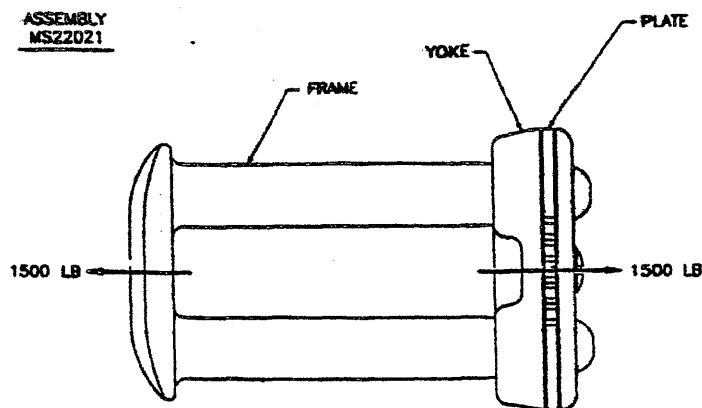


THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODDS SPECIFIED IN THE SOLICITATION: MIL-H-7195

ASSEMBLY
MS22021



NOTES:

1. MATERIALS:
 - (A) FRAME AND YOKE: HOT FORGED STEEL (4140) IN ACCORDANCE WITH MIL-S-8828 OR MIL-S-8849.
 - (B) SCREW: STEEL 800 IN ACCORDANCE WITH MIL-S-8828 OR MIL-S-8849.
 - (C) PLATE: STEEL (4130) IN ACCORDANCE WITH MIL-S-18729 OR AMS 6350.
2. HEAT TREATMENT: FRAME, YOKE, SCREW AND PLATE: HEAT TREAT IN ACCORDANCE WITH MIL-H-8873, CLASS A, CONDITION 1050, TENSILE STRENGTH RANGE OF 170 KSI TO 190 KSI (ROCKWELL C38 TO C41).
3. FINISH:
 - (A) FRAME, YOKE AND PLATE: CADMIUM PLATING, TYPE I, CLASS I, IN ACCORDANCE WITH QQ-P-416. BAKE AT A MINIMUM OF 375 °F ± 25 °F FOR 3 HOURS MINIMUM, WITHIN 4 HOURS AFTER PLATING, FOR BRITTLENESS RELIEF.
 - (B) SCREW: CADMIUM PLATING, TYPE I, CLASS 3, 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 BRITTLENESS RELIEF.
- (M1) 4. SURFACE ROUGHNESS SHALL BE 125 UNLESS OTHERWISE SPECIFIED. SURFACE CONDITIONS SHALL BE IN ACCORDANCE WITH AMS B44.1.
- (M2) 5. ALL EDGES, INCLUDING EDGES OF HOLES, SHALL BE ROUNDED, TOP AND BOTTOM, WITH A MINIMUM RADIUS OF .005. PARTS SHALL BE SMOOTH AND FREE FROM FLASHING, PITTS AND BURRS.
- (C1) 6. MAGNETIC PARTICLE INSPECTION IN ACCORDANCE WITH MIL-STD-1949, REQUIRED BEFORE PLATING, VISUAL INSPECTION AFTER PLATING. NO CRACKS PERMISSIBLE. "U" SHAPED AREA OF FRAME TO BE UNWELDED IN ACCORDANCE WITH MIL-STD-1949. FRAME SHALL BE FREE OF DISCREPANCIES FOR AREA OF EXPOSED CROSS BAR AND FIRST .250 INCHES OF EACH PIN UP FROM THE CROSS BAR (AS SHOWN).
- (M3) 7. ASSEMBLY SHALL BE IMPRESSION STAMPED WITH THE MS PART NUMBER AND MFRS NAME OR TRADEMARK.
- (C2) 8. SLIDE PLATE SHALL MOVE FREELY.
- (C3) 9. REMOVAL OF YOKE FROM FRAME SHALL BE ACCOMPLISHED WITHOUT ANY DIFFICULTIES.
- (C4) 10. WHEN SCREW IS MOVED TO SEATED POSITION, SCREW SHALL MOVE PLATE TO CLOSED POSITION. PLATE SHALL NOT MOVE MORE THAN .016 OF AN INCH.
- (C5) 11. SPEED LINK PROOF LOAD - THE COMPLETELY ASSEMBLED LINK SHALL BE SUBJECTED TO A 3000 POUND PROOF LOAD IN THE DIRECTION SHOWN. IF BREAKAGE, LOT SHALL BE REJECTED.
- (M4) 12. SPEED LINK STATIC TEST - THE COMPLETELY ASSEMBLED LINK SHALL BE SUBJECTED TO A 1500 POUND SIDE STATIC LOAD IN THE DIRECTION SHOWN. IF BREAKAGE, LOT SHALL BE REJECTED.
- (M5) 13. SPRING SHALL BE PERFORMED SO AS TO PROVIDE A POSITIVE STOP UNIT FOR RETRACTION OF SCREW.
- (C6) 14. ANY PROJECTION OF THE .3316 (NOM) DIA PLATE HOLES INTO THE PERIPHERY OF THE .319 (NOM) DIA FRAME HOLES OF THE YOKE IS CAUSE FOR REJECTION.
- (M6) 15. IN ACCORDANCE WITH FED-STD-428.
16. ALL DIMENSIONS IN INCHES. TOLERANCES: +0.030 AND -0.016 (DECIMALS) AND ± 1° (ANGLES). INTERPRET DIMENSION AND TOLERANCES IN ACCORDANCE WITH AMS Y14.5M-1982 AND MIL-H-7195.

