,9 microns thick.



COPPER PIPE M3  
GOST 617-72

AMDT. NOTN. No: 0009-82

D-83

4. Butt-end may be drawn tight upto 2 mm.

PILOT SAMPLE SHOULD BE APPROVED BY A.I.S.P BEFORE BULK PRODUCTION

		EST. MASS 0.02 Kg	TO BE STAMPED OR INDICATED THUS $\phi$	(111)
			LETTERS	
ISSUE	DATE	NATURE OF AMENDMENTS	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNER TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
DRN		SCALE: - 1:1	MATERIAL * SEE ABOVE	USED ON 700-042-H
END		DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	$\oplus \ominus$	TITLE: CABLE LUG
APPO		ALL THREADS TO CONFORM TO	D S CAT NUMBER	DRAWING NUMBER 712 199 H
DATE	9-9-87			

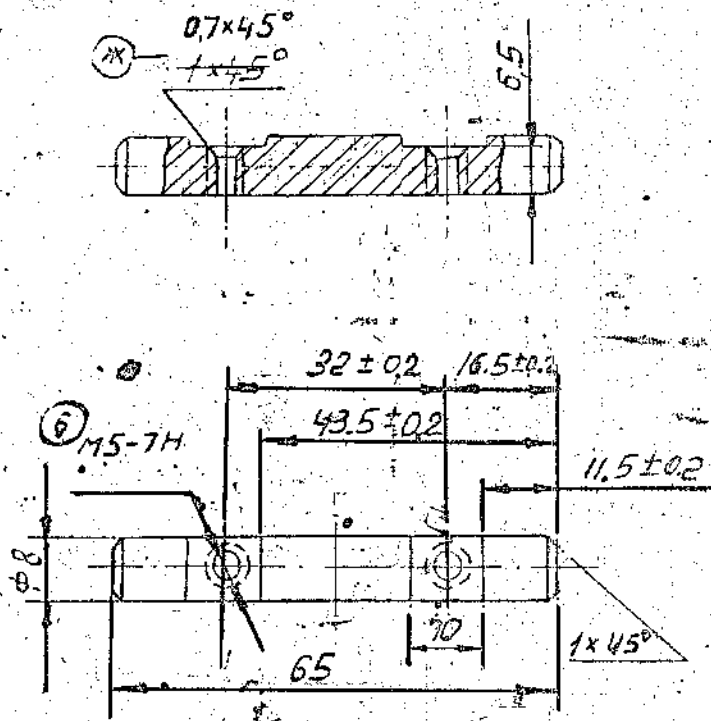


183.037H

35

▽5 unless otherwise specified.

1. Tolerances for free dimensions are as per accuracy class 7 OCT 1010.
2. Coating: Zinc-plating, 6 microns thick, chromatisation.



\* STEEL 45 GOST 1051-73  
GOST 7417 -75

D-83

PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

		EST. MASS <b>0.025 Kg</b>	TO BE STAMPED OR MARKED WHERE INDICATED THIS WAY (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE POSSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE: <b>1:1</b>	MATERIAL: <b>SEE ABOVE</b> USED ON: <b>270-034 H</b>
CHD		DIMENSIONS IN mm	CONTROLLER OF INSPECTION (HEAVY VEHICLES) AVADI
TCD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: <b>SHAFT</b>
APPD		ALL THREADS CONFORM TO	D S CAT NUMBER
DATE	9-9-87		DRAWING NUMBER <b>183.037 H</b>

H 8E0-E81

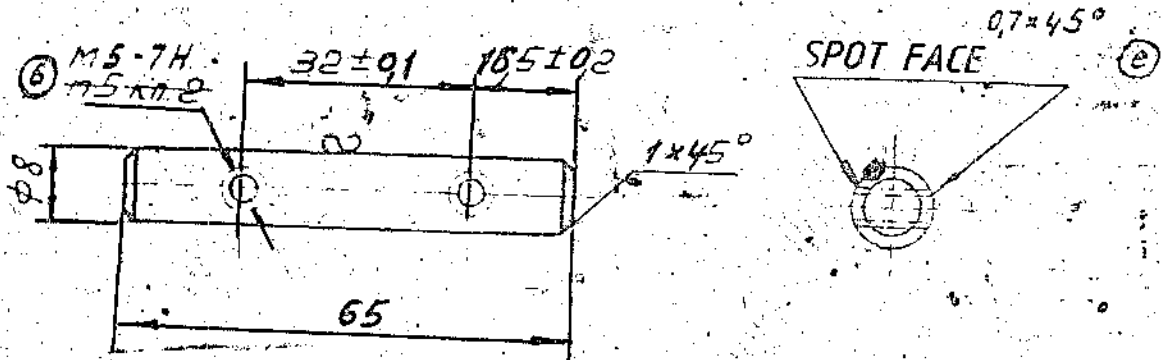
AVDI

▽5 Unless Specified Otherwise

1. TOLERANCES FOR FREE DIMENSIONS ARE AS PER ACCURACY CLASS 7 OST 1010.

2. COATING: ZINC-PLATING, 6 MICRONS THICK, CHROMATIZATION.

X141  
36



AMDT, NOTN, Not 0085-80

0085-80

0-83

\* STEEL 45 GOST 1051-73  
GOST 7417-75

PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION.

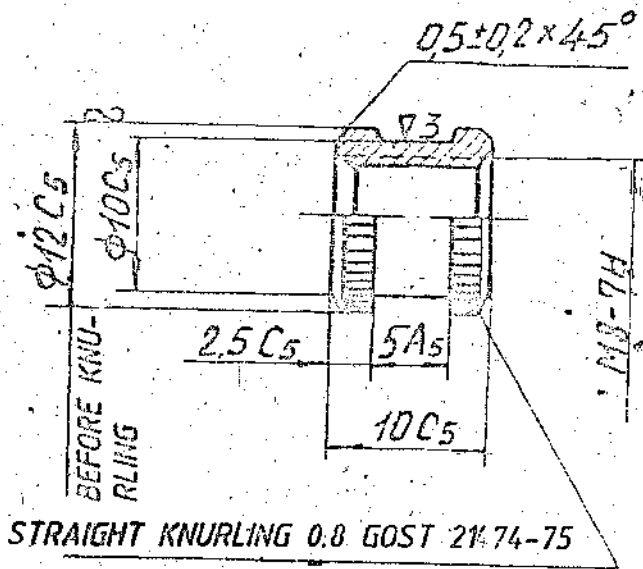
51

		EST. MASS <b>0.026 Kg</b>	TO BE STAMPED ON INDICATED THIS I
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNER TO HAVE R OUTSIDE R RISHIE EQUIVALENT CHANGES ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN	18/	SCALE: <b>1:1</b>	MATERIAL * SEE ABOVE
CID	18/	DIMENSIONS IN mm	USED ON: <b>270 034 H</b>
TCD	18/	TOLERANCE ON DIMENS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPO	18/	ALL THREADS TO CONFORM TO	TITLE: <b>ROLLER</b>
DATE	9-9-07		D'S CAT NUMBER DRAWING NUMBER: <b>183.038 H</b>

206 275H

75 Unless otherwise specified

1. CHAMFERS OF THREAD SHOULD BE AS PER GOST 10549-80.
2. MAKE THREAD M18-7H IN PANEL UNIT.



AMDT. NOTN. No. 0109-80

\* BAR A KPHT 12.0H A БpKMшЗ-1  
GOST 1620 -78

0-83

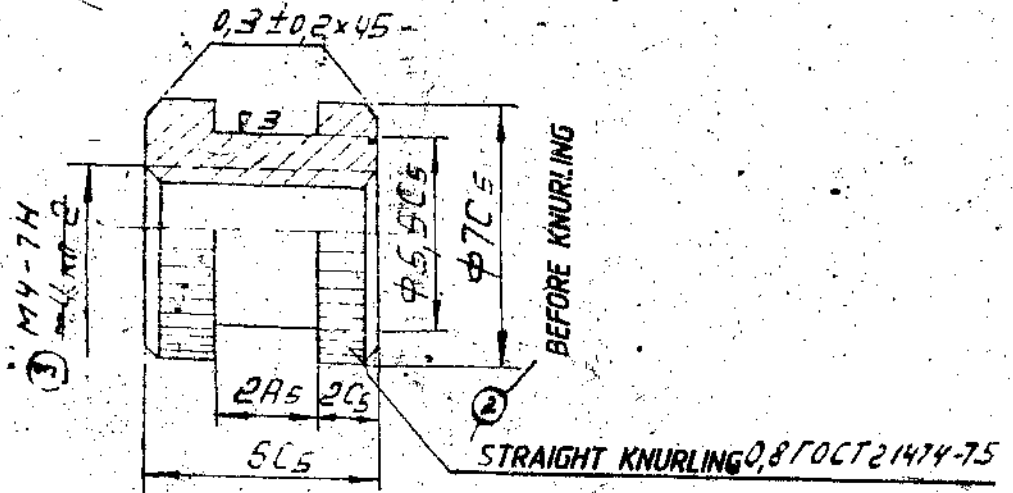
PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

