

SRI LANKA STANDARD 109:1981
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SPECIFICATION FOR
METAL FITTINGS FOR PLYWOOD TEA CHESTS
(FIRST REVISION)

BUREAU OF CEYLON STANDARDS

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Gr.5

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FOREWORD

This Sri Lanka Standard specification has been prepared by the Drafting Committee on Tea Chests. It was approved by the Civil Engineering Divisional Committee of the Bureau of Ceylon Standards and was authorized for adoption and publication by the Council of the Bureau on 1981-07-28.

This specification was first published in 1971 as CS 109. The present revision includes a revised sampling scheme, tolerances for dimensions of fittings, a clause on marking and it covers packing requirements of metal fittings for both 12-batten and 8-batten type tea chests. Detailed specifications for rivets are not included as these are not manufactured in Sri Lanka.

This specification covers only the requirements for metal fittings. The requirements for plywood panels and battens are covered in CS 108 and the requirements for the complete tea chest are covered in SLS 378.

All standard values in this specification are given in SI units.

For the purpose of deciding whether a particular requirement of this specification is complied with the final value, observed or calculated, expressing the result of a test or analysis shall be rounded off in accordance with CS 102. The number of significant places retained in the rounded off value should be the same as that of the specified value in this specification.

1 SCOPE

This specification covers the requirements for metal fittings used in the assembly of plywood tea chests specified in SLS 378.

2 REFERENCES

This specification makes reference to the following Sri Lanka Standards:

- CS 7 Cold drawn mild steel wire for the manufacture of wire nails
- CS 8 Wire nails
- CS 102 Presentation of numerical values
- CS 108 Components for plywood tea chests
- SLS 378 Plywood tea chests

3 COMPONENTS

Metal fittings for plywood tea chests shall consist of the following:

3.1 Metal strips

- a) Corner strips (flat) - 3 per chest;
- b) Corner strips (angled 90°) - 1 per chest; and
- c) Top and bottom strips, angled 90° and 'V' notched - 8 per chest.

3.2 Fixing accessories

- a) Wire nails, 25 mm;
- b) Wire nails, 30 mm (see 5.1);
- c) Tenterhooks; and
- d) Bifurcated rivets - only for 8-batten type chests.

4 REQUIREMENTS FOR METAL STRIPS

4.1 These shall be made from bright tin plate free from surface imperfections. The longitudinal edges shall be folded over flat (towards the outer side) to form beaded edges as shown in Figure 1a and Figure 1b.

4.2 In the case of strips provided with 'V' notch (see 3.1(c)) the 'V' notch shall extend up to the fold.

NOTE - The 'V' notch may differ in shape from that shown in the figure. But the metal strip should be capable of being bent at right angles at the 'V' notch without damage.