CRITICAL CHARACTERISTICS:

- (C1) THRU (C11): INSPECT 100%, EACH LOT, ACCEPT NO DEFECTS OR FAILURES AS INDICATED.

MAJOR CHARACTERISTICS:

- (M1) THRU (M10): SAMPLE SIZE IN ACCORDANCE WITH MIL-STD-105, GENERAL INSPECTION LEVEL II, SINGLE NORMAL INSPECTION, AQL 1.5.

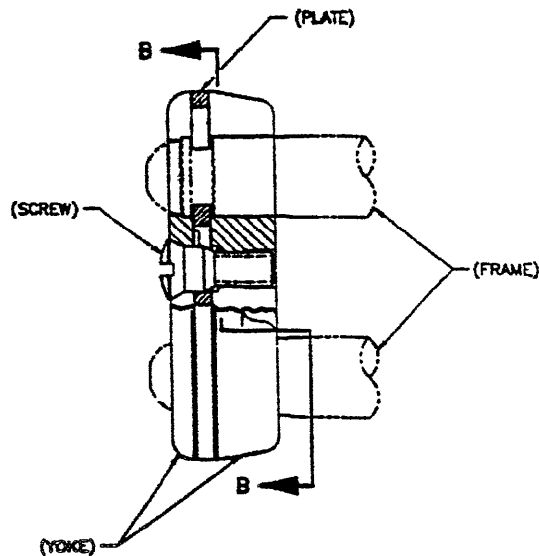
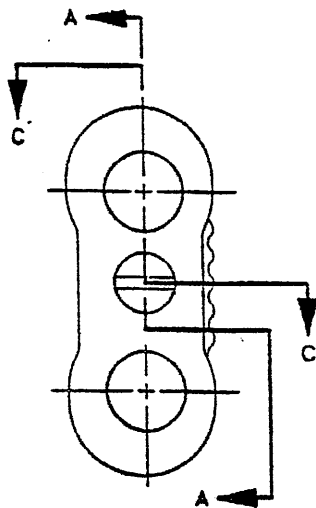
UNLESS OTHERWISE STATED ALL OTHER DIMENSIONS IN THIS DOCUMENT ARE FOR MANUFACTURING PURPOSES. THE PROCURING ACTIVITY RESERVES THE RIGHT TO INSPECT/VERIFY THESE DIMENSIONS AT ANYTIME.

(F) REVISED AND REDRAWN

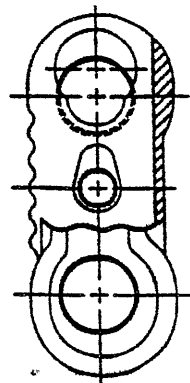
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CUSTODIANS: NAVY-AS AIR FORCE-11	TITLE: LINK, PARACHUTE REMOVABLE CONNECTOR, SPEED	MS22021 REV F 13 SEP 91
REVIEW:		SUPERSEDING
USER:		MS22021 REV E 26 OCT 84
PROJECT NUMBER: 1670-0790		ANSC- N/A FSC: 1670
DISTRIBUTION STATEMENT: A. APPROVED FOR PUBLIC RELEASE; DISTRIBUTION IS UNLIMITED.		PAGE 1 OF 4

THIS SPECIFICATION IS APPROVED FOR USE BY ALL DEPARTMENTS AND AGENCIES OF THE DEPARTMENT OF DEFENSE.

