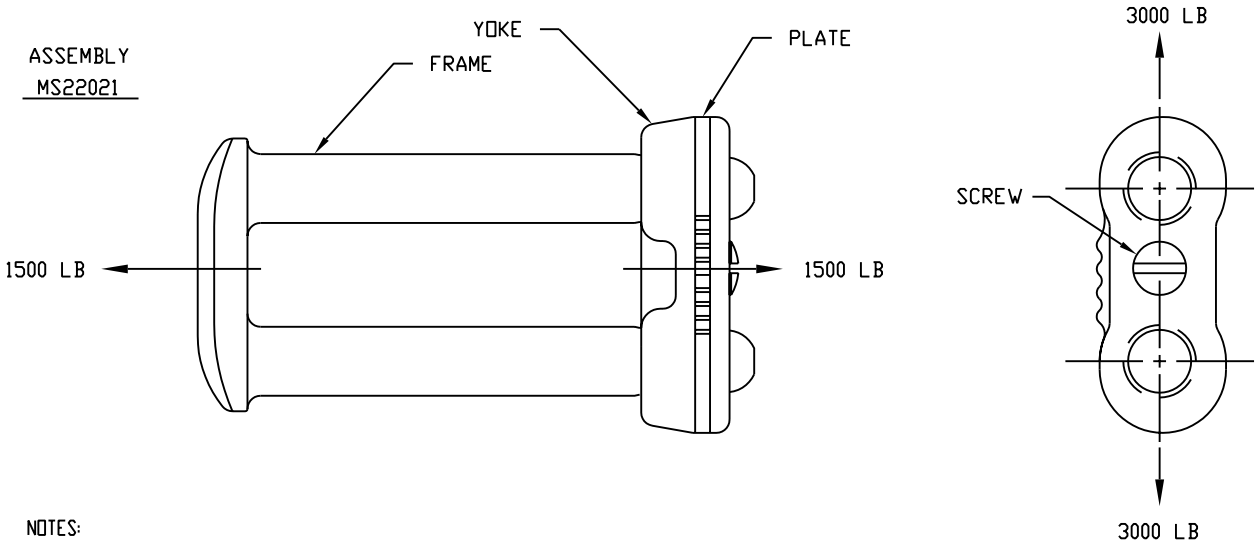

NOTES:

1. MATERIALS:
   (A) FRAME AND YOKE: HOT FORGED STEEL (4140) IN ACCORDANCE WITH MIL-S-5626 OR MIL-S-6049.
   (B) SCREW: STEEL ROD IN ACCORDANCE WITH MIL-S-5626 OR MIL-S-6049.
   (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-6875, CLASS A, CONDITION H850, TENSILE STRENGTH RANGE OF 170 TO 190 KSI (ROCKWELL C38 TO C41).
3. FINISH:
   (A) FRAME, YOKE AND PLATE: CADMIUM PLATING, TYPE I, CLASS 1, 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 EMBRITTLEMENT 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 EMBRITTLEMENT RELIEF.

(M1) 4. SURFACE ROUGHNESS SHALL BE $\sqrt{125}$ UNLESS OTHERWISE SPECIFIED. SURFACE CONDITIONS SHALL BE IN ACCORDANCE WITH ANSI B46.1.

(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, PITS 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 MAGNAFLUXED IN ACCORDANCE WITH MIL-STD-1949. FRAME SHALL BE FREE OF DISCONTINUITIES FOR AREA OF ENTIRE 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. STAKING SHALL BE PERFORMED SO AS TO PROVIDE A POSITIVE STOP LIMIT FOR RETRACTION OF SCREW.

(C6) 14. ANY PROJECTION OF THE .3315 (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-H28.

16. ALL DIMENSIONS IN INCHES. TOLERANCES: +0.030 AND -0.016 (DECIMALS) AND ± 1° (ANGLES). INTERPRET DIMENSION AND TOLERANCES IN ACCORDANCE WITH ANSI 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 SAMPLING, 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.

ADAPTED 1/7/98, REVISED Ⓐ 9/10/04.

Parachute Industry Association
3833 West Oakton St.
Skokie, IL 60076 USA
Tel (847) 674-9742
Fax (847) 674-9743
Web Address: pia.com

Title
LINK, PARACHUTE REMOVABLE CONNECTOR, SPEED

Parachute Standard
PS22021

Procurement Specification
MIL-H-7195

Adopted From:
MS22021 Ⓕ