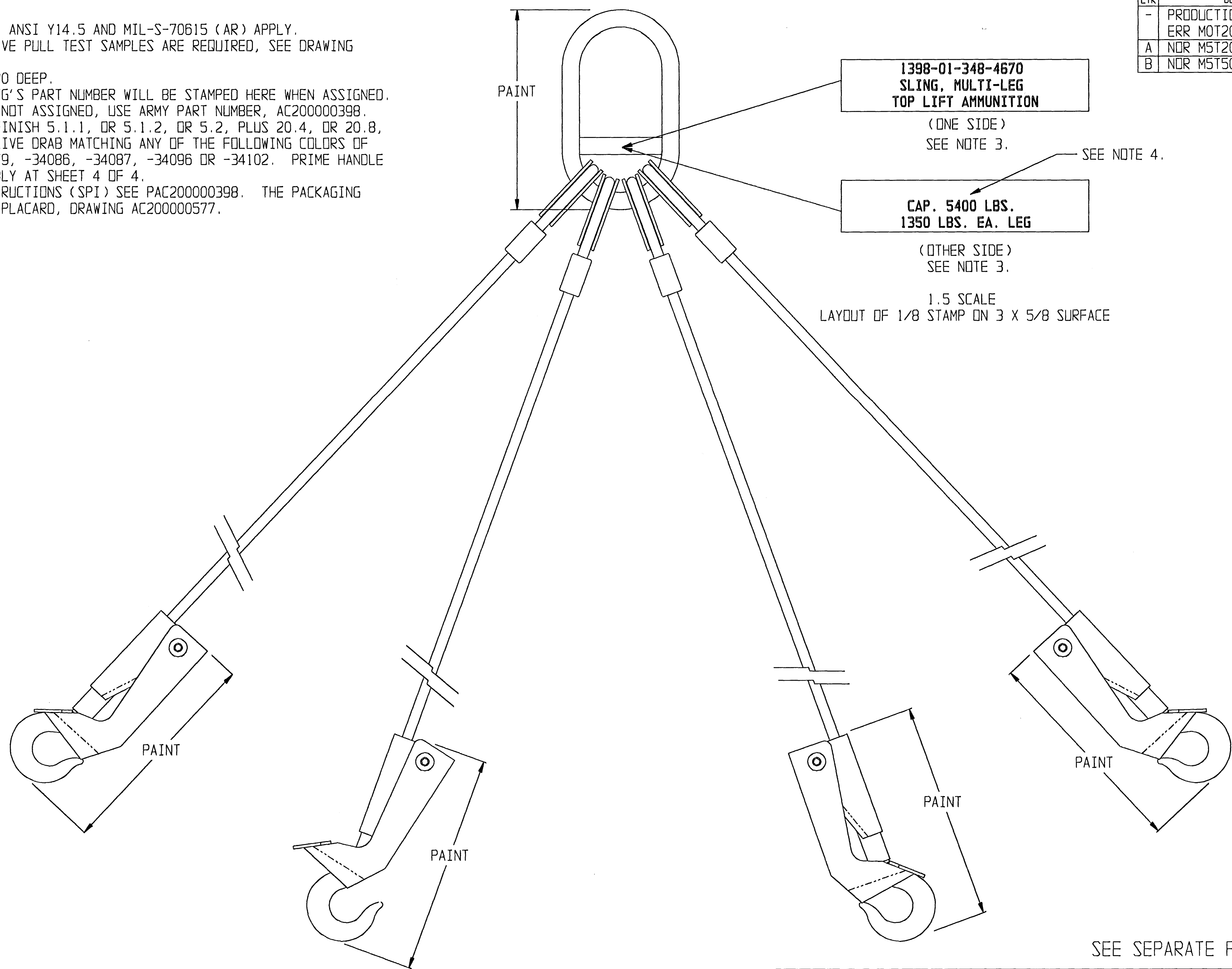


REVISION			
LTR	DESCRIPTION	DATE	APPROVED
-	PRODUCTION RELEASE ERR MOT2017 91-08-20	91-08-21	SPRAGUE
A	NDR MST2007 95-08-07	95-08-10	SPRAGUE
B	NDR MST5000 96-04-17	97-03-24	<i>SPRAGUE</i>

