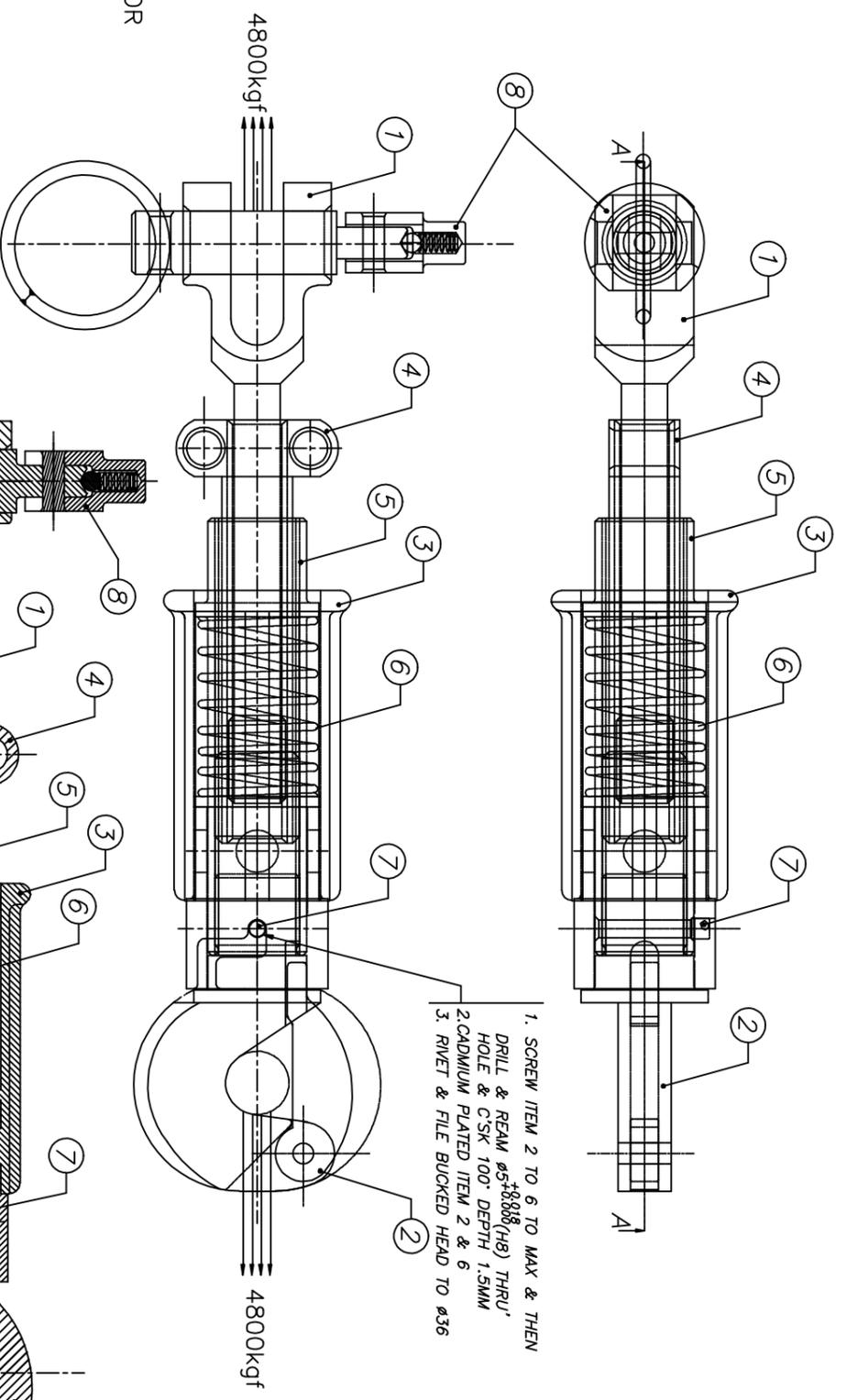


NOTE:-  
LUBRICATE WITH GREASE AIR 4205B  
(MIL-G-3545C) OR EQUIVALENT



PROOF LOAD TEST  
QUICK RELEASE FASTENER TO BE TESTED FOR  
4800kgf LOAD AS SHOWN IN DRAWING.

FITMENT TEST  
IT SHOULD BE FITTED TO THE SHACKLE WITH PIN (AS PER DRG. No. 1410)  
AND EYE BOLT (AS PER DRG. No. 1403 01 01 15) WITHOUT ANY PROBLEM.

8	ADRDE 1409 08	LOCK PIN SUB ASSEMBLY	1	14-19
7	ADRDE 1409 07	PIN	1	13
6	ADRDE 1409 06	SPRING	1	12
5	ADRDE 1409 05	MAIN BODY	1	11
4	ADRDE 1409 04	ADJUSTIVE LINK	1	10
3	ADRDE 1409 03	HANDLE SUB ASSEMBLY	1	7-9
2	ADRDE 1409 02	HOOK SUB ASSEMBLY	1	3-6
1	ADRDE 1409 01	FORK	1	2

ITEM LIST

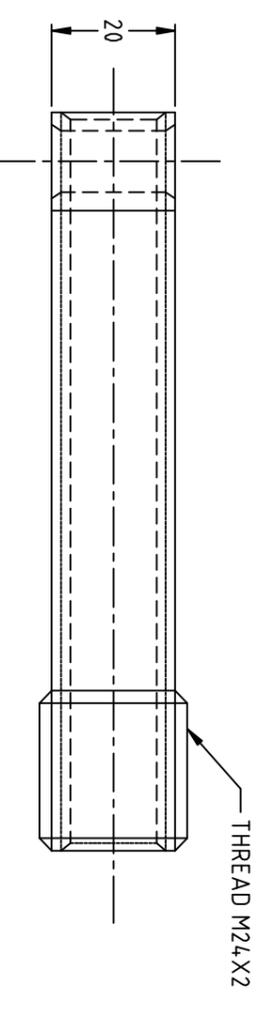
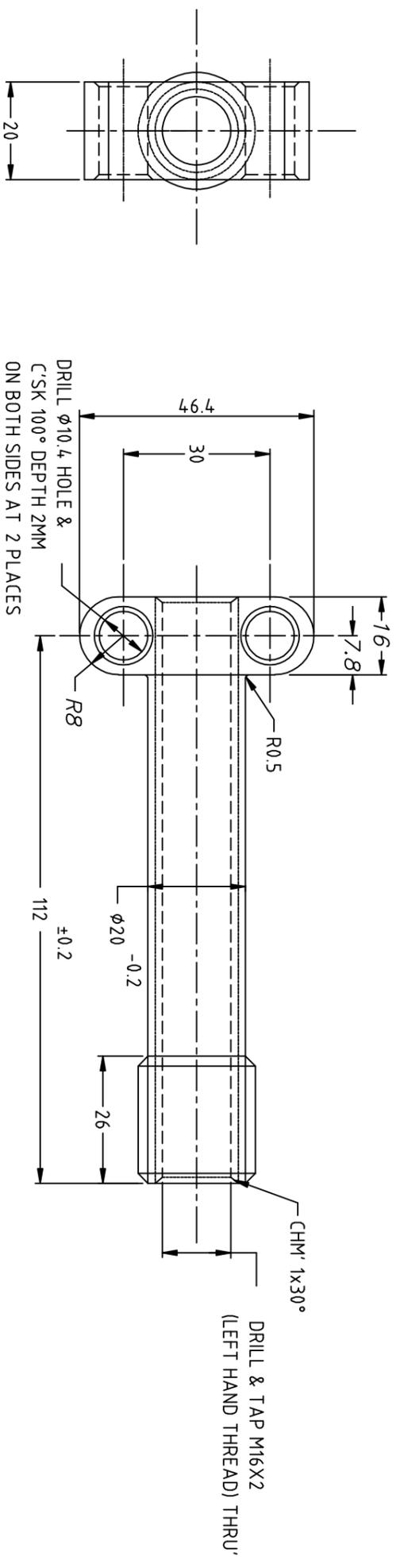
PROCESS : FABRICATION

