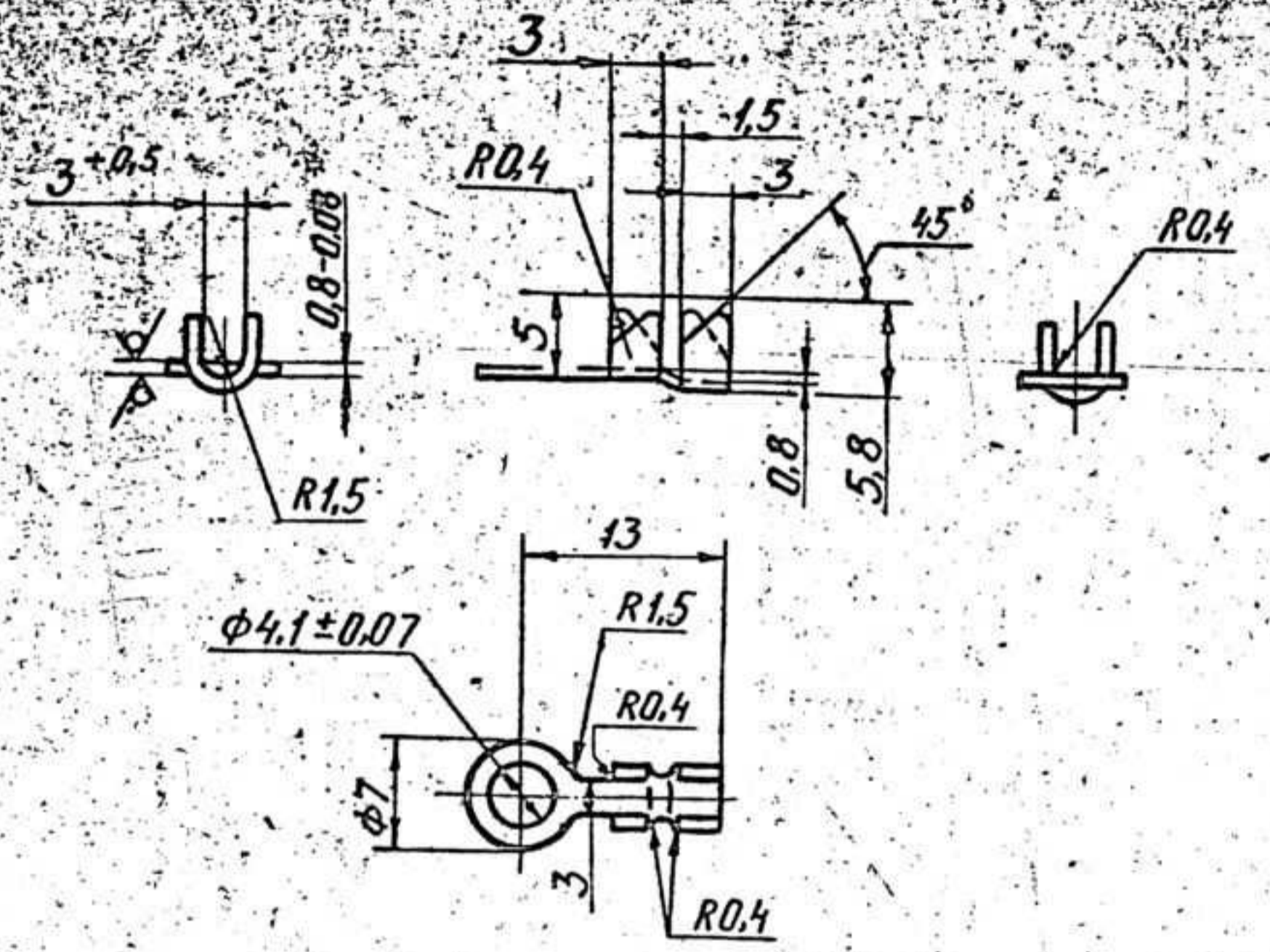


1-ИГБ-132

Rz 80 ✓(✓)



TECHNICAL CONDITIONS

1. [#]Sizes for reference.
2. Tolerance for all sizes is within ± 0.25 , but tolerance for angular sizes, within $\pm 30'$, unless otherwise specified.
3. Coating: 0 - Bu (97)9.

1-ИГБ-132

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

END PIECE SHOULD BE MANUFACTURED FROM BRASS STRIP COLD ROLLED (D-D) OF RECTANGULAR SECTION (TP-PR), SOFT (M) HAVING THICKNESS 0.8 MM OF GRADE L63 (T-L) CONFORMING TO GOST 931-78

① CHEMICAL COMPOSITION OF BRASS GRADE L63 TO GOST 15527-70 (AS REFERRED IN GOST 931-78) IS AS FOLLOWS

CHEMICAL COMPOSITION %							
BASIC ELEMENT		ADMIXTURES (MAX)					
COPPER	ZINC	LEAD	IRON	ANTIMONY	BISMUTH	PHOSPHORUS	TOTAL
62.0 - 65.0	REMAINING	0.07	0.2	0.005	0.002	0.01	0.5

② MECHANICAL PROPERTIES:- MECHANICAL PROPERTIES OF BRASS STRIP GRADE L63 CONFORMING TO GOST 931-78 SHOULD BE AS FOLLOWS

- (A) ULTIMATE TENSILE STRENGTH - 30-41 kgf/mm²
- (B) ELONGATION - 38% (MIN)
- (C) HARDNESS - 70 BHN

③ CUPPING TEST:- THE CUPPING TEST WITH PUNCH OF RADIUS 10 MM. EXTENSION DEPTH OF PRESSING SHOULD NOT BE LESS THAN 10.0 M.M.

④ TOLERANCE ON SHEET OF 0.8 MM THICKNESS - -0.08 M.M.

⑤ SURFACE FINISH

- i) Rz 80 ✓(✓) :- INDICATES SURFACE FINISH OF RZ VALUE 80 MICRONS TO BE OBTAINED BY ANY PRODUCTION METHOD ON THOSE SURFACE WHERE SURFACE FINISH IS NOT SPECIFIED.
- ii) :- INDICATES SURFACE FINISH ON BOTH SIDE TO BE OBTAINED BY WITHOUT REMOVAL OF MATERIAL.

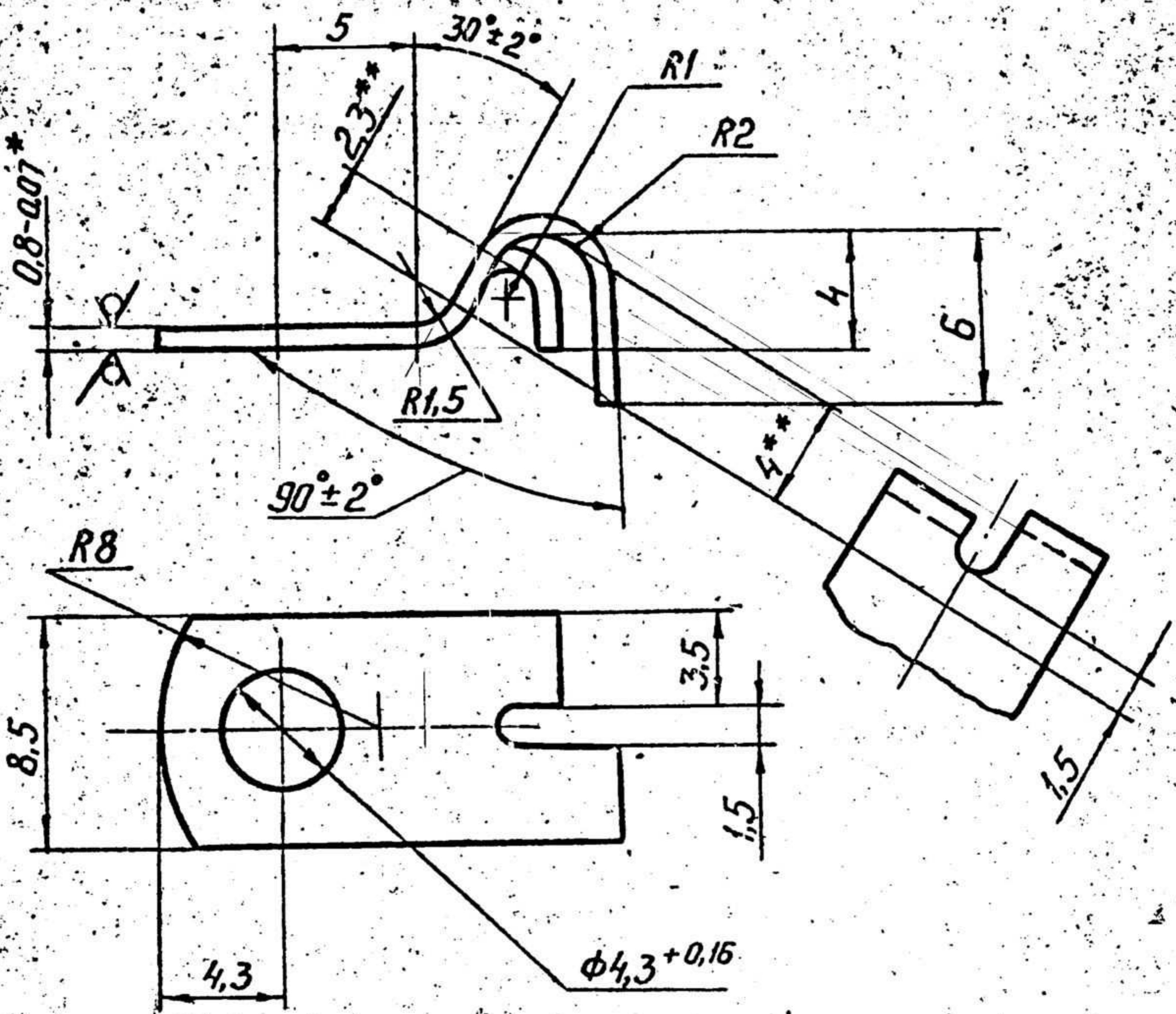
79/D2073

APPROVED	1-ИГБ-132	
CHECKED	WEIGHT	SCALE
	0.5g	2:1
	SHT	SHTS 1
END PIECE		
www.easy2convert.com		
SHEET ДПРМ 0.8 Л63		
ГОСТ 931-78		

INScribed	CHECKED	APPROVED	DATE	DRG NOT TO BE SCALED	PERTAINS TO
				ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	
				ALL DIMENSION ARE IN MM. UNLESS OTHERWISE SPECIFIED	
				END PIECE	
TOLERANCE UNLESS OTHERWISE SPECIFIED				1-ИГБ-132	
D-CO	D-T	ZONE	BRIEF RECORD	SIGN	GEN DEC ANG
					SCALE
CONTROLLERATE OF INSPECTION FIRE FIGHTING EOPT PUNE					

8L-Φ14-1

Rz 80 ✓(✓)



TECHNICAL CONDITIONS

"REFER TO DRG NO. ДГН-3.035 FOR EXPLANATORY NOTES"

1. $\#$ Size for reference.
2. $\#\#$ Provide for sizes by appropriate tools.
3. Tolerable deviations should be within ± 0.25 mm unless otherwise specified.

4. Coating: 0 - Bu 9. (TIN-BISMUTH 9 MICRONS THICK)

SURFACE FINISH \sqrt{Rz} :- REPRESENTS THE REMOVAL OF MATERIAL IS NOT PERMITTED ON BOTH SIDES OF THE JOB.

[Signature]
(R VEERARAGHAVAN)
SSO-II

Rz 80/√ :- REPRESENTS THE SURFACE FINISH TO BE OBTAINED BY ANY PRODUCTION METHOD IN Rz VALUE 804 max ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED. 73/02073

APPROVED

[Signature]
MVASU

1-ИГФ-78

CHECKED.

