

(NOTE : - TOOL FOR FITMENT OF LOCKING PIN IN ADU)

PROCESS : FABRICATION/MACHINING

TOLERANCE :- AS PER IS:2102 (PART-1) 1993; MEDIUM UNLESS OTHERWISE SPECIFIED

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.	SK SHARMA	PRO.OFFR.		
DIMENSIONS IN mm		GROUP:- HDS		CHD.	J.C.DUTTA	PD		
TOL.:- AS ABOVE		<p>SCREW CLAMP AUTOMATIC DISENGAGING UNIT(ADU) (HD SYSTEM FOR AN-32)</p>		<p><input type="checkbox"/> I/C D&S APPROVED HEAD Q.A. DRG. NO. ADRDE/ 1413 -15</p>				
MATERIAL:- <i>St. 42-5(MS) IS 226</i>								
FINISH:- <i>CADMIUM PLATED & CHROMATED PASSIVATED Gr.3 AS PER IS 1572</i>								
HEAT TREATMENT:-								

PACKING NOTE:-1-BEFORE FINAL FINISHING

ENGRAVE SERIAL NO./CAT PART NO/
NAME OF MANUFACTURER & DATE OF MAN-
UFACTURE ON BODY(SHEET NO 2)/LINK
(SHEET NO10) & LARGE PIN (SHEET NO3) AT
AT MARKED PLACE IN THE CROSS-SECTION
DRAWINGS.

2- BEFORE PACKING APPLY A THIN PROTE-
CTIVE LAYER OF ANTI-RUST GREASE
CORTEC-VEL 368L OR ANY EQUIVALENT
ON ALL COMPONENTS

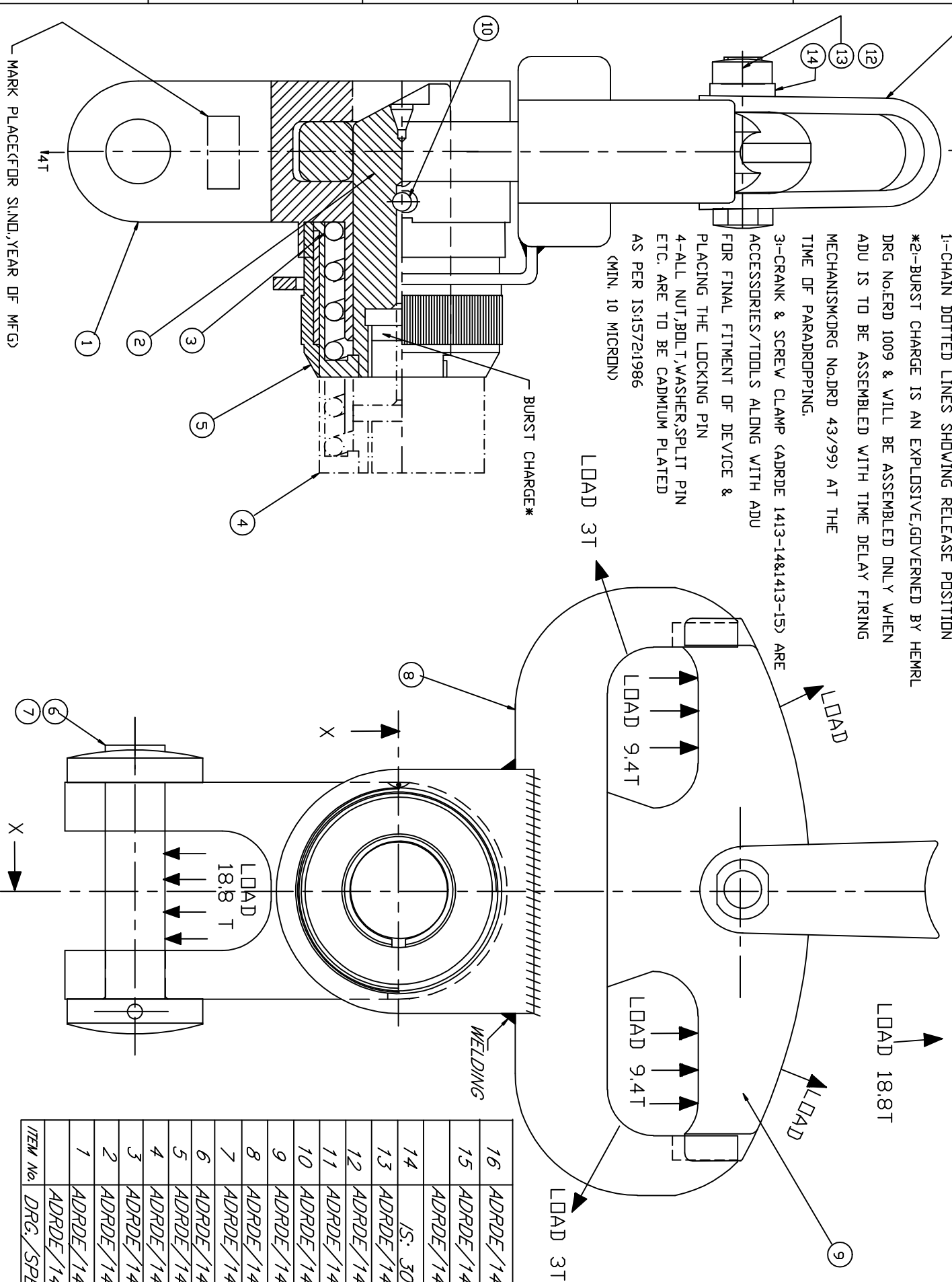
3- WRAP EACH UNIT WITH A BUTTER/GREASE
PAPER/AGAIN EACH UNIT OF DISMANTLED
ADU MAY BE SEALED IN A POLYETHENE BAG
EACH SEALED UNIT MAY BE PLACED IN
WOODEN BOX/CASE.

4- THE PACKING CASE SHALL BE MARKED
INDELIBLY WITH ADDRESS OF CONSIGNEE/
CONSIGNER,CAT NO, Nomenclature OF STORE
QTY, YEAR OF MANUFACTURE ETC.

NOTE:-

1-CHAIN DOTTED LINES SHOWING RELEASE POSITION
*2-BURST CHARGE IS AN EXPLOSIVE,GOVERNED BY HEMPL
DRG No.ERD 1009 & WILL BE ASSEMBLED ONLY WHEN
ADU IS TO BE ASSEMBLED WITH TIME DELAY FIRING
MECHANISM(DRG No.DRD 43/99) AT THE
TIME OF PARADROPPING.

3-CRANK & SCREW CLAMP (ADRD 1413-14&1413-15) ARE
ACCESSORIES/TOOLS ALONG WITH ADU
FOR FINAL FITMENT OF DEVICE &
PLACING THE LOCKING PIN
4-ALL NUT,BOLT,WASHER,SPLIT PIN
ETC. ARE TO BE CADMIUM PLATED
AS PER IS:1572/1986
(MIN. 10 MICRON)



ITEM No.	DRG./SPEC. No.	QTY	Sheet No.
16	ADRD/1413-15	1	1-1
15	ADRD/1413-14	1	1-12
	ADRD/1413-14		17
14	IS: 3063	1	
13	ADRD/1413-13	1	16
12	ADRD/1413-12	1	15
11	ADRD/1413-11	1	14
10	ADRD/1413-10	10	13
9	ADRD/1413-09	1	12
8	ADRD/1413-08	1	11
7	ADRD/1413-07	1	10
6	ADRD/1413-06	1	9
5	ADRD/1413-05	1	8
4	ADRD/1413-04	1	7
3	ADRD/1413-03	1	6
2	ADRD/1413-02	1	3-5
1	ADRD/1413-01	1	2
	ADRD/1413(0)	1	1
	NOMENCLATURE		

DETAIL INDEX

PROOF LOAD TEST:-1-THE AUTOMATIC DISENGAGING UNIT (ADU) IS TO BE TESTED FOR PROOF LOAD TEST

AT 18800kgf.
2-CLAMP (ITEM No.11) IS TO BE TESTED AT 4000kgf FOR PROOF LOAD TEST.
3-AUTO DISCONNECTOR PIECE (ITEM No.8) IS TO BE TESTED AT 3000kgf LOAD
ALL THE ABOVE TESTING ARE TO BE CARRIED OUT IN ASSEMBLED CONDITION
AS SHOWN IN DRAWING.