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD
1				

SECTION -AA

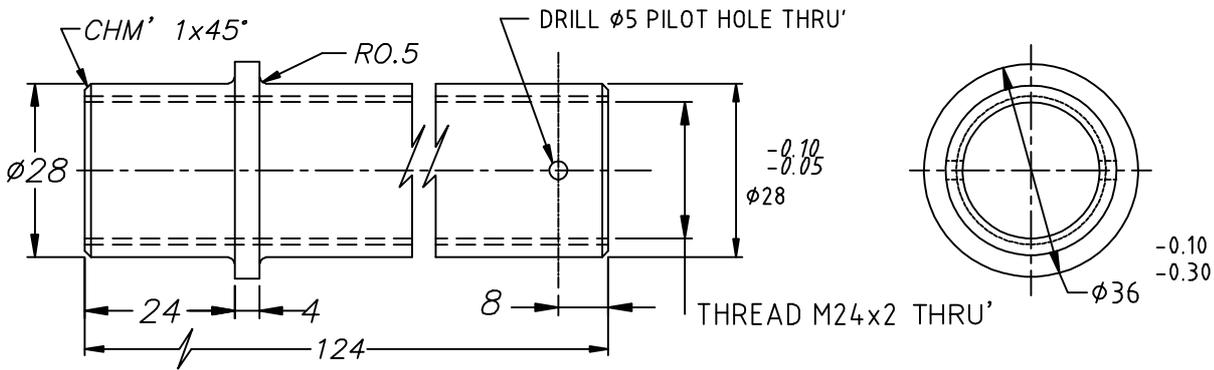
FINISH :- CADMIUM PLATING TO A AVERAGE THICKNESS OF  
0.012mm AND CHROMATE PASSIVATED TO SPEC.  
IS: 1572-1986 Gr.2 AND CLASSIFICATION Fe/Cd-8 CA

SCALE:- NTS	QTY :- 1 No.	AD R D E AGRA	DRN.	SK SHARMA
DIMENSIONS IN mm		GROUP:- HDS	CHKD.	J.C.DUTTA
TOL:- VERY COARSE UNLESS OTHERWISE SPECIFIED		ASSEMBLY QUICK RELEASE FASTENER (HD SYSTEM FOR AN-32A/C)		
MATERIAL:-		APPROVED		
FINISH:- AS ABOVE		PROJ.DIR./GRP OFFR		
HEAT TREATMENT:-		DRG. NO. ADRDE/1409		



NOTE:-  
 ROUND OFF ALL SHARP CORNERS TO RADIUS 0.2  
 MANUFACTURING PROCESS : MACHINING

SCALE:- NTS		QTY :- 1 No.		A D R D E A G R A		DRM..		SK SHARMA	
DIMENSIONS IN mm		TOL.:- IS:2102(PART1) :1993 MEDIUM		GROUP:- HDS		CHKD.		J.C.DUTTA	
MATERIAL:- STEEL ALLOY		AS PER BS:970		ADJUSTIVE LINK		QUICK RELEASE FASTENER		APPROVED	
FINISH:-		AS PER SHEET No.1		HEAT TREATMENT:-		HARDENED & TEMPERED		PROJ.DIR./GP DIR	
HEAT TREATMENT:-		32±5HRC		DRG NO.		ADDRDE/14.09 - 04		PROJ.DIR./GP DIR	
Ref. NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD		O I/C	HEAD		
1				2	3	D&S	Q.A.		

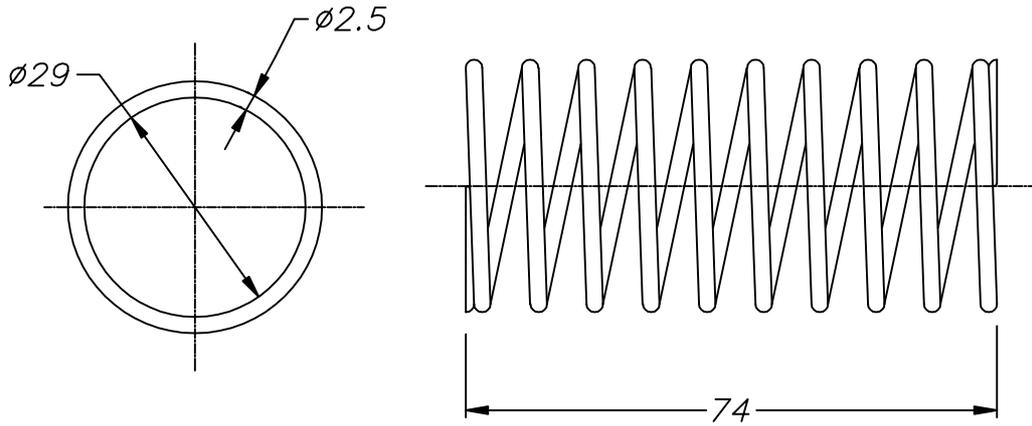


NOTE:-

ROUND OFF ALL SHARP CORNERS TO RADIUS 0.2

PROCESS : MACHINING

Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:- NTS		QTY:- 1No.		A D R D E A G R A	DRN..	SK SHARMA		PRO.OFFR./GP.OFFR	
DIMENSIONS IN mm		GROUP:- HDS		CHKD.	J C D U T T A				
TOL.: IS:2102(Pt-1)1980 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				MAIN BODY QUICK RELEASE FASTENER HD SYSTEM FOR AN 32 A/C				APPROVED	
MATERIAL: STEEL ALLOY 709M40/817M40,(EN19/EN24) AS PER BS:970								PROJ.DIR/GP.DIR	
FINISH:- AS PER SHEET No.1								DRG. NO. ADRDE/1409- 05	
HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC									

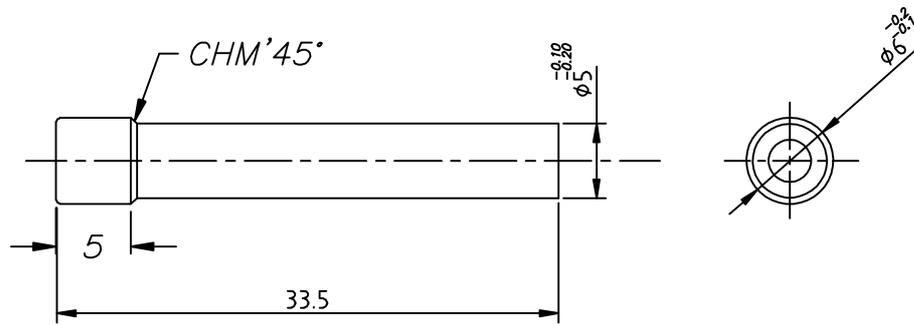


NOTE:-

1. TOTAL NUMBERS OF COILS = 11
2. TOTAL EFFECTIVE NUMBERS OF COILS = 9
3. ENDS ARE GROUND SQUARE TO AXIS
4. STIFFNESS OF SPRING = 0.15 kg/mm
5. SPRING WIRE DIAMETER = 2.5mm.

PROCESS : FABRICATION

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)	
SCALE:- NTS		QTY:- 1 No.		ADRDE AGRA	DRN.	SK SHARMA			
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA			
TOL.: IS:2102(Pt-1)1980 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED				SPRING QUICK RELEASE FASTENER HD SYSTEM FOR AN 32 A/C				PRO.OFFR./GP.OFFR	
MATERIAL: SPRING STEEL WIRE AS PER IS: 4454 ,(PART-1) GRADE IV								APPROVED	
FINISH:- AS PER SHEET No.1								PROJ.DIR/GP.DIR	
HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC								DRG. NO. ADRDE/1409- 06	



