SIZE	ZONE	REF. No	PART №	NOMENCLATURE	Qty	REMARKS
				DOCUMENTS		
22			A45.935.057C6	ASSEMBLY DRAWING	1	
				ASSEMBLY UNITS		
11		1	(HW) A45.944 016(5620-000114)	GLASS ~~HEATING~~ SHEET	2	
				COMPONENTS		
22		3	A47 200.040	PRISM	1	
11		4	A47.842.052	ADHESIVE FILM	2	
		5	-01+	ADHESIVE FILM	4	
12		6	A48.640.066	PLATE	2	
11		7	A48.683.087	GASKET	1	
11		8	A48.683.234 -01+	GASKET	10	SELECTION
		9	-02+	GASKET	10	SELECTION
		10	-03+	GASKET	10	SELECTION
		11	-04	GASKET	10	SELECTION
		12	-05+	GASKET	10	SELECTION
						17-2

D.C.(1):-1232-I(P), 1392-I(P), 1462-I(P), 5423-I(P)

88

D C(1):-5423-I PT LIST SEALED	5.10.90	
(a) D.C.(1):-1462-I(P) PLATE-WAS SHEET.	10.7.90	CAT/PART No 6650-001011 Qty 41
(b) D C (1)-1392-I(P) NOMS AMENDED & CAT/PT.Nos ADDED	7.2.90	up dated up to 21/57 & 59 DO(OL-F)
(c) D.C.(1):-1232-I(P) PART LIST PROV. SEALED	1.12.87	A45.935.057

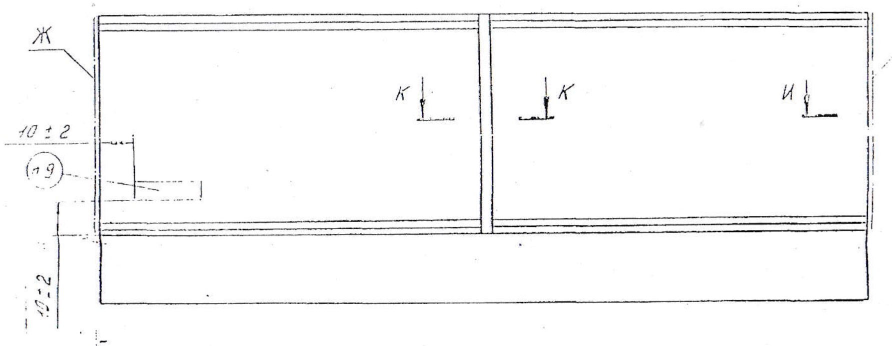
Alt	Sheet No	No. OF DOCUMENT	SIGNATURE	DATE
DESIGNER				
CHECKED BY				16/3/87
QUALITY CONTROL & PARTS KIT				
INSPECTOR				
APPROVED				21/3/87

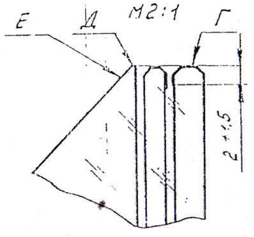
PRISM ASSEMBLY
~~HEATING PRISM~~
OPTICAL INSTRUMENT

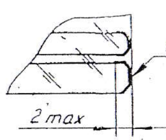
LETTER	SHEET	No OF SHEET
	1	1

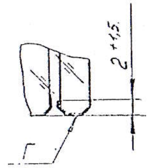
HEAVY VEHICLES FACTORY
AVADI

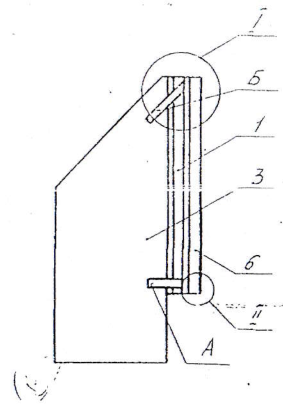
ORIGINAL FACTOR | SIGNATURE AND DATE | INITIATED | SIGNATURE AND DATE