			EST. MASS 0.005 Kg	TO BE STAMPED OR INDICATED THIS WAY [ LETTERS ]
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNER TO HAVE R OUTSIDE IF INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL * SEE ABOVE	USED ON 160-525 H
DRN		SCALE:- 2:1	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI	
CHD		DIMENSIONS $\phi$ mm		TITLE: BUSH
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER	DRAWING NUMBER 206 275 H
APPO		ALL THREADS TO CONFORM TO		
DATE	9-9-87			

206 301H

75 UNLESS OTHERWISE SPECIFIED

1. MAKE THREAD M4-7H IN PANEL UNIT.
2. CHAMFERS OF THREAD ARE AS PER GOST 10549-63.



BARAKPHT 8-0 HAbp KMU 3-1  
GOST 1628 -78

0-83

PILOT SAMPLE SHOULD BE APPROVED BY AHSR BEFORE BULK PRODUCTION

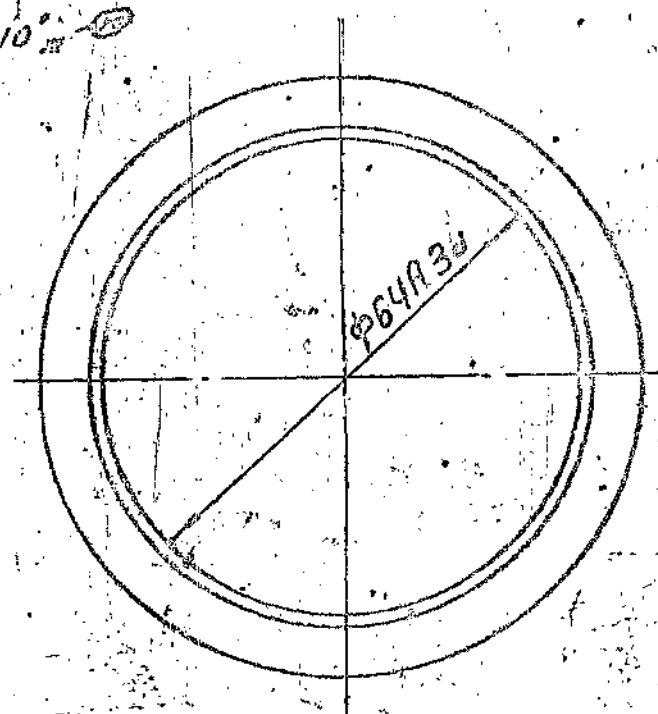
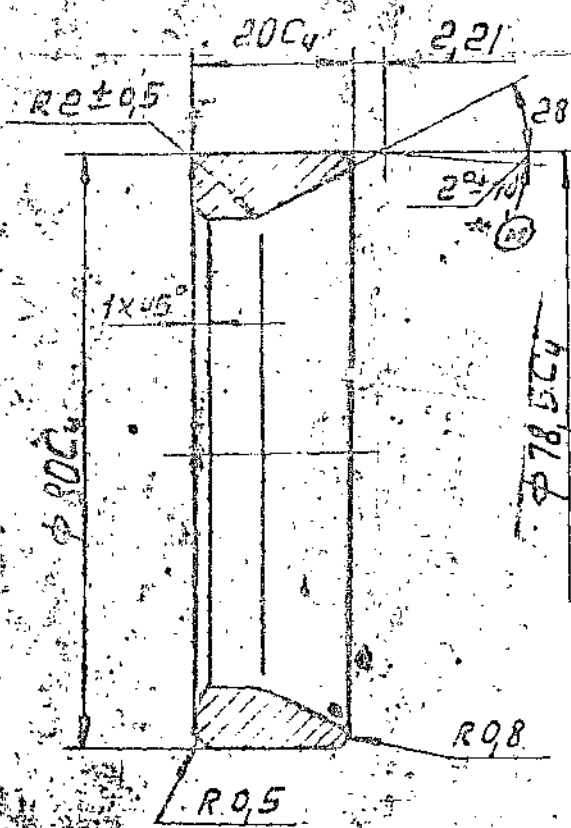
			EST. MASS	TO BE STAMPED OR INDICATED THIS WAY	(129)
				LETTERS: -	
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNER TO HAVE R OUTSIDE R W/SHR EQUIVALENT CHAMFERS ARE PERMISSIBLE		
ISSUE	DATE	NATURE OF AMENDMENTS	MATERIAL: * SEE ABOVE	USED ON: 160 525 H	
DRN		SCALE: 5:1	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI		
CND		DIMENSIONS IN mm	⊕ □ TITLE: BUSH		
TCO		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	⊕ □ TITLE: BUSH		
APPO		ALL THREADS TO CONFORM TO	D'S CAT NUMBER	DRAWING NUMBER	
DATE	9-9-87			206 301 H	

218.203H

Principal  
Symptoms

CARRY-OUT HEAT TREATMENT. HRC 34 TO 38.  
\*DIMENSIONS ARE GIVEN FOR TOOL.  
TOLERANCES FOR FREE DIMENSIONS ARE AS PER 22 AT 52.

14  
41



NOT IN NO. 0186-80

PIPE JOINTER GOST 8732-78  
TY 14-3-675-78

PILOT SAMPLE SHOULD BE APPROVED BY A.I.R.P. BEFORE WORK PROCEEDS

D 85

EST. MASS	TO BE STAMPED ON DRAWING WHERE INDICATED THIS	<b>(55)</b>
0,21 Kg	LETTERS	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED EDGES TO HAVE R OUTSIDE R BEING EQUIPMENT CHANGERS ARE PERMISSIBLE		
ISSUE DATE	NATURE OF AMENDMENTS	
DRW <i>CPL</i>	SCALE: 1:1	MATERIAL: ** SEE ABOVE
CRO <i>[Signature]</i>	DIMENSIONS IN mm	USED ON: 520 097H
TCO <i>[Signature]</i>	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROL RATE OF INSPECTION (AVY VEHICLES) AVAD
APPD <i>[Signature]</i>	ALL THREADS CONFORM TO	TITLE: V - RING
DATE 9-9-87		D S CAT NUMBER
		DRAWING NUMBER: 218-203 H

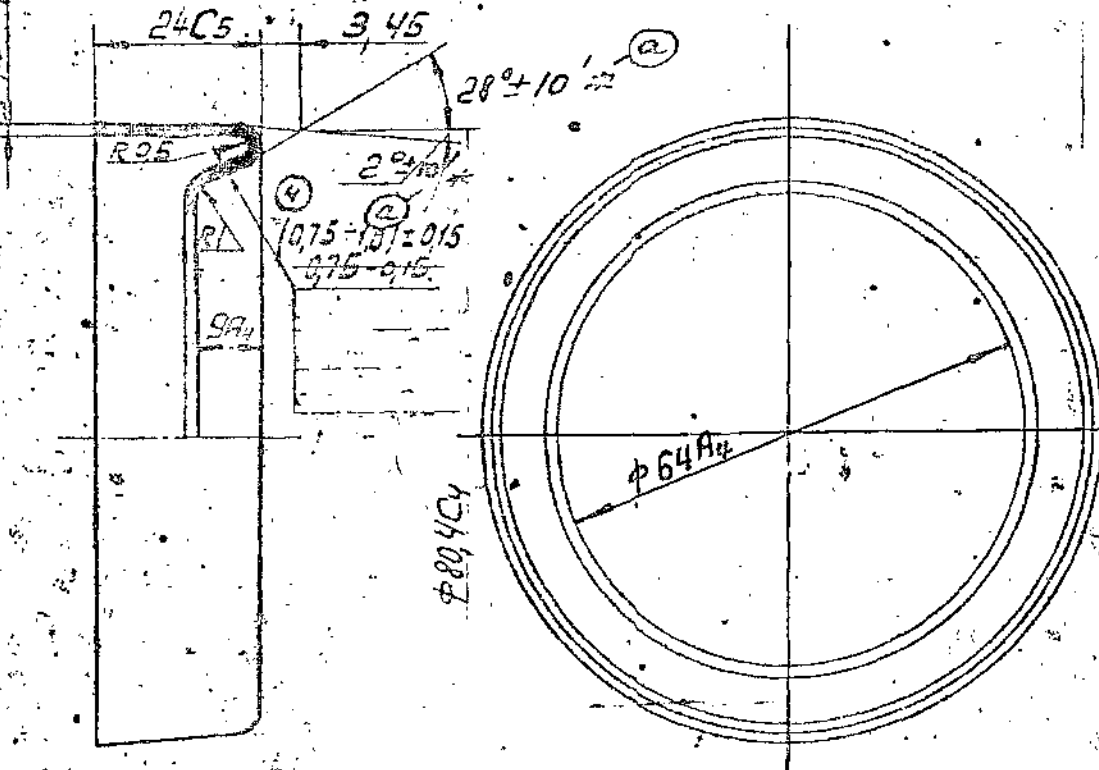
219-024H

\* Dimensions are given for tool.

Thickness of one cone at various points may vary by  $\pm 0.15\text{mm}$  tolerance value for working part  $\pm 0.2\text{mm}$  for non-working part.

