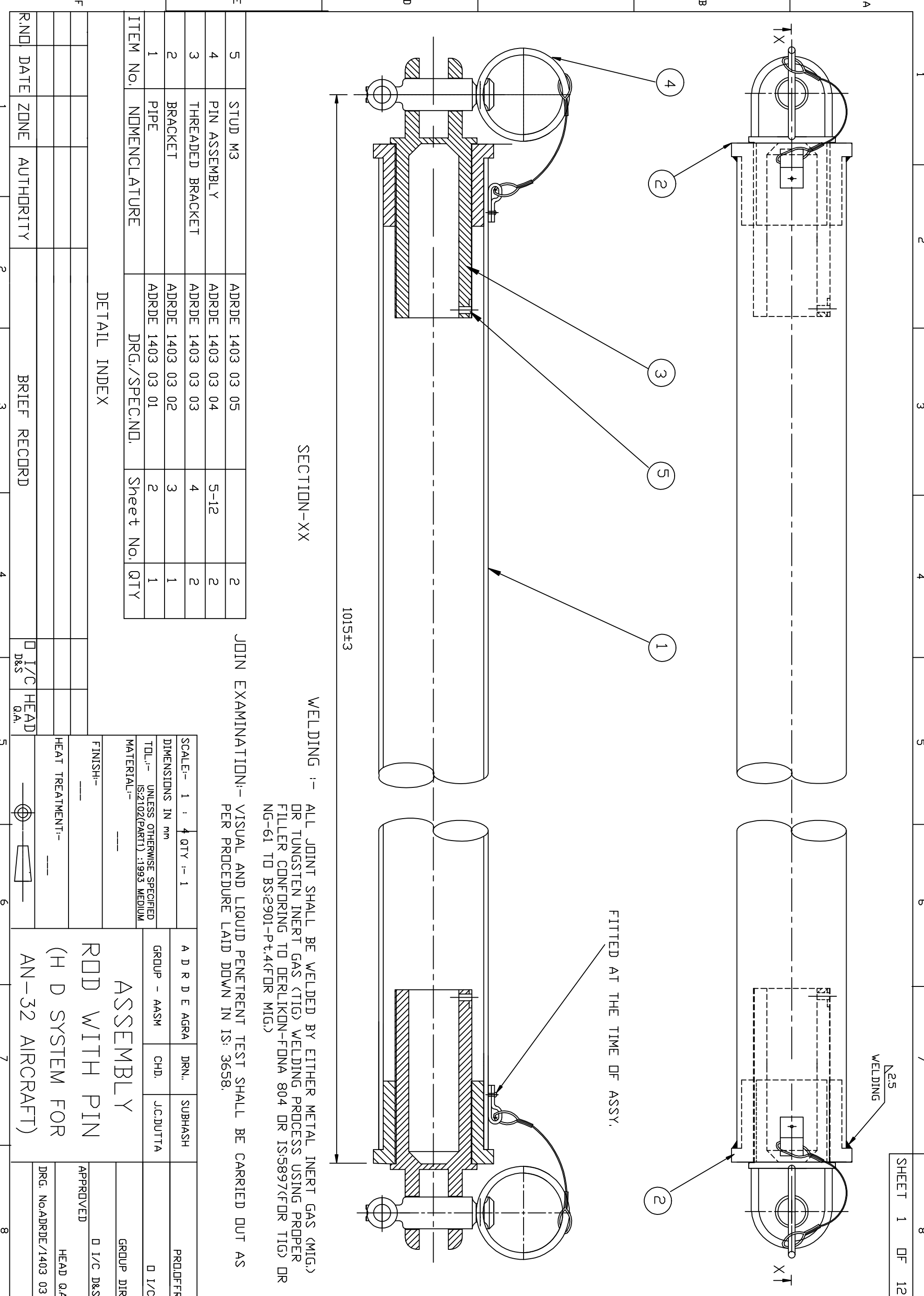
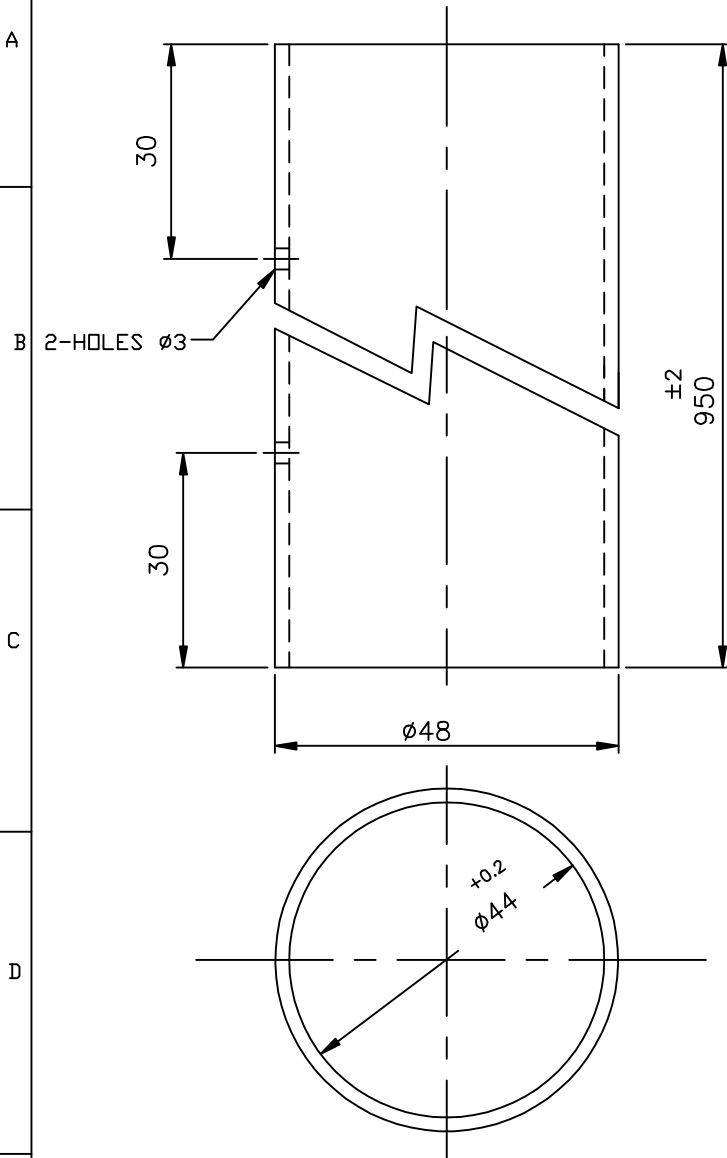
