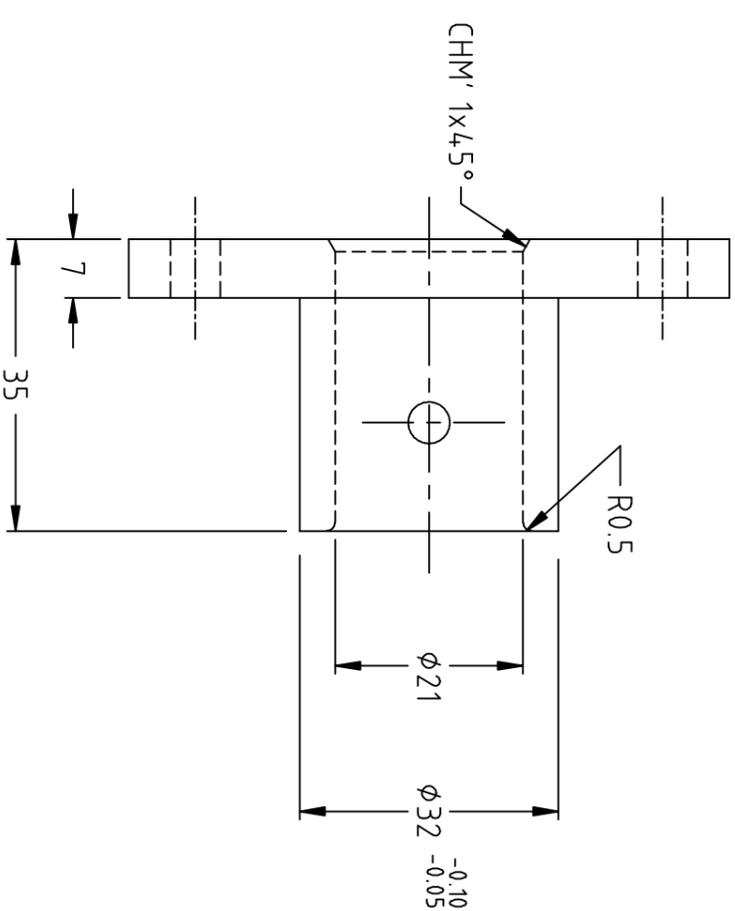
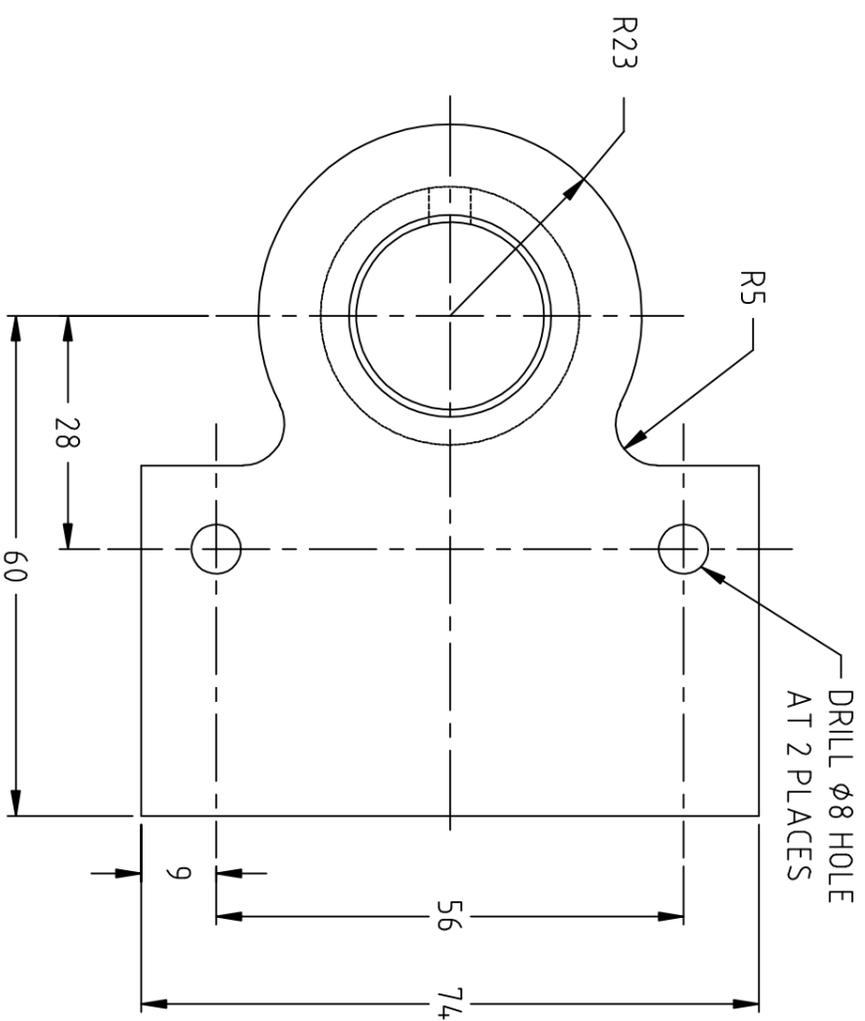
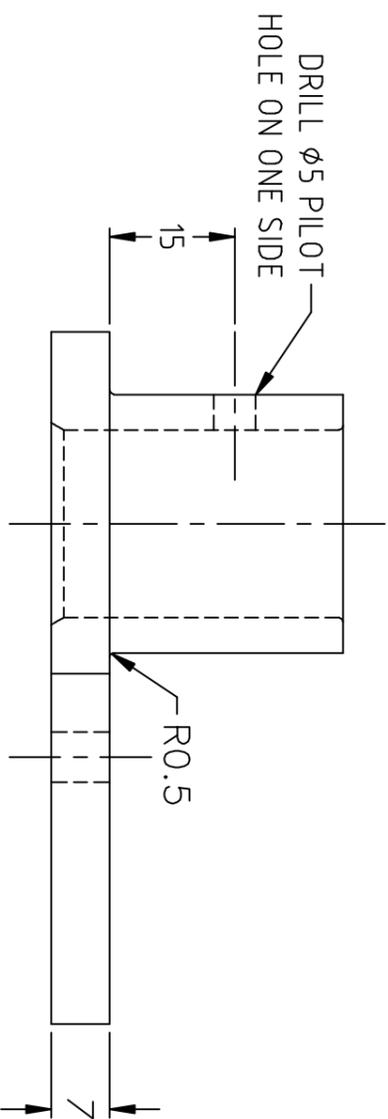


NOTE:- ROUND OFF ALL SHARP CORNERS TO RADIUS 0.2mm  
 PROCESS :- MACHINING/FABRICATION

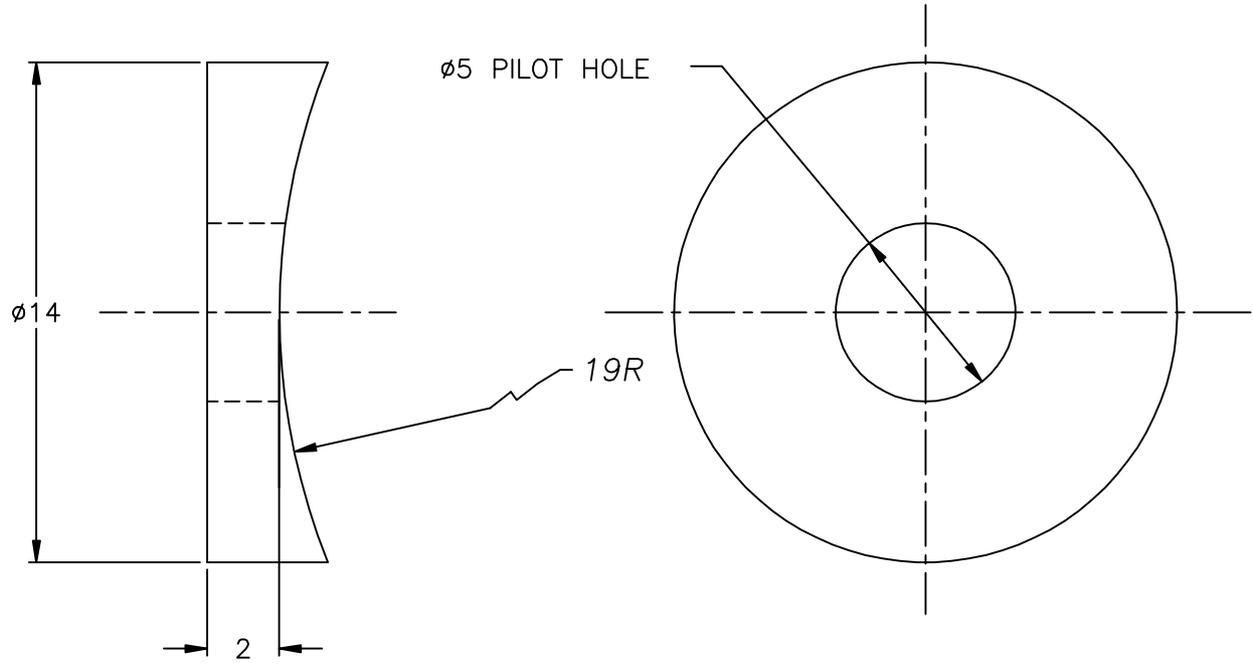
Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE :- 1:1		QTY:- 1 No.		ADRDE AGRA	DRN.	SK SHARMA		PROJ.OFFR./GP.OFFR	
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA			
TOLERANCE:- IS:2102(PART-I) :1993 MEDIUM UNLESS OTHERWISE SPECIFIED				RIB PIPE SUB ASSEMBLY TENSIONING DEVICE WITH PIN (H D 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.24							GROUP DIR.		
HEAT TREATMENT:- HARDENED AND TEMPERED 32±5 HRC							DRG. NO. ADRDE/1408 -02- 02		