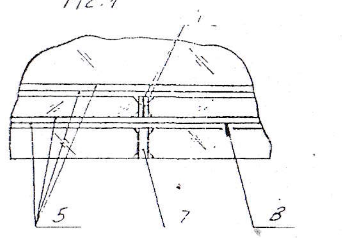












1. RESISTANCE OF CURRENT CONDUCTING COATING (18 9-1 5) OHM. SHOULD . BE MEASURED BETWEEN THE TERMINALS OF BUS BAR A.B
2. INSULATION RESISTANCE BETWEEN CURRENT CONDUCTING AND VARNISH COATED PRISM AT LEAST 100 MEGHAOHM.
3. PLATE POS.1 SHOULD BE CEMENTED ON PRISM 3 HAVING CURRENT CONDUCTING COATING ON OUTERSIDE AND NON-PROTECTING SUB COATING ON END FACES TO EACH OTHER
4. PROJECTION OF PLATE/ STRIP OUT OF THE SURFACE SHOULD NOT BE MORE THEN 2 m.m. AND SINKING SHOULD NOT BE MORE THAN 0.5 m.m. PROJECTION OF STRIPS BEYOND THE SURFACE Ж IS NOT ALLOWED.
5. AFTER PRESSING RESULTANT FILM SHOULD BE CUT TO ALONG THE PROFILE OF PLATE AND PRISM LAYER OF FILM ON SURFACES Д Е Г AND Ж HAVING THICKNESS NOT MORE THAN 0.5 m.m. SO THAT ON SURFACE Е THE TOTAL AREA SHOULD NOT BE MORE THAN 10 / cm².
6. END FACE Г OF PLATES ITEM 6 SHOULD BE COATED WITH LIQUID UNDER COAT OF ПС-4-ТУ6-05-041-305-83
7. LOCAL PROJECTION OF UNDER COAT 7.4 BEHIND THE ELECTRODES ON THE LIGHT ZONE OF PRISM SHOULD NOT BE MORE THAN 1 m m.
8. PLATE NO 6: SHOULD NOT BREAK OUT BY THE IMPACT OF STEEL BALL WEIGHING 55± 1GR FALLING FREELY FROM A HEIGHT OF 170±1 CM TWO PLATES FROM THE TOUGHENED LOT ARE CHECK CEMENTED ON PRISM. FOR TESTING PRISMS WITH DEVIATIONS WHICH DOES NOT EFFECT THE RESULT MAY BE USED.
9. TECHNOLOGICAL MARKING IS MADE ON SURFACE B WITH BLACK INK ТУ-6-15-458-76
10. REMAINING TECHNICAL REQUIREMENT AS PER ТУ3-3-834-78

~~9. Технологическую маркировку~~ наносить на поверхность В тушью черной ТУ6-15-458-76.
10. Остальные технические требования по ТУ3-3.834-78.

D.C(I):-1232-I(P), 1392-I(P), 1462-I(P), 5423-I

SIG	DATE	AMENDMENTS
	5.10.90	D.C(I):-5423-I. DRG. SEALED.
	10.7.90	D.C(I):-1462-I(P). UPDATED DRG. PROV. SEALED IN SUPERSESSION OF EXISTING ONE.

18		АЦ8.56-86			
17	Зам	АЦ.686-83		21.1.83	
Изм	Кол.	№ докум.	подп.	дата	
Разраб.		Протасов			
Пров.		Удачин			
Т.контр.		Трещева			
Н.контр.		Сенчукова			

CAT/PT. NO. 6650-001011

GROUP No. 41315 KD

FOLDER/SHEET No. 39/29

DRG. No. AU5.935.057 CБ

PRISM ASSEMBLY
OPTICAL INSTRUMENT

SHEET	WEIGHT	SCALE
	1.738	1:1

MATERIAL

OPTO. ELECTRONICS FACTORY DEHRADUN

87

SIZE	ZONE	REF.†	PART Nº	NOMENCLATURE	Qty	REMARKS
				DOCUMENTS		
13			A45 944. 016 C6	ASSEMBLY DRAWING		
				COMPONENTS		
11		1	A47 755. 033	TIE	2	
12		2	A48. 640. 065	PLATE	1	
						14-1

D.C.(1)-1232-I(P), 1392-I(P), 1462-I(P), 5423-I

ORIGINATING INSPECTORY | SIGNATURE AND DATE | FIRST ISSUE/REVISION No. | CONTRACT/SPECIFICATION No. | SIGNATURE AND DATE

D C(1)-5423-I PT LIST SEALED.		5.10.90	
(B) D.C.(1):-1462-I(P) PLATE WAS SHEET.		10.7.90	
(a) D C (1)-1392-I(P). NOM AMENDED & CAT/PT No ADDED		7.2.90	
J.	D.C.(1):-1232-I(P) PART LIST PROV. SEALED	C6	1.12.87
A/I	Sheet No.	No. OF DOCUMENT	SIGNATURE / DATE
DESIGNER			
CHECKED BY			16/2/87
CHIEF OF DEPARTMENT			
INSPECTOR			
APPROVED			21/3/87

CAT/PAT No (a) 5620-000114

4135

up dated up to 31/5/89 00 (O.L.F)

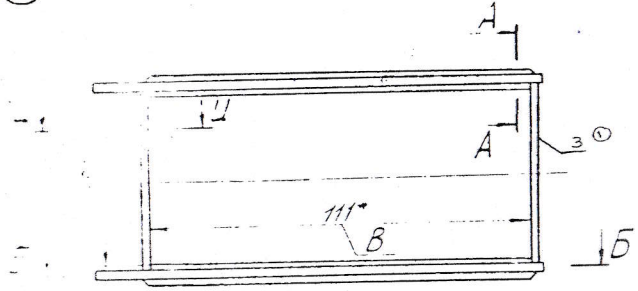
A45. 944. 016

GLASS SHEET

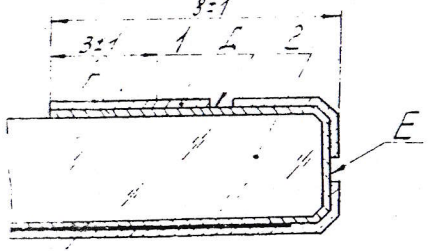
LETTER	SHEET	No. OF SHEET
	1	1

HEAVY VEHICLES FACTORY
AVADI

(2)