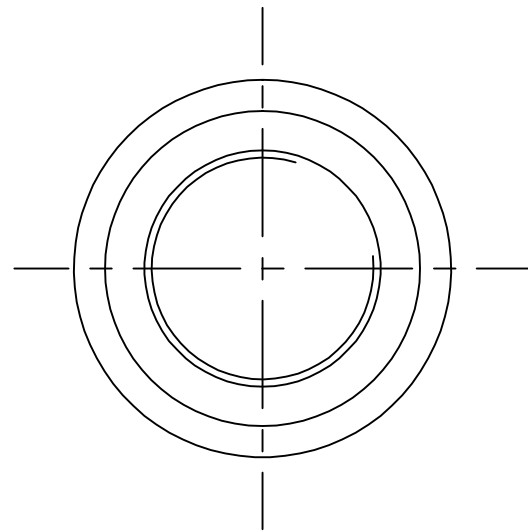
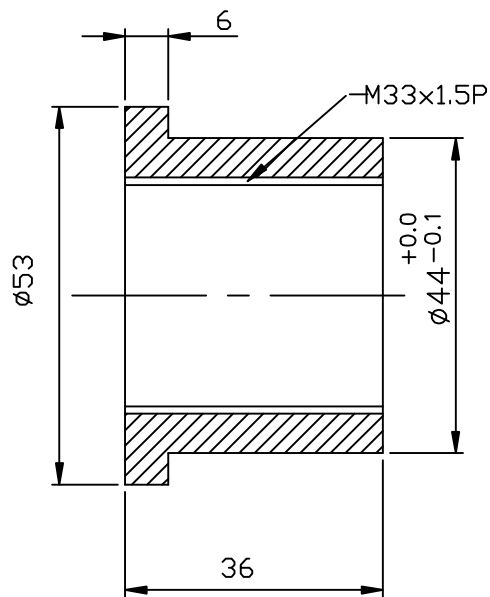


