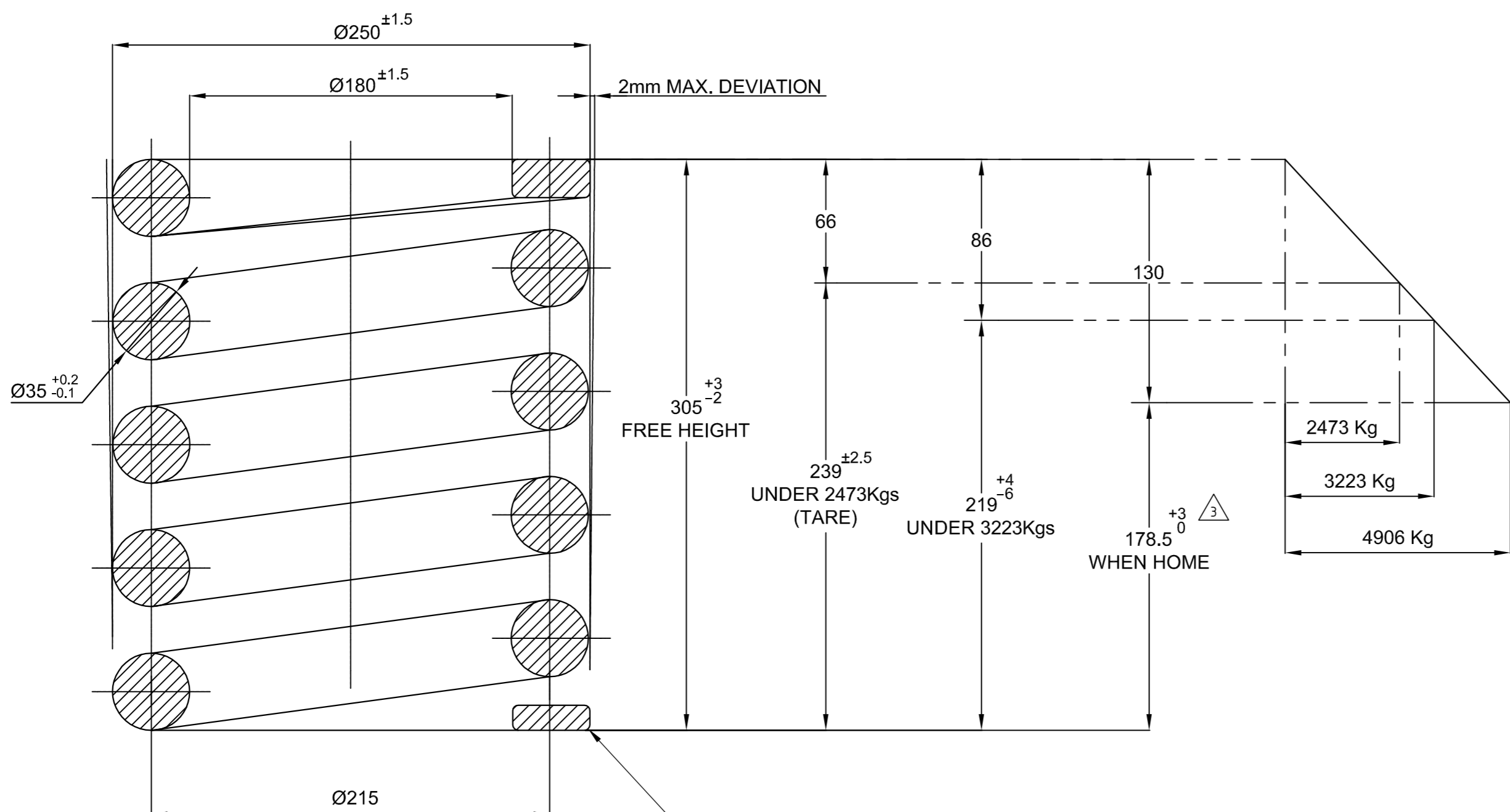
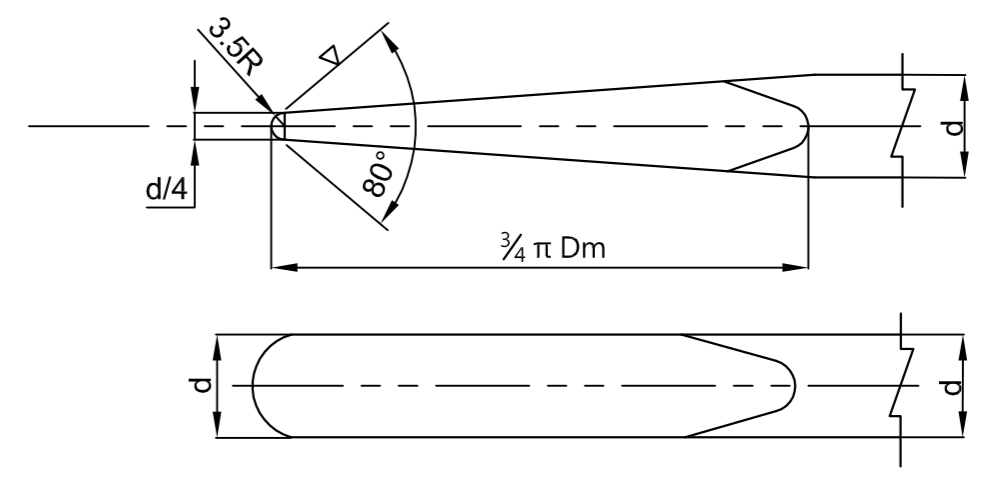