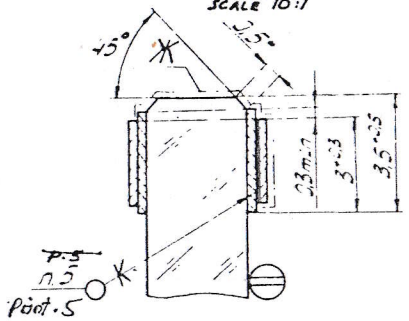


Б-Б
М 1:1
SCALE 10:1



SILICATE-SILVER ELECTRODE
Силикатно-серебряный

Г-Г
М 1:1
SCALE 10:1



1. ① Conducting coating should be made of semiconductor dioxide of tin with the addition of fluorine.
2. Silicate-silver electrodes should be applied over conducto coating along it full length, over face "Б" and surface "Д" Thickness of electrodes should be 0.[illegible] .[illegible]
3. Sheet with electrodes should be hardened. Hardening degree should be 0.7 N/cm minimum.
4. Tie 1 on lenght "B" should be glued [illegible] using conducting adhesive with silver filler and on length "B" soldered without using additional solder.
5. Conducting adhesive is not allowed on face "Б" and surface "Д" ТУ6-05-041-805-83 ①
6. Liquid sublayer ПС-4 ~~ТУ6-05-1163-75~~ should be applied on surface "Ж", and on face "К".
7. Conducting coating resistance should ensure the fulfillment of point 1 of АЦ 5.935.057сб.
8. *Dimensions for reference.
9. Rest of the technical requirements [illegible] as per ТУ6-8.031-~~73~~ ④ 78
10. ① The Presence of current conducting coating on ~~surface~~ surface 3 is allowed.

up dated up to 31/5/89 DO(O.L.F)

D.C.(1):-1232-1(P),1392-1(P), 5423-1

			CAT/PART No. (a) 5620-000114	A1315 ND	AL-1
	5.10.90	D.C(1):-5423J.			
	7.2.90	(a)D.C.(1):-1392-1(P) NOM. AMENDED & CAT/PT. No ADDED.	AL5.944.016 LD		
M	1.12.87	D.C.(1):-1232-1(P) DRG. PROV. SEALED.	GLASS SHEET (a)	SHEET	MASS
1	23 [illegible]	AL4.682 - [illegible]	ASSEMBLY DRAWING	1 of 1	0.048
ISSUE	DATE	REFERENCE			
APPROVED			MATERIAL:	HEAVY VEHICLES FACTORY AVADI	
CHECKED					
DRAWN					

(4)

(12)

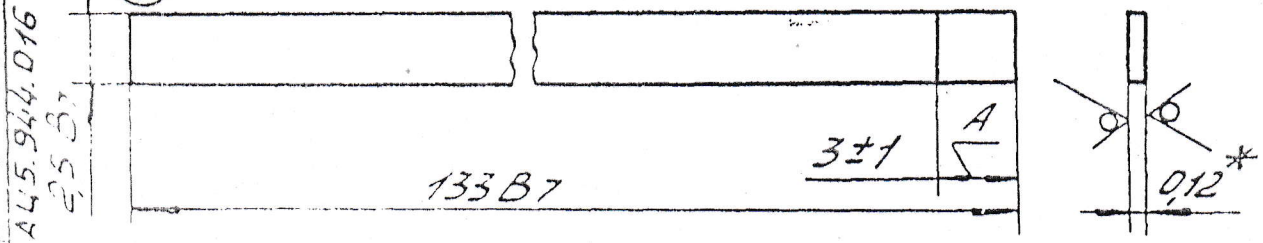
(85)

~~AU7.755.033~~ (L)

R280 (V)

(84)

(A1.1/46)



1. Heat treatment: Vacuum annealing.
   Annealing should be checked as per Gost 1173-77 through two test pieces of dimension 20 X 60 mm from each batch
2. Deformation and burrs are not allowed.
3. The tie should be pickled.
   The thickness of the pickled tie should be 0.09 mm min.
4. After pickling surface "A" should tined with solder ПР2 ПОС 61 Gost 21931. Thickness of soldering layer is to 0.05 mm.
5. Local darkenings and temper colours are not allowed.
6. *Dimension for reference.

(A) ALT. EQUVT. MATL. : IS: 1897-2008 (GRADE Cu-ETP OR Cu-FRHC) AS PER IS: 191-07 FOR CHEMICAL. up dated up to 31/5/89 DO (O.M.F)

ISSUE	DATE	REFERENCE
(A)	05.08.16	D.C:- 7127-I ALT. EQUVT. MATL. ADDED
	5.10.90	D.C(I):-5423-I DRG. SEALED.
13	1.12.87	D.C.(I):-1232-I(P). DRG. PROV. SEALED.

