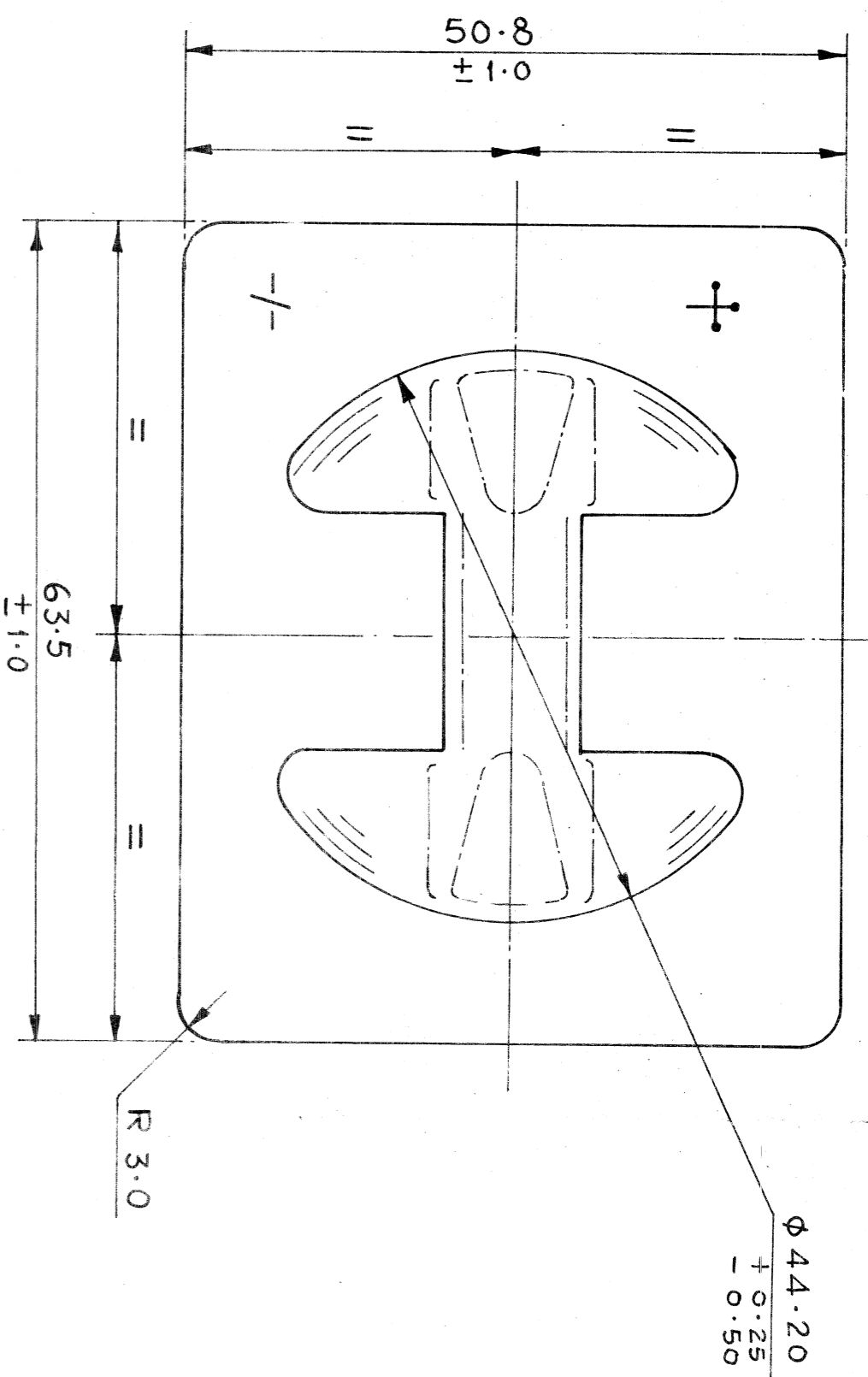


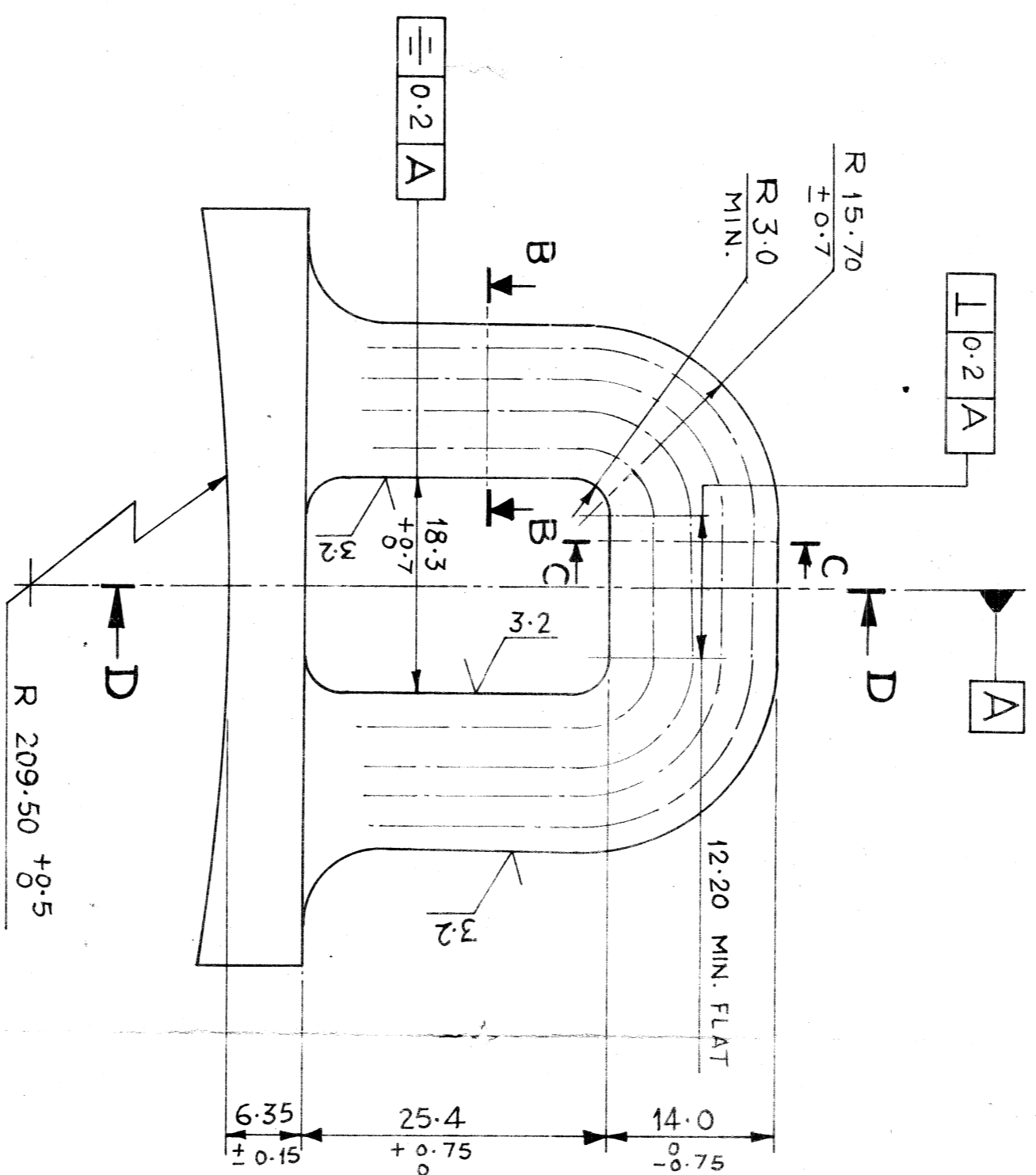
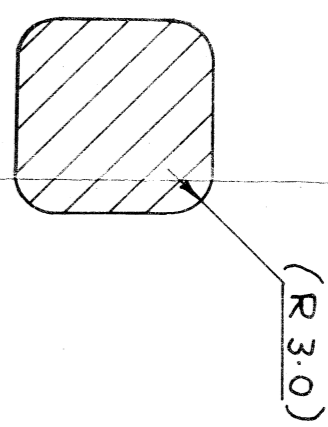
MARKING TO BE STAMPED ON:-