MANUFACTURING PROCESS :- MACHINING/FABRICATION

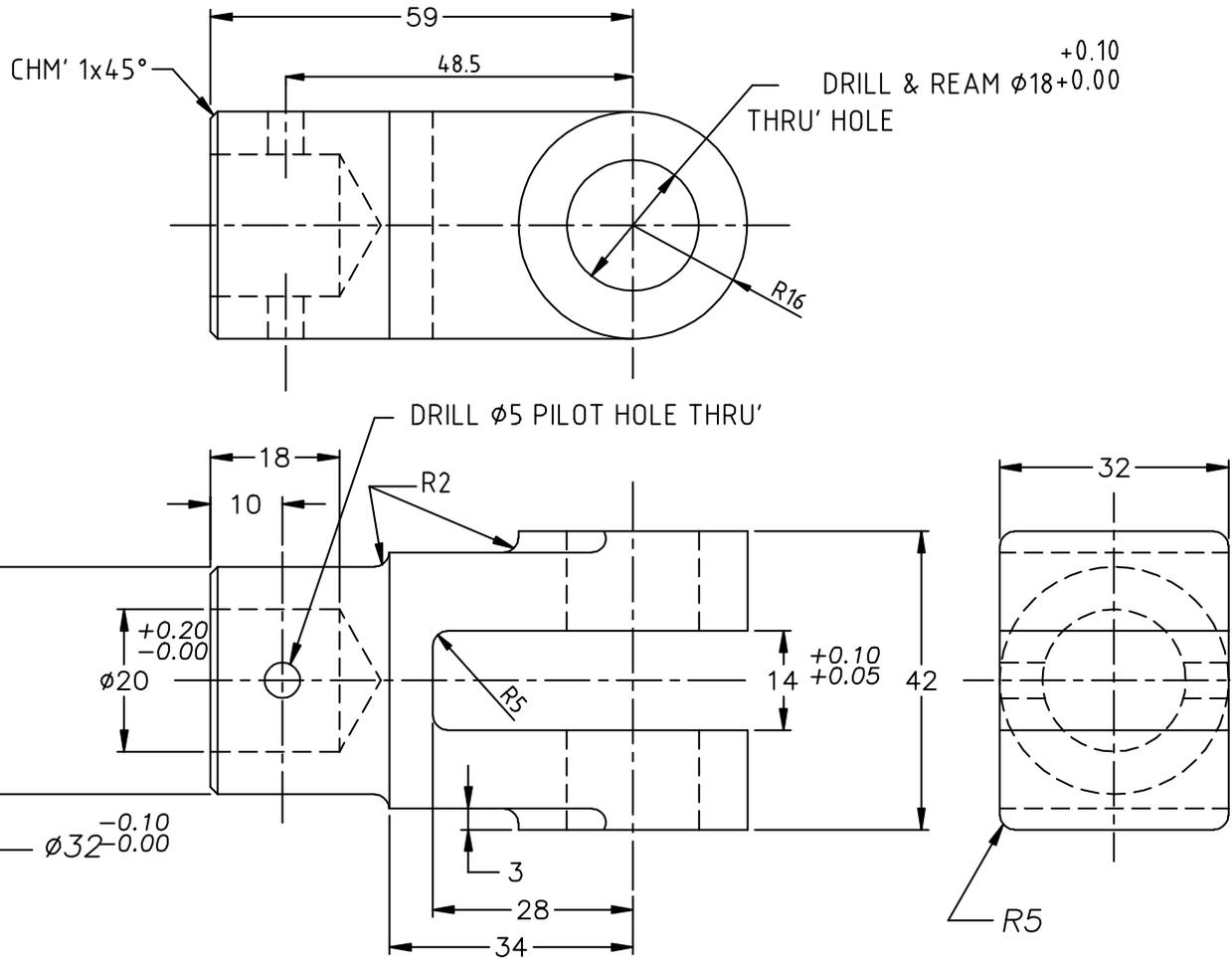
Ref. NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/I/C	HEAD
1					D&S	D.A.

SCALE:- NTS	QTY :- 1 No.	A D R D E A G R A	DRN.	S K S H A R M A	APPROVED
DIMENSIONS IN mm		GROUP:- HDS	CHKD.	J.C.DUTTA	
TOL:- IS:2102(PART-I) :1993MEDIUM UNLESS OTHERWISE SPECIFIED		MATERIAL:- STEEL ALLOY (EN19/EN24)709M40/817M40 AS PER BS:970		FINISH:- AS PER SHEET No.24	
HEAT TREATMENT:- HARDENED & TEMPERED 32±5 HRC		PIPE SUB ASSEMBLY TENSIONING DEVICE WITH PIN (HD SYSTEM FOR AN-32 A/C)		GROUP DIR.	
DRG. NO. ADPDE/1408-01-02		PROJ.DIR.			



NOTE:- ROUND OFF ALL SHARP CORNERS TO RADIUS 0.2 mm  
 PROCESS :- MACHINING

Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)		
SCALE :-NTS		QTY:- 3 Nos.		ADRDE AGRA	DRN.	SK SHARMA		PROJ.OFFR./GP.OFFR			
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA					
TOLERANCE:- IS:2102(PART-I) :1993 MEDIUM UNLESS OTHERWISE SPECIFIED				SADDLE WASHER PIPE SUB ASSEMBLY TENSIONING DEVICE WITH PIN (H D SYSTEM FOR AN-32 A/C)				PROJ.DIR.			
MATERIAL:- STEEL ALLOY 709M40/817M40, (EN19/EN24 ),AS PER BS:970.								APPROVED		GROUP DIR.	
FINISH:- AS PER SHEET No.24								DRG. NO. ADRDE/1408-02- 04			
HEAT TREATMENT:- HARDENED AND TEMPERED 32±5 HRC											

