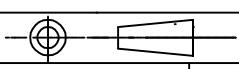
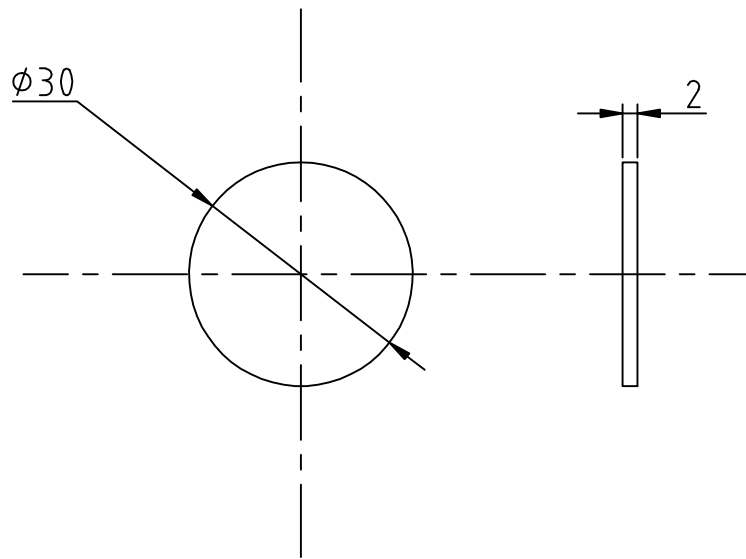


PROCESS :- FABRICATION

SECTION AA

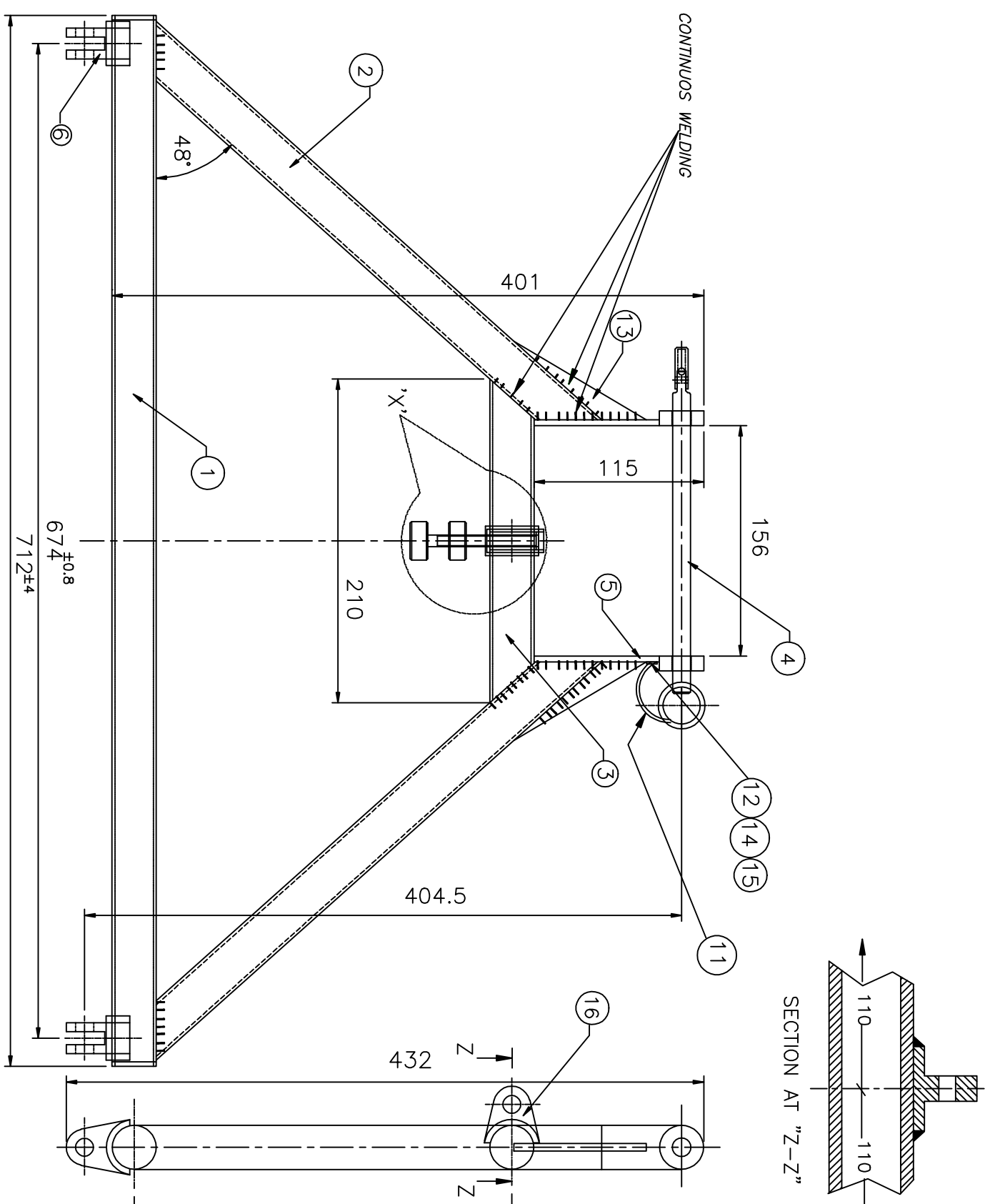
Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:-NTS		QTY:- 1 No.	A D R D E AGRA	DRN.	SK SHARMA	PROJ.OFFR./GP.OFFR.		
DIMENSIONS IN mm			GROUP:- HDS	CHKD.	JC DUTTA			
TOL.:- IS:2102 (Pt-I) 1993 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED			<p style="text-align: center;">SHEET MAIN FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)</p>			PROJ. DIR.		
MATERIAL:- ALUMINIUM. ALLOY SHEET 64430 (HE30) T6 (WP) COND. IS :738-1994						APPROVED		
FINISH:- AS PER ANNEXURE 'B'(GREY) AS PER SHEET No. 40						GROUP DIR.		
HEAT TREATMENT:-						DRG. NO. ADRDE/1407-01-08		



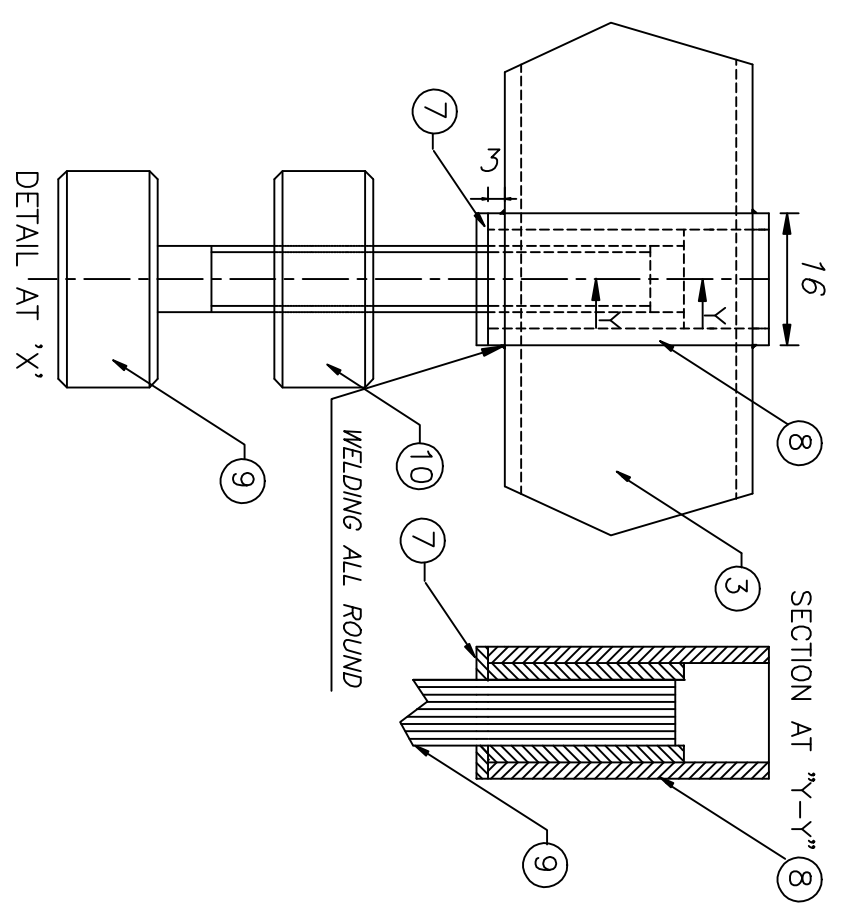


PROCESS :- FABRICATION

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:-1:1	QTY.:- 1 No.		A D R D E AGRA	DRN.	SK SHARMA	PROJ.OFFR./GP.OFFR.		
DIMENSIONS IN mm			GROUP:- HDS	CHKD.	JC DUTTA	PROJ. DIR.		
TOL.:- IS:2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED			<p style="text-align: center;">ROUND PLATE MAIN FRAME PARA FRAME SMALL (HD SYSTEM FOR AN 32 A/C)</p>			APPROVED		
MATERIAL:- MS SHEET						GROUP DIR.		
FINISH:- AS PER SHEET No. 40						DRG. NO. ADRDE/1407-01-09		
HEAT TREATMENT:- 32±5HRC								



ITEM NO	DRG/SPECN. NO.	NOMENCLATURE	SHEET NO	QTY
16	ADRDE/1407-02-14	TOP BRACKET	31	1
15	IS: 3063	SPRING WASHER M3	—	1
14	IS: 6101-1971	PAN HEAD SCREW A M 3X16	—	1
13	ADRDE/1407-02-13	GUSSET	30	2
12	ADRDE/1407-02-12	ARMING WIRE CLIP	29	1
11	ADRDE/1407-02-11	ARMING WIRE	28	1
10	ADRDE/1407-02-10	NUT	27	1
9	ADRDE/1407-02-09	SCREW	26	1
8	ADRDE/1407-02-08	SLEEVE	25	1
7	ADRDE/1407-02-07	THREADED BUSH	24	1
6	ADRDE/1407-02-06	MOUNTING BRACKET	23	2
5	ADRDE/1407-02-05	PLATE VERTICAL	22	2
4	ADRDE/1407-02-04	PIN SUB ASSEMBLY	16-21	1
3	ADRDE/1407-02-03	PIPE SMALL	15	1
2	ADRDE/1407-02-02	PIPE MEDIUM	14	2
1	ADRDE/1407-02-01	PIPE LONG	13	1



CONTINUOUS WELDING :- AS SPECIFIED ON SHEET NO. 2

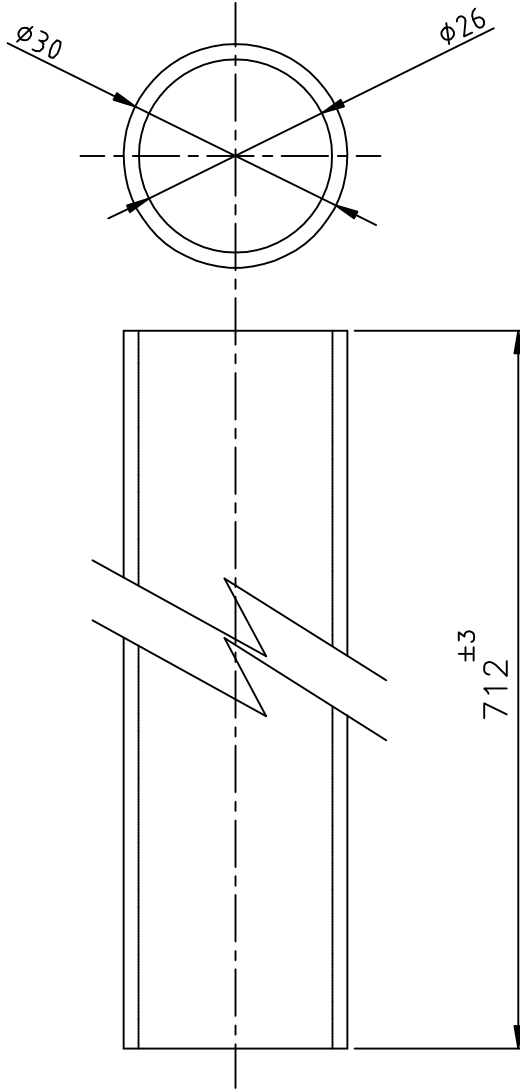
REF. NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O I/C D&S	HEAD Q.A.
1			2	3	4	5

SCALE:- NTS	QTY:- 1No.	ADRDE AGRA	DRN	SK SHARMA
DIMENSIONS IN mm		GROUP- HDS	CHKD	JC DUTTA
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102 (PART-I):1993 VERY COARSE		VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)		
MATERIAL:-		APPROVED		
FINISH:- AS PER ANNEXURE 'C'(GREY) AS PER SHEET No. 40		PROJDIR		
HEAT TREATMENT:-		GROUP DIR.		

