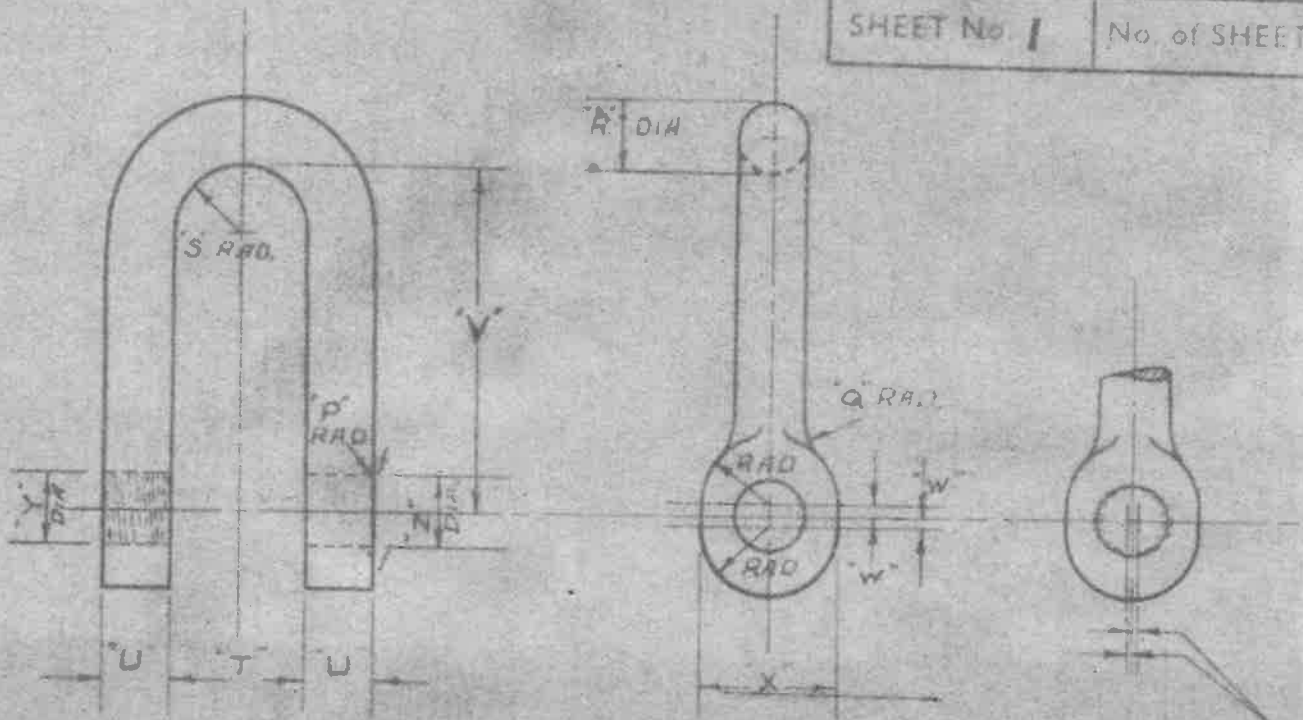


C.10.36  
32/12/36



TO BE MACHINED WHERE MARKED

HOLE MUST NOT BE MORE THAN 0.02" OFF THE CENTRE LINE OF THE SHACKLE.

MARK	NOMINAL SIZE OF SHACKLE	Z +0.05 +0.05	Y	X -0 +0.03	W 0 +0.02	V 0 +0.06	U -0 +0.03	T -0 +0.03	S -0 +0.03	R 0 +0.03	Q 0 +0.03	P 0 +0.01	PROOF LOAD	WELDED OR WIRE SHTABLE
C	3/8 IN	3/8 IN	3/8 BSF	.72	.06	1.80	.36	.72	.36	.36	.36	.12	2100	1/4
D	7/16	7/16	7/16 BSF	.84	.07	2.10	.42	.84	.42	.42	.42	.14	2860	5/16
E	1/2	1/2	1/2 BSF	.96	.08	2.40	.48	1.00	.48	.48	.48	.16	3730	3/8
F	5/8	5/8	5/8 BSF	1.20	.10	3.00	.60	1.20	.60	.60	.60	.20	5830	7/16
G	3/4	3/4	3/4 BSF	1.44	.12	3.60	.72	1.50	.72	.72	.72	.24	8400	1/2

SPECIFICATION - THE MATERIAL TO BE TO B.S. SPEC# S.6-C. (LATEST ISSUE)

SCREW THREADS - BRITISH STANDARD FINE (BSF) TO B.S. SPEC. N° 84.

