

# DRAFT

## TECHNICAL SPECIFICATION OF 11-TYPES OF FLAT SEAL FOR HS748 AIRCRAFT

<b>Date</b>	<b>Prepared</b>	<b>Checked</b>	<b>Approved</b>	<b>RCMA(K)</b>

REPORT NUMBER	ISSUE	REVISION	DATE
HAL(K)/INDGN/HS748/HS748-2537_HS748-2547	Nil	Nil	04/09/2025

## AMENDMENT RECORD TABLE

The incorporation of each amendment, to this document is to be recorded by filling the column against the issue/amendment number.

Sl. No.	Issue/ Amendment No	Date of Issue/ Amendment	Amended Page Nos. (For amendments)	Signature of the 'Approved by' authority	Remarks

REPORT NUMBER	ISSUE	REVISION	DATE
HAL(K)/INDGN/HS748/HS748-2537_HS748-2547	Nil	Nil	04/09/2025

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## 1. General

Nomenclature	11-Types of Flat Seals
Project	HS748 Aircraft
Part Number	Refer Table 1
Aircraft System	Refer Table 1

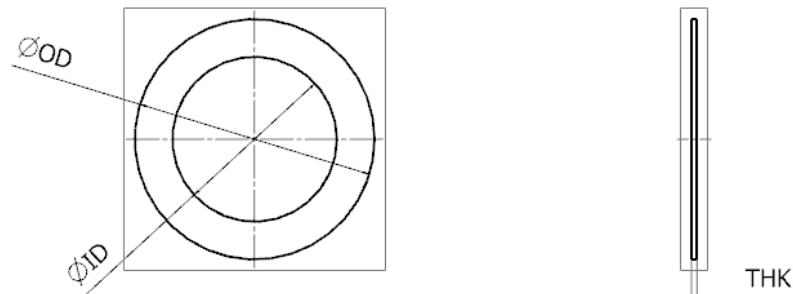
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## 2. Assembly Description:

Refer table 1 appended below for assembly details of all the Flat Seals.

## 3. Technical data: Refer table 1 and following fig.



**Table 1.**

S/N	Indigenous P/N	Outer Dia. (OD) (MM)	Internal Dia. (ID) (MM)	Thickness (THK) (MM)	Material	Remark
1	HS748-2537	76.2 ± 0.50	67.9 ± 0.5	2.15 ± 0.15	Rubberised Fabric 1666	Rubberised Fabric 1666 / Detailed material spec. to be provided.
2	HS748-2538	75.6 ± 0.50	66.7 ± 0.50	5 ± 0.20	M-DLMAT436 Type 2454	Nitrile Rubber compound ref. 2454, shore 'A' hardness 66-74, temp. rage -54 to 135 / Detailed material spec. to be provided.
3	HS748-2539	18.7 ± 0.20	14 ± 0.20	3.13 ± 0.15	MAT436 Type 2454	
4	HS748-2540	89.2 ± 0.50	79.7 ± 0.50	3.2 ± 0.15	M-DLMAT436 Type 2454	
5	HS748-2541	81.9 ± 0.50	76 ± 0.50	3.15 ± 0.15	M-DLMAT436 Type 2454	
6	HS748-2542	71.7 ± 0.50	65.6 ± 0.50	3.2 ± 0.15	MAT436 Type 2454	
7	HS748-2543	73.7 ± 0.50	64.52 ± 0.50	3.15 ± 0.15	M-DLMAT436 Type 2454	
8	HS748-2544	65.1 ± 0.50	57.7 ± 0.40	3.15 ± 0.15	M-DLMAT436 Type 2454	
9	HS748-2545	19.8 ± 0.25	15.6 ± 0.20	2.17 ± 0.15	MAT436 MAT 2454	
10	HS748-2546	9.8 ± 0.20	6.9 ± 0.20	2.17 ± 0.15	MAT436, Type 2454	
11	HS748-2547	16.75 ± 0.25	12.5 ± 0.20	2.2 ± 0.15	M-DLMAT436 Type 2454	

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#### 4. Qualification Testing:

S/N	Type of Test/ Inspection	Requirements/Reference documents
1	Material Test	Detailed material characterization as per the material mentioned in the Table 1
1.1	Tensile strength	To meet the equivalent material requirements of material cited in Table 1.
1.2	Hardness	
1.3	Elongation	
1.4	Air aging	
1.5	Volumetric Swelling	
1.6	Compression Set	
2	Dimensional check	As per Drawings
3	Installation check	As per CMM/AMM
4	Operational test (Leakage)	As per CMM/AMM
5	Strip off inspection	Visual inspection

The qualification requirements suggested by regulatory authority at any stage of development shall be binding to the vendor/DA and shall be demonstrated to CEMILAC/DGAQA.