

CONTROL COPY No. 1

3-POINT SLING FOR
J.V.P.C 5.56x30mm
0204 04 03 00 00 000 00DA

QRB AND STRAP PULLING
ASSEMBLY
0204 04 03 00 01 000 00DA

STRAP PULLING ASSEMBLY
0204 04 03 01 03 000 00DA

HOOK SLING ASSEMBLY
0204 04 03 00 02 000 00DA

SL. NO.	DWG. NO.	NOMENCLATURE	QTY.	SL. NO.
1	0204 04 03 00 00 001 00DA	SLIDING BUCKLE	1	1

2	IS: 4727- 1968- TYPE-2	STEEL GREY (COLOUR NO. 698 TO IS:5-2007) NYLON WEBBING 30.0WIDTH x 2.0 THICK x 170.0 LENGTH	1	2
---	------------------------	---	---	---

3	IS: 4727- 1968- TYPE-2	OLIVE GREEN (COLOUR NO. 220 TO IS:5-2007) NYLON WEBBING 30.0WIDTH x 1.0 THICK x 65.0 LENGTH	2	3
---	------------------------	---	---	---

1	IS: 4727- 1968- TYPE-2	STEEL GREY (COLOUR NO. 698 TO IS:5-2007) NYLON WEBBING 30.0WIDTH x 2.0 THICK x 300.0 LENGTH	1	4
---	------------------------	---	---	---

2	STD. COMPONENT	QUICK RELEASE BUCKLE (QRB)	1	5
---	----------------	----------------------------	---	---

1	0204 04 03 00 02 001 00DA	HINGE HOUSING HOOK SLING	2	6
---	---------------------------	--------------------------	---	---

2	0204 04 03 00 02 002 00DA	HOOK SLING	2	7
---	---------------------------	------------	---	---

3	0204 04 03 00 02 003 00DA	RING LOCKING PLUNGER HOOK SLING	2	8
---	---------------------------	---------------------------------	---	---

4	0204 04 03 00 02 004 00DA	HOUSING HOOK SLING	2	9
---	---------------------------	--------------------	---	---

5	0204 04 03 00 02 005 00DA	PIN HINGE HOOK SLING	2	10
---	---------------------------	----------------------	---	----

6	0204 04 03 00 02 006 00DA	SPRING PLUNGER HOOK SLING	2	11
---	---------------------------	---------------------------	---	----

7	0204 04 03 00 02 007 00DA	PLUNGER HOOK SLING	2	12
---	---------------------------	--------------------	---	----

1	0204 04 03 00 00 001 00DA	SLIDING BUCKLE	2	R
---	---------------------------	----------------	---	---

1	IS: 4727- 1968- TYPE-2	STEEL GREY (COLOUR NO. 698 TO IS:5-2007) NYLON WEBBING/ STRAP LENGTH 2200.0	1	13
---	------------------------	---	---	----

DESIGN AUTHORITY
ARDE
PUNE 411021

DRN.
SD
APPD.
DATE 05/10/18
SEALED
DATE
CHD.
For Director

3-POINT SLING FOR J.V.P.C. 5.56x30mm

List of Assemblies & Components for 3-Point Sling for JVPC

Sr. No.	Component	Drawing Number	Qty Each
1.	3-Point Sling for JVPC 5.56x30mm	0204 04 03 00 00 000 00DA	1
2.	QRB And Strap Pulling Assembly	0204 04 03 00 01 000 00DA	1
3.	Strap Pulling Assembly	0204 04 03 01 03 000 00DA	1
4.	Sliding Buckle	0204 04 03 00 00 000 00DA	1
5.	Steel Gray (Colour No. 698 to IS : 5 -2007) Nylon Webbing 30.0 Width x 2.0 Thick x 170.0 Length	IS : 4727-1968 Type-2	1
6.	Olive Green (Colour No. 220 to IS : 5 -2007) Nylon Webbing 26.0 Width x 1.0 Thick x 65.0 Length	IS : 4727-1968 Type-2	1
7.	Steel Gray (Colour No. 698 to IS : 5 -2007) Nylon Webbing 30.0 Width x 2.0 Thick x 300.0 Length	IS : 4727-1968 Type-2	1
8.	Quick Release Buckle (QRB)	Standard Component	1
9.	Hook Sling Assembly	0204 04 03 00 02 000 00DA	1
10.	Hinge Housing Hook Sling	0204 04 03 00 02 001 00DA	2
11.	Hook Sling	0204 04 03 00 02 002 00DA	2
12.	Ring Locking Plunger Hook Sling	0204 04 03 00 02 003 00DA	2
13.	Housing Hook Sling	0204 04 03 00 02 004 00DA	2
14.	Pin Hinge Hook Sling	0204 04 03 00 02 005 00DA	2
15.	Spring Plunger Hook Sling	0204 04 03 00 02 006 00DA	2
16.	Plunger Hook Sling	0204 04 03 00 02 007 00DA	2
R	Sliding Buckle	0204 04 03 00 00 000 00DA	2
17.	Steel Gray (Colour No. 698 to IS : 5 -2007) Nylon Webbing 30.0 Width x 2.0 Thick x 300.0 Length	IS : 4727-1968 Type-2	1

Specification on Three Point Sling Assembly for JVPC 5.56X30mm (Drawing No. 0204 04 03 00 00 000 00DA)

1. Scope: This specification serves the manufacture, assembly and inspection of sling assembly.

2. Components: The details of the components required for the manufacture shall be used only as a guide to workmanship and as a guide to detail.

2.1 Components for Sling Assembly:

See Appendix 'A'

3. MATERIAL

3.1 The Nylon Webbing Sling Assy shall be of Steel Grey Colour. The width and thickness shall be 30mm X 2.0 mm (ref Specification IS: 4727 type 2:1968).

3.1 Nylon 6 or Nylon 66 yarn should be used in the manufacture of webbing.

3.2 The finished webbing should be clean, even and well woven with firm and regular selvages. The webbing should be free from weaving defects and stains. The dyed webbing should be of uniform shade.

3.3 The webbing shall comply with the requirements given below:

1) Ends in full length	95-110	Each comprising of two yarns and 8/9 binders single
2) Picks/dm	80-95	Each comprising of two yarns
3) Denier of Yarns	Single	Warp -1200-1500. Weft-800-900
4) Tenacity of Yarn	g/denier	Warp- 6.5-9. Weft- 6.5.-9
5) Weight (max)	g/m	45
6) Width	m/m	30.0+1.0/ -0.5 (after dyeing)
7) Thickness	m/m	2.1max.1.95min (after dyeing)
8) Breaking Load	kg	1000 min
9) pH Value		between 6 & 8
10) Colour fastness to washing (ref IS: 764)		Change in Color –Rating 4

Staining in Nylon –Rating 4/5

11) Colour

Steel Grey (No.698) to IS:5-2007

3.4 The effective length 'L' should be as specified in the drawing. It should be ensured that the both ends of the webbing of length 'L' are properly and evenly heat sealed.

3.5 Material for Metallic Components of Sling Assembly should be as per specifications mentioned in the respective drawing of the components.

3.6 Use of scrap material spruces and runners for production of components is prohibited.

4. MANUFACTURE

4.1 The dimension and form of the store and its components are to be in conformity with the drawings used. The Manufacturer should prepare and supply to the AHSP/QA Officer the process schedule which is to be followed for the Manufacture of the store and its components. Any subsequent change in the process schedule should be notified to the AHSP/QA Officer in advance in writing.

4.2 Neither the completed store nor any component part shall be altered or rectified in any way not provided for in the drawing or specification without the prior sanction of the AHSP/QA Officer in writing.

4.3 Where the drawing or the specification permits a choice of alternative materials or forms for particular components. The manufacturer is required to notify the AHSP/QA Officer in writing. Which of the permitted alternatives he choose to produce. If the choice of alternatives is changed during the course of the order the manufacturer shall again notify the AHSP/QA Officer of such changes.

4.4 No mechanical work heat treatment or other operation which may modify the physical properties of the material will be carried out after it has been submitted for mechanical tests unless authorized by the AHSP/QA Officer in writing.

5. Nylon Webbing: The Nylon Webbing of the Sling Assembly is to be manufacture as per specification IS: 4727 type 2: 1968.

5.1 The Nylon webbing must be manufactured from material judged by the AHSP/QA Officer to satisfy the relevant material specification.

5.2 The actual details of the processed for manufacture of the Nylon webbing will be intimated by the manufacturer to the AHSP/QA Officer.

5.3 During manufacture samples of Nylon webbing may be taken by the Inspecting Authority /AHSP at his discretion for check test.

5.4 Finish-The Nylon webbing shall be woven in double plain weaves.6.5.5=5.1.3, 6.5.6=5.1.4, 6.5.7=5.1.5

5.5 The finished webbing should be clean, even and well woven with firm and regular selvages. The webbing should be free from weaving defects and stains. The dyed webbing should be of uniform shade.