~~XIV~~  
43

1075-101302  
075-015



MICANITES  $\Phi$ МГА  
ГОСТ 6122-75

~~XIV~~  
43

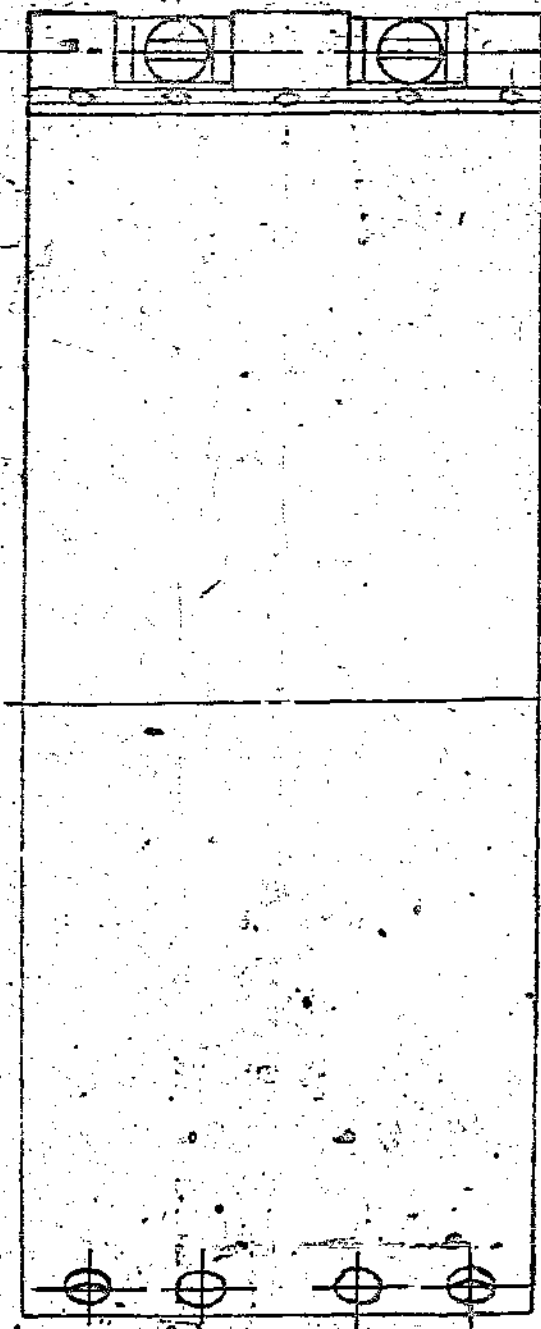
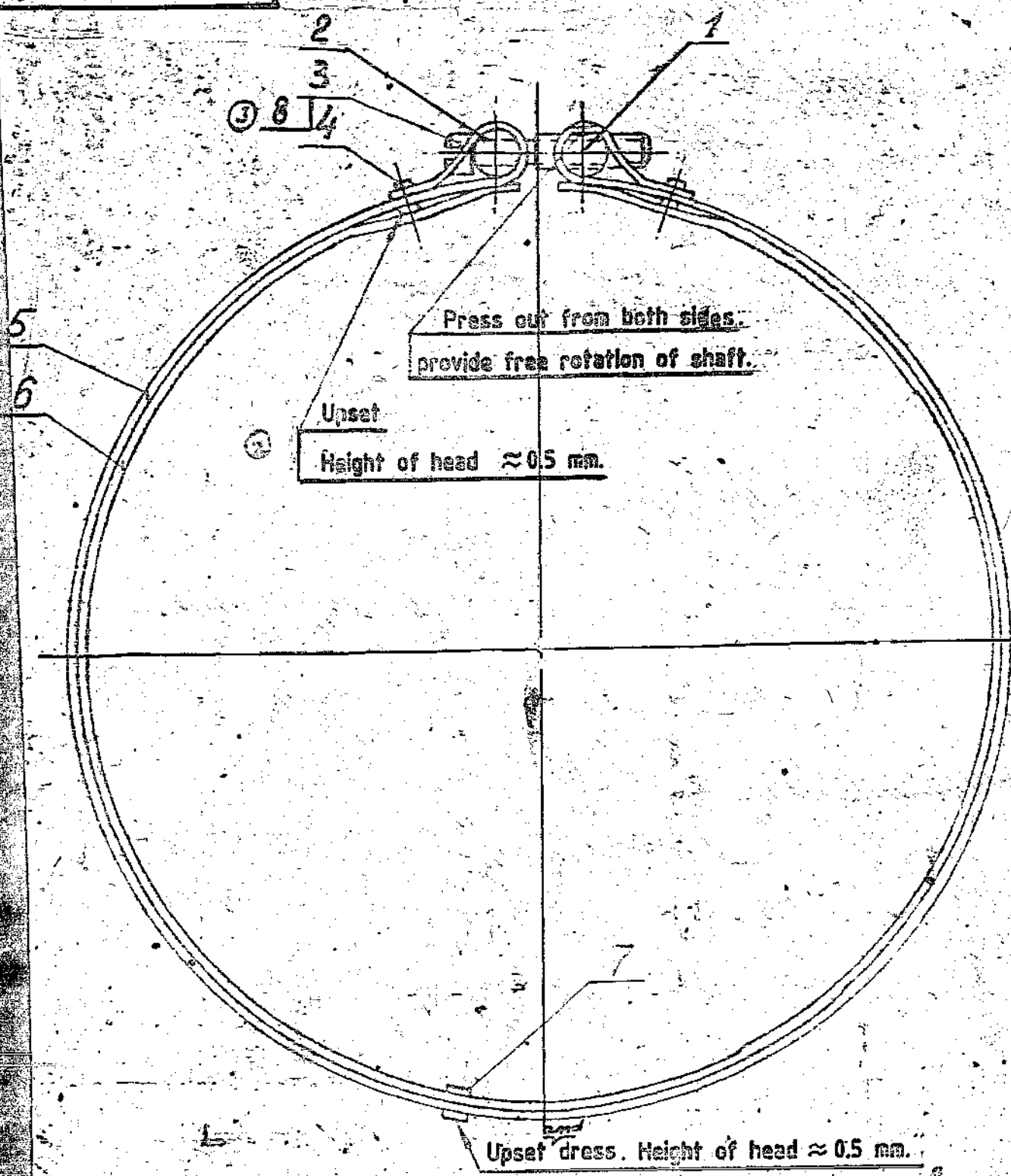
PILOT SAMPLE SHOULD BE APPROVED BY VOPD BEFORE USE FROM TOOL

57

783

ISSUE DATE	NATURE OF AMENDMENTS	PSY MASS	0,018 Kg	LET BE STAMPED OR MARKED WHERE INDICATED THROUGH LETTERS
DRAWN <i>CPA</i>	SCALE: 1:1	ALL SHARP EDGES AND CORNERS TO BE ROUNDED UNLESS OTHERWISE STATED SACRIFICING TO AVOID HAVING IT OUTSIDE IT BEING EQUIVALENT CHARACTER IS PERMISSIBLE	MATERIAL	USED ON: 520 09TH
CHKD <i>CPA</i>	DIMENSIONS IN mm	** SEE ABOVE	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	TITLE: INSULATION CONE
TED <i>CPA</i>	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	OS CAT NUMBER	DRAWING NUMBER	219-024 H
APPD <i>CPA</i>	ALL THREADS TO CONFORM TO			
DATE 9-9-07				

270.034H



1. Coat the heads of the rivets and places of their upsetting with Гр.ЭП - 076, Yellow III H8A0.050.001-3. It may be coated with one continuous strip of primer.
2. Screws, reference no:3 may be replaced by screws, reference no:8.

Upset dress. Height of head ≈ 0.5 mm.

PILOT SAMPLE SHOULD BE APPROVED BY A.M.S.P. BEFORE BULK PRODUCTION

S.NO.	DESIGNATION	DESCRIPTION	QTY.	REMARKS
8.	7B8. 916. 002	SCREW	2	
7.	488. 109 H	RIVET	2	
6.	893 252 H	INSULATING GASKET	1	
5.	272. 040H	BAND	1	
4.	3521 A-2,5-3-K3	RIVET	10	STANDARD
3.	462. 701 H	SCREW	2	
2.	183. 037 H	SHAFT	1	
1.	183. 030 H	ROLLER	1	

