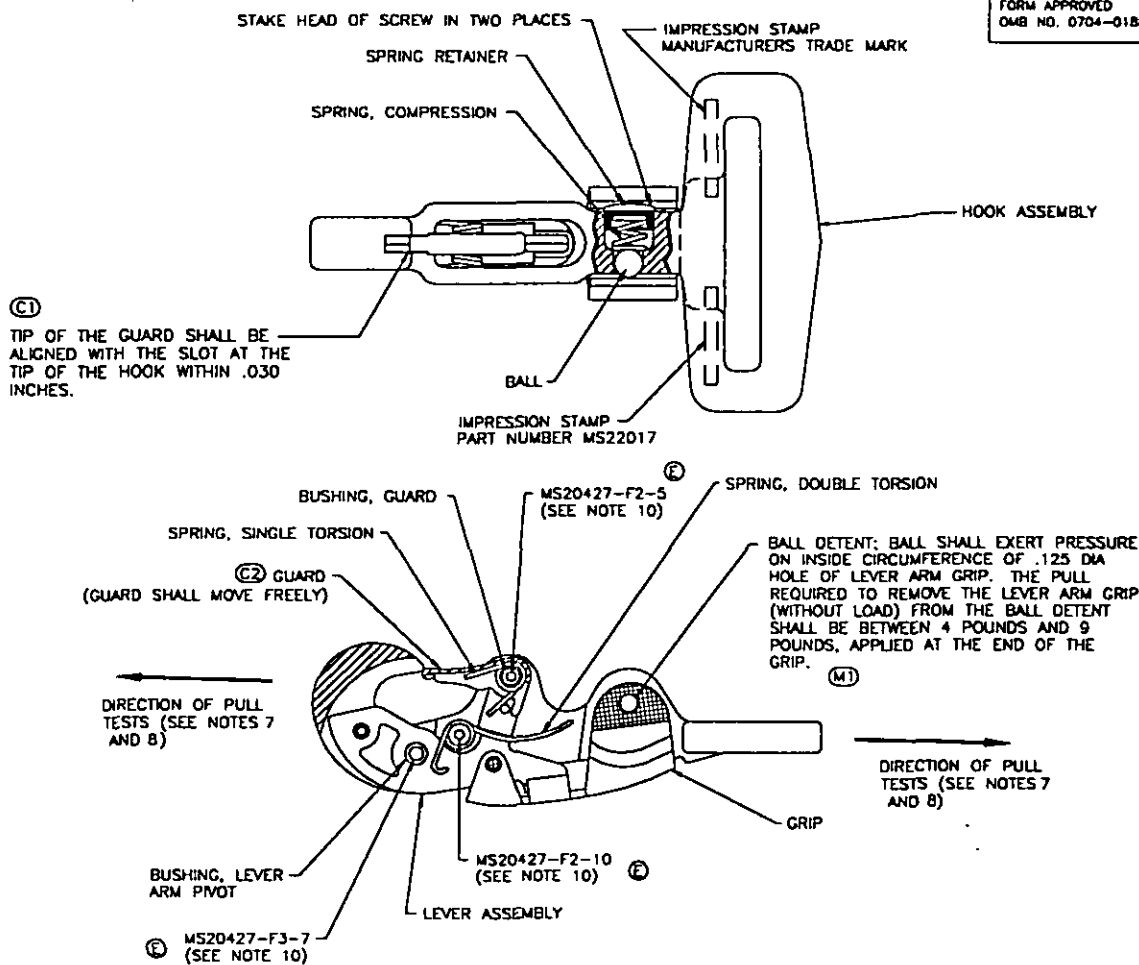
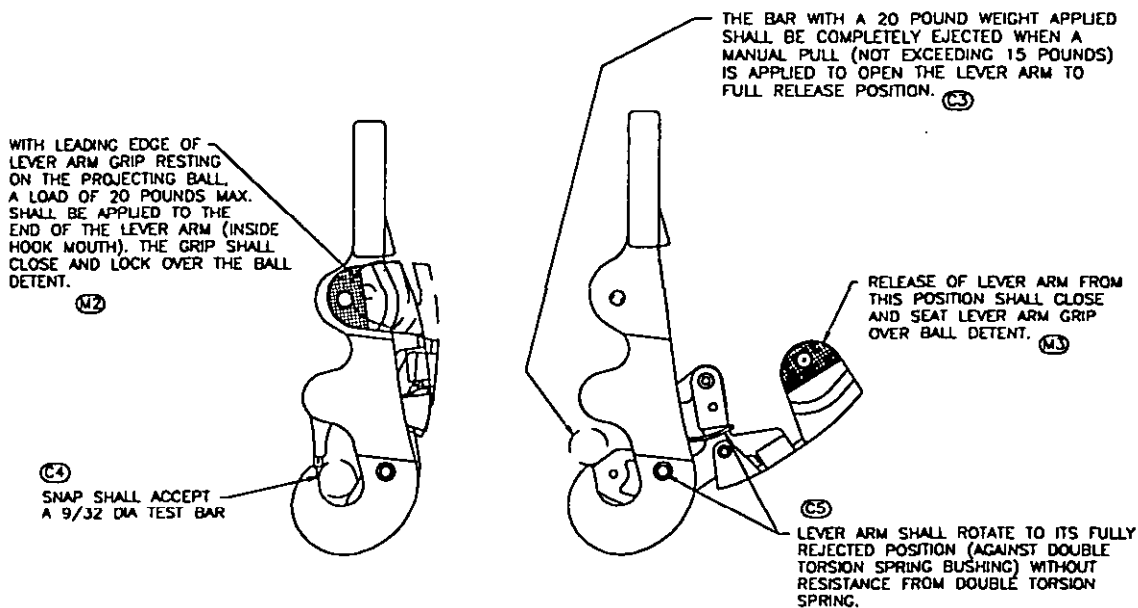


