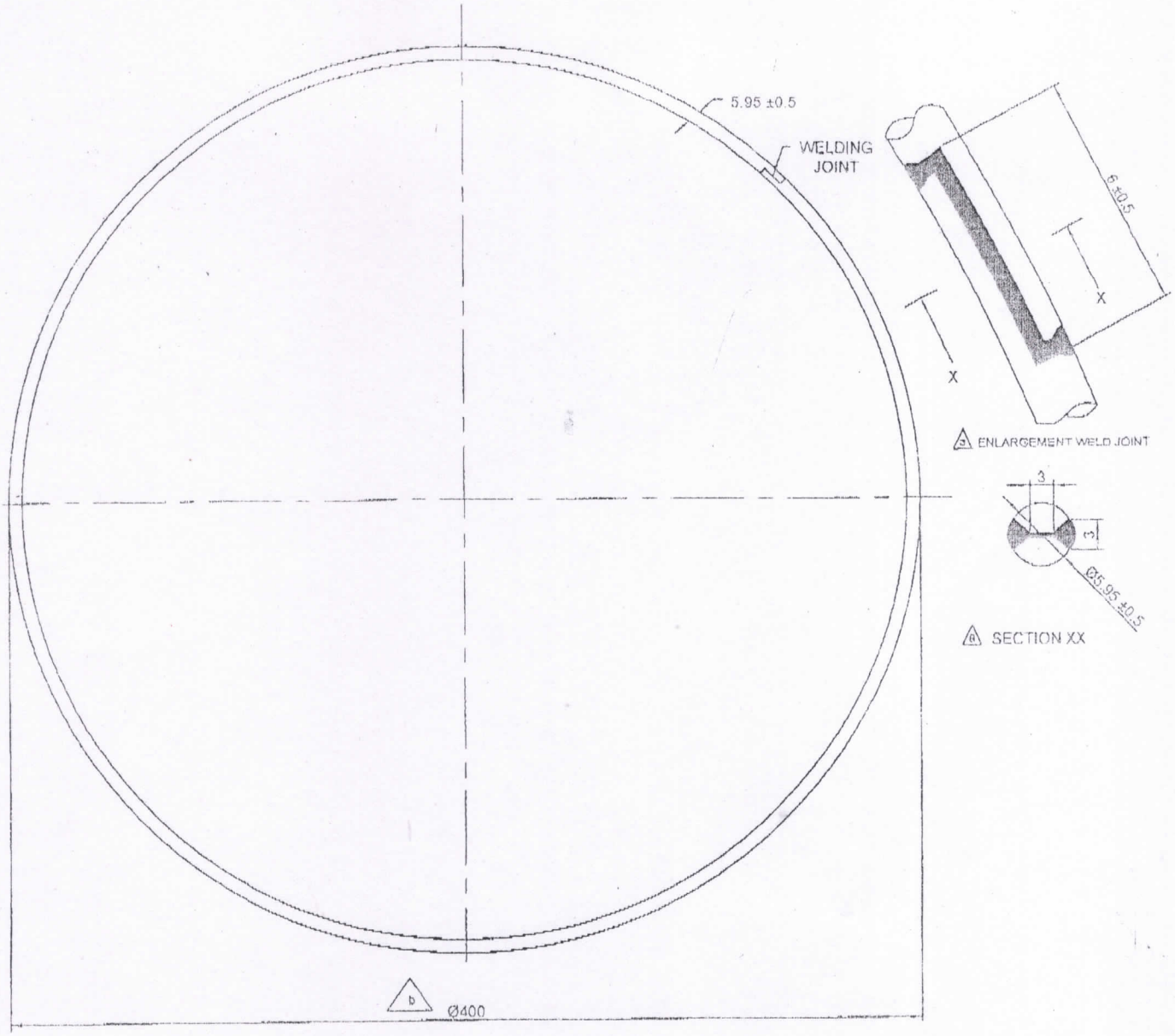
SHEET 01 OF 01




WELD NOTE:-

JOINT TO BE WELDED WITH ELECTRODE CONFORMING TO IS:1395-1982 E630-M 1129Fe

PACKING :-

TEN Nos OF RING SHALL BE GROUPED TOGETHER SO THAT THEIR COILS DOVETAIL INTO ONE ANOTHER THEREAFTER THESE SHOULD BE SECURED WITH JUTE TWINE AT THE TOP AND BOTTOM ENDS. EACH SUCH UNIT SHALL BE PACKED IN A POLYTHENE BAG. EIGHT SUCH BAGS SHALL BE PLACED IN A C.W.P. (FULLY LINED WITH PAPER PACKING WATER PROOF) ONE SAMPLE IN EACH POLYTHENE BAG SHALL BE IDENTIFIED BY A LABEL, SHOWING CAT No. DESIGNATION OF STORE AND RECOGNISED INITIAL OF THE MANUFACTURER AND YEAR OF MANUFACTURE.

THE PACKING CASE SHALL BE INDELIBLY MARKED WITH THE ADDRESS OF THE CONSIGNEE AND CONSIGNOR CAT No., DESIGNATION, YEAR OF MANUFACTURE, QUANTITY AND NUMBER OF INDIVIDUAL PACK.

a PROFF LOAD :- 4900 N
(THE WELD JOINT SHOULD SUSTAIN 4900 N LOAD)

F
F

MATERIAL :-

a STAINLESS STEEL AUSTENITIC TO SPECN No. IS:6603-1972 X07Cr18Ni9

WORKMANSHIP :-

ENDS OF THE JOINTS SHOULD BE PROPERLY FINISHED. FINISHED COMPONENTS SHALL BE WELL DRAWN AND FREE FROM CRACKS, WRINKLES, DENTS AND OTHER DEFECTS.

MFG. PROCESS :-

GENERAL ENGINEERING METHOD

| REF. | DATE | ZONE | AUTHORITY | BRIEF RECORD | Ch/c D&S | HEAD QA |
|---|---|---|---|---|---|---|
| b | 12-07-2018 | --- | --- | DIA OF THE RING HAS BEEN CHANGED FROM 370mmTO 400mm | | |
| a | 20.05.16 | | Change Sheet No. 1 | Enlargement Weld joint View and Proof Load test procedure added | | |

SCALE :- 1 : 2
DIMENSION IN mm
TOLERANCE: IS-2102-1993
MATERIAL:- AS ABOVE
FINISH:-
HEAT TREATMENT:-

ADRDE, AGRA
GROUP :- CP(H.D. SYSTEM)

RING
No-2-13033-00
DRAG PANEL
HEAVY DROP P'CHUTE (P-7 PLATFORM)
SYSTEM FOR IL-76 AIRCRAFT

DRN. | CHO. | PRO. OFF. | Gp.Dir. | Ch/cD&S | APPROVED HEAD (P&R)

DRG.No. :-ADRDE/ 1.8.01.01.02-01 (a/b)