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कम सं. 33/05 /समन्वय भावकी
दिनांक 02/06/2014 के अनुसार रक्षा
मंत्रालय द्वारा अनुमोदित SSC
Approved by Ministry of Defence
Vide letter No
Reord/Std dated.....



6/06/14
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Joint Director (T.C.)
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Directorate of Standardisation
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Min. of Defence, New Delhi-110 011

रक्षा मंत्रालय
MINISTRY OF DEFENCE

ज्वाइंट सर्विस स्पेसिफिकेशन
JOINT SERVICES SPECIFICATION

ON

SNAP HOOK STATIC LINE (PTR - M)
(D S Cat No. 5340 – 000 325)

मानकीकरण निदेशालय
रक्षा उत्पादन विभाग
रक्षा मंत्रालय
‘एच’ – ब्लॉक, निर्माण भवन डाकघर
नई दिल्ली – 110 011

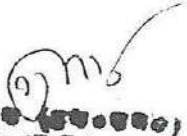
DIRECTORATE OF STANDARDISATION
DEPARTMENT OF DEFENCE PRODUCTION
MINISTRY OF DEFENCE
‘H’ - BLOCK, NIRMAN BHAVAN, P.O.
NEW DELHI - 110 011

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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RECORD OF AMENDMENTS

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

Sl. No.	CONTENTS	Page No.
0.	FOREWORD	1 - 2
1.	SCOPE	3
2.	RELATED SPECIFICATIONS	3 - 4
3.	STANDARD PATTERN	4
4.	MATERIALS	5
5.	PROCESSING	5
6.	DIMENSIONS AND TOLERANCES	6
7.	WORKMANSHIP AND FINISH	6
8.	PRE - INSPECTION OF SUPPLIES BY PRODUCER	6
9.	QUALITY ASSURANCE	6
10.	SAMPLING PROCEDURE	7
11.	CRITERIA FOR CONFORMITY	7 - 9
12.	TEST METHOD	9
13.	WARRANTY	10
14.	MARKING	10
15.	PACKAGING	10 - 11
16.	DEFENCE STORES CATALOGUE NUMBER	12
17.	SUGGESTIONS FOR IMPROVEMENT	12
18.	DRAWINGS	13 - 17

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 Dta. of Defence, New Delhi-110

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 Number IND / GS / 1753 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, Controllerate of Quality Assurance (General Stores), 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.ddpdos.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.ddpdos.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.


 प्रधान निदेशक (प्रक.उ.सं.)
 Asstt. Director (T.C.)
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1.0 SCOPE

1.1 This specification covers the requirements of Snap Hook (Static Line) PTR - M (DS Cat No 1670 – 000 325) and provides guidance to contractors / Suppliers, Manufacturers, Quality Assurance Agencies and Stockists / Indentors etc.

2.0 RELATED SPECIFICATIONS

Sl. No.	Specification No.	Title / Subjects
(a)	IS 740 : 1977 (Second Revision) Reaffirmed - 2006	Specification for Wrought aluminium and aluminium alloy rivet stock for general engineering purposes
(b)	IS 1029 : 1970 (First Revision) Reaffirmed - 2013 Amd - 3	Specification for Hot Rolled Steel Strips (Baling)
(c)	IS 1068 : 1993 (Third Revision) Reaffirmed - 2010 Amd - 1	Electroplated Coatings of Nickel Plus Chromium and Copper Plus Nickel Plus Chromium - specification
(d)	IS 1503 : 1988 (Third Revision) Reaffirmed - 2008	Specification for Wooden packing cases
(e)	IS 1570 : Part 4 : 1988 (First Revision) Reaffirmed - 2012	Schedules for Wrought Steels : Part 4 : Alloy Steels (Alloy Constructional and Spring Steels) with specified Chemical Composition and Related Mechanical Properties
(f)	IS 1572 : 1986 (Second Revision) Reaffirmed - 2010 Amd - 1	Specification for Electroplated Coatings of Cadmium on Iron and Steel
(g)	IS 2102 : Part 1 : 1993 (Third Revision) Reaffirmed - 2008	General Tolerances : Part 1 : Tolerances for Linear and angular dimensions without individual tolerance indications
(h)	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