1		2		3		4		5		6		7		8	
														SHEET 1 OF 12	
															
WELDING :- ALL JOINT SHALL BE WELDED BY EITHER METAL INERT GAS (MIG) OR TUNGSTEN INERT GAS (TIG) WELDING PROCESS USING PROPER FILLER CONFORMING TO DERLIKON-FD0A 804 OR IS:58976(FOR TIG) OR NG-61 TO BS:2901-Pt.4(FOR MIG.)															
JOIN EXAMINATION:- VISUAL AND LIQUID PENETRENT TEST SHALL BE CARRIED OUT AS PER PROCEDURE LAID DOWN IN IS: 3658.															
SCALE:- 1 : 4 QTY :- 1															
DIMENSIONS IN mm															
TOL:- UNLESS OTHERWISE SPECIFIED															
IS:2102(PART 1):1993 MEDIUM															
MATERIAL:-															
FINISH:-															
HEAT TREATMENT:-															
ASSEMBLY															
ROD WITH PIN															
(H D SYSTEM FOR															
AN-32 AIRCRAFT)															
APPROVED															
HEAD Q.A.															
DRG. No.ADRDE/1403 03															



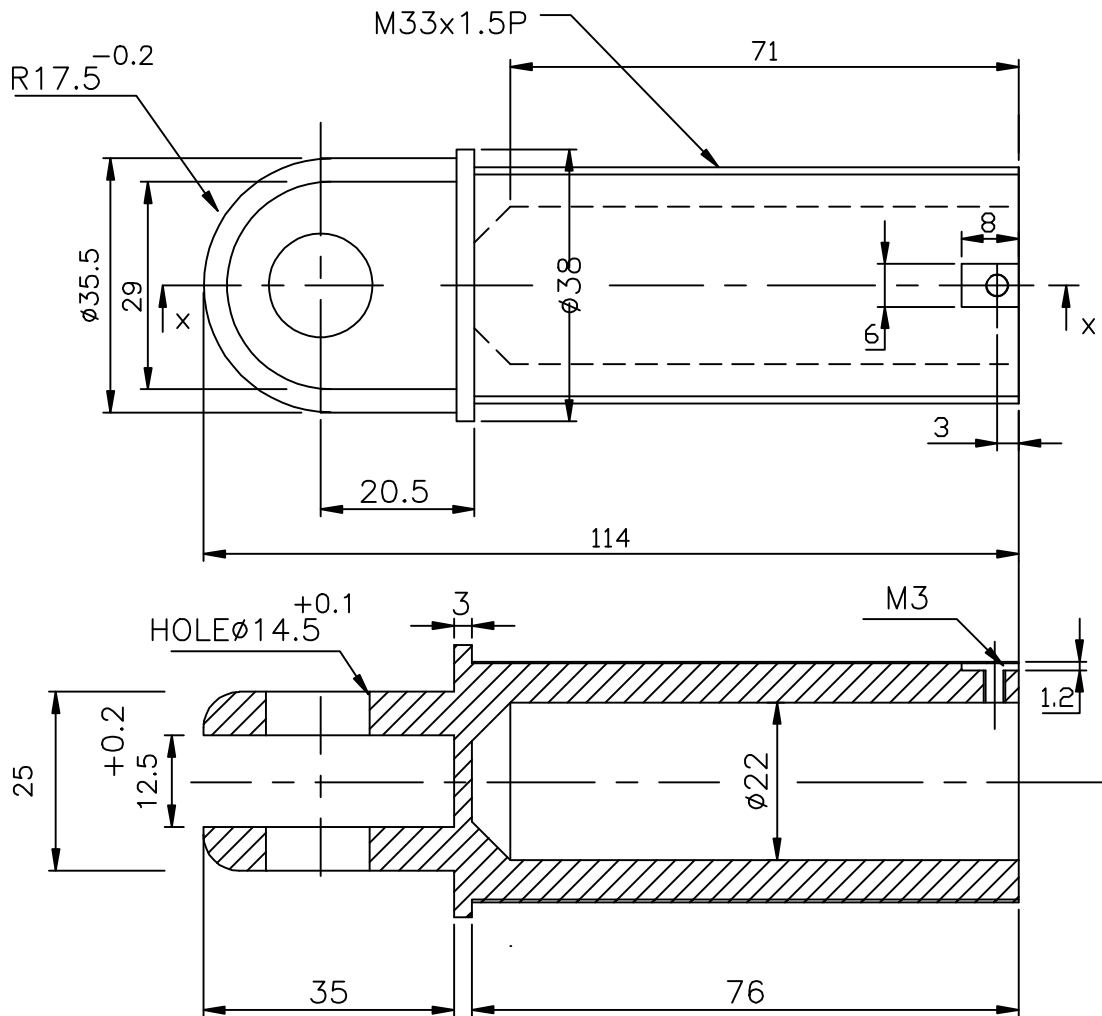
PROCESS ; FABRICATION

R.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		I/C HEAD D&S Q.A.
SCALE:- 1 : 1		QTY.- 1		ADRDE AGRA	DRN..	SK SHARMA	PRO.DFFR.
DIMENSIONS IN mm				GROUP	HDS	CHD.	JC DUTTA
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM				PIPE ROD WITH PIN (H D SYSTEM FOR AN-32 AIRCRAFT)			
MATERIAL:- ALUMINIUM.ALLOY GRADE 64430 (HE-30) IS:733				GROUP DIR.			
FINISH:- ANNEXURE 'B'				I/C D&S			
HEAT TREATMENT:- WP CONDITION				APPROVED			
				HEAD Q.A.			
				DRG. NO. ADRDE/1403 03 01			