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EJECTOR SNAP ASSEMBLY



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CUSTODIANS: ARMY-CL NAVY-AS
AIR FORCE-11
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USER:
PROJECT NUMBER: 1670-0817

MILITARY SPECIFICATION SHEET
TITLE: SNAP, PARACHUTE HARNESS
QUICK-FIT EJECTOR

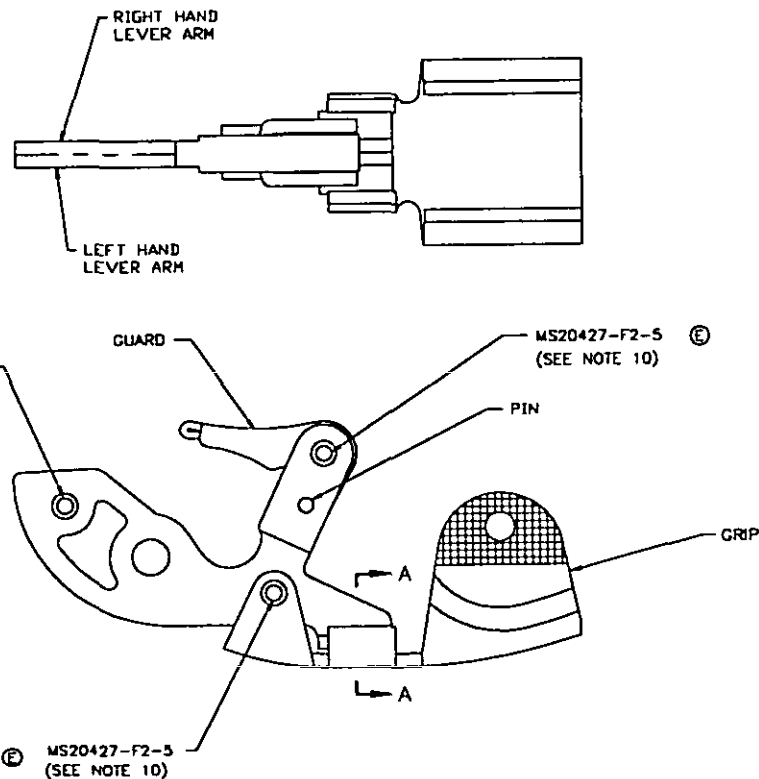
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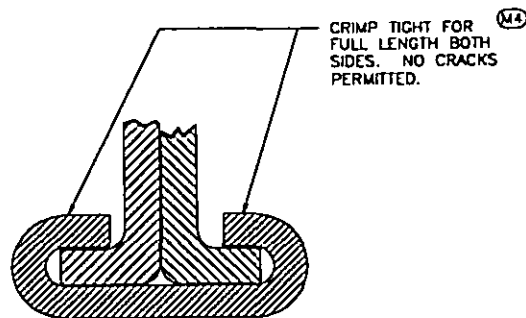
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LEVER ASSEMBLY



