

MANUFACTURING PROCESS :-  
 MATERIAL :-

GENERAL ENGG. METHOD FORGING  
 EN-24/ ERW PIPE 40/32 mm NOMINAL DIA  
 DIA MEDIUM CLASS AS PER IS:11161-1998

PLATING :-  
 FINISH :-

TO BE FINISH SMOOTH CADMIUM PLATING 0.013 mm ( MIN.)  
 FIRST PUT THE RED OXIDE PRIMER AS SPECIFIED IN IS : 2074-1979 THEN  
 TWO COATS READY MIX PAINT SPRAYING AS PER IS : 5-1994 D.G.COLDUR

PACKING NOTE:-

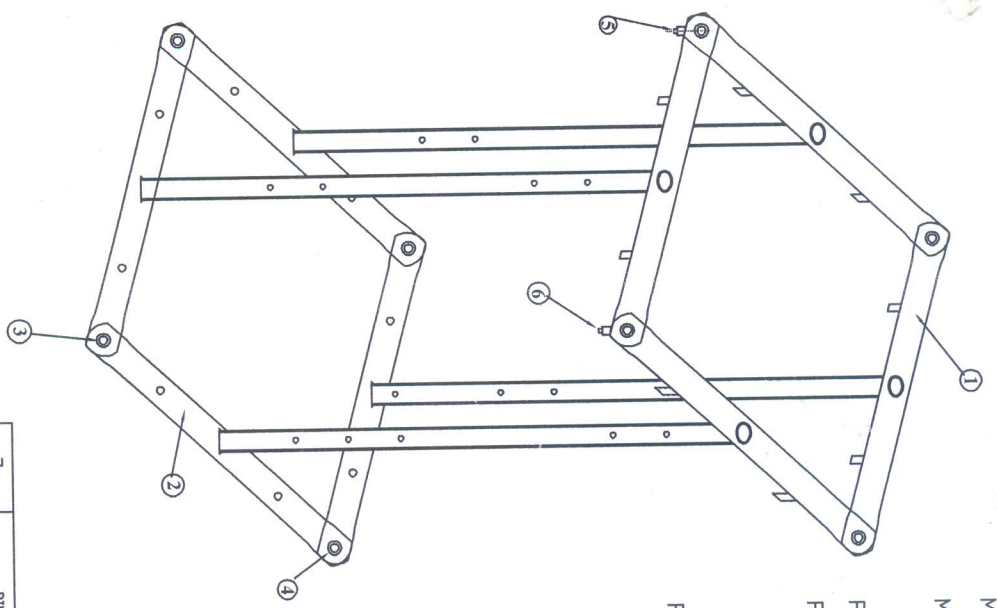
1. EACH SECTION OF UNIVERSAL SHALL BE WRAPPED IN TISSUE PAPER  
 4 NO. THUS WRAPPED BE PACKED IN A SUITABLE IN A EACH  
 CARTON SHALL THAN BE IDENTIFIED BY A LABEL CAT NO. DESIGNATION  
 OF THE OF THE MANUFACTURER , EACH CARTON INITIAL OF THE  
 MANUFACTURER THE PACKING WITH THE NAME OF ITEM ADDRESS OF  
 THE CONSIGNEE CAT NO. DESIGNATION OF STORE , YEAR OF  
 MANUFACTURE , THE INDIVIDUAL PACKS.  
 2. ONE SET PACKED IS A CCBC/ WOODEN BOX OF  
 SUITABLE SIZE

NOTE:-

1. JOINT SHALL BE SOUNDLY WELDED & FINISH SMOOTHLY .
2. THE FINISH COMPONENT SHALL BE FREE FROM PITS, CREAKS,  
 TODL MARKS, OTHER SURFACE DEFECT AND ALL EDGE SHOULD BE ROUNDED

WELDING:-

ALL WELDING JOINTS SHOULD BE WELDED BY ELECTRODE CONFORING  
 TO ADVANI DERLIKON SUPERCITD AWS/SFAS1.E7018  
 ISEB 5426 H3 IX DR ITS EQUIVALENT WELDED JOINTS SHOULD  
 BE TESTED BY DYE PENITRATION TEST (IS:3658) BEFORE FINISH.  
 FIRST PUT THE ROD OXIDE PRIMER AS PER IS:2074-1974  
 THEN TWO COATS READY MIX PAINT SPRAYING AS PER IS:- 5-1994 D.G. COLOUR