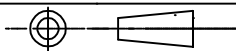
  

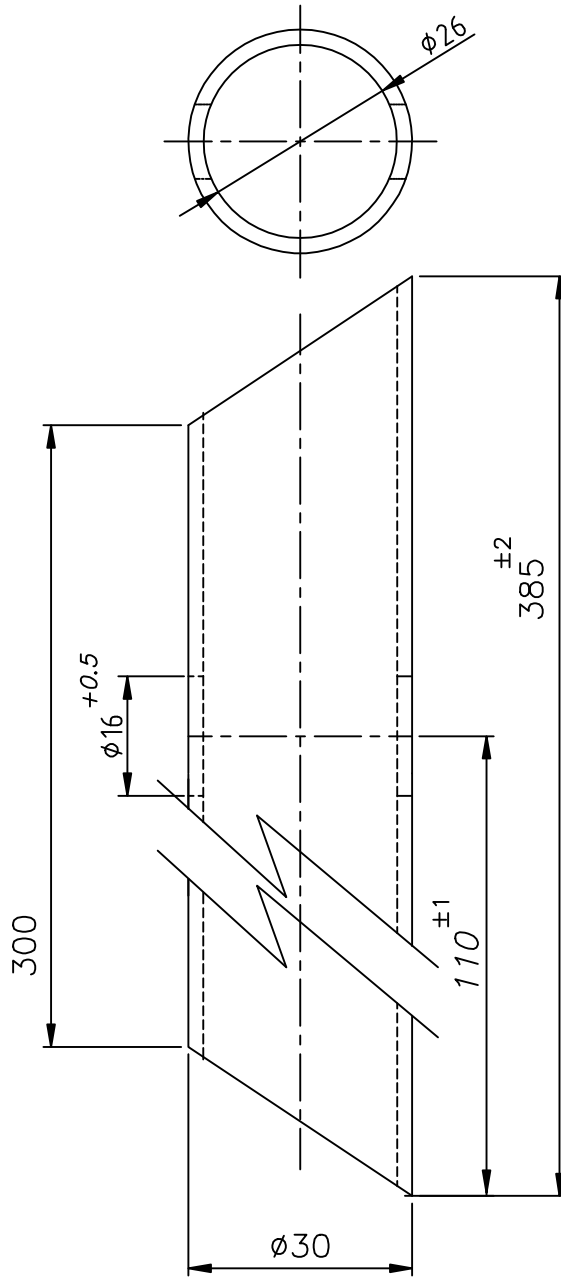
DRG. NO.	ADRDE/1407-02
8	



PROCESS :- FABRICATION

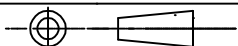
Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		O I/C (D&S)	HEAD (Q.A.)			
SCALE:-1:1		QTY:- 1 No.		A D R D E A G R A	DRN.	SK SHARMA		PROJ.OFFR./GP.OFFR.			
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	J C D U T T A					
TOL:- IS:2102(Pt-1)1993 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED				PIPE LONG VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)				PROJ. DIR.			
MATERIAL:- ALUMINIUM. ALLOY TUBE 64430 (HE30) T6 (WP) COND. IS :738-1994								APPROVED		GROUP DIR.	
FINISH:- AS PER ANNEXURE 'B'(GREY) AS PER SHEET No. 40								DRG. NO. ADRDE/1407-02-01			
HEAT TREATMENT:-											

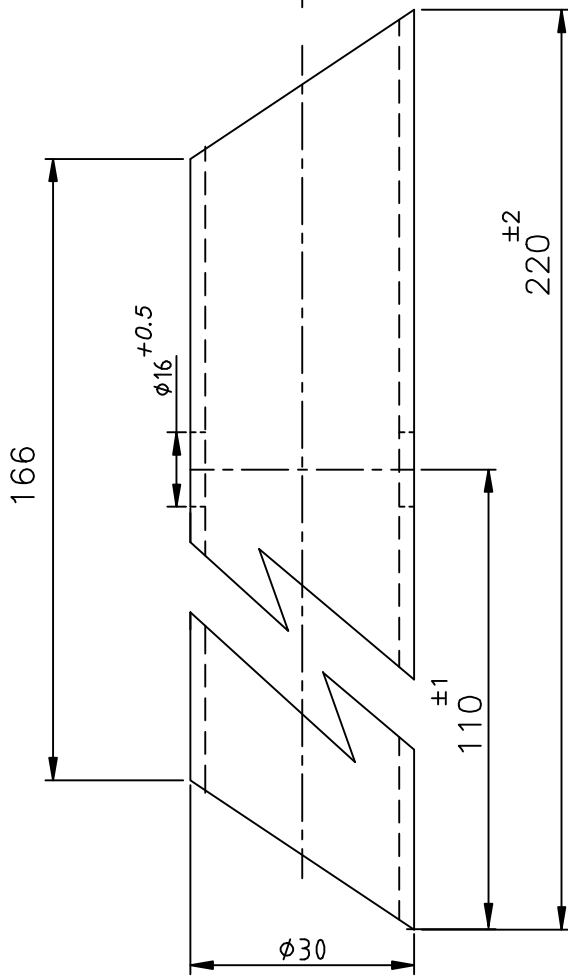
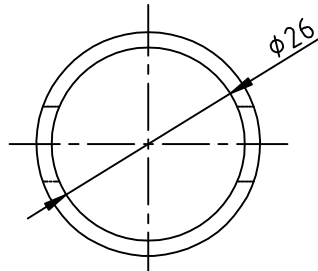




PROCESS :- FABRICATION

Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		O I/C (D&S)	HEAD (Q.A.)	
SCALE:-1:1		QTY.:- 1 No.		A D R D E A G R A	DRN.	SK SHARMA			
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	J C D U T T A			
TOL.:- IS:2102(Pt-1)1993 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED				PIPE MEDIUM VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			PROJ.OFFR./GP.OFFR.		
MATERIAL:- ALUMINIUM. ALLOY TUBE 64430 (HE30) T6 (WP) COND. IS :738-1994							PROJ. DIR.		
FINISH:- AS PER ANNEXURE 'B'(GREY) AS PERSHEET No. 40							APPROVED		
HEAT TREATMENT:-							GROUP DIR.		
HEAT TREATMENT:-				DRG. NO. ADRDE/1407-02-03					

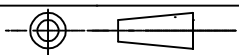




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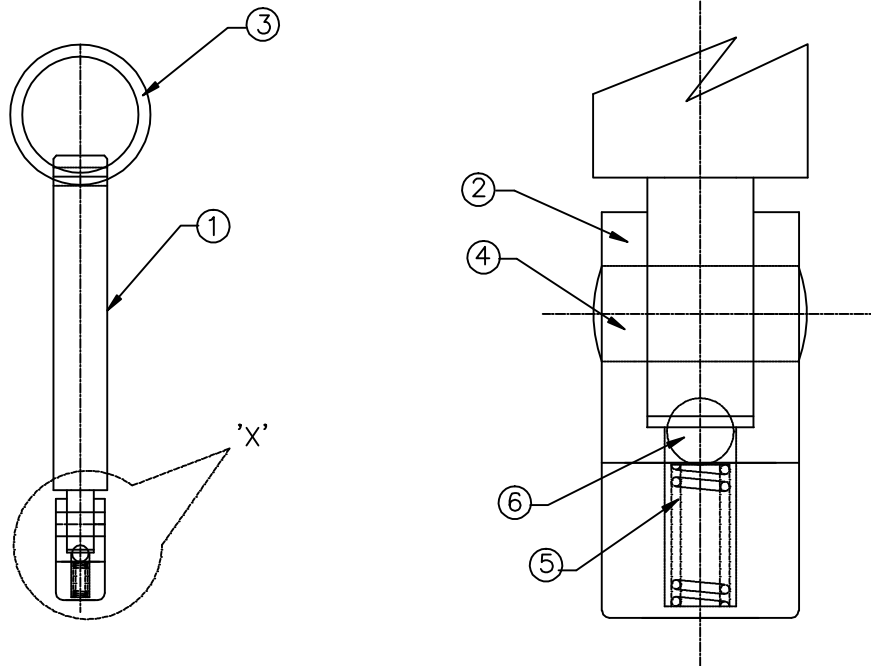
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Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)			
SCALE:- NTS		QTY:- 1 No.		ADRDE AGRA	DRN.	SK SHARMA		PROJ.OFFR./GP.OFFR.			
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA					
TOL:- IS:2102(Pt-1)1993 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED				PIPE SMALL VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)				PROJ. DIR.			
MATERIAL:- ALUMINIUM. ALLOY TUBE 64430 (HE30) T6 (WP) COND. IS :738-1994								APPROVED		GROUP DIR.	
FINISH:- AS PER ANNEXURE 'B'(GREY) AS PER SHEET No. 40								DRG. NO. ADRDE/1407-02-03			
HEAT TREATMENT:-											



6	(COMMERC. QLT.)	STEEL BALL $\phi 4.7$	—	1
5	ADRDE/1407-02-04-05	SPRING	21	1
4	ADRDE/1407-02-04-04	RIVET	20	1
3	ADRDE/1407-02-04-03	RING	19	1
2	ADRDE/1407-02-04-02	LOCK PIN	18	1
1	ADRDE/1407-02-04-01	PIN	17	1
ITEM No	DRG./SPECN. NO.	NOMENCLATURE	SHEET No.	QTY

ITEM LIST

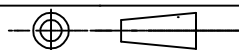


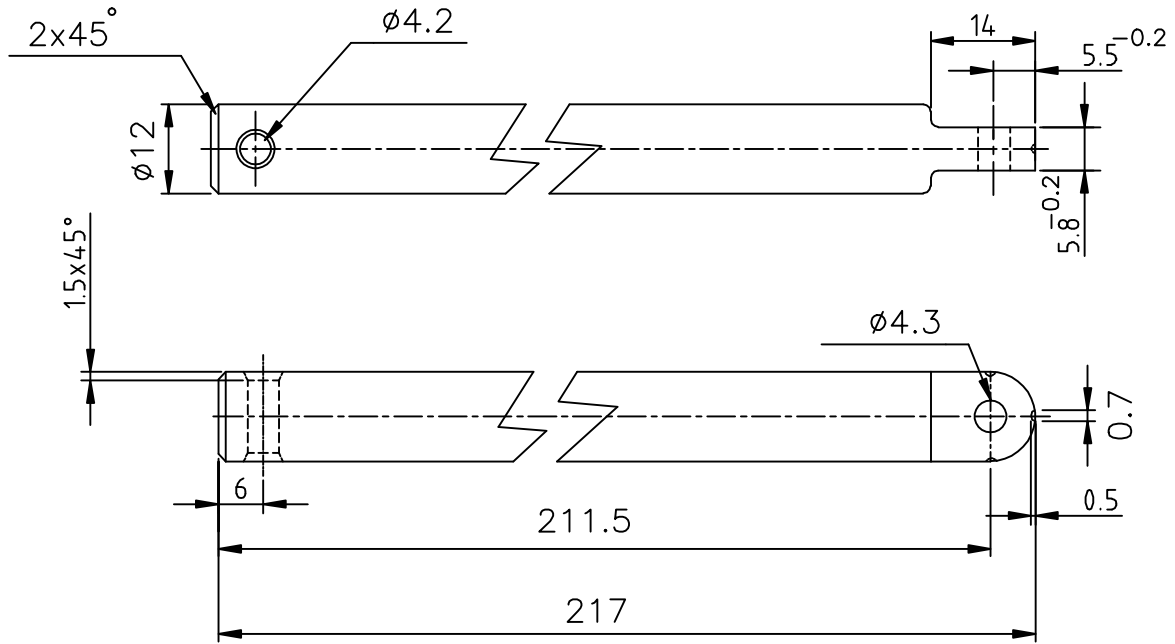
ENLARGED VIEW AT 'X-X'

PROCESS :- FABRICATION

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Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)			
SCALE:- NTS		QTY:- 1 No		A D R D E AGRA	DRN.	SK SHARMA					
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA	PROJ.OFFR./GP.OFFR.				
TOL.:- IS:2102 (Pt-I) 1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				PIN SUB ASSEMBLY VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)				PROJ. DIR.			
MATERIAL:-								APPROVED		GROUP DIR.	
FINISH:-											
HEAT TREATMENT:-											
								DRG. NO. ADRDE/1407-02-04			

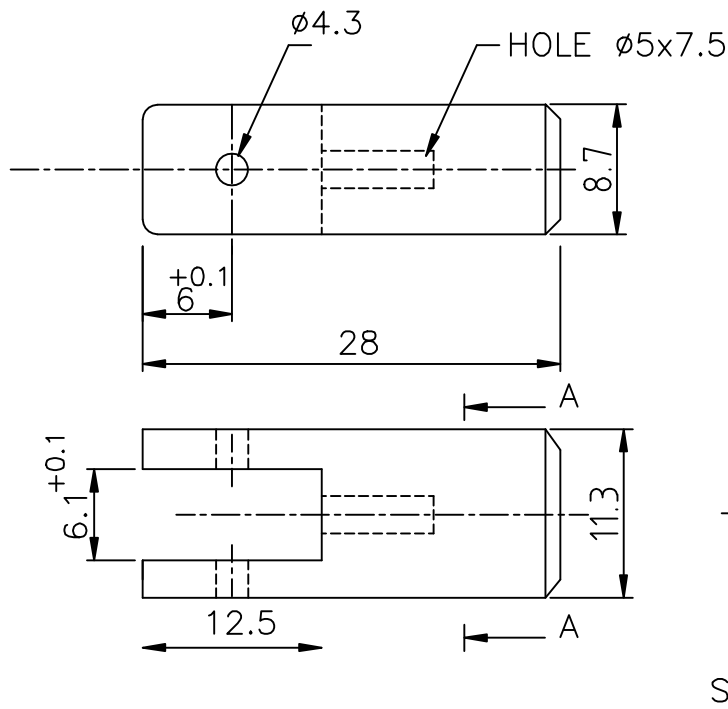




PROCESS :- FABRICATION

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)	
SCALE:- NTS		QTY.:- 1 No.		ADRDE AGRA	DRN.	SK SHARMA			
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA			
TOL.:- IS:2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				PIN PIN SUB ASSY. VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			PROJ.OFFR./GP.OFFR.		
MATERIAL:- ALLOY STEEL 070M55 (EN-9) BS 970							PROJ. DIR.		
FINISH:- AS PER SHEET No. 40							APPROVED		
HEAT TREATMENT:- 28±3HRC							GROUP DIR.		
							DRG. NO. ADRDE/1407-02-04-01		

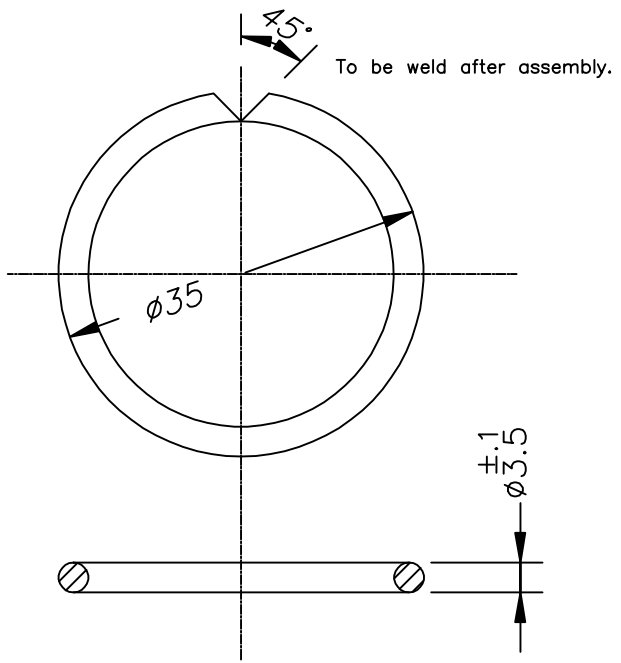




SECTION-AA

PROCESS :- FABRICATION

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:-2:1	QTY.:- 1 No.		A D R D E AGRA	DRN.	SK SHARMA	PROJ.OFFR./GP.OFFR.		
DIMENSIONS IN mm			GROUP:- HDS	CHKD.	JC DUTTA			
TOL.:- IS:2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED			<p style="text-align: center;">LOCK PIN PIN SUB.ASSY. VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)</p>			PROJ. DIR.		
MATERIAL:- ALLOY STEEL 070M55 (EN-9) BS 970						APPROVED		
FINISH:- AS PER ANNEXURE 'B'(GREY) AS PER SHEET No. 40						GROUP DIR.		
HEAT TREATMENT:- 32±5HRC						DRG. NO. ADRDE/1407-02-04-02		