[Signature]
V. Baburam

CONTROLLERATE
OF
INSPECTION

END PIECE

WEIGHT

SCALE

0.95g

1:1

SHT

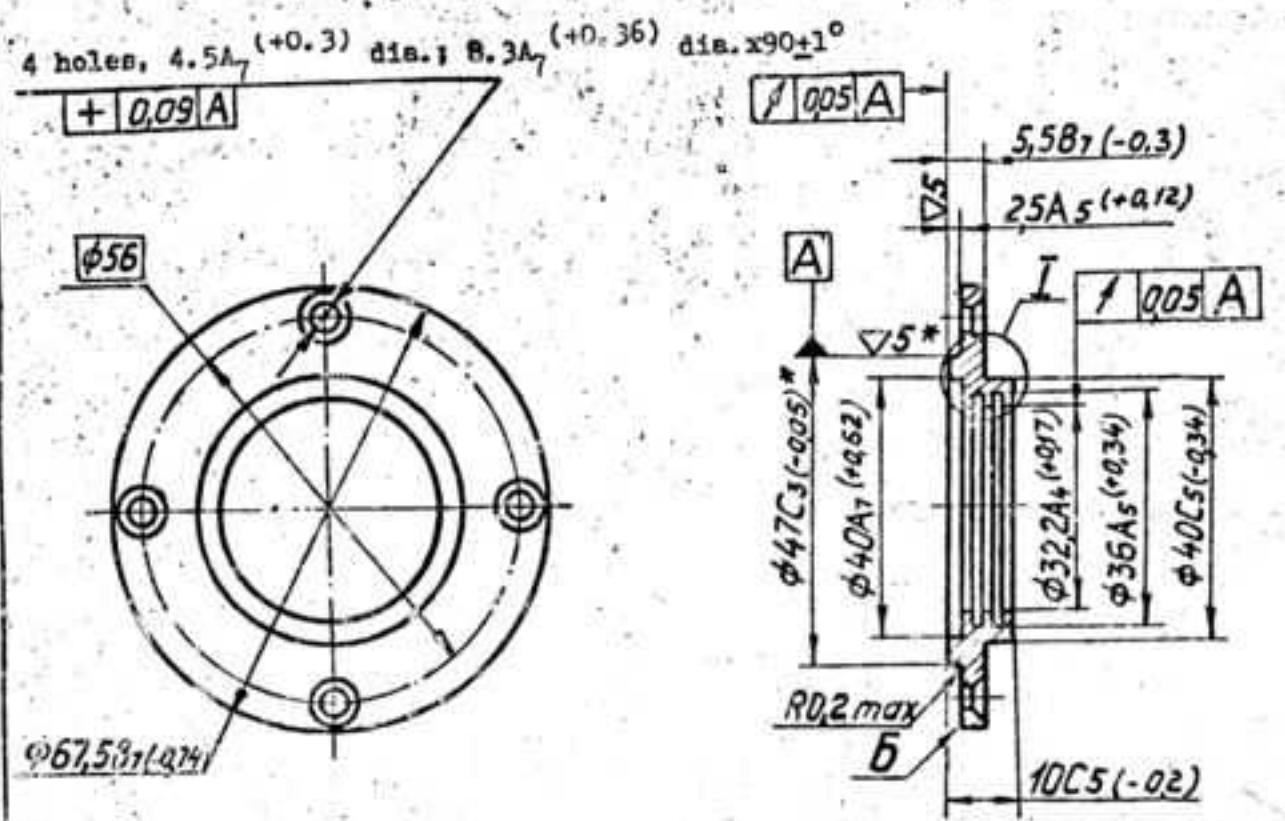
SHTS. 1

FE (ICV) PUNE

BAND APRM 0.8 J 63
ГОСТ 2208-75

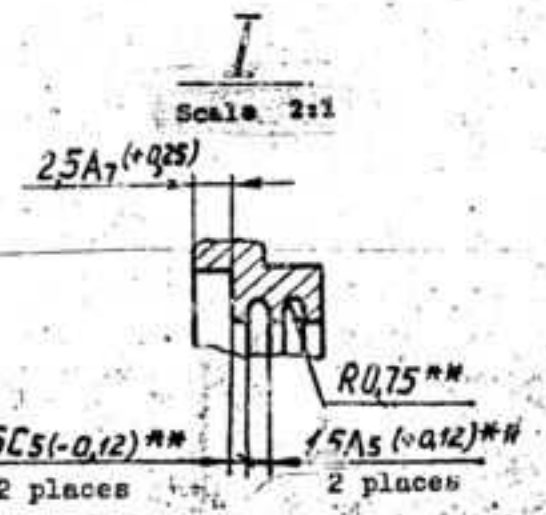
1-4-4-

110.020E



TECHNICAL CONDITIONS

1. Coating: zinc plating 15 followed by chromate treatment.
2. Size and roughness of the surface after coating.
3. Provide for sizes by appropriate tools which are to be checked at least once quarterly.
4. Round off to R 0.5 mm or chamfer 0.5x45°, maximum.
5. It is allowed to cut into planes A and B to a depth of 0.5 mm, maximum.



APPROVED: *[Signature]* 110.020E

CHECKED: *[Signature]*

FLANGE

STEEL GRADE 10 TO GOST 1050-74

WEIGHT: 0.0725 SCALE: 1:1

SHT: 1 SHOTS: 1

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

1. FLANGE SHOULD BE MANUFACTURED FROM CARBON STRUCTURAL HOT ROLLED / FORGED STEEL OF GRADE 10 TO GOST 1050-74 HAVING THE FOLLOWING CHEMICAL COMPOSITION

STEEL GRADE	CONTENTS OF ELEMENT %			
	CARBON	SILICON	MANGANESE	CHROMIUM(MAX)
10	0.07-0.14	0.17-0.37	0.35-0.65	0.15

2. MECHANICAL PROPERTIES OF STEEL GRADE 10 TO GOST 1050-74 ARE GIVEN BELOW: —

- 1) HEAT TREATMENT OF BLANKS — NORMALISING.
- 2) YIELD POINT — 21 kgf/mm² (MIN.)
- 3) ULTIMATE TENSILE STRENGTH — 34 kgf/mm² (MIN.)
- 4) PERCENTAGE ELONGATION — 31% (MIN.)
- 5) REDUCTION OF AREA — 55% (MIN.)
- 6) HARDNESS (WITHOUT HEAT-TREATMENT) — 143 BHN (MAX.)

3. THE RECOMMENDED HEATING TEMPERATURE DURING HEAT TREATMENT OF BLANKS FOR CARRYING OUT THE TESTS OF MECHANICAL PROPERTIES ARE GIVEN BELOW:

- NORMALISING — 920°C
- HOLDING PERIOD — MIN. 30 MINUTES

4. SURFACE FINISH:

- 1) ∇3 (CV) : REPRESENTS THE SURFACE FINISH VALUE R_a 20 MICRONS ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.
- 2) ∇5 : — REPRESENTS THE SURFACE FINISH VALUE R_a 5 MICRONS.

5. NOTES:—

- 1) 0.05 A : REPRESENT RUNOUT OF INDICATED DIMENSION TO BE WITHIN 0.05 mm. WITH REFERENCE TO BASE INDICATED AS 'A'
- 2) φ 56 : ON THE DIMENSIONS φ 56 TOLERANCE IS NOT SPECIFIED BUT IT IS NOT A FREE DIMENSION
- 3) +0.09 A : — POSITIONAL TOLERANCE OF HOLES IS 0.09 mm FROM BASE 'A'

INSCRIBED: _____

CHECKED: *[Signature]*

APPROVED: *[Signature]*

DATE: 17.11.86

TOLERANCE UNLESS OTHERWISE SPECIFIED

GEN. DEC. ANG.

DRG. NOT TO BE SCALED. ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF. ALL DIMENSIONS ARE IN MM. UNLESS OTHERWISE SPECIFIED.

FLANGE

SCALE:—

CONTROLLERATE OF INSPECTION FIRE FIGHTING EQUIP. PUNE.

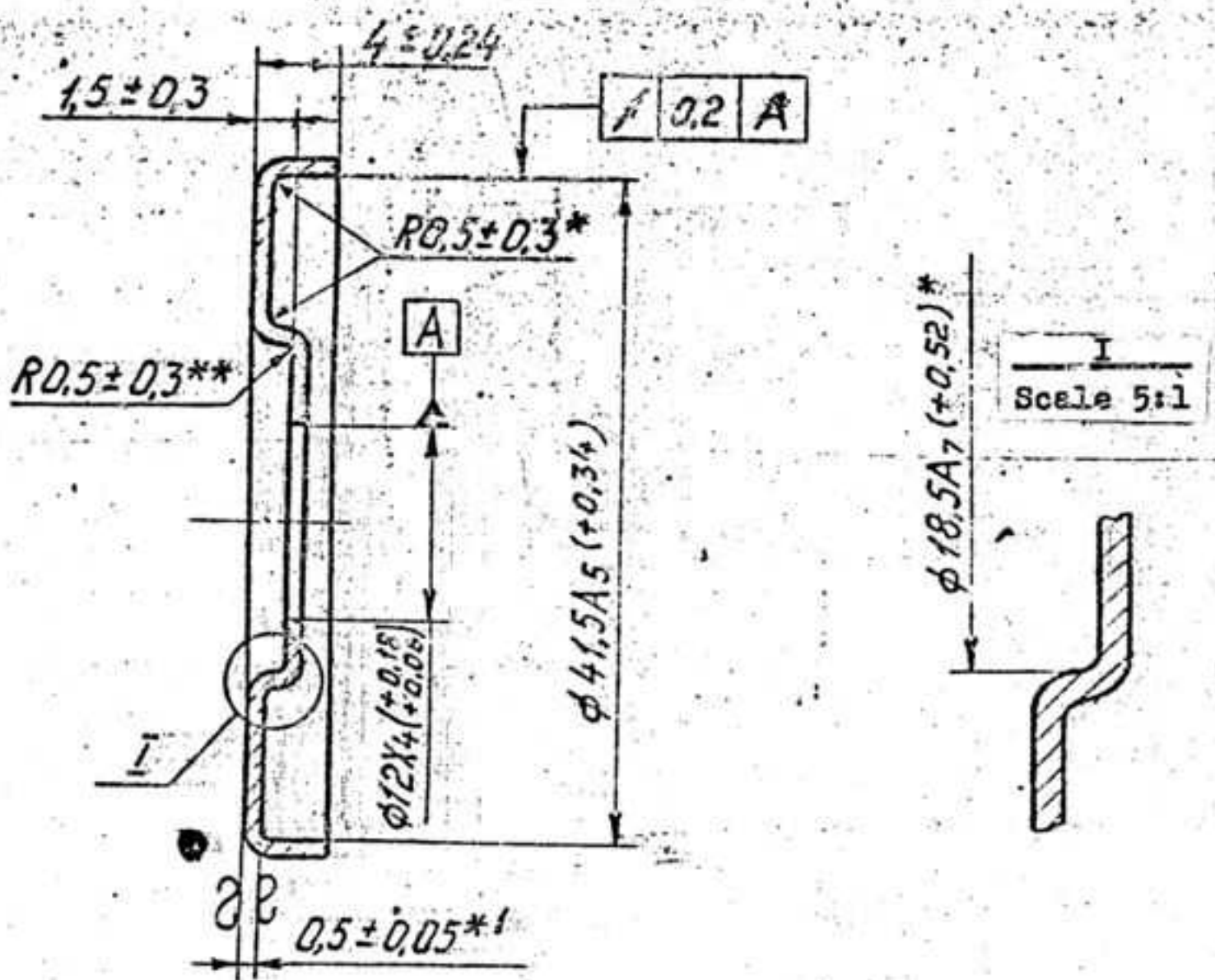
PERTAINS TO: 110.020E

1-4-4

Восстановлен с подлинника №1 Верно 3568 11.4.72 (Подп.)

