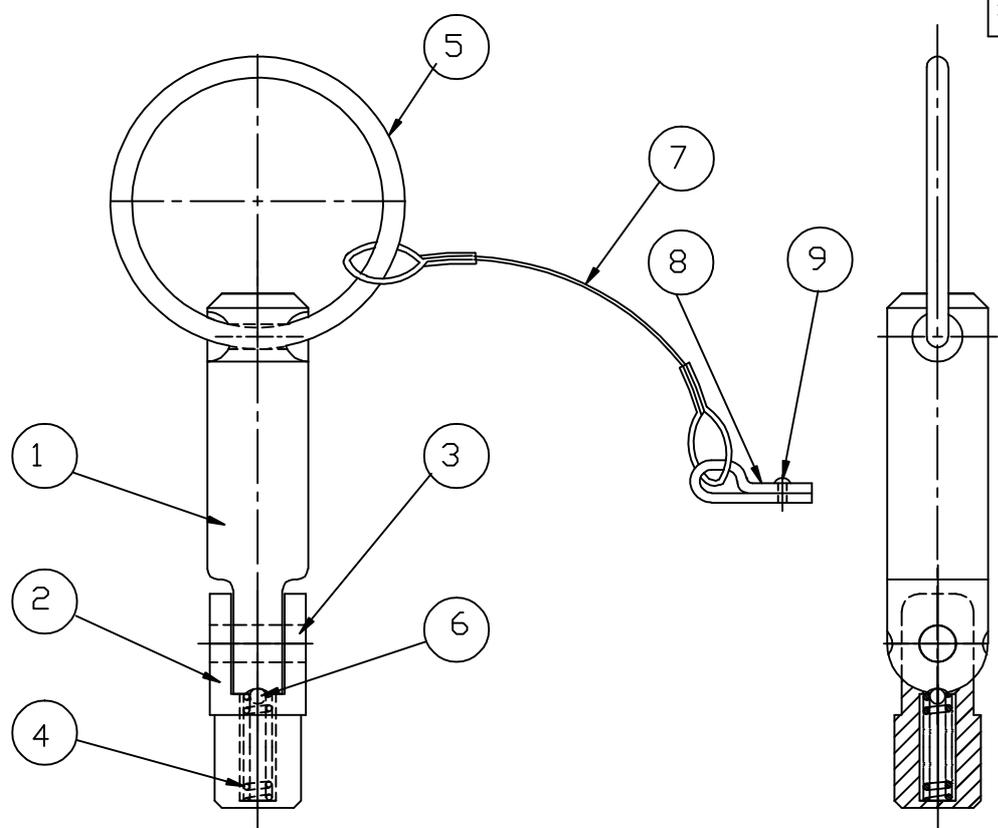


PROOF LOAD TEST : Each strut with pin assy. has to be tested for a proof load test at 8000 kgf load on a suitable fixture which simulate the actual loading distance between leg pipe assembly

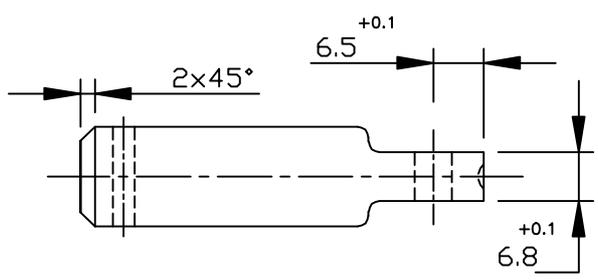
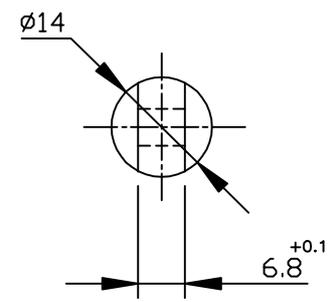
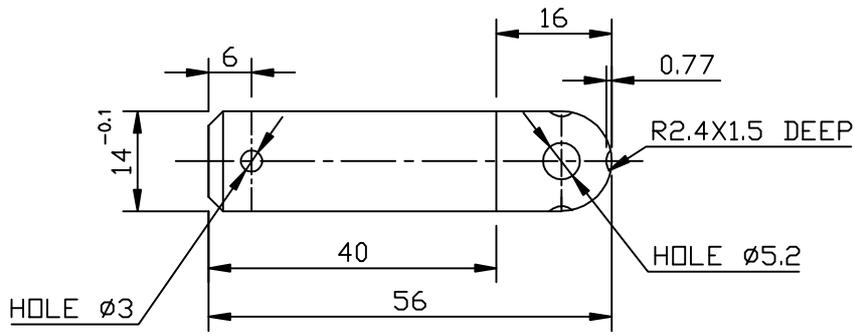
R.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		<input type="checkbox"/> I/C HEAD D&S Q.A.				
SCALE:- NTS		QTY.- 1		ADRDE AGRA	DRN..	SK SHARMA	PRO.OFFR.				
DIMENSIONS IN mm				GROUP	HDS	CHD.	J.C.DUTTA				
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 VERY COARSE				PROOF LOAD TEST FIXTURE STRUT WITH PIN H D SYSTEM FOR AN-32 AIRCRAFT				GROUP DIR.			
MATERIAL:-								<input type="checkbox"/> I/C D&S			
FINISH:-								APPROVED			
HEAT TREATMENT:-								HEAD Q.A.			
								DRG. No., ADRDE/1403 02 04			



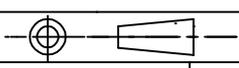
9	ROUND HEAD STEEL SCREW M3X6	COMMERCIAL QUALITY	-	1
8	CLIP	ADRDE/ 1403 02 03 07	17	2
7	MOUNTING WIRE	ADRDE/ 1403 0203 06	16	1
6	STAINLESS STEEL BALL $\phi 4.8$	COMMERCIAL QUALITY	-	1
5	RING	ADRDE/ 1403 02 03 05	15	1
4	SPRING	ADRDE/ 1403 02 03 04	14	1
3	RIVET	ADRDE/ 1403 02 03 03	13	1
2	PIN LOCK	ADRDE/ 1403 02 03 02	12	1
1	PIN	ADRDE/1403 02 03 01	11	1
SR.No.,	DESIGNATION	DRG. /SPEC.No.	SHEET No.	QTY

