

## 6. REQUIREMENTS

- 6.1 The chaplets shall be given an anti-corrosion coating (passivated). Zinc shall not be used for coating.
- 6.2 Chaplets for castings that are subjected to hydraulic testing shall be coated with tin conforming to grade SN 99.75 of IS: 26-1966\*.
- 6.2.1 Chaplets for other uses may also be tinned in accordance with the requirements of the purchaser. Hot dip tinning shall be done in conformity with IS: 5274-1969.
- 6.3 The columns of chaplets shall be perpendicular to the supporting surfaces and the deviation from perpendicularity shall not exceed 3 degrees.
- 6.4 The supporting surface of the chaplets shall be mutually parallel. The departure from parallelism shall not exceed:

Height, H	Departure from Parallelism
mm	mm
Up to 20	0.8
From 22 to 30	1.0
" 32 " 50	1.2
" 55 " 80	1.4
" 85 " 120	1.7
" 120 mm and above	2.0

- 6.5 The purchaser may order for supply of perforated chaplets excepts in case of type 11. The holes shall be uniformly staggered in such cases.
- 6.6 The pitch of the threads for type 5, variant 2, 3, 5 and 6 shall be mentioned in the order, and the roots of the threads shall have no grease, dirt or rust deposited on them.

## 7. PACKAGING

- 7.1 Unless specified otherwise, the material shall be supplied in waterproof double gunny bags or polythene lined boxes each weighing not more than 50 kg overall.

\*Specification for tin ingots (second revision).  
Recommended practice for hot dip tinning of plain carbon steel.