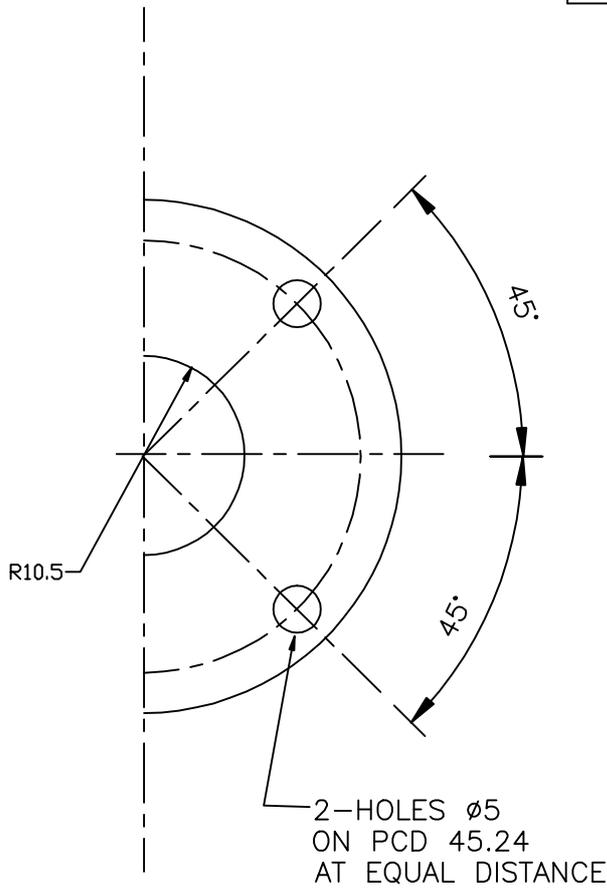
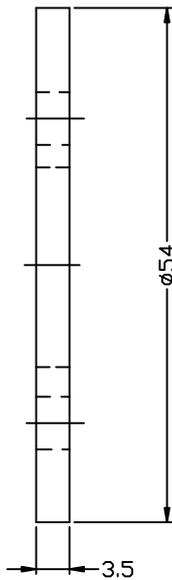


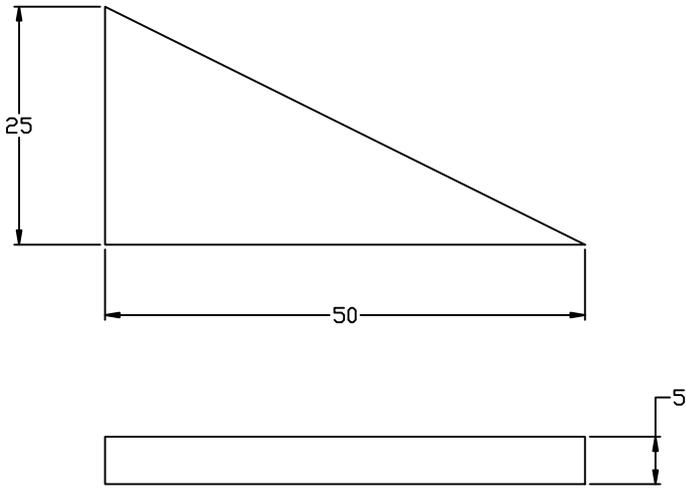
NOTE : - SPACER IS TO BE PRESS FITTED ON HANDLE (SHEET 9 OF 13)
 PROCESS : - MACHINING

| | | | | | | | | |
|---|--------------|------|---|--------------|-----------|------------------------|--------------|----------------|
| Ref.No | DATE | ZONE | AUTHORITY | BRIEF RECORD | | | I/C (D&S) | HEAD (Q.A.) |
| SCALE:- 8:1 | QTY:- 4 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 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED | | | SPACER LOADING BRACKET (LEFT & RIGHT) HD SYSTEM FOR AN 32 A/C | | | PROJ. DIR. | | |
| MATERIAL:- MILD STEEL St42-S, AS PER IS:226 | | | | | | APPROVED | | |
| FINISH:- AS PER SHEET No.13 | | | | | | GROUP DIR. | | |
| HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC | | | | | | DRG. No. ADRDE/1414-08 | | |
| | | | | | | | | |



PROCESS :- MACHINING

| | | | | | | | | | | |
|---|--|--------------|------|---|--------------|-----------|---|------------------------|------------|--|
| Ref.No | | DATE | ZONE | AUTHORITY | BRIEF RECORD | | <input type="checkbox"/> I/C HEAD (D&S) (Q.A.) | | | |
| SCALE:-2:1 | | QTY:- 4 Nos. | | ADRDE AGRA | DRN. | SK SHARMA | | | | |
| DIMENSIONS IN mm | | | | GROUP:- HDS | CHKD. | JC DUTTA | | | | |
| TOL:-IS:2102 (Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED | | | | <p style="text-align: center;">WASHER LARGE LOADING BRACKET (LEFT & RIGHT) HD SYSTEM FOR AN 32 A/C</p> | | | | PROJ.OFFR./GP.OFFR. | | |
| MATERIAL:- MILD STEEL St42-S,AS PER IS:226 | | | | | | | | PROJ. DIR. | | |
| FINISH:- AS PER SHEET No. 13 | | | | | | | | APPROVED | GROUP DIR. | |
| HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC | | | | | | | | DRG. No. ADRDE/1414-09 | | |
| | | | | | | | | | | |