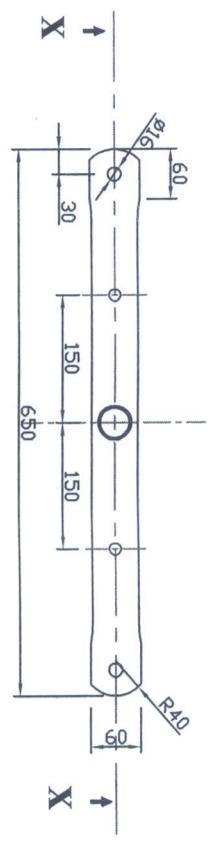


|         |                |         |
|---------|----------------|---------|
| 7       | PIN            | 2       |
| 6       | HEXAGONAL BOLT | 8       |
| 5       | HEXAGONAL NUT  | 8       |
| 4       | WASHER         | 8       |
| 3       | INNER PART     | 4       |
| 2       | OUTER PART     | 4       |
| 1       | ASSEMBLY       | 1       |
| SL. No. | NOMENCLATURE   | NO. DFF |

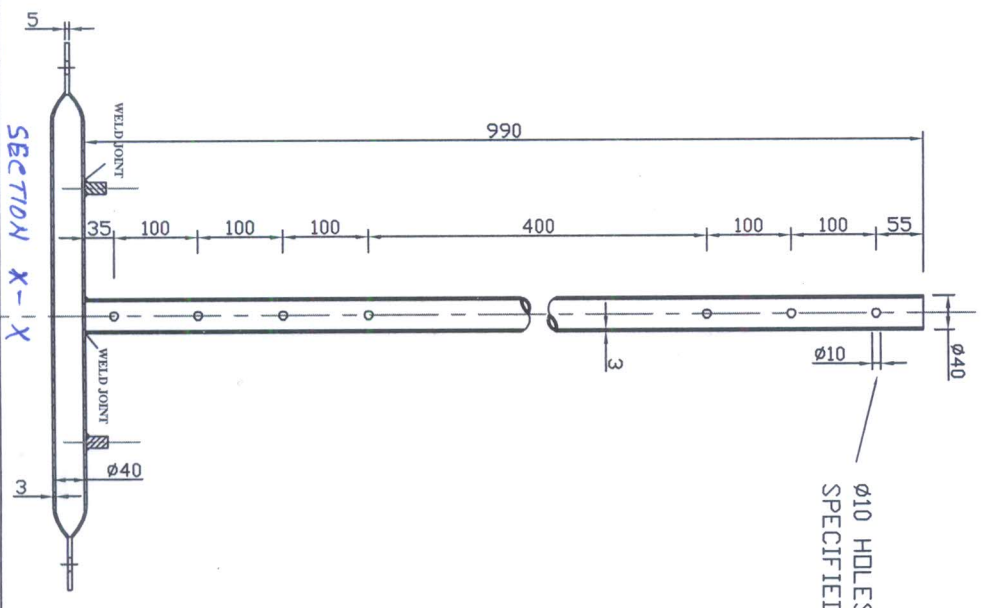
DETAIL INDEX

|                  |                     |                        |      |      |  |                                 |
|------------------|---------------------|------------------------|------|------|--|---------------------------------|
| SCALE:-          | NTS                 | A D R I D E            | AGRA | DRN. |  | PROJ. OFFICER/<br>GROUP OFFICER |
| DIMENSIONS IN mm |                     | GROUP-                 | ABS  | CHD. |  | APPROVED                        |
| TOL:-            | ANSI/AIAA-8-17-2000 | SECTION MULTI PURPOSE  |      |      |  | DRG. No.                        |
| MATERIAL:-       | BS-970              | PACKING FRAME          |      |      |  | ADPDE/16.01.04.26               |
| FINISH:-         |                     | HEAVY DRDP PARACHUTE   |      |      |  |                                 |
| HEAT TREATMENT:- | 40±3HRC             | P-7SYSTEM FOR IL-76A/C |      |      |  |                                 |

|         |      |      |           |              |                       |
|---------|------|------|-----------|--------------|-----------------------|
| Rev.No. | DATE | ZONE | AUTHORITY | BRIEF RECORD | I/C HEAD<br>CAD GROUP |
| 1       |      |      | 2         | 3            | 4                     |
|         |      |      |           |              | 5                     |
|         |      |      |           |              | 6                     |
|         |      |      |           |              | 7                     |
|         |      |      |           |              | 8                     |

