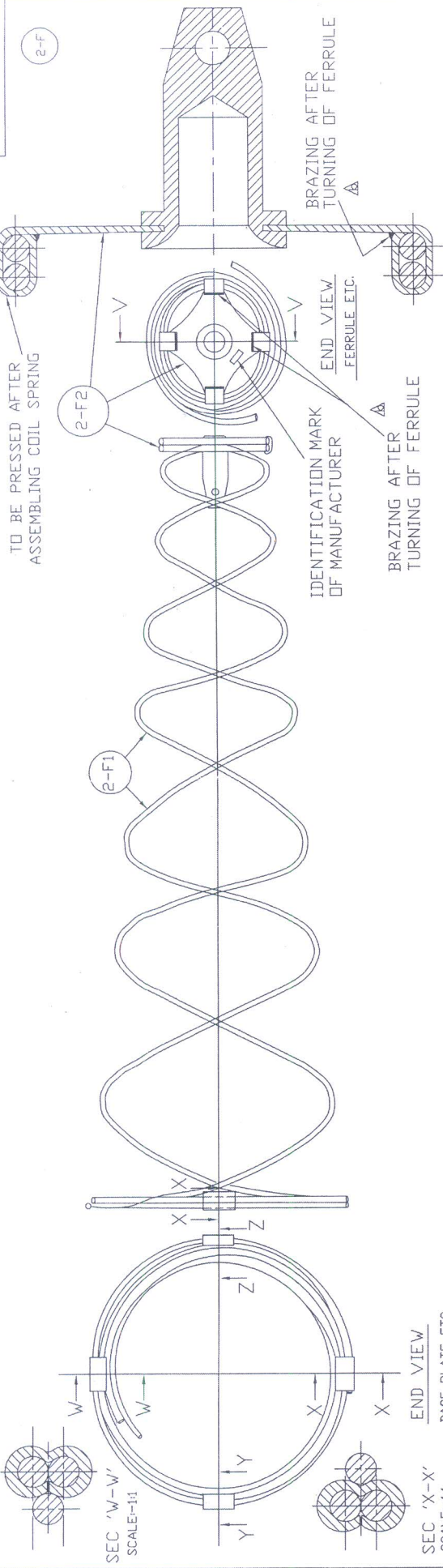




SECTION 'V-V'

SCALE-1:1

2-F2	3	BASE PLATE WITH CONE	1
2-F1	2	SPRING WITH FERRULE	2
DTL. No.		SHEET No.	No. OFF

DETAIL INDEX

ENDURANCE TEST:-

ENDURANCE TEST AS PER THE PROCEDURE FOR COMPRESSION TEST TO BE REPEATED FOR 20 TIMES FOR 5% SPRINGS OF EACH LOT OR MIN. OF INO. IF THE LOT QUANTITY IS LESS THAN 20. PERMANENT SET SHALL NOT BE MORE THAN 03mm AFTER 20 COMPRESSION. SPRING USED FOR ENDURANCE TEST SHALL BE YELLOW BANDED AND SHALL NOT BE DELIVERED.

सही सत्यापित / CERTIFIED CORRECT
A. M. B.
आइसो 9001:2015 / ISO 9001:2015

PACKING:-

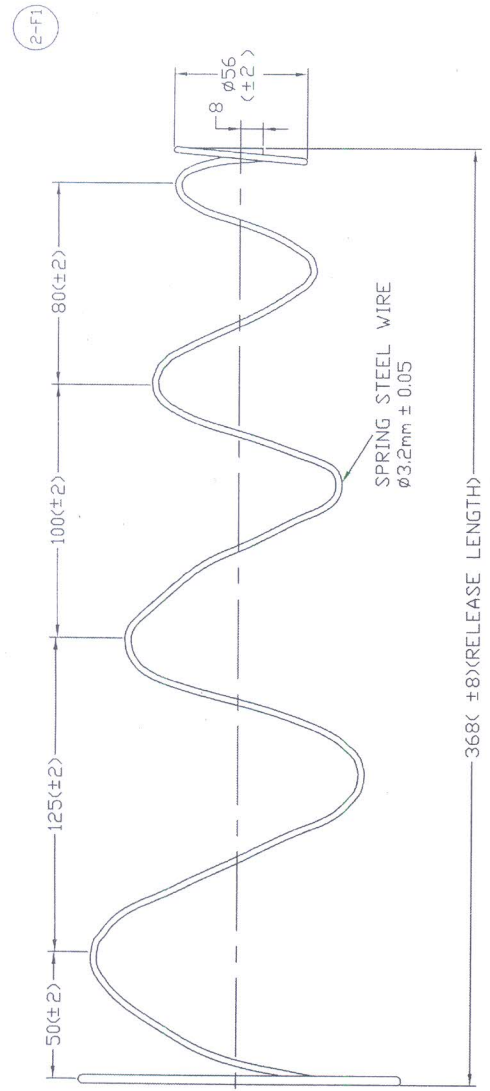
FIVE NOS OF COIL SPRING SHALL BE GROUPED TOGETHER SO THAT THEIR COILS DO NOT COME INTO ONE ANOTHER THEREAFTER THESE SHOULD BE SECURED WITH JUTE TWINE AT THE TOP AND BOTTOM ENDS. EACH SUCH UNIT SHALL BE PACKED IN A POLYTHENE BAG. EIGHT SUCH BAGS SHALL BE PLACED IN A C.W.P. DULY LINED WITH PAPER PACKING WATER PROOF. ONE SAMPLE IN EACH POLYTHENE BAG SHALL BE IDENTIFIED BY A LABEL SHOWING CAT. No. DESIGNATION OF THE STORE AND RECOGNISED INITIAL OF THE MANUFACTURE AND YEAR OF MANUFACTURING. THE PACKING CASE SHALL BE INDELIBLY MARKED WITH THE ADDRESSES OF THE CONSIGNEE, CONSIGNOR, CAT. No., DESIGNATION, YEAR OF THE MANUFACTURE, QUANTITY AND THE NUMBER OF THE INDIVIDUAL PACKS

