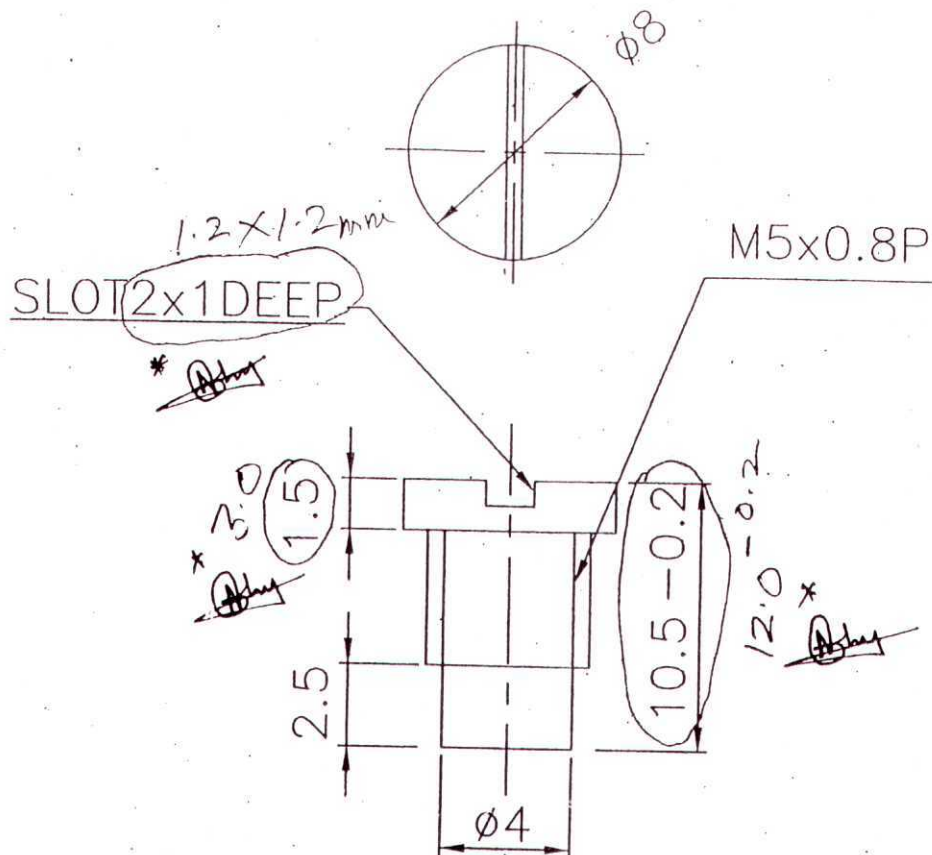




* AS per ADRDE Letter No. ADRDE/QMS/HDS/467, Dt. 11.09.13
Amendation in drawing is incorporated. (i.e. a) Head thickness - 3.00mm

b) Slot - 1.2 x 1.2 mm

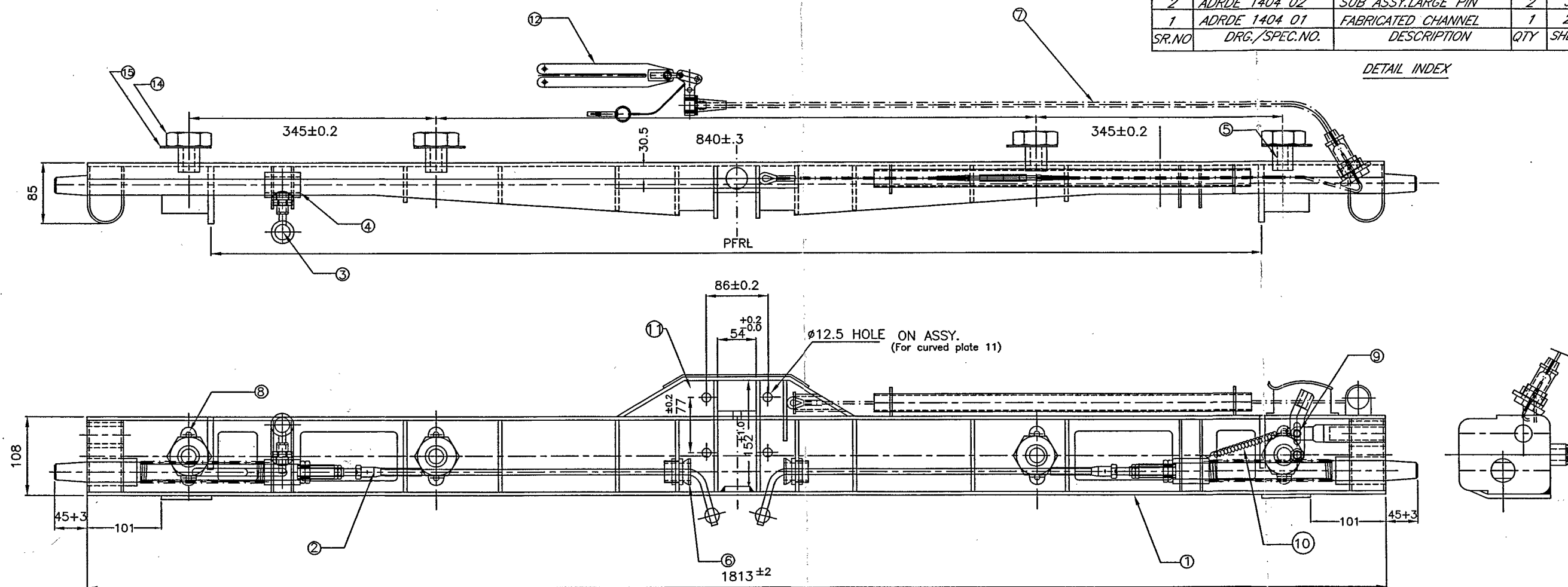
c) Total length - 12.0^{-0.2} mm.

PROCESS : MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S	MATERIAL: IS:961, St 55 HTW OR ASTM A 516 Gr. 70	ADRDE ; AGRA		
CHECKED		SKS	 PRO.OFFR.	PD	FINISH: AS PER ANNEXURE 'C'		
TRACED		JCD					
COMPARED					HEAT TREATMENT: NORMALIZED	APPROVED HEAD (Q.A.)	
SCALE: N T S				OI/C D & S	QTY. 2Nos.	DRG.No.	
ALL DIMENSIONS IN MM						ADRDE 1404 03 05(a)(b)(c)	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			GURB SCREW HOOK (LOCATER)- SUB.ASSY.BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				

15	ADRDE 1403 01 04	LOCK WASHER	4	—
14	ADRDE 1403 01 07	HEX NUT	4	—
13	ADRDE 1404 13	TESTING METHOD	—	86
12	ADRDE 1404 12	FORK SUB. ASSY.	1	82-85
11	ADRDE 1404 11	CURVED PLATE SUB ASSY.	1	78-81
10	ADRDE 1404 10	SPRING	1	77
9	ADRDE 1404 09	TENSION LEVER SUB ASSY.	1	71-76
8	AS PER IS 1364	SCREW M8x1.25 P	8	—
7	ADRDE 1404 07	ROPE SUB ASSY.	1	47-70
6	ADRDE 1404 06	GUIDE BUSH-ROPE	2	46
5	ADRDE 1404 05	T BRACKET	4	45
4	ADRDE 1404 04	BUSH BLOCK	2	44
3	ADRDE 1404 03	HOK LOCATER SUB.ASSY.	2	37-43
2	ADRDE 1404 02	SUB ASSY.LARGE PIN	2	32-36
1	ADRDE 1404 01	FABRICATED CHANNEL	1	2-31
SR.NO	DRG./SPEC.NO.	DESCRIPTION	QTY	SHEET NO.

DETAIL INDEX



PERFORMANCE TEST:

PFRL (LOCK) WILL BE FITTED IN BEAM ASSMBLY AND COMPLETE OPERATION OF CHANGE OVER MECHANISM WILL BE CARRIED OUT 10 TIMES ON GROUND

PROOF LOAD TEST:

BEAM ASSEMBLY TO BE TESTED FOR 2740 KG LOAD AS SHOWN IN DRAWING NO. ADRDE 1404 13

PLATING :

ALL NUTS, BOLTS & WASHERS SHOULD BE CADMIUM PLATED AS PER IS 1572 Gr 3, 10-12 micron

WELDING :

ALL WELDED JOINTS SHOULD BE WELDED BY ELECTRODES CONFORMING TO ADVANI OERLIKON SUPERCITO AWS/SFA 5.1-E7018 ISEB-5426 H3Jx OR ITS EQUIVALENT.

WELD CHECKING :

ALL THE WELD JOINTS TO BE CHECKED BY DYE PENETRATION TEST METHOD AS PER IS 3658.

NOTE:- ITEM NO. 11,14&15 WILL BE USED AT THE TIME OF ASSEMBLY WITH PLATFORM MODULES.

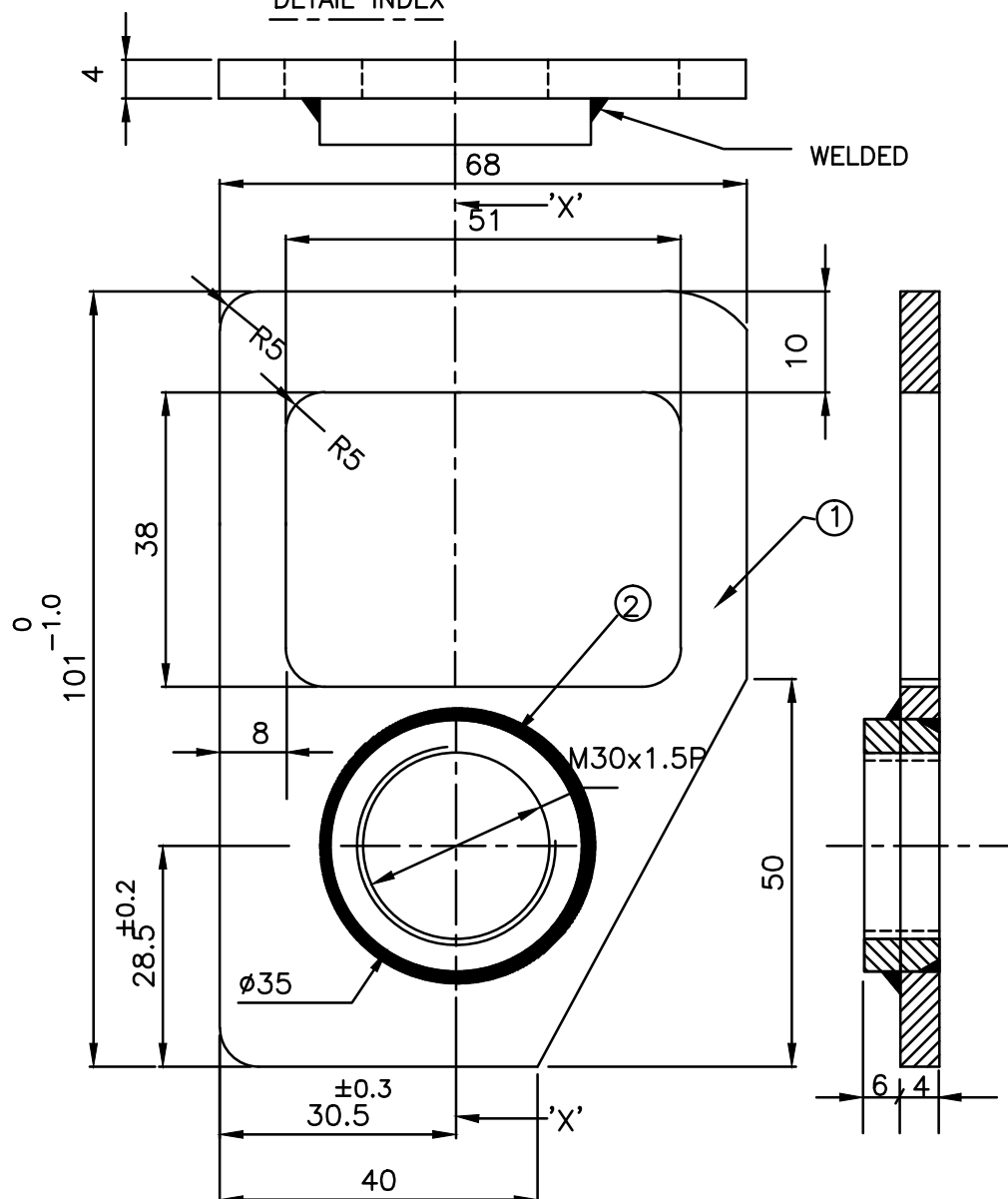
	DATE	NAME	H D S	MATERIAL:	ADRDE ; AGRA
DRAWN		SKS			
CHECKED		JCD			
TRACED			PRO.OFFR.	FINISH: AS PER ANNEXURE 'A' (GREY)	
COMPARED				HEAT TREATMENT:	APPROVED
SCALE: NTS				QTY: 1No.	HEAD(Q.A.)
ALL DIMENSIONS IN MM			OI/C D & S		
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 VERY COARSE					DRG.No.
				BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)	ADRDE 1404(a)(b) (C)

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	OI/C D&S	HEAD QA

4		3	2	1
2	ADRDE 1404 01 08 02	GUIDED BUSH	2	12
1	ADRDE 1404 01 08 01	PLATE 'F'	2	11
S.NO	Drg. /SPEC.NO.	Description	QTY	SHEET NO.

SHEET 10 OF 86

DETAIL INDEX



WELDING :

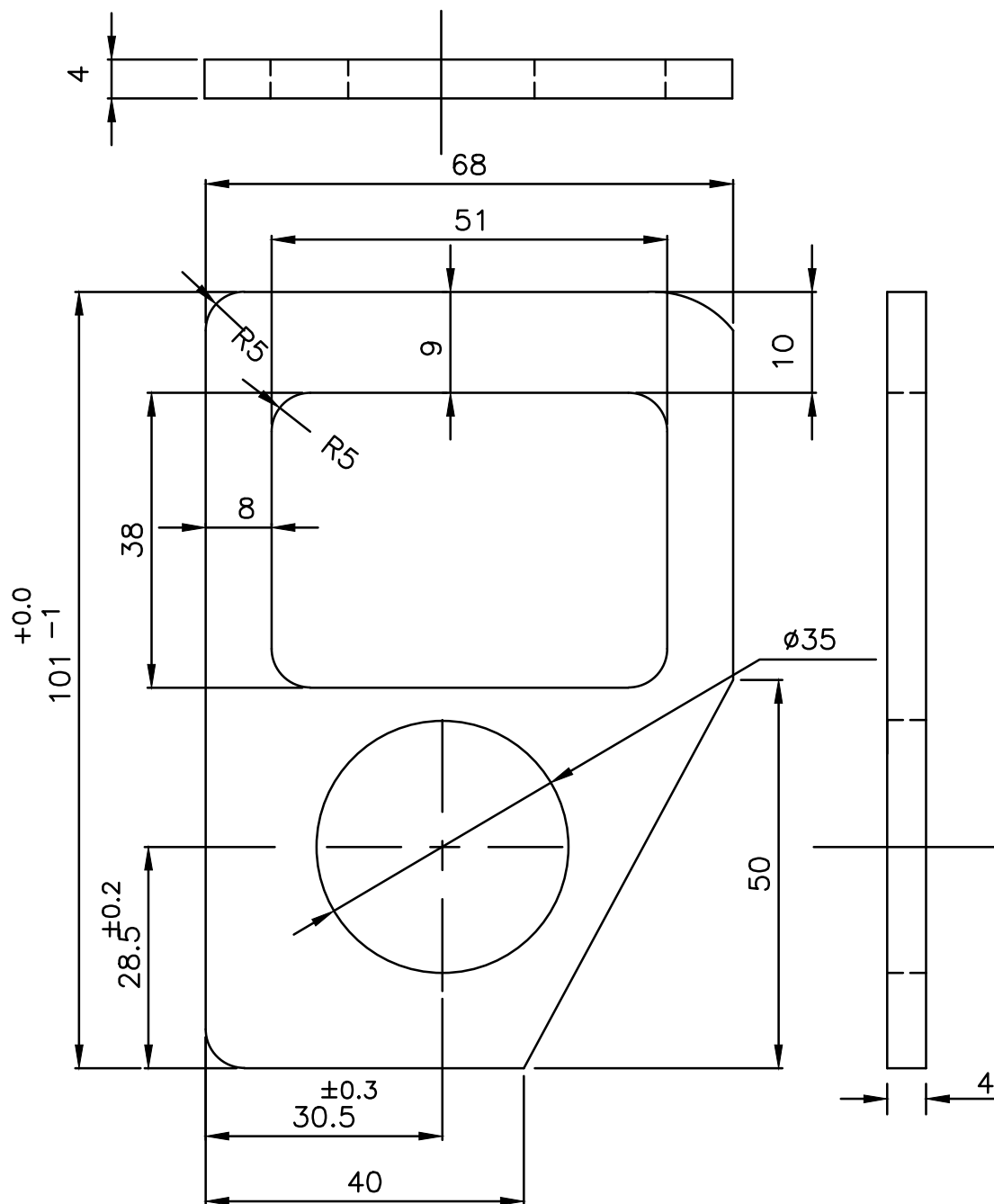
ALL JOINTS SHOULD BE WELDED BY ELECTRODES CONFORMING TO ADVANI OERLIKON SUPERCITO AWS/SFA 5.1-E7018 ISEB-5426 H3Jx OR ITS EQUIVALENT. WELDED JOINTS SHOULD BE TESTED BY DYE PENETRATION TEST (IS: 3658) BEFORE FINISH .

PROCESS:FABRICATION

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	OI/C D&S	HEAD QA
DRAWN	DATE	NAME	HDS	MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS				
TRACED		JCD		FINISH: AS PER ANNEXURE'A' (GREY)		
COMPARED		—	PRO.OFF.	PD	HEAT TREATMENT: NORMALIZED	APPROVED
SCALE: NTS				OI/C D & S	QTY.: 2Nos.(one LH & one RH)	HEAD (Q.A.)
ALL DIMENSIONS IN MM						DRG.No.
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM						ADRDE 1404 01 08 (a)(b)

PLATE'F' SUB.ASSEMBLY
FABRICATED CHANNEL- BEAM ASSEMBLY
(HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)

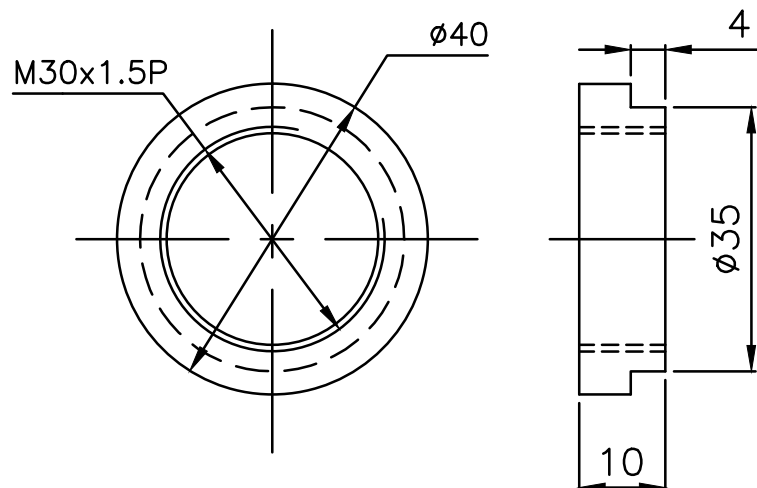
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PROCESS :- MACHINING

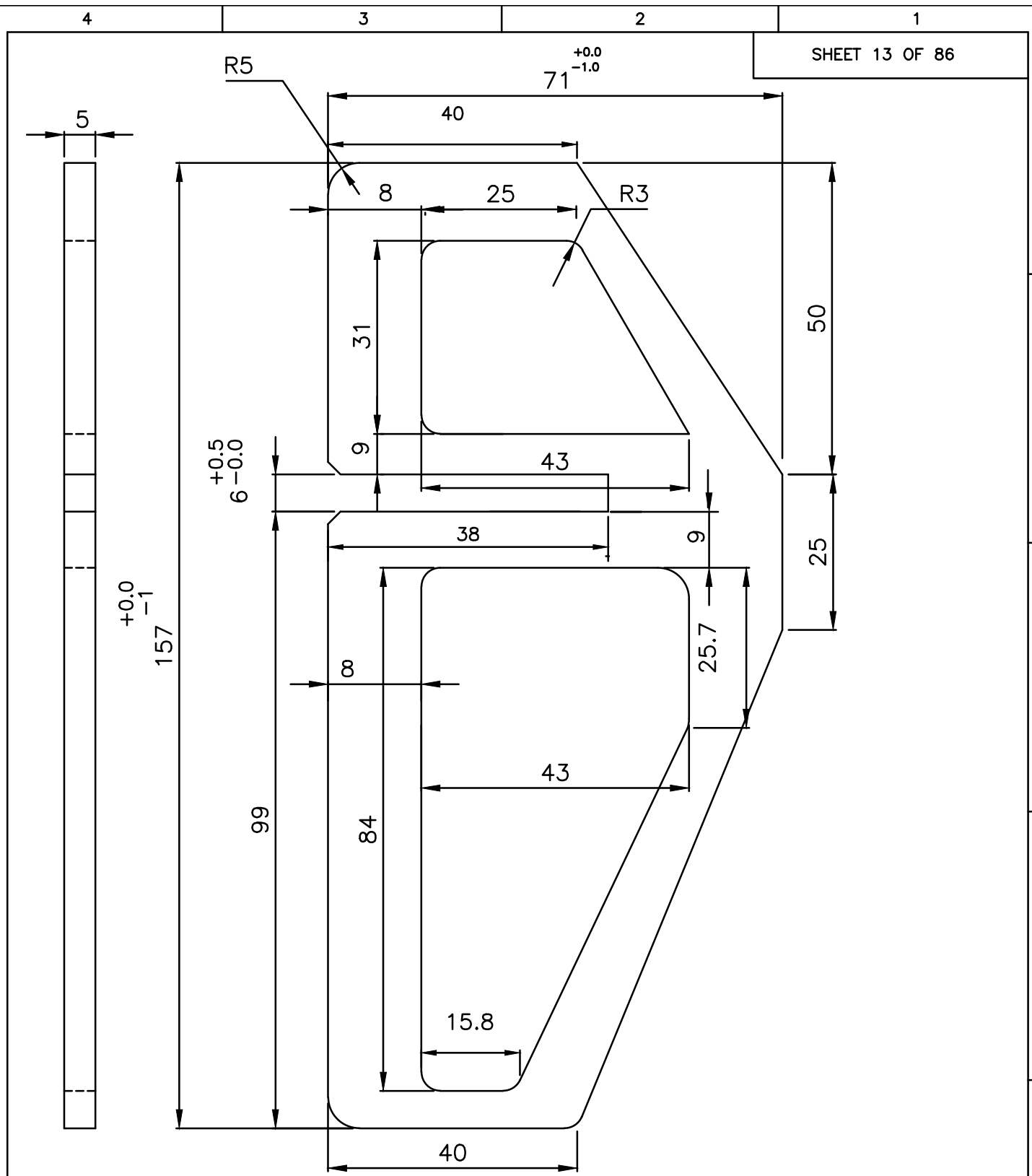
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD QA
DRAWN	DATE	NAME	HDS		MATERIAL: IS:961, St 55 HTW OR <i>ASTM A 516 Gr. 70</i>	ADRDE ; AGRA	
CHECKED		SKS			FINISH: <i>AS PER ANNEXURE 'A' (GREY)</i>		
TRACED		JCD					
COMPARED		PRO.OFF.	PD		HEAT TREATMENT:	APPROVED	
SCALE: NTS					NORMALIZED	HEAD (Q.A.)	
ALL DIMENSIONS IN MM			OI/C D & S		QTY.: 2Nos.(one LH & one RH)	DRG.No.	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			PLATE- F PLATE F ASSY - BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN 32 AIRCRAFT)				ADRDE 1404 01 08 01(4)(b)

2

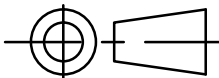


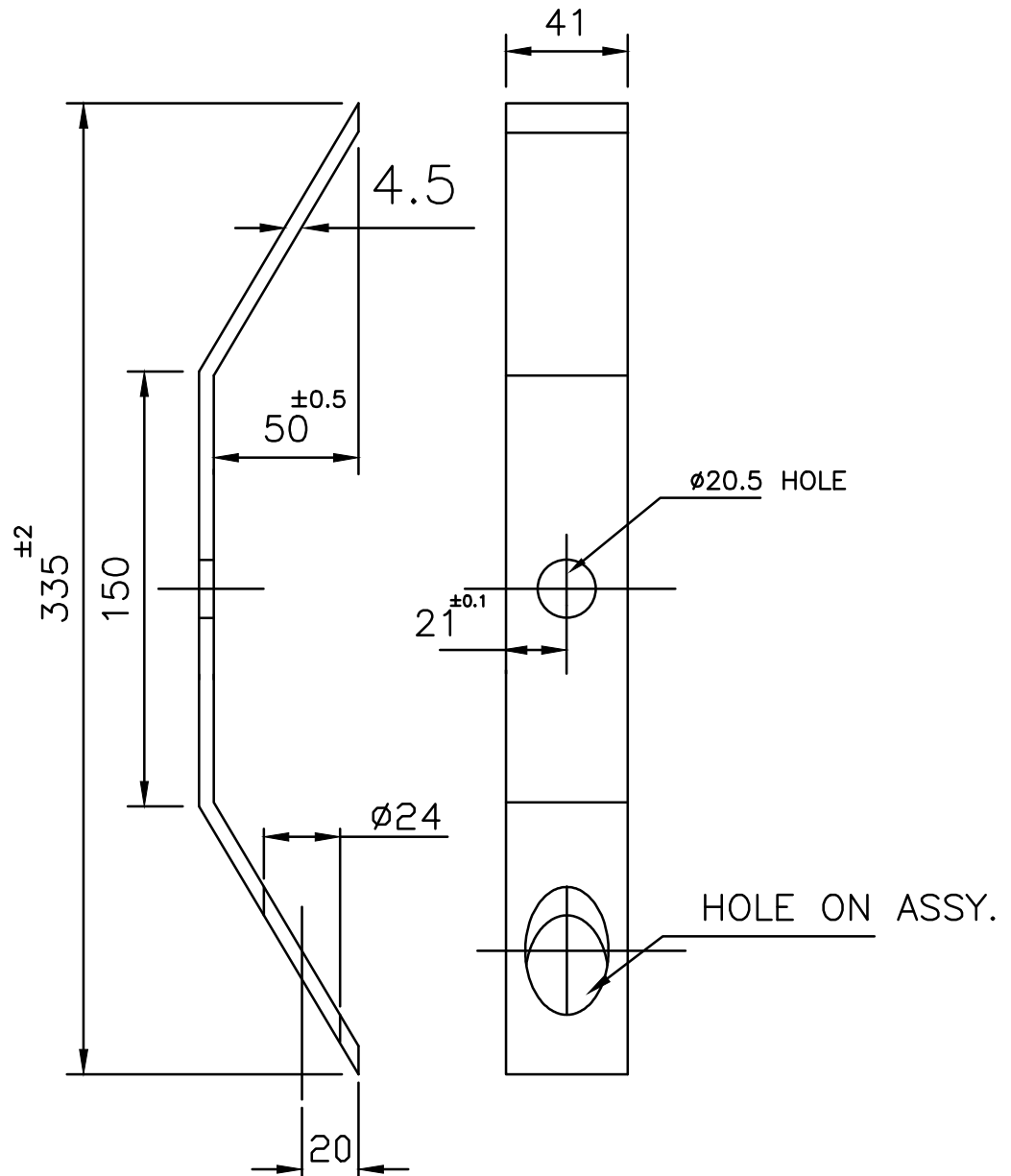
PROCESS :- MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD	OI/C D&S	HEAD QA
	DATE	NAME	H D S	MATERIAL: IS:961, St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
DRAWN		SKS	OI/C D&S PD	FINISH: AS PER ANNEXURE 'A' (GREY)		
CHECKED		JCD				
TRACED		—			HEAT TREATMENT: NORMALIZED	APPROVED
COMPARED		—			HEAD (Q.A.)	
SCALE: NTS			OI/C D & S	QTY.: 1 No.	DRG.No.	
ALL DIMENSIONS IN MM						ADRDE1404 01 08 02(d)(b)
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			NUT-GUIDE BUSH PLATE F ASSY - BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			



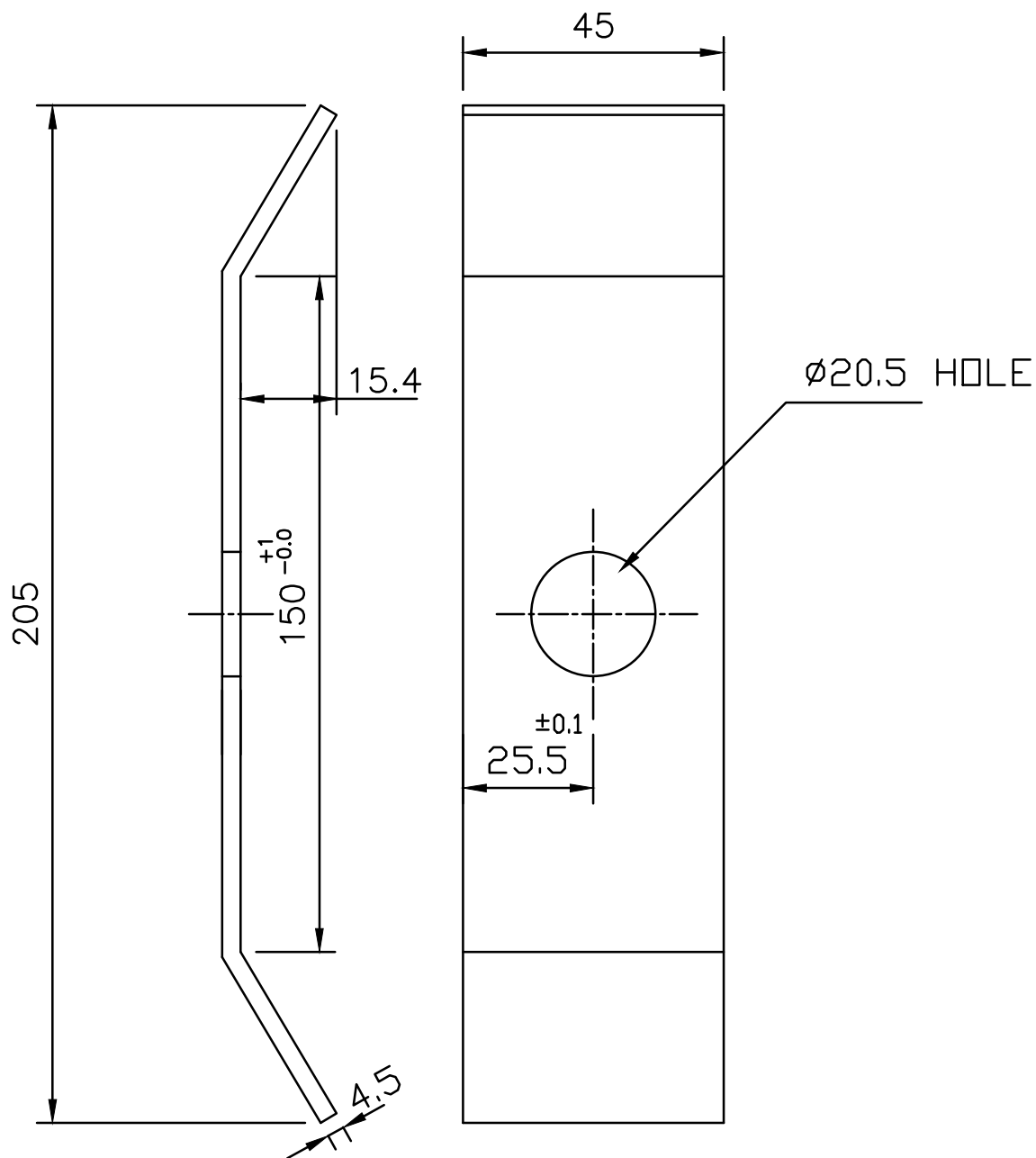
PROCESS: MACHINING

Ref. No.	DATE	ZONE	AUTHORITY		BRIEF RECORD			OI/C D&S	HEAD QA		
	DATE	NAME	HDS		MATERIAL: IS:961,St 55 HTW OR ASTM A 516 Gr.70			ADRDE ; AGRA			
DRAWN		SKS	PRO.OFF.	PD				FINISH: AS PER ANNEXURE 'A'(GREY)			
CHECKED		JCD			HEAT TREATMENT: NORMALIZED		APPROVED				
TRACED		—			OI/C D & S		QTY.: 2Nos.			HEAD (Q.A.)	
COMPARED		—									
SCALE: N T S											
ALL DIMENSIONS IN MM											
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			PLATE G FABRICATED CHANNEL – BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN 32 AIRCRAFT)					DRG.No. ADRDE 1404 01 09(a)(b)			