5.6 The webbing shall comply with the requirements given below:

1) Ends in full length	95-110	Each comprising of two yarns and 8/9 binders, single.
2) Picks/dm	80/95	Each Comprising of two yarns
3) Denier of Yarns	Single,	Warp-1200-1500, weft-800-900
4) Tenacity of Yarn g/denier		Warp: 6.5 - 9. Weft: 6.5 - 9
5) Weight (max)	g/m	45
6) Width	mm	30.0+1.0/-0.5 (after dyeing)
7) Thickness	mm	2.1max, 1.95min (after dyeing)
8) Breaking Load	kg	1000 min
9) pH Value		between 6 & 8
10) Color fastness to washing (IS: 764)		Change in colour – Rating 4 Staining in Nylon –Rating 4/5
11) Colour		No.220 olive green to IS:5-1978

5.7 The length 'L' should be as specified in the drawing. It should be ensured that the both ends of the webbing of length 'L' are properly and evenly heat sealed.

5.8 Coloring of Nylon webbing: If dying process is used to obtain specified color, the same should be done with acetone or acid dyes. Metalized or Chrome dyes should not be used.

6. Inspection:

6.1 One set of inspection gauges is to be made available by the manufacturer.

6.2 Requisite testing of the components after manufacture will be done by the manufacturer and test certificate will be supplied to the AHSP.

7. Metallic Components:

The metallic components of the Sling Assembly are to be manufactured in accordance with the current drawing complying with the relevant requirement of the material as specified in the drawing.

7.1 The hardness and spring characteristics of the spring should be maintained as specified in the drawing.

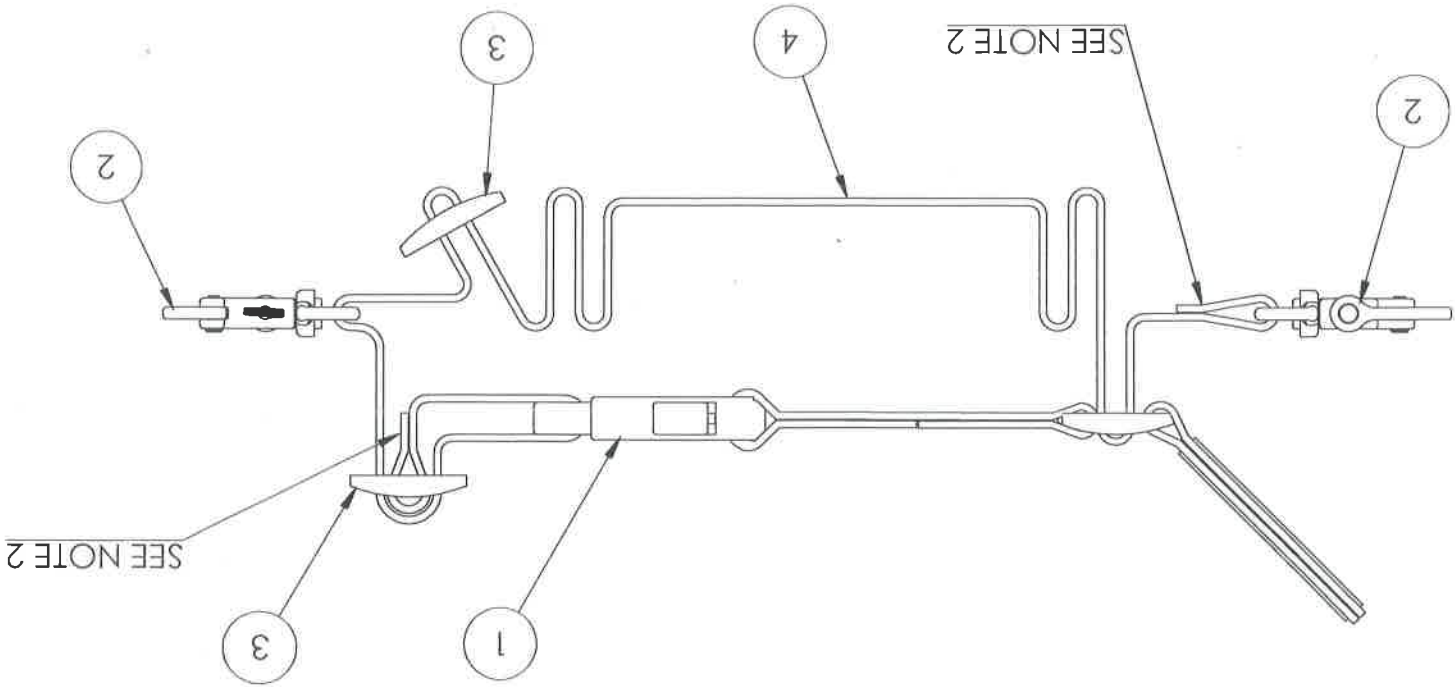
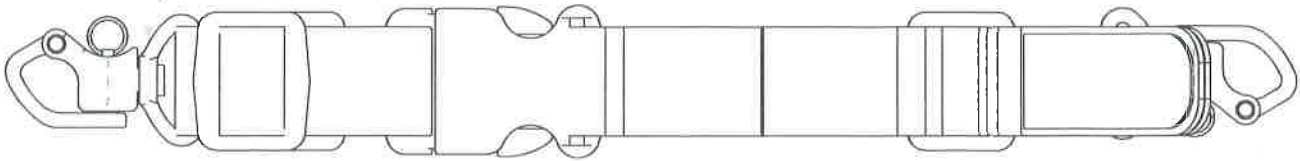
8. PROTECTIVE TREATMENT

8.1 Spring and Metallic Components: Before assembly, the steel components are to be phosphated as per Specification No. WPN/GEN3-CLASS II oil finish or equivalent JSS Specification in phosphate coating bath for which proper records for composition and concentration shall be maintained by the manufacturer and submitted to the inspecting authority when demanded. Test pieces with data and identity should be maintained to demonstrate batch conditions.

9. Assembly:

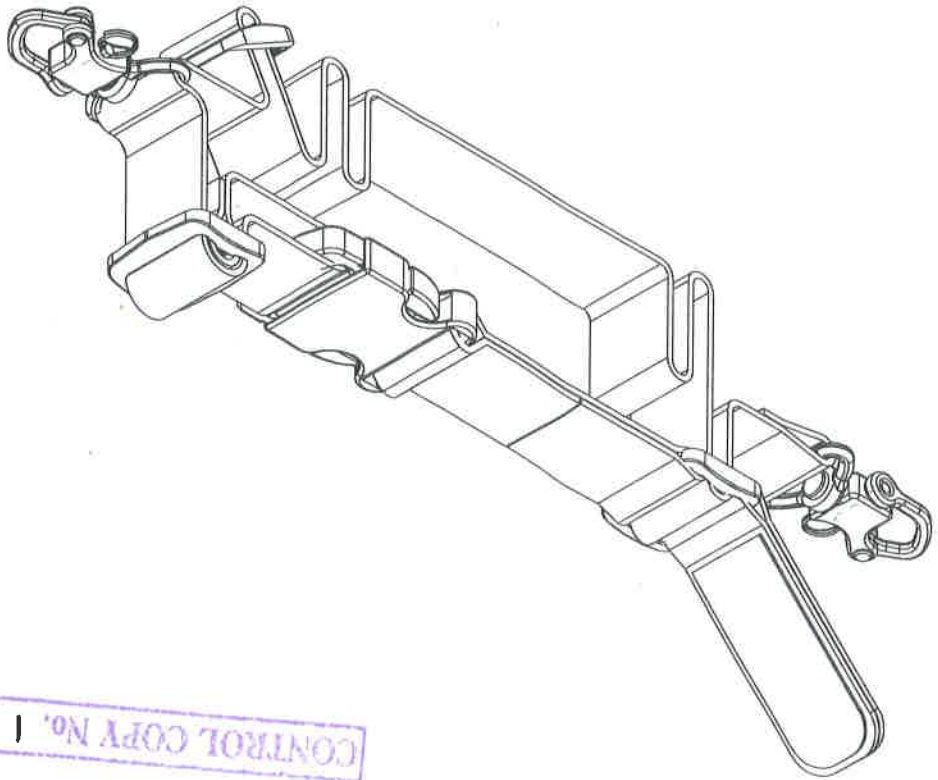
The assembly of Three Point Sling is as per Drg No. 0204 04 03 00 00 000 00DA .The *Hook Assembly* is as per Drg No. 0204 04 03 00 02 000 00DA. *QRB* is as per Drg No. 0204 04 03 00 01 000 00DA and *Trap pulling assembly* is as per Drg No. 0204 04 03 01 03 000 00DA

