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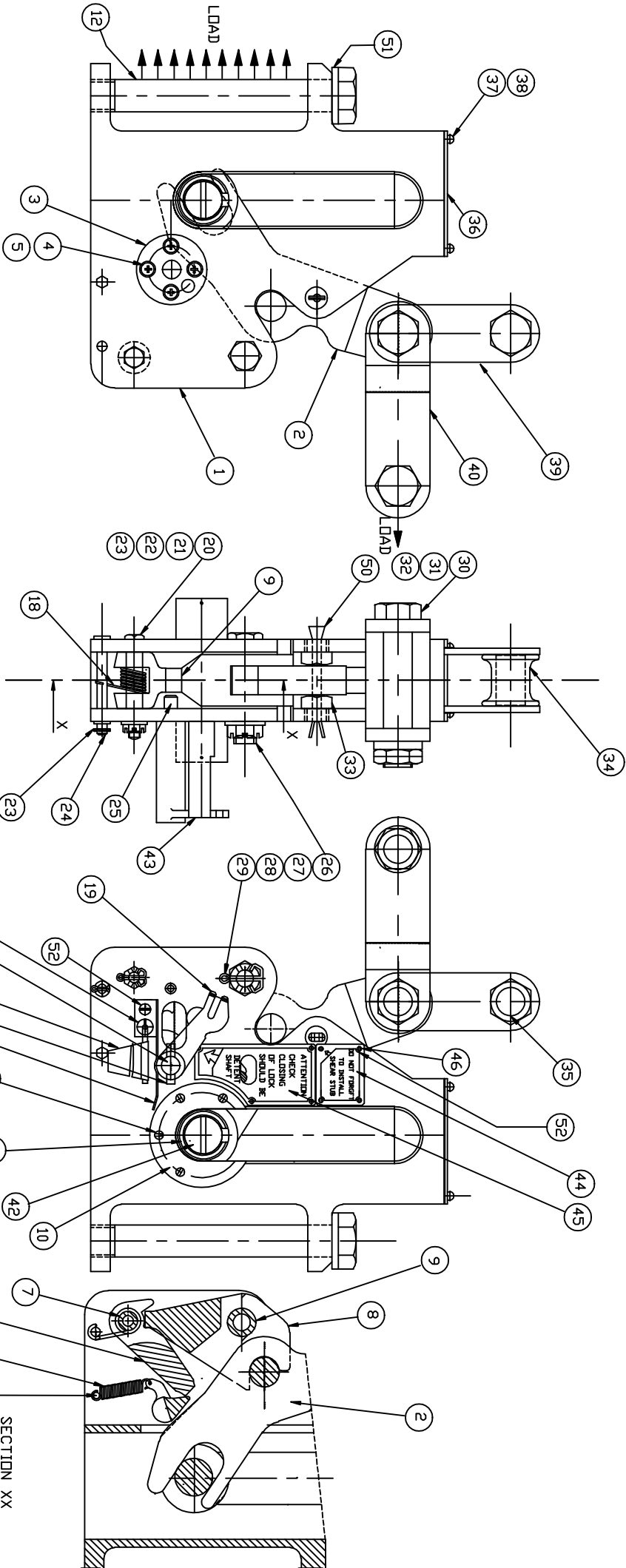
4

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1

SHEET 1 OF 45



PROOF LOAD TEST :- ALL THE PLATFORM FASTENING RELEASE LOCK(PFRL) ARE TO BE SUBJECTED TO PROOF LOAD TEST AT 2740 Kgf LOAD (USING SUITABLE FIXTURE)

PERFORMANCE TEST :-PERFORMANCE TEST MAY BE CARRIED BY DETACHING LEVER (DETAIL No 2) AT1370 Kgf LOAD BY PULLING BACK LOCK LEVER (DETAIL No 19)

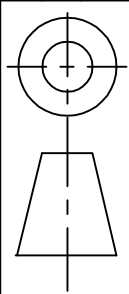
FINISH :- ALL ,BOLTS,WASHERS AND PINS ARE TO BE CADMIUM PLATED 10-12 MICRON AS PER IS : 1572

PACKING:- EACH UNIT (PFRL) SHALL BE WRAPPED WITH BUTTER PAPER AGAIN EACH UNIT SHALL BE PACKED IN A POLYTHENE BAG AND EACH BAG SHALL BE PLACED IN SUITABLE WOODEN/CORRUGATED BOX. EACH BOX SHALL BE IDENTIFIED BY A LABEL SHOWING CAT. No DESIGNATION OF THE STORE AND RECOGNISED INITIAL OF THE MANUFACTURER AND YEAR OF THE MANUFACTURE.

52	IS:1365-1968	SLOTTED RAISED C'SK HEAD SCREW A	8	-
51	IS:3063-1965	SPRING WASHER M20	2	-
50	ADRD/1412-42	SHEAR PIN	10	45
49	ADRD/1412-41	PIN (RED FLAG)	1	44
48	ADRD/1412-40	BUSHING	1	43
47	ADRD/1412-39	SPRING (LEAF)	1	42
46	IS:1365-1968	SLOTTED RAISED C'SK HEAD SCREW A M36	7	-
45	ADRD/1412-38	INSTRUCTION PLATE II	1	41
44	ADRD/1412-37	INSTRUCTION PLATE I	1	40
43	ADRD/1412-36	STOPPER	1	39
42	ADRD/1412-35	PLUG	2	38
41	ADRD/1412-34	PIVOT	1	37
40	ADRD/1412-33	LINK	1	36
39	ADRD/1412-32	SIDE PLATE	2	35
38	IS:3063-1965	SPRING WASHER M-4 B	3	-
37	IS:6101-1971	PAN HEAD SCREW A M-3X10	4	-
36	ADRD/1412-31	COVER PLATE	1	34
35	ADRD/1412-30	BOLT(HEX.M18x60)	2	33
34	ADRD/1412-29	PULLY	1	32
33	ADRD/1412-28	BUSHING	2	31
32	IS:3063	SPRING WASHER M-18 B	3	-
31	ADRD/1412-27	NUT(M-18)	3	30
30	ADRD/1412-26	BOLT(HEX. M18X94)	1	29
29	IS:549-1974	SPLIT PIN 2X37	1	-
28	ADRD/1412-25	WASHER	1	28
27	ADRD/1412-24	HEX. NUT (SLOTTED)	1	27
26	ADRD/1412-23	BOLT	1	26
25	ADRD/1412-22	PIN(STOPPER)	1	25
24	ADRD/1412-21	ROLLER	1	24
23	IS:549-1974	SPLIT PIN 2X23	1	23
22	ADRD/1412-20	PLAN WASHER	1	22
21	ADRD/1412-19	SLOTTED HEX. NUT	1	21
20	ADRD/1412-18	HEX. NUT	1	20
19	ADRD/1412-17	LOCK LEVER	1	19
18	ADRD/1412-16	TORSION SPRING	1	18
17	ADRD/1412-15	SHAFT	1	17
16	ADRD/1412-14	LOCK PIN	1	16
15	ADRD/1412-13	SPRING(TENSION SPRING)	1	15
14	IS:3063	SPRING WASHER M-4-B	1	-
13	ADRD/1412-12	STUD	1	13
12	ADRD/1412-11	BOLT PFRL	1	12
11	ADRD/1412-10	SCREW	5	11
10	ADRD/1412-09	FLANGE II	1	10
9	ADRD/1412-08	BUSH- LARGE	1	9
8	ADRD/1412-07	LEVER- II	1	8
7	ADRD/1412-06	BUSH SMALL	1	7
6	ADRD/1412-05	PAWL	1	6
5	IS:537	MULTI-TOOTH LOCK WASHER C 5.4	9	-
4	ADRD/1412-04	SCREW OR SLOTTED COUNTER SUNKHEAD	4	7
3	ADRD/1412-03	FLANGE	1	6
2	ADRD/1412-02	SUB ASSEMBLY(LEVER-SHAFT)	1	3-5
1	ADRD/1412-01	HOUSING	1	2
-	ADRD/1412	ASSEMBLY	-	1
DETAIL NO.	DRG / SPEC.No.	NOMENCLATURE	QTY	SHEET NO.

DETAIL INDEX.

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/C	PGD



(H D SYSTEM FOR AN 32 AIRCRAFT)

PLATFORM FASTENING
AND RELEASE LOCK

DRG.No.

ADRD/1412

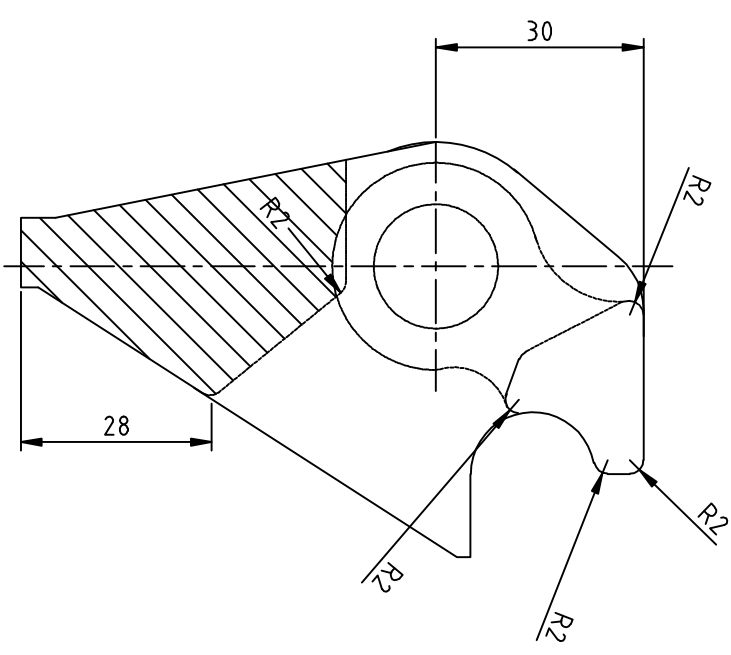
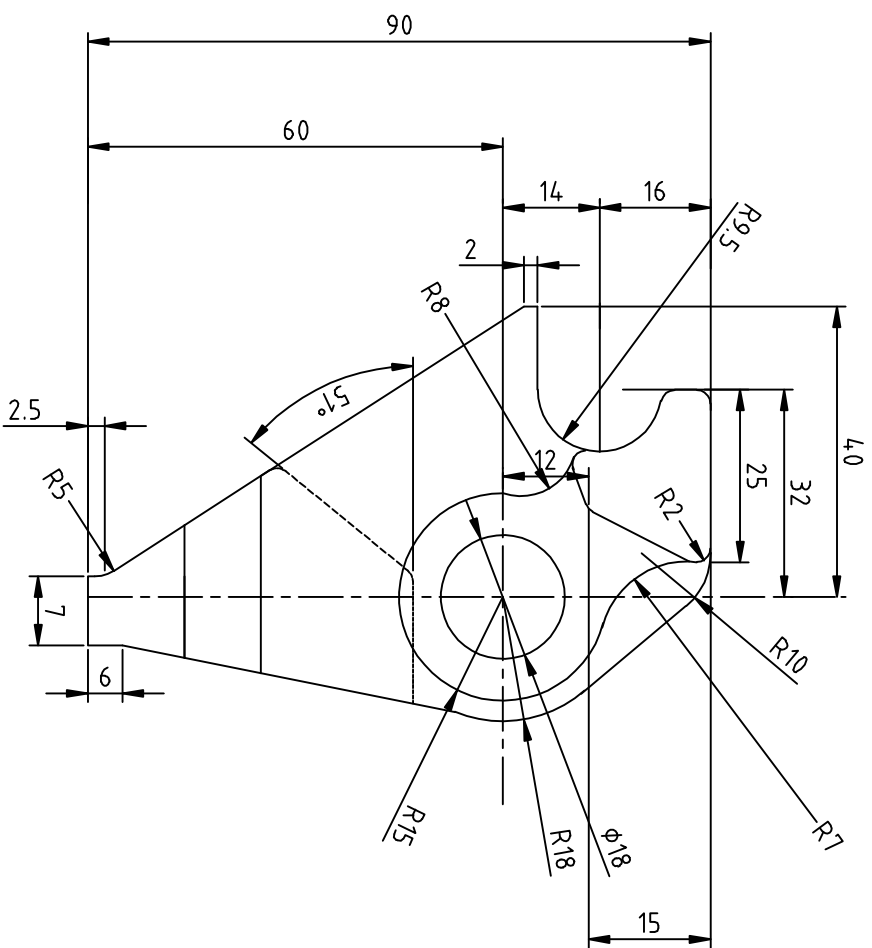
PROJ OFFR

PD

O I/C D&S

APPROVED

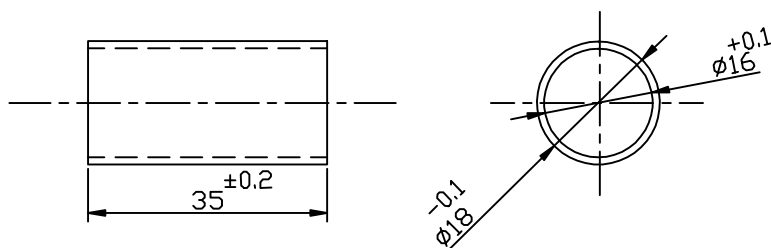
HEAD(QA)



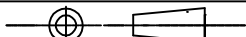
MATERIAL :- EN 19 (709 M-40)/EN24 (817 M-40) AS PER SPECIFICATION BS : 970
FINISH:- AS PER SHEET No. 2 OF 45
TOLERANCE:- IS:2102 (PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.
WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK, TOOL MARKS AND ANY OTHER SURFACE DEFECTS.
PROCESS:- MACHINING FROM FORGED BLOCK

[illegible]

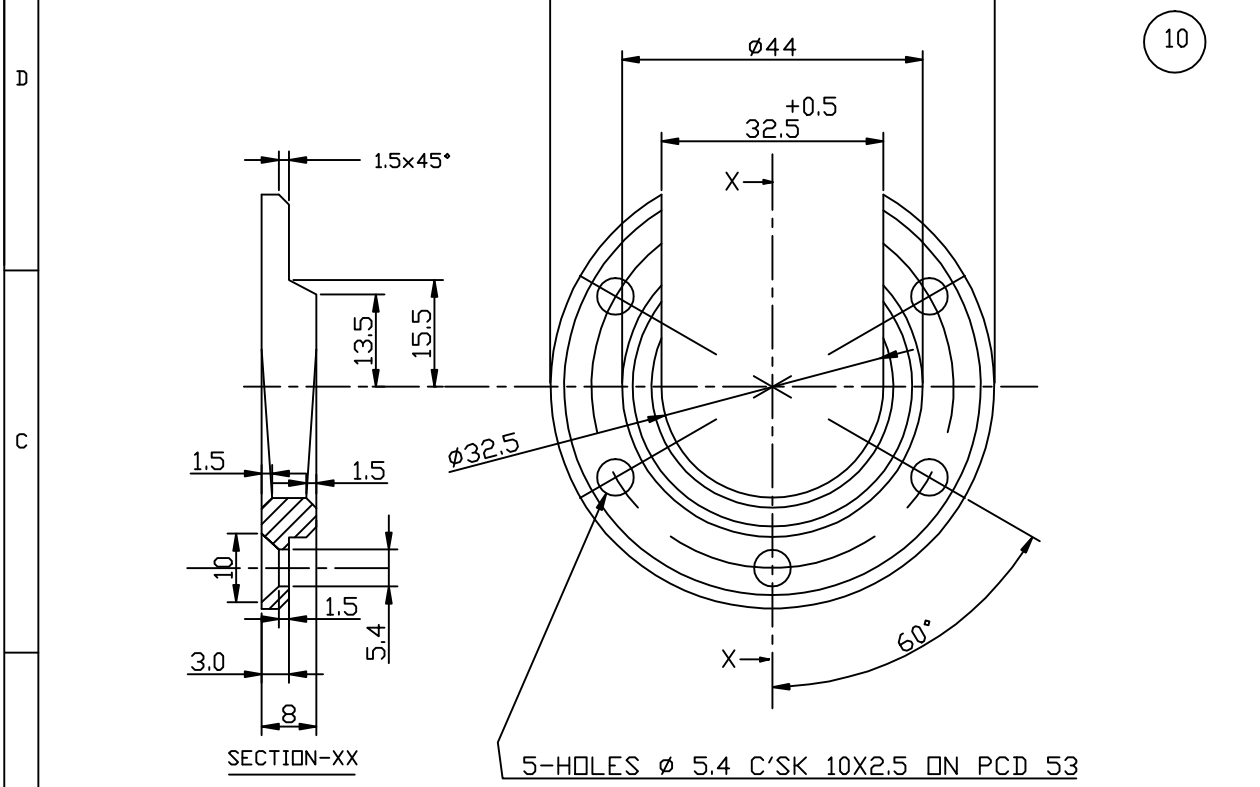
A



PROCESS:- MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			I/C D&S	HEAD Q.A.
SCALE 1:1		QTY:- 1 No.	A D R D E AGRA	DRN.,	SK SHARMA	PRO.OFFR		
DIMENSIONS IN mm			GROUP:- HDS	CHD.	JC DUTTA	PD		
TOL:- IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.			BUSH-LARGE PLATFORM FASTENING AND RELEASE LOCK HD SYSTEM FOR AN 32 AIRCRAFT			I/C D&S APPROVED HEAD Q.A. DRG. NO. ADRDE/1412-08		
MATERIAL AS ABOVE								
FINISH :- AS PER SHEET NO 2 OF 45								
HEAT TREATMENT:- NORMAL CONDITION								
								

4	3	2	1
			SHEET 12 OF 45



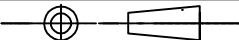
MATERIAL:- STEEL FOR GENERAL STRUCTURAL PURPOSE SPEC.IS:2062

FINISH:- AS PER SHEET No. 2 OF 45

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

WORKMANSHIP:- THE FINISHED COMPONENT SHALL BE FREE FROM CRACK, TOOLMARKS AND ANY OTHER SURFACE DEFECT.

