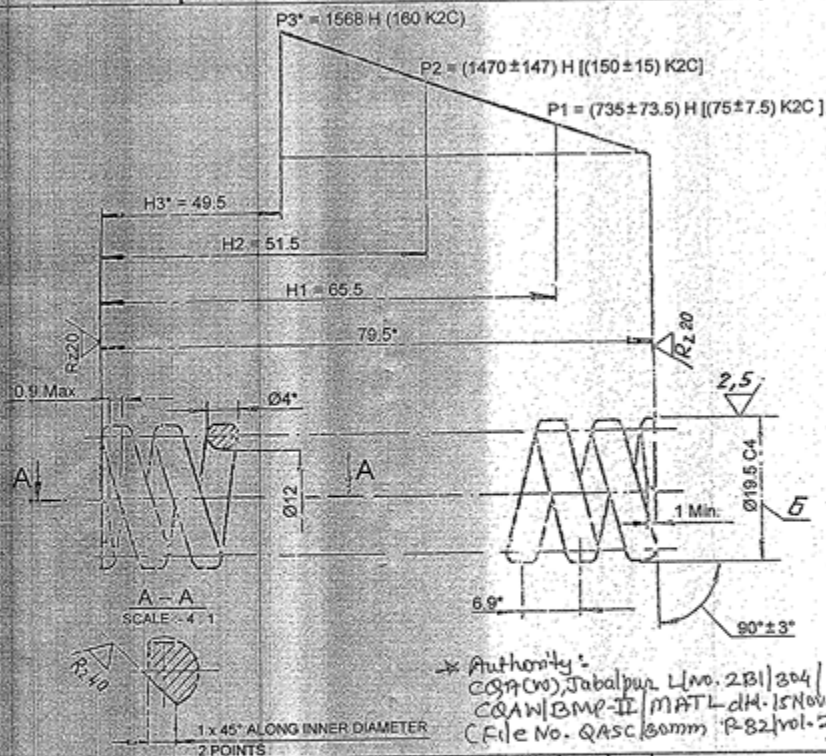


PART No./D.S. CAT. No.  
5360-007793



- $G^N = 80000 \text{ MPa}$  ( $8000 \text{ kgf/mm}^2$ ).
- $\tau_3^N = 1500 \text{ MPa}$  ( $150 \text{ kgf/mm}^2$ ).
- Direction of coiling - clockwise.
- $L = 650 \text{ mm}$ .
- $n = 11$ .
- $n_1 = 12.5$ .
- HRC ref 49 to 53. Test for hardness using a blank sample.
- $D_h = 20 \text{ mm}$ .
- $D_r = 12 \text{ mm}$ . Stiff entering of the rod is permissible.
- \* Sites and parameters for reference.
- Time of holding the spring in a state compressed to a solid length is 24 h.
- Coating: accelerated electroless phosphating with chromate treatment coated with varnish 3I-96 RV 6-10-763-75 Colourless (2) OR APC 221 oil based stoving to grade I as JSS:8010-28
- Make size F and coat after winding up the spring to solid length.
- Other technical requirements are according to IS 16118-7C, for springs of accuracy group II.
- Stamp X, Y on the lot tag.
- After acceptance tests reduction of  $P_1$  to 617.4 N (63 kgf) is permissible. **C 1036**
- Check power parameters and geometrical sizes before coating with varnish 3I-96.
- After coating with varnish 3I-96 power characteristic  $P_1$  may range from 695.8 N to 886.9 N (from 71 kgf to 90.5 kgf) \* Gde 925A60

INDIGS MATL :-

BS : 970 Pt- 2 1988/Gde 926-A 60/AN/NEALED (WITH BHN 277 MAX.)  
DRAWN / TURNED / GROUND INCLUSION CONTENT AND GRAIN SIZE  
AS PER SPECN. SPRING SHALL BE HEAT TREATED TO HRC 49.5 - 53

\* Authority :-  
CQA(W), Jabalpur L/No. 2B1/304/  
CQA(W)/BMP-II MATL d/d. 15 Nov. 2011  
(File No. QASC/30mm R-82/vol. 29)

17.11.12	19293-W	Index Mail Amended			DRAWN:-	CHD:-	ASSY DRG:-	CQA(W), JABALPUR	
16.01.07	19022-W	D.S. CAT. No. ADDED & NOMEN. AMENDED.			SCANNED:- SKB	CHD:- OFS	DATE:-		
12.7.06		SCANNED & PRINTED WITHOUT CHANGE				AHSP	SCALE:- 2:1		
DATE	AUTHORITY	ZONE	AMENDMENTS	SIG. AHSP	SIG. DO	MATERIAL:- WIRE 65 C2 BA - T-XH - 4, IS 14963 - 78	ESTD mass:- 0.055		DESIGN No.
PREV DC Nos. - 15407-W, 16975-W, 17490-W, 18174-W, 18193-W, 18349-W, 18383-W & 18845-W DT:13-01-04				PROTECTIVE FINISH:-				PART No.	
DRG SEALED:- 18174-W DT:22-09-95				DO CQA(W)				2A42.01.036	
<b>SPRING स्पिंग</b>								DS CAT No.	
<b>HELICAL COMPRESSION हेलिकल कम्प्रेशन</b>								5360-007793	