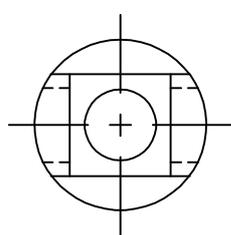
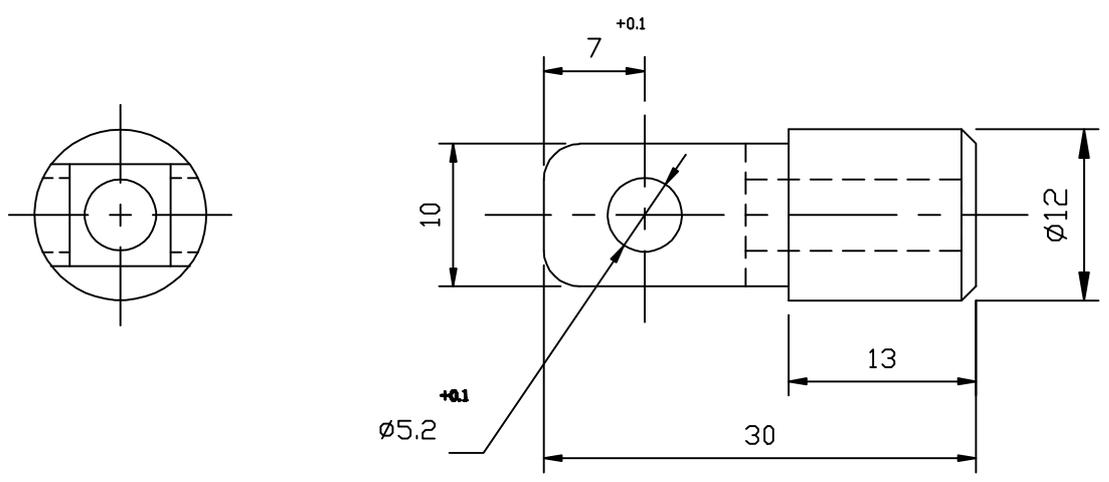
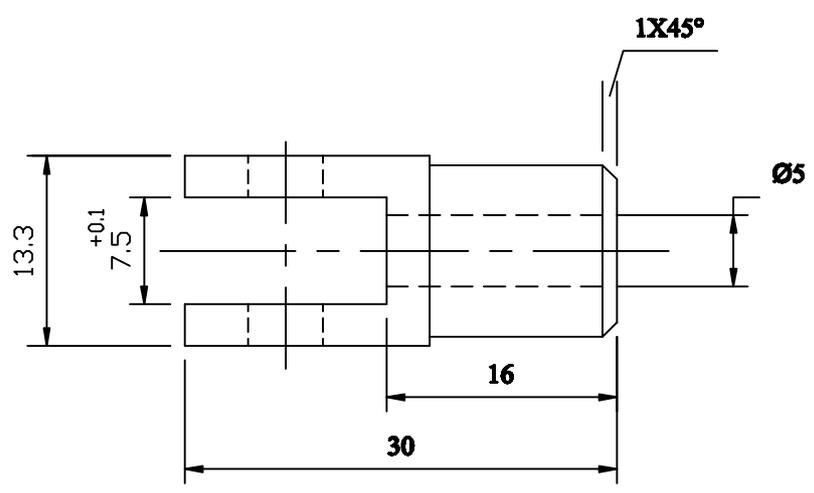
PROCESS : -
FABRICATION

R.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			<input type="checkbox"/> I/C HEAD D&S	<input type="checkbox"/> HEAD Q.A.		
SCALE:- 1:1		QTY: 1 No.	A D R D E AGRA	DRN..	SUBHASH		PRO.OFFR.			
DIMENSIONS IN mm			GROUP	HDS	CHD.	J.C.DUTTA		GROUP DIR.		
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) 1993 MEDIUM			PIN SUB ASSEMBLY STRUT WITH PIN H D SYSTEM FOR AN-32 AIRCRAFT			<input type="checkbox"/> I/C D&S				
MATERIAL:- ---						APPROVED			HEAD Q.A.	
FINISH:-ANNEXURE 'C'						DRG. No.ADRDE/ 1403 02 03				
HEAT TREATMENT:- ---										



R.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			<input type="checkbox"/> I/C HEAD D&S Q.A.			
SCALE:- 1:1		QTY.- 1		ADRDE AGRA	DRN..	SUBHASH		PRO.OFFR.			
DIMENSIONS IN mm				GROUP	HDS	CHD.	J.C.DUTTA	GROUP DIR.			
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM				PIN PIN SUB ASSY. STRUT WITH PIN H D SYSTEM FOR AN-32 AIRCRAFT				<input type="checkbox"/> I/C D&S			
MATERIAL:- STEEL ALLOY 070M55 (EN9) TO BS 970								APPROVED			
FINISH:- ANNEXURE'C'								HEAD Q.A.			
HEAT TREATMENT:- HARDENED & TEMPERED 28±3HRC								DRG. No., ADRDE/1403 02 03 01			
1		2		3		4					

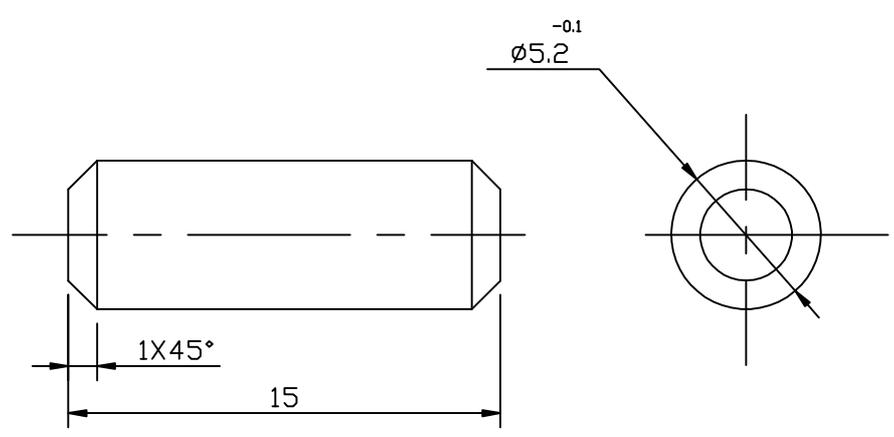




PROCESS : MACHINING

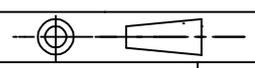
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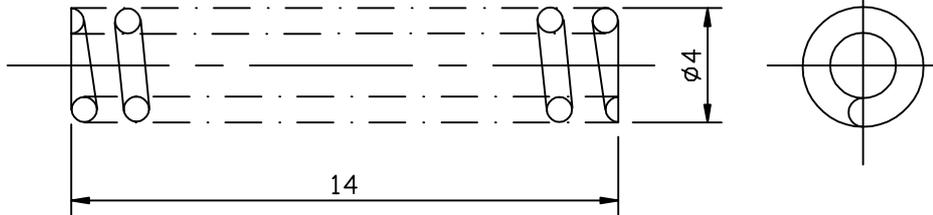
R.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			<input type="checkbox"/> I/C HEAD D&S Q.A.
SCALE:-	2:1	QTY.-	1	A D R D E AGRA	DRN..	SUBHASH	PRO.OFFR.
DIMENSIONS IN mm				GROUP	HDS	CHD.	J.C.DUTTA
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) 1993 MEDIUM				PIN LOCK PIN SUB ASSY. ROD WITH PIN H D SYSTEM FOR AN-32 AIRCRAFT			GROUP DIR.
MATERIAL:- STEEL ALLOY 070M55 (EN9) TO BS 970							<input type="checkbox"/> I/C D&S
FINISH:- ANNEXURE 'C'							APPROVED
HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC							HEAD Q.A.
				DRG. NO. ADRDE/1403 02 03 02			



PROCESS : MACHINING

R.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			<input type="checkbox"/> I/C HEAD D&S Q.A.	
SCALE:- 4 : 1		QTY.: 1		A D R D E AGRA	DRN..	S.K.SHARMA		PRO.OFFR.	
DIMENSIONS IN mm				GROUP	HDS	CHD.	J.C.DUTTA		
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM				RIVET PIN SUB ASSY. STRUT WITH PIN H D SYSTEM FOR AN-32 AIRCRAFT				GROUP DIR.	
MATERIAL:- STEEL ALLOY 070M55 (EN9) TO BS 970								<input type="checkbox"/> I/C D&S	
FINISH:- ANNEXURE 'C'								APPROVED	
HEAT TREATMENT:-								HEAD Q.A.	
								DRG. NO.ADRDE/ 1403 02 03 03	