- NOTES:
- SPECIFICATIONS MIL-A-2550, ANSI Y14.5 AND MIL-S-70615 (AR) APPLY.
 - IF FIRST ARTICLE DESTRUCTIVE PULL TEST SAMPLES ARE REQUIRED, SEE DRAWING AC200000384.
 - STAMP 1/8 CHARACTERS X .020 DEEP.
 - THE MFG'S CAGE CODE AND MFG'S PART NUMBER WILL BE STAMPED HERE WHEN ASSIGNED. IF A MFG'S PART NUMBER IS NOT ASSIGNED, USE ARMY PART NUMBER, AC200000398.
 - FOR SURFACES INDICATED: FINISH 5.1.1, OR 5.1.2, OR 5.2, PLUS 20.4, OR 20.8, OR 20.9 OF MIL-STD-171; OLIVE DRAB MATCHING ANY OF THE FOLLOWING COLORS OF FED STD 595; -34052, -34079, -34086, -34087, -34096 OR -34102. PRIME HANDLE COMPONENTS PRIOR TO ASSEMBLY AT SHEET 4 OF 4.
 - FOR SPECIAL PACKAGING INSTRUCTIONS (SPI) SEE PAC200000398. THE PACKAGING SHALL INCLUDE INSTRUCTION PLACARD, DRAWING AC200000577.



PART NO AC200000398
SEE SEPARATE PARTS LIST PL AC200000398

