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मंत्रालय द्वारा जारी  
App. के अन्तर्गत रक्षा  
Vide Ministry of Defence  
SSSC



30/11/13  
रक्षा मंत्रालय (सक.सं.सं.)  
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मानकीकरण निदेशालय  
Directorate of Standardisation  
रक्षा मंत्रालय, नई दिल्ली,  
Min. of Defence, New Delhi-11

रक्षा मंत्रालय  
MINISTRY OF DEFENCE

ज्वाइंट सर्विस स्पेसिफिकेशन  
JOINT SERVICES SPECIFICATION

ON

SLIDING BAR BUCKLE  
(DS Cat No. 1670 - 000 123)

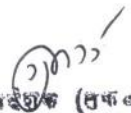
मानकीकरण निदेशालय  
रक्षा उत्पादन विभाग, रक्षा मंत्रालय,  
'एच' - ब्लॉक, निर्माण भवन डाकघर  
नई दिल्ली - 110 011

DIRECTORATE OF STANDARDISATION  
DEPARTMENT OF DEFENCE PRODUCTION  
MINISTRY OF DEFENCE, 'H' - BLOCK,  
NIRMAN BHAVAN, P.O.  
NEW DELHI - 110 011

**LIST OF MEMBERS ASSOCIATED WITH FORMULATION OF THIS STANDARD**

1. This Joint Services Specification has been approved by Shri Sanjeev Kapur Addl DGQA (S), Chairman, Stores Standardisation Sub Committee.
2. The following members have been associated in preparing the document :-

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 रक्षा मंत्रालय, नई दिल्ली,  
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**RECORD OF AMENDMENTS**

Amendment		Amendment pertains to SI. No. / Para No. / Column No.	Authority	Amended by Name & Appointment (IN BLOCK LETTERS)	Signature & Date
No.	Date				



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रक्षा मन्त्रालय, नई दिल्ली  
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0.0 **FOREWORD**

0.1 This specification has been prepared by the Stores Standardisation Sub Committee on the authority of Standardisation Committee, Ministry of Defence.

0.2 This specification has been approved by the Ministry of Defence and is mandatory for use by the Defence Services.

0.3 This specification has been prepared based on Departmental specification No. IND / GS / 1717 (a) and supersedes the same.

0.4 This specification would be used for Manufacture, Quality Assurance and Procurement of the item.

0.5 Quality Assurance Authority for the item covered by this specification is The Controller, CQA (GS), DGQA Stores Complex, Ashok Path, Cantt Kanpur - 208 004 for Army, Navy and Air Force. Enquiries regarding technical parameters shall be addressed to the Quality Assurance Authority, while other enquiries shall be referred to :-

The Director,  
Directorate of Standardisation,  
Ministry of Defence,  
'H' Block, Nirman Bhavan PO,  
New Delhi – 110 011

0.6 Non - registered users can obtain the following on payment :-

(a) **Copies of IS from :-**

Bureau of Indian Standards,  
Manak Bhavan,  
9, Bahadur Shah Zafar Marg,  
New Delhi – 110 002

or  
their regional / branch offices

(b) **Copies of JSS / JSG from :-**

The Director,  
Directorate of Standardisation,  
Standardisation Documents Centre  
Ministry of Defence  
Room No.05, 'J' Block,  
Nirman Bhavan PO,  
New Delhi – 110 011

0.7 Indian Standard (IS) specifications are available free of cost for registered users on :

Directorate of Standardisation Website : -

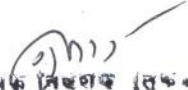
[www.defstand.gov.in](http://www.defstand.gov.in)

for registration visit our website.

0.8 This specification holds good only for the supply order for which it is issued.

0.9 **Directorate of Standardisation Website.** All the approved JSSs / JSGs are available on the Directorate of Standardisation Website [www.defstand.gov.in](http://www.defstand.gov.in) Defence organisations desirous of accessing a copy of this document are requested to approach the Directorate of Standardisation for obtaining user id / password to access the website.



  
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## 1.0 SCOPE

1.1 This specification covers the requirement of Sliding Bar Buckle (DS Cat. No. 1670 – 000 123) and provides guidance to Contractors / Suppliers, Manufacturers, Quality Assurance Agencies and Stockiest / Indentors etc.

