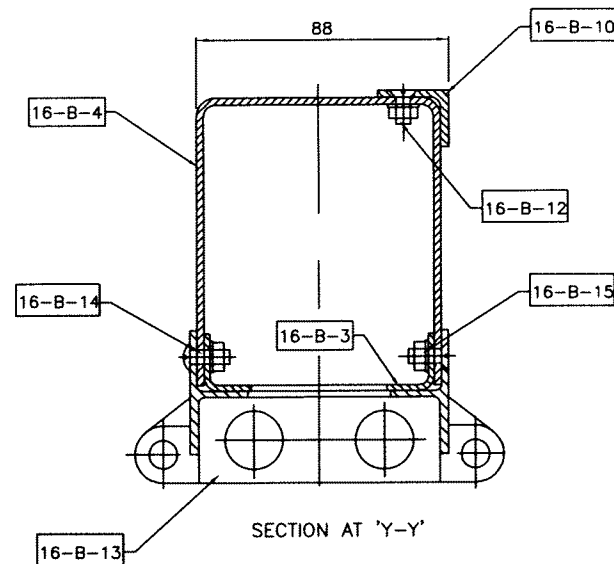
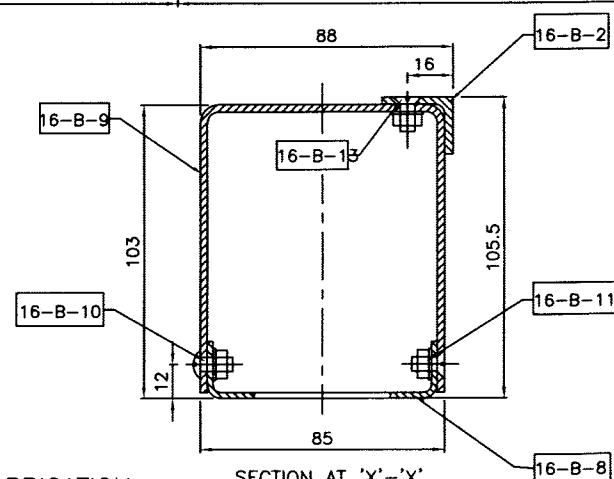
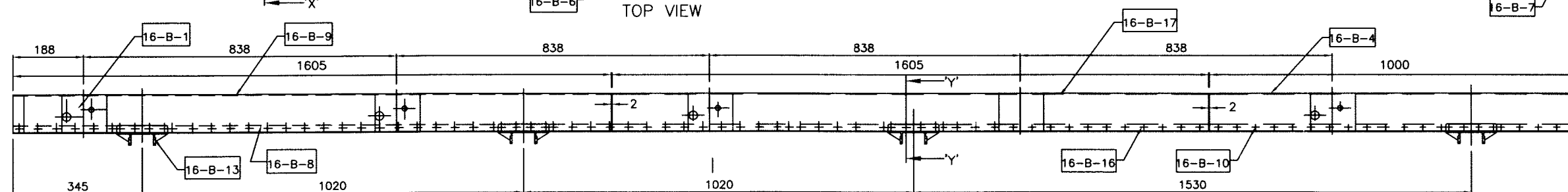
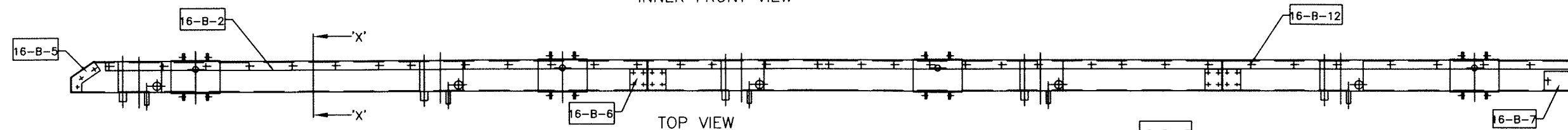
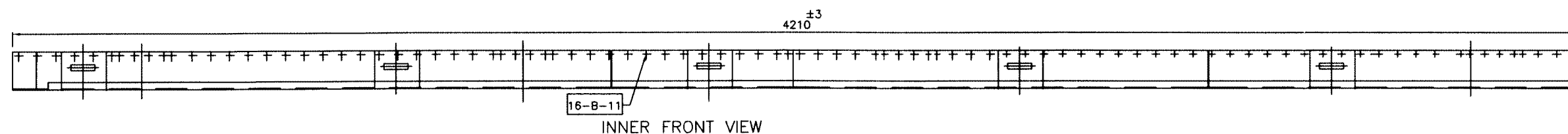


16-B



16-B-17	CHANNEL LARGE-MIDDLE	1	169
16-B-16	CHANNEL SMALL-MIDDLE	3	168
16-B-15	CSK HEAD SCREW M5x20	16	—
16-B-14	SLOTTED PAN HEAD SCREW M5x15	16	—
16-B-13	GUIDE RAIL FITTING	4	—
16-B-12	CSK HEAD SCREW M5x15	36	—
16-B-11	CSK HEAD SCREW M5x15	76	—
16-B-10	SLOTTED PAN HEAD SCREW M5x15	76	—
16-B-9	CHANNEL LARGE-FRONT	1	167
16-B-8	CHANNEL SMALL-FRONT	1	166
16-B-7	END PLATE	1	165
16-B-6	JOINT	2	164
16-B-5	END COVER	1	163
16-B-4	CHANNEL LARGE-REAR	1	162
16-B-3	CHANNEL SMALL-REAR	1	161
16-B-2	FRONT ANGLE	1	160
16-B-1	LOCK SUB ASSEMBLY	5	133-159
ITEM	DESCRIPTION	QTY	DRAWING./SPEC.No. SHEET No.

DETAIL INDEX



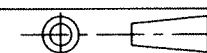
PROCESS :- FABRICATION

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	I/C D&S	HEAD Q.A.
1		2		3	4	

SCALE:- NTS	QTY:- 2 Nos.
DIMENSIONS IN mm	
TOLERANCE:- IS:2102(PART-1)-1993 VERY COARSE UNLESS OTHERWISE SPECIFIED	
MATERIAL:-	

FINISH:-
AS PER SHEET No. 215

HEAT TREATMENT:-

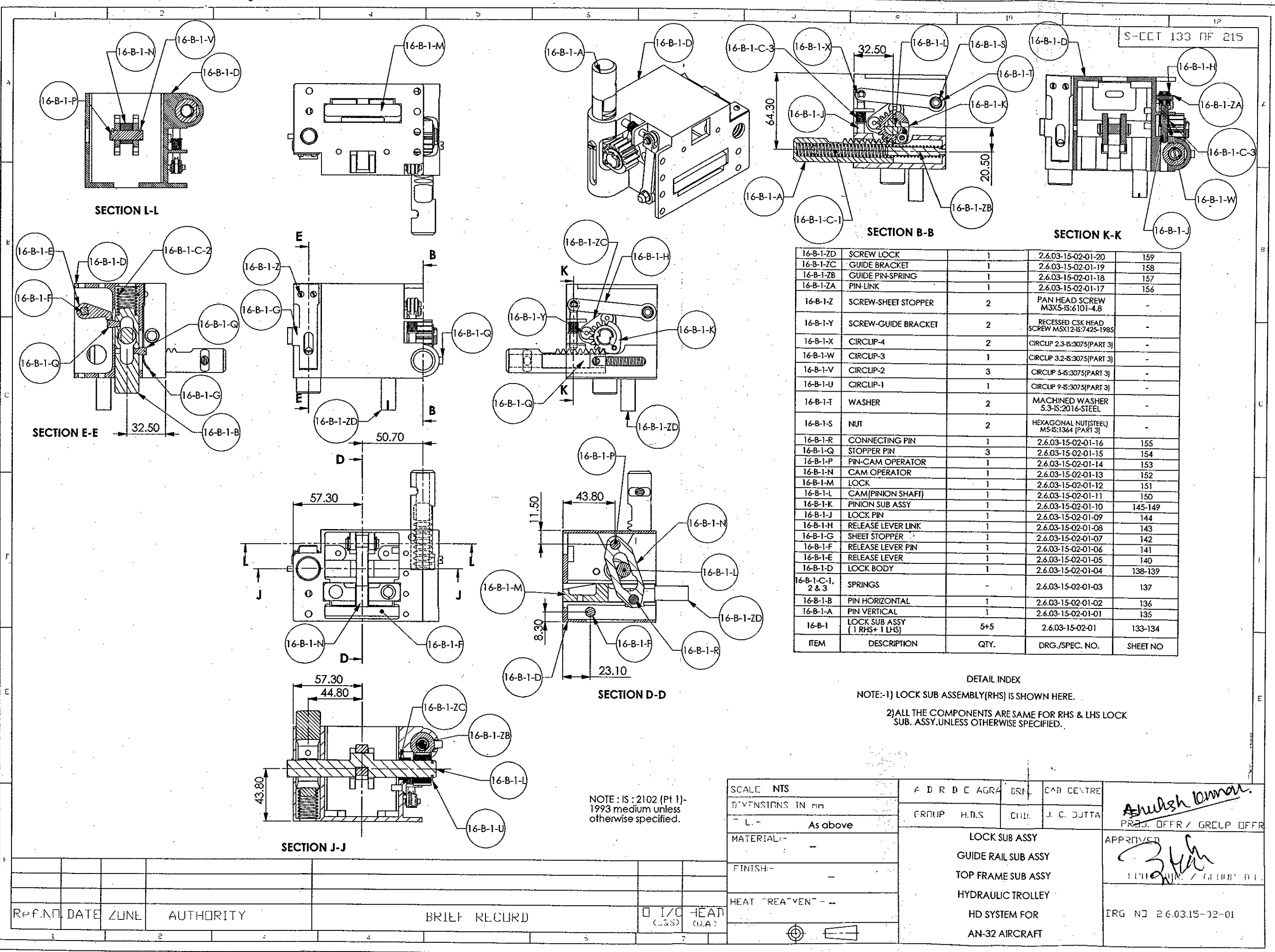


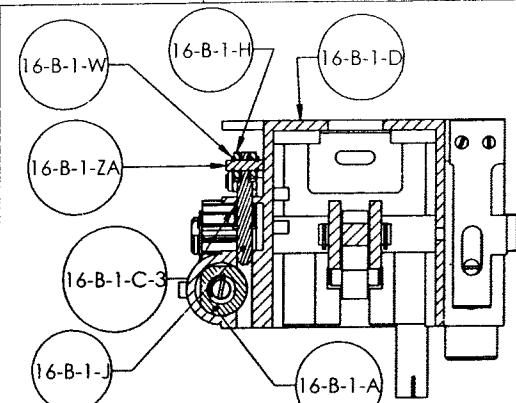
A D R D E AGRA	DRN.	SK SHARMA
GROUP:- HDS	CHKD.	JC DUTTA

GUIDE RAIL SUB ASSEMBLY
(L.H. SIDE & R.H. SIDE)
FRAME SUB ASSY.
TOP FRAME SUB ASSY.
HYDRAULIC TROLLEY
H D SYSTEM
FOR AN-32 AIRCRAFT

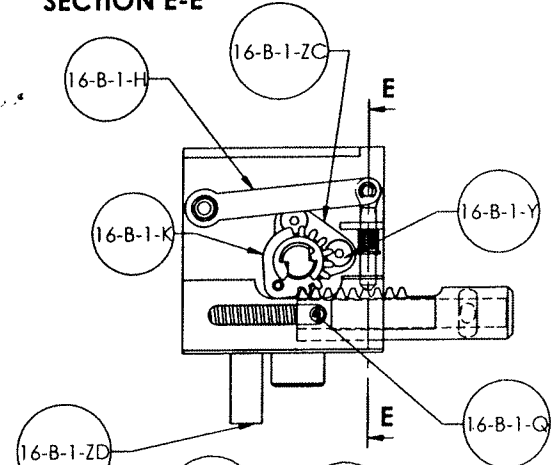
APPROVED
Ashu Sharma
PROJ.OFFR./GP.OFFR.
2 Feb
PROJ. DIR./GP.DIR.
DRG. No.

2.6.03-15-02

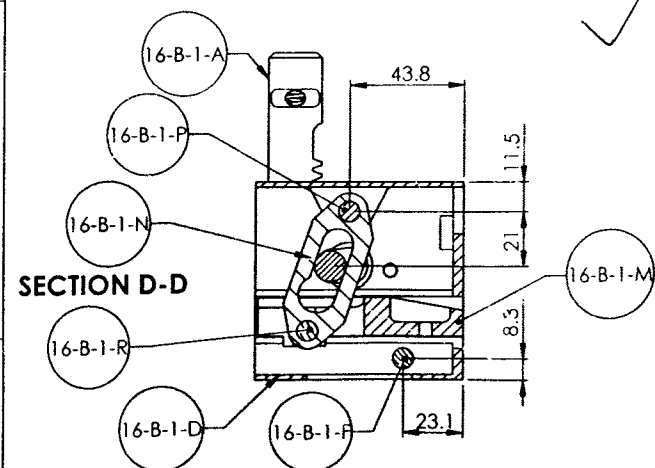




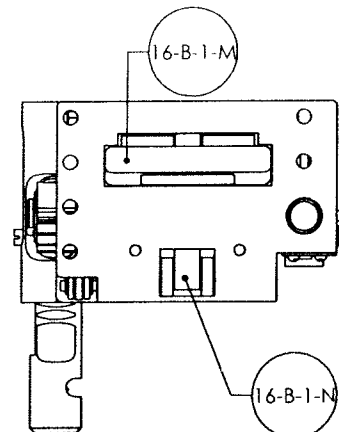
SECTION E-E



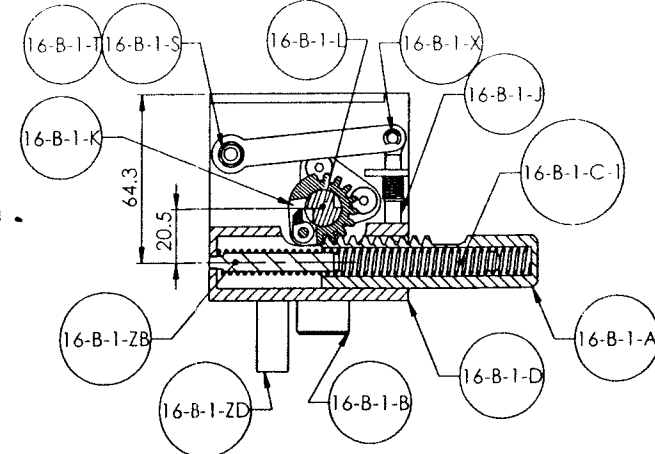
SECTION F-F



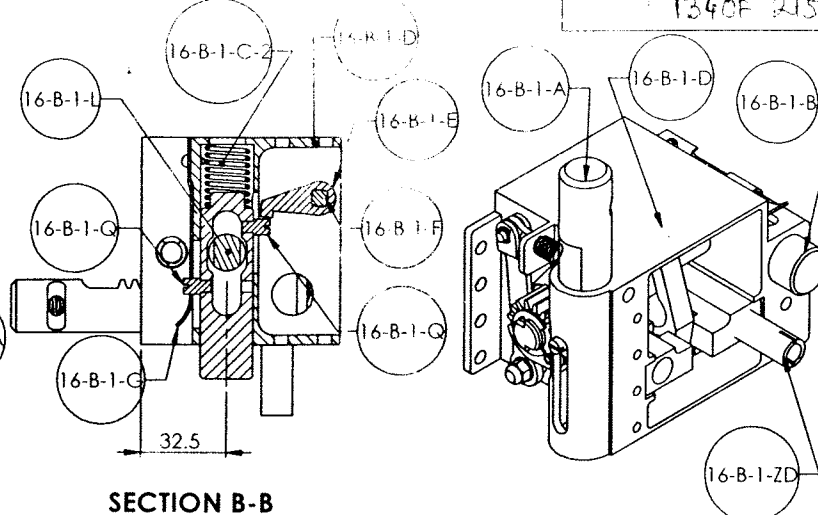
SECTION D-D



SECTION A-A



SECTION B-B



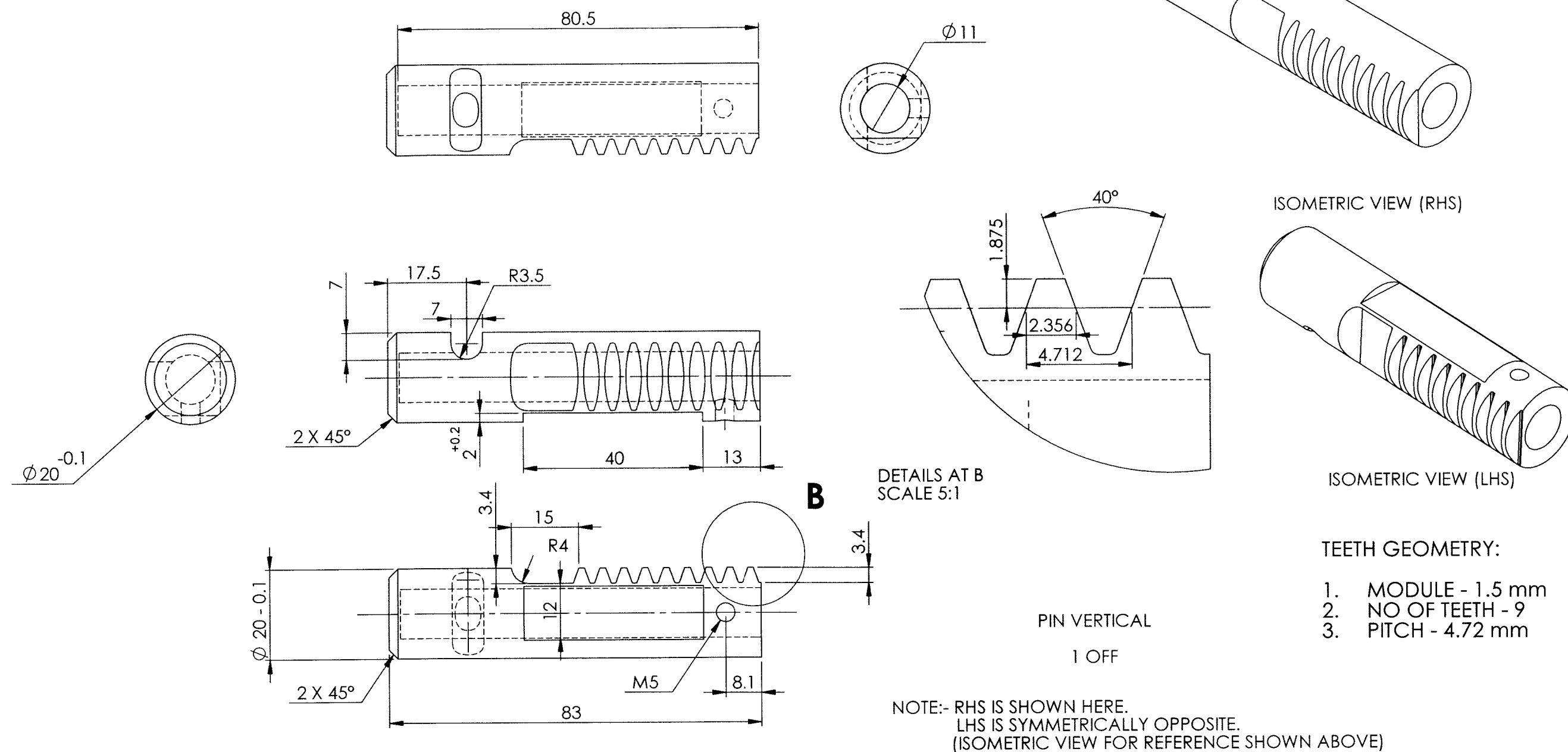
SECTION C-C

16-B-1-ZD	SCREW LOCK	1	2.6.03-15-02-01-20	159
16-B-1-ZC	GUIDE BRACKET	1	2.6.03-15-02-01-19	158
16-B-1-ZB	GUIDE PIN-SPRING	1	2.6.03-15-02-01-18	157
16-B-1-ZA	PIN-LINK	1	2.6.03-15-02-01-17	156
16-B-1-Z	SCREW-SHEET STOPPER	2	PAN HEAD SCREW M3X5-IS:6101-4.8	-
16-B-1-Y	SCREW-GUIDE BRACKET	2	RECESSED CSK HEAD SCREW M5X12-IS:7425-1985	-
16-B-1-X	CIRCLIP-4	2	CIRCLIP 2.3-IS:3075(PART 3)	-
16-B-1-W	CIRCLIP-3	1	CIRCLIP 3.2-IS:3075(PART 3)	-
16-B-1-V	CIRCLIP-2	3	CIRCLIP 5-IS:3075(PART 3)	-
16-B-1-U	CIRCLIP-1	1	CIRCLIP 9-IS:3075(PART 3)	-
16-B-1-T	WASHER	2	MACHINED WASHER 5.3-IS:2016 STEEL	-
16-B-1-S	NUT	2	HEXAGONAL NUT(STEEL)M5-IS:1364(PART 3)	-
16-B-1-R	CONNECTING PIN	1	2.6.03-15-02-01-16	155
16-B-1-Q	STOPPER PIN	3	2.6.03-15-02-01-15	154
16-B-1-P	PIN-CAM OPERATOR	1	2.6.03-15-02-01-14	153
16-B-1-N	CAM OPERATOR	1	2.6.03-15-02-01-13	152
16-B-1-M	LOCK	1	2.6.03-15-02-01-12	151
16-B-1-L	CAM(PINION SHAFT)	1	2.6.03-15-02-01-11	150
16-B-1-K	PINION SUB ASSY	1	2.6.03-15-02-01-10	145-149
16-B-1-J	LOCK PIN	1	2.6.03-15-02-01-09	144
16-B-1-H	RELEASE LEVER LINK	1	2.6.03-15-02-01-08	143
16-B-1-G	SHEET STOPPER	1	2.6.03-15-02-01-07	142
16-B-1-F	RELEASE LEVER PIN	1	2.6.03-15-02-01-06	141
16-B-1-E	RELEASE LEVER	1	2.6.03-15-02-01-05	140
16-B-1-D	LOCK BODY	1	2.6.03-15-02-01-04	138-139
16-B-1-C-1, 2 & 3	SPRINGS	---	2.6.03-15-02-01-03	137
16-B-1-B	PIN HORIZONTAL	1	2.6.03-15-02-01-02	136
16-B-1-A	PIN VERTICAL	1	2.6.03-15-02-01-01	135
16-B-1	LOCK SUB ASSY(1 LHS+1 RHS)	5+5	2.6.03-15-02-01	133-134
ITEM	DESCRIPTION	QTY.	DRG./SPEC.No.	SHEET NO.