SCALE:- 1:1		QTY:- 1 NO.		A D R D E AGRA		DRN		SK SHARMA		PROOF FR.	
DIMENSIONS IN mm		TOL:- AS ABOVE		GROUP:- HDS		CHD		JC DUTTA		PD	
MATERIAL:-		FINISH:-		HEAT TREATMENT		ASSEMBLY		AUTOMATIC DISENGAGING UNIT (ADU)		APPROVED	
D I/C D&S		HEAD Q.A.		HD SYSTEM FOR AN 32 A/C		DRG. NO.		ADRD/ 1413 (0)		D I/C D&S	
RAND.		DATE		ZONE		AUTHORITY		BRIEF RECORD		HEAD Q.A.	
8		7		6		5		4		3	

4

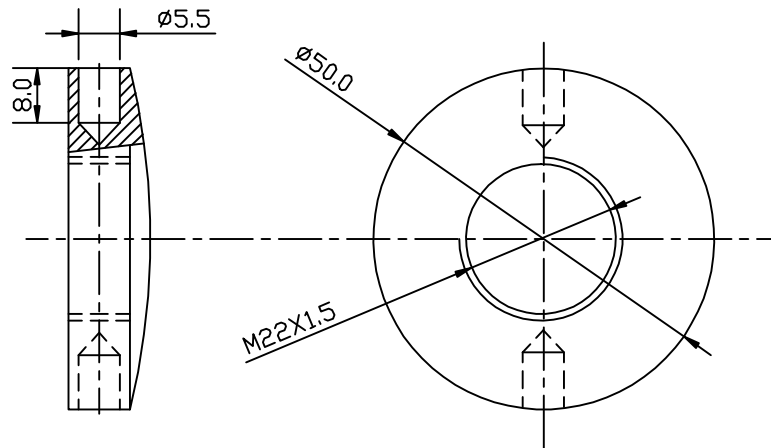
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2

1

SHEET 10 OF 17

7



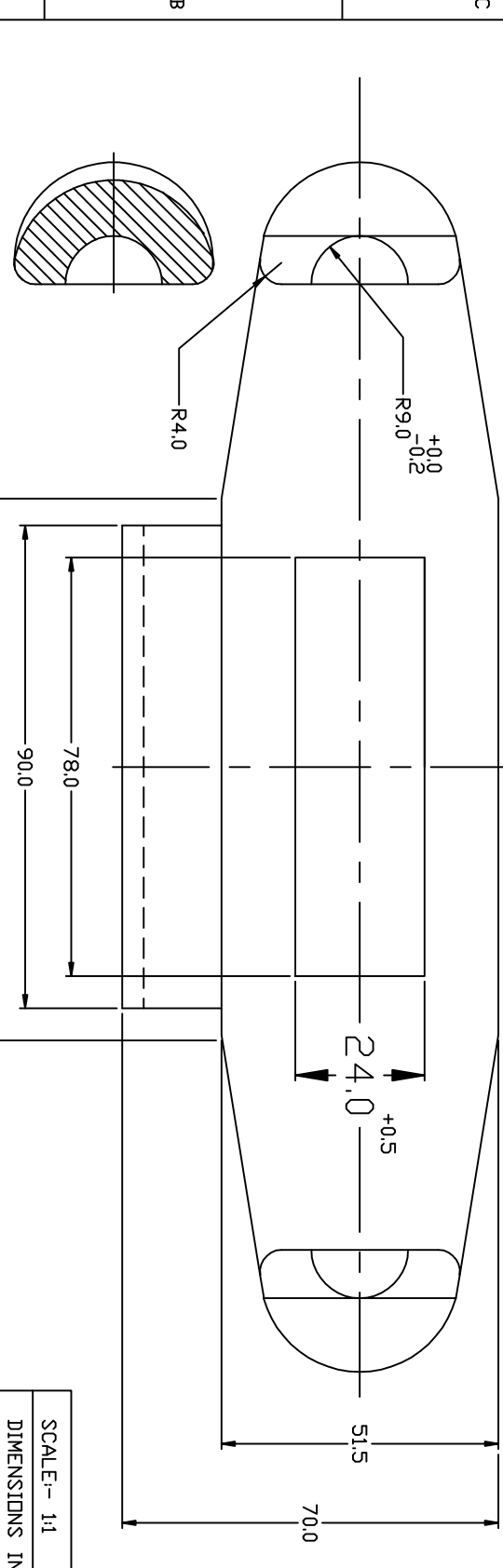
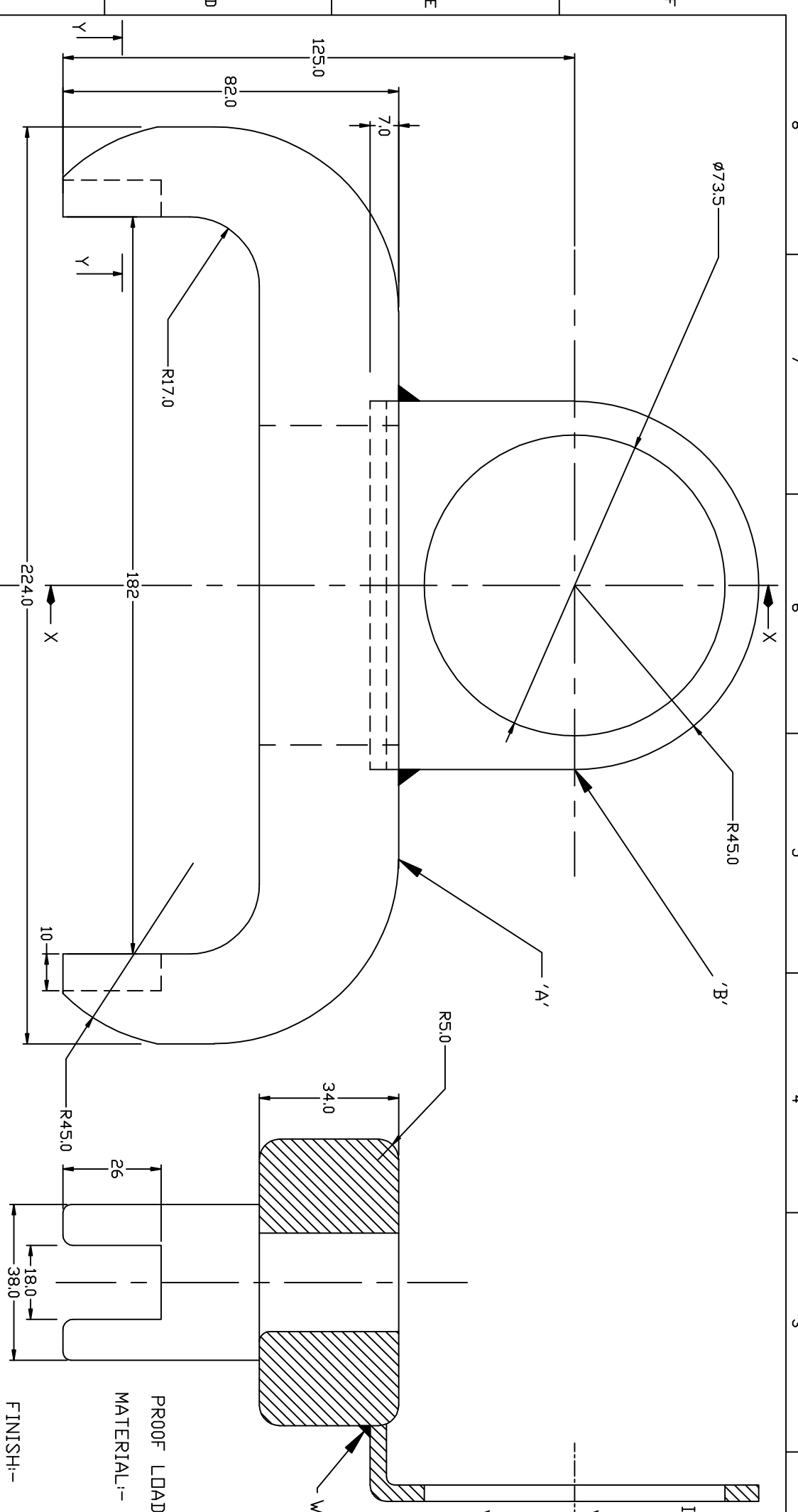
WORKMANSHIP:- AS IN SHEET NO. 2

TOLERANCE:- IS:2102(PART-1) MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED.

