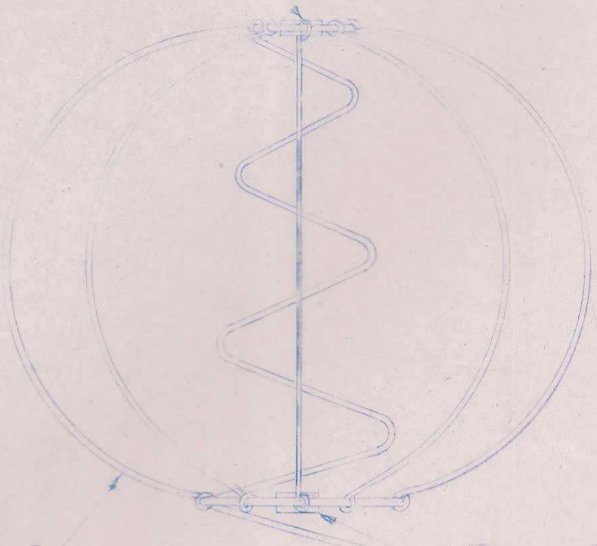
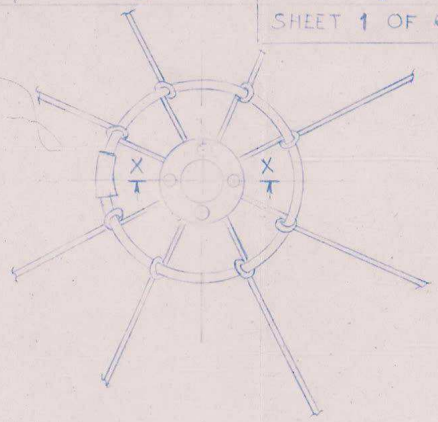
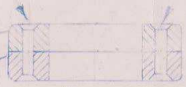



X
X

RIVETS CSK HD.
TO BE RIVETED PERFECTLY

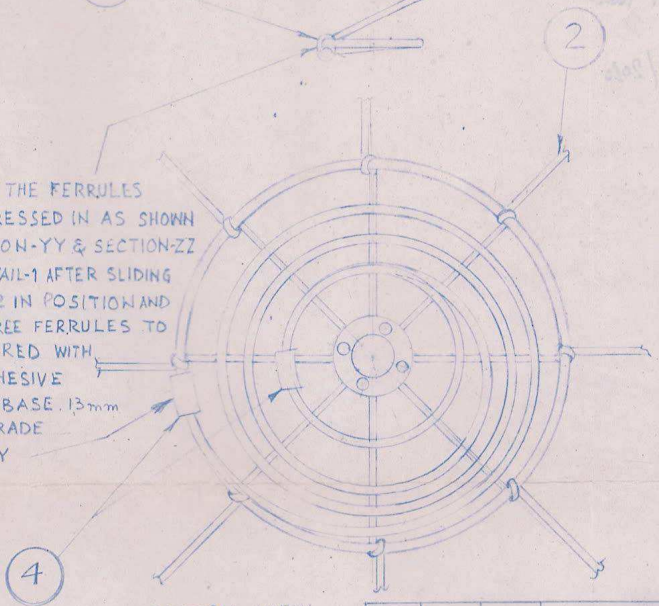

5

SECTION-XX
SCALE:- 1:1

TOP VIEW

COMPRESSION TEST:- THE SPRING SHALL BE COMPRESSED FULLY. UNDER A LOAD OF NOT LESS THAN 7.5 kgf & NOT MORE THAN 8.5 kgf. THE SPRING SHALL BE SUBJECTED TO CRAMP TEST i.e. HOLDING THE SPRING COMPRESSED TO THE MIN. WORKING COMPRESSED HEIGHT FOR A PERIOD NOT LESS THAN 6 HRS, FIVE (5) MINUTES AFTER RELEASE OF THE LOAD, THE SPRING SHALL BE CHECKED FOR PERMANENT SET.