610 0206

▽3(▽)



TECHNICAL CONDITIONS

1. Coating: zinc plating 15 followed by chromate treatment.
2. Provide for size by appropriate tools which are to be checked at least once quarterly.
3. ^{m1} Size for reference.

610.0206

EXPLANATORY NOTES TO TECHNICAL CONDITIONS

PROTECTIVE WASHER SHOULD BE MANUFACTURED FROM COLD-ROLLED SHEET-STEEL, GRADE 08K17, WITH NORMAL ROLLING ACCURACY (B), HIGH SURFACE FINISH (II) & SUITABLE FOR EXTREMELY DEEP DRAWING (BT) CONFORMING TO GOST 9045-80

1. CHEMICAL COMPOSITION: (GOST 9045-80)

STEEL GRADE	CARBON (MAX.)	MANGANESE	SULPHUR (MAX.)	PHOSPHORUS (MAX.)	PROPORTION OF ELEMENTS BY WEIGHT, %			
					SILICON	CHROMIUM	NICKEL	COPPER
08K17	0.10	0.20 - 0.40	0.030	0.025	0.03	0.10	0.10	0.15

NOTE: - ARSENIC & NITROGEN CONTENT SHOULD NOT EXCEED 0.08% AND 0.006% BY WEIGHT RESPECTIVELY.

2. MECHANICAL PROPERTIES: - (GOST 9045-80)

- a) CATEGORY: (BT (VG): SUITABLE FOR EXTREMELY DEEP DRAWING.
- b) ULTIMATE STRENGTH: 26 - 37 Kgf/mm²
- c) RELATIVE ELONGATION: 28 %
- d) DEEP DRAWING TEST ON RAW MATERIAL

THE DEPTH OF OF SPHERICAL INDENTATION MUST CONFORM TO THE NORMS SHOWN BELOW: -

SHEET THICKNESS	DEPTH OF SPHERICAL INDENTATION (MIN) THREE PLACES
0.5 MM.	9.0

e) MICRO STRUCTURE: STRUCTURALLY FREE FROM CEMENTITE^{tc} NOT MORE THAN 3

3. SURFACE FINISH:

- 1) dk: - REPRESENTS SURFACE VALUE Ra 80 μ ON BOTH SIDE OF THE JOB
- 2) V3 (γ): - REPRESENTS THE SURFACE FINISH VALUE Ra 20 μ ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.

4. SYMBOLS: -

$\sqrt{0.2 A}$: - REPRESENTS RUN OUT OF INDICATED DIMENSION TO BE WITHIN 0.2 mm WITH RESPECT TO BASE 'A'

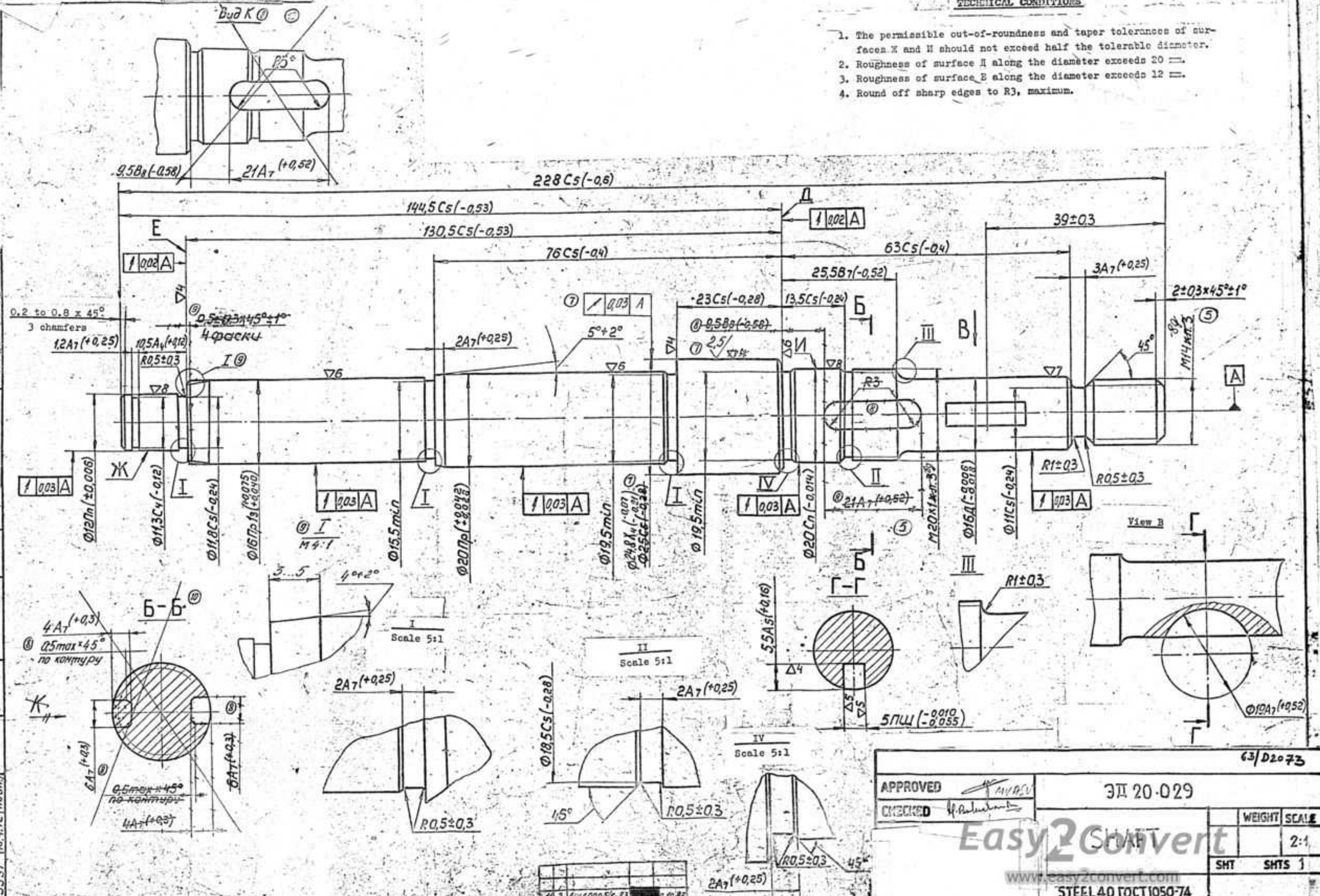
Восстановлен с подлинника

APPROVED <i>MV/ASV</i>		ЭД 20-019	
CHECKED <i>V. Baturanov</i>		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)		0.006	1:1
		SHT	SHTS 1
SHEET		Б0-5 ГОСТ 19904-74	
		П-8Г-08КП-АН ГОСТ 9045-80	

INSCRIBED	DRG. NOT TO BE SCALED.		PERTAINS TO		
	CHECKED <i>ASV</i>	ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.			
		ALL DIMENSIONS ARE IN MM. UNLESS OTHERWISE SPECIFIED.			
	APPROVED <i>ASV</i>	PROTECTIVE WASHER		ЭД 20-019	
	DATE 17-11-14	SCALE: -			
TOLERANCE UNLESS OTHERWISE SPECIFIED.	CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT. PUNE.				
GEN. DEC. ANG.	DCU	BT.	ZONE	BRIEF RECORD	SIGN.

TECHNICAL CONDITIONS

1. The permissible out-of-roundness and taper tolerances of surfaces X and W should not exceed half the tolerable diameter.
2. Roughness of surface I along the diameter exceeds 20 μ .
3. Roughness of surface B along the diameter exceeds 12 μ .
4. Round off sharp edges to R3, maximum.



EXPLANATORY NOTES TO TECH. CONDITIONS

1. SHAFT SHOULD BE MANUFACTURED FROM CARBON STRUCTURAL FORGED STEEL OF GRADE 40 OF GOST 1050-74 ARE HAVING THE FOLLOWING CHEMICAL COMPOSITION.

GRADE OF STEEL	CONTENTS OF ELEMENT-%			
	CARBON	SILICON	MANGANESE	CHROMIUM (MAX.)
40	0.37-0.45	0.17-0.37	0.50-0.80	0.25

2. MECHANICAL PROPERTIES OF STEEL GRADE 40 OF GOST 1050-74 ARE GIVEN BELOW:-

- a) HEAT TREATMENT OF BLANKS ——— NORMALISING
- b) YIELD POINT ——— 24 Kgf/mm² (MIN)
- c) ULTIMATE TENSILE STRENGTH ——— 58 Kgf/mm² (MIN)
- d) PERCENTAGE ELONGATION ——— 19% (MIN)
- e) REDUCTION OF AREA ——— 45% (MIN)
- f) IMPACT STRENGTH ——— 61 Kgm/cm² (MIN)
- g) HARDNESS ——— 217 BHN. (MAX)

3. THE RECOMMENDED HEATING TEMPERATURE DURING HEAT TREATMENT OF BLANKS FOR CARRYING OUT THE TESTS OF MECHANICAL PROPERTIES OF STEEL GRADE ARE GIVEN BELOW:-
 NORMALISING — 870 °C
 MINIMUM HOLDING PERIOD — 30 MINUTE

SURFACE FINISH :-

- ▷ $\sqrt{0.3}$:- REPRESENTS THE SURFACE FINISH VALUE $R_a 20 \mu$ ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.
- ▷ $\sqrt{0.4}$:- REPRESENTS THE SURFACE FINISH VALUE i.e. $R_a 10 \mu$.
- ▷ $\sqrt{0.5}$:- REPRESENTS THE SURFACE FINISH VALUE i.e. $R_a 5 \mu$.
- ▷ $\sqrt{0.6}$:- REPRESENTS THE SURFACE FINISH VALUE i.e. $R_a 2.5 \mu$.
- ▷ $\sqrt{0.7}$:- REPRESENTS THE SURFACE FINISH VALUE i.e. $R_a 1.25 \mu$.
- ▷ $\sqrt{0.8}$:- REPRESENTS THE SURFACE FINISH VALUE i.e. $R_a 0.63 \mu$.
- ▷ $\sqrt{2.5}$:- THE R_a VALUE OF SURFACE FINISH TO BE OBTAINED BY ANY PRODUCTION METHOD IS MAXIMUM 2.5 μ .

NOTES :-

- ▷ $\sqrt{0.02} A$:- REPRESENT THE RUN OUT OF INDICATED DIMENSION TO BE WITHIN 0.02mm FROM THE BASE INDICATED AS 'A'
- ▷ $\sqrt{0.03} A$:- REPRESENT THE RUN OUT OF INDICATED DIMENSION TO BE WITHIN 0.03mm FROM THE BASE INDICATED AS 'A'
- ▷ \sqrt{A} :- BASE IS 'A'

APPROVED [Signature] 3II 20-029 63/D2073

CHECKED [Signature]

WEIGHT SCALE 2:1

SHT SHTS 1

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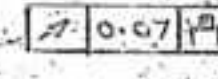
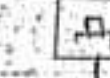
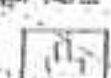
STEEL 40 GOST 1050-74

INSCRIBED	DRS. NOT TO BE SCALED.	PERTAINS TO
CHECKED [Signature]	ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	
APPROVED [Signature]	ALL DIMENSIONS ARE IN MM. UNLESS OTHERWISE SPECIFIED.	
DATE [Signature]		SHAFT 3 II 20-029
TOLERANCE UNLESS OTHERWISE SPECIFIED		SCALE :-
GEN DET ANG		CONTROLLER OF INSPECTION FIRE FIGHTING DEPT. PUNE.