PROCESS:- MACHINING

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.,	SK SHARMA	PRO.OFFR.					
DIMENSIONS IN mm			GROUP:-HDS	CHD.	JC DUTTA	PD					
TOL:- AS ABOVE			<p style="text-align: center;">NUT AUTOMATIC DISENGAGING UNIT<ADU> HD SYSTEM FOR AN 32 A/C</p>			I/C D&S					
MATERIAL:- ALLOY STEEL EN 24 (817 M 40) AS PER SPECN. BS:970.						APPROVED			HEAD Q.A.		
FINISH:- AS IN SHEET NO. 2						DRG. NO.			ADRDE/ 1413-07(a)		
HEAT TREATMENT:- 265-352 BHN											

INSPECTION--FOLLOWING AS PER IS: 8780-1976
 (a) VISUAL EXAMINATION-100%
 (b) PENETRANT FLOW DIRECTION 20%
 (c) ULTRA SOUND FLOW DIRECTION 10%
 WELDING-- WELDING IS TO BE CARRIED OUT WITH ELECTRODE CONFIRMING TO IS:1395-82 E 63 B-G 219 Fe AWS/A 5.5/E 9018 G (MDDI/ ADVANI DREKON) OR EQUIVALENT.
 WELDING INSPECTION-- VISUAL AND LIQUID PENETRANT TEST SHALL BE CARRIED OUT AS PER PROCEDURE LAID DOWN IN IS: 3658.



SECTION YY

SECTION XX

RAND.	DATE	ZONE	AUTHORITY	BRIEF RECORD	D I/C D&S	HEAD Q.A.
8						
<p>SCALE:- 1:1 QTY:- 1 NO. DIMENSIONS IN mm TOL:- AS ABOVE MATERIAL:- AS ABOVE FINISH:- AS ABOVE HEAT TREATMENT 265-352 BHN</p>						
<p>ADRD E AGRA</p>			DRN	SK SHARMA	<p>AUTO DISCONNECTOR PIECE AUTOMATIC DISENGAGING UNIT(KADU) HD SYSTEM FOR AN 32 A/C</p>	
<p>GROUP:- HDS</p>			CHD	JC DUTTA	<p>APPROVED D I/C D&S HEAD Q.A.</p>	
<p>DRG. NO. 1413-08(a) ADDRDE/ 1413-08(a)</p>						

PROOF LOAD:- 3000Kg, AS GIVEN IN SHEET 1.
 MATERIAL:- HIGH STRENGTH STEEL CASTING (Gr 3/4) AS PER IS: 2644:1994 OR STEEL ALLOY EN 19 (709-40) AS PER BS: 970 OR TYPE ANC-2 OF BS:3146 Pt. 2:1961
 FINISH:- CADMIUM PLATED TO A MINIMUM THICKNESS OF 12 MICRON STRESS RELIEF BEFORE PLATING HYDROGEN EMBRITTELEMENT AND CHROMATE PASSIVATED TO IS:1572-1986, Gr 3 Fe/Cd-12 CA

WORKMANSHIP:- THE FINISHED COMPONENTS SHALL BE FREE FROM PITS, CRACKS, TOOL MARKS AND ANY OTHER SURFACE DEFECTS.
 TOLERANCE:- IS:2102(PART-1) MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED
 PROCESS:- ITEM 'A' CASTING & MACHINING
 ITEM 'B' SHEET METAL WORKING THEN WELDED WITH ITEM 'A'

4

3

2

1

SHEET 13 OF 17

(10)

Ra-8 TO 25 MICRON

M4X0.5

 $\phi 7$
 -0.1
 $+0.0$
 -0.1
 14

-0.1

25.8

1X45°

WORKMANSHIP:- AS IN SHEET NO. 2

TOLERANCE:- IS:2102(PART-1) MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED.

PROCESS:- MACHINING

PACKING:- EACH PIN SHOULD BE LIGHTLY GREASED AND PACKED
 IN POLYETHYLENE PAPER. 10 SUCH PINS MAY BE PACKED IN
 A CARD BOARD / PLASTIC BOX.

R.NO.

DATE

ZONE

AUTHORITY

BRIEF RECORD

I/C
D&SHEAD
Q.A.

SCALE:-2:1

QTY:- 1 NO.

A D R D E AGRA

DRN.,

SK SHARMA

PRD.OFFR.

DIMENSIONS IN mm

GROUP:-HDS

CHD.

JC DUTTA

PD

TOL:- AS ABOVE

MATERIAL:-
 ALLOY STEEL EN 24 (817 M 40)
 AS PER SPECN. BS:970.

FINISH:-

AS IN SHEET NO. 2

HEAT TREATMENT:-

265-352 BHN

LOCK PIN
 AUTOMATIC DISENGAGING
 UNIT(ADU)
 HD SYSTEM FOR AN 32 A/C

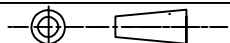
I/C D&S

APPROVED

HEAD Q.A.

DRG. NO.

ADRDE/ 1413-10(a)



4

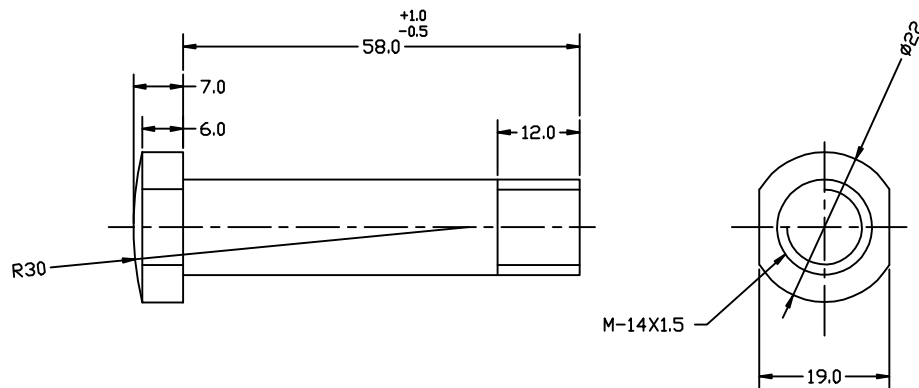
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1

SHEET 15 OF 17

(12)



WORKMANSHIP:- AS IN SHEET NO. 2

TOLERANCE:- IS:2102(PART-1) MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED.

PROCESS:- TO BE MACHINED FROM FORGED BAR/BLANK

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

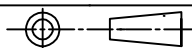
SCALE:-1:1	QTY:- 1 NO.	A D R D E AGRA	DRN.,	SK SHARMA	PRO.OFFR.
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DIMENSIONS IN mm	GROUP	CHD.	JC DUTTA	PD
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TOL:- AS ABOVE	MATERIAL:- ALLOY STEEL EN 24 (817 M 40) AS PER SPECN. BS:970. FINISH:- AS IN SHEET NO. 2	BOLT SMALL AUTOMATIC DISENGAGING UNIT<ADU> HD SYSTEM FOR AN 32 A/C	D I/C D&S
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HEAT TREATMENT:- 265-352 BHN	APPROVED	HEAD Q.A.
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DRG. NO. ADRDE/ 1413-12(a)



4

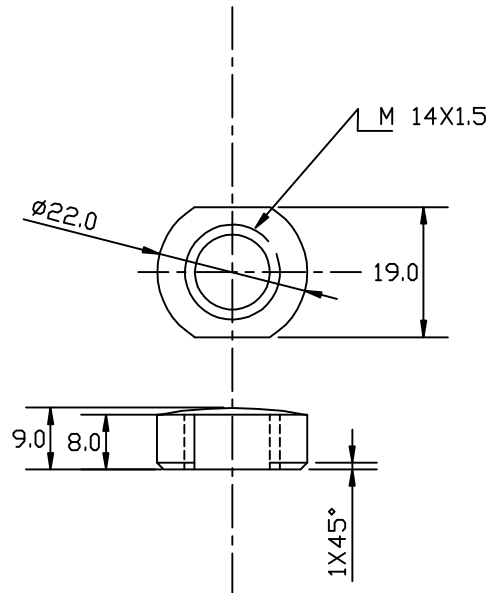
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SHEET 16 OF 17

(13)

