

1. Unspecified limit deviations of dimensions for holes are as per A5, for shafts as per C5.
2. Coating: FOP. noc-40, GOST 21931-76.
3. Do not machine over diameter D while making the part from bar as per GOST 2060-73.

Size	Designation	Dimensions in mm		Mass Kg.
		D <sub>1</sub>	d	
1	700-42-37	8.5	5.5	0.0006
2	700-42-38	12.5	10.5	0.0009
3	700-42-39	14.5	12.5	0.0017
4	700-42-40	18	15	0.002
5	700-42-41	20	17	0.0023
6	700-42-42	22	19	0.0025
7	700-42-43	25	22	0.0029
8	700-42-44	28	24	0.0042
9	700-42-45	34	30	0.0052

APPROVED

H VASU

CHECKED

W. Pathak

700-42-37/45

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

RING

WEIGHT SCALE

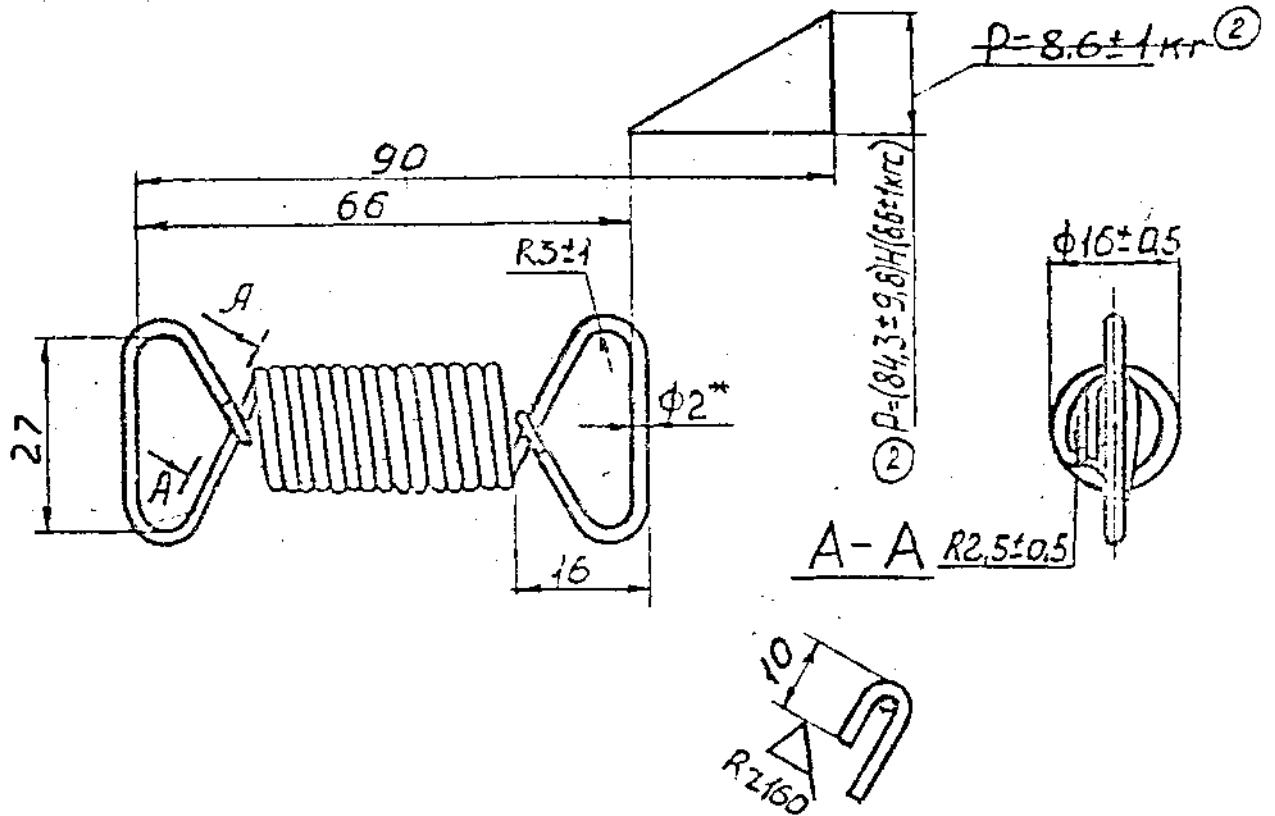
SEE  
TABLE

SHT SHTS

ЖС 59-1 ГОСТ 15527-70

672-38-26

V(V)

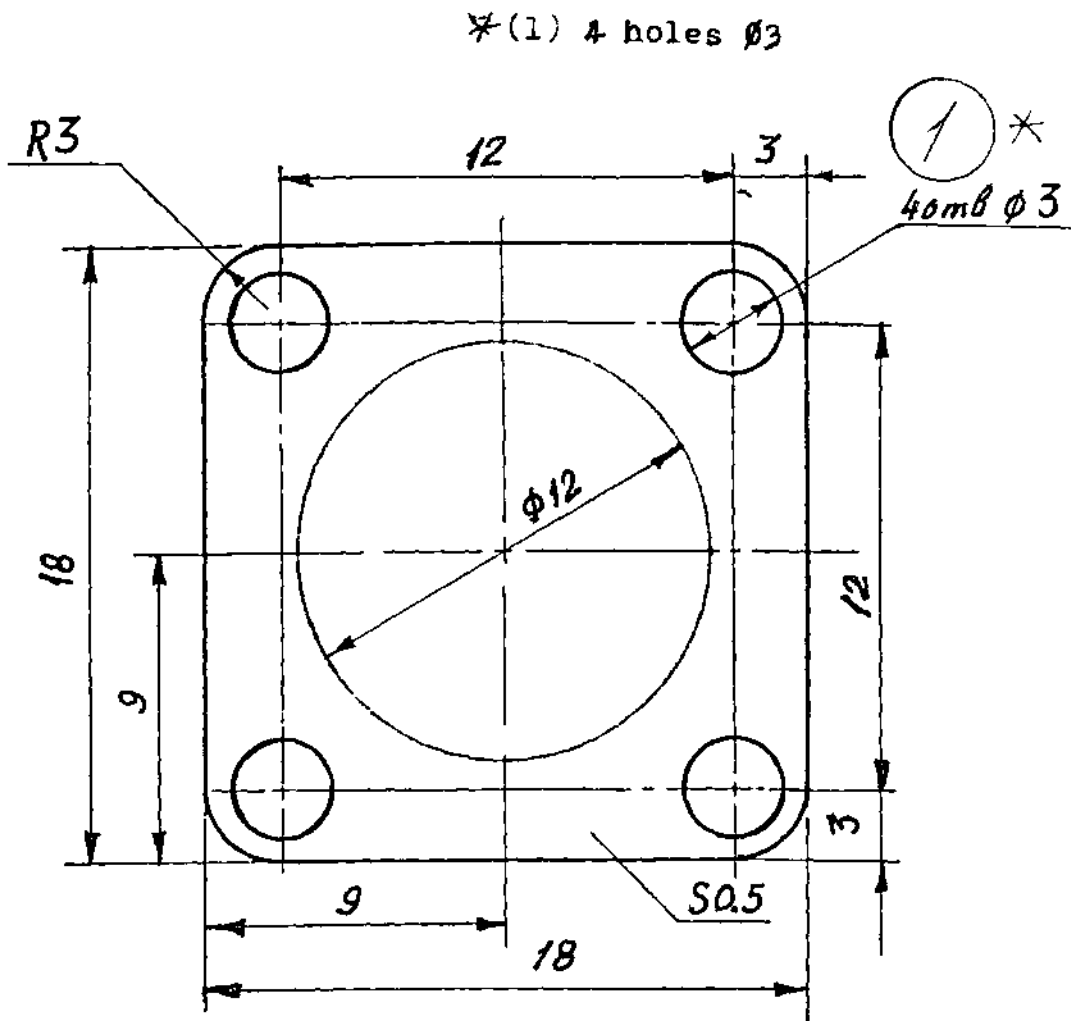


TECH. CONDITIONS

1. Coating: chemically phosphatized Cr pltd impregnated with preservation oil K-17 ГОСТ 10677-76 in compliance with Instructions 053.252.89.00002.
2. Unspecified limit deviations of sizes -  $\pm 2$  mm.
3. Spring full length  $L^{\#}$  = 920 mm, approximately.
4. Number of operating coils  $n$  = 16
5. Direction of coiling - arbitrary.
6. Shift of hook ends relative to spring axis by 2 mm and relative to each other by  $10^{\circ}$  is tolerable.
7. Conic bending of end in cross-section A - A is allowed.
8. It is permitted not to check coating between coils.
9.  $\#$  Sizes are given for reference.

APPROVED	<i>[Signature]</i>	672-38-26	
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF INSPECTION (ICV)	SPRING		WEIGHT SCALE
			0.024 1:1
			SHT I SHTS I
		wire II-2.0 ГОСТ 9389-75	

675-42-42



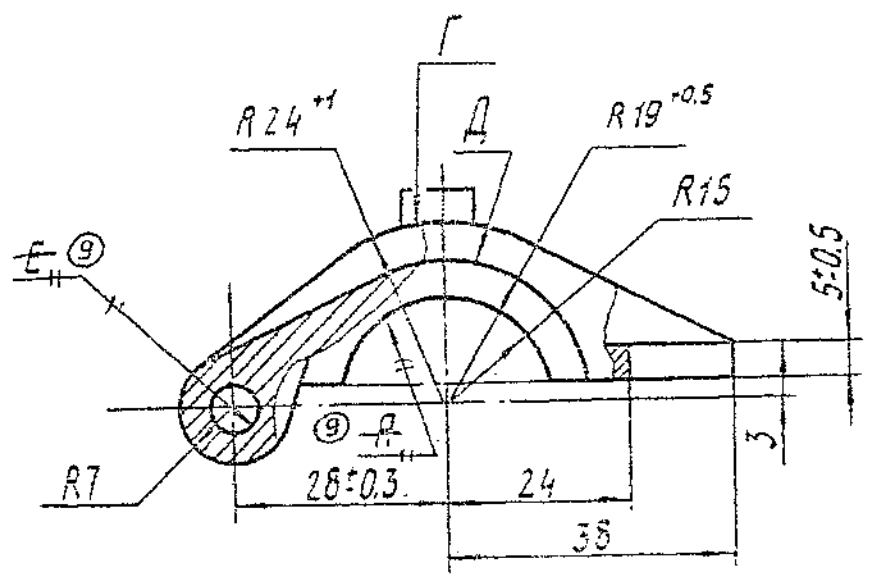
1. Not specified limit deviations of sizes are  $\pm 0.5$  mm.
2. Mutilated edges are permissible.

(A) EQ MATERIAL.-VEGETABLE FIBRE BASE JOINTING MATERIAL TO IS-5566

00802-ICV	(A)	VEGETABLE FIBRE BASE JOINTING MATERIAL TO IS:5566 ADDED AS EQ MATERIAL
18-8-2000		
DC(No. & DATE)	ISSUE	AMENDMENTS

APPROVED		<h1>675-42-42</h1>		
CHECKED				
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>	<h2>GASKET</h2>		WEIGHT	SCALE
			0.0001	5:1
	MATERIAL GASKET CARDBOARD GRADE 'A', GOST 9347-74		SHT	SHTS

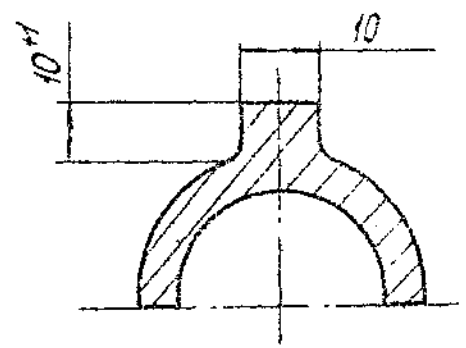
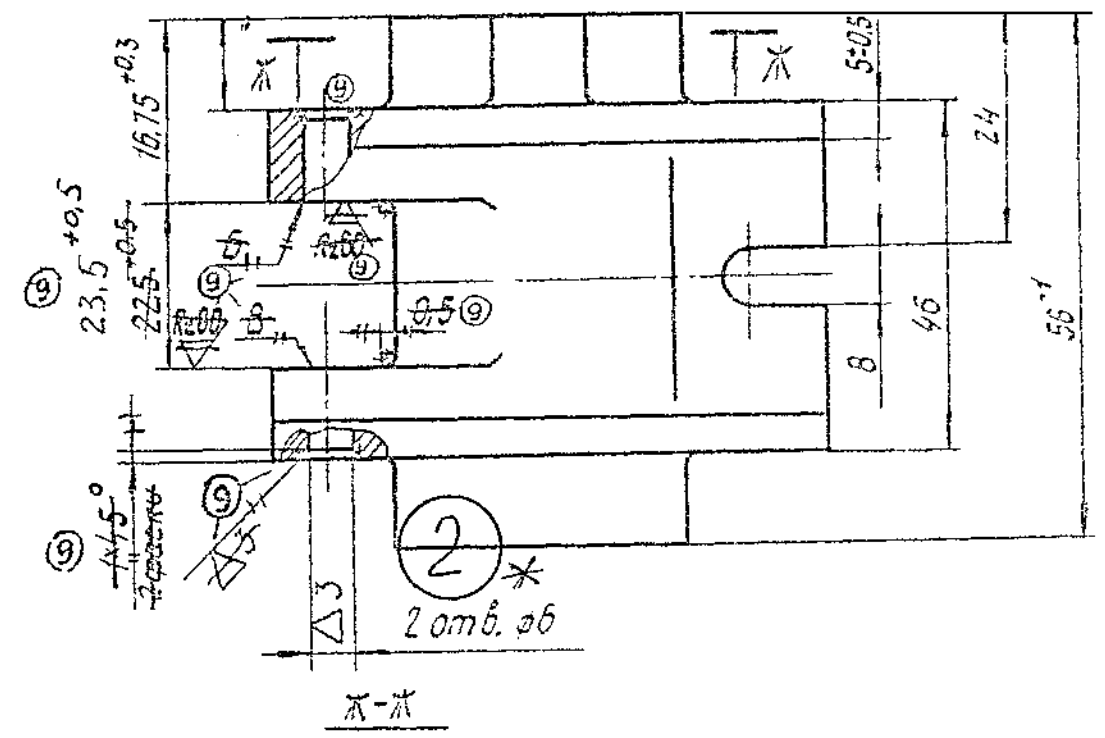
675-42-46



TECH. CONDITIONS

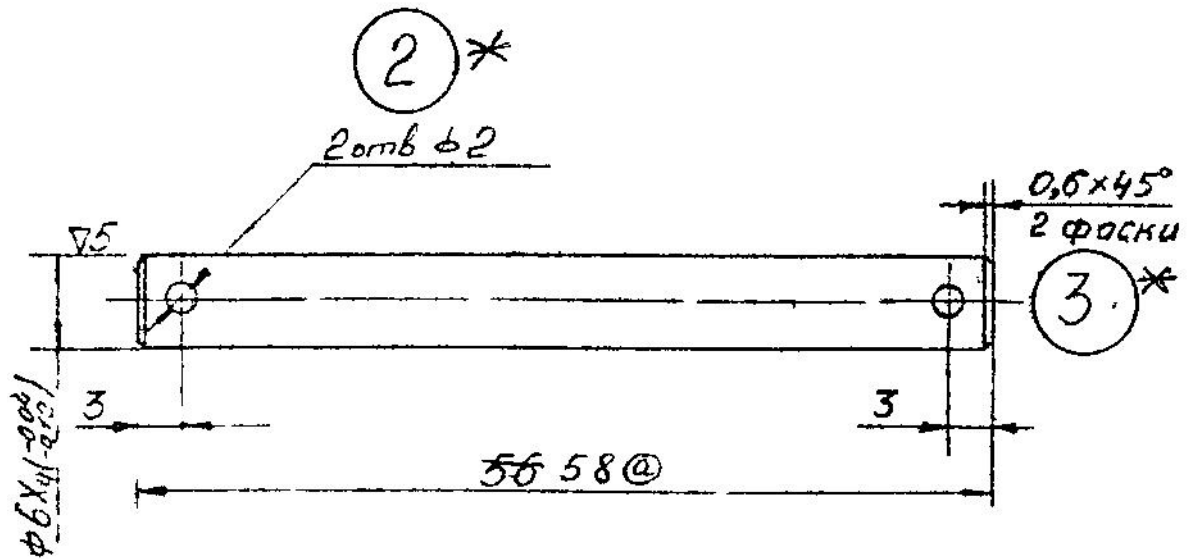
1. The material may be replaced by AL2, ГОСТ 2685-75.
2. Not specified limit deviations of sizes: of holes - according to A<sub>7</sub>, of shafts - according to B<sub>7</sub>; of other values - according to CM<sub>7</sub>.
3. Not specified casting radii are 2 mm.
4. Casting slopes should not exceed 2°.
5. Coating is anodic, oxidized, chrome-plated or chemical, phosphorous, blue.
6. Surfaces Γ and II may have pusher traces, ±0.5 mm.
7. For other requirements for casting, see TIAN-370.

\* (2) 2 holes Ø 6



APPROVED	<i>[Signature]</i>	675-42-46		
CHECKED	<i>[Signature]</i>			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		CLAMP	WEIGHT	SCALE
			0.075	1:1
MATERIAL:AL9 GOST 2685-75		SHT 1	SHTS 1	

675-42-50



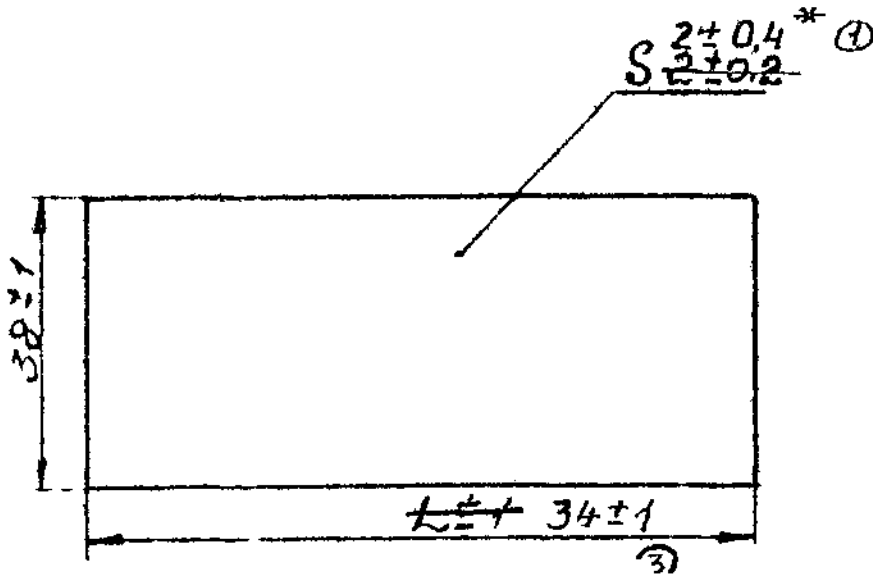
TECH. CONDITIONS

1. Steel 30, 40, 50, ГОСТ 1050-74, may be substituted for steel 45.
2. Not specified limit size deviations are: shafts - according to A<sub>7</sub>, holes - according to B<sub>7</sub>, other values - according to CM<sub>8</sub>.
3. Coating is chemical phosphating, accelerated, chrome-plated, impregnated with preservation oil K-17, ГОСТ 10877-76 according to Instructions 053.25289.00002 or with lacquer KO-815, ГОСТ 11066-74. Absence of coating in holes is permissible.
4. Mutual location of holes is arbitrary.

✕(2) 2 holes  $\varnothing 2$   
 ✕(3) 2 chamfers

APPROVED		675-42-50		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	PIN	WEIGHT	SCALE	
		0.01	2:1	
		SHT 1	SHTS 1	
MATERIAL: STEEL, 45 GOST 1050-74				

675-42-56



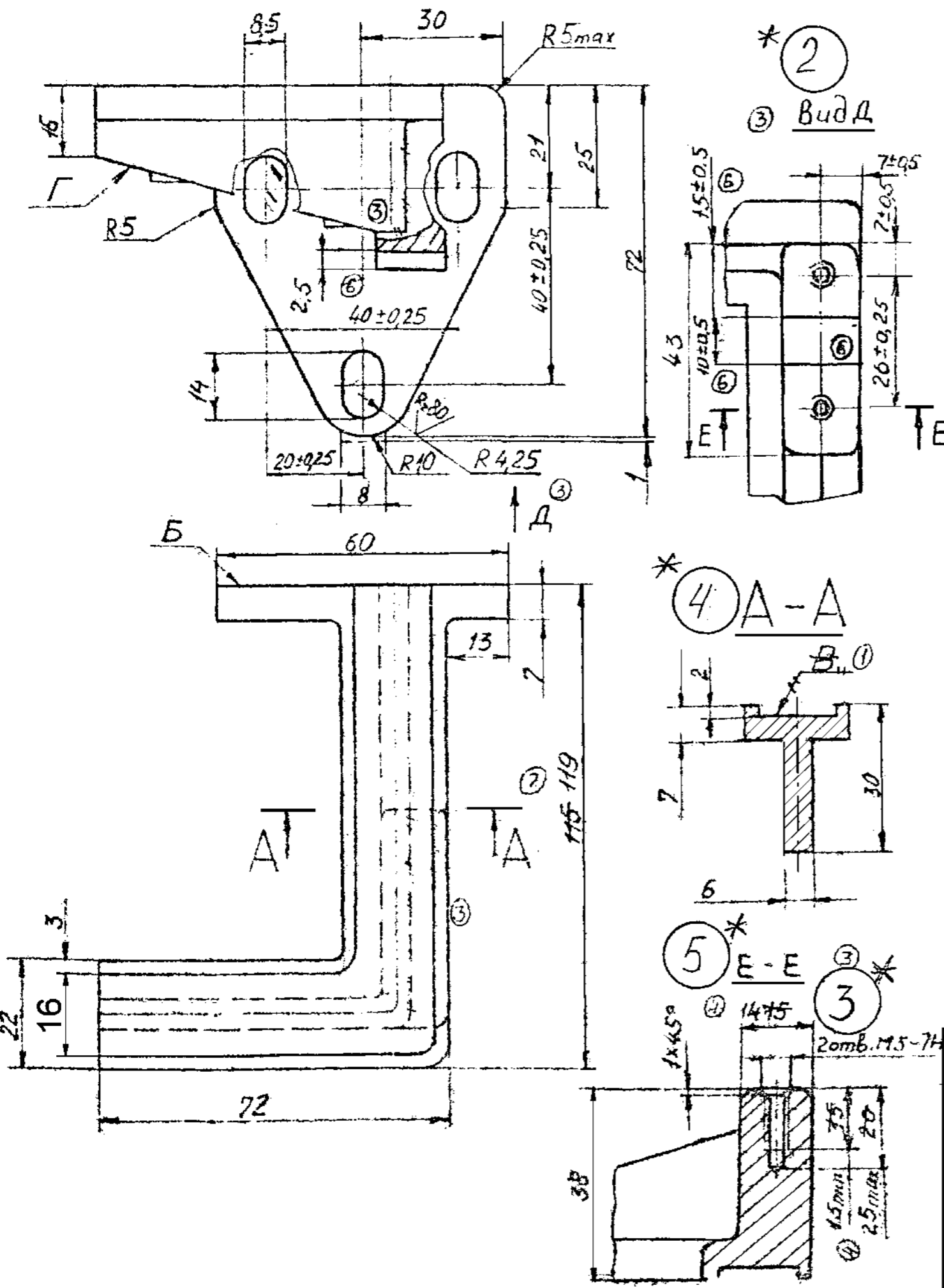
TECH. CONDITIONS

1. Material substitute is rubber 3311, Specifications TY 005.216-75.
2. For other requirements, see Specifications TY 005216-75 for article of code 254311.
3. <sup>#</sup>Size for reference.

