



1. Tolerance for force dimension shall be as per IS 102 A7
2. Carry-out heat treatment for 2-3 hours and should be 10 to 30.
3. Blow between the two eyes may be checked by using a scriber.
4. Distortion of eye may be 1-2% (See table 1 and 2).
5. Dimensions marked as φ are given for the construction of eye.
6. Permissible displacement of eye with respect to the spring axis should not exceed 0.2 mm.
7. Permissible displacement of eyes with respect to the spring axis should not exceed 0.4 mm.
8. Undercutting and mechanical damage are not allowed at eye bands over 3 mm.
9. Force by load of 3.5 Kg for 24 hours.
10. Spring length may be increased by 2.6 mm after forcing by load.
11. Spring dimensions are given without considering the coating.
12. To obtain the given strength characteristic the external spring diameter A may be increased upto 0.2 mm for the values specified in tables.
13. Carry-out heat treatment after cadmium coating for two hours and at 180° to 200°C.
14. Springs should be made from the wire having the depth of surface decarburization not exceeding 0.01 mm (for each side).

TABLE NO-1

Wire Dia.	Spring Dia. A
0.99	7.67-0.1
1	8.0 -0.1
1.01	8.67-0.1
1.02	8.17-0.1
1.03	8.29-0.1

TABLE NO-2

Wire Dia.	Spring Dia. A

WIRE 5xφA
TYAEX 265-76

Spring designation	Developed strength of spring when it is stretched upto the dimension 34 mN/Kgf.	Coating	Dependence of spring diameter A on wire diameter (Considering tolerance).	Remarks
443-353H-1	1.85 — 2.1	Chemical oxidation. Coat with varnish KP-965 FOCT 15030-70	Table no:1	

PROT SAMPLE SHOULD BE APPROVED BY AHS P BEFORE BULK PRODUCTION

EST. MASS 0.002 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THIS BY LETTERS
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED ROUNDED CORNERS TO HAVE R QUANTITY	
ISSUE DATE	NATURE OF AMENDMENTS
DRAWN	SCALE: 1:1
CHKD	DIMENSIONS IN mm
TCD	TOLERANCE ON DIMS UNLESS OTHERWISE STATED
APPROVED	ALL THREADS CONFORM TO
DATE 9-9-87	
MATERIAL: * SEE ABOVE	
USED ON: 550 044H	
CONTROLLENATE OF INSPET (HEAVY VEHICLES) AVADI	
TITLE: SPRING	
DRAWING NUMBER: 443-353H	

69

56