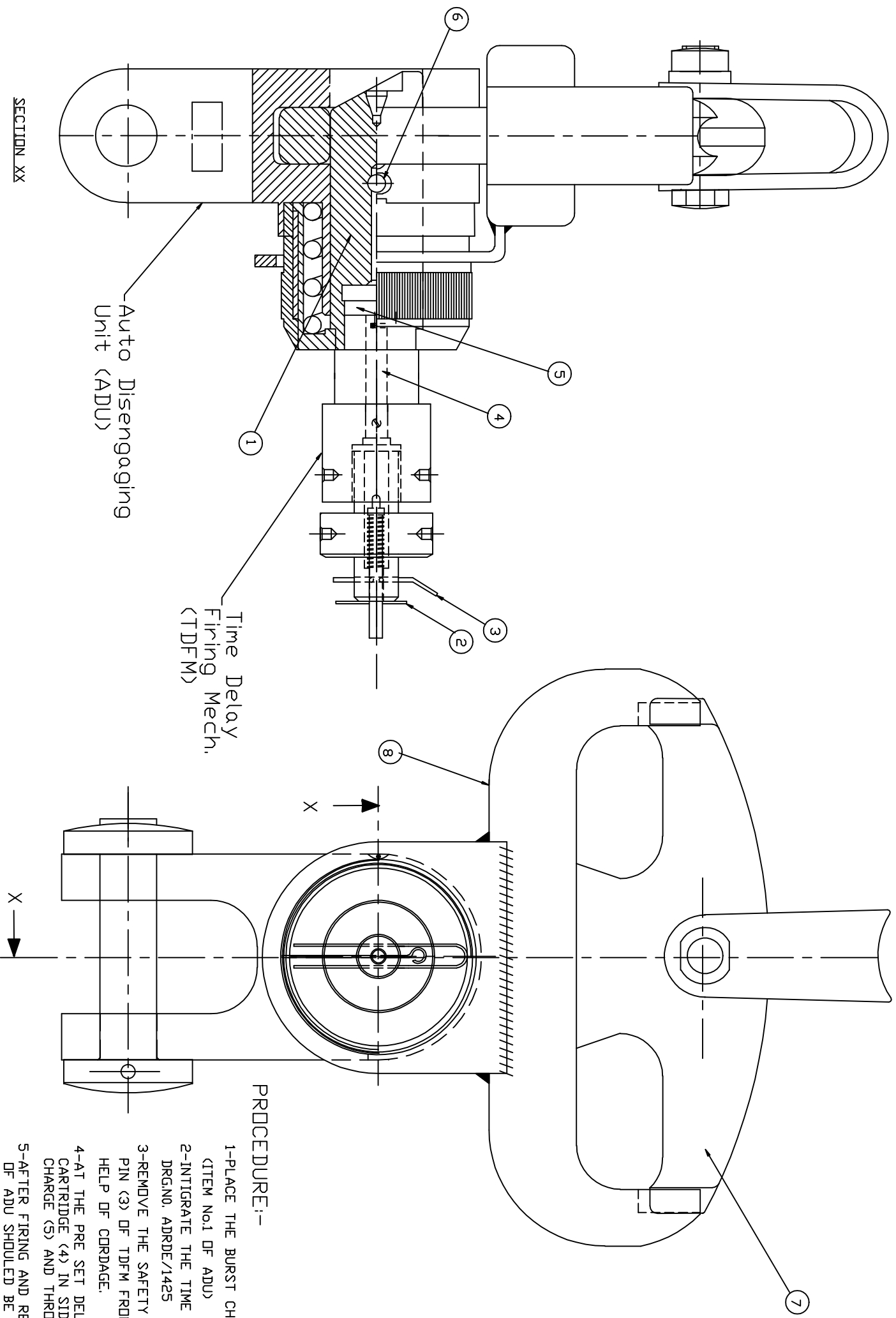


WORKMANSHIP:- AS IN SHEET NO. 2

TOLERANCE:- IS:2102(PART-1) MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED.

PROCESS:- MACHINING FROM FORGED BAR/BLANK

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.	SK SHARMA	PRO.OFFR.					
DIMENSIONS IN mm			GROUP:-HDS	CHD.	JC DUTTA	PD					
TOL:- AS ABOVE			<p style="text-align: center;">NUT AUTOMATIC DISENGAGING UNIT<ADU> HD SYSTEM FOR AN 32 A/C</p>			□ I/C D&S					
MATERIAL:- ALLOY STEEL EN 24 (817 M 40) AS PER SPECN. BS:970.						APPROVED			HEAD Q.A.		
FINISH:- AS IN SHEET NO. 2						DRG. NO.			ADRDE/ 1413-13(a)		
HEAT TREATMENT:- 265-352 BHN											



PROCEDURE:-

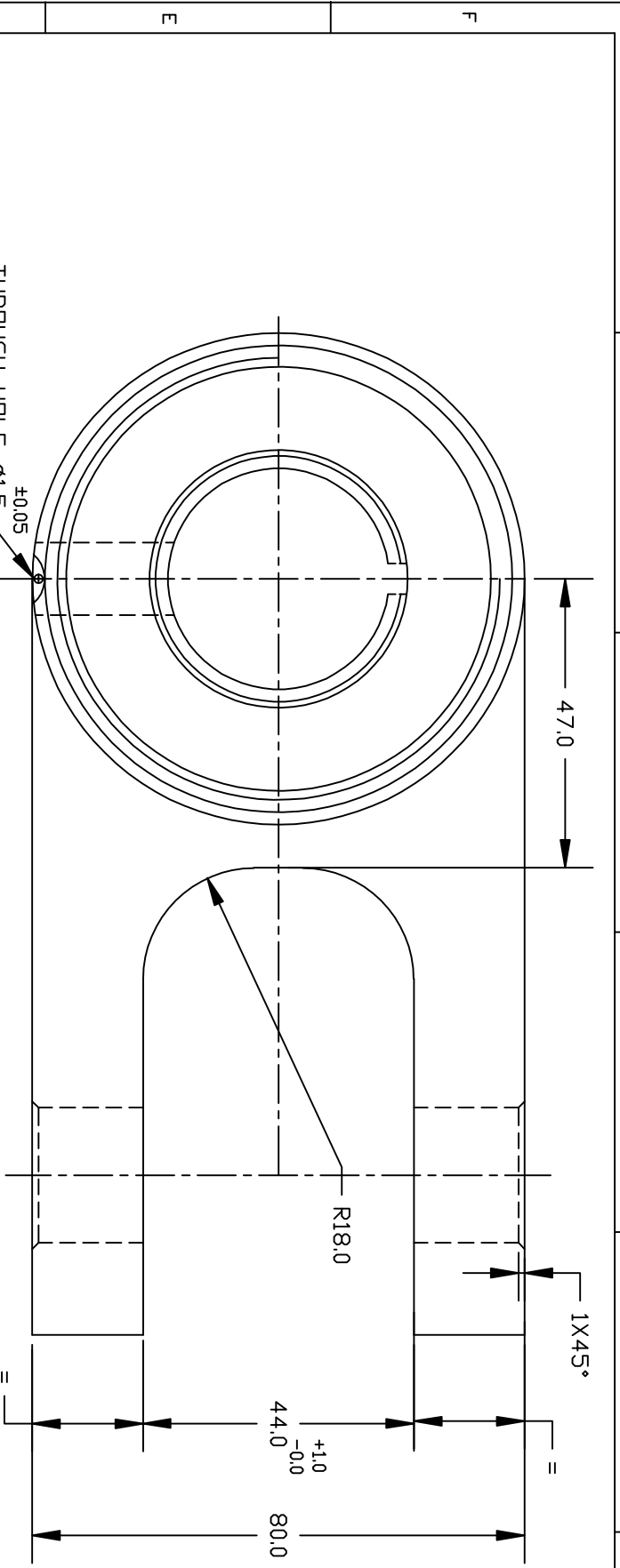
- 1-PLACE THE BURST CHARGE (5) (PYRD) IN THE LARGE PIN (ITEM No.1 OF ADU)
- 2-INTIGRATE THE TIME DELAY FIRING MECHANISM (TDFM) DRGNO. ADRDE/1425
- 3-REMOVE THE SAFETY PIN (2) AND PULLTHE OPERATING PIN (3) OF TDFM FROM A SAFE DISTANCE WITH THE HELP OF CORPAGE.
- 4-AT THE PRE SET DELAY PROVIDED BY PYRD CARTRIDGE (4) IN SIDE THE TDFM IGNITE THE BURST CHARGE (5) AND THROW THE LOCKING PIN (ITEM 6) FROM ADU.
- 5-AFTER FIRING AND RELEASE OF LOCKING PIN LINK (7) OF ADU SHOULD BE DISENGAGE FROM ADU.
- 6-AFTER THIS TEST ADU SHOULD BE CLEANED PROPERLY AS PER MANUAL