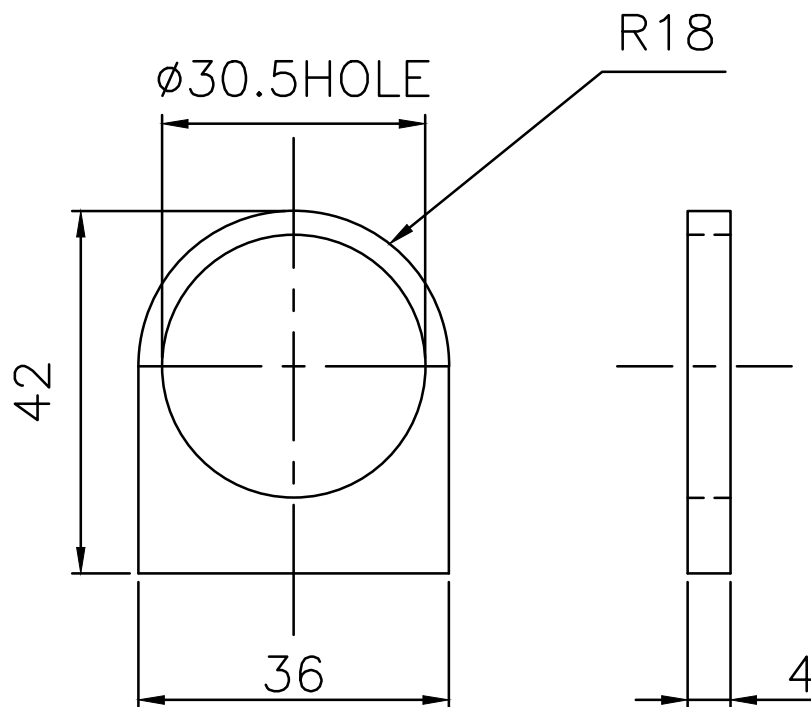
PROCESS :- FORMING

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD QA
	DATE	NAME	H D S		MATERIAL: IS:961, St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
DRAWN		SKS			FINISH: AS PER ANNEXURE 'A' (GREY)		
CHECKED		JCD					
TRACED			PRO.OFF.	PD	HEAT TREATMENT: NORMALISED	APPROVED	
COMPARED					QTY.: 1No.	HEAD (Q.A.)	
SCALE: NTS							
ALL DIMENSIONS IN MM			OI/C D & S			DRG.No.	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			PLATE LARGE MIDDLE FABRICATED CHANNEL - BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				ADRDE 1404 01 10(a)(b)



PROCESS :- FORMING

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD		OI/C D&S	HEAD QA
DATE		NAME	H D S		MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
DRAWN		SKS	PRO.OFFR. PD		FINISH: AS PER ANNEXURE'A' (GREY)		
CHECKED		JCD					
TRACED							
COMPARED			OI/C D & S		HEAT TREATMENT NORMALIZED	APPROVED	
SCALE: NTS					QTY.: 1No.	HEAD (Q.A.)	
ALL DIMENSIONS IN MM							
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			PLATE SMALL MIDDLE FABRICATED CHANNEL - BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				DRG.No. ADRDE 1404 01 11(g)(b)

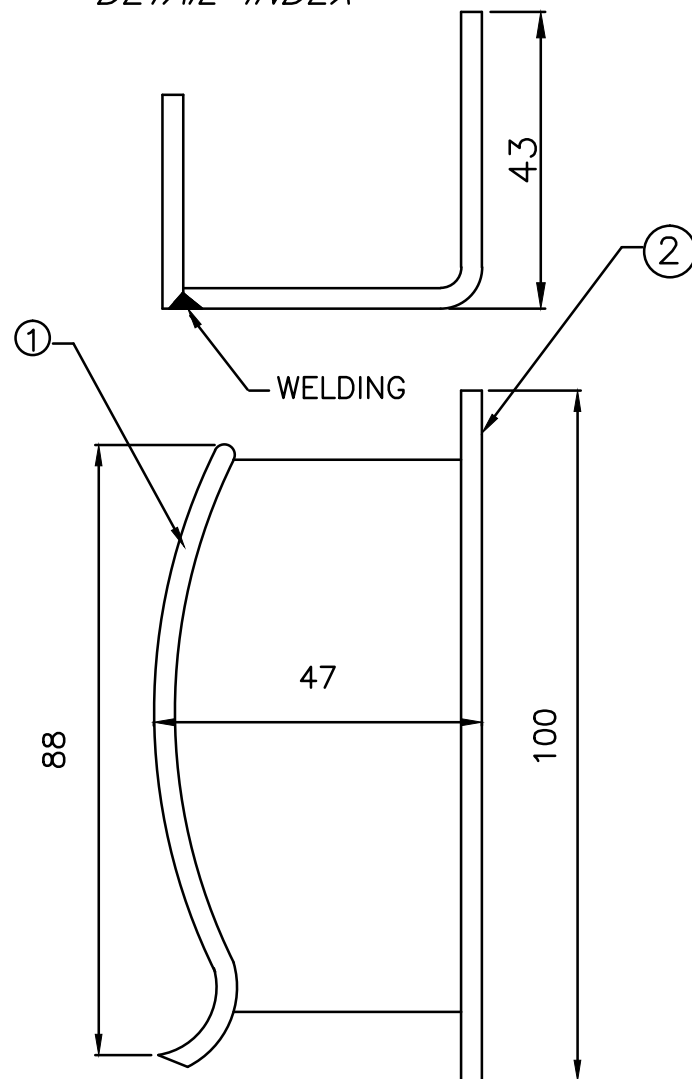


PROCESS :- MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD	DI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S	MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS		FINISH: AS PER ANNEXURE'A' (GREY)		
TRACED		JCD				
COMPARED			PRO.OFF.	PD	APPROVED	
SCALE: NTS				HEAT TREATMENT: NORMALIZED	HEAD (Q.A.)	
ALL DIMENSIONS IN MM			D & S OI/C	QTY.: 1No.	DRG.No.	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			PLATE SIDE FABRICATED CHANNEL – BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			ADRDE 1404 01 12(8)(b)

			SHEET 17 OF 86	
2	ADRDE 1404 01 13 02	'L' PLATE	1	19
1	ADRDE 1404 01 13 01	TOP PLATE	1	18
SR.NO.	DRG../SPEC.NO.	DESIGNATION	QTY	SHEET NO.

DETAIL INDEX

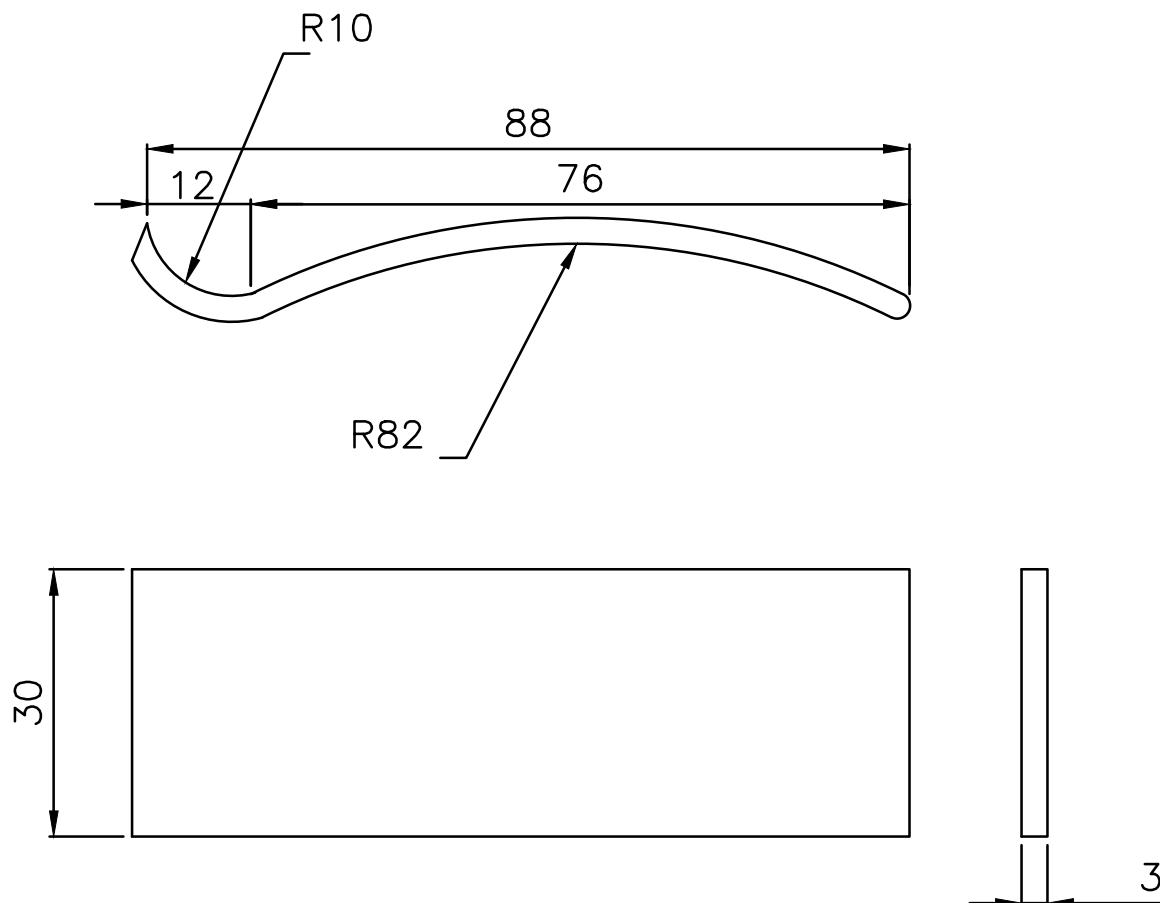


PROCESS :- FABRICATION

WELDING :

ALL WELDED JOINTS SHOULD BE WELDED BY ELECTRODES CONFORMING TO ADVANI OERLIKON SUPERCITO AWS/SFA 5.1-E7018 ISEB-5426 H3Jx OR ITS EQUIVALENT. WELDED JOINTS SHOULD BE TESTED BY DYE PENETRATION TEST (IS: 3658) BEFORE FINISH .

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	OI/C D&S	HEAD QA
	DATE	NAME	H D S	MATERIAL:	ADRDE ; AGRA	
DRAWN		SKS				
CHECKED		JCD		FINISH: AS PER ANNEXURE'A' (GREY)		
TRACED			PRO.OFF. PD			
COMPARED				HEAT TREATMENT:	APPROVED	
SCALE: NTS				NORMALIZED	HEAD (Q.A.)	
ALL DIMENSIONS IN MM			OI/C D & S	QTY.: 1Nos.		
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			BRACKET-SUB ASSY. FABRICATED CHANNEL – BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 01 13(a)(b)



PROCESS :- FORMING

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD		OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S		MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS			FINISH: AS PER ANNEXURE'A' (GREY)		
TRACED		JCD					
COMPARED			PRO.OFF.	PD	HEAT TREATMENT:	APPROVED	
SCALE: NTS					NORMALIZED	HEAD (Q.A.)	
ALL DIMENSIONS IN MM			OI/C D & S		QTY.: 1No.	DRG.No.	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			TOP PLATE BRACKET SUB ASSY-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				ADRDE 1404 01 13 01(d)(b)

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SHEET 19 OF 86

(2)

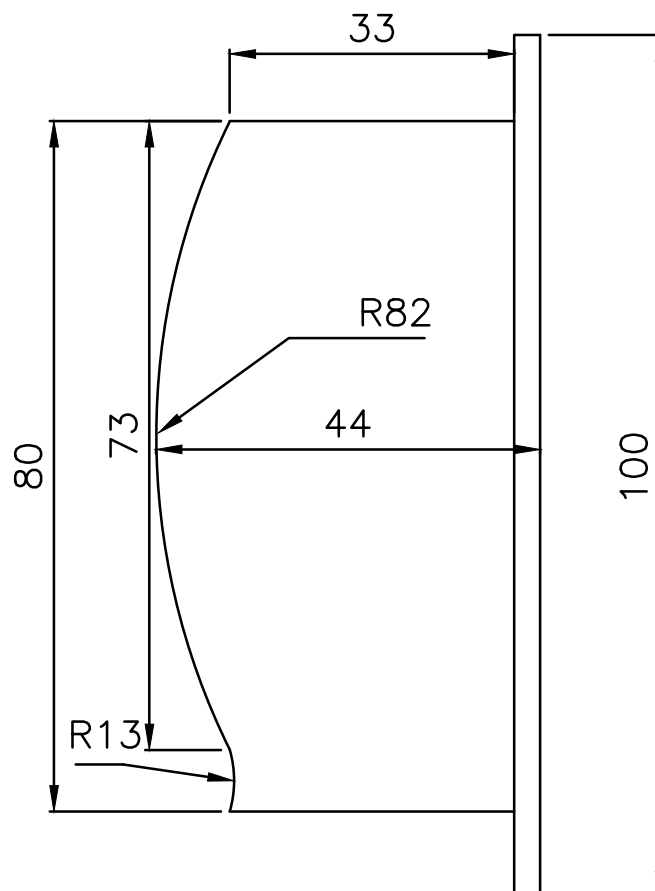
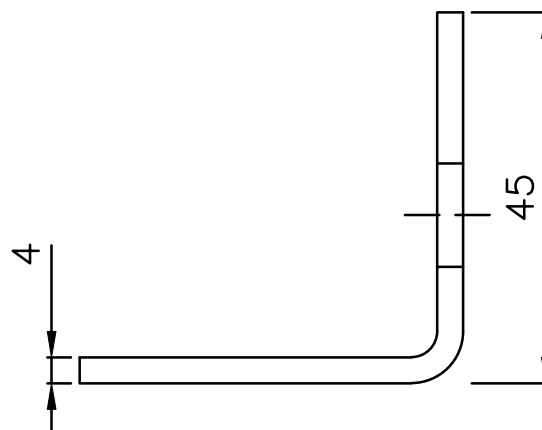
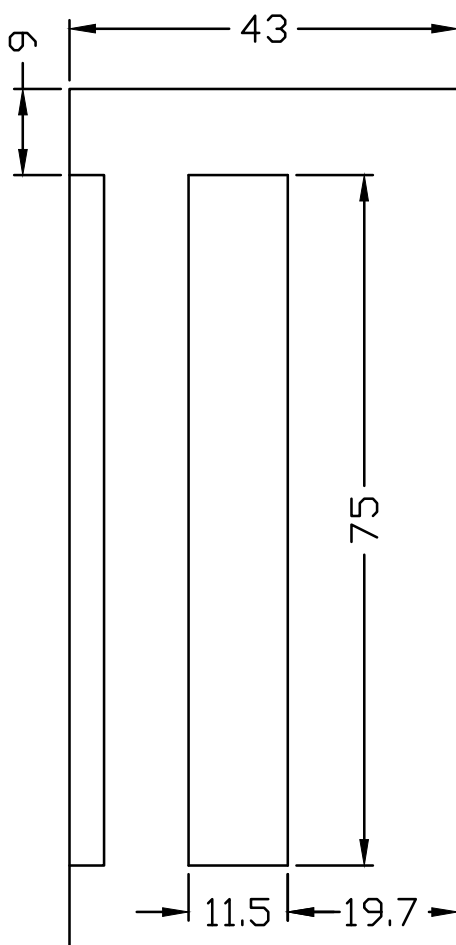
F

E

D

C

B



PROCESS :- FABRICATION

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD	DI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S	MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRD ; AGRA	
CHECKED		SKS		FINISH: AS PER ANNEXURE'A' (GREY)		
TRACED		JCD				
COMPARED			PRO.OFF	PD	HEAT TREATMENT: NORMALIZED	
SCALE: NTS					APPROVED	
ALL DIMENSIONS IN MM			DI/C D & S		HEAD(Q.A.)	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			QTY.: 1Nos.			DRG.No.
			'L' PLATE BRACKET SUB ASSY-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			ADRD 1404 01 13 02(a)(b)

25	ADRDE 1404 01 25	BUSH MEDIUM	2	31
24	ADRDE 1404 01 24	SUPPORT BUSH	1	30
23	ADRDE 1404 01 23	SUPPORT PLATE	4	29
22	ADRDE 1404 01 22	BUSH LARGE	2	28
21	ADRDE 1404 01 21	BUSH SMALL	1	27
20	ADRDE 1404 01 20	PLATE K	1	26
19	ADRDE 1404 01 19	PLATE J	1	25
18	ADRDE 1404 01 18	PLATE CHANNEL	2	24
17	ADRDE 1404 01 17	BUSH	1	23
16	ADRDE 1404 01 16	PLATE BOTTOM-MIDDLE	1	22
SR.NO	DRG./SPEC.NO.	DESCRIPTION	QTY	SHEET NO.

15	ADRDE 1404 01 15	PIPE	1	21
14	ADRDE 1404 01 14	PLATE-PIPE	2	20
13	ADRDE 1404 01 13	BRACKET SUB.ASSY	1	17-19
12	ADRDE 1404 01 12	PLATE SIDE	1	16
11	ADRDE 1404 01 11	PLATE SMALL MIDDLE	1	15
10	ADRDE 1404 01 10	PLATE LARGE MIDDLE	1	14
9	ADRDE 1404 01 09	PLATE G	2	13
8	ADRDE 1404 01 08	PLATE F SUB.ASSY	2	10-12
7	ADRDE 1404 01 07	PLATE E	2	9
6	ADRDE 1404 01 06	PLATE D	2	8
5	ADRDE 1404 01 05	PLATE C	2	7
4	ADRDE 1404 01 04	PLATE B	4	6
3	ADRDE 1404 01 03	PLATE A	2	5
2	ADRDE 1404 01 02	'U' PLATE	2	4
1	ADRDE 1404 01 01	CHANNEL	1	3
SR.NO	DRG./SPEC.NO.	DESCRIPTION	QTY	SHEET NO.

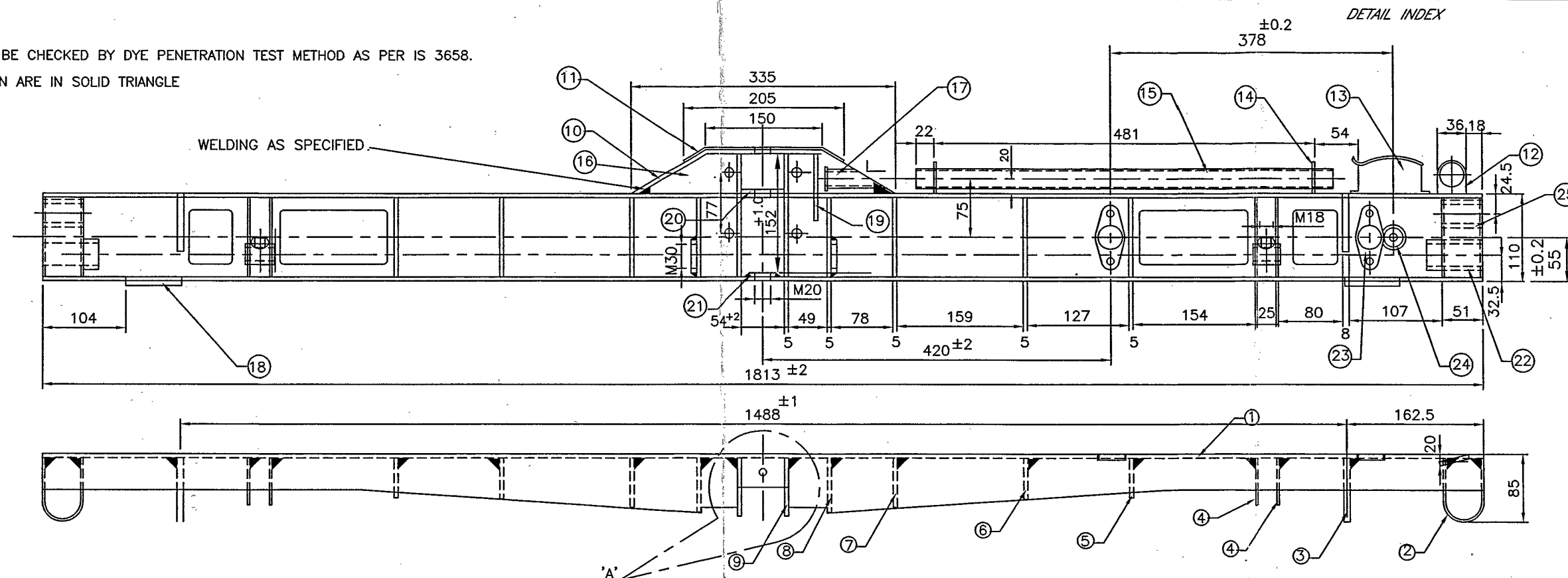
WELDING :

ALL WELDED JOINTS SHOULD BE WELDED BY ELECTRODES CONFORMING TO ADVANI OERLIKON SUPERCITO AWS/SFA 5.1-E7018 ISEB-5426 H3Jx OR ITS EQUIVALENT.

WELD CHECKING :

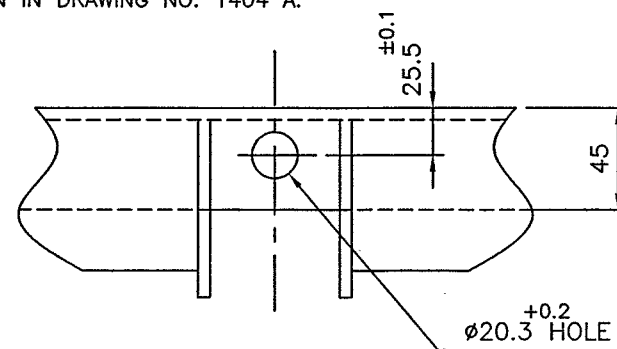
ALL THE WELD JOINTS TO BE CHECKED BY DYE PENETRATION TEST METHOD AS PER IS 3658.

NOTE:-WELDING ARE SHOWN ARE IN SOLID TRIANGLE



NOTE :-

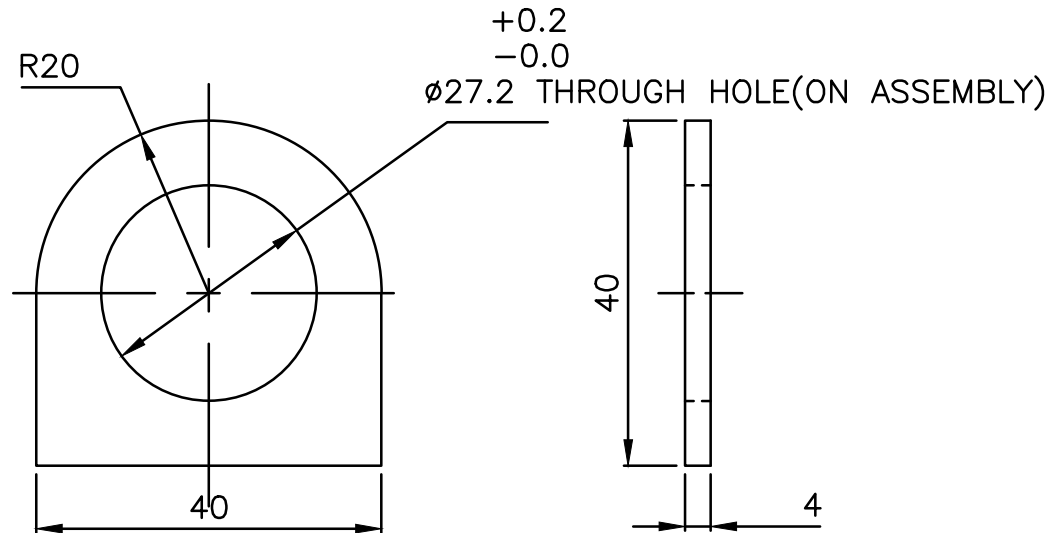
PLATES AS PER DRAWING NO. 1404 01 02 TO 14 & 16,18,19,20 & ARE TO BE WELDED AS PER WELD SPECIFICATION IN DRAWING NO. 1404 A.



PROCESS :- FABRICATION

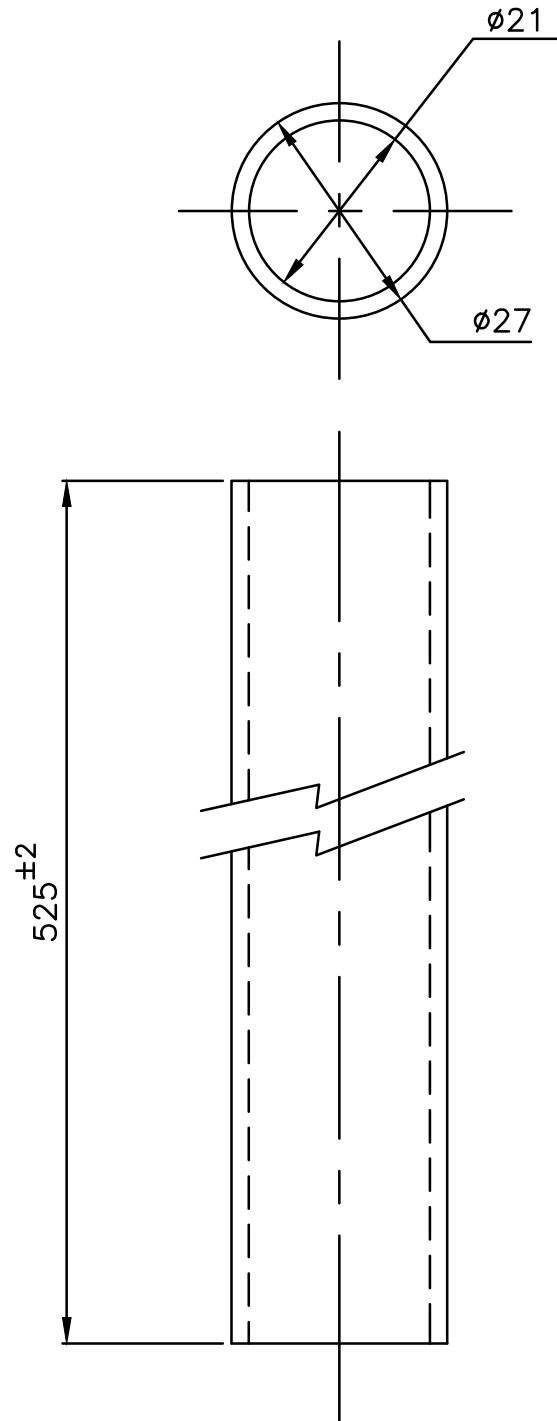
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	DI/C D&S HEAD QA

DATE	NAME	H D S	MATERIAL:	ADRDE ; AGRA
DRAWN	SKS			
CHECKED	JCD			
TRACED		PRO.OFF.	FINISH: AS PER ANNEXURE 'A' (GREY)	
COMPARED			HEAT TREATMENT:	APPROVED
SCALE: NTS			QTY : 1No.	HEAD(Q.A.)
ALL DIMENSIONS IN MM		DI/C D & S		
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 VERY COARSE			FABRICATED CHANNEL BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)	DRG.No. ADRDE 1404 01 (a)(b)(c)



PROCESS :- MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		DI/C D&S	HEAD QA
	DATE	NAME	H D S		MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
DRAWN		SKS	PRO.OFF.	PD	FINISH: AS PER ANNEXURE'A' (GREY)		
CHECKED		JCD					
TRACED							
COMPARED			OI/C D & S		HEAT TREATMENT: NORMALIZED	APPROVED	
SCALE: NTS					QTY.: 2 Nos.	HEAD Q.A.)	
ALL DIMENSIONS IN MM							
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			PLATE PIPE FABRICATED CHANNEL-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				DRG.No. ADRDE 1404 01 14(ø)(b)



FINISH: ZINK COATING ON TUBE
AS PER IS:4736-1968 BEFORE
PAINTING AS PER ANNEXURE 'A'(GREY) .

PROCESS :- FABRICATION

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD		OI/C D&S	HEAD QA
	DATE	NAME	H D S		MATERIAL: ERW TUBE. ø20 (NOMINAL BORE),LIGHT AS PER IS:1239 (Pt. 1)1968	ADRDE ; AGRA	
DRAWN		SKS	PRO.OFFR. PD		FINISH: AS ABOVE		
CHECKED		JCD			HEAT TREATMENT: NORMALIZED		
TRACED					QTY.: 1No.		
COMPARED			OI/C D & S		APPROVED		HEAD (Q.A.)
SCALE: NTS					ADRDE1404 01 15(ø)(b)		
ALL DIMENSIONS IN MM							
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			PIPE FABRICATED CHANNEL-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				

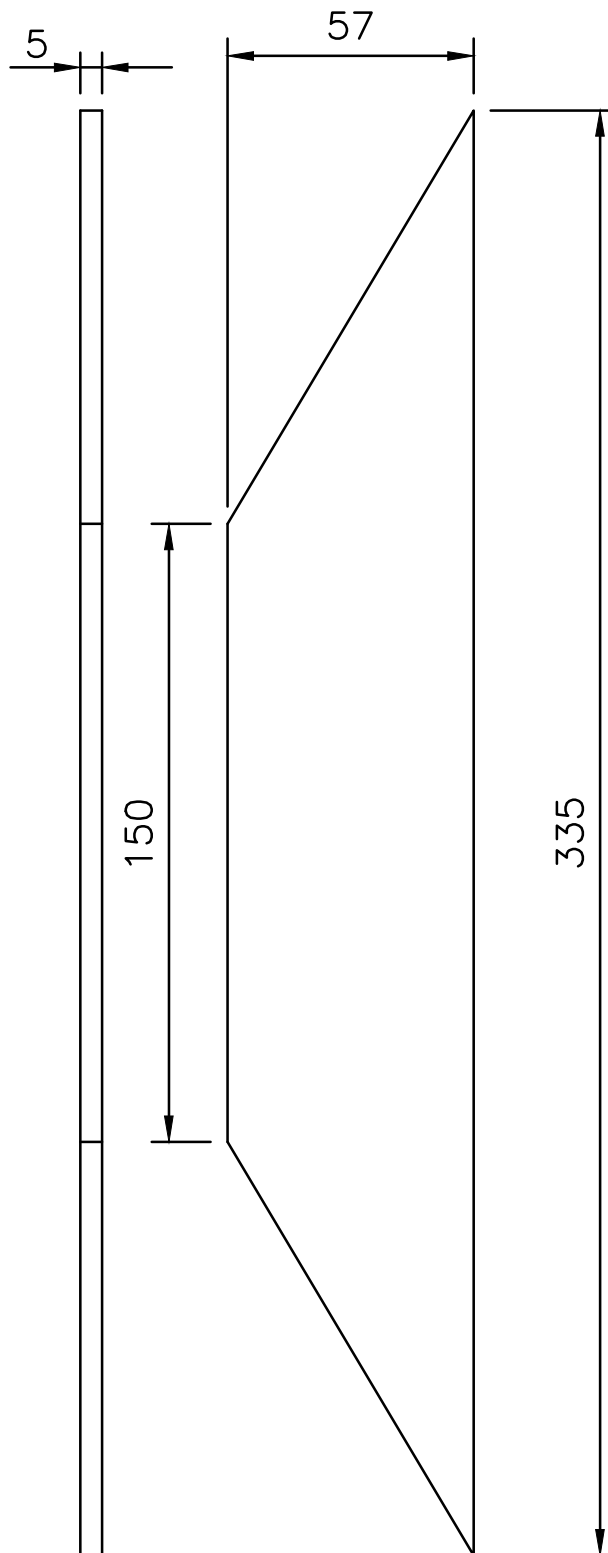
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2

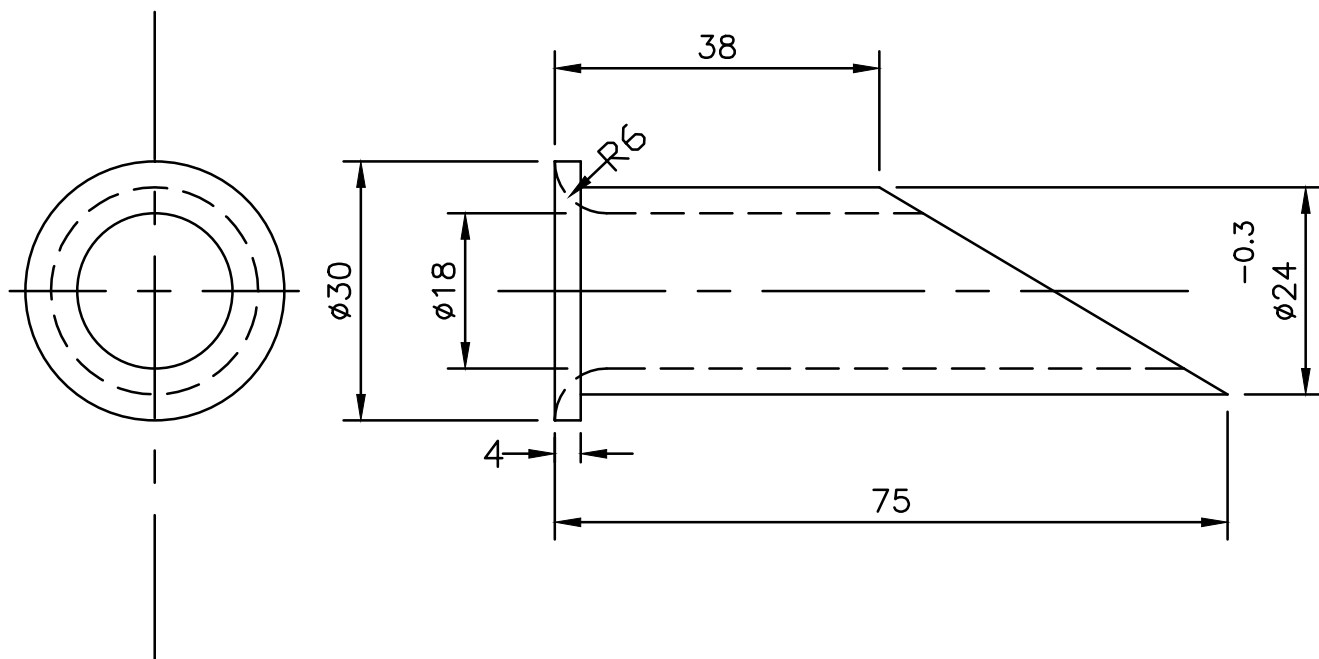
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SHEET 22 OF 86