ENDS OF THE FERRULES TO BE PRESSED IN AS SHOWN IN SECTION-YY & SECTION-ZZ (SEE DETAIL-1 AFTER SLIDING DETAIL-2 IN POSITION AND THEN THREE FERRULES TO BE COVERED WITH TAPE ADHESIVE CLOTH BASE 13mm BEST TRADE QUALITY



BOTTOM VIEW
SCALE :- 1:2

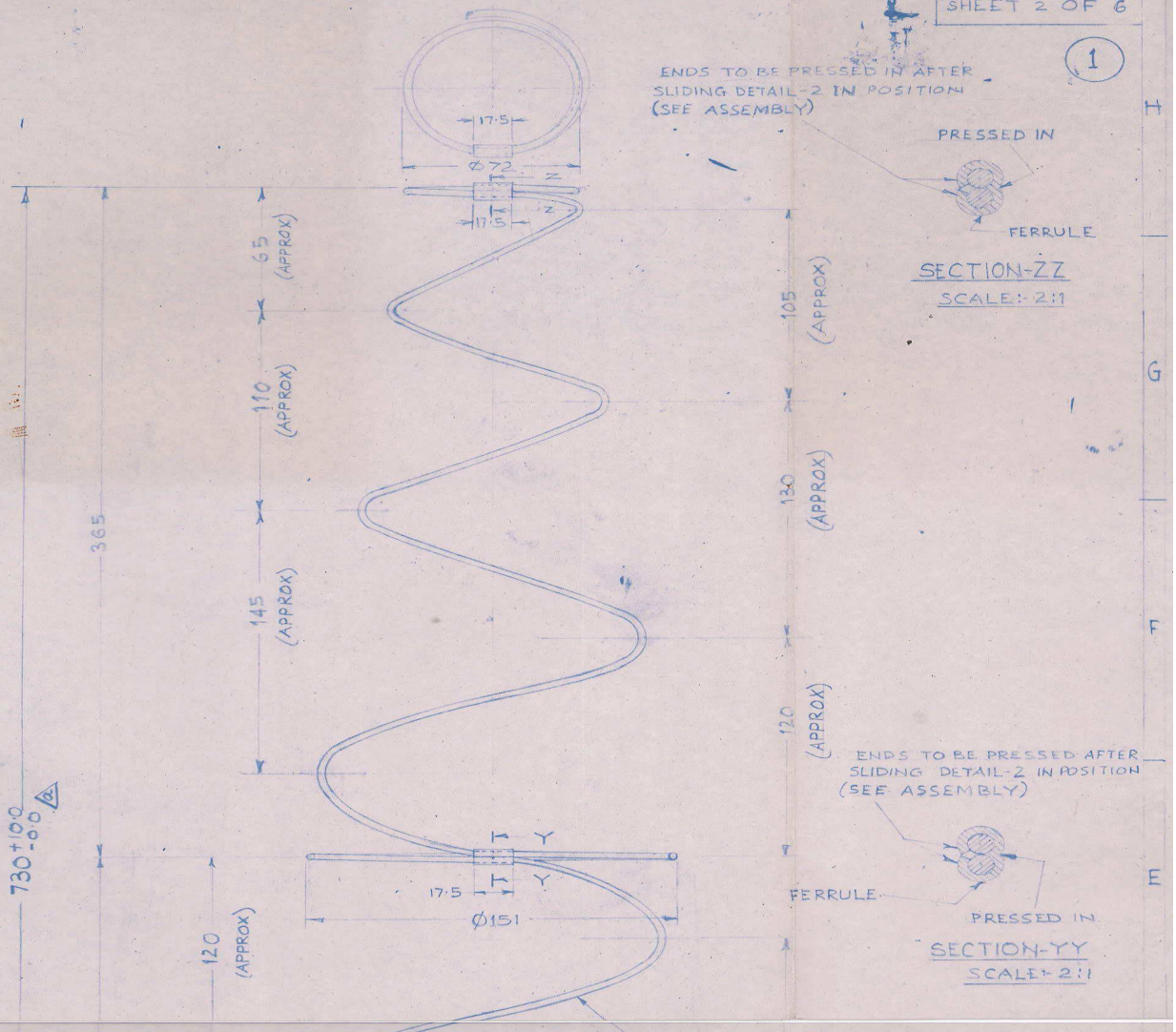
DETAIL No.	SHEET No.	NOMENCLATURE	No. OFF
5	6	RIVET (FLAT COUNTERSUNK HEAD 90°)	8
4	5	FERRULE	3
3	4	CIRCULAR RING	4
2	3	SPOKE	8
1	2	MAIN SPRING	1
-	1	ASSEMBLY, COMPRESSION TEST	-