GEN.TOL. : ± 0.2		DRAWING CONVENTION CONFORM TO INDIAN STD.		DIMIN MM UNLESS OTHERWISE STATED	
SS	C	A	AA	S	SS
0	0	0	0	1	0
0	0	0	0	4	0
0	0	0	0	2	0
0	0	0	0	4	0
DRG NO					



ITEM NO.	NOMENCLATURE	DESCRIPTION	QTY.
1	GRB AND STRAP PULLING ASSEMBLY	0204-04-03-00-01-000-00DA	1
2	HOOK SLING ASSEMBLY	0204-04-03-00-02-000-00DA	2
3	SLIDING BUCKLE	0204-04-03-00-00-001-00DA	2
4	STEEL GREY (COLOUR NO. 698 TO IS: 5-2007) NYLON WEBBING/ STRAP, LENGTH 2200.0	IS: 4727-1968-TYPE- 2	1

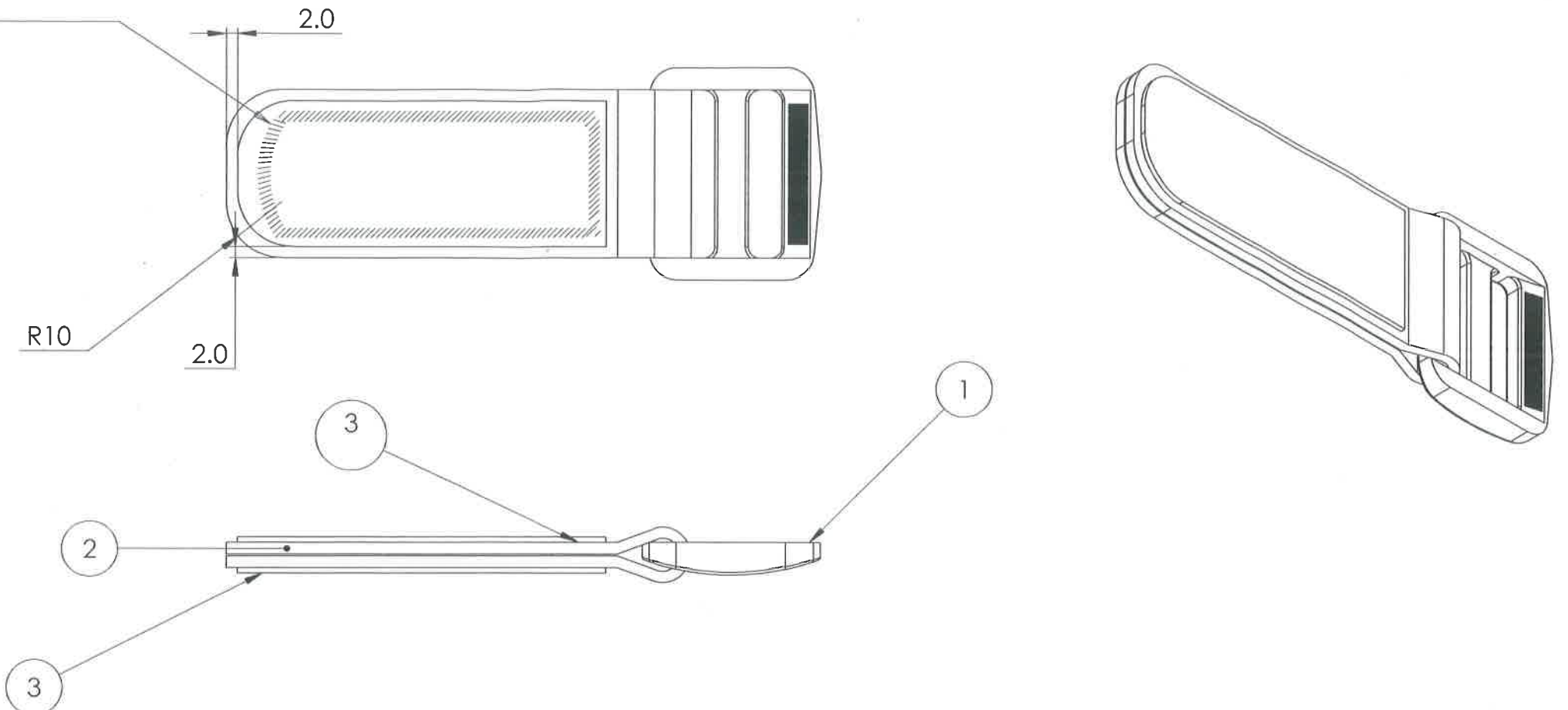
R NO		DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	SIGN
DRN	SD	CHD	MATERIAL				
APPD	DATE	FOR DIRECTOR		PROTECTIVE FINISH			
05/10/15							
SCALE	1:1	EST MASS	TITLE				
DESIGN AUTHORITY	3-POINT SLING FOR JVPC 5.56 X 30mm						
DRG NO	0204	SS	04	S	03	AA	00
	02	IC	04	SS	00	A	00
	04			C	00		
				SS	00		
PART NO		DS CAT NO		AHSP			