COMPRESSION TEST:-

THE SPRING SHALL BE COMPRESSED FULLY (WHEN CONE HOLE JUST COMES OUT OF THE SPRING COIL) UNDER A LOAD OF NOT LESS THAN 234N (29Kg) AND NOT MORE THAN 324N (33Kg), AFTER BEING MAINTAINED IN FULLY COMPRESSED POSITION UNDER SUCH LOAD FOR A PERIOD OF 10-MINUTES. PERMANENT SET SHALL NOT MORE THAN 01mm

SCALE:- 1:2, 1:1, 2:1	ADRDE AGRA	DRN.	NARESH	PRD. OFF.
DIMENSIONS IN mm	GROUP:- ABS	CHD.	NIROTI	GP. DIR.
TOL:- AS PER SHEET-2				DI/C D&S
MATERIAL:- AS PER SHEET-2	ASSEMBLY COIL SPRING			APPROVED
FINISH:-	BRAKE PARACHUTE (17Sqm) HYBRID			DRG. No.
HEAT TREATMENT:-				1.3.01-02-01(a)(b)

Rev. No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	0 I/C D&S	HEAD QA
b	07-01-19	SE. 20	OMS/PG/ABS/65/01	AMENDED AS PER CHANGE SHEET No. 62	5	



FERRULE BOTH ENDS
TO BE PRESSED IN
AND BRAZED

SECTION X-X
SCALE:-1:1

NOTE:- ALL THE SHARP EDGES TO BE ROUNDED OFF

MATERIAL:-

- (a) SPRING-SPRING STEEL MUSIC WIRE Ø3.2±0.05 TO SPECN IS:4454-2001, PART1,SH
- (b) FERRULE-M.S.SHEET 1.0mm THICK

WORKMANSHIP:-

BOTH ENDS OF FERRULE TO BE PROPERLY JOINED AND FINISHED AFTER SOLDERING.

FINISH:-

- (a) SPRING SHOULD BE CADMIUM PLATED TO A MIN. THICKNESS OF 0.012mm AND CHROMATE PASSIVATED AS PER SPECN:IS:1572-1986, GRADE 3, Fe/Cd12
- (b) FERRULE SHOULD BE CADMIUM PLATED TO A MIN. THICKNESS OF 0.012mm AND CHROMATE PASSIVATED AS PER SPECN. IS: 1572-1986, GRADE 3, Fe/Cd12

EMBRITILEMENT RELEASE:-

SPRING AFTER CADMIUM PLATED AND PRIOR TO CHROMATE PASSIVATION SHALL BE MAINTAINED AT A TEMP.OF 150° C FOR HALF AN HOUR TO REMOVE HYDROGEN EMBRITILEMENT.

GENERAL TOLERANCE:-

±0.2mm EXCEPT SPECIFIED OTHERWISE.