TO BE ZINC OR CADMIUM COATED BY AN APPROVED PROCESS.

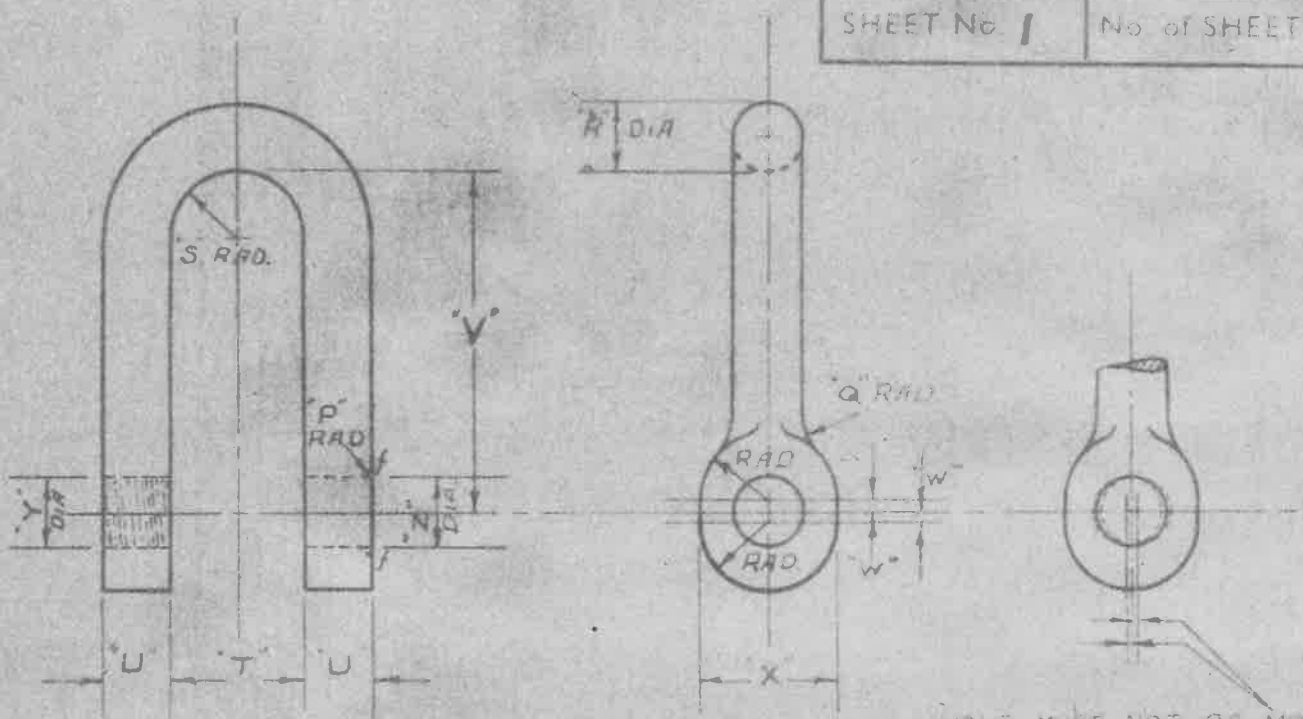
COATING TO BE NOT LESS THAN .0003" THICK.

THE PROOF LOAD IS TO BE APPLIED TO A BOW & PIN ASSEMBLED AS A COMPLETE SHACKLE AND IS TO RESULT IN NO APPRECIABLE DISTORTION OF EITHER PART. THE PIN IS TO SCREW IN AND OUT OF THE BOW FREELY BEFORE PROOF LOADING. AFTER PROOF LOADING, IT MUST BE POSSIBLE TO SCREW THE PIN IN AND OUT BY HAND, USING A BAR NOT LONGER THAN 6". A PIN OF THE TYPE SHOWN IN A.G.S. 916 IS TO BE USED WHEN PROOF LOADING.