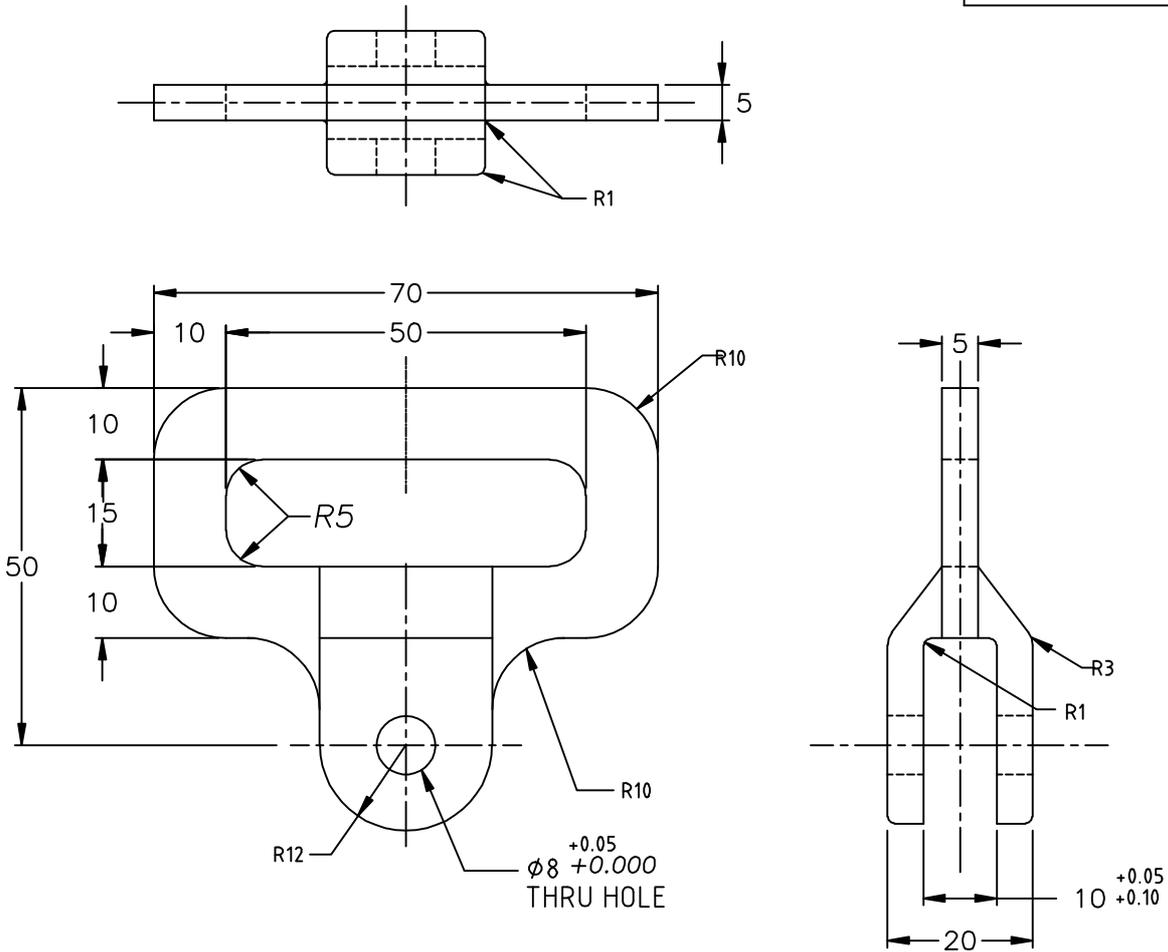


NOTE:- ROUND OFF ALL SHARP CORNERS TO RADIUS 0.2 mm

PROCESS :- MACHINING

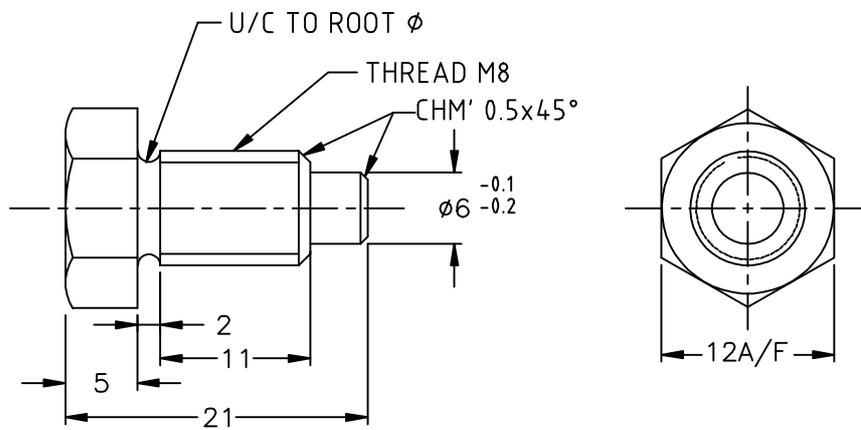
Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)		
SCALE :-1:1		QTY:- 1 No.		A D R D E AGRA	DRN.	SK SHARMA		PROJ.OFFR./GP.OFFR			
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA					
TOLERANCE:- IS:2102(PART-I) :1993 MEDIUM UNLESS OTHERWISE SPECIFIED				FORK TENSIONING DEVICE WITH PIN (H D SYSTEM FOR AN-32 A/C)				PROJ.DIR.			
MATERIAL:- STEEL ALLOY 709M40/817M40, (EN19/EN24 ),AS PER BS:970.								APPROVED		GROUP DIR.	
FINISH:- AS PER SHEET No.24								DRG. NO. ADRDE/1408- 03			
HEAT TREATMENT:- HARDENED AND TEMPERED 32±5 HRC											
											





NOTE:- ROUND OFF ALL SHARP CORNERS TO RADIUS 0.2 mm.  
 PROCESS :- MACHINING

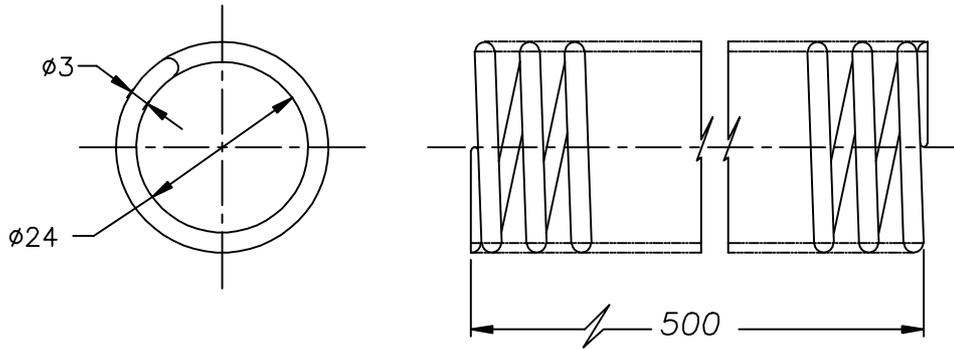
Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE :-1:1	QTY:- 1 No.		A D R D E A G R A	DRN.	SK SHARMA			
DIMENSIONS IN mm			GROUP:- HDS	CHKD.	JC DUTTA	PROJ.OFFR./GP.OFFR		
TOLERANCE:- IS:2102(PART1) :1993 MEDIUM UNLESS OTHERWISE SPECIFIED			<p style="text-align: center;"><b>LUG</b>                  TENSIONING DEVICE WITH PIN                  (H D SYSTEM FOR AN-32 A/C)</p>			PROJ.DIR.		
MATERIAL:- STEEL ALLOY 709M40/817M40, (EN19/EN24 ),AS PER BS:970						APPROVED		
FINISH:- AS PER SHEET No.24						GROUP DIR.		
HEAT TREATMENT:- HARDENED AND TEMPERED 32±5 HRC						DRG. NO. ADRDE/1408- 05		



NOTE:- ROUND OFF ALL SHARP CORNERS TO RADIUS 0.2 mm.

PROCESS :- MACHINING

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 A G R A	DRN.	SK SHARMA		PROJ.OFFR./GP.OFFR	
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	J C D U T T A			
TOLERANCE:- IS:2102(PART1):1993 VERY COARSE UNLESS OTHERWISE SPECIFIED				STOPPER TENSIONING DEVICE WITH PIN (H D 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.24							GROUP DIR.		
HEAT TREATMENT:- HARDENED AND TEMPERED 32±5 HRC							DRG. NO. ADRDE/1408- 06		

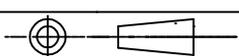


NOTE:-

1. NUMBERS OF COILS = 60
2. TOTAL EFFECTIVE NUMBERS OF COILS = 58
3. ENDS ARE GROUND SQUARE TO AXIS
4. STIFFNESS = 0.072kg/mm.(Min)
5. SPRING WIRE DIAMETER = 3mm

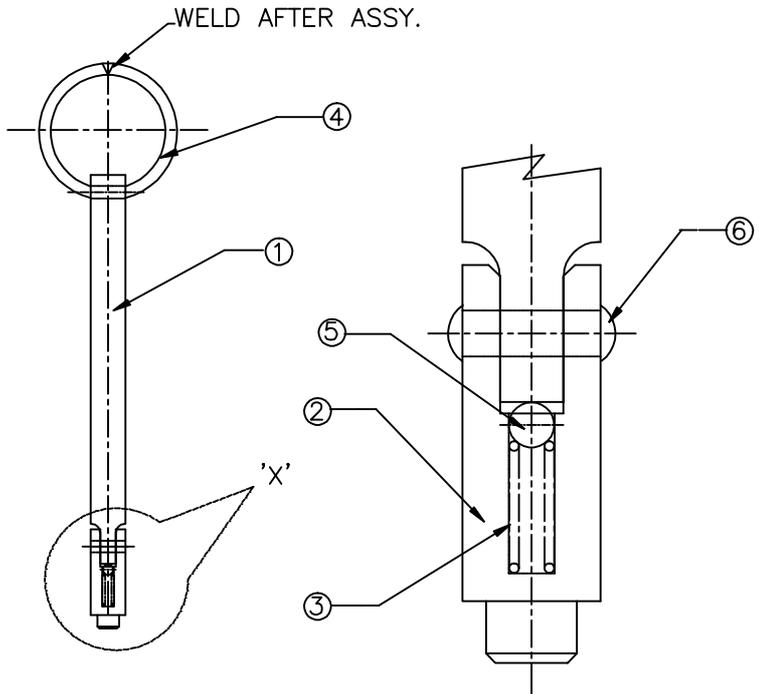
NOTE :- ROUND OFF ALL SHARP CORNERS TO RADIUS 0.2. mm.

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		
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA		
TOLERANCE:- IS:2102(PART1) :1993 VERY COARSE UNLESS OTHERWISE SPECIFIED				SPRING TENSIONING DEVICE WITH PIN  (H D SYSTEM FOR AN-32 A/C)			PROJ.OFFR./GP.OFFR	
MATERIAL:- SPRING STEEL WIRE PART-1 GRADE IV AS PER IS: 4454							PROJ.DIR.	
FINISH:- AS PER SHEET No.24							APPROVED	
HEAT TREATMENT:-							GROUP DIR.	
							DRG. NO.ADRDE/1408- 07	

ITEM No.	DRG./SPECN. NO.	NOMENCLATURE	QTY	SHEET No.
6	ADRDE-1408-08-05	RIVET	1	23
5	STAINLESS STEEL BALL COMMERCIAL QUALITY	BALL $\phi$ 5.5	1	—
4	ADRDE-1408-08-04	RING	1	22
3	ADRDE-1408-08-03	SPRING	1	21
2	ADRDE-1408-08-02	FORK	1	20
1	ADRDE-1408-08-01	PIN	1	19

