

SECTION - XX

MFG. PROCESS :- MACHINING.

NOTE:- 1-PART No.1 AND PART No.2 SHOULD HAVE 'LOOSE RUNNING FIT'.
 2-O-RING PART-1 IS TO BE PUNCHED SEALED AT TWO PLACES WITH PART-3 THREADED BUSH AT THE TIME OF ASSEMBLY.

DETAIL No.	SHEET No.	NOMENCLATURE	No. OFF	SPEC. DRG. No.
4	5	RING-SUB ASSEMBLY	-	
3	4	THREADED BUSH	1	
2	3	BODY	1	
1	2	O-RING	1	
-	1	ASSEMBLY	-	

DETAIL INDEX

DRN: RAVI	DRD	MATERIAL:-	ADRDE, AGRA
CHD: S. V. Rami	DRD	FINISH -	
TRD	0/c	HEAT TREATMENT -	
COMP	PGD		
SCALE: N T S	PROJ. OFFR: <i>DRD</i>	APPROVED	
DIMENSIONS ARE IN mm	DIV HEAD: <i>DRD</i>		
TOLERANCE IS: 2102 (PT-1)			
MEDIUM			
ASSEMBLY		PROG. DIRECTOR (QA)	
FEMALE COUPLING OF CWL		DRG. No. ADRDE/1344 (a/b)	
JAGUAR A/C			

BRIEF RECORD

0/c/PGD

QMS/PG/PAS/245, AMENDED AS PER CHANGE SHEET No.120

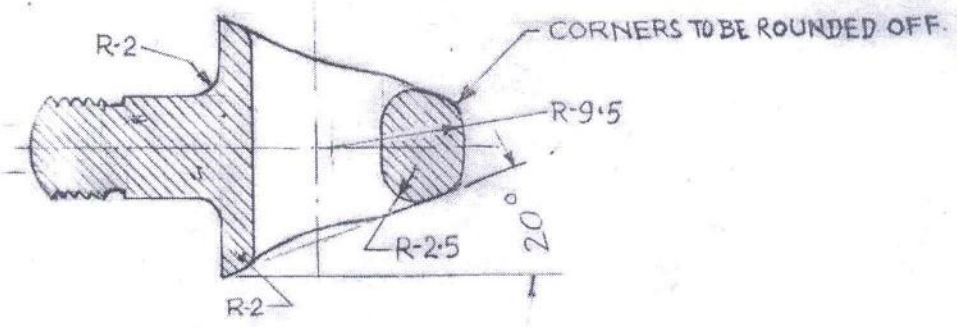
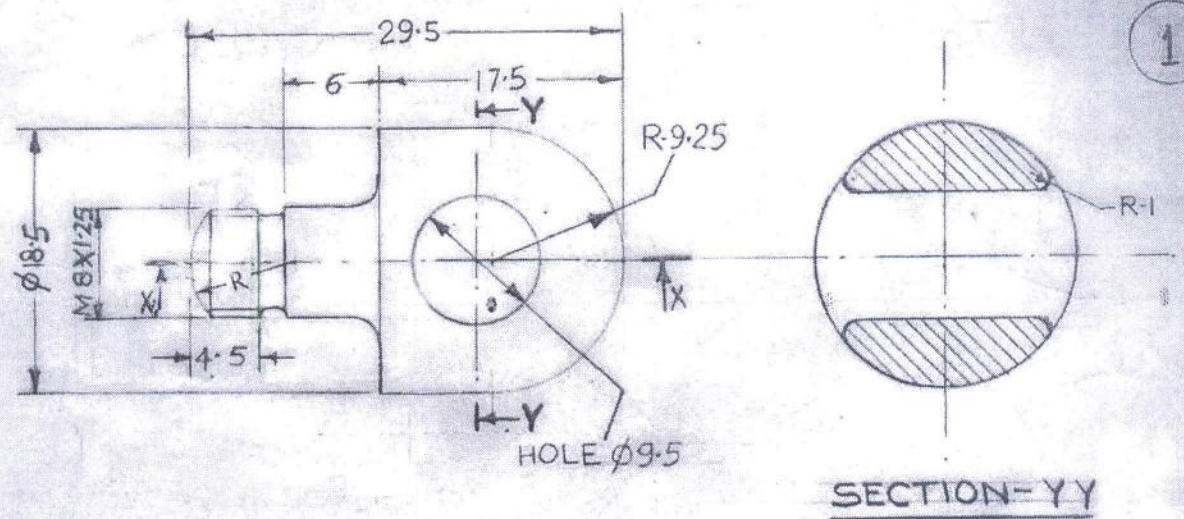
04-04-18