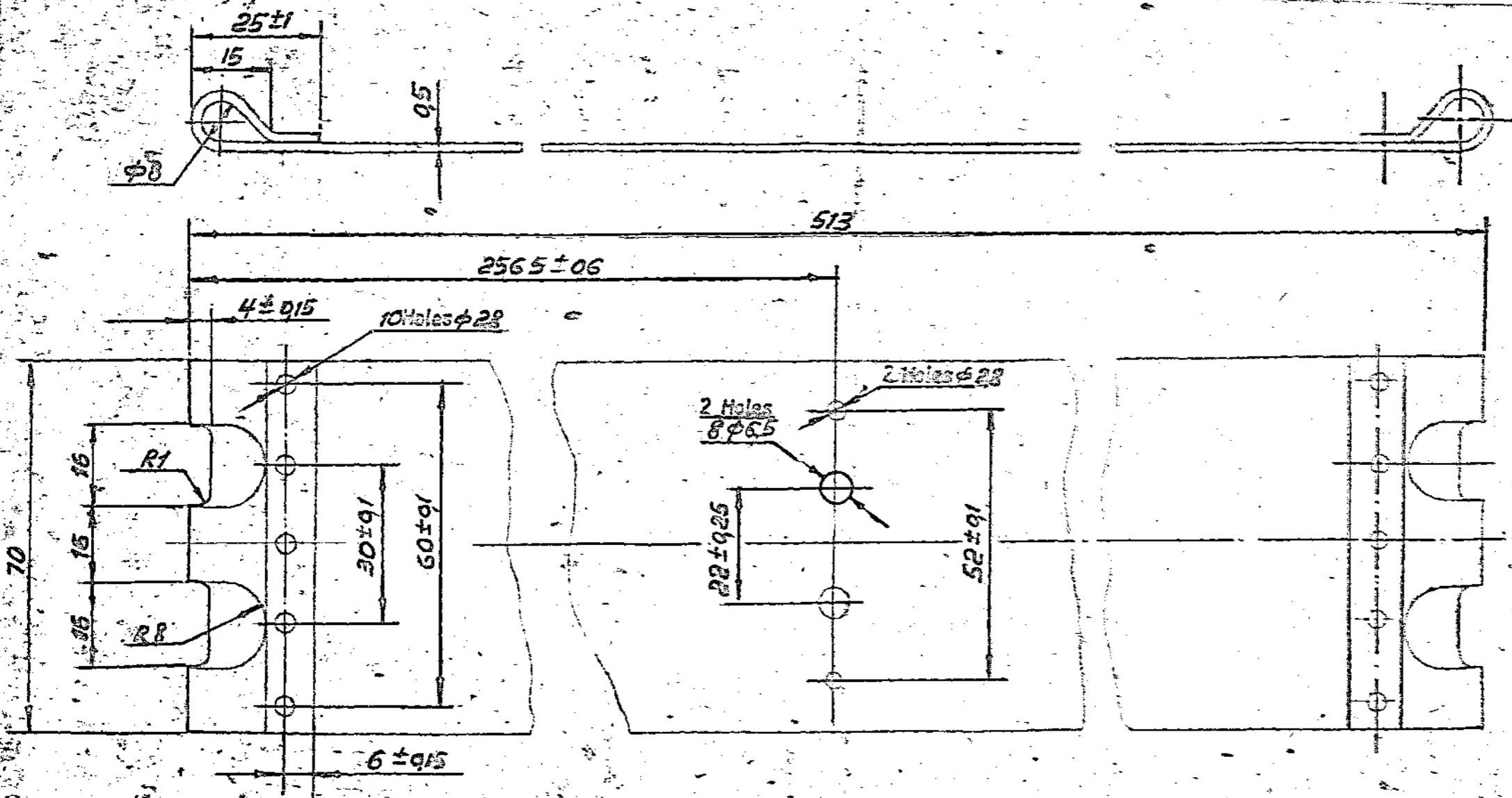
EST. MASS	TO BE STAMPED OR MARKED WHERE LOCATED THIS IS	(26)
0.255 Kg	LETTERS I	
ISSUE DATE	NATURE OF AMENDMENTS	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R. OUTSIDE R. WHERE EQUIVALENT CHAMFERS ARE PREFERABLE.
ORN	SCALE: 1:1	MATERIAL: USED ON: 002 145 H
CAD	DEPARTMENTS IN CHARGE	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI
ICD	TO EMPLOY OR DISMISS UNLESS OTHERWISE STATED	PROTECTIVE STRIP
APPD	ALL THREADS CONFORM TO	D.S. (A) NUMBER
DATE 9-9-87		DRAWING NUMBER 270.034 H

272040H

IND

Tolerances for size dimensions are as per accuracy class 7 - GOST 1010

Coating : Zinc-plateing, 30 microns thick, chromatisation



BAND YGHC - H-0.5X70  
GOST 2283-69

62

PROOF SAMPLE SHOULD BE APPROVED BY A HSP BEFORE BULK PRODUCTION

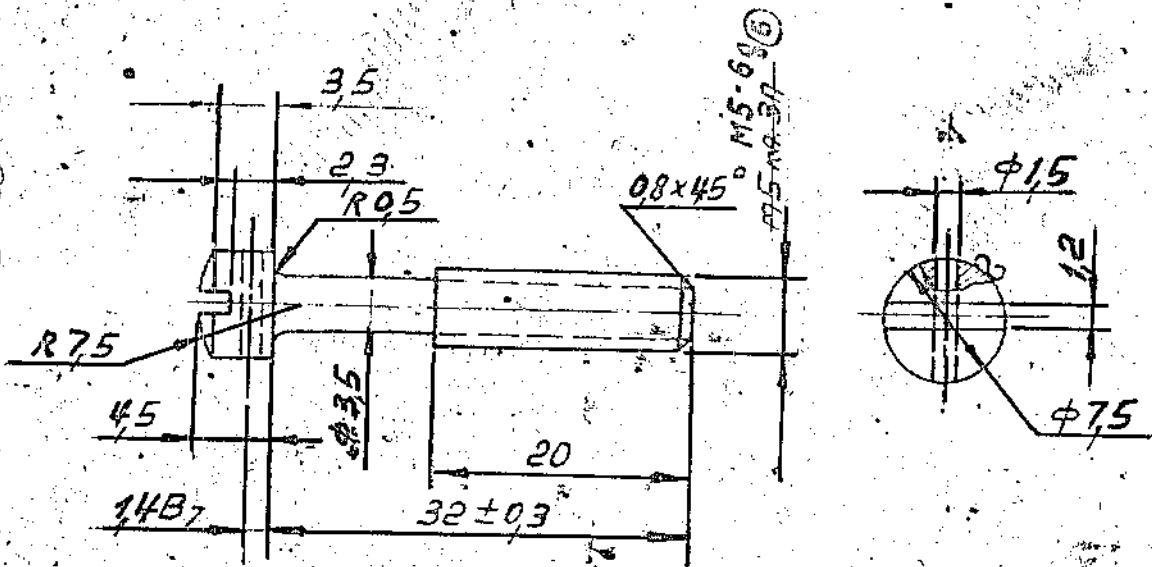
EST. MASS	0.142 Kg	TO BE STAMPED OR MARKED WHERE LOCATED THUS ( LETTERS )
ISSUE DATE	NATURE OF AMENDMENTS	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED FORM TO HAVE R OUTSIDE RADIUS EQUIVALENT CHAMFERS AS FOLLOWS
DRW	SCALE 1:1	MATERIAL - SEE ABOVE USED ON 270-034 H
CD	OVER ENDING N RA	CONTROLLER OF INSPECTION (HEAVY VEHICLES) AVADI
TC	TOLERANCE BY DEVS UNLESS OTHERWISE STATED	TITLE: BAND
APP	ALL THREADS CONFORM TO	D'S PART NUMBER
DATE 9-9-87		DRAWING NUMBER 272.040 H

H10L 797

▽5 - Unless otherwise specified.

- 1 Tolerances for free dimensions are as per accuracy Class 7.
- 3 Coating:- zinc-plating, 6 microns thick, chromiation.
- 5 Dehydrogenate.

0006 20



STEEL 45 GOST 1051-73  
GOST 7617-75

74

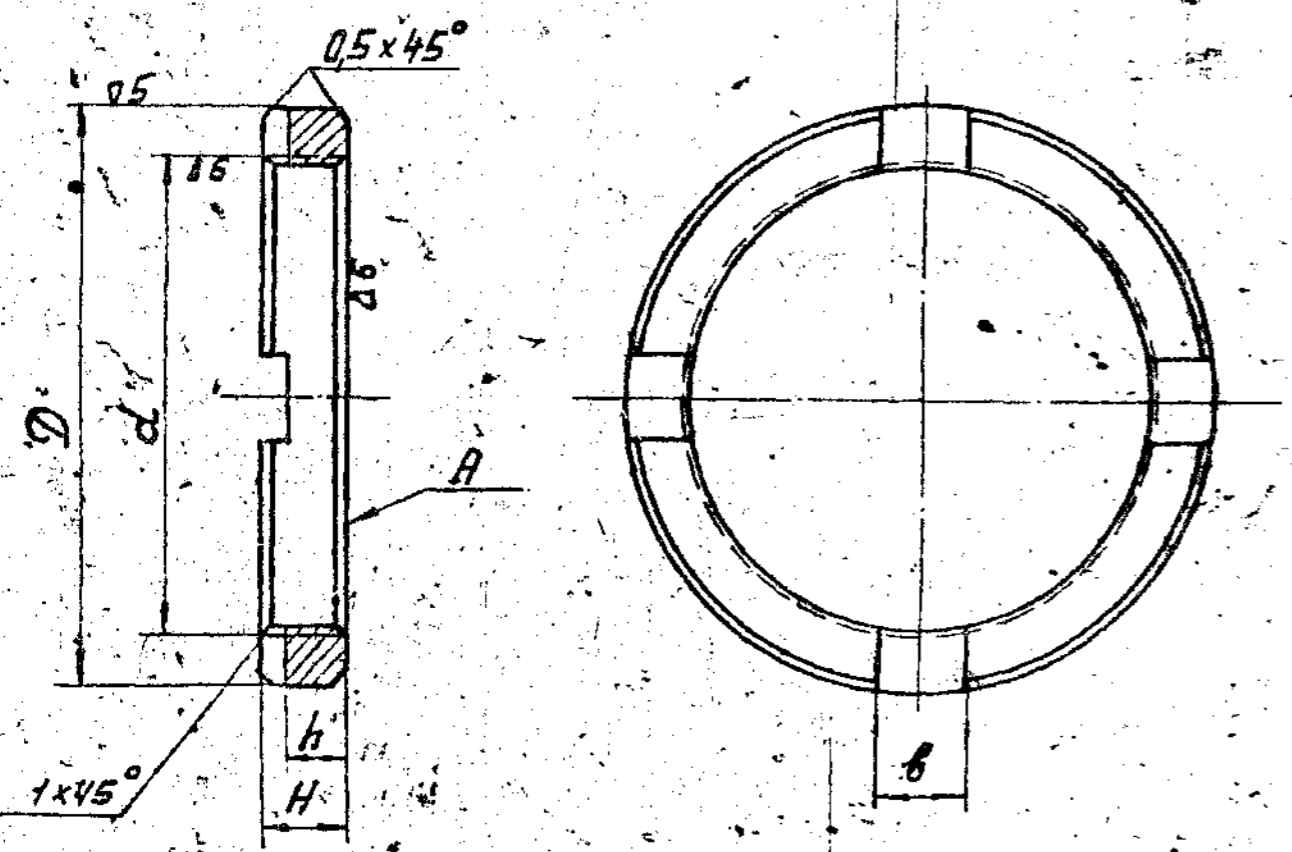
PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

