

MARKING PLACE FOR MANUFACTURER
S No. / PART No. / YEAR OF
MANUFACTURE

PUSH FIT IN PIPE

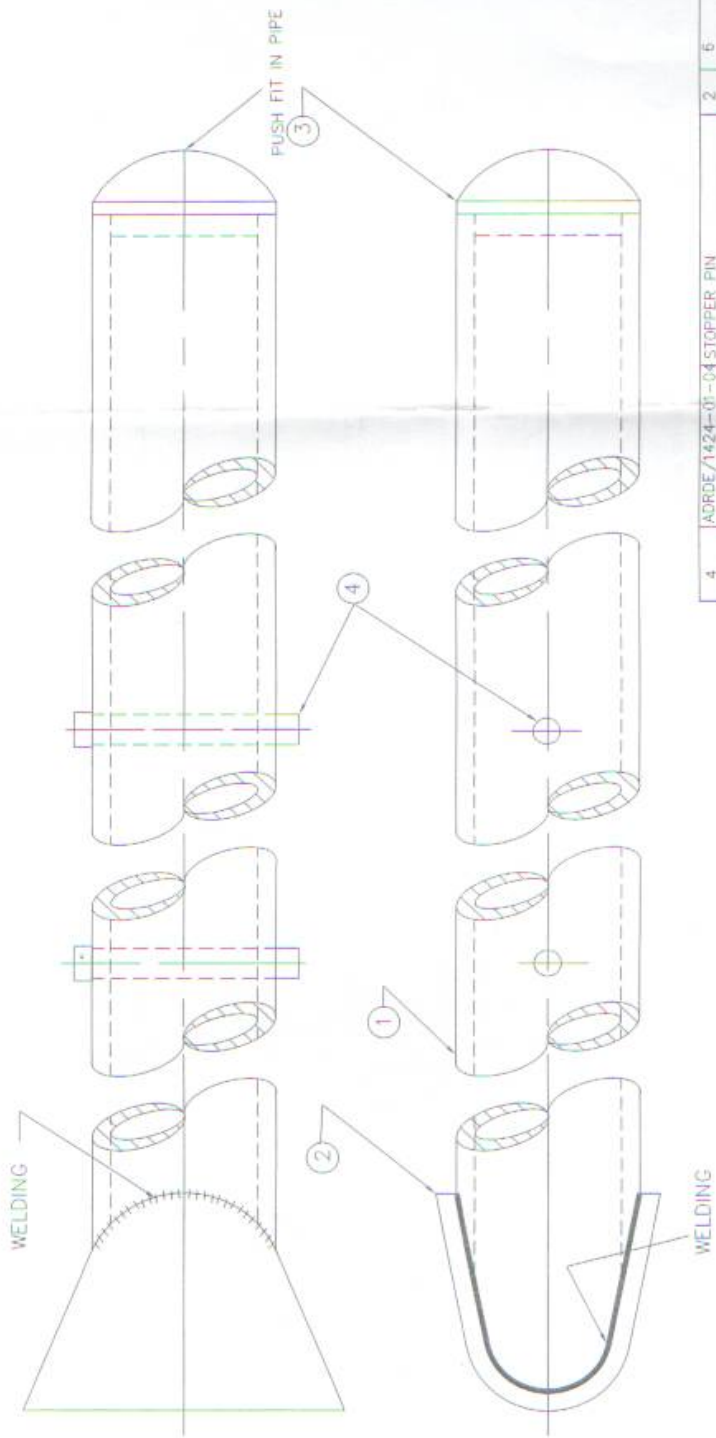
THIS PIN (DRG.No.1424-01-04) TO BE PUSH FIT
AFTER PLACING BELT SUB. ASSY.(DRG No.1424-02)
IN POSITION

WORKMANSHIP: - 1-JOINTS SHALL BE SOUNDLY WELDED & FINISH SMOOTHLY.
2-THE FINISHED COMPONENT SHALL BE FREE FROM PITS,CRACKS TOOL MARKS & OTHER
SURFACE DEFECTS.

ITEM NO.	DRG./SPECN. NO.	NOMENCLATURE	QTY	SHEET NO.
3	ADRDE/ 1424-03	BUCKLE SUB ASSEMBLY	1	10-12
2	ADRDE/ 1424-02	BELT SUB ASSEMBLY	1	7-10
1	ADRDE/ 1424-01	PIPE SUB ASSEMBLY	1	2-6
-	ADRDE/ 1424	ASSEMBLY	1	1

