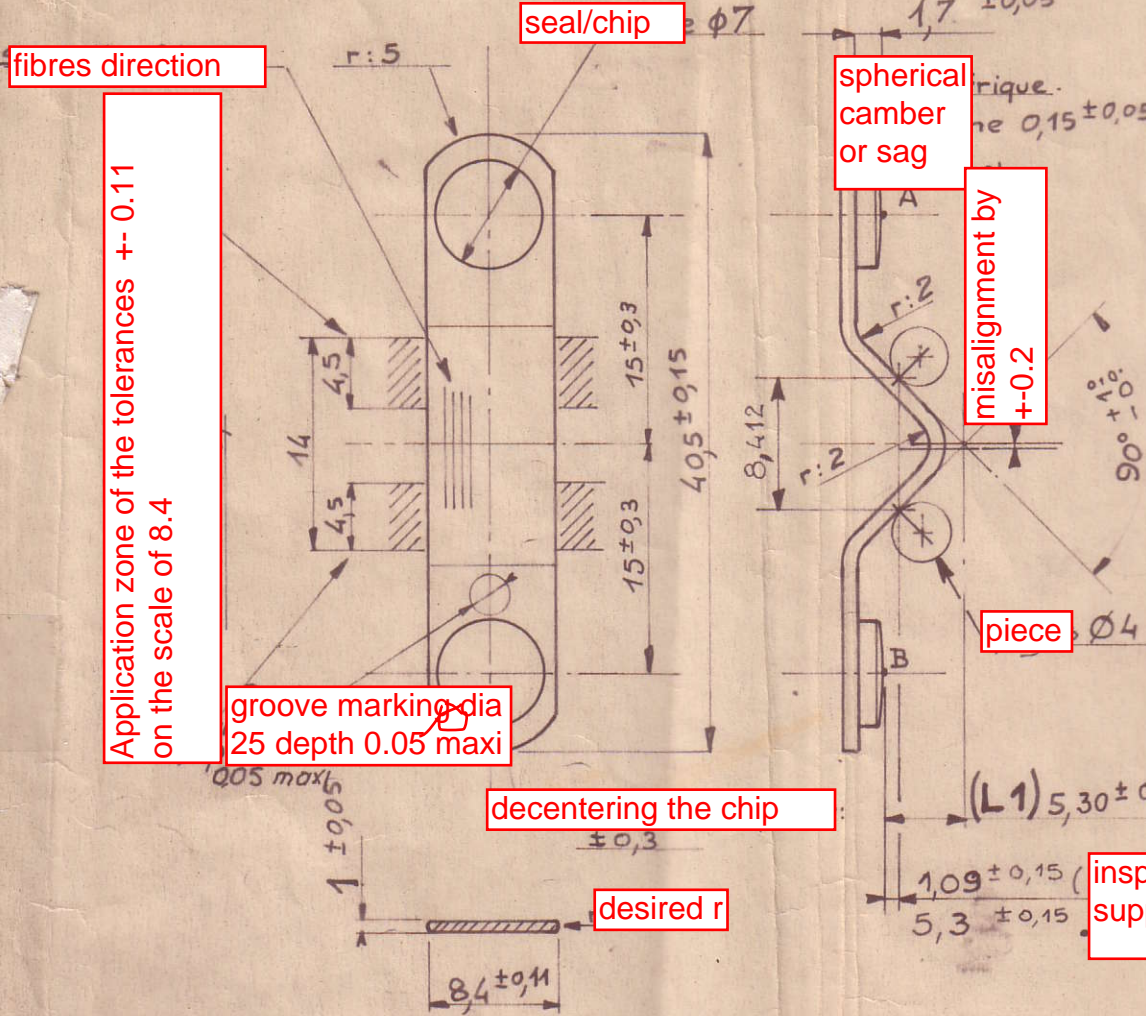


Standard Solutions



Application zone of the tolerances +/- 0.11 on the scale of 8.4

groove marking dia 25 depth 0.05 maxi

decentering the chip

desired r

spherical camber or sag

misalignment by +0.2

piece

inspection side for support piece in A and B

- Note: 1. The mark L1 which precedes the tolerance dimensions refer to the functional test 443900A2
 2. No ray or mark of tool after bending in the zone which include the interior of the side having 30
 3. Process condition for heat treatment of supports/ contacts to be referred from test certificates received from manufacturer