PROCESS :- MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD	OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S	MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS		FINISH: AS PER ANNEXURE 'A' (GREY)		
TRACED		JCD				
COMPARED			PRO.OFF.	PD	APPROVED	
SCALE: NTS			HEAT TREATMENT:		HEAD (Q.A.)	
ALL DIMENSIONS IN MM			NORMALIZED		DRG.No.	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			QTY.: 1No..		ADRDE 1404 01 16(a)(b)	
PLATE BOTTOM MIDDLE FABRICATED CHANNEL-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)						



PROCESS : MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD		OI/C D&S	HEAD QA
	DATE	NAME	H D S		MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
DRAWN		SKS	PRO.OFF. PD		FINISH: <i>AS PER ANNEXURE 'A' (GREY)</i>		
CHECKED		JCD					
TRACED							
COMPARED			OI/C D & S		HEAT TREATMENT: <i>NORMALIZED</i>	APPROVED	
SCALE: NTS					QTY.: 1Nos.	HEAD (Q.A.)	
ALL DIMENSIONS IN MM							
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			BUSH FABRICATED CHANNEL-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 01 17(ø)(b)	

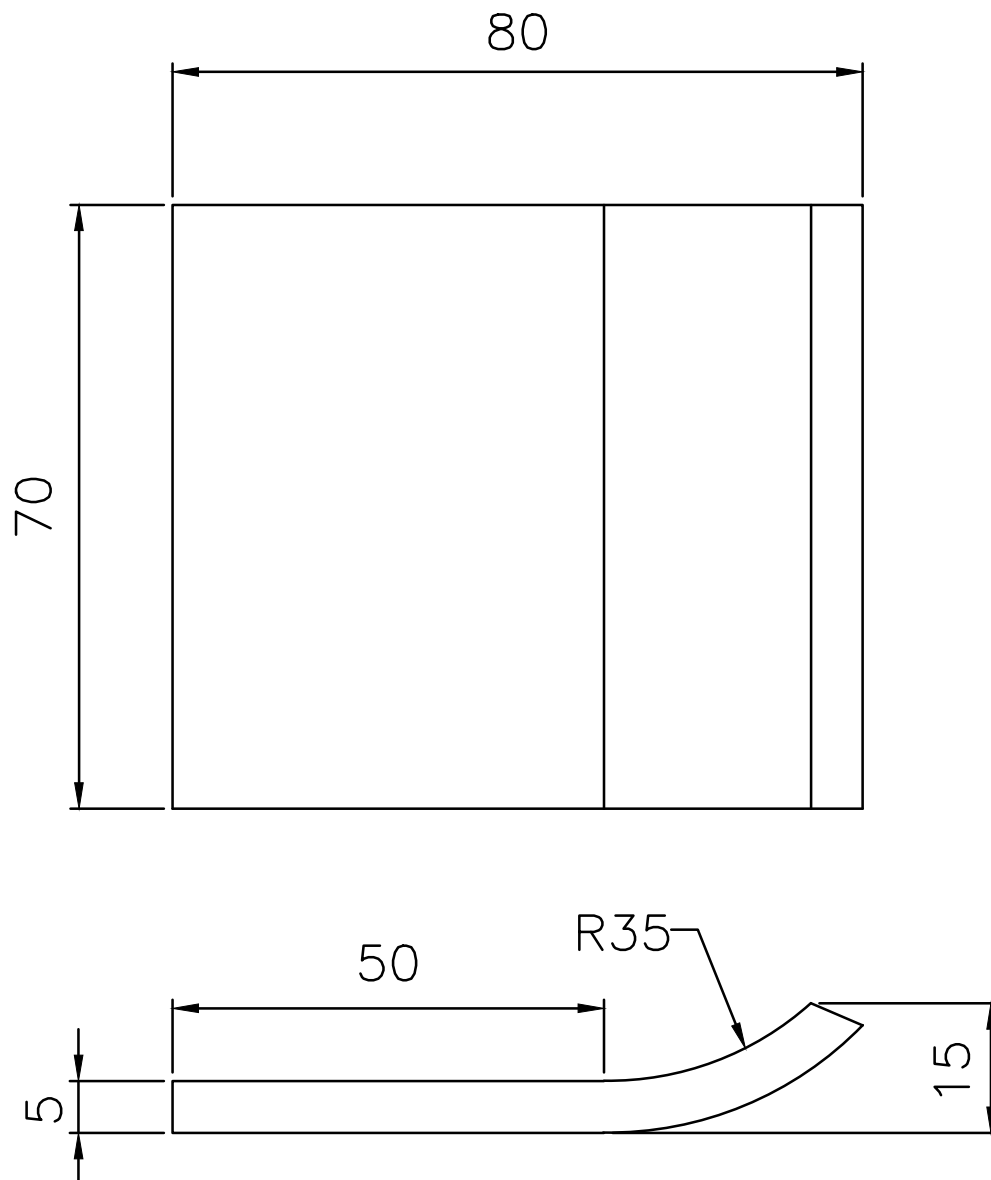
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3

2

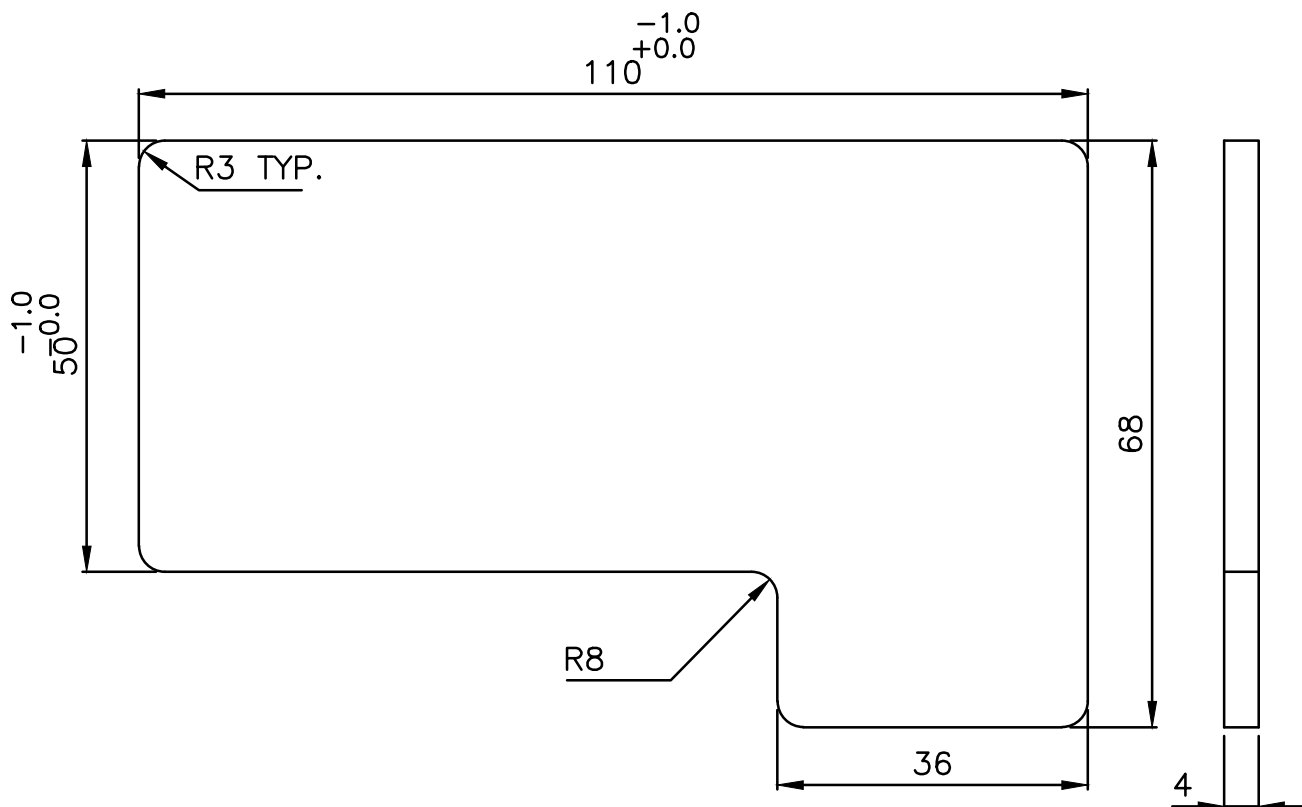
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SHEET 24 OF 86



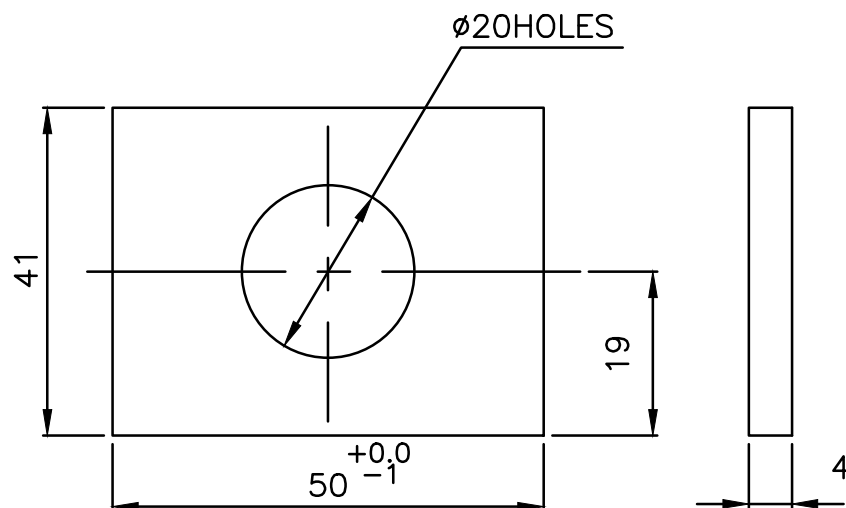
PROCESS: FORMING

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD(QA)
DRAWN	DATE	NAME	HDS		MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS			FINISH <i>AS PER ANNEXURE 'A' (GREY)</i>		
TRACED		JCD					
COMPARED			PRO.OFF.	PD	HEAT TREATMENT: NORMALIZED	APPROVED	
SCALE: NTS			OI/C D & S		QTY.: 2Nos.	HEAD (Q.A.)	
ALL DIMENSIONS IN MM			PLATE CHANNEL FABRICATED CHANNEL-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 01 18(ø)(b)	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM							

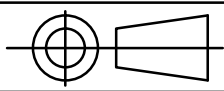


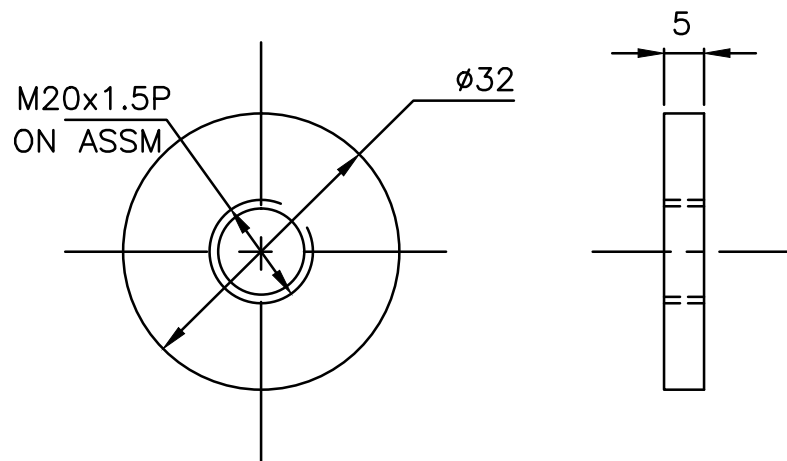
PROCESS : MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD	OI/C D&S	HEAD QA
DRAWN	DATE	NAME	HDS	MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS				
TRACED		JCD	PRO.OFF.	PD	APPROVED	
COMPARED				FINISH: AS PER ANNEXORE 'A' (GREY)	HEAD (Q.A.)	
SCALE: NTS				HEAT TREATMENT: <i>NORMLISED.</i>	DRG.No.	
ALL DIMENSIONS IN MM			OI/C D & S	QTY.: 1No.	ADRDE 1404 01 19(a)(b)	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 VERY COARSE			PLATE-J FABRICATED CHANNEL-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN 32 AIRCRAFT)			



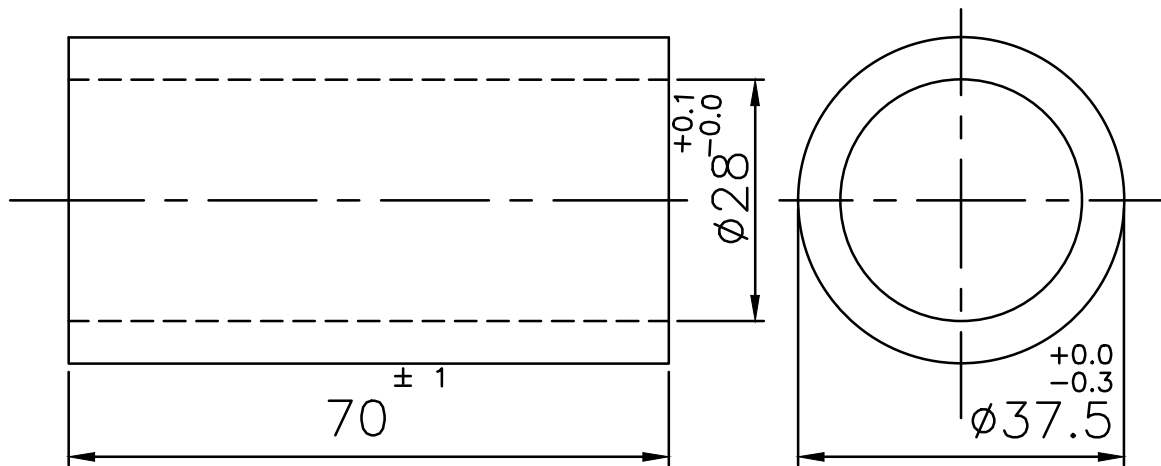
PROCESS: MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD(QA)
	DATE	NAME	HDS		MATERIAL: IS:961, St 55 HTW OR <i>ASTM A 516 Gr. 70</i>	ADRDE ; AGRA	
DRAWN		SKS	PRO. OFF.	PD	FINISH: <i>AS PER ANNEXURE 'A' (GREY)</i>		
CHECKED		JCD					
TRACED							
COMPARED			OI/C D & S		HEAT TREATMENT: NORMALISED	APPROVED	
SCALE: NTS					QTY.: 1No	HEAD(Q.A.)	
ALL DIMENSIONS IN MM							
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MED.			PLATE K FABRICATED CHANNEL-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				DRG.No. ADRDE 1404 01 20(ø)(b)



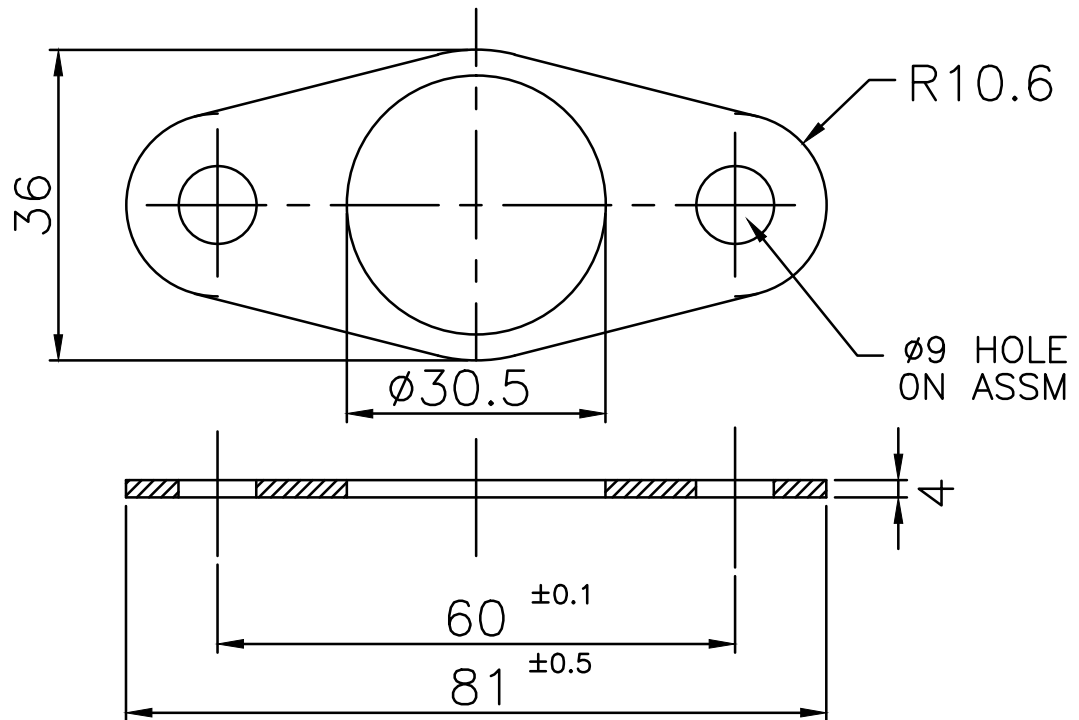
PROCESS:— MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD		OI/C	PGD
DRAWN	DATE	NAME	H D S		MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS	PRO.OFFR. PD		FINISH: <i>AS PER ANNEXURE 'A' (GREY)</i>		
TRACED		JCD					
COMPARED			D & S		HEAT TREATMENT: <i>NORMALIZED</i>	APPROVED	
SCALE: NTS			OI/C		QTY.: 1No.	HEAD (Q.A.)	
ALL DIMENSIONS IN MM						DRG.No.	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			BUSH SMALL FABRICATED CHANNEL-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			ADRDE 1404 01 21(ø)(b)	



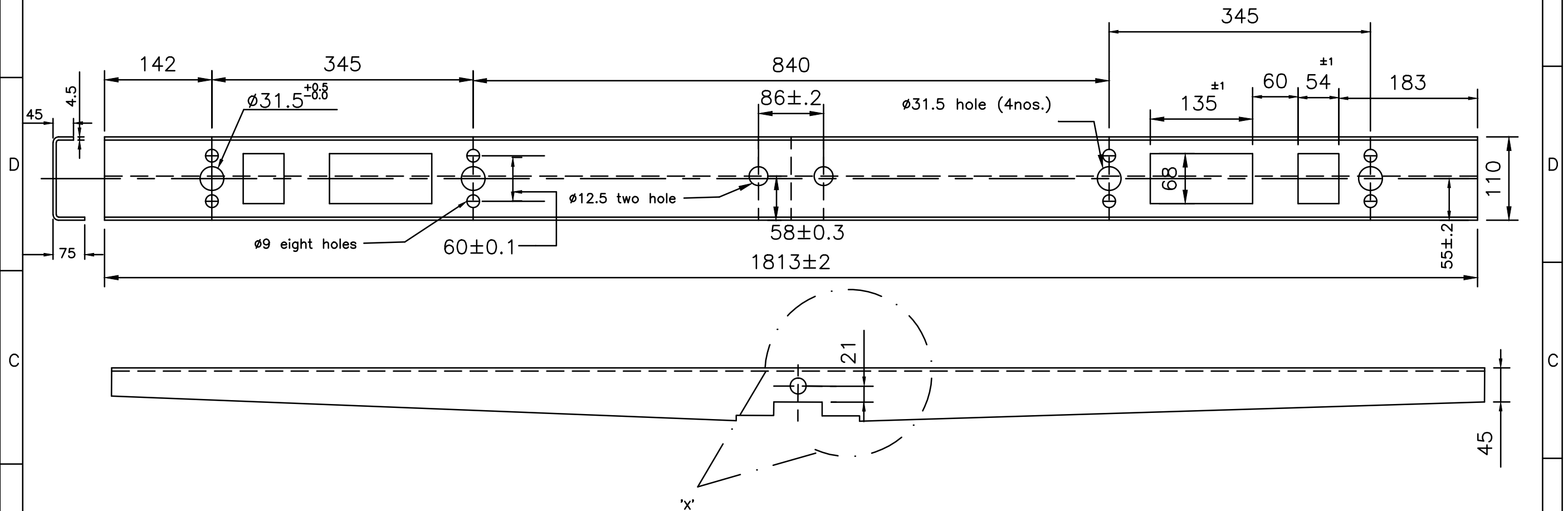
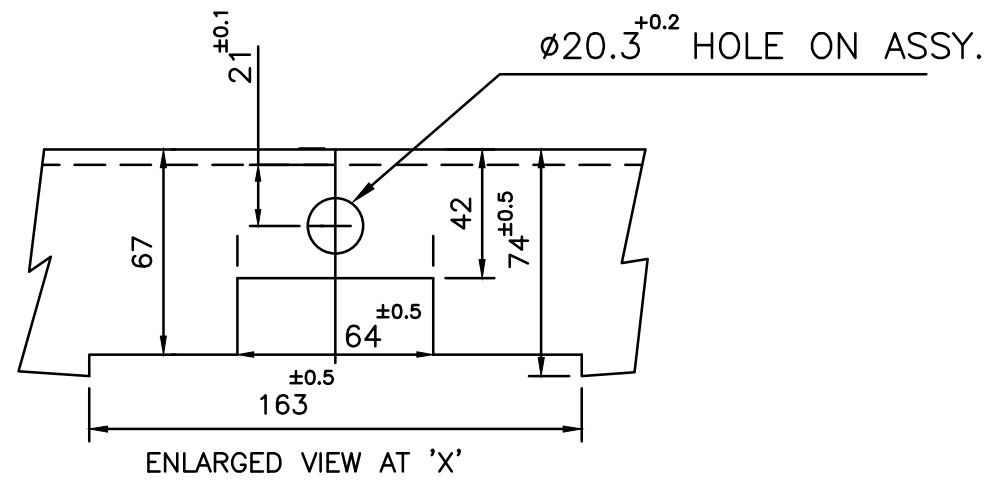
PROCESS :- MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD		OI/C D&S	HEAD(QA)	
	DATE	NAME	H D S		MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA		
DRAWN		SKS	PRO.OFF.	PD	FINISH: AS PER ANNEXURE 'A' (GRAY)			
CHECKED		JCD						
TRACED								
COMPARED			OI/C D & S		HEAT TREATMENT: NORMALIZED	APPROVED		
SCALE: NTS					QTY.: 2Nos.	HEAD (Q.A.)		
ALL DIMENSIONS IN MM								
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			BUSH LARGE FABRICATED CHANNEL-BEAM ASSEMBLY (HEAVY DROPPING SYSTM FOR AN-32 AIRCRAFT)				DRG.No. ADRDE 1404 01 22(a)(b)	

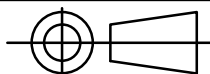


PROCESS :- MACHINING

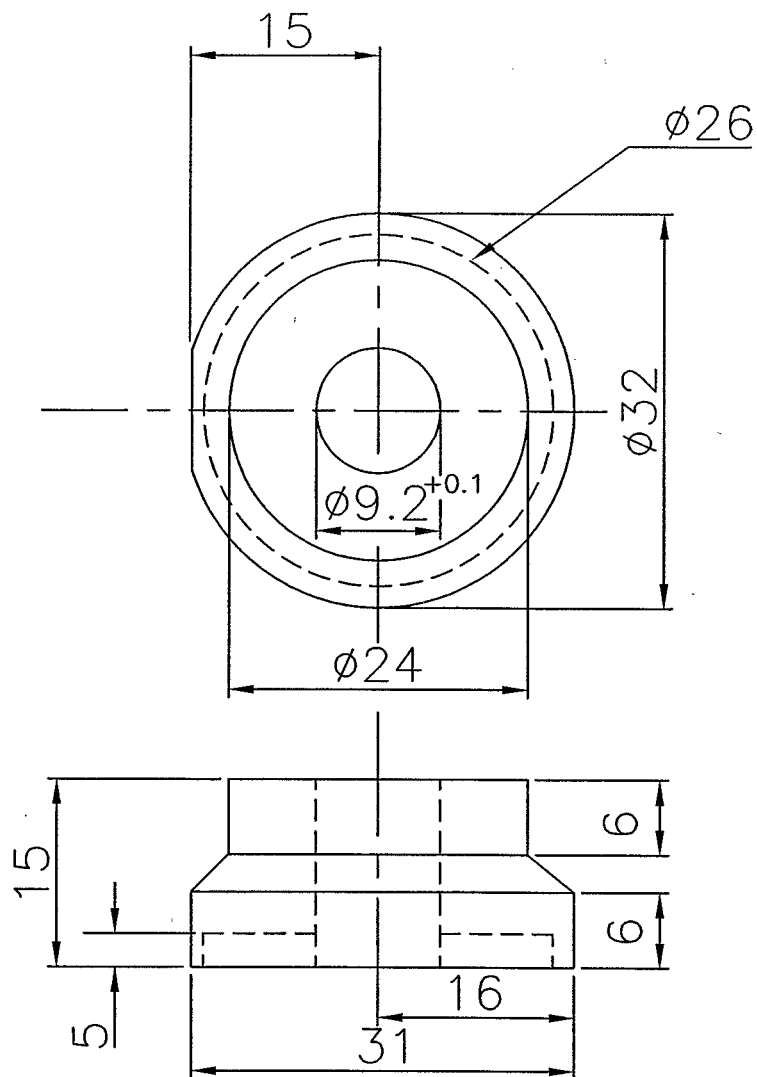
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD(QA)
DRAWN	DATE	NAME	H D S		MATERIAL: IS:961, St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS	PRO.OFF. PD		FINISH: AS PER ANNEXURE 'A'		
TRACED		JCD			HEAT TREATMENT: NORMALIZED		
COMPARED			OI/C D & S		QTY.: 4Nos.	APPROVED	
SCALE: NTS					HEAD (Q.A.)		
ALL DIMENSIONS IN MM			SUPPORT PLATE FABRICATED CHANNEL-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				DRG.No. ADRDE 1404 01 23(ø)(b)
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM							



PROCESS:FABRICATION

	DATE	NAME	H D S		MATERIAL: IS:961,St 55 HTW OR ASTM A 516 Gr.70	ADRDE ; AGRA
DRAWN		SKS	PRO.OFF.	PD	FINISH: AS PER ANNEXURE'A' (GREY)	
CHECKED		JCD				
TRACED					OI/C D & S	
COMPARED			QTY.: 1No.	HEAD(Q.A.)		
SCALE: NTS			CHANNEL FABRICATED CHANNEL— BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN—32 AIRCRAFT)			DRG.No. ADRDE 1404 01 01 (d)(b)
ALL DIMENSIONS IN MM						
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 VERY COARSE						

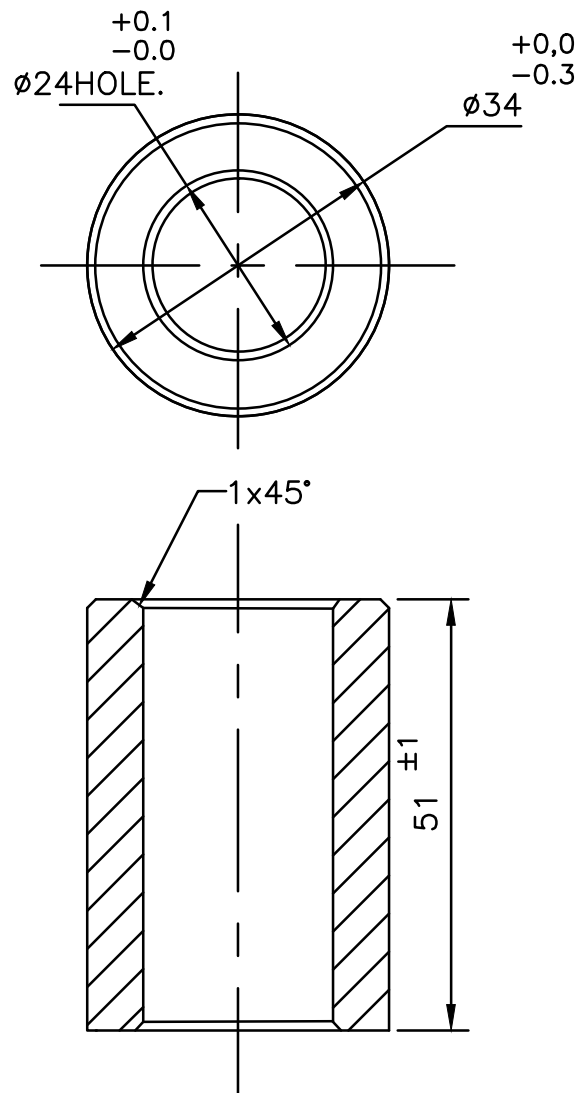
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	OI/C D&S	HEAD(QA)
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NOTE- THIS PART TO BE WELDED
WITH CHANNEL AS SHOWN IN SHEET NO-2

PROCESS : MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	OI/C D&S	HEAD(QA)
DRAWN	DATE	NAME	H D S	MATERIAL: IS:961, St 55 HTW OR ASTM A 516 Gr.70	ADRDE ; AGRA	
CHECKED		SKS	 PRO.OFF. PD	FINISH:		
TRACED		JCD		AS PER ANNEXURE 'A' (GREY)		
COMPARED			OI/C D & S	HEAT TREATMENT:	APPROVED	
SCALE: NTS				NORMALIZED	 HEAD (Q.A.)	
ALL DIMENSIONS IN MM				QTY.: 2Nos.	DRG.No.	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			BUSH SUPPORT FABRICATED CHANNEL-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			ADRDE 1404 01 24 (e)(b)(C)

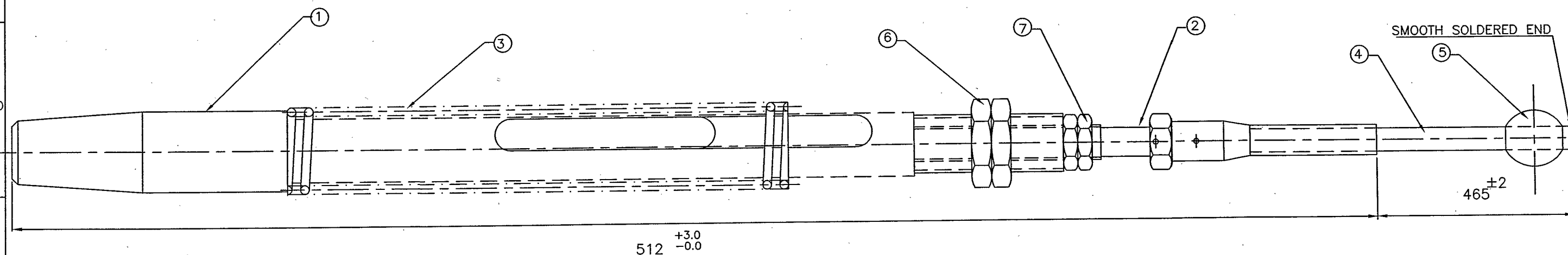


PROCESS: MACHINING

Ref. No.	DATE	ZONE	AUTHORITY		BREIF RECORD		OI/C D&S	HEAD(QA)
	DATE	NAME	HDS		MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>		ADRDE ; AGRA	
DRAWN		SKS	PRO.OFF.	PD	FINISH: <i>AS PER ANNEXURE 'A'</i>			
CHECKED		JCD			HEAT TREATMENT: NORMALIZED		APPROVED	
TRACED					QTY.: 2Nos.		HEAD (Q.A.)	
COMPARED			OI/C D & S				DRG.No.	
SCALE: NTS								
ALL DIMENSIONS IN MM								
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			BUSH MEDIUM FABRICATED CHANNEL-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				ADRDE 1404 01 25(g)(b)	

7	IS:4218	HEX-NUT M12	2	—
6	IS:4218	HEX-NUT M20	2	—
5	ADRDE 1404 02 05	ROPE END	2	36
4	CONST 7x19 (WITH STEEL CORE) AS PER GOST 2172-80 (OR EQUIVALENT) ROPE DIA-8 mm GALVENIZED WIRE; RIGHT HAND LAY-REGULAR	ROPE	2	—
3	ADRDE 1404 02 03	SPRING	2	35
2	ADRDE 1404 02 02	PIN SMALL	2	34
1	ADRDE 1404 02 01	PIN LARGE	2	33
SR.NO	DRG./SPEC.NO.	DESCRIPTION	QTY	SHEET NO

DETAIL INDEX

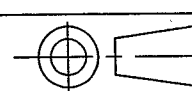
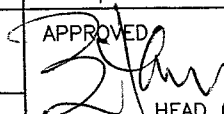


TESTING : Wire rope assy (i.e pin small, wire rope, ball 5) to be tested for 1000 kgf to check any slippage at BALL & PIN end crimping etc.

TESTING METHOD : Threaded fixture at one end and slotted fixture at ball end may be used for testing. Any other suitable method may also be adopted in consultation with ADRDE Agra.

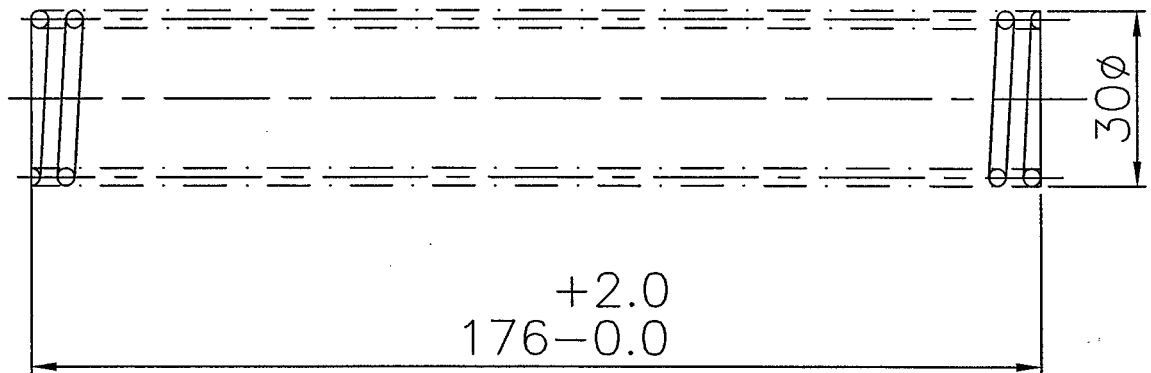
Seperate cut for Right & Left key.

