

MIL-C-2683A

20 JANUARY 1955

SUPERSEDING

MIL-C-2683

23 AUGUST 1951

MILITARY SPECIFICATION**CHAIN ASSEMBLY, SINGLE LEG, BOAT ANCHOR**

This specification was approved by the Department of Defense for use by the Departments of the Army, the Navy and the Air Force.

1. SCOPE

1.1 Scope. — This specification covers a single leg, boat anchor chain assembly used for securing the boat anchor line to the anchor.

1.2 Classification. — The chain assembly shall be of the following sizes as specified (see 6.1):

Size $\frac{3}{8}$ inch

Size $\frac{1}{2}$ inch

2. APPLICABLE DOCUMENTS

2.1 The following specifications and standards, of the issue in effect on date of invitation for bids, form a part of this specification:

SPECIFICATIONS**FEDERAL**

NN-K-231 —Kegs; Wood Slack.

NN-B-621 —Boxes, Wood, Nailed and Lock-Corner.

RR-C-271 —Chains and Attachments, Welded, Weldless, and Roller Chain.

PPP-B-41 —Barrels, Wood, Slack.

PPP-B-601 —Boxes, Wood, Cleated, Plywood.

MILITARY

JAN-P-106 —Packaging and Packing for Overseas Shipment — Boxes, Wood, Nailed.

NAVY DEPARTMENT

46Z3 —Zinc Coating (Hot-Dip Galvanizing).

STANDARDS**MILITARY**

MIL-STD-129 —Marking for Shipment and Storage.

(Copies of specifications, standards, drawings, and publications required by contractors in connection with specific procurement functions should be obtained from the procuring agency or as directed by the contracting officer.)

2.2 Other publications. — The following document forms a part of this specification. Unless otherwise indicated the issue in effect on date of invitation for bids shall apply.

CONSOLIDATED CLASSIFICATION COMMITTEE

Consolidated Freight Classification Rules.

(Application for copies should be addressed to the Consolidated Classification Committee, 202 Chicago Union Station, Chicago 6, Ill.)

3. REQUIREMENTS

3.1 Material.—Chains shall be fabricated from steel made by the open hearth or electric furnace process and shall be of a quality capable of producing finished assemblies that will meet the requirements of this specification.

3.2 Construction.—Chains shall consist of a center section of chain made from common

MIL-C-2683A

open links, 2 enlarged open links, 1 pear-shaped link, and a bending shackle assembled as shown on figures 1 and 2.

3.3 Length.—Chains shall be 10 feet in length.

3.4 Common links.—The center section of the chain shall conform to type I, grade C, class 3 of Specification RR-C-271.

3.5 Enlarged links.—The enlarged links shall be of the shape and proportions shown on figures 1 and 2.

3.6 Pear-shaped links.—The pear-shaped links shall be made of steel of the shape, size and proportions shown on figures 1 and 2.

3.7 Bending shackle.—The bending shackle shall conform to type IV, class 3 of Specification RR-C-271 and shall be $\frac{1}{2}$ inch size for the $\frac{3}{8}$ inch chain and the $\frac{3}{4}$ inch size for the $\frac{1}{2}$ inch chain. The shackle pin shall have a round head and shall be secured to the shackle with a counter sunk riveted forelock pin. Counter sunk pins shall be supplied loose.

3.8 Zinc coating.—Chains shall be zinc coated by the hot dip process in accordance with Specification 46Z3. The zinc coating shall be adherent, smooth, free from uncoated spots, injurious lumps, blisters, dross, or flux.

3.9 Proof loads.—Chains, including shackles, shall be capable of withstanding the proof loads shown in table I, when tested as specified in 4.2.1, without developing surface rupture or defects which would interfere with the serviceability or prevent disassembly of the shackle pin.

TABLE I.—Proof load.

| Size | Proof load |
|---------------|------------|
| Inch | Pounds |
| $\frac{3}{8}$ | 4650 |
| $\frac{1}{2}$ | 8250 |

3.10 Workmanship.—The workmanship shall be first class in every respect.

4. QUALITY ASSURANCE PROVISIONS**4.1 Inspection.**

4.1.1 Each chain shall be cleaned and then surface inspected by the Government inspector after proofing and before zinc coating. Assemblies showing cracks, seams, defective welds, dimensions beyond the specified tolerances, or other defects that would affect the performance, shall be rejected. Rejected assemblies may be resubmitted after the manufacturer has satisfied the Government inspector that the defects have been corrected.

4.1.2 After the assembly has been zinc coated it shall be reinspected by the Government inspector to determine compliance with 3.8. Assemblies rejected because of unsatisfactory zinc coating may be resubmitted for Government inspection after the assembly has been stripped of zinc and recoated.

4.2 Tests.

4.2.1 Proof test.—Each chain shall be proofed before galvanizing in the presence of the Government inspector, using a means of loading employing round pin grips not larger than the sizes given in table II.

TABLE II.—Proof test.

| Nominal size of assembly | Size of pin for use with pear link (maximum) | Size of pin for use with shackle (maximum) |
|--------------------------|--|--|
| Inch | Inch | Inch |
| $\frac{3}{8}$ | $\frac{3}{4}$ | $\frac{3}{4}$ |
| $\frac{1}{2}$ | 1 | 1 |

5. PREPARATION FOR DELIVERY**5.1 Packing.**

5.1.1 For domestic shipment—immediate use.—The chain assemblies shall be packed

to insure carrier acceptance and safe delivery to destination at the lowest applicable rate. Containers shall comply with the Consolidated Freight Classification Rules or other carrier regulations applicable to the mode of transportation.