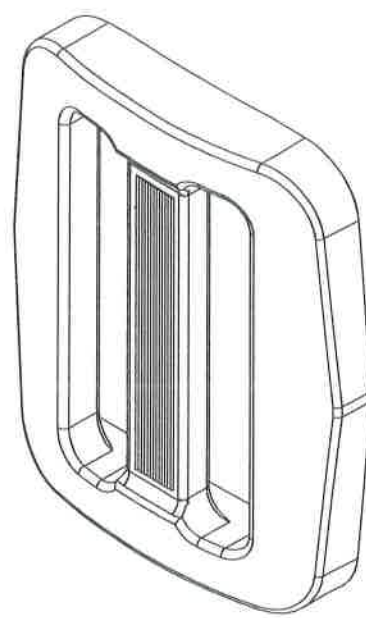
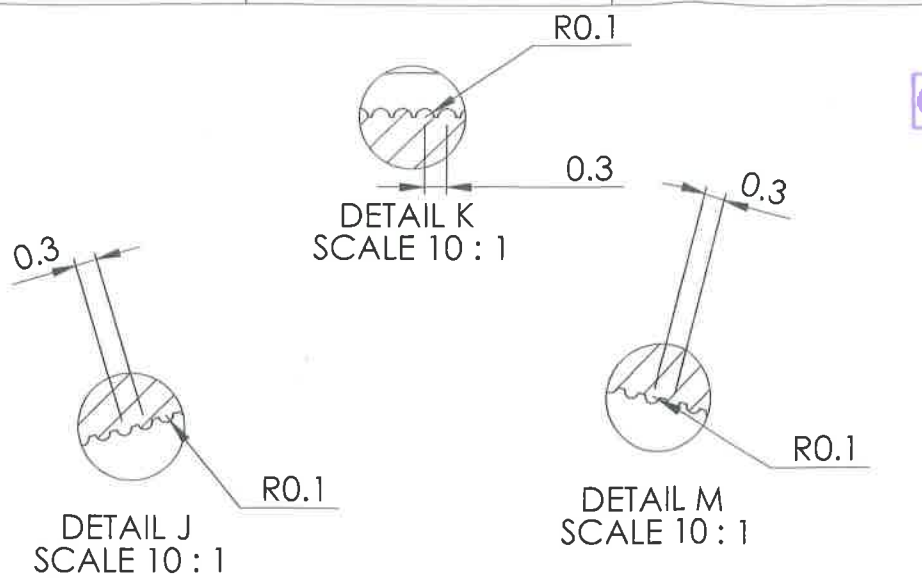
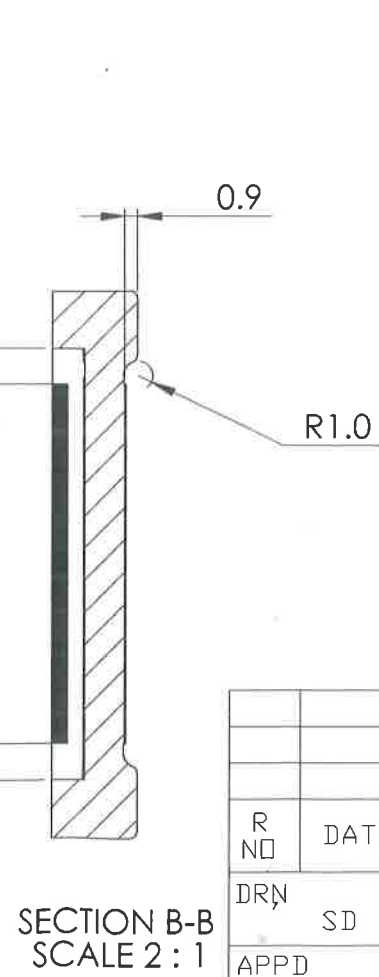
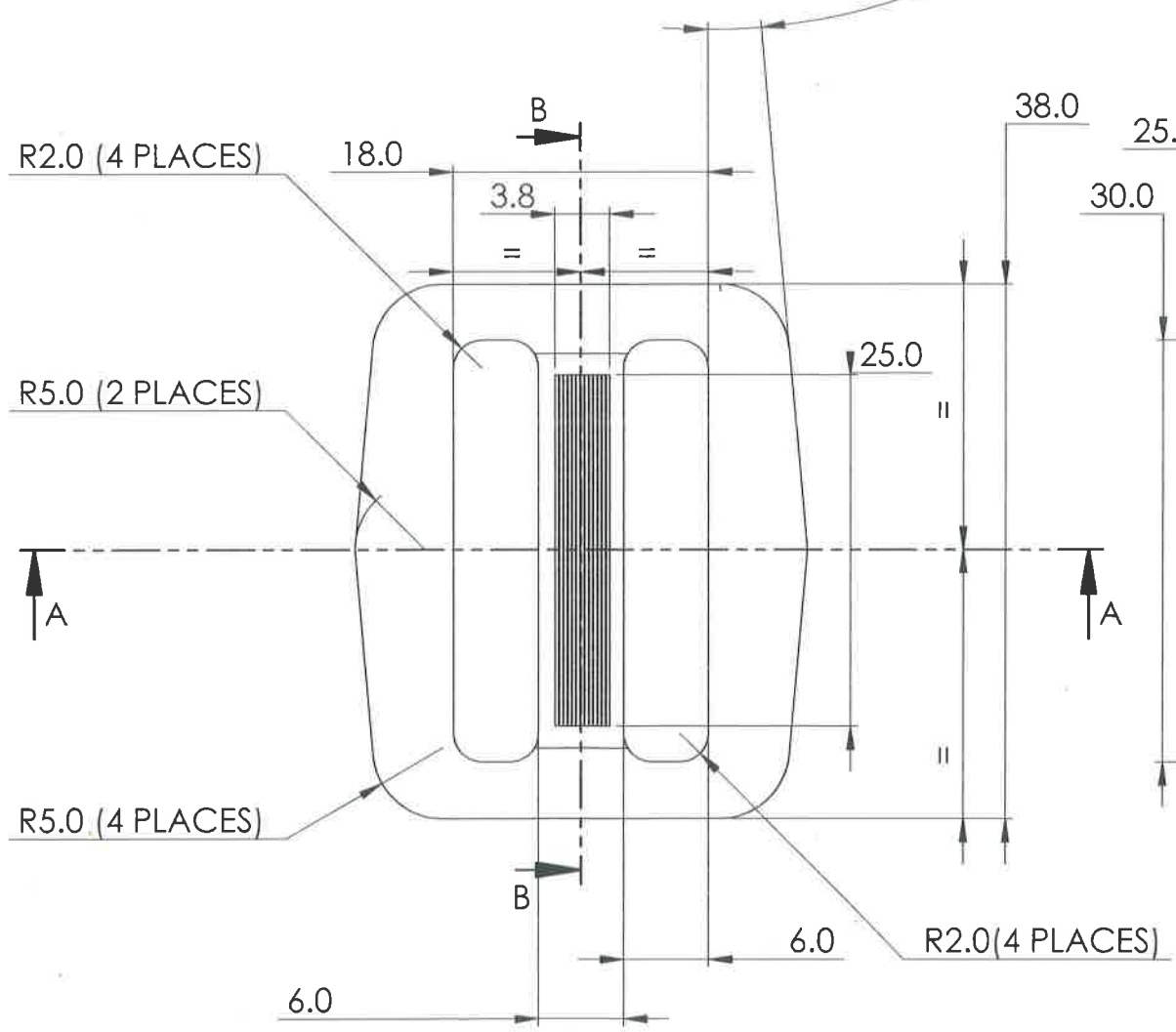
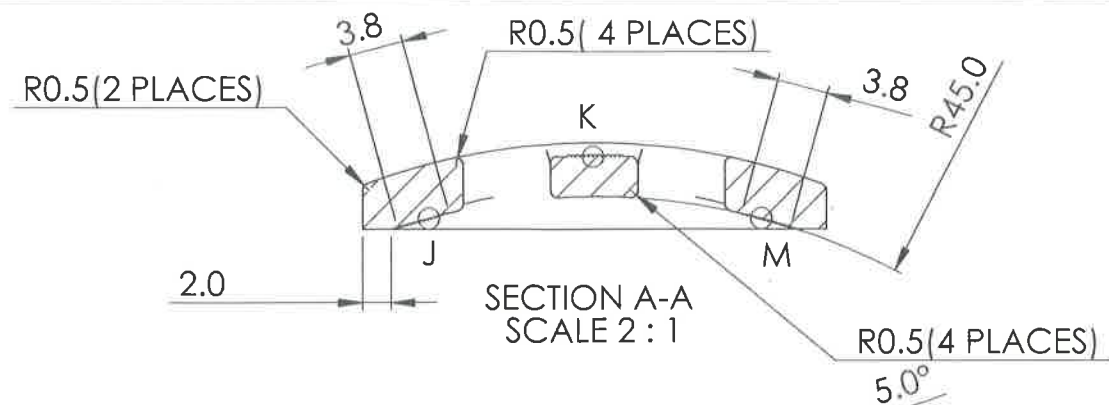
NOTE:-
1) BOTH THE ENDS OF WEBBING TO BE HEAT SEALED
2) TO BE STITCHED IN TWO ROWS WITH STEEL GREY (COLOUR NO. 698 TO IS: 5-2007) NYLON THREAD TO IS: 4229
3) REFER SPECIFICATION ARDE/SPECN/JVPC/2016/01 (PROV) FOR DETAILS OF WEBBING

CONTROL COPY No. 1

8	7	6	5	4	3	2	1																																																																															
DRG NO 02040300000DA				CONTROL COPY No. 1																																																																																		
GEN.TOL. ±0.2				DRAWING CONVENTION CONFIRM TO INDIAN STDS. DIMN.IN mm UNLESS OTHERWISE STATED																																																																																		
TO BE STITCHED AS SHOWN WITH STEEL GREY (COLOUR NO. 698 TO IS:5-2007) NYLON THREAD TO IS:4229,40 STICHES PER 100 LENGTH, AFTER ASSEMBELED WITH QRB AND STRAP PULLING ASSEMBLY.																																																																																						
NOTE:- ALL ENDS OF WEBBING TO BE HEAT SEALED																																																																																						
<table><thead><tr><th>ITEM NO.</th><th>PART NUMBER</th><th>DRAWING NUMBER</th><th>QTY.</th></tr></thead><tbody><tr><td>1</td><td>STRAP PULLING ASSEMBLY</td><td>0204-04-03-01-03-000-00DA</td><td>1</td></tr><tr><td>2</td><td>STEEL GREY (COLOUR NO. 698 TO IS: 5-2007) NYLON WEBBING 30.0 WIDTH X 2.0 THICK X 300.0 LENGTH</td><td>IS: 4727-1968-TYPE- 2</td><td>1</td></tr><tr><td>3</td><td>QUICK RELEASE BUCKLE (QRB)</td><td>STD. COMPONENT</td><td>1</td></tr></tbody></table>				ITEM NO.	PART NUMBER	DRAWING NUMBER	QTY.	1	STRAP PULLING ASSEMBLY	0204-04-03-01-03-000-00DA	1	2	STEEL GREY (COLOUR NO. 698 TO IS: 5-2007) NYLON WEBBING 30.0 WIDTH X 2.0 THICK X 300.0 LENGTH	IS: 4727-1968-TYPE- 2	1	3	QUICK RELEASE BUCKLE (QRB)	STD. COMPONENT	1	<table><tr><td>R NO</td><td>DATE</td><td>AUTHORITY</td><td>BRIEF RECORD</td><td>ZONE</td><td>CD</td><td>GO</td></tr><tr><td>DRN SD</td><td>CHD</td><td>FOR DIRECTOR</td><td>MATERIAL</td><td></td><td></td><td></td></tr><tr><td>APPD</td><td>DATE 05/10/15</td><td></td><td>PROTECTIVE FINISH</td><td></td><td></td><td></td></tr><tr><td>SEALED DATE</td><td></td><td></td><td></td><td></td><td></td><td></td></tr><tr><td>SCALE 1:1</td><td>EST MASS</td><td>TITLE</td><td colspan="4">QRB AND STRAP PULLING ASSEMBLY</td></tr><tr><td>DESIGN AUTHORITY ARDE</td><td></td><td></td><td colspan="4"></td></tr><tr><td>DRG NO</td><td>0204</td><td>04</td><td>03</td><td>00</td><td>01</td><td>00000DA</td></tr><tr><td></td><td>IC</td><td>SS</td><td>S</td><td>AA</td><td>A</td><td>C SST</td></tr><tr><td>PART NO</td><td colspan="3">DS CAT NO</td><td colspan="3">AHSP</td></tr></table>				R NO	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO	DRN SD	CHD	FOR DIRECTOR	MATERIAL				APPD	DATE 05/10/15		PROTECTIVE FINISH				SEALED DATE							SCALE 1:1	EST MASS	TITLE	QRB AND STRAP PULLING ASSEMBLY				DESIGN AUTHORITY ARDE							DRG NO	0204	04	03	00	01	00000DA		IC	SS	S	AA	A	C SST	PART NO	DS CAT NO			AHSP		
ITEM NO.	PART NUMBER	DRAWING NUMBER	QTY.																																																																																			
1	STRAP PULLING ASSEMBLY	0204-04-03-01-03-000-00DA	1																																																																																			
2	STEEL GREY (COLOUR NO. 698 TO IS: 5-2007) NYLON WEBBING 30.0 WIDTH X 2.0 THICK X 300.0 LENGTH	IS: 4727-1968-TYPE- 2	1																																																																																			
3	QUICK RELEASE BUCKLE (QRB)	STD. COMPONENT	1																																																																																			
R NO	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO																																																																																
DRN SD	CHD	FOR DIRECTOR	MATERIAL																																																																																			
APPD	DATE 05/10/15		PROTECTIVE FINISH																																																																																			
SEALED DATE																																																																																						
SCALE 1:1	EST MASS	TITLE	QRB AND STRAP PULLING ASSEMBLY																																																																																			
DESIGN AUTHORITY ARDE																																																																																						
DRG NO	0204	04	03	00	01	00000DA																																																																																
	IC	SS	S	AA	A	C SST																																																																																
PART NO	DS CAT NO			AHSP																																																																																		
8	7	6	5	4	3	2	1																																																																															

