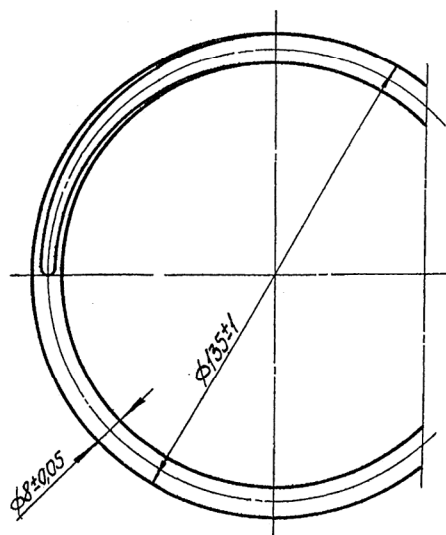
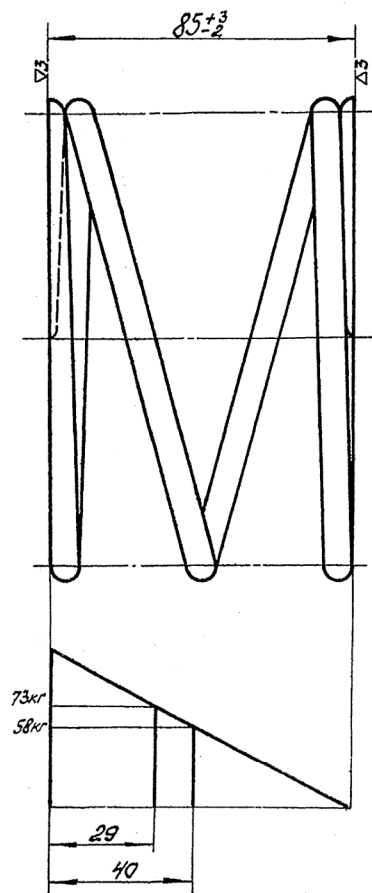


DRAWING NUMBER  
172.47.116-1

SHEET No. 1 OF 1

~ (▽)



NUMBER OF OPERATING COILS	1.5	DIRECTION OF SPRING COILING	LEFT
TOTAL NUMBER OF COILS	3.5 - 0.5	LENGTH OF STRAIGHTENED SPRING	≈ 1420

1. AFTER 3 TIME COIL - TO - COIL COMPRESSION OF SPRING, RESIDUAL DEFORMATION IS NOT ALLOWED.
2. THE HEIGHT OF FULLY COMPRESSED SPRING SHOULD BE 25 mm, MAX.
3. WHILE COMPRESSING THE SPRING TO THE HEIGHT OF 40 mm, THE FORCE SHOULD BE 58<sup>+10</sup><sub>-7</sub> Kg.
4. TO BE HARDENED. HARDNESS HRC 40 - 48 HARDNESS SHOULD BE TESTED ON TEST PIECE.
5. TO BE GALVANIZED TO 6 - 12 μ. TO BE CHROMATIZED.
6. LOADING DIAGRAM IS GIVEN FOR REFERENCE.
7. THICKNESS OF COIL SUPPORTING ENDS SHOULD BE 2.5 mm, MIN.  
IN THIS CASE, THE SUPPORTING SURFACE SHOULD NOT BE LESS THAN 3/4 OF THE CIRCUMFERENCE.
8. DECREASE OF EXTERNAL DIAMETER 135 ± 1 ON A LENGTH OF OPERATING COILS OF SPRING UPTO 132 mm IS ALLOWED.
9. IT IS ALLOWED TO USE OTHER GROUPS OF SURFACE FINISH OF WIRE AS PER GOST 14963 - 78, EXCEPT GROUPS H AND A.
10. NON - SQUARENESS OF SPRING AXIS SHOULD NOT BE MORE THAN 3 mm ON THE SPRING LENGTH.

PILOT SAMPLE SHOULD BE APPROVED BY A H S P  
BEFORE BULK PRODUCTION.

EST. WT. (Kg) 0.55 ✓	TO BE STAMPED OR MARKED WHERE INDICATED THUS # ( LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUT- SIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

8C	06.05.12	55150/CQA(HV)/08/BLT T-72 Dt. 19.07.11	DRN	Sd / =	MATERIAL:- WIRE 60 C 2 A - Γ - XH - 8.0 GOST 14963 - 78. ✓	USED ON:- PV572.0711.0093 475.47eb-1Gb 172.45.060cbCb ✓
8B	07.07.06	AUTHY.LINo.80001/CQA(HV)/GEN/Dt.15.10.05	CHD	Sd / =		
8A	25.10.04	N OF A No. CQA(HV)/T90/45/001 ✓	APPD	Sd / =		
ISSUE	DATE	NATURE OF AMENDMENTS	DATE	18 - 09 - 86 ✓	CONTROLLERATE OF QUALITY ASSURANCE (HEAVY VEHICLES) AVADI	
			SCALE:-	1 : 1 ✓		
			DIMENSIONS IN mm			
			TOLERANCE ON DIMNS UNLESS OTHERWISE STATED IS : 2102 - 69			
			ALL THREADS TO CONFORM TO IS : 4218 Pt.IV			
			D S CAT NUMBER			
			DRAWING NUMBER			

SPRING

DRAWING NUMBER  
172.47.116-1