## 2.0 RELATED SPECIFICATIONS

Srl. No	Specification No	Title / subject
(a)	IS 1573 : 1986 (Second Revision) Reaffirmed - 2010	Specification for Electroplated Coatings of Zinc on Iron and Steel
(b)	IS 1875 : 1992 (Fifth Revision) (Reaffirmed - 2009) Amd - 2	Carbon steel billets, Blooms, slabs and bars forgings
(c)	IS 2102 : Part 1 : 1993 (Third Revision) Reaffirmed - 2008	General Tolerances : Part 1 : Tolerances for Linear and angular dimensions without individual tolerance indications
(d)	IS 2500 : Part 1 : 2000 (Third Revision) Reaffirmed - 2011 Amd - 1	Sampling Procedure for Inspection by Attributes : Part 1 : Sampling schemes Indexed by Acceptance Quality Limit (AQL) for Lot - by - Lot Inspection
(e)	IS 2771 : Part 1 : 1990 (Second Revision) Reaffirmed - 2008 Amd - 3	Corrugated Fibreboard Boxes – Specification : Part 1 : General Requirements
(f)	IS 4185 : 1989 (First Revision) Reaffirmed - 2010	Adhesive Paper Tapes - Specification
(g)	IS 4905 : 1968 Reaffirmed - 2011 Amd - 1	Methods for random sampling
(h)	JSS 8115 – 01 : 2007 (Revision No. 3) Amd - 1 & SS No. CIGS / SS / 27 (e).	Boxes Rigid Collapsible Cover Type 'D'
(j)	JSS 8135 - 10 : 2004 (Revision No. 1) Reaffirmed - 2011 Amd - 1	Polypropylene Strapping, 12 mm Wide

Srl. No	Specification No	Title / subject
(k)	JSS 9330 - 02 : 2008 (Revision No. 2) & Supp. Sch. No. CIGS / SS / 313 (a)	Polythene Bag 0.04 mm thickness
(l)	U / S Spech No. CIGS / US / 239.	Label Carton 50 x 25 mm
(m)	0.89 mm thick, Average Bursting Strength 775 kPa based on atleast five tests.	Label Card Board 45 x 25 mm with tie – on – tag

2.2 Copies of this IND / GS specification can be obtained on payment from :-

The controller,  
 Controllerate of Quality Assurance (General Stores),  
 DGQA Stores Complex, Ashok Path  
 Kanpur – 208 004 (U.P.)

### 3.0 STANDARD PATTERN

3.1 Standard pattern of Sliding Bar Buckles (DS Cat no. 1670–000123) held by the Purchase Officer shall be constitute the standard as regards any particulars or properties, not noted or defined in this specification.

### 4.0 MATERIAL

4.1 The item shall be manufactured from the following materials: -

Sl. No.	Store component	Material & Grade if any	Specification
(a)	Complete Store	C - 20 Carbon Steel	IS 1875:1992

4.2 Test certificates of materials from recognised laboratories shall be obtained showing physical and chemical properties if the manufacturer does not have his own laboratory.

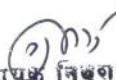
### 5.0 PROCESSING

5.1 The Sliding Bar Buckle shall be manufactured to the shape and design as shown in the relevant plate attached to this specification.

5.2 The buckle and bar shall be electroplated as per classification No. Fe / Zn 12.5 (service grade No. 3) of IS 1573:1986.

5.3 All the sharp edges shall be removed. Ends of the Bar shall be chamfered having 6 (six) parallel small 0.5 mm deep, V cuts lengthwise Knurling on bar shall be coarse, pronounced, cross square type.



  
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 Joint Director (T.C.)  
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 Directorate of Standardisation  
 रक्षा मंत्रालय, नई दिल्ली,  
 Min. of Defence, New Delhi-110

## 6.0 DIMENSIONS AND TOLERANCES

### 6.1 Dimensions

6.1.1 The store shall conform to the dimension shown in the plate attached to this specification.

### 6.2 Tolerances

6.2.1 Unless otherwise specified, general tolerances to IS2102 : Part - I:1993 as given below shall apply.

Tolerance	class	
Designation	Description	Applicable on components / parts
C	Coarse	Complete store

## 7.0 WORKMANSHIP AND FINISH

7.1 Surface of all Sliding Bar Buckle shall be free from pits, burrs, chipping, blisters, bare surface and deformation.

7.2 All the sharp edges be removed.

7.3 Parallel movement of bar in sliding buckle from one end to other shall be smooth.

7.4 The general workmanship and finish shall be of a high standard and similar to sealed pattern.

## 8.0 PRE - INSPECTION OF SUPPLIES BY THE PRODUCER

8.1 Manufacturers / contractors must satisfy themselves that the stores are in accordance with the terms of the contract and fully conform to the required specification by carrying out a thorough pre - inspection of each lot before actually tendering the same for inspection to the Quality Assurance Officer nominated under the terms of the contract. A declaration by the contractor that the necessary pre - inspection has been carried out on the stores tendered, will be submitted alongwith the challan. The declaration will also indicate the method followed in carrying out pre - inspection showing the features checked / tested and will have the test certificate attached to the challan / declaration.