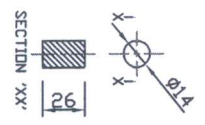


Ø10 HOLES AS PER SPECIFIED DISTANCE



SECTION X-X

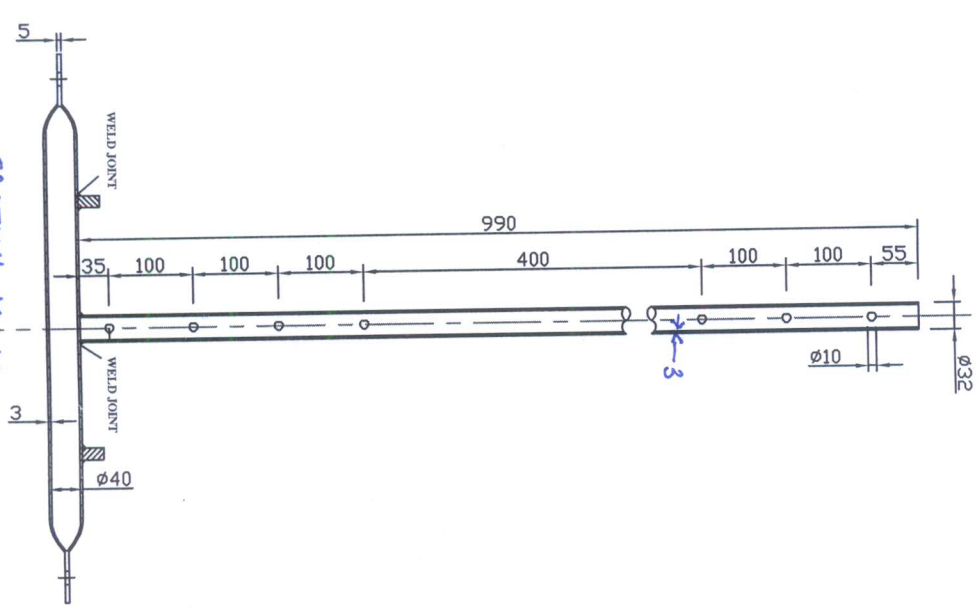
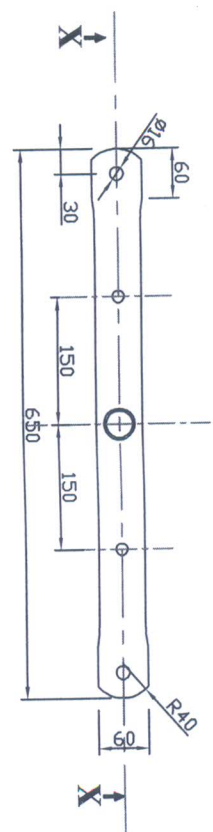
4-0FF



SECTION XX

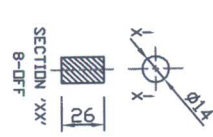
|                              |      |                      |           |              |                          |                |       |                                  |                                  |
|------------------------------|------|----------------------|-----------|--------------|--------------------------|----------------|-------|----------------------------------|----------------------------------|
| Rev.No.                      | DATE | ZONE                 | AUTHORITY | BRIEF RECORD | I/C HEAD                 | HEAT TREATMENT | GROUP | DRG. No.                         | PROD.DIRECTOR/<br>GROUP DIRECTOR |
| 1                            |      |                      |           |              | CAD                      | 40±3HRC        |       | ADRDE/1.6.01.04.26               |                                  |
| SCALE-- NTS                  |      | A D R D E A G R A    |           | DRN.         | GROUP-- ABS              |                | CHD.  | APPROVED                         |                                  |
| DIMENSIONS IN mm             |      | GROUP-- ABS          |           | CHD.         | MATERIAL--               |                |       | PROD.OFFICER/<br>GROUP OFFICER   |                                  |
| TOL.-- AS PER IS:2102 PART-1 |      | MATERIAL--           |           |              | FINISH--                 |                |       | PROD.DIRECTOR/<br>GROUP DIRECTOR |                                  |
|                              |      | BS-970               |           |              | HEAT TREATMENT--         |                |       | PROD.DIRECTOR/<br>GROUP DIRECTOR |                                  |
|                              |      | 40±3HRC              |           |              | SECTION OF UNIVERSAL     |                |       | PROD.DIRECTOR/<br>GROUP DIRECTOR |                                  |
|                              |      | HEAVY DROP PARACHUTE |           |              | KP-7SYSTEM-FDR IL-76 A/C |                |       | PROD.DIRECTOR/<br>GROUP DIRECTOR |                                  |

