

MATERIAL:- ALLOY STEEL Q80M36 (EN-8) OR 709M40 (EN-19) TO SPECIFICATION BS-970
HARDNESS:- 200-300 BHN
PROOF LOAD:- 1275 N (125 kgf)
WORKMANSHIP:-
 1. JOINT SHALL BE SOUNDLY WELDED AND FINISHED SMOOTHLY.
 2. THE FINISHED COMPONENT SHALL BE FREE FROM PITS, CRACKS, TOOL MARKS AND ANY OTHER SURFACE DEFECTS.
FINISH:- CADMIUM PLATED TO A AVERAGE THICKNESS OF 0.013 MM AND CHROMATE PASSIVATED TO SPECIFICATION IS: 1572-1986 GRADE 3 AND CLASSIFICATION Fe/Cd-12 CA.
TOLERANCE:- IS: 2102 (PART) 1980 COARSE EXCEPT WHERE OTHERWISE SPECIFIED

PACKING:- EACH BUCKLE ALONG WITH A LABEL SHOWING NOMENCLATURE AND PART No. OF THE STORE SHALL BE PACKED AND SEALED IN A POLYETHYLENE BAG OF SUITABLE SIZE AND 50 SUCH BAGS SHALL BE PACKED IN A CARTON (DULY LINED WITH WATER-PROOF PAPER) EACH CARTON SHALL INDELIBLY MARKED WITH ADDRESS OF CONSIGNEE, CONSIGNER, NOMENCLATURE AND DESCRIPTION OF STORE, YEAR OF MANUFACTURE AND NUMBER OF INDIVIDUAL BUCKLE IN THE CARTON.

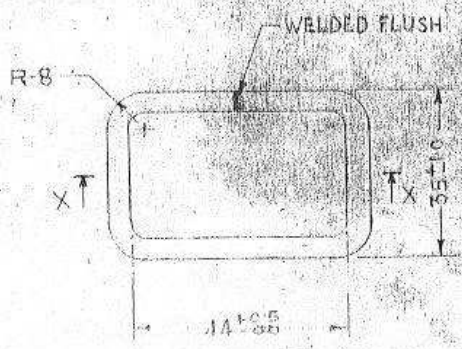
2	BAR	1	3
1	BUCKLE	1	2
-	ASSEMBLY	-	1
DETAIL No.	NOMENCLATURE	No. OF	SHEET No.

DETAIL INDEX

Re. No.	DATE	AUTHORITY	BRIEF RECORD	ZONE CD	DRG. O
					PROJ. OFF. @
DRN. No.	CHD. No.	TRD. No.	COMP.	DRG. O/A	PROJ. OFF. @
				PASSED	PH
SCALE: 1:1			O/C DES. OFF. APPROVED		
DIMENSIONS ARE IN MM			HEAD. G		
			DESIGN AUTHORITY		
			ADRDE, AGRA		
			DRG. No.		
			ADRDE/1430		
			SHEET 1 OF 3		

BUCKLE WITH BAR (PACK COVER FOR AUX. PARACHUTE)
 (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)

(1)



SECTION - XX

BUCKLE

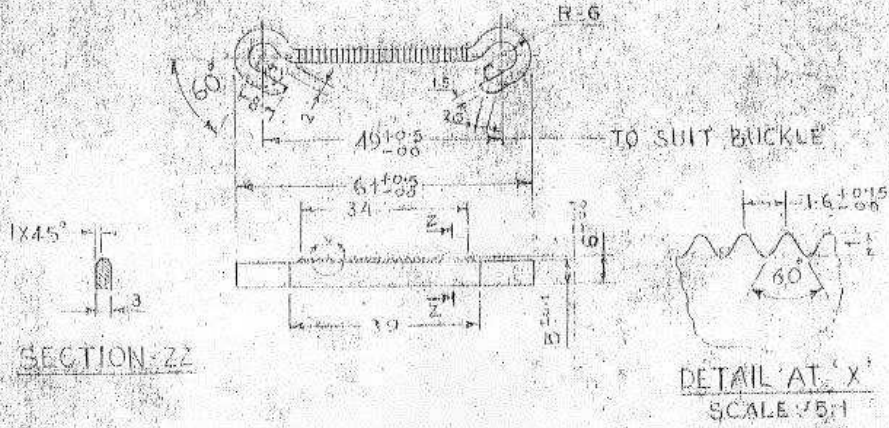
1- OFF

MANUFACTURING PROCESS: FORGING

R No.	DATE	AUTHORITY	BRIEF RECORD	ZONE / CD	DRG O/C B
			DRM: RAJIV KUMAR TRD	CHD: ANSHU COMP	DRG O/C: [Signature] PASSED
					o/c: D. G. [Signature] etc.
			SCALE: 1:1	APPROVED: [Signature] HEAD (G.P.)	

A BUCKLE WITH BAR (BACK COVER FOR AUX. P. CHUTE)
(HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)

DESIGN AUTHORITY
ADRDE, AGRA
DRG No.
ADRDE/1430-01
SHEET 2 OF 3



BAR
1- OFF

PROCESS - MACHINING

R No	DATE	AUTHORITY	BRIEF	RECORD	ZONE	CD	DRG O/C
DRN			RAVIA	CHD	DRG O/C	PROJ OFF	
TRD			COMP	PASSED			
SCALE: 1:1			0% D&S		APPROVED		
DIMENSIONS ARE IN mm					HEAD QA		

DESIGN AUTHORITY
ADRDE, AGRA

A BUCKLE WITH BAR (PACK COVER FOR AUX. P. CHUTE)
(HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)

DRG. No.
ADRDE/1430.02
SHEET 3 OF 3