ITEM LIST

SCALE: - NTS	QTY :- 1	ADRDE AGR	DRN.	C.F.PAL
DIMENSIONS IN mm		GROUP - HDS	CHD	HROTI
TOL. :-		ASSEMBLY DEVICE FOR TIGHTENING BELT HEAVY DROP PARACHUTE (P-7, PLATFORM) SYSTEM FOR IL-76 AIRCRAFT		
MATERIAL :-	AS IN DRAWINGS	APPROVED		
FINISH :-	AS IN DRAWINGS	PROLOFFR./GP OFFR		
HEAT TREATMENT :-	AS IN DRAWINGS	DRG. NO. :-		
		ADRDE/1.6.01.04-25 (PROV.)		
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD



ITEM NO.	DRG./SPECN NO.	NOMENCLATURE	QTY	SHEET No.
4	ADRDE/1424-01-04	STOPPER PIN	2	6
3	ADRDE/1424-01-03	CAP	1	5
2	ADRDE/1424-01-02	BASE	1	4
1	ADRDE/1424-01-01	PIPE	1	3
-	ADRDE/1424-01	PIPE SUB-ASSEMBLY	1	2

ITEM LIST

FINISH :- FIRST PUT THE RED OXIDE PRIMER AS SPECIFIED IN IS : 2074-1979 THEN TWO COATS READY MIX PAINT SPRAYING AS PER IS : 5-1994 O.G.COLOR

WORKMANSHIP: - 1-JOINTS SHALL BE SOUNDLY WELDED & FINISH SMOOTHLY.
 2-THE FINISHED COMPONENT SHALL BE FREE FROM PITS,CRACKS TOOL MARKS & OTHER SURFACE DEFECTS

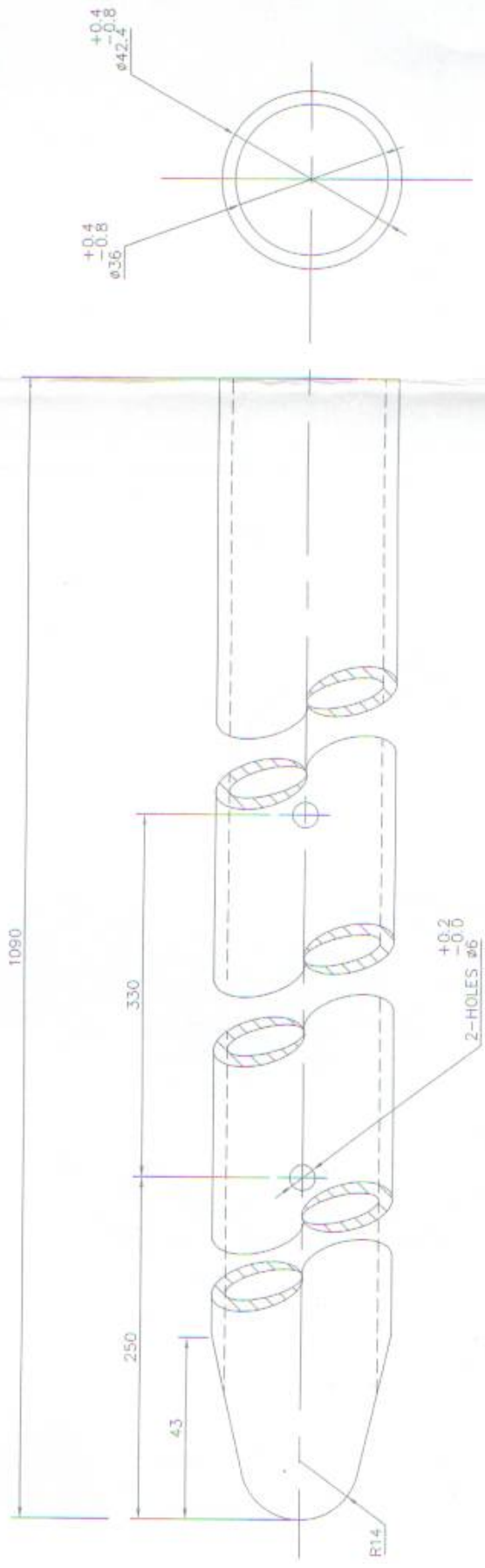
TOLERANCE :- AS PER IS:2102 (PART-1) 1993; MEDIUM UNLESS OTHERWISE SPECIFIED

WELDING : ALL WELDED JOINTS SHOULD BE WELDED BY ELECTRODE CONFORMING TO ADVANI OERLIKON SUPERGITO AWS/SFA 5.1-E7018 ISEB 5426 H3 JX OR ITS EQUIVALENT. WELDED JOINTS SHOULD BE TESTED BY DYE PENETRATION TEST (IS : 3658) BEFORE FINISH.