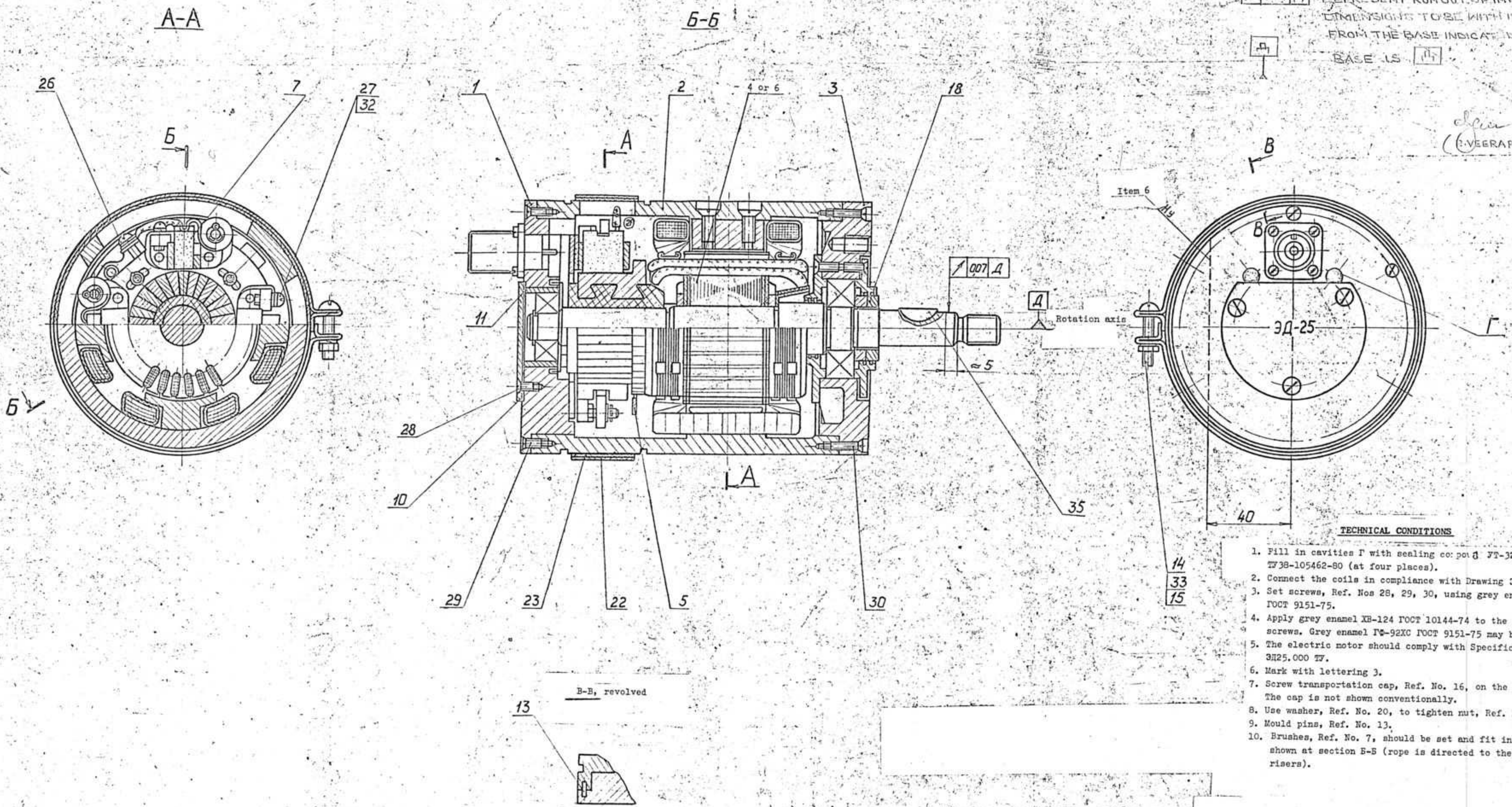
Восстановлен с подлинника. Слоб. № 3А 20.150СБ
 13537 10.4.72 (подп.)

I) COPY OF 325.000 TY ENCLOSED
 II) THE SEALING COMPOUND TO TY 38-105462-80 ARE LIQUID THICOL BASED COMPOUND WITH TEMPERATURE RANGE 60°C TO 100°C

III) COATINGS
 REF. NOTE NO. 1
 APPLY GREY ENAMEL CONFORMING TO IS: 2932-74 (ENAL 10-694 OF IS: 5-1073)

IV) SYMBOLS
 REPRESENT RUN OUT OF INDICATED DIMENSIONS TO BE WITH IN 0.07 mm FROM THE BASE INDICATED BY 'A'
 BASE IS 

(Signature)
 VEERARAGHAN
 13.08.72

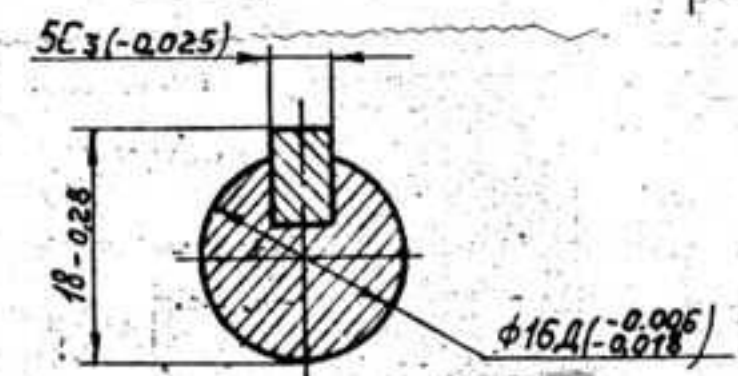
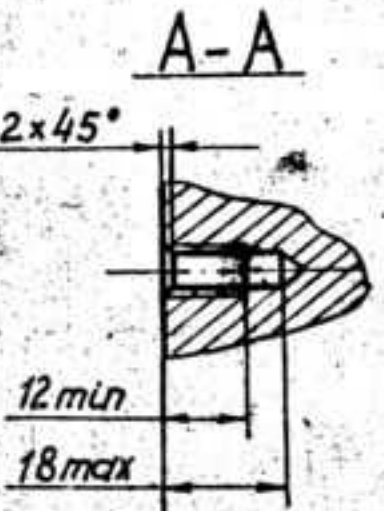
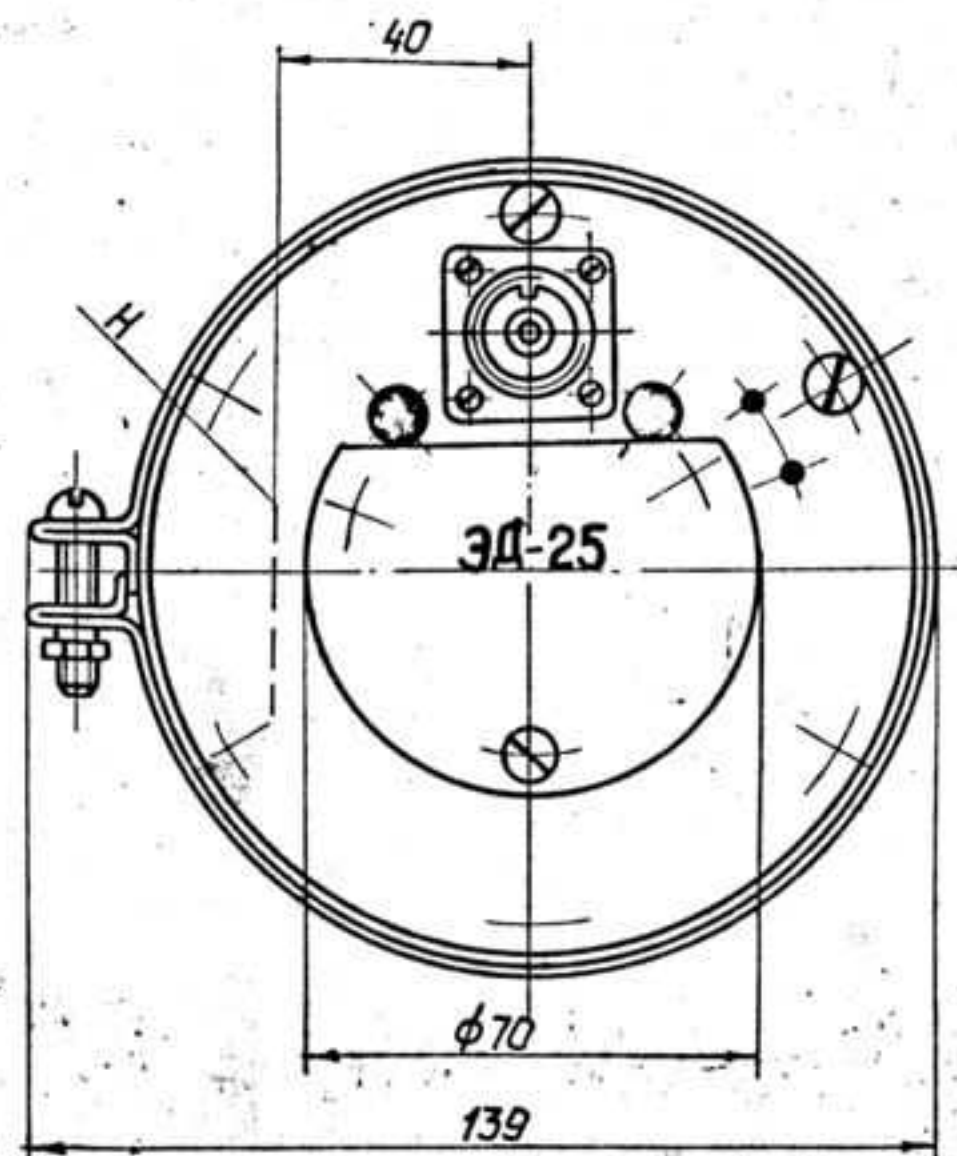
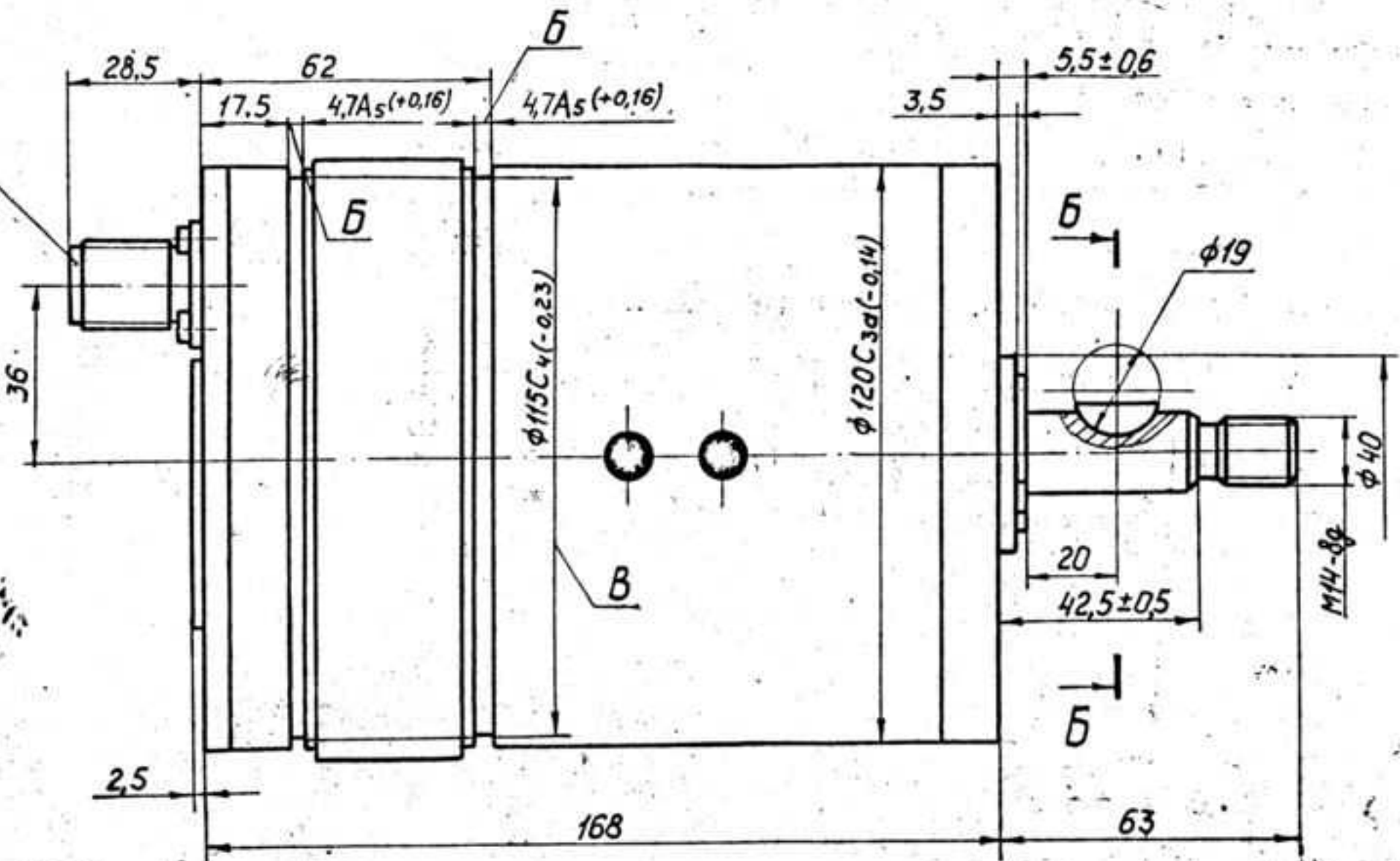
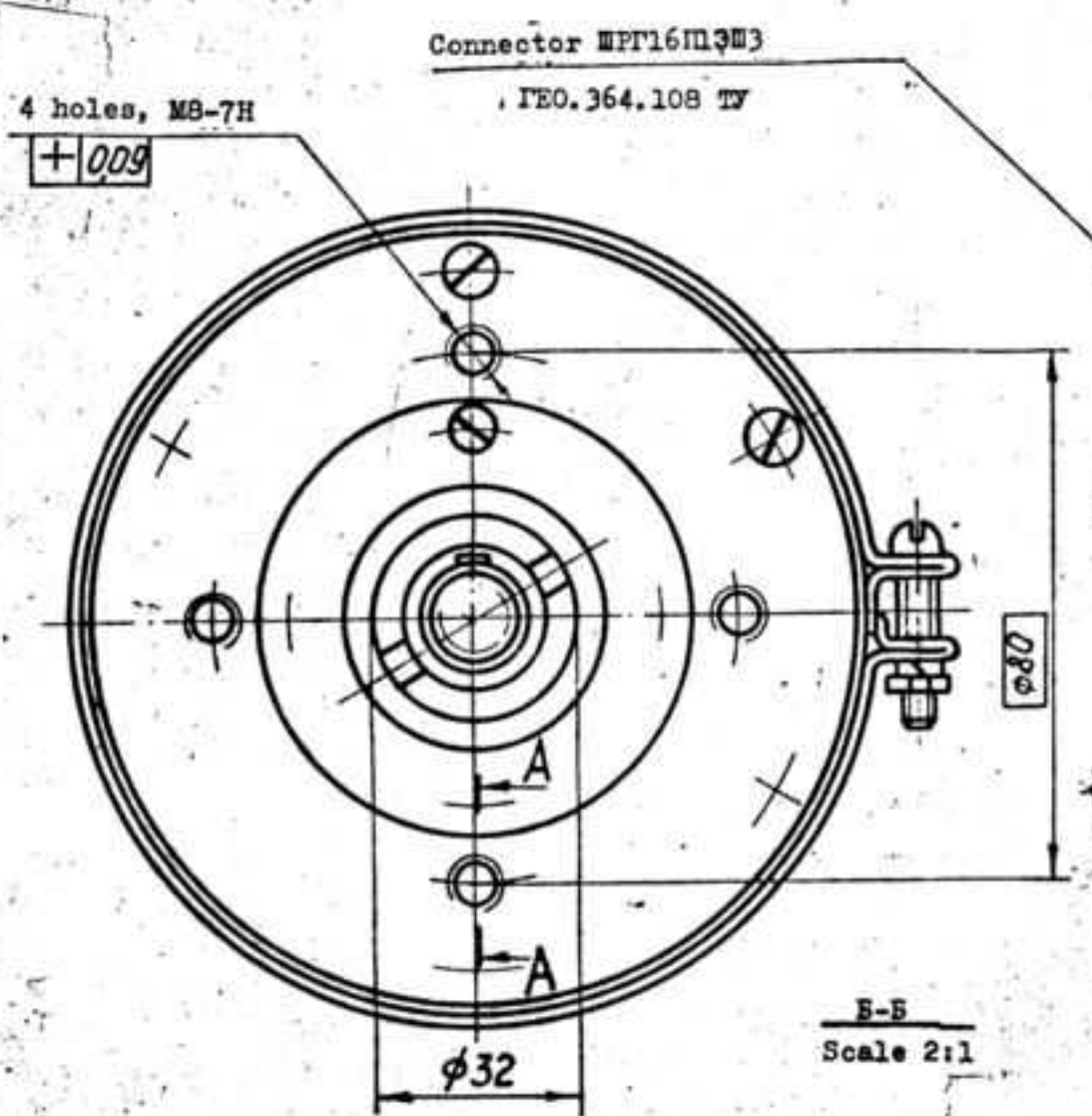