PROCESS :- FABRICATION

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Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:- NTS		QTY:- 1 No		ADRDE AGRA	DRN.	SK SHARMA		
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA		
TOL.:- IS:2102 (Pt-I) 1993 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED				RING PIN SUB. ASSY. VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			PROJ.OFFR./GP.OFFR.	
MATERIAL:- AUSTENITIC STAINLESS STEEL X 04Cr18Ni10 AS PER IS:6527:1972							PROJ. DIR.	
FINISH:- NATURAL							APPROVED	
HEAT TREATMENT:- ANNEALING							GROUP DIR.	
							DRG. NO. ADRDE/1405-02-04-03	

1

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6

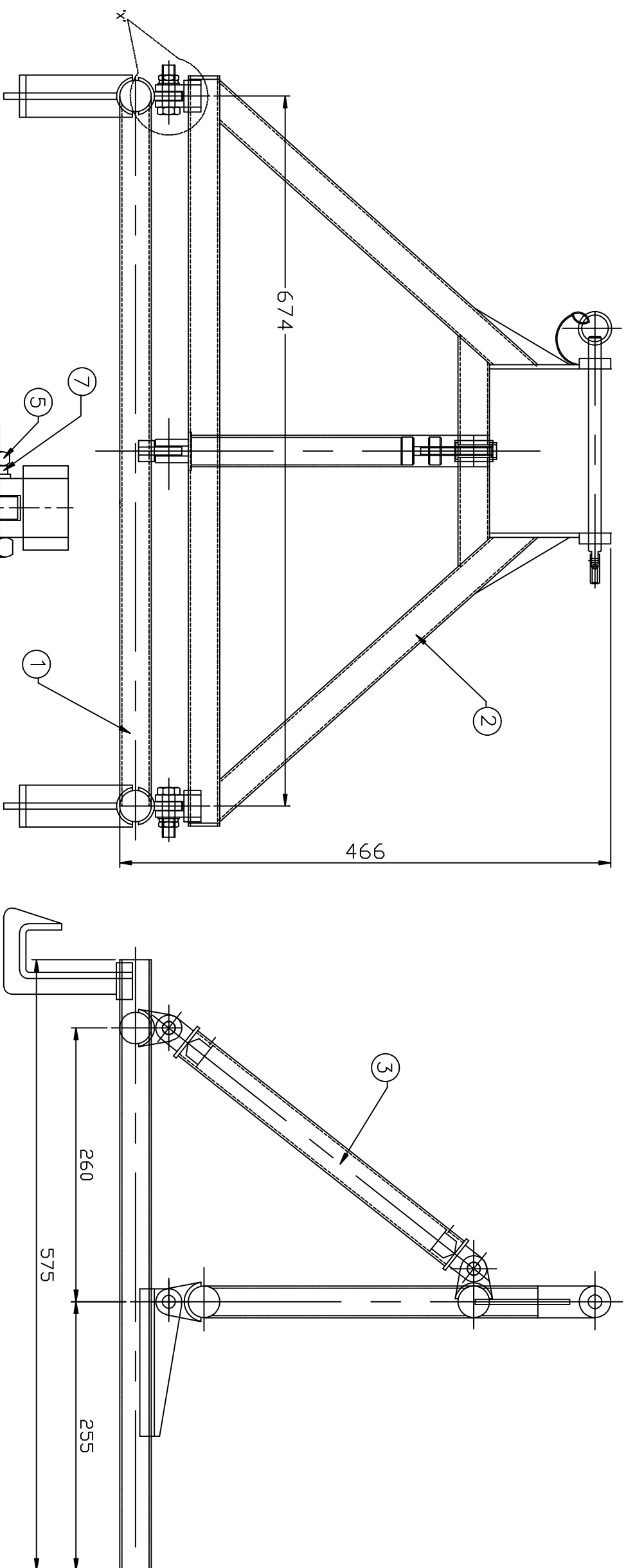
7

8

SHEET 1 DF 40

ITEM NO	DRG./SPECN. NO.	NOMENCLATURE	SHEET NO	QTY
-	-	PROCEDURE FOR FINISH	40	-
7	IS:3063	SPRING WASHER M12	-	2
6	IS:2016	PLAIN WASHER M12	-	2
5	IS:1364	HEX NUT ,M12x1.5P	-	2
4	IS:1364	HEX BOLT M12x1.5P, 40Lg	-	2
3	ADRDE/1407-03	SUPPORT	32-39	1
2	ADRDE/1407-02	VERTICAL FRAME	12-31	1
1	ADRDE/1407-01	MAIN FRAME	2-11	1

## ITEM LIST



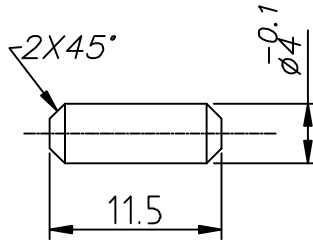
DETAILS AT 'X'

## NOTE :-

Before assembly all Nuts, Bolts, Washers & Split Pins should be Cadmium plated,  
Chromate passivated and after plating Hydrogen Embrittlement relief as per IS: 1572 - 1986 (8 micron)

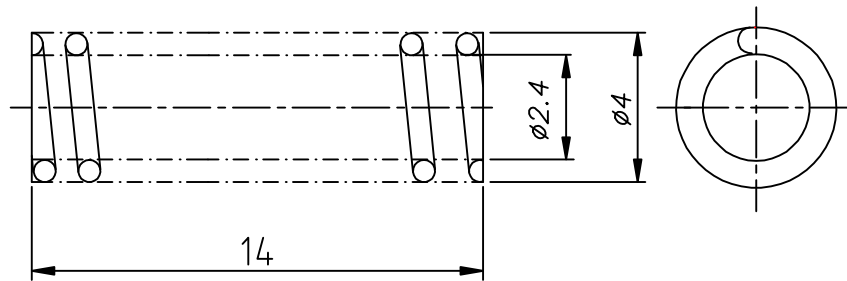
REF. NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD	I/C D&S	HEAD Q.A.
1						

SCALE:- NTS	QTY:- 1 No.	ADRDE AGRA	DRN.	SK SHARMA	PRODFFR./GRDFFR.
DIMENSIONS IN mm		GROUP- HDS	CHD.	JC DUTTA	
TOL.:-IS:2102 (PART-1) :1993VERY COARSE UNLESS OTHERWISE SPECIFIED		PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			
MATERIAL:-					
FINISH:-		APPROVED PROD DIR.			
HEAT TREATMENT:-		DRG. NO. ADRDE/1407 GROUP DIR.			



PROCESS :- FABRICATION

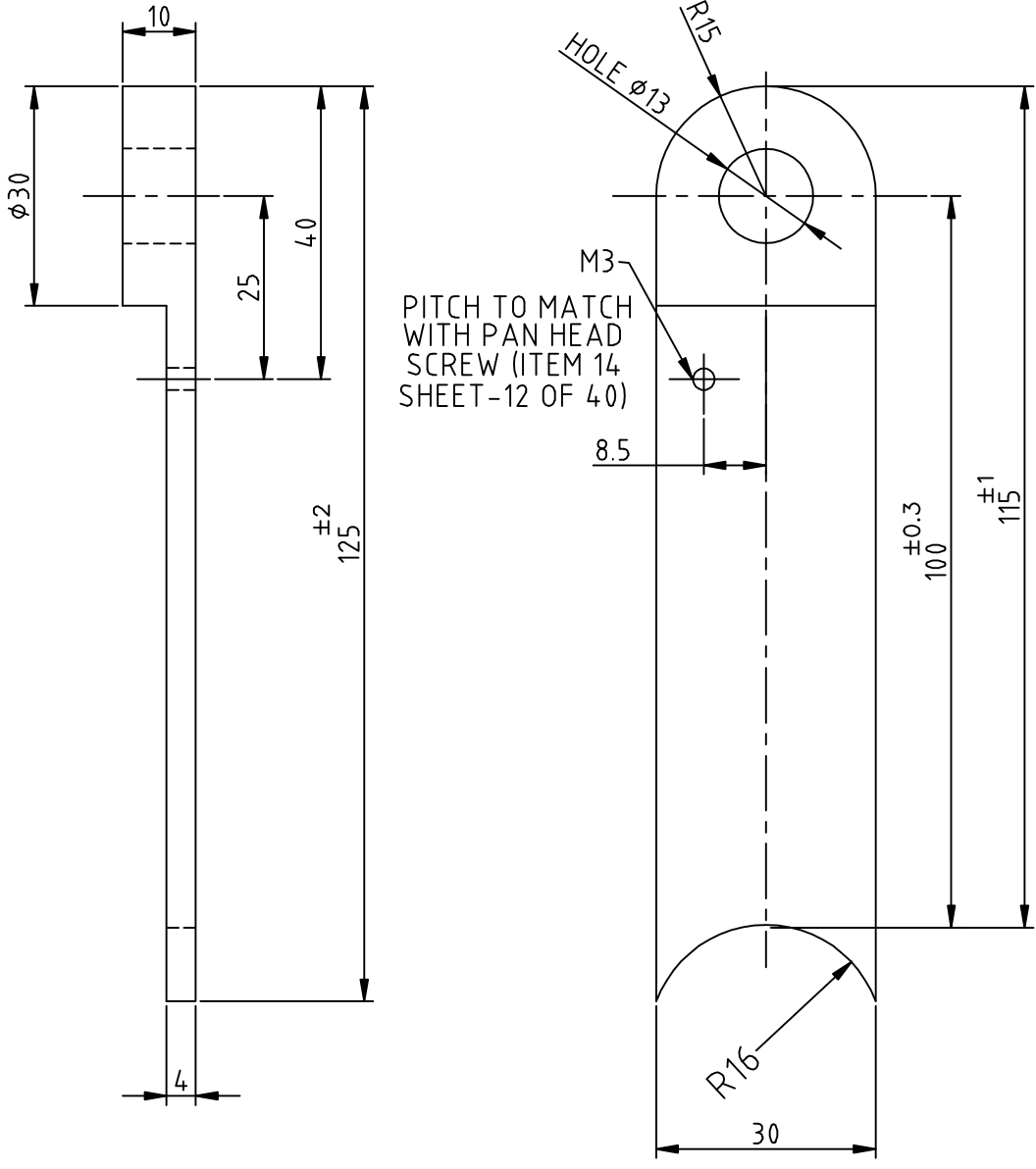
Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		O I/C (D&S)	HEAD (Q.A.)	
SCALE:- 2:1		QTY:- 1 No		A D R D E AGRA	DRN.	SK SHARMA			
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA			
TOL.:- IS:2102 (Pt-I) 1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				RIVET PIN SUB. ASSY. PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			PROJ.OFFR./GP.OFFR.		
MATERIAL:- Austenitic Stainless Steel 04 Cr 18 Ni 10 IS 6527-1972							PROJ. DIR.		
FINISH:- NATURAL							APPROVED		
HEAT TREATMENT:- HARDENED & TEMPERED 32 ±5 HRC							GROUP DIR.		
				DRG. NO. ADRDE/1405-02-04-04					



NO OF COILS-11  
 WIRE DIA.:  $\phi 0.8$  mm  
 STIFFNESS : 0.5 kg / mm

PROCESS : - FABRICATION

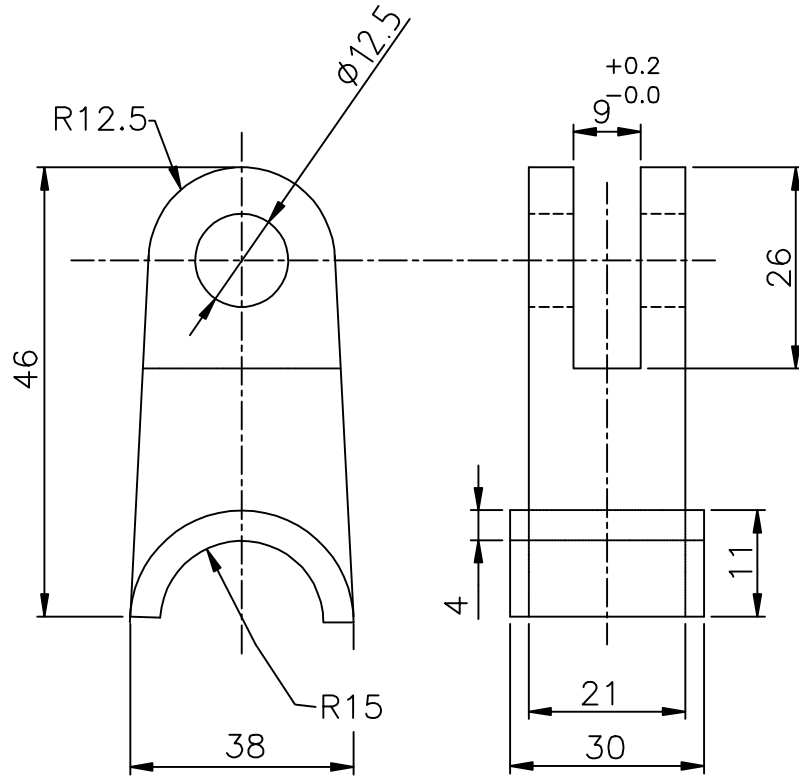
Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		O I/C (D&S)	HEAD (Q.A.)	
SCALE:-NTS		QTY.:- 1No.		ADRDE AGRA	DRN.	SK SHARMA	PROJ.OFFR./GP.OFFR.		
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA	PROJ. DIR.		
TOL.:- IS:2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				SPRING PIN SUB ASSY. VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			APPROVED		
MATERIAL:- S.S. SPRING WIRE IS 4454 Gr. IV							GROUP DIR.		
FINISH:- NATURAL							DRG. NO. ADRDE/1407-02-04-05		
HEAT TREATMENT:- NORMALIZED									