SECTION A-A

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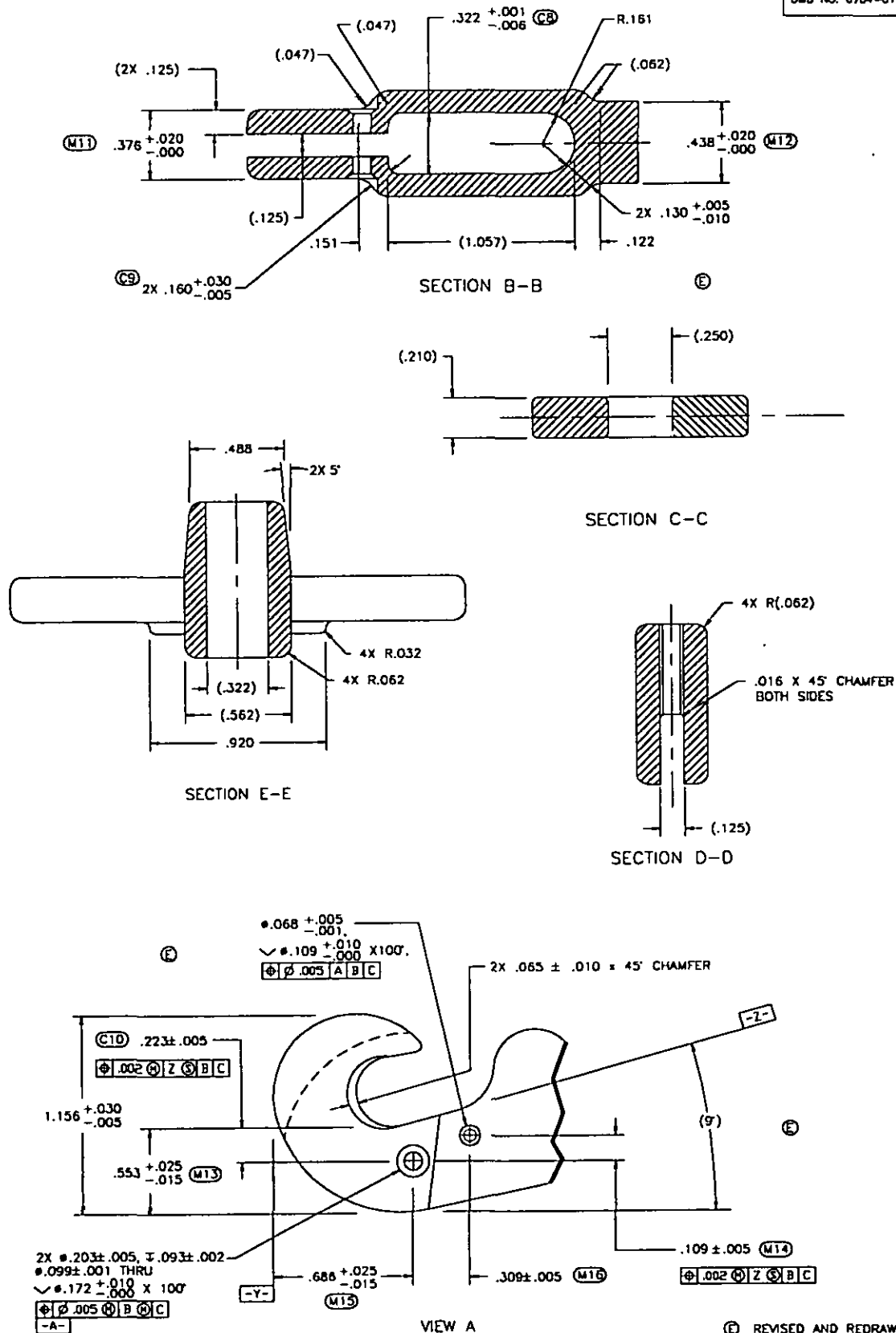