ITEM LIST

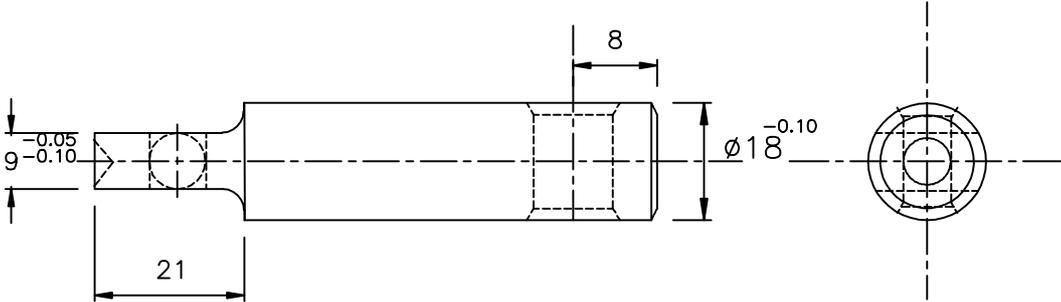
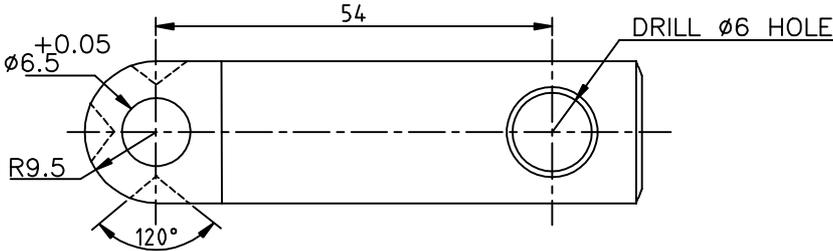


ENLARGED VIEW AT 'X'

WELDING :- ALL WELDED JOINTS SHOULD BE WELDED BY ELECTRODES CONFORMING TO ADVANI OERLIKON SUPERCITO AWS A/SFA 5.1:E7018 OR IS:814:EB 5426 H3JX OR ITS EQUIVALENT.

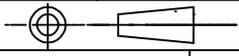
PROCESS :- FABRICATION

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	PROJ.OFFR./GP.OFFR			
DIMENSIONS IN mm		GROUP :- HDS		CHKD.	JC DUTTA	PROJ.DIR.				
TOLERANCE :- IS:2102(PART1):1993 MEDIUM UNLESS OTHERWISE SPECIFIED				LOCK PIN SUB. ASSEMBLY TENSIONING DEVICE WITH PIN (H D SYSTEM FOR AN-32 A/C)				APPROVED		
MATERIAL :-							GROUP DIR.		DRG. NO. ADRDE/1408-08	
FINISH :- AS PER SHEET No.24									HEAT TREATMENT :-	
HEAT TREATMENT :-										

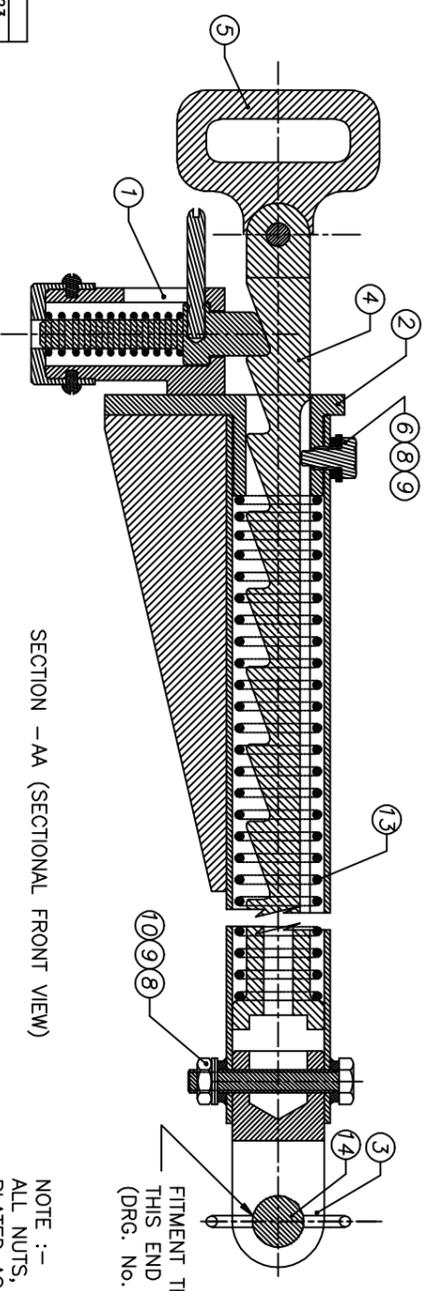
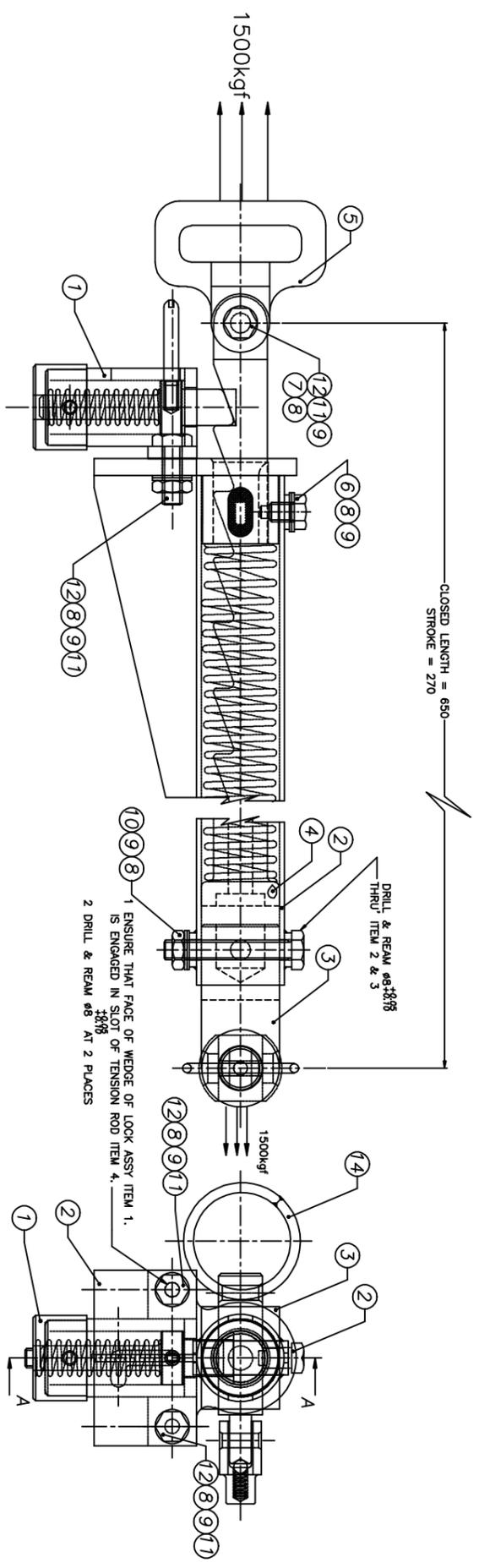


PROCESS :- MACHINING

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.	JC DUTTA	PROJ.OFFR./GP.OFFR	
TOLERANCE:- IS:2102(PART-I) :1993 MEDIUM UNLESS OTHERWISE SPECIFIED				PIN LOCK PIN SUB. ASSY TENSIONING DEVICE WITH PIN (H D 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.24							GROUP DIR.	
HEAT TREATMENT:- HARDENED AND TEMPERED 32±5 HRC							DRG. NO. ADRDE/1408- 08-01	



PROOF LOAD TEST :- TENSIONING DEVICE WITH PIN TO BE TESTED FOR 1500kgf LOAD AS SHOWN IN DRAWING.



FITMENT TEST :  
 THIS END SHOULD BE FITTED TO THE EYE BOLT (DRG. No. 1287-01-15) WITHOUT ANY PROBLEM

NOTE :-  
 ALL NUTS, BOLTS AND WASHERS SHOULD BE CADMIUM PLATED AS PER IS:1572 GR-3,10-12 MICRONS.

MANUFACTURING PROCESS :- FABRICATION

ITEM NO.	DRG./SPECN. NO.	QTY	SHEET No.
1	ADPDE/1408-01	1	2-7
2	ADPDE/1408-02	1	8-12
3	ADPDE/1408-03	1	13
4	ADPDE/1408-04	1	14
5	ADPDE/1408-05	1	15
6	ADPDE/1408-06	1	16
7	IS:549	1	17
8	IS:3063:1975	5	18-23
9	IS:2016-1967	1	19
10	IS:1364-1967	1	20
11	IS:2232-1967	1	21
12	IS:1364-1967	1	22
13	ADPDE/1408-07	1	23
14	ADPDE/1408-08	1	24