DETAIL INDEX
NOTE:- 1) LOCK SUB ASSEMBLY (LHS) IS SHOWN HERE.
 TOLERANCE : IS : 2102 (PT-1)-1993 medium unless otherwise specified.

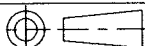
As above	LOCK SUB ASSY	As above
As above	GUIDE RAIL SUB ASSY	As above
As above	TOP FRAME SUB ASSY	As above
As above	HYDRAULIC ROLLER	As above
As above	HD SYSTEM FOR	As above
As above	AND AIR RAIL	As above

16-B-1-A

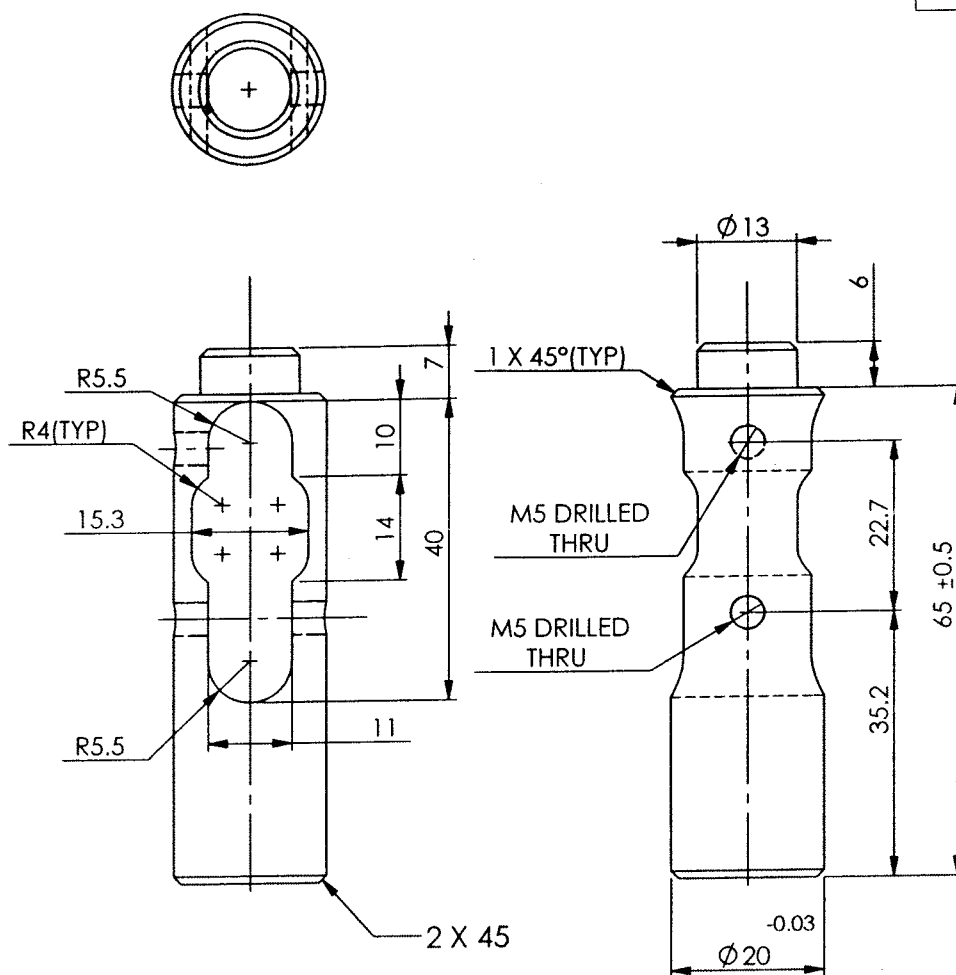


TOLERANCE:- IS:2102(PART-1) 1993 MEDIUM UNLESS OTHERWISE SPECIFIED

PROCESS:- MACHINING

SCALE:- 1:1	A D R D E AGRA	DRN	CAD CENTRE	APPROVED <i>A. Subashky</i> PROD. OFFR./ GP. OFFR.
DIMENSIONS IN mm	GROUP:- HDS	CHD.	J.C. DUTTA	
TOL:- AS ABOVE	PIN VERTICAL LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT			PROD. OFFR./ GP. OFFR.
MATERIAL:- ALLOY STEEL 709M40/817M40(EN19/EN24), AS PER BS:970				APPROVED
FINISH:- AS PER PARA SHEET No. 215				<i>2 Feb</i> PROD. OFFR./ GP. OFFR.
HEAT TREATMENT:- HARDENED & TEMPERED 32±5 HRC				DRG. NO.
				2.6.03-15-02-01-0

16-B-1-B



TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED.

PROCESS:- FABRICATION

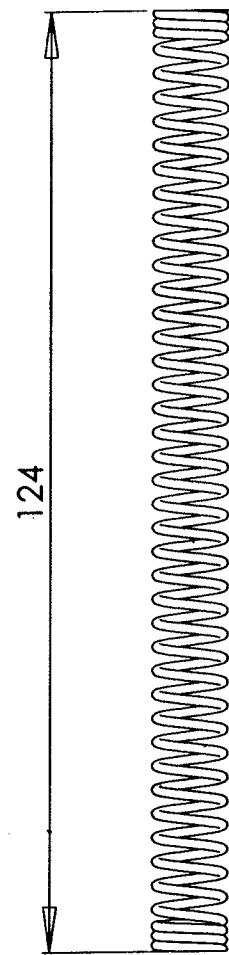
PIN HORIZONTAL

1 OFF

5

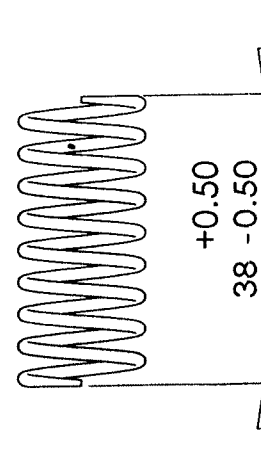
Ref No	DATE	ZONE	AUTHORITY	BRIEF RECORD			GROUP
							(Q A)
SCALE: 1:1				APPROVED BY	DRN	CAD CENTER	<i>Ashish</i> PROJECTS/ENGINEER
DIMENSIONS IN mm				INSTRUMENT	CHD	UNIT BUTTA	
TE. AS ABOVE							APPROVED BY
MATERIAL: ALLOY STEEL 709M40/817M40 (EN19/EN24). AS PER BS:970				LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT			<i>Ashish</i> for TEST CRASH TEST
FINISH: AS PER SHEET No. 215							
TREATMENT: HARDENED & TEMPERED 32±5 HRC							
							2.6.03-15-02-01-02

16-B-1-C



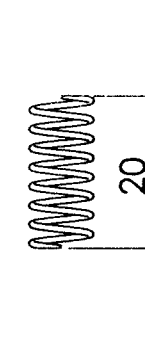
1. OUTSIDE DIAMETER = 10 mm
2. WIRE DIAMETER = ϕ 1.2 mm
3. TOTAL No. OF COILS = 42
4. TOTAL No. OF EFFECTIVE COILS = 40
5. ENDS ARE GROUND SQUARE TO AXIS
6. STIFFNESS OF SPRING = 0.083 kg/mm

16-B-1-C-1



1. INSIDE DIAMETER = 14 mm
2. WIRE DIAMETER = ϕ 1.6 mm
3. TOTAL No. OF COILS = 9
4. TOTAL No. OF EFFECTIVE COILS = 7
5. ENDS ARE GROUND SQUARE TO AXIS
6. STIFFNESS OF SPRING = 0.26 kg/mm

16-B-1-C-2



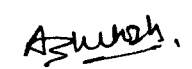
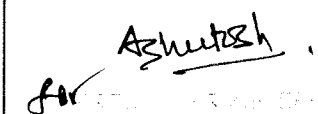
1. OUTSIDE DIAMETER = 8 mm
2. WIRE DIAMETER = 0.8 mm
3. TOTAL No. OF COILS = 8
4. TOTAL No. OF EFFECTIVE COILS = 6
5. ENDS ARE GROUND SQUARE TO AXIS
6. STIFFNESS OF SPRING = 0.10 kg/mm

16-B-1-C-3

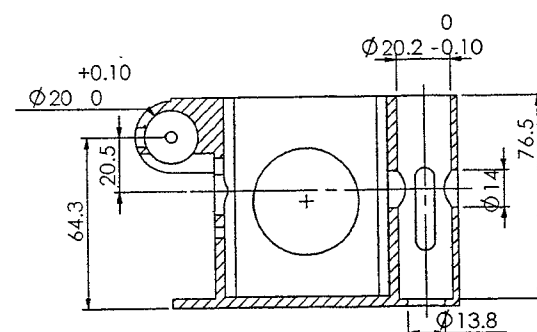
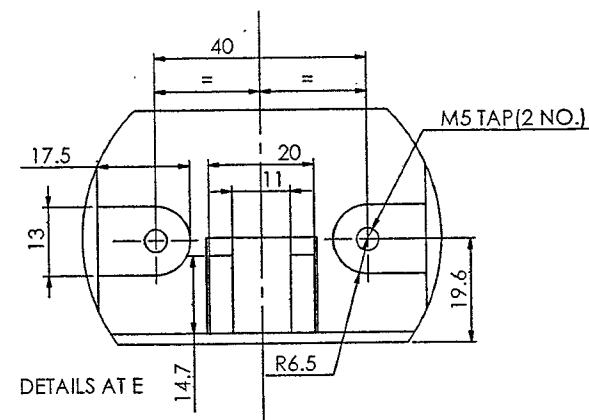
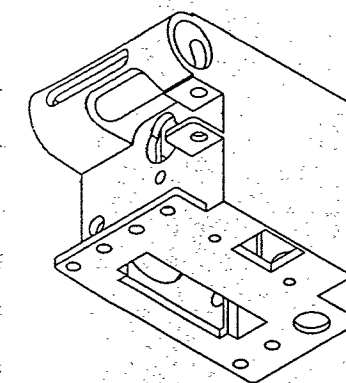
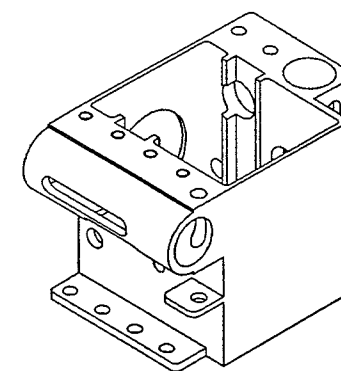
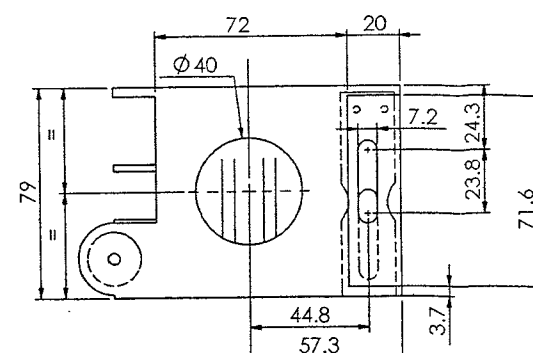
16-B-1-C-3	SPRING SMALL	1	26.03-15-02-01-03
16-B-1-C-2	SPRING LARGE	1	26.03-15-02-01-03
16-B-1-C-1	SPRING-VERTICAL PIN	1	26.03-15-02-01-03
ITEM	DESCRIPTION	QTY.	DRG./SPEC.No.

DETAIL INDEX SPRINGS

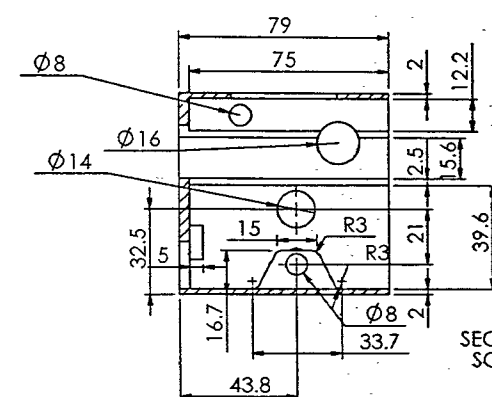
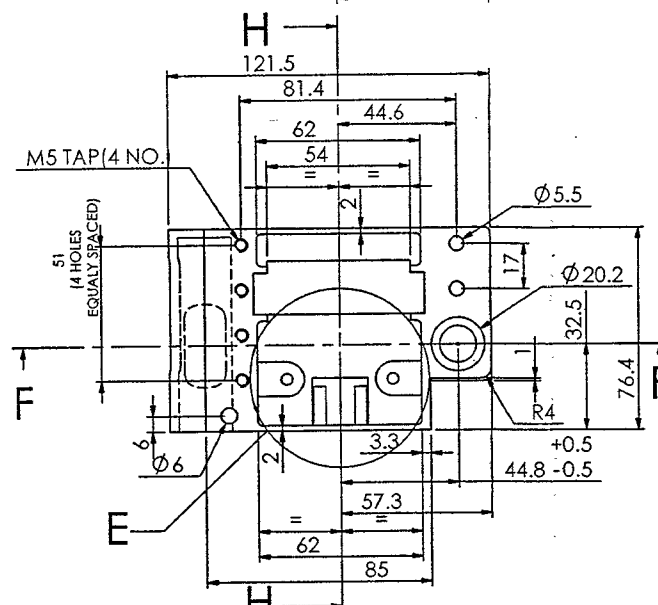
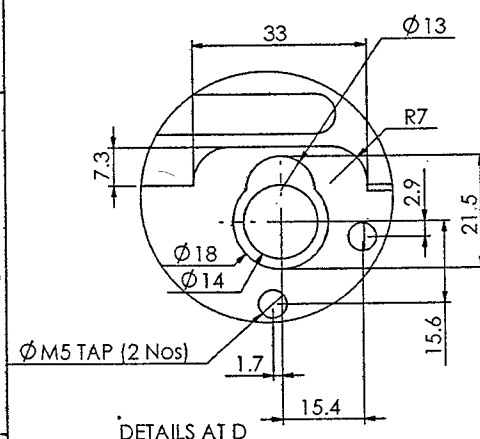
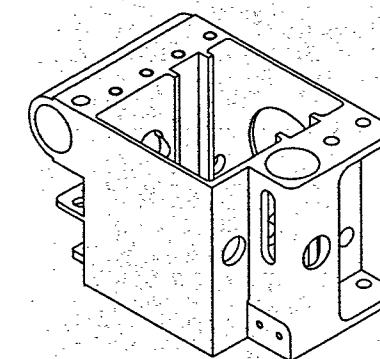
TOLERANCE:- IS:2102(PART-1)-1993 VERY COARSE UNLESS OTHERWISE SPECIFIED.
PROCESS:- FABRICATION

SCALE:- 1:1	A D R D E A R N	DRN	DAD CENTRE	 26.03-15-02-01-03
DIMENSIONS IN mm	GROUP	HDS	LD	
FINISH AS ABOVE				
MATERIAL:- STAINLESS SPRING STEEL WIRE IS:4454:2001 (PART-4) Gr. 1	LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT			 26.03-15-02-01-03
FINISH:- NATURAL				
REMARKS				

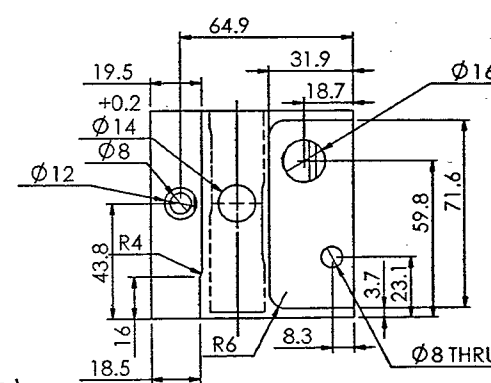
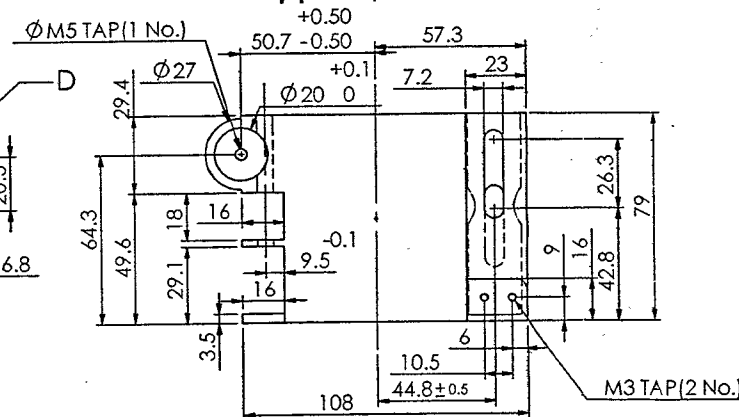
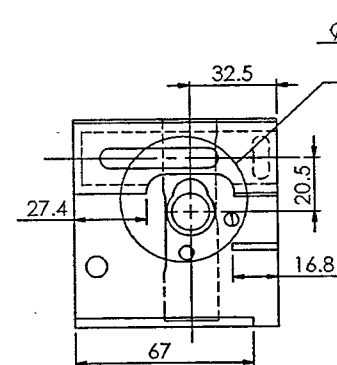
16-B-1-D

SECTION F-F
SCALE 1:2

DETAILS AT E

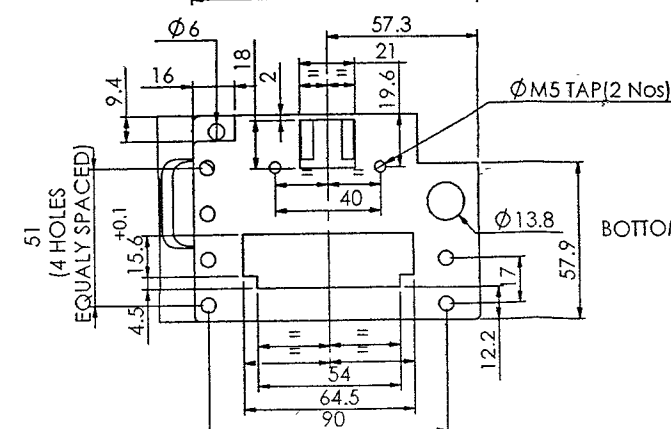
SECTION H-H
SCALE 1:2

DETAILS AT D

LOCK BODY
1 OFF

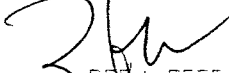
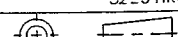
NOTE:-1) LOCK BODY(RHS) SHOWN HERE

PROCESS:- FABRICATION



BOTTOM

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	D 1/0 HEAD

SCALE: NTS	A D R D E AGRA	DRN.	CAD CENTRE	<u>Abhishek</u> PRJ. OFFR / GP OFFR
DIMENSIONS IN MM	GROUP: HDS	CHD	J. C. DUTTA	
TOL: IS:2102(PH-1)-1993 VERY COARSE UNLESS OTHERWISE SPECIFIED.	LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT			APPROVED  PRJ. OFFR / GP OFFR
MATERIAL: ALLOY STEEL 709M40/817M40(EN19/EN24), AS PER BS:970				APPROVED PRJ. OFFR / GP OFFR
FINISH: AS PER SHEET No. 215				PRJ. OFFR / GP OFFR
HEAT TREATMENT: HARDENED & TEMPERED 32±5 HRC				PRJ. OFFR / GP OFFR
 8403-15-02-11-04R				

1

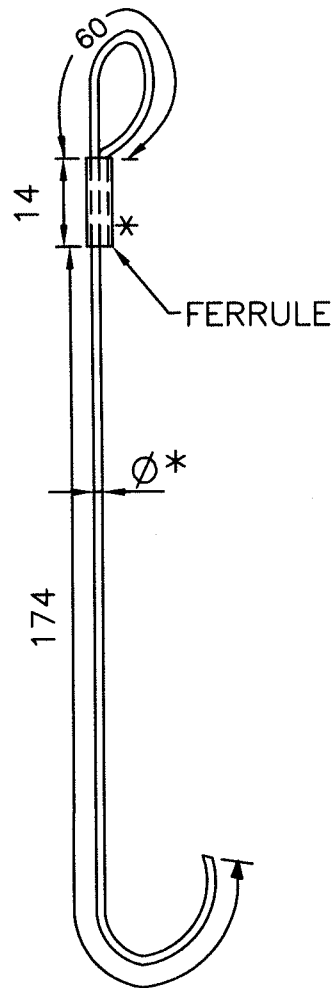
2

3

4

SHEET 130 OF 215

16-A-11-P-3-F



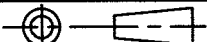
ARMING WIRE
1-OFF

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

NOTE:—Suitable copper ferruling with smooth finish.