8	7	6	5	4	3	2	1																																																																	
ISSC AA S SS IC DRG NO				CONTROL COPY No.																																																																				
GEN.TOL. ±0.2		DRAWING CONVENTION CONFIRM TO INDIAN STDS. DIMN.IN mm UNLESS OTHERWISE STATED																																																																						
TO BE STITCHED AS SHOWN WITH STEEL GREY (COLOUR NO 698 TO IS: 5-2007) NYLON THREAD TO IS:4229 40 STICHES PER 100 LENGTH																																																																								
																																																																								
<table><thead><tr><th>ITEM NO</th><th>NOMENCLATURE</th><th>DRAWING NO</th><th>QTY.</th></tr></thead><tbody><tr><td>1</td><td>SLIDING BUCKLE</td><td>0204-04-03-00-00-001-00DA</td><td>1</td></tr><tr><td>2</td><td>STEEL GREY (COLOUR NO. 698 TO IS: 5-2007) NYLON WEBBING 30.0 WIDTH X 2.0 THICK X 170.0 LENGTH</td><td>IS: 4727-1968-TYPE- 2</td><td>1</td></tr><tr><td>3</td><td>OLIVE GREEN (COLOUR NO. 220 TO IS:5-2007) NYLON WEBBING 26.0 WIDTH X 1.0 THICK X 65.0 LENGTH</td><td>IS: 4727-1968-TYPE- 2</td><td>2</td></tr></tbody></table>				ITEM NO	NOMENCLATURE	DRAWING NO	QTY.	1	SLIDING BUCKLE	0204-04-03-00-00-001-00DA	1	2	STEEL GREY (COLOUR NO. 698 TO IS: 5-2007) NYLON WEBBING 30.0 WIDTH X 2.0 THICK X 170.0 LENGTH	IS: 4727-1968-TYPE- 2	1	3	OLIVE GREEN (COLOUR NO. 220 TO IS:5-2007) NYLON WEBBING 26.0 WIDTH X 1.0 THICK X 65.0 LENGTH	IS: 4727-1968-TYPE- 2	2	<table><thead><tr><th>R NO</th><th>DATE</th><th>AUTHORITY</th><th>BRIEF RECORD</th><th>ZONE</th><th>CD</th><th>GD</th></tr></thead><tbody><tr><td>DRW</td><td>SD</td><td>CHD</td><td>MATERIAL</td><td></td><td></td><td></td></tr><tr><td colspan="3">APPD DATE 26/10/15</td><td>PROTECTIVE FINISH</td><td></td><td></td><td></td></tr><tr><td colspan="3">SEALED DATE</td><td></td><td></td><td></td><td></td></tr><tr><td colspan="2">SCALE 1:1</td><td>EST MASS</td><td colspan="4">TITLE</td></tr><tr><td colspan="2">DESIGN AUTHORITY ARDE</td><td colspan="5">STRAP PULLING ASSEMBLY</td></tr><tr><td colspan="2">DRG NO</td><td colspan="2">DS CAT NO</td><td colspan="3">AHSP</td></tr></tbody></table>				R NO	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GD	DRW	SD	CHD	MATERIAL				APPD DATE 26/10/15			PROTECTIVE FINISH				SEALED DATE							SCALE 1:1		EST MASS	TITLE				DESIGN AUTHORITY ARDE		STRAP PULLING ASSEMBLY					DRG NO		DS CAT NO		AHSP		
ITEM NO	NOMENCLATURE	DRAWING NO	QTY.																																																																					
1	SLIDING BUCKLE	0204-04-03-00-00-001-00DA	1																																																																					
2	STEEL GREY (COLOUR NO. 698 TO IS: 5-2007) NYLON WEBBING 30.0 WIDTH X 2.0 THICK X 170.0 LENGTH	IS: 4727-1968-TYPE- 2	1																																																																					
3	OLIVE GREEN (COLOUR NO. 220 TO IS:5-2007) NYLON WEBBING 26.0 WIDTH X 1.0 THICK X 65.0 LENGTH	IS: 4727-1968-TYPE- 2	2																																																																					
R NO	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GD																																																																		
DRW	SD	CHD	MATERIAL																																																																					
APPD DATE 26/10/15			PROTECTIVE FINISH																																																																					
SEALED DATE																																																																								
SCALE 1:1		EST MASS	TITLE																																																																					
DESIGN AUTHORITY ARDE		STRAP PULLING ASSEMBLY																																																																						
DRG NO		DS CAT NO		AHSP																																																																				
PART NO				AHSP																																																																				
8	7	6	5	4	3	2	1																																																																	

DRG NO	0204	IC	03	S	01	AA	A	C	SS
GEN.TOL. ±0.2									
DRAWING CONVENTION CONFIRM TO INDIAN STDS. DIMN.IN mm UNLESS OTHERWISE STATED									



CONTROL COPY No.

R NO	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO
DRN	SD	CHD	MATERIAL	SIGN		
APPD	DATE	FOR DIRECTOR	NYLON-66 (GF 10%)			
SEALED	DATE		PROTECTIVE FINISH			
SCALE	2:1	EST MASS	TITLE			
DESIGN	AUTHORITY	ARDE	SLIDING BUCKLE			
DRG NO	0204	IC	04	S	03	00
PART NO	DS CAT NO		AHSP		00100DA	