PROCESS : MACHINING

R.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			☐ I/C D&S	HEAD Q.A.
SCALE:- 1 : 1		QTY.- 2		A D R D E AGRA		DRN..	SK SHARMA	PRO.DFFR.	
DIMENSIONS IN mm				GROUP HDS		CHD.	JC DUTTA	OIC	
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM				BRACKET ROD WITH PIN (H D SYSTEM FOR AN-32 AIRCRAFT)					
MATERIAL:- ALUMINIUM .ALLOY GRADE 64430 (HE-30) IS:733									
FINISH:- ANNEXURE'B'									
HEAT TREATMENT:- W CONDITION									
				GROUP DIR. ☐ I/C D&S APPROVED HEAD Q.A. DRG. NO. ADRDE/ 1403 03 02					



SECTION XX

PROCESS : MACHINING

R.No.

DATE

ZONE

AUTHORITY

BRIEF RECORD

☐ I/C HEAD
D&S Q.A.

SCALE:- 1 : 1 QTY.- 2

A D R D E AGRA

DRN..

SK SHARMA

PRO.DFFR.

DIMENSIONS IN mm

GROUP HDS

CHD.

JC DUTTA

DIC

 MATERIAL:- EN19/EN24, ROD ø38
(709M40/817M40) BS:970

 THREADED BRACKET
ROD WITH PIN
(H D SYSTEM FOR
AN-32 AIRCRAFT)

GROUP DIR.

☐ I/C D&S

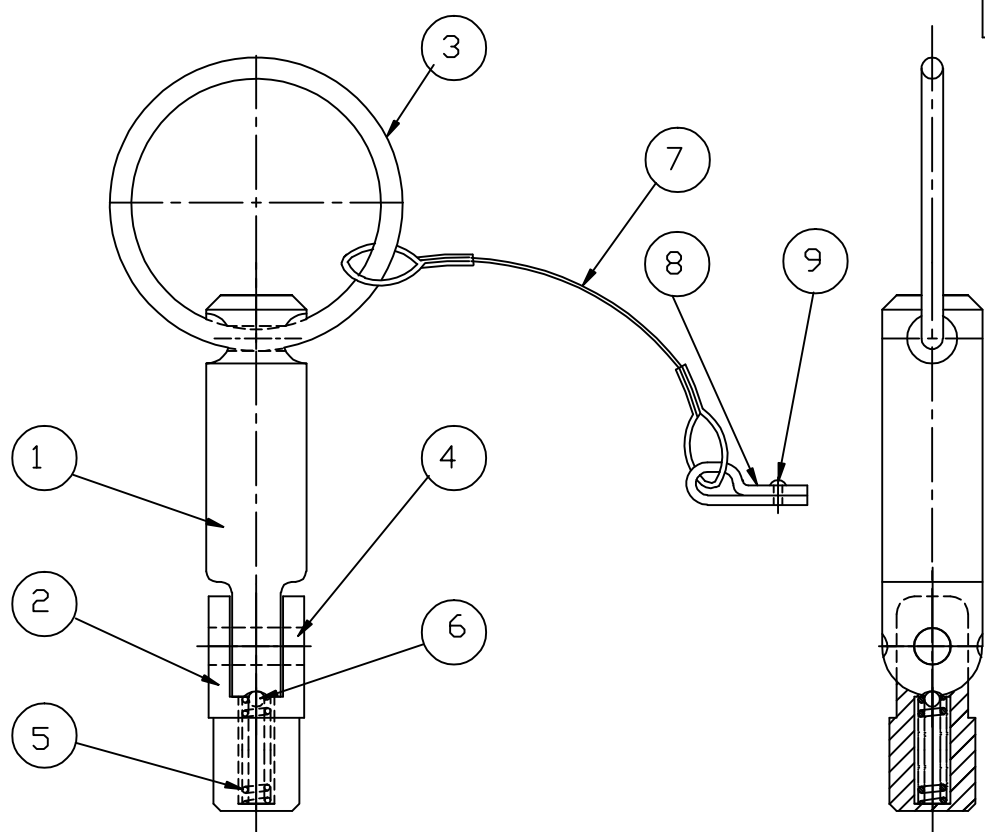
APPROVED

HEAD Q.A.

