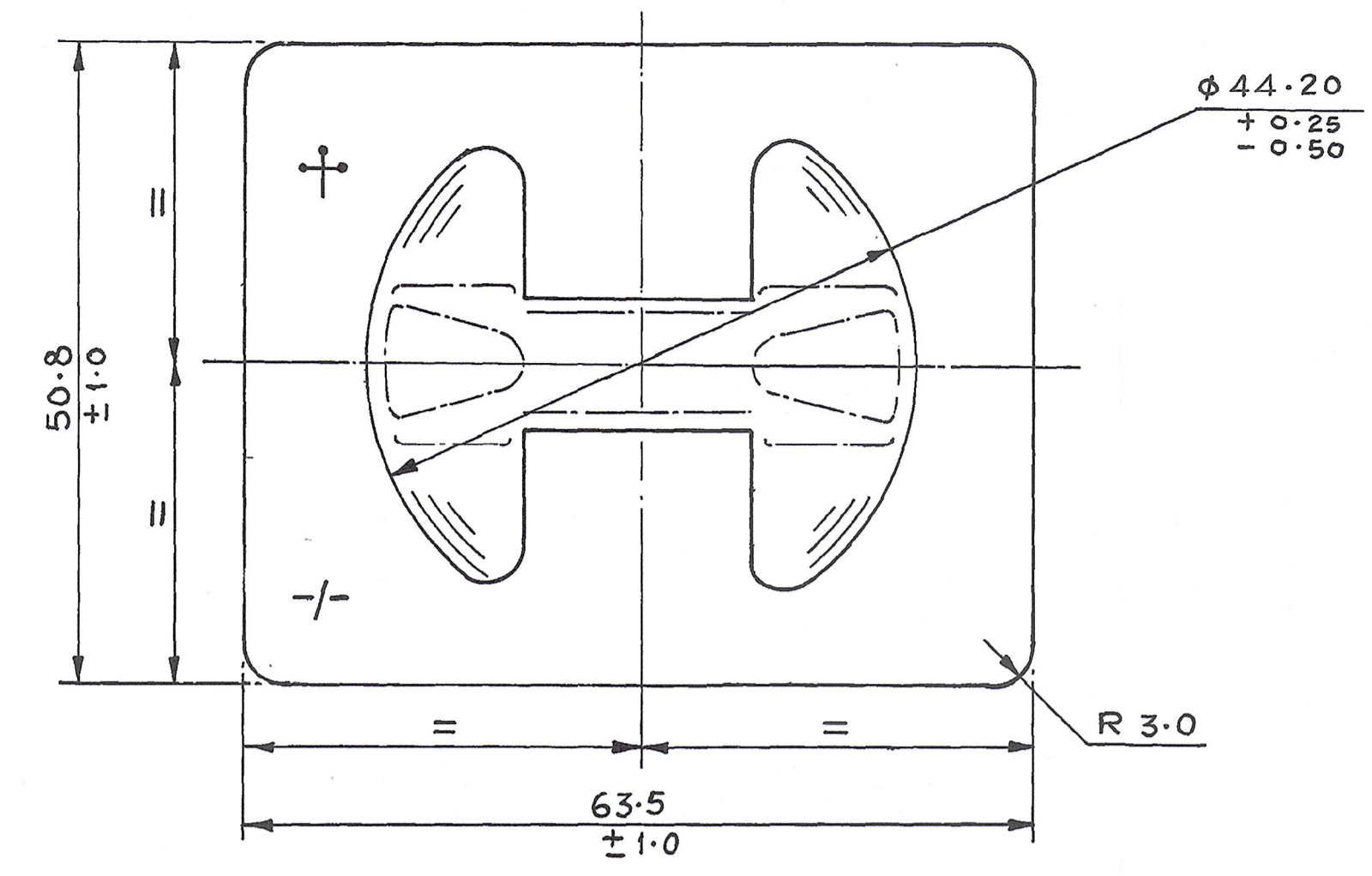


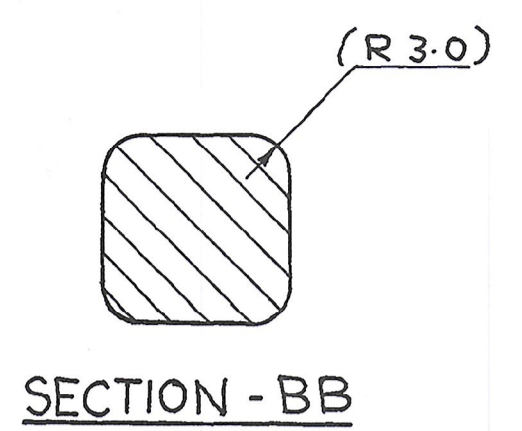
DRG CONVENTIONS CONFORM TO IS: 696.
DIM ARE IN mm
GEN. TOL MEDIUM CLASS TO IS: 2102

DRG NO. **ARM 1461 D**
PART NO.
SHTS/SHT NO.



MARKING TO BE STAMPED ON:-
 † CONTRACTOR'S INITIALS OR RECOGNISED TRADE MARK.
 -/- DATE OF MANUFACTURE (MONTH AND YEAR)