		EST. MASS 0.005 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS (LETTERS)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED RACHISED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL * SEE ABOVE	USED ON 270 034 H
DRH	SCALE:- 2:1	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
END	DIMENSIONS IN mm	⊕ □ TITLE: SCREW	
ICD	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	⊕ □ D S CAT NUMBER	DRAWING NUMBER 462.701 H
APPO	ALL THREADS CONFORM TO		
DATE 9-9-07			

HLB/14h

▽ 4 Unless otherwise specified

1. Tolerances for free dimensions are as per 722 AT.
2. Threaded chamfer is as per GOST 1049-63.
3. End play  $A^*$  with respect to thread not exceeding 0,08 mm is allowed. carry out hardening HRC 33 to 39.
4. Nuts marked with \* are allowed to be made with two splines.



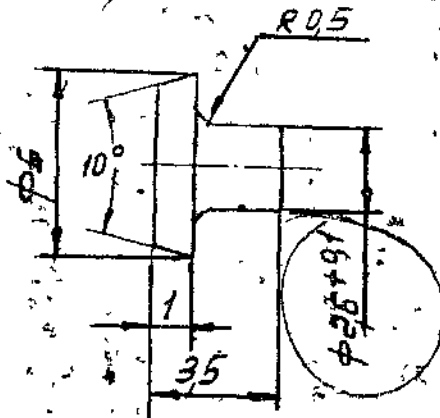
No. of nut	d	D	H Permissible deviations as per C <sub>5</sub> is .	h Permissible deviations ±0,2	Mass	Remarks
471.137H-11	M64x15-7H	75	10	7	0,110	

(80)

PROT SAMPLE SHOULD BE APPROVED BY A HSP BEFORE USE IN PRODUCTION

EST. MASS	TO BE STAMPED & MARKED WHERE INDICATED IN THIS DRAWING
ISSUE DATE	NATURE OF AMENDMENTS
SCALE: - 1:1	DIMENSIONS IN mm
TOLERANCE ON DIMS UNLESS OTHERWISE STATED	ALL THREADS CONFORM TO
DATE 9-9-87	
EST. MASS	TO BE STAMPED & MARKED WHERE INDICATED IN THIS DRAWING
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED	INDICATED EDGES TO HAVE R OUTSIDE R IF MORE EQUIVALENT FILLS ARE PERMISSIBLE
MATERIAL - STEEL 30XPCA TY 14-3-675-78	USED ON - 520 097 H
CONTROL (STATE OF INSPECTION HEAVY VEHICLES) AVADH	TITLE: ROUND NUT
D/S CAT NUMBER	DRAWING NUMBER 471-137H

Tolerances for free dimensions are as per accuracy class 7,0ST 1010.



AMDT, NOTN, No: 0024-79

1. Coating: Chemically oxidization chromatization.

D-83

\* Aluminium alloy AM U  
GOST 14830-76

PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

		EST. MASS	TO BE STAMPED OR MARKED WHERE INDICATED THIS BY LETTERS
		0-0005 Kg	
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL	USED ON
DRH	SCALE - 5:1	* SEE ABOVE	270-034 H
CHD	DIMENSIONS BY GOST	CONTROL RATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCO	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED		RIVET
APPO	ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NO: 488.109 H
DATE 9-9-87			

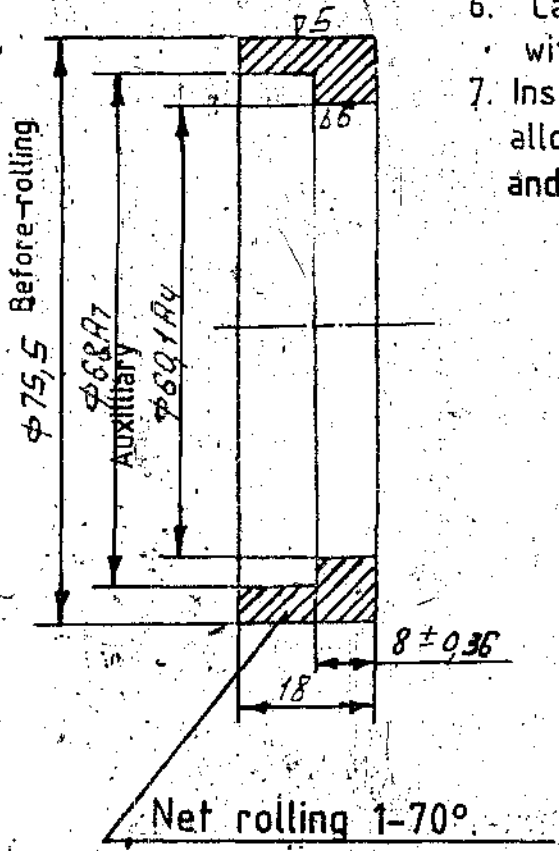
508 024 H

IND

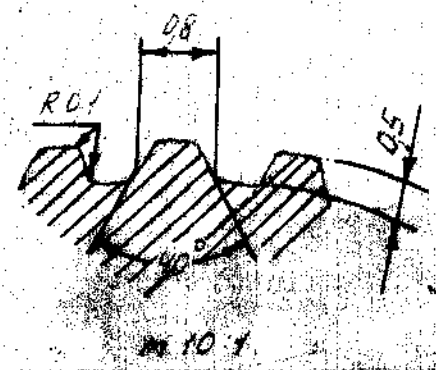
141  
86

Unless otherwise specified.

1. Tolerance for casting and allowances for machining are as per class 5 of standards 56-15 and 56-16.
2. Pattern taper should be 2°.
3. Casting radius should be R 1.5 to 2mm.
4. Carry-out heat treatment as per condition T5 GOST 2685-75.
5. Technical requirements for casting are as per OST 190021-71 group-3.
6. Casting is allowed by centrifugal method without heat treatment.
7. Instead of net rolling Straight rolling is allowed in casting with dimensions 0.5x0.8x40° and pitch 1.6 mm.



Profile of casting teeth pitch 1.6 mm



093  
Line

Aluminium alloy  
AA-9 GOST 2685-79

PILOT SAMPLE SHOULD BE APPROVED BY ANSP BEFORE MILK PRODUCTION

			EST. MASS <b>0.039 Kg</b>	TO BE STAINED OR INDICATED THIS BY [ ] (LETTERS)
				(98)
			ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED COPPER TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	SCALE: <b>1:1</b>	USED ON: <b>508-025 H</b>
DRW			SEE ABOVE	
CHKD			CONTROLLEDATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCB		TOLERANCE ON DIMS. UNLESS OTHERWISE STATED	TIT: <b>WINDING SUPPORT</b>	
APPO			D S CAT NUMBER	DRAWING NUMBER
DATE	<b>9-9-87</b>	ALL THREADS TO CONFORM TO		<b>508 024 H</b>

