

VISUAL INSPECTION : THE FINISH COMPONENT SHALL BE FREE FROM TOOL MARKS AND ANY OTHER SURFACE DEFECTS.

PACKING :- EACH SHACKLE SHALL BE SEALED IN A POLYTHEYLENE BAG. 15 SUCH BAGS MAY BE PACKED IN A CCBC WITH SUITABLE LABEL.

MARKING : EACH SHACKLE SHALL BE MARKED AS: ADRDE / (YEAR OF MFG./ .. OF 15/SET...

05	SPLIT PIN 2 X 32	01	-	IS:549-1974
04	SPACER	01	05	1417 04
03	HEX. NUT	01	04	1417 03
02	HEX. BOLT	01	03	1417 02
01	BODY	01	02	1417 01
-	ASSEMBLY	01	01	1417
ITEM No.	NOMENCLATURE	QTY.	SHEET No.	DRG./ SPEC.No.

ITEM LIST

TOLERANCE :- AS PER IS:2102 (PART-D) 1993; MEDIUM UNLESS OTHERWISE SPECIFIED

PROOF LOAD TEST :- Samples may be tested for Proof Load test at 4000kgf.

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	<input type="checkbox"/> I/C HEAD (D&S)	HEAD (Q.A.)
1		2		3		4

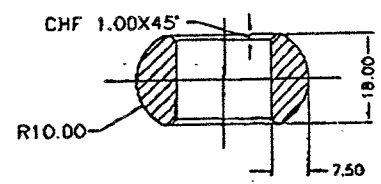
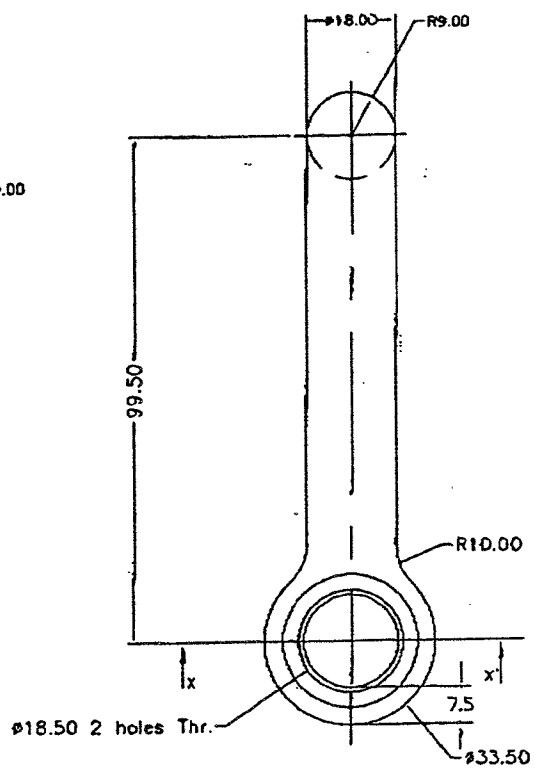
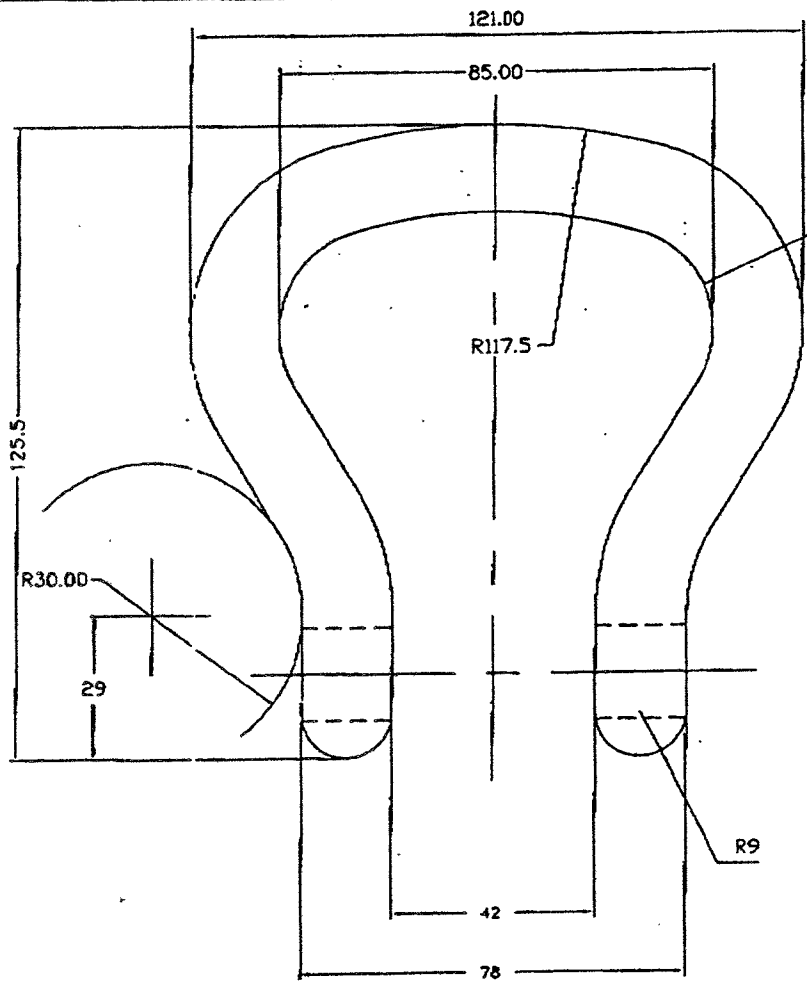
SCALE:- 1:1	QTY :- 1	A D R D E AGRA	DRN.	SK SHARMA	 PROJ.OFFR./GP OFFR
DIMENSIONS IN mm	TOL:- AS ABOVE	GROUP -HDS	CHKD.	J.C.DUTTA	
MATERIAL:-	FINISH:-	ASSEMBLY CLAMP (SHACKLE) CH D SYSTEM FOR AN-32 A/C			APPROVED
HEAT TREATMENT:-					 61764 PROJ. DIR./GP DIR
					DRG. NO. ADRDE /1417

