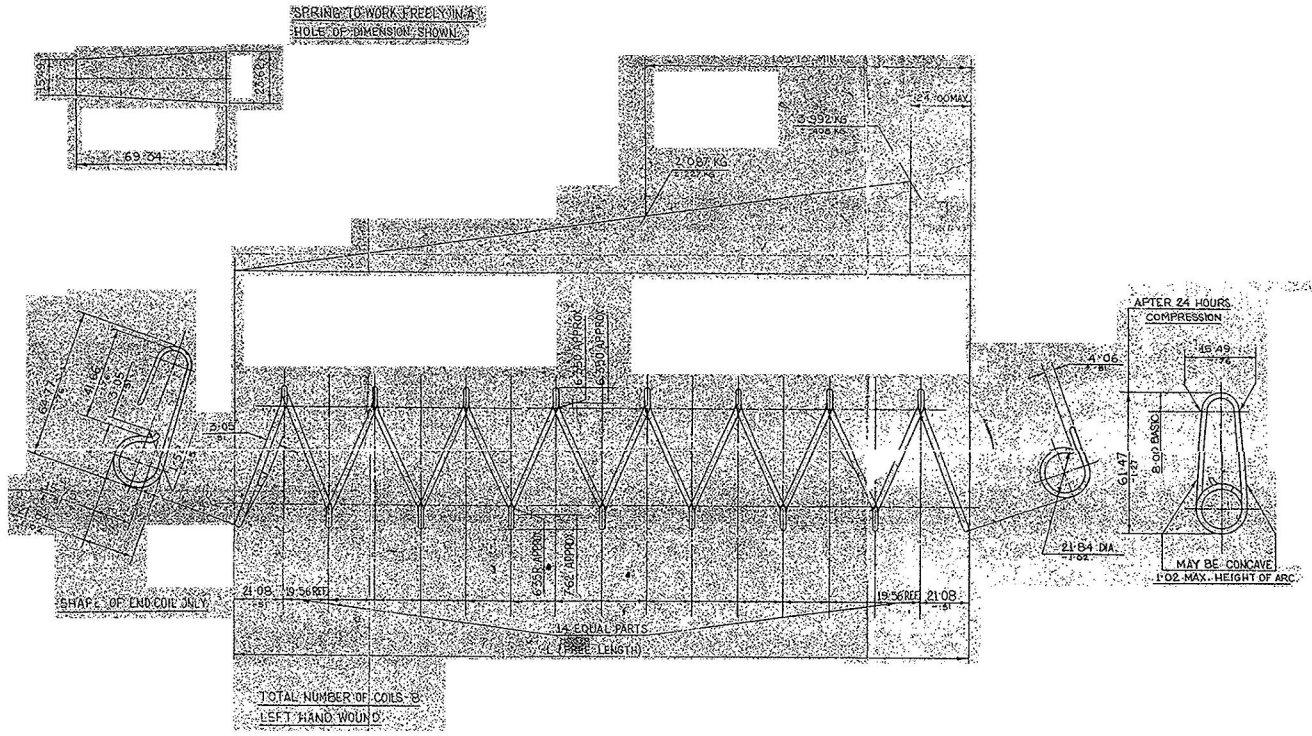

NOTE
WHERE TOLERANCES ARE NOT SHOWN DIMENSIONS IN BRACKET, NUMBER OF WITH ONE DECIMAL PLACE ± 1.27 MM DIMENSIONS WITH NO DECIMAL PLACES ± 1.27 MM

L	MATERIAL	DIA OF WIRE	CAMP TESTING LENGTH	HEAT TREATMENT	TENSILE RANGE
285.8 ± 2.7	BS 1429 EN42C	1.78	20.57 FOR 24 HRS	HARDENED AND TEMPERED.	
316.0 ± 4.0	~~SPECN DEPDC 15/4454 PT.1 / 2816 GR.~~	1.70	19.81 FOR 24 HRS	LOW TEMPERATURE TREATMENT 220°C - 240°C	204.72 TO 220.47 KG/mm²

① IS:4454 Pt.1, 2001 GRADE 'DH'

~~ALT. MATERIAL : IS: 4454/1975 SEC. II, Gr. 3~~

PROTECTIVE FINISH : ZINC PLATED TO SPECN. IS: 1573 GRADE A TYPE 2 (HYDROGEN EMBRITTLEMENT SHALL BE REMOVED BY BAKING AT 190°C - 210°C FOR NOT LESS THAN 4 HOURS, BEFORE 16 HOURS AFTER PLATING.)

OR

CADMIUM PLATE TO SPECN. IS: 1572 GRADE A TYPE 2 (HYDROGEN EMBRITTLEMENT SHALL BE REMOVED BY BAKING AT 190°C - 210°C FOR NOT LESS THAN 4 HOURS, BEFORE 16 HOURS AFTER PLATING.)

OR

PHOSPHATE TO SPECN. IS:6, 6665 CLASS 1 OIL FINISH.

Certified correct copy of the design issued Dept/Source at this date..... to Controller Quality Assurance (SA) Property of CQA (SA) Ichalkaranji and is issued to be destroyed on completion of this Job/JED.

ICR 1508

DS CAT No. 5360-007080

① MATL. AMENDED AS PER Lr.No.CQA(SA) 3/R/S/QA Dt.13.10.15 DA.No. 003/16 Dt.23.02.16

AUTH	DATE	ZONE	BRIEF RECO
22545/SA	13-12-76		material amended ALT material deleted
22706/SA	12-2-79		SPECIFN AMENDED
22543/SA	6-7-79		NEGATIVE RETRACED DRAWING PREPARED
			PREVIOUS D.C.No. 14781 SA / 14801-SA, 14679-SA, 14819-SA

	DATE	NAME
DSN.		
DRN.		
CHD.		
TRD	8-6-93	
COMP.		

ASSY. PRG. — MATERIAL :- AS ABOVE — DIMENSIONS ARE IN MILLIMETRES.

DT. 31/12/0.0. SCALE :- 1:1 SEALED :- D-C-No. 14789-SA. DT. 10.9.76.

SPRING PLATFORM. S.A.

CQA(SA) ICHALKARANJI — APPROVED 01-12-6.81 — NEG. RETRACED — DESIGNER'S REF. CISA/10 — D.S. CAT. NO. 1005-007745