PROCESS :- MACHINING

| | | | | | | | | | |
|--|--|--------------|------|--|--------------|-----------|------------------------|----------------|--|
| Ref.No | | DATE | ZONE | AUTHORITY | BRIEF RECORD | | I/C (D&S) | HEAD (Q.A.) | |
| SCALE:- 2:1 | | QTY:- 2 Nos. | | ADRDE AGRA | DRN. | SK SHARMA | | | |
| DIMENSIONS IN mm | | | | GROUP:- HDS | CHKD. | JC DUTTA | | | |
| TOL:- IS:2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED | | | | SUPPORT PLATE LOADING BRACKET (LEFT & RIGHT) HD SYSTEM FOR AN 32 A/C | | | PROJ.OFFR./GP.OFFR. | | |
| MATERIAL:- MILD STEEL St42-S,AS PER IS:226 | | | | | | | PROJ. DIR. | | |
| FINISH:- NORMAL | | | | | | | APPROVED | | |
| HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC | | | | | | | GROUP DIR. | | |
| | | | | | | | DRG. No. ADRDE/1414-10 | | |

| ITEM No. | DRG./SPEC. No. | NOMENCLATURE | QTY | SHEET No |
|----------|----------------|--------------------------|--------|----------|
| — | — | PROCEDURE FOR FINISH | — | 13 |
| 11 | ADRDE/1414-10 | SUPPORT PLATE | 2 | 12 |
| 10 | IS : 6101-1971 | PAN HEAD SCREW M5x8 | 8 | — |
| 9 | ADRDE/1414-09 | WASHER LARGE | 4 | 11 |
| 8 | ADRDE/1414-08 | SPACER | 4 | 10 |
| 7 | ADRDE/1414-07 | HANDLE | 2 | 9 |
| 6 | ADRDE/1414-06 | SHAFT | 2 | 8 |
| 5 | ADRDE/1414-05 | WASHER SMALL | 2 | 7 |
| 4 | ADRDE/1414-04 | SLOTTED NUT | 2 | 6 |
| 3 | ADRDE/1414-03 | SHACKLE | 2 | 5 |
| 2 | ADRDE/1414-02 | BOX | 2 | 4 |
| 1 | ADRDE/1414-01 | BODY (RIGHT)/BODY (LEFT) | 2(1+1) | 2-3 |

ITEM LIST

INSPECTION:-

- 1. VISUAL EXAMINATION - 100%.
- 2. PENETRATION FLOW DETECTION - 20%.
- 3. ULTRASONIC FLOW DETECTION - 10%.

MARKING :-

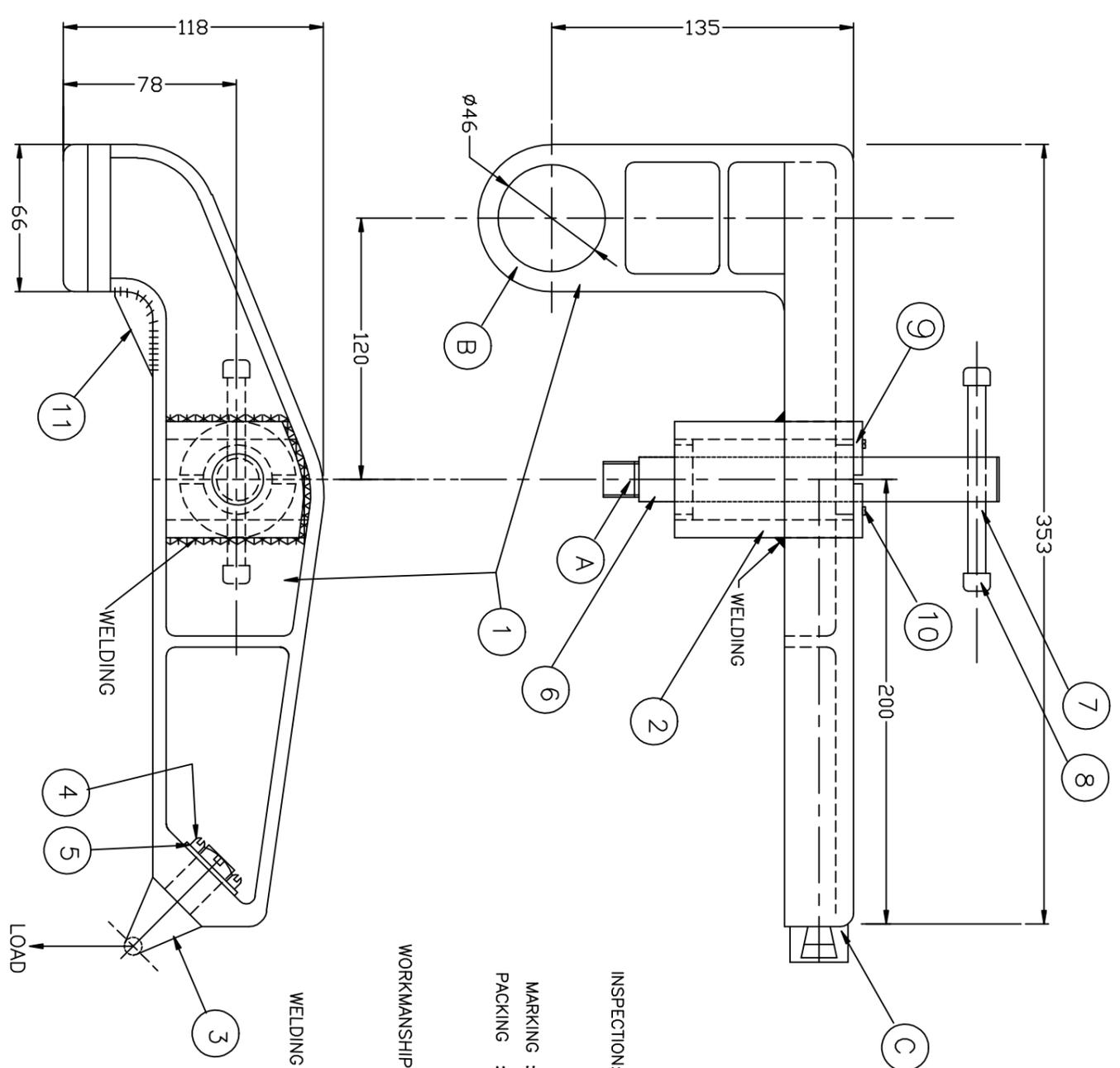
EACH ITEM SHOULD BE SEALED IN A POLYETHYLENE BAG. ONE SET OF LOADING BRACKETS (LHS & RHS ONE EACH) SEALED IN A POLYETHYLENE BAG THEN SHOULD BE PACKED IN A COBC/CARTON