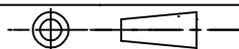


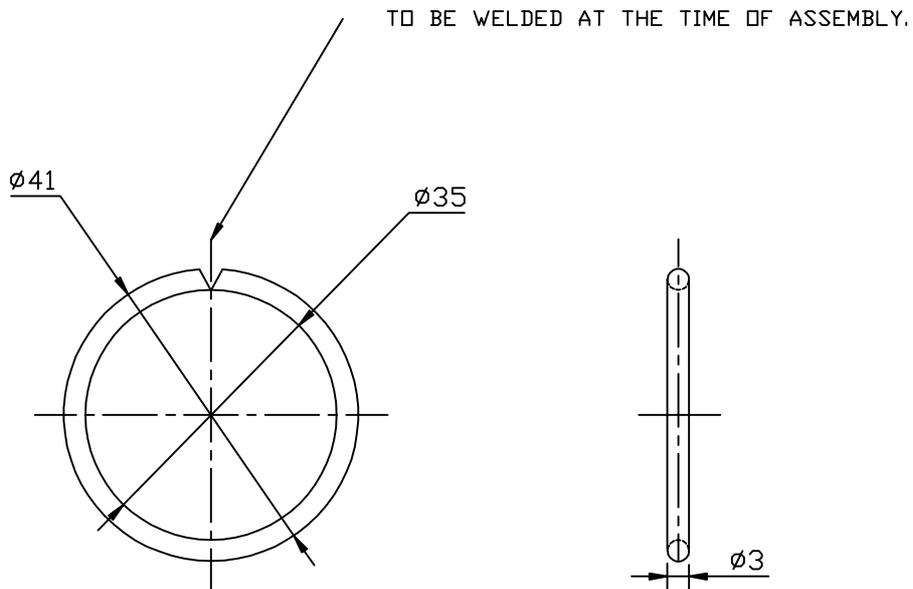


WIRE DIA.= 0.8
 No. OF TURNS = 11
 No. OF ACTIVE TURNS = 9
 STIFFNESS : 0.475 kg/mm

PROCESS : FABRICATION

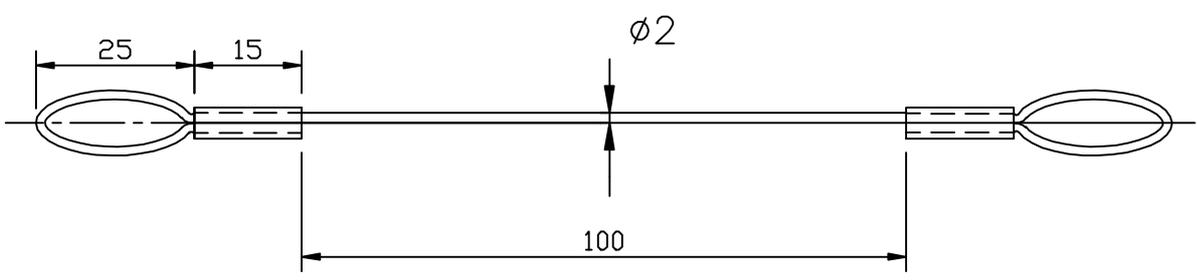
Ref.No	DATE	ZONE	AUTHORITY	BRIEF RECORD			<input type="checkbox"/> I/C HEAD D&S Q.A.			
SCALE:- 4 : 1	QTY.: 1	A D R D E AGRA	DRN..	S.K.SHARMA	PRO.OFFR.					
DIMENSIONS IN mm		GROUP	HDS	CHD.	J.C.DUTTA	GROUP DIR.				
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) 1993 MEDIUM		SPRING PIN SUB ASSY. STRUT WITH PIN H D SYSTEM FOR AN-32 AIRCRAFT				<input type="checkbox"/> I/C D&S				
MATERIAL:- SS SPRING WIRE IS:4454 GRADE IV.						APPROVED		HEAD Q.A.		
FINISH:- ANNEXURE 'C'						DRG. No.ADRDE/ 1403 02 03 04				
HEAT TREATMENT:-										





PROCESS : MACHINING

R.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			<input type="checkbox"/> I/C HEAD	
SCALE:- 1 : 1		QTY.: 1		A D R D E AGRA	DRN..	subhash	D&S	Q.A.	
DIMENSIONS IN mm				GROUP	HDS	CHD.	J.C.DUTTA	PRO.OFFR.	
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM				RING PIN SUB ASSY. STRUT WITH PIN H D SYSTEM FOR AN-32 AIRCRAFT				GROUP DIR.	
MATERIAL:- SPRING STEEL IS:4454 GRADE IV.								<input type="checkbox"/> I/C D&S	
FINISH:- TO BE PLATED AS PER ANNEXURE 'C' AFTER FITMENT & WELDING IN THE ASSEMBLY								APPROVED	
HEAT TREATMENT:-								HEAD Q.A.	
				DRG. NO.ADRDE/ 1403 02 03 05					

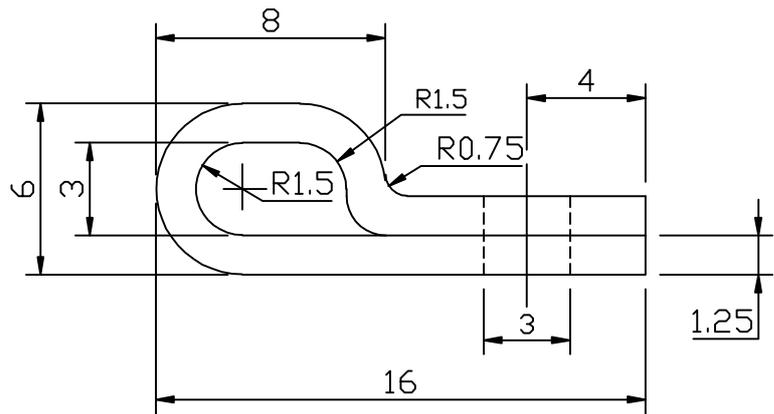
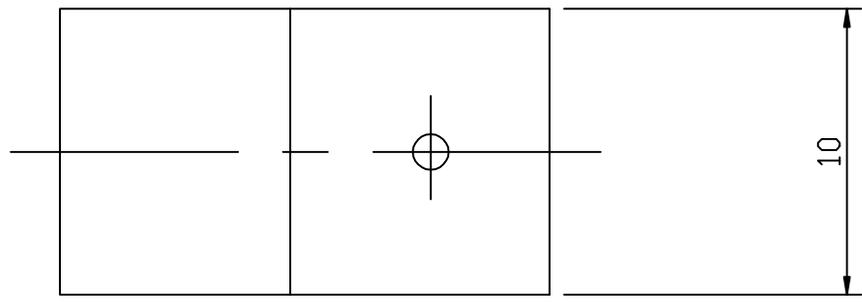


MATERIAL:-

ø* COMMERCIAL WIRE ROPE (GALVANIZED / SS) DIA 1.6 -2.0 mm CONSTRUCTION 5/6 x 7
 SUITABLE COPPER FERRULING WITH SMOOTH FINISH AFTER ASSEMBLING WITH PIN.

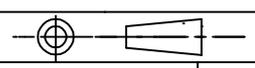
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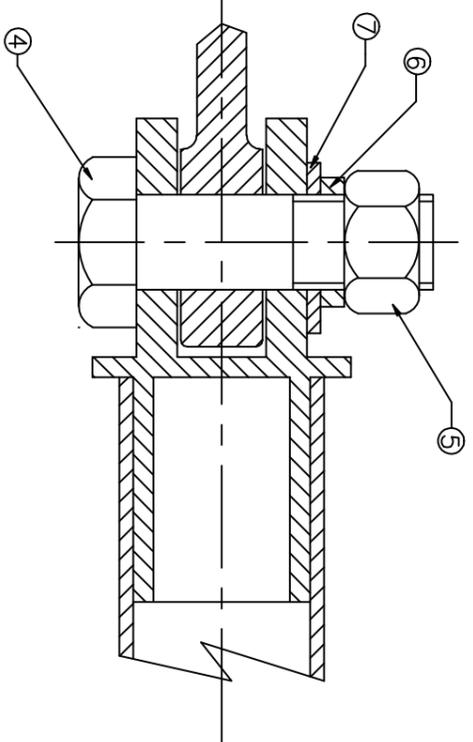
R.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			<input type="checkbox"/> I/C D&S	HEAD Q.A.
SCALE:- NTS		QTY.: 1		A D R D E AGRA	DRN..	subhash		PRO.OFFR.	
DIMENSIONS IN mm				GROUP	HDS	CHD.	J.C.DUTTA		
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM				MOUNTING WIRE PIN SUB ASSY. STRUT WITH PIN H D SYSTEM FOR AN-32 AIRCRAFT				GROUP DIR.	
MATERIAL:- AS GIVEN ABOVE								<input type="checkbox"/> I/C D&S	
FINISH:- ---								APPROVED	
HEAT TREATMENT:- ---								HEAD Q.A.	
								DRG. NO.ADRDE/ 1403 02 03 06	