DRG. NO. ADRDE/ 1403 03 03

 FINISH:- CADMIUM PLATING AS PER
IS:1572 Gr3,10-12u

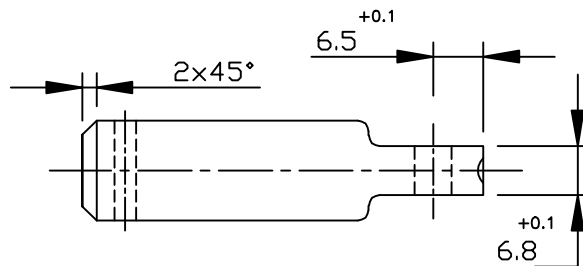
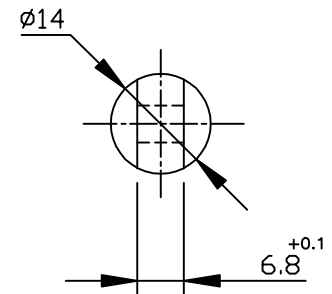
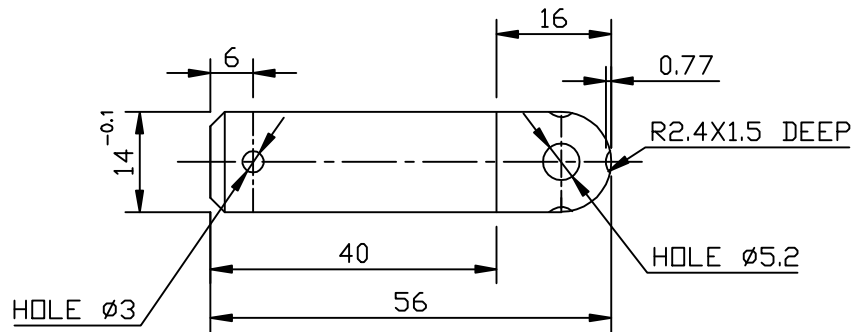
 HEAT TREATMENT:-
HARDENED & TEMPERED
32±5 HRC

9	ROUND HEAD STEEL SCREW M3X6	COMMERCIAL QUALITY	—	1
8	CLIP	ADRDE/ 1403 03 04 06	12	1
7	MOUNTING WIRE	ADRDE/ 1403 03 05	11	1
6	STAINLESS STEEL BALL (COM. QLTY) Ø4.76	—	—	1
5	SPRING	ADRDE/ 1403 03 04 04	9	1
4	RIVET	ADRDE/ 1403 03 04 03	8	1
3	RING	ADRDE/ 1403 01 04 05	10	1
2	PIN LOCK	ADRDE/ 1403 03 04 02	7	1
1	PIN	ADRDE/ 1403 03 04 01	6	1
SR.No.	DESIGNATION	DRG. /SPEC.No.	SHEET No.	QTY

PROCESS :
FABRICATION

R.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		☐ I/C D&S	HEAD Q.A.
SCALE:- 1:1		QTY.: 1 No.		A D R D E AGRA	DRN..	SUBHASH	PRO.DFFR.	
DIMENSIONS IN mm				GROUP	CHD.	J.C.DUTTA	DIC	
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM				PIN ASSEMBLY ROD WITH PIN (H D SYSTEM FOR AN-32 AIRCRAFT)		GROUP DIR.		
MATERIAL:-						☐ I/C D&S		
FINISH:-						APPROVED		
HEAT TREATMENT:-						HEAD Q.A.		
DRG. NO.ADRDE/ 1403 03 04 A								



R.No. DATE ZONE AUTHORITY

BRIEF RECORD

I/C HEAD
D&S Q.A.

SCALE:- 2 : 1 QTY.- 1

A D R D E AGRA

DRN..

SUBHASH

PRO.DFFR.

DIMENSIONS IN mm

GROUP

CHD.

J.C.DUTTA

I/C

MATERIAL:- STEEL ALLOY 070M55
(EN9) TO BS 970

GROUP DIR.