2) M
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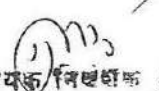
Sl. No.	Specification No.	Title / Subjects
(j)	IS 4185 : 1989 (First Revision) Reaffirmed - 2010 & Supp. Sch. Number CIGS / SS / 185 (b)	Adhesive Paper Tapes - Specification
(k)	IS 4454 : Part - 2 : 2001 (Second Revision) Reaffirmed - 2010 Amd - 2	Steel wire for Cold Formed Springs. Oil hardened & tempered spring Steel wire and Valve Steel Wire - Unalloyed.
(l)	IS 4905 : 1968 Reaffirmed - 2011 Amd - 1	Methods for random sampling
(m)	IS 7283 : 1992 (First Revision) Reaffirmed - 2007	Hot Rolled Bars for the Production of Bright Bars and Machined Parts for Engineering Application - Specification
(n)	IS 11169 : Part 1 : 1984 Reaffirmed - 2009	Specification for cold heading / cold extrusion applications : Part - 1 : wrought carbon and low alloy steels
(o)	JSS 9330 - 02 : 2008 (Revision No. 2) & CIGS / SS / 313 (a)	Polythene Film Various
(p)	U / S No. CIGS / US / 239	Label carton 50 x 25 mm

2.2 Copies of CIGS / SS / 27 (e) & CIGS / SS / 313 (a) are obtainable on payment from :

The Controller
 Controllerate of Quality Assurance (GS)
 Post Box No.127
 Kanpur - 208 004 (U.P.)

3.0 STANDARD PATTERN

3.1 Standard Pattern of Snap Hook (Static Line) PTR - M (DS Cat No. 1670 – 000 325) held by the Purchase Officer shall constitute the standard as regards any particulars or properties, not noted or defined in this specification.


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 Asstt. Director (T.C.)
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 Min. of Defence, New Delhi.

4.0

MATERIALS

4.1

The item shall be manufactured from the following materials :

SI No.	Store / component	Material & Grade if any	Specification
(a)	Plate	(i) 40 Cr 4 Mo 3 or	IS 11169 : Part 1 : 1984
		(ii) 40 Cr 5 Mo 6 or	IS 1570 : Part 4 : 1988 (Table 1)
		(iii) 40 Ni 6 Cr 4 Mo 3	- do -
(b)	Cover & Press Button	Mild Steel, 1.26 mm thick.	Grade C - 20 of IS 7283 : 1992
(c)	Safety pin and Spring for Press button.	Spring Steel Wire 1.63 mm.	BS - 1408 - C - 1964 or IS 4454 : Part - 2 : 1975
(d)	Rivet 3 mm dia length to suit	Aluminum Alloy	IS 740 : 1977

NOTE : Material used for manufacture of plate safety pin shall be from Decarburisation.

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 Snap Hook (Static Line) PTRM shall be manufactured to the shape and design as shown in the relevant plate attached to this specification.

5.2 The Snap Hook Plate shall be suitably hardened to the required hardness of 360 to 410 VHN.

5.3 The Snap Hook shall be heat treated to ensure that a tensile strength of 120 to 134 kg / Sq. m is achieved.

5.4 The Plate, Cover, Safety pin and press button are plated with Chromium over Nickel over Copper.

5.5 The Spring shall be Cadmium plated as per Service Grade No. 2 and classification No. Fe / Cd 8 of IS 1572 : 1986.

(2)mm
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Asstt. Director (T.O.)
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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 IS 2102 : Part - 1 : 1993 as given below shall apply.

Tolerance	Class	
Designation	Description	Applicable on Components / Parts
C	Coarse	Complete store except where specified in the plate.

7.0 WORKMANSHIP AND FINISH

7.1 Each Hook Snap shall be free from defects like burrs, fins, cut marks, chipping, pits, blisters, cracks and deformation. The plating shall be uniform without leaving unplated / bare spots.

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

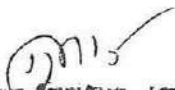
8.0 PRE - INSPECTION OF SUPPLIES BY PRODUCER

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 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 any 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.


 ॐ
 क्वालिटी निश्चयक (एफ.ए.ए.),
 Asst. Director (T.C.)
 बानकी करण निदेशालय
 Directorate of Standardisation
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 Bha. of Defects, New Delhi.

10.0 SAMPLING PROCEDURE

10.1 The suppliers shall arrange the units of the homogeneous lot in such a way that all the units are easily accessible to the Quality Assurance Officer to enable him to draw samples from any portion of the homogeneous lot.

10.2 Sampling of stores shall be done adopting appropriate sampling method as per IS 4905 : 1968 so that samples drawn as per table I and II given for assessing various quality requirements, are truly representative of the lot.

10.3 Scale of Sampling

10.3.1 The number of sample - units to be drawn for assessing the quality of the store, characteristic wise, should be in accordance with the table I for dimensional / non - destructive / visual inspection and table II for detailed laboratory testing.

11.0 CRITERIA FOR CONFORMITY

11.1 All the sample units as specified in table I and II are required to be tested / inspected irrespective of the rejection number ($= AC + 1$) being achieved earlier.