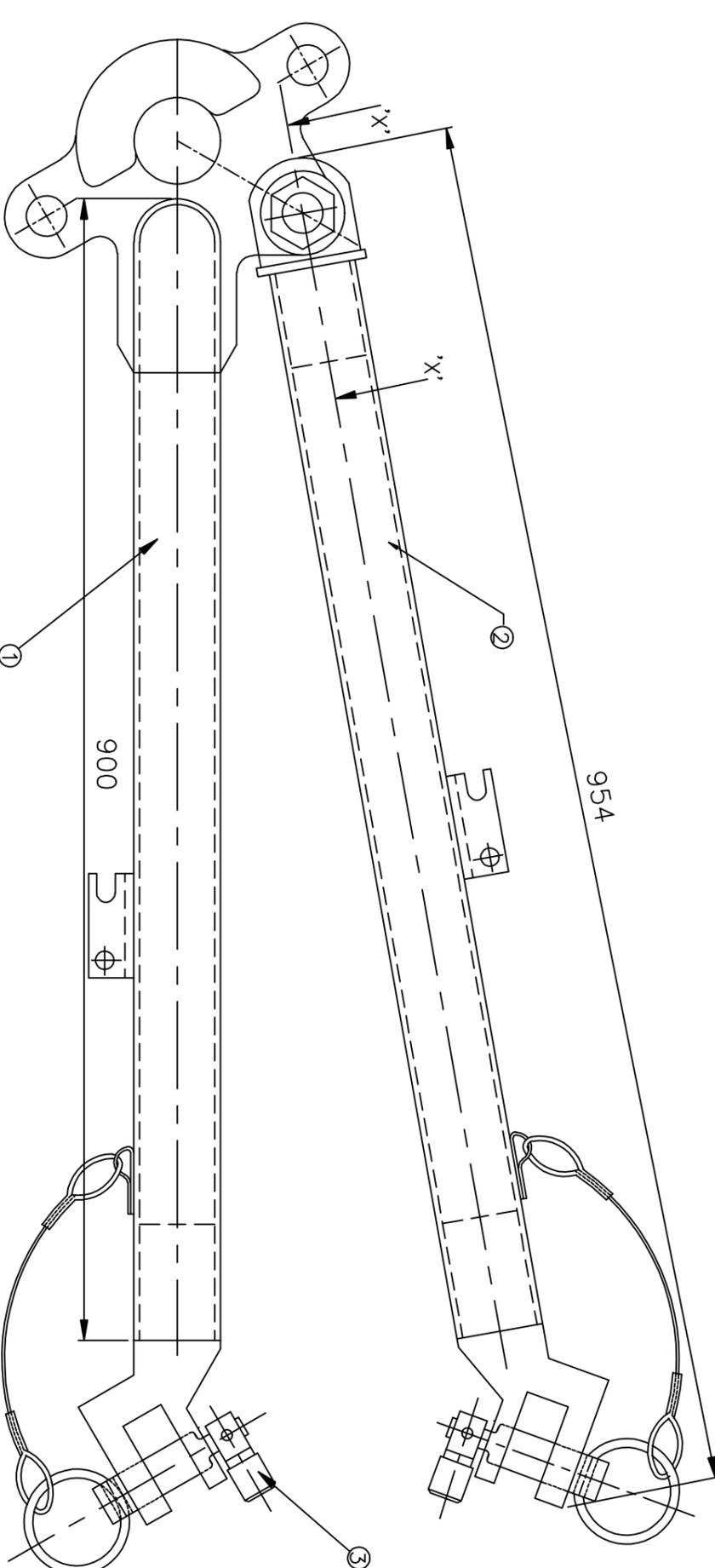
PROCESS : MACHINING

R.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			<input type="checkbox"/> I/C HEAD D&S Q.A.	
SCALE:- 4 : 1		QTY.: 2		ADRDE AGRA	DRN..	SUBHASH		PRO.OFFR.	
DIMENSIONS IN mm				GROUP	HDS	CHD.	J.C.DUTTA		
TOL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM				<p style="text-align: center;">CLIP PIN SUB ASSY. STRUT WITH PIN H D SYSTEM FOR AN-32 AIRCRAFT</p>				GROUP DIR.	
MATERIAL:- COMMERCIAL QLTY. COPPER / ALUMINIUM SHEET								<input type="checkbox"/> I/C D&S	
FINISH:- NATURAL								APPROVED	
HEAT TREATMENT:- -								HEAD Q.A.	
				DRG. NO.ADRDE/ 1403 02 03 07					





SECTION AT 'X-X'



ITEM NO	DRG./SPEC. No.	DESCRIPTION	SHEET NO.	QTY
7	IS:2016	WASHER M14		2
6	IS:3063	SPRING WASHER M14		2
5	IS:1364	HEX NUT M14x1.5P		2
4	IS:1364	HEX BOLT M14x1.5P,50Lg		2
	ADRDE-1403-02-04	PROOF LOAD FIXTURE	18	1
3	ADRDE-1403-02-03	PIN SUB ASSEMBLY	10-17	2
2	ADRDE-1403-02-02	PIPE SUB ASSEMBLY	7-9	1
7	ADRDE-1403-02-01	BRACKET PIPE SUB. ASSEMBLY	2-6	1

ITEM LIST

PACKING NOTE :
 EACH STRUT SHOULD BE PACKED IN A POLYTHYLENE BAG,SIX SUCH UNITS
 MAY BE PACKED IN A GUNNY BAG.IT SHALL THEN BE PUT INTO A WOODEN BOX.
 BOX MUST BEAR A LABEL SHOWING THE NAME OF ITEM,YEAR OF MANUFACTURING,
 COMPANY'S NAME,TRADE MARK IF ANY, NAME OF CONSIGNEE ETC..

SCALE:-	NTS	QTY:-	1NO.	A D R D E A G R A	DRN.	SK SHARMA	PRD. OFFR.
DIMENSIONS IN	mm			GRU P - H D S	CHD.	J C D U T T A	P.M.
TDL:- UNLESS OTHERWISE SPECIFIED				ASSEMBLY			
IS:2102(PART1) :1993 VERY COARSE				STRUT WITH PIN			
MATERIAL:-				HD SYSTEM FOR AN-32 AIRCRAFT			
FINISH:-				APPROVED			
HEAT TREATMENT:-				HEAD Q.A.			
REF.ND.	DATE	ZONE	AUTHORITY	BRIEF RECORD	D I / C D & S	HEAD Q.A.	DRG. ND.
1	1		2	3	4	5.	ADRDE/ 1403-02