FINISH:- ANNEXURE 'C'

I/C D&S

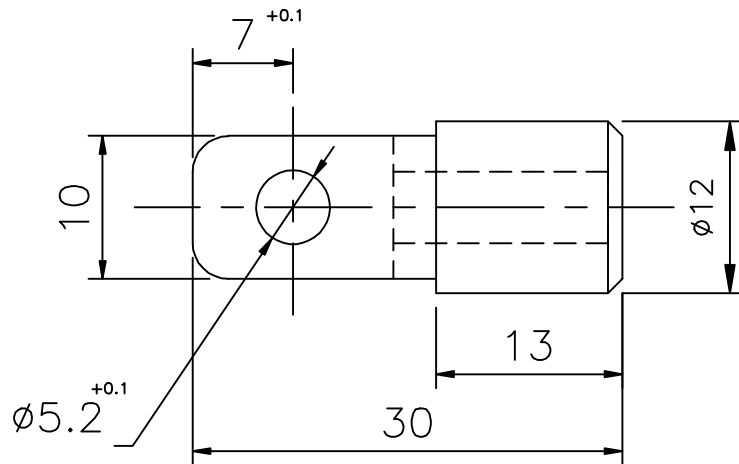
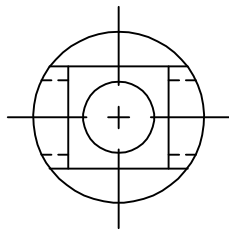
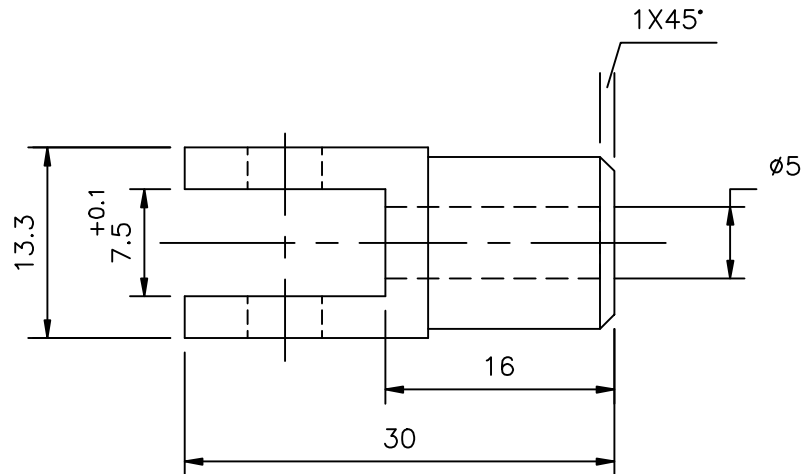
APPROVED

HEAD Q.A.

HEAT TREATMENT:-
HARDENED & TEMPERED 28 $\pm$ 3HRC

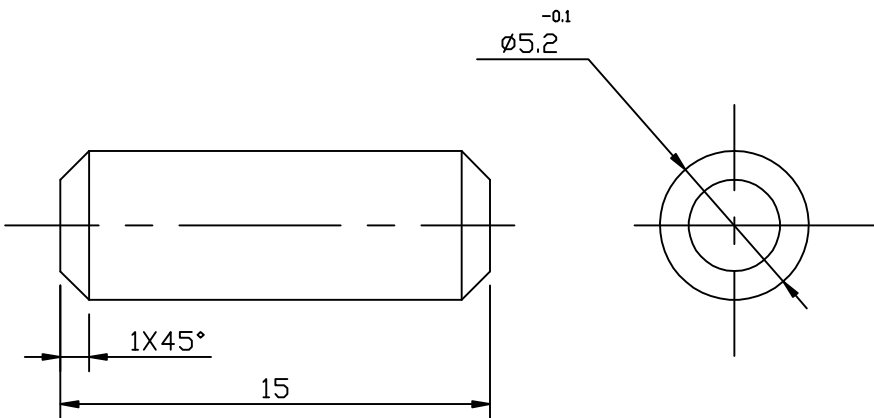
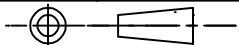
DRG. No.. ADRDE/1403 03 04 01