B	-	-	B
SHEET 1	SHEET 2	SHEET 3	SHEET 4
REVISION STATUS OF SHEETS			

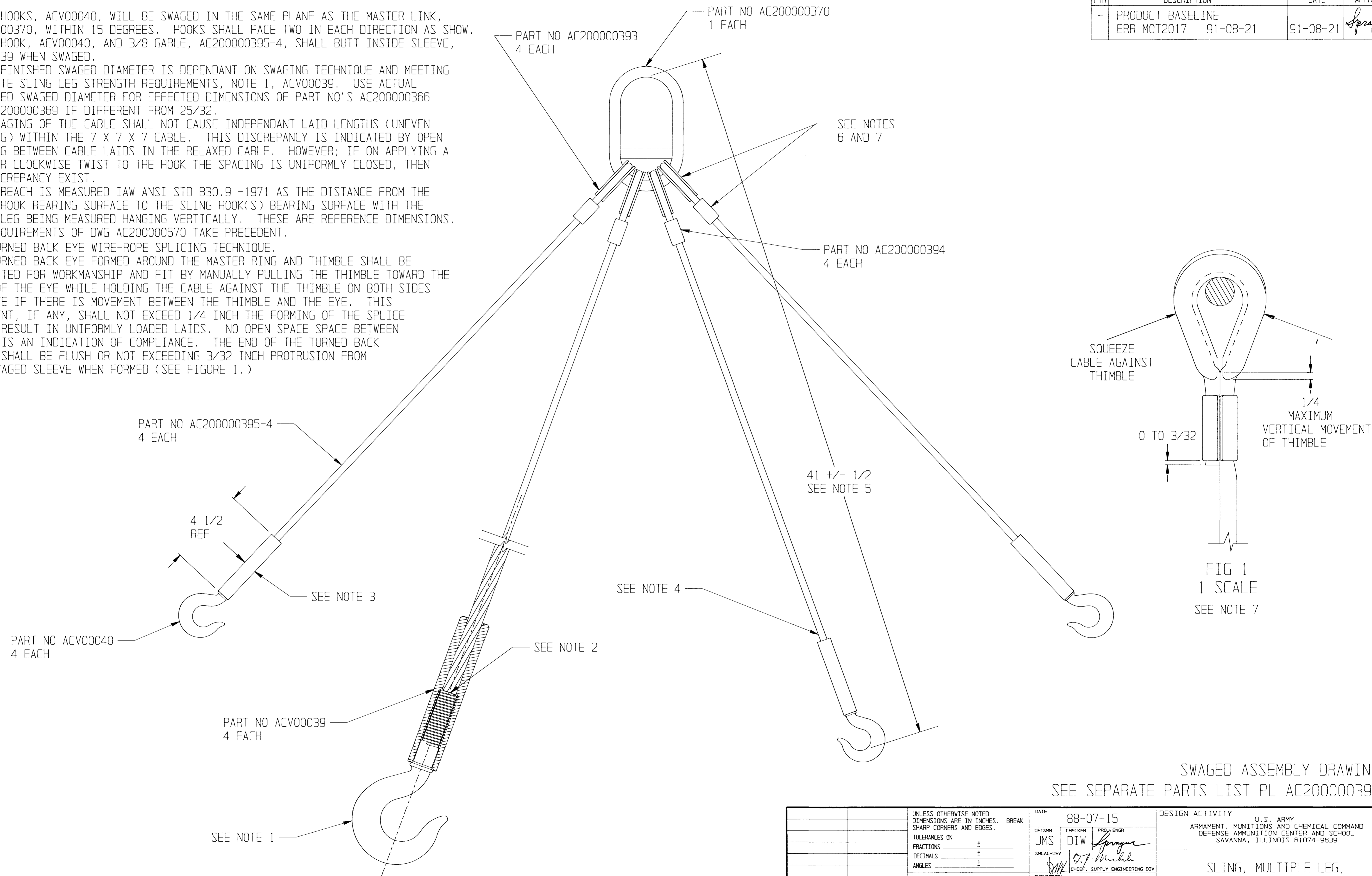
UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES. BREAK SHARP CORNERS AND EDGES. TOLERANCES ON FRACTIONS \pm DECIMALS \pm ANGLES \pm	DATE	88-07-15	DESIGN ACTIVITY	
	DPTSMN	JMS	U.S. ARMY ARMAMENT, MUNITIONS AND CHEMICAL COMMAND DEFENSE AMMUNITION CENTER AND SCHOOL SAVANNA, ILLINOIS 61074-9639	
	CHECKER	SPRAGUE	SLING, MULTIPLE LEG, TOP LIFT AMMUNITION	
	PROJ ENGR	T.J. MICHELS CHIEF, SUPPLY ENGINEERING DIV	SIZE	D
MATERIAL	WILLIAM F. ERNST CHIEF, LOGISTICS ENGINEERING OFFICE	CAGE CODE	28620	AC200000398
APPROVED BY ORDER OF COMMANDING GENERAL, U.S. ARMY MATERIEL COMMAND (AMC)	JOHN L. BYRD JR. U.S. ARMY DEFENSE AMMUNITION CENTER AND SCHOOL	SCALE	1/2	UNIT WT
APPLICATION				SHEET 1 OF 4