PROCESS: -FABRICATION

Sl. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	0 I/C CAD GROUP	HEAD GROUP
1						
2						
3						
4						

SCALE: -1:1	A D R D E AGRA	DRN.	C P PAL
DIMENSIONS IN mm	GROUP--HDS	CHG.	NR01
TOL-- AS ABOVE	PIPE SUB-ASSEMBLY		
MATERIAL--	DEVICE FOR TIGHTENING BELT		
FINISH-- AS ABOVE	HEAVY DROP PARACHUTE (P+7, PLATFORM) SYSTEM		
HEAT TREATMENT--	FOR IL-76 AIRCRAFT		
	APPROVED		
	PROJ.DWG./OP.DWTR		
	DRG. No.		
	ADRDE/1.6.01.04-25 (PROV.)		



MATERIAL: - ERW PIPE 32 mm NOMINAL DIA. MEDIUM CLASS AS PER IS:1161-1998

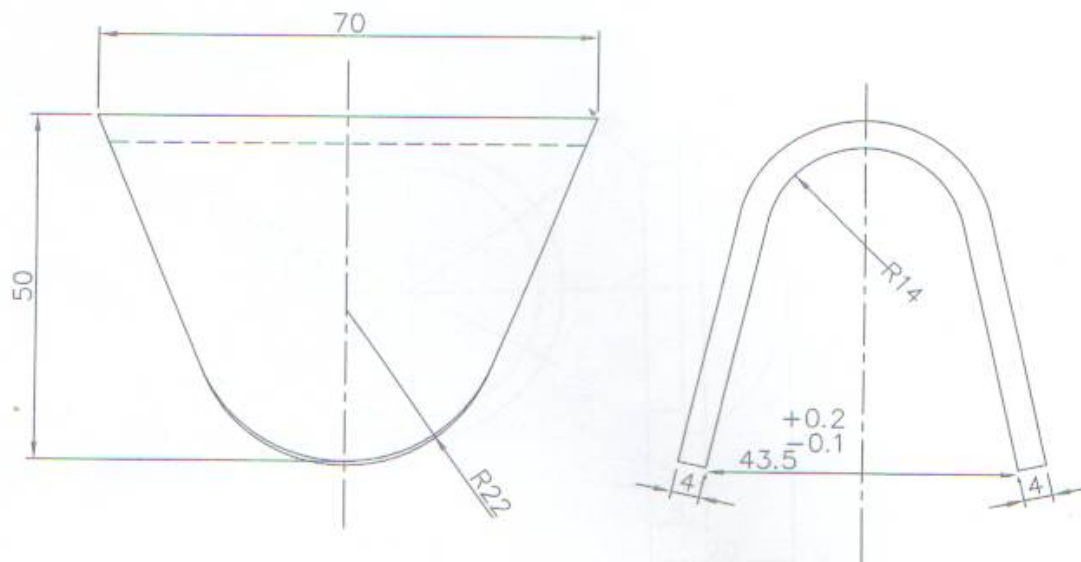
FINISH: - FIRST PUT THE RED OXIDE PRIMER AS SPECIFIED IN IS : 2074-1979 THEN TWO COATS READY MIX PAINT SPRAYING AS PER IS : 5-1994 O.G. COLOR

WORKMANSHIP: - 1-JOINTS SHALL BE SOUNDLY WELDED & FINISH SMOOTHLY.
 2-THE FINISHED COMPONENT SHALL BE FREE FROM PITS, CRACKS TOOL MARKS & OTHER SURFACE DEFECTS



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

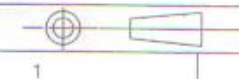
PROCESS: - MACHINING

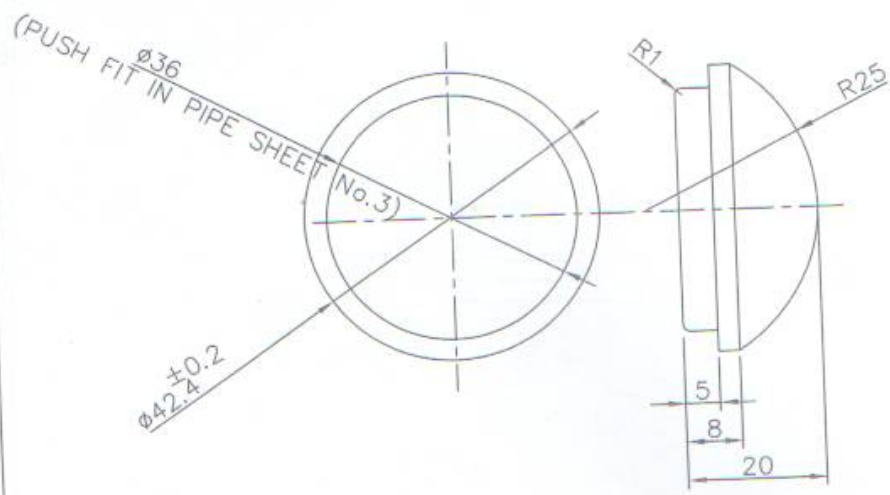
SCALE: - 1:1	QTY: - 1	A. D. R. D. E. AGRA	DRNL.	C.P.PAL
DIMENSIONS IN mm		GROUP: - HDS	CHD.	NIROTI
TOL: - AS ABOVE		PIPE		
MATERIAL: - AS ABOVE		DEVICE FOR		
FINISH: - AS ABOVE		TIGHTENING BELT		
HEAT TREATMENT: -		HEAVY DROP PARACHUTE		
		(P-7, PLATFORM)		
		SYSTEM		
		FOR II -76 AIRCRAFT		
DATE	ZONE	AUTHORITY	APPROVED	
			PROJ.DR/OP.DR	
			DRG. NO.:-	
			PROJ.DR/OP.DR	