0003

ADRDE

+05622251677

30/05 2018 2:26 PM FAX



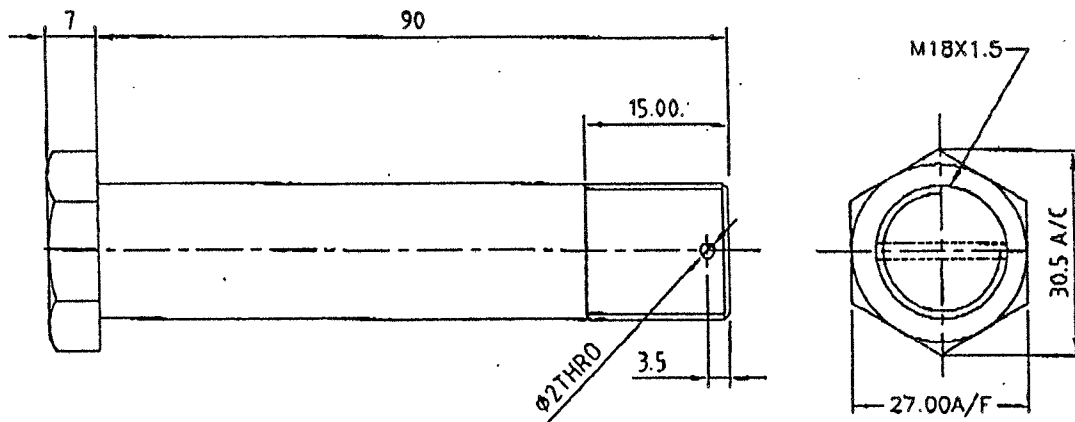
SECTION AT X-X'