WORKMANSHIP :-

THE CASTING SHOULD BE SOUND,CLEAN & FREE FROM BLOW HOLES , DISTORTION AND OTHER SURFACE DEFECTS THAT ARE LIKELY TO AFFECT THE UTILITY OF THE CASTING. SHARP CORNERS ARE TO BE ROUNDED OFF.

WELDING :-

ALL JOINTS SHOULD BE WELDED BY ELECTRODE CONFORMING TO ADVANI OERLUKON SUPERCITO AWS A/SFA 5.1:E 7018 OR IS:814:EB 5426 H3 JX OR ITS EQUIVALENT. WELDED JOINTS SHOULD BE TESTED BY DYE PENETRATION TEST (AS PER IS : 3658) BEFORE FINISH.

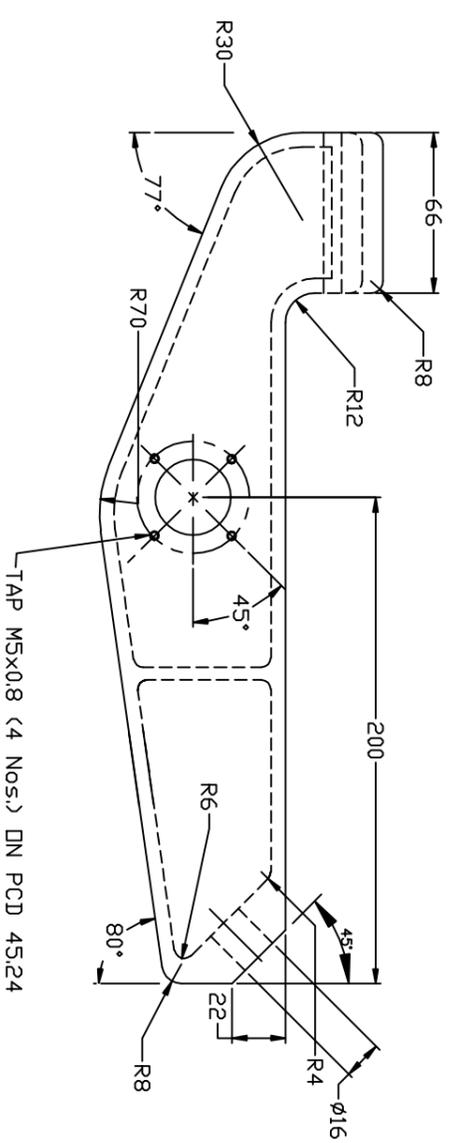


PROOF LOAD TESTING :- EACH LOADING BRACKET SHALL BE SUBJECT TO A LOAD TEST AT 1500 kgf LOAD. LOAD MAY BE APPLIED THROUGH HOOK 'C' BY HOLDING AT 'B' AND SCREW GRIPPING AT 'A' AS SHOWN IN DRAWING.