APPROVED		675-42-56		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	GASKET	WEIGHT	SCALE	
		0.005	1:1	
		SHT 1	SHTS 1	
MATERIAL: PLATE 254311-2/ RUBBER-1847 TY 005.216-75				



675-42-64



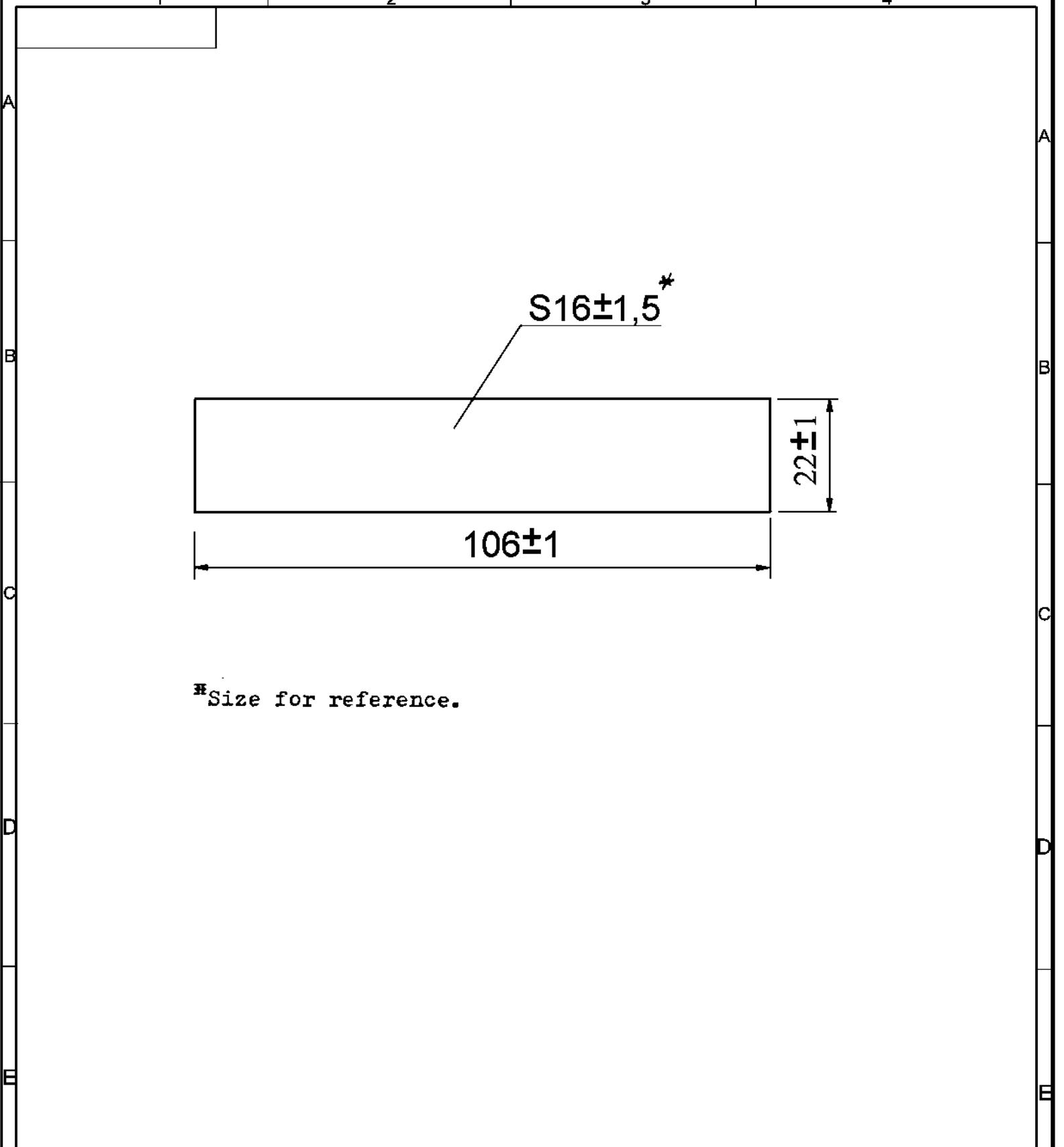
TECH. CONDITIONS

1. Material substitute is AL4, ГОСТ 2685-75.
2. Not specified limit deviations of sizes are the following:  
holes - according to A<sub>7</sub>, shafts - according to B<sub>7</sub>, other values - according to CM<sub>8</sub>.
3. Drafts should not exceed 1°, and on surface B - not more than 30'.
4. Not specified casting radii are 2 mm.
5. For other requirements, see TTAJ-436.
6. Coating is anodic oxidizing, chrome-plating or chemical phosphating, blue.
7. It is permissible to make a part according to conventional dotted line.
8. Depth of pusher traces on surface Γ should not exceed 0.5 mm.

- \*(2) View II
- \*(3) 2 holes M5-7H
- \*(4) Section A-A
- \*(5) Section E-E

APPROVED	<i>[Signature]</i>	675-42-64	
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	MATERIAL: AL9, GOST2685-75	WEIGHT	SCALE
		0.1	1:1
		SHT 1	SHTS 1

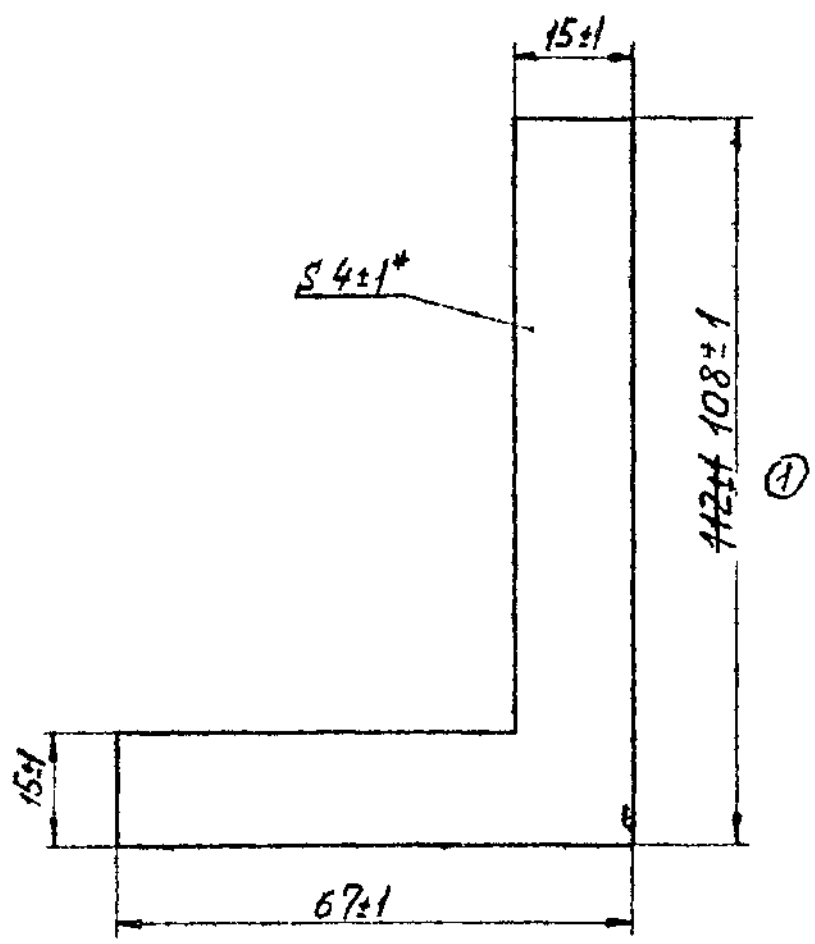




\*Size for reference.

APPROVED	<i>CR</i>	<b>675-42-65</b>					
CHECKED	<i>AS</i>				<b>GASKET</b>		
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>			WEIGHT	SCALE			
		SHT 1	0.0185	1:1			
<b>(ICV)</b>		MATERIAL: SPONGY PRESSED PLATE, GR.I, TY 38.105817-81					
		SHTS 1					

675-42-66



\*Size for reference

APPROVED *[Signature]*  
 CHECKED *[Signature]*  
 CONTROLLERATE  
 OF  
 QUALITY ASSURANCE  
 (ICV)

675-42-66

GASKET

MATERIAL: SPONGY PRESSED PLATE,  
GRITTY 38.105867-75

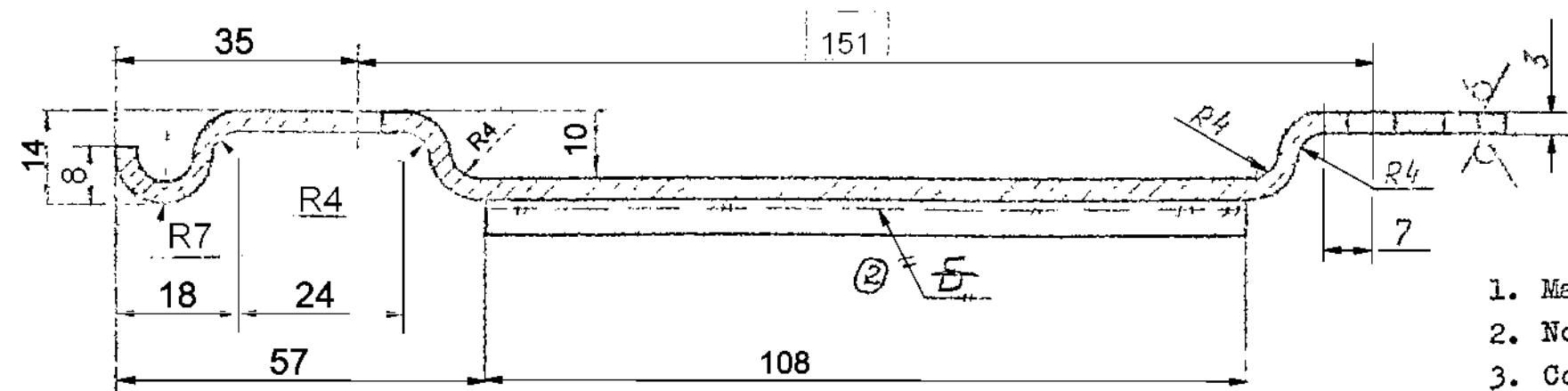
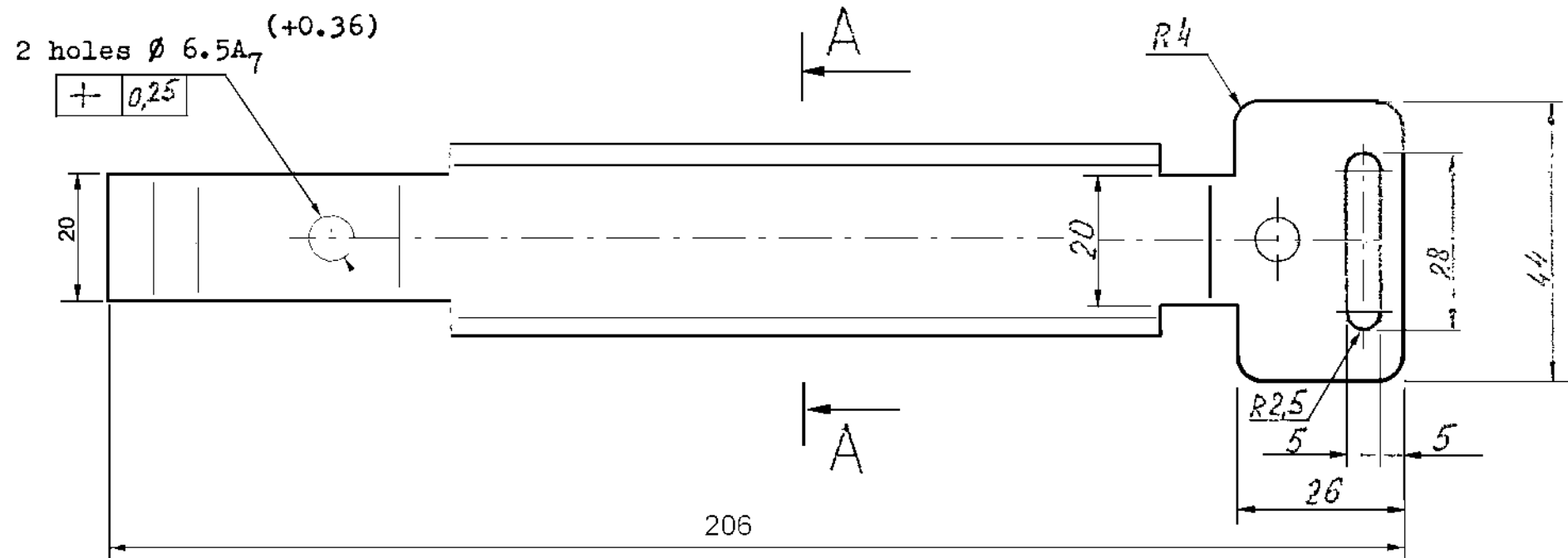
WEIGHT SCALE

0.0066 1:1

SHT 1 SHTS 1

675-42-67

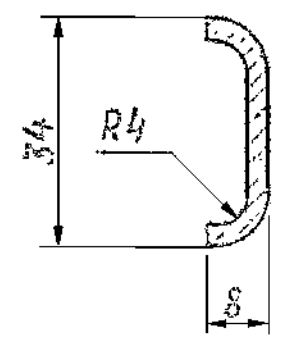
R2/160 105 (V)



TECH. CONDITIONS

1. Material substitute is sheet AMr6EM-3.0, ГOCT 21631-76.
2. Not specified limit deviations of sizes are  $\pm 1.5$  mm.
3. Coating is anodic oxidizing and chrome-plating or chemical phosphating blue. Use primer ФЛ-03HX, ГOCT 9109-81, mixture of enamel ПФ-223, ГOCT 14923-78, consisting of three portions of red enamel and five portions of yellow enamel.
4. \*Size for reference.

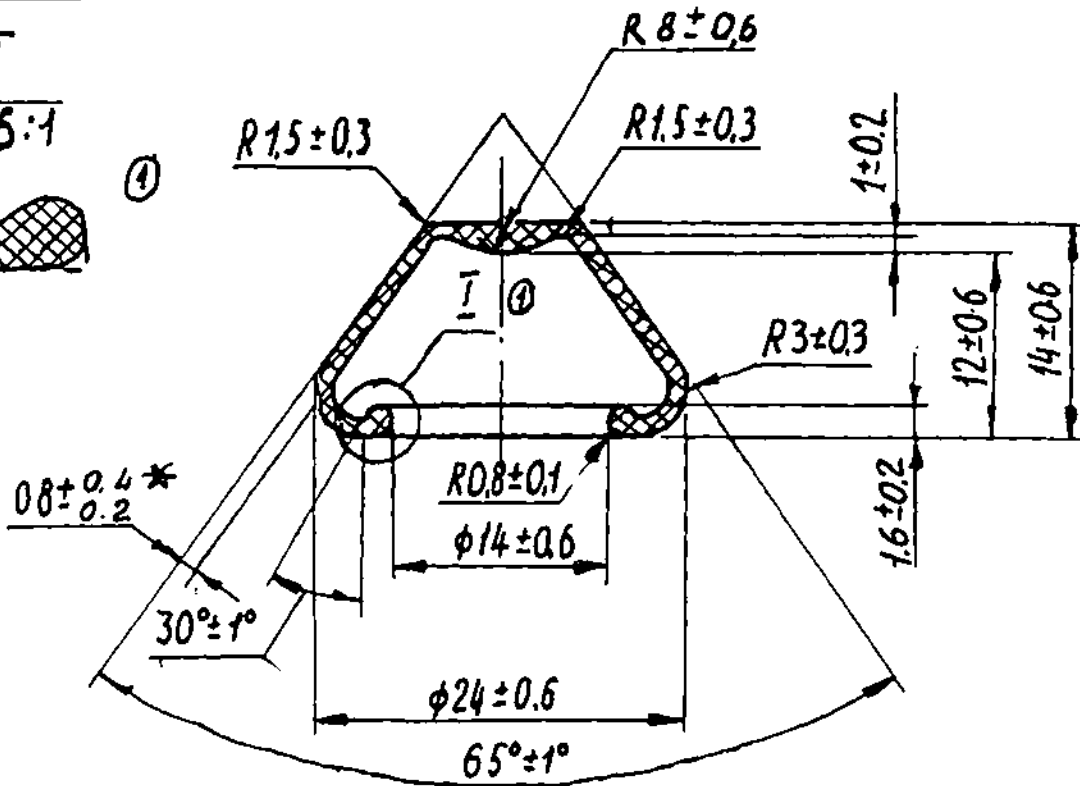
Section A-A



APPROVED	<i>[Signature]</i>	675-42-67	
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	SHEET AMr 5M-3 GOST 21631-76	WEIGHT	SCALE
		0.039	1:1
		SHT	SHTS

675-42-70

\* (2)  $\frac{T}{M 5:1}$



TECH. CONDITIONS

1. Sizes are ensured by tooling (except size<sup>✱</sup>).
2. Wall difference is permissible within the tolerance zone.
3. Mark on a tag.
4. For other requirements for an article of code 253151, see Specifications TY 005216-75.
5. Part may be manufactured according to thick dot-and-dash line.
6. Cut on a collar of up to 0.5 mm is permissible.

✱(2) Scale 5:1

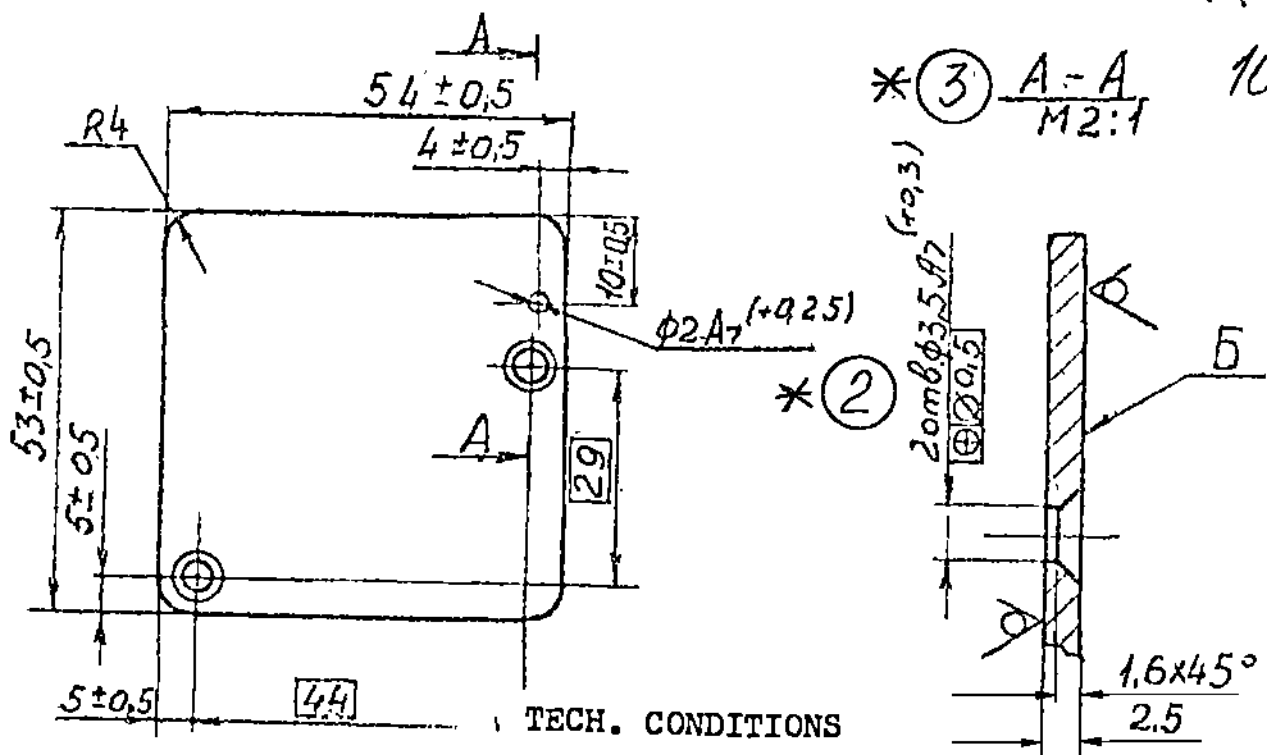
(A) EQ. MATERIAL:- NITRILE+CHLOROPHENE (a) BA-60 TO BS:2751-82  
(b) C-60 TO BS:2751-82

00802-ICV	(A)	BA-60 TO BS:2751-82 OR C-60 TO BS:2751-82 ADDED AS EQ MATERIAL
18-08-2000		
DC(I)No. & DATE	ISSUE	AMENDMENTS

APPROVED		<h1>675-42-70</h1>		
CHECKED				
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>	<h2>CAP</h2>		WEIGHT	SCALE
			0.001	2:1
			SHT 1	SHTS 1
MATERIAL: RUBBER HO-68-1 TY 005.216-75				

675-42-73

RZ80/  
√(1)



\* (3)  $\frac{A-A}{M2:1}$  107

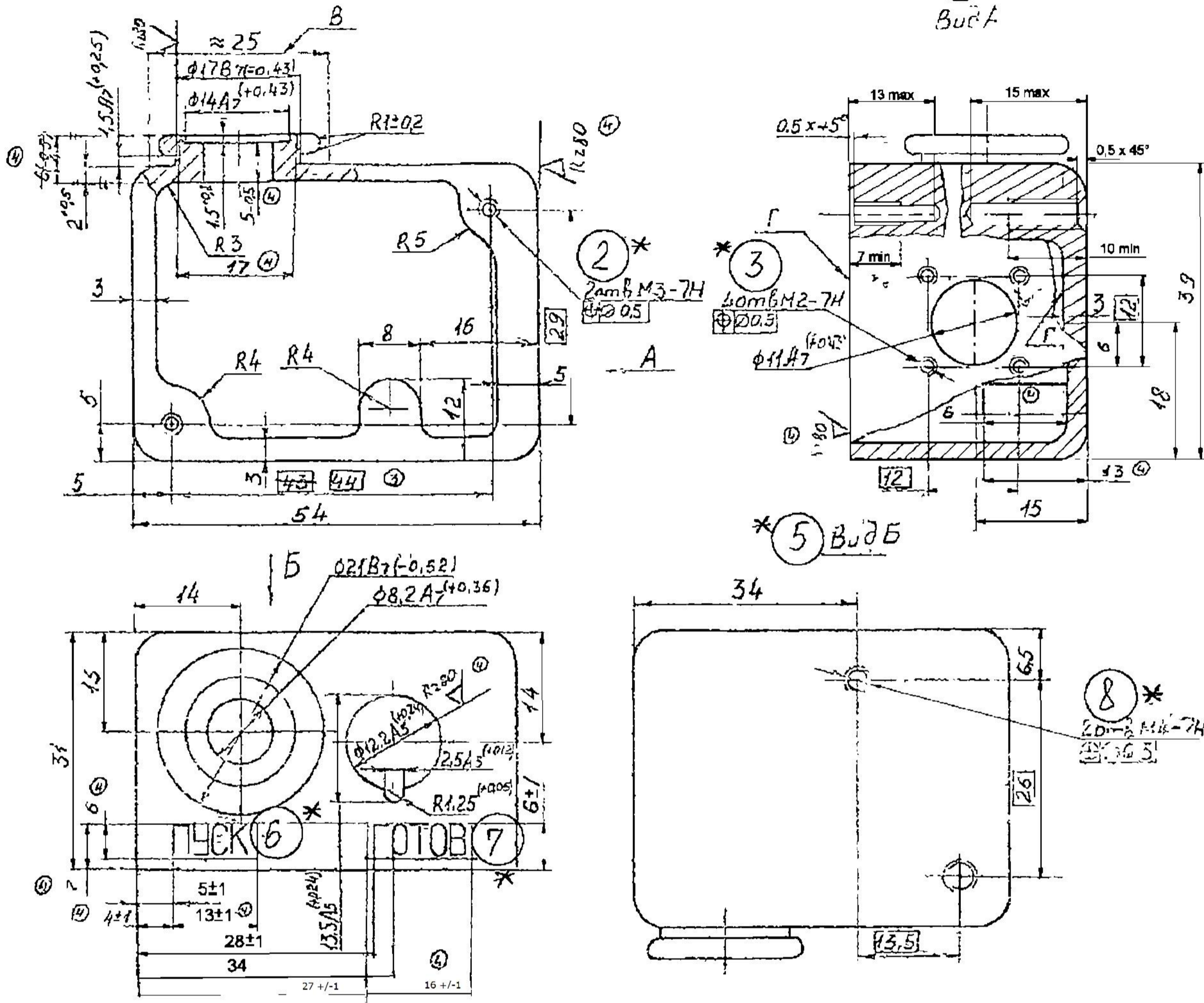
\* (2)

TECH. CONDITIONS

1. Material substitute is sheet AMr5M-2.5, ГOCT 21631-76.
2. Coating is anodic oxidizing and chrome-plating or chemical phosphating, blue. External surfaces are covered with primer ФЛ-03Ж, ГOCT 9109-81, grey enamel МЛ-12, ГOCT 9754-76, silvery enamel МЛ-165, ГOCT 12034-77. Replacement by dard-grey enamel. ПФ-223, ГOCT 14923-78 is permissible.
3. \* Size for reference.