b

AUTHORITY

RCM(AK)
 APPROVED





SECTION-XX

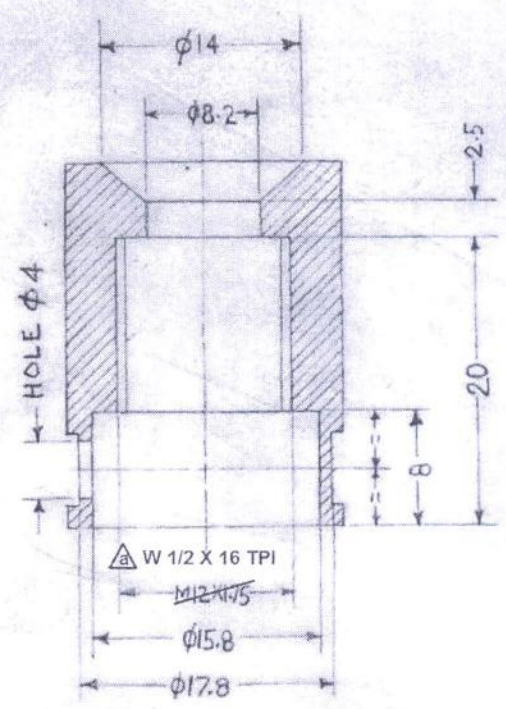
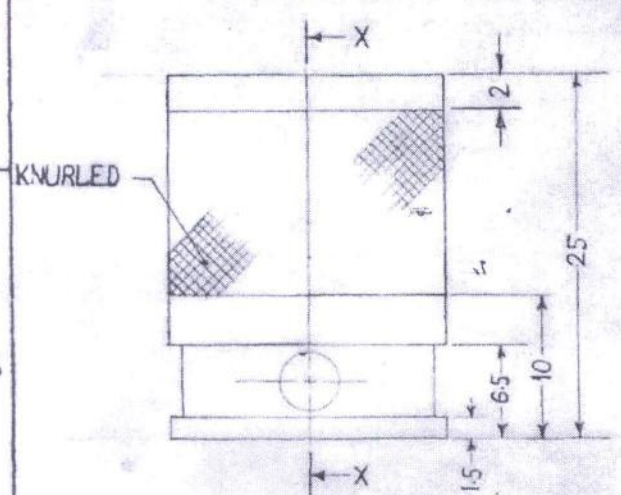
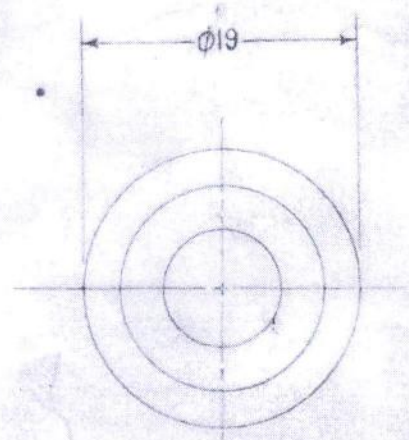
MATERIAL :- AUSTENITIC STAINLESS STEEL AS PER IS : 6603 - 2001 GRADE 07Cr18 Ni9

1-OFF

MATERIAL :- AUSTENITIC STAINLESS STEEL CASTING TO GRADE 6 AS PER IS: 3444-1986 INCAST AND ANNEALED CONDITION.

b	04-04-18	----	QMS/PG/PAS/245	AMENDED AS PER CHANGE SHEET No.120		
R.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	OVC	PGD
DRN	<i>Sattar Khan</i>		DRD	MATERIAL :- AS ABOVE	ADRDE, AGRA.	
CHD	<i>Sita Ram</i>		<i>Tolmi</i>	FINISH :- TO BE SMOOTHLY FINISHED & POLISHED BRIGHT		
TRD			OVC PGD			
COMP				HARDNESS :- AVERAGE 175/215 BHN.	APPROVED	
SCALE :-	2:1		PROJ. OFFR <i>cv</i>		 PROJ. DIRECTOR	
DIV. HEAD	<i>os</i>				DRG. No. ADRDE/1344 (2)(b) PROJ/11/99	
DIMENSIONS	IN mm			O-RING	PROJ. DIRECTOR	
TOLERANCE	IS: 2102 (Pt. 1)			FEMALE COUPLING OF CWL		
	MEDIUM			JAGUAR A/C		