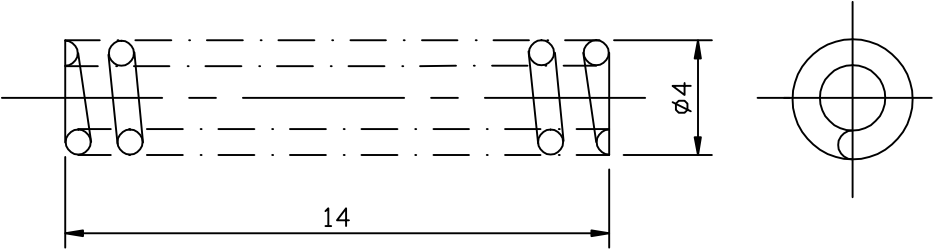


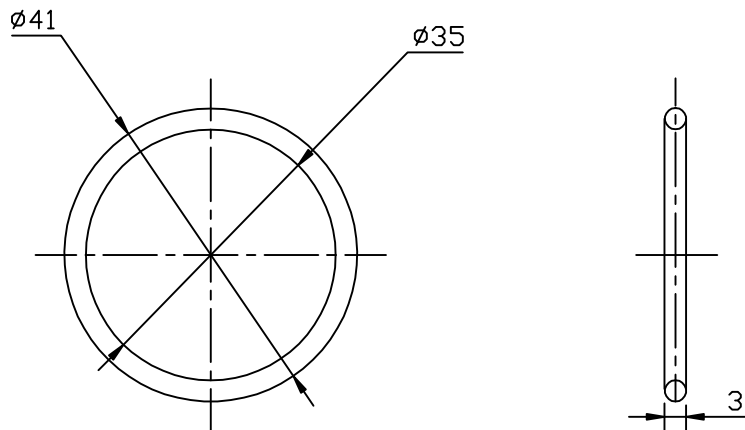


PROCESS : MACHINING

R.No.		DATE		ZONE		AUTHORITY		BRIEF RECORD				I/C HEAD D&S Q.A.	
SCALE:- 2 : 1		QTY.- 1		A D R D E AGRA		DRN..		SUBHASH		PRO.DFFR.			
DIMENSIONS IN mm				GROUP		CHD.		J.C.DUTTA		OIC			
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM				LOCK PIN ROD WITH PIN (H D SYSTEM FOR AN-32 AIRCRAFT)		APPROVED		GROUP DIR.		O I/C D&S		HEAD Q.A.	
MATERIAL:- STEEL ALLOY 070M55 (EN9) TO BS 970													
FINISH:- ANNEXURE 'C' FLASH Gr.													
HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC													

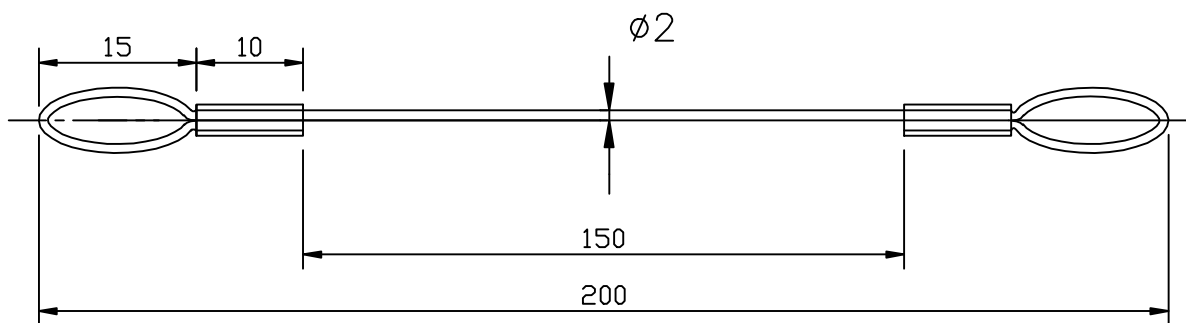
1		2		3		4	
						SHEET 8 OF 12	
A							A
B							B
C							C
D							D
E	PROCESS : MACHINING						E
R.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		☐ I/C HEAD D&S Q.A.
SCALE:- 4 : 1		QTY.: 1		A D R D E AGRA	DRN..	S.K.SHARMA	PRO.DFFR.
DIMENSIONS IN mm				GROUP	CHD.	J.C.DUTTA	IIC
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM				RIVET ROD WITH PIN (H D SYSTEM FOR AN-32 AIRCRAFT)		GROUP DIR.	
MATERIAL:- SPRING STEEL IS:4454 GRADE IV.						☐ I/C D&S	
FINISH:- NORMAL						APPROVED	
HEAT TREATMENT:- NORMALISED						HEAD Q.A.	
				DRG. NO.ADRDE/ 1403 03 04 03			
1		2		3		4	
F							F

1		2		3		4	
						SHEET 9 OF 12	
A							A
B							B
C							C
D							D
E	PROCESS : FABRICATION WIRE DIA.= 0.8 No. OF TURNS = 11 No. OF ACTIVE TURNS = 9 STIFFNESS : 0.475 kg/mm						E
R.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		☐ I/C HEAD D&S Q.A.
SCALE:- 4:1		QTY.: 1		A D R D E AGRA	DRN..	S.K.SHARMA	PRO.DFFR.
DIMENSIONS IN mm				GROUP	CHD.	J.C.DUTTA	OIC
TOL.i:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM				SPRING ROD WITH PIN (H D SYSTEM FOR AN-32 AIRCRAFT)		GROUP DIR.	
MATERIAL:- SS SPRING WIRE IS:4454 GRADE IV.						☐ I/C D&S	
FINISH:- ANNEXURE 'D'						APPROVED	
HEAT TREATMENT:-						HEAD Q.A.	
				DRG. NO.ADRDE/ 1403 03 04 04			
1		2		3		4	
F							F