\* (2) 2 holes  $\phi$  3.5A<sub>7</sub>  
 \* (3) Section A-A  
 Scale 2:1

APPROVED		675-42-73		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	COVER	WEIGHT	SCALE	
		0.013	1:1	
		SHT 1	SHTS 1	
MATERIAL: SHEET AMG6BM-2.5 GOST 21631-76				



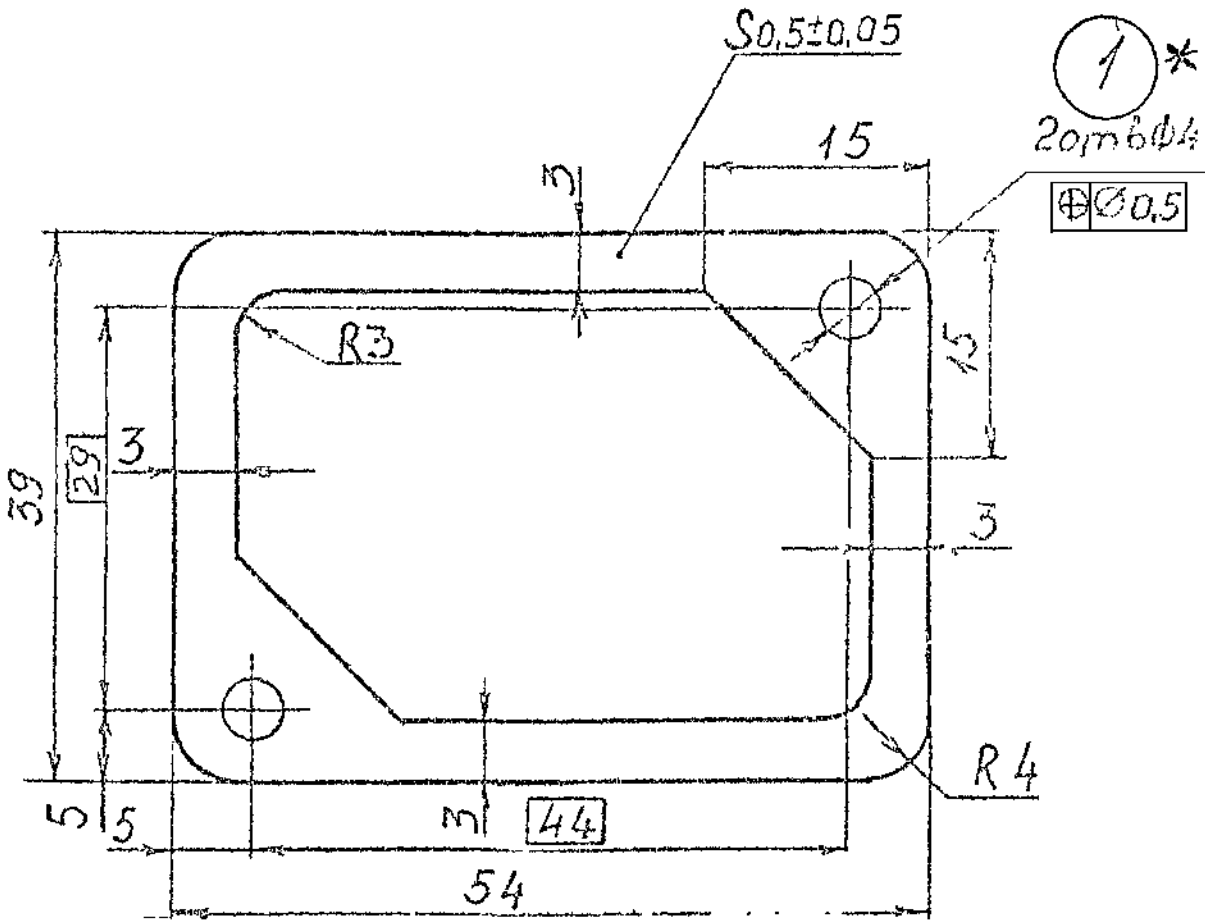
TECH. CONDITIONS

- Material substitute is АЛ4В, ГОСТ 2685-75.
- Coating is anodic oxidizing and chrome-plating or chemical phosphating, blue. External surfaces are coated with primer ФН-03Ж, ГОСТ 9109-81, grey enamel МН-12, ГОСТ 9754-76, silvery enamel МН-165, ГОСТ 12034-77. Use of dark-grey enamel НФ-223, ГОСТ 14923-78, is permissible.
  - Protect threaded surfaces from painting.
  - Not specified limit deviations of sizes are  $\pm 0.5$  mm.
  - Not specified casting radii should not exceed 4 mm.
  - Casting slopes should not exceed  $2^\circ$  towards tolerance increase.
  - Permissible pusher traces on surface Г should not exceed 0.5 mm, and rifling  $\pm 0.2$  mm.
  - Permissible cutting-in along size В should not exceed 0.5 mm.
  - Print is П0-4, ГОСТ 2930-62. Sign protrusion beyond the surface is  $0.5^{+0.5}$  mm.
  - Fill inscriptions with black enamel НФ-223, ГОСТ 14923-78.
  - For other requirements for casting, see ТТЛН-370.

- \*(2) 2 holes M3-7H
- \*(3) 4 holes M2-7H
- \*(4) View A
- \*(5) View B
- \*(6) START
- \*(7) READY
- \*(8) 2 holes M4-7H

APPROVED	<i>[Signature]</i>	675-42-74		
CHECKED	<i>[Signature]</i>	CASING	WEIGHT	SCALE
CONTROLLERATE OF QUALITY ASSURANCE (ICV)			0.072	2:1
		matl	SHT 1	SHTS 1

675-42-76



X-(1) 2 holes  $\varnothing 4$

TECH. CONDITIONS

Not specified limit deviations of sizes are  $\pm 0.5$  mm.

APPROVED

675-42-76

CHECKED

WEIGHT

SCALE

0.005

2:1

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

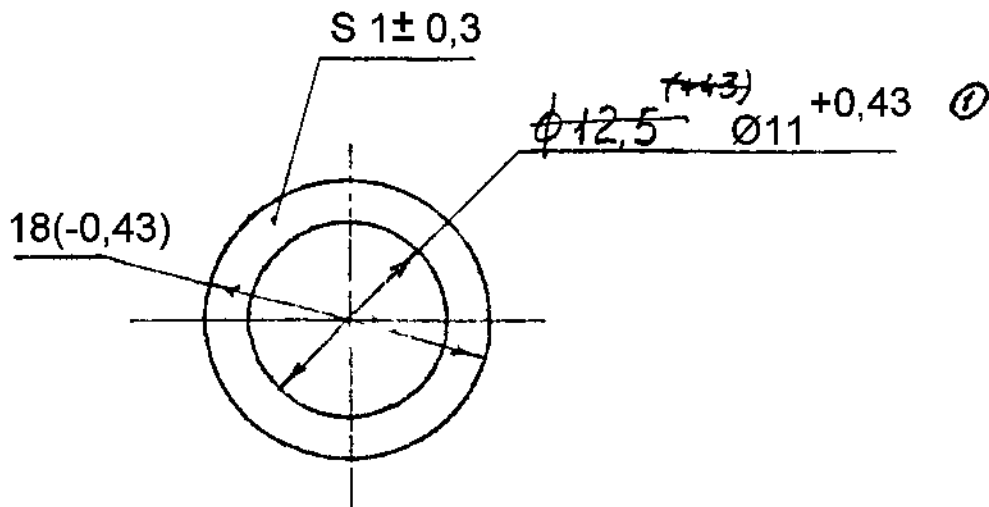
GASKET

SHT 1

SHTS 1

MATERIAL:GASKET CARDBOARD  
MARK A,GOST 9347-74

675-42-77



TECH. CONDITIONS

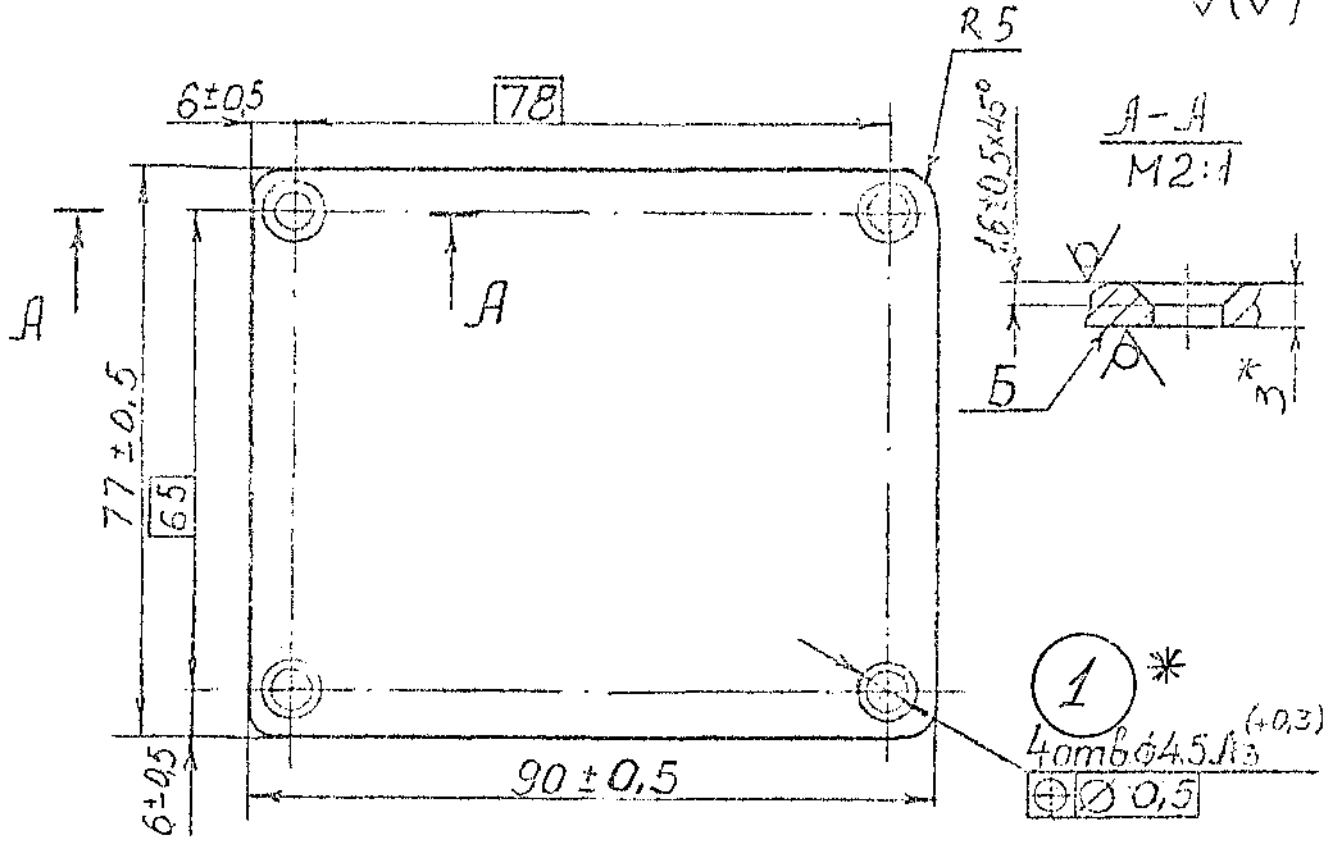
1. Material substitute is plate 254311-1 rubber 10643, Specifications TY 005216-75.
2. For other requirements for articles with code 254311, see Specifications TY 005.216-75.

APPROVED		<b>675-42-77</b>		
CHECKED				
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>	<b>GASKET</b>		WEIGHT	SCALE
			0.0002	2:1
		SHT 1	SHTS 1	
	MATERIAL: PLATE 254311-1 RUBBER 10576 TY 005 216 - 75			



675-42-79

R<sub>L80</sub> ✓(✓)



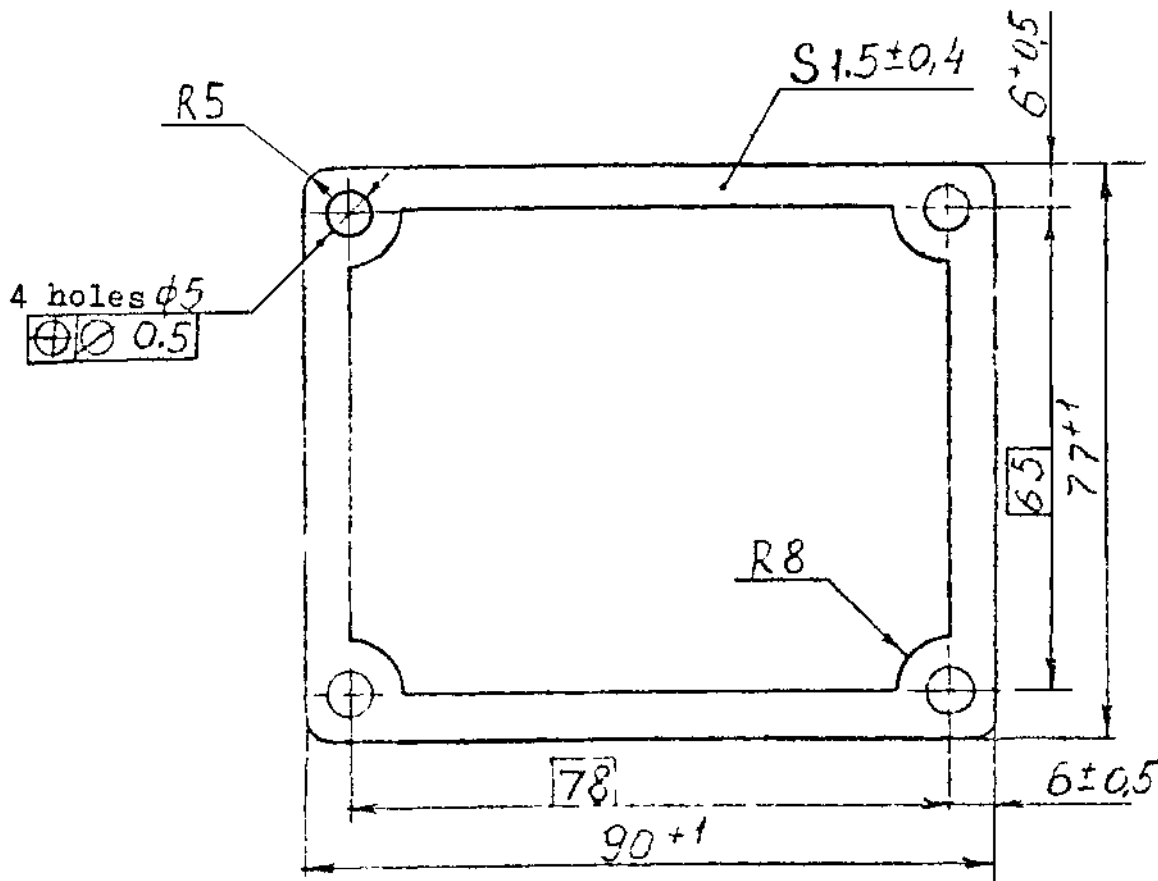
\* (1) 4 holes  $\varnothing 4.5A_3^{(+0.3)}$

TECH. CONDITIONS

1. Material substitute is sheet AMr5M-3, ГOCT 21631-76.
2. Coating is anodic oxidizing and chrome-plating or chemical, phosphating, blue. Coat surfaces, except surface B, with primer ФЛ-03Ж, ГOCT 9109-81, grey enamel MJ-12, ГOCT 9754-76, silvery enamel MJ-165, ГOCT 12034-77.
3. \*Size for reference.

APPROVED		<b>675-42-79</b>		
CHECKED				
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>	<b>COVER</b>		WEIGHT	SCALE
			0.056	1:1
			SHT	SHTS
SHEET AMr 6 6M-3, GOST 21631-76				

08-24-979



TECH. CONDITIONS

1. Not specified radii should not exceed 1 mm.
2. For other requirements for articles with code 254311, see Specifications TY 005.216-75.