- TECHNICAL CONDITIONS**
- Fill in cavities F with sealing compound JT-32HT TY38-105462-80 (at four places).
 - Connect the coils in compliance with Drawing 325.000 33.
 - Set screws, Ref. Nos 28, 29, 30, using grey enamel PQ-92XC POCT 9151-75.
 - Apply grey enamel XB-124 POCT 10144-74 to the heads of the screws. Grey enamel PQ-92XC POCT 9151-75 may be used as well.
 - The electric motor should comply with Specifications 325.000 TY.
 - Mark with lettering 3.
 - Screw transportation cap, Ref. No. 16, on the plug connector. The cap is not shown conventionally.
 - Use washer, Ref. No. 20, to tighten nut, Ref. No. 18.
 - Mould pins, Ref. No. 13.
 - Brushes, Ref. No. 7, should be set and fit in the position shown at section B-B (rope is directed to the commutator risers).

APPROVED <i>(Signature)</i>		325.000 CB	
CHECKED <i>(Signature)</i>	CONTROL RATE OF INSPECTION	ELECTRIC MOTOR	WEIGHT SCALE
FE (ICV) PUNE		32-25 ASSEMBLY DRAWING	8 1:1
			SHT SHTS 1
			3-4-At

325.000Г4-4

3A-25
 Справ. №
 13628
 12.4.72 (1962)
 Восстановлен с подлинника №1
 ч. 108.1108 № 0108. Подп. К.
 13628



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www.easy2convert.com

TECHNICAL CONDITIONS

- Counterclockwise rotation on the drive side.
- Remove the protective band when installing the electric motor.
- Before installing the compressor impeller on the shaft, it should be dynamically balanced with an accuracy of 0.3 gcm.
- The electric motor is used to actuate the compressor-separator, type BHCH-200 with a minimum air discharge of 200 m³/h and maximum consumed power of 600 W.
- When installing the electric motor in the compressor-separator, place the sealing rings, 3,3 mm dia., in the grooves having dimensions B and B.

SYMBOLS

- +0.09 - DISPLACEMENT OF AXES OF HOLE FROM ITS TRUE POSITION TO BE WITHIN 0-09 mm
- φ80 - DIMENSION ENCLOSED IN RECTANGLE IS SHOWN WITHOUT TOLERANCE BUT IT IS NOT A FREE DIMENSION

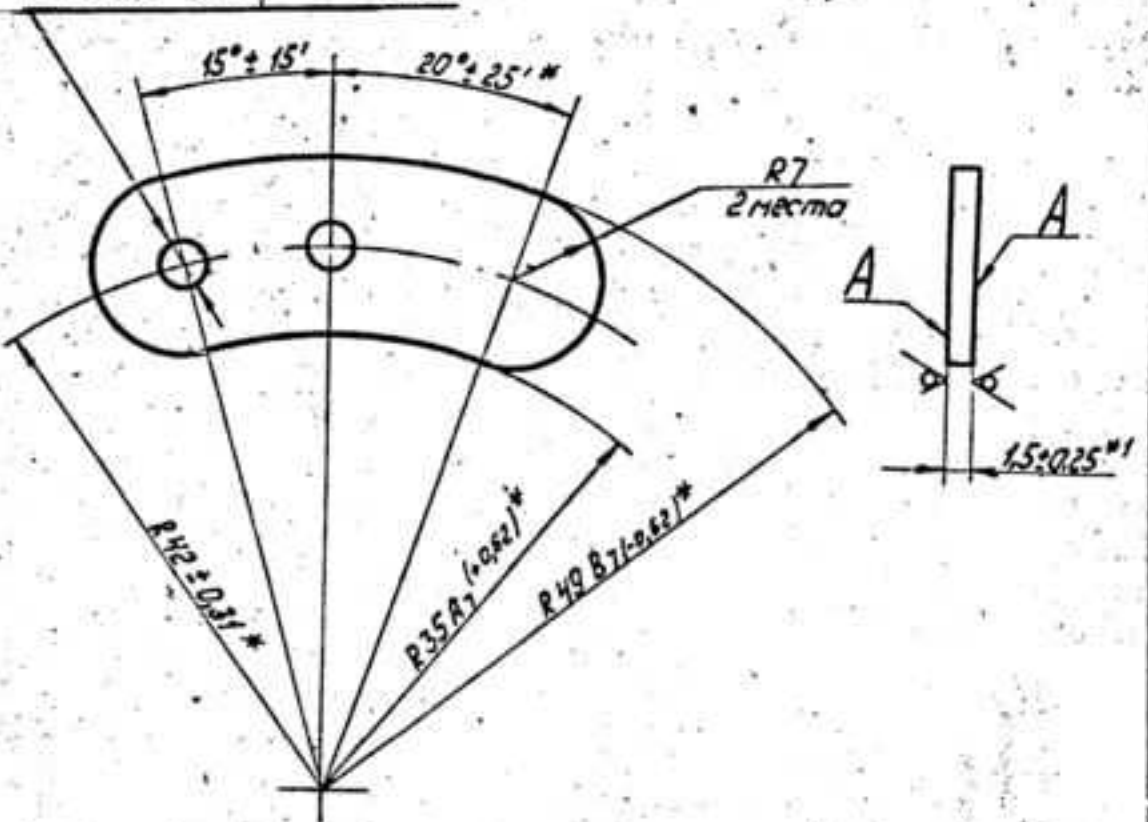
(R VEERARAGHAVAN)
SS011

APPROVED	ЭД25.000Г4-4	
CHECKED	ELECTRIC MOTOR	WEIGHT SCALE
CONTROLLERATE OF INSPECTION	3A-25	8.0 1:1
	OUTLINE DRAWING	SHT SHTS 1
FE (ICV) PUNE	1-3A-4	

3A25.003

▽3(▽)

2 holes, 3.5A₇ (+0.3) dia.