PROCESS :- FABRICATION

	DATE	NAME	H D S		MATERIAL:	ADRDE ; AGRA
DRAWN		SKS	 PRO.OFF. PD			
CHECKED		JCD			FINISH:	
TRACED					HEAT TREATMENT:	
COMPARED			OI/C D & S		QTY.2NOS.	APPROVED  HEAD (Q.A.)
SCALE: NTS					DRG.No.	
ALL DIMENSIONS IN MM			SUB ASSY. LARGE PIN			1404 02 (a)(b)(c)
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 VERY COARSE			FABRICATED CHANNEL-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	OI/C D&S	HEAD(QA)

(3)



No OF TURNS = 21

ACTIVE COIL = 19

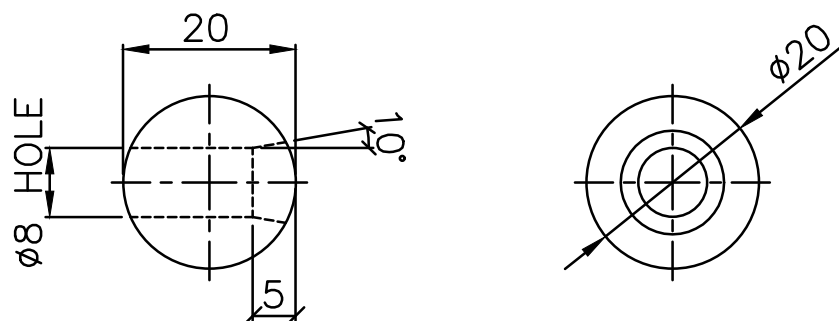
WIRE DIA = 3

STIFFNESS = 0.23 $\pm$ 0.002kg/mm

PROCESS : FABRICATION

END CONDITION SQUIRE & GROUND

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S		MATERIAL: <i>SPRING STEEL AS PER IS:4454 (PART-2) GR-FDCrV-A</i>	ADRDE ; AGRA	
CHECKED		SKS	 PRO.OFF. PD		FINISH: NATURAL	 APPROVED HEAD (Q.A.)	
TRACED		JCD					
COMPARED			OI/C D & S		HEAT TREATMENT:	DRG.No. ADRDE 1404 02 03(a)(b)(c)	
SCALE: NTS					OIL HARDENED & TEMPERED		
ALL DIMENSIONS IN MM					QTY.2Nos		
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 VERY COARSE			SPRING SUB. ASSY.LARGE PIN-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				



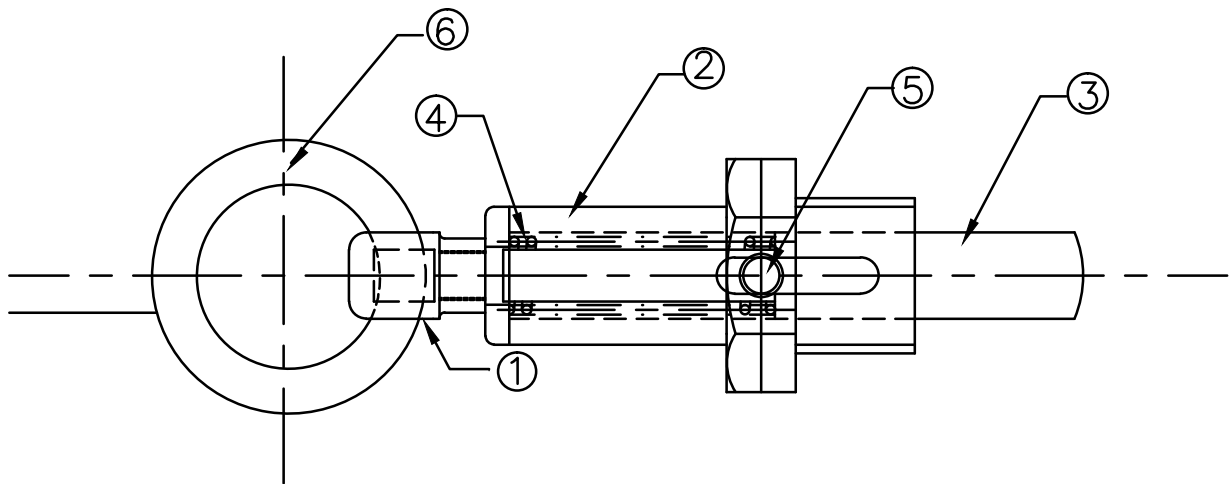
PROCESS : MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD		OI/C D&S	HEAD (QA)
DRAWN	DATE	NAME	H D S		MATERIAL:	ADRDE ; AGRA	
CHECKED		SKS			<i>AUSTENITIC STAINLESS STEEL</i>		
TRACED		JCD			<i>04Cr18Ni10, AS PER IS:6527-1972</i>		
COMPARED			PRO.OFFR.	PD	FINISH:	NATURAL	APPROVED
SCALE: NTS					HEAT TREATMENT:		HEAD (Q.A.)
ALL DIMENSIONS IN MM					ANNEALING/SOFTENING		
					192±3 BHN		
TOLERANCE:					QTY. 2 Nos		DRG.No.
UNLESS OTHERWISE SPECIFIED							
IS:2102(PART1) :1993							
MEDIUM							

ROPE END
SUB. ASSY.LARGE PIN-BEAM ASSEMBLY
(HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)

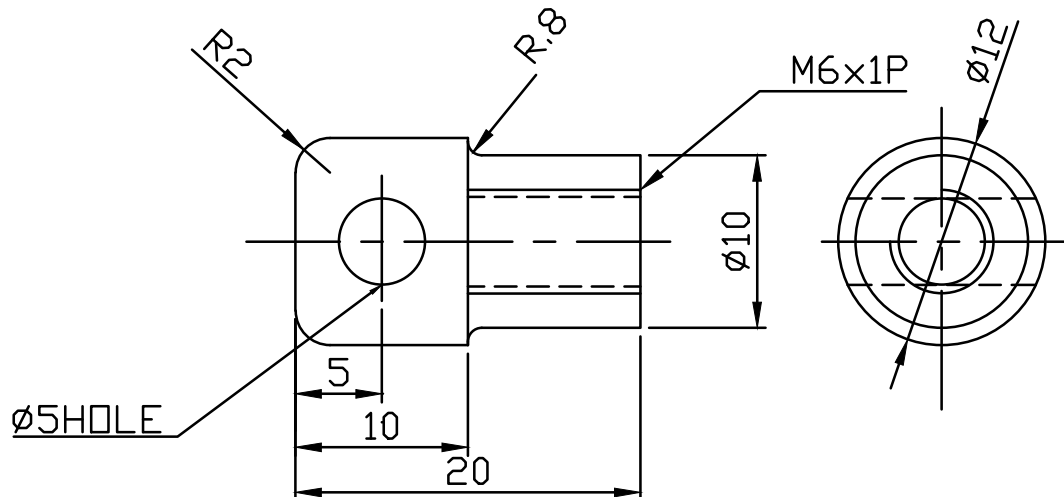
4	3	2	1	
				SHEET 37 OF 86
6	ADRDE 1404 03 06	RING	1	43
5	ADRDE 1404 03 05	GRUB SCREW	1	42
4	ADRDE 1404 03 04	SPRING	1	41
3	ADRDE 1404 03 03	GUIDE	1	40
2	ADRDE 1404 03 02	PIN	1	39
1	ADRDE 1404 03 01	HOOK	1	38
SR.NO.	DRG/SPEC.NO.	DESIGNATION	QTY	SHEET NO.

DETAIL INDEX



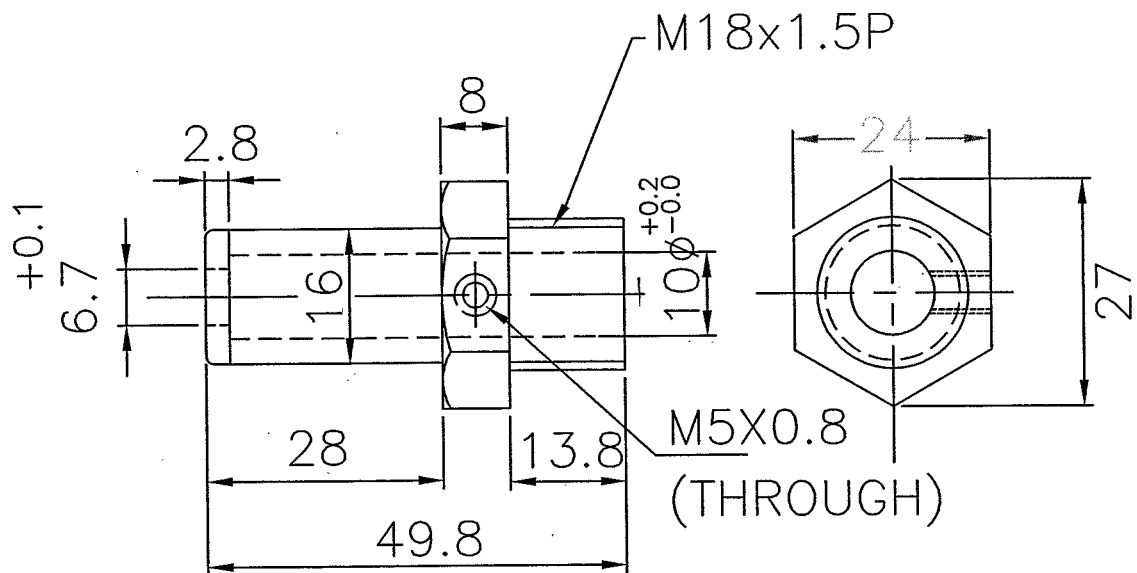
PROCESS : FABRICATION

Ref. No.		DATE	ZONE	AUTHORITY		BRIEF RECORD		OI/C D&S	HEAD (Q.A.)
		DATE	NAME	H D S		MATERIAL:		ADRDE ; AGRA	
DRAWN			SKS	PRO.OFF. PD		FINISH:			
CHECKED			JCD						
TRACED									
COMPARED				OI/C D & S		HEAT TREATMENT:		APPROVED	
SCALE: NTS						QTY.: 2Nos.		HEAD (Q.A.)	
ALL DIMENSIONS IN MM									
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 VERY COARSE				HOOK(LOCATER) SUB ASSEMBLY BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				DRG.No. ADRDE 1404 03 (a)(b)	

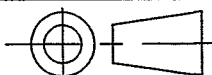


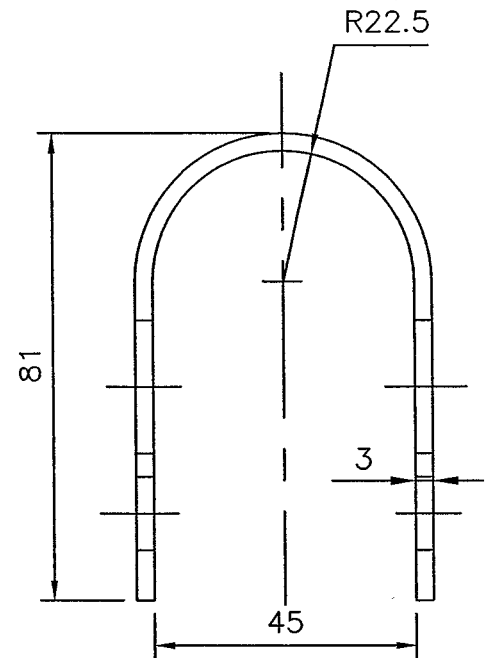
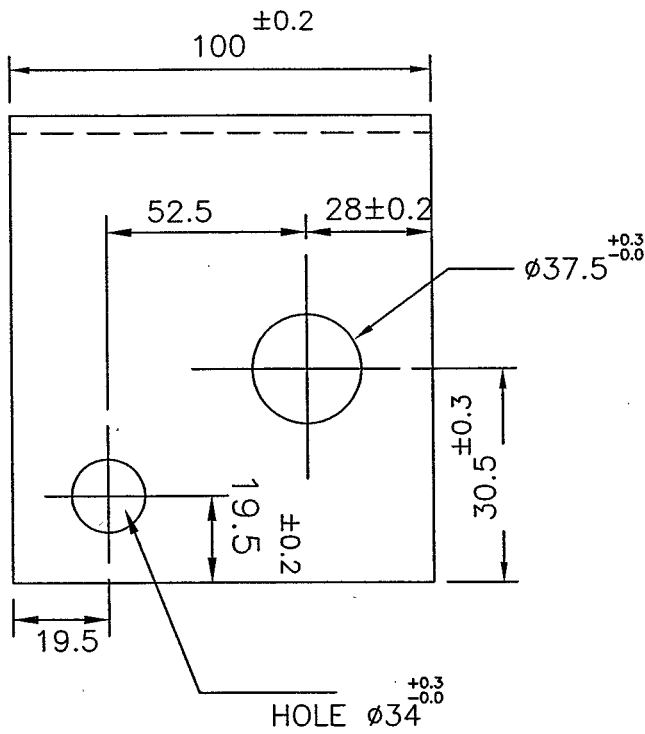
PROCESS : MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S		MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS			FINISH: AS PER ANNEXURE 'C' Cd PLATED & Cr PASSIVATED.		
TRACED		JCD					
COMPARED			PRO.OFF.	PD	HEAT TREATMENT:	APPROVED	
SCALE: NTS					NORMALIZED	HEAD (Q.A.)	
ALL DIMENSIONS IN MM			OI/C D & S		QTY.2Nos.(L+R)	DRG.No.	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			HOOK,HOOK(LOCATER) SUB ASSEMBLY BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				ADRDE 1404 03 01(ø)(b)

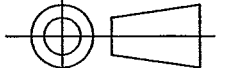


PROCESS : MACHINING

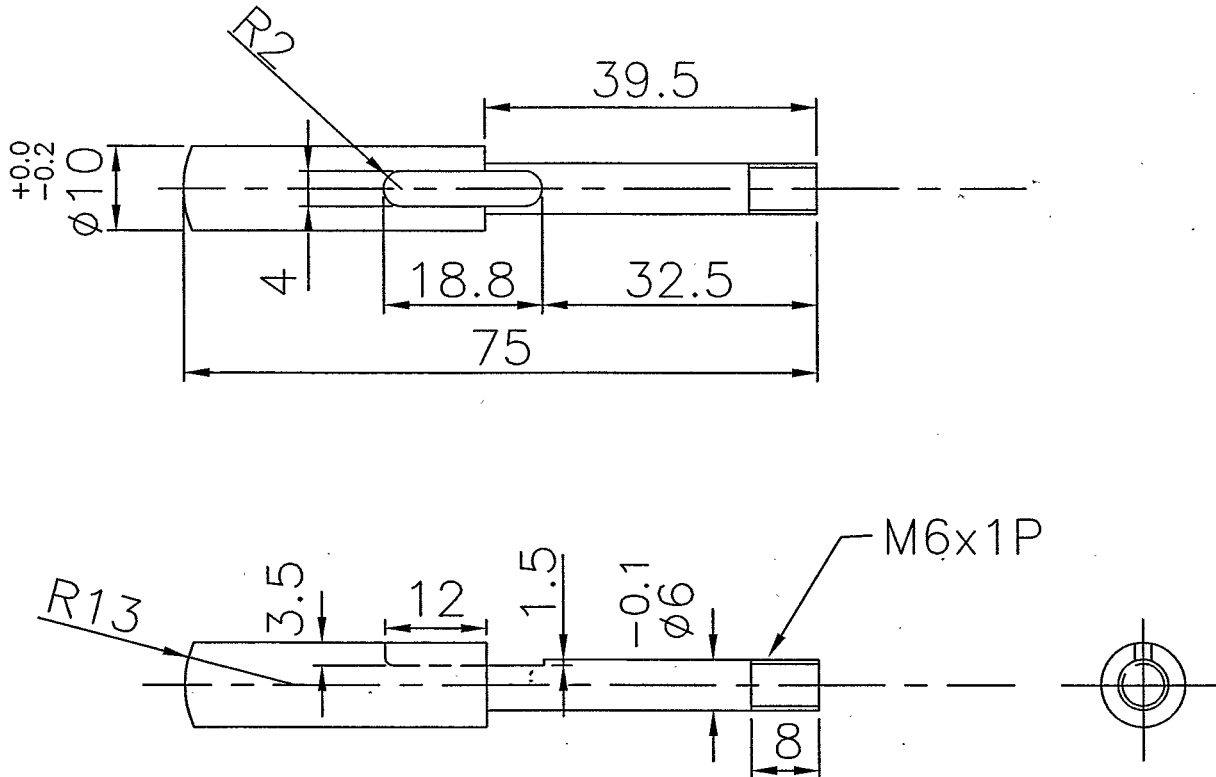
Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD	OI/C D&S	HEAD QA
	DATE	NAME	H D S	MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
DRAWN		SKS	 PRO.OFF. PGD	FINISH: <i>AS PER ANNEXURE 'C'</i>		
CHECKED		JCD		HEAT TREATMENT:		
TRACED				<i>NORMALIZED</i>		
COMPARED			OI/C D & S	QTY.: 2Nos.	APPROVED  HEAD (Q.A.) DRG.No.	
SCALE: NTS				PIN HOOK (LOCATER) SUB.ASSY..-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)	ADRDE 1404 03 02(01)(C)	
ALL DIMENSIONS IN MM						
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM						



PROCESS :- FORMING

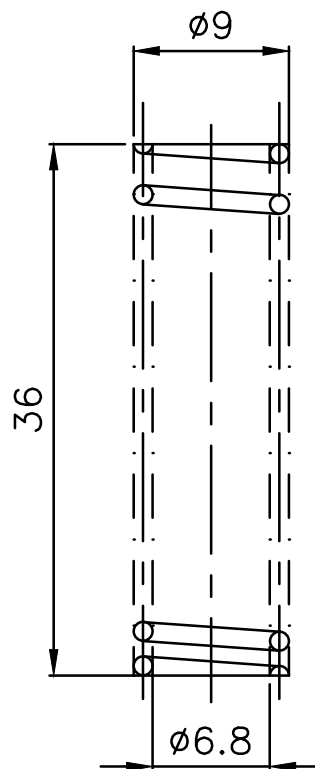
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OIC D&S	HEAD(Q.A.)
	DATE	NAME	H D S		MATERIAL: IS:961, St 55 HTW OR ASTM A 516 Gr.70	ADRDE ; AGRA	
DRAWN		SKS	 PROJ. OFFICER PD		FINISH: AS PER ANNEXURE'A' (GREY)		
CHECKED		JCD					
TRACED							
COMPARED			OI/C D & S		HEAT TREATMENT: NORMALIZED	APPROVED	
SCALE: NTS					QTY.: 2Nos.	 HEAD(Q.A.)	
ALL DIMENSIONS IN MM							
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			U' PLATE FABRICATED CHANNEL- BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 01 02(2/2) (C)	

3



PROCESS : MACHINING

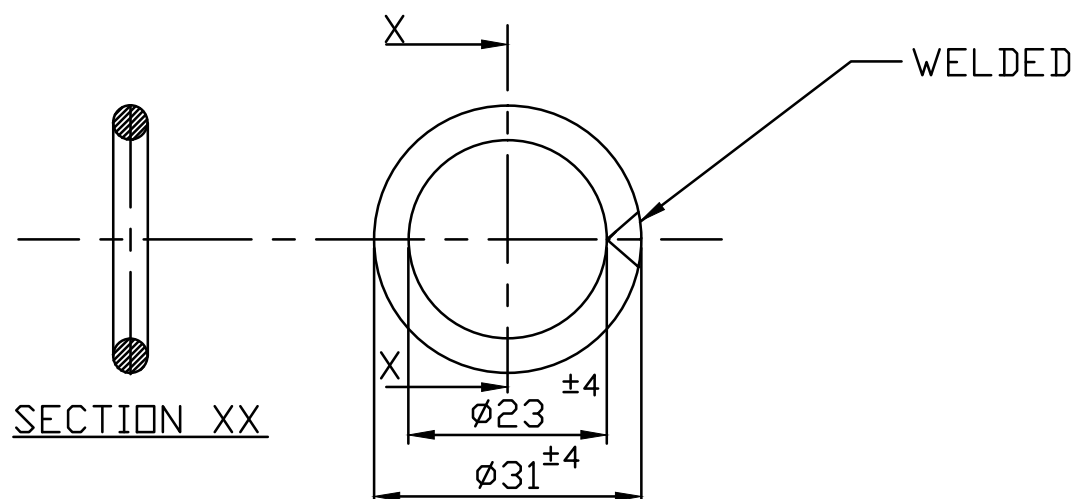
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD Q.A	
	DATE	NAME	H D S		MATERIAL: EN 19/24	ADRDE ; AGRA		
DRAWN		SKS			FINISH: AS PER ANNEXURE 'C'			
CHECKED		JCD						
TRACED								
COMPARED					HEAT TREATMENT: 32±4HRC			
SCALE: NTS					OI/C D & S			QTY.: 2Nos.
ALL DIMENSIONS IN MM								
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS: 2102(PART 1) : 1993 MEDIUM			GUIDE HOOK(LOCATER) SUB.ASSY.-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 03 03(a)(b)(c)		



DIAMETER OF WIRE : 1.1mm
 NOS. OF COILS = 15
 NOS. OF ACTIVE COILS=13
 STIFFNESS = 0.27 kgf/mm

PROCESS : FABRICATION

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S		MATERIAL: STAINLESS SPRING SPRING WIRE	ADRDE ; AGRA	
CHECKED		SKS			IS : 4454 : 1975(PART-IV) GR.1		
TRACED		JCD			FINISH: NATURAL		
COMPARED			PRO.OFF.	PD	HEAT TREATMENT:	APPROVED	
SCALE: NTS					NORMALIZED	HEAD (Q.A.)	
ALL DIMENSIONS IN MM					QTY.:2Nos.	DRG.No.	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			SPRING HOOK(LOCATER)-SUB.ASSY.BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				ADRDE 1404 03 04(d)(b)



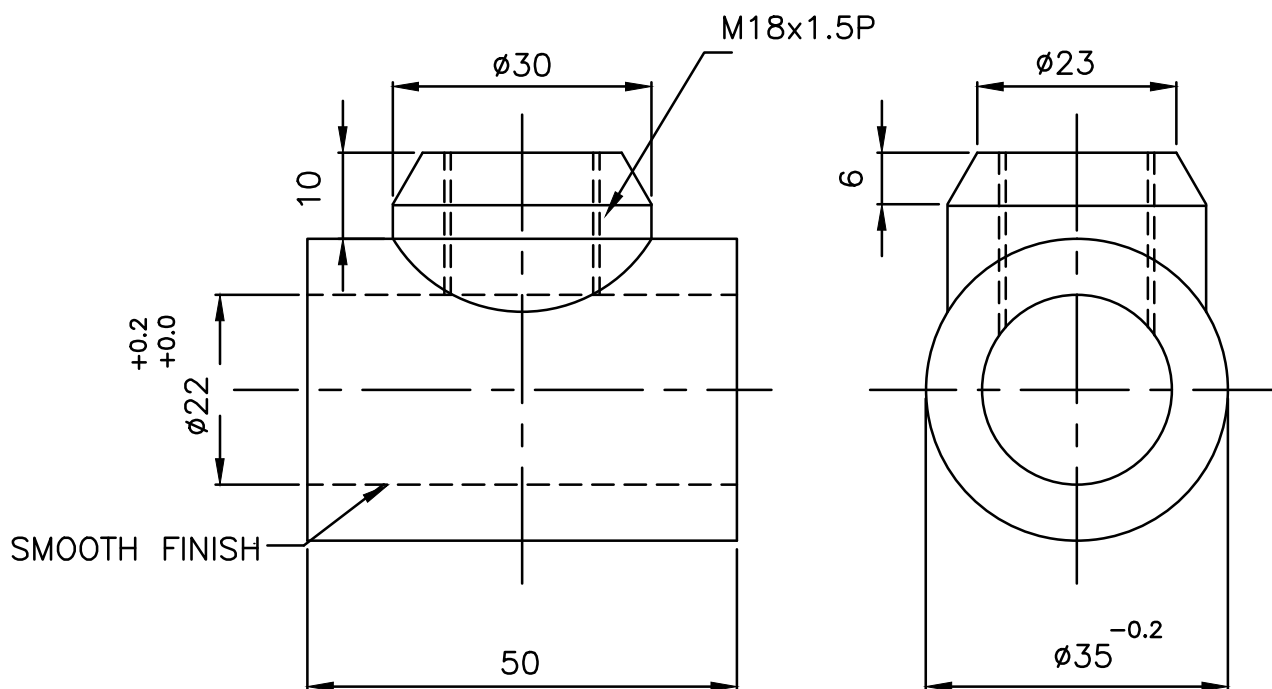
NOTE:— WELDING MAY BE CARRIED OUT AFTER ASSEMBLY WITH HOOK

WELDING :

ALL WELDED JOINTS SHOULD BE WELDED BY ELECTRODES CONFORMING TO ADVANI OERLIKON SUPERCITO AWS/SFA 5.1—E7018 ISEB—5426 H3Jx OR ITS EQUIVALENT. WELDED JOINTS SHOULD BE TESTED BY DYE PENETRATION TEST (IS: 3658) BEFORE FINISH .

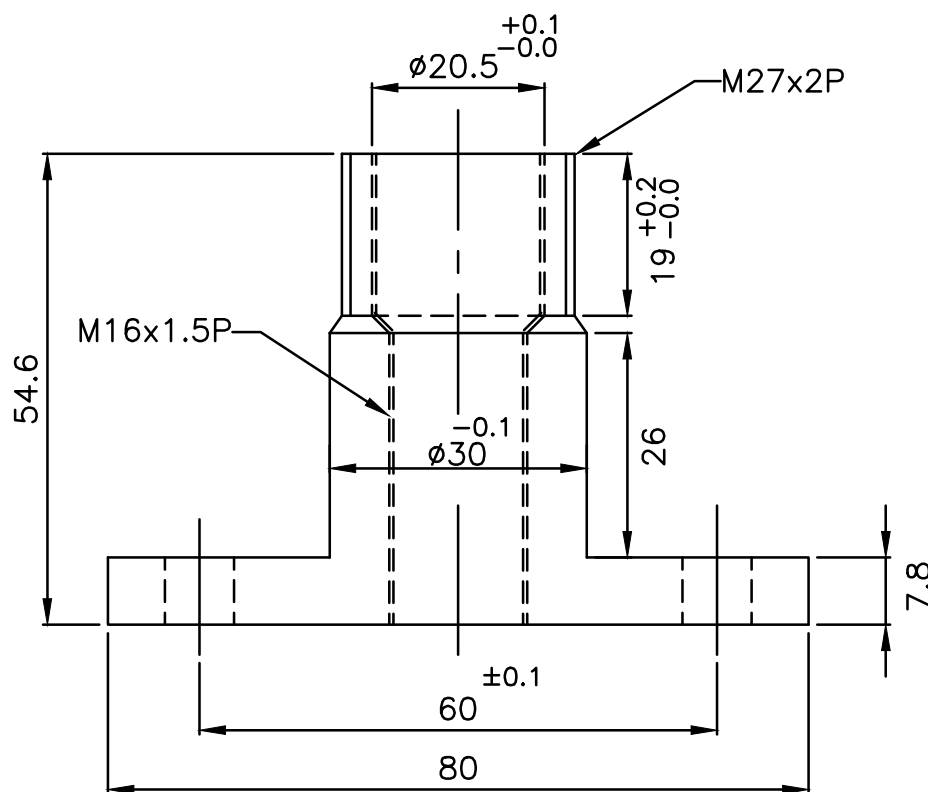
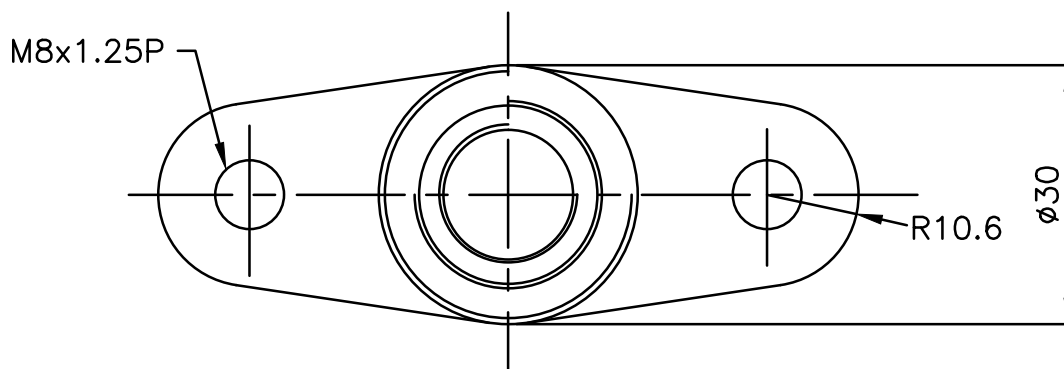
PROCESS : FABRICATION

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD (Q.A.)		
	DATE	NAME	H D S		MATERIAL: IS:961, St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA			
DRAWN		SKS	PRO.OFF.		PD	FINISH: AS PER ANNEXURE 'C'			
CHECKED		JCD							
TRACED									
COMPARED			OI/C D & S		HEAT TREATMENT: NORMALIZED	APPROVED			
SCALE: NTS						QTY. 2Nos		HEAD (Q.A.)	
ALL DIMENSIONS IN MM									
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			RING HOOK (LOCATER). SUB.ASSY.—BEAM ASSEMBLY (HEAVY DROPPING SYSTEM AN—32 AIRCRAFT)				DRG.No. ADRDE 1404 03 06(a)(b)		

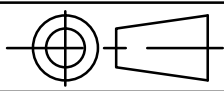


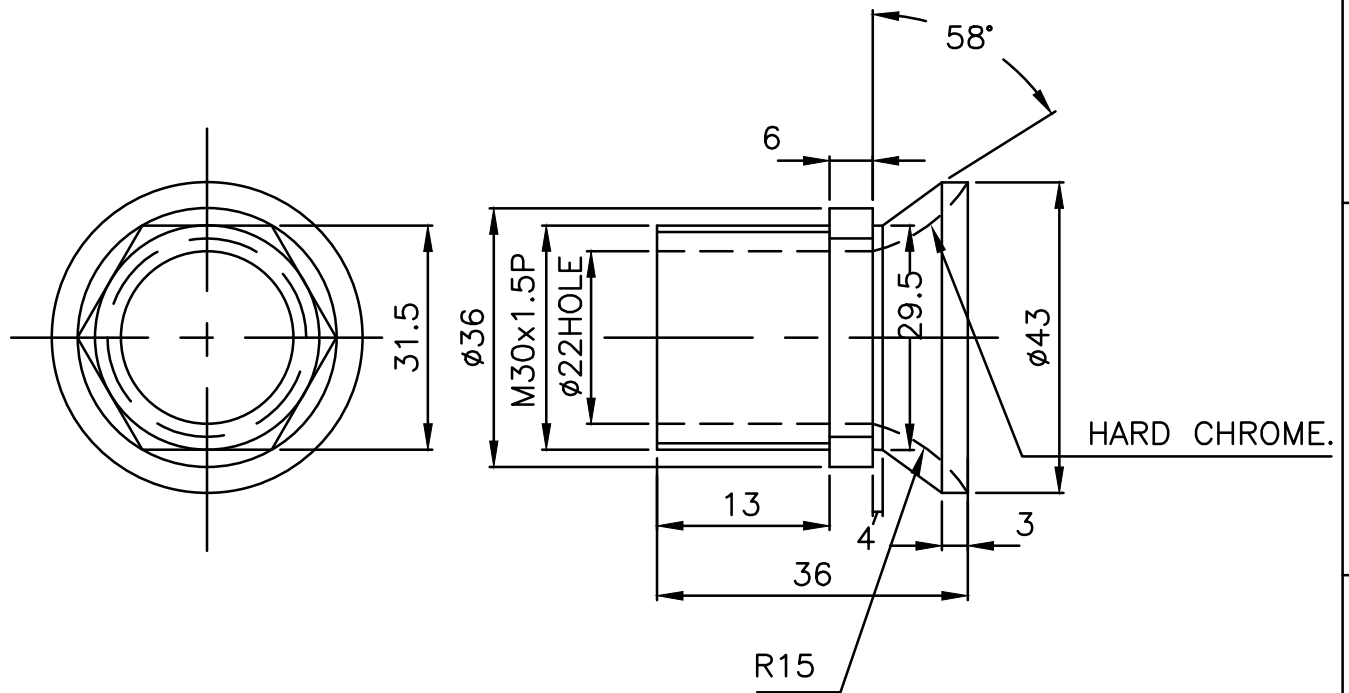
PROCESS : MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S		MATERIAL: IS:961, St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS			FINISH: <i>AS PER ANNEXURE 'A'</i>		
TRACED		JCD					
COMPARED			PRO.OFF.	PD	HEAT TREATMENT:	APPROVED	
SCALE: NTS					<i>NORMALIZED</i>		
ALL DIMENSIONS IN MM					QTY.: 2Nos.	HEAD (Q.A.)	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			BUSH BLOCK BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				DRG.No. ADRDE 1404 04(ø)(b)



