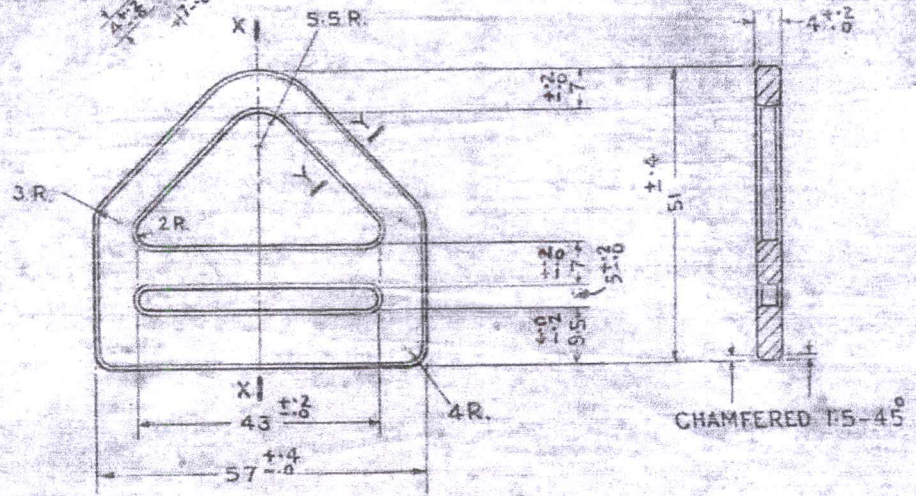


SECTION-YY

SECTION-XX



MATERIAL:- 55 CARBON STEEL TO SPEC. No. BS: 970-PT. 1: 1972, DESIGNATION Q70 M55.
OR
STEEL TO SPEC. No. BS: 970-PT. 2: 1970, DESIGNATION T09 M40.

HARDNESS:- 260-320 VPH.

PLATING:- TO BE CADMIUM PLATED TO AN AVERAGE THICKNESS OF 0.012 mm MIN. AND CHROMATE PASSIVATED TO SPECN-1.5:1572 GRADE A TYPE 2. THE PLATING SHALL BE EVEN AND UNIFORM THROUGHOUT. THE PLATING SHALL NOT PEEL OFF. THE 'D' RINGS SHALL BE FINISHED SMOOTH BEFORE BEING PLATED.

PROOF LOAD:- THE TRIANGULAR 'D' RING SHALL BE SUBJECTED TO A PROOF LOAD OF 11130N (1135KG). THE LOAD SHALL BE GRADUALLY INCREASED AND MAINTAINED AT 1135 Kgs FOR NOT LESS THAN 10 SECONDS. THE 'D' RINGS SHALL SHOW NO SIGNS OF DAMAGE OR PERMANENT SET. 100% CHECK WILL BE MADE.

PACKING:- THE TRIANGULAR 'D' RINGS WILL BE INDIVIDUALLY WRAPPED IN TISSUE PAPER AND TWENTY NUMBERS PACKED IN PAPER PACKING AND TIED WITH JUTE TWINE. TWENTY FIVE SUCH PACKS WILL BE PACKED IN CASES WOOD PACKING (SUITABLE FOR RAIL TRANSIT) LINED WITH PAPER PACKING WATER PROOF. ONE 'D' RING IN EACH PACKING WILL BE IDENTIFIED WITH A LABEL INDICATING THE NOMENCLATURE, INITIALS OF THE MANUFACTURER AND THE YEAR OF MANUFACTURE. THE CASES WOOD PACKING WILL BE LEGIBLY MARKED WITH THE NAME OF THE CONSIGNEE, CONSIGNOR, DESIGNATION OF THE STORE, QUANTITY PACKED AND THE NUMBER OF THE INDIVIDUAL PACK.

EMBRITTLMENT RELEASE
D'RINGS AFTER CADMIUM PLATING AND PRIOR TO CHROMATE PASSIVATION SHALL BE MAINTAINED AT A TEMP. OF 150° TO 200°C FOR NOT LESS THAN HALF AN HOUR TO REMOVE HYDROGEN EMBRITTLMENT.

DATE		NAME	SIGNATURE
DGN.			
DEN.		(R.K. BAJAJ)	
CHD.		(O.P. LONI)	
PELTD.		(S. K. SINGH)	
COMP.		(S. K. SINGH)	
PASSD.			

ALL DIMENSIONS IN MILLIMETRES.

TRIANGULAR 'D' RING THIRD-ANGLE PROJECTION

SCALE: 1/1

FOR
BRAKE PARACHUTE (HINDI)
/HF-24/ GNAT MK II

APPROVED BY: 15/5/73
BY: DIR. (DEV)

PROV. DRG. No. C165/65-14/66

PROV. DRG. No. C165/65-14/66