8.2 If the Quality Assurance Officer finds that pre - inspection of the consignment as required above has not been carried out, the consignment is liable for rejection.

## 9.0 QUALITY ASSURANCE

9.1 Examination of samples taken from portion of the consignment or during surveillance inspection shall conform to the requirement when tested in accordance with the methods mentioned against each in this specification.

(2013)

उत्पादक निदेशक (तक-उपम-३)  
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India of Delhi-110002, New Delhi-11

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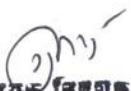
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 सहायक निदेशक (सक.स.स.),  
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 India of Delhi, New Delhi-110

### 12.5 Sampling and Formation of Lot

12.5.1 The delivery shall be visually inspected by the Quality Assurance Officer at the spot in the first instance to ascertain its homogeneity in respect of nature, size, shape, source and year of manufacture. If it is homogeneous, the delivery shall be treated as one lot. If not, it shall be segregated by the supplier into separate groups so that each group which is homogeneous within itself forms a lot.

### 12.6 Sampling Tables

**TABLE - I**

**GENERAL INSPECTION LEVEL - II, AQL 2.5 %  
BASED ON TABLE - IIA FOR VISUAL EXAMINATION / INSPECTION**

Lot Size	Sample Size (n)	Acceptance Number (Ac)
Up to 50	8	1
51 to 90	13	1
91 to 150	20	1
151 to 280	32	2
281 to 500	50	3
501 to 1200	80	5
1201 to 3200	125	7
3201 to 10000	200	10
10001 to 35000	315	14

**TABLE II**

**SPECIAL INSPECTION LEVEL S - 3 AND S - 4, AQL 2.5 %  
BASED ON TABLE - IIA FOR LABORATORY TESTING**

Lot Size	Sample Size (n)		Acceptance Number (Ac)	
	S - 3	S - 4	S - 3	S - 4
Up to 50	3	5	0	0
51 to 90	5	5	0	0
91 to 150	5	8	0	1
151 to 280	8	13	1	1
281 to 500	8	13	1	1
501 to 1200	13	20	1	1
1201 to 3200	13	32	1	2
3201 to 10000	20	32	1	2
10001 to 35000	20	50	1	3



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Directorate of Standardisation  
एन.डी.ए. मन्त्रालय, नई दिल्ली,  
Min. of Defence, New Delhi.

Note –

- (1) When the sample size equals to lot size, do 100 % inspection /Non -destructive testing with zero acceptance number.
- (2) The rejection number (Re) will always be one more than the acceptance number (Ac).
- (3) Level S - 3 for Chemical tests (Individual samples to be tested).
- (4) Level S - 4 for physical tests (Individual samples to be tested).

Source : IS 2500 (Part 1) : 2000, (Third Revision), (Reaffirmed - 2011), (Amd - 1), Sampling inspection procedure : Part 1 : Attribute Sampling plan Indexed by Acceptable Quality Limit (AQL) for Lot - by - Lot Inspection.

12.7 Test Methods

12.7.1 Physical Tests: Design, shape and dimension.

12.7.2 Chemical Test: Chemical analysis, thickness / amount of plating / coating

12.7.3 Performance Test

12.7.3.1 Performance Test–Sliding Bar Buckle shall be subjected to performance test using web Nylon 44 mm width  $\pm$  1.5 mm undyed with thickness 1.1 mm (min) and 2.0 mm (max) having breaking load 17800 N (1815 Kg), at load of 500 kg (4980 N) for a period of 10 seconds minimum. Web Nylon shall not show any slipping during the test.