*(Signature)*



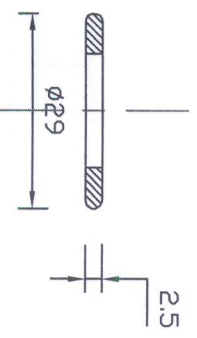
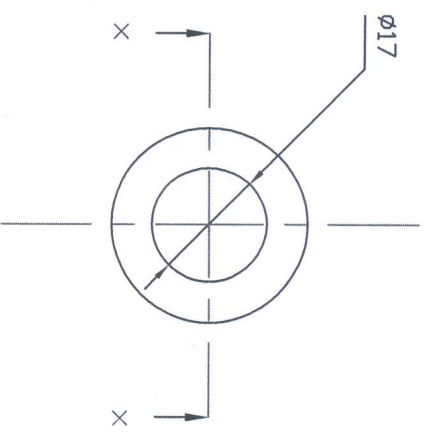
4 - DFF

SECTION X-X



|                              |                          |      |                                  |
|------------------------------|--------------------------|------|----------------------------------|
| SCALE-- NTS                  | A D R D E AGRA           |      | APPROVED                         |
| DIMENSIONS IN mm             | GROUP-- ABS              | DRN. |                                  |
| TOL.-- AS PER IS:2102 PART-1 | INNER PART BASE          |      | PROD. OFFICER/<br>GROUP DIRECTOR |
| MATERIAL-- BS-970            | SECTION OF UNIVERSWAL    |      |                                  |
| FINISH--                     | HEAVY DRDP PARACHUTE     |      | DRG. No.<br>ADRDE/15.01.04.26    |
| HEAT TREATMENT-- 40±3HRC     | (P-7)SYSTEM-FDR IL-76A/C |      |                                  |

|         |      |      |           |              |              |               |
|---------|------|------|-----------|--------------|--------------|---------------|
| Rev.No. | DATE | ZONE | AUTHORITY | BRIEF RECORD | D I/C<br>CAD | HEAD<br>GROUP |
| 1       |      |      | 2         | 3            | 4            | 5             |



**SECTION XX**

8-DFF

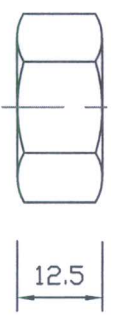
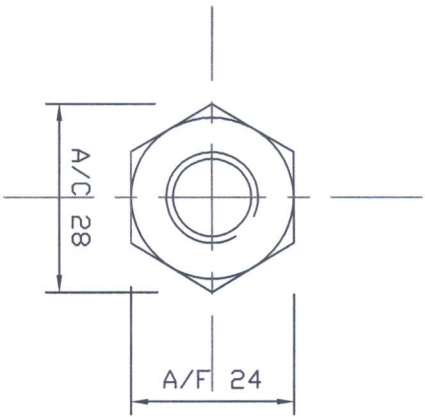
|         |      |      |           |              |              |               |
|---------|------|------|-----------|--------------|--------------|---------------|
| Rev.No. | DATE | ZONE | AUTHORITY | BRIEF RECORD | D T/C<br>CAD | HEAD<br>GROUP |
| 1       |      |      | 2         | 3            | 4            | 5             |

|                            |         |
|----------------------------|---------|
| SCALE--                    | NTS     |
| DIMENSIONS IN mm           |         |
| TOL. AS PER IS:2102 PART-1 |         |
| MATERIAL--                 | BS-970  |
| FINISH--                   |         |
| HEAT TREATMENT--           | 40±3HRC |

|   |      |      |
|---|------|------|
| ADDRESS   | DRN. | CHD. |
| GROUP-- ABS   |      |      |
| WASHER<br>SECTION OF UNIVERSWAL<br>HEAVY DRDP PARACHUTE<br>KP-7)SYSTEM-FDR IL-76A/C |      |      |

|          |                                 |
|----------|---------------------------------|
| APPROVED | PROJ. OFFICER/<br>GROUP OFFICER |
| DRG. No. | APRDE/16.01.04.26               |