A

B

C

D

E

F

A

B

C

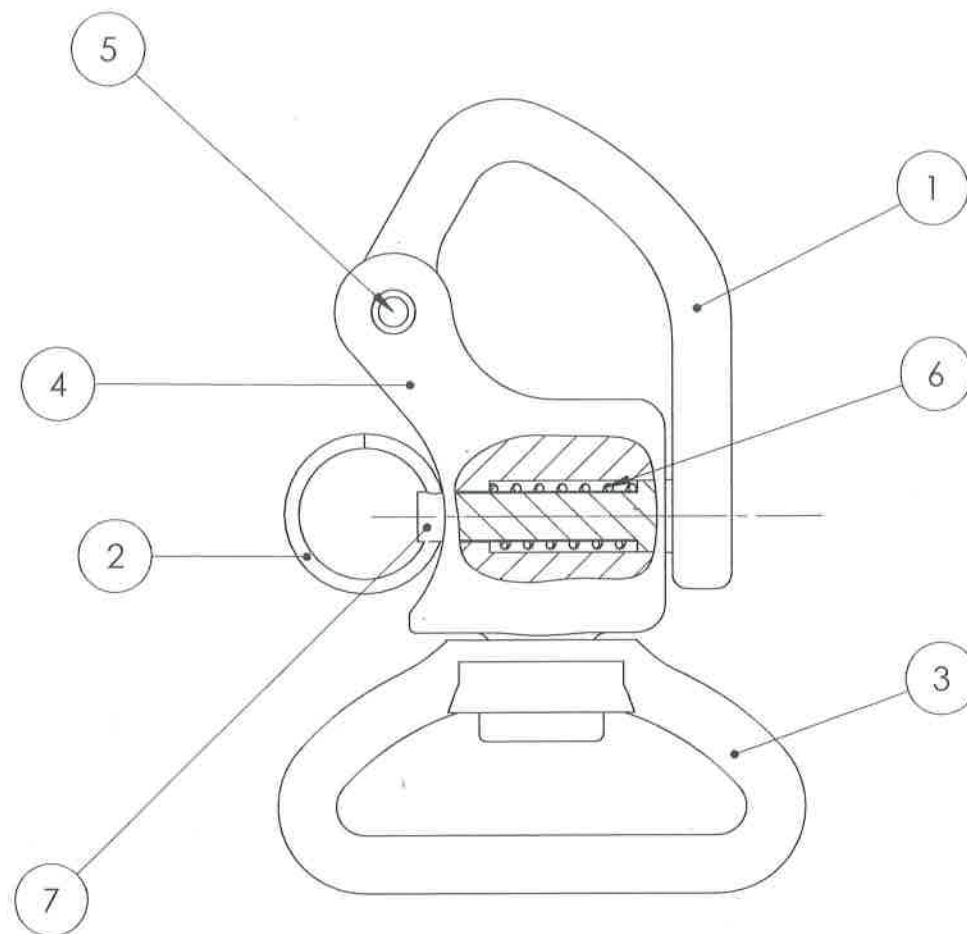
D

E

F

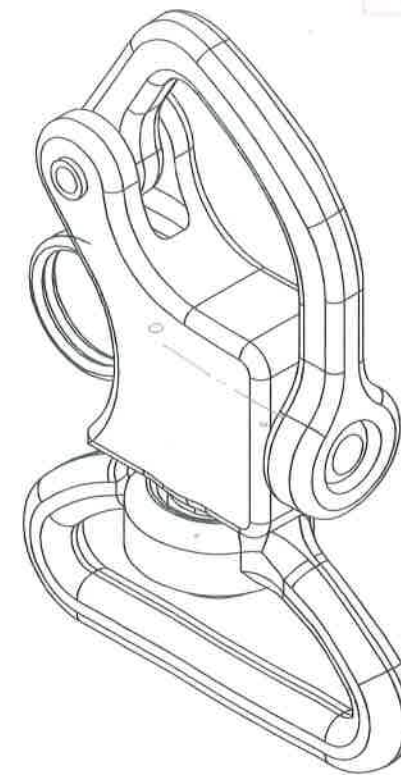
DRG NO 02040300200100DA
IC SS S AA C SST

GEN.TOL. : ±0.2

DRAWING CONVENTION CONFIRM TO INDIAN STDS.
DIMN.IN mm UNLESS OTHERWISE STATED

SL NO.	NOMENCLATURE	DRAWING No.	QTY.
1	HINGE HOUSING HOOK SLING	0204-04-03-00-02-001-00DA	1
2	RING LOCKING PLUNGER	0204-04-03-00-02-002-00DA	1
3	HOOK SLING	0204-04-03-00-02-003-00DA	1
4	HOUSING HOOK SLING	0204-04-03-00-02-004-00DA	1
5	PIN HINGE HOOK SLING	0204-04-03-00-02-005-00DA	1
6	SPRING PLUNGER HOOK SLING.	0204-04-03-00-02-006-00DA	1
7	PLUNGER HOOK SLING	0204-04-03-00-02-007-00DA	1

CONTROL COPY No.



R NO	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO
DRN	SD	CHD	MATERIAL			SIGN
APPD	DATE 24/06/2015	FOR DIRECTOR	PROTECTIVE FINISH			
SEALED	DATE	SCALE 2:1	EST MASS	TITLE		
DESIGN	AUTHORITY	ARDE		HOOK SLING ASSEMBLY		
DRG NO	0204	04	03	00	02	000000DA
	IC	SS	S	AA	A	C SST
PART NO		DS CAT NO		AHSP		

A

B

C

D

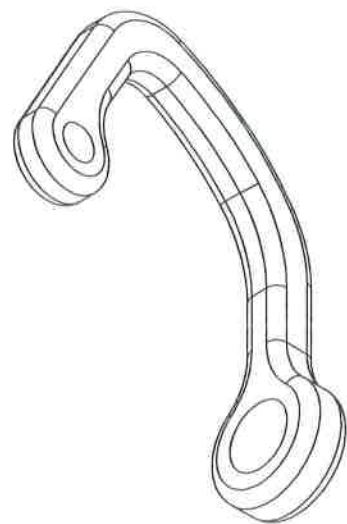
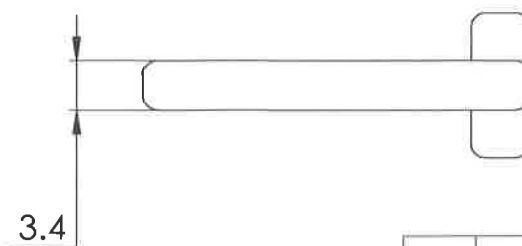
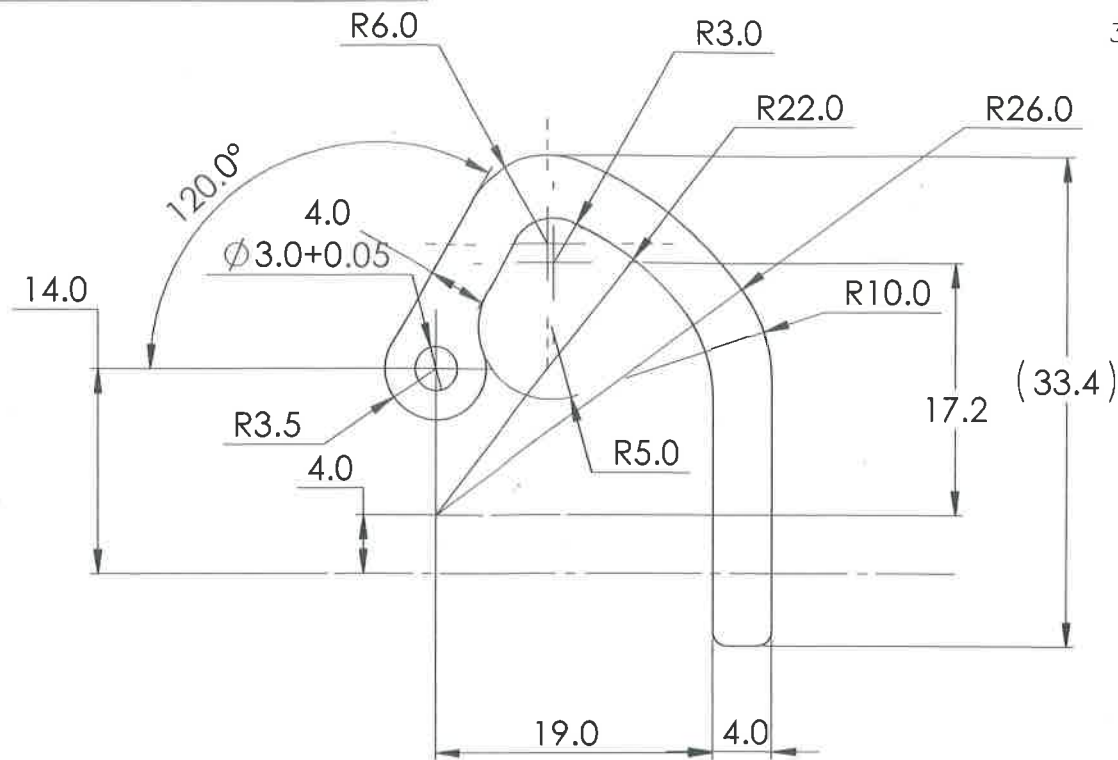
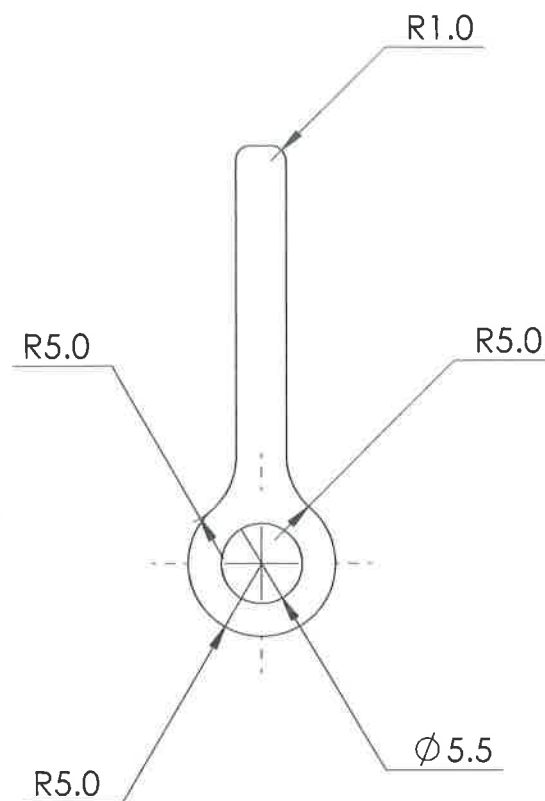
E

F

SS	C	A	AA	S	SS	IC	DRG NO
0	0	0	0	1	0	4	0204

GEN.TOL. : ±0.2

DRAWING CONVENTION CONFIRM TO INDIAN STDS.
DIMN.IN mm UNLESS OTHERWISE STATED



NOTES:

CONTROL COPY No.