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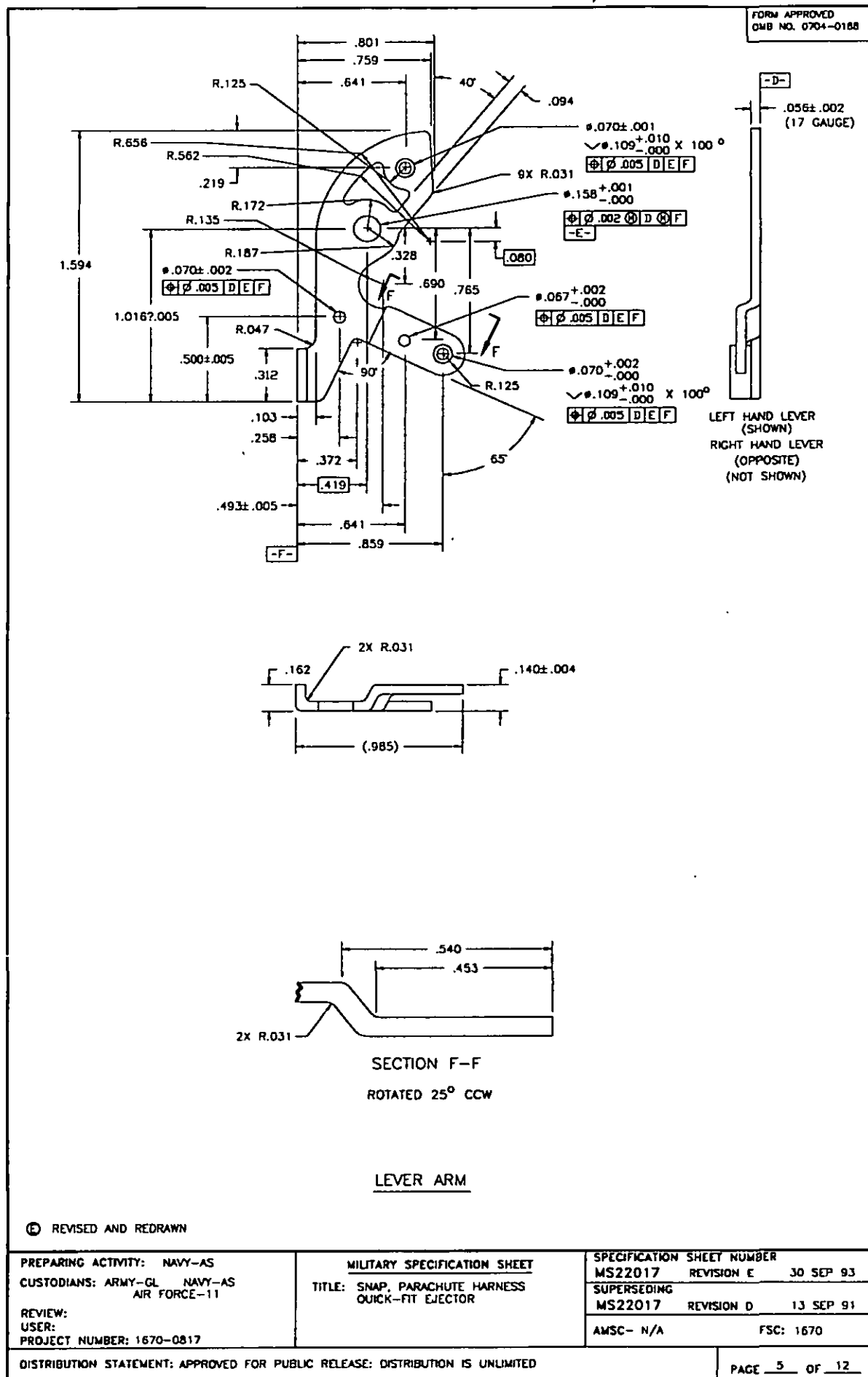
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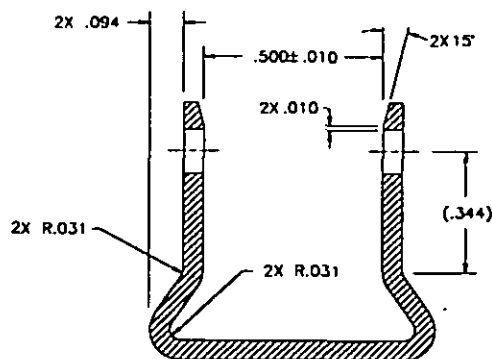
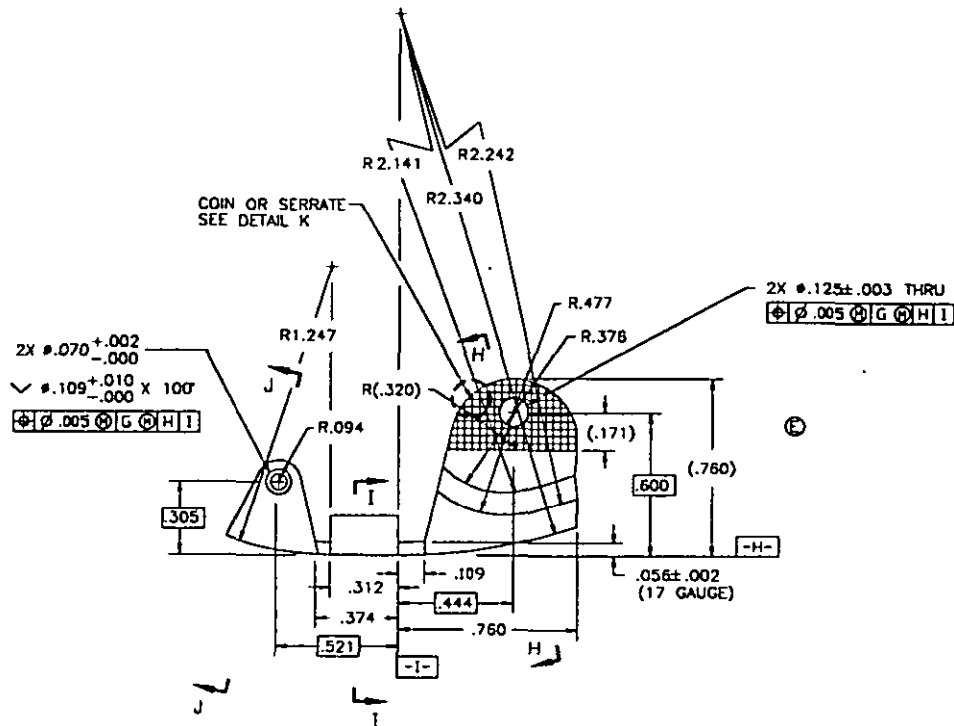
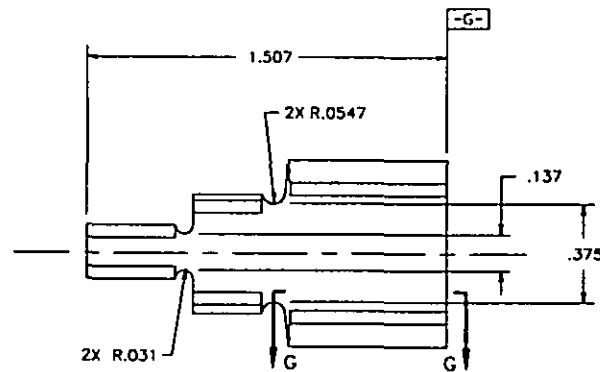
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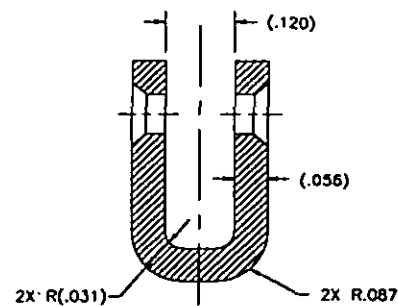