11.2 The Quality Assurance Officer shall draw samples as per table - I for dimensional / nondestructive / visual inspection to assess the quality of the lot. If the quality of the lot indicates conformity to the standard as laid down in table - 1, sampling for laboratory testing will be done. Otherwise the lot shall be straightway rejected.

11.3 Sampling for Laboratory Testing

11.3.1 If the lot is considered conforming to the quality standards as specified in table - I, sampling for laboratory tests shall be carried out as per table - II and the samples shall be subjected to the laboratory tests.

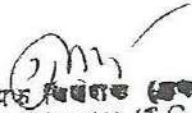
11.4 Bulk Sentencing

11.4.1 If the laboratory test report indicates that the lot does not conform to the standards as specified in table II, the whole lot shall be rejected.

11.4.2 The lot shall be considered conforming to the specified quality if the number of defective units observed in the sample is not more than the respective acceptance number of each class of defects.

11.4.3 When the sample size equals to the lot size, do 100 % Quality Assurance.

11.4.4 The number of sample units to be sampled for laboratory testing should be a multiple of the number of Characteristics / tests which cannot be carried out simultaneously on the same sample units.


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 Min. of Defence, New Delhi.

11.5 Sampling and Formation of Lot

11.5.1 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.

11.6 Sampling Tables

TABLE - I


**SAMPLING PLAN FOR VISUAL INSPECTION
(Based on General Inspection Level II - A, AQL 2.5 %)**

Sl. No.	Lot Size	Sample Size (n)	Acceptance Number (Ac)
(a)	Up to 50	8	1
(b)	51 to 90	13	1
(c)	91 to 150	20	1
(d)	151 to 280	32	2
(e)	281 to 500	50	3
(f)	501 to 1200	80	5
(g)	1201 to 3200	125	7
(h)	3201 to 10000	200	10

TABLE - II

SAMPLING PLAN FOR LABORATORY TESTING, AQL 2.5%

Sl. No.	Lot Size	Sample Size (n)		Acceptance Number (Ac)	
		S - 3	S - 4	S - 3	S - 4
(a)	Up to 50	3	5	0	0
(b)	51 to 90	5	5	0	0
(c)	91 to 150	5	8	0	0
(d)	151 to 280	8	13	0	0
(e)	281 to 500	8	13	0	0
(f)	501 to 1200	13	20	0	0
(g)	1201 to 3200	13	32	0	1


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 रषुड डरुडलड, नई दललु,
 Min. of Defence, New Delhi-11

- NOTE :**
- (1) When the sample size equals 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 test (individual sample to be tested).
 - (4) Level S - 4 for physical test (individual sample to be tested).

SOURCE : 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.

12.0 TEST METHOD

12.1 Physical Tests - (Design, Shape, Dimensions) - The hardness of the Snap Hook shall be 360 to 410 VPN.

12.2 Chemical Test - (Chemical Analysis)

12.2.1 The Plating of Plate, Cover, Safety pin and Press button shall conform to the Service grade No. 3 and classification No. Fe / Cu / 15 Ni 25 P (err of (Table 1B of IS 1068 : 1993).

12.2.2 Adhesion - Adhesion of the coating shall be tested as per IS 1068 : 1993.


12.2.3 The spring of Press button shall be Cadmium plated to service grade No. 2 of IS 1572 : 1986 and Chrome passivated.

12.2.4 Corrosion Resistance - The store shall withstand the Corrosion test laid down in IS 1068 : 1993.

12.3 Performance Test

12.3.1 Proof Load Test (100 %) - Each Snap Hook static Line PTR - M shall be subjected to the proof load test for 1360 kg as per direction shown in the drawing. The load shall be applied gradually and maintained for not less than 10 seconds. The samples should not show any sign of permanent set / breakage / damage after the test. The functioning of press button should be satisfactory after the load test for locking / unlocking of cover plate over the snap hook body.

12.4 Crack Detection Test - There shall be no crack in the heat treated and finished components after proof loading. All components / details required to be proof load tested shall be tested for cracks after finishing and prior to plating. The crack detection will be done by the use of a suitable magnetic crack detector. After crack detection test, the components shall be fully demagnetised by the supplier.


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 Dept. of Defence, New Delhi.

13.0 WARRANTY

13.1 Stores supplied against this specification shall be deemed to bear the warranty of the contractor against defective design material, workmanship and performance for a period of 12 months from the date of receipt of store at consignee end. and if during the specified period, the store supplied are 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.

14.0 MARKING

14.1 Marking by the Supplier

14.1.1 The store shall be legibly and indelibly marked with the following markings on the label attached by tie - on - tag method :

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

14.2 Marking by the Quality Assurance Officer

14.2.1 In case of small components, where steel stamping or stencilling 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.