- 1) REMOVE ALL SHARP EDGES AND BURRS.
- 2) HARDNESS: 300-350HV
- 3) ALT. PROTECTIVE FINISH: Ni-PTFE, 20 μ m THICKNESS.

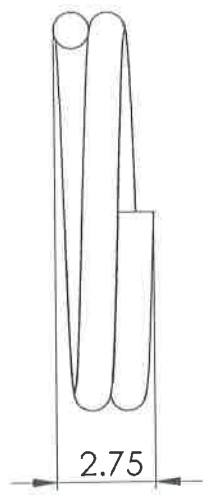
R NO	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GD
DRN	SD	CHD	MATERIAL			
APPD	DATE	FOR DIRECTOR	STEEL TO IS: 5517:1993,Gd-40Ni6Cr4Mo3 (EN-24)			
SEALED	DATE		PROTECTIVE FINISH			
SCALE	EST MASS		PHOSPHATED TO SPECN IS:3618-1966, CLASS B			
DESIGN	AUTHORITY		TITLE			
ARDE			HINGE HOUSING HOOK SLING			
DRG NO	IC	SS	S	AA	A	C
0204	04	03	00	02	00	1
PART NO	DS CAT NO		AHSP			

1	2	3	4
ISS	C	A	WA
S	SS	IC	DRG.No.
1 0	3 0	4 0 2 0	

GEN TOL FINE/MEDIUM/COARSE CLASS TO IS:2102

DRG CONVENTIONS CONFIRM TO INDIAN STDS. DIMN IN mm UNLESS OTHERWISE STATED

CONTROL COPY No.



- 1) WIRE DIA=1.0
- 2) MEAN DIA=10.0
- 3) NO OF TURNS=1.75
- 4) BOTH ENDS TO BE CLOSED.

SR No	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO
					SIGN	
DRN	SD	CHD	MATERIAL			
APPD	DATE 24/06/2015 For Director		STEEL WIRE TO IS:4454 (Pt-1), 2001, DH			
SEALED	DATE		PROTECTIVE FINISH			
SCALE 5:1	EST MASS		PHOSPHATED TO SPECN IS:3618-1966, CLASS B			
DESIGN AUTHORITY			TITLE			
ARDE			RING LOCKING PLUNGER HOOK SLING			
PUNE 411021						
DRG.No.	0 2 0 4	0 4	0 3	0 0	0 2	0 0 2 0 0 D A
	IC	SS	S	AA	A	C SST
PART No	DS CAT No			AHSP		

DRG NO 0204 0300 0200 0040 00DA

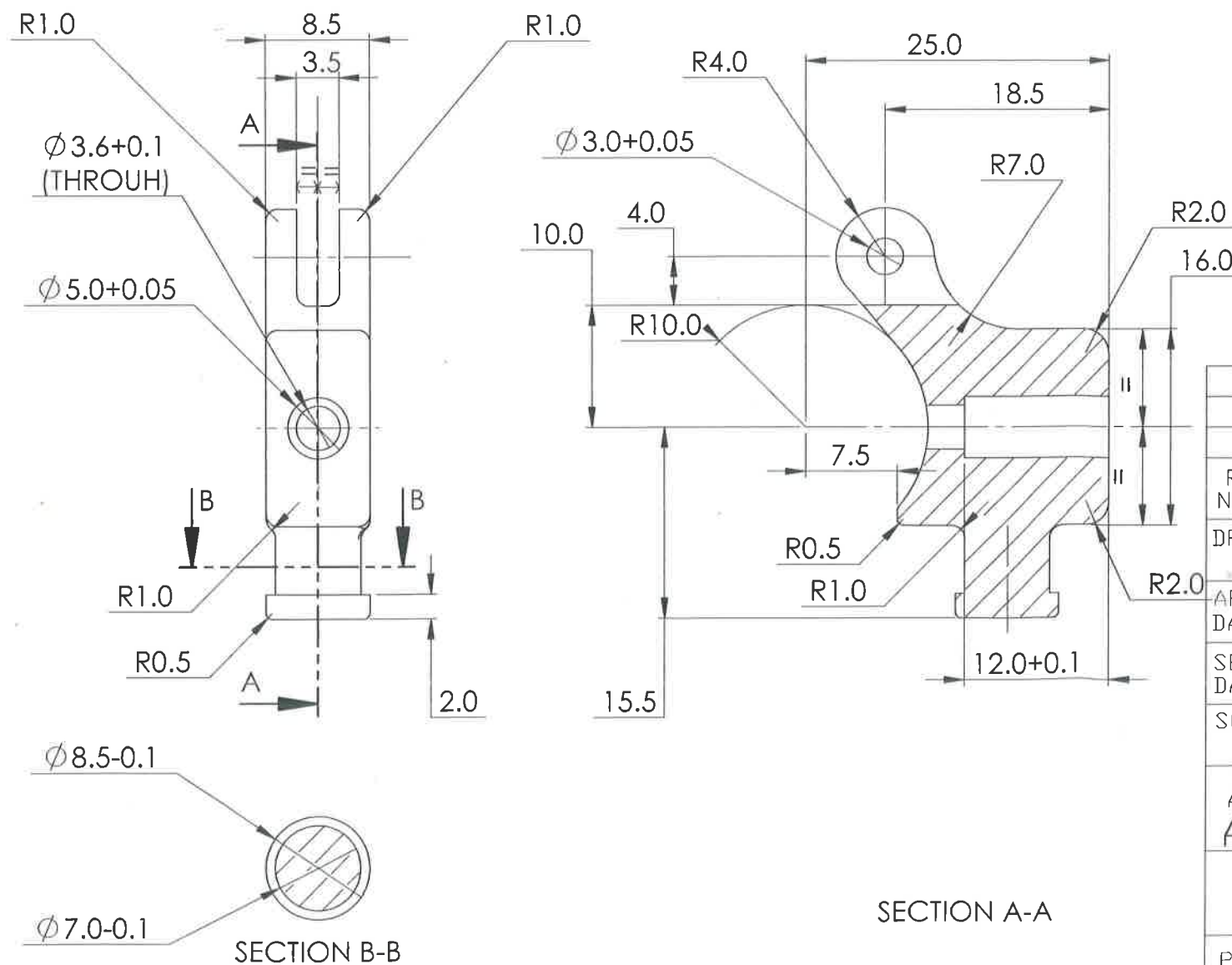
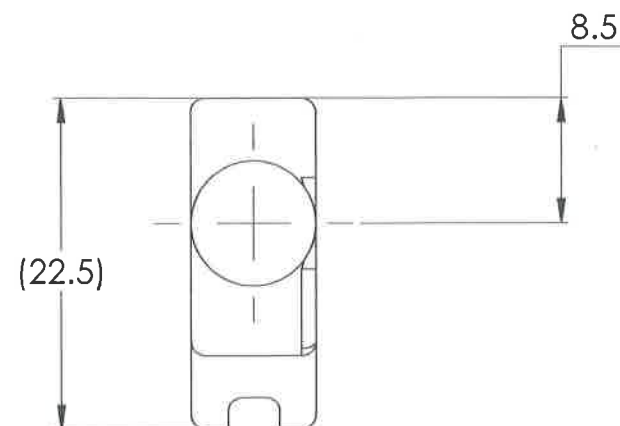
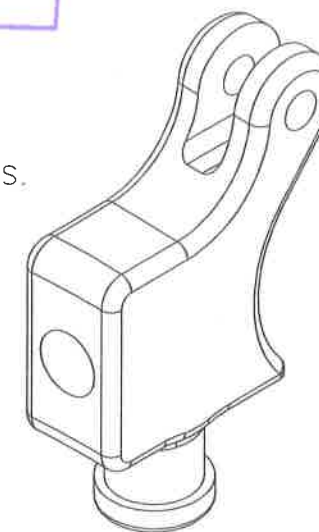
GEN.TOL. : ± 0.2

DRAWING CONVENTION CONFIRM TO INDIAN STDS.
DIMN.IN mm UNLESS OTHERWISE STATED

CONTROL COPY No.

NOTES:

- 1) REMOVE ALL SHARP EDGES AND BURRS.
- 2) HARDNESS: 300-350HV
- 3) ALT. PROTECTIVE FINISH: Ni-PTFE, 20 μ m THICKNESS.