+ CONTRACTOR'S INITIALS OR RECOGNISED TRADE MARK
 -/- DATE OF MANUFACTURE (MONTH AND YEAR)

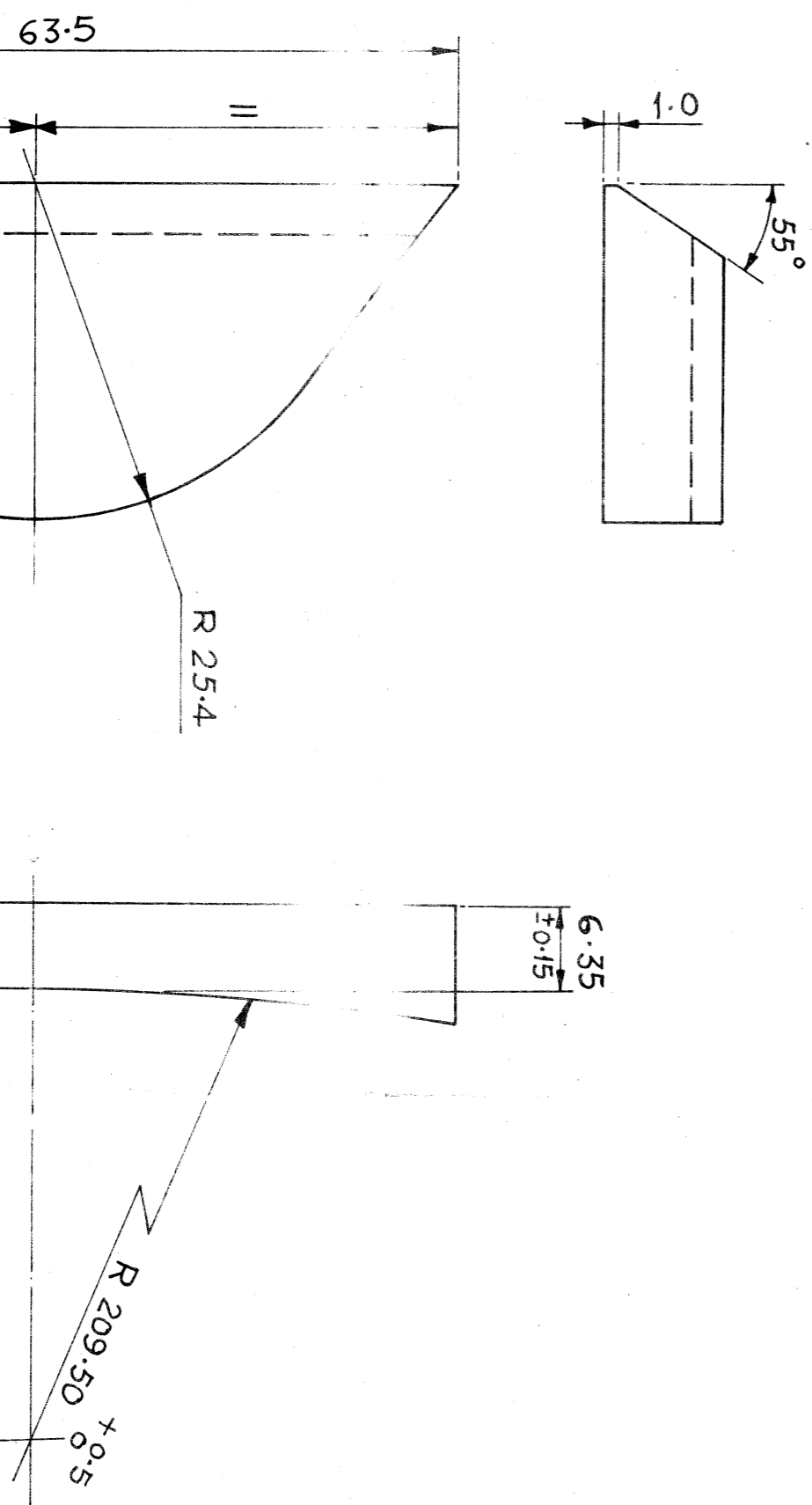
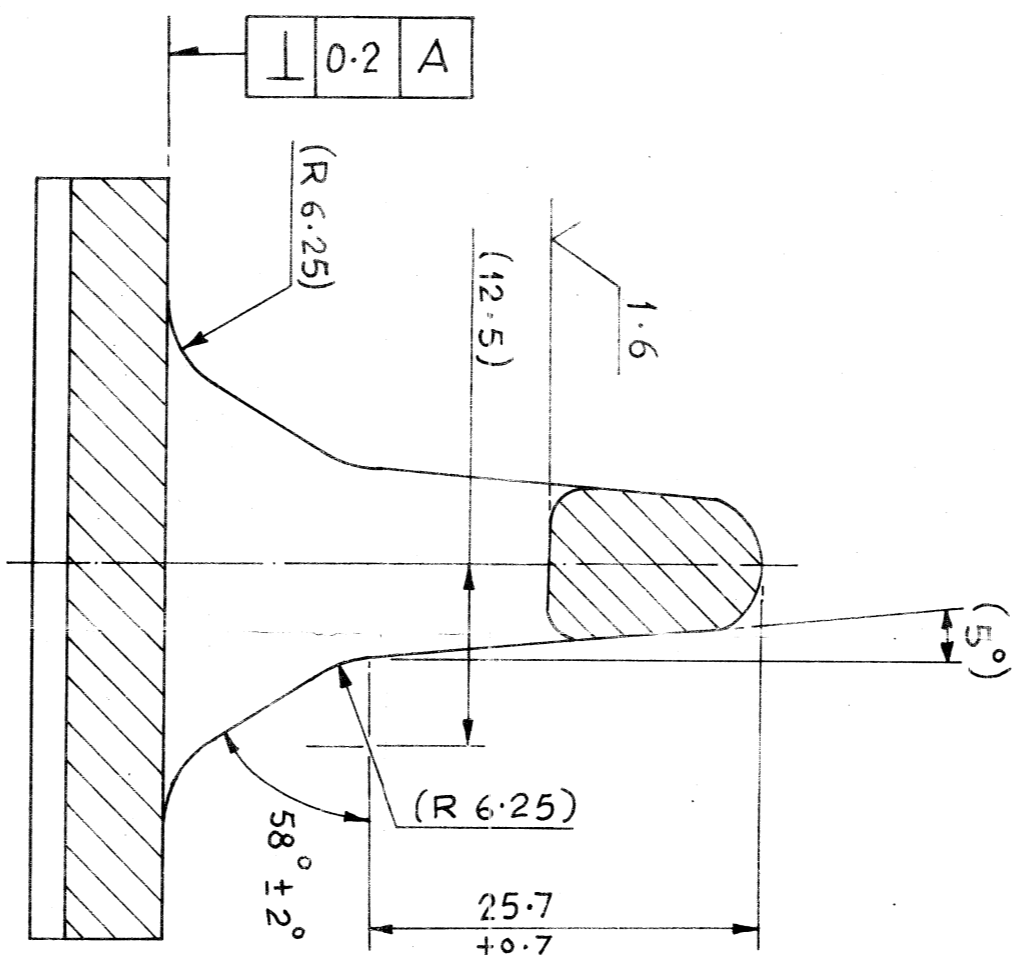
ROUND OFF SHARP EDGES BY R 0.5.