PROCEDURE FOR FINISH

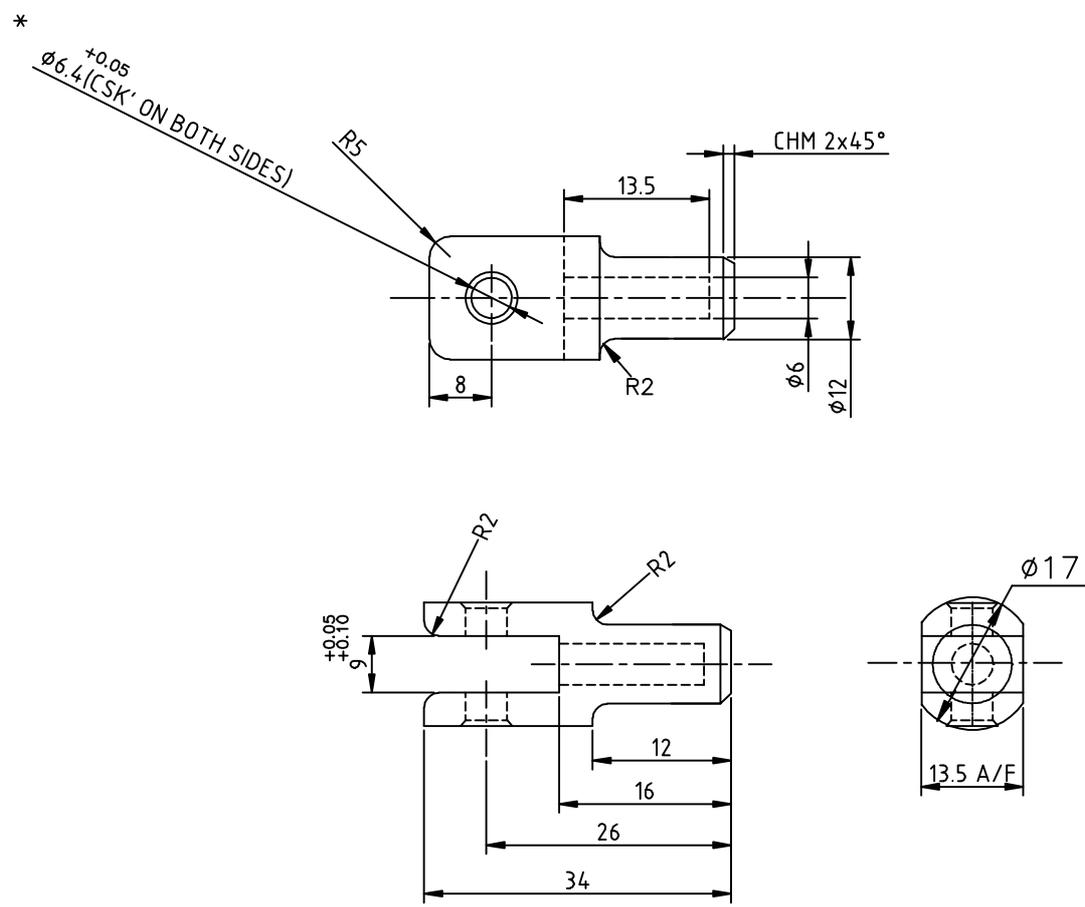
SCALE:-	NTS	QTY :-	1 No.
DIMENSIONS IN mm			
TOL:- IS:202(PART1):1993 VERY COARSE UNLESS OTHERWISE SPECIFIED			
MATERIAL:-			
FINISH:- AS PER SHEET No.24			
HEAT TREATMENT:-			
GROUP:- HDS			
DRN. SK SHARMA			
CHKD. J.C.DUTTA			
APPROVED			
PROJ.OFFR./GP OFFR			
PROJ.DIR.			

ASSEMBLY  
 TENSIONING DEVICE WITH PIN  
 (HD SYSTEM FOR AN-32A/C)

APPROVED  
 PROJ.OFFR./GP OFFR  
 PROJ.DIR.  
 DRG. NO. ADPDE/1408  
 GROUP DIR.

Ref. NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD
1				
2				
3				
4				

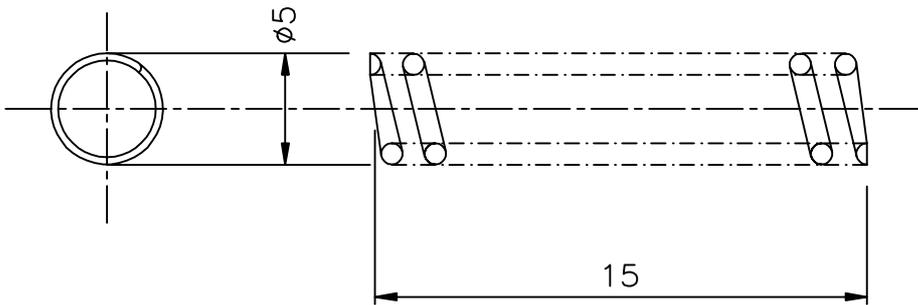
Ref. NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD
1				
2				
3				
4				



\* DRILL  $\phi 6.4$  TO MATCH RIVET CSK' ON BOTH SIDES

PROCESS :- MACHINING

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	PROJ.OFFR./GP.OFFR	
TOLERANCE:- IS:2102(PART1) :1993 MEDIUM UNLESS OTHERWISE SPECIFIED				<p style="text-align: center;">FORK LOCK PIN SUB. ASSEMBLY TENSIONING DEVICE WITH PIN (H D SYSTEM FOR AN-32 A/C)</p>			PROJ.DIR.	
MATERIAL:- STEEL ALLOY 709M40/817M40, (EN19/EN24 ),AS PER BS:970.							APPROVED	
FINISH:- AS PER SHEET No.24							GROUP DIR.	
HEAT TREATMENT:- HARDENED AND TEMPERED 32±5 HRC							DRG. NO. ADRDE/14.08- 08-02	

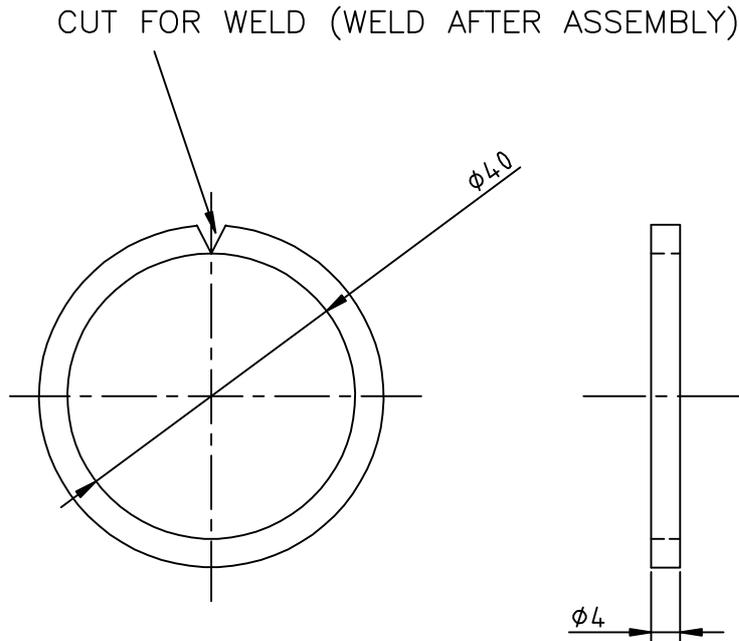


NOTE :-

1. WIRE DIAMETER = 0.8 mm
2. TOTAL No. OF COILS = 9
3. TOTAL No. OF EFFEECTIVE COILS = 7
4. ENDS ARE GROUND SQUARE TO AXIS
5. STIFFNESS OF SPRING = 0.729kg/mm

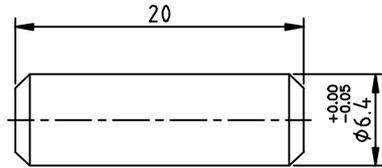
PROCESS :- FABRICATION

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		
TOLERANCE:- IS:2102(PART1) :1993 VERY COARSE UNLESS OTHERWISE SPECIFIED				<b>SPRING.</b> LOCK PIN SUB. ASSEMBLY TENSIONING DEVICE WITH PIN (H D SYSTEM FOR AN-32 A/C)			PROJ.OFFR./GP.OFFR	
MATERIAL:- STAINLESS SPRING STEEL WIRE IS :4454:1975(PART-IV)Gr.1							PROJ.DIR.	
FINISH:- NATURAL							APPROVED	
HEAT TREATMENT:-							GROUP DIR.	
							DRG. NO. ADRDE/1408- 08-03	



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					
TOLERANCE:- IS:2102(PART1) :1993 VERY COARSE UNLESS OTHERWISE SPECIFIED				RING LOCK PIN SUB. ASSEMBLY TENSIONING DEVICE WITH PIN (H D SYSTEM FOR AN-32 A/C)			PROJ.DIR.			
MATERIAL:- MILD STEEL ST-42 S ,AS PER IS:226							APPROVED		GROUP DIR.	
FINISH:- AS PER SHEET No.24							DRG. NO. ADRDE/1408-08-04			
HEAT TREATMENT:- NORMALISING										