1. Impregnate with varnish IV-95 GOCT 8018-0.
2. Local tears of 0.5 mm, max., are allowed along the part contour without chipping surfaces A.
3. Provide for sizes by appropriate tools which are to be checked at least once quarterly.
4. Size for reference.

48/D2073

APPROVED

CHECKED

3A25-003

GASKET

WEIGHT	SCALE
0.0015	2:1
SHT	SHTS. 1

GLASS-CLOTH-BASE LAMINATE CT-I-13 GOCT 12652-74

3A25.003

EXPLANATORY NOTES TO TECHNICAL CONDITIONS:-

- 1) GASKET SHOULD BE MANUFACTURED FROM GLASS CLOTH BASE LAMINATE SHEET OF THICKNESS 1.5 mm. GRADE CT-I AS PER GOCT: 12652-74 HAVING THE TECHNICAL REQUIREMENTS AS FOLLOWS
 - i) ELECTRICAL QUALITY TEXTOLITE SHEET IS A PRESSED MATERIAL CONSISTING OF TWO OR MORE LAYERS OF GLASS FIBRE CLOTH IMPREGNATED WITH THERMOACTIVE RESIN.
 - ii) GLASS TEXTOLITE OF GRADE CT-I MUST CONFIRM TO THE FOLLOWING PHYSICAL MECHANICAL AND ELECTRICAL REQUIREMENTS.
 - i) DENSITY g/cm³ - 1.60 - 1.90
 - ii) RESISTANCE TO SHORT DURATION HEATING - NOT LESS THAN 200 Ohm.
 - iii) RESISTANCE TO ACTION OF OIL - IN - TRANSFORMER OIL FOR 4 HOURS AT NOT LESS THAN 130°C
 - iv) WATER ABSORPTION NOT MORE THAN 1%
 - v) SURFACE RESISTIVITY, OHMS, NOT LESS THAN 1×10^{12} AFTER SOAKING FOR 24 HOURS IN A HUMIDITY CHAMBERS AT RELATIVE HUMIDITY OF 95 ± 2% & 20 ± 2°C
 - vi) VOLUME RESISTIVITY, OHM-CM, NOT LESS THAN 1×10^{13} AT A RELATIVE HUMIDITY OF 45 TO 75% AND 15 TO 35°C, 1×10^{12} AFTER SOAKING FOR 24 HOURS IN A HUMIDITY CHAMBER AT A RELATIVE HUMIDITY OF 95 ± 2% AND 20 ± 2°C
 - vii) DISSIPATION FACTOR AT 50° HZ, RELATIVE HUMIDITY 45 TO 75% AND 15 TO 35°C - NOT MORE THAN 0.03.
 - viii) DIELECTRIC STRENGTH PERPENDICULAR TO THE LAYERS AT 50 HZ IN TRANSFORMER OIL AT 90 ± 2°C - NOT LESS THAN 27 KVEFF/mm.
- 2) GASKET SHOULD BE IMPREGNATED WITH VARNISH GRADE T-95 AS PER GOCT 8018 HAVING PHYSICO-CHEMICAL AND ELECTRICAL PROPERTIES AS GIVEN BELOW.
 - i) 1×10^{13} AT RELATIVE HUMIDITY, 45 TO 75% & 15 TO 35°C, - 1×10^{12}

- i) APPEARANCE OF VARNISH FILM AFTER DRYING, THE VARNISH SHOULD FORMULATE GLOSSY, HOMOGENEOUS AND SMOOTH FILM.
- ii) VISCOSITY BY VISCOSMETER B₃-4 AT 20°C IN SECS - 30 - 50
- iii) DRY RESIDUE IN %, NOT LESS THAN - 45
- iv) ACID NUMBER IN MG OF KOH, NOT EXCEEDING - 12
- v) DRYING TIME AT 105-110°C IN HOURS, NOT EXCEEDING - 2
- vi) THERMOELASTICITY OF FILM AT 150°C IN HOURS, NOT LESS THAN - 48.
- vii) HARDNESS OF FILM BY PENDULUM TESTER AT 20 ± 1°C, NOT LESS THAN - 0.40
- viii) OIL RESISTANCE OF FILM IN KG, NOT LESS THAN - 6
- ix) ELECTRICAL STRENGTH OF FILM IN KV/mm, NOT LESS THAN AT 20 ± 2°C - 70 AT 120 ± 2°C - 40 AFTER ACTION OF WATER FOR 24 HRS AT 20 ± 2°C - 20
- x) VOLUME RESISTIVITY OF FILM IN OHM.CM, NOT LESS THAN, AT 20 ± 2°C - 1×10^{14} AFTER ACTION OF WATER FOR 24 HRS. AT 20 ± 2°C - 1×10^{12}

4 SURFACE FINISH:-

- i) ▽3 (▽) - REPRESENTS SURFACE FINISH R VALUE 20 MICRONS ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.
- ii) $\frac{1}{2} \frac{1}{k}$ - SPECIFIED SURFACE FINISH TO BE OBTAINED ON BOTH SIDE BY WITHOUT REMOVAL OF MATERIAL.

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INSCRIBED	DRG NOT TO BE SCALED	PERTAINS TO
CHECKED	ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF.	
APPROVED	ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE SPECIFIED	
DATE	GASKET	3A25-003
TOLERANCE UNLESS OTHERWISE SPECIFIED	SCALE :-	
GEN I DEC 1 ANA.	CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT PUNE.	

400 52 06

▽3(▽)

TECHNICAL CONDITIONS

1. [#]Size for reference.
2. Coating: cadmium plating 9.
3. [#]Provide for sizes by appropriate tools which are to be checked at least once quarterly.
4. Excessive metal is allowed at size R at the place of bending.

3A 25.010.05

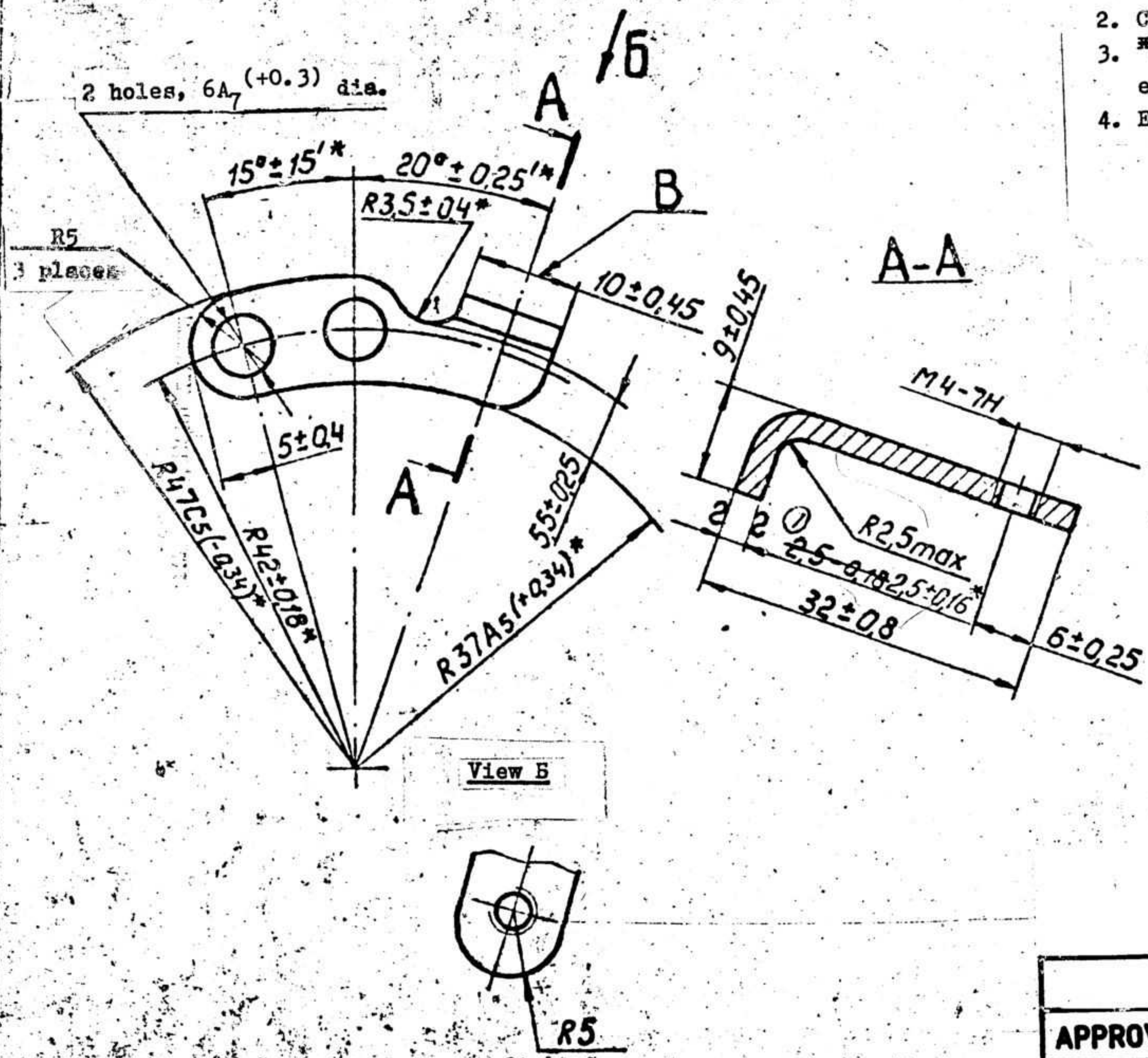
Восстановлен с подлинника

Исполнен в приводе

Исполнен в приводе

Исполнен в приводе

13615 12.472 (подп.)



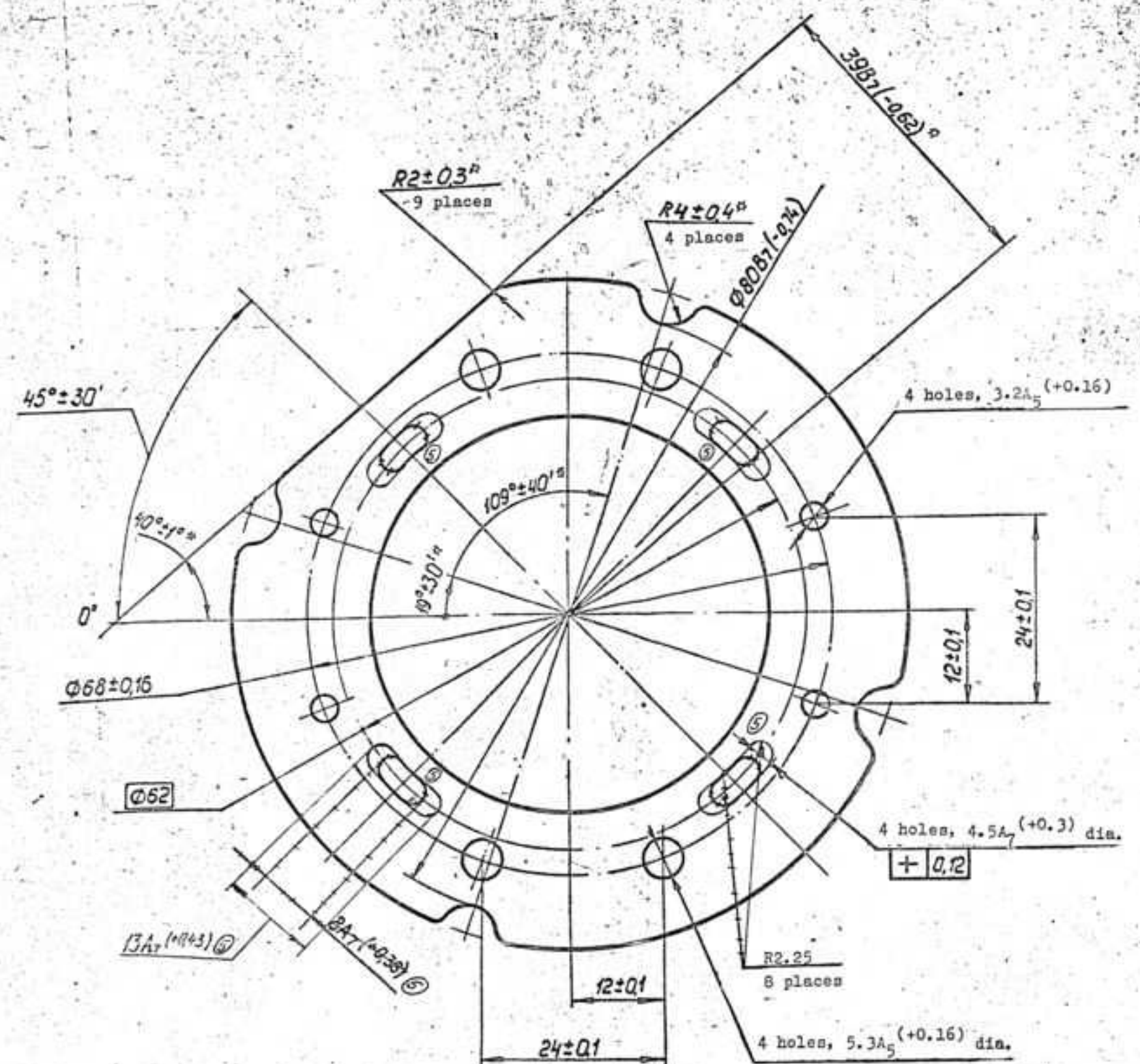
"REFER TO DRG NO 3A 25.005 FOR EXPLANATORY NOTES"