5.1.2 For domestic shipment and storage.—Chain assemblies shall be packed in cleated plywood or nailed wood boxes conforming to Specifications PPP-B-601 (domestic type) and NN-B-621, respectively, or in wood slack kegs or barrels conforming to Specifications NN-K-231 and PPP-B-41, respectively. Items of one stock number only shall be bulk packed in a container. The gross weight of plywood or wood boxes shall not exceed 200 pounds; slack kegs, 250 pounds; and slack barrels, 300 pounds.

5.1.3 For overseas shipment.—Chain assemblies shall be packed as specified in 5.1.2 except that the cleated plywood and nailed wood boxes shall conform to Specifications PPP-B-601 (overseas type) and JAN-P-106, respectively.

5.2 Marking.—In addition to any special marking required in the contract or order, marking for shipment shall be in accordance with Standard MIL-STD-129.

6. NOTES

6.1 Ordering data.—Procurement documents should specify the following:

- (a) Title, number, and date of this specification.
- (b) Size required (see 4.1.2).
- (c) Whether the chain assemblies shall be packed for domestic shipment—immediate use; domestic shipment and storage; or overseas shipment (see 5.1).

6.2 Superseding data.—The superseded Navy specification number is 6C3d.

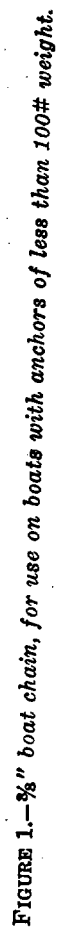
Patent notice.—When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility nor any obligation whatsoever; and the fact that the Government may have formulated, furnished, or in any way supplied the said drawings, specifications, or other data is not to be regarded by implication or otherwise as in any manner licensing the holder or any other person or corporation or conveying any rights or permission to manufacture, use, or sell any patented invention that may in any way be related thereto.

Custodians:

Navy—Bureau of Ships
Air Force

Other interest:

Navy—Y



MIL-C-2683A

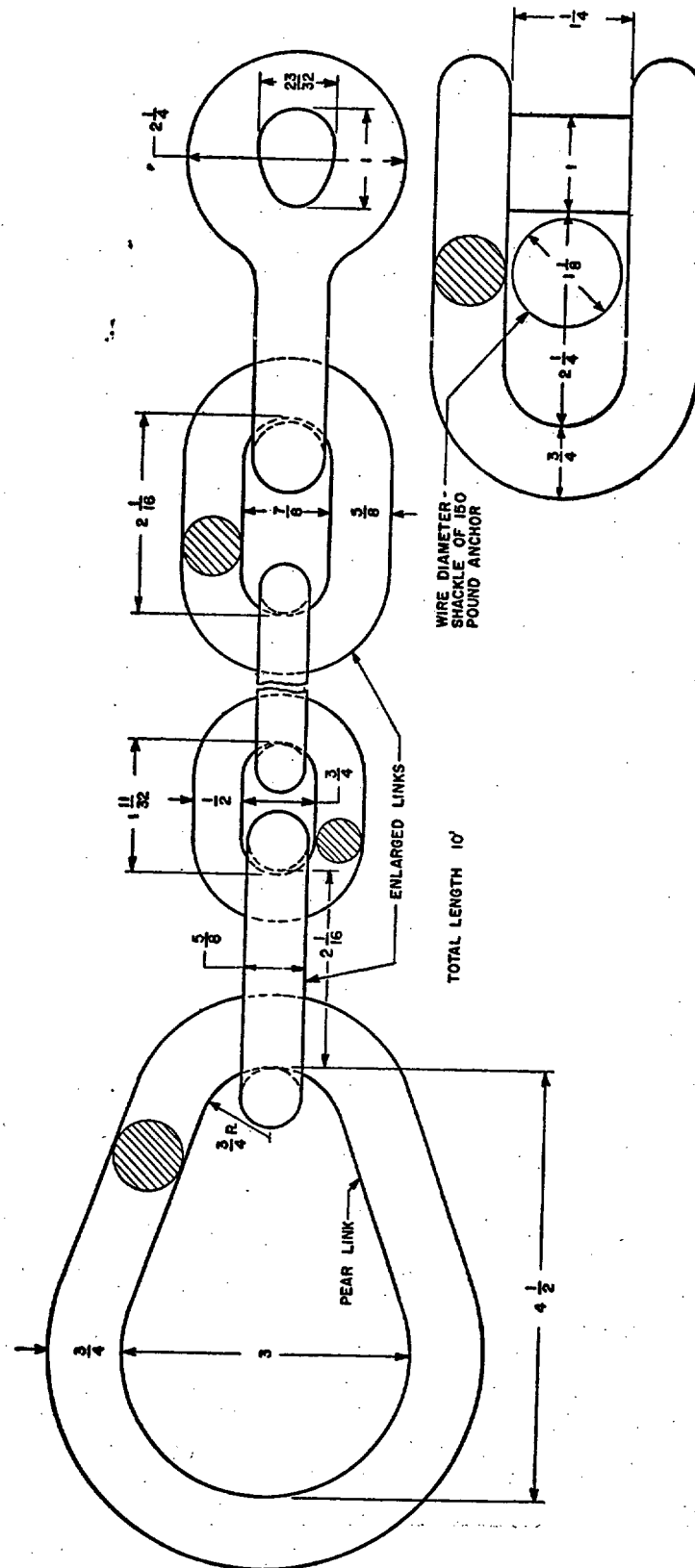


FIGURE 2.— $\frac{1}{2}$ " boat chain, for use on boats with anchors from 100# to 150# weight.