1

2

3

4

5

6

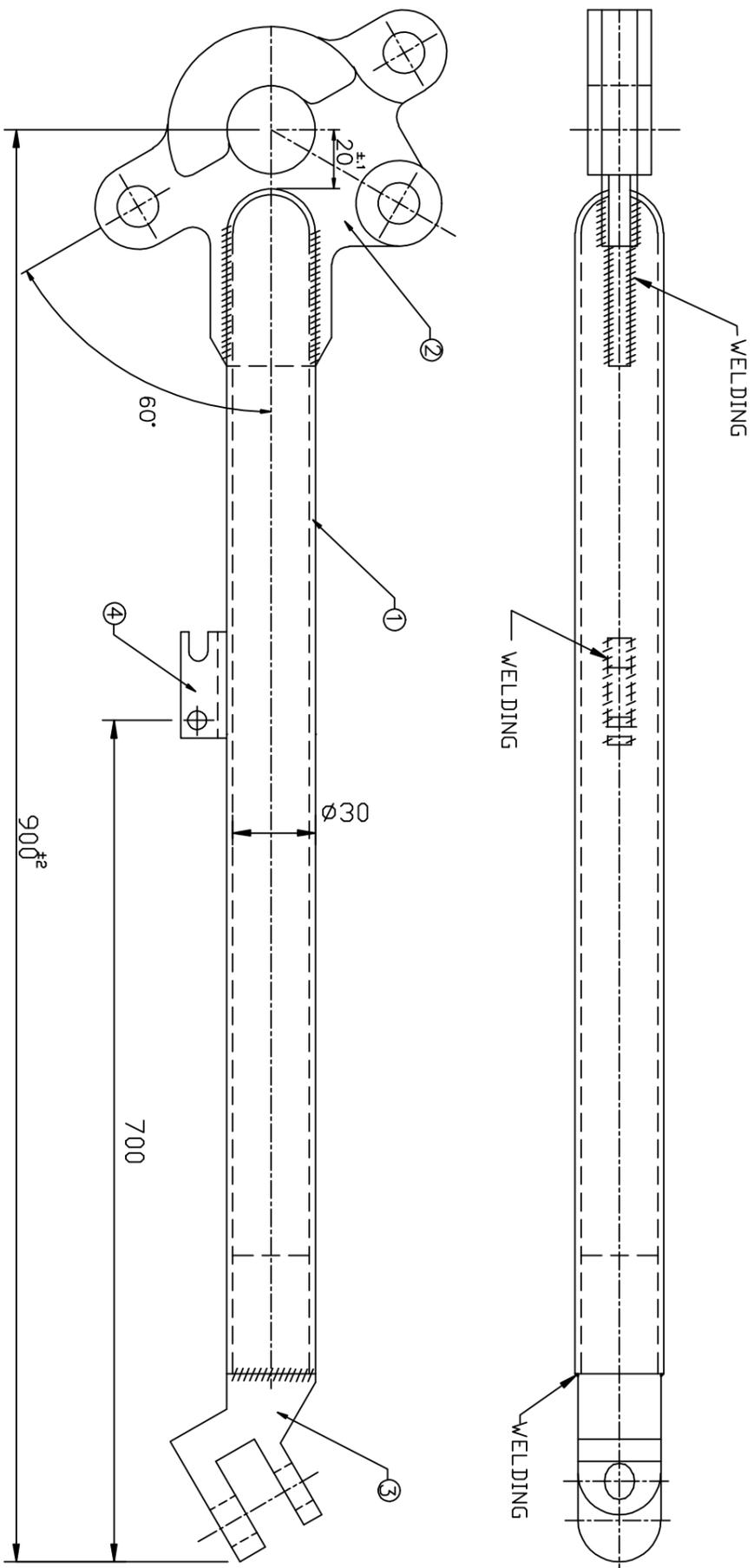
7

8

SHEET 2 OF 18

ITEM NO	DRG./SPEC. No.	DESCRIPTION	SHEET No.	QTY
4	ADRDE-1403-02-01-04	PLATE	6	1
3	ADRDE-1403-02-01-03	BRACKET ANGULAR	5	1
2	ADRDE-1403-02-01-02	PROFILE BRACKET	4	1
1	ADRDE-1403-02-01-01	PIPE	3	1

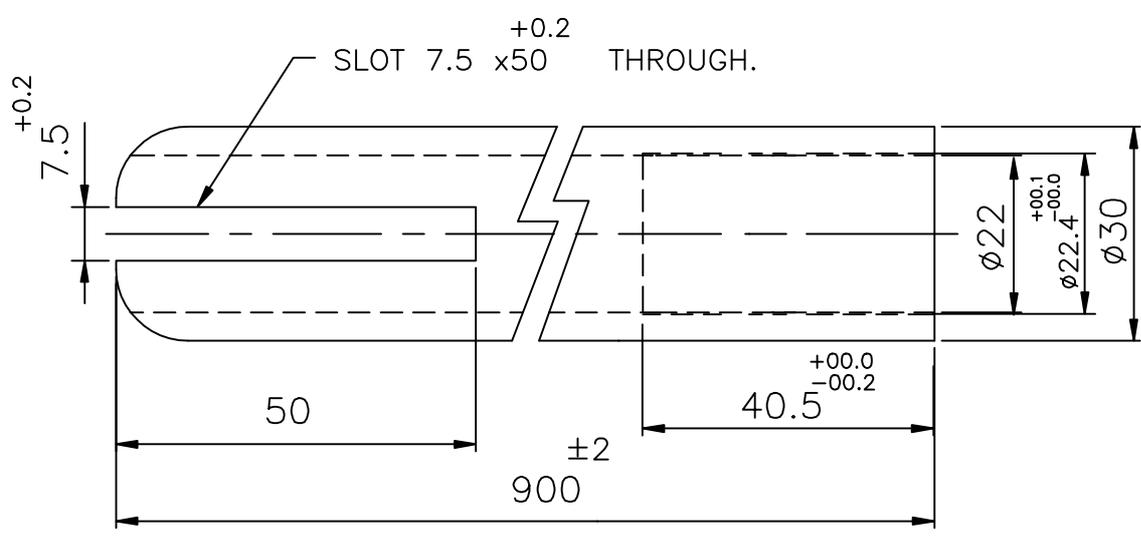
ITEM LIST



WELDING :

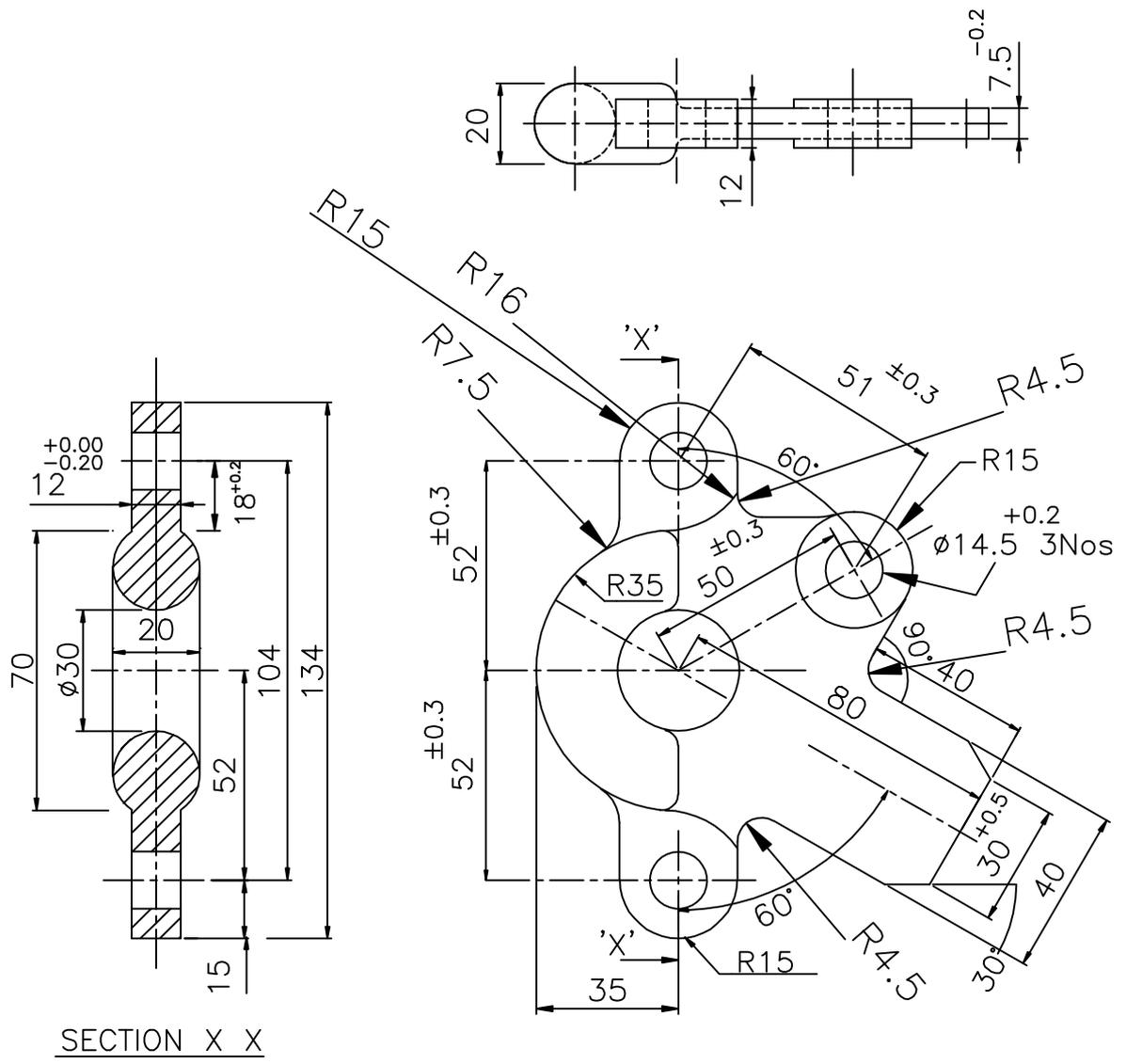
ALL JOINTS ARE TO BE WELDED WITH ELECTRODES CONFORMING TO THE IS:1395-1982 : E63 B-G-129 FeAWS/A 5.5:E9018(MODI:9018G) OR EQUIVALENT ALLOY STEEL WELDING ELECTRODE . ALL WELDED JOINT SHOULD BE TESTED BY DPT PROCESS BEFORE FINISH.