PROCESS : MACHINING

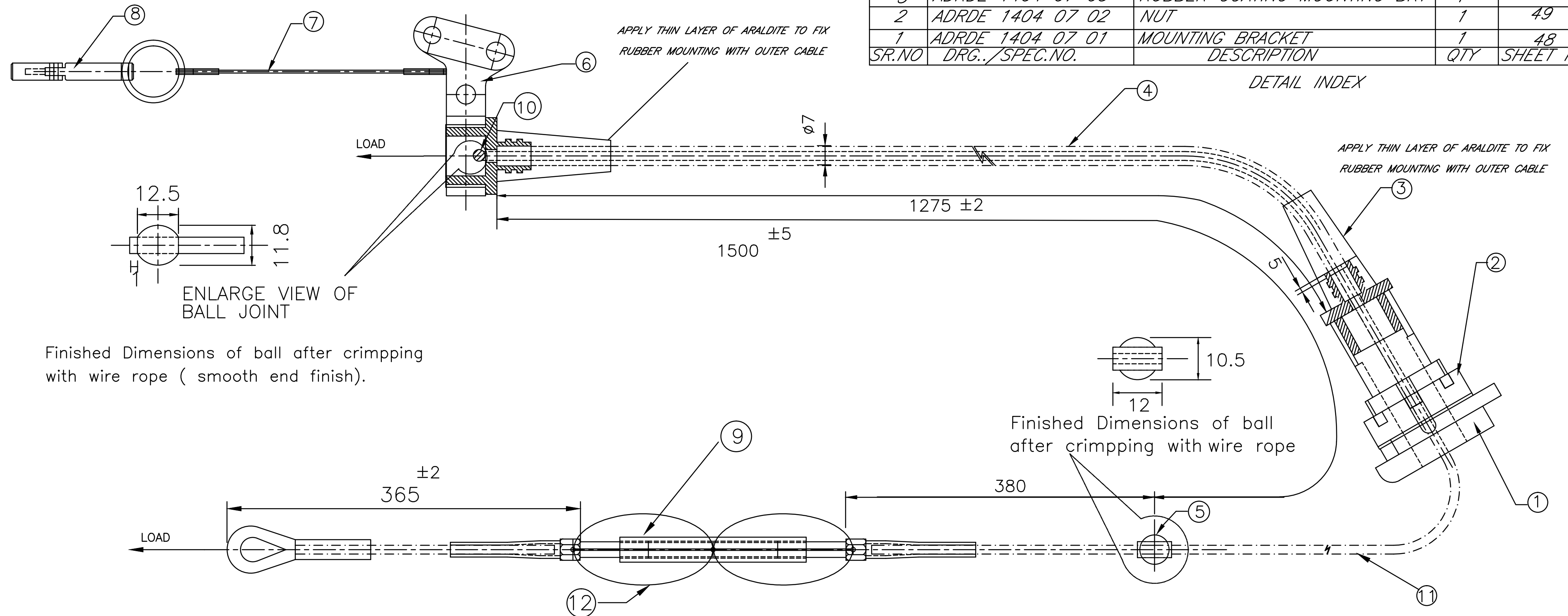
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S		MATERIAL: IS:961, St 55 HTW OR ASTM A 516 Gr.70	ADRDE ; AGRA	
CHECKED		SKS			FINISH: AS PER ANNEXURE 'C'		
TRACED		JCD					
COMPARED			PRO.OFF.	PD	HEAT TREATMENT: NORMALIZED	APPROVED	
SCALE: NTS					QTY.: 4Nos.	HEAD (Q.A.)	
ALL DIMENSIONS IN MM			OI/C D & S				
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			'T' BRACKET BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				DRG.No. ADRDE 1404 05(ø)(b)



PROCESS : MACHINING

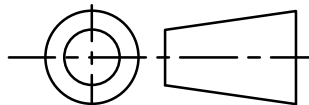
Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD		OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S		MATERIAL: IS:961, St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS			FINISH: Ni-Cr PLATING AS PER IS 1068 Gr 3 (min. 12 micron) HARD CHROMIUM(12-15 micron) AS PER IS 1337 (AT SPECIFIED LOCATION)		
TRACED		JCD					
COMPARED			PRO.OFF.	PD	HEAT TREATMENT:	APPROVED	
SCALE: NTS					<i>NORMALIZED</i>	HEAD (Q.A.)	
ALL DIMENSIONS IN MM			OI/C D & S		QTY.: 2Nos.	DRG.No.	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			GUIDE BUSH-ROPE BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				ADRDE 1404 06(ø)(b)

12	_____	LOCKING WIRE (G.I.) 1mm Ø	1m	
11	IS 3459 -1977	WIRE ROPE Ø3 AS SPECIFIED *	1	
10	ADRDE 1404 07 10	STEEL BALL	1	70
9	ADRDE 1404 07 09	WIRE JOINING SUB ASSEMBLY	1	65-69
8	ADRDE 1404 07 08	LOCKING PIN	1	59-64
7	ADRDE 1404 07 07	PIN ARMING WIRE	1	58
6	ADRDE 1404 07 06	BRACKET SUB. ASSEMBLY	1	53-57
5	ADRDE 1404 07 05	STEEL BALL	1	52
4	ADRDE 1404 07 04	OUTER CABLE	1	51
3	ADRDE 1404 07 03	RUBBER COATING MOUNTING BKT	1	50
2	ADRDE 1404 07 02	NUT	1	49
1	ADRDE 1404 07 01	MOUNTING BRACKET	1	48
SR.NO	DRG../SPEC.NO.	DESCRIPTION	QTY	SHEET NO.

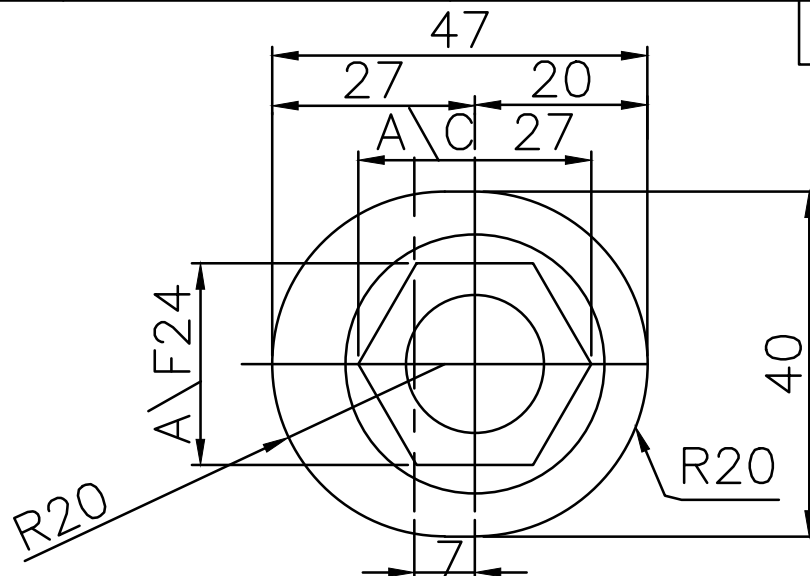


* WIRE ROPE GALVANIZED 6/19 (WSC) CONSTRUCTION 3 mm $\varnothing$
(MINIMUM BREAKING LOAD 540 kg) CONFORMING TO IS:3459-1977.

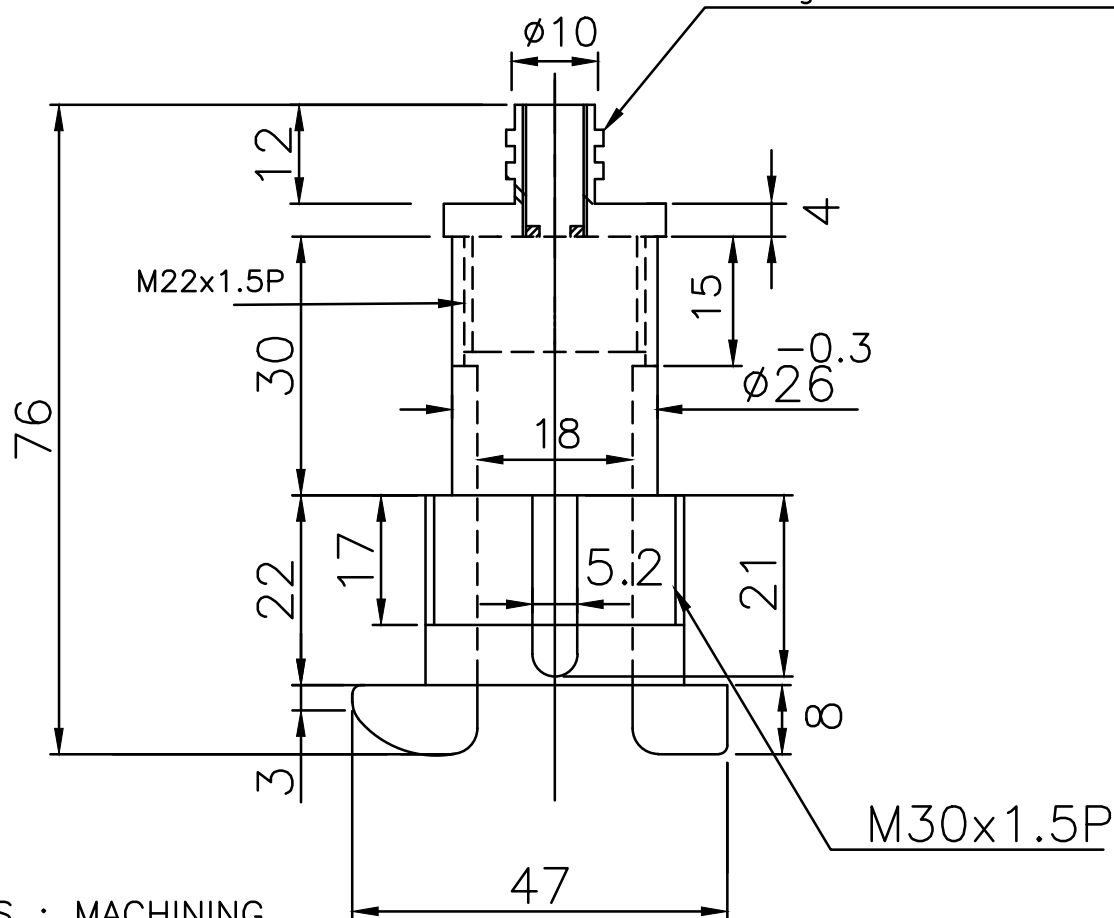
PROOF LOAD TESTING OF WIRE ROPE ASSEMBLY AND CRIMPING
AS SHOWN ABOVE 200 Kgf
PROCESS : FABRICATION

	DATE	NAME	H D S		MATERIAL:	ADRDE ; AGRA
DRAWN		SKS	PRO.OFFR.	PD		
CHECKED		JCD				
TRACED						
COMPARED			OI/C D & S		FINISH:	APPROVED
SCALE: NTS		HEAT TREATMENT:				
ALL DIMENSIONS IN MM		QTY: 1Nos.				
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 VERY COARSE			ROPE SUB. ASSEMBLY BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 07(ø)(b)

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	OI/C D&S	HEAD C



Part Drg. No. 1404 07 06 03

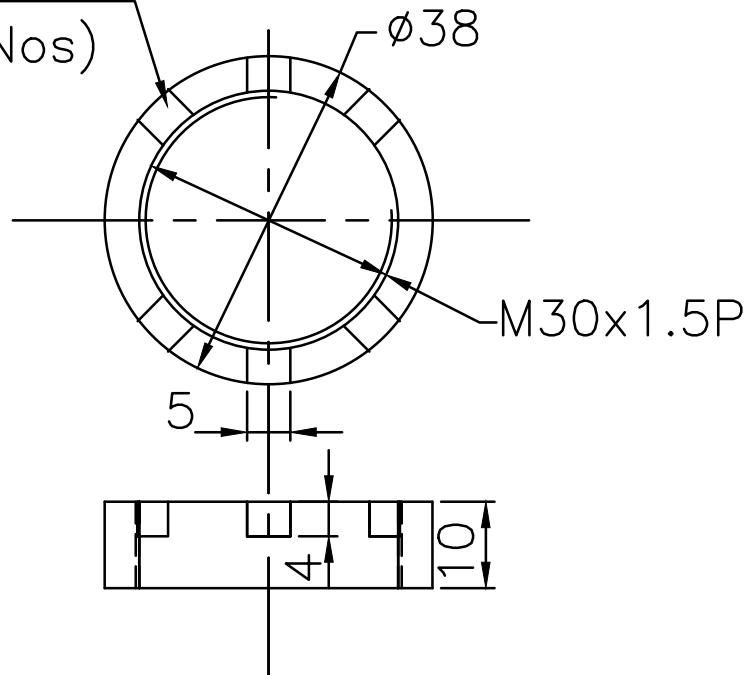


PROCESS : MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD			OI/C D&S HEAD QA
	DATE	NAME	H D S		MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>		ADRDE ; AGRA
DRAWN		SKS	PRO.OFF.	PD			
CHECKED		JCD					
TRACED							
COMPARED							
SCALE: NTS			OI/C D & S		HEAT TREATMENT: <i>NORMALIZED</i>		APPROVED
ALL DIMENSIONS IN MM					QTY.: 1 No.		
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			MOUNTING BRACKET ROPE SUB.ASSEMBLY—BEAM ASSEMBLY (HEAVY DROPPING SYSTEM AN—32 AIRCRAFT)				DRG.No. ADRDE1404 07 01(ø)(b)

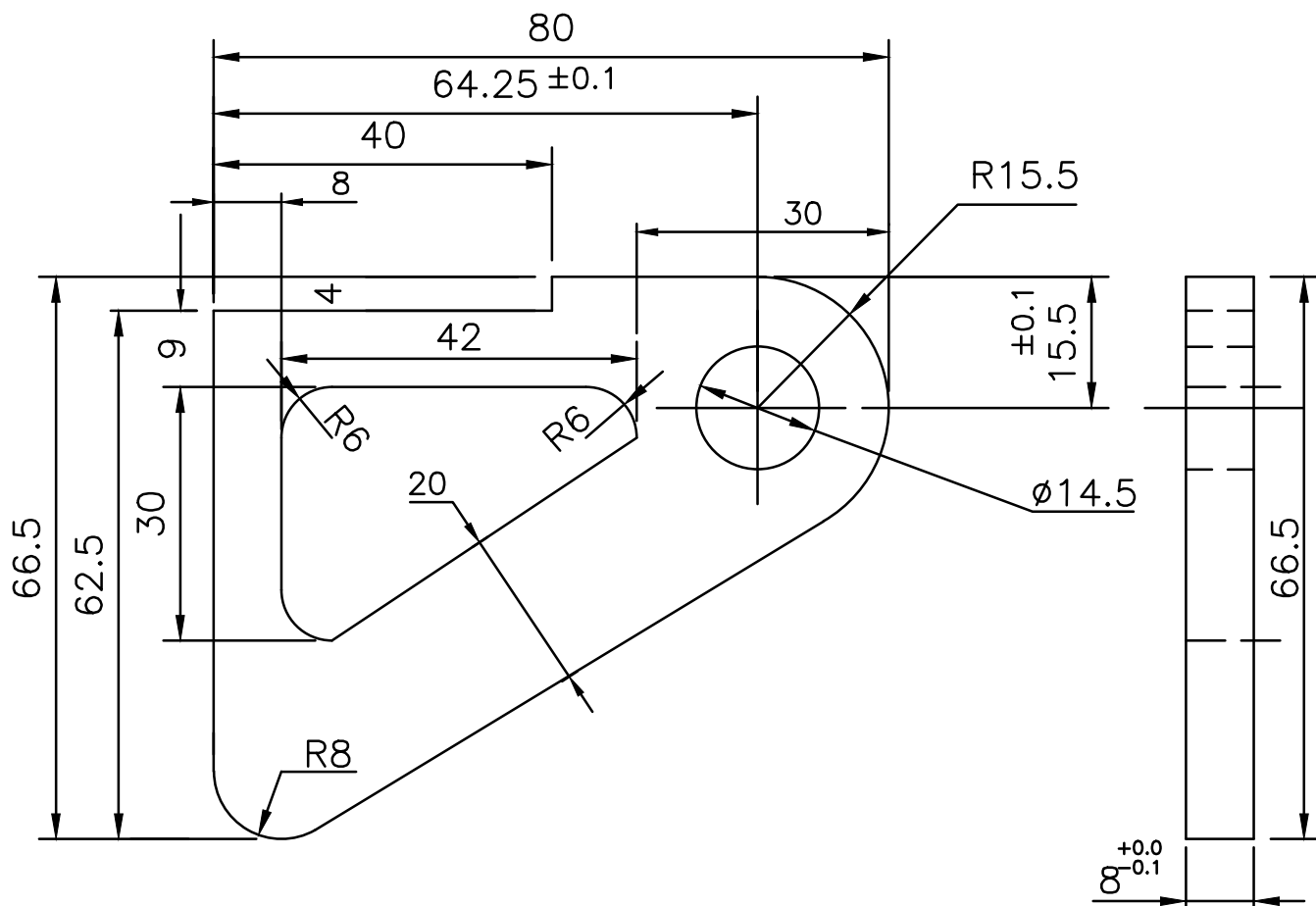
(2)

5x4DEEP
(8Nos)



PROCESS : MACHINING

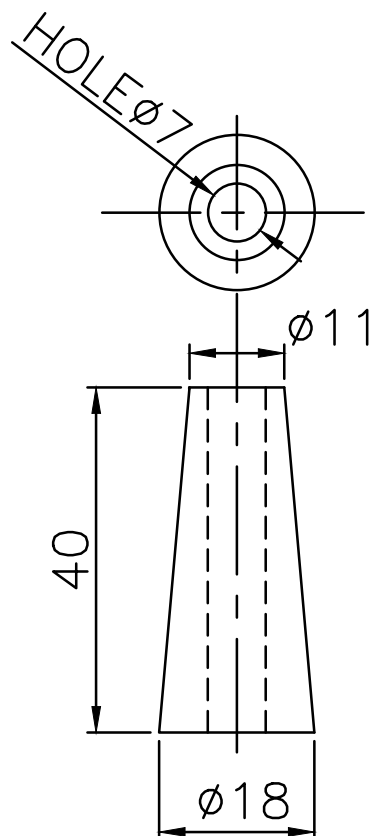
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S		MATERIAL: IS:961, St 55 HTW OR ASTM A 516 Gr.70	ADRDE ; AGRA	
CHECKED		SKS			FINISH: AS PER ANNEXURE 'C'		
TRACED		JCD					
COMPARED			PRO.OFF.	PD	HEAT TREATMENT:	APPROVED	
SCALE: NTS			OI/C		NORMALIZED	HEAD Q.A.)	
ALL DIMENSIONS IN MM			D & S		QTY.: 1No.	DRG.No.	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			NUT ROPE SUB ASSEMBLY-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				ADRDE 1404 07 02(a)(b)



PROCESS :- MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD		OI/C D&S	HEAD QA
DATE		NAME	H D S		MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
DRAWN					FINISH: AS PER ANNEXURE'A' (GREY)		
CHECKED							
TRACED			PRO.OFF.	PD	HEAT TREATMENT:	APPROVED	
COMPARED					NORMALIZED		
SCALE: NTS					OI/C D & S	HEAD(Q.A.)	
ALL DIMENSIONS IN MM					QTY.: 2Nos.		
TOLERANCE: UNLESS OTHERWISE SPECIFIED S:2102(PART1) :1993 MEDIUM			PLATE -A FABRICATED CHANNEL- BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				DRG.No. ADRDE 1404 01 03(a)(b)

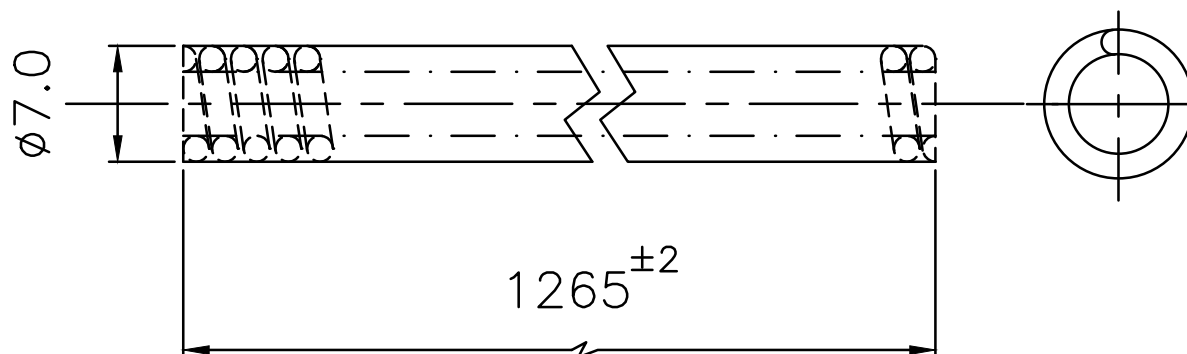
3



PROCESS : FABRICATION

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD	OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S	MATERIAL:	ADRDE ; AGRA	
CHECKED		SKS		NITRILE RUBBER		
TRACED		JCD		FINISH: _____		
COMPARED			PRO.OFF.	PD	HEAT TREATMENT: _____	APPROVED
SCALE: NTS						
ALL DIMENSIONS IN MM			OI/C D & S		QTY.: 1 Nos.	HEAD (Q.A.)
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			RUBBER COATING— MOUNTIG BRACKET ROPE SUB ASSEMBLY—BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 07 03(1)(b)

④

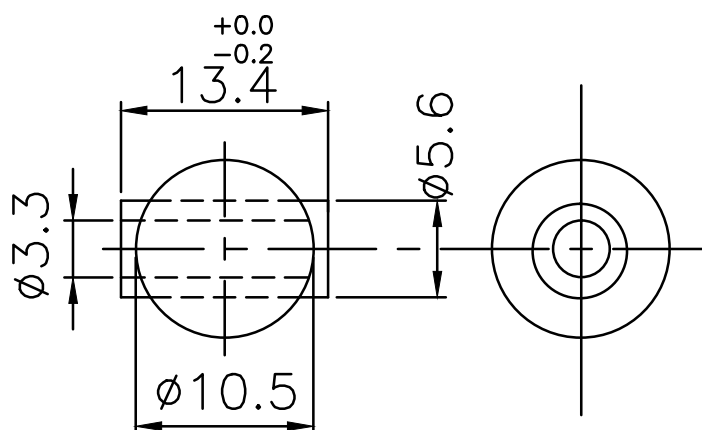


WIRE DIAMETER = 1.2

PROCESS : FABRICATION

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD		OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S		MATERIAL: IS:961, St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS	PRO.OFF. PD		FINISH: <i>NATURAL</i>		
TRACED		JCD			HEAT TREATMENT: <i>NORMALIZED</i>		
COMPARED					QTY.: 1No.		
SCALE: NTS			OI/C D & S		APPROVED		
ALL DIMENSIONS IN MM					HEAD(Q.A.)		
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			OUTER CABLE ROPE SUB ASSEMBLY-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 07 04(8)(b)	

5



NOTE : THIS BALL IS TO BE CRIMPED ON WIRE ROPE
(ITEM No. 10) WITH PROPER DIE AT
SPECIFIED PLACES.

PROCESS : MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S		MATERIAL: <i>STAINLESS STEEL (AUSTENITIC) 04Cr18Ni10 AS PER IS: 6527 -1972</i>	ADRDE ; AGRA	
CHECKED		SKS			FINISH: <i>NATURAL</i>		
TRACED		JCD					
COMPARED			PRO.OFF.	PD	HEAT TREATMENT: <i>NORMALIZED</i>	APPROVED	
SCALE: NTS			OI/C D & S		QTY.: 1No.	HEAD (Q.A.)	
ALL DIMENSIONS IN MM							
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			STEEL BALL ROPE SUB ASSEMBLY-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 07 05(a)(b)	

4

3

2

1

SHEET 55 OF 86

2

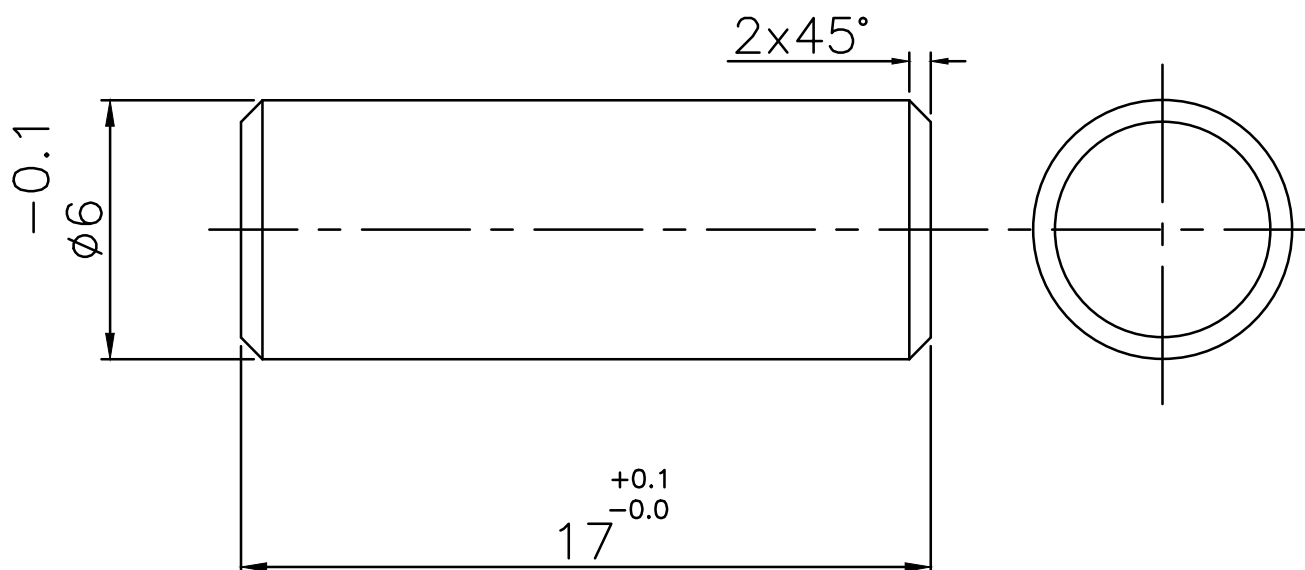
F

E

D

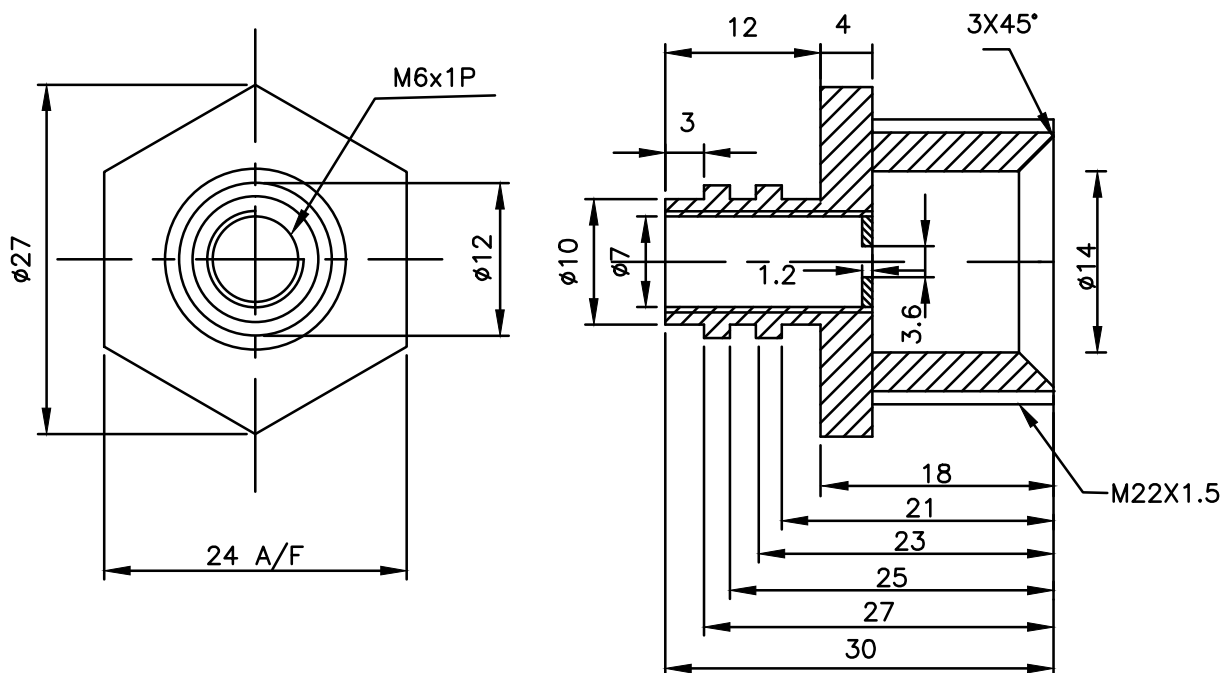
C

B



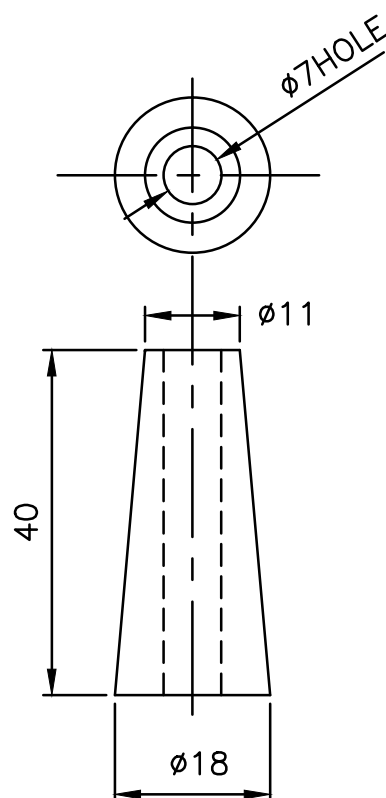
PROCESS : MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD QA
	DATE	NAME	H D S		MATERIAL: IS:961, St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
DRAWN		SKS	OI/C D&S PD		FINISH: <i>AS PER ANNEXURE 'C'</i>		
CHECKED		JCD					
TRACED							
COMPARED			OI/C D & S		HEAT TREATMENT: <i>NORMALIZED</i>	APPROVED	
SCALE: NTS					QTY.: 2 No.	HEAD (Q.A.)	
ALL DIMENSIONS IN MM							
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			PIN BRACKET SUB ASSY. ROPE SUB.ASSY.—BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 07 06 02(<i>g</i>)9b)	



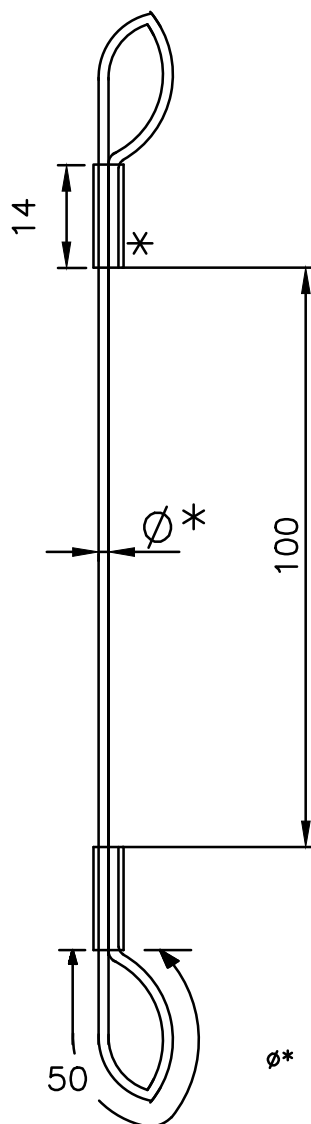
PROCESS : MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD QA
	DATE	NAME	H D S		MATERIAL: IS:961, St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
DRAWN		SKS	OI/C D&S PD		FINISH: <i>AS PER ANNEXURE 'c'</i>		
CHECKED		JCD					
TRACED					HEAT TREATMENT: <i>NORMALIZED</i>		APPROVED
SCALE: NTS			OI/C D & S		QTY.: 1No.	HEAD (Q.A.)	
ALL DIMENSIONS IN MM						DRG.No. ADRDE1404 07 06 03(8)(b)	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			GUIDE BRACKET- BRACKET SUB ASSY. ROPE SUB.ASSY.-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				



PROCESS : FABRICATION

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD		OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S		MATERIAL:	ADRDE ; AGRA	
CHECKED		SKS	PRO.OFF. PD		NITRILE RUBBER		
TRACED		JCD			FINISH: _____		
COMPARED					HEAT TREATMENT: _____		
SCALE: NTS			OI/C D & S		QTY.: 1No.	APPROVED	
ALL DIMENSIONS IN MM					HEAD (Q.A.)		
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			RUBBER COATING-BRACKET SUB ASSY. ROPE SUB.ASSY.-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 07 06 04(ø)(b)	