PROCESS:- MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			□ I/C D&S	HEAD Q.A.
SCALE 1:1		QTY:- 1No.	A D R D E AGRA	DRN..	SK SHARMA	PRO.DFFR.		
DIMENSIONS IN mm			GROUP:-HDS	CHD.	JC DUTTA	PD		
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED			FLANGE II PLATFORM FASTENING AND RELEASE LOCK HD SYSTEM FOR AN 32 AIRCRAFT			□ I/C D&S APPROVED HEAD Q.A. DRG. NO. ADRDE/1412-09		
MATERIAL AS ABOVE								
FINISH:- AS PER SHEET NO.2 OF 45								
HEAT TREATMENT :- NORMAL CONDITION.								
								

4	3	2	1
			SHEET 13 OF 45

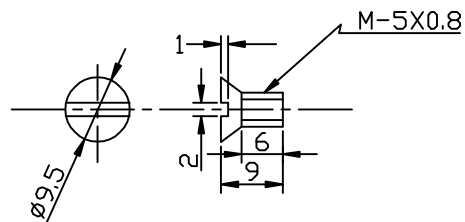
(11)

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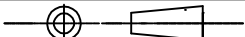
MATERIAL:- EN 19(709 M-40)/EN-24(817 M-40)AS PER SPECIFICATION BS:970

FINISH:- AS PER SHEET No. 2 OF 45

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

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOLMARKS AND ANY OTHER SURFACE DEFECT.

PROCESS :- MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			I/C D&S	HEAD Q.A.
SCALE 1:1		QTY:- 5 Nos.	A D R D E AGRA		DRN..	SK SHARMA	PRO.DFFR.	
DIMENSIONS IN mm			GROUP:-HDS		CHD.	JC DUTTA	PD	
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.			SCREW PLATFORM FASTENING AND RELEASE LOCK HD SYSTEM FOR AN 32 AIRCRAFT				I/C D&S	
MATERIAL :- AS ABOVE							APPROVED	
FINISH:- AS PER SHEET NO.2 OF 45							HEAD Q.A.	
HEAT TREATMENT :- NORMAL CONDITION.							DRG. NO. ADRDE/1412-10	
								

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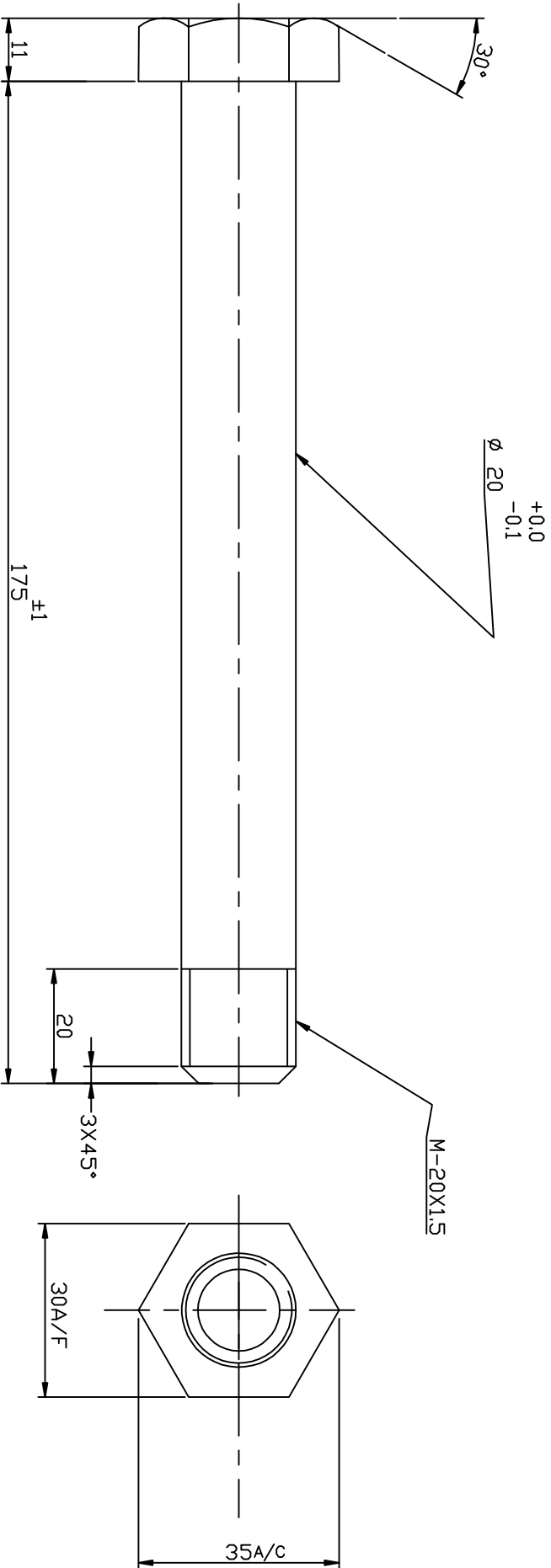
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SHEET 14 OF 45

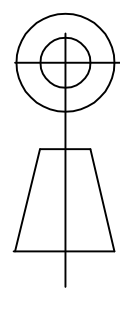
12



MATERIAL:-- EN 19(709-40) EN 24(817 M-40) AS PER SPECIFICATION BS:970.
FINISH:-- AS PER SHEET No. 2
TOLERANCE: IS:2102(PART-1)MEDIUM UNLESS OTHERWISE SPECIFIED.
WORKMANSHIP:-- THE FINISHED COMPONENT SHALL BE FREE FROM PITS,CRACKS,TOOL MARKS AND ANY OTHER SURFACE DEFECTS.
PROCESS:-- MACHINING FROM FORGED BAR/BLANK

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/C	PGD

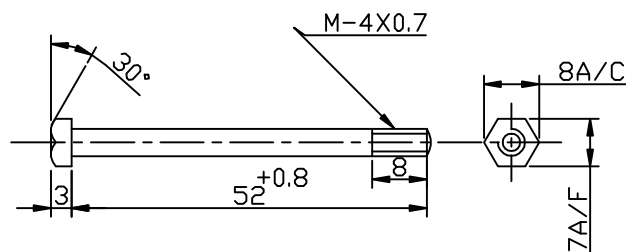
SCALE:-1:1	QTY:-1No.
DIMENSIONS ARE IN mm	
TOLERANCE:AS ABOVE	
MATERIAL :-AS ABOVE	
FINISH:-AS ABOVE	
HEAT TREATMENT:- 265-352 BHN(32±5 RHC)	



ADRDE AGRA	DRN	SK SHARMA	PROJ OFFR
GROUP:HD5	CHD	JC DUTTA	PD
BOLT-M 20X175 PLATFORM FASTENING AND RELEASE LOCK (H D SYSTEM FOR AN 32 AIRCRAFT)			O I/C D&S
			APPROVED
			HEAD(QA)
			DRG.No.
			ADRDE/1412-11

4	3	2	1
			SHEET 15 OF 45

13



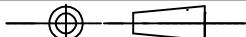
MATERIAL:- 709 M-40(EN-19) 817 M-40 (EN-24) AS PER SPECIFICATION BS:970

FINISH:- AS PER SHEET No. 2 OF 45

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

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOLMARKS AND ANY OTHER SURFACE DEFECT.

PROCESS:- MACHINING

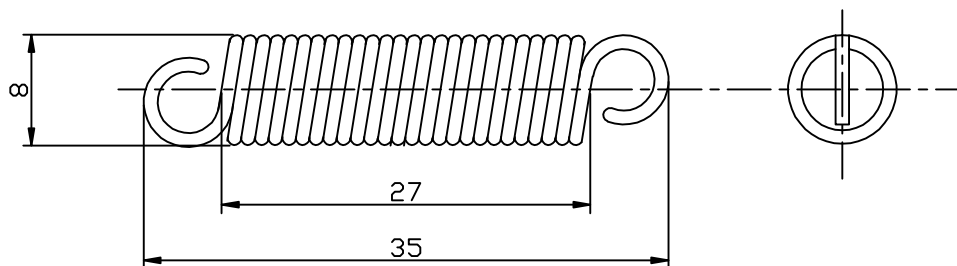
R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			☐ I/C D&S	HEAD Q.A.
SCALE 1:1		QTY:-1No.		A D R D E AGRA	DRN..	SK SHARMA	PRO.OFFR.	
DIMENSIONS IN mm				GROUP:-HDS		CHD.	JC DUTTA	PD
TOL:- IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED. MATERIAL :- AS ABOVE				STUD PLATFORM FASTENING AND RELEASE LOCK HD SYSTEM FOR AN 32 AIRCRAFT			☐ I/C D&S	
FINISH :- AS PER SHEET NO 2 OF 45							APPROVED	
HEAT TREATMENT :- 265-352 BHN							HEAD Q.A.	
							DRG. NO. ADRDE/1412-12	

4	3	2	1
			SHEET 16 OF 45

15

D

C



No. OF ACTIVE COILS:- 27 Nos.

WIRE DIA :- 1.00mm

STIFFNESS:- 1.13Kg/ mm

B

MATERIAL:- STAINLESS STEEL SPRING WIRE IS: 4454:1974(Pt. IV) Gr I

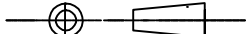
FINISH:- NATURAL

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

WORKMANSHIP:- SMOOTH FINISHED ROUND ENDS MARKS AND ANY OTHER SURFACE DEFECT.

PROCESS:- MACHINING/COILING

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R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			I/C D&S	HEAD Q.A.			
SCALE 2:1		QTY:-1No.	A D R D E AGRA		DRN..	SK SHARMA	PRO.OFFR.				
DIMENSIONS IN mm			GROUP:-HDS		CHD.	JC DUTTA	PD				
TOL:- IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.			SPRING (TENSION) PLATFORM FASTENING AND RELEASE LOCK HD SYSTEM FOR AN 32 AIRCRAFT					I/C D&S			
MATERIAL:-AS ABOVE								APPROVED		HEAD Q.A.	
FINISH :-NORMAL								DRG. NO. ADRDE/1412-13			
HEAT TREATMENT:- 265-352 BHN(32±5 RHC)											
											

4	3	2	1
			SHEET 17 OF 45

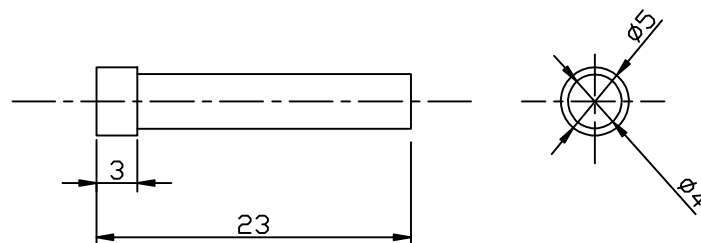
16

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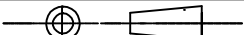
MATERIAL:-EN 19(709 M-40) EN-24(817 M-40)AS PER SPECIFICATION BS:970

FINISH:- AS PER SHEET No. 2 OF 45

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

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOLMARKS AND ANY OTHER SURFACE DEFECT.

PROCESS:- MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			I/C D&S	HEAD Q.A.
SCALE 2:1		QTY:-1No.		A D R D E AGRA	DRN..	SK SHARMA	PRO.DFFR.	
DIMENSIONS IN mm				GROUP		CHD.	JC DUTTA	PD
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.				LOCK-PIN PLATFORM FASTENING AND RELEASE LOCK HD SYSTEM FOR AN 32 AIRCRAFT				
MATERIAL:-AS ABOVE								
FINISH :- AS PER SHEET NO 2								
HEAT TREATMENT:- 265-352 BHN								
				APPROVED HEAD Q.A. DRG. NO. ADRDE/1412-14				

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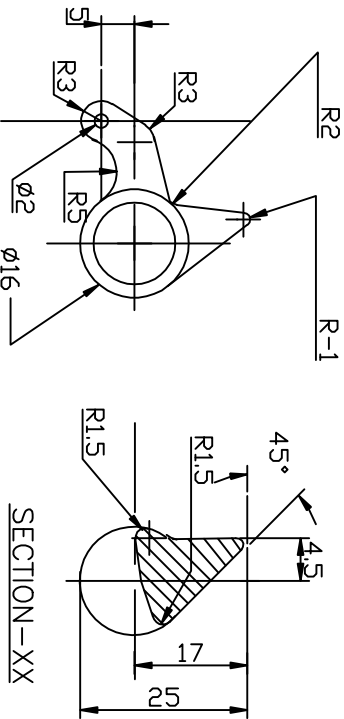
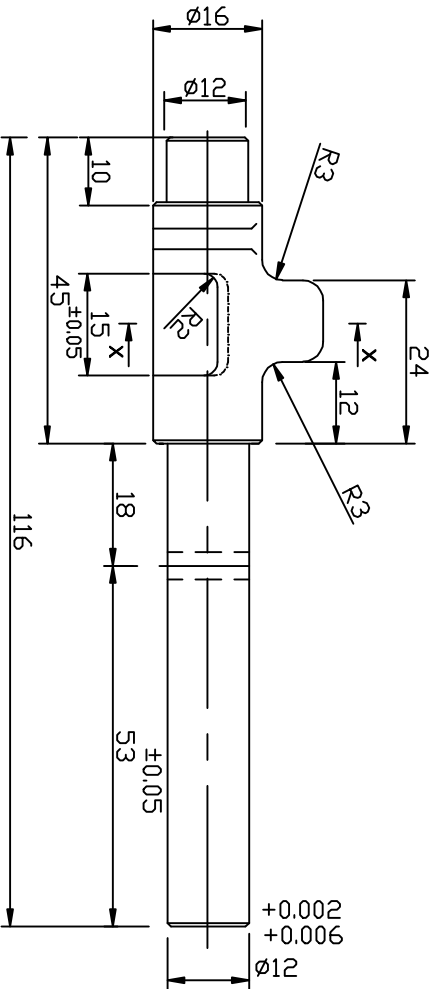
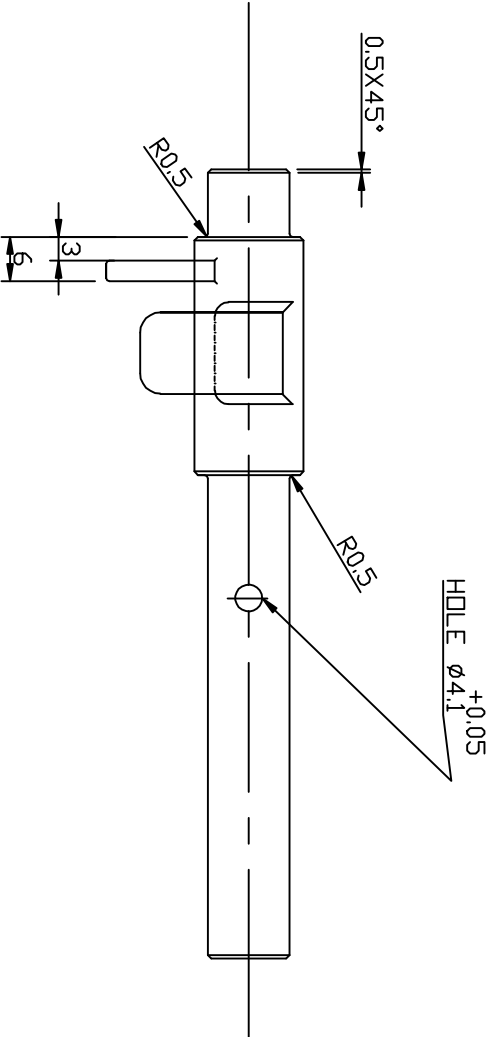
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SHEET 18 OF 45

17

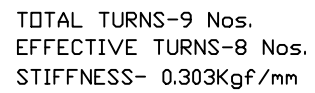


MATERIAL:- EN 19(709-40)/ EN 24(817 M-40) AS PER SPECIFICATION BS:970.
FINISH:- AS PER SHEET No. 2 OF 45
TOLERANCE:- IS:2102(PART-1)MEDIUM UNLESS OTHERWISE SPECIFIED.
WORKMANSHIP: -THE FINISHED COMPONENT SHALL BE FREE FROM PITS,CRACKS,TOOL MARKS AND ANY OTHER SURFACE DEFECTS
PROCESS:- FORGING.& MACHINING

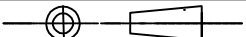
Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/C	PGD

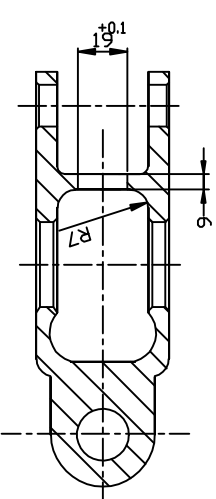
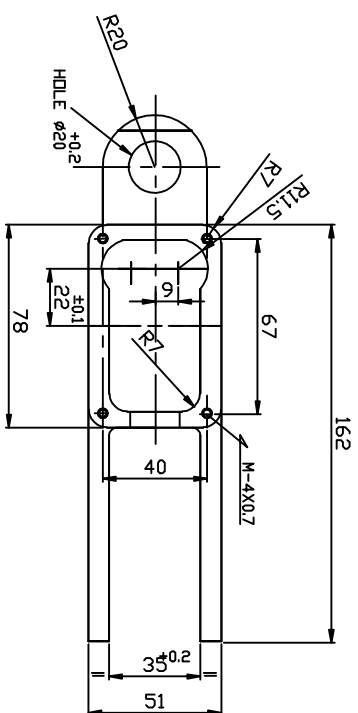
SCALE:-1:1	QTY:-1No.	ADDRDE: AGRA	DRN	SK SHARMA	PROJ OFFR
DIMENSIONS ARE IN mm	GROUP:HDS		CHD	JC DUTTA	PD
TOLERANCE:AS ABOVE					O I/C D&S
MATERIAL :-AS ABOVE					APPROVED
FINISH:- AS PER SHEET No 2					DIVISIONAL HEAD(QA)
HEAT TREATMENT:- 265-352 BHN					DRG.No.