PITCH TO MATCH WITH PAN HEAD SCREW (ITEM 14 SHEET-12 OF 40)

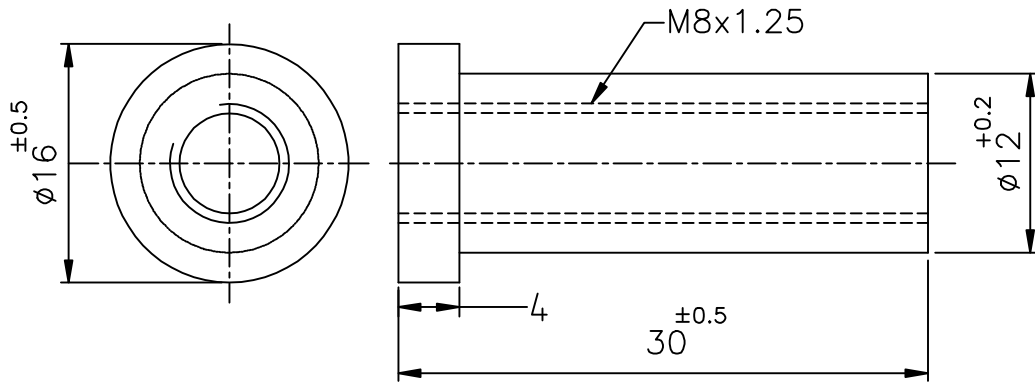
PROCESS :- FABRICATION

Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:-1:1		QTY.- 2 Nos.		ADRDE AGRA	DRN.	SK SHARMA		PROJ.OFFR./GP.OFFR.	
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA			
TOL.:- AS PER IS:2102(Pt-1)1993VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED				PLATE VERTICAL VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			PROJ. DIR.		
MATERIAL:- ALUMINIUM ALLOY SHEET 64430 (HE-30) T4/T6 (W/WP) COND. IS 737							APPROVED		
FINISH:- AS PER ANNEXURE 'B'(GREY) AS PER SHEET No. 40							GROUP DIR.		
HEAT TREATMENT:-							DRG. NO. ADRDE/1407-02-05		



PROCESS :- FABRICATION

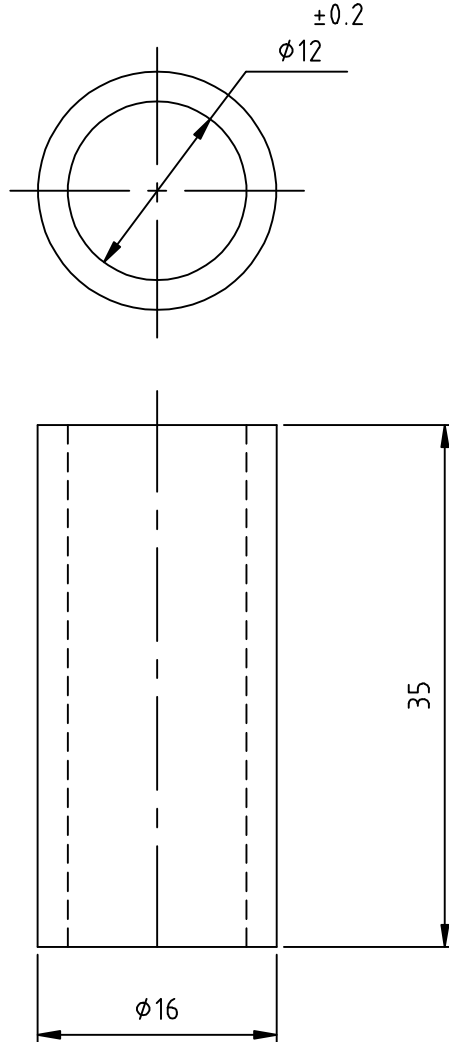
Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		O I/C (D&S)	HEAD (Q.A.)
SCALE:-1:1		QTY.- 2 Nos.		A D R D E AGRA	DRN.	SK SHARMA	PROJ.OFFR./GP.OFFR.	
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA	PROJ. DIR.	
TOL.:- IS:2102(Pt-1)1993 COARSE EXCEPT WHERE OTHERWISE SPECIFIED				<p style="text-align: center;"><b>MOUNTING BRACKET VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)</b></p>			APPROVED	
MATERIAL:- ALUMINIUM ALLOY 64430 (HE-30) T4/T6 (W/WP) COND. IS 737 :1983							GROUP DIR.	
FINISH:- AS PER ANNEXURE 'B'(GREY) AS PER SHEET No. 40							DRG. NO.	
HEAT TREATMENT:-							ADRDE/1407-02-06	



PROCESS :- FABRICATION

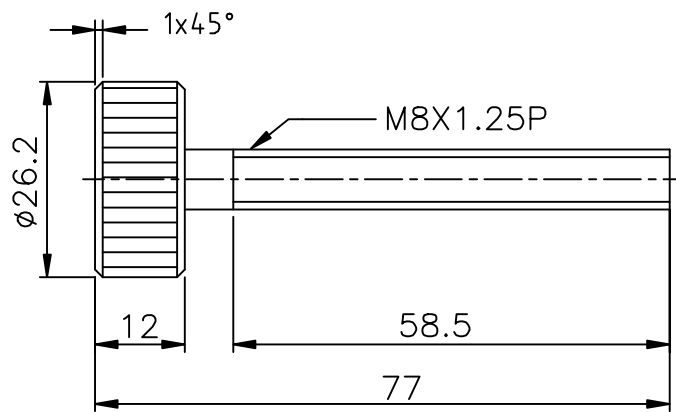
Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		O I/C (D&S)	HEAD (Q.A.)
SCALE:-2:1		QTY:- 1 No.		ADRDE AGRA	DRN.	SK SHARMA	PROJ.OFFR./GP.OFFR.	
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA	PROJ. DIR.	
TOL.:- IS:2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				THREADED BUSH VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			APPROVED	
MATERIAL:-ALLOY STEEL 070M55 (EN-9) TO BS 970							GROUP DIR.	
FINISH:- CADMIUM PLATING AS PER IS:1572 Gr3,10-12u AS PER SHEET No. 40							DRG. NO.	
HEAT TREATMENT:- HARDENED & TEMPERED 28±3 HRC							ADRDE/1407-02-07	





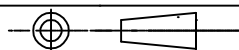
PROCESS :- FABRICATION

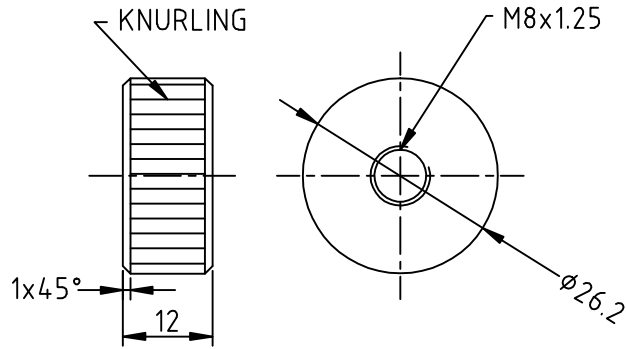
Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:-2:1		QTY.- 1 No.		ADRDE AGRA	DRN.	SK SHARMA		
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA		
TOL.:- IS:2102 (Pt-I) 1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				<p style="text-align: center;">SLEEVE VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)</p>			PROJ.OFFR./GP.OFFR.	
MATERIAL:- ALUMINIUM ALLOY TUBE 64430 (HE-30) T6 (WP) COND IS 738 : 1994							PROJ. DIR.	
FINISH:- AS PER ANNEXURE 'B'(GREY) AS PER SHEET No. 40							APPROVED	
HEAT TREATMENT:-							GROUP DIR.	
							DRG. NO. ADRDE/1407-02-08	



PROCESS :- FABRICATION

Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		O I/C (D&S)	HEAD (Q.A.)	
SCALE:-1:1		QTY.- 1 No.		ADRDE AGRA	DRN.	SK SHARMA	PROJ.OFFR./GP.OFFR.		
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA	PROJ. DIR.		
TOL.:- IS:2102 (Pt-I) 1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				SCREW VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			APPROVED		
MATERIAL:- STEEL ALLOY ( EN19/20) 709M40/817M40 TO BS 970							GROUP DIR.		
FINISH:- AS PER SHEET No. 40							DRG. NO. ADRDE/1407-02-09		
HEAT TREATMENT:- HARDENED & TEMPERED 28±3 HRC									





PROCESS :- MACHINING

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:-1:1	QTY.- 1 No.		ADRDE AGRA	DRN.	SK SHARMA	PROJ.OFFR./GP.OFFR.		
DIMENSIONS IN mm			GROUP:- HDS	CHKD.	JC DUTTA			
TOL.:- IS:2102 (Pt-I) 1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED			NUT VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			PROJ. DIR.		
MATERIAL:- BS:EN19/EN24, ROD Ø27 (709M40/817M40)						APPROVED		
FINISH:- AS PER SHEET No. 40						GROUP DIR.		
HEAT TREATMENT:- HARDENED & TEMPERED 32±5 HRC						DRG. NO. ADRDE/1407-02-10		

1

2

3

4

SHEET 28 OF 40

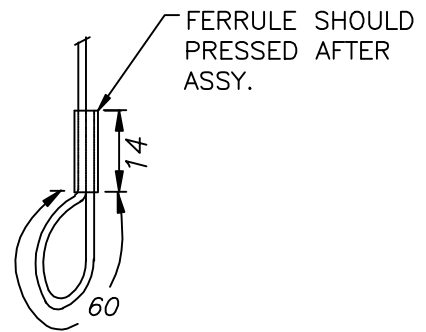
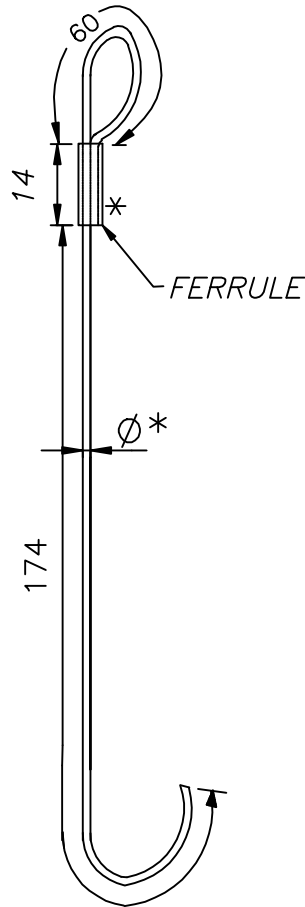
A

B

C

D

E



Ø\* Commercial wire rope (galvanized / ss) dia 1.6 -2.0 mm  
Construction 5/6 x 7

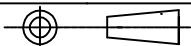
Suitable copper ferruling with smooth finish

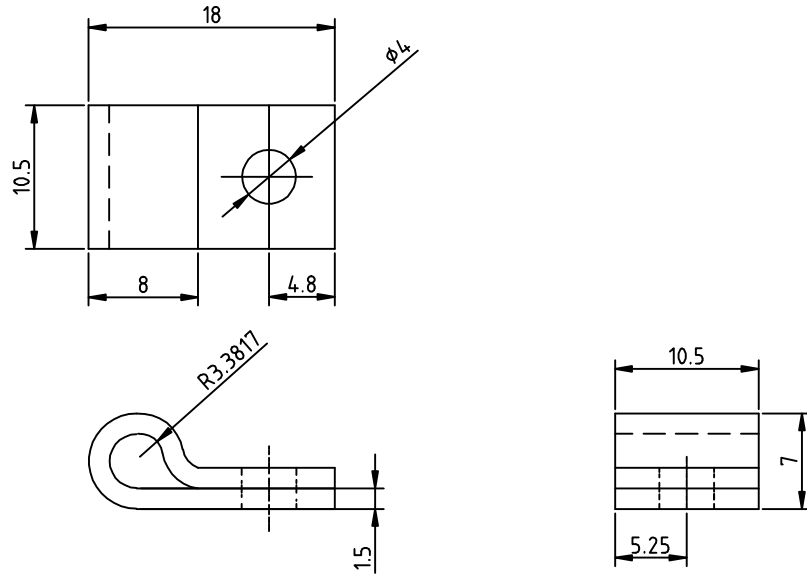
TOLERANCE:- IS:2102 (PART-1) 1993 V.COARSE EXCEPT WHERE OTHERWISE SPECIFIED.

PROCESS:- FABRICATION


Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O I/C D&S	HEAD Q.A.
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SCALE:-NTS	QTY:- 1 No.	A D R D E AGRA	DRN.	SK SHARMA	PROJ.OFFR./GP.OFFR.			
DIMENSIONS IN mm		GROUP:-HDS	CHKD.	JC DUTTA				
TOL:- AS ABOVE		<p style="text-align: center;">ARMING WIRE VERTICAL FRAME PARA FRAME SMALL HD SYSTEM FOR AN-32 A/C</p>			PROJ. DIR.			
MATERIAL:-					APPROVED		GROUP DIR.	
FINISH:-					DRG. No. ADRDE/1407-02-11			
HEAT TREATMENT:-								





NOTE :- LENGTH OF CLIP CAN BE SMOOTHLY TRIMMED TO SUIT FITMENT.

TOLERANCE:- IS:2102 (PART-1) 1993 V.COARSE EXCEPT WHERE OTHERWISE SPECIFIED.