2



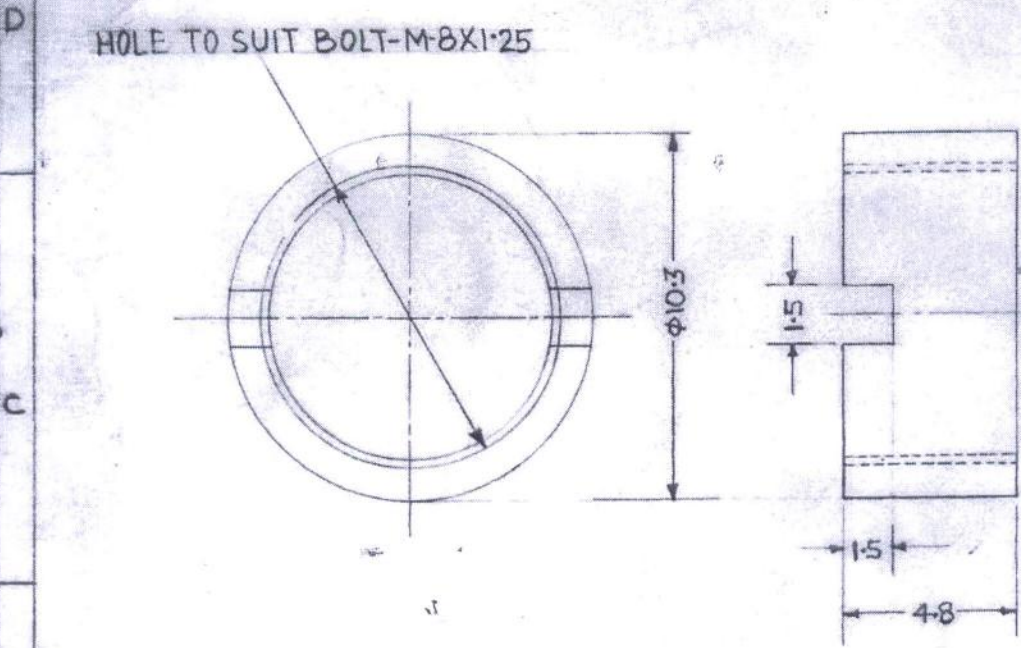
SECTION-XX

1-OFF

RCMA (K)

b	04-04-18	---	QMS/PG/PAS/245	AMENDED AS PER CHANGE SHEET No. 120		
a	23-2-16	B-2	ADRDE/QMS/PAS/224	AMENDED AS PER CHANGE SHEET No 43		
R.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/C	PGD
DR	S.C.SHARMA		DRD	MATERIAL :- ALLOY BAR AS PER SPECN.IS: 733-1976 HE 14 (W) CONDITION.	ADRDE, AGRA	
CHD	Sita Ram			FINISH :- TO BE SMOOTHLY FINISHED AND ANODIZED BLACK TO GRADE 15 AS PER SPECN.IS: 1868-1968		
TRD						
COMP			O/C	PGD	APPROVED :-	
SCALE :-	2:1		PROJ. OFFR <i>by</i>	HARDNESS :- 155/175 BHN.		
			DIV. HEAD <i>only</i>			
DIMENSIONS IN M.M						
TOLERANCE :-	IS: 2102 (Pt. 1)				PROG. DIRECTOR (QA) DRG. No. ADRDE / 134-4 (a)(b)	
	MEDIUM			BODY FEMALE COUPLING OF CWL JAGUAR A/C	DRD / 11199	