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

5340 - 000 325
 X Firm's Name X
 Year

15.0 PACKAGING

15.1 Packing Materials

Sl. No.	Material	Conforming to
(a)	Polythene films 0.04 mm thick (Low density bag)	JSS 9330 - 02 : 2008 (Revision No. 2) & CIGS / SS / 313 (a)

Sl. No.	Material	Conforming to
(b)	Wooden Packing Case	IS 1503 : 1988
(c)	Hot Rolled Steel Strips Bailing	IS 1029 : 1970
(d)	Adhesive Paper Tapes	IS 4185 : 1989 & Supp. Sch. No. CIGS / SS / 185 (b).
(e)	Label Card Board 45 x 25 mm with tie - on - tag	0.89 mm thick, Average Bursting Strength 775 Kpa
(f)	Label Carton 50 x 25 mm	U / S No. CIGS / US / 239.

15.2 Method of Packaging

15.2.1 Each Snap Hook shall be individually packed in a Polythene bag of 0.04 mm thick of suitable size. Five such packets shall be kept in a card board of suitable size. Each box shall be sealed by gummed paper tape 25 mm wide in the middle by pasting the same around the width and overlapping the ends at least 25 mm at the top and then be rubber stamped with acceptance mark suitable with sealing joints. Fifty such Boxes shall be packed in a wooden packing case. Wooden packing cases shall be strapped with Hot Rolled Steel Strip 10 mm x 0.4 mm thick widthwise at two places inside the battens. Each CWP shall be affixed with a label Carton 50 x 25 mm bearing D.S. Cat No., Nomenclature, Quantity packed and year of manufacture.

15.3 Marking on Package

15.3.1 Each final package shall be legibly and indelibly marked as under :

- (a) D.S. Cat. Number and designation of the store.
- (b) Quantity 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) Consignor's name, initials or recognised Trade Mark.
- (g) Month and year of packing.
- (h) A / T, S / O or Extract Number and Date.
- (j) I / Note Number and Date.

16.0 **DEFENCE STORES CATALOGUE NUMBER**

16.1 The stores covered by this specification shall bear the following DS Cat Number :

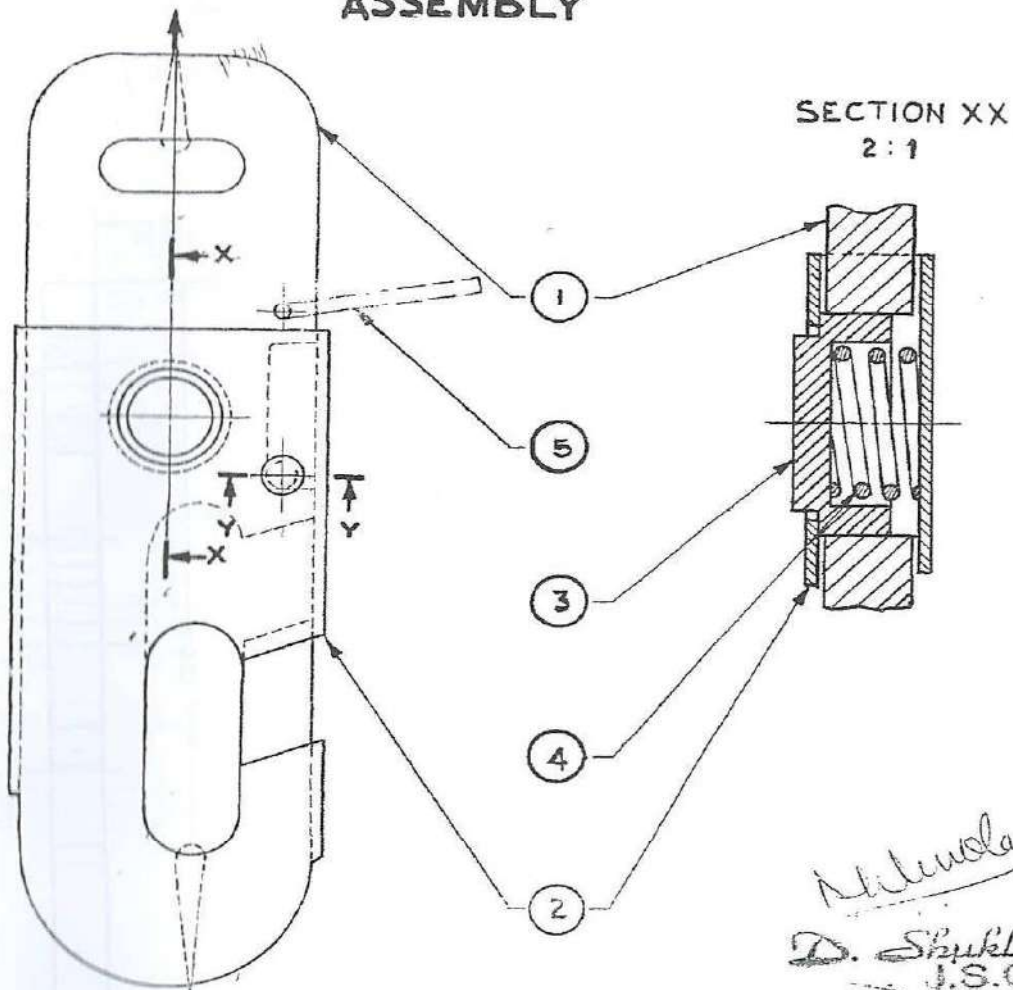
DS Cat No.	Nomenclature
5340 - 000 325	SNAP HOOK STATIC LINE (PTR - M)