PROCESS :- FABRICATION

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

| | | | | |
|------------------|------------------------------|--------------------------------|-------|-----------|
| SCALE:-NTS | QTY:- 1 No. | A D R D E AGRA | DRN. | SK SHARMA |
| DIMENSIONS IN mm | | GROUP:- HDS | CHKD. | JC DUTTA |
| TOL:- | | ASSEMBLY | | |
| MATERIAL:- | | LOADING BRACKET (LEFT & RIGHT) | | |
| FINISH:- | AS PER SHEET No.13 | HD SYSTEM FDR AN 32 A/C | | |
| HEAT TREATMENT:- | HARDENED & TEMPERED,32±5 HRC | DRG. No. ADRDE/1414 | | |
| | | APPROVED | | |
| | | PRD.J. DIR. | | |
| | | GROUP DIR. | | |



INSPECTION :- INSPECT FOLLOWING AS PER IS:8780-1978

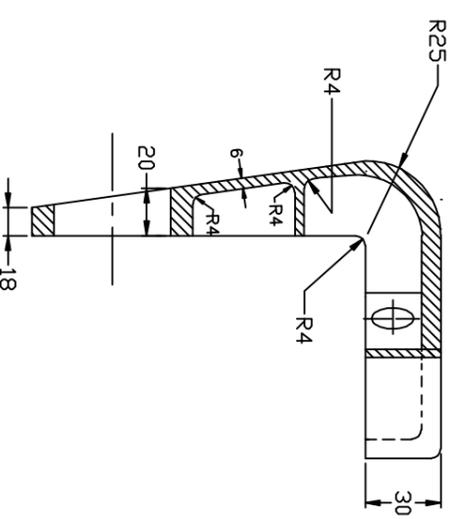
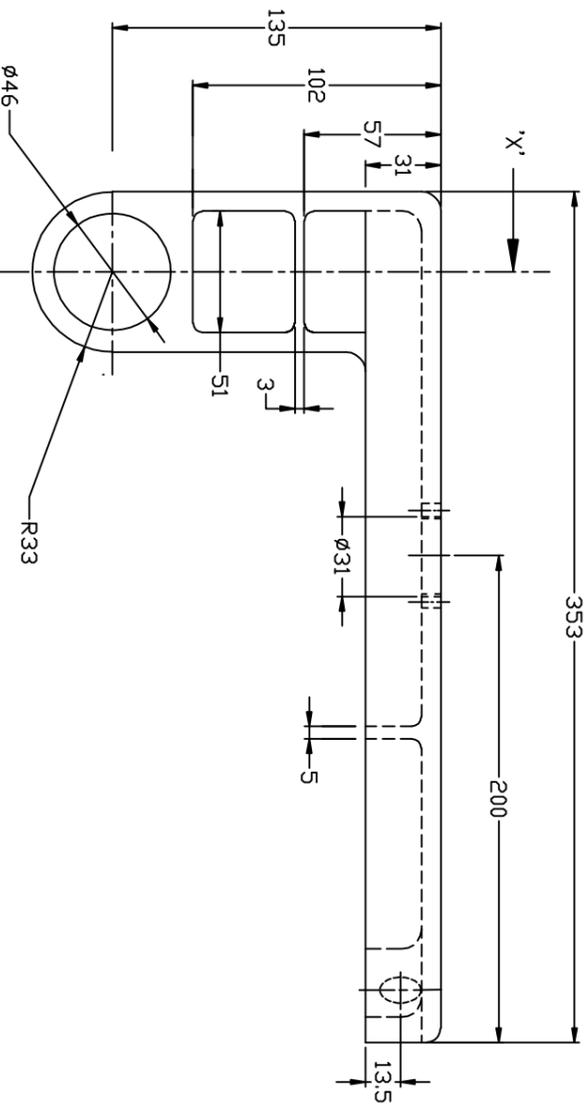
1. VISUAL EXAMINATION - 100%.
2. PENETRATION FLOW DETECTION - 20%.
3. ULTRASONIC FLOW DETECTION - 10%.

WORKMANSHIP :-

THE CASTING SHOULD BE SOUND,CLEAN & FREE FROM BLOW HOLES , DISTORTION AND OTHER SURFACE DEFECTS THAT ARE LIKELY TO AFFECT THE UTILITY OF THE CASTING. SHARP CORNERS ARE TO BE ROUNDED OFF.

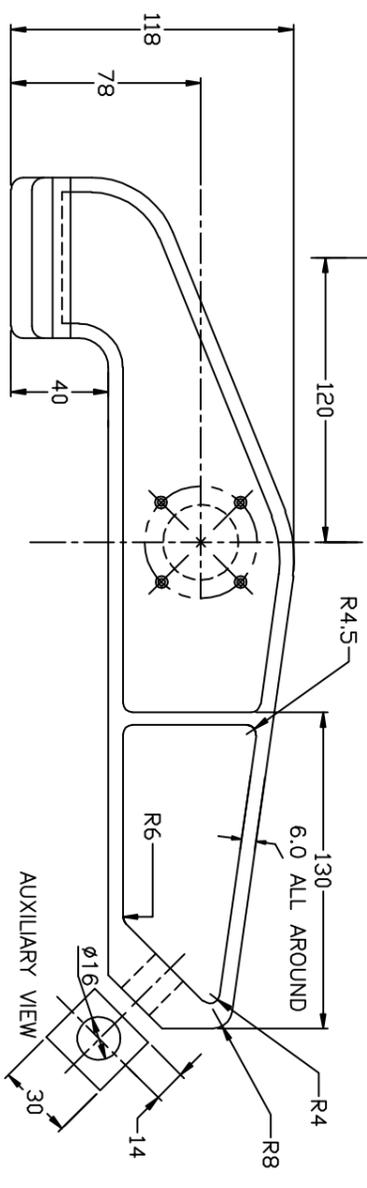
MATERIAL:- HIGH STRENGTH STEEL CASTING (G-3/4) AS PER IS:2644-1994 OR STEEL ALLOY EN19(709M40) AS PER BS:970 OR TYPE ANC-2 OF BS:3146 Pt-2:1961.