MACHINING DEVIATIONS FOR LINEAR DIMENSIONS	RANGE	TOLERANCE								
		0 - 6	6 - 30	30 - 120	120 - 315	315-1000	1000-2000	2000-4000	ABOVE 4000	
		±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2	±3	
FOR DIMENSIONAL TOLERANCES OF SHEET METAL PARTS AND WELDED STRUCTURES, REFER STD. RD-227										
UNSPECIFIED TOLERANCE FOR LINEAR AND ANGULAR DIMENSIONS REF. IS 2102 (PT-1) (MEDIUM)										
VALUES OF SURFACE TEXTURE SHALL BE AS PER COMPANY STD DS.1012.C. QUALITY OF WELD JOINTS REF. ISO: 5817										
PAINTING SHALL BE DONE AS PER RD - 38										
WELDING SHALL BE CARRIED OUT AS PER IS: 9595-96										
*PROTO/PILOT/PRODUCTION										



WIRE DIAMETER = d	35mm
MEAN COIL DIAMETER = Dm	215mm
NUMBER OF ACTIVE COILS	4
TOTAL NUMBER OF COILS	5.5
FREE HEIGHT	305mm
SOLID HEIGHT	178.5mm
DEFLECTION UNDER 1000 Kg LOAD	26.5mm
STRESS UNDER 1000 Kg LOAD	1572 Kg/cm ²
STRESS AT SOLID HEIGHT	7712 Kg/cm ²



HOT STAMP ON OUTER VISIBLE FACE OF DEAD COIL
IN 5 mm HIGH LETTERS AS FOLLOWS (WITH BLUNT EDGED STAMP)

CM 02/09 BEML 901-81027

 INITIALS OF MANUFACTURER

02/09 MONTH AND YEAR OF MANUFACTURE

TABLE-1

SL. No.	HEIGHT AT TARE	No. OF BAND	COLOUR
1	306.3 - 308	3 BAND	BLUE
2	304.7 - 306.3	2 BAND	GREEN
3	303 - 304.7	1 BAND	YELLOW

NOTE

- SPECIFICATION OF SPRING STEEL MATERIAL 52Cr4Mo2V TO IS:3195-92
HARDNESS: AFTER HARDENING AND TEMPERING 415 TO 460BHN.
- THE SPRING SHALL BE MANUFACTURED / INSPECTED AS PER RDSO SPECIFICATION No. WD-01-HLS-94 WITH LATEST REVISION.

UN CONTROLLED

GRADE No.	VALUE	SYMBOL
N1	0.025	▽
N2	0.05	▽
N3	0.1	▽
N4	0.2	▽
N5	0.4	▽
N6	0.8	▽
N7	1.6	▽
N8	3.2	▽
N9	6.3	▽
N10	12.5	▽
N11	25	▽
N12	50	▽
SURFACE ROUGHNESS		

SL.No.	QTY	DRG / STOCK No.	DESCRIPTION	SIZE	COMPANY STD/IS STD	WT.Kg
		HELICAL SPRING			Ø37.5 min L=3730mm	REF NOTE
DETAIL PARTS						
PRODUCT: 8W CMV / OHE						
SURFACE TREATMENT: -						
5	1	921-81005	921	SCALE 1:2	Wf.(Kgl)	-
5	1	922-81005	922			
		QTY	NEXT ASSY	MODEL	REF DRG	
TITLE: HELICAL SPRING (AXLE)				APPROVED	AVR	07.03.87
				CHECKED	AVR	07.03.87
				DRAWN	G SUDARSHAN	07.03.87
				DRG No.		ALT
BEML LIMITED R&D, BANGALORE COMPLEX BANGALORE 560 075				901-81027		5
ALT	CHANGES	DATE	BY	CKD	APP	