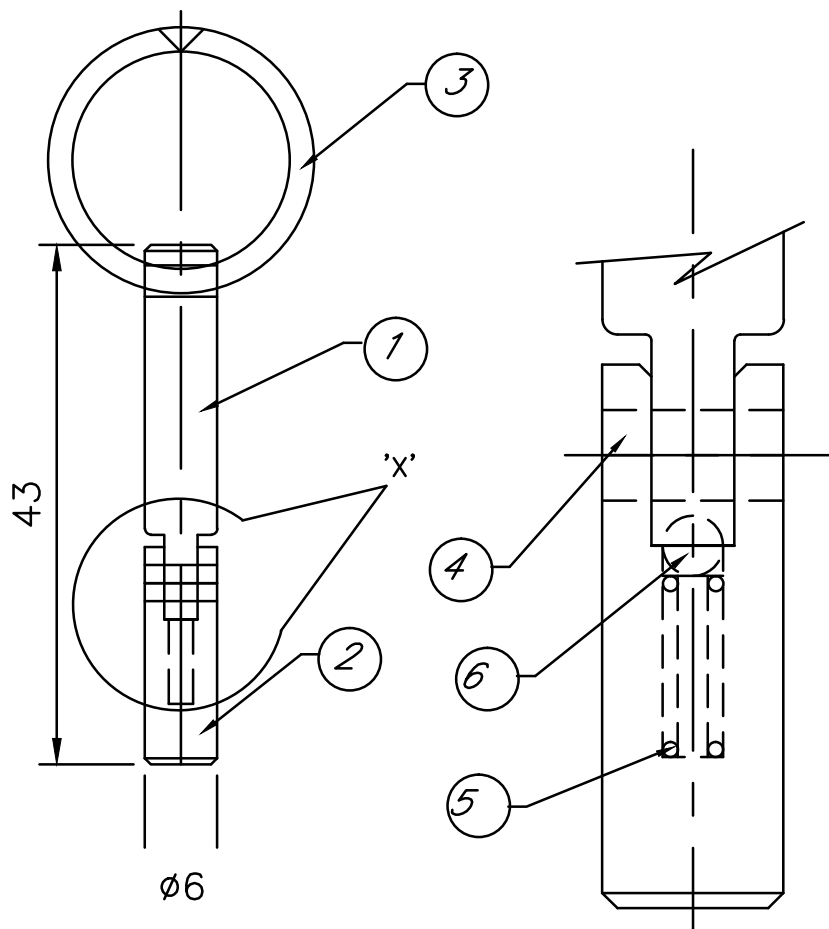


Ø* Commercial wire rope (galvanized / ss) dia 1.6 –2.0 mm
Construction 5/6 x 7

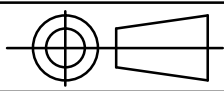
Suitable copper ferruling with smooth finish

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD QA	
	DATE	NAME	HDS		MATERIAL:	ADRDE ; AGRA		
DRAWN		SKS	PRO.OFF. PD					
CHECKED		JCD			FINISH:			
TRACED					HEAT TREATMENT:			
COMPARED			OI/C D & S		QTY.: 1	APPROVED		
SCALE: NTS					HEAD (Q.A.)			
ALL DIMENSIONS IN MM								
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 VERY COARSE			PIN ARMING WIRE(ROPE SUB.ASSY.) BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 07 07 (a)(b)		

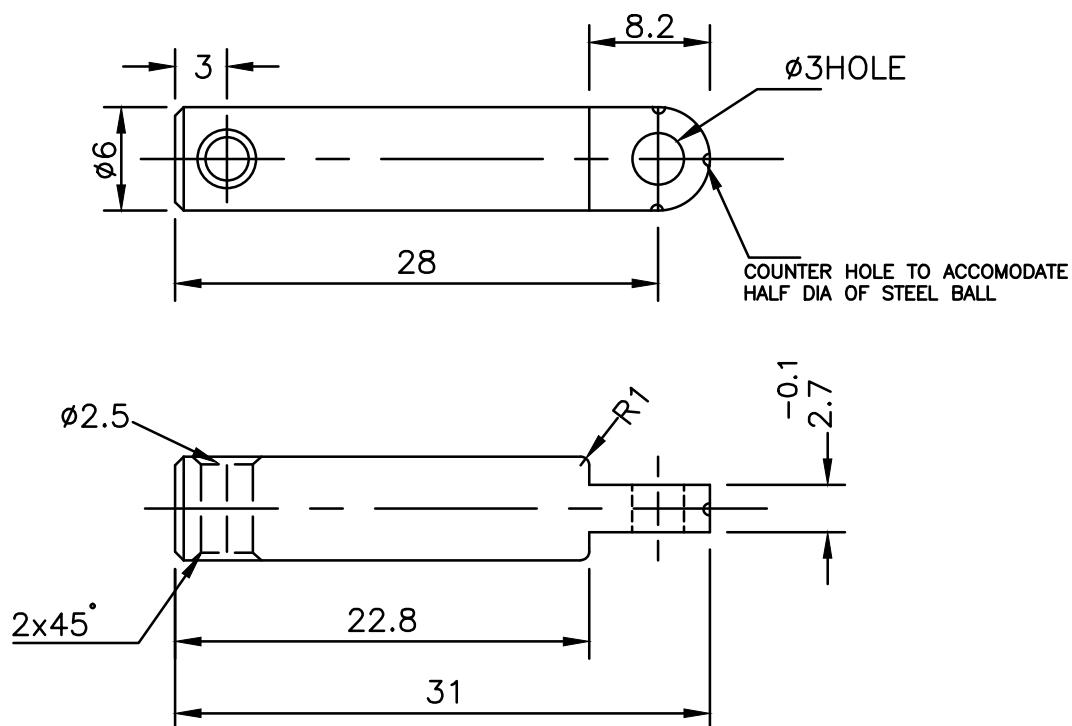
6	STAINLESS STEEL BALL COMERCIAL QULTY. 4.76 Ø	1	
5	ADRDE 1404 07 08 05	SPRING	1
4	ADRDE 1404 07 08 04	RIVET	1
3	ADRDE 1404 07 08 03	RING	1
2	ADRDE 1404 07 08 02	PIN LOCK	1
1	ADRDE 1404 07 08 01	PIN	1
SR.NO.	DRG/SPEC.NO.	DESIGNATION	QTY
			SHEET NO.

DETAIL INDEXENLARGED VIEW AT 'X'

PROCESS : FABRICATION

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/CD&S	HEAD QA
	DATE	NAME	H D S		MATERIAL:	ADRDE ; AGRA	
DRAWN		SKS					
CHECKED		JCD					
TRACED			PRO.OFF.	PD	FINISH:		
COMPARED					HEAT TREATMENT:	APPROVED	
SCALE: NTS						HEAD(Q.A.)	
ALL DIMENSIONS IN MM			OI/C D & S		QTY.: 1Nos.	DRG.No.	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			LOCKING PIN SUB ASSEMBLY ROPE SUB ASSY.-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				ADRDE 1404 07 08 (a)(b)

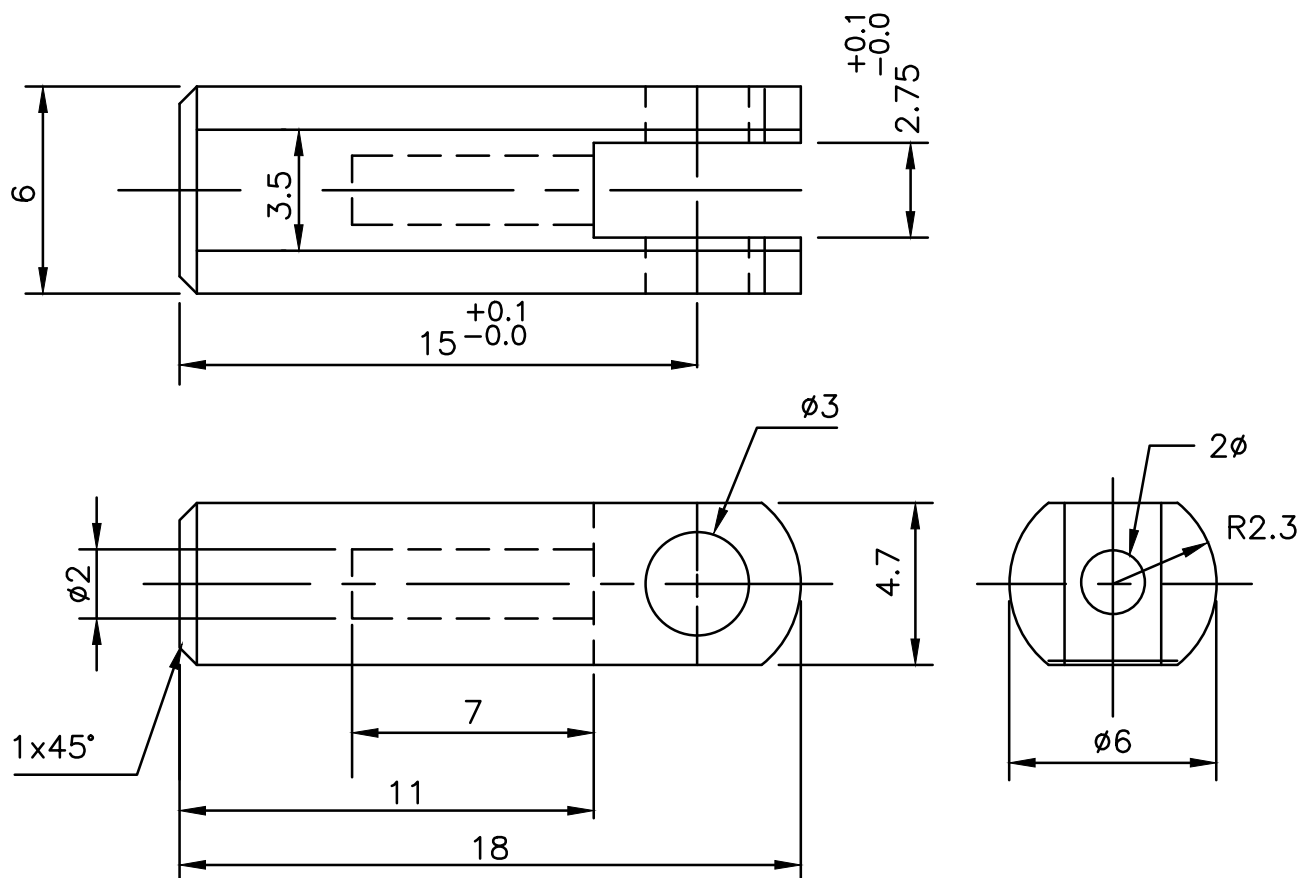
1



PROCESS : MACHINING (RIVITTED JOINT SHOULD BE SMOOTH FINISHED)

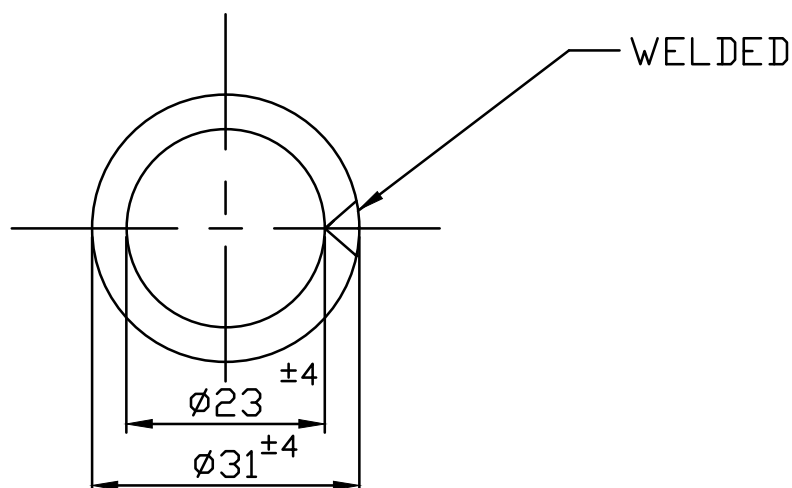
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S		MATERIAL: IS:961, St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS			FINISH: AS PER ANNEXURE 'C'		
TRACED		JCD					
COMPARED			PRO.OFFR.	PD	HEAT TREATMENT: <i>NORMALIZED</i>	APPROVED	
SCALE: NTS					QTY.: 1	HEAD(Q.A.)	
ALL DIMENSIONS IN MM							
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			PIN -LOCKING PIN SUB ASSY. ROPE SUB ASSY.-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 07 08 01(a)(b)	

(2)



PROCESS : MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD		OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S		MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS	PRO.OFF. PD		FINISH: AS PER ANNEXURE 'C'		
TRACED		JCD					
COMPARED							
SCALE: NTS			OI/C D & S		HEAT TREATMENT: NORMALIZED	APPROVED	
ALL DIMENSIONS IN MM					QTY.: 1No.	HEAD (Q.A.)	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			PIN-LOCK -LOCKING PIN SUB ASSY. ROPE SUB ASSY.-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 07 08 02(d)(b)	



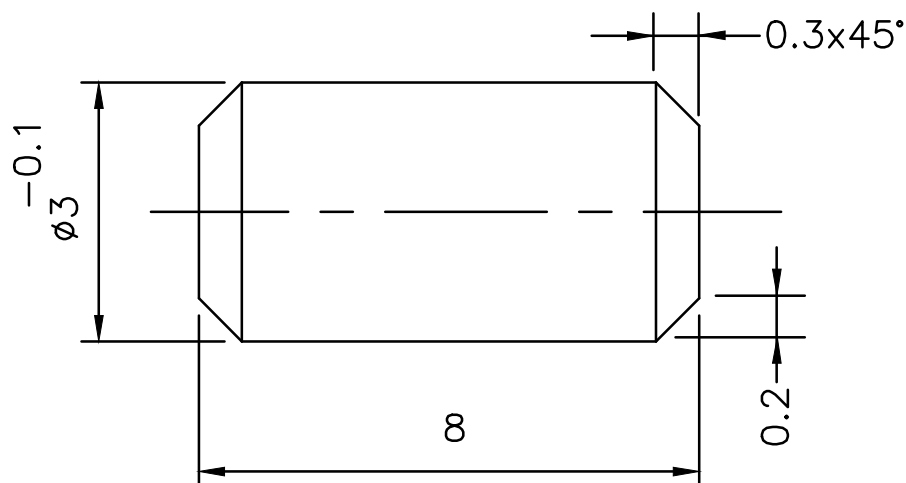
NOTE:— WELDING MAY BE CARRIED OUT AFTER ASSEMBLY WITH HOOK

WELDING :

ALL WELDED JOINTS SHOULD BE WELDED BY ELECTRODES CONFORMING TO ADVANI OERLIKON SUPERCITO AWS/SFA 5.1—E7018 ISEB—5426 H3Jx OR ITS EQUIVALENT. WELDED JOINTS SHOULD BE TESTED BY DYE PENETRATION TEST (IS: 3658) BEFORE FINISH .

PROCESS : FABRICATION

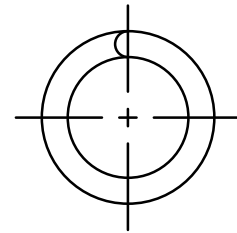
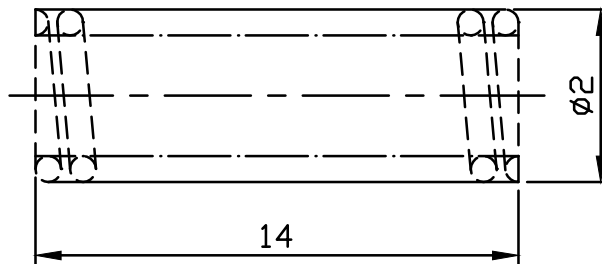
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	HEAD (Q.A.)
	DATE	NAME	H D S		MATERIAL: IS:961, St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
DRAWN		SKS	PRO.OFF. PD		FINISH: AS PER ANNEXURE 'C'		
CHECKED		JCD					
TRACED					HEAT TREATMENT: NORMALIZED		APPROVED
COMPARED			OI/C D & S		QTY.:1No	HEAD (Q.A.)	
SCALE: NTS						DRG.No.	
ALL DIMENSIONS IN MM			RING—LOCKING PIN SUB ASSY. ROPE SUB.ASSY.—BEAM ASSEMBLY (HEAVY DROPPING SYSTEM AN—32 AIRCRAFT)			ADRDE 1404 07 08 03(a)(b)	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM							



PROCESS : MACHINING

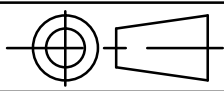
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/CD&S	HEAD QA
	DATE	NAME	H D S		MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
DRAWN		SKS	PRO.OFFR.	PD	FINISH: <i>AS PER ANNEXURE 'C'</i>		
CHECKED		JCD					
TRACED							
COMPARED			OI/C D & S		HEAT TREATMENT: NORMALIZED	APPROVED	
SCALE: NTS					QTY.: 1No.	HEAD(Q.A.)	
ALL DIMENSIONS IN MM							
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			RIVET -LOCKING PIN SUB ASSY. ROPE SUB ASSY.-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 07 08 04(a)(b)	

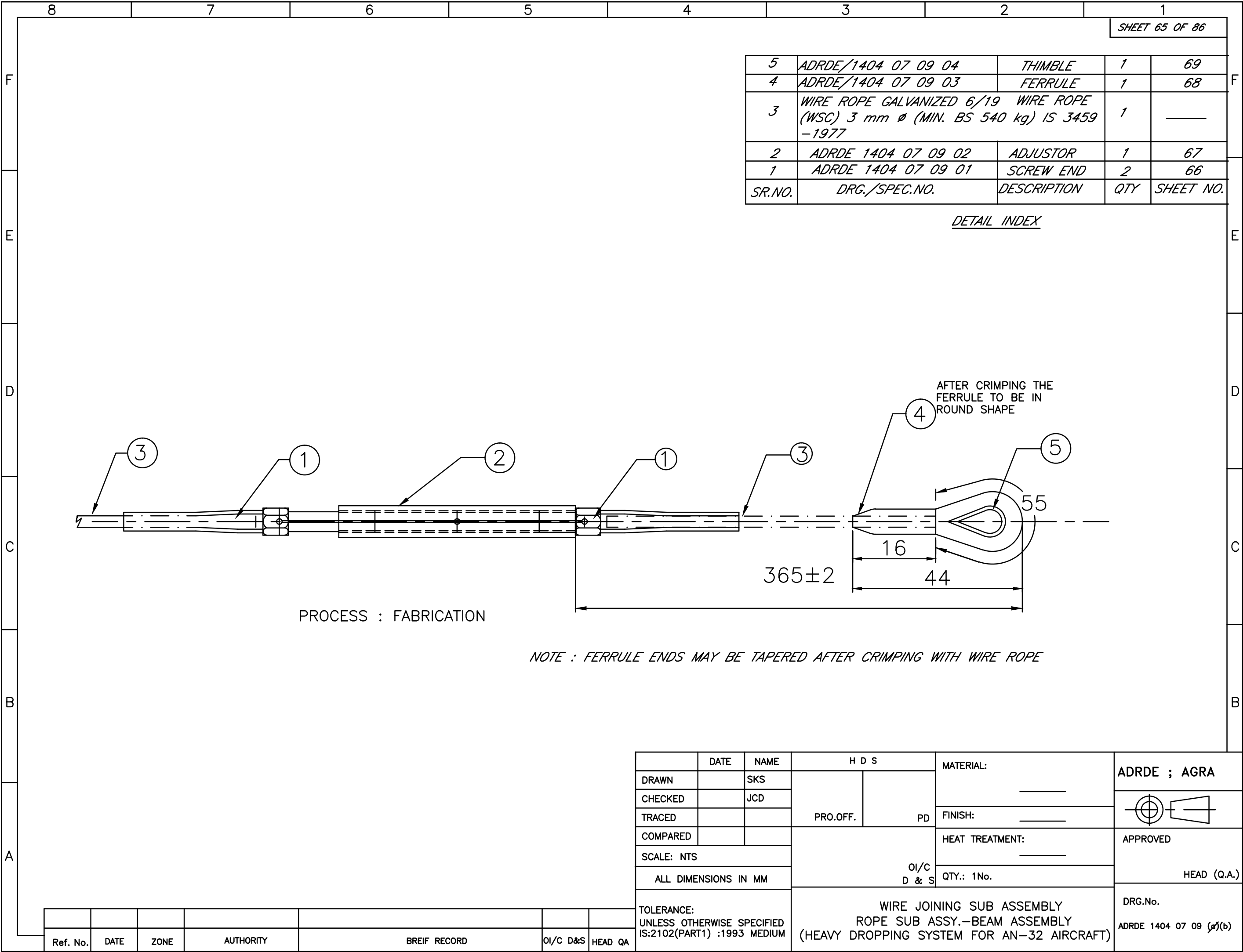
⑤

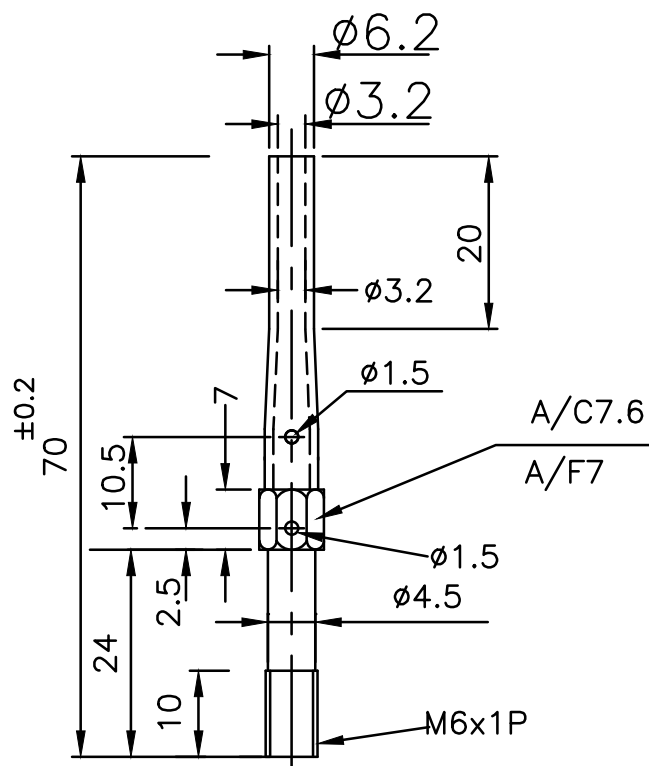


WIRE DIA. = 0.6
 No. OF TURNS = 11
 No. OF ACTIVE TURNS = 9
 STIFFNESS : 0.475 kg/mm

PROCESS :- FABRICATION

'a'	18-01-07	E,D-2	CH. SH. No.01	'2' IN PLACE OF '4'		
'a'	18-01-07	C-3	CH. SH. No.01	CHANGE IN WIRE DIA.		
'a'	18-01-07		CH. SH. No.01	CHANGE IN NOMENCLATURE		
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	OI/C CAD	HEAD CAD
	DATE	NAME	H D S	MATERIAL: SS SPRING WIRE	ADRDE ; AGRA	
DRAWN		SKS		IS 4454 Gr IV		
CHECKED		JCD		FINISH: NATURAL		
TRACED			PRO.OFF. PD	HEAT TREATMENT:		
COMPARED				NORMALIZED	APPROVED	
SCALE: NTS				QTY.: 1No.	HEAD (Q.A.)	
ALL DIMENSIONS IN MM						
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 COARSE				SPRING-LOCKING PIN SUB ASSY. ROPE SUB ASSY. LOCKING BEAM (BEAM ASSEMBLY) (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)	DRG.No. ADRDE1404 07 08 05(a)(b)	



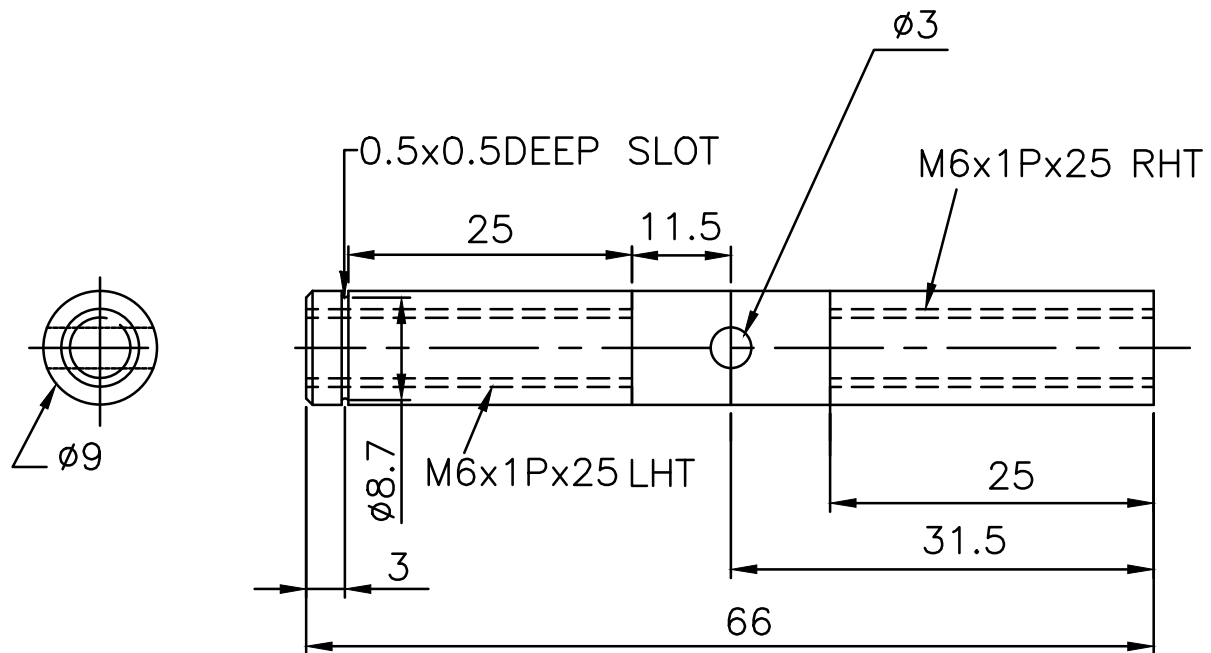


NOTE: ONE NUMBER LHT (M6x1P)
ONE NUMBER RHT (M6x1P)

PROCESS : MACHINING

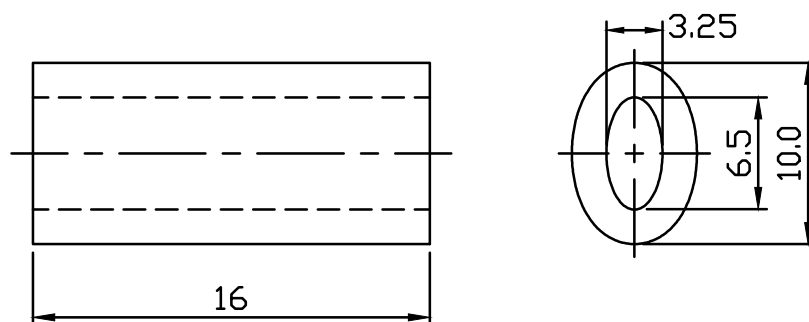
Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD	OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S	MATERIAL: IS:961, St 55 HTW OR ASTM A 516 Gr.70	ADRDE ; AGRA	
CHECKED		SKS				
TRACED		JCD				
COMPARED			PRO.OFF.	PD	FINISH: AS PER ANNEXURE 'C'	APPROVED
SCALE: NTS					HEAT TREATMENT: NORMALIZED	
ALL DIMENSIONS IN MM			OI/C D & S		QTY.: 2 No.(1 LHT+1RHT)	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			SCREW END— WIRE JOINING SUB. ASSY. ROPE SUB ASSY—BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 07 09 01(d)(b)

(2)



PROCESS : MACHINING

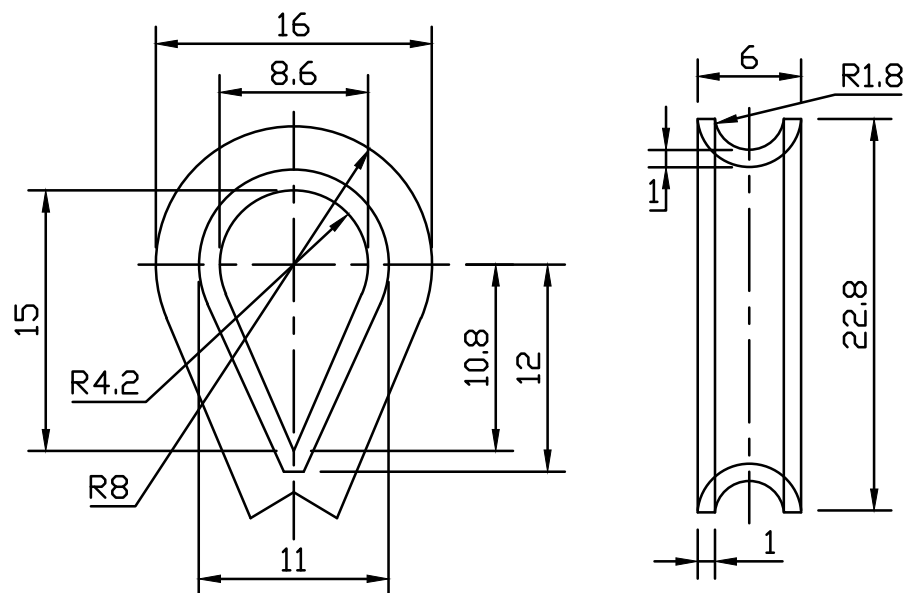
Ref. No.		DATE	ZONE	AUTHORITY		BRIEF RECORD		DI/C D&S	HEAD QA
DRAWN		DATE	NAME	HDS		MATERIAL: IS:961, St 55 HTW OR ASTM A 516 Gr.70		ADRDE ; AGRA	
CHECKED			SKS						
TRACED			JCD						
COMPARED				PRO.OFF.		PD		APPROVED	
SCALE: NTS						HEAT TREATMENT: HARDENED & TEMPERED 35±5 HRC		HEAD(Q.A.)	
ALL DIMENSIONS IN MM						QTY.: 1No.		DRG.No. ADRDE	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MED.						ADJUSTER-WIRE JOINING SUB. ASSY. ROPE SUB ASSY-BEAM ASSEMBLY H D SYSTEM FOR AN-32 AIRCRAFT.		1404 07 09 02(ø)(b)	



PROCESS :- MACHINING

'a'	18-01-07		CH. SH. No.01	CHANGE IN NOMENCLATURE			
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C CAD	HEAD CAD
	DATE	NAME	H D S		MATERIAL: AS PER IS: 10942 TYPE 'A', ALUMINIUM ALLOY TO DESEGNATED (IS:1285-Wr.ALUMINIUM)	ADRDE ; AGRA	
DRAWN		SKS	PRO.OFF.	PD	FINISH: NATURAL		
CHECKED		JCD					
TRACED							
COMPARED			OI/C D & S		HEAT TREATMENT:	APPROVED	
SCALE: 2 : 1					NORMALIZED		
ALL DIMENSIONS IN MM					QTY.: 1 No.		
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			FERRULE- WIRE JOINING SUB. ASSY. ROPE SUB ASSY. LOCKING BEAM (BEAM ASSEMBLY) (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE1404 07 09 03(a)(b)	

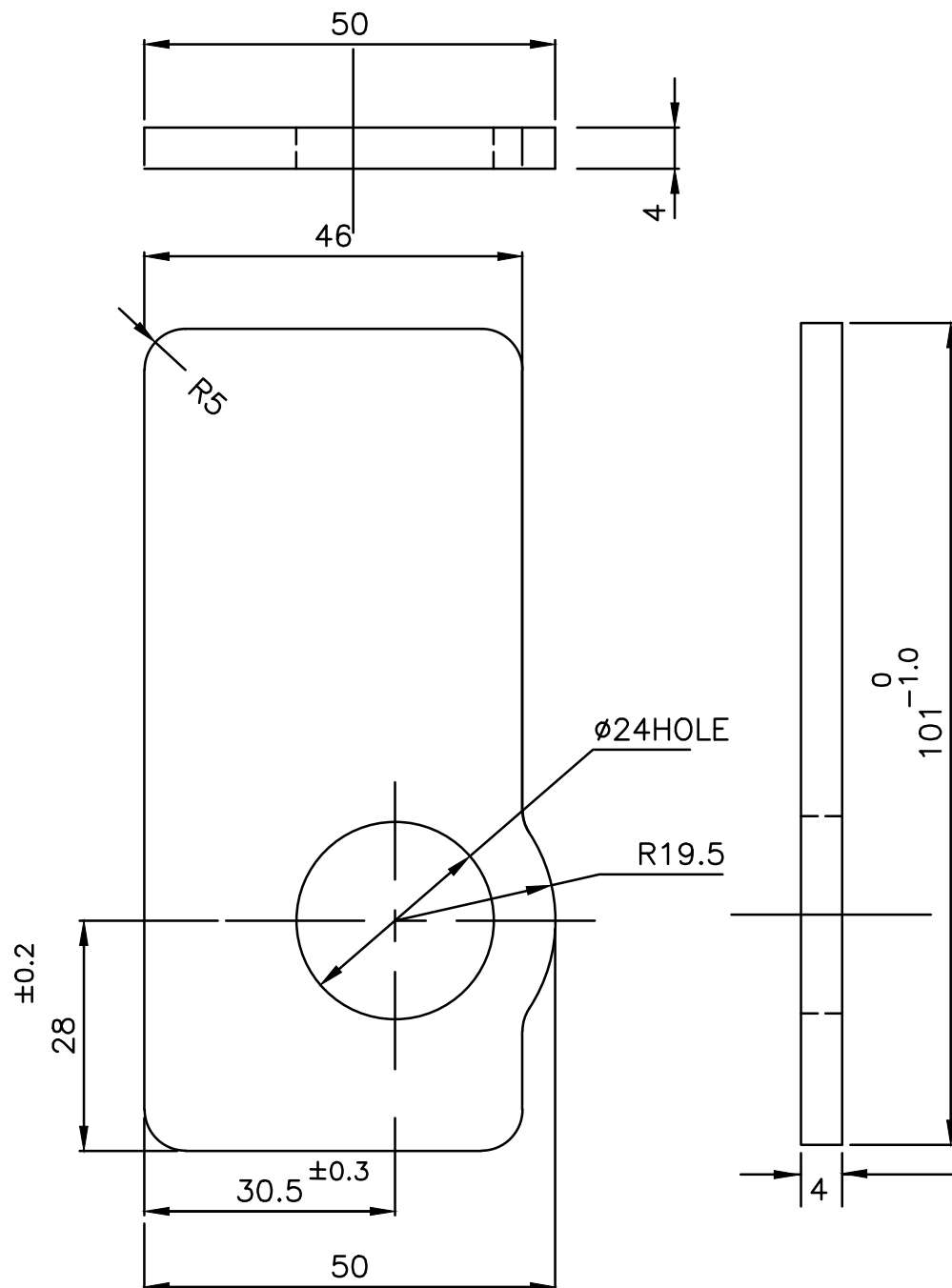
(5)



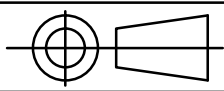
NOTE : AFTER ASSY WITH CABLE (WIRE ROPE ASSY) THIS LOOP (WITH THIMBLE & CABLE) SHOULD PASS SMOOTHLY THRU A BUSH (drg no. ADRDE/1404 06) WITH 18 mm ID.