FINISH :- FIRST PUT THE RED OXIDE PRIMER AS SPECIFIED IN IS : 2074-1979 THEN TWO COATS READY MIX PAINT SPRAYING AS PER IS : 5-1994 O.G. COLOR
 PROCESS :- FABRICATION

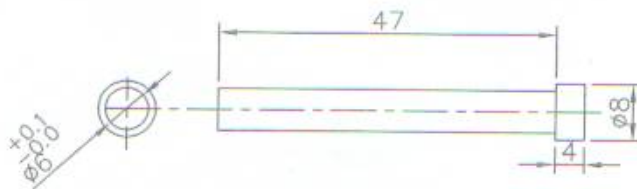
Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I / C CAD	HEAD GROUP
SCALE: -1:1	QTY. 1 No.		A D R D E AGRA	DRN..	C.P.PAL		 30/7/12 PRO.OFFR./GP.OFFR	
DIMENSIONS IN mm			GROUP: - HDS	CHD.	NIROTI			
TOL.: IS: 2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED			BASE DEVICE FOR TIGHTENING BELT HEAVY DROP PARACHUTE (P-7, PLATFORM) SYSTEM FOR IL-76 AIRCRAFT					
MATERIAL: - MILD STEEL AS PER IS:2062 1992						APPROVED		 PRO.DIR./GP.DIR
FINISH:- AS ABOVE			DRG. NO. ADRDE/1.6.01.04-25 (PROV.)					
HEAT TREATMENT:-								





FINISH :- FIRST PUT THE RED OXIDE PRIMER AS SPECIFIED IN IS : 2074-1979 THEN TWO COATS READY MIX PAINT SPRAYING AS PER IS : 5-1994 O.G. COLOR
 PROCESS : MACHINING

Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C CAD	HEAD GROUP
SCALE: -1:1		QTY.1No.		ADRDE AGRA	DRN..	C.P.PAL	APPROVED PRO.OFFR./GP.OFFR 30/7/12		
DIMENSIONS IN mm		TOL.: IS: 2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED		GROUP: - HDS	CHD.	NIROTI			
MATERIAL: MILD STEEL AS PER IS: 2062 1992		CAP DEVICE FOR TIGHTENING BELT HEAVY DROP PARACHUTE (P-7, PLATFORM) SYSTEM FOR IL-76 AIRCRAFT		APPROVED PRO.DIR./GP.DIR DRG. NO.		ADRDE/1.6.01.04-25 (PROV.)			
FINISH:- AS ABOVE									
HEAT TREATMENT:-									



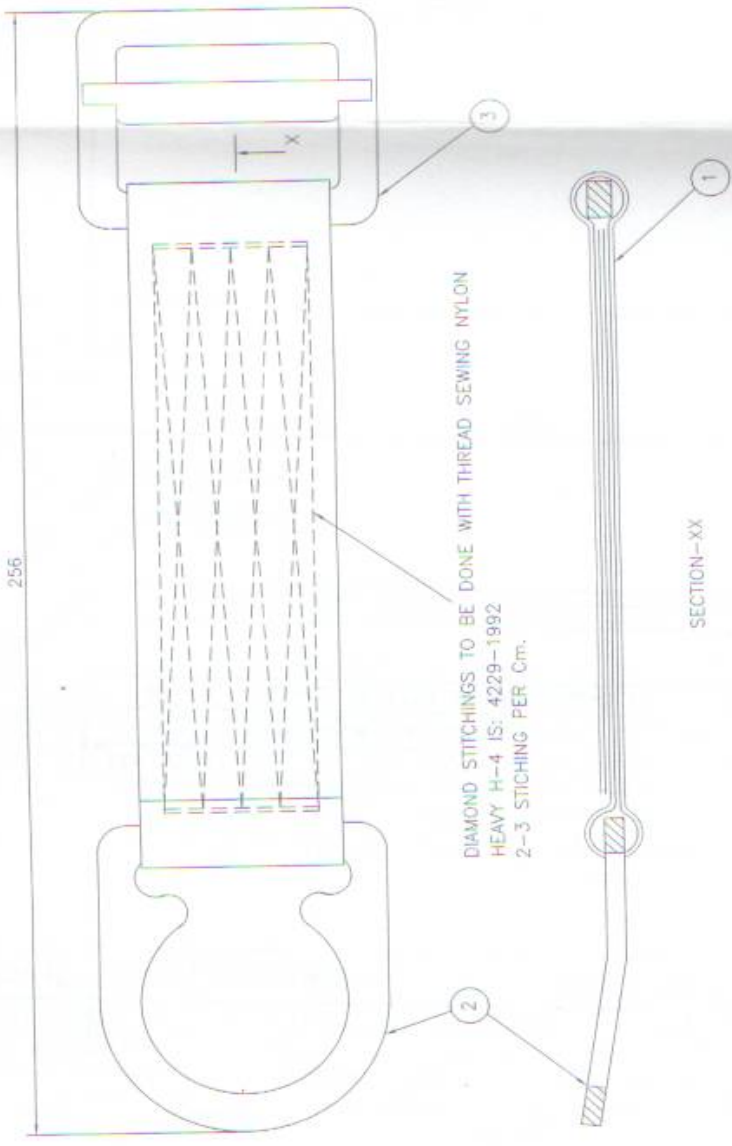
FINISH :--FIRST PUT THE RED OXIDE PRIMER AS SPECIFIED IN IS : 2074-1979 THEN
 TWO COATS READY MIX PAINT SPRAYING AS PER IS : 5-1994 O.G. COLOR
 PROCESS : MACHINING