(R.VEERARAGHAVAN)
SSO-II

APPROVED <i>[Signature]</i>		3A 25.004	
CHECKED <i>[Signature]</i>		ANGLE	WEIGHT SC
CONTROLLERATE OF INSPECTION			0.0108 2
FE XXXXXXXXXX PUNE		SHTS	SHTS 1
SHEET		Б-ПВ-2.5 П СТ 19904-74	
		4-П-10 ГОСТ 16523-70	

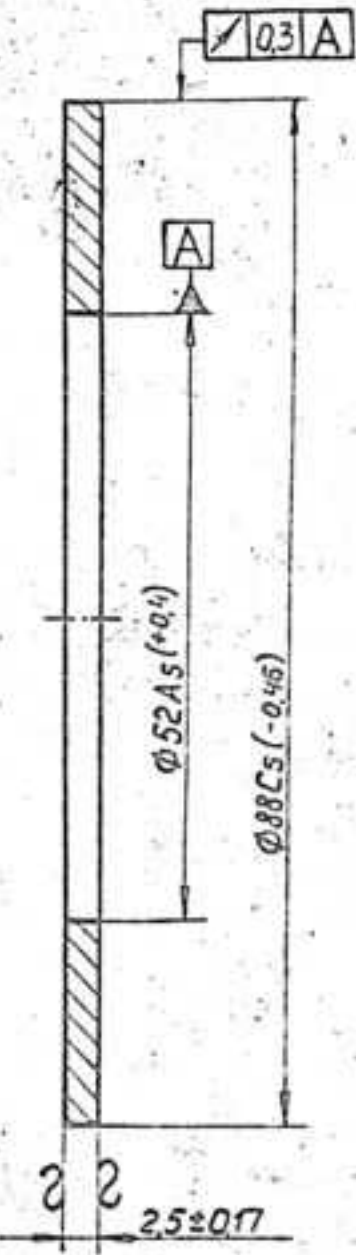
49/D2073

Easy2Convert



TECHNICAL CONDITIONS

1. Zinc plating 15 followed by chromate treatment.
2. Provide for sizes by appropriate tools which are to be checked at least once quarterly.



EXPLANATORY NOTES TO TECH. CONDITIONS

1. CROSS BEAM SHOULD BE MANUFACTURED FROM COLD ROLLED QUALITY CARBON STEEL OF GRADE 10, SHEET 2.5 mm THK. WITH STANDARD ROLLING ACCURACY (B) CATEGORY 4 & HIGH SURFACE FINISH (II) HAVING THE DIMENSION OF SHEET AS PER GOST 19904-74 AND CHEMICAL COMPOSITIONS & MECHANICAL PROPERTIES CONFORM TO GOST 16523-78 & GOST 1050-74.

2. CHEMICAL COMPOSITION (GOST 1050-74)

CONTENTS OF ELEMENTS %			
CARBON	SILICON	MANGANESE	CHROMIUM
0.07-0.14	0.17-0.37	0.35-0.65	0.15 (MAX.)

3. MECHANICAL PROPERTIES :-

- a) TENSILE STRENGTH — 30-42 Kgf/mm²
- b) RELATIVE ELONGATION — 2.8%

- iv) $\square 0.3 A$:- REPRESENTS THE RUN OUT OF INDICATED DIMENSION TO BE WITHIN 0.3 mm FROM THE BASE INDICATED AS 'A'
- v) $\square A$:- INDICATES BASE DIMENSION IS 'A'

vi) DIMENSIONS SHOWN IN RECTANGLES ARE WITHOUT TOLERANCES BUT THOSE ARE NOT A FREE DIMENSIONS.

4. SURFACE FINISH :-

- ab - REPRESENTS SURFACE FINISH TO BE OBTAINED IN Ra VALUE OF 50 μ ON BOTH SIDE OF THE JOB.
- ▽3(▽) - REPRESENTS SURFACE FINISH TO BE OBTAINED IN Ra VALUE OF 20 μ ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.

$\square + 0.12$ DISPLACEMENT OF HOLE AXES TO BE WITHIN 0.12 mm FROM ITS THROUGH POSITION

APPROVED	50 10 20 73	31 25 005	WEIGHT	SCALE
CHECKED			0.066	2:1
		CROSS BEAM	SHT	SHTS. 1
		SHEET 52.5 GOST 19904-74		
		4-1-10 GOST 16523-76		

DESCRIBED	DWG. NOT TO BE SCALED.	PERTAINS TO
CHECKED	ALL SHARP EDGES & CORNERS ARE TO BE ROUNDED OFF.	
APPROVED	ALL DIMENSIONS ARE IN MM. UNLESS OTHERWISE SPECIFIED.	
DATE		CROSS BEAM
TOLERANCE UNLESS OTHERWISE SPECIFIED.		31 25 005
SIGN	SCALE:-	CONTROLLER/INSP. FIRE FIGHTING EQPT. PUNE.

3A 25.006 CB

Справ. №

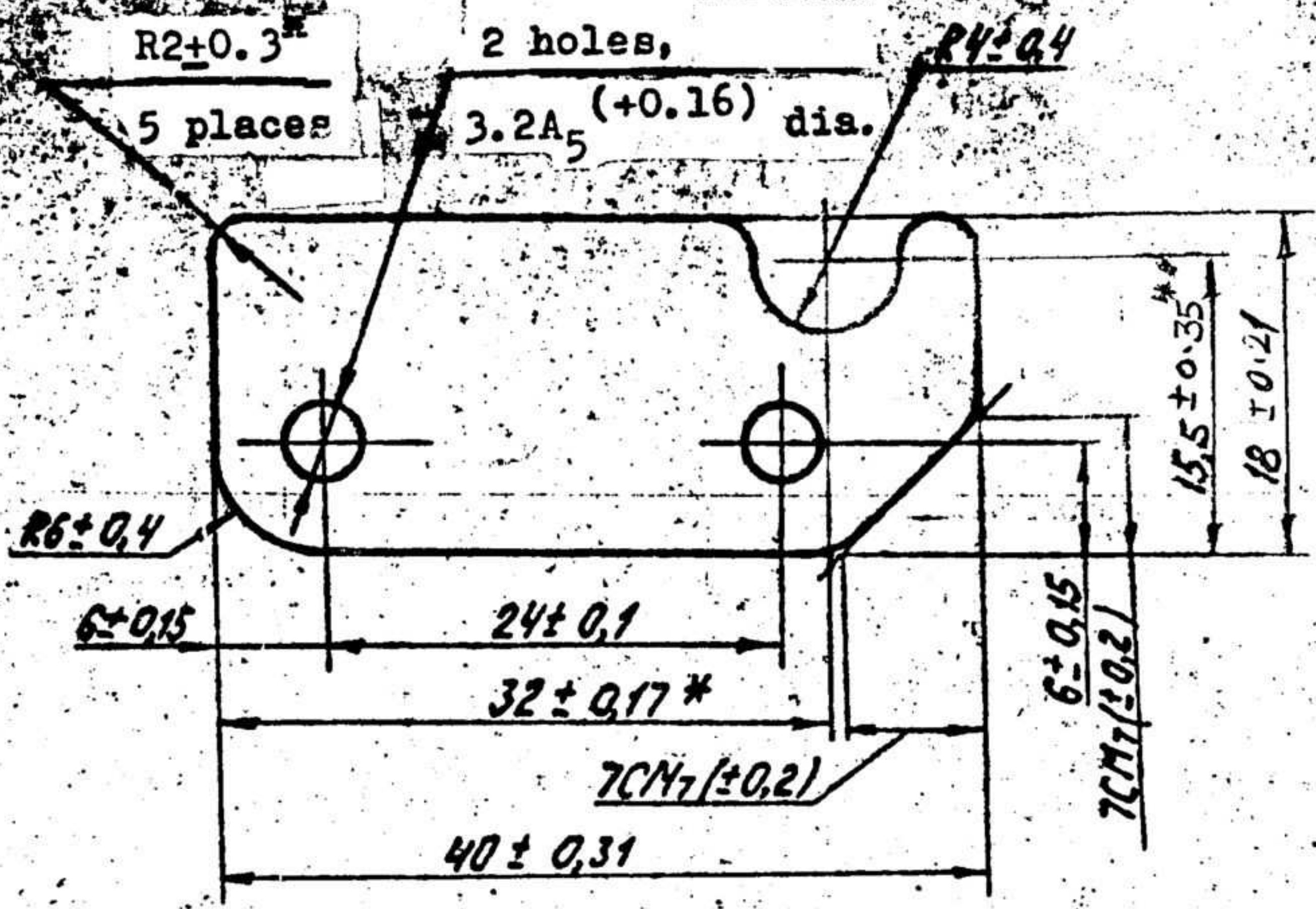
Подпись и дата

№ Инв. №-авт.

Взв.

Подпись и дата

№ док. №



TECHNICAL CONDITIONS

1. Impregnate with varnish ГФ-95 ГОСТ 8018-70.
 2. Local tears of 0.5 mm, max., deep are allowed on the part contour without chipping of surfaces A.
 3. Provide for sizes by appropriate tools which are to be checked at least once quarterly.
 4. Size for reference.
- REFER TO DRG No ЭД.25.003 FOR EXPLANATORY NOTES

SURFACE FINISH

REPRESENTS THE REMOVAL OF MATERIAL IS NOT PERMITTED ON BOTH SIDES OF THE JOB.