APPROVED		21/3/85
CHECKED		21/3/85
DRAWN		5/3/85

AU7.755.033 16B

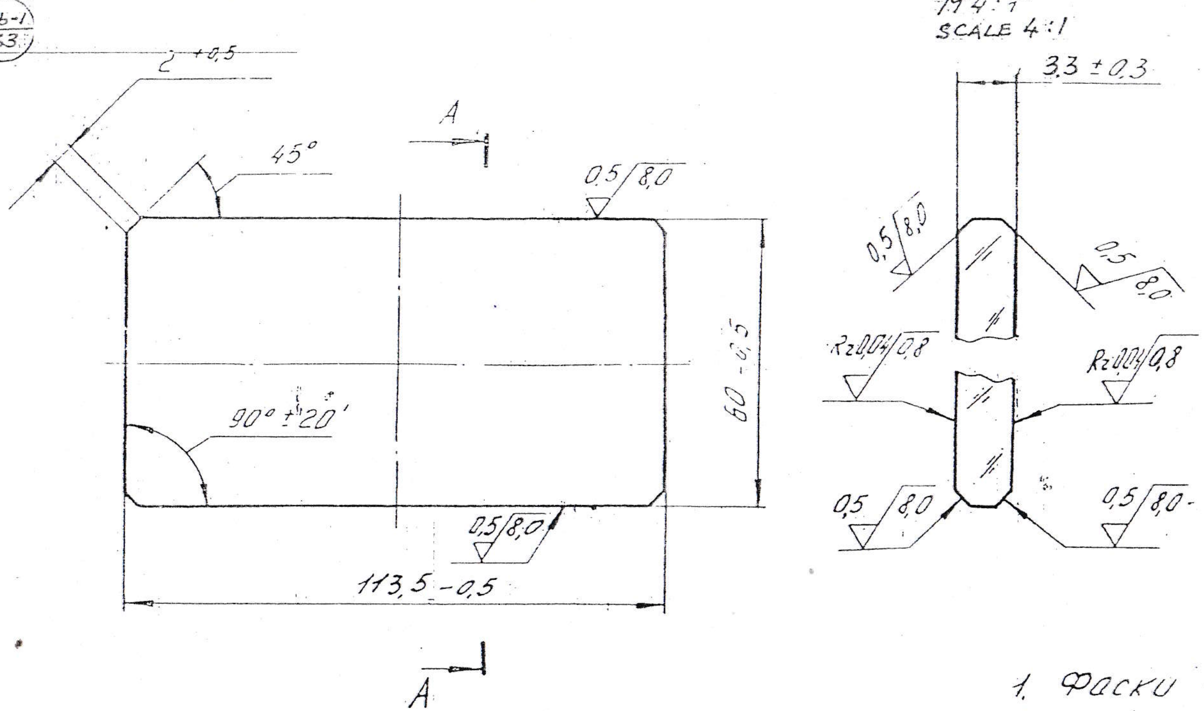
TIE

SHEET	MASS	SCALE
1 of 1	0.0003	4:1

MATERIAL: COPPER STRIP MIT-HT GOST 1173-77

HEAVY VEHICLES FACTORY (T) AVADI

D.C.(I):-1232-I(P), 5423-I, 7127-I



Δ ne	5
Δ (nF' - nc')	5
HOMOGENEITY	5
DOUBLE REFRACTION	5
WEAKENING	8
NONSTRIATION	*
BUBBLING	7E
P	VII

1. Фаски на ребрах $0{,}2^{+0{,}3} \times 45°$

2.* бессвильность и остальные ТТ по ТУ 3-3.834-73.

1. CHAMFERS ON EDGES SHOULD BE $0{\cdot}2^{+0{\cdot}3} \times 45°$

2. *NONSTRIATION AND REST OF THE TECHNICAL REQUIREMENTS ARE AS PER ТУ3-3.834.78. (A)

A-1

up dated up to 31/5/89 DD(O.L.F)

ISSUE	DATE	REFERENCE
	5.10.90	D.C(I):-5423-I. DRG. SEALED.
	10.7.90	(A) D.C.(I):-1462-I(P) NOM. MATL. & SPECK. FOR NOTE No.2 AMENDED.
	1.12.87	D.C.(I):-1232-I(P). DRG. PROV. SEALED

APPROVED		21/3/85
CHECKED		16/3/85
DRAWN		4/3/85

АЦ8.640.065

PLATE (A)

SHEET	MASS	SCALE
1 of 1	0.048	1:1

MATERIAL: GLASS ЛК 105 GOST 3514-76E (A)

HEAVY VEHICLES FACTORY AVADI (D)