SECTION XX

Auto Disengaging Unit (ADU)

Time Delay Firing Mech. (TDFM)

SCALE:- NTS		QTY:- 1 ND.		A D R D E AGRA		DRN	SK SHARMA	PROJ.FFR.	
DIMENSIONS IN mm		TOL:- AS ABOVE		GROUP:- HDS		CHD	JC DUTTA	PD	
MATERIAL:-		FINISH:-		HEAT TREATMENT		PERFORMANCE TEST			
HEAT TREATMENT		AUTOMATIC DISENGAGING UNIT(ADU)		HD SYSTEM FOR AN 32 A/C		APPROVED			
D I/C D&S		HEAD Q.A.		DRG. NO.		HEAD Q.A.			
BRIEF RECORD		D I/C D&S		HEAD Q.A.		ADRDE/ 1413 14(a)			
RND.	DATE	ZONE	AUTHORITY	BRIEF RECORD		ADRDE/ 1413 14(a)			

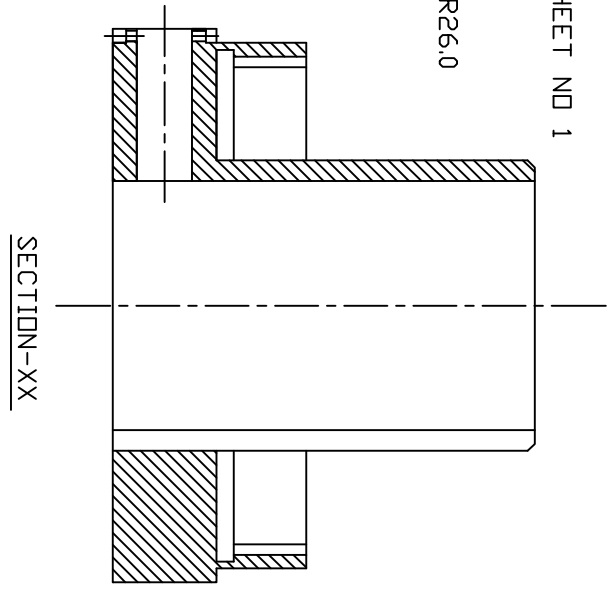
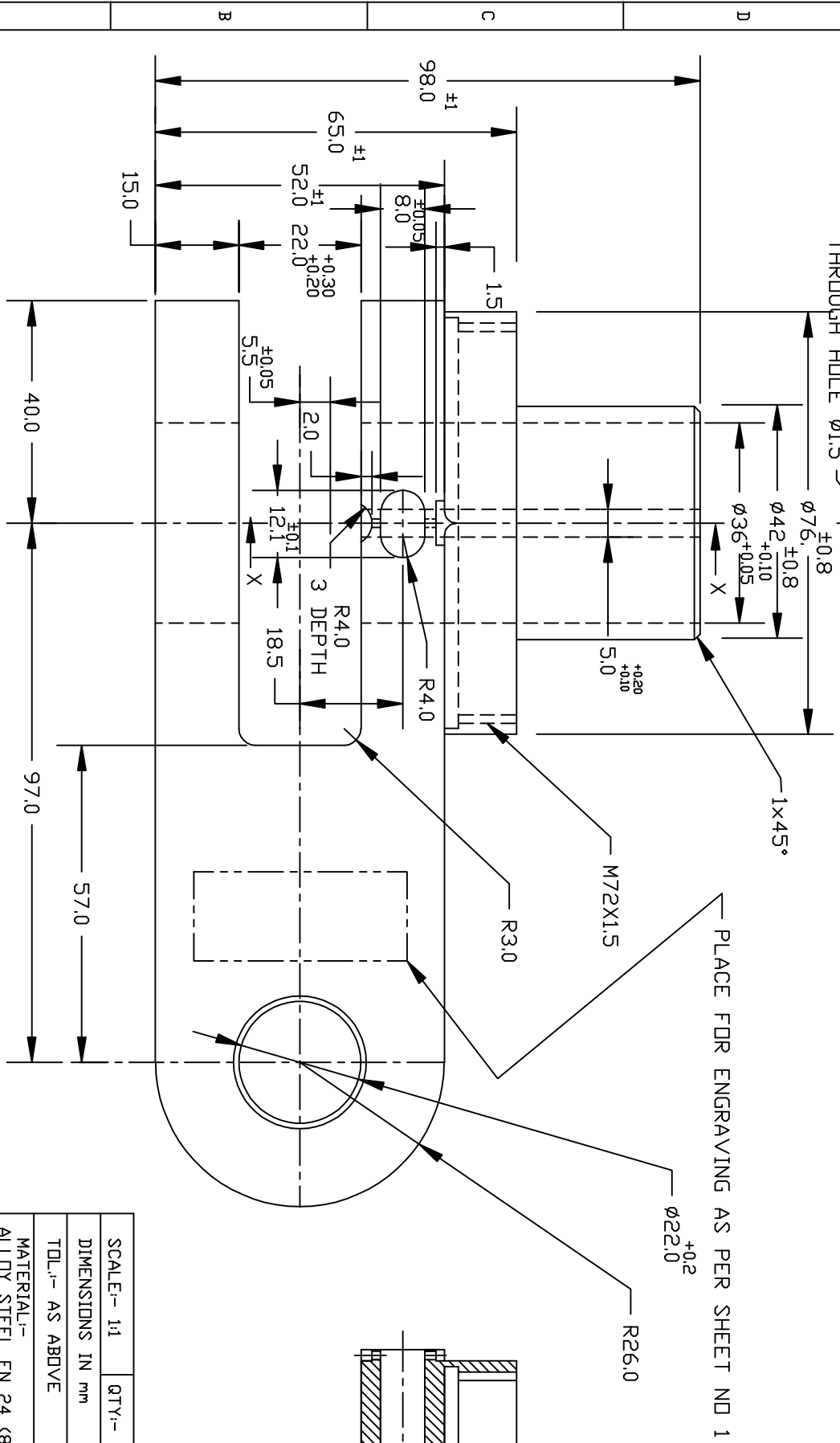


FINISH:-
 CADMIUM PLATED TO A MINIMUM THICKNESS OF
 12 MICRON STRESS RELIEF BEFORE PLATING
 HYDROGEN EMBRITTLEMENT AND CHROMATE
 PASSIVATED TO IS:1572-1986,Gr 3 Fe/Cd-12 CA

WORKMANSHIP:- THE FINISHED COMPONENTS SHALL
 BE FREE FROM PITS,CRACKS TOOL MARKS
 AND ANY OTHER SURFACE DEFECTS.

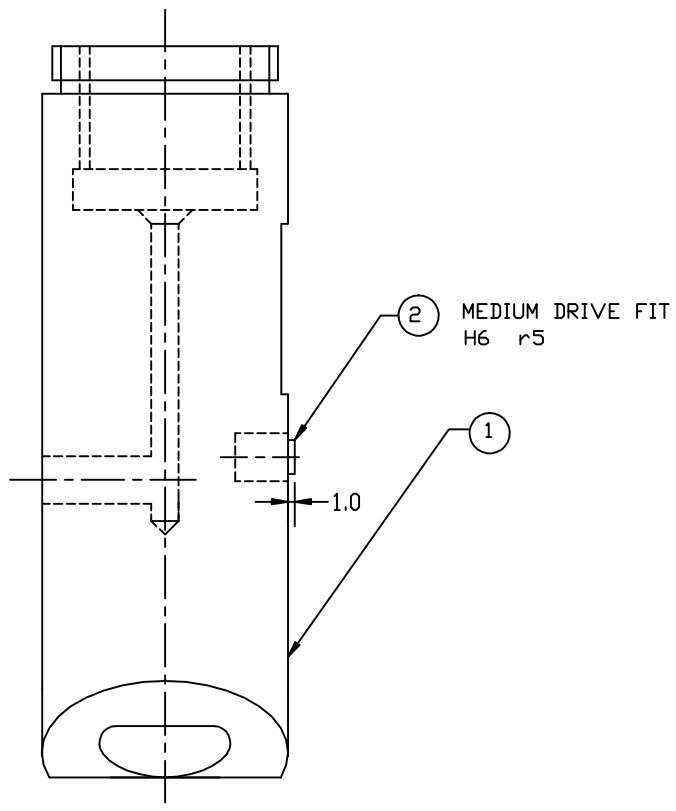
TOLERANCE:- IS:2102(PART-1) VERY COARSE EXCEPT
 WHERE OTHERWISE SPECIFIED