Jeenu
(R VEERARAGHAVAN)
SSO-II

51/02073

APPROVED	<i>MVABU</i>
CHECKED	<i>H. Balachandran</i>
CONTROLLERATE OF INSPECTION	

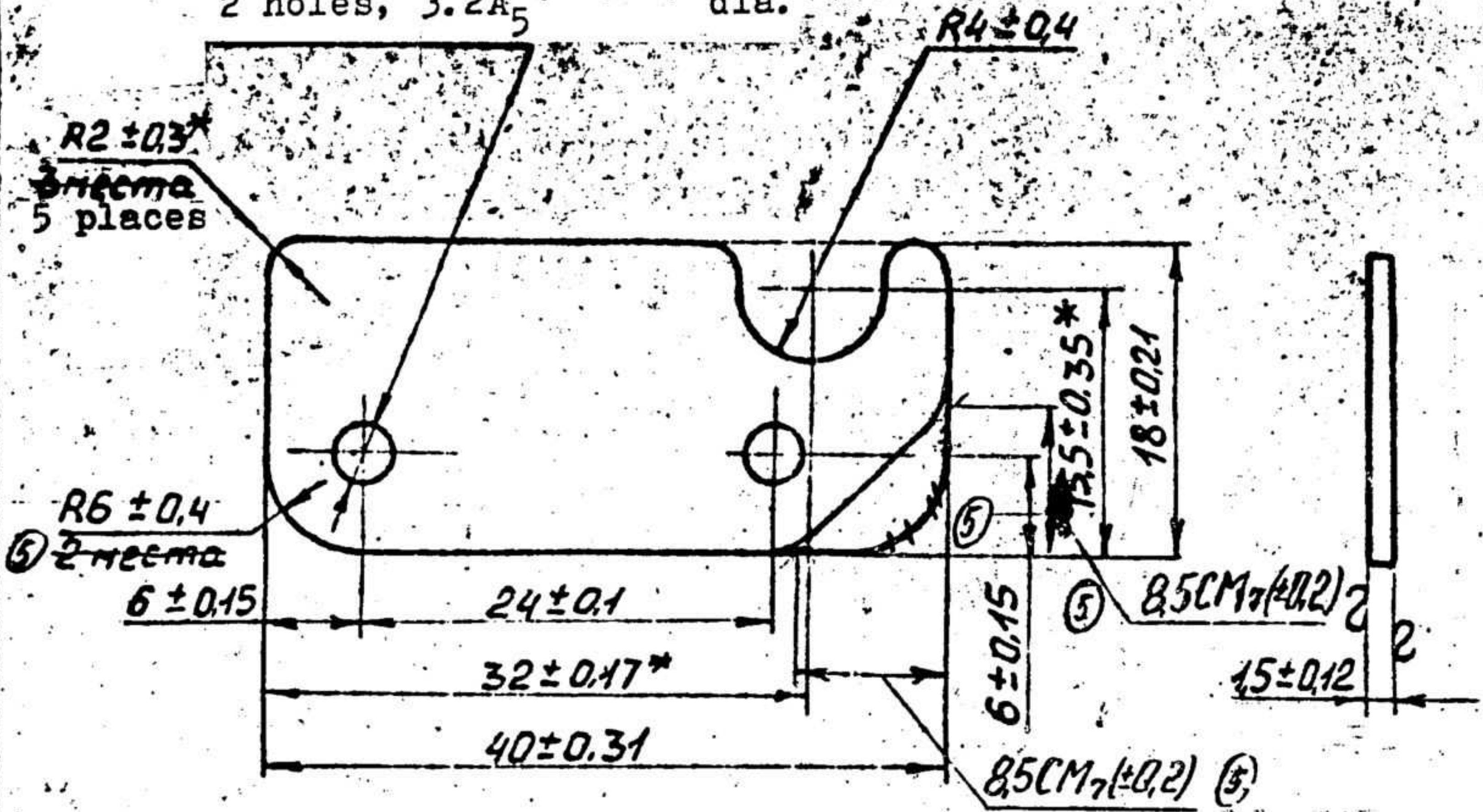
ЭД 25.006	
GASKET	
WEIGHT	SCALE
0.028	2:1
SHT	SHTS 1
GLASS-CLOTH-BASE LAMINATE CT-I-1.5, ГОСТ 12652-74	

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LOOSE

▽3 (▽)

2 holes, 3.2A₅ (+0.16) dia.



REFER TO DRG No 3A 25.005 FOR EXPLANATORY NOTES

SURFACE FINISH

$\sqrt{15}$ - REPRESENTS SURFACE FINISH TO BE OBTAINED IN Ra VALUE 80 μ MAX; ON BOTH SIDE OF THE JOB

$\sqrt{3}(\nabla)$ - REPRESENTS SURFACE FINISH TO BE OBTAINED IN Ra VALUE 20 μ MAX ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.

TECHNICAL CONDITIONS

(Signature)
(R VEERARAGHAVAN)
550II

1. Coating: zinc plating 15 followed by chromate treatment.
2. Provide for size by appropriate tools which are to be checked at least once quarterly.

Восстановлен с подлинника.

3A25.050C6

52102073

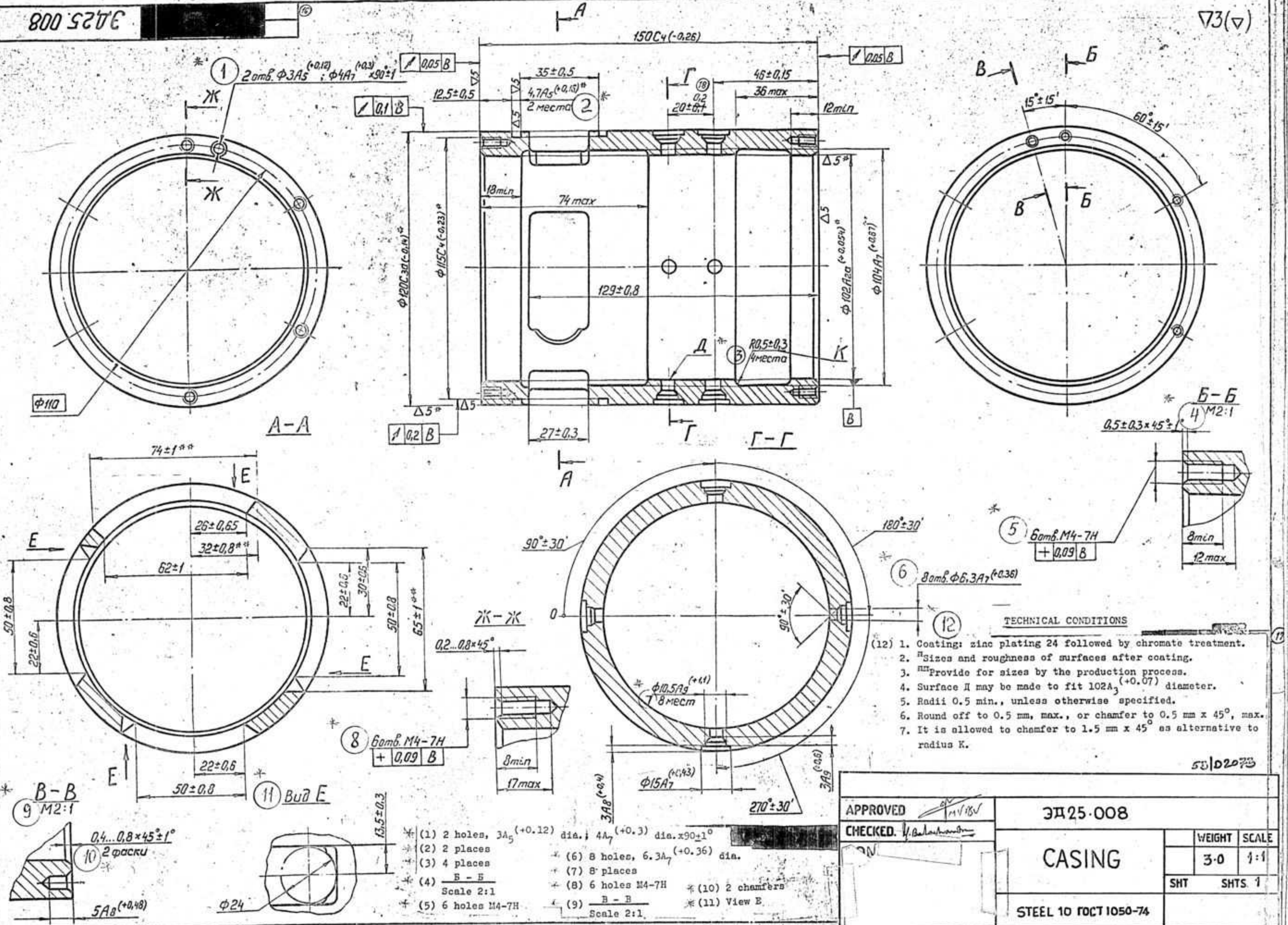
APPROVED *(Signature)*
 CHECKED *(Signature)*
 CONTROLLERATE
 OF
 INSPECTION
 FE (ICV) PUNE

3A 25.007
 GASKET
 SHEET Б 1.5 ГОСТ 19904-74
 4-II-10 ГОСТ 16523-70

	WEIGHT	SCALE
	0.008	2:1
SHT	SHTS 1	
1-4-4		

800.527E

73(▽)



- TECHNICAL CONDITIONS**
- Coating: zinc plating 24 followed by chromate treatment.
 - Sizes and roughness of surfaces after coating.
 - Provide for sizes by the production process.
 - Surface II may be made to fit 102A₃ (+0.07) diameter.
 - Radii 0.5 min., unless otherwise specified.
 - Round off to 0.5 mm, max., or chamfer to 0.5 mm x 45°, max.
 - It is allowed to chamfer to 1.5 mm x 45° as alternative to radius R.

APPROVED	ЭД25.008	WEIGHT	SCALE
CHECKED	CASING	3.0	1:1
		SHT	SHTS. 1
STEEL 10 ГОСТ 1050-74			

800.527E

EXPLANATORY NOTES TO TECH CONDITIONS

"REFER TO DRG No ЭД 20.011 FOR EXPLANATORY NOTES
STEEL 10, GOST - 1050-74"

SYMBOLS

- $\sqrt{0.05} B$:- REPRESENTS RUN OUT OF INDICATED DIMENSION TO BE WITHIN 0.05 mm WITH REFERENCE TO BASE INDICATED AS 'B'
- $\sqrt{0.1} B$:- REPRESENTS RUNOUT OF INDICATED DIMENSION TO BE WITHIN 0.1 mm WITH REFERENCE TO BASE INDICATED AS 'B'
- $\sqrt{0.2} B$:- REPRESENTS RUNOUT OF INDICATED DIMENSION TO BE WITHIN 0.2 mm WITH REFERENCE TO BASE INDICATED AS 'B'
- $+0.09 B$:- POSITIONAL TOLERANCE OF HOLE M4-7H IS 0.09mm FROM BASE 'B'

SURFACE FINISH

- $\nabla 5$:- REPRESENTS SURFACE FINISH TO BE OBTAINED IN Ra VALUE 5µ max
- $\nabla 3(\nabla)$:- REPRESENTS SURFACE FINISH TO BE OBTAINED IN Ra VALUE 20µ max ON THOSE SURFACES WHERE SURFACE FINISH IS NOT SPECIFIED.

SYMBOL

- $\phi 110$:- ON THE DIMENSION $\phi 110$ TOLERANCE IS NOT SPECIFIED BUT IT IS NOT A "FREE DIMENSION"

DCU	DATE	ZONE	BRIEF RECORD	SIGN
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INSCRIBED	DRG NOT TO BE SCALED	PERTAINS TO
CHECKED	ALL SHARP EDGES & CORNERS TO BE ROUNDED OFF	
APPROVED	ALL DIMENSIONS ARE IN mm UNLESS OTHERWISE SPECIFIED	ЭД25.008
DATE	CASING	
TOLERANCE UNLESS OTHERWISE SPECIFIED	SCALE 1:-	CONTROLLERATE OF INSPECTION FIRE FIGHTING EQPT, PUNE
GEN DEC ANG		

Восстановлен с подлинника №1. Перв. прамен. 3А 25.020СБ
 Подп. и дата (подп.) 10.4.72
 13.533