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Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I / C CAD	HEAD GROUP
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SCALE: -1:1	QTY. 2 Nos.	A D R D E AGRA	DRN..	C.P.PAL	APPROVED 30/7/12 PRO.OFFR./GP.OFFR PRO.DIR./GP.DIR DRG. NO. ADDRDE/1.6.01.04-25 (PROV.)
DIMENSIONS IN mm		GROUP: - HDS	CHD.	NIROTI	
TOL.: IS: 2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED		STOPPER PIN DEVICE FOR TIGHTENING BELT HEAVY DROP PARACHUTE (P-7, PLATFORM) SYSTEM FOR IL-76 AIRCRAFT			
MATERIAL: - MILD STEEL AS PER IS: 2062 1992					
FINISH:-- AS ABOVE					
HEAT TREATMENT:--					

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ITEM NO.	DRG./SPECN NO.	NGMENCLATURE	QTY	SHEET No.
3	ADRDE/1424-03	BUCKLE SUB. ASSEMBLY	1	10-12
2	ADRDE/1424-02-01	CURVED BUCKLE	1	9
1	ADRDE/1424-02-01	BELT	1	8
-	ADRDE/1424-02	BELT SUB. ASSEMBLY	1	7

GENERAL TOLERANCES (ANSI/AIAA-5-017-1991)		TOL
DIMENSIONS ARE IN mm		
UP TO - 2		±1
MORE THAN - 2 BUT UPTO - 50		±2
MORE THAN - 50 BUT UPTO - 250		±3
MORE THAN - 250 BUT UPTO - 750		±6
MORE THAN - 750 BUT UPTO - 1500		±10
MORE THAN - 1500		±1%

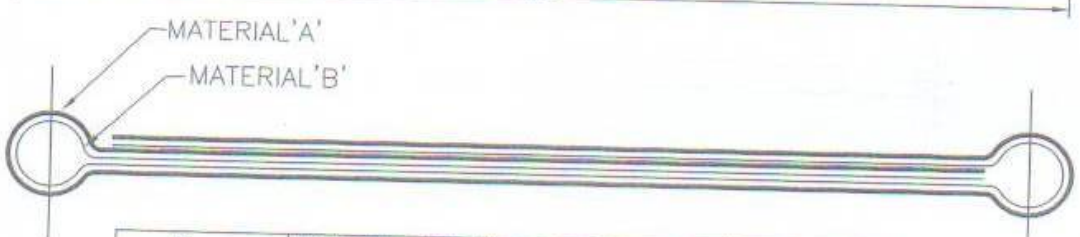
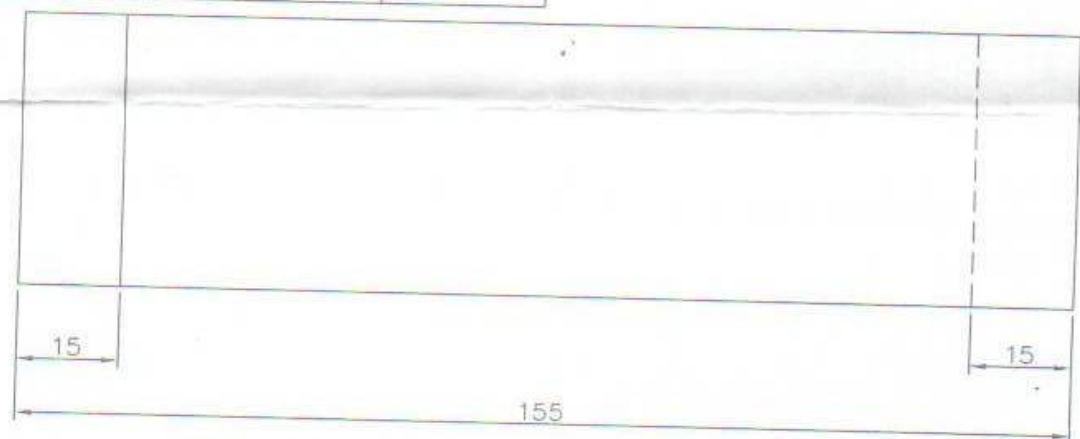
ITEM LIST

