

RR-S-550D
AMENDMENT 1
February 20 1986

FEDERAL SPECIFICATION

SOCKETS, WIRE ROPE

This amendment, which forms a part of RR-S-550D, dated February 7, 1980, is approved by the Assistant Administrator, Office of Federal Supply and Services, General Services Administration, for the use of all Federal Agencies.

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Paragraph 2.1

DELETE: (under "Military Standards")

MIL-STD-271 - Nondestructive Testing Requirements
for Metals.

DELETE: Military Publication:

Naval Sea Systems Command (NAVSEA)
0900-LP-003-8000 - Metals, Surface Inspection
Acceptance Standards.

(Copies of Military Specifications and Standards required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting officer.)

Paragraph 2.2

ADD: (under "AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM):")

A 275 - Magnetic Particle Examination of Steel
Forgings. (DoD adopted)
E 446 - Standard Reference Radiographs for Steel
Castings Up To 2 in. (51 mm) In Thickness.
(DoD adopted)

FSC 4030

DISTRIBUTION STATEMENT A Approved for public release; distribution unlimited

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Paragraph 3.2.1

DELETE: These sockets shall be steel, drop forged, without any welding.

ADD: 3.2.1.1 Wire rope sockets for wire rope sizes 1/4-inch through 1-1/2 inches diameter, shall be steel, forged, without welding.

ADD: 3.2.1.2 Wire rope sockets for wire rope sizes 1-5/8 inches and larger shall be steel, forged, without welding or shall be cast alloy steel. Cast alloy steel sockets shall meet class 2 requirements.

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Table I

DELETE: (under column "H", "line 6")
3-1/8

ADD: 3-1/4

DELETE: (under column "H", "line 7")
3-5/8

ADD: 3-3/4

DELETE: (under column "H", "line 8")
4

ADD: 4-1/8

DELETE: (under column "H", "line 9")
4-5/8

ADD: 4-3/4

DELETE: (under column "E", "line 8")
3/4

ADD: 13/16

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Table IV

DELETE: (under column "H", "line 1")
1-11/16

ADD: 1-9/16

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Table IV
footnote
DELETE:

1/ All dimensions, except B, D, G, and L, under 4 inches to have a tolerance plus and minus 1/8-inch. All dimensions, except B, D, G, and L, 4 inches and over, to have a tolerance plus and minus 1/4-inch. Dimensions B, D, G, and L are minimum. Dimension E, socket sizes 1-3/4 inches and larger, to have a tolerance of plus and minus 1/4-inch.

ADD:

1/ All dimensions except D, G, and L, under 4 inches to have a tolerance plus or minus 1/8-inch. All dimensions, except B, D, G and L, 4 inches and over, to have a tolerance plus or minus 1/4-inch. Dimension B, 4 inches and over, to have a tolerance plus or minus 1/8 inch. Dimensions D, G, and L are minimum. Dimension E, socket size 1-3/4 inches and larger, to have a tolerance of plus or minus 1/4-inch.

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Paragraph 3.6
DELETE:

Magnetic particle inspection. Type A and B, finish 1, class 2 sockets shall be completely magnetic particle inspected in accordance with MIL-STD-271. These sockets shall comply with class 3 of NAVSEA 0900-LP-003-8000. Indications in excess of class 3 shall be cause for rejection of that socket.

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Paragraph 3.6

- ADD:
- 3.6. Magnetic particle inspection. Type A and B, finish 1, class 2 sockets shall be completely magnetic particle inspected in accordance with ASTM A 275 and E 446 respectively (see 3.2.1.1 and 3.2.1.2).
 - 3.6.1 Repairs. Sockets may be repaired by grinding providing the following requirements are met:
 - 3.6.1.1 Repaired areas shall be blended into the surrounding material.
 - 3.6.1.2 Changes of section shall be uniformly contoured.
 - 3.6.1.3 The maximum depth of grinding shall be in accordance with 3.6.2.3 and 3.6.2.4.
 - 3.6.2 Rejection criteria.
 - 3.6.2.1 Indications of discontinuities 1/16-inch and larger shall be investigated by grinding to determine their depth.
 - 3.6.2.2 Depth measurements shall be made from the surface of the forging using an appropriate mechanical measuring device.
 - 3.6.2.3 Sockets shall be considered rejectable if the depth of any individual discontinuity extends below the minimum allowable dimension as determined from table I or table IV.
 - 3.6.2.4 Sockets shall be considered rejectable if the cumulative depth of two or more discontinuities located 180 degrees apart from each other reduce the socket dimension below the minimum allowable dimension as determined from table I or table IV.

MILITARY INTERESTS:

Custodians

Army - AR
Navy - SH

Review activities

Navy - YD
DLA - IS

User activities

Navy - MC, CG

CIVIL AGENCY COORDINATING ACTIVITY:

GSA - FSS

Preparing activity:

Navy - SH
(Project 4030-0197)