DISTRIBUTION STATEMENT A.
APPROVED FOR PUBLIC RELEASE;
DISTRIBUTION IS UNLIMITED.

NOTES:

1. SHANK HOOKS, ACV00040, WILL BE SWAGED IN THE SAME PLANE AS THE MASTER LINK, AC200000370, WITHIN 15 DEGREES. HOOKS SHALL FACE TWO IN EACH DIRECTION AS SHOW.
2. SHANK HOOK, ACV00040, AND 3/8 GABLE, AC200000395-4, SHALL BUTT INSIDE SLEEVE, ACV00039 WHEN SWAGED.
3. 25/32 FINISHED SWAGED DIAMETER IS DEPENDANT ON SWAGING TECHNIQUE AND MEETING ULTIMATE SLING LEG STRENGTH REQUIREMENTS, NOTE 1, ACV00039. USE ACTUAL FINISHED SWAGED DIAMETER FOR EFFECTED DIMENSIONS OF PART NO'S AC200000366 AND AC200000369 IF DIFFERENT FROM 25/32.
4. THE SWAGING OF THE CABLE SHALL NOT CAUSE INDEPENDANT LAID LENGTHS (UNEVEN LOADING) WITHIN THE 7 X 7 X 7 CABLE. THIS DISCREPANCY IS INDICATED BY OPEN SPACING BETWEEN CABLE LAIDS IN THE RELAXED CABLE. HOWEVER; IF ON APPLYING A COUNTER CLOCKWISE TWIST TO THE HOOK THE SPACING IS UNIFORMLY CLOSED, THEN NO DISCREPANCY EXIST.
5. SLING REACH IS MEASURED IAW ANSI STD B30.9 -1971 AS THE DISTANCE FROM THE CRANE HOOK REARING SURFACE TO THE SLING HOOK(S) BEARING SURFACE WITH THE SLING LEG BEING MEASURED VERTICALLY. THESE ARE REFERENCE DIMENSIONS. THE REQUIREMENTS OF DWG AC200000570 TAKE PRECEDENT.
6. USE TURNED BACK EYE WIRE-ROPE SPLICING TECHNIQUE.
7. THE TURNED BACK EYE FORMED AROUND THE MASTER RING AND THIMBLE SHALL BE INSPECTED FOR WORKMANSHIP AND FIT BY MANUALLY PULLING THE THIMBLE TOWARD THE APEX OF THE EYE WHILE HOLDING THE CABLE AGAINST THE THIMBLE ON BOTH SIDES OBSERVE IF THERE IS MOVEMENT BETWEEN THE THIMBLE AND THE EYE. THIS MOVEMENT, IF ANY, SHALL NOT EXCEED 1/4 INCH THE FORMING OF THE SPLICE SHALL RESULT IN UNIFORMLY LOADED LAIDS. NO OPEN SPACE SPACE BETWEEN LAIDS IS AN INDICATION OF COMPLIANCE. THE END OF THE TURNED BACK CABLE SHALL BE FLUSH OR NOT EXCEEDING 3/32 INCH PROTRUSION FROM THE SWAGED SLEEVE WHEN FORMED (SEE FIGURE 1.)