DETAIL INDEX

R.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		O½c	PGD
DRN			DRD	MATERIAL :-		ADRDE, AGRA	
CHD				FINISH :-			
TRD							
COMP			O½c 11-3-99 PGD 23/3				
SCALE :- 1:4, 1:2 & 1:1			PROJ. OFFR.	HEAT TREATMENT :-		APPROVED. FOR DIRECTOR	
			DIV. HEAD				
DIMENSIONS ARE IN mm			ASSEMBLY			DRG. No. (a)	
TOLERANCE :- IS:2102 (PT-I) FINE			BALL TYPE SPRING (PSM SERIES)			ADRDE/1332-G	

DRD/71/98

(1)



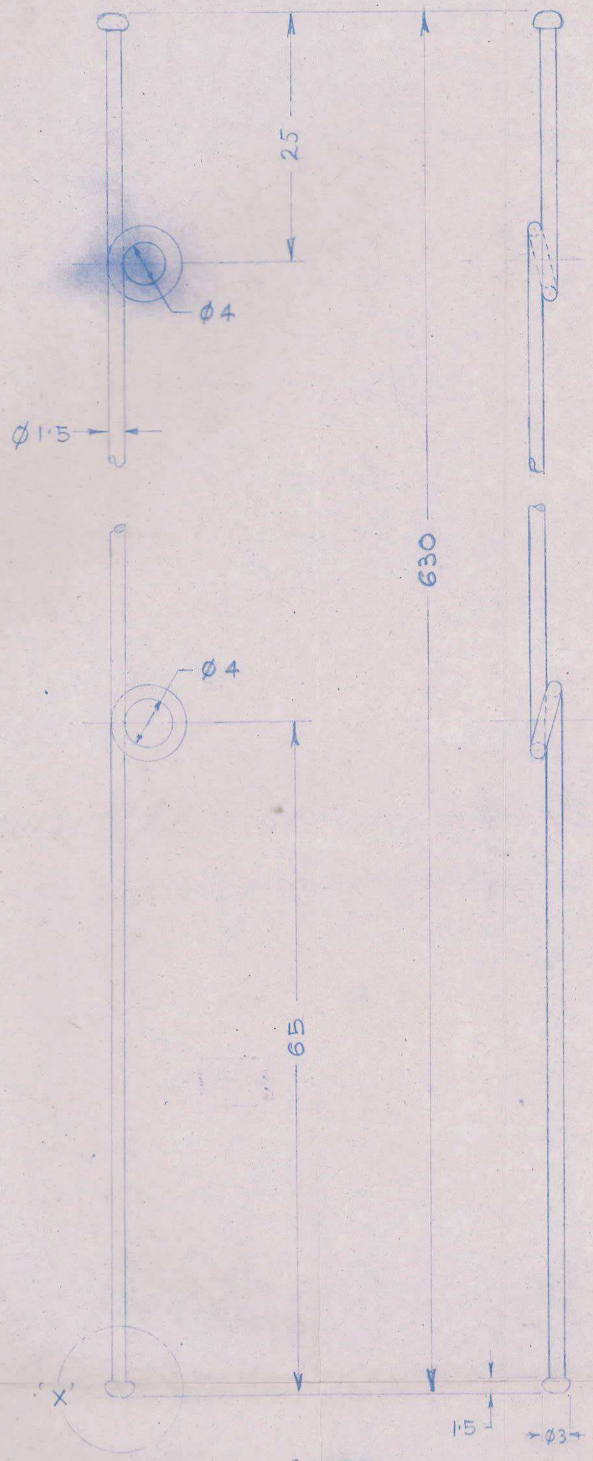
MATERIAL :- HIGH CORBON STEEL WIRE TO GRADE-2 IN COLD DRAWN CONDITION AS PER IS:4454 (PART-I) 1975.

FINISH :- TO BE SMOOTHLY FINISHED AND cd. PLATED TO SPECN. NO. IS : 1572 - 1986 Fe/Cd 12 CA.

