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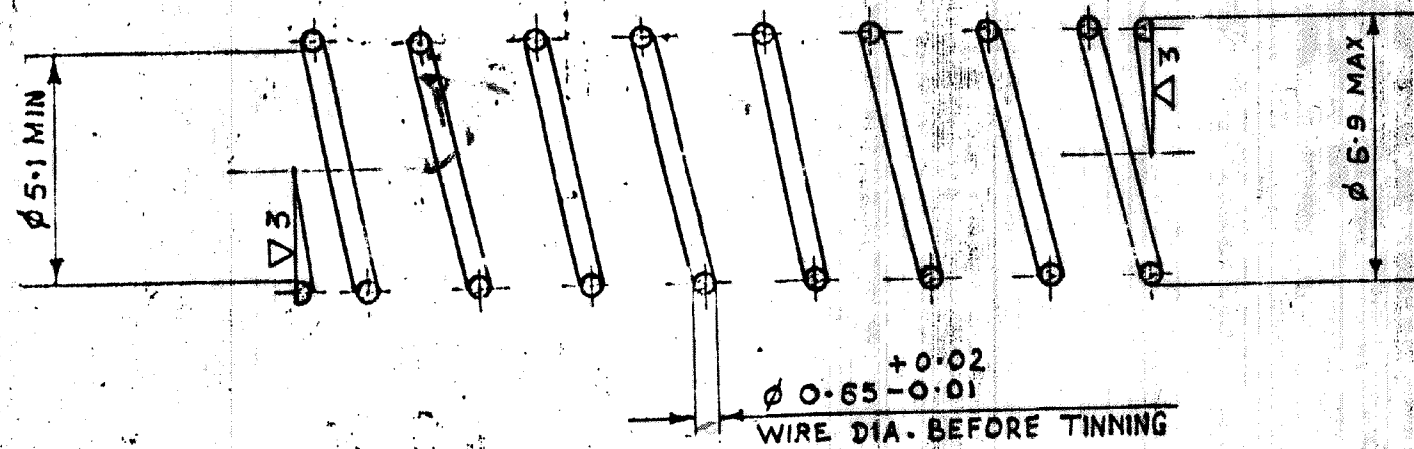
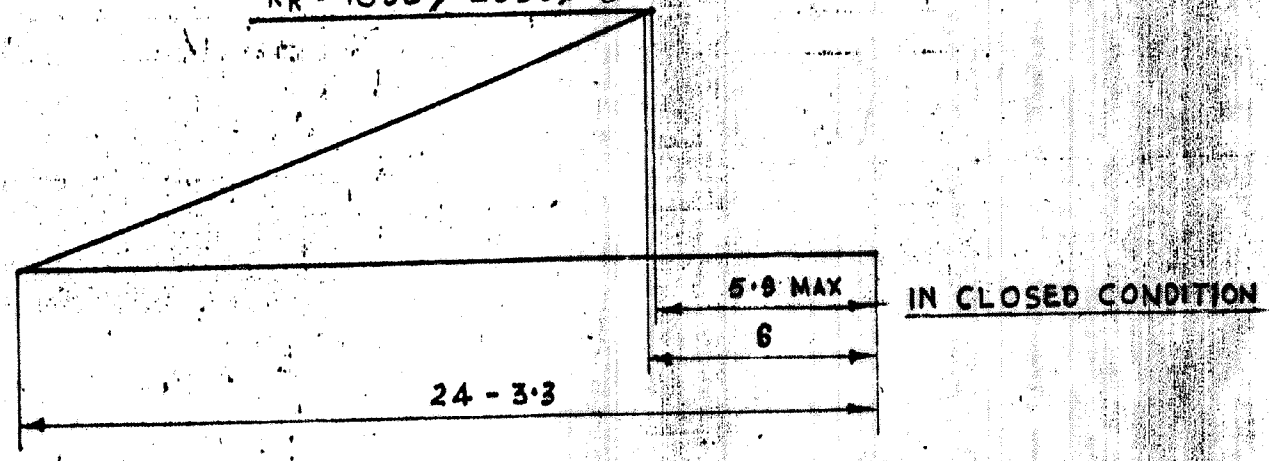


616910-2

PROTECTIVE TREATMENT :-  
IN INDIA THE COMPONENT WILL BE  
TINNED TO SPEC. DTD 924

D.C. 1-28794-A

RK = 1850 <sup>to</sup> 2350 / 8



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

- 1 LENGTH OF SPRING WIRE 68 mm
- 2 WINDING MAY BE L.H OR R.H.
- 3 TOTAL NUMBER OF COIL 8 ± 0.5
- 4 DIA OF CONTROLLING PLUNGER DC = 5.128 - 0.012
- 5 DIA OF CONTROLLING CYLINDER Dr = 6.865 ± 0.01
- 6 ELECTRICAL DEGREASING OR PICKLING IS NOT PERMITTED
- 7 SPRING WHEN KEPT ON A HORIZONTAL PLANE MUST STAND VERTICALLY. DEVIATION FROM VERTICAL MUST NOT BE MORE THAN 5°
- 8 AFTER TINNING OR OXYDISING, THE SPRING MUST NOT BE DAMAGED WHEN STRETCHED TO 1 1/2 TIMES THE HEIGHT. CHECK SELECTIVE.
- 9 MATERIAL PERMITTED :- STEEL WIRE FOR SPRINGS OF TYPE 'HT' AND OBT TY2822 GAy.
- 10 LOW TEMPERATURE TEMPERING IS PERMITTED. TEMPERATURE REGIME TO BE DETERMINED BY THE PLANT
- 11 ALL DIMENSIONS GIVEN 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 AFTER TINNING OR OXIDATION THE SPRING IS KEPT 3 DAYS COMPRESSED TO A HEIGHT OF 5.9 mm. THE HEIGHT IS CHECKED EVERY HOUR AFTER THIS TEST, THE SPRING MUST RETAIN RESISTANCE AND DIMENSIONS WITHIN DRAWING LIMITS
- 15 OXIDATION CROMATING, AND DIPPING IN MACHINE OIL GOST 1805-51
- 16 LACQUERED WITH SHELLAC LAC. LACQUER 3-5% TY GAy 4391-54 \*

MATERIAL :- STEEL WIRE TO SPECN. NO.  
BS 5216: 1975-M, GRADE 4 OR 5

D.S. CAT No 1390-000242

		3-016919		53-B-025Y	
6-7-11	DC 37284-A	MATERIAL AMENDED			
05-3-97	D.C. 34253-A	RK-1850-2350 Amended as RK-1850 to 2350		11/87	
11-2-88	D.C. 34325-A	D.S. CAT NO ADDED.		32	
23-4-83	D.C. 33430-A	MATERIAL AMENDED.		1/87	
25-2-87		TRACED WITHOUT CHANGE		1/87	
		PREVIOUS DCS (11 NOS 28794-A, 29221-A, 29306-A, 29466-A, 2931027-A)		SD/-	
DATE	AUTHORITY	REVISION	AMSP D.O. SIGN.	SPRING WIRE 0.65 TY. 2622 GAy.	

SPRING.

LETTER	MASS	SCALE
	0.4	5

R 516 CD MAN DRAWN CHD. TCD. COMP. D.M.N.