APPROVED

CHECKED

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

675-42-80

GASKET

PLATE 254311-15 TY 005-216-75  
RUBBER 10676

WEIGHT

SCALE

0.003

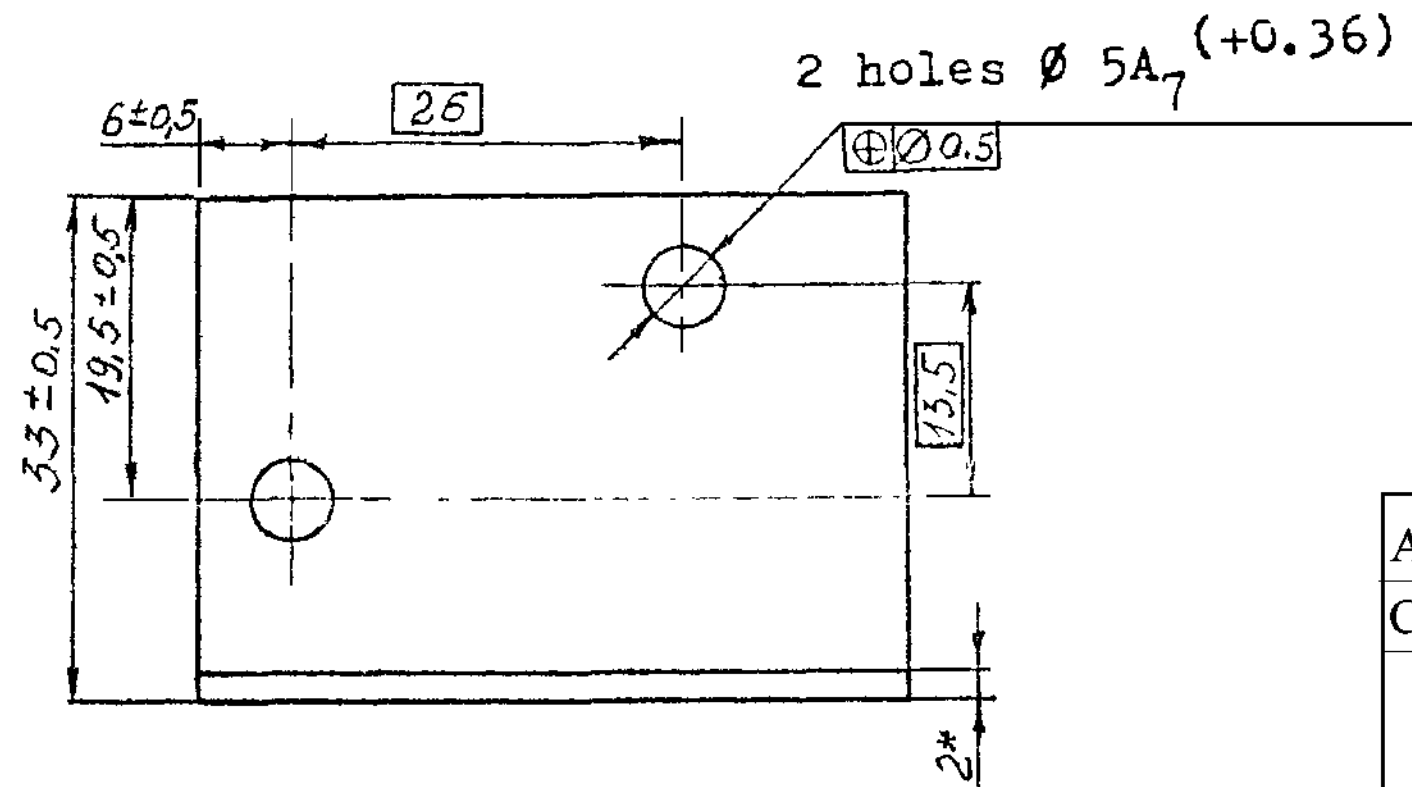
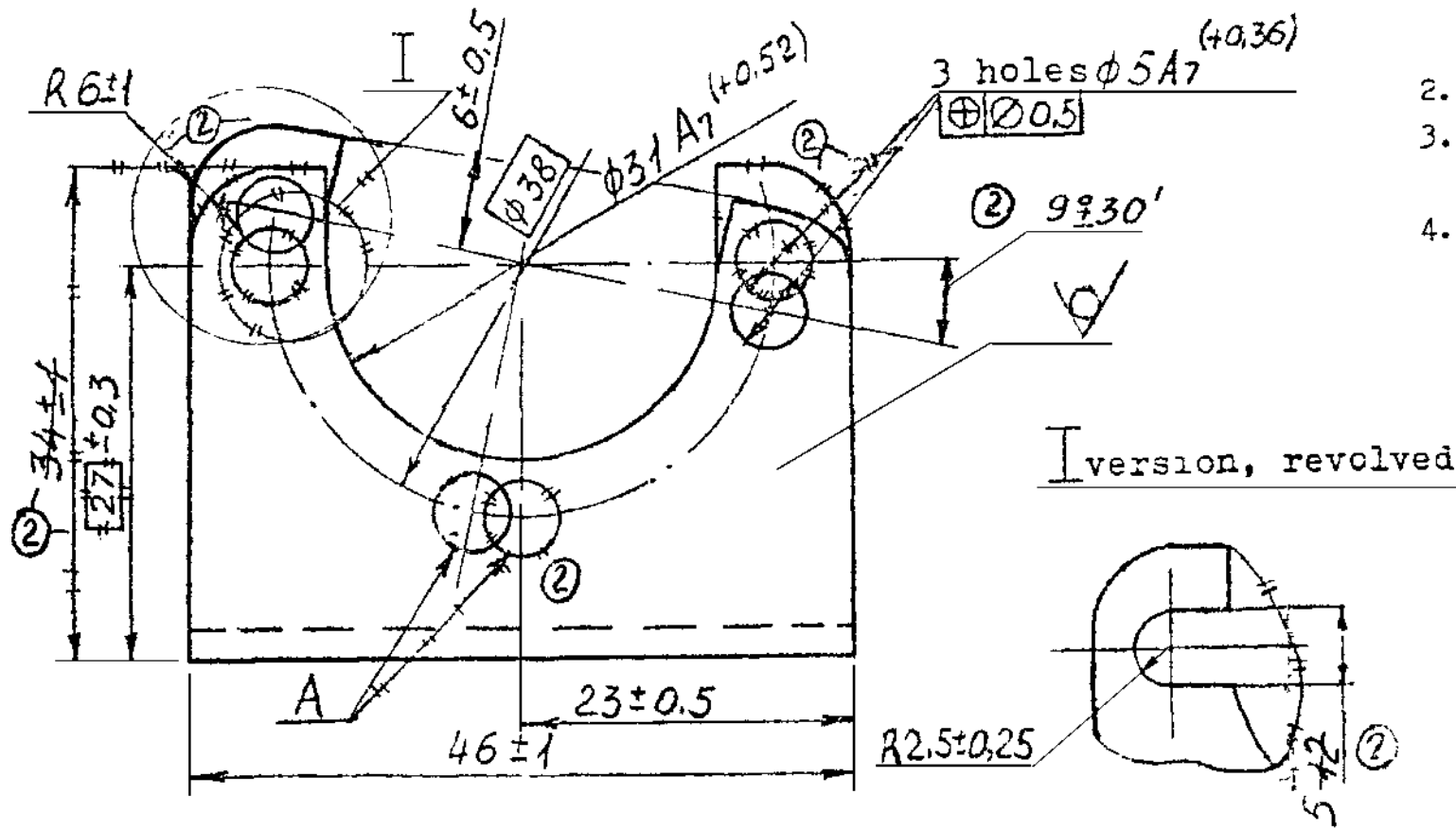
1:1

SHT

SHTS

TECH. CONDITIONS

1. Coating is chemical phosphating, chrome-plating. Coat surfaces with primer ФЛ-03К, ГОСТ 9109-81, and enamel 223, (white 1 ГОСТ 14923-78).
2. Bending radius is R3.
3. Permissible expansion of hole A on an outer edge should not exceed 0.5 mm above tolerance.
4. \*Size for reference.

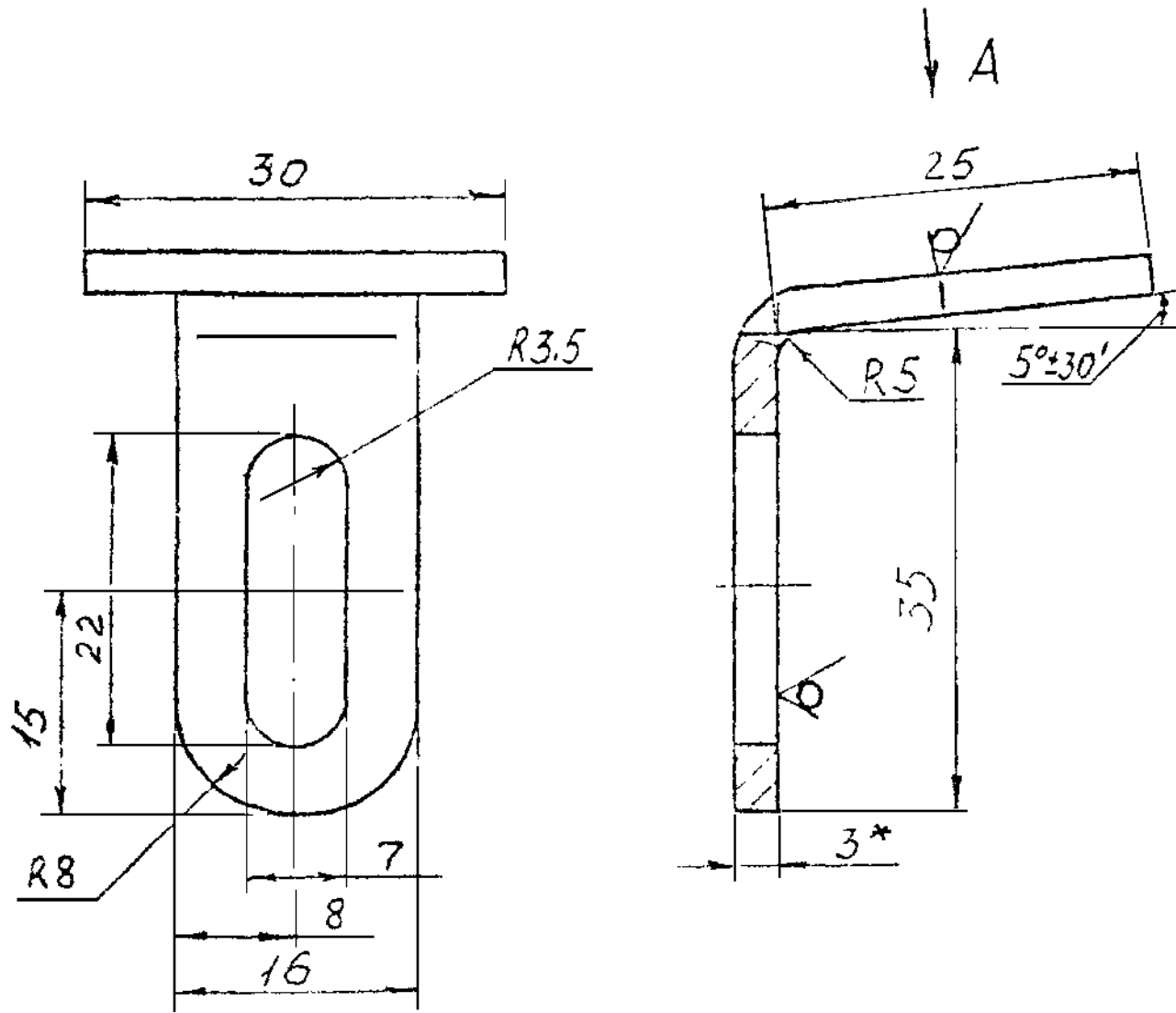


APPROVED	<i>[Signature]</i>	675-42-81	
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	SHEET	BRACKET	WEIGHT SCALE
		Б-ПН-0-2 GOST 19903-74	0.037 2:1
		10, GOST 16523-70	SHT 1 SHTS 1

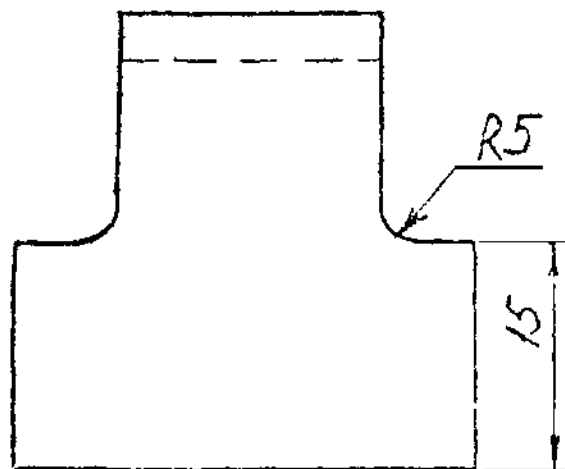


TECH. CONDITIONS

1. Material substitute is sheet AMr6EM-3.0, ГОСТ 21631-76.
2. Not specified limit deviations of sizes are  $\pm 0.5$  mm.
3. Coating is anodic oxidizing, chrome-plating or chemical phosphating, blue. Coat surfaces with primer ФЛ-03Ж, ГОСТ 9109-76, mixture of enamel ПФ-223, ГОСТ 14923-78, consisting of three parts of red enamel and five parts of yellow enamel.
4. #Size for reference.

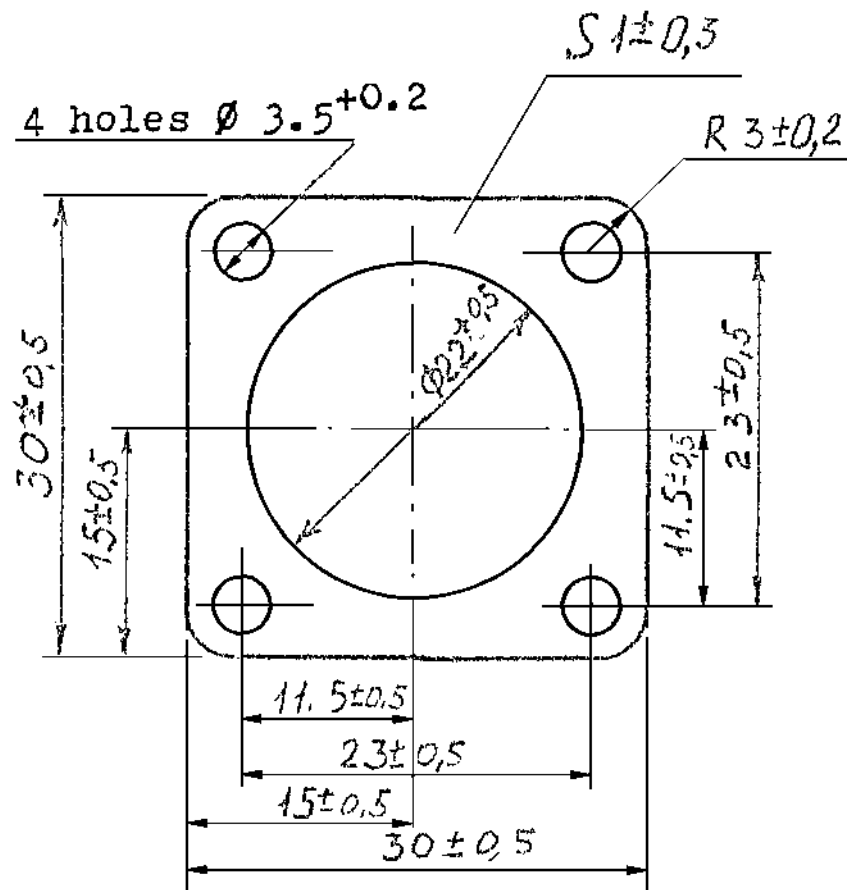


View A



APPROVED	<i>[Signature]</i>	<b>675-42-83</b>		
CHECKED	<i>[Signature]</i>			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		<b>BRACKET</b>	WEIGHT 0.008	SCALE 2:1
		SHEET AMr5M-3 GSOT 21631-76	SHT 1	SHTS 1

675-42-84



For other requirements for articles with code 25 3161, see Specifications TY 005.216-75.

APPROVED

CHECKED

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

675-42-84

GASKET


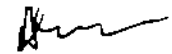
PLATE  $\frac{254311-1}{\text{RUBBER 637}}$  TY 005.216-75

WEIGHT	SCALE
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0.0015	2:1
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SHT 1	SHTS 1
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No.	Designation	Description	Qty	Remark
		<u>List of Documents</u>		
	675-42-c6705	Assembly drawing		
	675-42-2TT	Technical requirements for check and acceptance of article 9M135M		
		<u>Assembly Units</u>		
1	675-42-c6131	Start button	1	
5	675-42-c6132	Control unit	1	
2	675-42-c6125	Bracket	1	
6	675-42-c6134	Cable assembly	1	
3	675-42-c6126	Bracket	1	
8	675-97-c6196	Plug	1	
4	675-42-c6129	Belt	1	
		<u>Parts</u>		
7	675-42-81	Bracket	1	
9	675-42-83	Bracket	1	
		<u>Standard Items</u>		
11		Screw BLM48h6hx10.48 O16 IOCT 17473-80	5	
13		Bolt M6x16.46-019 IOCT 7798-70	3	
14		Nut M6.6.019 IOCT 5927-70	3	
15		Bolt M8x50.46.019 IOCT 7795-70	3	
16		Nut M8.6.019 IOCT 5927-70	6	

APPROVED		<b>675-42-Sb7</b>		
CHECKED			WEIGHT	SCALE
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>		<b>CONTROL SYSTEM</b>		
			SHT 1	SHTS 3


No.	Designation	Description	Qty	Remark
17		Washer 4.01.019 or 4.02.019 FOCT 11371-78	5	
18	EQ MAT.C-30 TO IS:1570-79	Washer 6x1.01.019 or 6x1.02.019 FOCT 11371-78	5	(Ref DCU) 00957-ICV)
19	EQ MAT.C-30 TO IS:1570-79	Washer 8.01.019 or 8.02.019 FOCT 11371-78	3	(Ref DCU) 00957-ICV)
① 20	COUNTERSUNK SCREW M5 X10 TO IS:1865-4-8 PITCH D-B AS PER IS:4218 (PART-2) 76 ZINC PLATED 9 MICRONS THICK.	Screw Bl.M5-8gx10.48.016 FOCT 17475-80	2	
21		Washer 4T65FO5 FOCT 6402-70	5	
22		Washer 6T65FO6 FOCT 6402-70	6	
23		Washer 8T65FO6 FOCT 6402-70	6	
24		Nut M5.6.016 FOCT 5927-70	2	
26	Washer 5T65FO5 FOCT 6402-70	2		
29	Washer 6.01.019 or 6.02.019 FOCT 6958-78	1		
27	<u>Materials</u> Wire K0.5 FOCT 792-67 <i>l</i> = 100 mm	1		

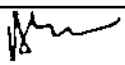
APPROVED	<i>g</i>	<b>675-42-Sb7</b>				
CHECKED	<i>[Signature]</i>					
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>		<b>CONTROL SYSTEM</b>			WEIGHT	SCALE
				SHT	2	SHTS 3

No.	Designation	Description	Qty	Remark
30	9П135.00.000	<u>Other Items</u> Item 9П135M	1	Purchased according to 675-73-c6201
		00353-1CV <i>Buy</i> 2-12-93	 <i>AD</i>	IS EQUIVALENT FOR SCREW REF. NO. 20 ADDED
		DC(I)N- & DATE	ISSUE	NATURE
		AMENDMENTS		

APPROVED	<i>g</i>	<b>675-42-Sb7</b>		
CHECKED	<i>[Signature]</i>			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	<b>CONTROL SYSTEM</b>		WEIGHT	SCALE
			SHT 3	SHTS 3

No.	Designation	Description	Qty	Remark
	675-42-c61250B	<u>List of Documents</u> Assembly drawing		
		<u>Parts</u>		
1	675-42-46	Clamp	1	
3	675-42-50	Pin	2	
4	700-28-669	Bolt	1	
5	675-42-56	Gasket	2	
7	675-42-63	Bracket	1	
		<u>Standard Items</u>		
9		Nut M6.5.35II-I 019 FOCT 3032-66	1	
10		Washer 6.01.019 or 6.02.019 FOCT 6958-68	1	
11	EQ MAT C-30 TO IS'1570-79	Washer 6x1.01.019 or 6x1.02.019 FOCT 11371-78	4	(Ref DC(1) 00957-ICV)
12		Washer 6T65FO6 FOCT 6402-70	1	
14		Cotter pin 2x12.019 FOCT 397-79	4	

APPROVED 

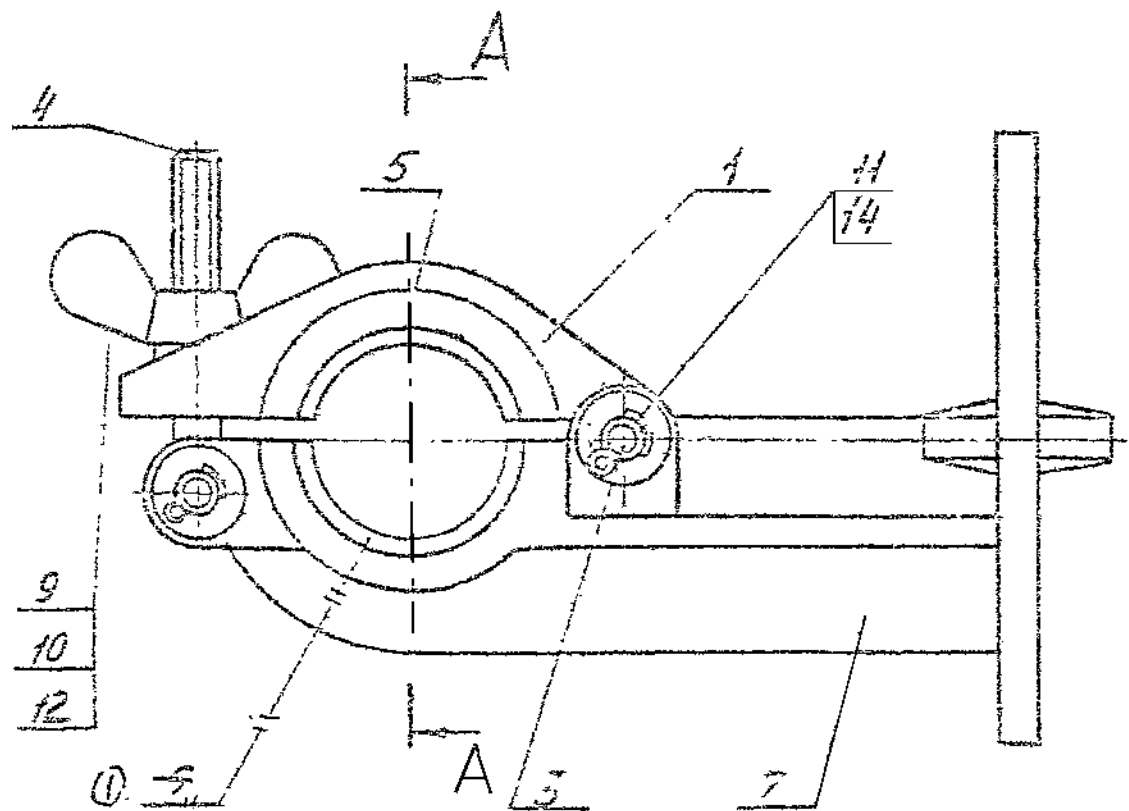
CHECKED 

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

**675-42-Sb125**

<b>BRACKET</b>	WEIGHT	SCALE
	SEE	1:1
	SHT 1	SHTS 1

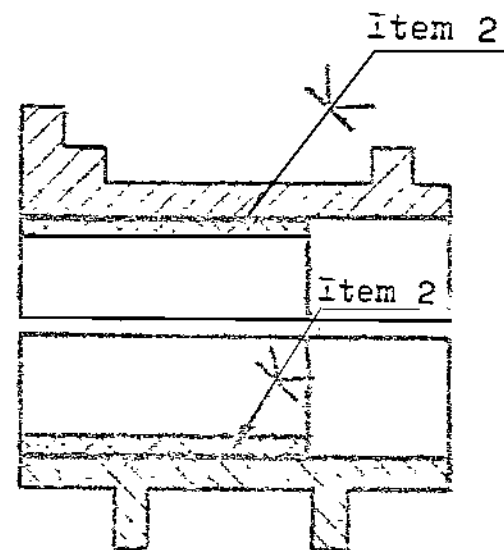
675-42-Sb125Sb



TECH. CONDITIONS

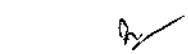
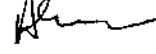
1. Punch or flatten bolt (4).
2. Use glue 88-HI, Specifications TV 38-105540-73.

A-A

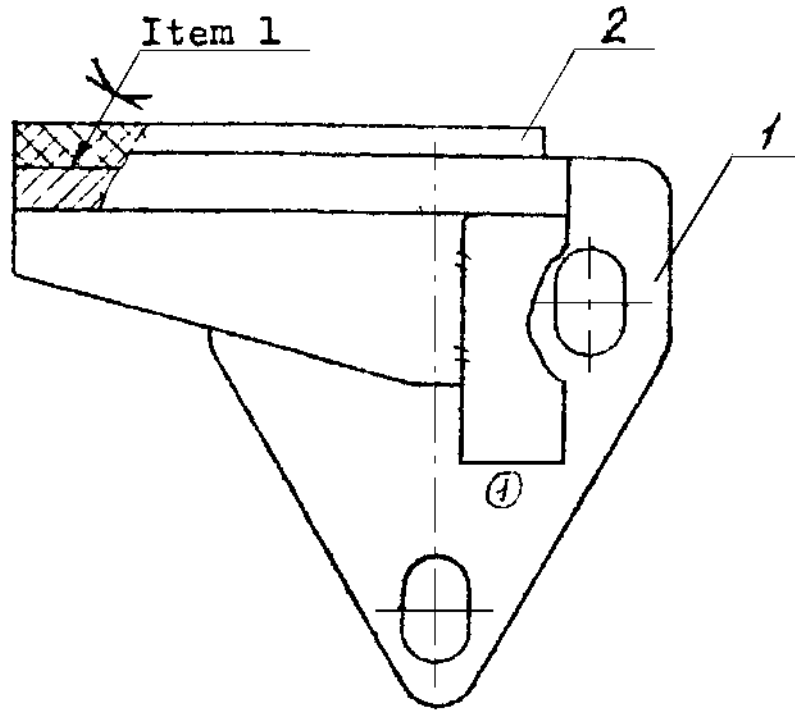


APPROVED		<b>675-42-Sb125Sb</b>			
CHECKED					
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>		<b>BRACKET ASSEMBLY DRAWING</b>		WEIGHT	SCALE
				0.451	1:1
				SHT 1	SHTS 1

No.	Designation	Description	Qty	Remark
	675-42-c6126CB	<u>List of Documents</u> Assembly drawing		
		<u>Parts</u>		
1	675-42-64	Bracket	1	
2	675-42-66	Gasket	1	

APPROVED		<b>675-42-Sb126</b>			
CHECKED					
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>		<b>BRACKET</b>		WEIGHT	SCALE
			SHT		SHTS

675-42-Sb126Sb



Use glue 88-HI, Specifications TV 38-105540-73.