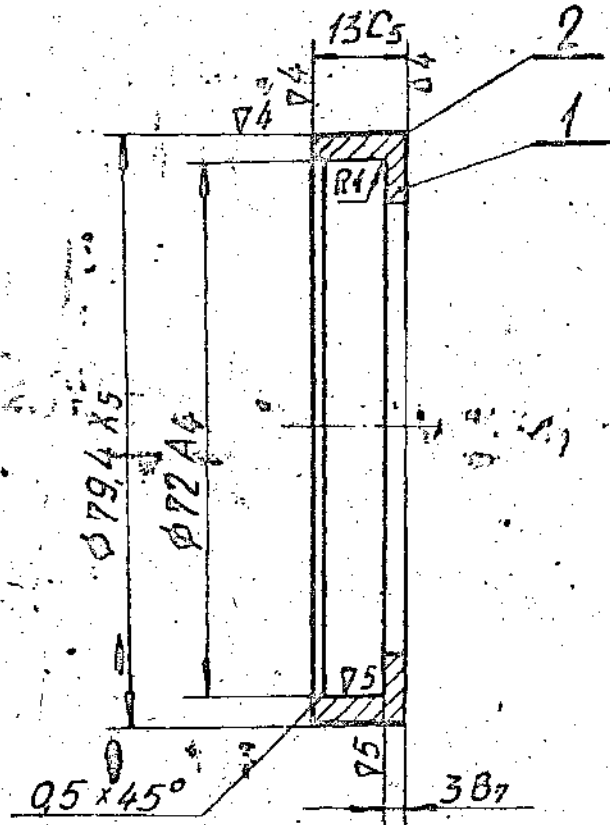
508 025 H

Unless otherwise specified,

Alternate material is 508-025 H-1

Moulding material is AL-4 GOST 20437-75

~~14~~



8390 59901 23.08.82

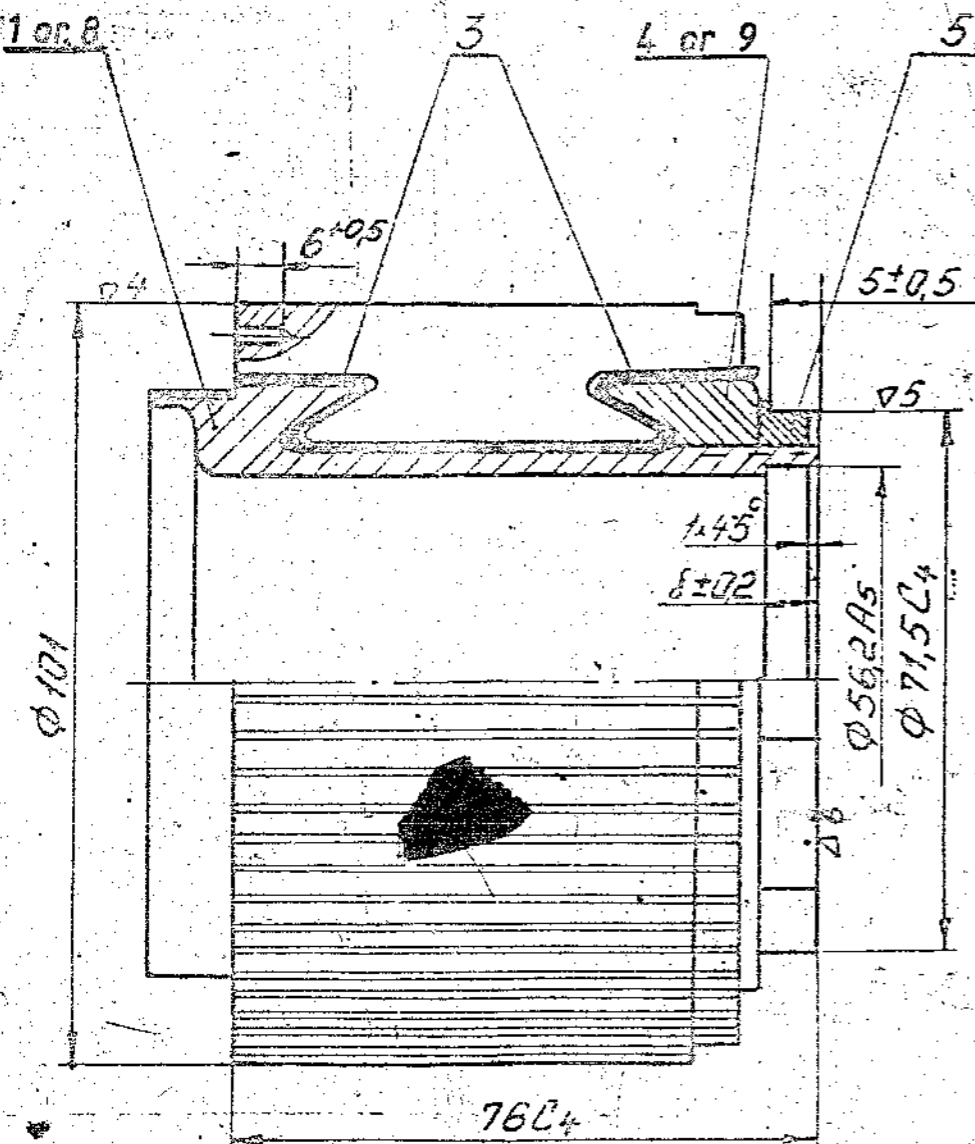
D-03

QTY	DESIGNATION	DESCRIPTION	MATERIAL	QTY	REMARKS
2	508.025H-1	Glass fabric			
		TB93-2 TY16-503.509-75		1	
1	508.024H ✓	WINDING SUPPORT		1	

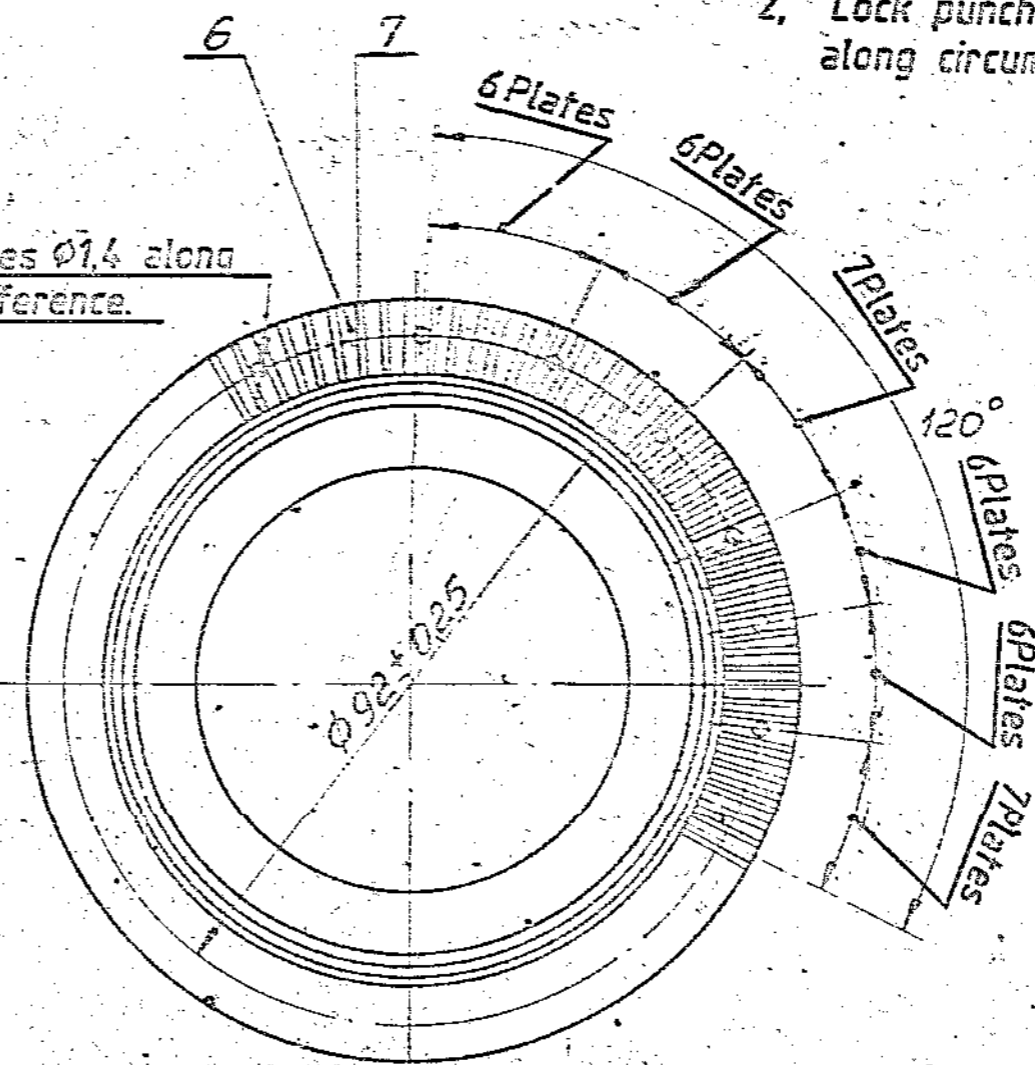
PHOT SAMPLE SHOULD BE APPROVED BY AMSY BEFORE BULK PRODUCTION

EST. MASS 0.04 kg	TO BE STAMPED (INDICATED ITEMS)	<b>29</b>
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. MATCHED CORNER TO HAVE R OUTSIDE OF BENCH EQUIPMENT PARTS ARE PERMISSIBLE.		
ISSUE DATE	NATURE OF ATTACHMENTS	MATERIAL
DRN	SCALE: 1:1	USED ON: 505-117 H
APPD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	CONTROLLED BY INSPECTION (BY VEHICLE) AVADI
DATE: 9-9-87	ALL THREADS TO COMPLY TO	TITLE: <b>WINDING SUPPORT-ASSY</b>
		D'S LAB NUMBER
		WINDING SUPPORT <b>508-025 H</b>

HL60 029



18 Holes  $\phi 1.4$  along circumference.



1. Check commutator for racing in hot condition as per TM 12-153 at 13000 r/mm.
2. Lock punch the nut over thread at six points along circumference.