PROCESS :- MACHINING

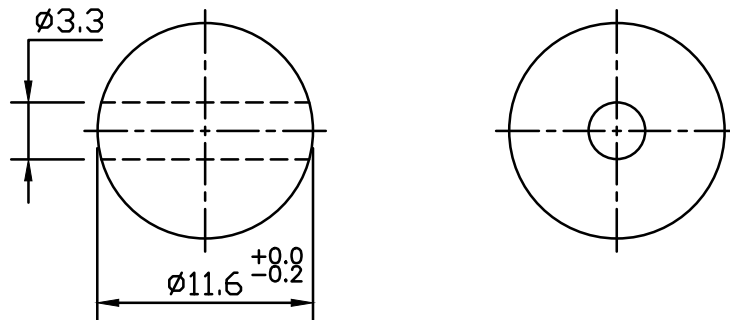
'a'	18-01-07		CH. SH. No.01	CHANGE IN NOMENCLATURE			
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C CAD	HEAD CAD
	DATE	NAME	H D S		MATERIAL: IS : 2062	ADRDE ; AGRA	
DRAWN		SKS			FINISH: NORMALIZED		
CHECKED		JCD					
TRACED			PRO.OFF.	PD			
COMPARED					HEAT TREATMENT: NORMALIZED	APPROVED	
SCALE: 2 : 1					QTY.: 1 No.	HEAD (Q.A.)	
ALL DIMENSIONS IN MM			OI/C D & S				
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			THIMBLE- WIRE JOINING SUB. ASSY. ROPE SUB ASSY. LOCKING BEAM (BEAM ASSEMBLY) (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE1404 07 09 04(a)(b)	



PROCESS:— MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		DI/C D&S	HEAD QA
DRAWN	DATE	NAME	HDS		MATERIAL: IS:961, St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS			FINISH: AS PER ANNEXURE 'A' (GREY)		
TRACED		JCD					
COMPARED			PRO.OFF.	PD	HEAT TREATMENT: NORMALIZED	APPROVED	
SCALE: NTS					QTY.: 2Nos.	HEAD(Q.A.)	
ALL DIMENSIONS IN MM			DI/C D & S				
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			PLATE— C FABRICATED CHANNEL— BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN 32 AIRCRAFT)				DRG.No. ADRDE 1404 01 05(g)(b)

10



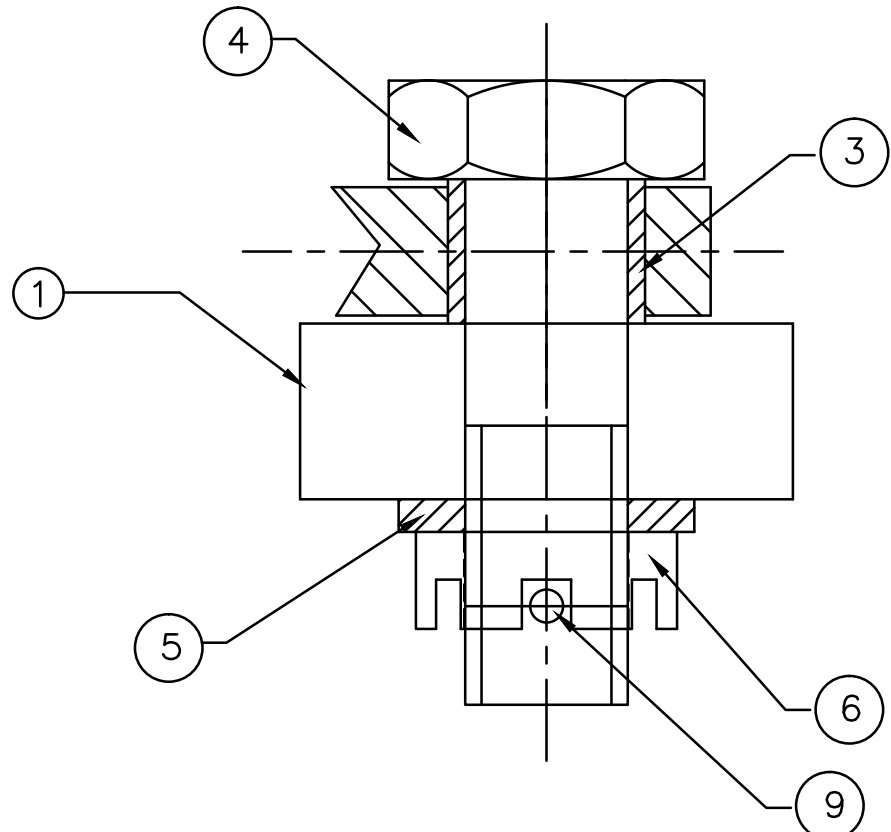
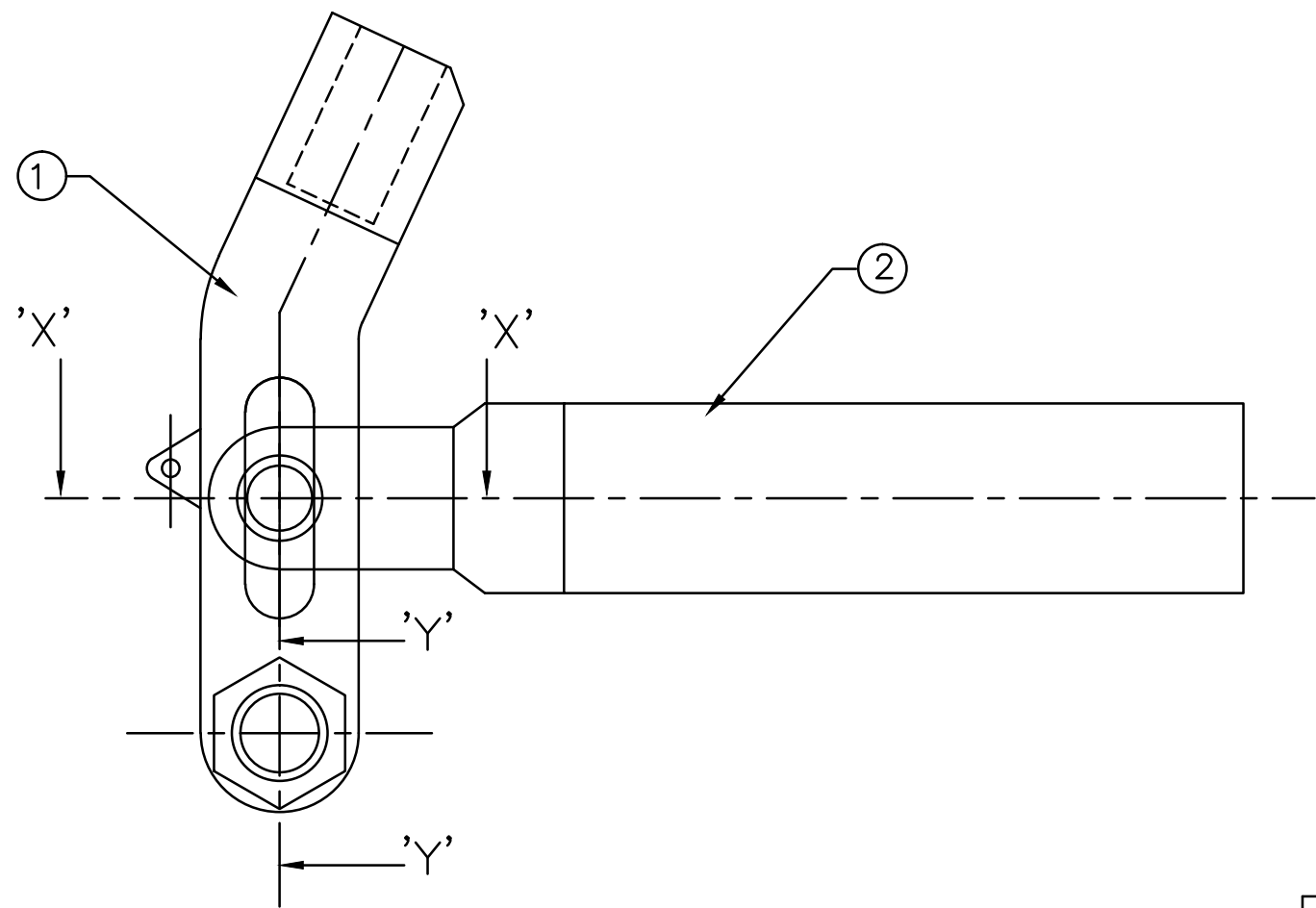
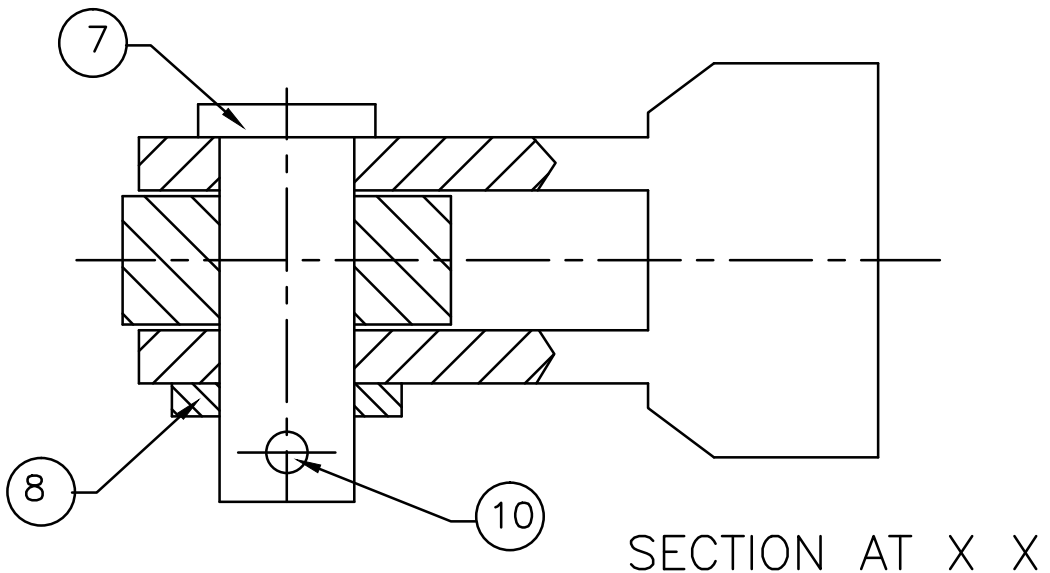
NOTE : THIS IS TO BE CRIMPED AT WIRE ROPE(ITEM No. 10) END WITH PROPER DIE. END SHOULD BE SMOOTH FINISHED.

PROCESS :- MACHINING

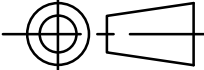
'a'	18-01-07		CH. SH. No.01	CHANGE IN NOMENCLATURE			
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C CAD	HEAD CAD
	DATE	NAME	H D S		MATERIAL: STAINLESS STEEL (AUSTENITIC) 04Cr18Ni10 AS PER IS: 6527 - 1972	ADRDE ; AGRA	
DRAWN		SKS			FINISH: NATURAL		
CHECKED		JCD					
TRACED			PRO.OFF.	PD			
COMPARED					HEAT TREATMENT:	APPROVED	
SCALE: NTS					NORMALIZED		
ALL DIMENSIONS IN MM			OI/C D & S		QTY.: 1 No.	HEAD (Q.A.)	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			STEEL BALL ROPE SUB ASSY. LOCKING BEAM (BEAM ASSEMBLY) (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE1404 07 10(a)(b)	

10	IS:549	SPLIT PIN $\varnothing$ 2x20 Lg	1	
9	IS:549	SPLIT PIN $\varnothing$ 2x25 Lg	1	
8	IS:2016	WASHER M8	1	
7	ADRDE 1404 09 07	PIN	1	76
6	ADRDE 1404 09 06	SLOTTED NUT	1	75
5	IS:2016	WASHER M10	1	
4	IS:1364	HEX BOLT M10x1.5P,32 Lg	1	
3	ADRDE 1404 09 03	BUSH	1	74
2	ADRDE 1404 09 02	PIN LEVER	1	73
1	ADRDE 1404 09 01	LEVER	1	72
SR.NO.	DRG./SPEC.NO.	DESCRIPTION	QTY	SHEET NO

DETAIL INDEX

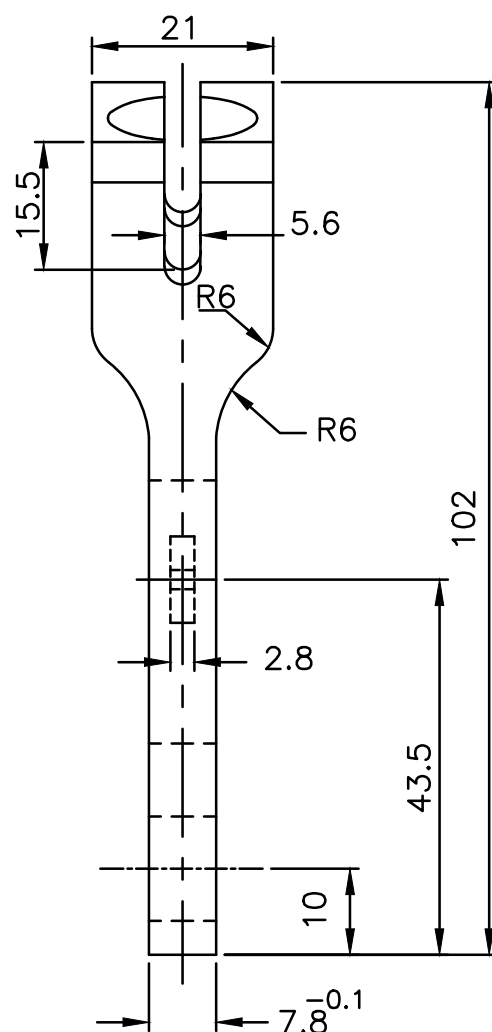


PROCESS : FABRICATION

	DATE	NAME	H D S		MATERIAL:	ADRDE ; AGRA	
DRAWN		SKS	PRO.OFF.	PD			
CHECKED		JCD			FINISH:		
TRACED					HEAT TREATMENT:		APPROVED
COMPARED							
SCALE: NTS			OI/C D & S	QTY.: 2Nos.	HEAD(Q.A.)		
ALL DIMENSIONS IN MM							
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 VERY COARSE			TENSION LEVER SUB ASSEMBLY BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 09 (ø)(b)	

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	OI/C D&S	HEAD QA
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1



PROCESS: MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD				OI/C D&S	HEAD QA
	DATE	NAME	H D S		MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>			ADRDE ; AGRA	
DRAWN		SKS	PRO.OFF.	PD				FINISH: <i>AS PER ANNEXURE 'C'</i>	
CHECKED		JCD							
TRACED					HEAT TREATMENT:			APPROVED	
COMPARED			OI/C D & S			<i>NORMALIZED</i>			
SCALE: NTS		QTY.: 1 Nos.				HEAD (Q.A.)			
ALL DIMENSIONS IN MM									
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM		LEVER TENSION LEVER SUB ASSY.—BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN—32 AIRCRAFT)						DRG.No. ADRDE 1404 09 01(d)(b)	

4

3

2

1

SHEET 73 OF 86

(2)

+0.1
ø8.2HOLE

R9

±0.4

122

4

18

15

+0.1
8.5

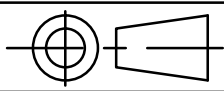
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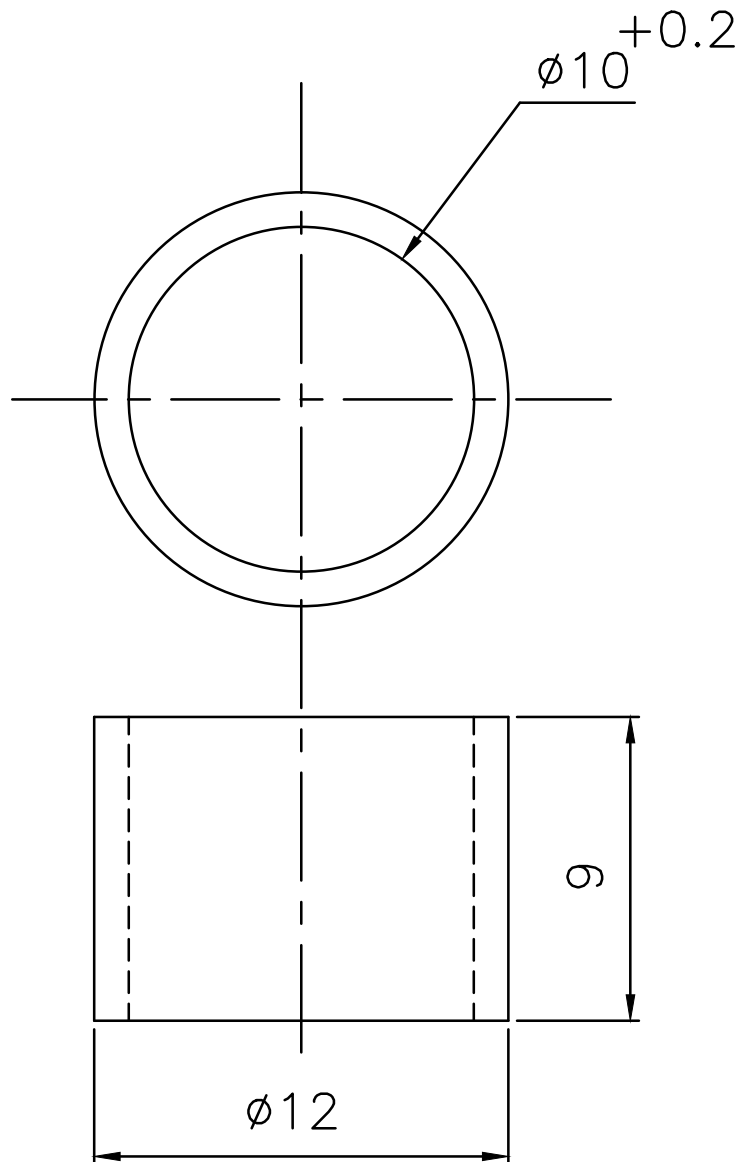
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131

-0.1

ø24

PROCESS : MACHINING

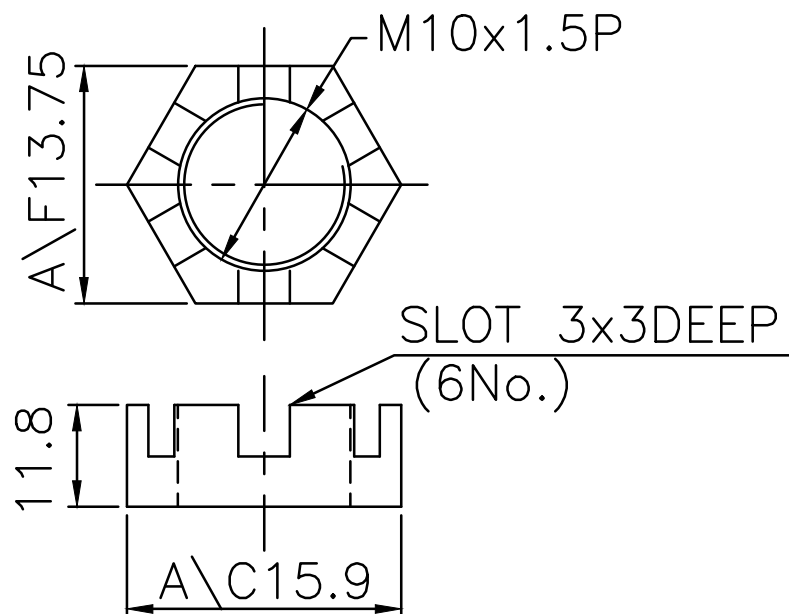
Ref. No.	DATE	ZONE	AUTHORITY		BREIF RECORD		OI/CD&S	HEAD QA
	DATE	NAME	H D S		MATERIAL: IS:961,St 55 HTW OR ASTM A 516 Gr.70		ADRDE ; AGRA	
DRAWN		SKS	PRO.OFF.		PD	FINISH: AS PER ANNEXURE 'C'		
CHECKED		JCD						
TRACED								
COMPARED			O/C D & S		QTY.: 1No.	HEAT TREATMENT: NORMALIZED	APPROVED	
SCALE: NTS							HEAD (Q.A.)	
ALL DIMENSIONS IN MM								
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102 (PART1):1993 MEDIUM			PIN LEVER TENSION LEVER SUB ASSY.-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				DRG.No. ADRDE 1404 09 02(ø)(b)	



PROCESS : MACHINING

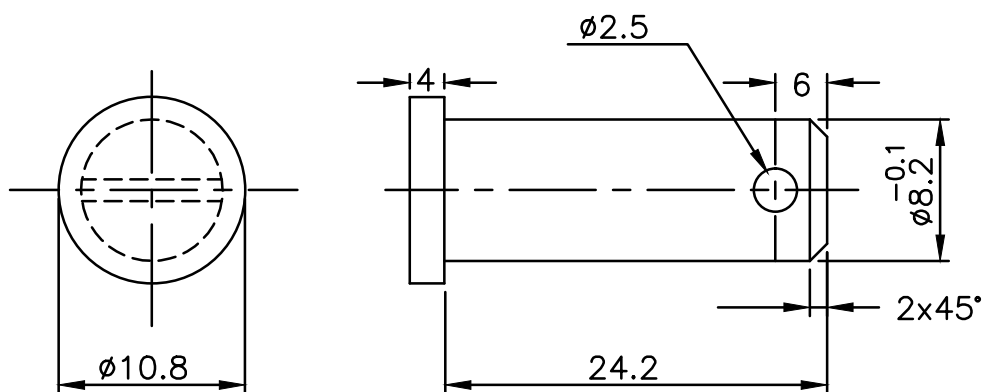
Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD		OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S		MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS			FINISH: <i>AS PER ANNEXURE 'C'</i>		
TRACED		JCD					
COMPARED			PRO.OFF.	PD	HEAT TREATMENT: <i>NORMALIZED</i>	APPROVED	
SCALE: NTS			D & S		QTY.: 1 Nos.	HEAD (Q.A.)	
ALL DIMENSIONS IN MM			OI/C			DRG.No.	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			BUSH TENSION LEVER SUB ASSY.-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				ADRDE 1404 09 03(ø)(b)

⑥



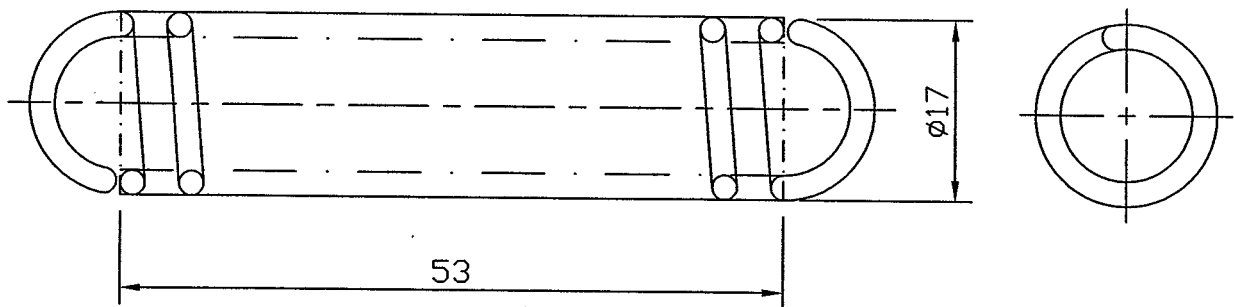
PROCESS : MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD		OI/C D&S	HEAD QA
DRAWN	DATE	NAME	H D S		MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS			FINISH: <i>AS PER ANNEXURE 'C'</i>		
TRACED		JCD					
COMPARED			PRO.OFF	PD	HEAT TREATMENT:	APPROVED	
SCALE: NTS					<i>NORMALIZED</i>	HEAD (Q.A.)	
ALL DIMENSIONS IN MM			OI/C D & S		QTY.: 2No.	DRG.No.	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			SLOTTED NUT TENSION LEVER SUB ASSY.-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				ADRDE 1404 09 06(a)(b)



PROCESS : MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BREIF RECORD		OI/C	PGD
DRAWN	DATE	NAME	H D S		MATERIAL: IS:961,St 55 HTW OR ASTM A 516 Gr.70	ADRDE ; AGRA	
CHECKED		SKS	PRO.OFFR.		FINISH: AS PER ANNEXURE 'C'		
TRACED		JCD					
COMPARED			OI/C D & S		HEAT TREATMENT: NORMALIZED	APPROVED	
SCALE: NTS					QTY.: 1 Nos.		HEAD Q.A.)
ALL DIMENSIONS IN MM			PIN		DRG.No.		
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			TENSION LEVER SUB ASSY.-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			ADRDE 1404 09 07(1)(b)	

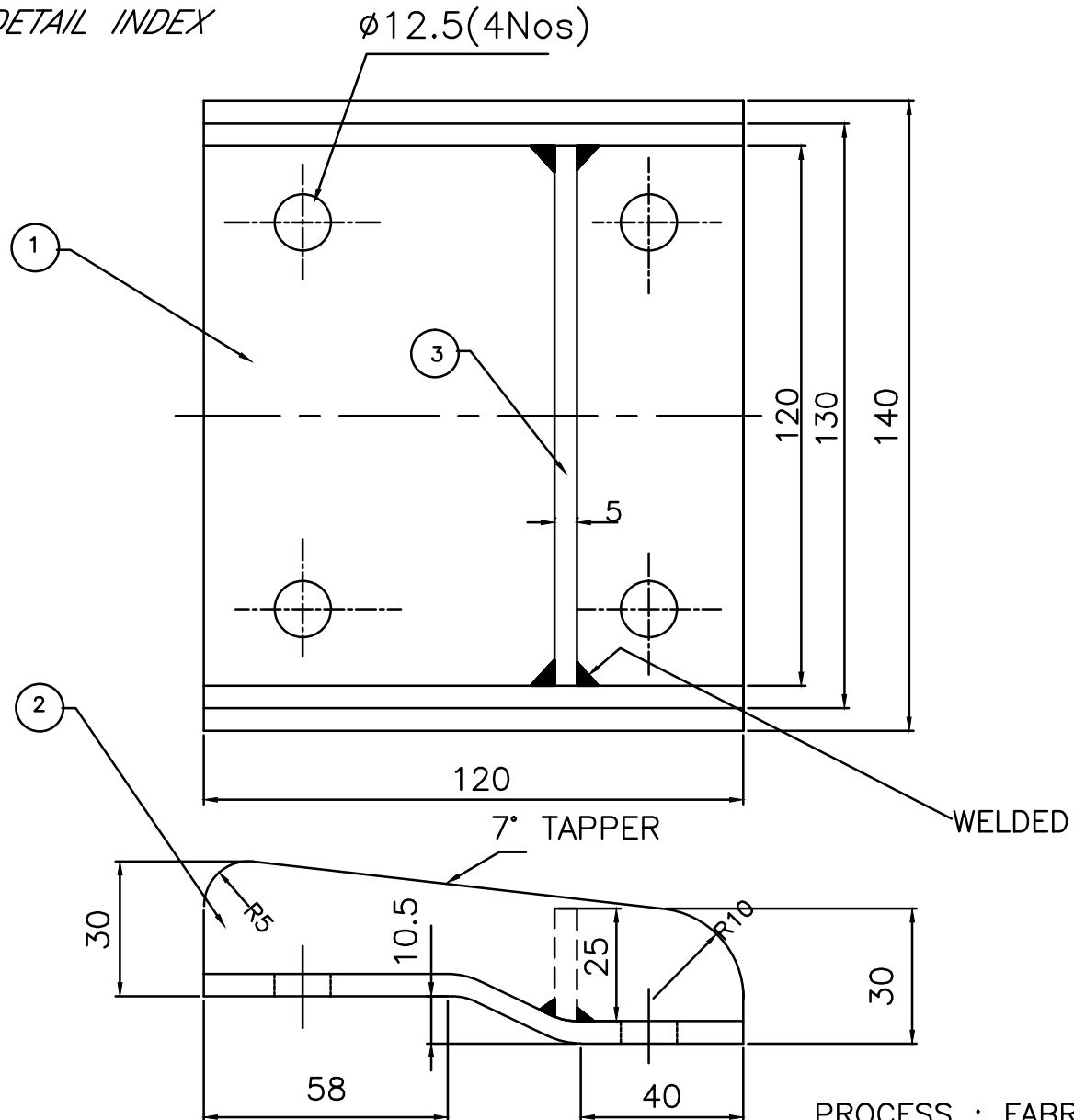


WIRE DIA. = 1.6
 No. OF TURNS = 34
 No. OF ACTIVETURNS = 33
 STIFFNESS : 0.475 kg/mm

'a'	18-01-07		CH. SH. No.01	CHANGE IN SPRING DIA. & SPRING PARAMETERS		
'a'	18-01-07		CH. SH. No.01	CHANGE IN NOMENCLATURE		
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	OI/C CAD	HEAD CAD
	DATE	NAME	H D S	MATERIAL:	ADRDE ; AGRA	
DRAWN		SKS	 PRO OFF. PD	SPRING STEEL AS PER IS:4454 (PART-2); GR-FDGV-A		
CHECKED		JCD		FINISH:		
TRACED				HEAT TREATMENT:		
COMPARED				OIL HARDENED & TEMPERED	APPROVED	
SCALE: NTS			OI/C D & S	QTY.: 1 No.	HEAD (Q.A.)	
ALL DIMENSIONS IN MM						
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 COARSE			SPRING LOCKING BEAM (BEAM ASSEMBLY) (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 10(a)(b)(c)

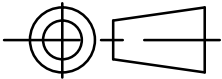
4		3	2	1	
3	ADRDE 1404 11 03	GUSSET	1	81	SHEET 78 OF 86
2	ADRDE 1404 11 02	SIDE PLATE	2	80	
1	ADRDE 1404 11 01	BOTTEM PLATE	1	79	
SR.NO.	DRG/SPEC.NO.	DESIGNATION	QTY	SHEET NO.	

DETAIL INDEX



WELDING :

ALL WELDED JOINTS SHOULD BE WELDED BY ELECTRODES CONFORMING TO ADVANI OERLIKON SUPERCITO AWS/SFA 5.1-E7018 ISEB-5426 H3Jx OR ITS EQUIVALLENT. WELDED JOINTS SHOULD BE TESTED BY DYE PENETRATION TEST (IS: 3658) BEFORE FINISH .