PROCESS:- FORGING & MACHINING



RND.	DATE	ZONE	AUTHORITY	BRIEF RECORD	D I/C D&S	HEAD Q.A.
8						

SCALE:- 1:1	QTY:- 1 ND.	A D R D E AGRA	DRN	SK SHARMA	PROJ.FFR.
DIMENSIONS IN mm		GROUP:- HDS	CHD	JC DUTTA	DIV./HEAD
TOL:- AS ABOVE		BDDY			GROUP DIR.
MATERIAL:- ALLOY STEEL EN 24 (817 M 40) AS PER SPECN. BS970		AUTOMATIC DISENGAGING UNIT(KADU)			DRG. NO.
FINISH:- AS ABOVE		HD SYSTEM FOR AN 32 A/C			HEAD Q.A.
HEAT TREATMENT 265-352 BHN		APPROVED			D I/C D&S
		DRG. NO.			
		ADDRDE/ 1413-01(α)			



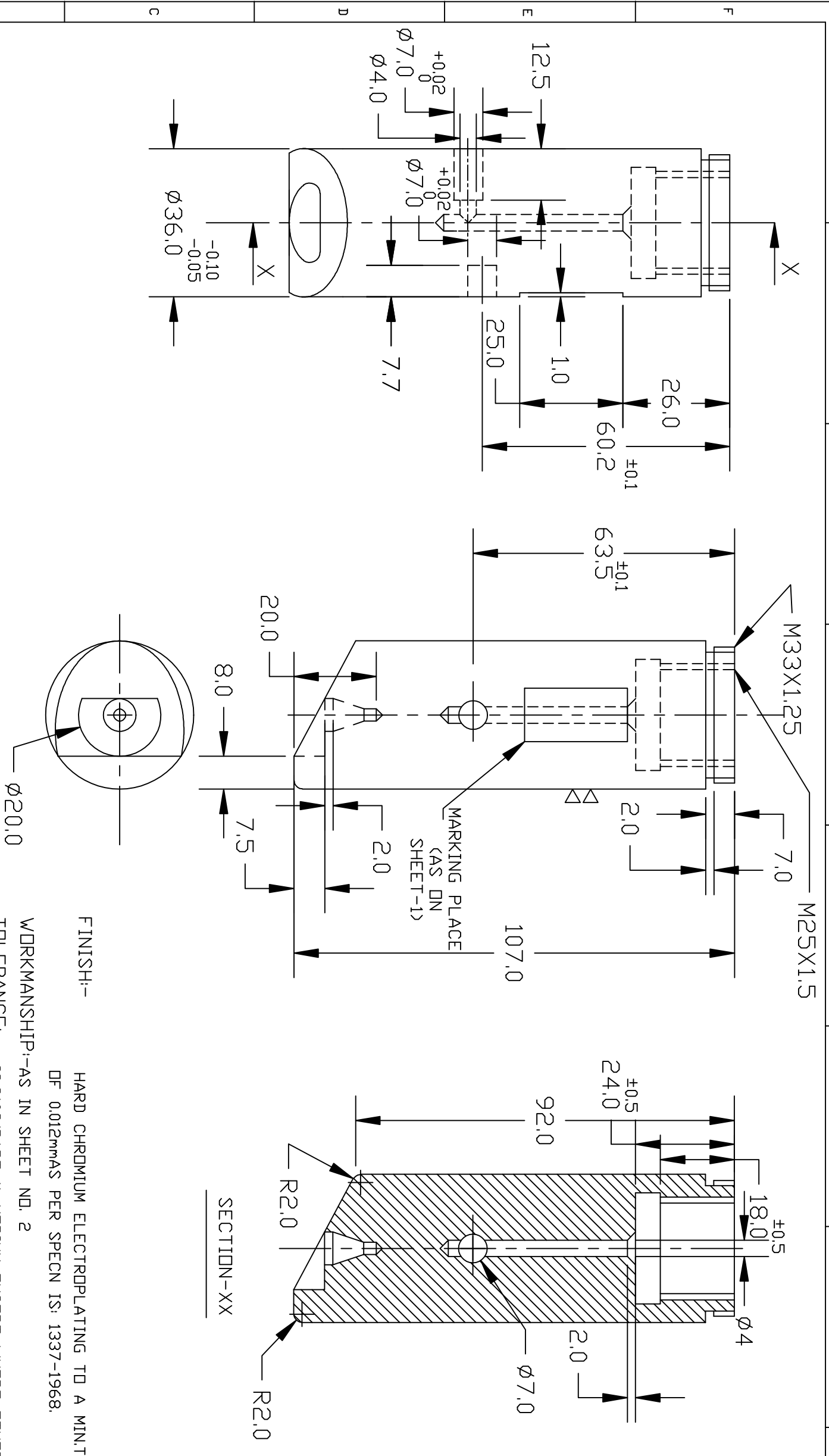
2	ADRDE/1413-02-02	GUIDE PIN	1	5
1	ADRDE/1413-02-01	LARGE PIN	1	4
ITEM No.	DRG./SPEC.No.	NOMENCLATURE	QTY	Sheet No

DETAIL INDEX

WORKMANSHIP:- AS IN SHEET NO. 2
 PROCESS:- FABRICATION

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD	I/C D&S	HEAD Q.A.
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SCALE:-1:1	QTY:- 1 NO.	A D R D E AGRA	DRN.	SK SHARMA	PRD.QFFR.
DIMENSIONS IN mm		GROUP	CHD.	JC DUTTA	PD
TOL.:- IS:2102(PART-1) MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED.		LARGE PIN SUB.ASSY. AUTOMATIC DISENGAGING UNIT(ADU) HD SYSTEM FOR AN 32 A/C			I/C D&S
MATERIAL:- ALLOY STEEL EN 24 (817 M 40) AS PER SPECN. BS:970.					APPROVED
FINISH:- AS PER DETAIL PART					HEAD Q.A.
HEAT TREATMENT:- 265-352 BHN					DRG. NO. ADRDE/ 1413-02(a)



FINISH:- HARD CHROMIUM ELECTROPLATING TO A MIN. THICKNESS OF 0.012mm/AS PER SPECN IS: 1337-1968.

WORKMANSHIP:- AS IN SHEET NO. 2

TOLERANCE:- IS:2102(PART-1) MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED.

PROCESS:- FABRICATION/MACHINING

SURFACE FINISH:- BEFORE CHROMIUM PLATING, THE SURFACE MARKED ∇ SHOULD HAVE ROUGHNESS OF 1.6 TO 8 MICRON.

SCALE:- 1:1	QTY:- 1 NO.	A D R D E AGRA	DRN	SK SHARMA	PROJ. OFFR.
DIMENSIONS IN mm		GROUP:-HDS	CHD	JC DUTTA	PD
TOL:- AS ABOVE		LARGE PIN, SUB ASSY			
MATERIAL:- ALLOY STEEL EN 24 (817 M 40) AS PER SPECN. BS970.					
FINISH:- AS ABOVE					
HEAT TREATMENT 265-352 BHN					
LARGE PIN, SUB ASSY					
AUTOMATIC DISENGAGING UNIT(KADU)					
HD SYSTEM FOR AN 32 A/C					
APPROVED					
D I/C D&S					
DRG. NO. HEAD Q.A.					
ADDRDE/ 1413-02-01(a)					

RND.	DATE	ZONE	AUTHORITY	BRIEF RECORD	D I/C D&S	HEAD Q.A.
8						

4

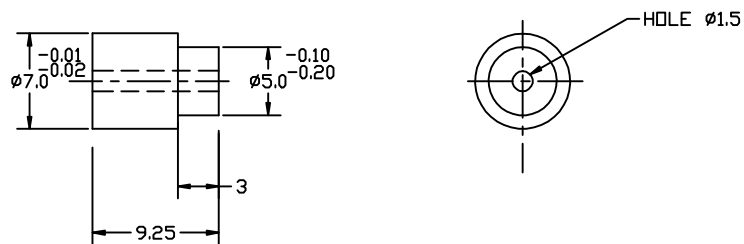
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1

SHEET 5 OF 17

(2)



WORKMANSHIP:- AS IN SHEET NO. 2

TOLERANCE:- IS:2102(PART-1) MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED.