SCALE	1:1	QTY	1	DRN.	CP PAL
DIMENSIONS IN mm					
TOL	AS ABOVE				
MATERIAL					
FINISH					
HEAT TREATMENT					
GROUP - HIS				CHKD.	NIROTI
BUCKLE SUB ASSEMBLY DEVICE FOR TIGHTENING BELT HEAVY DROP PARACHUTE (P-7, PLATFORM) SYSTEM FOR IL-76 AIRCRAFT					
APPROVED					
PROJ. OFFR./OP. OFFR.					
DRG. NO.:-					
ADRDE/15.01.04-25 (PROV.)					

DATE	ZONE	AUTHORITY	BRIEF RECORD

GENERAL TOLERANCES
(ANSI/AIAA-5-017-1991)

DIMENSIONS ARE IN mm	TOL.
UP TO- 2	±1
MORE THAN-2 BUT UPTO-50	±2
MORE THAN-50 BUT UPTO-250	±3
MORE THAN-250 BUT UPTO-750	±6
MORE THAN-750 BUT UPTO-1500	±10
MORE THAN-1500	±1%

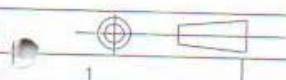


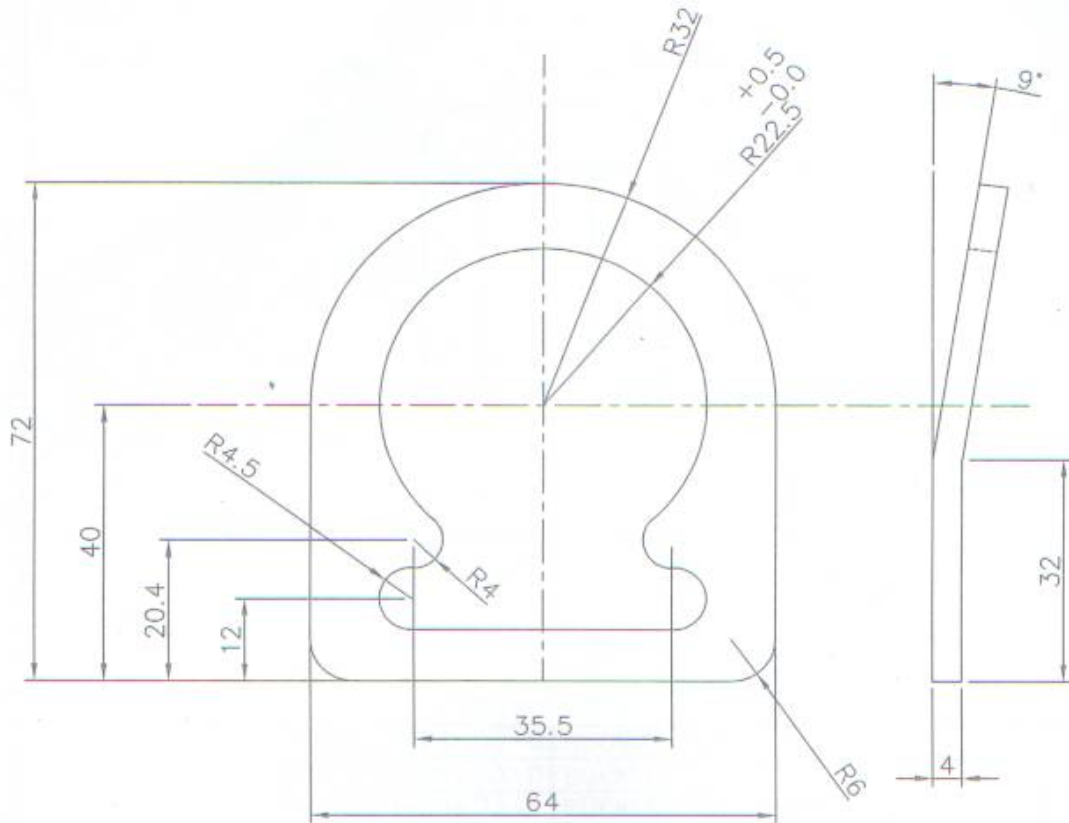
MATERIAL	NOMENCLATURE	SPECN. No
B	TAPE NYLON 43mm 9000 N	ADRDE/1985/27
A	WEBBING NYLON 44mm 17798 N	IS: 4727-1968

