



Specification No : APSQ – 043

Rev. No : 07

Page No : 01 of 01

01.	Item	<b>HELICAL COMPRESSION SPRING</b>			
02.	Material code(s)	96 356 079 0000	96 356 081 0000	96 356 078 0000	
03.	Application	Hot end Trunion seal	Cold end Trunion seal	ALCS	
04.	Maximum working temp.	50°C	50°C	50°C	
05.	Coil mean diameter	28.5 ± 0.5 mm	20.25 ± 0.5 mm	18.5 ± 0.2 mm	
06.	Diameter of Wire	2.5 mm	3.75 mm	2.00 mm	
07.	Free length	280 ± 10 mm	63.5 ± 2 mm	70 ± 2 mm	
08.	No. of working coils	21	8	12	
09.	Total No. of coils	23	10	14	
10.	Spring rate	0.8 ± 0.1 Kg / Cm	30 ± 2 Kg / Cm	5 ± 1 Kg / Cm	
11.	Type of ends	Closed and ground	Closed and ground	Closed and ground	
12.	Material	IS 4454 Part 1 Gr DH	IS 4454 Part 2 Gr VDSiCr	IS 4454 Part 1 Gr DH	
13.	Finish	Oiled	Oiled	Oiled	
14.	Tolerance	As per <b>IS 7906 Part 2</b> for all springs			
15.	GENERAL a) Only latest revision shall be referred for all the Standards specified. b) The spring shall be packed properly to avoid damage during transit.				
16.	INSPECTION a) Inspection by BHEL. b) Necessary Test & Material Certificates shall be submitted.				
07	15.06.21	(Sd) VMR	(Sd) SCH	(Sd) SCH	Material code 963560780000 added.
06	10.01.18	(Sd) SCH	(Sd) SCH	(Sd) RSB	Material specification was IS 4454 Part 1 Gr 2 & IS 4454 Part 3 Gr 2D.
05	06.02.17	(Sd) VMR	(Sd) SCH	(Sd) RSB	Reviewed & re-affirmed.
04	16.12.10	(Sd) SCH	(Sd) KP	(Sd) PPS	Clause 15b added.
03	20.04.02	(Sd) RR	(Sd) PPS	(Sd) GRV	MC 96 356 082 deleted; page modified
02	27.12.93	(Sd) VAS	(Sd) PPS	(Sd) GRV	Clause 8 & 13 added; clause 12 modified; in clause 10, spring rates were 1 & 35 for matl codes 96356079 & 96356081 respectively.
01	22.11.93	(Sd) VAS	(Sd) PPS	(Sd) GRV	Inspection Clause 13 was 12.
00	30.06.93	(Sd) GA	(Sd) PPS	(Sd) RSM	<b>FRESH ISSUE</b>
<b>Rev.No</b>	<b>Date</b>	<b>Prepared</b>	<b>Checked</b>	<b>Approved</b>	<b>Record of Revisions.</b>