REVISION			
LTR	DESCRIPTION	DATE	APPROVED
-	PRODUCT BASELINE ERR MOT2017	91-08-21	91-08-21 <i>Spangor</i>



SWAGED ASSEMBLY DRAWING
SEE SEPARATE PARTS LIST PL AC200000398

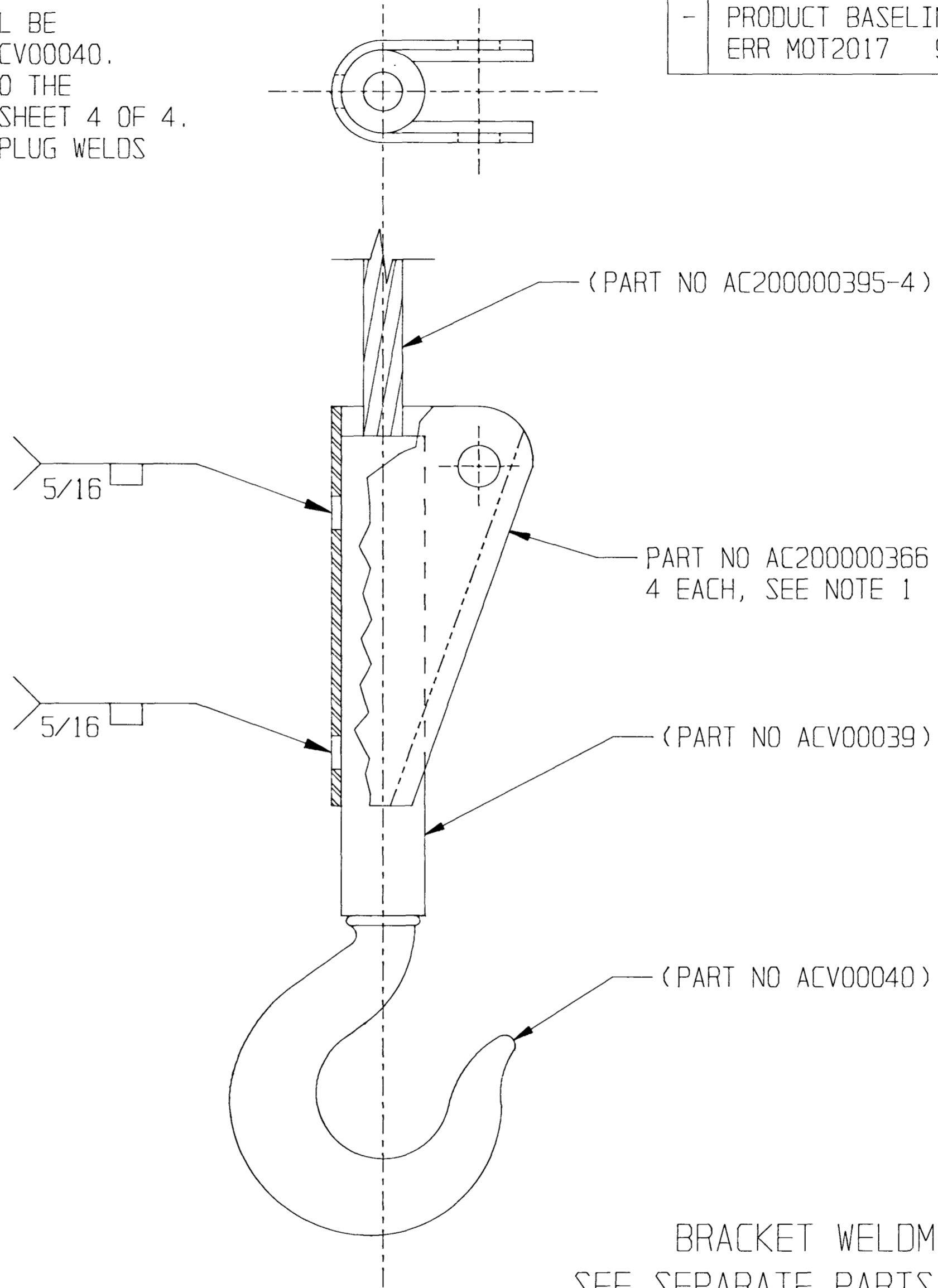
UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES. BREAK SHARP CORNERS AND EDGES.		DATE	88-07-15	DESIGN ACTIVITY	U.S. ARMY ARMAMENT, MUNITIONS AND CHEMICAL COMMAND DEFENSE AMMUNITION CENTER AND SCHOOL SAVANNAH, ILLINOIS 61074-9639
TOLERANCES ON	FRACTIONS	DECIMALS	ANGLES	SLING, MULTIPLE LEG, TOP LIFT AMMUNITION	
	±	±	±	SIZE	CAGE CODE
				D	28620
				SCALE	UNIT WT
				3/8	
APPLICATION		MATERIAL		SHEET 2 OF 4	