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SECTION H-H



SECTION J-J

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GRIP

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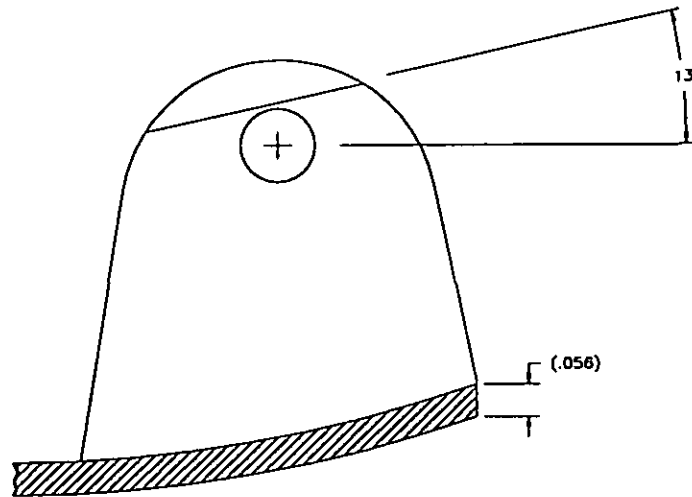
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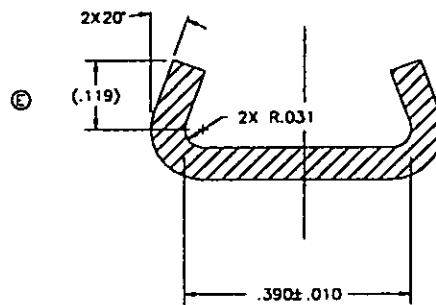
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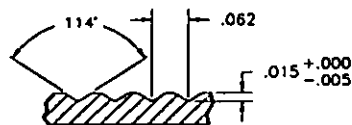
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SECTION G-G



SECTION I-I



DETAIL K

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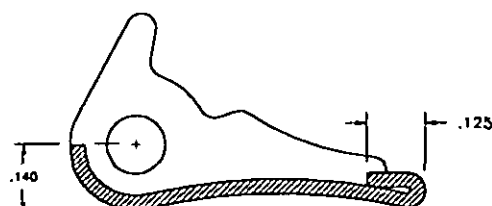
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SECTION L-L

GUARD

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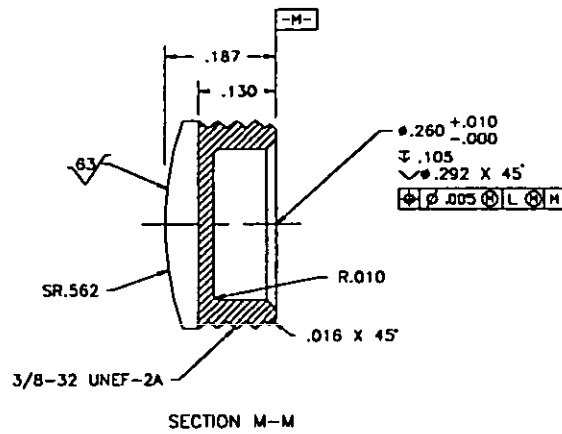
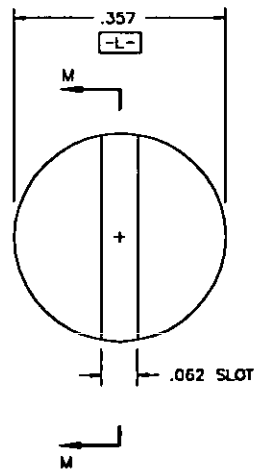
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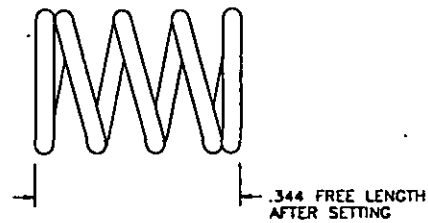
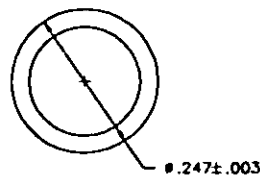
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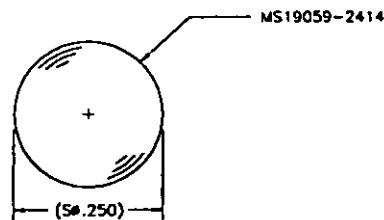
RETAINER, SPRING