APPROVED

CHECKED

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

675-42-Sb126Sb

BRACKET  
ASSEMBLY DRAWING

WEIGHT

SCALE


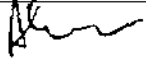
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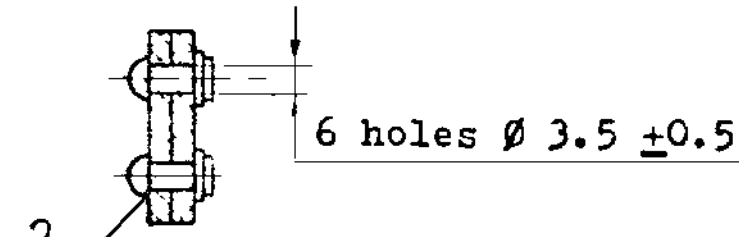
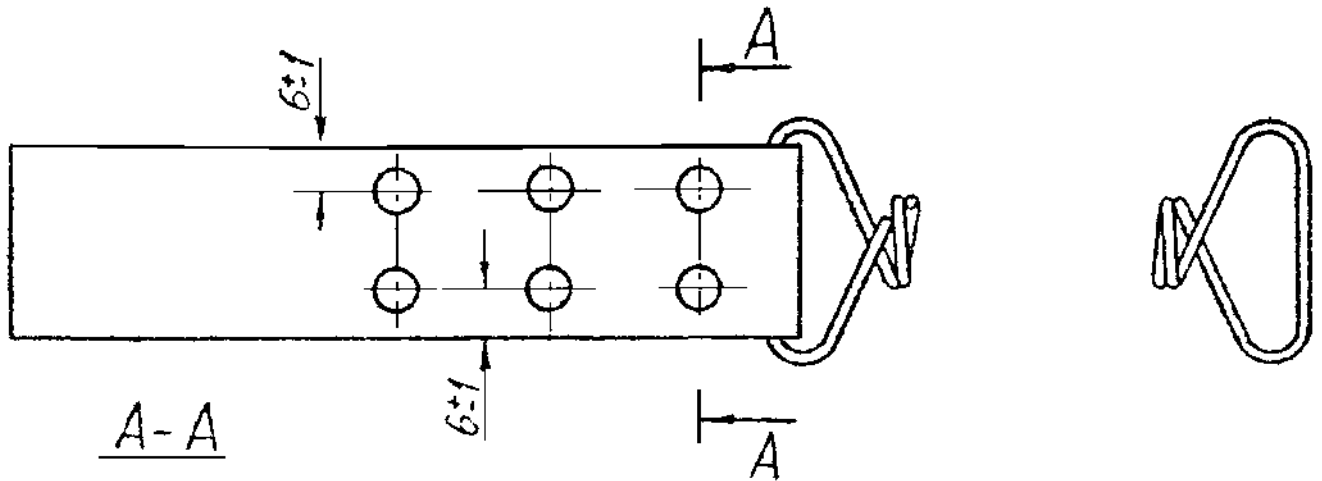
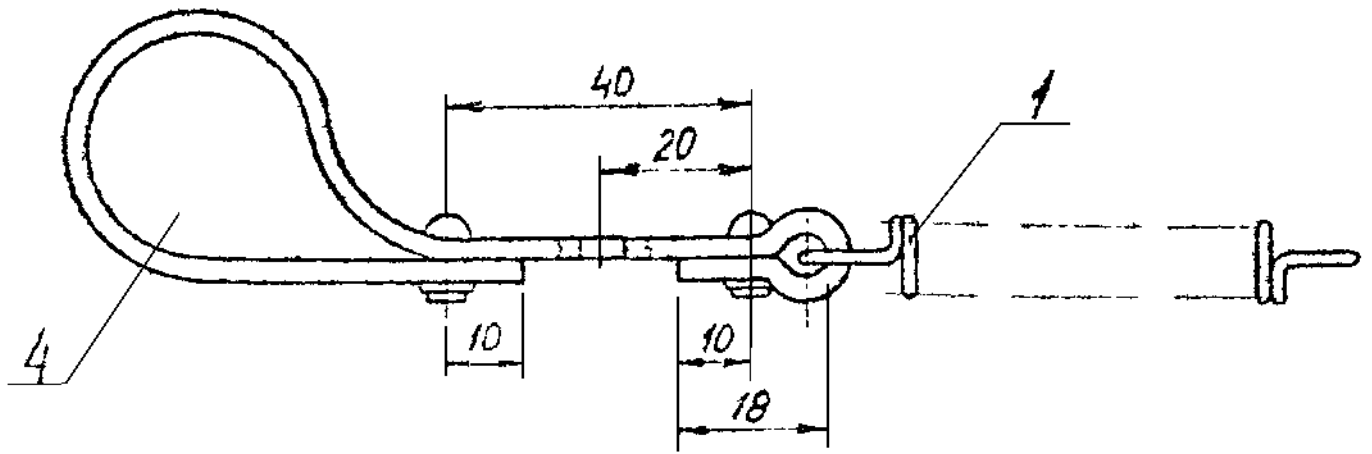
1:1

SHT

SHTS

No.	Designation	Description	Qty	Remark
	675-42-c6127CB	<u>List of Documents</u> Assembly drawing		
1	672-38-26	<u>Parts</u> Spring		
2		<u>Standard Items</u> Washer 4.01.019 or 4.02.019	4	
3		TOCT 11371-78 Eyelet, steel, nickel-plated 3X-25 OCT 17-600-76	4	
4		<u>Materials</u> Belt strip EPT 25x3.1 I grade TOCT 16996-71 $l = 250$	1	

APPROVED		<b>675-42-Sb127</b>		
CHECKED				
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>	<b>BRACKET</b>		WEIGHT	SCALE
		SHT	SHTS	



TECH. CONDITIONS

2  
3

1. Coat the ends of band (4) over a length of 10 mm with phenol formaldehyde lacquer, mark ЛЕС-1, ГОСТ 901-78, and dry them.
2. Not specified limit deviations of sizes are  $\pm 2$  mm.

APPROVED

CHECKED

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

675-42-Sb127Sb


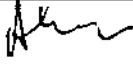
BELT  
ASSEMBLY DRAWING

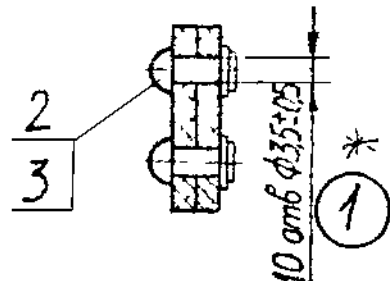
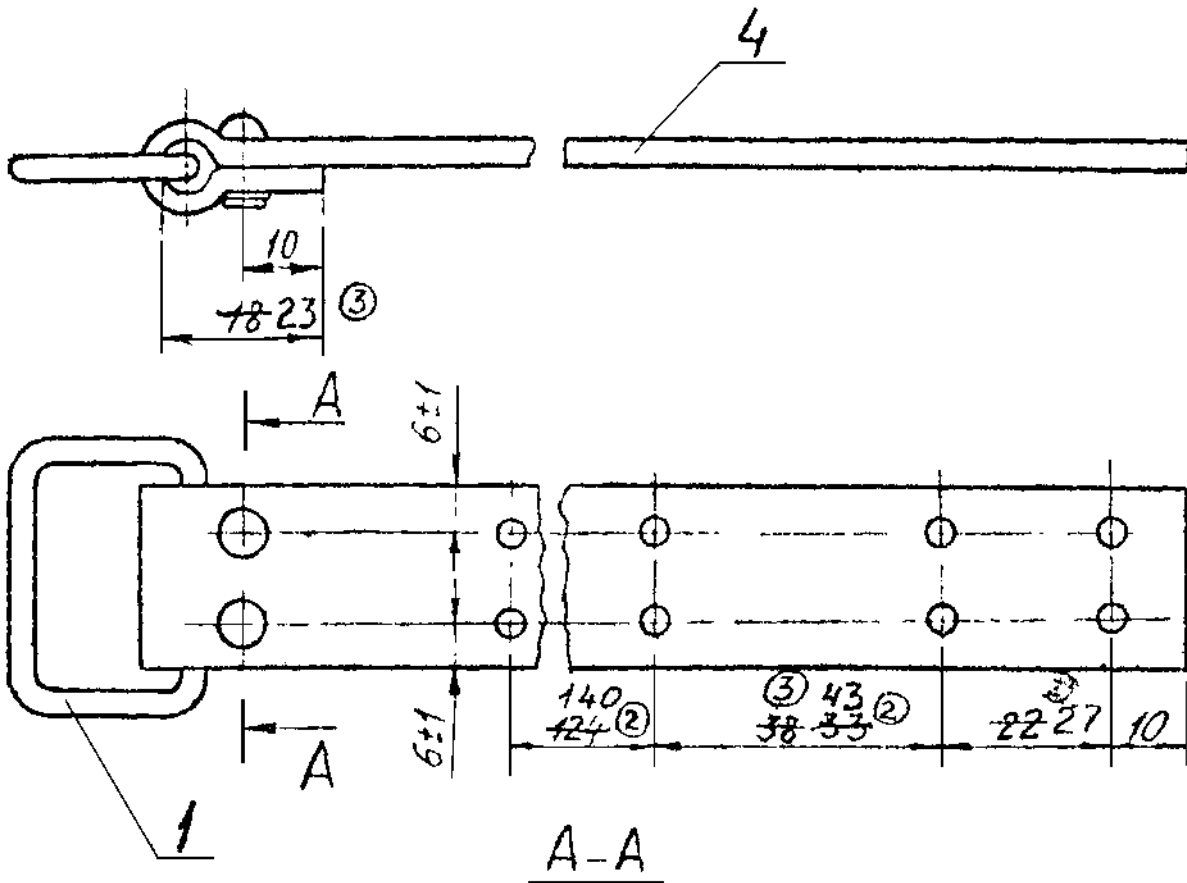
WEIGHT	SCALE
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0.034	1:1
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SHT	SHTS
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No.	Designation	Description	Qty	Remark
	675-42-c6128CB	List of Documents Assembly drawing		
		<u>Parts</u>		
1	765-94-224	Frame	1	
		<u>Standard Items</u>		
2		Washer 4.01.019 or 4.02.019	2	
3		FOCT 11371-78 Eyelet, steel, nickel-plated 3X-25OCT17-600-76	2	
		<u>Materials</u>		
4		Belt strip JPT 25x3.1 I grade FOCT 16996-71 ℓ = 500 mm.	1	

APPROVED		<b>675-42-Sb128</b>		
CHECKED				
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>		<b>BELT</b>		
			SHT	SHTS




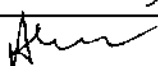
\*(1) 10 holes  $\varnothing$  3.5 ± 0.5

**TECH. CONDITIONS**

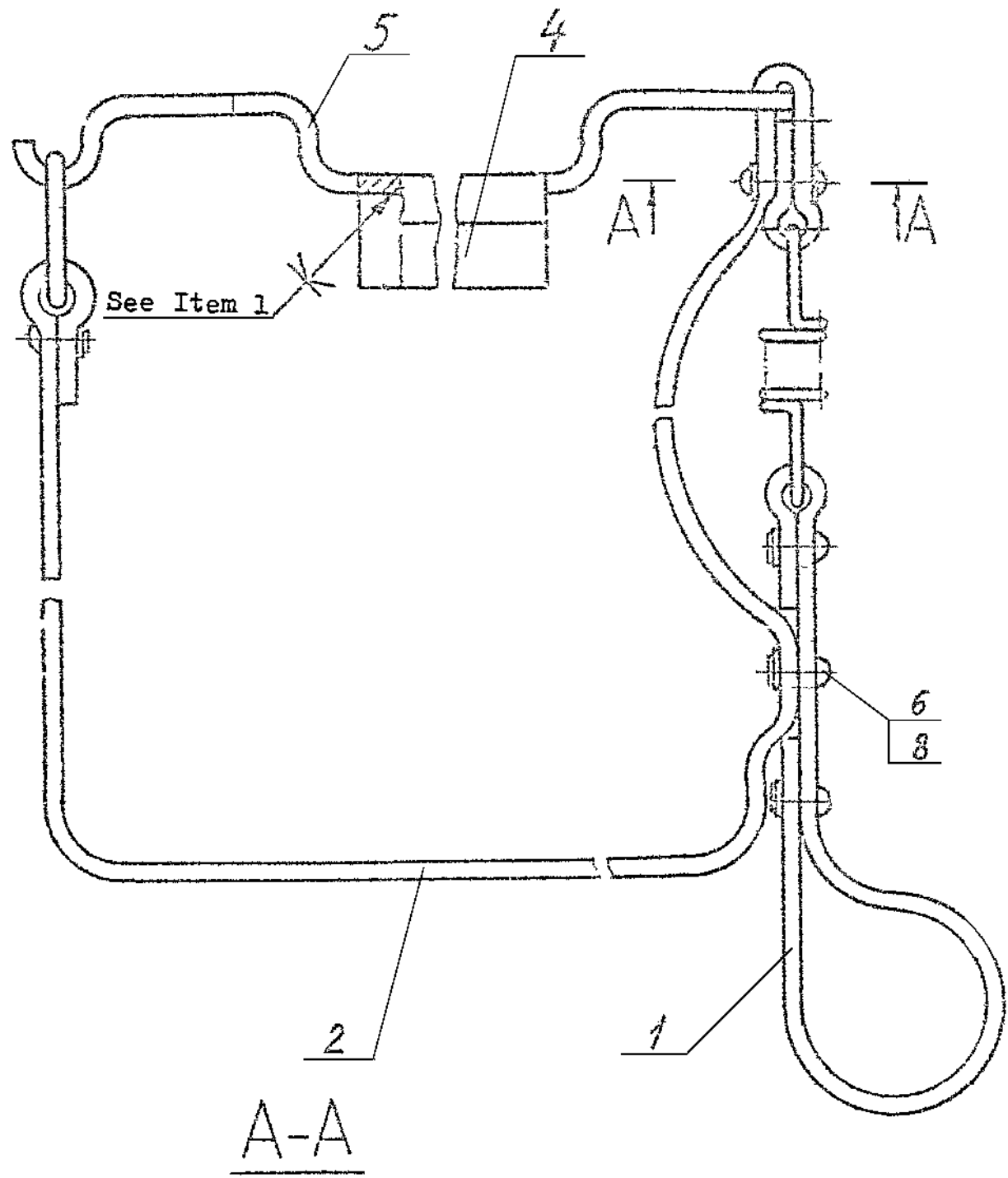
1. Coat the ends of band (4) over a length of 10 mm with phenol-formaldehyde lacquer, mark ЛБС-1, ГОСТ 901-78, and dry them.
2. Not specified limit deviations of sizes are ±2 mm.

APPROVED		<b>675-42-Sb128Sb</b>		
CHECKED				
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>	<b>BELT ASSEMBLY DRAWING</b>	WEIGHT	SCALE	
		0.026	1:1	
		SHT 1	SHTS 1	

No.	Designation	Description	Qty	Remark
		<u>List of Documents</u>		
	675-42-c6129CB	Assembly drawing		
		<u>Assembly Units</u>		
1	675-42-c6127	Belt	1	
2	675-42-c6128	Belt	1	
		<u>Parts</u>		
4	675-42-65	Gasket	1	
5	675-42-67	Strap	1	
		<u>Standard Items</u>		
6		Washer 4.01.019 or 4.02.019	6	
8		FOCT 11371-78 Eyelet, steel, nickel-plated 3X-25	2	
9		OCT 17-600-76 Rivet 3x12.37 FOCT 10299-80	2	

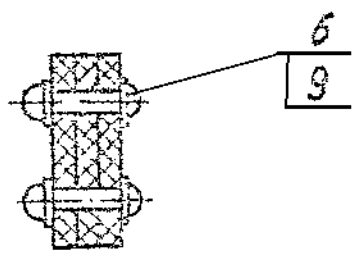
APPROVED		<b>675-42-Sb129</b>		
CHECKED				
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>	<b>BELT</b>		WEIGHT	SCALE
		SHT	SHTS	

675-42-Sb129Sb




1. Use glue 88-III, Specifications TV 38-105540-73.  
 \*(2)

A-A



APPROVED	<i>[Signature]</i>	675-42-Sb129Sb	
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	BELT ASSEMBLY DRAWING	WEIGHT	SCALE
		0.125	1:1
		SHT 1	SHTS 1

Co.	Designation	Description	Qty	Remarks
		<u>List of Documents</u>		
	675-42-c6131CB	Assembly drawing		
		<u>Assembly Units</u>		
1	700-88-c6202	Wire termination		
		<u>Parts</u>		
3	675-42-42	Gasket	1	
4	675-42-70	Cap	1	
5	675-42-73	Cover	1	
7	675-42-74	Housing	1	
9	675-42-76	Gasket	1	
10	675-42-77	Gasket	1	
		<u>Standard Items</u>		
13		Screw ALM2-6gx6.48.016 FOCT 17473-80	4	
(A) 15		Screw BLM3-8h.6hx8.48 016 FOCT 17475-80	2	
19	COUNTERSUNK SCREW M3X8 TO IS: 1365-4-8 PITCH Ø 8 AS PER IS.4218 (PART-III) 76, ZINC PLATED 9 MICROMET THICK	Washer 2T65T05 FOCT 6402-70	4	
		<u>Other Items</u>		
21		Plug PC4TB ABO.364.047 TV	1	Purchased
22		Small-size button K11-I O10.360.011 TV	1	Purchased
23		Lamp GM28-0.05-1 TV 16-535.641-72	1	Purchased

APPROVED		<b>675-42-Sb131</b>		
CHECKED				
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>	<b>START BUTTON</b>		WEIGHT	SCALE
			SHT 1	SHTS 2

No.	Designation	Description	Qty	Remark
24		Lamp $\Phi$ M1-3 ИY0.242.001 ТУ	1	Purchased
26		<u>Materials</u> Wire МТМБ-0.35 mm <sup>2</sup> ТУ 16-505.437-73 $l = 400$ mm	1	
27		Pipe ИИТБ-50-355-2.5 not painted ГОСТ 19034-73 $l = 15$ mm	7	

00353-1CV 21-4-83 <i>BoB</i>	Ⓐ <i>110</i>	IS EQUIVALENT FOR SCREW REF 15 ADDED
DC(I)N. & DATE	ISSUE	NATURE
AMENDMENTS		

APPROVED	<i>[Signature]</i>	<b>675-42-Sb131</b>		
CHECKED	<i>[Signature]</i>			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		<b>START BUTTON</b>		
		SHT 2	SHTS 2	

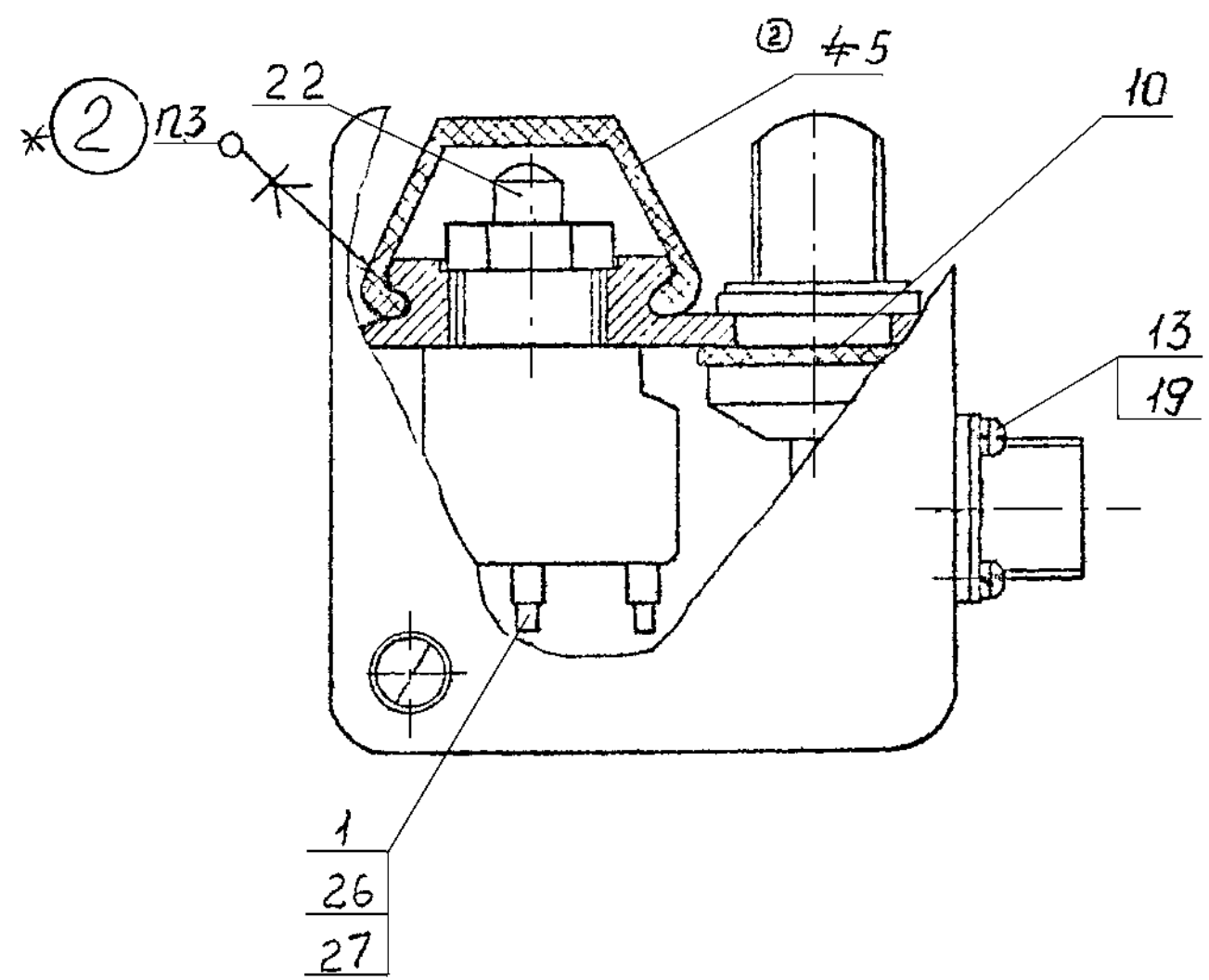
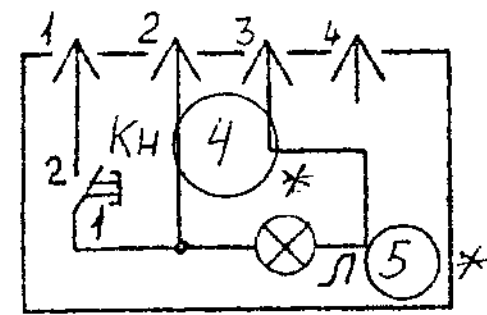