or

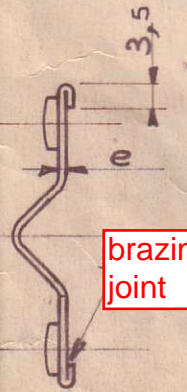
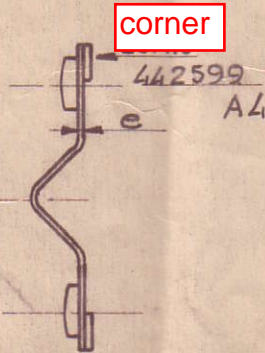
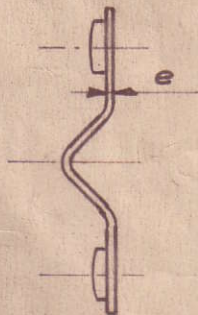
other possible solutions

$$1,2 \geq e > 1$$

$$0,8 \leq e \leq 1$$

reported corners

filled corners



corner

brazing in the joint

Remarks

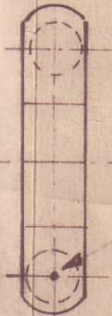
exclusively in Cu.Cr

Cracks

Materials support	disk/Pastille Materials	Mounting method	State of the material when delivering.	Thermal treatment during mounting	Final Characteristics
drawing no.358051 UN2Be u: copper n: nickel Be: beryllium UN2Be	drawing no.358047 AgCdo	Brazing HF	Tempered cold-worked 1/4 hardness 100.13- HV30 Resistivity 5to $8 \times 10^{-8} \Omega \text{ m}^2/\text{m max}$	Nitrogen tempering R for 1h at 475-480°	Hardness 205 +-35 HV30 Resistivity 4to $10^{-8} \Omega \text{ m}^2/\text{m max}$
	drawing no.358025 AgCdo	or Brazing by resistance	idem	idem	idem

Cuivre au Chrome	Brasage HF ou Soudure électrique	Trempe. écroui Dureté: 100-120 HV30 Resistivité: $4 \text{ à } 5 \cdot 10^{-8} \Omega \text{ m}^2/\text{m}$	Revenu en Azote R 1h à 450°	Dureté 125 HV30 mini Resistivité: $2,5 \cdot 10^{-8} \Omega \text{ m}^2/\text{m}$
		— id —	idem	— id —

Sub -Assembly



putting the supplier identification mark on the back of the support and in the axis or bolt of the disk.
(no protusion allowed)

CENTRAL PLANS
LE VALDREUIL
- 8. JUL. 1985
DOSSIER :

Contact disks : Cadmium Oxide silver

CO-precipitated or diffused

according to the following specification QF 2805

		351/2/97	28/2/97	R&D
K	Note S.No 3 added	28232	28.7.82	BP
J	material UK3Be replaced by UN2Be	28113	28.1.82	ILL
I	Mark added in groove depth 0,05max	26277	8.5.82	PM
H	Modification during coding or identification	26254	31.03.82	PM
G	Modification during coding or identification	25811	7.2.80	BP
F	diminished disk thickness 1.75 to 1.7 +0.05	25304	9.11.79	H. Ledaire
E	Updating	24341	2.3.78	BP
D	added control dimension 1.04 +-0.15 (this plan becomes sub-assembly: supression of the support material chromium copper. 90°angle +- 1° Suppressed dimension 7 to 15	24296	1e 7.10.77	H. Ledaire
C	Added TT in the 2nd case of assembling by electrical welding	23736	1e 1.12.75	PR
B	Commencing Ev7 0-> Ind A	23691	1e 4.7.75	PR
A				

VOIR INSTRUCTION DE CONTROLE

Index	Modification	Note number	Date	emetteur
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Material : See table Weight Thermal treatment Surface protection

tumbling

Invest: 2AB30 Dossier Contactors LC1D50,635,638EUA-H2BD90A7 Mobile Power contact 063 sp358707

done by verified by Date Scale Format

VAYRE 31.7.72 2 et 1 A3



442578