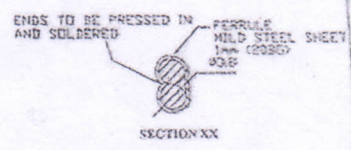


SHEET 1 OF 1

NOTE - ALL THE SHARP EDGES TO BE ROUNDED OFF.  
 MATERIAL - SPRING STEEL WIRE AS PER I.S. 4454 PART-11, 2001 GRADE VDSIC FERRULE MILD STEEL SHEET 0.2mm THICK.  
 WORKMANSHIP - BOTH JOINT OF FERRULE TO BE PROPERLY JOINT AND FINISHED.  
 FINISH - TO BE FINISHED SMOOTH CADMIUM PLATED TO AN AVERAGE THICKNESS OF 0.013mm AND CHROMATE PASSIVATED AS PER SPECN. ISIS72-1968.  
 EMBRITTLEMENT RELEASE - SPRING AFTER CADMIUM PLATING AND PRIOR TO CHROMATE PASSIVATION SHALL BE MAINTAINED AT A TEMP. OF 150°C-200°C FOR HALF AN HOUR TO REMOVE HYDROGEN EMBRITTLEMENT.  
 COMPRESSION TEST - THE SPRING SHALL BE FULLY COMPRESSED UNDER A LOAD NOT LESS THAN 18kg AND NOT MORE THAN 22kg AFTER BEING MAINTAINED IN ABOVE COMPRESSED POSITION UNDER SUCH LOAD FOR A PERIOD OF 1 MINUTES SPRING WILL SHOW PERMANENT SET NOT MORE THAN 4mm IN COMPLETE REMOVAL OF LOAD AND THE JOINT SHALL REMAIN UNDAUNAGED THIS TEST MAY BE CARRIED OUT ON EACH SPRING.  
 PACKING - EACH HELICAL SPRING SHALL BE PLACED IN A POLYTHENE BAG OF SUITABLE SIZE THE POLYTHENE BAG SHALL THAN BE PLACED IN AN UNLINED WITH PAPER PACKING WATER PROOF. ONE SPRING IN EACH POLYTHEN BAG SHALL BE IDENTIFIED BY A LABEL SHOWING CAT. No., DESIGNATION OF THE STORE AND RECOGNIZED INITIAL OF THE MANUFACTURER AND YEAR OF MANUFACTURE.  
 THE PACKING CASE SHALL BE INDELIBLY MARKED WITH THE ADDRESS OF THE CONSIGNEE, CONSIGNOR CAT. No. DESIGNATION YEAR OF MANUFACTURE AND QUALITY AND NUMBER OF INDIVIDUAL PACKS.  
 TOLERANCE - ±0.2mm.



QUALIFIED CHECKER  
 M. L. S.  
 10/10/2018

SCALE - N.T.S		ADBE AGRA	DRH	C.P.PAL	APPROVED  PROJ OFFR / GROUP OFFR
DIMENSIONS IN mm		GROUP - CP	CHD	NIRDTI	
TEL - ANSALALWS-017 2000		MATERIAL - AS ABOVE			APPROVED  PROJ OFFR / GROUP OFFR
FINISH -		COIL SPRING AUXILIARY PARACHUTE BRAKE PARACHUTE FOR HAWK (AJT) AIRCRAFT			
HEAT TREATMENT -		D 1 / C HEAD CAD (CIRCLE)			DRG No. 1.3.03-01-01(a)(b)
Rev.No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	
1		2		3	4