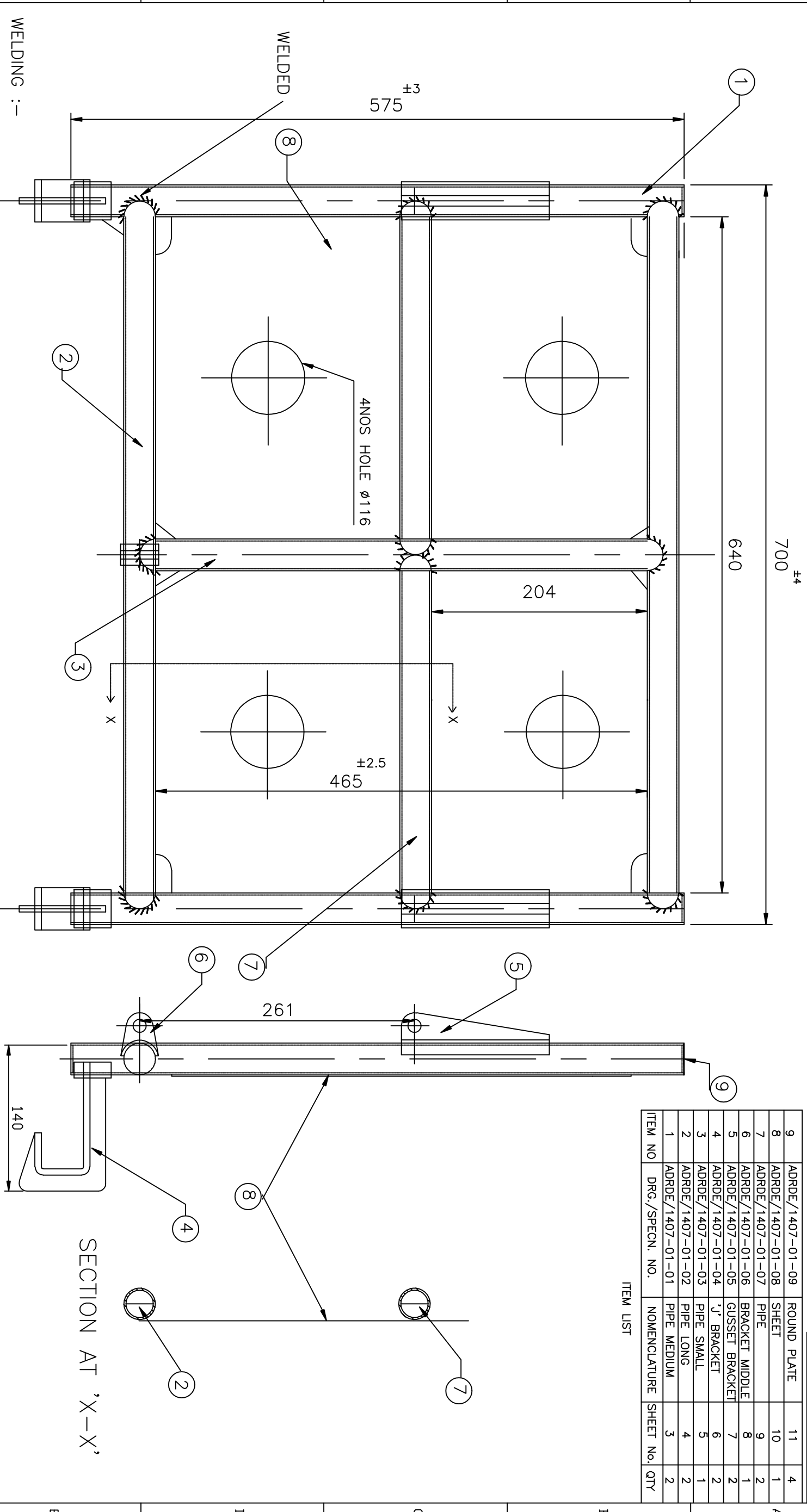
PROCESS:- FABRICATION


Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O I/C D&S	HEAD Q.A.
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SCALE:-NTS	QTY:- 1 No.	A D R D E AGRA	DRN.	SK SHARMA	PROJ.OFFR./GP.OFFR.	
DIMENSIONS IN mm		GROUP:-HDS	CHKD.	JC DUTTA		
TOL:- AS ABOVE		<p style="text-align: center;">ARMING WIRE CLIP VERTICAL FRAME PARA FRAME SMALL HD SYSTEM FOR AN-32 A/C</p>			PROJ. DIR.	
MATERIAL:- M.S.					APPROVED	
FINISH:- _____					GROUP DIR.	
HEAT TREATMENT:- _____					DRG. No. ADRDE/1411-01-14-03-07	

ITEM NO	DRG./SPECN. NO.	NOMENCLATURE	SHEET No.	QTY
9	ADRDE/1407-01-09	ROUND PLATE	11	4
8	ADRDE/1407-01-08	SHEET	10	1
7	ADRDE/1407-01-07	PIPE	9	2
6	ADRDE/1407-01-06	BRACKET MIDDLE	8	1
5	ADRDE/1407-01-05	GUSSET BRACKET	7	2
4	ADRDE/1407-01-04	'J' BRACKET	6	2
3	ADRDE/1407-01-03	PIPE SMALL	5	1
2	ADRDE/1407-01-02	PIPE LONG	4	2
1	ADRDE/1407-01-01	PIPE MEDIUM	3	2

ITEM LIST



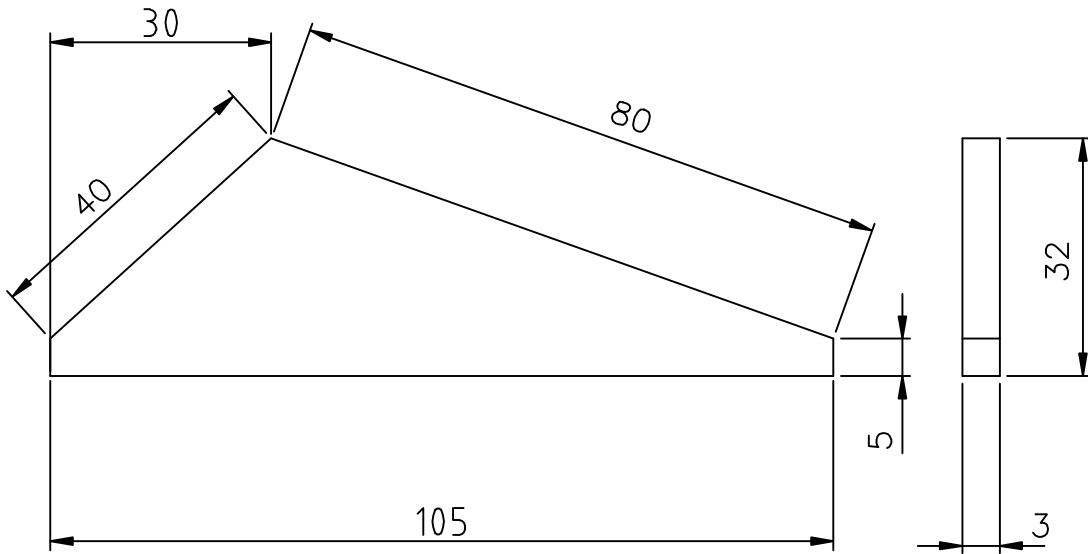
WELDING :-

All joints shall be welded by either Metal Inert Gas (MIG) or Tungsten Inert Gas (TIG) welding process using proper ADVANI OERLIKON-FON filler confirming to IS:5897 OR BS:2901-Pt-4

\* Welding of Sheet :- Weld length 30mm at intervals 60/70mm. with items ① & ②  
 \* continuous welding with items ④, ⑤, ⑥ & ⑨

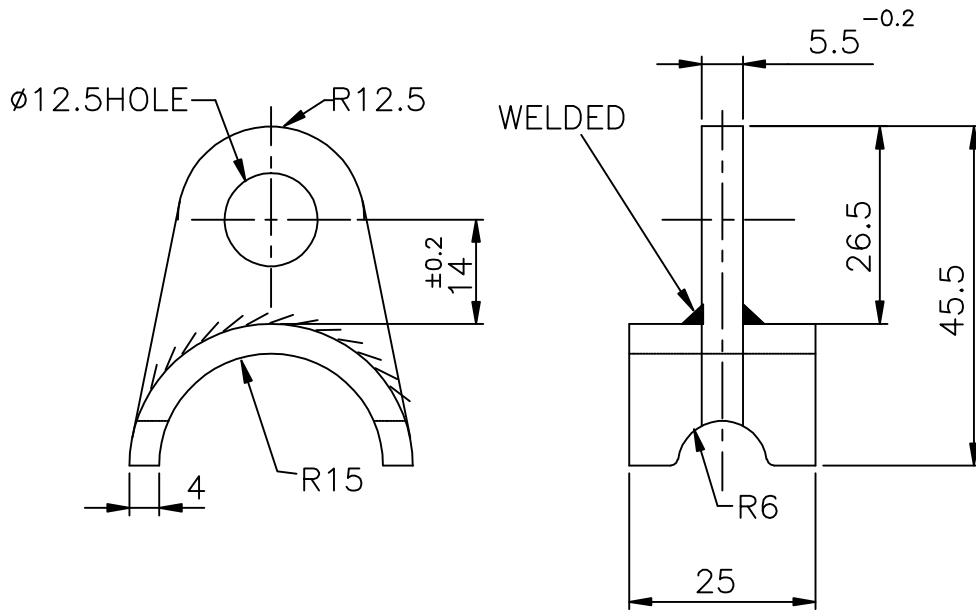
JOINT EXAMINATION :-  
 Visual and Liquid Penetrant Test shall be carried out as per IS : 3658

REF. NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD	I/C D&S	HEAD Q.A.	SCALE:- NTS	QTY:- 1 No.	ADRDE AGRA	DRN.	SK SHARMA	PRODFFR./GP.DFFR.
1			2	3	4	5.	DIMENSIONS IN mm		GROUP- HDS	CHD.	JC DUTTA	
							TDL:- IS:2102(PART-1):1993VERY COARSE UNLESS OTHERWISE SPECIFIED		MAIN FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			
							MATERIAL:-		APPROVED			
							FINISH:- AS PER ANNEXURE 'B'(GREY) AS PER SHEET No. 40		GROUP DIR.			
							HEAT TREATMENT:-		DRG. NO. ADRDE/1407-01			



PROCESS :- FABRICATION

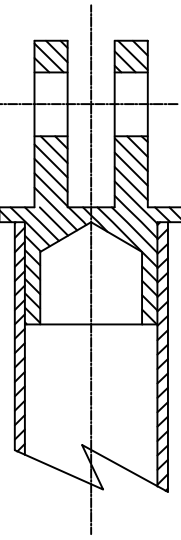
Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:-1:1	QTY:- 2 Nos.		A D R D E A G R A	DRN.	SK SHARMA	PROJ.OFFR./GP.OFFR.		
DIMENSIONS IN mm			GROUP:- HDS	CHKD.	JC DUTTA	PROJ. DIR.		
TOL.:- IS:2102 (Pt-I) 1993 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED			GUSSET VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			APPROVED		
MATERIAL:- ALUMINIUM ALLOY SHEET 64430 (HE-30) T4/T6 (W/WP) COND IS 737 : 1965						GROUP DIR.		
FINISH:- AS PER ANNEXURE 'B'(GREY) AS PER SHEET No. 40						DRG. NO. ADRDE/1407-02-13		
HEAT TREATMENT:- HARDENED & TEMPERED 32±5 HRC								



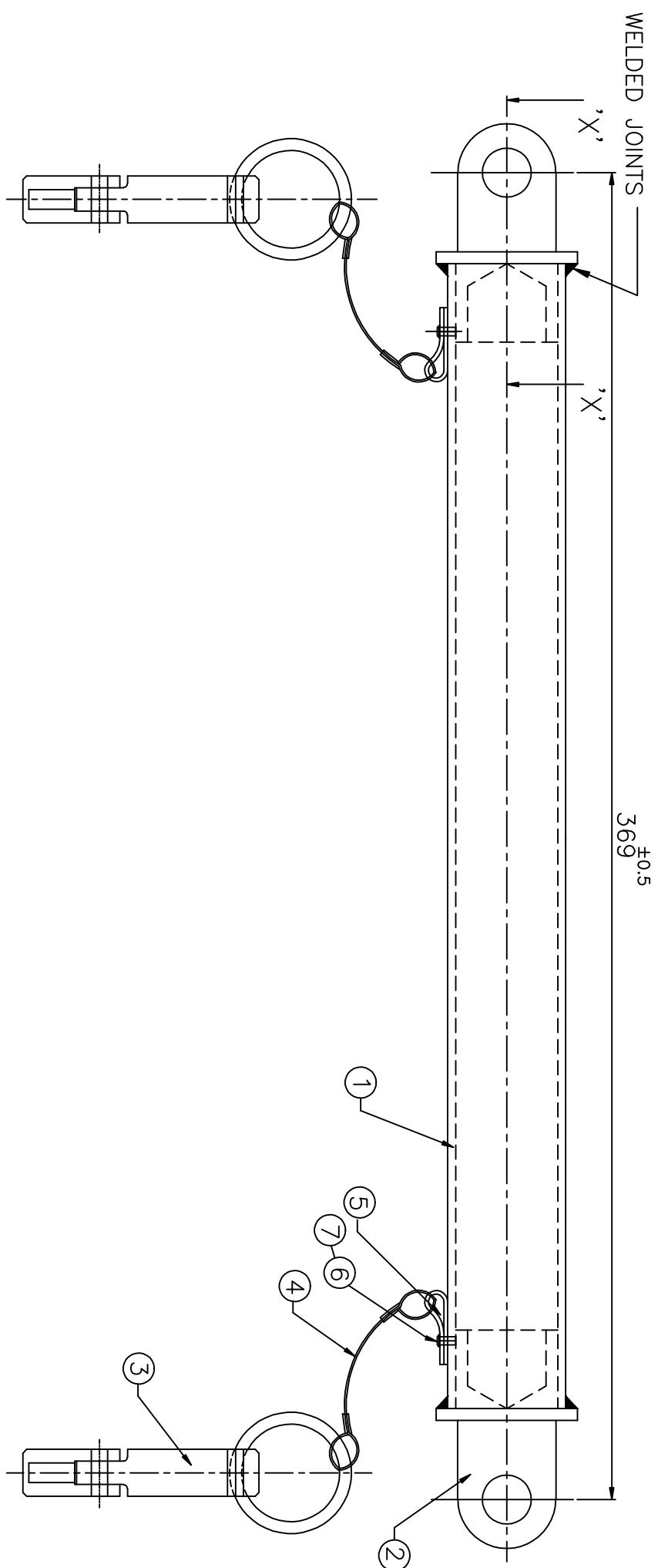
PROCESS :- FABRICATION

Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		O I/C (D&S)	HEAD (Q.A.)
SCALE:-1:1		QTY.- 1 No.		ADRDE AGRA	DRN.	SK SHARMA	PROJ.OFFR./GP.OFFR.	
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA	PROJ. DIR.	
TOL.:- IS:2102 (Pt-I) 1993 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED				<p style="text-align: center;">TOP BRACKET VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)</p>			APPROVED	
MATERIAL:- ALUMINIUM ALLOY 64430 (HE-30) T4/T6 (W/WP) COND IS 737 : 1983							GROUP DIR.	
FINISH:- AS PER ANNEXURE 'B'(GREY) AS PER SHEET No. 40							DRG. NO. ADRDE/1407-02-14	
HEAT TREATMENT:- HARDENED & TEMPERED 32±5 HRC								