NOTE:-

ROUND OFF ALL SHARP CORNERS TO RADIUS 0.2

PROCESS : MACHINING

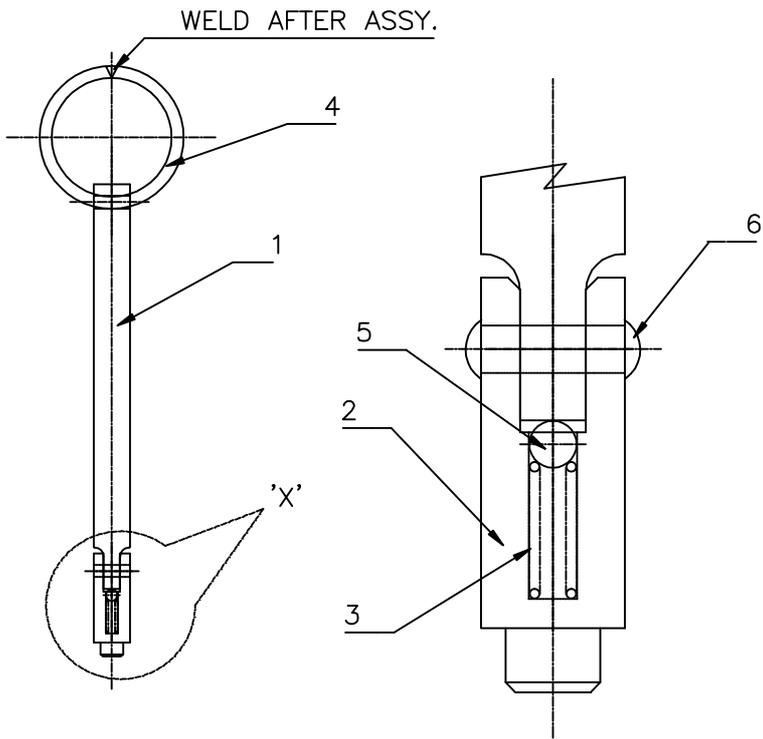
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SCALE:- 2:1		QTY:- 1No.		ADRDE AGRA	DRN.	SK SHARMA		PRO.OFFR./GP.OFFR	
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA			
TOL.: IS:2102(Pt-1)1980MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				PIN QUICK RELEASE FASTENER HD SYSTEM FOR AN 32 A/C			APPROVED		
MATERIAL: STEEL ALLOY 709M40/817M40 (EN19/EN24) AS PER BS:970									
FINISH:- AS PER SHEET No.1							PRO.DIR./GP.DIR		
HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC									
1		2		3		4			



1	2	3	4
6	ADRDE 1409 08 05	RIVET	1 19
5	STAINLESS STEEL BALL COMMERCIAL QUALITY	BALL Ø 5.5	1
4	ADRDE 1409 08 04	RING	1 18
3	ADRDE 1409 08 03	SPRING	1 17
2	ADRDE 1409 08 02	FORK	1 16
1	ADRDE 1409 08 01	PIN	1 15
LIST No.	DRG./SPEC. NO.	NOMENCLATURE	QTY SHEET No.

SHEET 14 OF 19

ITEM LIST



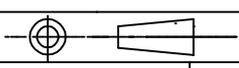
ENLARGED VIEW AT 'X'

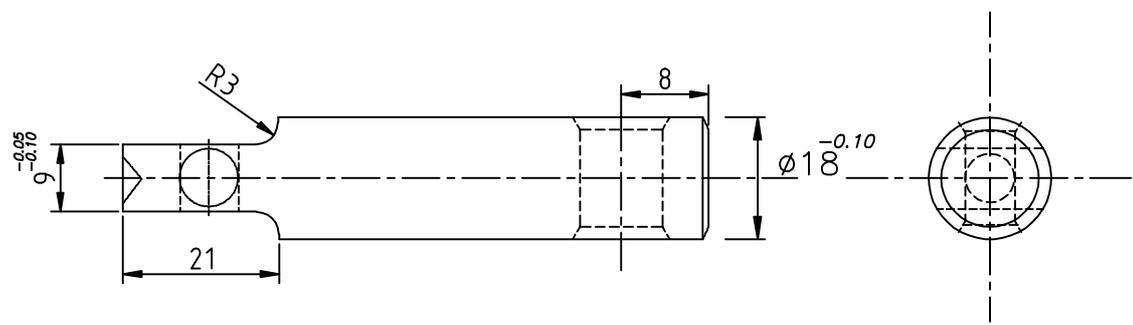
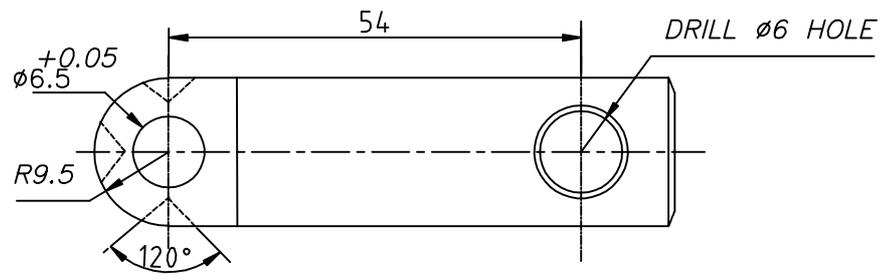
WELDING :  
ALL WELDED JOINTS SHOULD BE WELDED BY ELECTRODES CONFORMING TO  
ADVANI OERLIKON SUPERCITO AWS/SFA 5.1-E7018 ISEB-5426 H3Jx OR ITS  
EQUIVALENT.

PROCESS : FABRICATION

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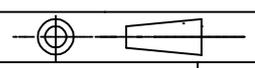
Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)		
SCALE:- NTS	QTY:- 1 No.		A D R D E A G R A	DRN..	SK SHARMA					
DIMENSIONS IN mm			GROUP:- HDS	CHKD.	J C D U T T A					
TOL.: IS:2102(Pt-1)1980VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED			LOCK PIN SUB ASSEMBLY QUICK RELEASE FASTENER HD SYSTEM FOR AN 32 A/C			PRO.OFFR./GP.OFFR				
MATERIAL: _____						APPROVED				
FINISH:- AS PER SHEET No.1									PRO.DIR./GP.DIR	
HEAT TREATMENT:- _____									DRG. NO. ADRDE/1409- 08	



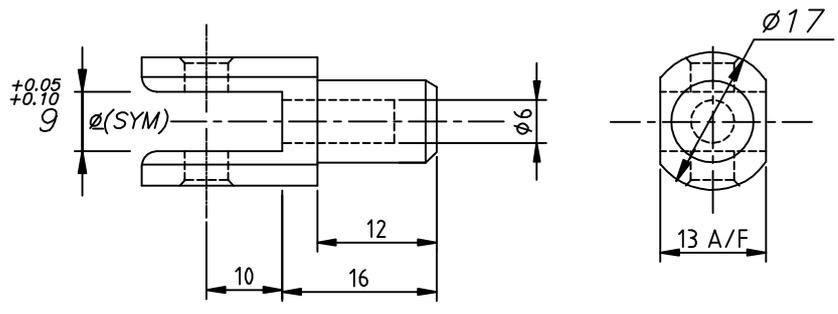
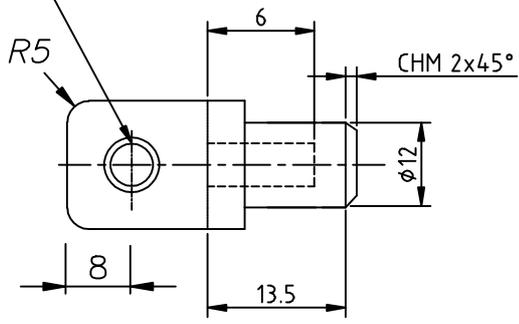


PROCESS : MACHINING

Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)	
SCALE:- NTS		QTY:- 1 No.		ADRDE AGRA	DRN..	SK SHARMA		PROJ.OFFR./GP.OFFR		
DIMENSIONS IN mm		GROUP:- HDS		CHKD.	JC DUTTA					
TOL.: IS:2102(Pt-1)1980 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				PIN LOCK PIN AUB ASSEMBLY QUICK RELEASE FASTENER HD SYSTEM FOR AN 32 A/C			APPROVED		PROJ.DIR./GP.DIR	
MATERIAL: STEEL ALLOY 070M40/817M40 (EN19/EN24),AS PER BS:970							DRG. NO. ADRDE/1409- 08- 01			
FINISH:- AS PER SHEET No.1										
HEAT TREATMENT:- _____										