MATERIAL : STEEL ALLOY EN19/24 (70%M40/817M40) AS PER BS 970
 FINISH : ZINC PLATED TO MINIMUM THICKNESS 12.5 MICRON
 & CHROMATE PASSIVATED TO IS 1573 : 1986 Gr.3 CL. Fe/Zn 12.5
 (STRESS RELIEF BEFORE PLATING, HYDROGEN EMBRITTLEMENT)
 TOLERANCE :- AS PER IS:2102 (PART-1) 1993; MEDIUM UNLESS OTHERWISE SPECIFIED
 PROCESS - FORGING

SCALE- 1:1	QTY - 1 No.	A D R D E AGRA	DRN.	SK SHARMA
DIMENSIONS IN mm		GROUP- HDS	CHKD.	J.C.DUTTA
TOL- AS ABOVE		BODY CLAMP(SHACKLE) (H D SYSTEM FOR AN-32 AXE)		
MATERIAL- AS ABOVE				
FINISH- AS ABOVE				
HEAT TREATMENT- 32 ±5 HRC				

APPROVED
 PRD.DIR./GP DIR
 DRG. NO. ADRDE/1417-01

Ref.NO.	DATE	ZONE	AUTHORITY	BRIEF RECORD	D I/C HEAD
1	2	3	4	5	6



MATERIAL : STEEL ALLOY EN19/24 (709M40/817M40) AS PER BS 970

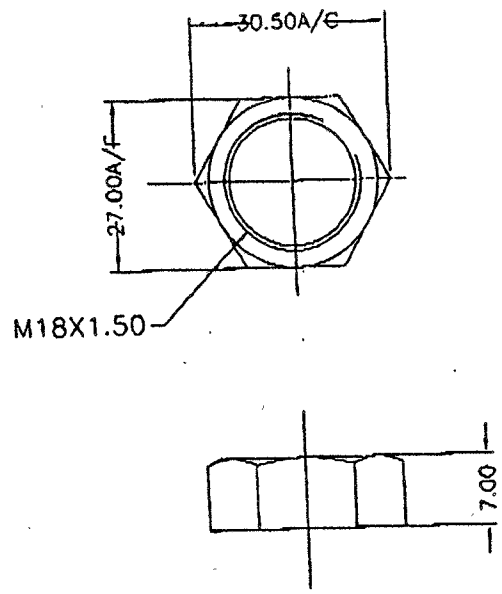
FINISH : ZINC PLATED TO MINIMUM THICKNESS 12.5 MICRON
& CHROMATE PASSIVATED TO IS 1573 : 1986 Gr.3 CL. Fe/Zn 12.5
(STRESS RELIEF BEFORE PLATING, HYDROGEN EMBRITTLEMENT)

TOLERANCE:-IS:2012 (PART-1) 1993 MEDIUM UNLESS OTHERWISE SPECIFIED.

PROCESS - FABRICATION/MACHINING

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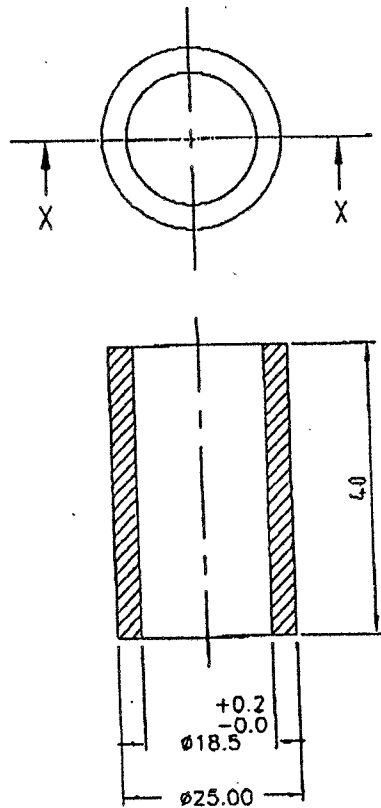
Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O I/C (D&S)	HEAD (Q.A.)
SCALE : 1:1	QTY:- 1No.		A D R D E A G R A	DRN.	SK SHARMA		<p><i>Anshu Patel</i></p> <p>PROJ.OFFR./GP OFFR</p> <p>APPROVED</p> <p><i>[Signature]</i></p> <p>PROJ.DIR./GP DIR</p> <p>DRG. NO. ADRDE/1417-02</p>	
DIMENSIONS IN mm			GROUP:- HDS	CHKD.	JC DUTTA			
TOL. :- AS ABOVE			<p>HEX BOLT CLAMP(SHACKLE) (H D SYSTEM FOR AN-32 A/C)</p>					
MATERIAL:- AS ABOVE								
FINISH:- AS ABOVE								
HEAT TREATMENT:- 32±5 HRC								