SECTION AT 'X-X'



ITEM No.	DRG./SPECN. NO.	NOMENCLATURE	SHEET No.	QTY
7	IS: 3063	SPRING WASHER M3	—	2
6	IS: 6101 -1971	PAN HEAD SCREW A M 3 X 16	—	2
5	ADDRDE/1407-02-12	ARMING WIRE CLIP	29	2
4	ADDRDE/1407-02-11	PIN ARMING WIRE	28	2
3	ADDRDE/1407-03-03	PIN SUB ASSEMBLY SMALL	35-39	2
2	ADDRDE/1407-03-02	BRACKET	34	2
1	ADDRDE/1407-03-01	PIPE	33	1

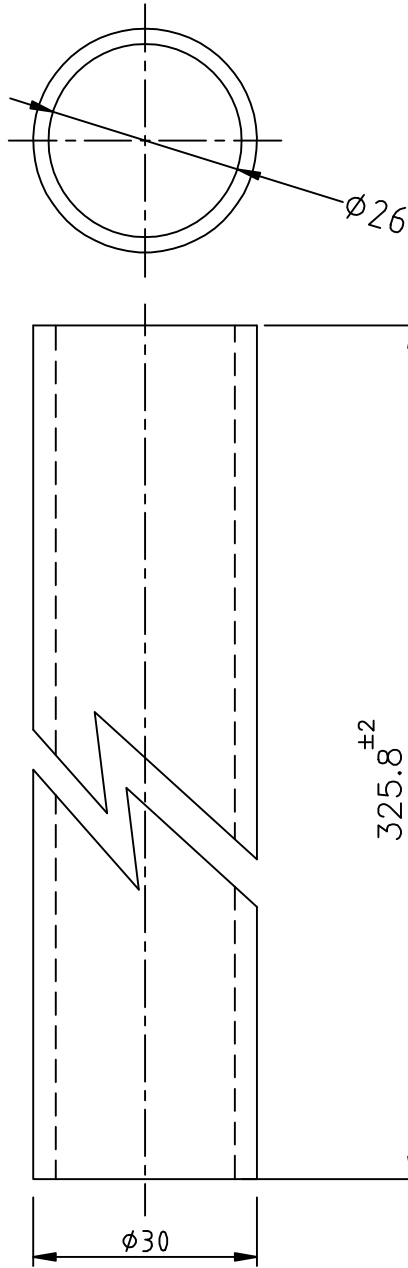
ITEM LIST

WELDING & EXAMINATION AS PER DETAILS GIVEN ON SHEET No.2 OF 40

REF. NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O I/C D&S	HEAD Q.A.
1						

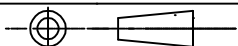
SCALE:- NTS	QTY:- 1No.	ADDRDE AGRA	DRN	SK SHARMA	PROJDIR
DIMENSIONS IN mm		GROUP- HDS	CHD	JC DUTTA	
TOL:- IS:2102(PART1) :1993 UNLESS OTHERWISE SPECIFIED VERY COARSE		SUPPORT PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			PROJDIR
MATERIAL:-					GROUP DIR.
FINISH:-					
HEAT TREATMENT:-					

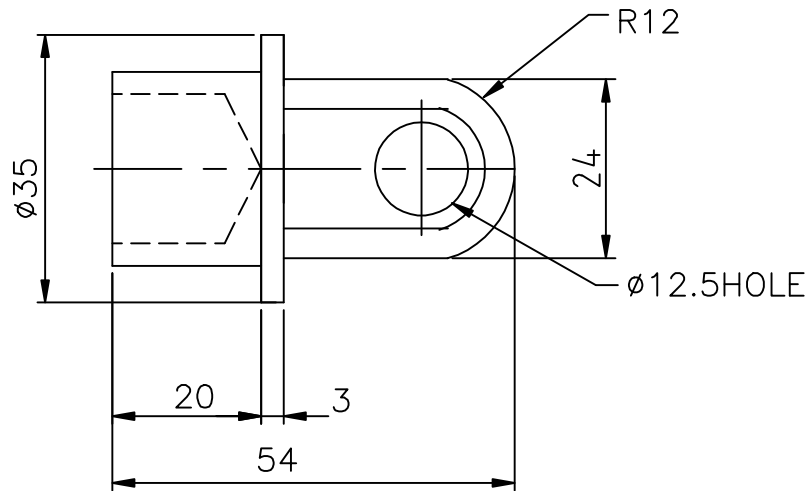
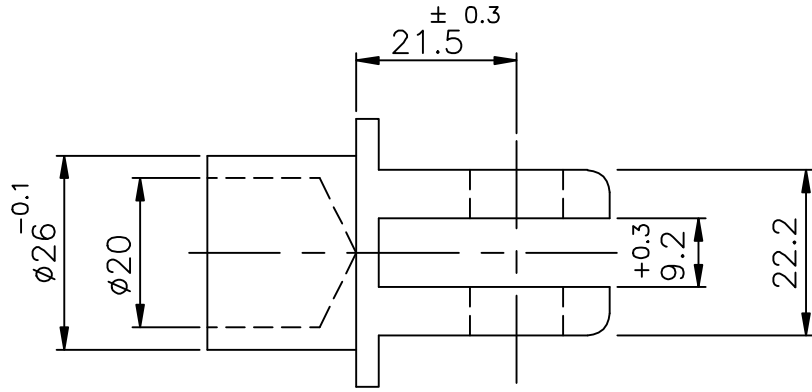
DRG. NO.	ADDRDE/1407-03
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PROCESS :- FABRICATION

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:-1:1	QTY.:- 1 No.		A D R D E A G R A	DRN.	SK SHARMA	PROJ.OFFR./GP.OFFR.		
DIMENSIONS IN mm			GROUP:- HDS	CHKD.	JC DUTTA			
TOL.:- IS:2102 (Pt-I) 1993 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED			PIPE SUPPORT VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			PROJ. DIR.		
MATERIAL:- ALUMINIUM ALLOY TUBE 64430 (HE-30) T4/T6 (W/WP) COND IS 737 : 1983						APPROVED		
FINISH:- AS PER ANNEXURE 'B'(GREY) AS PER SHEET No. 40						GROUP DIR.		
HEAT TREATMENT:-						DRG. NO. ADRDE/14.07-03-01		



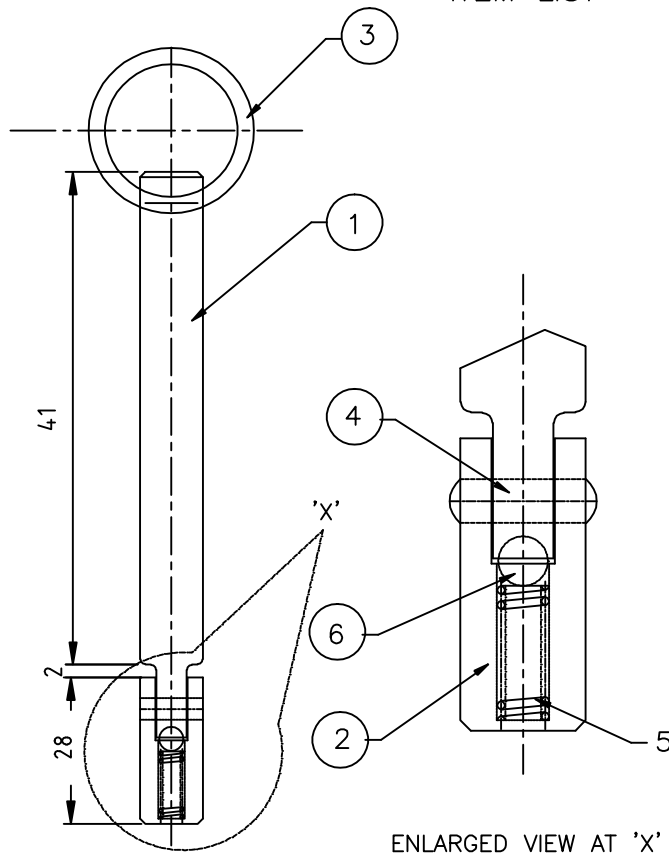


PROCESS : - FABRICATION

Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		O I/C (D&S)	HEAD (Q.A.)	
SCALE:- 1:1		QTY.- 2 Nos.		A D R D E A G R A	DRN.	SK SHARMA		PROJ.OFFR./GP.OFFR.	
DIMENSIONS IN mm		GROUP:- HDS		CHKD.	J C D U T T A				
TOL.:- IS:2102 (Pt-I) 1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED		<p style="text-align: center;">BRACKET SUPPORT VERTICAL FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)</p>		<p style="text-align: center;">APPROVED</p>		<p style="text-align: center;">PROJ. DIR.</p>			
MATERIAL:- ALUMINIUM ALLOY 64430 (HE-30) T4/T6 (W/WP) COND IS 737 : 1983									
FINISH:- AS PER SHEET No. 40								<p style="text-align: center;">GROUP DIR.</p>	
HEAT TREATMENT:-									
		DRG. NO. ADRDE/1407-03-02							

6	STAINLESS STEEL BALL (COM. QLTY) $\phi$ 4.76	1
5	ADRDE/1407-03-03-04 SPRING	39 1
4	ADRDE/1407-03-03-03 RIVET	38 1
3	ADRDE/1407-02-04-03 RING	19 1
2	ADRDE/1407-03-03-02 LOCK PIN	37 1
1	ADRDE/1407-03-03-01 PIN	36 1
ITEM NO.	DRG. /SPECN. NO.	DESIGNATION SHEET NO. QTY

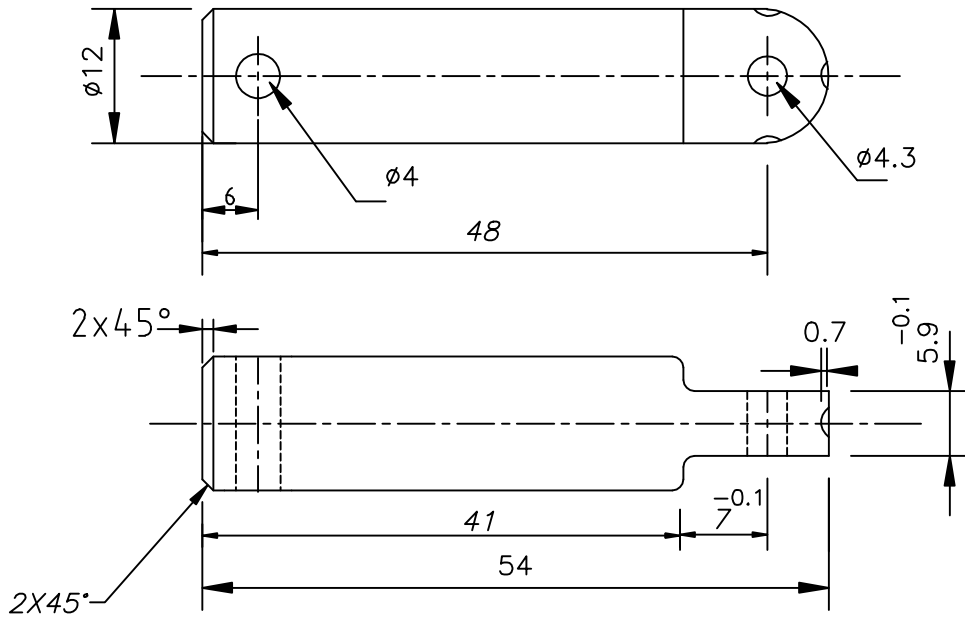
ITEM LIST



ENLARGED VIEW AT 'X'

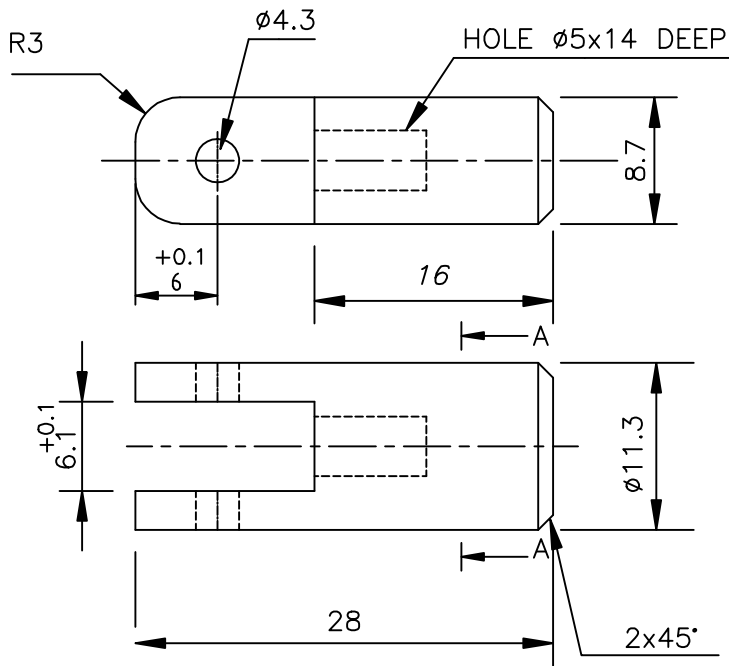
PROCESS : - FABRICATION

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		O I/C (D&S)	HEAD (Q.A.)
SCALE:- NTS		QTY.- 2 Nos.		ADRDE AGRA	DRN. SK SHARMA	PROJ.OFFR./GP.OFFR.	
DIMENSIONS IN mm				GROUP:- HDS	CHKD. JC DUTTA	PROJ. DIR.	
TOL.:- IS:2102(Pt-1)1993 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED				PIN SUB ASSY. SMALL SUPPORT PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)		APPROVED	
MATERIAL: _____						GROUP DIR.	
FINISH:- AS PER SHEET No. 40						DRG. NO. ADRDE/1407-03-03	
HEAT TREATMENT:- _____							