ROUTINE TESTING: - NOT LESS THAN 5% OF THE FORGINGS IN EACH BATCH ARE TO BE PROOF-LOADED. (A BATCH COMPRISES FORGING FROM THE SAME CAST & HEAT-TREATED TOGETHER)

ISSUED BY DRAWING OFFICE DIRECTORATE OF TECHNICAL DEVELOPMENT AIR MINISTRY	TITLE - <b>BOW (DEE SHAPE) FOR CHAIN SHACKLE</b>				REVISION FOR A.P.C.	DRAWN	188
					G.C. 23-7.41	J. Meade	3-12-34
	ISSUE NO.	1	2	3	4	CHECKED	APPROVED
	863	1455	765	125			

6.10.36  
39/372/36



TO BE MACHINED WHERE MARKED

HOLE MUST NOT BE MORE THAN 0.02" OFF THE CENTRE LINE OF THE SHACKLE.

MARK	NOMINAL SIZE OF SHACKLE	Z +005 +015	Y	X -0 +03	W -0 +02	V -0 +06	U -0 +03	T -0 +03	S -0 +03	R -0 +03	Q -0 +03	P -0 +01	PROOF LOAD	WICHAIN FOR WHICH SUITABLE
C	3/8 IN	3/8 IN	3/8 BBSF	.72	.06	1.80	.36	.72	.36	.36	.36	.12	2100	7/4
D	7/16	7/16	7/16 BBSF	.84	.07	2.10	.42	.84	.42	.42	.42	.14	2860	5/16
E	1/2	1/2	1/2 BBSF	.96	.08	2.40	.48	1.00	.48	.48	.48	.16	3730	3/8
F	5/8	5/8	5/8 BBSF	1.20	.10	3.00	.60	1.20	.60	.60	.60	.20	5830	7/16
G	3/4	3/4	3/4 BBSF	1.44	.12	3.60	.72	1.50	.72	.72	.72	.24	8400	1/2

SPECIFICATION - THE MATERIAL TO BE TO BS SPEC<sup>n</sup> S.6-C. (LATEST ISSUE)

SCREW THREADS - BRITISH STANDARD FIN. (BSF) TO BS SPEC NO 84-1940, MEDIUM FIT

FINISH :- TO BE CADMIUM PLATED TO SPEC. D.T.D. 304. (LATEST ISSUE)

THE PROOF LOAD IS TO BE APPLIED TO A BOW & PIN ASSEMBLED AS A COMPLETE SHACKLE AND IS TO RESULT IN NO APPRECIABLE DISTORTION OF EITHER PART. THE PIN IS TO SCREW IN AND OUT OF THE BOW FREELY BEFORE PROOF LOADING. AFTER PROOF LOADING, IT MUST BE POSSIBLE TO SCREW THE PIN IN AND OUT BY HAND, USING A BAR NOT LONGER THAN 6". A PIN OF THE TYPE SHOWN IN A.G.S. 916 IS TO BE USED WHEN PROOF LOADING.

ROUTINE TESTING :- NOT LESS THAN 5% OF THE FORGINGS IN EACH BATCH ARE TO BE PROOF-LOADED. (A BATCH COMPRISES FORGING FROM THE SAME CAST & HEAT-TREATED TOGETHER)

ISSUED BY DRAWING OFFICE DIRECTORATE OF TECHNICAL DEVELOPMENT AIR MINISTRY	TITLE - <u>BOW (DEE SHAPE) FOR CHAIN SHACKLE</u>					APPROVED FOR A.P.C.	DRAWN	TRACED
						G.C. 23-7.01	T.G. Griffiths	J. Neale
	ISSUE No.	X	2	3	4	5	CHECKED	APPROVED
ALTERATION	AGS 302	AGS 125	AGS 155	AS AGS/367	AS NO. 65/663		G. Anderson	1.1.41