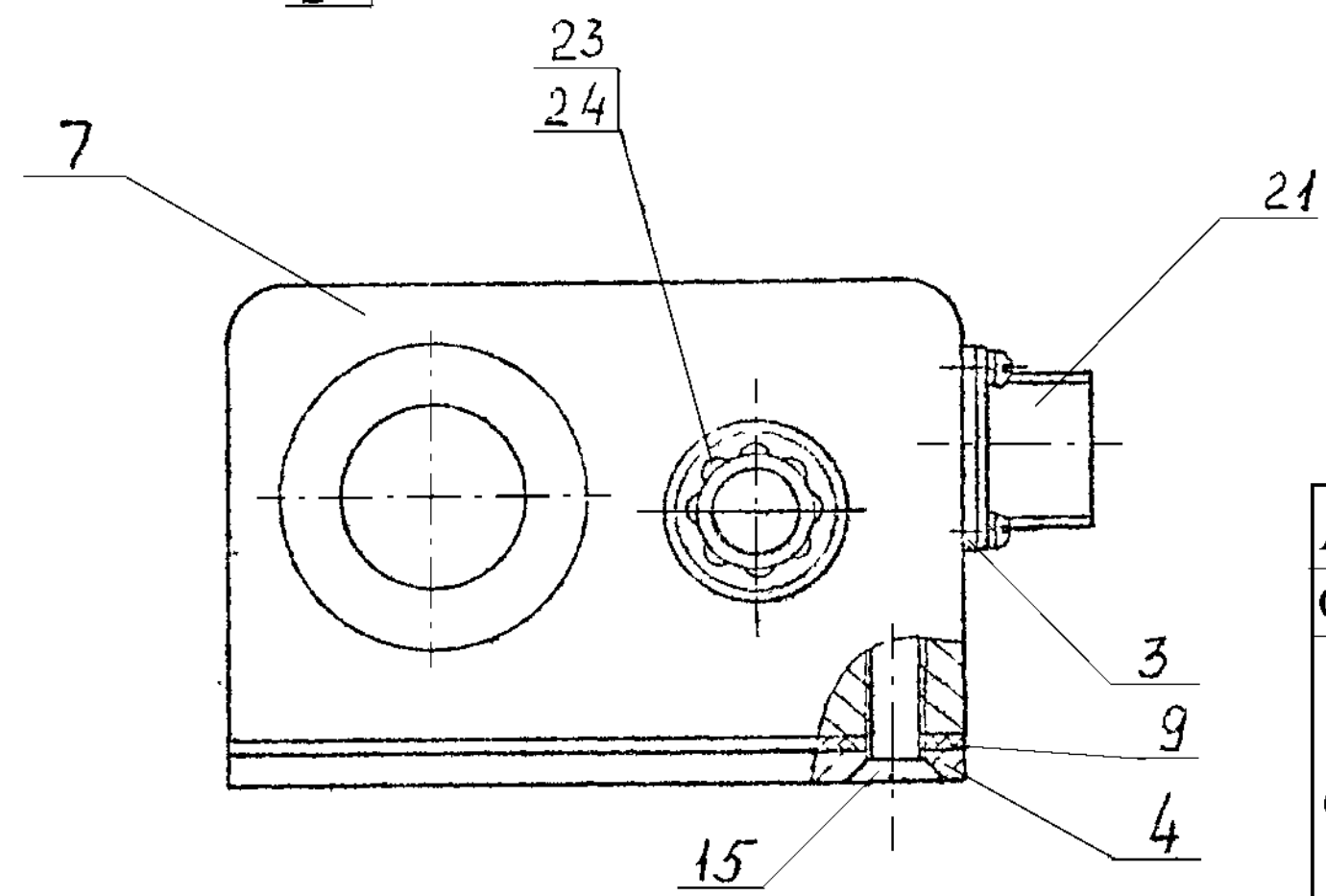
Diagram of soldered connections.



TECH. CONDITIONS

1. Perform wiring according to diagram of soldered connections.
2. Perform wiring by wire (26), solder it with solder Пp.3ПOC61. ГOCT 21931-76. Terminate wire ends (1) according to drawing 700-88-c6202 and fit pipes (27) on both sides.
3. Use glue 88-НП, Specifications ТУ 38-105540-73.
4. Secure screws (13) and a fastening nut of lamp (24) with red enamel ПЭ-223, ГOCT 14923-78.
5. Other requirements for manufacturing and check conform to OCT B3-4048-78.
6. Bend the tab on button (22).


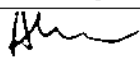
\* (2) See Item 3  
 \* (4) Button  
 \* (5) Lamp





APPROVED	<i>[Signature]</i>	675-42-Sb131Sb	
CHECKED	<i>[Signature]</i>		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	START BUTTON	WEIGHT	SCALE
		0.12	2:1
		SHT 1	SHTS 1

Co.	Designation	Description	Qty	Remark
		<u>List of Documents</u>		
	675-42-c6132CB 675-42-c613233	Assembly drawing Control unit of guidance circuit. Schematic electric circuit diagram		
(A)	675-42-c6132M3	<u>Wiring Diagram</u>		
		<u>Assembly Units</u>		
1	675-42-c6133	Cover	1	
2	675-42-c6135	Strip	1	
3	700-88-c6202	Wire termination	22	
		<u>Parts</u>		
5	675-42-78	Casing	1	
6	675-95-145	Nut	1	
8	675-42-84	Gasket	1	
9	BK8.649.000A	Canvas cover	1	
		<u>Standard Items</u>		
12		Screw ALM2-6gx6.48.016 FOCT 17473-80	8	
13		Screw BLM3-8h6hx12.48.016 FOCT 17473-80	4	
14		Screw Bl.M4-8h6hx12.48.016 FOCT 17475-80	4	
17		Washer 2x1.01.019 or 2x1.02.019 FOCT 11371-78	8	

77	A	12-2-87
NO	ISSUE	DATE
AMENDMENTS		

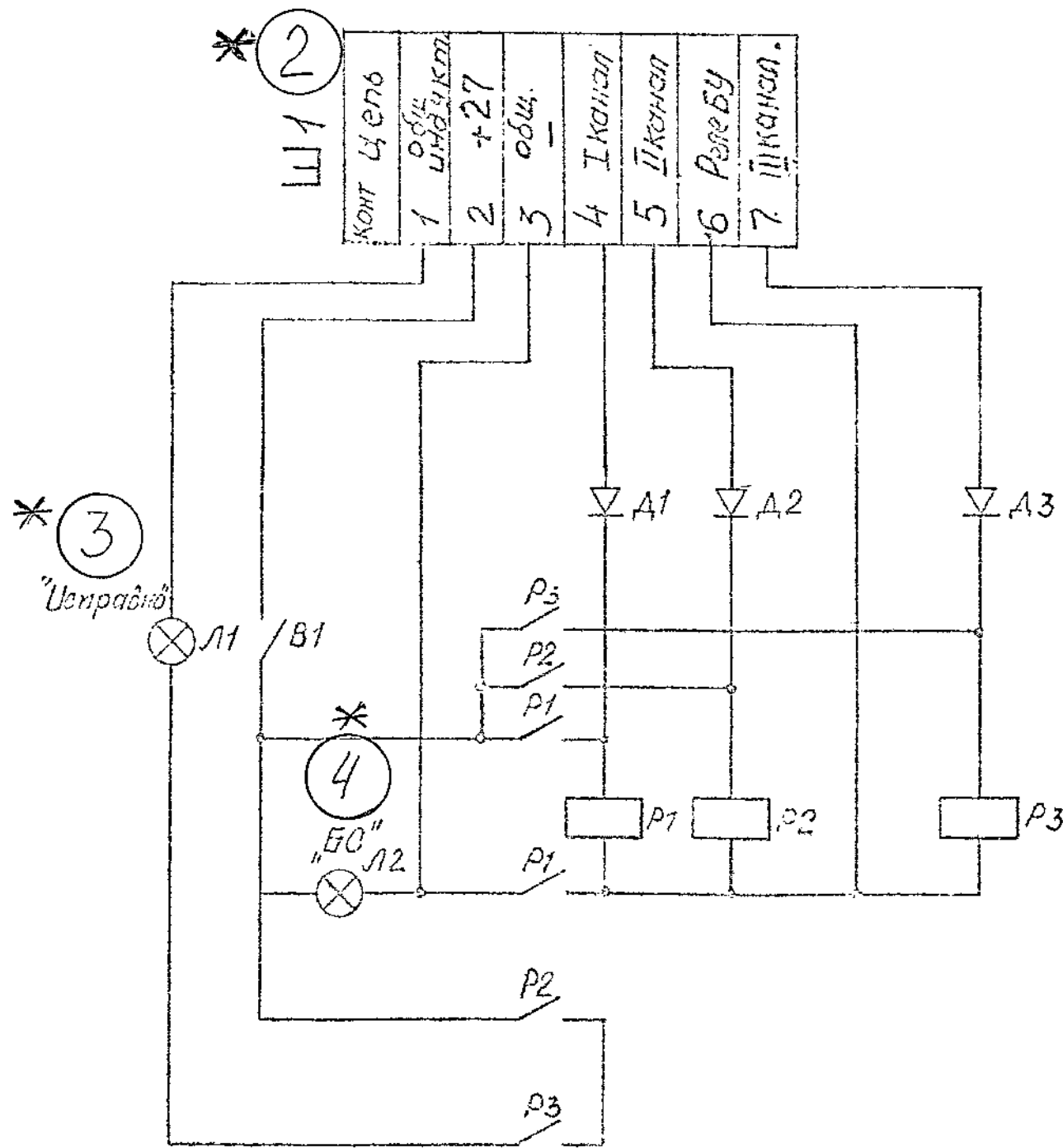
APPROVED		<b>675-42-Sb132</b>		
CHECKED				
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>		<b>CONTROL UNIT</b>		
			SHT 1	SHTS 2

Co.	Designation	Description	Qty	Remark		
18	EQ MAT.C-30 TO IS:1570-79	Washer 3.01.019 or 3.02.019 FOCT 11371-78	4	(Ref. DC(1) 00957-ICV)		
19		Washer 2T65T05 FOCT 6402-70	8			
20		Washer 3T65T05 FOCT 6402-70	4			
22		Ring 014-018-25-2-2 FOCT 9833-73	1			
<u>Other Items</u>						
24		Plug 2PM22B10M1B1 TPO.364.126 TV	1		Purchased	
25		Toggle switch TIC BPO.360.007 TV	1		Purchased	
26		Lamp CM28-0.05-1 TV 16-535.641-72	2		Purchased	
27		Lamp ΦM1-K HO.242-004	2		Purchased	
28		Relay P3C48B PC4.590.201 RPO.450.033 TV	3		Purchased	
<u>Materials</u>						
30	Pipe IIITB-50-355 not painted FOCT 19034-73 2.5: $l = 15$	24				
31	4.5: $l = 15$	20				
32	Wire MPMB-0.35 mm TV 16-505-437-73 $l = 1 \text{ m}$	1				

APPROVED		<b>675-42-Sb132</b>		
CHECKED				
<b>CONTROLLERATE OF QUALITY ASSURANCE (ICV)</b>		<b>CONTROL UNIT</b>		
			WEIGHT	SCALE
		SHT 2	SHTS 2	

TECH. CONDITIONS

Designation	Description	Qty	Remarks
Л1...Л3	Diode Л220А CM3.362.041 TV	3	
Р1...Р3	Relay РЭС48Б РС4.590.201 ЯПО.450.033 TV	3	
Л1, Л2	Lamp CM28-0.05-1 TV 16-535.641-72	2	
В1	Toggle switch Т1С ВР0.360.007 TV	1	
И1	Plug 2PM22Б10И1В1 ГЕ0.364.126 TV	1	



(2)\* И1

Contact	Circuit
1	Common induc.
2	+27 V
3	Common
4	I Channel
5	II Channel
6	Control unit relay
7	III Channel

\* (3) SERVICEABLE

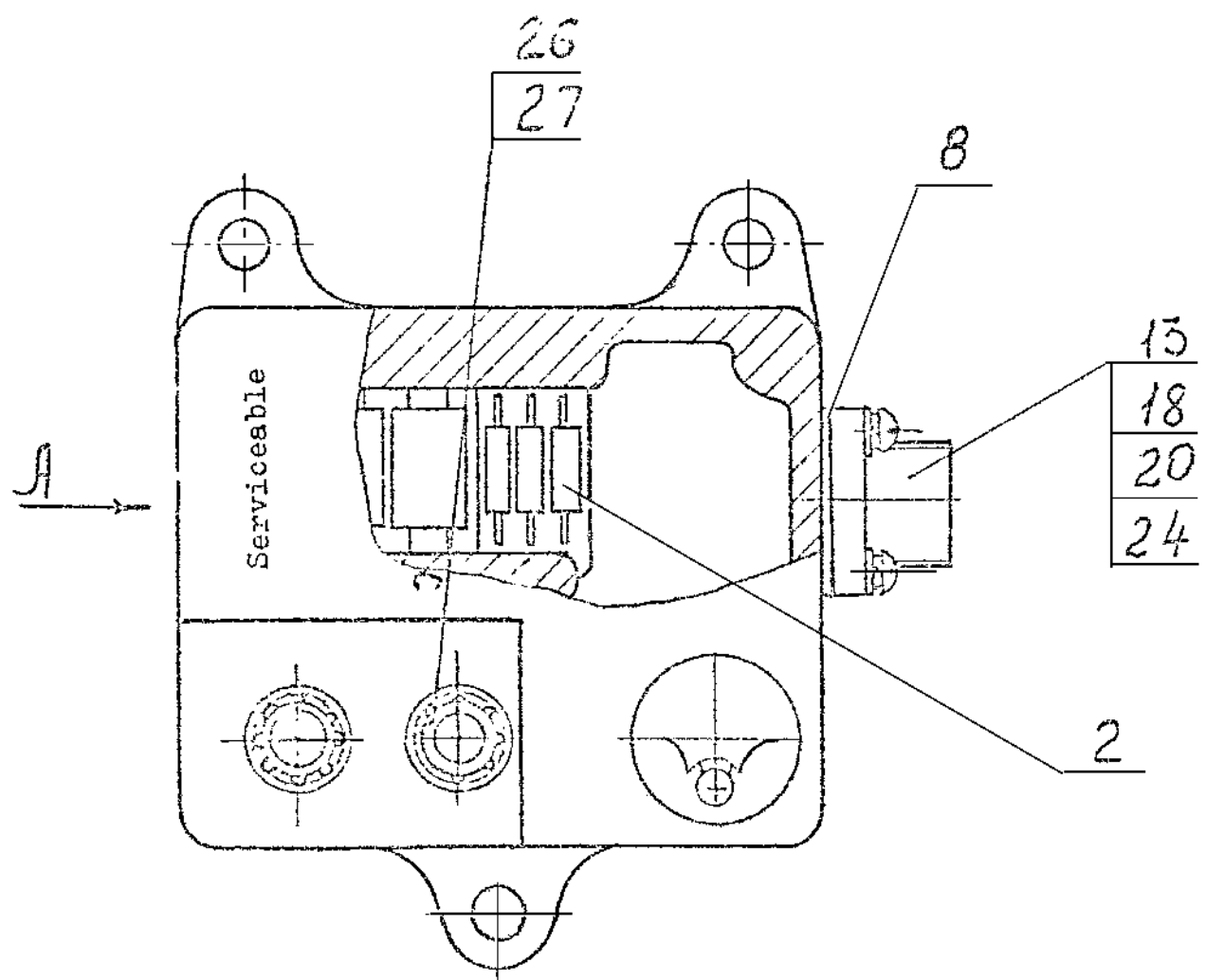
\* (4) MAINS

APPROVED	<i>[Signature]</i>	<b>675-42-Sb13233</b>			
CHECKED	<i>[Signature]</i>				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		CONTROL UNIT OF GUIDANCE CIRCUITS SCHEMATIC CIRCUIT DIAGRAM		WEIGHT	SCALE
				SHT	SHTS

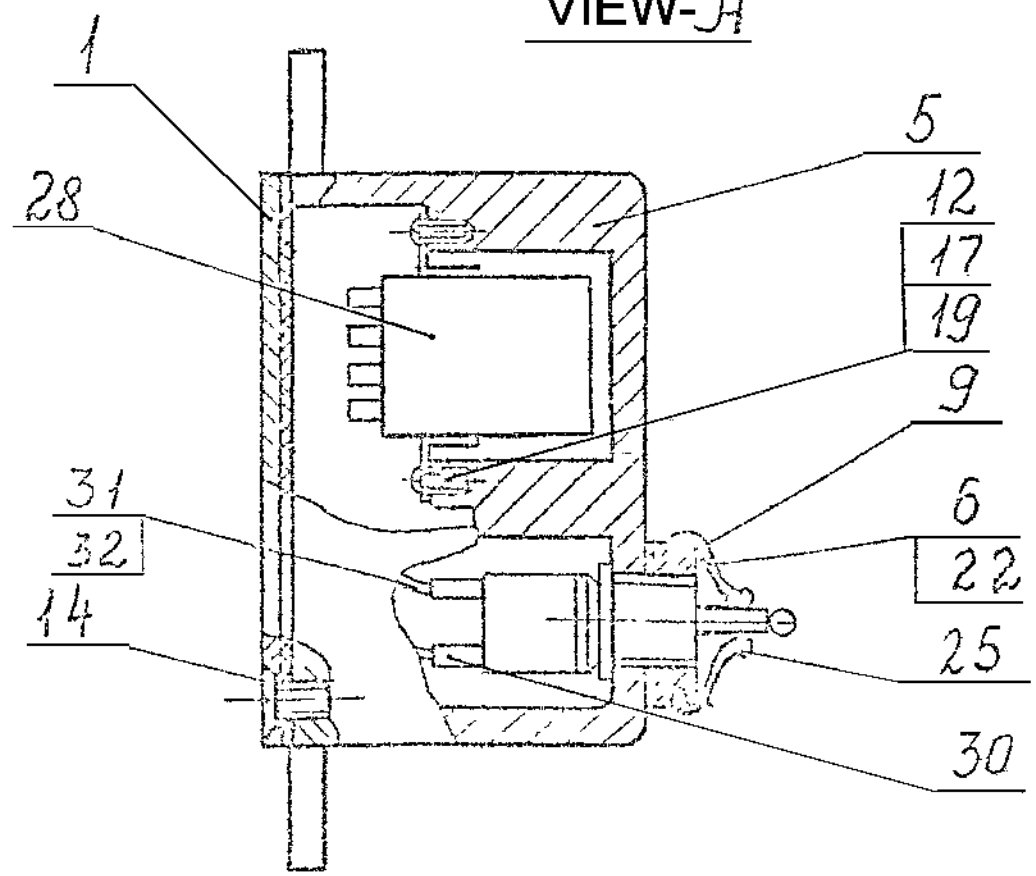


TECH. CONDITIONS

1. Perform wiring according to schematic circuit diagram 675-42-c6132 93.
2. For wiring use wire (32), solder with solder Пр.3 ПOC61, ГОСТ 21931-76. Terminate the ends of wires (3) according to diagram 700-88-c6202. Fit pipe (30) to contacts with one wire, and pipe (31) to contacts with two wires.
3. When installing toggle switch (25), do not use washer and nut.
4. Secure screws (13, 14) and a nut fastening lamp (27) with red enamel ПЭ-223, ГОСТ 14923-78.
5. For other requirements for manufacturing and check, see OCT B3-4048-78.
6. Check the control unit for proper functioning.