Ref. No.	DATE	ZONE	AUTHORITY		BRIEF RECORD		DI/C D&S	HEAD QA	
	DATE	NAME	H D S		MATERIAL: IS:961,St 55 HTW OR <i>ASTM A 516 Gr.70</i>		ADRDE ; AGRA		
DRAWN		SKS	PRO.OFF.	PD			FINISH: AS PER ANNEXURE 'A' (GREY)		
CHECKED		JCD							
TRACED							HEAT TREATMENT: <i>NORMALIZED</i>		APPROVED
COMPARED			DI/C D & S		QTY.: 1No.		HEAD (Q.A.)		
SCALE: NTS									
ALL DIMENSIONS IN MM									
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			CURVED PLATE SUB ASSY. BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)					DRG.No. ADRDE 1404 11(ø)(b)	

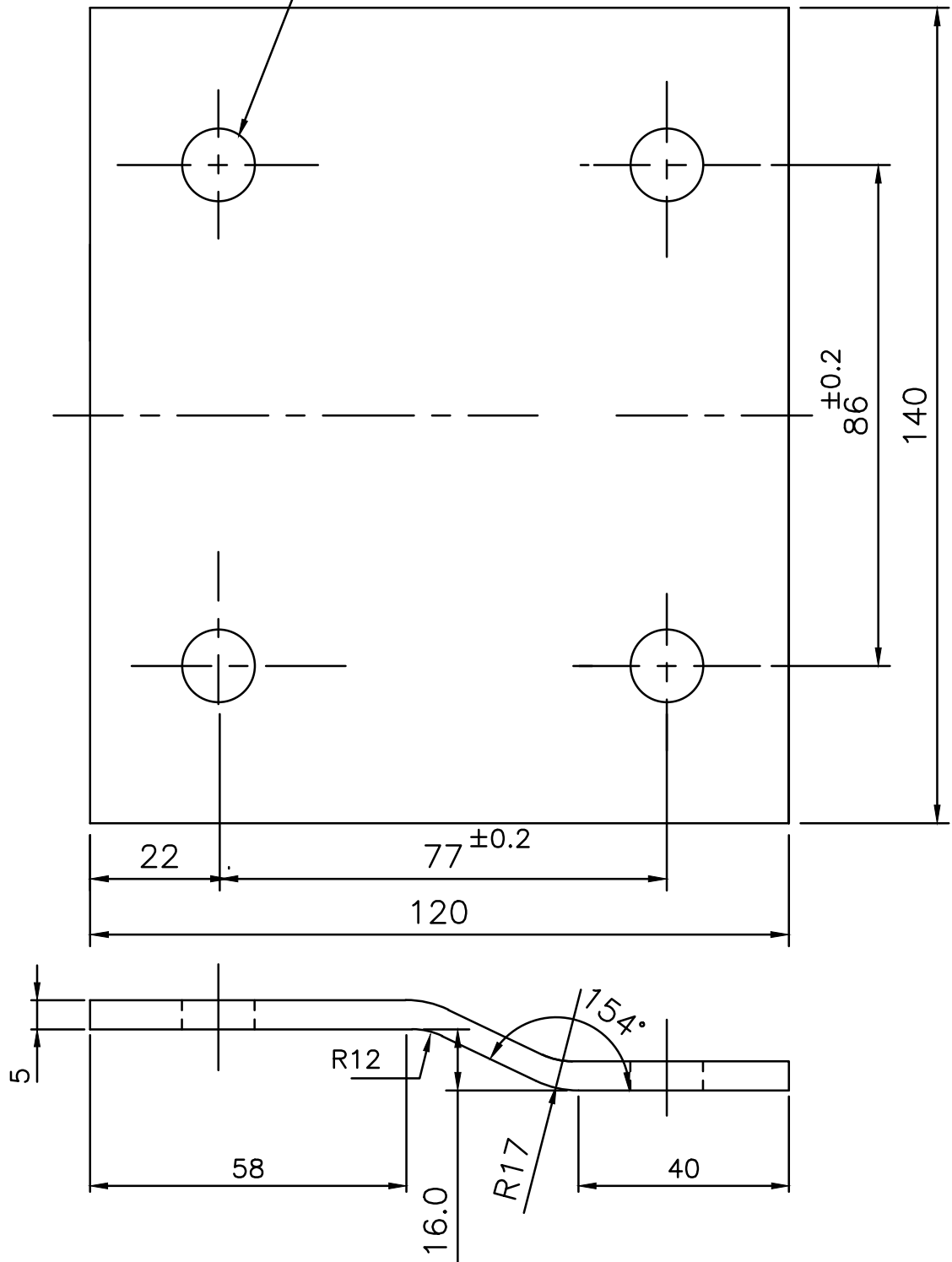
4

3

2

1

SHEET 79 OF 86

 $\begin{matrix} +0.2 \\ -0.0 \\ \phi 12.5(4\text{Nos}) \end{matrix}$


PROCESS : FABRICATION

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/CD&S	HEAD QA
DRAWN	DATE	NAME	H D S		MATERIAL: IS:961, St 55 HTW OR ASTM A 516 Gr.70	ADRDE ; AGRA	
CHECKED		SKS			FINISH: AS PER ANNEXURE 'A' (GREY)		
TRACED		JCD					
COMPARED			PRO.OFF.	PD	HEAT TREATMENT: NORMALIZED	APPROVED	
SCALE: NTS						HEAD (Q.A.)	
ALL DIMENSIONS IN MM			OI/C D & S		QTY.1No.	DRG.No.	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			BOTTOM PLATE CURVED PLATE SUB ASSY.-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				ADRDE 1404 11 01(a)(b)

(2)

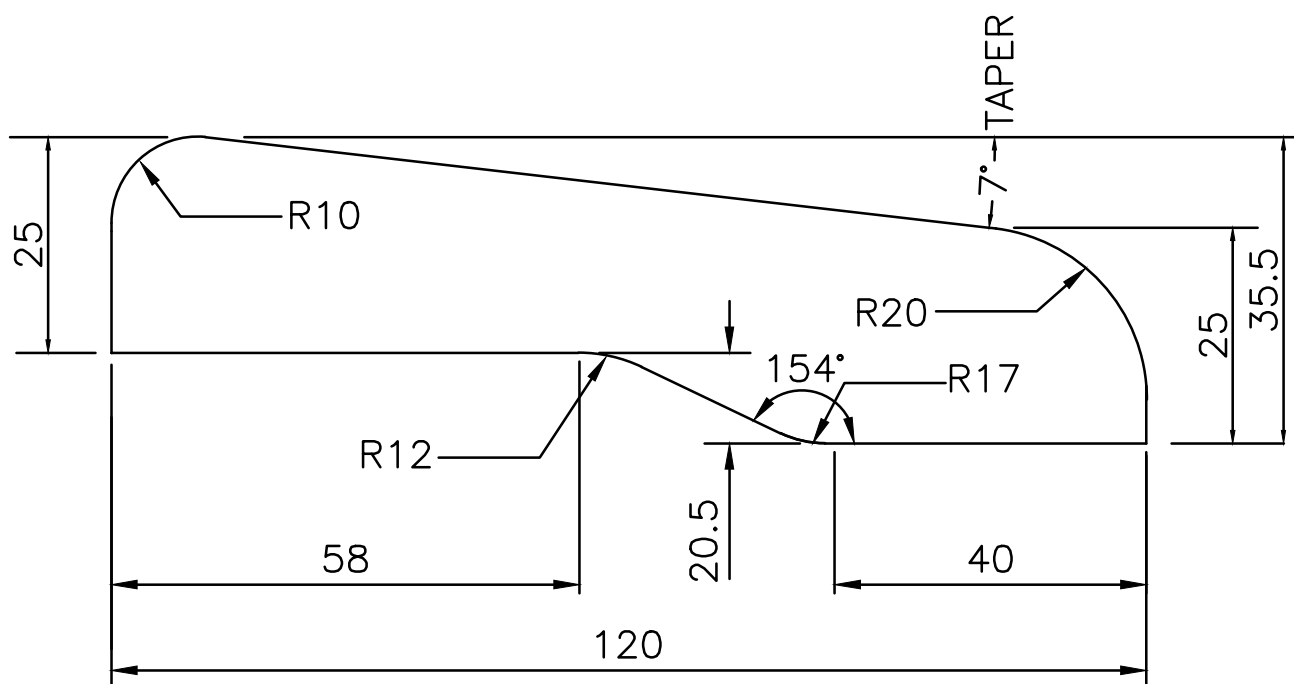
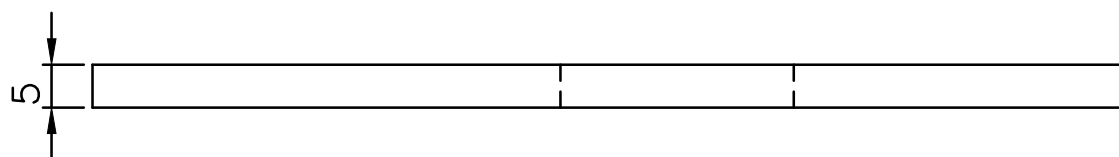
F

E

D

C

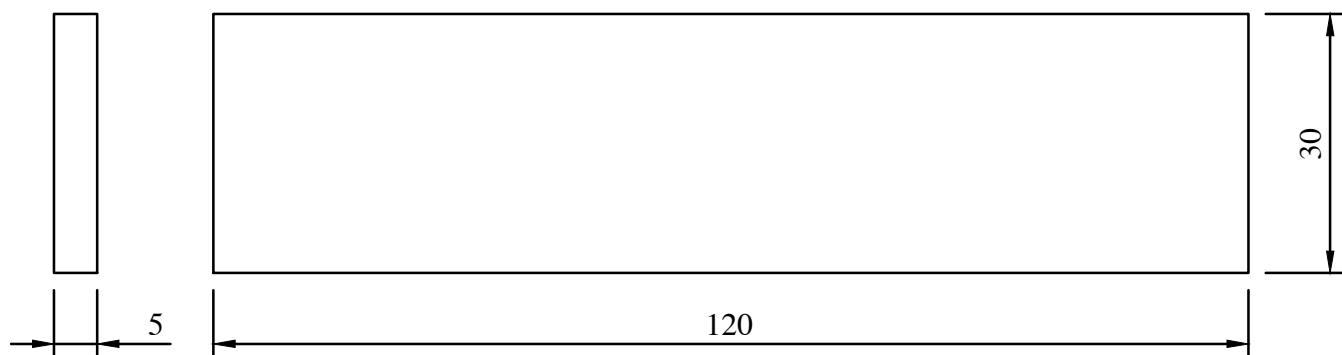
B



PROCESS : MACHINING

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C D&S	PGD
DRAWN	DATE	NAME	H D S		MATERIAL: IS:961, St 55 HTW OR <i>ASTM A 516 Gr.70</i>	ADRDE ; AGRA	
CHECKED		SKS	PRO.OFF.		FINISH: AS PER ANNEXURE 'A' (GREY)		
TRACED		JCD					
COMPARED			OI/C D & S		HEAT TREATMENT: <i>NORMALIZED</i>	APPROVED	
SCALE: NTS					QTY.: 1 No.	HEAD (Q.A.)	
ALL DIMENSIONS IN MM			SIDE PLATE			DRG.No.	
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			CURVED PLATE SUB ASSY-BEAM ASSEMBLY (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			ADRDE 1404 11 02(a)(b)	

3

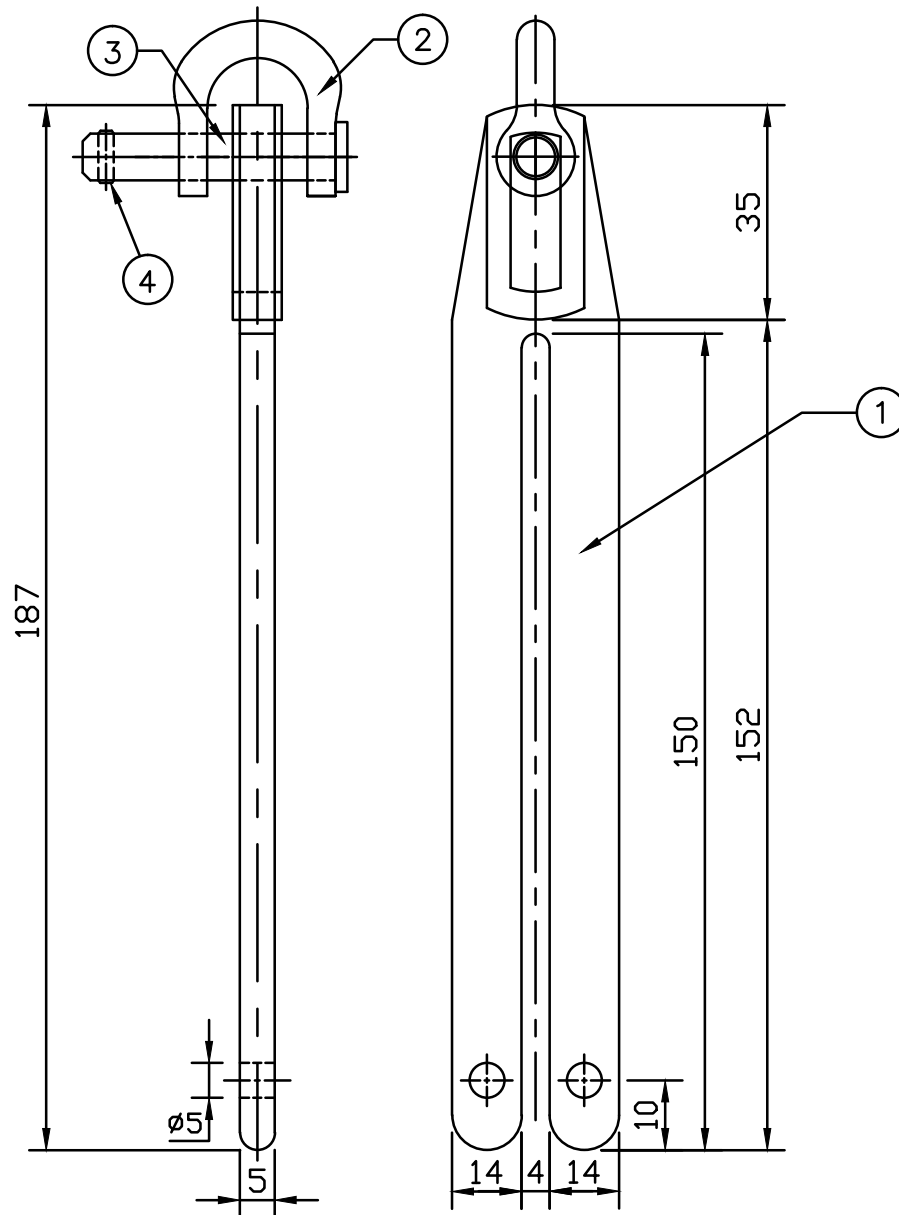


PROCESS : MACHINING

'a'	18-01-07		CH. SH. No.01	CHANGE IN NOMENCLATURE			
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C CAD	HEAD CAD
	DATE	NAME	H D S		MATERIAL:	ADRDE ; AGRA	
DRAWN		SKS	PRO.OFF. PD		IS: 961, St 55 HTW OR ASTM A 516 Gr.70		
CHECKED		JCD			FINISH:		
TRACED					AS PER ANNEXURE 'A' (GREY)		
COMPARED			OI/C D & S		HEAT TREATMENT:	APPROVED	
SCALE: NTS					NORMALIZED	HEAD (Q.A.)	
ALL DIMENSIONS IN MM					QTY.: 1 No.		
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			GUSSET CURVED PLATE SUB ASSY. LOCKING BEAM (BEAM ASSEMBLY) (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 11 03(a)(b)	

4	3	2	1
4	IS : 549	SPLIT PIN $\phi 2 \times 5Lg$	1
3	ADRDE1404 12 03(ϕ)(b)	PIN	1
2	ADRDE1404 12 02(ϕ)(b)	'D' SHACKLE	1
1	ADRDE1404 12 01(ϕ)(b)	FORK	1
SR.NO.	DRG/SPEC.NO.	DESIGNATION	QTY
			SHEET NO.

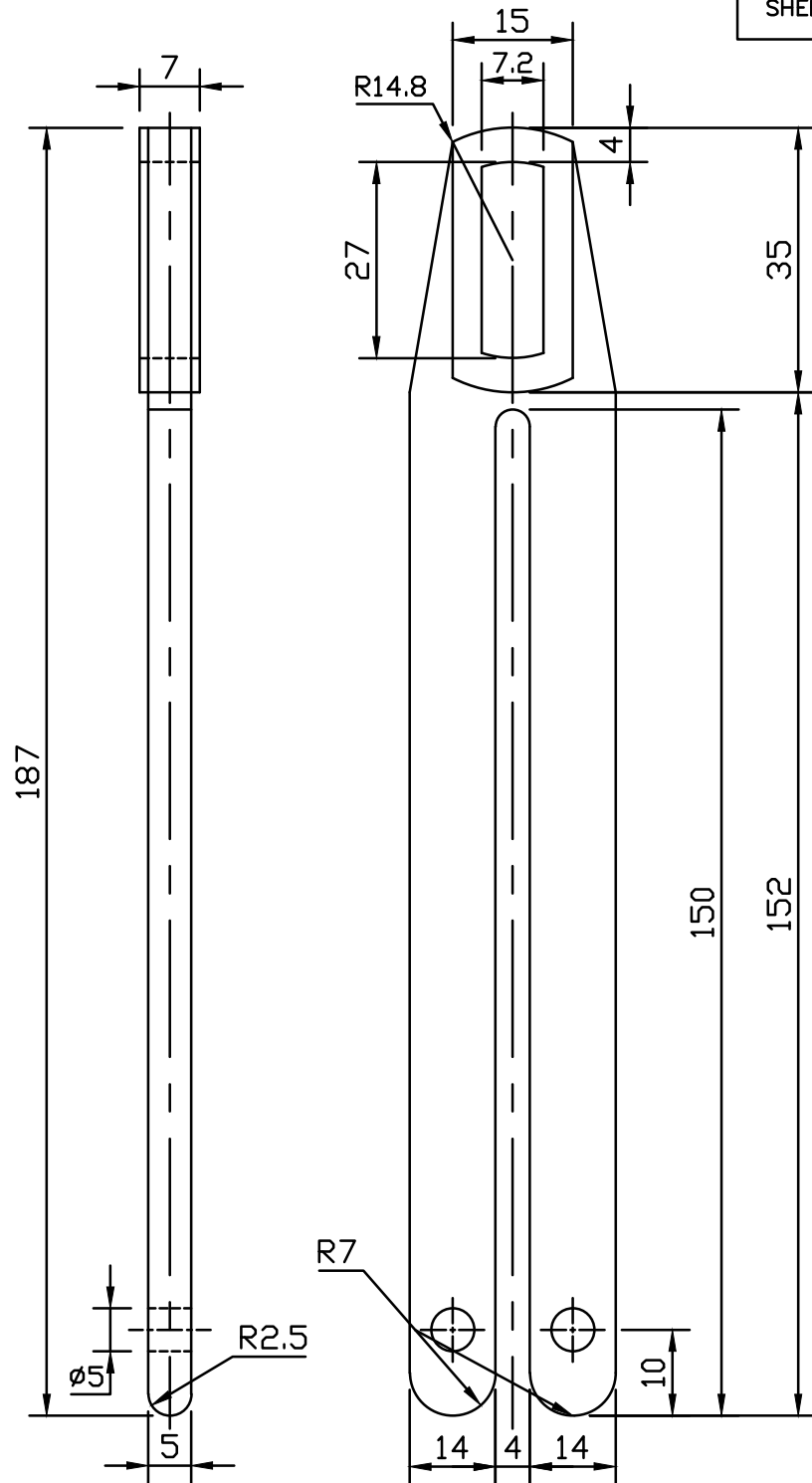
DETAIL INDEX



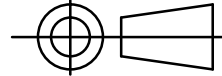
PROCESS : MACHINING

'a'	18-01-07	CH. SH. No.01	CHANGE IN NOMENCLATURE		
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	OI/C CAD HEAD CAD
	DATE	NAME	H D S	MATERIAL:	ADRDE ; AGRA
DRAWN		SKS			
CHECKED		JCD			
TRACED			PRO.OFF. PD	FINISH:	
COMPARED				HEAT TREATMENT:	APPROVED
SCALE: NTS					
ALL DIMENSIONS IN MM			OI/C D & S	QTY.: 1 No.	HEAD (Q.A.)
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM					DRG.No. ADRDE 1404 12 (ϕ)(b)

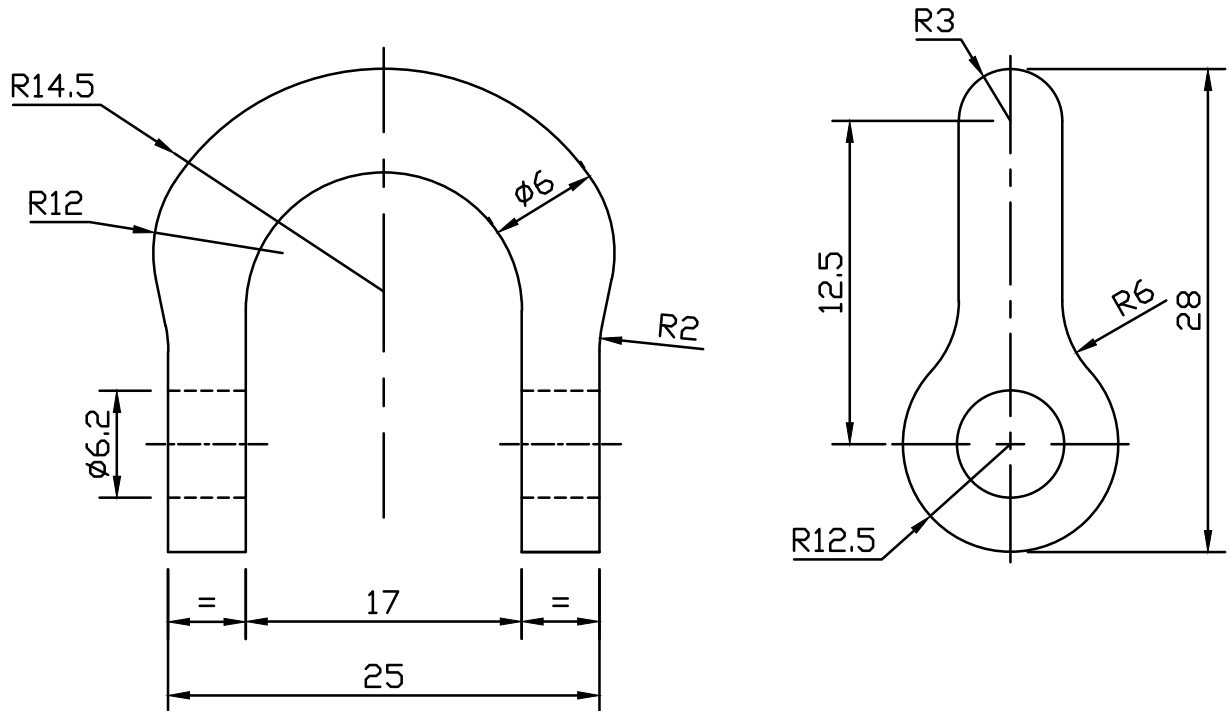
FORK SUB ASSEMBLY
LOCKING BEAM (BEAM ASSEMBLY)
(HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)



PROCESS : MACHINING

'a'	18-01-07		CH. SH. No.01	CHANGE IN NOMENCLATURE				
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			OI/C CAD	HEAD CAD
	DATE	NAME	H D S		MATERIAL:	ADRDE ; AGRA		
DRAWN		SKS	PRO.OFF.	PD	IS: 961, St 55 HTW OR ASTM A 516 Gr.70			
CHECKED		JCD			FINISH:HARD CHROMIUM(12-15 MICRON) AS PER IS: 1337			
TRACED					HEAT TREATMENT:		APPROVED	
COMPARED					NORMALIZED		HEAD (Q.A.)	
SCALE: NTS			OI/C D & S		QTY.: 1 No.			
ALL DIMENSIONS IN MM					DRG.No.			
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			FORK FORK SUB ASSY. LOCKING BEAM (BEAM ASSEMBLY) (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			ADRDE 1404 12 01(a)(b)		

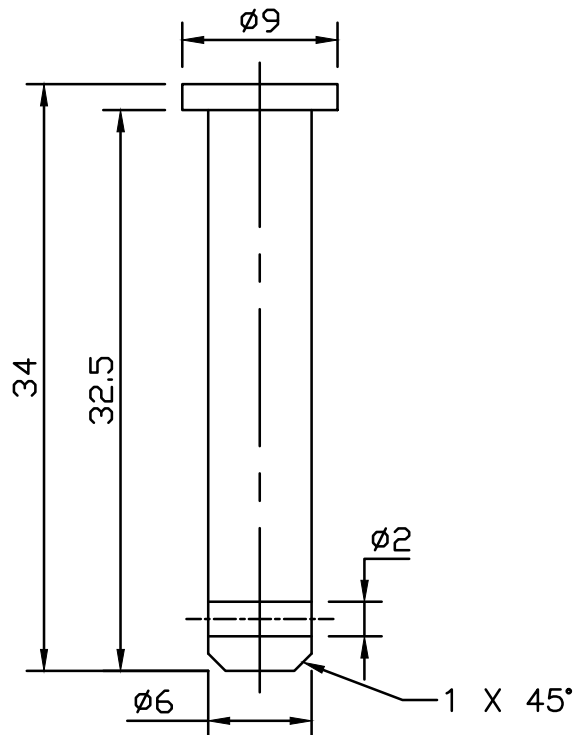
2



PROCESS : MACHINING

'a'	18-01-07		CH. SH. No.01	CHANGE IN NOMENCLATURE			
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C CAD	HEAD CAD
	DATE	NAME	H D S		MATERIAL:	ADRDE ; AGRA	
DRAWN		SKS			IS: 961, St 55 HTW OR ASTM A 516 Gr.70		
CHECKED		JCD			FINISH: AS PER ANNEXURE 'C'		
TRACED			PRO.OFF.	PD	HEAT TREATMENT:		
COMPARED					NORMALIZED	APPROVED	
SCALE: NTS					QTY.: 1 No.	HEAD (Q.A.)	
ALL DIMENSIONS IN MM			OI/C D & S				
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			'D' SHACKLE FORK SUB ASSY. LOCKING BEAM (BEAM ASSEMBLY) (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)				DRG.No. ADRDE 1404 12 02(a)(b)

3



PROCESS : MACHINING

'a'	18-01-07		CH. SH. No.01	CHANGE IN NOMENCLATURE			
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C CAD	HEAD CAD
	DATE	NAME	H D S		MATERIAL:	ADRDE ; AGRA	
DRAWN		SKS			IS: 961, St 55 HTW OR ASTM A 516 Gr.70		
CHECKED		JCD			FINISH:		
TRACED			PRO.OFF.	PD	AS PER ANNEXURE 'C'	APPROVED	
COMPARED					HEAT TREATMENT:	HEAD (Q.A.)	
SCALE: NTS					NORMALIZED		
ALL DIMENSIONS IN MM			OI/C D & S		QTY.: 1 No.		
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			PIN FORK SUB ASSY. LOCKING BEAM (BEAM ASSEMBLY) (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 12 03(ø)(b)	

8

7

6

5

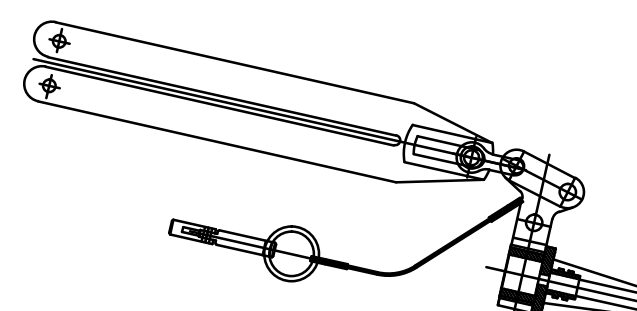
4

3

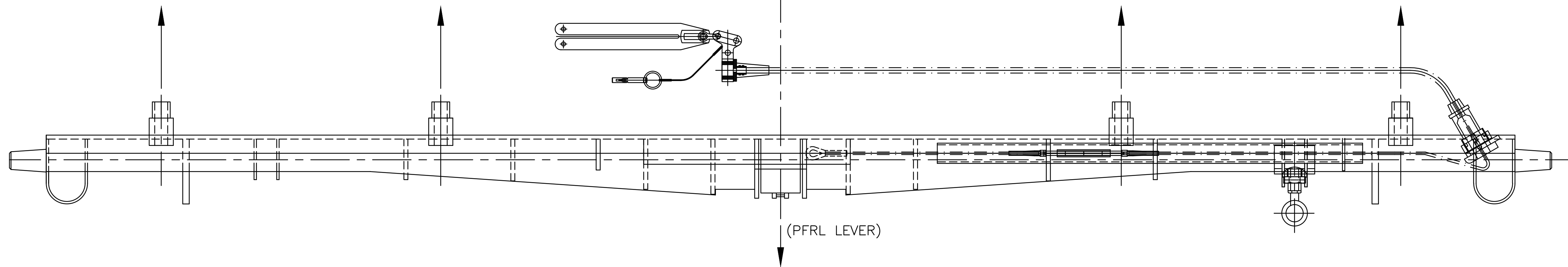
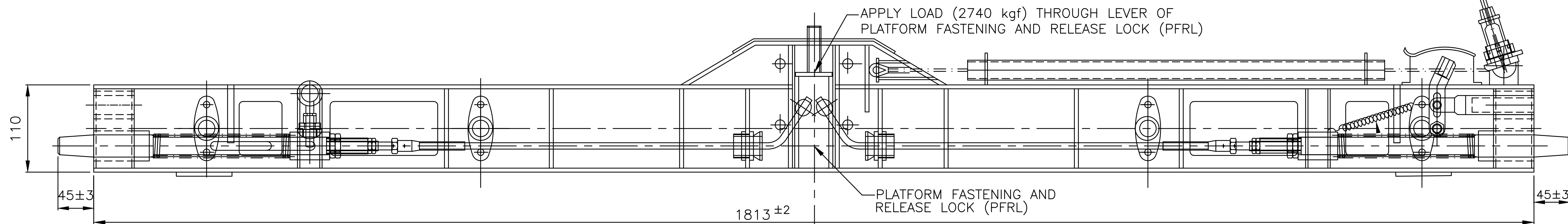
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1

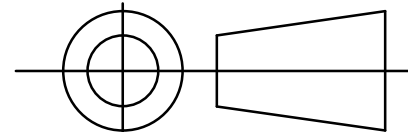
SHEET 86 OF 86



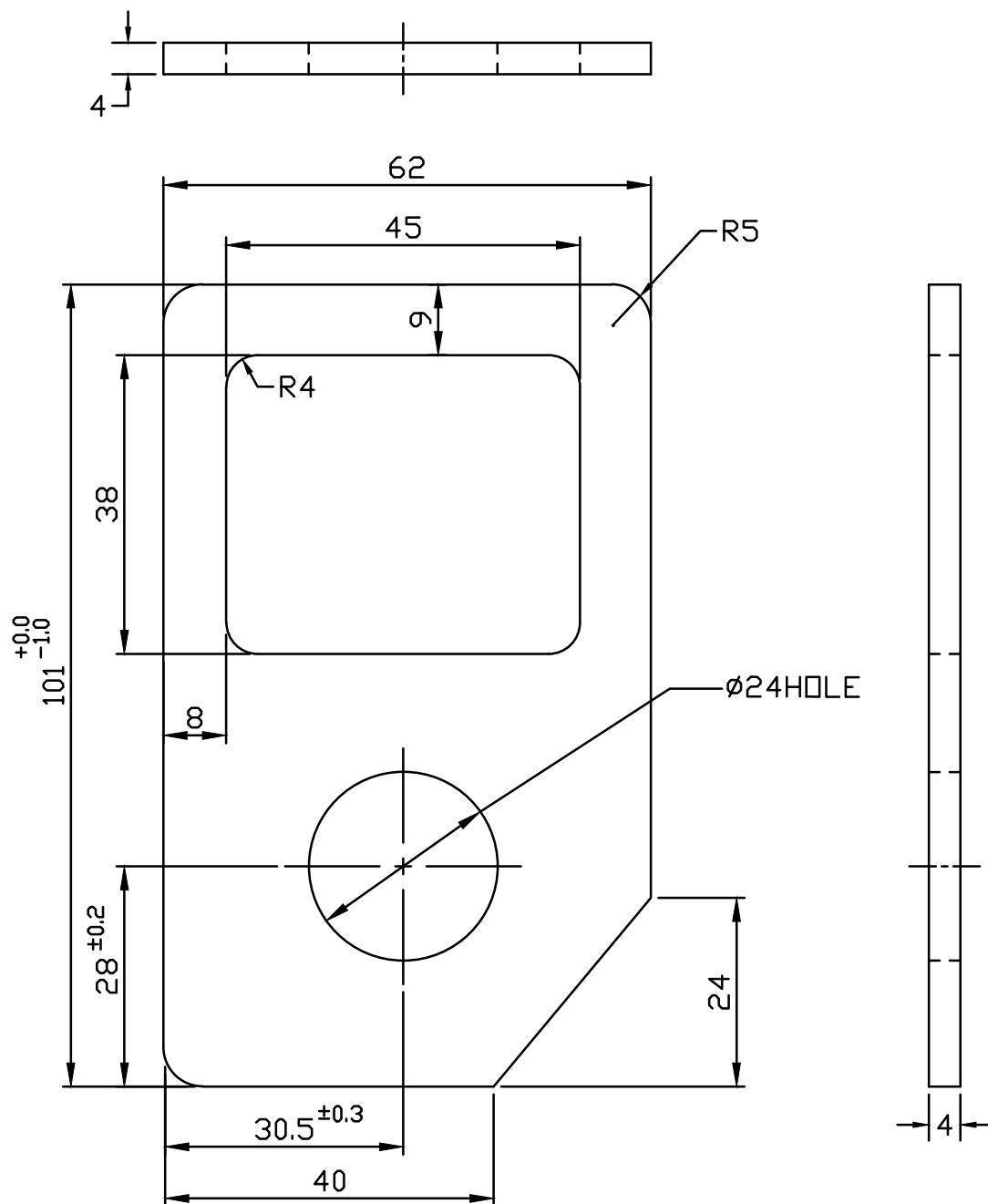
CHANGE OVER CABLE MECHANISM



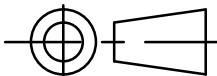
PROOF LOAD TEST:-
BEAM ASSEMBLY TO BE TESTED FOR 2740 KG LOAD.

	DATE	NAME	H D S		MATERIAL: _____	ADRDE ; AGRA	
DRAWN		SKS					
CHECKED		JCD					
TRACED			PRO.OFFR.	PD	FINISH: _____	APPROVED	
COMPARED					HEAT TREATMENT: _____		
SCALE: NTS					QTY : 1No.		
ALL DIMENSIONS IN MM		OI/C D & S					
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 VERY COARSE			TESTING METHOD LOCKING BEM (BEAM ASSEMBLY) (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE 1404 13(ø)(b)	

'a'	18-01-07	A-2,3	CHANGE SHEET No. 01	CHANGE IN NOMENCLATURE		
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/C CAD	HEAD CAD



PROCESS :- MACHINING

'a'	18-01-07		CH. SH. No.01	CHANGE IN NOMENCLATURE			
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		OI/C CAD	HEAD CAD
	DATE	NAME	H D S		MATERIAL: IS:961,St 55 HTW OR ASTM A 516 GR.70	ADRDE ; AGRA	
DRAWN		SKS	PRO.OFF.	PD		FINISH: AS PER ANNEXURE'A' (GREY)	
CHECKED		JCD					
TRACED							
COMPARED			OI/C D & S		HEAT TREATMENT:	APPROVED	
SCALE: NTS					NORMALIZED	HEAD (Q.A.)	
ALL DIMENSIONS IN MM					QTY.: 2 Nos.		
TOLERANCE: UNLESS OTHERWISE SPECIFIED IS:2102(PART1) :1993 MEDIUM			PLATE-E FABRICATED CHANNEL LOCKING BEAM (BEAM ASSEMBLY) (HEAVY DROPPING SYSTEM FOR AN-32 AIRCRAFT)			DRG.No. ADRDE1404 01 07(a)(b)	