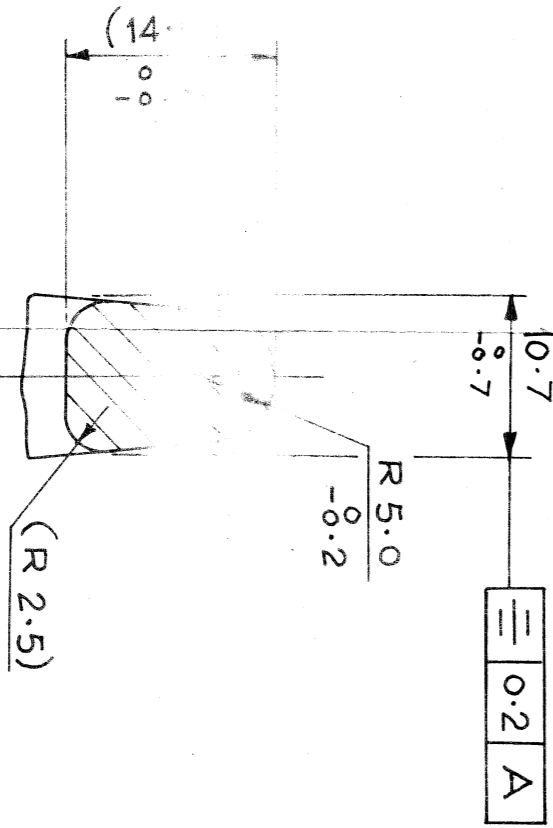
SECTION - BB



SECTION - DD



SECTION - CC



NOTES:-

1. AFTER HEAT-TREATMENT, ALL LUGS ARE TO BE TESTED FOR HARDNESS TO MATERIAL SPECIFICATION BY DIAMOND IMPRESSION ON THE BOTTOM SURFACE.
2. FLAW DETECTION - ALL LUGS SHALL BE INSPECTED FOR FLAWS BY AN APPROVED MAGNETIC FLAW DETECTION PROCESS.
3. 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.
4. 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 IN 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 BATCHES AFTER ANY REJECTION) SHALL BE SUBJECTED TO A MEAN LOAD OF 2000 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 5000. 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 OF US SPEC MIL A 8591 G.

DRG NO.	ARM 1461 D	ASSY DRG.	
DET NO.		DESIGN AUTHORITY	
PART NO.			
D.S. CAT NO.			
AHSP DGAQA			
DRG NO.	ARM 1461 D	DRN - SKK	
DET NO.		CD	
PART NO.		TRD	
D.S. CAT NO.		SCALE	2:1
		EST. WEIGHT	
		GAUGE SCHD	
		DATE	2/12/85
		OR	
		CD	
		GO	
		SIGN	
		PROTECTIVE FINISH	SEE NOTE NO. 3
		DRG SEALED	PROVISIONAL
		BRIEF RECORD	
		AUTHORITY	
		DATE	5/10/86
		RETRAGED WITHOUT CHANGE	
		AMENDED	VIDE A.L. NO. 562
		NO.	1
		ZONE	
		MATL - STEEL	
		OR	
		0 SPEC B.S. 970 EN 14 A OR	
		MIN 2.	
		PROTECTIVE FINISH	SEE NOTE NO. 3
		DRG	SEALED
		PROVISIONAL	
		CD	
		TRD	
		SCALE	2:1
		EST. WEIGHT	
		GAUGE SCHD	
		DATE	2/12/85
		OR	
		CD	
		GO	
		SIGN	
		PROTECTIVE FINISH	SEE NOTE NO. 3
		DRG	SEALED
		PROVISIONAL	
		BRIEF RECORD	
		AUTHORITY	
		DATE	5/10/86
		RETRAGED WITHOUT CHANGE	
		AMENDED	VIDE A.L. NO. 562
		NO.	1
		ZONE	
		MATL - STEEL	
		OR	
		0 SPEC B.S. 970 EN 14 A OR	
		MIN 2.	
		PROTECTIVE FINISH	SEE NOTE NO. 3
		DRG	SEALED
		PROVISIONAL	

LUG SUSPENSION NO. 243 AND THRUSTER PLATE