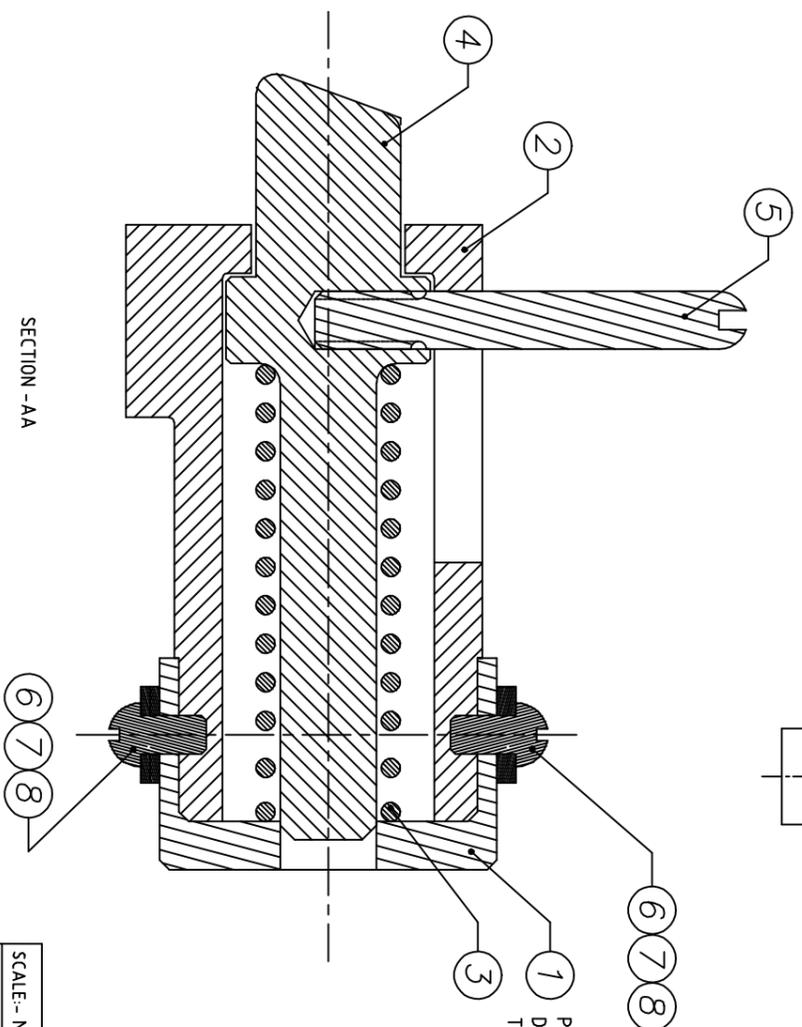
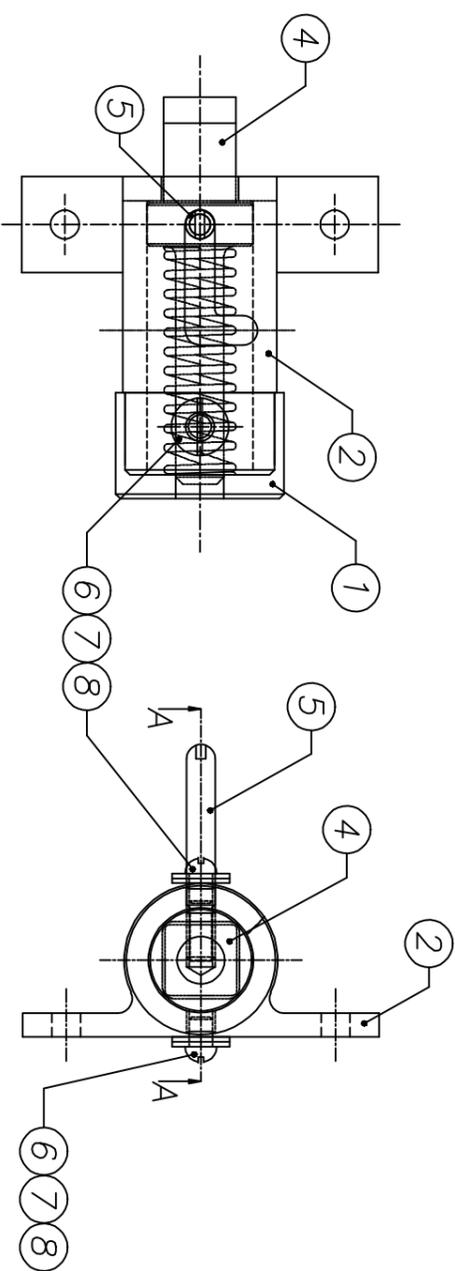
PROCESS :- MACHINING

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			
TOLERANCE:-[S:2102(PART-I) :1993]MEDIUM UNLESS OTHERWISE SPECIFIED			RIVET LOCK PIN SUB. ASSEMBLY TENSIONING DEVICE WITH PIN (H D SYSTEM FOR AN-32 A/C)			PROJ.DIR.		
MATERIAL:- STAINLESS STEEL (AUSTENITIC) 04Cr18Ni10 AS PER IS:6527-1972						APPROVED		
FINISH:- AS PER SHEET No.24						GROUP DIR.		
HEAT TREATMENT:- _____						DRG. NO. ADRDE/1408- 08-05		



8	IS: 3063-1965	SPRING WASHER M3	2	—
7	IS: 2016-1967	PLAIN WASHER	2	—
6	IS:2398-1968	SCREW M3	2	—
5	ADRDE/1408-01-05	PIN	1	7
4	ADRDE/1408-01-04	WEDGE	1	6
3	ADRDE/1408-01-03	SPRING	1	5
2	ADRDE/1408-01-02	HOUSING	1	4
1	ADRDE/1408-01-01	CAP	1	3
ITEM No.	DRG./SPEC.NO.	NOMENCLATURE	QTY.	SHEET No.

ITEM LIST

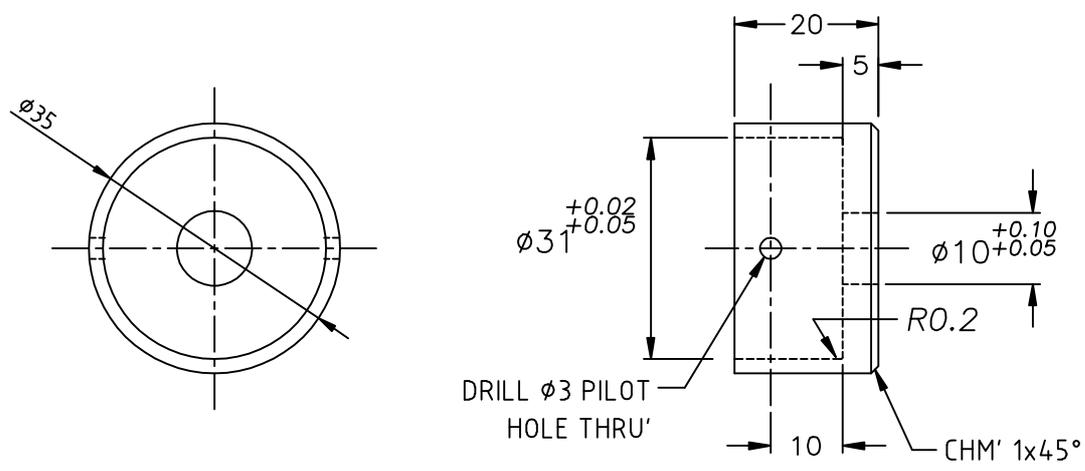


MANUFACTURING PROCESS :- MACHINING/FABRICATION

PICK UP HOLES IN ITEM 1  
 DRILL Ø3 HOLE IN ITEM 1,  
 THREAD M3 IN ITEM 2. AT TWO PLACES.

SCALE:- NTS	QTY :-	1 No.
DIMENSIONS IN mm		
TOL:- IS:2102(PART1):1993 MEDIUM UNLESS OTHERWISE SPECIFIED		
MATERIAL:-		
FINISH:- AS PER SHEET No.24		
HEAT TREATMENT:-		
AD R D E AGRA	DRN.	SK SHARMA
GROUP:- HDS	CHKD.	J.C.DUTTA
LOCK SUB ASSEMBLY TENSIONING DEVICE WITH PIN (HD SYSTEM FOR AN-32A/C)		
APPROVED		PROJ.DIR.
DRG. NO. ADRDE/1408-01		GROUP DIR.

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



NOTE:- ROUND OFF ALL SHARP CORNERS UPTO RADIUS 0.2mm  
 PROCESS :- MACHINING

Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)	
SCALE :-1:1		QTY:- 1No.		ADRDE AGRA	DRN.	SK SHARMA		PROJ.OFFR./GP.OFFR		
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA				
TOLERANCE:- IS:2102(PART1) :1993 MEDIUM UNLESS OTHERWISE SPECIFIED				CAP LOCK SUB ASSEMBLY TENSIONING DEVICE WITH PIN (H D SYSTEM FOR AN-32 A/C)			APPROVED		PROJ.DIR.	
MATERIAL:- STEEL ALLOY 709M40/817M40, (EN19/EN24 ), AS PER BS: 970							DRG. NO. ADRDE/1408-01-01		GROUP DIR.	
FINISH:- AS PER SHEET No.24										
HEAT TREATMENT:- HARDENED AND TEMPERED 32±5 HRC										