2 SCALE DETAIL
OF SWAGED ASSEMBLY

NOTES:

1. THE PLANE OF THE MOUNTING BRACKET, AC200000366, SHALL BE WELDED WITHIN 1/2 DEGREE OF THE PLANE OF THE HOOK, ACV00040. THE POSITION OF THE MOUNTING BRACKET SHALL CONFORM TO THE GAUGED OPEN AND CLOSED POSITIONS OF THE HANDLE; SEE SHEET 4 OF 4.
2. WELD IN ACCORDANCE WITH MIL-STD-1261, CLASS 1. THE PLUG WELDS SHALL BE COMPLETE WITH NO SHARP OR JAGGED EDGES.

REVISION			
LTR	DESCRIPTION	DATE	APPROVED
-	PRODUCT BASELINE ERR MOT2017	91-08-21	91-08-21 <i>Sprague</i>



BRACKET WELDMENT ASSEMBLY DRAWING
SEE SEPARATE PARTS LIST PL AC200000398

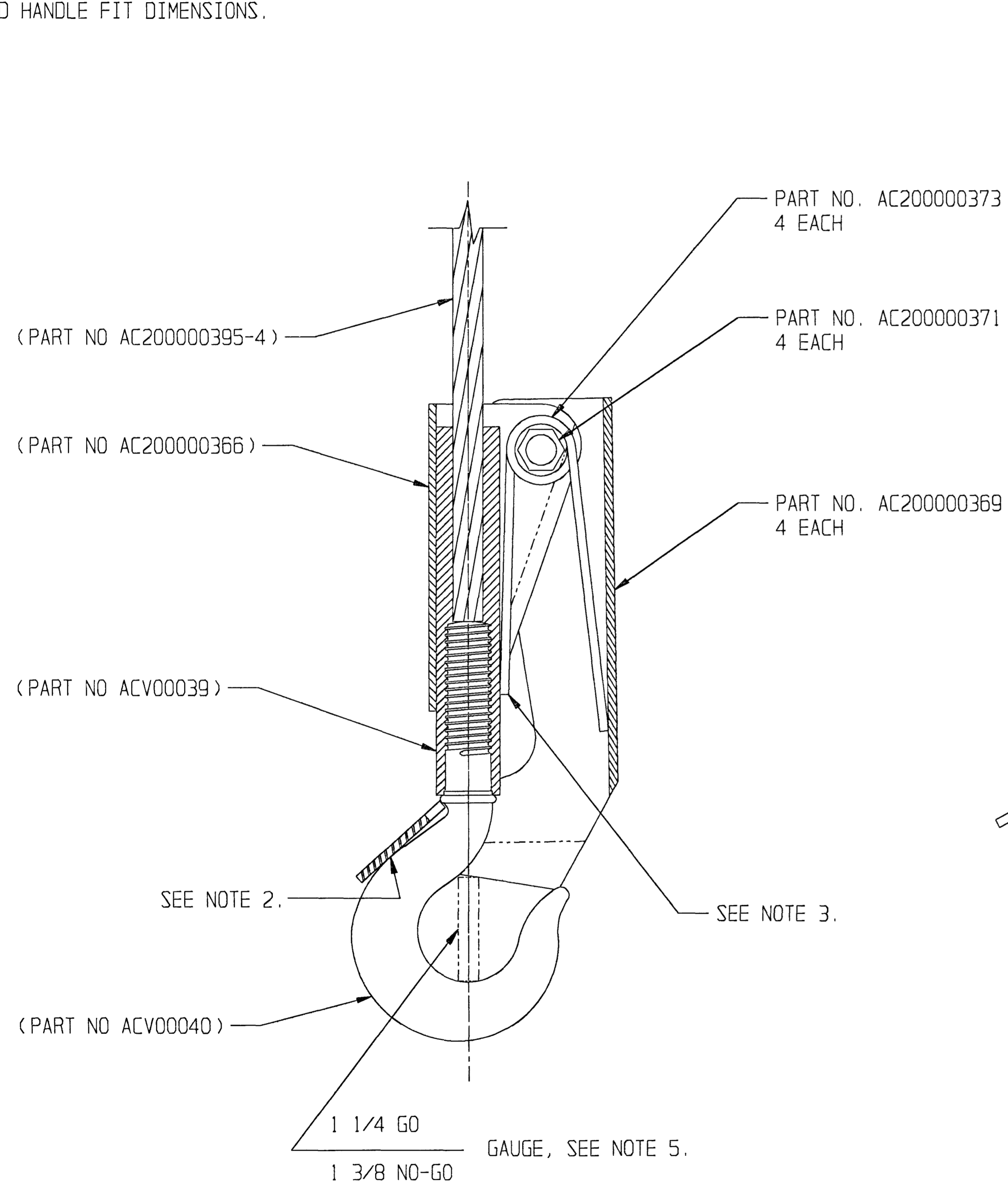
APPLICATION	UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES. BREAK SHARP CORNERS AND EDGES.	DATE 88-07-15	DESIGN ACTIVITY U.S. ARMY ARMAMENT, MUNITIONS AND CHEMICAL COMMAND DEFENSE AMMUNITION CENTER AND SCHOOL SAVANNA, ILLINOIS 61074-9639	
	TOLERANCES ON	DFTSMN JMS	CHECKER DIW	PROJ ENGR <i>Sprague</i>
	FRACTIONS ±	SMCAC-DEV	SUBMITTED <i>William F. Ernst</i> CHIEF, LOGISTICS ENGINEERING OFFICE	
	DECIMALS ±	APPROVED BY ORDER OF COMMANDING GENERAL, U.S. ARMY MATERIEL COMMAND (AMC) <i>Allen L. Byrd</i> U.S. ARMY DEFENSE AMMUNITION CENTER AND SCHOOL		SIZE C
ANGLES ±	MATERIAL	CHIEF, SUPPLY ENGINEERING DIV <i>T.J. Michal</i>	CAGE CODE 28620	AC200000398
			SCALE 1	UNIT WT
				SHEET 3 OF 4

REVISION			
LTR	DESCRIPTION	DATE	APPROVED
-	PRODUCT BASELINE		
	ERR MOT2017	91-08-20	91-08-21 SPRAGUE
B	NOR MST5000	96-04-17	97-03-24 <i>Sprague</i>