	SHAFT PLATFORM FASTENING AND RELEASE LOCK (H D SYSTEM FOR AN 32 AIRCRAFT)	ADRDE/1412-15
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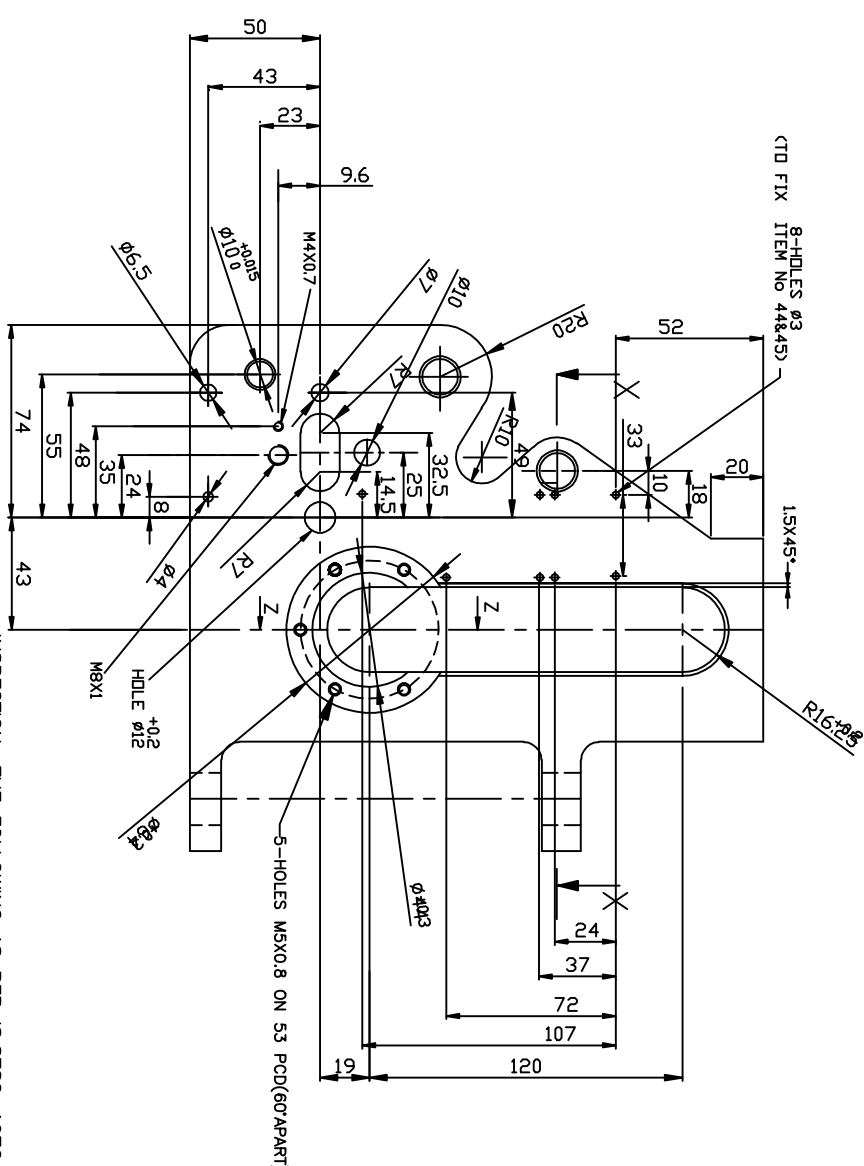
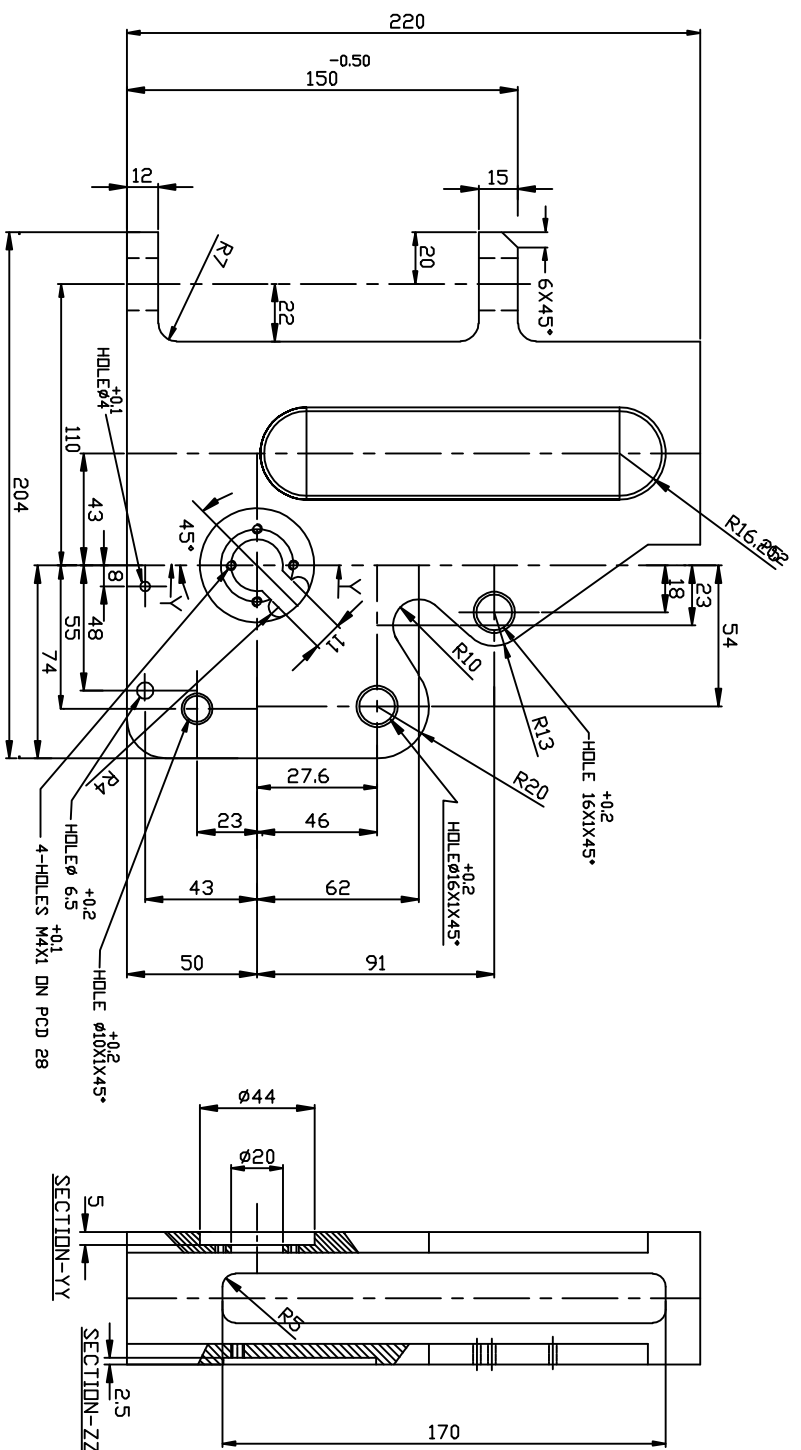


PROCESS- COILING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD						I/C D&S	HEAD Q.A.
SCALE:-1:1		QTY:- 1No.		A D R D E AGRA		DRN.	SK SHARMA	PRO.OFFR.			
DIMENSIONS IN mm				GROUP:-HDS		CHD.	JC DUTTA	PD			
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.				TORSION SPRING PLATFORM FASTENING AND RELEASE LOCK (HD SYSTEM FOR AN 32 AIRCRAFT)							
MATERIAL AS ABOVE											
FINISH NORMAL											
HEAT TREATMENT :- NORMALISE											
				DRG. NO. ADRDE/1412-16							



SECTION-X X



INSPECTION:—THE FOLLOWING AS PER IS:8780—1976

- (a) VISUAL EXAMINATION-100%
- (b) PENETRANT FLAW DETECTION-20%
- (c) ULTRA SONIC FLAW DETECTION-10%

MATERIAL:- EN 19 (709 M-40)/HIGH STRENGTH STEEL CASTING(GJ-4)/AS PER IS:1994 OR STEEL ALLOY EN 19(709M-40) AS PER BS:970 OR TYPE ANC-2 OF BS 3146 Pt 2:1961TION BS:970

FINISH:— CADMIUM PLATED TO A MINIMUM THICKNESS 12 MICRON(0.012mm) (STRESS RELIEF BEFORE PLATING HYDROGEN EMBRITTLEMENT)AND CHROME PASSIVATED TO IS:1572—1986, GRADE -3

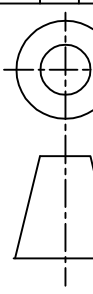
CLASSIFICATION Fe/Cd 12 CA.

WORKMANSHIP:--THE CASTING SHALL BE SOUND,CLEAN AND FREE FROM BLOW HOLES,DISTORTION,HARD SPOTS AND ALL SURFACE OR OTHER

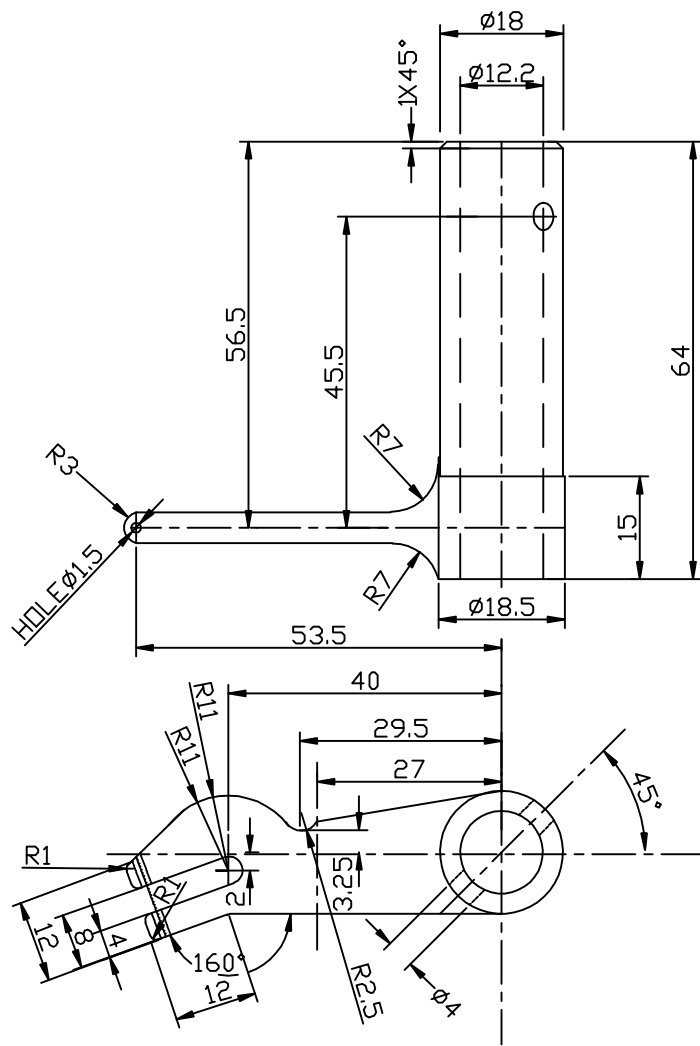
DEFECT THAT ARE LIKELY TO AFFECT THE UTILITY OF THE CASTING. SHARP CORNERS ARE TO BE ROUNDED OFF.

PROCESS:- DIE/ INVESTMENT CASTIN , MACHINING STAGE.

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/c	PGD

SCALE:NTS	QTY:- 1No.	ADRDE ; AGRA	DRN	SK SHARMA	PROJ OFFR
DIMENSIONS ARE IN mm		GROUP:HDS	CHD	JC DUTTA	PD
TOLERANCE:-IS:2012 (PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.		HOUSING PLATFORM FASTENING AND RELEASE LOCK (H D SYSTEM FOR AN 32 AIRCRAFT)			O I/C D&S
MATERIAL PROCESS:AS ABOVE					APPROVED
FINISH:AS ABOVE					HEAD(QA)
HEAT TREATMENT:- 265--352 BHN		DRG.No.			ADRDE/1412-0
					

(H D SYSTEM FOR AN 32 AIRCRAFT)



MATERIAL:- EN 19(709 M-40) EN-24(817 M-40)AS PER SPECIFICATION BS:970

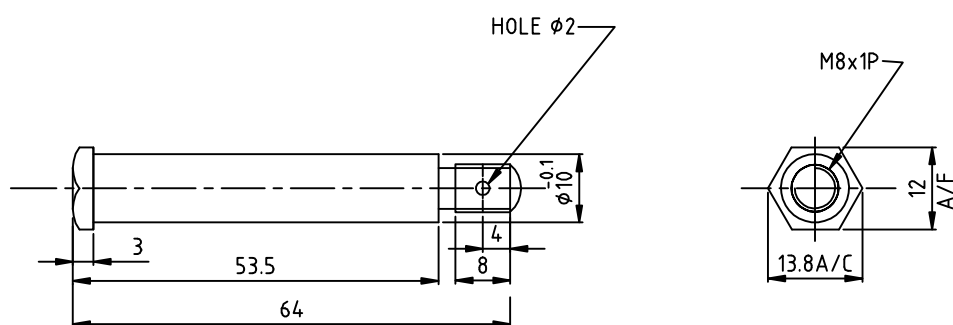
FINISH:- AS PER SHEET No. 2 OF 45

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

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL MARKS AND ANY OTHER MARKS AND ANY OTHER SURFACE DEFECT.

PROCESS: - CASTING & MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			□ I/C D&S	HEAD Q.A.
SCALE:-1:1		QTY:-1No.	A D R D E AGRA		DRN.,	SK SHARMA	PRO.DFFR.	
DIMENSIONS IN mm			GROUP:-HDS		CHD.	JC DUTTA	PD	
TOL:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.			LOCK LEVER PLATFORM FASTENING AND RELEASE LOCK (HD SYSTEM FOR AN 32 AIRCRAFT)					
MATERIAL AS ABOVE								
FINISH:- AS PER SHEET NO 2							APPROVED	
HEAT TREATMENT :- 265-352 BHN							HEAD Q.A.	
			DRG. NO. ADRDE/1412-17					



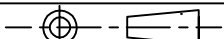
MATERIAL :- EN 19 (709 M-40)/EN24(817 M-40) AS PER SPECIFICATION BS :970

FINISH:- AS PER SHEET No. 2 OF 45

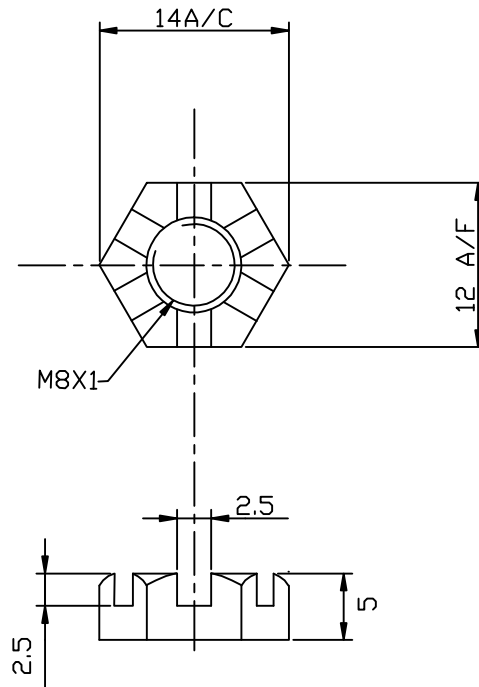
TOLERANCE:- IS:2102 (PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.