ROUND OFF SHARP EDGES BY R 0.5



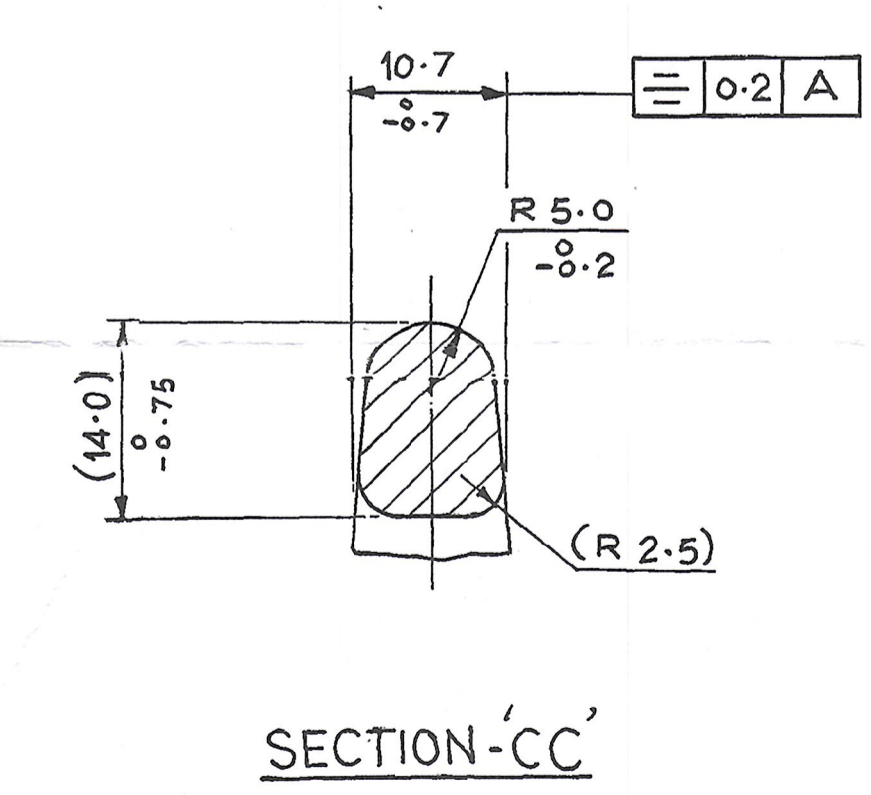