LIST OF MATERIAL

NOTE:- STITCHING IS TO BE DONE IN ASSEMBLY AS SHOWN IN SHEET No.7

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O/I/C (D&S)	HEAD (Q.A.)			
SCALE: -1:1	QTY.1No.	A D R D E AGRA		DRN.	C.P.PAL						
DIMENSIONS IN mm		GROUP:- HDS		CHD.	NIROTI						
TOL.: AS ABOVE		BELT DEVICE FOR TIGHTENING BELT HEAVY DROP PARACHUTE (P-7, PLATFORM) SYSTEM FOR IL-76 AIRCRAFT						 30/7/12 PRO.OFFR./GP.OFFR			
MATERIAL: - AS ABOVE								APPROVED		 PRO.DIR./GP.DIR	
FINISH:-								DRG. NO.		ADRDE/1.6.01.04-25 (PROV.)	
HEAT TREATMENT:-											

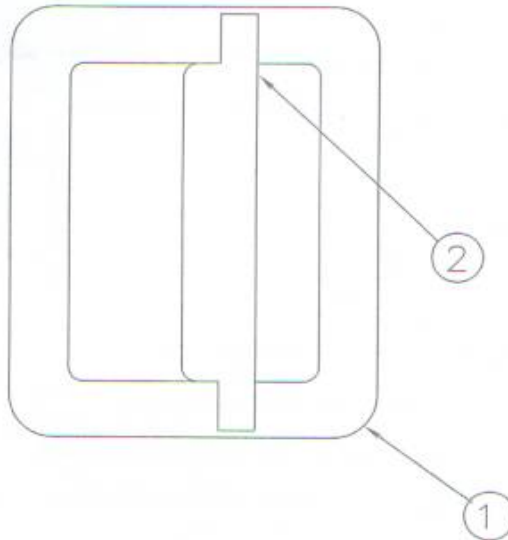




FINISH :- CADMIUM PLATING TO A AVERAGE THICKNESS OF 0.012mm AND CHROMATE PASSIVATED TO SPEC.
IS: 1572-1986 Gr.2 AND CLASSIFICATION Fe/Cd-8 CA .

PROCESS : MACHINING/FABRICATION

Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C CAD	HEAD GROUP	
SCALE:-1:1		QTY.1 No		A D R D E AGRA	DRN..	C.P.PAL				
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	NIROTI				
TOL.:IS: 2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				CURVED BUCKLE DEVICE FOR TIGHTENING BELT HEAVY DROP PARACHUTE (P-7, PLATFORM) SYSTEM FOR IL-76 AIRCRAFT			 30/7/12 PRO.OFFR./GP.OFFR			
MATERIAL: STEEL ALLOY 709M40/817M40,(EN19/EN24) AS PER BS:970							APPROVED		 PRO.DIR./GP.DIR	
FINISH :- AS ABOVE							DRG. NO.		DRDE/1.6.01.04-25 (PROV.)	
HEAT TREATMENT:- 265-352 BHN										



2	ADRDE/1424-03-02	SLIDING-BAR	1	12
1	ADRDE/1424-03-01	BUCKLE	1	11
-	ADRDE/1424-03	BUCKLE SUB. ASSEMBLY	1	10
ITEM NO.	DRG./SPECN NO.	NOMENCLATURE	QTY	SHEET No.