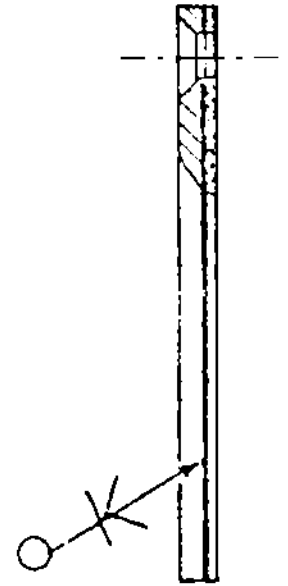
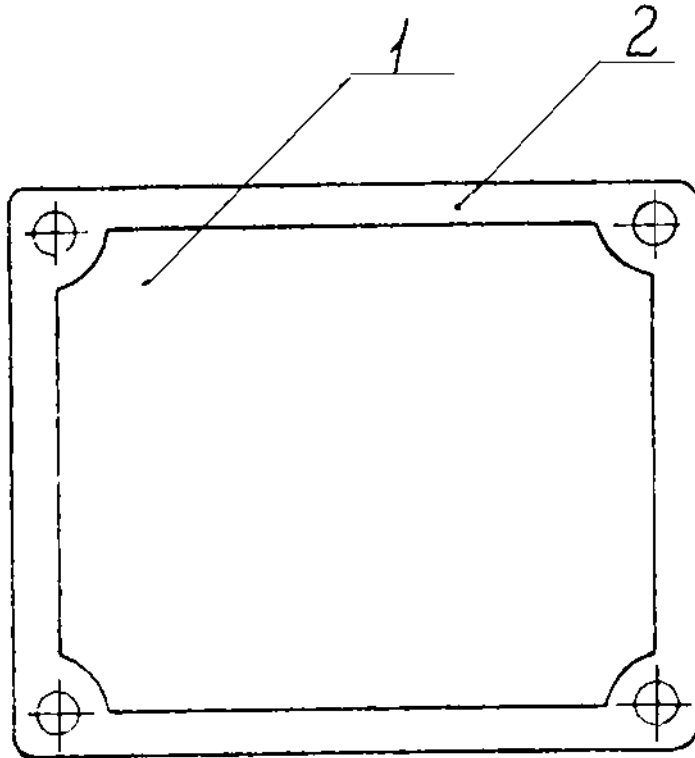


VIEW-A



APPROVED		<b>675-42-Sb132Sb</b>	
CHECKED			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	<b>CONTROL UNIT</b>	WEIGHT	SCALE
		0.504	1:1
		SHT	SHTS

675-42-Sb133



Glue 88-НП, Specifications TV 38-105540-73

Ref. No.	Designation	Description	Qty	Remarks
1	675-42-79	Cover	1	
2	675-42-80	Gasket	1	


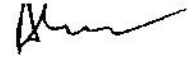
APPROVED *[Signature]*  
 CHECKED *[Signature]*  
 CONTROLLERATE  
 OF  
 QUALITY ASSURANCE  
 (ICV)

675-42-Sb133

COVER

	WEIGHT	SCALE
	0.06	1:1
SHT	SHTS	

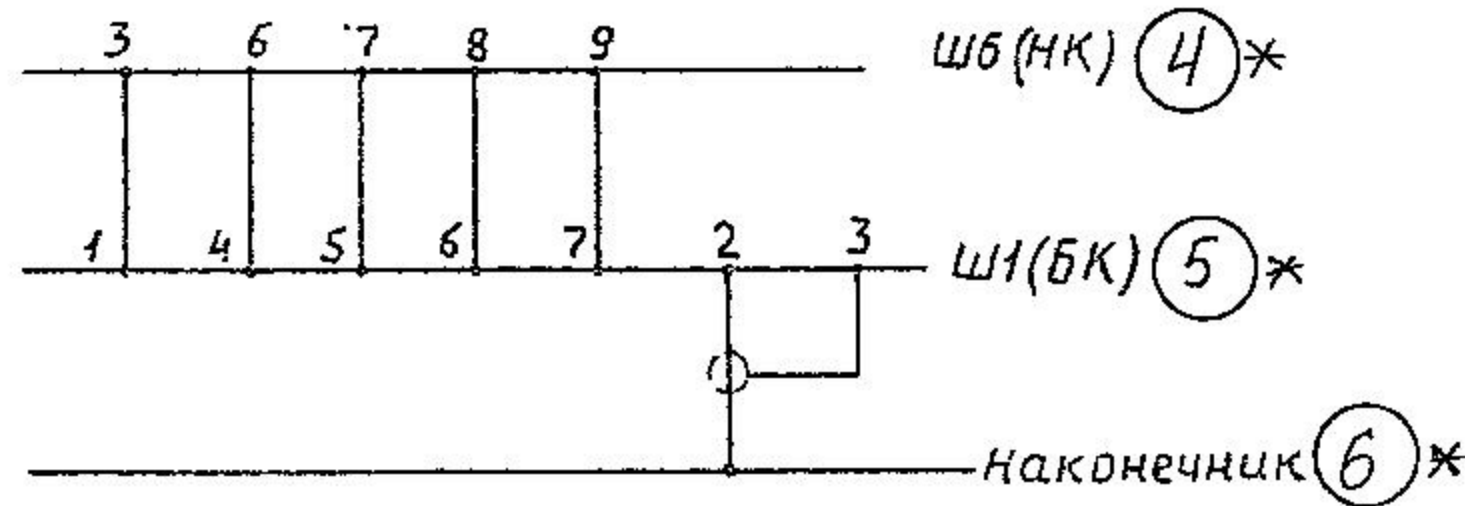
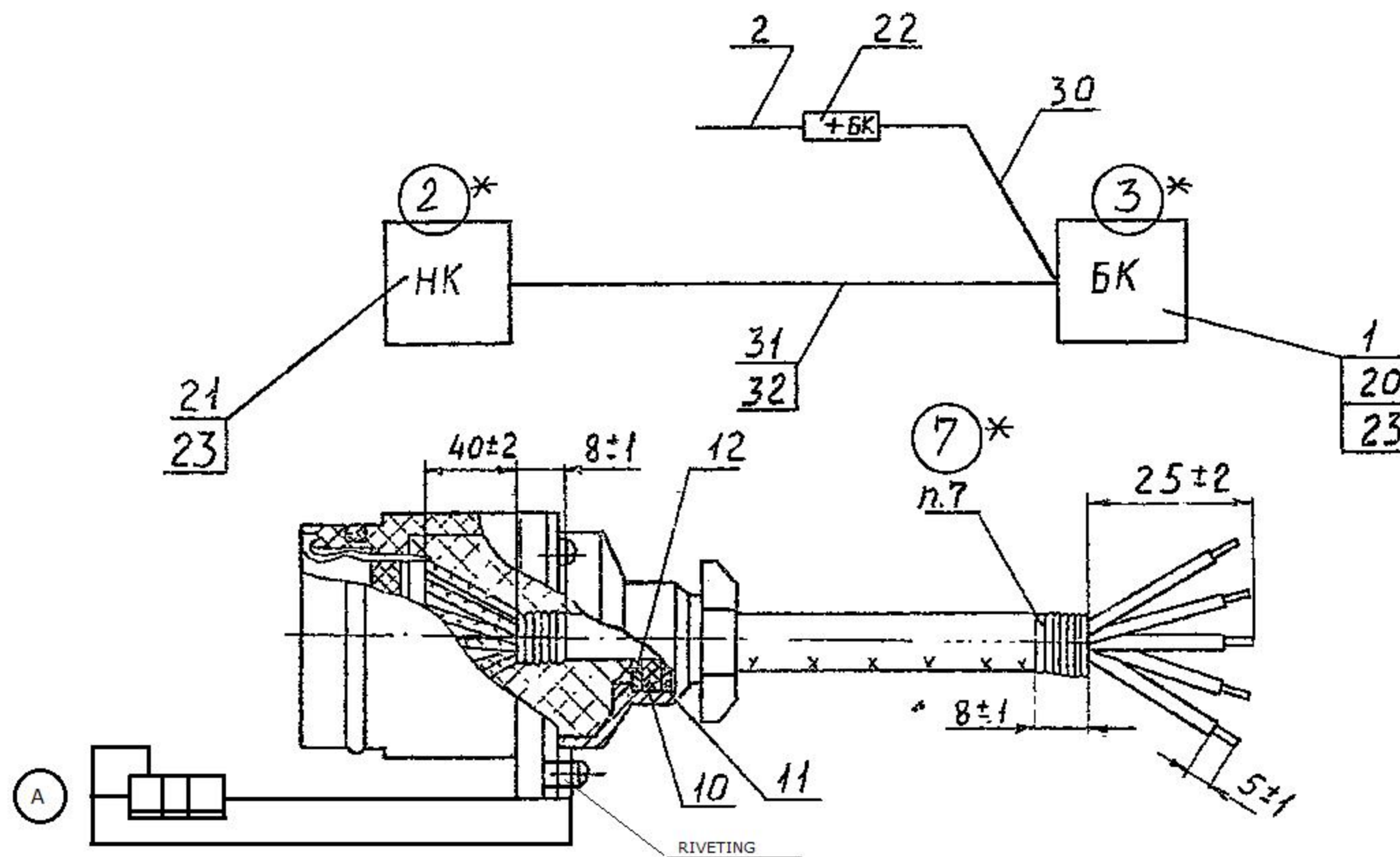
No.	Designation	Description	Qty	Remark
	675-42-c6134CB	<u>List of Documents</u> Assembly drawing		
		<u>Assembly Units</u>		
1	700-88-c6202	Wire termination	1	
2	700-88-c6212-05	Wire termination	1	
		<u>Parts</u>		
10	675-97-60-15	Bushing	1	
11	675-97-61-16	Washer	18	
12	700-42-41	Ring	1	
13	10 P1-9 135-000	GUIDE	1	(A)
		<u>Other Items</u>		
20		Socket 2PM22KTH10P1B1 PEO.364.126 TY	1	Purchased
21		Connector socket 10HP1-9P135.000	1	Purchased
22		Collar MKA-25 Normal 95	1	
23		Collar MKA-50 Normal 95	2	
		<u>Materials</u>		
30		Wire ENB130.5 TY 16-505.911-76 l = 2080 mm	1	
31		Cable KMH3 5 TY 16-505.232-77 l = 1040 mm	1	
32		Braiding HMD3.0x16 TY 22-3708-76 l = 1000 mm	1	

APPROVED		675-42-Sb134		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		CABLE ASSEMBLY	WEIGHT	SCALE
			SHT	SHTS

TECH. CONDITIONS

1. Specifications for manufacturing, marking, check, testing, packing, storage and shipment conform to OCT B3-4048-78.
2. When terminating wire (30), as shown in Ref. No. 1, make a hole in the wire shield at a distance of 35 mm from its end, and push the wire through this hole. Solder the shield in jack 3 of control unit connector.
3. When assembling connector (21), secure threaded surfaces with glue БФ-4, ГОСТ 12172-74.
4. Fill the inner space of connector (21) with sealant "Vicsint Y-1-18", Specifications ТУ 38.103.420-76. Perform filling according to Instructions O53.252.64.00003 using underlayer И-11.
5. Fill space between cable bundle and nut of connector (21) with compound K-115, Specifications ТУ 6-05-1251-75. Perform filling according to Instructions O53.252.64.00002.
6. Solder cable conductors to connectors with the aid of solder Пр3 НОС61, ГОСТ 21931-76 according to Specifications 700-88-3 ТУ.
7. Impregnate a binding made of black cotton glossy threads No. 00, ГОСТ 6309-80, of HK connector with phenolformaldehyde lacquer, mark ЛЕО-1, ГОСТ 901-78. Wind light-blue band ВРХ 15x0.20, of 1st grade, ГОСТ 16214-70, under thread binding.

- \* (2) Guide
- \* (3) Control unit
- \* (4) И6 guide
- \* (5) И1 control unit
- \* (6) Pin connector
- \* (7) See Item 7



A Guide added in assembly drg & part list which was not shown earlier. For GUIDE Ref. Spec NO.10 P1-9 135-000

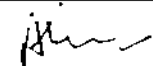
DCI NO ISSUE

NATURE OF AMENDMENT

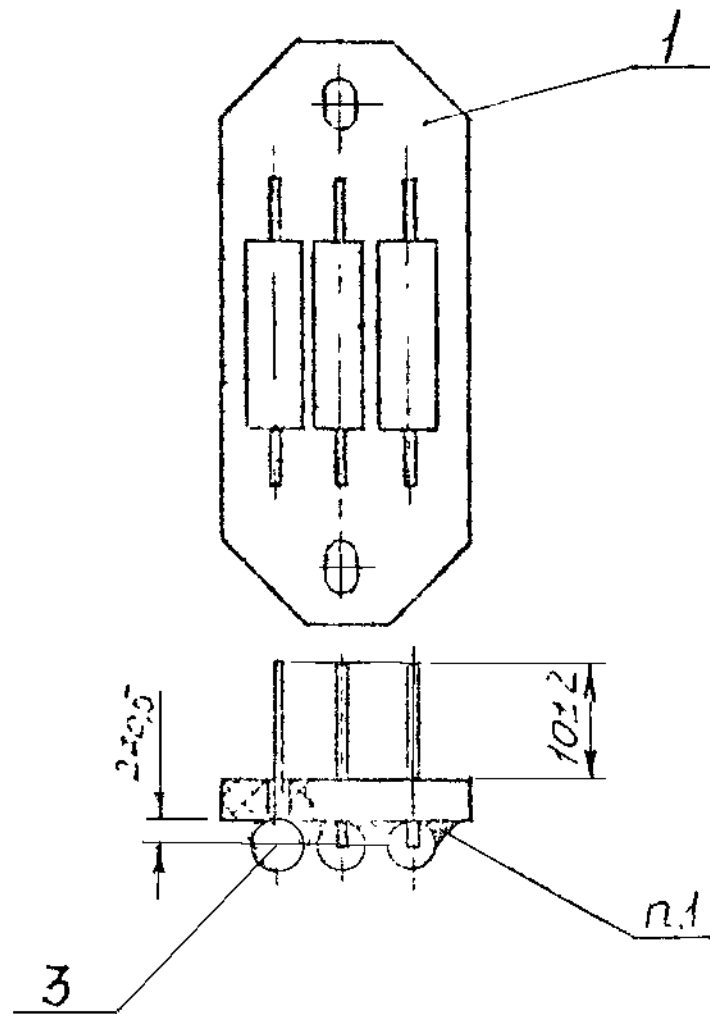
JWM/PDO

APPROVED		675-42-Sb134Sb		
CHECKED				
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	CABLE ASSEMBLY OF CONTROL UNIT	WEIGHT	SCALE	
		0.24	1:1	
		SHT	SHTS	

No.	Designation	Description	Qty	Remark
		<u>List of Documents</u>		
	675-42-c6135CB	Assembly drawing		
		<u>Parts</u>		
1	675-42-82	Strip	1	
		<u>Other Items</u>		
3		Diode 1220A CM3.362.041 TY	3	Purchased

APPROVED		675-42-Sb135					
CHECKED					STRIP		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)			WEIGHT	SCALE			
			SHT	SHTS			

675-42-Sb135Sb



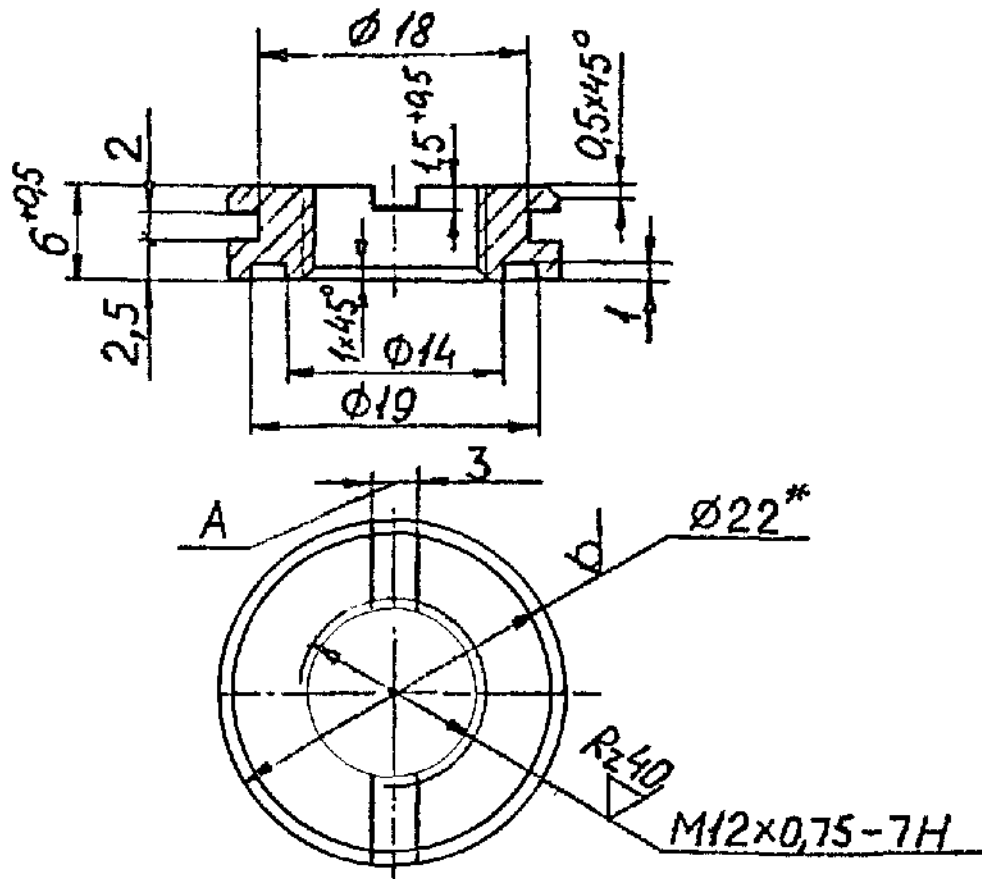
TECH. CONDITIONS

1. Use compound K-115, Specifications TV 6-05-1251-75.
2. Perform filling according to Instructions 053.252.64.00002.
3. Compound protrusion beyond the element bodies is 3 to 5 mm.

APPROVED	<i>[Signature]</i>	675-42-Sb135Sb		
CHECKED	<i>[Signature]</i>			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		STRIP	WEIGHT	SCALE
			0.009	2:1
			SHT	SHTS

675-95-145

Rz 80 (✓)



**TECHNICAL CONDITIONS**

1. Material-substitute is steel 45, ГОСТ 1050-74.
2. Coating: 11.6xp. (zinc plating followed by chromate treatment, zinc coat of 6 microns thick). Remove hydrogen embrittlement.
3. Unspecified limit deviations of sizes are as follows: holes according to  $A_7$ ; shafts according to  $B_7$ ; other values according to  $CM_8$ .
4. The surface of slot A may have a burr caused by thread cutting.
5. When making grooves, bear in mind that a radius of 3 mm, max., is permissible.

APPROVED

CHECKED

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

675-95-145

NUT

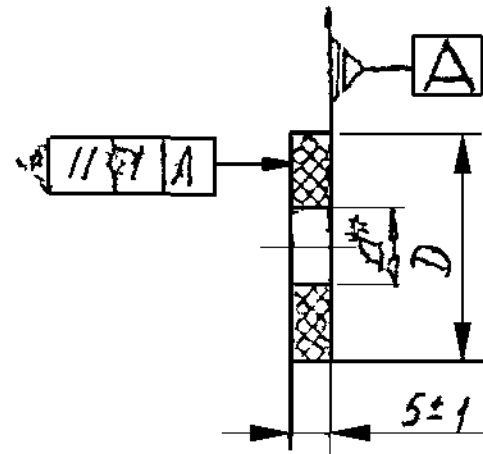
ROUND BAR  $\frac{22-5, \text{GOST } 7417-75}{20-B, \text{GOST } 1051-73}$

WEIGHT SCALE

0.015 2:1

SHT 1 SHTS 1

09-26-929



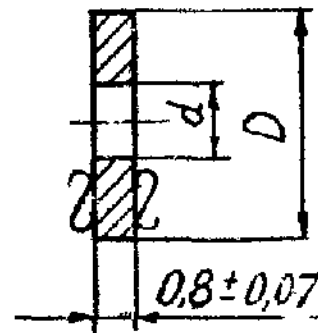
**TECHNICAL CONDITIONS**

1. <sup>H</sup>Sizes are ensured by tools.
  2. Apply a mark to the tag.
  3. For the other requirements, see Specifications TY 005216-75 for the article of code 418260
- Note. It is permissible to use rolled-up stock, 20 to 28 mm long, as a blank for part 675-97-60

lot no	Designation	d <sup>H</sup>	Dev	D	Dev	Connector	Mass
1	675-97-60	3,5	±0,2	8	±0,2	PC4	0,00023
2	-01	5					0,00018
3	-02	3,5		10		PC7	0,00004
4	-03	4					0,00037
5	-04	6					0,00029
6	-05	3,5		11		PC10	0,00049
7	-06	6					0,00038
8	-07	8					0,00025
9	-08	6		13		PC19	0,00006
10	-09	8					0,00047
11	-10	10					0,00031
12	-11	8		15		PC32	0,00073
13	-12	10					0,00057
14	-13	12					0,00037
15	-14	6		19		PC50	0,00147
16	-15	8					0,00137
17	-16	10					0,00118
18	-17	12					0,00098
19	-18	14					0,00074
20	-19	16					0,00047

APPROVED		<b>675-97-60</b>	
CHECKED	MR. K. T. ... 10/12/51		
CONTROLLERATE OF QUALITY ASSURANCE (ICV)	<b>BUSHING</b>	WEIGHT	SCALE
		SEE TABLE	
		SHT 1	SHTS 1
		RUBBER 51-2059, TY 005216-75	

19-26-929



\* ① Зачесенцы не допускаются  
2. Покрытие Ц9Хр.

**TECHNICAL CONDITIONS**

1. Burrs not allowed
2. Coating: Zinc plating 9 <sup>MICRONS</sup> thick and chromotise

Ref No	Designation	d	DEV	D	DEV	Connec-tor	Mass
1	675-97-61	3,5	8		PC4	<del>0,00250</del>	0,00023
2	-01	5,5				<del>0,00167</del>	0,00017
3	-02	3,5	10	-0,20	PC7	<del>0,00430</del>	0,00043
4	-03	4,5				<del>0,00394</del>	0,00040
5	-04	6,5				<del>0,00285</del>	0,00029
6	-05	4	11		PC10	<del>0,00520</del>	0,00052
7	-06	6,5				<del>0,00382</del>	0,00038
8	-07	8,5				<del>0,00235</del>	0,00024
9	-08	6,7	13	-0,24	PC19	<del>0,00613</del>	0,00061
10	-09	8,7				<del>0,00462</del>	0,00046
11	-10	10,7				<del>0,00269</del>	0,00027
12	-11	8,7	15		PC32	<del>0,00736</del>	0,00074
13	-12	10,7				<del>0,00545</del>	0,00053
14	-13	12,7				<del>0,00315</del>	0,00032
15	-14	7	19	-0,28	PC: 0	<del>0,01639</del>	0,00164
16	-15	9				<del>0,01380</del>	0,00138
17	-16	11				<del>0,01190</del>	0,00119
18	-17	13				<del>0,00945</del>	0,00095
19	-18	15				<del>0,00670</del>	0,00067
20	-19	16	<del>0,00515</del>	0,00052			

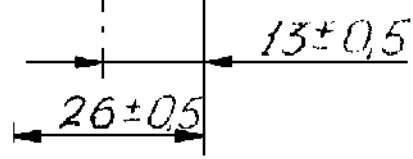
APPROVED		675-97-61		
CHECKED	MR. K. T. ... 10/12/51			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		WASHER	WEIGHT	SCALE
			SEE TABLE	
STEEL 10, GOST 1050-74		SHT 1 SHTS 1		