WORKMANSHIP:- THE FINISHED COMPONENT SHALL BE FREE FROM CRACK, TOOL MARKS AND ANY OTHER SURFACE DEFECTS.

PROCESS: - MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C D&S	HEAD Q.A.
SCALE : 1:1		QTY:- 1No.	A D R D E AGRA	DRN..	SK SHARMA	PRO.OFFR.		
DIMENSIONS IN mm			GROUP:-HDS	CHD.	JC DUTTA	PD		
TOL:- IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.								
MATERIAL:- AS ABOVE								
FINISH:- AS PER SHEET NO 2 OF 45			HEX-BOLT PLATFORM FASTENING AND RELEASE LOCK (H D SYSTEM FOR AN-32 AIRCRAFT)			O I/C D&S		
HEAT TREATMENT:- 265-352 BHN						APPROVED		
						HEAD Q.A.		
						DRG. NO. ADRDE / 1412 - 18		

21



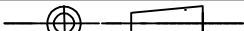
MATERIAL:- STEEL FOR GENERAL STRUCTURAL PURPOSE AS PER IS :2062

FINISH:- AS PER SHEET No. 2 OF 45

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

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL MARKS AND ANY OTHER MARKS AND ANY OTHER SURFACE DEFECT.

PROCESS- MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			□ I/C D&S	HEAD Q.A.
SCALE:-2:1		QTY:- 1No.	A D R D E AGRA	DRN..	SK SHARMA	PRO.OFFR.		
DIMENSIONS IN mm			GROUP:-HDS	CHD.	JC DUTTA	PD		
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.			SLOTTED HEX.NUT PLATFORM FASTENING AND RELEASE LOCK (HD SYSTEM FOR AN 32 AIRCRAFT)			□ I/C D&S		
MATERIAL AS ABOVE						APPROVED		
FINISH:- AS PER SHEET NO.2 OF 45						HEAD Q.A.		
HEAT TREATMENT :- NORMALISE						DRG. NO. ADRDE/1412-19		
								

4	3	2	1
			SHEET 24 OF 45

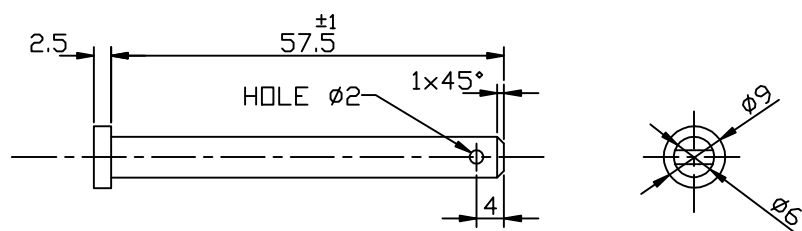
(24)

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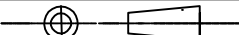
MATERIAL:- EN19<709M-40>/EN-24<817M-40> AS PER SPECIFICATION BS: 970

FINISH:- AS PER SHEET No. 2 OF 45

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

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL MARKS AND ANY OTHER MARKS AND ANY OTHER SURFACE DEFECT.

PROCESS: - MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			□ I/C D&S	HEAD Q.A.
SCALE:- 1:1		QTY:- 1No.		A D R D E AGRA	DRN.	SK SHARMA	PRO.DFFR.	
DIMENSIONS IN mm				GROUP:-HDS	CHD.	JC DUTTA	PD	
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.				ROLLER PLATFORM FASTENING AND RELEASE LOCK (HD SYSTEM FOR AN 32 AIRCRAFT)			□ I/C D&S	
MATERIAL AS ABOVE							APPROVED	
FINISH:- AS PER SHEET NO.2 OF 45							HEAD Q.A.	
HEAT TREATMENT :- NORMALISE							DRG. NO. ADRDE/1412-21	
								

4	3	2	1
			SHEET 25 OF 45

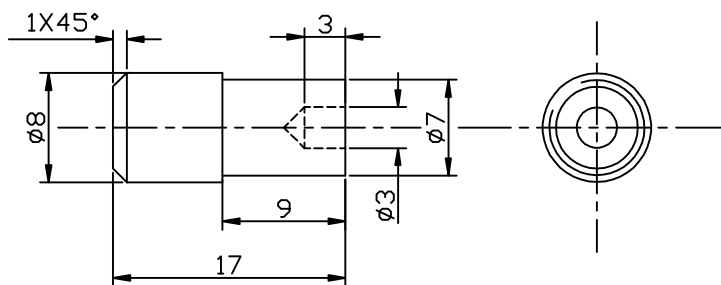
(25)

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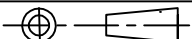
MATERIAL:- EN 19(709 M-40)/EN24(817 M-40) AS PER BIS 1970

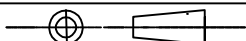
FINISH:- AS PER SHEET No. 2 OF 45

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

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK, TOOL MARKS AND ANY OTHER MARKS AND ANY OTHER SURFACE DEFECT.

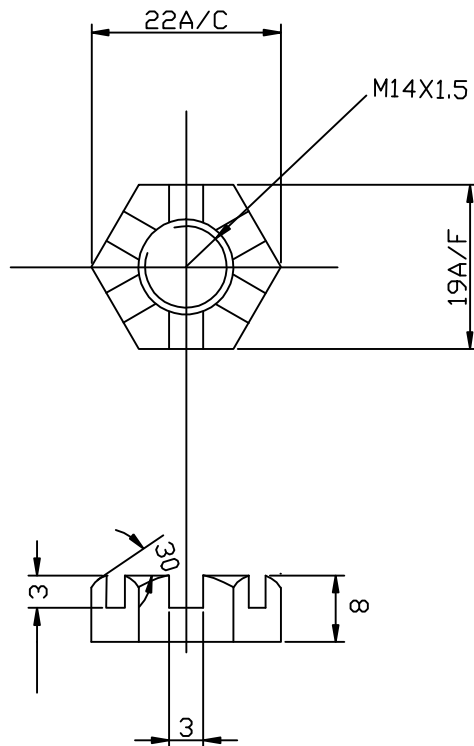
PROCESS:- MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			□ I/C D&S HEAD Q.A.
SCALE:- 2:1		QTY:- 1No.	A D R D E AGRA	DRN.	SK SHARMA	PRO.OFFR.	
DIMENSIONS IN mm			GROUP:-HDS	CHD.	JC DUTTA	PD	
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.			PIN-STOPPER PLATFORM FASTENING AND RELEASE LOCK (HD SYSTEM FOR AN 32 AIRCRAFT)			□ I/C D&S	
MATERIAL AS ABOVE		APPROVED					
FINISH:- AS PER SHEET NO.2 OF 45		HEAD Q.A.					
HEAT TREATMENT :- 265-352 BHN		DRG. NO. ADRDE/1412-22					
							



4	3	2	1
			SHEET 27 OF 45

(27)



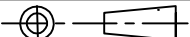
MATERIAL:- STEEL FOR GENERAL STRUCTURAL PURPOSE AS PER IS :2062

FINISH:- AS PER SHEET No. 2 OF 45

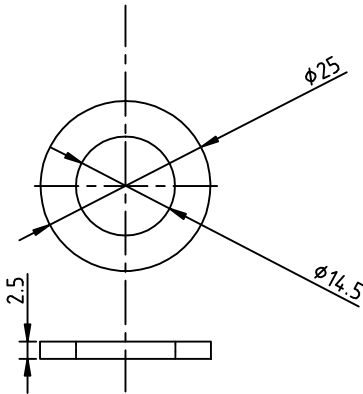
TOLERANCE:- IS:2102 (PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL MARKS AND ANY OTHER MARKS AND ANY OTHER SURFACE DEFECT.

PROCESS:- MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			□ I/C D&S HEAD Q.A.
SCALE:-NTS		QTY:- 1No.	A D R D E AGRA	DRN.,	SK SHARMA	PRO.OFFR.	
DIMENSIONS IN mm			GROUP:-HDS	CHD.	JC DUTTA	PD	
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.							
MATERIAL:- AS ABOVE			SLOTTED HEX.NUT PLATFORM FASTENING AND RELEASE LOCK (HD SYSTEM FOR AN 32 AIRCRAFT)			□ I/C D&S	
FINISH:- AS PER SHEET NO.2 OF 45						APPROVED	
HEAT TREATMENT :- NORMALISE						HEAD Q.A.	
						DRG. NO. ADRDE/1412-24	

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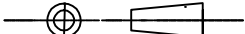
MATERIAL :- STEEL FOR GENERAL STRUCTURAL PURPOSE AS PER IS:2062

FINISH:- AS PER SHEET No. 2 OF 45

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

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL MARKS AND ANY OTHER SURFACE DEFECTS.

PROCESS:- MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C D&S	HEAD Q.A.
SCALE : 1:1		QTY:-1No.	A D R D E AGRA	DRN..	SK SHARMA	PRO.OFFR.		
DIMENSIONS IN mm			GROUP:-HDS	CHD.	JC DUTTA	PD		
TOLERANCE:- IS:2012 (PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.			WASHER PLATFORM FASTENING AND RELEASE LOCK (H D SYSTEM FOR AN-32 AIRCRAFT)					
MATERIAL:- AS ABOVE								
FINISH: - AS PER SHEET NO 2 OF 45						O I/C D&S		
HEAT TREATMENT:- NORMAL						APPROVED		
						HEAD Q.A.		
						DRG. NO. ADRDE/1412-25		

4	3	2	1
			SHEET 29 OF 45

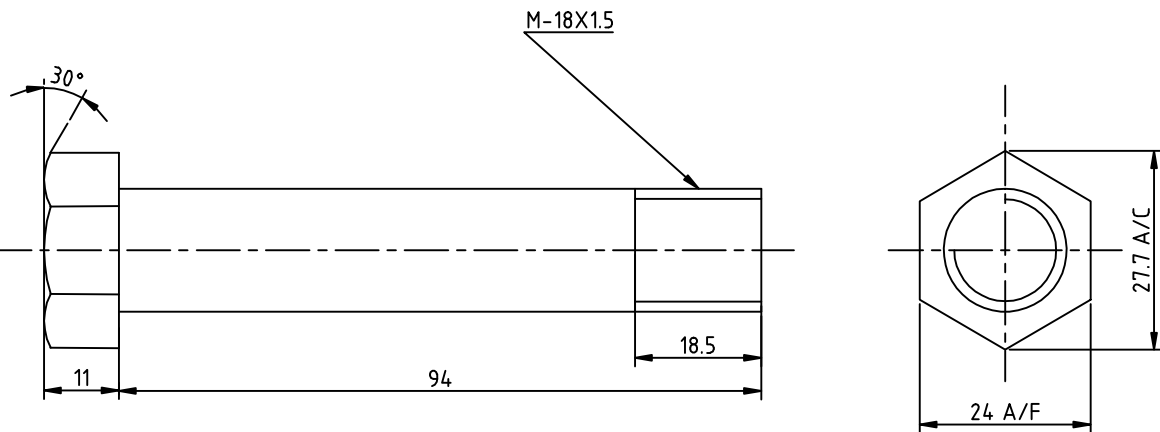
30

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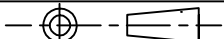
MATERIAL :- EN 19 (709 M-40)/EN24(817 M-40) AS PER SPECIFICATION BS :970

FINISH:- AS PER SHEET No. 2 OF 45

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

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL MARKS AND ANY OTHER SURFACE DEFECTS.

PROCESS:- MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C D&S	HEAD Q.A.
SCALE : 1:1		QTY:- 1No.	A D R D E AGRA	DRN..	SK SHARMA	PRO.OFFR.		
DIMENSIONS IN mm			GROUP:-HDS	CHD.	JC DUTTA	PD		
TOLERANCE:- IS:2012 (PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.			HEX-BOLT M 18X94 PLATFORM FASTENING AND RELEASE LOCK (H D SYSTEM FOR AN-32 AIRCRAFT)			O I/C D&S		
MATERIAL:- AS ABOVE						APPROVED		
FINISH: - AS PER SHEET NO 2 OF 45						HEAD Q.A.		
HEAT TREATMENT:- 265-352 BHN						DRG. NO.		
						ADRDE/1412-26		

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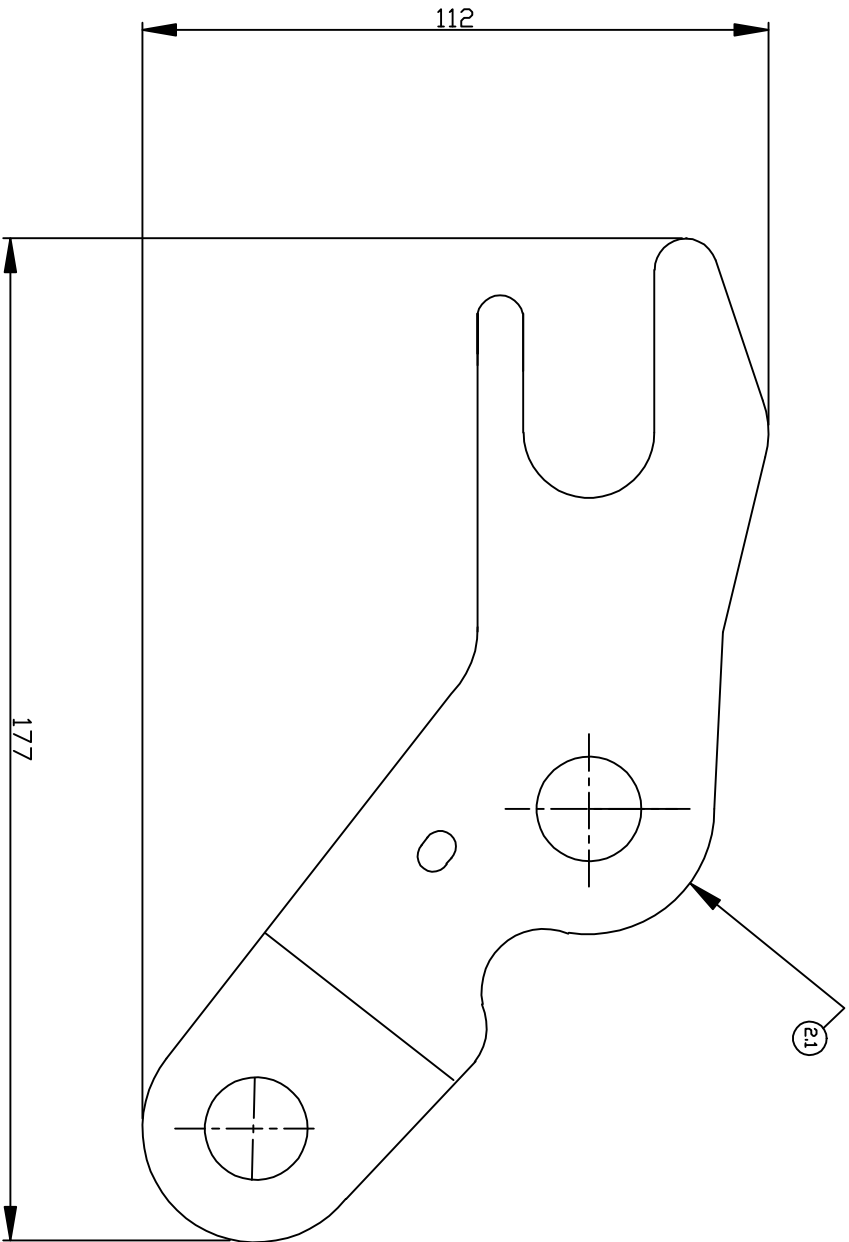
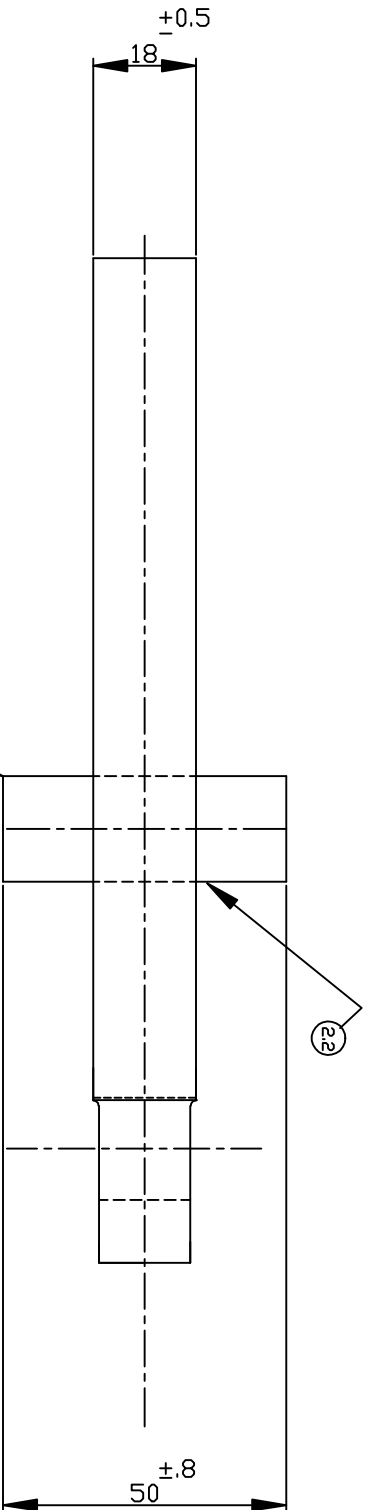
4

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SHEET 3 OF 45



2.2	SHAFT	1412-02-02	1	5
2.1	LEVER	1412-02-01	1	4
	SUB-ASSEMBLY		1	3
DETAIL No.	NOMENCLATURE	DRG No.	QTY.	SHEET No.

DETAIL INDEX

MATERIAL:- EN 19(709-40) / EN 24(817 M-40) AS PER SPECIFICATION BS:970.