D.C.(I):-1232-I(P), 1462-I(P), 5423-I

ТНПО-1688-033А АЦ5.944.016

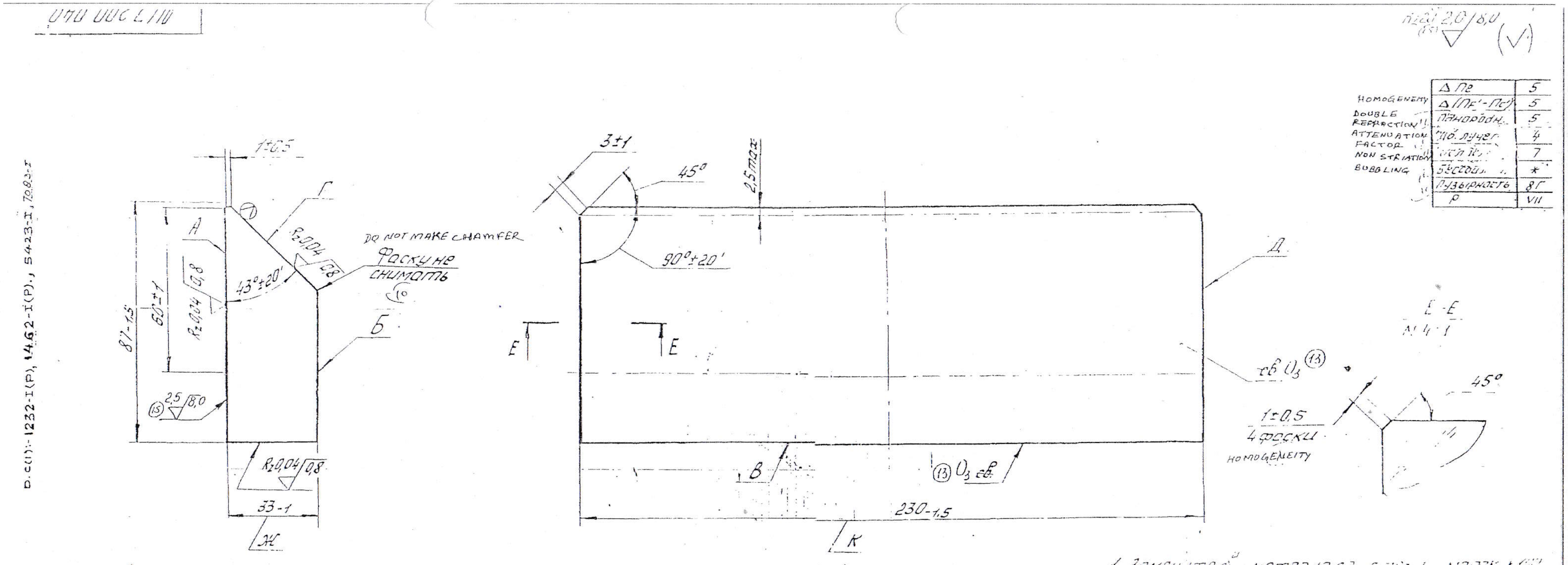
A16-1/63

1763

6

83

070 006 L110



1. ALTERNATE MATERIAL - GLASS K-100 GOST 3514-76E AND БК-104 GOST 3514-76E. K 110 GOST. 3-28-77
2. ANGLE BETWEEN THE SURFACES Д AND А Д AND Б Д AND В Д AND Г SHOULD BE EQUAL TO 90° 20'.
3. CHAMFERS AT EDGES 1+1X45° EXCEPT THE PLACES INDICATED. SPECIAL CHAMFER AT ANGLE 2+1X45°
4. TAPER ON DIMENSION Ж AND K WITHIN 1/2 LIMIT OF TOLERANCE FOR DIMENSIONS.
5. WORKING ZONES ON SURFACES А,В,Г ARE LIMITED BY CHAMFERS AND SPECIFICAL DIMENSION.
6. 25Р3Е·72 II·72·II AS PER O.S.T. 73-1901-85.
7. SILVER COATING AND ON DULL SURFACES - BAKALITE VARNISH ЛБС GRADE I AS PER GOST 901-78 WITH FILLER INDUSTRIAL CARBON GRADE П 803 GOST 7885-77E AND TALC ТРПН GOST 19729-74, THERE AFTER BAKALITE VARNISH ЛБС-1 GRADE-1 WITH FILLER: TITANIUM DIOXIDE AS PER GOST 9808-84 AND TALC.
8. INSULATION RESISTANCE OF VARNISH COATING IN RELATION TO COPPER LAYER SHOULD NOT BE LESS THAN 20 MEGHA OHM.
9. NON STRIATION AND OTHER REQUIREMENT AS TY-3-834-78.