17.0 **SUGGESTIONS FOR IMPROVEMENT**

17.1 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

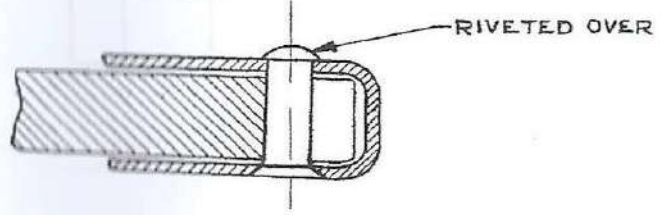


**SECTION XX
2:1**

M. Shukla
D. Shukla
 J.S.O.
 5.5/10/2014

PROOF LOAD - (1350 kg) OR 13540 N

**SECTION YY
2:1**



	DATE	NAME	ALL DIMENSION ARE IN M.M.	Dte. OF STANDARDISATION MINISTRY OF DEFENCE STORES STD. SUB COMMITTEE
DGN.			D.S. CAT No. 5340 - 000 325	
R. DRN		P D ARYA	JSS No. 5340 - 05 : 2014	
CHD.				
TRD.				
COMP.		P D ARYA		
			SNAP HOOK (STATIC LINE) PTR-M	APPROVED DIRECTOR
				JSS No. 5340 - 05
				GS-9/14/2014