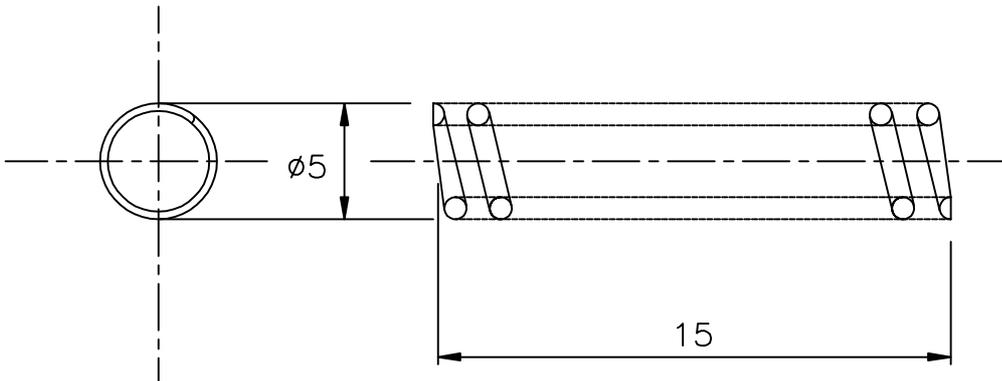


\*  $+0.05$   
 $\phi 6.4$  (CSK' ON BOTH SIDES)



\* DRILL  $\phi 6.4$  TO MATCH RIVET CSK' ON BOTH SIDES  
 PROCESS : MACHINING

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)	
SCALE:- NTS		QTY:- 1 No.		ADRDE AGRA	DRN.	SK SHARMA			
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA			
TOL.: IS:2102(Pt-1)1980 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				FORK LOCK PIN AUB ASSEMBLY QUICK RELEASE FASTENER HD SYSTEM FOR AN 32 A/C				PRO.OFFR./GP.OFFR	
MATERIAL: STEEL ALLOY 070M40/817M40 (EN19/EN24),AS PER BS:970								APPROVED	
FINISH:- AS PER SHEET No.1								PRO.DIR./GP.DIR	
HEAT TREATMENT:- HARDENED & TEMPERED 32±5 HRC								DRG. NO. ADRDE/1409- 08- 02	



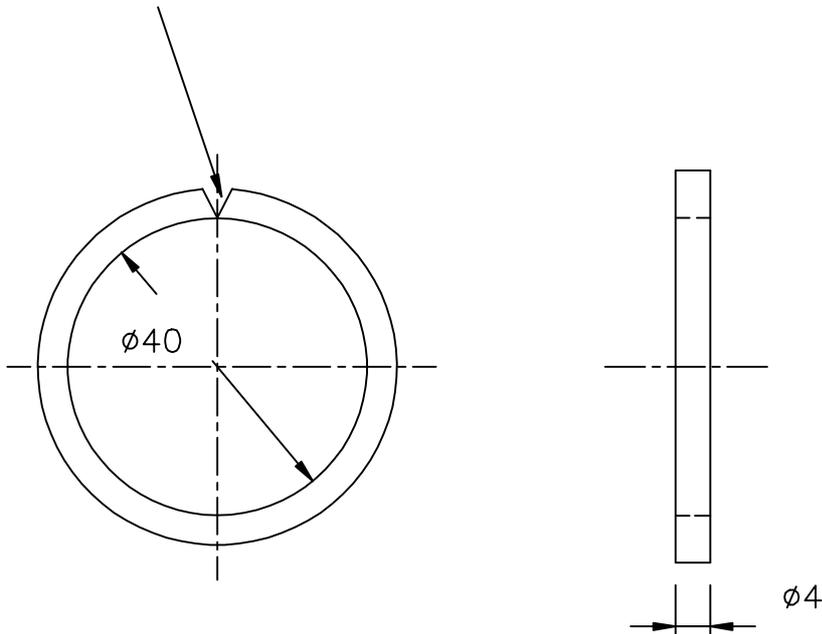
NOTE :

1. WIRE DIAMETER = 0.8
2. TOTAL No. OF COILS = 9
3. TOTAL No. OF EFFECTIVE COILS = 7
4. ENDS ARE GROUND SQUARE TO AXIS
5. STIFFNESS OF SPRING = 0.729kg/mm

PROCESS : FABRICATION

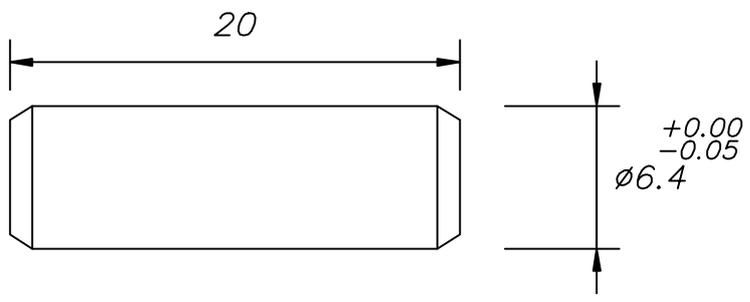
Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD				O I/C (D&S)	HEAD (Q.A.)		
SCALE:- NTS		QTY:- 1 No.		A D R D E AGRA		DRN..	SK SHARMA				
DIMENSIONS IN mm				GROUP:- HDS		CHKD.	JC DUTTA				
TOL.: IS:2102(Pt-1)1980 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED				<p><b>SPRING.</b> LOCK PIN AUB ASSEMBLY QUICK RELEASE FASTENER HD SYSTEM FOR AN 32 A/C</p>						PRO.OFFR./GP.OFFR	
MATERIAL: STAINLESS SPRING STEEL WIRE IS :4454:1975(PART-IV)Gr.1										APPROVED	
FINISH:- _____										PRO.DIR./GP.DIR	
HEAT TREATMENT:- _____										DRG. NO. ADRDE/1409- 08- 03	

CUT FOR WELD (WELD AFTER ASSEMBLY)



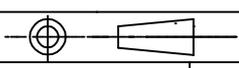
PROCESS : FABRICATION

Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:- NTS		QTY.:- 1No.		ADRDE AGRA	DRN..	SK SHARMA		PRO.OFFR./GP.OFFR	
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA			
TOL.: IS:2102(Pt-1)1980 VERY COARSE EXCEPT WHERE OTHERWISE SPECIFIED				<p style="text-align: center;"><b>RING</b> LOCK PIN AUB ASSEMBLY QUICK RELEASE FASTENER HD SYSTEM FOR AN 32 A/C</p>				APPROVED	
MATERIAL: MILD STEEL ST-42 S ,AS PER IS:226								PRO.DIR./GP.DIR	
FINISH: AS PER SHEET No.1								DRG. NO. ADRDE/1409- 08- 04	
HEAT TREATMENT:- NORMALISING									



PROCESS : MACHINING

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:-NTS		QTY.1No.	A D R D E AGRA	DRN..	SK SHARMA	APPROVED		
DIMENSIONS IN mm			GROUP:- HDS	CHKD.	JC DUTTA			
TOL.: IS:2102(Pt-1)1980 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED			<p style="text-align: center;">RIVET LOCK PIN AUB ASSEMBLY QUICK RELEASE FASTENER HD SYSTEM FOR AN 32 A/C</p>			PRO.OFFR./GP.OFFR		
MATERIAL: STAINLESS STEEL (AUSTENITIC) 04Cr18Ni10 AS PER IS:6527-1972						PRO.DIR./GP.DIR		
FINISH: AS PER SHEET No.1						DRG. NO. ADRDE/1409- 08 -05		
HEAT TREATMENT:-								