FINISH:- HARD CHROMIUM PLATED TO A MINIMUM THICKNESS 12 MICRON(0.012mm)

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

WORKMANSHIP:- THE FINISHED COMPONENT SHALL BE FREE FROM PITS,CRACKS,TOOL MARKS AND ANY OTHER SURFACE DEFECTS

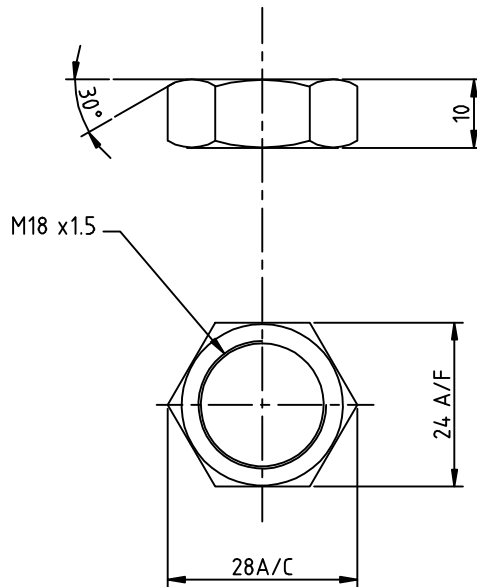
PROCESS:- FORGING & MACHINING.

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/C	PGD

SCALE:-1:1	QTY:-1 No.	ADDRDE ; AGRA	DRN	SK SHARMA	PROJ OFFR
DIMENSIONS ARE IN mm	GROUP:HDS	CHD	JC DUTTA	PD	
TOLERANCE: AS ABOVE					O I/C D&S
MATERIAL :- AS ABOVE					APPROVED
FINISH: AS ABOVE					HEAD(QA)
HEAT TREATMENT:- 265-352 BHN(32±5 RHC)					DRG.No.
(H D SYSTEM FOR AN 32 AIRCRAFT)					ADDRDE/1412-02

4	3	2	1
SHEET 30 OF 45			

31



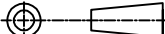
MATERIAL :- EN 19 (709 M-40)/EN24(817 M-40) AS PER SPECIFICATION BS :970

FINISH:- AS PER SHEET No. 2 OF 45

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

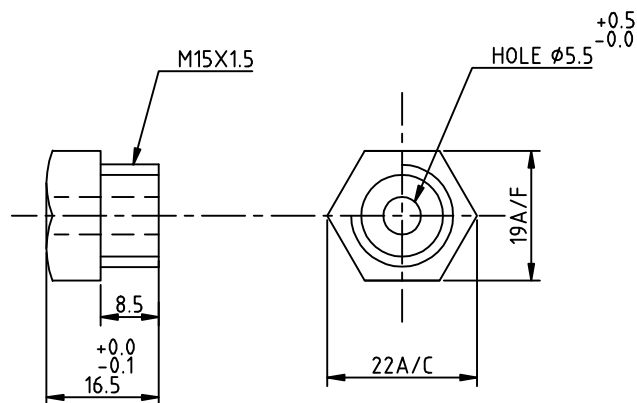
WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL MARKS AND ANY OTHER SURFACE DEFECTS.

PROCESS:- MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD		O I/C D&S	HEAD Q.A.
SCALE: 1:1		QTY:- 3NoS.		A D R D E AGRA	DRN..	SK SHARMA	PRO.OFFR.
DIMENSIONS IN mm				GROUP:-HDS	CHD.	JC DUTTA	PD
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.				NUT M-18 PLATFORM FASTENING AND RELEASE LOCK (H D SYSTEM FOR AN-32 AIRCRAFT)			
MATERIAL:- AS ABOVE							
FINISH:- AS PER SHEET NO.2 OF 45							
HEAT TREATMENT;- 265-352 BHN							
				APPROVED HEAD Q.A.			
				DRG. NO. ADRDE/1412-27			

4	3	2	1
			SHEET 31 OF 45

33



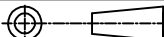
MATERIAL :- EN 19 (709 M-40)/EN24(817 M-40) AS PER SPECIFICATION BS :970

FINISH:- AS PER SHEET No. 2 OF 45

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

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL MARKS AND ANY OTHER SURFACE DEFECTS.

PROCESS:- MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C D&S	HEAD Q.A.
SCALE : 1:1		QTY:- 2NoS.	A D R D E AGRA	DRN..	SK SHARMA	PRO.OFFR.		
DIMENSIONS IN mm			GROUP:-HDS	CHD.	JC DUTTA	PD		
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.			BUSHING PLATFORM FASTENING AND RELEASE LOCK (H D SYSTEM FOR AN-32 AIRCRAFT)			O I/C D&S		
MATERIAL:- AS ABOVE						APPROVED		
FINISH:- AS PER SHEET NO.2 OF 45						HEAD Q.A.		
HEAT TREATMENT:- 265-352 BHN						DRG. NO. ADRDE/1412-28		
								

4	3	2	1
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SHEET 32 OF 45

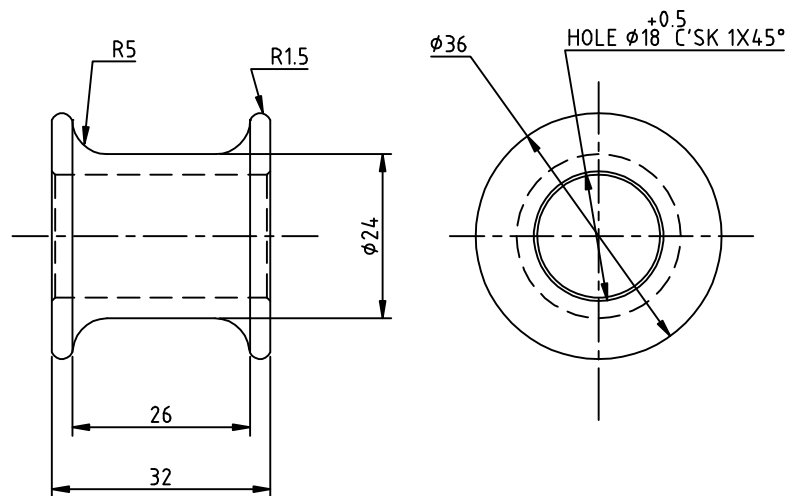
34

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MATERIAL :- ALUMINIUM ALLOY GRADE 64430(HE-30)/24345(HE-15) IS : 733 : 1983 W.P

FINISH:- NATURAL

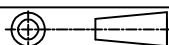
TOLERANCE:- IS:2102 (PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.

WORKMANSHIP:- THE FINISHED COMPONENT SHALL BE FREE FROM CRACK, TOOL MARKS AND ANY OTHER SURFACE DEFECTS.

PROCESS:- MACHINING

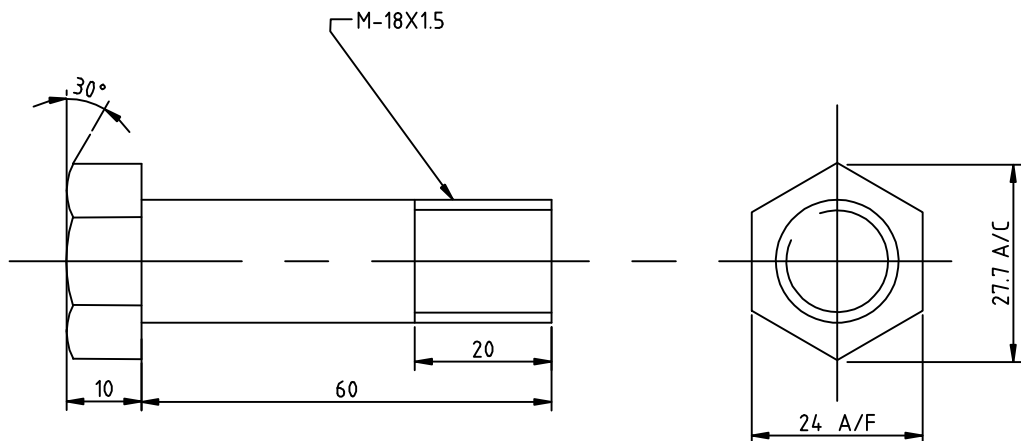
R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O I/C D&S	HEAD Q.A.
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SCALE :1:1	QTY:-1 No.	ADRDE AGRA	DRN..	SK SHARMA	PRO.OFFR.	
DIMENSIONS IN mm		GROUP:-HDS	CHD.	JC DUTTA	PD	
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.		PULLEY PLATFORM FASTENING AND RELEASE LOCK (H D SYSTEM FOR AN-32 AIRCRAFT)			O I/C D&S	
MATERIAL:- AS ABOVE					APPROVED	
FINISH:- NATURAL					HEAD Q.A.	
HEAT TREATMENT:- WP					DRG. NO. ADRDE/1412-29	



(35)

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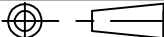
MATERIAL :- EN 19 (709 M-40)/EN24(817 M-40) AS PER SPECIFICATION BS :970

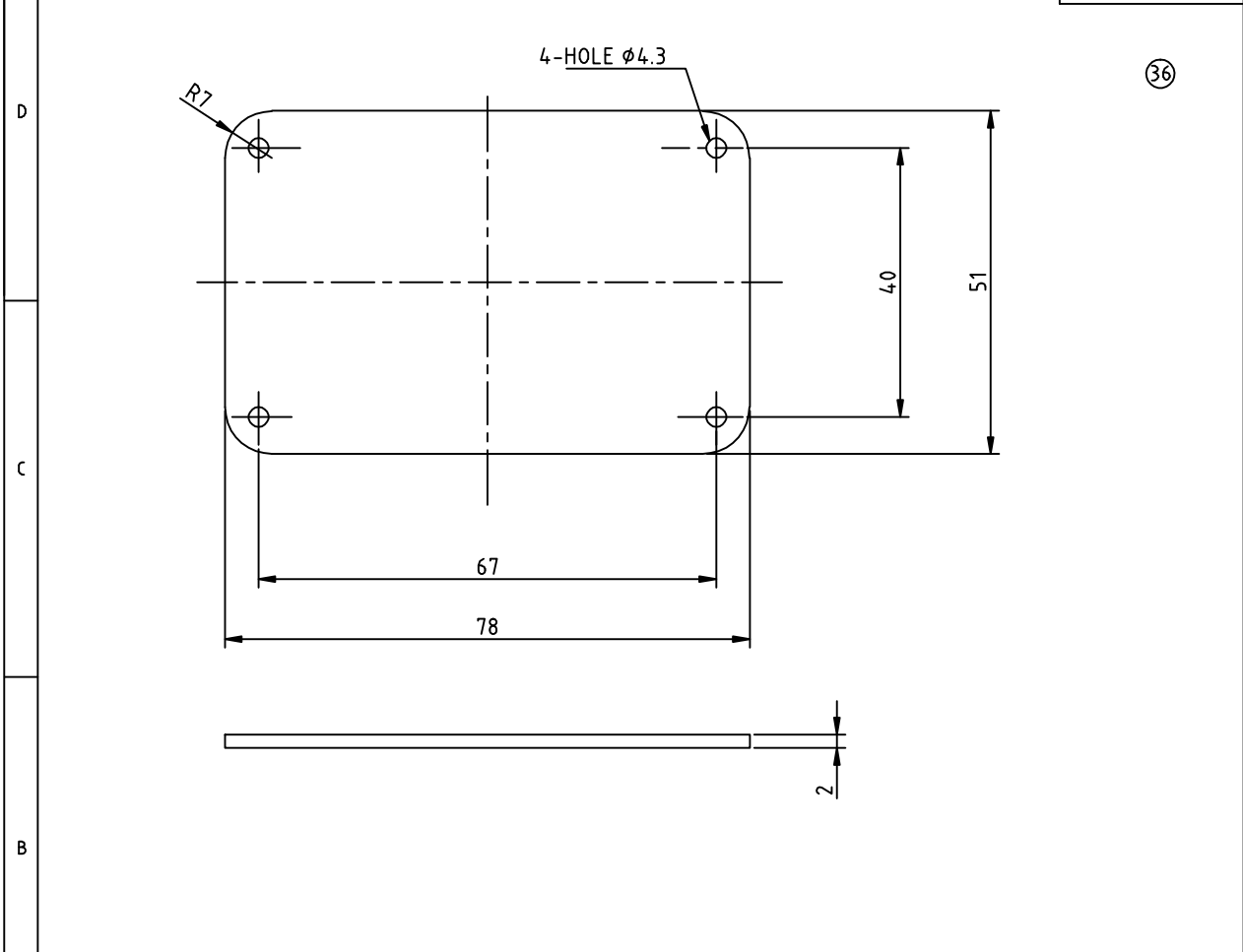
FINISH:- AS PER SHEET No. 2 OF 45

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

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL MARKS AND ANY OTHER SURFACE DEFECTS.

PROCESS:- MACHINING/FABRICATION

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C D&S	HEAD Q.A.	
SCALE : 1:1		QTY:-2 No.S		A D R D E AGRA		DRN..	SK SHARMA	PRO.OFFR.	
DIMENSIONS IN mm				GROUP:-HDS		CHD.	JC DUTTA		
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.								PD	
MATERIAL:- AS ABOVE				HEX-BOLT M 18 X 60 PLATFORM FASTENING AND RELEASE LOCK (H D SYSTEM FOR AN-32 AIRCRAFT)		O I/C D&S			
FINISH:- AS PER SHEET NO 2 OF 45									
HEAT TREATMENT:-265-352 BHN						APPROVED			HEAD Q.A.
						DRG. NO.			ADRDE/1412-30



D

MATERIAL:- STEEL FOR GENERAL STRUCTURAL PURPOSE IS:2062

FINISH:- AS PER SHEET No. 2 OF 45

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

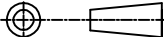
WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL MARKS AND ANY OTHER SURFACE DEFECTS.