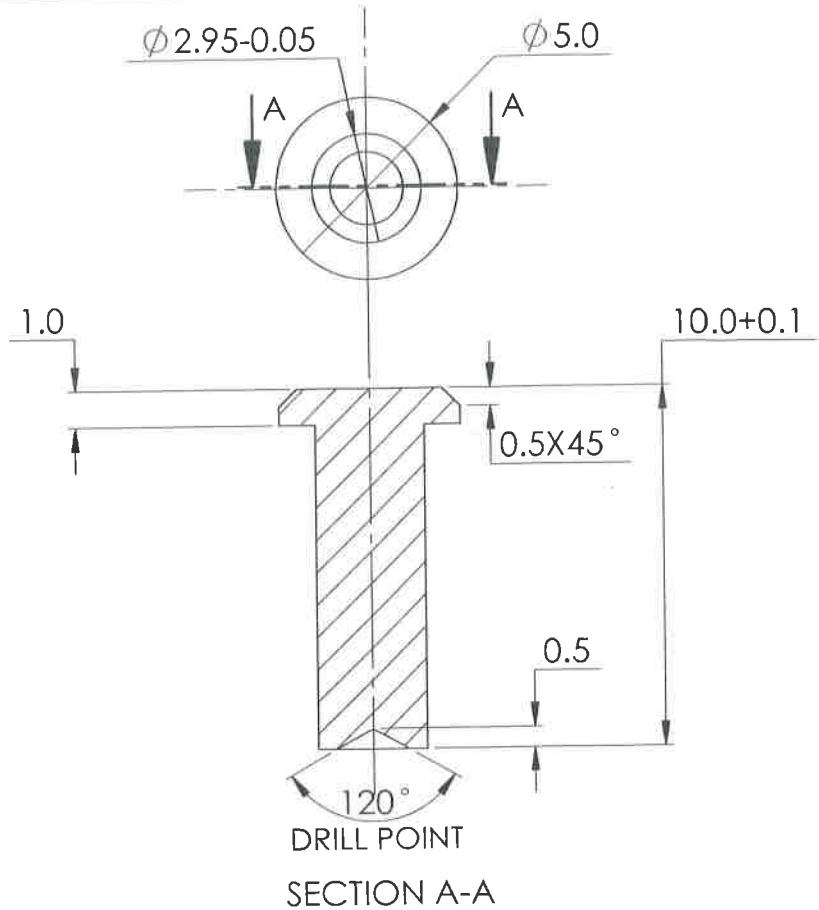
R NO	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO
DRN	SD	CHD	MATERIAL			SIGN
APPD	DATE 15/4/15	FOR DIRECTOR	STEEL TO IS: 5517:1993,Gd-40Ni6Cr4Mo3 (EN-24)			
SEALED	DATE		PROTECTIVE FINISH			
SCALE 2:1	EST MASS		PHOSPHATED TO SPECN IS:3618-1966, CLASS B			
DESIGN	AUTHORITY		TITLE			
ARDE			HOUSING HOOK SLING			
DRG NO	0204	04	03	00	02	00400DA
PART NO		DS CAT NO		AHSP		

1	2	3	4
ISS	C	A	AA
S	SS	IC	DRG.No.
0 1	0 3	0 2 0 4	0 2 0 4

GEN TOL FINE/MEDIUM/COARSE CLASS TO IS:2102

DRG CONVENTIONS CONFIRM TO INDIAN STDS. DIMN IN mm UNLESS OTHERWISE STATED

CONTROL COPY No.



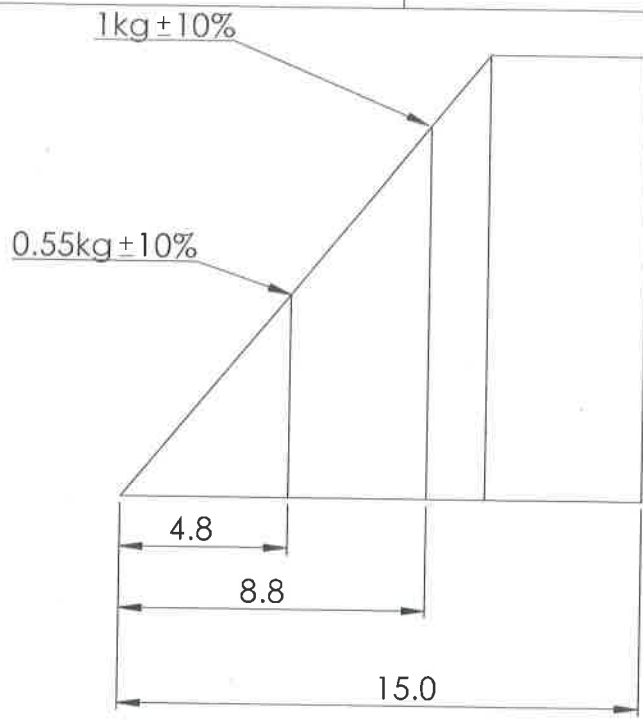
- NOTES:
- 1) REMOVE ALL SHARP EDGES AND BURRS.
 - 2) HARDNESS: 300-350HV
 - 3) ALT. PROTECTIVE FINISH: Ni-PTFE, 20µm THICKNESS.

SR No	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO
DRN	SD	CHD	MATERIAL			
APPD	DATE	DATE	PROTECTIVE FINISH			
SEALED	DATE		PHOSPHATED TO SPECN IS:3618-1966, CLASS B			
SCALE	5:1	EST MASS	TITLE			
DESIGN AUTHORITY			PIN HINGE HOOK SLING			
ARDE						
PUNE 411021						
DRG.No.	0 2 0 4	0 4	0 3	0 0	0 2	0 0 5
IC	SS	S	AA	A	C	SST
PART No		DS CAT No		AHSP		

1	2	3	4
ISS	C	A	AA
S	SS	IC	DRG.No.
01	03	04	0204

GEN TOL FINE/MEDIUM/COARSE CLASS TO IS:2102

DRG CONVENTIONS CONFIRM TO INDIAN STDS
DIMN IN mm UNLESS OTHERWISE STATED



CONTROL COPY No.

- 1) STRESS RELEIVED
- 2) WIRE DIA=0.5
- 3) MEAN DIA=4.0
- 4) NO OF EFFECTIVE COIL=8
- 4) ONE COIL OF EACH END TO BE CLOSED AND GROUND SQUARE TO THE AXIS OF THE COIL LEAVING 3/4 OF COIL AT EACH END NON EFFECTIVE

SR No	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO
DRN	SD	CHD	MATERIAL	SIGN		
APPD	DATE	For Director	STEEL WIRE TO IS:4454 (Pt-1), 2001, DH			
SEALED	DATE		PROTECTIVE FINISH			
SCALE	5:1	EST MASS	PHOSPHATED TO SPECN IS:3618-1966, CLASS B			
DESIGN AUTHORITY	ARDE		TITLE			
PUNE 411021			SPRING PLUNGER HOOK SLING			
DRG.No.	IC	SS	S	AA	A	C
0204	04	03	00	02	006	00DA
PART No	DS CAT No		AHSP			

1

2

3

4

ISS

C

A

AA

S

SS

IC

DRG.No.

0	2	0	4
---	---	---	---

0	4
---	---

0	3
---	---

0	0
---	---

0	2
---	---

0	0	7
---	---	---

0	0	D	A
---	---	---	---

A

GEN TOL FINE/MEDIUM/COARSE
CLASS TO IS:2102

DRG CONVENTIONS CONFIRM TO INDIAN STDS.
DIMN IN mm UNLESS OTHERWISE STATED

A

CONTROL COPY No.

B

$\phi 1.2$
(THROUGH)

1.2

R1.0

 $\phi 4.9-0.05$

15.0

6.0

 $\phi 3.4-0.05$

B

C

NOTES:

- 1) REMOVE ALL SHARP EDGES AND BURRS.
- 2) HARDNESS: 300-350HV
- 3) ALT. PROTECTIVE FINISH: Ni-PTFE, 20 μ m THICKNESS.

D

SR
No

DATE

AUTHORITY

BRIEF RECORD

ZONE

CD

GO

SIGN

DRN

SD

CHD

MATERIAL

STEEL TO IS: 5517:1993,Gd-40Ni6Cr4Mo3 (EN-24)

APPD

DATE 15/4/15

For Director

PROTECTIVE FINISH

SEALED
DATE

PHOSPHATED TO SPECN IS:3618-1966, CLASS B

SCALE 2:1

EST MASS

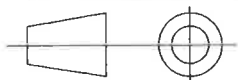
TITLE

PLUNGER HOOK SLING

DESIGN AUTHORITY

ARDE

PUNE 411021



F

DRG.No.

0	2	0	4
---	---	---	---

IC

0	4
---	---

SS

0	3
---	---

S

0	0
---	---

AA

0	2
---	---

A

0	0	7
---	---	---

C

0	0	D	A
---	---	---	---

SST

PART No

DS CAT No

AHSP

F

1

2

3

4