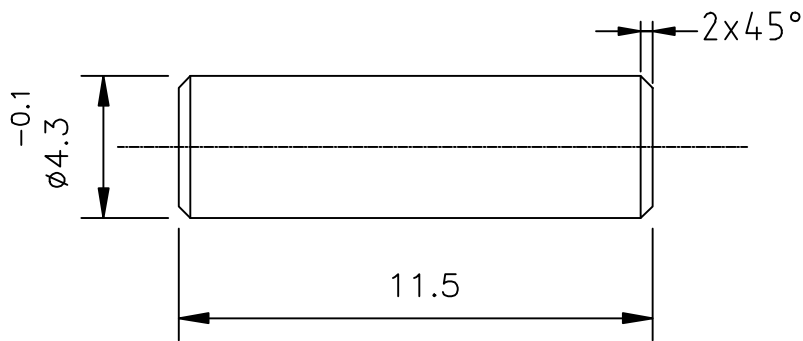
PROCESS :- MACHINING

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:- NTS		QTY.- 2 Nos.		ADRDE AGRA	DRN.	SK SHARMA	PROJ.OFFR./GP.OFFR.	
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA	PROJ. DIR.	
TOL.:- IS:2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				PIN PIN SUB. ASSY SMALL SUPPORT PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			APPROVED	
MATERIAL:- STEEL ALLOY 070M55 (EN9) TO BS 970							GROUP DIR.	
FINISH:- AS PER SHEET No. 40							DRG. NO. ADRDE/1407-03-03-01	
HEAT TREATMENT:- HARDENED & TEMPERED 28±3HRC								



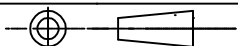
PROCESS :- MACHINING

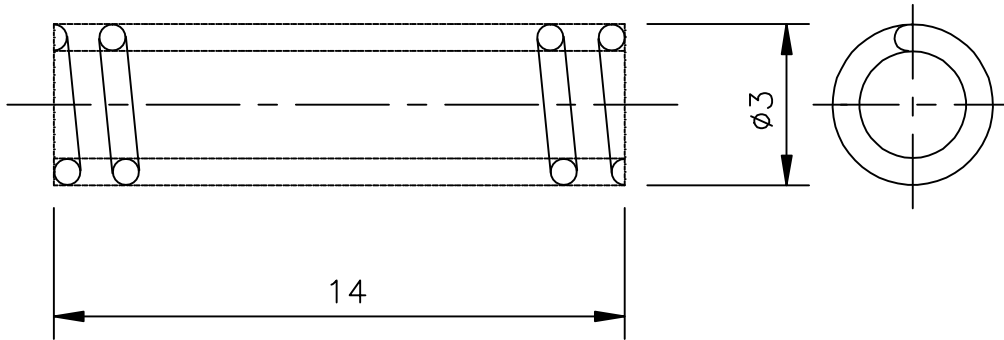
Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)	
SCALE:- NTS		QTY.- 2 Nos.		ADRDE AGRA	DRN.	SK SHARMA			
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA			
TOL.:- AS PER IS:2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				LOCK PIN SUPPORT PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)				PROJ.OFFR./GP.OFFR.	
MATERIAL:- STEEL ALLOY 070M55 (EN9) TO BS 970								PROJ. DIR.	
FINISH:- AS PER SHEET No. 40								APPROVED	
HEAT TREATMENT:- HARDENED & TEMPERED 28±3HRC								GROUP DIR.	
				DRG. NO. ADRDE/1407-03-03-02					



PROCESS :- MACHINING

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)	
SCALE:-NTS		QTY.- 2 Nos.		A D R D E AGRA	DRN.	SK SHARMA		PROJ.OFFR./GP.OFFR.	
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA			
TOL.:- AS PER IS:2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				RIVET PIN SUB ASSY SMALL SUPPORT PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)				PROJ. DIR.	
MATERIAL:- AUSTENITIC STAINLESS STEEL X 04 Cr 18 Ni 10 (IS:6527-1972)								APPROVED	
FINISH:- NATURAL								GROUP DIR.	
HEAT TREATMENT:-								DRG. NO. ADRDE/1407-03-03-03	





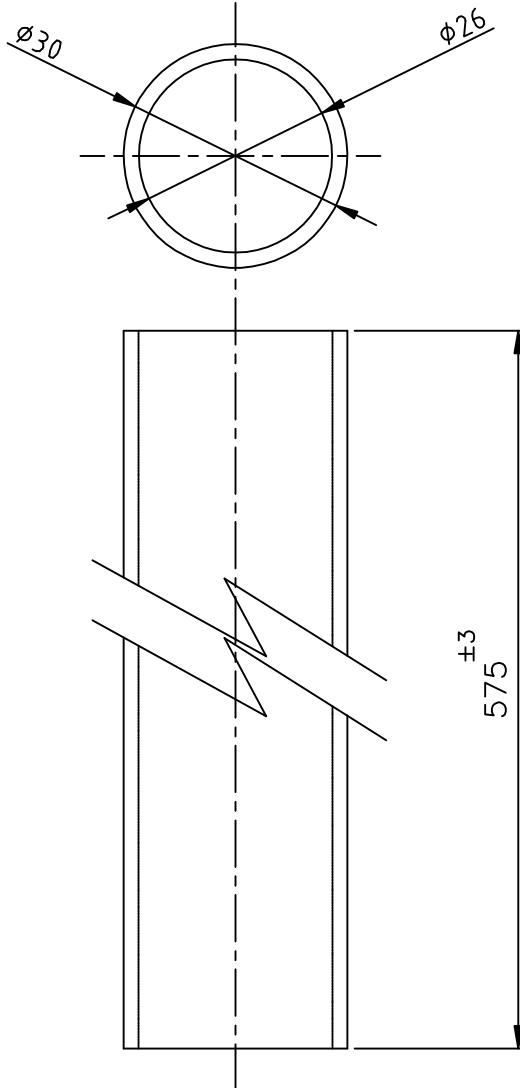
WIRE DIA.= 0.5 mm  
 No. OF TURNS = 9 active + 2 end coils  
 STIFFNESS = 0.475 kg/mm

PROCESS : - FABRICATION

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		O I/C (D&S)	HEAD (Q.A.)
SCALE:- NTS		QTY.- 2 Nos.		ADRDE AGRA	DRN.	SK SHARMA	
DIMENSIONS IN mm		GROUP:- HDS		CHKD.	JC DUTTA	PROJ.OFFR./GP.OFFR.	
TOL.:- AS PER IS:2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED		SPRING PIN SUB ASSY. SMALL SUPPORT PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)		APPROVED		PROJ. DIR.	
MATERIAL:- SS SPRING WIRE IS 4454 Gr IV						GROUP DIR.	
FINISH:- NATURAL						DRG. NO. ADRDE/1407-03-03-04	
HEAT TREATMENT:-							



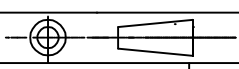




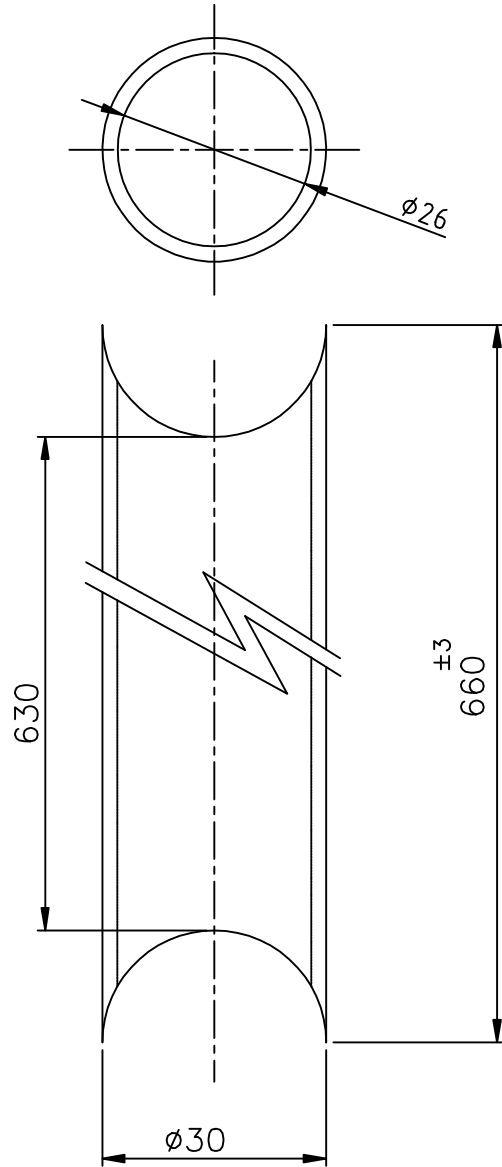
PROCESS :- FABRICATION

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Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)			
SCALE:-1:1		QTY.:- 2 Nos.		A D R D E AGRA	DRN.	SK SHARMA		PROJ.OFFR./GP.OFFR.			
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA					
TOL.:- IS:2102(Pt-1)1993 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED				PIPE MEDIUM MAIN FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)				PROJ. DIR.			
MATERIAL:- ALUMINIUM. ALLOY TUBE 64430 (HE30) T6 (WP) COND. IS :738-1994								APPROVED		GROUP DIR.	
FINISH:- AS PER ANNEXURE 'B'(GREY) AS PER SHEET No. 40								DRG. NO. ADRDE/1407-01-01			
HEAT TREATMENT:-											

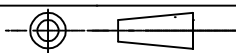


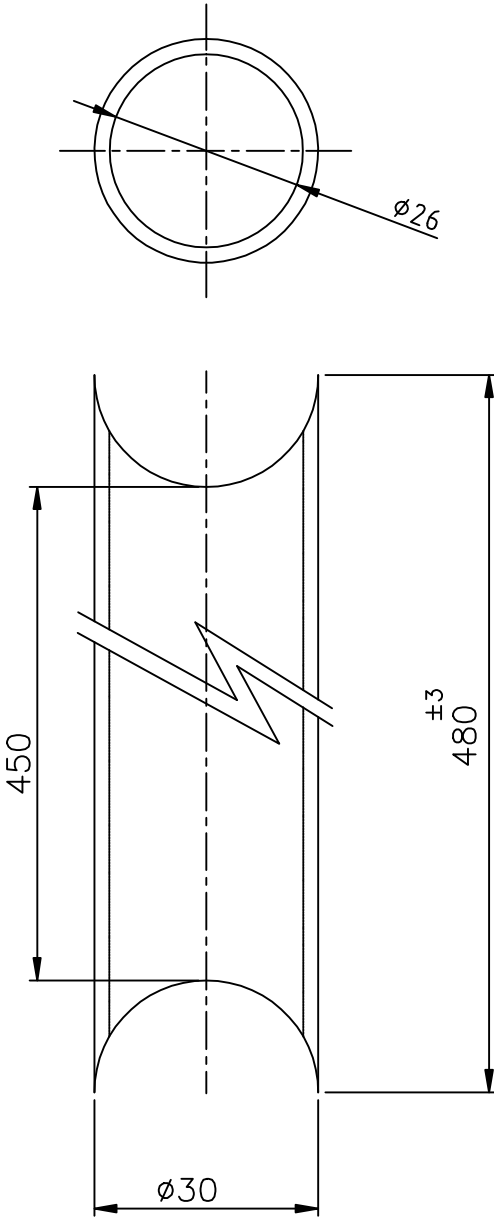




PROCESS :- FABRICATION

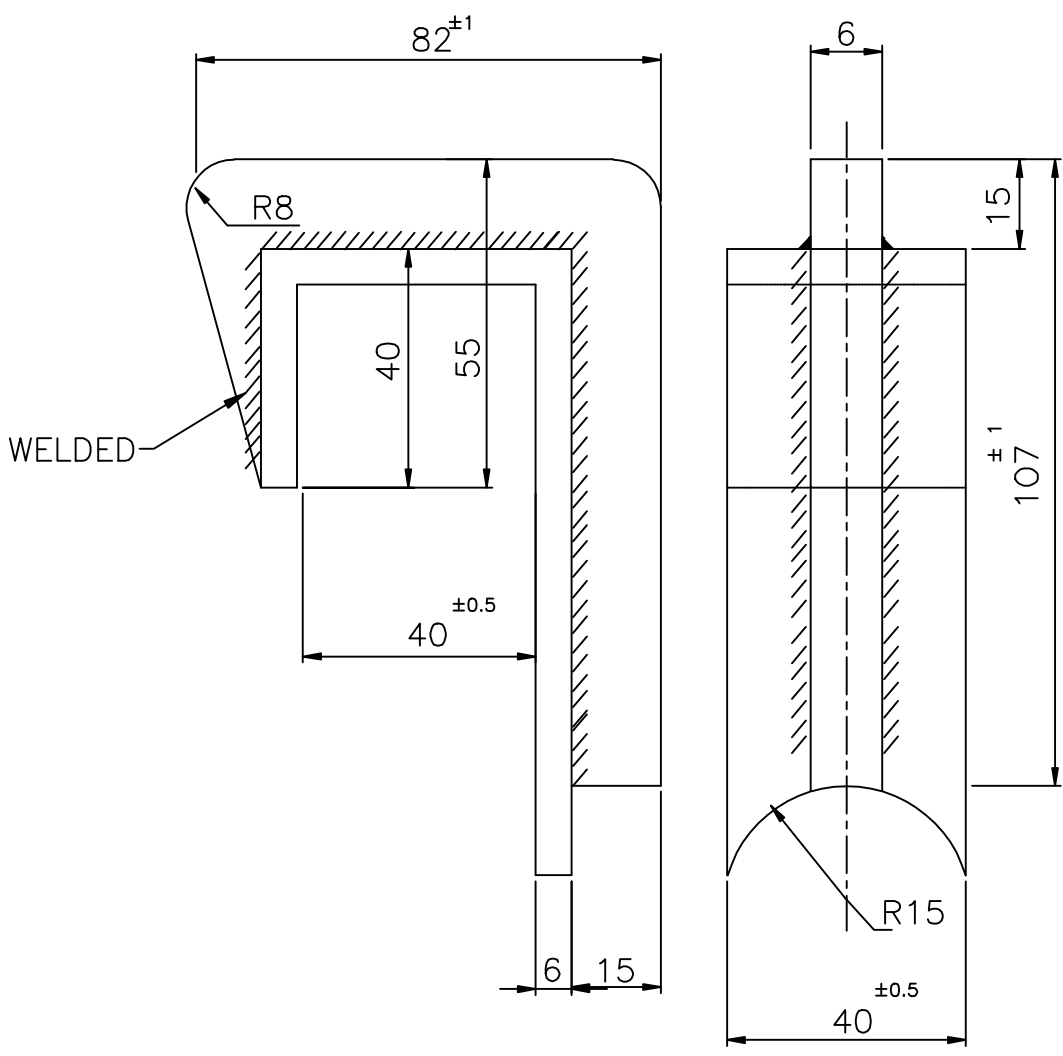
Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:-1:1	QTY.:-2 Nos.		A D R D E AGRA	DRN.	SK SHARMA	PROJ.OFFR./GP.OFFR.		
DIMENSIONS IN mm			GROUP:- HDS	CHKD.	JC DUTTA	PROJ. DIR.		
TOL.:- IS:2102(Pt-I)1993 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED			PIPE LONG MAIN FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			APPROVED		
MATERIAL:- ALUMINIUM. ALLOY TUBE 64430 (HE30) T6 (WP) COND. IS :738-1994						GROUP DIR.		
FINISH:- AS PER ANNEXURE 'B'(GREY) AS PER SHEET No.40						DRG. NO. ADRDE/1407-01-02		
HEAT TREATMENT:-								