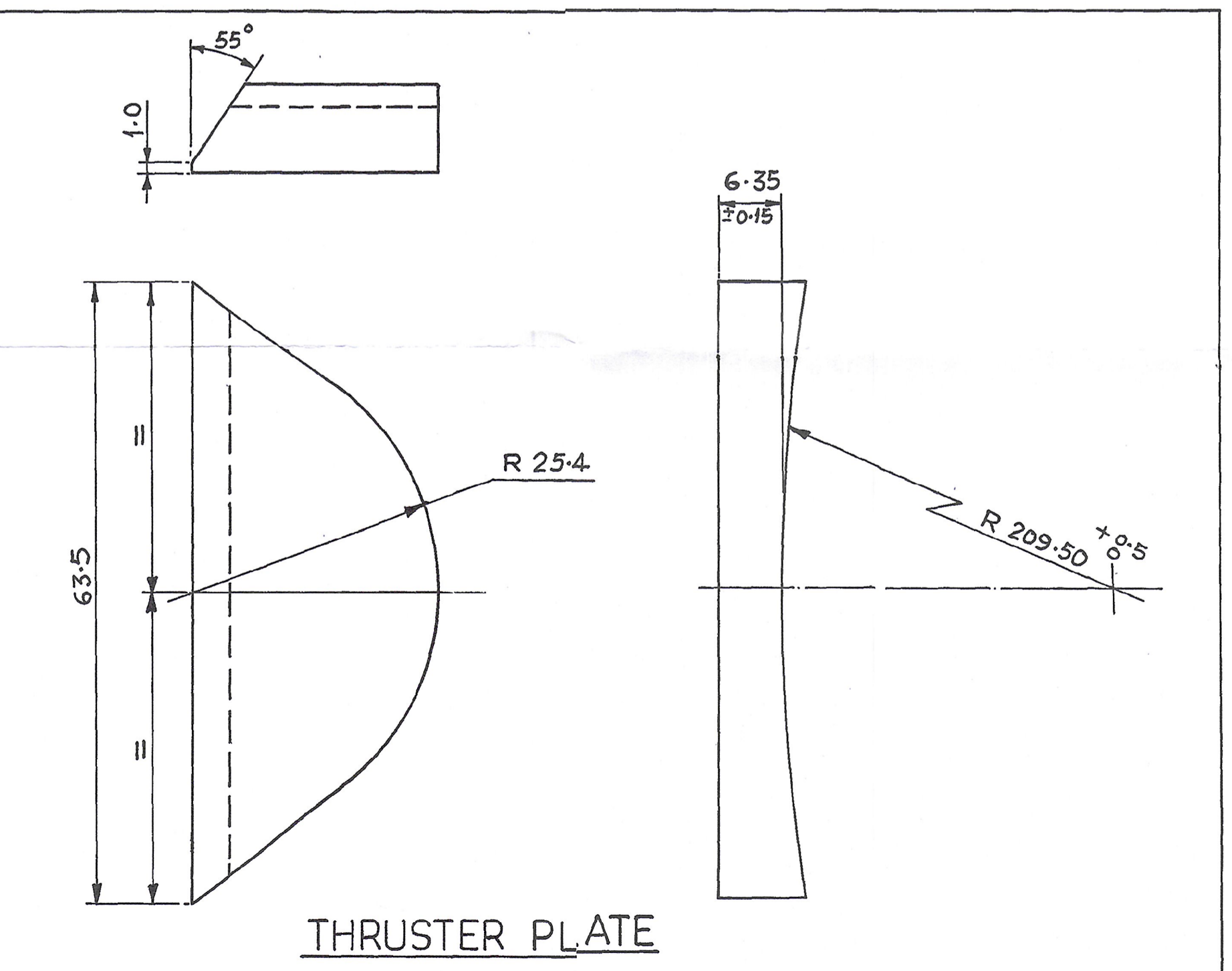
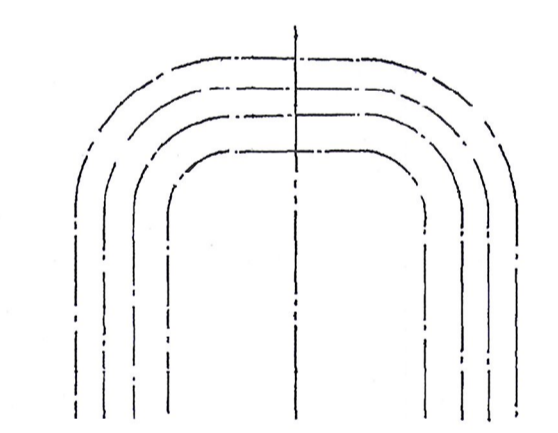