PROCESS:- MACHINING

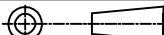
C

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R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C D&S	HEAD Q.A.
SCALE : 1:1		QTY:--1 No.	A D R D E AGRA	DRN..	SK SHARMA	PRO.OFFR.		
DIMENSIONS IN mm			GROUP:--HDS	CHD.	JC DUTTA	PD		
TOLERANCE:--IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.			COVER PLATE PLATFORM FASTENING AND RELEASE LOCK (H D SYSTEM FOR AN-32 AIRCRAFT)			O I/C D&S		
MATERIAL:-- AS ABOVE						APPROVED		
FINISH:-- AS PER SHEET NO 2 OF 45						HEAD Q.A.		
HEAT TREATMENT:-- NORMAL CONDITION						DRG. NO.		
						ADRDE/1412-31		

PROCESS:- MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C D&S	HEAD Q.A.
SCALE : 1:1		QTY:-2 NoS.	A D R D E AGRA	DRN..	SK SHARMA	PRO.OFFR.		
DIMENSIONS IN mm			GROUP:-HDS	CHD.	JC DUTTA	PD		
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.			SIDE PLATE PLATFORM FASTENING AND RELEASE LOCK (H D SYSTEM FOR AN-32 AIRCRAFT)			O I/C D&S		
MATERIAL:- AS ABOVE						APPROVED		
FINISH:- AS PER SHEET NO.2 OF 45						HEAD Q.A.		
HEAT TREATMENT:- 265-352 BHN						DRG. NO. ADRDE/1412-32		
								

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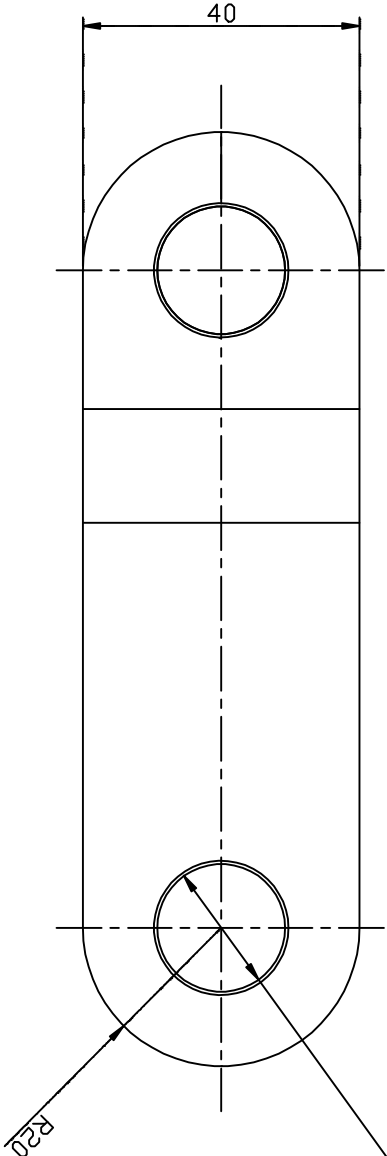
2

1

SHEET 36 DF 45

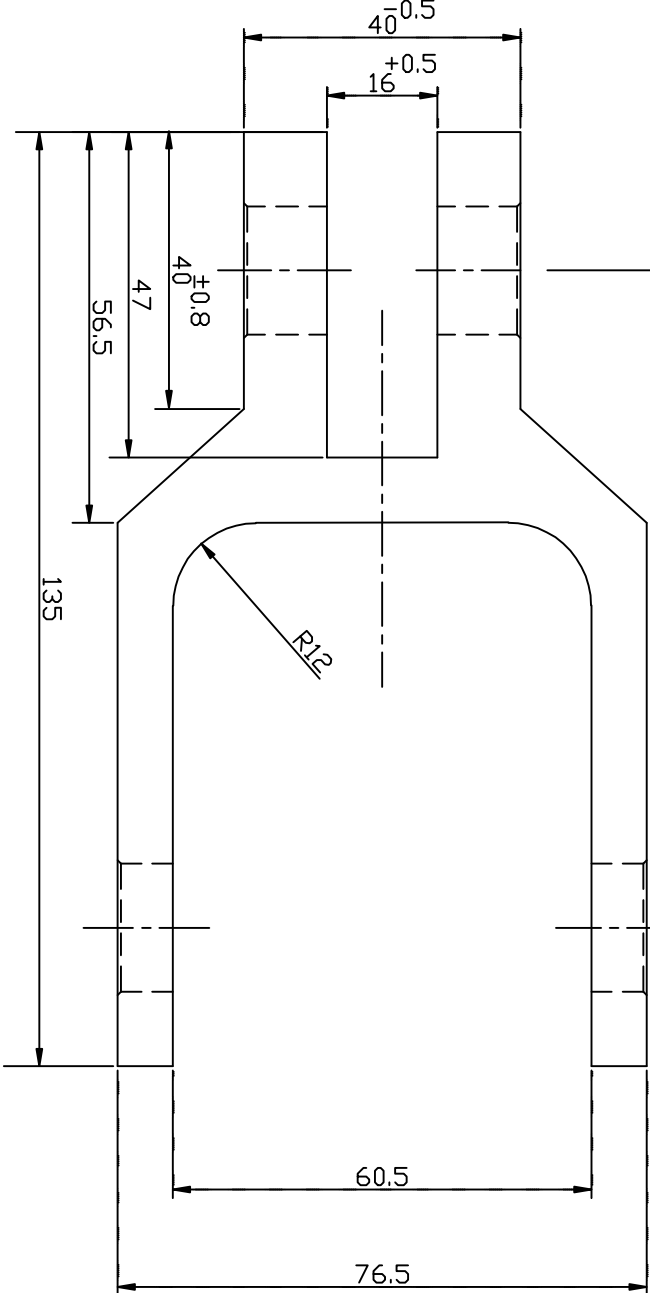
40

4-HOLE $\phi 18.5^{+0.5}_{-0.5}$ C/SK 1X45°



95

$40^{+0.5}_{-0.5}$
 $16^{+0.5}_{-0.5}$



60.5

76.5

$40^{+0.8}_{-0.8}$

47

56.5

135

R12

R20

MATERIAL :- EN-19(709M-40) /EN-24(817M-40) AS PER SPECIFICATION BS970
FINISH:- AS PER SHEET NO. 2 DF 45
TOLERANCE:- IS:2102 (PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.
WORKMAN SHIP :- THE FINISH COMPONENT SHALL BE FREE FROM PITS, CRACK,
TOOL MARKS AND ANY OTHER SURFACE DEFECTS
PROCESS :- FORGING & MACHINING

SCALE 1:1	QTY:- 1 No.	A D R D E AGRA	DRN.	S K SHARMA	PROOFFR.
DIMENSIONS IN mm	GROUP:-HDS	CHD.	JC DUTTA		PD
TOLERANCE:- IS:2012 (PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.					
MATERIAL:-AS ABOVE					

FINISH:-AS PER SHEET NO 2 DF 45

LINK

D I/C D&S

HEAT TREATMENT:-

265-352 BHN (H D SYSTEM FOR AN-32 AIRCRAFT)

PLATFORM FASTENING AND RELEASE LOCK

APPROVED

HEAD Q.A.

DRG. NO. ADRDE/1412-33

RND.

DATE

ZONE

AUTHORITY

BRIEF RECORD

D I/C D&S

HEAD Q.A.

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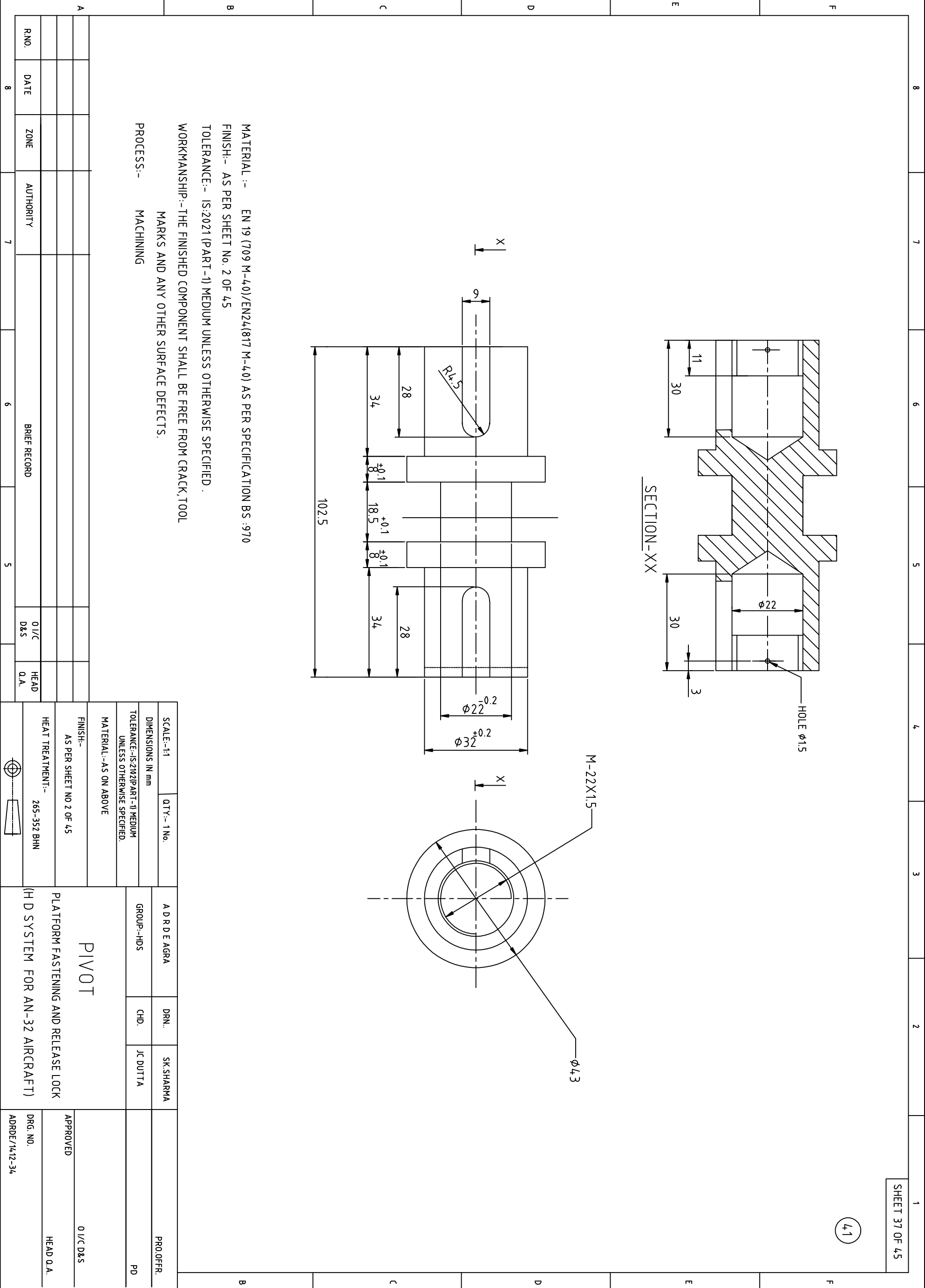
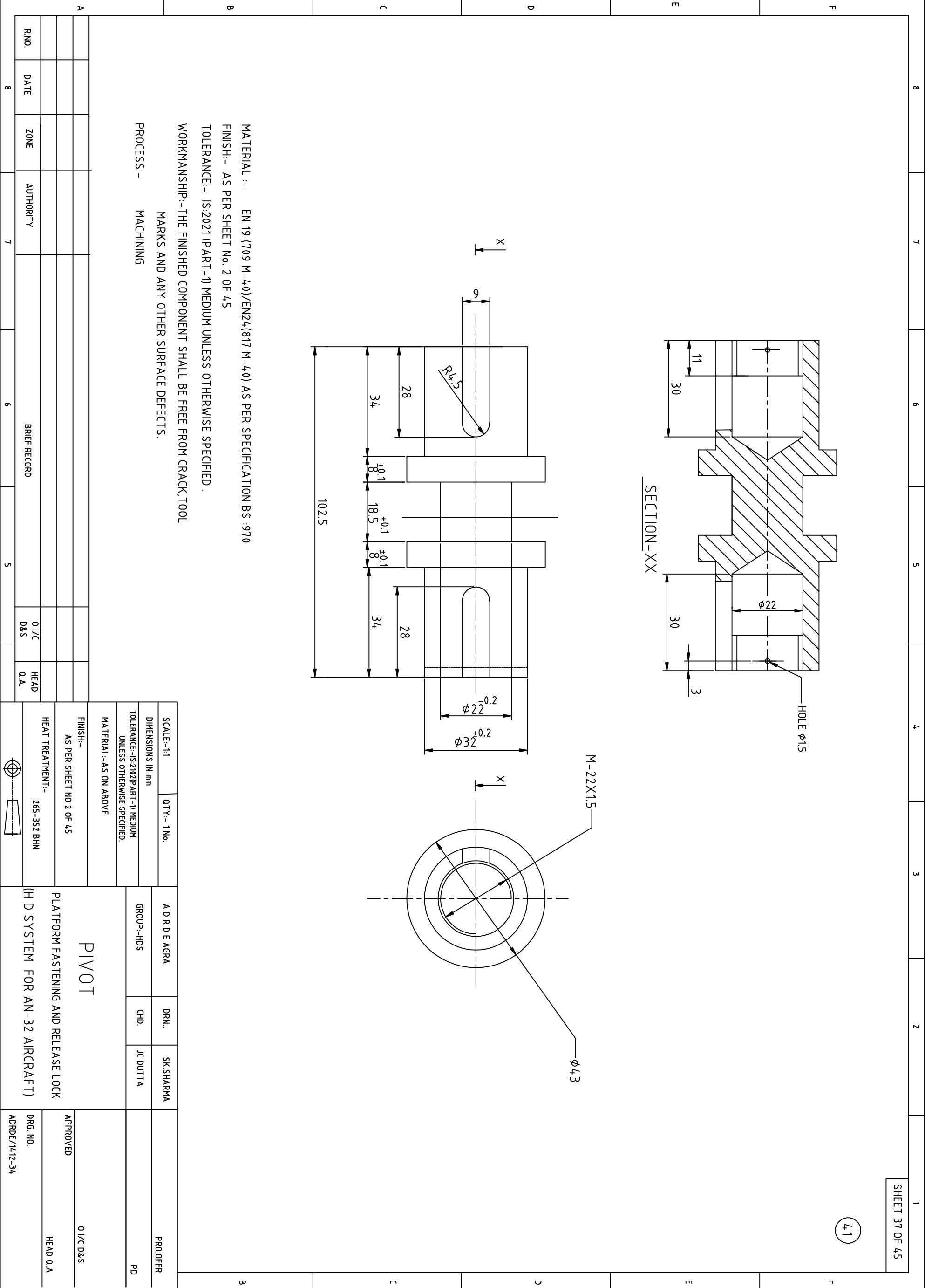
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[illegible]

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SHEET 38 OF 45

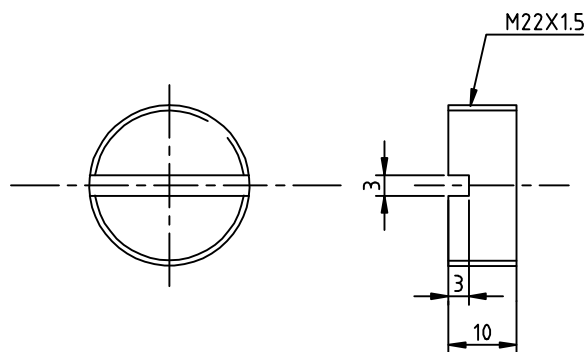
42

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MATERIAL :- STEEL FOR GENERAL STRUCTURAL PURPOSE IS:2062

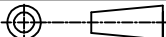
FINISH:- AS PER SHEET No. 2 OF 45

TOLERANCE:- IS:2021 (PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.

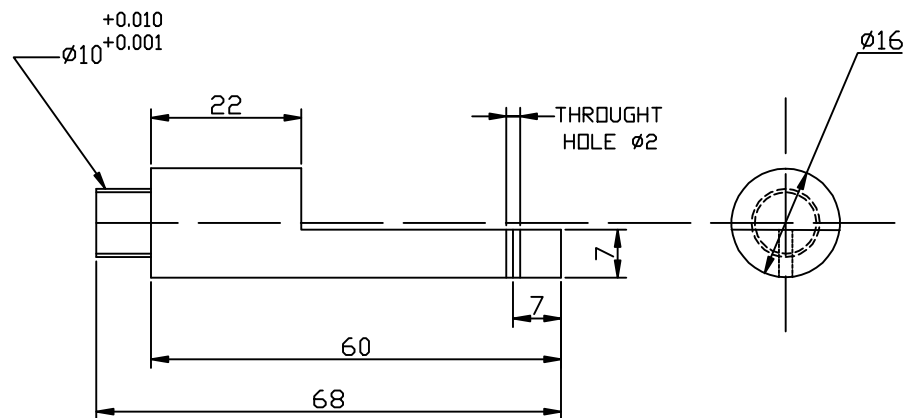
WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL

MARKS AND ANY OTHER SURFACE DEFECTS.

PROCESS:- MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C D&S	HEAD Q.A.		
SCALE :1:1		QTY:- 2 NoS.		A D R D E AGRA		DRN..	SK SHARMA	PRO.OFFR.		
DIMENSIONS IN mm				GROUP:-HDS		CHD.	JC DUTTA	PD		
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.				PLUG PLATFORM FASTENING AND RELEASE LOCK (H D SYSTEM FOR AN-32 AIRCRAFT)						
MATERIAL:- AS ABOVE										
FINISH:- AS PER SHEET NO.2 OF 45										
HEAT TREATMENT:- NORMAL CONDITION			O I/C D&S							
			APPROVED							
			HEAD Q.A.							
			DRG. NO. ADRDE/1412-35							

43



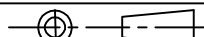
MATERIAL:- 709-M40(EN19)/817M-40(EN24) AS PER SPECIFICATION BS:970

FINISH:- AS PER SHEET No. 2 OF 45

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

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL MARKS AND ANY OTHER MARKS AND ANY OTHER SURFACE DEFECT.