PROCESS:- CASTING



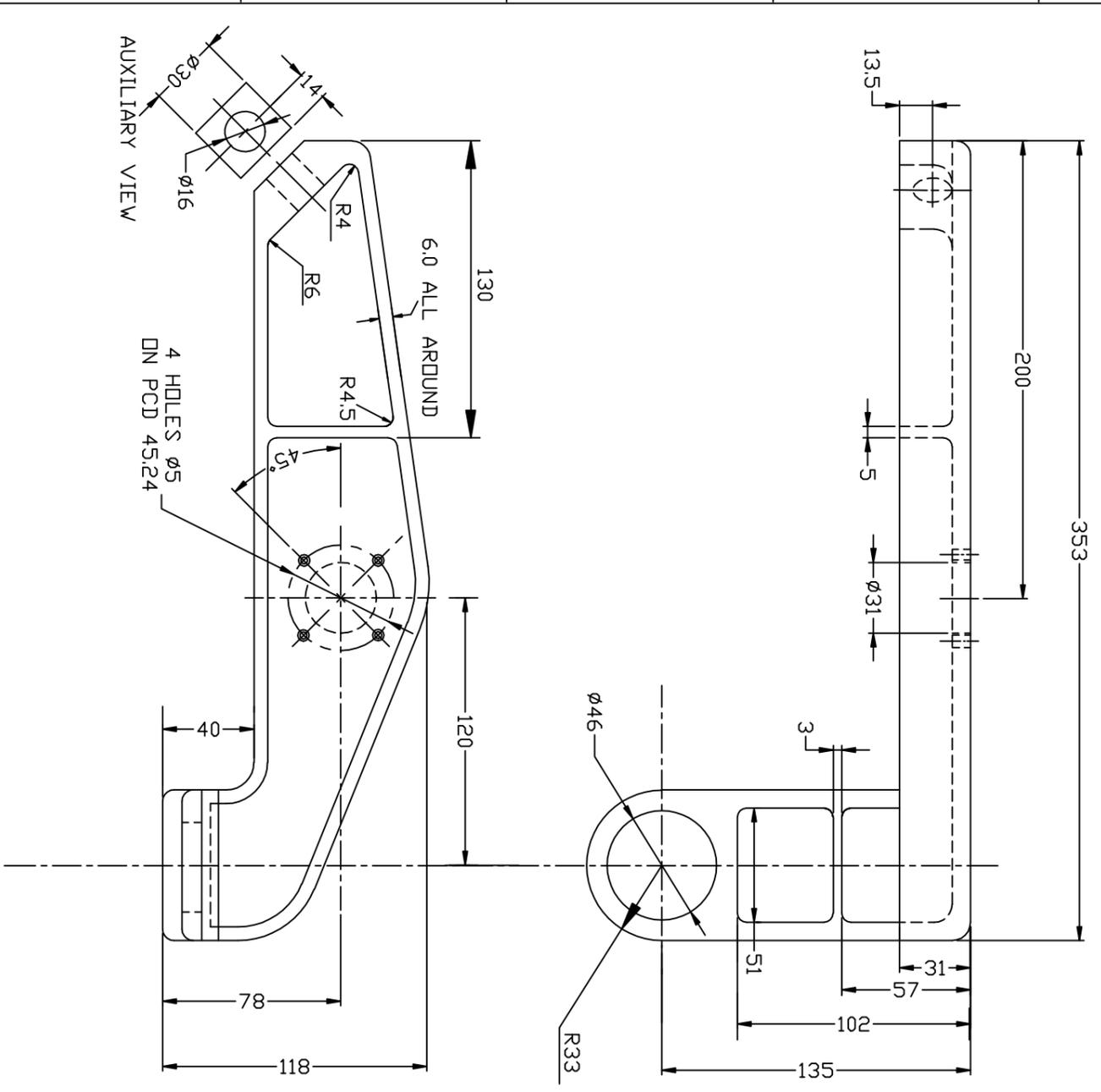
SECTION 'X'-'X'

TOL:- IS:2102 (Pt-1) 1993 VERY COARSE,EXCEPT WHERE DITHERWISE SPECIFIED.



| | | | | |
|------------------|------------------------------|---|-------|-----------|
| SCALE:-NTS | QTY. 1 No. | A D R D E AGRA | DRN. | SK SHARMA |
| DIMENSIONS IN mm | | GROUP- HDS | CHKD. | JC DUTTA |
| TOL:- | AS ABOVE | BODY (RIGHT) LOADING BRACKET (LEFT & RIGHT) | | |
| MATERIAL:- | AS ABOVE | HD SYSTEM FOR AN 32 A/C | | |
| FINISH:- | AS PER SHEET No.13 | APPROVED | | |
| HEAT TREATMENT:- | HARDENED & TEMPERED,32±5 HRC | PRD. DIR. | | |
| | | GROUP DIR. | | |

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



INSPECTION :- INSPECT FOLLOWING AS PER IS:8780-1978
 1. VISUAL EXAMINATION - 100%.
 2. PENETRATION FLOW DETECTION - 20%.
 3. ULTRASONIC FLOW DETECTION - 10%.