TOLERANCE:— IS:2102 (PART-1)–1993 V.COARSE UNLESS OTHERWISE SPECIFIED.
PROCESS:— FABRICATION

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		□ I/C D&S	HEAD Q.A.

SCALE:-NTS	A D R D E AGRA	DRN.	YOGESH	Ashish Kumar PROJ.OFFR./GP.OFFR.
DIMENSIONS IN mm	GROUP:-HDS	CHKD.	JC DUTTA	
TOL:- AS ABOVE	LOCK PIN SUB ASSY. BRACKET SUB ASSEMBLY FRAME SUB ASSY. TOP FRAME STRUCTURE SUB ASSY. TOP FRAME SUB ASSY. HYDRAULIC TROLLEY H D SYSTEM FOR AN-32 AIRCRAFT			APPROVED
MATERIAL:- _____				2 fch PROJ. DIR./GP.DIR.
FINISH:- _____				
HEAT TREATMENT:- _____				
				DRG. No. 2.6.03-15-01-07-14-03-06

1

2

3

4

SHEET 131 OF 215

16-A-11-P-3-H

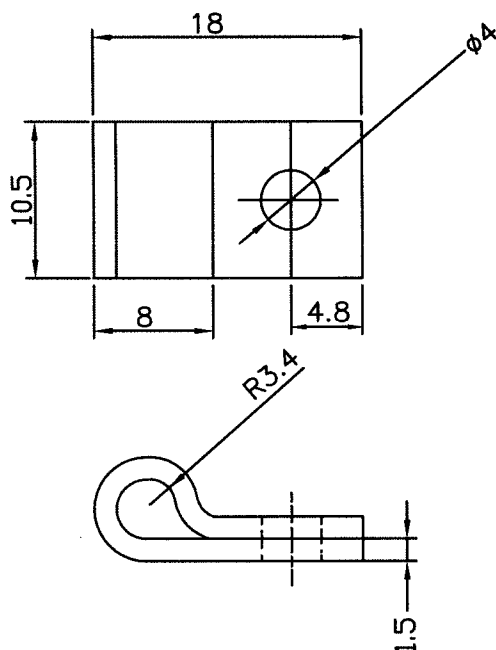
A

B

C

D

E



ARMING WIRE CLIP
1-OFF

NOTE :- LENGTH OF CLIP CAN BE SMOOTHLY TRIMMED TO SUIT THE FITMENT.

TOLERANCE:- IS:2102 (PART-1)-1993 V.COARSE UNLESS OTHERWISE SPECIFIED.

PROCESS:- FABRICATION

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	D I/C D&S	HEAD Q.A.

SCALE:-NTS

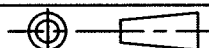
DIMENSIONS IN mm

TOL:- AS ABOVE

MATERIAL:-
M.S.

FINISH:-
AS PER SHEET No. 215

HEAT TREATMENT:-



A D R D E AGRA

DRN.

YOGESH

GROUP:-HDS

CHKD.

JC DUTTA

LOCK PIN SUB ASSY.
BRACKET SUB ASSEMBLY
FRAME SUB ASSY.
TOP FRAME STRUCTURE
SUB ASSY.
TOP FRAME SUB ASSY.
HYDRAULIC TROLLEY
H D SYSTEM
FOR AN-32 AIRCRAFT

Ashish Kumar
PROJ.DFFR./GP.DFFR.

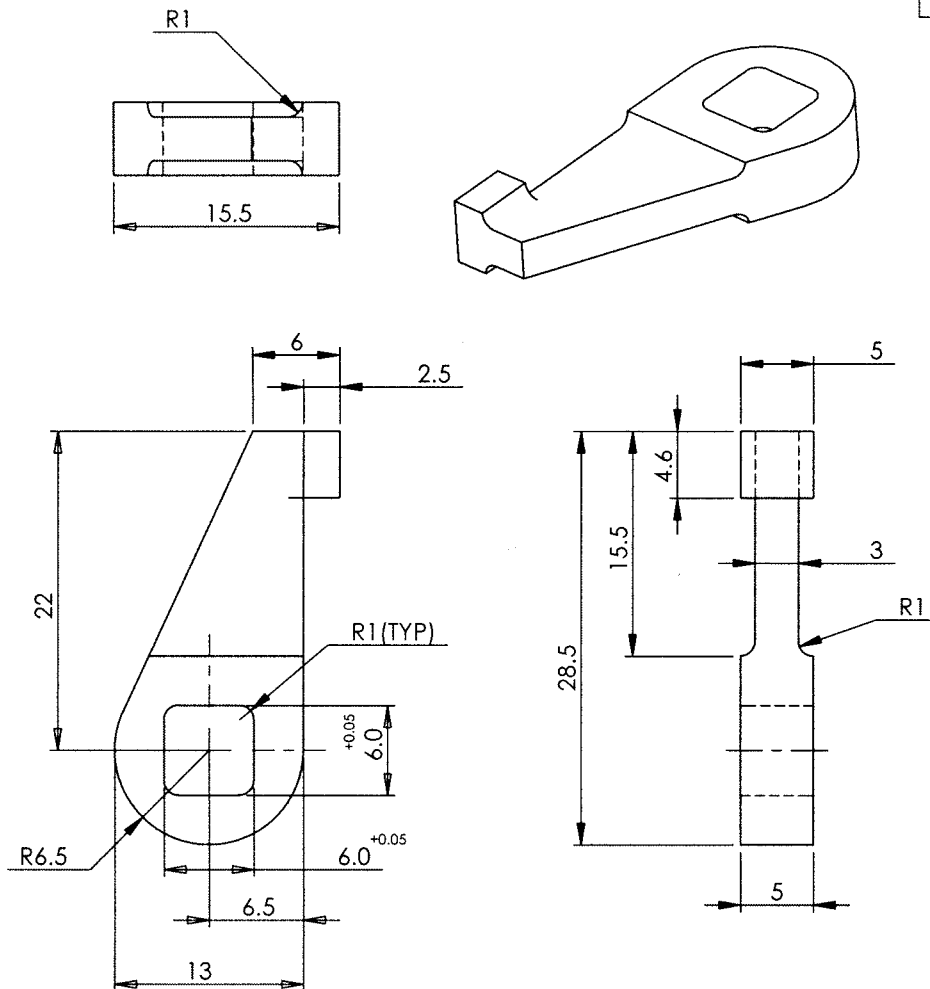
APPROVED

3 Mid
PROJ. DIR./GP.DIR.

DRG. No.

2.6.03-15-01-07-14-03-07

16-B-1-E



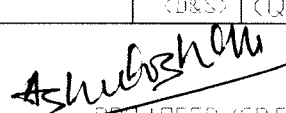
TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED.

PROCESS:- MACHINING

*TO SUIT RELEASE LEVER PIN(DRG.No.2.6.03-15-02-01-06)

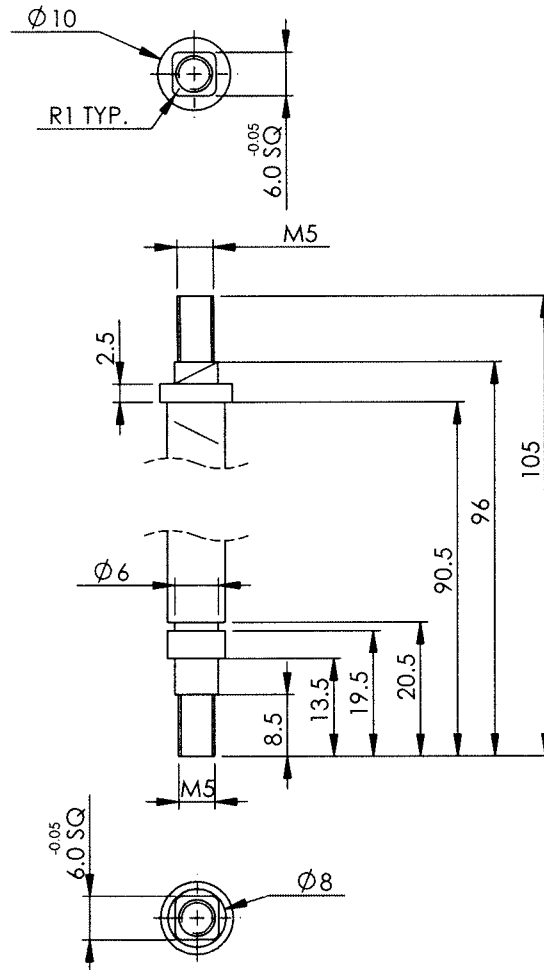
RELEASE LEVER

1 OFF

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			□ I/O GROUP (D&S) (Q.A.)
SCALE:- 2:1			A D R D E AGRA	DRN.	CAD CENTRE	 PROJ.OFFER / GP.OFFER.	
DIMENSIONS IN mm			GROUP:- HDS	CHD.	J. C. DUTTA		
TOL:- AS ABOVE			LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT			APPROVED BY  PROJ.OFFER / GP.OFFER.	
MATERIAL:- ALLOY STEEL 709M40/817M40(EN19/EN24), AS PER BS:970						DRG. NO.	
FINISH:- As per sheet no. 215						26.03-15-02-01-05	
HEAT TREATMENT:- HARDENED & TEMPERED 32±5 HRC							



16-B-1-F



TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED.

PROCESS:- MACHINING

RELEASE LEVER PIN

1 OFF

Ref.No. DATE ZONE AUTHORITY

BRIEF RECORD

D I/O GROUP
(D&S) HEAD

SCALE:- 1:1

A D R D E AGRA DRN. CAD CENTRE

DIMENSIONS IN mm

GROUP:- HDS CHD. J. C. DUTTA

TOL:- AS ABOVE

MATERIAL:- ALLOY STEEL
709M40/817M40(EN19/EN24),
AS PER BS:970

FINISH:- AS PER SHEET No. 215

HEAT TREATMENT:- HARDENED &
TEMPERED
32±5 HRCLOCK SUB ASSY
GUIDE RAIL SUB ASSY
TOP FRAME SUB ASSY
WHEEL TROLLEY

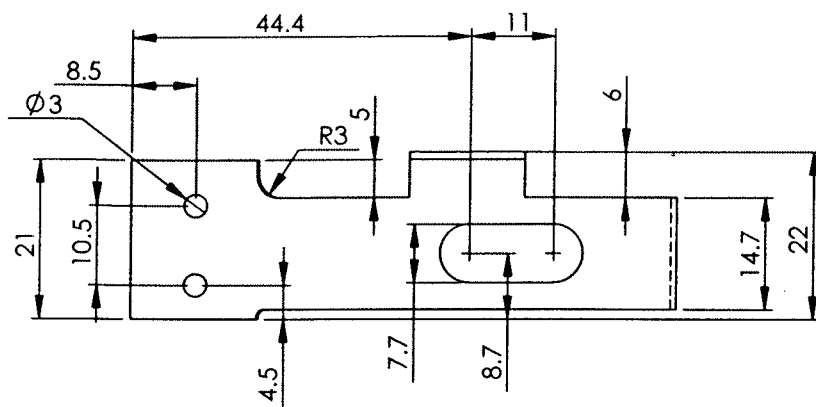
HD SYSTEM FOR AN-32 A/C

PROJECTER / GROUP IN CH.

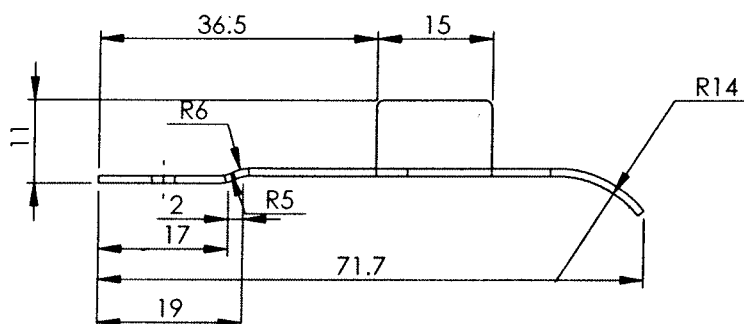
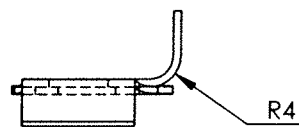
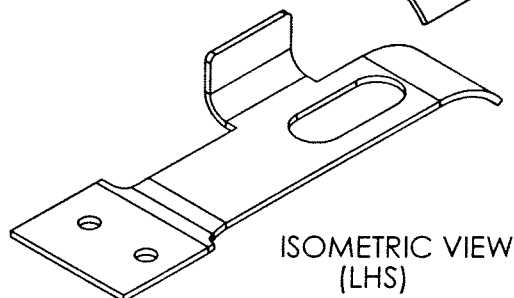
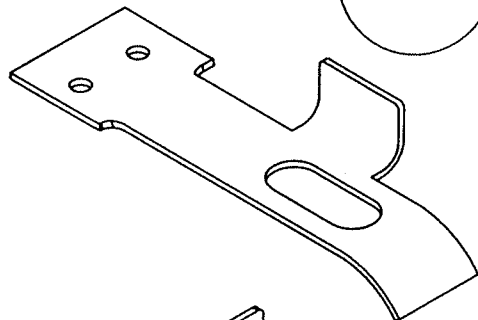
APPROVED BY

PROJ DIR/GR. DIR

DRG. NO.
2.6.03.15-02-01-06



ISOMETRIC VIEW
(RHS)



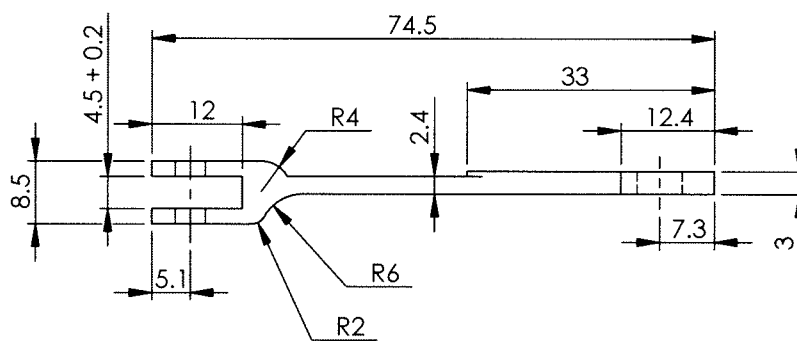
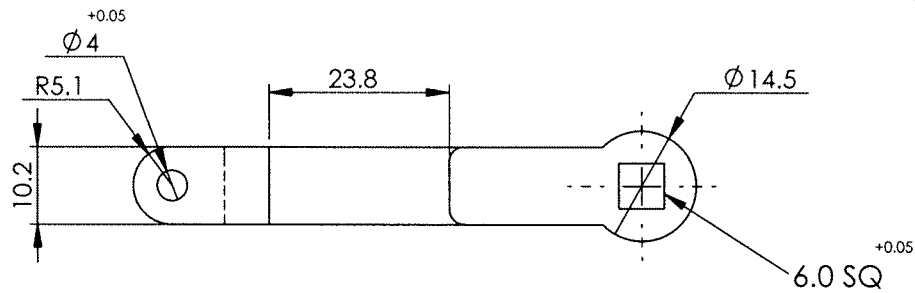
PROCESS:- FABRICATION

NOTE:- RHS IS SHOWN HERE.
LHS IS SYMMETRICALLY OPPOSITE.
(ISOMETRIC VIEW FOR REFERENCE SHOWN ABOVE)

SHEET STOPPER
1 OFF

[illegible]

16-B-1-H



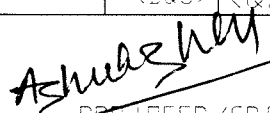
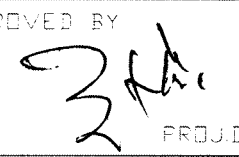
TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED

PROCESS:- MACHINING

TO SUIT RELEASE LEVER PIN(DRG. No.2.6.03-15-0201-06)

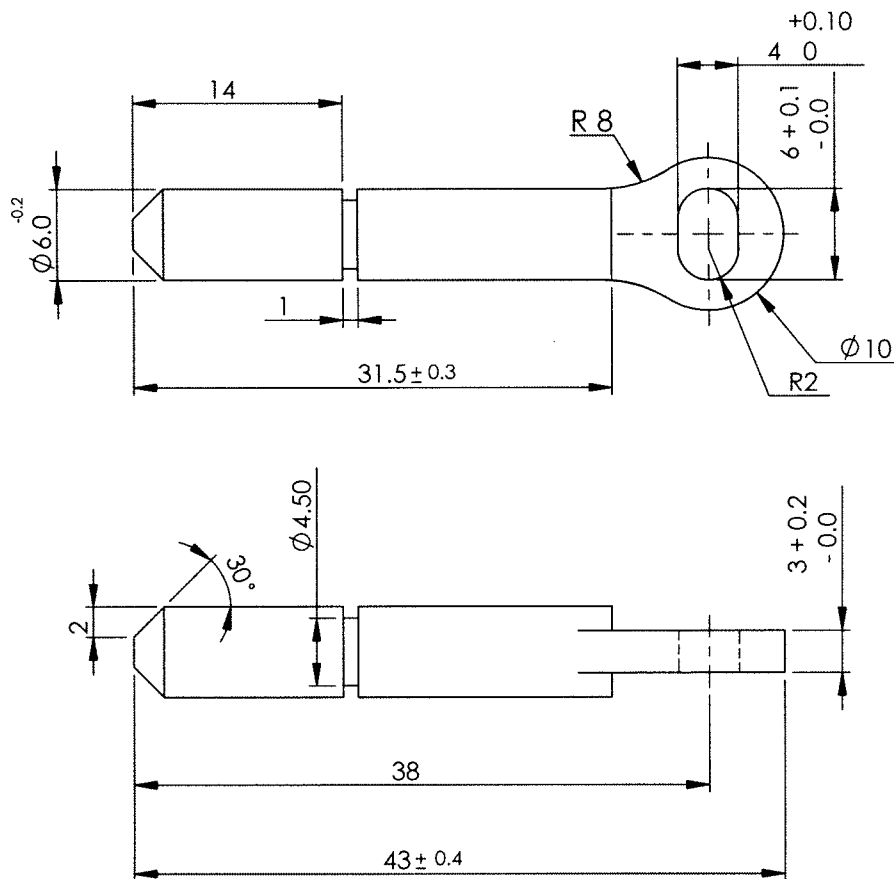
RELEASE LEVER LINK

1 OFF

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		I/O GROUP (D&S) (Q.A.)
SCALE:- 1:1			A D R D E AGRA	DRN.	CAD CENTRE	 PROJ.DIR./GP.DIR.
DIMENSIONS IN mm			GROUP:- HDS	CHD.	J. C. DUTTA	
TOL:- AS ABOVE			LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT			APPROVED BY  PROJ.DIR./GP.DIR.
MATERIAL:- ALLOY STEEL 709M40/817M40(EN19/EN24), AS PER BS:970						DRG. NO.
FINISH:- AS PER SHEET No. 215						
HEAT TREATMENT:- HARDENED & TEMPERED 32 $\pm$ 5 HRC						
 						

2.6.03-15-02-01-08

16-B-1-J

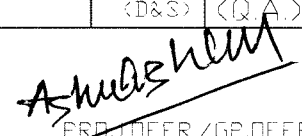


TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED.