SPRING DATA	
WIRE DIA	.0320 ± .005
DIRECTION OF HELIX	RIGHT OR LEFT HAND
TOTAL COILS	5.139
SOLID HEIGHT	.196
DEFLECTION RATE	42 LB/IN
TYPE OF ENDS	CLOSED ENDS NOT GROUND
5.0 ± 0.5 LB LOAD AT .225 MEAN ASSEMBLED LENGTH.	

SPRING, COMPRESSION

Ⓔ



BALL

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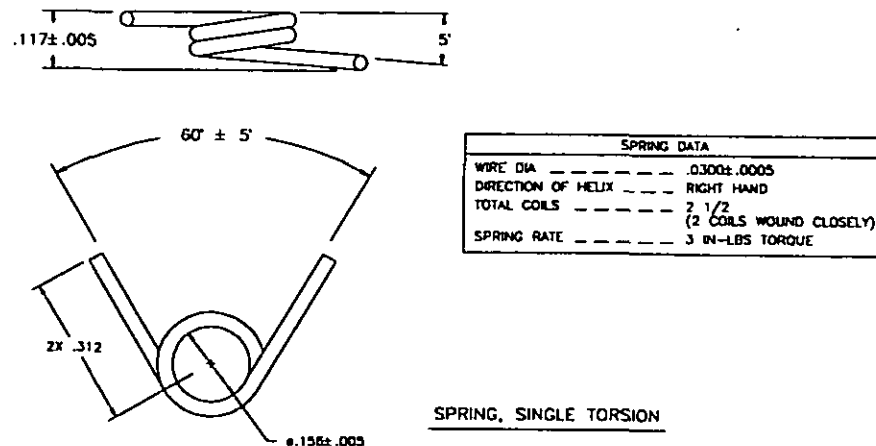
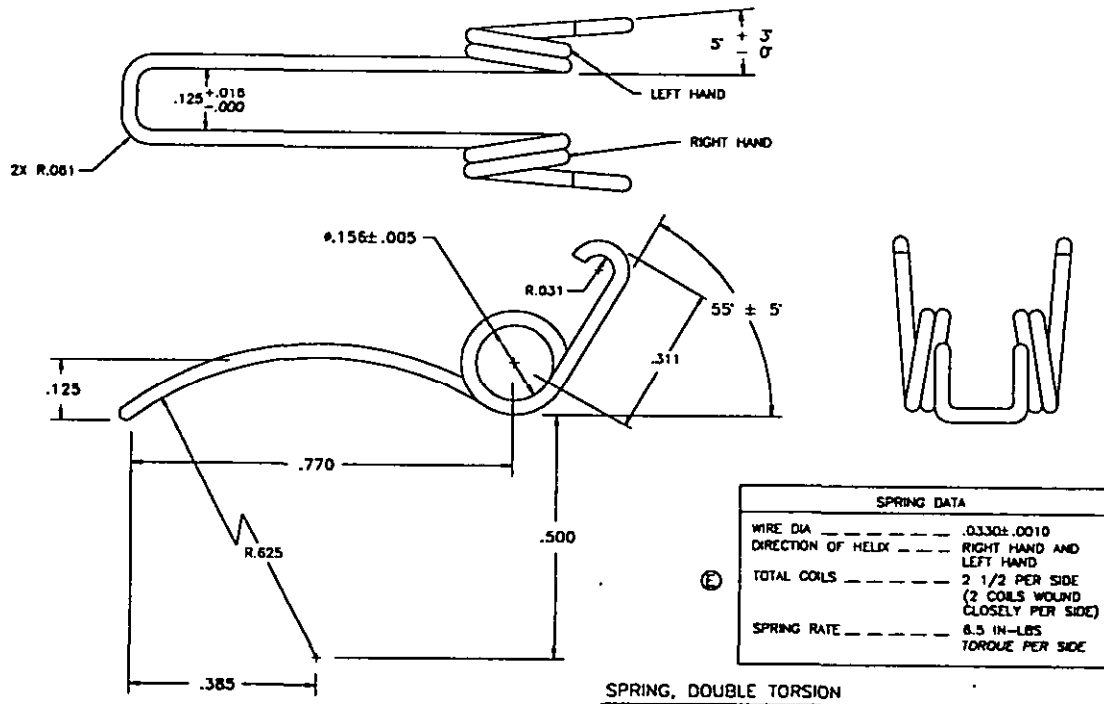
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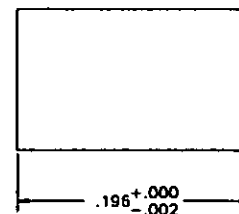
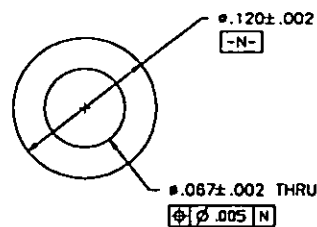
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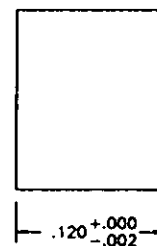
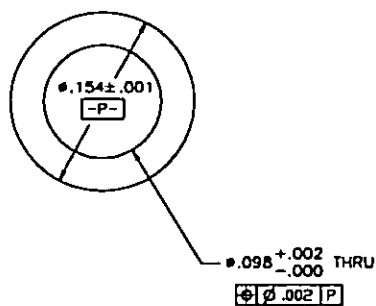
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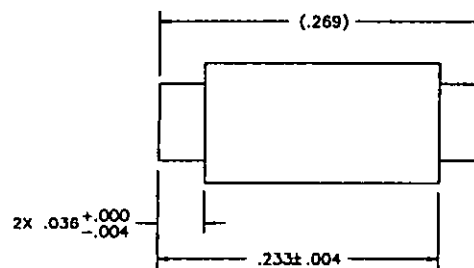
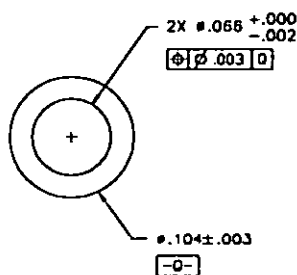
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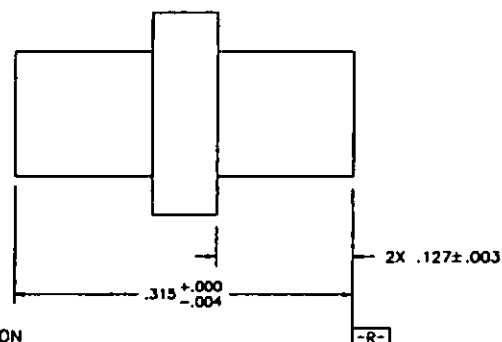
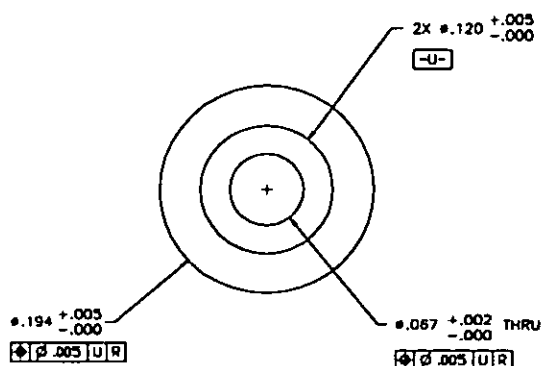
BUSHING, GUARD