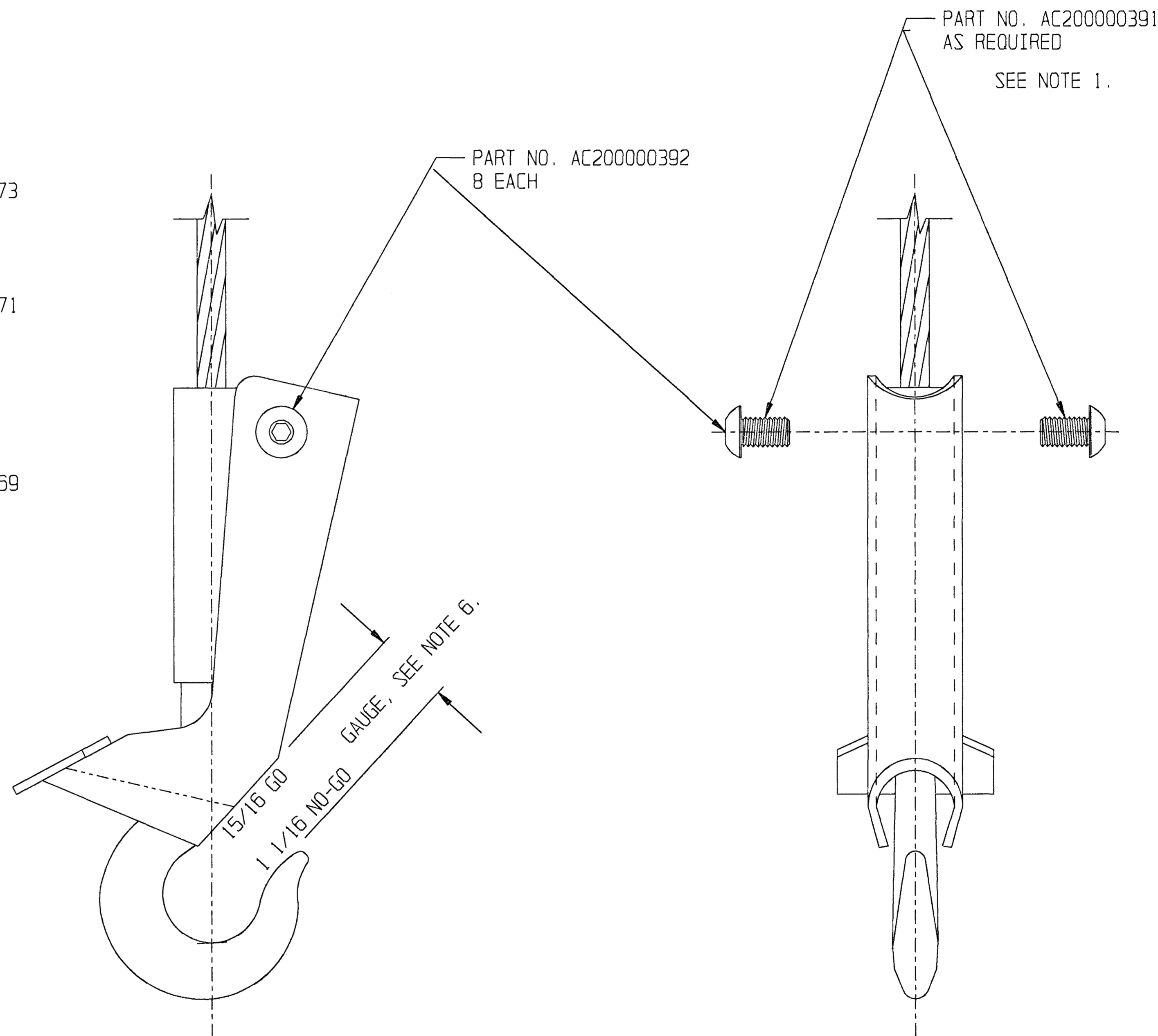
NOTES:

1. THE TWO SCREWS, AC200000392, ARE SECURED IN THE SPACER NUT, AC200000371, BY "LOCTITE", AC200000391. ADJUST THE BOLTS TO ELIMINATE BINDING OF THE HANDLE. THERE SHOULD BE NO MORE THAN 1/64 CLEARANCE BETWEEN HEAD OF BOLT AND THE HANDLE SURFACE.
2. THERE SHALL BE NO CONTACT BETWEEN THE HOOK AND HANDLE EXCEPT AS SHOWN.
3. SEE NOTE ON SPRING ALTERATION, DRAWING AC200000373.
4. THE ASSEMBLED MOUNTING BRACKET, AC200000366, HANDLE, AC200000369, AND HOOK, ACV00040, AFTER PAINTING SHALL WORK FREELY AND RESPOND TO CLOSING TENSION OF THE SPRING, AC200000373, WITHOUT DRAG. WORKING THE HANDLE UP TO FIVE TIMES SHALL REMOVE ANY PAINT INTERFERENCE. THIS NOTE HAS PRECEDENCE OVER BRACKET AND HANDLE FIT DIMENSIONS.

