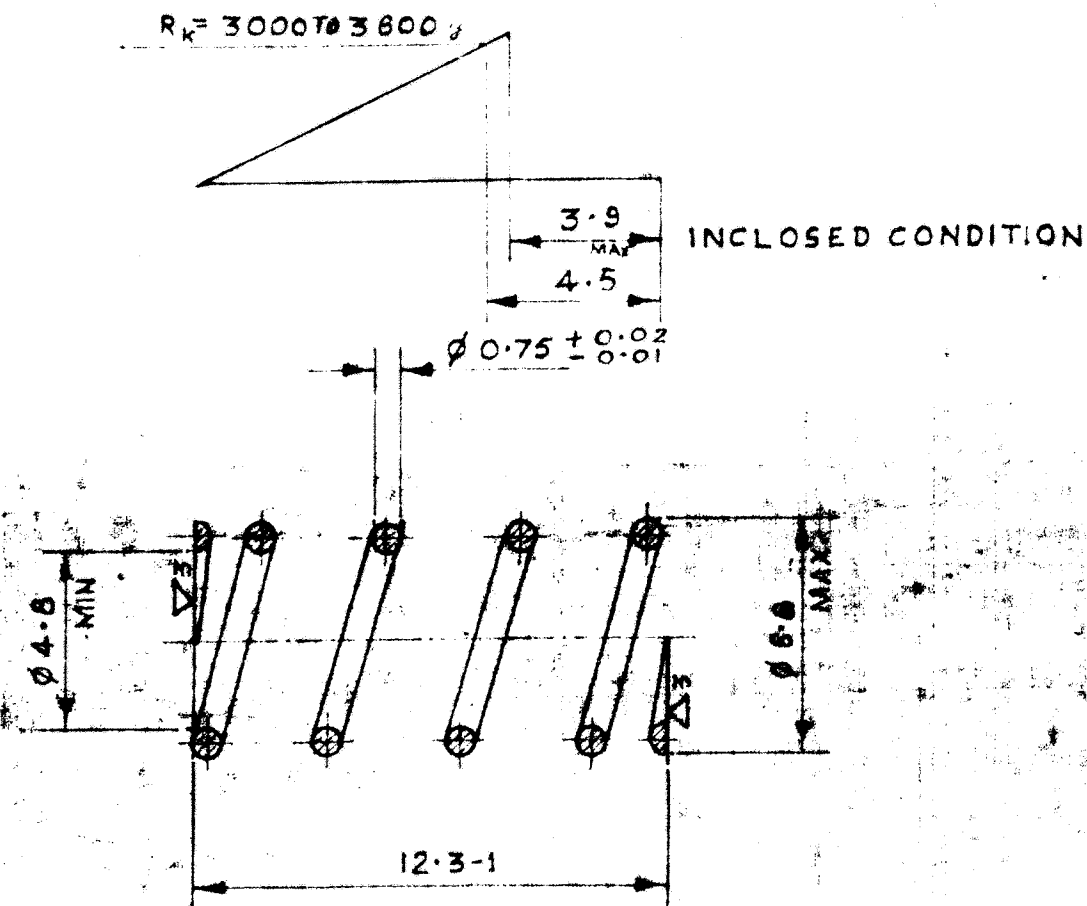


02



616910-2

D.C.I. 28794-A



- 1 UNCOILED LENGTH OF WIRE. L = 71
- 2 WINDING OF COIL LH OR RH
- 3 NO OF COILS. n = 4.5 ± 0.5
- 4 SPRING WHEN KEPT ON A HORIZONTAL PLANE MUST STAND VERTICALLY. DEVIATION FROM VERTICAL MUST NOT BE MORE THAN 5°
- 5 ELECTRICAL DEGREASING OR PICKLING IS NOT PERMITTED.
- 6 AFTER TINNING OR OXYDISING THE SPRING MUST NOT BE DAMAGED WHEN STRETCHED TO 1/2 TIMES THE HEIGHT. CHECK SELECTIVELY.
- 7 EXTERNAL DIA TO BE CHECKED WITH CYLINDER Ø 6.798 ± 0.005, INTERNAL DIA TO BE CHECKED WITH PLUNGER Ø 4.82 ± 0.02 (ON A STRETCHED CONDITION). LENGTH OF CYLINDER 8 mm.
- 8 MATERIAL PERMITTED: STEEL WIRE FOR SPRINGS OF TYPE 'H TR' AND OB TTY 2622 FAY.
- 9 ALL DIMENSIONS OF DETAIL BESIDES MATERIAL ARE AFTER PLATING.
- 10 END COILS MUST BE CLOSED.
- 11 SURFACES NOT HAVING MACHINING SYMBOL SHOULD HAVE A FINISH CORRESPONDING TO THE MECHANICAL CONDITIONS OF THE MATERIAL
- 12 LOW TEMPERATURE TEMPERING IS PERMITTED. TEMPERATURE REGEIME TO BE DETERMINED BY THE PLANT
- 13 OXIDATION, CHROMATING AND DIPPING IN MACHINE OIL GOST 1805-51.
- 14 AFTER TINNING OR OXIDATION THE SPRING IS KEPT FOR 3 DAYS COMPRESSED TO A HEIGHT OF 3.9 mm. THE HEIGHT IS CHECKED EVERY HOUR. AFTER THIS KEEPING, THE SPRING MUST RETAIN RESISTANCE AND DIMENSIONS WITHIN DRAWING LIMITS.
- 15 LAQUERED WITH SHELLAC LAC. LAQUER 3-5 % TY FA- 4391-54. IN INDIA TO BE COATED WITH APC NO 222 TO SPECIFICATION NO JSS 1-63-11

ZINC PLATING & CHROMATE PASSIVATION TO BE LACQUERED WITH SHELLAC LAC.

MATERIAL:- STEEL WIRE TO SPECN. BS: 5216-1991-M GRADE 4 OR 5

			6-7-11	DC. 37284-A	MATERIAL AMENDED					
			5-8-97	D.C. 36253-A	Rk = 3000 TO 3600g WAS Rk = 3000 ± 3600					
			11-2-88	D.S.I. 34523-A	D.S.CAT. NO ADDED.					
4			21-4-85	D.C.I. 33740-A	NOTE NO 15 IN INDIA ----- JSS 1-63-V AMENDED					
2			23-4-83	D.C.I. 33430-A	MAT. AMENDED					
			22-2-82		TRACED WITHOUT CHANGE					
					PREVIOUS D.C.P (D.N. 28794-A, 29221-A, 29486-A)					
				DATE	AUTHORITY	REVISION				
							AMSP D.D. 618N			
MATL:- STEEL WIRE TO SPECN. NO BS 5216-1975-M GRADE 4 OR 5										
								3-016919	53-B-025Y	
								SPRING FOR PART NO. 29.	30	
									LETTER	MASS
									6	0.28
								SPRING WIRE 0.75 MM TY 2622 FAY.	D.S.CAT NO	
									1390-000343	