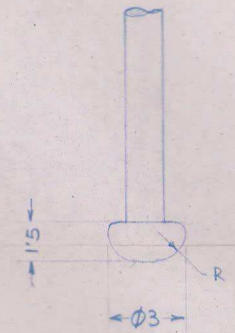
a	6/8/02	E-5	PAS/240/7	DIMENSIONS 730 +10.0 -0.0 INCLUDED			
R.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD		O/C D&S	HEAD QA

DRN		DRD	MATERIAL AS ABOVE	ADRDE, AGRA
CHD				
TRD		17-3-99	FINISH AS ABOVE	
COMP		O/C	PGD	APPROVED
SCALE :- 1:2 & 2:1		PROJ. OFFR	HEAT TREATMENT	FOR : DIRECTOR
DIMENSIONS IN MILLIMETRES		DIV. HEAD.		DRG. No. ADRDE/1332-01 (a)
TOLERANCE :- IS:2102 (PT-1) MEDIUM		MAIN SPRING BALL TYPE SPRING (PSM SERIES)		DRD/71/92

(2)



8-OFF



DETAIL AT X
SCALE:- 5:1

MATERIAL :- SPRING STEEL WIRE TO GRADE I AS PER IS:4454 (Pt-I)-1975.

FINISH :- TO BE SMOOTHLY FINISHED AND Cd. PLATED TO SPECN. No. IS:1572-1986, Fe/Cd 12 CA.

R No	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/C	PGD
DRN			DRD	MATERIAL :- AS ABOVE		
CHD				FINISH :- AS ABOVE		
TRD			O/C PGD			
COMP						
SCALE :- 2:1 & 5:1			PROJ. OFFR.	HEAT TREATMENT :-		
			DIV. OFFR.			

ADRDE, AGRA

APPROVED

FOR DIRECTOR

DIMENSIONS IN MILLIMETRES

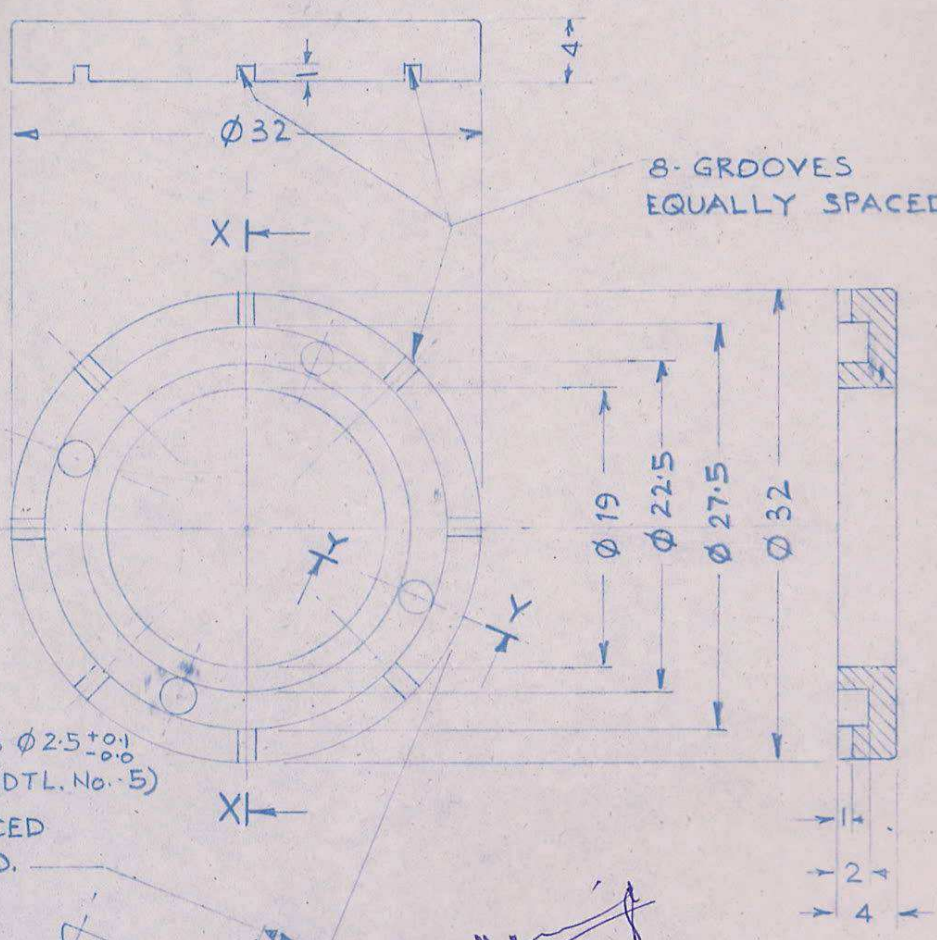
TOLERANCE IS: 2102 (Pt I) MEDIUM

SPOKE BALL TYPE SPRING (PSM SERIES)

DRG No (a) ADRDE/1332-02

DRD/71/98

(3)



MATERIAL :- STEEL BAR TO GRADE C-20 AS PER IS:2073-1962 IN ANNEALED CONDITION.