SCALE:-	NTS	QTY:-	1No.	ADRDE	AGRA	DRN.	SK SHARMA	PRD. DFFR.
DIMENSIONS IN	mm	GROUP-	HDS	CHD.	JC DUTTA			P.M.
TDL:-	UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 COARSE.			BRACKET PIPE SUB ASSEMBLY				APPROVED
MATERIAL:-				STRUT WITH PIN				HEAD Q.A.
FINISH:-	ANNEXURE 'A' GREY			HD SYSTEM FOR AN-32 AIRCRAFT				
HEAT TREATMENT:-	HARDENED & TEMPERED 30±3HRC							DRG. NO. 1403-02-01
REF. NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD	I/C D&S	HEAD Q.A.		
1								



PROCESS : MACHINING

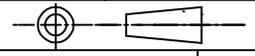
Ref.No		DATE	ZONE	AUTHORITY	BRIEF RECORD			<input type="checkbox"/> I/C HEAD (D&S) (Q.A.)	
SCALE:-1:1		QTY.-2Nos.		A D R D E AGRA	DRN..	SK SHARMA	PRO.DFFR.		
DIMENSIONS IN mm				GROUP:- HDS	CHD.	JC DUTTA	P.M.		
TOL:- IS:2102(Pt-1)1980 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED				PIPE STRUT WITH PIN HD SYSTEM FOR AN 32 A/C			<input type="checkbox"/> I/C (D&S)		
MATERIAL: STEEL ALLOY (EN19/EN24), 709M40/817M40, AS PER BS:970							APPROVED		
FINISH:-AS PER ANNEXURE 'A' GREY							HEAD (Q.A.)		
HEAT TREATMENT:- HARDENED AND TEMPERED 32±5 HRC							DRG. NO. ADRDE/1403-02-01-01		

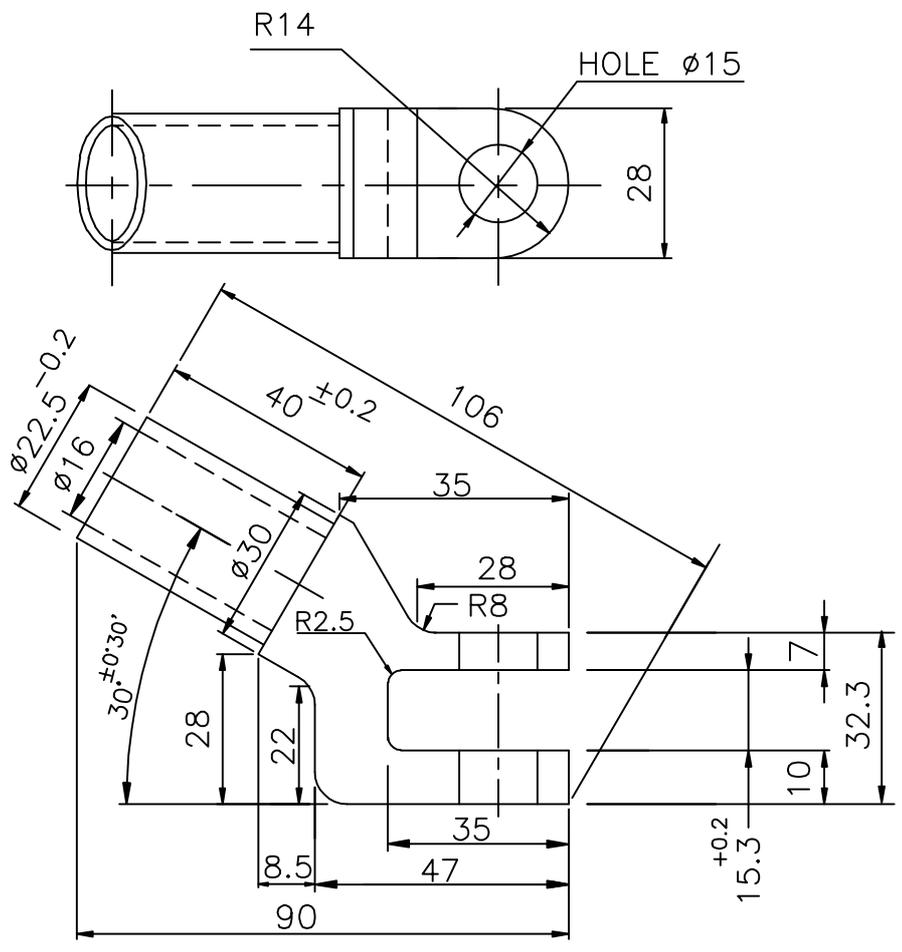


SECTION X X

PROCESS:- FORGING/MACHINING

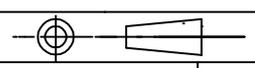
Ref.No	DATE	ZONE	AUTHORITY	BRIEF RECORD			<input type="checkbox"/> I/C HEAD (D&S) (Q.A.)
SCALE:- NTS	QTY.-1No.	A D R D E AGRA		DRN..	SK SHARMA	PRO.DFFR.	
DIMENSIONS IN mm		GROUP:- HDS		CHD.	JC DUTTA	P.M.	
TOL:- IS:2102(Pt-1)1980 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED		<p style="text-align: center;">PROFILE BRACKET STRUT WITH PIN HD SYSTEM FOR AN 32 A/C</p>		<p style="text-align: center;">APPROVED</p>		<input type="checkbox"/> I/C (D&S)	
MATERIAL:- STEEL ALLOY (EN19/EN24), 709M40/817M40, AS PER BS:970						HEAD (Q.A.)	
FINISH: AS PER ANNEXURE 'A' GREY						DRG. NO.	
HEAT TREATMENT:- HARDENED AND TEMPERED 32±5 HRC						ADRDE/1403-02-01-02	