PROCESS:- MACHINING

R.NO.

DATE

ZONE

AUTHORITY

BRIEF RECORD

D I/C
D&SHEAD
Q.A.

SCALE:-2:1

QTY:- 1 NO.

A D R D E AGRA

DRN.,

SK SHARMA

PRO.OFFR.

DIMENSIONS IN mm

GROUP:-HDS

CHD.

JC DUTTA

PD

MATERIAL:-
ALLOY STEEL EN 24 (817 M 40)
AS PER SPECN. BS:970.

FINISH:-

AS IN SHEET NO. 2

GUIDE PIN
LARGE PIN SUB ASSY.
AUTOMATIC DISENGAGING
UNIT(ADU)
HD SYSTEM FOR AN 32 A/C

D I/C D&S

APPROVED

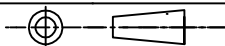
HEAD Q.A.

HEAT TREATMENT:-

265-352 BHN

DRG. NO.

ADRDE/ 1413-02-02(a)



4

3

2

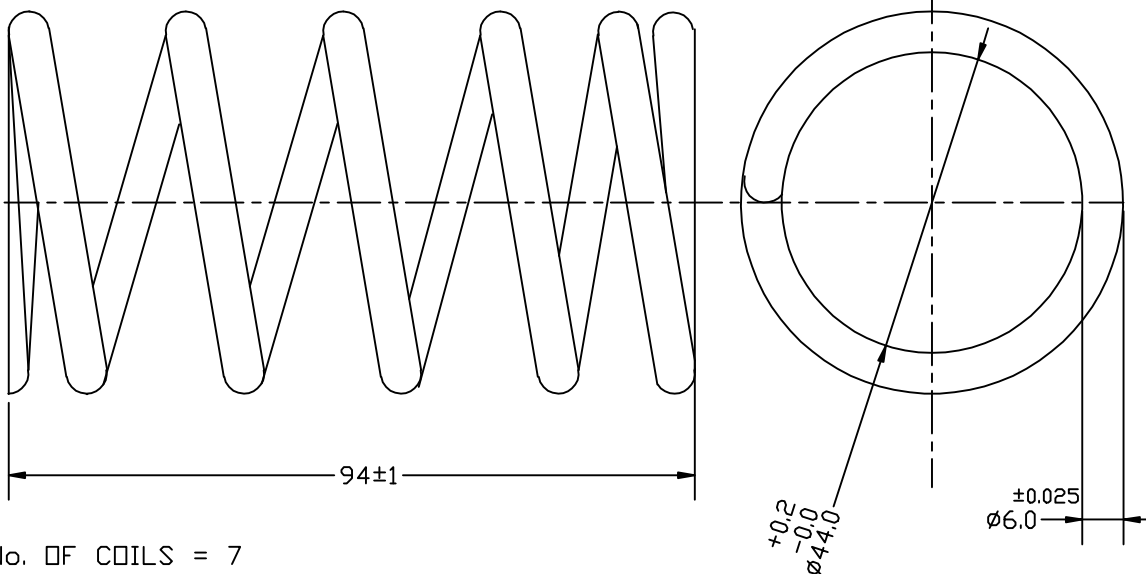
1

PERFORMANCE TEST:-

3

SHEET 6 OF 17

- 1-COMPRESSION LOAD OF RANGE 73 ± 3 Kg FOR 35mm COMPRESSION LENGTH
 2-SPRING SHALL BE KEPT IN FULL COMPRESSED POSITION UNDER A LOAD NOT MORE THAN 120 Kg. FOR 10 MINUTES. THERE SHOULD BE NO PERMANENT SET ON COMPLETE WITHDRAWL OF LOAD.
 3- 5% OF SPRINGS SHOULD BE KEPT IN FULL COMPRESSED POSITION UNDER A LOAD OF 170 Kg. FOR A PERIOD OF 24 HOURS. AFTER RELEASE OF LOAD PERMANENT SET SHOULD NOT MORE THEN 0.2mm.



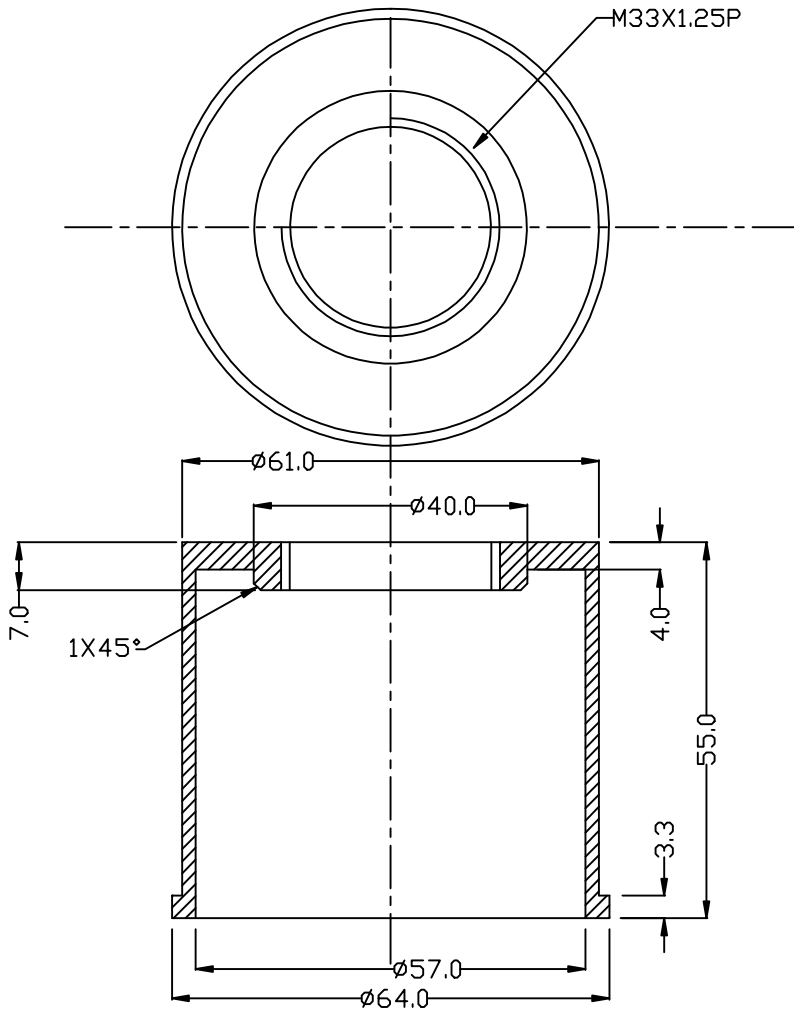
No. OF COILS = 7
 No. OF ACTIVE COILS = 5
 BOTH END SQUARED & GROUND FLAT
 FREE LENGTH = 94

WORKMANSHIP:- AS IN SHEET NO. 2

PROCESS:- COILING

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.	SK SHARMA	PRD.OFFR.					
DIMENSIONS IN mm			GROUP:-HDS	CHD.	JC DUTTA	PD					
TOL:- AS ABOVE			SPRING AUTOMATIC DISENGAGING UNIT(ADU) HD SYSTEM FOR AN 32 A/C			□ I/C D&S					
MATERIAL:- STAINLESS SPRING STEEL WIRE Gr1 AS PER IS:4454(Pt.IV)-1975						APPROVED			HEAD Q.A.		
FINISH:- AS PER SHEET NO. 2						DRG. NO.			ADRDE/ 1413-03(a)		
HEAT TREATMENT:-											