*Handwritten signature*

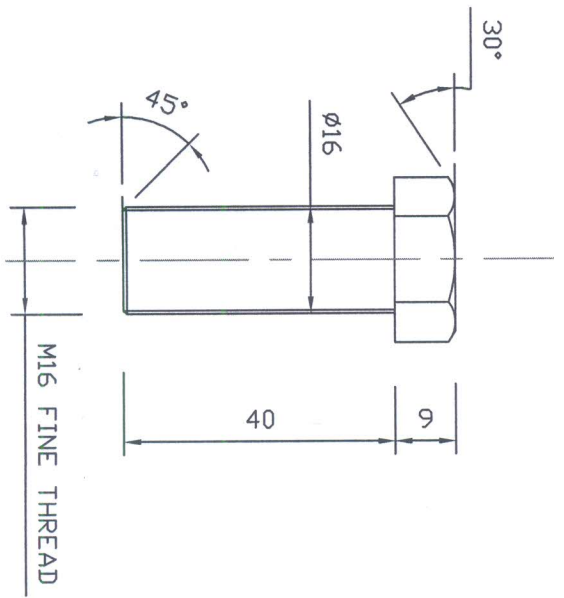
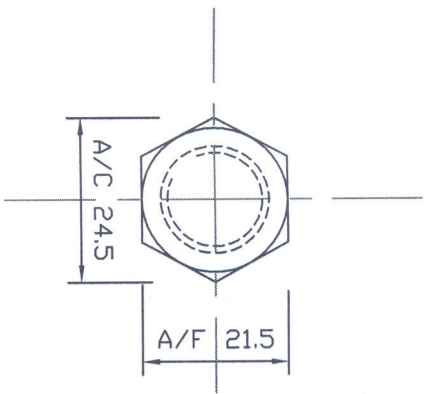


SECTION XX

8-DFF

|                             |  |      |                                 |                              |
|-----------------------------|--|------|---------------------------------|------------------------------|
| SCALE- NTS                  | A D R D E AGRA   |      | DRN.                            | APPROVED                     |
| DIMENSIONS IN mm            | GROUP- ABS   | CHD. | PRD. OFFICER/<br>GROUP DIRECTOR |                              |
| TOL.- AS PER IS:2102 PART-1 | HEXAGONAL NUT<br>SECTION OF UNIVERSWAL<br>HEAVY DRDP PARACHUTE<br>(P-7)SYSTEM-FDR IL-76A/C |      |                                 | DRG. No.<br>ADPDE/16.0104.26 |
| MATERIAL- BS-970            |  |      |                                 |                              |
| FINISH-                     |  |      |                                 |                              |
| HEAT TREATMENT- 40±3HRC     |  |      |                                 |                              |

|         |      |      |           |              |         |            |
|---------|------|------|-----------|--------------|---------|------------|
| Rev.No. | DATE | ZONE | AUTHORITY | BRIEF RECORD | I/C CAD | HEAD GROUP |
| 1       |      |      | 2         | 3            | 4       | 5          |