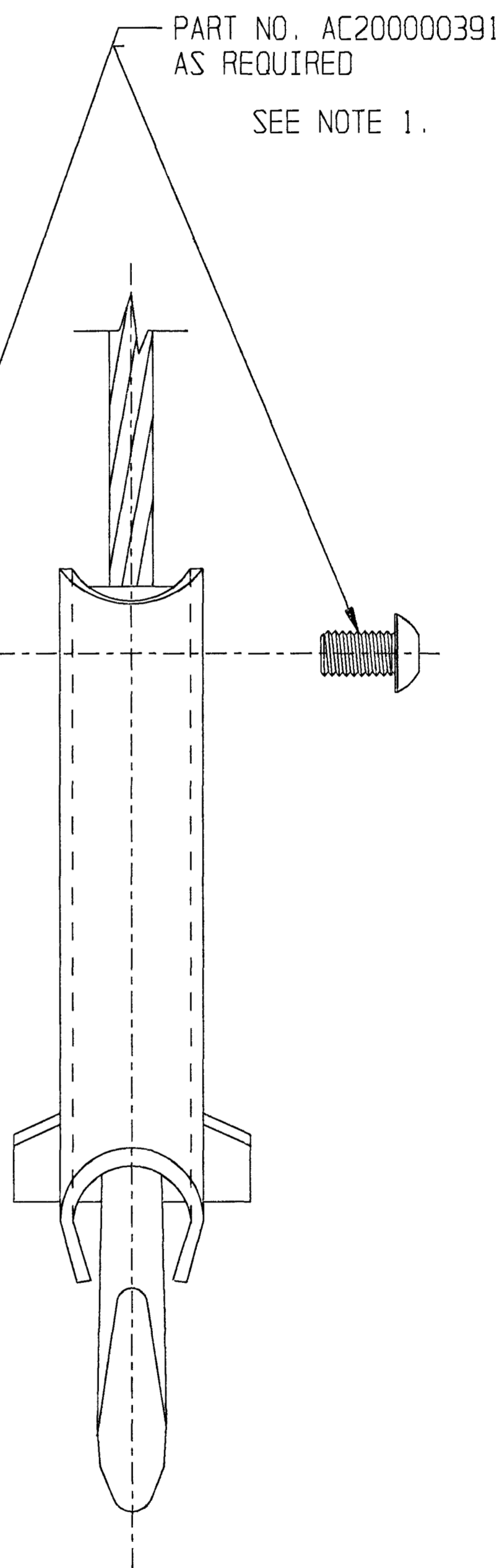
5. CONSTRUCT FROM 1/4 X 1 1/2 FLAT BAR STOCK A GO, NO-GO GAUGE HAVING A WIDTH OF 1 1/4 +/-1/64 FOR THE GO GAUGE AND A WIDTH OF 1 3/8 +/-1/64 FOR THE THE NO-GO GAUGE. THE GAUGE MEASUREMENT IS TO BE TAKEN VERTICALLY CENTERED ON THE CENTERLINE OF THE HOOK.
6. CONSTRUCT FROM 1/4 X 1 1/4 FLAT BAR STOCK A GO, NO-GO GAUGE HAVING A WIDTH OF 15/16 -1/64 FOR THE GO GAUGE AND A WIDTH OF 1 1/16 -1/64 FOR THE NO-GO GAUGE. THE GAUGE MEASUREMENT IS TO BE TAKEN PERPENDICULAR TO THE THROAT OPENING OF THE HOOK. THE CONTACT SURFACE AT THE UPPER LEFT SIDE SHOULD BE THE HOOK BODY.



ASSEMBLY AND GAUGING
CLOSED POSITION
SEE NOTE 1, SHEET 3 OF 4



ASSEMBLY AND GAUGING
OPEN POSITION
SEE NOTE 1, SHEET 3 OF 4



HANDLE ASSEMBLY DRAWING
SEE SEPARATE PARTS LIST PL AC200000398

DISTRIBUTION STATEMENT A.

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UNLESS OTHERWISE NOTED DIMENSIONS ARE IN INCHES. BREAK SHARP CORNERS AND EDGES.		DATE	88-07-15	DESIGN ACTIVITY	U.S. ARMY ARMAMENT, MUNITIONS AND CHEMICAL COMMAND DEFENSE AMMUNITION CENTER AND SCHOOL SAVANNA, ILLINOIS 61074-9639
TOLERANCES ON FRACTIONS	±	DFTSHN	JMS	CHECKER	PROJ ENGR
DECIMALS	±	SHEAC-DEV	T. J. MICHELS	CHIEF, SUPPLY ENGINEERING DIV	
ANGLES	±	SUBMITTED	WILLIAM F. ERNST	CHIEF, LOGISTICS ENGINEERING OFFICE	
MATERIAL		APPROVED BY ORDER OF COMMANDING GENERAL, U.S. ARMY MATERIEL COMMAND (AMC)	JOHN L. BYRD JR.	SIZE	CAGE CODE
				D	28620
				SCALE	UNIT WT
				1	
APPLICATION					SHEET 4 OF 4