3



1-OFF

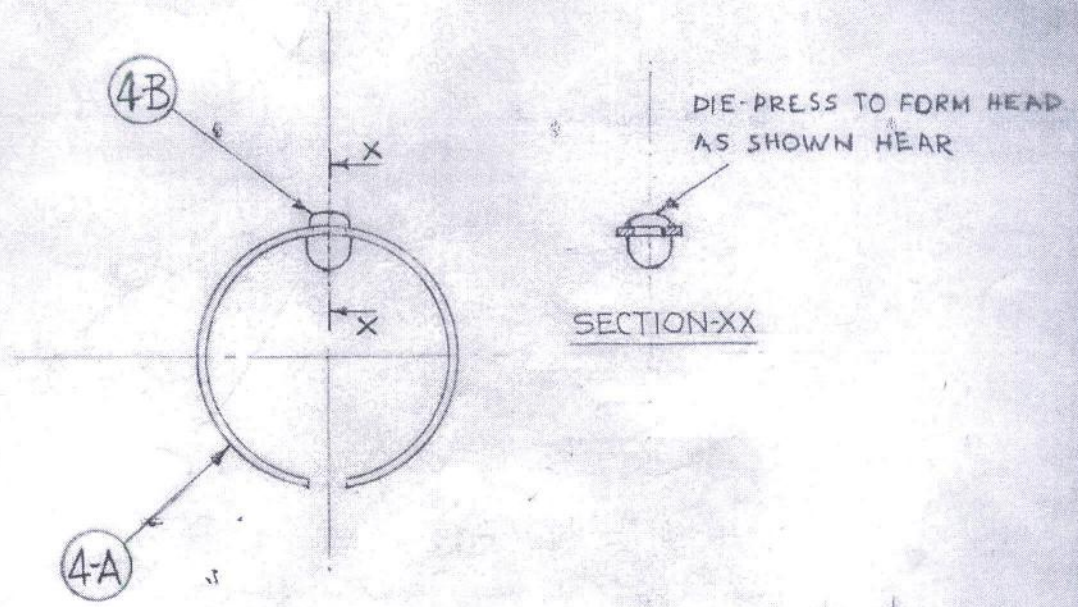
MATERIAL:- AUSTENITIC STAINLESS STEEL BAR TO GRADE 07 Cr 18 Ni 9 AS PER IS: 6603 IN 1/2 HARD CONDITION.

RCMA(K)

b		04-04-18	-----	QMS/PG/PAS/245	AMENDED AS PER CHANGE SHEET No. 120				
R/NO	DATE	ZONE	AUTHORITY	BRIEF RECORD		O/C	PGD		
DRN	S.C.SHARMA		DRD	MATERIAL :- AS ABOVE		ADRDE AGRA			
EHD	<i>Sita Ram</i>		<i>Jsh</i>		FINISH :- TO BE SMOOTHLY FINISHED & POLISHED BRIGHT				
TRD			O/C	PGD					
COMP					HEAT TREATMENT :-	APPROVED			
SCALE: 5:1		PROJ OFFR :- <i>by</i>		DIV HEAD <i>Jsh</i>		 PROG DIRECTOR (QA)			
DIMENSION'S IN mm		THREADED BUSH b FEMALE COUPLING OF CWL JAGUAR A/C						DRG NO. - ADRDE/- 1344 (a)(b)	
TOLERANCE: IS: 2102 (Pt 1) MEDIUM								DRD/11/99	

4

D
C
B
A



4-B	7	STOPPER	1	
4-A	6	RING	1	
4	5	RING SUB-ASSEMBLY	-	
DETAIL NO.	SHEET NO	NOMENCLATURE	NO.OFF	SPECN./DRG NO.

DETAIL INDEX

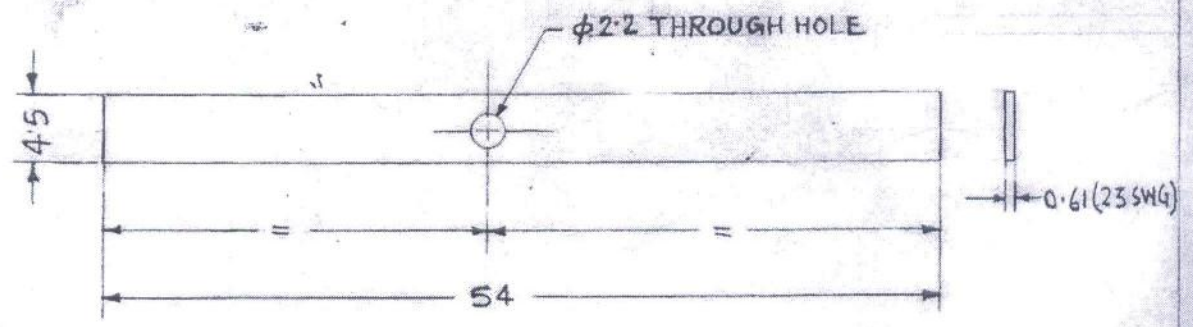
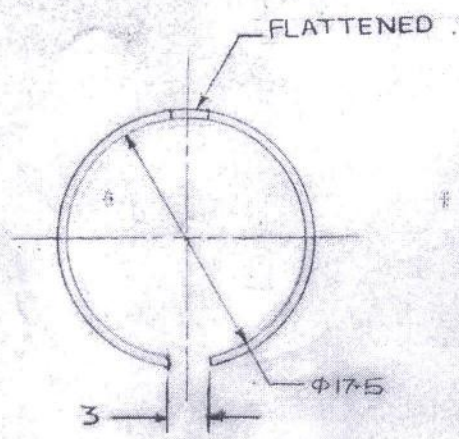
Handwritten signature
RCMA(K)