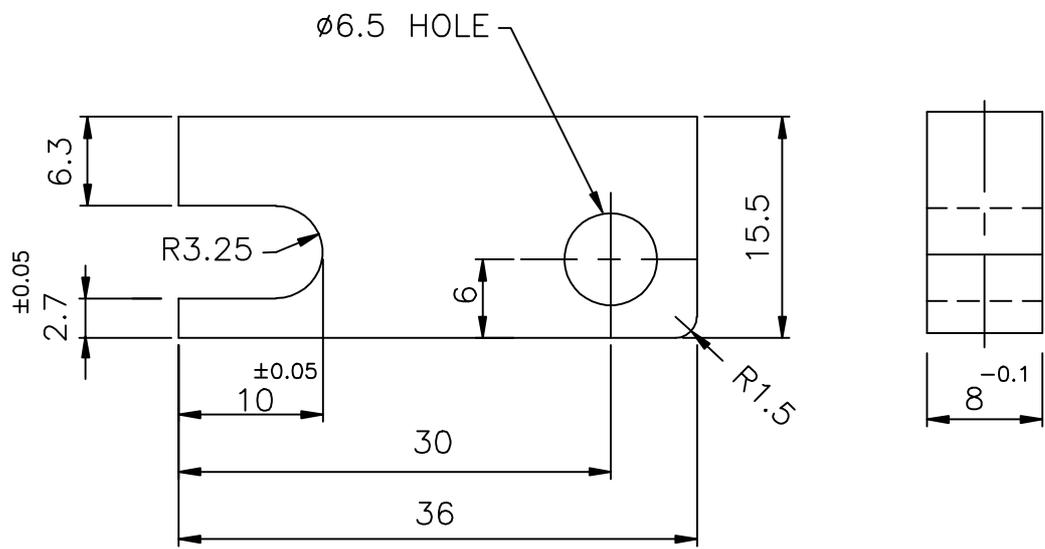




PROCESS :- MACHINING

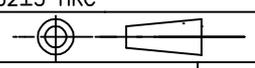
Ref.No		DATE	ZONE	AUTHORITY	BRIEF RECORD			<input type="checkbox"/> I/C HEAD (D&S) (Q.A.)
SCALE:-NTS		QTY.-1No.		ADRDE AGRA	DRN..	SK SHARMA	PRO.OFFR.	
DIMENSIONS IN mm				GROUP:- HDS	CHD.	JC DUTTA	P.M.	
TOL:- IS:2102(Pt-1)1980 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				BRACKET ANGULAR STRUT WITH PIN HD SYSTEM FOR AN 32 A/C			<input type="checkbox"/> I/C (D&S)	
MATERIAL: STEEL ALLOY (EN19/EN24), 709M40/817M40,AS PER BS:970							APPROVED	
FINISH: AS PER ANNEXURE 'A' GREY							HEAD (Q.A.)	
HEAT TREATMENT:- HARDENED & TEMPERED 32±5							DRG. NO. ADRDE/1403-02-01-02	
1		2		3		4		





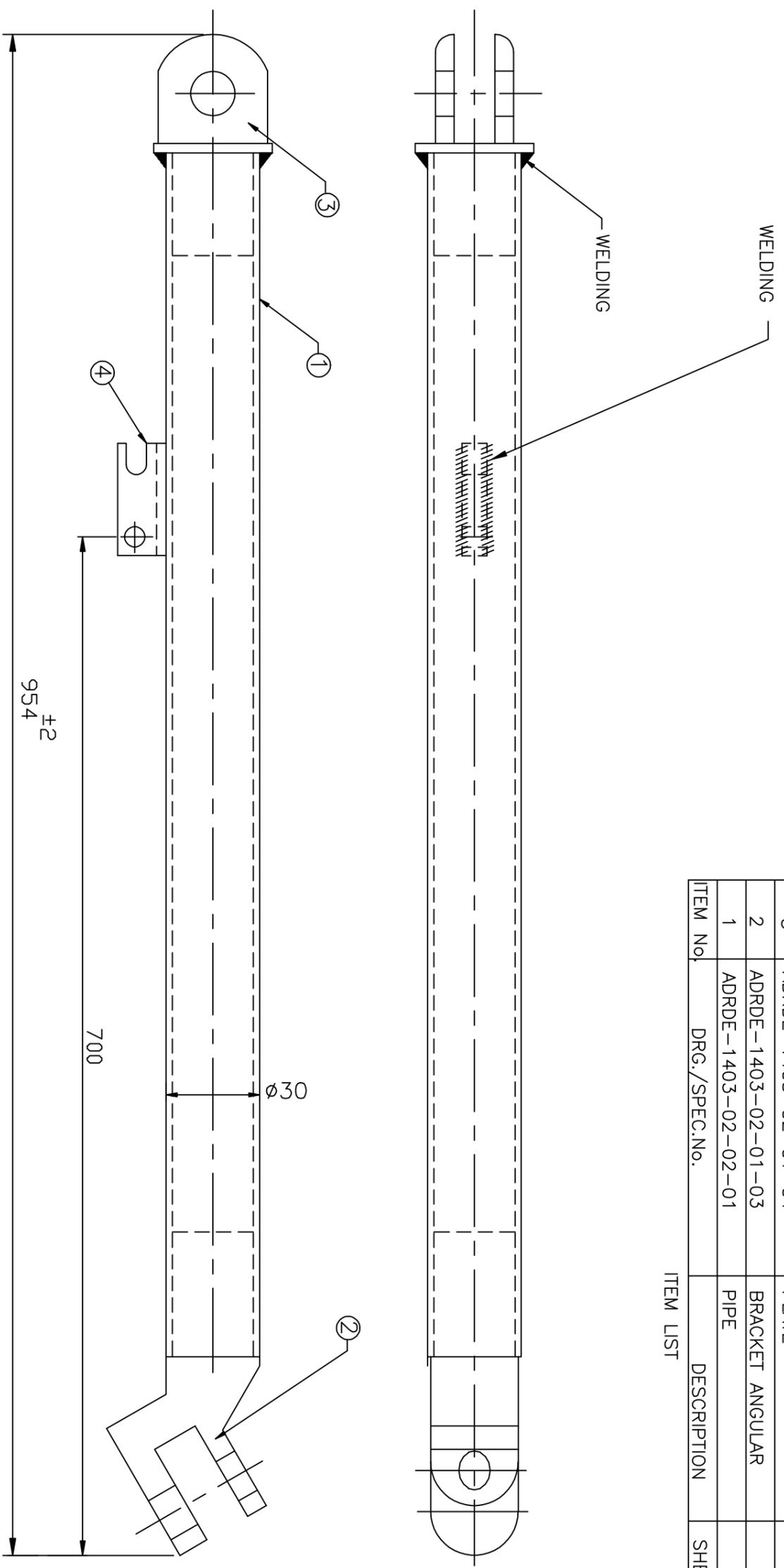
PROCESS :- MACHINING

Ref.No		DATE	ZONE	AUTHORITY	BRIEF RECORD			<input type="checkbox"/> I/C HEAD (D&S) (Q.A.)	
SCALE:-2:1		QTY.-2Nos.		A D R D E AGRA	DRN..	SK SHARMA	PRO.DFFR.		
DIMENSIONS IN mm				GROUP:- HDS	CHD.	JC DUTTA	P.M.		
TOL:- IS:2102(Pt-1)1980 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				PLATE STRUT WITH PIN HD SYSTEM FOR AN 32 A/C			<input type="checkbox"/> I/C (D&S)		
MATERIAL: STEEL ALLOY (EN19/EN24), 709M40/817M40,AS PER BS:970							APPROVED		
FINISH: AS PER ANNEXURE 'A' GREY							HEAD (Q.A.)		
HEAT TREATMENT:- HARDENED AND TEMPERED 32±5 HRC							DRG. NO. ADRDE/1403-02-01-04		
1		2		3		4			