BUSHING, LEVER ARM



PIN



BUSHING, DOUBLE TORISON

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NOTES:

1. MATERIALS:

- (A) GUARD BUSHING, LEVER ARM BUSHING, DOUBLE TORSION BUSHING, SPRING RETAINER AND PIN; TYPE 303, TYPE 1, IN ACCORDANCE WITH AMS 5640. (E)
- (B) LEVER ARM, GUARD AND GRIP; TYPE 302 OR 304 IN ACCORDANCE WITH AMS 5513.
- (C) COMPRESSION SPRING, DOUBLE TORSION SPRING AND SINGLE TORSION SPRING; TYPE 302 CLASS I OR 304 IN ACCORDANCE WITH ASTM A313-87.
- (D) HOOK BODY; HOT FORGED STEEL TYPE 4140 IN ACCORDANCE WITH MIL-S-5626 AND MIL-F-7190 GRADE A. FORGING GRAIN FLOW PATTERN SHALL BE PARALLEL WITH THE PREDOMINANT TENSILE STRESSES (AS INDICATED BY ARROWS). (E)

2. HEAT TREATMENT:

- (M18) (A) HOOK BODY; HEAT TREAT IN ACCORDANCE WITH MIL-H-6875, CLASS A, CONDITION H850, TENSILE STRENGTH RANGE OF 170 KSI TO 190 KSI (ROCKWELL C36 TO C41).
- (M19) (B) GUARD BUSHING, LEVER ARM BUSHING, DOUBLE TORSION BUSHING, SPRING RETAINER AND PIN; SHALL HAVE A MINIMUM HARDNESS OF ROCKWELL C23. (E)