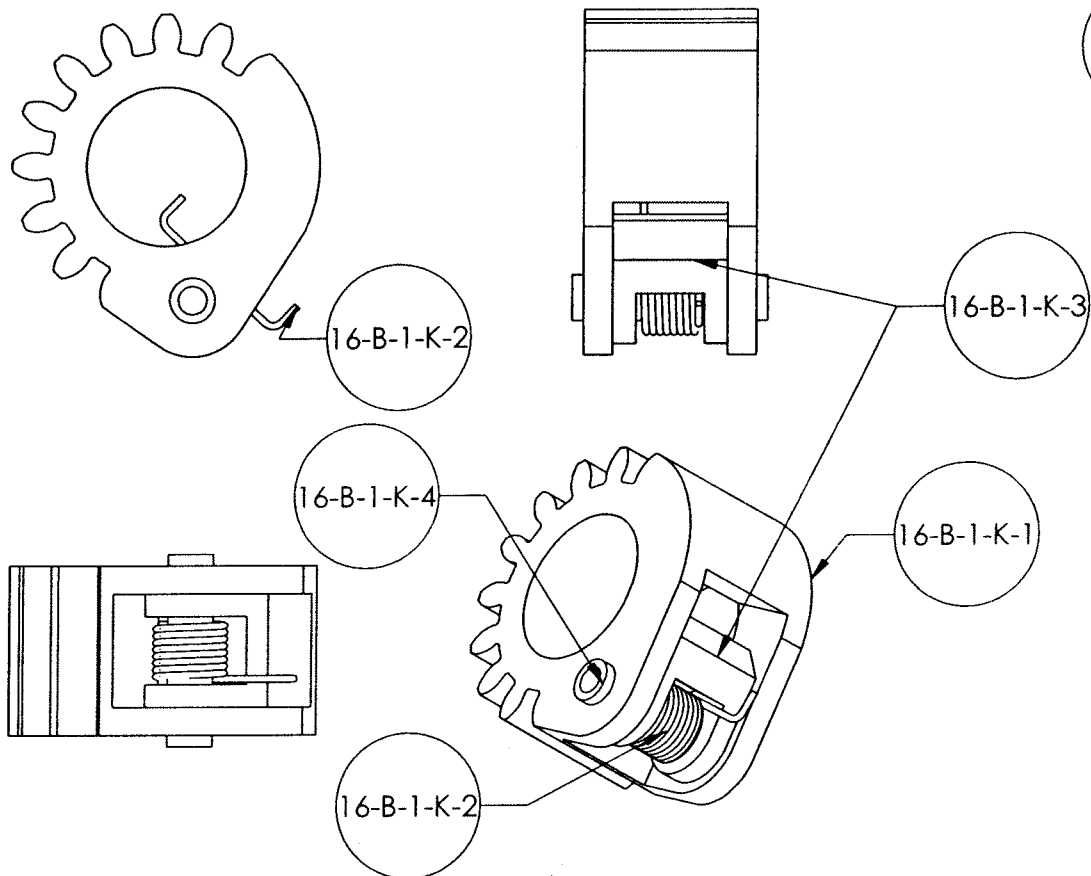
PROCESS:- MACHINING

LOCK PIN

1 OFF

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			I/O GROUP (D&S) (Q.A.)
SCALE:- 2:1			A D R D E AGRA	DRN.	CAD CENTRE	 PROJ.OFFR / GP.OFFR	
DIMENSIONS IN mm			GROUP:- HDS	CHD.	J. C. DUTTA		
TOL:- AS ABOVE			LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT			APPROVED BY  PROJ.DIR / GP.DIR.	
MATERIAL:- ALLOY STEEL 709M40/817M40(EN19/EN24), AS PER BS:970						DRG. NO.	
FINISH:- AS PER SHEET No. 215							
HEAT TREATMENT:- HARDENED & TEMPERED 32 ± 5 HRC							
 			2.6.03-15-02-01-09				

16-B-1-K



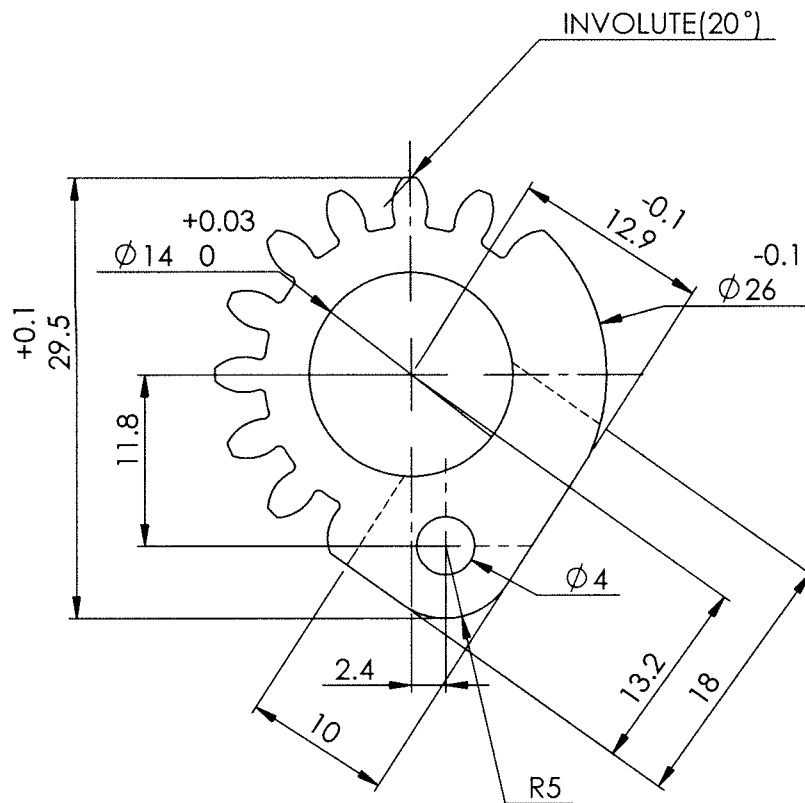
16-B-1-K-4	PIN-PINION LOCK	1	2.6.03-15-02-01-10-04	149
16-B-1-K-3	PINION LOCK	1	2.6.03-15-02-01-10-03	148
16-B-1-K-2	TORSION SPRING	1	2.6.03-15-02-01-10-02	147
16-B-1-K-1	PINION	1	2.6.03-15-02-01-10-01	146
ITEM	DESCRIPTION	QTY.	DRAWING/SPEC. NO.	SHEET NO.

DETAIL INDEX
PINION SUB ASSY
1 OFF

TOLERANCE:-IS:2102(Pt-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED.

REF NO	DATE	ZEN	AL	REVISION	BRIEF RECORD	1/2	3/4
SCALE:- NTS						APPROVED BY	
DESIGNER						for	
CHECKED						2.6.03-15-02-01-10	
LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT							

16-B-1-K-1



TEETH GEOMETRY:

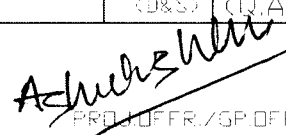
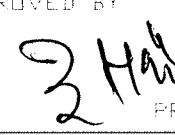
1. MODULE - 1.5mm
2. No. OF TEETH - 8

TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED.

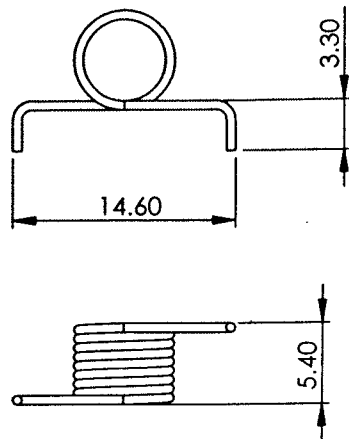
PROCESS:- MACHINING

PINION

1 OFF

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			I/O GROUP (D&S) (Q.A.)
SCALE:- 2:1			A D R D E AGRA	DRN.	CAD CENTRE	 PROD/FR./GRP/DIR	
DIMENSIONS IN mm			GROUP - HDS	CHD.	J. C. DUTTA		
TOL:- AS ABOVE			PINION SUB ASSY LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT			APPROVED BY	
MATERIAL:- ALLOY STEEL 709M40/817M40(EN19/EN24), AS PER BS:970						 PROD/DIR /GRP/DIR.	
FINISH:- AS PER SHEET NO. 215							
HEAT TREATMENT:- HARDENED & TEMPERED 32±5 HRC							
 			DRG. NO.				
				26.03-15-02-01-10-01			

16-B-1-K-2



1. OUTSIDE DIAMETER = 6.6 mm
2. WIRE DIAMETER = 0.6 mm
3. No. OF TURNS = 8

TOLERANCE:- IS:2102(PART-1)-1993 VERY COARSE UNLESS OTHERWISE SPECIFIED.

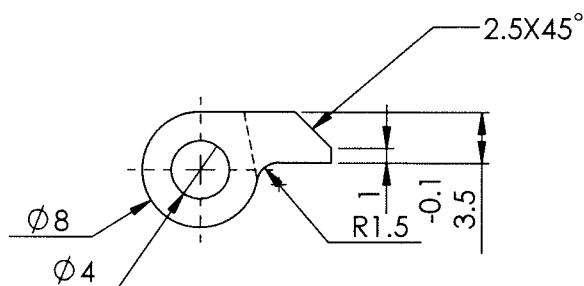
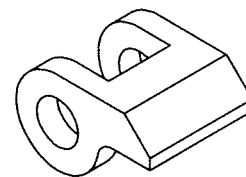
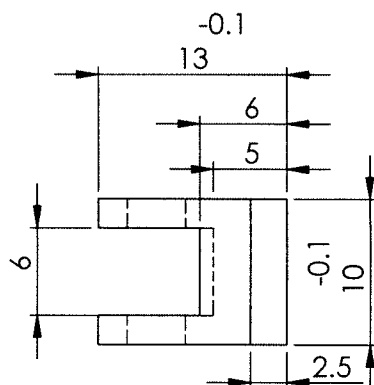
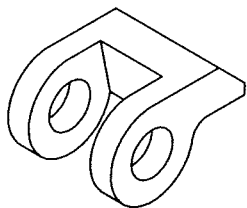
PROCESS:- FABRICATION

TORSION SPRING

1 OFF

Ref No	DATE	ZONE	AUTHORITY	BRIEF RECORD				Q. I/O GROUP (D&S) (Q.A.)			
SCALE:- 2:1				A. D. R. D. E. AGRA	DRN	QAD CENTRE	<i>Aswsh</i> PROJEKTER / GRP DEER				
DIMENSIONS IN mm				GROUP	HDS	CHD			J. C. BUTTA		
MATERIAL - STAINLESS SPRING STEEL WIRE IS:4454:2001 (PART-4) Gr. 1				PINION SUB ASSY LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT				APPROVED BY			
NORMALISED								<i>Aswsh</i> PROJEKTER / GRP DEER			
REVISION								2.6.03-15-02-01-10-02			

16-B-1-K-3

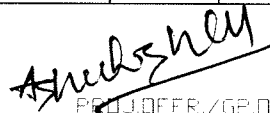


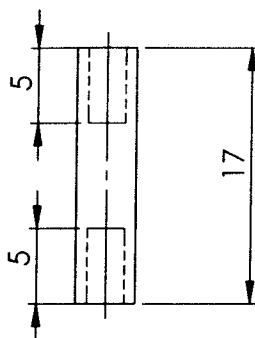
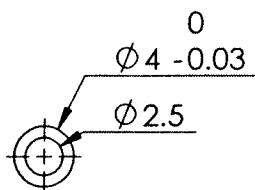
TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED.

PROCESS:- MACHINING

PINION LOCK

1 OFF

Ref.No	DATE	ZONE	AUTHORITY	BRIEF RECORD		I/C GROUP (D&S) (Q.A.)
SCALE:- 2:1			A D R D E AGRA	DRN.	CAD CENTRE	 PROJ.OFFR./GP.OFFR.
DIMENSIONS IN mm			GROUP:- HDS	CHD.	J. C. DUTTA	
TOL:- AS ABOVE			PINION SUB ASSY LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT			APPROVED BY
MATERIAL:- ALLOY STEEL 709M40/817M40(EN19/EN24), AS PER BS:970						 PROJ.DIR./GP.DIR.
FINISH:- AS PER SHEET NO. 215						
HEAT TREATMENT:- HARDENED & TEMPERED 32±5 HRC						
 			DRG. NO.			
			2.6.03-15-02-01-10-03			

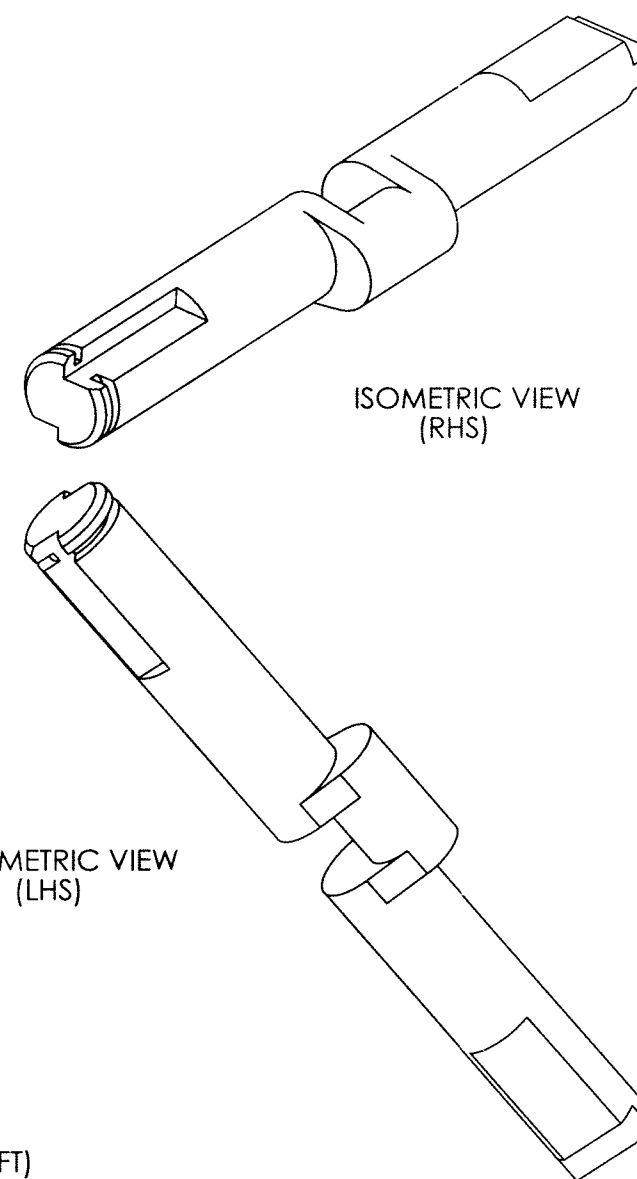
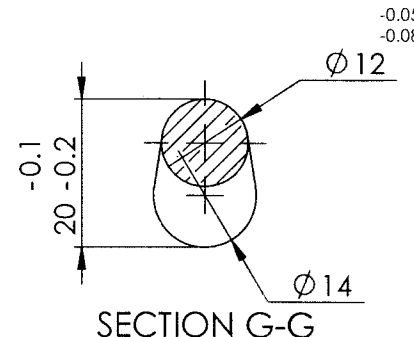
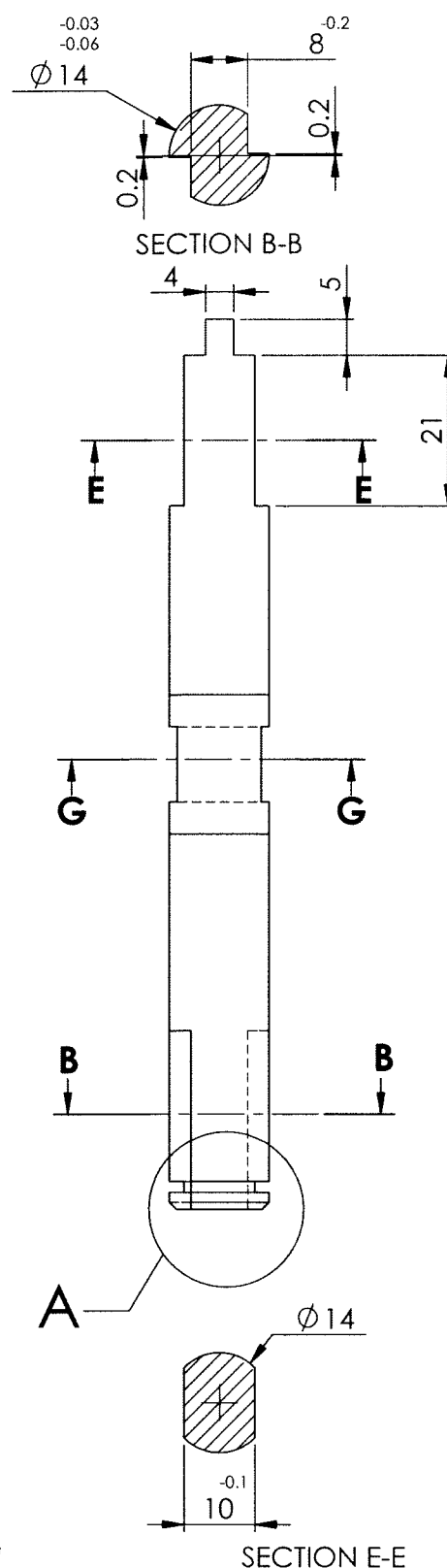
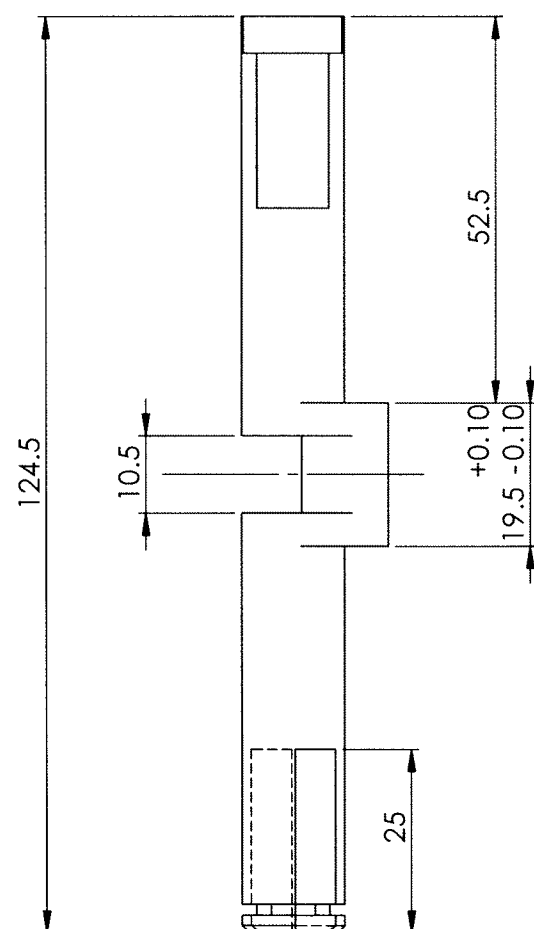


PROCESS:- MACHINING

1 OFF

NO		DATE		Z/A		AUTHORITY		BRIEF RECORD		7.1/0		GRO			
										(K&S)		(Q&A)			
SCALE:- 2:1				A B R D E AGRN		DRN		CAD CENTRE		<i>Ashugh.</i> PROVIDER/USER					
DIMENSIONS IN mm				GROUP		HRS		CND						JUN DUTIA	
MATERIAL															
ALLOY STEEL 709M40/817M40(EN19/EN24). AS PER BS:970				PINION SUB ASSY LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT								APPROVED BY <i>Ashugh.</i> for			
AS PER SHEET NO. 215															
HARDENED & TEMPERED 32±5 HRC															
 															
2.6.03-15-62-01-10-04															

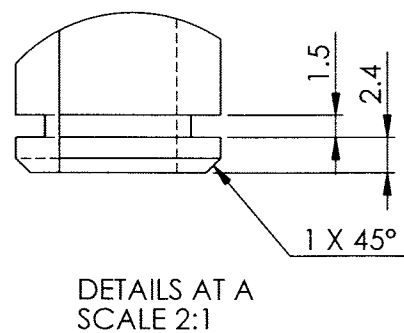
16-B-1-L



CAM (PINION SHAFT)
1 OFF

TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED
PROCESS:- MACHINING

NOTE:- RHS IS SHOWN HERE
LHS IS SYMMETRICALLY OPPOSITE (ISOMETRIC VIEW FOR REFERENCE SHOWN ABOVE)

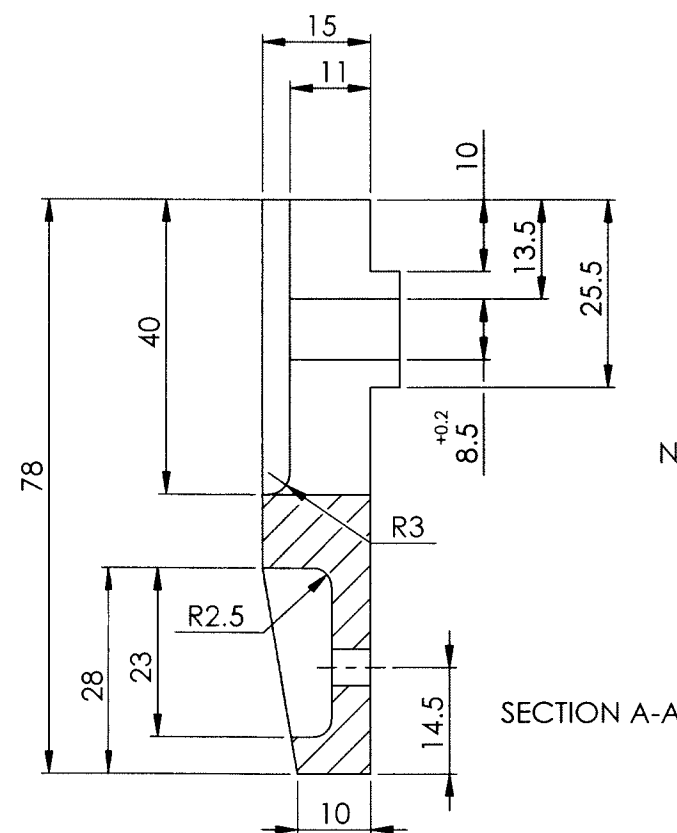
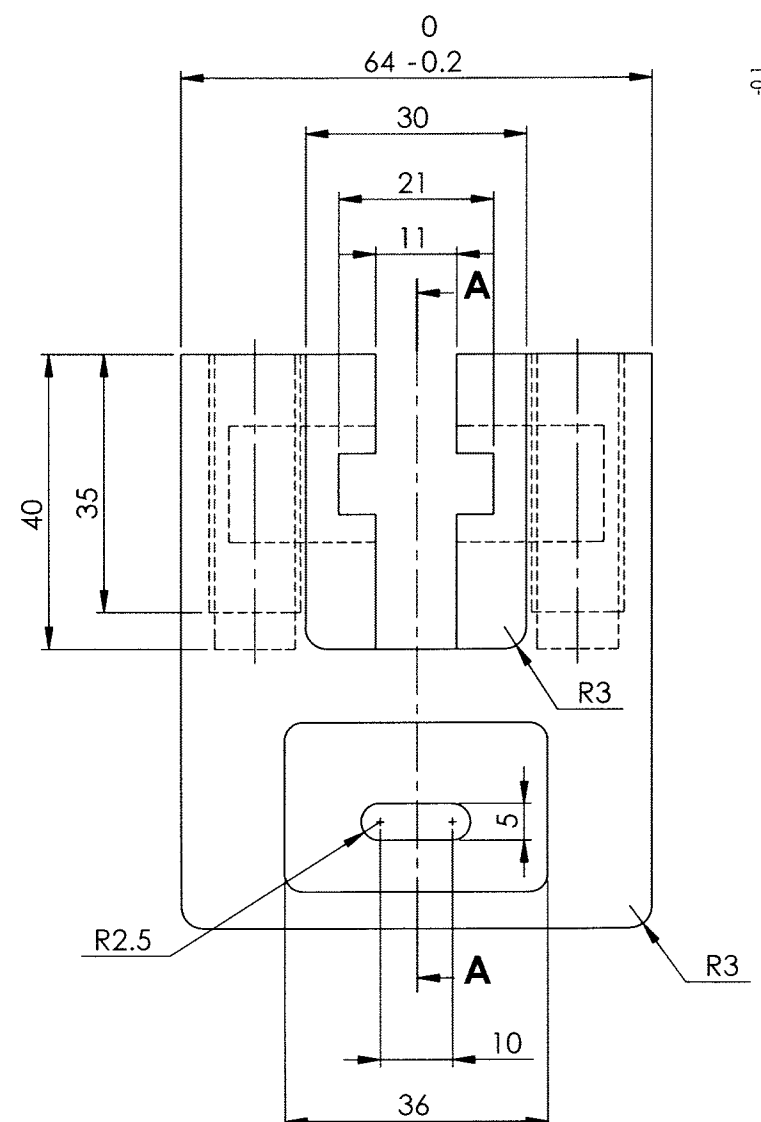
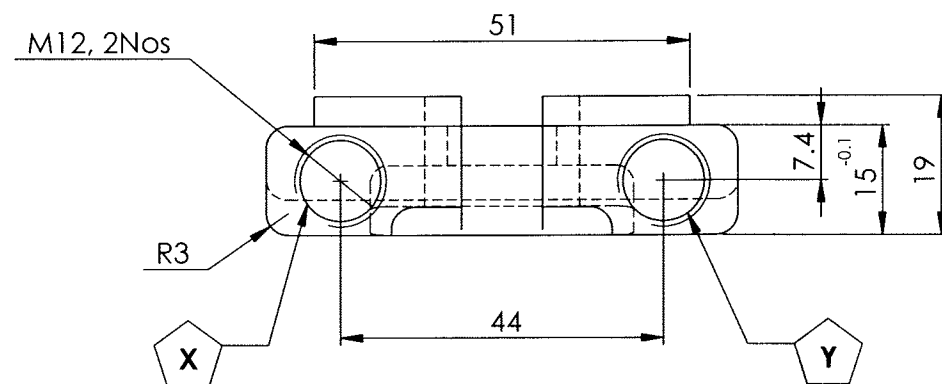


SCALE:- 1:1	A D R D E AGRA	DRN.	CAD CENTRE	APPROVED <i>Ashish Kumar</i> PROJ. DIR. / GP. OFFR.
DIMENSIONS IN mm	GROUP:- HDS	CHD.	J.C. DUTTA	
TOL:- AS ABOVE	LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT			APPROVED <i>3 Haw</i> PROJ. DIR. / GP. DIR.
MATERIAL:- ALLOY STEEL 709M40/817M40(EN19/EN24), AS PER BS:970				
FINISH:- AS PER SHEET NO. 215				DRG. NO. 26.03-15-02-01-11
HEAT TREATMENT:- HARDENED & TEMPERED 32±5 HRC				

REF.NO. DATE ZONE AUTHORITY BRIEF RECORD

I/C GROUP
D&S (Q.A.)