X141  
15

Designation of alternate	Code of article	A	B	Г	Д	Е
520.0.97 H	BF-7500	522.064H	219.024H	218.203H	-	-
-01	BF-7500 Я BF-7500 Я 2 Series				BE6.239.020H	BE6.485.016H

S.No	Designation	Description	Qty.	Remarks
6	523.171 H	Commutator bar	114	
5	471.137 H-11	Round nut	1	
4	Г	Vee Ring	1	See Table
3	B	Insulation taper	2	See Table
1	A	Commutator bush	1	See Table

9	E	Vee Ring	1	See Table
8	Д	Commutator bush	1	See Table
7	520.097 H-1	Mica C/T M -1 TY 21-25-25-74	114	Without drawing

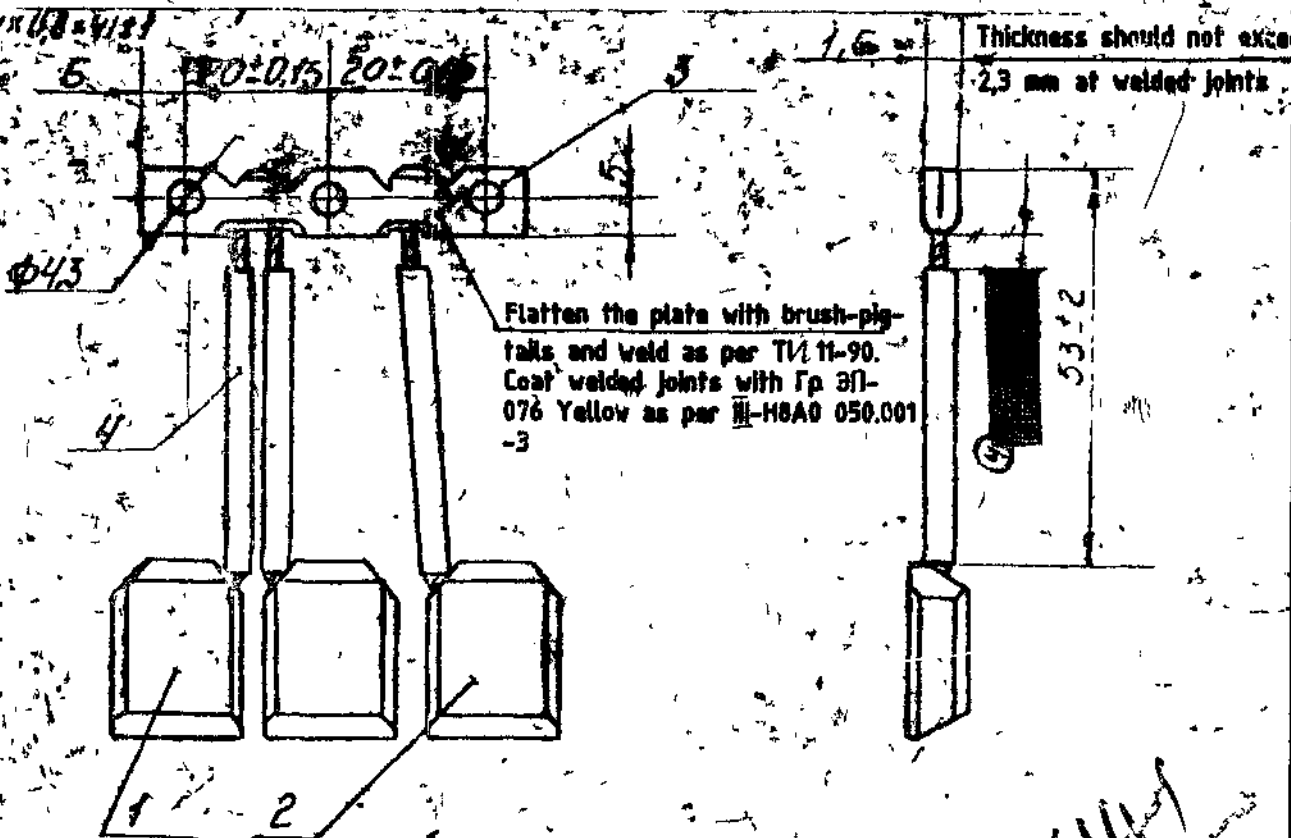
PILOT SAMPLE SHOULD BE APPROVED BY AHS/P BEFORE BULK PRODUCTION

EST. MASS	2.54 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS WAY (LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED. ROUNDED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE		
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL: USED ON: 505 117 H
DRN	SCALE: 1:1	CONTROLLER OF INSPECTION (HEAVY VEHICLES) AVADI
CHKD	DIMENSIONS IN mm	TITLE: COMMUTATOR
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED	D S CAT NUMBER
APPD	ALL THREADS CONFORM TO	DRAWING NUMBER: 520 097 H
DATE: 9-9-87		

30



- 555
1. Grinding radius of brushes should be in compliance with remarks in drawings 557,007 H and 557,008 H,
  2. Height of brush after grinding should be at least 24mm,
  3. Part reference no: 4 may be made from rubber tube B4x0,8x41±1 Sp - 129 TY38-10554-76.



AMDT, NOTN, No: 06-1900

83

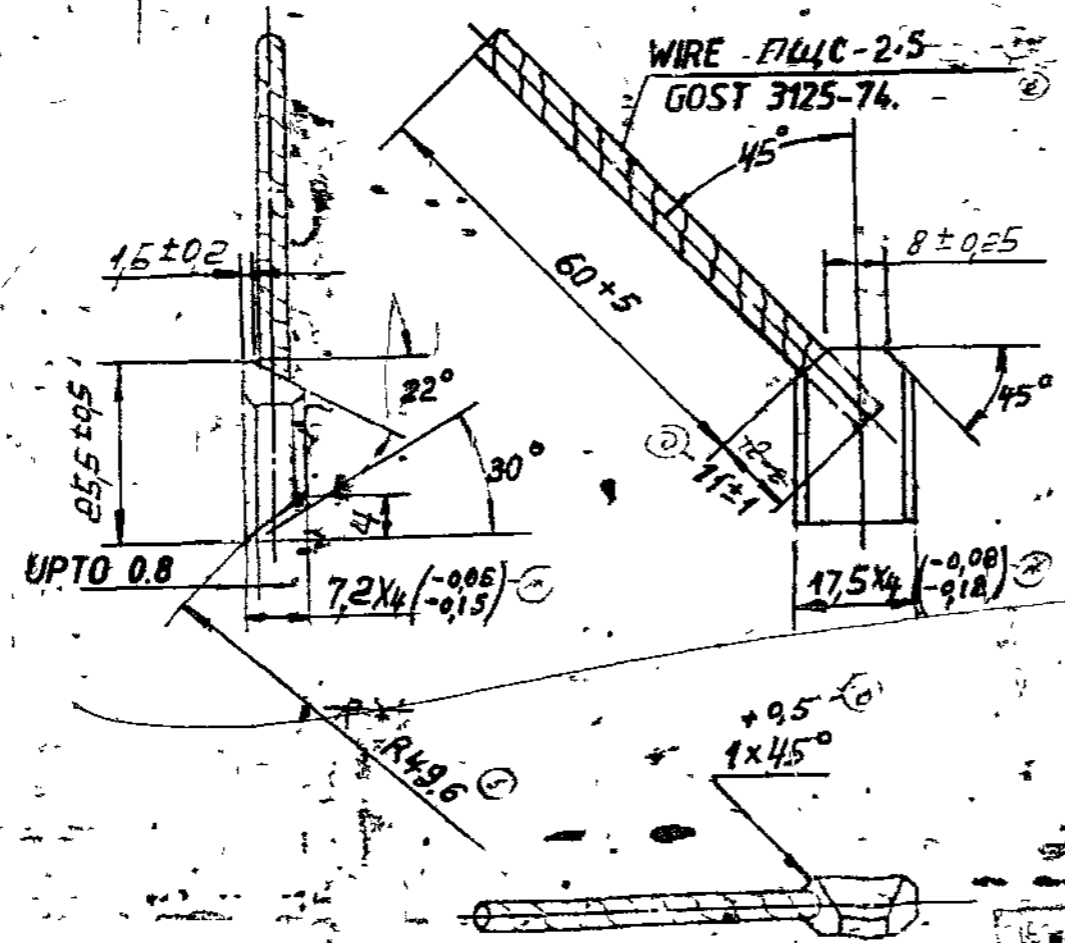
S.No	Designation	Description	Qty	Remarks
4,		Rubber tube ИПП-1338P external φ4x0,5x41±1 TY38-40576-77.	3	
3,	751, 309 H ✓	Contact plate	1	
2,	557, 008 H ✓	Brush	2	
1,	557, 007 H ✓	Brush	1	

PROT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION

EST. MASS 0,05 Kg		TO BE STAMPED OR MARKED WHERE INDICATED THUS * <b>33</b> LETTERS	
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE			
ISSUE DATE	NATURE OF AMENDMENTS	MATERIAL -	USED ON - 002-145 H
DRN	SCALE- 1:1	CONTROLLERATE OF INSPECTION(HEAVY VEHICLES ) AVADI	
CHD	DIMENSIONS IN mm	TITLE- BRUSH	
TCO	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	⊕ ⊖	D S CAT NUMBER
APPO	ALL THREADS CONFORM TO	DRAWING NUMBER 555-182 H	
DATE 9-9-87			

IND

1. Caulker's iron is copper silvered with at least 30% silver content.
2. Force to pull-out standard wire-rope should be at least 12 kg.
3. Sharp corners of upper and lower ends may be blunt upto 0,3m
4. Incomplete caulking of wire is allowed upto 0,5mm from upper end of brush.
5. Tolerance for free dimensions are as per accuracy class 7 A7,B7, for angles  $\pm 1^{\circ}30'$ .
6. Brushes are supplied without r R\*) with additional dimensions "upto 0,8" and 30°.
7. Contact electrical resistance between the body of brush and wire should not exceed 1 m. Ohm.
8. Mark.