1

2

3

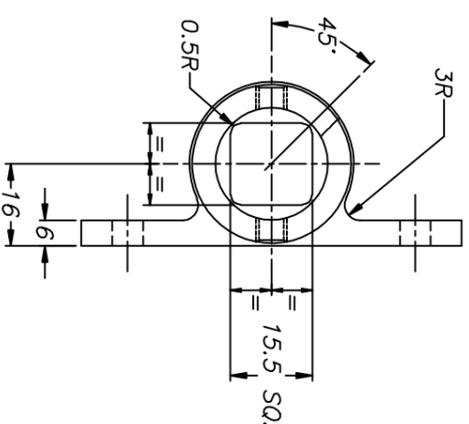
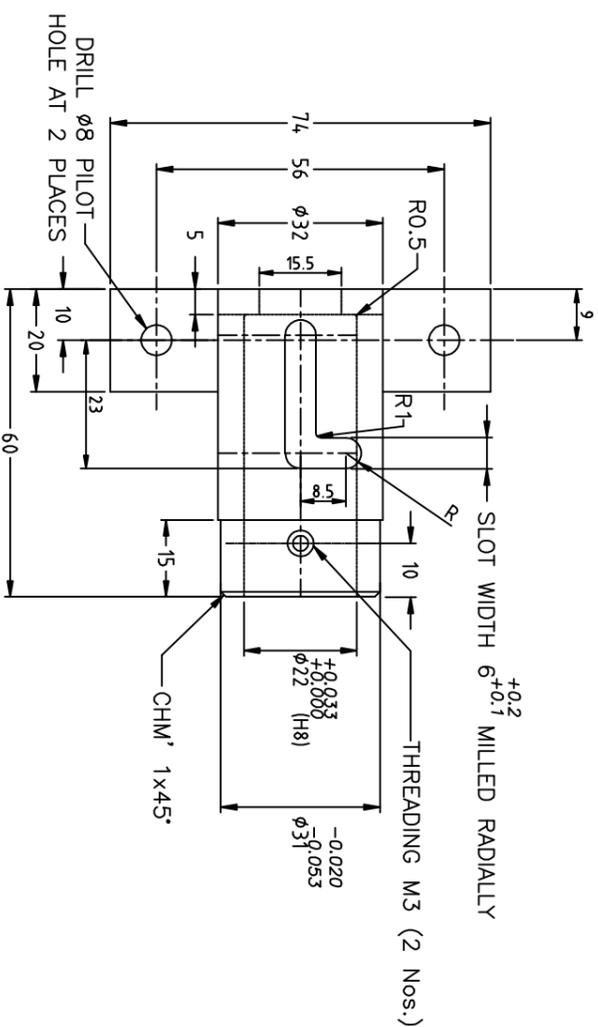
4

5

6

7

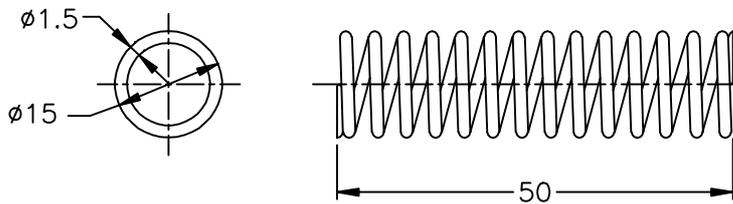
8



MANUFACTURING PROCESS :- MACHINING

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

SCALE:- NTS	QTY :- 1 No.	A D R D E A G R A	DRN.	SK SHARMA	APPROVED
DIMENSIONS IN mm		GROUP:- HDS	CHKD.	J.C.DUTTA	
TOL:- IS:2102(PART1):1993 MEDIUM UNLESS OTHERWISE SPECIFIED		HOUSING		PROJ.OFFR./GP.OFFR.	
MATERIAL: STEEL ALLOY (EN19/EN24)709M40/817M40 AS PER BS:970		LOCK SUB ASSEMBLY		PROJ.DIR.	
FINISH:- AS PER SHEET No.24		TENSIONING DEVICE WITH PIN		GROUP DIR.	
HEAT TREATMENT:- HARDENED & TEMPERED 32±5 HRC		(HD SYSTEM FOR AN-32A/C)		DRG. NO. ADRDE/1408-01-02	

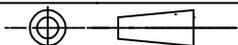


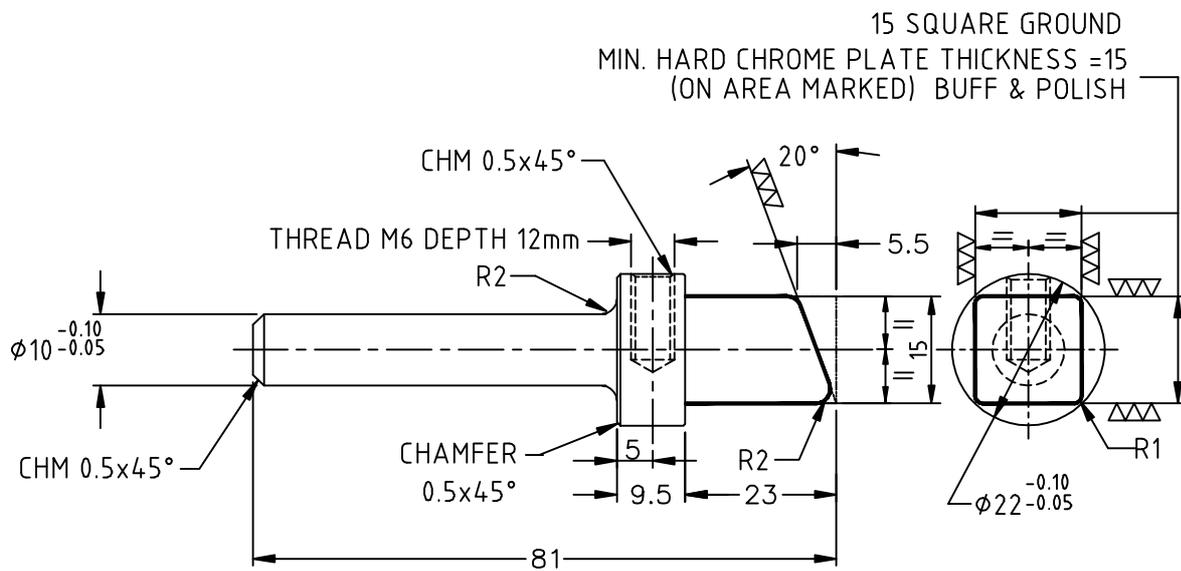
NOTE:-

1. NUMBERS OF COILS = 13
2. TOTAL EFFECTIVE NUMBERS OF COILS = 11
3. ENDS ARE GROUND SQUARE TO AXIS
4. STIFFNESS OF SPRING = 0.19kg/mm(Min.)
5. WIRE DIAMETER = 1.5mm.

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			
TOLERANCE:- IS:2102(PART1) :1993 VERY COARSE UNLESS OTHERWISE SPECIFIED			SPRING LOCK SUB ASSEMBLY TENSIONING DEVICE WITH PIN (H D SYSTEM FOR AN-32 A/C)			PROJ.DIR.		
MATERIAL:- SPRING STEEL WIRE AS PER IS:4454(PART I) Gr. IV						APPROVED		
FINISH:- AS PER SHEET No.24.						GROUP DIR.		
HEAT TREATMENT:-						DRG. NO. ADRDE/1408- 01- 03		