12.7.3.2 Proof Load Test– The Sliding Bar Buckle shall be subjected to proof load of 500 kg (4980 N). The load shall be gradually increased and maintained at 500 kg (4980 N) for not less than 10 seconds. After removal of the load the buckle shall be left for 10 seconds and then be measured for permanent set. The buckle shall not show any sign of damage / deformation or permanent set more than 0.15 mm after completion of proof load test.

13.0 MARKING

13.1 Marking by The Supplier

13.1.1 The store shall be embossed legibly and indelibly marked with the following details as shown in the plate attached to this specification: -

- (a) Manufacturer's name, initials or recognised trade mark.
- (b) The year of manufacture.
- (c) D.S.Catalogue number of the store.

  
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13.2 Marking by the Quality Assurance Officer

13.2.1 Each accepted store shall be legibly and indelibly marked using stencil plate or Rubber / Steel stamp of letter size 6 mm depending upon the size of store / component.

13.2.2 In case of small components, where steel stamping or stenciling is not possible, the rubber acceptance mark shall be stamped on individual packages containing the items for this purpose each package shall be sealed by a continuous piece of gummed tape such that ends overlap each other. Acceptance marks shall be affixed on the joint of the tape end partly covering the package.

13.3 The final rejections may be marked by Quality Assurance Officer by stamping the letter 'x' on both sides of manufacturer's marking thus : -

1670 – 000123  
 X Frims Name X  
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14. PACKAGING

14.1 Packing

Sl. No.	Material	Confirming to
(a)	Polythene Bag 0.04 mm thickness	JSS 9330 - 02 : 2008 (Revision No. 2) & Supp. Sch. No. CIGS / SS / 313(a)
(b)	Boxes Rigid Collapsible Cover Type 'D'	JSS 8115 – 01 : 2007 (Revision No. 3) Amd - 1 & SS No. CIGS / SS / 27(e).
(c)	Adhesive Paper Tapes	IS 4185 : 1989 & CIGS / SS / 185(b)
(d)	Boxes Corrugated Fibre Board	IS 2771 : Part -1 : 1990 & SS No CQA (GS) / SS / 290
(e)	Polypropylene Strapping 12 mm wide	JSS 8135 - 10 : 2004 (Revision No. 1) Reaffirmed - 2011 Amd - 1
(f)	Label Carton 50 x 25 mm	U / S Spech No. CIGS / US / 239.
(g)	Label Card Board 45 x 25 mm with tie - on - tag	0.89 mm thick, Average Bursting Strength 775 kPa based on atleast five test



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14.2 Method

14.2.1 Each Sliding Bar shall be individually packed in polythene bag 0.04 mm thick sheet. Ten such pack shall be kept in one carton (Box Rigid) of suitable size and then sealed with Adhesive Paper tape and stamped with acceptance mark. Fifteen such cartons shall be packed in a corrugated fibre board box 5 ply of suitable size. Finally the box shall be strapped suitably spaced at two places lengthwise and at two places width wise.

14.2.2 Each package shall be affixed with a label carton 50 x 25 mm bearing, D.S. Cat No., Nomenclature, Qty packed and year of manufacture. The label shall be coated by Varnish clear.

14.2.3 One item of each package shall be tied with label card board 45 x 25 mm bearing Cat No. and Nomenclature of the store.

14.2.4 Each final package shall be strapped at two places as mentioned below :-

Box Fiber Board, Corrugated - Polypropylene strapping.

14.2.5 Mass of any Box, Fiber Board, Rigid Corrugated shall not exceed 25 kg. In order to maintain the limit of mass, the number of items in the package may be altered at the discretion of the QAO.

14.3 Marking on Package

14.3.1 Each final package shall be legibly and indelibly marked as under.

- (a) D.S. Cat. No. and designation of the store.
- (b) Qty packed, preceded by the abbreviation 'QTY'
- (c) Name and address of the consignee as given in the contract.
- (d) Mass of the package in Kilogram preceded by the abbreviation 'kg'.
- (e) Number of the individual package and total number of packages in the consignment i.e. 1 of 4, 2 of 4, 3 of 4 and 4 of 4 when the consignment consists of 4 packages.
- (f) Consigner's name, initials or recognised Trade Mark.
- (g) Month and year of packing.
- (h) Acceptance of Tender, Supply Order or Extract No. and Date.
- (j) Inspection Note No. and date.

15. TECHNICAL LITERATURE

15.1 Illustrated spare parts list History sheet / maintenance manual shall be supplied with each store wherever required / demanded.