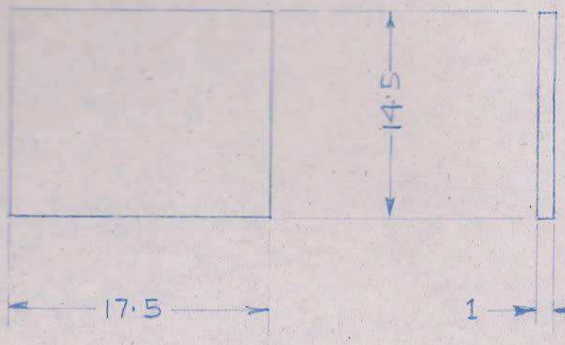
FINISH :- TO BE SMOOTHLY FINISHED & Cd PLATED TO SPECN. No. IS:1572-1986, Fe/Cd 12 CA.

RNo	DATE	ZONE	AUTHORITY	BRIEF RECORD	O½C	PGD

DRN	DRD	MATERIAL :- AS ABOVE	ADRDE, AGRA
CHD	11-3-99 O½C	23/3 PGD	
TRD		FINISH :- AS ABOVE	
COMP			
SCALE :- 2:1	PROJ. OFFR	HEAT TREATMENT	APPROVED FOR DIRECTOR
DIMENSIONS IN MILLIMETRES	DIV. HEAD		
TOLERANCE IS:2102 (Pt-I), MEDIUM	CIRCULAR RING BALL TYPE SPRING (PSM SERIES)		DRG. No. (a) ADRDE/1332-03

DRD/71/98

(4)



3-OFF

FINISH :- TO BE SMOOTHLY FINSHED AND Cd. PLATED TO SPECN. No. IS: 1572 - 1986, Fe/Cd 12 CA.

R.No	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/C	PGD

DRN		DRD	MATERIAL :- M.S. SHEET-
CHD			
TRD			FINISH AS ABOVE
COMP		O/C PGD	
SCALE :- 2:1		PROJ. OFFR	HEAT TREATMENT
		DIV. HEAD.	
DIMENSIONS IN MILLIMETRES		FERRULE BALL TYPE SPRING (PSM SERIES)	
TOLERANCE :- IS:2102 (PT-I) MEDIUM			

ADRDE, AGRA

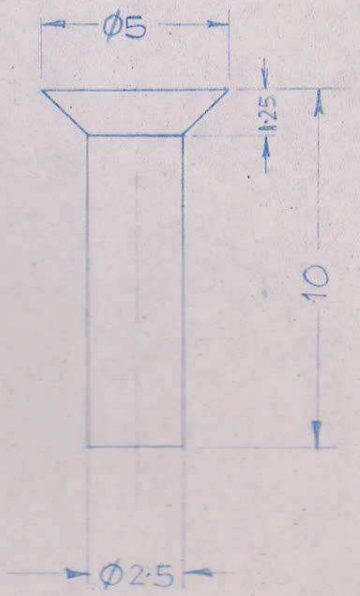
APPROVED

FOR DIRECTOR

DRG. No. (a) ADRDE/1332-04

DRD/71/98

5



8-OFF

MATERIAL :- M.S. WIRE ROD AS PER IS: 280-1972 IN SOFT CONDITION

FINISH :- TO BE SMOOTHLY FINISHED

RN No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/C	PGD

DRN	DRD	MATERIAL AS ABOVE	ADRDE, AGRA
CHD		FINISH AS ABOVE	
TRD			
COMP	O/C PGD		
SCALE :- 5:1	PROJ. OFFR.	HEAT TREATMENT	APPROVED
	DIV. HEAD		FOR DIRECTOR
DIMENSIONS IN MILLIMETRES	RIVET (FLAT COUNTER SUNK HEAD 90°)		DRG. NO. (a) ADRDE/1332-05
TOLERANCE :- IS: 2102 (PT-1) MEDIUM	BALL TYPE SPRING (PSM SERIES)		

DRD/71/98