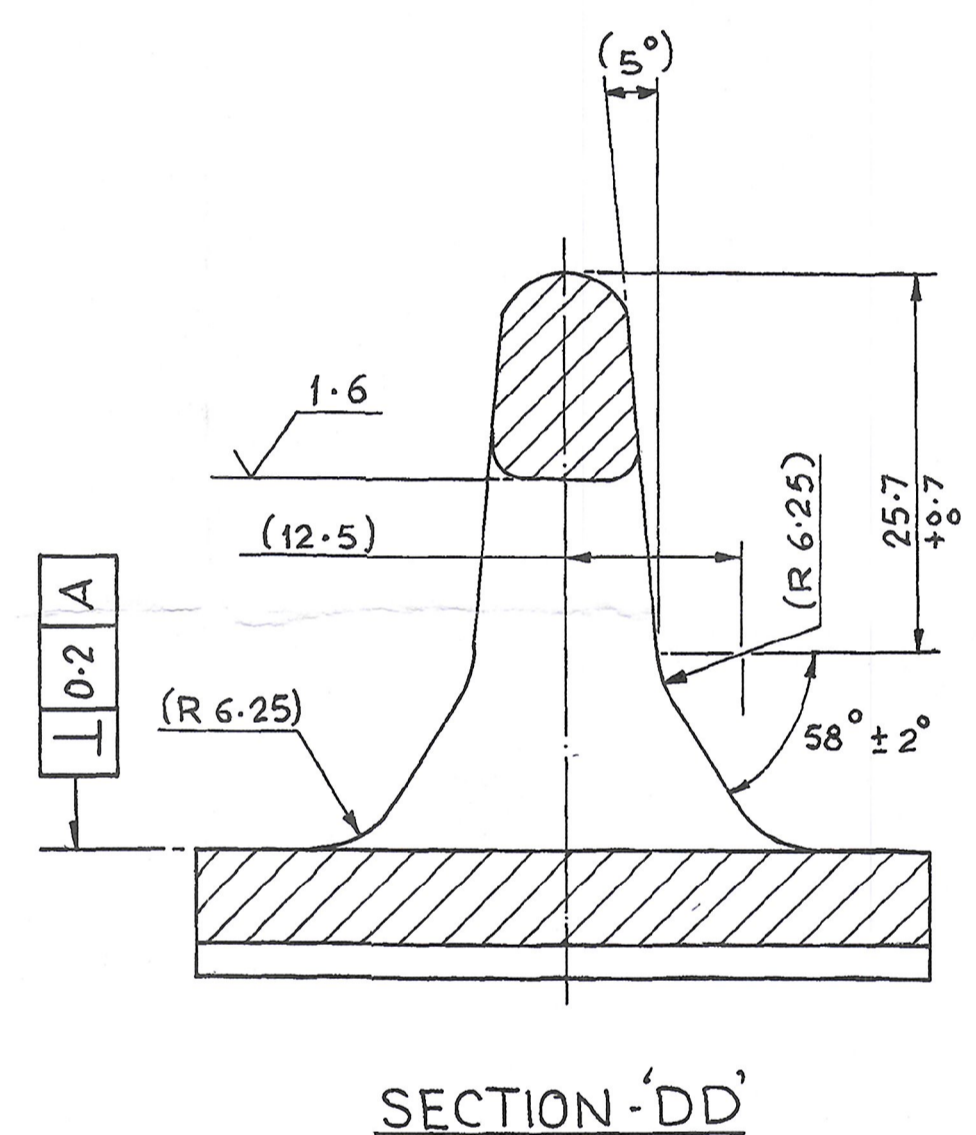
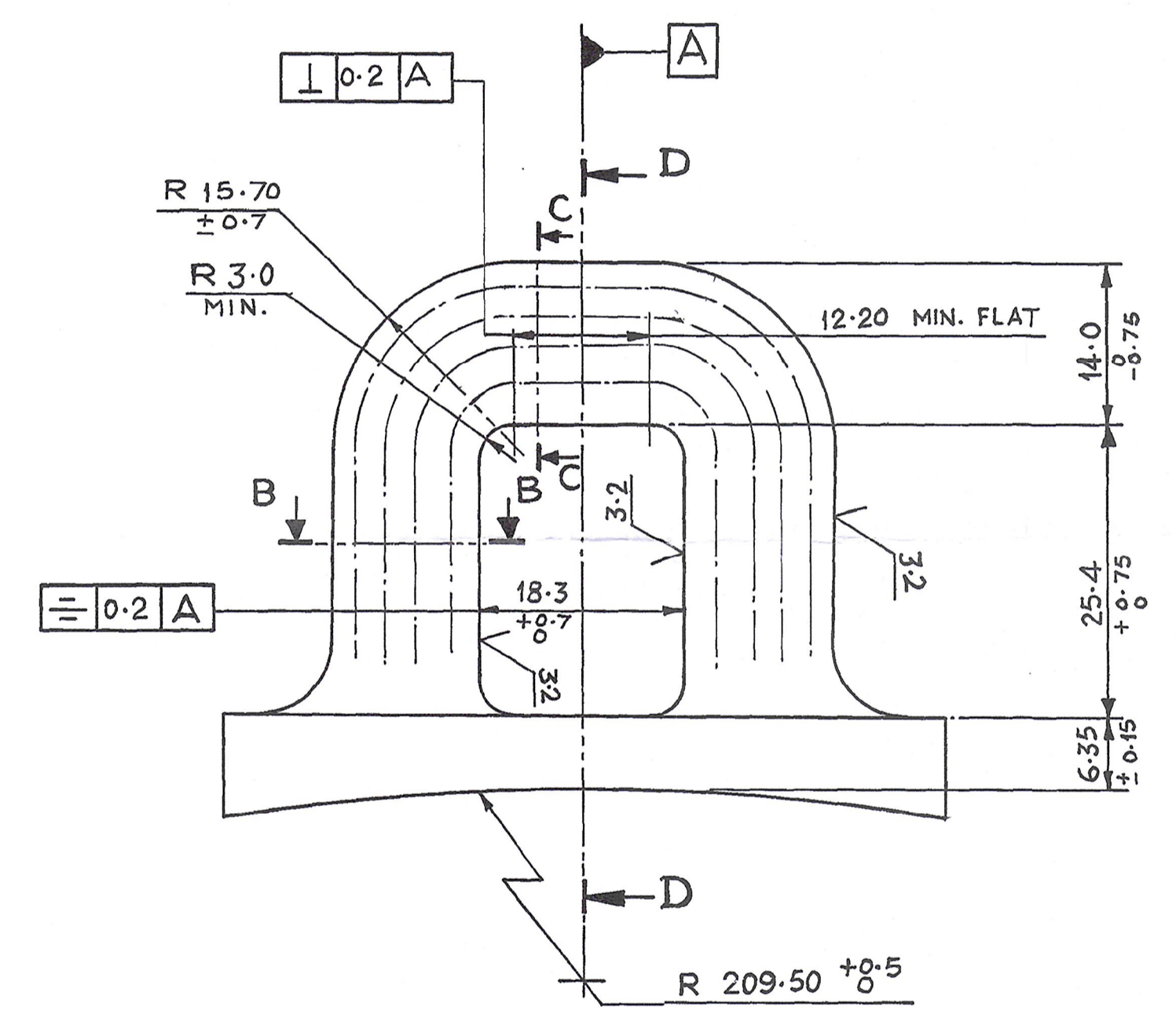
NOTES:-