16-B-1-M

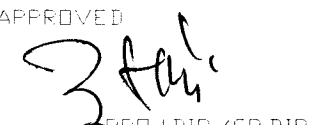


- NOTE:-
1. HOLE X IS USED FOR FITMENT OF ITEM NO. 28 IN LOCK SUB ASSEMBLY(RHS)
 2. HOLE Y IS USED FOR FITMENT OF ITEM NO. 28 IN LOCK SUB ASSEMBLY(LHS)

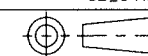
SECTION A-A

LOCK
1 OFF

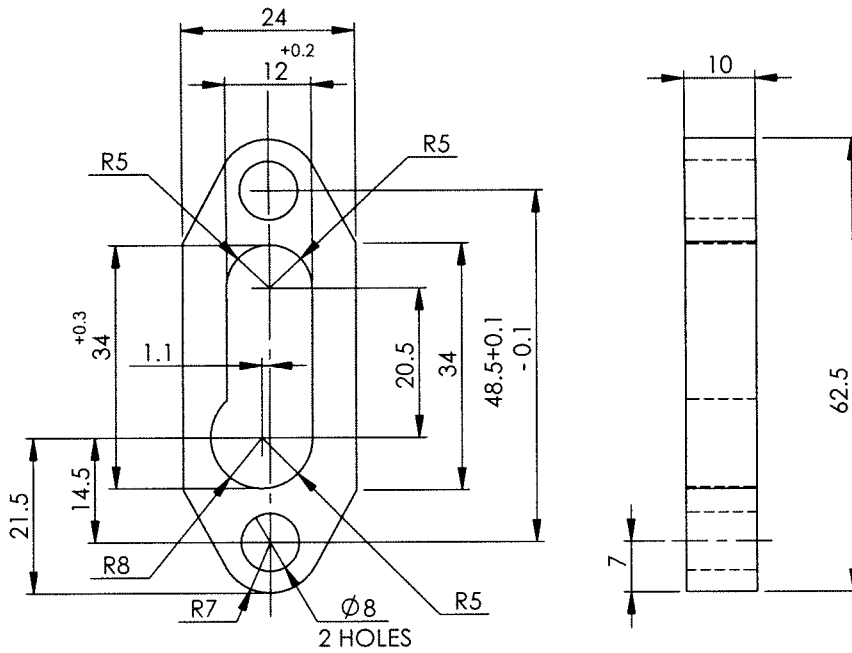
TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED.
PROCESS:- MACHINING

SCALE:- 1:1	A D R D E AGRA	DRN.	CAD CENTRE	
DIMENSIONS IN mm	GROUP- HDS	CHD.	J.C. DUTTA	
TOL:- AS ABOVE	LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT			APPROVED
MATERIAL - ALLOY STEEL 709M40/817M40(EN19/EN24), AS PER BS:970				
FINISH:- CHROME PLATING				
HEAT TREATMENT:- HARDENED & TEMPERED 32±5 HRC				DRG. NO.
				2.6.03-15-02-01-12

REF.NO. DATE ZONE AUTHORITY BRIEF RECORD

I/C GROUP
D&S (Q.A.)

16-B-1-N



TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED.

PROCESS:- MACHINING

CAM OPERATOR

1 OFF

Ref.No. DATE ZONE AUTHORITY

BRIEF RECORD

D I/O GROUP
(D&S) (Q.A.)

SCALE:- 1:1

A D R D E AGRA

DRN.

CAD CENTRE

DIMENSIONS IN mm

GROUP:- HDS

CHD.

J. C. DUTTA

TOL:- AS ABOVE

PROJ.OFFR./GP.OFFR.

MATERIAL:- ALLOY STEEL
709M40/817M40(EN19/EN24),
AS PER BS:970

FINISH:- AS PER SHEET NO. 215

APPROVED BY

PRO DIR / GP DIR.

HEAT TREATMENT:- HARDENED &
TEMPERED
32±5 HRC

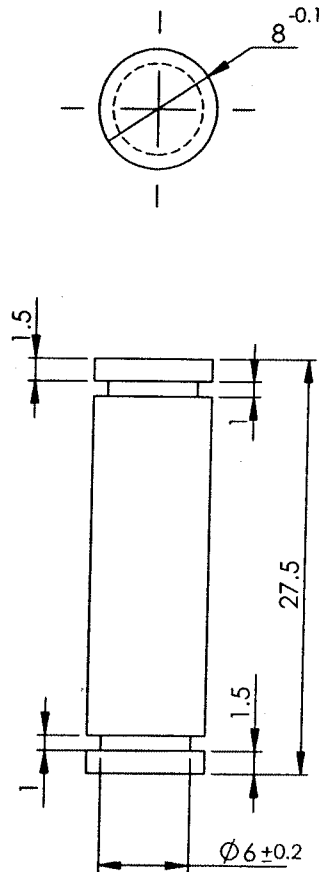
LOCK SUB ASSY
GUIDE RAIL SUB ASSY
TOP FRAME SUB ASSY
HYDRAULIC TROLLEY
HD SYSTEM FOR
AN-32 AIRCRAFT

DRG. NO.

26.03-15-02-01-13



16-B-1-P



TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED.

PROCESS:- MACHINING

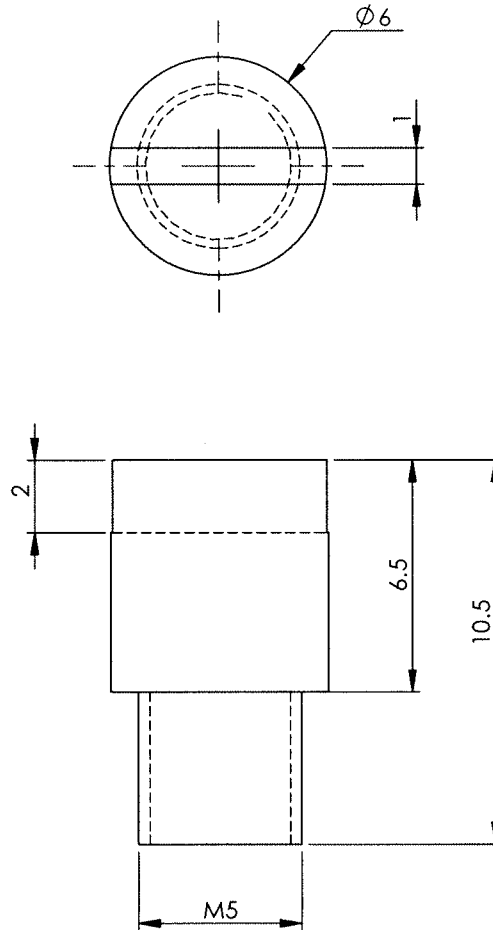
PIN-CAM OPERATOR

1 OFF



Ref No	DATE	ZONE	AUTHORITY	BRIEF RECORD		GROUP (Q.A.)
SCALE:- 2:1			A D R D E AGRA	DRN	HEAD CENTRE	<i>Amish</i> PROVIDER / OFFER
DIMENSIONS IN mm			ASTUP	HDS	CHD	
AS ABOVE			LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT			APPROVED BY <i>Amish</i> for
MATERIAL: ALLOY STEEL 709M40/817M40(EN19/EN24), AS PER BS:970						
AS PER SHEET NO. 215						
HARDENED & TEMPERED 32 ± 5 HRC						
 			2.6.03-15-02-01-14			

16-B-1-Q



TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED.

PROCESS:- MACHINING

STOPPER PIN

3 OFF

Ref.No. DATE ZONE AUTHORITY

BRIEF RECORD

I/C GROUP
(D&S) (Q.A.)

SCALE:- 5:1

A D R D E AGRA DRN. CAD CENTRE

DIMENSIONS IN mm

GROUP:- HDS CHD. J. C. DUTTA

TOL:- AS ABOVE

MATERIAL:- ALLOY STEEL
709M40/817M40(EN19/EN24),
AS PER BS:970

FINISH:- AS PER SHEET NO. 215

HEAT TREATMENT:- HARDENED &
TEMPERED
32±5 HRCLOCK SUB ASSY
GUIDE RAIL SUB ASSY
TOP FRAME SUB ASSY
HYDRAULIC TROLLEY
HD SYSTEM FOR
AN-32 AIRCRAFT

APPROVED BY

PROJ.DIR./GP.DIR.

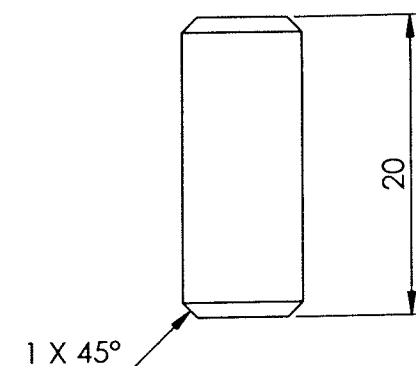
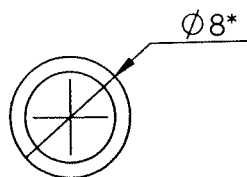
DRG. NO.

26.03-15-02-01-15



155 OF 215

16-B-1-R



* PRESS FIT WITH CAM OPERATOR (ITEM NO.13)

TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED.

PROCESS:- MACHINING

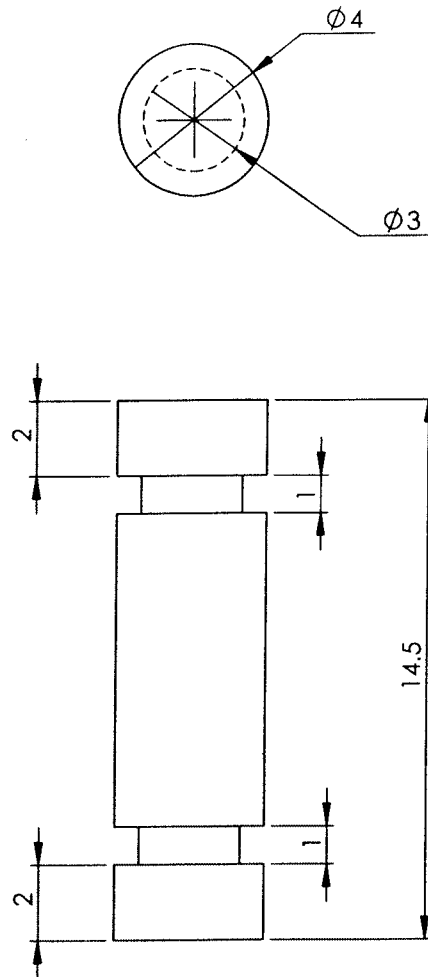
CONNECTING PIN

1 OFF



ROLL NO	DATE	ZONE	AUTHORITY	BRIEF RECORD		1/3 CRIBL (PASS) (Q.A.)
SCALE:- 2:1			DESIGNER	DRN	QA ENGINEER	<i>Ashish</i> QA ENGINEER
DIMENSIONS IN mm			CHECKED	DATE	BY	
MATERIAL			APPROVED BY			
ALLOY STEEL 709M40/817M40(EN19/EN24). AS PER BS:970			LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT			<i>Ashish</i> 2.6.03-15-02-01-16
AS PER SHEET NO. 215						
HARDENED & TEMPERED 32±5 HRC						

16-B-1-ZA



TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED.

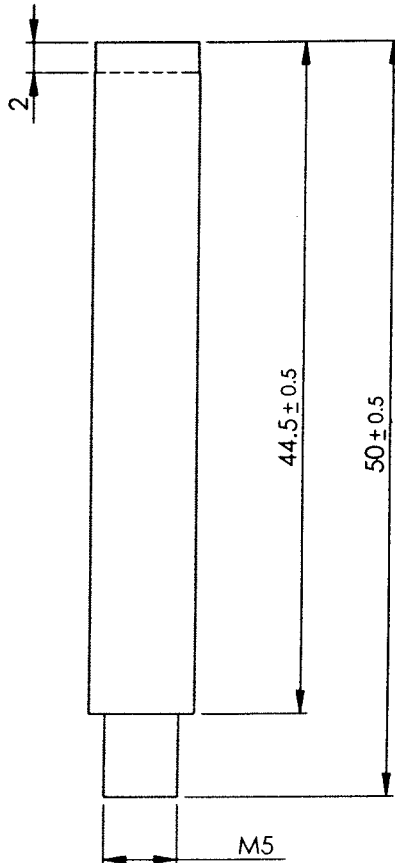
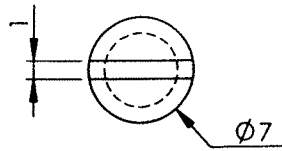
PROCESS:- MACHINING

PIN-LINK

1 OFF

ROLL NO	DATE	ZONE	AUTHORITY	BRIEF RECORD			PLT/0 GROUP (PASS) (Q.A.)
SCALE:- 5:1			WATER PUMP	DRN	WATER PUMP	Aswagh. PROJECTS AND DESIGNS	
DIMENSIONS IN mm			WATER PUMP	DRN	WATER PUMP		
MATERIAL			LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT			APPROVED BY	
ALLOY STEEL 709M40/817M40(EN19/EN24). AS PER BS:970						Aswagh. PROJECTS AND DESIGNS	
AS PER SHEET NO. 215						per Aswagh. PROJECTS AND DESIGNS	
HARDENED & TEMPERED 32±5 HRC						2.6.03-15-62-01-17	

16-B-1-ZB



TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM
UNLESS OTHERWISE SPECIFIED.

PROCESS:- MACHINING

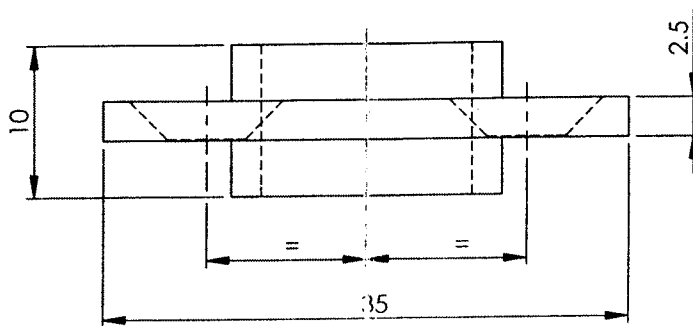
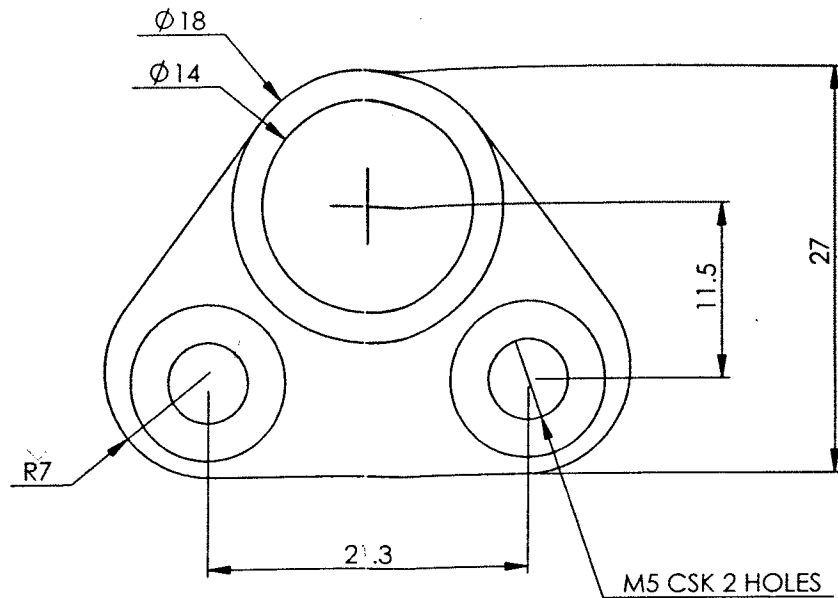
GUIDE PIN-SPRING

1 OFF

19

Ref No	DATE	ZONE	AUTHORITY	BRIEF RECORD		GROUP HEAD
SCALE:- 2:1		A D R D E AGRA		DRN	OAD CENTRE	
DIMENSIONS IN mm		GROUP HDS		ONE	J. L. DUTTA	
TOLERANCE AS ABOVE						
MATERIAL ALLOY STEEL 709M40/817M40(EN19/EN24). AS PER BS:970		LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT		APPROVED BY		
AS PER SHEET NO. 215				 PROD OFFER / GR OFFER		
HARDENED & TEMPERED 32 ± 5 HRC				 PROD OFFER / GR OFFER		
 				2.6.03-15-02-01-18		

16-B-1-ZC



TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED.

