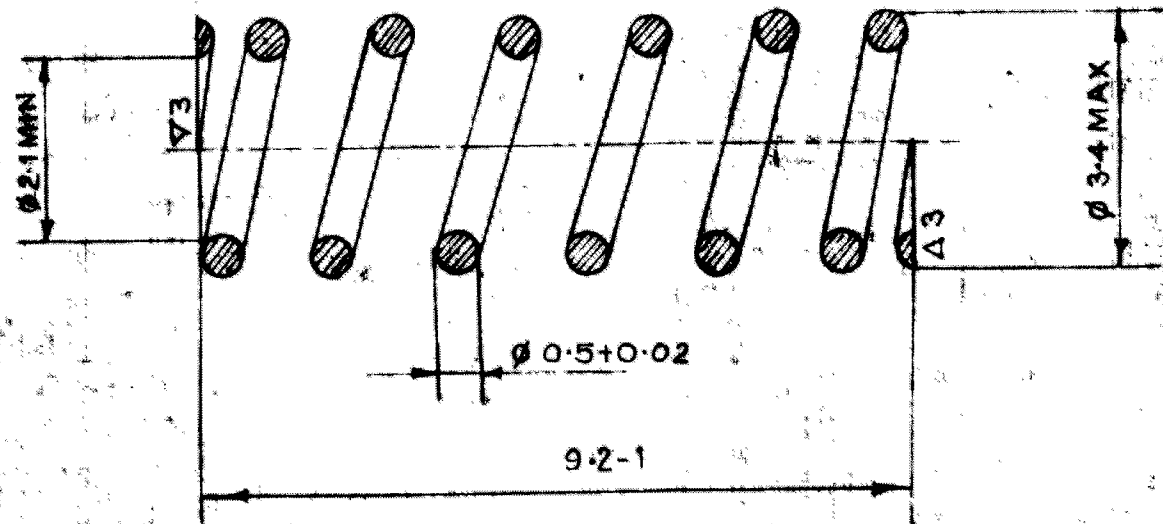
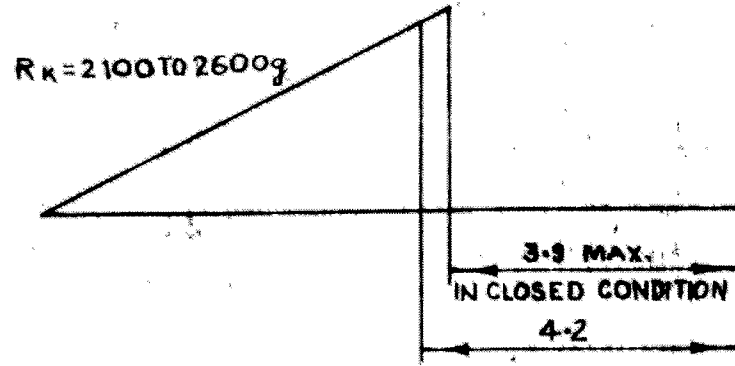


31



616910-2

D.C.I. 28794-A



1. UNCOILED LENGTH OF WIRE L = 66 mm
2. WINDING MAY BE R.H. OR L.H.
3. No. OF COILS  $n = 7 \pm 0.25$
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  $1\frac{1}{2}$  TIMES THE HEIGHT. CHECK SELECTIVELY.
7. EXTERNAL DIA. TO BE CHECKED WITH CYLINDER  $\phi 3.398 \pm 0.003$ . INTERNAL DIA. TO BE CHECKED WITH PLUNGER  $\phi 2.12 - 0.02$  (ON A STRETCHED CONDITION). LENGTH OF CYLINDER 6 mm.
8. AFTER TINNING OR OXIDATION THE SPRING IS KEPT FOR 5 DAYS COMPRESSED TO A HEIGHT OF 4.25 mm. THE HEIGHT IS CHECKED EVERY HOUR. AFTER THIS KEEPING, THE SPRING MUST RETAIN RESISTANCE AND DIMENSIONS WITHIN DRAWING LIMITS.
9. THE OUTER  $\phi$  OF THE DETAIL MAY BE CHECKED FULLY COMPRESSED CONDITION. IN THIS CASE THE  $\phi$  OF CONTROLLING CYLINDER MUST BE OF 3.45 MAX. IN THIS THE AXIS OF THE DETAIL IS NOT CHECKED FOR PERPENDICULARITY
10. MATERIAL PERMITTED : STEEL WIRE FOR SPRINGS OF TYPE 'HT' AND OB-TY 2622 FAY.
11. ALL DIMENSIONS OF DETAIL BESIDES MATERIAL ARE AFTER PLATING.
12. END COILS MUST BE CLOSED.
13. SURFACES NOT HAVING MACHINING SYMBOL SHOULD HAVE A FINISH CORRESPONDING TO THE MECHANICAL CONDITIONS OF THE MATERIAL.
14. LOW TEMPERATURE TEMPERING IS PERMITTED. TEMPERATURE REQUIRE TO BE DETERMINED BY THE PLANT.
15. OXIDATION, CHROMATING AND DIPPING IN MACHINE OIL, GOST 1805-51.
16. LACQUERED WITH SHELLAC LAC LACQUER - 3-5% ТУ ГЛВ 4391-54  
IN INDIA TO BE COATED WITH APC NO 222 TO SPECIFICATION NO JSS 1-63-11

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

**PROTECTIVE TREATMENT:** TO BE ELECTROPLATED WITH TIN TO SPECIFICATION NO DTD 924.

DATE	AUTHORITY	REVISION	AS PLO	BY	DATE	REVISION	AS PLO	BY	DATE	REVISION
6.7.11	DC.37284-A	MATERIAL AMENDED								
6.3.97	D.C. 56253-A	PROTECTIVE TREATMENT ADDED								
11-2-88	D.C. 134325-A	D.S. CAT NO ADDED.								
21-4-85	D.C.I. 33746-A	PROTECTIVE TREATMENT ADDED IN INDIA								
23-4-81	D.C.I. 33430-A	MATERIAL AMENDED								
4-2-82		TEMPERATURE CHANGE								
		PREVIOUS D.C.I. NO. 28794-A								
		28794-A-SEA ADD 31012-A								

D.S. CAT NO		1590-0003A2	
3-016919		53-8-025V	
SPRING FOR		31	
PART NO. 28		LETTER	
SPRING WIRE $\phi 0.5$		6	
"HT" TY 2622 FAY		0-12	
		10.1	