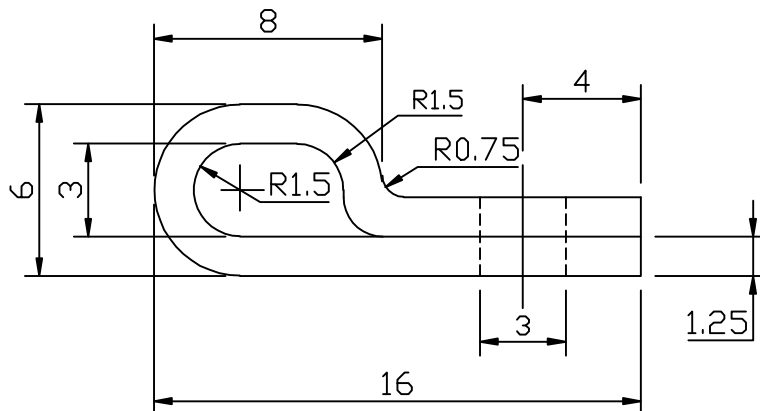
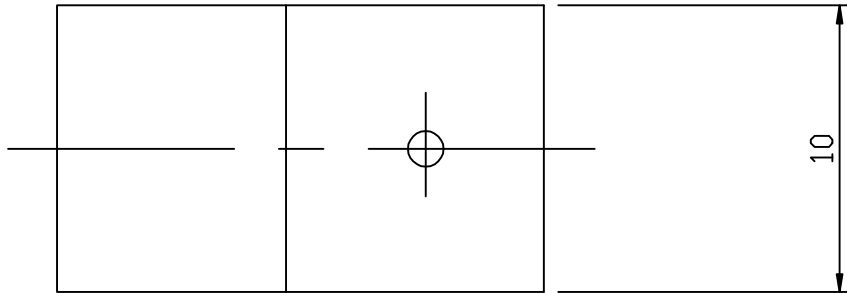
PROCESS : MACHINING

R.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		□ I/C D&S	HEAD Q.A.
SCALE: 1:1		QTY.: 1		A D R D E AGRA	DRN..	subhash	PRO.DFFR.	
DIMENSIONS IN mm				GROUP	CHD.	J.C.DUTTA	□ IC	
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM				RING ROD WITH PIN (H D SYSTEM FOR AN-32 AIRCRAFT)		GROUP DIR.		
MATERIAL:- SPRING STEEL IS:4454 GRADE IV.						□ I/C D&S		
FINISH:- NORMAL						APPROVED		
HEAT TREATMENT:- NORMALISED						HEAD Q.A.		
						DRG. NO.ADRDE/ 1403 03 04 05		



PROCESS : MACHINING

R.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		☐ I/C D&S	HEAD Q.A.
SCALE:- NTS		QTY.: 1		A D R D E AGRA	DRN..	subhash	PRO.DFFR.	
DIMENSIONS IN mm				GROUP	CHD.	J.C.DUTTA	DIC	
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM				MOUNTING WIRE ROD WITH PIN (H D SYSTEM FOR AN-32 AIRCRAFT)		GROUP DIR.		
MATERIAL:-						☐ I/C D&S		
FINISH:-						APPROVED		
HEAT TREATMENT:-						HEAD Q.A.		
						DRG. NO.ADRDE/ 1403 03 05		



PROCESS : MACHINING

R.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		☐ I/C HEAD D&S Q.A.
SCALE:- 4 : 1		QTY:- 2		A D R D E AGRA	DRN..	subhash	PRO.DFFR.
DIMENSIONS IN mm				GROUP	CHD.	J.C.DUTTA	OIC
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM				CLIP ROD WITH PIN (H D SYSTEM FOR AN-32 AIRCRAFT)		GROUP DIR.	
MATERIAL:- SPRING STEEL IS:4454 GRADE IV.						☐ I/C D&S	
FINISH:- NORMAL						APPROVED	
HEAT TREATMENT:- NORMALISED						HEAD Q.A.	
				DRG. NO.ADRDE/ 1403 03 04 03			