PROCESS:- MACHINING

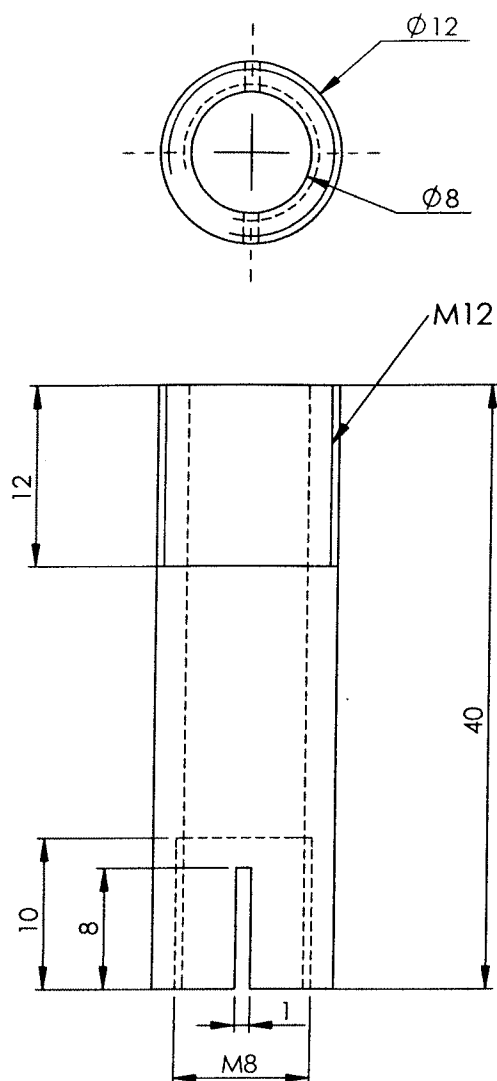
GUIDE BRACKET

1 OFF

20

Ref No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		I/O GROUP (D&S) (Q.A.)
SCALE:- 2:1			APPROVED BY	DATE	APPROVED BY	
DIMENSIONS IN mm			APPROVED BY	DATE	APPROVED BY	
MATERIAL			APPROVED BY		APPROVED BY	
ALLOY STEEL 709M40/817M40(EN19/EN24). AS PER BS:970			APPROVED BY		APPROVED BY	
AS PER SHEET NO. 215			APPROVED BY		APPROVED BY	
HARDENED & TEMPERED 32±5 HRC			APPROVED BY		APPROVED BY	
			LOCK SUB ASSY - GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT		206103-15-02-01-19	

16-B-1-ZD

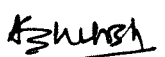
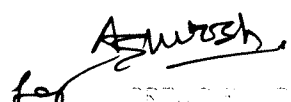
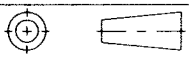


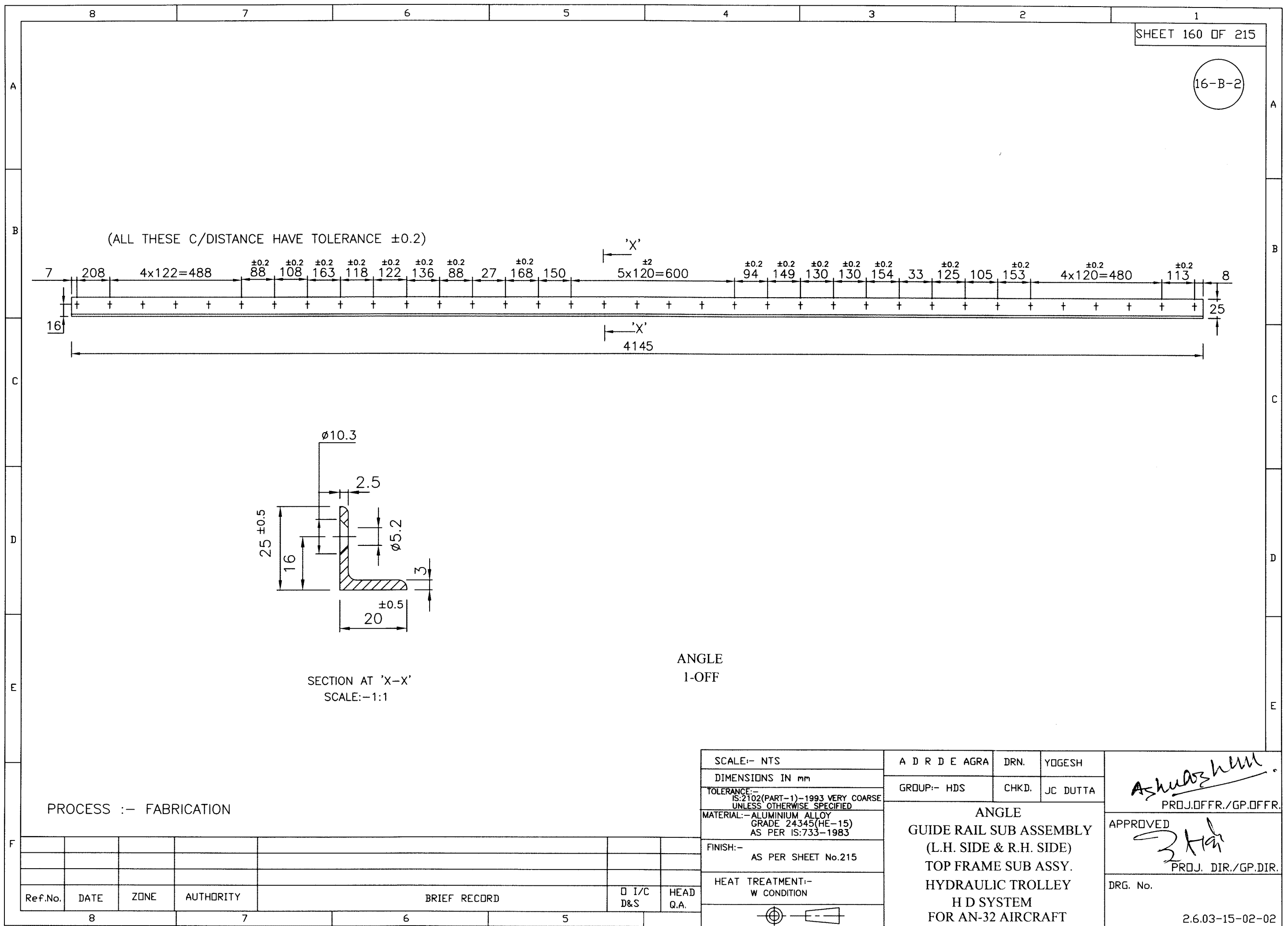
TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED.

PROCESS:- MACHINING

SCREW LOCK

1 OFF

Ref No	DATE	ZLINE	AUTHORITY	BRIEF RECORD		1/0 GROUP (R&S) HEAD
SCALE:- 2:1			APPROVED BY	DRN	LOAD CENTER	 PRODUCED BY
DIMENSIONS IN mm			GROUP	DRN	LOAD CENTER	
AS ABOVE						APPROVED BY  for
MATERIAL: ALLOY STEEL 709M40/817M40(EN19/EN24), AS PER BS:970			LOCK SUB ASSY GUIDE RAIL SUB ASSY TOP FRAME SUB ASSY HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT			
AS PER SHEET NO. 215						
HARDENED & TEMPERED 32±5 HRC						
						
						2.6.03-15-02-01-20

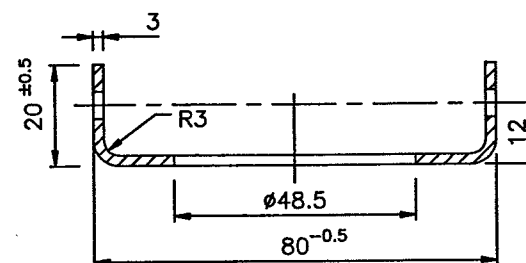
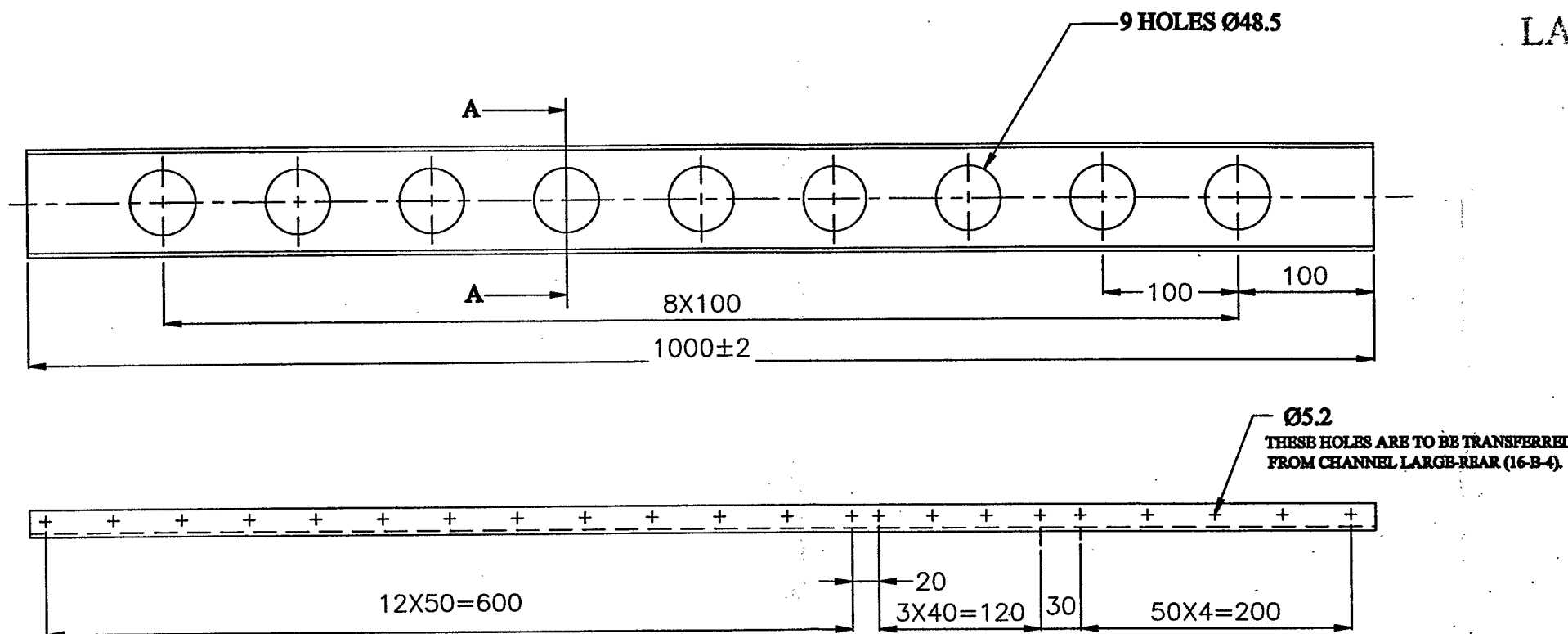


LATEST COPY

SHEET 161 OF 215

16-B-3

LATEST COPY



CHANNEL SMALL-REAR
1-OFF

NOTE:- R.H.S. IS SHOWN HERE.
PROCESS :- FABRICATION

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	D I/C D&S	HEAD Q.A.
8						
7						
6						
5						

SCALE:- NTS	A D R D E AGRA	DRN.	YOGESH
DIMENSIONS IN mm	GROUP:- HDS	CHKD.	JC DUTTA
TOLERANCE:- IS:2102(PART-1)-1993 VERY COARSE UNLESS OTHERWISE SPECIFIED	GUIDE RAIL SUB ASSEMBLY (L.H. SIDE & R.H. SIDE) TOP FRAME SUB ASSY. HYDRAULIC TROLLEY H D SYSTEM FOR AN-32 AIRCRAFT		
MATERIAL:- ALUMINIUM ALLOY GRADE 24345(HE-15) AS PER IS:733-1983			
FINISH:- AS PER SHEET No.215			
HEAT TREATMENT:- W CONDITION			

APPROVED

PROJ.DFFR./GP.DFFR.

APPROVED

PROJ.DIR./GP.DIR.

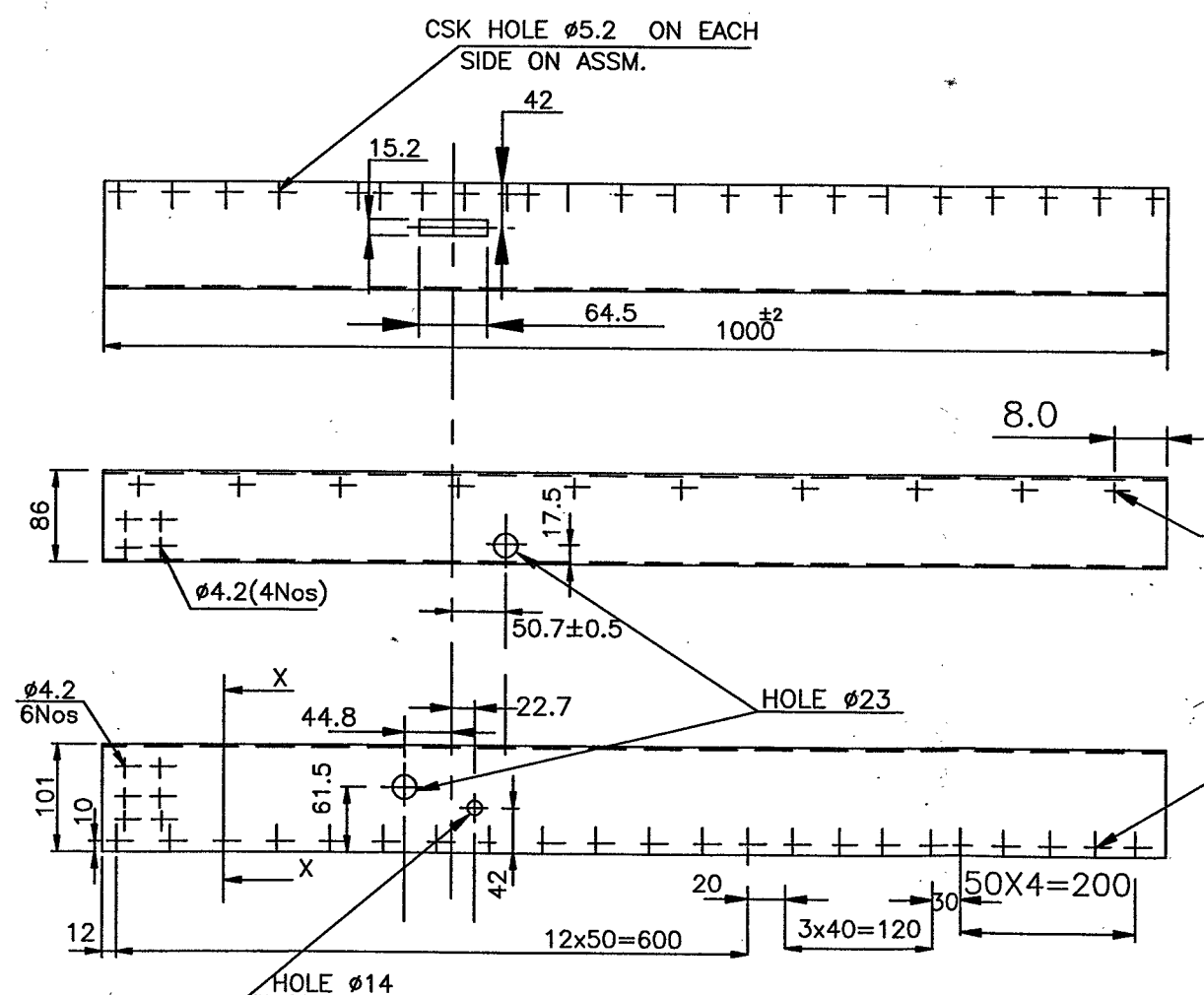
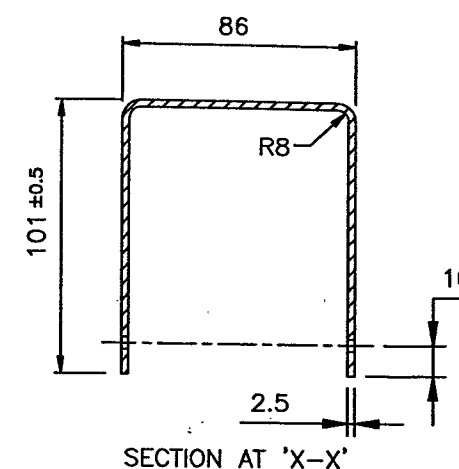
DRG. No.

2.6.03-15-02-03

16-B-4

LATEST COPY

LATEST COPY



THESE HOLES ARE TO BE TRANSFERRED FROM ANGLE (DRG. NO. 2.6.03-15-02-02)

CHANNEL LARGE-REAR
1-OFF

NOTE:- R.H.S. IS SHOWN HERE.

PROCESS :- FABRICATION

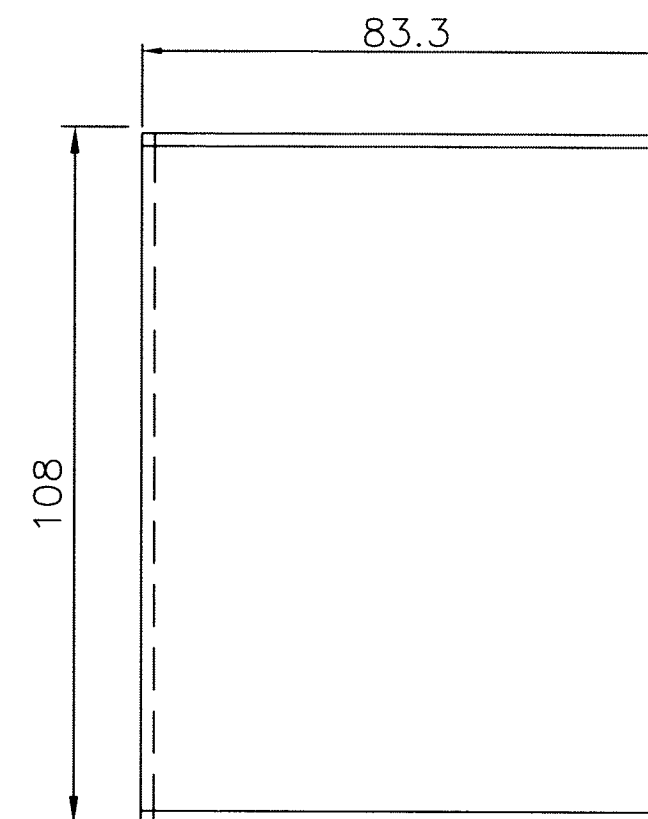
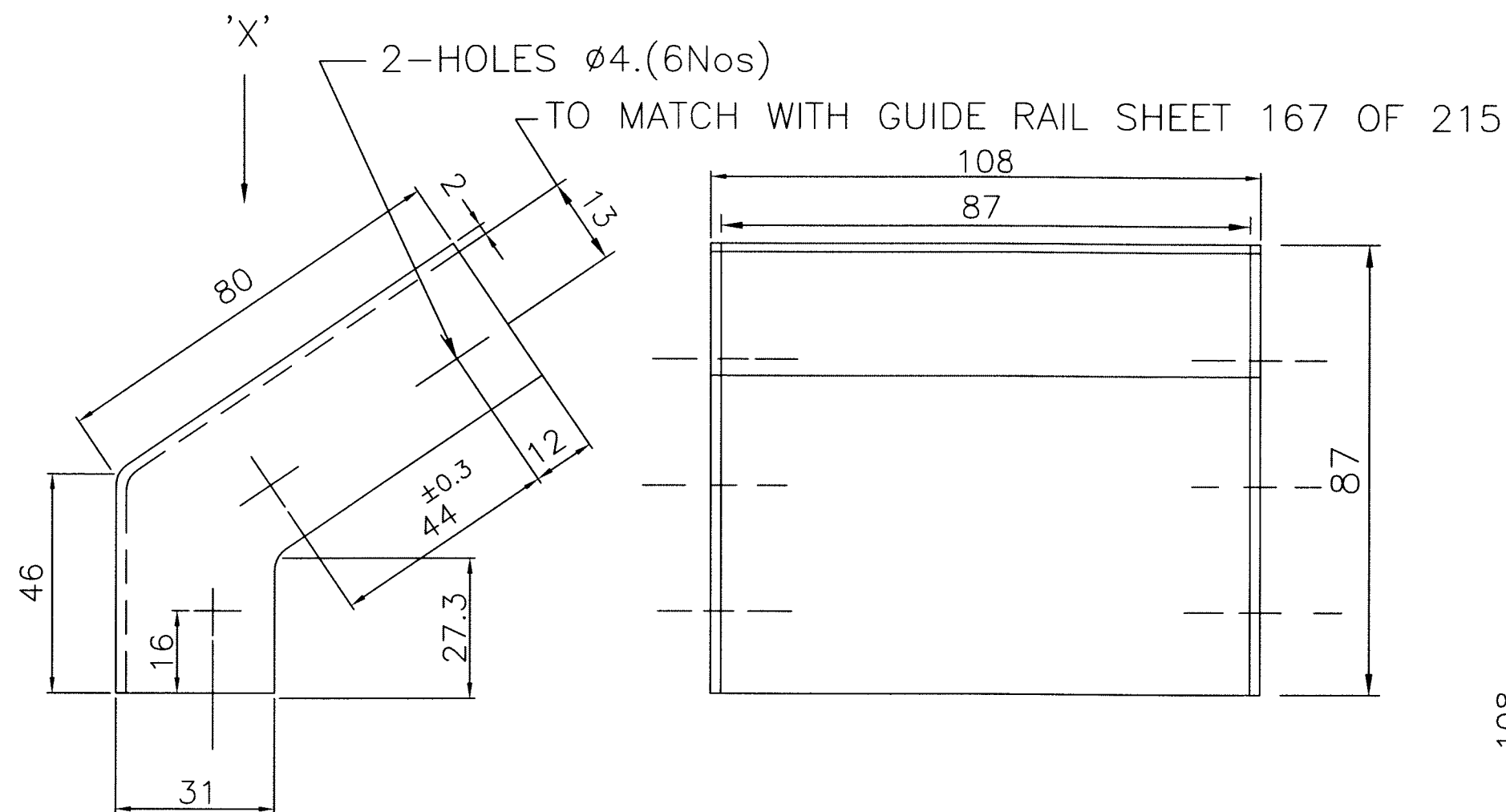
Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	I/C D&S	HEAD Q.A.
1						
2						
3						
4						

SCALE:- NTS	QTY:- 1 No.
DIMENSIONS IN mm	
TOLERANCE:- IS:2102(PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED	
MATERIAL:- ALUMINIUM ALLOY GRADE 24345(HE-15) AS PER IS:733-1983	
FINISH:- AS PER SHEET No.215	
HEAT TREATMENT:-	

A D R D E AGRA	DRN	YOGESH
GROUP:- HDS	CHKD.	JC DUTTA
GUIDE RAIL SUB ASSEMBLY (L.H. SIDE & R.H. SIDE) TOP FRAME SUB ASSY. HYDRAULIC TROLLEY H D SYSTEM FOR AN-32 AIRCRAFT		

APPROVED	PROJ.OFFR./GP.OFFR
APPROVED	PROJ.DIR./GP.DIR.
DRG. No.	2.6.03-15-02-04

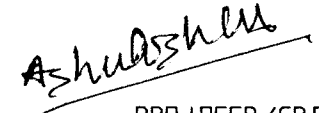
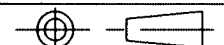
16-B-5