PROCESS :- FABRICATION

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:-1:1	QTY.:- 2 Nos.		A D R D E AGRA	DRN.	SK SHARMA	PROJ.OFFR./GP.OFFR.		
DIMENSIONS IN mm			GROUP:- HDS	CHKD.	JC DUTTA			
TOL.:- IS:2102(Pt-I)1993 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED			PIPE SMALL MAIN FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			PROJ. DIR.		
MATERIAL:- ALUMINIUM. ALLOY TUBE 64430 (HE30) T6 (WP) COND. IS :738-1994						APPROVED		
FINISH:- AS PER SHEET No. 40						GROUP DIR.		
HEAT TREATMENT:-						DRG. NO. ADRDE/1407-01-03		

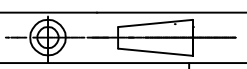


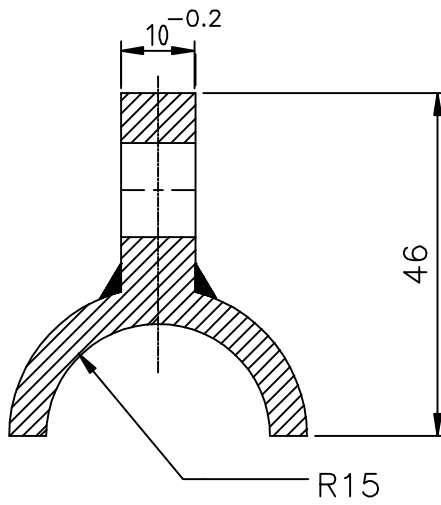
NOTE :- Welding & Examination as per details given on drg. no. ADRDE/1407-01  
(Sheet 2 of 40)

PROCESS :- FABRICATION

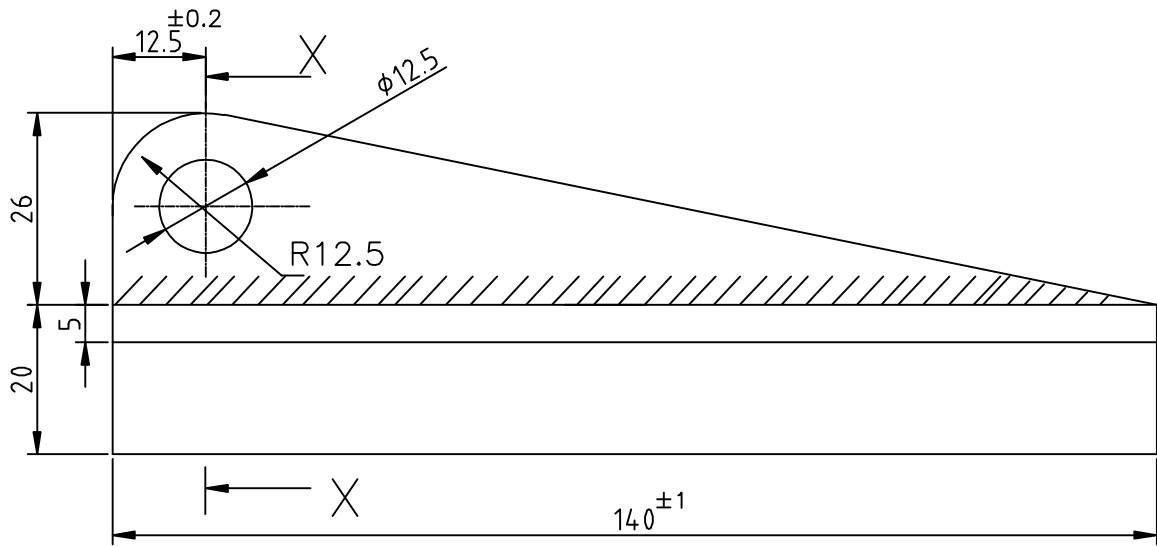
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Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)			
SCALE:-NTS		QTY.:- 2 Nos.		A D R D E A G R A	DRN.	SK SHARMA		PROJ.OFFR./GP.OFFR.			
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA					
TOL.:- IS:2102(Pt-I)1993 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED				<p>'J' BRACKET MAIN FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)</p>				PROJ. DIR.			
MATERIAL:- ALUMINIUM. ALLOY PLATE 64430 (HE30) T6 (WP) COND. IS :738-1994								APPROVED		GROUP DIR.	
FINISH:- AS PER ANNEXURE 'B'(GREY) AS PER SHEET No. 40								DRG. NO. ADRDE/1407-01-04			
HEAT TREATMENT:-											





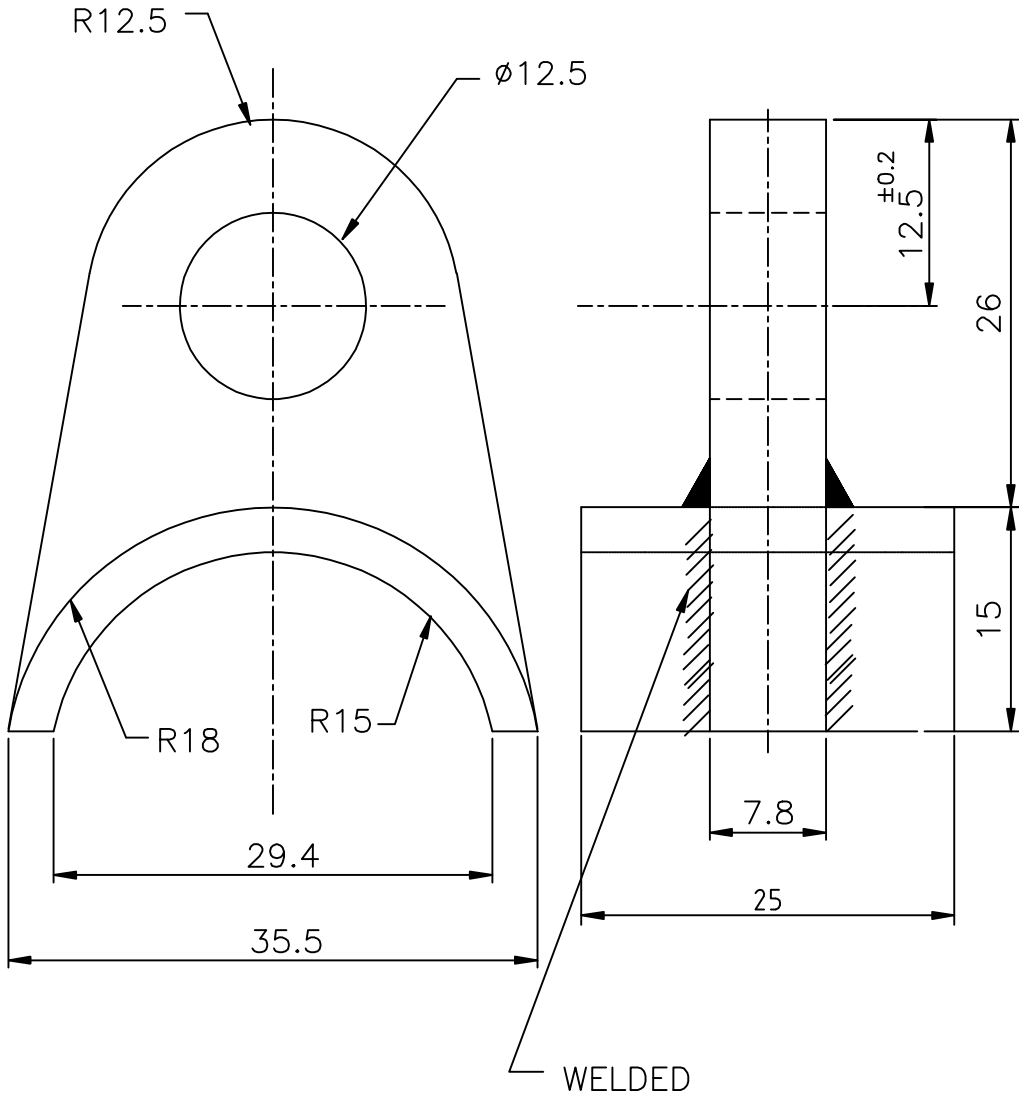
SECTION X-X



PROCESS : - FABRICATION

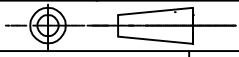
Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:-1:1	QTY.:- 2 Nos.		A D R D E AGRA	DRN.	SK SHARMA			
DIMENSIONS IN mm			GROUP:- HDS	CHKD.	JC DUTTA	PROJ.OFFR./GP.OFFR.		
TOL.:- IS:2102(Pt-I)1993 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED			GUSSET BRACKET MAIN FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			PROJ. DIR.		
MATERIAL:- ALUMINIUM. ALLOY PLATE 64430 (HE-30) T6 (W/WP) COND. IS :738-1994						APPROVED		
FINISH:- AS PER ANNEXURE 'B'(GREY) AS PER SHEET No. 40								
HEAT TREATMENT:-						GROUP DIR.		
HEAT TREATMENT:-			DRG. NO. ADRDE/1407-01-05					

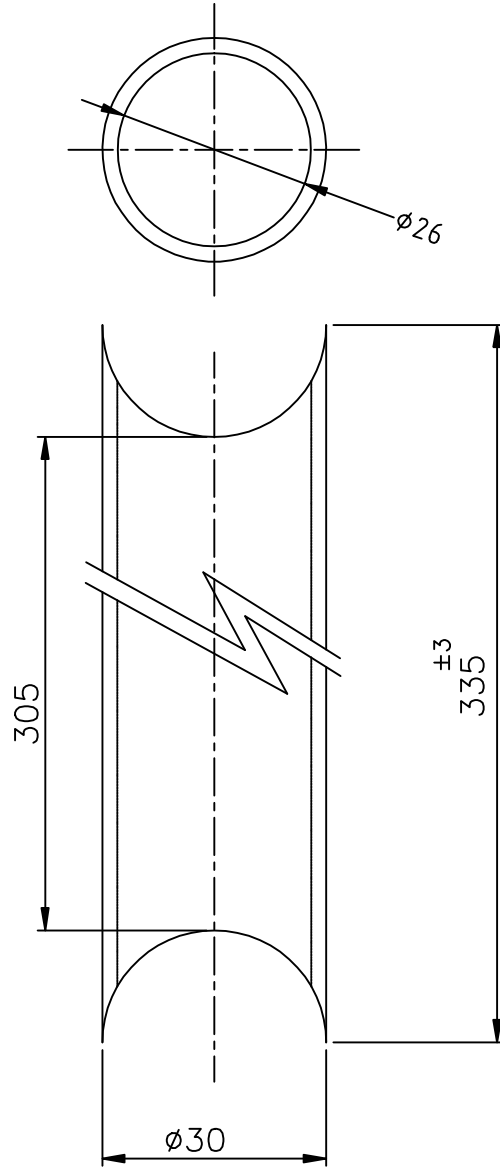




PROCESS :- FABRICATION

Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)		
SCALE:-2:1		QTY:- 2 Nos.		A D R D E AGRA	DRN.	SK SHARMA		PROJ.OFFR./GP.OFFR.			
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA					
TOL.:- IS:2102 (Pt-I) 1993 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED				BRACKET MIDDLE MAIN FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)				PROJ. DIR.			
MATERIAL:- ALUMINIUM. ALLOY PLATE 64430 (HE30) T6 (W/WP) COND. IS :738-1994								APPROVED		GROUP DIR.	
FINISH:- AS PER ANNEXURE 'B'(GREY) AS PER SHEET No. 40								DRG. NO. ADRDE/1407-01-06			
HEAT TREATMENT:-											





PROCESS :- FABRICATION

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:-1:1	QTY.:- 2 Nos.		A D R D E AGRA	DRN.	SK SHARMA	PROJ.OFFR./GP.OFFR.		
DIMENSIONS IN mm			GROUP:- HDS	CHKD.	JC DUTTA	PROJ. DIR.		
TOL.:- IS:2102 (Pt-I) 1993 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED			PIPE MAIN FRAME PARA FRAME SMALL (HD SYSTEM FOR AN-32 A/C)			APPROVED		
MATERIAL:-ALUMINIUM. ALLOY TUBE 64430 (HE30) T6 (WP) COND. IS :738-1994						GROUP DIR.		
FINISH:- AS PER ANNEXURE 'B'(GREY) AS PER SHEET No. 40						DRG. NO. ADRDE/1407-01-07		
HEAT TREATMENT:-								

