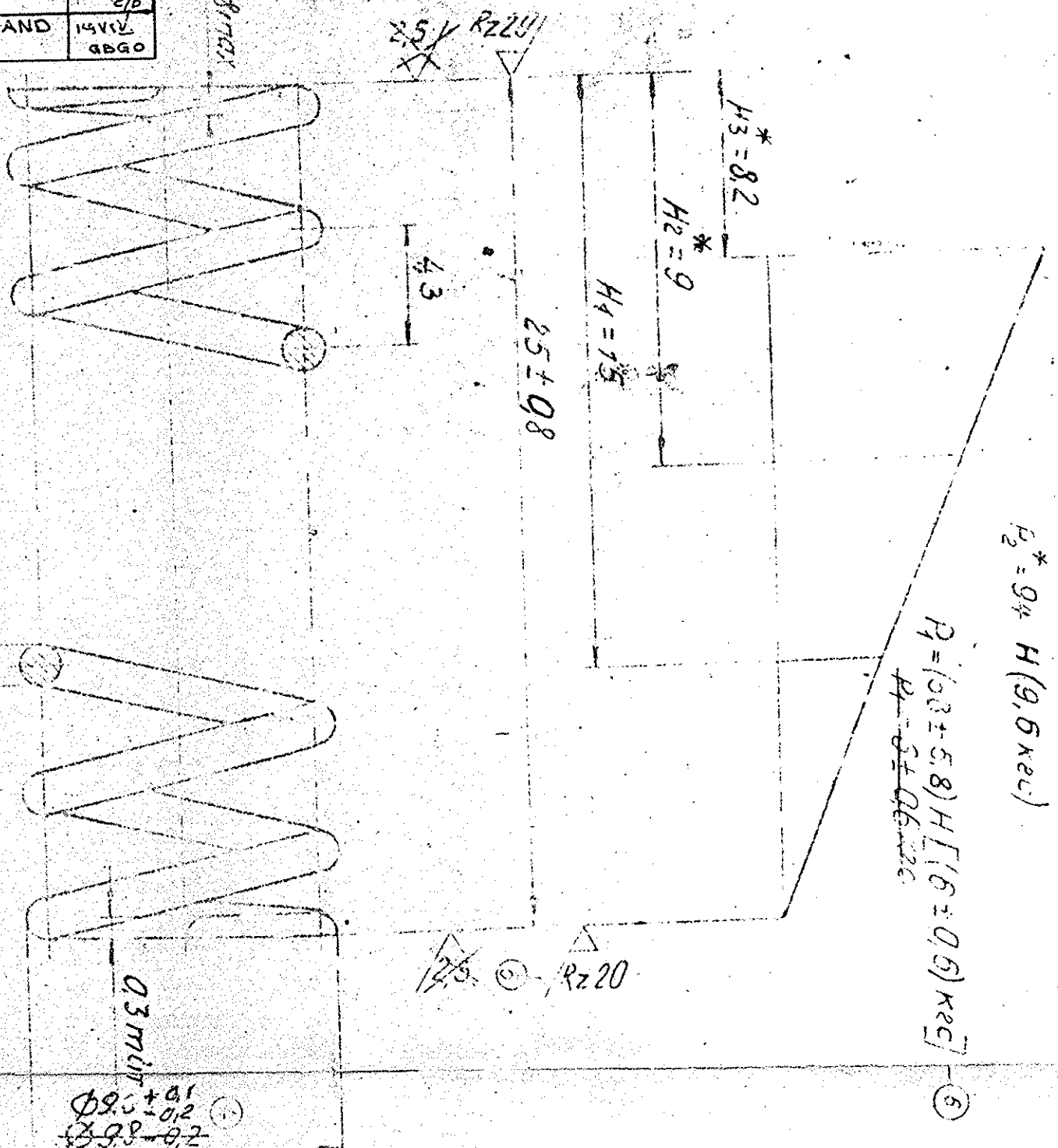


18193-W NOTE No.12 AMENDED 15/11/95
 30-11-95
 18283-W NOTE No.4, AMENDED 19-8-96
 19-8-96

$P_3 = 100H (10.2 \text{ kcal})$

$P_2^* = 94 H (9.6 \text{ kcal})$

$P_1 = (33 \pm 5.8) H [(6 \pm 0.6) \text{ kcal}]$



17755-W 14-10-93	P2* - 94 H (9.6 K2 C) WAS P2* - 940 H (9.6 K2 C)	149VW c/p
18174-W 22-9-95	PROV SEALING CANCELLED AND DRG SEALED.	149VW GBGO

17430-W 23-12-92	INDIGS MATL ADDED.
16975-W 14-11-90	NOTE No. 4 - AMENDED.
16699-W 22-10-88	IN NOTE No. 4, L = 216.5 mm WAS L = 616.5 mm
16407-W 20-2-86	DRG SEALED PROV.

* (2) LONGROCKET'S UNHOLDENGE
 10/2/2001

19022-W 16-01-2007	NOMENCLATURE AMENDED & DS. CAT. NO. ADDED.	199VW c/p
18845-W 13-1-04	HINDI NOMEN ADDED	199VW c/p
18631-W 24-5-2001	INDIGS MATL AMENDED	199VW c/p

APPROVED: 2A42-01, 044

CONTROL SHEET OF QA(W) JABALPUR

SPRING HELICAL COMPRESSION

DS. CAT. NO. 5360-040684

- $G^{\#} = 80000 \text{ MPa (8000 kgf/mm}^2\text{)}$.
 - $\tau^{\#} = 1560 \text{ MPa (156 kgf/mm}^2\text{)}$
 - Direction of coiling - clockwise.
 - $L = 216.5 \text{ mm}$ 250 mm.
 - $n = 5.5$.
 - $n_1 = 7-0.25$.
 - Tempering 24) to 260 °C.
 - $D_h = 10.2 \text{ mm}$.
 - $D_r = 7 \text{ mm}$. Stiff entering of the rod is permissible.
 - The sizes and parameters are given for reference.
 - The time of holding the spring in a state compressed to a solid length is 24 h.
 - Coating: accelerated electroless phosphating with cirro-mabe treatment/impregnation with active P-2-4. (OUT 1217-74-01) Code I to ISS: 0465-01-1994 with coating of Durloph adhesive B 758 one layer.
 3. Samp K, M on the 1st set.
 - Other technical requirements are according to INDIGS 16118-70 for springs of accuracy Group II.
 - Outer diameter of end coils may be diminished to 9.4 mm
- INDIGS MATL:- IS: 4454 Pt 1-81, GRADE-3
 OR
 BS: 5216. GRADE-4 CODE-M
- Ref: QA(W) Dr. No. 1B218-CAAW Dt. 21 sep. 2007
 Authority: DQA-19 NO. CAAW/NV/01/2007 Dt. 06 JAN. 2007.
- C1044
- 73/D 21-03-02