- AFTER HEAT-TREATMENT, ALL LUGS ARE TO BE TESTED FOR HARDNESS TO MATERIAL SPECIFICATION BY DIAMOND IMPRESSION ON THE BOTTOM SURFACE.
- FLAW DETECTION :- ALL LUGS SHALL BE INSPECTED FOR FLAWS BY AN APPROVED MAGNETIC FLAW DETECTION PROCESS.
- PROTECTIVE FINISH :- THE LUGS ARE TO BE PROVIDED WITH PROTECTIVE FINISH Zn-SPRAYING TO SPECN. NO IS-5905 FOLLOWED BY PAINTING IN THE SAME WAY AS GIVEN TO THE BOMB BODY.
- TESTING :- THIS SHALL BE CARRIED OUT IN THE SEQUENCE DETAILED BELOW IN PARAGRAPHS (a), (b) AND (c) AFTER 100% CRITICAL INSPECTION. EACH LUG SHALL BE WELDED TO BODY OF 1000 lb MK 4in BOMB OR TO RECTANGULAR SPECIMEN MADE OUT OF 14 mm THICK MATERIAL HAVING COMPOSITION AND MECHANICAL/PHYSICAL PROPERTIES OF BOMB MATERIAL FOR TESTING PURPOSE. WELD SPECIFICATION/INSPECTION SHALL BE GOVERNED BY SPEC. IS: 815, 822 AND 823