4

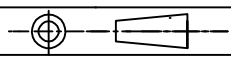


FINISH:- AS IN SHEET NO. 2

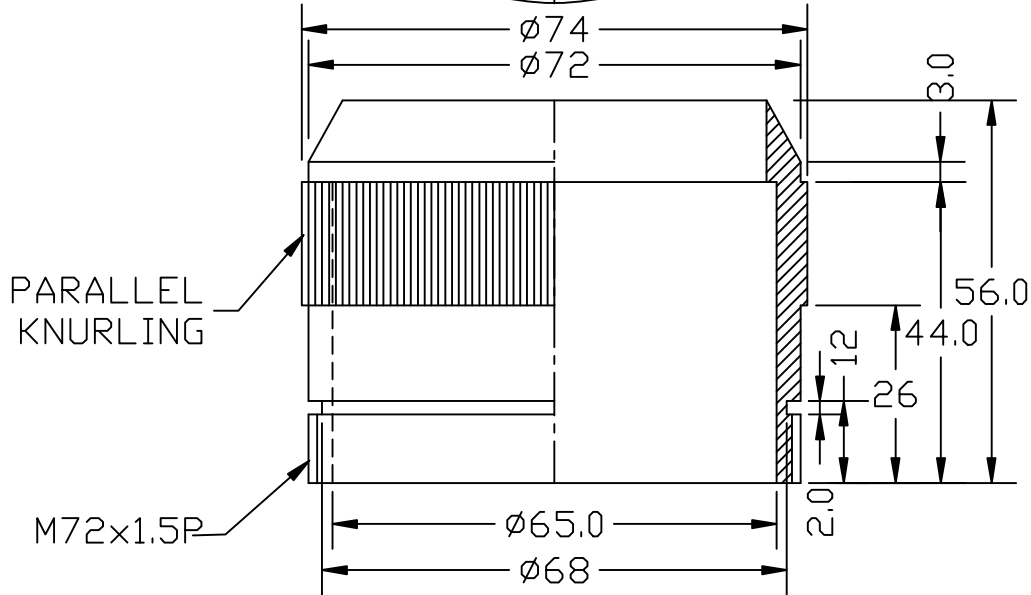
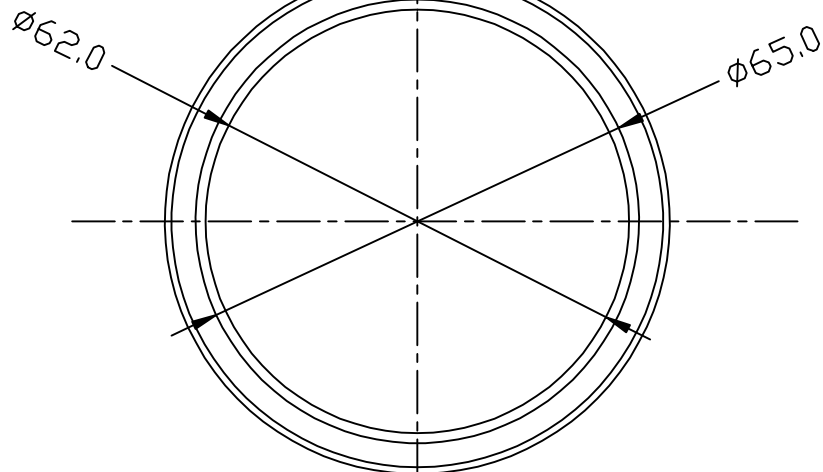
TOLERANCE:- IS:2102(PART-1) MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED.

PROCESS:- MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD		D I/C D&S	HEAD Q.A.		
SCALE:-1:1	QTY:- 1 NO.	A D R D E AGRA	DRN.	SK SHARMA	PRO.OFFR.				
DIMENSIONS IN mm		GROUP	CHD.	JC DUTTA	PD				
TOL:- AS ABOVE		INNER CYLINDER AUTOMATIC DISENGAGING UNIT(ADU) HD SYSTEM FOR AN 32 A/C				D I/C D&S			
MATERIAL:- ALLOY STEEL EN 24 (817 M 40) AS PER SPECN. BS:970.						APPROVED		HEAD Q.A.	
FINISH:- AS IN SHEET NO. 2						DRG. NO.		ADRDE/ 1413-04(a)	
HEAT TREATMENT:- 265-352 BHN									



5

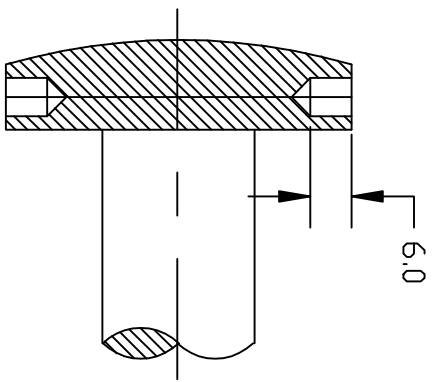
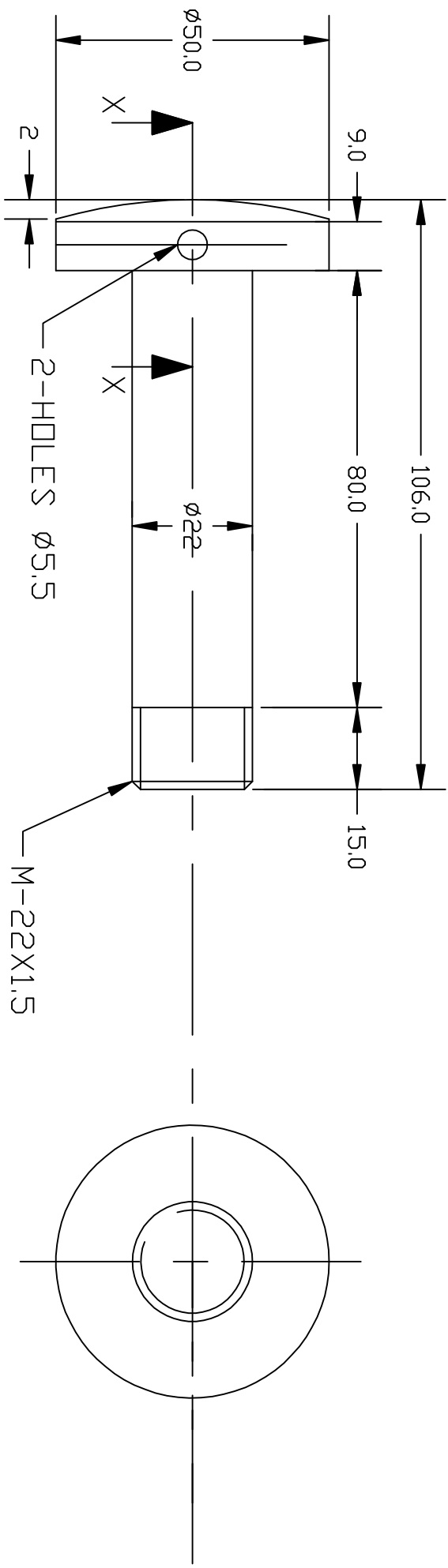


WORKMANSHIP:- AS IN SHEET NO. 2

TOLERANCE:- IS:2102(PART-1) MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED.

PROCESS:- MACHINING

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.	SK SHARMA	PRO.DFFR.			
DIMENSIONS IN mm			GROUP:-HDS	CHD.	JC DUTTA	PD			
TOL:- AS ABOVE			<p>OUTER CYLINDER AUTOMATIC DISENGAGING UNIT(ADU) HD SYSTEM FOR AN 32 A/C</p>			I/C D&S			
MATERIAL:- ALLOY STEEL EN 24 (817 M 40) AS PER SPECN. BS:970.						APPROVED		HEAD Q.A.	
FINISH:- AS IN SHEET NO. 2						DRG. NO.		ADRDE/ 1413-05(a)	
HEAT TREATMENT:- 265-352 BHN									



SECTION-XX

WORKMANSHIP:- AS IN SHEET NO. 2
 TOLERANCE:- IS:2102(PART-1) MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED.
 PROCESS:- FORGING/MACHINING FROM FORGED BAR
 PROOF LOAD:- AT 3500 LOAD IN ASSEMBLED CONDITION AS PER ASSEMBLY DRAWING 1413

SCALE:- 1:1		QTY:- 1 NO.		A D R D E AGRA		DRN		SK SHARMA		PROOFFR.	
DIMENSIONS IN mm		TOL:- AS ABOVE		GROUP		CHD		JC DUTTA		PD	
MATERIAL:- ALLOY STEEL, EN 24 (817 M 40) AS PER SPECN. BS970.		FINISH:- AS IN SHEET NO. 2		HEAT TREATMENT 265-352 BHN		AUTOMATIC DISENGAGING UNIT(KADU)		HD SYSTEM FOR AN 32 A/C		DRG. NO. ADRDE/ 1413-06(a)	
D I/C D&S		HEAD Q.A.		D I/C D&S		HEAD Q.A.		D I/C D&S		HEAD Q.A.	
BRIEF RECORD		D I/C D&S		HEAD Q.A.		D I/C D&S		HEAD Q.A.		D I/C D&S	
RND.		DATE		ZONE		AUTHORITY		BRIEF RECORD		D I/C D&S	
8		7		6		5		4		3	
8		7		6		5		4		3	