

1593
31 REF
3A

MF

② CANCELLED AFTER 23 MARCH 1976
NO SUPERCEDING DOCUMENT

1E .015
EAT TR

0

1

0.015 R(TYP)

ON A-A
(IN POSITION)

SEC

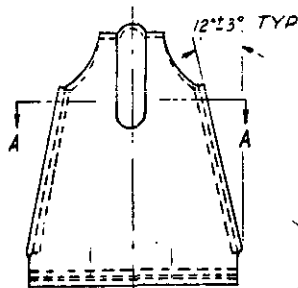
1/8" .015 CLEARANCE ON BOTH SIDES
HEAT TREATING AND FINISHING



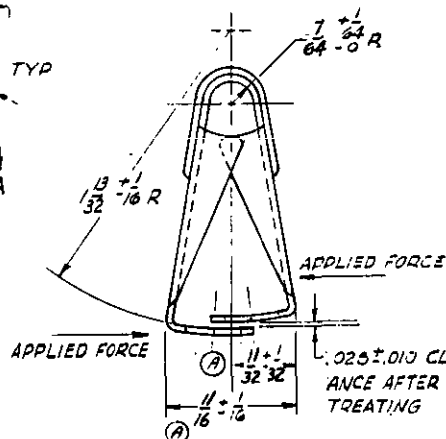
SECTION B-B

$\frac{1}{2}$.015 R (TYP)

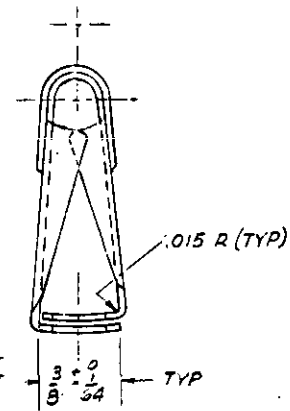
ON A-A
(IN POSITION)



FRONT VIEW



OPEN POSITION



CLOSED POSITION

(A) FOR CHANGES SEE SHEETS 1 AND 2

P.A. ARMY GL Other Cust	TITLE CLIP, SPRING TENSION, DRAWCORD	MILITARY STANDARD
		MS 70110 (GL)
PROCUREMENT SPECIFICATION NONE	SUPERSEDES: NLABS DWG NO. 4-1-204 AND (B) MIL-S-85905	SHEET 1 OF 2

FED. SUP CLASS

5340

NOTES

1. MATERIAL - STEEL, STEEL OR STRIP, CONDITION 1 OR 2 OF MIL-8-7947, THICKNESS 0.0239.
2. FINISH - ALL SURFACES AND EDGES SHALL BE GIVEN A SEALED PHOSPHATE COATING, DYED BLACK, CONFORMING TO TYPE Z, CLASS 4C OF MIL-P-16232.
3. DIMENSIONS - IN INCHES
4. TOLERANCES - DECIMALS $\pm .005$, FRACTIONS $\pm 1/64$, UNLESS OTHERWISE NOTED.
5. AFTER STAMPING AND PUNCHING BUT BEFORE BENDING, REMOVE ALL SHARP EDGES, BURRS AND SLIVERS.
6. MARKING - INDENT MANUFACTURER'S NAME OR IDENTIFICATION BEFORE HEAT TREATMENT. CHARACTERS SHALL BE $1/16$ TO $1/8$ INCH, AND DEPTH OF INDENT APPROXIMATELY $1/64$ INCH. MARKING TO BE IDENTIFIABLE AFTER FINISHING.
- (A) 7. CLIP, AFTER FORMING, SHALL BE HEAT TREATED TO RESULT IN SUFFICIENT SPRING SO AS TO REQUIRE A FORCE OF 9 TO 13 POUNDS TO DEPRESS CLIP AND ALIGN HOLES AND UPON RELEASE TO PERMIT CLIP TO RETURN TO ORIGINAL OPEN POSITION.
- (A) 8. TEST - 9 TO 13 POUNDS SHALL BE APPLIED AS SHOWN ON SHEET 1. THIS FORCE SHALL DEFLECT THE LEGS OF THE CLIP AND ALIGN HOLES. AFTER RELEASE, THE CLIP SHALL RETURN TO THE OPEN POSITION WITHOUT ANY DEFORMATION OR CRACKS. WHEN THIS TEST HAS BEEN COMPLETED 10 TIMES, THE CLIP SHALL BE INSPECTED FOR ANY CRACKING OR DEFORMATION.
9. FOR DESIGN FEATURE PURPOSES, THIS STANDARD TAKES PRECEDENCE OVER PROCUREMENT DOCUMENTS REFERENCED HEREIN.
10. REFERENCED DOCUMENTS SHALL BE OF THE ISSUE IN EFFECT ON DATE OF INVITATION FOR BIDS OR REQUEST FOR PROPOSAL.

APPROVED 3 JAN 68 REVISED (A) FOR CHANGES SEE SHEETS 1 AND 2 @ 23 MAR 76 (SEE LEAD SHEET 1)

P.A. ARMY OL Other Cust	TITLE CLIP, SPRING TENSION, DRAWCORD	MILITARY STANDARD MS 70110 (GL)
PROCUREMENT SPECIFICATION NONE	SUPERSEDES: N LABS DWG NO 4-1-204 AND (A) MIL-C-45905	SHEET 2