6. ⦸ -~~зеркальн.~~ 25Р.3Е.72П. по ОСТ3-1901-78 85 (16)
7. Покрытие серебряной и матовой поверхностей - лак бакелитовый ЛБС-1 сорт 1 по ГОСТ 901-78 с наполнителями: углеродом техническим марки ~~ДМ-15~~ П803 ГОСТ 7885-77Е и тальком ТРПН ГОСТ 19729-74, затем - лак бакелитовый ЛБС-1 сорт 1 с наполнителями: двуокисью титана по ГОСТ 9808-84 (16) и тальком.
8. Сопротивление изоляции лакового покрытия относительно слоя меди не менее ... МОм
9.* Бессвильность и остальные технические требования по ТУ3-3.834-78.

1. Заменитель материала [illegible] ГОСТ 3514-76Е и БК 104 ГОСТ 3514-76Е [illegible] 28-77
2. Угол между поверхностями Д и А, Д и Б, Д и В, Д и Г равен 90°±20'.
3. Фаски на ребрах 1+1x45°, кроме мест указанных особо. Фаски на углах 2+1x45°
4. Клиновидность по размерам Ж и К в пределах половины допуска на [illegible].
5. Рабочая зона на поверхностях А, В, Г ограничивается фасками и заданными размерами.

(9) 3.6.4	D.C. 7083-I ALT. EQUL MATL. ADDED.				
5.10.90	D.C(I):- 5423-I. DRG. SEALED				
10.7.90	D.C(I):-1462-I(P). UPDATED DRG. PROV. SEALED IN SUPER SESSION OF EXISTING ONE.				
DATE	AMENDMENTS				

16		АЦ856-86		
15		АЦ450-84		
14	1	АЦ764-83		
13	4	АЦ288-83		
12	2	АЦ465-82	Подп.	
Изм	Лист	№ докум.	Подп.	Дата
Разраб.	Колмыкова		Подп.	Дата
Пров.	Шашкина		Подп.	Дата
Т.контр.	Заровнятных		Подп.	Дата
Н.контр.			Подп.	Дата

GROUP No. 41315 KD — FOLDER/SHEET No 31/32

DRG. No. AC 7.200.040

PRISM

ALTERNATE EQUIVALENT MATL. OPTICAL GLASS, BSC-7 (517642) (RADIATION RESISTANT), GRADE A & TO IS: 1400-1960 RE-AFFIRMED 1996, ABSORPTION LESS THAN 1%.

GLASS K 108

MATERIAL GOST 3514-76E

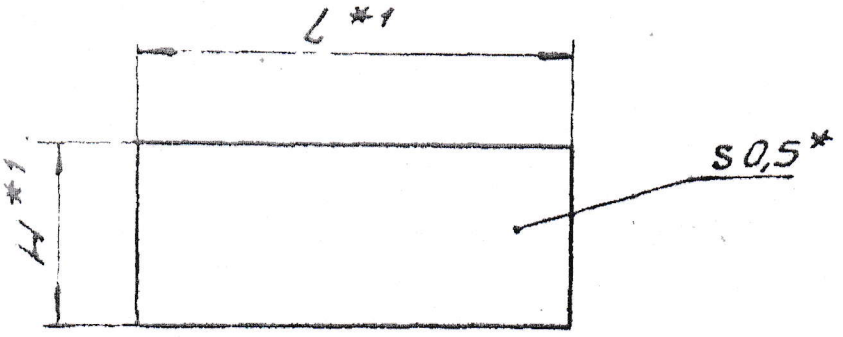
SHEET	WEIGHT	SCALE
	1.326	1:1

OPTO ELECTRONICS FACTORY DEHRADUN

82

АЦ7.842.052

А16-1
50



PART NO. Обозначение	DIMENSIONS, Размеры, мм		MASS Масса, кг*
	L	H	
АЦ7.842.052	60 C5	3 C5	0,00011
-01	227,2-0,2	59,6-0,1	0,008
-02	239,2-0,2	64,1-0,1	0,009

1. *DIMENSION FOR REFERENCE
2. *1 SHOULD BE ENSURED BY TOOL.

1. * Размер для справок.
2. *1 Обеспеч. инстр.

op dated up to 31/5/89 DO(D.L.P.)

ISSUE	DATE	REFERENCE
	5.10.90	D C(1)-5423-I. DRG. SEALED.
	10.7.90	(A) D.C.(1):-1462-I(P) MATL. AMENDED
	1-12-87	D.C.(1):-1232-I(P). DRG. PROV. SEALED

APPROVED		21/3/85
CHECKED		16/4/85
DRAWN		5/3/85

АЦ7.842.052.