1

2

3

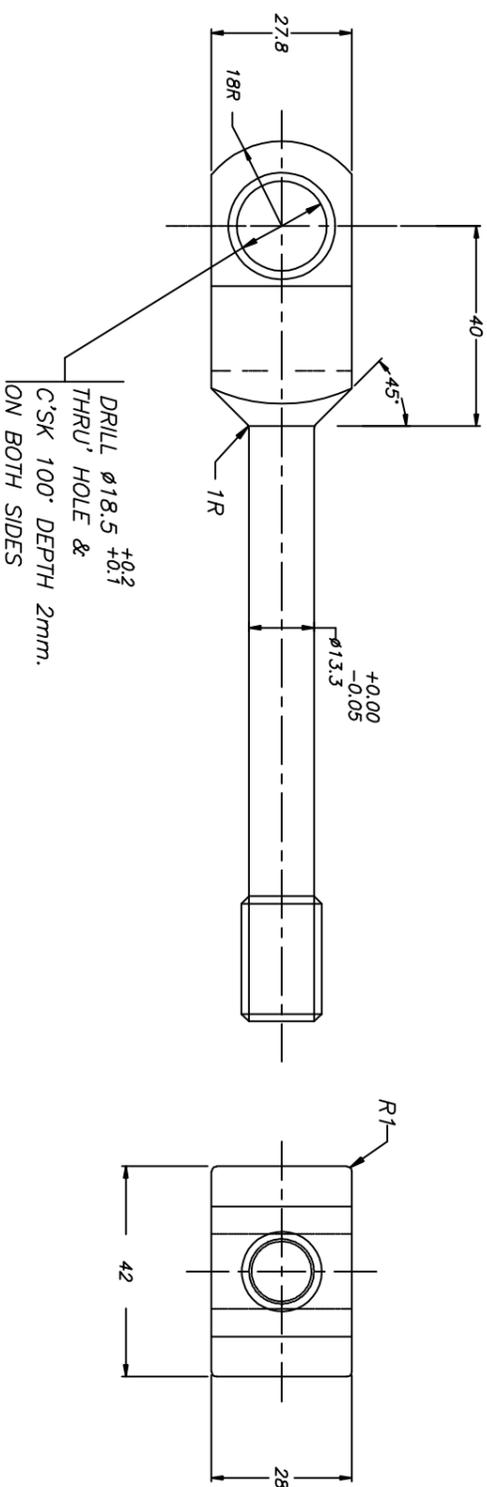
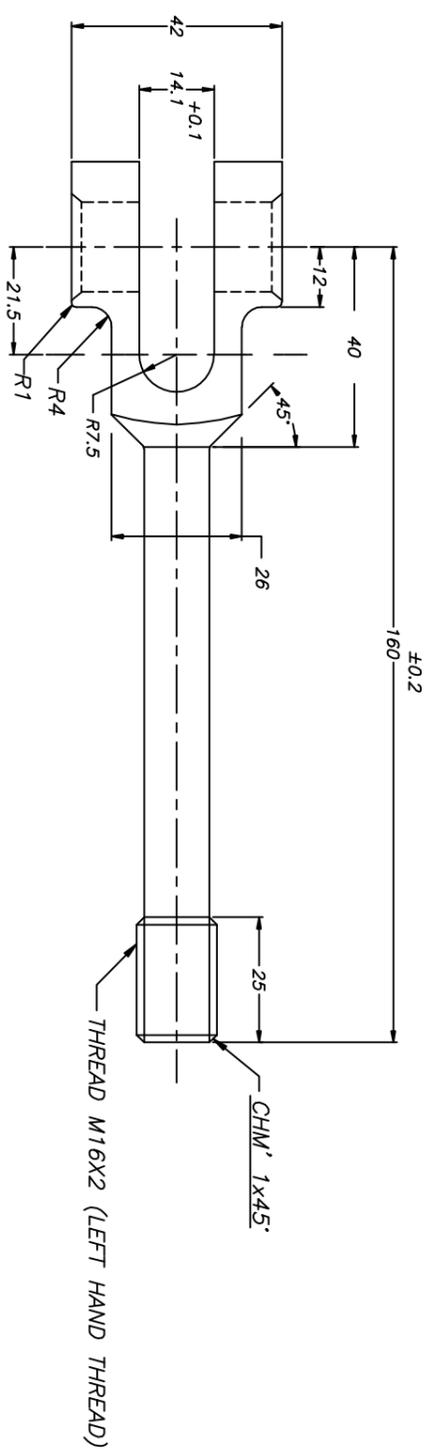
4

5

6

7

8



NOTE:-  
ROUND OFF ALL SHARP CORNERS TO RADIUS 0.2

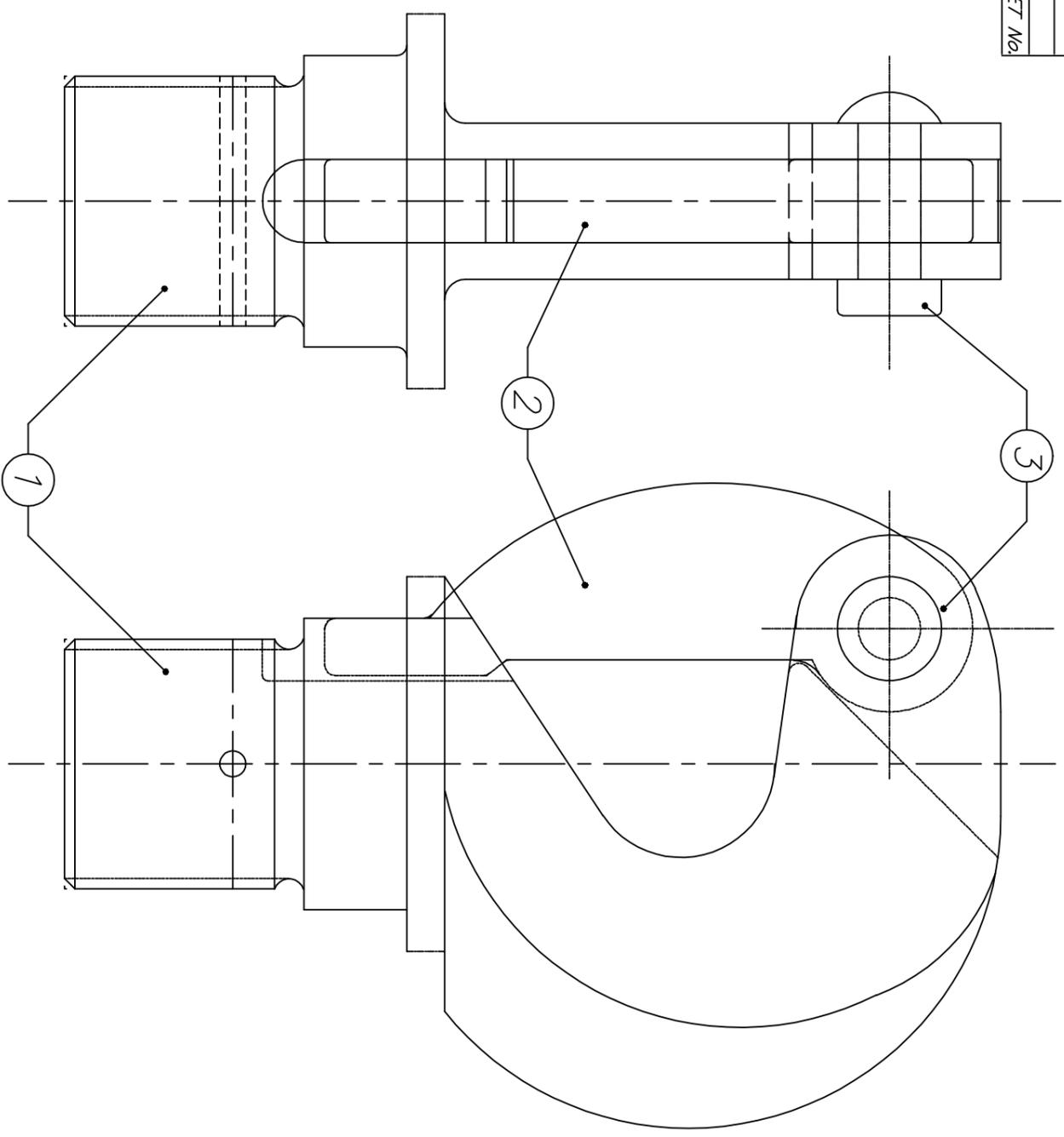
PROCESS : MACHINING

Ref. NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/I/C	HEAD
1					D&S	G.A.