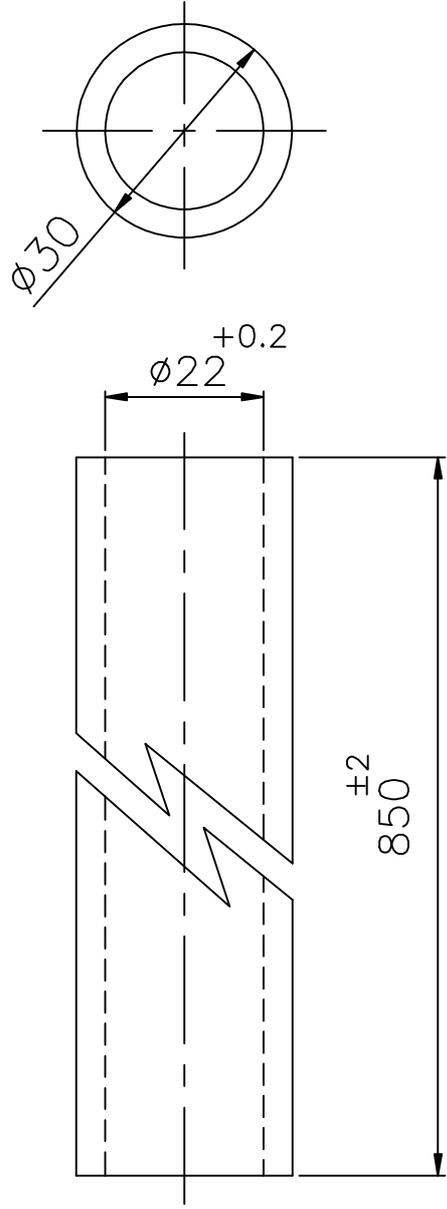
ITEM No.	DRG./SPEC.No.	DESCRIPTION	SHEET No.	QTY
4	ADRDE-1403-02-02-02	7" BRACKET	9	1
3	ADRDE-1403-02-01-04	PLATE	6	1
2	ADRDE-1403-02-01-03	BRACKET ANGULAR	5	1
1	ADRDE-1403-02-02-01	PIPE	8	1

ITEM LIST



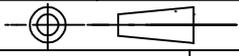
WELDING : ALL JOINTS ARE TO BE WELDED WITH ELECTRODES CONFORMING TO THE IS:1395-1982 : E63 B-G-129 FeAWS/A 5.5:E9018(MODI:9018G) OR EQUIVALENT ALLOY STEEL WELDING ELECTRODE . ALL WELDED JOINT SHOULD BE TESTED BY DPT PROCESS BEFORE FINISH.

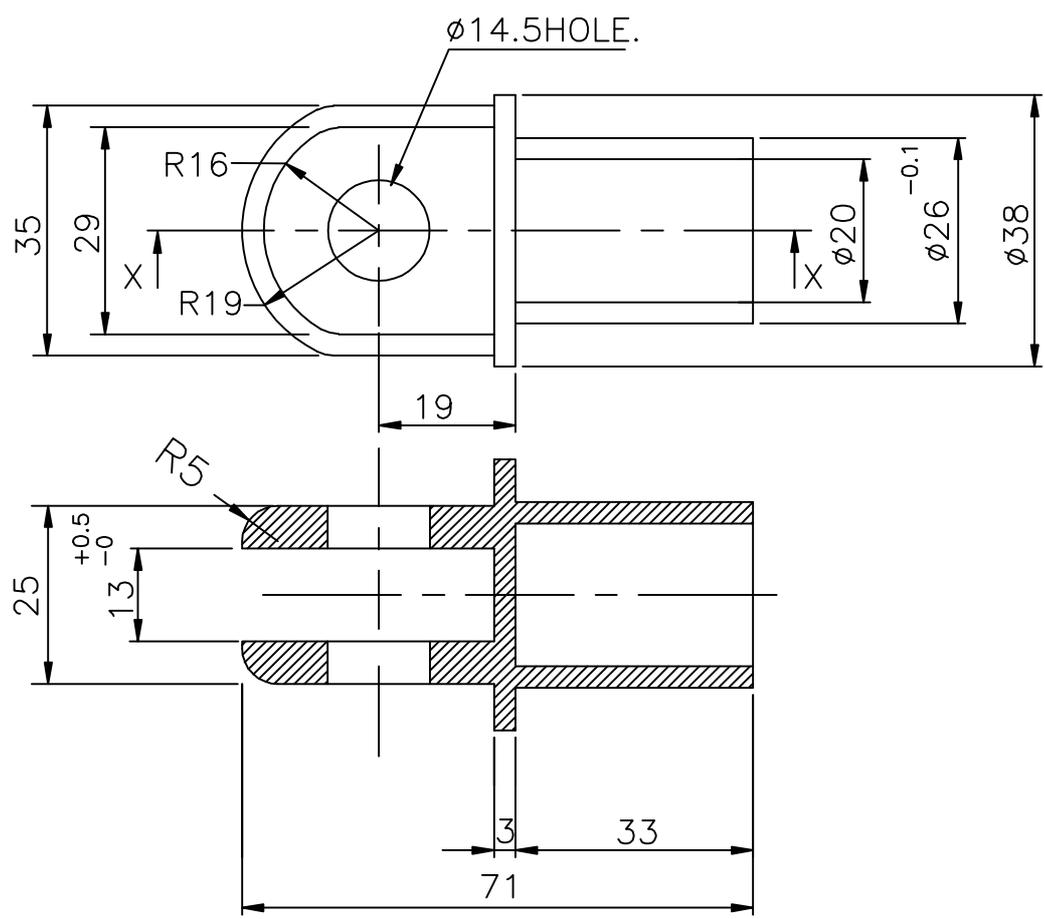
SCALE:-NTS	QTY:-1No.	ADRDE	AGRA	DRN.	SK SHARMA	PRD. OFFR.
DIMENSIONS IN mm		GROUP- HDS	CHD.	JC DUTTA		P.M.
TDL:- UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 V.COARSE.		PIPE SUB ASSEMBLY		APPROVED		HEAD Q.A.
MATERIAL:-		STRUT WITH PIN		HD SYSTEM FOR AN-32 AIRCRAFT		
FINISH:-AS PER PARA A/B/C OF SHEET ND. 18		HEAT TREATMENT:- HARDENED & TEMPERED 30±3HRC		DRG. NO. 1403-02-02		
REF. NO. DATE ZONE AUTHORITY BRIEF RECORD		D I/C HEAD D&S Q.A.		1 2 3 4 5 6 7 8		



PROCESS : FABRICATION

Ref.No		DATE	ZONE	AUTHORITY	BRIEF RECORD			<input type="checkbox"/> I/C HEAD (D&S) (Q.A.)
SCALE:-NTS		QTY.-1No.		ADRDE AGRA	DRN..	SK SHARMA	PRO.DFFR.	
DIMENSIONS IN mm				GROUP:- HDS	CHD.	JC DUTTA	P.M.	
TOL:- IS:2102(Pt-1)1980 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED				PIPE STRUT WITH PIN HD SYSTEM FOR AN 32 A/C			<input type="checkbox"/> I/C (D&S)	
MATERIAL: STEEL ALLOY (EN19/EN24), 709M40/817M40, AS PER BS:970							APPROVED	
FINISH: AS PER ANNEXURE 'A' GREY							HEAD (Q.A.)	
HEAT TREATMENT:- HARDENED AND TEMPERED 32±5 HRC							DRG. NO. ADRDE/1403-02-02-01	
1		2		3		4		





SECTION XX

PROCESS :- MACHINING

Ref.No		DATE	ZONE	AUTHORITY	BRIEF RECORD			<input type="checkbox"/> I/C HEAD (D&S) (Q.A.)
SCALE:-1:1		QTY.-1No.		A D R D E AGRA	DRN..	SK SHARMA	PRO.OFFR.	
DIMENSIONS IN mm				GROUP:- HDS	CHD.	JC DUTTA	P.M.	
TOL:- IS:2102(Pt-1)1980 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				'T'BRACKET STRUT WITH PIN HD SYSTEM FOR AN 32 A/C			<input type="checkbox"/> I/C (D&S)	
MATERIAL: STEEL ALLOY (EN19/EN24), 709M40/817M40,AS PER BS:970							APPROVED	
FINISH: AS PER ANNEXURE 'A' GREY							HEAD (Q.A.)	
HEAT TREATMENT:- HARDENED AND TEMPERED 32±5 HRC							DRG. NO. ADRDE/1403-02-02-02	