ADHESIVE FILM

SHEET	MASS	SCALE
1 of 1	SEE TABLE	-

MATERIAL: TAPE A-17, Q·5 × 1000 GOST 9438-85

(A) HEAVY VEHICLES FACTORY AVADI (31)

Перв. примен. АЦ5.935.057

Справочный № ТИПО-1688-035А

D.C.(1):-1232-I(P), 1A.62-I(P), 5423-I; 5040-95

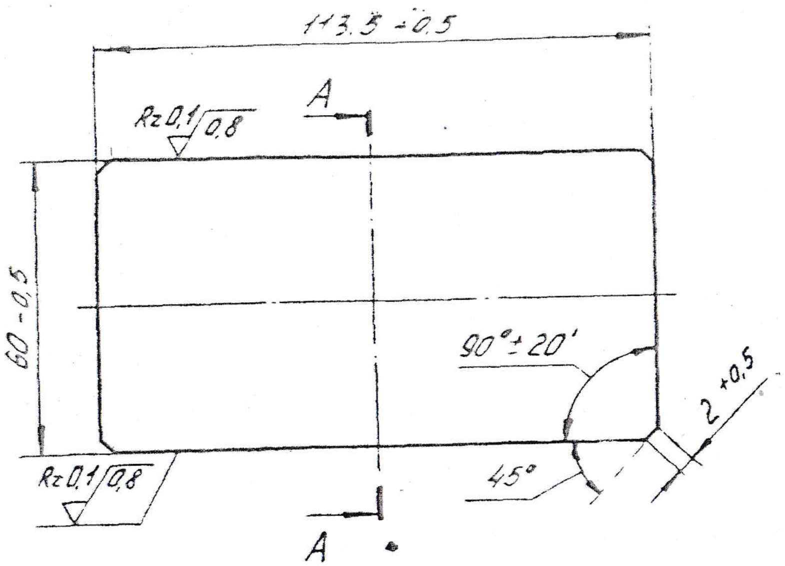
Восстановленный подлинник

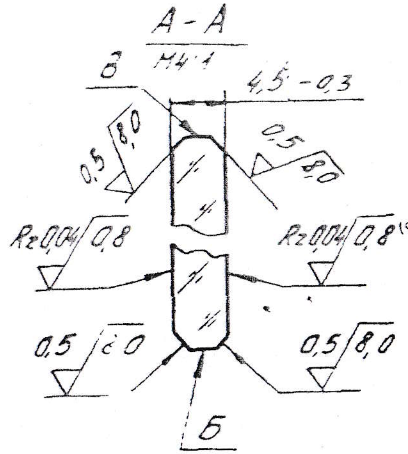
-48-

АЦ8.640.066

D.C (I):-1232-I(P), 1462-I(P), 5423-I; ТНПО-1688-034 | АЦ5.935.057

7083-I,





2,0/8,0 (✓)

Δпе	5
Δ(пF'-пс')	5
HOMOGENEITY Однородн	5
DOUBLE REFRACTION ДВ. лучепр	5
ATTENUATION FACTOR Ослабление	7
NON STRIATION Бессвилн	*
BUBBLING Пузырность	8Г
P	VH
θ	4

(a) DC: 7083-I ALT. EQUL. MATL. ADDED

~~кается не более 6'.~~

~~6 По длинным сторонам допускаются~~

7. TAP-ERNESS SHOULD BE CONTROLLED ACCORDING TO THE DIFFERENCE OF THICKNESS ON DIMENSION 113·5 SHOULD NOT BE MORE THEN 0·12 mm, ON DIMENSION 60, IT SHOULD NOT BE MORE THAN 0·06 mm.

~~6. На поверхностях Б, В точки и царапины не нормируются.~~

~~7. Допускается контролировать клиновидность по разнотолщинности по размеру 113,5 не более 0,12 мм, по размеру 60 не более 0,06 мм.~~

1. CHAMFER AT EDGES 0.3+0.2 x 45° EXCEPT THE PLACES SPECIALLY SPECIAFIED
2. TOUGHENED THE PLATE, TOUGHENED GRADE SHOULD BE AT LEAST 2-2 N/CM. AT THIS ENSORING COMPLETION ?SBAЦ-5-935-057-СБ.
4. ON LONGER SIDES ... STEEPS FROM CHAMEER ARE ALLOWED UPTO A LENGTH OF 1·5 mm.

5.* NON STRIATION AND OTHER TECHNICAL REQUIREMENTS AS PER ТУ3-3-834-78.

6. THERE SHOULD NOT BE ANY DOTS AND SCRATCHES ON SURFACE Б AND В.

D.C (I):- 5423-I. DRG. SEALED.	5.10.90	
D.C (I):- 1462-I(P): UPDATED ORG. PROV. SEALED IN SUPERSESSION OF EXISTING ONE.	10.7.90	

16	АЦ85-86	2011.86
15	АЦ181-85	28.02.85
14 1	729-82	Подп. Дата
13 3	806-79	Подп. Дата
Изм. Лист	№ докум.	Подп. Дата
Калмыкова	Подп.	Дата
Шашкина	Подп.	Дата
Зеров...	Подп.	Дата
Верждуцкая	Подп.	Дата

GROUP No. 41315 KD — FOLDER/SHEET No. 39/48

DRG. No. АЦ8.640.066

PLATE

SHEET	WEIGHT	SCALE
	0.072	1:1

(a) ALTERNATE EQUIVALENT MALT. OPTICAL GLASS, BSC-7 (517642) (RADIATION RESISTANT), GRADE AQ TO IS: 1400-1960 RE-AFFIRMED 1996, ABSORPTION LESS THAN ...