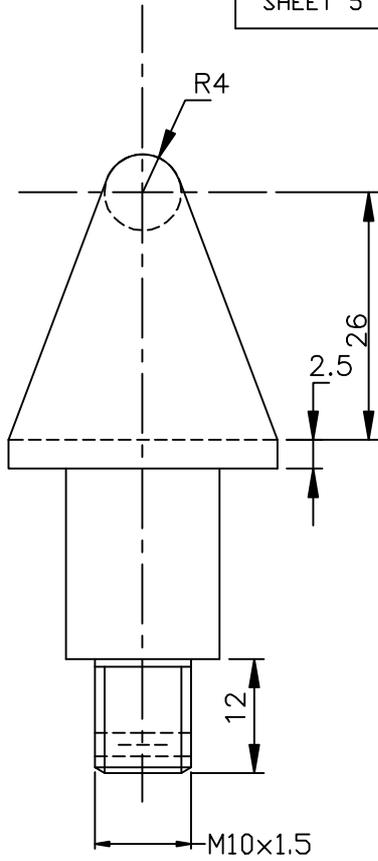
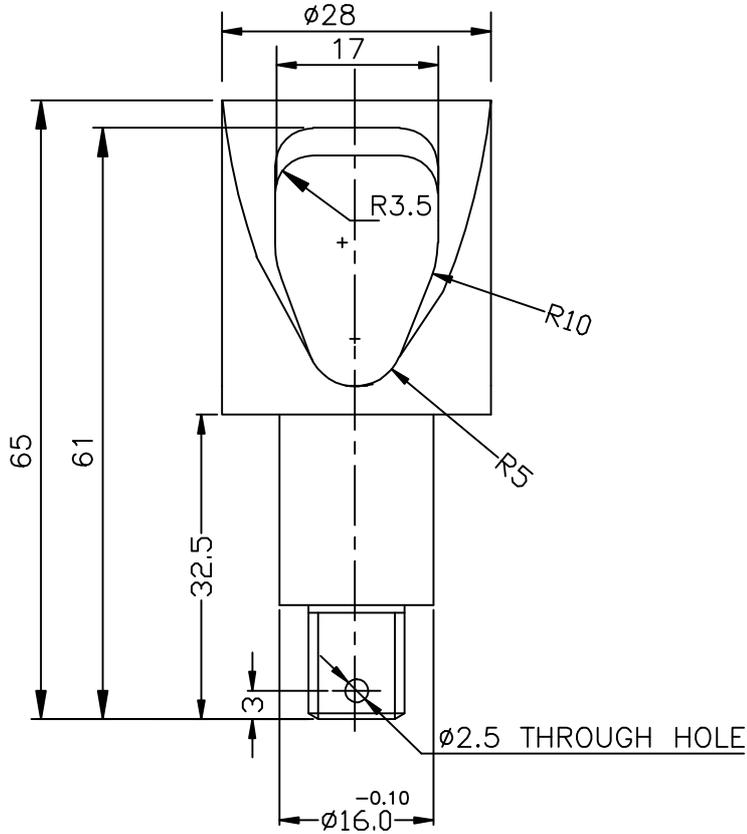
WORKMANSHIP :- THE CASTING SHOULD BE SOUND,CLEAN & FREE FROM BLOW HOLES , DISTORTION AND OTHER SURFACE DEFECTS THAT ARE LIKELY TO AFFECT THE UTILITY OF THE CASTING. SHARP CORNERS ARE TO BE ROUNDED OFF.

MATERIAL:- HIGH STRENGTH STEEL CASTING (Gr3/4) AS PER IS:2644-1994 OR STEEL ALLOY EN19 (709M40) AS PER BS:970 OR TYPE ANC-2 OF BS:3146 Pt-2:1961.

PROCESS:- CASTING

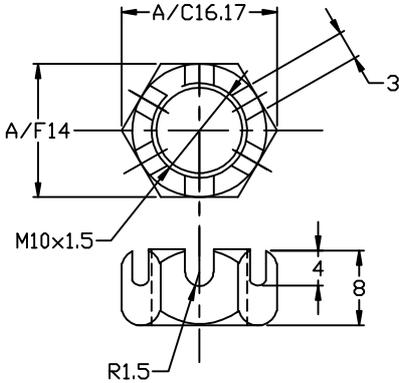
TOL:- AS PER IS:2102 (Pt-1) 1993 VERY COARSE,EXCEPT WHERE OTHERWISE SPECIFIED.