675-97-74

$S6 \pm 1,0$


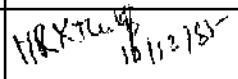
$\phi 43 \pm 1$

2 HOLES  $\phi 10 \pm 1$



TECHNICAL CONDITIONS

1. Material-substitute is rubber, group I, TY 38-105867-75.
2. Hour-glass shape of circles is permissible

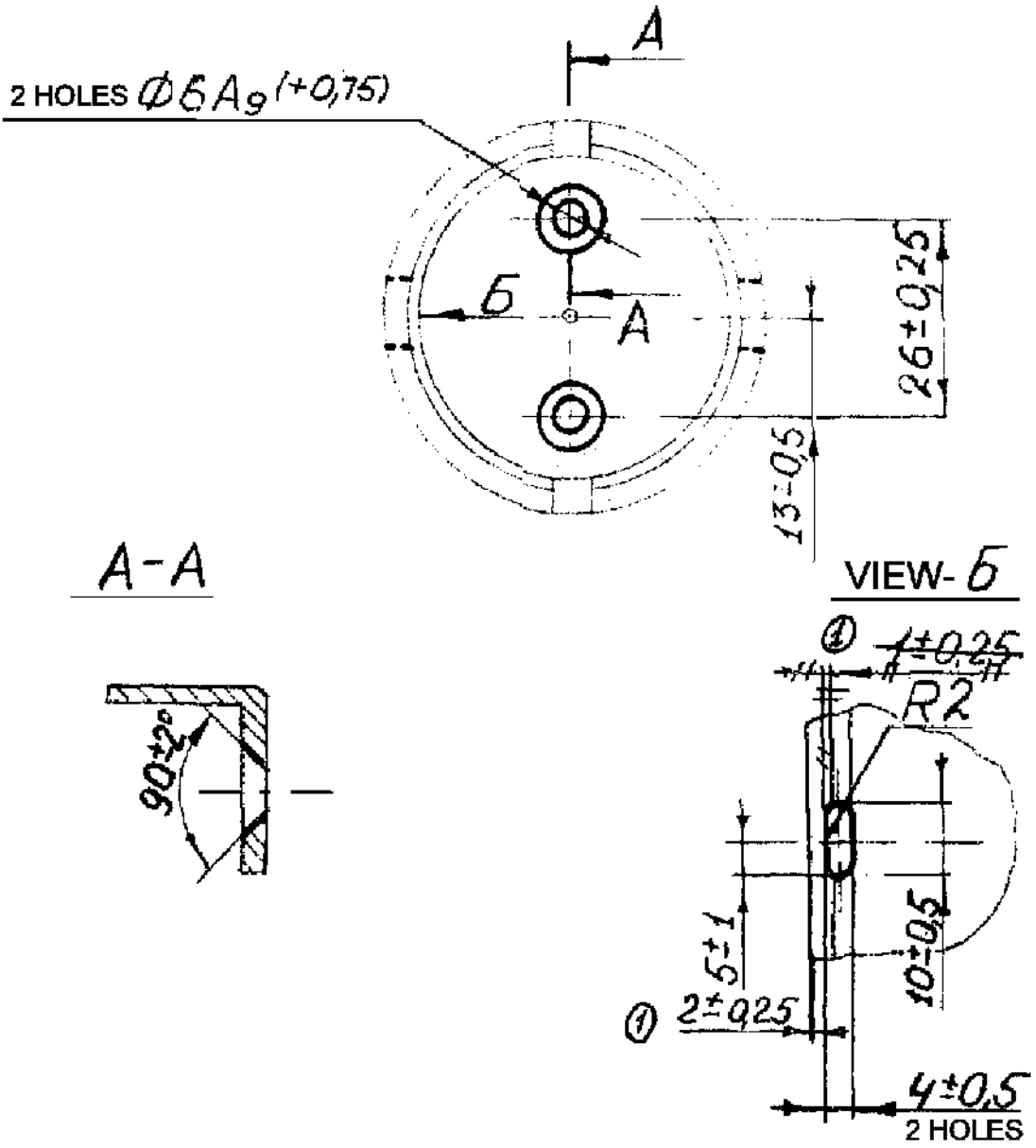
APPROVED   
 CHECKED   
 CONTROLLERATE  
 OF  
 QUALITY ASSURANCE  
 (ICV)

675-97-74

GASKET

RUBBER Group-II, TY 38-105867-75

WEIGHT	SCALE
0.005	1:1
SHT 1	SHTS 1



TECHNICAL CONDITIONS

Coating: anodic oxidation with subsequent bichromate treatment or electrolessly phosphated one (blue)

APPROVED

CHECKED

*[Signature]*  
10/12/85

675-97-75

CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

BLANK PLUG

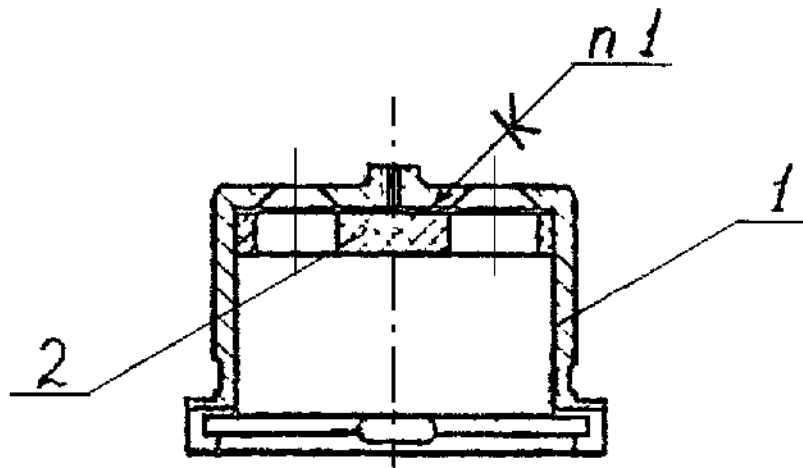
WEIGHT SCALE

0.047 1:1

SHT 1 SHTS 1

BLANK PLUG (VENDER ITEM) DELIVERED  
ACCORDING TO 10nP1-9n135.000 Sb

675-97-Sb196



Make use of cement 88-HH TV-38-105540-73

Ref. No.	Designation	Description	Qty	Remark
		<u>Parts</u>		
1	675-97-75	Blank plug	1	
2	675-97-74	Gasket	1	

APPROVED

CHECKED

HRK/...  
10/12/85

675-97-Sb196

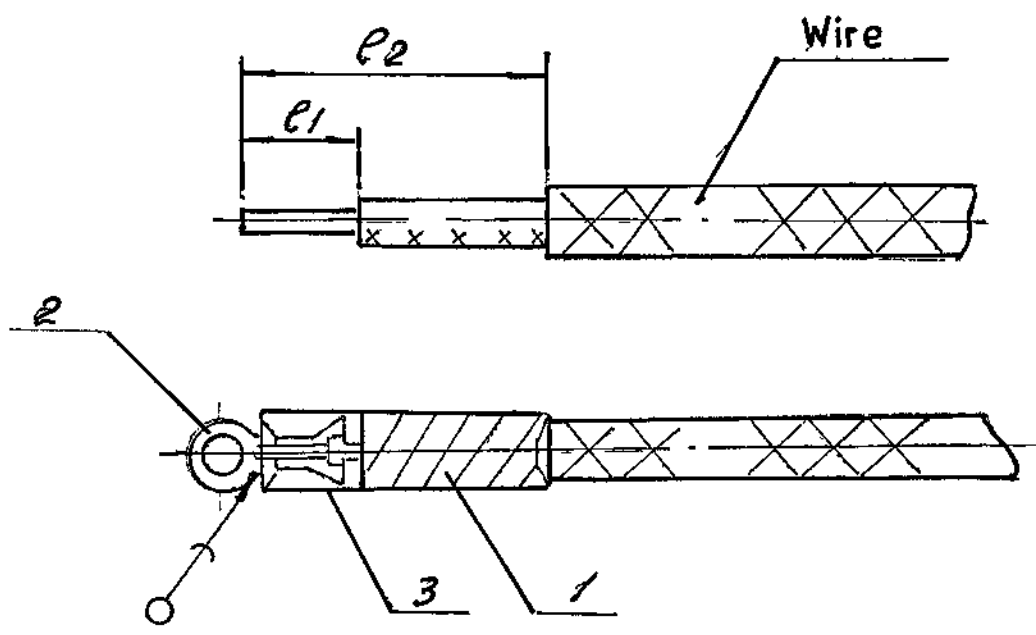
CONTROLLERATE  
OF  
QUALITY ASSURANCE  
(ICV)

**BLANK PLUG**  
(ASSEMBLY DRAWING)

WEIGHT SCALE

0.053 1:1

SHT 1 SHTS 1



1. Place order for wire as per specifications of groups, wherein the given assembly is used.
2. Carryout termination and soldering of wire into lugs as per 700-88-3TT
3. Ref.nos with sign\* are referential.

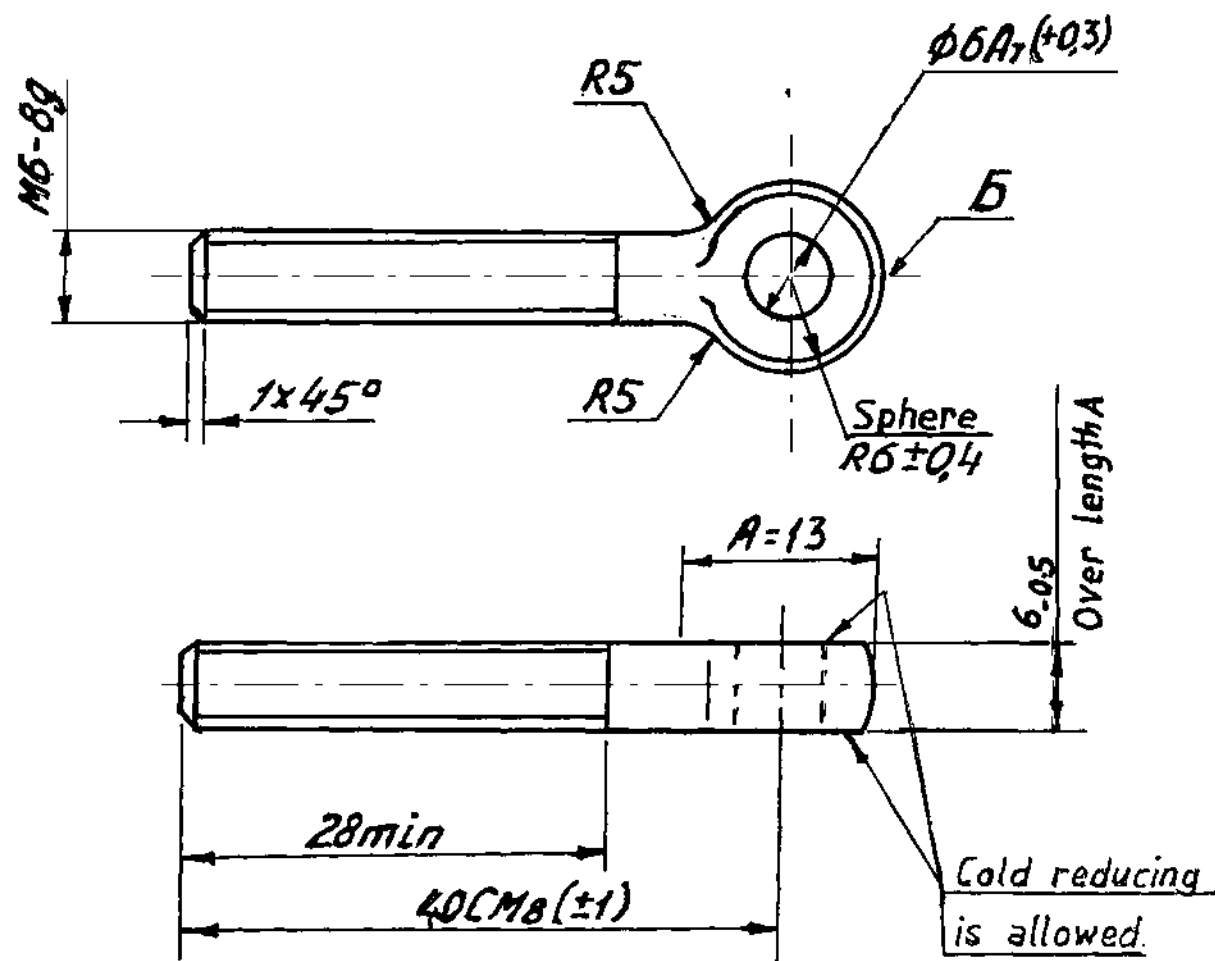
Designation	Ref. No.s		Sizes, mm		weight in kg	Remarks	
	2	3	l <sub>1</sub>	l <sub>2</sub>			
	Lug standard 304	Unpainted sleeve TB-50-355 GOST 19034-73					
700-88-c6 212 c6	HIK-2,5x3,2	5	l=30	5	20	0,0013	B
-01	HIK-2,5x7	4,5	l=30	5	20	0,0036	B
-02	HIK-3x4,2	5	l=30	8	25	0,0016	B
03	HIK-4x4,2	5	l=30	8	25	0,0016	B
-04	HIK-4x5,3	6	l=30	10	25	0,0027	B
-05	HIK-1,5x3,2	3,5	l=30	5	20	0,0009	B
-06	HIK-4,5x3,2	4,5	l=120	5	110	0,0027	B
-07	HIK-2,5x3,2	5	l=100	5	80	0,0027	B
-08	HIK-2,5x7	5	l=30	5	20	0,0036	B
-09	HIK-2,5x3,2	6	l=30	5	20	0,0013	B

700-88-c6 212 c6


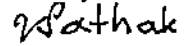
SNO	SHT	DOC NO	SIGN	DATE
	DRAWN	PRASAD		3 12 84
	EDT,CHKD	A R DUBOY		6 12 84
	F/M,DC.	S-R NAIK		6 12 84
	DIV.OFFR	T.R BANERJEE		18 12 84
		NAME	SIGN	DATE

WIRE TERMINATION  
ASSEMBLY DRAWING

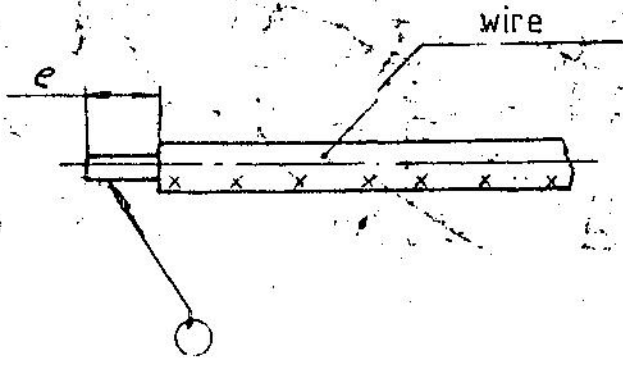
SHEET	WEIGHT	SCALE
		CM
TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYD-PAB'D		



1. Alternate material is Steel cm3cn, GOST 380-71 and Steel 10, 15, 25, GOST 1050-74, Steel 15Г and 20Г, GOST 4543-71.
2. The thread may be made by rolling without chamfer at the rod end. In this case, diameter of the non-threaded portion should be equal to angle diameter of thread.
3. An area not exceeding  $\phi 2\text{mm}$  and 0.5mm height is allowed on surface B.
4. Bolt may be made as per the dash-dotted-line.
5. Coating Chemical parkering accelerated, chromatizing, impregnation with preservation oil K-17 GOST 10077-76. Zinc-plating, 9 microns thick, chromatizing is allowed. Remove hydrogen embrittlement.
6. Non-machined sections are allowed on the spherical surf. 2.

APPROVED	 M VASU	700-28-669		
CHECKED	 R Pathak			
CONTROLLERATE OF QUALITY ASSURANCE (ICV)		BOLT	WEIGHT	SCALE
			0.013	2:1
		STEEL 20 GOST 1050-74	SHT	SHTS

700-88-c6202



1. Carryout wire termination as per 700-88-3TT
2. Place order for wire as per specifications of GROUPS WHEREIN THE GIVEN ASSEMBLY IS USED

Designation	Size, mm	Remarks
700-88-c6202	7	
-01	10	

008024CV 16-8-2000	Sn 40 Sb TO IS: 193-82 ADDED AS EQ. MATERIAL	EQ. MATERIAL ADDED.	NATURE OF AMENDMENT
00769 -1CV V. Ramesh	(B)	(A)	ISSUE
27 3-2000			DATE

Format	Zone	Ref. No.	DESIGNATION	DESCRIPTION	QTY.	REMARKS
				Material		
				Solder 100 40		
				GOST 2030-76		

- (A) EQ. MATL:- SOFT SOLDER Sn 40 TO IS: 193-82.
- (B) EQ. MATERIAL:- Sn 40 Sb TO IS: 193-82

APPROVED	<i>M. VASU</i>	700-88-c6 202 6		
CHECKED	V. D. PATHAK		WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)	WIRE TERMINATION	SHT	ENTS	
		16	of 28	
			63	



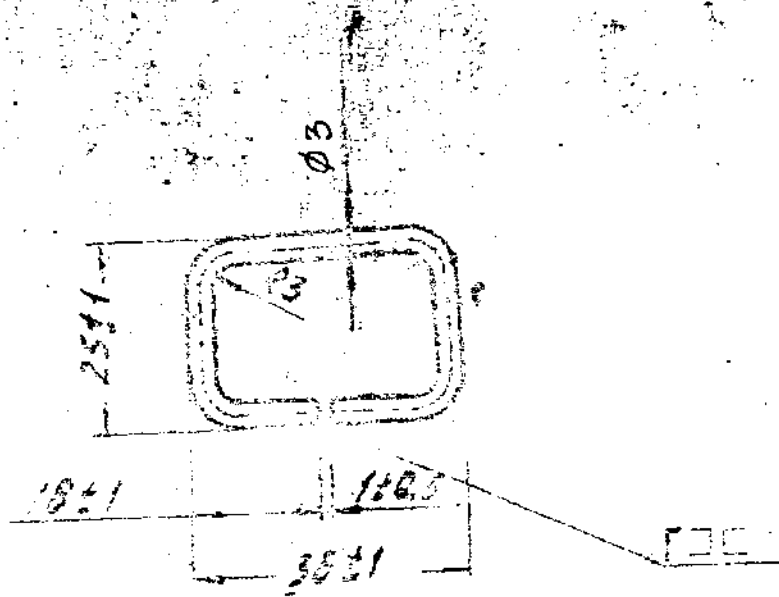
FORMAT	ZONE	REF. NO.	DESIGNATION.	DESCRIPTION.	QTY	REMARKS
			Variable data for modifications			
				700-88-C212		
				Miscellaneous items		
				Lug		
				HIK-2.5x3.2		
				Standard 304	1	
				Material		
		3		Un painted sleeve		
				III TB-50-355-5		
				GOST19034-73 $l=30$	1	
				700-88-Cb212-01		
				Misellaneous items		
		2		Lug		
				HIK-2.5x7		
				Standard 304	1	
				Material		
		3		Un painted sleeve		
				III TB-50-355-4.5		
				GOST19034-73 $l=30$		

APPROVED	<i>[Signature]</i> H VASU	700-88-CB-212	
CHECKED	<i>[Signature]</i> Rathak		
CONTROLLERATE OF INSPECTION (ICV)		WIRE TERMINATION	
		WEIGHT SCALE	
		SHT 2 SHTS 6	

FORMAT	ZONE	REF. NO.	DESIGNATION.	DESCRIPTION.	QTY	REMARKS
				700-88-CB212-02,		
		2		Miscellaneous items,		
				Lug		
				HIK-3x4,2.		
				Standard 304	1	
				Material		
		3		un-painted sleeve		
				III TB-50-355-5		
				GOST19034-73. $l=30$	1	
				700-88-CB212-03		
				Miscellaneous items		
		2		Lug		
				HIK-4x4,2		
				Standard 304	1	
				Material		
		3		Unpainted sleeve		
				III TB-50-355-5		
				GOST19034-73. $l=30$	1	
				700-88-CB212-04		
				Miscellaneous items		
		2		Lug		
				HIK-4x5,3		
				Standard 304	1	

APPROVED	<i>[Signature]</i> H. VASU	700-88-CB212	
CHECKED	<i>[Signature]</i> Pathak		
CONTROLLERATE OF INSPECTION (ICV)		WIRE TERMINATION	
		WEIGHT	SCALE
		SMT 3	SMTS 6

427

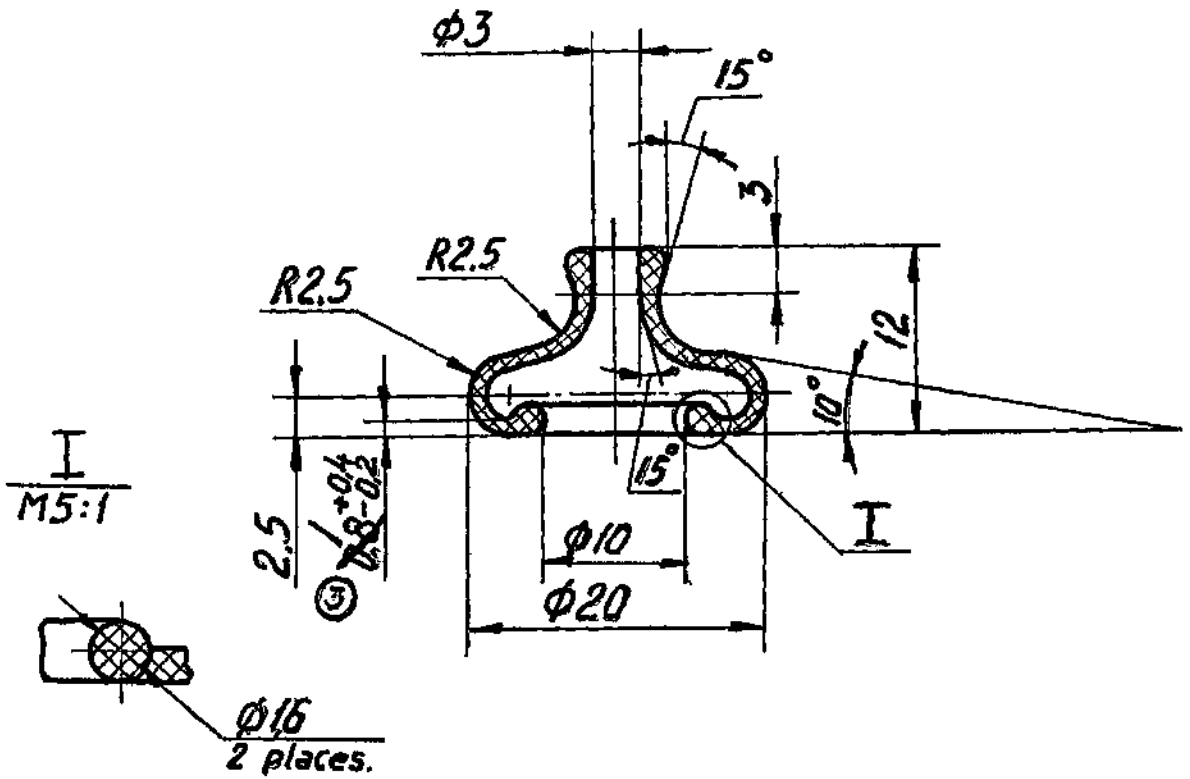


1. Dress welds flush.
2. Coating: Chemically parkerized, oiled.
3. Alternate material is steel cm3cn GOST 380-71 and 15,20 and 25 GOST 1050-74.

215 OF 289

APPROVED		765-94-224		
CHECKED		FRAME	WEIGHT	SCALE
CONTROLLERATE OF INSPECTION (ICV)			0,001	1:1
		SMT	SHTS	215 OF 289
		WIRE 3-10 GOST 17305-71 94		

БК8649.000А



1. Dimensions are provided with tools.
2. Shoulder of up to 0.8mm is allowed along parting line of mould.
3. Mark on label
4. Remaining technical requirements are as per TY.005.216-75.
5. Variation in wall thickness is allowed within the limits of tolerances.

Восстановлен с. 0020/11/11/11

71  
I-648

БК8.649.000А

COVER				SHEET	WEIGHT	SCALE.
				5 0,001 2:1		
Rubber 1847 TY 005.216-75.				TOTAL SHEETS		
ORDNANCE FACTORY PROJECT HYDERABAD						
SNO	SHT	DOC NO	SIGN	DATE		
DRAWN		R.H.PRASAD.		7.12.84		
EDT,CHKD		B. Sankar	[Signature]	11.12.84		
F/M,DC.		S.R.NAIR.	[Signature]	12.12.84		
DIV.OFFR		T.K.BANERJEE	[Signature]	14.12.84		
		NAME	SIGN	DATE		