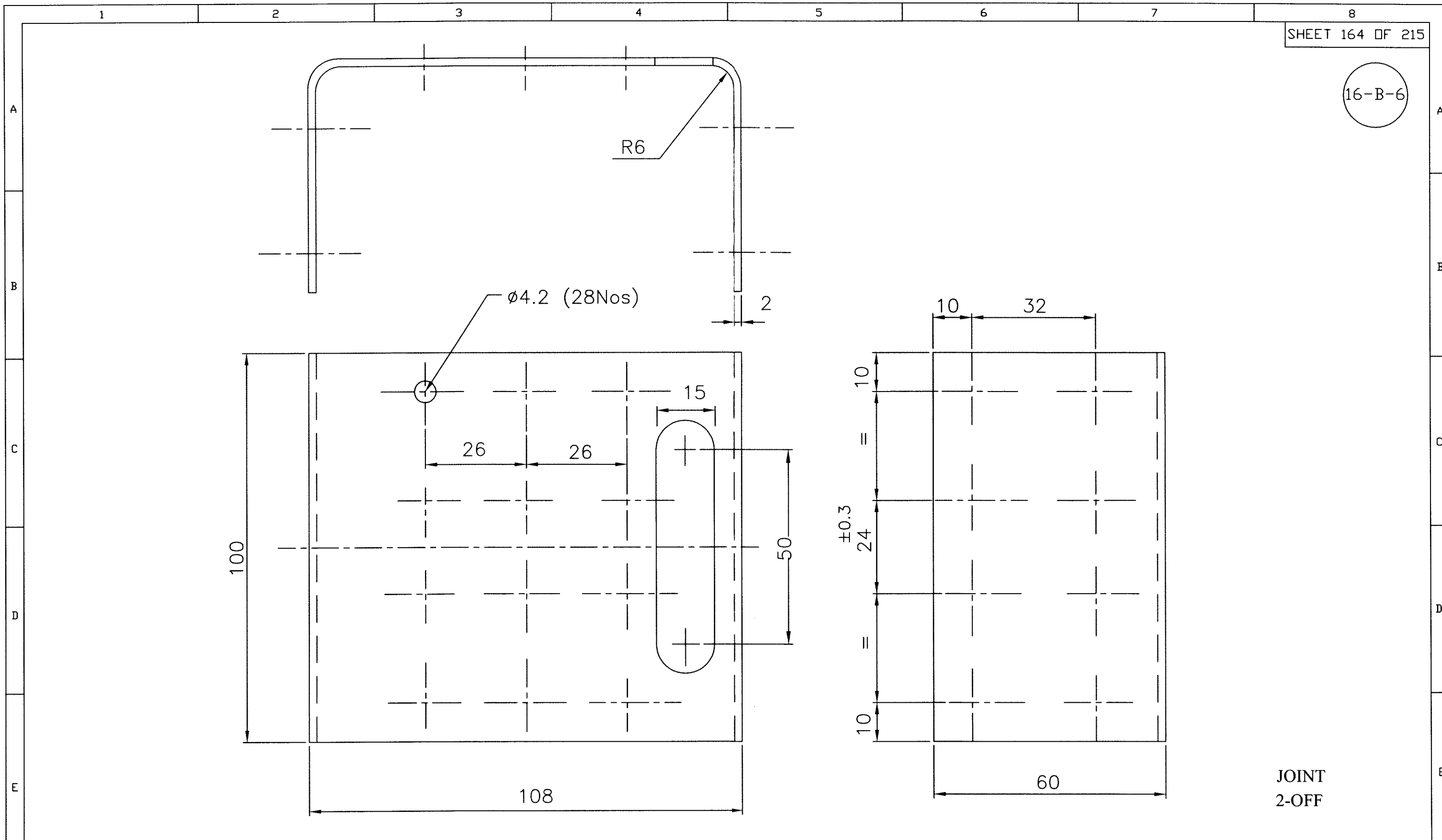
END COVER
1-OFF

VIEW AT 'X'

PROCESS :- FABRICATION

SCALE:- NTS	QTY:- 1 NO.	A D R D E AGRA	DRN.	YOGESH	 PROJ.DFFR./GP.DFFR.
DIMENSIONS IN mm		GROUP:- HDS	CHKD.	JC DUTTA	
TOLERANCE:- IS:2102 (PART-1)-1993 VERY COARSE UNLESS OTHERWISE SPECIFIED		GUIDE RAIL SUB ASSY. (L. H. SIDE & R. H. SIDE) TOP FRAME SUB ASSY. HYDRAULIC TROLLEY H D SYSTEM FOR AN-32 AIRCRAFT			APPROVED  PROJ. DIR./GP.DIR.
MATERIAL:- STEEL AS PER IS:2062-1999(Gr.C)					DRG. No. 2.6.03-15-02-05
FINISH:- AS PER SHEET No.215					
HEAT TREATMENT:-					
					

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	I/C D&S	HEAD Q.A.
1						
2						
3						
4						

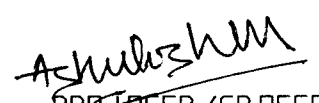
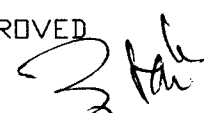
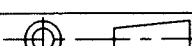


SHEET 164 OF 215

16-B-6

JOINT
2-OFF

PROCESS :- FABRICATION

SCALE:- NTS	A D R D E AGRA	DRN.	YOGESH	 PROJ. DIR./GP.DIR.
DIMENSIONS IN mm	GROUP:- HDS	CHKD.	JC DUTTA	
TOLERANCE:- IS:2102 (PART-1)-1993 VERY COARSE UNLESS OTHERWISE SPECIFIED	GUIDE RAIL SUB ASSEMBLY (L.H. SIDE & R.H. SIDE) TOP FRAME SUB ASSY HYDRAULIC TROLLEY H D SYSTEM FOR AN-32 AIRCRAFT			APPROVED  PROJ. DIR./GP.DIR.
MATERIAL:- STEEL AS PER IS:2062-1999 (Gr.C)				DRG. No. 2.6.03-15-02-06
FINISH:- AS PER SHEET No.215				
HEAT TREATMENT:- —				
				

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	I/C D&S	HEAD Q.A.
1						
2						
3						
4						

1

2

3

4

SHEET 165 OF 215

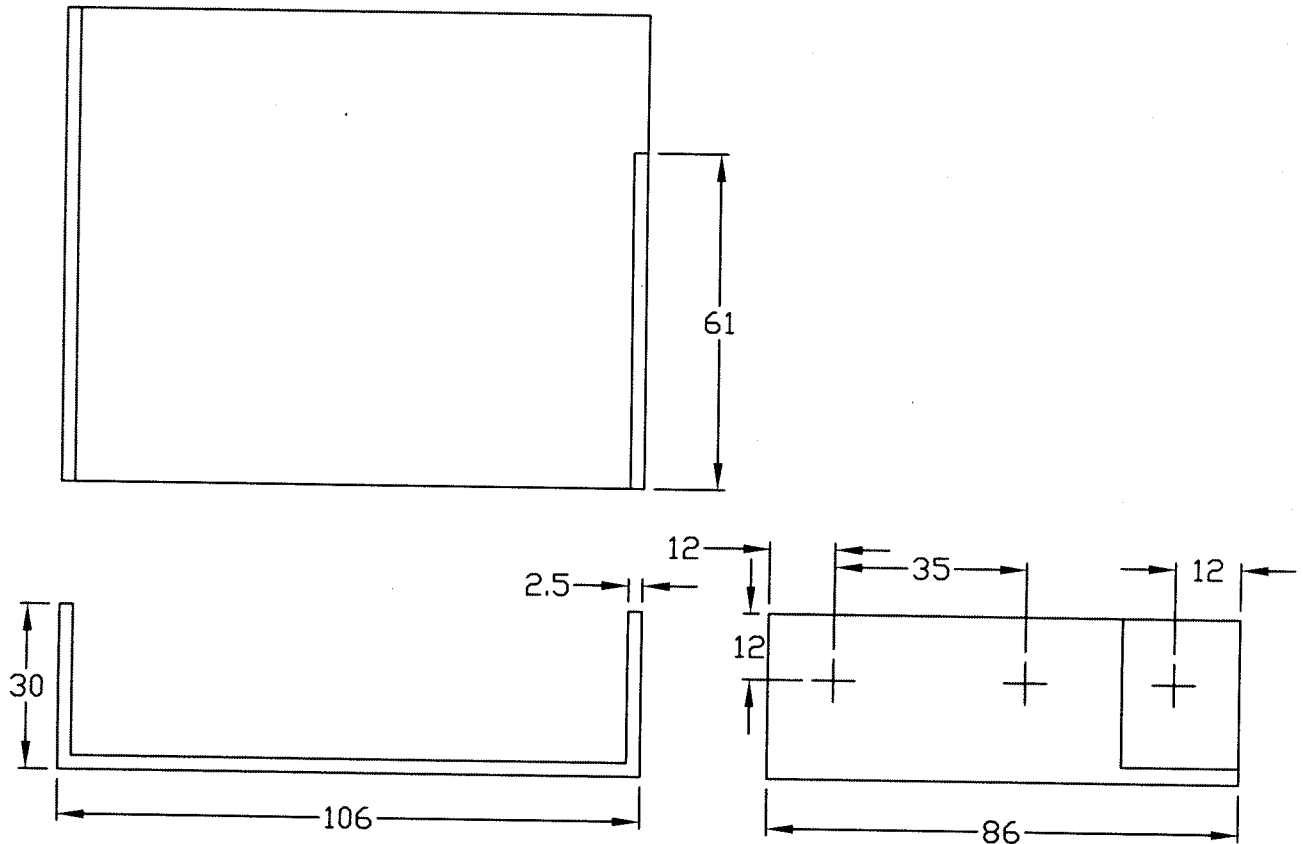
16-B-7

A

B

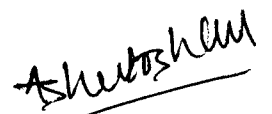
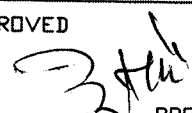
C

D



END PLATE
1-OFF

TOLERANCE:- IS: 2102 (PART-1)-1993 MEDIUM UNLESS OTHERWISE SPECIFIED.
PROCESS :- MACHINING

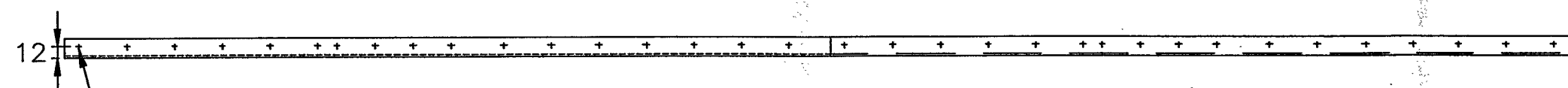
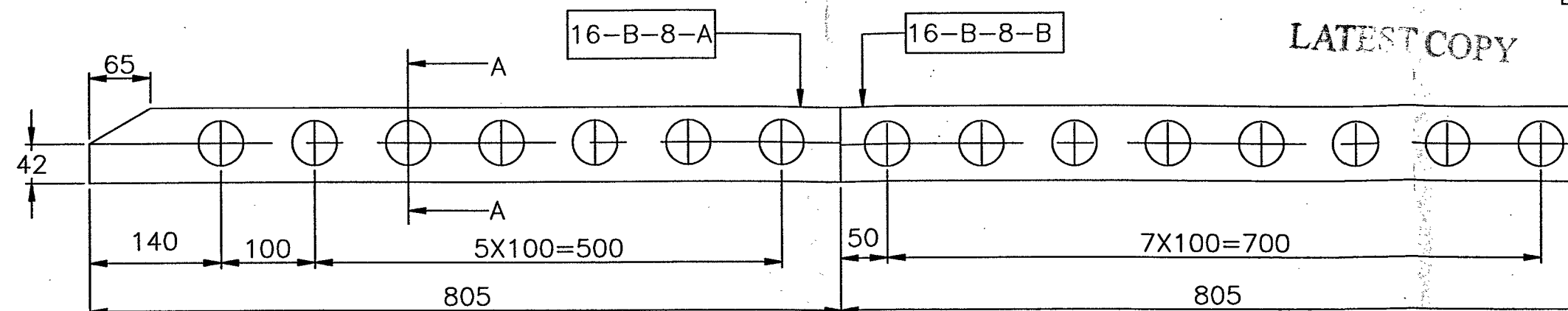
Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			D I/C D&S	HEAD Q.A.
SCALE:- 1:1		QTY:- 1 No,		A D R D E AGRA	DRN.	YOGESH	 PROJ.OFFR./GP.OFFR.	
DIMENSIONS IN mm				GROUP:-HDS	CHKD.	JC DUTTA		
TOL:- AS ABOVE				END PLATE GUIDE RAIL SUB ASSEMBLY HYDRAULIC TROLLEY H D SYSTEM FOR AN-32 AIRCRAFT			APPROVED  PROJ. DIR./GP.DIR.	
MATERIAL:- STEEL AS PER IS:2062-1999 (Gr.C)							DRG. No.	
FINISH:- AS PER SHEET No.215								
HEAT TREATMENT:-								
 				2.6.03-15-02-07				

LATEST COPY

SHEET 166 OF 215

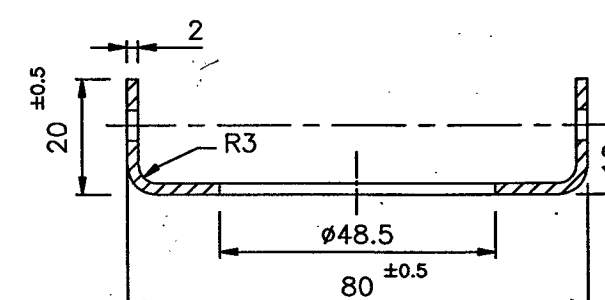
LATEST COPY

16-B-8



Ø5.2 HOLES ON EACH SIDE
THESE HOLES ARE TO BE TRANSFERRED FROM
CHANNEL LARGE FRONT (ITEM NO. 16-B-9)
AFTER ASSEMBLY.

16-B-8-B	CHANNEL SMALL FRONT-2	1
16-B-8-A	CHANNEL SMALL FRONT-1	1
ITEM	DESCRIPTION	QTY.



SECTION AT A-A

CHANNEL SMALL - FRONT
2-OFF

NOTE -1. R.H.S. IS SHOWN HERE.

2. ITEM NO. 16-B-8-B IS TO BE CONNECTED BETWEEN ITEM
ITEM NO. 16-B-16 & 16-B-8-A.

3. ITEM 16-B-8 IS TO BE MADE INTO TWO PARTS AS SHOWN ABOVE.

PROCESS :- FABRICATION

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	D I/C D&S	HEAD Q.A.
1						
2						
3						
4						

SCALE:- NTS	QTY:- 1 No.
DIMENSIONS IN mm	
TOLERANCE:- IS:2102 (PART-1)-1993 VERY COARSE UNLESS OTHERWISE SPECIFIED	
MATERIAL:- ALUMINIUM ALLOY GRADE 24345 (HE-15) AS PER IS :733-1983	
FINISH:- AS PER SHEET No.215	
HEAT TREATMENT:- W CONDITION	

A D R D E AGRA	DRN.	YOGESH
GROUP:- HDS	CHKD.	JC DUTTA
GUIDE RAIL SUB ASSEMBLY (L. H. SIDE & R. H. SIDE) TOP FRAME SUB ASSY HYDRAULIC TROLLEY H D SYSTEM FOR AN-32 AIRCRAFT		

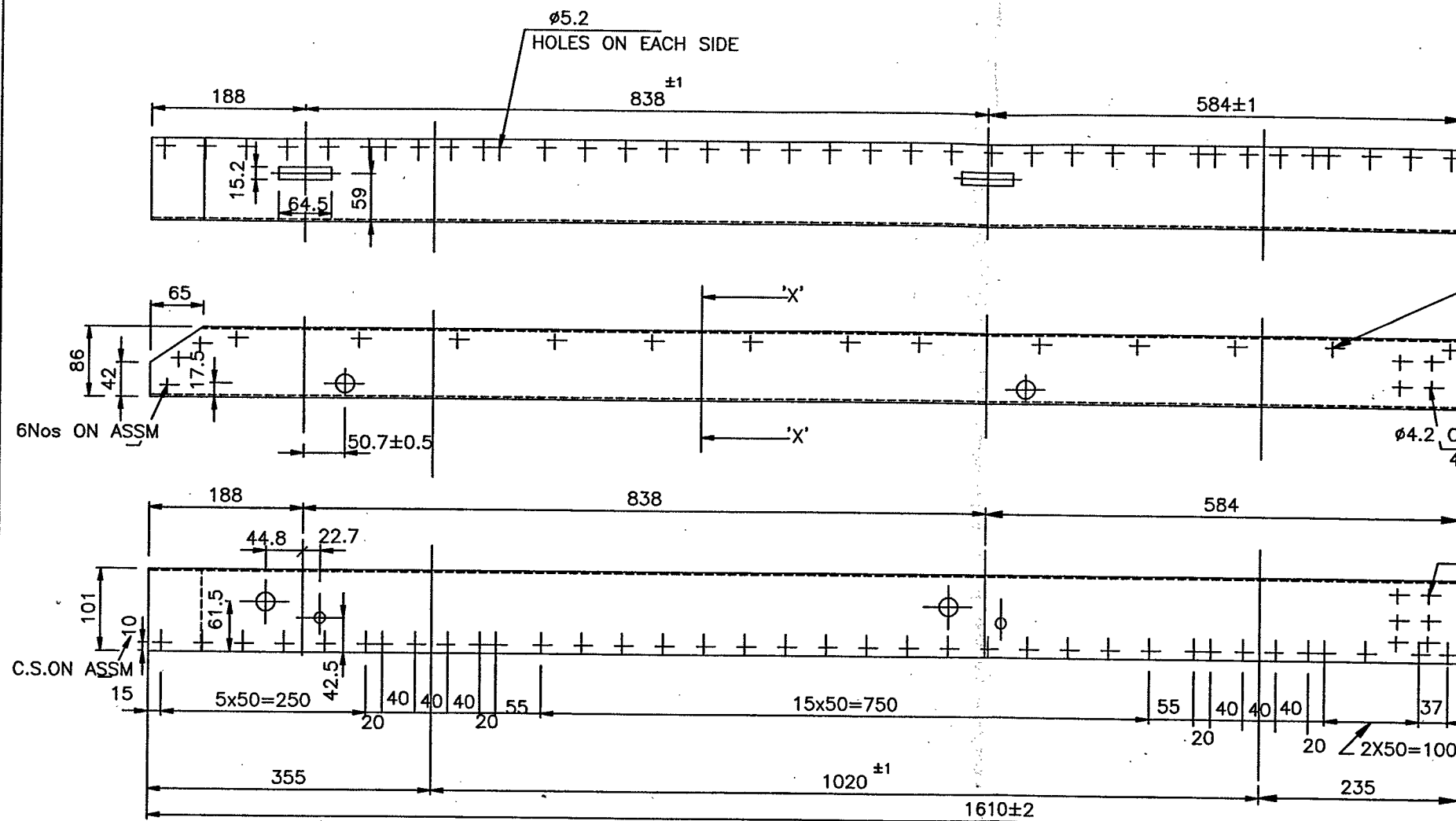
APPROVED 	PROJ.OFFR./GP.OFFR.
APPROVED 	PRJ.DIR./GP.DIR.
DRG. No.	2.6.03-15-02-08

LATEST COPY

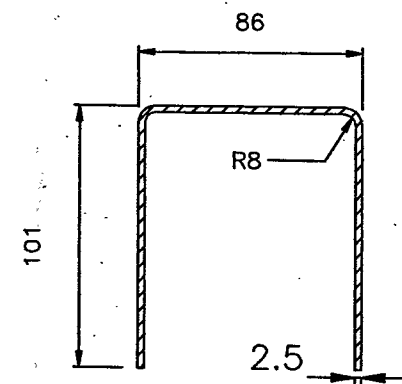
SHEET 167 OF 215

LATEST COPY

16-B-9



THESE HOLES ARE TO BE TRANSFERRED FROM ANGLE(DRG.NO.2.6.03-15-02-02) AFTER ASSEMBLY OF ANGLE WITH ITEMS NO.16-B-4,16-B-17 16-B-9.



