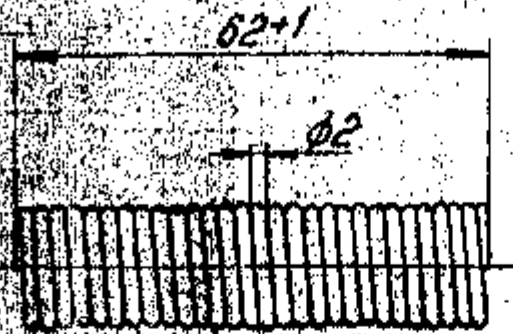


3315-623-1

40С770.00ТКО08 20-2
DIRECTION OF COILING R.H.
Направление намотки Правое

∞ (✓)
③



(A) EQUIVALENT MATERIAL
Gr. DH/DM IS: 4454-2001

1. Группы контроля - по ТУ-14. (2)
2. Пружину намотать без предварительного натяжения. Минимальный зазор между витками не менее 0,03 мм. (2)
3. Длину подогнать в узле.
4. Острые кромки затупить.
5. Пружину проверять по чертежу сд. 3315-602-1.

THE SPRING SHOULD BE COILED WITHOUT
SECONDARY TENSIONING, ENSURING CLEARANCE BETWEEN
THE COILS 0,03 MM MIN.
THE SPRING SHOULD BE ADJUSTED IN UNITS
SHARP EDGES SHOULD BE BLUNTED
THE SPRING SHOULD BE CHECKED AS PER DRAWING
CD 3315-602-1

NUMBER OF COILS	28 ± 1
DIRECTION OF COILING	R.H.

15/6

12/11/20
 12/11/20
 12/11/20

		EST. MASS	0.027 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS *
				LETTERS!
A	16.8.10	4 th Alt. Comm. Meeting Minutes Point No.13	DF: 26-10-09	ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.
ISSUE DATE		NATURE OF AMENDMENTS		
DRN		SCALE - 1 : 1	MATERIAL :- WIRE II A П-2 GOST 9369-75	USED ON :- СБ 3315-602-1
CHD		DIMENSIONS IN mm.	CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI	
TCD		TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	TITLE :- 1 St. SPRING GOVERNOR	
APPD		ALL THREADS CONFORM TO	D S CAT NUMBER	DRAWING NUMBER
DATE	08/08			3315-623-1

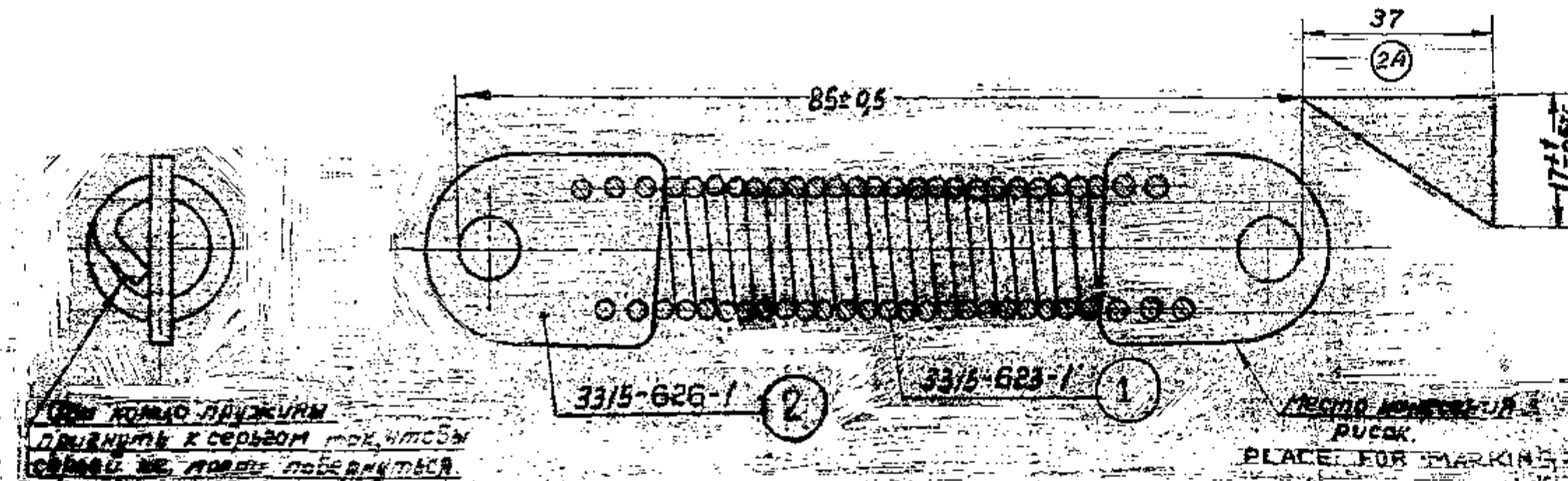
(A6)





