

VENDOR QUALIFICATION CRITERIA (VQC) MAIN SPRING TO DRG NO. 432.23.058-1

Sl no.	Nomenclature & drawing No.	Manufacturing technology & Testing / Inspection Facilities required to produce the item		Must be possessed by the vendor in his premises (P&M list and testing / inspection equipment list to be submitted)	May be possessed by the vendor in his premises or out sourced (Self declaration to be submitted)	FIRM Compliance (Y/N)	Remarks
1	Main Spring to Drg no 432.23.058-1	TECHNOLOGY-1	Raw material		Firm should be capable to arrange the raw material defect free Spring Wire as per drawing specification (or) Alternate Specification and standard.		
		TECHNOLOGY-2	Spring Making	Spring winding machine (capacity of winding machine wire dia 7mm and coil inner dia 13mm) suitable to the component and trimming facility to the required length.			
		TECHNOLOGY-3	Grinding		Surface grinding machine as per component requirement with 0.050mm accuracy		
		TECHNOLOGY-4	Heat Treatment		Thermal Stabilisation furnace Hardening & Tempering furnace with Oil quenching facility suitable to the Spring		
			Protection coating		Zinc chromatising suitable to the component		
		TEST / INSPECTION-1	Spring Mechanical Testing		Hardness Testing (Rockwell) Load Test to hold spring for 24 Hrs Elastic characteristics test		
			Measuring Instruments	Vernier Caliper suitable to the requirement of the component			

Note : Justification for alternate facilities may be shared to prove that alternate facilities can be utilised to manufacture the item wherever the facilities are mentioned above are not available, but vendor has alternate facilities.