b	04-04-18	-----	QMS/PG/PAS/245	AMENDED AS PER CHANGE SHEET No.		
R NO	DATE	ZONE	AUTHORITY	BRIEF	RECORD	O/C PSC

DRN	SC SHARMA	DRD	MATERIAL :-	ADRDE AGRA
CHD	Sita Ram	<i>Tol</i>	FINISH :-	
TRD		<i>+7</i>		
COMP		O/C PGD	HEAT TREATMENT :-	APPROVED
SCALE :-	2:1	PROJ OFFR <i>W</i>	DIV HEAD :- <i>my</i>	<i>Signature</i>
DIMENSIONS IN mm	RING SUB-ASSEMBLY \triangle			PROG DIRECTOR (SMA)
TOLERANCE:-	FEMALE COUPLING OF CWL			DRG No.
IS: 2102 (pt 1)	JAGUAR A/C			ADRDE/1344 (a)(b)
MEDIUM				DRD/11/99

4A

D
C
B
A



DEVELOPMENT

I-OFF

RCMA(k)

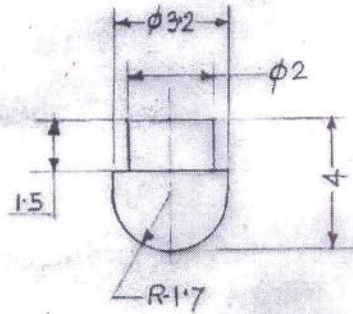
b	04-04-18	----	QMS/PG/PAS/245	AMENDED AS PER CHANGE SHEET No. 120		
RNO	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/C	PGD
DRN	SCSHARMA		DRD	MATERIAL :- CARBON SPRING STEEL EN-42J AS PER IS:1449-1956	ADDRDE	AGRA
CHD	Sita Ram		<i>Jain</i>	FINISH :- Cd PLATED AS PER SPECN. No. IS:1572-1986 Fe/cd		
TRD			O/C	12 CA		
COMP			PGD	HARDNESS :- 201/255 BHN.	APPROVED	<i>Spandh</i>
SCALE :-	2:1	PROJ OFFR :-	<i>...</i>		PROG DIRECTOR (R-A)	
DIMENSIONS IN mm		DIV HEAD :-	<i>...</i>		DRG NO-	
TOLERANCE IS: 2102 (Pt 1) MEDIUM					ADRDE/1344 (A)(b)	
					DRD/11/99	

RING

FEMALE COUPLING OF CWL

JAGUAR A/C

4-B



T-OFF

[Signature]
RCMALK

b	04-04-18	-----	QMS/PG/PAS/245	AMENDED AS PER CHANGE SHEET No. 120		
RNO	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/C	PGD
DRN	SC.SHARMA		DRD	MATERIAL :- STEEL AS PER SPECN. 15: 4882-1968	ADRDE AGRA	
CHD	Sita Ram		<i>[Signature]</i>	FINISH :- cd PLATED AS PER SPECN. No.15: 1572-1986Fe/cd12c		
TRD			O/C			
COMP			PGD			
SCALE: 5:1	PROJ OFFR: - <i>[Signature]</i>		HARDNESS :-		APPROVED	
DIMENSIONS IN mm	DIV. HEAD: - <i>[Signature]</i>				<i>[Signature]</i>	
TOLERANCE: 15: 2102 (Pt. 1) MEDIUM	STOPPER FEMALE COUPLING OF CWL JAGUAR A/C				PROG DIRECTOR (QA)	
					DRG NO ADRDE/1344 (a)(b)	
					DRD/11/99	