TUB COUPLING

5 TONNE

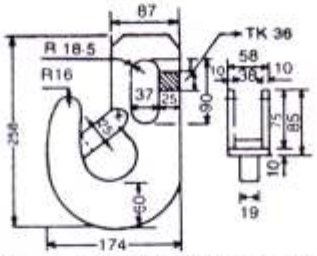

FIG. 1 HOOK COUPLING

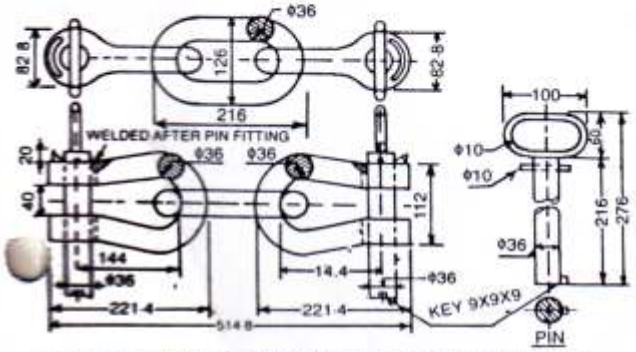

FIG. 2. TWO SHACKLE & PIN 'R' TYPE

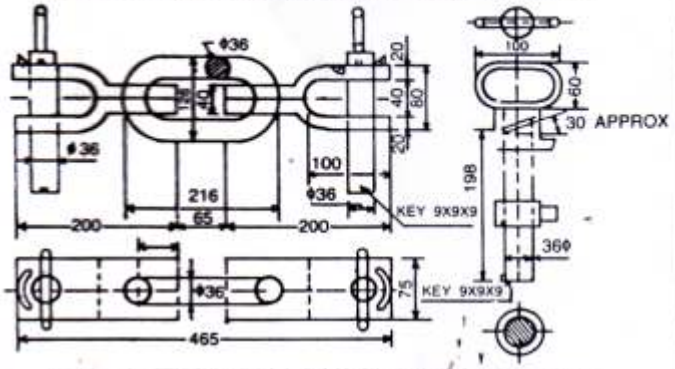

FIG. 3. TWO SHACKLE & PIN 'F' TYPE

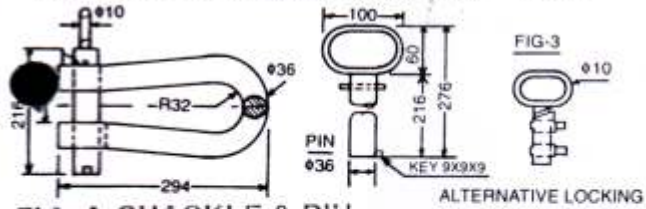

FIG. 4. SHACKLE & PIN

ALTERNATIVE LOCKING ARRANGEMENT OF PIN

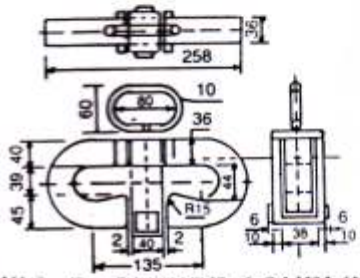

FIG. 5. 'C' TYPE COUPLING

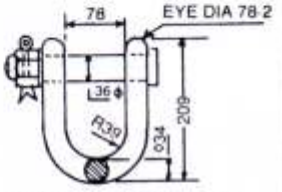

FIG. 6. 'D' LINK

Tub Couplings are manufactured Conforming to DGMS circular No. 1 of 1986

Design :

The main dimension of Coupling have been shown in sketches.

Materials :

5 Tonne Coupling from 11 Mn_2 to IS : 4432-1967 or 20 Mn_2 to IS : 1570-1961 or 20 Ni 55 Cr 50 Mo 20 to IS : 4432-1967.

Chemical Composition :

Class	C%	Mn%	Si%
$11Mn_2$	.16Max	1.3—1.7	0.15—0.35
$20Mn_2$	.16—.24Max	1.3—1.7	0.15—0.35

Heat-Treatment :

Coupling shall be supplied in Hardened & tempered condition.

Every coupling after all forging and welding operations shall be given proper heat-treatment in a recognised establishment at the following temperature and certificate of heat-treatment shall be obtained.

Sl. No.	Designation of Steel	Normalising °C Temp.	Hardening °C Temp.	Tempering °C Temp.	Quenching Agent
1.	11 Mn2	870—910	870—910	550—660	Water or Oil
2.	20 Mn2	860—900	860—900	550—660	Water or Oil
3.	20Ni55Cr 50Mo20	*	820—850	*	Water

*Suitable temperature may be adopted so as to attain the optimum properties.

Marking :

5 mm size punch shall be used for marking.

NMC / YR / S. No. /SWL/A

*A for Hardened & Tempered condition.

Certification :

Certificate for 10% P.L. & 5% N.D.T. shall accompany the supply.

Repair & Rejection :

Wear & tear shall not be built through welding & coupling should be discarded when there is loss of cross-section of 15% or more.

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