X 144  
92

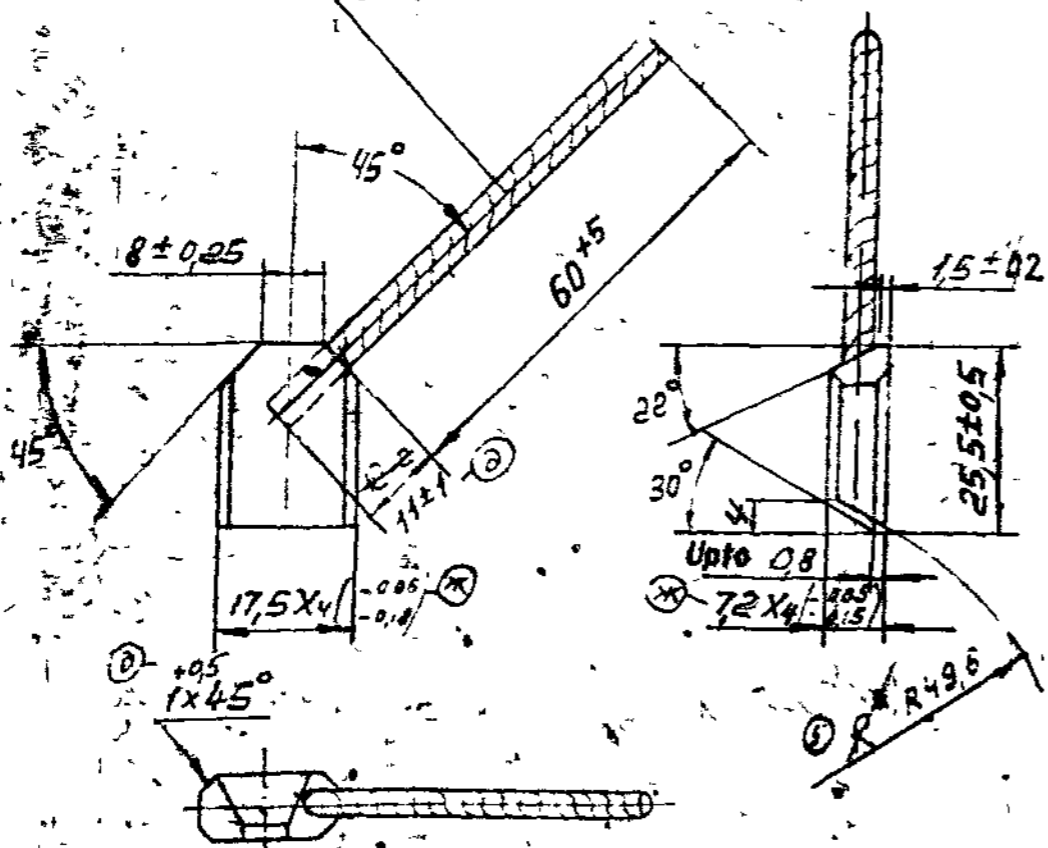
GRADE MFC - 7

PILOT SAMPLE SHOULD BE APPROVED BY A H-S P BEFORE BULK PRODUCTION a. 104

EST MASS 0,013 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS #	LETTERS) (104)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE		
ISSUE DATE ORN	NATURE OF AMENDMENTS SCALE - 1:1	MATERIAL * SEE ABOVE
APPROVED DATE 9-9-87	DIMENSIONS IN mm TOLERANCE ON DIMS UNLESS OTHERWISE STATED. ALL THREADS CONFORM TO	USED ON - 555-182 H
CONTROLLED DATE OF INSPECTION (HEAVY VEHICLES) AVADI		TITLE BRUSH
D & CAT NUMBER		DRAWING NUMBER 557-007 H

557-008H

WIRE 74C-2.5 GOST 9125-74



- 1) Caulker's iron is copper silvered with at least 30% silver contact .
- 2) Force to pull-out standard wire-rope should be at least 12 kg .
- 3) Sharp corners of upper and lower ends may be blunt upto 0,3 mm .
- 4) Incomplete caulking of wire is allowed upto 0,5 mm from upper end of brush .
- 5) Brushes are supplied without R \* ) with additional dimensions upto 0,8 and 30°
- 6) Tolerances for free dimensions are as per accuracy class 7, A7, B7, for angles ±1° 30'
- 7) Contact electrical resistance between the body of brush and wire should not exceed 1,0 mohm .
- 8) Mark .

GRADE TTC - X 111

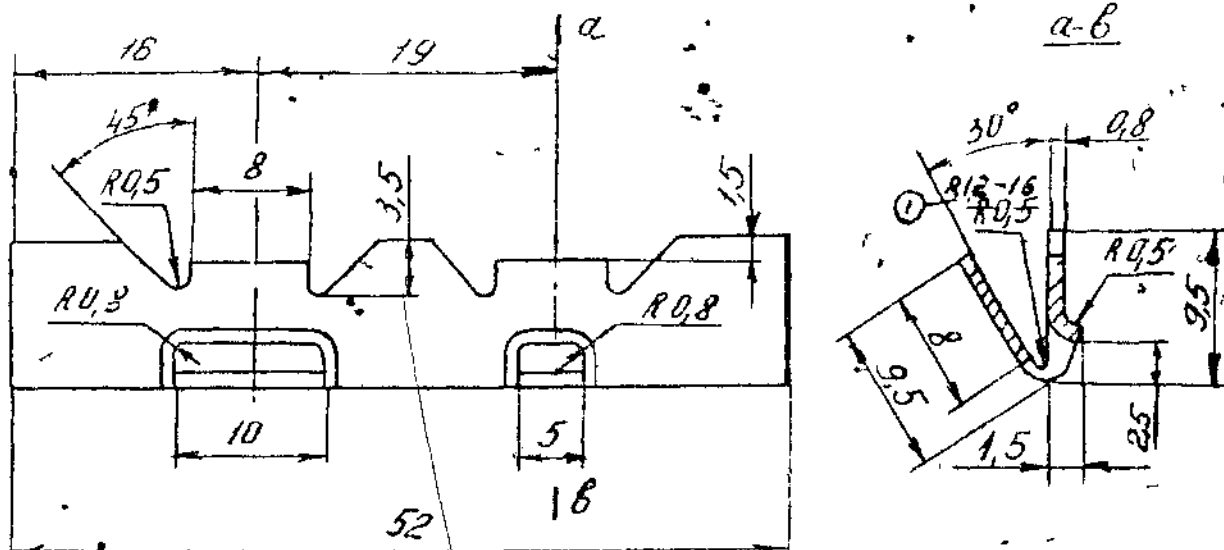
PILOT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

		EST. MASS 0,03 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS #	(105)
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE		
ISSUE	DATE	NATURE OF AMENDMENTS		
DRN		SCALE - 1:1	MATERIAL * SEE ABOVE	USED ON - 555-182 H
CHD		DIMENSIONS IN mm	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
YCD		TOLERANCE ON DIMS UNLESS OTHERWISE STATED	TITLE: BRUSH	
APPD		ALL THREADS CONFORM TO	D S T AT NUMBER	DRAWING NUMBER 557-008 H
DATE	9-07			

751-309H

IND

1. Tolerances for free dimensions are as per 22AT 52
2. Surface ruptures of material to depth not exceeding 0,2 mm are allowed in the corners of flanging,



AMDT, NGTN, No: 0057-82

\* SHEET 0,8x710x1410 M.D. GOST 931-78  
Л. ПРМ/08 А 63

D-83

PILOT SAMPLE SHOULD BE APPROVED BY A.H.S.P BEFORE BULK PRODUCTION

116

		EST. MASS 0,005 Kg	TO BE STAMPED OR INDICATED THUS * LETTERS )
		ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNER TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE	
ISSUE	DATE	NATURE OF AMENDMENTS	
DRN		SCALE - 2.1	MATERIAL - * SEE ABOVE
CHD		DIMENSIONS IN mm	USED ON :- 555-102 H
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI
APPD		ALL THREADS TO CONFORM TO	TITLE: CONTACT PLATE
DATE 9-9-87			D S CAT NUMBER
			DRAWING NUMBER 751-309H