ITEM LIST

PROCESS : MACHINING/FABRICATION

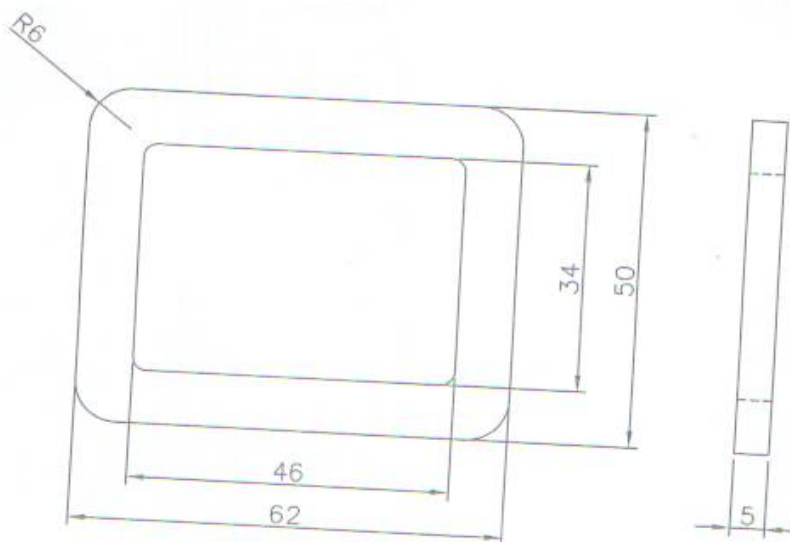
Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C CAD	HEAD GROUP
SCALE:-1:1	QTY.1 No		A D R D E AGRA	DRN..	C.P.PAL		 PRO.OFFR./GP.OFFR APPROVED PRO.DIR./GP.DIR DRG. NO. ADRDE/1.6.01.04-25 (PROV.)	
DIMENSIONS IN mm			GROUP:- HDS	CHD.	NIROTI			
TOL.: IS: 2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED			BUCKLE SUB ASSEMBLY DEVICE FOR TIGHTENING BELT HEAVY DROP PARACHUTE (P-7, PLATFORM) SYSTEM FOR IL-76 AIRCRAFT					
MATERIAL: STEEL ALLOY 709M40/817M40,(EN19/EN24) AS PER BS:970								
FINISH:- AS IN DRAWINGS								
HEAT TREATMENT:- AS IN DRAWINGS								

1

2

3

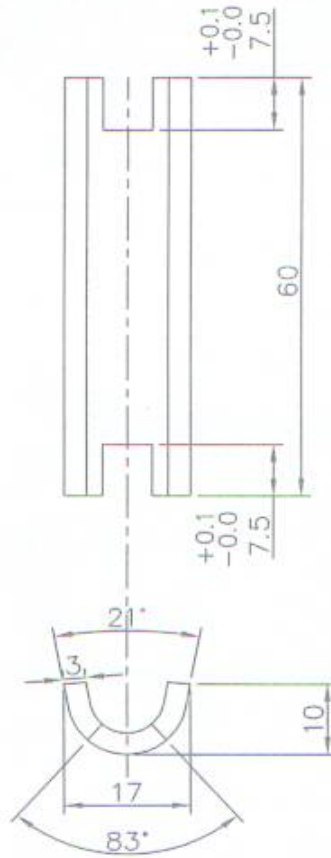
4



FINISH :- CADMIUM PLATING TO A AVERAGE THICKNESS OF 0.012mm AND CHROMATE PASSIVATED TO SPEC.
IS: 1572-1986 Gr.2 AND CLASSIFICATION Fe/Cd-8 CA

PROCESS : MACHINING/FABRICATION

SCALE: -1:1		QTY.: -1 No.		A D R D E AGRA			DRN..	C.P.PAL	O I/C	HEAD
DIMENSIONS IN mm		GROUP: - HDS		CHD.			NIROTI		CAD	GROUP
TOL.: IS: 2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED		<p align="center">BUCKLE DEVICE FOR TIGHTENING BELT HEAVY DROP PARACHUTE (P-7, PLATFORM) SYSTEM FOR IL-76 AIRCRAFT</p>		APPROVED		<p align="right"><i>[Signature]</i> 30/5/12 PRO.OFFR./GP.OFFR</p>				
MATERIAL: STEEL ALLOY 709M40/817M40,(EN19/EN24) AS PER BS:970				APPROVED		<p align="right"><i>[Signature]</i> PRO.DIR./GP.DIR</p>				
FINISH:- AS ABOVE				DRG. NO.		<p align="right">ADRDE/1.6.01.04-25 (PROV.)</p>				
HEAT TREATMENT:- 265/352 BHN										



FINISH :- CADMIUM PLATING TO A AVERAGE THICKNESS OF 0.012mm AND CHROMATE PASSIVATED TO SPEC.
 IS: 1572-1986 Gr.2 AND CLASSIFICATION Fe/Cd-8 CA

PROCESS : MACHINING/FABRICATION

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C CAD	HEAD GROUP
SCALE: -1:1	QTY.1 No	A D R D E AGRA		DRN..	C.P.PAL		 PRO.OFFR./GP.OFFR 20/7/12	
DIMENSIONS IN mm		GROUP: - HDS		CHKD.	NIROTI			
TOL.: IS: 2102(Pt-1)1993 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED			SLIDING-BAR DEVICE FOR TIGHTENING BELT HEAVY DROP PARACHUTE (P-7, PLATFORM) SYSTEM FOR IL-76 AIRCRAFT			APPROVED		
MATERIAL: STEEL ALLOY 709M40/B17M40,(EN19/EN24) AS PER BS:970						 PRO.DIR./GP.DIR		
FINISH:- AS ABOVE						DRG. NO.		
HEAT TREATMENT:- 265-352 BHN			ADRDE/1.6.01.04-25 (PROV.)					