| | | | | | |
|---|------------|---|-----------|--------------|------------------------------|
| SCALE:-NTS | QTY. 1 No. | A D R D E AGRA | DRN. | SK SHARMA | PROD.DFR./GR.DFR. |
| DIMENSIONS IN mm | | GROUP- HDS | CHKD. | JC DUTTA | |
| TOL:- AS ABOVE | | BODY (LEFT) LOADING BRACKET (LEFT & RIGHT) HD SYSTEM FDR AN 32 A/C | | | APPROVED |
| MATERIAL:- AS ABOVE | | | | | PRD. DIR. |
| FINISH:- AS PER SHEET No. 13 | | | | | GROUP DIR. |
| HEAT TREATMENT:- HARDENED & TEMPERED,32±5 HRC | | | | | DRG. No. ADPDE/1414-01 (LHS) |
| REF. NO. | DATE | ZONE | AUTHORITY | BRIEF RECORD | I/C HEAD D&S Q.A. |
| 1 | | | | | |
| 2 | | | | | |
| 3 | | | | | |
| 4 | | | | | |
| 5 | | | | | |
| 6 | | | | | |
| 7 | | | | | |
| 8 | | | | | |



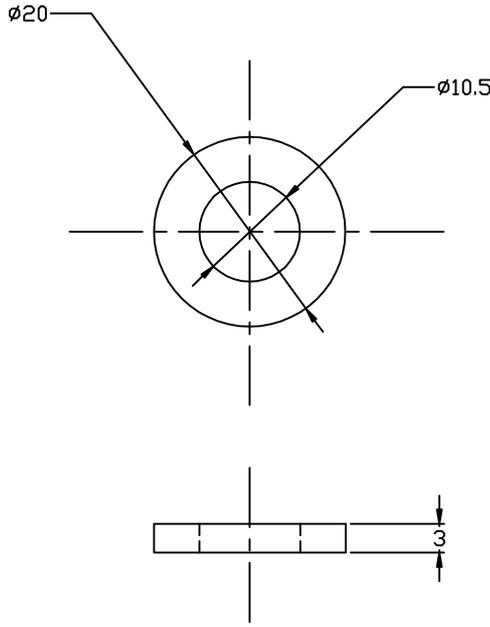
PROCESS :- MACHINING

| | | | | | | | |
|--|--------------|------|--|--------------|-----------|------------------------|--------------------------|
| Ref.No | DATE | ZONE | AUTHORITY | BRIEF RECORD | | | I/C HEAD (D&S) (Q.A.) |
| SCALE:-2:1 | QTY.- 2 Nos. | | ADRDE AGRA | DRN. | SK SHARMA | | PROJ.DFFR./GP.DFFR. |
| DIMENSIONS IN mm | | | GROUP:- HDS | CHKD. | JC DUTTA | | |
| TOL:-IS:2102 (Pt-1) 1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED | | | SHACKLE LOADING BRACKET (LEFT & RIGHT) HD SYSTEM FOR AN 32 A/C | | | PROJ. DIR. | |
| MATERIAL:- STEEL ALLOY 709M40/817M40 (EN19/EN24),AS PER BS:970 | | | | | | APPROVED | |
| FINISH:- AS PER SHEET No. 13 | | | | | | GROUP DIR. | |
| HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC | | | | | | DRG. No. ADRDE/1414-03 | |
| | | | | | | | |