PROCESS: - MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			□ I/C D&S	HEAD Q.A.
SCALE:-1:1		QTY:-1 No.		A D R D E AGRA	DRN..	SK SHARMA	PRO.OFFR.	
DIMENSIONS IN mm				GROUP:-HDS		CHD.	JC DUTTA	PD
TOLERANCE:-IS:2012 (PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.				STOPPER PLATFORM FASTENING AND RELEASE LOCK (HD SYSTEM FOR AN 32 AIRCRAFT)				
MATERIAL AS ABOVE								□ I/C D&S
FINISH:- AS PER SHEET NO 2 OF 45								APPROVED
HEAT TREATMENT :- 265-352 BHN.								HEAD Q.A.
				DRG. NO. ADRDE/1412-36				

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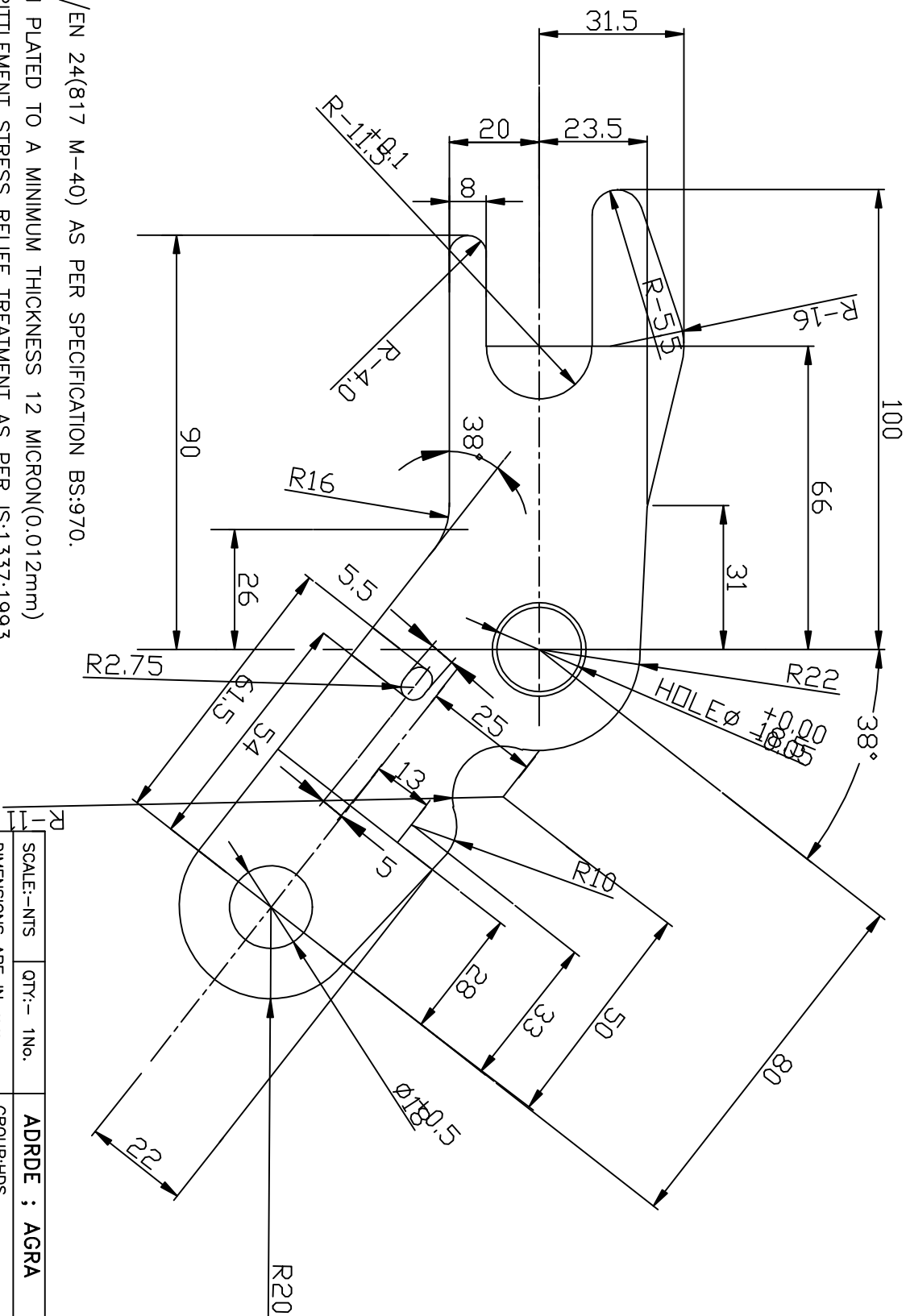
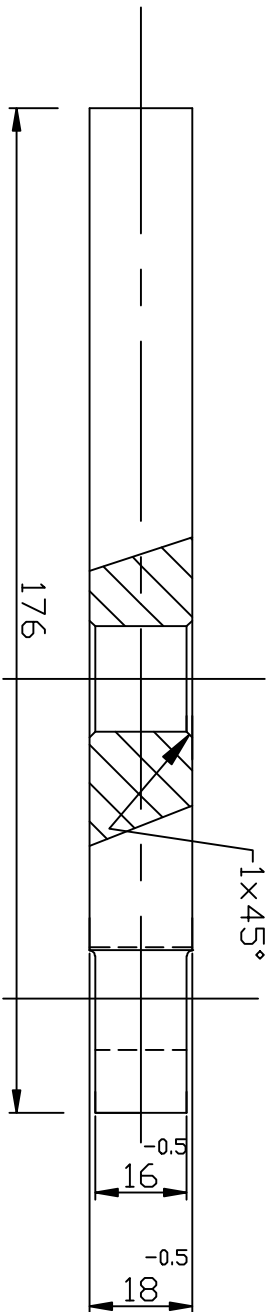
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SHEET 4 OF 45



MATERIAL:- EN 19(709-40)/EN 24(817 M-40) AS PER SPECIFICATION BS:970.

FINISH:- HARD CHROMIUM PLATED TO A MINIMUM THICKNESS 12 MICRON(0.012mm)

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

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM PITS,CRACKS,TOOL MARKS AND ANY OTHER SURFACE DEFECTS

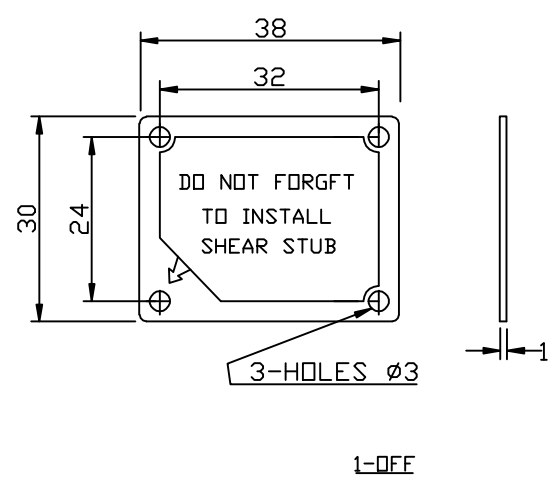
PROCESS:- FORGING & MACHINING.

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/C	PGD

SCALE:- NTS	QTY:- 1No.	ADDRDE ; AGRA	DRN	SK SHARMA	PROJ OFFR
DIMENSIONS ARE IN mm		GROUP:HDS	CHD	JC DUTTA	PD
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.		LEVER			O I/C D&S
MATERIAL:-AS ABOVE		PLATFORM FASTENING			APPROVED
FINISH:- AS ABOVE		AND RELEASE LOCK			HEAD(OA)
HEAT TREATMENT:- 265-352 BHN(32 $\pm$ 5 RHC)		(H D SYSTEM FOR AN 32 AIRCRAFT)			DRG.No.
					ADDRDE/1412-02-01

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MATERIAL:- ALUMINIUM SHEET

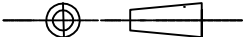
FINISH:- AS PER SHEET No. 2 OF 45

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

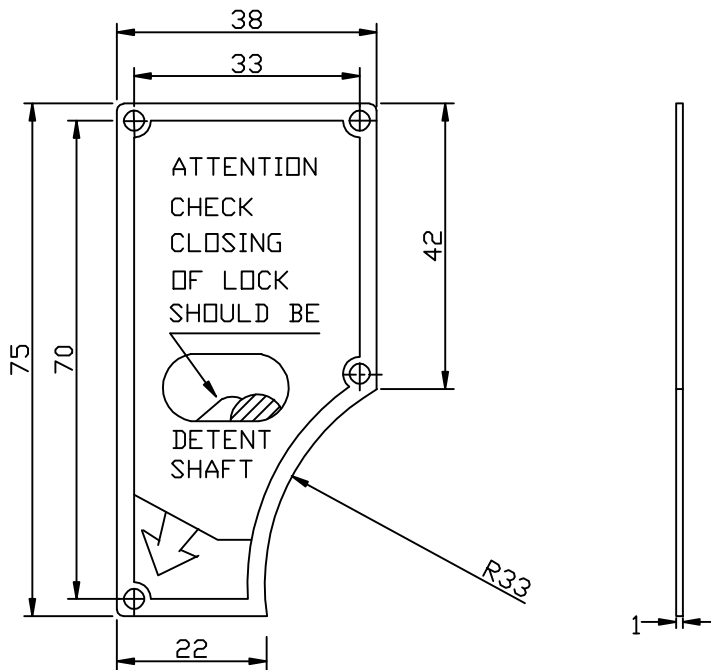
WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL MARKS AND ANY OTHER MARKS AND ANY OTHER SURFACE DEFECT.

PROCESS:- FABRICATION

NOTE:-INSTRUCTION WRITTING MAY BE GIVEN BY PHOTO ETCHING/ANODISED PROCESS ON PLATE.
(WHILE WRITTING ON BLACK BACKGROUND)

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			□ I/C D&S HEAD Q.A.
SCALE:-1:1		QTY:-1 No.	A D R D E AGRA	DRN..	SK SHARMA	PRO.0FFR.	
DIMENSIONS IN mm			GROUP:-HDS	CHD.	JC DUTTA	PD	
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.			INSTRUCTION-PLATE. I PLATFORM FASTENING AND RELEASE LOCK (HD SYSTEM FOR AN 32 AIRCRAFT)			□ I/C D&S	
MATERIAL AS ABOVE						APPROVED	
FINISH NATURAL						HEAD Q.A.	
HEAT TREATMENT :- _____						DRG. NO.	
						ADRDE/1412-37	

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MATERIAL:- ALUMINIUM SHEET

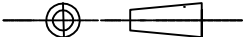
FINISH:- AS PER SHEET No. 2 OF 45

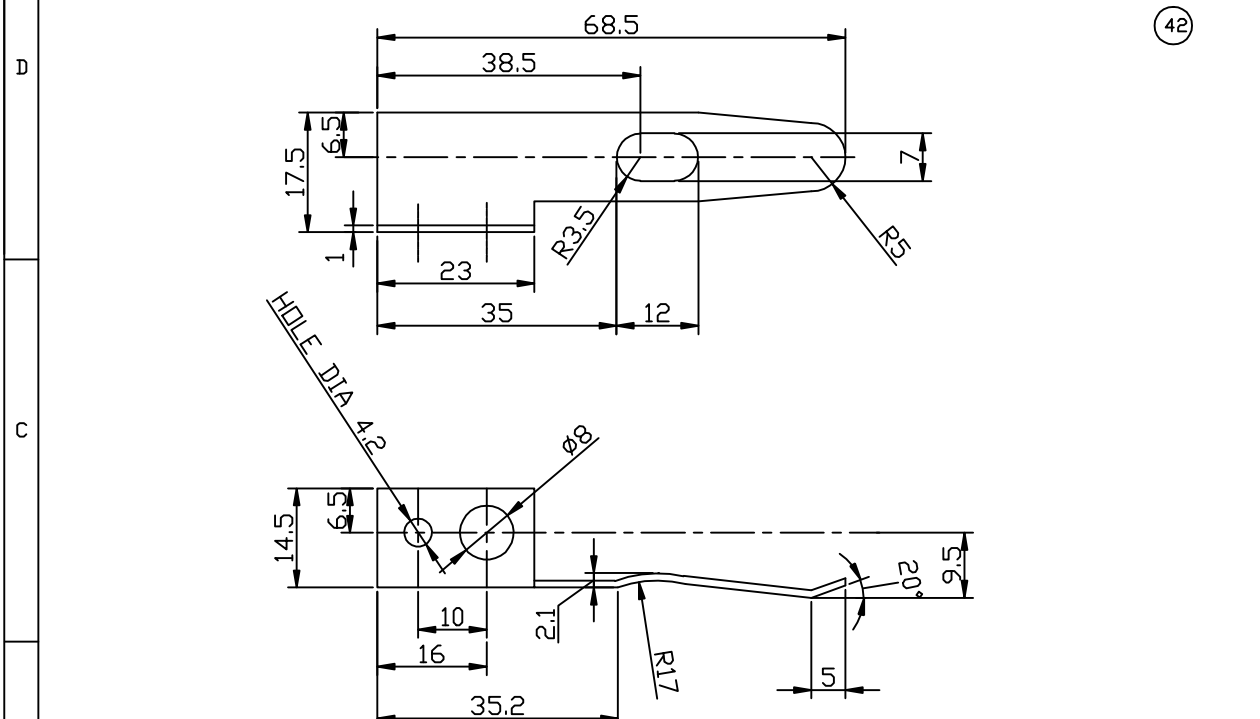
TOLERANCE:- IS:2102 (PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL MARKS AND ANY OTHER MARKS AND ANY OTHER SURFACE DEFECT.

PROCESS:- MACHINING

NOTE:-INSTRUCTION WRITTING MAY BE GIVEN BY PHOTO ETCHING/ANODISED PROCESS ON PLATE.
(WHILE WRITTING ON BLACK BACKGROUND)

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			□ I/C D&S	HEAD Q.A.
SCALE:-1:1		QTY:-1No.	A D R D E AGRA	DRN.	SK SHARMA	PRO.QFFR.		
DIMENSIONS IN mm			GROUP:-HDS	CHD.	JC DUTTA	PD		
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.			INSTRUCTION-PLATE. II PLATFORM FASTENING AND RELEASE LOCK (HD SYSTEM FOR AN 32 AIRCRAFT)			□ I/C D&S		
MATERIAL AS ABOVE		APPROVED						
FINISH:- NATURAL		HEAD Q.A.						
HEAT TREATMENT :- _____		DRG. NO. ADRDE/1412-38						
								



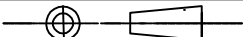
MATERIAL:- ICOLD-ROLLED STEEL STRIP FOR SPING IS:2507-1975 65 C-6

FINISH:- AS PER SHEET No. 2 OF 45

TOLERANCE:- IS:2012 (PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL MARKS AND ANY OTHER MARKS AND ANY OTHER SURFACE DEFECT.

PROCESS:- FABRICATION

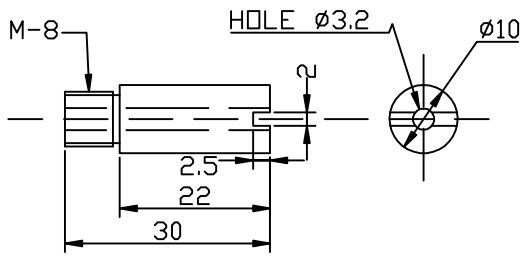
R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			□ I/C D&S	HEAD Q.A.
SCALE:-1:1		QTY:-1No.	A D R D E AGRA	DRN.,	SK SHARMA	PRD.OFFR.		
DIMENSIONS IN mm			GROUP:-HDS	CHD.	JC DUTTA	PD		
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.			SPRING-LEAF PLATFORM FASTENING AND RELEASE LOCK (HD SYSTEM FOR AN 32 AIRCRAFT)			□ I/C D&S		
MATERIAL AS ABOVE								
FINISH AS PER SHEET No.2						APPROVED		
HEAT TREATMENT :- _____						HEAD Q.A.		
			DRG. NO. ADRDE/1412-39					

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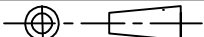
MATERIAL:- EN19(709M-40)/EN-24(817M-40) AS PER SPECIFICATION BS: 970

FINISH:- AS PER SHEET No. 2 OF 45

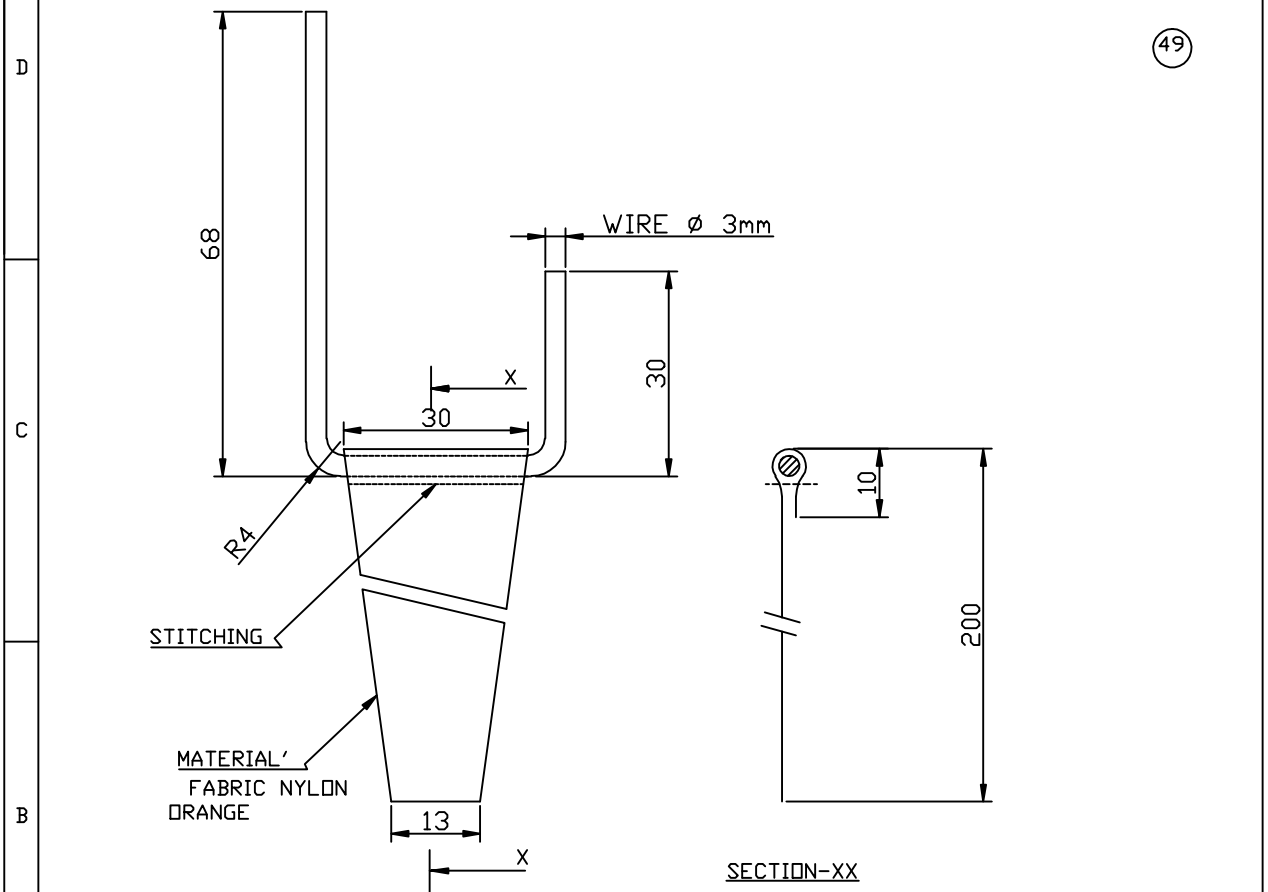
TOLERANCE:- IS:2102 (PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL MARKS AND ANY OTHER MARKS AND ANY OTHER SURFACE DEFECT.