GLAS K-108

MATERIAL GOST 3514-76E

OPTO ELECTRONICS FACTORY DEHRADUN

17080-71. Подп. 10.11.76

(80)

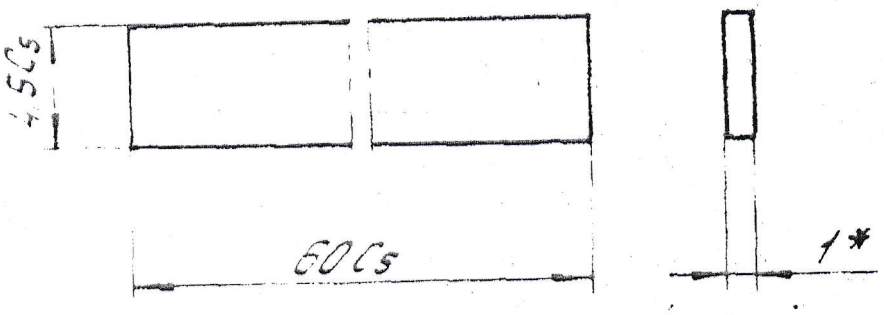
L80 E89 874 -66-

(19)

A16-1
66

A4.5.935.057

D.C.(1):-1232-I(P), 1462-I(P), 5423-I, 5777-I.
TH.TO-168 5-240



1* размер для справок.

2. размеры обеспеч. инстр.

1.* DIMENSION FOR REFERENCE

2. DIMENSIONS TO BE ENSURE BY TOOL

17-I

up dated up to 31/5/89 DO(O.L.F)

ISSUE	DATE	REFERENCE
	12.10.93	(b) D.C:-5777-I. DETAIL OF MATL. AMENDED.
	5.10.90	D.C(1):-5423-I DRG. SEALED.
	10.7.90	(A) D.C.(1):-1462-I MATL. AMENDED.
	1.12.87	D.C.(1):-1232-I(P). DRG. PROV. SEALED

APPROVED		21/3/85
CHECKED		6/3/85
DRAWN		5/3/85

AU8.683.087

GASKET

SHEET	MASS	SCALE
1 of 1	0.00033	4:1

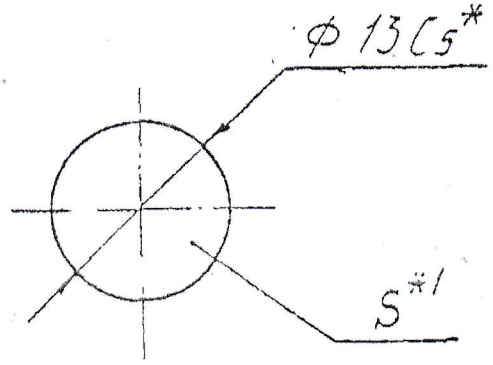
MATERIAL: (4)
SUBSTRACT ПС-4
ТУ6-05-041-83 (6)

HEAVY VEHICLES FACTORY
AVADI

(10)

АЦ8.683.234 -28-

78



(H) CODE Обозначение	(5) S, мм	(6) WEIGHT. KG. Масса, кг
(a) АЦ8.683.234 (VS/RUS/AU8·683·234) -01	0.5	0,000066
	1,0	0,00013
AU8.683.234-02 (RUS/AU8.683.234 -02)	1,5	0,0002
AU8·683.234-03 (RUS/AU8.683.234-03)	2,0	0,00026
AU8.683.234-04 (RUS/AU8.683.234-04)	2,5	0,00033
AU8.683.234-05 (RUS/AU8.683.234-05)	3,0	0,00042

(a) CAT/PT.No. VS/RUS/AU8·683·234

(b)
1.* Размер обеспеч. инстр.
2.*1 Размер для справок.
3. Заменитель материала Пластина 254311 / Резина 1847
ТУ 005216-75

1.* DIMENSION TO BE ENSURED BY TOOL.
2. DIMENSION FOR REFERENCE.
3. ALTERNATE MATERIAL PLATE 254311 / RUBBER 1847 SPECS. 005216-75.

Al/mo3

UPDATED ON 6·3·92. sd/sd wm/pd

~~CAT/PT.No. 5330-015668~~

ISSUE	DATE	REFERENCE
	29.7.02	(a) D.C. 6551-I. CAT/PT.No. AMENDED
	4.9.96	D.C. -6139-I. UPDATED DRG. SEALED IN SUPER SESSION OF EXISTING ONE

GROUP No. 41315 KD FOLDER/SHEET No. 25/20

DRG. No: АЦ8.683.234

GASKET

SHEET	WEIGHT	SCALE
		2:1

APPROVED
CHECKED
DRAWN

MATERIAL PLATE 254311-5 RUBBER 1311
SPECS. 005-16-75

22

ORDNANCE FACTORY PROJECT DEHRADUN

D.C:-1231-I(P), 1393-I(P), 5422-I, 6139-I, 6551-I.

ТИПО-170-021 АЦ5-935-079-080