THE REQUIREMENTS FOR ACQUIRING THE PRODUCT(S) DESCRIBED HEREIN SHALL CONSIST OF THIS SPECIFICATION SHEET AND THE ISSUE OF THE FOLLOWING SPECIFICATION LISTED IN THAT ISSUE OF THE DODISS SPECIFIED IN THE SOLICITATION: MIL-H-7193

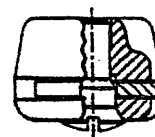


SECTION A-A

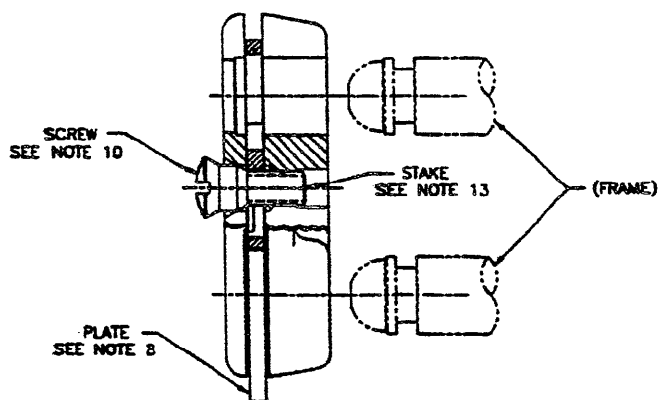


SECTION B-B

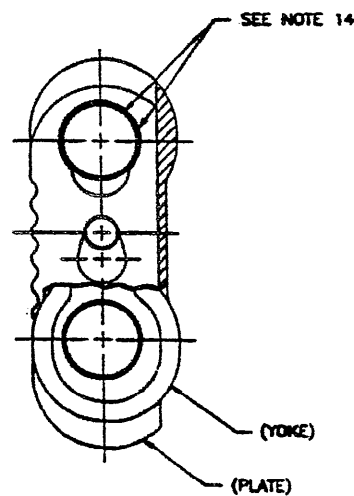
CLOSED POSITION



SECTION C-C



OPEN POSITION



(F) REVISED AND REDRAWN

PREPARING ACTIVITY: NAVY-AS
CUSTODIANS: AIR FORCE-89

REVIEW:
USER:
PROJECT NUMBER: 1670-0790

MILITARY SPECIFICATION SHEET
TITLE: LINK, PARACHUTE REMOVABLE
CONNECTOR, SPEED