SCALE:- NTS	QTY :-	1 No.	A D R D E A G R A	DRN.	S K S H A R M A
DIMENSIONS IN mm			GROUP:- HDS	CHKD.	J C D U T T A
TOL:- IS:2102(PART1):1993 MEDIUM UNLESS OTHERWISE SPECIFIED			<b>FORK</b> QUICK RELEASE FASTENER (HD SYSTEM FOR AN-32A/C)		
MATERIAL: STEEL ALLOY 709M40/817M40.(EN19/EN24) AS PER BS:970					
FINISH:- AS PER SHEET No.1			APPROVED		
HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC			PROJ.DIR./GROUP DIR.		
			DRG. NO. ADPDE/1409- 01		

ITEM No.	DRG./SPEC.NO.	NOMENCLATURE	QTY	SHEET No.
3	ADRDE 1409 02 03	RIVET(ROUND HEAD)	1	6
2	ADRDE 1409 02 02	LEVER	1	5
1	ADRDE 1409 02 01	HOOK	1	4

ITEM LIST



NOTE:-

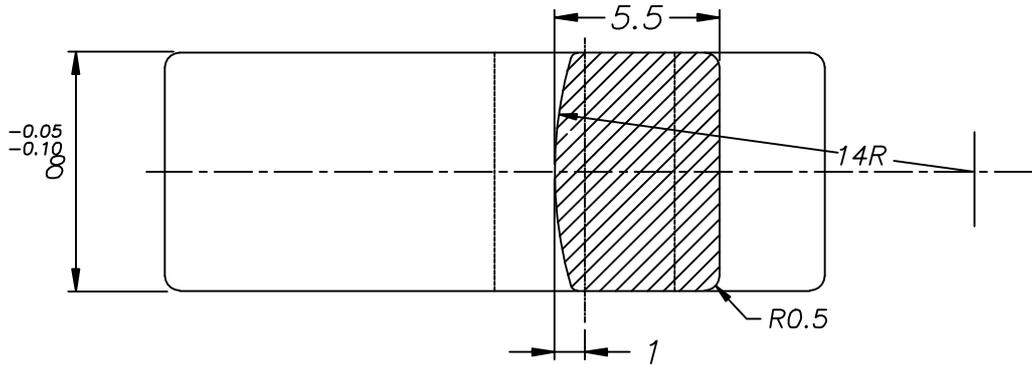
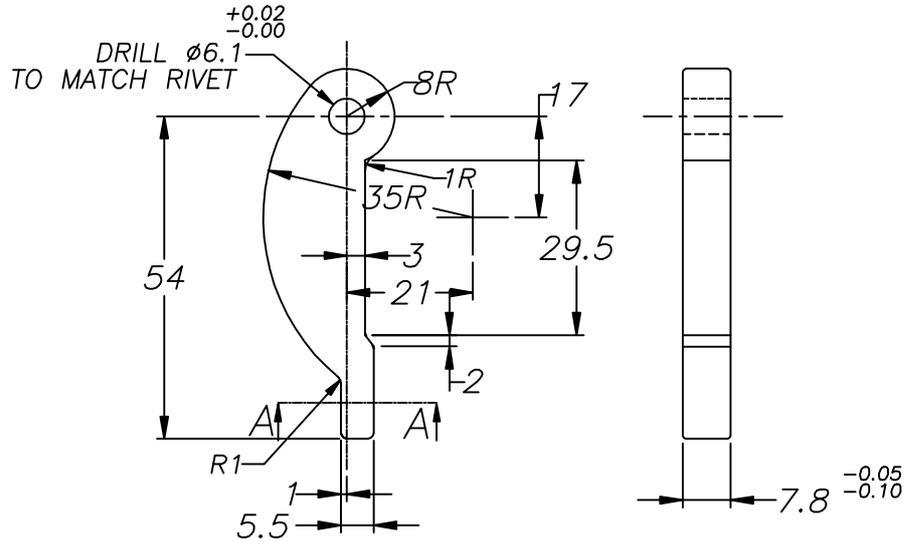
ROUND OFF ALL SHARP CORNERS TO RADIUS 0.2

MANUFACTURING PROCESS : FABRICATION/MACHINING

Ref.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/I/C	HEAD
1					D&S	G.A.

SCALE:- NTS	QTY :- 1 No.	FINISH:- AS PER SHEET No.1	HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC	GROUP:- HDS	DRN.	SK SHARMA	APPROVED	PROJ.DIR./GP OFFR	
DIMENSIONS IN mm		MATERIAL:-		A D R D E A G R A		CHKD.			J.C.DUTTA
TOL:- IS:2102(PART1):1993 VERY COARSE UNLESS OTHERWISE SPECIFIED				HOOK SUB ASSEMBLY				DRG. NO. ADRDE/1409- 02	
UNLESS OTHERWISE SPECIFIED				QUICK RELEASE FASTENER				PROJ.DIR./GROUP DIR.	
HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC				( HD SYSTEM FOR AN-32A/C)					