(a) FATIGUE TESTING :- FROM ANY NEW CONTRACT OR NEW CONTRACTOR OR AFTER ANY CHANGE OF MATERIAL SPECIFICATION, DIMENSION, OF MANUFACTURING TECHNIQUE, THE FOLLOWING QUANTITIES OF LUG SHALL BE SUBJECTED TO THIS TEST. THIS FIRST LUG PRODUCED PLUS 2% FROM EACH HEAT TREATMENT (HT) BATCH (MINIMUM 5 FOR EACH OF INITIAL 4 HT BATCHES AND 4 CONSECUTIVE HT BATCHES AFTER ANY REJECTION) SHALL BE SUBJECTED TO A MEAN LOAD OF 2,000 da N WITH AN ALTERNATING LOAD OF ± 1000 da N (MAX. 3000 da N, MIN 1000 da N) AT A FREQUENCY OF 15 TO 25 Hz. RUPTURE MUST NOT OCCUR. MAXIMUM NUMBER OF REVERSALS 50000. THE LOAD SHALL BE APPLIED TO THE JOURNAL FLAT IN A PERPENDICULAR DIRECTION BY SUITABLE ADAPTOR.

(b) ALL LUGS THAT HAVE BEEN SUBJECTED TO FATIGUE TESTING SHALL BE RE-INSPECTED FOR FLAWS BY THE PROCESS DEFINED IN NOTE 2 PRIOR TO SUBMISSION TO DESTRUCTIVE TESTING.

(c) DESTRUCTIVE TESTING :- ALL LUGS THAT HAVE BEEN SUBJECTED TO THE REQUIREMENTS OF 4 (a) & 4 (b) SHALL BE TESTED TO DESTRUCTION. EACH LUG SHALL WITH STAND A MINIMUM FAILING LOAD OF 9500 da N APPLIED PERPENDICULAR TO THE JOURNAL FLAT.



DESIGN IS BASED ON FIG 2 (F US SPEC MIL A 8591 G .

DRN-SKK	CHD	TRD	COMP	ASSY DRG.
CD	PASSED	SCALE	2:1	DESIGN AUTHORITY
2 5-10-01	RETRACTED WITHOUT CHANGE	EST. WEIGHT		
1 3-10-86	AMENDED WIDE AL NO. 562	GAUGE SCHED		
R. NO.	DATE	AUTHORITY	BRIEF RECORD	ZONE
			CD GO	MATL-STEEL '0 SPEC B.S. 970 En 14 A OR
			SIGN	IS-1570 20 Mn 2.
DRG SEALED PROVISIONAL		Sd.		PROTECTIVE FINISH- SEE NOTE NO.3

LUG SUSPENSION NO. 243 AND THRUSTER PLATE

DRG. NO. **ARM 1461 D**
 DET NO. SHTS SHT NO.
 PART NO.
 D.S. CAT NO.
 AHSP DGAQA