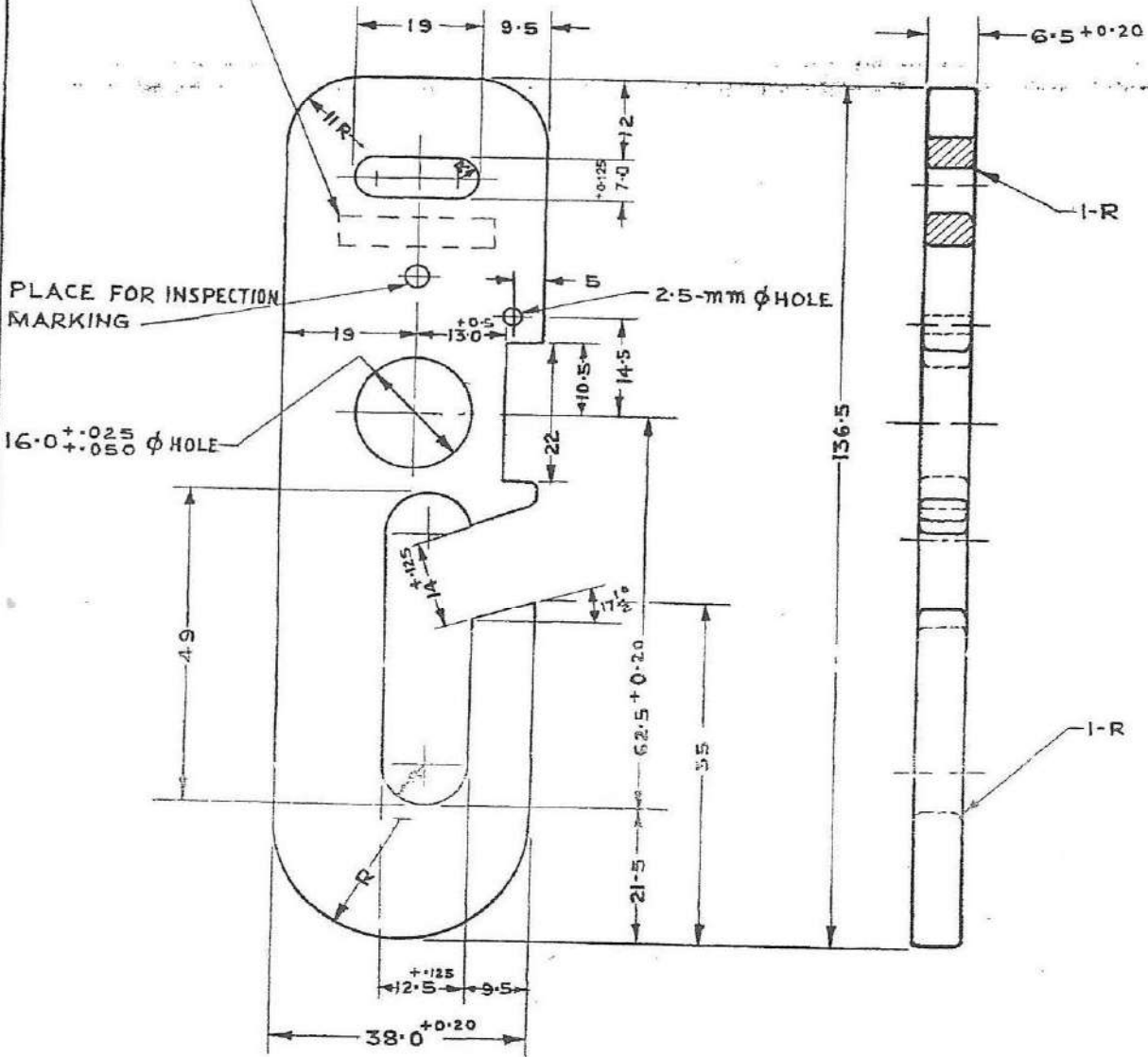
D. Shukla
D. Shukla
J.S.O.
 90/CS-2 & 6

PLATE

1-OFF

①

PLACE FOR MANUFACTURER'S MARKING AND YEAR OF MANUFACTURE



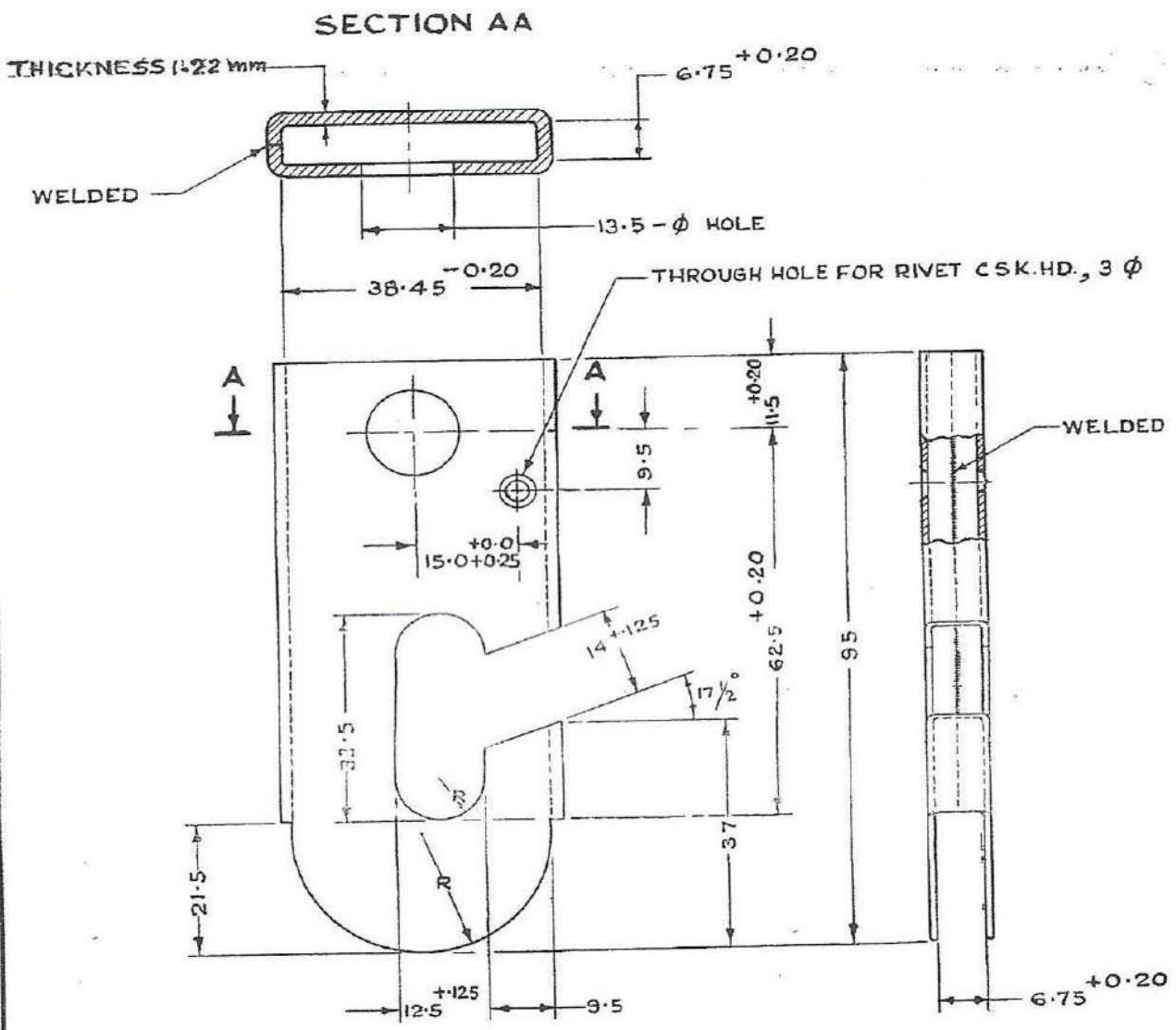
NOTE -

ALL SHARP EDGES ARE TO BE REMOVED AND ROUNDED OFF

DATE	NAME	ALL DIMENSION ARE IN M.M.	Dts. OF STANDARDISATION MINISTRY OF DEFENCE STORES STD. SUB COMMITTEE
DGN.		D.S. CAT No. 5340 - 000 325	
R. DRN	P D ARYA	JSS No. 5340 - 05 : 2014	
CHD.		SNAP HOOK (STATIC LINE) PTR-M	 APPROVED DIRECTOR
TRD.			