3. FINISH:

- (M20) (A) GUARD BUSHING, LEVER ARM BUSHING, DOUBLE TORSION BUSHING, PIN, GRIP, SPRING RETAINER, LEVER ARM, GUARD, COMPRESSION SPRING, DOUBLE TORSION SPRING AND SINGLE TORSION SPRING; PASSIVATE IN ACCORDANCE WITH QQ-P-35, TABLE II, FOR MATERIAL BEING USED.
- (M21) (B) HOOK BODY; CADMIUM PLATING, CLASS I, TYPE I, IN ACCORDANCE WITH QQ-P-416. BAKE AT A MINIMUM OF 375 °F ± 25 °F FOR 3 HOURS MINIMUM, WITHIN FOUR HOURS AFTER PLATING, FOR EMBRITTLEMENT RELIEF.
- (M22) 4. ALL EDGES, INCLUDING EDGES OF HOLES, SHALL BE ROUNDED, TOP AND BOTTOM, WITH A MINIMUM RADIUS OF .005. PART SHALL BE SMOOTH AND FREE FROM FLASHING, PITS AND BURRS.
- (M23) 5. SURFACE ROUGHNESS SHALL BE $\sqrt{125}$ UNLESS OTHERWISE SPECIFIED. SURFACE CONDITION SHALL BE IN ACCORDANCE WITH ANSI B46.1.
6. ALL DIMENSIONS IN INCHES. UNLESS OTHERWISE SPECIFIED FOR THE CRITICAL, MAJOR AND MINOR, TOLERANCES SHALL BE +0.030 AND -0.016 (DECIMALS) AND ± 1° (ANGLES). INTERPRET DIMENSION AND TOLERANCES IN ACCORDANCE WITH ANSI Y14.5M-1982.
- (C12) 7. EVERY HOOK BODY SHALL BE PROOF LOADED TO 2500 POUNDS (AS INDICATED), HELD FOR A MINIMUM OF 1 SECOND, AFTER HEAT TREAT AND MACHINING. FOLLOWING PROOF LOADING, INSPECT BY MAGNETIC PARTICLE INSPECTION. IN ACCORDANCE WITH MIL-H-7195. (E)
- (C14) 8. ASSEMBLED SNAP ASSEMBLY SHALL BE PROOF LOADED TO 2500 POUNDS, HELD FOR A MINIMUM OF 1 SECOND, WITHOUT ANY BREAKAGE. IF ANY BREAKAGE, LOT SHALL BE REJECTED. (E)
- (C13) 9. ONE ASSEMBLY OF EACH INSPECTION LOT LESS THAN 500 OR ONE IN EVERY 500, SHALL BE LOADED TO 3750 POUNDS AND HELD FOR 15 SECONDS WITHOUT ANY BREAKAGE (AS INDICATED) ASSEMBLY SUBJECTED TO THIS SHALL NOT BE PLACED IN SERVICE. IF BREAKAGE, LOT SHALL BE REJECTED. (E)
- (C11) 10. RIVETS SHALL BE DRIVEN COLD SATISFACTORILY WITH HEAD FREE FROM CRACKS AND OTHER DEFORMITIES. RIVETS SHALL BE TRUE TO FORM AND POSITION. UP-SET END OF RIVETS SHALL COMPLETELY FILL COUNTERSINK, BUT, RIVET HEADS SHALL NOT PROJECT BEYOND SURFACES OF THE EJECTOR SNAP ASSEMBLY, AFTER ASSEMBLY. (E)
- (C15) 11. GUARD BUSHING, LEVER ARM BUSHING, DOUBLE TORSION BUSHING, PIN, SPRING RETAINER, GUARD, DOUBLE TORSION SPRING AND SINGLE TORSION SPRING SHALL BE COATED WITH DRY FILM LUBRICATE IN ACCORDANCE WITH DOD-L-85645, TYPE I OR II, BEFORE ASSEMBLY. (E)

CRITICAL CHARACTERISTICS:

- (C1) THRU (C11) AND (C14) : SAMPLE SIZE IN ACCORDANCE WITH MIL-STD-105, GENERAL INSPECTION LEVEL II, SINGLE NORMAL SAMPLING, ACCEPT NO DEFECTS. (E)
- (C12), (C13) AND (C15) : INSPECT 100%, ACCEPT NO DEFECTS.

MAJOR CHARACTERISTICS:

- (M1) THRU (M24) : SAMPLE SIZE IN ACCORDANCE WITH MIL-STD-105, GENERAL INSPECTION LEVEL II, SINGLE NORMAL SAMPLING, AQL 2.5. (E)

UNLESS OTHERWISE STATED ALL OTHER DIMENSIONS IN THIS DOCUMENT ARE FOR MANUFACTURING PURPOSES. THE PROCURING ACTIVITY RESERVES THE RIGHT TO INSPECT/VERIFY THESE DIMENSIONS AT ANYTIME.

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