DRAWING NUMBER
CB 3315 602 1

(2A) No. OF WORKING COILS - 23 ± 1



BOTH ENDS OF SPRING SHOULD BE SENT TO THE SHACKLES SO THAT THE SHACKLES DO NOT TURN.

1. ACCORDING TO THE LOAD APPLIED THE SPRINGS ARE DIVIDED IN TO 3 GROUPS:
- I GROUP WITH LOAD $17^{+0.5}_{-0.5}$ KGF.
 - II GROUP WITH LOAD $17^{+0.5}$ KGF.
 - III GROUP WITH LOAD $17^{-0.5}$ KGF.
2. AFTER TESTING SPRINGS UNDER LOAD, NO. OF GROUP SHOULD BE MARKED ON ONE OF THE UNIT SHACKLES IN THE FOLLOWING WAY:
- 1ST GROUP - ONE MARK.
 - 2ND GROUP - TWO MARKS.
 - 3RD GROUP - THREE MARKS.
3. IT IS PERMITTED TO ADJUST THE LOAD BY CHANGING THE NUMBER OF WORKING COILS IN UNIT.
4. BOTH SHACKLES SHOULD LIE IN THE SAME PLANE.
5. COATING: ZN 9 TO 15, CHROMATIZING AS PER INSTRUCTIONS U.I-483-82 WITH ELIMINATION OF HYDROGEN EMBRITTLEMENT.
6. BENT ENDS OF SPRING SHOULD BE LOCATED ON ONE SIDE OF SHACKLES.
7. THERE MAY BE NO ZINC ON THE SURFACES OF MARKINGS.

DRG. INDIANISED BASED ON RUSSIAN ORIGINAL ISSUE - 2

PILOT SAMPLE SHOULD BE APPROVED BY A H S P BEFORE BULK PRODUCTION.

EST. MASS 0.037 Kg	TO BE STAMPED OR MARKED WHERE INDICATED THUS # LETTERS)
ALL SHARP EDGES AND CORNERS TO BE REMOVED UNLESS OTHERWISE STATED MACHINED CORNERS TO HAVE R OUTSIDE R INSIDE EQUIVALENT CHAMFERS ARE PERMISSIBLE.	

DRN	CHD	TCD	APPD	DATE	SCALE - 2 : 1	DIMENSIONS IN mm.	TOLERANCE ON DIMNS UNLESS OTHERWISE STATED.	ALL THREADS CONFORM TO
				09-5-86				
MATERIAL:-					USED ON:- CB 315 663 21			
CONTROLLERATE OF INSPECTION (HEAVY VEHICLES) AVADI					TITLE:- 1st SPRING GOVERNOR			
D.S. CAT NUMBER					DRAWING NUMBER CB 3315 602 1			
2A	24-29	D.D. CORRECTION.						
ISSUE	DATE	NATURE OF AMENDMENTS						

(A-6)
SIZE A2