SPECIFICATION SHEET NUMBER
MS22021 REV F 13 SEP 91

SUPERSEDING
MS22021 REV E 26 OCT 84

AMSC- N/A FSC: 1670

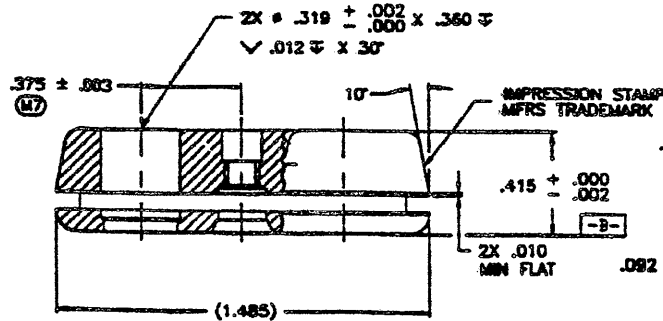
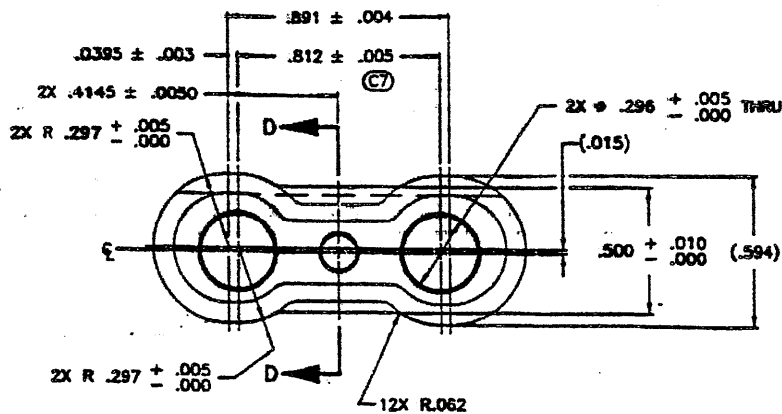
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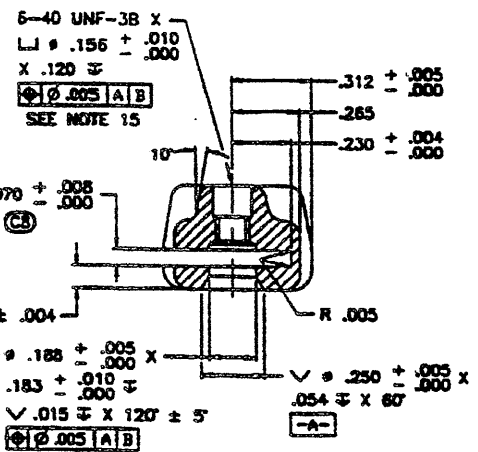
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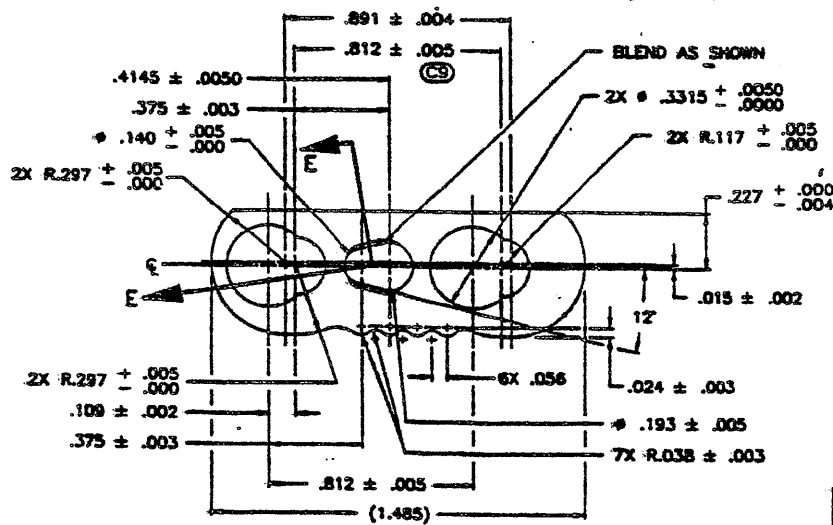
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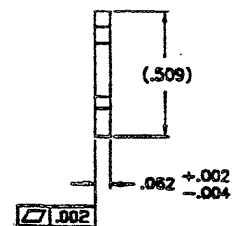
YOKE



SECTION D-D



PLATE

SECTION E-E
ENLARGED

Ⓡ REVISED AND REDRAWN

PREPARING ACTIVITY: NAVY-AS

CUSTODIANS: AIR FORCE-99

REVIEW:

USER:

PROJECT NUMBER: 1670-0790

MILITARY SPECIFICATION SHEET
TITLE: LINK, PARACHUTE REMOVABLE
CONNECTOR, SPEED

SPECIFICATION SHEET NUMBER
MS22021 REV F 13 SEP 91

SUPERSEDING
MS22021 REV E 26 OCT 84

AMSC- N/A FSC: 1670

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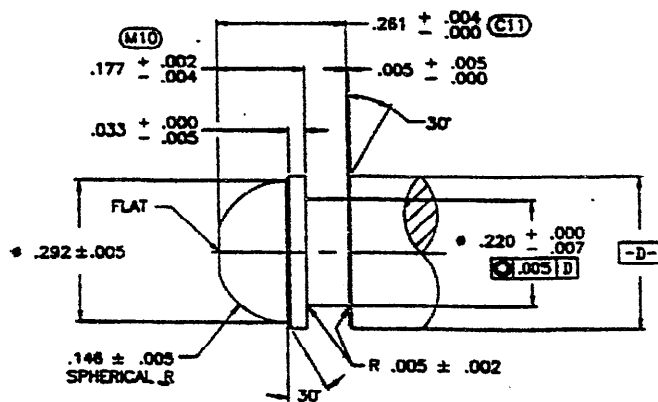
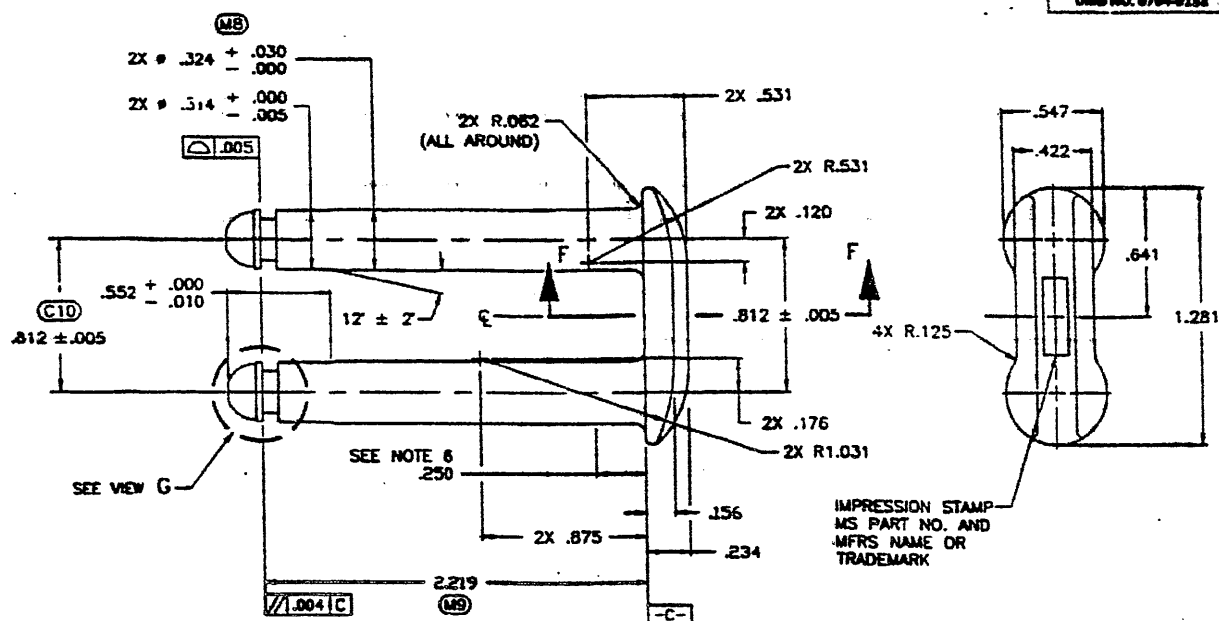
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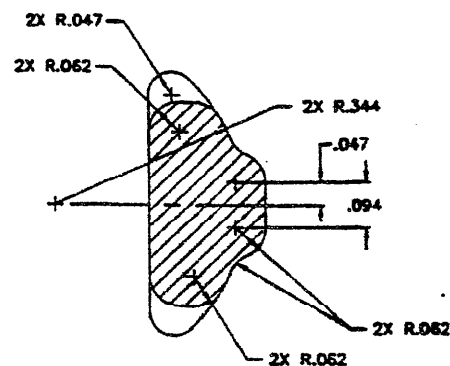
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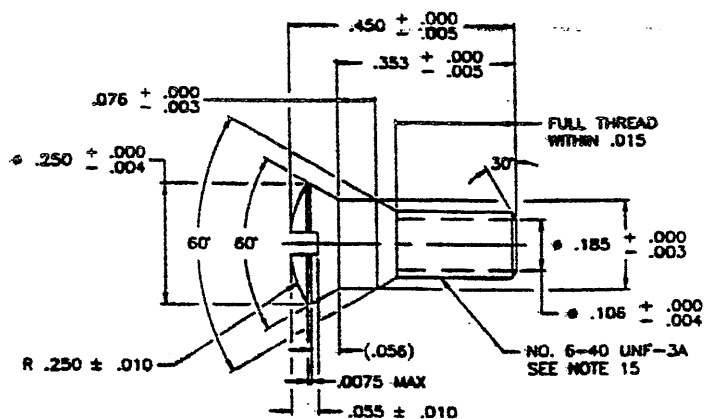


**VIEW G
ENLARGED**

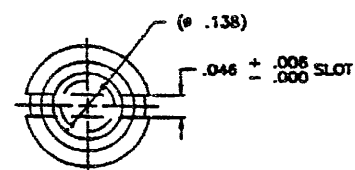
FRAME



SECTION F-F
ENLARGED



SCREW



Ⓕ REVISED AND REDRAWN

PREPARING ACTIVITY: NAVY-AS

CUSTODIANS: AIR FORCE-99

REVIEW:

PROJECT NUMBER: 1670-0790

MILITARY SPECIFICATION SHEET

**TITLE: LINK, PARACHUTE REMOVABLE
CONNECTOR, SPEED**

SPECIFICATION SHEET NUMBER

MS22021 REV F 13 SEP 91

SUPERSEDING

MS22021 REV E 26 OCT 84

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