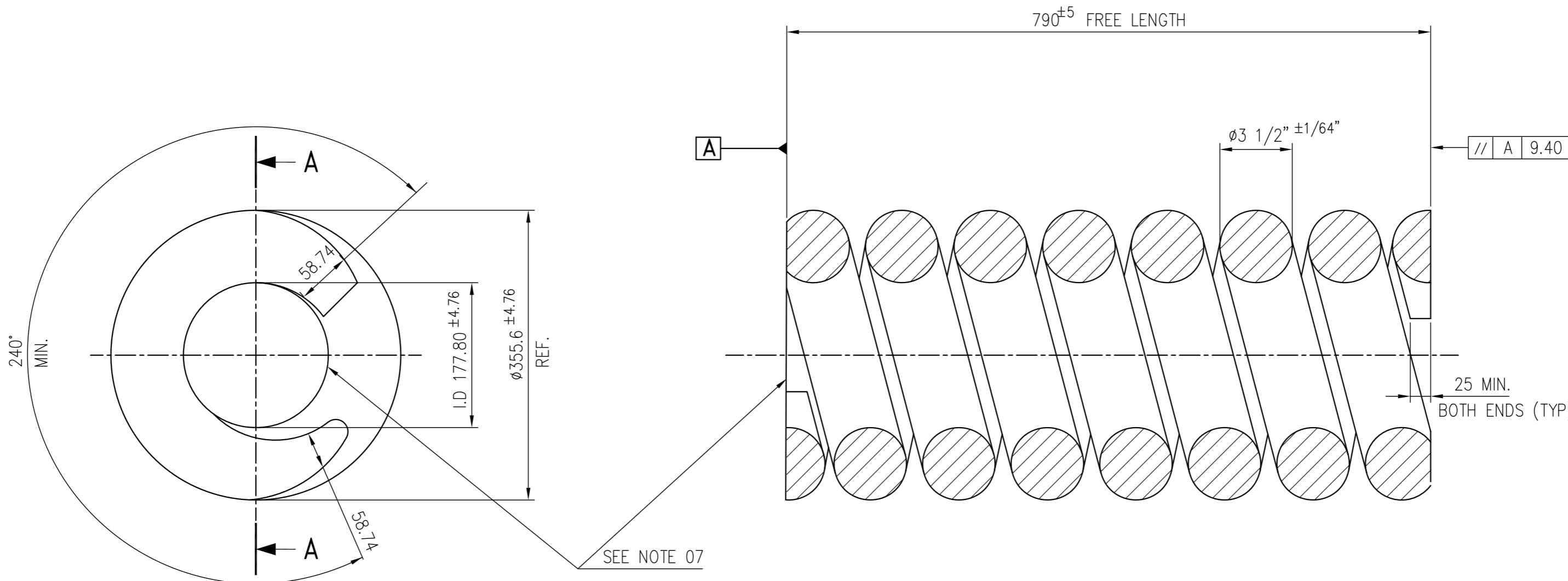


DRG. NO. 2-61-300-00776



SEE NOTE 07

SECTION-AA

NOTES:-

1. SPRING TO HAVE SQUARED AND GROUND ENDS
2. HEAT TREATMENT & TOLERANCES IN ACCORDANCE WITH ASTM. A-125 UNLESS OTHERWISE SPECIFIED.
3. MAGNETIC PARTICLE INSEPECTION PER ASTM E-709 IS REQUIRED SURFACE DISCONTINUOUS GREATER THAN 1/16" LONG ARE CAUSE FOR REJECTION FLAWS MAY BE WET GROUND OUT TO A DEPTH OF 1/16" MAX.
4. SHOT PEENING REQUIRED INTENSITY-5 TO 7C; MEASURED WITH ALMEN STRIP SHOT SIZE 550 HARD 100% VISUAL INSPECTION.
5. STRESS RELIEVE AFTER GRINDING
6. COAT SPRING WITH EITHER TWO COATS OF BLACK WATER-BASED PRIMER EQUIVALENT TO WILLIAMS-HAYWARD # 62-12075 OR 1 COAT OF SIEBERT POWDER COATING PUB-2644 BLACK POLYSTER URETHANE OR EQUIVALENT.
7. REMOVE ALL SHARP EDGES FROM GROUND ENDS W / 1/8" RAD.
8. CUSTOMER APPROVED QUALITY PLAN TO BE FOLLOWED.
9. REFER PROD.STD.BA75019 FOR TDC
10. INSPECT SPRING RATE PER ASTM A-125, SECTION S6. TOLERANCE ±10% UNLESS OTHERWISE SPECIFIED.
11. BOTH ENDS OF THE BAR STOCK ARE TO BE HOT TEMPERED BEFORE COILING. BLUNT END CONSTRUCTION IS NOT PERMITTED.

SPRING COILING SPECIFICATIONS:-

FREE LEANGTH = 790.6±6.4  
 SOLID LENGTH = 663.6  
 SPRING RATE = 535.745 kgs/mm ±10%.  
 ACTIVE COILS = 6.16 REF.  
 TOTAL COILS = 7.46 REF.  
 WEIGHT = 303.91  
 BAR STOCK CENTRELESS GROUND.

MATL:-

LOW ALLOY ASTM A-322 GR. 4161 H.F QUENCHED AND TEMPERED TO 429 TO 477 BHN.

ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	UNIT WT.
					BA9717552037	303.91
					BA75019	
					MATERIAL SPECN.	QUANTITY

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED...

1. REF.TO HY0230261 FOR UNSPECIFIED TOLERANCES.
2. CHAMFER M/CD SHARP EDGE 1.2 TO 1.0 AT 45°.
3. INTERNAL M/CD CORNER RADII 1 TO 0.7.
4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE BACK SLASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT  
**1003 XRP BOWL MILL**

DRN.	NAME	SIGN.	DATE	NO.OF VAR.
N.D.S			5.10.98	
S.G			5.10.98	
K.M.RAO			5.1098	

DEPT. PULV. ENGG.	GRADE OF TOL. DIM. 0.1/0.1	SCALE N.T.S	WEIGHT(Kg) 303.91	REF. TO ASSY DRG. C-101-01297 REV. 2	ITEM No. -	NO.OF ITEMS -
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TITLE **JOURNAL PRESSURE SPRINGS**

DRAWING No.. **2-61-300-00776** REV. **05**

SHEET No. No. OF SHEETS

INVENTORY NO. 26100776.DWG COMP. FILE NAME 26100776.DWG THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY.

REV.	DATE	ALTERED	APPD.	REV.	DATE	ALTERED	APPD.	REV.	DATE	ALTERED	APPD.	REV.	DATE	ALTERED	APPD.
04	14.03.11	CHECKED	APPD.	03	14.03.11	CHECKED	APPD.	02	04.06.03	CHECKED	APPD.	01	08.10.98	CHECKED	APPD.
ZONE	SOLID LENGTH WRONGLY MENTIONED AS ±7. SPRING RATE CORRECTED TO ±10.			ZONE	NOTE 10,11 ADDED			ZONE	NOTE 9 ADDED			ZONE	DRAWING REDRAWN ON CAD NOTE 8 ADDED		