CHANNEL LARGE - FRONT
1-OFF

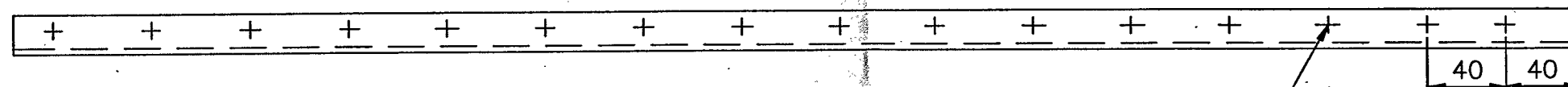
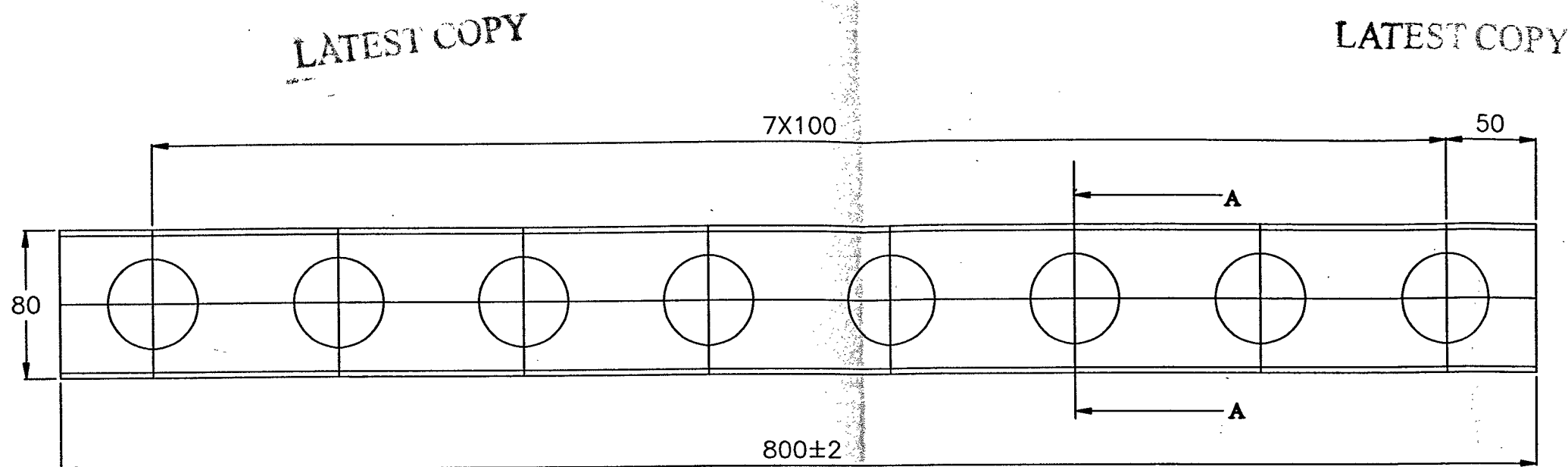
NOTE :- (1) R.H.S. IS SHOWN HERE.
(2) FOR ASSEMBLY OF ANGLE(ITEM NO.16-B-2) WITH ITEMS 16-B-4, 16-B-17 & 16-B-9 REAR END OF ANGLE SHOULD MATCH WITH REAR END OF ITEM 16-B-4.

PROCESS :- FABRICATION

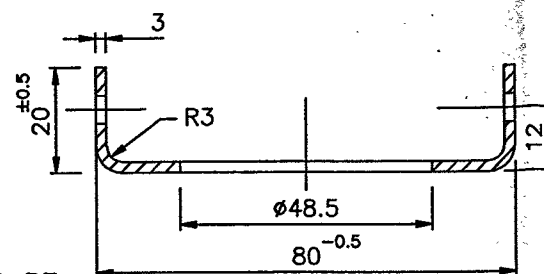
Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	D I/C D&S	HEAD Q.A.
1						
2						
3						
4						

SCALE:- NTS	A D R D E AGRA	DRN.	YDGESH
DIMENSIONS IN mm	GROUP:- HDS	CHKD.	JC DUTTA
TOLERANCE:- IS:2102 (PART-1)-1993 VERY COARSE UNLESS OTHERWISE SPECIFIED	GUIDE RAIL SUB ASSEMBLY (L.H. SIDE & R.H. SIDE) TOP FRAME SUB ASSY HYDRAULIC TROLLEY H D SYSTEM FOR AN-32 AIRCRAFT		
MATERIAL:- ALUMINIUM ALLOY GRADE 24345 (HE-15) AS PER IS :733-1983			
FINISH:- AS PER SHEET No.215			
HEAT TREATMENT:-			
APPROVED PROJ. DIR./GP.DIR. DRG. No. 2.6.03-15-02-09			

16-B-16



THESE HOLES ARE TO BE TRANSFERRED FROM
ITEM NO. 16-B-17.



SECTION AT A-A

CHANNEL SMALL - MIDDLE
2-OFF

NOTE:-(1) RHS IS SHOWN HERE.
(2) THESE ITEMS ARE TO BE POSITIONED
ONE AFTER OTHER JUST ADJACENT TO ITEM
16-B-3. THEN HOLES IN THESE ITEMS ARE TO BE
TRANSFERRED FROM ITEM 16-B-17.

PROCESS :- FABRICATION

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	I/C D&S	HEAD Q.A.
1						
2						
3						
4						

SCALE:- NTS	A D R D E AGRA	DRN.	YOGESH
DIMENSIONS IN mm	GROUP:- HDS	CHKD.	JC DUTTA
TOLERANCE:- IS:2102 (PART-1)-1993 VERY COARSE UNLESS OTHERWISE SPECIFIED	GUIDE RAIL SUB ASSEMBLY (L.H. SIDE & R.H. SIDE) TOP FRAME SUB ASSY HYDRAULIC TROLLEY H D SYSTEM FOR AN-32 AIRCRAFT		
MATERIAL:- ALUMINIUM ALLOY GRADE 24345 (HE-15) AS PER IS :733-1983			
FINISH:- AS PER SHEET No.215			
HEAT TREATMENT:- W CONDITION			

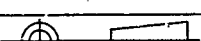
APPROVED

DRG. No.

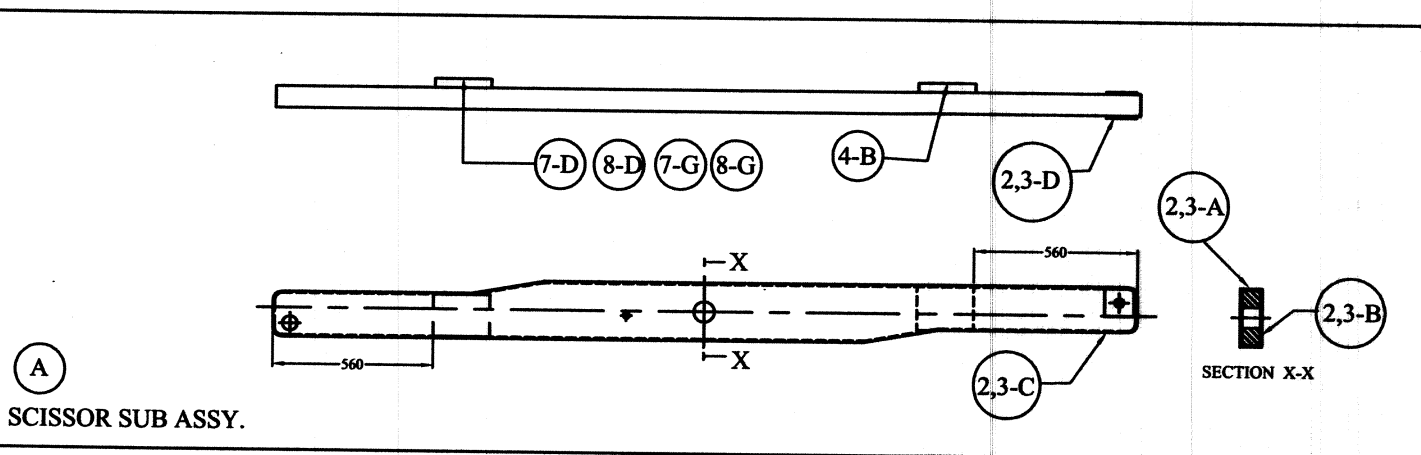
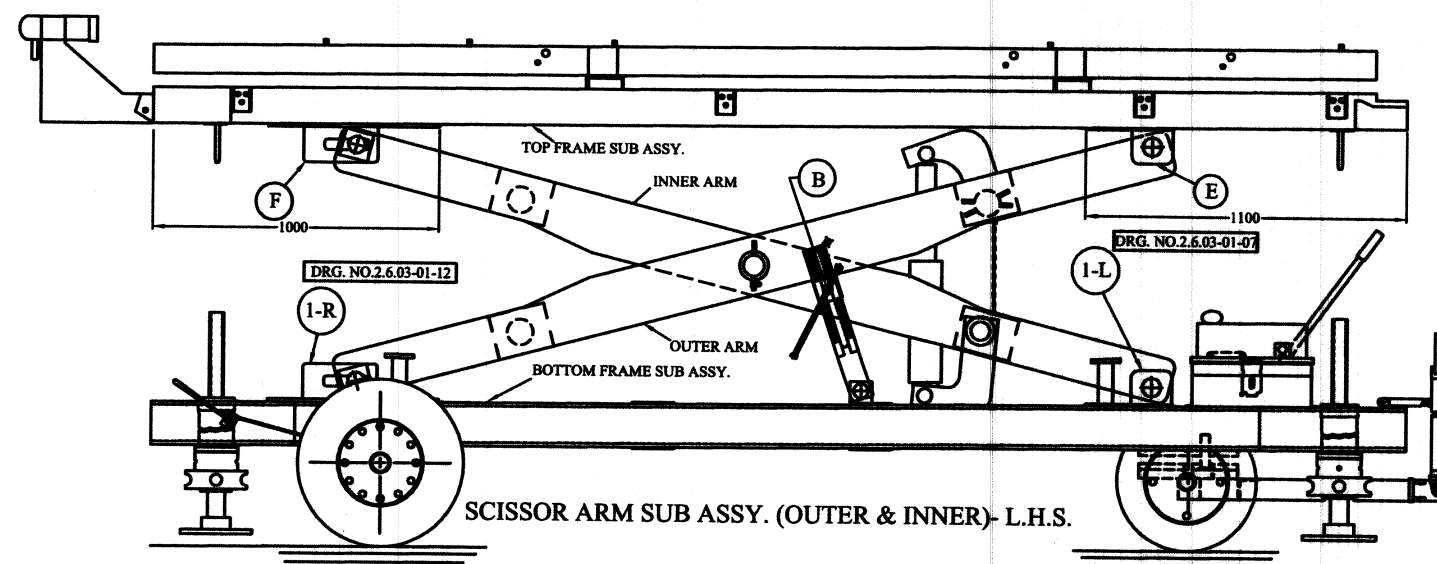
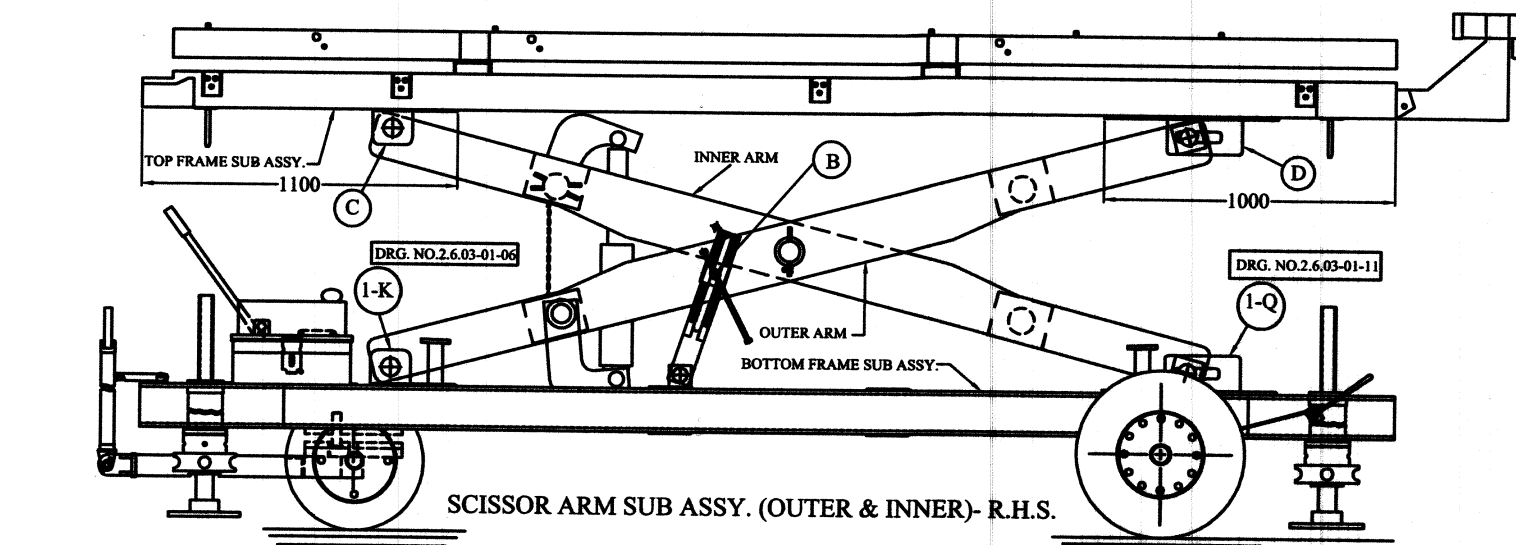
2.6.03-15-02-10

LATEST COPY
LATEST COPY



SCALE:- NTS	QTY:- 1 No.	A D R D E AGRA	DRN.	YDGESH	 PROJ.OFFR./GP.OFFR.
DIMENSIONS IN mm		GROUP:- HDS	CHKD.	JC DUTTA	
TOLERANCE:- IS:2102(PART1)-1993 VERY COARSE UNLESS OTHERWISE SPECIFIED		CHANNEL LARGE - MIDDLE GUIDE RAIL SUB ASSEMBLY HYDRAULIC TROLLEY H D SYSTEM FOR AN-2 AIRCRAFT			APPROVED  PROJ. DIR./GP.DIR
MATERIAL:- ALUMINIUM ALLOY GRADE 24345 (HE-15) AS PER IS :733-1983					
FINISH:- AS PER SHEET No.215					DRG. No. 2.6.03-15-02-14
HEAT TREATMENT:- W CONDITION					
					

2 3



NOTE: -1.RHS VIEW OF SCISSOR SUB ASSY(ITEM A) IS SHOWN ABOVE.

2. ON REAR SIDE, SCISSOR ARM SUB ASSY (OUTER) & SCISSOR ARM SUB ASSY.(INNER) OF RHS ARE JOINED TO SCISSOR ARM SUB ASSY. (INNER) & SCISSOR ARM SUB ASSY.(OUTER) RESPECTIVELY OF LHS USING SUPPORT PIPE SUB ASSY(REAR SIDE).

3. ON FRONT SIDE, SCISSOR ARM SUB ASSY.(OUTER) & SCISSOR ARM SUB ASSY.(INNER) OF RHS ARE JOINED TO SCISSOR ARM SUB ASSY. (INNER) & SCISSOR ARM SUB ASSY.(OUTER) RESPECTIVELY OF LHS USING BRACKET FOR HYDRAULIC JACK (UPPER & LOWER).

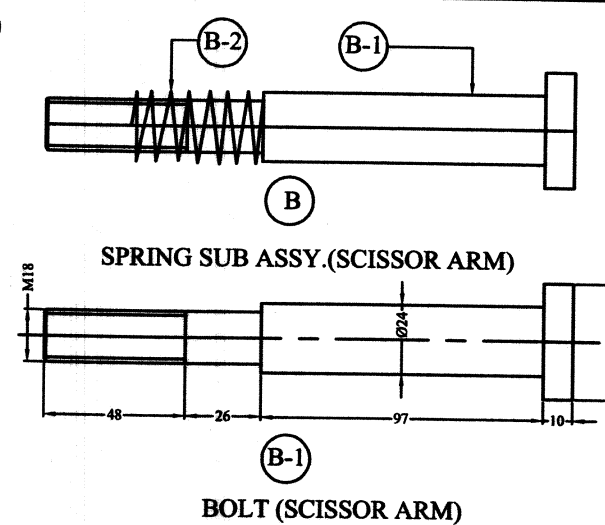
4. ITEM B IS TO BE USED ONLY WITH SCISSOR SUB ASSY. (OUTER) OF BOTH SIDES I.e. RHS & LHS.

5. MATERIAL OF BOLT(SCISSOR ARM) : ALLOY STEEL EN19 (709M40) / EN24 (817M40) AS PER BS970. HARDNESS : 28-36 HRC (HARD. & TEMPERED).

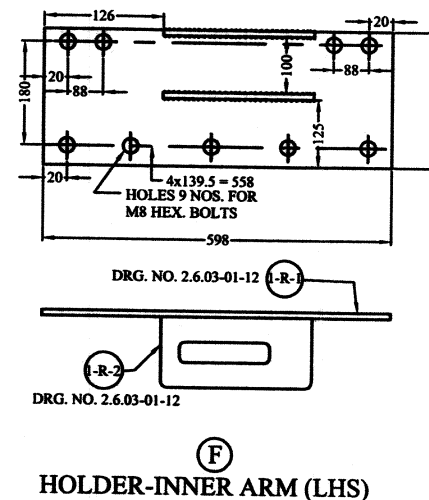
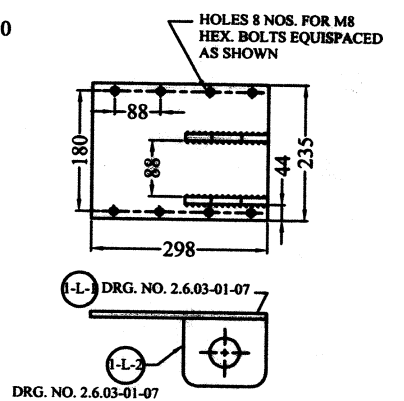
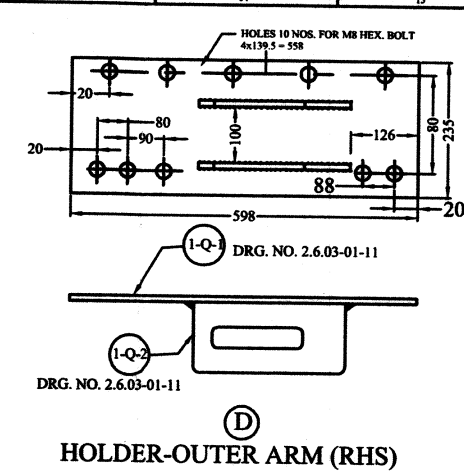
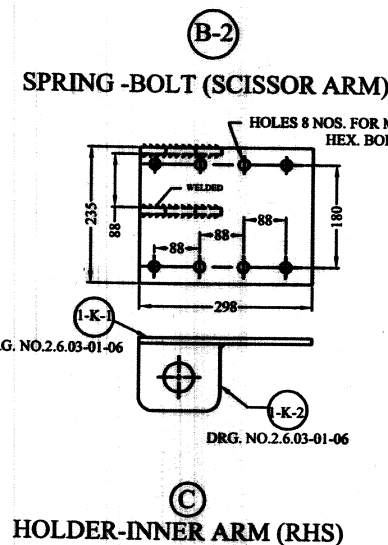
6.MATERIAL OF SPRING-BOLT(SCISSOR ARM) : STAINLESS SPRING STEEL WIRE AS PER IS: 4454-2001 (Pt. 4) Gr.1.

7. MATERIAL & FINISH REQUIREMENTS FOR ITEMS-C,D,E&F ARE SAME AS THOSE FOR ITEM 1-K.

8.COMPONENTS OF ITEMS C,D,E & F ARE EXACTLY SIMILAR TO THEIR CORRESPONDING COMPONENTS OF ITEMS K,Q,L & R RESPECTIVELY AS SHOWN ABOVE.



FREE LENGTH OF SPRING = 49 mm
OUTER COIL DIAMETER = 25 mm
WIRE DIA. = 2.5 mm
TOTAL NO. OF TURNS = 7
STIFFNESS OF SPRING = 0.53 kg per mm.
ENDS ARE GROUND SQUARE TO AXIS.



8-G	SUPPORT PLATE-2	1	2.6.03-07-07	45
8-D	SUPPORT PLATE-1	1	2.6.03-07-04	42
7-G	SUPPORT PLATE-2	1	2.6.03-06-07	37
7-D	SUPPORT PLATE-1	1	2.6.03-06-04	34
4-B	SIDE PLATE	2	2.6.03-03-02	23
F	HOLDER-INNER ARM (LHS)	1	2.6.03-02-00	17
E	HOLDER-OUTER ARM (LHS)	1	2.6.03-02-00	17
D	HOLDER-OUTER ARM (RHS)	1	2.6.03-02-00	17
C	HOLDER-INNER ARM (RHS)	1	2.6.03-02-00	17
B	B-2 SPRING - BOLT (SCISSOR ARM)	2	2.6.03-02-00	17
	B-1 BOLT (SCISSOR ARM)	2	2.6.03-02-00	20
A	2,3-D STRENGTHENING PLATE	8	2.6.03-02-03	20
	2,3-C ARM COVER PLATE	4	2.6.03-02-02	19
	2,3-B COVER PLATE	8	2.6.03-02-02	19
	2,3-A SCISSOR OUTER & INNER ARM	2+2	2.6.03-02-01	18
ITEM	DESCRIPTION	QTY.	DRG. NO.	SHEET NO.

DETAIL INDEX

TOL: - IS: 2102 (PART-1)-1993 VERY COARSE UNLESS OTHERWISE SPECIFIED.

9. HEX. BOLTS, NUTS & WASHERS ARE TO BE USED TO CONNECT ITEMS C,D,E,F WITH TOP FRAME SUB ASSY.

10. ALL THE HEX. BOLTS AND NUTS ARE AS PER IS:1364-2002.

11. ALL THE PLAIN WASHERS ARE AS PER IS: 2016.

SCALE: - N T S	AD R D E AGRA	DRN.	W C LAL
DIMENSIONS IN mm	GROUP: - HDS	CHD.	J.C.DUTTA
TOL: - AS ABOVE	SCISSOR ARM SUB ASSY. (OUTER & INNER) HYDRAULIC TROLLEY HD SYSTEM FOR AN-32 AIRCRAFT		
MATERIAL: - AS ABOVE	APPROVED		
FINISH: -	DRG. NO. 2.6.03-02-00		
HEAT TREATMENT: -			

REF.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O I/C (D&S)	HEAD (Q.A.)