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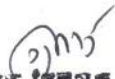
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 Asst. Director (T.C.)  
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 Directorate of Standardisation  
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 Min of Defence, New Delhi-110 011

16.0 **WARRANTY**

16.1 Stores supplied against this specification shall be deemed to bear the warranty of contractor against defective design material, workmanship and performance for period of twelve months from the date of receipt of store at consignee end. If during the specified period, the store supplied is found to be defective, the same shall be replaced immediately with serviceable store by the contractor at site free of any charges as may be decided by the purchasing officer, on recommendation of consignee / Quality Assurance Authority.

17.0 **DEFENCE STORE CATELOGUE NUMBER**

17.1 The store covered by this specification shall bear the following DS Cat No.

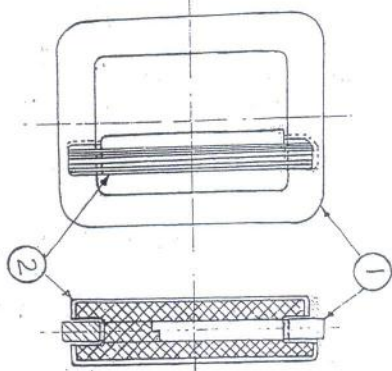
Sl. No.	DS Cat No.	Nomenclature
(a)	DS Cat.No.1670 – 000 123	Sliding Bar Buckle

18.0 **SUGGESTIONS FOR IMPROVEMENT**

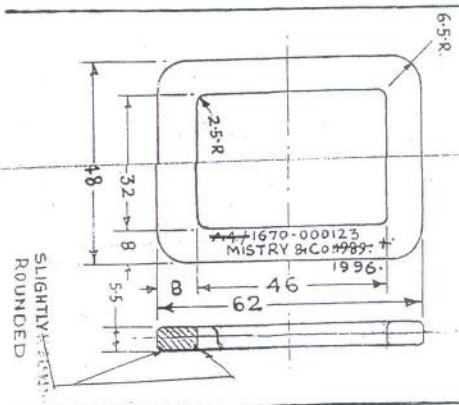
18.1 Any suggestion for improvement in this document may be forwarded to :-

The Director,  
 Directorate of Standardisation,  
 Ministry of Defence,  
 'H' Block, Nirman Bhavan PO,  
 New Delhi - 110 011.

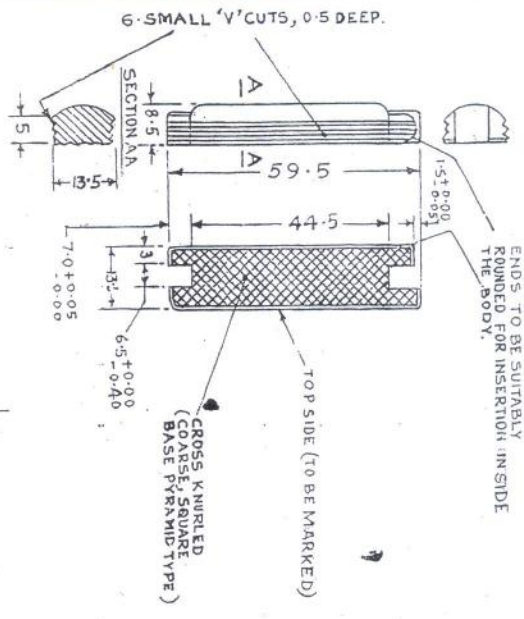
ASSEMBLY



BODY  
1-OFF



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1-OFF



NOTES:-  
(1) A TOLERANCE IS ALLOWED AS PER FIGURE 1670-000123 MISTRY & Co. 1996. DIMENSIONS INDICATED, PROVIDED, DOES NOT INTERFERE WITH THE DIMENSIONS OF SLOTS.

(2) ALL SHARP EDGES TO BE SLIGHTLY ROUNDED OFF

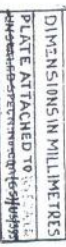
MATERIAL: C-20 CARBON STEEL TO IS-1675  
PROF. LOAD: 4980 NEWTONS

APPROVED	DATE	NAME
<i>[Signature]</i>		
CHIEF D/MAN		
PASSED BY		
9/6-5		
D. C. (18)		

STORAGE No.  
393

SCALE: 1:1  
SLIDING BAR BUCKLE

C. Q. A. (GS)  
KANPUR



DIMENSIONS IN MILLIMETRES  
PLATE ATTACHED TO...