COMP.	P D ARYA		JSS No. 5340 - 05
			GS-9/14/2014

Handwritten: D. Shukla J.S.O. GS/CS-286
 SHEET 3 OF 5
 2

COVER



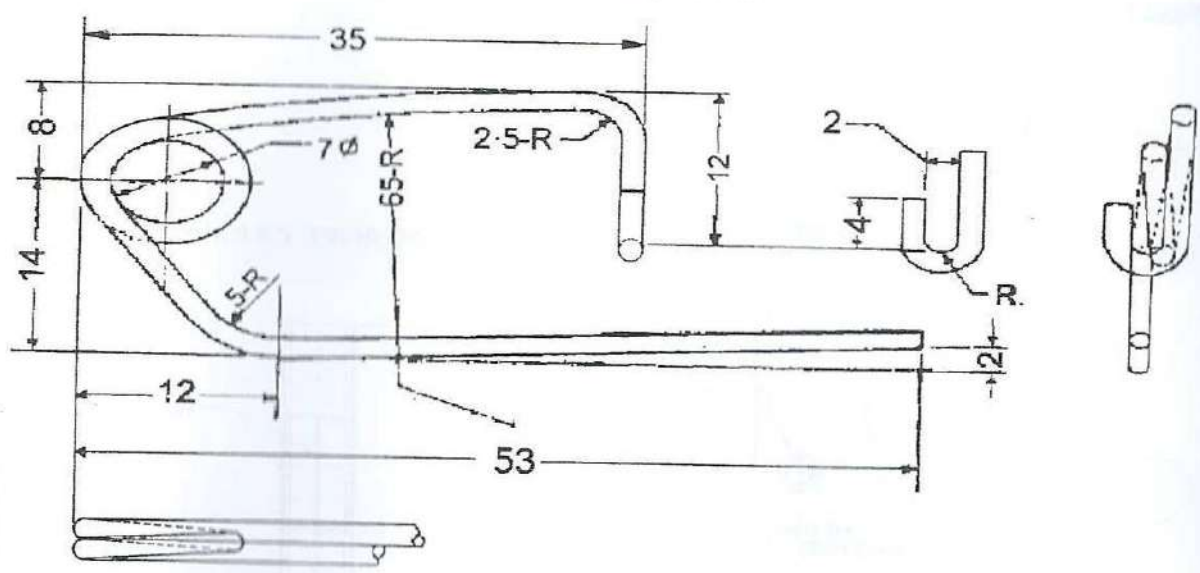
NOTE - ALL SHARP EDGES TO BE REMOVED

	DATE	NAME	ALL DIMENSION ARE IN M.M.	Dtd. OF STANDARDISATION MINISTRY OF DEFENCE STORES STD. SUB COMMITTEE
DGN.			D.S. CAT No. 5340 - 000 325	
R. DRN		P D ARYA	JSS No. 5340 - 05 : 2014	
CHD.			SNAP HOOK (STATIC LINE) PTR-M	 APPROVED DIRECTOR JSS No. 5340 - 05 GS-9/14/2014
TRD.				
COMP.		P D ARYA		

