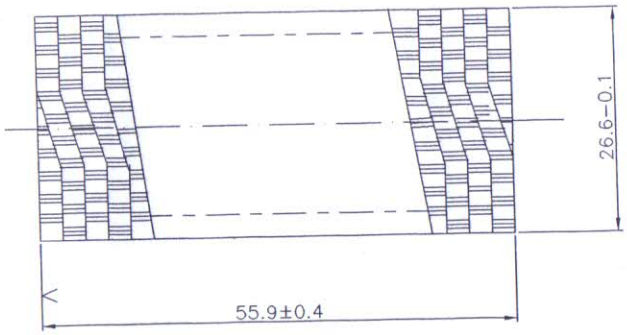
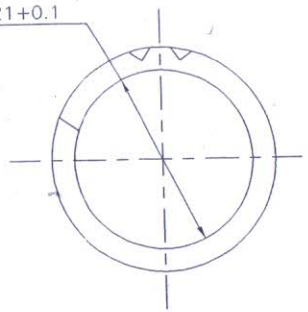
9

GEN. TOL. ~~FINE~~/MEDIUM/~~COARSE~~ CLASS TO IS:2102	DRG. CONVENTIONS CONFIRM TO INDIAN STD. DIMN. IN mm UNLESS OTHERWISE STATED

DRG. No. 9 1 0 2 (IC) 0 0 (SS) 0 1 (S) 0 0 (AA) 0 1 (A) 0 0 2 (C) 0 0 1 B (SST)





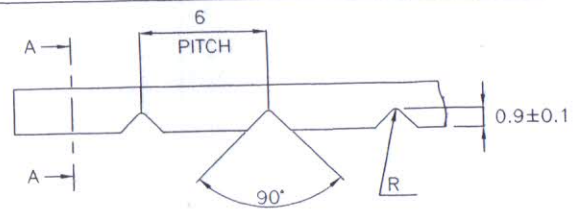
NOTES:−

1. WIRE CROSS SECTION SHOULD BE AS INDICATED
2. GRINDING AFTER COILING IS ALLOWED TO MAINTAIN THE FINAL DIMENSIONS.
3. BOTH THE FREE ENDS TO BE CLOSED IN UNDER PRESSURE SQUARED TO THE AXIS
4. I/D OF THE COIL SHOULD BE FREE FROM ANY BURR, SHARP CORNER ETC.
5. LENGTH 55.9 ± 0.4 IS A SOLID LENGTH
6. AFTER COILING OF WIRE NOTCHING IS PERMITTED BY MILLING PROCESS.
7. MAXIMUM WIDTH OF WIRE UPTO 2.82 IS PERMITTED.
8. COMPONENT AFTER PHOSPHATING TO BE SEALED WITH RUST PREVENTIVE OIL.
9. DIMENSIONS APPLY AFTER PHOSPHATING.

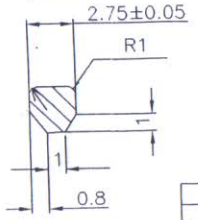
HARDNESS :− 425 ± 50 VPN AT 5 Kg.

SURFACE FINISH:− 6.4 ALL OVER

PRE NOTCHING OF WIRE FOLLOWED BY COILING

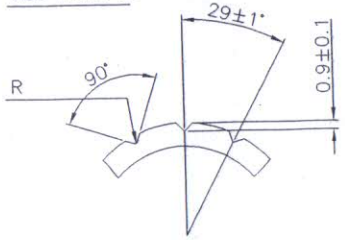


A − A
(NTS)



COILING FOLLOWED BY NOTCHING(MILLING PROCESS)

SEE NOTE 6.



Sr. No.	DATE	AUTHORITY	BRIEF RECORD	ZONE	CD	GO
					SIGN	
DRN. SNK		CHD.	MATERIAL STEEL TO IS:5517−1978 DESIG. 40C−8			
APPD. DATE		For Director	PROTECTIVE FINISH PHOSPHATED TO IS3618 CLASS 'B'			
SEALED DATE						
SCALE 1:2		EST. MASS 69±2g	TITLE NOTCHED CLOSE COIL			
DESIGN AUTHORITY ARDE PUNE 411021						
DRG. No. 9 1 0 2 (IC) 0 0 (SS) 0 1 (S) 0 0 (AA) 0 1 (A) 0 0 2 (C) 0 0 1 B (SST)						
PART No.		DS CAT. No.		AHSP		