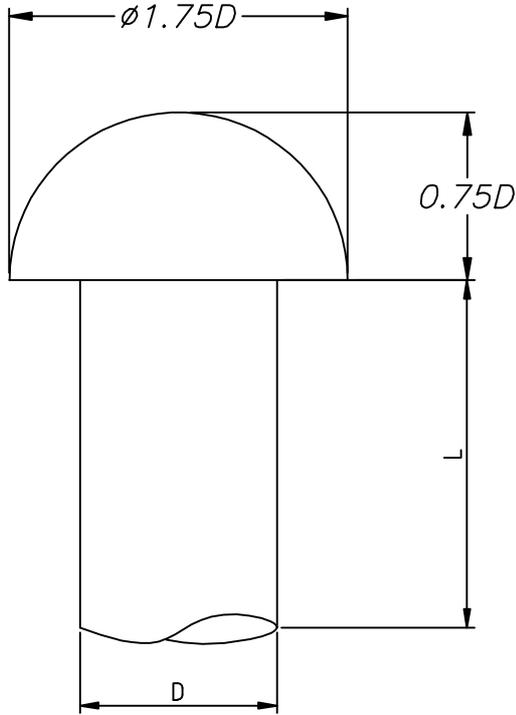
SECTIONAL VIEW - AA  
SCALE: 4:1

NOTE:-

ROUND OFF ALL SHARP CORNERS TO RADIUS 0.2

PROCESS : MACHINING

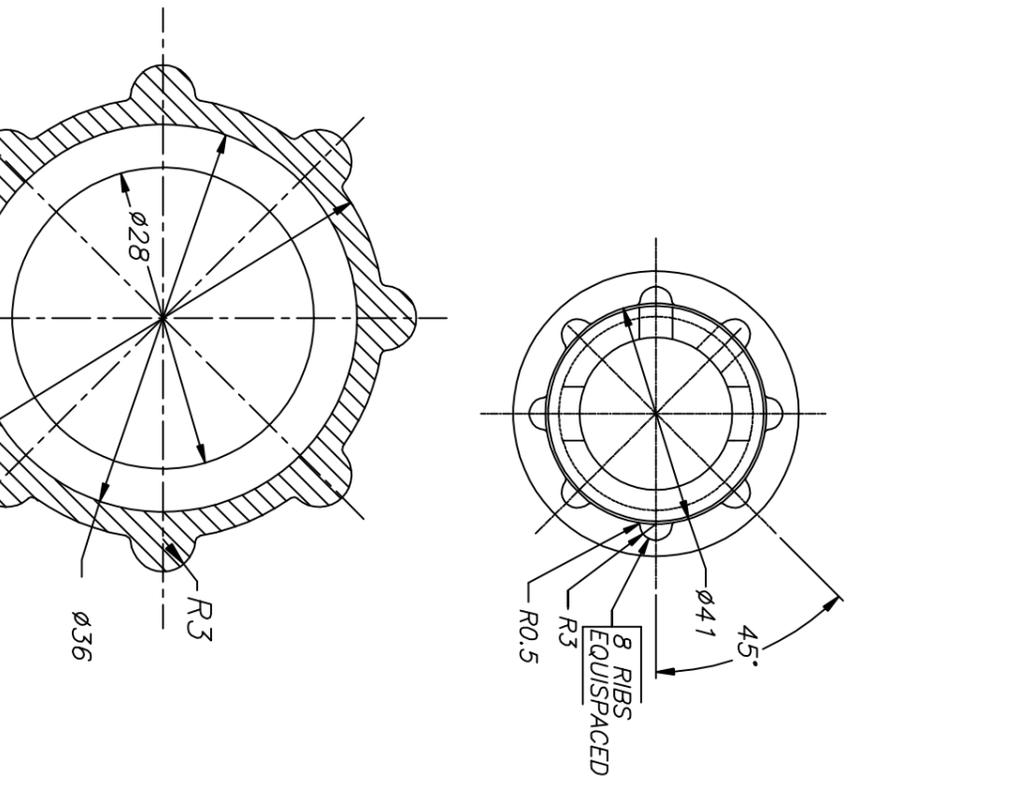
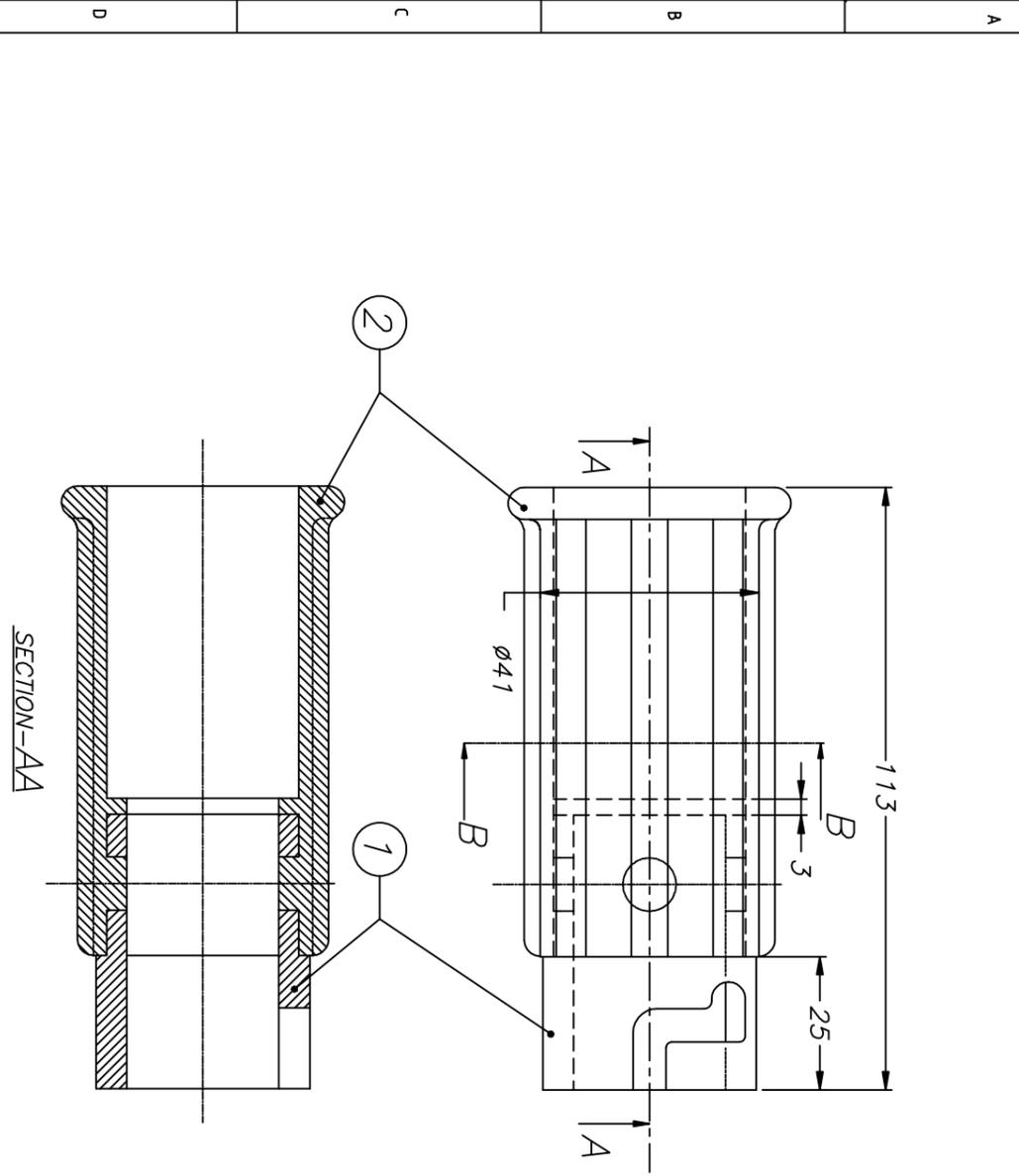
Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)	
SCALE:- NTS		QTY:- 1 No.		A D R D E AGRA	DRN.	SK SHARMA	PRO.OFFR./GP.OFFR		
DIMENSIONS IN mm				GROUP:- HDS	CHKD.	JC DUTTA	APPROVED		
TOL.: IS:2102(Pt-1)1980 MEDIUM EXCEPT WHERE OTHERWISE SPECIFIED				<b>LEVER</b> HOOK SUB ASSY QUICK RELEASE FASTENER HD SYSTEM FOR AN 32 A/C				PRO.DIR./GP.DIR	
MATERIAL: STEEL ALLOY 709M40/817M40,(EN19/EN24) AS PER BS:970								DRG. NO. ADRDE/1409- 02- 02	
FINISH:- AS PER SHEET No.1									
HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC									



NOTE :-  
 DIAMETER OF RIVET 'D' = 6.1mm  
 LENGTH OF RIVET 'L' = 18mm

PROCESS : COLD HEADING/FORGING  
 \* FOR DETAILS REFER IS:2155-1962

Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE:-NTS		QTY.1No.		ADRDE AGRA	DRN..	SK SHARMA		PRO.OFFR./GP.OFFR	
DIMENSIONS IN mm		GROUP:- HDS		CHKD.	JC DUTTA				
TOL.: IS:2102(Pt-1)1980 COARSE EXCEPT WHERE OTHERWISE SPECIFIED				RIVET (ROUND HEAD) HOOK SUB. ASSY. QUICK RELEASE FASTENER HD SYSTEM FOR AN 32 A/C			APPROVED		PROJ.DIR/GP.DIR
MATERIAL: STEEL ALLOY AS PER IS:1929		FINISH:- AS PER SHEET No.1					DRG. NO. ADRDE/1409- 02- 03		
HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC		HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC							



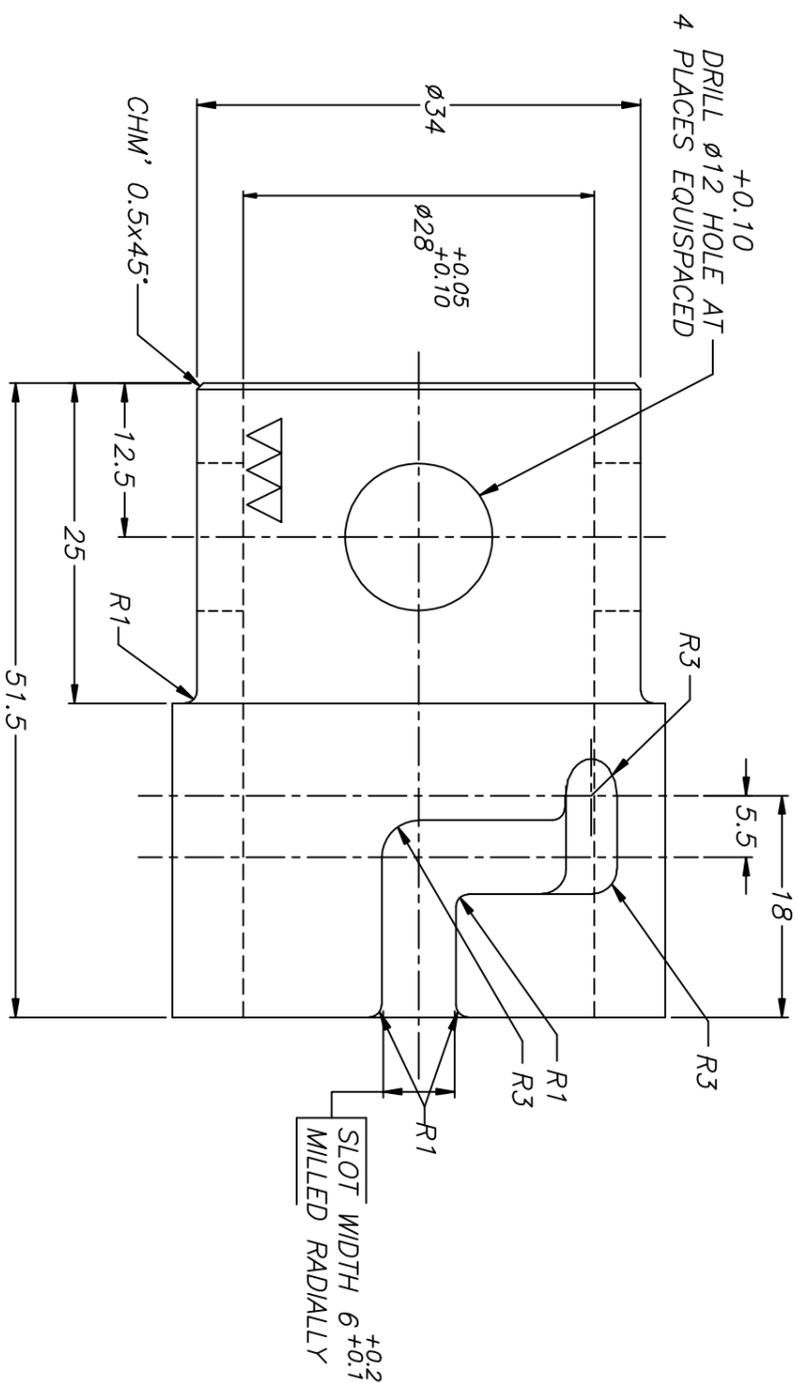
NOTE:-  
ROUND OFF ALL SHARP CORNERS TO RADIUS 0.2

