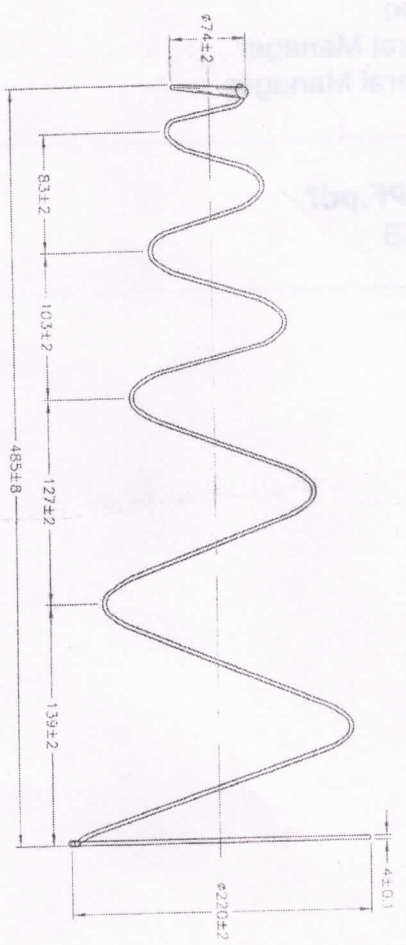
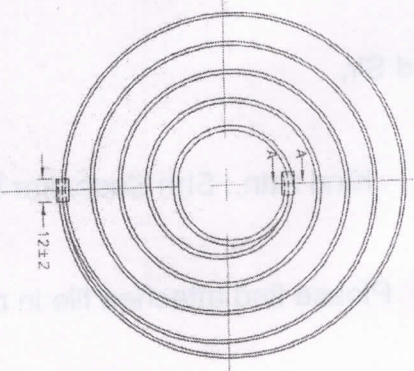


ENDS OF THE FERRULE AT THE TOP AND BOTTOM JOINTS TO BE OVERLAPPED AND BRESSED IN AS SHOWN AND THIN SOLDERED.



SECTION - AA



**MATERIAL:** (1) SPRING: STEEL SPRING MUSIC WIRE  $\phi 4 \pm 0.03$  mm TO SPECN. BS: 5216M-1975

(11) FERRULE: MILD STEEL SHEET 0.966 mm THICK

**WORKMANSHIP:** JOINTS AT TOP AND BOTTOM OF SPRING TO BE FIRMLY SECURED IN POSITION WITH FERRULE AND SOLDERED

**FINISH:** THE SPRING SHOULD BE CADMIUM PLATED TO A MINIMUM THICKNESS OF 0.012 mm AND CHROMATE PASSIVATED AS PER SPECN. 151572-1968 CD 12

**EMBRITTLMENT RELEASE:** SPRINGS AFTER PLATING AND PRIOR TO CHROMATE PASSIVATION, SHALL BE MAINTAINED AT A TEMP. OF 150-200°C FOR NOT LESS THAN HALF AN HOUR TO REMOVE HYDROGEN EMBRITTLMENT.

**COMPRESSION TEST:** THIS SPRING SHALL COMPRESS FULLY UNDER A LOAD OF NOT LESS THAN 20 kgf AND NOT MORE THAN 25 kgf, AFTER BEING MAINTAINED IN FULLY COMPRESSED POSITION UNDER SUCH LOAD FOR A PERIOD OF 30 MINUTES. IT SHALL NOT SHOW PERMANENT SET MORE THAN 2 mm. ON COMPLETE WITHDRAWAL OF LOAD AND THE JOINTS SHALL REMAIN UNDAMAGED. THIS TEST MAY BE CARRIED OUT ON EACH SPRING EITHER BEFORE OR AFTER PLATING.

**TOLERANCES:** 10.4 mm, EXCEPT SHEET THICKNESS WIRE DIA. AND OTHERWISE SPECIFIED.

**PACKING:** TEN NOS. OF COIL SPRINGS SHALL BE GROUPED TOGETHER SO THAT THEIR COILS DO NOT TANGLE IN ANOTHER. THEREAFTER THESE SHOULD BE SECURED WITH JUTE TWINE AT THE TOP AND BOTTOM ENDS. EACH SUCH UNIT SHALL BE PACKED IN THE POLYTHENE BAG. SIX SUCH BAGS SHALL BE PACKED IN CWP (DULY LINED WITH PAPER PACKING WATER PROOF). EACH PACKING CASE SHALL BE LEGIBLY AND INDUBILY MARKED WITH FOLLOWING DETAILS-

(i) NOMENCLATURE, CAT. NO. OF THE STORE AND YEAR OF MANUFACTURING.

(ii) TOTAL NO. OF PACKING CASES AND THE NUMBER OF THE INDIVIDUAL PACKING CASE IN CONSIGNMENT.

(iii) NO. OF BAG IN EACH PACKING CASE.

(iv) MASS OF THE PACKING CASE.

(v) ADDRESS OF THE CONSIGNER.

(vi) ADDRESS OF THE CONSIGNOR.

NOTE: (1) FERRULE (2-OFF) TO BE COVERED WITH TAPE ADHESIVE (CLOTH BASE 3 mm WIDE (JOHNSON OR PARASOL))  
(2) ALL SHARP EDGES TO BE ROUNDED OFF.

SCALE: - N.T.S.	APPROVED	PROJ. DIR./GROUP DIR.
DIMENSIONS IN mm	GROUP - RP	CHD
TOL. - AS SPECIFIED	OK	ADITYA
MATERIAL - AS SPECIFIED	CONICAL SPIRAL SPRING	
FINISH - AS SPECIFIED	ADC-150	
HEAT TREATMENT: - AS SPECIFIED	DRG No	

Rev No.	DATE	ZONE	AUTHORITY	BRIEF RECORD	O/I/C HEAD	CAD GROUP
8						
7						
6						
5						