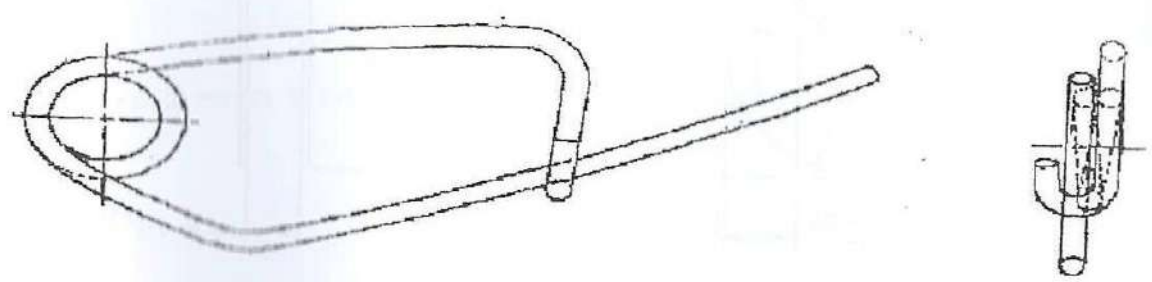
SAFETY - PIN
1 - OFF

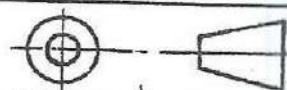

D. Shukla
D. Shukla
J.S.O.
G.O. / GS-226 **(5)**

RELEASED POSITION



LOCKED POSITION



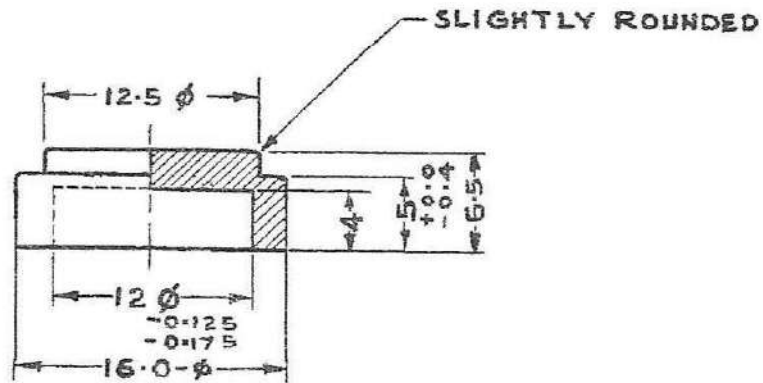
DATE	NAME	ALL DIMENSION ARE IN M.M.	Dte. OF STANDARDISATION MINISTRY OF DEFENCE STORES STD. SUB COMMITTEE
DGN.		D.B. CAT No. 5340 - 000 325	
H. DRN	P D ARYA	JSS No. 5340 - 05 : 2014	 APPROVED  DIRECTOR JSS No. 5340 - 05 GS-9/14/2014
CHD.			
TRD.			
COMP.	P D ARYA		
SNAP HOOK (STATIC LINE) PTR-M			

M. Shukla SHEET 5 OF 5
D. Shukla
 J.S.O.
 G.O./G.S. 2 & 6

3

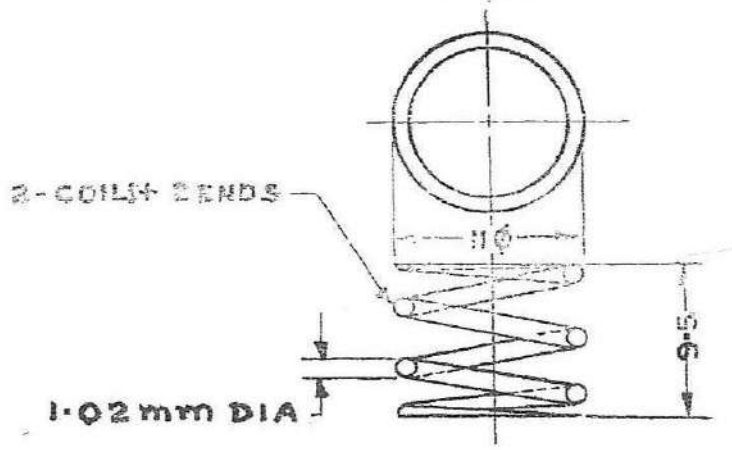
PRESS BUTTON

1-OFF



SPRING

1-OFF



4

DATE	NAME	ALL DIMENSION ARE IN M.M.	Dte. OF STANDARDISATION
DRN	P D ARYA	D.S. CAT No. 5340 - 000 325	MINISTRY OF DEFENCE
CHD.		JSS No. 5340 - 05 : 2014	STORES STD. SUB COMMITTEE
TRD.		SNAP HOOK (STATIC LINE) PTR-M	APPROVED
OMP	P D ARYA		<i>[Signature]</i> DIRECTOR
			JSS No. 5340 - 05
			GS-9/14/2014