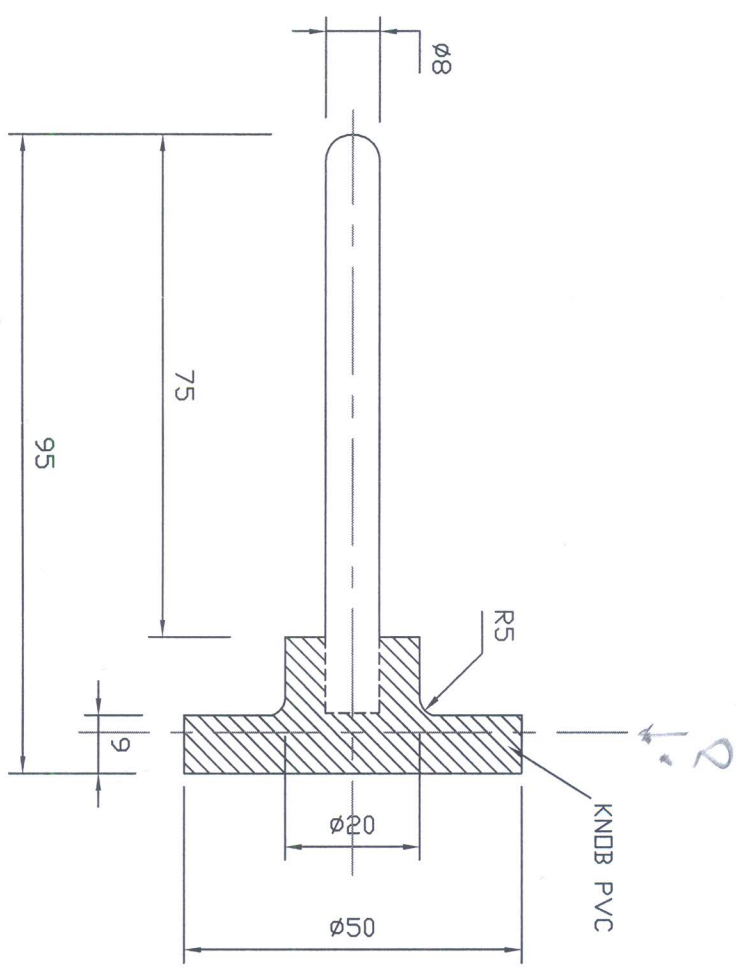


8- DFF

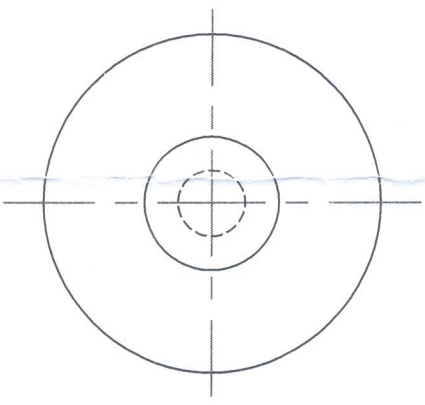
|                             |                |      |                          |  |                               |
|-----------------------------|----------------|------|--------------------------|--|-------------------------------|
| SCALE:- NTS                 | A D R D E AGRA |      | HEAT TREATMENT:- 40±3HRC | HEXAGONAL BOLT<br>SECTION OF UNIVERSWAL<br>HEAVY DROP PARACHUTE<br>P-7)SYSTEM-FDR IL-76A/C | DRG. No.<br>ADRDE/16.01.04.26 |
| DIMENSIONS IN mm            | GROUP- ABS     | DRN. |                          |  |                               |
| TOL:- AS PER IS:2102 PART-1 | CHD.           |      | APPROVED                 | PROD. DIRECTOR/<br>GROUP DIRECTOR  |                               |
| MATERIAL:- BS-970           |                |      |                          |  |                               |
| FINISH:-                    |                |      |                          |  |                               |

|         |      |      |           |              |           |            |
|---------|------|------|-----------|--------------|-----------|------------|
| Rev.No. | DATE | ZONE | AUTHORITY | BRIEF RECORD | D T/C CAD | HEAD GROUP |
| 1       |      |      |           |              |           |            |

|    |    |    |    |
|----|----|----|----|
| 5. | 6. | 7. | 8. |
|----|----|----|----|



PIN MAT. - M.S. (EN-8)  
KNDB - P.V.C.



2- DFF

|         |      |      |           |              |              |               |   |               |                                 |
|---------|------|------|-----------|--------------|--------------|---------------|---|---------------|---------------------------------|
| Rev.No. | DATE | ZONE | AUTHORITY | BRIEF RECORD | D I/C<br>CAD | HEAD<br>GROUP | SECTION OF UNIVERSWAL<br>HEAVY DRDP PARACHUTE<br>(P-7)SYSTEM-FDR IL-76A/C |               | DRG. No.<br>ADRD/16.01.04.26    |
| 1       |      |      |           |              |              |               | SCALE:- NTS   | AD R D E AGRA | PROJ. OFFICER/<br>GROUP OFFICER |
|         |      |      |           |              |              |               | DIMENSIONS IN mm  | GROUP- ABS    | CHD.                            |
|         |      |      |           |              |              |               | TOL.- AS PER IS:2102 PART-1   |               |                                 |
|         |      |      |           |              |              |               | MATERIAL--  |               |                                 |
|         |      |      |           |              |              |               | BS-970  |               |                                 |
|         |      |      |           |              |              |               | FINISH--  |               |                                 |
|         |      |      |           |              |              |               | HEAT TREATMENT--  |               |                                 |
|         |      |      |           |              |              |               | 40±3HRC   |               |                                 |