PROCESS: - MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			□ I/C D&S HEAD Q.A.
SCALE:-1:1		QTY:- 1No.	A D R D E AGRA	DRN.	SK SHARMA	PRO.DFFR.	
DIMENSIONS IN mm			GROUP:-HDS	CHD.	JC DUTTA	PD	
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.			BUSHING PLATFORM FASTENING AND RELEASE LOCK (HD SYSTEM FOR AN 32 AIRCRAFT)			□ I/C D&S	
MATERIAL:-AS ABOVE						APPROVED	
FINISH:- AS PER SHEET NO.2 OF 45						HEAD Q.A.	
HEAT TREATMENT :- NORMALISE						DRG. NO.	
						ADRDE/1412-40	

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			SHEET 44 DF45



MATERIAL:- STAINLESS STEEL SPRING WIRE IS:4454-1975(Pt-1)

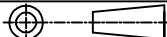
HARDNESS:- 265 - 352 BHN

FINISH:- NORMAL

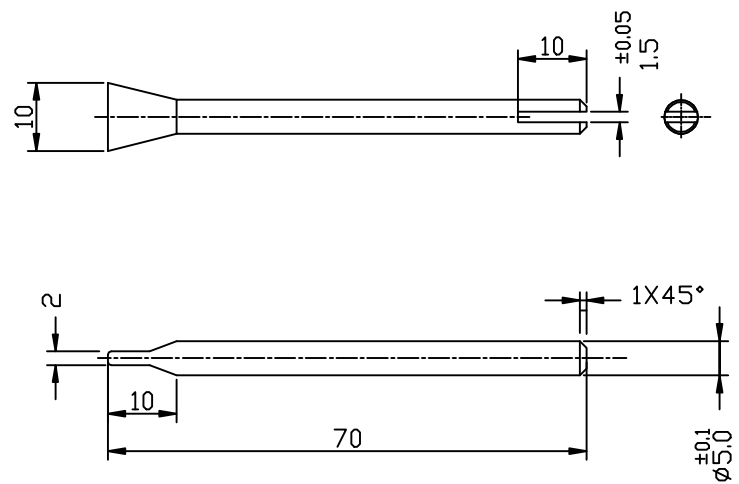
TOLERANCE:- IS:2102 (PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOLMARKS AND ANY OTHER SURFACE DEFECT.

PROCESS:- FABRICATION.

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			□ I/C D&S	HEAD Q.A.
SCALE 1:1		QTY:-1 No.	A D R D E AGRA		DRN.,	SK SHARMA	PRO.OFFR.	
DIMENSIONS IN mm			GROUP		CHD.	JC DUTTA	PD	
TOLERANCE:-IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED			PIN-RED FLAG PLATFORM FASTENING AND RELEASE LOCK HD SYSTEM FOR AN 32 AIRCRAFT				□ I/C D&S	
MATERIAL AS ABOVE							APPROVED	
FINISH:- NORMAL							HEAD Q.A.	
HEAT TREATMENT:- 265-352 BHN							DRG. NO. ADRDE/1412-41	
								

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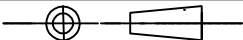


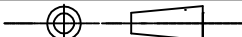
MATERIAL:- ALUMINIUM ALLOY HE 30 (GRADE 64430) W/WP CONDITION AS PER IS:733

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL MARKS AND ANY OTHER MARKS AND ANY OTHER SURFACE DEFECT.

PROCESS: - MACHINING

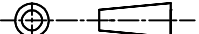
TESTING:- IT SHOULD BE SHEAR-OFF IN ASSEMBLED CONDITION WITH (PFRL) LOCK AT 300 Kg±30

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			□ I/C D&S HEAD Q.A.
SCALE:-1:1		QTY:-1No.	A D R D E AGRA	DRN..	SK SHARMA	PRO.OFFR.	
DIMENSIONS IN mm			GROUP:HDS	CHD.	JC DUTTA	PD	
TOL:-IS:2012 (PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.			SHEAR PIN PLATFORM FASTENING AND RELEASE LOCK (HD SYSTEM FOR AN 32 AIRCRAFT)				
MATERIAL AS ABOVE							
FINISH NATURAL						□ I/C D&S	
HEAT TREATMENT :-NORMALISE						APPROVED HEAD Q.A.	
						DRG. NO. ADRDE/1412-42	

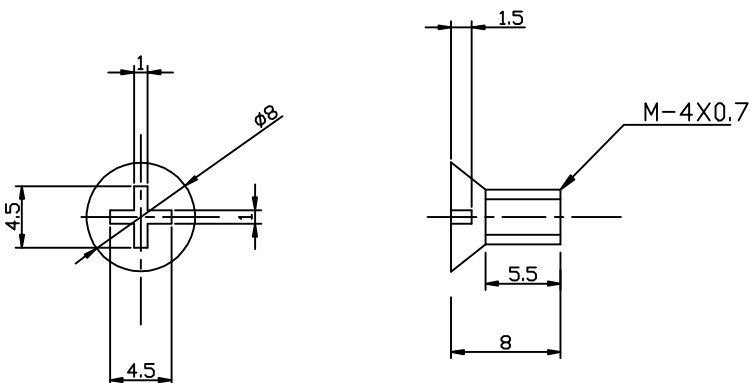
R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD				□ I/C D&S	HEAD Q.A.
SCALE 1:1		QTY:-1No.	A D R D E AGRA	DRN.,	SK SHARMA	PRO.OFFR.			
DIMENSIONS IN mm			GROUP	CHD.	JC DUTTA	PD			
TOL. AS ABOVE			SHAFT PLATFORM FASTENING AND RELEASE LOCK HD SYSTEM FOR AN 32 AIRCRAFT			□ I/C D&S APPROVED HEAD Q.A. DRG. NO. ADRDE/1412-02-02			
MATERIAL AS ABOVE									
FINISH AS ABOVE									
HEAT TREATMENT:- 265-352 BHN(32±5 RHC)									
									



A	PROCESS:-	MACHINING.
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R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD				□ I/C D&S	HEAD Q.A.
SCALE 1:1		QTY:- 1No.	A D R D E AGRA	DRN..	SK SHARMA	PRO.OFFR.			
DIMENSIONS IN mm			GROUP:- HDS	CHD.	JC DUTTA	PD			
TOL:-IS:2102 (PART-1)MEDIUM UNLESS OTHERWISE SPECIFIED.			FLANGE PLATFORM FASTENING AND RELEASE LOCK HD SYSTEM FOR AN 32 AIRCRAFT			□ I/C D&S			
MATERIAL:-AS ABOVE						APPROVED			
FINISH:- AS PER SHEET NO 2 OF 45						HEAD Q.A.			
HEAT TREATMENT:- 265-352 BHN(32±5 RHC)						DRG. NO. ADRDE/1412-03			
									

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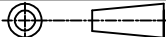
MATERIAL:- STEEL FOR GENERAL PURPOSE AS PER IS:2062

FINISH:- AS PER SHEET No. 2 OF 45

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

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOLMARKS AND ANY OTHER SURFACE DEFECT.

PROCESS:- MACHINING

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			□ I/C D&S	HEAD Q.A.
SCALE 2:1		QTY:-4 NoS.		A D R D E AGRA	DRN..	SK SHARMA	PRO.DFFR.	
DIMENSIONS IN mm				GROUP:-HDS	CHD.	JC DUTTA	PD	
TOL:- IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.				SCREW PLATFORM FASTENING AND RELEASE LOCK HD SYSTEM FOR AN 32 AIRCRAFT				
MATERIAL AS ABOVE								
FINISH :- AS PER SHEET NO 2 OF 45		□ I/C D&S						
HEAT TREATMENT:- NORMAL CONDITION		APPROVED						
						HEAD Q.A.		
						DRG. NO. ADRDE/1412-04		
								

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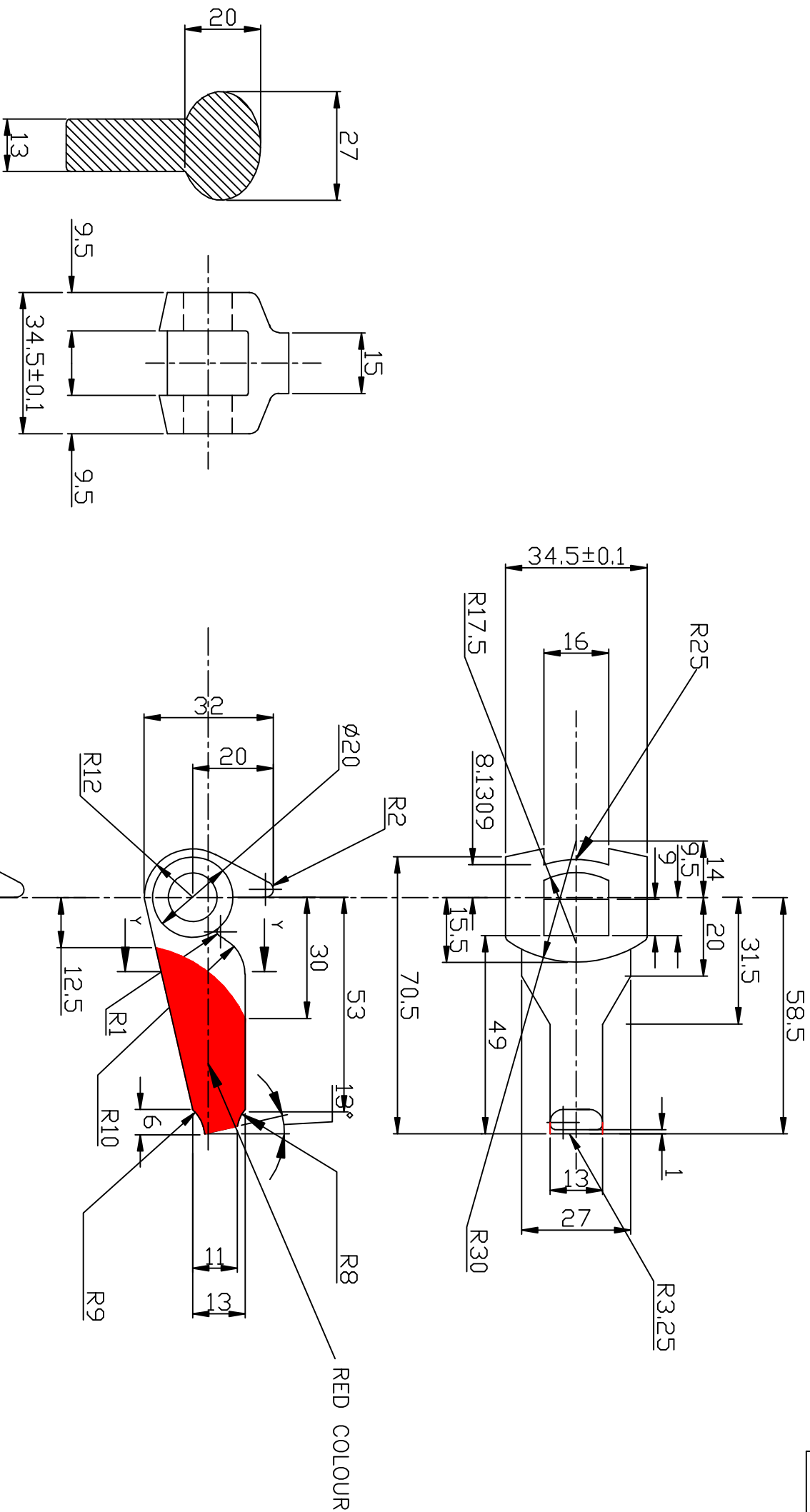
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SHEET 8 OF 45

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SECTION-YY

SECTION XX

MATERIAL:- EN 19(709-40) EN 24(817 M-40) AS PER SPECIFICATION BS:970.
FINISH:- AS PER SHEET No.2 OF 45
TOLERANCE: - IS:2102(PART-1)MEDIUM UNLESS OTHERWISE SPECIFIED.
WORKMANSHIP:- THE FINISHED COMPONENT SHALL BE FREE FROM PITS,CRACKS,TOOL MARKS AND ANY OTHER SURFACE DEFECTS
PROCESS:- FORGING & MACHINING.

Ref. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/C	PGD

SCALE:-1:1	QTY:- 1No.	ADDRDE AGRA	DRN	SK SHARMA	PROJ OFFR
DIMENSIONS ARE IN mm	GROUP:HDS	CHD	JC DUTTA	PD	
TOLERANCE:AS ABOVE				O I/C D&S	
MATERIAL :-AS ABOVE				APPROVED	
FINISH:-AS ABOVE					
HEAT TREATMENT:- 265-352 BHN(32±5 RHC)					
PAWL PLATFORM FASTENING AND RELEASE LOCK (H D SYSTEM FOR AN 32 AIRCRAFT)					DRG.No. HEAD(QA)
					ADRDE/1412-05(d)

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			SHEET 9 OF 45

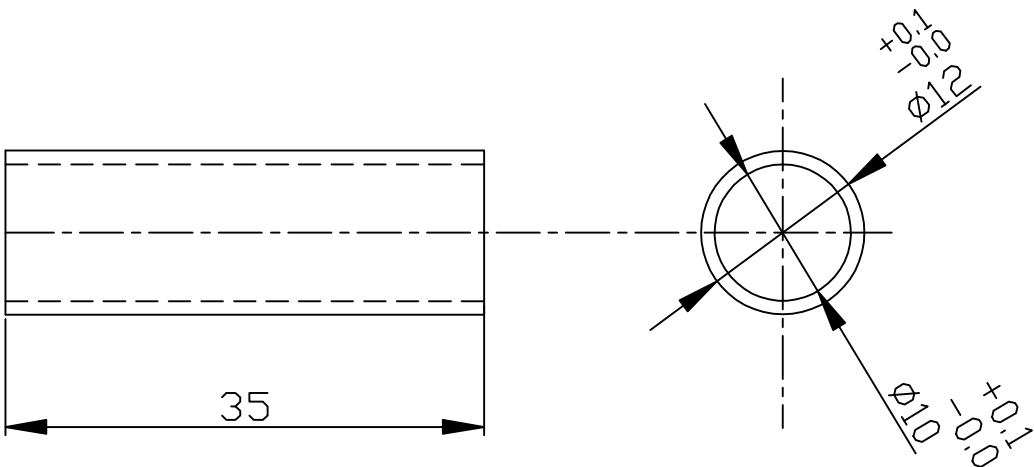
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MATERIAL:- EN 19 (709 M 40)/EN 24 (817 M40) AS PER SPECIFICATION BS:970

HARDNESS:- 265 - 352 BHN NORMAL CONDITION.

FINISH:- AS PER SHEET No. 2 OF 45

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

WORKMANSHIP:-THE FINISHED COMPONENT SHALL BE FREE FROM CRACK,TOOL MARKS AND ANY OTHER SURFACE DEFECTS.

PROCESS:- MACHINING.

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD			□ I/C D&S	HEAD Q.A.	
SCALE 2:1		QTY:- 1No.		A D R D E AGRA		DRN..	SK SHARMA	PRO.OFFR.	
DIMENSIONS IN mm				GROUP:-HDS		CHD.	JC DUTTA	PD	
TOL:- IS:2102(PART-1) MEDIUM UNLESS OTHERWISE SPECIFIED.				BUSH SMALL PLATFORM FASTENING AND RELEASE LOCK HD SYSTEM FOR AN 32 AIRCRAFT				□ I/C D&S	
MATERIAL:-AS ABOVE								APPROVED	
FINISH:- AS PER SHEET NO 2 OF 45								HEAD Q.A.	
HEAT TREATMENT:- NORMAL								DRG. NO.	
				ADRDE/1412-06(a)					