ITEM No.	DRG./SPEC.No.	NOMENCLATURE	QTY	SHEET No.
2	ADRDE 1409 03 02	COVER	1	9
1	ADRDE 1409 03 01	BUSH	1	8

PROCESS : FABRICATION

R.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O I/C D&S	HEAD Q.A.
1						
2						
3						
4						

SCALE:- NTS	QTY :- 1 No.	A D R D E A G R A	DRN.	S K S H A R M A
DIMENSIONS IN mm		GROUP:- HDS	CHKD.	J C D U T T A
TOL:- IS:2102(PART1):1993 VERY COARSE UNLESS OTHERWISE SPECIFIED		HANDLE SUB ASSEMBLY QUICK RELEASE FASTENER (HD SYSTEM FOR AN-32A/C)		
MATERIAL: STEEL ALLOY 709M40/817M40.(EN119/EN24) AS PER BS:970		APPROVED		
FINISH:- AS PER SHEET No.1		PROJ DIR./GP OFFR		
HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC		DRG. NO. ADRDE/1409- 03		



NOTE:-  
 ROUND OFF ALL SHARP CORNERS TO RADIUS 0.2  
 PROCESS : MACHINING

Ref. NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O I/C	HEAD
1					D&S	G.A.

SCALE:- NTS	QTY :-	1 No.	A D R D E A G R A	DRN.	S K S H A R M A
DIMENSIONS IN mm	TOL:- IS:2102(PART1):1993 MEDIUM UNLESS OTHERWISE SPECIFIED		GROUP:- HDS	CHKD.	J.C.DUTTA
MATERIAL: STEEL ALLOY 709M40/817M40.(EN19/EN24) AS PER BS:970	FINISH:- AS PER SHEET No.1		BUSH HANDLE SUB ASSEMBLY QUICK RELEASE FASTENER (HD SYSTEM FOR AN-32A/C)		
HEAT TREATMENT:- HARDENED & TEMPERED 32±5HRC	APPROVED		PROJ.DIR./GROUP DIR.		
DRG. NO. ADRDE/1409 -03- 01					

1

2

3

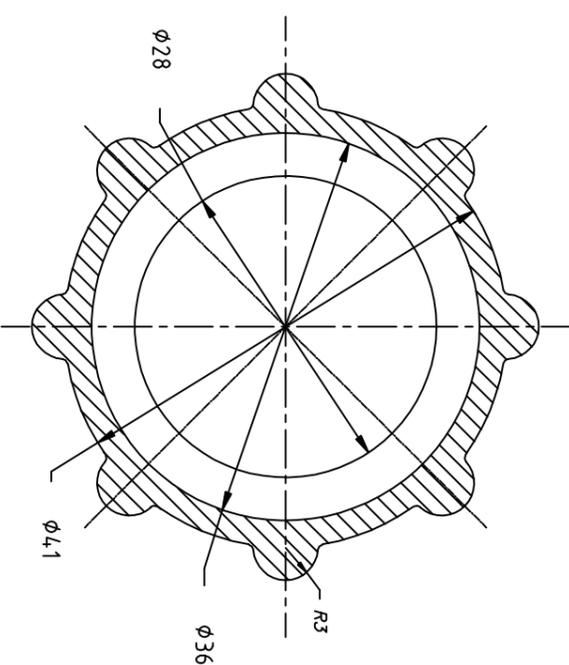
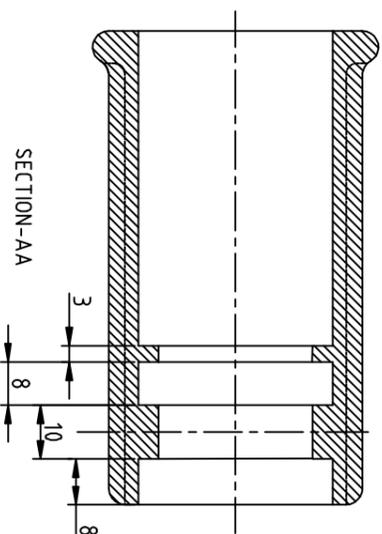
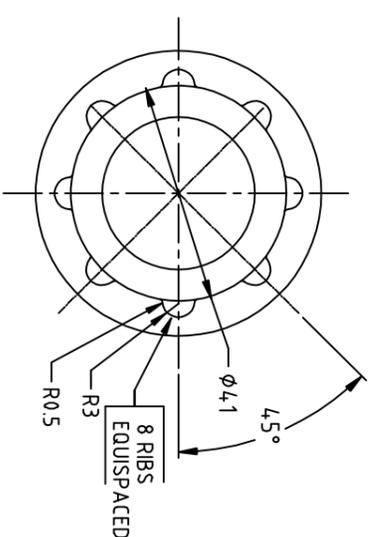
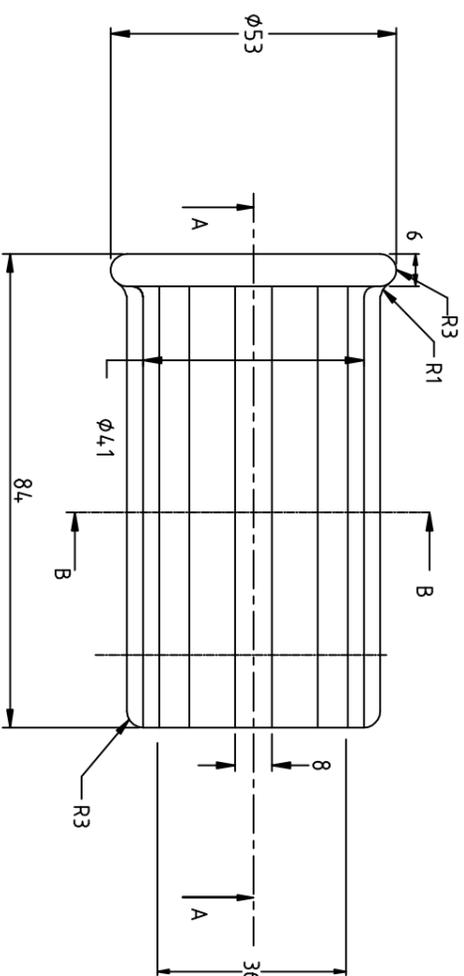
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NOTE :

COVER IS TO BE MOULDED OVER BUSH(DRG. No.1409-03-01) ON ASSEMBLY WITH PROPER DIE & FIXTURE.

SCALE:- NTS	QTY :- 1No.	A D R D E A G R A	DRN.	S K S H A R M A
DIMENSIONS IN mm		GROUP:- HDS	CHKD.	J C D U T T A
TOL:- IS:2102(PART1):1993 VERY COARSE UNLESS OTHERWISE SPECIFIED		<b>COVER</b> HANDLE SUB ASSEMBLY QUICK RELEASE FASTENER (HD SYSTEM FOR AN-32A/C)		
MATERIAL: COMMERCIALY AVAILABLE PLASTIC/ NYLON (BLACK/GREY COLOUR)				
FINISH:-		APPROVED		
HEAT TREATMENT:-		PROJ OFFR./GP OFFR		

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

DRG. NO.	APRDE/1409-03-02
PROJ.DIR./GROUP DIR.	