MFG. PROCESS:-

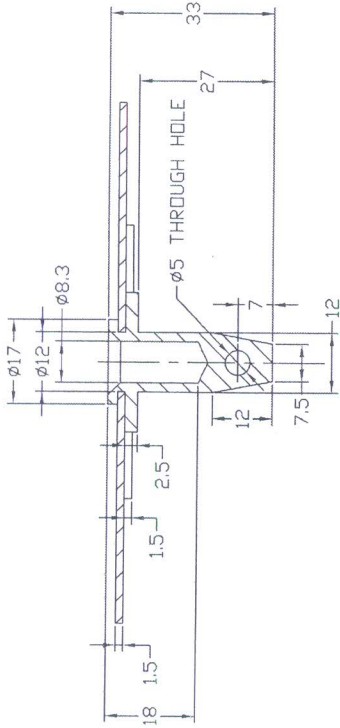
GENERAL ENGINEERING METHOD

Rev.No.	07-01-19	DATE	ZONE	AUTHORITY	AMENDED AS PER CHANGE SHEET No. 62	HEAD QA
BRIEF RECORD						
8		7		6		5

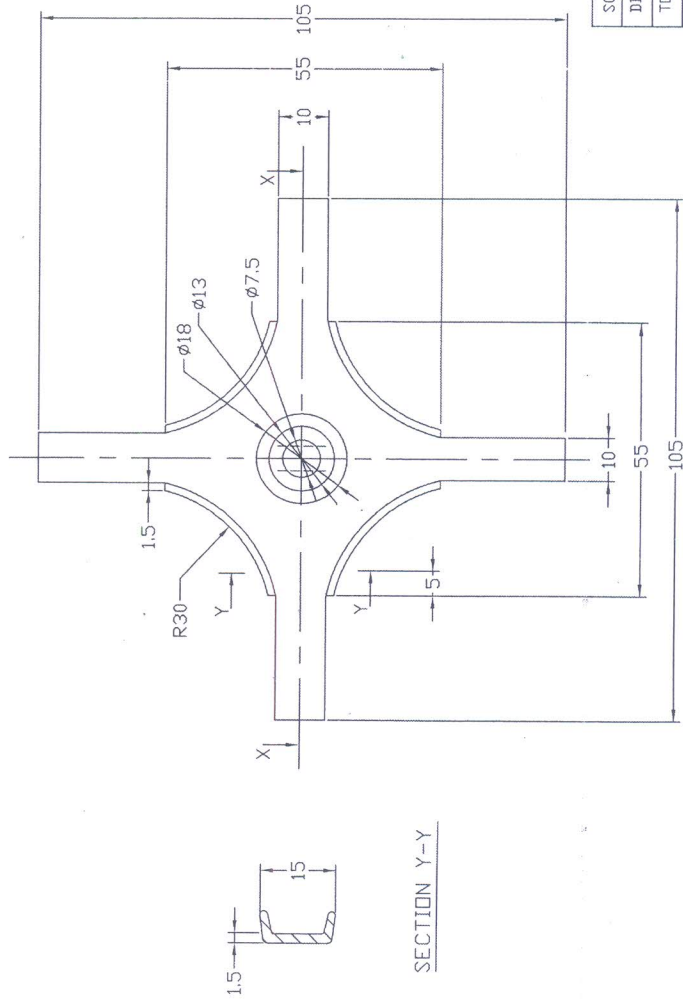
2-OFF

SCALE:- 1:2,1:1	ADRD AGRA	DRN.	NARESH	PRD. OFF.
DIMENSIONS IN mm	GROUP:- ABS	CHD.	NIROTI	GP. DIR.
TOL:- AS ABOVE	SPRING COIL SPRING BRAKE PARACHUTE (17Sqm) HYBRID			DI/C D&S
MATERIAL:- AS ABOVE				APPROVED
FINISH:- AS ABOVE				DRG. No.
HEAT TREATMENT:- _____				1.3.01-02-01(ø)(b)
				

(2-F2)



SECTION X-X



SECTION Y-Y

MATERIAL:-

STEEL TO SPECN IS1570-1979, PART 2, SECTION 1, 2008

TOLERANCE:-

IS:2102(Part-1)1993-MEDIUM, UNLESS OTHERWISE SPECIFIED.

WORKMANSHIP:-

1. ALL SHARP EDGES TO BE ROUNDED OFF.
2. CONE TO BE PRESS FITTED AND PUNCHED FIRMLY WITH THE BASE PLATE
3. HOLE OF THE CONE SHOULD BE FINISHED ENOUGH TO ALLOW SMOOTH MOVEMENT OF DIA 5mm M.S. ROD THROUGH IT.

FINISH:-

HAVING FITTED THE BASE PLATE TO THE SPRING, THE WHOLE ASSEMBLY SHOULD BE CADMIUM PLATED TO A MINIMUM THICKNESS OF 0.012mm AND CHROMATE PASSIVATED AS PER SPECN. No. IS1572-1986, GRADE 3, Fe/Cd12 AS MENTIONED IN SHEET No. 2 OFF 3.

MFG. PROCESS:-

GENERAL ENGINEERING METHOD

C. M. K.

<									
---	--	--	--	--	--	--	--	--	--

BRIEF RECORD

AUTHORITY

ZONE

DATE

Rev.No.

HEAD

D&S

GA