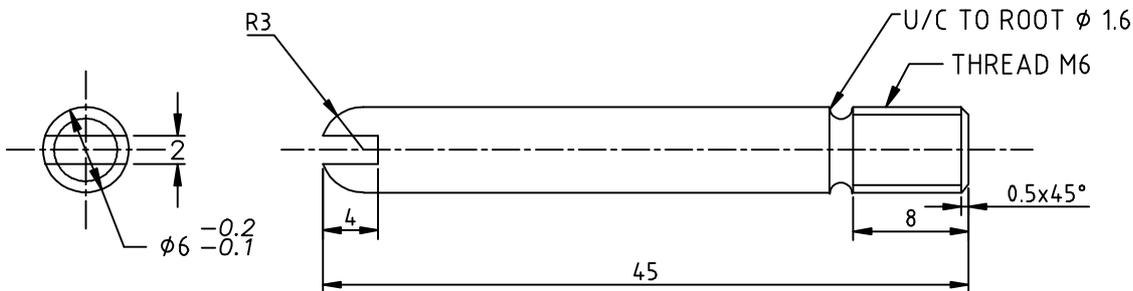




NOTE:- ROUND OFF ALL SHARP CORNERS TO RADIUS 0.2 mm

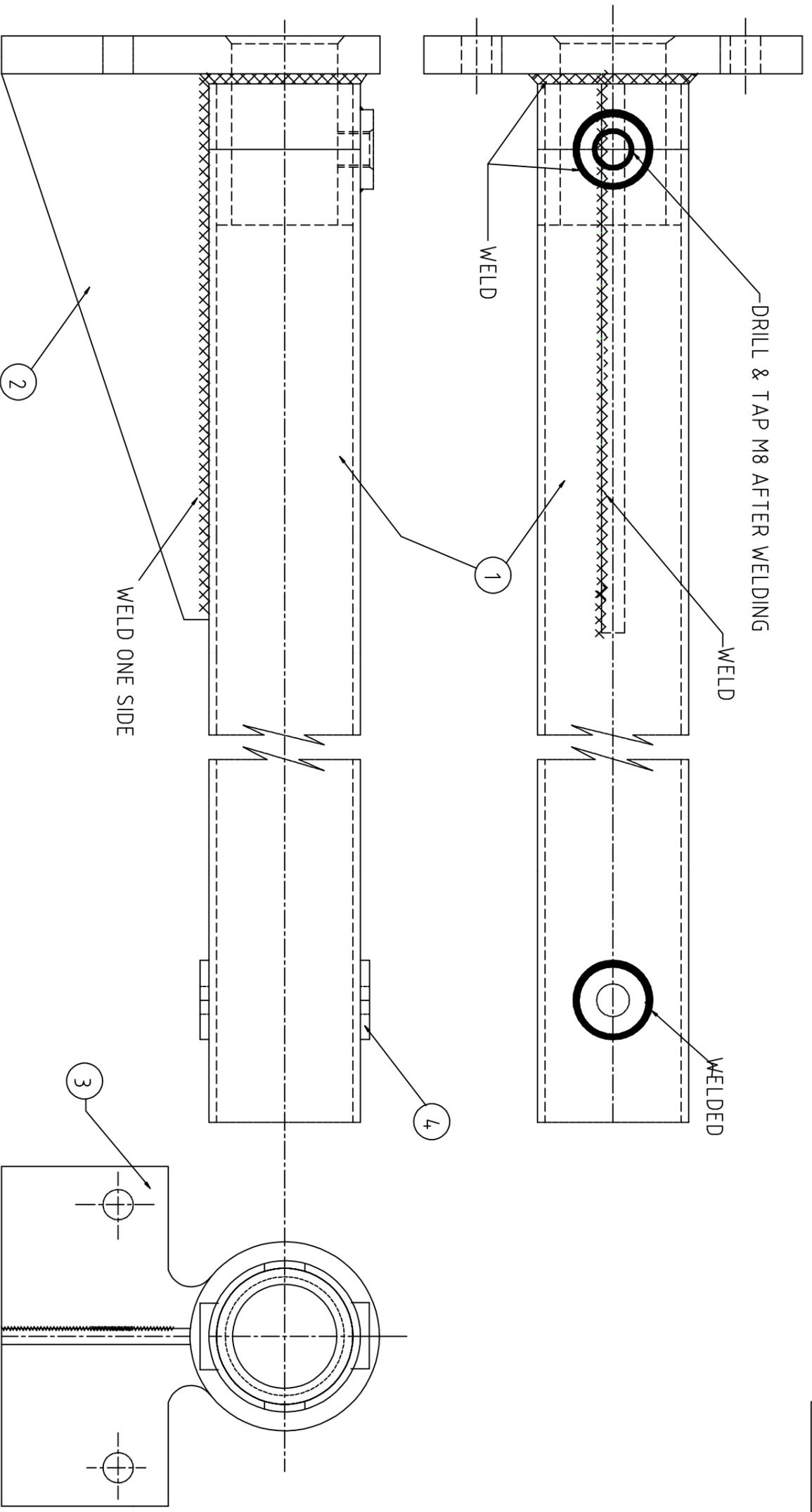
PROCESS :- MACHINING

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.		
TOLERANCE:- IS:2102(PART1):1993MEDIUM UNLESS OTHERWISE SPECIFIED				WEDGE LOCK SUB ASSEMBLY TENSIONING DEVICE WITH PIN (H D SYSTEM FOR AN-32 A/C)			APPROVED		
MATERIAL:- STEEL ALLOY 709M40/817M40, AS PER BS:970 (EN19/EN24)							GROUP DIR.		
FINISH:- AS PER SHEET No.24.							DRG. NO. ADRDE/1408- 01- 04		
HEAT TREATMENT:- HARDENED AND TEMPERED 32±5 HRC									



NOTE:-ROUND OFF ALL SHARP CORNERS TO RADIUS 0.2 mm  
 PROCESS :- MACHINING

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 A G R A	DRN.	SK SHARMA		
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA	PROJ.OFFR./GP.OFFR	
TOLERANCE:-IS:2102(PART1) :1993 MEDIUM UNLESS OTHERWISE SPECIFIED				PIN LOCK SUB ASSEMBLY TENSIONING DEVICE WITH PIN (H D SYSTEM FOR AN-32 A/C)			PROJ.DIR.	
MATERIAL:- STEEL ALLOY 709M40/817M40, AS PER BS:970 (EN19/EN24)							APPROVED	
FINISH:- AS PER SHEET No.24							GROUP DIR.	
HEAT TREATMENT:- HARDENED AND TEMPERED 32±5 HRC							DRG. NO. ADRDE/1408- 01- 05	



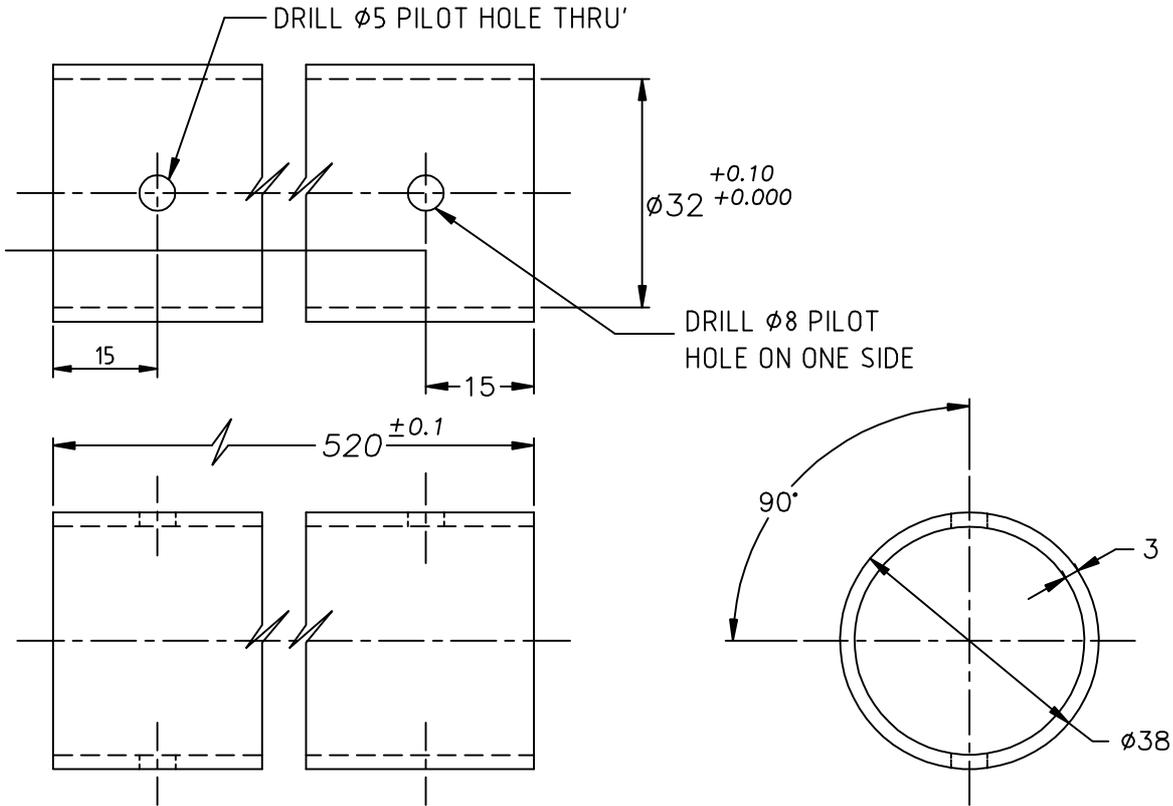
ITEM LIST

ITEM NO.	DRG. / SPECN. NO.	NOMENCLATURE	QTY	SHEET No.
4	ADRDE/1408-02-04	SADDLE WASHER	3	12
3	ADRDE/1408-02-03	COUPLING	1	11
2	ADRDE/1408-02-02	RIB	1	10
1	ADRDE/1408-02-01	PIPE	1	9

WELDING :-  
 ALL WELDED JOINTS ARE TO BE WELDED WITH ALLOY STEEL ELECTRODE  
 GRADE E68BM2-29Fe TO IS:1395 OR TENACITO-75 OF ADVANI OERLIKON  
 OR MODI-110 OR EQUIVALENT. ALL WELDED JOINTS SHOULD BE TESTED  
 BY DPT AS PER IS:3658 BEFORE FINISH.  
 MANUFACTURING PROCESS :- MACHINING/FABRICATION

Ref. NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O I/C D&S	HEAD D.A.	FINISH:- AS PER SHEET No. 24	HEAT TREATMENT:-	SCALE:- NTS	QTY :- 1 No.	DIMENSIONS IN mm	TOL:- MEDIUM UNLESS OTHERWISE SPECIFIED	MATERIAL:	GROUP:- HDS	DRN.	SK SHARMA	PROJ OFFR./GP OFFR	APPROVED	PROJ DIR.	DRG. NO. ADRDE/1408-02	GROUP DIR.	
1																						

PIPE SUB ASSEMBLY  
 TENSIONING DEVICE WITH PIN  
 ( HD SYSTEM FOR AN-32 A/C)



NOTE:- ROUND OFF ALL SHARP CORNERS TO RADIUS 0.2 mm

PROCESS :- FABRICATION/MACHINING

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				
TOLERANCE:- UNLESS OTHERWISE SPECIFIED IS:2102(PART-I) :1993 VERY COARSE				PIPE PIPE SUB ASSEMBLY TENSIONING DEVICE WITH PIN  (H D SYSTEM FOR AN-32 A/C)			PROJ.DIR.		
MATERIAL:- ERW PIPE (SEAMLESS PIPE) IS:1161-1968							APPROVED		
FINISH:- AS PER SHEET No.24							GROUP DIR.		
HEAT TREATMENT:-							DRG. NO. ADRDE/1408- 02 -01		