MATERIAL : STEEL ALLOY EN19/24 (709M40/817M40) AS PER BS 970
 FINISH : ZINC PLATED TO MINIMUM THICKNESS 12.5 MICRON
 & CHROMATE PASSIVATED TO IS 1573 : 1986 Gr.3 CL. Fe/Zn 12.5
 (STRESS RELIEF BEFORE PLATING, HYDROGEN EMBRITTLEMENT)

TOLERANCE:-IS:2012 (PART-1) 1993 MEDIUM UNLESS OTHERWISE SPECIFIED.
 PROCESS - FABRICATION/MACHINING

Ref.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD			O/C (C.S.)	HEAD (C.A.)
SCALE: 1:1	QTY:- 1 No.		ADR DE AGRA	DRN.	SK SHARMA		<i>Anshu Patel</i>	PROJ.OFFR./GP OFFR
DIMENSIONS IN mm			GROUP:- HDS	CHKD.	JC OUTTA			
TOL.:- AS ABOVE			HEX. NUT CLAMP(SHACKLE) (H D SYSTEM FOR AN-32 A/C)			APPROVED		<i>Anshu Patel</i> PROJ.OIR./GP DIR
MATERIAL:- AS ABOVE						DRG. NO. ADRDE/1417-03		
FINISH:- AS ABOVE								
HEAT TREATMENT:- 32±5 HRC								



MATERIAL : STEEL ALLOY EN19/24 (709M40/817M40) AS PER BS 970
 FINISH : ZINC PLATED TO MINIMUM THICKNESS 12.5 MICRON
 & CHROMATE PASSIVATED TO IS 1573 : 1986 Gr.3 CL. Fe/Zn 12.5
 (STRESS RELIEF BEFORE PLATING, HYDROGEN EMBRITTLEMENT)

TOLERANCE:-IS:2012 (PART-1) 1993 MEDIUM UNLESS OTHERWISE SPECIFIED.
 PROCESS - FABRICATION/MACHINING

Ref.No.		DATE	ZONE	AUTHORITY	BRIEF RECORD		O I/C (D&S)	HEAD (D.A.)
SCALE : 1:1		QTY:- 1No.		A O R D E AGRA	DRN.	SK SHARMA	<p style="text-align: right;"><i>Anshu Patel</i></p> <p style="text-align: right;">PROJ.OFFR./GP OFFR</p> <p style="text-align: center;">APPROVED</p> <p style="text-align: center;"><i>[Signature]</i></p> <p style="text-align: right;">PROJ.DIR./GP DIR</p> <p style="text-align: center;">DRG. NO. ADRDE/1417-04</p>	
DIMENSIONS IN mm		GROUP:- HDS		CHKD.	JC DUTTA			
TOL :- AS ABOVE		<p>SPACER</p> <p>CLAMP(SHACKLE)</p> <p>(H D SYSTEM FOR AN-32 A/C)</p>						
MATERIAL:- AS ABOVE								
FINISH:- AS ABOVE								
HEAT TREATMENT:-		32±5 HRC						