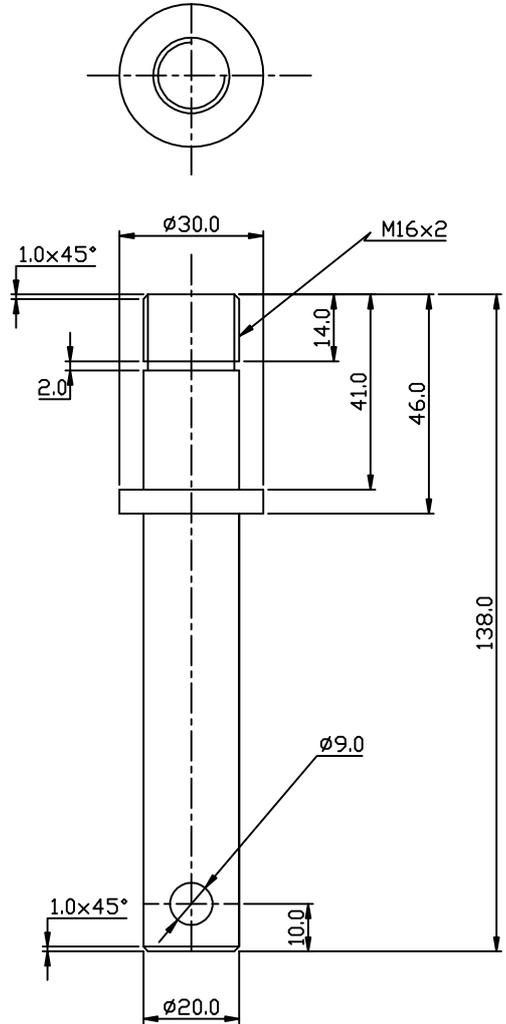
PROCESS :- MACHINING

| | | | | | | | | |
|---|--------------|------|---|--------------|-----------|------------------------|---------------------|----------------|
| Ref.No | DATE | ZONE | AUTHORITY | BRIEF RECORD | | | I/C (D&S) | HEAD (Q.A.) |
| SCALE:- 2:1 | QTY:- 2 Nos. | | ADRDE 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;">SLOTTED NUT</p> <p style="text-align: center;">LOADING BRACKET (LEFT & RIGHT)</p> <p style="text-align: center;">HD SYSTEM FOR AN 32 A/C</p> | | | APPROVED | | PROJ. DIR. |
| MATERIAL:- STEEL ALLOY 709M40/817M40 (EN19/EN24),AS PER BS:970 | | | | | | GROUP DIR. | | |
| FINISH:- AS PER SHEET No.13 | | | | | | DRG. No. ADRDE/1414-04 | | |
| HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC | | | | | | | | |
| | | | | | | | | |



PROCESS :- MACHINING

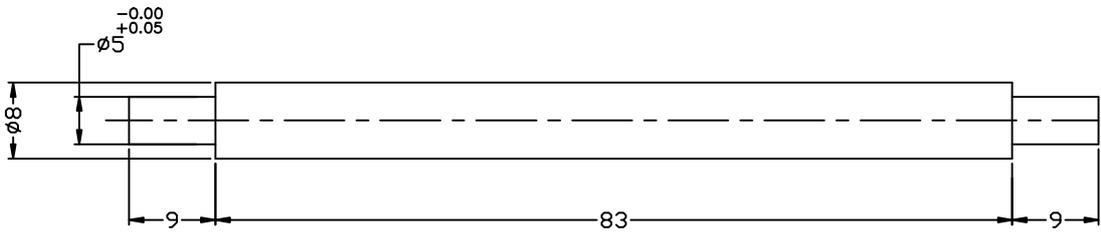
| | | | | | | | | | |
|---|--|--------------|------|---|--------------|-----------|---------------------|----------------|--|
| Ref.No | | DATE | ZONE | AUTHORITY | BRIEF RECORD | | I/C (D&S) | HEAD (Q.A.) | |
| SCALE:- 2:1 | | QTY:- 2 Nos. | | ADRDE AGRA | DRN. | SK SHARMA | | | |
| DIMENSIONS IN mm | | | | GROUP:- HDS | CHKD. | JC DUTTA | | | |
| TOL:- IS:2102 (Pt-1) 1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED | | | | <p style="text-align: center;">WASHER SMALL LOADING BRACKET (LEFT & RIGHT) HD SYSTEM FOR AN 32 A/C</p> | | | PROJ.DFFR./GP.DFFR. | | |
| MATERIAL:- MILD STEEL St42-S,AS PER IS:226 | | | | | | | PROJ. DIR. | | |
| FINISH:- AS PER SHEET No 13 | | | | | | | APPROVED | | |
| HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC | | | | | | | GROUP DIR. | | |
| | | | | DRG. No. ADRDE/1414-05 | | | | | |



PROCESS :- MACHINING

| | | | | | | | |
|---|--|--------------|------|--|--------------|---------------------|--------------------------|
| Ref.No | | DATE | ZONE | AUTHORITY | BRIEF RECORD | | I/C HEAD (D&S) (Q.A.) |
| SCALE:- 1:1 | | QTY:- 2 Nos. | | ADRDE AGRA | DRN. | SK SHARMA | |
| DIMENSIONS IN mm | | | | GROUP:- HDS | CHKD. | JC DUTTA | |
| TOL:- IS:2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED | | | | SHAFT LOADING BRACKET (LEFT & RIGHT) HD SYSTEM FOR AN 32 A/C | | PROJ.DFFR./GP.DFFR. | |
| MATERIAL:- STEEL ALLOY 709M40/817M40 (EN19/EN24),AS PER BS:970 | | | | | | PROJ. DIR. | |
| FINISH:- AS PER SHEET No.13 | | | | | | APPROVED | |
| HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC | | | | | | GROUP DIR. | |
| 1 | | 2 | | 3 | | 4 | |





PROCESS :- MACHINING

| | | | | | | | | | |
|---|--|--------------|------|---|--------------|-----------|------------------------|----------------|--|
| Ref.No | | DATE | ZONE | AUTHORITY | BRIEF RECORD | | I/C (D&S) | HEAD (Q.A.) | |
| SCALE:- 2:1 | | QTY:- 2 Nos. | | ADRDE AGRA | DRN. | SK SHARMA | | | |
| DIMENSIONS IN mm | | | | GROUP:- HDS | CHKD. | JC DUTTA | | | |
| TOL:- IS:2102 (Pt-1) 1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED | | | | HANDLE LOADING BRACKET (LEFT & RIGHT) HD SYSTEM FOR AN 32 A/C | | | PROJ.DFFR./GP.DFFR. | | |
| MATERIAL:- MILD STEEL St42-S,AS PER IS:226 | | | | | | | PROJ. DIR. | | |
| FINISH:- AS PER SHEET No. 13 | | | | | | | APPROVED | | |
| HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC | | | | | | | GROUP DIR. | | |
| | | | | | | | DRG. No. ADRDE/1414-07 | | |