

FRONT ELEVATION

**MATERIAL** :-  
 (a) SPRING - SPRING STEEL MUSIC WIRE  
 62-55 ± 0.1 TO SPECN DG4400H 1954  
 (b) FERRULE - M.S. PIPE 0.5mm THICK

**WORKMANSHIP** :-  
 BOTH ENDS OF SPRING TO BE JOINTS WITH  
 FERRULE PIPE AND COMPRESSED PROPERLY.

**FINISH** :-  
 a. SPRING SHOULD BE CADMIUM PLATED TO A MIN.  
 THICKNESS OF 0.02mm AND CHROMATE  
 PASSIVATED AS PER SPECN IS-1572-1968  
 b. FERRULE SHOULD BE CADMIUM PLATED TO A  
 MIN. THICKNESS OF 0.02mm AND CHROMATE  
 PASSIVATED AS PER SPECN IS-1572-1968

**EMBRIITLEMENT RELEASE** :-  
 SPRING, AFTER CADMIUM PLATED AND PRIOR TO  
 CHROMATE PASSIVATION SHALL BE MAINTAINED  
 AT A TEMP OF 150° TO 200°C FOR HALF AN  
 HOUR TO REMOVE HYDROGEN EMBRIITLEMENT.

**MFG. PROCESS** :-  
 GENERAL ENGINEERING METHOD

**COMPRESSION LOAD TEST** :-  
 SEE ON SHEET No 2 OF 2.

2A	DEVELOPMENT OF FERRULE	1	3
D.No.		No. OFF	SHEET No.

DETAIL - INDEX

REF.	DATE	ZONE	AUTHORITY	BRIEF RECORD		DI/C	HEAD
SCALE :- 1:1				ADRDE, AGRA		DI/C	DR
DIMENSION IN mm				GROUP :- CP(H.D. SYSTEM)		DI/C	DR
TOLERANCE:- IS-2302-1993				MATERIAL:- AS ABOVE		PRG. OFF. 27.4.71	
FINISH:-				HEAT TREATMENT:-		DI/C/AS	
APPROVED				SPRING		APPROVED	
ORG. NO. :- ADRDE				No-2-13033-00		16.01.02	
L6.01.02-02				DRAG PANEL		HEAVY DROP P'CHUTE (P-7 PLATFORM)	
				SYSTEM FOR IL-76 AIRCRAFT			

3.5 ± 0.1

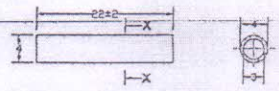
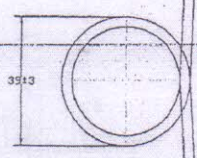
**COMPRESSION LOAD TEST -**

SPRING SHALL BE COMPRESSED BY PUTTING THE SMALL WIRE OVER THE LARGE WIRE UNDER A LOAD OF NOT LESS THAN 6kg AND NOT MORE THAN 8kg. AFTER BEING MAINTAINED IN COMPRESSED POSITION UNDER SUCH LOAD FOR A PERIOD OF 10 MINUTES THE LOAD SHALL BE REMOVED. ON REMOVAL OF THE LOAD, BOTH THE WIRES (SMALL & LARGE) SHALL NOT SHOW THE DISPLACEMENT FROM THE BASE MORE THAN 12mm AND THERE MUST NOT BE ANY SLIPPAGE OF THE FERRULE OR THE JOINT. THIS TEST MAY BE CARRIED OUT ON EACH SPRING.

**PACKING -**

FOUR Nos OF SPRING 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.M.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 CONSIGNER CAT No., DESIGNATION, YEAR OF MANUFACTURE, QUANTITY AND NUMBER OF INDIVIDUAL PACK.



REF.	DATE	ZONE	AUTHORITY	BRIEF RECORD		D/C	HEAD
				ADRDE, AGRA			
				GROUP :- CP(H.D. SYSTEM)			
				<b>DEVELOPMENT OF FERRULE</b>			
				<b>No-2-13033-00</b>			
				<b>DRAG PANEL</b>			
				<b>HEAVY DROP P'CHUTE (P-7 PLATFORM)</b>			
				<b>SYSTEM FOR IL-76 AIRCRAFT</b>			
						PRD OFF	11/11/00
						CHD	27-84
						Q/C/DAS	
						APPROVED	9/10/00
						DRG.No. I-ADR	
						1.6.01.01.02-02	